

VERSION 4.0  
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# Xerox® Iridesse® Production Press

User Documentation

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# Learning About

This chapter contains:

- Safety ..... 8
- Production Press Overview ..... 17
- System Specifications ..... 31
- Regulatory Information ..... 43
- Recycling and Disposal ..... 50

This section contains topics about the system configuration, safety features and regulations, specifications, billing, and optional feeding and finishing components.

## Safety

Your press and the recommended supplies have been designed and tested to meet strict safety requirements. Attention to the following information ensures the continued safe operation of your Xerox® press.

### NOTICES AND SAFETY



Note: This equipment is not suitable for use in locations where children are likely to be present.

Your Xerox® press and supplies are designed and tested to meet strict safety requirements. Safety requirements include safety agency evaluation and certification, and compliance with electromagnetic regulations and established environmental standards.

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

Unauthorized alterations, which can include the addition of new functions or connection of external devices, can affect the product certification. For more information, contact your Xerox representative.

### ELECTRICAL SAFETY

#### General Guidelines



**Warning:** Read the following warnings.

- Do not push objects into slots or openings on the press. Touching a voltage point or shorting out a part could result in fire or electric shock.
- Do not remove the covers or guards that are fastened with screws unless you are installing optional equipment and are instructed to do so. Switch off the press when performing these installations. Disconnect the power cord when removing covers and guards for installing optional equipment. Except for user-installable options, there are no parts that you can maintain or service behind these covers.

#### Emergency Power Off

The following are hazards to your safety:

- The power cord is damaged or frayed.
- Liquid is spilled into the press.
- The press is exposed to water.
- The press emits smoke, or the surface is unusually hot.
- The press emits unusual noises or odors.
- The press causes a circuit breaker, fuse, or other safety device to activate.

If any of these conditions occur, do the following:



1. Turn off the press immediately.
2. Disconnect the power cord from the electrical outlet.
3. Call an authorized service representative.

### Power Cord and Electrical Supply



**Warning:** To avoid risk of fire or electrical shock, do not use extension cords, power strips, or power plugs. Always adhere to national and local building, fire, and electrical codes regarding length of cord, conductor size, grounding, and protection.

- Use the power cords that are supplied with your press.
- Do not remove or modify the power cord.
- The electrical outlet must be near the press and must be easily accessible.
- Plug the power cord directly into a correctly grounded electrical outlet. Ensure that each end of the cord is connected securely. If you do not know whether an outlet is grounded, ask an electrician to check the outlet.
- Do not use a ground adapter plug to connect this equipment to an electrical outlet that lacks a ground connection terminal.
- The electrical supply for the press must meet the requirements stated on the data plate located on the rear of the press. If necessary, consult your local electricity provider or a licensed electrician.
- Do not place the press in an area where people can step on the power cord.
- Do not place objects on the power cord.
- Do not plug or unplug the power cord while the power switch is in the On position.
- If the power cord becomes frayed or worn, replace it.
- To avoid electrical shock and damage to the cord, grasp the plug when unplugging the power cord.

### Disconnect Device

The power cord is the disconnect device for this equipment. To remove all electrical power from the press, disconnect the power cord from the electrical outlet.

## LASER SAFETY

### North America Laser Safety

This product complies with safety standards and is certified as a Class 1 Laser product under the Center for Devices and Radiological Health (CDRH) of the United States Food and Drug Administration (FDA) implemented regulations for laser products. This product complies with FDA performance standards for Laser products except for deviations pursuant to Laser Notice No. 50 dated June 24, 2007. These regulations apply to laser products marketed in the United States. The label on the Production Press indicates compliance with CDRH regulations and must be attached to laser products marketed in the United States. This product does not emit hazardous laser radiation.



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

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

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

### European Union (EU) Laser Safety

This product complies with IEC's safety standard EN 60825-1: 2014.

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



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

If you need additional safety information about the product or Xerox supplied materials, you can email a request to [EHS-Europe@xerox.com](mailto:EHS-Europe@xerox.com)

### OPERATIONAL SAFETY

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

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

- Do not remove any trays when the press is printing.
- Do not open the doors when the press is printing.
- Keep hands, hair, neckties, and so on, away from the exit and feed rollers.
- Covers, which require tools for removal, protect the hazard areas within the Press. Do not remove the protective covers.
- Do not attempt to remove paper that is jammed deeply inside the press. Switch off the press promptly and contact your local Xerox representative.
- To avoid a tip hazard, do not push or move the device with all of the paper trays extended.
- Do not place the press in locations susceptible to vibrations.
- For optimum performance, use the press at the altitude specified in the *Environmental Specifications* section of the digital user documentation.
- Use the materials and supplies specifically designed for your press. The use of unsuitable materials may result in poor performance of the press and possibly a hazardous situation.
- Follow all warnings and instructions that are marked on or supplied with the press.
- Place the press in a room that provides adequate space for ventilation and servicing.

- Place the press on a level, solid surface, not on a thick pile carpet, that has adequate strength to support the weight of the press.
- Do not attempt to move the press. A leveling device that was lowered when your press was installed can damage the carpet or floor.
- Do not set up the press near a heat source.
- Do not set up the press in direct sunlight.
- Do not store or operate the press in an extremely hot, cold, or humid environment.
- Do not set up the press in line with the cold air flow from an air conditioning system.
- Do not place containers of coffee or other liquid on the press.
- Do not block or cover the slots and openings on the press.
- Do not attempt to override any electrical or mechanical interlock devices.



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

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

### Ozone Information

This product produces ozone during normal operation. The ozone is heavier than air, and the quantity is dependent on print volume. Install the system in a well-ventilated room.

For more information, refer to *Facts about ozone* and *Facts about ventilation* at [www.xerox.com/EHS](http://www.xerox.com/EHS) or [www.xerox.com/EHS-eu](http://www.xerox.com/EHS-eu).

### MAINTENANCE INFORMATION

Do not carry out any maintenance on this product that is not described in the customer documentation.



**Warning:** Do not use aerosol cleaners. Aerosol cleaners can be explosive or flammable when used on electromechanical equipment.

Use supplies and cleaning materials only as directed.

Do not remove the covers or guards that are fastened with screws. Customer service items are not located behind these covers.



Note: Your Xerox Production Press is equipped with a power saving device to conserve power when the Production Press is not in use. The Production Press can be left on continuously.



**WARNING—HOT SURFACE:** The metallic surfaces in the fuser area are hot. Use caution when you remove paper jams from this area and avoid touching any metallic surfaces.

### Vacuum Cleaner Use for Dry Ink/Toner Spills

Use a broom or a wet cloth to wipe off spilled dry ink/toner. Sweep slowly to minimize generation of dust during clean up. Avoid using a vacuum. If a vacuum must be used, the unit should be designed for combustible dusts (for example, explosion rated motor and non-conductive hose).

### CONSUMABLE INFORMATION



**Caution:** Use of non-Xerox supplies is not recommended. The Xerox Warranty, Service Agreement, and Total Satisfaction Guarantee do not cover damage, malfunction, or degradation of performance caused by use of non-Xerox supplies, or the use of Xerox supplies not specified for this Production Press. The Total Satisfaction Guarantee is available in the United States and Canada. Coverage can vary outside these areas. For more details, contact your Xerox representative.



**Warning:** When handling cartridges, such as ink or fuser, avoid skin or eye contact. Eye contact can cause irritation and inflammation. Do not attempt to disassemble the cartridge. This can increase the risk of skin or eye contact.

Store all consumables in accordance with the instructions given on the package or container.

Keep all consumables away from the reach of children.

Never throw dry ink/toner, print cartridges, or dry ink/toner containers into an open flame.

For information on Xerox® supplies recycling programs, go to:

- For the United States or Canada: [www.xerox.com/recycling](http://www.xerox.com/recycling)
- For Europe and other markets: [www.xerox.com/recycling-eu](http://www.xerox.com/recycling-eu)

### BATTERY SAFETY

One or more circuit boards in this printer contain a lithium battery.

Do not attempt to repair or replace the lithium battery. If there is a problem with the battery, contact an authorized service representative to correct the problem.











The lithium battery in this printer contains Perchlorate Material. For information about the special handling procedures associated with Perchlorate Material, refer to [www.dtsc.ca.gov/hazardouswaste/perchlorate](http://www.dtsc.ca.gov/hazardouswaste/perchlorate).











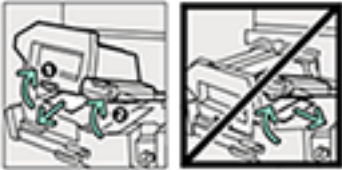





**Warning:** If the battery on a circuit board is installed incorrectly, there is a risk of explosion.

### PRODUCT SYMBOLS

Refer to the following table for the product symbols and their definitions.

| SYMBOL  | DEFINITION   |
|---|--|
|    | <p>Caution</p> <p>This symbol indicates a mandatory action to take in order to avoid damage to these areas.</p>  |
|    | <p>Warning</p> <p>This symbol alerts users to areas where there is the possibility of personal injury.</p>   |
|    | <p>Hot Warning</p> <p>This symbol alerts users to areas where there are heated surfaces which should not be touched.</p>   |
|    | <p>Laser Warning</p> <p>This symbol indicates a laser is being used and alerts the user to refer to the appropriate safety information.</p>  |
|    | <p>Lock</p> <p>This symbol is often used with a jam clearance graphic to indicate that a baffle or handle is closed; refer to the following example:</p>  <p>Always ensure that the jam clearance areas are returned to their original positions and / or closed (locked).</p>                             |
|  | <p>Unlock</p> <p>When this symbol is used with a jam clearance graphic, it indicates that a jam clearance baffle or handle is open or unlocked; refer to the following example:</p>  <p>Always ensure that the jam clearance areas are returned to their original positions and / or closed (locked).</p> |
|  | <p>Do not leave open, unlatched, or unlocked</p> <p>This applies to jam clearance areas, such as baffles, latches, and handles. It also applies to doors and trays / drawers. It often accompanies an Unlocked symbol.</p>   |
|  | <p>Do Not Touch</p> <p>This symbol is often accompanied with a hot warning symbol and an area, such as the fuser, where it is hot; refer to the following example:</p>   |

| SYMBOL  | DEFINITION  |
|---|---|
|    | <p>Do not touch these areas as personal injury may occur.</p>                                       |
|    | <p>Do Not Use Transparencies / Overhead Projector Sheets</p>  |
|    | <p>Do Not Use Envelopes</p>   |
|    | <p>Do Not Use Open Envelopes</p>  |
|   | <p>Do Not Use Folded, Creased, Curled, or Wrinkled Paper</p>  |
|  | <p>Do Not Use Ink Jet Paper</p>   |
|  | <p>Do Not Use Postcards</p>   |
|  | <p>Do Not Store Anything in This Area</p>   |
|  | <p>Do Not Open a Jam Clearance Area<br/>This graphic is accompanied with the following graphic:</p> |

| SYMBOL  | DEFINITION   |
|---|--|
|   |  <ul style="list-style-type: none"> <li>• The first graphic indicates the order in which the jam clearance areas should be opened for removing a jam: Area 1 and then Area 2.</li> <li>• The second graphic instructs the user that Area 2 should not be opened before Area 1.</li> </ul>   |
|    | <p>Do Not Incinerate the Dry Ink/Toner Cartridge</p> <ul style="list-style-type: none"> <li>• Do not dispose a Dry Ink/Toner Cartridge into an open flame/ incinerate.</li> <li>• Always refer to the recycling instructions for your region/marketplace for correct disposal information and procedures.</li> </ul>   |
|    | <p>Do Not Incinerate the Dry Ink/Toner Waste Bottle</p> <ul style="list-style-type: none"> <li>• Do not dispose a Dry Ink/Toner Waste Bottle into an open flame/incinerate.</li> <li>• Always refer to the recycling instructions for your region/marketplace for correct disposal information and procedures.</li> </ul>  |
|  | <p>Do Not Remove Quickly</p> <p>This graphic is accompanied with the following graphic to indicate that the Dry Ink/Toner Waste Bottle should be slowly removed.</p>  <p>Slowly removing the Dry Ink/Toner Waste Bottle avoids the possibility of dry ink/toner dispersing throughout the air.</p>  |
|  | <p>Do Not Dispose Using Normal Household Waste Procedures</p> <ul style="list-style-type: none"> <li>• Application of this symbol is confirmation that you should not dispose of items, such as Customer Replaceable Units (CRUs), using the normal household waste procedures. You must dispose of these items in compliance with agreed national procedures.</li> <li>• This symbol often accompanies batteries and indicates that used electrical and electronic products and batteries should not be mixed with general household waste.</li> <li>• For more information about collection and recycling, please contact your local municipality, your waste disposal service, or the point of sale where you purchased the items.</li> </ul> |

### ENVIRONMENTAL, HEALTH, AND SAFETY CONTACT INFORMATION

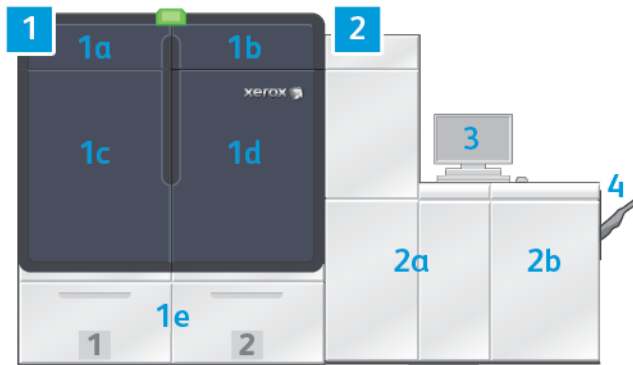
For more information on Environment, Health, and Safety in relation to this Xerox® product and supplies, contact the following:

- Web address: [www.xerox.com/environment](http://www.xerox.com/environment) or [www.xerox.com/environment\\_europe](http://www.xerox.com/environment_europe)
- United States and Canada: 1-800-ASK-XEROX (1-800-275-9376)
- For other markets, send an email request to [EHS-Europe@xerox.com](mailto:EHS-Europe@xerox.com)




## Production Press Overview

The Xerox® Iridesse® Production Press is a full color, high-speed, network printing system that produces 120 pages per minute. The following illustration shows a basic configuration of the Xerox® Iridesse® Production Press:



### 1. Print Engine - Left Side

- a. Upper Left Door: Contains dry ink or toner cartridges, and a storage compartment for maintenance tools
- b. Upper Right Door: Contains dry ink or toner cartridges
- c. Left Front Door
- d. Right Front Door
- e. Trays 1 and 2

 Note: More feeding accessories are available.

### 2. Print Engine - Right Side

- a. Left Front Door
- b. Right Front Door

### 3. Control Center

For more information, refer to [Production Press Control Center](#).

### 4. Optional Offset Catch Tray

 Note: More optional finishing accessories are available.

Other features include:

- Specialty inks and custom colors: The use of gold and silver custom colors, enabling single-pass, mixed-metallic gradation with gold or silver tones. Also, to add shine to your images with clear toner overlays, you can use Clear Dry Ink. For added effect, you can use White or Fluorescent Pink Dry Inks.
- A cut-sheet, high-resolution, 2400 x 2400-dpi Production Press
- A full-width, in-line scanner that automatically adjusts the print engine settings and facilitates print-server calibration and profiling
- Long-lasting, dual-wire, auto-cleaning corotrons that provide uniform quality
- Seamless integration with various optional feeding and finishing devices

## PRINT SERVER

The Production Press is configured with a digital print server, the Xerox® EX-P 6 Print Server, Powered by Fiery®. The print server is used for job submission and job management. The print server also enables you to coordinate optimal job color processing with the color capabilities of the Production Press. For detailed information on using the print server, refer to the user documentation delivered with it. Additional user documentation supplied by Fiery is available at [www.xerox.com](http://www.xerox.com) under the **Customer Support > Support and Drivers** link for your Press.



Fiery® Print Server version 4.0 includes Fiery System version FS600 and have unique features that are not available on older Fiery® Print Servers. To find your print server version or Fiery System version, on the Command WorkStation window, go to **Server > Device Center > GENERAL > General Info**, then refer to **Fiery Server** or **Fiery System**. This information is accessible also on the Fiery configuration page, printed through Fiery® Print Server.

### Xerox Easy Vitals

Fiery® Print Servers version 4.0, FS600, introduces a new feature called **Easy Vitals**. It is a dashboard available in the printer server, showing graphical and numeric indicators of key elements of the digital press. The dashboard also shows warning messages associated with the press. The key elements in the Easy Vitals dashboard include:

- Temperature and Humidity
- Toner levels
- Waste toner bottle status
- High Frequency Service Items (HFSI) status

You can access Easy Vitals dashboard from Fiery Command WorkStation. From the print server menu, click **Easy Vitals**. Data on the Easy Vitals dashboard is updated shortly after the print engine has cycled down. Temperature and Humidity data are from sensors inside the print engine and can vary from the operating environment of the press.

For more information, refer to [Fiery - Xerox Iridesse Production Press](#).

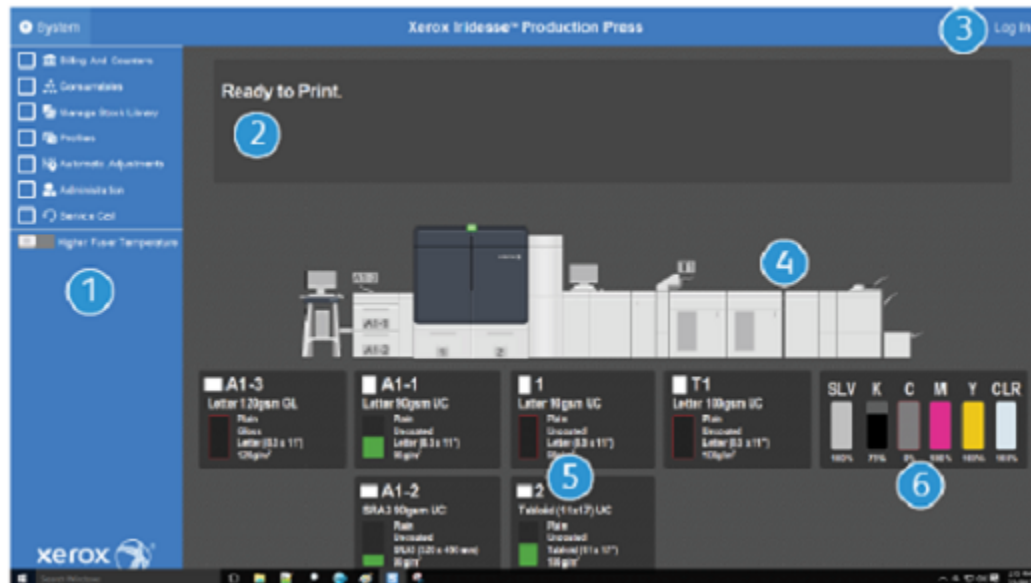
### Xerox® FreeFlow® Vision Connect

Xerox® FreeFlow® Vision Connect is a Web-based software solution that offers real-time, at-a-glance visibility and control of production operations. The dashboard screen monitors, tracks, and benchmarks performance across printers and sites. To access FreeFlow® Vision Connect web application, install the Vision Connect Printer Agent on your Fiery Print Server. For more information, refer to *Xerox® FreeFlow® Vision Connect Web Application User Guide* available at [Workplace and Digital Printing Solutions | Xerox](#).

## PRODUCTION PRESS CONTROL CENTER

The Production Press Control Center is the interface for press interactions. This computer, monitor, and keyboard allows you to operate, administer, and maintain the Production Press.

The main window of the Production Press Control Center displays the Production Press information that you refer to most often. The main window enables you to complete many tasks and view paper and dry ink or toner supply status without having to change windows.



1. **Function Menu:** The menu provides quick access to more Press functions, including PredictPrint Stock Wizard.
2. **Message Area:** Job status information and faults appear to alert you to areas of the Production Press that require attention.
3. **Log In link:** This link enables System Administrators and Technical Key Operators to log in to the Production Press and access more functions. A walk-up Operator does not need to log in.
4. **Production Press Mimic:** This graphic represents the Production Press configuration and displays caution and error icons. Click the areas in the graphic to read dialogs related to that component.
5. **Paper Tray Status:** Click the appropriate paper tray graphic to view the type, size, and amount of stock in the tray.



Note: Fiery® Print Server version 4.0 include Fiery System version FS600 and have unique features that are not available on older Fiery® Print Servers. On Fiery® Print Server version 4.0, FS600 or newer version, if the stock loaded in the tray is registered with PredictPrint Stock Wizard, then you can right-click on the tray to **Run Image Quality System Check**. To enable this feature, refer to [Automatic Image Quality System Check](#).

6. **Dry Ink Level Indicators:** Indicators representing each dry ink consumable show the approximate ink levels of CMYK and specialty inks.

### Function Menu

The main menu on the Control Center window allows you to access the following functions. To open the Function window for the listed item, click the check box preceding the function:

- **Billing and Counters:** View the billing meters on your Production Press and usage counters that show the number of print impressions produced for different types of jobs.
- **Consumables:** View the status of dry ink or toner and other supplies and learn when to add or change the consumables.
- **PredictPrint Stock Library or Manage Stock Library:** Create, manage, and assign the stocks used in a job.
- **Profiles:** Create custom profiles for Fold Adjustments, Image Alignment, Air Assist settings, and, if installed, Document Finishing Architecture (DFA) devices.
- **Automatic Adjustments:** Perform image quality adjustments, such as Auto Density Uniformity and Auto Alignment.

You are required to log on as the system administrator to perform the following functions:

- **Administration:** Change system settings, such as power saver timers, printing priority, Stock Library access for operators, password control, and tray-switching priority.
- **Service Call:** Send Production Press data to Xerox Support.
- **Maintenance:** Perform Charge Corotron and Dry Ink cleaning procedures.

## System Menu

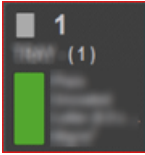

The System menu allows you to administer the Control Center and its display.

- **Machine Details:** This option provides information about the installed system software, any attached optional feeding or finishing accessories, error log details, the customer support telephone number, and the machine serial number.
- **Language:** This option allows you to change or set the default language shown on the Control Center.
- **Power Saver – Print Engine Only:** This option places the print engine in power saver mode so that it consumes less energy. Use a timer to set the amount of time to lapse before the print engine enters a reduced power saver mode.
- **Power Saver – Print Engine & System PC:** This option allows you to set the time lapse for both the print engine and Control Center to enter a reduced power saver mode.
- **Restart Control Center:** This option stops and exits the Control Center and Windows operating system, then immediately restarts it.
- **Exit Control Center:** This option exits the Control Center but leaves the Control Center running. If a software update notification appears, before performing the update, power off the Production Press. While updating, select this option to power off the Production Press Control Center.
- **Restore Down Control Center:** This option closes down the Production Press Control Center to a half-screen size so that half of the desktop behind it is visible.
- **Minimize:** This option minimizes the Control Center screen and places an icon for it in the system tray along the bottom of the screen.
- **Full screen:** This option restores the Production Press Control Center screen to maximum size after it was minimized.
- **Shutdown System PC:** This option shuts down both the Windows operating system and the Control Center.

## Alerts and Icons

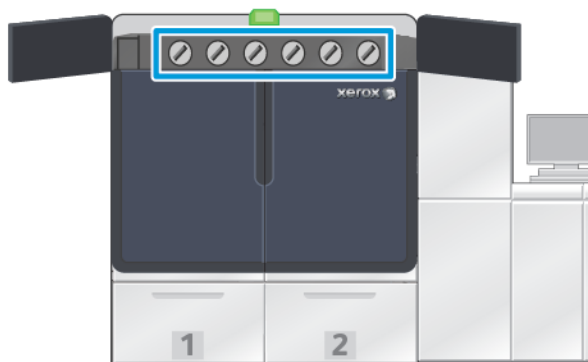
Alerts and Icons contains information about the methods the Production Press uses to alert you to situations that require attention. This menu option also contains icons used within the software.

| IMAGE   | DESCRIPTION   |
|---|---|
|    | <ul style="list-style-type: none"> <li>• <b>Attention Light:</b> The Attention light indicates the Production Press status. The light is much easier to see in a busy production setting than the messages in a computer window.</li> <li>• <b>Green – steady:</b> A steady green light indicates that the Production Press is ready to print jobs.</li> <li>• <b>Green – flashing:</b> The green flashing light indicates that an incoming print job is in process.</li> <li>• <b>Orange – flashing:</b> The orange flashing light indicates a minor problem, such as an open door.</li> <li>• <b>Red:</b> A red light indicates that the Production Press has a serious fault.</li> </ul> <p>If you do not know the reason for the alert, check the messages on the Control Center.</p> |
|    | <p><b>Warning Icon:</b> When a warning icon appears on the Control Center, it indicates that an item needs attention, but is not serious enough to halt or prevent printing.</p>  |
|  | <p><b>Fault Icon:</b> When an fault icon appears on the Control Center, it indicates that an item needs attention and is preventing the Production Press from printing.</p>   |
|  | <p><b>Information Icon:</b> Click the information <b>icon</b> for detailed information about a Warning.</p>   |
|  | <p><b>Check Mark:</b> The check mark icon indicates the successful completion of a process.</p>   |
|  | <p><b>Consumable Status Icons:</b></p> <ul style="list-style-type: none"> <li>• <b>Red:</b> A red icon indicates that operator action is required.</li> <li>• <b>Yellow:</b> A yellow icon appears when a consumable requires replacement soon.</li> <li>• <b>Green:</b> A green icon appears when a consumable supply is sufficient.</li> </ul>  |
|  | <p><b>Dry Ink or Toner Status Icons:</b> Each color bar reflects the status of one dry ink or toner color cartridge.</p>  |
|  | <p><b>Manage Stock Library Actions:</b></p> <ul style="list-style-type: none"> <li>• <b>Add:</b> To add or create, a new stock, select the stock, then click the add icon.</li> <li>• <b>Edit:</b> To edit the properties for a stock, select the stock, then click the edit icon.</li> </ul>   |

| IMAGE   | DESCRIPTION   |
|---|---|
|   | <ul style="list-style-type: none"> <li>• <b>Copy:</b> To copy a stock, select the stock, then click the copy icon.</li> <li>• <b>Delete:</b> To delete a stock from the library, select the stock, then click the delete icon.</li> </ul>   |
|  | <p><b>Tray Status Icons:</b> This icon provides a quick summary of the tray status including: tray number, stock loaded, and a color bar that represents the remaining stock in the tray.</p>   |
|  | <p><b>Recommended Media List Actions:</b></p> <ul style="list-style-type: none"> <li>• <b>View:</b> To view properties of a stock, select the stock, then click the view icon.</li> <li>• <b>Edit and Add:</b> To copy a stock from the RML to the Stock Library and edit it, select the stock, then click the edit and add icon.</li> <li>• <b>Add:</b> To copy a stock from the RML to the Stock Library without editing, select the stock, then click the add icon. When you click OK, the stock is added to the Stock Library just as it is listed in the RML.</li> </ul> |

## SPECIALTY DRY INKS AND TONERS

The Xerox® Iridesse® Production Press uses cartridges of color toner and dry ink. The cartridges are located behind the two smaller doors at the top of the press. The press supports four-, five-, and six-color configurations.



The Xerox® Iridesse® Production Press uses HD EA toner for CMYK colors, and HD EA dry ink for Gold, Silver, Clear, White, and Fluorescent Pink.

- The Gold and Silver Dry Inks offer high-reflectance capability. Use these metallic dry inks to add gold or silver highlights to logos or graphic images.
- To enhance your prints, use the full-flood method or the spot method, along with the Clear Dry Ink. Both methods use a varnish or clear coat to achieve appropriate effects.
- Use White Dry Ink for accents and special effects.

- To obtain new effects and colors, add Fluorescent Pink Dry Ink to the CMYK colors.

### Pink Gamut Extension

Fiery® Print Server version 4.0 include Fiery System version FS600 and have unique features that are not available on older Fiery® Print Servers. After loading Fluorescent Pink in the Press, on Fiery® Print Server version 4.0, FS600 or newer version, you can initiate On-press gamut extension. It is a fast, automated process that maximizes the value of Fluorescent Pink. While On-press gamut extension can work with Fluorescent Pink in either station, it is recommended to run it in the underlay station for the most vibrant results. Once initiated, the print server assesses the job and automatically determines how its content can be improved with Fluorescent Pink Dry Ink. For example, adding more vibrancy, pop and detail to images, or improving the accuracy of brand-critical spot colors. To create more impactful prints, the gamut extension automatically creates a color-managed channel that applies Fluorescent Pink in the ideal places and at the ideal percentages. You can preview the channel and make minor adjustments to fine-tune the application of Fluorescent Pink, if needed. The color-managed channel is pre-optimized to avoid the need for manual corrections.

On-press gamut extension can be applied to all elements within a PDF or only to spot colors. When used for spot colors only, the Press applies its standard CMYK profile to images and the color-managed Fluorescent Pink channel to spot colors. Improvements can be defined with the following elements:

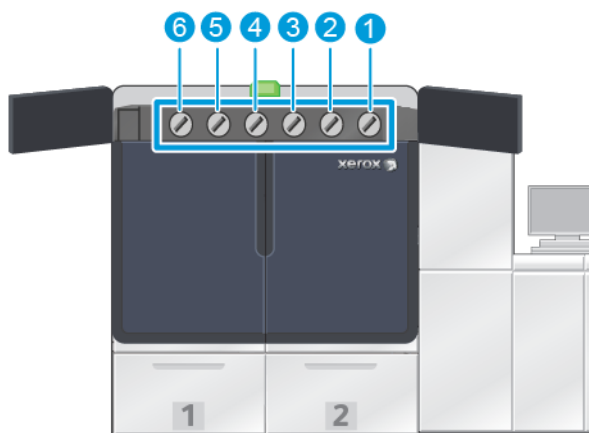
- **Images:** On-press gamut extension boosts the CMYK image quality by adding more vibrancy and detail to a wide array of four-color photos.
- **Spot Colors:** On-press gamut extension makes it easier to match more brand-critical spot colors, automatically.

To learn more about Pink Gamut Extension, refer to [Fiery - Xerox Iridesse Production Press](#).

### Specialty Dry Ink Stations and Printing Order

Four toner stations are standard with the Production Press: Yellow (Y), Magenta (M), Cyan (C), and Black (K) colors. The optional Specialty Dry Ink stations are Clear-CLR, White-WHT, Gold-GLD, Silver-SLV, or Fluorescent Pink-FPK. You can install only two of the specialty inks at one time.

From right to left, across the top of the Production Press, the stations are numbered from 1–6. If you have Clear or Low Gloss Clear specialty dry ink, you can load it in Station 1 only. If you have Gold, Silver, White, or Fluorescent Pink specialty dry ink, you can load any of these colors in either Station 1 or Station 6.



## Printing Order of Ink:

The Drum Cartridges transfer the xerographic image onto the Transfer Belt. The Transfer Belt rotates counterclockwise. If Silver is in Station 1 and Gold is in Station 6, the Production Press transfers the images onto the belt with Silver first, then Yellow, Magenta, Cyan, Black, and Gold.

The Transfer Belt then transfers the images to the paper. When the image is transferred to the paper, the order of the inks is reversed. As the belt contacts the paper, the Gold on the top ink layer transfers first, followed by Black, Cyan, Magenta, Yellow, and Silver. Since Silver is transferred last, it is on top of the ink layers on the paper.

Station 1 places the ink on the belt first and the other inks are placed over it. After the transfer to paper, the order of the ink is reversed. As a result, Station 1 is referred to as an Overlay. After the transfer from the belt to paper, Station 6 ink is on top of the other inks, and is called an Underlay.

## FULL WIDTH ARRAY

The Full Width Array is an assembly located in the paper path, after the Decurler Module. It contains an inline scanner to provide image-quality adjustments, print server calibration, and destination profiling. After an administrator or operator initiates the process, measurements and adjustments are performed automatically. The Full Width Array improves operator and press productivity and enables you to set and maintain consistent image quality.

The Full Width Array enables the EZ Press Check process. After a few simple clicks, you can choose all the options required to perform a simultaneous color and image-quality maintenance check. Included in the check are an automated alignment adjustment, an automated 2nd bias transfer roll adjustment, and an automated density-uniformity adjustment.

## XEROX REMOTE SERVICES

Xerox Remote Services are a key feature of your Xerox Production Press. This program provides you with several important support features from Xerox:

- **Remote Diagnostics:** This feature provides quick identification of potential problems, and helps with the resolution of any existing problems. Remote Diagnostics automatically sends detailed service data periodically to the Xerox Service Center for analysis and diagnosis. Many issues are resolved quickly without having to send a Service representative to your site,
- **Automated Meter Reads:** This feature automates the process of collecting and submitting meter reads for tracking and billing purposes. Automated Meter Reads generates and sends current meter reads directly to Xerox, eliminating the need for you to have to perform this task.
- **Automatic Supplies Replenishment:** This feature automatically orders certain supplies for your Production Press, based on your actual usage. Automatic Supplies Replenishment saves time by eliminating the need for you to place an order manually and manage your supplies inventory.



Note: Automatic Supplies Replenishment is available in selected markets.

- **Secure Communications:** Xerox Remote Services create a secure Internet connection between the Production Press and Xerox, using SSL protocols and 256-bit encryption. This connection ensures that your information is protected. Only Production Press performance information is sent to Xerox through this connection.



## BILLING

The Billing window is where you learn about the billing meters for the Production Press and the number of image impressions successfully printed from the Production Press. These meters ensure that your jobs are billed accurately.

### Accessing Billing Information

To access and view information about the billing meters and usage counters for various types of print impressions, perform the following steps:

1. From the System menu on the main window, click **Billing And Counters**.  
The Billing and Counters window appears.
2. To view the meters on your system and the total impressions to date, select the **Billing Meters** tab.
3. To view more detail on the impression count being tracked, select the **Usage Counter** tab.

### Billing Impression Mode

The type of Billing Impression Mode used by your Production Press is set during system installation. The Billing Impression Mode defines how the Production Press tracks and records impressions made on large-size paper, such as A3 or tabloid. A Xerox Sales Representative can confirm the Billing Impression Mode applicable for your Production Press.

There are two types of Impression Modes:

- **A3 Impression Mode:** This mode increments either the black or color impression counter once for any sheet size up to SRA3 (13 x 19.2 in.).
- **A4 Impression Mode:** This mode increments either the black or color impression counter once for any sheet size up to 145 square inches. This mode increments twice for sheet sizes ranging from 8.5 x 14 in. to SRA3 (13 x 19.2 in.).

To view or change the current Billing Impression Mode in effect on the Production Press:

1. Click **Log In** at the upper right of the Control Center main window, and log in as Administrator.
2. Select the **Administration** button. The System Settings window appears.
3. Select the **User Interface** tab and locate the Billing Impression Mode field on the right side of the window.
4. To change the billing impression mode configured on the system, click **Change Impression Mode**.
5. From the Change Impression Mode window that appears, enter the PIN code and select **OK**. This code is provided by the Hotline.
6. From the System Settings window, select **OK**.

### Billing Meters




Note: The billing meters that appear on the Control Center vary depending on your Production Press configuration, region, and setup.

This feature allows you to understand how the system charges and bills for print services. The Billing Meters tab from the Billing and Counters window lists the total number of impressions for color, black only, large, and extra long printed output.


 Note: An impression is the image on one side of one sheet of media.

The totals listed represent a complete history from the first Production Press use. The impression information is separated into the following categories:

- **Color Impressions:** This value represents the total number of color impressions, regardless of the media size.
  - For each color, 1-sided printed output, the meter increases by one.
  - For each color, 2-sided printed output, the meter increases by two.
- **Black Impressions:** This value represents the total number of black-only impressions, regardless of the media size.
  - For each black-only, 1-sided printed output, the meter increases by one.
  - For each black-only, 2-sided printed output, the meter increases by two.
- **Total Impressions:** This value represents the total number of all impressions, regardless of size or color. It is the sum of the color impressions and the black impressions combined.
- **Color Large Impressions:** This value represents the total number of large color impressions. These impressions are one side of one sheet of media greater than 145 square inches, such as A3 or 11 x17 in.
  - For each large, color, 1-sided printed output, the meter increases by one.
  - For each large, color, 2-sided printed output, the meter increases by two.

 Note: This value is not added to total impressions since every color large impression is counted as a color impression, which is included in total impressions.

- **Black Large Impressions:** This value represents the total number of large, black-only impressions. These impressions are one side of one sheet of media greater than 145 square inches, such as A3 or 11 x17 in.
  - For each large, black-only, 1-sided printed output, the meter increases by one.
  - For each large, black-only, 2-sided printed output, the meter increases by two.

 Note: This value is not added to total impressions since every black large impression is counted as a black impression, which is included in total impressions.

- **Extra Long Impressions:** For this impression type, the meter increases by two for any media with a length between 491 mm (19.33 in.) and 661 mm (26 in.). The meter increases by three for any media with a length that is greater than 661 mm (26 in.) and less than 877 mm (34.5 in.)

## Usage Counter

The Usage Counter tab from the Billing and Counters window allows you to view more detail on impression counts that are tracked on the Production Press.

The types of counter categories listed represent a particular type of printed job. There are counters for sheets and impressions of various sizes and colors. Definitions of some of the counter terms listed include:

- Impressions: An image on one side of one sheet of media
- Large: A sheet of media that is greater than 145 square in. and less than 491 mm (19.33 in.) in length
- 3xA4 Long: A sheet of media that is greater than 491 mm (19.33 in.) and less than 661 mm (26 in.) in length
- 4xA4 Long: A sheet of media that is greater than 661 mm (26 in.) and less than 877 mm (34.5 in.) in length

- Color: Any image that contains cyan, magenta, or yellow toner
- Black: Any image that contains only black toner
- Clear, Silver, Gold, White, or Fluorescent Pink: Any image that contains only that specialty color toner

## OPTIONAL COMPONENTS

The Xerox® Iridesse® Production Press ships with a wide variety of optional feeding and finishing components. These components enable you to customize the capabilities of your production press system.

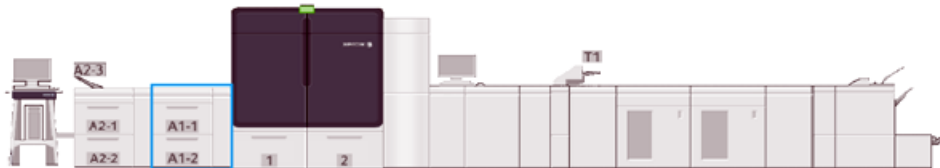
- **Feeders**
- **Finishers**

### Feeders

The following high-capacity feeders are available for your production press. Having these additional trays enables you to keep various stocks always loaded, extends your productivity, and extends your continuous run times.


#### Advanced Oversized High Capacity Feeder

You can purchase the Advanced Oversized High Capacity Feeder for your Xerox system to extend its paper capacity. The Advanced Oversized High Capacity Feeder is comprised of two high-capacity trays, Trays A1-1 and A1-2.



#### Dual Advanced High Capacity Feeder

You can purchase the Dual Advanced High Capacity Feeder for your Xerox system to extend its paper capacity. This optional feeder adds two High-Capacity Trays, Trays A2-1 and A2-2, to the configuration.

 Note: The Dual Advanced High Capacity Feeder requires the two-tray Advanced High Capacity Feeder.

These trays feed various stock sizes, including standard and heavy weight. The trays also feed large-sized stocks up to 330 x 488 mm (13 x 19.2 in.) and weigh between 52 g/m<sup>2</sup> and 400 g/m<sup>2</sup>. Each tray holds 2000 sheets of 90 g/m<sup>2</sup> uncoated stock.



#### Multi-Sheet Inserter

The Multi-Sheet Inserter, Tray A1-3 or A2-3, depending on your feeder configuration, is a paper tray on the left side of the Production Press. The tray accommodates all types of stock in various size and weight ranges. The Multi-Sheet Inserter holds a maximum of 250 sheets of 75 g/m<sup>2</sup> (20 lb.) plain paper.

- When optional feeding devices are added to the press configuration, the mounting location for the Multi-Sheet Inserter varies.
- The Multi-Sheet Inserter is the only tray that can feed extra long sheets (over 19.2 in. or SRA3).

## Finishers

This section describes the different finishers available with the press.

### Offset Catch Tray

The Offset Catch Tray receives the completed print job. Output print sets are offset for easy separation. The maximum capacity of the Offset Catch Tray is 500 sheets of 90 g/m<sup>2</sup> (24 lb.) paper.

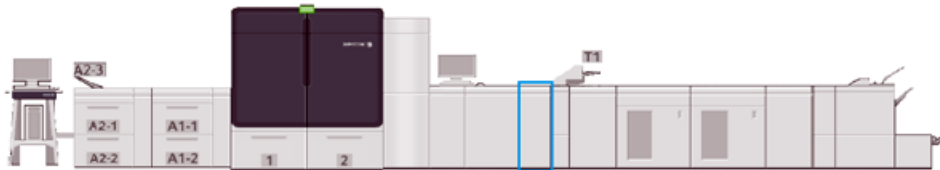


### Interface Decurler Module

The Interface Decurler Module is required with any inline finishing devices installed with the system. The Interface Decurler Module is not required with the Offset Catch Tray.

The Interface Decurler Module enables:

- Communication between the Production Press and the attached finishing devices
- An aligned paper path between the Production Press and the attached finishing device
- Paper cooling and decurling as the paper exits the Production Press



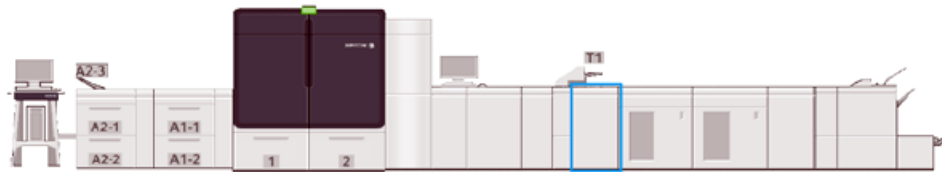
### Inserter Module

Use the Inserter Tray, tray T1, to load stock, such as blank, pre-printed, or special stock that is inserted into the finished output. The stock serves as separators and covers for the printed output. The Production Press does not print on paper fed from the Inserter; the Inserter is positioned in a post-process location in the paper path. Instead, paper from the Inserter is placed into the printed output at selected locations.




### GBC® AdvancedPunch® Pro

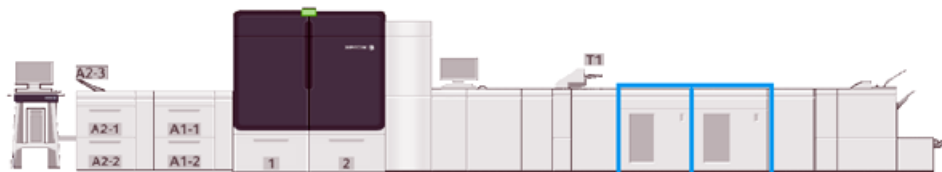
The GBC® AdvancedPunch® Pro is an automatic hole-punch module that integrates with the Production Press. Together they streamline the production of reports, directories, pricing guides, and bound books. It equals or better traditional quality while saving time and increasing productivity by eliminating the labor-intensive steps of manual punching.



### High Capacity Stacker

The High Capacity Stacker is an optional finishing device that provides stacking and offsetting capabilities for output to a stacker tray.

 Note: The following image illustrates two high-capacity stackers.



### Crease and Two-Sided Trimmer

The Crease and Two-sided Trimmer is an optional finishing device that performs creasing and trims output on two sides.



### C/Z Folder

The C/Z Folder is an optional finishing device that provides C-fold and Z-fold output for A4 (8.5 x 11 in.) output and A3 (11 x 17 in.) media.

The C/Z Folder requires the Interface Decurler Module and is available only with one of the optional Production Ready Finisher models.



### Production Ready Finishers

The Production Ready Finisher and Production Ready Booklet Maker Finisher provide the following capabilities:

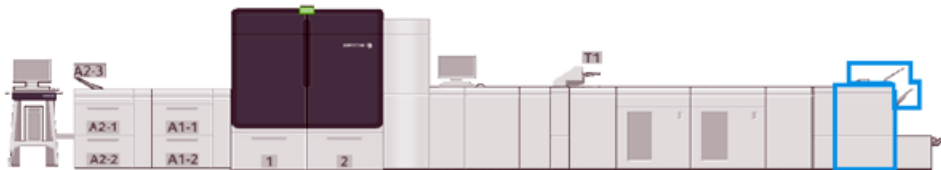
- Handling stock as small as A5 (5.83 x 8.27 in.).
- Handling large-sized stock, up to 330.2 x 488 mm (13 x 19.2 in.).

The Production Ready Finisher consists of a top tray, a stacker tray, a variable-length stapler, and optional hole-punch. It can staple up to 100 sheets with one or two staples.

The Production Ready Finisher Plus provides the same features as the Production Ready Finisher. Also, to enable an inline connection to available third-party finishing devices, the Production Ready Finisher Plus adds a Finishing Transport Module.

The Production Ready Booklet Maker Finisher provides all the same features as the Production Ready Finisher. It also creates booklets containing up to 30 sheets.

The following image shows the Production Ready Finisher with the SquareFold® Trimmer Module attached below it.

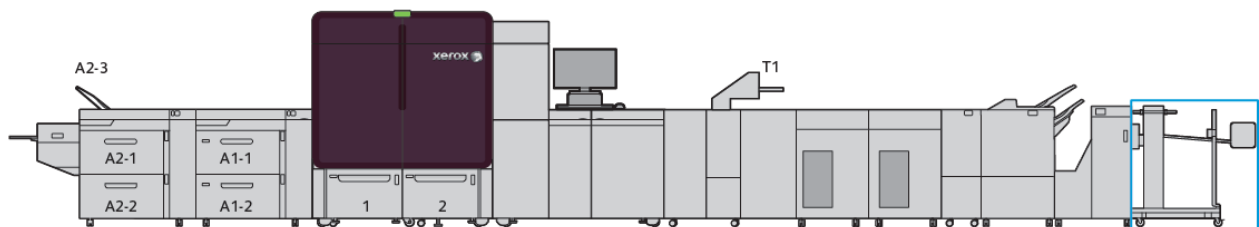


### Plockmatic MPS XL (Multi-Purpose Stacker)

The Plockmatic Multi-Purpose Stacker XL is a flexible stacking solution that assists operators with paper stacking and handling during the finishing process. The stacker offers a unique combination of features with a printer in a single product.

The stacker can stack a wide variety of media, such as A4 or Letter trifold or gatefold, A4 or Letter Landscape brochures, leaflets, menus, business cards, postcards, and so on.

For your Digital Press to be compatible with Plockmatic Multi-Purpose Stacker XL, it is required to connect the MPS with a PR Finisher Plus module.



### SquareFold® Trimmer Module

The SquareFold® Trimmer Module is an optional finishing device that is used with a finishing device that contains a booklet maker. The SquareFold® Trimmer Module can cut the edge of the book and can also square-fold the book. These finishing options improve the appearance of the book.



## System Specifications

Refer to System Specifications to learn about environmental requirements for maintaining the Production Press and the associated modules. Also, review the specifications for supported stock types and sizes required for different modules.

- [Production Press Specifications](#)
- [Environmental Specifications](#)
- [Stock Specifications](#)

### PRODUCTION PRESS SPECIFICATIONS

#### Production Press Warm-up Time

The Production Press warm-up times vary depending on the environment or current state or mode of the Production Press. Warm-up times are as follows:

- From a cold start, either power on or power saver mode, 5–7 minutes
- From sleep mode or power saver mode, less than 5 minutes
- From standby, less than 1 minute
- When switching print modes, approximately 2 minutes

#### First Print-Out Time

- From a cold start, either power on or power saver, the system takes less than 5 minutes to start printing
- From standby mode, when Lower Power Mode is disabled, the system usually takes less than 1 minute to start printing.

When Lower Power Standby Mode is enabled, it takes less than 3 minutes to start printing.

### ENVIRONMENTAL SPECIFICATIONS

#### Ambient Temperature and Humidity

10°–32° C (50°–90° F), 85 % Relative Humidity (RH) J zone

- When the temperature is 32° C (90° F), the humidity needs to be 62.5 % or below.
- When the humidity is 85 %, the temperature needs to be 28° C (82° F) or below.
- Coated stock does not perform well when the relative humidity exceeds 60 %.
- When conditions are maintained between 20–25° C (68–77° F) and 45–55 % RH, performance is better.
- If the relative humidity exceeds 55 %, water spots can appear on the first few prints.
- The Xerox® Iridesse® Production Press can operate at altitudes up to 2500 m (8200 ft) with no additional adjustments or kits. Locations above 2500 m can require field adjustments.

## STOCK SPECIFICATIONS



Note: Always refer to the Recommended Media List (RML) for a comprehensive list of recommended media. You can access the RML from the PredictPrint Media Manager or the Manage Stock Library, depending on your software version, or you can download it from:

- PredictPrint Media Manager: <https://www.xerox.com/predictprintmedia>
- Manage Stock Library: [www.xerox.com/IRIDESSEsupport](http://www.xerox.com/IRIDESSEsupport)



| STOCK TYPE               | STOCK SIZE              | DIMENSIONS<br>(MM) SEF X LEF | WEIGHT (G/M <sup>2</sup> ) | COATING TYPE |
|--------------------------|-------------------------|------------------------------|----------------------------|--------------|
| Plain paper              | B5 SEF/LEF              | 182.0 x 257.0                | 52–400                     | Uncoated     |
| Embossed                 | A4 SEF/LEF              | 210.0 x 297.0                |                            | Coated       |
| Postcard                 | A4-Cover SEF/LEF        | 223.0 x 297.0                |                            |              |
| Drilled                  | DT Special A4 SEF/LEF   | 226.0 x 310.0                |                            |              |
|                          | B4 SEF                  | 257.0 x 64.0                 |                            |              |
|                          | A3 SEF                  | 297.0 x 420.0                |                            |              |
|                          | SRA3 SEF                | 320.0 x 450.0                |                            |              |
|                          | DT Special A3 SEF       | 310.0 x 432.0                |                            |              |
|                          | 4 x 6 in. SEF           | 101.6 x 152.4                |                            |              |
|                          | 7.25 x 10.5 in. SEF/LEF | 184.2 x 266.7                |                            |              |
|                          | 8 x 10 in. SEF/LEF      | 203.2 x 254.0                |                            |              |
|                          | 8.46 x 12.4 in. SEF     | 215.0 x 315.0                |                            |              |
|                          | 8.5 x 11 in. SEF/LEF    | 215.9 x 279.4                |                            |              |
|                          | 8.5 x 13 in. SEF/LEF    | 215.9 x 330.2                |                            |              |
|                          | 8.5 x 14 in. SEF        | 215.9 x 355.6                |                            |              |
|                          | 9 x 11 in. SEF/LEF      | 228.6 x 279.4                |                            |              |
|                          | 11 x 15 in. SEF         | 279.4 x 381.0                |                            |              |
|                          | 11 x 17 in. SEF         | 279.4 x 431.8                |                            |              |
|                          | 12 x 18 in. SEF         | 304.8 x 457.2                |                            |              |
|                          | 12.6 x 19.2 in. SEF     | 320.0 x 488.0                |                            |              |
|                          | 13 x 18 in. SEF         | 330.2 x 457.2                |                            |              |
|                          | 16-kai (TFX) SEF/LEF    | 194.0 x 267.0                |                            |              |
|                          | 16-kai (GCO) SEF/LEF    | 195.0 x 270.0                |                            |              |
| Pa-kai (TFX) SEF         | 267.0 x 388.0           |                              |                            |              |
| pa-kai (GCO) SEF         | 270.0 x 390.0           |                              |                            |              |
| Executive LEF            | 10.5 x 7.25 in. LEF     | 184.2 x 266.7                | —                          | —            |
| Quatro LEF               | 8 x 10 in.              | 203.2 x 254.0                | —                          | —            |
| Government-Legal SEF/LEF | 8.5 x 13 in.            | 215.9 x 330.2                | —                          | —            |
| DT Special A4 SEF/LEF    | 8.90 12.20 in.          | 226.0 x 310.0                | —                          | —            |

| STOCK TYPE        | STOCK SIZE          | DIMENSIONS<br>(MM) SEF X LEF | WEIGHT (G/M <sup>2</sup> ) | COATING TYPE   |
|-------------------|---------------------|------------------------------|----------------------------|----------------|
| DT Special A3 SEF | 12.20 x 17.00 in.   | 310.0 x 432.0                | —                          | —              |
| SRA3 SEF          | 12.60 x 17.72 in.   | 320.0 x 450.0                | —                          | —              |
| Transparency      | 8.5 x 11 in./A4 LEF | 215.9 x 279.4                | —                          | —              |
| Labels            | 8.5 x 11 in./A4 LEF | 215.9 x 279.4                | 190                        | Gloss<br>Matte |
| Tabbed Inserts    | 8.5 x 11 in./A4 LEF | 215.9 x 279.4                | 163                        | Uncoated       |

### Advanced and Dual Advanced High Capacity Feeders Specifications



Note: Paper height below 182 mm (7.16 in.) requires the postcard bracket.

| ITEM           | SPECIFICATION  |
|----------------|--|
| Sheet Size     | <p>Standard sizes:</p> <ul style="list-style-type: none"> <li>• Letter (8.5 x 11 in.)</li> <li>• Legal (8.5 x 14 in.)</li> <li>• Tabloid (11 x 17 in.)</li> <li>• Quarto (8 x 10 in.)</li> <li>• Foolscap (8.3 x 13 in.)</li> <li>• Tabloid Oversized (12 x 18 in.)</li> <li>• A4 (210 x 297 mm)</li> <li>• A3 (297 x 420 mm)</li> <li>• JIS B5 (182 x 257 mm)</li> <li>• JIS B4 (257 x 264 mm)</li> <li>• SRA3 (320 x 450 mm)</li> <li>• 8K (267 x 388 mm)</li> <li>• 8K (270 x 390 mm)</li> <li>• 16K (267 x 194 mm)</li> <li>• 16 K (270 x 195 mm)</li> <li>• Executive (7.25 x 10.5 in.)</li> <li>• DT Special A4 (226 x 310 mm)</li> <li>• DT Special A3 (310 x 432 mm)</li> <li>• 12.6 x 19.2 in.</li> <li>• 13 x 18 in.</li> <li>• 13 x 19 in.</li> <li>• Postcard (4 x 6 in.)</li> <li>• Postcard (100 x 148 mm)</li> <li>• #7 3/4 (Monarch) (3 7/8 x 7 1/2 in.)</li> <li>• #10 (4 1/8 x 9 1/2 in.)</li> <li>• C5 (6.4 x 9 in.)</li> <li>• C4 (9.0 x 12.8 in.)</li> </ul> <p>Custom sizes:</p> <p> Note: For long sheets, a custom size is required.</p> <ul style="list-style-type: none"> <li>• Width: 148.0–488 mm (5.83–19.21 in.), Height: 98.0–330.2 mm (3.86–13.0 in.)</li> </ul> <p> Note: For internal and external trays except for the Multi-Sheet Inserter.</p> <ul style="list-style-type: none"> <li>• Width 146.0–1200 mm (5.75–47.24 in.), Height: 98.0–330.2 mm (3.86–13.0 in.)</li> </ul> <p> Note: The size is only available with the Multi-Sheet Inserter.</p> |
| Stock Weight   | 52–400 g/m <sup>2</sup>  |
| Stock Capacity | <p>2000 sheets/drawer</p> <p> Important: Specification applies only when using stocks up to Xerox 24 lb./90</p>   |

| ITEM | SPECIFICATION      |
|------|--------------------|
|      | g/m <sup>2</sup> . |

### Dual Advanced Oversized High Capacity Feeder Specifications

| MINIMUM SIZE                | MAXIMUM SIZE                 |
|-----------------------------|------------------------------|
| 3.86 x 5.75 in./98 x 146 mm | 13 x 19.2 in./330.2 x 488 mm |

### Finishing Devices

This section provides information on:

- [Inserter Tray](#)
- [High Capacity Stacker](#)
- [Crease and Two-Sided Trimmer](#)
- [C/Z Folder](#)
- [Production Ready Finishers](#)
- [SquareFold® Trimmer Specifications](#)

#### Inserter Tray



Tip: The Production Press does not print on media fed from the Inserter Tray. Instead, the media is inserted into the printed output at selected locations.

| PAPER SIZE   | PAPER WEIGHT  | TRAY CAPACITY                      |
|--|---|------------------------------------|
| 182 x 148 mm (7.2 x 5.8 in.) – 330 x 488 mm A3 (13 x 19.2 in.) | 52–400 g/m <sup>2</sup> uncoated / 72–350 g/m <sup>2</sup> coated * | 250 sheets<br>based on Colotech+90 |

\*



Note: Use the Inserter Tray when combining the following stock types and saddle-stitch or bi-fold:

- Coated paper weighing 127 g/m<sup>2</sup> or less
- Blank sheets, unprinted stock, weighing 80 g/m<sup>2</sup> or less

If you use a tray other than the Inserter Tray, the combination can cause the misalignment of folding positions and wrinkling.

#### High Capacity Stacker

- The Stacker Tray accepts 52–400 g/m<sup>2</sup>, either coated or uncoated stock.



Note: Media that are heavier than 300 g/m<sup>2</sup> are prone to have degraded stock quality and an increased jam rate.

- Output transparencies to either the Top Tray or the Stacker Tray. Limit the stack height to 100 transparencies.
- Coated paper that is heavier than 100 g/m<sup>2</sup> runs more reliably than coated paper lighter than 100 g/m<sup>2</sup>.

- Non-standard papers that are longer than 305 mm (12 in.) in the feed direction, are required to be at least 210 mm (8.3 in.) across the feed direction.
- Non-standard papers shorter than 254 mm (10 in.) in the cross-feed direction are required to be at least 330 mm (13 in.) in the feed direction.

### Recommended Stack Heights

Be aware of the following points:

- Due to stack weight limitations of the High Capacity Stacker, to prevent damage to the unit caused by an excessively heavy stack, particular settings are necessary. For sheets larger than 8.5 x 11 in. or A4, for approximate stack sizes, refer to the following chart.
- Stack quality can degrade and jams can increase with 64–106 g/m<sup>2</sup> coated paper stocks.
- Watch for paper misalignments when you send mixed stock sizes to the High Capacity Stacker. To improve alignment and stack integrity, unload the High Capacity Stacker between jobs that use different stock sizes.

**Table 1.1 High Capacity Stacker Specifications**

| FEATURE               | SPECIFICATIONS                 |
|-----------------------|--------------------------------|
| Stacker Tray Capacity | 5000 sheets                    |
| Top Tray Capacity     | 500 sheets                     |
| Maximum Stack Weight  | 70 kg (154 lb.)                |
| Maximum Paper Size    | 330 mm x 488mm (13 x 19.2 in.) |


### Hints and Tips

When you use the High Capacity Stacker, refer to the following hints and tips:



1. In the applicable High Capacity Stacker tray, check the media for curl.
  - a. If no curl is present, and if the output is acceptable and meets your requirements, you are finished.
  - b. If curl is present, continue to the next step.
2. To correct the media curl, use the curl correction controls on the top of the Interface Decurler Module.
3. If the output is not improved, adjust the curl again.
4. If the output is still not improved, call the Customer Support Center.

### Crease and Two-Sided Trimmer

| ITEM         | SPECIFICATION |               |                            |                             |
|--------------|---------------|---------------|----------------------------|-----------------------------|
| 2-Sided Trim | Media Size    | Standard Size | Minimum                    | Executive (7.25 x 10.5 in.) |
|              |               |               | Maximum                    | SRA3                        |
|              | Custom Size   | Height        | 182–210 mm (7.17–8.27 in.) |                             |


| ITEM   | SPECIFICATION |                         |       |                            |
|--|---------------|-------------------------|-------|----------------------------|
|  |               |                         | Width | 330.2–488 mm (13–19.2 in.) |
|  | Media Weight  | Uncoated                |       | 52–400 g/m <sup>2</sup>    |
|  |               | Coated                  |       | 106–350 g/m <sup>2</sup>   |
|  | Trimming Size | 6–25 mm (0.24–0.99 in.) |       |                            |
|  Note: Setting a head-to-toe trimming area size of 7 mm (0.275 in.) or less can damage the trimmed edges. |               |                         |       |                            |


**C/Z Folder**



| ITEM              | SPECIFICATION  |                                       |
|-------------------|--|---------------------------------------|
| Z-Fold Half Sheet | Media Size   | 11 x 17 in. (Tabloid)<br>A3<br>JIS B4 |
|                   | Media Weight   | 60–90 g/m <sup>2</sup> (Uncoated)     |
|                   |  Note: Each Z-Fold Half Sheet added to a stapled set counts as 10 sheets. It reduces the total number of sheets for any given specified weight range. |                                       |
| Trifold (C or Z)  | Media Size   | 8.5 x 11 in. (Letter)<br>A4           |
|                   | Media Weight   | 60–90 g/m <sup>2</sup> (Uncoated)     |
| Tray Capacity     | 30 sheets<br> Note: Values are based on Colotech+90.  |                                       |

**Production Ready Finishers**

| ITEM       | SPECIFICATION |   |         |                         |
|------------|---------------|---|---------|-------------------------|
| Tray       | Top Tray      | Collate and stack   |         |                         |
|            | Stacker Tray  | Collate, offsetting supported and stack, offsetting supported |         |                         |
|            | Booklet Tray  | Collate and stack   |         |                         |
| Media Size | Top Tray      | Standard Size   | Minimum | Postcard (100 x 148 mm) |
|            |               |   | Maximum | 13 x 19 in., A3         |

| ITEM  | SPECIFICATION                 |                         |  |                     |
|---|-------------------------------|-------------------------|--|---------------------|
|   |                               | Custom Size             | Height   | 98.0–330.2 mm       |
|   |                               | Width                   | 148.0–660.4 mm   |                     |
|   | Stacker Tray                  | Standard Size           | Minimum  | 5.83 × 8.27 in., A5 |
|   |                               |                         | Maximum  | 13 x 19 in., A3     |
|   |                               | Custom Size             | Height   | 148.0–330.2 mm      |
|   |                               |                         | Width  | 148.0–488.0 mm      |
|   | Booklet Tray                  | Standard Size           | Minimum  | JIS B5              |
|   |                               |                         | Maximum  | 13 x 19 in., A3     |
|   |                               | Custom Size             | Height   | 182.0–330.2 mm      |
|   |                               |                         | Width  | 257.0–488.0 mm      |
| Stock Weight  | Top Tray                      | 52–400 g/m <sup>2</sup> |  |                     |
|   | Stacker Tray                  | 52–400 g/m <sup>2</sup> |  |                     |
|   | Booklet Tray                  | 60–350 g/m <sup>2</sup> |  |                     |
| Tray Capacity   | Top tray                      | 500 sheets              |  |                     |
|   | Stacker Tray, without staples | 8.5 x 11 in., A4        | Production Ready Finisher: 3000 sheets<br>Production Ready Booklet Maker Finisher: 2000 sheets             |                     |
|   |                               | JIS B4 or larger        | 1500 sheets  |                     |
|   |                               | Mix Stack               | 350 sheets   |                     |
|   | Stacker Tray, with staples    | 8.5 x 11 in., A4        | Production Ready Finisher: 200 sets or 3000 sheets<br>Production Ready Booklet Maker Finisher: 2000 sheets |                     |
|   |                               | JIS B4 or larger        | 100 sets or 1500 sheets  |                     |
|   | Booklet Tray                  | 20 sets                 |  |                     |
|  Note: <ul style="list-style-type: none"> <li>The values are based on Colotech+90.</li> <li>Mix stack means a set of stock sheets, where larger sheets are placed over smaller ones. For example, A4 over JIS B5, or JIS B4 over A4.</li> <li>If one set consists of 17 or more sheets, the Booklet Tray capacity is 16 sets.</li> </ul> |                               |                         |  |                     |
| Staple  | Capacity                      | 100 sheets              |  |                     |

| ITEM | SPECIFICATION  |                                |                         |                           |
|------|--|--------------------------------|-------------------------|---------------------------|
|      |  Note: <ul style="list-style-type: none"> <li>The values are based on Colotech+90.</li> <li>5 sheets, larger than A4 or Letter (8.5 x 11 in.).</li> </ul> |                                |                         |                           |
|      | Media Size   | Standard Size                  | Minimum                 | 5.83 × 8.27 in., A5       |
|      |  |                                | Maximum                 | Tabloid (11 x 17 in.), A3 |
|      |  | Custom Size                    | Height                  | 182.0–297.0 mm            |
|      |  |                                | Width                   | 148.0–432.0 mm            |
|      | Media Weight   | Uncoated                       | 52–400 g/m <sup>2</sup> |                           |
|      |  | Coated                         | 72–350 g/m <sup>2</sup> |                           |
|      | Stapling Position  | 1 place, 2 places, or 4 places |                         |                           |

| ITEM                                    | SPECIFICATION   |                           |                         |                           |
|---|---|---------------------------|-------------------------|---------------------------|
| Punch,<br>with Punch Unit               | Media Size  | Standard Size             | Maximum                 | A3, Tabloid (11 x 17 in.) |
|   |   |                           | Minimum                 | 2-hole or 3-hole          |
|   |   | 4-hole                    |                         | A4, 16K                   |
|   |   | Custom Size               | Height                  | 203.0–297.0 mm            |
|   | Width   |                           | 182.0–431.8 mm          |                           |
|   | Media Weight  | Uncoated                  | 52–220 g/m <sup>2</sup> |                           |
|   |   | Coated                    | 72–200 g/m <sup>2</sup> |                           |
|   | Number of Holes   | 2, 4-hole or US 2, 3-hole |                         |                           |
|   |  Note: The number of punch holes you can choose depends on the media size. |                           |                         |                           |
| Saddle Stitch or Bi-Fold                | Capacity  | Saddle Stitch             | 30 sheets               |                           |
|   |   | Bi-Fold                   | 5 sheets                |                           |
| Production Ready Booklet Maker Finisher |  Note: The values are based on Colotech+90.                                |                           |                         |                           |
|   | Media Size  | Standard Size             | Maximum                 | A3, 13 x 19 in.           |
|   |   |                           | Minimum                 | JIS B5                    |



| ITEM | SPECIFICATION |             |        |                         |
|------|---------------|-------------|--------|-------------------------|
|      |               | Custom Size | Height | 182.0–330.2 mm          |
|      |               | Uncoated    | Width  | 257.0–488.0 mm          |
|      | Media Weight  |             |        | 60–350 g/m <sup>2</sup> |
|      |               | Coated      |        | 2–350 g/m <sup>2</sup>  |

### Staple Output Capacity

| MEDIA WEIGHT<br>(G/M <sup>2</sup> ) | SIDE STITCH   |        |                |        | SADDLE STITCH |        |
|-------------------------------------|---------------|--------|----------------|--------|---------------|--------|
|                                     | A4 OR SMALLER |        | LARGER THAN A4 |        | UNCOATED      | COATED |
|                                     | UN-COATED     | COATED | UNCOATED       | COATED |               |        |
| 52–59                               | 100           | 35*    | 65             | 35*    | 30*           | 25*    |
| 60–71                               |               |        |                |        | 30            |        |
| 72–80                               |               | 35     |                |        | 35            | 25     |
| 81–90                               |               |        |                |        |               |        |
| 91–105                              | 50            | 30     | 50             | 30     | 20            |        |
| 106–128                             |               |        | 45             |        | 15            |        |
| 129–150                             | 20            | 20     | 20             | 20     | 10            |        |
| 151–176                             |               |        |                |        |               |        |
| 177–220                             |               |        |                |        | 5             |        |
| 221–256                             |               |        |                |        | 4             |        |
| 257–300                             | 10            | 10     | 10             | 10     | 3             |        |
| 301–350                             |               |        |                |        |               |        |

\* Can be stapled. However, binding accuracy or feed performance cannot be guaranteed.

Values in the table indicating the maximum number of sheets that can be stapled were evaluated using the following paper types: 82 g/m<sup>2</sup>, Colotech+ (200 g/m<sup>2</sup>, 250 g/m<sup>2</sup>, 350 g/m<sup>2</sup>)



Important:

- Jobs printed on recommended media where the number of pages is within the limits can still have staple faults depending on the following factors:
  - Media type used – specifically, gloss coated stocks
  - Environment where the Production Press resides – room temperature and humidity
  - Print data
- In an environment at a low temperature and low humidity, the stapling of 40 sheets or more can cause paper jams.

- For Side Stitch, each Z-Fold Half Sheet added to a stapled set counts as 10 sheets. It reduces the total number of sheets for any given specified weight range.



Note:

- The Production Press determines stock type and stock weight based on paper information set for the job, and not based on the stock loaded in the tray.
- The Production Press determines the number of sheets per job based on job information. Therefore, when multifeeds occur, stapling continues even if the number of sheets fed exceeds the limit. However, this event can cause staple faults.

### SquareFold® Trimmer Specifications

| ITEM          | SPECIFICATIONS   |
|---------------|--|
| Media Size    | <ul style="list-style-type: none"> <li>• Maximum: 13 x 18 in. (330 x 457 mm)</li> <li>• Minimum: 8.5 x 11 in. or A4 SEF (216 x 270 mm)</li> </ul>  |
| Trim Capacity | <ul style="list-style-type: none"> <li>• 5–20 sheet booklet, up to 80 imaged sides, at 24 lb./90 g/m<sup>2</sup></li> <li>• 5–25 sheet booklet, up to 100 imaged sides, at 200 lb./80 g/m<sup>2</sup></li> </ul> |
| Trim Size     | 2–20 mm, adjustable in 0.1 mm increments   |
| Media Weights | <ul style="list-style-type: none"> <li>• 16 lb. bond-90 lb. cover</li> <li>• 64–300 g/m<sup>2</sup> uncoated; 106–300 g/m<sup>2</sup> coated</li> </ul>  |

## Regulatory Information

This section provides regulatory information for your production press.

### BASIC REGULATIONS

Xerox® has tested this printer to electromagnetic emission and immunity standards. These standards are designed to mitigate interference caused or received by this printer in a typical office environment.

Changes or modifications to this device not specifically approved by Xerox® Corporation may void the authority of the user to operate this equipment.

### FCC Regulations in the USA

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

To maintain compliance with FCC regulations, shielded cables must be used with this equipment. Operation with non-approved equipment or unshielded cables is likely to result in interference to radio and TV reception.

This device complies with Part 15 of the FCC Rules. Operation is subject to the following two conditions:

1. This device may not cause harmful interference, and
2. This device must accept any interference received, including interference that may cause undesired operation.

Responsible Party: Xerox® Corporation

Address: 800 Phillips Road, Webster, NY 14580

Web address: <https://www.xerox.com/en-us/about/ehs>.

### Canada

This Class A digital apparatus complies with Canadian ICES-003 and ICES-001.

Cet appareil numérique de la classe A est conforme à la norme NMB-003 et NMB-001 du Canada.

This device complies with Industry Canada's license-exempt RSSs. Operation is the subject to the following two conditions:

1. This device may not cause interference, and
2. This device must accept any interference, including interference that may cause undesired operation of the device.

Le présent appareil est conforme aux CNR d'Industrie Canada applicables aux appareils radio exempts de licence. L'exploitation est autorisée aux deux conditions suivantes:

1. l'appareil ne doit pas produire de brouillage, et
2. l'utilisateur de l'appareil doit accepter tout brouillage radioélectrique subi, même si le brouillage est susceptible d'en compromettre le fonctionnement.

### European Union and European Economic Area Compliance



The CE mark applied to this product indicates compliance to applicable EU Directives. You can find the full text of the EU Declaration of Conformity in [www.xerox.com/environment\\_europe](http://www.xerox.com/environment_europe).

### European Union Lot 4 Imaging Equipment Agreement

Xerox® has agreed to design criteria for energy efficiency and environmental performance of our products that are in scope of the European Union (EU) Energy Related Products Directive, specifically the Lot 4 – Imaging Equipment.

In scope products include Household and Office equipment that meet the following criteria:

- Standard monochrome format products with a maximum speed less than 66 A4 images per minute.
- Standard color format products with a maximum speed less than 51 A4 images per minute.

| TO LEARN MORE ABOUT  | GO TO   |
|--|---|
| <ul style="list-style-type: none"> <li>• Power Consumption and Activation Times</li> <li>• Default Power Saver Settings</li> </ul>   | <p><i>User Documentation</i> or <i>Systems Administrators Guide</i></p> <p><a href="http://www.xerox.com/IRIDESSEdocs">www.xerox.com/IRIDESSEdocs</a></p>                 |
| <ul style="list-style-type: none"> <li>• Environmental Benefits of Duplex Printing</li> <li>• Benefits of using lighter paper weights (60 g/m<sup>2</sup>) and Recyclability</li> <li>• Cartridge disposal and treatment</li> <li>• Xerox participation in sustainability initiatives</li> </ul> | <p><a href="http://www.xerox.com/environment">www.xerox.com/environment</a> or <a href="http://www.xerox.com/environment_europe">www.xerox.com/environment_europe</a></p> |
| <p>Benefits of purchasing ENERGY STAR® qualified products</p>  | <p><a href="http://www.energystar.gov">www.energystar.gov</a></p>   |

## ENERGY STAR



The ENERGY STAR program is a voluntary scheme to promote the development and purchase of energy-efficient models, which help to reduce environmental impact. Details on the ENERGY STAR program and models qualified to ENERGY STAR can be found at the following website: [www.energystar.gov](http://www.energystar.gov).

The ENERGY STAR and ENERGY STAR mark are registered United States trademarks.

The ENERGY STAR Imaging Equipment Program is a team effort between United States, European Union, Japanese governments, and the office equipment industry to promote energy-efficient copiers, printers, fax, multifunction printers, personal computers, and monitors. Reducing product energy consumption helps combat smog, acid rain, and long-term changes to the climate by decreasing the emissions that result from generating electricity.

For more information on energy or other related topics, go to:

- [www.xerox.com/environment](http://www.xerox.com/environment) or
- [www.xerox.com/environment\\_europe](http://www.xerox.com/environment_europe)

### Power Consumption and Activation Time

The amount of electricity that a device consumes depends on the way the device is used. This device is designed and configured to enable you to reduce your energy usage.

Low-Power mode is enabled on your device to reduce energy consumption. After the last print, the device transitions to Ready mode. In this mode, the device can print again immediately. If the device is not used for a specified period, the device transitions to Low-Power mode. In this mode, only essential functions remain active to reduce power consumption. The device takes longer to produce the first print after it exits the Low-Power mode than it takes to print in Ready mode. This delay is the result of the system waking up and is typical of most imaging devices on the market.

This device is ENERGY STAR®-qualified under the ENERGY STAR Program Requirements for Imaging Equipment. The Low-Power mode occurs after 1 minute.

To change the Energy Saver settings, refer to the *User Documentation* at [www.xerox.com/IRIDESSEdocs](http://www.xerox.com/IRIDESSEdocs). For more details, contact your System Administrator.

To learn more about Xerox participation in sustainability initiatives, go to:

- [www.xerox.com/environment](http://www.xerox.com/environment) or
- [www.xerox.com/environment\\_europe](http://www.xerox.com/environment_europe)

### Environmental Benefits of Duplex Printing

Most Xerox® products have duplex printing, also known as 2-sided printing, capability. This enables you to print on both sides of the paper automatically, and therefore helps to reduce the use of valuable resources by reducing your paper consumption. The Lot 4 Imaging Equipment agreement requires that on models greater than or equal to 40 ppm color or greater than or equal to 45 ppm monochrome the duplex function has been auto-enabled, during the setup and driver installation. Some Xerox models below these speed bands may also be enabled with 2-sided printing settings defaulted on at the time of install. Use of the duplex function will reduce the environmental impact

of your work. However, you must require simplex or 1-sided printing, you can change the print settings in the print driver.

### **Paper Types**

You can use this product to print on both recycled and virgin paper, approved to an environmental stewardship scheme, which complies with EN12281 or a similar quality standard. Lighter weight paper (60 g/m<sup>2</sup>), which contains less raw material and thus saves resources per print, can be used in certain applications. We recommend you to check if this is suitable for your printing needs.

### **Eurasian Economic Union Compliance**



The EAC mark applied to this product indicates certification for use on the markets of the Member States of the Customs Union.

### **Turkey RoHS Regulation**

In compliance with Article 7(d), we hereby certify “it is in compliance with the EEE regulation EEE yönetmeliğine uygundur.” (Compliant with EEE Regulations).

### **Ukraine RoHS Compliance**

Обладнання відповідає вимогам Технічного регламенту щодо обмеження використання деяких небезпечних речовин в електричному та електронному обладнанні, затвердженого постановою Кабінету Міністрів України від 3 грудня 2008 № 1057

(The equipment complies with requirements of the Technical Regulation, approved by the Resolution of Cabinet of Ministry of Ukraine as of December 3, 2008, in terms of restrictions for the use of certain dangerous substances in electrical and electronic equipment.)

## **COPY REGULATIONS**

### **United States**

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

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

- Certificates of Indebtedness
- National Bank Currency
- Coupons from Bonds
- Federal Reserve Bank Notes

- Silver Certificates
  - Gold Certificates
  - United States Bonds
  - Treasury Notes
  - Federal Reserve Notes
  - Fractional Notes
  - Certificates of Deposit
  - Paper Money
  - Bonds and Obligations of certain agencies of the government, such as FHA and so on
  - Bonds. United States Savings Bonds can be photographed only for publicity purposes for the campaign of the sale of such bonds.
  - Internal Revenue Stamps. If it is necessary to reproduce a legal document on which there is a canceled revenue stamp, this can be done provided the reproduction of the document is performed for lawful purposes.
  - Postage Stamps, canceled or uncanceled. For philatelic purposes, Postage Stamps can be photographed, provided the reproduction is in black and white and is less than 75 % or more than 150 % of the linear dimensions of the original document.
  - Postal Money Orders
  - Bills, Checks, or Draft of money drawn by or upon authorized officers of the United States
  - Stamps and other representatives of value, of whatever denomination, which have been or can be issued under any Act of Congress
  - Adjusted Compensation Certificates for Veterans of the World Wars
2. Obligations or Securities of any Foreign Government, Bank, or Corporation
  3. Copyrighted materials, unless permission of the copyright owner has been obtained or the reproduction falls within the fair use or library reproduction rights provisions of the copyright law. Further information of these provisions can be obtained from the Copyright Office, Library of Congress, Washington, D.C. 20559. Ask for Circular R21.
  4. Certificates of Citizenship or Naturalization. Foreign Naturalization Certificates can be photographed.
  5. Passports. Foreign Passports can be photographed.
  6. Immigration Papers
  7. Draft Registration Cards
  8. Selective Service Induction Papers that bear any of the following Registrant information:
    - Earnings or Income
    - Court Record
    - Physical or mental condition
    - Dependency Status
    - Previous military service

- Exception: United States military discharge certificates can be photographed.
9. Badges, Identification Cards, Passes, or Insignia carried by military personnel, or by members of the various Federal Departments, such as FBI, Treasury, and so on, unless the head of such department or bureau orders a photograph.

The above list is not all-inclusive, and no liability is assumed for its completeness or accuracy. If there is doubt, consult your attorney.

For more information about these provisions, contact the Copyright Office, Library of Congress, Washington, D.C. 20559. Ask for Circular R21.

## **Canada**

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

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

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

## **Other Countries**

Copying certain documents may be illegal in your country. Penalties of fine or imprisonment may be imposed on those found guilty of making such reproductions.

- Currency notes
- Bank notes and checks
- Bank and government bonds and securities
- Passports and identification cards
- Copyright material or trademarks without the consent of the owner



- Postage stamps and other negotiable instruments

This list is not inclusive and no liability is assumed for either its completeness or accuracy. In case of doubt, contact your legal counsel.

### SAFETY CERTIFICATION

This device is compliant with IEC and EN product safety standards certified by a National Regulatory Test Laboratory (NRTL).

### SAFETY DATA SHEETS

For Material Safety Data information regarding your press, go to:

- Web address: [www.xerox.com/sds](http://www.xerox.com/sds) or [www.xerox.co.uk/sds\\_eu](http://www.xerox.co.uk/sds_eu)
- United States and Canada: 1-800-ASK-XEROX (1-800-275-9376)
- For other markets, send an email request to [EHS-Europe@xerox.com](mailto:EHS-Europe@xerox.com)

## Recycling and Disposal

This section provides recycling and disposal information for your production press.

### ALL COUNTRIES

If you dispose your Xerox product, note that the printer may contain lead, mercury, perchlorate, and other materials whose disposal may be regulated due to environmental considerations. The presence of these materials is fully consistent with global regulations applicable at the time that the product was placed on the market. For recycling and disposal information, contact your local authorities.

Perchlorate Material: This product may contain one or more perchlorate-containing devices, such as batteries. Special handling may apply. For more information, go to [www.dtsc.ca.gov/hazardouswaste/perchlorate](http://www.dtsc.ca.gov/hazardouswaste/perchlorate).

### Battery Removal

Only a manufacturer approved service facility can replace the batteries.

### NORTH AMERICA

Xerox operates an equipment take-back and reuse or recycle program. To ensure that this Xerox® product is part of the program, contact your Xerox representative (1-800-ASK-XEROX). For more information about Xerox environmental programs, go to [www.xerox.com/environment](http://www.xerox.com/environment).

For recycling and disposal information, contact your local authorities.

## EUROPEAN UNION



These symbols indicate that this product is not to be disposed of with your household waste, according to the Waste Electrical and Electronic Equipment (WEEE) Directive (2012/19/EU), the Battery Directive (2006/66/EC) and national legislation implementing those Directives.



If a chemical symbol is printed beneath the symbol shown above, in accordance with the Battery Directive, this indicates that a heavy metal (Hg = Mercury, Cd = Cadmium, Pb = Lead) is present in this battery or accumulator at a concentration above an applicable threshold specified in the Battery Directive.



Some equipment can be used in both a domestic or household and a professional or business application. Private households within European Union can return used electrical and electronic equipment to designated collection facilities free of charge. For more information about collection and recycling of old products and batteries, contact your local municipality, your waste disposal service or the point of sale where you purchased the items. In some member states, when you purchase new equipment, your local retailer may be required to take back your old equipment free of charge. For more information, contact your retailer.

Business Users in the European Union, in accordance with European legislation, end of life electrical and electronic equipment subject to disposal must be managed within agreed procedures. If you discard electrical and electronic equipment, contact your dealer or supplier, local reseller or Xerox representative for end of life take-back information prior to disposal.

Improper handling of this type of waste can have a possible impact on the environment and human health due to potentially hazardous substances that are generally associated with EEE. Your cooperation in the correct disposal of this product will contribute to the effective usage of natural resources.

### Disposal Outside of the European Union

These symbols are only valid in the European Union. If you want to discard these items, please contact your local authorities or dealer and ask for the correct method of disposal.

## OTHER COUNTRIES

Contact your local waste management authority to request disposal guidance.



# Working With

This chapter contains:

- Start Up and Shut Down ..... 54
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- Stock and Feeders ..... 91
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- Maintenance ..... 160
- Finishing ..... 180
- Profiles ..... 236
- Job Workflows ..... 254

This section contains information on how to get started with your Production Press, common job workflows, procedures for maintaining the Production Press, and other operation information.

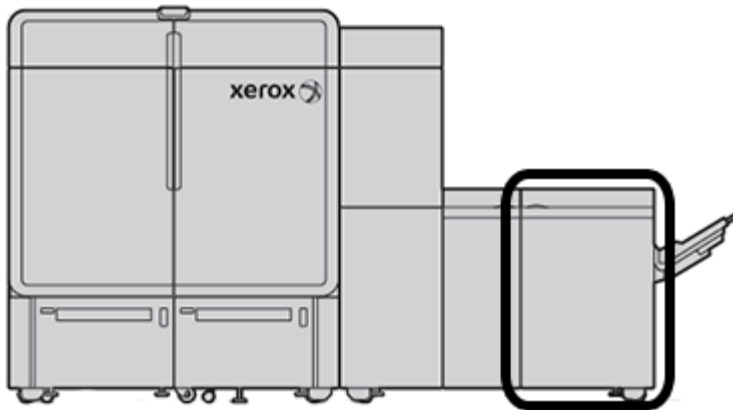
## Start Up and Shut Down

Start Up and Shut Down includes the procedures for powering on, logging in, restarting, and powering off the Production Press. It also includes information about user log-in levels and the Power Saver Mode.

### POWERING ON THE PRESS FOR THE FIRST TIME


If you are starting the Production Press for the first time, or after an emergency full system shutdown, perform the following procedure.


1. Open the right front door on the print engine right side.



2. Press the red Main Power Switch to the **On** position.



 Note: Unless there is cause to perform a full system shutdown, the red Main Power Switch remains in the On position.

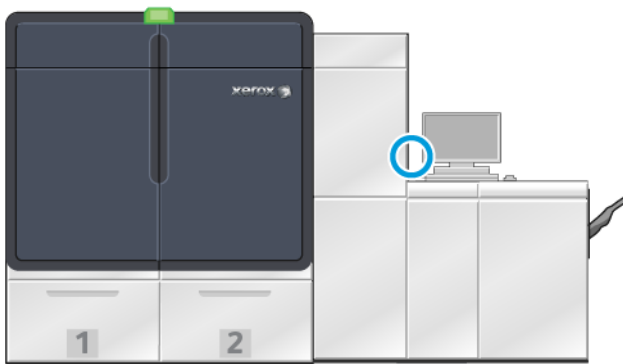
 Important: In an emergency, toggle this red Main Power Switch, also referred to as the Emergency Power Off Switch, to the Off position. This action immediately cuts electricity to all Production Press components. Use this method instead of the slower cycle-down process of using the Power Switch on the right side of the press.

- Continue to start up the entire press system. To power on the print engine, the Control Center PC, and the print server, refer to [Powering On the Production Press System](#).

## POWERING ON THE PRODUCTION PRESS SYSTEM

To power on the entire Production Press system:

- Ensure that the power switches on the feeders and stackers are in the **On** position.
- Ensure that all covers and doors on the press are closed tightly.
- To power on the Control Center interface, press the on/off button on the Control Center PC and monitor. Wait about 30 seconds until the PC software screen displays fully.
- Power on the Fiery print server workstation PC and monitor. If your print server has a touch screen device, the on/off button is on the touch screen.
- Locate the white Power Button on the right side of the Production Press near the Control Center. Press the Power Button to the **On** position.



- All of the system modules begin to initialize and the Fuser warms up. The Production Press runs a system check. The system check can take several minutes. During this time you can program the Production Press for a job. When the Production Press is ready, the printing process starts automatically.  
  
After a set number of idle time lapses, the Production Press automatically goes into Power Saver Mode. The Administrator sets this amount of time. When you operate the Control Center or send a job to the Production Press, the system automatically exits the Power Saver Mode.

### Power Saver

The Production Press automatically enters Power Saver Mode after a set amount of idle time. To change or set the amount of time to lapse before the system wakes up, you are required to be in Administrator mode. Log in as Administrator and access the System tab from the System Settings window.

To apply and use the power saver mode, from the System menu on the main window, select one of the following two Power Saver options:

- **Print Engine Only:** This option places only the Production Press print engine in power saver mode. The Control Center remains on.
- **Print Engine & System PC:** This option places both the Production Press and the Control Center in power saver mode.

When power saver mode is in effect, and the Control Center is not in power saver mode, the system shows the Power Saver icon on the Control Center main window.

To exit power saver mode:

- For the print engine only, from the System menu, select **Power Saver - Exit Print Engine Only**.



Note: The system also exits the power saver mode when you send a job to print or operate the Control Center.

- For the print engine and Control Center, click the Control Center mouse or touch some keys on the keyboard.

### Logging In and Logging Out

After you power on the Production Press system, the Control Center defaults to the Operator login level. If you are a basic operator and walk-up user, you do not need to log in to the system.



Note: Users who log in to the system have access to more functions. To learn which functions and areas of the system you can access when logged in as Administrator or Technical Key Operator, refer to [User Access Levels](#).

If you are an Administrator or Technical Key Operator, use the following steps to log in and log out:

1. Locate and click the **Log In** link in the upper right of the header bar on the main screen. A Login dialog opens.
2. Select **Administrator** or **Technical Key Operator** and type your password in the Password field. Click **OK**.



Note: The default Administrator password is 11111. As an administrator, you can change the password at any time.

The name of the new user, such as Administrator, appears in the link area on the title bar.

3. To log out and end your session, locate and click the User ID in the upper right of the header bar on the main screen. A dialog opens.
4. Select **Log Out**.

The User name on the title bar changes to the Log In link. The login access level returns to basic Operator.

### User Access Levels


The press defaults to the basic Operator access level. If you are a basic operator and walk-up user, you do not need to log in at the Control Center. An operator can access most functions and print jobs.

To access more functionality and administrator tasks, select the Log In link on the upper right of the main screen. From the Log In window, select the appropriate user access level and enter your password:


- **Administrator:** This level allows you to access the Maintenance menu for cleaning routines, customize system settings that affect productivity, restrict Operator access to the Stock Library, and work with Finishing Profiles.
- **Technical Key Operator:** This level is reserved for Xerox-certified users so that they can perform some maintenance activities normally done by a customer service engineer.



To print jobs and return to Operator mode, click the user name link in the upper right of the main screen and select **Log Out**.

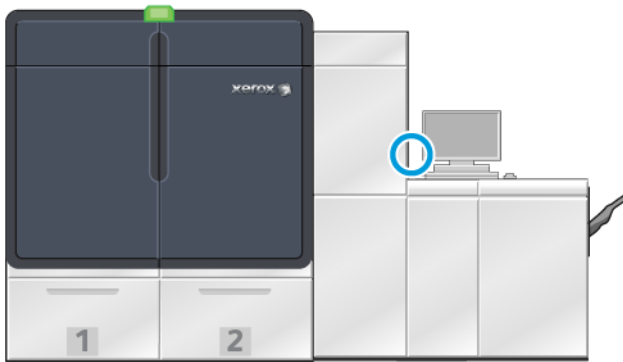
 Note: Refer to the Administrator area of the documentation for all of the functions available to the Administrator and Technical Key Operator.


## RESTARTING THE PRESS

 Note: Follow this procedure when the Control Center instructs you to restart the system. Attempt to resolve all declared faults or errors at the print server and at the Control Center.


You can either restart the entire Press System or the Control Center interface only.

1. To restart the print engine, all modules, and Control Center, press the white Power Button to the **Off** position.



 Note: Allow the Production Press to remain off for a minimum of 10 seconds.

- a. Press the white Power Button to the **On** position.

 Note: After powering off the Production Press, always restart the Control Center PC.

2. To restart the Control Center only, from the System menu, select **Restart User Interface**.
  - a. If a confirmation message appears, select **Yes**.
  - b. The system powers off and immediately restarts both the Control Center and user interface.

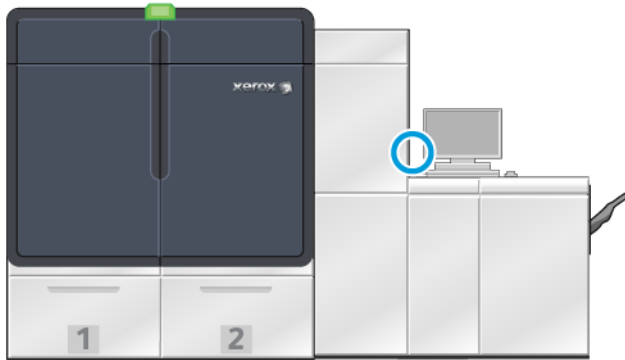
## POWERING OFF THE PRODUCTION PRESS SYSTEM

At the end of the day, it is recommended that you power off the entire Production Press system. There are two ways to shut down completely:


- Use the power on/off button on the print engine
- Use the System menu at the Control Center

1. Power off the Production Press using one of the following methods:

- To power off the Production Press using the **Power** button, at the print engine, press the white **Power** button to the Off position.



The press, all modules connected to the press, and the Control Center power off. After a set amount of time, the press automatically goes into power saver mode.

 Note: Allow the Production Press to remain off for a minimum of 10 seconds before switching the press back on.

- To power off the Production Press at the Control Center, from the System menu, select **Shut down System PC**.

The press, all modules connected to the press, and the Control Center power off. After a set amount of time, the press automatically goes into power saver mode.

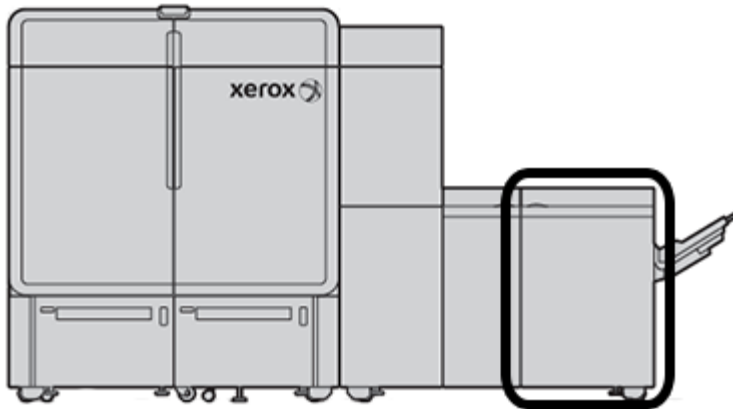
2. Power off the Fiery print server PC and monitor. If the touch screen device is installed, power off at the touch screen.
3. To restart the system, refer to [Restarting the Press](#)

 Note: After powering off the Production Press, always restart the Control Center PC.

### Powering Off the Press in an Emergency


To power off the Production Press immediately:

1. On the print engine right side, open the right front door.



2. Press the red Main Power Switch to the **Off** position.



 Important: This action immediately cuts electricity to all Production Press components. Use this method instead of the slower cycle-down process of using the Power Button on the right side of the press.

3. Disconnect the power cord from the electrical outlet.
4. Call an authorized Xerox service representative to correct the problem.

## DOWNLOADING AND UPGRADING THE PRESS SOFTWARE REMOTELY

When connected to the Internet, the press receives remote software upgrades for software version 6.0.4x or later. To download and upgrade the software remotely, do the following:

1. When a new software version is available, a warning appears on the status bar of the Control Center. To upgrade the software, click the warning icon. A window opens that shows the full warning message.

 Note: Before you initiate the software upgrade, close all active print jobs.

2. Follow the instructions that appear in the warning message. Open any front door of the press, then in the warning message window, click **Start**. A window with an End User License Agreement (EULA) appears.



Note: When a door of the press is opened, a window appears that instructs you to close the Transport Module and Output Module doors. To return to the software upgrade instructions, in this window, click **Close**.

3. The End User License Agreement is displayed in a language that is set by the administrator. You can change the language of the license agreement from the EULA menu, as needed. To run the software installation, in the End User License Agreement, click **Agree**.
4. For User Account Control, click **Accept**. The press enters diagnostic mode and the software installs. The Command Prompt windows show that the software installation is in progress.



Important: Do not close any of the Command Prompt windows during the installation process.

5. When the software upgrade completes, if there is no error, the Control Center restarts with the new software version, automatically.
6. After the Control Center restarts, make sure to power on the press. If the press does not power on after 1 minute, do the following:
  - a. Open the right door on the Press Transport Module.
  - b. Toggle the red switch to Off and wait for 10 seconds.
  - c. Toggle the red switch to On and close the door.
  - d. Power on the press from the usual external power switch.
7. To verify that your press is upgraded to the latest software, at the Control Center PC, click **System > Machine Details**, then view the System Software version.  
If there is an error, to complete the installation, contact a Xerox service representative.

## Stock Library Management

This section includes information on the PredictPrint Media Manager and the Manage Stock Library. You have access to either the PredictPrint Media Manager features or the Manage Stock Library features, depending on the software version that is installed on your press.

PredictPrint Media Manager includes all of the features of the Manage Stock Library. PredictPrint Media Manager builds on Manage Stock Library functionality with the addition of barcode scanning, PredictPrint Stock Wizard, and PredictPrint Cloud Server.

### PREDICTPRINT STOCK WIZARD

PredictPrint Stock Wizard uses a handheld barcode scanner and software applications to do the following:

- Program trays with specific stock properties for a job
- Perform print engine adjustments to optimize print performance for the stock
- Complete calibration and profiling for the stock, which provides maximum image quality and color output

When you open a paper tray or scan a barcode, the PredictPrint Stock Wizard opens and loads stock properties to a tray instantly. The Stock Wizard then provides simple step-by-step guidance through a series of automatic, semi-automatic, and manual setup routines for printing optimization. The Internet-based PredictPrint Cloud Server determines the setup routines that are recommended for the stock.

### PredictPrint Stock Wizard Overview

The PredictPrint Stock Wizard is a feature that automates media management for the digital presses. The Administrator can specify whether the PredictPrint Stock Wizard appears in the Control Center. For details, refer to [Managing Access to the PredictPrint Stock Wizard](#).

You can use the handheld barcode scanner to scan a media barcode as follows:

- Scan the barcode, then load the paper in the tray
- Load the paper in the tray, then scan the barcode

When you scan a barcode, the press connects to the PredictPrint Cloud Server and retrieves all the properties and recommended set points and setup routines for the scanned stock.

The PredictPrint Stock Wizard performs all of the advanced setup routines that are recommended to optimize print performance for each stock. When a stock is loaded for the first time, to maximize image quality and color output, the PredictPrint Stock Wizard runs a fully automated Calibration and Profiling process.

The PredictPrint Stock Wizard uses the following processes:


#### Scan

On the Scan page, you scan the barcode of a specific stock using a barcode scanner. When you scan the barcode, the PredictPrint Stock Wizard connects to the PredictPrint Cloud Server and downloads all the stock attributes, set points, and recommended setup routines for the stock.




## Define

If you have an unknown barcode or are creating a custom barcode, the Define screen appears. When you create a custom barcode or scan a barcode that is not listed in the PredictPrint Cloud Server, you are required to define the stock attributes manually.

 Note: The stock is defined only once. After you set up the stock, the data is stored on the PredictPrint Cloud Server. To obtain the data automatically, you can scan the associated barcode.

## Load

Load the stock in a paper tray. After you load the stock, on the Load screen, select the corresponding paper tray option: **Trays 1–2 or A1-1–A2-2, A2-3 (MSI), or T1.**

 Note: The available tray options are dependent on the configuration of your system. The options appear in accordance with the feeders and finishing devices that are attached to your press.

You can load the stock before or after you scan a barcode or define the stock properties. For multiple tray loading, you can load all trays or scan the barcodes in any order, as follows:

- If you scan the barcodes first: Scan all stock barcodes. To load the stock in the correct trays, follow the wizard screens.
- If you load the trays first: Load all stocks in the appropriate trays. To verify the barcodes for the loaded stocks, follow the wizard screens.

## Setup

On the Setup screen, you can confirm whether the stock properties are correct. You can select the paper feed orientation: Long Edge Feed or Short Edge Feed. On the Setup page, the PredictPrint Stock Wizard performs automatic set points and setup routines that are recommended for the stock. The automatic setup routines include:

- Tray Programming
- Alignment Setup: Basic Alignment Setup and Advanced Alignment Setup are automatic setup routines, but their parameters are set on the Automatic Adjustments tab.

- Basic Alignment runs when you scan the barcode for the first time. Basic Alignment does not run for subsequent barcode scans for the same stock. You can manage this setting on the PredictPrint Cloud Server.
- Advanced Alignment runs every time you scan the barcode for the stock. You can select the Print Density and Alignment Profile.
- Secondary Transfer Voltage Adjustment
- Calibration and Profiling



Note: Calibration and Profiling is the last routine to run and appears on the Setup screen only if there are no semi-automatic setup routines to run.

### Advanced

On the Advanced screen, the PredictPrint Stock Wizard performs semi-automatic setup routines that are recommended for the stock. The advanced setup routines include:

- Aligner Roll Pressure Adjustment
- Fusing Temp Adjustment Belt Side
- Fusing Temp Adjustment PRoll Side
- Tray Heater Adjustment
- Air Assist Adjustment
- Trail Edge Transfer Output Adjustment
- Calibration and Profiling

### Done

When the automatic and semi-automatic setup routines are complete, the Done screen shows a list of the manual setup routines that are recommended after you exit the PredictPrint Stock Wizard. You can complete the manual setup routines in the PredictPrint Stock Library. Manual setup routines include:

- Paper Curl Adjustment. For details, refer to [Correcting the Paper Curl](#).
- Multifeed Detection. For details, refer to [Multifeed Detection](#).

### Scanning a Media Barcode

A handheld barcode scanner is required for scanning barcodes.

1. To open the PredictPrint Stock Wizard, use one of the following methods:
  - On the Control Center screen, click **PredictPrint Stock Wizard**.
  - Scan the media barcode using the barcode scanner.
  - Load the stock in the appropriate tray.



When the PredictPrint Stock Wizard starts for the first time, a Welcome screen appears.

If the barcode is registered already in the PredictPrint Cloud Server, after you scan the barcode, the PredictPrint Stock Wizard displays the stock properties and the press automatically receives the settings for the best printing values for the stock.

If the barcode is not registered in the PredictPrint Cloud Server, on the Scan screen, click **Set Up As New Stock**. On the Define screen, set the properties for the stock, then click **Save and Next**.

2. If you did not load the media before you scanned the barcode, load the media into one or more paper trays, then click **Next**.

### Define a New Stock and Create a Barcode

When a stock does not have a barcode, you can create a barcode for the stock on the Define screen of the PredictPrint Stock Wizard. After you create the barcode, you can print the new barcode and retain it for scanning each time you load that stock.

To create a barcode for a new stock:

1. To open the PredictPrint Stock Wizard, use one of the following methods:
  - On the Control Center screen, click **PredictPrint Stock Wizard**.
  - Load the stock in the appropriate tray.

When the PredictPrint Stock Wizard starts for the first time, a Welcome screen appears.

2. Click **Define New Stock and Create Barcode**.

The Define screen appears.



3. Define the following items for your stock:
  - Name
  - Manufacturer
  - Size
  - Type
  - Modulus (if needed)
  - Preprinted Stock (required for stocks printing from T1)
  - Color
  - Coating
  - Grain
  - Weight
  - Hole Punched
4. To save the changes and go to the next step, click **Save and Next**.

### Loading Media with the PredictPrint Stock Wizard

To load your media in the paper tray:

1. Open a paper tray. Based on your media, select from Trays 1–2 or A1-1–A2-2, Tray A2–3 (MSI), or Inserter Tray T1.
2. Load the media, then close the paper tray.
3. On the PredictPrint Stock Wizard Load screen, select the tray that contains the loaded stock:
  - **Trays 1–2 or A1-1–A2-2**
  - **A2-3 (MSI)**
  - **T1**



Note: The available tray options are dependent on the configuration of your system. The options appear in accordance with the feeders and finishing devices that are attached to your press.

4. Click **Next**.  
The Setup screen appears. Continue to [Setting Up Media in the PredictPrint Stock Wizard](#).
5. At any time during the process, to change the information on the previous screen, click **Go Back**.


### Setting Up Media in the PredictPrint Stock Wizard


You can set up the media or stock in the PredictPrint Stock Wizard with or without a barcode. Refer to:


- [Setting Up Media with a Barcode](#)
- [Setting Up Media without a Barcode](#)
- [Setting Up Media with a Custom Barcode without Internet](#)

### Setting Up Media with a Barcode

1. On the PredictPrint Stock Wizard Setup screen, select the paper orientation:
  - **Long Edge Feed**
  - **Short Edge Feed**
2. Click **Next**.
3. The PredictPrint Stock Wizard performs the recommended automatic setup routines. After each routine, click **Accept and Next**. The automatic setup routines include:
  - Tray Programming
  - Alignment Setup
  - Secondary Transfer Voltage Adjustment
  - Calibration and Profiling: This automatic setup routine is performed after the semi-automatic adjustments, and before any manual adjustments. For more information, refer to [Calibration and Profiling](#).

 Note: It is important to remember that these setup routines and all of the other print engine adjustments are performed only if needed. If the PredictPrint Cloud Server intelligence determines that they are not needed, the PredictPrint Stock Wizard skips them.

 Note: Calibration and Profiling is the last routine to run and appears on the Setup screen only if there are no semi-automatic setup routines to run.
4. At any time during the process, to change the information on the previous screen, click **Go Back**.
5. At any time during the process, to cancel running the setup routines, click **Cancel Setup**.


 Note: The Cancel Setup option stops any remaining setup routines from running. Canceling setup routines does not cancel the assignment of the stock to the tray.
6. To go to the next routine, click **Accept and Next**.


### Setting Up Media without a Barcode

To get a barcode for the media, ensure that the tray is loaded with the stock for which you need a barcode.

1. On the Setup screen, select the paper orientation:
  - **Long Edge Feed**
  - **Short Edge Feed**
2. Click **Next**.

A barcode appears on the next screen.
3. To print the barcode, click **Print Barcode**.

 Note: To print a barcode, load Letter or A4 size paper in any tray other than the one you are currently programming with the stock. If no Letter or A4 size paper is loaded in the press, you cannot print the barcode during the setup process in the wizard.

 Note: Keep the printed barcode for scanning when you load the same stock in the future.

4. Click **Accept and Next**.

The PredictPrint Stock Wizard starts a series of recommended automatic setup routines. The automatic setup routines include:

- Tray Programming
- Alignment Setup
- Secondary Transfer Voltage Adjustment
- Calibration and Profiling: This automatic setup is performed after the semi-automatic adjustments and before any manual adjustments.



Note: It is important to remember that these setup routines and all of the other print engine adjustments are performed only if needed. If the PredictPrint Cloud Server intelligence determines that they are not needed, the PredictPrint Stock Wizard skips them.

5. After each routine completes, click **Accept and Next**.

6. At any time during the process, to change the information on the previous screen, click **Go Back**.

7. At any time during the process, to cancel running the setup routines, click **Cancel Setup**.



Note: The Cancel Setup option stops any remaining setup routines from running. Canceling setup routines does not cancel the assignment of the stock to the tray.

8. To go to the next routine, click **Accept and Next**.

#### Setting Up Media with a Custom Barcode without Internet

When the stock does not have a barcode and the press is not connected to the Internet, the PredictPrint Stock Wizard cannot communicate with the PredictPrint Cloud Server to generate a barcode. Before you proceed to generate a custom barcode, ensure that you have a portable USB storage device.



Note: If the press is not connected to the Internet, you can download the Stock Lists from the PredictPrint Cloud Server. To download the Stock Lists from the PredictPrint Cloud Server, refer to [Downloading a Stock List](#).

1. On the PredictPrint Stock Wizard Setup screen, select the paper orientation:

- **Long Edge Feed**
- **Short Edge Feed**

2. Click **Next**.

3. To obtain a barcode and complete the stock setup, insert a USB storage device into a USB port on the press. Click **Copy Stock File**.

4. Save the stock file on the USB storage device.

5. From a browser on an Internet-connected device, go to <https://www.xerox.com/predictprintmedia>. Click **Get New Barcode**.


6. Upload the stock file from the USB storage device to the PredictPrint Cloud Server. The PredictPrint Cloud Server generates a new barcode with stock setup routines. Save the setup and barcode information on the USB storage device.


7. Ensure that the tray is loaded with the stock for which you need a barcode.

8. Insert the USB storage device into a USB port on the press. On the PredictPrint Stock Wizard Setup screen, click **Load Barcode File**.
9. From the USB storage device, copy the file with the stock setup routines and barcode information to the PredictPrint Stock Wizard. Click **Next**.

A barcode appears on the next screen.

10. To print the barcode, click **Print Barcode**.

 Note: To print a barcode, load Letter or A4 size paper in any tray other than the one you are currently programming with the stock. If you do not have Letter or A4 size paper loaded in the press, you cannot print the barcode during the setup process in the wizard.

 Note: Keep the printed barcode for scanning when loading the same stock in the future.

11. Click **Accept and Next**.


The PredictPrint Stock Wizard starts the series of recommended automatic setup routines.

### Advanced Stock Setup


On the Advanced screen, the PredictPrint Stock Wizard guides you through a series of advanced settings that include semi-automatic and automatic setup routines.

For any semi-automatic routine, you can print a sample, inspect the sample, and make adjustments, if needed. The semi-automatic setup routines include:


- Aligner Roll Pressure Adjustment
- Fusing Temp Adjustment Belt Side
- Fusing Temp Adjustment PRoll Side
- Tray Heater Adjustment
- Air Assist Adjustment
- Trail Edge Transfer Output Adjustment
- Calibration and Profiling

 Note: Calibration and Profiling is the last routine to run and appears on the Setup screen only if there are no semi-automatic setup routines to run.

1. To view the instructions about adjusting a specific semi-automatic setup routine, click **Get Instructions**. For details, refer to [Creating or Modifying Advanced Stock Setup Options](#).
2. To verify the printed output, click **Print Sample**. Make adjustments to the setup as needed.
3. After each semi-automatic setup routine, to perform the next routine, click **Accept and Next**.

 Note: It is important to remember that these setup routines and all of the other print engine adjustments are performed only if needed. If the PredictPrint Cloud Server intelligence determines that they are not needed, the PredictPrint Stock Wizard skips them.

4. At any time during the process, to cancel running the setup routines, click **Cancel Setup**.

 Note: Cancel Setup stops any remaining setup routines from running. Cancel Setup does not cancel the assignment of the stock to the tray.

5. To go to the previous setup routine, click **Go Back**.

### Calibration and Profiling

Color Calibration and Profiling is a fully automated process within the PredictPrint Stock Wizard. The Stock Wizard hands off the stock information to the Fiery® Print Server to initiate the process. Calibration and Profiling is performed after all other adjustments are completed.

The need for Calibration and Profiling is first determined by the PredictPrint Cloud Server based on the stock properties, then performed and managed by the Fiery Print Server. The Calibration and Profiling process uses the Full Width Array. Each individual stock is first calibrated and then profiled. Profiling each stock is performed once. Recalibration is performed after the set time limit has expired for the stock-barcode, and it is scanned again to load the stock into a tray. The calibration process takes about 60 sheets for the first time the stock is added, then about 18 sheets for each recalibration.

With the new Fiery® Print Server version 4.0, FS600, the Calibration and Profiling process is streamlined and enhanced further, as follows:

1. By using the **Group Adjustments By** feature, the print server can group stocks with common **Coating or Media Name** when the stock passes a new Color Check routine. The first passing stock only requires 9 sheets to be calibrated, followed by 4 sheets for the Color Check routine. If successful, any additional stock added for calibration requires only 4 sheets.
2. If you decide to maintain **Individual Stock** as the method for Calibration and Profiling, then the process requires about 30 sheets the first time the stock is added, then 9 sheets for each recalibration.
3. A Color Check routine is performed prior to recalibration, when needed. If the stock passes the routine, no further sheet printing is required, and the calibration expiration time limit is extended.



Note: The Calibration and Profiling process is enhanced on Fiery® Print Server version 4.0, FS600 or newer versions. To find your print server version or Fiery System version, on the Fiery Command WorkStation window, go to **Server > Device Center > GENERAL > General Info**, then refer to **Fiery Server** or **Fiery System**. This information is accessible also on the Fiery configuration page, printed through Fiery® Print Server.

The default time limit for recalibration is 7 days. From the print server, you can change the default 7-day time setting for calibration. On the Fiery Print Server Device Center, click **General > Tools > Calibrator**, then click the small gear icon at the bottom of the page.

Calibration and Profiling proceeds as follows:

1. On the Advanced screen, after the semi-automatic setup routines are complete, the PredictPrint Stock Wizard starts the Calibration and Profiling process automatically.



Note: If there are no semi-automatic setup routines to run, the Calibration and Profiling process is done on the Setup screen.

2. The PredictPrint Stock Wizard coordinates with the Fiery Print Server. The Color Profiling and Calibration Check are done automatically.
3. You can cancel the Calibration and Profiling process. In the PredictPrint Stock Wizard, click **Cancel**.
4. After the Calibration and Profiling process completes, the Done and Close screen appears.

If needed, you can perform other Calibration and Profiling procedures outside of the PredictPrint Stock Wizard using the **Fiery Calibrator** on the Fiery Print Server. For more information, refer to the Fiery Print Server documentation at

Fiery - Xerox Iridesse Production Press.

## Manual Stock Setup

After the Advanced semi-automatic and automatic setup routines are complete, the PredictPrint Stock Wizard displays the list of manual setup routines that are recommended. To make the manual adjustments, go to Advanced Setup for the stock in the PredictPrint Stock Library.

Manual setup routines are performed last. Manual setup routines include:

- Paper Curl Adjustment
  - Multifeed Detection
1. After the Calibration and Profiling process has completed, to exit the PredictPrint Stock Wizard, click **Done and Close**.

The main Control Center screen appears that shows all of the trays and the respective properties for the stock loaded into each tray. A yellow triangle icon appears on the tray that is loaded with the stock that you are setting up.

2. To view the list of recommended manual setup routines, on the main Control Center screen, for the tray loaded with the stock for which you want to run manual setup routines, hover the cursor over the yellow triangle icon.

The list of recommended manual setup routines appears.

3. Perform the manual setup routines in the Stock Library. To open the Stock Library, on the main Control Center screen, click **PredictPrint Stock Library**. In the Stock Library list, select the stock that requires the manual setup routines. To access the stock properties, on the Stock Library menu bar, click the pencil icon for Edit. To access the manual adjustments, click **Advanced Setup**.



Note: For details on how to perform the manual setup routines, refer to [Creating or Modifying Advanced Stock Setup Options](#).

## PREDICTPRINT CLOUD SERVER

The PredictPrint Cloud Server stores and downloads the stock data to the PredictPrint Stock Library, including recommended setup routines and setpoints based on Cloud Server analysis at the time a barcode is scanned.

### Downloading a Stock List

If your press is connected to the Internet, every time the corresponding barcode is scanned, the stock information updates on your system automatically. There is no need to download any stock lists to your system.

If your system does not have access to the Internet, you can download the Stock Lists from <https://www.xerox.com/predictprintmedia>.

1. Go to <https://www.xerox.com/predictprintmedia>.
2. Select **Download Stock List**.

The Download Stock List page appears.

3. Select an option:
  - To download the entire stock list, click **Download Full Stock & Media List**.
  - To download the Recommended Media List (RML), click **Download Recommended Media List**.
  - To download the Tested Substrate List, click **Download Tested Media List**.
4. Select **Xerox IRIDESSE Production Press**, then click **OK**.
5. In the Save As window, select a location for the Stock List file, then click **Save**.  
The file downloads to your computer.
6. Extract the .xml file from the .zip file.
7. Insert a USB drive into a USB port on the computer and copy the .xml file to the USB drive.

For details on how to load the stock lists into the Stock Library, refer to [Load PredictPrint Database from Device](#). This procedure requires that you are logged in as Administrator.

## PREDICTPRINT STOCK LIBRARY

The PredictPrint Stock Library window on the Control Center enables you to create and manage a library of frequently used stocks. Operators or Administrators can define attributes for a stock, such as size, color, type, and weight, and can assign the stock to a paper tray.

The Administrator allows or restricts access to the PredictPrint Stock Library. If access to the PredictPrint Stock Library is restricted, the PredictPrint Stock Library button does not appear on the main Control Center screen and Operators cannot edit or delete stocks from the Stock Library.



Note: If the PredictPrint Stock Library button does not appear in the Control Center, for more information, contact your administrator.

### PredictPrint Stock Library Window

The PredictPrint Stock Library window displays the All Media list at the top of the window and the Stock Library list is at the bottom. All Media is a read-only list. When you select a stock, the following actions are available:

- **Reset to System Default:** Returns the PredictPrint Stock Library view to its original layout.
- **View:** Allows you to view the properties of stocks listed in the Stock Library list. You cannot edit or change the stock name. You can view the properties of a stock, but you cannot edit the properties of the stock.
- **Edit:** Allows you to modify the properties of a stock in the Stock Library.
- **Create New:** Allows you to create and save a new stock to the Stock Library list. This option opens the PredictPrint Stock Wizard, if enabled.
- **Copy:** Allows you to copy an existing stock from either the RML or the Stock Library list, edit the stock properties, and save it to the Stock Library as a new stock.
- **Delete:** Allows you to delete, or remove, a stock from the Stock Library list.
- **Print Barcode:** Allows you to print a custom barcode.
- **Add to Stock Library:** Allows you to add a stock from the RML to the Stock Library list.
- **Sorting:** Select either **Use Columns** or **Sort Manually**.

- **Move to Top** or **Move to Bottom** icons: Allow you to move a stock up or down in the Stock Library list.
- **Close**: Exits the PredictPrint Stock Library window.

### Stock Lists

The Stock Lists are Xerox-supplied lists of stocks for the Production Press. If your system is connected to the Internet, there is no need to download any Stock Lists or information manually. All stock information is automatically downloaded and updated to the Stock Library every time you scan the barcode for the stock. If your system is not connected to the Internet, you can download the Stock Lists from <https://www.xerox.com/predictprintmedia>. The Stock Lists that are downloaded and loaded manually appear in the All Media list on the PredictPrint Stock Library window after you scan a barcode.

The downloaded Stock Lists are read-only lists. You cannot add, delete, or edit the stocks directly. From the Stock Lists, you can:

- Copy a stock to the Stock Library
- Copy and edit a stock before moving it to the Stock Library
- View the properties of a stock
- Assign a stock to a paper tray

There are three Stock Lists:

- All Media
- Recommended Media List (RML)
- Tested Substrate List (TSL)

You can update all of the media lists to include new papers, updated set points, and recommended setup routines as determined by the PredictPrint Cloud Server intelligence.

To view specific stocks recommended for the Production Press, always refer to the Recommended Media List. The Recommended Media List is updated as required to include new papers and other media.

### Stock Ratings

You can set your own valuation for stocks. My Ratings values are retained locally on the press.

To set the rating for a stock, in the My Ratings column, click one of the five stars.

## MANAGE STOCK LIBRARY

The Manage Stock Library screen is where you identify the media used by the Production Press and manage the media attributes, such as type, weight, and name.

You can assign each media in the Stock Library to one or more feeder trays. Each feeder tray is programmed to feed one specific media. Then, the Production Press can select media from one or more trays to match the requirements of the job.

For information on how to manage media in the Stock Library, refer to:

- [Manage Stock Library](#)
- [Backing Up and Transferring the Stock Library](#)



- [Recommended Media List \(RML\)](#)
- [Adding a Media Entry](#)
- [Creating a New Stock From Tray Properties](#)
- [Creating a New Stock From Manage Stock Library](#)
- [Editing an Existing Stock in the Stock Library](#)
- [Removing a Stock From the Stock Library](#)

### Backing Up and Transferring the Stock Library



Note: To protect data on the Iridesse Production Press, it is important to back up the entire Stock Library regularly. The best way to copy and create a Stock Library backup is by using a USB flash drive.

Perform the following procedure to back up all Stock Library files and, if needed, transfer those files to another Iridesse Production Press.

1. At the Control Center, insert a USB flash drive into a USB port.
2. At the Control Center, select and open the Profiles shortcut on the desktop.
3. Locate and open the Stock folder.

The stock files are stored in this folder and the .stock extension distinguishes them.

4. Select all the files in the stock directory with the .stock extension.
5. Select **Edit > Copy** or **Ctrl > C**.
6. Open the USB flash drive directory.
7. Select **Edit > Paste** or **Ctrl > V**.

The system copies the files onto the USB flash drive.

8. Close both directories.
9. From the Control Center, remove the USB flash drive.

Keep the Stock Library backup files in a safe location, such as on the flash drive or another portable device. The .stock files can remain on the USB flash drive as a backup copy.

10. To use the same Stock Library on two co-located Production Presses, use the flash drive to transfer or copy the Stock Library backup files to another Production Press.

### Manage Stock Library

The Manage Stock Library window on the Control Center enables you to create and manage a library of frequently used stocks. Operators or administrators can define attributes for a stock, such as size, color, type, and weight, and assign the stock to a paper tray.

The administrator allows or restricts access to the Stock Library. If access is restricted, the Manage Stock Library button does not display on the main Control Center window and operators cannot edit or delete stocks from the library.



Note: If the Manage Stock Library button is not displayed under the Function menu on the main window, contact your administrator for more information.

To open the Manage Stock Library window, select the **Manage Stock Library** button. The Manage Stock Library window contains the Recommended Media List (RML) and the Stock Library list:

- **Recommended Media List (RML):** The RML is a Xerox-supplied list of recommended stocks for the Production Press. From this list, you can assign stocks to trays or add them to the Stock Library.
- **Stock Library:** Much like the RML, this list contains the names of all the stocks that are available for the Production Press. Unlike the RML, this list contains stocks that either the user created or was copied or edited from the Recommended Media List. From this list, you can select a stock for any paper tray for printing easily.

### Manage Stock Library Window

The Manage Stock Library window displays the Recommended Media List (RML) at the top of the window and the Stock Library list at the bottom. The RML is a read-only list. You can select a stock from either location and assign that stock to a paper tray. When you select a stock, the following actions are available:

- **Default Layout:** Returns the Manage Stock Library view to its original layout.
- **Properties:** Allows you to view the properties of stocks listed in the Stock Library list. You cannot edit or change the stock name. You can only view the properties of a stock in the RML. The properties cannot be changed.
- **Create New:** Allows you to create and save a new stock to the Stock Library list.
- **Copy:** Allows you to copy an existing stock from either the RML or the Stock Library list, edit the stock properties, and save it to the Stock Library as a new stock.
- **Delete:** Allows you to delete, or remove, a stock from the Stock Library list.
- **Add to Stock Library:** Allows you to add a stock from the RML to the Stock Library list.
- **Sorting:** Select either **Use Columns** or **Sort Manually**.
- **Move to Top** or **Move to Bottom** buttons: Moves a stock up or down in the Stock Library list.
- **Close:** Closes the window and exits the Manage Stock Library window.

### Recommended Media List (RML)

The Recommended Media List (RML) is a Xerox-supplied list of recommended stocks for the Production Press. You can download it from [www.xerox.com/IRIDESSEsupport](http://www.xerox.com/IRIDESSEsupport). It appears above the Stock Library list on the Manage Stock Library window.

The RML is a read-only list. You cannot add, delete, or edit the stocks directly. From the Recommended Media List, you can:

- Copy a stock to the Stock Library
- Copy and edit a stock before moving it to the Stock Library
- View the properties of a stock
- Assign an RML stock to paper trays

To view specific stocks recommended for the Production Press, always refer to the Recommended Media List. The Recommended Media List is updated as required to include new papers and other media.

### Applying a New Stock List



Note: If you have the latest software release, the Recommended Media List (RML) is updated on your system automatically.

If the RML file exists on xerox.com, you can apply a new Stock List:

1. Go to [www.xerox.com/IRIDESSEsupport](http://www.xerox.com/IRIDESSEsupport).
2. Select **Customer Support > All Support and Drivers**.  
The Support & Drivers page appears.
3. In the Search field, type `Xerox Iridesse Production Press`.
4. Press **Enter**.  
The Search Results page appears.
5. Click **Xerox Iridesse Production Press.rml**.  
A message appears asking if you want to download the file.
6. Click **Yes**.  
The file downloads to your computer.
7. On the desktop, double-click the **Profiles** folder.  
A list of folders appears.
8. Double-click the **rml** folder.
9. From the rml folder, click **Xerox Iridesse Production Press.rml**.  
The Replace or Skip Files dialog box appears.
10. Click **Replace the file in the destination**.  
The Stock List is updated.

### Media Management

From the Manage Stock Library window, you can reference a media type that is defined, named, and saved as new media easily. You can select and assign saved media to a paper tray for printing quickly.

You can perform the following tasks from the Manage Stock Library window:

- Add or copy media directly from the RML to the Stock Library
- Copy RML media to the Stock Library and edit it so that the new entry in the Stock Library has different properties from the RML listing
- After copying to create a stock in the library, copy the existing media in the Stock Library and edit the media properties
- To reflect what is used on the Production Press, edit an existing media entry
- Create and save new media. You can create media in one of two ways:
  - From Manage Stock Library
  - From Tray Properties

- Delete a media entry
- Change the order of the media by moving media up or down in the Stock Library list

### Creating a New Stock From Manage Stock Library

1. If needed, at the Control Center, click **Log In** and log in as the Administrator.
2. From the Function menu, select the **Manage Stock Library** button.  
The Manage Stock Library window appears.
3. Click the **Add (+)** button.  
The New Stock Setup window appears.
4. To create the stock, enter a new stock name and enter the stock properties as needed.
5. Select **OK**.  
The Production Press adds the stock to the bottom of the Stock Library list.
6. To move the stock toward the front of the list, select the sort **Manually** button, then the up arrow.
7. To exit the Manage Stock Library, select **Close**.

### Adding a Media Entry

When you add media to the Stock Library from the Manage Stock Library window, use the following procedure.



Note: You can add only pre-existing media from the RML to the Stock Library.

1. From the Control Center, click **Log In** and log in as the Administrator.
2. From the Function menu, select the **Manage Stock Library** button.  
The Manage Stock Library window appears.
3. From the Recommended Media List, click the stock you want to edit or add to the Stock Library.
4. Select the **Add to Stock Library** button.
5. If needed, to create the stock, enter a new stock name and change the properties.
6. Select **OK**.  
The stock is added to the bottom of the Stock Library List. The original remains in the RML.
7. To move the media within the Stock Library List, use the **Up** or **Down** arrows.
8. To exit the Manage Stock Library, select **Close**.

### Copying a Stock Entry

Sometimes an existing stock entry, either from the RML or the Stock Library list, already contains most of the attributes required for a new stock entry. In this case, to create a stock entry, the user simply copies an existing stock and modifies its attributes.

1. If needed, from the Control Center, click **Log In** and log in as the Administrator.
2. From the Function menu, select the **Manage Stock Library** button.  
The Manage Stock Library window appears.

3. From either the Recommended Media List or the Stock Library list, select the stock that you want to copy.
4. For the Stock Library or RML, select the **Copy (+)** icon.
5. Enter a new stock name. If needed, change any of the stock attributes.
6. Select **OK**.

The Production Press adds the stock to the bottom of the Stock Library list. The original stock remains in the list.

7. To move the stock within the Stock Library List, select sort **Manually** and use the **Up** and **Down** arrows.
8. To exit the Manage Stock Library, select **Close**.

### Editing an Existing Stock in the Stock Library

To edit an existing stock in the Stock Library, use the following procedure.

1. If needed, from the Control Center, click **Log In** and log in as the Administrator.
2. From the Function menu, select the **Manage Stock Library** button.

The Manage Stock Library window appears.

3. From the Stock Library List, select the stock you want to edit.
4. To edit the properties, click the pencil icon for Edit.

The Stock Properties window appears.

5. As needed, modify the stock attributes.
6. To save the changes to the stock and close the window, select **OK**.
7. To exit the Manage Stock Library, select **Close**.

### Removing a Stock From the Stock Library

To remove a stock from the Stock Library list, use the following procedure.

1. If needed, from the Control Center, click **Log In** and log in as the Administrator.
2. From the Function menu, select the **Manage Stock Library** button.

The Manage Stock Library window appears.

3. From the Stock Library List, select the stock you want to remove from the library.
4. Click the Trash Can icon.

A confirmation window appears.

5. To delete the stock from the Stock Library, select **Yes**.
6. To exit the Manage Stock Library window, select **Close**.

### Tray Properties

From the Tray Properties window, you can view and select various functions for the paper tray.

- **Stock Details:** This area displays the current tray information, including the paper Size, Type, Coating, Modulus, Hole Punch, Color, Weight, and Grain.

- Long Edge Feed/Short Edge Feed (LEF/SEF): Indicates the orientation direction that the paper is loaded in the tray: either in the LEF or SEF direction.
- Enable Tray: Permits the selected tray to be used for printing.
- Disable Tray: Prohibits the selected tray to be used for printing.
- Override:
  - If the current media loaded in the tray does not match the media information displayed on the Tray Properties window, when you clear this selection, the Production Press displays a message. Load the tray with the same media as indicated on the Tray Properties window.
  - If selected, a job can run without errors when certain stock properties in the job do not match the tray properties.
- Display Tray Properties automatically when Tray is open: When selected, when the tray is open, the Tray Properties window always opens.
- **Stock Library**: This option opens the Manage Stock Library window, which contains the names of all the paper stocks that were either created, copied, or edited from the Recommended Media List (RML). You select a desired stock from the list, and that stock is assigned to the tray.
- **Recommended Media List (RML)**: Provides a list of all the recommended stocks that are available for the Production Press. You can select a stock from the RML to assign temporarily to the tray. After the Tray Properties window is closed, the stock name appears in blue italics, indicating that it is a temporary stock. When you select a different stock, the stock is deleted.
- **Create New Stock**: Allows you to create a stock that is assigned to the tray. This stock can be saved permanently to the stock library, or it can remain as a temporary stock.
- **Alignment Profile**: Allows you to keep the system default profile or, from this button, select a specific profile that was created and saved using the Profiles feature.

### Tray Stock Mismatch

If the paper loaded in a tray does not match the information on the Tray Properties window, the Control Center alerts you by displaying a Tray Stock Mismatch message.



Note: This functionality is available only if the Administrator enabled it from the System Settings window.

If you receive this message, do either step 1 or step 2:

1. Load the stock indicated on the Tray Stock Mismatch window.
2. Change the Tray Properties to match the contents of the tray.
  - a. Verify the paper size, type, coated or uncoated, and weight of the paper loaded in the tray.
  - b. Enter that information on the Tray Properties window.

### Creating a New Stock From Tray Properties

1. Load the new stock to a paper tray.

2. Close the paper tray fully.

At the Control Center, the Tray Stock Properties window opens. If not, you can double-click on the tray number displayed on the press mimic.

The Tray Properties window for that tray opens.

3. Click the **Create New Stock** button.
4. Accept the default for the Stock Name or enter a new name.
5. Enter or select the stock properties for Size, Type, Coating, Color, Weight, and Grain.
6. To save this stock in the Stock Library permanently for future use, check the Save in Stock Library check box. Otherwise, the stock is temporary.
7. If needed, to make further specific stock property settings for the job, select the **Advanced Setup** button.
8. To save and close the New Stock Setup window, select **OK**.
9. To close the Tray Stock Properties window, select **OK**.

The new stock is shown in the list.

### Advanced Stock Setup

The **Advanced Stock Setup** feature allows you to adjust the Production Press settings for special stocks, beyond size, weight, type, and other characteristics. To achieve the best image quality on the stock, these additional settings are applied to the job automatically.



Tip: Access the **Advanced Stock Setup** feature from either the Stock Properties window or the New Stock Setup window.

The **Advanced Stock Setup** feature allows you to:

- Adjust fusing and paper transport settings
- Correct for output prints that are skewed, curled, or have too much dry ink/toner or not enough dry ink/toner in areas
- Correct for images that are not registered properly on the output print, such as Side 1 or Side 2 images that are misregistered

To ensure optimum output quality of your jobs, you can use these custom stocks where needed. The stocks can be either temporary stocks for a specific, one-time job, or a permanent stock added to the Stock Library list.




Note: Once a custom stock is created, either temporarily or permanently, the Production Press passes this information on to your print server. The print server then reflects this information in the print options for the print jobs.

### Tips for Using Advanced Stock Setup Options

Before using any of the Advanced Stock Setup options, refer to the following information:

- It is recommended that you adjust and test only one option at a time. This practice helps you determine if that option is providing the best printed output before changing other parameters.

 Important: It is recommended that you run test prints after selecting each Advanced Stock option. This practice allows you to evaluate the printed output and determine if it is acceptable or not.

- If you determine that the output is unacceptable, further adjust the value for an option, if applicable, or return the option to its default value and continue to the next option.
- It is important to remember that any settings for a particular option that are used today for a specific print job can achieve different results when used on a different day for that same print job. If the room where the Production Press is located experiences changes in temperature and humidity, this condition is especially relevant.
- If you determine that your output still is unacceptable after repeating this process several times, contact your Customer Support Center for assistance.

### Applying a Profile to a Stock

To apply existing profiles to your job for Alignment, Fold Adjustment, and Air Assist, access the Advanced Stock Setup window. Perform the following procedure.

1. From the main window on the Control Center, select the **Manage Stock Library** button.  
The Manage Stock Library window appears.
2. Select the specific media to which you want to apply the profile.
3. Click the **Edit** icon.
4. On the Stock Properties window, click the **Advanced Setup** button.  
The Advanced Stock Setup window appears.
5. Click in the **Tray Air Assist** field. This field can have a System Default entry, or another profile listed.
6. Click in the **Fold Adjustment Profile** field. This field can have a System Default entry, or another profile listed.
7. Click in the **Alignment File Name** field. This field can have a System Default entry, or another profile listed.
8. Select other options on this window that you want to apply to this stock.
9. To save and close the Advanced Stock Setup window, click **OK**.
10. On the Stock Properties window, click **OK**.

### Creating or Modifying Advanced Stock Setup Options

To select the various Advanced Stock Setup options for a new stock entry or for an existing stock entry, use the following procedure.

1. From the Function menu on the Control Center, select the **Manage Stock Library** button.  
The Manage Stock Library window appears.
2. Select the stock to which you want to apply the advanced setup options.
3. To modify an existing stock, click the **Edit** icon. Or, to create a stock, click the **Add** icon.  
The Stock Properties window appears.
4. From the Stock Properties window, select the attributes for the stock. For a new stock, enter the stock name.
5. Select the **Advanced Setup** button.  
The Advanced Stock Setup window appears.



6. Select the various options as required, such as:

- Stock By Name Only
- Multifeed Detection
- Fuser Temperature
- Near Empty Detection Level
- Aligner Roll Pressure
- Tray Air Assist
- Fold Adjustment Profile



Note: This option is available only if the optional finisher is attached to your Production Press.

7. To close the Advanced Stock Setup window, select **OK**.

8. To save and close the Stock Properties window, select **OK**.

9. To exit the Manage Stock Library window, select **Close**.

### Stock By Name Only

When this option is checked, the Production Press selects loaded stocks for a print job using just the Stock Name instead of Stock Type, Size, Weight, and other media attributes. The option turns off the automatic selection of a stock by matching a job with the properties and requires that you select the stock by its name. This function is useful for preventing expensive or specialty stocks from being used unintentionally.

When this option is not checked, stocks are selected from the print server or from a print driver by matching attributes, such as weight. Stock names are also examined, but are not used exclusively.

### Multifeed Detection

For the Production Press to detect and report misfeeds when multiple sheets are fed from the paper trays, check this option. This option allows the job to continue running, pulling both stocks from the same tray for the same job, and completes the print job without faults or jams.

When this option is not checked, the Production Press ignores any multiple sheets that feed through the paper path. Clear this option only as a temporary measure to allow users to continue their printing until a service representative resolves the problem. Leave this option on unless the sensor reports misfeeds that do not actually occur.

### Fuser Temperature Adjustment

Under most conditions, the fuser temperature is adjusted automatically as needed. However, it can be necessary to adjust the fuser temperature to improve fusing performance in the following situations.

- Depending on the paper type and image type, for more paper curl improvement when the Decurler adjustment is not sufficient, increase or decrease the temperature. For example, lighter weight papers and high-area coverage typically need lower temperatures than heavyweight stock. Adjust the settings in increments of 5 degrees.
- With some paper stocks, like coated stocks, lowering the temperature can decrease a slightly higher gloss on the lead edge as the sheet enters the fuser. Try lowering the temperature by 5 degree increments.

- On some stocks, like coated stocks, areas of dry ink/toner transitioning from no dry ink/toner or low dry ink/toner coverage to high areas coverage can cause what looks like rain drops in the high area coverage due to moisture in the paper. Try lowering the temperature by 5 degree increments.
- On some stocks, dry ink/toner flaking can occur due to paper stock and image type. Overall fusing performance can improve by either lowering or raising the temperature. Try to increase the temperature by 5 degrees first, and if there is no change, try to lower the setting by 5 degrees.

### Setting a Higher Fuser Temperature

Using a higher temperature for the fuser can improve the adhesion of dry ink/toner to stock. Depending on the paper type and weight, it can be necessary to increase or decrease the fuser belt temperature. You can use the plus or minus icons to adjust the fuser temperature from -20 degrees to +30 degrees.

To improve lead-edge uniformity or toner coverage on lightweight papers, use the Belt Side adjustment feature.

To improve gloss streaks from the pressure roll stripper fingers, use the Pressure Roll Side feature and increase or decrease the value in 5 degree increments to find the optimal temperature.


 Important: Running the fuser at the higher temperature can decrease the life of the fuser assembly.

### Aligner Roll Pressure

Use this option with special paper types that slip or skew, causing image misregistration on the printed output. To avoid edge damage to the printed output, you can also use this feature with some lightweight or heavyweight stocks that require more or less roll pressure.

You can increase or decrease the pressure applied to sheets independently for Side 1 and for Side 2. Note the following:

- The default setting is 0. It is best that you leave this option at its default setting until you run test prints and evaluate the output of the prints.
- Adjust Side 2 when there is a difference in image density between Side 1 and Side 2. If Side 1 is up when a jam occurs, adjust only Side 1. If Side 2 of the sheet is facing up, adjust only Side 2.
- Some coated, heavier stock types slip and skew, misregistering the image on the output prints. To compensate for the slippage and skewing, increase the roll pressure.
- Some lightweight stocks can have too much roll pressure applied to them resulting in edge damage to the output prints. If edge damage occurs, decrease the roll pressure.

 Important: Because environmental conditions vary from day to day, only make temporary changes to the default setting. When you complete the print job, return the option to its default setting.

### Transfer Output Adjustment for Trail Edge

To improve or resolve defects along the trail edge of the image on the sheet, use this option. This adjustment is for only the trail edge area. It raises or lowers the transfer voltage to the Second Bias Transfer Belt where the image is transferred from the belt to the paper. To improve the image, increase or lower the setting in 10% increments.

If you use this adjustment and it does not work, the problem can be trail-edge flip. Trail-edge flip can occur with heavier-weight paper. When the paper leaves the transfer area, the trail end of the paper can flip and can disturb the image before it gets fused. If you experience the trail-edge defects on heavyweight stock, and think that it is trail-edge flip, contact Xerox support.

## Second (2nd) Bias Transfer Belt

The 2nd Bias Transfer Belt is where the image is transferred from the belt to the paper. To improve image transfer or uneven toner coverage, to increase or lower the transfer voltage to the belt, use the 2nd Bias Transfer Belt. This option normally is used with heavyweight stocks, such as 220 g/m<sup>2</sup> and greater. If you use a heavier or lighter weight paper, to make manual changes or perform an automatic adjustment, select the **Auto** button.

If defects continually occur in a printed job when you use heavier weight paper, check the following areas on your printed output. The results determine if the 2nd Bias Transfer Belt adjustments on Side 1 or Side 2 are appropriate.

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



Tip: To check the printed output before saving the changes made to the 2nd Bias Transfer Belt option, you can run test prints.

## Contact Image Sensor (CIS) Operation

This option is used to resolve jams and side registration faults with pre-printed or colored stock. To power on the operation of the CIS in the Registration Assembly, select **Yes**. The CIS detects the lead edge of each sheet as it enters the registration area, and then the Registration Roll side-shifts the sheet to be aligned correctly with the image on the IBT belt. The CIS then detects the trail edge as it exits. This information is used to coordinate the paper position with the ROS creating the image on the IBT belt.

The process ensures that the image on the belt is aligned with the paper for side registration only. When pre-printed content is on the paper, right up to the inboard edge, or the paper is colored, it is possible that the sensor is not able to read the paper position accurately. To function correctly, the sensor needs a white area on the sheet near the edge. Otherwise, a jam or some malfunction with the side shift can occur. To avoid this issue, power off the sensor so that it is not used.

## Tray Air Assist

The Tray Air Assist feature allows you to optimize and control the environmental conditions in your paper trays, which improves paper feeding to the Production Press.

Use this feature to adjust how the fans and shutters in a paper tray work to separate sheets and eliminate misfeeds, multifeeds, or paper jams. To provide a stable feed of paper, these fans blow air to the paper stack during the feeding operation and separate sheets of paper.

To view the Tray Air Assist options, click in this field:

- **Use default Tray Air Assist Profile:** With this selection, the paper tray blowers adjust automatically by using system settings that are optimized for Xerox papers.
- **Multi-Feed Support Table:** Select this option when you have sheets stuck together. This option lowers the air volume so that it does not fluff or pick up as many sheets of paper. A preset lower volume is stored in the non-volatile memory of the Production Press already.
- **Misfeed Support Table:** Select this option when you have a misfeed condition. To reduce paper jams, the air assist function lowers the air volume. A preset lower air volume is stored in the non-volatile memory of the Production Press.
- **Forced Off:** Select this option when neither of the other options produce a change in the output. This option turns off all air assist fans.

## Enable Tray Heater

The Enable Tray Heater option works with the Tray Air Assist option. Checking this box enables the tray heater. The heater maintains the appropriate internal temperature of the paper tray. Depending on the external temperature and humidity, the heater sends information to the tray blowers. The paper tray blowers then power on and provide the required air to the paper stack, which prevents multifeeds or misfeeds.

## Alignment File Name

 Note: If needed, first create an Alignment Adjustment Profile for the stock using the Profiles feature.

To apply a pre-set profile to the stock that adjusts the image position on the paper:

1. Click in the Alignment File Name field. This field can have a system default entry, or another profile listed.
2. Click the **Choose Alignment Profile Library** button.
3. Select the specific profile that you want to apply and assign to this stock.
4. Click **OK**.

## Fold Adjustment Profile

If your Production Press is attached to the appropriate finisher, to apply a pre-set profile to a stock that adjusts fold and staple positions for booklets, use this field:

 Note: If needed, first create a Fold Adjustment profile for the stock using the Profiles feature.

1. Click in the Fold Adjustment Profile field. This field can have a System Default entry, or another profile listed.
2. Click the **Choose From Fold Adjustment Library** button.
3. Select the specific profile that you want to assign to this stock.
4. Click **OK**.

## Productivity Modes

When printing transparencies or embossed papers, this setting enables you to place priority on the speed of printing or place greater focus on image quality. Set the priority to either productivity or image quality mode.

### Transparency Productivity

When you run transparencies, the Productivity setting instructs the Production Press to make fewer fuser and image quality adjustments, which saves time.

### Embossed Paper Productivity

When you run embossed paper, the Productivity setting instructs the Production Press to make fewer fuser and image quality adjustments, which saves time.

### Fuser Performance Priority

Use this setting to adjust the image quality of toner on the paper by changing the paper transport speed in the fuser. Use the Normal setting for most stocks. Use the Low setting for heavy textured or linen stocks. Also, use Low to achieve a higher gloss level.

## Near Empty Detection Level

This option is available only if the Tray Near Empty option is used for the Auto Tray Switch Timing feature, using **System Settings > Tray Options**. Otherwise, this option is ignored. When available, this option informs the user

that a tray is nearing an empty level. When this message displays depends on where the Near Empty Detection Level indicator is set.

### V-TRA Fans

To resolve jams and faults in the fuser area, use this option. The faults can occur when sheets do not arrive at the Fuser in time, or sheets do not exit the Fuser in time. The V-TRA Fans option adjusts the transport speed in area #3. The V-TRA Fans also adjust the air volume or suction used on the transport belt before the fuser, in area #4, and after the fuser, at the fuser exit. The suction holds the sheets to the belt through holes in the belt.

To increase the speed of the belt before the fuser in area #3, select a faster speed. To decrease the speed of the belt before the fuser in area #3, select a slower speed.

To increase the vacuum, or suction, on the belt before the fuser in area #4, and also after the fuser at the fuser exit, select more air volume. To decrease the vacuum on the belt in these areas, select a lower air volume.

To get the results you need, try different settings. Generally, if you increase the speed of the belt in area #3, it is possible you have to increase the air volume in areas #4 and the fuser exit. If you decrease the speed of the belt in area #3, it is possible you also have to decrease the air volume in areas #4 and the fuser exit.

### Test Print Overview

The Test Print option runs sample prints of the specific stock loaded in a tray. Use these sample prints to assess if the loaded stock is working correctly with the selected stock properties, including any selected Advanced Stock Setup options. The test pattern that is used for the sample prints can vary depending on which **Test Print** option you select and use.

The **Test Print** option is available with the following features or options:

- Stock Properties
- New Stock Setup
- Advanced Stock Setup

### Tips for Using the Test Print Option

Before using the **Test Print** option, review the following information.

- If multiple Stock Properties attributes or Advanced Stock Setup options are changed or modified, do the following:
  1. Modify only one attribute or option.
  2. Run test prints.
  3. Evaluate the sample output.
  4. If the sample output is acceptable, then modify a different attribute or option.
  5. Repeat the previous steps for evaluating the next attribute or option.
- If the sample output is unacceptable after running test prints, do one of the following:
  - Make further adjustments to the attribute or option and run more test prints
  - Return the attribute or option to its default value and continue to the next attribute or option.

- It is possible that any settings used today for a particular attribute or option do not achieve the same desired output when used on different day. If the room where the Production Press is located experiences changes in temperature and humidity, this situation is especially relevant.
- Continually repeat procedures and test prints for any attribute or option until you achieve acceptable output prints.
- If the printed output still is not acceptable after repeating procedures and test prints multiple times, contact your Customer Support Center for assistance.

### Using the Test Print Option

To create test prints and evaluate the print after making any Advanced Stock Setup changes, use the following procedure.

Use the Test Print option to view a print of your output having advanced settings applied such as a different fuser temperature or roll pressure for better adherence, or to correct paper curl.

1. After selecting the advanced settings for the stock in the Advanced Stock Setup window, select the **Test Print** button.
2. From the Test Print window, select the job settings.
3. Select the **Print Test** button.

The press prints a sheet with your settings applied.

4. Obtain your printed output from the output area of the press.
5. Evaluate the printed output.

It can take multiple adjustments to the Advanced Stock Setup options and running test prints before the printed output meets your satisfaction.

6. To close the Advanced Stock Setup window, select **OK**.
7. To save and close the Stock Properties window, select **OK**.
8. To exit Manage Stock Library, select **Close**.

### Test Print Option for 2nd Bias Transfer Roll

When you use the 2nd Bias Transfer Roll option, run test prints and evaluate the output before you continue.

The 2nd Bias Transfer Belt values are entered for the stock in the Advanced Stock Setup window automatically.

1. Select the **Auto** or **Manual** button from the Advanced Stock Setup window.

The Test Print Setup: 2nd Bias Transfer Belt window appears.

2. For the Manual mode, to improve the image, select the Sides Imaged and adjust the Change Percentage in increments of 10%.
3. Select the **Start** button.

The press prints 1 or 2 sheets with 16 patch numbers to the output area in the N-1 order. If acceptable, select the **Accept** button. If further adjustments are needed, select **Cancel**, and for the specific patch number, increase or decrease the settings for Side 1 and Side 2.

## Correcting the Paper Curl

Use this procedure when selecting or setting paper curl correction options for either a new permanent stock or a modification to an existing stock.

1. From the Advanced Stock Setup window, select the appropriate **Paper Curl Correction** option from the menu.
  - Severe Upward
  - Medium Upward
  - Moderate Upward
  - Slight Upward
  - No Curl
  - Medium Downward
  - Severe Downward
2. Select the **Test Print** button.
3. Select the appropriate print density setting.
4. Select the tray where the stock is loaded and the appropriate output quantity to be printed.
5. Select the **Print Test** button.
6. To close the Advanced Stock Setup window, select **OK**.
7. To save the changes to the stock and close the Stock Properties window, select **OK**.
8. To exit the Manage Stock Library, select **Close**.

## Paper Curl Overview

This option allows you to select the appropriate paper curl setting to prevent your output from curling. This section provides an overview of paper curl, the causes, and why adjustments can be required to obtain optimum print output.

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

Many variables cause paper curl, including:

- The weight of the paper and if it is coated or uncoated.
- The amount of dry ink/toner and the area being covered on a sheet—the heavier the coverage, the greater the tendency to curl.
- How the paper is loaded in the tray. Make sure that you load the paper as instructed on the ream wrapper.
- The atmospheric conditions of the room where the paper is stored, especially those conditions related to humidity and temperature.
- The heat generated during the fusing processes.

Your system is designed with an automated setting to control curl. When you use the system Default, the Production Press automatically sends paper through the proper decurler. To reduce the output curl of the paper, the system Default automatically determines the amount of pressure needed at the different decurlers.

With some print jobs, the output prints can still curl more than is necessary even after using the system default. In those cases, to compensate for paper curl in your prints, use the Paper Curl Correction option in the **Advanced Stock Setup** window. Paper Curl Correction settings are based on the job type and image density ratio.



Note: It is important to remember that a successful paper curl correction setting used today is not necessarily the same setting that you would use on another day. If the room where the Production Press is located experiences changes in temperature and humidity, this fact is especially relevant.

### Paper Curl Correction Options

The Paper Curl Correction options from the Advanced Stock Setup window include:

- **Adjust 1 Sided – Face Up:** This option allows you to set specific paper curl information for 1-sided only printed output that exit the Production Press in the face-up position.
- **Adjust 1 Sided – Face Down:** This option allows you to set specific paper curl information for 1-sided only printed output that exit the Production Press in the face-down position.
- **Adjust 2 Sided – Side 1:** This option allows you to set specific paper curl information for 2-sided printed output when jams or curling occur along the return paper path after Side 1 prints.
- **Adjust 2 Sided – Side 2:** This option allows you to set specific paper curl information for 2-sided printed output when jams or curling occur along the return paper path after Side 2 prints.

### Secondary Transfer Voltage Adjustment

Use the **Secondary Transfer Voltage Adjustment** option to correct for mottle (uneven toner coverage) and color shift (inconsistent color). These image quality issues may occur on heavy-weight stocks. The **Secondary Transfer Voltage Adjustment** option creates and saves an image transfer adjustment to the Bias Transfer Roll in the press. The Bias Transfer Roll is where the image is transferred from the belt to the paper.

Once created for a stock, the adjustment is saved and can be selected for that stock for any tray.

The adjustment can be performed by selecting one these buttons: **Auto** or **Manual**.

- **Auto:** The adjustment is done automatically by the press and eliminates the need for you to interpret printed targets and manually enter adjustment values. This saves time and avoids errors. Usually **Auto** fixes most image quality issues.



Note: Always perform the **Auto** adjustment first before performing a manual adjustment.

- **Manual:** The user must manually perform the adjustment, including printing test patterns, interpreting the printed targets on those patterns, and then manually entering the adjustment values. Use the **Manual** adjustment option only when the **Auto** adjustment does not provide the desired output.

### Using the Auto Adjustment Option for Secondary Transfer Voltage Adjustment

1. Perform one of the following:
  - Create a new stock entry,
  - Copy an existing stock entry, or
  - Editing an existing stock



2. From either the New Stock Setup or Stock Properties window, select and modify the stock attributes as required, including entering a new or revised stock name, selecting a stock size, color, and other attributes.  
If using the **Secondary Transfer Voltage Adjustment** option, customize the stock name or include information in the Comment section to identify the usage of this option; for example name the stock **Custom STVAdj\_Auto** or add a comment stating *This custom stock is using Secondary Transfer Voltage Auto Adjustment*.
3. Select the Advanced Setup button.  
The Advanced Stock Setup window opens.
4. Select the **Auto** option for Secondary Transfer Voltage Adjustment.  
The Test Print - Secondary Transfer Voltage Auto Adjustment window opens.
5. Select the following settings:
  - a. Paper tray
  - b. Sides Imaged: **Side 1** or **Sides 1 and 2**
  - c. Desired Color Mode
  - d. Do not enter a **Change Percentage** value for either Side 1 or Side 2
6. Select **Start**.  
The press generates 16 patches on a single test print:
  - Patches 1-10 have more bias applied to them (more transfer voltage)
  - Patches -1 through -5 have less bias applied to them (less transfer voltage)
  - Patch 0 is the median range; this is the default value
7. Retrieve the test print from the output area of the press. Continue to the next step.
8. Select **Bias Acceptable** on the Test Print - Secondary Transfer Voltage Auto Adjustment second window.
  - The window closes and displays Advanced Stock Setup.
9. Select **OK** to save and close the Advanced Stock Setup window.
10. Select **OK** to save and close either the New Stock Setup window or the Stock Properties window.
11. Select **Close**

#### Using the Manual Adjustment Option for Secondary Transfer Voltage Adjustment

1. Perform one of the following:
  - Create a new stock entry,
  - Copy an existing stock entry, or
  - Editing an existing stock
2. From either the New Stock Setup or Stock Properties window, select and modify the stock attributes as required, including entering a new or revised stock name, selecting a stock size, color, and other attributes.  
If using the **Secondary Transfer Voltage Adjustment** option, customize the stock name or include information in the Comment section to identify the usage of this option; for example name the stock **Custom STVAdj\_Manual** or add a comment stating *This custom stock is using Secondary Transfer Voltage Manual Adjustment*.

3. Select the Advanced Setup button.

The Advanced Stock Setup window opens.

4. Select the **Manual** option for Secondary Transfer Voltage Adjustment.

The Test Print - Secondary Transfer Voltage Manual Adjustment window opens.

5. Select the following settings:

- a. Paper tray
- b. Sides Imaged: **Side 1** or **Sides 1 and 2**
- c. Desired Color Mode
- d. When running a test print for the first time, there is no need to enter a **Change Percentage** value for either Side 1 or Side 2

6. Select **Start**.

The press generates 16 patches on a single test print:

- Patches 1-10 have more bias applied to them (more transfer voltage)
- Patches -1 through -5 have less bias applied to them (less transfer voltage)
- Patch 0 is the median range; this is the default value

7. Retrieve the test print from the output area of the press.

The Stock Library Manager displays a message to select either **Bias Acceptable** or **Adjust Test Prints**. Continue to the next step.

8. Evaluate the printed output for the patch with the best image quality. For example, the best image quality is on **Patch# 2**.

9. In the Patch number field for Side 1 and Side 2, enter the correct number of the patch with the best image quality.

10. Select **Bias Acceptable**.

- The current window closes and displays Advanced Stock Setup.
- A new value is displayed in the Side 1 field or Side 1 and Side 2 fields (depending on which Sides Imaged option was selected earlier in this procedure).

11. Select **OK** to save and close the Advanced Stock Setup window.

12. Select **OK** to save and close either the New Stock Setup window or the Stock Properties window.

13. Select **Close**

14. Run a few prints from a job that uses the Stock Properties with the new **Secondary Transfer Voltage Manual Adjustment** setting (as modified earlier in this procedure).

This verifies whether or not the changes made to the Secondary Transfer Voltage Adjustment option are providing the desired printed output.

15. Retrieve and review the printed output for image quality. Choose one of the following:

- The printed output is acceptable: continue with normal workflow processes.
- The printed output is unacceptable: Repeat the steps of this procedure and if the output continues to be unacceptable, contact the Customer Support Center for further assistance.

## Stock and Feeders

Stocks and Feeders is where you go to learn about supported stocks, stock guidelines, and how to load trays and feeders.



Note: The Production Press supports non-standard media sizes. However, the rounding and conversion of units occurring in client applications, print server, and printer, create a mismatch between the media sizes entered at the application and the Production Press. When necessary, adjust the entered paper dimensions by up to 2.5 mm (0.1 in.) so that the Production Press can detect the required media size. The Production Press interprets some media sizes included in the PostScript Printer Description (PPD) as non-standard.

### SUPPORTED MEDIA

For supported media types, media sizes, media specifications for all trays, and unsupported media, refer to the following information.

- [Paper Types](#)
- [Paper Size Ranges](#)
- [Standard Media Specifications for All Trays](#)
- [Dual Advanced Oversized High Capacity Feeder Specifications](#)
- [Unsupported Media](#)

### Paper Types

To ensure maximum performance of the Production Press, before running your job, ensure that you select the appropriate paper type.

Available paper types are:


- Plain
- Textured/Embossed
- Transparency
- Film
- Metallic
- Postcard
- Recycled
- Label
- Tack
- Transfer
- Pre-cut tab – Plain
- Pre-cut tab – Embossed
- Pre-cut tab – Recycled
- Full-cut tab – Plain

## Working With


- Full-cut tab – Embossed
- Full-cut tab – Recycled
- Ordered/Sequenced – Plain
- Ordered/Sequenced – Embossed
- Ordered/Sequenced – Recycled
- Custom

### Paper Size Ranges

| TRAY                                    | MINIMUM SIZE                  | MAXIMUM SIZE                     |
|---|-------------------------------|----------------------------------|
| Trays 1 and 2                           | 98 x 148 mm (3.86 x 5.83 in.) | 330.2 x 488 mm (13 x 19.21 in.)  |
| Trays A1-1 and A1-2                     | 98 x 148 mm (3.86 x 5.83 in.) | 330.2 x 488 mm (13 x 19.21 in.)  |
| Trays A2-1 and A2-2                     | 98 x 148 mm (3.86 x 5.83 in.) | 330.2 x 488 mm (13 x 19.21 in.)  |
| Multi-Sheet Inserter, Tray A1-3 or A2-3 | 98 x 148 mm (3.86 x 5.83 in.) | 330.2 x 1200 mm (13 x 47.25 in.) |

 Note: Paper height below 182 mm (7.17 in.) requires the postcard bracket.

### Standard Media Specifications for All Trays

 Note: For a comprehensive list of supported media, always refer to the Recommended Media List (RML). You can access the RML from the Manage Stock Library window, and also download it from [www.xerox.com/IRIDESSEsupport](http://www.xerox.com/IRIDESSEsupport).

| MEDIA                    | MEDIA SIZE                            | DIMENSIONS (MM) AND FEED DIRECTION (SEF/LEF*) | WEIGHT (G/M <sup>2</sup> ) | COATING TYPE |
|--------------------------|---------------------------------------|---|----------------------------|--------------|
| Plain paper              | A4 8.3 x 11.7 in.                     | 210 x 297 SEF/LEF                             | 52-400                     | Uncoated     |
| Embossed                 | A3 11.7 x 16.5 in.                    | 297 x 420 SEF                                 |                            | Gloss        |
| Postcard                 | B5 7.17 x 10.12 in.                   | 182 x 257 SEF/LEF                             |                            | Matte        |
| Custom                   | B4 10.12 x 14.33 in.                  | 257 x 364 SEF                                 |                            | Cast-coated  |
| Recycled Media           | Executive 7.25 x 10.5 in.             | 184.2 x 266.7 SEF/LEF                         | —                          | —            |
| Textured/<br>Embossed    | 8 x 10 in.                            | 203.2 x 254 SEF/LEF                           |                            |              |
|                          | Letter 8.5 x 11 in.                   | 215.9 x 279.4 SEF/LEF                         |                            |              |
| Transfer Paper           | 8.5 x 13 in.                          | 215.9 x 330.2 SEF/LEF                         |                            |              |
| Film                     | Legal 8.5 x 14 in.                    | 216 x 356 SEF                                 |                            |              |
| Metallic                 | 11 x 17 in.                           | 279.4 x 431.8 SEF                             |                            |              |
|                          | SRA3 12.6 x 17.7 in.                  | 320 x 450 SEF                                 |                            |              |
|                          | 12 x 18 in.                           | 304.8 x 457.2 SEF                             |                            |              |
|                          | 12.6 x 19.2 in.                       | 320 x 487.7 SEF                               |                            |              |
|                          | 13 x 18 in.                           | 330.2 x 457.2 SEF                             |                            |              |
|                          | 13 x 19 in.                           | 330.2 x 482.6 SEF                             |                            |              |
|                          | 16K (Taiwan) 7.64 x 10.51 in.         | 194 x 267 SEF/LEF                             |                            |              |
|                          | 16K (Mainland China) 7.68 x 10.63 in. | 195 x 270 SEF/LEF                             |                            |              |
|                          | 8K (Taiwan) 10.51 x 15.28 in.         | 267 x 388 SEF                                 |                            |              |
|                          | 8K (Mainland China) 10.63 x 15.35 in. | 270 x 390 SEF                                 |                            |              |
| Postcard 3.94 x 5.83 in. | 100 x 148 SEF                         |   |                            |              |
| Postcard 4 x 6 in.       | 101.6 x 152.4 SEF                     |   |                            |              |
| Transparency             | A4 8.3 x 11.7 in.                     | 210 x 297 LEF                                 | —                          | —            |
|                          | Letter 8.5 x 11 in.                   | 215.9 x 279.4 LEF                             |                            |              |
| Tack Paper               |                                       |   | —                          | —            |
| Precut Tab, Plain        | 9 x 11 in.                            | 228.6 x 279.4 LEF                             | 52-400                     | Uncoated     |
| Full-cut Tab,<br>Plain   |                                       |   |                            | Gloss        |
|                          |                                       |   |                            | Matte        |
| Precut Tab:              |                                       |   |                            | Cast-coated  |

| MEDIA   | MEDIA SIZE                               | DIMENSIONS (MM) AND FEED DIRECTION (SEF/LEF*) | WEIGHT (G/M <sup>2</sup> ) | COATING TYPE |
|---|--|---|----------------------------|--------------|
| <ul style="list-style-type: none"> <li>• Embossed</li> <li>• Recycled</li> </ul> Full-cut Tab: <ul style="list-style-type: none"> <li>• Embossed</li> <li>• Recycled</li> </ul> |  |   |                            |              |
| Labels  | A4 8.3 x 11.7 in.<br>Letter 8.5 x 11 in. | 210 x 297 LEF<br>215.9 x 279.4 LEF            | 52-400                     | Uncoated     |

\* LEF: Long Edge Feed; SEF: Short Edge Feed



Note: Height below 182 mm requires the postcard bracket.

### Unsupported Media

Some paper and other media types can cause poor output quality, increased paper jams, or damage the Production Press. Do not use the following:

- Rough or porous paper
- Inkjet paper
- Paper that is business-card size
- Paper that is folded or wrinkled
- Paper that is curled more than 12 mm (0.47 in.)
- Paper with cutouts or perforations
- Stapled paper
- Damp paper
- Thermal or heat-transfer paper
- Envelopes of any type



Note: In addition to the media listed, there can be other media that are not recommended or supported. For details, contact your local Xerox representative.

### STOCK AND MEDIA GUIDELINES

For guidelines on using stocks and media with the Xerox® Iridesse® Production Press, refer to the following information.

- [Media Selection Guidelines](#)
- [General Media Loading Guidelines](#)

- [Guidelines for Printing on Glossy Media](#)
- [Guidelines for Printing on Hole-Punched Paper](#)
- [Guidelines for Printing on Tab Media](#)
- [Guidelines for Printing on Transparencies](#)
- [Matching the Tray and Media Information](#)

### Media Selection Guidelines

When you select media, use the following guidelines:

- To maximize reliability and paper-handling performance, use only Xerox-recommended media. To ensure the best image quality, use Centerline paper.
- Typically, heavy-weight papers exhibit increased variability of formation and surface smoothness, which can result in degraded image quality.
- When the ambient relative humidity exceeds 60%, manufacturers of coated media do not recommend use of their media. Relative humidity greater than 40% can increase the misfeed rate from all input trays.
- All media stretches, to a certain extent, during printing. The amount of stretch depends on paper type and environmental conditions. Stretch is most noticeable on coated media. This stretch can affect front-to-back image registration. To minimize this effect, use the Alignment Profiles feature described in the Manage Stock Library window.
- Image registration, image quality such as white spots, and Production Press reliability can deteriorate in the following conditions:
  - When custom-cut paper is cut inaccurately or is of poor quality, or when loose paper fibers are present on the cut edges
  - When punched or drilled paper is of poor quality, or loose hole plugs are present in the ream
- If you plan to run the Production Press output through finishing devices such as a coater, laminator, or other accessory, test the application before you run the job. Many factors impact the success of running the Production Press output in other equipment.

For more information and recommendations about media testing, selections, and handling, refer to the Recommended Media List (RML). The RML is available from your Xerox representative or you can download it from [www.xerox.com/IRIDESSEsupport](http://www.xerox.com/IRIDESSEsupport).

### General Media Loading Guidelines

- Fan the media before loading it in the tray.
- Do not overfill the trays. Do not load media above the indicated maximum fill line in the tray.
- Adjust the guides to fit the media size.
- If excessive jams occur, use approved media from a new package.
- Do not print on label media if the label is removed from a sheet.

### **Guidelines for Printing on Glossy Media**

Glossy media is a type of coated paper that can print from all trays.

Before using glossy media, always refer to the following guidelines:

- In the Coating field, select **Gloss**. For Paper Source, select the tray containing the glossy media.
- Select the correct Paper Weight and Size.
- Until you are ready to load them into the Production Press, do not open sealed packages of glossy media.
- Store glossy media flat in the original packaging.
- Before loading glossy media, remove all other media from the tray.
- Load only the amount of glossy media that you plan to use, and when you finish printing, remove the unused portion from the tray.
- Replace the unused portion of glossy media into the original wrapper and seal the wrapper.
- Rotate the media frequently.
- Long periods of storage in extreme conditions can cause glossy media to curl and jam in the Production Press.

### **Guidelines for Printing on Hole-Punched Paper**

Hole-punched paper is defined as having two or more holes along one edge for use in ring binders and notebooks.

Before using hole-punched media, always refer to the following guidelines:

- Media with punched holes can print from all trays.
- You can load hole-punched paper either in the LEF (portrait) or SEF (landscape) direction. Select the hole-punch type that matches the stock in use.
- As shown on the image on the front of the tray, position the holes along the feed edge.
- Load hole-punched media with the side to print facing up.
- To prevent jams or damage, ensure that any plugs, which are pieces cut out of the media to create the holes, do not remain in the stack.

### **Guidelines for Printing on Tab Media**

Before you use the tab media, always refer to the following guidelines:

- Tab media can print from all trays.
- Tabs are loaded in the tray only in the long-edge feed (LEF) direction.
- Tab media is loaded so the straight edge of the stock is in the feed direction.
- You can load either single straight collated or single reverse collated tab media.
- For more detailed information on how to set up a tab job at your print server, refer to the print server documentation.
- If a jam occurs while running tabbed sets, cancel the job and start again.
- Before loading tab media in a tray, program your tab job at the Stock Library application on the print server or from your print driver:



- Select **Tab Stock** or **Precut Tabs** as the Paper Type.
- Select the tray containing the stock as the Paper Source.
- Select the correct Paper Weight for the tabs, usually 163 g/m<sup>2</sup>. The weight range can be 106–176 g/m<sup>2</sup>.
- Set Modules, or Banks, to the number of tabs in the set.



Note: This option becomes active only after you select a tab.

- For the media size, set a Custom Size of 229 x 279 mm (9 x 11 in.) LEF.
- For the Print Output Order or Tab Sequence, select **N to 1**.
- For **Output Delivery**, select **Face Up**.

### Guidelines for Printing on Transparencies

Before using transparencies, always refer to the following guidelines:

- For optimum system performance and image projection, use Xerox® removable stripe transparency materials. These premium transparencies are designed to provide optimum print quality.
- Use of other transparencies can damage the Production Press and result in excessive service calls.
- Transparencies can print from all trays.
- Use only transparency stock listed in the Recommended Media List (RML).
- Do not mix paper with individual transparencies in a tray. Jams can occur.
- Do not load more than 100 transparencies in a paper tray.
- Load A4 (8.5 x 11 in.) transparencies long-edge feed, portrait, only.
- To prevent them from sticking together before loading, fan the transparencies.
- Load transparencies on top of a small stack of the same-size paper.
- At the Stock Library, select **Transparency** as the Paper or Media Type and select the tray containing the transparencies as the Paper Source.
- For the maximum output stack height, do not exceed 100 transparencies.

### Special Print Jobs

Review the following points:

### Printing Duplex 2-Sided Prints



Note: Duplex, or 2-sided, performance does not necessarily match the performance for 1-sided printing or copying. More paper jams can occur when you print 2-sided than when you use the same throughput material 1-sided.

- For automatic 2-sided printing, use the recommended media up to SRA3 320 x 450 mm (13 x 19 in.), maximum 320 x 482 mm from 52–400 g/m<sup>2</sup>.
- For manual 2-sided printing, use the recommended media up to SRA3 320 x 450 mm (13 x 19 in.), maximum 320 x 482 mm from the Multi-Sheet Inserter.
- To reduce jams when using 2-sided printing on a media heavier than 220 g/m<sup>2</sup> (80 lb. Cover), ensure that the grain of the media is perpendicular to the print process direction, or short grain.

### Printing Transparencies

- For optimum system performance and image projection, use Xerox removable stripe transparency materials. These premium transparencies offer optimum print quality. Use of other transparencies can damage the Production Press and result in excessive service calls.
- Due to the increased thickness of the removable stripe, do not load more than 100 transparencies in a tray. Do not exceed the maximum output stack height of 100 transparencies.

### Printing Extra Long Sheets longer than 488 mm (19.2 in.)

#### Configurations

- Feed extra long sheets using only the Multi-Sheet Inserter.
- When you use sheets longer than 488 mm (19.2 in.), direct the output to only the trays or finishing devices listed. Otherwise, the stacking capacity and quality can diminish.
  - Offset Catch Tray
  - Top Tray
    - Production Ready Finisher
    - Production Ready Booklet Maker Finisher
    - Production Ready Finisher Plus
  - Top Tray of the High Capacity Stacker
- Sheets greater than 488 mm (19.2 in.) cannot be stapled, punched, folded, or use any other finishing option, including any 3rd party DFA finishers.

### Printing Postcards

- The Postcard bracket that comes with the Advanced Oversized High Capacity Feeder allows you to print on smaller media without requiring post-processing cutting or sorting. The Postcard bracket specifically accommodates 101.6 x 152.4 mm (4 x 6 in.) SEF media.

For more information, refer to:

- [Loading Postcards in the Multi-Sheet Inserter](#)
- [Loading Postcards in Trays A1-1 and A1-2, and A2-1 and A2-2](#)

### Media Handling

- Print sheets longer than 729 mm (28.7 in.) 1-sided (simplex) only. Auto-duplex is not possible.
- For uncoated media and for coated media, the media range is 52–400 g/m<sup>2</sup>.

### Caveats


- Full Width Array features are not available for sheets longer than 729 mm (28.7 in.).
- The risk of jams increases when running sheets longer than 729 mm (28.7 in.).
- When printing long sheets, jams can span multiple modules of the Production Press and can be more difficult to clear.
- Multi-feeds can occur when printing on coated media. To prevent multi-feeds, feed sheets individually.
- When printing sheets longer than 729 mm (28.7 in.), you can use Auto Registration for 1-sided printing only. Auto Registration is not available for 2-sided printing on sheets longer than 729 mm (28.7 in.).
- Registration performance is not guaranteed on sheets longer than 729 mm (28.7 in.). Any registration specifications cited in the documentation for the Xerox® Iridesse® Production Press do not apply to sheets longer than 729 mm (28.7 in.).
- The risk of print quality defects increases when printing sheets longer than 729 mm (28.7 in.).
- The risk of creasing and wrinkles increases when printing sheets longer than 729 mm (28.7 in.).
- More image quality adjustments during run-time are likely when printing sheets longer than 729 mm (28.7 in.).
- The Transfer and Density Uniformity features are not available for sheets longer than 729 mm (28.7 in.).
- When you run the same media at less than 729 mm (28.7 in.), reevaluate any Production Press problems identified when you ran sheets longer than 729 mm (28.7 in.). Before calling for service, validate that the problem persists on sheets shorter than 729 mm (28.7 in.).
- When you cut larger paper to Extra Long Sheet (XLS) format, when possible, cut the paper in the long-grain direction.

### Installing and Using the Postcard Bracket

You can print postcards using either the Multi-Sheet Inserter or the Advanced Oversized High Capacity Feeder.


When you print postcards using the Advanced Oversized High Capacity Feeder, use the postcard bracket that comes with the High Capacity Feeder. The postcard bracket allows you to print on smaller media without requiring post-processing cutting or sorting. The postcard bracket specifically accommodates 101.6 x 152.4 mm (4 x 6 in.) short-edge feed media. For more information about installing and using the postcard bracket, refer to [Loading Postcards in Trays A1-1 and A1-2, and A2-1 and A2-2](#).

## Matching the Tray and Media Information

-  Important: To ensure maximum productivity and successful job completion, always verify that the Tray Properties information from the Manage Stock Library on the Control Center matches the media that is loaded in the tray used for the print job.


Before running a print job, check for any of the following conditions:

- Modifications were made to the Stock Library, such as
  - Adding media
  - Copying media
  - Creating media
  - Editing existing media
- Media was loaded into the selected tray for the print job
- The tray selected for the print job was opened or closed

-  Note: If any of these conditions applies, verify that the Tray Properties information matches the tray contents.

If the media loaded in the tray does not match the information on the Tray Properties window, a message can appear on one or more of the following locations:

- Control Center of the Production Press
- Manage Stock Library on the Control Center
- Print server
- Both the Manage Stock Library and the print server
- Manage Stock Library, print server, and possibly on the Control Center.

-  Tip: Media and tray mismatch information and how it appears depends on the individual print server. If media is changed in a tray, it is possible no message appears. Therefore always perform the following steps before running a print job.

1. Check for a tray mismatch message on the Production Press Control Center. If a mismatch message appears, select it.

A new message appears that provides the required media and the tray location.

2. Go to the print server and check the main window for a similar message:
  - If a message exists, to correct the media mismatch issue, follow the information provided on the print server and continue to the next step.
  - If a message does not exist, continue to the next step.
3. Load the media in the tray.  
If the Control Center on the Production Press displays a mismatch message, follow the instructions provided to load the correct media.
4. At the Manage Stock Library on the PC UI, change the Tray Properties to match the contents of the tray.
  - a. Verify the size, coated or uncoated type, and the weight of the media loaded in the tray.

- b. If necessary, enter that information on the Tray Properties window.
5. Ensure that the tray is closed.
6. Ensure that all tray and media mismatch messages are resolved.
7. Start your print job.

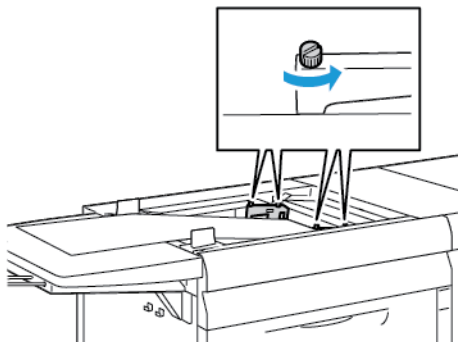
## USING THE MULTI-SHEET INSERTER


To load stock into the Multi-Sheet Inserter, refer to the following information:

- [Loading Media in the Multi-Sheet Inserter](#)
- [Adjusting the Skew on Long Paper](#)
- [Loading Long Paper in the Multi-Sheet Inserter](#)
- [Using the Optional Banner Feeder Extension for the Advanced High Capacity Feeder](#)
- [Loading Hole-Punched Media in the Multi-Sheet Inserter](#)
- [Loading Transparencies in the Multi-Sheet Inserter](#)
- [Loading Tab Media in the Multi-Sheet Inserter](#)
- [Loading Postcards in the Multi-Sheet Inserter](#)
- [Using the Xerox® XLS Automatic Feeding Kit](#)

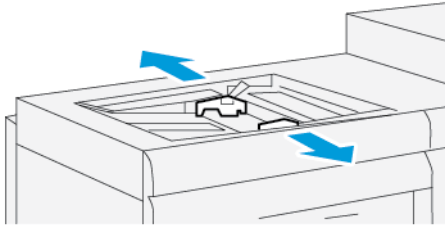
### Loading Media in the Multi-Sheet Inserter

1. Loosen the four screws on the front-edge guide.

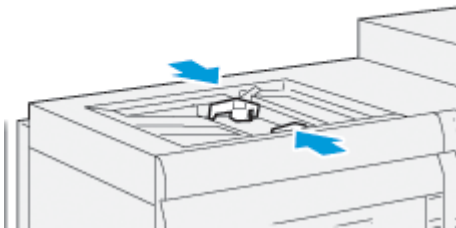


-  Important: Before you make any adjustments, loosen both sides of the guide. If you forcibly adjust the guides, they can become misaligned, after which a service call is required.


- Slide the paper guides outward to the appropriate paper size.

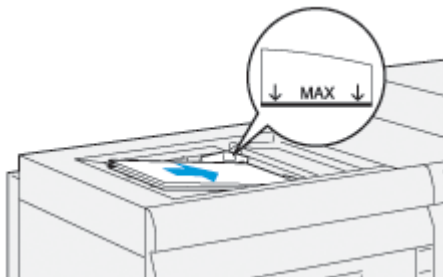


- Select the appropriate media for your print job.
- Open the media with the seam side facing up.
- Before loading media into the Multi-Sheet Inserter, fan the sheets.
- Insert the stack of media into the Multi-Sheet Inserter until it stops.
- Adjust the paper guides so that they touch the edges of the stack.



The paper Tray Properties window appears on the main window of the Control Center.

 Note: Do not load materials above the **MAX** line on the guides.



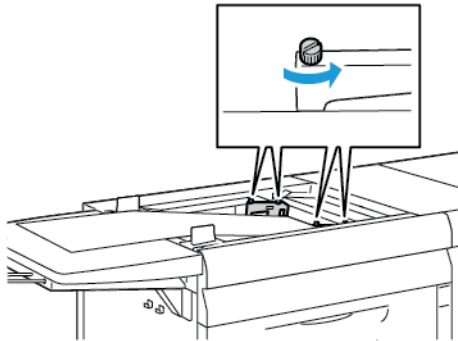
- From the Tray Properties window, verify that the correct paper information such as size, type and weight, are selected and match the media loaded in the Multi-Sheet Inserter.
- To save the information and close the Tray Properties window, select **OK**.


### Adjusting the Skew on Long Paper

If you perform the Auto Alignment procedure and it fails, adjust the skew.

To check the alignment, then adjust the skew:

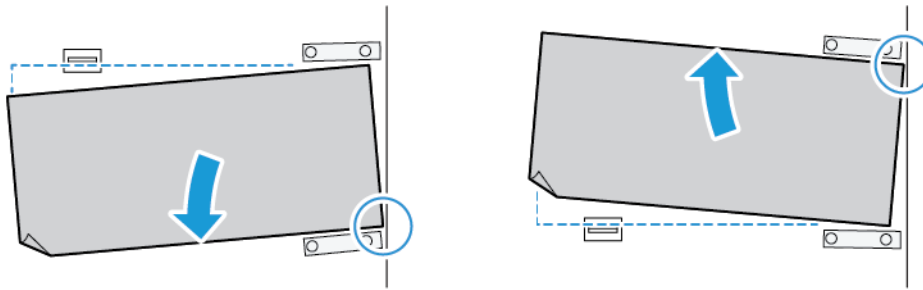
1. On the front-edge guide, loosen the four screws.




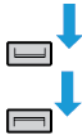
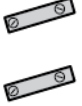

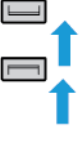
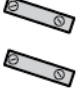
 Important: Before you make any adjustments, loosen both sides of the guide. If you forcibly adjust the guides, they can become misaligned, after which a service call is required.

2. Load the paper.
3. Adjust the guides for the Multisheet Feeder and the Banner feeder so that they are as parallel to the Production Press as possible.
4. Run the automatic alignment procedure. Refer to [Setting the Auto Alignment Profile](#).
5. If the result of the auto alignment is satisfactory, continue to refine the alignment using other procedures in this document. For example, [Adjustments to the Position of the Output Image](#). If the result of the auto alignment is not satisfactory, continue this procedure.
6. Loosen the four screws on the front-edge guide.

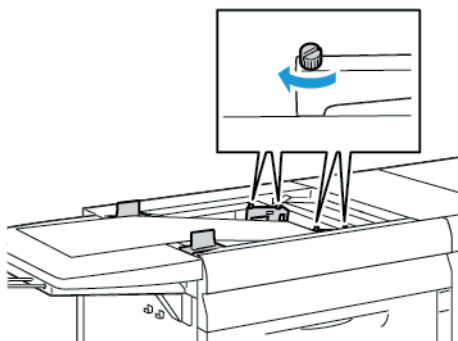
7. Move the rear edge of the paper to the position corresponding to the skew amount:



- If the skew is oriented to the left, use the right-front edge of the paper as the pivot point.
- If the skew is oriented to the right, use the left-front edge of the paper as the pivot point.

| IMAGE   | REAR-EDGE GUIDE   | FRONT-EDGE GUIDE   |
|---|---|--|
| Skew is oriented to the left.<br>    | <br>Move downward. | <br>Right side is higher. Left side is lower.   |
| Skew is oriented to the right.<br> | <br>Move upward. | <br>Right side is lower. Left side is higher. |

8. Tighten the four screws on the front-edge guide, then, to match the paper size, fine-tune the rear-edge guide.




9. Rerun the auto alignment procedure. Refer to [Setting the Auto Alignment Profile](#).



### Loading Long Paper in the Multi-Sheet Inserter

To load long paper in the Multi-Sheet Inserter:

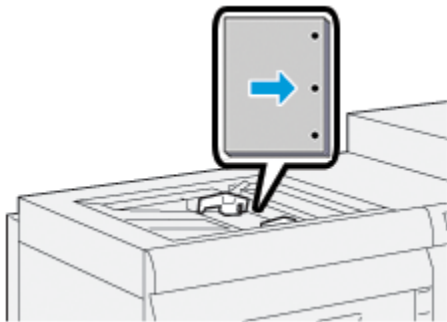
1. If necessary, adjust the skew on the paper. Refer to [Adjusting the Skew on Long Paper](#).
2. For anything over a length of 488 mm, to reduce the risk of multifeeds, load each page separately to a maximum stack of 20 sheets.

 Important: There are some stocks that require you to feed the long paper into the Multi-Sheet Inserter one sheet at a time. When you use the default settings, the Production Press cycles down for about two minutes between each manually inserted sheet.

3. If you use stock that requires you to feed one sheet at a time, to minimize the out-of-paper recovery time:
  - a. From the Stock Properties window, clear the **Display Tray Properties Automatically When Stock is Added** check box.
  - b. Log in as the administrator.
  - c. Select the **System** tab.
  - d. Change the Auto Resume After Fault Clearance setting to 0 minutes and 1 second.

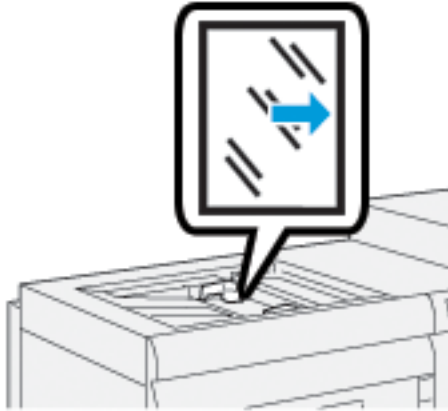
### Loading Hole-Punched Media in the Multi-Sheet Inserter

Load and align the edge of the hole-punched media with the holes against the right edge of the Multi-Sheet Inserter.



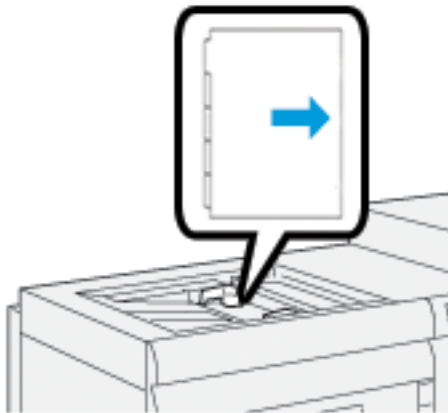
### Loading Transparencies in the Multi-Sheet Inserter

Load the transparencies in the LEF portrait direction, and align the edge of the transparencies against the right edge of the Multi-Sheet Inserter, with the side to print on facing up.



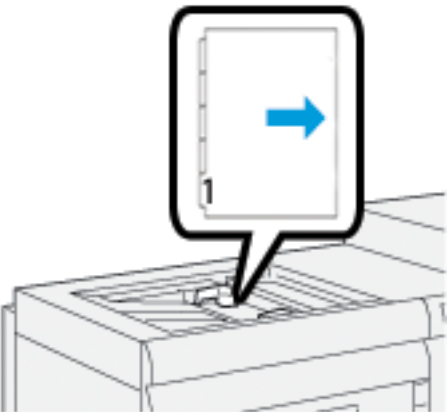
### Loading Tab Media in the Multi-Sheet Inserter

Load the tab media LEF, with the side to print on facing up. Align the straight edge of the tab stock against the right edge of the Multi-Sheet Inserter and the tabs to the left.



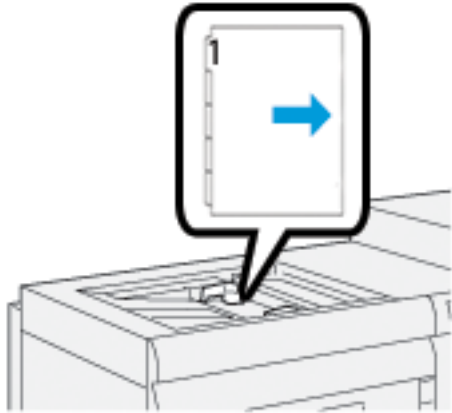
### Loading Straight Collated Tabs

Load straight collated tabs with the first blank tab cutout toward the front of the Multi-Sheet Inserter.



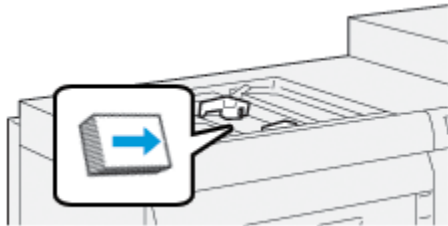
### Loading Reverse Collated Tabs

Load reverse-collated tabs with the first blank tab cutout toward the rear of the Multi-Sheet Inserter.



### Loading Postcards in the Multi-Sheet Inserter

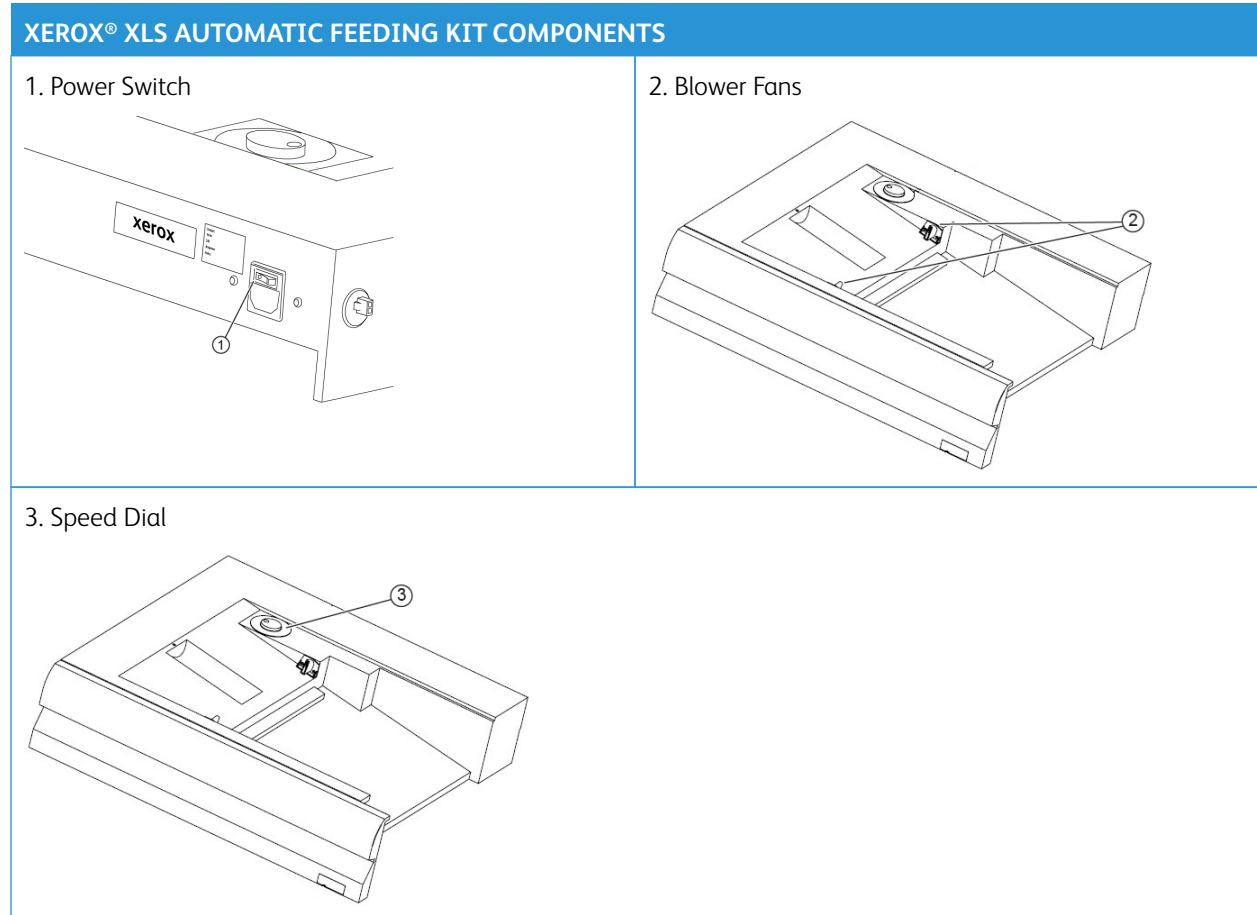
Load postcards SEF, with the side to print on facing up.



### Using the Xerox® XLS Automatic Feeding Kit




The optional Xerox® XLS Automatic Feeding Kit fluffs the media in the Multi-Sheet Inserter using blower fans. The Xerox® XLS Automatic Feeding Kit can improve sheet feed accuracy for long media and heavyweight media.



If the power switch for the Xerox® XLS Automatic Feeding Kit is in the On position, when you add media to the Multi-Sheet Inserter, the blower fans power on automatically.



1. To power on the Xerox® XLS Automatic Feeding Kit, move the power switch to the On position. The power switch is located on the rear side of the Multi-Sheet Inserter tray.
2. Load media into the Multi-Sheet Inserter tray. The blower fans power on automatically.


- To adjust the blower fan speed, turn the dial to the appropriate speed for the weight of the media.

| BLOWER FAN SPEED  | MEDIA WEIGHT SUPPORTED         |
|---|--------------------------------|
|  | Less than 100 g/m <sup>2</sup> |
|  | 100–200 g/m <sup>2</sup>       |
|  | More than 200 g/m <sup>2</sup> |

-  Note: When the Xerox® XLS Automatic Feeding Kit is not in use, to ensure that the blower fans power off, remove all material from the Multi-Sheet Inserter tray.
-  Note: Whenever you power off the press, Xerox recommends that you also power off the Xerox® XLS Automatic Feeding Kit using its power switch.

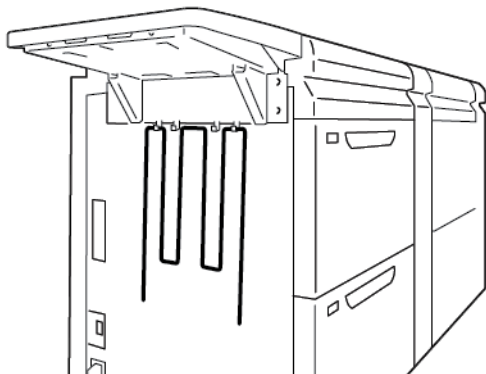
### USING THE OPTIONAL BANNER FEEDER EXTENSION FOR THE ADVANCED HIGH CAPACITY FEEDER

To allow you to use long paper that stays in place without falling, an optional Banner Feeder Extension is installed on the left side of the feeder.

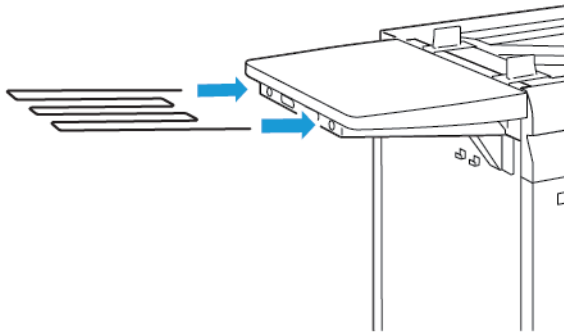
-  Note: The Banner Feeder Extension consists of new hardware, including an Extension Tray and a Wire Support that increases the length of the tray. The tray alone supports paper over 660 mm (25.98 in.), with a maximum of about 990 mm (39 in.). When you add the Wire Support extension, the support increases to up to 1200 mm (47.24 in.).

If you have the optional Banner Feeder Extension:

- From the storage location under the tray, remove the Wire Support Extension.



2. In the two holes on the left of the tray, insert the Wire Support Extension. Push the extension all the way in until it stops.



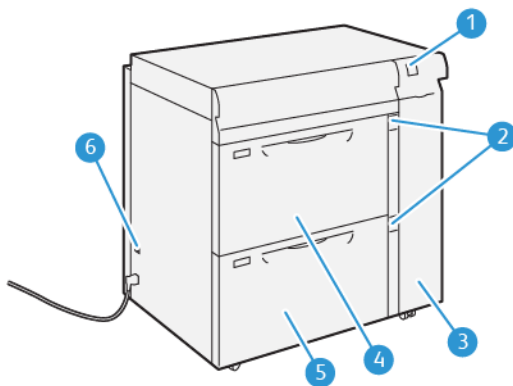
3. Run the banner print job.
4. When the job is complete, return the Wire Support Extension to its storage location.

### USING THE ADVANCED AND DUAL OVERSIZED HIGH CAPACITY FEEDERS

To load media into Trays A1-1, A1-2, A2-1, and A2-2 of the Advanced Oversized High Capacity Feeders, refer to the following information.

- [Trays A1-1 and A1-2 Components](#)
- [Feed Performance in Trays A1-1 and A1-2](#)
- [Loading Paper in Trays A1-1 and A1-2](#)
- [Loading Hole-Punched Paper in Trays A1-1 and A1-2](#)
- [Loading Transparencies in Trays A1-1 and A1-2](#)
- [Loading Tab Media in Trays A1-1 and A1-2](#)
- [Loading Postcards in Trays A1-1 and A1-2, and A2-1 and A2-2](#)

#### Trays A1-1 and A1-2 Components



1. Paper Jam and Error Indicator Panel
2. Paper Level Indicators

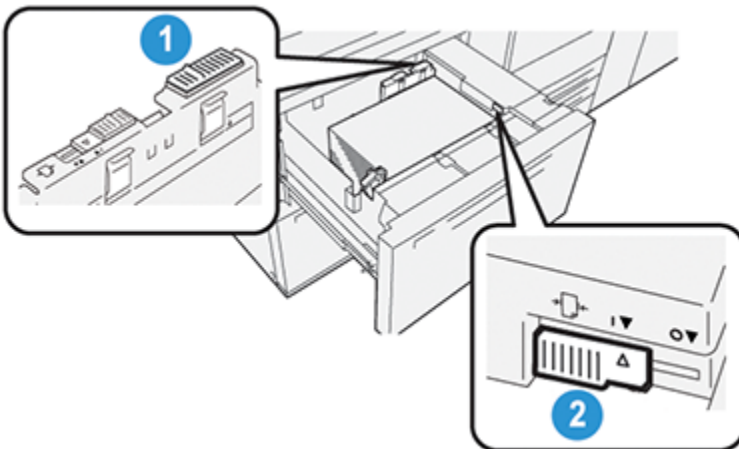
3. Feeder Front Cover
4. Tray A1-1
5. Tray A1-2
6. Circuit Breaker Switch

### Feed Performance in Trays A1-1 and A1-2

If misregistration or skew occurs on printed output that was fed from Trays A1-1 or A1-2, to improve and correct the printed output, manually adjust the paper-feed levers. The default position is **0**.

- ⓘ Important: For most print jobs, keep the levers in their default position. Change the position of the levers only if there is a skew problem when you run a specific print job or stock type. Changing the levers can cause more skew problems when you run certain media types such as coated, label, tab media, hole-punched media, transparency, film, and postcards.

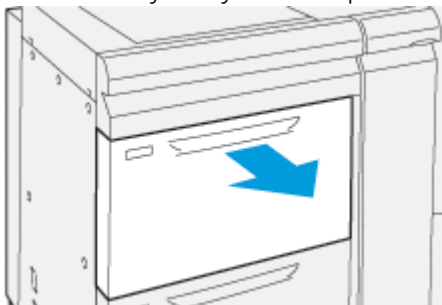
To improve paper-feed accuracy and to reduce paper skew, use the paper-feed adjustment levers located in Trays A1-1 and A1-2.



1. Rear Paper-feed Adjustment Lever
2. Right-side Paper-feed Adjustment Lever

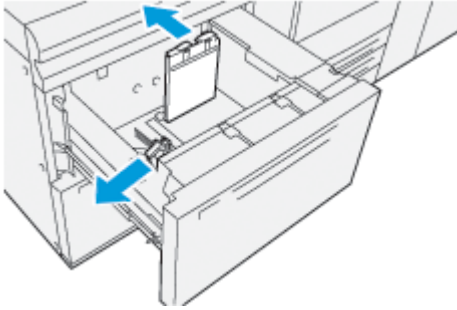
### Loading Paper in Trays A1-1 and A1-2

1. Select the appropriate paper media for your print job.
2. Pull out the tray slowly until it stops.

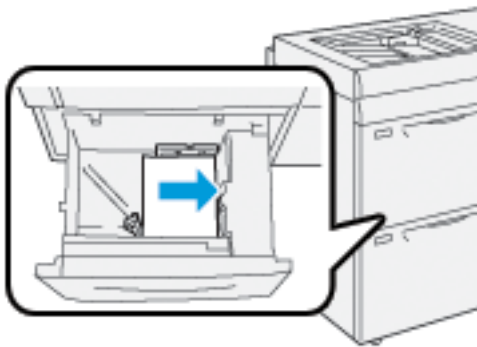


## Working With

3. Open the rear of media with the seam side facing up.
4. Before loading them into the tray, fan the sheets.
5. Extend the paper guides outward until they stop.




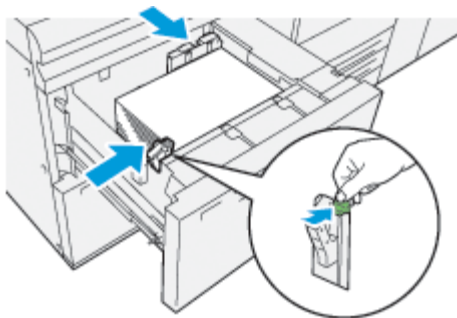
6. Load and align the edge of the paper against the right front corner of the tray.



You can load paper in either the LEF portrait or SEF landscape direction.

7. To adjust the paper guides, press in the guide releases and carefully move the guides until they just touch the edges of the media in the tray.

 Note: Do not load media above the **MAX** line on the guides.



8. Gently push in the tray until it comes to a stop.

The paper Tray Properties window appears on the main screen of the PC UI. You can view and set media attributes and verify that trays are assigned with the correct media.

9. From the Tray Properties window, enter or verify the correct paper information, including size, type, weight and, if necessary, paper curl and alignment option. Select the media and assign the media to the appropriate tray.

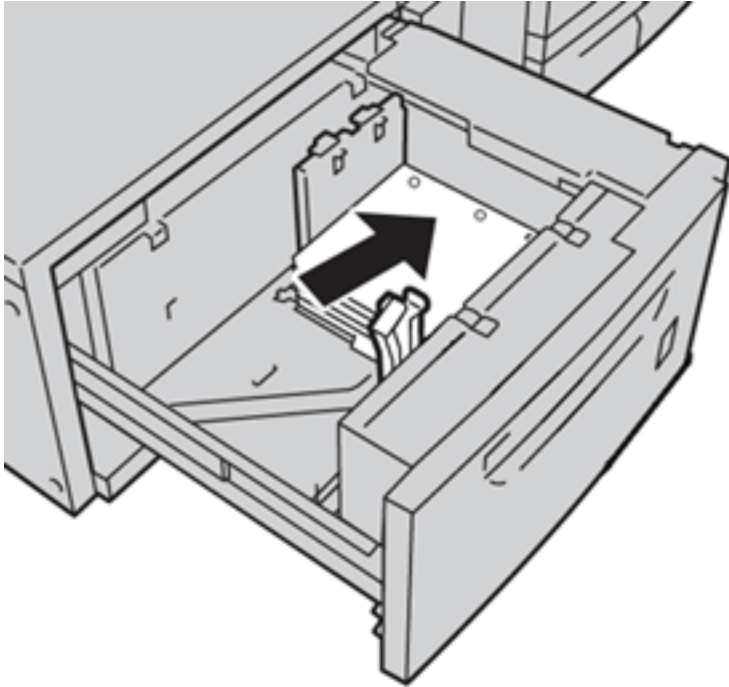


10. To save the information and close the Tray Properties window, select **OK**.

### Loading Hole-Punched Paper in Trays A1-1 and A1-2

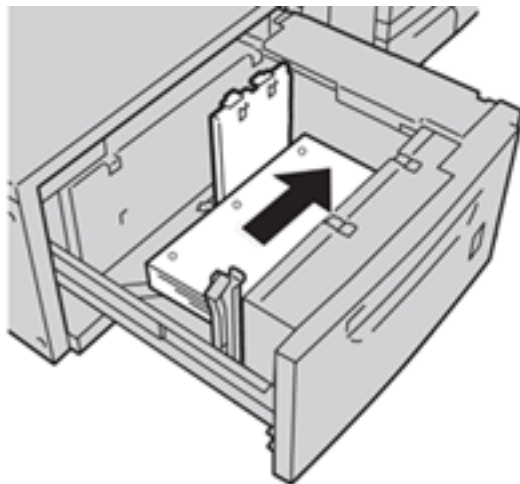
#### Long-Edge Feed (LEF) Direction

For LEF direction, load and align the paper against the right side of the tray.



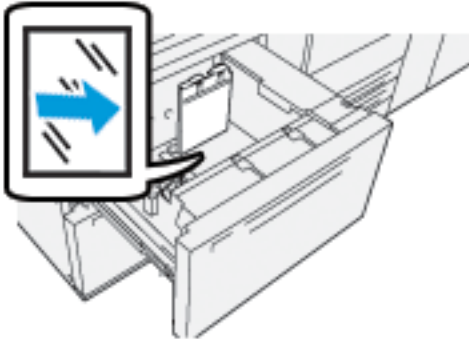
#### Short-Edge Feed (SEF) Direction

For SEF direction, load and align the paper against the right side of the tray.



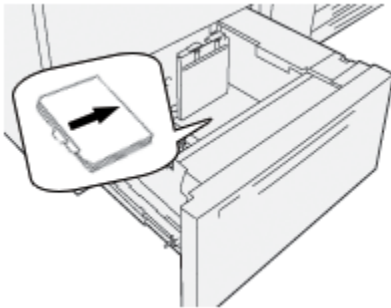
### Loading Transparencies in Trays A1-1 and A1-2

Load the transparencies in the LEF portrait direction and align the edge of the transparencies against the right edge of the tray, with the side to print facing up.



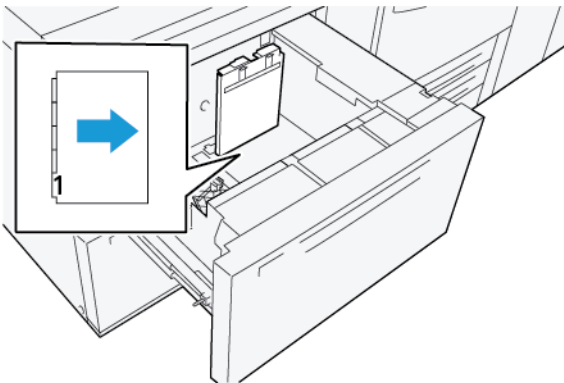
### Loading Tab Media in Trays A1-1 and A1-2

Load the tab media LEF, with the side to print facing down. Align the straight edge of the tab media against the right edge of the tray and the tabs to the left.



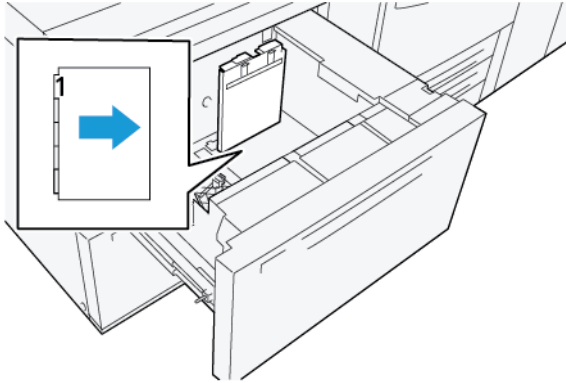
### Loading Straight Collated Tabs

Load straight collated tabs with the first blank tab cutout toward the front of the tray.



### Loading Reverse-Collated Tabs

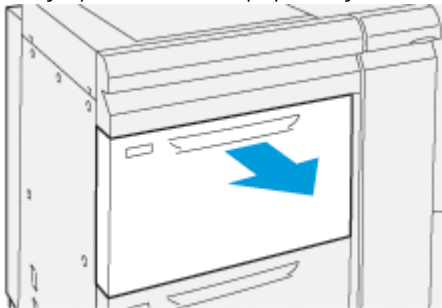
Load reverse-collated tabs with the first blank tab cutout toward the rear of the tray.



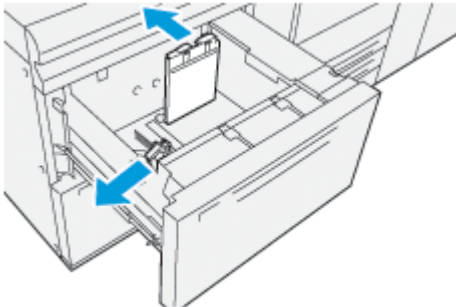
### Loading Postcards in Trays A1-1 and A1-2, and A2-1 and A2-2

 Note: Before printing the postcards, install the postcard bracket. Refer to [Installing and Using the Postcard Bracket](#).

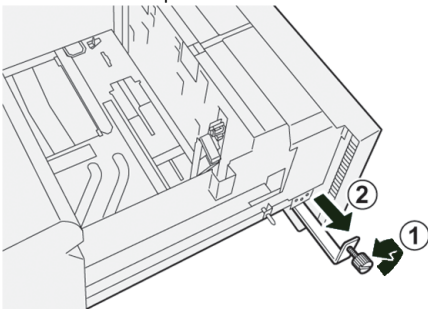
1. Slowly open one of the paper trays until it stops, then remove the media.



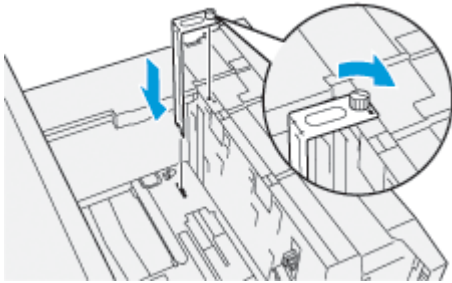
2. Move the paper guides out to their largest position.



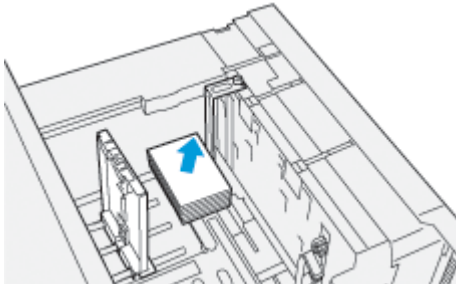
3. To remove the postcard bracket, loosen the screw on the left side of the tray (1) and remove the bracket (2).



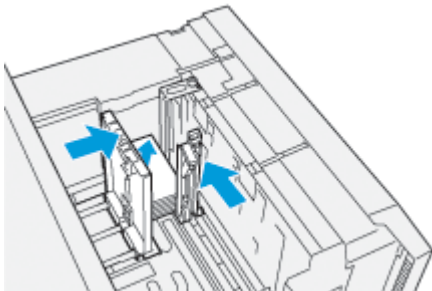
4. Install the postcard bracket:



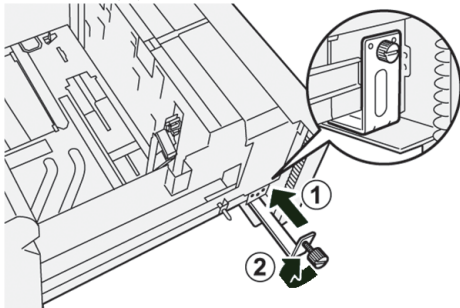
- a. Seat the bracket on the locating pins on the upper frame and in the grooves on the bottom of the tray.
  - b. Tighten the thumb screw so it locks the postcard bracket in place.
5. Load the postcard media SEF and against the right side of the tray.



6. Adjust the paper guides against the media.



7. Close the paper tray, and at the print server, confirm the new settings.
8. Run the print job.
9. Upon completion of the print job, remove the postcard media and the postcard bracket from the tray.
10. Store the postcard bracket by inserting it into the storage area on the left side of the tray (1) and tightening the screw (2).

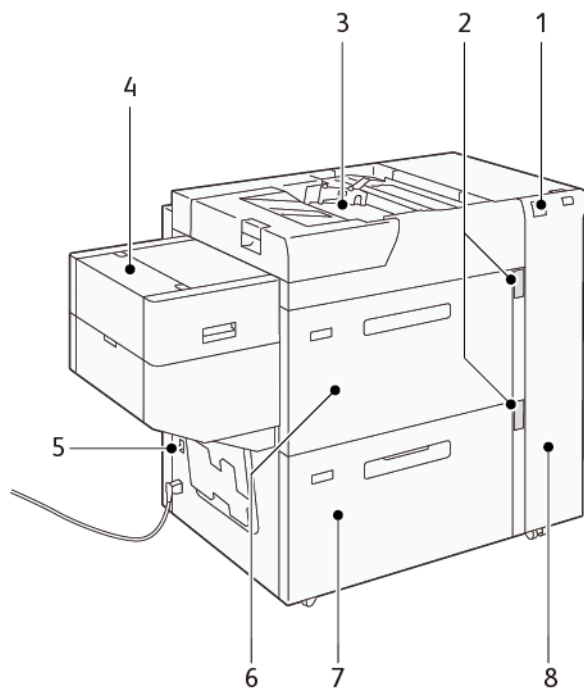


## USING THE HIGH CAPACITY XLS VACUUM FEEDER AND DUAL HIGH CAPACITY XLS VACUUM FEEDER

To load media into Trays A1-1, A1-2, A2-1, and A2-2 of the High Capacity XLS Vacuum Feeder and Dual High Capacity XLS Vacuum Feeder, refer to the following information:

- High Capacity XLS Vacuum Feeder (HCVF) Components
- Dual High Capacity XLS Vacuum Feeder Components
- Circuit Breaker Switch
- High Capacity XLS Vacuum Feeder Specifications
- Paper and Media for High Capacity XLS Vacuum Feeder
- Loading Paper in the High Capacity XLS Vacuum Feeder (HCVF) Trays
- Special Media
- Postcard Setting
- Loading Paper in the Automatic Extra Long Sheet (XLS) Feeder

### High Capacity XLS Vacuum Feeder (HCVF) Components



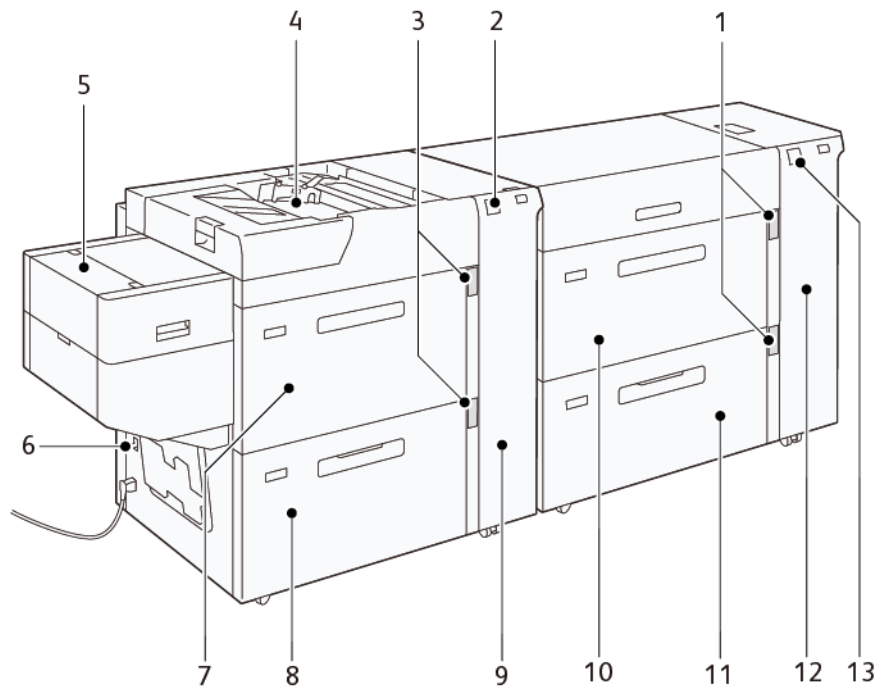
1. Error Indicator
2. Paper Level and Tray in Use Indicator
3. Tray A1-3, Bypass Tray
4. Extra Long Sheet (XLS) Feeder
5. Circuit Breaker Switch

6. Tray A1-1 of High Capacity XLS Vacuum Feeder
7. Tray A1-2 of High Capacity XLS Vacuum Feeder
8. Right Side Cover

The following information applies to the High Capacity XLS Vacuum Feeder:

- When a paper jam occurs, the error indicator illuminates.
- For the paper level indicator, when the corresponding tray is active, the top active indicator illuminates. The four center indicators, 1=25%, indicate the amount of remaining paper. When all four indicators are off, the tray is empty and the Empty Paper Indicator illuminates.
- In the event of fault current or a short circuit, the circuit breaker disconnects the electrical supply to the device automatically.
- To clear paper jams, open the right side cover.

### Dual High Capacity XLS Vacuum Feeder Components

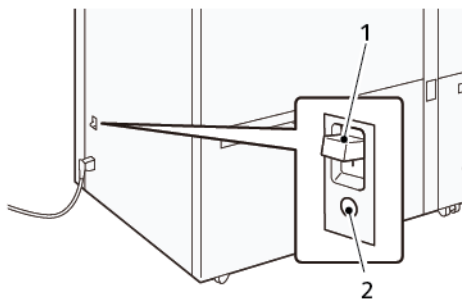


1. Paper Level and Tray in Use Indicator for Trays A1-1 and A1-2
2. Error Indicator for Trays A2-1 and A2-2
3. Paper Level and Tray in Use Indicator for Trays A2-1 and A2-2
4. Tray A2-3, Bypass Tray
5. Extra Long Sheet (XLS) Feeder
6. Circuit Breaker Switch
7. Tray A2-1 of High Capacity XLS Vacuum Feeder
8. Tray A2-2 of High Capacity XLS Vacuum Feeder

9. Right Side Cover for Trays A2-1 and A2-2
10. Tray A1-1 of High Capacity XLS Vacuum Feeder
11. Tray A1-2 of High Capacity XLS Vacuum Feeder
12. Right Side Cover for Trays A1-1 and A1-2
13. Error Indicator for Trays A1-1 and A1-2

### Circuit Breaker Switch

During normal operating conditions, the circuit breaker switch is in the up position. Before you move the HCVF, or if the HCVF is idle for an extended period of time, switch off the circuit breaker. To switch off the circuit breaker, move the switch to the down position.



1. Circuit Breaker Switch
2. Test Button



Note: When a fault is detected, the power to the circuit breaker is disconnected automatically. Do not touch the breakers under normal operating conditions.

### High Capacity XLS Vacuum Feeder Specifications

#### Supported Paper Types and Weights

| TRAYS                                | PAPER SIZES   | WEIGHTS                 |
|--------------------------------------|---|-------------------------|
| Tray A1-3 or Tray A2-3, Bypass Tray* | Standard: <ul style="list-style-type: none"> <li>• Maximum: SRA3 (320 x 450 mm),<br/>320 x 488 mm (12.6 x 19.2 in.)</li> <li>• Minimum: Postcard, 100 x 148 mm (3.9 x 5.8 in.)</li> </ul> | 52–400 g/m <sup>2</sup> |
|                                      | Custom: <ul style="list-style-type: none"> <li>• Width: 98–330.2 mm (3.8–13 in.)</li> <li>• Length: 146–660 mm (5.7–26 in.)</li> </ul>  |                         |

| TRAYS  | PAPER SIZES   | WEIGHTS                 |
|--|---|-------------------------|
| HCVF Tray A1-2, or<br>Dual HCVF Trays A1-1, A1-2, and A2-2   | Standard: <ul style="list-style-type: none"> <li>Maximum: SRA3 (320 x 450 mm),<br/>320 x 488 mm (12.6 x 19.2 in.)</li> <li>Minimum: Postcard, 100 x 148 mm (3.9 x 5.8 in.)</li> </ul> | 52–400 g/m <sup>2</sup> |
|  | Custom: <ul style="list-style-type: none"> <li>Width: 98–330.2 mm (3.8–13 in.)</li> <li>Length: 148–488 mm (5.8–19.2 in.)</li> </ul>  |                         |
| Extra Long Sheet (XLS) Feeder  | Standard: <ul style="list-style-type: none"> <li>Maximum: SRA3 (320 x 450 mm),<br/>320 x 488 mm (12.6 x 19.2 in.)</li> <li>Minimum: A4 (210 x 297 mm), 8.3 x 11.7 in.</li> </ul>      | 52–400 g/m <sup>2</sup> |
|  | Custom: <ul style="list-style-type: none"> <li>Width: 210–330.2 mm (8.2–13 in.)</li> <li>Length: 210–1200 mm (8.2–47.2 in.)</li> </ul>  |                         |
| * If the press is equipped with a Dual High Capacity XLS Vacuum Feeder, the Bypass Tray is installed on the second HCVF. |   |                         |

### High Capacity XLS Vacuum Feeder Tray Capacity

- Tray A1-3 or Tray A2-3, Bypass Tray: 250 sheets
- HCVF Trays A1-2 or Dual HCVF Trays A1-1, A1-2, and A2-2: 2100 sheets for each tray
- Extra Long Sheet (XLS) Feeder: 700 sheets



Note: The values are based on 90 g/m<sup>2</sup> paper.


### Paper and Media for High Capacity XLS Vacuum Feeder




Important:



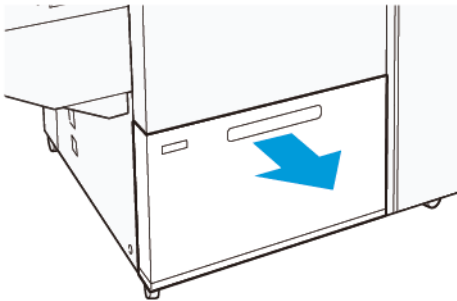
- Loading paper above the maximum fill line can cause paper jams or device malfunctions.
- Position the guides correctly to match the paper size. Incorrectly positioned guides can cause misfeeds and paper jams.
- When the power is reconnected while the bottom plate of the tray is rising, it is possible that the plate does not continue to move up. In this case, pull out the tray, ensure that the plate lowers fully, then push the tray into the machine slowly and firmly.

 Note: When paper sheets are loaded or fed, the tray makes a sound of supplying air. This sound is caused by the Air Assist function and not an abnormal noise.

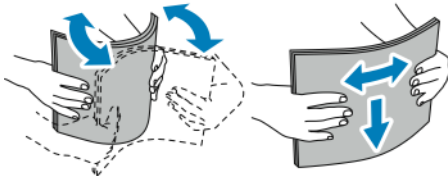
### Loading Paper in the High Capacity XLS Vacuum Feeder (HCVF) Trays

 Important: If fewer than 100 sheets of paper are loaded, the tray guides apply too much pressure to the paper, which causes the paper to be skewed. Skewed paper leads to paper jams.

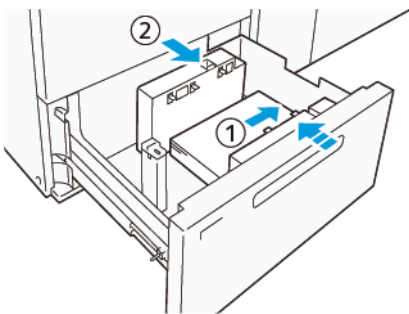
1. Pull out the tray toward you until it stops.



2. Remove any paper remaining in the tray.
3. Flex the sheets back and forth and fan them, then align the edges of the stack on a level surface. This procedure separates any sheets that are stuck together and reduces the possibility of paper jams.

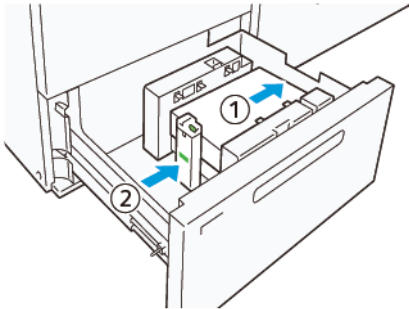


4. Load 100–500 sheets of paper. For preprinted media, load the paper with the printed side facing up.



- a. Align the edges of the paper against the right edge of the tray (1). Paper can be loaded in the long-edge-feed (LEF) or portrait direction, or in the short-edge-feed (SEF) or landscape direction.

- b. To adjust the paper guides, press in the guide release lever and move the guides carefully until they touch lightly the edges of the paper in the tray (2).
5. Load the remaining sheets into the tray, then align the paper edges in the direction shown (1). To adjust the paper guides, press in the guide release lever and move the guides carefully until they touch lightly the edges of the paper (2).

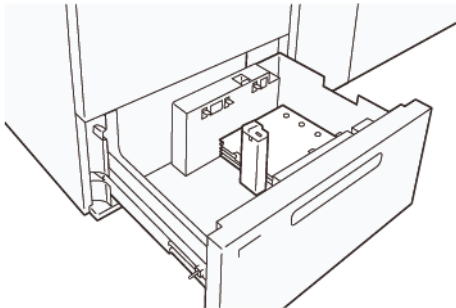


6. Gently push the tray into the press until it stops.

### Special Media


#### Hole-Punched Paper

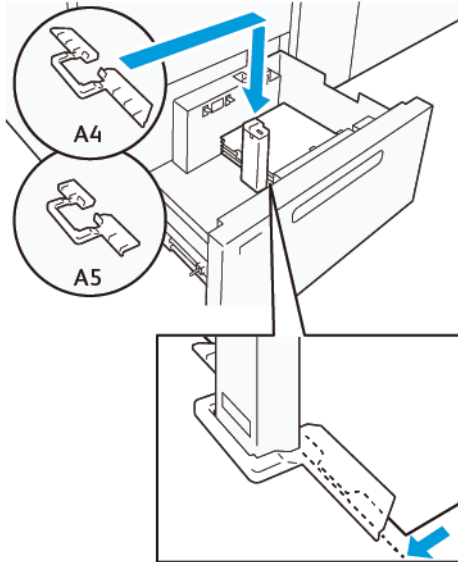
For hole-punched paper, place the paper with the holes to the right when you face the front side of the High Capacity Vacuum Feeder (HCVF).



#### Precut Tabs

For precut tabs, place the paper with the tabs to the left when you face the front side of the HCVF. After you load the paper, install the appropriate tab guide on the end guide, at the short edge of the paper.

 Note: Ensure that the tabs of the precut tab fit the notch of the tab guides.

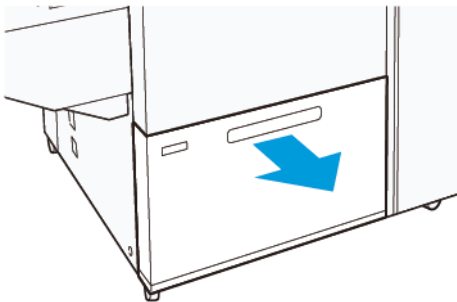


### Postcard Setting

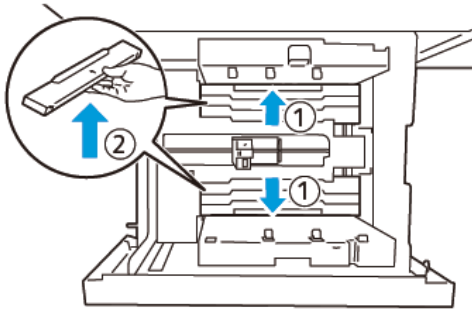
To load paper size 98–181.9 mm portrait or smaller, attach the Postcard Kit to the High Capacity Vacuum Feeder (HCVF) tray. The Postcard Kit can be used in the HCVF trays only. You cannot use the Postcard Kit with Extra Long Sheet (XLS) Trays.

The following procedure defines how to load paper using postcard guides.

1. Pull out the tray toward you until it stops.

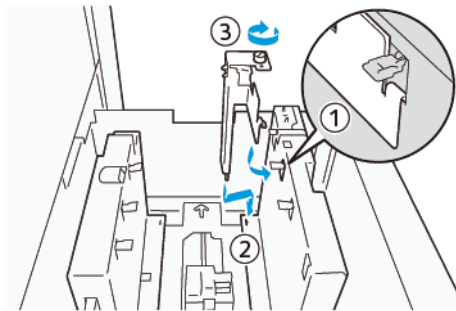


2. Remove any paper that remains in the tray.
3. To install the Postcard Kit, remove the postcard guides from their storage area.
4. Remove the shutters.
  - a. Fold the shutters (1).
  - b. Lift the stack of shutters and remove them (2).

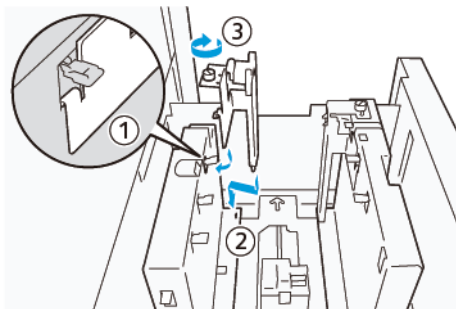


5. Insert guide B into the slits on the side (1) and bottom (2) of the tray. Tighten the screw to secure the guide (3).


**Caution:** If the screw is not tightened fully, it can come off and hit the transport device, which can result in breakage of the transport device.

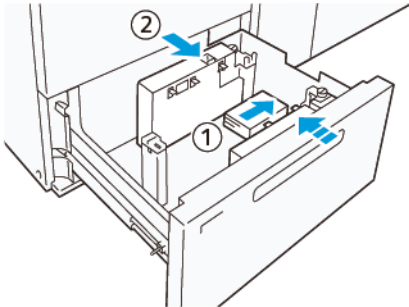


6. Insert the guide A into the slit on the interior (1) and the bottom (2) of the tray. Tighten the screw to secure the guide (3).

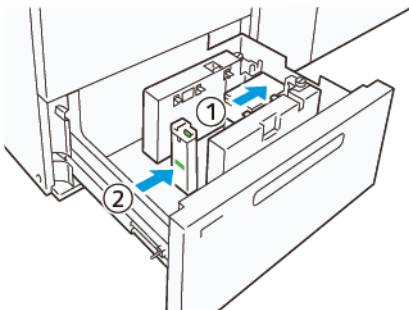


7. Load 100–500 sheets of paper, then align the paper edges in the direction shown (1). For preprinted media, load the paper with the printed side facing up. Hold the side guides by its grip, then move them to touch the long edges of the paper lightly (2).

 Note: Ensure that you load the paper in the short-edge-feed (SEF) direction. The right side of the short edge of the postcard is the leading edge (1).




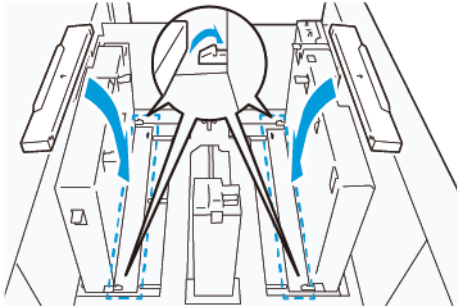
8. Load the remaining sheets in the tray.
  - a. Align the paper edges in the direction shown (1).
  - b. Move the end guide to touch the short-edges of the paper lightly (2).  
Adjust the paper guides by pressing in the guide release lever and carefully moving the guides until they touch the edges of the paper lightly.




9. Gently push the tray into the press until it comes to a stop.
10. To remove and store the postcard guides, perform the following:
  - a. Remove any paper from the tray.
  - b. Unfasten the screw from the postcard guide.

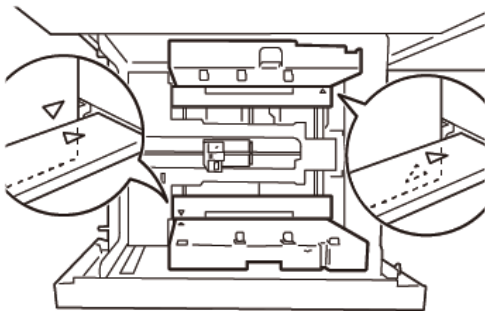
11. After removing the postcard guides, place the shutters in their original positions, then expand them.

 Note: Hang the edges of the shutters on the beveled shutter retainers on both ends of the adjustable side guide. Confirm that they are fixed firmly.





12. Store the postcard guides in their storage area.

 Note: Align the triangular marks so that the shutters can be mounted in the correct orientation. In the following image, the mark on the guide at the top edge of the paper is not visible, and the mark on the guide at the bottom edge of the paper is shown in the correct state.



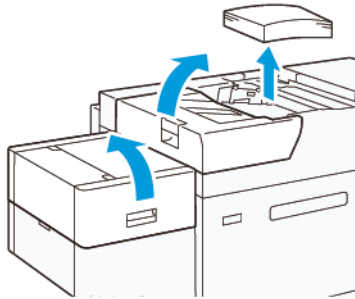
### Loading Paper in the Automatic Extra Long Sheet (XLS) Feeder

 **Caution:** If fewer than 100 sheets are loaded in the Extra Long Sheet (XLS) Feeder tray, the paper guides apply more pressure to the paper. This pressure can distort the paper, which causes paper jams. For example, loading 10–20 sheets of 864 mm (34 in.) or longer paper can cause paper jams.

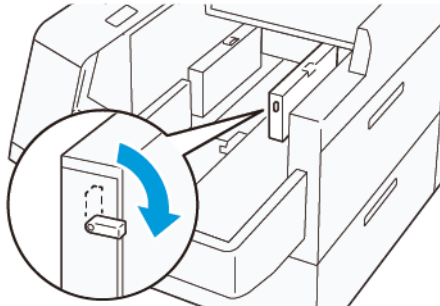
 Note: The Postcard Kit for High Capacity XLS Vacuum Feeder (HCVF) cannot be used with the Extra Long Sheet (XLS) Feeder tray.

### Loading 488 mm (19.21 in.) or Smaller Paper

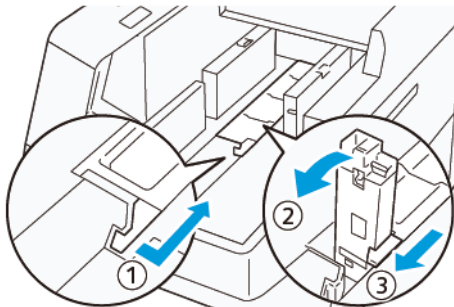
1. Remove the paper from the bypass tray, then open the two covers.



2. On the left of the side guides at the long edge of the paper, lower the lever. Remove any paper remaining in the tray.



3. If the end guide is stored, open the end guide shutter, then rotate the end guide to latch in the vertical position.



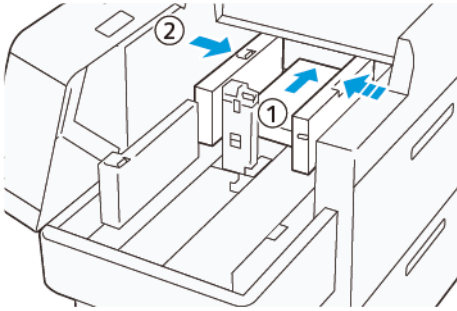
- a. Pinch the lever and open the shutter (1).
- b. Hold the paper guide and pull it up (2). Pull the paper guide toward you until it clicks in place.
- c. Pinch the lever (3) and close the shutter.



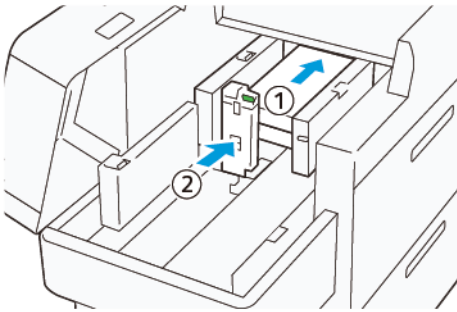
**Caution:** Do not hold the paper guide clip to pull up the paper guide. The guide clip can break.

## Working With

4. Load 100–500 sheets of paper with the paper edges aligned in the direction shown (1). For preprinted media, load the paper with the printed side facing up. Hold the side guides by its grip, then move it to touch the edges of the paper lightly (2).



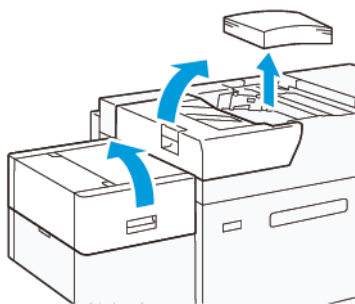
5. Load the remaining sheets into the tray, then align the paper edges in the direction shown (1). Move the end guide to touch the edges of the paper lightly (2). Adjust the paper guides by pressing in the guide release lever and carefully moving the guides until they touch the edges of the paper lightly.



6. Close the two covers.

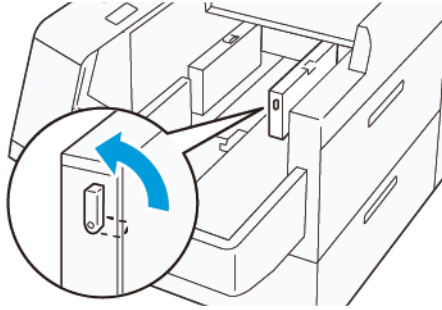
### Loading 488.1–864 mm (19.21–34.0 in.) Paper

1. Remove the paper from the bypass tray, then open the two covers.

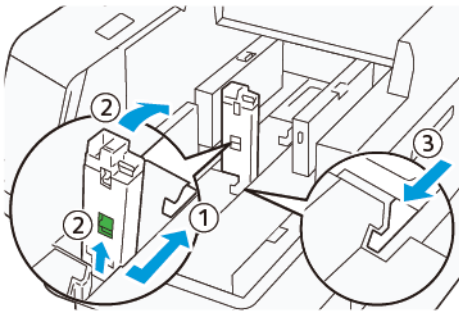




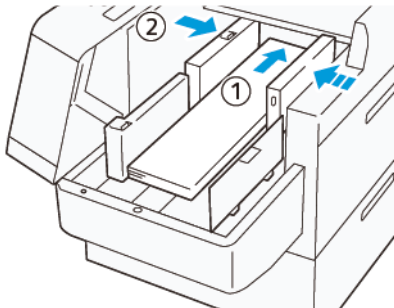
2. Lift the lever on the left of the side guide. Remove any paper that remains in the tray.



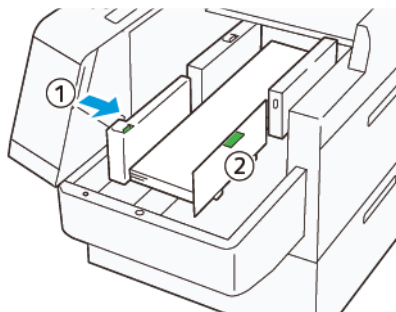
3. If the end guide is standing, store it:



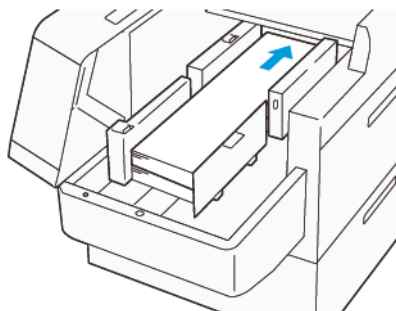
- a. Pinch the lever and open the shutter (1).
  - b. Hold the release lever and lay down the paper guide (2).
  - c. Pinch the lever (3) and close the shutter.
4. Load about 100 sheets of paper with the paper edges aligned in the direction shown (1). For preprinted media, load the paper with the printed side facing up. Hold the side guide by its grip, then move it to touch the edges of the paper lightly (2).



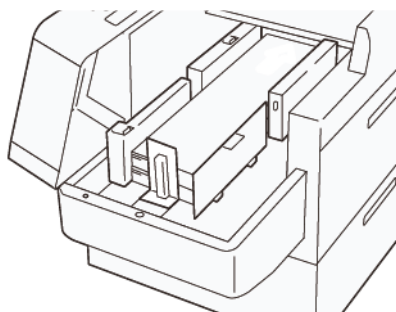
5. Hold the XLS rear-side guide by its grip, then move it to touch the edges of the paper lightly (1). Place the XLS front side guide to fit the loaded paper (2).  
The XLS front side guide is removable. Install the front side guide in the direction that ensures that the metal surface touches the paper.



6. Load the remaining sheets in the tray, then align the paper edges in the direction shown.



7. Place the rear XLS end guide to fit the loaded paper.  
The rear end guide is removable. Install the rear end guide in the direction that ensures that the metal surface touches the paper.

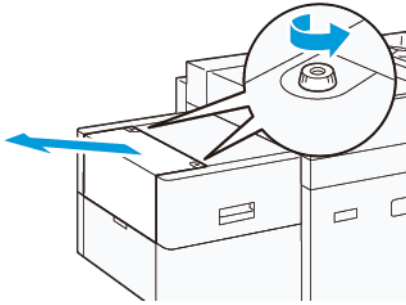


8. Close the two covers.

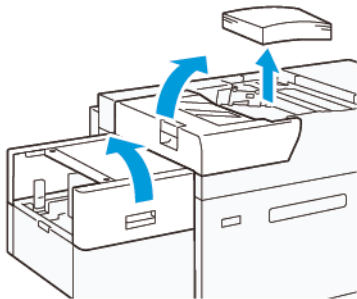
#### **Loading 864.1 mm (34.02 in.) or Larger Paper**

You can load a maximum of 100 sheets of 864.1 mm (34.02 in.) or larger, 90 g/m<sup>2</sup> paper.

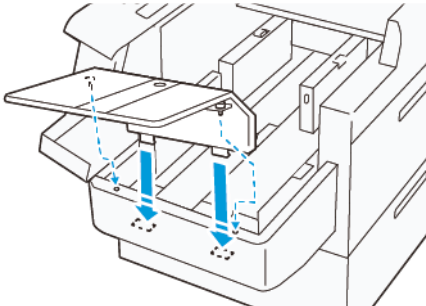
1. Unfasten and remove the screws on the top of the left side cover. Remove the cover.



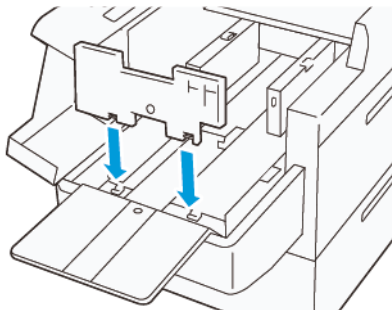
2. Remove the paper from the bypass tray, then open the two covers.



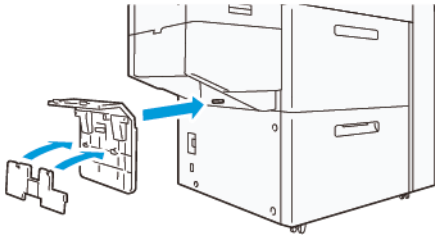
3. Attach the XLS extension tray and the extension plate.
  - a. Insert the XLS extension tray, then tighten the screws to secure it, as shown.



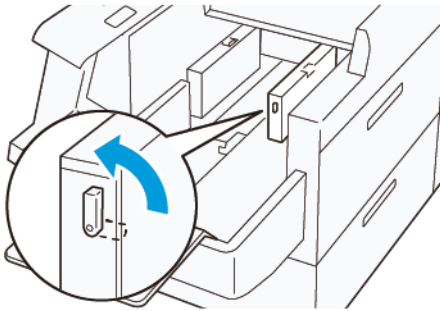
- b. Insert the XLS extension plate.



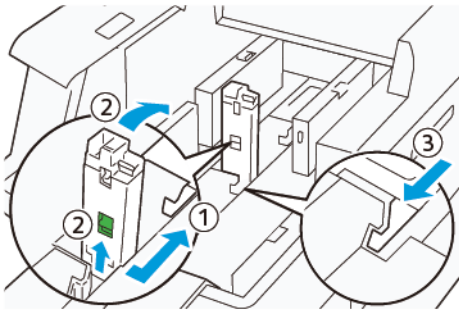
- c. When not in use, hang the parts on the holder of the lower part.



- 4. Lift the lever on the left of the front side guide. Remove any paper that remains in the tray.

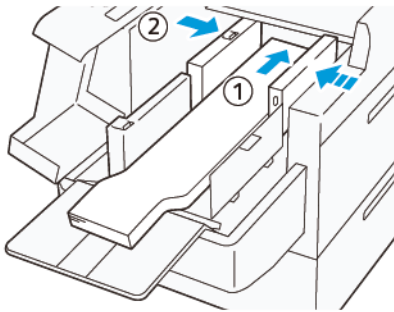


- 5. If the end guide is standing, store it:

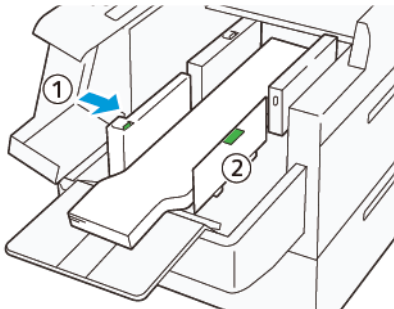


- a. Pinch the lever and open the shutter (1).
- b. Hold the release lever and lay down the paper guide (2).
- c. Pinch the lever (3) and close the shutter.

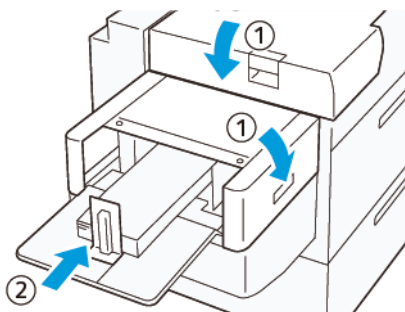
6. Load 100 or less sheets of paper with the paper edges aligned in the direction shown (1). For preprinted media, load the paper with the printed side facing up. Hold the rear-side guide by its grip, then move it to touch the edges of the paper lightly (2).



7. Hold the XLS rear-side guide by its grip, then move it to touch the edges of the paper lightly (1). Place the XLS front side guide to fit the loaded paper (2). The XLS front side guide is removable. Install the front side guide in the direction that ensures that the metal surface touches the paper.



8. Close the two covers (1), then wait until the bottom plate rises. Place the XLS end guide to fit the loaded paper (2). The XLS end guide is removable. Install the end guide in the direction that ensures that the metal surface touches the paper.



## EZ-Swap Color Housings

The press has two color stations for Specialty Dry Inks: Stations 1 and 6. These two stations allow you to load up to two Specialty Dry Inks at a time.

To change from one Specialty Dry Ink to another, perform the EZ-Swap Specialty Dry Ink Color Housings procedure. This process involves both removing and replacing the dry ink/toner loaded in Stations 1 or 6.

[Removing the Specialty Dry Ink in Stations 1 or 6](#)

[Replacing the Specialty Dry Ink in Stations 1 or 6](#)

### REMOVING THE SPECIALTY DRY INK IN STATIONS 1 OR 6



**Caution:** Before you perform this procedure, ensure that the press is powered off.



**Caution:** When you perform this procedure, wear protective gloves. Failure to use gloves can result in image quality issues related to the Drum Module.



**Caution:** The drums are highly light-sensitive. Ensure that the drums are protected from light.

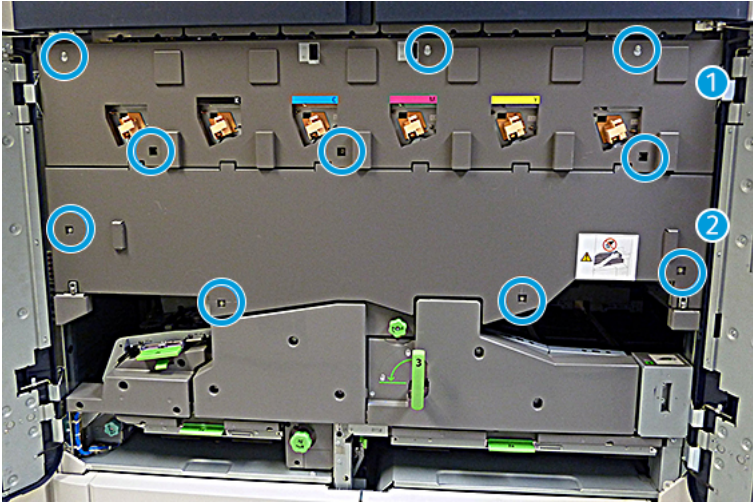


**Caution:** Do not remove any parts or assemblies, attempt any steps, or use the Xerox-provided Torx driver other than described in this procedure. If the customer performs a prohibited procedure, the customer waives all claims that arise from doing so and Xerox disclaims any liability. The prohibited removal of parts or assemblies and prohibited use of the Torx driver is included.



Note: The entire procedure to remove and replace the dry ink/toner in Stations 1 or 6 requires two carts. For the removal procedure, position an empty storage cart close to the press. Place any screws removed during the procedure in the cart tool bin.

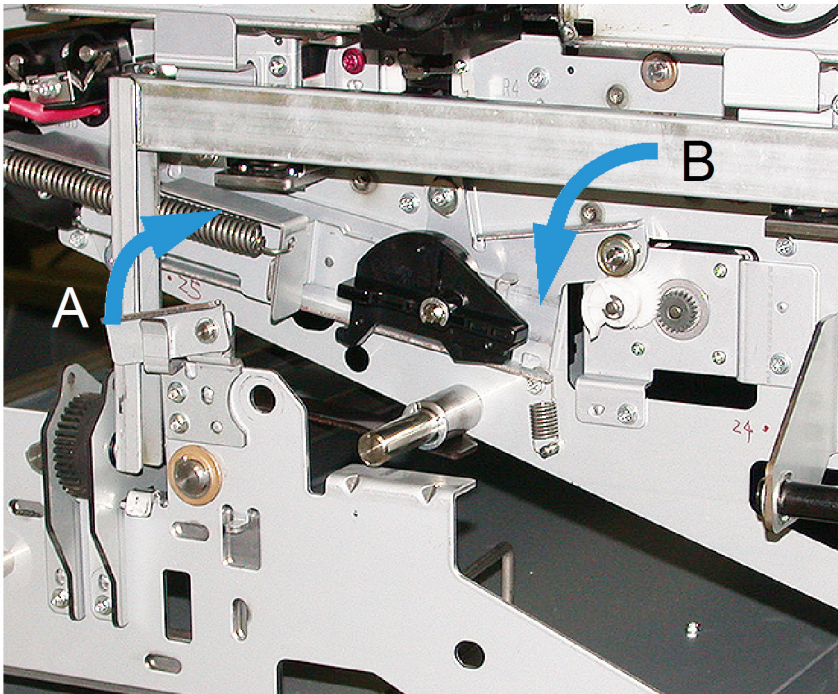
1. Power off the press.
2. Open the left, front doors of the press.
3. Remove the Xerographic Marking Module Cover (1) and the IBT Front Cover (2):
  - a. Loosen the three upper screws and the three lower screws of the Xerographic Marking Module Cover. Remove the Module Cover (1).
  - b. Loosen the four screws of the IBT Front Cover. Remove the Front Cover (2).



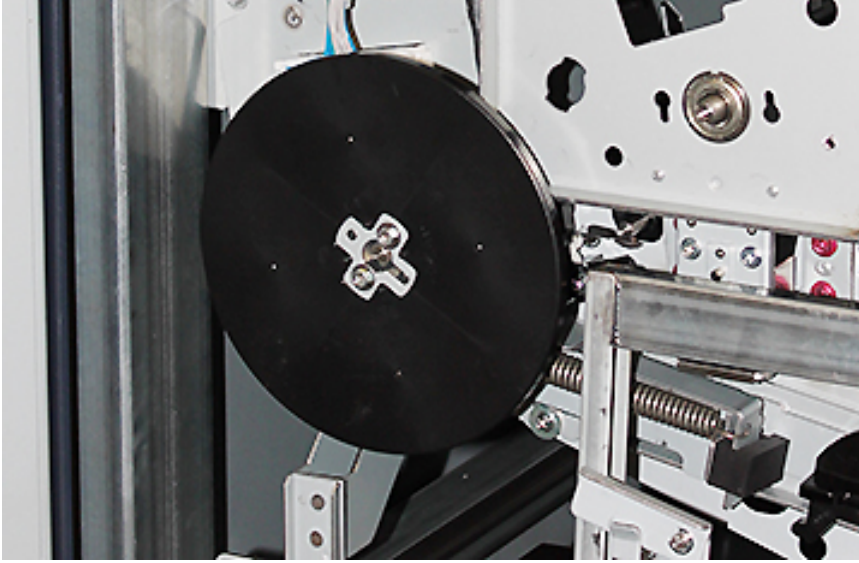
1 Xerographic Marking Module Cover

2 IBT Front Cover

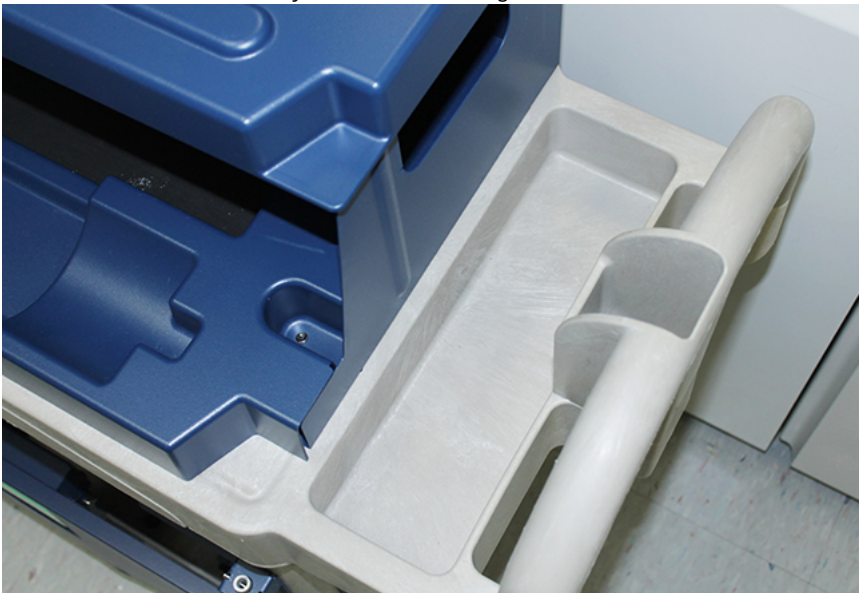
4. Unlatch the Paper Path Module by setting the green Locking Handle 3 to the Unlock position.
5. Unlatch the Transfer Drawer by rotating the Restraining Latch (A) clockwise and pulling down on the Latch Bar (B).



6. Before performing this step, use the black light shield curtain. If you change the dry ink/toner in Station 6, remove the two screws on the Flywheel, then remove the Flywheel.

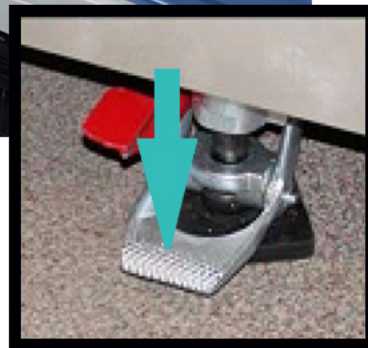
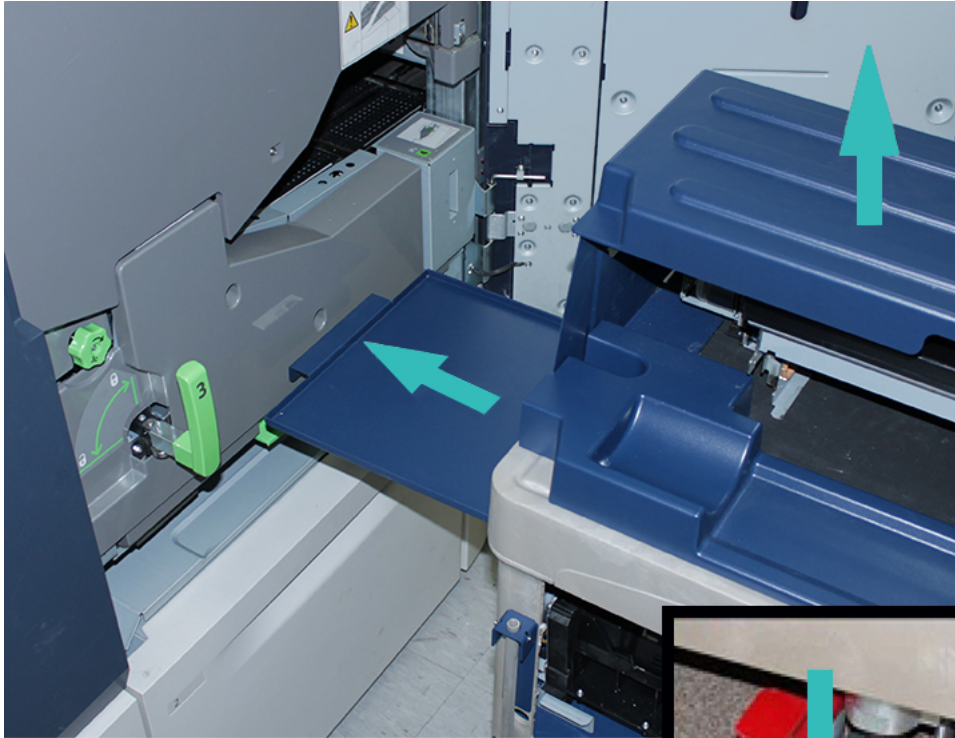



7. Place the screws and the Flywheel in the storage cart bin.





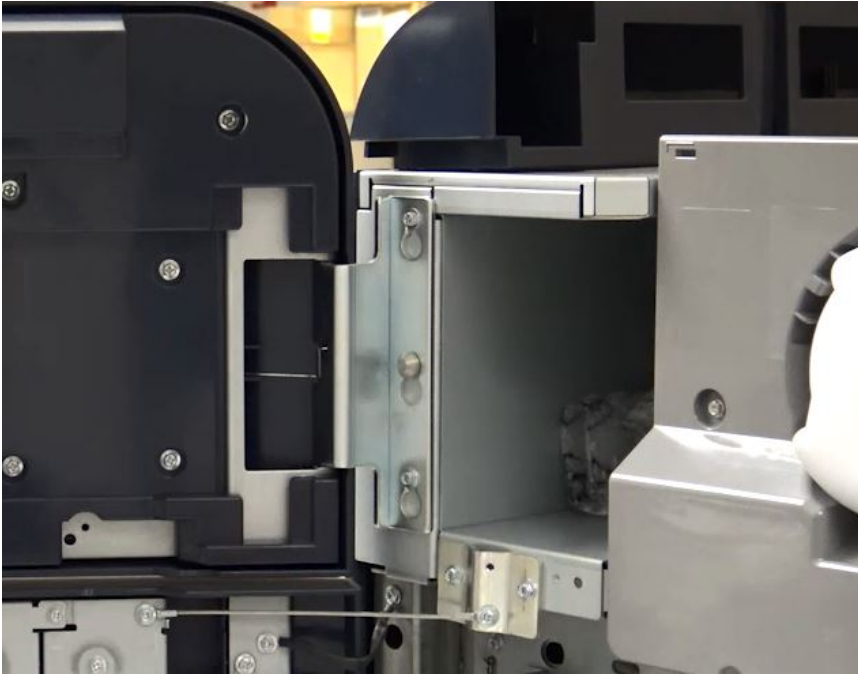
8. Position the empty storage cart in front of Station 1 or 6. To catch excess dry ink/toner, extend the tray, then raise the top cover of the cart.



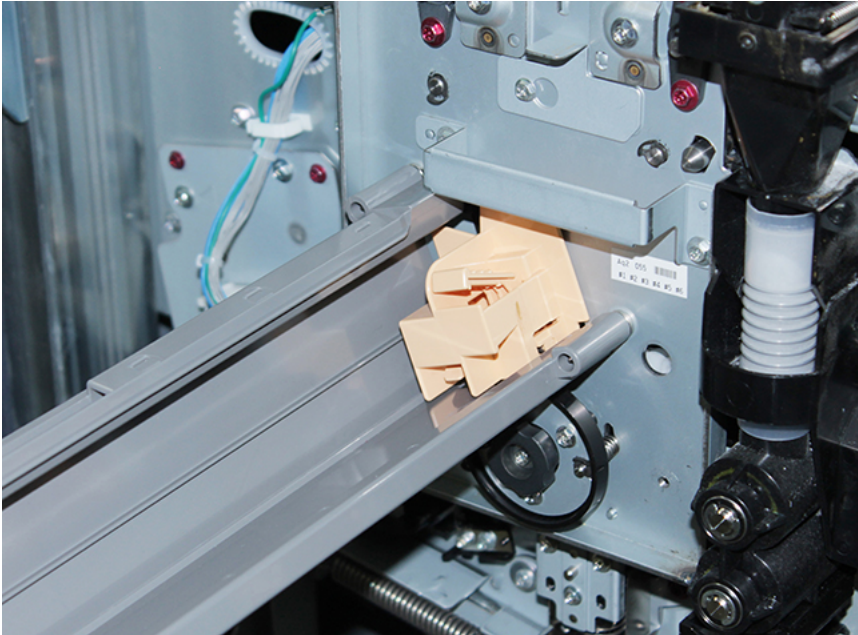
 **Caution:** In the following step, when you push down to engage the Foot Brake, use caution.

9. To prevent the cart from moving, press down on the cart Foot Brake.

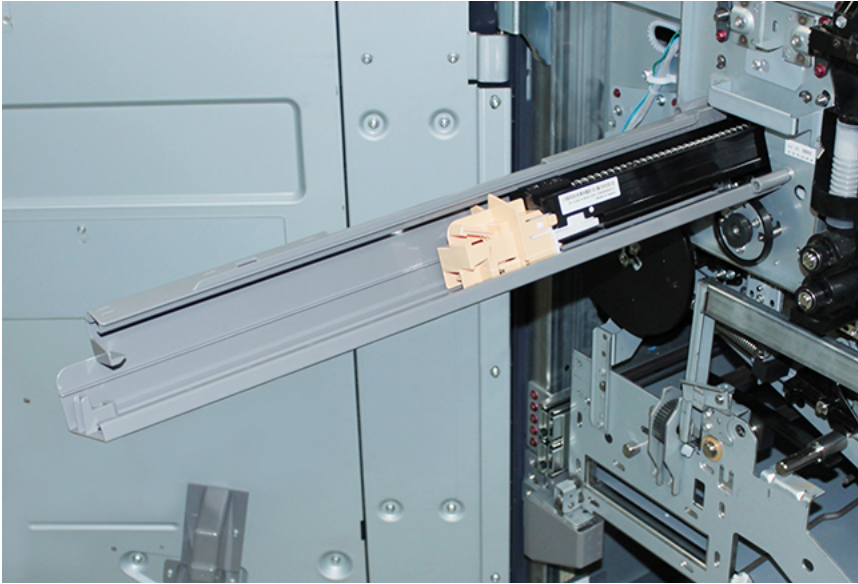
10. Open the top, left dry ink door of the press. From the top left compartment, retrieve the Corotron Assist Tool.



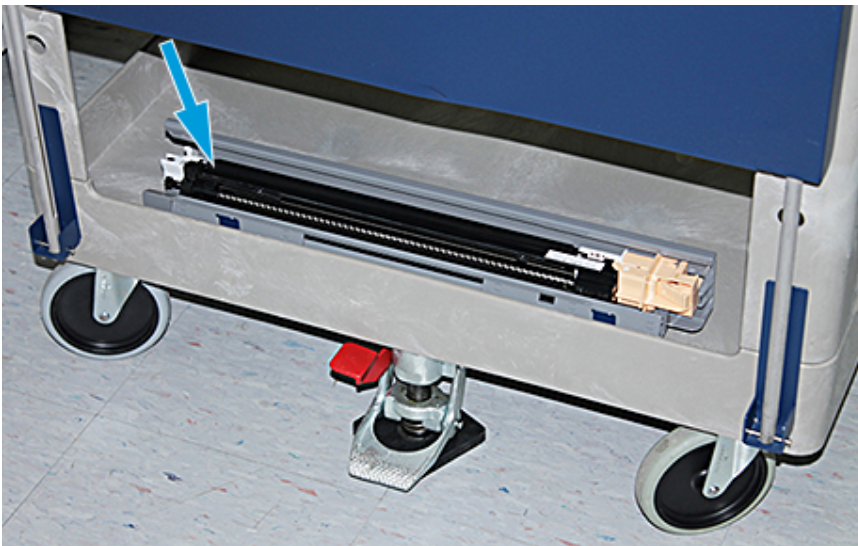
11. On the Xerographic Marking Module faceplate, push the Corotron Assist tool onto the two pins.




12. To unlatch and release the Charge Corotron, press down on the tab and pull the corotron out of the press.

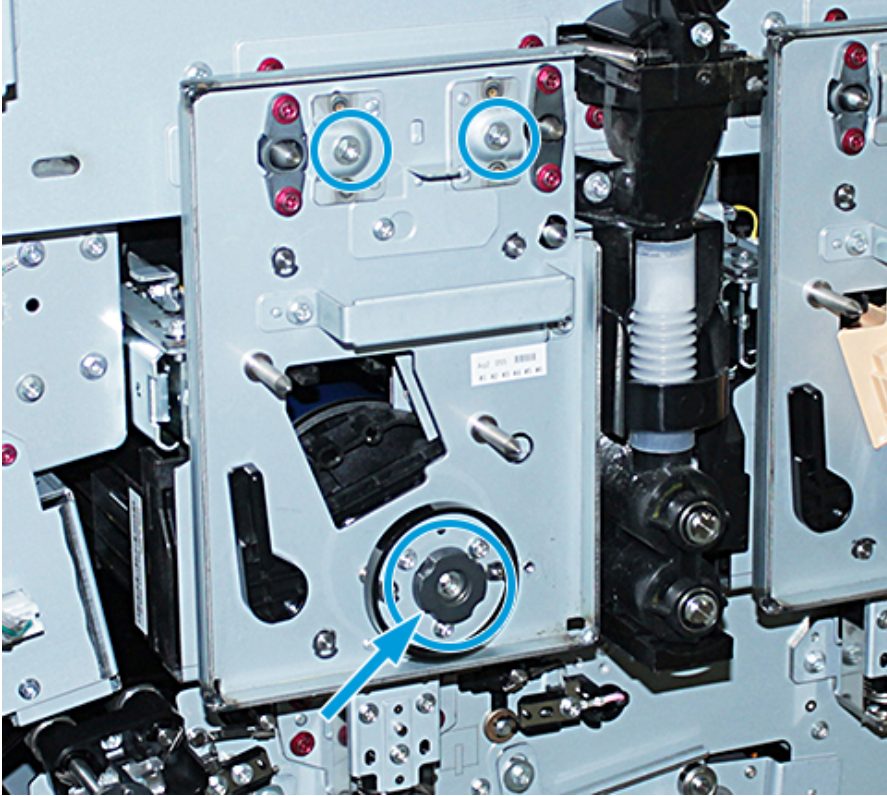


13. Place the Charge Corotron with the Corotron Assist Tool on the storage cart.

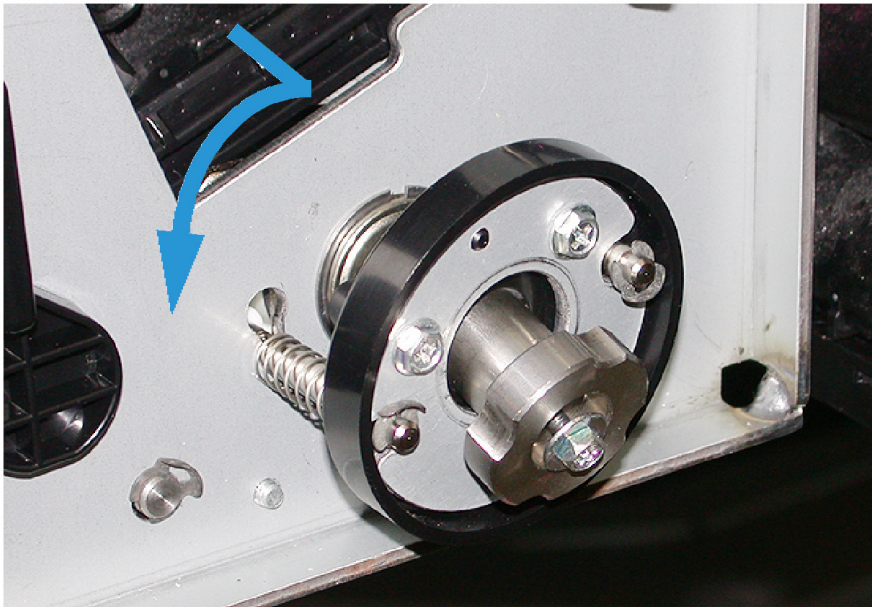


 **Caution:** To prevent damage to the Drum and to prevent the Drum from turning, hold the knob assembly when loosening the lower screw.

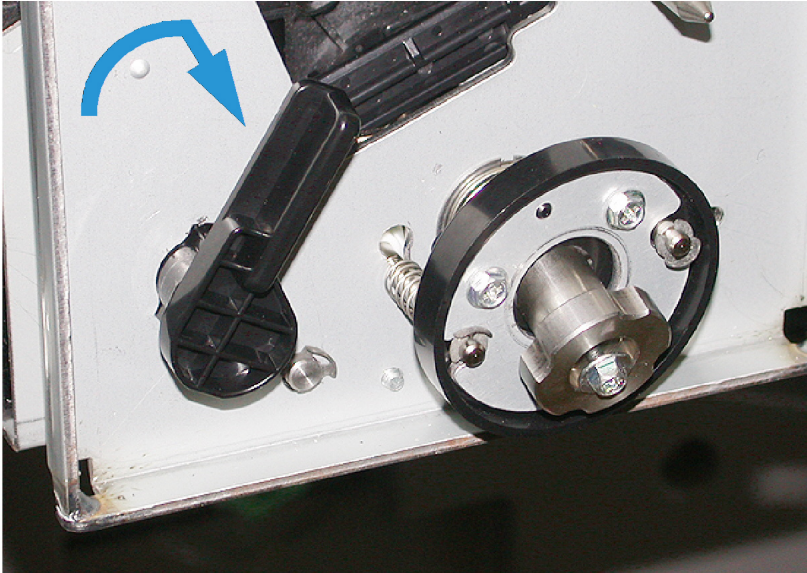
14. There are three Xerographic Marking Module screws. Loosen the two screws at the top and, while holding the Knob Assembly, loosen the lower screw inside the knob assembly.



15. To disengage the Front Drum Guide from the Drum Cartridge, pull the Guide toward the front of the press and rotate it counterclockwise.



16. Slide out the marking module to the service position. Rotate the Drum Cartridge Retaining Latch clockwise and pull it toward the front of the press.

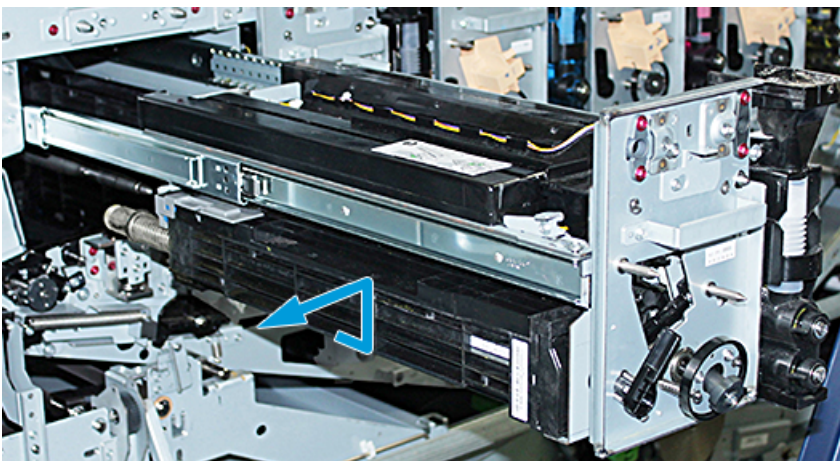


17. From the top left compartment behind the dry ink door, locate and retrieve the protective, black bag.

**!** **Caution:** To prevent light shock to the Drum Cartridge, do not expose the Drum Cartridge to light for longer than one minute. Immediately after you remove the Drum Cartridge, place the cartridge in the protective bag.

**!** **Caution:** Do not slide the Xerographic Marking Module out of the press until you are fully ready to remove the Drum Cartridge.

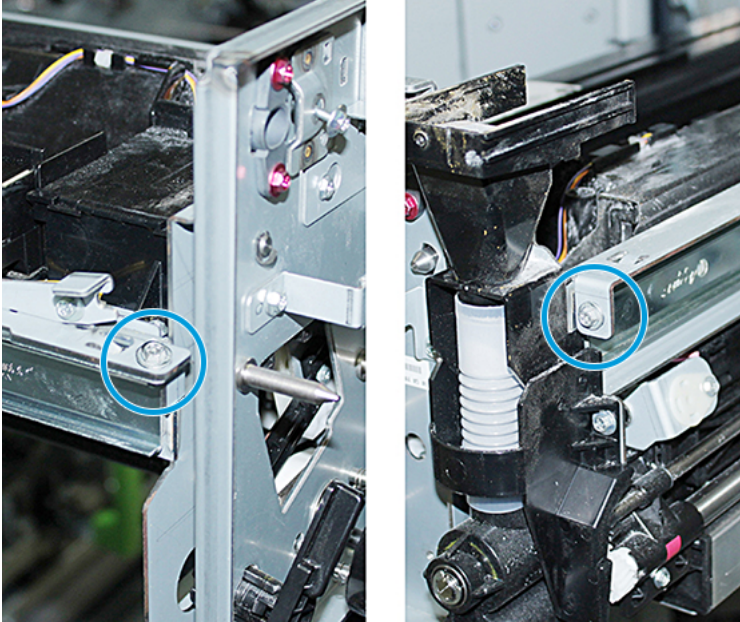
18. Grab the handle and pull the Xerographic Marking Module out to the Service position.
19. To remove the Drum Cartridge, stand at the side of the Xerographic Marking Module. Move the Drum Cartridge toward the front of the Xerographic Module, then up and out the side of the Module.



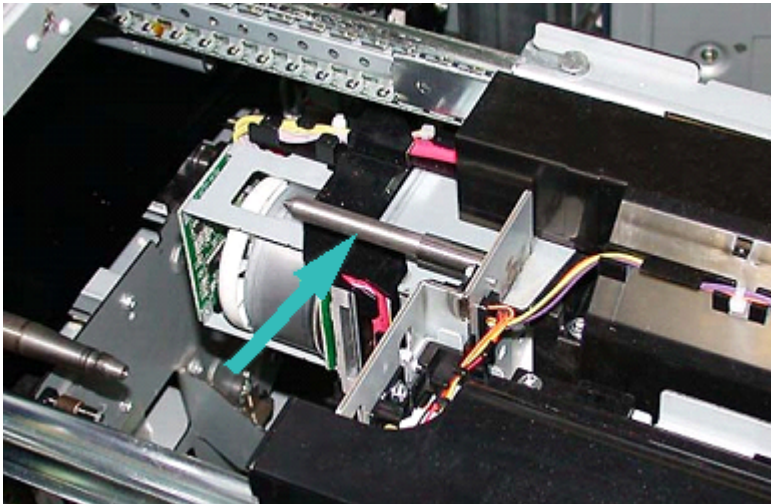
20. Immediately place the Drum in the protective, black bag. To prevent damage to the Drum Cartridge, place the flat side of the Drum facing down on the storage cart.



21. Remove the shoulder screw on each of the Xerographic Marking Module rails. Place the screws in the tool bin of the storage cart.



**!** **Caution:** When lifting the Xerographic Marking Module, do not lift using the Locating Pin.

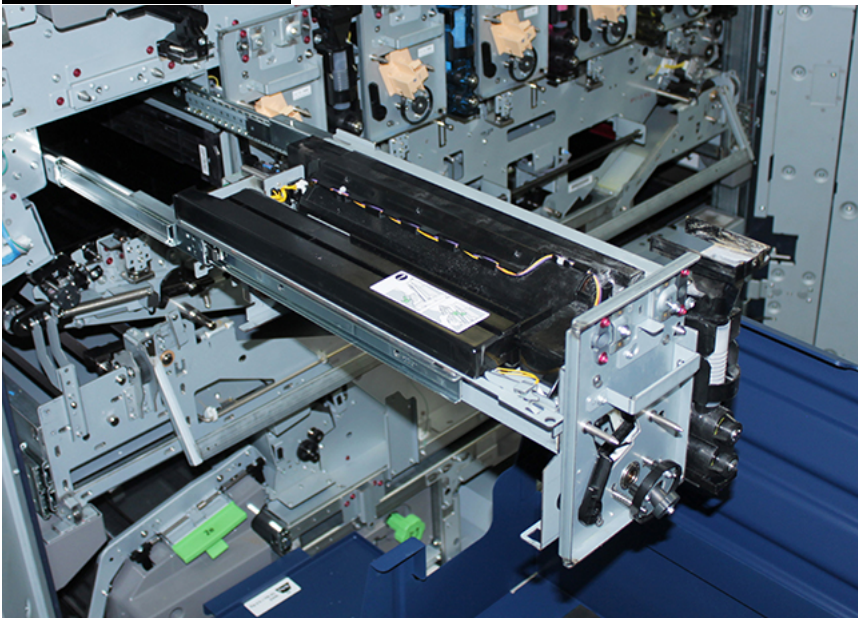
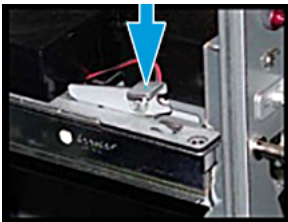


**!** **Caution:** Due to the height and weight of the Module, use a step stool to perform the following procedure.

22. Place the step stool in front of the cart and press.



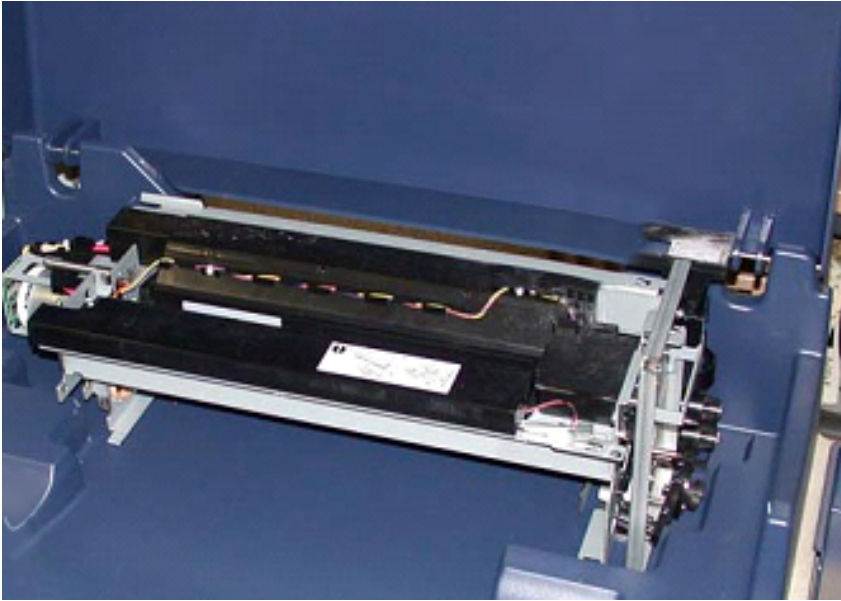
23. While pushing down on the rail latch, lift the front of the assembly, and slide it forward.



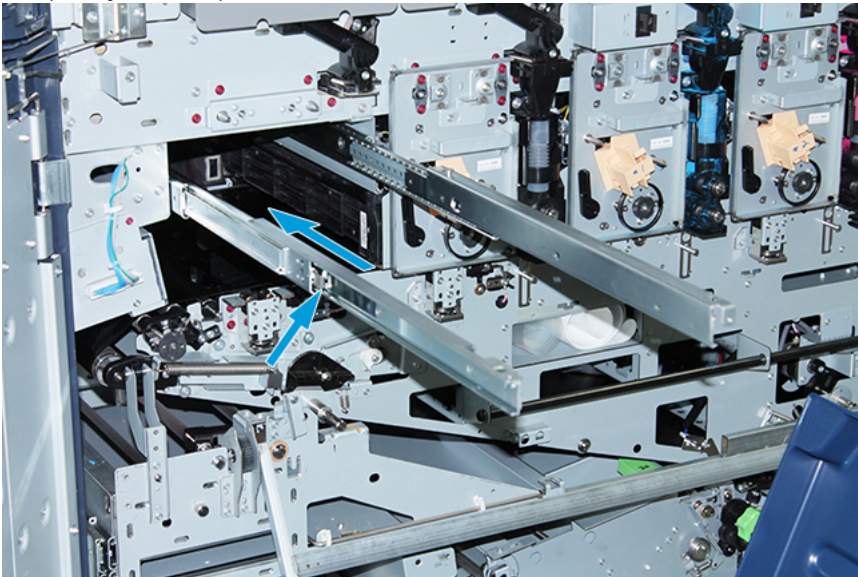
**Caution:** The Developer Housing weighs approximately 4.5 kg (10 lbs.).



24. Use both hands to lift and remove the Xerographic Marking Module. Place it on the storage cart.



25. At the press, on the side of each rail, release the Xerographic Marking Module rail tab, then push the rails completely into the press.



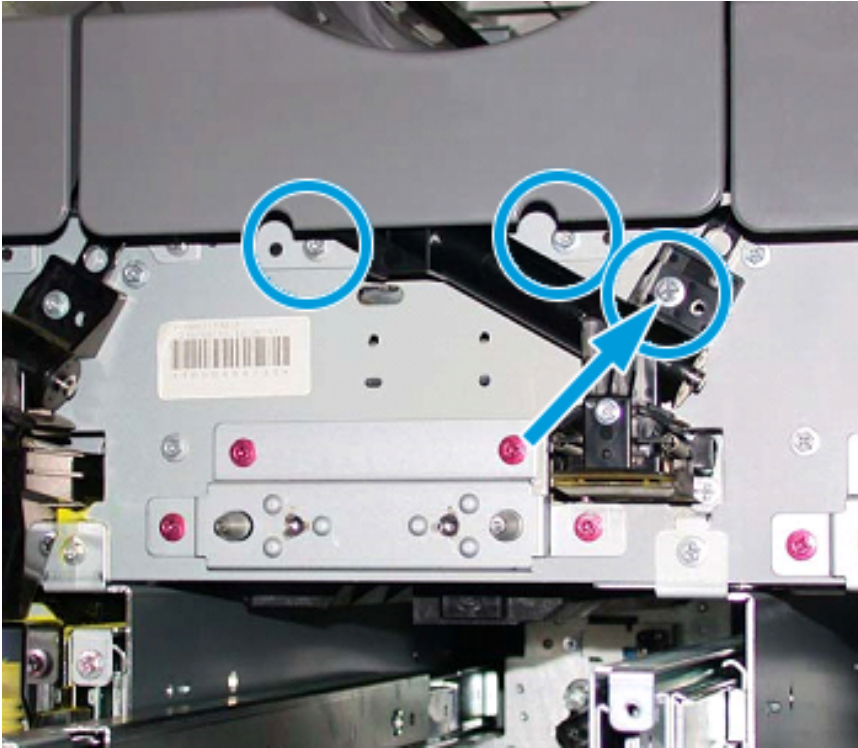
26. Remove the existing dry ink/toner cartridge from Station 1 or 6 by grasping the end of the cartridge and pulling straight out of the press.



27. Place the cartridge on the storage cart.

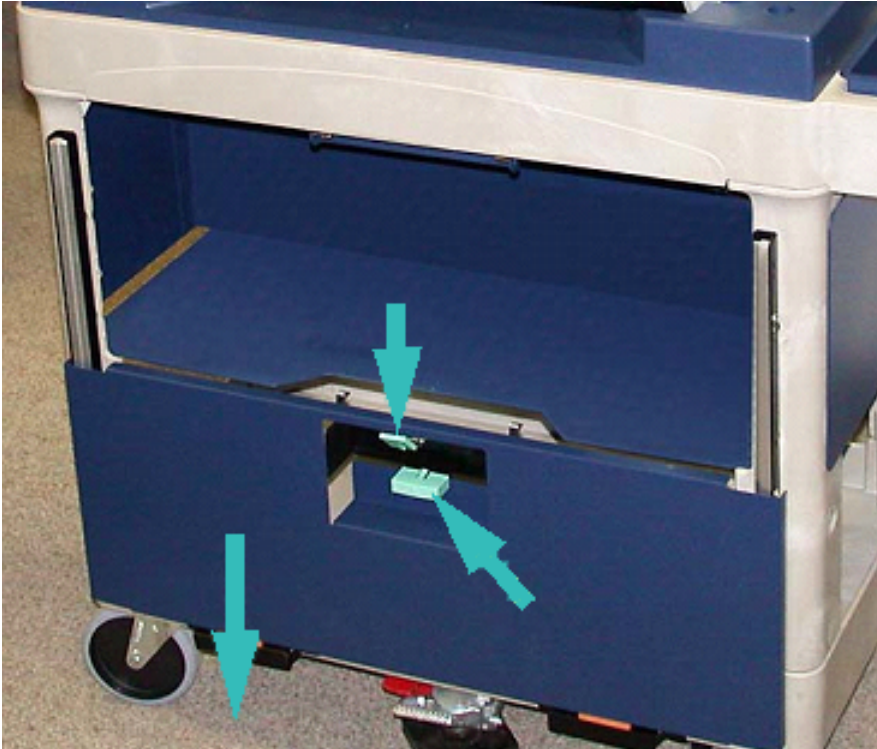



28. Loosen the screw on the Auger Assembly, and remove the two screws on the frame that secure the Dispenser Assembly. Place the screws in the tool bin of the storage cart.



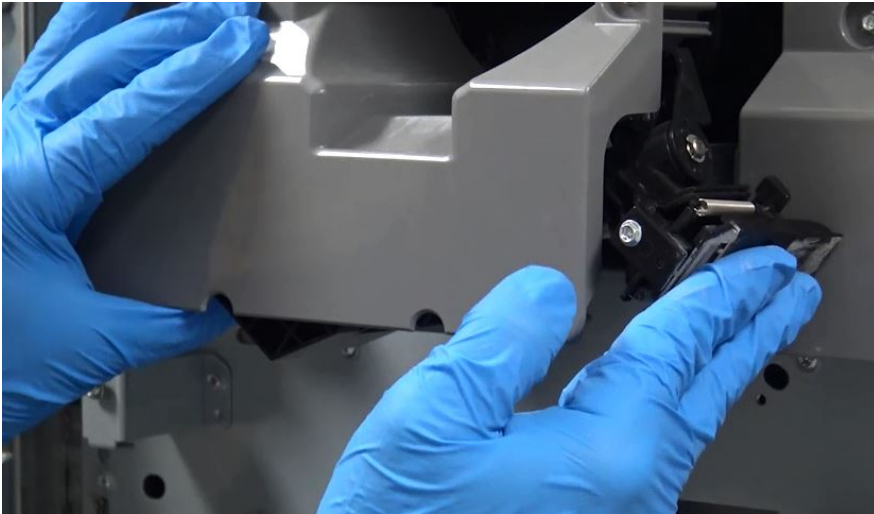
**Caution:** For the following step, when the Bottom Door Latch of the cart releases, the door drops suddenly. Hold the door handle and slide the door down into position.

29. At the cart, hold the door handle, release the door latch, and slide the door down into position.

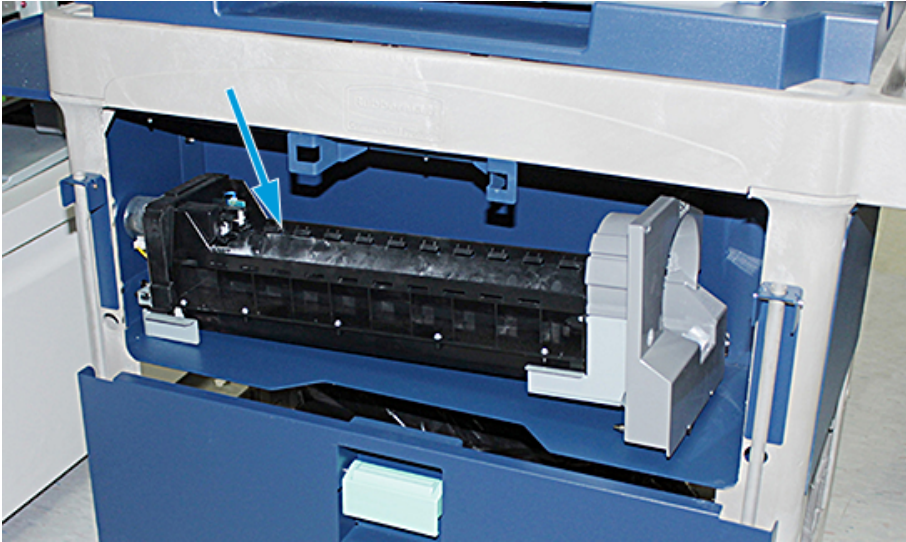


 **Caution:** Before placing the Dispenser Assembly on the cart, raise and lock the Auger Assembly.

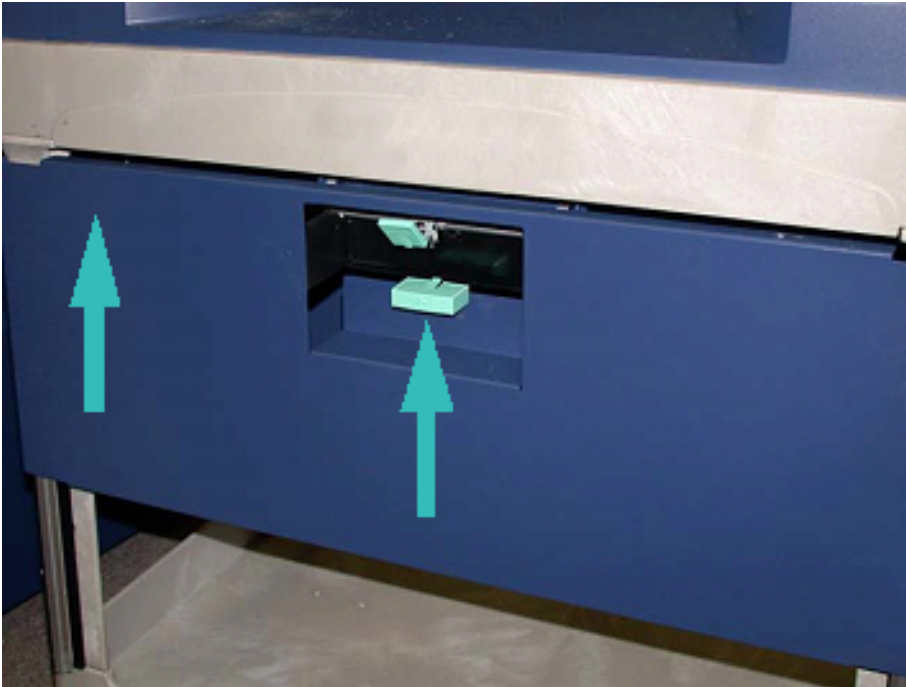
30. As you begin to pull the Dispenser Assembly out of the press, rotate the Auger Assembly up until it is latched in position. Keep the front of the Auger Assembly up and raise the black latch to lock it into place.



31. With both hands, remove the Dispenser Assembly and place the assembly on the storage cart.



32. Lift on the door handle and slide the door into position until the latch engages.




 **Caution:** When you release the Foot Brake, use caution.

33. To release the Foot Brake, hold the storage cart and carefully push down the Foot Brake.




34. Push in the tray and close the top of the storage cart.
35. Move the storage cart to a safe area.
36. From the storage cart with the dry ink station you removed, transfer over the components on this storage cart to the other storage cart with the unused dry ink station.

#### REPLACING THE SPECIALTY DRY INK IN STATIONS 1 OR 6

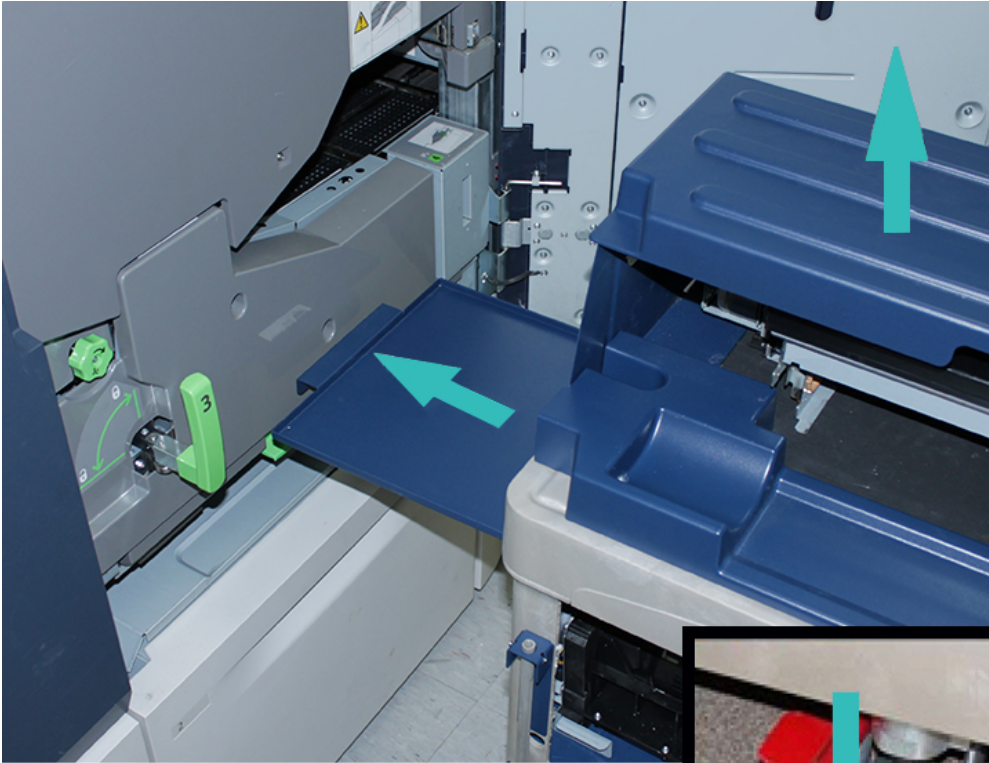
 **Caution:** When you perform this procedure, wear protective gloves. Failure to use gloves can result in image quality issues related to the Drum Module.

1. Power **Off** the press and wait 20 seconds.
2. Position the storage cart that has the new, unused specialty dry ink/toner in front of Station 1 or 6.
3. To catch excess dry ink/toner, extend the tray.

 **Caution:** Use caution when pushing down to engage the Foot Brake.

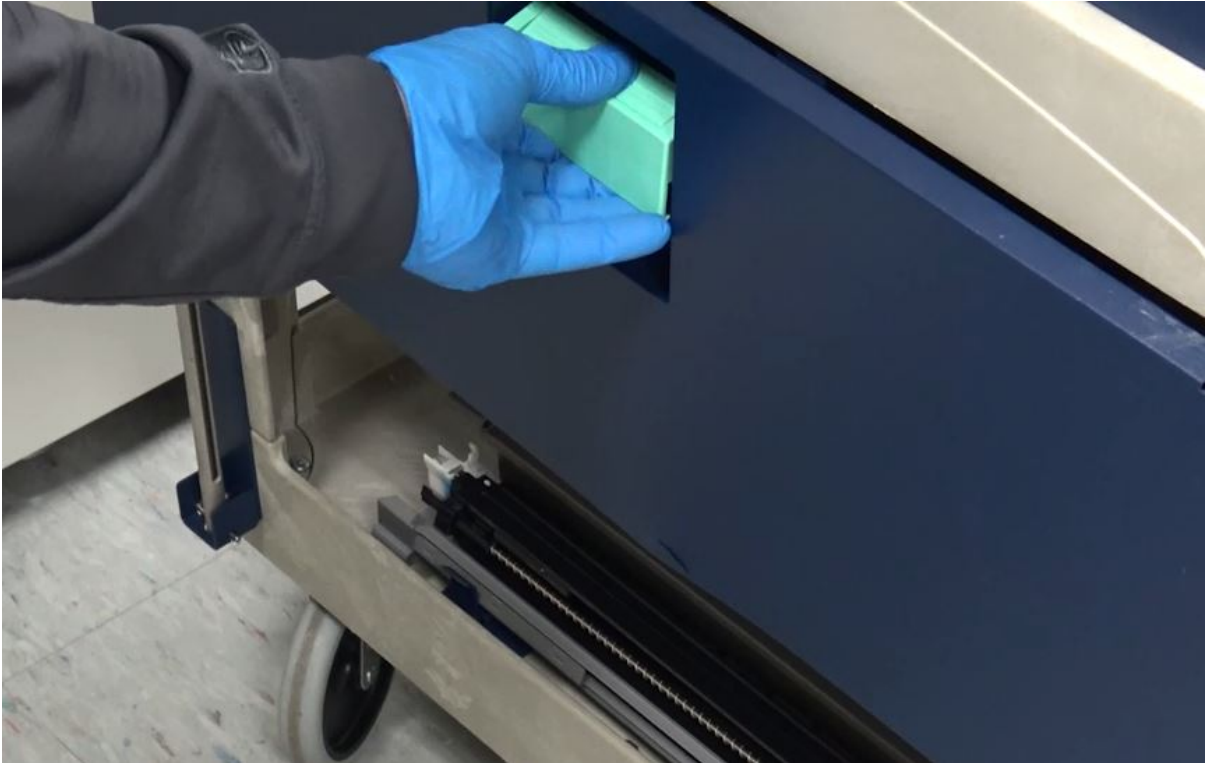
4. To prevent the cart from moving, press down on the cart Foot Brake.

5. Raise the top cover of the cart.

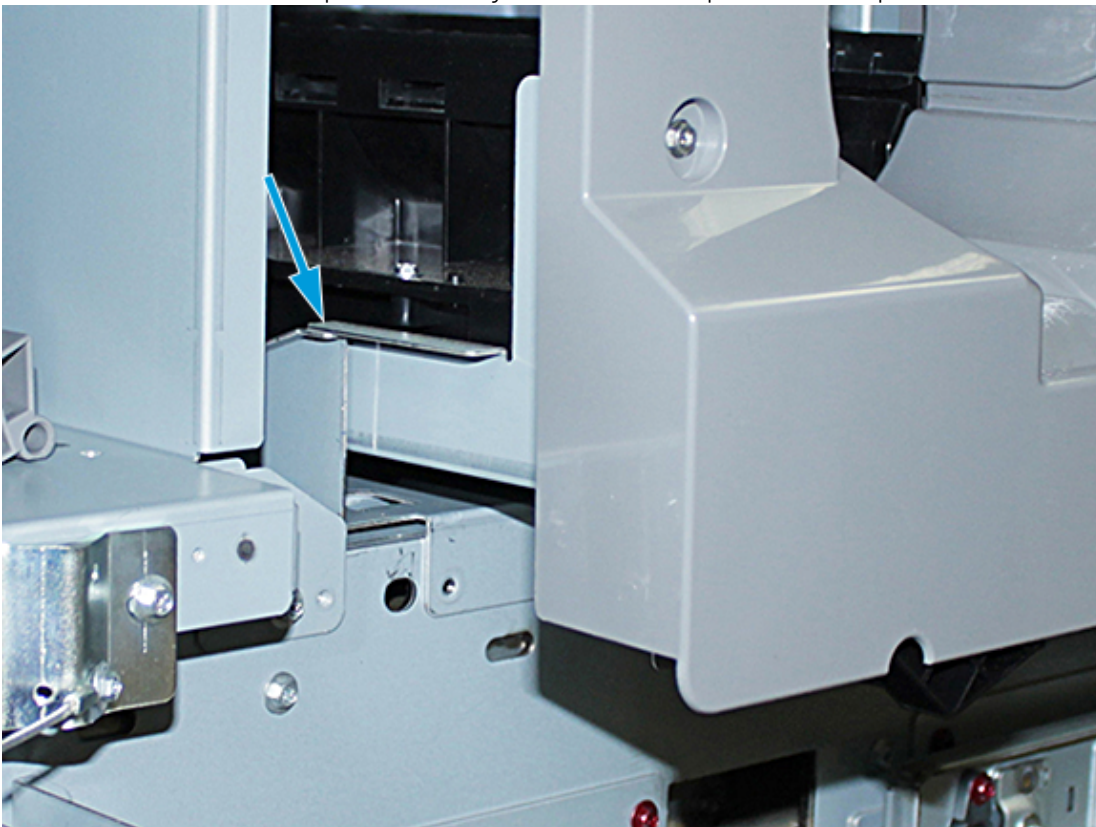


**!** **Caution:** For the following step, when the bottom Door Latch releases, the door drops suddenly. Hold the door handle and slide the door down into position.

6. At the cart, hold the door handle, release the Door Latch, and slide the door down into position.



7. Retrieve the Station 1 or 6 Dispenser Assembly from the cart and position it on top of the frame.

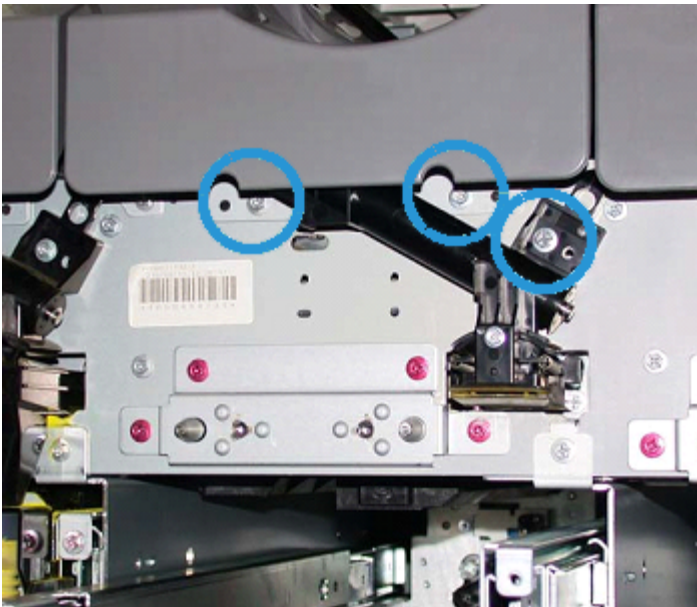




8. Lift the front of the Dispenser Assembly and slide it into the press, up to the black latch.
9. To release the Auger Assembly, keep the front of the assembly lifted and push down on the black latch to lock it into place. Slide the assembly fully into the press.



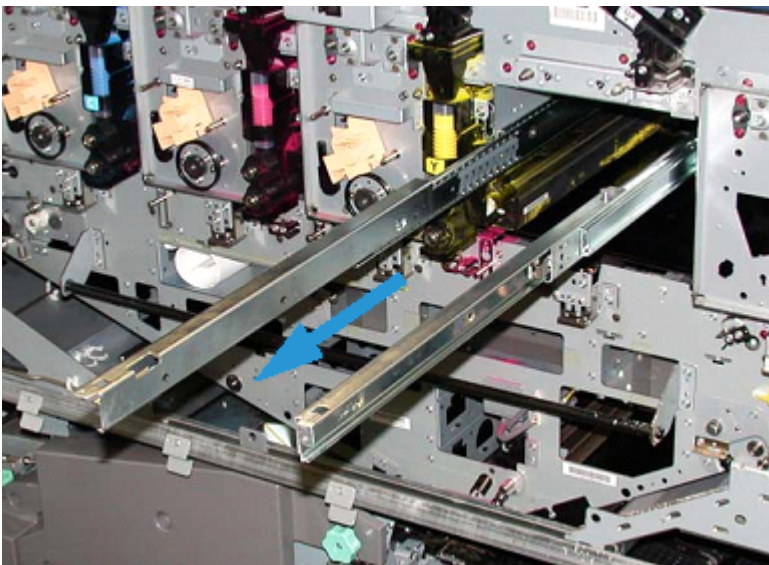
10. Access the screws from the cart bin and secure the Auger Assembly with the three screws.



11. Retrieve the new dry ink/toner cartridge from the cart and install it in the housing assembly.



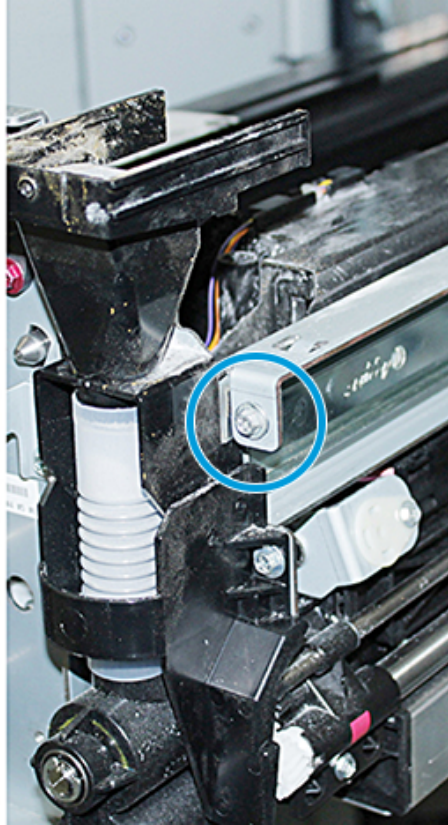
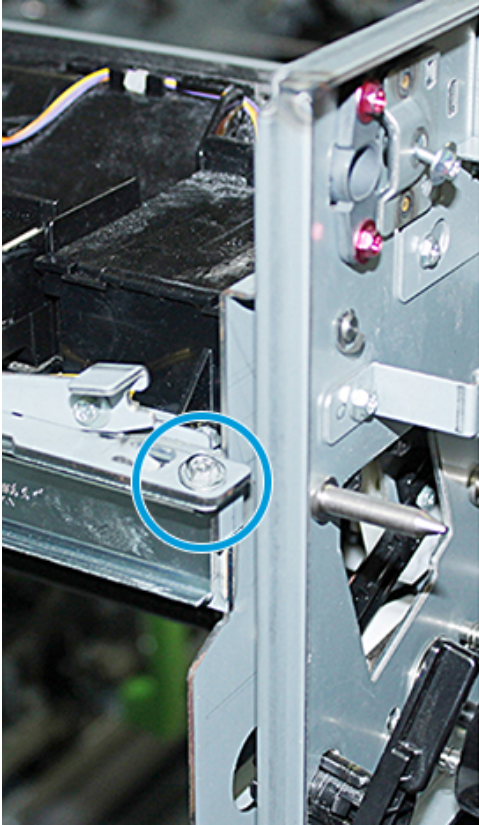
12. To install the Xerographic Marking Module, slide out the two rails of the module for Station 1 or 6 until they lock into position.



**Caution:** Due to the height and weight of the Module, use a step stool to perform the following procedure.

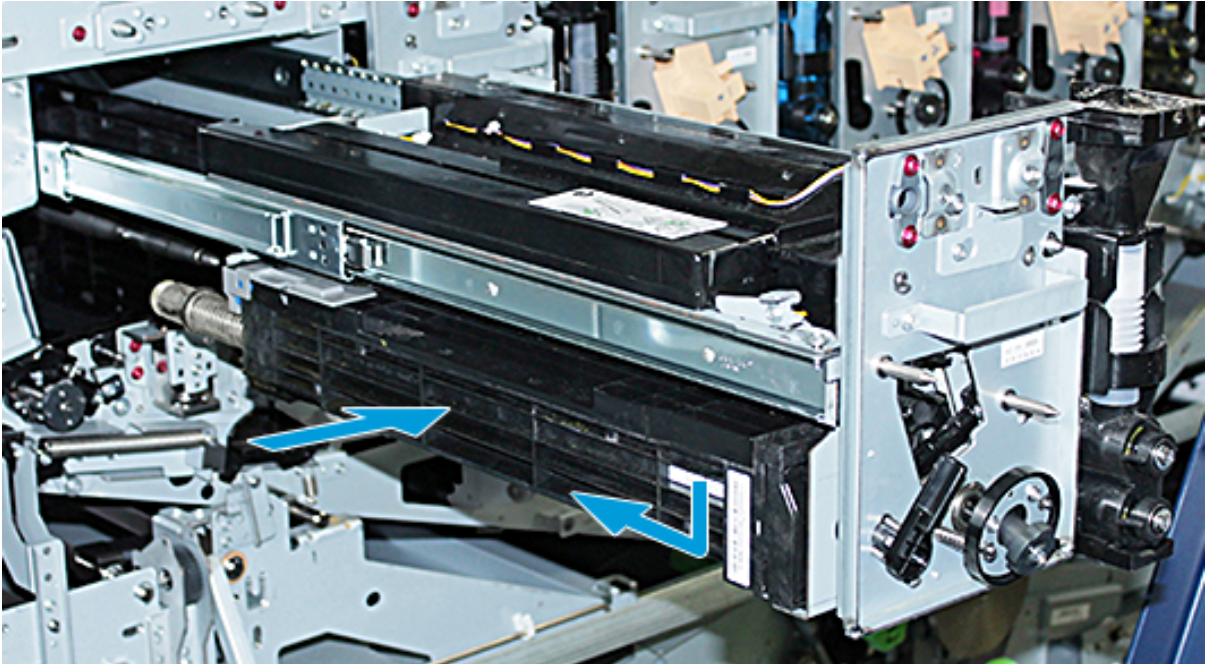
13. Retrieve the Xerographic Marking Module assembly from the cart and place on top of the rails. Slide it on top of the rails and into the press, up to the Service position.

14. Lock the assembly into position. Retrieve the screws from the cart tool bin and secure the assembly to the rails with the two shoulder screws.

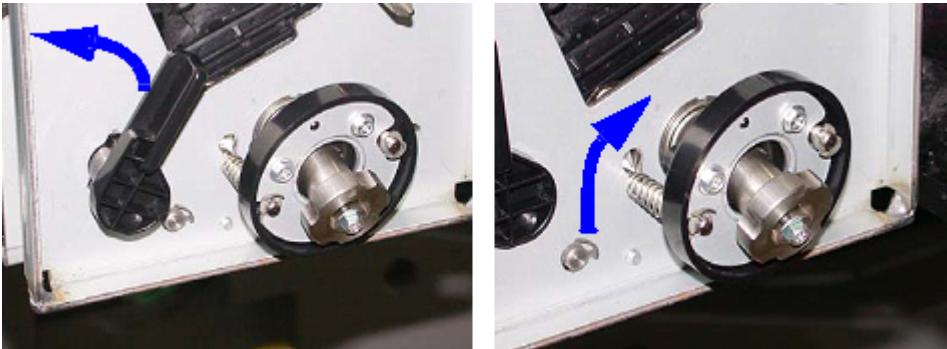


15. To replace the Drum Cartridge, locate the cartridge in the protective bag on the storage cart, and remove it from the bag.


16. At the side of the Xerographic Marking Module, install the Drum Cartridge into the module and move the cartridge toward the back of the module, then down.



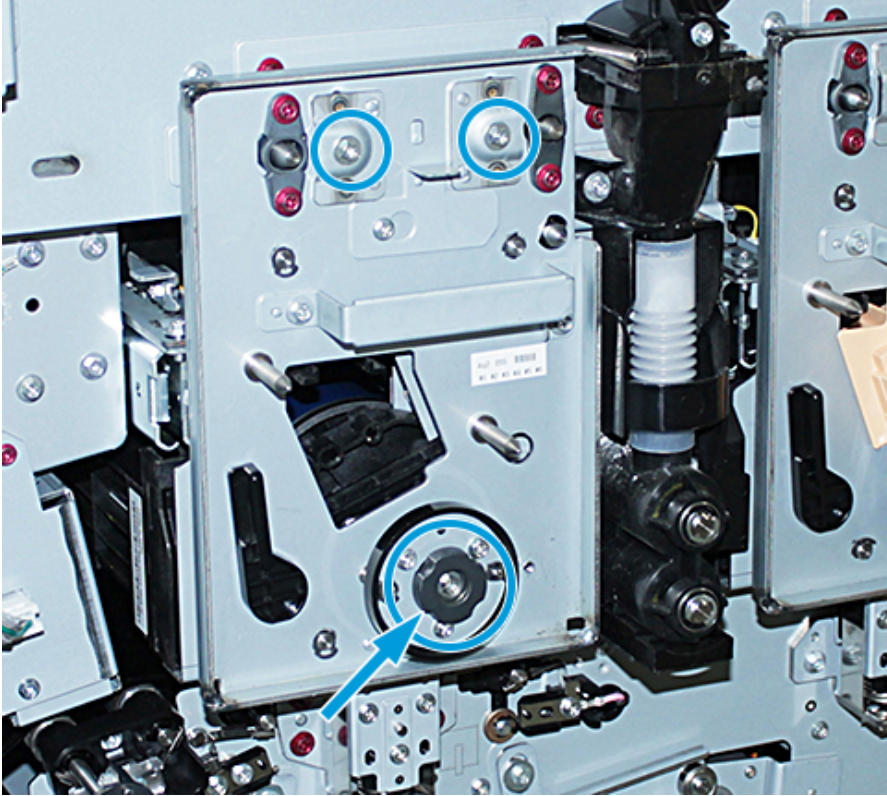
17. Engage the Drum Cartridge Retaining Latch counterclockwise and release the Front Drum Guide clockwise.



18. Release the rail locks and push the Xerographic Marking Module into the press.

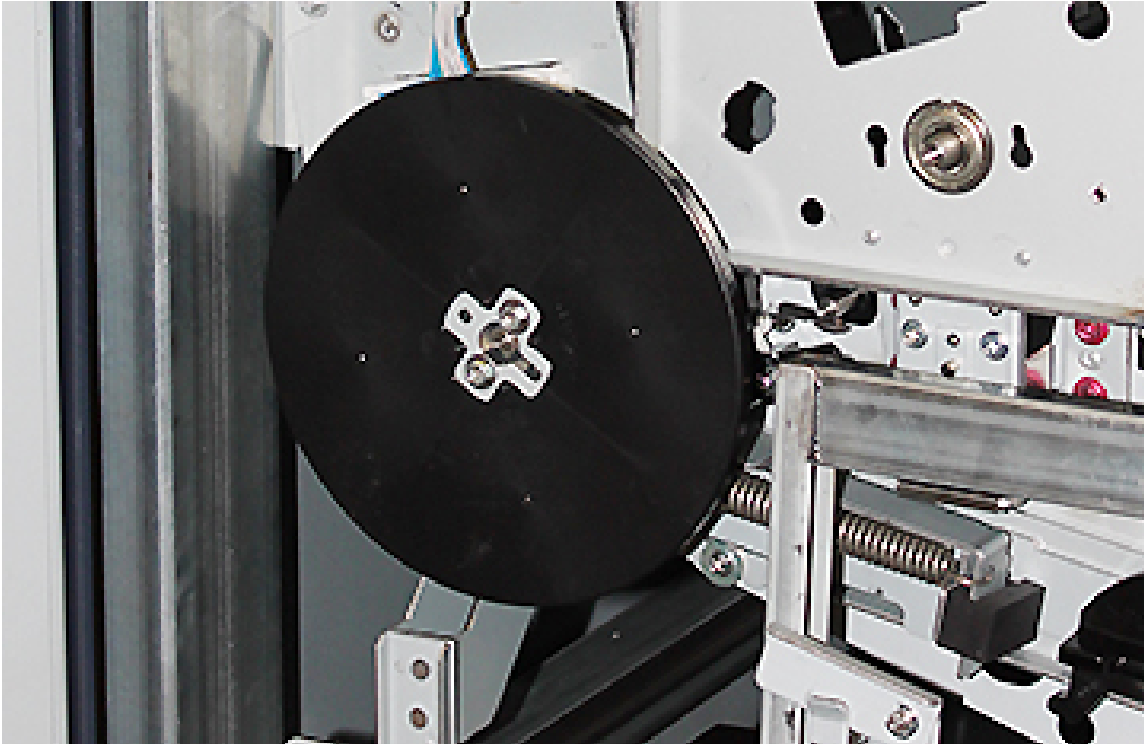
 **Caution:** To prevent damage to the Drum and to prevent the Drum from turning, hold the knob assembly when tightening the lower screw inside the assembly.

19. Ensure that the top and bottom of the Xerographic Marking Module is seated fully. Tighten the three module screws: the two screws at the top and the lower screw inside the knob assembly.

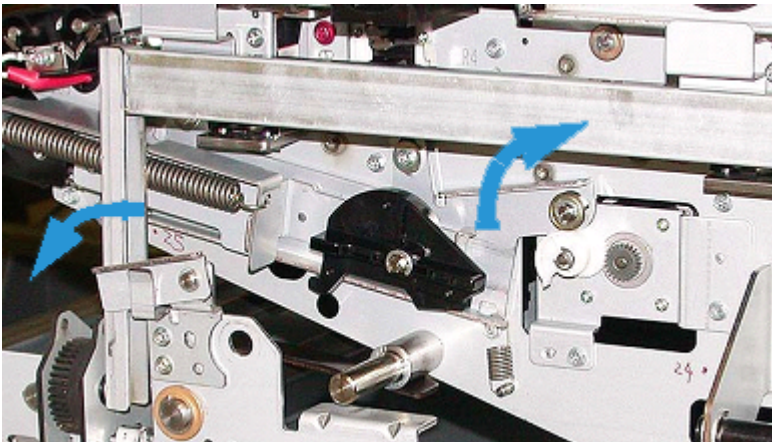


20. From the storage cart, retrieve the Charge Corotron with the Corotron Assist Tool.
21. On the Xerographic Marking Module faceplate, push the Corotron Assist Tool into the two pins.
22. Install the Charge Corotron by releasing the pin on the Corotron and sliding the Corotron along the tool and into the press.
23. Remove the Corotron Assist Tool from the faceplate and store in the compartment behind the left top dry ink/toner door. The Corotron snaps into place.

24. If you changed the dry ink/toner in Station 6, install the Flywheel. Retrieve the two screws from the cart and tighten the screws on the Flywheel.

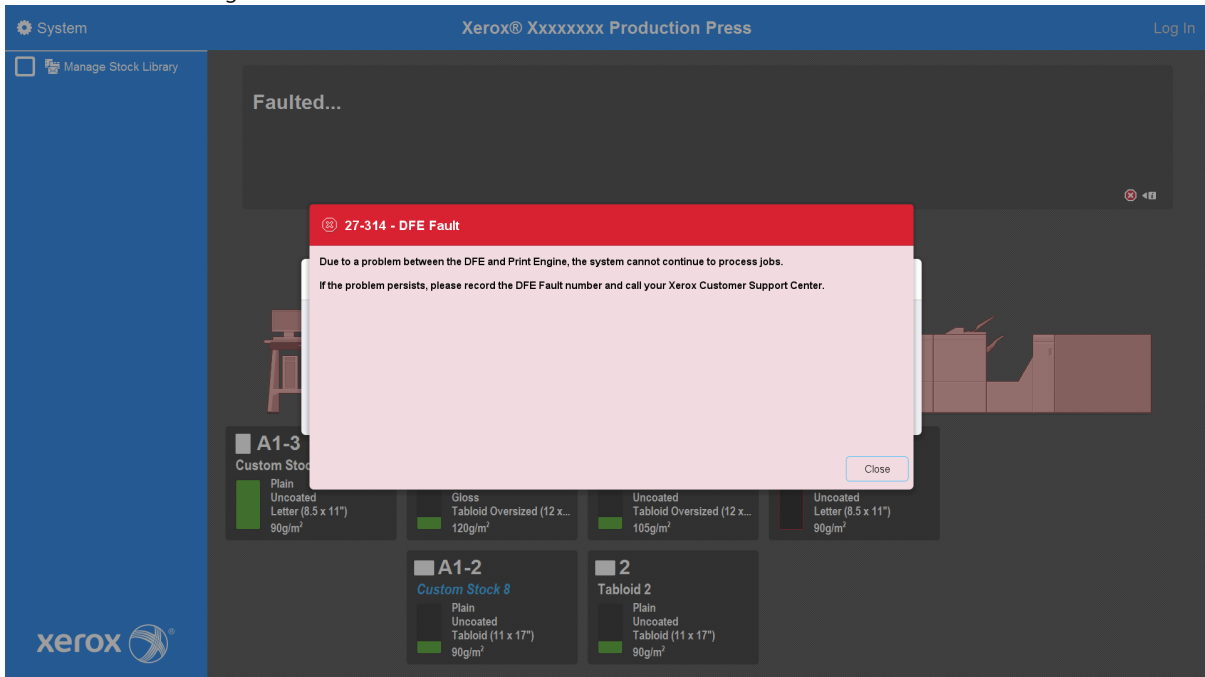



25. Close the top cover of the storage cart, push in the tray, and release the cart Foot Brake. Move the storage cart to a secure location.
26. Engage the Latch Bar on the Transfer Drawer and lock it.

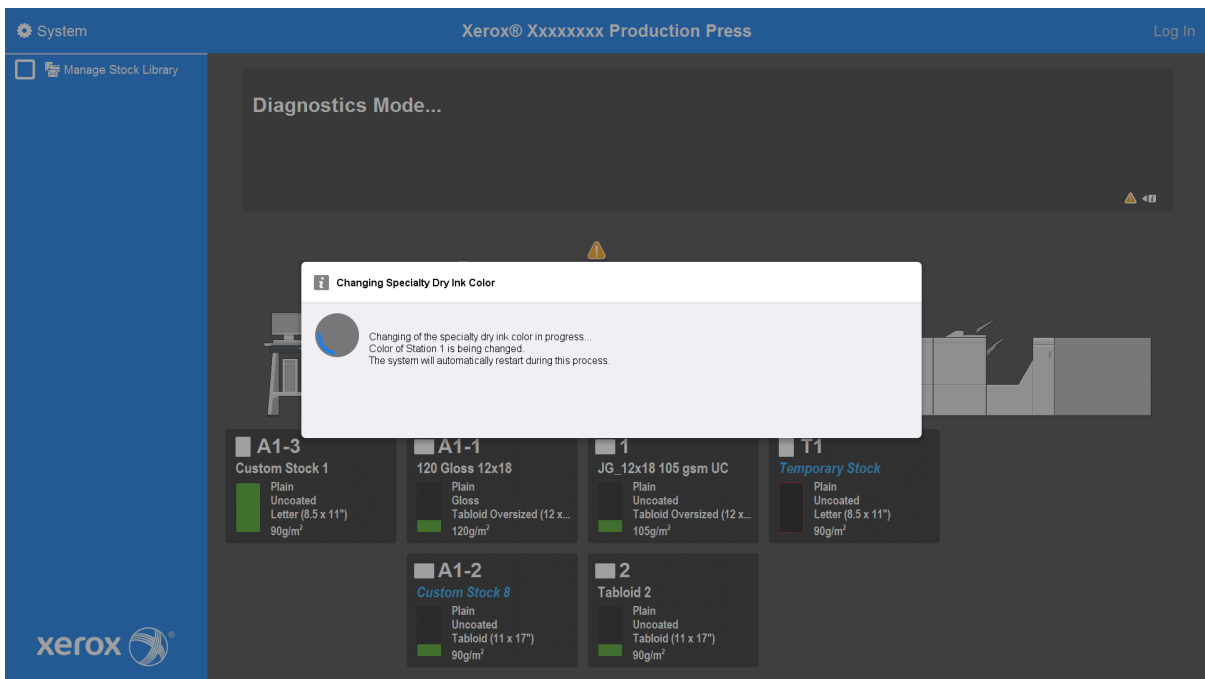


27. Latch the Paper Path Module by setting the green Locking Handle 3 to the Lock position.
28. To install the IBT Cover and the Xerographic Marking Module Cover, lift the covers and slide the covers in. Tighten the three upper screws and three lower screws of the covers.
29. Close the front doors on the press.

30. Power **On** the press. The press reboots. It is possible that the following error message appears. If so, ignore it and close the message window.



-  Note: During the reboot, the following message appears. It displays up to 10 minutes for each newly installed color station. If you replaced two color stations at one time, you could wait up to 20 minutes for the press reboot to complete.



31. After the system reboot completes, the press restarts and the current specialty dry ink graphic appears on the press Control Center.


## Maintenance


Maintenance contains information and procedures that can help you keep the Production Press functioning smoothly. Maintenance also has information about ordering consumables for all inline modules of the Production Press system.

For information on general maintenance tasks on individual feeder or finishing devices, refer to the Working With section for that device.

### CLEANING PROCEDURES

If the exterior surfaces of the Production Press require cleaning, dampen a paper towel or a soft, clean cloth with a liquid, nonabrasive glass cleaner or water.


 **Caution:** Do not use any other cleaners or solvents on the Production Press. They can interact with the paint on the covers, eventually causing the paint to peel.

 **Caution:** Do not pour or spray liquid directly into any of the paper trays. Always apply the liquid to the cloth first.


### Cleaning the Control Center Screen


**Frequency:** Daily, at the start of each day


Wipe the screen with a clean, lint-free cloth. Remove all dust and fingerprints.

 **Caution:** To avoid damage, do not use any Xerox cleaner, commercial cleaner, or water on the screen.

### Cleaning the Paper Path

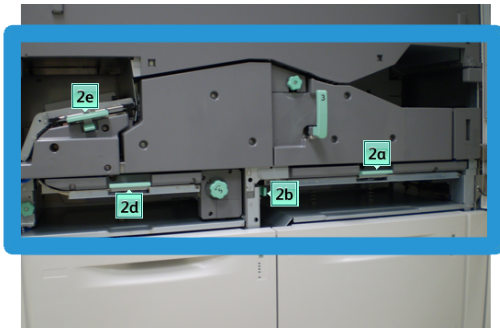
 Note: Perform the following procedures daily, preferably before turning on the Production Press while the Fuser is cool. Clean only the recommended areas of the paper path that are described in the procedures.

 **DANGER:** If the Production Press is powered on and the fuser is hot, before performing the procedure, power off the Production Press and allow 50 minutes for the fuser to cool.

 Note: If you notice large amounts and frequent accumulation of paper dust, for alternate paper recommendations, contact your Xerox® supply representative. If analysis determines that cut papers and using non-recommended material caused persistent paper contamination, you can be liable for any additional costs beyond the scope of the service contract.

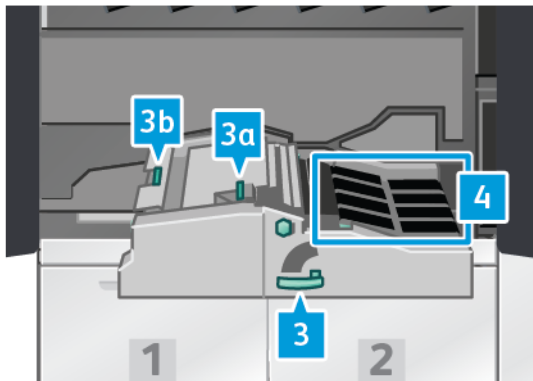


### Cleaning Paper Path Area 2



1. Open the print engine left and right front doors.
2. To clean the paper path only in the green lever jam-clearance areas, use a damp, water-moistened, lint-free cloth.
  - a. Open each area and clean the surfaces of the green-handle areas.
  - b. Remove any residual moisture with a dry, lint-free cloth.
3. Return all the green levers to their original positions.
4. Close the print engine left and right front doors.

### Cleaning Paper Path Areas 3 and 4



1. Open the print engine left and right front doors.
2. Grasp handle 3 and rotate it counter-clockwise.
3. Slowly pull out the paper transport drawer until it stops.
4. To clean the paper path only in the green lever jam-clearance areas, use a damp, water-moistened, lint-free cloth.
  - a. Open each green-handle area and clean the surfaces.
  - b. Remove any residual moisture with a dry, lint-free cloth.
5. Return all the green levers to their original positions.

- Using a lint-free cloth, clean the belts in Area 3 by rotating them in the direction that the paper travels. Continue to wipe the belts as you rotate them until all the belts are clean.

 Note: Do not rotate the belts with your bare hands. Touching the belts with bare hands leaves grease and dirt residue that can create paper jams.

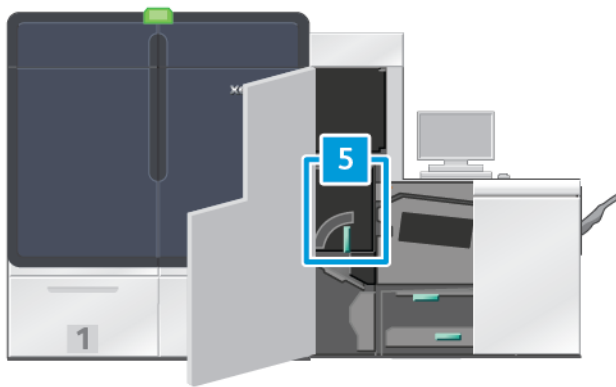
- Grasp handle 3 and slowly push in the paper transport drawer until it stops. Turn the handle clockwise to lock the module in place.

- Using a lint-free cloth, clean the belts in Area 4 by rotating them in the direction that the paper travels. Continue to wipe the belts as you rotate them until all the belts are clean.

 Note: Do not rotate the belts with your bare hands. Touching the belts with bare hands leaves grease and dirt residue, which can create paper jams.

- Close the print engine left and right front doors.


### Cleaning Paper Path Area 5



- On the print engine right side, open the left front door.
- Grasp handle 5, rotate it counterclockwise, then slowly pull out the fuser until it stops.


- Using a lint-free cloth, clean the belts on the left side of the fuser by rotating them in the direction that the paper travels. Continue to wipe the belts as you rotate them until all the belts are clean.



 Note: Do not rotate the belts with your bare hands. Touching the belts with bare hands leaves grease and dirt residue, which can create paper jams.

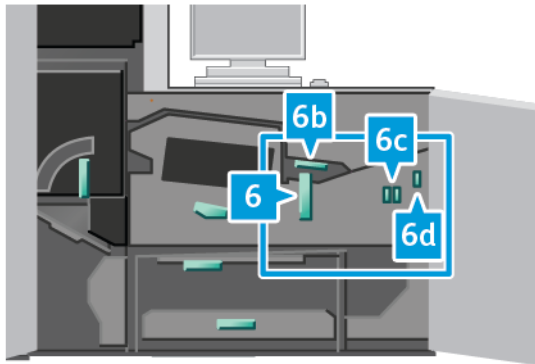
- Using a lint-free cloth, clean the belts on the right side of the fuser by rotating them in the direction that the paper travels. Continue to wipe the belts as you rotate them until all the belts are clean.



 Note: Do not rotate the belts with your bare hands. Touching the belts with bare hands leaves grease and dirt residue, which can create paper jams.

- Grasp handle 5 and gently push in the fuser until it stops.
- Close the print engine door.

### Cleaning Paper Path Area 6



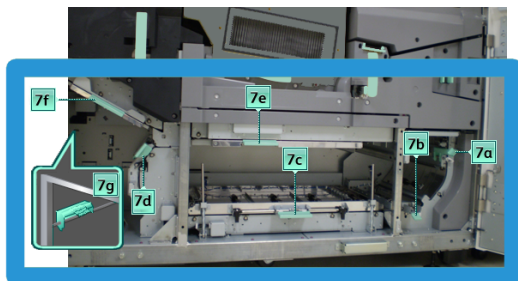
1. Open the left and right front doors on the print engine right side.
2. Grasp handle 6 and rotate it counterclockwise, then slowly pull out the exit drawer assembly until it stops.
3. To clean the paper path only in the green lever jam-clearance areas, use a damp, water-moistened, lint-free cloth.
  - a. Open each area and clean the surfaces of the green-handle areas.
  - b. Remove any residual moisture with a dry, lint-free cloth.



Note: Avoid touching the White Reference Roll when you clean Area 6.

4. After you have cleaned all areas, return levers 6b, 6c, and 6d to their original positions.
5. Grasp handle 6 and gently push in the exit drawer assembly until it stops.
6. To lock the exit drawer assembly in place, rotate handle 6 clockwise.
7. Close the print engine doors.

### Cleaning Paper Path Area 7



1. Open the left and right front doors on the print engine right side.
2. Lift lever 7g and move it to the right.
3. To clean the paper path only in the green lever jam-clearance areas, use a damp, water-moistened, lint-free cloth.
  - a. Open each area and clean the surfaces of the green-handle areas.
  - b. Remove any residual moisture with a dry, lint-free cloth.
4. Return lever 7g to its original position.

5. Grasp lever 7f and move it downward.
6. To clean the paper path only in the green lever jam-clearance areas, use a damp, water-moistened, lint-free cloth.
  - a. Open each area and clean the surfaces of the green-handle areas.
  - b. Remove any residual moisture with a dry, lint-free cloth.
7. Return lever 7f to its original position.
8. Grasp lever 7d and move it to the left.
9. To clean the paper path only in the green lever jam-clearance areas, use a damp, water-moistened, lint-free cloth.
  - a. Open each area and clean the surfaces of the green-handle areas.
  - b. Remove any residual moisture with a dry, lint-free cloth.
10. Return lever 7d to its original position.
11. Grasp lever 7e and move it downward.
12. To clean the paper path only in the green lever jam-clearance areas, use a damp, water-moistened, lint-free cloth.
  - a. Open each area and clean the surfaces of the green-handle areas.
  - b. Remove any residual moisture with a dry, lint-free cloth.
13. Return lever 7e to its original position.
14. Lift lever 7c.
15. To clean the paper path only in the green lever jam-clearance areas, use a damp, water-moistened, lint-free cloth.
  - a. Open each area and clean the surfaces of the green-handle areas.
  - b. Remove any residual moisture with a dry, lint-free cloth.
16. Return lever 7c to its original position.
17. Lift lever 7b.
18. To clean the paper path only in the green lever jam-clearance areas, use a damp, water-moistened, lint-free cloth.
  - a. Open each area and clean the surfaces of the green-handle areas.
  - b. Remove any residual moisture with a dry, lint-free cloth.
19. Return lever 7b to its original position.
20. Grasp lever 7a and move it to the left.
21. To clean the paper path only in the green lever jam-clearance areas, use a damp, water-moistened, lint-free cloth.
  - a. Open each area and clean the surfaces of the green-handle areas.
  - b. Remove any residual moisture with a dry, lint-free cloth.
22. Return lever 7a to its original position.

23. Close the print engine doors.

## CALIBRATING THE PRODUCTION PRESS



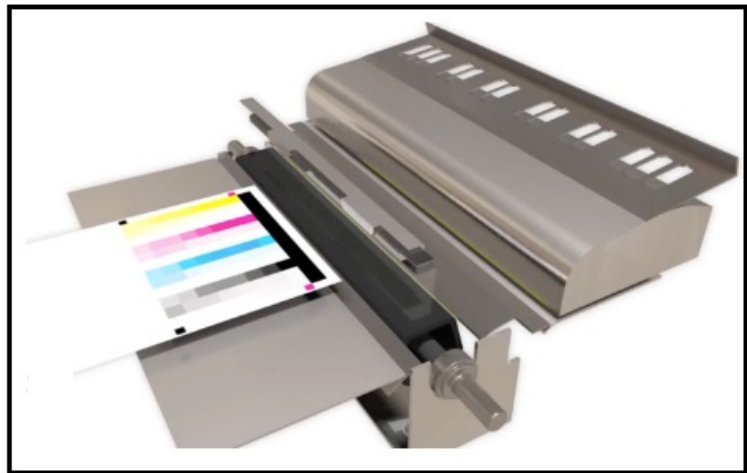
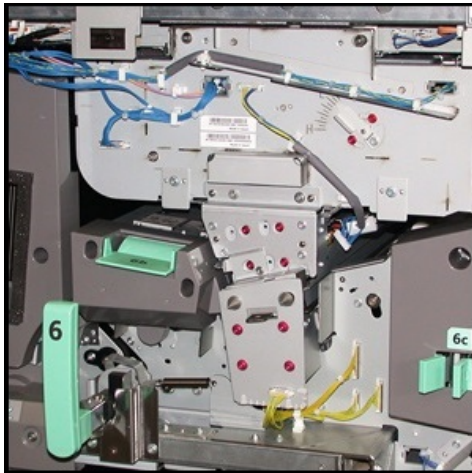
Note: The information contained in this section is about calibrating the Production Press only.

For information about calibrating the print server, refer to [For Administrators](#) for the Production Press. Also refer to the print server documentation at [Fiery - Xerox Iridesse Production Press](#).

For Fiery® Print Servers version 4.0, FS600 or newer version, if the stock loaded in the tray is registered with PredictPrint Stock Wizard, then you can right-click on the tray to **Run Image Quality System Check**. To enable this feature, refer to [Automatic Image Quality System Check](#).

### Full Width Array

The Full Width Array is an assembly located in the paper path before the Decurler. To provide image quality adjustments, print server calibration, and destination profiling, the Full Width Array contains an inline scanner. There are internal color calibration strips, or tiles, used as reference for known colors of a test pattern. To produce accurate and consistent reproductions, these color values are adjusted automatically. Customer intervention is no longer required.



When initiated by an operator or administrator, measurements and adjustments are automatic. The Full Width Array:

- Improves operator and Production Press productivity
  - Replaces lengthy manual procedures for print server calibration and creating destination profiles
  - Saves time by automatically scanning and measuring targets – no need to use an external spectrophotometer
  - Uses simple steps for some print engine adjustments that previously required a Customer Service Engineer
- Delivers the ability to set and maintain stable and accurate image quality quickly
  - Fast execution helps keep the Production Press centered
  - Automated calibration delivers accurate color

In addition to calibration and profiling, the Full Width Array provides these three image quality adjustments:

- **Automatic Alignment:** To adjust the image-to-paper placement on your printed output, use this feature. This alignment includes adjusting 1-sided and 2-sided image registration, perpendicularity, skew, and magnification.
- **2nd Bias Transfer Roll:** To adjust for uneven toner coverage and color shift or to improve image transfer for textured or linen stocks, use this feature.
- **Automatic Density Uniformity Adjustment:** When the density of the printed output is inconsistent throughout the printed page, run this image quality adjustment. Non-uniform, inconsistent density can appear as faded colors on portions of the printed page. This feature adjusts the inboard to outboard, and process direction uniformity of toner density. Running this adjustment to correct this inconsistent density can avoid a service call and possible down-time.

## Density Uniformity Adjustment

Density Uniformity Adjustment is done to ensure even toner density across each page.

The Production Press prints density test patterns, scans them, and automatically corrects for variations by resetting software controls. Uniformity is important for high area coverage applications where density drift from edge to edge can impact image quality. Density Uniformity Adjustment saves time because without it, to make this type of adjustment, a service call is required.

To correct inboard to outboard density uniformity defects, run **Automatic Density Uniformity Adjustment**. For example, the image quality is lighter or faded, or heavier or thicker, on the left or right sides of the output, which is inboard or outboard. After xerographic components are replaced, also run **Automatic Density Uniformity Adjustment**.



Note: Auto Density Uniformity Adjustment does not require system administrator access. The operator can perform it by accessing the System menu and selecting **System > Automatic Adjustments**.

## Adjusting Automatic Density Uniformity

1. From the Control Center, select the **Administration** button.
2. Select the **Automatic Density** button for Automatic Density Uniformity Adjustment.
3. Select the tray containing A3 (11 x 17 in.) or SRA3 (12 x 18 in.) paper.
4. Select **Start**.

The Production Press prints the Density test patterns and automatically updates the system controls appropriately.

5. Select one of the following:
  - If the output prints are acceptable, select **Accept Changes**.
  - If the output prints are not acceptable, to make the adjustment prints, select **Start** again.



Note: If acceptable output cannot be reached after numerous attempts, contact the Customer Support Center.

6. To return to the main window, from the System Settings window, select **OK**.

## Automatic Adjustments

All Image Quality (IQ) adjustments that use the Full Width Array appear in a single window. You can select and run them as a group, or run them individually. Run the Auto Alignment Adjustment and 2nd Bias Transfer Roll Auto Adjustment weekly. Run Auto Density Uniformity Adjustment less often.

Optimize image quality by performing the following automatic IQ adjustments using the Full Width Array.

### Auto Alignment Adjustment

This tool generates an individual alignment profile for each media and tray combination. The adjustment ensures the correct placement of images onto the media. Adjustments are saved in the Manage Stock Library for later use.

### 2nd Bias Transfer Roll Auto Adjustment

This tool corrects uneven toner coverage and color shift. The tool automatically creates and saves an adjustment to the Bias Transfer Roll. The adjustment values are saved in the Manage Stock Library for later use.

### Auto Density Uniformity Adjustment

This tool adjusts print engine tables to ensure the uniform and consistent deposit of dry ink/toner across the page. You can run the adjustment for uniformity in either the cross-process direction or the process direction.



Note: You can run this adjustment less often than the other adjustments. Deselect it from the group and run it as needed.

## Setting Up the Automatic Adjustments

1. From the Control Center, select the **Automatic Adjustments** button.  
The Automatic Adjustments Setup window appears.
2. To run all three adjustments at once, at the top of the Automatic Adjustments Setup window, select the **Execute All FWA Adjustments** button.  
To run each adjustment selectively, select the button for the appropriate adjustment.
3. Click the **Start** button. As each of the three adjustments completes, a green check mark displays on the status window.

When the procedure is complete, a window opens to show the results.

4. To print sheets to check the results visually, click **Print Test**.
5. To return to the main window, click **Close**.

## Automatic Alignment Information

If your Production Press has the Full Width Array, the Auto Alignment feature is available for use. This feature automatically adjusts the output image for different media types without the manual progression through the alignment profile steps. This point-of-need output adjustment is quick and easy and reduces productivity loss.

To access the Auto Alignment feature, log in as the Administrator. On the Control Center, select the **Profiles** button. When the Profiles feature opens, to open the Profiles Properties window, where you find the Auto Alignment feature, select either **New** or **Edit**.

For detailed information on Auto Alignment, refer to [Alignment](#).



## Performing an Auto Density Uniformity Adjustment

To run an Auto Density Uniformity Adjustment, perform the following steps:

 Note: The Administrator defines the standard stock used to print the test targets.

1. From the Control Center, select the **Automatic Adjustments** button.
2. From the Automatic Adjustments Setup window, select **Tray Settings**.
3. From the Tray Setup window, select a tray containing A3 (11 x 17 in.) or SRA3 (12 x 18 in.) paper. Select **OK**.
4. To enable this operation, click the box in front of **Auto Density Uniformity Adjustment**.

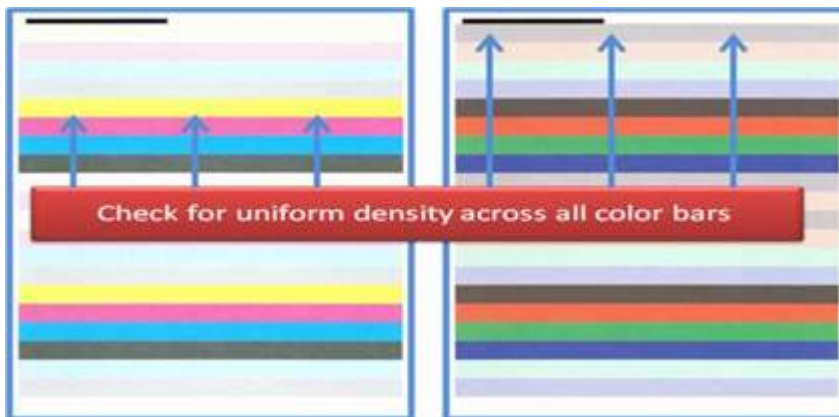
A check mark appears in front of the adjustment.

5. Select **Start**.

The Production Press prints test targets, measures them, and automatically adjusts the toner density for consistent application across the page. Note that the printed sheets do not reflect the new settings, but are the sheets that were used to make the adjustments.

6. Decide if you want to check the new settings visually:
  - If you do not want to print new sheets with the revised settings, select **Close**.
  - If you do want to print new sheets with the revised settings, select **Sample Printout**. Sample sheets now print using the updated settings.
7. Check the printed samples for density uniformity.

To check the print samples, verify that each line of color shows even density across the page:



8. Decide if you are satisfied with the results:
  - If you are satisfied with the results, select **Save** and **Close**.
  - If you do not like the results, repeat the procedure.

## PERFORMING AN EZ PRESS CHECK

The EZ Press check performs all three adjustments with just a few menu selections. You can also run these adjustments individually from this window. Generally, if you run these as a set with Execute All FWA Adjustments, deselect Auto Density Uniformity Adjustment. You do not need to run this program often as the other two. Check

your settings carefully; after the Automated Adjustments are performed, the Setup screen recalls the last settings used.

- **Auto Alignment:** Adjusts the image-on-paper for registration, perpendicularity, skew, and magnification. This adjustment is saved to the Manage Stock Library for the selected stock and then applied whenever the stock is used for a job. The system automatically assigns a name. For example, Alignment 1, Alignment 2, or Alignment 3.
- **2nd Bias Transfer Roll:** Adjusts for uneven toner coverage and color shift, and improves image transfer for textured or linen stocks. This adjustment is saved to the Manage Stock Library for the selected stock and then applied whenever the stock is used for a job.
- **Auto Density Uniformity Adjustment:** Adjusts the inboard to outboard and lead-edge to trail-edge uniformity of toner density. This adjustment is run on a system-level Standard Stock set up by a System Administrator. Do not change it for individual media, as with the other adjustments.
- **Auto Correction**
  - Right Angle Direction
  - Paper Process Direction

### Performing an EZ Press Check - Basic Procedure

To perform an all-in-one EZ Press Check:

1. At the Control Center, select **Automated Adjustments**.
2. On the Automatic Adjustments window, if not already enabled, click **On** for the Execute All FWA Adjustments.
3. Ensure that the buttons for the checks that you want to run are switched on. If you only want to perform one or two of these checks, switch off the buttons for the checks that you do not want to perform.
  - Auto Alignment
  - 2nd Bias Transfer Roll
  - Auto Density Uniformity:
    - Auto Correction
      - Right Angle Direction
      - Paper Process Direction

Do not run the Auto Density Uniformity routinely every time you perform the EZ Press Check. Switch off **Auto Density Uniformity Adjustment** to skip this adjustment. Run the Auto Density Uniformity Adjustment only when you notice a variation in toner density across the page—inboard to outboard, or lead edge to trail edge.

4. Check that the paper tray and stock listed next to each adjustment is the one you want for the auto adjustments.

Note that only an administrator can change the stock for Auto Density Uniformity. The settings you use routinely to run EZ Press Check probably do not change. However, if a user changes the setup values, verify that they are correct for your stock and the jobs types.

5. Click **Start**.

As each of the three adjustments is completed, a green check mark appears on a status window.

6. Click **Close**.

When the procedure is complete, a window opens showing the results. To print sheets to check the results visually, optionally you can click **Print Test**.

### CONSUMABLE SUPPLIES

Order any needed supplies and paper from Xerox at [www.xerox.com/IRIDESSEsupplies](http://www.xerox.com/IRIDESSEsupplies). From the site, do one of the following:

- To obtain specific contact information in your area, select **Contact Us**.
- Select **Supplies**, then select an appropriate option from the menu.



Note: For the latest Customer Replaceable Unit part numbers, always refer to [www.xerox.com/IRIDESSEsupplies](http://www.xerox.com/IRIDESSEsupplies).

Store supplies and Xerox parts in their original packages.

The following table shows all the consumables for the Xerox® Iridesse® Production Press. To minimize downtime, keep a supply of these items.

| SUPPLY ITEM                                | SUPPLY UNIT SHIPPED WITH PRESS – REORDER QUANTITY | APPROXIMATE PRINT YIELD/ CARTON WITH FULL COLOR PRINTS |
|--|---|--|
| HD EA Toner Cartridge – Black              | 1 per /box  | 69,000   |
| HD EA Toner Cartridge – Cyan               | 1 per /box  | 82,000   |
| HD EA Toner Cartridge – Magenta            | 1 per /box  | 82,000   |
| HD EA Toner Cartridge – Yellow             | 1 per /box  | 82,000   |
| HD EA Dry Ink Cartridge – Clear            | 1 per /box  | 55,000   |
| HD EA Dry Ink Cartridge – White            | 1 per /box  | 25,000   |
| HD EA Dry Ink Cartridge – Gold             | 1 per /box  | 55,000   |
| HD EA Dry Ink Cartridge – Silver           | 1 per /box  | 55,000   |
| HD EA Dry Ink Cartridge – Fluorescent Pink | 1 per /box  | 55,000   |
| Dry Ink Waste Bottle                       | 1   | 120K   |
| Fuser Web Assembly                         | 3   | 800K   |
| Developer                                  | 1   | 12 million   |

- Dry ink/toner yield projections are based on 7.5 percent area coverage per color (4 colors = 30 percent) at standardized conditions on A4 (8.5 x 11 in.) Xerox® Iridesse® Production Press centerline paper and other stocks with equivalent smoothness, cut, quality, and structure. Replacement rates can be more frequent for operations that use high percentages of coated stocks, have area coverage greater than 70% of each color, and larger

than A4 (8.5 in x 11 in.) size throughput. Specialty dry ink developer is not included in metered supplies plans. Actual yields vary greatly, depending on color intensity, area coverage, paper stock, and the run mode selected.

- To reorder dry ink/toner waste bottles, fuser Web assemblies, or charge corotron units at no charge, call your Xerox service representative.

For information on ordering consumables for the finishing devices, refer to [Finisher Consumable Supplies](#).

## Replacing Consumable Supplies

Replacing supplies on the Production Press involves three skill levels:

- Operators can replace Customer Replaceable Units such as dry ink/toner and their waste bottles, and charge corotrons.
- Technical Key Operators, with specialized training, can replace other consumable items.
- Qualified Service Representatives can replace Service Representative Replaceable Units. These units have specially designed features that enable them to perform much longer than the average life indicator. If the status indicates a low or depleted level, the Production Press does not interrupt a job or stop running. Your Service Representative uses this status indicator information each time the Production Press is serviced.

## REPLACING THE DRY INK/TONER CARTRIDGES

Toner cartridges include Black (K), Cyan (C), Magenta (M), Yellow (Y), and any optional cartridges that you purchased.

Optional dry ink cartridges that you can use in Stations 1 and 6 are:

- White Dry Ink
- Silver Dry Ink
- Gold Dry Ink
- Fluorescent Pink Dry Ink

Optional dry ink cartridges that you can use in Station 1 are:

- Clear Dry Ink
- Low Gloss Clear Dry Ink



Note: To prevent dry ink/toner spills, remove the dry ink/toner cartridges only when a message on the Control Center instructs you to do so.

1. Place a drop cloth below the dry ink/toner area.
2. Open the print engine upper doors.
3. Remove the empty cartridge. Dispose of the cartridge according to local regulations.



Tip: Do not use warm water, hot water, or cleaning solvents, to remove dry ink or toner from your skin or clothing. Using these cleaning options sets the dry ink or toner and makes it difficult to remove. If any dry ink or toner gets on your skin or clothing, use a brush to remove it, blow it off, or wash it off with cold water and mild soap.

4. Remove a new cartridge from the box.

- Vigorously shake or slap the new cartridge with your hand until the dry ink/toner is loosened completely.

**Caution:** Dry ink/toner settles and compacts during shipping. Loosen the contents before inserting the cartridge into the Production Press. Failure to loosen the particles can damage the gear at the end of the cartridge.

- Insert the new cartridge into the compartment with the arrow at the top. Gently push the cartridge in all the way.

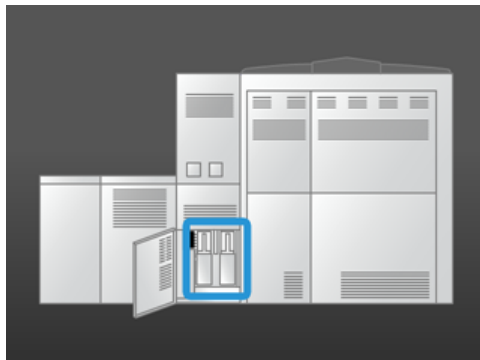


**Caution:** Each color bottle is keyed to a specific location. If you replace more than one cartridge at the same time, ensure that you place the cartridges in the correct color locations.

- Close the print engine doors.


### DRY INK/TONER WASTE BOTTLE

The dry ink/toner waste bottle collects the waste dry ink/toner that occurs during the printing process. The Production Press contains two dry ink/toner waste bottles that are in the rear of the Production Press.



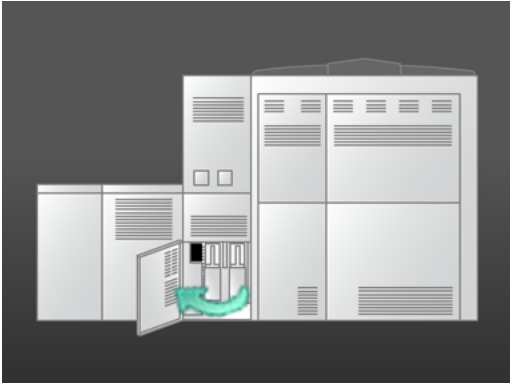
When a waste bottle is full, a message appears on the Control Center advising you when to replace it. As long as the second waste bottle is not full, while you exchange the full bottle with an empty one, the Production Press continues to run.

### Replacing a Dry Ink/Toner Waste Bottle

 **Note:** When removing a full dry ink/toner waste bottle, to prevent spills, pull it out of the Production Press slowly.

## Working With

1. Open the dry ink/toner waste bottle panel at the rear of the Production Press.



2. Grasp the handle of the full bottle and pull the bottle bin out of the Production Press.



3. Lift the full bottle out of the Production Press.



4. Remove the cap from the cap holder on the side of the full bottle. Press the cap securely into the open hole on the top of the full bottle.



5. Dispose of the full bottle according to your local regulations.
6. Remove a new, empty bottle from the carton and insert it into the bottle rack.
7. Gently push the new bottle into the Production Press.
8. At the rear of the Production Press, close the dry ink/toner waste bottle panel.

#### REPLACING A CHARGE COROTRON ASSEMBLY



Note: All charge corotron removal procedures are identical.

1. Install the charge corotron guide onto the pins on the Xerographic Module.



2. Squeeze the release tab at the front of the charge corotron and pull out until the charge corotron clicks into the guide.



3. Remove the Guide and the charge corotron from the Xerographic Module.
4. Squeeze the release tab at the front of the charge corotron and slide it out the back of the guide.
5. Carefully slide the new charge corotron into the guide from the rear, ensuring that the tabs of the charge corotron slide on the rails of the guide. Slide the charge corotron forward until it clicks into the guide.



6. Position the corotron guide onto the pins on the Xerographic Module.
7. At the front of the charge corotron, squeeze the release tab and push straight in to the Xerographic Module until the corotron clicks into place.
8. On the Control Center, reset the HFSI.

 Note: Only the Technical Key Operator can reset the HFSIs.

9. If you installed a new corotron, follow the directions on the Control Center. If you replaced an existing corotron, click **Cancel**.



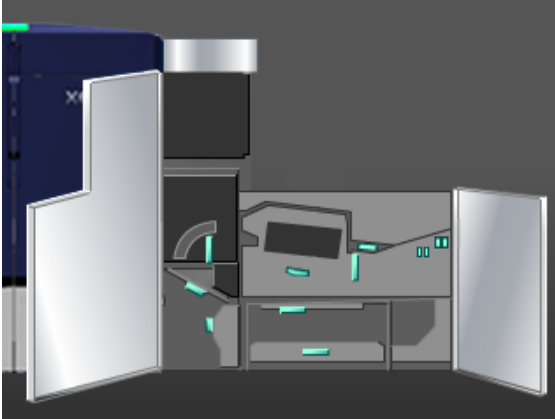
## REPLACING THE FUSER WEB ASSEMBLY

Two messages about the Fuser Web assembly appear on the Control Center. The first message advises that the Fuser Web almost is worn and to have a new unit available. The second message appears when the Fuser Web is used completely and you must replace it. When this message appears, the Production Press shuts down and it cannot print until you replace the Fuser Web.

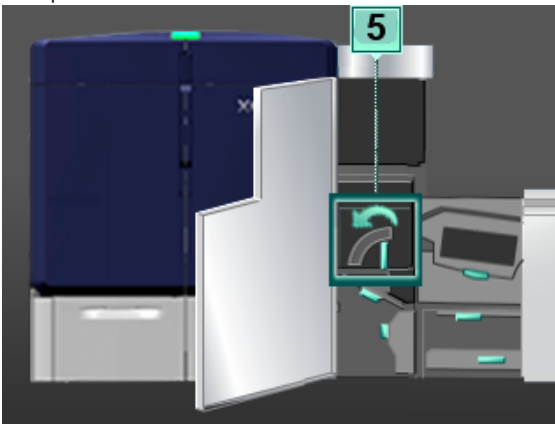


**DANGER:** Be careful when you clear jams in the fuser area, the fuser is hot and causes injury.

1. At the right side of the print engine, open the left and right front doors.



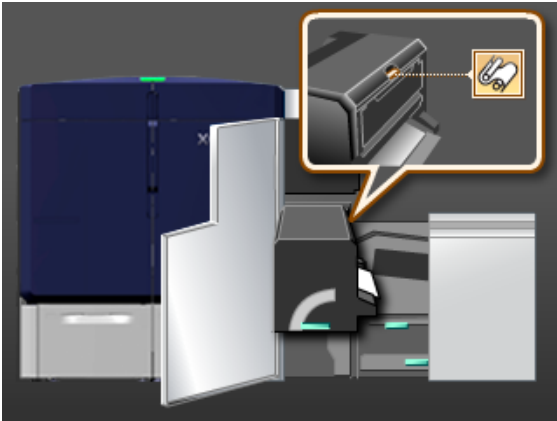
2. Grasp handle **5** and rotate it in the direction of the arrow. Slowly pull out the fuser until it stops.



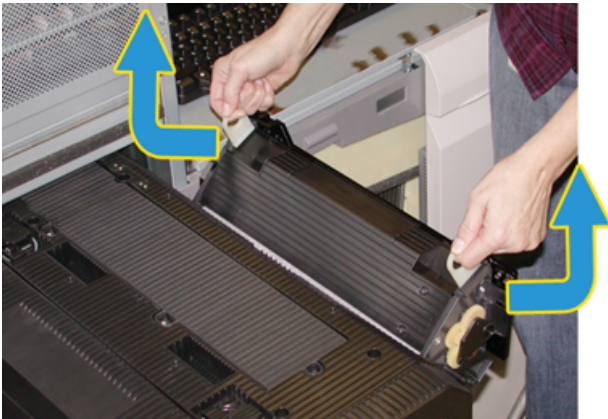
Working With

3. Push down on the lever.

The fuser exit area opens.

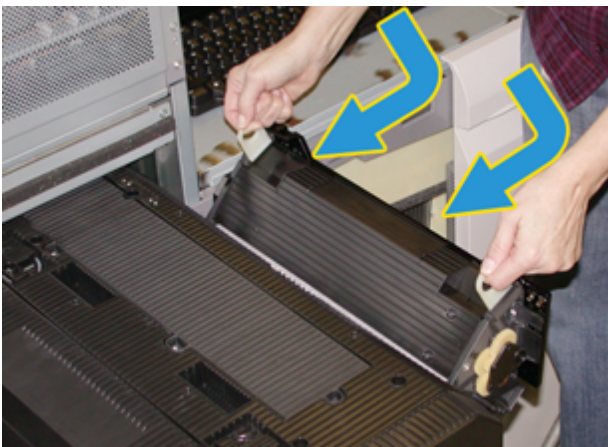


4. To remove the assembly, grasp the handles on the Fuser Web assembly and pull it up and out.

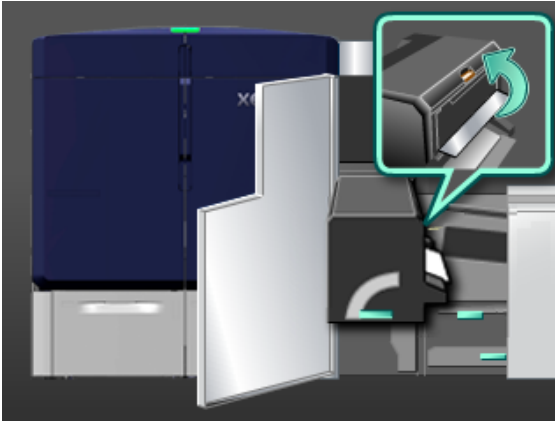


Dispose of the old Fuser Web assembly according to your local regulations.

5. Remove the new Fuser Web assembly from the box and the protective covering.
6. Hold the assembly by the handles with both hands, and insert the assembly into the fuser.



7. Close the fuser exit area.




8. Grasp handle **5** and gently push in the fuser until it stops.
9. To lock the fuser module in place, rotate handle **5** in the direction of the arrow.
10. At the right side of the print engine, close the left and right front doors.
11. To restart your print job, follow the instructions on the Control Center.

### Using the Correct Fuser Web Assembly

There are two different Fuser Web Assemblies available for the Production Press:

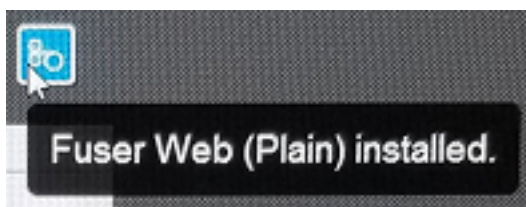
- Fuser Web for standard stock
- Fuser Web for film

 Important: Do not confuse film with transparencies.

The Fuser Web for film is supplied in a box that is labeled clearly as Fuser Web Assembly for Clear Film. When you receive this product, do not throw away the box. When you switch from one Fuser Web to another Fuser Web, store the Fuser Web that is not in use in the box.

The Fuser Web for film does not work with paper stock or standard transparencies. When you run a job, be sure to use the correct Fuser Web. Using an incorrect Fuser Web causes an error to occur.

An icon appears on the screen when a Fuser Web Assembly is installed. When you hover over the icon with your mouse, a message appears that indicates which Fuser Web is installed, either plain or film. For example:



## Finishing

Finishing provides information about how to configure and program the various optional finishing devices that are available for use with the Production Press.

### INTERFACE DECURLER MODULE

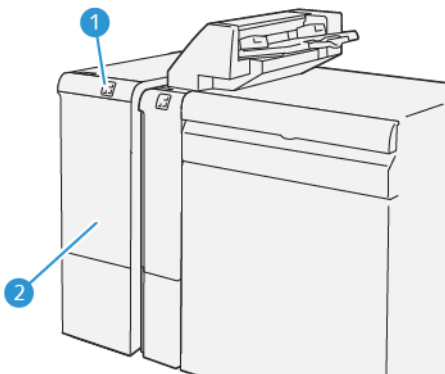
- ⓘ Important: The Interface Decurler Module is required with any inline finishing device installed with the system. It is not required with the Offset Catch Tray.



The Interface Decurler Module provides the following functions:

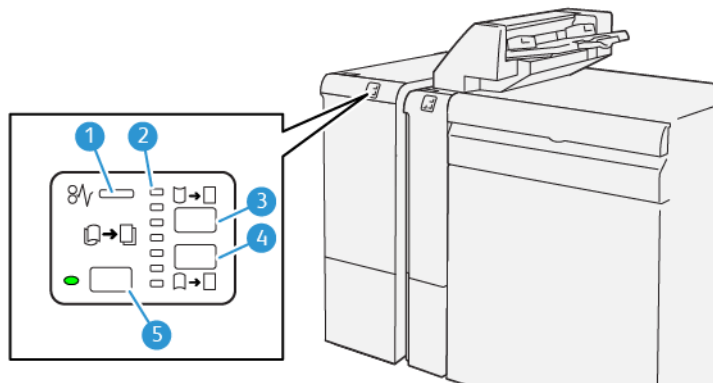
- Communication between the Production Press and the attached finishing device
- Provides an aligned paper path between the Production Press and the attached finishing device
- Matches the sheet speed between the Production Press and the finishing devices
- Cooling and decurling of the paper as it exits the Production Press

### Interface Decurler Module Components



1. Stock Jam and Error Indicator Panel
2. Interface Decurler Module Front Cover

### Interface Decurler Module Control Panel

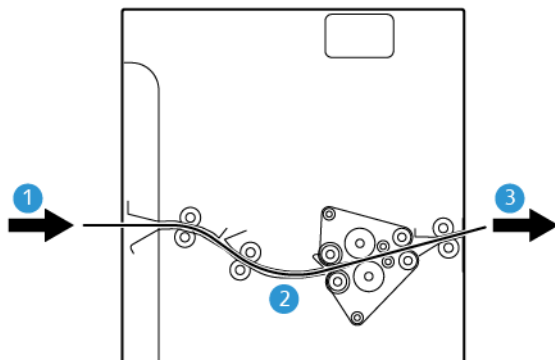


1. Stock Jam and Error Indicator
2. Curl Up and Down Indicators
3. Manual Curl Up Button
4. Manual Curl Down Button
5. Auto Curl Button and Indicator

### Interface Decurler Module Curl Correction



Tip: The purpose of the curl correction is to fix media curl as it leaves the press, but before it reaches the next inline-finishing device. Use the Interface Decurler Module curl correction feature while the press is printing.



1. Printed media from the Production Press
2. Interface Decurler Module Paper Path
3. Printed media from the Interface Decurler Module to Inline Finishing Device

As media enters the module, it moves to the decurler for curl correction. The decurler has a decurler roll that applies pressure to the media based on the following:


- System default **Auto** on
- Manual selections made from the Interface Decurler Module control panel

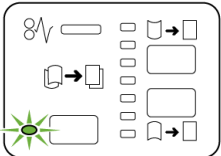
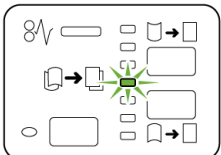
If you want to quickly, and at the point-of-need, adjust the media curl on the printed output, use the manual curl up or down buttons. If, after using these buttons, the printed output contains too much curl, for more adjustment

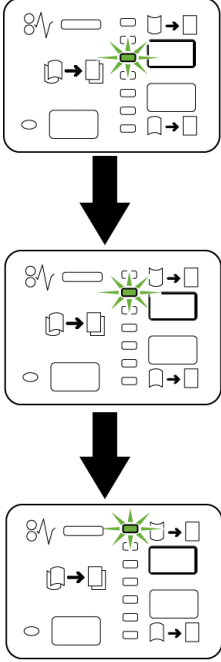
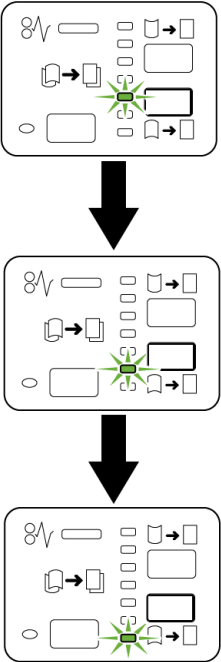
information, refer to [Correcting the Paper Curl](#).

From the decurler, the printed media is cooled and routed from the Interface Decurler Module to the next optional finishing device connected to the Production Press.

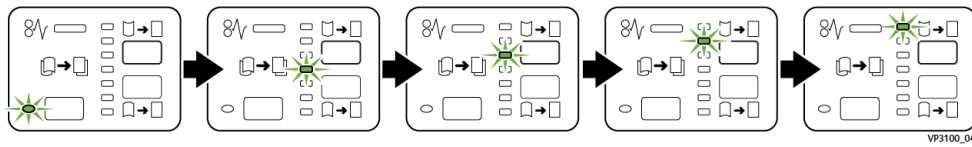
**Interface Decurler Module Curl Correction Modes and Functions**

 Note: When you select an Interface Decurler Module curl correction mode, the new mode is applied to the next sheet that is delivered to the Interface Decurler Module.

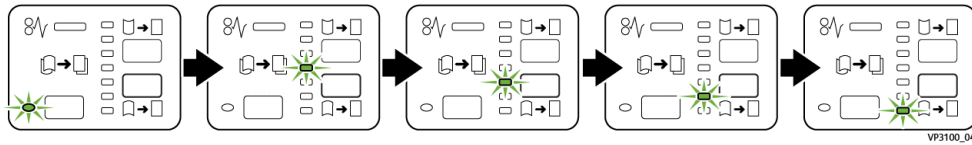
| INDICATOR   | MODE        | FUNCTION   |
|---|-------------|--|
|  <p style="text-align: center; font-size: small;">VP3100_036</p>   | <p>Auto</p> | <p>Auto is the default mode.</p> <ul style="list-style-type: none"> <li>• Automatically corrects the paper curl by selecting the curl direction and amount. This correction is based on the media weight, media type, front and back image coverage, and environment.</li> <li>• When you select Auto, the indicator to the left of the button is lit.</li> <li>• This mode has seven automated settings for controlling paper curl: three up-curl settings, three down-curl settings, and off.</li> <li>• When you use the <b>Auto</b> mode, an indicator momentarily flashes on the control panel. This indicator indicates the preselected curl direction and amount that is being applied to the paper.</li> </ul> |
|  <p style="text-align: center; font-size: small;">VP3100_037</p> | <p>Off</p>  | <p>When this indicator is lit, for either the Auto or Manual modes, no curl correction is applied to the printed output.</p>   |

| INDICATOR   | MODE                    | FUNCTION   |
|---|-------------------------|--|
|    | Manual Upward Curling   | <ul style="list-style-type: none"> <li>• When the printed output is curled upwards, meaning that the edges of the print curl upwards in the output tray, select the curl-up button.</li> <li>• There are three upward curl correction values.</li> <li>• The top three indicators show which level of upward curl correction is selected.</li> <li>• The top indicator is the highest amount of upward curl correction that can be applied to a printed output.</li> </ul>               |
|  | Manual Downward Curling | <ul style="list-style-type: none"> <li>• When the printed output is curled downwards, meaning that the edges of the print curl downwards in the output tray, select the curl-down button.</li> <li>• There are three downward curl correction values.</li> <li>• The top three indicators show which level of downward curl correction is selected.</li> <li>• The bottom indicator is the lowest amount of downward curl correction that can be applied to a printed output.</li> </ul> |

Pressing the **Curl-up** button changes the curl correction levels as shown:



Pressing the **Curl-down** button changes the curl correction levels as shown:



## INSERTER MODULE



Note: The Inserter requires use of a High Capacity Stacker or use of one of the following Production Ready Finishers:

- Production Ready Finisher
- Production Ready Booklet Maker Finisher
- Production Ready Finisher Plus

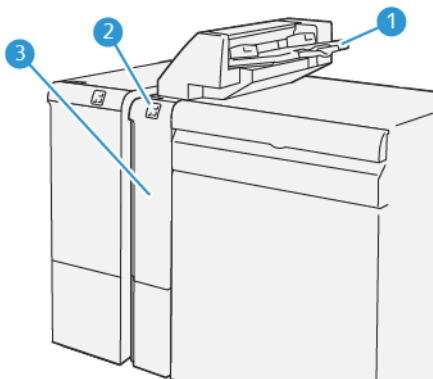
For information on these finishers, refer to [Production Ready Finisher and Production Ready Booklet Maker Finisher](#) and [Production Ready Finisher Plus](#).

To load media such as blank, pre-printed, or special media that you insert into the finished output, use the Inserter. This media serves as separators and covers for the finished output. The Production Press does not print on media fed from the Inserter, Tray T1. Instead, the media is inserted into the printed output at selected locations.



Note: The Inserter sometimes is referred to as the post-process inserter or the interposer.

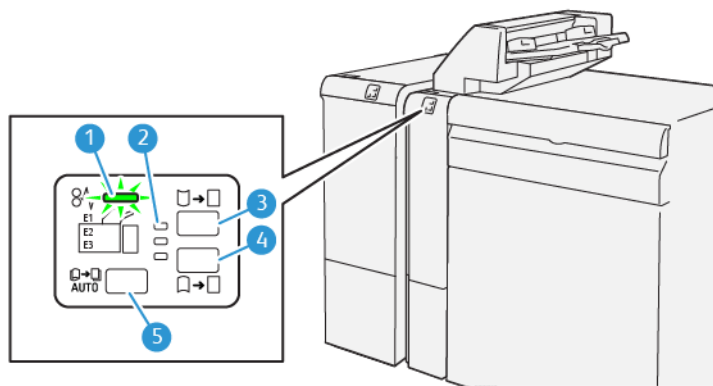
## Inserter Components





1. Inserter Tray, or Tray T1
2. Inserter Control Panel
3. Inserter Front Cover

### Inserter Control Panel



| NUMBER | COMPONENT                                 | DESCRIPTION  |
|--------|---|--|
| 1      | Paper Jam and Error Indicator             | This indicator lights when a jam occurs in the Inserter.   |
| 2      | Curl Up or Down Indicators                | These indicators display the operating mode of the Decurler inside the Inserter. This feature is not required when a system is equipped with an Interface Decurler module. In these cases, the Decurler function is disabled. There are only three curl correction options for the Inserter: <ul style="list-style-type: none"> <li>• One upward curl correction, which is the top indicator.</li> <li>• One downward curl correction, which is the bottom indicator.</li> <li>• Off, or no curl correction, which is the middle indicator.</li> </ul> |
| 3      | IP Auto Decurler Switch – Button 5        |  |
| 4      | IP Manual Decurler Up Switch – Button 3   |  |
| 5      | IP Manual Decurler Down Switch – Button 4 |  |

### Media for Inserter Tray T1



Tip: Media fed from the Inserter is pre-printed or blank media. At selected locations, the Inserter places these sheets into the printed output.


### Supported Media for Inserter Tray T1

| MEDIA SIZE   | MEDIA WEIGHT  | TRAY CAPACITY                      |
|--|---|------------------------------------|
| 182 x 148 mm (7.2 x 5.8 in.) – 330 x 488 mm, or A3 (13 x 19.2 in.) | 52–400 g/m <sup>2</sup> uncoated 72–350 g/m <sup>2</sup> coated | 250 sheets<br>Based on Colotech+90 |

#### Loading Media in the Inserter Tray

Before using the Inserter Tray, review the following guidelines:

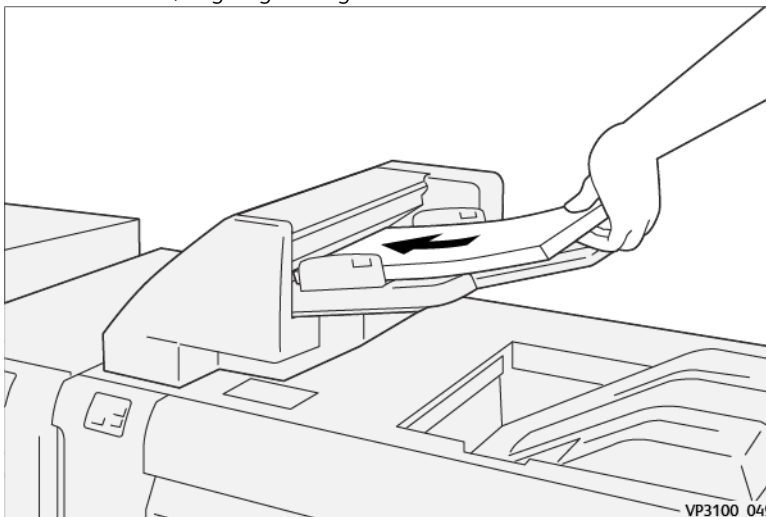
- Remove any remaining media from the tray.
- Load all the media required for the job into the tray.
- To use saddle stitch or bi-fold options, ensure that the media loaded in the main feeding tray, such as tray 1, is the same size as the media loaded in the Inserter Tray.
- For supported media information, refer to [Inserter Tray](#).

 Note: When the Inserter Tray is filled with 8.5-in. wide, SEF media, its default size is 8.5 x 14-in. If you insert 8.5 x 11-in. media, adjust the default of NVM 769–503 using the Admin Mode tools. For more instruction, refer to [For Administrators](#).

To insert separator sheets or cover sheets, such as blank or pre-printed sheets, use the Inserter Tray. Media loaded in the Inserter Tray is inserted into the finished, printed output. The Inserter Tray holds a maximum of 250 sheets of Colotech+90.

 Tip: The Production Press does not print on media fed from the Inserter. Instead, the media is inserted into the printed output at selected locations.

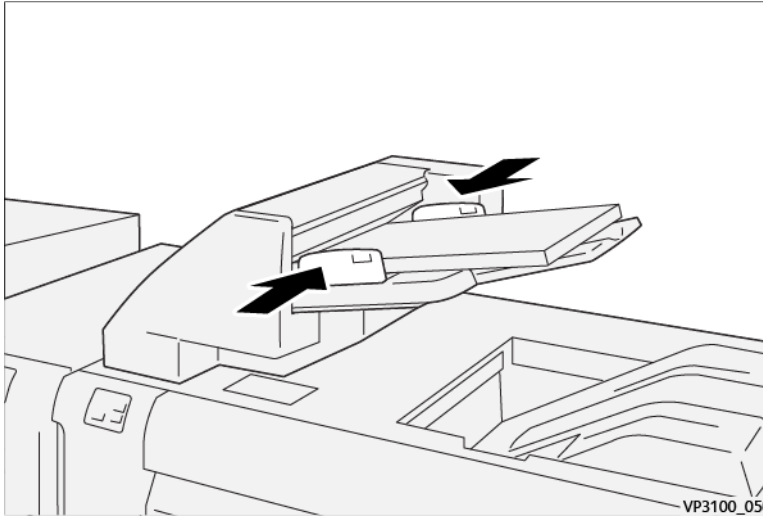
1. Load the media, aligning all edges.



For pre-printed media, load it with the printed side facing up.

 Note: To avoid jams or Production Press malfunctions, do not load media above the maximum fill line.

2. Hold the center of the paper guides and gently slide them to the appropriate media size so that they touch the edges of the media.



If the distance between the guides is too long or short relative to the media, jams can occur.

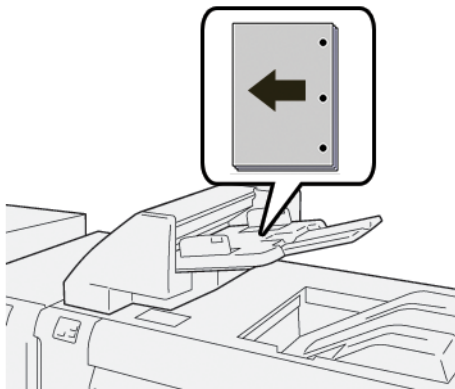
If set by the system administrator, the Tray Properties window appears on the main window of the Control Center.

3. From the Tray Properties window, enter or verify the correct media information.
4. To save the information and close the Tray Properties window, select **OK**.

### Printing on Special Media

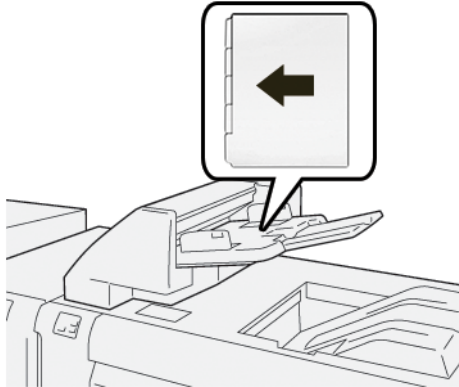
#### Hole-Punched Media

Load hole-punched media into the Inserter Tray long-edge feed (LEF), and with the holes on the right side when you face the front of the Inserter.



#### Tab Media

Load tab media in the Inserter Tray long-edge feed (LEF), and with the tabs on the left side when you face the front of the Inserter.



### Managing Inserter Productivity

You can choose how the Production Press manages productivity when using the Inserter Tray, also called tray T1. The Inserter Productivity setting determines how the Production Press behaves in the following conditions:

- When blank or pre-printed sheets from the Inserter Tray are inserted into the printed output
- When the Inserter Tray runs out of stock

The Inserter Productivity setting offers two options:


- **Priority on Sequence Accuracy:** For each set, before printing, the Production Press checks to ensure that paper is loaded in the Inserter Tray. After confirming that paper is loaded in the Inserter Tray, the Production Press starts printing the job. Immediately prior to the insertion of a sheet from the Inserter Tray, the Production Press pauses printing. After the sheet is inserted, the Production Press resumes printing. This setting results in increased waiting time and thus, decreased productivity. However, printed output is not purged when the paper loaded in the Inserter Tray runs out.
- **Priority on Productivity:** The Production Press starts printing regardless of the status of the Inserter Tray. As long as paper is loaded in the Inserter Tray, printing does not pause when a sheet is inserted. However, when the paper in the Inserter Tray runs out, printing pauses and the printed output in the paper path between the print engine and the Inserter is purged to the first output tray beyond the Inserter. After the Inserter Tray is reloaded with paper, printing resumes, starting with reprinting the sheets that were purged. This setting helps you to maintain productivity.

 Note:

- To avoid paper jams, do not reuse the output that is purged from the paper path.
- Priority on Productivity is the default setting for Inserter Productivity.

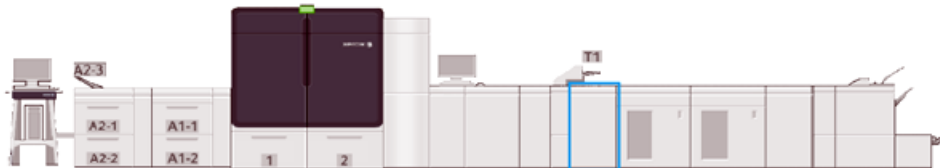
### GBC® ADVANCEDPUNCH® PRO

The GBC® AdvancedPunch® Pro is an automatic hole punch module that integrates with the Production Press to streamline the production of reports, directories, pricing guides, and other bound books. By eliminating manual punching, the punch saves time and increases productivity. The compact GBC®AdvancedPunch® Pro requires minimal space and accepts various optional multiple hole punch die sets.

 Note: The GBC®AdvancedPunch® Pro requires use of a High Capacity Stacker or use of one of the following Production Ready Finishers:

- Production Ready Finisher
- Production Ready Booklet Maker Finisher
- Production Ready Finisher Plus

For information on these finishers, refer to [Production Ready Finisher and Production Ready Booklet Maker Finisher](#) and [Production Ready Finisher Plus](#).




The GBC®AdvancedPunch® Pro provides the following capabilities:

- Punches a broad range of media sizes and types
- Trail edge, LEF, and SEF punching
- Die set detection control panel shows die type and cycle count
- To enable most popular binding formats, user die set options include comb, wire, coil, and 3–7 hole varieties
- Operates at rated print engine speed for most media sizes
- Quick-change die sets that can be interchanged without any tools
- All die sets include an identification label that provides the hole pattern and name
- Convenient storage area for two extra die sets, which is located above the sheet bypass on the device

For detailed information and instructions for using the GBC® AdvancedPunch® Pro, refer to the guide on the customer documentation CD that came with the device, or go to [www.xerox.com/IRIDESSEsupport](http://www.xerox.com/IRIDESSEsupport).

## HIGH CAPACITY STACKER

 Note: This optional finishing device requires the Interface Decurler Module.

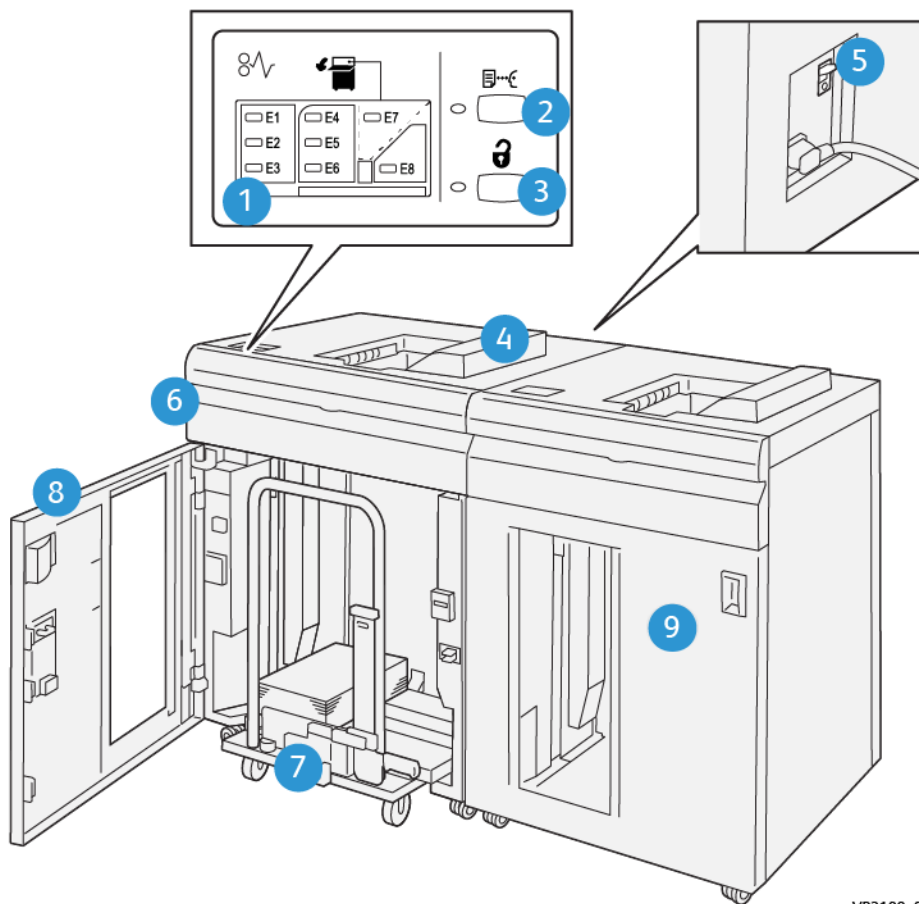
The High Capacity Stacker is an optional finishing device that provides large-capacity stacking and offsetting capabilities for production output to a stacker tray and cart. The High Capacity Stacker also provides a top tray that is convenient for short stack runs.



### High Capacity Stacker Media Guidelines


- The stacker tray and cart accepts 52–400 g/m<sup>2</sup> either coated or uncoated media. Degraded stack quality and increased jam rate for media heavier than 300 g/m<sup>2</sup> is possible.
- Transparencies can go to either the top tray or the stacker tray and cart. Limit the stack height to 100 transparencies.
- Coated media lighter than 100 g/m<sup>2</sup> does not run as reliably as coated media heavier than 100 g/m<sup>2</sup>.
- The stacker does not offset or tap stack a media size of 13 x 19 in. or SRA3.

### High Capacity Stacker Components



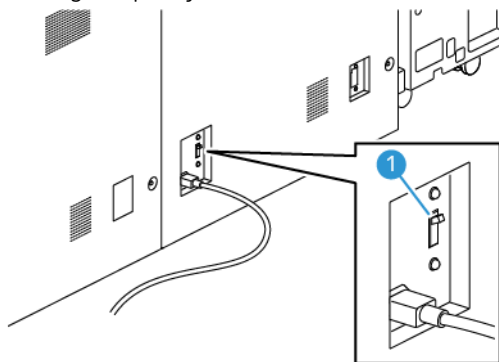
VP3100\_062

| NUMBER | COMPONENT               | DESCRIPTION   |
|--------|-------------------------|---|
| 1      | Jam or Error Indicators | These indicators illuminate when a jam occurs in the E1–E8 areas of the High Capacity Stacker.  |
| 2      | <b>Sample</b> Button    | Select this button to have the High Capacity Stacker deliver a sample sheet to the top tray.<br><br>The indicator to the left of the button blinks until a sample sheet is delivered to the top tray. |

| NUMBER | COMPONENT                             | DESCRIPTION   |
|--------|---------------------------------------|---|
| 3      | <b>Unload</b> Button                  | Select this button to stop printing and remove the paper.   |
| 4      | Top Tray                              | The tray holds a maximum of 500 sheets of 80 g/m <sup>2</sup> or less. The top tray accepts the following media sizes and weights: <ul style="list-style-type: none"> <li>• <b>Sizes:</b> 98 x 146 mm (3.9 x 5.7 in.)–330.2 x 488 mm (13 x 19.2 in.)</li> <li>• <b>Stock Weights:</b> 52–400 g/m<sup>2</sup> uncoated and 72–350 g/m<sup>2</sup> coated</li> </ul>  |
| 5      | Circuit Breaker Switch                | The circuit breaker switch is on the rear of the High Capacity Stacker. If an electrical failure or a short circuit occurs, this switch automatically shuts off the electricity.  |
| 6      | Top Cover                             | Open this cover to clear paper jams.  |
| 7      | Stacker Tray and Cart                 | The tray and cart holds a maximum of 500 sheets of 80 g/m <sup>2</sup> or less. The Stack Tray and Cart accept the following media sizes and weights: <ul style="list-style-type: none"> <li>• <b>Sizes:</b> 203 x 182 mm (8.0 x 7.2 in.)–330.2 x 488 mm (13 x 19.2 in.)</li> <li>• <b>Stock Weights:</b> 52–400 g/m<sup>2</sup>(56–360 g/m<sup>2</sup>) for stack offset feature</li> <li>• <b>Capacity:</b> 5000 sheets (80 g/m<sup>2</sup> or less)</li> </ul> <p> <b>Note:</b> Due to unique characteristics of some media, stack quality handling can degrade with media exceeding 300 g/m<sup>2</sup>.</p> |
| 8      | Front Door                            | Open this door to remove media and printed output.  |
| 9      | Optional Second High Capacity Stacker | A second, optional High Capacity Stacker can be added to the system configuration for more output capacity.   |

### High Capacity Stacker Circuit Breaker


The High Capacity Stacker circuit breaker is on the rear of the High Capacity Stacker unit.



## Working With

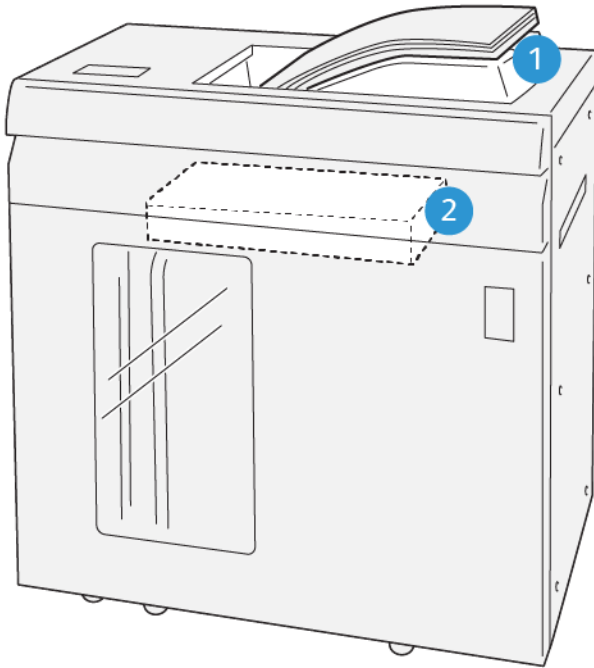
### 1. On or Off Switch

The circuit breaker switch is normally in the **ON** position.

 Note: When an electrical interruption occurs, to discontinue the electrical flow to the High Capacity Stacker, the circuit breaker automatically switches off. For electrical information, refer to [Electrical Safety](#).

### Output Trays

The High Capacity Stacker has two output trays.



VP3100\_064

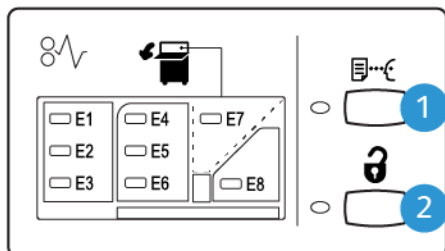
### 1. Top Tray

### 2. Stacker Tray and Cart

The Top Tray offers the following:

- Convenience for short stack runs, up to 500 sheets, without offsetting
- Delivery of purged sheets

### Control Buttons




VP3100\_065

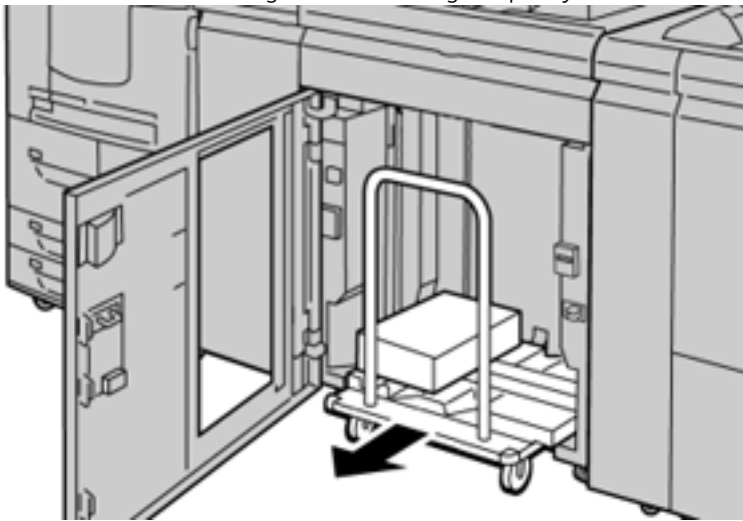


1. **Sample** button: To output a sample sheet to the top tray, select this button.
2. **Unload** button: To stop printing and remove paper, select this button.

### Unloading the Stacker Tray and Cart

 Note: With the optional second High Capacity Stacker, you can unload one High Capacity Stacker while the output is directed to the other High Capacity Stacker.

1. On the High Capacity Stacker control panel, select the **Unload** button.
2. When the Unload Indicator illuminates, open the High Capacity Stacker front door.
3. Position the securing bar on top of the stacked media.
4. Pull the **Stacker Cart** straight out of the High Capacity Stacker.



5. Remove the securing bar.
6. Remove the media from the stacker tray.
7. Push the empty Stacker Cart straight into the High Capacity Stacker.
8. Position the securing bar in the storage area inside the Stacker Cart.
9. Close the front door.

The tray rises to the Operate position.

### Hints and Tips


When you use the High Capacity Stacker, refer to the following hints and tips:

1. In the applicable High Capacity Stacker tray, check the media for curl.
  - a. If no curl is present, and if the output is acceptable and meets your requirements, you are finished.
  - b. If curl is present, continue to the next step.
2. To correct the media curl, use the curl correction controls on the top of the Interface Decurler Module.
3. If the output is not improved, adjust the curl again.

4. If the output is still not improved, call the Customer Support Center.

## CREASE AND TWO-SIDED TRIMMER

The Crease and Two-Sided Trimmer trims the tops and bottoms of sheets or booklets to produce an even edge and a full bleed when combined with the SquareFold® Trimmer Module.

 Note: This optional finishing device requires one of the following Production Ready Finishers:

- Production Ready Finisher
- Production Ready Booklet Maker Finisher
- Production Ready Finisher Plus



The Crease and Two-Sided Trimmer is an optional finishing device that provides page creasing and trimming on two sides of the output.

The Crease and Two-Sided Trimmer performs the following tasks:

- To produce an output with the appropriate finished width and appearance, trims 6–25 mm (0.24–0.99 in.) from the top and bottom of prints or booklets.

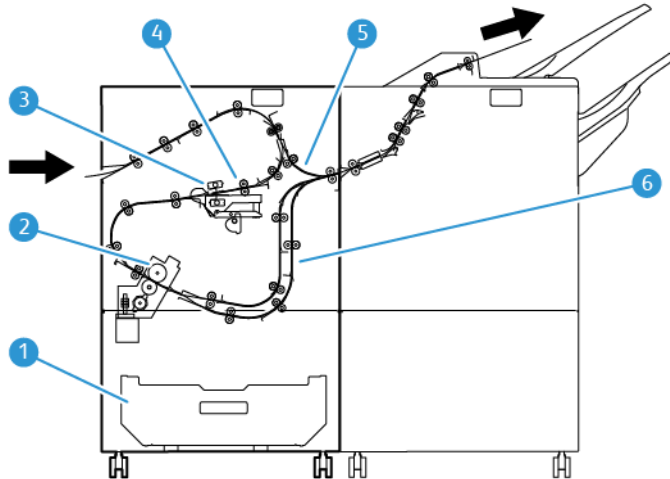
 Note:

- If you crease the media within 62 mm of the lead edge, the chance of jams increases.
- The lowest crease setting value of 1 possibly does not produce any visible crease on some media.
- Trims incoming media sizes 194 x 257 mm (7.6 x 10.1 in.)–330.2 x 488 mm (13 x 19.2 in.)
- Trims incoming media sizes 52–400 g/m<sup>2</sup> or coated paper 106–350 g/m<sup>2</sup>

When paired with the SquareFold® Trimmer, all sides of booklets can be trimmed except the binding, which enables full-bleed booklets. For information, refer to [SquareFold® Trimmer](#).

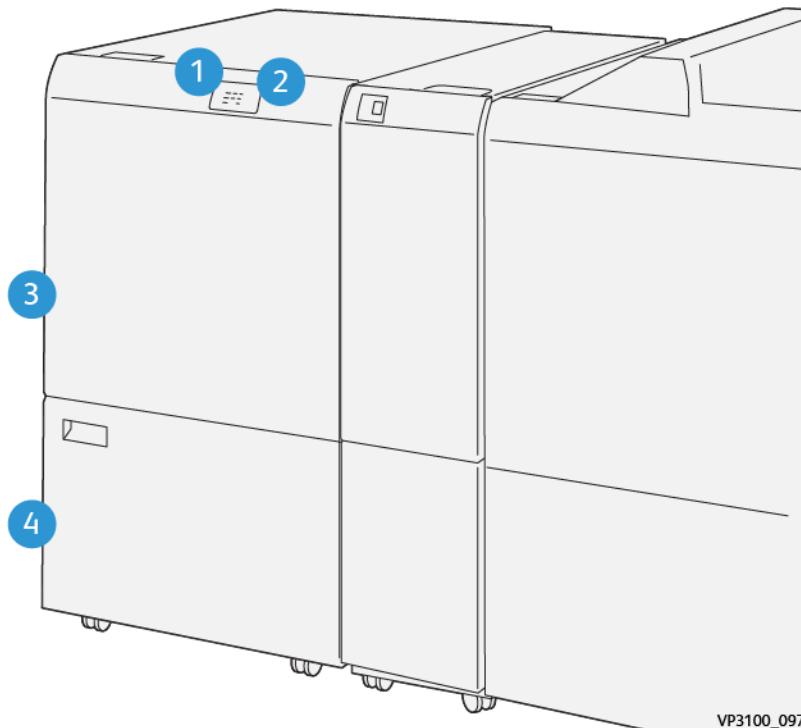
### Crease and Two-Sided Trimmer Configuration

The Crease and Two-Sided Trimmer trims the top and bottom edge of output media, applies creases in the vertical direction, and overlaps two sheets of output.



1. Dust Box: The Dust Box stores trim waste.
2. Trimmer: The Trimmer trims the top and/or bottom edges in the process direction.
3. Creaser: The Creaser applies creases in the vertical direction.
4. Registration: The Registration adjusts media skew and detects the position of the media.
5. Bypass: The Bypass transports media through the remaining modules without providing finishing.
6. Buffer: The Buffer overlaps two sheets of media to output.

### Crease and Two-Sided Trimmer Components



VP3100\_097

| NUMBER | COMPONENT                              | DESCRIPTION   |
|--------|--|---|
| 1      | Stock Jam and Error Indicator          | This indicator illuminates when a jam occurs.<br>If the indicator is blinking, clear the jam so that printing can resume. |
| 2      | Trimmer Waste Container Full Indicator | This indicator illuminates when it is time to empty the Trimmer Waste Container and blinks when the container is full.    |
| 3      | Upper Cover                            | To clear jams, open this cover.   |
| 4      | Lower Cover                            | To empty the Trimmer Waste Container, open this cover.  |

### Crease and Two-Sided Trimmer Maintenance

For information about maintaining optimum performance of the trimmer by removing trimmed waste and clearing debris, refer to [Emptying the Crease and Two-Sided Trimmer Waste Container](#).

#### Emptying the Crease and Two-Sided Trimmer Waste Container

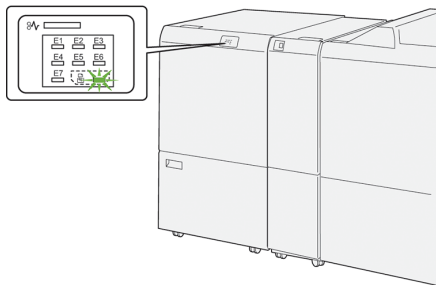
When the waste container of the Crease and Two-Sided Trimmer is nearly full, an indicator illuminates on the top of optional accessory.



Note: You can empty the waste container before it reaches its full condition, and can empty it with the printer running.

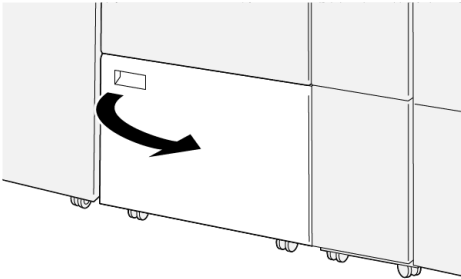
When the waste container reaches the full condition, the following changes occur:

- The indicator changes from a steady lighted condition to blinking.
- A message appears on the Production Press, indicating that the waste container is full.



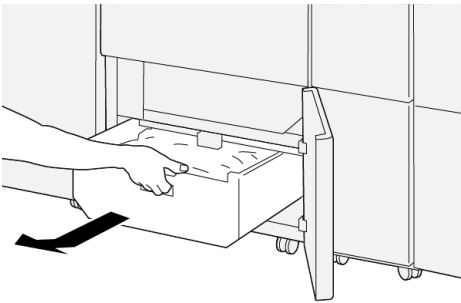
To empty the waste container, perform the following steps.

1. Open the lower cover of the Crease and Two-Sided Trimmer.



VP3100\_088

2. Pull out and remove the waste container.



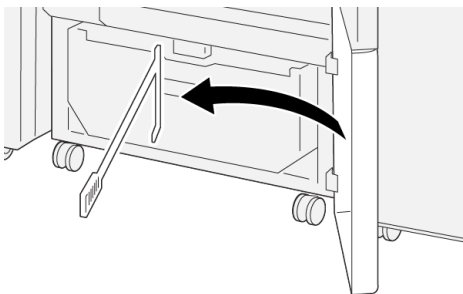
VP3100\_090

3. Discard all waste.

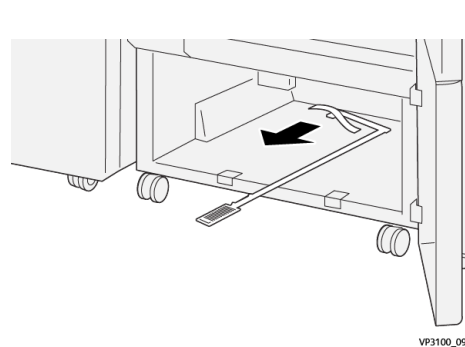


Important: Ensure that you completely empty all waste from the container. If waste or debris remains in the container, the trimmer can malfunction.

4. To ensure that you remove all waste and debris, especially beneath the frame that is located behind the container, to remove any remaining waste from inside the trimmer, use the cleaning rod.



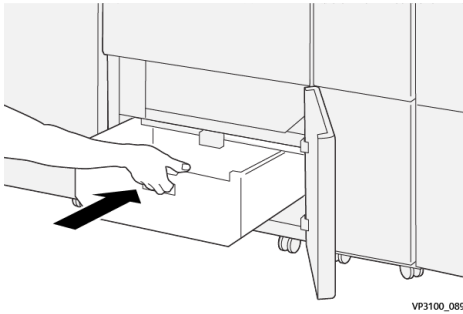
VP3100\_091



VP3100\_099

5. Return the cleaning rod to its original position, inside the lower cover.

- Reinsert the waste container and push it in fully.



- Close the lower cover.

### Crease and Two-Sided Trimmer Module

|                                     |  |
|-------------------------------------|--|
| Function                            | <ul style="list-style-type: none"> <li>Trims 6–25 mm (0.2–0.9 in.) from the head and the foot of the sheets, the inboard and outboard edges</li> <li>Provides full-bleed trim for booklets when used with the Xerox® SquareFold® Trimmer</li> <li>Creates an attractive crease fold</li> </ul> |
| Paper size for 2-sided sheet trim   | <ul style="list-style-type: none"> <li>Minimum: 194.0 x 210.0 mm (7.7 x 8.3 in.)</li> <li>Maximum: 330.0 x 488.0 mm (13.0 x 19.2 in.)</li> </ul>   |
| Paper size for 2-sided booklet trim | <ul style="list-style-type: none"> <li>Minimum: 194.0 x 257.0 mm (7.7 x 10.12 in.)</li> <li>Maximum: 330.0 x 488.0 mm (13.0 x 19.2 in.)</li> </ul>   |
| Paper Weight                        | <ul style="list-style-type: none"> <li>Trim: 52–400 g/m<sup>2</sup></li> <li>Crease: 106–350 g/m<sup>2</sup></li> <li>Bypass: 52–400 g/m<sup>2</sup></li> </ul>  |
| Creasing                            | <ul style="list-style-type: none"> <li>For booklets, scores outside cover and innermost sheet</li> <li>For sheets, scores all folds for offline folding so that sheets exit flat</li> </ul>  |
| More Details                        | <ul style="list-style-type: none"> <li>To regulate booklet processing and keep pace with print engine productivity, contains a Buffer Assembly</li> </ul>  |

## Creaser Media Specifications



Note:

- 157 g/m<sup>2</sup> or heavier when not using Saddle Stitch and Bi-Fold. You can also apply a crease to paper weighing 156 g/m<sup>2</sup> or lighter. However, if you can fold the output paper sheets easily by hand along the crease lines, for example, the crease quality cannot be guaranteed.
- If wrinkles occur around crease lines on output sheets when you are using Saddle Stitch and Bi-Fold, in the Manage Stock Library, set the Crease Pressure to a lower value.

## Paper Weight

60–350 g/m<sup>2</sup> Saddle Stitch and Bi-Fold

## Paper Size

### Standard and Custom Sizes

|          |         |  |
|----------|---------|--|
| Standard | Maximum | SRA3 (320 x 450 mm, 12.6 x 17.7 in.)   |
|          | Minimum | A4 (210 x 297 mm, 8.27 x 11.69 in.)<br>184.15 x 266.7 mm (7.25 x 10.5 in.)                         |
| Custom   | Height  | 182.0–330.2 mm (7.2–13 in.)  |
|          | Width   | Width to Top Tray: 210–488 mm (3.3–19.2 in.)<br>Width to Booklet Maker: 257–488 mm (10.1–19.2 in.) |

## Number of Lines

1–5



Note: When the media size is less than 254 mm (10 in.) landscape, or is 437 mm (17.2 in.) landscape or larger, the maximum number of crease lines allowed is three.

## Crease Buffer Module









- This module can create up to five creases on a sheet of paper.
- This module can produce multiple creases in a combination of spine up and spine down orientations.
- The pressure of the folding line can be adjusted to five levels.

## Crease Fold Types

The Crease and Two-Sided Trimmer can produce many possible fold types as follows:









### One- and Two-Line Crease – Internal Printing

#### Paper Fold Types

| Fold Type | Bi-Fold   | Tri-C   | Tri-Z  | Z-Fold  |
|-----------|---|---|--|---|
| Crease    | 1 Line  | 2 Lines   | 2 Lines  | 2 Lines   |
| Landscape |  |  |  |  |
| Portrait  |  |  |  |  |

### One- and Two-Line Crease – External Printing

#### Paper Fold Types











| Fold Type | Bi-Fold   | Tri-C   | Tri-Z  | Z-Fold  |
|-----------|---|---|--|---|
| Crease    | 1 Line  | 2 Lines   | 2 Lines  | 2 Lines   |
| Landscape |  |  |  |  |
| Portrait  |  |  |  |  |

### Three-, Four-, and Five-Line Crease – Internal Printing

#### Paper Fold Types











| Fold Type | Gate-Fold | Accordion-Fold | Quatro-Letter-Fold | Accordion – 4 Lines | Accordion – 5 Lines |
|-----------|-----------|----------------|--------------------|---------------------|---------------------|
| Crease    | 3 Lines   | 3 Lines        | 3 Lines            | 4 Lines             | 5 Lines             |



|           |   |   |   |   |   |
|-----------|---|---|---|---|---|
| Landscape |  |  |  |  |  |
| Portrait  |  |  |  |  |  |

### Three-, Four-, and Five-Line Crease – External Printing

#### Paper Fold Types

| Fold Type | Gate-Fold   | Accordion-Fold  | Quatro-Letter-Fold  | Accordion – 4 Lines)  | Accordion – 5 Lines   |
|-----------|---|---|---|---|---|
| Crease    | 3 Lines   | 3 Lines   | 3 Lines   | 4 Lines   | 5 Lines   |
| Landscape |   |   |   |   |   |
| Portrait  |  |  |  |  |  |

#### Crease Ranges for Crease and Two-Sided Trimmer Module

The crease ranges for the Crease and Two-Sided Trimmer Module are set initially, but you can adjust the ranges as needed. Refer to the Fiery website at [Fiery - Xerox Iridesse Production Press](#). Scroll down and select *Fiery Crease for Standard and Custom*, click the version (or NA), then click **Go**. Open the Addendum pdf.

#### C/Z FOLDER



Note: The C/Z Folder requires use of an Interface Decurler Module, and use of one of the following Production Ready Finishers:

- Production Ready Finisher
- Production Ready Booklet Maker Finisher

- Production Ready Finisher Plus

For information on these finishers, refer to [Production Ready Finisher and Production Ready Booklet Maker Finisher](#) and [Production Ready Finisher Plus](#).

The C/Z Folder is an optional finishing device that provides C-Fold and Z-Fold output for 8.5 x 11 in./A4 output and 11 x 17 in./A3 media.



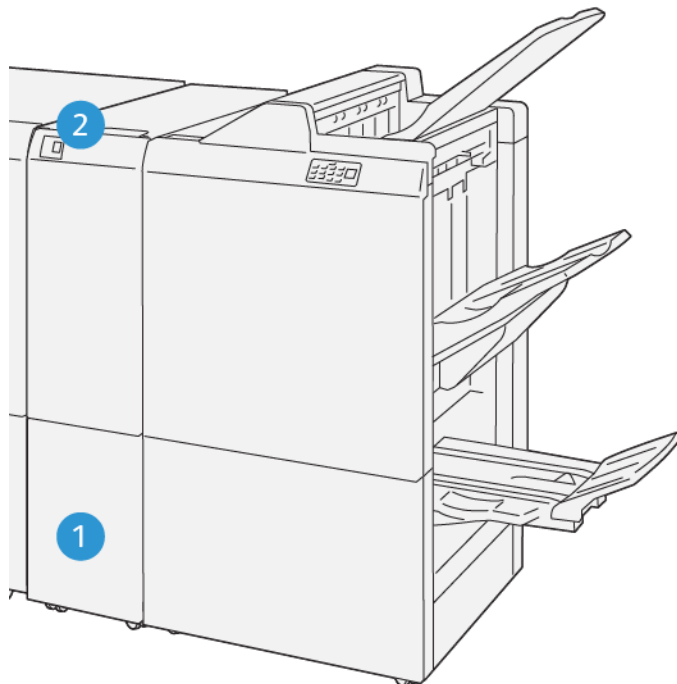
To produce folded output, select the **Fold** feature.

- For network print jobs, from the print driver, select the **Fold** feature.
- To use the **Fold** feature, ensure that the orientation of the documents is short-edge feed (SEF). Select a tray that contains SEF media.
- There are three types of folds available: C-Fold, Z-Fold, and Z-Fold Half-Sheet.

### C/Z Folder Components



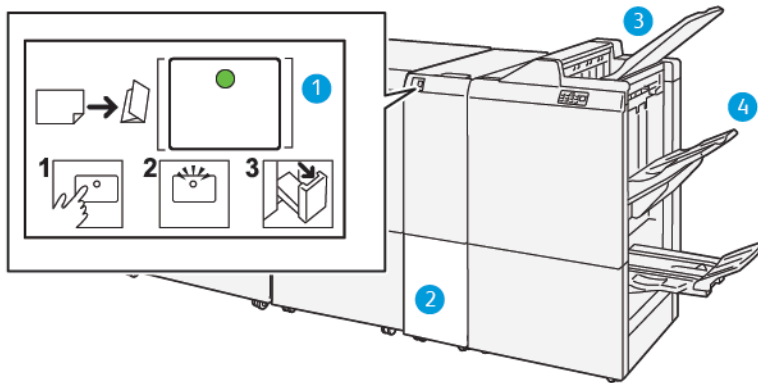
Note: For detailed information about the Fold Adjustment feature, refer to the *Advanced Stock Setup* in *Manage Stock Library for Fold Adjustment Profiles*.




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| NUMBER | COMPONENT                  | DESCRIPTION  |
|--------|----------------------------|--|
| 1      | Trifold Output Tray        | This tray receives output sheets.                    |
| 2      | Trifold Output Tray Button | To open the trifold output tray, select this button. |

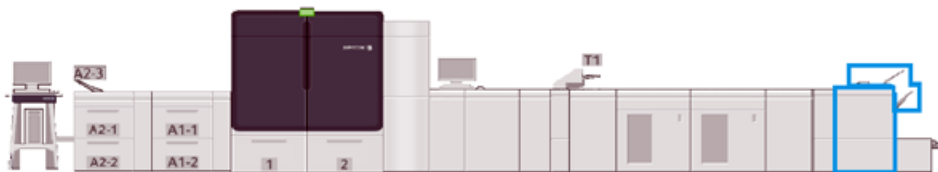
### Trifold Output




| NUMBER | COMPONENT                          | DESCRIPTION  |
|--------|------------------------------------|--|
| 1      | Trifold Output Tray Button         | When you select the button, the indicator flashes. When the trifold output tray is unlocked, and the indicator shows a steady light on with no blinking, pull out the trifold output tray.               |
| 2      | Trifold Output Tray                | C-Fold or Z-Fold jobs are delivered to this tray only.<br> Note: C/Z Fold jobs cannot be delivered to any other tray. |
| 3      | Production Ready Finisher Top Tray | This tray receives Z-Fold Half Sheet output.   |
| 4      | Stack Tray                         | This tray receives Z-Fold Half Sheet output.   |

### PRODUCTION READY FINISHER AND PRODUCTION READY BOOKLET MAKER FINISHER

 Note: These optional finishing devices require the Interface Decurler Module.



 Note: Throughout this section, the Production Ready Finisher and Production Ready Booklet Maker Finisher are called the Finisher. Use of the specific finisher name distinguishes any differences between the two finishers.


The Production Ready Finisher and Production Ready Booklet Maker Finisher provide the following capabilities:

- **Top Tray**


- Media Sizes: 98 x 146 mm (3.9 x 5.7 in.)–330.2 x 488 mm (13 x 19.2 in.)
- Media Weights: 52–400 g/m<sup>2</sup>
- Capacity: 500 sheets, (82 g/m<sup>2</sup> or less)

- **Stack Tray:**

- Media Sizes for stack only: 148 x 146 mm (5.8 x 5.7 in.)–330 x 488 mm (13 x 19.2 in.)
- Media Sizes for stack and offset: 203 x 146 mm (8.0 x 5.7 in.)–297 x 488 mm (11.7 x 19.2 in.)
- Media Sizes for stack and staple: 182 x 182 mm (7.2 x 7.2 in.)–297 x 432 mm (11.7 x 17.0 in.)
- Media Weights for stack: 52–400 g/m<sup>2</sup> (max 360 with offset)


 Note: Due to unique characteristics of some media, stack quality handling can degrade with media exceeding 350 g/m<sup>2</sup>.

- Media Weights for staple: 52–400 g/m<sup>2</sup>
- Media Weights for Half-Accordion Fold, or Z-Fold: 60–105 g/m<sup>2</sup>

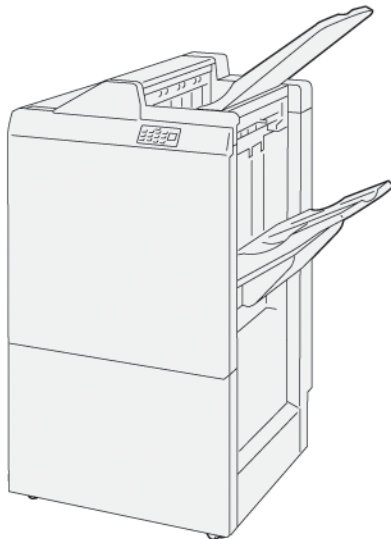
 Note: Due to grain orientation of some media, fold quality and reliability can degrade with media exceeding 90 g/m<sup>2</sup>.

- Capacity: 3000 sheets for Production Ready Finisher and 2000 for Production Ready Booklet Maker Finisher, 82 g/m<sup>2</sup> or less

### **Production Ready Finisher**

 Note: This optional finishing device requires the Interface Decurler Module.

 Note: The optional C/Z Folder is available for this finisher.



The Production Ready Finisher consists of:

- Two output trays: Top Tray and Stacker Tray
- Stapler
- Optional Basic Punch

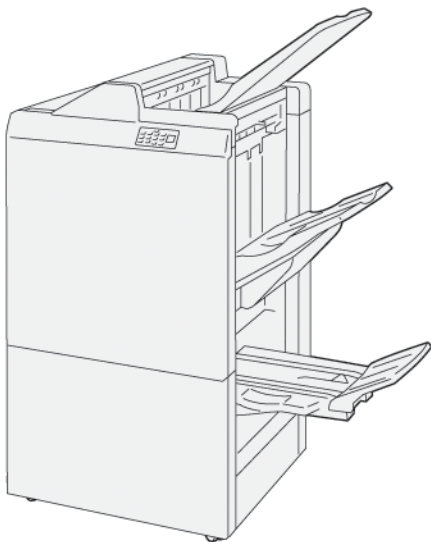
### Production Ready Booklet Maker Finisher



Note: This optional finishing device requires the Interface Decurler Module.

### Production Ready Booklet Maker Finisher

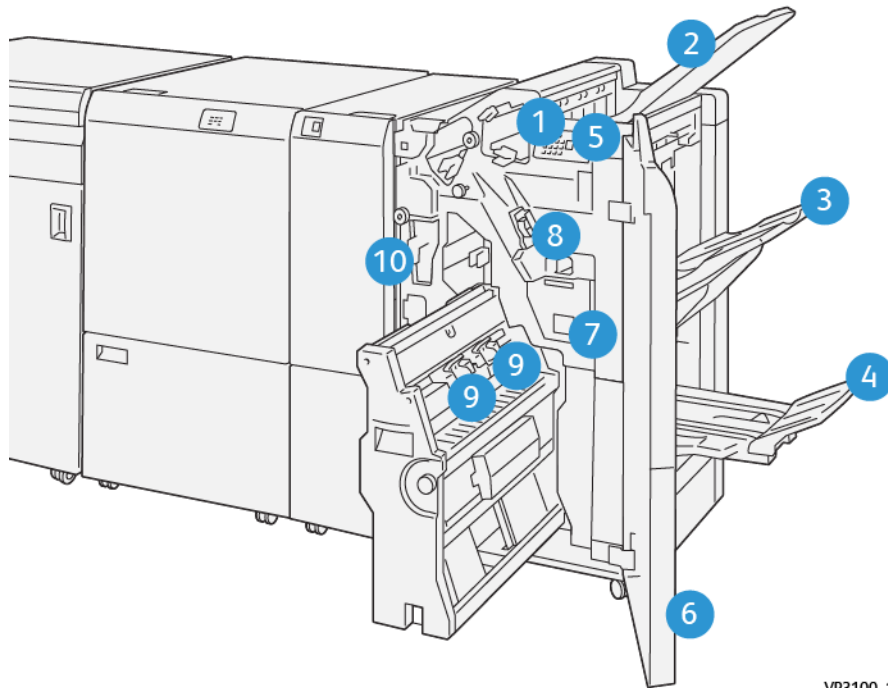
The Production Ready Booklet Maker Finisher provides all the same features as the Production Ready Finisher. In addition, the Production Ready Booklet Maker Finisher automatically creates saddle-stitched booklets of up to 30 sheets and bi-folding, also called single-folding.



The Production Ready Booklet Maker Finisher consists of:

- Three output trays: Top Tray, Stacker Tray, and Booklet Output Tray
- Booklet Maker Unit
- Stapler
- Optional Basic Punch

## Finisher Components



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1. Paper Jam Error Indicator
2. Top Tray
3. Stacker Tray
4. Booklet Tray\*
5. Booklet Output Button\*
6. Front Cover
7. Staple Waste Container
8. Basic Staple Cartridge for Side Stitch
9. Two Booklet Staple Cartridges for Saddle Stitch\*
10. Hole Punch Waste Container\*\*

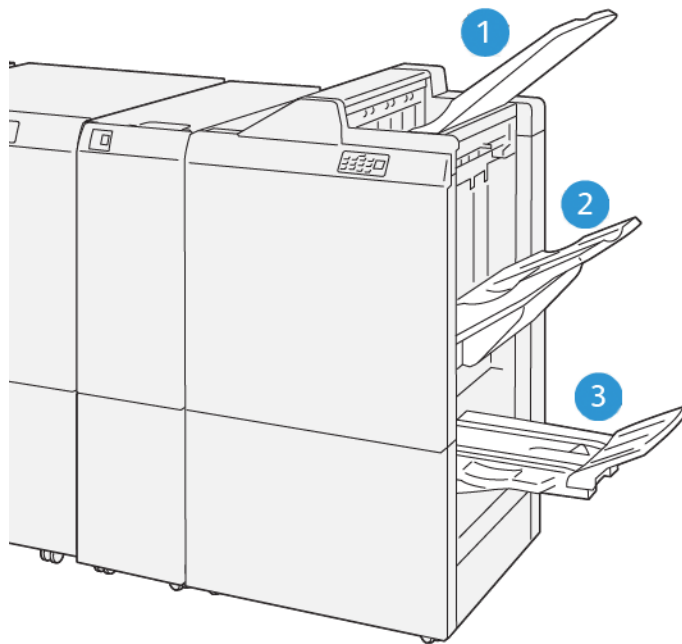


Note: \* Available only with the Production Ready Booklet Maker Finisher.



Note: \*\* The Hole Punch Waste Container is needed only for the optional Basic Punch.

## Finisher Output Trays



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1. Top tray
2. Stacker tray
3. Booklet tray\*

\*Available only with the Production Ready Booklet Maker Finisher.

### Top Tray


Description:

- Receives printed output and sample sheets
- Capacity of 500 sheets measuring 330 x 488 mm (13 x 19.2 in.).
- Collects all sheets automatically ejected before and after a jam
- Used for printing on postcards

If output sheets do not fully eject, the Production Press detects a Paper Full condition. If this condition occurs frequently, change the angle of the top tray.

Refer to the following guidelines for changing the top tray angle:

- For normal usage, keep the tray in its lower, default position.

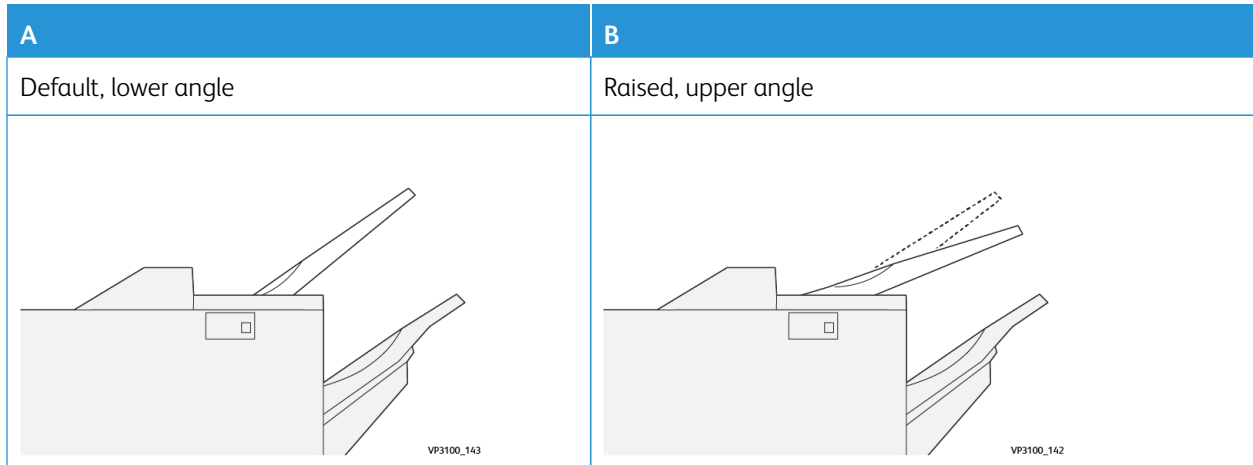
 Important: Continual use of the tray in the upper position, can cause paper jams or output sheets to fall from the tray when delivered.

- When using the following media types, change the angle of the tray to its upper position. These media types can cause frequent Paper Full conditions:

## Working With

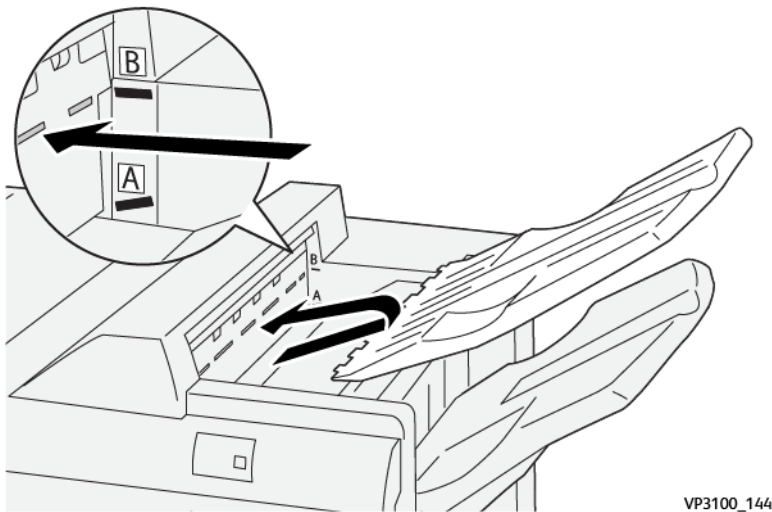
- Light-weight (106 g/m<sup>2</sup> or lighter) coated paper
- Coated media having edges that are 364 mm or longer
- Long sheet

 Note: Changing the tray angle does not affect curl.



To change the angle of the tray:


1. Pull the top tray from the lower seating (A) by pulling it toward the right.
2. Insert the clutches at the lead edge of the tray into upper seating (B).



### Stacker Tray and Cart

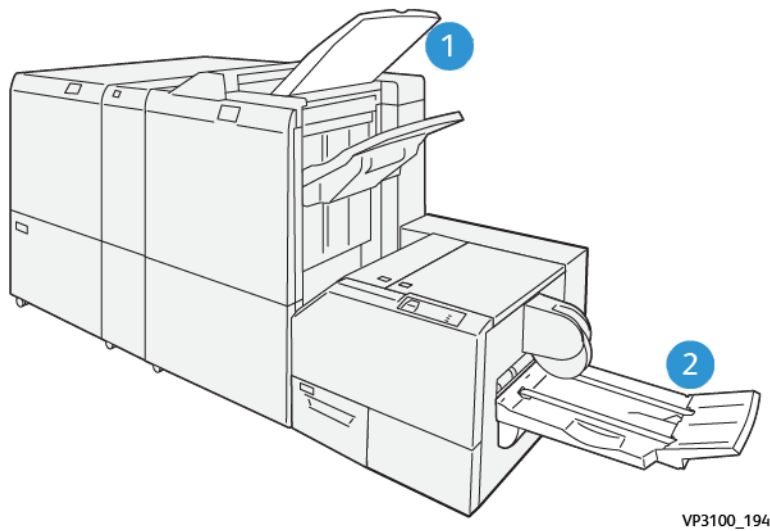
Description: Side stitch jobs are delivered to this tray only.

- Collates sets up to a total of 5000 sheets
- Located on a movable stacker cart

 Note: Delivering 2000 or more sheets to this tray with excessive downward curl can cause the output stack to fall out of the tray. If this happens, set the curl correction level on the Interface Decurler Module to its **lowest** level. Set curl correction on the Inserter setting to **downward**.



## Output Trays



1. Finisher Output Tray: The Production Press ejects any unused sheets that are purged by the Production Press to this output tray.
2. Booklet Tray: The Production Press delivers Saddle Stitch/Bi-fold and Trim/Square-fold jobs only to this tray. For more information, see [SquareFold® Trimmer](#).

### Booklet Tray

Description: The Booklet Tray accepts input sheet sizes 182 x 257 mm – 330.2 mm x 488 mm (7 x 10 in. - 13 x 19 in.) stacks up to 20 finished sets or transports to collection bin.

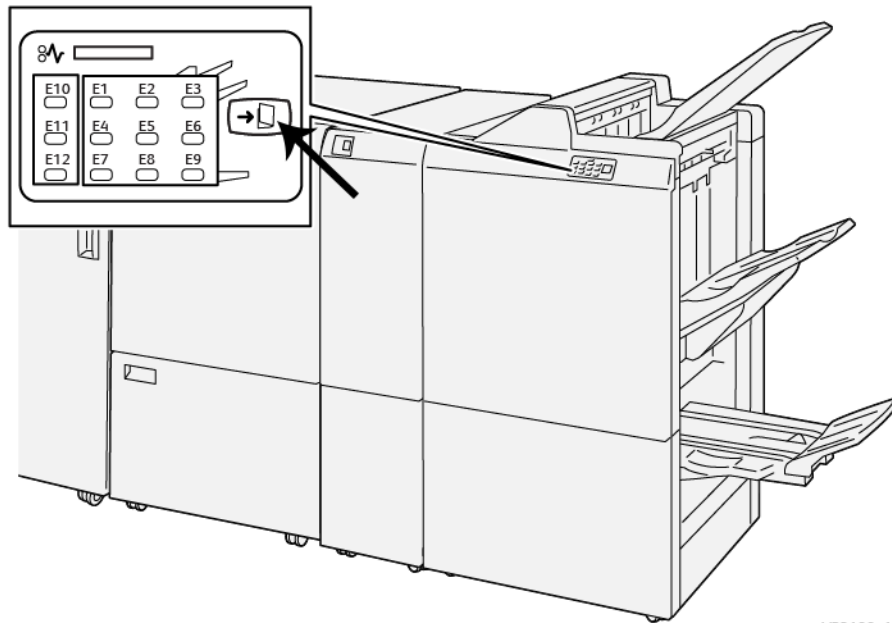


Note: The Booklet Tray is attached to the Production Ready Booklet Maker Finisher. However, if the SquareFold® Trimmer is installed, the Booklet Tray is attached to SquareFold® Trimmer.


Bi-Fold and Bi-Fold with Saddle Stitch jobs are delivered to this tray only.

### Booklet Output Button

Select this button to remove finished booklets from the finisher.




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 Note: If the SquareFold® Trimmer is installed, selecting this button moves the booklets to the booklet tray installed on SquareFold® Trimmer.

#### Bi-Fold Feature for the Production Ready Booklet Maker Finisher

 Note: Only the Production Ready Booklet Maker Finisher offers the Bi-Fold feature.

- To use the Bi-Fold feature, orient documents short-edge feed (SEF), and select a tray that contains SEF media.
- For network print jobs, from the print driver, select the **Bi-Fold** feature.


 Important: Only the C/Z Folder offers C-Fold and Z-Fold options. For more information on the C/Z Folder, refer to the section [C/Z Folder](#).

 Note: A Bi-Fold, also known as a Single Fold, has one fold that creates two panels to the output.



The Production Press has three Bi-Fold options:

- Bi-Fold Single Sheet
- Bi-Fold Multiple Sheets
- Bi-Fold Multiple Sheets Stapled

 Note: For detailed information about fold types and the Fold Adjustment feature, refer to [Fold Adjustment Information](#).

## Production Ready Finisher Plus

 Note: These optional finishing devices require the Interface Decurler Module.


The Production Ready Finisher Plus includes the same features and functions as the Production Ready Finisher. In addition, the Production Ready Finisher Plus serves as an interface to transfer media between the Production Press and any third-party Document Finishing Architecture device attached to the Production Press.

- **Stack Tray:**

- Capacity: 2000 sheets (82 g/m<sup>2</sup> or less)

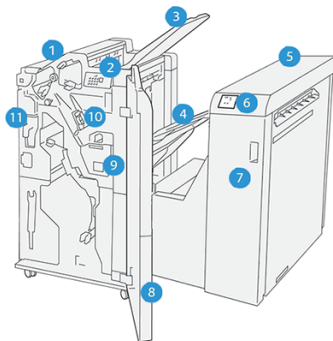
- **Document Finishing Architecture Transport:**

- Media Sizes: 7.2 x 7.2 in. (182 x 182 mm) – 13 x 19.2 in (330.2 x 488 mm)
- Media Weights: 52 - 400 g/m<sup>2</sup>

 Note: Due to the unique characteristics of some media, transport reliability can degrade with media less than 80 g/m<sup>2</sup> and exceeding 350 g/m<sup>2</sup>.

- Handling large-sized paper: maximum size of 330.2 x 488 mm (13 x 19.2 in.)
- Feeding the output media from the Production Press, and any inline finishing devices to a third-party DFA device

### Production Ready Finisher Plus Components



1. Finisher Module
2. Finisher Module Stock Jam/Error Indicators
3. Finisher Top Tray
4. Finisher Stacker Tray
5. Finishing Transport
6. Finishing Transport Paper Jam/Error Indicators
7. Finishing Transport Front Cover
8. Finisher Module Front Cover
9. Finisher Staple Waste Container
10. Finisher Basic Stapler for Side Stitching
11. Finisher Hole Punch Waste Container



Note: For details on the functions of your third-part finishing device, refer to the manual supplied with the device.

## Finisher Maintenance

For information about maintenance procedures for the Production Ready Finishers, refer to the following links:

- [Finisher Consumable Supplies](#)
- [Checking the Status of Finisher Consumables](#)
- [Replacing the Basic Staple Cartridge for Side Stitching](#)
- [Replacing the Booklet Staple Cartridge for Saddle Stitching](#)
- [Replacing the Finisher Staple Waste Container](#)
- [Emptying the Hole Punch Waste Container](#)

## Finisher Consumable Supplies

Order supplies, including staples, staple cartridges, and staple waste containers from Xerox at [www.xerox.com/supplies](http://www.xerox.com/supplies). Once there, do one of the following:

- Select **Contact Us** to obtain specific contact information in your area.
- Select **Supplies** and then select an appropriate option from the menu.



Note: Always refer to [www.xerox.com/supplies](http://www.xerox.com/supplies) for the latest Customer Replaceable Unit part numbers.

Store supplies and Xerox parts in their original packages.

The following table shows the consumables for the optional Production Ready Finisher, the Production Ready Booklet Maker Finisher, and the Production Ready Finisher Plus. Keep a supply of these items to eliminate downtime.

| SUPPLY ITEM   | SUPPLY UNIT SHIPPED WITH FINISHER/REORDER QUANTITY  |
|---|---|
| Corner Stapler Refill Staples for the optional Production Ready Finisher, Production Ready Booklet Maker Finisher, and Production Ready Finisher Plus | 4 Staple Cartridges (5,000 Staples per Cartridge) and 1 Staple Waste Container per carton |
| Booklet Stapler Refill Staples for the optional Production Ready Booklet Maker Finisher   | 1 container of 5,000 Staples each   |

For information on replenishing Production Press consumables, refer to [Press Consumable Supplies](#).

## Checking the Status of Finisher Consumables

When a consumable nears the time for replacement, a message appears on the control panel. With some Customer Replaceable Units (CRUs), the screen indicates that the Production Press can continue to print jobs without you immediately replacing the item. Other times, a message appears and the Production Press stops running.

To check the status of your consumables:

1. Select the **Consummable** button on the Control Center.



- To display more information about supplies and their status, select the **Information** button .

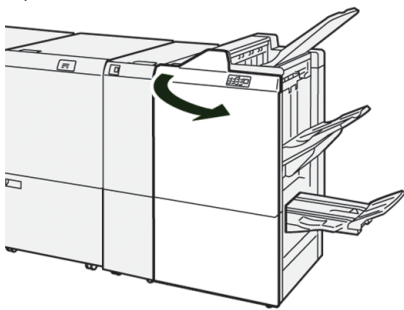
You can view the Consumable tab and see the status of the following:

- Charge Corotron
- Supply Unit
- Finisher Unit

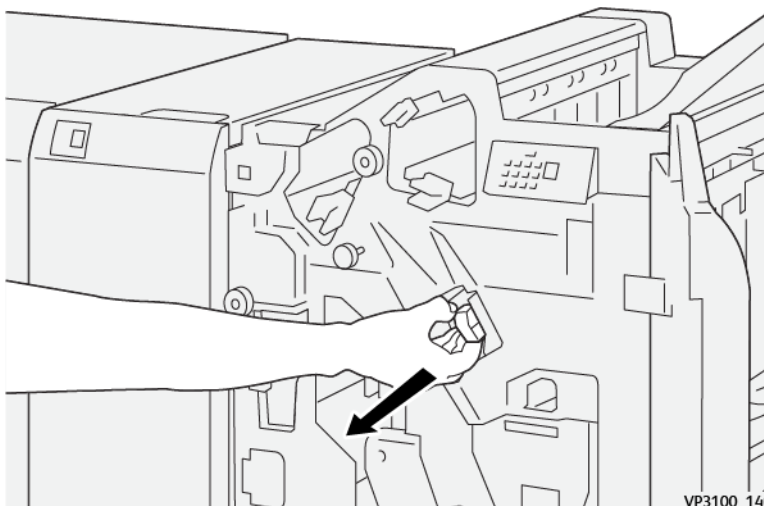
### Replacing the Basic Staple Cartridge for Side Stitching

Note: Ensure that the Production Press is not running before performing this procedure.

- Open the finisher front cover.

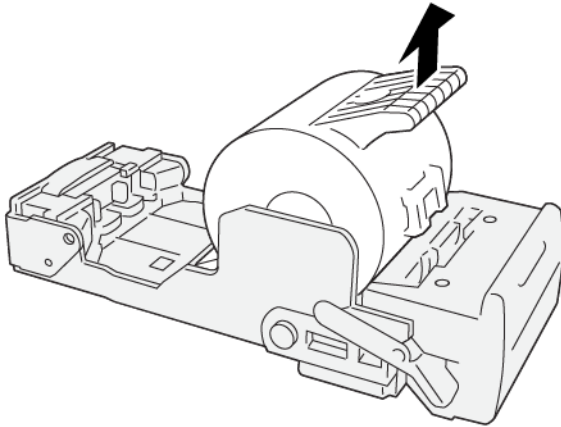


- Pull out R1.



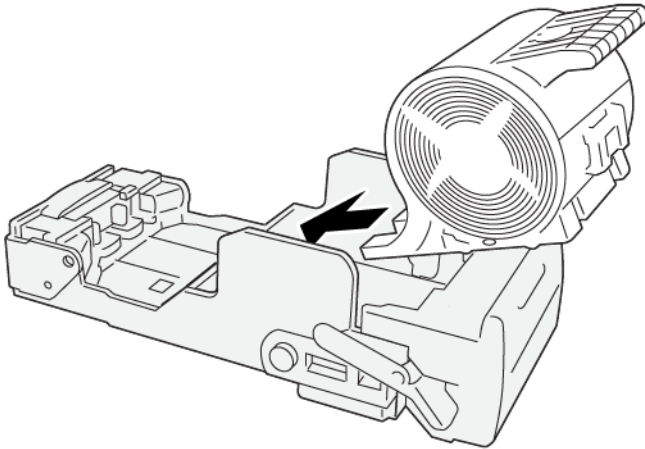
Note: You can only remove a staple cartridge if it is empty. If you still cannot remove it, or the cartridge is jammed, call for Service.

3. Holding the staple cartridge at the position indicated by the arrow, remove it from the unit.



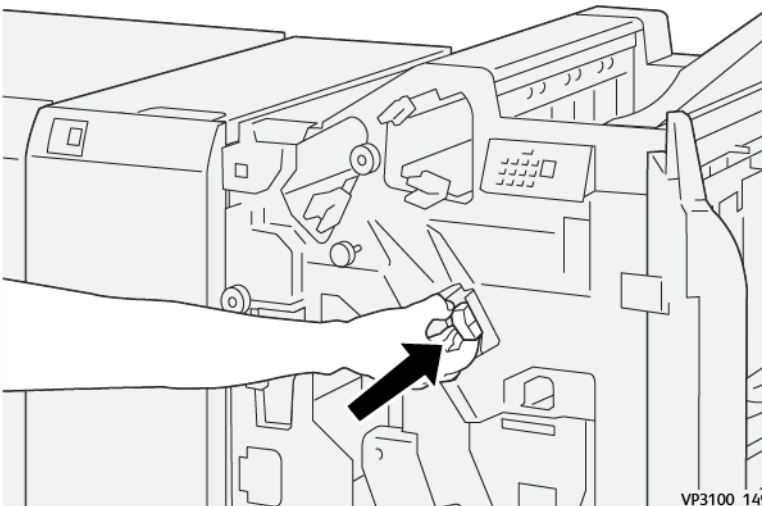
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4. Insert a new staple cartridge into the unit.



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5. Insert the unit to its original position.




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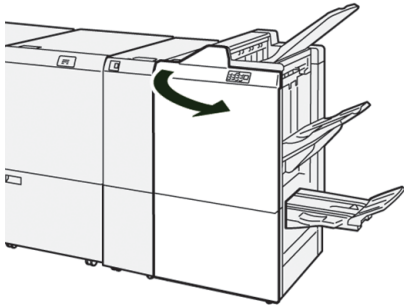
6. Close the finisher front cover.

### Replacing the Booklet Staple Cartridge for Saddle Stitching

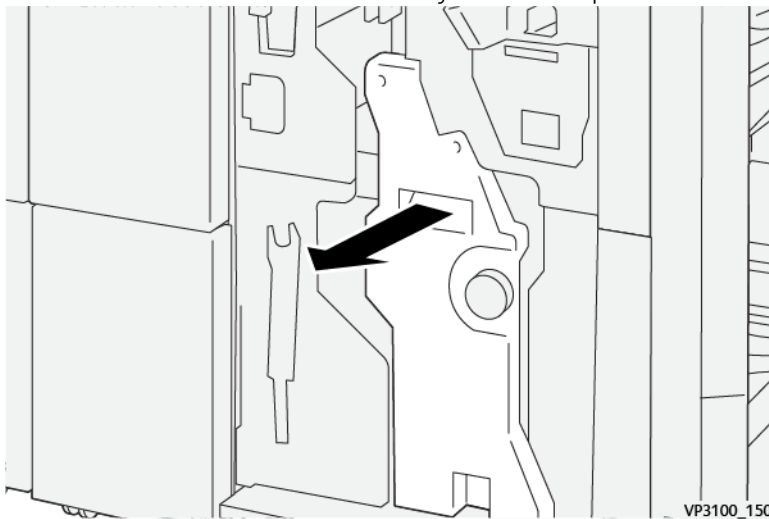
 Note: Before performing this procedure, ensure that the Production Press is not running.

 Note: This procedure is applicable only for the Production Ready Booklet Maker Finisher.


1. Open the finisher front cover.

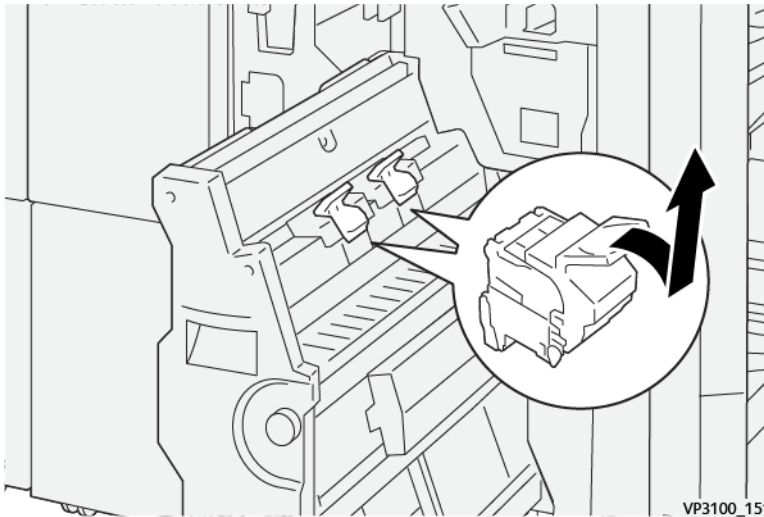


2. Pull out the Saddle Stitch Unit 3 toward you until it stops.




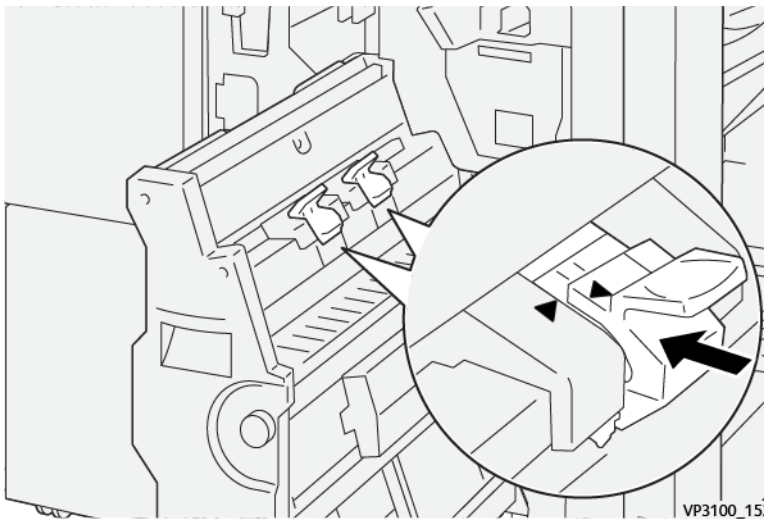
3. While holding the tabs on the staple cartridge, pull out the cartridge to remove it.

 Note: There are two booklet staple cartridges provided. Check the message to see which cartridge needs replacing.



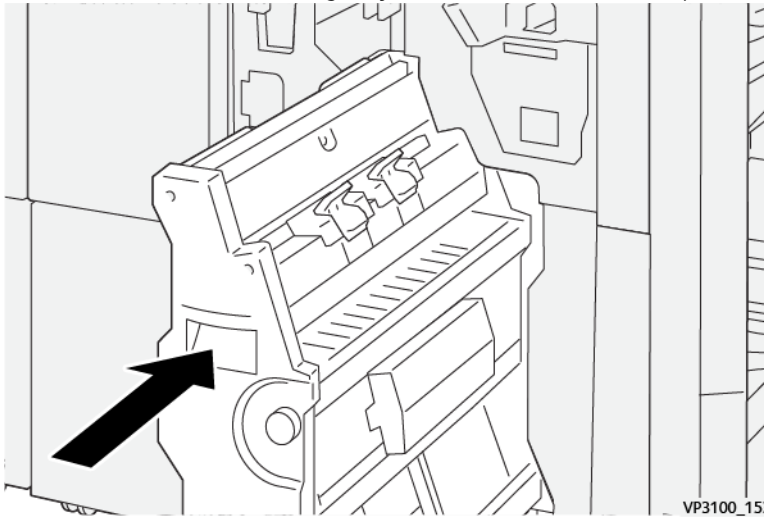
4. While holding the tabs on the new staple cartridge, push in the cartridge until it seats.

 Note: Make sure that the marks are aligned.





5. Push the Saddle Stitch Unit 3 gently into the finisher until it stops.



6. Close the finisher front cover.

### Replacing the Finisher Staple Waste Container

**⚠ WARNING:** To avoid personal injury, use care when removing the staple waste container.

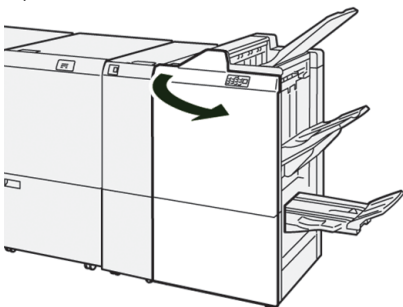
The Production Press displays a message when the staple waste container is full. When the message appears, replace the container with a new one.

**!** Important:

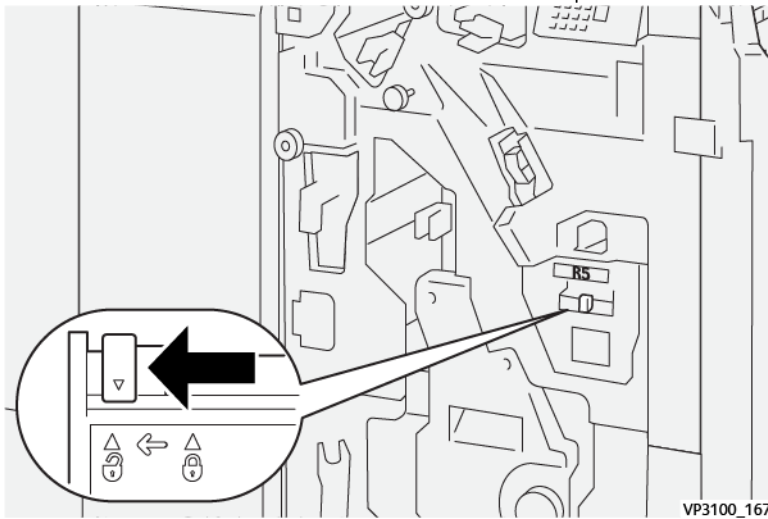
- Before performing this procedure, ensure that the Production Press is not running.
- Keep the Production Press powered on when replacing the staple waste container. If powered off, the Production Press does not recognize the replacement of the waste container, and a full message remains displayed.
- To ensure that the Production Press continues to run after replacing the waste container, close the finisher front cover.

**✎** Note: A staple waste container comes with the basic staple cartridge.

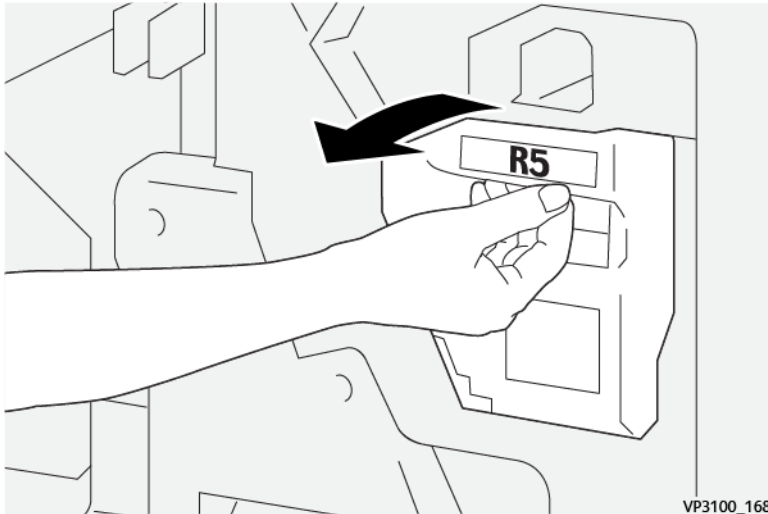
1. Open the finisher front cover.



2. Move the lock lever under R5 toward the left to the opened-lock mark.



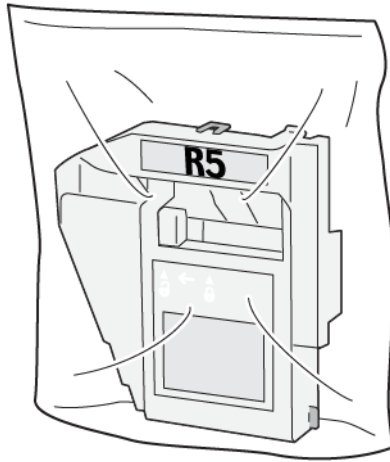
3. Pull out R5.



- Place the used staple waste container into the plastic bag supplied.



Note: Do not disassemble the used waste containers. Return the used staple waste containers to the Customer Support Center.

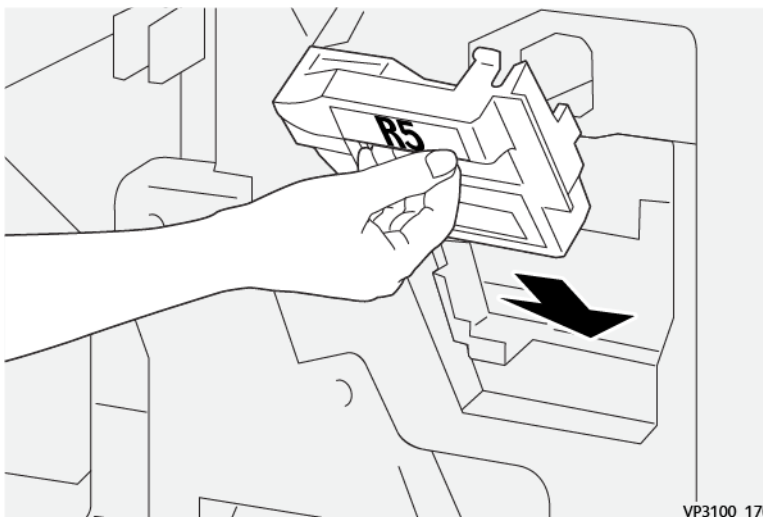


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- Insert the new staple waste container by lowering it into position and gently pushing it into place.

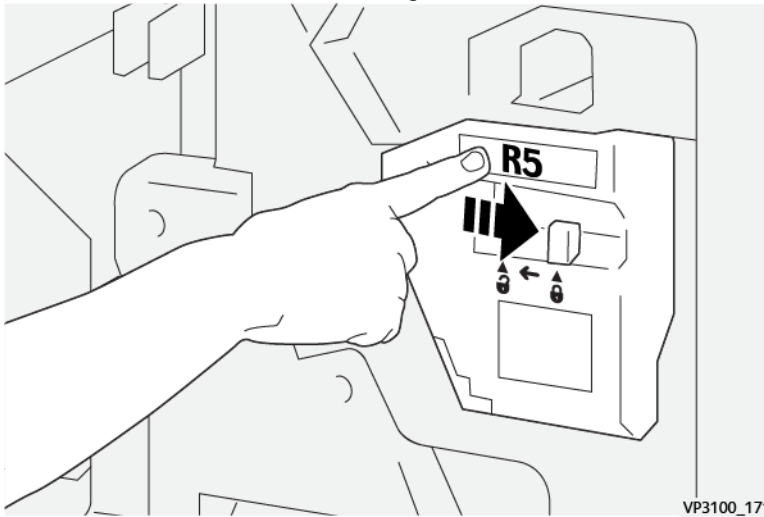


**WARNING:** To prevent injury, do not put your fingers on top of the container.



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6. Move the lock lever under R5 to the right to the closed-lock mark.



7. Close the finisher front cover.

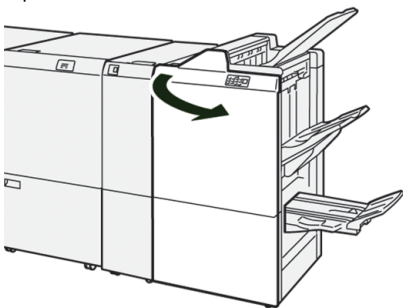
### Emptying the Hole Punch Waste Container

The Production Press displays a message when the hole punch waste container is full. When the message appears, empty the container of all paper scraps.

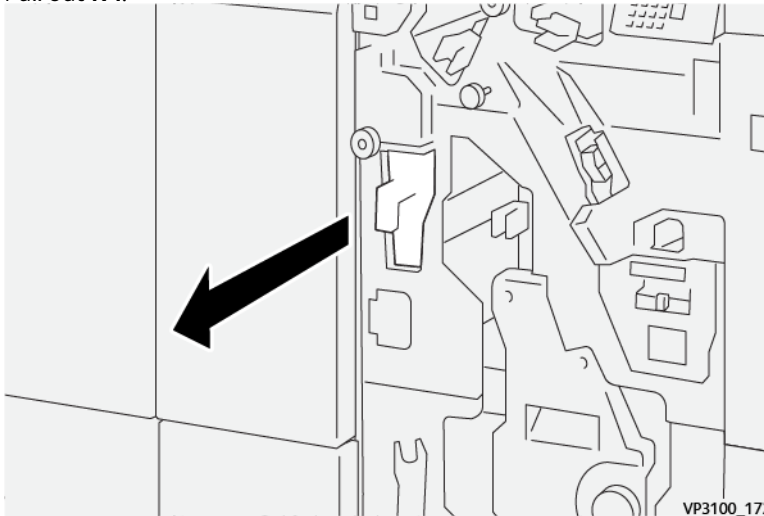
 Important:

- Ensure that the Production Press is not running before performing this procedure.
- Keep the Production Press powered on when emptying the container. If powered off, the Production Press does not recognize that the container was emptied and the full message remains displayed.
- To ensure that the Production Press continues running after emptying the container, close the finisher front cover.


1. Open the finisher front cover.

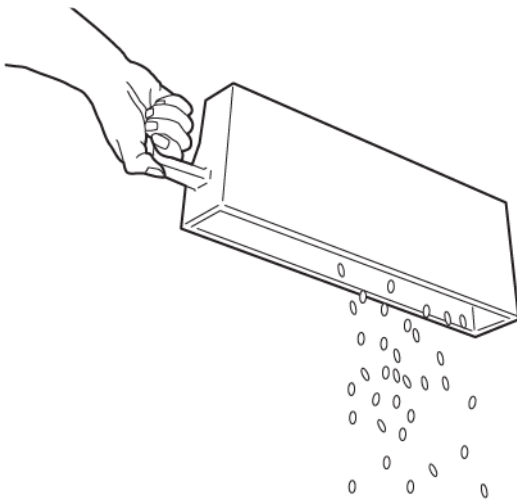


2. Pull out **R4**.



3. Discard all the waste from the container.

 Important: Be sure to completely empty the container. If any waste or scraps remain, the container becomes full before a full message appears causing a fault to occur.



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4. Return **R4** to its original position.
5. Close the finisher front cover.

### Third-Party Finishing Devices

If your Production Press has an optional, third-party, Document Finishing Architecture (DFA) device attached, the Finishing Devices feature is available.

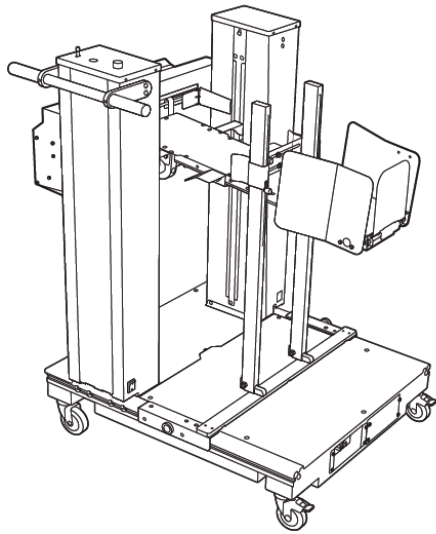
The Finishing Devices tab allows you to create, enable, or delete a profile for each third-party module configured with your system. These profiles describe the finishing device to the Production Press. The setup values you create appear on the Finishing Devices option for each specific profile.

### PLOCKMATIC MPS XL (MULTI-PURPOSE STACKER)

The Plockmatic Multi-Purpose Stacker XL is a flexible stacking solution that assists operators with paper stacking and handling during the finishing process. The stacker offers a unique combination of features with a printer in a single product.

The stacker can stack a wide variety of media such as A4 or Letter trifold or gatefold, A4 or Letter Landscape brochures, leaflets, menus, business cards, postcards, and so on.

The stacker is fully integrated into the Xerox® Digital Presses.




The stacker provides the following features:

- Provides the link between printing and the finishing device that will help to create the complete application.
- Offers a unique combination of features such as stacking, lifting, transporting, and integration with a printer in a single product.
- The stacker has multiple sensors that can detect jams and stack capacity limits, which triggers a soft stop within the printer.
- Integration and communication with the printer conveniently allows the operator to pause and resume jobs directly from the stacker control panel.
- Simple docking mechanism and large casters allow frequent docking or undocking and easy transportation of paper from the printer to finishing system.



Note: When docked, the stacker is powered through the docking bracket that is attached to the upstream device.

- Capable of stacking a wide range of media, sheets as large as 330 x 1200 mm (13 x 47.2 in.) and as thick as 400 g/m<sup>2</sup>.
- The stacking table has a default length of 715 mm (28 in.) for longer sheets, and the table can be extended all the way up to 1200 mm (47.2 in.). The upstream print engine determines the maximum sheet size.
- Supports a maximum stacking load of 40 kg (88.2 lbs.) and a maximum stacking height of 330 mm (13 in.) for sheets within 715 mm (28 in.) in length and 140 mm (5.5 in.) for the sheets over 715 mm (28 in.) in length.

 Note: Maximum stack height can vary between -10 mm (-0.4 in.) and +5 mm (+0.2 in.) depending on media type and weight.

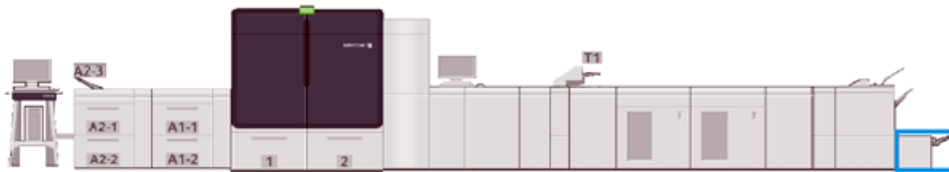
- An active Infeeder Unit receives paper from the upstream device and drives each sheet into the stacker. It also contains a fan which helps to cool media down and prevents sheets from sticking to each other.
- An active side jogger on the Infeeder Unit helps to align sheets and produce high quality stacks.
- The Motorized Stacking Table eliminates the need to manually lift heavy paper stacks.

For detailed information and instructions to use the Plockmatic Multi-Purpose Stacker XL, go to <https://www.support.xerox.com>, then search for your Press and Plockmatic MPS XL.

## SQUAREFOLD® TRIMMER

 Note: This optional finishing device requires a Production Ready Booklet Maker Finisher.

The SquareFold® Trimmer is an optional finishing device that flattens the spine of a booklet and performs face trim of the booklet.

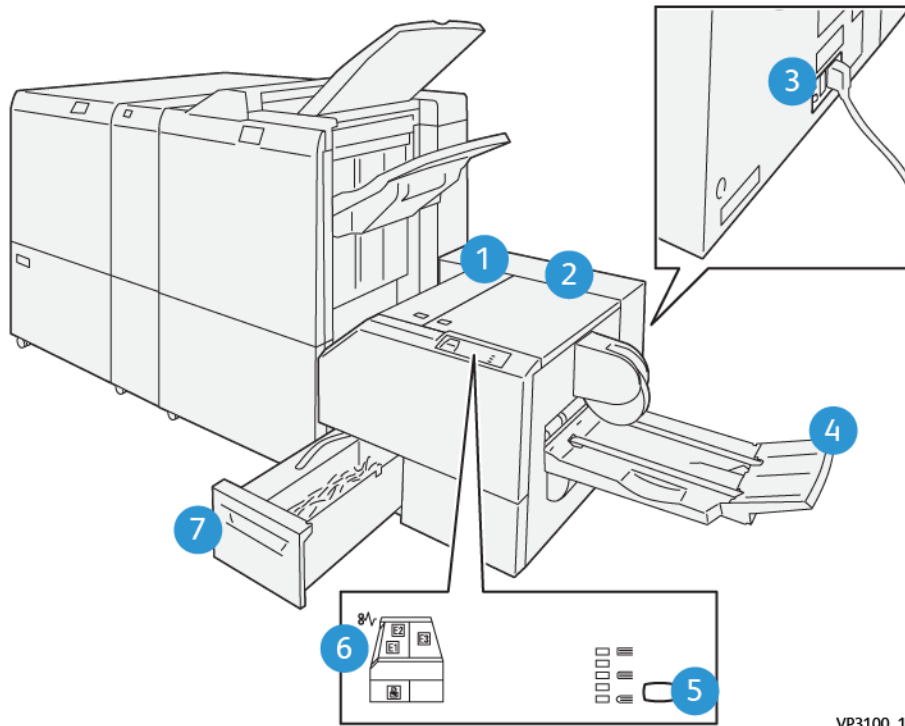


The SquareFold® Trimmer performs the following tasks:

- Receives the booklet from the Booklet Maker area of the Finisher
- To reduce the booklet thickness and to provide the appearance of a perfect-bound book, flattens the booklet spine
- Trims or cuts away the face, or edge, of the booklet resulting in a neatly finished edge

The booklet area of the Finisher assembles and staples the booklet. The booklet then enters the SquareFold® Trimmer already assembled. Any adjustments to the image of the original and its placement on the booklet page is set at the print server.

**SquareFold® Trimmer Components**



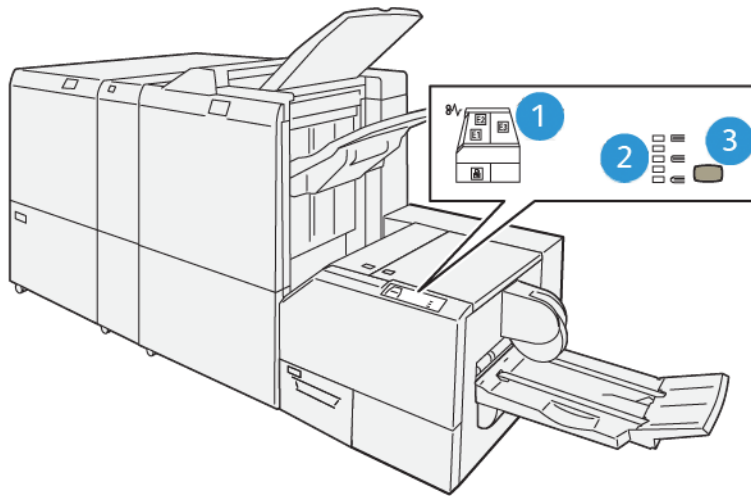
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| NUMBER | COMPONENT   | DESCRIPTION  |
|--------|---|--|
| 1      | Left Cover*                                       | To remove media jams, open this cover.   |
| 2      | Right Cover*                                      | To remove media jams, open this cover.   |
| 3      | Circuit Breaker Switch, on the rear of the device | If an electrical fault or a short circuit occurs, automatically shuts off the electricity. |
| 4      | Booklet Tray                                      | This tray receives square-fold booklet output from the finisher.                           |
| 5      | Square-fold Adjustment Button                     | To adjust the thickness of printed booklets, select this button.                           |
| 6      | Paper Jam/Error Indicator                         | This indicator illuminates when media jams occur.  |
| 7      | Trimmer Waste Container                           | This container collects waste from the trimmer area of the device.                         |


\* You cannot open the covers during normal operation or when the Production Press is idle. You can open the covers only when an indicator is lit and a jam or fault occurs within the SquareFold® Trimmer.



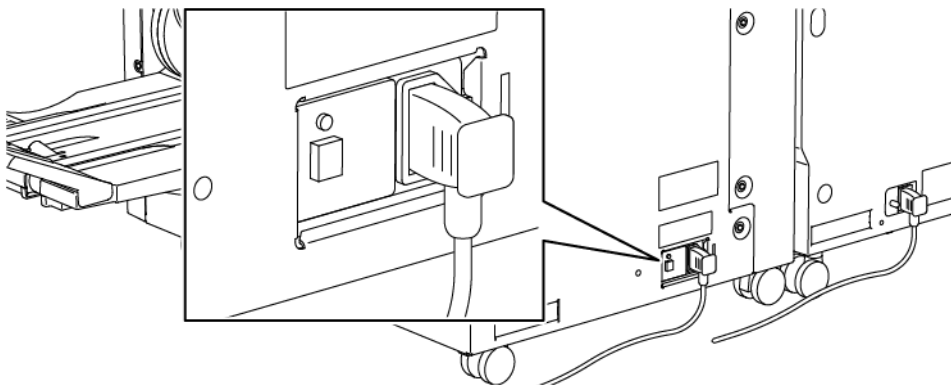
## Control Panel




VP3100\_195

| NUMBER | DESCRIPTION  |
|--------|--|
| 1      | <p>Fault indicators: When a fault or jam occurs in a particular area of the SquareFold® Trimmer, these indicators illuminate. When you pull out the trimmer waste container or when the container is full, the lower indicator, with the lock icon, illuminates.</p> <p> Note: If E1, E2, or E3 is lit, you can open the left and right covers, and clear the jam or fault. Otherwise you cannot open the covers during normal operation or when the Production Press is idle.</p> |
| 2      | Select the appropriate square-fold setting. For more information refer to <a href="#">Square Fold Adjustment Settings</a> .  |
| 3      | Press this button to adjust the square-fold, or book thickness, setting.   |

## SquareFold® Trimmer Circuit Breaker



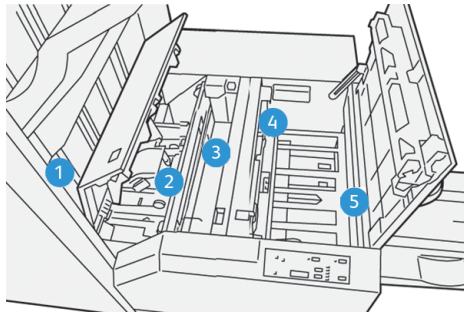
You can locate the circuit breaker on the rear of the device. The circuit breaker is normally in the **ON** position.

 Note: When an electrical interruption occurs, to discontinue the electrical flow to the device, the circuit breaker automatically switches off. For electrical information, refer to [Electrical Safety](#).

Under normal operating conditions, you do not need to touch this switch. If the Production Press is moved, to

switch off power to the device, press this button.

### SquareFold® Trimmer Paper Path



| NUMBER | DESCRIPTION   |
|--------|---|
| 1      | The booklet leaves the booklet area of the finisher and enters the SquareFold® Trimmer. The Booklet Exit sensor, in the SquareFold® Trimmer, detects the lead edge, or spine, of booklet and moves the booklet to the square-fold area.   |
| 2      | Once the booklet spine reaches the square-fold area, the booklet is clamped and the square-folding operation begins.  |
| 3      | The booklet gets flattened and the spine squared according to the square-fold setting indicated on the control panel.   |
| 4      | After the booklet is flattened and the spine squared, it advances to the trimmer area. <ul style="list-style-type: none"> <li>Based on the finished booklet size, the booklet advances until the trail edge reaches the trimmer cutter.</li> <li>The trail edge gets trimmed, or cut, based on the finished booklet size entered for the trimmer mode setting.</li> </ul> |
| 5      | The booklet then advances to the exit area where it gets transported to the booklet tray.   |



Note: Booklets exiting the SquareFold® Trimmer can contain trim remnants or scraps from the previously trimmed booklet. This is due to static electricity build-up and is normal. If booklets contain trim remnants or scraps, remove and discard them.

### Square Fold® and Trim Features

This section provides information on the following:

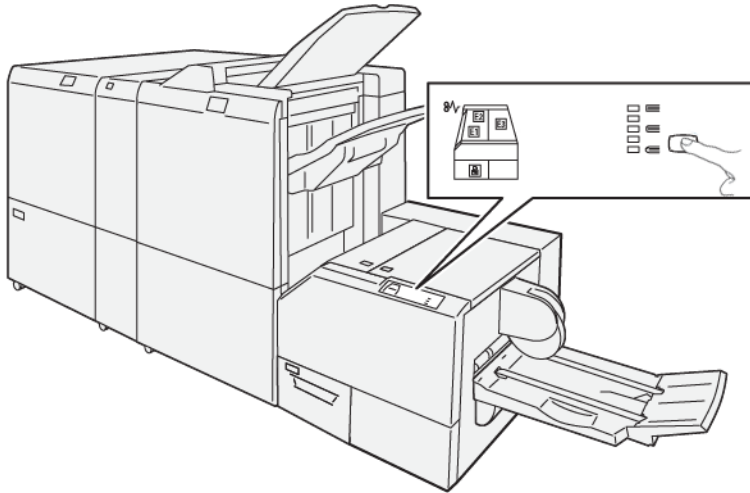
- [Square Fold Feature](#)
- [Trim Feature](#)

#### Square Fold Feature



Note: The term Book Pressing is used synonymously with the terms Square Fold or Square Folding.

To adjust the spine shape, or square-folding, of the printed booklets, press the **Square-fold** button.

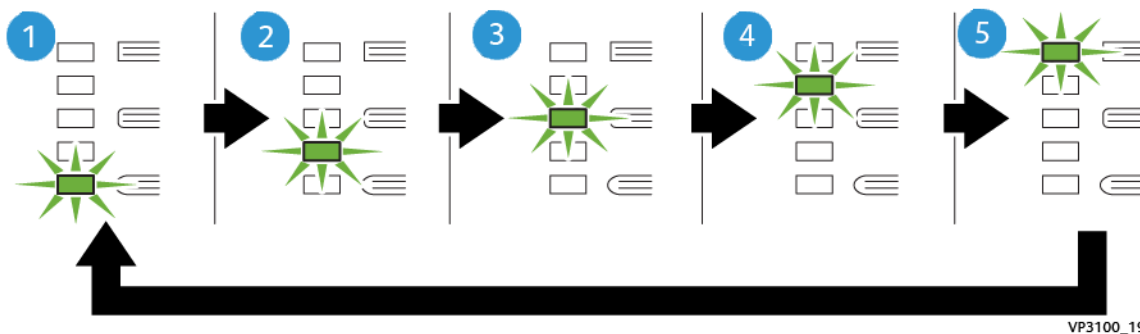


You can access the square fold feature from your computer print driver or from the print server.

### Square Fold Adjustment Settings

Based on user preference, you can switch on or off the Square Fold feature. When you switch on the feature, depending on your requirements for the finished booklet job, you can select one of five options.

 Note: Before running large jobs, run one or more test prints.



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| NUMBER | DESCRIPTION   |
|--------|---|
| 1      | When your finished booklet is five pages or less and on lightweight paper (100 g/m <sup>2</sup> or lower), select <b>-2/Lower/Low 2</b> . The least amount of pressure that can be applied to the booklet is -2.  |
| 2      | When you want less pressure applied to the spine of the booklet, select <b>-1/Low/Low 1</b> . The less pressure applied to the booklet, the more rounded the booklet spine.   |
| 3      | <b>Auto/Normal</b> is the default setting and is used for most jobs.  |
| 4      | When you want a greater amount of pressure applied to the spine of the booklet, but not as much as the +2 setting uses, select <b>+1/High/High 1</b> .  |
| 5      | When you want the most amount of pressure applied to the spine of the booklet, select <b>+2/Higher/High 2</b> . The more pressure applied, the more square the booklet spine. The greatest amount of pressure that can be applied to the booklet is +2. |

## Booklet Example

The following illustration shows two different booklet types:



1. This booklet is not square-folded. It has a rounded, thicker appearance to the spine.
2. This booklet is square-folded. The booklet spine is flattened and squared, giving a perfect-bound book appearance.

### Trim Feature

Access the trim feature from your computer print driver or from the print server.

### Trim Options

When using the trim options, always consider the following:

- Booklets exiting the SquareFold® Trimmer can contain trim remnants or scraps from the previously trimmed booklet. This condition can be due to static electricity build-up and is normal. If booklets contain trim remnants, remove and discard them.
- You can switch on or off the trim feature. When the feature is on, depending on your requirements for the finished booklet job, you can adjust the trim setting in 0.1mm/0.0039 inch increments.

The trim options include the following:

- **Trimming On/Off:** Switch **On/Off** the Trimming feature. The default setting is **Off**.
- **Cut to Size:** To decrease or increase the trimmer setting, use the **Left/Right Arrow** buttons. Adjustments are made in 0.1 mm/0.0039 inch increments.

The trim setting is based on:

- The number of sheets in the finished booklet
- The finished booklet width size
- The media type, coated or uncoated

- The media weight



Note: To determine the best selections for your job, experiment with various settings. For the best booklet output, before running larger jobs, you can run one or more test prints.



Note: To remove less than 2 mm (0.078 in.) or more than 20 mm (0.787 in.) of edge material from the booklet, you cannot adjust trim settings. Adjustments less than 2 mm can produce poor trim quality. Adjustments greater than 20-mm result in no trimming to the booklet edge.

### Trim Guidelines

The following table shows various scenarios using different paper weights, media types, and trim setting selections. When you select a trim setting for your specific job, use this table as a guideline.



Note: The settings shown in the following table provide examples and are not meant to represent every possible job scenario. Use this table only as a guideline.

| SCENARIO NUMBER | PAPER SIZE                     | FINISHED BOOKLET SIZE          | PAPER WEIGHT G/M <sup>2</sup> (LBS.) | APPROXIMATE TRIM SETTING (MM) | NUMBER OF PAGES IN FINISHED BOOKLET |
|-----------------|--------------------------------|--------------------------------|--------------------------------------|-------------------------------|-------------------------------------|
| 1               | 210 x 298 mm (8.5 x 11 in./A4) | 149 x 210 mm (5.5 x 8.5 in.)   | 75 g/m <sup>2</sup> (20 lbs.)        | 130                           | 20                                  |
| 2               | 210 x 298 mm (8.5 x 11 in./A4) | 149 x 210 mm (5.5 x 8.5 in.)   | 90 g/m <sup>2</sup> (24 lbs.)        | 125                           | 14                                  |
| 3               | 210 x 298 mm (8.5 x 11 in./A4) | 149 x 210 mm (5.5 x 8.5 in.)   | 120 g/m <sup>2</sup> (32 lbs.)       | 135                           | 10                                  |
| 4               | 210 x 298 mm (8.5 x 11 in./A4) | 149 x 210 mm (5.5 x 8.5 in.)   | 75 g/m <sup>2</sup> (20 lbs.)        | 125                           | 10                                  |
| 5               | 210 x 298 mm (8.5 x 11 in./A4) | 149 x 210 mm (5.5 x 8.5 in.)   | 120 g/m <sup>2</sup> (80 lbs.)       | 135                           | 12                                  |
| 6               | 250 x 353 mm (8.5 x 14 in./B4) | 250 x 176.5 mm (8.5 x 7 in.)   | 75 g/m <sup>2</sup> (20 lbs.)        | 172                           | 6                                   |
| 7               | 250 x 353 mm (8.5 x 14 in./B4) | 250 x 176.5 mm (8.5 x 7 in.)   | 90 g/m <sup>2</sup> (24 lbs.)        | 170                           | 6                                   |
| 8               | 297 x 420 mm (11 x 17 in./A3)  | 210 x 297 mm (8.5 x 11 in./A4) | 90 g/m <sup>2</sup> (24 lbs.)        | 200                           | 14                                  |
| 9               | 297 x 420 mm (11 x 17 in./A3)  | 210 x 297 mm (8.5 x 11 in./A4) | 216 g/m <sup>2</sup> (80 lbs.)       | 205                           | 5                                   |
| 10              | 297 x 420 mm (11 x 17 in./A3)  | 210 x 297 mm (8.5 x 11 in./A4) | 80 g/m <sup>2</sup> (20 lbs.)        | 210                           | 22                                  |
| 11              | 297 x 420 mm (11 x 17 in./A3)  | 210 x 297 mm (8.5 x 11 in./A4) | 90 g/m <sup>2</sup> (24 lbs.)        | 210                           | 8                                   |

| SCENARIO NUMBER | PAPER SIZE                    | FINISHED BOOKLET SIZE          | PAPER WEIGHT G/M <sup>2</sup> (LBS.) | APPROXIMATE TRIM SETTING (MM) | NUMBER OF PAGES IN FINISHED BOOKLET |
|-----------------|-------------------------------|--------------------------------|--------------------------------------|-------------------------------|-------------------------------------|
| 12              | 297 x 420 mm (11 x 17 in./A3) | 210 x 297 mm (8.5 x 11 in./A4) | 120 g/m <sup>2</sup> (80 lbs.)       | 205                           | 10                                  |
| 13              | 305 x 458 mm (12 x 18 in.)    | 152 x 229 mm (6 x 9 in.)       | 120 g/m <sup>2</sup> (80 lbs.)       | 220                           | 6                                   |
| 14              | 305 x 458 mm (12 x 18 in.)    | 152 x 229 mm (6 x 9 in.)       | 120 g/m <sup>2</sup> (80 lbs.)       | 215                           | 5                                   |
| 15              | 305 x 458 mm (12 x 18 in.)    | 152 x 229 mm (6 x 9 in.)       | 120 g/m <sup>2</sup> (80 lbs.)       | 210                           | 4                                   |
| 16              | 305 x 458 mm (12 x 18 in.)    | 152 x 229 mm (6 x 9 in.)       | 105 g/m <sup>2</sup> (28 lbs.)       | 220                           | 16                                  |
| 17              | 305 x 458 mm (12 x 18 in.)    | 152 x 229 mm (6 x 9 in.)       | 120 g/m <sup>2</sup> (80 lbs.)       | 210                           | 14                                  |

### Guidelines for Using the SquareFold® Trimmer

This section provides information on the following:

- [Full-Page Images on Booklets](#)
- [Booklet Considerations](#)
- [Considerations for Obtaining Appropriate Booklet Output](#)

#### Full-Page Images on Booklets

When you use full-page images, ensure that the finished booklet size accommodates any full-page images. Also, ensure that when the booklet is trimmed, these images do not get truncated.

The following are examples of booklets with pre-printed front and back covers with full-page images, but of different sizes:



1. Booklet 1 is printed on 8.5 x 14 in./B4 paper: The front cover, which was trimmed, displays the entire image.
2. Booklet 2 is printed on 8.5 x 11 in./A4 paper: The image on the front cover is truncated after you trim it.

### Booklet Considerations

Before you print any booklet, consider the following:

- Image location on the original—the image cannot appear in the center of the page any longer. Do you need to shift images to ensure that they fit on the finished booklet?
- What is the needed size of the finished booklet?
- Does the booklet contain full-page images?
- Are you using pre-printed covers with full-page images?
- Are you trimming the booklet?

### Considerations for Obtaining Appropriate Booklet Output

To ensure that you achieve the appropriate output, follow these tips:


- Before running a larger output quantity, always run one or more test prints of your job.
- Review your test prints for truncated images and text.
- If any images or text need shifting, use the various selections from the application print driver. Refer to your print driver help information.
- Remember: Before you achieve the appropriate output, it can take one or more test prints.

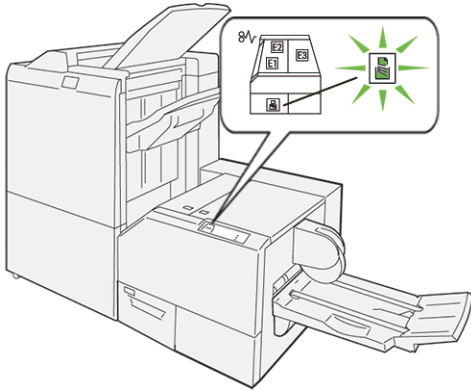
### SquareFold® Trimmer Maintenance

For information about maintaining optimum performance of the trimmer by removing trimmed waste and clearing debris, refer to [Emptying the SquareFold® Trimmer Waste Container](#).

### Emptying the SquareFold® Trimmer Waste Container

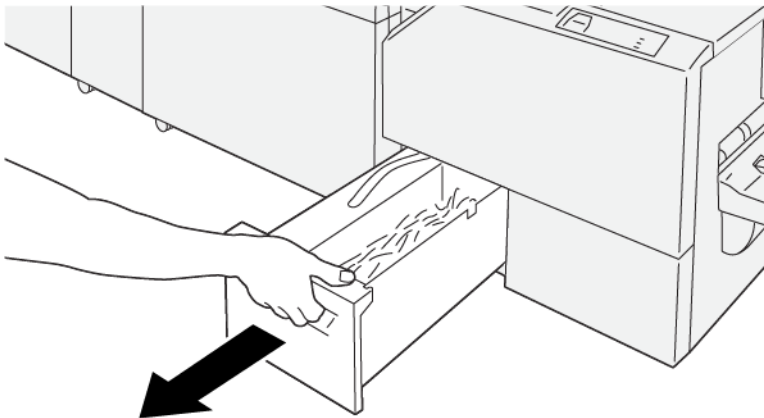
When the waste container approaches full, an indicator illuminates on the top of the SquareFold® Trimmer. A message also appears on the Production Press indicating that the waste container is full. When the message appears, dispose of the waste scraps.

-  Note: Keep the Production Press powered on when you dispose of the waste. If powered off, the Production Press does not recognize that you emptied the container.



To empty the trimmer waste container, perform the following steps.

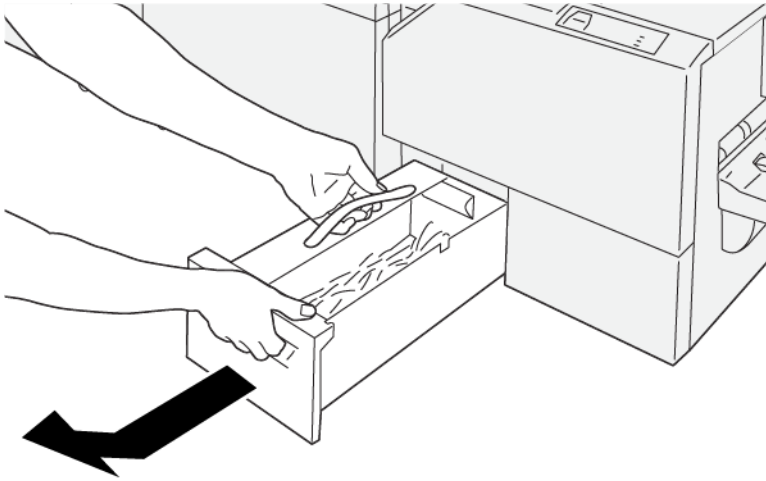
1. Ensure that the Production Press is not running, and slowly pull out the trimmer waste container.



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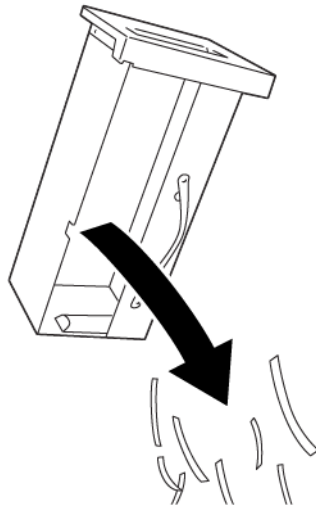
2. Hold the belt on the waste container, and using both hands, remove the container.



VP3100\_200

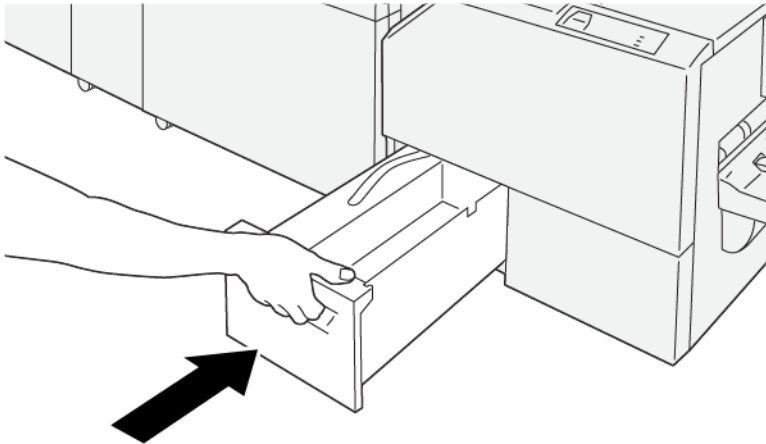
3. Discard all waste and scraps.

 Note: Ensure that you completely empty the container. If any waste or scraps remain, the container fills before a message appears and causes the Production Press to malfunction.



VP3100\_201


4. Reinsert the empty waste container and slowly push it in completely.



VP3100\_202

### USING THE OPTIONAL TRAY EXTENSION FOR LONG PAPER ON PRODUCTION-READY FINISHERS

To allow you to run banner sheets and hold them in position at the output tray, an optional tray extension for long paper is installed.

-  Note: The tray extension consists of new hardware, including wire supports, wire guides, and a guide template. The wire supports alone support stacking paper up to 729 mm (28.7 in.). When you add the wire guides, the support increases to up to 1200 mm (47.24 in.).

To use the tray extension for long paper:

1. Remove the wire supports and wire guide from their storage location on the upper rear cover.



2. On the tray behind the wire support brackets, in the four holes, insert the two wire supports.



3. On the wire supports, attach the plastic clip end of the wire guides.



4. Align the opposite end of the wire guides to the arrows on the guide template.



5. Run the banner print job.  
The paper bends slightly in the wire guides, which prevents the paper from falling on the floor.
6. When the job is complete, return the wire guides and wire supports to their storage location.

## Profiles

You can create and apply custom profile settings for media when printing. The types of profiles available include image alignment, document fold adjustments, Tray Air Assist changes, and Document Finishing Architecture (DFA) finishing options.

### PROFILES OVERVIEW

The Profiles feature allows you to create and customize various profiles to use for a particular print job.



Note: As an alternative to using the Profiles feature, you can create an alignment profile using the automatic adjustments feature. Both features apply the same image adjustments to the stock you select for the procedure. However, when you complete the automatic adjustment procedure, the system assigns a name and automatically enters the adjusted values for the stock in the Advanced Stock Setup window.

- **Alignment:** To accommodate for misalignment or skew, the Alignment tab allows you to define a profile for a particular stock that repositions the output image. At the point of need for specialized print jobs, use these profiles.
- **Fold Adjustment:** If optional devices are connected to the Production Press, the Fold Adjustment tab is available. The Fold Adjustment tab allows you to define a profile that adjusts the fold position for various paper types. To set adjustment values to various default types, use this profile.
- **Air Assist:** The Air Assist tab allows you to customize the blower settings in the sheet feeding areas of the paper trays. If stock is misfeeding during a print run, to reduce misfeeds, apply these settings.
- **Finishing Devices:** If a third-party Document Finishing Architecture device is attached to the Production Press, and you are logged in as Administrator, the Finishing Devices tab is available. Administrators can enable or disable a finisher and also adjust their profile settings.

### ENTER AND EXIT PROFILES

Both the operator and administrator can create, edit, or delete profiles.

1. From the Function menu on the left side of the main window, select the **Profiles** button.

The Profiles window appears.



Note: The Finishing tab appears only if you are logged in as Administrator and your Production Press has a third-party Document Finishing Architecture (DFA) device attached.

2. To create or edit an Image Alignment profile, select the **Alignment** tab.
3. To create or edit a Document Fold Adjustment profile, select the **Fold Adjustment** tab.
4. To create or edit a Tray Air Assist profile, select the **Air Assist** tab.
5. To create or edit a third-party DFA profile, log in as Administrator and select the **Finishing Devices** tab.
6. To exit the Profiles window and return to the main window, select **Close**.


### ALIGNMENT



Note: You can sort the list of profiles by name, date of change, and comment. If necessary, to view the entire text of long profile names, use the horizontal scroll bar.

The Alignment feature allows you to create and store specific alignment adjustment profiles. These profiles allow you to accommodate different media types and how the image is registered, aligned, or magnified for side 1 and side 2 output. To ensure optimum output quality of your prints, you can use these profiles at point of need.

When the position of the output image is misaligned or skewed, you can make alignment adjustments. This condition can be a result of paper expansion or contraction, cutting inaccuracy, or paper storage conditions.

 Note: It is recommended that you read through the entire Alignment section before you create, edit, or perform any actual alignment adjustments.

## Alignment Information

When you print duplex jobs and use different media types, including paper type, weight, and coating or uncoating, the output can require specific handling by the Production Press as it moves through the paper path. With certain media types and duplex jobs, the images on side 1 or side 2 can be misregistered, skewed, perpendicularly misaligned, or stretched. To eliminate these types of issues, use alignment profiles.

Alignment adjustment profiles allow you to:

- Adjust the image based on the alignment output of a document. You can modify various adjustments, such as registration, perpendicularity, skew, and magnification.
- Make adjustments when the position of the output image is misaligned or skewed. This condition can be a result of paper expansion or contraction, cutting inaccuracy, or paper storage conditions.

### Things to Consider When Creating or Using an Alignment Profile



Tip: As your first course of action, before you use the manual alignment steps, always try the Auto Alignment feature.

When you create Alignment profiles for side 1 or side 2 prints, be aware of the following:

- Because the paper is not the exact same size, side 1 and side 2 images can misregister. The size can vary slightly, with differences of +/- 1 mm, causing the image to misregister. To reduce the possibility of size differences, when running duplex jobs, it is recommended that you use paper from the same lot.
- During the fusing process, the heat and pressure applied to the paper causes the paper to stretch. If the images on sides 1 and 2 are the same size, the stretching of the paper can cause the image on side 1 to be slightly larger than the image on side 2.

Creating an Alignment profile for these types of jobs allows you to reduce or eliminate the images being larger on side 1 than on side 2 prints.



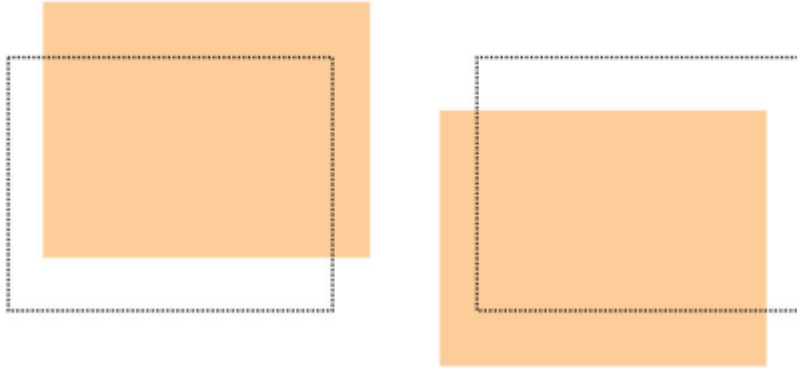
Note: After an Alignment profile is set and in use, on your print server, that profile is not reflected in the print options for print jobs.

### Adjustments to the Position of the Output Image

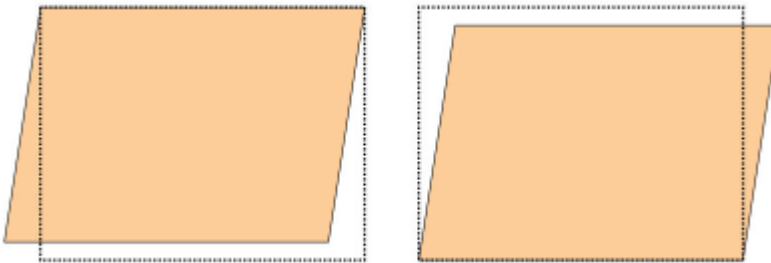
Make the following adjustments to the position of the output image:

- Registration:
  - Lead Registration: To adjust the lead edge of the image for side 1 or side 2 registration, use this feature.
  - Side Registration: To adjust the side edge of the image for side 1 or side 2 registration, use this feature.

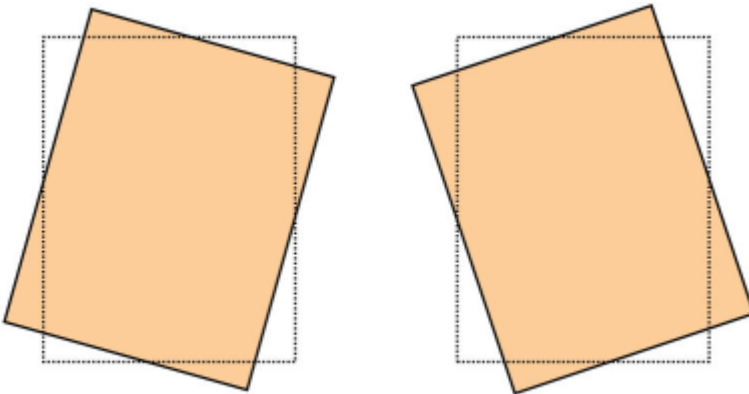
## Working With



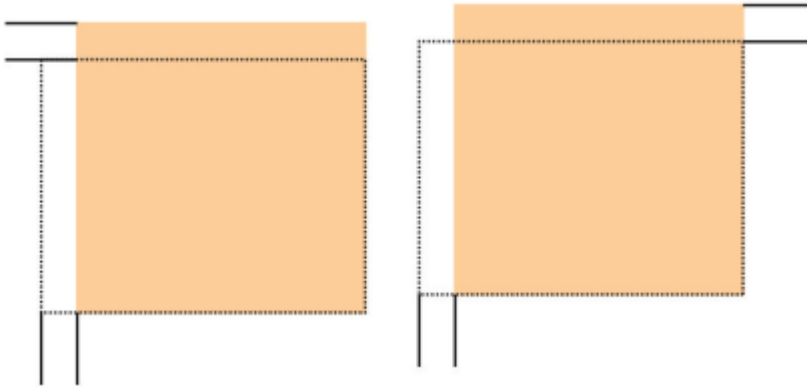
- Perpendicularity: When the image is straight on the page, but the corners are slanted, not at right, or 90 degrees, angles to each other, use this adjustment. This feature adjusts the image digitally on the drum until it aligns with the paper for both side 1 and side 2.



- Skew: When the entire image on the page is slanted and not straight, use this adjustment. This feature adjusts the paper so that the image for side 1 or side 2 are not skewed, but are aligned with each other.



- Magnification: To correct for image stretch from side 1 to side 2, use this feature. The image can be enlarged or reduced as necessary.



Tip: Preferably, choose only one Alignment profile feature, such as skew. Then, to evaluate the skew on that output, run a set of test prints. If you want to adjust multiple Alignment profile features, to evaluate the skew on that output, individually select each feature, run some test prints for that feature, and evaluate the output. After you determine that the output for the selected feature is acceptable, you can select another alignment profile feature to adjust.



Tip: When you adjust multiple items, adjust the image in the following order:

- Perpendicularity adjustment
- Skew adjustment
- Magnification adjustment
- Registration adjustment

### Setting the Auto Alignment Profile

The Automatic Alignment feature automatically performs corrective registration, perpendicularity, skew, and magnification adjustments.

1. Select the **Profiles** button.
2. Ensure that the Alignment tab is selected.
3. To create an alignment profile or to edit an existing Alignment profile, select the **New (+)** icon or the **Edit** icon. Either the New Profile Properties or the Edit Profile Properties window appears.
4. If needed, enter a new name or modify the existing name.
5. Select the **Auto Alignment** button. The Auto Alignment – Test Print Setup window appears.
6. Select the appropriate tray and profile name.
7. Select side 1 and side 2 print density levels that closely match the print jobs to run with this profile. Print density amounts range from 1–10, with 1 being the minimum and 10 being the maximum. Select 5 or 6 for an average job, and 8 or 9 for a job that uses a large amount of ink. For a text only job, select 3 or 4.
8. For Color Mode, select the dry ink/toner colors being used in the job requiring the profile.

9. For Fill – Color Mode side 1 and side 2, select the dry ink/toner colors being used in the job requiring the profile.
10. For Fill Placement Pattern – side 1 and side 2, select one or more of the check boxes for TopLeft, TopRight, BottomLeft, or BottomRight. Select the area of the page that has heavy dry ink/toner coverage. The density levels that you set determine how much dry ink/toner is placed in these areas on the test print.
11. Select the **Start** button.

The Production Press runs multiple test prints and performs successive adjustments until the optimum image alignment is achieved. The last sheet reflects the best alignment.
12. Obtain the test patterns printed and ensure that the registration is acceptable.
13. To accept the new settings, select **OK**. If not acceptable, to revert to the original settings, select **Cancel**.

The new alignment adjustments for registration, perpendicularity, skew, and magnification appear on the Profile Properties window.
14. If you want to check prints with the adjustments applied again, select the **Test Print** button. The Alignment Test Print window appears.
15. Select the appropriate Test Print options, including:
  - a. For the test pattern, select **PH-Regi**.
  - b. The appropriate paper tray.
  - c. Print quantity.

To evaluate the printed output best, select a quantity of 10 test prints.
  - d. Other values such as 1-sided or 2-sided, Color Mode, Fill Color Mode, and Fill Patterns.
16. Select **Start**.

The window displays a message stating that the test print is in progress.
17. Retrieve your printed output.

Discard the first few prints as inconsistency can be high with the first images.
18. Evaluate the test prints by holding the output at eye level near a light source.

If you selected 2-sided output, this step allows you to see the registration marks for side 1, and side 2.
19. To save and close the alignment Profile Properties window, select **OK**.

The new or edited profile procedure, such as AlignmentProfile2, appears on the Alignment window. You can select the profile procedure at any future time.
20. To exit Profiles and return to the main window, select **Close**.
21. Click the **User** link and to exit the Administrator mode, select **Log Out**.

### Alignment Options

Alignment options include:

- Registration
- Perpendicularity
- Skew
- Magnification



When selecting or editing the various Alignment options, consider these tips:

- The arrows above the paper illustration indicate the feed direction.
- To modify the alignment values, use the plus (+) and minus (-) icons.
- As you adjust the values, the illustration moves to indicate the direction that the image moves, increases, or decreases on the paper.



Note: The factory default setting for all the alignment options is zero.

### Before Creating or Using an Alignment Profile

Before you create a new, or use an existing, alignment profile, perform the following procedure.

1. Load the appropriate stock into the appropriate tray.
2. Print a sample output and check for any misalignment of the output image.
3. If the output image is misaligned, perform the instructions provided in the [Things to Consider When Creating or Using an Alignment Profile](#) procedure.

### Create or Edit an Alignment Profile

Both the operator and the administrator can create, edit, or delete profiles. To create a new, or edit an existing, alignment profile for adjusting side 1 or side 2 image output, use the following procedure. The administrator then assigns the profile to a particular stock from the Advanced Stock Setup window.



Tip: Choose only one Alignment profile feature, such as skew, then to evaluate the skew on that output, run a set of test prints. If you want to adjust multiple Alignment profile features, individually select each feature, run some test prints, and evaluate the output. After you determine that the output for the selected feature is acceptable, then you can select another alignment profile feature to adjust.

1. Select **Profiles**.
2. Ensure that the **Alignment** tab is selected.
3. To create an alignment profile or select a profile from the list, select the **New** icon. Then, to edit an existing alignment profile, select the **Edit** icon.


Either the New Profile Properties or the Edit Profile Properties window appears.

4. In the Profile Name field, enter a new name or modify the existing name.
5. Select an alignment profile option – Registration, Perpendicularity, Skew, or Magnification, then for that option, make the appropriate selections.

When you adjust multiple items, adjust the image in the following order and perform one at a time:

- Perpendicularity adjustment
- Skew adjustment
- Magnification adjustment
- Registration adjustment

6. Select **Test Print**.
7. Select the appropriate Test Print options to use in the jobs that require the profile, including:
  - a. The appropriate paper tray.

- b. Print quantity.  
To evaluate the printed output properly, select a minimum of 10 prints.
  - c. Sides imaged, such as 1-sided face up or 2-sided.
  - d. The appropriate test pattern, if necessary.
  - e. For Color Mode, the dry ink/toner colors being used.
  - f. For Fill Placement Pattern, side 1 or side 2, select the areas of the pages for your job that have heavy ink coverage. The density level setting determines how much ink is placed in these areas of the test print.
8. Select **Start**.
  9. Retrieve your printed output.  
Since inconsistency tends to be greater with the first images, discard the first few prints.
  10. Evaluate the test prints by holding the output at eye level near a light source.  
If 2-sided output was selected, this step allows you to see the registration marks for side 1, and side 2.
    - a. If you determine that the alignment between side 1 and side 2 is unacceptable and needs adjusting, repeat this procedure.
-  Note: Before the printed output meets customer satisfaction, it can take multiple adjustments to the alignment options and running test prints.
- b. When the printed output is acceptable, continue to the next step.
11. If needed, select another alignment option and make the necessary changes.
    - a. Run test prints.
    - b. Evaluate the output.
    - c. Repeat the previous two substeps for any additional alignment options that require adjusting.

When the output meets your satisfaction, continue to the next step.
  12. To save and close the alignment Profile Properties window, select **OK**.  
The new or edited profile procedure appears on the Alignment window and can be selected at any point of need in the future.
  13. To exit Profiles and return to the main window, select **Close**.

## FOLD ADJUSTMENT

The Fold Adjustment feature allows you to adjust the fold position for various paper types, as well as set adjustment values to various default types. You can assign a set type to each tray.

In addition, you can adjust the fold positions for Bi-Fold Single Sheet, Bi-Fold Multiple Sheet, Bi-Fold Multiple Sheets Stapled, C-Fold, Z-Fold, and Z-Fold Half Sheet.

## Fold Types

The fold type specified for the job defines the number of folding lines applied to the paper when printing. The paper shapes vary depending upon whether the orientation of the paper is set to portrait or landscape. The terminology used to identify fold types for both the PC UI and the print server are listed below.

| Name of Fold Type on PC UI | Name of Fold Type on Print Server | Number of Crease Lines |
|----------------------------|-----------------------------------|------------------------|
| Bi-Fold                    | Half-Fold or Booklet-Fold         | 1                      |
| C-Fold                     | Tri-Fold                          | 2                      |
| Accordion Z-Fold           | Z-Fold                            | 2                      |
| Z-Fold                     | Z-Fold                            | 3                      |
| Quatro-Letter-Fold         |                                   | 3                      |
| Accordion (4 Times)        |                                   | 4                      |
| Accordion (5 Times)        |                                   | 5                      |

### Fold Adjustment Profile Option


This option allows you to select a preset fold adjustment profile.



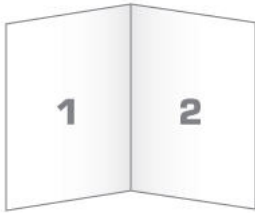
Note: This option is available only if your Production Press has the optional Production Ready Finisher, Production Ready Booklet Maker Finisher, or Production Ready Finisher Plus attached to it.

To view preset profiles or create and maintain profiles, use the **Profiles** feature on the main window of the Control Center and select the Fold Adjustment tab.

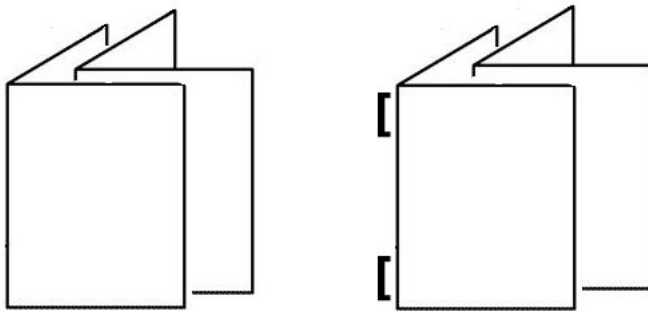
### Fold Adjustment Information

 Note: The Fold Adjustment option is available with the Production Ready Booklet Maker Finisher or when the finisher has the optional C/Z Folder attached to it. The C/Z Folder is applicable for the Production Ready Finisher, Production Ready Booklet Maker Finisher, or Production Ready Finisher Plus.

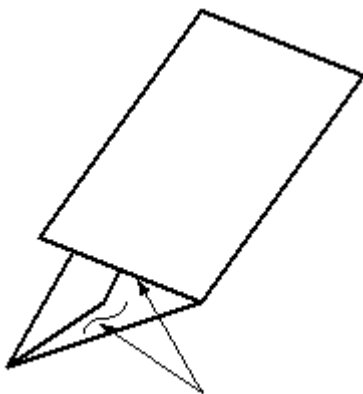
- Bi-fold adjustment: A Bi-fold has one fold, which creates two panels to the output. Bi-fold, or Single Fold, output is delivered to the Booklet Output Tray. The following illustration reflects a Bi-fold Single Sheet:



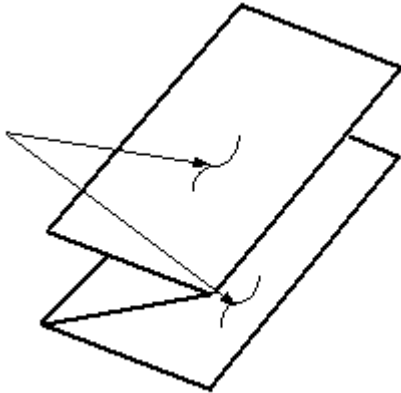
You can also add multiple sheets or multiple sheets with staples to a Bi-fold adjustment as depicted in the following illustrations:



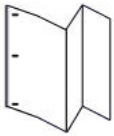
- C-fold: A C-fold has two folds, which creates a three-panel output. C-fold output is delivered to the C/Z Fold Output Tray. The following illustration reflects a C-fold adjustment:




- Z-fold: A Z-fold has two folds that are folded in opposite directions, resulting in a type of fan fold. Z-fold output is delivered to the C/Z Fold Output Tray. The following illustration reflects a Z-fold adjustment:




- Z-Fold Half Sheet: As with a regular Z-fold, it has two folds that are folded in the opposite directions. The difference between a regular Z-fold and a Z-Fold Half Sheet is that the Z-Fold Half Sheet is not folded in two equal folds. The two folds are unequal, which allows one edge of the Z-Fold Half Sheet to have a longer edge. The longer edge allows for stapling or hole punching. Z-Fold Half Sheet output is delivered to the C/Z Fold Output Tray. Refer to the following illustration:



-  Note: Each Z-Fold Half Sheet added to a stapled set counts as 10 sheets. It reduces the total number of sheets for any given specified weight range.

### Create or Edit Bi-Fold Single/Multiple Sheets Adjustment Procedure

-  Note: The fold adjustment feature is available only when the Production Ready Finisher, Production Ready Booklet Maker Finisher, or Production Ready Finisher Plus is attached to your press.

The operator and the administrator can create, edit, or delete profiles. To adjust the fold positions for booklets, you first create a profile with the adjustments. The following procedure provides the basic steps required for creating a new or editing an existing bi-fold adjustment profile for either a single sheet or multiple sheets.

1. Make sure that the appropriate stock is loaded in the Production Press and program the tray. For booklets, load the stock Short Edge Feed (SEF).
2. Select **Profiles**.  
The Profiles window appears.
3. Select the **Fold Adjustment** tab.
4. To create a profile, click the **New** icon. To edit an existing profile, select the appropriate profile from the list, then click the **Edit** icon.  
The Profile Properties window appears.

5. In the Profile Name field, type in a new name or edit an existing name.  
It is recommended that you use a name such as Single Fold Plain or something that indicates the fold type.
6. From the Fold Type menu, select the appropriate fold type, such as **Bi-Fold – Multiple Sheets**.
7. Select appropriate stock settings, such as Size, Type, Coating, and Weight.
8. For the feed edge, select Short Edge Feed.
9. Select **Test Print**.

The Fold Adjustment Test Print window appears.

10. From the Tray menu, use the arrow to select the tray with the loaded stock you are using.
11. If you use the trimmer to score pages, set the crease to **On**. Only the first and last sheets are creased for the booklet. Otherwise, leave this setting to **Off**.
12. Select **Test Print**.  
A message appears indicating that the test print is being created, followed by a message that the print is complete.
13. To close the message window, select **Close**.
14. Notice the adjustment area for Set 1 that shows the two dimensions, A and B, that you need to measure and enter.
15. Obtain the Test Print from the output area of the Production Press and hold it in front of the adjustments for Set 1 in the position shown on the window. The large black arrow faces up and points left.
16. Determine if the Left (top icon) and Right (bottom icon) sides of the fold are equal, or if one of the sides is longer. If one side is longer, measure the amount of overlap, which is the distance between the edges. Record the difference in millimeters.
17. Select the correct fold position for either the single sheet or multiple sheets:
  - Left Side of Fold is Longer
  - Right Side of Fold is Longer
  - Left and Right Sides Equal
18. If you select either the Left Side or Right Side of Fold is Longer, set the distance of the overlap using the up arrow. As you enter the amount in millimeters, the image of the fold changes to confirm which edge you selected as longer. Look at the image and verify that it represents the layout of your test print.
19. From the Sheets in Set 1 area, select **Test Print**, then evaluate the output with the new settings.
20. If you need further adjustments to the new fold positions, repeat the steps. Otherwise, go to the following step.
21. On the right side of the window, based on the weight of the paper selected, the Sheets in Set 2 area shows the maximum number of sheets you can assign to the booklet. You can set this number to the exact number of pages in your booklets, but do not exceed the actual number in this field.
22. On the right side of the window, select **Test Print**.
23. From the Tray menu, select **Start**.
24. To make adjustments for Set 2, repeat the steps for Set 1.
25. When all adjustments are complete, select **OK**. The new or edited fold adjustment profile appears in the Fold Adjustment window.

26. To exit Profiles and return to the main window, select **Close**.

### Create or Edit Bi-Fold Multiple Sheets Stapled Adjustment Procedure



Note: The fold adjustment feature is available only when the Production Ready Finisher, Production Ready Booklet Maker Finisher, or Production Ready Finisher Plus is attached to your press.

The operator and the administrator can create, edit, or delete profiles. To adjust the fold and staple positions for booklets, you first create a profile with the adjustments. The following procedure provides the basic steps required to create a new or edit an existing bi-fold adjustment profile for multiple stapled sheets.

1. Make sure that the appropriate stock is loaded in the press and program the tray. For booklets, load the stock Short Edge Feed (SEF).
2. Select **Profiles**.  
The Profiles window appears.
3. Select the **Fold Adjustment** tab.  
The Fold Adjustment option appears.
4. To create a profile, click the **New** icon. To edit an existing profile, select the appropriate profile from the list, then click the **Edit** icon.  
The Profile Properties window appears.
5. In the Profile Name field, type a new name or edit the existing name.  
It is recommended that you use a name that indicates the fold type.
6. From the Fold Type menu, select the appropriate fold type, **Bi-Fold – Multiple Sheets Stapled**.
7. Select the appropriate stock settings for the booklets: Size, Coating, and Weight.
8. Select **Test Print**.  
The Fold Adjustment Test Print window appears.
9. From the Tray menu, to select the tray with the loaded stock you are using, use the arrow.
10. If you use the trimmer to score pages, set the crease to **On**. Only the first and last sheets are creased for the booklet. Otherwise, leave this setting to **Off**.
11. Select **Test Print**.  
A message appears that indicates that the test print is being created, followed by a message that the print is complete.
12. To close the message window, select **Close**.
13. Notice the adjustment area for Set 1 that shows the two dimensions, A and B, that you need to measure and enter.
14. Obtain the test print from the output area of the press and hold it in front of the adjustments for Set 1 in the position shown on the window. The large black arrow faces up and points left.
15. Determine if the Left, top icon, and Right, bottom icon, sides of the fold are equal, or if one of the sides is longer. If one side is longer, measure the amount of overlap, which is the distance between the edges. Record the difference in millimeters.

16. Select the correct fold position for multiple stapled sheets:
  - Left Side of Fold is Longer
  - Right Side of Fold is Longer
  - Left and Right Sides Equal
17. Set the distance of the overlap using the up arrow. As you enter the amount in millimeters, the image of the fold changes to confirm which edge you selected as longer. Look at the image and verify that it represents the layout of your test print.
18. Select the appropriate staple position option. If the staple lies exactly on the fold, no adjustments are needed. If the staple is positioned off from the center of the fold, measure the distance from the fold in millimeters. If the staple is too far up and onto the top sheet, select **Left of Fold**. If the staple is rotated too far down and onto the bottom sheet, select **Right of Fold**.
19. Set the distance of the offset using the up arrow. As you enter the amount in millimeters, the image of the staple position changes to confirm which direction you selected. Look at the image and verify that it represents the staple position of your test print.
20. From the Sheets in Set 1 area, select **Test Print**, then evaluate the output with the new settings.
21. If you need further adjustments to the new fold and staple positions, repeat the steps. Otherwise, go to the following step.
22. On the right side of the window, the Sheets in Set 2 area show the maximum number of sheets you can assign to the booklet based on the weight of the paper selected. You can set this number to the exact number of pages in your booklets, but do not exceed the actual number in this field.
23. On the right side of the window, select **Test Print**.
24. From the Tray menu, select **Start**.
25. To make adjustments for Set 2, repeat steps 12–20.
26. When all adjustments are complete, select **OK**. The new or edited fold adjustment profile appears in the Fold Adjustment window.
27. To exit Profiles and return to the main window, select **Close**.

### Create or Edit C-Fold Adjustment Procedure



Note: The C-Fold Adjustment feature is available only with the C/Z Folder, which is available with the Production Ready Finisher, Production Ready Booklet Maker Finisher, or Production Ready Finisher Plus attached to your Production Press.

The operator and the administrator can create, edit, or delete profiles. To create a new or edit an existing C-fold adjustment profile, use the following procedure. To modify the C-fold position of your output, you first create a profile with the fold adjustments.

1. Make sure that the appropriate stock is loaded in the Production Press and program the tray. Load stock Short Edge Feed (SEF) and select a tray that contains SEF stock.
2. Select **Profiles**.

The Profiles window appears.



3. Select the **Fold Adjustment** tab.  
The Fold Adjustment window appears.
4. To create a profile, click the **New** icon. To edit an existing profile, select the appropriate profile from the list, then click the **Edit** icon.  
The Profile Properties window appears.
5. In the Profile Name field, type in a new name or edit an existing name.  
It is recommended that you use a name that indicates the fold type.
6. From the Fold Type menu, select the appropriate C-fold type.
7. Select the appropriate stock settings, such as Size and Weight.  
Verify that the Short Feed Edge option is selected.
8. Notice the Fold Position adjustment area that shows the two dimensions, A and B. These points are the dimensions to measure and modify.
9. Select **Test Print**.  
The Fold Adjustment Test Print window appears.
10. Select the tray that contains the stock you are using.
11. Select the print quantity.
12. Select **Print Test**.  
A message appears indicating that the test print is being created, followed by a message that the print is complete.
13. Obtain the test print from the output area of the Production Press and hold it in the position shown on the Fold Position adjustment icon in the window. The large black arrow faces up and points left.
14. Determine if the Left, top icon, and Right, bottom icon, sides of the fold are equal, or if one of the sides is longer. If one side is longer, measure the amount of overlap, which is the distance between the edges. Record the difference in millimeters.
15. Using the plus and minus icons, enter the A length and the B length of the fold position.
16. Select **Test Print**.
17. Evaluate the results of the new settings. If you need to make further adjustments to the fold position, repeat steps 10–17.
18. When all adjustments are complete, select **OK**. The new or edited fold adjustment profile appears in the Fold Adjustment window.
19. To exit Profiles and return to the main window, select **Close**.

### Create or Edit Z-fold Adjustment Procedure



Note: The Z-fold Adjustment feature is available only with the C/Z Folder, which is available with the Production Ready Finisher, Production Ready Booklet Maker Finisher, or Production Ready Finisher Plus attached to your Production Press.

The operator and the administrator can create, edit, or delete profiles. To create a new or edit an existing Z-fold adjustment profile, use the following procedure. To modify the Z-fold position of your output, you first create a profile with the fold adjustments.

1. Make sure that the appropriate stock is loaded in the Production Press and program the tray. Load stock Short Edge Feed (SEF) and select a tray that contains SEF stock.
2. Select **Profiles**.  
The Profiles window appears.
3. Select the **Fold Adjustment** tab.  
The Fold Adjustment window appears.
4. To create a profile, click the **New** icon. To edit an existing profile, select the appropriate profile from the list, then click the **Edit** icon.  
The Profile Properties window appears.
5. In the Profile Name field, type a new name or edit the existing name.  
It is recommended that you use a name that indicates the fold type.
6. From the Fold Type menu, select the Accordion Z -fold type.
7. Select the appropriate stock settings such as Size and Weight.  
Verify that the Short Feed Edge option is selected.
8. Notice the Fold Position adjustment area that shows the two dimensions, A and B. These points are the dimensions to measure and modify.
9. Select **Test Print**.  
The Fold Adjustment Test Print window appears.
10. Select the tray that contains the stock you are using.
11. Select the print quantity.
12. Select **Print Test**.  
A message appears indicating that the test print is being created, followed by a message that the print is complete.
13. Obtain the test print from the output area of the Production Press and hold it in the position shown on the Fold Position adjustment icon in the window. The large black arrow faces up and points left.
14. Determine whether the Left, top icon, and Right, bottom icon, sides of the fold are equal, or if one of the sides is longer. If one side is longer, measure the amount of overlap, which is the distance between the edges. Record the difference in millimeters.
15. Using the plus and minus icons, enter the A length and the B length of the fold position.
16. Select **Test Print**.
17. Evaluate the results of the new settings. If you need to make further adjustments to the fold position, repeat steps 10–17.
18. When all adjustments are complete, select **OK**. The new or edited fold adjustment profile appears in the Fold Adjustment window.
19. To exit Profiles and return to the main window, select **Close**.

## Create or Edit Z-fold Half-Sheet Adjustment Procedure



Note: The Z-fold Half-Sheet Adjustment feature is available only with the C/Z Folder, which is available with the Production Ready Finisher, Production Ready Booklet Maker Finisher, or Production Ready Finisher Plus attached to your Production Press.

The operator and the administrator can create, edit, or delete profiles. To create a new or edit an existing Z-fold Half-Sheet adjustment profile, use the following procedure. To modify both the Z-fold and half-sheet positions of your output, you first create a profile with the fold adjustments.


1. Make sure that the appropriate stock is loaded in the Production Press and program the tray. Load the stock Short Edge Feed (SEF) and select a tray that contains SEF stock.
2. Select **Profiles**.  
The Profiles window appears.
3. Select the **Fold Adjustment** tab.  
The Fold Adjustment window appears.
4. To create a profile, click the **New** icon. To edit an existing profile, select the appropriate profile from the list, then click the **Edit** icon.  
The Profile Properties window appears.
5. In the Profile Name field, type a new name or edit the existing name.  
It is recommended that you use a name that indicates the fold type.
6. From the Fold Type menu, select the Z-fold Half Sheet type.
7. Select the appropriate stock settings, such as Size and Weight.  
Verify that the Short Feed Edge option is selected.
8. Notice the Fold Position adjustment area that shows the two dimensions, A and B. These points are the dimensions to measure and modify.
9. Select **Test Print**.  
The Fold Adjustment Test Print window appears.
10. Select the tray that contains the stock you are using.
11. Select the print quantity.
12. Select **Print Test**.  
A message appears indicating that the test print is being created, followed by a message that the print is complete.
13. Obtain the Test Print from the output area of the Production Press and hold it in the position shown on the Fold Position adjustment icon in the window. The large black arrow faces up and points left.
14. Determine if the Left, top icon, and Right, bottom icon, sides of the fold are equal, or if one of the sides is longer. If one side is longer, measure the amount of overlap, which is the distance between the edges. Measure the sample output and record both Z-fold, half-sheet positions on a sheet of paper. Record the difference in millimeters.
15. Using the plus and minus icons, enter the A length and the B length of the fold position.
16. Select **Test Print**.

17. Evaluate the results of the new settings. To make further adjustments to the fold position, repeat steps 10–17.
18. When all adjustments are complete, select **OK**. The new or edited fold adjustment profile appears in the Fold Adjustment window.
19. To exit Profiles and return to the main window, select **Close**.

## AIR ASSIST


The Air Assist profile allows you to create a group of custom settings that adjust the air flow in the paper trays and improve how paper is fed into the Production Press.

If you experience misfeeds or multifeeds with a particular stock, create an Air Assist profile for that stock. These settings control the fan and blower speeds in the paper tray and the shutters that direct air flow. The fans blow air to the paper stack during the feeding operation and separate sheets of paper.


 Note: The blowers, or fans, always operate in unison, while the blowers and shutters operate independently.

### Create or Edit an Air Assist Profile

Both the operator and administrator can create, edit, or delete profiles. If your job experiences misfeeds or multifeeds with a certain stock, you can create a custom Air Assist Profile for that stock and assign it during printing.

 Note: Before creating an Air Assist Profile and assigning the profile to a stock, the administrator can attempt to address misfeeds by adjusting Tray Air Assist settings from the Advanced Stock Setup window. To apply an Air Assist Profile, refer to the Advanced Stock Setup window in the Manage Stock Library.


To create a new or edit an existing Air Assist profile, use the following procedure.

 Tip: If sheets are sticking together, increase the values a step or two at a time until the problem is resolved.

1. On the main window, select **Profiles**.
2. Click the **Air Assist** tab.
3. To create a profile, click the **New (+)** icon. Or, select a profile from the list, then to modify an existing profile, click the **Edit** icon.

Either the New Profile Setup or the Edit Air Assist Setup window appears.

4. In the Profile Name field, enter a new name or modify the existing name.
5. In the Number of Pre-Blows field, select the number of times the shutter in front of the lead and end blowers of the feed tray open and close – 1 time, 2 times, 4 times, or 8 times.

 Tip: Pre-blows are short bursts of air that occur immediately after the tray closes, not during printing, to help separate the sheets. This setting applies to all internal and external paper trays, except for the Multi-Sheet Inserter.

6. Under Air Volume:
  - a. Set the Front and Rear Blower to **Off**, **Low**, **Med**, or **High**.
  - b. Set the Lead Blower to **Off**, **Low**, **Med**, or **High**.
  - c. Adjust the End Blower value to **Off**, **Low**, **Med**, or **High**, only if the paper is over 297.2 mm (11.7 in.) in the feed direction.

7. Under Shutter Action:
  - a. Set the Lead Shutter to **Off**, **Shift Amount-Small**, or **Shift Amount-Large**.
  - b. Adjust the End Shutter value to **Off**, **Shift Amount-Small**, or **Shift Amount-Large**, only if the paper is over 297.2 mm (11.7 in.) in the feed direction.
8. To evaluate how the settings work with the profile, load a tray with the paper that requires the profile.
9. Select **Test Print**.  
The Test Print window appears.
10. To save and close the setup window, select **Print Test**.
11. To exit Profiles and return to the main window, select **Close**.

### FINISHING DEVICES PROFILES

If your Production Press has an optional, third-party, Document Finishing Architecture (DFA) device attached, the Finishing Devices feature is available and the Finishing Devices tab appears on the Profiles window.

Before physically attaching the DFA device to the Production Press, a Xerox representative configures your Production Press with the DFA profiles that you need. These profiles describe the finishing device to the Production Press.

The administrator can create, edit, or delete profiles. To create, enable, or delete a profile for each third-party module configured with your system, from the Profiles area, use the Finishing Devices tab. The setup values for each specific profile appear on the Finishing Devices window.

1. From the Control Center, click **Log In** and log in as the Administrator.
2. From the System menu on the main window, select **Profiles**.
3. Click the **Finishing Devices** tab.
4. Click on the device name that you want to enable, view, edit, or delete.
5. To enable this device on your system, click on the name. A check mark appears in the box in front of the name.
6. To disable this device on your system, to remove the check mark in the box in front of it, click on the name.
7. To edit the profile for the device, select the device name, then click the **Edit** icon.
8. To create a new profile for the device, select the device name, then click the **New** icon.
9. To delete an existing profile, select the device name, then click the **Delete** icon.

## Job Workflows

Job Workflows provides descriptions and step-by-step instructions for commonly-used workflows.

### USING SPECIALTY DRY INKS

The procedure for printing with clear, white, fluorescent pink, metallic silver, and gold dry ink is similar to the procedure for printing with CMYK colors.

For clear, white, fluorescent pink, and metallic dry inks, you can apply the ink:

- To full pages
- To pre-defined spot colors in the file
- To selected objects in the file

If you have the two optional Toner Stations, 1 and 6, you can apply up to two specialty dry inks to the same print job.

- The specialty dry ink loaded into Toner Station 1 is applied over CMYK colors. It is an overlay.
- The specialty dry ink loaded into Toner Station 6 is applied under CMYK colors. It is an underlay.

### Selecting Settings for Specialty Dry Inks

1. Submit the job to the Hold queue on the print server.
2. To open the Job Properties window, double-click the job file.
3. Make the general job settings for the job.
4. Select the **Color** tab, then scroll down. Ensure that the check box for Composite overprint is selected.
5. Select the **Specialty Color** tab.
6. Do one of the following steps:
  - If you are applying the specialty color dry ink over the CMYK colors from Station 1, select the check box for **Apply specialty color over CMYK**.
  - If you are applying the specialty color dry ink under the CMYK colors from Station 6, select the check box for **Apply specialty color under CMYK**.
  - If you have specialty inks loaded in both Stations 1 and 6, and want to print with both colors, select the check boxes for both the **over** and **under** options.

7. After you select the check box for the appropriate CMYK options, you can select any of the following settings that the job requires:
  - Select the specialty color dry ink to apply over or under the CMYK colors.
  - To flood pages with the specialty dry ink, select **Full page**.  
The Full page option covers the entire page with ink.
  - To apply ink to spot colors defined in the file, from the dropdown list, select a color. Color options are **Gold, Silver, White, Clear, Low Gloss Clear, Double print specialty color, or Fluorescent Pink**. Click the **[selected color] spot colors and selected object types** radio button. To define objects now at the print server for the application of the specialty dry ink, click the radio button.
  - If you want to define objects now at the print server for the application of gold, silver, white, clear, or fluorescent pink, select one or more of the specific objects: **Text, Graphics, Image, or Spot**. The ink is applied to all objects of that type on the pages selected. The Spot selection applies the specialty color to all spot colors defined in the print file.
  - To apply the specialty dry ink to all pages in the document, select **All Pages**. To apply the ink to the selected pages, select **Pages**. If you select Pages, enter the specific page or page range. For example, 1 or 12-16 or 3, 5, 7-10.
  - If you want to limit the amount of the specialty dry ink, set the Dry Ink limit to the appropriate percentage.
8. To complete the setup and send the job to the Production Press, click **Print**.

### Using Multi-Pass

To enhance the special effects of the ink further, the multi-pass feature adds multiple layers of specialty dry ink to a job. The job passes through the Production Press multiple times. On each pass-through, the Production Press adds a separate layer. The maximum number of layers over the CMYK output is six. While you print in multi-pass mode, other print jobs are suspended.

1. Load the paper for the job, then at the Control Center, program the media.
2. On the print server, submit the job to the **Hold** queue.
3. To open the job Properties, double-click the job.
4. On the Media tab, for Paper Catalog, select the media that you loaded.
5. On the Media tab, for Pre-printed media, select **Yes**.
6. On the Specialty Color tab, select how you want to apply the clear dry ink. Refer to the options listed.
7. For Job Properties, click **OK**.
8. To open the Multi Pass Clear window, on the top-left of the Command WorkStation menu, click the double arrow >>. Click the **Multi Pass Clear Dry Ink** icon.
9. For Job Name, select your job.


10. Set the mode.  
There are two modes:
  - Normal mode: This mode prints clear plus CMYK ink. If you have not printed the job, use Normal mode. This mode prints CMYK ink, then prints clear ink on the last pass, and prints only clear ink on all other passes.
  - Clear Only mode: This mode prints only clear dry ink. When you have printed the job and want to add more layers of clear ink, use this mode.
11. Set the number of passes.  
You can set up to seven passes.
12. Click **Print First Pass**.
13. After each pass, retrieve the prints, then reload them for the next pass.
  - Do not change the orientation of the paper stack.
  - Load the stack face-up into the same feeder tray.
  - Check that the stack is in the same orientation as it was when you removed it from the output tray.
14. After the first pass, define the prints that you loaded into the tray as **Preprinted**. As the sheets are processed, the Production Press can adjust the fuser temperature. Use the following steps:
  - a. On the main window of the Control Center, select **Manage Stock Library**, then locate the media that you used for the first run.
  - b. Select the media, then click **Copy**.
  - c. Note the name that the system assigned to the new media, Custom Stock XX. In a later step, you select this new media name for the tray.
  - d. Select the **Preprinted** check box for the new media, then click **OK**.
  - e. Close the **Manage Stock Library** window.
  - f. At the Control Center, click the tray number for the paper tray that you are using.
  - g. Click **Manage Stock Library**, then select the media that you created for the tray that has Preprinted selected.
15. Click **Print [next] Pass**.
16. When the job is completed, to allow other print jobs, close the Multi Pass Clear Dry Ink window.

### **Adding Metallic Effects with the Image Enhance Visual Editor**

Image Enhance Visual Editor (IEVE) is an image-editing application in the Command WorkStation. This tool lets you add specialty color effects to images in a job and view the adjusted images as you make changes.

1. Submit the job to a Hold queue.
2. Right-click the job and select **Image Enhance Visual Editor**. Before the job is opened, all raster images are removed. After editing, reprocess the job.
3. For Special Effects Layer, select **On**.
4. The specialty color layer appears in the preview. To show or hide the specialty color, use the **Preview** mode setting.
5. For **Type**, select the specialty color.




6. To set the amount of specialty colorant applied, use **Adjust Ink Level**.
  7. For **Style**, select the effects that you want:
    - **Posterize**: This option applies specialty color to a specific level of darkness and does not apply specialty color to any areas that are lighter. The result is a high-contrast effect.
    - **Emboss**: This option applies specialty color to edges. The result is a three-dimensional effect.
    - **Hue Select**: This option applies specialty color to the hue specified by the Hue/Highlight setting. The Hue/Highlight setting includes the hue angle in degrees.
    - **Highlight Select**: This option applies specialty color to the highlight level specified by the Hue/Highlight setting. Colors at that level and lighter are overprinted.
-  Note: To use Hue Select or Highlight Select, set a low Amplitude value. Set the hue angle or highlight level, then set Amplitude to the appropriate level. To set the extent of the effect, use Amplitude. The higher the Amplitude setting, the greater the area affected. You can select Invert to create the opposite effect. The Invert setting applies specialty color everywhere except where the style specifies.
8. Save the job, then exit.
  9. Before you print the job, open the properties for the job, then select the **Specialty Colors** tab.
  10. For silver, gold, white, or fluorescent pink spot color or colors and selected objects, select **Apply**. Ensure that the object check boxes are clear.

### Setting Spot Color Equivalent Names

If you receive a job that contains specialty dry ink objects that are defined in the print file by a designer, at the print server, set the names used for the spot color definition. The names Clear, clear, White, white, Fluorescent Pink, fluorescent pink, Silver, silver, Gold, and gold are set automatically by default at the server. However, if the designer used other names, to specify the actual name used in the file, create an equivalent name on the print server.

1. From the Server menu, select **Device Center**.
2. Under Resources, select **Specialty Colors**.
3. In the Group Name area, select the general name for the specialty dry ink that you are using: silver, gold, white, fluorescent pink, or clear.
4. To ensure that your alternate name is not listed, review the names at the right of the window.
5. Above the Group Name list, select **+ New**. The New Specialty Color window opens.
6. In the Name area, enter the exact name of the spot color to print with clear dry ink.

 Important: Enter the name exactly as defined by the designer. Spot color names on the server are case-sensitive.

7. Click **OK**.  
The new equivalent name is on the right of the window, under the default color names provided with the print server. If the color name does not have a lock icon next to it, you can delete the name. To delete a name in the list, right-click the name, then select **Delete**.

## BOOKLETS WITH FULL BLEED USING FOUR OPTIONAL FINISHING DEVICES

The print job workflows involve creating full-bleed booklets using the Inserter, Production Ready Booklet Maker

Finisher, a Two-Sided Trimmer, and a SquareFold® Trimmer.

### Enabling the Offset Mode

When printing jobs, if a message appears indicating that the Offset Catch Tray is not offsetting, check the print server. Ensure that the print server offset mode is enabled. Use the following procedure to enable the offset mode:

1. If necessary, cancel the print job.
2. Select the appropriate job.
3. Open the job **Properties** window.
4. Select the **Finishing** tab.
5. Ensure that Offset Catch Tray is selected for the Output Tray.
6. Select the check box for **Offset Mode**.
7. To save and close the Properties window, select **OK**.
8. Resend the print job.

### Printing Saddle-Stitched Booklets With Full Bleed, Trimmed Edges, and Inserting Pre-printed Covers

This workflow produces an appealing look on the printed output.

The Production Ready Booklet Maker creates saddle-stitched booklets. The Crease and Two-sided Trimmer and the SquareFold® Trimmer cut the edges off three sides of the booklets so that the images extend to the page edge. You can use the Inserter to include pre-printed cover pages. The full-bleed selection produces an appealing look for many documents. The setup for this type of workflow includes:

- Loading the paper and programming it from the print server
- Submitting the job and opening Job Properties
- Setting Properties for the media, layout, folding, and trimming
- Making settings to insert pre-printed covers
- Releasing the job for a Proof copy
- Checking the output and making trim setting or imposition adjustments
- Printing the job



Note: To determine the amount of trim needed for a full bleed of page images, print the file with no trim, then make adjustments as needed.

### Creating Booklets With Full Bleed

To print booklets with three-sided trimming for full-bleed output, perform the following steps:

1. Load the media into a Production Press tray.
  - For a finished size of A4/210 x 297 mm (8.5 x 11 in.), load A3/297 x 420 mm (12 x 18 in.) paper into the tray. Impose two A4/210 x 297 mm (8.5 x 11 in.) images onto each side of the sheets. This method provides an edge around the images for trimming.
  - If you load 279 x 432 mm (11 x 17 in.) paper into the tray, you can impose two A4/210 x 297 mm (8.5 x 11 in.) images onto each side of sheets. After the edges are trimmed, the resulting size is less than 210 x 297 mm (8.5 x 11 in.).
2. From the Control Center, program the media for the tray.
  - a. Select the number of the tray where you loaded the paper.  
The Tray Properties window appears.
  - b. In the Tray Properties window, select the **Create New Stock** button.  
The New Stock Setup window appears.
  - c. In the New Stock Setup window, select the media that is loaded in the tray, then enter the details for the media.
  - d. To save and close the New Stock Setup window, select **OK**.
  - e. To close the Tray Properties window, select **OK**.
  - f. Minimize the Control Center window.
3. From the Hold queue on the print server, to open the Properties window, double-click the job.
4. On the Quick Access tab, enter the Paper size and Paper source where you loaded the media. Enter the number of Copies.
5. On the Media tab, for Duplex, if printing on two sides of the media, select **Top-top**. For 1-sided, or Simplex printing, ensure that the setting is Off.
6. On the Finishing tab, for Fold, set Fold style to **Booklet-fold**.
7. On the Finishing tab, for Stapler, set Stapler mode to **Center**.
8. On the Finishing tab, for Trim, select the check box for **Head and foot trim**.
9. To set the Finish Size of pages, use the up and down arrows.  
The Finish Size is the distance from the top of the page to the bottom of the page.
10. For Spine printing, select **Normal**.
11. Select the check box for **Engage fore** face trim.
12. To set the face trim, use the up and down arrows.  
You can set either the Finish Size, or the amount of the face to trim. For a right-bound booklet, the Finish Size is the distance from the spine to the right side of the page.
13. If your file is pre-imposed, the settings are complete, and you can release the job to print.  
If the file is not pre-imposed, access the Layout tab. To set the imposition for the job, select **Booklet**.
14. If you are not inserting pre-printed covers, to proof the job and check the output, click **Proof**. To print the full job, click **Print**.
15. **To insert covers when the job is pre-imposed:**


If you have an Inserter configured for your Production Press, you can insert pre-printed cover sheets for the booklets. The size of the cover sheets is the same as the body sheets. The Booklet Maker wraps the pre-printed cover sheet around the body pages to form a front and a back cover.

- a. Load the pre-printed cover media into the Inserter Tray.
  - b. Program the media from the Control Center. Select the **T1** tray.  
The Tray Properties window appears.
  - c. In the Tray Properties window, select the **Create New Stock** button.  
The New Stock Setup window appears.
  - d. From the New Stock Setup window, select the paper that is loaded in the tray. Enter the details for the media.
  - e. To save and close the New Stock Setup window, select **OK**.
  - f. To close the Tray Properties window, select **OK**.
  - g. Minimize the Manage Stock Library window.
  - h. At the print server, in the **Job Properties** window, select the **Media** tab. Scroll down, then select **Define Cover**.
  - i. Select the check box for **Front Cover**. From the menu, select **Insert**.
  - j. For Paper Source, select **T1**.
  - k. If the cover media is different from the body media, set any other unique paper properties for the cover media. For example, the g/m<sup>2</sup> cover weight can be heavier than the body media weight.
  - l. In the Cover Media window, select **OK**.
  - m. To release the job, on the Media tab, select **Print**.
16. **To insert covers when the job is not pre-imposed:**
- a. Load the pre-printed cover media into the Inserter Tray.
  - b. Program the media at the **Manage Stock Library**.
  - c. Select the **Layout** tab.
  - d. Scroll down to the Cover area.
  - e. Select **Pre-Printed**.
  - f. Select **Define Cover**.
  - g. For Cover source, select **T1**.
  - h. For **Media Weight**, select the g/m<sup>2</sup> for the cover media, then set any other unique cover media properties.
  - i. Select **OK**.
17. To release the job, on the Layout tab, select **Print**.

### Using the Production Ready Finisher, Basic Punch, and C/Z Folder


If you have the optional C/Z folder, you can produce Tri-folds and Z-folds on 216 x 279 mm (8.5 x 11 in.) or A4 sheets.


You can create Half Z-folds on A3/B4 (11 x 17 in.) media. For Z-folds or Half Z-folds, the Production Press folds the A3 (11 x 17 in.) paper and reduces the sheet to A4 (8.5 x 11 in.) paper. B4 size sheets are reduced B5 size. You can insert the folded sheet into an A4 (8.5 x 11 in.) document so that readers can pull out the folded portion to see an extra-large image.

 Important: When loading or selecting media for folding, it is important to position the paper Short Edge Feed (SEF).

### Producing Simple Folded Sheets

1. For the job, load the paper short-edge feed (SEF) into the appropriate tray, then program the media at the Control Center.
2. From the print server, to open the Properties window, double-click the job. Set the number of print Copies that you want.
3. Set all required properties for the job, such as quantity, paper size, source tray, and 1-sided or 2-sided.

 Note: For C-folds (Tri-folds) and Z-folds, use A4, 210 x 297 mm (8.5 x 11 in.) sheets. For Engineering Z-folds (Half Z-folds), use A3, 297 x 420 mm (11 x 17 in.) or B4, 250 x 253 mm (9.8 x 13.9 in.) paper.

4. Select the **Finishing** tab, then scroll down to the Fold area.
  5. For Fold, set Fold style to the appropriate fold. Select an option:
    - Half Fold (Bi-Fold)
    - Half Z-Fold
    - Z-Fold (Accordian)
    - Tri-Fold (Letter C-Fold)
  6. Set the fold order to **Inside** or **Outside**. When you select Inside, Page 1 is within the fold. When you select Outside, Page 1 is on the back of the fold.
  7. If this message about the Output delivery appears, correct the setting. *Face down – normal order and should be Face down – reverse order.* To correct the setting, select **OK**.
  8. For punched sheets, under Punch, set Punch edge to **Left**, **Right**, or **Top**. Set Punch to one of the following options:
    - Off
    - 2-hole punch
    - 3-hole punch
    - 4-hole punch
-  Important: You can punch Half Z-Folds only.
9. Select **Print**.
  10. Collect the folded output from the finisher top tray or from the C/Z Folder bottom drawer. To open the C/Z Folder bottom drawer, push the button on the top-left front of the unit.

## Using the Inserter to Include Sheets or Tabs into the Printed Output

When you insert covers, sheets, or tabs into printed documents, use the Inserter. The insertion takes place after documents exit the Production Press, but before they reach the final finishing device where the output is retrieved. Use only pre-printed or blank insert media.



Note:

- When using the following accessories, position the tab sheets into the Inserter Tray with the tabs at the lead edge:
  - GBC® Advanced Punch® Pro
  - Stapler
  - Production Ready Finisher
- If you want to print on the inserted sheets, use the Multi-Sheet Inserter or another tray.

### Inserting Sheets and Tabs into the Printed Output

1. If needed, load the main media for the document into a feeder tray with a long-edge feed (LEF) orientation. At the Control Center, ensure that the correct media is programmed.
2. With the tabs at the lead edge, load tab sheets into the Inserter Tray. When you load tabs, place the tabs face up and to the left in the tray, at the trail edge of the media. When you insert pre-printed or blank tabs, the system inserts the tabs, one at a time, in the same order as they were placed in the tray. Ensure that there are no partial sets.
3. At the Control Center, program the media for inserts:



Note: Make the properties for Special Pages unique. If the properties are not unique, the print server can select the same type of media from another tray. Since you want to use only the pre-printed media in the Inserter Tray, ensure that no other media in other trays has the same properties as Special Pages. For example, make unique selections for the Special Pages properties for name, size, and weight. If different types of media have the same properties as Special Pages, from the print server, define a unique name for the media that you want to use. Usually, cover media fed from the Inserter Tray has a heavier weight than other loaded paper, so the cover media has unique properties.

- a. From the Control Center, select tray **T1**.
  - b. If the tab media that you loaded is defined in your Stock Library, select **Stock Library**, then select the tab media. If the tab media that you loaded is not in the Stock Library, select **Create Temporary Stock** and enter the required information.
    - The Size of the media, for example, A4 or 8.5 x 11 in.
    - The Weight of the tab media, usually about 164 g/m<sup>2</sup>, but the weight depends on the media.
    - For Type, select the type of media, for example, Precut tab – Plain.
4. Select the **Long Edge Feed** radio button.
  5. To close the Tray Properties window, select **OK**.
  6. Using the Fiery command workstation, submit the job file to the Hold queue on the print server.
  7. To open the Properties window, double-click the job.

8. Set all the Properties for the job, such as Paper size, 1-sided or 2-sided, Duplex, Off, Top-top, Top-bottom, and number of Copies.
9. Select the **Media** tab, then scroll down to the Mixed Media section. Select **New Insert**.
10. With **Page Number** selected, enter the page numbers after which you want to insert pre-printed or blank sheets or tabs. Use a comma to separate the numbers. For example, to insert a blank sheet after page 7 and page 13, enter **7,13**.
11. For Paper Size, select the size of your tabs, either **8.5 x 11 in. Tab LEF** or **A4 Tab LEF**.
12. For Media Type, select either **Tab stock (uncoated)** or **Tab stock (emboss)**.
13. Select **Insert**.
14. Select **Close**.
15. Select **Print**.

### Creasing Sheets and Booklets and Stapling

To adjust the fold and staple positions for booklets, create a profile with the adjustments. To associate the profile with the media for the job, apply the profile to the booklet job.



Note: This procedure only adjusts the staple position horizontally on the paper and ensures that the booklet staples lie precisely on the fold. The procedure does not enable you to move the staples up or down on the fold. If you require vertical adjustments for staple positions on the fold, contact a Xerox Customer Service Engineer.

### Adjusting Booklet Fold and Staple Position

1. If the booklet media is not loaded in the Production Press, place the media in a tray with short-edge feed (SEF). Program the tray.
2. At the Control Center, select the check box for **Profiles**.
3. Select the **Fold Adjustment** tab.
4. To create a profile or select an existing profile, click the **New** icon (+). To edit an existing profile, click the **Edit** button.
5. From the Fold Type menu, select **Bi-Fold-Multiple Sheets Stapled**.
6. For Name, enter a unique, meaningful name for the profile. You can accept the default name provided, for example, Fold Adjustment 1 or Fold Adjustment 2.
7. For the booklet media, enter the Paper Size, Weight, and Coating.
8. On the right side of the window, click **Test Print**.
9. To select the tray for the media that you are using, from the Tray menu, use the arrow.
10. If you use the trimmer to score pages on the booklets, set the Crease to **On**. If you are not using the trimmer to score pages, set the Crease to **Off**.  
Only the first and last sheets are creased for each booklet. When folded, these pages are the front and back cover sheet and the inside sheet at the center of the booklet.

11. Click **Test Print**.

An information message informs you that the device is creating a test print. When the test print is complete, a message appears.

12. Close the message window. In the adjustment window for Set 1, notice the two dimensions A and B that you need later in the process.

13. Collect the test print. Hold the test print in front of the adjustments for Set 1, in the position shown on the left of the window. The large black arrow faces up and points left.

14. Determine if the Left (top) and Right (bottom) sides of the fold are equal, or if one of the sides is longer than the other. If the sides are equal, no adjustments are necessary. Go to [Step 18](#).

15. If one side is longer, measure the amount of overlap. The overlap is the distance between the edges. Calculate the difference in lengths in millimeters.

16. Select either **Left Side of Fold is Longer** or **Right Side of Fold is Longer**. Note that in the drawing, the left side is shown on the top, and the right side is shown on the bottom.

17. Set the distance of the overlap using the up arrow. As you enter the amount in millimeters, the image of the fold changes to confirm which edge you selected as longer. Look at the image, then verify that it represents the layout of your test print.

18. Evaluate the staple position, then take the appropriate action:

- If the staple lies exactly on the fold, no adjustments are necessary. Go to [Step 21](#).
- If the staple is positioned off-center from the fold, measure the distance from the fold to the staple in millimeters. Continue to the next step.

19. Select the position of the staple:

- If the staple is too far up and onto the top sheet, select **Left of Fold**.
- If the staple is rotated too far down and onto the bottom sheet, select **Right of Fold**.

20. Set the distance of the offset using the up arrow. As you enter the number in millimeters, the image of the staple position changes to confirm the direction that you selected. Look at the image and verify that it represents the staple position on your test print.

21. To output a sample with the new settings, in the Set 1 area, select **Test Print**. If you are satisfied with the new fold and staple positions, go to the next step. To make more adjustments, return to the previous steps. Measure and adjust either the fold position, step , or the staple position, [Step 18](#), or both positions.

22. On the right side of the screen, notice the Sheets in Set 2 field.

The number 30 is the number of sheets in Set 2, and is the maximum number of sheets that you can assign to the booklet, based on the weight of the selected paper. To add pages, reduce the weight of the paper that you are using. You can leave this number as it is and complete the steps. This method provides the profile with the most flexibility for booklets with a range of pages from Set 1 to Set 2. If you always print booklets of a certain size that are less than the maximum sheets listed, set this number to the exact number of pages in your booklets.

23. On the right side of the adjustment window, click **Test Print**.

24. From the Tray menu, select **Start**.

25. To make adjustments for Set 2, repeat [Step 12](#) through [Step 21](#).



26. When all adjustments are completed, click **OK**.  
The new profile is listed on the Fold Adjustment tab.
27. Click **Close**.

#### Applying a Profile that Adjusts Folds or Staple Position for Booklets

1. Select the **Manage Stock Library** function.
2. When the Manage Stock Library window opens, select the specific media to which you want to apply the profile.
3. Click the **Edit** icon.
4. On the Stock Properties window, click **Advanced Setup**.
5. Click the **Fold Adjustment Profile** field. This field can have a system default entry, or another profile listed.
6. Click the **Choose From Fold Adjustment Library** radio button.
7. Select the specific profile that you want to apply to this media.
8. For Fold Adjustment Library, click **OK**.
9. For Advanced Stock Setup, click **OK**.
10. In the Stock Properties window, click **OK**.

#### Printing Full-Page Images on Booklets

When you use full-page images, ensure that the finished booklet size accommodates any full-page images, and that when the booklet is trimmed, the images are not truncated.

- If your booklet has a pre-printed front and back cover with a full-page image, and was printed on 8.5 x 14 in./B4 paper, the front cover, which was trimmed, displays the entire image.
- If the same booklet was printed on 8.5 x 11 in./A4 paper, after trimming the image, the image on the front cover is truncated.

Before you print any booklet job, consider the whole job, including the following:

- What is the appropriate size of the finished booklet?
- Does the booklet contain full-page images?
- Are you using pre-printed covers with full-page images?
- Are you trimming the booklet?
- Do you need to shift any full-page images to ensure that the images fit the finished booklet?

These are important questions that can affect the output of your booklet jobs, especially if you use full-page images and trim the booklet edges.

#### Using the GBC®AdvancedPunch® Pro



Note: The GBC®AdvancedPunch® Pro is shipped with a User Guide on CD.

1. If needed, load the media for the job and program it at the Control Center.

2. Submit the job to the **Hold** queue on the print server.
3. To open the Properties menu, double-click the job.
4. Set all required properties for the job, such as Copies, Paper size, Source tray, and 1-sided or 2-sided.
5. Select the **Finishing** tab.
6. Scroll down to the Punch area.
7. For Punch edge, select the location of the punch on the media: **Left**, **Right**, or **Top**.
8. For Punch, select either **Advanced Pro-ANSI** or **Advanced Pro-ISO**.  
The exact name of the unit depends on your geographic region.
9. To release the job, on the Finishing tab, select **Print**.

# Troubleshooting

This chapter contains:


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This section provides information on recovering from system errors, faults, and jams. It also provides information about how the system alerts you to problems, and other tips and information to help you use the Production Press and improve output.

## General Troubleshooting

The following table helps you resolve some basic problems you can encounter with the Production Press. If the problem persists after following all the instructions, contact your Xerox® Representative or the Customer Support Center.

| PROBLEM   | SUGGESTED SOLUTION  |
|---|---|
| <p>The Production Press does not power on.</p>  | <ul style="list-style-type: none"> <li>• Make sure that the power cord from the Production Press is plugged into the power outlet or receptacle correctly.</li> <li>• Make sure that the red power switch inside the front doors on the print engine right side is set to the ON position.</li> <li>• Make sure that the white power switch on the right side of the print engine tower is set to the ON position.</li> <li>• Check the GFI circuit breakers.</li> <li>• If the power in your location is working properly, you have tried the suggested solutions, and the Production Press does not power on, for assistance, contact the Customer Support Center.</li> </ul>   |
| <p>There is no power to the Production Press and you cannot access the Press Details window to get the serial number.</p> | <p>Open the two main front doors. The serial number is on the frame area above Trays 1 and 2 on the print engine left side.</p>   |
| <p>The Production Press does not complete a print job successfully.</p>   | <ul style="list-style-type: none"> <li>• Is your Production Press connected to the network as a printer? To verify that the Production Press is connected on the network, try printing a test page from your workstation to the Production Press.</li> <li>• Verify that the power cable is connected to the Production Press and to a suitable power socket.</li> <li>• Verify that the network cables are attached securely to the Production Press and seated properly.</li> <li>• Clear out the print job from the print queue and resend the print job.</li> <li>• Power Off, then On the Production Press to restart it.</li> </ul> <p>It is possible that your Production Press is not configured on the network. To connect the Production Press to the network, contact your System Administrator.</p> |
| <p>The Production Press is taking longer than one minute before printing the next job.</p>                                | <p>To make any necessary adjustments for the next print job, including color-to-color registration, density, charge levels, bias levels, or other adjustments, the system requires approximately 2 minutes when switching print modes.</p> <ul style="list-style-type: none"> <li>• If the next print job is switching print modes, for example from black-only to 6-color, to make any necessary adjustments, the system requires approximately 2 minutes. Any changes that involve removing and replacing color cartridges, require a longer adjustment period.</li> </ul>  |

| PROBLEM  | SUGGESTED SOLUTION   |
|--|--|
|  | <ul style="list-style-type: none"> <li>• During this time, the Control Center displays the <i>Adjusting Image Quality</i> message.</li> <li>• When the system completes its adjustments, the next job begins printing.</li> </ul> <p>Other information to remember includes:</p> <ul style="list-style-type: none"> <li>• From a cold start, either power on or power saver, the system takes less than 7 minutes to start printing.</li> <li>• From standby mode, the system usually takes less than 1 minute to start printing.</li> </ul>   |
| <p>After clearing a paper jam, a message appears on the Control Center indicating that a Charge Corotron is not properly installed.</p> <p>None of the charge corotron assemblies were changed or touched.</p> | <ul style="list-style-type: none"> <li>• The Production Press automatically cleans the charge corotron assemblies every 1000 prints.</li> <li>• If a paper jam occurs while the Production Press is cleaning charge corotrons, the cleaning process is interrupted and a message appears on the Control Center.</li> <li>• To clear this message and resume printing, cancel out of the message.</li> </ul> <p> Important: Only a trained, qualified Technical Key Operator can replace the charge corotrons.</p>   |
| <p>Paper is misfed or wrinkles repeatedly</p>  | <p>If a message appears on the UI, follow the instructions displayed.</p> <ul style="list-style-type: none"> <li>• Ensure that the proper paper is loaded correctly and not filled above the MAX line. Refer to the Recommended Materials list.</li> <li>• Turn the paper stack around or over in the selected paper tray.</li> <li>• In the paper tray, remove a few sheets from the top and the bottom of the stack.</li> <li>• Fan all four edges of the paper in the selected paper tray.</li> <li>• Replace the paper in the selected paper tray with paper from a new package.</li> <li>• Remove any partially fed paper from the trays.</li> <li>• Ensure that the paper you are using had been stored properly.</li> </ul> |
| <p>The Control Center does not respond to a command.</p>   | <ul style="list-style-type: none"> <li>• Select <b>System &gt; Restart User Interface</b></li> <li>• Select <b>System &gt; Shutdown System PC</b>. After the Control Center shuts down, wait 15 seconds and restart it by pressing the Control Center On/Off button.</li> </ul> <p>If the problem persists, call the Customer Support Center.</p>  |
| <p>The Control Center display is locked up.</p>  | <p>If the Control Center is locked up, and the mouse or keyboard do not work, press and hold the Control Center power button. Wait 30 seconds and to reboot, press the Control Center power button.</p>  |

| PROBLEM  | SUGGESTED SOLUTION  |
|--|---|
| The Control Center monitor screen is blank.        | <ul style="list-style-type: none"> <li>• Verify that the Control Center button is pressed and lit.</li> <li>• Verify that the Control Center monitor cable is seated properly into the back.</li> </ul>   |
| Multiple sheets feed from the paper trays.         | <ul style="list-style-type: none"> <li>• Do not fill the paper trays above the MAX fill line indicator.</li> <li>• Remove the paper from the tray and to separate the joined sheets, fan the sheets.</li> <li>• Predrilled sheets can stick together at the holes. Remove the paper from the tray and fan the sheets to separate the joined sheets.</li> <li>• Paper and transparencies can stick together if environmental conditions are too dry and cause excessive static. To minimize static, increase the humidity level in the room.</li> <li>• To separate the sheets before you load them, gently fan transparencies.</li> <li>• If the problem is from Trays A1-1, A1-2, A2-1, or A2-2, refer to <a href="#">Stock Library Troubleshooting</a>.</li> </ul>  |
| Paper jams when exiting the Paper Trays.           | <ul style="list-style-type: none"> <li>• Ensure that the edge guides of the paper tray fit snugly against the paper stack.</li> <li>• Do not fill the paper trays above the MAX fill line indicator.</li> <li>• To avoid shifting the paper stack, close the tray slowly.</li> <li>• If the problem is from Trays A1-1, A1-2, A2-1, or A2-2, refer to <a href="#">Stock Library Troubleshooting</a>.</li> </ul>   |
| Output jams when exiting to the Offset Catch Tray. | <ul style="list-style-type: none"> <li>• When no other output device is present, the Offset Catch Tray can hold up to 500 sheets of 24 pound (90 g/m<sup>2</sup>) paper. To ensure continuous production, when output approaches this limit, empty the catch tray.</li> <li>• Ensure that the first sheet is not blocking the paper exit, particularly for A3 (11 x 17 in.) output.</li> </ul>  |
| Excessive paper curl                               | <p>Paper curl can be a result of:</p> <ul style="list-style-type: none"> <li>• Failure to ensure that the correct paper weight and paper type are selected.</li> <li>• The mass of dry ink or toner coverage on the print output – the greater the dry ink/toner mass, the greater the paper curl.</li> <li>• The paper weight and if it is coated or uncoated.</li> <li>• The humidity conditions at the Production Press.</li> </ul> <p>To minimize paper curl:</p> <ul style="list-style-type: none"> <li>• Flip the paper over in the tray and make the prints again.</li> <li>• Use heavier paper or paper that is less sensitive to moisture</li> <li>• When the output approaches the maximum amount that device can hold, empty the output device.</li> </ul> |

## BARCODE SCANNER FAULTS AND ERRORS

| PROBLEM   | SUGGESTED SOLUTION  |
|---|---|
| <p>A Barcode Scanner Fault message appears in the Control Center that indicates one of the following conditions:</p> <ul style="list-style-type: none"> <li>• The barcode scanner is not connected.</li> <li>• The barcode scanner is not detected during startup.</li> </ul> | <ul style="list-style-type: none"> <li>• Ensure that the barcode scanner is connected to the Control Center.</li> <li>• Restart the system.</li> </ul>  |
| <p>More than one barcode scanner is detected</p>  | <p>Ensure that only one barcode scanner is connected to the Control Center.</p>   |
| <p>The following Barcode Scan Error appears:<br/><br/>The last attempted barcode scan was unsuccessful.</p>   | <ul style="list-style-type: none"> <li>• Ensure that the barcode is a valid and complete barcode.</li> <li>• Rescan the barcode.</li> <li>• If the error message persists, scan another barcode.</li> </ul> |

## Problems With Media

As media passes through the components of the Production Press, it sometimes tears, jams, becomes creased, or is misfed.

If these problems occur, the press either performs an automatic purge of the damaged or extra sheets, or you are required to remove jammed media. For more information, refer to [Automatic Media Purge](#) and [Jams](#).

### AUTOMATIC MEDIA PURGE

When a jam occurs in the Production Press, the system displays a purge-in-process message. Any unused sheets upstream from where the jam occurred automatically are purged from the paper path to the closest output tray. However, there can be sheets that remain in the area of the Production Press preceding the jam that are not purged automatically. Make sure to clear those areas manually.



Note: When the purge is completed, a message appears on the interface screen identifying the output tray locations of the purged sheets and the number of purged sheets. Make sure that you remove the same number of sheets as are displayed.

### JAMS

When jams occur, an error message appears on the Control Center. To clear the jam, follow the instructions in the message.

Procedures to clear jams refer to the specific transport to clear by area number. When clearing the fault, you can identify areas of the modules by their number labels on green handles or on green labels. Each module has its own area numbers. For example, Feeder Area 1, IOM Area 1, and Stacker Area 1. To ensure that you clear the correct transport, make note of the module that has the jam. Clear all areas before resetting. Any uncleared sheets can cause another shutdown the next time you start the Production Press.

When a fault occurs, such as media jams, open doors or covers, or a Production Press malfunction, the following actions occur:

- The Production Press stops running and an error message appears on the Production Press User Interface screen.
- The message provides an illustration that shows the location of the fault and brief actions for clearing the fault.
- When a fault occurs in an optional device, the illustration shows the multiple locations of the fault and the required corrective actions.



Note: You can find step-by-step recovery instructions on the inside the front cover of each optional device.

When clearing media jams, always refer to the following information:

- When removing jams, do not power off the Production Press.
- If you power off the Production Press, all stored information in the system memory gets erased.
- Before you resume printing jobs, clear all jams.
- To avoid print defects, do not touch components inside the Production Press.
- Use care when removing the media to avoid tearing it. If the media tears, remove all torn pieces.
- Before printing jobs, check that you removed all jams, including any small ripped pieces of media.



- As long as a jam exists, an error message remains on the display. To clear any remaining jams, for instructions and information, refer to the Production Press User Interface screen.
- After removing all jams, close all doors and covers. When doors or covers are open, the Production Press cannot print.
- After clearing a jam, printing automatically resumes from the state before the jam occurred.
- If all media jams are not cleared, an error message remains on the User Interface screen. To clear any remaining jams, for instructions and information, refer to the User Interface screen.
- Also, if a fault occurs with an optional device, an indicator illuminates on the device control panel and shows the corresponding area on the device where the fault occurred.

## DUPLICATE BARCODES FOR MEDIA

### Problem:

Same barcode is used by some media suppliers or distributors for multiple medias. The duplicate barcodes are flagged in the PredictPrint Cloud Server, but they are not prohibited to use in the trays. Press detects the duplicate barcode as unknown. A barcode can be used at least once per press serial number and share code when used while creating the barcode. Once programmed, the specific system can be able to use only the first programmed stock properties.

### Suggested Solutions:

Use the **Stock Wizard** button to create a new custom barcode for each media using a known duplicate barcode. Create new custom barcode for any media with different stock properties that are reusing the same barcode.

## Image Quality Troubleshooting

Several factors, in addition to completing maintenance tasks, can affect the image quality of your printed output.

When printing a sample of your job and before calling for Service, ensure that:

- Humidity levels of the room are within the Production Press specification, [Environmental Specifications](#).
- You have the appropriate stock type and weight for the Production Press, [Stock Specifications](#).

This section contains a list of image quality artifacts that can occur on your printed output and the actions you can take to improve or resolve the issues.



Tip: All solutions provided here are accessed from the **Advanced Stock Setup** feature. Refer to [Advanced Stock Setup](#).

### IMAGE QUALITY ISSUES

This section contains the following problem-solving topics to help you locate and resolve an image quality problem. Locate the appropriate defect and perform the suggested resolution. If the problem persists after following all of the instructions, contact the Customer Support Center.

- [White Lines, Streaks, Spots, or Deletions](#)
- [Light Image](#)
- [Unfused Dry Ink/Toner Visible and Rubs Off](#)
- [Mottle](#)
- [Random Spots](#)
- [Repeating Spots or Bands](#)
- [Inboard and Outboard Density Variation](#)
- [Skewed or Crooked Image](#)
- [Image Misregistered or Shifted](#)
- [Gloss Differences within a Page](#)
- [Trail Edge Deletions](#)
- [Banding](#)
- [Streaks](#)

### White Lines, Streaks, Spots, or Deletions

Problem: White Lines, Streaks, Spots, or Deletions Appear on Printed Output



### Suggested Solutions

- Ensure that the paper loaded is within Production Press specifications.
- For information on paper specifications and storage, refer to [System Specifications](#) and [Stock and Feeders](#).
- Clean the corotrons:
  1. On the Control Center, log in to Administrator mode.
  2. Select **Maintenance**.
  3. From the System menu, select **Image Quality**.
  4. Clean the Corotrons.
- Perform a 2nd Bias Transfer Roll Auto Adjustment:

1. From the System menu, select **Auto Adjustments**.
2. Slide the 2nd Bias Transfer Roll Auto Adjustment button to the right.
3. Select **Start**.



Note: The adjustment takes approximately 1.5 minutes to run, to produce a test print, and to indicate when the routine is complete.

### Light Image

Problem: Output is too Light or Washed Out



### Suggested Solutions

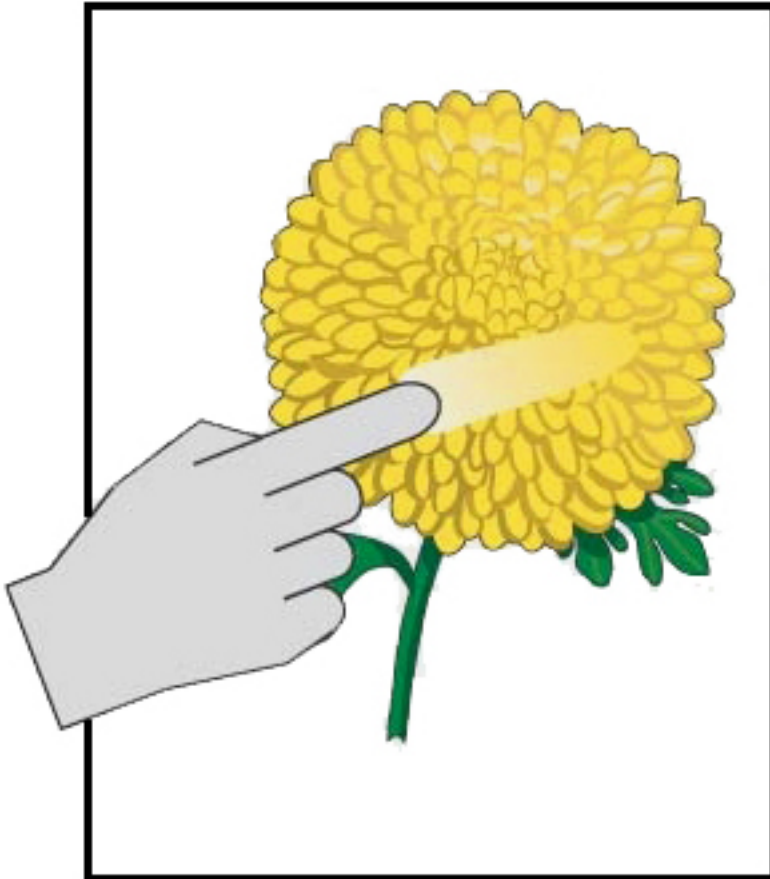
- Verify that Stock Library settings are correct:
  1. Select **Manage Stock Library**.
  2. Select the paper type for the job.
  3. To display the Stock Properties, select **Edit**. For more information, select **Advanced Stock Setup**.
- Perform a 2nd Bias Transfer Roll Auto Adjustment:
  1. From the System menu, select **Auto Adjusting**.
  2. Slide the 2nd Bias Transfer Roll Auto Adjustment button to the right.
  3. Select **Start**.



Note: The adjustment takes approximately 1.5 minutes to run, to produce a test print, and to indicate when the routine is complete.

## Unfused Dry Ink/Toner Visible and Rubs Off

Problem: Unfused Dry Ink/Toner Visible and Rubs Off

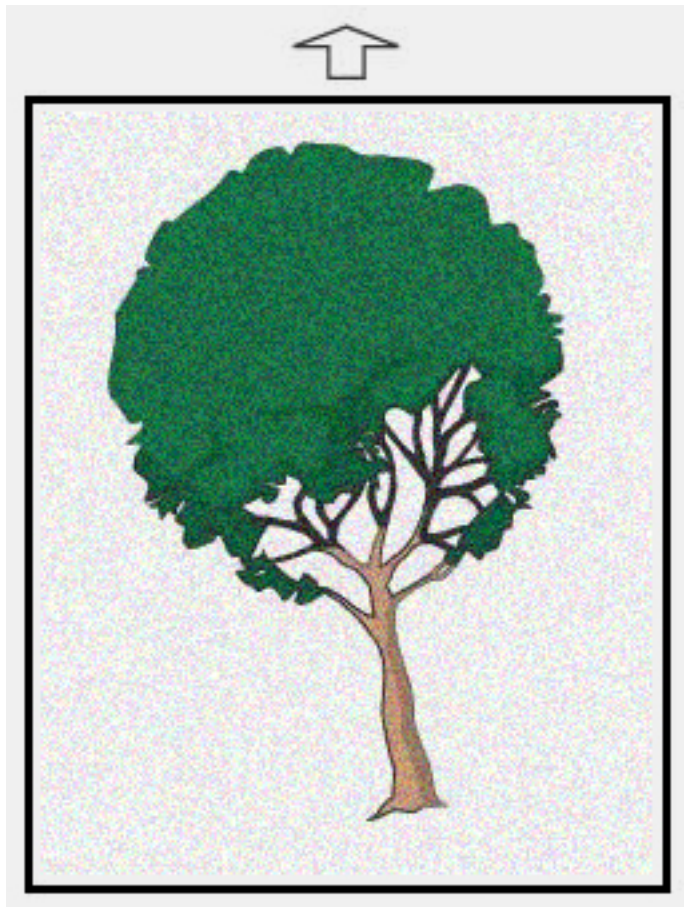


### Suggested Solutions

- Ensure that the paper loaded is within Production Press specifications. For information on paper specifications and storage, refer to [System Specifications](#) and [Stock and Feeders](#).
- Verify that the Stock Library settings are correct for the media weight and type.
- Increase the temperature of the Fuser.
  1. Select **Manage Stock Library**.
  2. Select the paper type for the job.
  3. To display the Stock Properties, select **Edit**.
  4. For more information, select **Advanced Stock Setup**.
  5. Adjust the fuser temperature for the belt and pressure roll.
- For more information, refer to [Unfused Dry Ink/Toner on Output](#).

## Mottle

Problem: High Density and Mottle



### Suggested Solutions

- Verify that the Manage Stock Library settings are correct for the media weight.
- Perform a 2nd Bias Transfer Roll Auto Adjustment:
  1. From the System menu, select **Auto Adjustments**.
  2. Slide the 2nd Bias Transfer Roll Auto Adjustment button to the right.
  3. Select **Start**.



Note: The adjustment takes approximately 1.5 minutes to produce a test print, and to indicate when the routine is completed.


- Adjust the density:




Note: To perform these steps, use software version 5.0 or higher.

1. On the Control Center, log in to Administrator mode.
2. From the System menu, select **Administration**.
3. Select the **Image Quality** tab.

4. Select Maximum Density Control Setup.
5. Add or subtract the value of each appropriate color and select **Apply**.
6. Reprint on a good centerline stock.
7. Evaluate if more adjustments are needed.
8. For more information, refer to [Uneven Density and Mottle](#).

 Note: To improve the mottle, increase the density.

- For the appropriate color, from the System menu, select **Maintenance**, and then select Dry Ink Cleaning.


 Note: If necessary, you can choose more than one color.

### Random Spots

Problem: Random Spots



### Suggested Solutions

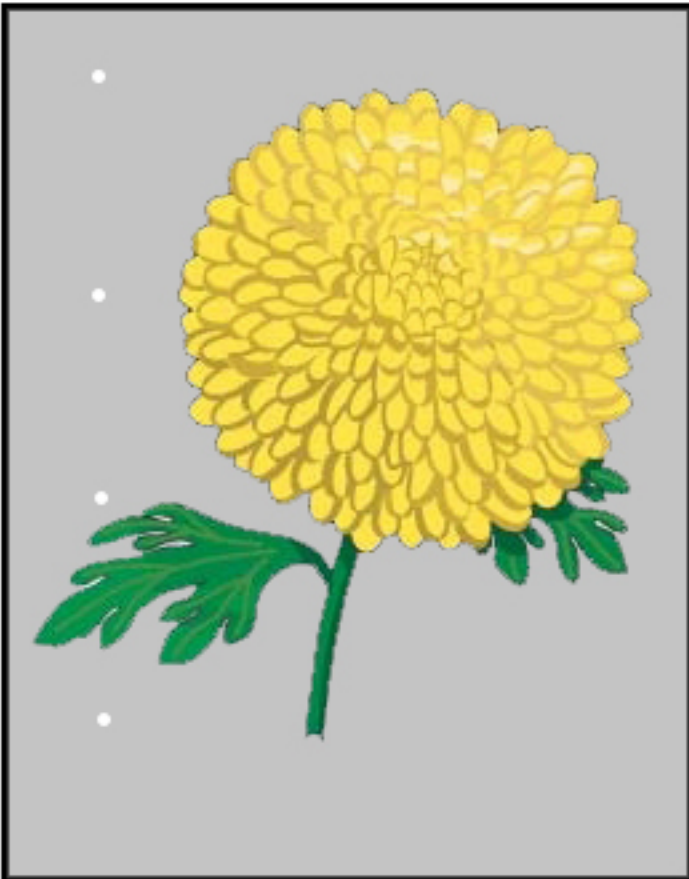
 Note: If one is available, a Technical Key Operator is required to perform the following items, and not an Operator.

## Troubleshooting

- Run the Dry Ink/Toner Cleaning routine in the Administrator mode.
- Vacuum key areas as recommended in the *Xerox® Productivity Plus Technical Key Operator Level 1 Maintenance Manual*.
- Install a new IBT Cleaner. Refer to the *Xerox® Productivity Plus Technical Key Operator Level 1 Maintenance Manual*.

### Repeating Spots or Bands

#### Problem: Repeating Spots or Bands



#### Suggested Solutions

- Determine which color is repeating.
- Measure the interval and compare it to the chart in the Image Quality Problems section of the *Xerox® Productivity Plus Technical Key Operator Level 1 Maintenance Manual*.
- Run the appropriate Density Uniformity adjustment in the Process direction or in the Cross Process direction.



## Inboard and Outboard Density Variation

Problem: Inboard or Outboard Density Variation

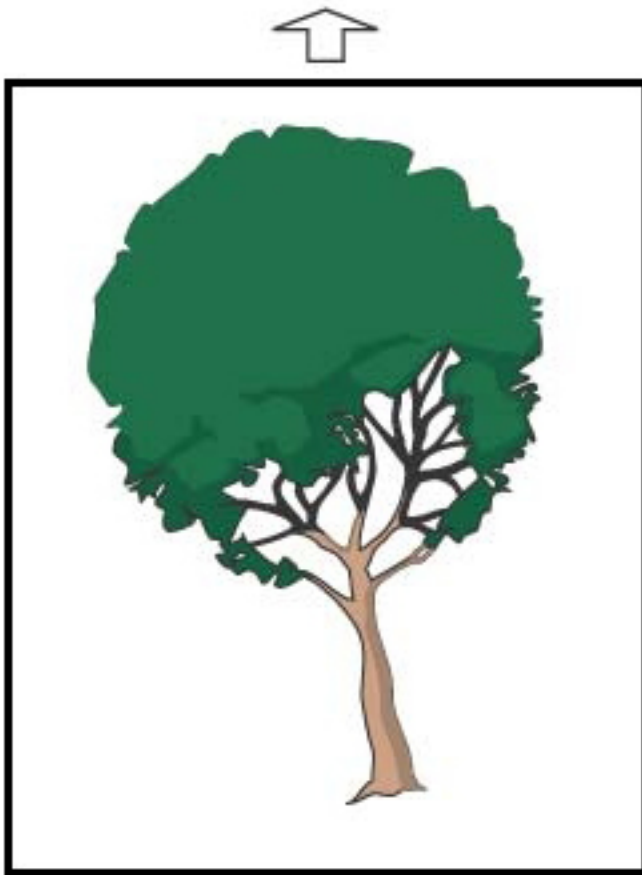


### Suggested Solutions

- Verify that the media settings for the paper in use are correct.
- Perform the Auto Density Adjustment:
  1. From the System menu, select **Auto Adjustments**.
  2. Slide the **Auto Density Uniformity Adjustment** button to the right
  3. Select **Automatic Adjustment Settings**.
  4. Select the radio button for Right Angle Direction and the appropriate Color Mode.
  5. Return to the Setup screen by selecting **OK**.
  6. To run the routine, select **Start**.
  7. Repeat the steps for the Paper Process Direction.

### Skewed or Crooked Image

Problem: Skewed or Crooked Image

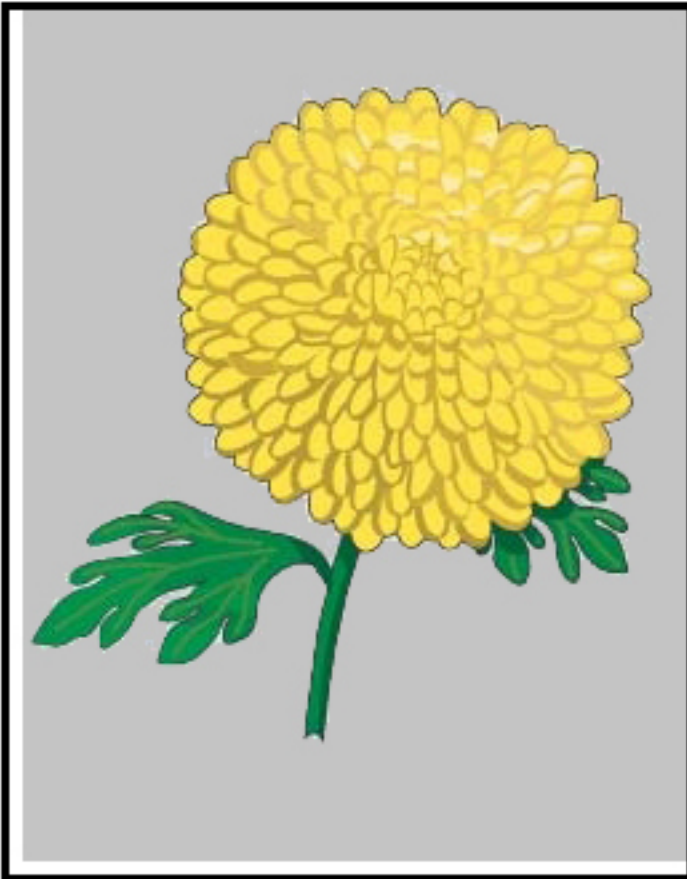


### Suggested Solutions

- Ensure that the paper tray guides are against the edges of the loaded paper.
- Ensure that you are using a correct alignment profile or create a new one. Refer to [Image Registration, Skew, and Magnification](#).
- Open the front door and check that there are no obstacles in the paper path.

### Image Misregistered or Shifted

Problem: Image is Misregistered or Shifted



### Suggested Solutions

- Perform the Auto or Manual Registration Adjustments.
- Perform the **Auto Density Adjustments > Correction Mode > Right Angle Direction and Paper Process Direction.**

### Gloss Differences within a Page

Problem: Gloss Differences within a Page



### Suggested Solutions

- Verify that the Manage Stock Library settings are correct for the media weight and type.
- To improve gloss uniformity, increase the Fuser Temperature under Advanced Setups in the appropriate Stock Profile that displays the differences in gloss laydown.
  1. On the Control Center, log in to Administrator mode.
  2. From the System menu, select **Image Quality**.
  3. Select the **Maximum Density Override** settings.
  4. Change Productivity mode to **IQ**.
  5. Run the **Fuser Belt Refresh** routine.

## Trail Edge Deletions

Problem: Trail Edge Deletions



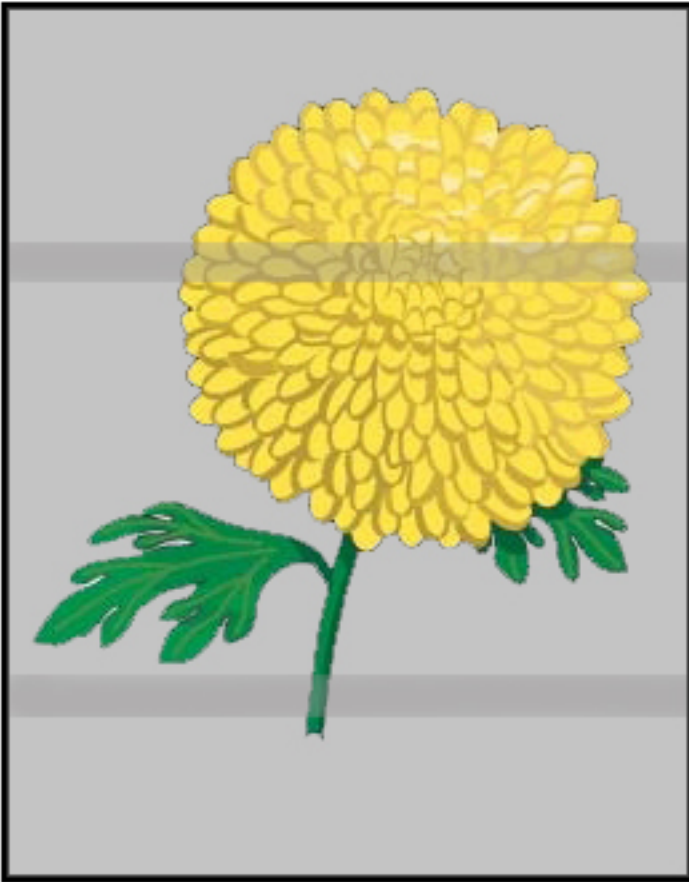
### Suggested Solutions

To adjust the Voltage ratio on the 2nd Bias Transfer Roll (BTR), where the image is transferred from the belt to the media, use this feature.

1. Access this feature in Manage Stock Library > Stock Properties > Advanced Setup.
2. For the particular stock showing the issue, lower the Transfer Output for the Adjustment for Trail Edge by increments of 10%.
3. Reprint the job and evaluate the results.

## Banding

Problem: Banding



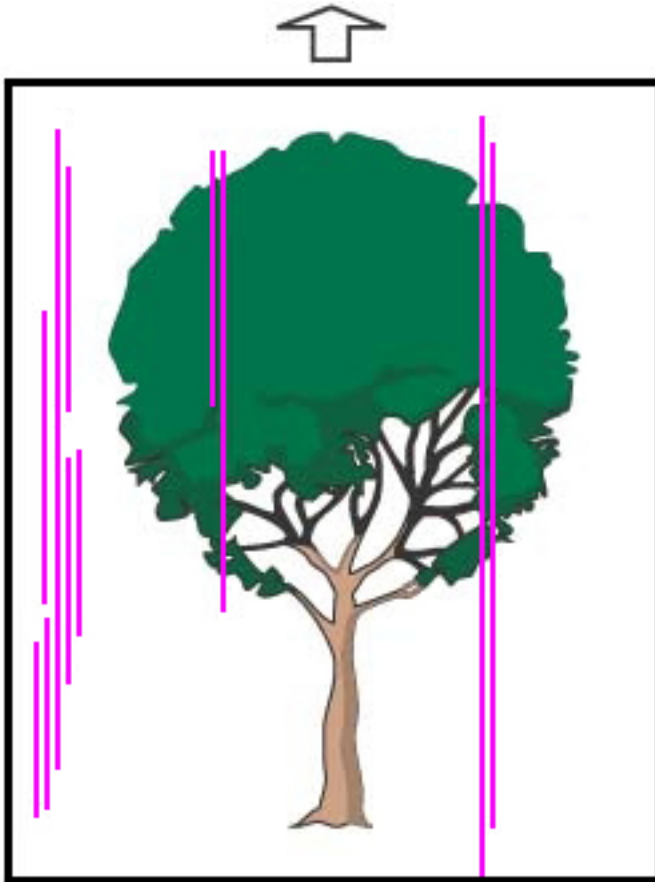
### Suggested Solutions

On the Control Center, check the Consumables/Supply status.

- If lines or dark muddy brown streaks exist throughout the whole page, there can be wear or damage to the Image Belt Transfer Cleaner Assembly. To assess and replace the assembly as required, if one is available, alert the Technical Key Operator.
- If lines, streaks, or deletions in the process direction appear only with black, then replace the Black Corotron Assembly.
- If spots or bands occur every 264 mm on the prints, check the drums for damage or light-shock.
- To determine which color drum can be damaged or light-shocked, run jobs with individual colors – yellow, magenta, and cyan.

## Streaks

Problem: Streaks



### Suggested Solutions

- Clean the Corotrons:
  1. On the Control Center, log in to Administrator mode.
  2. Select **Maintenance**.
  3. From the System menu, select **Image Quality**.
  4. Clean the Corotrons.
- On the Control Center, check the Consumables/Supply status.
  - If lines or dark muddy brown streaks exist throughout the whole page, there can be wear or damage to the Image Belt Transfer Cleaner Assembly. To assess and replace the assembly as required, alert the Technical Key Operator.
  - If lines, streaks, or deletions in the process direction appear only with black, then install a new Black Corotron Assembly. Refer to [Replacing a Charge Corotron Assembly](#).

- Ask a Technical Key Operator, if available, to check the Drums for damage or light-shock.
- To determine which color drum can be damaged or light-shocked, run jobs with individual colors – yellow, magenta, and cyan.
- Perform the Auto Adjustments from the System menu.
  1. Select **Auto Adjustments** from the System menu.
  2. Slide the **Auto Density Uniformity Adjustment** button to the right.
  3. Select **Automatic Adjustment Settings**.
  4. Select the radio button for **Right Angle Direction**, and the appropriate **Color Mode** setting.
  5. To return to the Setup screen, select **OK**.
  6. To run the routine, select **Start**.
  7. For the Cross Process Direction, repeat the process.



## Stock Library Troubleshooting

This section helps you locate and resolve specific problems through the use of **Manage Stock Library**. For detailed information on the features referred to in the following tables, go to your Control Center and access **Manage Stock Library**.

### ACTIONS

#### Initial Actions

To improve print quality, perform these actions first:

- Confirm that the media used meets the following conditions:
  - Compatible with the Production Press
  - Within supported specifications
  - In good condition
  - Assigned to the correct tray

#### Secondary Actions

To view the suggested actions, click the appropriate problem description below. If the action does not resolve the problem, contact the Customer Support Center.

- [Multifeeds, Misfeeds, and Paper Jams in Trays A1-1 through A2-2](#)
- [Paper Curl](#)
- [Paper Jams](#)
- [Uneven Density or Mottle](#)
- [Image Registration, Perpendicularity, Skew, and Magnification](#)
- [Unfused Dry Ink/Toner on Output](#)
- [Edge Damage](#)
- [Fold Adjustment](#)

#### **Multifeeds, Misfeeds, or Paper Jams in Trays A1-1 — A2-2**

**Problem:** Multifeeds, Misfeeds, or Paper Jams in Trays A1-1 — A2-2

Multifeeds, misfeeds, or paper jams are occurring in Trays A1-1 — A1-2.

#### Suggested Solutions

From the **Manage Stock Library** on the Control Center, perform the following solutions.

1. Change the **Tray Air Assist** setting.

- To adjust the air volume generated by the tray blowers that help in separating sheets when feeding media, use this feature. When using light-weight or heavy-weight media, which stick together easily, to better separate sheets and prevent jams or multifeeds, select a stronger air flow setting.
- This feature resides in **Manage Stock Library > Stock Properties > Advanced Stock Setup > Tray Air Assist**.
- The settings available for this feature are:
  - **System Default:** Based on the media and environmental conditions, the air volume is set to the appropriate volume.



Note: For the remaining settings, click **System Default**. A complete list of settings for this feature appear.

- **Multifeed Support Table:** If you use media that triggers multifeeds, select this option. This setting increases the air volume to a level higher than the **System Default**.
- **Mis-Feed Support Table:** If you use media that triggers jams, select this option. This setting increases the air volume to a level higher than the **Multifeed Support Table**.
- **Forced Off:** When working with special media that jams as a result of the air flow that **Tray Air Assist** introduces, select this option. This setting turns off **Tray Air Assist**.
- **Choose from Tray Air Assist Profile Library.** Select from the created Air Assist Profiles.

2. Change the **Enable Tray Heater** setting.

- To **Enable**, which is checked, or **Disable**, which is not checked, the tray heater, use this feature. To help prevent jams and multifeeds by loosening contact between sheets, the tray heater warms the air that is blown into the tray by **Tray Air Assist**.
- The tray heater partially can dry paper and affect print quality. If dry paper affects the print quality, **Disable** the tray heater.



Note: Disabling the tray heater can result in an increase of multifeeds.

- This feature resides in **Manage Stock Library > Stock Properties > Advanced Stock Setup > Enable Tray Heater**

- To **Disable** (unchecked) the tray heater:
  - a. Remove any media loaded in the tray.
  - b. In **Tray Air Assist**, select any option except **Forced Off**.
  - c. **Disable** (unchecked) the tray heater and register the media.


The printer performs a forced exhaust action for approximately one minute. During the forced exhaust action, do not change any settings or open a tray.

 Important: A forced exhaust with paper loaded in tray can lead to image quality problems.

- d. After the forced exhaust is complete, load media in tray.

### 3. Change the **Multifeed Detection** setting.

- To **Enable** (checked) or **Disable** (unchecked) multifeed notifications, use this feature. This feature does not make any other adjustments.
- Access the **Multifeed Detection** feature from **Manage Stock Library > Stock Properties > Advanced Stock Setup > Multifeed Detection**.
- The settings available for the **Multifeed Detection** option include:
  - **Enabled** (checked): Multifeed notifications are switched **On**.
  - **Disabled** (unchecked): Multifeed notifications are switched **Off**.

 Note: To prevent the system from reporting faults due to multifeeds, **temporarily** disable notifications. This action allows you to continue the workflow until you resolve the cause of the problem. Disabling this feature has no impact on the occurrence rate of actual multifeeds, and if disabled, multifeed sheets can cause jams elsewhere in the system or result in more blank sheets in the final output.

## Paper Curl

### Problem: Paper Curl

The paper is curling on the printed output.

## Suggested Solutions

1. If your Production Press configuration includes the Interface Decurler Module (IDM)s, confirm that the **IDM Curl Correction** option on the IDM control panel is set to **Auto**.
2. Change the **Paper Curl Correction** setting from the **Manage Stock Library**.



Tip: Changing the default setting is considered a temporary solution because environmental conditions vary daily. Upon completion of the print job, return the option to its default setting.

- To correct paper curl caused by heat and pressure, and to apply fine adjustments based on the characteristics of each paper type, use the **Paper Curl Correction** feature. Paper curl can cause jams and wrinkled output. This feature can be found in **Manage Stock Library > Stock Properties > Advanced Stock Setup > Paper Curl Correction**.
- From the **Paper Curl Correction** screen, under the type of job that is experiencing the problem – **1 Sided – Face Up**, **1 Sided – Face Down**, or **2 Sided – Side 1**, or **2 Sided – Side 2**, select the **Edit Settings** button.
- When changing the **Paper Curl Correction** setting, make the change by moving up or down the available selections one at a time.
- To ensure that the desired output is achieved, when changing the paper curl, use the following order:
  - Default
  - Severe Upward
  - Medium Upward
  - Moderate Upward
  - Slight Upward
  - No Curl
  - Medium Downward
  - Severe Downward



Tip: To avoid paper jams and wrinkled output, perform the change in the recommended sequential order. For example, using **Default** and then skipping to **Moderate Upward**.



Note: Run test prints every time you change or select a setting. This process allows you to evaluate the output and determine whether to make more changes.

For more information, refer to [Correcting the Paper Curl](#).

- If paper curl continues after trying several or all these settings, try decreasing the image density on the print job or use a different type of paper.
- If paper curl is still a problem after decreasing the image density and after using a different type of paper, for further assistance, contact the Customer Support Center.

## Paper Jams

### Problem: Paper Jams

Paper jams are occurring during print jobs.

## Suggested Solutions

Information about reducing paper jams:

- The air pressure from the vertical transfer (V-TRA) fans on the transfer belts holds sheets on the paper path between the transfer module and the fusing module.
- The lower the air pressure from V-TRA fans, the higher the possibility of paper jams.
- The higher the air pressure, the higher the possibility of having Image quality defects, such as uneven gloss.
- Adjusting the air volume on V-TRA fans can help resolve paper jams or image quality defects.

To minimize paper jams or image quality defects:

1. Access this feature from **Manage Stock Library > Stock Properties > Advanced Stock Setup > V-TRA Fans**.
2. Adjust the air volume of one of the following V-TRA fans:
  - V-TRA Fan #3 – between the Secondary Transfer and Fuser Module
  - V-TRA Fan #4 – between the Transfer and Fuser Module
  - Fuser Exit Fan – between the Fuser Module and Cooling Unit
3. When paper jams occur, increase the air volume. When uneven gloss occurs, decrease the air volume.
4. For the affected area of the Production Press, set up the V-TRA Fans Test Print as necessary.
5. After each incremental adjustment, if you need more adjustments, run test prints and evaluate the output prints to determine.

## Uneven Density and Mottle

### Problem: Uneven Density or Mottle

The printed output contains uneven density or mottle.

## Suggested Solutions

### 1. Perform **2nd Bias Transfer Roll Adjustment**.

- To adjust the voltage ratio on the 2nd bias transfer roll (2nd BTR), use this feature. The 2nd BTR is where the image is transferred from the belt to the paper. Access this feature from **Manage Stock Library > Stock Properties > Advanced Stock Setup > 2nd Bias Transfer Roll Adjustment**.
- You can perform the **2nd Bias Transfer Roll Adjustment** procedure by selecting either **Auto** or **Manual**.



Note: An automatic adjustment fixes most image quality issues. Always perform the **Auto** procedure before performing the **Manual** adjustment.

- **Auto:** The Production Press automatically performs the adjustment. The adjustment eliminates the need to interpret printed targets, and manually enter adjustment values.
- **Manual:** The user manually performs the adjustment, including printing test patterns, interpreting the printed targets, and manually entering the adjustment values.

Use the **Manual** adjustment option only when the **Auto** adjustment does not provide the appropriate output.

When using the manual transfer adjustment, it can be helpful to run the job for which you are performing the adjustment.

- For detailed information and instructions on using the **Auto** and **Manual** adjustment options, refer to [Secondary Transfer Voltage Adjustment](#)

### 2. If you observe this issue on the trail edge of the printed output, and it is not corrected by performing a **2nd Bias Transfer Roll Adjustment**, change the **Transfer Output Adjustment for Trail Edge** setting.

- To adjust the voltage ratio on the 2nd bias transfer roll (2nd BTR), use this feature. This feature is where the image is transferred from the belt to the paper.
- Access this feature from **Manage Stock Library > Stock Properties > Advanced Stock Setup > Transfer Output Adjustment for Trail Edge**.
- Decrease the **Transfer Output Adjustment for Trail Edge** in increments of 10%. After every incremental adjustment, to determine if more adjustment is necessary, run test prints and evaluate the output.

### 3. Perform an **Automatic Density Uniformity Adjustment**.



Note: This adjustment is a Production Press feature and is not a **Manage Stock Library** feature.

- To correct image quality issues on the output when that image quality is not consistent throughout the entire output, use this feature. For example, the image quality is lighter (faded) or heavier (thicker) on the left or right sides of the output (inboard/outboard).
- For information and instructions on how to use this feature, refer to [Performing an Auto Density Uniformity Adjustment](#).

## Image Registration, Skew, and Magnification

### Problem: Image, Registration, Skew, and Magnification

The image on the output requires adjustment on the registration, skew, or magnification.

## Suggested Solutions

1. If using trays 1 or 2, try switching to tray A1-1 or A1-2 or, if available, optional tray A2-1 or A2-2.

- Trays A1-1 through A2-2 have better registration and skew performance.
- For more information on Skew, refer to [Feed Performance in Trays A1-1 and A1-2](#).

2. Create or use an existing **Alignment Profile**.

Before creating a new or using an existing manual alignment, read all the information in the [Alignment](#).

- Use Center Line Stock for **Alignment Profiles**. If the problem occurs when using this stock, call the Customer Support Center.
- For more information, refer to the **Manage Stock Library > Alignment File Name**.
- The following is a summary of the steps required for each procedure. For complete instructions, refer to [Create or Edit an Alignment Profile](#).

- To create a **New Alignment Profile**, perform the following:

a. Select **Profiles > Alignment**.

b. From the Alignment tab, select **New**.

A New Profile Properties window appears.

c. Enter the Name you want to assign to the profile.

d. Perform the **Auto Alignment** procedure. When the routine is complete, select **OK**.

e. To run a set of test prints for evaluation, select **Test Pattern**. On the next screen, select **Start**.

f. If necessary, depending on the results, perform a **Manual Adjustment**.

g. When making manual adjustments to multiple items, use the following guidelines:

- Adjust the image in the following order: **Registration, Perpendicularity, Skew**, and **Magnification**.
- Choose **only one option** at a time, such as **Registration**, then run a set of test prints to evaluate the output. Determine if the printed output for the selected option is acceptable. If it is acceptable, select and adjust the next alignment option.
- After you select each option, always run a set of test prints and evaluate the output. Determine if the output for the selected feature is acceptable. If it is acceptable, continue to adjust another alignment option as required.
- To use an existing Alignment Profile, perform the following:



Note: Select **Manage Stock Library > Stock Properties > Advanced Stock Setup > Alignment File Name**.

a. From the Stock Properties of the appropriate stock, select **Advanced Stock Setup > Alignment File Name**.

b. Select either **Use Default Alignment Profile** or **Choose from Alignment Profile Library**.

If using **Choose from Alignment Profile Library**, select from the list of saved **Alignment Profiles**.

3. Change the **Aligner Roll Pressure** setting.



Tip: Changing the default setting of 0 (zero) is a temporary solution because environmental conditions vary daily. When the print job is complete, return the option to its default setting.

- To adjust the aligner roll pressure, use this feature.
  - Some types of coated media slip and skew, misregistering the image on the output prints. In this case, to apply more force to hold down the media to compensate for the slippage and skewing, increase the Aligner Roll Pressure.
  - Some light weight media can have too much roll pressure applied to them, causing edge damage to the output prints. In this case, to apply less force to hold down the media, decrease the roll pressure.
  - To change the **Aligner Roll Pressure** setting, perform the following:
    - a. Adjust the **Aligner Roll Pressure**.
      - Access the feature from **Manage Stock Library > Stock Properties > Advanced Stock Setup > Aligner Roll Pressure**.
      - Based on the output, increase or decrease the **Aligner Roll Pressure** in increments of five or ten.
      - After each incremental adjustment, to determine if you need to make more adjustments, run test prints, then evaluate the output prints.
4. Change the **Fuser Performance Priority** setting.
- To improve print quality when the image is distorted, either stretched or shrunken, this feature adjusts the fusing speed.
    - If the image is shrunken, increase the fuser speed. If the fuser speed is set too high, it can cause jams.
    - If the image is stretched, decrease the fuser speed.
  - Access this feature **Manage Stock Library > Stock Properties > Advanced Stock Setup > Fuser Performance Priority > Optimize for Speed**.
  - To determine if you need to make more adjustments, after each adjustment, run test prints and evaluate the output.

### **Unfused Dry Ink/Toner on Output**

#### **Problem: Unfused Dry Ink/Toner**

The printed output contains unfused toner on it.



## Suggested Solutions

1. Change the **Fuser Temperature Adjustment** setting.



Tip: Changing the default setting of 0 (zero) is a temporary solution because environmental conditions vary daily. When the print job is completed, return the option to its default setting.

- Use this feature to adjust the fuser temperature.
  - If dry ink/toner comes off the media, especially with special media, increase the fusing temperature.
  - If the fuser temperature is too high when printing on lightweight media, it can cause blocking, media damage, or jams at the Stripper Finger unit in the Fusing module.
  - If the fuser temperature is too low, it can cause poor fusing on higher-density image areas and toner can peel off the printed output.
  - Access this feature from **Manage Stock Library > Stock Properties > Advanced Stock Setup > Fuser Temperature**.
  - Based on the printed output, increase or decrease the **Fuser Temperature Adjustment** in increments of 1° or 2°.
  - After each incremental adjustment, run test prints and evaluate the output to determine whether you need to make additional adjustments.
2. If feeding media from trays A1-1 through A2-2, and if the media is damp, confirm that the **Enable Tray Heater** feature is **Enabled** (checked).



Note: **Enable Tray Heater** is available only for trays A1-1 through A2-2.

- Use this feature to **Enable** (checked) or **Disable** (unchecked) the tray heater.
- The tray heater warms the air that is blown into the tray by **Tray Air Assist** and helps prevent jams and multifeeds by loosening contact between sheets.
- The tray heater can partially dry media and affect print quality. If print quality is affected, disable the tray heater.



Note: Disabling the tray heater can result in an increase of multifeeds.

- Access this feature from **Stock Library > Stock Properties > Advanced Stock Setup > Enable Tray Heater**.
  - To **Enable** (check) the box for **Enable Tray Heater**.
3. Change the **Fuser Performance Priority** setting.
    - Use this feature when you use paper that has poor ink-dry fixing.
    - Access this feature from **Manage Stock Library > Stock Properties > Advanced Stock Setup > Fuser Performance Priority > Optimize for Image Quality**.
    - When you use this setting, the printer runs at a speed of 48 sheets per minute for A4 LEF, 1-sided printing.
    - If you use a stock for which Productivity is set, the setting of the stock takes precedence.

## Edge Damage

### Problem: Edge Damage

The printed output contains damage on the edges.

### Suggested Solutions

Change the **Aligner Roll Pressure** setting.



Tip: Changing the default setting of 0 (zero) is a temporary solution because environmental conditions vary daily. When the print job is completed, return the option to its default setting.

- To adjust the aligner roll pressure, use the Aligner Roll Pressure feature.
- Some types of coated media slip and skew, misregistering the image on the output prints. In this case, to apply more force to hold down the media to compensate for the slippage and skewing, increase the aligner roll pressure.
- Some lightweight media can have too much roll pressure applied to them, which causes damage to the edge of output prints. In this case, to apply less force to hold down the media, decrease the roll pressure.

To change the **Aligner Roll Pressure** setting, adjust the **Aligner Roll Pressure**:

1. Access this feature from **Manage Stock Library > Stock Properties > Advanced Stock Setup > Aligner Roll Pressure**.
2. Based on the output, increase or decrease the **Aligner Roll Pressure** in increments of five or ten.
3. After each incremental adjustment, to determine if you need to make more adjustments, run test prints and evaluate the output prints.

## Fold Adjustment Issues

The **Fold Adjustment Profile** is available only when the system configuration includes one of the following:

- Production Ready Booklet Maker Finisher for Bi-fold/Single-fold, or
- C/Z Folder device with one of the following optional finishers:
  - Production Ready Finisher
  - Production Ready Booklet Maker Finisher
  - Production Ready Finisher Plus

For detailed information about these finishing devices, refer to the [Finishers](#).

### Problem: Fold Adjustment Issues

The fold on the output is not acceptable.

### Suggested Solutions

Create or use an existing **Fold Adjustment Profile**.



Note: Before creating a new or using an existing profile or performing any alignment adjustments, review the entire **Fold Adjustment Profile** section in the **Manage Stock Library**.

For more information, refer to the [Fold Adjustment](#).

- Depending on your system configuration, the following fold adjustments are available:
  - Bi-fold Single Sheet – available only with the Production Ready Booklet Maker Finisher
  - Bi-fold Multiple Sheets – available only with the Production Ready Booklet Maker Finisher
  - Bi-fold Multiple Sheets Stapled – available only with the Production Ready Booklet Maker Finisher
  - C-fold – available with the optional C/Z Folder
  - Z-fold – available with the optional C/Z Folder
  - Z-fold Half-Sheet – available with the optional C/Z Folder

Create a new or use an existing **Fold Adjustment Profile**. The following is a summary of the steps required for creating a new or using an existing procedure.



Note: Access this option from **Profiles > Fold Adjustment Profile**.

1. From the main window, select **Profiles**.
2. Select the Fold Adjustment tab.
3. Select either the **New** or **Edit** button.


If you are editing an existing fold adjustment, select the appropriate profile from the list and then select the **Edit** button.
4. Type in a new name or edit the existing name.
5. To complete the procedure, refer to **Manage Stock Library > Stock Properties > Advanced Stock Setup > Fold Adjustment Profile**. Select the appropriate fold adjustment procedure and complete the procedure for creating a new or editing an existing **Fold Adjustment Profile**.

## Tools to Ensure Production Consistency

To provide ongoing image quality for superior production consistency, the Automatic Image Management System works in concert with the ACQS and FWA tools. How these tools achieve the different time requirements for consistency is shown:

| CONSISTENCY REQUIREMENT  | TOOL  | TYPE OF ADJUSTMENT   | AUTOMATION LEVEL   |
|--|---|--|--|
| <p><b>Consistency within a page</b></p> <p>Uniformity of toner</p>                               | Density Uniformity Adjustment using FWA   | Uniformity across the page – right angle direction, and down the page – paper process direction  | <p><b>Semi-automatic:</b></p> <p>Operator initiates with a click and accepts the results with a click. The system prints targets, scans them, and makes adjustments.</p>   |
| <p><b>Consistency within each print run</b> Color Registration and Uniformity of Toner</p>       | Image Management System Registration Control (RegiCon) Process Control (ProCon) | Color-to-color image alignment and uniformity of toner application   | <p><b>Fully automatic:</b></p> <p>Continuous run-time adjustments from patches being laid down on the Intermediate Belt Transfer (IBT). Marks are read and image data and voltages are adjusted automatically.</p> |
| <p><b>Consistency in image alignment from job to job</b></p> <p>Auto Alignment Adjustment</p>    | Image to Media Alignment using FWA  | Adjusts image placement on the paper. The adjustment is created, saved for specific stocks, and when printing on these stocks, can be selected for any tray  | <p><b>Semi-automatic:</b></p> <p>Operator initiates with a click and accepts the results with a click. System prints targets, scans them, and makes adjustments.</p>   |
| <p><b>Consistency in color from job to job</b></p> <p>2nd Bias Transfer Roll Auto Adjustment</p> | 2nd Bias Transfer Roll Adjustment using FWA                                     | Corrects for uneven toner and color shift by adjusting the transfer roll in the Production Press. The adjustment is created and saved for specific stocks and when the stock is selected for a job, is applied automatically | <p><b>Semi-automatic:</b></p> <p>Operator initiates with a click and accepts the results with a click. System prints targets, scans them, and makes adjustments.</p>   |

| CONSISTENCY REQUIREMENT  | TOOL                                      | TYPE OF ADJUSTMENT   | AUTOMATION LEVEL  |
|--|---|--|---|
| <b>Stability of color from day to day</b><br>Color Calibration | Color Calibration using ACQS with FWA     | Updates the Production Press and print server  | <b>Semi-automatic:</b><br>Operator initiates with a click and accepts the results with a click. System prints targets, scans them, and makes adjustments. |
| <b>Accuracy of color from week to week</b><br>Profiling        | Destination Profiling using ACQS with FWA | Develops a map so that output colors accurately replicate a known standard (for example, GRACoL or SWOP) | <b>Semi-automatic:</b><br>Operator initiates with a click and accepts the results with a click. System prints targets, scans them, and makes adjustments. |

 Important: While these IQ tools are either automatic or semi-automatic, and they save you much time, to keep your Production Press tuned for optimum quality, you still need to use them at the right time.

**Best Practices**

Use the following best practices to optimize your quality output and save time attending to color and registration problems:

1. To perform an EZ Press Check at least once a week, and after any of the xerographic components have been serviced, use the Automated Adjustments function.
2. Optimize the settings for the 2nd Bias Transfer Roll Auto Adjustment initially for new stocks, especially heavyweight and specialty media. Also, perform this adjustment when you notice problems with the way color appears. For example, mottle, which is uneven toner coverage, or color shift, which is inconsistent color.
3. Daily, and before color-critical jobs, calibrate the print server. This procedure adjusts print server color settings, and is essential to maintaining color consistency. You can use either the Full Width Array or a hand-held spectrophotometer.
4. Before you create or update destination profiles, first run the 2nd Bias Transfer Roll Auto Adjustment, then perform the Auto Density Uniformity Adjustment. Running these adjustments first ensures the best possible color from the new profiles you create.
5. For each stock type used in color workflows, create Destination Profiles. This step is critical for stocks with different coatings, gloss levels, colors or white points, and paper weights. The profiling process develops a map so that output colors on selected media accurately replicate a known standard, such as GRACoL or SWOP. Make sure that you associate each new profile with a specific stock so that it is used when the stock is selected.

## High Capacity XLS Vacuum Feeder (HCVF) Troubleshooting

For a printable flowchart of the HCVF Troubleshooting, that is described in the following section, refer to *Troubleshooting Feed Errors in the Xerox® High Capacity XLS Vacuum Feeder* in [www.xerox.com](http://www.xerox.com). In the **Customer Support > All Support and Drivers** section of the web page, search for your Product. In the **Documentation** web page of your printer, you can find the HCVF Troubleshooting flowchart.

### TROUBLESHOOTING MISFEEDS AND MULTIFEEDS IN THE HIGH CAPACITY XLS VACUUM FEEDER (HCVF)

When using the optional High Capacity XLS Vacuum Feeder (HCVF) and a misfeed or multifeed condition occurs, check the press user interface for one of the following fault codes.

| MISFEED FAULT CODES |           | MULTIFEED FAULT CODES |           |
|---------------------|-----------|-----------------------|-----------|
| • 078–101           | • 178–101 | • 077–131             | • 078–125 |
| • 078–131           | • 178–131 | • 077–132             | • 078–126 |
| • 078–132           | • 178–132 |                       | • 078–127 |
| • 078–151           | • 178–151 |                       |           |

To resolve misfeed or multifeed conditions, adjust the air assist profile. For instructions on adjusting the air assist profile, refer to [Adjusting the Air Assist Profile](#).

For information about the blower settings, refer to [Information about the HCVF Air Assist Blowers](#).

To troubleshoot misfeeds, refer to [Troubleshooting Misfeeds in the HCVF](#).

To troubleshoot multifeeds, refer to [Troubleshooting Multifeeds in the HCVF](#).

#### Information about the HCVF Air Assist Blowers

Location of the air assist blowers in the High Capacity XLS Vacuum Feeder (HCVF):

| HCVF BLOWER LOCATIONS | DESCRIPTION   |
|-----------------------|---|
|                       | <p>A: Vacuum Blower</p> <p>B: Air Knife Blower</p> <p>C: Rear Lead Blower</p> <p>D: Rear End Blower</p> <p>E: Front Blower</p> <p>F: Rear Option Blower</p> |

Before adjusting any HCVF air assist blower settings, refer to the following information.

- ⚠ Important: For all blowers, the settings do not require increasing or decreasing unless misfeed or multifeed faults are occurring.

For the Air Knife Blower, refer to the following information:

- The available settings are: **Off**, **Low**, **Mid**, or **High**.
- **Low** is the slowest speed, and **High** is the fastest speed.
- If the preset value is **Off**, the blower is not operating. Do not change the setting.

For the Rear Lead Blower and Front Blower, refer to the following information:

- The slowest speed is setting **2**. Decrease the blower speed only if the current setting is greater than **2**.
- The fastest speed is setting **13**. Increase the blower speed only if the current setting is less than **13**.
- If the preset value is **1**, the blower is not operating. Do not change the setting.



Note: Before changing a blower setting, check the current value. For example, if the current value on a blower is set at **5**, to increase the speed by two settings, change the setting to **7**.

### Adjusting the Air Assist Profile

The air assist profile controls blower settings in the HCVF. You can create a new profile or modify an existing profile. You can test changes to blower settings before you save a profile.



Note: Before you adjust the air assist profile, ensure that the media loaded in the HCVF adheres to the *Paper and Media Guidelines* for the HCVF.

For information about the blower settings, refer to [Information about the HCVF Air Assist Blowers](#).

To adjust the air assist profile, do the following:

1. At the home screen, select **Profiles**.
2. In the Profiles window, select **Air Assist**.
3. In the Air Assist area, do one of the following.
  - To create a new profile, select **New**.
  - To modify an existing air assist profile, select a named profile, then select **Edit**.
4. In the Air Assist Setup window, select **VCF Settings**.
5. In the VCF Settings window, you can adjust the settings for each blower in the HCVF. Make adjustments according to the recommended troubleshooting instructions only.
  - a. To reset blower settings to system defaults, select **Apply System Defaults**.
  - b. To test an adjustment, select **Test Print**. Before you save your changes, you can run a test print.
6. To save the profile, select **OK**.
7. To return to the home screen, close the Profiles window.

### Troubleshooting Misfeeds in the HCVF

When using the optional High Capacity XLS Vacuum Feeder (HCVF), the following fault codes indicate a misfeed condition:

- 078–101, 078–131, 078–132, 078–151.
- 178–101, 178–131, 178–132, 178–151.

For fault codes relating to multifeeds, refer to [Troubleshooting Multifeeds in the HCVF](#).

To resolve a misfeed, follow the steps in the appropriate section.



Note: Before you make any adjustments, note the current settings for the Air Knife Blower, the Rear Lead Blower, and the Front Blower. If you are instructed to change a blower setting to the preset value, use the setting that you noted.

#### Misfeeds when using paper weight 177 g/m<sup>2</sup> or heavier

When using paper of weights 177 g/m<sup>2</sup> or heavier, misfeeds can occur.

1. Make the following blower adjustments:
  - Air Knife Blower: No change.
  - Rear Lead Blower: Increase the blower speed by two settings. For example, if the blower speed is set at **5**, to increase the speed by two settings, change the setting to **7**.
  - Front Blower: Increase the blower speed by two settings.
2. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.
3. If a misfeed or multifeed occurs, for the Rear Lead Blower and Front Blower, do the following:
  - If a misfeed occurs, increase the blower speed by two settings.
  - If a multifeed occurs, decrease the blower speed by one setting.
4. Run another test print. If the problem is not resolved, contact your Xerox representative.

#### Misfeeds when using paper weight less than 177 g/m<sup>2</sup> and printing five or fewer sheets

When using paper of weights less than 177 g/m<sup>2</sup> and printing five or fewer sheets, misfeeds can occur.

1. Make the following blower adjustments:
  - Air Knife Blower: Decrease the blower speed by one setting. For example, if the current setting is **High**, change the setting to **Mid**.



Note: For the Air Knife Blower, decrease the speed only if the current setting is **High** or **Mid**.

- Rear Lead Blower and Front Blower: Do not change any settings.
2. Run a test print. If no misfeed occurs, the problem is resolved.
  3. If a misfeed occurs again, do the following:
    - Air Knife Blower: Decrease the blower speed by one setting. For example, if the current setting is **Mid**, change the setting to **Low**.



Note: For the Air Knife Blower, decrease the speed only if the current setting is **High** or **Mid**.

- Rear Lead Blower and Front Blower: Do not change any settings.
4. Run another test print. If the problem is not resolved, contact your Xerox representative.

#### Misfeeds when using paper weight less than 177 g/m<sup>2</sup> and printing more than five sheets



When using paper of weights less than 177 g/m<sup>2</sup> and printing more than five sheets, misfeeds can occur.

1. Make the following blower adjustments:
  - Air Knife Blower: No change.
  - Rear Lead Blower: Increase the blower speed by two settings. For example, if the blower speed is set at **5**, to increase the speed by two settings, change the setting to **7**.
  - Front Blower: Increase the blower speed by two settings.
2. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.
3. If a misfeed or multifeed occurs, for the Rear Lead Blower and Front Blower, do the following:
  - If a misfeed occurs, increase the blower speed by two settings.
  - If a multifeed occurs, decrease the blower speed by one setting.
4. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.
5. If a misfeed occurs again, do the following:
  - Air Knife Blower: Decrease the blower speed by one setting. For example, if the current setting is **High**, change the setting to **Mid**.



Note: For the Air Knife Blower, decrease the speed only if the current setting is **High** or **Mid**.

- Rear Lead Blower: Change the setting to the preset value.
  - Front Blower: Change the setting to the preset value.
6. Run a test print. If no misfeed occurs, the problem is resolved.
  7. If a misfeed occurs again, for the Air Knife Blower, decrease the blower speed by one setting.



Note: For the Air Knife Blower, decrease the speed only if the current setting is **High** or **Mid**.

8. Run another test print. If the problem is not resolved, contact your Xerox representative.

### Troubleshooting Multifeeds in the HCVF

When using the optional High Capacity XLS Vacuum Feeder (HCVF), the following fault codes indicate a multifeed condition:

- 077–131, 077–132.
- 078–125, 078–126, 078–127.

For fault codes relating to misfeeds, refer to [Troubleshooting Misfeeds in the HCVF](#).

To resolve a multifeed, follow the steps in the appropriate section.



Note: Before you make any adjustments, note the current settings for the Air Knife Blower, the Rear Lead Blower, and the Front Blower. If you are instructed to change a blower setting to the preset value, use the setting that you noted.

[Multifeeds when using coated paper weight 177 g/m<sup>2</sup> or heavier](#)

### Humidity levels of 50 percent or higher

When using coated paper of weight 177 g/m<sup>2</sup> or heavier in humidity levels of 50 percent or higher, multifeed problems can occur.

1. If the paper is coated on one side only, go to step 3.
2. If the paper is coated on both sides, do the following.
  - a. Make the following blower adjustments:
    - Air Knife Blower: No change.
    - Rear Lead Blower: Increase the blower speed by one setting. For example, if the blower speed is set at **5**, to increase the speed by one setting, change the setting to **6**.
    - Front Blower: Increase the blower speed by one setting.
  - b. Run a test print. If no multifeed occurs, the problem is resolved.
  - c. If a multifeed occurs again, for the Rear Lead Blower and Front Blower, increase the blower speed by one setting.
  - d. Run a test print. If no multifeed occurs, the problem is resolved.
  - e. If multifeeds continue, repeat steps 2c and 2d twice.
3. If using paper that is coated on one side only, or if multifeeds continue, do the following.
  - a. Make the following blower adjustments:
    - Air Knife Blower: No change.
    - Rear Lead Blower: Change the setting to the preset value, then decrease the speed by one setting.
    - Front Blower: Change the setting to the preset value, then decrease the speed by one setting.
  - b. Run a test print. If no multifeed occurs, the problem is resolved.
  - c. If a multifeed occurs again, for the Rear Lead Blower and Front Blower, decrease the blower speed by one setting.
  - d. Run a test print. If no multifeed occurs, the problem is resolved.
  - e. If multifeeds continue, repeat steps 3c and 3d twice.
4. If the problem is not resolved, contact your Xerox representative.

### Humidity levels below 50 percent

When using coated paper of weight 177 g/m<sup>2</sup> or heavier in humidity levels below 50 percent, multifeed problems can occur.

1. To resolve the multifeed, do the following.
  - a. Make the following blower adjustments:
    - Air Knife Blower: No change.
    - Rear Lead Blower: Decrease the blower speed by one setting. For example, if the blower speed is set at **7**, to decrease the speed by one setting, change the setting to **6**.
    - Front Blower: Decrease the blower speed by one setting.
  - b. Run a test print. If no multifeed occurs, the problem is resolved.
  - c. For the Rear Lead Blower and Front Blower, decrease the blower speed by one setting.
  - d. Run a test print. If no multifeed occurs, the problem is resolved.
  - e. If multifeeds continue, repeat steps 1c and 1d twice.
2. If multifeeds continue, do the following.
  - a. Make the following blower adjustments:
    - Air Knife Blower: Decrease the blower speed by one setting.



Note: For the Air Knife Blower, decrease the speed only if the current setting is **High** or **Mid**.

- Rear Lead Blower: Change the blower speed to the preset value, then decrease the speed by one setting.
  - Front Blower: Change the blower speed to the preset value, then decrease the speed by one setting.
- b. Run a test print. If no multifeed occurs, the problem is resolved.
  - c. If a multifeed occurs again, do the following:
    - Air Knife Blower: Decrease the blower speed by one setting.



Note: For the Air Knife Blower, decrease the speed only if the current setting is **High** or **Mid**.

- Rear Lead Blower: Decrease the blower speed by one setting.
  - Front Blower: Decrease the blower speed by one setting.
- d. Run a test print. If no multifeed occurs, the problem is resolved.
  - e. If multifeeds continue, for the Rear Lead Blower and Front Blower only, repeat steps 2c and 2d twice.
3. If the problem is not resolved, contact your Xerox representative.

### Multifeeds when using uncoated paper of weight 177 g/m<sup>2</sup> or heavier

When using uncoated paper of weight 177 g/m<sup>2</sup> or heavier, multifeed problems can occur.

1. To resolve the multifeed, make the following blower adjustments:
  - Air Knife Blower: No change.
  - Rear Lead Blower: Decrease the blower speed by three settings. For example, if the blower speed is set at **7**, to decrease the speed by three settings, change the setting to **4**.
  - Front Blower: Decrease the blower speed by three settings.
2. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.
3. If a misfeed or multifeed occurs, for the Rear Lead Blower and Front Blower, do the following:
  - If a misfeed occurs, increase the blower speed by one setting.
  - If a multifeed occurs, decrease the blower speed by one setting.
4. Run another test print. If the problem is not resolved, contact your Xerox representative.

## Multifeeds when using paper weight less than 177 g/m<sup>2</sup>

### Humidity levels of 50 percent or higher

When using paper of weight less than 177 g/m<sup>2</sup>, in humidity levels of 50 percent or higher, multifeed problems can occur.

1. To resolve the multifeed, make the following blower adjustments:
  - Air Knife Blower: No change.
  - Rear Lead Blower: Decrease the blower speed by two settings. For example, if the blower speed is set at **7**, to decrease the speed by two settings, change the setting to **5**.
  - Front Blower: Decrease the blower speed by two settings.
2. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.
3. If a misfeed or multifeed occurs, for the Rear Lead Blower and Front Blower, do the following:
  - If a misfeed occurs, increase the blower speed by one setting.
  - If a multifeed occurs, decrease the blower speed by two settings.
4. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.
5. If a multifeed occurs again, do the following.
  - a. Make the following adjustments:
    - Air Knife Blower: No change.
    - Rear Lead Blower: Change the blower speed to the preset value, then increase the speed by one setting.
    - Front Blower: Change the blower speed to the preset value, then increase the speed by one setting.
  - b. Run a test print. If no multifeed occurs, the problem is resolved.
  - c. If a multifeed occurs again, for the Rear Lead Blower and Front Blower, increase the blower speed by one setting.
  - d. Run a test print. If no multifeed occurs, the problem is resolved.
  - e. If multifeeds continue, repeat steps 5c and 5d twice.
6. If multifeeds continue, do the following:
  - Air Knife Blower: Decrease the blower speed by one setting.



Note: For the Air Knife Blower, decrease the speed only if the current setting is **High** or **Mid**.

- Rear Lead Blower: Change the blower speed to the preset value.

- Front Blower: Change the blower speed to the preset value.

7. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.

8. If a misfeed occurs, for the Air Knife Blower, decrease the blower speed by one setting.



Note: For the Air Knife Blower, decrease the speed only if the current setting is **High** or **Mid**.

9. Run another test print. If the problem is not resolved, contact your Xerox representative.

### Humidity levels below 50 percent

When using paper of weight less than 177 g/m<sup>2</sup>, in humidity levels below 50 percent, multifeed problems can occur.

1. To resolve the multifeed, make the following blower adjustments:
  - Air Knife Blower: No change.
  - Rear Lead Blower: Increase the blower speed by two settings. For example, if the blower speed is set at **5**, to increase the speed by two settings, change the setting to **7**.
  - Front Blower: Increase the blower speed by two settings.
2. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.
3. If a misfeed or multifeed occurs, for the Rear Lead Blower and Front Blower, do the following:
  - If a misfeed occurs, increase the blower speed by two settings.
  - If a multifeed occurs, decrease the blower speed by one setting.
4. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.
5. If a multifeed occurs again, do the following:
  - Air Knife Blower: Decrease the blower speed by one setting.



Note: For the Air Knife Blower, decrease the speed only if the current setting is **High** or **Mid**.

- Rear Lead Blower: Change the blower speed to the preset value.
  - Front Blower: Change the blower speed to the preset value.
6. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.
  7. If a misfeed occurs, for the Air Knife Blower, decrease the blower speed by one setting.



Note: For the Air Knife Blower, decrease the speed only if the current setting is **High** or **Mid**.

8. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.
9. If a misfeed occurs, do the following.
  - a. Make the following adjustments:
    - Air Knife Blower: Change the blower speed to the preset value.
    - Rear Lead Blower: Decrease the blower speed by one setting.
    - Front Blower: Decrease the blower speed by one setting.
  - b. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.
  - c. If a multifeed occurs again, for the Rear Lead Blower and Front Blower, decrease the blower speed by one setting.
  - d. Run a test print. If no misfeed or multifeed occurs, the problem is resolved.
  - e. If misfeeds continue, repeat steps 5c and 5d twice.
10. If the problem is not resolved, contact your Xerox representative.

## Error Information

This section provides information on the following:

- [Module Fault Messages](#)
- [Fault Codes](#)

### MODULE FAULT MESSAGES

When a fault occurs, such as a jam, open doors or covers, or a Production Press malfunction, the Production Press stops printing, and a message appears on the Production Press User Interface screen. An illustration shows the location of the fault with a brief explanation of corrective actions for clearing the fault. If a fault occurs in more than one location, the illustration changes to indicate the multiple locations and the required corrective actions.

The User Interface screen also displays a **Faults** button, which provides information about the fault and detailed instructions for correcting the fault. The **E** code on the upper-left part of the Fault message displays which error indicator is lit on the Inserter control panel – E1, E2, E3.



Note: For information about faults and fault messages, refer to the [General Troubleshooting](#) section.

### FAULT CODES

If printing ends abnormally or a malfunction occurs in the Production Press, a fault appears in the Active Status List. The Active Status List shows the priority of the fault, the module in which the fault occurred, and a brief description of the issue.

The fault priority code indicates the following:

1. The Production Press is not operating, you can expect the current job to still print, future jobs do not necessarily print.
2. Current job still prints, loss of functionality occurred.
3. Indicates a Note.

To open a dialog that provides the following information, double-click an individual fault listing:

- Steps to clear the fault
- Primary fault code, if relevant
- List of related fault, or service, codes

If you need to call for service, use these codes.

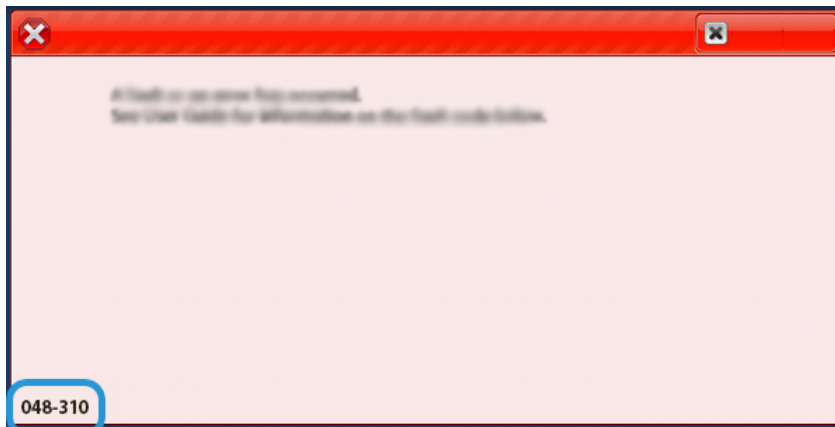
### Interface Decurler Module Fault Code Information

When a fault occurs, such as a jam, open doors or covers, or a Production Press malfunction, the Production Press stops printing, and a message appears on the Production Press User Interface screen.

The User Interface screen also displays a **Faults** button, which provides information about the fault and detailed instructions for correcting the fault.



 Tip: You can identify Interface Decurler Module faults by their codes, which start with the three-digit number 048.

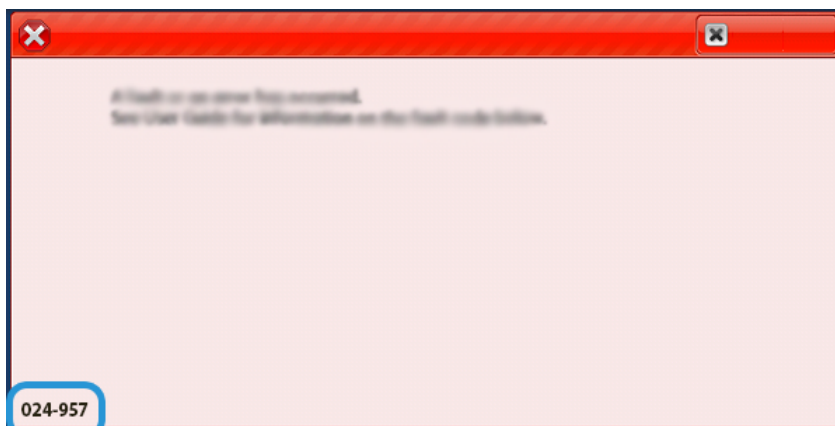


### Inserter Fault Code Information

When a fault occurs, such as a jam, open doors or covers, or a Production Press malfunction, the Production Press stops printing, and a message appears on the Production Press User Interface screen.

The User Interface screen also displays a **Faults** button, which provides information about the fault and detailed instructions for correcting the fault.


 Tip: You can identify Inserter faults by their codes, which start with the three-digit numbers 012, 013 and 024.

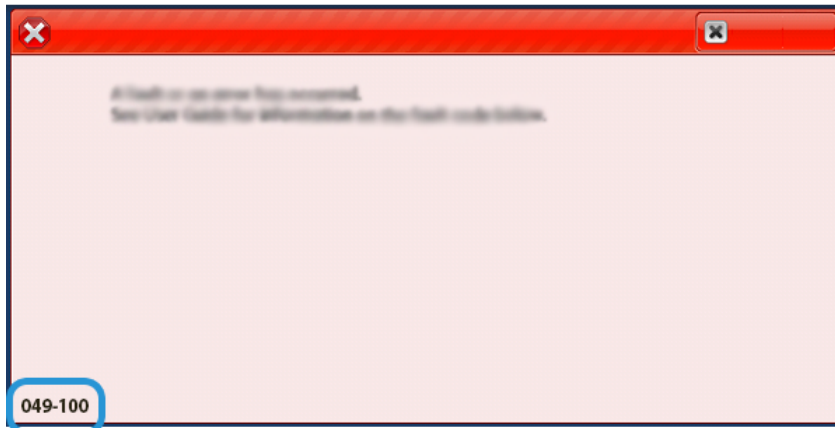


### High Capacity Stacker Fault Code Information

When a fault occurs, such as a jam, open doors or covers, or a Production Press malfunction, the Production Press stops printing, and a message appears on the Production Press User Interface screen.

The User Interface screen also displays a **Faults** button, which provides information about the fault and detailed instructions for correcting the fault.


 Tip: You can identify High Capacity Stacker faults by their codes, which start with the three-digit numbers 049.

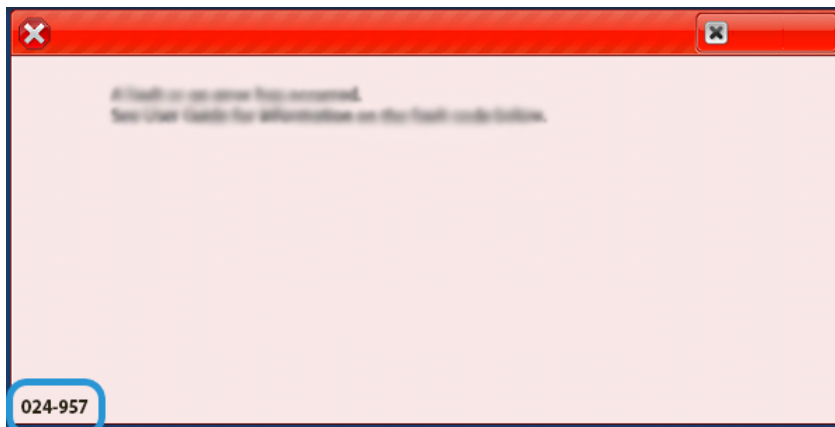


### Crease and Two-Sided Trimmer Fault Code Information

When a fault occurs, such as a jam, open doors or covers, or a Production Press malfunction, the Production Press stops printing, and a message appears on the Production Press User Interface screen.

The User Interface screen also displays a **Faults** button, which provides information about the fault and detailed instructions for correcting the fault.


 Tip: You can identify Crease and Two-Sided Trimmer faults by their codes, which start with the three-digit numbers 012, 013, 014, 024, and 028.

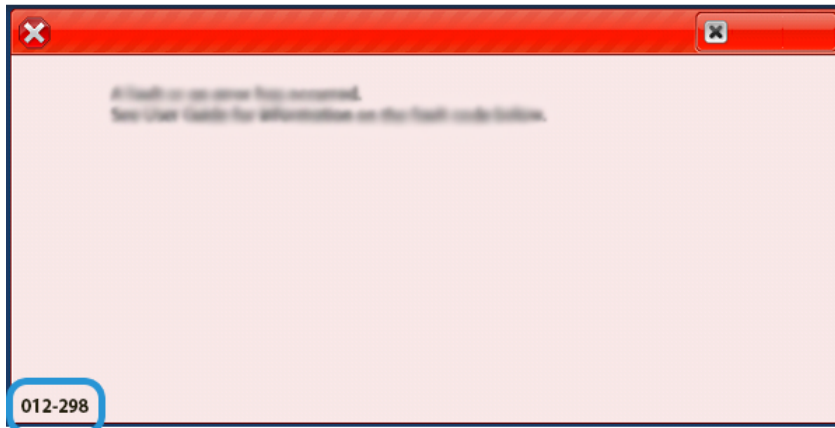


### C/Z Folder Fault Code Information

When a fault occurs, such as a jam, open doors or covers, or a Production Press malfunction, the Production Press stops printing, and a message appears on the Production Press User Interface screen.

The User Interface screen also displays a **Faults** button, which provides information about the fault and detailed instructions for correcting the fault.


 Tip: You can identify C/Z Folder faults by their codes, which start with the three-digit numbers 012 and 013.

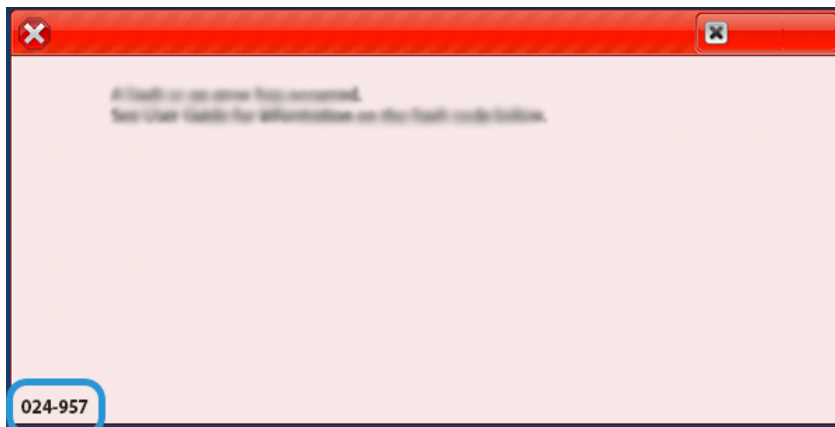


### Finisher Fault Code Information

When a fault occurs, such as a jam, open doors or covers, or a Production Press malfunction, the Production Press stops printing, and a message appears on the Production Press User Interface screen.

The User Interface screen also displays a Faults button, which provides information about the fault and detailed instructions for correcting the fault.


 Tip: You can identify Finisher faults by their codes, which start with the three-digit numbers 012, 013, 024, 041, 112, and 124.

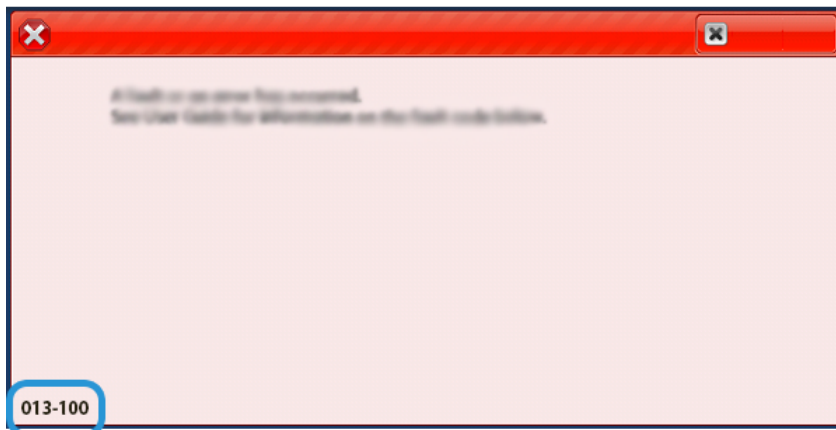


### SquareFold® Trimmer Fault Code Information

When a fault occurs, such as a jam, open doors or covers, or a Production Press malfunction, the Production Press stops printing, and a message appears on the Production Press User Interface screen.

The User Interface screen also displays a Faults button, which provides information about the fault and detailed instructions for correcting the fault.


 Tip: You can identify SquareFold® Trimmer faults by their codes, which start with the three-digit number 013.

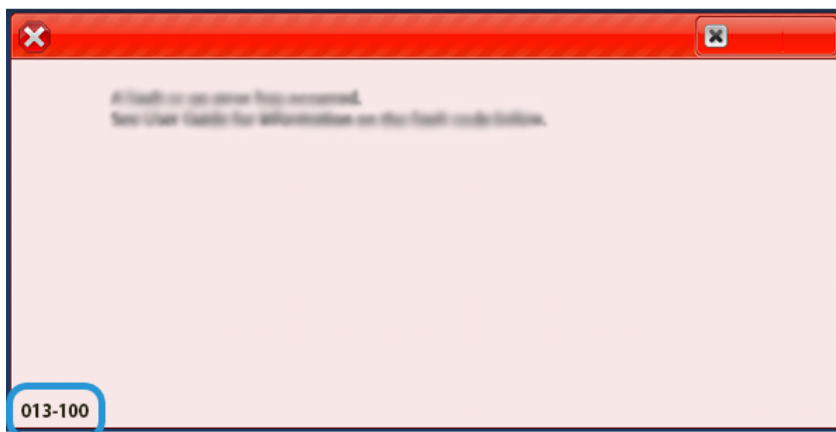


### Production Ready Finisher Plus Fault Code Information

When a fault occurs, such as a jam, open doors or covers, or a Production Press malfunction, the Production Press stops printing, and a message appears on the Production Press User Interface screen.

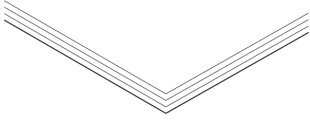
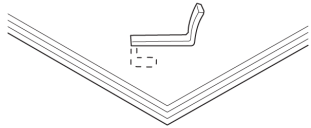
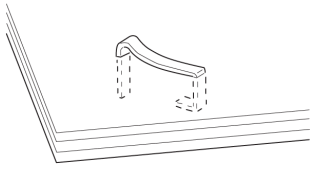
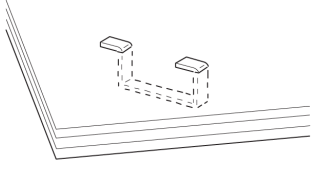
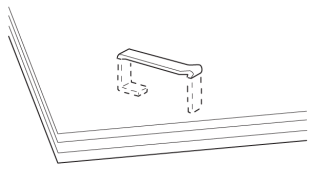
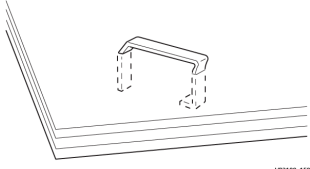
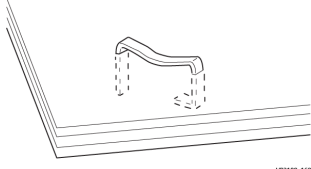
The User Interface screen also displays a Faults button, which provides information about the fault and detailed instructions for correcting the fault.

 Tip: You can identify Production Ready Finisher Plus faults by their three-digit codes, which start with the numbers 013 and 051.



### Finisher Staple Faults

When stapling issues occur with the printed output, such as the sheets are not stapled or staples are bent, use the following procedures. If the problems continue after you have tried the following solutions, contact the service representative.


|   |   |   |
|---|---|---|
| <p>Not stapled</p>  <p>VP3100_154</p>                  | <p>Bent staple</p>  <p>VP3100_155</p>                                  |   |
| <p>If printed sheets are stapled as shown in the following figures, contact your service representative.</p>                            |   |   |
| <p>One side of staple raised up</p>  <p>VP3100_157</p> | <p>Staple bent in reverse direction</p>  <p>VP3100_156</p>             | <p>Flattened staple</p>  <p>VP3100_158</p> |
| <p>Entire staple raised up</p>  <p>VP3100_159</p>     | <p>Staple raised up with center pressed inward</p>  <p>VP3100_160</p> |   |

 Important:

- Depending on the type of paper being stapled, the staple nails can be bent. If the bent nails are stuck inside the finisher, they eventually can cause paper jams.
- When you open the cover of the staple cartridge, remove any bent staples. Otherwise, staple jams can occur. Use the cover of the staple cartridge only when removing jammed staples.

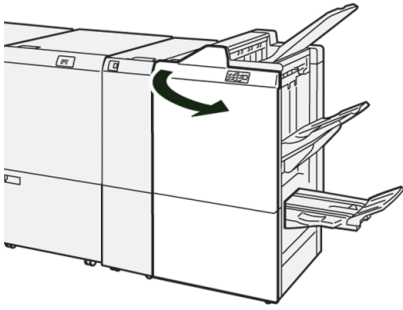
**Clearing Staple Jams in the Basic Stapler**

 Note: If the staple cartridge accidentally detaches from its holder, refer to [Reinserting the Basic Staple Cartridge](#).

 Note: Before you perform this procedure, ensure that the Production Press is not running.

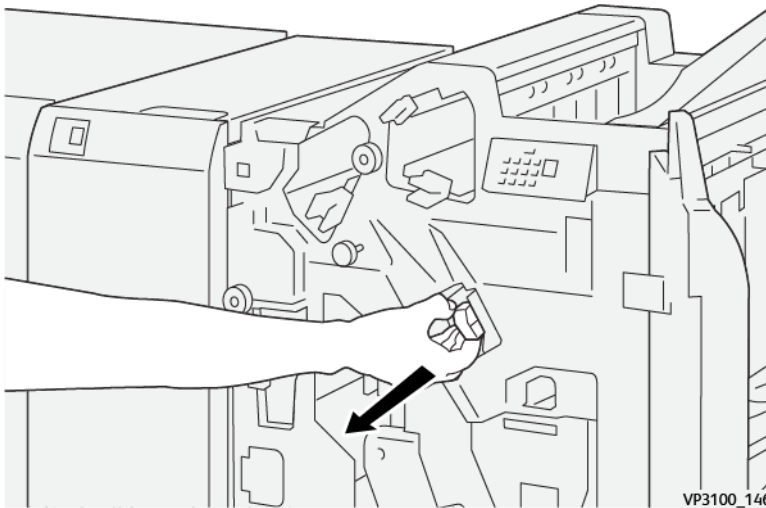
## Troubleshooting

1. Open the finisher front cover.




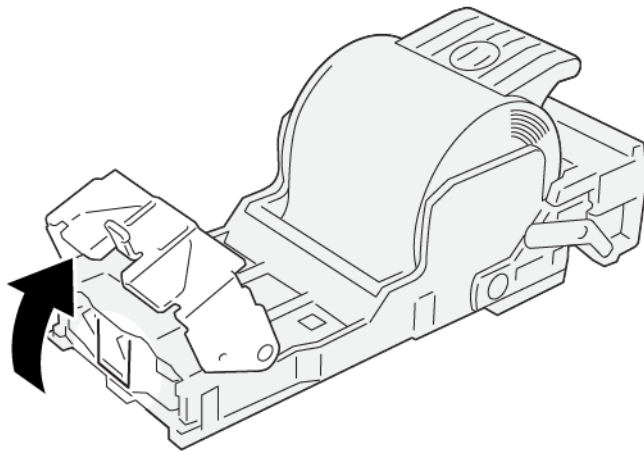
2. Pull out **R1**.

 Note: After you remove the staple cartridge, check the inside the finisher for any remaining staples.



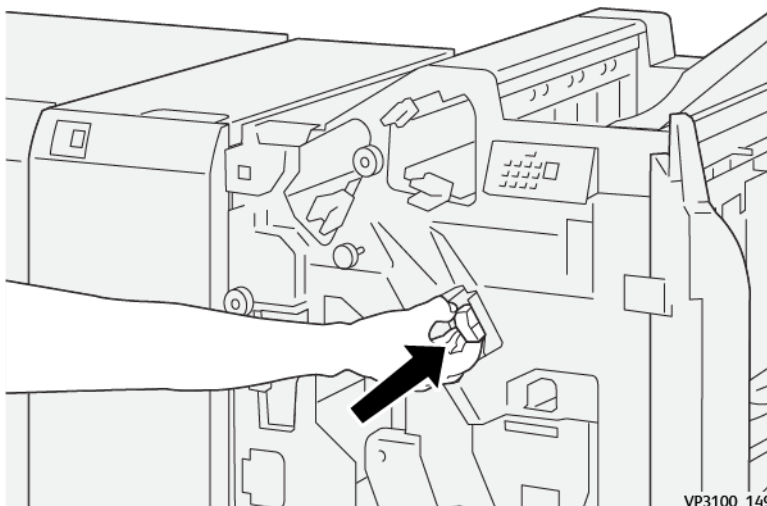
3. Open the unit cover, and remove the jammed staples.

 **WARNING:** To avoid personal injury, use care when you remove jammed staples.



VP3100\_161

4. Reinsert the unit to its original position.

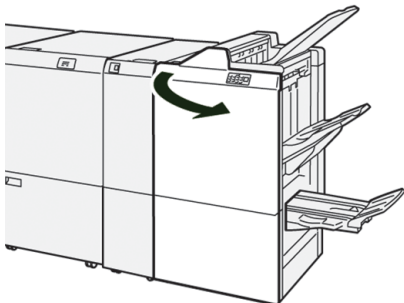


5. Close the finisher front cover.

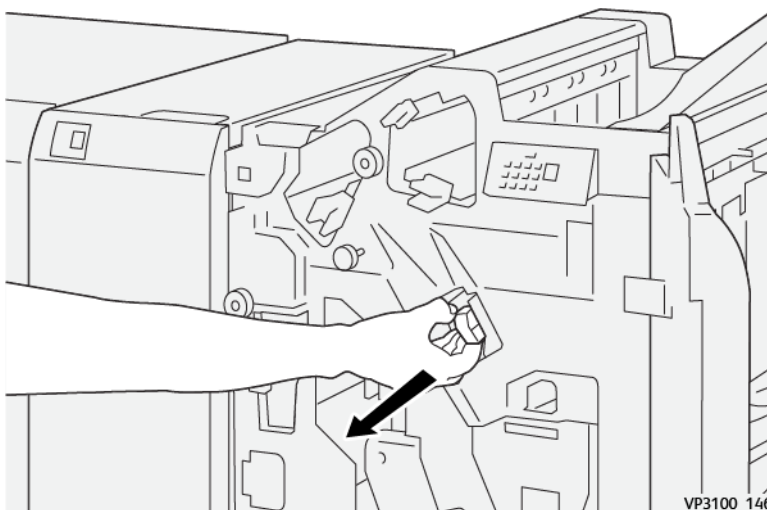
### Reinserting the Basic Staple Cartridge

If a staple cartridge was inserted incorrectly or accidentally removed, to reinsert the staple cartridge into the cartridge unit correctly, perform the following procedure.


1. Open the finisher front cover.

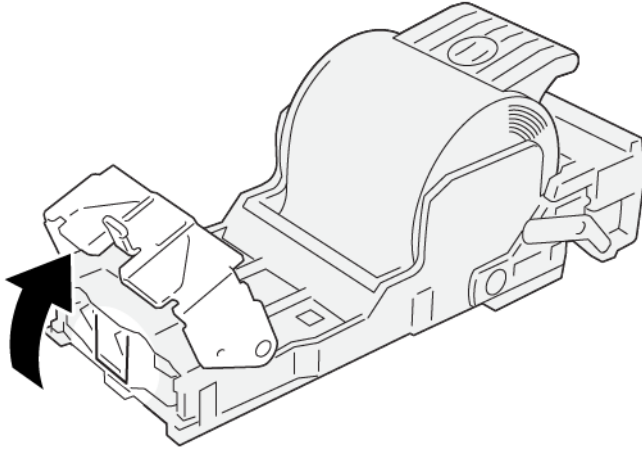


2. Pull out R1.




3. Open the unit cover, then remove the jammed staples.

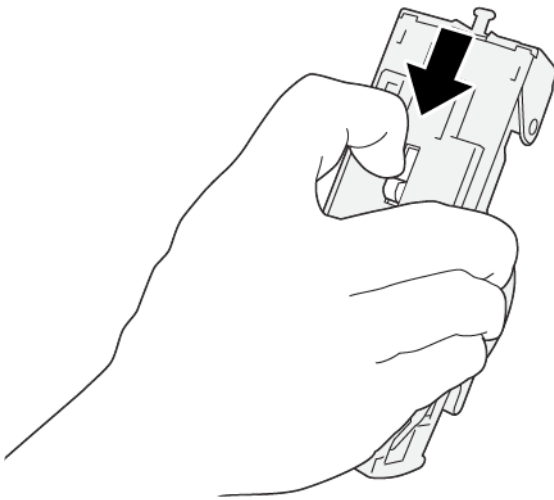
 **WARNING:** To avoid personal injury, use care when removing jammed staples.



VP3100\_161

4. On the back of the unit, locate the lever.

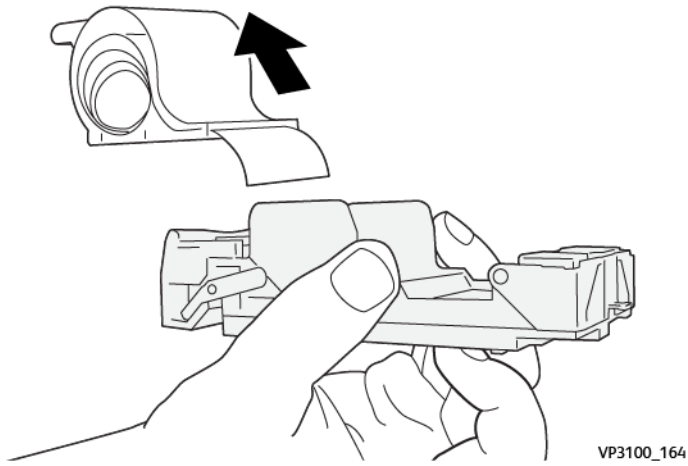
 **WARNING:** When you move the lever, be careful not to hurt your fingers and nails.



VP3100\_163

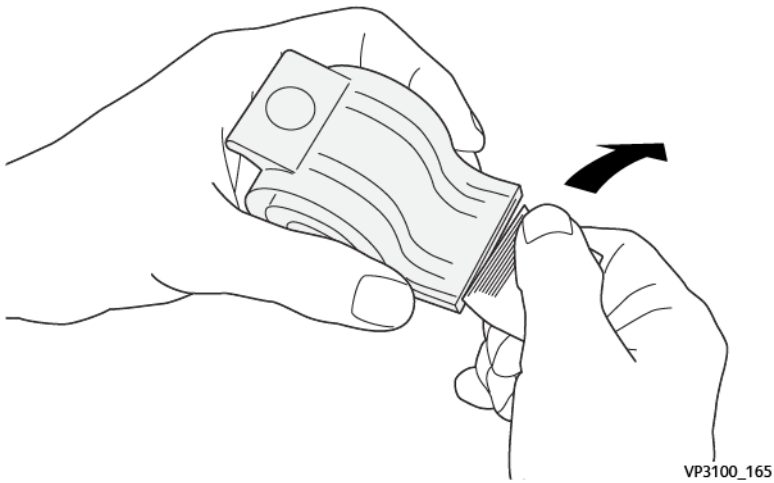


5. While holding the lever, turn up the unit, then take out the staple cartridge from the unit.

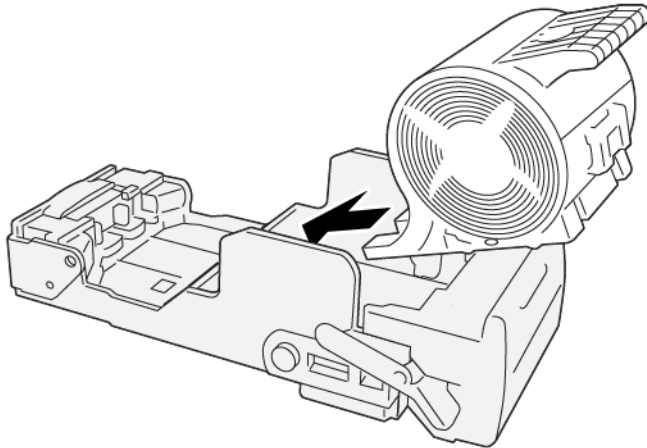


6. Remove the outside staples along the line.

**⚠ WARNING:** When you remove staples, be careful not to hurt your fingers.

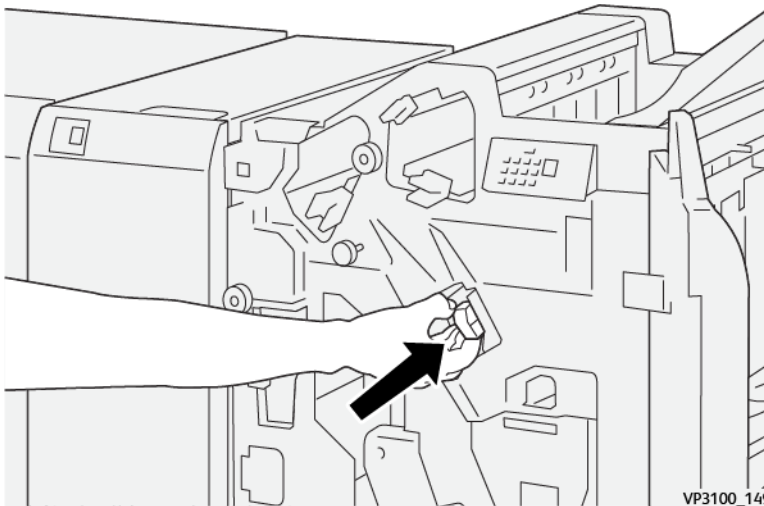


7. Insert the staple cartridge into the unit.



VP3100\_166


8. Reinsert the unit to its original position.



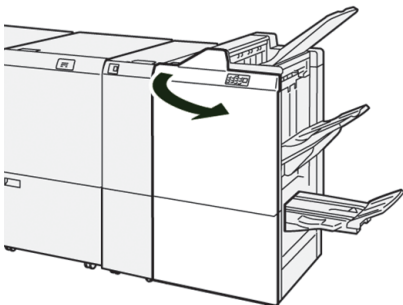
VP3100\_149

9. Close the finisher front cover.

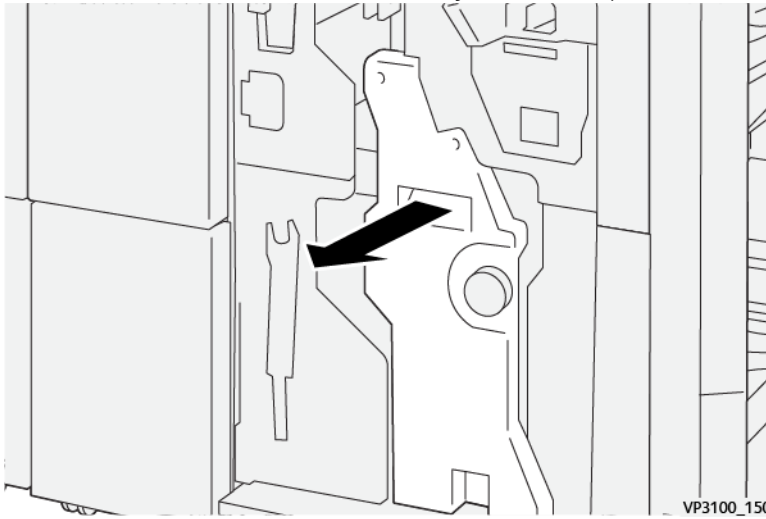
#### Clearing Staple Jams in the Booklet Stapler

 Note: Before you perform this procedure, ensure that the Production Press is not running.

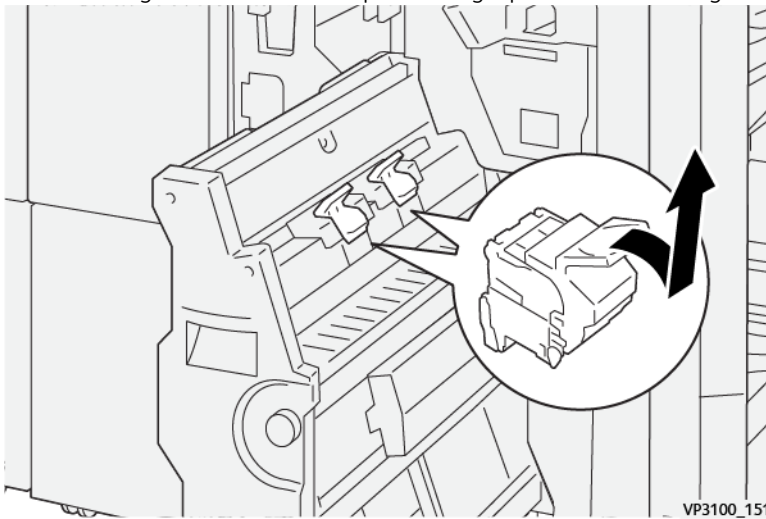
1. Open the finisher front cover.



2. Pull out the **Saddle Stitch Unit 3** toward you until it stops.



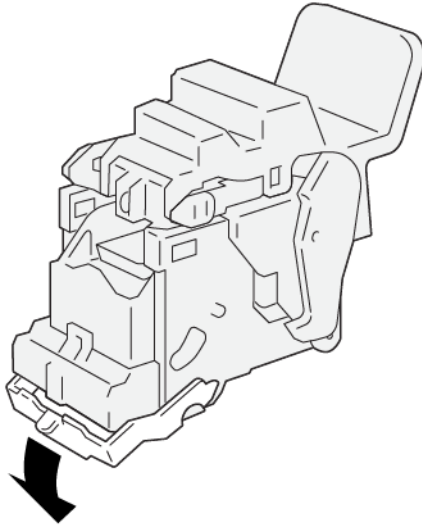
3. While holding the tabs on the staple cartridge, pull out the cartridge to remove it.



4. Remove any jammed staples.



**WARNING:** To avoid personal injury, use care when you remove jammed staples.

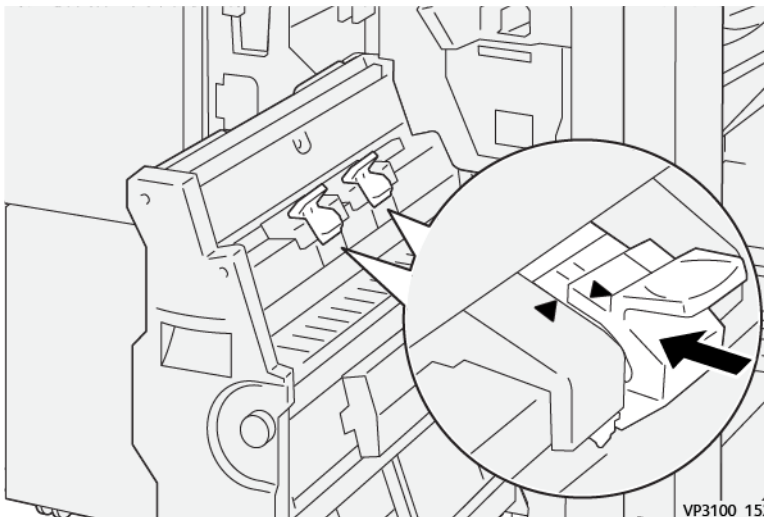


VP3100\_162

5. While holding the tabs on the new staple cartridge, push in the cartridge until it seats.

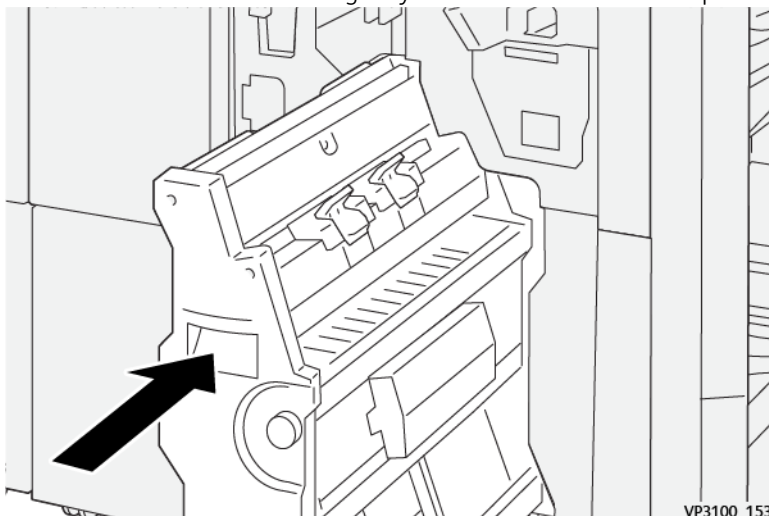


Note: Make sure that the marks are aligned.



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6. Push the **Saddle Stitch Unit 3** gently into the finisher until it stops.



7. Close the finisher front cover.

#### **Stapler Faults in the Production Ready Finisher Plus**

For clearing staple jams in the basic staple cartridge of the Production Ready Finisher Plus, refer to the following procedures:

- [Clearing Staple Jams in the Basic Stapler](#)
- [Reinserting the Basic Staple Cartridge](#)
- [Clearing Staple Jams in the Booklet Stapler](#)



# For Administrators

This chapter contains:

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This section provides links to topics specifically for administrators.

## Administration

The Administrator mode allows you to set the default settings for your Production Press to fit your individual requirements. You can change the settings for a variety of features, such as the language displayed on the Control Center, timers, the Administrator password, creating custom paper and alignment profiles, and more.



## Administrator Overview

When you are logged on as Administrator:

- The Administration menu option displays a window on which you can edit or change a wide range of system settings.
- Additionally, the main screen displays the Maintenance option. Using this function, you can run a quick routine to clean the Charge Corotrons and Dry Ink Dispensers.
- The PredictPrint Media Manager or the Manage Stock Library menu option on the main Control Center screen is always available to Administrators, but can be restricted for Operators. When you select Restrict Casual User Interface, on the User Interface tab, you can remove access to the main Stock Library function for regular users. When this option is selected, the PredictPrint Media Manager or Manage Stock Library menu option disappears from the main screen. When Allow Casual User Access is selected on the User Interface tab, the PredictPrint Media Manager or Manage Stock Library option displays on the main screen.



Note: Based on the software version installed, either the PredictPrint Media Manager option or the Manage Stock Library option appears on the user interface.

### LOGGING ON AS ADMINISTRATOR

1. From the Control Center, click **Log In**.
2. From the Login screen, select **Administrator**.
3. Type the Administrator password.  
The default password is five ones – 11111.



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

4. Click **OK**.



Note: To prevent unauthorized access to the Administrator mode, after installing the Production Press, change the Administrator password as soon as possible.

5. To exit the Administrator mode, click **Log Out**.


## Administration Tab

The Administration menu option displays a window with System Settings. It allows you to change or edit a wide range of System Settings operations.

### SYSTEM SETTINGS

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

- User Interface
- Stock Wizard or PredictPrint Settings (available only on Fiery® Print Server version 4.0, FS600 or newer version)
- System
- Tray Options
- Output Devices
- Image Quality
- Full Width Array

 Important: On Fiery® Print Server version 4.0, FS600, or Press software 6.2.11 and newer version, the **Stock Wizard** tab is changed to **PredictPrint Settings** tab. To find your print server version or Fiery System version, on the Fiery Command WorkStation window, go to **Server > Device Center > GENERAL > General Info**, then refer to **Fiery Server** or **Fiery System**. This information is accessible also on the Fiery configuration page, printed through Fiery® Print Server.

### User Interface Tab Settings

The User Interface tab allows you to make changes to the following:

- Fault Details Window
- Manage Stock Library Window
- Default Language
- Change Password for Administrator
- Technical Key Operator Password
- Billing Impression Mode accessible to Xerox representative only

### Fault Details Window

By default, the Control Center automatically opens a Details window that provides additional information about the alert, warning, or fault.

You can select to open this window automatically or to open only when the user clicks the alert, warning, or fault message in the Production Press mimic and message area.

### Setting the Fault Details Window Behavior

Use the following procedure to choose the default setting for the Fault Details window.


1. From the Control Center, click **Log In** and log in as the Administrator.

2. Select **Administration**.
3. From System Settings window, select the **User Interface** tab.
4. Select if you want any press faults to appear automatically on the Control Center when they occur.
  - **Do Not Display Automatically:** If you do not want the fault Details window to open automatically when an alert, warning, or fault occurs, select this option.
  - **Display Automatically:** If you do want the fault Details window to open automatically when an alert, warning, or fault occurs, select this option.
5. To save the setting and close the System Settings window, select **OK**.

### Managing Access to the Stock Library

The administrator can specify whether the Stock Library is accessible to users logged in as Operator. By default, the Stock Library tab appears on the main screen for all users. The Administrator can choose to hide the Stock Library tab for users that are not logged in as Administrator.

To restrict access to the Stock Library:

1. From the Control Center, click **Log In**, then log in as the Administrator.
  2. Click **Administration**.
  3. On the System Settings window, click **User Interface**.
  4. For Manage Stock Library Window, select an option:
    - **Allow Casual User Access:** This option is the default setting. When this option is selected, all users have access to the Stock Library. Additionally, the PredictPrint Stock Library tab or the Manage Stock Library tab appears on the main Control Center window.
-  Note: Based on the software version installed on your press, either the PredictPrint Stock Library tab or the Manage Stock Library tab appears.
- **Restrict Casual User Access:** When this option is selected, the PredictPrint Stock Library tab or the Manage Stock Library tab does not appear on the main screen for the Operator. Access to the Stock Library is available only when the Administrator is logged in.
5. To save your changes and close the System Settings window, click **OK**.
  6. To exit the Administrator mode, click **User: Administrator**, then click **Log Out**.

### Default Language

To set the default for the appropriate language shown on the Control Center, use the Default Language feature. Available language settings depend on the language file installed on the Control Center.

 Note: Languages that are not installed on the Control Center cannot be selected through the Default Language settings feature.

The language files loaded on your Control Center vary from marketplace to marketplace. To change or set the default language for your Production Press, use the following procedure:

1. From the Control Center, click **Log In** and log in as the Administrator.
2. Select **Administration**.
3. From the System Settings window, select **User Interface**.

For Administrators

4. From the Default Language menu, select the default language.
5. To save your changes, then close the System Settings window, select **OK**.
6. To exit the Administrator mode, click **Log Out**.

### Changing the Administrator Password

The Production Press arrives from the factory with a default Administrator password of five ones – 11111. Use this default password to log in the first time. To maintain security, after the initial login, change the Administrator password.

1. From the Control Center, click **Log In** and log in as the Administrator.
2. Select **Administration**.
3. From System Settings window, select the **User Interface** tab, then **Change Password**.



Tip: Use numbers only for creating your password. Alpha characters – letters and other characters, such as !\* & – are not allowed. A maximum of 12 numbers can be entered for your password.

4. From the Change Password window, enter:
  - a. The old, or current, password.
  - b. The new password.
  - c. In the **Confirm New Password** area, reenter the new password.
  - d. Click **OK**.



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

### Technical Key Operator Password

If the Technical Key Operator (TKO) password is lost or forgotten, the system administrator can reset it on the User Interface tab.

1. Log in as Administrator.
2. Select **Administration**.
3. From the System Settings window, select **User Interface**.
4. For Technical Key Operator Password, select **Reset to Default**.
5. On the confirmation dialog, to reset the TKO password, click **Yes**.
6. To save the changes and close the window, click **OK**.
7. To exit Administrator mode, click **Log Out**.

### Stock Wizard or PredictPrint Settings Tab



Important: On Fiery® Print Server version 4.0, FS600, or Press software 6.2.11 and newer version, the **Stock Wizard** tab is changed to **PredictPrint Settings** tab. To find your print server version or Fiery System version, on the Fiery Command WorkStation window, go to **Server > Device Center > GENERAL > General Info**, then refer to **Fiery Server** or **Fiery System**. This information is accessible also on the Fiery configuration page, printed through Fiery® Print Server.


On the Stock Wizard or PredictPrint Settings tab, you can adjust the following settings:

- Show or hide the **PredictPrint Stock Wizard** on the Control Center screen
- Guided stock setup
  - Paper calibration and profiling
  - Group adjustments by (available only on Fiery® Print Server version 4.0, FS600 or newer version)
  - Alignment profile setup
  - Secondary transfer voltage setup
  - Other routines
- Custom stock name
- Private stock sharing
- Stock wizard timeout
- Load PredictPrint database from device
- Automatic Image Quality System Check (available only on Fiery® Print Server version 4.0, FS600 or newer version)
  - Auto Alignment + 2nd Bias Transfer Roll + Auto Density Uniformity
  - Auto Color Check

#### Managing Access to the PredictPrint Stock Wizard

The administrator can specify whether the **PredictPrint Stock Wizard** button appears on the main Control Center screen. By default, the **PredictPrint Stock Wizard** button always appears on the main screen. The administrator can choose to restrict access to the **PredictPrint Stock Wizard**. When access is restricted, the **PredictPrint Stock Wizard** button does not appear on the main screen.

1. On the upper right corner of the main screen, click **Log In**, then log in as the Administrator.
2. Click **Administration**.
3. From the System Settings screen, select the **Stock Wizard** or **PredictPrint Settings** tab.

 Important: On Fiery® Print Server version 4.0, FS600, or Press software 6.2.11 and newer version, the **Stock Wizard** tab is changed to **PredictPrint Settings** tab. To find your print server version or Fiery System version, on the Fiery Command WorkStation window, go to **Server > Device Center > GENERAL > General Info**, then refer to **Fiery Server** or **Fiery System**. This information is accessible also on the Fiery configuration page, printed through Fiery® Print Server.

4. To show or hide the **PredictPrint Stock Wizard** icon on the main screen, for the Stock Wizard option, click the **On/Off** toggle button.

The toggle button changes color and a label indicates whether the PredictPrint Stock Wizard is On or Off.

5. To save your changes and close the System Settings screen, click **OK**.
6. To exit the Administrator mode, click **User: Administrator**, then click **Log Out**.

## Guided Stock Setup


By default, when you scan and load a stock, the PredictPrint Cloud Server guides you through recommended setup routines for the stock. You can choose to disable guided stock setup completely, or you can choose to disable the following elements of guided stock setup:

- Paper calibration and profiling
- Group adjustments by (available only on Fiery® Print Server version 4.0, FS600 or newer version)
- Alignment profile setup
- Secondary transfer voltage setup
- Other routines

1. On the Control Center, click **Log In**, then log in as the Administrator.

2. Click **Administration**.

3. From the System Settings screen, select the **Stock Wizard** or **PredictPrint Settings** tab.

 Important: On Fiery® Print Server version 4.0, FS600, or Press software 6.2.11 and newer version, the **Stock Wizard** tab is changed to **PredictPrint Settings** tab. To find your print server version or Fiery System version, on the Fiery Command WorkStation window, go to **Server > Device Center > GENERAL > General Info**, then refer to **Fiery Server** or **Fiery System**. This information is accessible also on the Fiery configuration page, printed through Fiery® Print Server.

4. Select options as needed:

- To enable or disable all elements of guided stock setup, for Guided stock setup, select the **On/Off** toggle button.
- To enable or disable automatic setup for paper calibration and profiling, for Paper calibration and profiling, select the **On/Off** toggle button.

Group adjustments by: This feature under Paper calibration and profiling is available only for the Fiery® Print Server version 4.0, FS600. Stocks with certain parameters are grouped together to use a single profile. Stock grouping saves the paper used in Calibration and Profiling routines. Following options are available for stock grouping:

- **Media Name:** Select this option to share profile for the stocks with same media name. Media name of the stock is pre-defined, user cannot change it.
- **Coating:** Select this option to share the profile for stocks with same coating type. This is the default option.
- **Individual Stocks:** Select this option to create dedicated profile for each stock.
- For Alignment profile setup, select a setup option: **Basic (set up once)**, **Advanced (multiple profile)**. To disable automatic alignment profile setup, select **Off**.
- To enable or disable automatic setup for secondary transfer voltage, for Secondary transfer voltage setup, select the **On/Off** toggle button.
- To enable or disable automatic setup for other routines, for Other routines, select the **On/Off** toggle button.


5. To save your changes and close the System Settings screen, click **OK**.

6. To exit the Administrator mode, click **User: Administrator**, then click **Log Out**.

### Custom Stock Name

To restrict the operator from adding a custom name for a scanned stock:

1. From the Control Center, click **Log In** and log in as the Administrator.
2. Click **Administration**.
3. From the System Settings screen, select the **Stock Wizard** or **PredictPrint Settings** tab.


 Important: On Fiery® Print Server version 4.0, FS600, or Press software 6.2.11 and newer version, the **Stock Wizard** tab is changed to **PredictPrint Settings** tab. To find your print server version or Fiery System version, on the Fiery Command WorkStation window, go to **Server > Device Center > GENERAL > General Info**, then refer to **Fiery Server** or **Fiery System**. This information is accessible also on the Fiery configuration page, printed through Fiery® Print Server.

4. For Custom stock name, select the **On/Off** toggle button.
5. To save your changes and close the System Settings screen, click **OK**.
6. To exit the Administrator mode, click **User: Administrator**, then click **Log Out**.

### Private Stock Sharing

You can create a unique, minimum 4-digit code that all locations in your company can use to share custom stocks and their barcodes.

1. On the Control Center, click **Log In**, then log in as the Administrator.
2. Click **Administration**.
3. From the System Settings screen, select the **Stock Wizard** or **PredictPrint Settings** tab.

 Important: On Fiery® Print Server version 4.0, FS600, or Press software 6.2.11 and newer version, the **Stock Wizard** tab is changed to **PredictPrint Settings** tab. To find your print server version or Fiery System version, on the Fiery Command WorkStation window, go to **Server > Device Center > GENERAL > General Info**, then refer to **Fiery Server** or **Fiery System**. This information is accessible also on the Fiery configuration page, printed through Fiery® Print Server.


4. To enable or disable private stock sharing, for Private stock sharing, select the **On/Off** toggle button. If you enabled private stock sharing, type a sharing code that has at least four digits.
5. To save your changes and close the System Settings screen, click **OK**.
6. To exit the Administrator mode, click **User: Administrator**, then click **Log Out**.

### Stock Wizard Timeout

After you open the PredictPrint Stock Wizard or open a tray, if you do not scan a stock, after a set time period, the Stock Wizard window closes. The default time period is 1 minute. The Administrator can change the amount of time that the Stock Wizard appears on the screen before it closes.

1. On the Control Center, click **Log In**, then log in as the Administrator.
2. Click **Administration**.

3. From the System Settings screen, select the **Stock Wizard** or **PredictPrint Settings** tab.

 Important: On Fiery® Print Server version 4.0, FS600, or Press software 6.2.11 and newer version, the **Stock Wizard** tab is changed to **PredictPrint Settings** tab. To find your print server version or Fiery System version, on the Fiery Command WorkStation window, go to **Server > Device Center > GENERAL > General Info**, then refer to **Fiery Server** or **Fiery System**. This information is accessible also on the Fiery configuration page, printed through Fiery® Print Server.


4. For Stock wizard timeout, select a timeout option:
  - **10 seconds**
  - **20 seconds**
  - **30 seconds**
  - **1 minute**
  - **2 minutes**
  - **5 minutes**
5. To save your changes and close the System Settings screen, click **OK**.
6. To exit the Administrator mode, click **User: Administrator**, then click **Log Out**.

#### Load PredictPrint Database from Device

When the press is not connected to the Internet, you can load the stock lists into the Stock Library manually.

This procedure requires that you have copied the database from the PredictPrint Cloud Server onto a USB flash drive. For details, refer to [Downloading a Stock List](#).

1. Insert the USB flash drive that contains one or more downloaded stock lists into a USB port on the press.
2. From the Control Center, click **Log In**, then log in as the Administrator.
3. Click **Administration**.
4. From the System Settings screen, select the **Stock Wizard** or **PredictPrint Settings** tab.

 Important: On Fiery® Print Server version 4.0, FS600, or Press software 6.2.11 and newer version, the **Stock Wizard** tab is changed to **PredictPrint Settings** tab. To find your print server version or Fiery System version, on the Fiery Command WorkStation window, go to **Server > Device Center > GENERAL > General Info**, then refer to **Fiery Server** or **Fiery System**. This information is accessible also on the Fiery configuration page, printed through Fiery® Print Server.

5. Click **Load database from device**.
6. In the Open window, locate and select the stock list .xml file to be loaded to the Stock Library.
7. Click **Open**.

The stock list file name appears on the Stock Wizard or PredictPrint Settings tab in the PredictPrint database area.

8. Click **OK**. If you are prompted to overwrite the existing database, click **Yes**. To cancel loading the database file, click **No**.
9. To exit the Administrator mode, click **User: Administrator**, then click **Log Out**.



## Automatic Image Quality System Check

The Automatic Image Quality System Check feature is available only with Fiery® Print Server version 4.0, FS600, and have unique features that are not available on older Fiery Print Servers. As an administrator, you can set up the following Image Quality checks through PredictPrint Settings tab:

- **Auto Alignment + 2nd Bias Transfer Roll + Auto Density Uniformity:** You can enable or disable Image Quality checks for Auto Alignment, 2nd Bias Transfer Roll, and Auto Density Uniformity from PredictPrint Settings. For detailed information about these checks, refer to [Calibrating the Production Press](#).
  - **Auto Color Check:** In Auto Color Check, the print server evaluates if the prior calibration and profiling associated with the PredictPrint stock remains within tolerance level. If the Calibration is out of tolerance level, the stock or group will be recalibrated when the stock or any stock linked to the same group is reloaded the next time.
1. On the Control Center, click **Log In**, then log in as the Administrator.
  2. Click **Administration**.
  3. From the System Settings screen, select the **PredictPrint Settings** tab.
    - ⓘ Important: On Fiery® Print Server version 4.0, FS600, or Press software 6.2.11 and newer version, the **Stock Wizard** tab is changed to **PredictPrint Settings** tab. To find your print server version or Fiery System version, on the Fiery Command WorkStation window, go to **Server > Device Center > GENERAL > General Info**, then refer to **Fiery Server** or **Fiery System**. This information is accessible also on the Fiery configuration page, printed through Fiery® Print Server.
  4. For Automatic Image Quality System Check, enable or disable the following settings:
    - To enable or disable Image Quality checks for Auto Alignment + 2nd Bias Transfer Roll + Auto Density Uniformity, select the **On/Off** toggle button.
    - To enable or disable Auto Color Check, select the **On/Off** toggle button.
    - ⓘ Important: When the above image quality checks are enabled in the **Administration** tab, you can access the feature from the main Control Central screen. To perform **Run Image Quality System Check**, right-click on a tray loaded with a stock registered with PredictPrint Stock Wizard. For more information, refer to [Calibrating the Production Press](#).
  5. To save your changes and close the System Settings screen, click **OK**.
  6. To exit the Administrator mode, click **User: Administrator**, then click **Log Out**.

## System Tab Options

Use the System tab to change the factory default settings for:

- Fuser Performance Priority
- Paper Type Mode
- Transparency Productivity
- Embossed Paper Productivity
- Inserter Productivity
- Lower Power Standby
- Power Saver Start wait times and Exit modes

For Administrators

- NVM Read/Write settings
- Stock by Name Only use
- Auto Resume behavior after a Fault or Pause
- Auto Logoff Timeframes
- Access the Sound settings
- Date and Time settings

### Productivity Modes

When printing transparencies or embossed papers, this setting enables you to place priority on the speed of printing or place greater focus on image quality. Set the priority to either productivity or image quality mode.

#### Transparency Productivity

When you run transparencies, the Productivity setting instructs the Production Press to make fewer fuser and image quality adjustments, which saves time.

#### Embossed Paper Productivity

When you run embossed paper, the Productivity setting instructs the Production Press to make fewer fuser and image quality adjustments, which saves time.

#### Fuser Performance Priority

Use this setting to adjust the image quality of toner on the paper by changing the paper transport speed in the fuser. Use the Normal setting for most stocks. Use the Low setting for heavy textured or linen stocks. Also, use Low to achieve a higher gloss level.

### Selecting the Productivity Mode Options

1. Click **Log In** from the Control Center and log in as the Administrator.
2. Select the **Administration** button.
3. From System Settings window, select the **System** tab.
4. Select the desired Productivity Mode settings including Fuser Performance Priority, Paper Type Mode, Transparency Productivity, Embossed Paper Productivity, and Inserter Productivity.
5. Select **OK** to save your changes and close the **System** window.
6. To exit the Administrator mode, click the **Log Out** button.

### Lower Power Standby

To meet ENERGY STAR requirements, this setting enables you to reduce the power consumption when the press is in standby mode.

- **Enabled (meets ENERGY STAR requirements):** This setting is selected as default in manufacturing and during printer installation. It represents the setting required to meet ENERGY STAR requirements.
- **Disabled:** This setting optimizes press First Print Out Time (FPOT) resulting in slight increase in power consumption in Standby mode.

### Power Saver

Use this feature to set the time that lapses until the Production Press and the Control Center enter a reduced power

consumption mode. The timers are activated when all print jobs are completed and there are no jobs in the job queue.

The Power Saver feature consists of the following options:

- Enter Power Saver
  - System PC & Print Engine
  - Print Engine Only
- Exit Power Saver
  - Automatically
  - Manually

The Production Press and/or user interface exits the Power Saver mode when a job is sent from the print server to the Production Press or when the Control Center is activated. To manually exit the Power Saver mode, press any key on the Control Center keyboard.

### System PC & Print Engine

In this mode, the printer enters Power Saver mode by turning off all internal subsystems, feeding and finisher modules, then the Control Center enters Power Saver mode. To exit from the Power Saver mode, either send a job from the print server to the Production Press or press any key on the Control Center keyboard.

To exit Power Saver mode when the **Manually** option is set, refer to **Exit Power Saver** below.

### Print Engine Only

In this mode, only the power to the Control Center remains on. The rest of the printer enters sleep mode. To use the Production Press, select the **Power Saver** icon on the Control Center. The **Power Saver** button goes out to indicate that the Power Saver mode is canceled.

### Exit Power Saver

From the System tab, select one of two options:

- **Automatically:** Select this option if you want the system to automatically exit from Power Saver mode whenever the mouse, keyboard, PC power switch, or print engine power switch is activated.
- **Manually:** Select this option if you want the system to exit from Power Saver mode on the PC only when you press any key on the Control Center keyboard. To exit Power Saver mode on the printer, do one of the following:
  - From the System menu, select **Power Saver > Exit Print Engine Only**
  - Use the power switch in the same manner to power on the printer.



Note: To manually exit the Power Saver mode, press and release the Power button on the Control Center.

### Setting the Power Saver Options

1. Click **Log In** from the Control Center and log in as Administrator.
2. Select the **Administration** button.
3. From System Settings window, select the **System** tab.

4. Uncheck the power saver options that you do not want enabled for the Production Press. The system default is enabled, checked, for the Print Engine Only only.
5. Use the plus (+) or minus (-) buttons to change the time for each of the power saver features:
  - System PC & Print Engine
  - Print Engine OnlyThe range available is 1-240 minutes.



Note: The system default time is 60 minutes for System PC & Print Engine and Print Engine Only.

6. Select either **Automatically** or **Manually** for the Exit Power Saver option. If you select Automatically, both the print engine and the Control Center are in Power Saver mode. Moving the mouse or touching the keyboard wakes up the Control Center and the print engine. If you select Manually, only the Control Center wakes up. To wake up the print engine, you have to use the System menu.
7. To save your changes, click **OK**, then close the System Settings window.
8. Click **Log Out** to exit the Administrator mode.

### NVM Read/Write

Under most conditions, this feature is used only by Xerox Service Representatives to change certain system settings.

Do not enter any numbers on this screen before consulting with your Xerox Service Representative. Entering numbers on this screen can change system settings which can result in a service call to restore the system to the correct settings.

### Using the NVM Read/Write Feature

1. Click **Log In** from the Control Center and log on as the Administrator.
2. Select the **Administration** button.
3. From System Settings window, select the **System** tab.
4. Click on **NVM Read/Write** button.
5. Type the appropriate six-digit Chain Link Number.
  - a. Type the Chain Number and select **Tab** to advance to the Link field.
  - b. Type the Link number. The current value appears.
  - c. Tab to the New Value field and type the new value to switch on a feature.

The NVM Read/Write window displays the entered value as the Current Value.

6. Select **Close** to save and close your new setting.
7. Click **Log Out** to exit the Administrator mode.
8. Run your print job.



Important: After running your print job, switch off the NVM feature; this ensures that the Production Press runs at maximum efficiency and prevents paper jams.


### Stock By Name Only

When this option is checked, the Production Press selects loaded stocks for a print job using just the Stock Name instead of Stock Type, Size, Weight, and other media attributes. The option turns off the automatic selection of a stock by matching a job with the properties and requires that you select the stock by its name. This function is useful for preventing expensive or specialty stocks from being used unintentionally.

When this option is not checked, stocks are selected from the print server or from a print driver by matching attributes, such as weight. Stock names are also examined, but are not used exclusively.

### Auto Resume After Fault Clearance


Use the Auto Resume After Fault Clearance feature to set the amount of time job processing automatically resumes after you clear a fault.

 Note: To resume automatically after pause or fault, set the time to a minimum of **1** second.

1. Click **Log In** from the Control Center and log in as the Administrator.
2. Select the **Administration** button.
3. From the System Settings window, select the **System** tab.
4. Click the **Auto Resume After Fault Clearance** check box.
5. Use the plus (+) or minus (-) buttons to set the amount of time in minutes or seconds before the Production Press resumes.  
The range for minutes is 0-60 and the range for seconds is 0-59. Select at least one second. The system default time is one minute.
6. Click **OK** to save your changes, then close the System Settings window.
7. To exit the Administrator mode, click the **Log Out** button.

### Auto Resume After Pause

Use the Auto Resume After Pause feature to set the amount of time a job automatically resumes after you click the **Pause Printing** button on the Control Center window.

 Note: To resume automatically after pause or fault, set the time to a minimum of **1** second.

1. Click **Log In** from the Control Center and log in as the Administrator.
2. Select the **Administration** button.
3. From the System Settings window, select the **System** tab.
4. For the Auto Resume After Pause option, use the plus (+) or minus (-) buttons to set the amount of time in minutes or seconds before the Production Press resumes.  
The range for minutes is 0-60 and the range for seconds is 0-59. Make sure you select at least one second. The system default time is one minute.
5. Click **OK** to save your changes, then close the System Settings window.
6. To exit the Administrator mode, click the **Log Out** button.

### Auto Logoff

Use the Auto Logoff feature for the Production Press to automatically return to the printing mode when no action is taken from any of the administrator functions after the set amount of time.

1. Click **Log In** from the Control Center and log in as the Administrator.
2. Select the **Administration** button.
3. From System Settings window, select the **System** tab.
4. To enable the feature, click the **Auto Logoff** check box, then use the plus (+) or minus (-) buttons to set the delay time from 1 to 60 minutes.
5. Click **OK** to save your changes, then close the System Settings window.
6. To exit the Administrator mode, click **Log Out**.

### Attention Sound Settings

The Attention Sound Settings option allows you to select whether or not to sound an alert when the Production Press has a fault, when the paper tray is empty, or when a consumable is low.



Note: These settings do not control the notification sounds from the Control Center PC. To mute or change the sound volume of the PC, use the volume control on the PC.

1. Click **Log In** from the Control Center and log in as the Administrator.
2. Select the **Administration** button.
3. From the System Settings window, select the **System > Attention Sound Settings**.  
The Attention Sound Settings window appears. You can set a sound volume for the Production Press conditions: Low Consumable, Near Full Paper Tray, Near Full Waste Container, Paper Tray Empty, and Other Stoppage.



Note: The Other Stoppage Sound Volume category includes most jam shutdown faults.

4. From the Volume menu for each category, select the appropriate setting: **Loud**, **Medium**, **Soft**, or **Off**.
5. From the Frequency menu, select either **Limited Duration** or **Until User Action**.
6. Click **OK** to save your changes, then close the System Settings window.
7. To exit the Administrator mode, click **Log Out**.

### Date and Time Settings

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

1. On the Control Center, click **Log In**, then log in as the Administrator.
2. Click **Administration**.
3. From the System Settings window, select the **System** tab.
4. To enter the month, day, and year, use the plus (+) or minus (-) icons.
5. Select the Date Format that you want to use.
6. To set the current time, in hours and minutes, use the plus (+) or minus (-) icons, then select **AM** or **PM**.
7. Select the Time Format that you want to use.


8. To set the correct hour and minutes, use the up or down arrow icons.
9. To save your changes and close the window, click **OK**.
10. To exit the Administrator mode, click **User: Administrator**, then click **Log Out**.

### Auto Tray Switching Option


When you select Automatic Tray Switching, the Production Press feeds stock from its trays automatically and in a pre-set order. Use the Automatic Tray Switching method to maintain press productivity and eliminate the need to stop and reload stock during printing.

There are two ways to use the Automatic Tray Switching option:

- Use the pre-set default paper tray settings
  - Define your own paper tray settings
1. To create stock selections and assign them to specific trays, select the **PredictPrint Stock Library** or **Manage Stock Library** tab.

 Note: Either the PredictPrint Stock Library option or the Manage Stock Library option appears on the user interface. The option that appears depends on the software version that is installed on your press.

2. On the Tray Options screen, specify the order of paper trays. Your selections may change with the types of jobs you run. Select one of the following options:
  - **Priority 1** - When a tray runs out of paper, the Production Press automatically checks the Priority 1 tray before checking others to locate the correct stock and continue printing.
  - **Check in a fixed order** - Instructs the Production Press to find the next high priority tray that contains the required stock in sequential order.

 Note: If a stock is assigned to a tray that does not meet the requirements to run the job, the PCUI displays a message to load the required paper stock. Printing will begin after the correct stock is loaded.


- **Manual Tray Switching:** This option requires more operator interaction during printing than Automatic Tray Switching.

To allow tray-switching while a job is printing, for Manual Tray Switching, select **Enable**.

When Manual Tray Switching is enabled, an arrow button in the Tray Status area allows you to change the feeding operation to another tray that is loaded with the same media.

When Manual Tray Switching is disabled, the preset Automatic Tray Switching option is active.

- **Do Not Include For Temporary:** This option tells the system not to automatically select and feed paper from a specific tray after other trays are empty.

 Note: This feature only works if there are more than two trays available for selection. If Trays 1 and 2 are the only trays available, this feature is unavailable.

### Selecting the Tray Feeding Options

At the Control Center, view the available paper trays and assign the appropriate paper stocks for the job to a tray. You can set tray feeding options to indicate how the Production Press feeds stock and switches trays automatically when printing.



Note: All trays in the Production Press have sensors that detect when paper in the tray is low or empty. At the Tray Options screen, you can set a notification to receive paper tray status. Select the tray paper level, **Near Empty** or **Empty**.



Note: Fiery® Print Server version 4.0 include Fiery System version FS600 and have unique features that are not available on older Fiery® Print Servers. On Fiery® Print Server version 4.0, FS600 or newer version, if the stock loaded in the tray is registered with PredictPrint Stock Wizard, then you can right-click on the tray to **Run Image Quality System Check**. To enable this feature, refer to [Automatic Image Quality System Check](#).

If you select the Automatic Tray Switching method, the Press feeds stock in a pre-set order. This method increases productivity and eliminates the need to stop and reload stock during printing. Select the default settings for the following paper tray options:

1. At the Control Center, click **Log In** and log in as the Administrator.
2. From the Administration window, select the **Tray Options** screen.
3. Specify the order of the Paper Trays.



4. Select a Paper Tray Feeding option:

- Automatic Tray Switching (default)- Instructs the Production Press to switch trays automatically in a specific order. Automatic Tray Switching maintains press productivity and eliminates the need to stop and reload stock during printing. Options include:
  - **Always check from priority 1:** When a tray runs out of paper, the Production Press automatically checks the tray listed as Priority 1 Tray before checking other available trays, to locate the correct stock and continue printing.
  - **Check in a fixed order:** This option instructs the Production Press to check the next higher priority tray. For example, if the paper being fed is from tray 2 and runs out of paper, the Production Press then checks the next tray in the priority list. The Production Press continues to check the trays in the priority list in sequential order until a tray is found with the same stock requirements.



Note: If a tray with the same stock requirements is not found, the Production Press displays a message to load the required paper.

- Manual Tray Switching- This option requires more user interaction. The options include:
  - **Enable:** This option allows the user to choose a specific tray instead of having the system automatically check the available trays with the matching paper parameters (size, weight, etc). When the current tray runs out of paper, or nears empty, the PC UI displays a message to ask which available tray to feed paper from next, or to cancel the job.
    - **Disable:** This option reverts to the default tray switching method, as per the selections made for Auto Tray Switching and Auto Tray Switch Method.
- Do Not Include For Temporary - Selecting a tray in this column means that the system does not automatically select and feed paper from that tray after other trays are empty.



Note: This feature works only if there are more than two trays available. If Trays 1 and 2 are the only trays available, the Production Press ignores this feature.

5. Select the appropriate Tray Properties for the print job. Set whether the Tray Properties window automatically closes if no changes are made:

- Select **Enable Timeout**. The window closes automatically once the preset time is reached. Select a timeout period between 1-240 minutes.

6. If you selected Automatic Tray Switching, set the default Tray Priority levels for each tray:

- a. Select the highest priority tray on the Tray Priority list.
- b. Click the up arrow to position the tray at the top of the tray in the Priority list.
- c. Repeat steps a and b to select and position each tray required to run the job.



Note: If each paper tray contains the same paper size and weight, the Production Press feeds paper from the tray set at Priority 1. When the Production Press feeds stock and switches trays automatically, the trays feed in this order: Tray 1, A1-1, 2, A1-2, A2-1, and so on.

7. Select **OK** to save your changes, then close the System Settings window.

8. To exit the Administrator mode, click **Log Out**.

## Output Devices Tab

This tab is available only when specific finishing devices are attached, such as the High Capacity Stacker or the Perfect Binder.

### High Capacity Stacker Settings

Use the Output Devices feature to set specific High Capacity Stacker output settings, including:

- Auto Output Switching: This option sets whether or not to allow the automatic switching of the output destination from a full High Capacity Stacker to a second High Capacity Stacker while jobs are printing or when you press the **Unload** button on the High Capacity Stacker.
  - **Disable:** This option reverts to the default tray switching method, as per the selections made for Auto Tray Switching and Auto Tray Switch Method.
  - **Disable:** This is the default setting. Select this option if you do not want automatic switching from one High Capacity Stacker to another High Capacity Stacker during print jobs.



Note: The Auto Output Switching and Auto Output Switching Priority options are available only when there is more than one High Capacity Stacker attached to the Production Press.

- Auto Output Switching Priority: Set the priority order for each attached High Capacity Stacker.
- Unload Timing: This option sets how the High Capacity Stacker **Unload** button functions.
  - **Unload at set boundary:** Selecting this option causes the High Capacity Stacker to stop after delivering output at the end of the set when you press the **Unload** button.
  - **Unload immediately:** Selecting this option causes the High Capacity Stacker to stop after delivering the scheduled paper immediately when you press the **Unload** button. This may occur in the middle of a job set, and the last set delivered may not be a complete set.




Note: If more than one High Capacity Stacker is attached to the Production Press, the option selected here applies to all of them.

## Image Quality Tab

This feature allows administrators to select the default settings to achieve maximum image quality on the printed output.

The Image Quality feature consists of:

- Priority When Switching Paper Types: Choose one of two options:
  - **Image Quality:** This selection provides the best possible image quality on the output. However, the Production Press pauses to adjust the image quality each time it switches paper types. As a result of these switches, the Production Press runs at a slower print speed, resulting in lower productivity.
  - **Productivity:** This selection allows the Production Press to run at a higher rate of speed than does the Image Quality setting. Using the Productivity setting results only in a slight reduction in productivity when the Production Press switches paper types.


 Note: For both settings, the reduction in productivity is relative to the number of paper type switches in the job. Each paper type switch results in a slight loss of productivity. For example, a job that switches paper types every other page results in the greatest productivity loss, while a job that switches paper types only once offers the a much better productivity rate.

- **Fuser Belt Refresh:** For details, refer to [Fuser Refresh Mode](#).
- **Silver, Gold, White, and Fluorescent Pink Printing:** This option uses a **Higher Fuser Temperature**, which can improve toner adhesion when printing with Silver, Gold, White, and/or Fluorescent Pink specialty dry inks. Use the higher fuser temperature option only when you notice toner adhesion problems. Note that this setting gives a very slight gloss increase on some media.
- **Registration Control Setup:** Run this option when image quality issues such as color-to-color, lead edge, and side edge registration problems occur on printed output. Running this option can fix the registration issues without placing a service call. To run the setup, select the **Color Mode** or toners you are using, then click **Start Registration Control Setup**.

### Fuser Refresh Mode

Use the Fuser Belt Refresh option to run a fuser belt refresh when the system is experiencing image quality defects on the printed output. These defects include scratches, spots, streaks, or bands. The refresh option engages the fuser refresh roll against the fuser belt and buffs out any scratches that may be occurring on the lead edge or side edge of the output.

When enabled, the refresh mode occurs every 10,000 prints and takes approximately 60 minutes. This refresh mode occurs while the press is idle, not printing.

 Note: If a job is submitted while the refresh mode is running, the refresh mode stops and the submitted job is printed. The refresh mode does not reconvene after the print job completes. Another refresh mode occurs after the next 10,000 prints are reached.

To set the system to run automatic fuser belt refresh at specific intervals:

- **Enable Automatic Refresh:** Enabling automatic refresh instructs the system to run a fuser belt refresh during a waiting for printer process.
- **Refresh Duration:** It can be set between 1-999 minutes.

**Start Manual Refresh:** This option allows you to set up a manual fuser refresh at the point of need instead of at a scheduled time. You can have a scheduled refresh time programmed and also perform a manual refresh at any time.

The duration default time is 60 minutes. If lead edge or side edge defects still occur upon completion of a 60-minute refresh mode, the refresh time can be changed to a longer duration to eliminate these defects.

### Full Width Array Tab

On the **Full Width Array** tab, you can run these image quality adjustments:

- **Automatic Density Uniformity Adjustment:** Adjusts uniformity in toner density across the page. Run once for the cross-process direction (inboard to outboard) and again for the process direction.
- **Restore Density to Default:** This button resets the Production Press settings for Density Uniformity to their factory values. Use only after Charge Corotrons are replaced, or when instructed by Xerox representative.

For Administrators

- **Automatic Banding Detection Diagnostics:** This option is not used, and accessible to Xerox representative only.
- **Automatic Streaks Detection Diagnostics:** This option is not used, and accessible to Xerox representative only.

For more information, refer to [Calibrating the Production Press](#).

## Maintenance Tab

Clicking the **Maintenance** button opens a window that displays options for cleaning particular components inside the Production Press. The Maintenance screen is divided into two sections: Charge Corotron Cleaning, and Dry Ink Cleaning.

The Maintenance cleaning options are listed below:

### Charge Corotron Cleaning

Allows you to clean one or all of the charge corotrons. You can run this cleaning procedure if you are experiencing image quality issues, such as banding or mottling.

### Dry Ink Cleaning

Allows you to clean one or all of the dry ink/toner cartridge systems. You can run this cleaning procedure if you are experiencing image quality issues, such as white or dark spots or blotches on the prints. These spots or blotches are caused by dry ink/toner adhering to the drum.

## CLEANING THE CHARGE COROTRONS

Perform the following steps to clean one or all of the charge corotrons.

1. Click **Log In** from the Control Center and log in as Administrator.
2. Click the **Maintenance** button.
3. Select the corotrons that need to be cleaned.
4. Click **Start Cleaning**.
5. When the cleaning is complete, click **Close** to exit.

## DRY INK/TONER CLEANING

The following cleaning procedure expels toner that has been in the housing too long (high toner age). High toner age can lead to low density conditions and difficulty in first and second transfer.

Perform the following steps to clean one or all of the dry ink/toner cartridge dispensers.



Note: Run a few test prints before performing the cleaning procedure. After you click the **Start Cleaning** button, the system automatically generates a test print. By running test prints before the cleaning process, you can compare the image quality of prints before and after cleaning.

1. Click **Log In** from the Control Center and log in as the Administrator.
2. Click the **Maintenance** button.
3. Select the check box next to the dry ink/toners to be cleaned.
4. Click the **Start Cleaning** button to begin the cleaning process.
5. Select the appropriate paper tray and feed orientation: Long Edge Feed or Short Edge Feed.
6. Click the **Start** button to begin.

When the process is complete, a *Cleaning is complete* message appears on the screen.

7. Click **Close** to exit.





