

DocuColor 5000AP **Administrator** Guide



©Copyright 2008 by Xerox Corporation. All Rights Reserved.

Copyright protection claimed includes all forms and matters of copyrighted material and information now allowed by statutory or judicial law or hereinafter granted, including without limitation, material generated from the software programs that are displayed on the screen such as styles, templates, icons, screen displays, looks, etc.

Xerox® and all Xerox product names and product numbers mentioned in this publication are trademarks of XEROX CORPORATION. Other company brands and product names may be trademarks or registered trademarks of the respective companies and are also acknowledged.

This product includes software developed by the Apache Software Foundation (<http://www.apache.org/http://www.apache.org/>).

Table of contents

1. Administrator overview **1-1**

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

2. System Settings **2-1**

Overview	2-1
User Interface	2-2
Fault Details window	2-3
Change Password	2-5
Setting the Date & Time	2-8
System	2-9
Productivity Setting	2-10
Productivity charts	2-11
All Weights Rated Speed	2-11
Mixed Paper Weight	2-12
Power Saver	2-13
Exit Power Saver	2-14
Auto Resume After	2-15
Fault Clearance	2-15
Pause	2-16
Job Spacing	2-17
Auto Logoff	2-18
NVM Read/Write	2-19
Tray Options	2-23
Auto Tray Switching, Auto Paper Selection, and Do Not Include	2-24
Paper Tray Assist	2-25
Tray Priority	2-28

3. Profiles	3-1
Overview	3-1
Alignment	3-1
Alignment Adjustment Profile procedure.	3-2
Selecting the Registration options	3-5
Selecting the Perpendicularity options	3-6
Selecting the Skew options.	3-7
Selecting the Magnification options	3-8
Running test prints	3-9
Custom Paper	3-11
Custom Paper procedure	3-11
Selecting the desired paper type	3-13
Selecting the desired paper weight.	3-14
Second Bias Transfer Belt	3-20
Aligner Roll Pressure	3-24
Paper Tray Air Assist	3-25
Decurler Overview	3-26
Decurler paper path	3-27
Decurler A-D Profile settings	3-28
Decurler A-D Profile procedure.	3-28
Custom Decurler Profiles	3-30
Entering values in the Custom Decurler Profile fields. . . .	3-34
Creating a Custom Decurler Profile	3-36

1. Administrator overview

Overview

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

Logging on as Administrator



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

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



2. Use the keyboard to enter the Administrator password.
The default password is five ones (**11111**).
For security reasons, only asterisks are displayed on the screen.

3. Select the **OK** button.

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



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

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

Finishing System Profiles overview

Availability	Sheet Sequence	Statuses Supported
Enabled	1 to N	S0, S1, S2, S3, S4
Between Sheets	Output Side 1 Direction	Recovery Method
32,767 ms	Face Up	Sheet
Finisher Capacity	Delivery Signal Type	Jam Timings
99 Sheets	Lead Edge	Sheet: 32,767 ms Set: 32,767 ms
Cycle Up Time	Delivery Adjust	Functions
60 seconds	Start: 300 ms End: 100 ms	1: System Specified 2: Line Off
Cycle Down Delay	Processing Times	
60 seconds	Set Compiler: 32,767 ms Maximum Set: 32,767 ms	

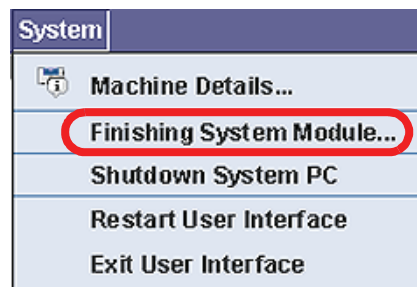
Sheet Length	Sheet Width	Sheet Weight	Set Size
Minimum: 182 mm	Minimum: 203 mm	Minimum: 60 g/m ²	Minimum: 1 Sheet
Maximum: 488 mm	Maximum: 320 mm	Maximum: 300 g/m ²	Maximum: 65,000 Sheets

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



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

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



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

2. System Settings

Overview

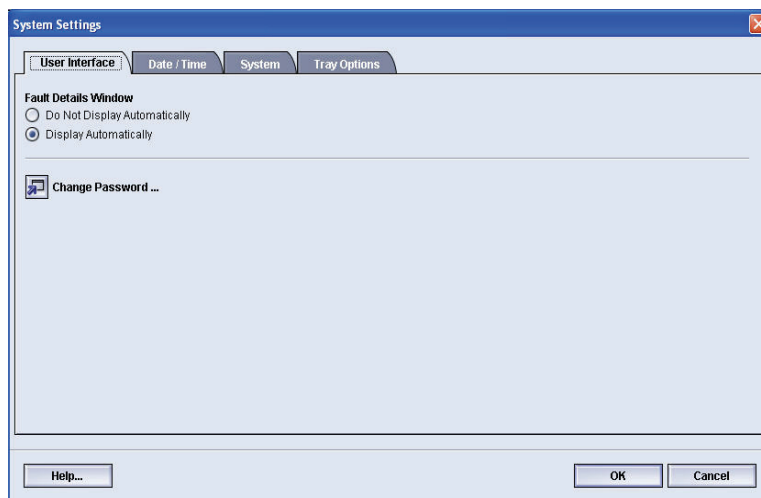
The System Settings feature allows you to make changes to the following features:

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

User Interface

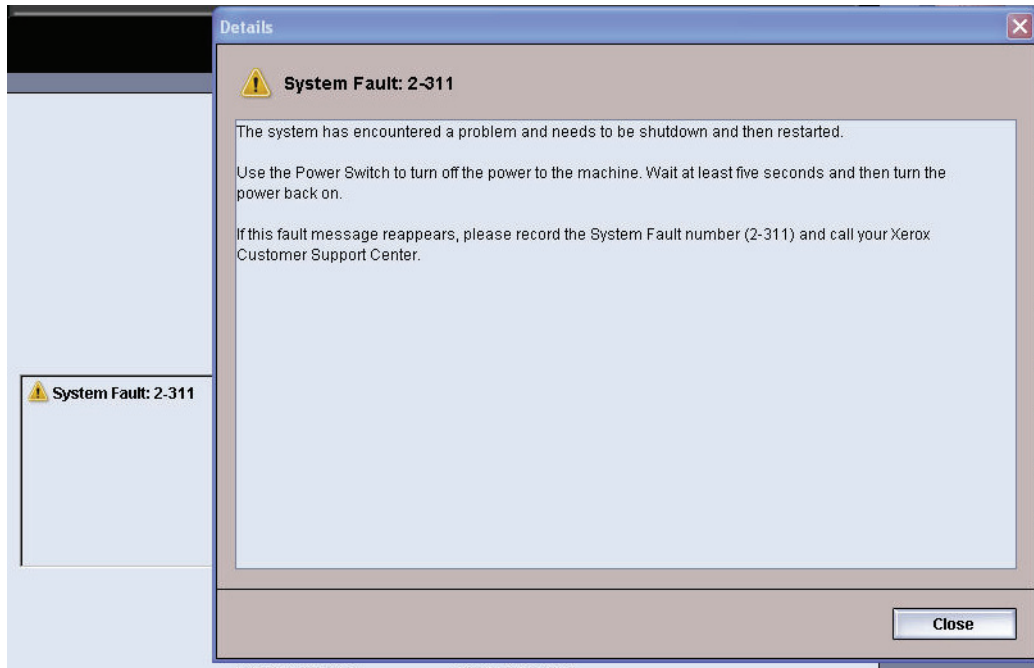
The **User Interface** feature allows you to make changes to the following:

- Fault Detail Window
- Changing the Administrator password



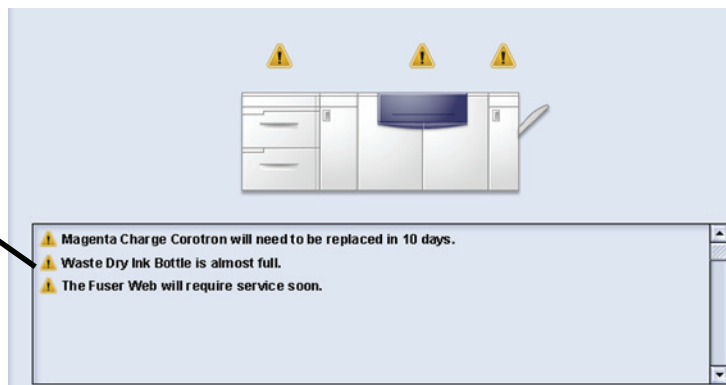
Fault Details window

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



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

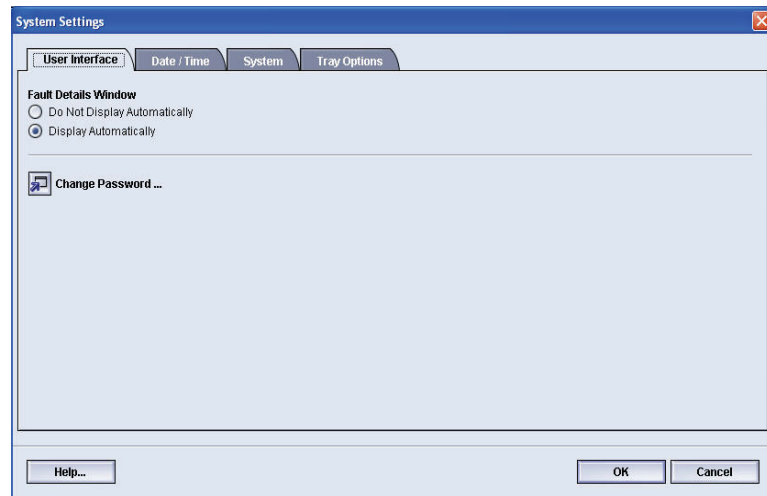
Machine
mimic and
Message
area





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

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



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

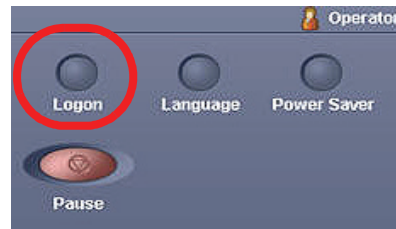
Change Password

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

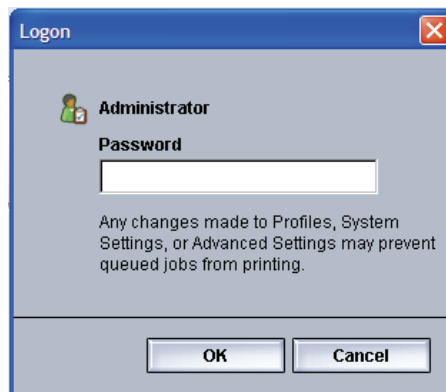


Use the following procedure to change the Administrator password.

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



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



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

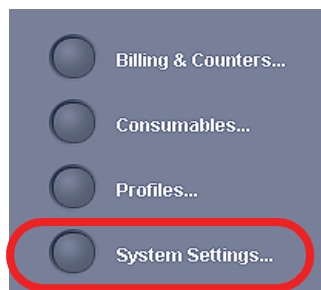


NOTE: The digital press arrives from the factory with a default Administrator password of five ones (11111). Use this default password to logon.

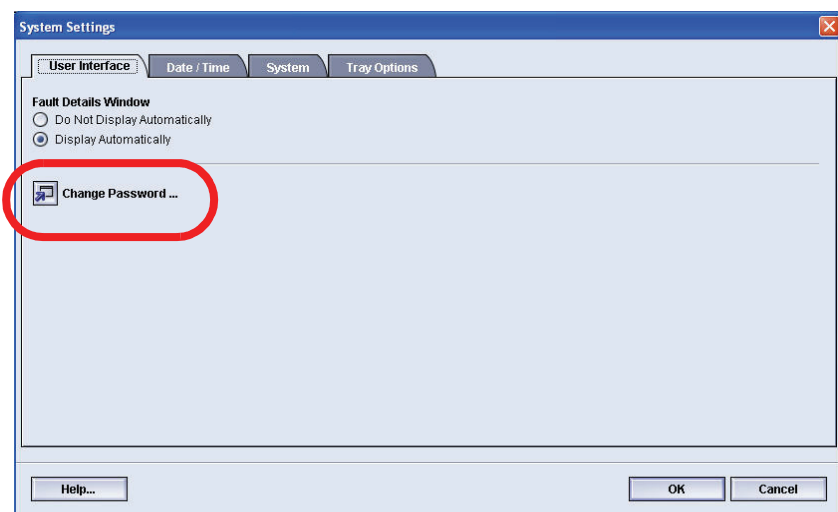


TIP: For security reasons, you should change the Administrator password from its default password to a new one.

3. Select the System Settings button.



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



The Change Password window opens.





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

5. From the Change Password window, enter:

- a. The old (current) password
- b. The new password
- c. Reenter the new password in the Confirm New Password area
- d. Select **OK**



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

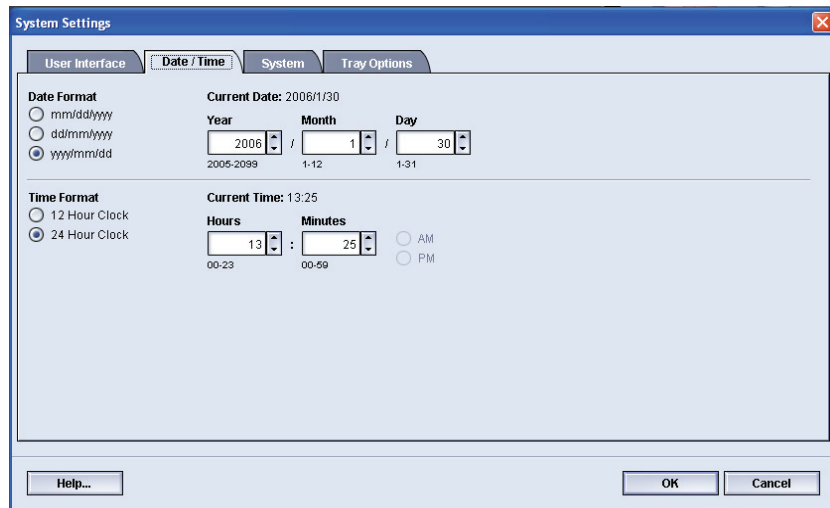
6. Select **OK** from the System Settings window to return to the main UI window.

Setting the Date & Time

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



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



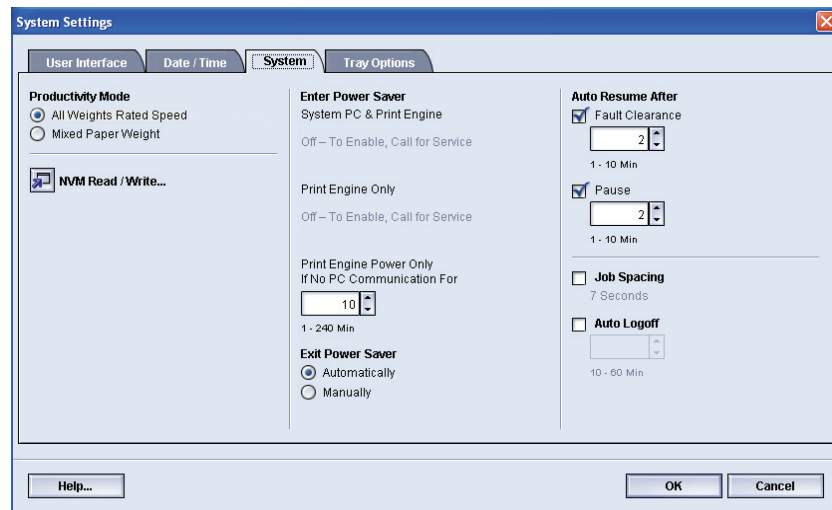
2. Select the Date Format you wish to use.
3. Use the up or down arrow buttons to enter the correct year, month, and day.
4. Select the Time Format you wish to use.
5. Use the up or down arrow buttons to set the correct hour and minutes.



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

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

System

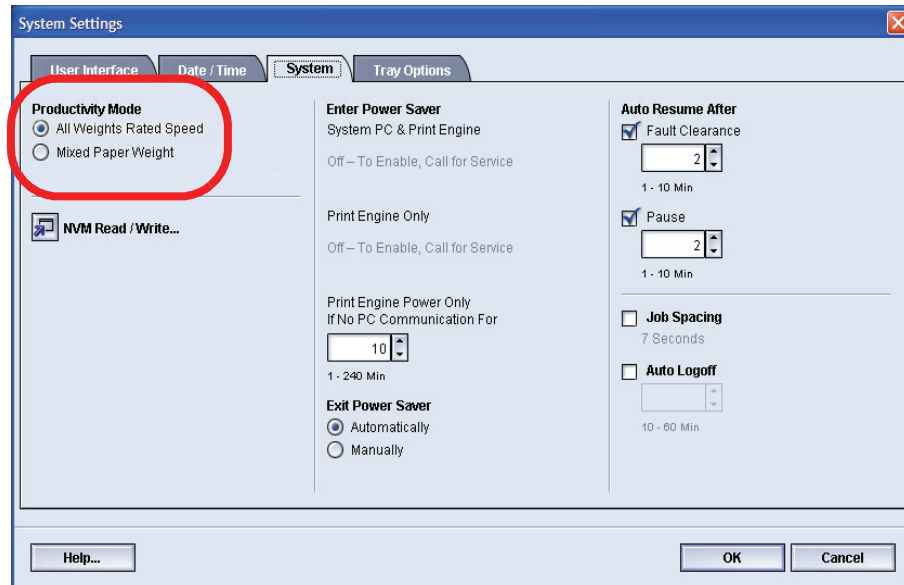


Use this feature to change the factory default settings for the following:

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

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

Productivity Setting



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

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

- **All Weights Rated Speed:** This setting runs all jobs at the same speed regardless of the paper weight. Gloss levels may appear lower on heavier weight media.
- **Mixed Paper Weight:** This setting optimizes the throughput speed of print jobs that contain mixed media weights from different paper trays.

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

Productivity charts

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

All Weights Rated Speed

All Weights Rated Speed Mode				
Paper Weight	Paper Size (Feed direction length) [inches/mm]		Print Speed (prints per minute = ppm)	
	Min.	Max	1 Sided	2 Sided
36 - 135 lb (60 - 220 g/m ²)	7.16 in. (182.0 mm)	8.5 in. (216.0 mm)	50	25
	8.51 in. (216.1 mm)	11.69 in. (297.0 mm)	50	25
	11.7 in. (297.1 mm)	18 in. (458.0 mm)	50	25
	18.1 in. (458.1 mm)	19.2 in. (488.0 mm)	50	25
136 - 184 lb (221 - 300 g/m ²)	7.16 in. (182.0 mm)	8.5 in. (216.0 mm)	50	25
	8.51 in. (216.1 mm)	11.69 in. (297.0 mm)	50	25
	11.7 in. (297.1 mm)	18 in. (458.0 mm)	50	25
	18.1 in. (458.1 mm)	19.2 in. (488.0 mm)	50	25

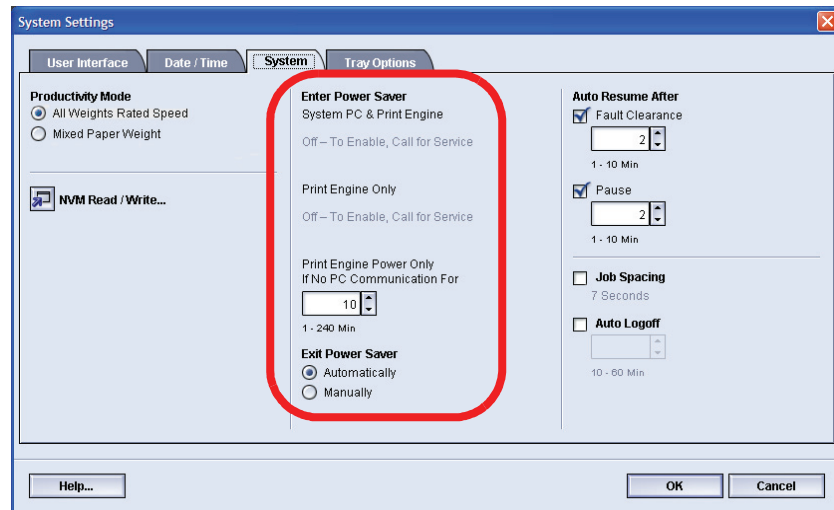
Mixed Paper Weight

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



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

Power Saver



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

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



NOTE: To manually exit Power Saver mode, quickly press the power button on the System PC.

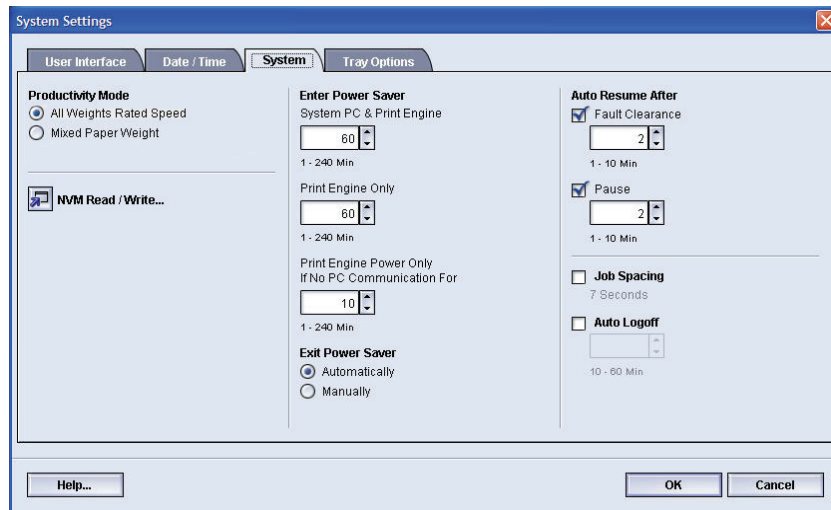


TIP: The **System PC & Print Engine** and **Print Engine Only** features must be enabled by your Xerox representative before you can use them. If these features are not enabled, call your Xerox representative for more information.



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

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



2. Use the up or down arrow buttons to change the time for each of the power saver features:
 - System PC & Print Engine
 - Print Engine Only
 - Print Engine Power Only If No PC Communication ForThe range available is 1-240 minutes.



NOTE: The system default time is sixty minutes.

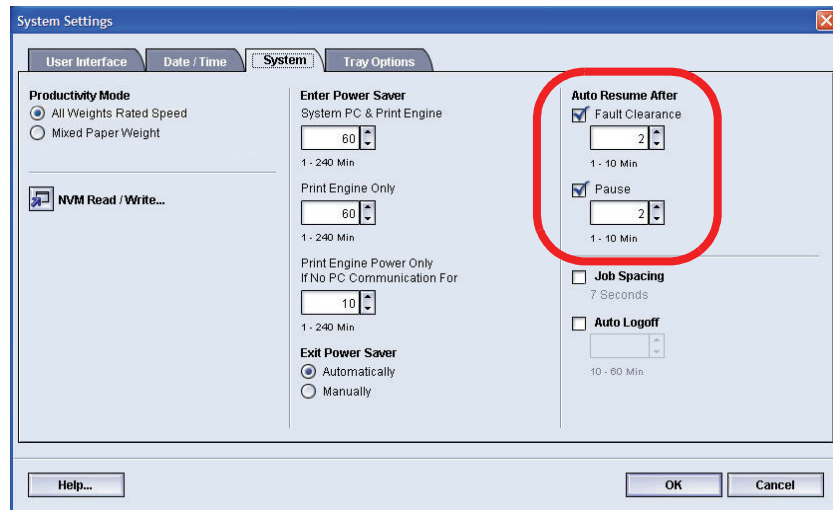
3. Select **OK** to save your changes and close the System Settings window.

Exit Power Saver

Select one of two options:

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

Auto Resume After

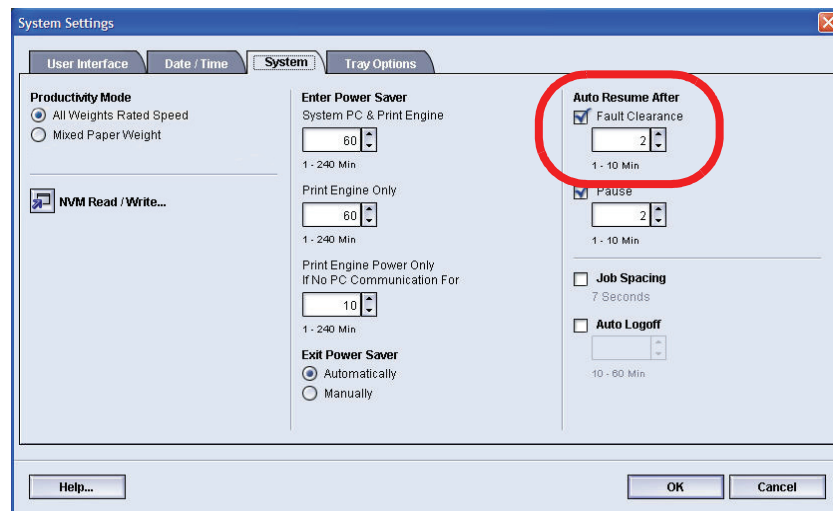


Fault Clearance

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



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



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



NOTE: The system default time is two minutes.

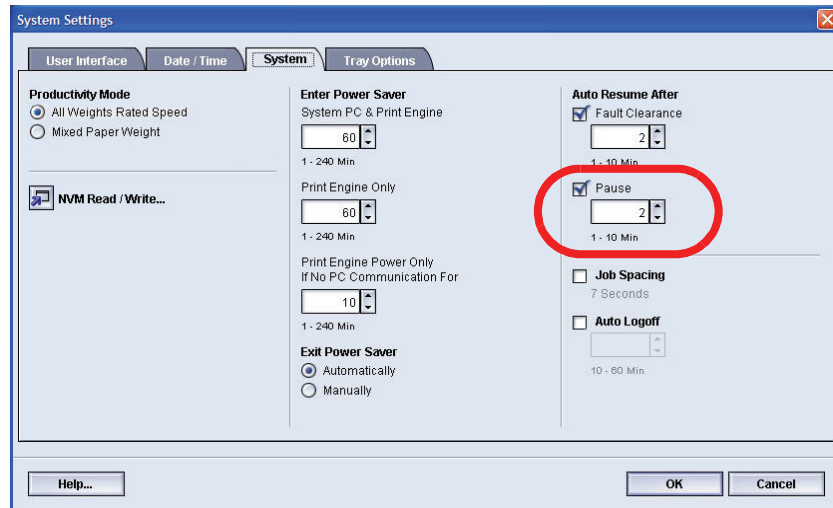
3. Select **OK** to save your changes and close the System Settings window.

Pause

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



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



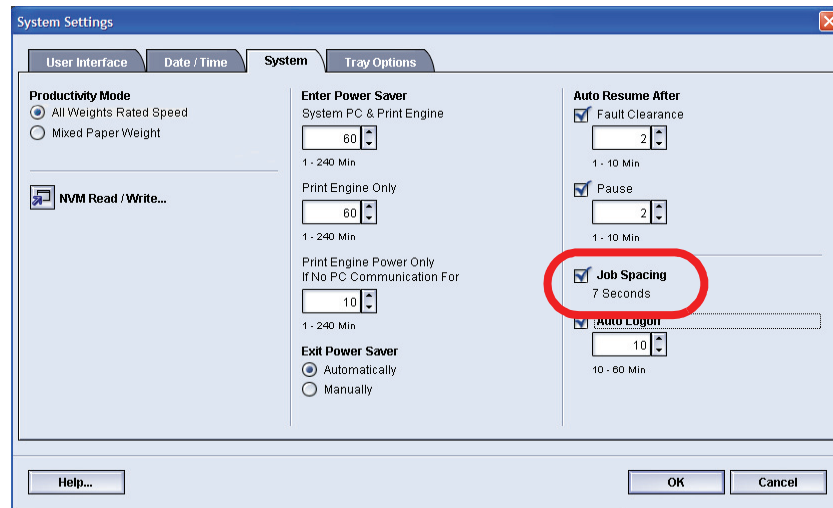
2. Use the up or down arrow buttons to change the time. The range available is 1-10 minutes.



NOTE: The system default time is two minutes.

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

Job Spacing

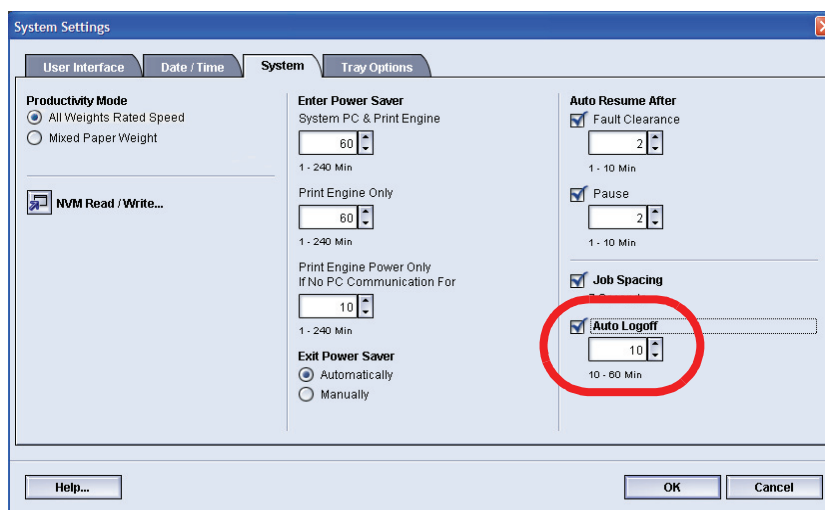


Use the Job Spacing feature when there are multiple jobs queued and you would like to allow seven seconds to unload prints from a finishing device before the next job starts printing.



1. From the System tab of the System Settings window, select the checkbox to the left of Job Spacing.
Seven seconds is the standard and only time for this option.
2. Select **OK** to save your changes and close the System Settings window.

Auto Logoff



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



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

2. Use the up or down arrow buttons to change the time. The range available is 10-60 minutes.

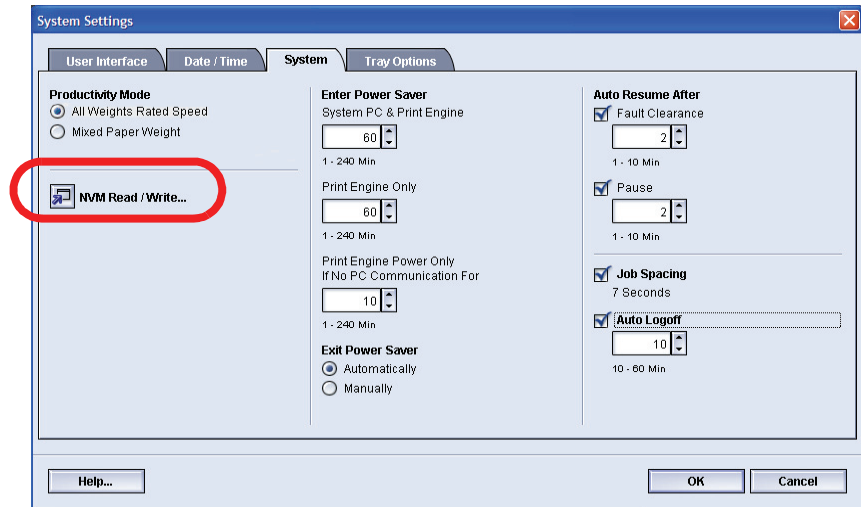


NOTE: The system default time is ten minutes.

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

NVM Read/Write

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



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

Special Media Setting for Drilled Papers

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

Special Media Setting for LEF Tab Stock

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

Carbonless Media Enablement

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

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

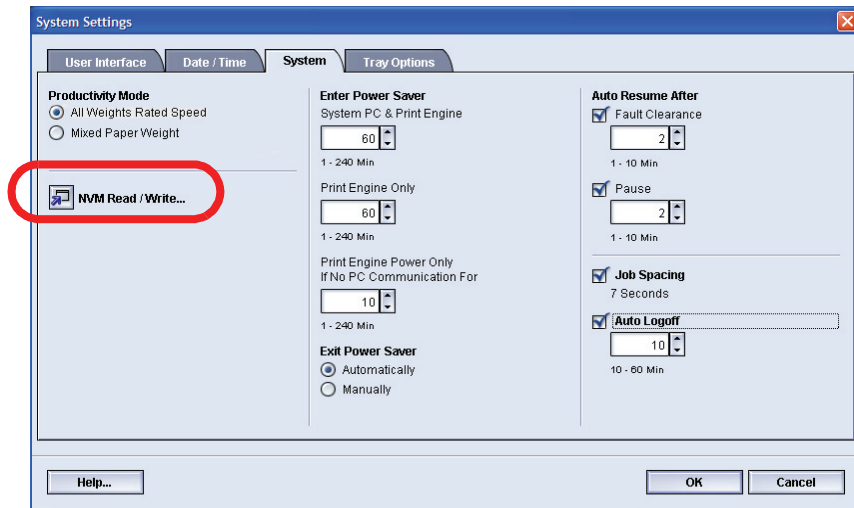


CAUTION: Do not enter any numbers on this screen other than the ones described in this procedure. Entering and saving numbers, other than the ones described, changes the system settings which may result in a service call to restore the system to the correct settings.

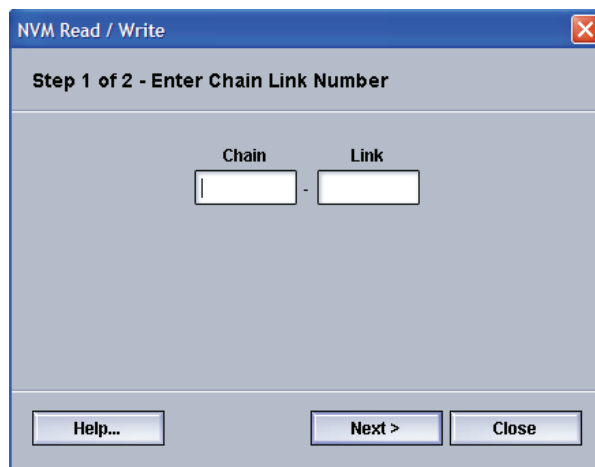


To switch **on** a feature, perform the following:

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



The NVM Read/Write window opens.



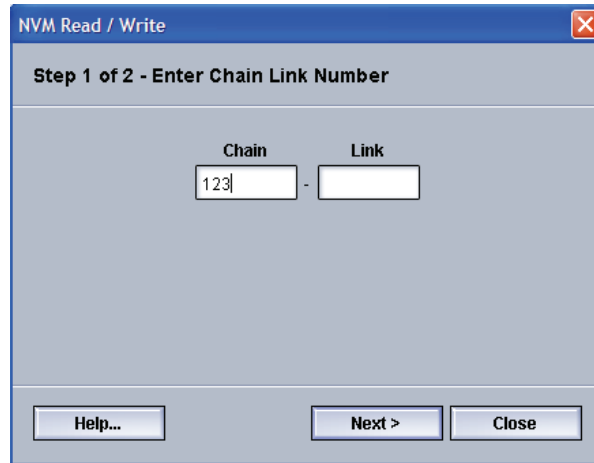
2. Enter the desired **Chain Link Number**:

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



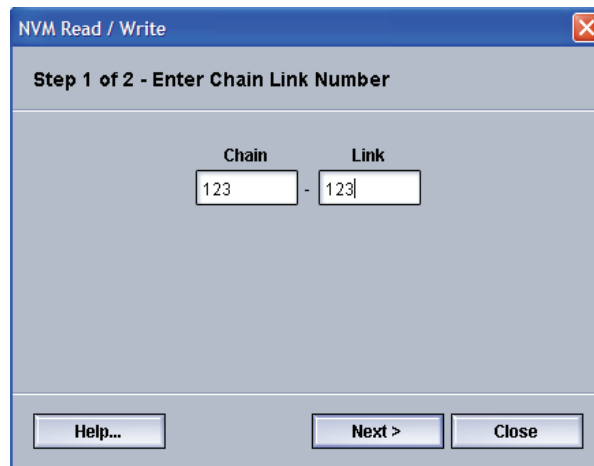
NOTE: For the purpose of this procedure, the following screens show an example of a Chain Link Number, Current Value, and New Value; this example does not represent an actual Chain Link Number. The Current Value and New Value numbers will vary depending on the Chain Link Number entered.

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



The screenshot shows a dialog box titled "NVM Read / Write" with a close button in the top right corner. The main heading is "Step 1 of 2 - Enter Chain Link Number". Below this, there are two input fields: "Chain" and "Link", separated by a hyphen. The "Chain" field contains the number "123". The "Link" field is empty. At the bottom of the dialog, there are three buttons: "Help...", "Next >", and "Close".

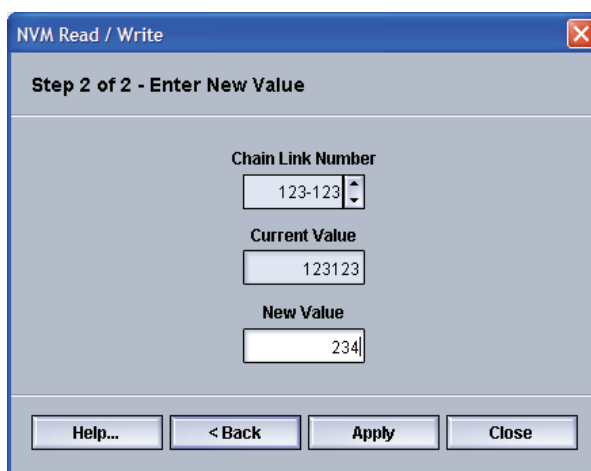
- b. Press the Tab button on the keyboard to advance to the Link field.
- c. Enter the Link number (the following example uses 123 as the Link number).



The screenshot shows the same dialog box as before, but now both the "Chain" and "Link" fields contain the number "123". The "Next >" button is now highlighted, indicating it is the active element.

- d. Select the Next button.

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



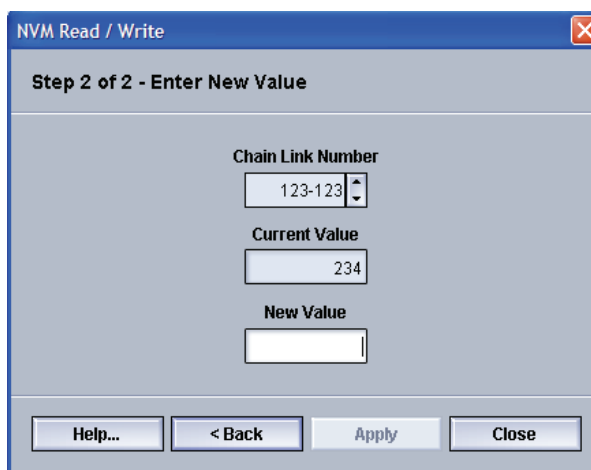
The screenshot shows a dialog box titled "NVM Read / Write" with a close button in the top right corner. The main heading is "Step 2 of 2 - Enter New Value". Below this, there are three input fields: "Chain Link Number" with a value of "123-123", "Current Value" with a value of "123123", and "New Value" with a value of "234". At the bottom, there are four buttons: "Help...", "< Back", "Apply", and "Close".



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

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

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



The screenshot shows the same dialog box as before, but now the "Current Value" field displays "234" and the "New Value" field is empty. The "Chain Link Number" remains "123-123". The buttons at the bottom are the same.

- Select **Close** to save and close your new setting.
- Select **OK** to close the System Settings window.



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

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



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

Tray Options

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

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

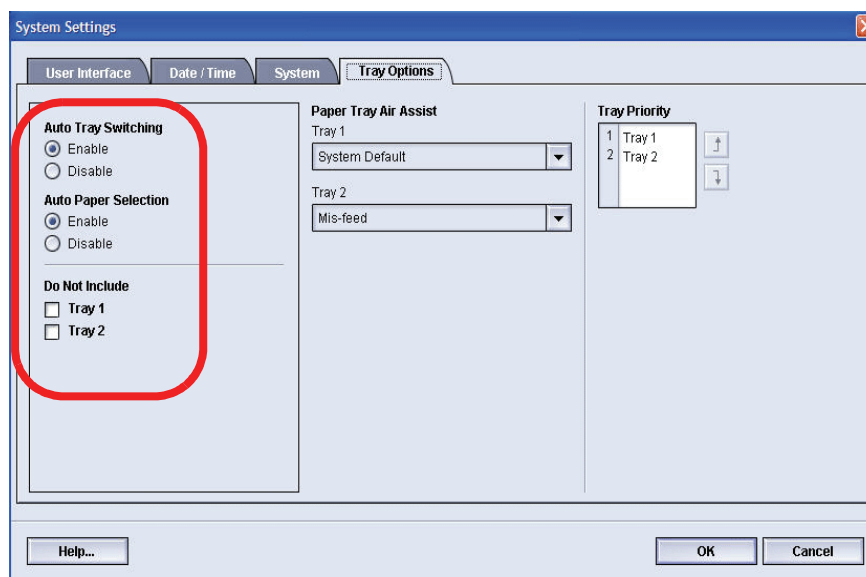
Auto Tray Switching, Auto Paper Selection, and Do Not Include

Choose the default settings for the following options:

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

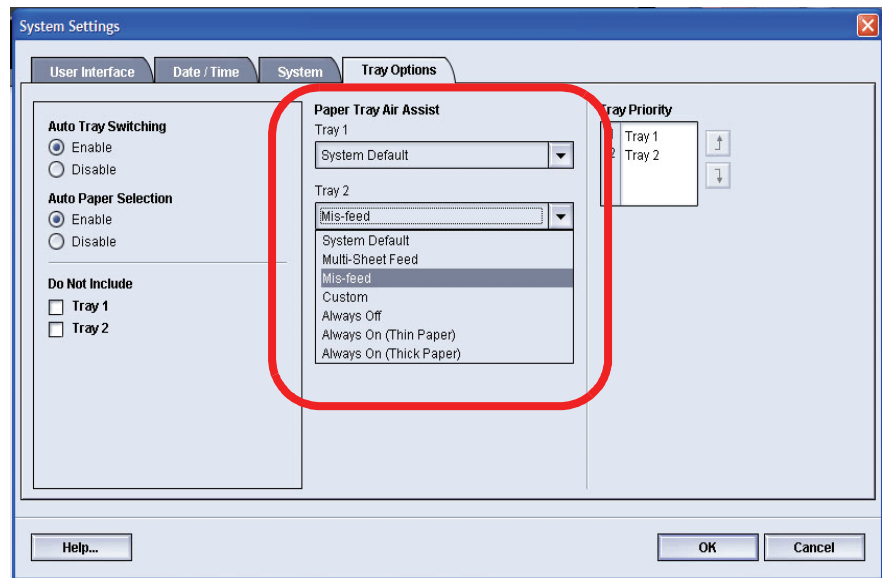


1. From the System Setting window, select the Tray Options tab.



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

Paper Tray Assist



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

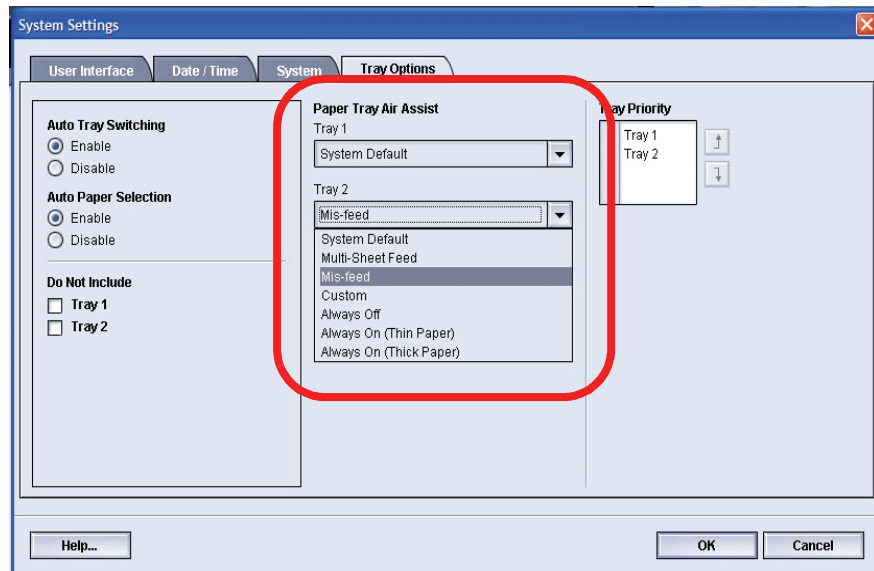
- Each paper tray has two blowers and two fans. The blowers are located in the front of each tray, while the two fans are located on the right-side of the tray.
- The lead edge blower is on at all times and produces heated air if one of the following selections are made: Coated paper, Transparencies, or Plain paper 106 g/m² or heavier. The trail edge blower is on at all times and does not produce heated air.
- The paper trays also have air adjustment levers on the drawer to regulate the direction of the air:
 - If the paper weight is between 60 and 256 g/m², the position of the air adjustment levers should be toward the front of the tray.
 - If the paper weight is between 257 and 300 g/m², the position of the air adjustment levers should be positioned toward the rear of the tray.





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

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



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

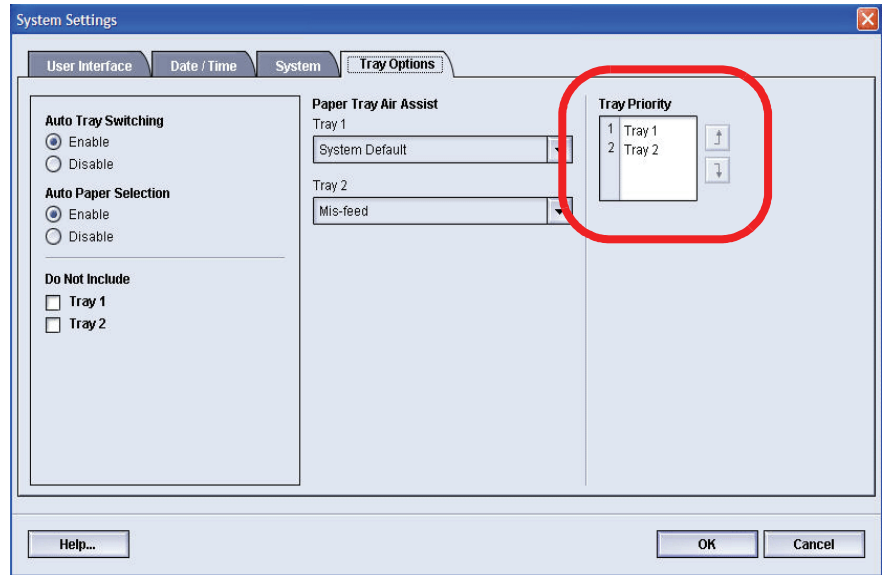
The options include the following:

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

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

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

Tray Priority



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



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

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

3. Profiles

Overview

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



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

Alignment

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

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



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

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

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



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

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

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

Alignment Adjustment Profile procedure



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

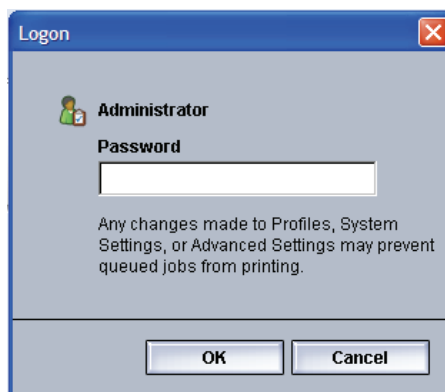


NOTE: If you require a Custom Paper Profile associated with this Alignment Profile, you can set the Custom Paper Profile information either now or after you create the Alignment Profile.

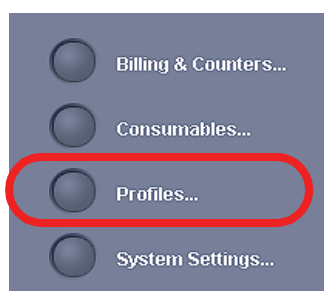
1. Select the Logon button from the main UI window.



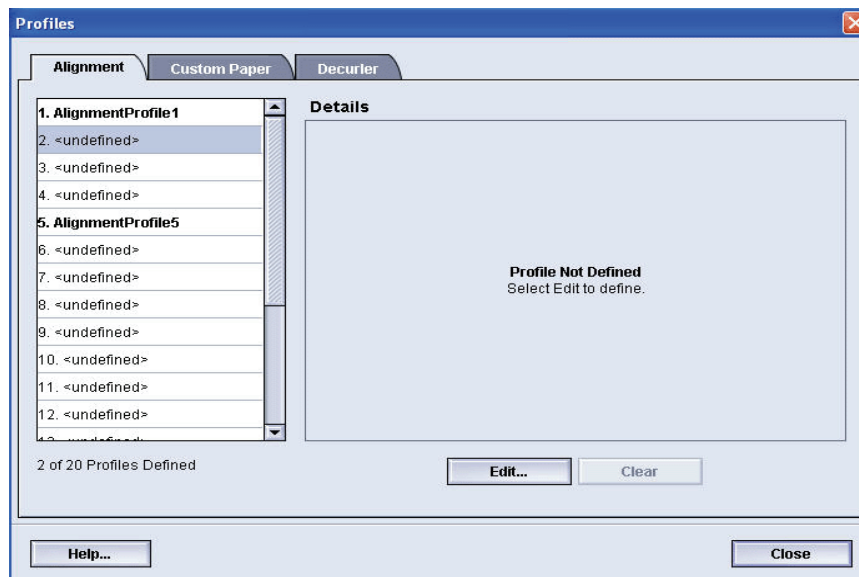
2. From the Logon window, enter the Administrator password and select **OK**.



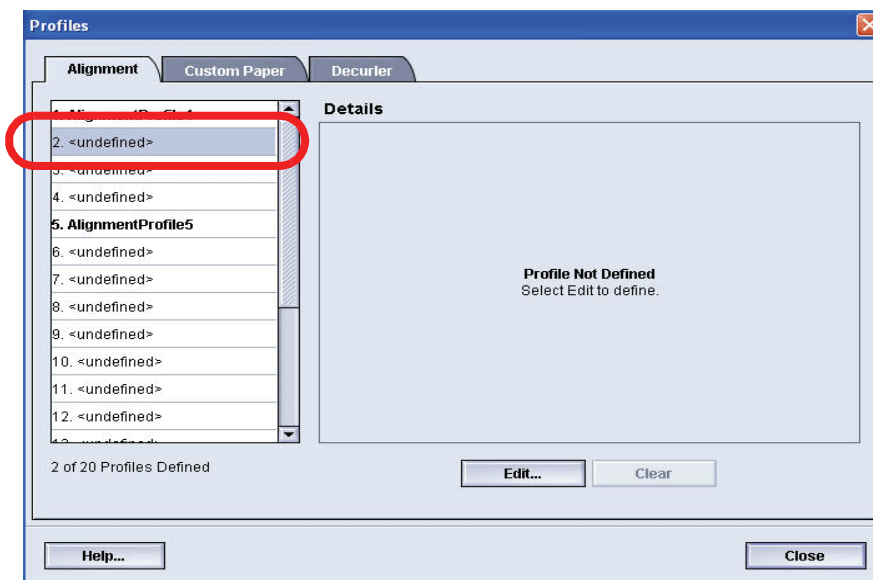
3. Select the Profiles button.



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

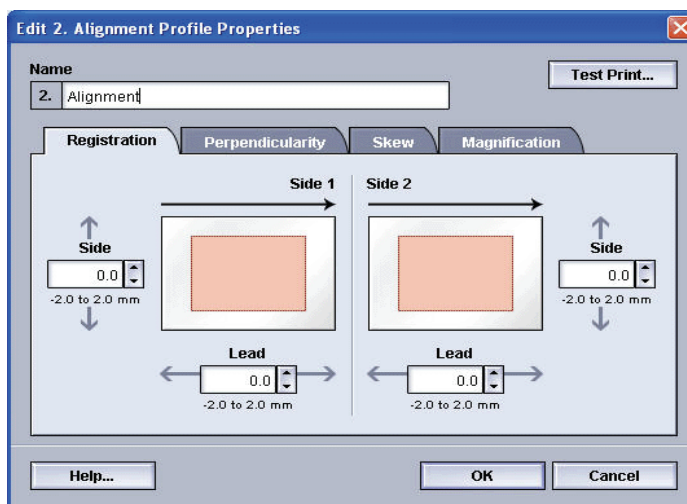


5. To create a **new** alignment procedure, select a undefined profile.



If you are editing an existing profile, go to Step 6.

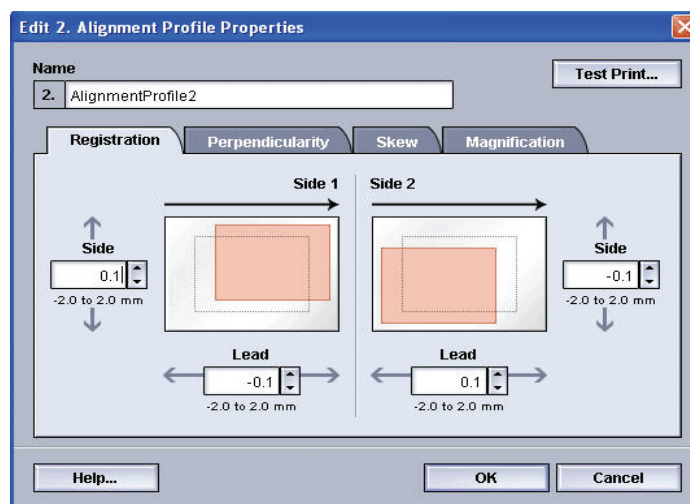
6. Click the Edit button; the Alignment Profile Properties window opens.



7. Type a name for this profile (the example in this procedure uses the name "AlignmentProfile2").
8. Next: [Selecting the Registration options.](#)

Selecting the Registration options

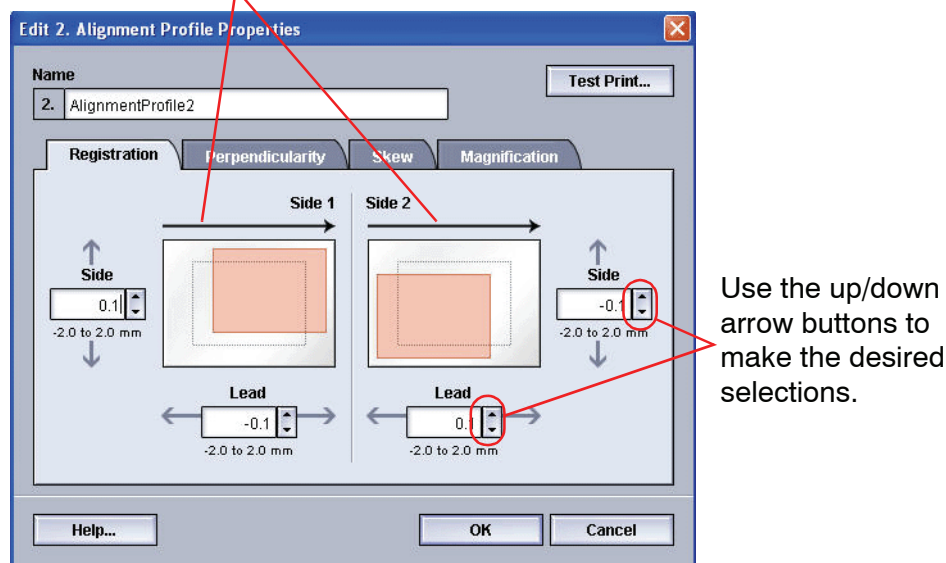
9. Make the desired selections to the Registration option.



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

The factory default setting is zero (0).

These arrows indicate the paper feed direction



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

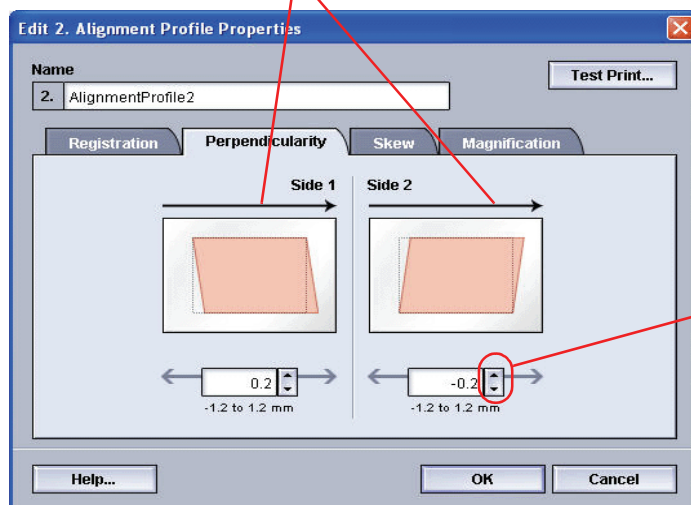
10. Next: [Selecting the Perpendicularity options](#).

Selecting the Perpendicularity options

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

The factory default is zero (0).

These arrows indicate the paper feed direction



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

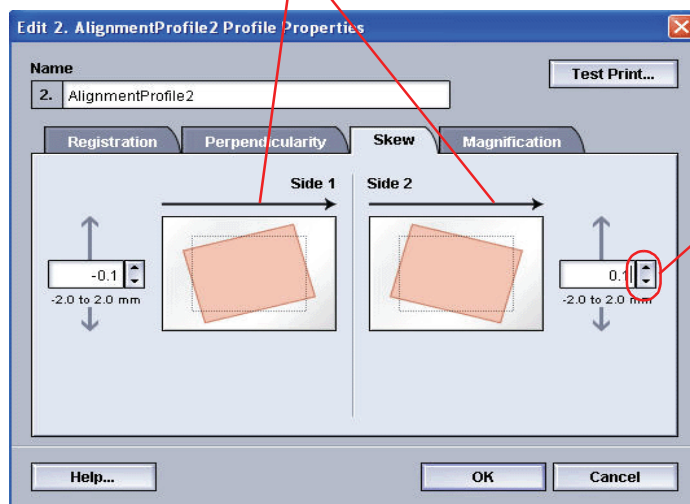
- 12.** Next: [Selecting the Skew options.](#)

Selecting the Skew options

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

The factory default is zero (0).

These arrows indicate the paper feed direction



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

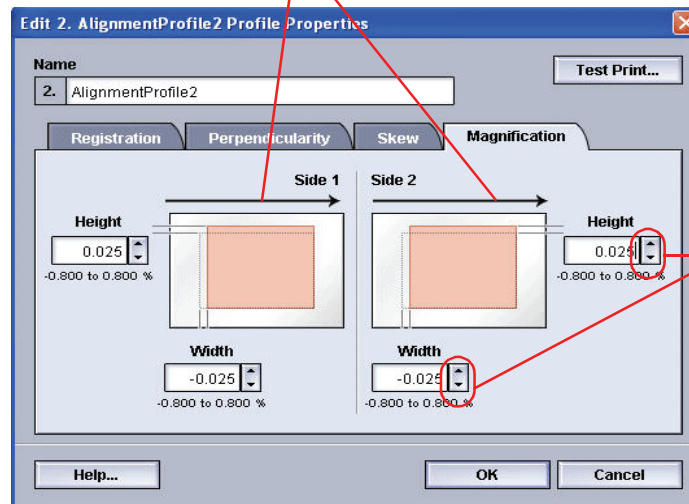
- 14.** Next: [Selecting the Magnification options.](#)

Selecting the Magnification options

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

The factory default is zero (0).

These arrows indicate the paper feed direction



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

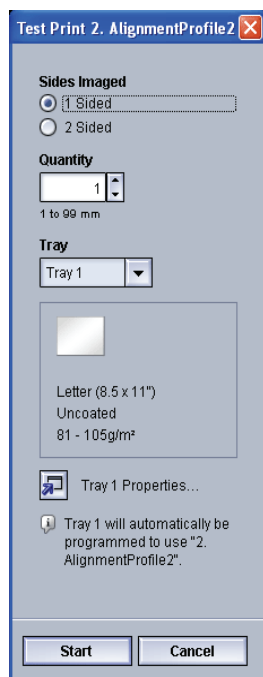


TIP: It is recommended that you choose only one Alignment Profile feature (such as Registration), and then run a set of Test Prints to evaluate the registration on that output. If you want multiple Alignment Profile features selected, individually select each feature, run Test Prints for that feature,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

- 16.** Next: [Running test prints.](#)

Running test prints

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

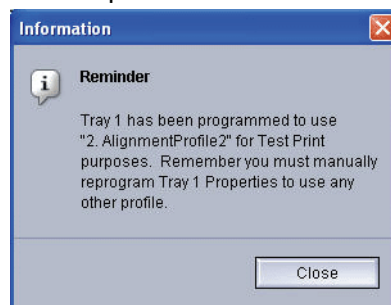


- a. Select the **2 Sided** button.



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

- b. Select **10** test prints by clicking the **Up** arrow button to change the number of test prints generated.
- c. Select the desired paper tray from the pull-down list.
- d. If necessary, select the Tray Properties button and make any desired settings.
- e. Select Start. The UI displays this message after the test prints are printed:



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

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

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



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

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



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

19. If you are editing an existing Alignment profile:

- a. From the Profiles window, Alignment tab, select the desired profile.
- b. Click the Edit button.
- c. Repeat this procedure starting at [Selecting the Registration options](#).

Custom Paper

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

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

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



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

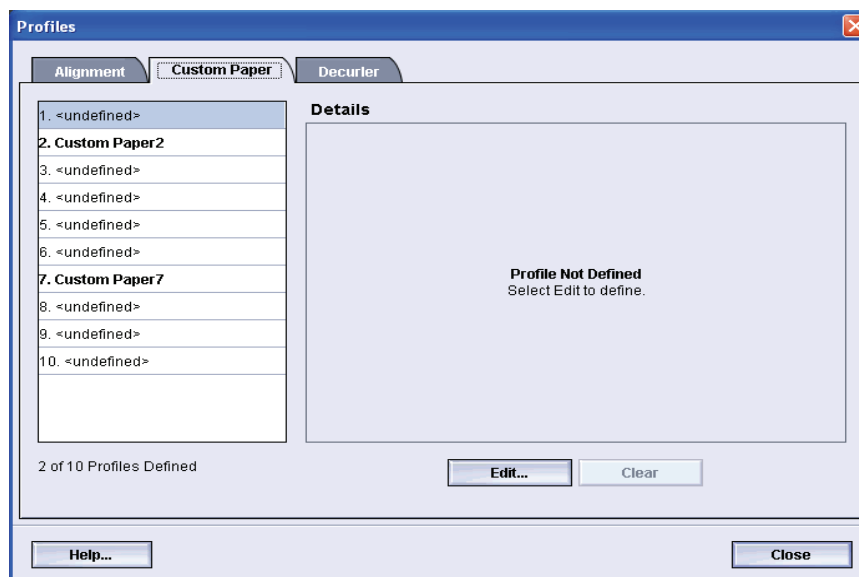
NOTE 2: Adjusting registration for Side 1 and/or Side 2 images is discussed in detail in the Alignment feature. Refer to the Alignment feature.

Custom Paper procedure

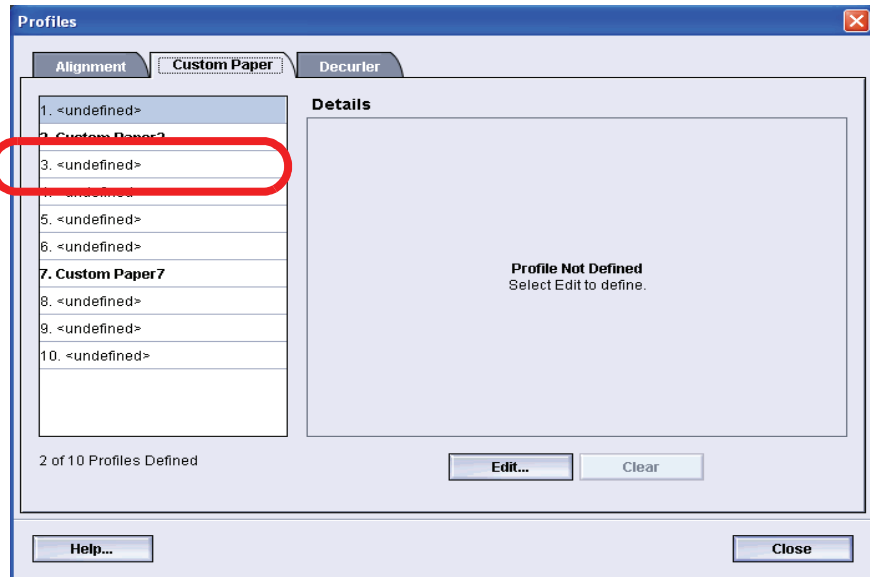


Use the following procedure for creating/modifying a Custom Paper Profile.

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

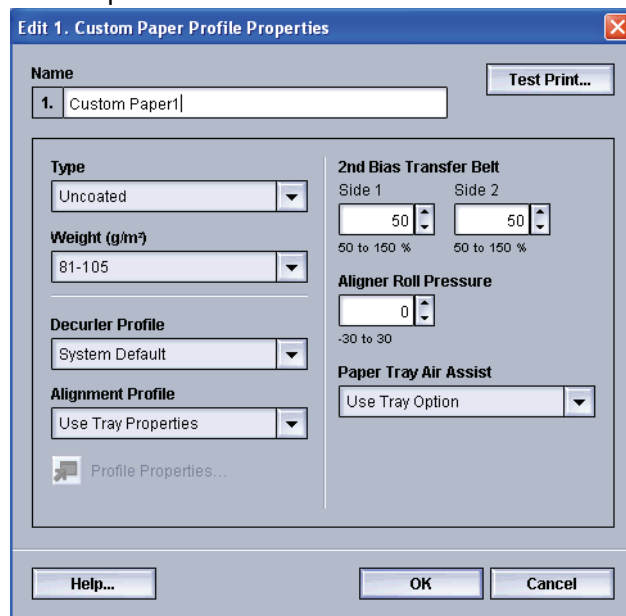


2. To create a **new** custom paper procedure, select a undefined profile.



If you are editing an existing profile, go to Step 4.

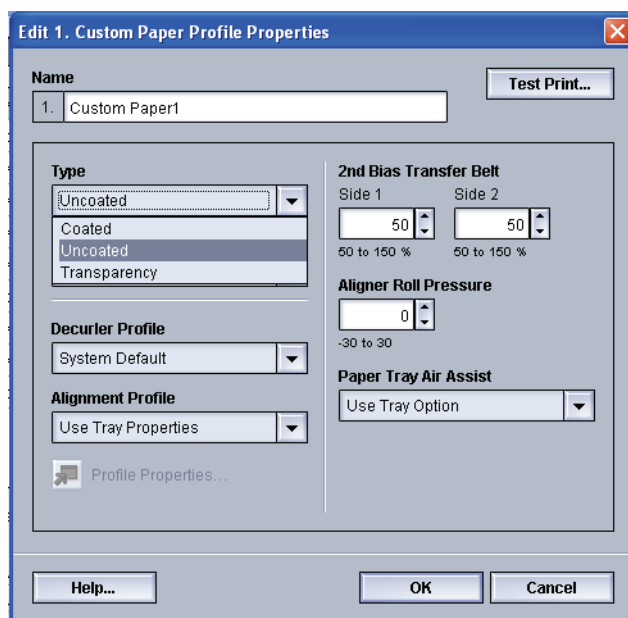
3. Click the Edit button; the Custom Paper Profile Properties window opens.



4. Type a name for this profile (the example in this procedure uses the name "Custom Paper1").
5. Next: [Selecting the desired paper type.](#)

Selecting the desired paper type

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



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

7. Next: [Selecting the desired paper weight.](#)

Selecting the desired paper weight

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

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



TIP: The default setting is System Default. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints. Test Print is discussed in more detail in Step 16.



NOTE: Use the Decurler feature in order to compensate for paper curl in your output prints. For Decurler information, refer to page 3-26.

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

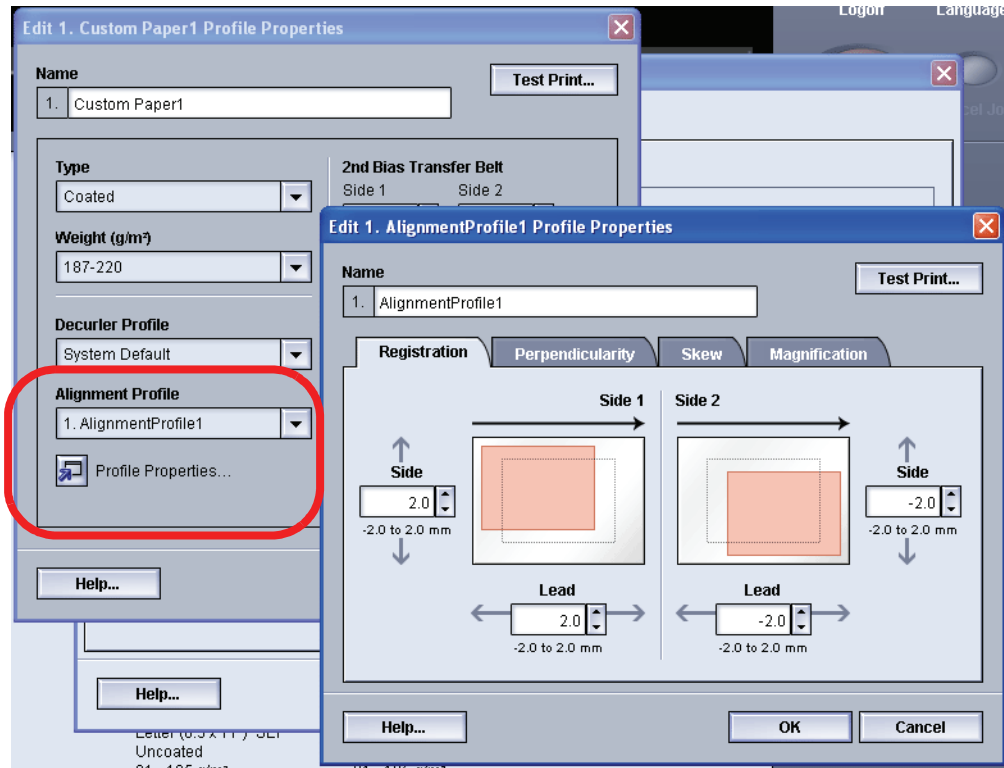


TIP: The default setting is Use Tray Properties. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints. Test Print is discussed in more detail in Step 16.

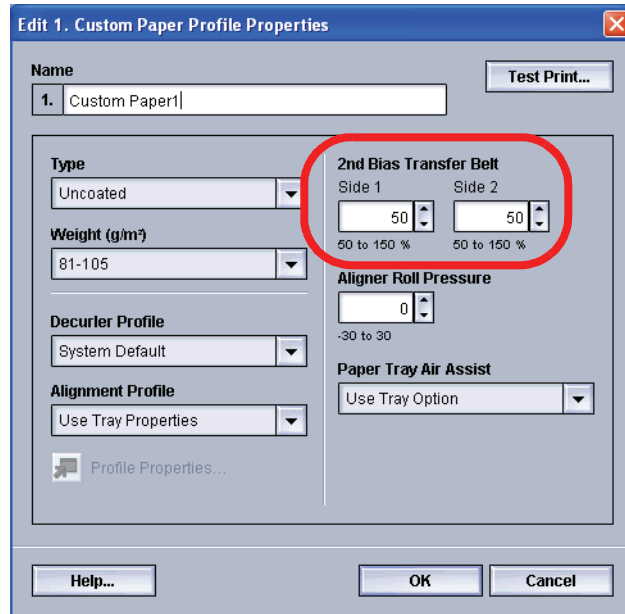


NOTE: If you select a specific Alignment Profile, the Profiles Properties button becomes accessible. By clicking on this button, the UI opens the Alignment Profile window for the selected profile, and you can edit that Alignment Profile if necessary.

NOTE: For Alignment information, refer to page 3-1.



- 11.** If required, choose 2nd Bias Transfer Roll settings for Sides 1 and 2.



TIP: The default setting for both Sides 1 and 2 is 100%. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints. Test Print is discussed in more detail in Step 16.



NOTE: Refer to page 3-20 for information on the 2nd Bias Transfer Belt.

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

Edit 1. Custom Paper Profile Properties

Name: 1. Custom Paper1 [Test Print...]

Type: Uncoated

Weight (g/m²): 81-105

Decurler Profile: System Default

Alignment Profile: Use Tray Properties

2nd Bias Transfer Belt

Side 1: 50 (50 to 150 %)

Side 2: 50 (50 to 150 %)

Aligner Roll Pressure: 0 (-30 to 30)

Paper Tray Air Assist: Use Tray Option

[Help...] [OK] [Cancel]



TIP: The default setting is 0. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints. Test Print is discussed in more detail in Step 16.



NOTE: Refer to page 3-24 for information on the Aligner Roll Pressure.

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

Edit 1. Custom Paper1 Profile Properties

Name: 1. Custom Paper1 [Test Print...]

Type: Coated

Weight (g/m²): 187-220

Decurler Profile: System Default

Alignment Profile: Use Tray Properties

2nd Bias Transfer Belt

Side 1: 50 (50 to 150 %)

Side 2: 50 (50 to 150 %)

Aligner Roll Pressure: 0 (-30 to 30)

Paper Tray Air Assist: Use Tray Option

- Use Tray Option
- System Default
- Multi-Sheet Feed
- Mis-feed
- Custom
- Always Off
- Always On (Thin Paper)
- Always On (Thick Paper)

[Help...] [OK] [Cancel]

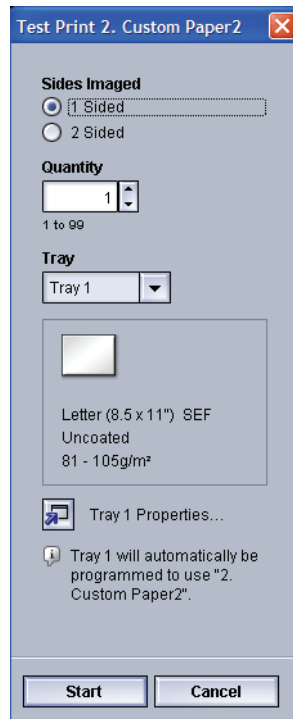


TIP: The default setting Use Tray Option. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints. Test Print is discussed in more detail in Step 16.



NOTE: Refer to page 3-25 for information on the Paper Tray Assist.

- 14.** Load your custom paper in the desired paper tray.
- 15.** Ensure that you select the correct paper information in the Tray Properties window (size, weight, type). From the Type pull-down menu, select the correct Custom Paper Profile.
- 16.** Select the **Test Print** button; a new window opens.



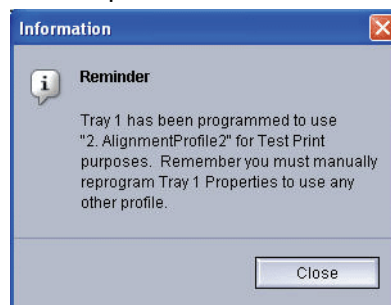
- a. Select the **2 Sided** button.



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

- b. Select **10** test prints by clicking the **Up** arrow button to change the number of test prints generated.
- c. Select the desired paper tray from the pull-down list.
- d. If necessary, select the Tray Properties button and make any desired settings.

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



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

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

- a. If you determine that further custom paper adjustments are required, repeat this procedure starting at [Selecting the desired paper type](#).



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

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

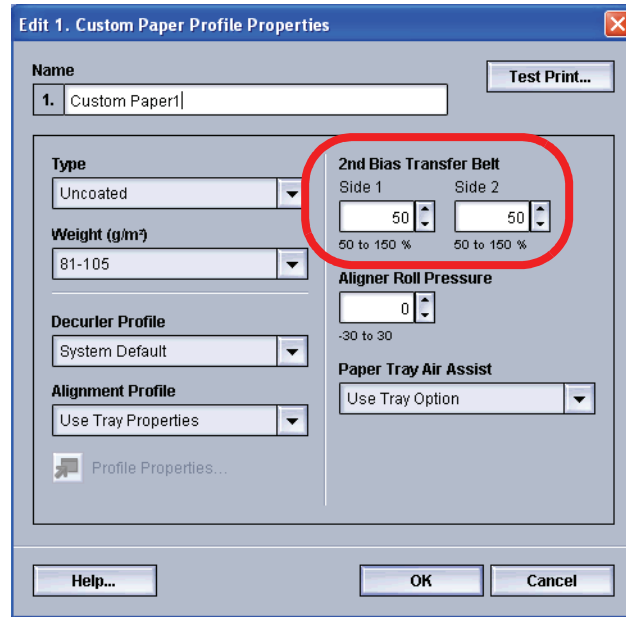


NOTE: Once you have selected OK to save and close the Profiles window, the new profile procedure (for example, Custom Paper1) can be selected from the Tray Properties window, the Type feature, whenever you want to run a job using this profile.

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

- a. From the Profiles window, Custom Paper tab, select the desired profile.
- b. Click the Edit button.
- c. Repeat this procedure starting at [Selecting the desired paper type](#).

Second Bias Transfer Belt



The Second Bias Transfer Belt is where the image is transferred from the belt to the paper. The Second Bias Transfer Belt feature is normally used with heavier weight paper, such as 220 g/m² and greater, 10 pt, or 12 pt, which are just three examples; however there are times when it is also used with lighter weight paper as well.

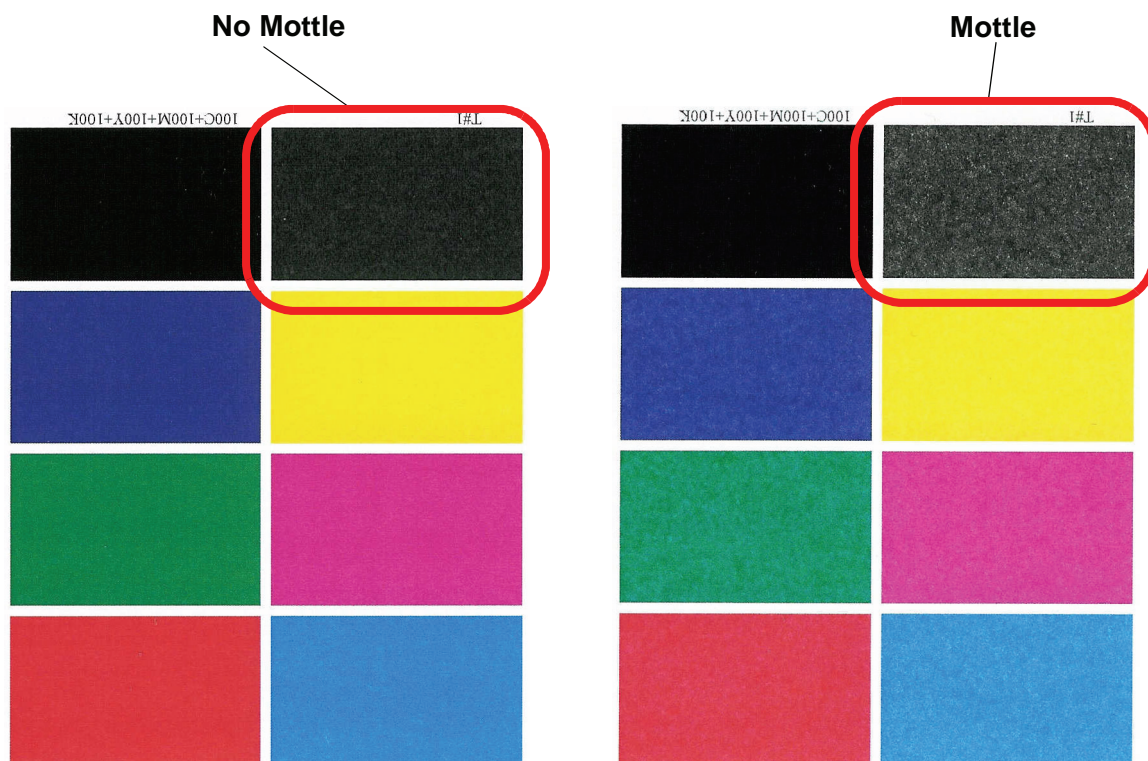


When using either heavier or lighter weight paper, you may want or need to adjust Side 1 for all 1-sided jobs. If defects continually occur in a printed job when using heavier weight paper, perform the following steps to determine if a Custom Paper Profile with Side 1 or Side 2 (2nd Bias Transfer Belt)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

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

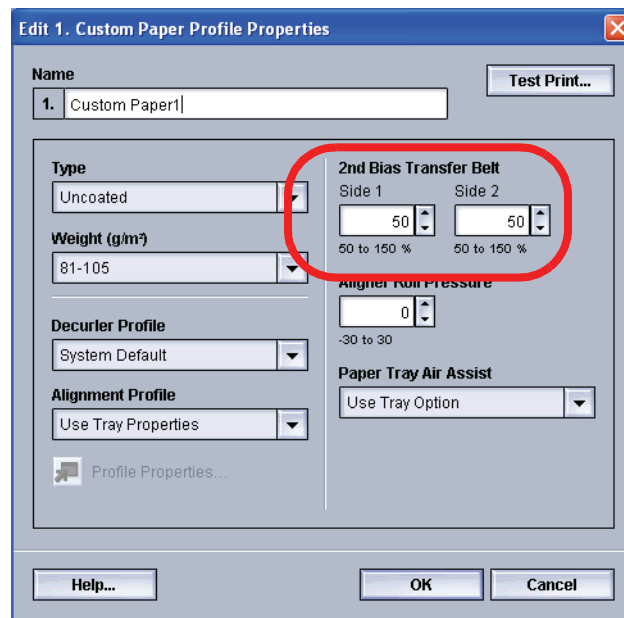
3. Use the 2nd Bias Transfer Belt feature when your:

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

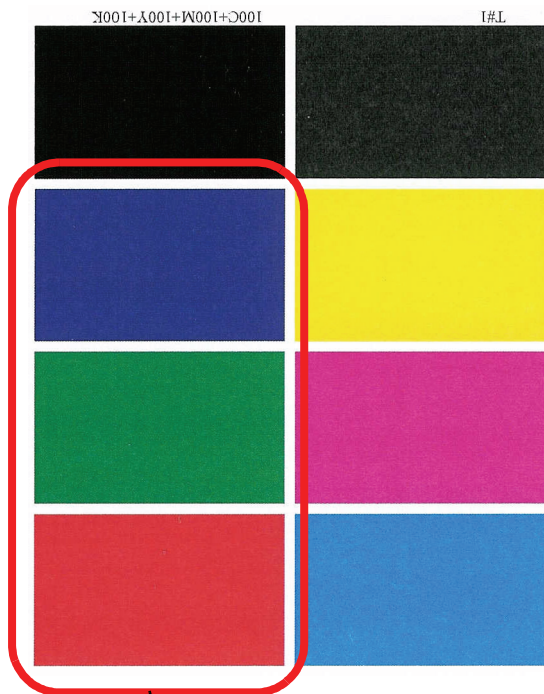


If mottle exists and it is heavy weight paper, **increase** one or both of the 2nd BTB values.

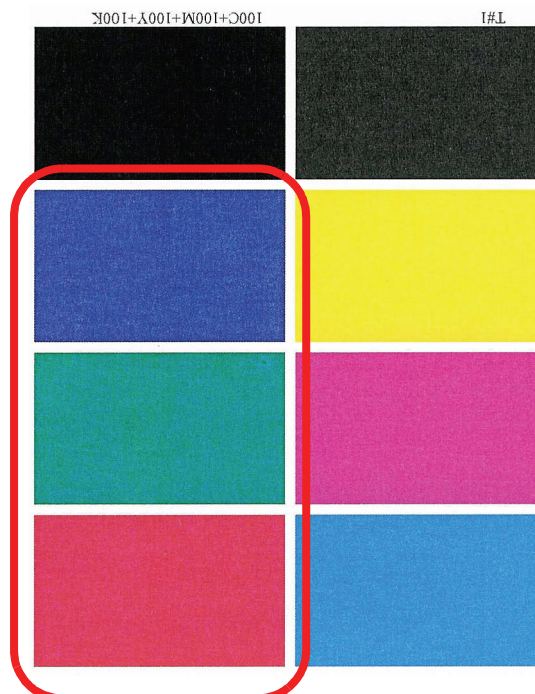
If mottle exists and it is light weight paper, **increase** one or both of the 2nd BTB values. Evaluate the image quality. If the image quality is equal to or worse than the 100% default setting, decrease one or both of the 2nd BTB values until a satisfactory image quality is obtained.



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

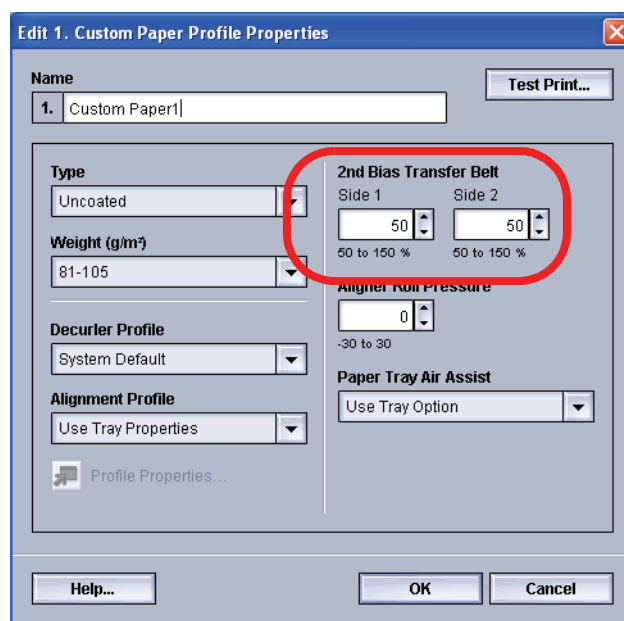


This test pattern represents an output with the desired colors.



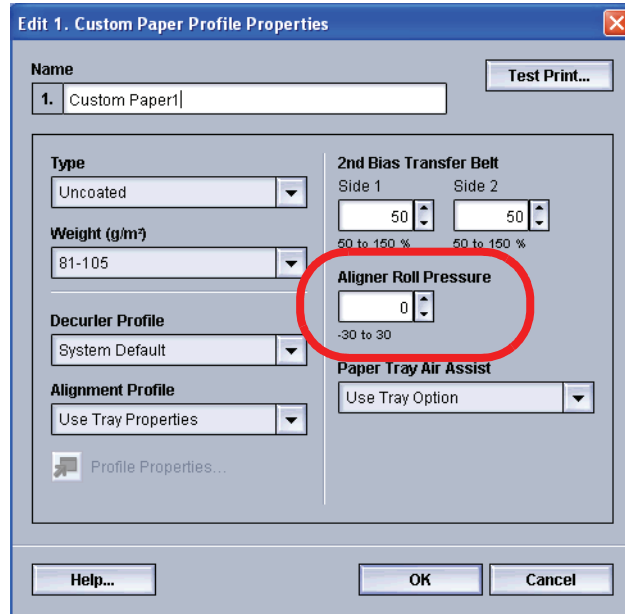
This test pattern represents an output with a shift in colors, and thereby an undesired output.

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



Aligner Roll Pressure

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



Examples:

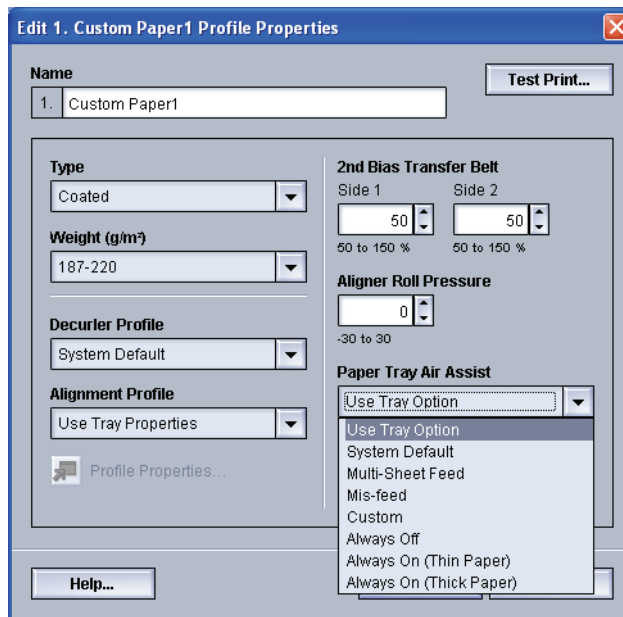
- Some coated paper types slip and skew, thereby misregistering the image on the output prints. In this case, you may want to increase the roll pressure in order to compensate for the slippage and skewing.
- Some light-weight papers may have too much roll pressure applied to them, thereby causing edge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



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

Paper Tray Air Assist

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



NOTE: The default setting is Use Tray Option.



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

Decurler Overview



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

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

Paper curl is caused by many variables, including:

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

Your system is designed with several automated settings to control curl. When using these settings the machine automatically sends paper through the proper Decurler:

- System Default: Automatically determines the amount of pressure needed at the different decurlers in order to reduce the output curl of the paper.
- A, B, C, and D settings: Preset Decurler settings.

With some print jobs, the output prints still may be curled more than you desire even after using the Decurler A-D Settings. In those cases, use the Custom Decurler Profile feature to compensate for paper curl in your prints. Custom Decurler Profile settings are based on job type and image density ratio. These settings are manually entered.



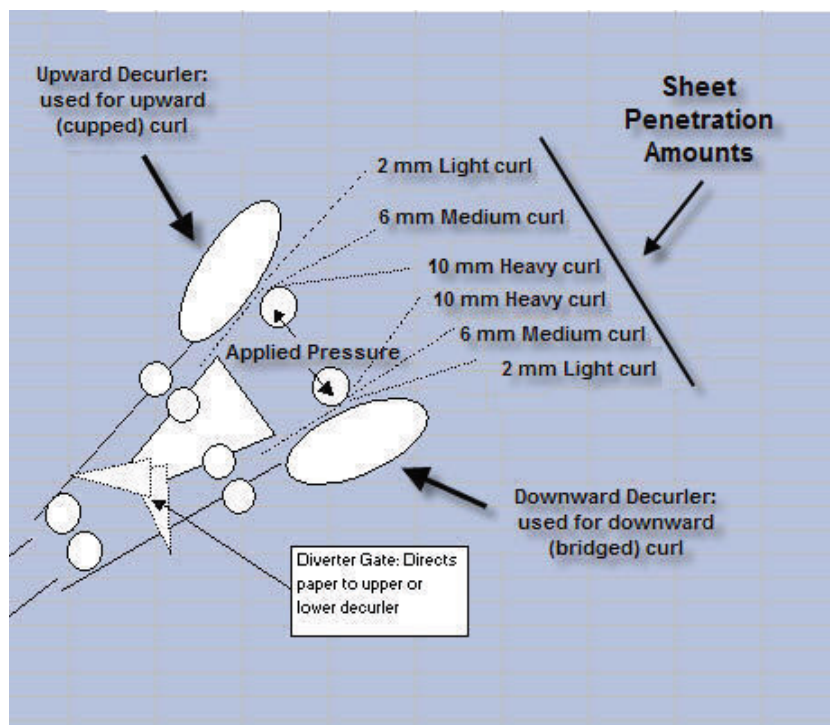
NOTE: *If a decurler profile is changed, it remains at that setting until changed again manually. As an example, if you decide to use the B decurler setting, the setting will remain at B until you change it to another setting.*



NOTE: *It is important to remember that a successful decurler setting used today may not be the same setting that you would use on another day. This is especially relevant if the room in which printer is located experiences changes in temperature and humidity.*

Decurler paper path

The Decurler has both upper and lower adjustment arms that apply pressure to the paper based on system defaults, selections made on the Tray Properties screen (A-D settings), or based on entries made on the Decurler Profile screen. The degree of pressure is applied independently to the upward and downward Decurler arms.



Decurler A-D Profile settings

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

Visit the www.xerox.com web site and refer to the latest **Recommended Materials List** (RML) for your digital press:

- To determine if Xerox has tested your paper type and weight
- View the recommended Decurler A - D Profile settings for particular paper types.



NOTE: The settings recommended in the in the “Recommended Materials List for DocuColor 5000” were developed from testing a wide range of paper samples, toner area coverages, and environments. The outcome of this testing is the preset parameters shown in the list, and these parameters refer to how particular papers interact with the digital press decurling system.

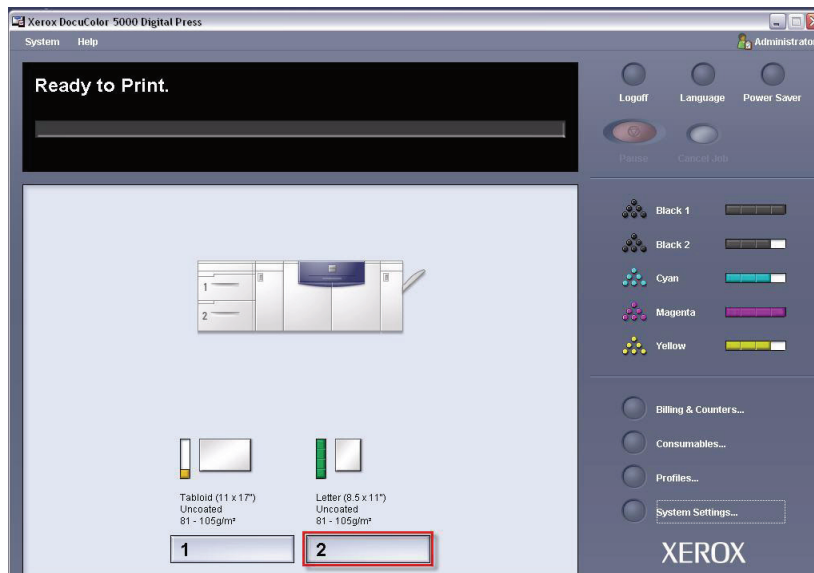
Decurler A-D Profile procedure



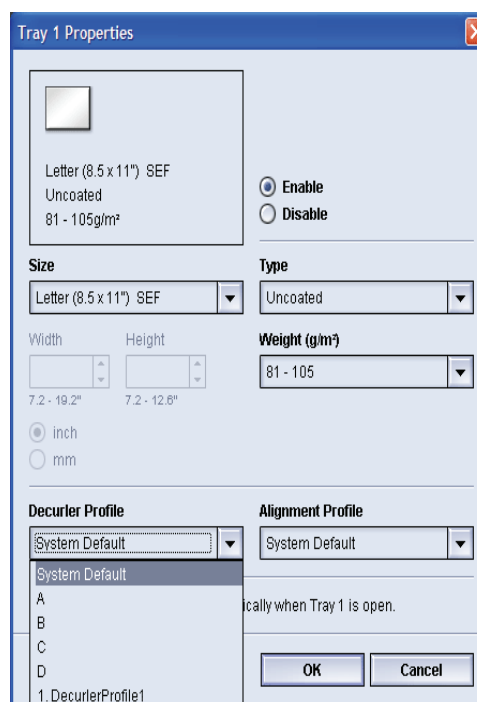
If after using the System Default setting paper curl is still unacceptable, select an alternate Decurler Type A - D Profile setting:

1. At the controller, logon as Administrator.
 - a. Select the Logon button.
 - b. Select Administrator and enter a password.
 - c. Select [OK].

2. To use an A-D Profile, select the Tray button that contains the stock that you are using for your job. In this exercise, select Tray 2. The Tray Properties window opens.



3. From the Decurler Profile menu, select one of the Decurler A-D settings.



4. Select [OK].
5. Run the same print job again, and retrieve the output from the exit area of the digital press.

6. Check the output for curl.
 - a. If the curl is eliminated, you are finished. Continue running your prints using the specific Decurler A-D setting.
 - b. If the curl is still persistent, try another Decurler Paper Type (A-D).
 - c. If the curl continues after using **each** Decurler Paper Type A-D setting, continue to the Custom Decurler Profile procedure.



NOTE: *If a decurler profile is changed, it remains at that setting until changed again manually. As an example, if you decide to use the B decurler setting, the setting will remain at B until you change it to another setting.*

Custom Decurler Profiles

While the system is programmed to correct for curl under most conditions, there may be instances where the pre programmed settings (System Default and A-D) may not meet your curl requirements. Using Custom Decurler Profiles allows you to enter an image density ratio range to help eliminate curl.



NOTE: *The examples that follow are designed to give you an understanding of programming the Custom Decurler Profile option to obtain optimal results, but due to various job stock and environmental conditions the manner in which you achieve the best results may vary.*

The most important aspect for creating a Custom Decurler Profile is determining the image density ratio on the curled paper. A sampling of image density ratio on some typical customer documents follows.



NOTE: The following image density ratios have been measured using appropriate devices. If you do not have access to devices that measure image density ratios, make your estimate using the following examples as a guide. Your estimates will be used when entering Custom Decurler Profile values, which is explained later in this section.

Image Density Ratio examples


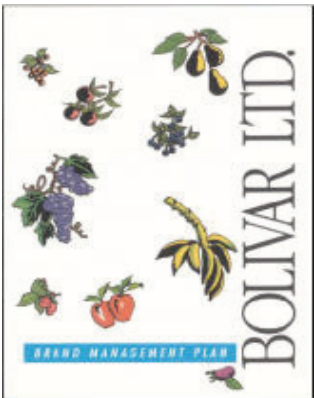




Carousel Horses		Bolivar Ltd.		Dunn Report	
					
Image Density Ratio per Color		Image Density Ratio per Color		Image Density Ratio per Color	
Black	30.5%	Black	5.4%	Black	10.8%
Magenta	28.1%	Magenta	4.3%	Magenta	8.5%
Cyan	23.8%	Cyan	6.0%	Cyan	8.5%
Yellow	29.5%	Yellow	6.7%	Yellow	7.2%

Image Density Ratio examples (continued)					
Upholstery by Morris		Alpine Nursery		Tulips	
					
Image Density Ratio per Color		Image Density Ratio per Color		Image Density Ratio per Color	
Black	11.6%	Black	4.5%	Black	27.8%
Magenta	11.9%	Magenta	5.1%	Magenta	24.7%
Cyan	11.1%	Cyan	4.3%	Cyan	23.8%
Yellow	11.4%	Yellow	6.0%	Yellow	28.8%

Determine if curl is upward (“cupped”) or curled downward (“bridged”).



Light, Medium and Heavy curl refer to the 2 mm (Light), 6 mm (Medium) and 10 mm (Heavy) curl selections in the Downward and Upward fields of the Custom Decurler Profile window.

Profiles

Alignment Custom Paper **Decurler**

1. Decurler

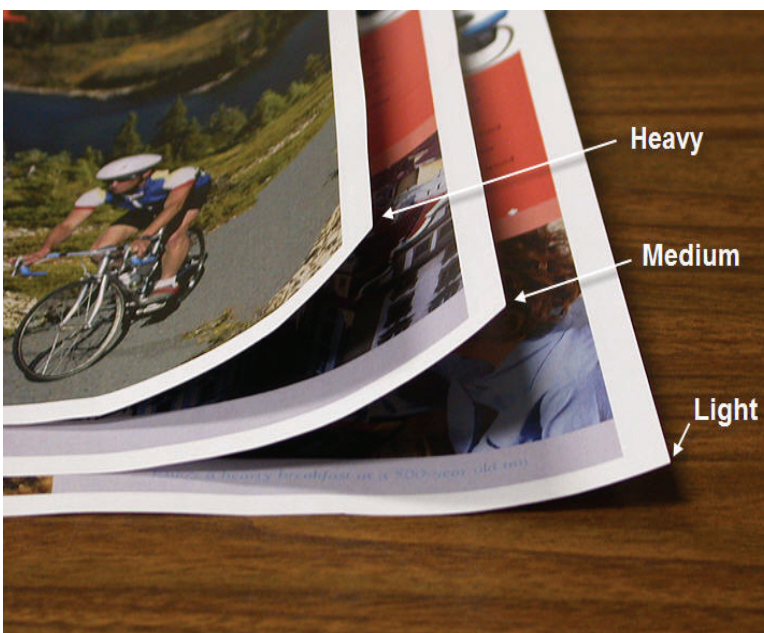
6 of 6 Profiles Defined

All Weights Rated Speed	Downward			Upward		
	Heavy	Medium	Light	Medium	Heavy	
	10 mm	6 mm	2 mm	2 mm	6 mm	10 mm
1 Sided: Face Up	100%	100%	100%	100%	100%	100%
1 Sided: Face Down	100%	100%	100%	100%	100%	100%
2 Sided: Face Up	100%	100%	100%	100%	100%	100%
2 Sided: Face Down	100%	100%	100%	100%	100%	100%
2 Sided	100%	100%	100%			
Mixed Paper Weight						
1 Sided: Face Up	100%	100%	100%	100%	100%	100%
1 Sided: Face Down	100%	100%	100%	100%	100%	100%
2 Sided: Face Up	100%	100%	100%	100%	100%	100%
2 Sided: Face Down	100%	100%	100%	100%	100%	100%
2 Sided	100%	100%	100%			

Edit... Clear

Help... Close

Use the following example as a guide when determining if your curl is Light, Medium, or Heavy.



Entering values in the Custom Decurler Profile fields




IMPORTANT! It is important to understand that when entering image density ratio values within the Decurler Profile Properties window that the maximum allowed entry is 100%.

When determining what values to enter, do not total all CMYK image density ratios, but instead determine the largest CMYK image density ratio value. Take a look at the following examples for further explanation:

- If your job contains image density ratios of 100% cyan, 100% magenta, 100% yellow, and 100% black, the maximum image density ratio value is 100%. If your job contains 100% cyan, 20% magenta, 20% yellow, and 20% black, the maximum value is still 100%.
- If your job contains image density ratios of 50% cyan, 50% magenta, 50% yellow, and 50% black, the maximum image density ratio value is 50%. If your job contains 50% cyan, 10% magenta, 10% yellow, and 10% black, the maximum value is still 50%.
- Consider the Carousel Horses image density ratios shown below. When entering image density ratio values to control curl, you will use the black 30.5% value, not the combined total of all CMYK values.

Image Density Ratios

Carousel Horses	
	
Black	30.5%
Magenta	28.1%
Cyan	23.8%
Yellow	29.5%

Within the Decurler Profile Properties window, you must enter Decurler values in ascending or descending order. If you do not enter values in ascending or descending order, the following screens display, which informs you to reenter the values correctly. In the following example, 100% was followed by 80% and 90%, respectively. The correct sequence would need to be 100%, followed by 90% and then 80%. The conflicting values are highlighted in red.

The exercise on the following pages will show you an example of how to enter Decurler values correctly.

Edit 6. Decurler Profile Properties

Name: 6. Decurler

	Downward			Upward		
	10 mm	6 mm	2 mm	2 mm	6 mm	10 mm
All Weights Rated Speed						
1 Sided: Face Up	100%	80%	90%	0%	0%	0%
1 Sided: Face Down	100%	100%	100%	100%	100%	100%
2 Sided: Face Up	100%	100%	100%	100%	100%	100%
2 Sided: Face Down	100%	100%	100%	100%	100%	100%
2 Sided	100%	100%	100%			
Mixed Paper Weight						
1 Sided: Face Up	100%	100%	100%	100%	100%	100%
1 Sided: Face Down	100%	100%	100%	100%	100%	100%
2 Sided: Face Up	100%	100%	100%	100%	100%	100%
2 Sided: Face Down	100%	100%	100%	100%	100%	100%
2 Sided	100%	100%	100%			

Buttons: Help..., OK, Cancel

Error

Conflict(s) Detected

Values should progressively increase or decrease across the entire row.
Example: 0%, 15%, 45%, 65%, 85%, 100%

The row(s) indicated contain conflicts.
The conflicting values are highlighted in red color.

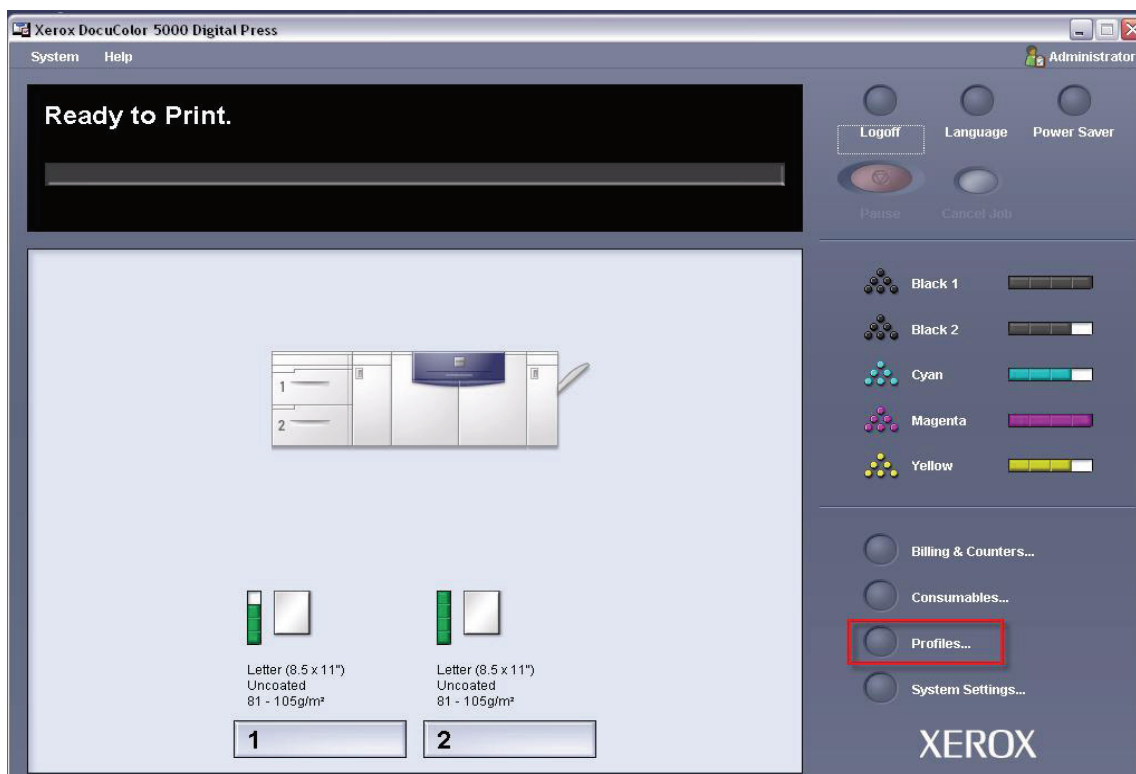
Close

Creating a Custom Decurler Profile

To program a Custom Decurler Profile, perform the following:

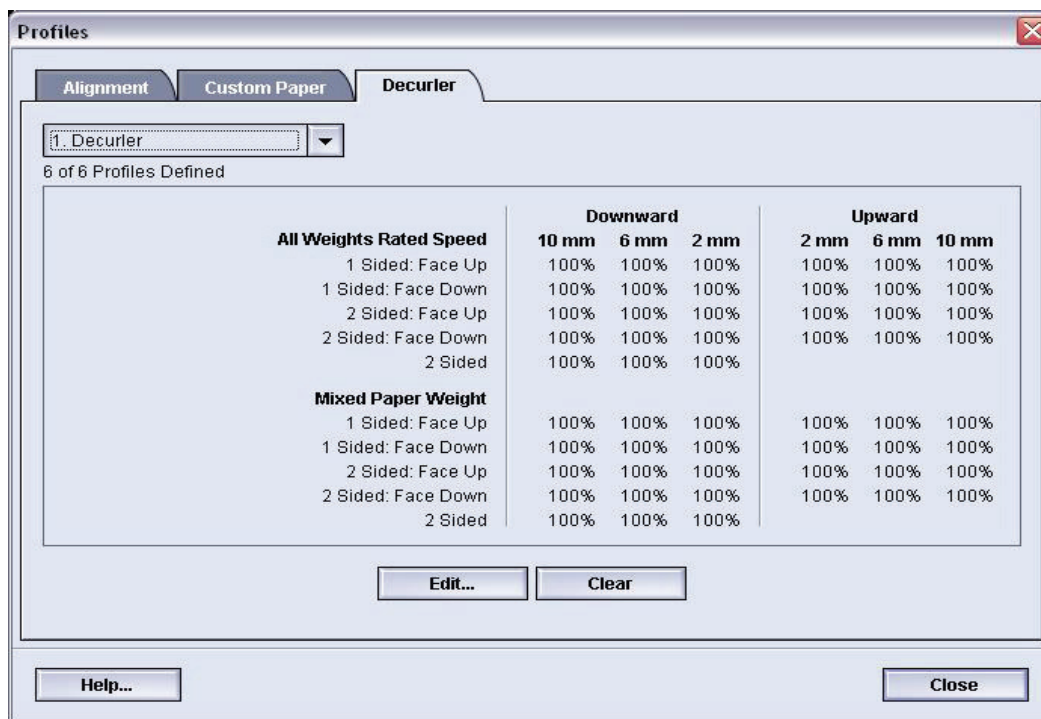


1. At the controller, logon as Administrator.
 - a. Select the **Logon** button.
 - b. Select Administrator and enter a password.
 - a. Select **[OK]**.
2. Select the **[Profiles...]** button.

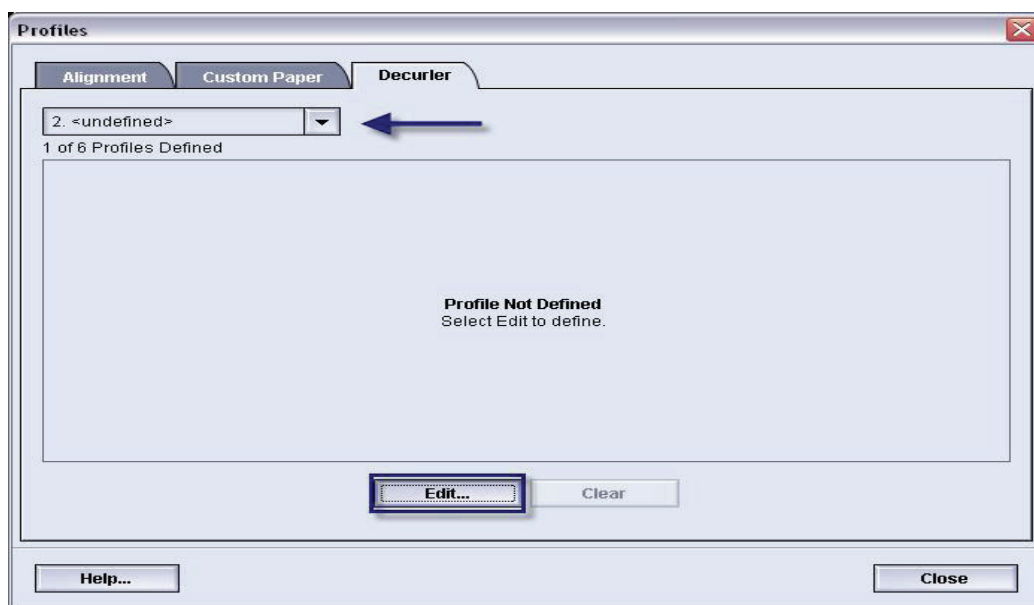


NOTE: You can create up to six different Custom Decurler Profiles.

3. From the Profiles window, select the Decurler tab.




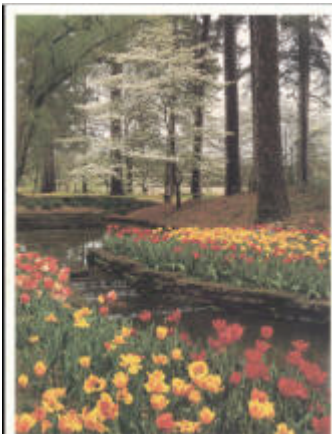
4. You can edit an existing Custom Decurler Profile or create a new one. For the following exercise you will create a new profile.
- From the Decurler drop-down menu, select <undefined>.
 - Select [**Edit...**] to define a new profile. The Decurler Profile Properties window opens.



5. In this example, you are running a 10-page, 1 Sided: Face Up job, which shows downward (bridged) curl. The job contains:

- Six pages with maximum image density ratio of 10.8% (Dunn Report) show light downward curl.
- Four pages with maximum image density ratio of 28.8% (Tulips) show medium downward curl.

Image Density Ratios

Dunn Report		Tulips	
			
Image Density Ratio per Color		Image Density Ratio per Color	
Black	10.8%	Black	27.8%
Magenta	8.5%	Magenta	24.7%
Cyan	8.5%	Cyan	23.8%
Yellow	7.2%	Yellow	28.8%

You have tried the System Default and the A through D settings, but curl remains. As a result, you need to program the Decurler to use the downward Decurler path to remove the downward (bridged) curl.



NOTE: Conversely, you would program the Decurler to use the upward Decurler path to remove upward (cupped) curl.



TIP: Paper that is curled *upwards* is adjusted using the **Upward** category values. Paper that is curled *downwards* is adjusted using the **Downward** category values.

6. In the Decurler Profile Properties window, you can give the Custom Decurler Profile a new name. In this example we rename the Custom Decurler Profile to Custom 1.
7. In the Decurler Profile Properties window, enter the following values in the All Weights Rated Speed, 1 Sided: Face Up fields:
 - Since your job shows downward curl, you do not want to use the Upward Decurler. As a result, in the **Upward** fields you must enter values in descending order, or in equal values less than 12% (the next value you will enter). For this exercise we will use 0%, 0% and 0%.
 - In the **Downward** 2 mm (Light curl) field enter 12%. This means that all pages with a 0% through 12% image density ratio, which includes the Dunn Report maximum of 10.8%, will be sent to the 2 mm downward Decurler path.
 - In the **Downward** 6 mm (Medium curl) field, enter 30%. This means that all pages with 13% to 30% image density ratio, which includes the Tulips 28.8%, will be sent to the 6 mm downward Decurler path.
 - In the **Downward** 10 mm (Heavy curl) field, enter 50%. Since none of your job pages have 31% through 50% image density ratio, this Decurler will not be used.



NOTE: Remember, all fields have to be considered (**Downward** and **Upward**) when entering Custom Decurler Profile values.

The following screen shows how the values would be entered:

Edit 2. Custom 1 Profile Properties

Name: 2. Custom 1

(50% - 31%) (30% - 13%) (12% - 0%) (0% - Decurler not used)

Downward			Upward		
10 mm	6 mm	2 mm	2 mm	6 mm	10 mm
50%	30%	12%	0%	0%	0%
100%	100%	100%	100%	100%	100%
100%	100%	100%	100%	100%	100%
100%	100%	100%	100%	100%	100%
100%	100%	100%			

All Weights Rated Speed

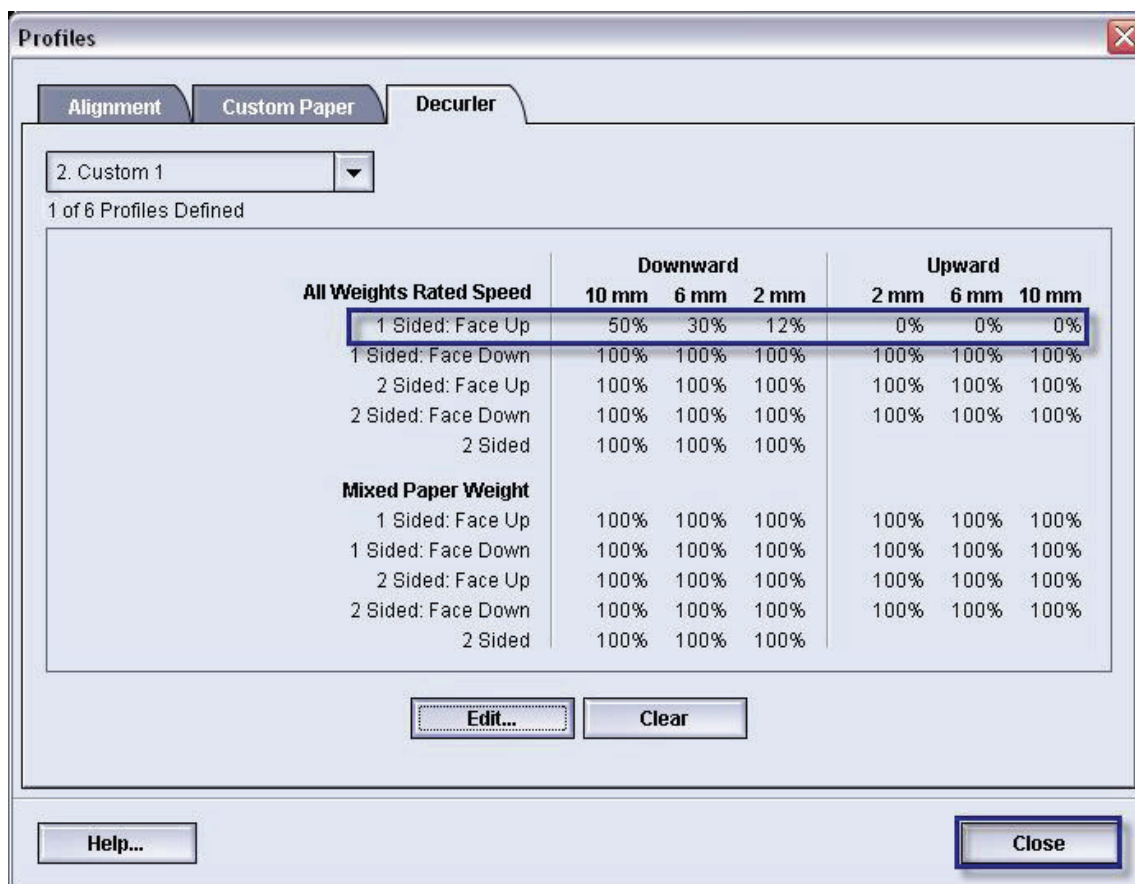
1 Sided: Face Up
1 Sided: Face Down
2 Sided: Face Up
2 Sided: Face Down
2 Sided

Mixed Paper Weight

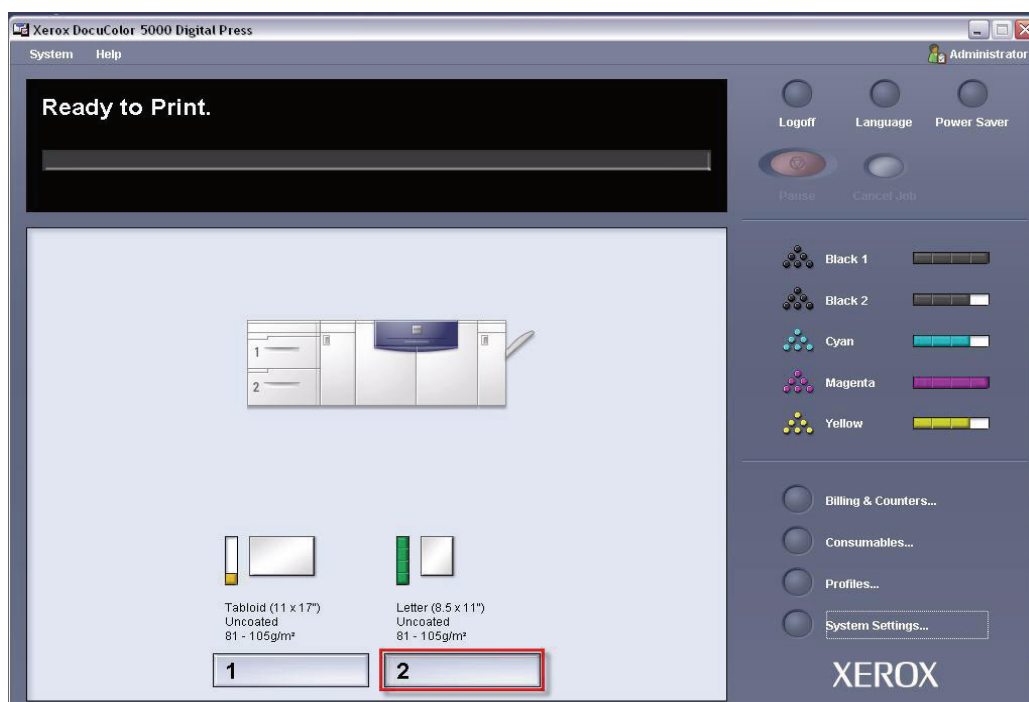
1 Sided: Face Up
1 Sided: Face Down
2 Sided: Face Up
2 Sided: Face Down
2 Sided

Help... OK Cancel

8. To save your Custom Decurler Profile, select **[OK]** after you have entered all required values. The Custom Profiles Properties window closes and the Profiles window displays.
9. Confirm that the values that you entered are correct in the Profiles window. Select **[Close]** to exit the window and save your profile.

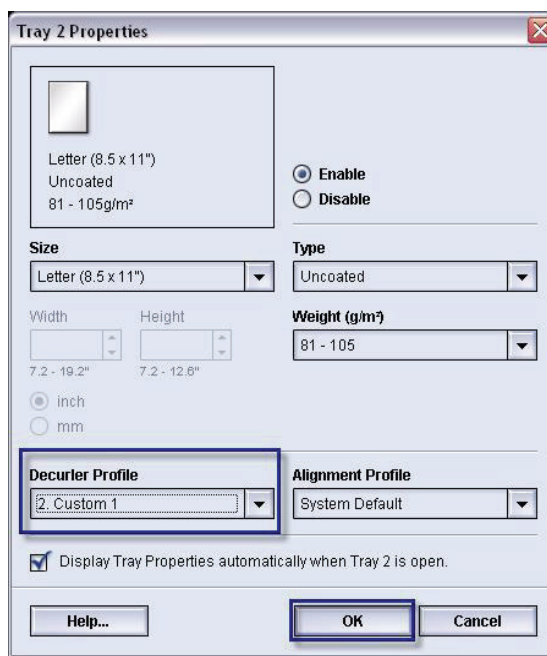


- 10.** To use the newly created Custom Decurler Profile, select the Tray button that contains the stock that you are using on your job. For this exercise, select Tray 2. The Tray Properties window opens.



- 11.** From the Decurler Profiles menu, select the Custom 1 profile you created.

- 12.** Select [OK] to activate the Custom 1 profile.



- 13.** Print your job and determine if the curl has been eliminated.
 - a. If the curl is eliminated in the new output stack, continue printing the job and you are finished.
 - b. If the curl remains, you may have to repeat this procedure and adjust the image density ratios entered in the Custom Decurler Profile window until you achieve acceptable output prints.
- 14.** If curl remains after trying various value entries in the Custom Decurler Profile window, call your Xerox service representative.



NOTE: *If a decurler profile is changed, it remains at that setting until changed again manually. As an example, if you decide to use the Decurler Profile named Custom 1, the setting will remain at Custom 1 until you change it to another setting.*

