

DCS 1224 Metric Lamination Settings		Page 1 of 2																		
April 14, 2004 Using Driver Version 134 and Firmware Version V306 or More Recent Versions																				
The Values Listed Below Are Starting Points Only. DCS Recommends Validating Different Materials In Each Operating Environment.																				
Due To Environmental & Manufacturers Tolerances, (Voltage Fluctuations, Gauge Variations, Etc.) Minor Adjustments																				
May Be Necessary For The Values Below To Achieve Optimum Lamination Quality.																				
DCS Recommends That If You Have Masked Material that Is Not Achieving Good Lamination Results, Please Try Cleaning The Surface With Alcohol As In																				
Different Environmental Conditions, Masking Can Sometimes leave A Residue Which Will Impede The Lamination Process Of The Image On The 1224 To The Substrate.																				
For Best Lamination Results, Power Up Printer For 15 Minutes Prior To Sending The First Print Job.																				
Material	Job Size	Thickness	Speed	Temperature	Bottom Heater	Notes														
	MM	MM	MM Per Second	Degree C	Duty Cycle %															
<b>ACRYLIC</b>																				
Chemcast Cell-Cast	200 x 250	3.300	5.100	210	80															
Acrylic (Acrylite+Plexiglas)	200 x 250	6.350	5.100	210	80															
Matte/Clear	200 x 300	1.520	5.720	204	80															
Matte/Clear	200 x 300	3.300	5.100	210	80															
DR	200 x 300	1.520	7.620	182	80	P														
<b>ALUMINUM DCS COATED</b>																				
	200 x 300	0.510	5.100	215	50	M, T, B, P														
<b>BRASS DCS COATED</b>																				
	150 x 300	0.510	5.100	215	50	M, T, B, P														
	200 x 300	0.510	5.100	215	50	M, T, B, P														
<b>LENTICULAR</b>																				
	200 x 300	2.032	6.350	185	50	W, B2														
<b>MAGNETIC (Vinyl Coated Only)</b>																				
Magnum Magnetic																				
	200 x 300	0.760	5.100	215	50	T, B, M														
	200 x 300	0.300	5.100	205	50	T, B, M														
<b>NOTES</b>																				
T = Tape The Lead Edge Of The Material To The Backing Material																				
M = Leave A 1 Inch Lead On The Material For Heat Sinking - Add Printed Black Rectangle To Sacrificial Area Across Leading Edge																				
B = Use Backing Material To Add Thickness (Plastic Recommended)																				
S = Use Metal Sled																				
W = Change Top Lam Wait To 250F/121C																				
P = Use 1/4" Piece Of Material On Exit Tray To Keep Material Flat While It Cools																				
T2 = Tape Trailing Edge																				
T4 = Tape All Edges																				
B2 = Use 2 Pieces of Backing Material																				

<b>DCS 1224 Metric Lamination Settings</b>						
						Page 2 of 2
<b>April 14, 2004 Using Driver Version 134 and Firmware Version V306 or More Recent Versions</b>						
The Values Listed Below Are Starting Points Only. DCS Recommends Validating Different Materials In Each Operating Environment.						
Due To Environmental & Manufacturers Tolerances, (Voltage Fluctuations, Gauge Variations, Etc.) Minor Adjustments						
May Be Necessary For The Values Below To Achieve Optimum Lamination Quality.						
DCS recommends that if you have masked material that is not achieving good lamination results, please try cleaning the surface with alcohol as in						
different environmental conditions, masking can sometimes leave a residue which will impede the lamination process of the image on the 1224 to the substrate.						
For best lamination results, power up printer for 15 minutes prior to sending the first print job						
<b>Material</b>	<b>Job Size</b>	<b>Thickness</b>	<b>Speed</b>	<b>Temperature</b>	<b>Bottom Heater</b>	<b>Notes</b>
	<b>MM</b>	<b>MM</b>	<b>MM Per Second</b>	<b>Degree C</b>	<b>Duty Cycle %</b>	
<b>POLYCARBONATE</b>						
Lexan 9600	200 x 200	0.800	5.100	215	50	T, B
Lexan	200 x 200	1.020	5.100	215	50	T, B
Lexan	200 x 200	1.520	5.100	210	90	
Lexan	200 x 200	3.300	5.100	215	90	
Lexan F2100	200 x 200	6.350	5.100	215	90	
<b>POLYESTER</b>						
Autotype (Autotex 2F6)	200 x 300	0.051	5.100	204	50	T, B, M, T2
<b>PVC (Rigid Sheet)</b>						
PVC .010"	300 x 300	0.254	6.350	199	50	T, B, M
PVC .030"	200 x 300	0.760	6.350	199	50	T, B, M
PVC .060"	200 x 250	1.520	6.350	199	50	P
<b>PVC (Expanded)</b>						
Sintra	200 x 300	3.300	6.350	193	80	
Sintra	300 x 600	3.300	6.350	193	50	W
Celtec	200 x 300	6.350	6.350	193	80	
Celtec	300x 600	3.300	6.350	193	50	W
<b>ROWMARK PRODUCTS</b>						
Mattes	200 x 300	1.600	5.720	199	80	
Mattes	200 x 600	1.600	6.350	199	50	W
Rowmark (2-228 Ivory/Brown)	200 x 300	1.600	5.590	204	80	
Satins	200 x 300	1.600	5.590	199	80	
<b>PRINTMARK PRODUCTS</b>						
Printmark 1 - 2 Ply	200 x 300	1.600	6.350	199	80	
Printmark 1 - 2 Ply	300x 600	1.600	6.350	199	50	W
Mono White	200 x 300	1.600	6.350	199	80	
<b>DCS Printmark 2</b>						
PM2 - Brushed Metals	200 x 600	1.320	6.350	199	50	W
PM2 - Brushed Metals	200 x 300	1.320	6.350	199	90	
PM2 Mono White	200 x 250	1.320	6.350	204	90	
<b>VINYL</b>						
Some Vinyl May Contain Plasticizers Which Would	200 x 300	0.102	7.620	176	50	S, B, M, T4
Degrade The Printed Image Over Time						
<b>NOTES</b>						
T = Tape The Lead Edge Of The Material To The Backing Material						
M = Leave A 1 Inch Lead On The Material For Heat Sinking - Add Printed Black						
Rectangle To Sacrificial Area Across Leading Edge						
B = Use Backing Material To Add Thickness (Plastic Recommended)						
S = Use Metal Sled						
W = Change Top Lam Wait To 250F/121C						
P = Use 1/4" piece of material on exit tray to keep Material flat while it cools						
T2 = Tape Trailing Edge						
T4 = Tape All Edges						
B2 = Use 2 Pieces of Backing Material						