



<b>DCS 1224 Imperial 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>Inches</b>	<b>Inches</b>	<b>Inches Per Second</b>	<b>Degree F</b>	<b>Duty Cycle %</b>		
<b>POLYCARBONATE</b>							
Lexan 9600	8 x 8	0.032	0.200	420	50	T, B	
Lexan	8 x 8	0.040	0.200	420	50	T, B	
Lexan	8 x 8	0.060	0.200	410	90		
Lexan	8 x 8	0.125	0.200	420	90		
Lexan F2100	8 x 8	0.250	0.200	420	90		
<b>POLYESTER</b>							
Autotype (Autotex 2F6)	8 x 12	0.002	0.200	400	50	T, B, M, T2	
<b>PVC (Rigid Sheet)</b>							
PVC .010"	8 x 12	0.010	0.250	390	50	T,B,M	
PVC .030"	8 x 10	0.030	0.250	390	50	T, B, M	
PVC .060"	8 x 10	0.060	0.250	390	50	P	
<b>PVC (Expanded)</b>							
Sintra	8 x 12	0.130	0.250	380	80		
Sintra	12 x 24	0.130	0.250	380	50	W	
Celtec	8 x 12	0.250	0.250	380	80		
Celtec	12 x 24	0.125	0.250	380	50	W	
<b>ROWMARK PRODUCTS</b>							
Mattes	8 x 12	0.063	0.225	390	80		
Mattes	8 x 24	0.063	0.250	390	50	W	
Rowmark (2-228 Ivory/Brown)	8 x 12	0.060	0.220	400	80		
Satins	8 x 12	0.063	0.220	390	80		
<b>PRINTMARK PRODUCTS</b>							
Printmark 1 - 2 Ply	8 x 12	0.063	0.250	390	80		
Printmark 1 - 2 Ply	8 x 24	0.063	0.250	390	50	W	
Mono White	8 x 12	0.060	0.250	390	80		
<b>DCS Printmark 2</b>							
PM2 - Brushed Metals	8 x 24	0.052	0.250	390	50	W	
PM2 - Brushed Metals	8 X 12	0.052	0.250	390	90		
PM2 Mono White	8 X 10	0.052	0.250	400	90		
<b>VINYL</b>							
	8 x 12	0.004	0.300	350	50	S, B, M, T4	
Some Vinyl May Contain Plasticizers Which Would 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							