



Customer Expectations Document (CED)

Xerox® 770 Digital Color Press



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Xerox® 770 Digital Color Press

Introduction and Overview

This document is intended to help you understand the performance and capabilities of the Xerox® 770 Digital Color Press (Henceforth “Xerox 770 Digital Color Press,” “Xerox 770,” or “X770”), including information on optional accessories. A separate Customer Expectations Document will be provided for the specific print server your machine is configured with. As indicated by the cover stamping, this document contains product specifications and other information that is proprietary to Xerox. The customer will use all reasonable efforts to safeguard the document, will not disclose its contents to third parties, and will only circulate it within the organization on a need-to-know basis.

All references to media capacity in this document are based on the Xerox 770 centerline paper. You will see the term “centerline paper” several times in this document. “Centerline paper” identifies the stock at the middle of the range of stocks that will deliver optimum performance for a given characteristic. Other paper weights and brands may alter performance (for example, paper tray capacities).

| Media Type | Xerox 770 Digital Press Centerline Paper |
|-----------------------|---|
| Uncoated paper | North America - Xerox Color Xpressions Plus (90 gsm/24 lbs) Europe – Colotech+ (90 gsm/24 lbs) |
| Coated paper | North America – Xerox Digital Color Elite Gloss 80# Text (120 gsm) Europe – Xerox Digital Color Elite Gloss 80# Text (120 gsm) |

Optimum Product Performance: Print Volume and Uptime

The Xerox 770 Digital Color Press is designed for an average monthly print volume range (AMPV Range):

| Press | AMPV Range | Conditions |
|--------------------------------------|-----------------|-------------------|
| Xerox 770 Digital Color Press | 20,000 – 75,000 | 8.5 in x 11 in/A4 |

The Xerox 770 is designed to produce a consistent uniform-looking color image and is designed to operate in the range of 20,000 – 75,000 copies or prints per month. The number of prints between service calls on a digital color printer is highly dependent on customer expectations of quality and the use of applications and throughput materials. At an average usage of 35,000 prints per month using centerline paper, it is expected that service will be required about once every 5 weeks.

Product Specifications

The following table contains the specifications for the performance of the Xerox 770 Digital Color Press:

| Item | Specification | Comments |
|--|---|---|
| Print Speeds | Refer to Print Engine Productivity Charts | |
| Paper weight range | 64-300 gsm Uncoated 106-300 gsm Coated (18 lb bond – 110 lb. cover) | Optional High Capacity Feeder is required for media weights >220 gsm |
| Internal tray capacity (Trays 1-3) | <ul style="list-style-type: none"> 550 sheet capacity each tray * Min: 5.5" x 8.5" (139 x 215.9mm) Max: 13" x 19.2" (SRA3) | <ul style="list-style-type: none"> Able to feed 64-220 gsm Uncoated and 106-220 gsm Coated Jam rates may be higher with Coated stocks |
| Multi Sheet Inserter Capacity (Tray 5) | <ul style="list-style-type: none"> 250 sheet capacity * Min: 3.9" x 5.8" (100 x 148) SEF Max: 13 x 19.2" (SRA3) SEF | <ul style="list-style-type: none"> Able to feed 64-300 gsm Uncoated and 106-300 gsm Coated |

| Item | Specification | Comments |
|-----------------------------|---|--|
| Paper Size | Min: 5.5" x 7.2" (140mm x 182mm) Max: 13" x 19.2" (330mm x 488mm) | |
| Imageable Area | Copy: Guaranteed Image Quality area is 11.69 in x 17.00 in (297 mm x 432 mm). Print: Guaranteed Image Quality area 12.48 in x 18.90 in (317 mm x 480 mm) | On all media there is a Lead Edge deletion of 4mm and a Trail Edge deletion of 4mm. Side edge deletion is 3mm except for 13x19" media. On 13x19" media the side deletion is 3.5mm. |
| Transparencies | USA and Canada: 3R3028, 3R3108; Xerox Europe: 3R98199, 3R3108. | Use of other transparencies may cause machine damage and result in excessive service calls. Refer to Print Engine Productivity Speeds Charts for print speeds |
| Warm-up Time * | <ul style="list-style-type: none"> 150 sec or less, after Sleep Mode or Power On exit 30 sec or less, after Low Power mode exit | * Status where paper feed can be started immediately when Start button is pressed. |
| First Print Out Time | <ul style="list-style-type: none"> 11.2 sec or less Color 7.5 sec or less B/W | In Ready mode, FPOT is the time elapsed from when IOT receives Start command, until the trail edge of the first print exits the print engine. |
| Resolution | 2400 x 2400 x 1 dpi (Print Engine) 2400 x 2400 x 1 dpi (Copy) 600 x 600 x 1 dpi (Gray Font Only) | Line Screens supported: 600, 300, 200, 150 Clustered Dot 200 Rotated |
| Scanning Resolution | Up to 600 x 600 x 1 dpi | Several scan resolution settings are selectable via User Interface touch panel. See Scan section for additional details |
| Color Consistency | DeltaE = 7 | Within a page |
| Front to Back Registration | + / - 1.0 mm | See Registration section for additional detail |
| Color to Color Registration | ≤ 87 microns | Specification applies on either Color Xpressions or Colotech+ 90gsm paper. Specification may vary on papers above 90gsm. |
| Service Call Rate | Approximately one call every 5 weeks. | At average usage of 35,000 prints per month on centerline paper Actual service call rate is influenced by total print volume, environmental conditions, area coverage, and media characteristics. |
| Shutdown Rate | On average, less than 1 fault per day requiring a power-recycle to recover. | Based on 35,000 AMPV, one 8-hour shift per day, using centerline papers. |
| Meters | Color Impressions Black Impressions Color Large Impressions Total Impressions | |

* Spec with Centerline Paper

Registration

Front to back registration on the Xerox 770 Digital Color Press is +/- 1.0 mm.

The following table contains more technical registration information regarding image registration, magnification, and skew specifications for the Xerox 770 Digital Color Press. Note that these specifications only apply to Xerox 770 Digital Color Press centerline paper measured on an 11 x 17" sheet.

| Item | Trays 1-3 OHCF 3 OHCF 3.2 | HCF (A4 -8.5x11 1Tray HCF) | MSI (Bypass) | Condition |
|--|---------------------------------|----------------------------------|-----------------|-----------|
| Lead Registration | ±0.7mm | ±1.5 mm | ±1.5 mm | |
| Side Registration | ±0.7 mm | ±1.7 mm | ±2.9 mm | |
| Skew along the Lead Edge (200mm) | ±0.5 mm | ±1.5 mm | ±1.5 mm | |
| Skew along the Side Edge (400mm) | ±1.0 mm | ±3.0 mm | ±3.0 mm | |
| Side1-2 Perpendicularity (400mm) | ±0.6 mm | - | - | |
| Parallelism (400mm) | ±0.6 mm | - | - | |
| Image Loss | | | - | 100 % |
| <ul style="list-style-type: none"> Lead Edge Trail Edge Side Edge | 4.0 mm 4.0 mm 3.0 mm | | | |
| Side1-2 Registration (Lead Reg. direction) | 1.0 mm | | — | |
| Side1-2 Registration (Side Reg. direction) | 1.0 mm | | — | |

Product Limitations and Caveats

- The maximum print/copy speed for the system is determined by the process speed of the Xerox 770 Digital Color Press engine. Image quality adjustments are done frequently to maintain consistent IQ and this will affect total productivity over an extended period, i.e. shift, week, or month.
- “Productivity Mode” enables printing at full rated speed on any stock weight. However, Mixed media jobs (containing more than one paper weight / type) will not print at full rated speed. The severity of productivity loss depends on the number of different media types or weights in a job, as well as the magnitude of the difference in weight between these media types. Larger differences in media weight (e.g. 300 gsm / 110 lb. Cover followed by 90 gsm / 24 lb Bond) result in larger productivity declines.
- Labels and Transparencies do not print at full rated speed – refer to the Print Engine Productivity Charts for details.
- When using reverse order (face-up) printing, the print engine will not cycle up until the entire job is ready. This will impact First Print Out Time (FPOT). The printer may cycle down between jobs, depending on job complexity.
- Attempts to feed heavier than recommended paper stocks, and/or misuse of the media settings, may cause machine damage or poor image quality. Using media at run modes other than that recommended for the grade may cause poor image quality and machine damage.
- If a requested finishing setting is outside machine capabilities:
 - Copy jobs will be sent through unfinished
 - Print jobs from the EFI color servers will be sent through unfinished
 - Print jobs from the FreeFlow color server will be held
- A fault with code 45-36x may occur intermittently. The expected frequency is approximately once every 20,000 prints or once a week, depending on print volume. To recover, Power Off/ Power On the printer.
- A fault with code 127-211 / 311 may occur after jam clearance. To recover, Power Off/ Power On the printer.
- System requirements messages (e.g., “Order Waste Toner Container”, “Hole Punch Waste Container Full”) may occasionally be blocked by the current UI screen. Close the Job Status screen and open the Machine Status/Supplies screen to check consumable status.
- If the machine stops running mid-job, or does not begin printing after a job is submitted, check the Machine Status/Supplies screen to determine if supplies need to be replaced. The system will stop if sufficient supplies are

not available for a submitted job. If the problem persists, check the Machine Status/Fault screen, select the fault, and click on the Instructions button.

- If the machine stops running mid-job, or does not begin printing after a job is submitted, verify that the applicable paper tray is not empty. The system will stop if sufficient media is not available for a submitted job. If the problem persists, check the Machine Status/Fault screen, select the fault, and click on the Instructions button.
- The system does not prohibit duplex printing of coated substrates from the internal trays (Trays 1-3); however, there can be a significant increase in jams or multi-feeds. If large quantities of coated paper are to be run, the optional Oversize High Capacity Feeder is recommended.
- Attempting to feed heavier than recommended paper stocks, and/or misuse of the media settings, may cause machine damage or poor image quality. Using media at run modes other than that recommended for the grade may cause poor image quality and serious machine damage.
- All paper trays can be reloaded while jobs are running from any other tray. It is not possible to change paper settings while jobs are running.
- When using heavy coated 11" x 17" stock, closing any trays with too much force will result in a paper size misread. Open and close the tray gently to allow the paper sensors to correctly identify paper size.
- If the adjustment arms are disturbed while re-loading paper in Tray 5, the paper size setting will return to default and cause job to stop until the paper size setting is corrected by the user.
- If you plan to run X770 prints through other equipment, it is recommended you test the application before committing to the job. Many factors (operating temperature of the fuser, fuser oils, fix reaction of toner/inks) impact the success of running X770 prints in other equipment. Similar testing should be performed when running pre-printed materials through the X770.

Image Quality

- As with any printing process, artifacts will occur. These include streaks, mottle, banding, spots, etc. For most jobs and clients, the expected level of artifacts is within the normal operational and component quality ranges of the system and will not affect the acceptability of the job. Maintenance procedures are available to mitigate these artifacts.
 - Artifacts may occur with more frequency when running heavyweight coated media
 - Edge deletions are most common when duplex printing on heavier (>220 gsm / 85 lb. Cover) stocks and when using the maximum available image area. Deletions can be mitigated by using less than the maximum imageable area, i.e. allowing extra blank space at the lead and trail edges of the paper
 - Fuser roll wear lines may be observed when changing from 8.5" x 11" / A4 printing to larger formats such as 12" x 18" / SRA3. To extend the life of your parts and to minimize wear lines, Xerox recommends the usage of multiple fusers: one for smaller format jobs and one for larger format jobs. A Fuser CRU can be changed over in less than one minute, plus warmup time.
 - Using products on the Recommended Materials List (RML) and maintaining your environment will help to minimize the occurrence of these artifacts
- Color quality perception is subjective and will be affected by ambient lighting conditions.
- The customer is responsible for calibrating the Xerox 770 Digital Color Press. Refer to the Xerox Automated Color Quality Suite for guidelines on the easy to use Automated Calibration procedure.
- Image quality is strongly influenced by paper surface structure, texture, and color. To ensure that your customers are optimally satisfied, key applications should be printed on the Xerox 770 Digital Color Press using representative paper and reviewed by the customer.
- The surface texture of some uncoated papers may cause increased graininess in halftone areas printed with only black toner. This effect may be minimized by adding process black and/or using smooth or coated papers (refer to the Recommended Materials List).
- Sheets of a job may exhibit slight variation in gloss within a page (variation across page in the process direction).
- Prints may exhibit random white spots caused by paper dust, stray developer beads, or other particles. You can reduce the occurrence of white spots by using Xerox approved paper. If you are cutting your own paper, ensure that

cut edges are dust free, and keep the machine in a clean and dust/dirt reduced environment. Failure to do this will result in increased frequency of white spots.

- Some media may exhibit curl, which can be corrected using the internal de-curlers on the print engine and Interface Module (IFM), as well as on the optional Standard Finisher (Light Production C Finisher).

Automated Color Quality Suite (ACQS)

The Xerox 770 includes an Inline Spectrophotometer (ILS) and the Automated Color Quality Suite (ACQS). The ACQS suite is available on both Xerox FreeFlow Print Server (FFPS) and Xerox EX Print Server Powered by Fiery. These tools can be used to perform automated DFE calibration and custom profiling. These procedures are automated in that they eliminate the need for an operator to manually scan target sheets using an external spectrophotometer. The operator must initiate the procedures at the print server. All target sheets are then generated and scanned automatically, and all measurements, calculations, and corrections are performed automatically. Following normal calibration or profiling, the ILS does not monitor or measure prints within an actual print job.

In order to ensure the best color quality, customers should always calibrate and then create a custom profile for each stock to ensure the best color quality.

An external (handheld) spectrophotometer can still be used for manual print server calibration and profiling, if preferred. However, customers should always use a single device type for calibration and profiling measurements, i.e. do not calibrate with an external spectrophotometer and then profile using the ILS.

The billing meter(s) will be incremented for pages generated by the ACQS procedures. This is no change from the manual procedures.

Automated Color Calibration Notes and Caveats

- All digital color presses require periodic image quality assessment and maintenance to deliver consistent color over time. Standard color maintenance procedures should include periodic Calibration to set gray balance, which returns the print engine to a nominal state.
- Automated Print Server Calibration must be initiated by an operator at the print server.
- Automated Calibration is accomplished in two to three minutes per halftone (line screen) using the ILS
- Calibration frequency depends in part on customer preference; however, the following guidelines apply:
 - We recommend that Calibration be performed daily.
 - Calibration should always be performed after service procedures or if any drift in color is detected.
 - During a regular 8-hour shift, many customers calibrate at least once for each halftone that is used during that shift and many customers calibrate more frequently to mitigate potential drift.
 - Calibration should be performed using your most commonly used paper stock, or a “centerline” stock with mid-range weight and coating within the set of stocks you typically use.
- Each time Automated Calibration is activated, the target sheets are printed, scanned and ejected to the purge tray location (for example, the top tray of a High Capacity Stacker). If the purge tray is full, performing Automated Calibration will cause a jam to occur. In most cases, once the jam is cleared, the printer will be able to resume calibration. If the Automated Calibration procedure cannot recover, the current calibration job will be aborted, and the operator will need to close the calibration dialog box and reinitiate calibration

Advanced Profiling Notes and Caveats

- Advanced Profiling creates a superior, custom ICC-compliant Destination Profile for color critical applications that require a high degree of color accuracy. Using the ILS, this procedure will automatically print target sheets, measure how closely they match a selected aim (standard) and generate a custom color profile, all on the press. For optimal color accuracy, customers should create a custom profile for each stock that is used.
- Advanced Profiling must be initiated by the operator at the print server using Advanced Profiling tool with FreeFlow Print Server or Color Profiler Suite with Fiery EX color server.
- When creating new advanced profiles, customers should perform DFE calibration first, and then create profile, and ensure that you are linking the correct calibration curve to the correct destination profile.

- Once the target sheets are printed and scanned, the Advanced Profiling software takes approximately 5 minutes to generate a profile for the selected halftone.
- Calibrating routinely (to maintain gray balance) will extend the period of time for which an Advanced Profile can be used. If calibration is performed regularly, the profile should be accurate for up to a month; however some customers prefer to replace their profiles every 2 weeks to ensure accuracy.
- A new (replacement) Advanced Profile may need to be generated after certain service procedures such as photoreceptor drum replacement or charge corotron replacement.
- If a jam or other fault occurs during printing of the profile sheets, the Profiling operation will automatically be aborted and the operator will need to restart the Advanced Profile creation process

Print Engine Productivity

The X770 has a rated speed of 70 letter (A4) sized prints per minute for full color or black-only. Press productivity (actual print speed) may depend on sheet size, stock type, number and types of media within a job, and other factors. The X770 is designed with two modes that can be selected by the press operator:

Productivity Mode: In Productivity Mode, the press runs at the 70 PPM rated speed for the full range of supported paper weights (64 – 300 gsm; 18 lb. Bond – 110 lb. Cover). Note that this applies to coated and uncoated paper types only – tabs, transparencies, labels, and other specialty stocks will not run at full speed. Please see the charts below for specifications.

Standard Mode: In Standard Mode, press productivity will decline when printing heavier coated and uncoated papers. Tabs, transparencies, and labels will run at the same speed in either mode. Please see the charts below for specifications.

Print mode is set at the color server. Following a Power On / Power Off cycle, ensure that “Productivity Mode” is set at the color server in order to take advantage of the faster print speed for the heavier stock types.

Press productivity will typically be reduced for a mixed media job (multiple paper weights within a job) because the press must pause while the fuser temperature is optimized for each paper weight. In order to optimize productivity for these Mixed Media jobs, the recommended usage of print modes is as follows:

- Use “Standard Mode” for any mixed media job that includes Tabs or Transparencies
- Use “Standard Mode” for a job if the majority of pages in the job are 176 gsm (65 lb Cover) or below
- Use “Productivity Mode” for a job if the majority of pages in the job are greater than 176 gsm (65 lb. Cover)

Print Engine Productivity Charts – “Productivity Mode”

The tables below show the print speed of the Xerox 770 across the full range of paper sizes that the press supports when using “Productivity Mode.” Unless otherwise noted, the print speed is identical for full color or black-only prints. The formal specifications are represented by the paper weights stated in grams per square meter (gsm); the references to Bond and Cover weight ranges are approximate based on conversion to the nearest standard paper weight and type.

Feeding from Internal Trays 1-3 and all High Capacity Feeders

| Media Type / Weight | Paper length (in the feed direction) | | | | Xerox 770 Productivity (PPM) | |
|---|--------------------------------------|------------------|-----------------------|----------------------|------------------------------|--------|
| | Examples - Standard Sizes | Feed Direction * | Min. | Max. | Simplex | Duplex |
| Uncoated Paper 64-300 gsm (18# Bond-110# Cover) | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 70 | 35 |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 51 | 25 |
| Coated Paper 106-300gsm | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 39 | 19 |
| Papers heavier than 220 gsm (80# Cover) cannot be fed from internal Trays 1-3 | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 35 | 17 |
| | 12 x 18 SRA3 13 x 19 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 31 | 15 |

| Media Type / Weight | Paper length (in the feed direction) | | | | Xerox 770 Productivity (PPM) | |
|--------------------------|--------------------------------------|------------------|-----------------------|----------------------|------------------------------|--------|
| | Examples - Standard Sizes | Feed Direction * | Min. | Max. | Simplex | Duplex |
| Labels 106-176 gsm | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 51 | - |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 35 | - |
| | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 30 | - |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 25 | - |
| | 12 x 18 SRA3 13 x 19 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 22 | - |
| Labels 177-300 gsm | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 35 + | - |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 25 + | - |
| | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 21 + | - |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 17 + | - |
| | 12 x 18 SRA3 13 x 19 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 15 + | - |
| Tab Paper 106-176 gsm | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 32 | - |
| Tab Paper 177-256 gsm | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 23 + | - |
| Tab Paper 257-300 gsm | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 16 + | - |
| Transparencies | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 40 B/W 18 Color | - |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 29 B/W 13 Color | - |

* SEF = Short Edge Feed, LEF = Long Edge Feed

Feeding from Multi Sheet Inserter (MSI, Tray 5)

| Media Type / Weight | Paper length (in the feed direction) | | | | Xerox 770 Productivity (PPM) | |
|---|--------------------------------------|------------------|-----------------------|----------------------|------------------------------|--------|
| | Examples - Standard Sizes | Feed Direction * | Min. | Max. | Simplex | Duplex |
| Uncoated Paper 64-300 gsm (18# Bond-110# Cover) | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 50 | 25 |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 41 | 20 |
| Coated Paper 106-300gsm | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 35 | 17 |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 31 | 15 |
| | 12 x 18 SRA3 13 x 19 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 28 | 14 |

* SEF = Short Edge Feed, LEF = Long Edge Feed

Print Engine Productivity Charts – “Standard Mode”

The tables below show the print speed of the Xerox 770 across the full range of paper sizes that the press supports. Unless specifically noted, the print speed is identical for full color or black-only (B/W) prints.

Feeding from Internal Trays 1-3 and all High Capacity Feeders

| Media Type / Weight | Paper length (in the feed direction) | | | | Xerox 770 Productivity (PPM) | |
|---|---|------------------|-----------------------|----------------------|------------------------------|--------|
| | Examples - Standard Sizes | Feed Direction * | Min. | Max. | Simplex | Duplex |
| <u>Uncoated Paper</u> 64-176 gsm 18# Bond-65# Cover | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 70 | 35 |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 51 | 25 |
| | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 39 | 19 |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 35 | 17 |
| | 12 x 18 SRA3 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 31 | 15 |
| <u>Uncoated Paper</u> 177-256 gsm 65# Cover-90# Cover Papers heavier than 220 gsm (80# Cover) cannot be fed from internal Trays 1-3 | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 51 | 25 |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 35 | 17 |
| | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 30 | 15 |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 25 | 12 |
| | 12 x 18 SRA3 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 22 | 11 |
| <u>Uncoated Paper</u> 257-300 gsm 90# Cover-110# Cover Papers heavier than 220 gsm (80# Cover) cannot be fed from internal Trays 1-3 | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 35 | 17 |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 25 | 12 |
| | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 21 | 10 |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 17 | 8 |
| | 12 x 18 SRA3 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 15 | 7 |
| <u>Coated Paper</u> 106-176 gsm 32# Bond-65# Cover | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 51 | 23 |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 35 | 17 |
| | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 30 | 15 |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 25 | 12 |
| | 12 x 18 SRA3 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 22 | 11 |
| <u>Coated Paper</u> 177-300 gsm 65# Cover-110# Cover Papers heavier than 220 gsm (80# Cover) cannot be fed from internal Trays 1-3 | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 35 | 15 |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 25 | 12 |
| | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 21 | 10 |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 17 | 8 |
| | 12 x 18 SRA3 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 15 | 7 |
| Labels, Tabs, Transparencies | Same speeds as “Productivity Mode” – see chart beginning on page 10 | | | | | |

* SEF = Short Edge Feed, LEF = Long Edge Feed

+ Media heavier than 220 gsm (80# Cover) cannot be fed from internal Trays 1-3

Feeding from Multi Sheet Inserter (MSI, Tray 5)

| Media Type / Weight | Paper length (in the feed direction) | | | | Xerox 770 Productivity (PPM) | |
|---|--------------------------------------|------------------|-----------------------|----------------------|------------------------------|--------|
| | Examples - Standard Sizes | Feed Direction * | Min. | Max. | Simplex | Duplex |
| <u>Uncoated Paper</u> 64-176 gsm 18# Bond-65# Cover | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 50 | 23 |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 41 | 20 |
| | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 35 | 17 |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 31 | 15 |
| | 12 x 18 SRA3 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 28 | 14 |
| <u>Uncoated Paper</u> 177-256 gsm 65# Cover-90# Cover Papers heavier than 220 gsm (80# Cover) cannot be fed from internal Trays 1-3 | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 40 | 18 |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 32 | 16 |
| | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 27 | 13 |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 24 | 12 |
| | 12 x 18 SRA3 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 22 | 11 |
| <u>Uncoated Paper</u> 257-300 gsm 90# Cover-110# Cover Papers heavier than 220 gsm (80# Cover) cannot be fed from internal Trays 1-3 | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 25 | 12 |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 19 | 9 |
| | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 17 | 8 |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 15 | 7 |
| | 12 x 18 SRA3 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 14 | 7 |
| <u>Coated Paper</u> 106-176 gsm 32# Bond-65# Cover | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 40 | 18 |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 32 | 16 |
| | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 27 | 13 |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 24 | 12 |
| | 12 x 18 SRA3 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 22 | 11 |
| <u>Coated Paper</u> 177-300 gsm 65# Cover-110# Cover Papers heavier than 220 gsm (80# Cover) cannot be fed from internal Trays 1-3 | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 35 | 15 |
| | 8.5 x 11 A4 | SEF | 8.51 in. 216.1 mm | 11.7 in. 298.0 mm | 25 | 12 |
| | 8.5 x 14 B4 | SEF | 11.71 in. 298.1 mm | 14.3 in. 365 mm | 21 | 10 |
| | 11 x 17 A3 | SEF | 14.4 in. 366 mm | 17 in. 432.0 mm | 17 | 8 |
| | 12 x 18 SRA3 | SEF | 17.1 in. 432.1 mm | 19.2 in. 488.0 mm | 15 | 7 |
| Tab Paper 106-176 gsm | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 32 | - |

| Media Type / Weight | Paper length (in the feed direction) | | | | Xerox 770 Productivity (PPM) | |
|--------------------------|--------------------------------------|------------------|---------------------|----------------------|------------------------------|--------|
| | Examples - Standard Sizes | Feed Direction * | Min. | Max. | Simplex | Duplex |
| Tab Paper 177-256 gsm | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 23 | - |
| Tab Paper 257-300 gsm | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 16 | - |
| Transparencies | 8.5 x 11 A4 | LEF | 7.2 in. 182.0 mm | 8.5 in. 216.0 mm | 40 B/W 23 Color | - |
| | 8.5 x 11 A4 | SEF | 8.5 in. 216.1 mm | 11.7 in. 298.0 mm | 29 B/W 15 Color | - |

Media Selection Guidelines and Media Support

- Every effort has been made to ensure that the Xerox 770 Digital Color Press supports a broad range of media. Using only Xerox-recommended media maximizes reliability and paper-handling performance. Furthermore, use of the Centerline papers are recommended to ensure you receive the best image quality from your Xerox 770 Digital Color Press
- Typically, heavy weight papers exhibit increased variability of formation and surface smoothness, which may result in degraded image quality.
- Paper from all trays is printed topside first. It is recommended that Xerox branded paper be loaded with ream wrapper seam-side up.
- Manufacturers of coated stock do not recommend use of their media when the ambient relative humidity exceeds 60%. Relative humidity greater than 40% may increase the misfeed rate from Trays 1, 2, 3 and 5.
- All paper stretches to a certain extent during printing. The amount of stretch is dependent on paper type and environmental conditions. Stretch is most noticeable on coated stocks. This stretch can affect front-to-back image registration. Use the Alignment Profiles feature described in the System Administration Guide to minimize this effect.
- Image registration, image quality (i.e. white spots), and machine reliability can be adversely affected when custom-cut paper is inaccurately cut, is of poor quality, or loose paper fibers are present on the cut edges.
- Image registration, image quality (i.e. white spots), jam frequency and machine reliability can be adversely affected when punched or drilled paper is of poor quality and/or loose hole plugs are present in the ream.
- For further information and recommendations regarding media testing, selection, and handling, refer to the Material Usage Guide provided with your system and the Recommended Materials List (RML) available from your Xerox representative or at

Western Hemisphere: < http://www.xerox.com/downloads/usa/en/supplies/rml/supplies_rml_700i.pdf >

Europe: <<http://www.gkls.co.uk/supplies/medialist/Default.aspx?locale=en-GB>>

Transparencies

Use Xerox removable stripe transparency material (USA and Canada: 3R3028, 3R3108; Xerox Europe: 3R98199, 3R3108) for optimum system performance and image projection. These premium transparencies are specifically designed to provide optimum print quality. Use of other transparencies may cause machine damage and result in excessive service calls.

Due to the increased thickness of the removable stripe, no more than (100) 3R3108 transparencies should be loaded in a paper tray at one time. The maximum output stack height should not exceed 100 transparencies.

Envelopes

Using Tray 5, the Xerox 770 Digital Color Press currently supports the European and Asian envelope types shown below. However, envelopes should be run in limited quantities on an occasional basis and are not intended to be a primary media for this product. Note that envelopes must be loaded with the opened flap set as the trail edge.

| Envelope Type | Feed Direction | Envelope Size (mm) |
|----------------------|----------------|--------------------|
| Envelope: Chou-kei3* | SEF | 120.0 × 235.0 |
| Envelope: Kaku-ga** | SEF | 240.0 × 332.0 |
| Envelope C4 | SEF | 229.0 × 324.0 |
| Envelope C5 | SEF | 162.0 × 229.0 |

*opening/flap on the envelope's short dimension; accepts A4 folded in thirds

** opening/flap on the envelope's short dimension; accepts A4 flat, A3 folded in half

Non-Standard paper sizes

The Xerox 770 Digital Color Press supports non-standard paper sizes. However, due to rounding and unit-conversions that occur in the client applications, print server, and printer, some mismatch may occur between the paper size entered at the application, and the paper size that must be entered at the printer. The operator may need to adjust the entered paper dimensions by up to 0.1 in (2.5 mm) in order for the printer to detect that the requested paper size has been loaded. In addition, the printer interprets some paper sizes included in the PPD as non-standard sizes.

Duplex Prints

The Duplexing Automatic Document Feeder (DADF) for hardcopy scanning will handle originals from 5.5 x 8.5" to 11 x 17" (or A3) in size, and from 16 to 28lb Bond in weight. The DADF has a maximum capacity of 250 sheets (based on 24lb Paper). Automatic duplex and Manual duplex printing can be performed on all recommended sizes of media up to 110lb Cover (300 gsm) or coated 100lb Cover (280 gsm) from Tray 5 (Bypass), and Trays 6 & 7.

Automatic duplex printing can be performed on recommended media up to 13x19" (SRA3 320mm x 450mm / Maximum 320mm x 482mm) from Tray 5 (Bypass), and Trays 6 & 7.

Manual duplex can also be performed on recommended media up to 13x19" (SRA3 320mm x 450mm / Maximum 320mm x 482mm) from Tray 5 (Bypass).

As with any printer or copier, duplex performance may not match the performance for single-sided printing or copying. Paper jam rates may be higher than the rate you will experience for the same throughput material in single sided mode.

Integrated Scanner

The integrated scanner performs Color or B/W scanning at 200 x 200, 300 x 300, 400 x 400, 600 x 600 dpi resolutions. Scan speed by document size is as follows:

| Document Size and Orientation | B/W Scan Speed | Color Scan Speed | Duplex B/W Scan Speed | Duplex Color Scan Speed |
|-------------------------------|----------------|------------------|-----------------------|-------------------------|
| A4 LEF | 81 | 51 | 60 | 36 |
| A4 SEF | 59 | 38 | 49 | 28 |
| A3 SEF | 49 | 28 | 41 | 22 |
| 8.5" x 11" LEF | 80 | 50 | 59 | 35 |
| 8.5" x 11" SEF | 62 | 40 | 51 | 29 |

| | | | | |
|----------------|----|----|----|----|
| 8.5" x 14" SEF | 49 | 32 | 45 | 25 |
| 11" x 17" SEF | 48 | 27 | 39 | 22 |

Recommended Supplies

| Supply Description | Reorder Numbers | | | Cartridges Per Carton | Yield Projection at representative total area coverage (AC), using centerline paper |
|---|---|----------------------------------|-------------------------------|-----------------------|---|
| Toner (1) | WW Metered Toner Reorder Number | WH/ XE Sold Toner Reorder Number | DMO Sold Toner Reorder Number | | AC = 7.5 % per color (30 % total CMYK) |
| Black | 6R1375 | 6R1383 | 6R1379 | 1 | 20,000 (3) |
| Cyan | 6R1376 | 6R1384 | 6R1380 | 1 | 22,000 |
| Yellow | 6R1378 | 6R1386 | 6R1382 | 1 | 22,000 |
| Magenta | 6R1377 | 6R1385 | 6R1381 | 1 | 21,000 |
| Drum Cartridge (2) | | | | | |
| Black | 13R00655 | | | 1 | 115,000 |
| Cyan | 13R00656 | | | 1 | 70,000 |
| Yellow | 13R00656 | | | 1 | 70,000 |
| Magenta | 13R00656 | | | 1 | 70,000 |
| Toner Waste Bottle | 8R12990 Contact the Welcome Center for replacement | | | 1 | 33,000 |
| Charge Corotron | 13R00650 | | | 1 | 175,000 |
| Fuser Module | 8R13065 | | | 1 | 200,000 |
| Convenience and Advance Staple Cartridge | 8R12964 | | | 1 | 5,000 staples |
| Convenience and Advance Staple Refills | 8R12941 | | | 3 staple refills | 5,000 staples each |
| Light Production C Finisher Staples | 8R13041 | | | 4 staple refills | 5,000 staples each |
| Booklet Maker Staple Refill | 8R12925 | | | 4 staple refills | 5,000 staples each |

(1) The dry ink yield projections are based on the indicated area coverage at standardized conditions on 8.5 in x 11 in/A4 Xerox 770 Digital Color Press centerline paper. Please note that actual yields vary greatly depending on color intensity, area coverage, paper stock, and mode selected.

(2) Drum Cartridge replacement frequency noted above for 8.5 in x 11 in/A4 images when using Xerox 770 Digital Color Press centerline paper and other stocks with equivalent smoothness, cut quality and structure. Replacement rates may be more frequent for operations which use high percentages of coated stocks, have area coverage greater than 70 % of each color, and/or larger than 8.5 in x 11 in/A4 size throughputs, e.g., 11 in x 17 in/A3.

(3) One black cartridge per carton; two black cartridges are used in tandem, with a resulting yield of 40k.

Initial Supplies

Each Xerox 770 Digital Color Press is delivered with an initial supply of Toner and all CRUs (Drum Cartridges, Charge Corotron, Fuser, Waste Toner Container, and Staples (if applicable)).

To order additional supply (toner / staples) or Throughput materials, contact the Xerox Supplies Marketing Center:

1-800-822-2200 US, 1-800-668-0199 CAN (English), 1-800-668-0133 CAN (French.)

US Customers on Metered Price Plans can order online at www.xerox.com/meteredsupplies or contact the Metered Supplies hotline at 1-800-599-2198.

Install Planning: Environmental, Electrical, and Space Requirements

Please refer to the “Xerox 770 Digital Color Press Installation Planning Guide” for all environmental, electrical, and space requirements. It is the customer’s responsibility to comply with these install planning requirements to ensure a successful product install and to enable safe operation and optimal performance of the product.

Optional Accessories

The following devices are available for the Xerox 770 Digital Color Press:

| Accessory | Description |
|--|---|
| High Capacity Feeder | 2,000 sheet capacity (based on 80 gsm centerline paper) |
| 1 Tray Oversize High Capacity Feeder | 2,000 Sheet* (up to 13x19.2/SRA3) capacity from 64-300 gsm (uncoated) and 106-300 gsm (coated). |
| 2 Tray Oversize High Capacity Feeder | 4,000 Sheet* (up to 13x19.2/SRA3) capacity from 64-300 gsm (uncoated) and 106-300 gsm (coated). |
| Interface Module (Standard – for reference only) | The Interface Module is standard on the Xerox 770. The Interface Module aligns the paper paths of the engine and finisher, cools and decurls paper exiting the printer, allows communication between the engine and finishers, and houses the inline spectrophotometer. |
| GBC Advanced Punch | The GBC AdvancedPunch is an inline die punch that utilizes modular die sets to enable a variety of hole-punch patterns in A4/8 ½ x 11 in (LTR) long-edge-fed media. LTR die punch ships with 19-hole die set A4 die punch ships with 21-hole die set |
| Standard Finisher (Light Production C Finisher) | The Standard Finisher includes a basic in-line punch, stapler, the stacker tray and top exit tray. It also includes a built-in decurler unit that corrects the curl on paper output from the print engine, and a built-in interposer that feeds cover paper to finisher for saddle-staple operation. |
| Standard Finisher with Booklet Maker (Light Production C Finisher with Booklet Maker) | The Standard Finisher with Booklet Maker unit includes a basic in-line punch, stapler, the stacker tray and top exit tray, and a booklet unit capable of saddle stapling and bi fold. It also includes a built-in decurler unit that corrects the curl on paper output from the print engine, and a built-in interposer that feeds cover paper to finisher for saddle-staple operation. |
| C/Z Folder | This optional Folder unit can handle Z-fold, Tri-C, and Tri-Z, and can be added to the Standard Finisher or the Standard Finisher with Booklet maker. The C/Z folding tray can accommodate approximately 60 sheets of 24 lb (90 gsm) media). Supported Paper sizes are 8.5x11. |
| SquareFold® Trimmer | This optional device attaches the Standard Finisher with Booklet Maker (with or without the C-Z Folder). The SquareFold® Trimmer flattens the spine of the booklet and trims the face of the booklet. |
| High Capacity Stacker | Stack up to 5,000 sheets* offsetting output stack tray with movable cart to move to off line finishing. Additional cart is available for customer to order. |

*based on 80 gsm centerline paper

High Capacity Feeder (HCF)

Product Specifications:



| Feature | Specification |
|--------------------|--|
| Capacity | 2,000 total sheets (80 gsm centerline paper) |
| Weight Range | 64-216 gsm (uncoated) |
| Maximum Paper Size | A4 / 8.5" x 11" |
| Power requirement | None – power provided from print engine |

Oversize High Capacity Feeder (OHCF)

One-Tray OHCF



Two-Tray OHCF



The OHCF is available in One-Tray and Two-Tray versions. The OHCF feeds stocks up to 300 gsm, coated and uncoated. It utilizes air assistance to improve feeding of oversized and heavy sheets.

Product Specifications:

| Feature | Specification (with centerline paper) |
|--------------------------|---|
| Capacity (One Tray) | 1 trays, 2,000 total sheets |
| Capacity (2-Tray Module) | 2 trays, 4,000 total sheets (each tray capacity 2,000 sheets) |
| Minimum Paper Weight | 64 gsm uncoated or 106 gsm coated |
| Maximum Paper Weight | 300 gsm coated or uncoated |
| Minimum Paper Size | 182mm x 210mm (7.2" x 8.3") (4" x 6" with Tray inserter) |
| Maximum Paper Size | 330mm x 488mm (13" x 19.2") |
| Power requirement | Additional electrical receptacle required; refer to Install Planning Guide. |

GBC® AdvancedPunch™

The GBC AdvancedPunch is an inline die punch that uses modular die sets to enable a variety of hole punch patterns in A4 or 8.5 x 11 inch (LTR), long-edge-fed media to support offline binding. The GBC AdvancedPunch is supported by all color servers. The GBC AdvancedPunch requires an Interface Module (IFM) as well as either a High Capacity Stacker or Standard Finisher (Light Production C Finisher), with or without booklet maker option.

GBC AdvancedPunch Specifications:

- Supports media from 75 to 216 gsm, coated and uncoated.
- ProClick die supports media from 75 to 203 gsm
- Supports tab stock no wider than 9". Oversized tabs may be damaged.
- The GBC AdvancedPunch is able to bypass all coated and uncoated media sizes and weights printed on the Xerox 770 Digital Color Press
- Requires an additional electrical receptacle; please refer to the Install Planning Guide for specifications.

GBC AdvancedPunch Limitations

- GBC AdvancedPunch does not work in conjunction with C/Z-fold or Standard Finisher (Light Production C Finisher) punch, staple, or booklet making.



- Hole punch position from edge of paper is not adjustable
- Preprinted Tabs cannot be punched
- Opening the door of the GBC AdvancedPunch while the machine is running will cause the machine to jam and shut down
- Gloss coated media may not run as reliably as uncoated paper. Typically, coated papers and high area coverage exhibit increased variability in paper handling due to lower coefficients of friction, resulting in a broader distribution of punch registration and elevated jam rates.
- Punching A4 or 8.5 x 11 duplexed coated stocks using the GBC 3-hole punch (008R13072) is not recommended due to higher jam rates.
- Stacking may be misaligned on jobs containing tab stock; these jobs will require additional jogging before final finishing
- Due to the nature of punching holes, each punched sheet is slightly deformed, and when stacked, the edge with the holes will have an increased height compared to the non-punched edge.
 - Reduced stack quality may be experienced due to variability in the punch hole formation.
 - When sending output to the stack tray of the High Capacity Stacker, if this stack height difference exceeds one inch, the machine will shut down and alert the operator to unload the stacker tray. This is done to prevent a jam and will result in a reduction of stack capacity depending on the die being used.
 - Using the HCS tray insert (shipped with your GBC unit) will increase stack capacity. See tables below for the expected stack ranges of the HCS stack tray for each punch die.

| Stack Tray Capacity: 8.5 x 11 inch (LTR) Dies: | | |
|--|--------------------------|-----------------------|
| Punch Die Description | Xerox Part Number (Ref.) | Stack Tray Capacity** |
| Xerox PB-19H (shipped w/ unit) | 497N00216 | 2300-2700 |
| Xerox PB-19H | 008R13066 | 2300-2700 |
| Xerox C4-44H | 008R13067 | 3500-3900 |
| Xerox W2-21H-SQ | 008R13068 | 1400-1550 |
| Xerox W3-32H-SQ | 008R13069 | 1500-1700 |
| Xerox VB-11H | 008R13070 | 5000 |
| Xerox PC-32H | 008R13071 | 1200-1450 |
| Xerox 3H | 008R13072 | 5000 |

** Using removable HCS Tray Insert. Capacity may be reduced if HCS Tray Insert is not used.

| Stack Tray Capacity: A4 Dies: | | |
|-------------------------------|--------------------------|-----------------------|
| Punch Die Description | Xerox Part Number (Ref.) | Stack Tray Capacity** |
| Xerox PB-20H, A4 | 498K19340 | 2500-3400 |
| Xerox PB-21H, A4 | 498K19440 | 3800-4500 |
| Xerox C4-47H, A4 | 498K19350 | 3600-4800 |
| Xerox W2-23H- RND, A4 | 498K19360 | 2300-4100 |
| Xerox W3-34H- RND, A4 | 498K19370 | 2300-4100 |
| Xerox W2-23H- SQ, A4 | 498K19380 | 2200-4000 |

| | | |
|----------------------|-----------|-----------|
| Xerox W3-34H- SQ, A4 | 498K19390 | 1500-3300 |
| Xerox VB-12H, A4 | 498K19400 | 4800-5000 |
| PC-34H, A4 | 498K19410 | 1000-1400 |
| Xerox 2H-8mm, A4 | 498K19420 | 5000 |
| Xerox 4H-8mm, A4 | 498K19430 | 5000 |

** Using removable HCS Tray Insert. Capacity may be reduced if HCS Tray Insert is not used.

- A4 and LTR punch units are not the same and A4 and LTR die sets are not interchangeable
 - LTR punch unit will be shipped with the 19-hole punch die
 - A4 unit will ship with the 21-hole punch die
 - Additional punch dies are available for order (see below)
 - Up to 3 additional die sets can be stored inside the GBC AdvancedPunch

Punch Dies:

The GBCR AdvancedPunch™ is capable of punching a variety of hole-punch patterns by simply changing the punch die. Punch dies can be changed in seconds without tools. The punch dies currently available are listed below. Each die set has a 90 day warranty from date of purchase. In the Western Hemisphere, LTR (8.5 x 11 inch) punch dies are ordered using the Supplies ordering process; in Europe (A4) dies are ordered through sales representatives; please check for availability.

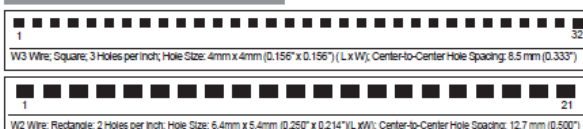
Punch die life will be maximized if the wick material is lightly oiled every 50K punch cycles (approximately every month) with light machine oil such as 3-in-1 Oil. Small deposits of oil will be observed around the perimeter of the punched holes until the excess oil is absorbed (usually within 20 sheets).

LTR (8.5 x 11 inch) Punch Dies:

For Plastic Comb Binding choose from:



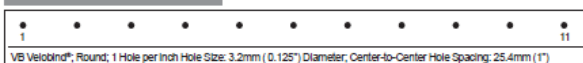
For Twin Loop™ Binding choose from:



For Color Coil™ Binding choose from:



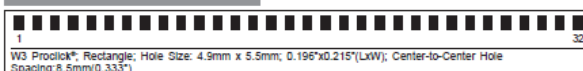
For Velo® Bind choose from:



For Looseleaf Binding choose from:



For Proclick® Binding choose from:



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Graphics do not represent actual punch pattern dimensions or spacing

Xerox Part Number:

XEROX PB-19H 008R13066

XEROX W3-32H-SQ 008R13069

XEROX W2-21H-SQ 008R13068

XEROX C4-44H 008R13067

XEROX VB-11H 008R13070

XEROX 3H 008R13072

XEROX PC-32H 008R13071

A4 Punch Dies:

| | | | |
|--------------------------------------|--|---------------------------|-----------|
| For Plastic Comb Binding: | | Xerox Part Number: | |
| | | XEROX PB-21H, A4 | 498K19440 |
| | | XEROX PB-20H, A4 | 498K19340 |
| For Twin Loop™ Binding: | | XEROX W3-34H-RND, A4 | 498K19370 |
| | | XEROX W2-23H-RND, A4 | 498K19360 |
| | | XEROX W3-34H-SQ, A4 | 498K19390 |
| | | XEROX W2-23H-SQ, A4 | 498K19380 |
| | | | |
| For Loose-leaf Binding: | | XEROX 4H-8mm, A4 | 498K19430 |
| | | XEROX 2H-8mm, A4 | 498K19420 |
| | | | |
| For Velo® Binding: | | XEROX VB-12H, A4 | 498K19400 |
| | | | |
| For Colour Coll™ Binding: | | XEROX C4-47H, A4 | 498K19350 |
| | | | |
| ProClick® A4 34-Hole Binding: | | XEROX PC-34H, A4 | 498K19410 |
| | | | |

Graphics do not represent actual punch pattern dimensions or spacing.

High Capacity Stacker (HCS)

The HCS is designed for long production runs.

- Up to 5,000 sheets offsetting output stack tray with movable cart to move to off line finishing.
- 500 sheet top tray
- Sample Prints are programmable at Color Server or On-Demand at HCS User Interface (single sheets diverted from Stack Tray to Top Tray)

**HCS Specifications:**

| Feature | Specification (with centerline paper) |
|----------------------|---|
| Stack Tray Capacity | 5,000 sheets |
| Top Tray Capacity | 500 sheets |
| Maximum Stack Weight | 70KG (154 lbs.) |
| Maximum Paper Size | 330mm x 488mm (13" x 19.2") |
| Power requirement | Additional electrical receptacle required; refer to Install Planning Guide. |

| Stack Tray Capacity by weight and paper finish | | | | | | | |
|--|-------------------------------|----------------|----------------|---------------|---------|------|-------------------------|
| Paper type and weight | Paper Size | | | | | | |
| | Smallest size 203 x 182 mm | A4 8.5 x 11 | B4 8.5 x 14 | A3 11 x 17 | 12 x 18 | SRA3 | 330x488 mm 13 x 19.2 |
| Uncoated 64-176 gsm | 5000 | 5,000 | 2300 | 2300 | 2300 | 2300 | 2300 |
| Uncoated 177-256 gsm | 5000 | 5,000 | 1900 | 1900 | 1900 | 1900 | 1900 |
| Uncoated 257-300 gsm | 5000 | 5,000 | 1500 | 1500 | 1500 | 1500 | 1500 |
| Coated 64-106 gsm | 5,000 | 5,000 | 4000 | 4000 | 4000 | 4000 | 4000 |
| Coated 106-128 gsm | 5,000 | 5,000 | 3400 | 3400 | 3400 | 3400 | 3400 |
| Coated 129-150 gsm | 5,000 | 5,000 | 2900 | 2900 | 2900 | 2900 | 2900 |
| Coated 136-216 gsm | 5,000 | 5,000 | 2400 | 2400 | 2400 | 2400 | 2400 |
| Coated 217-220 gsm | 5,000 | 5,000 | 2000 | 2000 | 2000 | 2000 | 2000 |
| Coated 221-256 gsm | 5,000 | 5,000 | 1500 | 1500 | 1500 | 1500 | 1500 |
| Coated 257-300 gsm | 5,000 | 5,000 | 1400 | 1400 | 1400 | 1400 | 1400 |

HCS Limitations

- The HCS is subject to stack weight limitations, and settings have been implemented to prevent damage to the unit caused by an excessively heavy stack. Please see the chart above for approximate stack sizes for sheets larger than 8.5" x 11" / A4.
- Stack quality may degrade and jams may increase with 64-106gsm coated paper stocks
- Mixed stock sizes can be sent to the HCS. However, the HCS generally should be unloaded between jobs that utilize different stock sizes to prevent stack quality problems such as paper misalignment or stack integrity.
- Two or more stackers cannot be chained together.

Standard Finisher (Light Production C Finisher)

The Standard Finisher / Light Production C Finisher is an output device that can perform up to 100-sheets stapling, up to 3,000 sheets stacking, punch, saddle stapling/center-fold, optional Z-fold/three-fold, and cover paper insertion. This finisher has a built-in decurler unit that corrects the curl on paper output from press, a built-in stapler with staple-pin cut function, and a built-in interposer that feeds cover paper to the finisher for stapled sets.

The Standard Finisher / Light Production C Finisher requires an additional electrical receptacle; please refer to the Install Planning Guide for specifications.

Note, the image of the product to the right is shown with the Optional C/Z Folder



Standard Finisher Product Specifications:**Top Tray:**

| Standard Finisher Top Tray Capacity by weight and paper finish | | | | | | | | |
|--|-------------|------------------|------------------|------------------|------------------|------------------|------------------|------------------|
| Paper type and weight | | Paper Size | | | | | | |
| | | 100x148mm | A4 | B4 | A3 | 12 x 18 (in)* | SRA3* | 13 x 19.2 (in)* |
| Uncoated | 64-80 gsm | H=67mm (2.64 in) | 500 | 500 | 500 | 500 | 500 | 500 |
| | 81-300 gsm | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) |
| Coated | 106-176 gsm | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) |
| | 177-300 gsm | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) | H=67mm (2.64 in) |

Stack Tray:

| Standard Finisher Stack Tray capacity by weight and paper finish | | | | | | | | |
|--|-------------|--------------------|--------------------|-------------------|-------------------|-------------------|-------------------|-------------------|
| Paper type and weight | | Paper Size | | | | | | |
| | | B5 | A4 | B4 | A3 | 12 x 18 (in)* | SRA3* | 13 x 19.2 (in)* |
| Uncoated | 64-80 gsm | 3,000 | 3,000 | 1,500 | 1,500 | 1,500 | 1,500 | 1,500 |
| | 81-300 gsm | H=378mm (14.88 in) | H=378mm (14.88 in) | H=180mm (7.09 in) | H=180mm (7.09 in) | H=180mm (7.09 in) | H=180mm (7.09 in) | H=180mm (7.09 in) |
| Coated | 106-300 gsm | H=378mm (14.88 in) | H=378mm (14.88 in) | H=180mm (7.09 in) | H=180mm (7.09 in) | H=180mm (7.09 in) | H=180mm (7.09 in) | H=180mm (7.09 in) |

*Cannot be offset

Stapling:

| Standard Finisher Staple Capabilities by weight and paper finish | | | | | |
|--|-------------|------------------|---------------|---------------|--------------|
| Paper type and weight | | Paper Size | | | |
| | | B5 | A4 | B4 | A3 |
| | | 7.25 x 10.5 (in) | 8.5 x 11 (in) | 8.5 x 14 (in) | 11 x 17 (in) |
| Uncoated | 64-80 gsm | 100 | 100 | 100 | 100 |
| | 81-90 gsm | up to 100 | up to 100 | up to 100 | up to 100 |
| | 91-105 gsm | 50 | 50 | 50 | 50 |
| | 106-128 gsm | 30 | 30 | 30 | 30 |
| | 129-150 gsm | 19 | 19 | 19 | 19 |
| | 151-176 gsm | 12 | 12 | 12 | 12 |
| | 177-220 gsm | 5 | 5 | 5 | 5 |
| | 221-256 gsm | 4 | 4 | 4 | 4 |
| | 256-300 gsm | 3 | 3 | 3 | 3 |

| | | | | | |
|---------------|-------------|---|---|---|---|
| Coated | 106-128 gsm | 5 | 5 | 5 | 5 |
| | 129-150 gsm | 5 | 5 | 5 | 5 |
| | 151-176 gsm | 5 | 5 | 5 | 5 |
| | 177-220 gsm | 5 | 5 | 5 | 5 |
| | 221-256 gsm | 4 | 4 | 4 | 4 |
| | 256-300 gsm | 3 | 3 | 3 | 3 |

Interposer

The Standard Finisher / Light Production C Finisher includes a standard Interposer, used to insert pre-printed stock into finished sets without having to go through the engine. Labels, coated media & envelopes are not supported

| Interposer Capacity by weight, size and paper finish | | | | | |
|--|------------|----------------------|------------------------|------------------------|-----------------------|
| Paper type and weight | | Paper Size | | | |
| | | B5 8 x 10 (in) | A4 8.5 x 11 (in) | B4 8.5 x 14 (in) | A3 11 x 17 (in) |
| Uncoated | 64-80 gsm | 200 shts | 200 shts | 200 shts | 200 shts |
| | 81-220 gsm | H=22mm (0.87 in) | H=22mm (0.87 in) | H=22mm (0.87 in) | H=22mm (0.87 in) |

Hole Punching

The Standard Finisher offers Hole Punching as a standard feature.

- Holes are created on the trail edge of the sheet.
- Hole punching is not available to the Booklet Tray.
- Hole punch capacity is equal to the regular capacity of the chosen output tray.
- For the US, 2- and 3-hole punching is available; for Europe, 2- and 4- hole punch is available. Stacks can be punched on the left or right side, or on the top edge.

| Hole Punch Capability by weight and paper finish | | | | | |
|--|-------------|------------|---------------------|---------------------|--------------------|
| Paper type and weight | | Paper Size | | | |
| | | B5 | A4 8.5 x 11 (in) | B4 8.5 x 14 (in) | A3 11 x 17 (in) |
| Uncoated | 64-200 gsm | Applicable | Applicable | Applicable | Applicable |
| Coated | 106-220 gsm | Applicable | Applicable | Applicable | Applicable |

Standard Finisher Limitations

- Productivity may be reduced by up to 50 % when running multiple sets of a single sheet job to the Stack Tray, due to the press being forced to wait while each single sheet set is ejected to the Stack Tray.
- If the compiler tamper arm resets itself during a job, the job will need to be re-submitted.
- If hole punching fails, check to make sure that the punch waste container is empty before calling for service.
- Productivity may decline when sending duplexed 11" x 17" stock to the stack tray.

Standard Finisher (Light Production C Finisher) With Booklet Maker

The Standard Finisher (Light Production C Finisher) with Booklet Maker is a separate configuration that adds basic booklet making capability to the features described for the Standard Finisher. Note, the image of the product to the right is shown with the Optional C/Z Folder. This device requires an additional electrical receptacle; please refer to the Install Planning Guide for specifications.

This device includes the punch and stapler, the stacker tray and top exit tray, and a booklet unit capable of saddle stapling and bi-fold. The specifications for the Top Tray, Stapling, Hole Punching, and the Interposer are the same as shown above for the Standard Finisher / Light Production C Finisher. Unique additional specifications for the additional Booklet Maker are shown below.



Booklet Capabilities by weight and paper finish:

| Sheets per booklet by weight, size and paper finish | | | | | | |
|---|-------------|------------------------|------------------------|-----------------------|-----------------|------|
| Paper type and weight | | Paper Size | | | | |
| | | A4 8.5 x 11 (in) | B4 8.5 x 14 (in) | A3 11 x 17 (in) | 12 x 18 (in) | SRA3 |
| Uncoated | 55-80 gsm | 25 | 25 | 25 | 25 | 25 |
| | 81-90 gsm | 20 | 20 | 20 | 20 | 20 |
| | 91-105 gsm | 10 | 10 | 10 | 10 | 10 |
| | 106-128 gsm | 10 | 10 | 10 | 10 | 10 |
| | 129-150 gsm | 10 | 10 | 10 | 10 | 10 |
| | 151-176 gsm | 10 | 10 | 10 | 10 | 10 |
| | 177-220 gsm | 5 | 5 | 5 | 5 | 5 |
| | 221-256 gsm | 4 | 4 | 4 | 4 | 4 |
| | 257-300 gsm | 3 | 3 | 3 | 3 | 3 |
| Coated | 106-128 gsm | 10 | 10 | 10 | 10 | 10 |
| | 129-150 gsm | 10 | 10 | 10 | 10 | 10 |
| | 151-176 gsm | 10 | 10 | 10 | 10 | 10 |
| | 177-220 gsm | 5 | 5 | 5 | 5 | 5 |
| | 221-256 gsm | 4 | 4 | 4 | 4 | 4 |
| | 257-300 gsm | 3 | 3 | 3 | 3 | 3 |

Fold accuracy of the inner sheet (lead and side edge):

- Stapled: ≤1.5 mm for A4 sheets, ≤2.0 mm for other sizes
- Non-stapled: ≤1.5 mm

Bi-Fold Capability

| PAPER TYPE AND WEIGHT | | BI-FOLD (SINGLE FOLD) **CAPABILITY BY WEIGHT, SIZE AND PAPER FINISH | | | | |
|-----------------------|-------------|---|------------------------|-----------------------|-----------------|------|
| | | A4 8.5 x 11 (in) | B4 8.5 x 14 (in) | A3 11 x 17 (in) | 12 x 18 (in) | SRA3 |
| Uncoated | 64-300 gsm | 1 | 1 | 1 | 1 | 1 |
| Coated | 106-300 gsm | 1 | 1 | 1 | 1 | 1 |

Fold accuracy (lead and side edge): ≤ 2.5 mm

Bi-Fold: 1 sheet/set, 64-300gsm uncoated stock, 106-300 gsm coated stock

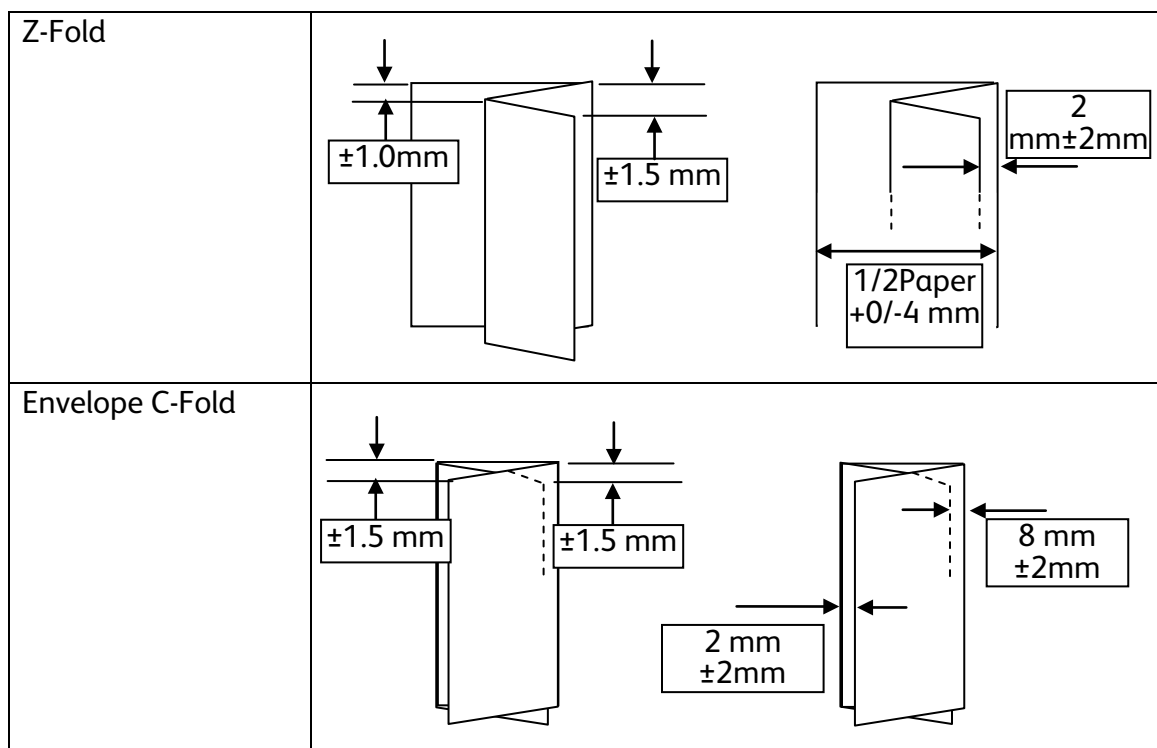
Booklet Maker Finisher Limitations

- Productivity may be reduced by up to 50 % when running multiple sets of a single sheet job to the Stack Tray.
- Higher jam rates may occur when running 280 gsm and above, tabloid sheets to the Booklet Maker.
- After cancelling a job sent to the Booklet maker, empty the purge tray before submitting another print job. This will ensure that purged sheets are not inadvertently inserted into the next booklet printed.

Optional C/Z Folder for the Standard Finisher / Light Production C Finisher

An optional Folder unit that can handle Z-fold, Tri-C, and Tri-Z, can be added to the Standard Finisher.

- The C/Z folding tray can accommodate 30 sheets of up to 24 lb (64-90 gsm) uncoated media.
- Supported Paper size is 8.5x11" (A4) to the bottom tray, 11 x 17" (B4 & A3) to the top tray
- Fold accuracy as shown below:



Optional SquareFold Trimmer

Overview

The SquareFold Trimmer is an optional finisher that flattens the spine of a booklet and performs face trim of the booklet. It can be added to a Standard Finisher / Light Production C Finisher equipped with the Booklet Maker option.

SquareFold Trimmer Specifications:

| Feature | Specification (with centerline paper) |
|-----------------------|---|
| Paper Types & Weights | 64 – 300 gsm, Coated and Uncoated (18# Bond – 110# Cover) |
| Paper Size | Min 8.5 x 11 SEF (216 mm x 279 mm) Max 13" x 18" SEF (330 mm x 457 mm) |
| Trim Capacity | 5 – 20 sheets @ 90 gsm (24#) 5 – 25 sheets @ 80gsm (20#) |
| Trim Dimensions | 2 mm – 20 mm, adjustable in 0.1 mm increments |

Configuration

This equipment is located after the Standard Finisher with Booklet Maker, and the operation is as follows:

- Receives the booklet from the booklet maker unit
- Transports the received booklet to the square fold unit to flatten the spine of the booklet and then to the trimmer unit to trim the face of the booklet
- Deposits the finished booklet into the booklet tray.

The SquareFold® Trimmer Module is also able to face-trim without square-folding. All output from the Standard Finisher / Light Production C Finisher can be passed through, square-folded, trimmed, or both squared-folded and trimmed, including custom sizes from 210x297.4mm – 330.2x457.2mm (SEF Letter through 13x18)

Auto Recognition of SquareFold Trimmer

When the SquareFold Trimmer is docked to the Booklet Maker Finisher via cable, the finisher automatically recognizes that the SquareFold Trimmer is installed.

Combination of Output Functions and Destinations

O: Can be combined

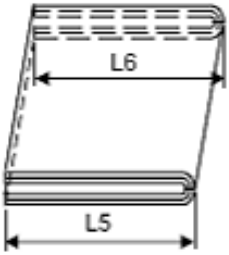
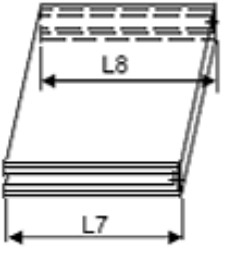
x: Cannot be combined

| | | Functions | | | Output Destination | |
|----------|------------|-----------|---------|-------------|--------------------|----------------------|
| | | Booklet | Trimmer | Square Fold | Booklet Tray | Trimmer Booklet Tray |
| Function | Offset | X | X | X | X | X |
| | Staple | X | X | X | X | X |
| | Punch | X | X | X | X | X |
| | Interposer | O | O | O | O | O |

| | | | | | | |
|---------------------|--------------------------------------|---|---|-----|---|---|
| Function + Function | Booklet | - | O | O*1 | O | O |
| | Z-Fold | X | X | X | X | X |
| | Letter Fold | X | X | X | X | X |
| | Bi-Fold | - | O | O*1 | O | O |
| | Offset | X | X | X | X | X |
| | Staple + Z-Fold | X | X | X | X | X |
| | Staple + Interposer | X | X | X | X | X |
| | Punch + Z-Fold | X | X | X | X | X |
| | Z-Fold + Interposer | X | X | X | X | X |
| | Staple + Punch + Z-Fold | X | X | X | X | X |
| | Staple + Punch + Z-Fold + Interposer | X | X | X | X | X |

*1: Square-folding/trimming of non-stapled sets and square-folding of 4 or less sheets in a set are outside the specification and cannot be assured (Jams may occur frequently or wrinkles may occur on the square-folded side of paper).

SquareFold Trimmer Skew Specification

| | |
|-------------------------------------|--|
| Booklet + trimming |  <p>Measures both side edges of the bottom sheet when the booklet is output.</p> <p>Staple: $L5-L6 \leq 2\text{mm}$ (Achievement rate: 95%)</p> <p>Bi-Fold / Non-staple: $L5-L6 \leq 2\text{mm}$ (Achievement rate: 95%)</p> |
| Booklet + trimming + square-folding |  <p>Measures both side edges of the bottom sheet when the booklet is output.</p> <p>Staple: $L7-L8 \leq 2.5\text{mm}$ (Achievement rate: 95%)</p> <p>(Performance is not guaranteed at Bi-Fold / Non-staple.)</p> |

Customer Expectations Agreement

Check off the modules that will be part of this install and for which expectations have been set:

| | |
|---|---|
| <input type="checkbox"/> Xerox 770 Digital Color Press | <input type="checkbox"/> Interface Module |
| <input type="checkbox"/> Xerox FreeFlow Print Server | <input type="checkbox"/> Standard (Light Production C) Finisher |
| <input type="checkbox"/> Xerox EX Print Server Powered by EFI | <input type="checkbox"/> Optional Booklet Maker |
| <input type="checkbox"/> High Capacity Feeder | <input type="checkbox"/> Optional C/Z Folder |
| <input type="checkbox"/> Oversized High Capacity Feeder (1 or 2 Tray) | <input type="checkbox"/> SquareFold Trimmer Module |
| <input type="checkbox"/> High Capacity Stacker | <input type="checkbox"/> GBC Advanced Punch |

Additional Reference Material:

Xerox 770 Digital Color Press Install Planning Guide will be provided by Xerox.

Xerox 770 Digital Color Press is shipped with a complete set of user guides on a CD ROM.

Primary Customer Applications:

Special considerations or performance limitations identified by Xerox and agreed to by the customer:

Upending and/or Stair Climbing Required and Reviewed:

Yes _____ Not Required _____

I have reviewed and understand the product specifications for each of the modules that will be installed, including those specified in the product Install Planning Guide: *(Signatures Required)*

Customer _____

Xerox Sales Representative _____

Xerox Analyst Representative _____

Xerox Service Representative _____

I have viewed a representative output sample from the Xerox 770 Digital Color Press and the image quality is acceptable for the needs of my organization:

(Signature required if Xerox 770 Digital Color Press is included with Order)

Customer _____