Xerox® Iridesse® Production Press

Customer Expectations Document

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Contents

Xerox® Iridesse® Production Press

Introduction and Overview

This document is intended to help you understand the performance and capabilities of the Xerox® Iridesse® Production Press. Information on accessories is also provided in this document. A separate Customer Expectations Document will be provided for the 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® Iridesse® Production Press 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 Equivalent	Notes
Uncoated paper	**North America**—Xerox® Bold Digital Printing Paper (90 gsm/24 lb) **Europe**—Xerox® Digital Color Colortech+ (90 gsm)	Xerox® Color Iridesse® Production Press centerline paper—Uncoated
Coated paper	**North America** Verso® Futura® Gloss Text (80 lb. / 118 gsm) **Europe** Verso® Futura® Gloss Text (80 lb. / 118 gsm)	Xerox® Color Iridesse® Production Press centerline paper—Coated

Refer to the recommended media list (“Recommended Media List” or “RML”), which will be available from www.xerox.com or your Xerox representative, for optimum media selections.

Optimum Product Performance: Print Volume and Uptime

The Xerox® Iridesse® Production Press is designed for an average monthly image volume (AMIV) as shown. An “image” refers to one 8.5 x 11 inch / A4 impression, and a “page” refers to a sheet that actually passes through the press and is counted by the billing meters. For example, a single side, 8.5 x 11 inch job would count as one Image and one Page, while a duplex, 11 x 17 inch job would count as four Images and two Pages. The Average Monthly Page Volume (AMPV) depends on the mix of sheet sizes used, so the numbers below are specified in Images and represent the optimal monthly volume for the Iridesse® Production Press.

Press	AMIV	Conditions
Xerox® Iridesse® Production Press	225,000–475,000*	8.5 in. x 11 in. / A4

*Although the stated range represents the optimal monthly volume, depending on job mix, stocks used, etc., it is possible to run up to 600,000 images/month on the Iridesse® Production Press.

Prints between service calls on a digital color press depend upon individual customer requirements for quality, volume, applications, and throughput material. Generally, customers who participate in formal operator training from Xerox experience better performance, improved productivity and reduced service activity.

The recommended maximum Black-only (K-only) volume is 20% of total monthly volume, or up to 35,000–60,000 K-only AMIV. Whenever higher volumes of K-only prints are run, or for any longer runs of K-only, productivity and image quality will be optimized by ensuring that job properties are set to “Grayscale” or “K (Black) Only” Mode at the print server.

The “Duty Cycle” is another metric that is sometimes used to describe the volume that a digital press can produce. Unlike AMIV, which refers to the average monthly volume, the duty cycle should be thought of as a “peak volume” for a digital press. The press cannot be run on a regular basis at duty cycle volumes. The Duty Cycle of the Xerox® Iridesse® Production Press is 2.25M prints.

Customers will also achieve improved system uptime and elimination of certain service calls through the Xerox Productivity Plus Basic program. Xerox Productivity Plus Basic is a self-maintenance program that will enable trained operators to replace certain parts and perform other service and diagnostic tasks. The program will provide supplies, documentation, and Technical Key Operator training, which will be scheduled with the Xerox Customer Service Engineer or Analyst at or shortly after installation. Following the initial training, if the customer requires additional people to be trained it may be chargeable or the service pricing may be adjusted. If the customer fails to perform the maintenance tasks, the service entity will be able to charge the customer for the service labor performing these tasks.

Product Specifications

The following table contains the specifications for the performance of the Xerox® Iridesse® Production Press:

<table>
<tr><th>ITEM</th><th>XEROX® IRIDESSE® PRODUCTION PRESS</th><th>COMMENTS</th></tr>
<tr><td>Paper weight range (internal trays)</td><td>• 52–400 gsm
• 16 lb Bond–148 lb Cover</td><td>• Coated and Uncoated
• Certain stocks heavier than 360 gsm may exhibit higher jam rates than lighter stocks.
• Certain stocks with high tensile strength may not process through the paper path.</td></tr>
<tr><td>Media Type</td><td>Coated stocks, uncoated stocks, drilled stocks LEF, transparencies, and special materials as defined in the RML (recommended media list)</td><td>Special materials and transparencies may not run as reliably as centerline paper.
Coated paper, lighter than 100 gsm, may not run as reliably as coated paper 100 gsm or heavier.</td></tr>
<tr><td>Paper Size</td><td>Standard Papers—JIS B5 (LEF/SEF), 8.5 in. x11 in./A4 (LEF/SEF), JIS B4 SEF, 11 in. x 17 in./A3 SEF, 8 in. x 10 in. LEF, 8.5 in. x 13 in. SEF/LEF, 8.5 in. x 14 in. SEF, 12 in. x 18 in. SEF, SRA3 (320 mm x 450 mm) SEF, 13 in. x 18 in. SEF, 13 in. x 19 in. SEF, 12.6 in. x 19.2 in. SEF
Non Standard—182 mm to 330 mm (7.2 in. to 13.0 in.) across the feed direction and 148 mm to 488 mm (5.83 in. to 19.2 in.) in the feed direction.
Post cards—4 in. x 6 in (102x154mm). post cards can be fed from the optional High Capacity Feeder (HCF). An inserter is included with the HCF for this purpose.
Extra Long Sheets – Sheets up to 1.2m (47.2 in) long may be fed through the MSI tray, up to 400gsm.
The maximum auto-duplex length is 729mm (28.7 in), up to 400gsm paper weight.</td><td>SEF = Short Edge Feed
LEF = Long Edge Feed
Papers that are 80 gsm or lighter and less than 210 mm (8.3 in.) may have increased jam rates.
The term Extra Long Sheets, or XLS, in this document refers to sheets that are between 488.1mm and 1.2m</td></tr>
<tr><td>Imageable Area</td><td>Maximum imageable area is 326 mm x 1196 mm (12.83 in. x 47.09 in.).
Guaranteed Image Quality Area:
<table>
<tr><th>Paper Length</th><th>Guaranteed IQ Area (Width x Length)</th></tr>
<tr><td>148 – 488mm</td><td>317 x 484mm</td></tr>
<tr><td>488.1 – 660.4mm</td><td>317 x 656mm</td></tr>
<tr><td>660.5 – 729mm</td><td>317 x 725mm</td></tr>
<tr><td>729.1 – 1200mm</td><td>317 x 1190mm</td></tr>
</table></td><td>All sheets will have a 2 mm–4 mm (0.16 in.) border without printing, regardless of sheet size. Default border is 2.1 mm.</td></tr>
<tr><td>Input Media Capacity (base configuration)</td><td>2 trays; 2,000 sheet capacity each</td><td>Represents capacity using Xerox® Color Iridesse® Production Press centerline paper.</td></tr>
</table>

ITEM	XEROX® IRIDESSE® PRODUCTION PRESS	COMMENTS
Print speed by media weight range (PPM for A4 / 8.5" x 11", Long Edge Feed, Simplex)	Single Weight Mode Productivity	• Single Weight Mode enables all stocks to print at full rated speed, assuming a job consists of a single paper weight. • On Mixed Media jobs (multiple paper weights within a job), productivity will be affected as fuser temperature is optimized for each stock. Two Mixed Weight Mode settings are provided to improve productivity on Mixed Media jobs. Please refer to the Mixed Weight Mode sections of this document for details. • Precise specs are in gsm paper weights; Bond, Text, and Cover weights are shown for reference only.
55–157 gsm 16–40 lb Bond; 40–100 lb Text	120 ppm	
158–220 gsm 110 lb Text; 60–80 lb Cover	120 ppm	
221–400 gsm 85–148 lb Cover	120 ppm	
Transparency feeding	High Productivity Mode—120 ppm High Image Quality Mode—60 ppm	
Resolution	Imaging 2400 x 2400 x 1 dpi RIP Resolution 1200 x1200 dpi x 10 bits/pixel	
Internal screens	150 cd, 150 rls, 175 cd, 200 cd, 200 rls, 300 cd, 600 cd, Stochastic	cd = Clustered Dot rls = Rotated Line Screen
Service Call Rate	Approximately 2.5 service calls/month.	Based on 225K AMIV. Actual service call rate is influenced by total print volume, environmental conditions, area coverage, and media characteristics.
Shutdown Rate (power-off power-on)	On average, approximately 3.5 shutdowns per month.	Based on 225K AMIV, one 8-hour shift per day, using Xerox® Color Iridesse® Production Press centerline paper.
Offsetting Catch Tray (Standard Output Device)	500 sheets	Represents capacity using Xerox® Color Iridesse® Production Press centerline paper.
Registration *1	• Image-to-paper placement on a simplex print or the first side of a duplex print can vary up to +0.5 mm in the feed direction and +0.5 mm cross-feed. • Image-to-paper alignment on the second side of automatically duplexed prints can vary up to +0.5 mm in the feed direction and +0.5 mm cross-feed. • Front-to-back alignment can vary up to a maximum of +0.5 mm in the feed direction and +0.5 mm cross-feed. • Color-to-Color 95% ≤ 70 microns	Depending on paper stock, machine setup, and other factors. Auto-duplexed Extra Long Sheets (488.1mm – 729mm) will exhibit greater Front to back alignment variation: - 488.1 – 660mm = +/- 1.0mm - 660.1 – 729.00mm = +/- 3.0mm The registration of sheets that are manually re-fed cannot be guaranteed.

****1 Registration specification applies only to Xerox® Iridesse® Press centerline paper measured on an 11 x 17" (A3) sheet.***

To achieve registration results with paper other than centerline paper, Xerox recommends that you use the Full Width Array to create Auto Alignment profiles for those stocks.

- ***Referenced from baseline Recommended Media List and tested substrate list ("Tested Substrate List" or "TSL").***

- ***Potential for additional 0.2mm variance for paper cut variation from RML stocks. Non-RML stocks may have larger paper cut variation which cannot be guaranteed and may cause larger variations.***
- ***IEC added: Xerox® Iridesse® meets Product Safety Standard IEC 62368-1.***

ITEM	XEROX® IRIDESSE® PRODUCTION PRESS	COMMENTS
Meters— the Billing display screen will show the following meters	• Color Impressions • Black Impressions • Total Impressions • Color Large Impressions • Extra Long Impressions	**Large Size Definition**—For the Xerox® Iridesse® Production Press, a large sheet is defined as having greater than or equal to 145 square inches (935.5 sq. cm) in total area **and** is less than or equal to 19.33 in. (491 mm) in length. For example: • 8.5 x 14 in. is NOT oversize (119 sq. in.) • 11 x 17 in. is oversize (187 sq. in.) • A3 is oversize (124,740 sq. mm) • A4 is NOT oversize (62,370 sq. mm) **Note**: For jobs that contain ONLY SDI's (Clear/Gold/Silver/White/Fluorescent Pink), no CMYK content, the Color, Black, and Color Large Impressions meters will NOT increment. If a job is run on Extra Long Sheets however, that meter will in fact increment even if the job only has SDI's. **Extra Long Definition:** For billing* on the Iridesse® Production Press, an extra long sheet is defined as having a length that is greater than 19.33 inches (491mm) ("Extra Long Sheet"). The Extra Long Impressions meter will increment as a function of the length of the sheet: – 491mm → 661mm = +2 – 662mm → 877mm = +3 – 878mm → 1083mm = +4 – 1084mm → 1200mm = +5 *(*note: the definition of an Extra Long Sheet for billing purposes (19.33in / 491mm) is slightly longer than the technical definition of an Extra Long Sheet (19.2in / 488mm) used in the rest of this document)*

Product Limitations

- The maximum rated print speed may be affected by job types and job settings. Productivity may be affected by the press cycling down / cycle up within or between jobs and Finishing options that are selected for a particular job.
- Overall productivity may also decline due to the press pausing to make adjustments to maintain consistent image quality. More frequent image quality adjustments and more severe productivity loss may be seen for the following job types. Note that impact to productivity depends on the specific attributes of each job.
  - 4-over-1 jobs (i.e., duplex job with color side 1, black side 2), particularly when the black area coverage is low (3% or less).
  - Jobs with mixed content of color and black-only pages.
  - Low area coverage jobs (3% area coverage per color or lower).
  - High area coverage (above 60% per color).
  - Complex mixed media jobs—see the sections on Mixed Media Productivity for guidelines and specifications.
- If utilizing the Catch Tray, overall productivity will decline if offsetting mode is selected. The print engine will pause printing in order to offset between sets, and then resume. Productivity loss depends on the number of sheets per set, with single-page jobs representing the worst case (approximately 50% productivity loss).
- The Xerox® Iridesse® Production Press has 8 print modes (see “Optional Fifth and Sixth Housings for Specialty Dry Inks” section for more details on print modes). When the engine changes print modes (based on the jobs submitted), at the start of the job with the new print mode, the print engine can take up to 2 minutes to adjust color to color registration and other system settings. The print engine PC-UI will display “Adjusting Image Quality” during this time.
- Tabs or Ordered/Sequenced stock will need to be confirmed by the operator when the printer is powered on and when exiting power save mode. This is done by opening the paper tray, verifying that the first tab or sheet in the series is on top, and then closing the paper tray.
- When printing a duplex job that utilizes Tabs, overall productivity will decline because the press must switch between Simplex mode (for Tabs) and Duplex mode (for body sheets). The severity of productivity loss depends on the number of Tabs in the job (more Tabs results in greater loss of productivity).
- A job may contain at most one ordered stock type (e.g., Tabs). If a job attempts to use more than one ordered stock, a fault will occur.
- If the operator changes the Auto Tray switching from the default “Near Empty” to “Empty”, the print engine will pause to switch the new tray.
- If the customer network is using a 100.100.100.x IP address series, conflicts will occur.
- Productivity / Speeds cited in this document are valid when sending pages to the OCT or top trays. Some productivity / speed reductions may occur when sending pages to other modules for finishing (booklet making, hole punching, etc.).
- Printing of 350 gsm–400 gsm media is only guaranteed to the PR finisher top tray. When sending to other locations (e.g., HCS stack trays, HCS top tray, etc.), paper handling and stack quality may be degraded for some stocks.
- Multiple passes of CMYK or any of the Specialty Dry Inks (“SDIs”) are possible. After the first pass, the sheets must be unloaded and reloaded in the feeder, then re-printed on. Note that mis-registration may occur for fine details and small areas on additional passes. The level of mis-registration is directly related to how many passes are performed.

  - Multiple passes of Gold or Silver are possible, however no more than 2 are recommended due to a reduction in the overall metallic look and feel.
- Mixed metallic effects are best created when Gold or Silver are loaded in Station #6, the underlay. Note that the file design must have the metallic layer multiplied or set to overprint in order to have the mixed metallic effect. Also note that an underlay of approximately 60% Silver or Gold will result in the largest possible metallic color gamut.
- "Stamp" metallic effects are best created when Gold or Silver are loaded in Station #1, the overlay. The file design for metallic objects should be set to leave "overprint fill" unselected or "normal".

Note: The "stamp" effects are possible when Gold and Silver are loaded in Station #6, the underlay, however the file design must have the objects set to "knockout".

If the file design has both "overprint" and "multiply" enabled, the file will likely print with unexpected results.

- Some files may have crop-marks that are defined in Adobe applications to lay down all available colors. When printed on a Xerox® Iridesse® Production Press, this will cause any SDIs that are loaded to be used even if the rest of the page has no SDI callouts in the file. This can be avoided by changing the definition of the crop marks to black only in the file, or by removing the SDI housings.
- Printing on envelopes is possible, however performance is not guaranteed. Envelopes are not recommended.
- Iridesse® inks can be used under the following well defined conditions* of use:
    - Indirect food contact – that is, the non-food contact side of the packaging

      AND

    - With an acceptable functional barrier
        - Current acceptable materials that qualify as functional barriers include
            - Aluminum
            - PET (virgin material)
                - US >1mil (25 microns) thick for use at room temperature and below
                - EU >0.5mil (12 microns) thick for use at room temperature and below
            - Glass / ceramic

All other conditions of use must be defined and tested at the responsibility of user

*(*Note that **any** other conditions of use must be defined and tested.)*

- Some digitally optimized sheets may exhibit poor toner adhesion- refer to the Tested Substrate List. Jobs that have a high area coverage of gold or silver that are sent to the C/Z folder for folding may exhibit a greater rate of jams.
- This product does have an Auto Tray Switching feature that enables the press to automatically switch paper trays when one becomes empty (assuming another tray has the same stock). However, this tray switching does not apply to either the Multi-Sheet Inserter (Bypass) or the Inserter / Interposer.

Note: The operator can set how much paper is left in a tray before the switching occurs. If the setting requests that the tray be completely empty, note that there will be a delay in switching to the next tray.

- Jobs printed on Extra Long Sheets (longer than 488mm) must be fed from the MSI / Bypass tray.
    - Due to static and friction, the longer sheets can exhibit more multi-feeds.
    - The frequency of multi-feeds can be reduced by hand separating sheets before loading them into the MSI. No more than 20 Extra Long Sheets should be loaded into the MSI at a time. This limitation can be improved by installing the optional XLS Air Assist Feeder Option.
    - If hand separating sheets and then loading ~20 doesn't work, feed each sheet one at a time (i.e. put one sheet in the tray, submit the job, allow the first sheet to be fed, then place another in the tray to be fed, etc.). Note that this will cause the print engine to cycle down and will therefore affect productivity / effective print speed.
- Extra Long Sheets may cause more severe jams than "standard" sized sheets.
- Certain system modes, setups, or stock types may be incompatible with Extra Long Sheets.
- If printing 100% Specialty Dry ink on an XLS media size, results may vary. Due to the nature of metallic toner and the xerographic process, the resulting image density may change when printing consecutive sheets of 100% density on XLS size media.

Image Quality

- As with any printing process, artifacts will occur. These may include fine scratches in the process direction, 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. Random artifacts will occur. Artifact-sensitive jobs should be monitored. Using products on the Recommended Media List and maintaining your environment will also help to minimize the occurrence of these artifacts. Consult the Tested Substrate List for additional guidance.
- Like other color reproduction processes, there will be some variation of output quality over time. Factors contributing to this can include frequency of calibration (including calibration to the stocks being used), extended runs of low area coverage (<3% area coverage per color separation), and xerographic components.
- If longer runs of Black-only (K-only) jobs are printed in 4-color mode, image quality may show higher variation over the course of the job. This can be mitigated by ensuring that job properties are set to “Grayscale” or “K (Black) Only” Mode at the print server.
- Color quality perception is subjective and will be affected by ambient lighting conditions. It is recommended that prints be viewed under a consistent light source, such as a D50 light booth.
- Image quality is strongly influenced by paper surface structure, texture, and color. To ensure that your customers are optimally satisfied, key applications should be proofed on the Xerox® Iridesse® Production Press using representative paper and reviewed by the customer.
- When printing on heavy metallic / mirror-like stocks, edge defects may occur in the printed area. This may be avoided by shifting the image or shrinking it to increase the distance between the imaged area and the edge of the page.
- Areas of solid Gold or Silver dry ink that span the width of the entire sheet may exhibit some banding. This can be avoided by breaking up the gold / silver areas such that they do not span the full width of the sheet.
- The visual appearance of silver underlay with 100% solid black on top may not be as the designer intended. Switching K-Overprint to “off” at the digital front end (“DFE”) will improve this. Testing should be done to validate that visual appearance is improved.
- Tinted fonts may look “soft” at the edges, particularly when adjacent to other tinted areas. This can be improved by switching to a lower LPI halftoning screen or switching to a rotated line screen.
- Jobs printed with white SDI on dark and colored stocks may exhibit a mottled appearance. Remedies to this mottle include:
    - Performing a 2nd bias transfer setup at the Control Center. It is recommended to run 2nd bias transfer before every job that uses white toner on dark and colored medias.
        - Note: 2nd bias transfer setup cannot be automated for white toner. Xerox recommends making adjustments to transfer voltage manually by running the specific job to be printed to evaluate white and white + cmyk quality.
            - Note that many dark medias require an increase in voltage, not a decrease, usually in the range of 100% - 150%, though not exclusively.
            - Note that pearlescent stocks tend to require a slight decrease in voltage.
    - Keep medias packaged and do not mix and match opened and unopened reams of dark stocks.

- Printing white toner on transparent films at lighter area coverages (~25%) can exhibit non-uniformities similar to mottle.
- A single “hit” of white may not be sufficient on all media types. Applying a second hit of white (overlay + underlay) can help improve performance. This 2nd hit of white is performed at the EFI in the Specialty Color tab.
    - Note that on some specialty medias (in particular coated medias), a double hit of white may exhibit some level of adhesion problems on the page. This can be addressed by using slightly less than 100% of white for each hit – either in the file itself or at the DFE.
    - Alternatively, adjustments can be made to the fusing temperature to improve toner adhesion to the media.
    - On certain medias the toner adhesion may worsen after hours or even days. Some medias may simply not be appropriate for double hits of white toner due to adhesion issues.
- Jobs that use white toner as an underlay with CMYK may show an edge where the white toner is visible. To minimize this, turn on trapping at the DFE and set the value to 1 pixel, elliptical shape.
- Double “hits” of Gold and Silver are possible (both underlay and overlay stations) and can be selected at the DFE. However, a double hit of Gold or Silver does not increase the shine or sparkle, rather it tends to darken the shade of the metallic.

- Carbonless Stock: This printer may run Xerox® brand collated carbonless stock, not to be confused with NCR-brand carbonless or non-collated carbonless which is not recommended because of reduced print quality results and negative impact to print reliability.

    Note: When using NCR-brand carbonless or non-collated carbonless stock:
    - reliability may decrease
    - special technical representative cleaning procedures are required (not covered by FSMA and are thus, billable.)

    -Although this printer is approved to run Xerox® brand collated carbonless stock applications, it is not recommended to do so extensively or exclusively.
    -For best results, please run Xerox® brand collated carbonless stock.
    -Please note that Xerox® brand collated carbonless stock may or may not be available for purchase in your geographic area.

Xerox® Iridesse® Production Press Print Speed—Single Weight Paper Mode

Single Weight Paper Mode refers to the default productivity mode for the press. In this mode, for basic paper types, the Xerox® Iridesse® Production Press maintains its rated speed across the entire range of supported paper weights (52–400 gsm). The rated speed depends on the size of the substrate and, for A4 / 8.5 x 11 paper, the orientation of the paper. The productivity specifications assume that a job contains a single paper weight and type; for Mixed Media (multiple paper weights within a job), see the following section on Mixed Media Productivity.

Note: Sheets fed through the Multi-Sheet Inserter (MSI) / Bypass tray will be at a lower speed than what is shown in the tables below.

For both transparencies and embossed (textured) papers, a “High Image Quality Mode” is provided that allows you to achieve better overall image quality while printing at reduced speeds (Note that this mode is not available for Extra Long Sheets). Use of this mode depends on your overall requirements for image quality on a particular application.

The tables below show the print speed of the Xerox® Iridesse® Production Press across the full range of paper sizes that the press supports. Note that print speed may be affected by the Finishing option selected for a particular job.

	Paper length (in the feed direction)				Xerox® Iridesse® Production Press Productivity (PPM)	
Media Type / Weight	**Examples: Standard Sizes**	**Feed Direction***	**Min.**	**Max.**	**Simplex**	**Duplex**
Paper 52–400 gsm 16 lb Bond–130 lb Cover (Other than Transparency)	8.5 x 11 A4	LEF	7.2 in. 182.0 mm	8.5 in. 216.0 mm	120	60
	8.5 x 11	SEF	8.51 in. 216.1 mm	11 in. 280.0 mm	96	48
	A4 8.5 x 14 11 x 17 12 x 18 13 x 19 A3 SRA3	SEF	11.01 in. 280.1 mm	19 in. 482.6 mm	60	30
	N/A	SEF	19.01 in. 482.7 mm	19.2 in. 488.0 mm	48	24
Post card **4”x 6”**	4 x 6	SEF	6 in. 152.4 mm	6 in. 152.4 mm	120	NA
Transparency **High Productivity Mode**	8.5 x 11 A4	LEF	210.0	216.0	120	NA
Transparency **High IQ Mode**	8.5 x 11 A4	LEF	210.0	216.0	60	NA

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

—continued

Media Type / Weight	Paper length (in the feed direction) Examples: Standard Sizes	Feed Direction*	Min.	Max.	Xerox® Iridesse® Production Press Productivity (PPM) Simplex	Duplex
Embossed Paper High Productivity Mode	8.5 x 11 A4	LEF	7.2 in. 182.0 mm	8.5 in. 216.0 mm	120	60
	8.5 x 11	SEF	8.51 in. 216.1 mm	11 in. 280.0 mm	96	48
	A4 8.5 x 14 11 x 17 12 x 18 13 x 19 A3 SRA3	SEF	11.01 in. 280.1 mm	19 in. 482.6 mm	60	30
	N/A	SEF	19.01 in. 482.7 mm	19.2 in. 488.0 mm	48	24
Embossed Paper High IQ Mode	8.5 x 11 A4 8.5 x 11 (SEF)	LEF	7.2 in. 182.0 mm	11 in. 280.0 mm	60	30
	A4 8.5 x 14 11 x 17 A3	SEF	11.01 in. 280.1 mm	17 in. 431.8 mm	40	20
	12 x 18 13 x 19 SRA3	SEF	17.01 in. 431.9 mm	19.2 in. 488.0 mm	36.9	18.4

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

Extra Long Sheet Print Speed:

Extra Long Sheets are only capable of running from the MSI tray, and they only run in the Single Weight Paper Mode. Speeds are as follows:

Paper Length	Simplex Speed	Duplex Speed
488.1 – 585mm	40	20
585.1 – 729mm	34.3	17
729.1 – 1200mm	20	NA

Xerox® Iridesse® Production Press Mixed Media Productivity and Productivity Modes

In Single Weight Mode, productivity will 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. Therefore, two Mixed Weight Mode settings are provided to enable improved overall productivity on mixed media jobs. In the Mixed Weight Modes, the fuser temperature is fixed over defined ranges of media weights. Print speed (PPM) may be reduced for heavier weights, but depending on the attributes of the job, overall productivity is generally better in these modes. The choice of a particular mode depends on the job attributes (media types and weights) as well as unique job requirements and customer preference for gloss level. The optimized for productivity mode will print with an increased fuser temperature for all stocks which may increase gloss levels on lighter gsm papers.

Note:

Sheets fed through the MSI / Bypass tray will be at a lower speed than what is shown in the tables below. The tables below summarize the productivity for different media weights and sizes.

Print speed may be affected by the Finishing option selected for a particular job.

Mixed Weight Mode—Optimized for Productivity (Identical to Single-Weight Mode)

	Paper length (in the feed direction)				Xerox® Iridesse® Production Press Productivity (PPM)	
Media Type / Weight	**Examples: Standard Sizes**	**Feed Direction***	**Min.**	**Max.**	**Simplex**	**Duplex**
Paper 52–400 gsm 16 lb Bond–140 lb Cover	8.5 x 11 A4	LEF	7.2 in. 182.0 mm	8.5 in. 216.0 mm	120	60
	8.5 x 11	SEF	8.51 in. 216.1 mm	11 in. 280.0 mm	96	48
	A4 8.5 x 14 11 x 17 12 x 18 13 x 19 A3 SRA3	SEF	11.01 in. 280.1 mm	19 in. 482.6 mm	60	30
	N/A	SEF	19.01 in. 482.7 mm	19.2 in. 488.0 mm	48	24

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

Mixed Weight Mode—Balanced for Speed and Image Quality (2-Weight Mode)

Media Type / Weight	Paper length (in the feed direction)				Xerox® Iridesse® Production Press Productivity (PPM)	
	Examples: Standard Sizes	Feed Direction*	Min.	Max.	Simplex	Duplex
Paper 52–220 gsm 16–40 lb Bond– 60–80 lb Cover * Same Productivity as Single Weight Mode	8.5 x 11 A4	LEF	7.2 in. 182.0 mm	8.5 in. 216.0 mm	120	60
	8.5 x 11	SEF	8.51 in. 216.1 mm	11 in. 280.0 mm	96	48
	A4 8.5 x 14 11 x 17 12 x 18 13 x 19 A3 SRA3	SEF	11.01 in. 280.1 mm	19 in. 482.6 mm	60	30
	N/A	SEF	19.01 in. 482.7 mm	19.2 in. 488.0 mm	48	24
Paper 220–400 gsm 60–80 lb Cover 140–150 lb Cover * Lower ppm compared to Single Weight Mode	8.5 x 11 A4	LEF or SEF	7.2 in. 182.0 mm	11 in. 280 mm	60	30
	8.5 x 14 11 x 17 A3	SEF	11.03 in. 280.1 mm	17 in. 431.8 mm	40	20
	12 x 18 13 x 19 SRA3	SEF	17.004 in. 431.9 mm	19.2 in. 488.0 mm	36.9	18.4

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

Tray Switching and Mixed Media Test Results

The table below provides test results on several job types that utilize mixed media and that require paper tray switching. These jobs were tested by Xerox to provide representative productivity. Results for similar jobs may vary depending on the Color Server, specific media, paper trays, and Mixed Media mode that are used.

JOB DESCRIPTION	CONFIGURATION	RESULTS*, **
10 sheets, all 8.5 x 11 LEF 90 gsm, alternating between two trays—1 sheet per tray	Run to HCS and Standard Finisher Stack tray with set offset. Auto Tray Switch Timing set to Tray Near Empty.	120 ppm
10 sheets, all 8.5 x 11 LEF, sheets 1 and 10 200 gsm, sheets 2–9 90 gsm	No Tray Impact (Tray 1 to 2 or Tray A1-1 to A1-2). Auto Tray Switch Timing set to Tray Near Empty.	120 ppm
3 sheets from different trays, all 8.5 x 11 LEF, sheet 1: 200 gsm, sheet 2: 90 gsm, sheet 3: 90 gsm	Auto Tray Switch Timing set to Tray Near Empty.	120 ppm
30 sheets, all 11 x 17 90 gsm uncoated. sheets 1–10: tray 1, sheets 11–20: tray 2, sheets 21–30 tray 3	Auto Tray Switch Timing set to Tray Near Empty.	60 ppm
23 sheets, all 8.5 x 11 LEF 90 gsm, (4 from tray 1, 1 from tray 3)*3 then (1 from tray 1, 1 from tray 3)*4	Auto Tray Switch Timing set to Tray Near Empty.	120 ppm
225 pages, 8.5 x 11 210 gsm Cover, 90 gsm body with 13 9x11 tabs, 15 sheets between tabs: cover, 15 sheets, tab, 15, tab, 15, tab, 15, cover	No tray restrictions. Auto Tray Switch Timing set to Tray Near Empty. Cannot stack in HCS.	80 ppm

* Switching between coated and uncoated media will cause slower speeds than what is shown in the table.

** All results listed in “Mixed Weight—Optimized for Productivity mode”. Other productivity modes will exhibit reduced speeds.

Note that “mixed plex” (pages with both duplex and simplex) jobs will exhibit reduced productivity vs. those that are all either simplex or duplex.

Full Width Array

The Full Width Array ("FWA") enables automation of several common image quality management tasks. These procedures are "automated" in that they eliminate the need for an operator to manually scan target sheets using an external device and manually update or store system values. The FWA procedures must be initiated by an operator at either the Print Server or at the Control Center. All target sheets are then generated and scanned automatically, and all measurements, calculations, and corrections are performed automatically. For several of the FWA processes, manual inspection of a confirmation print is required.

Note: The FWA ***does not*** monitor or make adjustments within a print job.

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

The procedures that are enabled by the FWA are listed and described below.

- Density Uniformity Adjustment
    - Note: Density Uniformity Adjustment will not function with Extra Long Sheet sizes.
- Image to Media Alignment
    - Note: Image to Media Alignment will function with Extra Long Sheet sizes, however it will not work with dark medias.
- 2nd bias transfer roll auto adjustment
    - Note: 2nd bias transfer adjustment will not function with Extra Long Sheet sizes. Also, 2nd bias transfer adjustment does not include White specialty dry ink.
- EZ Press Check
- Print Server Calibration
- Custom Profiling

Automatic Density Uniformity Adjustment

- This procedure must be initiated by an operator at the press Control Center screen.
- Density Uniformity Adjustment is done to ensure even toner density across the page ("inboard to outboard") as well as up and down the page (i.e., paper process direction / lead edge to trail edge). This is particularly important for high area coverage applications where uniformity from edge to edge is more critical.
- Once this process is initiated, the press automatically prints density test patterns, measures inboard to outboard density values, and corrects for variations by adjusting print engine software controls.
- This process does not monitor density within a print run. It is used prior to a shift or a print run to correct any existing variations in density across a page.
- Automatic Density Uniformity should be run after xerographic components (photoreceptor drum, charge corotron, etc.) are replaced OR if inboard to outboard density uniformity defects are observed.
- Use white paper. Gloss and paper weight should be "centerline" for the range of stocks you plan to run.

- This procedure includes a manual inspection step to confirm quality. Inspect quality on the confirmation print, not the targets. If the confirmation print is not acceptable after auto-adjustment, then the customer should retry the routine. If still unacceptable, a service call will be necessary.
- Larger size paper (SRA3 or 13 x 19) will tend to yield optimal results.

Automatic Image to Media Alignment

- This procedure must be initiated by an operator at the press Control Center screen.
- This process helps to ensure correct positioning of the print image on the media and is important for calibrating new stock types. This is particularly useful when front-to-back registration is critical to a job.
- When this process is initiated, the press automatically prints test patterns, measures them, and makes automatic adjustments to registration, skew, perpendicularity and magnification.
- This procedure should be run when using new papers, especially when image on media registration and front to back registration are critical, or if an alignment problem (registration, skew, etc.) is observed.
- The registration profile that is established is optimized for a particular paper tray. If a media is being run from multiple tray locations, the Image to Media Alignment procedure should be used for each media / tray combination.
  - Use a naming convention for the profiles to help ensure that the correct profile is applied to the media/tray being used (Example: PaperType_Tray_Date).
- Alignment profiles may need to be rerun or updated following extreme changes in temperature or humidity, or following a service procedure to a paper tray. Otherwise, the profiles should not “expire.”
- This procedure includes a manual inspection step to confirm quality. Inspect quality on the confirmation print, not the targets. If the confirmation print is not acceptable after auto-adjustment, retry the routine. If still unacceptable, a manual setup will be required.

Automatic 2nd Bias Transfer Roll Adjustment

- This procedure must be initiated by an operator at the press Control Center screen.
- The 2nd Bias Transfer Roll Adjustment is done to ensure even toner density and smooth tinted areas on various kinds of medias including thick stocks, synthetics, and textured stocks.
- Once this process is initiated, the press automatically prints test patches at various 2nd bias transfer roll settings, measures the patches for the smoothness of the resulting tints, and selects the optimal (smoothest) setting for that particular stock.
- This process does not monitor quality within a print run. It is used prior to a shift or a print run to optimize performance for a particular stock.

Note: This adjustment may also be made manually / visually by the operator. This visual method, although slower, may be capable of slightly superior results as compared to the automatic FWA method.

- Changes in temperature and/or humidity will typically require the 2nd bias transfer roll adjustment to be re-run for optimal press / stock performance.

EZ Press Check

- This procedure must be initiated by an operator at the press Control Center screen.
- The EZ Press Check enables multiple print engine adjustment routines (Density Uniformity, Image to Media Alignment, and 2nd Bias Transfer Roll) to be run all at once.
- EZ Press Check can be performed to optimize press performance on a particular stock before running a quality-critical job.

> **Note**: EZ Press Check does NOT adjust color management. Color Calibration and Custom Profiling must be performed, if desired, at the DFE controller.

- This process does not monitor quality within a print run.

Print Server Calibration—Automated Color Quality Suite (ACQS)

Automatic Print Server Calibration is a component of the Automated Color Quality Suite and is enabled with the Full Width Array. This procedure must be initiated by an operator at the print server.

- 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 Calibration is accomplished in two to three minutes per halftone (line screen) using the Full Width Array.
- The external (handheld) spectrophotometer that is included with each print server can still be used for manual print server calibration, if preferred.
- 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 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 Automatic Calibration is activated, the target sheets are printed, scanned and ejected to the purge tray location (for example, the Offset Catch Tray or the top tray of a High Capacity Stacker). Each purge tray location has a capacity of 500 sheets (based on 120 gsm stock). When performing Automatic Calibration, a full tray will cause a jam to occur. In most cases, once the jam is cleared, the printer will be able to resume calibration. If the Automatic 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.
- Automatic Printer Server Calibration with the FWA cannot be used with stock sizes smaller than 8.5" x 11" / A4. In these cases, manual calibration with the external spectrophotometer would be required.

Advanced Profiling—Automated Color Quality Suite (ACQS)

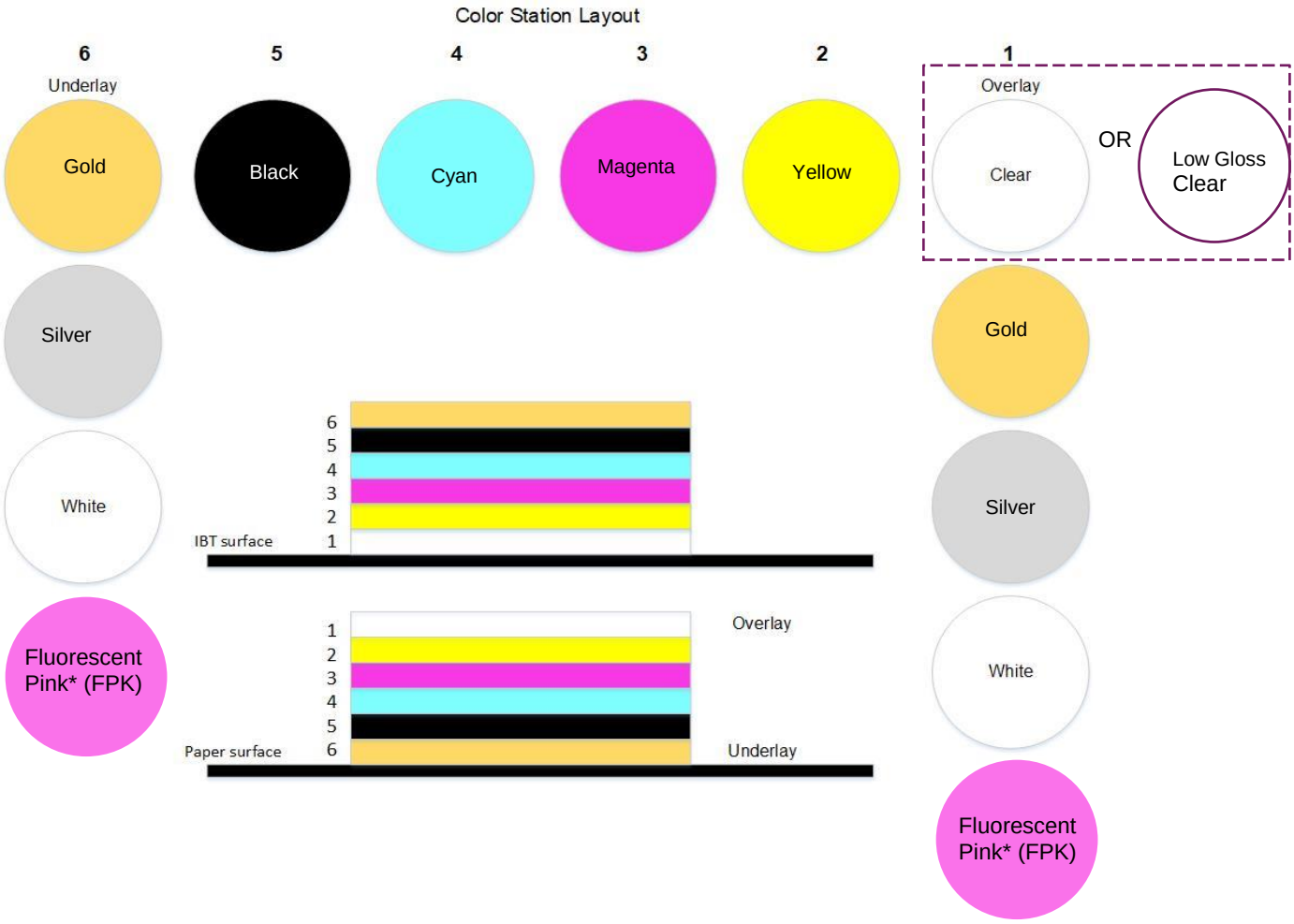
Advanced Profiling is a component of the Automated Color Quality Suite and is enabled with the Full Width Array. The FWA Advanced Profiling procedure must be initiated by an operator at the print server.

- Advanced Profiling creates custom ICC-compliant Destination Profile for color critical applications that require a high degree of color accuracy. Using the Full Width Array, this procedure will automatically print target sheets, measure how closely they match a selected aim (standard) and generate a profile, all on the press.
- Advanced Profiles are utilized exactly the same way as other destination profiles.
- 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.

Optional Fifth and Sixth Housings for Specialty Dry Inks

- Specialty Dry Inks are Low Gloss Clear Dry Ink, Clear Dry Ink, White Dry Ink, Gold Dry Ink, Silver Dry Ink and Fluorescent Pink*. Up to two Specialty Dry Inks can be loaded at a time. The customer or service representative can switch between Specialty Dry Inks.
- Print speeds will not slow down when applying specialty dry inks, once the press has switched to the correct color print mode (e.g., 4 color to 5 color, etc.)
    - Switching between 4, 5, and 6 color modes will impact productivity.
- Due to the wide range of applications, Specialty Dry Inks are not available in a “Metered” plan. Customers will purchase Specialty Dry Inks and Specialty Dry Ink Developers as needed based on their usage.
- The layout of all color stations when looking at the Xerox® Iridesse® Production Press looks like the following:
- When these colors are imaged and applied to paper they look like the following image, representing a particular 6 color configuration. Note that Clear and Low Gloss Clear are NOT able to be installed and operated in station 6.
- Xerox® HD EA Fluorescent Pink* (FPK) Dry Ink (Optional)

  *Please note Xerox® HD EA Fluorescent Pink Dry Ink is offered as an option on Iridesse®, and available at an additional charge (similar to other specialty dry inks)



- Note that when choosing a 5 color configuration, you must select either the underlay OR overlay station. You cannot switch back and forth with the 5th station between the two positions.
- It is possible to load the same color in both the underlay and the overlay stations simultaneously (e.g. White and White) in a 6 color configuration. This color configuration allows the operator to, if desired, apply a "double hit" of the SDI in a single pass. This double hit capability is selected at the DFE specialty color tab.
- Clear and Low Gloss Clear are only available as an overlay. These SDIs cannot be put in the underlay position.
    - A 6 station configuration that has only one metallic plus Clear stations must keep the metallic in the underlay position as one cannot swap the two because Clear must remain an overlay.
- The maximum % area coverage on a page depends on how many color layers are being applied to the printed page. The following table shows the maximum area coverage for each color "mode".

COLOR MODE	MAXIMUM TOTAL % AREA COVERAGE	MAXIMUM CMYK AREA COVERAGE	MAXIMUM SPECIALTY DRY INK AREA COVERAGE
4 color (CMYK)	240%	240%	—
5 color (CMYK + 1 SDI in position #1, Top Layer)	260%	240%	20% - 100%*
5 color (CMYK + 1 SDI in position #6, Bottom Layer)	340%	240%	100%**
6 color (CMYK + 2 SDIs)	360%	240%	Position #1 (Top Layer): 20%-100%*** Position #6 (Bottom Layer): 100%
6 color with LGC in position #1 (LGC+CMYK + SDI in position 6)	440%	240%	100%****
5 color (CMYK + LGC in position #1, Top Layer)	*340%*	*240%*	*100%*

* With 1 SDI on the top layer, the SDI %AC will be scaled back to accommodate the max total %AC.

** With 1 SDI on the bottom layer, the SDI %AC will be untouched, allowing for the maximum amount of possible mixed metallic colors.

*** With 1 SDI on top and 1 SDI on bottom, the position #6 (bottom layer) SDI %AC will be untouched, while the position #1 (top layer) SDI %AC will be scaled back to accommodate the max total %AC.

**** LGC Dry Ink can be added to all CMYK content or specific object types during document creation or to a job at the EX-P 6 Print Server.

- An example of scaling the maximum SDI % Area Coverage (%AC) is shown in the table below. The example assumes a CMYK image with a layer of clear on top:

CMYK AREA COVERAGE	MAXIMUM SPECIALTY DRY INK AREA COVERAGE (CLEAR)
0%–160%	100% Specialty Dry Ink
161%–240%	99%–20%, up to total maximum of 260%

EXAMPLE IMAGES	MAXIMUM SPECIALTY DRY INK AREA COVERAGE
 **Darker image, higher CMYK %AC**	Approximately **74%**
 **Lighter image, lower CMYK %AC**	Approximately **96%**

Embossed Mode

When printing on embossed (textured) stocks, an Embossed mode can be selected. This mode adjusts several press settings in order to improve transfer of dry ink to the textured stock, and the impact on productivity (print speed) is described in the “Single Weight Mode Print Speed” tables above. Note that this mode is incompatible with Extra Long Sheet sizes. Note that Embossed mode can be run in either IQ or Productivity Priority mode. Running in IQ priority mode reduces the process speed to improve fusing performance.

On systems equipped with the Clear Dry Ink, when Embossed Paper High Image Quality mode is selected, the operator can choose to use 5-color print mode and take advantage of Clear Dry Ink. Choosing this mode will automatically add a layer of Specialty Dry Inks to each page in the job (approximately 20% area coverage, adjustable by operator at the DFE). Very little of the Specialty Dry Inks are subsequently transferred to the paper. Instead, the layer of Specialty Dry Ink ensures maximum transfer of the CMYK dry inks to the textured paper, thus enabling the highest color quality on the textured stock. If using Embossed Stock High IQ Mode, the additional cost of this Specialty Dry Ink should be factored into the decision of whether to use 5-Color mode.

Low Gloss Clear

When printing on textured stocks, Low Gloss Clear can be selected over ‘All Printed Content’ to increase transfer onto media. It is recommended to set the stock as a plain uncoated stock. Further improvement can be made by changing fuser performance to Image Quality and lowering belt side fuser temperature. Some of these adjustments may impact productivity (such as print speed). Running in IQ priority mode reduces the process speed to improve fusing performance.

Media Selection Guidelines

The following are the centerline paper types for the Xerox® Iridesse® Production Press:

MEDIA TYPE	XEROX EQUIVALENT	
Uncoated paper	**North America**—Xerox® Bold Digital Printing Paper (90 gsm/24 lb Bond) **Europe**—Xerox® Digital Color Colortech + (90 gsm)	Xerox® Iridesse® Production Press centerline paper
Coated paper	**North America** Verso® Futura® Gloss Text (80 lb. / 118 gsm) **Europe** Verso® Futura® Gloss Text (80 lb. / 118 gsm)	Xerox® Production Press centerline paper

- Every effort has been made to ensure that the Xerox® Iridesse® Production Press supports a broad range of media. Keep in mind, however, that using Xerox-recommended media helps maximize reliability and paper-handling performance.
- For further information and recommendations regarding media selection and handling, refer to the Recommended Media List available from your Xerox representative or on www.xerox.com/.
- Unqualified Media or Non-Approved Media - Increased service activity related to the use of media not specifically approved by Xerox for this product is not covered under the standard FSMA (or maintenance agreement) and could result in billable Xerox service activity at current T&M rates. Media usage can be managed by moving to a comparable paper with better performance from our Recommended Media List or Tested Substrate List.
- Specialty stocks that tend to be used with white toner (black paper, colored paper, film, craft stock, pearlescent, metallic, etc.) exhibit a wide variety of performance levels in terms of both print quality and jams. Testing and experimentation of these kinds of medias, including trying similar stocks from various vendors, is recommended.
- Note that performance of the same stock at various GSM weights can also vary.
- Typically, heavy weight papers exhibit increased variability of formation and surface smoothness, which may result in degraded image quality.
- Paper from the base and second feeder paper 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 if ambient relative humidity exceeds 60%.
- 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 for instructions on how 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.
- The texture of certain stocks may be somewhat visible when printing larger areas of very dark colors (black, dark blue, etc.). Performance can be improved using the 2nd bias transfer adjustment, however the texture may still be visible.
- 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.

Media Support Documentation

Media support documentation includes the Xerox® Iridesse® Production Press Recommended Materials Lists, which will be available at www.xerox.com/. Other media support documentation, guides, and tools, including the Xerox® Iridesse® Production Press Specialty Media Guide—Hints and Tips, may be available at a later date. Please consult the Recommended Media List for recommendations to get the best performance.

Duplex Prints

- The Xerox® Iridesse® Production Press can automatically produce duplex prints from all paper trays for coated and uncoated media weights across the media range of 52–400 gsm.
  - It is recommended to run 360–400 gsm papers from the internal paper trays.
  - External feeders may exhibit degraded feeding and paper transportation reliability for 360–400 gsm stocks.
- All paper sizes are supported including 8.5 x 11/A4, 11 x 17/A3,12 x 18/SRA3, and Extra Long Sheets up to 729mm. Transparencies and 4 x 6 postcards cannot be automatically duplexed.

Xerox® Iridesse® Production Press Color Prints in Other Equipment (And Vice Versa)

- Xerox® Iridesse® Production Press prints should not be run through the printing path of Xerox Nuvera® or Xerox® DocuTech® Production Publishing systems. However, the prints can be used with the Inserter / Interposer module.
- Xerox Nuvera®, Xerox® DocuTech® and other technology output, including pre-printed offset shells, should not be run though the printing path of a Xerox® Iridesse® Production Press.

If you plan to run Xerox® Iridesse® Production Press prints through other equipment, including finishing devices such as a coater or laminator, it is recommended you test the application before committing to the job. Many factors impact the success of running Xerox® Iridesse® Production Press prints in other equipment.

Transparencies

The Xerox® Iridesse® Production Press will feed 8.5 in. x 11 in./A4 transparencies at a speed of 120 ppm or 60 ppm in High Image Quality mode. For optimum system performance and image projection, we recommend using Xerox®-branded RML transparencies.

Recommended Supplies

Supply Description	Reorder Number Xerox Europe	Reorder Number Xerox North America	Reorder Number Xerox DMO	Cartridges Per Carton	Yield Projection at representative total area coverage (AC), using centerline paper		
Dry Ink— SOLD Plans (1)					AC = 7.5% per color (30% total CMYK)	AC = 11.25% per color (45% total CMYK)	AC = 15% per color (60% total CMYK)
Black	006R01711	006R01711	006R01719	1	69,000	46,000	34,500
Cyan	006R01712	006R01712	006R01720	1	82,000	54,667	41,000
Magenta	006R01713	006R01713	006R01721	1	82,000	54,667	41,000
Yellow	006R01714	006R01714	006R01722	1	82,000	54,667	41,000
Clear	006R01715	006R01715	006R01723	1	55,000	36,667	27,500
Low Gloss Clear	006R01790	006R01790	006R01791	1	55,000	36,667	27,500
Gold	006R01716	006R01716	006R01724	1	55,000	36,667	27,500
Silver	006R01717	006R01717	006R01725	1	55,000	36,667	27,500
White	006R01718	006R01718	006R01726	1	25,000	16,700	12,500
Fluorescent Pink*	006R01814	006R01814	006R01813	1	55,000	36,667	27,500
Dry Ink— METERED Plans (1)					AC = 7.5% per color (30% total CMYK)	AC = 11.25% per color (45% total CMYK)	AC = 15% per color (60% total CMYK)
Black	006R01707			1	69,000	46,000	34,500
Cyan	006R01708			1	82,000	54,667	41,000
Magenta	006R01709			1	82,000	54,667	41,000
Yellow	006R01710			1	82,000	54,667	41,000
Developer (2)							
Black	005R00756			1	12 Million		
Cyan	005R00757			1	12 Million		
Magenta	005R00758			1	12 Million		
Yellow	005R00759			1	12 Million		
Clear	005R00746			1	12 Million		
Low Gloss Clear	005R00763			1	12 Million		
Gold	005R00760			1	12 Million		
Silver	005R00761			1	12 Million		
White	005R00762			1	12 Million		
Fluorescent Pink*	005R00768			1	12 Million		
Fuser Web Assembly (standard)	008R13103			n/a	1,200,000		
Fuser Web Assembly (for film only)	008R13252			n/a	55,000		
Dry Ink Waste Bottle (3)	008R13145			n/a	200,000		

—continued

*Please note Xerox® HD EA Fluorescent Pink Dry Ink is offered as an option on Iridesse®, and available at an additional charge (similar to other specialty dry inks)

Recommended Supplies (continued)

Supply Description	Reorder Number Xerox Europe	Reorder Number Xerox North America	Reorder Number Xerox DMO	Cartridges Per Carton	Yield Projection at representative total area coverage (AC), using centerline paper
Corner Stapler Refill Staples	008R13041			With Waste Box and four (4) refills @ 5,000 staples each	
Optional Production Ready Finisher, Production Ready Booklet Maker Finisher, and Production Ready Finisher Plus					
Booklet Stapler Refill Staples	008R13177			One (1) unit @ 5,000 staples	
Optional Production Ready Booklet Maker Finisher					

(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® Iridesse® Production Press centerline paper. Please note that actual yields vary greatly depending on color intensity, area coverage, paper stock, and mode selected.

(2) Developer replacement frequency is projected to be approximately twelve million 8.5 in. x 11 in./A4 images when using Xerox® Iridesse® Production Press centerline paper and other stocks with equivalent smoothness, cut quality and structure. Replacement rates may be more frequent for operations that 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 throughput, e.g., 11 in. x 17 in./A3. Specialty Dry Ink Developer is not included in Metered supplies plans.

(3) Toner Waste Bottle replacement frequency is projected to be approximately 200,000 8.5 in. x 11 in. / A4 images when printing an average area coverage = 30% (7.5% per color).

(4) Based on 100-page books of 80 gsm stock. Yield will vary depending on book size (pages) and stock thickness.

Initial Supplies

Each Xerox® Iridesse® Production Press is delivered with one cartridge of each dry ink color, as well as a Fuser Web. Developer is pre-loaded in the machine. Contact the Xerox Welcome Center prior to system delivery to order an initial supply of paper, dry ink, developer, and a replacement Dry Ink waste bottle.

Safety Considerations for Consumables

Xerox will deliver to you certain Safety Data Sheets (“SDS”) required under the Occupational Safety and Health Administration Hazard Communication Standard in electronic form (via email, pdf file, CD or such other electronic form), which you consent to such electronic delivery via your signature on this CED. At any time, you may withdraw your consent for electronic delivery of the SDS by notifying your Xerox account representative and allowing reasonable time for Xerox to process this withdrawal. In addition to printing a paper copy of the electronically-provided SDS, you can also download the latest SDS from https://safetysheets.business.xerox.com, or request a paper copy of the SDS be mailed to you by contacting your Xerox account representative. Or, US and Canadian customers can call Customer Service at 1-800-ASK-XEROX.

Fuser Webs

Note that the Iridesse® Production Press has 2 fuser web options:

- Standard Fuser Web: For use with most stocks. This fuser web has a long life at 1.2m impressions and is included in the FSMA package.
- Special Fuser Web for Film: Only for use with films or other highly reflective stocks. This fuser web avoids a defect known as “wax offset”. It is NOT included with the FSMA package and has a much shorter life at 55K impressions. The system will warn you if you attempt to run “standard” stocks with the film fuser web (s/w versions 5.3.15 and higher).

Environmental Requirements

The Xerox® Iridesse® Production Press performance is guaranteed under the following environmental conditions:

ENVIRONMENTAL CONDITION	MINIMUM	MAXIMUM
Temperature	10 degrees Celsius 50 degrees Fahrenheit	35 degrees Celsius 95 degrees Fahrenheit
Relative Humidity (% RH)	15%	85%
Altitude		2,500 meters 8,200 feet

- When Temperature is 32° Celsius, Humidity needs to be 62.5% or below.
- When Humidity is 85%, Temperature needs to be 28 degrees Celsius or below.
- Manufacturers of coated stock do not recommend use of their media when ambient relative humidity exceeds 60%.
- Better performance is achieved when conditions are maintained between 20–25° C (68–77° F) and 45–55% RH.
- Water spots may be exhibited on the first few prints if the relative humidity exceeds 55% RH.
- The Xerox® Iridesse® Production Press is capable of proper operation at altitudes up to 2,500 meters (8,200 feet) with no additional adjustments or kits. Locations above 2,500 meters may require field adjustments.
- Shelf life expectancy of the specialty toners for Iridesse® is approximately 30 months when stored in normal indoor conditions and less than 35 degrees Celsius.

Electrical Requirements

Power supply requirements for the Xerox® Iridesse® Production Press are as follows:

ITEM	REQUIREMENT	NOTES
Power Drop for USA and Canada	208–240V / 60A	Single Phase
Power Drop for XE, DMO	220–240V / 50A	Single Phase

	ITEM	REQUIREMENT	NOTES
USA	Power Supply Voltage	208–240 VAC	+/- 10%
	Power Supply Frequency	50 Hz / 60 Hz	+/- 3%
Europe	Power Supply Voltage	220–240 VAC	+/- 10%
	Power Supply Frequency	50 Hz	+/- 3%

- For USA and Canada, the female connector/drop to connect to the Xerox® Iridesse® Production Press power cord is Hubbell HBL 360C6W (60 Amp). For more details and a picture of the receptacle, please see the Installation Planning Guide.
- The print server and each optional feeding and finishing device require an additional 100–240 VAC country-specific power receptacle.
- All machine optional accessories and print servers should be placed within 6 feet (2 meters) of wall outlets. Ensure that there are enough wall outlets available for optional accessories and the print server.

Additional Power Supply Requirements for Europe

A single phase 50amp source is required. The Iridesse® Production Press is offered in most countries with two power cord options. The first option is a kit containing a print engine power cord with flying leads. The second option is a kit with a print engine cord with an attached connector of type IEC 60309, referred to in the UK as a "commando connector", of type 2P+E -single phase and 63 A. If the power cord with connector is purchased, then the appropriate wall socket can be pre-installed by a qualified electrician; if the flying lead option is purchased, then the machine must be hardwired into the customer power supply by a qualified electrician as part of the install process.

Power consumption of the Xerox® Iridesse® Production Press performance is as follows:

OPERATING MODE	POWER CONSUMPTION	NOTES
Standby Mode	3.7 or less kVA	Including warm up time
Printing Mode	8.05 or less kVA	

- Reflects power consumption of base configuration only (Xerox® Iridesse® Production Press without additional feeding or finishing options).

Space Requirements

Please see *Installation Planning Guide* for physical dimensions.

Physical Dimensions

Please see *Installation Planning Guide* for physical dimensions.

Optional Accessories

The following devices are available for the Xerox® Iridesse® Production Press:

Xerox® PredictPrint® Media Manager* (Optional)

The Xerox® PredictPrint® Media Manager Software will automate customer workflow to improve the user experience when loading, using, and choosing media. This is intended to optimize ease of install and reduce the frequency of improperly defined stocks. A Xerox® cloud-based stock library database is used to continually improve setup and optimize system performance.

Xerox® PredictPrint® Media Manager Software Customer Benefits:

- Dramatic reduction in time to program stocks
- Stocks run with optimal settings
- Wizard led operator instructions

Xerox® PredictPrint® Media Manager Software Key Capabilities:

- Initial Startup: Assist the customer in setting up a stock/ tray
- Scan a barcode and load the paper into the machine
- Automated Engine Setups utilizing Artificial Intelligence
- Automated Color Calibration and Profiling
- Centralized Cloud Server

Xerox® PredictPrint® Media Manager Software Customer Caveats:

- If Calibration/Profiling is enabled in Xerox® PredictPrint® Media Manager Stock Wizard, and the user does not want to run these routines in the Wizard, they can be cancelled after the Calibration job is registered in the Control Center. (Calibration job appears in the GUI status area.) Please note, cancelling the routine before the job is registered may require a restart of the Iridesse® Press UI.
- When utilizing stocks such as metallic paper, deep/dark colored paper, transparent paper, or white stocks narrower than 8.3 inches (210mm) or longer than 26 inches (660mm) with Xerox® PredictPrint® Media Manager Stock Wizard, it is recommended that the user disable Calibration/Profiling in Administration before setting up these types of stocks. (When the Cancel button appears, please pause for a few seconds before selecting Cancel.)

Other Notes:

- When using Xerox® PredictPrint® Media Manager, printing a barcode requires that customers have a letter or A4 size stock loaded first in a different tray than the one being programmed. If no Letter or A4 size paper is loaded in the press, you cannot print the barcode during the setup process in the wizard. You can also print your custom barcodes from the Xerox® PredictPrint® Media Manager Stock Library at any time.

- If the barcode scanner is unplugged, you will need to reboot the Control Center to re-establish communication.

- When setting up a stock using Xerox® PredictPrint® Media Manager Stock Wizard, the 2nd Transfer routine will automatically run as needed. After running the automated routine, the setting is selected by the system. If the user chooses to adjust this setting, the routine may be run manually and adjusted based on the user's preferences.

- When setting up a specialty media using Xerox® PredictPrint® Media Manager Stock Wizard, customers may choose to disable Calibration/Profiling in Administration, or cancel the routine in the Stock Wizard, to reduce pages printed using the specialty media during setup.

Please ensure you are satisfied with Iridesse® and Xerox® PredictPrint® Media Manager as is, if improvements to the caveats listed above cannot made available in the future.

Please note Xerox® PredictPrint® Media Manager is offered as an option on Iridesse®, and available at an additional charge.

Feeding Options

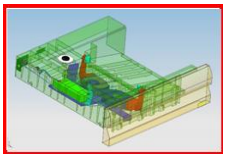
Advanced High Capacity Feeder—The optional Advanced High Capacity Feeder can be added in either single or dual configurations. Note that the feeder includes an MSI / Bypass tray.

ADVANCED HIGH CAPACITY FEEDER (SINGLE OR DUAL CONFIGURATIONS)

Capacity	• 2,000 sheets (using centerline paper) per tray • 4,000 sheets (using centerline paper) per feeder
Sizes	• Minimum: 7.2 x 7.2 in. (182 x 182 mm) • Minimum with postcard kit: 4 x 6 in. (100 x 148 mm) • Maximum: 13 x 19.2 in. (330 x 488 mm)
Weights	Range: 52–400 gsm * **Note**: Optimal performance for coated stocks is 64–350 gsm **Note**: Optimal performance for uncoated stocks is 52–350 gsm

Banner Feeder Extension Kit- Optional Banner Feeder Extension Kit that can be used to feed Extra Long Sheets.

Xerox® XLS Automatic Feeding Kit - Optional Air Assist Kit for the HCF MSI to improve XLS feeding by introducing airflow to separate the sheets.

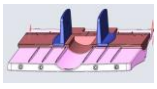


Finishing Options

Important: Refer to Configuration Dependencies for information on configuration requirements for the finishing devices.

Finishing Option	Description
Offset Catch Tray (OCT)	Holds a maximum of 500 sheets.
Interface Decurler Module 	The Interface Decurler Module transports and automatically flattens sheets based on media characteristics (weight and coating) and area coverage (front and back) and transports from the press to the finishing device; it also allows communication between the press and the finishing device. Sheet flatness can be adjusted by the operator in real time by pressing the adjustment button on the control panel on the Interface Decurler Module. The Interface Module is required with any system configuration that has one or more finishing devices, except the Offset Catch Tray (OCT).
GBC® AdvancedPunch™ Pro 	The GBC ® AdvancedPunch Pro is a compact hole punching unit that offers multiple hole punch die sets as options. The AdvancedPunch Pro is a compact device and requires only a small increase in footprint. Productivity is at rated print engine speed for most paper sizes from A4 or 8.5 x 11 (LTR) (LEF) to 12 x 18 or SRA3 media. Modules ship with a single interchangeable punch die that can be adjusted to punch a broad range of media sizes.
High Capacity Stacker (HCS) 	The HCS is designed for long production runs: • Top tray has a maximum 500 sheet capacity. • Stacking a maximum of 5,000 sheets (based on 80 gsm centerline paper) and offsetting the output in the stack tray/cart. • The movable stack tray/cart provides easy transition of the output to off-line finishing. • An additional stack tray/cart is available for the customer to order. • Sample prints are additional prints that are directed to the top tray for inspection. Sample prints are not produced by redirecting sheets from the stack tray/cart to the top tray; therefore the contents in the stack tray/cart are complete. • Two High Capacity Stackers may be chained together for additional stacking capacity.

OPTIONAL ACCESSORIES

Finishing Option	Description
Production Ready Finisher 	The Production Ready Finisher features include a 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. Options for the Production Ready Finisher: • C/Z Folder • Basic Punch • Crease and Two-Sided Trimmer
Production Ready Booklet Maker Finisher 	The Production Ready Booklet Maker Finisher features include a stapler, the stacker tray, 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. Options for the Production Ready Booklet Maker Finisher: • C/Z Folder • Basic Punch • Crease and Two-Sided Trimmer • Xerox® SquareFold® Trimmer
Production Ready Finisher Plus 	The Production Ready Finisher Plus includes the functionality of the Production Ready Finisher and adds interface/transport module to enable connection to third-party finishing solutions. Options for the Production Ready Finisher Plus: • C/Z Folder • Basic Punch • Crease and Two-Sided Trimmer
C/Z Folder 	This optional unit can perform C-Fold, Z-fold, and Z- Fold Half-Sheet (also called Engineering Z-Fold). The C/Z Folder can be added to these finishing devices: • Production Ready Finisher • Production Ready Booklet Maker Finisher • Production Ready Finisher Plus
Basic Punch	This optional module can perform a basic in-line punch function. There are three types of ring binder punch pattern options. The Basic Punch can be added to these finishing devices: • Production Ready Finisher • Production Ready Booklet Maker Finisher • Production Ready Finisher Plus
PR Finisher Banner Extension	This optional extension allows any of the PR finishers to catch Extra Long Sheets.
Top Tray Aligner 	The optional Top Tray Aligner is a small assembly installed and removed by the operator as required. The Top Tray Aligner has adjustable guides set by the operator to neatly collect output directed to the Top Tray. Customers running small stocks should see benefits as the Top Tray Aligner optimizes stacking.
Inserter 	This optional unit can be used to insert sheets into jobs to be finished without having to go through the print engine (e.g., pre-printed covers, etc.). The Inserter can be added to these finishing devices:carbon • Production Ready Finisher • Production Ready Booklet Maker Finisher • Production Ready Finisher Plus • High Capacity Stacker

Finishing Option	Description
Crease and Two-Sided Trimmer 	This optional device can perform a two-sided trim to the top and bottom of finished sets. It also enables a creasing function for bi-fold booklets as well as custom creases for post-print finishing. The Crease and Two-Sided Trimmer can be added to these finishing devices: • Production Ready Finisher • Production Ready Booklet Maker Finisher • Production Ready Finisher Plus
Xerox® SquareFold® Trimmer Module 	This optional device is available only with the Production Ready Booklet Maker Finisher (with or without the C/Z Folder). The SquareFold Trimmer Module flattens the spine of the booklet and trims the face of the booklet.

Configuration Dependencies

The following dependencies are required for all or certain configurations:

Interface Decurler Module	The Interface Decurler Module is required with any system configuration that has one or more finishing devices, except the OCT.
GBC® AdvancedPunch™ Pro	This device requires the Interface Decurler Module and another finishing device, such as the High Capacity Stacker, Production Ready Finisher, Production Ready Booklet Maker Finisher, or Production Ready Finisher Plus.
SquareFold Trimmer Module	This device requires the Interface Decurler Module and the Production Ready Booklet Maker Finisher Module and is not available with any other finishing device.
Crease and Two-sided Trimmer, Basic Punch, and Inserter	These devices require the Interface Decurler Module and the Production Ready Finisher, Production Ready Booklet Maker Finisher, or the Production Ready Finisher Plus.
Production Ready Finisher Plus	This device requires the Interface Decurler Module and a third-party finishing device.

Extra long sheets have some output configuration dependencies for the 729.1mm – 1.2m length range (Extra long sheets dependencies table below)

Configuration	Output Location for 660mm – 1.2m long sheets
OCT configuration	Output to the OCT
Configurations with a HCS but no GBC Punch	Greater than *729mm* output to HCS top tray *only* (i.e. even if there is a PR Finisher with the config, long sheets must go to HCS top tray)
Configurations with HCS and a GBC Punch	Greater than *660mm* not possible – these long sheets cannot bypass the GBC and have no output location. They cannot be run in this configuration.
Non-HCS configuration – no Crease & Two Sided Trimmer	Greater than *729mm* PR Finisher top tray *only*.

Non-HCS configuration with Crease & Two Sided Trimmer AND GBC Advanced Punch Pro	Greater than *660mm* not possible – these long sheets cannot bypass the GBC and have no output location, they cannot be run in this configuration.
Non-HCS configuration with Crease & Two Sided Trimer, WITHOUT GBC Advanced Punch Pro	Greater than *729mm* must have Inserter module to run these length sheets.

Note that there are no finishing functions (staple, booklet, punch, fold, etc.) that are compatible with extra long sheets. They can only be output to top trays.

Offset Catch Tray (OCT)

The Catch Tray holds a maximum of 500 sheets.

Catch Tray Limitations

- If utilizing the Catch Tray, overall productivity will decline if offsetting mode is selected. The print engine will pause printing to offset between sets, and then resume. Productivity loss depends on the number of sheets per set, with single-page jobs representing the worst case (approximately 50% productivity loss).
- Sheets smaller than 6.7 inches (170 mm) in the cross-process direction (e.g., the feed edge) cannot be offset.
- Sheets larger than 11.7 inches (297 mm) in the cross-process direction (e.g., the feed edge) cannot be offset.

Interface Decurler Module

Note: The Interface Decurler Module is required with any system configuration that has one or more finishing devices, except the Offset Catch Tray.

The Interface Decurler Module acts as a paper path from the press to the finishing device; it also allows communication between the press and the finishing device. The Interface Decurler Module also cools and decurls paper as it exits the press and before it enters the finishing device.

GBC® AdvancedPunch™ Pro

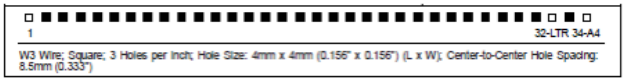
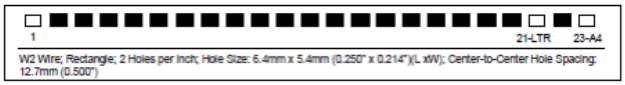
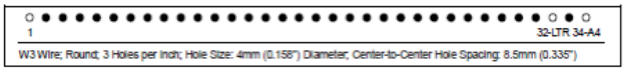
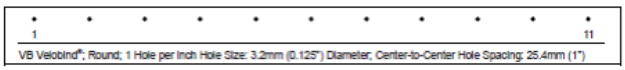
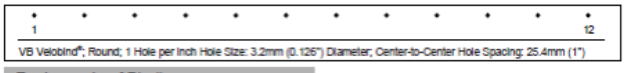
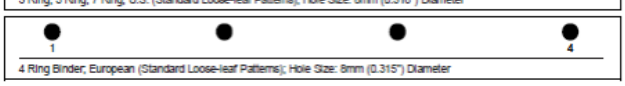
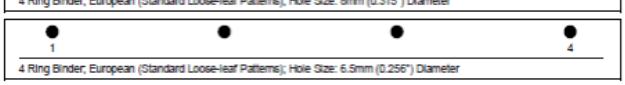
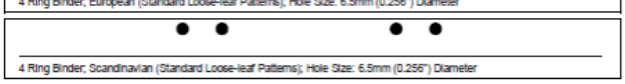
The GBC AdvancedPunch Pro is an inline die punch that uses modular die sets to create a variety of hole punch patterns in a range of papers sizes, from A4 or 8.5 x 11 in. (LEF) to 12 x 18 in. or SRA3 media, to support offline binding. The GBC AdvancedPunch Pro is supported by all print servers. The GBC AdvancedPunch Pro requires an Interface Decurler Module, as well as a High Capacity Stacker, Production Ready Finisher, Production Ready Booklet Maker Finisher, or Production Ready Finisher Plus (and additional third-party device).

GBC AdvancedPunch Pro	
GBC AdvancedPunch Pro Specifications	• Supports media from 75–300 gsm uncoated, 120–300 gsm coated • Supports tab stocks: Letter (3, 4, 5, 8, 10 bank), ½ letter (3 and 5 bank), A4 (5 and 10 bank), and A5 (3 and 5 bank) • Requires an additional electrical receptacle; refer to the Electrical Requirements for Optional Devices. • GBC AdvancedPunch Pro is “double punch”-enabled on this digital press. Refer to the GBC AdvancedPunch Pro User Manual for supported sizes. • Refer to extra long sheets dependencies table on page 36
GBC AdvancedPunch Pro Limitations	• GBC AdvancedPunch Pro punched sheets cannot be punched, stapled, folded, or converted into a booklet in a PR Finisher. • Hole punch position from edge of paper is user adjustable using the AdvancedPunch Pro LCD User Interface. • The “double punch” feature is centered on 11x17” stocks only. Other sizes such as A3, 12x18, etc. will not be centered. Refer to the GBC AdvancedPunch Pro User Manual for adjustment of punch. • 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. • Stacking may be misaligned on jobs containing tab stock; these jobs will require additional jogging before final finishing. • The maximum stock length that the GBC AdvancedPunch Pro can bypass to other modules further down the finishing chain is 729mm. • 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.

GBC AdvancedPunch Pro	
Punch Dies	The GBC AdvancedPunch Pro 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. Punch dies are ordered using the Supplies ordering process. Punch die life will be maximized if lightly oiled every 100K punch cycles (approximately every two months) 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).

OPTIONAL ACCESSORIES

Punch Dies

Die Set Description	Xerox Part Number	
For Plastic Comb Binding:		
 PB Plastic Bind; Hole Size: 8mm x 2.9mm (0.313" x 0.116") (LxW); Center-to-Center Hole Spacing: 14.3mm (0.563")	Die, Xerox, Comb Bind	008R13190
For Twin Loop™ Binding:		
 W3 Wire; Square; 3 Holes per Inch; Hole Size: 4mm x 4mm (0.156" x 0.156") (L x W); Center-to-Center Hole Spacing: 8.5mm (0.333")	Die, Xerox, Wire 3.1, Sq.	008R13192
 W2 Wire; Rectangle; 2 Holes per Inch; Hole Size: 6.4mm x 5.4mm (0.250" x 0.214")(L xW); Center-to-Center Hole Spacing: 12.7mm (0.500")	Die, Xerox, Wire 2.1, Sq.	008R13191
 W3 Wire; Round; 3 Holes per Inch; Hole Size: 4mm (0.156") Diameter; Center-to-Center Hole Spacing: 8.5mm (0.335")	Die, Xerox, Wire, 3:1, Rnd.	008R13181
 W2 Wire; Round; 2 Holes per Inch; Hole Size: 6.5mm (0.256") Diameter; Center-to-Center Hole Spacing: 12.7mm (0.5")	Die, Xerox, Wire, 2:1, Rnd.	008R13180
For Color Coil™ Binding:		
 C4 Coil; Round; 4 Holes per Inch; Hole Size: 4.4mm (0.174") Diameter; Center-to-Center Hole Spacing: 6.3mm (0.2475")	Die, Xerox, Coil, Rnd.	008R13179
For Velo® Bind:		
 VB Velobind®; Round; 1 Hole per Inch Hole Size: 3.2mm (0.125") Diameter; Center-to-Center Hole Spacing: 25.4mm (1")	Die, Xerox, Velobind®, 11 Holes, Ltr.	008R13187
 VB Velobind®; Round; 1 Hole per Inch Hole Size: 3.2mm (0.126") Diameter; Center-to-Center Hole Spacing: 25.4mm (1")	Die, Xerox, Velobind®, 12 Holes, A4.	008R13188
For Loose Leaf Binding:		
 3 Ring Binder; U.S. (Standard Loose-leaf Patterns); Hole Size: 8mm (0.316") Diameter	Die, Xerox, 3 Hole, 8mm	008R13182
 3 Ring, 5 Ring, 7 Ring; U.S. (Standard Loose-leaf Patterns); Hole Size: 8mm (0.316") Diameter	Die, Xerox, 3/5/7 Hole, 8mm	008R13183
 4 Ring Binder; European (Standard Loose-leaf Patterns); Hole Size: 8mm (0.315") Diameter	Die, Xerox, 4 Hole, 8mm	008R13184
 4 Ring Binder; European (Standard Loose-leaf Patterns); Hole Size: 6.5mm (0.256") Diameter	Die, Xerox, 4 Hole, 6.5mm	008R13185
 4 Ring Binder; Scandinavian (Standard Loose-leaf Patterns); Hole Size: 6.5mm (0.256") Diameter	Die, Xerox, 4 Hole, Scan	008R13186

Graphics do not represent actual punch pattern dimensions or spacing.

*__Note__: Check the SPG for changes or additions to this list.

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 additional prints directed to the top tray for inspection. Samples are not produced by redirecting sheets from the Stack to the Top Tray; therefore, the contents in the Stack Tray are complete.
- Additionally, an optional GBC® AdvancedPunch™ Pro and/or Inserter module may be added with a system equipped with an HCS. For detailed specifications, refer to the following sections.

High Capacity Stacker (HCS) Tray		
HCS Specifications	Feature	Specification (with centerline paper)
	Stacker Tray Capacity	5,000 sheets
	Top Tray Capacity	500 sheets
	Maximum Stack Weight	70KG (154 lb)
	Maximum Paper Size	330 mm x 488 mm (13 x 19.2 in.), See Extra Long Sheet configurations.
	Minimum Paper Size	203 mm x 182 mm (7.99 x 7.17)
	Power Requirement	Refer to Electrical Requirements for Optional Devices for information.
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 refer to this chart for approximate stack sizes for sheets larger than 8.5 x 11 in./A4. • Stack quality may degrade and jams may increase with 64–106 gsm 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.	

Stacker Tray Specifications

Stacker Tray Capacity by weight and paper finish								
Paper type and weight		Paper Size						
		Smallest size 203 x 182 mm	A4 8.5 x 11 in.	B4 / 8.5 x 14 in.	A3 / 11 x 17 in.	12 x 18 in.	SRA3	13 x 19.2 in. (330x488mm)
Uncoated 52–350 gsm	Sheets	≤ 5,000	≤ 5,000	≤ 2,300	≤ 2,300	≤ 2,300	≤ 2,300	≤ 2,300
	Stack Height	H ≤ 570 mm (22.44 in.)	H ≤ 570 mm (22.44 in.)	H ≤ 460 mm (≤18.11 in.)	H ≤ 460 mm (≤18.11 in.)	H ≤ 460 mm (≤18.11 in.)	H ≤ 460 mm (≤18.11 in.)	H ≤ 460 mm (≤18.11 in.)
Coated 64–400 gsm	Sheets	≤ 5,000	≤ 5,000	≤ 3,400	≤ 3,400	≤ 3,400	≤ 3,400	≤ 3,400
	Stack Height	H ≤ 570 mm (22.44 in.)	H ≤ 570 mm (22.44 in.)	H ≤ 412 mm (≤16.22 in.)	H ≤ 412 mm (≤16.22 in.)	H ≤ 412 mm (≤16.22 in.)	H ≤ 412 mm (≤16.22 in.)	H ≤ 412 mm (≤16.22 in.)

Production Ready Finisher

The Production Ready Finisher is an output device that can perform up to 100-sheets stapling and up to 3,000 sheets stacking. Additionally, an optional C/Z-fold/three-fold, punch, and cover paper insertion modules may be added.

The Production Ready Finisher has an optional inserter / interposer (Tray T1 or 8 depending on your product) that feeds cover paper to the finisher for stapled sets. Other than the Top Tray, the Production Ready Finisher does not support the full paper weight range that can be printed on the press. Refer to Production Ready Finisher Specifications for details on the media that is supported.

Production Ready Finisher Specifications

Top Tray

Production Ready Finisher Top Tray Capacity by weight and paper finish

Paper type and weight		Paper Size						
		Post Card 182 x 257 mm	A4 / 8.5 x 11 in.	B4 / 8.5 x 14 in.	A3 / 11 x 17 in.	12 x 18 in.*	SRA3*	13 x 19.2 in.*
Uncoated	52–80 gsm	H=67 mm (2.64 in.)	500	500	500	500	500	500
	80–400 gsm	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)
Coated	106–400 gsm	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)

*Cannot be offset

Top Tray minimum sheet size: 98 mm x 146 mm (SEF)

Top Tray maximum sheet size: 330.2 mm x 1200 mm

Stacker Tray

Production Ready Finisher Stacker Tray Capacity by weight and paper finish

Paper type and weight		Paper Size						
		B5 / 182 x 257 mm	A4 / 8.5 x 11 in.	B4 / 8.5 x 14 in.	A3 / 11 x 17 in.	12 x 18 in.*	SRA3*	13 x 19.2 in.*
Uncoated	52–80 gsm	1,500	3,000	1,500	1,500	1,500	1,500	1,500
	80–400** gsm	H=180 mm (7.09 in.)	H=378 mm (714.88 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)
Coated	106–400** gsm	H=180 mm (7.09 in.)	H=378 mm (14.88 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)

*Cannot be offset

**Weights greater than 360gsm cannot be offset

Stacker Tray minimum sheet size: 148 mm x 146 mm (LEF)
Stacker Tray maximum sheet size: 330.2 mm x 488 mm

Stapling

Production Ready Finisher Staple Capacity by weight and paper finish				
Paper type and weight	**A4 or Letter Sized Stock**		**Smaller *OR* larger than A4 / Letter Sized Stock**	
	Uncoated	Coated	Uncoated	Coated
52–80 gsm	100	35	65	35
81–90 gsm	100	35	65	35
91–105 gsm	50	30	50	30
106–128 gsm	50	30	45	30
129–150 gsm	20	20	20	20
151–176 gsm	20	20	20	20
177–220 gsm	20	20	20	20
221–256 gsm	20	20	20	20
257–300 gsm	10	10	10	10
301–350 gsm	10	10	10	10

Inserter

The Production Ready Finisher has an optional Inserter (also called a Post-Process Inserter), used to insert preprinted stock into finished sets without having to go through the engine. This tray on the Press Control Panel is called Tray T1 (on some products it is Tray 8).

Note: Labels and envelopes are not supported. Coated media capacity is not guaranteed.

Inserter Capacity by weight and paper finish				
Paper 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.
52–80 gsm	250 sheets	250 sheets	250 sheets	250 sheets
81–400 gsm	H=22 mm (0.87 in.)	H=22 mm (0.87 in.)	H=22 mm (0.87 in.)	H=22 mm (0.87 in.)

Inserter minimum sheet size: 182 mm x 148 mm (LEF)
Inserter maximum sheet size: 330.2 mm x 488 mm

Basic Punch

The Production Ready Finisher offers Hole Punching as an optional feature.

- Holes are created on the trail edge of the sheet.
- Hole punch capacity is equal to the regular capacity of the chosen output tray.
- For the USA, 2- and 3-hole punching is available; for Europe, 2- and 4- hole punch and Swedish punch is available.
- Stacks can be punched on the left or right side, or on the top edge.

Hole Punch Capacity 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	52–300 gsm	Applicable	Applicable	Applicable	Applicable
Coated	106–300 gsm	Applicable	Applicable	Applicable	Applicable
Production Ready Finisher Limitations		Productivity may be reduced by up to 50% when running multiple sets of a single sheet job to the Stacker Tray, due to the press being forced to wait while each single sheet set is ejected to the Stacker Tray.			

Punch minimum sheet size:

- 2 hole (LEF): 203.2 mm x 182 mm
- 3 hole (LEF): 254 mm x 182 mm
- 4 hole (LEF): 267 mm x 182 mm

Punch maximum sheet size: 297 mm x 431.8 mm

Production Ready Finisher Caveats	
Lightweight paper	Lightweight coated stocks may exhibit subtle gloss marking due to rollers. This may be more visible with high area coverage.
Stack capacity	Stacking multiple finished sized jobs will reduce the stack capacity.

Production Ready Booklet Maker Finisher

The Production Ready Booklet Maker Finisher is a separate configuration that adds basic booklet making capability to all the same features as the Production Ready Finisher. The Production Ready Booklet Maker Finisher includes:

- Stapler
- Top Tray
- Stacker Tray
- Booklet Unit capable of saddle stapling and bi-folding

Production Ready Booklet Maker Finisher	
Production Ready Booklet Maker Finisher Specifications	For specifications on the Top Tray, Stapling, Hole Punching, and the Inserter / Interposer, refer to Production Ready Finisher Specifications. The Stacker tray specifications can be found in the Production Ready Finisher Plus section. The following provides specifications on the Booklet Maker.

Booklet Capabilities by Weight and Paper Finish

Production Ready Finisher Booklet Capacity (Stapled) by weight and paper finish		
Paper type and weight	**Paper Finish**	
	Uncoated	Coated
60–80 gsm	30	—
81–90 gsm	30	25
91–105 gsm	20	20
106–128 gsm	15	15
129–150 gsm	10	10
151–176 gsm	10	10
177–220 gsm	5	5
221–256 gsm	4	4
257–300 gsm	3	3
301–350 gsm	3	3

Half-Fold / Unstapled Booklet Capability

Paper Weight	Unstapled Booklet Capacity (coated & uncoated)
52 – 220gsm	5
221 – 256gsm	4
257 – 350gsm	3

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	52–350 gsm	1	1	1	1	1
Coated	106–350 gsm	1	1	1	1	1
Fold Accuracy of Bi-Fold (Lead and Side Edges)		Fold accuracy (lead and side edge): ≤2.5 mm Bi-Fold: 1 sheet/set, 64–300 gsm 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 Stacker 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.				

C/Z Folder

The C/Z Folder is available with these finishing devices:

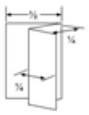
- Production Ready Finisher
- Production Ready Booklet Maker Finisher
- Production Ready Finisher Plus

C/Z Folder

The C/Z Folder unit produces Tri-C fold, Z-fold, and Z-Fold half-sheet.

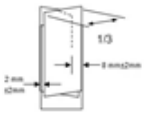
- The C/Z folding tray accommodates 30 sheets of up to 24 lb (60–105 gsm) uncoated media.
- Supported Paper size is 8.5 x 11 in. (A4) to the bottom tray; 11 x 17 in. (B4 and A3) to the top tray.
- Fold types, accuracy, and supported paper sizes are shown in the following table:

Z-Fold Half-Sheet
Also known as:
- Engineering Z-Fold
- Accordion Fold
- Accordion Fold-out



Produces folded output ½ size of original.
- B4 -> B5
- A3 -> A4
- 11 x 17 in. -> 8½ x 11 in.

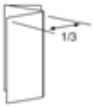
C-Fold
Also known as:
- Letter Fold
- Tri-fold
- Envelope Fold



Produces folded output 1/3 size of original.
For stock sizes:
- A4**
- 8½ x 11 in. **

** Delivered to Envelope Folder Tray

Z-Fold
Also known as:
- Accordion Fold
- Concordia Fold



Produces folded output 1/3 size of original.
For stock sizes:
- A4**
- 8½ x 11 in. **

** Delivered to Envelope Folder Tray

C/Z Folder Caveats:
C/Z Folder jam rate and fold position variance may increase for jobs that run very high area coverages of gold and/or silver.

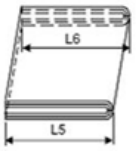
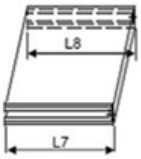
Xerox® SquareFold® Trimmer Module

The SquareFold Trimmer is an optional finishing device that flattens the spine of a booklet and performs face trim of the booklet.

Important: It is available with the Production Ready Booklet Maker Finisher; it is not available with any other finishing device. For information related to the SquareFold Trimmer Module, refer to Module Dimensions for Optional Devices and Electrical Requirements for Optional Devices.

SquareFold Trimmer Module		
SquareFold Trimmer Specifications	**Feature**	**Specification (with centerline paper)**
	Paper Types and Weights	52–350 gsm, Coated and Uncoated (18 lb Bond–110 lb Cover)
	Paper Size	Minimum: 8.5 x 11 in. SEF (182 mm x 257 mm) Maximum: 13 x 19.2 in. SEF (330.2 mm x 488 mm)
	Booklet Receiving Tray Capacity	20 booklets
	Trim Dimensions	2 mm–20 mm, adjustable in 0.1 mm increments
Configuration	This equipment is located after the Production Ready Booklet Maker Finisher, 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 Production Ready Booklet Maker Finisher can be passed through, square-folded, trimmed, or both squared-folded and trimmed.	
Auto Recognition of the SquareFold Trimmer Module	When the SquareFold Trimmer Module is docked to the Production Ready Booklet Maker Finisher via cable, the finisher automatically recognizes that the SquareFold Trimmer is installed.	
Booklet Size	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.	
Caveats	• When performing a face-trim of thicker booklets, the trimmed pieces of paper may not clear properly and result in jams, sensor errors, or other issues. • When creating a full-bleed booklet using both the SquareFold Trimmer and the Crease and Two-Sided Trimmer together, face trim skew may be more obvious due to the contrast of imaged area on the cover next to white paper on the body stock. • Thicker square fold booklets may cause the default staple location to be misaligned. Booklet quality can be optimized by centering the staple position in the center of the square fold area OR by moving the staple position such that it is outside of the square fold area. • Thicker booklets may show a beveled or slanted trim at the default face trim setting of 2 mm. This can be avoided by increasing this value at the DFE. • Face-trimming of specialty stocks such as scored or perforated stocks may show an increased amount of variation during a print run. • Tall and narrow booklets may exhibit more variation of face trimming during a print run. • It is not recommended or required to combine the creasing function of the Crease and Two-Sided Trimmer module with the squarefold function.	

SquareFold® Trimmer Skew Specification

Booklet + trimming		Measure both sides of the bottom sheet when the booklet is output. **Staple**: |L5-L6| ≤ 2 mm (Achievement rate: 95th percentile* within run) **Bi-Fold/Non-staple**: |L5-L6| ≤ 2 mm (Achievement rate: 95th percentile* within run)
Booklet + trimming + square-folding		Measure both sides of the bottom sheet when the booklet is output. **Staple**: |L7-L8| ≤ 2.5 mm (Achievement rate: 95th percentile* within run) Performance is not guaranteed at Bi-Fold/Non-staple.

*Note: Face-trim skews beyond the 95th percentile may be as high as 5 mm within run.

Crease and Two-Sided Trimmer Module

The Crease and Two-Sided Trimmer is an optional finishing device that trims the top and bottom of a booklet. Additionally, it can crease sheets to help prevent toner cracking on folded sheets. Finally, it has a buffering function that can improve the productivity of booklet making with the Production Ready Booklet Maker Finisher for certain stock weights.

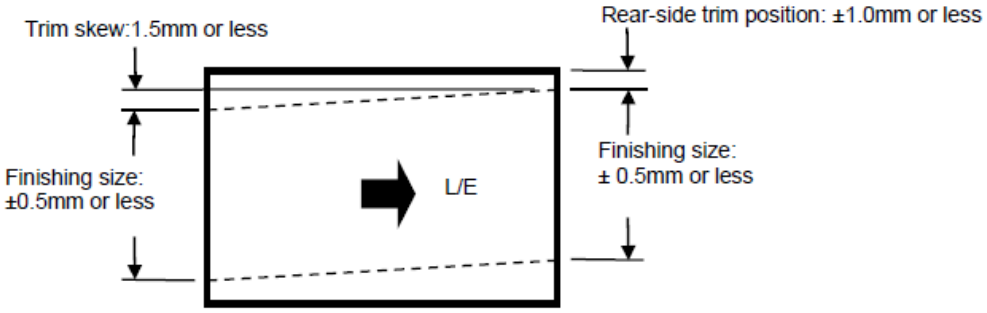
Two-Sided Trimming Function	
Trim Range (per side)	**Minimum Trim**: 6 mm **Maximum Trim**: 25 mm
Page Width	**Minimum Width**: • Paper input: 194 mm • Booklet output:108.5 mm **Maximum Width**: • Paper input: 330 mm • Booklet output: 242 mm
Page Length	**Minimum Length**: • Paper input: 210 mm (Two-sided sheet trim), 257mm (Two-sided booklet trim) • Booklet output: 182 mm **Maximum Length**: • Paper input: 488 mm • Booklet output: 318 mm
Max / Min Inputs	Minimum Input Paper Size: 194 x 210mm (2-sided sheet trim) or 194 x 257mm (2-sided booklet trim) Maximum Input Paper Size: 330 x 488mm
Max / Min Booklet Outputs	Minimum Booklet Output Size: 108.5 x 182mm Maximum Booklet Output Size: 242 x 318mm

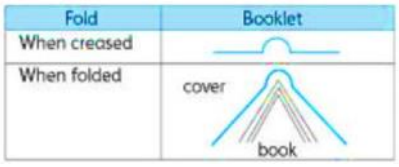
Two-Sided Trimming Function	
Stock Weights	**Uncoated**: • Weight Range: 52 gsm–350 gsm **Coated**: • Weight Range*: 52 gsm–350 gsm *Coated stocks between 52 and 105 gsm can be trimmed; however, performance is not guaranteed.

Two-Sided Trimming Skew Specification

Booklet + trimming

- Accuracy of the "rear side" (i.e., back of the machine) trim position ≤ +/- 1.0 mm against target trim value on paper leading edge.
- Finished size ≤ +/- 0.5 mm
- Total trimming skew ≤ 1.5 mm



Creasing Function ("Fold Enhance")	
Booklet Crease (for adding crease to booklets made with PR Booklet Maker)	**Paper Size**: 182 x 210 mm → 330 x 488 mm 7.17 x 8.27 in. → 13 x 19.2 in. **Paper Weight**: Uncoated: 52–350 gsm Coated: 106–350 gsm
Custom Crease (for offline folds)	**Creases**: Up to 5 creases (depending on sheet size) **Paper Size**: 182 x 210 mm → 330 x 488 mm 7.17 x 8.27 in. → 13 x 19.2 in.
Crease Directions	

Crease and Two-Sided Trimmer Limitations:

- Lightweight stocks may jam when creasing is within 62 mm of the lead edge.
- Creasing of mixed media booklets (e.g., heavier weight cover stock vs. body of booklet) is not possible at this time.
- Setting 2-sided trim at the minimum 6 mm may show damage on the trimmed edge. This may be avoided by applying trimming at 7 mm or more.
- Creasing on booklets reduces toner cracking at folds. However, the effectiveness is dependent on media characteristics (stiffness, grain, etc.).
- Creasing on booklets will apply to the first and the last sheets of the booklet.
- Booklets finished with a squared spine do not require creasing, and the application of creasing may degrade spine quality.
- For custom creases, the productivity depends on the number of creases applied (i.e., 1 crease is faster than 2 creases, etc.).
- Creasing Margins:
  - Lead Edge: Must be at least 45 mm from the lead edge of the sheet. Creasing between 45 and 62 mm from the lead edge may cause a paper jam.
  - Trail Edge: Must be at least 12 mm from the trail edge of the sheet.
- When creasing and trimming the same sheet, the maximum number of creases will be reduced to 3 if the length of the paper is shorter than 279 mm or longer than 450 mm.
- The creasing function cannot be applied to C-Fold and Z-fold produced from the C/Z Folder option.

Production Ready Finisher Functional Combinations

The following tables show the possible combination of functions and output locations for the Production Ready Finisher.

Function/ Combination of Functions	Staple	Offset	Booklet	Z-Fold	Envelope size C/Z	Punch	Inserter	Square Fold Trim	Two-Sided Trim	Crease	GBC Punch
Staple	—	Y	N	Y	N	Y	Y	N	N	N	N
Offset	—	—	N	Y	N	Y	Y	N	N	N	Y
Booklet	—	—	—	N	N	N	Y	Y	Y	Y	N
Z-Fold	—	—	—	—	N	Y	Y	N	N	N	Y
Envelope size C/Z	—	—	—	—	—	N	Y	N	N	N	N
Punch	—	—	—	—	—	—	Y	N	Y	Y	N
Inserter	—	—	—	—	—	—	—	N	Y	Y	Y
Square Fold Trim	—	—	—	—	—	—	—	—	Y	Y	N
Two-Sided Trim	—	—	—	—	—	—	—	—	—	Y	N
Crease	—	—	—	—	—	—	—	—	—	—	N
GBC Punch	—	—	—	—	—	—	—	—	—	—	—
Staple + Punch	—	Y	N	Y	N	-	Y	N	N	N	N
Staple + Z Fold	—	Y	N	—	N	Y	Y	N	N	N	N
Staple + Inserter	—	Y	N	Y	N	Y	—	N	N	N	N
Punch + Z Fold	Y	Y	N	—	N	—	Y	N	N	N	N
Punch + Inserter	Y	Y	N	Y	N	—	—	N	Y	N	N
Inserter + Z Fold	Y	Y	N	—	N	Y	—	N	N	N	N
Inserter + Booklet	N	N	—	N	N	N	—	Y	Y	N	N
Inserter + Crease and Two-Sided Trim	N	N	Y	N	N	N	—	Y	—	—	N
Inserter + GBC Punch	N	N	N	N	N	N	—	N	N	N	—
Booklet + Square Fold Trim	N	N	—	N	N	N	Y	—	Y	Y	N
Booklet + Two-Sided Trim	N	N	—	N	N	N	Y	Y	—	—	N

OPTIONAL ACCESSORIES

Function/ Combination of Functions	Output Location						
	Adv. High Capacity Stacker Top Tray	Adv. High Capacity Stacker Stacker Tray	PR Finisher Top Tray	PR Finisher Stacker Tray	PR Finisher Sq. Fold Trim Booklet Tray	C/Z Envelope Fold Tray	PR Finisher Plus Output
Staple	-	-	N	Y	N	N	N
Offset	-	-	N	Y	N	N	N
Booklet	-	-	Y	N	Y	N	N
Z-Fold	-	-	Y	Y	N	N	N
Envelope size C/Z	-	-	N	N	N	Y	N
Punch	-	-	Y	Y	N	N	N
Inserter	Y	Y	Y	Y	Y	Y	Y
Square Fold Trim	-	-	N	N	Y*	N	N
Two-Sided Trim	-	-	Y	N	Y	N	Y
Crease	-	-	Y	N	Y *	N	Y
GBC Punch	Y	Y	Y	Y	N	N	Y
Staple + Punch	-	-	N	Y	N	N	N
Staple + Z Fold	-	-	N	Y	N	N	N
Staple + Inserter	-	-	N	Y	N	N	N
Punch + Z Fold	-	-	Y	Y	N	N	N
Punch + Inserter	-	-	Y	Y	N	N	N
Inserter + Z Fold	-	-	Y	Y	N	N	N
Inserter + Booklet	-	-	Y	N	Y	N	N
Inserter + Two-Sided Trim	-	-	Y	N	Y	N	Y
Inserter + GBC Punch	Y	Y	Y	Y	N	N	Y
Booklet + Square Fold Trim	-	-	N	N	Y*	N	N
Booklet + Two-Sided Trim	-	-	N	N	Y*	N	N

* Combination of Crease and Square-Fold is not guaranteed.

Production Ready Finisher Plus

The Production Ready Finisher Plus provides the same functions as the Production Ready Finisher, although Stacker Tray capacity is reduced from 3,000 sheets to a maximum of 2,000 sheets. The Production Ready Finisher Plus adds a Finishing Transport module that enables connection to available third-party finishing solutions.

Note: A Production Ready Finisher cannot be upgraded to a Production Ready Finisher Plus. Finishing solutions that can be connected to the Production Ready Finisher Plus include the Plockmatic Pro 50/35 Booklet Maker and GBC® eWire™.

Specifications and expectations for these devices are available in a Solutions Planning Guide that is available from your Xerox sales representative or analyst.

For information related to the Production Ready Finisher Plus, refer to *Module Dimensions for Optional Devices*.

Top Tray

Note: These specifications are the ***same*** as the Production Ready Finisher.

Production Ready Finisher Plus Top Tray Capacity by weight and paper finish

Paper type and weight		Paper Size						
		Post Card 182 x 257 mm	A4 / 8.5 x 11 in.	B4 / 8.5 x 14 in.	A3 / 11 x 17 in.	12 x 18 in.*	SRA3*	13 x 19.2 in.*
Uncoated	52–80 gsm	H=67 mm (2.64 in.)	500	500	500	500	500	500
	80–400 gsm	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)
Coated	106–400 gsm	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)	H=67 mm (2.64 in.)

Stacker Tray

Important: These specifications are ***different*** from the Production Ready Finisher, they are the ***same*** as the Production Ready Booklet Maker Finisher..

Production Ready Finisher Plus Stacker Tray Capacity by weight and paper finish

Paper type and weight		Paper Size						
		B5 / 182 x 257 mm	A4 / 8.5 x 11 in.	B4 / 8.5 x 14 in.	A3 / 11 x 17 in.	12 x 18 in.*	SRA3*	13 x 19.2 in.*
Uncoated	52–80 gsm	1,500	2,000	1,500	1,500	1,500	1,500	1,500
	80–400 gsm	H=180 mm (7.09 in.)	H=378 mm (14.88 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)
Coated	106–400 gsm	H=180 mm (7.09 in.)	H=378 mm (14.88 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)	H=180 mm (7.09 in.)

*Cannot be offset

Stapling

Note: These specifications are the same as the Production Ready Finisher. See that section above for details.

Inserter

The Production Ready Finisher Plus has an optional Inserter used to insert pre-printed stock into finished sets without having to go through the print engine. Labels, coated media and envelopes are not supported.

The Inserter is also called the Interposer or Post-Process Inserter and, depending on the product, it is either Tray T1 or Tray 8.

Note: The specifications are the same as the Production Ready Finisher. See that section above for details.

Hole Punching

The Production Ready Finisher Plus has an optional punch.

Note: The punch specifications are the same as the Production Ready Finisher punch.
See that section above for details.

Third-Party Finishing Options

Third-Party Finishing devices that can be connected to the Production Ready Finisher Plus include:

- Plockmatic Pro 50/35 Booklet Maker
- GBC® eWire™

Customer Expectations Agreement

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

_____ Xerox® Iridesse® Production Press

_____ Xerox® EX-P 6 Print Server Powered by Fiery®

_____ Advanced High Capacity Feeder

_____ Banner Feeder Extension Kit

_____ Xerox® XLS Automatic Feeding Kit

_____ Offset Catch Tray (OCT)

_____ Interface Decurler Module

_____ GBC® AdvancedPunch™ Pro

_____ High Capacity Stacker

_____ Production Ready Finisher

_____ Production Ready Booklet Maker Finisher

_____ Production Ready Finisher Plus

_____ C/Z Folder

_____ Basic Punch

_____ PR Finisher Banner Extension

_____ Inserter

_____ Crease and Two-Sided Trimmer

_____ Xerox® SquareFold® Trimmer Module

Primary Customer Applications:

_____

_____

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

_____

_____

I have reviewed and understand the product specifications for each of the modules that will be installed: (Signatures Required)

_____ _____
Customer Date

_____ _____
Xerox Sales Representative Date

_____ _____
Xerox Analyst Representative Date

_____ _____
Xerox Service Representative Date

I have viewed a representative output sample from the Xerox® Iridesse® Production Press and the image quality is acceptable for the needs of my organization: (*Signature required if Xerox® Iridesse® Production Press is included with Order.*)

_____ _____
Customer Date