


5 Operating Procedures

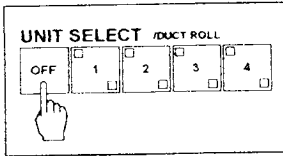
5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

This section explains common procedures for M1, M2 and M3 operations.

Procedure	Display
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1. Set the unit selection to OFF.

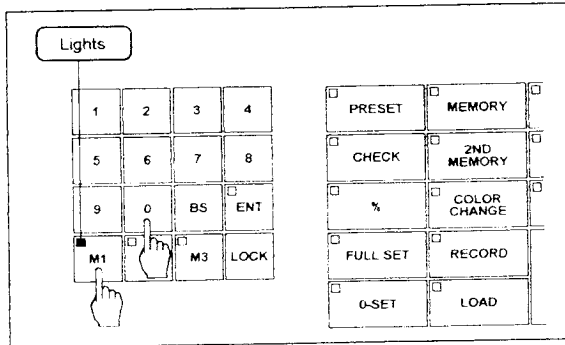


2. Put the system into M1, M2 or M3 mode.

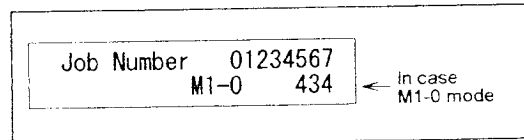
Press the **M1**, **M2** or **M3** key together with one of the **0** to **9** numeric keys to put the system into M1, M2 or M3 mode.

The **0** to **9** keys select the individual data settings, which will be explained in detail below.

The mode number and the current data setting appear in the display.



Example: Selecting M1-0

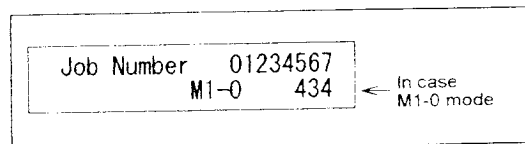
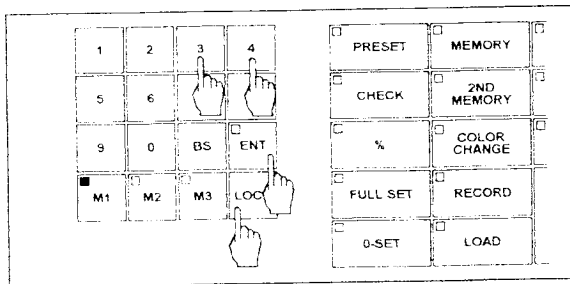


The mode number and the current data setting appear.

3. Enter the data.


Enter the data using the appropriate keys, for example the **0** to **9** numeric keys and the **ENT** and **LOCK** keys.

Data entry procedures for each setting will be explained in detail below.



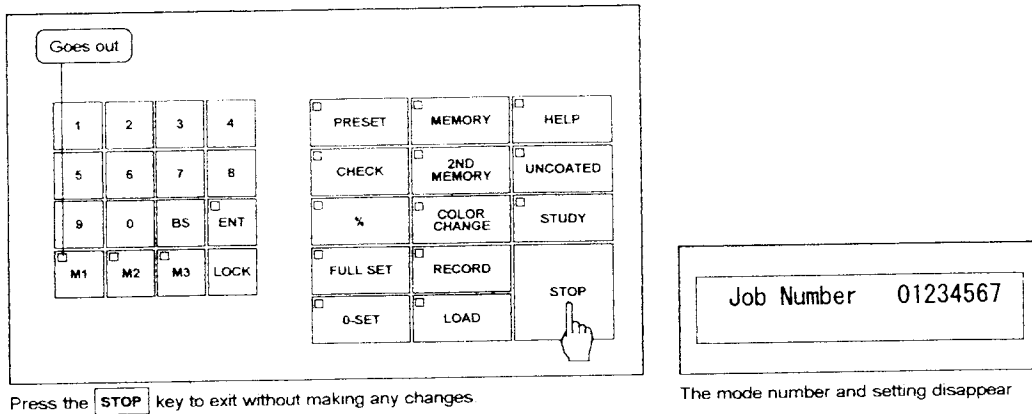
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5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

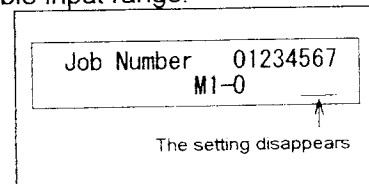
4. To cancel the operation

Press the **STOP** key to cancel the operation at any time.



5. If the input value is too large or too small

If the input value is too large or too small, the setting disappears from the display. Repeat from the beginning and input a number in the permissible input range.




6. If you make a mistake

If you make a mistake while entering a number, re-input the correct number.

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5.17 M1, M2 and M3 Modes

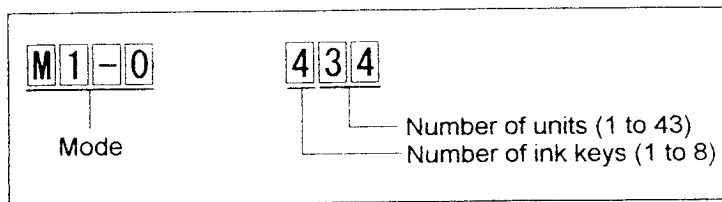
 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

5.17.1 M1 Mode

5.17.1.1 M1-0 : Number of units and number of ink keys

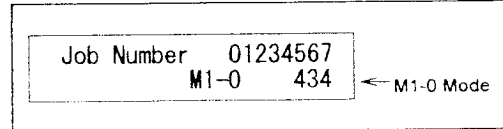
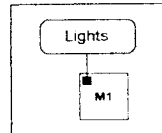
Note

This setting should be changed only by a qualified Komori engineer.
Never try to change this setting yourself.

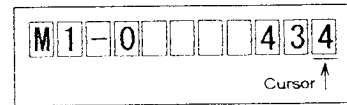


Procedure

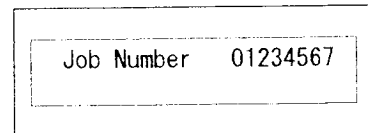
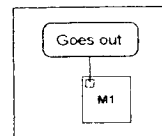
- ① While pressing the **M1** key, press the **0** key to put the system into M1-0 mode. The M1 lamp lights and the current setting appears in the display.



- ② Using the **0** to **9** numeric keys, input the number of units in the first digit and the number of ink keys as the last two digits.




- ③ Press the **LOCK** key to confirm the changes and exit M1 mode.



- ④ To cancel the operation, press the **STOP** key.

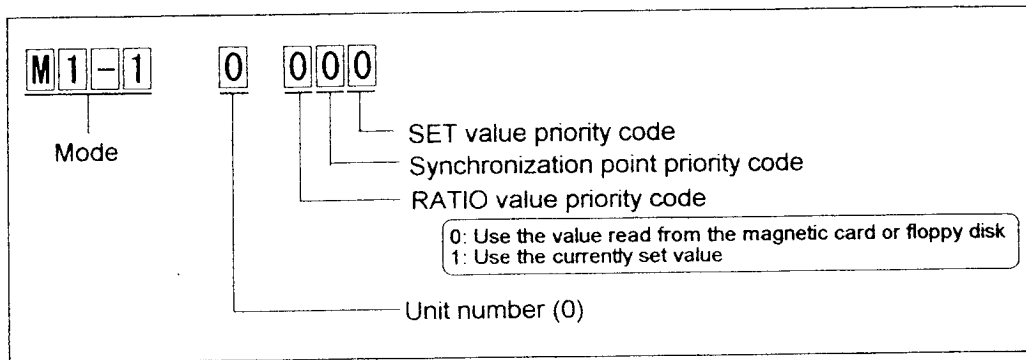
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5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

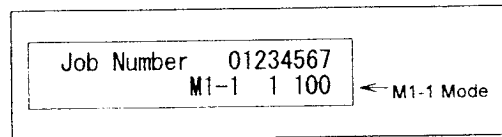
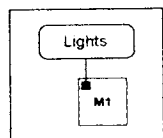
5.17.1.2 M1-1 : Ink feed priority codes and synchronization commencement point priority code

When loading data from a magnetic card or floppy disk, the settings of these items determine whether ink feed data should be loaded into the PQC from the magnetic card or floppy disk, or whether the currently set values should be used.

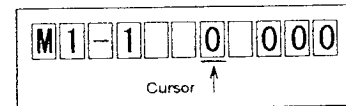


Procedure

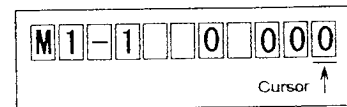
- While pressing the **M1** key, press the **1** key to put the system into M1-1 mode. The M1 lamp lights and the current setting appears in the display.



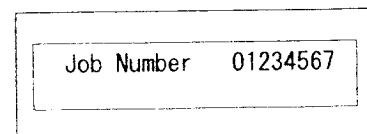
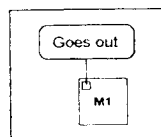
- Press the **0** key.
- Press the **ENT** key to confirm the setting.



- Using the **0** and **1** keys, enter the three priority codes.
- Press the **LOCK** key to save the settings.



- When finished, press the LOCK key again to exit M1-1 mode.




- To cancel the operation, press the **STOP** key.

Setup for InkzonePerfect / InkzoneLoop:



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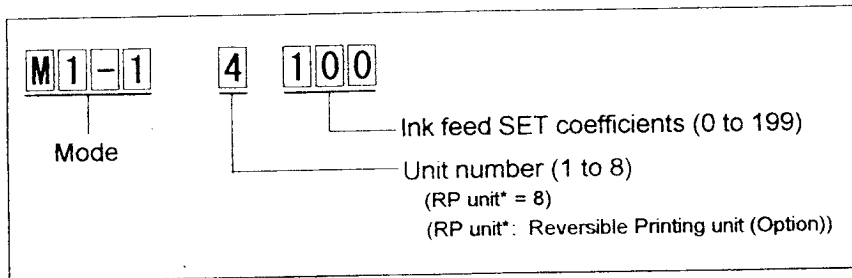
5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

M1-1-1~8 : Ink feed SET coefficients

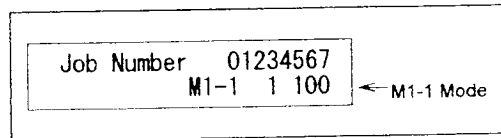
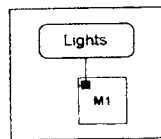
Set the corrective coefficients applied for each unit to ink feed SET values loaded from a magnetic card or floppy disk.

$$\text{Loaded SET value} \times \text{coefficient} / 100 = \text{PQC SET value}$$

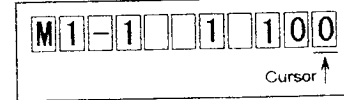
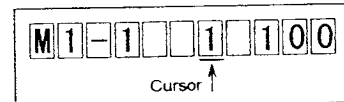


Procedure

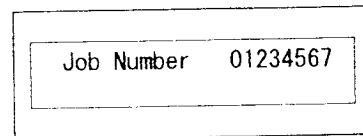
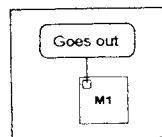
- While pressing the **M1** key, press the **1** key to put the system into M1-1 mode. The M1 lamp lights and the current setting appears in the display.



- Use the **1** to **8** keys to select a unit.
- Press the **ENT** key to confirm the selection.
- Using the **0** to **9** keys, enter a three-digit corrective coefficient.
- Press the **LOCK** key to save the setting.




- After saving the setting, return to step ② and repeat for the remaining units.
- After entering coefficients for all units, press the **LOCK** key to exit M1 mode.



- To cancel the operation, press the **STOP** key.

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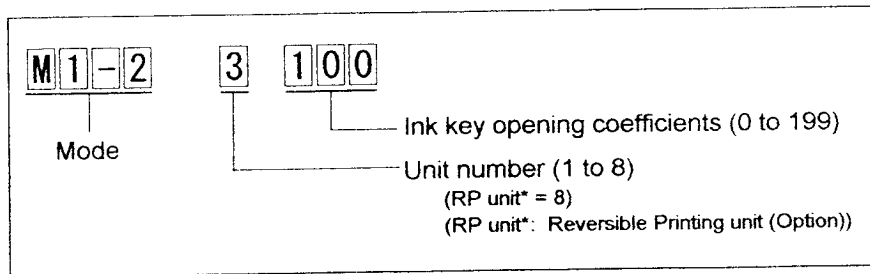
5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

5.17.1.3 M1-2 : Ink key opening coefficients

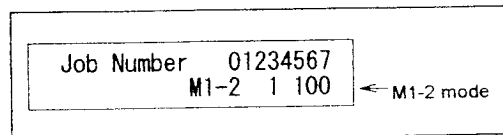
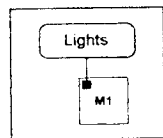
Set the corrective coefficients applied for each unit to ink fountain key opening values loaded from a magnetic card or floppy disk.

Loaded ink key opening value x coefficient / 100 = PQC ink key opening value

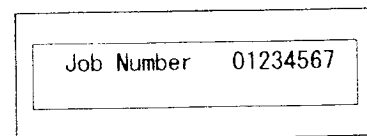
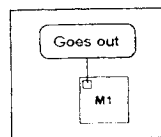
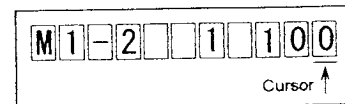
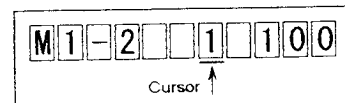


Procedure

- While pressing the **M1** key, press the **2** key to put the system into M1-2 mode. The M1 lamp lights and the current setting appears in the display.




- Use the **1** to **8** keys to select a unit.
- Press the **ENT** key to confirm the selection.
- Using the **0** to **9** keys, enter a three-digit corrective coefficient.
- Press the **LOCK** key to save the setting.
- After saving the setting, return to step ② and repeat for the remaining units.
- After entering coefficients for all units, press the **LOCK** key to exit M1 mode.



- To cancel the operation, press the **STOP** key.

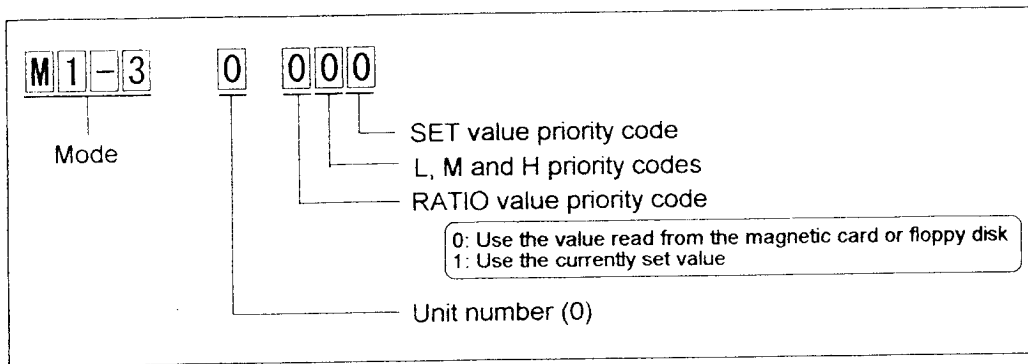
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5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

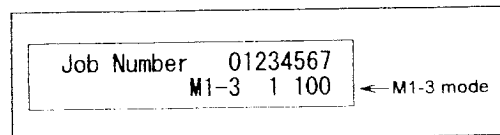
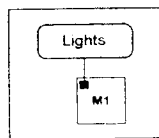
5.17.1.4 M1-3 : Water feed priority codes, L, M, and H priority codes and water feed rate

When loading data from a magnetic card or floppy disk, the settings of these items determine whether water feed data should be loaded into the PQC from the magnetic card or floppy disk, or whether the currently set values should be used.

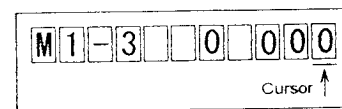
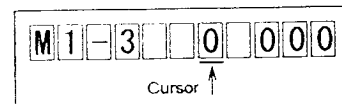


Procedure

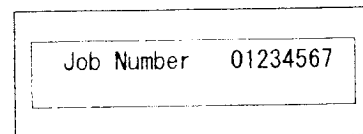
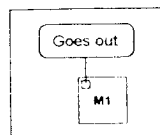
- While pressing the **M1** key, press the **3** key to put the system into M1-3 mode. The M1 lamp lights and the current setting appears in the display.



- Press the **0** key.
- Press the **ENT** key to confirm the setting.
- Using the **0** and **1** keys, enter the three priority codes.
- Press the **LOCK** key to save the settings.




- When finished, press the **LOCK** key again to exit M1 mode.



- To cancel the operation, press the **STOP** key.

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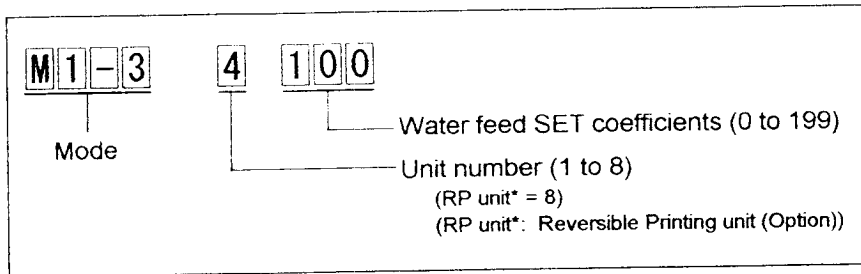
5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

M1-3-1~8 : Water feed SET coefficients

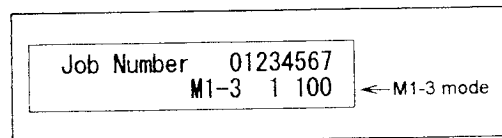
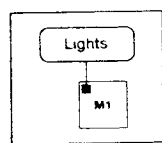
Set the corrective coefficients applied for each unit to water feed SET values loaded from a magnetic card or floppy disk.

Loaded SET value x coefficient / 100 = PQC SET value

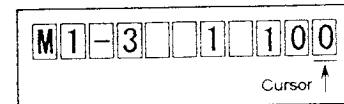
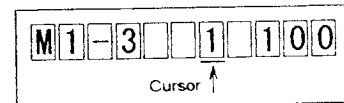


Procedure

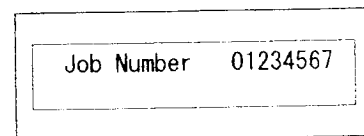
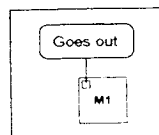
- While pressing the **M1** key, press the **3** key to put the system into M1-3 mode. The M1 lamp lights and the current setting appears in the display.



- Use the **1** to **8** keys to select a unit.
- Press the ENT key to confirm the selection.
- Using the **0** to **9** keys, enter a three-digit corrective coefficient.
- Press the **LOCK** key to save the setting.




- After saving the setting, return to step ② and repeat for the remaining units.
- After entering coefficients for all units, press the **LOCK** key to exit M1 mode.



- To cancel the operation, press the **STOP** key.

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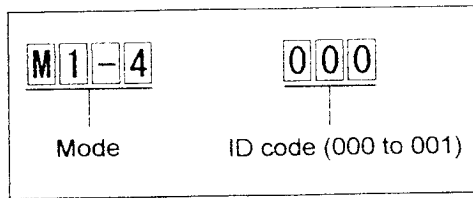
5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

5.17.1.5 M1-4 : Ink key motor circuit ID code

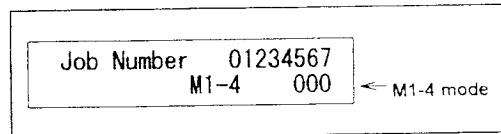
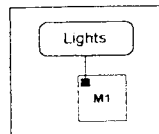
Note

This setting should be changed only by a qualified Komori engineer.
Never try to change this setting yourself.

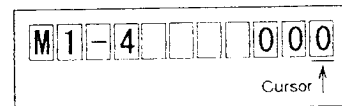


Procedure

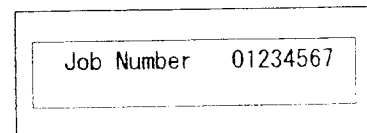
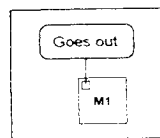
- ① While pressing the **M1** key, press the **4** key to put the system into M1-4 mode. The M1 lamp lights and the current setting appears in the display.



- ② Using the **0** to **9** keys, enter a three-digit ID code.




- ③ Press the **LOCK** key to save the setting.



- ④ To cancel the operation, press the **STOP** key.

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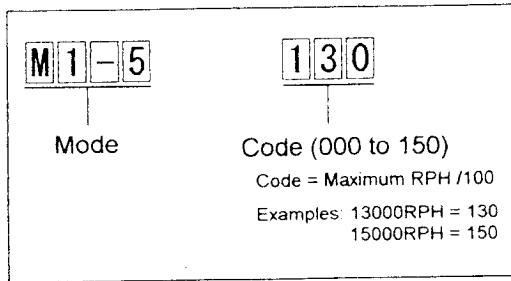
5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

5.17.1.6 M1-5 : Maximum press speed

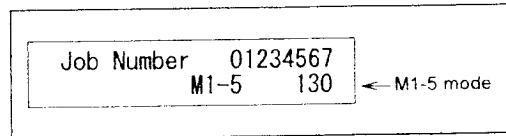
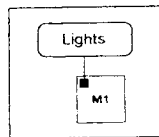
Note

This setting should be changed only by a qualified Komori engineer.
Never try to change this setting yourself.

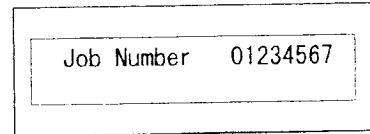
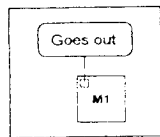
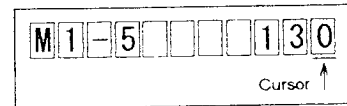


Procedure

- While pressing the **M1** key, press the **5** key to put the system into M1-5 mode. The M1 lamp lights and the current setting appears in the display.




- Using the **0** to **9** keys, enter a three-digit value.
- Press the **LOCK** key to save the setting.



- To cancel the operation, press the **STOP** key.

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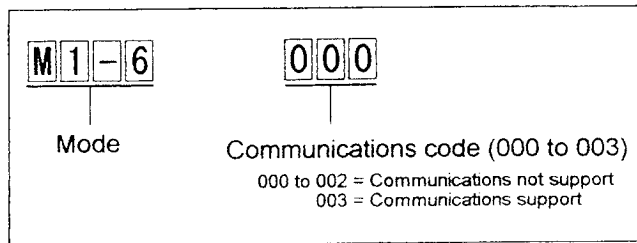
5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

5.17.1.7 M1-6 : Communications specifications

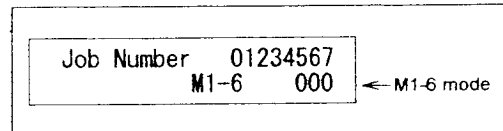
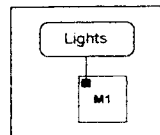
Note

This setting should be changed only by a qualified Komori engineer.
Never try to change this setting yourself.

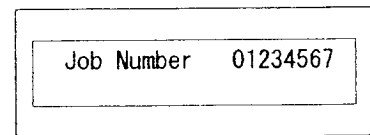
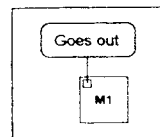
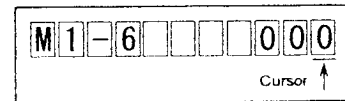


Procedure

- ① While pressing the **M1** key, press the **6** key to put the system into M1-6 mode. The M1 lamp lights and the current setting appears in the display.




- ② Using the **0** to **9** keys, enter a three-digit communications code.
- ③ Press the **LOCK** key to save the setting.



- ④ To cancel the operation, press the **STOP** key.

5 Operating Procedures

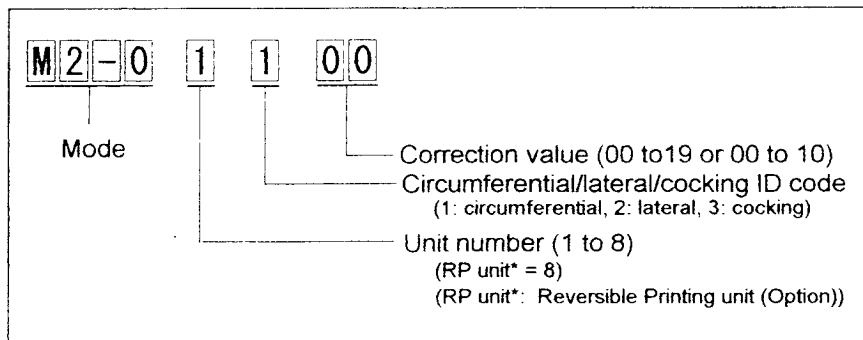
5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

5.17.2 M2 Mode

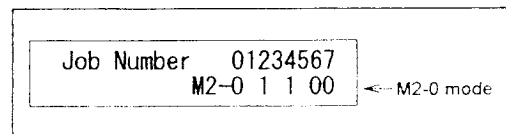
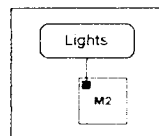
5.17.2.1 M2-0 : Plate register correction value

Enter a correction value for plate registration. This value is used to correct for mechanical backlash within about three seconds after adjustment of the plate register.

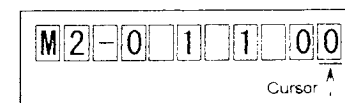
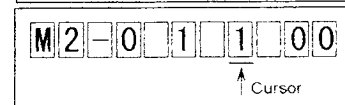
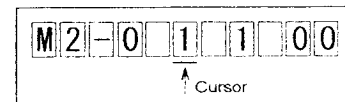


Procedure

- While pressing the **M2** key, press the **0** key to put the system into M2-0 mode. The M2 lamp lights and the current setting appears in the display.

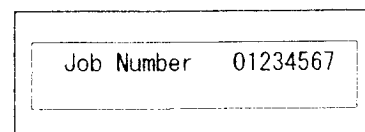
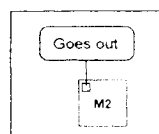


- Use the **1** to **8** keys to select a unit.
- Press the **ENT** key to confirm the selection.
- Using the **1** to **3** keys, select the circumferential, lateral or cocking register.
- Press the **ENT** key to confirm the selection.
- Using the **0** to **9** keys, enter a two-digit value.
- Press the **LOCK** key to save the setting.



After saving the setting, return to step ② and repeat for the remaining units.


- After entering values for all units, press the **LOCK** key to exit



- To cancel the operation, press the **STOP** key.

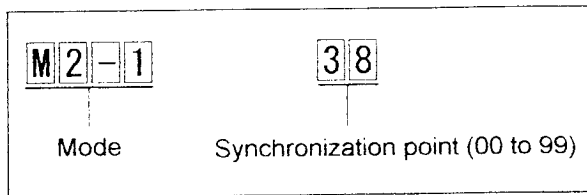
5 Operating Procedures

5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

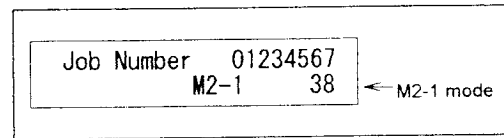
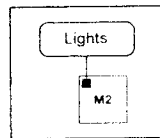
5.17.2.2 M2-1 : Ink feed synchronization point

Set the point shown below, at which the system begins to control ink feed to match the speed of the press.

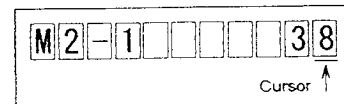


Procedure

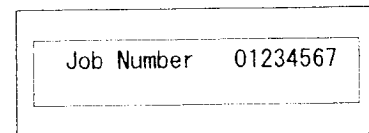
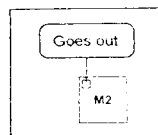
- While pressing the **M2** key, press the **1** key to put the system into M2-1 mode. The M2 lamp lights and the current setting appears in the display.



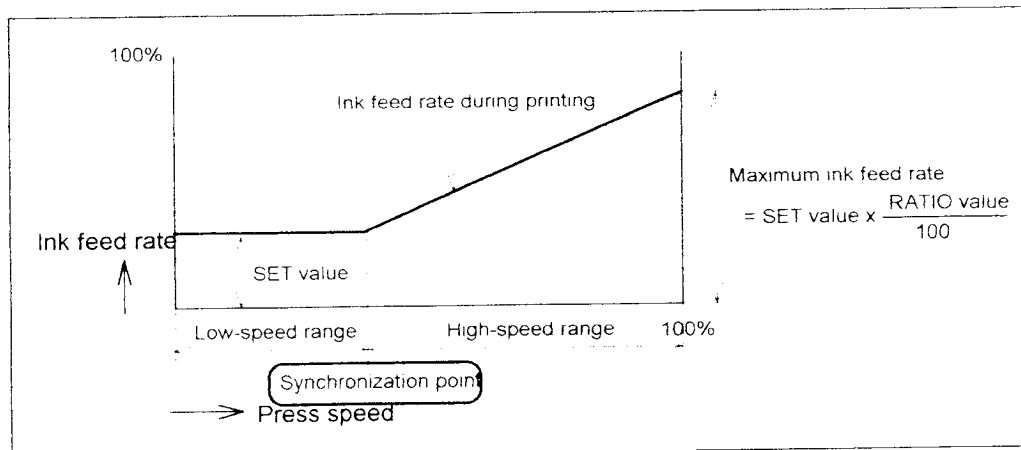
- Using the **0** to **9** keys, enter a two-digit synchronization point.



- Press the **LOCK** key to save the setting and exit M2 mode.




- To cancel the operation, press the **STOP** key.



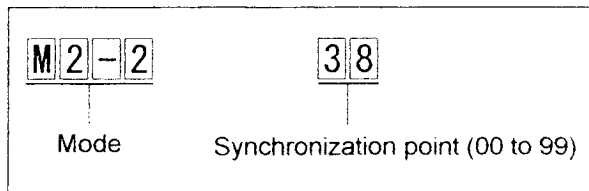
5 Operating Procedures

5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

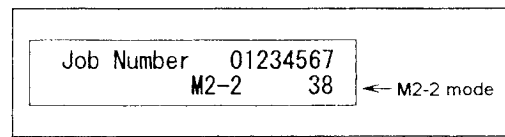
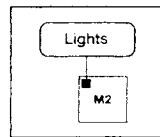
5.17.2.3 M2-2 : Water feed synchronization point

Set the point shown below, at which the system begins to control water feed to match the speed of the press.

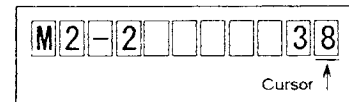


Procedure

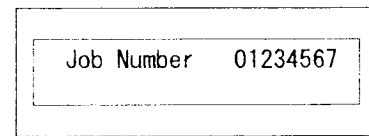
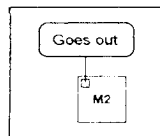
- While pressing the **M2** key, press the **2** key to put the system into M2-2 mode. The M2 lamp lights and the current setting appears in the display.



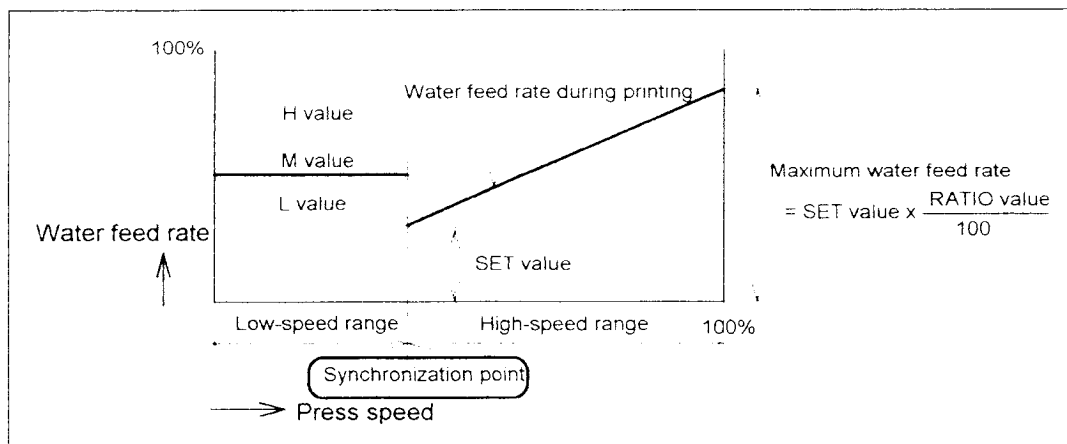
- Using the **0** to **9** keys, enter a two-digit synchronization point.



- Press the **LOCK** key to save the setting and exit M2 mode.




- To cancel the operation, press the **STOP** key.



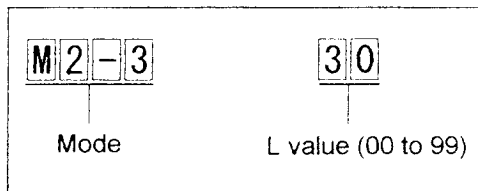
5 Operating Procedures

5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

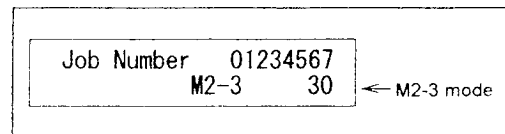
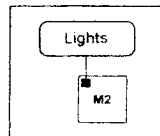
5.17.2.4 M2-3 : Low-speed water feed value L (Low)

Set the value shown below, which determines water feed for the L setting during low-speed printing.

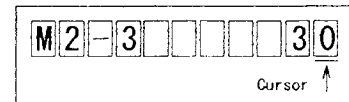


Procedure

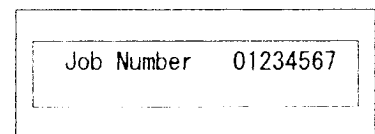
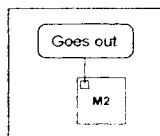
- While pressing the **M2** key, press the **3** key to put the system into M2-3 mode. The M2 lamp lights and the current setting appears in the display.



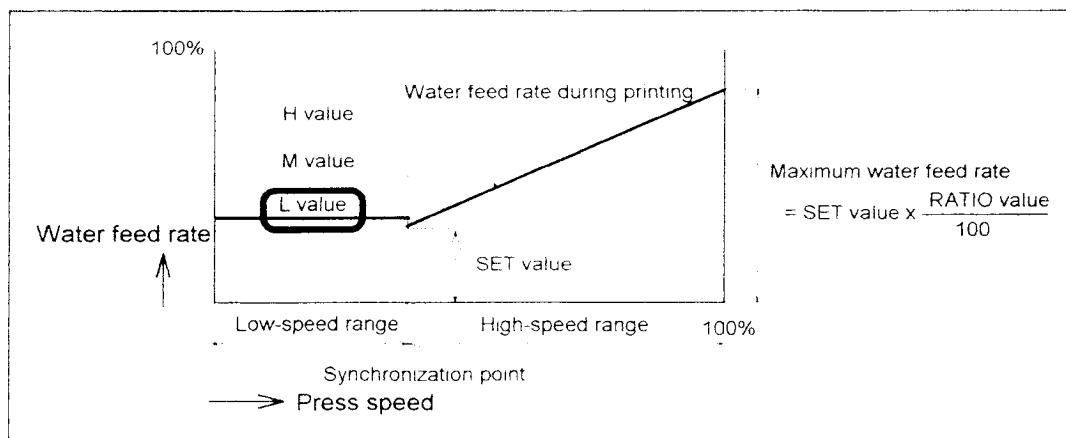
- Using the **0** to **9** keys, enter a two-digit water feed value.



- Press the **LOCK** key to save the setting and exit M2 mode.




- To cancel the operation, press the **STOP** key.



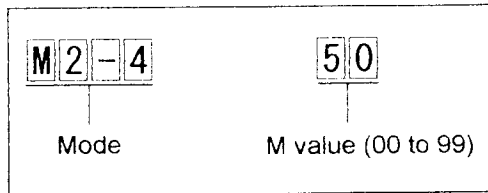
5 Operating Procedures

5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

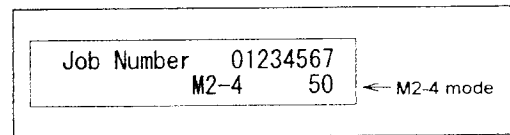
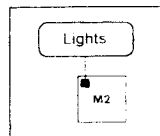
5.17.2.4 M2-4 : Low-speed water feed value M (Medium)

Set the value shown below, which determines water feed for the M setting during low-speed printing.

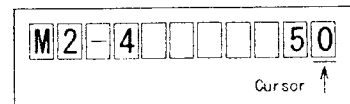


Procedure

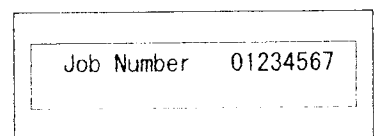
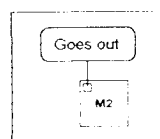
- While pressing the **M2** key, press the **4** key to put the system into M2-4 mode. The M2 lamp lights and the current setting appears in the display.



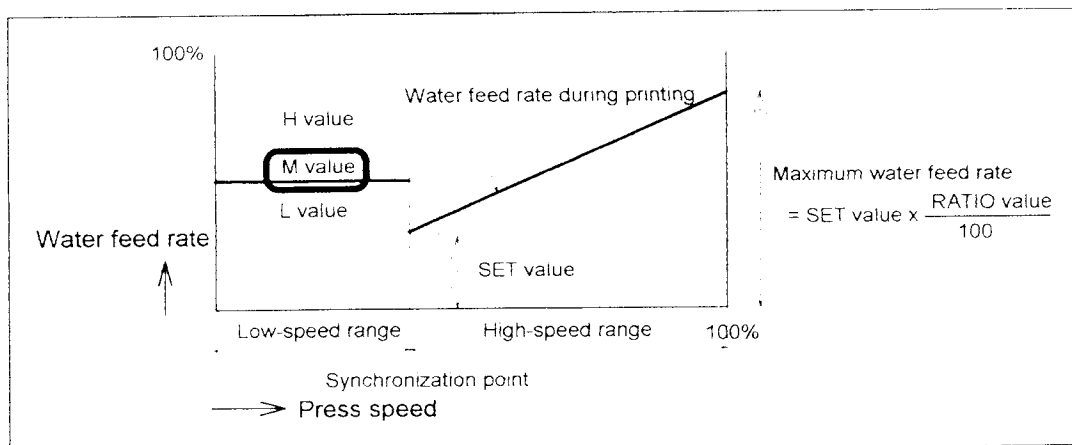
- Using the **0** to **9** keys, enter a two-digit water feed value.



- Press the **LOCK** key to save the setting and exit M2 mode.




- To cancel the operation, press the **STOP** key.



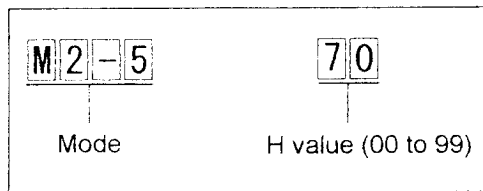
5 Operating Procedures

5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

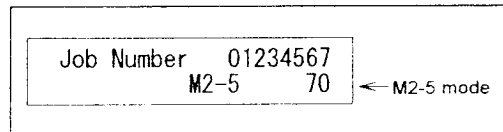
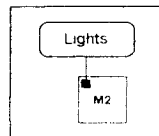
5.17.2.4 M2-3 : Low-speed water feed value H (High)

Set the value shown below, which determines water feed for the H setting during low-speed printing.

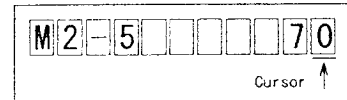


Procedure

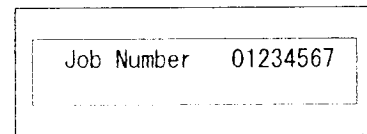
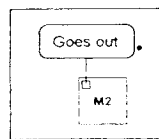
- While pressing the **M2** key, press the **5** key to put the system into M2-5 mode. The M2 lamp lights and the current setting appears in the display.



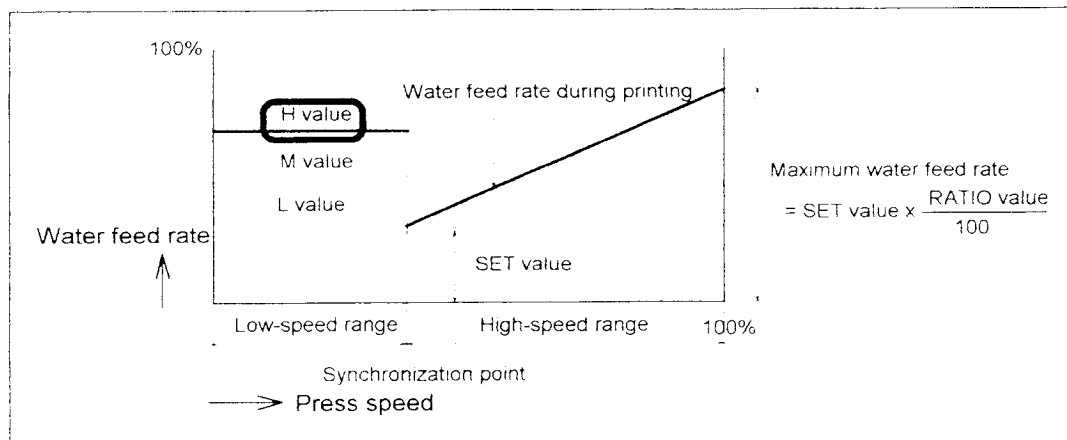
- Using the **0** to **9** keys, enter a two-digit water feed value.



- Press the **LOCK** key to save the setting and exit M2 mode.




- To cancel the operation, press the **STOP** key.



5 Operating Procedures

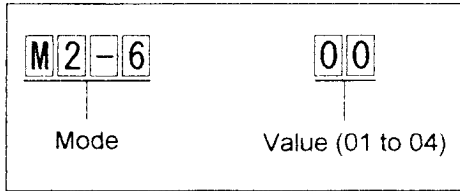
5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

5.17.2.7 M2-6 : High-speed water supply 1/N output

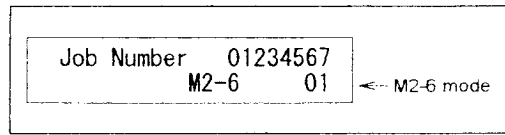
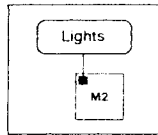
Note

This setting should be changed only by a qualified Komori engineer.
Never try to change this setting yourself.

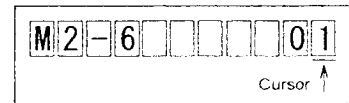


Procedure

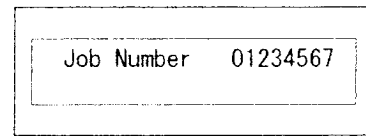
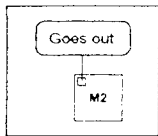
- ① While pressing the **M2** key, press the **6** key to put the system into M2-6 mode. The M2 lamp lights and the current setting appears in the display.



- ② Using the **0** to **9** keys, enter a two-digit value.




- ③ Press the **LOCK** key to save the setting and exit M2 mode.



- ④ To cancel the operation, press the **STOP** key.

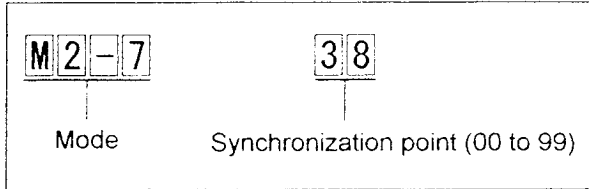
5 Operating Procedures

5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

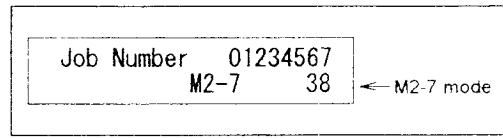
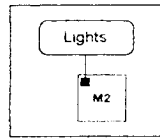
5.17.2.8 M2-7 : Coater unit varnish feed synchronization point

Set the point shown below, at which the system begins to control varnish feed to match the speed of the press.

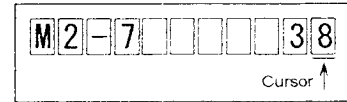


Procedure

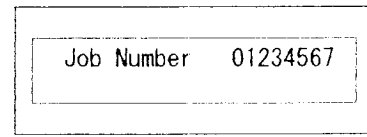
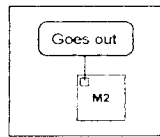
- While pressing the **M2** key, press the **7** key to put the system into M2-7 mode. The M2 lamp lights and the current setting appears in the display.



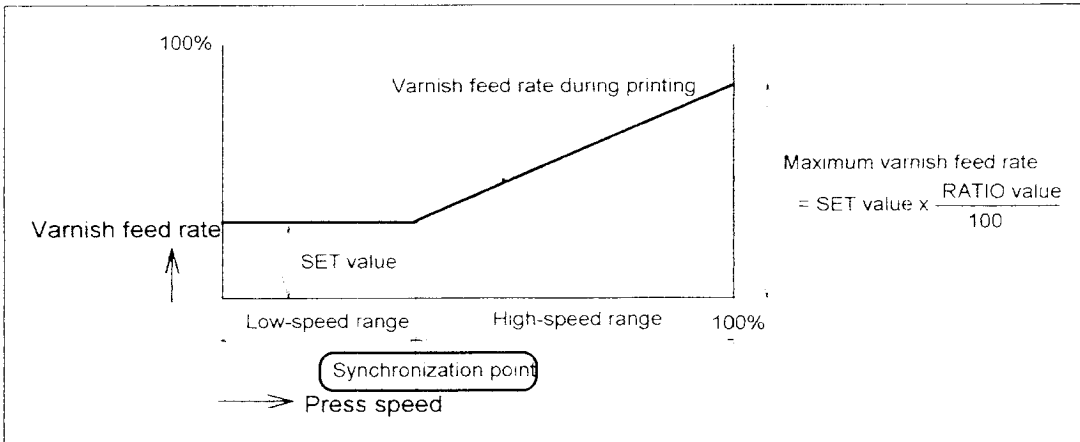
- Using the **0** to **9** keys, enter a two-digit synchronization point.



- Press the **LOCK** key to save the setting and exit M2 mode.




- To cancel the operation, press the **STOP** key.



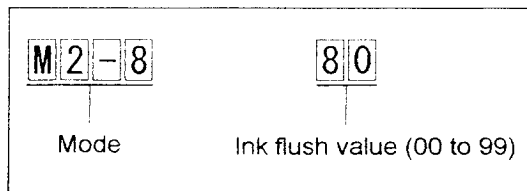
5 Operating Procedures

5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

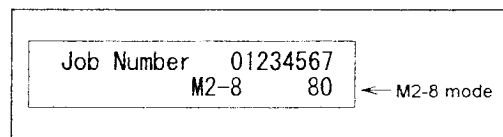
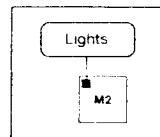
5.17.2.9 M2-8 : Ink flush value

When the FLUSH ON key is pressed, the system temporarily increases the ink feed. Set the point shown below, which represents the maximum amount of ink feed after the FLUSH ON key is pressed.

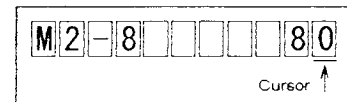


Procedure

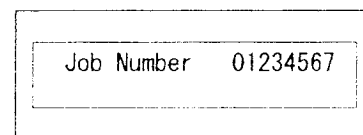
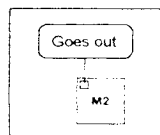
- While pressing the M2 key, press the 8 key to put the system into M2-8 mode. The M2 lamp lights and the current setting appears in the display.



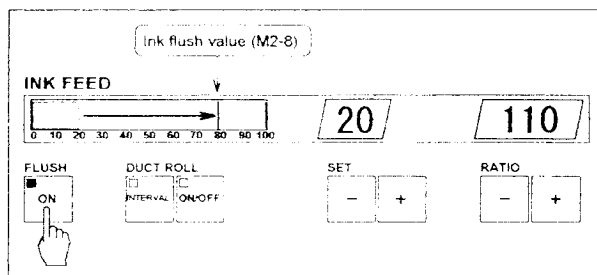
- Using the 0 to 9 keys, enter a two-digit value.



- Press the LOCK key to save the setting and exit M2 mode.




- To cancel the operation, press the STOP key.



5 Operating Procedures

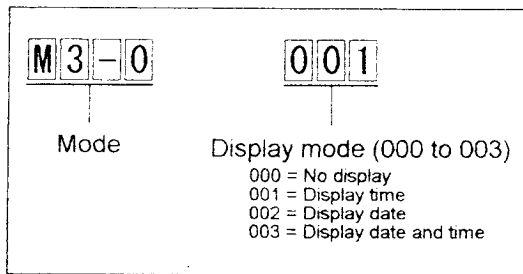
5.17 M1, M2 and M3 Modes

 Be sure to read and fully understand the "Safety Precautions" before operation. Also make sure you fully understand the safety remarks in the text.

5.17.3 M3 Mode

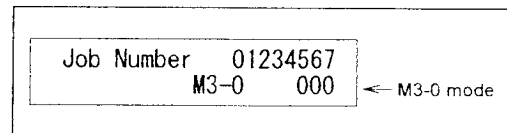
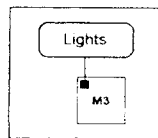
5.17.3.1 M3-0 : Time display mode

Set the mode which determines the display of the time and date in messages.

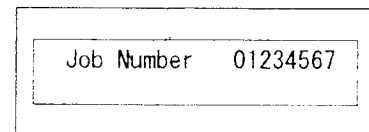
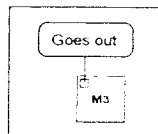
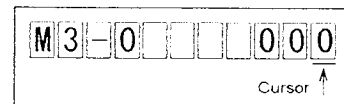


Procedure

- ① While pressing the **M3** key, press the **0** key to put the system into M3-0 mode. The M3 lamp lights and the current setting appears in the display.



- ② Using the **0** to **9** keys, enter a three-digit code.
- ③ Press the **LOCK** key to save the setting and exit M3 mode.



- ④ To cancel the operation, press the **STOP** key.