

# Programmer's Manual

Monarch®  
Sierra Sport 2  
9460 Printer

{F,1,A,R,E,100,200,"DIAPERS" |  
T,1,5,V,80,4,0,1,1,1,B,L,0,0 |  
T,2,6,V,80,102,0,1,1,1,B,L,0,0 |  
C,80,156,0,1,1,1,B,L,0,0,"ea." |  
C,65,4,0,1,1,1,B,L,0,0,"SKU" |  
T,3,10,V,65,35,0,1,1,1,B,L,0,0 |  
T,4,10,V,50,4,0,1,1,1,B,L,0,0 |  
T,5,2,V,50,110,0,1,1,1,B,L,0,0 |  
T,6,5,V,50,143,0,1,1,1,B,L,0,0 |  
B,7,10,V,0,4,4,0,45,8,L,0,0 }

{B,1,N,1 |  
1,"\$9.99" |  
2,"\$0.416" |  
3,"6387910981" |  
4,"KB DIAPERS" |  
5,"SM" |  
6,"24-pk." |  
7,"6387910981" }



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# GETTING STARTED



Before you read this manual, review the printer information in the *Operator's Handbook*. This manual provides the necessary information to design, write and print a Monarch® Printer Control Language II (MPCLII) format.

## **About This Manual**

---

This manual is for the developer who is creating the formats for the printer.

Use this manual to design and print your own custom formats on the Monarch® Sierra Sport2 printer. This chapter creates a sample Monarch® Printer Control Language II (MPCLII) packet.

## **Standard Features**

---

The following features are standard on the printer: 203 dots per inch (DPI) printhead, 1.89 inch by 12 inch maximum print image, print speed (2 or 3 inches per second), graphical LCD, 5 buttons (on/off, feed, and 3 context-sensitive), 512K RAM with an additional 2MB flash memory.

## Creating an MPCLII Format Packet

---

A *format* defines which fields appear and where the fields are printed on the label. The printer requires this information in a special form, using Monarch® Printer Control Language II (MPCL). This section describes how to create a sample MPCLII format packet.

Make sure supplies are loaded, you have a fully charged battery, the printer is connected to a host and ready to receive data, and you have software in the printer. Refer to your *Operator's Handbook* for more information.

1. Type the following format header in any text editor:

```
{F,25,A,R,E,200,200,"FMT-25" |
```

2. Type the following constant text field:

```
C,140,40,0,1,2,1,W,C,0,0,"SAMPLE FORMAT",1 |
```

3. Type the following bar code field:

```
B,1,12,F,85,40,1,2,40,5,L,0 |
```

4. Type the following text field:

```
T,2,18,V,50,50,1,3,1,1,B,L,0,0,1 |}
```

For detailed information about the format header, text, constant text, and bar code fields, see Chapter 3, “Defining Fields.” For information about batch packets, see Chapter 6, “Printing.”

You have created a format packet for your MPCLII printer. Now, a batch packet must be created before you can print the format.

5. Type the following batch header, after the text field line:

```
{B,25,N,1 |
```

6. Type the following bar code data:

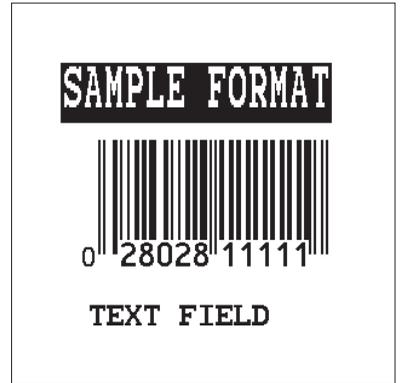
```
1, "02802811111" |
```

7. Type the following text field data:

```
2, "TEXT FIELD" |}
```

8. Save your file as SAMPLE.FMT.

9. Import the packets into your communications software or send it to the printer's communication port through the Monarch® MPCL Toolbox Download Utility (available on our Web site).



## **Printer Memory**

---

The printer has both RAM and flash memory. You can use one or both types of memory, depending on how you use your printer.

### **Using RAM**

Use RAM for temporary storage. It is volatile; the contents are lost when you turn the printer off. The printer has 512K of RAM.

RAM can contain formats, graphics, batches, and fonts. In the header of each packet, you specify to send it to RAM. Then, to download them to the printer from a host device. See Chapter 3, "Defining Fields," for more information.

## Using Flash Memory

Use flash memory for permanent storage. It is non-volatile; the contents stay in place until erased. The printer has 2MB of flash memory, depending on your configuration.

To load flash memory, use either the Monarch® MPCL Toolbox Soft Font Utility (fonts) or the Label Designer software (formats). This software is available on our Web site.

Every time you download these packets into flash memory, another copy is made, even if it is already in memory. After doing this several times, you will eventually use up flash memory.

## Starting with a Design

---

Before you create a format packet, you must design your label. There are several steps to designing a custom label:

1. Decide which fields should appear on your label. See “Determining Format Contents” for more information.
2. Determine your label size. Labels are available from us in a wide variety of sizes. Your application and the amount of data you need to print determines the supply size. Contact your Sales Representative for more information.
3. Draw a rough sketch of your label. You may want to draw several variations to see what works best. See “Drawing Rough Sketches” for more information.
4. Identify the field types that appear on your label. See “Considering Field Types” for more information.
5. Decide which fonts you want to use. See “Considering Fonts” for more information.
6. Fill out your Format Worksheet. See “Using the Format Worksheet” for more information.

At this point, you are ready to use your format.

7. Create a format packet, based on how you filled out your worksheet. See Chapter 3, “Defining Fields,” for more information.

## Determining Format Contents

---

Before you lay out your format, answer these questions. How large is your supply, which fonts do you want to use, do you want to include a bar code, and do you want to include graphics?

## Determining the Print Area

---

The print area varies depending on the size of your supply. Below are the maximum and minimum print areas. Notice that the top edge (leading edge) of the supply exits the printer first. There is a non-print zone (0.055 inches) on either edge of the supply.

Unit of Measure	Max. Supply (Wid x Len)	Max. Print Area (Wid x Len)	Min. Supply (Wid x Len)	Min. Print Area (Wid x Len)
English (1/100")	205 x 1200	189 x 1200	50 x 37.5	37.5 x 37.5
Metric (1/10mm)	521 x 3048	480 x 3048	127 x 95	95 x 95
Dots (1/203 dots)	416 x 2436	384 x 2436	102 x 76	76 x 76

The length you can print is dependent on the amount of memory you allocate for the image buffer. See "Defining the Memory Configuration Packet" in Chapter 2.

**Note:** For exact print area measurements of your supply, see the supply layout grids in Appendix D, "Format Design Tools."

Use the following formulas to convert inches to dots and metric:

$$\text{Dots} = \text{inches} \times 203$$

$$\text{Metric (1/10mm)} = \text{inches} \times 254$$

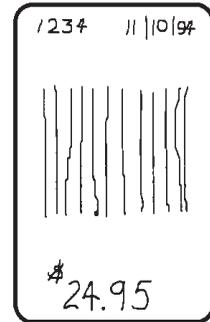
$$\text{English (1/100 inch)} = 100 \times (\text{dots}/203)$$

$$\text{Dots} = \text{Metric (1/10 mm)} \times .797$$

## Drawing Rough Sketches

After you decide what information you want to print, sketch how you want the information to appear on the label. Note any areas that are preprinted on the label, such as a logo.

As soon as you know what information to include on the label, and you have a rough sketch, you can use a supply layout grid to help you layout and size your label. If you do not want to use a grid, go to “Considering Field Types” to choose what information you want on your label.



## Using Supply Layout Grids

A supply layout grid contains measurement markers. These markers help you accurately position information on your label.

Decide whether you want to design formats using English, Metric, or Dot measurements. Choose from the following grids:

### English

The English grid is measured in 1/100 inches.

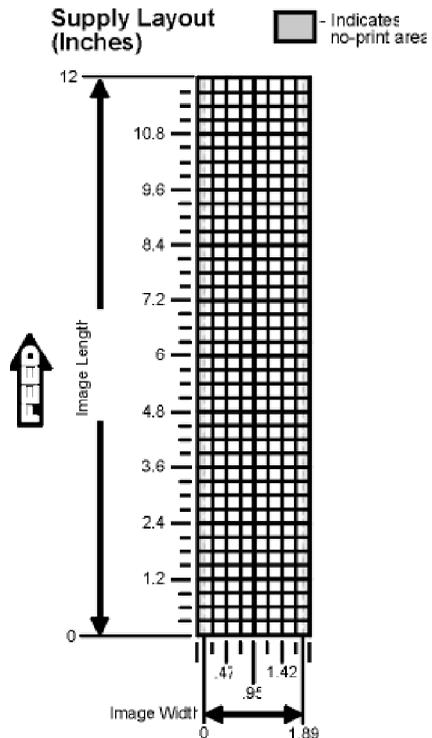
### Metric

The Metric grid is measured in 1/10 millimeters (mm).

### Graphic

The printer uses dots to print images on a label. The printhead has 203 dots per inch (dpi).

If you want to use the supply layout grids, a copy of each is in Appendix D, “Format Design Tools.”



## Considering Field Types

---

After you select a supply size, the next step in designing a format is to decide what information you want to print on the label. For example, you may want to print your company name, price of an item, and a bar code that combines information from other places. Everything you want to print falls into one of the following categories.

<b>Field Type</b>	<b>Description</b>	<b>Examples</b>
Text	Contains letters, numbers, or symbols you want to print.	item number, item description, department number, price, date
Bar Code	Used for printing bar codes that can be scanned.	item or serial numbers, zip codes, information you don't want to have visible to customers
Constant Text	Prints fixed characters that print without changing.	company name, company address
Line or Box	Highlights or separates items.	line marking out the regular price, border around the supply
Graphic	Contains a bitmap image or a compliance label overlay.	logos

All of the above field types except graphics are discussed in Chapter 3. See Chapter 5, "Creating Graphics" for information on including graphics in your format.

## Considering Fonts

---

When working with fonts, you have three considerations: font appearance, font size (scalable or bitmapped), and font spacing (monospaced or proportional). See Appendix B, "Fonts," for samples of each font.

## **Using the Format Worksheet**

---

The Format Worksheet is divided into sections that list the field types. Each section has boxes to fill in with parameters that define your format. A format worksheet is included in Appendix D, “Format Design Tools.”

### **Filling in the Format Worksheet**

Decide what type of field to use on your label.

1. Make a copy of the Format Worksheet.
2. Define the Format Header.
3. Define options as you require them. See Chapter 4, “Defining Field Options” for more information.

# CONFIGURING THE PRINTER

## 2

This chapter discusses how to

- set communication parameters.
- upload the printer's configuration or font information.
- configure the printer using online configuration packets.
- use immediate commands to control the printer's operation at any time.

## **Setting Communication Parameters**

---

Use the following information if you are connecting to the printer's 9-pin serial port.

The communication parameters at the printer must match those at the host, or you will not be able to communicate.

You can use the communication settings packet to set communication parameters for your printer.

On MS-DOS computers, you can use the MODE command to set communication values on your PC.

For example

```
MODE COM1:9600,N,8,1
```

This command sets your host to these communication values:

- a baud rate of 9600

- no parity

- 8 bit word length

- 1 stop bit

## Using MPCLII Conventions

---

Here are some guidelines to follow when using MPCLII.

### MPCLII Punctuation

Use the following symbols when creating MPCLII packets:

Character	Decimal Value	Description
{ (left bracket)	123	start of header
} (right bracket)	125	end of header
(vertical bar)	124	field separator*
, (comma)	044	parameter separator
"ABC" (quotation marks)	034	Quotation marks enclose character strings. Empty quotes ("") identify null strings or unused fields.
'comment' (single quotation marks)	039	Grave accents enclose comments. Any data enclosed in grave accents is ignored. Do not embed comments within a quoted string. Grave accents are also used to reject mainframe data.

\* The field separator is the split vertical bar, which we are representing as | in this manual. The decimal value is 124. To enter this character, use the Shift key plus the Split Vertical Bar key on your computer's keyboard. Depending on your text editor, it may appear as a solid vertical bar or as a split vertical bar.

**Note:** These MPCL characters are the default.

### Standard Syntax Guidelines

When creating MPCLII packets:

Begin each packet with a **start of header** ({}).

End each packet with an **end of header** ({}).

Define no more than **200** fields in a format. Each | indicates one field. However, options are not counted as fields. The actual number of fields a format can have may be less, because the number of fields is limited by the available memory.

The field number (**0** to **999**) must be unique. We recommend starting at 1, instead of 0.

Do not use a field number more than once per format.

Define all fields in the order you want to image/print them. The printer does not print in field number order.

Separate all parameters with a **Parameter Separator** (,).

End each field with a **Field Separator** (|).

Enter all information in CAPITAL letters, except words or phrases within quotation marks.

Include all parameters for a field unless documented as optional.

Define options immediately after the field to which they apply.

Multiple options can be used with most fields. Options can be used in any combination except as noted with each definition. Options are processed in the order they are received.

Keep in mind that proportionally spaced fonts need wider fields than monospaced fonts. For variable field data, use a letter "W" to determine the maximum field size.

Do not place a new line (return) or any other non-printing character within a field definition. However, a carriage return or line break after each | makes your formats easier to read.

```
T,1,20,V,30,30,1,1,1,1,B,C,0,0,0 |  
T,2,10,V,50,30,1,1,1,1,B,C,0,0,0|
```

Spaces are ignored, except within character strings.

Indenting options improves readability of your formats.

```
T,1,18,V,30,30,1,1,1,1,B,C,0,0,0 |  
  R,42,1 |
```

Use a tilde (~) followed by a 3-digit ASCII code in a quoted string to send function codes or extended characters or send the 8-bit ASCII code.

You can modify formats and fields with the optional entry method. See "Optional Entry Method" in Chapter 6 for more information.

## Using Online Configuration Packets

---

Use online configuration packets to change the printer's settings. You can send an individual configuration packet or a single packet containing all the configuration packets. Supply all parameters for each packet. Leave the parameters blank that you do not need to change. For example,

```
{ I,A,,,,1}
```

prints a slashed zero and uses the last sent *online* System Setup parameters.

Make a copy of the online configuration worksheet in Appendix D, "Format Design Tools," and save the original. Packets A-M are listed on the worksheet.

When you turn off the printer, all the information in the online configuration packets is saved and used when the printer is turned back on. After you change printer configurations, you must resend the format, batch, or graphic to the printer before the changes take effect.

Always include an I, immediately after the left bracket { and before the packet identifier (A, B, C, etc.). The I parameter identifies the data stream as a configuration packet.

**Note:** Include the I parameter with each packet if you are sending them individually. Include it only at the beginning of a data stream if you are sending multiple packets.

This is the syntax to use when you create online configuration packets:

### Syntax

{	Start of Header
<b>I</b> ,	Configuration Header
1 - 8 optional records	
A, parameter 1...parameter 5	System Setup
B, parameter 1...parameter 5	Supply Setup
C, parameter 1...parameter 5	Print Control
D, parameter 1...parameter 3	Monetary Formatting
E, parameter 1...parameter 9	Control Characters
F, parameter 1...parameter 5	Communication Settings
G, parameter 1...parameter 4	Backfeed Control
M, parameter 1...parameter 4	Memory Configuration
}	End of Header

### Syntax for single packet

{	Start of Header
<b>I</b> ,	Configuration Header
A, parameter 1...parameter 5	System Setup
}	End of Header

You can also add a configuration to RAM or specify units for supply, print, margin, and cut positions. If you use the optional parameters with the **I** packet, any online configuration packets following the split vertical bar (|) must specify distances using the selected units. However, the test labels display the units in dots, even if you entered them in English or Metrics units.

**Syntax** {header, ID#, action, device |}

1. *header* Constant **I**.
2. *ID#* ID. Use **0**.
3. *action* Action. Options:
  - A** Add configuration.
  - U** Upload User Configuration.
4. *device* Storage Device. Use **R** (Volatile RAM).

## 5. *units*

Units. (Optional parameter.) Options:

<b>E</b>	English (1/100 inches)
<b>M</b>	Metric (1/10 mm)
<b>G</b>	Dots

### *Example*

```
{I,0,A,R,E|  
C,0,25,0,0,0|}
```

Adds a configuration to volatile RAM and specifies English units. It also uses the default contrast, moves print 0.25 inches closer to the bottom of the supply and does not change the margin adjustment, prints at the default print speed, and uses the default printhead width.

If you do not use the optional parameters, the syntax for the online configuration packets does not change. For example,

```
{I,C,0,50,0,0,0|}
```

uses the default contrast, moves print 50 dots (0.25) inches closer to the bottom of the supply and does not change the margin adjustment, prints at the default print speed, and uses the default printhead width.

### *Example*

```
{I,0,U,R|}
```

Uploads the printer configuration from volatile RAM and returns the following to the host.

```
A,0,0,0,0,1|  
B,2,0,0,0,0|  
C,0,0,0,0,0,0|  
D,1,0,2|  
E,"~123~044~034~124~125~126", "", "~013~010"|  
F,3,1,0,0,1|  
G,0,65,65|  
M,R,R,160|  
M,T,R,20|  
M,I,R,320|  
M,D,N,1280|  
M,F,N,640|  
M,V,R,1280|
```

The parameters for each packet (**A-M**) are displayed. The remaining lines beginning with **M** list the buffer sizes in 1/10K for the Receive, Transmit, Image, Downloadable Fonts, Formats, and Scalable Fonts Buffers.

## Configuration Syntax Guidelines

When creating a printer configuration packet:

Follow the “Standard Syntax Guidelines” listed at the beginning of this chapter.

The first character after the **start of header** (**{**) is the **configuration header** (**I**).

Download multiple configuration packets within one packet or download a single configuration packet.

If you change any of the online configuration packets, resend the format packet to the printer, so the configuration changes take effect.

Include the first five ANSI codes, at a minimum, in the control characters packet.

Send configuration packets once per session (each time the printer is turned off and then back on), not with every format or batch packet.

Make sure the communication settings at the host match those at the printer.

## Making Print Adjustments

---

You can adjust where the printer prints on your supply by adjusting the supply, print, or margin positions. However, keep in mind the following:

Supply adjustments across the width of your supply, such as the margin position, are based in dots. The printhead has 203 dots per inch.

Supply adjustments for the length of your supply, such as supply position or print adjustment, are measured in 1/203 of an inch.

## Defining the System Setup Packet

---

Use the system setup packet (A) to select the power up mode, display language, print separators between batches, print a “slashed zero,” and select the symbol set.

**Syntax**                    {**I**,**A**,**powup\_mode**,**language**,**sep\_on**,**slash\_zero**,  
                              **symbol\_set** }

**A1. A**                    System Setup Packet

**A2. powup\_mode** Online Mode. Enter **0**.

**A3. language**        Display Language. Options:  
                              **0**        English (default)  
                              **1**        French  
                              **2**        German  
                              **3**        Spanish - ES

**A4. sep\_on**            Batch Separators. The printer does not print batch separators. Enter **0**.

**A5. slash\_zero**      Slash Zero. Options:  
                              **0**        Print a standard zero (default)  
                              **1**        Print a zero with a slash through it

**A6. symbol\_set**      Symbol Set. Options:  
                              **0**        Internal (default)  
                              **1**        ANSI  
                              **2**        Code Page 437 (Latin U.S.)  
                              **3**        Code Page 850 (Latin 1)  
                              **4**        Code Page 1250 (Latin 2)  
                              **5**        Code Page 1251 (Cyrillic)  
                              **6**        Code Page 1252 (Latin 1)  
                              **7**        Code Page 1253 (Greek)  
                              **8**        Code Page 1254 (Turkish)  
                              **9**        Code Page 1255 (Hebrew)  
                              **10**      Code Page 1256 (Arabic)  
                              **11**      Code Page 1257 (Baltic)  
                              **12**      Code Page 1258 (Vietnamese)  
                              **13**      DOS Code Page 852 (Latin 2)  
                              **14**      DOS Code Page 855 (Russian)  
                              **15**      DOS Code Page 857 (IBM Turkish)  
                              **16**      DOS Code Page 860 (MS-DOS Portuguese)  
                              **17**      Wingdings  
                              **18**      Macintosh  
                              **19**      Unicode

**Note:** The Standard, Reduced, Bold, OCRA and HR fonts only support the Internal Symbol Set (0). The CG Triumvirate™ typefaces support only the ANSI and DOS Code Page 437 and 850 Symbol Sets. The scalable font (font 50) does not support Code Page 1256 (Arabic). Code pages 852-860 and 1250-1258 are for downloaded TrueType® fonts or the scalable font. Symbol set 19 requires a downloaded International TrueType font. TrueType fonts are designed to be regionally specific; therefore, all code pages may not be supported in a given font. See Appendix C for more information.

*Example*            {I,A,0,0,0,1,0 }

Powers up the printer in the online mode, displays prompts in English, does not print a separator after each batch, prints zeros with slashes through them, and uses the internal symbol set.

## Defining the Supply Setup Packet

Use the supply setup packet (B) to select supply type, printhead energy, feed mode, and supply position.

*Syntax*            {I,B,supply\_type,ph\_energy,feed\_mode,supply\_posn }

*B1. B*            Supply Setup Packet

*B2. supply\_type*    Supply Type. Options:

- 0      Black mark supply
- 1      Die Cut/edge aperture supply (default)
- 2      Continuous (non-indexed) supply

**Note:** You must use continuous (non-indexed) supply in continuous mode. You may need to adjust the print contrast (in the Print Control packet) based on the type of supply you are using.

*B3. ph\_energy*    Printhead energy. Options:

- 0      Standard Supplies (default)
- 1      Special (fax paper)
- 2      High Energy (linerless and synthetic)

**Note:** We do not recommend printing serial bar codes with linerless supplies.

*B4. feed\_mode*    Feed Mode. Options:

- 0      Continuous operation (default)
- 1      On-demand mode (purchase optional)

*B5. supply\_posn* Supply Position. Range: **-99** to **99** in 1/203 inch. 0 is the default. Adjusts the machine to print at the vertical 0,0 point on the supply. This adjustment accounts for mechanical tolerances from machine to machine. The supply position adjustment only needs to be made on the initial machine setup. Adjust the supply position if formats do not start at the 0,0 point on the supply. Increase the supply position to move print up, decrease to move print down on the label. To verify the 0,0 point, print a test label. See "Printing a Test Label" in Chapter 8 for more information.

You can not change the supply position while the printer is active. Changing the supply position will affect the print position, dispense position, and backfeed distance. Once the supply position is set, use the print control packet and backfeed control packet to adjust printing and the dispense position.

*Example*            {**I**,**B**,**0**,**0**,**1**,**10** | }

Indicates black mark and thermal direct stock has been loaded, causes the printer to operate in on-demand mode (purchase optional), and feeds the supply approximately .05 inches up before printing the format on each label (10/203 inches).

## Defining the Print Control Packet

---

Use the print control packet (C) to set the contrast, print, and margin adjustment, print speed, and printhead width.

**Syntax**                    {**I**,**C**,**contrast**,**print\_adj**,**margin\_adjust**,**speed\_adj**,  
                                  **ph\_width**! }

**C1. C**                    Print Control Packet

**C2. contrast**            Print Contrast. Range: **-28** to **40**. 0 is the default. You may need to adjust this value depending on the type of supplies you are using. For example, linerless supplies require a higher print contrast, but receipt paper requires less contrast.

**C3. print\_adj**            Print adjustment (position). Range: **-99** to **99** in 1/203 inch. 0 is the default. Adjusts where data prints vertically on the supply. Increase the print position to move print up, decrease to move print down.

**C4. margin\_adj**        Margin adjustment (position). Range: **-99** to **99** in 1/203 inch. 0 is the default. Adjusts where data prints horizontally on the supply. Increase the margin position to move print to the right, decrease to move print to the left. Margin and print position are format adjustments. They will not effect the supply position, dispense position, or backfeed distance.

**C5. speed\_adj**        Print Speed in inches per second (ips). Options:

- 0**            The printer determines the print speed automatically. This is the default.
- 20**          Uses a print speed of 2.0 ips. This is the only valid speed for serial bar codes. If the speed is set differently, the printer changes to this speed to print serial bar codes.
- 30**          Uses a print speed of 3.0 ips

**C6. ph\_width**        Width of the printhead in dots. Use **0**.

**Example**                {**I**,**C**,**0**,**-20**,**-10**,**0**,**0**! }

Uses the default contrast, moves print 0.1 inch closer to the bottom of the supply (20/203 inches) and .05 inch to the left on the supply (10/203 inches), the printer determines the print speed, and uses the default printhead width.

## Defining the Monetary Formatting Packet

---

The monetary formatting packet (D) selects the monetary symbols to print for a price field. Use the monetary formatting packet to select primary and secondary monetary symbols, and designate the number of digits to appear at the right of a decimal.

**Syntax**                    {**I**,**D**,*cur\_sym*,*secondary*,*decimals*! }

**D1. D**                    Monetary Formatting Packet

**D2. *cur\_sym***            Currency Symbol. Options:

<b>0</b>	No symbol
<b>1</b>	USA (\$, Dollar- default)
<b>2</b>	UK (£, Pound)
<b>3</b>	Japan (¥, Yen)
<b>4</b>	Germany (₳, Deutsche Mark)
<b>5</b>	France (F, Franc)
<b>6</b>	Spain (P, Peseta)
<b>7</b>	Italy (L., Lira)
<b>8</b>	Sweden (Kr, Krona)
<b>9</b>	Finland (₯, Markka)
<b>10</b>	Austria (₯, Shilling)
<b>11</b>	India (Rs, Rupee)
<b>12</b>	Russian (₮, Ruble)
<b>13</b>	Korean (₩, Won)
<b>14</b>	Thai (฿, Baht)
<b>15</b>	Chinese (¥, Yuan)
<b>16</b>	Euro-Dollar (€)

**Note:** To use these symbols, select the internal symbol set.

**D3. *secondary***        Secondary Sign. Secondary symbols only print if you designate at least one decimal place. Options:

<b>0</b>	No secondary sign (default)
<b>1</b>	Print secondary sign

**D4. *decimals***        Number of digits to the right of the decimal. Options:

<b>0</b>	No digits
<b>1</b>	One digit
<b>2</b>	Two digits (default)
<b>3</b>	Three digits

**Example**                {**I**,**D**,**1**,**1**,**2**! }

Prints the dollar sign, uses a secondary symbol, and places two digits to the right of the decimal.

## Defining the Control Characters Packet

---

Use the control characters packet (E) to change the MPCLII control characters, enable and disable the immediate commands, and change the default terminator character for job requests and ENQ's.

Changes take effect with the first character following the end of header character } of the configuration packet. Each control character must be unique and cannot appear anywhere else in your packet, except within quotation marks. You can customize the trailer characters to work with your host.

**Note:** Wait two seconds for the new characters to take effect before sending packets using the new characters.

Use the following syntax for the control characters packet. Notice all but the first parameter are within quotation marks.

**Syntax**                    {I,E,"ANSI\_cd","string1","string2" |}

E1. E                    Control Characters Packet

E2. "ANSI\_cd"        ~123     Start of header     {            (left bracket)  
                      ~044     Parameter            ,            (comma)  
   separator  
                      ~034     Quoted strings     "            (quotes)  
                      ~124     Field separator     |            (pipe sign)  
                      ~125     End of header        }            (right bracket)  
                      ~126     Data escape         ~~           (double tilde)  
   character (optional)  
**def. ch.**            Immediate command character (optional).  
                      Up to any 3 characters in the 0 to 255 decimal  
                      range. The character must be defined before this  
                      command can be used. The caret (~094) is  
                      normally used.

**Note:** "ANSI\_cd" includes seven separate parameters. The first five parameters are required. The other parameters are optional.

E3. "string 1"        Terminator for status requests and ENQ requests. Up to any 3 characters in the 0-255 decimal range. The default is "013". Sending "" disables this sequence.

E4. "string 2"        Terminator for job requests and data uploads. Up to any 3 characters in the 0-255 decimal range. The default is none. Sending "" disables this sequence.

After you change these parameters, all packets, including any future configuration packets, must use the new control characters. We recommend using the tilde and ASCII character code sequence when sending this packet multiple times. Also, set the packet delimiters to characters within the 21 hex to 7E hex range.

You must send the control characters packet to enable the immediate commands. An immediate command executes immediately, even if it is embedded within quotation marks, and all data following the command in the string is ignored.

Example                    {I,E,"~123~063~034~124~125~126~094" | }

Changes the parameter separator character from , to ?. The other control characters remain unchanged. It also enables the immediate commands by defining the ^ symbol as the command identifier.

## Resetting Control Characters

You can change the characters in the previous example back to their original settings by downloading this packet:

```
{I?E?"~123~044~034~124~125~126~094" | }
```

Notice that the parameter separator is ? in this packet. This is the parameter separator that was set before this packet. Once the packet is received by the printer, the new parameter separator (a comma, in this case) is valid.

Be careful when using this feature. If you forget what the control characters were changed to, print a test label. (The test label lists the current control characters.) See "Printing a Test Label," in Chapter 8 for more information.

## Using Immediate Commands

---

Immediate commands effect printer operation as soon as the printer receives them, even if they are included within a packet or used inside quotation marks.

You can use immediate commands to change immediate command or status polling control characters, reset the printer, or cancel and repeat batches.

### Enabling Immediate Commands

When the printer is first turned on, these commands are not available. To use these commands, you must first send the control characters packet and define the immediate command control character. The immediate command control character is saved when you turn off the printer. Once the immediate command control character is defined, the immediate commands are enabled.

### Sending Immediate Commands

Immediate commands consist of a three- or four-character sequence you can send in a packet or embed in your application. Each command must be sent separately.

*Syntax*                    control character\_immediate command

The printer can accept only one immediate command at a time. Sending a command before the previous one is completed can result in an error.

*Example*                    ^CB

Immediately cancels the batch currently printing unless an error exists in the printer. This example assumes that the defined immediate command control character is the caret (^).

The table represents the defined immediate command control character as ^ and the defined status polling control character as d. You may define these characters to suit your needs.

To use the immediate command control character or the status polling character within your data, use the tilde sequence

Command	Parameter
^CA	Cancels all the batches in the queue unless an error exists on the printer.
^CB	Cancels only the current batch being printed unless an error exists.
^DD or ^DCd	Disables the MPCL data escape character (the tilde) and inhibits MPCL from acting on ANY data escape sequence from the host. Sets the MPCL data escape character to the ASCII value given by the <b>d</b> parameter. The value can be any ASCII character.
^EA	Aborts an error condition. This command is the same as pressing the left ⏏ button to clear an error. May need to be sent multiple times. Use ^RB to reprint batch. <b>CAUTION:</b> This command causes the current batch to stop and the condition that caused the error to remain uncorrected.
^ED	Disable error reporting.
^EA	Enable error reporting. Sends an “E” plus the error number to the serial port, so a print server can track errors. For example, error 704 is sent to the serial port as E704.
^ER	Resets the error. This command is the same as pressing ⏏ to acknowledge an error. Normal operation resumes.
^FD	Feeds a label when printer is idle. Simulates the operation of pressing ⏏ and dispenses the next label if printer is in the on-demand mode. <b>Note:</b> Printer ignores this command if printing.
^ID or ^ICd	Disables the Immediate Command feature by turning off the Immediate Command escape character. Sets the Immediate Command escape character to the ASCII value given by the <b>d</b> parameter. The value can be any ASCII character. Use ^IE to enable immediate commands.
^MC	Returns the customer ID or RPQ version to the host. <b>(00 to 99)</b>
^MD	Returns the printhead dot density to the host. <b>00</b> = 203 dpi
^MF	Uploads the MIF file to the host.
^MI	Returns the customer ID or RPQ revision level to the host. <b>(00 to 99)</b>
^MM	Returns the model number to the host. <b>22</b> = 9460
^MP	Returns the prototype number to the host. <b>(00 to 99)</b>
^MR	Returns the revision number to the host. <b>(00 to 99)</b>
^MS	Returns the flash file system information.
^MV	Returns the version number to the host. <b>(00 to 99)</b>
^PR	Resets the printer. This command takes five seconds to complete and then the printer is ready to receive data. It has the same effect as turning off and then turning on the printer. <b>Note:</b> Command should be used only when the printer is <b>not</b> printing.
^RB	Repeats the last printed batch, printing the same number of labels as specified in the original batch. This command does not work if using batch separators. <b>Note:</b> Printer ignores this command if printing.

Command	Parameter
<b>^RS</b>	Resynchronizes supply when supply roll is changed. <b>Note:</b> Printer ignores this command if printing.
<b>^SD or ^SCd</b>	Disables the status polling feature by turning off the status polling control character. Sets the status polling control character to the ASCII value given by the <b>d</b> parameter. The value of <b>d</b> can be any ASCII character.
<b>^TP</b>	Prints a test label. <b>Note:</b> Printer ignores this command if printing.

**Note:** To use the immediate command control character or the status polling character within your data, use the tilde sequence.

## Defining the Communication Settings Packet

Use the communication settings packet (F) to set the baud rate, word length, stop bits, parity, and flow control for serial communications. Changing the communication settings takes approximately two seconds. Communications sent during this interval will be lost. Make sure the host communication values match the values on the printer and the host is capable of communicating at the speed you select for the printer.

Do not add any characters, such as a carriage return/line feed, in your communication settings packet or communications errors may occur.

**Syntax**                    {**I**,**F**,*baud*,*word\_length*,*stop\_bits*,*parity*,  
                                  *flow\_control*!}

**F1. F**                      Communication Settings Packet

**F2. *baud***                Baud Rate. Options:  
                              **0** 1200                    **1** 2400  
                              **2** 4800                    **3** 9600 (default)  
                              **4** 19200                   **5** 38400

**F3. *word\_length***        Word Length. Options:  
                              **0**     7-bit word length (odd or even parity only)  
                              **1**     8-bit word length (default)

**F4. *stop\_bits***            Stop Bits. Options:  
                              **0**     1-stop bit (default)  
                              **1**     2-stop bits



**Syntax**                    {**I,G,action,dis\_pos,bkfd\_dis** | }

**G1. G**                    Backfeed Control Packet

**G2. action**            Action. Options:  
                  **0**        disable backfeed (default)  
                  **1**        enable backfeed

**G3. dis\_pos**            Dispense Position. Adjusts the stopping point of the label. **10 to 200** dots (default 65 dots).

**G4. bkfd\_dis**           Backfeed Distance. Amount to move label backwards. **10 to 200** dots (default 65 dots). This distance can not be greater than the dispense position.  
The backfeed distance should equal the dispense position. An exception is if you are tearing instead of peeling. Then, the backfeed distance must be 30 dots (.150 inches) less than the dispense position. However, you will have a 30 dot non-print zone on your supply. The 30-dot difference accounts for improper tearing of butt cut supplies, because you do not want any exposed adhesive under the printhead.

**Example**                {**I,G,1,50,10** | }

Enables backfeed and sets the dispense position to 0.25 inches (50/203) and the backfeed distance to 0.05 inches (10/203).

## Special Considerations When Using Backfeed

Make a note of the following items:

Be careful when tearing supplies, because the adhesive can adhere to the printhead or platen roller.

Backfeed effects each label in the on-demand mode or the first and last label of the batch in continuous mode.

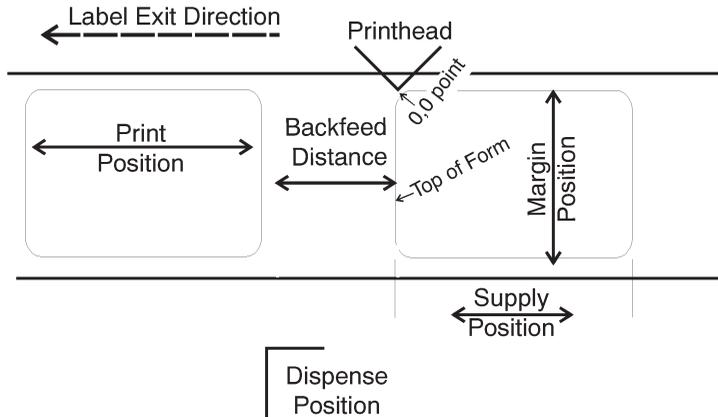
When backfeed is enabled and multiple batches are sent, the printer may not backfeed between each batch.

Backfeed should only be used when you need to advance labels to the desired dispense point.

Backfeed does not interfere with the supply, print, or margin positions you have set.

If the supply inter-label gap is not between .07 inch to .15 inch (14 to 30 dots), you must adjust the dispense position and backfeed distance accordingly.

See the following graphic for a representation of the following adjustments: dispense position, backfeed distance, supply position, print position, and margin position.



Contact Technical Support if you have problems adjusting where the format prints on the supply.

## Defining the Memory Configuration Packet

Use the memory configuration packet (M) to customize the size of your printer's buffers, which gives you greater flexibility in your formats.

Memory must be allocated in 1/2K increments. The memory configuration packet does not accept decimals, so enter whole numbers. Multiply the amount to reallocate (in K) by 10. For example,

To reallocate (in K)	Enter this amount
1	10
1.5	15
2	20
2.5	25
153	1530
229.5	2295

Each buffer's allocated memory remains in effect until that buffer is reallocated. For this reason, you may want to reallocate all the buffers when reallocating any buffer. If you reallocate more memory than you have available, you will receive an error.

**Syntax**                    {**I**,**M**,**buffer**,**device**,**buffer\_size** ! }

**M1. M**                    Memory Configuration Packet

**M2. buffer**                Buffer type. Options:  
**D**            Downloadable Fonts  
**F**            Format  
**I**            Image  
**R**            Receive  
**T**            Transmit  
**V**            Scalable (vector) fonts

**M3. device**                Storage type. Use **R** (volatile RAM).

**M4. buffer size**            Buffer size. Options:

Buffer	Range	Default
Transmit	.5K- 4K	10K
Receive	2K- 16K	40K
Image	16K-114K	38.9K
Downld. Fonts	64K-128K	64K
Scalable Fonts	10K-128K	64K
Formats	16K- 128K	16K
Internal	cannot reallocate	cannot reallocate

**Note:** For the scalable font buffer, specify 10 if you do not use the buffer. When using the buffer, specify a minimum of 40. The larger the number you specify for the image buffer, the longer your formats can be. As a rule of thumb, divide the value you select by 100, and round up to the next whole number. That number will be the length in inches.

**Example**                    {**I**,**M**,**I**,**R**,**1530** ! }

Stores the image buffer in volatile RAM and allocates 153K for it.

## Checking Current Buffer Sizes

Send a configuration upload packet to check the sizes of your current buffers. See “Configuration Packet Header” for more information. After you check your current buffer sizes you can begin reallocating memory.

If you want to increase your image buffer and you will not be using scalable fonts, add that memory into your image buffer.

### Example

{ <b>I</b> ,M,R,R,20 }	Receive buffer	2K
M,T,R,10 }	Transmit buffer	1K
M,D,N,80 }	Downloadable fonts	8K
M,V,R,160 }	Scalable fonts buffer	16K
M,I,N,3200 }	Image buffer	320K

Make sure memory is available before adding memory to a buffer. In the above example, if the image buffer (M,I,N,3200) was defined before the downloadable fonts and scalable fonts buffers (M,D,N,80 and M,V,R,160) were defined, an error would have occurred.

## About Memory Buffers

---

- Transmit Buffer** Used to send ENQ, job, and upload responses. This buffer must be allocated as volatile (**R**) RAM.
- Receive Buffer** Used to save data received from the host before it is processed by the printer. Changing this buffer size affects the amount of data the printer can receive without using flow control. This buffer must be allocated as volatile (**R**) RAM.
- Image Buffer** Used to image the current format. Use the formula below to calculate the approximate image buffer size.
- $$10K \times \text{Length}$$
- Length is the length of your label in inches.

*Example*

$$10K \times 10 = 100$$

(Multiply by 10 and round up)

$$100K \times 10 = 1000$$

Enter 1000 for your Image buffer.

**Format Buffer**

Used to store formats, batch data, and graphics. Use the following formula to calculate the required format buffer size:

$$\text{Linecount} \times 50/1024$$

*Linecount* is the number of lines in your format packet including the format header and all the options.

The result of the above calculation is in kilobytes. Formats remain in memory when you turn off the printer.

**Downloadable Fonts Buffer**

Used to store downloaded soft (bitmapped or TrueType) fonts. To determine the size of your downloadable fonts, send a font packet. For TrueType fonts, the file size, in bytes, is the minimum amount needed in this buffer. See "Using the Font Packet" for more information.

**Scalable (Vector) Fonts Buffer**

Used to image the scalable or downloaded (TrueType or bitmapped) font characters. Increasing this buffer size allows more characters to be saved in cache memory, so the characters do not have to be re-built the next time they are printed. Use **10** if you are not using scalable/TrueType fonts. This buffer must be allocated as volatile (**R**) RAM.

The printer does not print the fonts if there is not enough memory in this buffer to image them.

## Buffer Worksheet

Make copies of this page to use as a buffer worksheet.

	HEADER	BUFFER	DEVICE	BUFFER SIZE
DOWN LOADABLE FONTS BUFFER	M	D		
FORMAT BUFFER	M	F		
IMAGE BUFFER	M	I		
RECEIVE BUFFER	M	R	R	
TRANSMIT BUFFER	M	T	R	
SCALABLE FONTS BUFFER	M	V	R	

## Buffer Allocation Considerations

Keep these items in mind when allocating memory.

Do not allocate more memory than what is available.

Free memory from one buffer *before* you add it to another buffer.

Reallocate all the buffers if you need to reallocate any buffer.

Send all buffer (re)allocations in one packet. The printer evaluates each individual buffer allocation separately. If one buffer allocation is invalid, the entire packet is invalid. If you define a buffer size that exceeds the maximum value, an error occurs. However, no information is lost.

Whenever the printer accepts a memory configuration packet, it takes effect immediately, causing a printer reset. Any information contained in the buffers is lost. Resend your formats, batches, graphics, or fonts to the printer.

If you remap your image buffer, make sure the length and width specified in your format header are not too large for the current image buffer. In other words, if you remap for a 2 x 6 inch label, you cannot print a 2 x 10 inch label without receiving an error, until you change your format header or increase your image buffer.

## Memory Considerations with Downloaded TrueType Fonts

The size of the TrueType font file, in bytes, is the minimum amount of memory you must have available in the downloadable fonts buffer.

The scalable (vector) fonts buffer is used to image the downloaded fonts (TrueType). If you are using several downloaded TrueType fonts, you may need 100K or more in this buffer. The printer does not print the fonts if there is not enough memory in the scalable (vector) fonts buffer.

To use large point sizes (greater than 60 point), you must reconfigure memory and increase the size of the scalable (vector) fonts buffer.

## Clearing Packets from Memory

---

You may want to remove packets from the printer to increase memory storage capacity or if the formats/fonts are no longer needed. In some cases, turning the printer off may clear the packets from memory. If not, send a format clear packet.

**Syntax**                    {header,packet#,action,device |}

1. *header*                Identifies the packet. Options:
  - A**     Check Digit Scheme
  - F**     Format
  - G**     Graphic
  - W**     Font
2. *packet#*             Identification number of the packet to clear (1 to 999) or font number (0 to 9999). 0 is for all fonts.
3. *action*                Action. Enter **C** to clear the packet.
4. *device*                Storage device. Options:
  - F**     Flash
  - R**     Volatile RAM

**Example**                {F,1,C,R |}

Clears Format #1 from volatile RAM.

## Using the Font Packet

---

You can use a font packet to add or clear downloaded fonts from memory, upload your font buffer, or upload the cell size information for a particular font. The font packet is useful when you are downloading fonts. If you are using downloaded fonts, the font number and the number of bytes each downloaded font uses is listed.

This packet does not list the number of bytes the standard printer fonts use.

Use the MONARCH® MPCL Toolbox **Font Utility** (available on our Web site) to create the font header and data. Refer to the online help for more information.

**Syntax**                    {W, font#, action, device, data\_length, data\_record!}

*W1. W*                    Writable Font Header.

*W2. font#*                The font identifier from **0** to **32000**.  
**0** is for all fonts. **1** to **5** digits is the font number.  
Example: 3 is the standard printer font, Bold.

*W3. action*                Action. Options:  
**A**        Adds the specified font.  
**C**        Clears all or specified fonts, except ones in flash.  
**H**        Uploads font size information.  
**M**        Uploads font memory usage information.

*W4. device*                Device. Options:  
**R**        Volatile RAM  
**Z**        All devices (use for upload).

*W5. data\_length*        The length of the font data. The range is **68** to **16384**.  
(*optional*)

If you are creating fonts, you need to have font data included with this packet.

*W6. data\_record*        Multiple data records define the font. The first character is either an **H** (hex) or an **R** (run-length), referring to the algorithm. The rest of the record is up to 2710 characters of font data in double quotes. Separate the algorithm and the data with a comma, and end the record with **!**.

*Example* {W,0,M,R | }

Selects all fonts and checks the memory usage in RAM. The printer returns the following to the host:

```
{W,0,M,R |  
Number of bytes free, Number of bytes used|}
```

*Example* {W,0,H,Z | }

Selects all fonts and uploads the font size information for any downloaded fonts.

The 9855 printer returns the following to the host:

```
{W,0,H,Z | _____ FontStyle _____ FontName  
0,1,0, "Standard",0,0,0,21,33,21,33,5,1 | _____ Spacing  
0,1,437, "Standard",0,0,0,21,33,21,33,5,1 | _____ Baseline  
0,2,0, "Reduced",0,0,0,10,21,10,21,2,1 | _____ Cell Width  
0,2,437, "Reduced",0,0,0,10,21,10,21,2,1 | _____ Cell Height  
0,3,0, "Bold",0,0,0,36,51,36,51,5,1 | _____ Nominal Width  
0,3,437, "Bold",0,0,0,36,51,36,51,5,1 | _____ Nominal Height  
0,4,0, "OCRA",0,0,0,19,36,19,36,5,1 | _____ Inter-Character Gap  
0,4,437, "OCRA",0,0,0,19,36,19,36,5,1 | _____  
0,5,0, "HR1",0,0,0,18,30,18,30,3,1 | _____  
0,5,437, "HR1",0,0,0,18,30,18,30,3,1 | _____  
0,6,0, "HR2",0,0,0,26,24,26,24,2,1 | _____  
0,6,437, "HR2",0,0,0,26,24,26,24,2,1 | _____  
0,10,0, "CGTriBd9",1,0,7,25,31,10,15,0 | _____ Type  
0,10,1, "CGTriBd9",1,0,7,25,31,10,15,0 | _____  
0,10,437, "CGTriBd9",1,0,7,25,31,10,15,0 | _____  
0,10,850, "CGTriBd9",1,0,7,25,31,10,15,0 | _____  
0,11,0, "CGTriumv6",1,0,5,17,21,5,10,0 | _____ Printhead Density  
0,11,1, "CGTriumv6",1,0,5,17,21,5,10,0 | _____  
0,11,437, "CGTriumv6",1,0,5,17,21,5,10,0 | _____  
0,11,850, "CGTriumv6",1,0,5,17,21,5,10,0 | _____  
0,50,0, "Swiss Bold",1,1,92248 | _____ Symbol Set  
0,50,437, "Swiss Bold",1,1,92248 | _____ }
```

\* The CG Triumvirate typefaces are trademarks of Monotype Imaging, Inc.

<b>Spacing</b>	Monospaced (0) or proportional (1).
<b>Type</b>	Bitmapped (0) or scalable (1).
<b>Baseline</b>	Bottom of the font.
<b>Cell Width</b>	Horizontal number of dots to contain the widest character.
<b>Cell Height</b>	Vertical number of dots to contain the tallest character.
<b>Nominal Width</b>	Average width for lower-case letters.
<b>Nominal Height</b>	Average height for lower-case letters.
<b>Inter-Character Gap</b>	Default spacing between characters in monospaced fonts.
<b>Printhead Density</b>	Shows that a 203 (0) dpi printhead is used. The scalable font (font 50) does not report a value for printhead density.

## Uploading Format Header Information

You can upload format header information from the formats in memory to check the supply length and width for each format.

**Syntax**                    {header, format#, action, device!}

*F1. header*                Format Header

*F2. format#*              Format number from **0** to **999**. 0 is for all formats in memory.

*F3. action*                Action. Options:

- A**     Adds the specified format
- C**     Clears the specified format
- H**     Uploads format header information

*F4. device*                Device. Options:

- R**     Volatile RAM
- Z**     All devices (use for upload)

*Example*            {F,0,H,Z | }

Selects all formats in memory and returns the following:

*Example*            {F,0,H,Z |  
Fmt\_1,406,406 |  
Fmt\_10,324,406 |  
Fmt\_15,812,812 |  
Fmt\_20,305,609 |  
Fmt\_25,1218,406 | }

Displays the format number, supply length and supply width (in dots) for each format in memory.

*Example*            {F,1,H,Z | }

Selects format1 and returns the following to the host:

```
{F,1,H,Z |  
Fmt_1,406,406 | }
```

Displays the supply length and supply width (in dots) for format1.

# DEFINING FIELDS

3

This chapter provides a reference for defining

- the format header
- text and constant text
- bar code fields
- line and box fields.

## Defining the Format Header

---

A Format Header begins a format file.

**Syntax**            {F, format#, action, device, measure, length,  
                         width, "name" }

**F1. F**                Format Header.

**F2. format#**        Unique number from **1** to **999** to identify the format.

**F3. action**            Action. Enter **A** to add the format to the printer.

**F4. device**            Format storage device. Options:  
                         **F**        Flash  
                         **R**        Volatile RAM

**F5. measure**        Unit of measure. Options:  
                         **E**        English, measured in 1/100 inches  
                         **M**        Metric, measured in 1/10 mm  
                         **G**        Graphic, measured in dots

**F6. length**            Supply length in selected units. Measure supply from the leading edge of one label to the leading edge of the next label.

English    **0 - 1200**  
Metric     **0 - 3045**  
Dots       **0 - 2436**

**F7. width**            Supply width, from left to right, in selected units.

English    **50 - 205**  
Metric     **127 - 521**  
Dots       **102 - 416**

**F8. "name"**            Format name (optional), **0** to **8** characters, enclose within quotation marks.

**Example**            {F, 1, A, R, E, 300, 200, "TEXTILES" }

Adds Format 1 ("TEXTILES") to the printer. It uses a three inch long by two inch wide label.

# Defining Text Fields

Create a separate definition for each text field. If text falls on two lines, each line of text requires a separate definition.

**Syntax**            T, field#, # of char, fix/var, row, column, gap, font, hgt mag, wid mag, color, alignment, char rot, field rot, sym set !

T1. T                    Text Field.

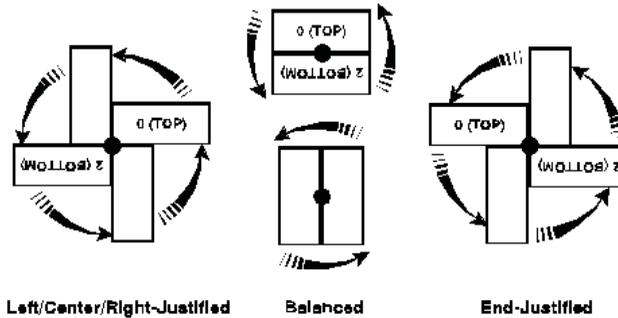
T2. field#             Unique number from 1 to 999 to identify this field.

T3. # of char         Maximum number of printed characters (0 to 2710) in the field.

T4. fix/var            Fixed or variable length field. Options:

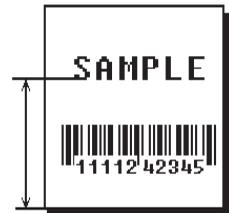
- F       Fixed length
- V       Variable length

T5. row                For monospaced fonts, distance from bottom of print area to the pivot point. The pivot point varies depending on how text is justified.



For proportionally spaced fonts, distance from bottom of print area to baseline of characters in field.

- English    0 - 1200
- Metric     0 - 3045
- Dots        0 - 2436



*T6. column*

Distance from the left edge of the print area to the pivot point to find the column location.

English    **0 - 189**  
Metric     **0 - 479**  
Dots       **0 - 383**



*T7. gap*

Number of dots between characters 203 dpi (or 300 dpi for 9855/9860 printers). Range: **0 to 99**.

**Note:** For monospaced fonts, the additional spacing is added to the existing inter-character gap. This is also true for proportionally spaced fonts, but remember that the inter-character gap varies with character combinations.

Any number other than **0** or the default number affects your field width. Default spacing:

Standard	<b>3 dots</b>
Reduced	<b>1 dot</b>
Bold	<b>3 dots</b>
OCRA-like	<b>3 dots</b>
CG Triumvirate	
Typeface Bold	<b>varies with each letter</b>
CG Triumvirate Typeface	<b>varies with each letter</b>

*T8. font*

Style of font. Options:

<b>1</b>	Standard	<b>6</b>	HR2
<b>2</b>	Reduced	<b>10</b>	CG Triumvirate Typeface Bold
<b>3</b>	Bold	<b>11</b>	CG Triumvirate Typeface
<b>4</b>	OCRA-like	<b>50</b>	EFF Swiss Bold (scalable)
<b>5</b>	HR1		

Or a valid downloaded font selector number.

Fonts **5** and **6** are only for numeric data.

The CG Triumvirate typefaces support only the ANSI and DOS Code Page 437 and 850 Symbol Sets. The scalable font does not support Code Page 1256 (Arabic). See Appendix C for more information.

*T9. hgt mag*

Height magnifier, **1 to 7** times (**4 to 255** points for the scalable font - font 50 or downloaded TrueType fonts). Use a magnifier of **1** with proportionally spaced fonts, because characters lose smoothness at higher magnifications. See Appendix B, "Fonts," for more information about fonts.

T10. *wid mag*

Width magnifier, 1 to 7 times (4 to 255 points for the scalable font - font 50 or downloaded TrueType fonts). Proportionally spaced fonts do not have a set width. To estimate the size of your field, use the letter "W" for the widest field or an "L" for an average width field. Find your selected font and the desired width in Appendix B, "Fonts."

**Note:** To use large point sizes (greater than 60 point), you must reconfigure memory and increase the size of the scalable (vector) fonts buffer.

T11. *color*

There are two types of field color overlay attributes:

Transparent The overlay field (text or constant text) does not block out (or "erase") existing fields.

Opaque The overlay field blocks out (or "erases") existing fields.

Options for standard printer fonts:

**B** Opaque, Normal, Black, Normal

**D/R/W** Opaque, Normal, White, Normal

**O** Transparent, Normal, Black, Normal

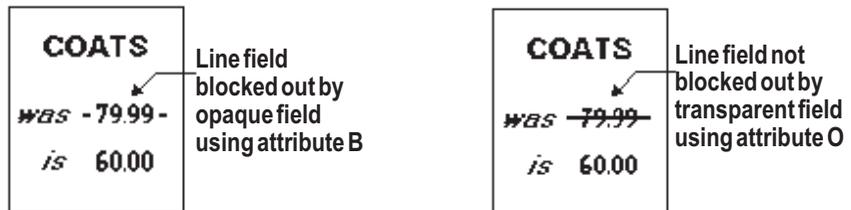
Options for scalable fonts:

**A/N** Opaque, Normal, Black, Bold

**B/O** Opaque, Normal, Black, Normal

**E/S** Opaque, Italics, Black, Bold

**F/T** Opaque, Italics, Black, Normal



**Note:** Solid black print should not exceed 30% on a given square inch of the label, or the printhead life may be decreased.

Field placement in the packet is an important consideration when using field color attributes. If a line field is defined before the overlay (text or constant text) field, the line field is blocked out by the overlay field, depending on the overlay field's color attribute. If a line field is defined after the overlay field, the line field is not blocked out by the overlay field, regardless of the overlay field's color attribute.

T12. alignment

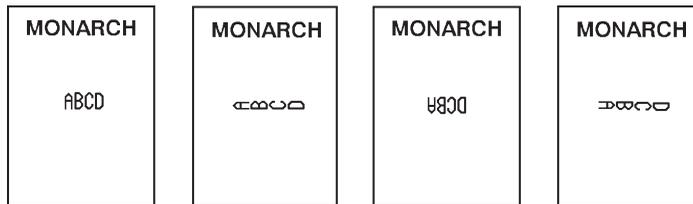
Options:

- L** Align on left side of field.
  - C** Center text within field (monospaced fonts only)
  - R** Align on right side of field (monospaced fonts only)
  - B** Align at midpoint of field
  - E** Align at endpoint of the field
- Use **L**, **B**, or **E** for any font.

T13. char rot

Character rotation. The field or supply does not rotate, only the characters do. Options:

- 0** Top of character points to top of field
- 1** Top of character points to left of field
- 2** Top of character points to bottom of field
- 3** Top of character points to right of field

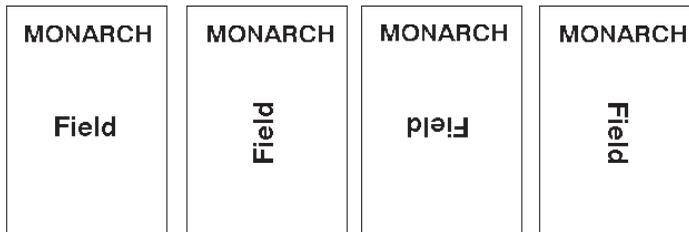


**Note:** Font 50 and downloaded TrueType fonts do not support character rotation.

T14. field rot

Field rotation. Field rotation rotates the whole field, not just the characters. Rotation is affected by the pivot point, which varies depending on how text is justified. Lower left corner of field is the pivot point. Options:

- 0** Top of field points to top of supply
- 1** Top of field points to left of supply
- 2** Top of field points to bottom of supply
- 3** Top of field points to right of supply





## Defining Bar Code Fields

---

Each bar code field requires a separate definition.

**Syntax**            `B, field#, # of char, fix/var, row, column,  
font, density, height, text, alignment, field rot |`

**B1. B**                Bar Code Field.

**B2. field#**           Unique number from **1** to **999** to identify this field.

**B3. # of char**        Maximum number of characters. If the bar code uses a check digit, allow an extra character for the check digit. The actual maximum number of characters is limited by the size of the label and bar code density. Range: **0** to **2710**.

For Quick Response bar codes, this number includes header information. The maximum depends on the type of characters entered for the batch data and differs for the two models of the bar code.

<b>Data Type</b>	<b>Model 1</b>	<b>Model 2</b>
Numeric Data	1167	2710
Alphanumeric data	707	2710
8-byte data	486	2710
Kanji data	299	1817

**Note:** The maximum number of characters depends on the selected level of error correction. As you increase the error correction level, the maximum number of characters decreases.

*B4. fix/var* Fixed (F) or variable (V) length field.

Bar Code	Number of Characters	Fixed or Variable
UPCA	12	F
UPCA+2	14	F
UPCA+5	17	F
UPCA+Price CD	12	F
UPCE	7	F
UPCE+2	9	F
UPCE+5	12	F
EAN8	8	F
EAN8+2	10	F
EAN8+5	13	F
EAN13	13	F
EAN13+2	15	F
EAN13+5	18	F
EAN13+Price CD	13	F
POSTNET	9 or 11	F
Interleaved 2 of 5 or Interleaved 1 2 of 5 with Barrier Bar	0 - 2710	F or V
Code 39 (w/ or w/o CD) or MOD43	0 - 2710	F or V
Codabar (NW7)	0 - 2710	F or V
Code 128	0 - 2710	F or V
Code 16K	0 - 2710	V
Code 93	0 - 2710	V
MSI	0 - 14	F or V
PDF 417	0 - 2710	F or V
Maxicode*	0 to 93 (alphanumeric) 0 to 128 (numeric)	F or V
Data Matrix*	0 to 2335 alphanumeric 0 to 2710 (numeric)	V
Quick Response*	1167 - 2710 (numeric) 707 - 2710 (alphanumeric)	V

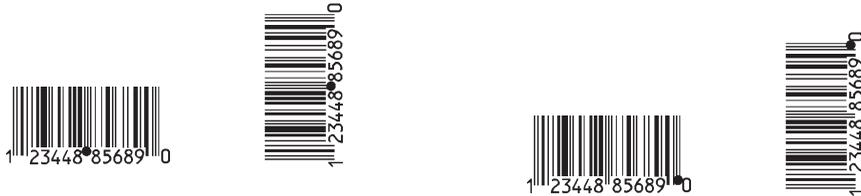
\* For more information about MaxiCode, Data Matrix, and Quick Response, see Appendix A, "Samples."

*B5. row*

Distance from the bottom of the print area to the pivot point of the field.  
The pivot point varies, depending on how the field is justified. Pivot points:



**Left/Center/Right-Justified Fields**

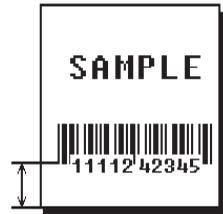


**Balanced Fields**

**End-Justified Fields**

Remember to include text or numbers that may appear with the bar code for the row measurement.

- English    **0 - 1200**
- Metric    **0 - 3045**
- Dots      **0 - 2436**



*B6. column*

Distance from the lower left edge of the print area to the pivot point.

- English    **0 - 189**
- Metric    **0 - 479**
- Dots      **0 - 383**

Allow a minimum of **1/10** inch between the scan edge of bar code and label edges or other data.



*B7. font*

Bar code.	Options:
<b>1</b>	UPCA
<b>2</b>	UPCE
<b>3</b>	Interleaved 2 of 5
<b>4</b>	Code 39 (no check digit)
<b>5</b>	Codabar
<b>6</b>	EAN8
<b>7</b>	EAN13
<b>8</b>	Code 128
<b>9</b>	MSI
<b>10</b>	UPCA +2
<b>11</b>	UPCA +5
<b>12</b>	UPCE +2
<b>13</b>	UPCE +5
<b>14</b>	EAN8 +2
<b>15</b>	EAN8 +5
<b>16</b>	EAN13 +2
<b>17</b>	EAN13 +5
<b>21</b>	LAC
<b>22</b>	POSTNET
<b>23</b>	Code 93
<b>31</b>	Code 16K
<b>32</b>	PDF417
<b>33</b>	MaxiCode
<b>35</b>	Data Matrix (ECC-200)
<b>36</b>	Quick Response
<b>40</b>	Code 39 (MOD 43 check digit)
<b>41</b>	UPCA & Price CD
<b>44</b>	EAN13 & Price CD
<b>50</b>	Interleaved 2 of 5 with Barrier Bar

*B8. density*

Bar code density. Use **0** for Quick Response bar codes. Use the following table for the other bar codes.

**Note:** If the field contains an 11-digit UPC bar code, the printer automatically zero-suppresses it into a 6-digit UPCE bar code.

## Bar code Densities

Bar Code Type	Density Selector	Density (% or cpi)	Narrow Element (dots/mils)	Narrow to Wide Ratio	Data Length	Appearance Codes Available	Char Set																																																																																																																																																																																					
UPCA +2/+5 Price CD	2	76%	2/9.9	N/A	11 or 12 14/17	1, 5, 6, 7 or 8	0 to 9																																																																																																																																																																																					
	4	114%	3/14.8					UPCE +2/+5	2	76%	2/9.9	N/A	6 or 7 9/12	1, 5, 6, 7 or 8	0 to 9	4	114%	3/14.8	EAN8 +2/+5	2	76%	2/9.9	N/A	7 or 8 10/13	1, 5, 6, 7 or 8	0 to 9	4	114%	3/14.8	EAN13+2/+5 Price CD	2	76%	2/9.9	N/A	12 or 13 15/18	1, 5, 6, 7 or 8	0 to 9	4	114%	3/14.8	Interleaved 2 of 5 or I2of5 with Barrier Bar	1	1.1	21/103.4	1:3.0	0 to 2710	8	0 to 9	2	2.1	12/59.1	1:2.5	3	3.2	7/34.5	1:3.0	4	4.2	6/29.6	1:2.5	5	5.6	4/19.7	1:3.0	6	6.3	4/19.7	1:2.5	7	7.5	3/14.8	1:3.0	8	8.8	3/14.8	1:2.3	9	9.6	3/14.8	1:2.0	10	11.2	2/9.9	1:3.0	11	11.0	2/9.9	1:3.0	12	12.7	2/9.9	1:2.5	13	14.5	2/9.9	1:2.0	(Code 39 or MOD43 (Extended Code 39)	1	1.4	10/49.3	1:2.5	0 to 2710	8	SPACE \$%*+-./ 0 to 9 A to Z	2	1.7	8/39.4	1:2.5	3	3.5	4/19.7	1:2.5	4	4.2	3/14.8	1:3.0	6	6.3	2/9.9	1:3.0	7	7.0	2/9.9	1:2.5	11	3.9	4/19.7	1:2.0	12	12.7	1/4.9	1:3.0	20	3.0	5/24.6	1:2.2	Codabar (NW7)	2	2.1	8/39.4	1:3.0	0 to 26	8	\$+-./ 0 to 9 a to d	3	3.0	6/29.6	1:2.5	4	4.6	4/19.7	1:2.5	5	5.1	4/19.7	1:2.0	7	8.4	2/9.9	1:3.0	8	9.2	2/9.9	1:2.5	9	10.1	2/9.9	1:2.0	Code 128 or Code 16K	4	3.5/7.0	5/24.6	N/A	0 to 2710	8	00H to 7FH	6	4.4/8.7	4/19.7	8	5.8/11.7	3/14.8	20	8.7/11.5	2/9.9			
UPCE +2/+5	2	76%	2/9.9	N/A	6 or 7 9/12	1, 5, 6, 7 or 8	0 to 9																																																																																																																																																																																					
	4	114%	3/14.8					EAN8 +2/+5	2	76%	2/9.9	N/A	7 or 8 10/13	1, 5, 6, 7 or 8	0 to 9	4	114%	3/14.8	EAN13+2/+5 Price CD	2	76%	2/9.9	N/A	12 or 13 15/18	1, 5, 6, 7 or 8	0 to 9	4	114%	3/14.8	Interleaved 2 of 5 or I2of5 with Barrier Bar	1	1.1	21/103.4	1:3.0	0 to 2710	8	0 to 9	2	2.1	12/59.1		1:2.5	3	3.2	7/34.5				1:3.0	4	4.2	6/29.6	1:2.5	5	5.6	4/19.7	1:3.0	6	6.3	4/19.7	1:2.5	7	7.5	3/14.8	1:3.0	8	8.8	3/14.8	1:2.3	9	9.6	3/14.8	1:2.0	10	11.2	2/9.9	1:3.0	11	11.0	2/9.9	1:3.0	12	12.7	2/9.9	1:2.5	13	14.5	2/9.9	1:2.0	(Code 39 or MOD43 (Extended Code 39)	1	1.4	10/49.3	1:2.5	0 to 2710	8		SPACE \$%*+-./ 0 to 9 A to Z	2	1.7	8/39.4				1:2.5	3	3.5	4/19.7	1:2.5	4	4.2	3/14.8	1:3.0	6	6.3	2/9.9	1:3.0	7	7.0	2/9.9	1:2.5	11	3.9	4/19.7	1:2.0	12	12.7	1/4.9	1:3.0	20	3.0	5/24.6	1:2.2	Codabar (NW7)	2	2.1		8/39.4	1:3.0	0 to 26	8				\$+-./ 0 to 9 a to d	3	3.0	6/29.6	1:2.5	4	4.6	4/19.7	1:2.5	5	5.1	4/19.7	1:2.0	7	8.4	2/9.9	1:3.0	8	9.2	2/9.9	1:2.5	9	10.1	2/9.9		1:2.0	Code 128 or Code 16K	4					3.5/7.0	5/24.6	N/A	0 to 2710	8	00H to 7FH	6	4.4/8.7	4/19.7	8	5.8/11.7	3/14.8
EAN8 +2/+5	2	76%	2/9.9	N/A	7 or 8 10/13	1, 5, 6, 7 or 8	0 to 9																																																																																																																																																																																					
	4	114%	3/14.8					EAN13+2/+5 Price CD	2	76%	2/9.9	N/A	12 or 13 15/18	1, 5, 6, 7 or 8	0 to 9	4	114%	3/14.8	Interleaved 2 of 5 or I2of5 with Barrier Bar	1	1.1	21/103.4	1:3.0	0 to 2710	8	0 to 9	2	2.1	12/59.1		1:2.5	3	3.2	7/34.5				1:3.0	4	4.2		6/29.6	1:2.5	5	5.6				4/19.7	1:3.0	6	6.3	4/19.7	1:2.5	7	7.5	3/14.8	1:3.0	8	8.8	3/14.8	1:2.3	9	9.6	3/14.8	1:2.0	10	11.2	2/9.9	1:3.0	11	11.0	2/9.9	1:3.0	12	12.7	2/9.9	1:2.5	13	14.5	2/9.9	1:2.0	(Code 39 or MOD43 (Extended Code 39)	1	1.4	10/49.3	1:2.5	0 to 2710	8		SPACE \$%*+-./ 0 to 9 A to Z	2	1.7	8/39.4					1:2.5	3	3.5				4/19.7	1:2.5	4	4.2	3/14.8	1:3.0	6	6.3	2/9.9	1:3.0	7	7.0	2/9.9	1:2.5	11	3.9	4/19.7	1:2.0	12	12.7	1/4.9	1:3.0	20	3.0	5/24.6	1:2.2	Codabar (NW7)	2	2.1		8/39.4	1:3.0		0 to 26	8							\$+-./ 0 to 9 a to d	3	3.0	6/29.6	1:2.5	4	4.6	4/19.7	1:2.5	5	5.1	4/19.7	1:2.0	7	8.4	2/9.9	1:3.0	8	9.2	2/9.9	1:2.5	9	10.1	2/9.9	1:2.0		Code 128 or Code 16K	4	3.5/7.0	5/24.6	N/A	0 to 2710	8					00H to 7FH	6	4.4/8.7	4/19.7	8	5.8/11.7
EAN13+2/+5 Price CD	2	76%	2/9.9	N/A	12 or 13 15/18	1, 5, 6, 7 or 8	0 to 9																																																																																																																																																																																					
	4	114%	3/14.8					Interleaved 2 of 5 or I2of5 with Barrier Bar	1	1.1	21/103.4	1:3.0	0 to 2710	8	0 to 9	2	2.1	12/59.1		1:2.5	3	3.2	7/34.5				1:3.0	4	4.2		6/29.6	1:2.5	5	5.6				4/19.7	1:3.0	6		6.3	4/19.7	1:2.5	7				7.5	3/14.8	1:3.0	8	8.8	3/14.8	1:2.3	9	9.6	3/14.8	1:2.0	10	11.2	2/9.9	1:3.0	11	11.0	2/9.9	1:3.0	12	12.7	2/9.9	1:2.5	13	14.5	2/9.9	1:2.0	(Code 39 or MOD43 (Extended Code 39)	1	1.4	10/49.3	1:2.5	0 to 2710	8		SPACE \$%*+-./ 0 to 9 A to Z	2	1.7	8/39.4					1:2.5	3	3.5					4/19.7	1:2.5	4				4.2	3/14.8	1:3.0	6	6.3	2/9.9	1:3.0	7	7.0	2/9.9	1:2.5	11	3.9	4/19.7	1:2.0	12	12.7	1/4.9	1:3.0	20	3.0	5/24.6	1:2.2	Codabar (NW7)	2	2.1		8/39.4	1:3.0		0 to 26	8											\$+-./ 0 to 9 a to d	3	3.0	6/29.6	1:2.5	4	4.6	4/19.7	1:2.5	5	5.1	4/19.7	1:2.0	7	8.4	2/9.9	1:3.0	8	9.2	2/9.9	1:2.5	9	10.1	2/9.9	1:2.0		Code 128 or Code 16K	4	3.5/7.0				5/24.6	N/A	0 to 2710	8		00H to 7FH	6	4.4/8.7	4/19.7	8
Interleaved 2 of 5 or I2of5 with Barrier Bar	1	1.1	21/103.4	1:3.0	0 to 2710	8	0 to 9																																																																																																																																																																																					
	2	2.1	12/59.1	1:2.5																																																																																																																																																																																								
	3	3.2	7/34.5	1:3.0																																																																																																																																																																																								
	4	4.2	6/29.6	1:2.5																																																																																																																																																																																								
	5	5.6	4/19.7	1:3.0																																																																																																																																																																																								
	6	6.3	4/19.7	1:2.5																																																																																																																																																																																								
	7	7.5	3/14.8	1:3.0																																																																																																																																																																																								
	8	8.8	3/14.8	1:2.3																																																																																																																																																																																								
	9	9.6	3/14.8	1:2.0																																																																																																																																																																																								
	10	11.2	2/9.9	1:3.0																																																																																																																																																																																								
	11	11.0	2/9.9	1:3.0																																																																																																																																																																																								
	12	12.7	2/9.9	1:2.5																																																																																																																																																																																								
	13	14.5	2/9.9	1:2.0																																																																																																																																																																																								
(Code 39 or MOD43 (Extended Code 39)	1	1.4	10/49.3	1:2.5	0 to 2710	8	SPACE \$%*+-./ 0 to 9 A to Z																																																																																																																																																																																					
	2	1.7	8/39.4	1:2.5																																																																																																																																																																																								
	3	3.5	4/19.7	1:2.5																																																																																																																																																																																								
	4	4.2	3/14.8	1:3.0																																																																																																																																																																																								
	6	6.3	2/9.9	1:3.0																																																																																																																																																																																								
	7	7.0	2/9.9	1:2.5																																																																																																																																																																																								
	11	3.9	4/19.7	1:2.0																																																																																																																																																																																								
	12	12.7	1/4.9	1:3.0																																																																																																																																																																																								
	20	3.0	5/24.6	1:2.2																																																																																																																																																																																								
	Codabar (NW7)	2	2.1	8/39.4				1:3.0	0 to 26	8	\$+-./ 0 to 9 a to d																																																																																																																																																																																	
3		3.0	6/29.6	1:2.5																																																																																																																																																																																								
4		4.6	4/19.7	1:2.5																																																																																																																																																																																								
5		5.1	4/19.7	1:2.0																																																																																																																																																																																								
7		8.4	2/9.9	1:3.0																																																																																																																																																																																								
8		9.2	2/9.9	1:2.5																																																																																																																																																																																								
9		10.1	2/9.9	1:2.0																																																																																																																																																																																								
Code 128 or Code 16K		4	3.5/7.0	5/24.6	N/A	0 to 2710	8	00H to 7FH																																																																																																																																																																																				
		6	4.4/8.7	4/19.7																																																																																																																																																																																								
	8	5.8/11.7	3/14.8																																																																																																																																																																																									
	20	8.7/11.5	2/9.9																																																																																																																																																																																									

**Note:** The start (\*) and stop (+) characters are automatically added for Code 39. Code 39, density 12, produces a one-dot narrow bar. This density is intended for special U.S.P.S. ACT-tag applications only.

## 3-12 Defining Fields

Bar Code Type	Density Selector	Density (% or cpi)	Narrow Element (dots/mils)	Narrow to Wide Ratio	Data Length	Appearance Codes Available	Char Set
CODE 93	3	3.7	6/29.6	N/A	0 to 2710	8	00H to 7FH
	4	4.5	5/24.6				
	5	5.6	4/19.7				
	7	7.5	3/14.8				
	10	11.2	2/9.9				
MSI	4	4.2	4/19.7	1:2.0	0 to 14	8	0 to 9
	5	5.6	3/14.8	1:2.0			
	7	7.2	2/9.9	1:2.5			
POSTNET	0 (fixed at 4.3 cpi)	24/118.2	10/49.3	4/19.7 (5 dot gap)	0,5,6,9 or 11	8	0 to 9
MaxiCode	7	N/A	N/A	N/A	99	8	00H to FFH

Bar Code Type	Density Selector	Element Width (dot/mils)	Row Height (dots/mils)	Aspect Ratio	Data Length	Appearance Codes Available	Char Set
PDF417	1	2/9.8	2/9.8	1:1	0 to 2709	8	00H to FFH
	2	2/9.8	4/19.7	1:2			
	3	2/9.8	6/29.6	1:3			
	4	3/14.8	3/14.8	1:1			
	5	3/14.8	6/29.6	1:2			
	6	3/14.8	9/44.3	1:3			
	7	4/19.7	4/19.7	1:1			
	8	4/19.7	8/39.4	1:2			
	9	4/19.7	12/59.1	1:3			

Bar Code Type	Density Selector	Data Length
Quick Response (QR Code) Models 1 and 2	<b>0</b>	Model 1: 0 - 1167 Numeric; 0 - 707 Alphanumeric; 0 - 486 (8-bit); 0 - 299 (Kanji) Model 2: 0 - 2710 Numeric, Alphanumeric and 8-bit; 0 - 1817 Kanji

**Note:** Values in bold indicate the default.

Bar Code	Size Row x Col.	Density Selector	Max. Data Length Num. X Alphanum.	App Code	Char Set
Data Matrix Square symbols	10 x 10	1	6 x 3	8	00H to FFH
	12 x 12	2	10 x 6		
	14 x 14	3	16 x 10		
	16 x 16	4	24 x 16		
	18 x 18	5	36 x 25		
	20 x 20	6	44 x 31		
	22 x 22	7	60 x 43		
	24 x 24	8	72 x 52		
	26 x 26	9	88 x 64		
	32 x 32	10	124 x 91		
	36 x 36	11	172 x 127		
	40 x 40	12	228 x 169		
	44 x 44	13	288 x 214		
	48 x 48	14	348 x 259		
	52 x 52	15	408 x 304		
	64 x 64	16	560 x 418		
	72 x 72	17	736 x 550		
	80 x 80	18	912 x 682		
	88 x 88	19	1152 x 862		
	96 x 96	20	1392 x 1042		
	104 x 104	21	1632 x 1222		
	120 x 120	22	2100 x 1573		
	132 x 132	23	2608 x 1954		
	144 x 144	24	2710 x 2335		

0 default (bar code size automatically determined by data)

Bar Code	Size Row x Col.	Density Selector	Max. Data Length Num. X Alphanum.	App Code	Char Set
Data Matrix Rectangular symbols	8 x 18	25	10 x 6	8	00H to FFH
	8 x 32	26	20 x 13		
	12 x 26	27	32 x 22		
	12 x 36	28	44 x 31		
	16 x 36	29	64 x 46		
	16 x 48	30	98 x 72		

0 default (bar code size automatically determined by data)

**Note:** The printers support printing a Data Matrix symbol with an X-dimension of 13 mils or greater (3 dots @203 dpi). If you use a denser bar code, make sure the bar code scans in your particular application. Our “premium” supplies and increasing the print contrast are recommended for denser bar codes. Depending on your application, additional densities are available.

*B9. height*

Bar code height, in 1/100 inches, 1/10 mm, or dots. Minimum values:

English	<b>20</b>
Metric	<b>51</b>
Dots	<b>41</b>

POSTNET, PDF417, and MaxiCode bar codes have a fixed height.

Always use **0** for these bar codes.

Small Data Matrix and QR Codes may not be scannable. The Data Matrix and QR Code's height depends on the number entered for this parameter. For example, if you select 80, the symbol could be smaller than 0.80," but it will not be greater than the amount specified in this parameter. The symbol arranges the data according to rows and columns within the specified height.

For Quick Response bar codes, the value you enter is the symbol's maximum height. Small bar codes may not be scannable.

*B10. text*

Appearance of text with bar code. For UPC and EAN only use **0** to **7**. For all others, use **8**, except where noted. Options:

<b>0</b>	Default MaxiCode Mode 0 (obsolete) QR Code Model 2
<b>1</b>	No check digit or number system QR Code Model 1
<b>2</b>	MaxiCode Mode 2 (Numeric Postal Code) QR Code Model 2
<b>3</b>	MaxiCode Mode 3 (Alphanumeric Postal Code)
<b>5</b>	Number system at bottom, no check digit
<b>6</b>	Check digit at bottom, no number system
<b>7</b>	Check digit and number system at bottom
<b>8</b>	No text, bar code only MaxiCode (autodetect modes 0, 2, or 3) Data Matrix

*B11. alignment*

Choose **L**, **R**, **C**, **B** or **E** to align the bar code data correctly in the field. **B** centers variable width bar codes, which may not allow pad-character centering (Code 128, Code 39, etc.) **E** right justifies variable width bar codes. MaxiCode, Data Matrix, and QR Code must use **L**.

*B12. field rot*

Field rotation. Field rotation rotates the whole field, not just the characters. Rotation is affected by the pivot point, which varies depending on how text is justified. Lower left corner of field is the pivot point. Options:

<b>0</b>	Top of field points to top of supply (Use for Maxicode)
<b>1</b>	Top of field points to left of supply
<b>2</b>	Top of field points to bottom of supply
<b>3</b>	Top of field points to right of supply

**Note:** Serial bar codes printed at speeds greater than 2.0 IPS may not scan properly.

### Example

B, 3, 12, V, 50, 40, 1, 2, 80, 7, L, 0 !

Defines a bar code field (field #3) with 12 characters of variable length starting at row 150, column 40. A UPCA bar code with a density of 2 and a height of 80 is used. The check digit and number system are shown at the bottom. The bar code is left aligned without any field rotation.

## Defining Constant Text Fields

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A constant text field is a set of fixed characters that prints on all labels. Define each constant text field separately. This field is not assigned a field number, but is counted as a field (keep this in mind, as the printer allows a maximum of **200** fields per format). The characters in this field cannot be changed by batch data. Field options do not apply to constant text fields. Mark the pivot point of your field. This will vary, depending on how your field is justified.

### Syntax

C, row, column, gap, font, hgt mag,  
wid mag, color, alignment, char rot,  
field rot, "fixed char", sym set !

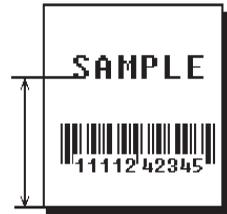
#### C1. C

Constant Text Field.

#### C2. row

For monospaced fonts, distance from bottom of print area to the pivot point. For proportionally spaced fonts, distance from bottom of print area to baseline of characters in the field.

English    **0 - 1200**  
Metric     **0 - 3045**  
Dots       **0 - 2436**



#### C3. column

Distance from the lower left edge of the print area to the pivot point.

English    **0 - 189**  
Metric     **0 - 479**  
Dots       **0 - 383**



*C4. gap* Number of dots between characters (203 dots per inch). Range: **0** to **99**.

Any number other than **0** or the default number affects your field width.  
Default spacing:

Standard	<b>3 dots</b>
Reduced	<b>1 dot</b>
Bold	<b>3 dots</b>
OCRA-like	<b>3 dots</b>
CG Triumvirate	
Typeface Bold	<b>varies with each letter</b>
CG Triumvirate Typeface	<b>varies with each letter</b>
EFF Swiss Bold	<b>varies with each letter</b>

*C5. font* Style of font. Options:

<b>1</b>	Standard	<b>6</b>	HR2
<b>2</b>	Reduced	<b>10</b>	CG Triumvirate Typeface Bold
<b>3</b>	Bold	<b>11</b>	CG Triumvirate Typeface
<b>4</b>	OCRA-like	<b>50</b>	EFF Swiss Bold (scalable)
<b>5</b>	HR1		

Or a valid downloaded font selector number.

Fonts **5** and **6** are for numeric data only.

The CG Triumvirate typefaces support only the ANSI and DOS Code Page 437 and 850 Symbol Sets. The scalable font does not support Code Page 1256 (Arabic). See Appendix C, "Symbol Sets/Code Pages" for more information.

*C6. hgt mag* Height magnifier, **1** to **7** times (**4** to **255** points for the scalable font - font 50 or downloaded TrueType fonts). Use a magnifier of **1** with proportionally spaced fonts, because characters lose smoothness at higher magnifications. See Appendix B, "Fonts," for more information about fonts.

*C7. wid mag* Width magnifier, **1** to **7** times (**4** to **255** points for the scalable font - font 50 or downloaded TrueType fonts). Proportionally spaced fonts do not have a set width. To estimate the size of your field, use the letter "W" for the widest field or an "L" for an average width field. Find your selected font and the desired width in Appendix B, "Fonts."

*C8. color* There are two types of field color overlay attributes:

Transparent The overlay field (text or constant text) does not block out (or "erase") existing fields.

Opaque The overlay field blocks out (or "erases") existing fields.

Options for standard printer fonts:

<b>B</b>	Opaque, Normal, Black, Normal
<b>D/R/W</b>	Opaque, Normal, White, Normal
<b>O</b>	Transparent, Normal, Black, Normal

Options for scalable fonts:

<b>A/N</b>	Opaque, Normal, Black, Bold
<b>B/O</b>	Opaque, Normal, Black, Normal
<b>E/S</b>	Opaque, Italics, Black, Bold
<b>F/T</b>	Opaque, Italics, Black, Normal

**Note:** Solid black print should not exceed 30% on a given square inch of the label, or the printhead life may be decreased.

Field placement in the packet is an important consideration when using field color attributes. If a line field is defined before the overlay (text or constant text) field, the line field is blocked out by the overlay field, depending on the overlay field's color attribute. If a line field is defined after the overlay field, the line field is not blocked out by the overlay field, regardless of the overlay field's color attribute.

*C9. alignment*

Alignment of constant text in the field. Options:

<b>L</b>	Align on left side of field.
<b>C</b>	Center text within field (for monospaced fonts only)
<b>R</b>	Align on right side of field (for monospaced fonts only)
<b>B</b>	Align at midpoint of field
<b>E</b>	Align at end of field.

Use **L**, **B**, or **E** for any font.

*C10. char rot*

Character rotation. The field or supply does not rotate, only the characters do. Options:

<b>0</b>	Top of character points to top of field
<b>1</b>	Top of character points to left of field
<b>2</b>	Top of character points to bottom of field
<b>3</b>	Top of character points to right of field

**Note:** Font 50 and downloaded TrueType fonts do not support character rotation.

*C11. field rot*

Field rotation. Field rotation rotates the whole field, not just the characters. Rotation is affected by the pivot point, which varies depending on how text is justified. Lower left corner of field is the pivot point. Options:

<b>0</b>	Top of overlay points to top of supply
<b>1</b>	Top of overlay points to left of supply
<b>2</b>	Top of overlay points to bottom of supply
<b>3</b>	Top of overlay points to right of supply

*C12. "fixed char"* Fixed characters to appear in the field. Maximum **2710** characters. Enclose in quotation marks.

*C13. sym set*

Symbol set. Use **0** for the Internal Symbol Set.

For scalable fonts, use:

<b>1</b>	ANSI Symbol Set
<b>102</b>	Unicode (user input) for particular mapping
<b>437</b>	DOS Code Page 437 (Domestic)
<b>850</b>	DOS Code Page 850 (International)
<b>852</b>	DOS Code Page 852 (Latin 2)
<b>855</b>	DOS Code Page 855 (Russian)
<b>857</b>	DOS Code Page 857 (IBM Turkish)
<b>860</b>	DOS Code Page 860 (MS-DOS Portuguese)
<b>1250</b>	Code Page 1250 (Latin 2)
<b>1251</b>	Code Page 1251 (Cyrillic)
<b>1252</b>	Code Page 1252 (Latin 1)
<b>1253</b>	Code Page 1253 (Greek)
<b>1254</b>	Code Page 1254 (Turkish)
<b>1255</b>	Code Page 1255 (Hebrew)
<b>1256</b>	Code Page 1256 (Arabic)
<b>1257</b>	Code Page 1257 (Baltic)
<b>1258</b>	Code Page 1258 (Vietnam)

**Note:** The CG Triumvirate™ typefaces support only the ANSI and DOS Code Page 437 and 850 Symbol Sets. The scalable font (font 50) does not support Code Page 1256 (Arabic). Code pages 852-860 and 1250-1258 are for downloaded TrueType fonts or the scalable font. Code page 102 requires a downloaded International TrueType font. TrueType fonts are designed to be regionally specific; therefore, all code pages may not be supported in a given font. See Appendix C, “Symbol Sets/ Code Pages” for more information.

*Example*

```
C,30,10,0,1,1,1,B,L,0,0,"MADE IN USA",0 !
```

Defines a constant text field starting at row 30, column 10. It does not have any additional inter-character gap. The Standard font is used without any additional magnification. The printing is black on white and left justified. No field or character rotation is used. “MADE IN USA” is printed in this field. The internal symbol set is used.

## Defining Line Fields

---

Use lines to form borders and mark out original prices. Define each line separately. This field is not assigned a field number, but is counted as a field (keep this in mind, as the printer allows a maximum of **200** fields per format). You can define any line length and a thickness up to 99 dots, as long as the solid black print does not exceed 30 percent of any given square inch of the label.

### Line Types

You can create horizontal and vertical lines. There are two ways to define lines.

**Segments**                    You choose the starting point and ending point.

**Vectors**                     You choose the starting point, the angle, and the length of the line.

*Syntax*                     `L, type, row, column, angle/end row, length/  
end col, thickness, "pattern" |`

*L1. L*                        Line Field.

*L2. type*                    Type of line. Only vertical and horizontal lines are supported. Options:

**S** Segment. You choose the starting point and ending point.

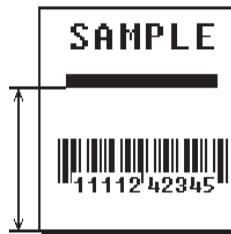
**V** Vector. You choose the starting point, angle, and length.

*L3. row*                    Distance from bottom of print area to the starting point.

English    **0 - 1200**

Metric     **0 - 3045**

Dots        **0 - 2436**



*L4. column*                Distance from left edge of the print area to line origin.

English    **0 - 189**

Metric     **0 - 479**

Dots        **0 383**



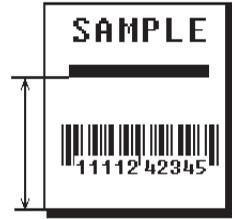
L5. angle  
/end row

If Using Segments:

Row location of ending point. Measure from bottom of print area. Ranges same as row above. On horizontal lines, this value must match item L3.

If Using Vectors:

Angle of line. Options: **0, 90, 180, or 270.**



L6. length/  
end col

If Using Segments:

Column location of end point. Measure from left edge of print area. Ranges same as column above. On vertical lines, this value must match parameter L4.

If Using Vectors:

Length of the line in selected units.

Ranges for horizontal lines:

English **0 - 189**

Metric **0 - 479**

Dots **0 - 383**

Ranges for vertical lines:

English **0 - 1200**

Metric **0 - 3045**

Dots **0 - 2436**



L7. *thickness*

Using the chart below for reference, write the line thickness (1 to 99) in box L7. Line thickness fills upward on horizontal lines, or to the right on vertical lines. Measured in dots.

Dots	Thickness
1	
10	
24	
48	
96	

L8. *"pattern"*

Line pattern. Enter "".

*Example*

L, S, 110, 30, 110, 150, 10, "" ↓

Defines a horizontal line field as a segment starting at row 110, column 30 and ending at row 110, column 150. The line thickness is 10 dots.

## Defining Box Fields

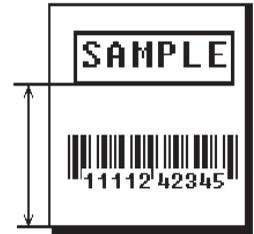
Use boxes to form borders or highlight items of interest. Define each box field separately. This field is not assigned a field number, but is counted as a field (keep this in mind, as the printer allows a maximum of **200** fields per format). You can define any line length and a thickness up to 99 dots, as long as the solid black print does not exceed 30 percent of any given square inch of the label.

**Syntax**                    `Q, row, column, end row, end col, thickness, "pattern" |`

**Q1. Q**                    Box (**Q**uadrilateral) Field.

**Q2. row**                Distance from bottom of print area to lower left corner of box.

English     **0 - 1200**  
Metric:     **0 - 3045**  
Dots:       **0 - 2436**

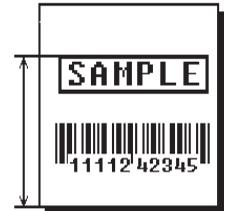


**Q3. column**            Distance from left edge of print area to lower left corner of box.

English     **0 - 189**  
Metric       **0 - 479**  
Dots        **0 - 383**



**Q4. end row**            Distance from bottom of print area to upper right corner of box. Ranges same as *row*.



**Q5. end col**            Distance from left edge of print area to upper right corner of box. Ranges same as *column*.



Q6. *thickness* Using the chart below for reference, write the desired line thickness (1 to 99) in box Q6. Boxes fill inward, so make sure your boxes do not overwrite other fields. Measured in dots.

Dots	Thickness
1	
10	
24	
48	
96	

Q7. *pattern* Line pattern. Enter "".

*Example* Q, 40, 30, 70, 150, 3, "" |

Defines a box field starting at row 40, column 30. It ends at row 70, column 150. It has a thickness of 3 dots.

# DEFINING FIELD OPTIONS



This chapter provides a reference for defining  
field options in formats  
check digit packets.

**Note:** When using multiple options on the printer, options are processed in the order they are received.

## Applying Field Options

---

Field options further define text and bar code fields. The text, constant text, or bar code field must be previously defined *before* you can apply any field option to it. Define options immediately after the field to which they apply.

### Combining Field Options

You can use more than one option with most fields. For example, you can use Option 4 to copy data from another field, and then use Option 30 to pad the field. When you use multiple options for the same field, you must place the options in the order you want to apply them to your format.

### Restrictions

Some options cannot be used together. For example, incrementing (Option 60) and price field (Option 42) options cannot be applied to the same field. Refer to the following sections addressing individual options for specific combinations to avoid.

Option 4 (copy a field) is the only option that can be repeated for a single field.

*Example*                R,1,3,1,3,1,1 |

*Syntax*                R,option#,parameter...parameter |

*R1. R*                    Indicates field option header.

*R2. option#*            Option number:

<b>1</b>	Define fixed characters
<b>2</b>	Data type restrictions
<b>4</b>	Copy data from previous field
<b>30</b>	Pad data to left or right with specified character
<b>31</b>	Generate check digit
<b>42</b>	Format as a price field
<b>50</b>	Define bar code densities
<b>51</b>	Define security and truncation of PDF417 bar codes
<b>52</b>	Define width or length of PDF417 bar codes
<b>60</b>	Define incrementing or decrementing field
<b>61</b>	Reimage fields

*R3. parameter(s)*    Varies per option. See the following option descriptions.

## Option 1 (Fixed Data)

---

Fixed data is information (a company name or store number) you want to print on all labels. You can define fixed characters for an entire field or for part of a field.

*Syntax*                    R,1,"fixed char" |

*R1. R*                    Option Header.

*R2. 1*                    Option 1.

*R3. fixed char*        Characters to insert. Enclose in quotation marks. If you are defining fixed characters for part of a field, place underscores(\_) in non-fixed positions. Any spaces in the phrase are fixed characters. Range: **0** to **2710**.

**Note:**        Underscore characters are stripped out and the data is compressed if no data is supplied by the batch and the field length is variable.

*Example*                    R,1,"\_ \_ \_%\$\_ \_ \_ \_ \_" |

Uses fixed characters (%\$) in positions 4 and 5. The other positions are variable.

*Example*                    R,1,"MONARCH" |

“MONARCH” appears as a fixed field in this example.

To fill in the non-fixed portion of the field, see “Defining Batch Data Fields” in Chapter 6. As an alternative, you can apply Option 4 to copy data into the non-fixed character positions.

## Option 2 (Data Type Restrictions)

---

This option restricts the data type for a particular field. You can use Option 2 only once per field.

If you do batch entry only in the batch packet, you do not need to apply Options 2 and 3. Use these options only for offline batch entry.

**Syntax**                    R, 2, char\_code |

*R1. R*                    Option Header.

*R2. 2*                    Option 2.

*R3. char code*        Character type for the field. Options:

<b>1</b>	Numeric only (0..9)
<b>2</b>	Letters only (A..Z,a..z)
<b>3</b>	Symbols only (printable characters other than letters or numbers)
<b>4</b>	Letters and numbers only
<b>5</b>	Numbers and symbols only
<b>6</b>	Letters and symbols only

Spaces are permitted in all categories. You can also use a combination of any two (letter, numbers, or symbols) character types.

**Note:** A use for this option is a quantity field, where the operator could enter only numeric data.

**Example**                    R, 2, 2 |

Restricts the field data to letters only (A-Z or a-z).



## Merging Fields

You can copy data to merge the contents of fields. Use the copy data option as many times as necessary to copy all the appropriate fields into the merged field.

In the following example, two text and two non-printable fields are shown. Data from these fields is merged to form field 5, and is then printed as a bar code.

Field	Data	Field Type
1	203	Non-printable
2	339	Non-printable
3	8	Text
4	BLUE	Text
5	2033398BLUE	Bar Code

To create this sequence:

1. Define fields 1, 2, 3, and 4.
2. Define field 5 as a bar code. Allow enough characters in the bar code field to hold all the copied characters.
3. Apply Option 4 to field 5 once for every source field.

## Sub-Fields

You can copy a segment of data from one field into a new location, called a sub-field. For example, extract part of the data in a bar code and display it in text form in a sub-field. Then, use the copy data option.

## Option 30 (Pad Data)

---

You can add characters to one side of a field to “pad” the field. Padding allows you to fill in the remaining spaces when the entered data does not fill an entire field. If a variable length field is not completely filled with batch data, this option fills the remaining positions in the field with the character designated by Option 30.

**Syntax**                    R, 30, L/R, "character" |

*R1. R*                    Option Header.

*R2. 30*                    Option **30**.

*R3. L/R*                    Indicates type of padding:  
                              **L**        Pad field on left side  
                              **R**        Pad field on right side

*R4. "character"*        Pad character must be within the **0** to **255** decimal range and enclosed inside quotation marks.

**Note:**    Do not use on fixed length fields.

**Example**                R, 30, L, "X" |

Pads data with an “X” on the left side of the field.

### Sample Use for Padding

If you have a variable length bar code that you want to occupy a fixed amount of space on the supply, use pad characters. If the maximum number of characters in the bar code is 15, but the batch record only has 10 characters, the padding option fills the remainder of the field with pad characters.

## Option 31 (Calculate Check Digit)

---

The printer generates a check digit if you apply Option 31 to the field. You cannot use this option if the field contains a UPC, EAN, or Code 39 (with the MOD43 check digit) bar code.

**Syntax**                R, 31, gen/ver, check digit # |

R1. R                    Option Header.

R2. 31                    Option **31**.

R3. gen/ver              Enter **G** to generate a check digit.

R4. check digit #        Specifies a check digit scheme. Enter a number that identifies a check digit scheme that has been defined. For more information, see "Using Check Digits." Range: **1** to **10**.

**Example**                R, 31, G, 5 |

Generates a check digit using the previously defined check digit scheme 5.

## Option 42 (Price Field)

---

You can apply options that will insert monetary symbols automatically. Do not use this option with Option 31 (define a check digit) or Option 60 (increment or decrement a field). This option is not recommended for bar codes. When determining the maximum number of characters, add the maximum number of digits and the monetary symbols.

**Syntax**                R, 42, appearance code |

R1. R                    Option Header.

R2. 42                    Option **42**.

R3. appearance code    Enter **1** to print price field in standard notation, as defined by country setting.

Use the monetary formatting packet to select monetary notations and symbols by country setting. See "Defining the Monetary Formatting Packet" for more information.

See Appendix C, "Symbol Sets/Code Pages," to make sure the monetary symbol you want to use is printable in the font selected for this field. For monetary symbols other than the dollar sign, use the internal symbol set.

*Example*            R, 42, 1 !

Uses a price field that prints the monetary symbol and notations as defined in the monetary formatting packet.

## **Option 50 (Bar Code Density)**

You can apply this option to bar code fields when you want to create custom densities. When you apply this option, it overrides the density value in the bar code field. When using this option, set the density parameter in your bar code field to the default value. You can only use this option once for each bar code field.

Bar codes produced using Option 50 may not be scannable. Code 39, density 12, produces a one-dot narrow bar. This density is intended for special U.S.P.S. ACT-tag applications only. Synthetic supplies are recommended to produce scannable bar codes.

The additional character gap, narrow space, and wide space parameters are valid **only** with Code 39 and Codabar. If these parameters are specified for any other bar codes, they will be ignored by the printer. Do not use Option 50 with fixed density bar codes.

Option 50 can be used with PDF417 bar codes for specific customer ratios. With PDF417 bar codes, use only the narrow and wide parameters. The narrow parameter defines the individual bar width in dots and the wide parameter is used to define the height of each individual stacked bar code. Option 50 can also be used with Option 52 to further customize the dimensions of a PDF417 bar code. Option 52 allows customization of the number of columns or number of rows for the bar code.

*Syntax*            R, 50, narrow, wide, gap, nar\_space, wide\_space !

*R1. R*            Field Option Header.

*R2. 50*            Option **50**.

*R3. narrow*        Dot width of the narrow element. Range: **1** to **99**.

*R4. wide*            Dot width of the wide element. Range: **1** to **99**.

*R5. gap*            Additional dot space between characters. Enter a value of **1** to **99**.  
(Code 39 and Codabar only.)

- R6. nar\_space* Additional dot width of the narrow bar code space. (Code 39 and Codabar only). Range: **1** to **99**.
- R7. wide\_space* Additional dot width of the wide bar code space. (Code 39 and Codabar only). Range: **1** to **99**.

*Example*            `R, 50, 4, 8, 4, 4, 8 |`

Creates a custom bar code density with a narrow element of 4 dots, a wide element of 8 dots, a gap of 4 dots, 4 additional dot widths for the narrow bar code space, and 8 additional dot widths for the wide bar code space (if this is a Code 39 or Codabar bar code).

## **Option 51 (PDF417 Security/Truncation)**

---

You can define a security level and choose whether or not to truncate a PDF417 bar code. Higher security levels add data to a bar code, improving scan reliability. Some damaged bar codes may still be scannable if the security level is high enough. You can use this option to create standard PDF417 bar codes or use the truncated option to create a narrower bar code. This option can appear only once per PDF417 field, in any order, following the bar code field.

As the security level is increased, so is the size of your PDF417 bar code. For each level increased, the bar code will double in size.

*Syntax*            `R, 51, security, stand/default |`

*R1. R*                Option Header.

*R2. 51*               Indicates Option **51**.

*R3. security*        Security level ranges from **0** to **8** (**0** is the default).

Higher security levels add data to a bar code, improving scan reliability. Some damaged bar codes may still be scannable if the security level is high enough.

*R4. stand/def*        Truncation selector. Valid values:  
                       **S**        (default) a standard PDF417 bar code  
                       **T**        truncated

*Example*            `R, 51, 2, S |`

Defines a security level of 2 for a standard PDF417 bar code.

## Option 52 (PDF417 Width/Length)

---

This option defines the image width or length of a PDF417 bar code. If you define a fixed number of columns (width), the bar code expands in length. If you define a fixed number of rows (length), the bar code expands in width.

Column value does not include start/stop or left/right indicator columns.

If this option does not immediately follow the PDF417 bar code field, the default settings are used. You can only use this option once per PDF417 bar code field.

**Syntax**                    `R, 52, row/column, dimension |`

**R1. R**                    Option Header.

**R2. 52**                    Indicates Option **52**.

**R3. row/column**        Indicates if you are defining the number of rows or columns.  
                              **R**        Row  
                              **C**        Column

If you specify rows, the bar code expands in columns,  
or vice versa.

**R4. dimension**        The number of rows or columns defined for the bar code.  
                              The default is **4**. Valid values:  
                              **3-90** for rows  
                              **1-30** for columns

**Example**                    `R, 52, C, 10 |`

Defines the column width of 10, which expands the PDF417 bar code length by 10.

## Option 60 (Incrementing/Decrementing Fields)

---

You may have an application, such as serial numbers, in which you need a numeric field to increment (increase in value) or decrement (decrease in value) on successive tickets within a single batch. Incrementing or decrementing can be applied to **numeric** data only. If you have a field that includes letters and digits, apply incrementing or decrementing to only the portion of the field that contains digits. Do not use with Option 42 (price field).

**Syntax**                    R,60,I/D,amount,l pos,r pos |

R1. R                    Option Header.

R2. 60                    Option 60.

R3. I/D                    Increment or decrement:  
                              **I**            incrementing field  
                              **D**            decrementing field

R4. amount                Amount to increase or decrease. Range: **0** to **999**.

R5. l pos                    Leftmost position in inc/dec portion of field. If this value is not entered, the default value 1 is used. Range: **0** to **2710**.

R6. r pos                    Rightmost position in inc/dec portion of field. If this value is not used, the entire field length is used as the default. Range: **0** to **2710**.

**Example**                    R,60,I,5,1,6 |

Increments a field by 5 each time the field is printed. The field increments beginning with the first left position and ending with the sixth position.

### Fixing the First Number in the Incrementing Sequence

There are two ways to enter the first number in the incrementing sequence. You can use batch data or use Option 1 to define the first number as a fixed character. The first number in the sequence must contain the same amount of digits as the highest number to be counted. For example, to count the numbers **1** to **999**, the first number in the sequence must be entered as **001**.

## Option 61 (Re-image Field)

---

This option redraws (reimages) a constant field when you have a constant field next to a variable field on your label. It can be used on text, constant text, bar code, line, or box fields.

These printers do not redraw an area if the field data does not change. When a field changes, that area is cleared and the new field data is imaged. However, the new field data may require a larger area than the previous field did. In some cases, neighboring fields that do not change (constant fields) may be covered with white space from the changing field's (variable fields) area. Use this option to reimage the constant field, or it may appear broken.

**Note:** The most common use for this option is with incrementing fields on your label, because they may cover a constant field..

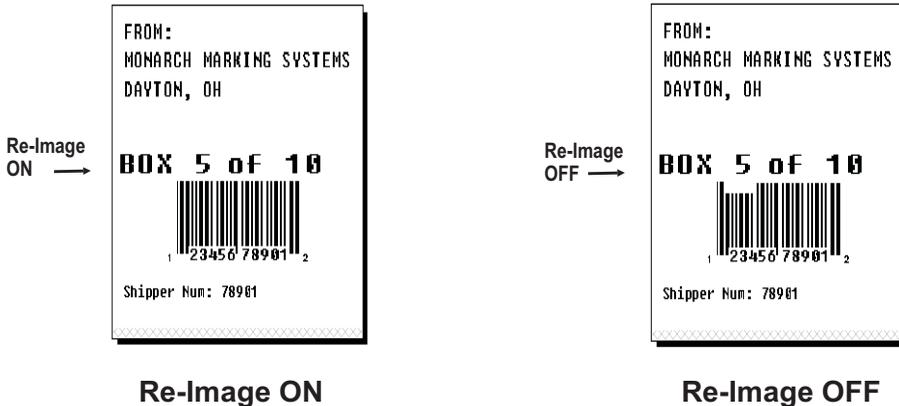
*Syntax*                    R, 61 |

*R1. R*                    Option Header.

*R2. 61*                    Option **61**.

*Example*                    R, 61 |

Reimages the constant field that appears next to a variable field.



In the above example, Option 61 was applied to the bar code field to keep the incrementing field (Box #) from blocking out the bar code field.

## Using Check Digits

---

Check digits are typically used to ensure that a text or bar code field scans correctly. If you apply Option 31, the printer calculates a check digit. A check digit scheme determines how the printer calculates a check digit. When you define a check digit scheme, you assign a number to identify it. This number is later entered in box **R4** when you apply Option 31 to a field. You can use check digits with text or bar code fields. Check digit calculations are performed on numeric data only.

Do not use check digits with price fields. Do not define a check digit scheme for UPC, EAN, Code 39 (with the MOD43 check digit), and Code 93 bar codes, because they have predefined check digits.

**Syntax**                    {A, selector, action, device, modulus,  
                              fld\_length, D/P, "weights" | }

- A1. A**                    Check Digit Header.
- A2. selector**            Assign a number from **1** to **10** to this check digit formula.
- A3. action**              The action to perform. Enter **A** to add the check digit scheme.
- A4. device**               Format storage device. Use **R** (Volatile RAM).
- A5. modulus**             Number from **2** to **11**. The modulus is used to divide the sum of products or the sum of digits.
- A6. fld\_length**          The maximum number of characters the field will contain.  
Range: **0** to **2710**.
- A7. D/P**                  Algorithm. The algorithm determines how the check digit is calculated.  
Options:  
      **D**        sum of digits  
      **P**        sum of products
- A8. "weights"**          String of digits used for calculation. A weight string is a group of two or more numbers that is applied to a field. The number of digits in this string should equal the number in *fld\_length*. Enclose in quotation marks.  
Range: **0** to **2710**.

**Example**                    {A, 1, A, R, 10, 5, P, "65432" | }

Adds check digit scheme number 1 to the printer's memory. The modulus is 10, the maximum number of characters in the field is 5. The check digit is calculated by using the Sum of Products and the string of digits used in the calculation is "65432."

## Sum of Products Calculation

This is an example of how the printer uses Sum of Products to calculate a check digit for this data:

5 2 3 2 4 5 2 1 9

1. Weights are applied to each digit, starting with the last digit in the weight string. They are applied right to left, beginning at the right-most position of the field. Remember, a weight string must contain at least two different numbers. This example has a weight string of **1,2,3,4**:

<b>field:</b>	5	2	3	2	4	5	2	1	9
<b>weight string:</b>	4	1	2	3	4	1	2	3	4

2. Each digit in the field is multiplied by the weight assigned to it:

<b>field:</b>	5	2	3	2	4	5	2	1	9
<b>weight string:</b>	4	1	2	3	4	1	2	3	4
<b>products:</b>	20	2	6	6	16	5	4	3	36

3. Next, the product of each digit is added together. This is the sum of the products.

$$20 + 2 + 6 + 6 + 16 + 5 + 4 + 3 + 36 = 98$$

4. Divide the sum of the products by the modulus (10 in this case), only to the whole number. The balance is called the remainder.

$$\begin{array}{r} 9 \\ 10 \overline{)98} \\ \underline{90} \\ 8 \end{array}$$

5. Subtract the remainder from the modulus.

The result becomes the check digit. In this case, the check digit is 2.

$$10 - 8 = 2$$

## Sum of Digits Calculation

This is an example of how the printer uses Sum of Digits to calculate a check digit for this data:

5 2 3 2 4 5 2 1 9

1. Weights are applied to each digit, starting with the last digit in the weight string. They are applied right to left, beginning at the right-most position of the field. Remember, a weight string must contain at least two different numbers. This example has a weight string of **1,2,3,4**:

<b>field:</b>	5	2	3	2	4	5	2	1	9
<b>weight string:</b>	<u>4</u>	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>

2. Each digit in the field is multiplied by the weight assigned to it:

<b>field:</b>	5	2	3	2	4	5	2	1	9
<b>weight string:</b>	<u>4</u>	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>	<u>1</u>	<u>2</u>	<u>3</u>	<u>4</u>
<b>products:</b>	20	2	6	6	16	5	4	3	36

3. Next, the digits of the products are added together. Two-digit products are treated as two separate digits. This is the sum of the digits.

$$2 + 0 + 2 + 6 + 6 + 1 + 6 + 5 + 4 + 3 + 3 + 6 = 44$$

4. Divide the sum of the digits by the modulus (10 in this case), only to the whole number. The balance is called the remainder.

$$\begin{array}{r} 4 \\ 10 \overline{)44} \\ \underline{40} \\ 4 \end{array}$$

5. Subtract the remainder from the modulus.

The result becomes the check digit. In this case, the check digit is 6.

$$10 - 4 = 6$$

# CREATING GRAPHICS

## 5

This chapter provides information on how to

- map out the graphic image using the hexadecimal (hex) or run length method.

- create a graphic packet using a graphic header, bitmap, duplicate, next-bitmap, text, constant text, line, and box fields.

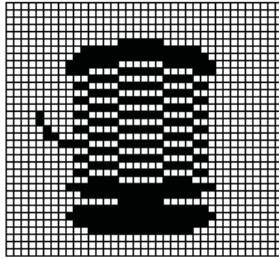
- place a graphic image into a format.

You can use graphic packets to create bitmapped images. To include a graphic packet within your format, your format **must** contain a graphic field. See “Placing the Graphic in a Format” for more information.

## Overview of Bitmapped Images

---

A printed image is formed through a series of dots. Each square on the grid below represents a dot on the printhead. The graphic image is created by blackening dots in a specific pattern. You can print varying shades of gray according to the concentration of dots on the image. When the dots are printed together, the end result is a graphic image.



### Determining a Method

You can use one of two methods to map out your graphic image:

#### Hex Method

The dot sequences are segmented into binary numbers and then converted to hex numbers.

A graphic using gray-scaling, several slanted lines, or several vertical lines typically translates more efficiently with hex representation.

#### Run Length Encoding Method

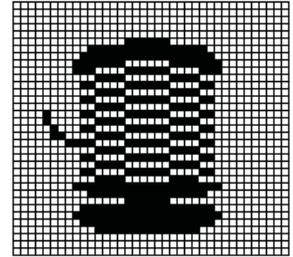
The dot sequences are segmented into black and white strings within a row. The total count of each white string is converted to a lower-case letter, corresponding to numeric value. The total count of each black string is converted to an uppercase letter, corresponding to numeric value. This method can reduce imaging time for graphics that contain repetitive rows of dots. A graphic with horizontal lines or very few white-to-black borders typically translates more efficiently with run length encoding.

The most efficient encoding method depends on how complicated your graphic image is and whether or not imaging time is a concern. You may want to experiment with both encoding methods to get optimal performance.

## Designing Bitmapped Images

Once you determine the encoding method to use, you can begin mapping out your graphic image.

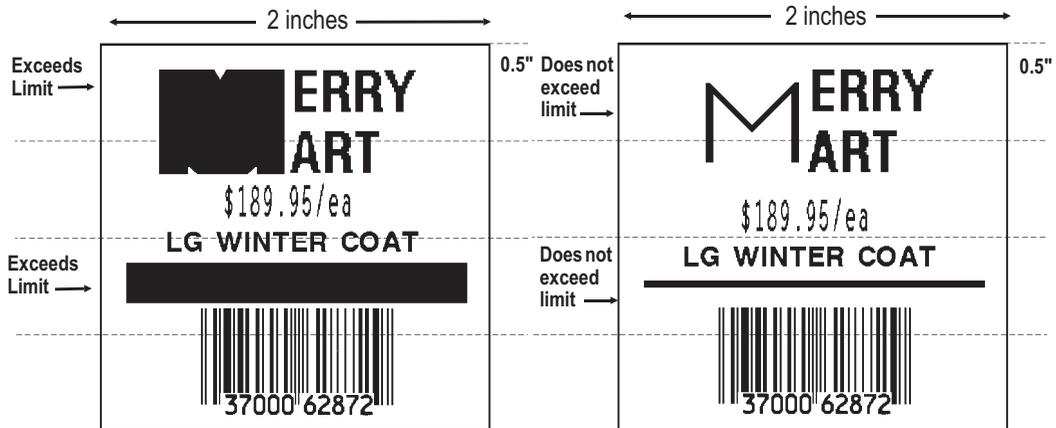
**Note:** The image that you map must be an upside down mirror image of the final result.



## Special Considerations

Solid black print cannot exceed 30% of any given square inch of the supply. If the black print exceeds this limit, you may lose data or damage the printhead.

In the first label, the large “M” logo and thick black line exceed the allowed black to white print ratio. In the second label, the large “M” logo does not exceed the black to white print ratio.









If the number is greater than 26, write z, followed by the letter corresponding to the amount over 26. For example, to represent 45 off dots, write zs.

5 on (E), 45 off (zs), 6 on (F)

.

3. Write the letter codes in sequence, uninterrupted, for each row.

(row 1, position 50) Z  
(row 2, position 39) KzI  
(row 3, position 34) EzsF  
(row 4, position 30) DpZoD

.

**Note:** If the end of the line specifies OFF dots (lower-case letters), the ending lower-case letters can be omitted. For example, uZFu can be written as uZF.

4. Repeat steps 1 through 5 for each row on the grid.
5. Insert the code values in syntax format.

## Determining How to Store the Image

Once you have mapped out your graphic image, determine how you want to store it. You have several options:

    Volatile RAM

    Temporary Storage

    Flash

### Using Volatile RAM

You should use RAM when the graphic image is used by several formats, because you only have to send the graphic image once. This eliminates the need to send the graphic image repeatedly. See "Placing the Graphic in a Format," for more information about using the graphic packet in a format. Graphics smaller than approximately 1/2 inch by 1/2 inch can be stored in printer RAM and referenced by the graphic ID number.

Graphics are stored in the format buffer and remain there until another graphic packet is sent or the printer is turned off.

## **Using Temporary Storage**

You should use temporary storage when the graphic image is used only in one format or your graphic image is very large. Graphic data in temporary storage is held in the image buffer until the graphic is printed and then it is cleared from memory. Temporary graphics are also cleared from memory when you send a new batch or update batch. You can use the same graphic image multiple times on a format. Send the graphic image to the printer after the format to which it applies.

If a graphic is stored in temporary storage, do not place a graphic field in the format. This causes an error. Instead, position the graphic image by using the row and column locations in the graphic packet header.

Image memory (temporary storage) accepts a graphic packet 1218 rows long with 811 dots per row.

## **Using Flash**

You can use flash memory when the graphic image is used by several formats, because you only have to send the graphic image once. This eliminates the need to send the graphic image repeatedly. See "Placing the Graphic in a Format," for more information about using the graphic packet in a format. Graphics stored in flash memory are saved when the printer is turned off.

## **Creating a Graphic Packet**

---

Your graphic packet can contain

- bitmapped fields (for bitmapped images)
- constant text fields
- lines
- boxes.

Images using hex representation or run length encoding are bitmapped images. See "Designing Bitmapped Images" to design your bitmapped image.

Once you design your graphic image, you are ready to define a graphic packet. This packet generates the graphic image you use in a format.

## Positioning the Graphic Image

This section explains how to position the graphic image within a graphic packet header, a field of a graphic packet, or within a format.

### Within the Graphic Packet Header

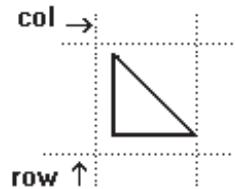
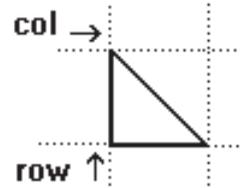
When you are using RAM, the row and column parameters in the graphic header are usually **0,0**, because placement is controlled by the graphic field in your format. This is especially true when designing a compliance label overlay.

When you are using temporary storage, these parameters control the placement of the graphic image on the supply.

The area enclosed within the dotted lines represents the graphic image starting at **0,0** (as defined in the graphic header).

If you want a fixed amount of white space around your graphic image, use something other than 0 for row and/or column.

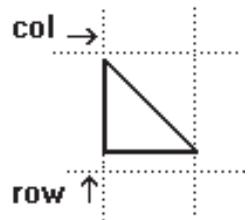
The area enclosed within the dotted lines represents the graphic image starting at **0,0** with a fixed amount of white space (**10,10**) around the graphic image.



### Within the Field

In a bitmap, constant text, line, or box field, the row and column parameters control where an individual field or bitmapped row begins in relation to the coordinates defined in the graphic header.

The bottom of the triangle in this example represents the first field of the graphic packet starting at **10,0**.



## Within a Format

When you define the graphic field within your format, the *row* and *column* parameters represent where on the **format** to place the graphic image.

If you are doing a compliance label, these numbers are usually **0,0**, because your compliance label covers the entire supply. See "Placing the Graphic in a Format," for a sample compliance label.

If you are placing a graphic (a logo, for example) within a certain area on your supply, enter the starting position (bottom left corner) of the graphic image.

This label shows the triangle "logo" beginning (the bottom left corner) at **155, 33** as defined in the graphic field.



## Defining the Graphic Header

---

Every graphic packet must contain a graphic header. This is the first thing you enter. It identifies and provides important measurement and formatting information for the graphic. Bitmap, duplicate, next-bitmap, constant text, line, and box fields follow the graphic header, if they are used.

**Syntax**                    {G, graphID, action, device, units, row, col,  
                                 mode, "name" }

- G1. G**                    Graphic Header.
- G2. graphID**            Unique number from **1** to **999** to identify the graphic image.
- G3. action**             Enter **A** to add the graphic to the printer.
- G4. device**             Graphic storage device:  
                              **R**        Volatile RAM  
                              **T**        Temporary storage
- G5. units**              Unit of measure. For bitmapped graphics, **G** (dots) is the only valid option.

*G6. row* Distance between the *bottom* of the graphic image area and the first bitmap line. This is usually **0**, unless you want a fixed amount of white space around the graphic image. See "Positioning the Graphic Image," for more information.

English    **0 - 1200**  
Metric     **0 - 3045**  
Dot        **0 - 2436**

*G7. column* Distance between the *left edge* of the graphic image area and the left edge of first bitmap line. This is usually **0**, unless you want a fixed amount of white space around the graphic image. See "Positioning the Graphic Image," for more information. Use the previous table for values.

English    **0 - 189**  
Metric     **0 - 479**  
Dots       **0 - 383**

*G8. mode* Imaging mode. Enter **0**.

*G9. "name"* Graphic name (optional), **0** to **8** characters, enclose within quotation marks.

*Example*            {G,99,A,R,G,0,0,0,"99Wire" ;

Adds a graphic image identified by number 99 to volatile RAM. The graphic uses dot measurement. The image will be placed according to the row and column parameters in the graphic field. The imaging mode is 0 and the image is called 99Wire.

## Creating Bitmap Fields

---

This defines one row of dots, starting at a specific row and column within the graphic image. Each unique row of dots requires a bitmap field. A bitmap field can later be repeated by using a duplicate field.

*Syntax*            `B, row, column, algorithm, "data" |`

*B1. B*            Bitmap Field.

*B2. row*            Distance (in dots) from the graphic image's bottom margin to the bitmap line.

English    **0 - 1200**  
Metric     **0 - 3045**  
Dot        **0 - 2436**

*B3. column*        Distance (in dots) from the graphic image's left edge to the bitmap line.

English    **0 - 189**  
Metric     **0 - 479**  
Dots       **0 - 383**

*B4. algorithm*     Coding method for bitmap data:  
          **H**     Hex Representation  
          **R**     Run Length Encoding

*B5. data*            Character string made up of hex or run length encoding. Do not put spaces or any other character between the numbers. Range: **0** to **2710**.

*Example*            `{B, 39, 56, H, "3FFFFFF0" |`

Defines a bitmapped graphic field. The image begins 39 dots from the bottom and 56 dots from the left edge of the graphic area. Hex representation is used.

## Creating Next-Bitmap Fields

---

This field uses the previous field's row and column locations. It allows you to use the bitmap or duplicate field data without having to recalculate row and column locations. This field represents one row of dots on the image.

**Syntax**                `N,adjdir,adjamt,algorithm,"data" |`

**N1. N**                Next-Bitmap Field.

**N2. adjdir**            Increments or decrements the row count. Inserts the duplicate line after or before the current row.

**0**                Increments (inserts after)  
    **1**                Decrements (inserts before)

    For example:

`B,50,35,R,"GsSsG" |`

`N,0,1,R,"DpZoD" |`

    prints a next-bitmap field on row 51 at column 35.

**N3. adjamt**            Amount of row adjustment in dot rows. Using **0** overwrites the same line. Range: **0** to **999**.

**N4. algorithm**        Coding method for bitmap data:

**H**                Hex Representation  
    **R**                Run Length Encoding

**N5. "data"**            Character string made up of hex or run length encoding. Do not put spaces or any other character between the hex numbers or run length code letters. Range: **0** to **2710**.

**Example**                `B,39,56,H,"3FFFFFF0" |`  
                          `N,0,1,H,"000000E00000" |`

Defines a next-bitmap graphic field beginning on row 40. The row count increments by 1. Hex representation is used.

## Creating Duplicate Fields

---

If a line of data is identical to a previous bitmap or next-bitmap field, the duplicate field allows you to repeat the dot sequence without retyping the data. A duplicate field represents one row of dots on the image.

**Note:** Duplicate fields are useful when you have a graphic with a lot of repetition.

**Syntax**            `D,adjdir,adjamt,count |`

*D1. D*                Duplicate Field.

*D2. adjdir*            Increments or decrements the row count. Inserts the duplicate line after or before the current row.

**0**                Increments (inserts after)

**1**                Decrements (inserts before)

                      For example:

`B,50,35,R,"GsSsG" |`

`D,0,20,2 |`

                      inserts row 50 again at row 70 and row 90. Rows 70 and 90 do not have to be defined later.

*D3. adjamt*            Amount of row adjustment in dot rows. Range: **0** to **999**. The above example adjusts the duplicate field to image on row 70 and 90 (adding 20 to the current row count).

*D4. count*            Number of times to duplicate the line. Range: **0** to **999**.

**Example**            `B,117,24,H,"03FFFFFFFFFFFFFFFFFFFFFC" |`  
                      `D,0,1,2 |`

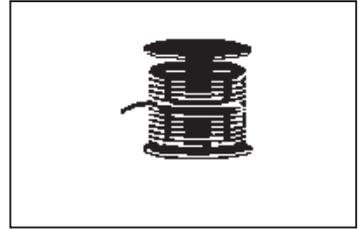
Defines a duplicate field that is imaged after the bitmap line. This field duplicates the preceding bitmap line twice (at row 118 and 119).

You can use constant text, line, or box fields in a graphic packet to create a compliance label overlay. See Chapter 3, "Defining Fields," for more information about these fields.

# Sample Hex Graphic Packet

---

```
{G,99,A,R,G,0,0,0,"99WIRE"!
B,39,48,H,"3FFFFFF0" !
B,40,32,H,"01FFC0000000FF8"!
B,41,32,H,"3E000000000000FC0" !
B,42,24,H,"03C0003FFFFFFF0000F"!
B,43,24,H,"7C3FFFFFFFFFFFFFFE1F0" !
B,44,16,H,"0183FFFFFFFFFFFFFFF06" !
B,45,16,H,"018FFFFFFFFFFFFFFFEE" !
B,46,16,H,"01FFFFFFFFFFFFFFFFFFFFE"!
B,47,16,H,"01FFFFFFF80001FFFFFFFFE" !
B,48,16,H,"01FFFFFF00000000007FFFC" !
B,49,24,H,"7F800007FFFF00003FF0" !
B,50,24,H,"1FC00007FFFF00001FC0" !
D,0,4,4 !
B,51,24,H,"1C03FFFFFFFFFFFFFFE01C0"!
D,0,4,4 !
B,52,32,H,"3FFFFFFFFFFFFFFE1C0" !
D,0,4,4 !
B,53,24,H,"03FFF00000000007FFE"!
D,0,4,4 !
B,70,0,H,"0400001FC00007FFFF00001FC0" !
B,71,0,H,"0600001C03FFFFFFFFFFFFFFE01C0" !
B,72,0,H,"030000003FFFFFFFFFFFFFFE1C0" !
B,73,0,H,"01000003FFF00000000007FFE" !
B,74,8,H,"FC001C03FFFFFFFFFFFFFFE00C0" !
B,75,8,H,"FE00003FFFFFFFFFFFFFFE0C0" !
B,76,8,H,"1FF803FFF00000000007FFE" !
B,77,8,H,"0FFFCFFC000000000000001C0" !
B,78,16,H,"FFDF000FFFFFFFFFFFF8003C0" !
B,79,16,H,"7FFFC00007FFFF00001FC0" !
B,80,24,H,"1C03FFFFFFFFFFFFFFE01C0" !
D,0,4,4 !
B,81,32,H,"3FFFFFFFFFFFFFFE1C0" !
D,0,4,4 !
B,82,24,H,"03FFF00000000007FFE" !
D,0,4,3 !
B,83,24,H,"1FC00007FFFF00001FC0" !
D,0,4,3 !
B,98,24,H,"03FFFFFFFFFFFFFFF0" !
```



```

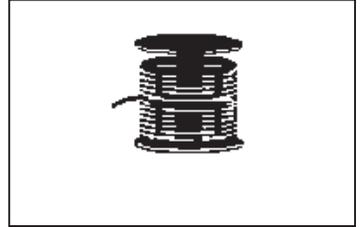
B,99,24,H,"07FFFFFFFFFFFFFFFC" |
B,100,24,H,"1FF9FFFFFFFFFFFFFF" |
B,101,24,H,"3FFE0007FFFF8000FF80" |
B,102,24,H,"391E0027FFFF803FFFC0" |
B,103,24,H,"1C7FFFFFFFFFFFFFFFC0" |
B,104,24,H,"1FC1FFFFFFFFFFFFFF1FC0" |
B,105,24,H,"0FFDFFFFFFFFFFFFFFE0FF" |
B,106,24,H,"FFFFFFFFFFFFFFFFF8" |
B,107,32,H,"3FFFFFFFFFFFFFFE0" |
B,108,32,H,"03FFFFFFFFFFFFFF" |
B,109,48,H,"07FFFF80" |
D,0,1,2 |
B,111,48,H,"FFFFFFFF" |
B,112,32,H,"FFFF0000000000FFE0" |
B,113,24,H,"078000FFFFFFFF001F" |
B,114,24,H,"78FFFFFFFFFFFFFFE060" |
B,115,16,H,"0187FFFFFFFFFFFFFFFC18" |
B,116,16,H,"027FFFFFFFFFFFFFFF2" |
B,117,16,H,"03FFFFFFFFFFFFFFFC" |
D,0,1,2 |
B,120,16,H,"01FFFFFFFFFFFFFFF8" |
B,121,24,H,"FFFFFFFFFFFFFFFFFE0" |
B,122,24,H,"07FFFFFFFFFFFFFFFC" |
B,123,32,H,"FFFFFFFFFFFFFFFC0" |
B,124,32,H,"01FFFFFFFFF8" | }

```

# Sample Run Length Graphic Packet

---

```
{G,99,A,R,G,0,0,0,"99WIRE" |
B,39,50,R,"Z" |
B,40,39,R,"KzI"|
B,41,34,R,"EzsF" |
B,42,30,R,"DpZoD" |
B,43,25,R,"EdZZEdE" |
B,44,23,R,"BeZZMeB" |
B,45,23,R,"BcZZW" |
B,46,23,R,"ZZZA" |
B,47,23,R,"ZDsZE" |
B,48,24,"TzkU" |
B,49,25,"HtRqJ" |
B,50,27,"GsSsG" |
D,0,4,4 |
B,51,27,"ChZWgC" |
D,0,4,4 |
B,52,34,R,"ZZEdC" |
D,0,4,4 |
B,53,30,R,"NzkN" |
D,0,4,4 |
B,70,5,R,"AuGsSsG" |
B,71,5,R,"BtChZWgC" |
B,72,6,R,"DxZZEdC" |
B,73,7,R,"CtNzkN" |
B,74,8,R,"FmChZWhC" |
B,75,8,R,"GsZZEdC" |
B,76,11,R,"JiNzkN" |
B,77,12,R,"NbJzzeC" |
B,78,16,R,"JaElZKmd" |
B,79,17,R,"QsSsG"|
B,80,27,R,"ChZWgC" |
D,0,4,4 |
B,81,34,R,"ZZEdC" |
D,0,4,4 |
B,82,30,R,"NzkN" |
D,0,4,4 |
B,83,27,R,"GsSsG" |
D,0,4,4 |
B,98,30,R,"ZZJ" |
B,99,29,R,"ZZM" |
B,100,27,R,"JbZZE" |
```



```
B,101,26,R,"MnToI" |
B,102,26,R,"CbHnTiP" |
B,103,27,R,"CcZzC" |
B,104,27,R,"GeZwCg" |
B,105,28,R,"JaZReH" |
B,106,32,R,"ZZI" |
B,107,34,R,"ZZE" |
B,108,38,R,"ZQ"|
B,109,53,R,"T" |
D,0,1,2 |
B,111,48,R,"ZF" |
B,112,33,R,"PzfK" |
B,113,29,R,"CpZBoE" |
B,114,25,R,"DcZZGfB" |
B,115,23,R,"BdZZMeB" |
B,116,22,R,"AbZZVbA" |
B,117,22,R,"ZZzB" |
D,0,1,2|
B,120,23,R,"ZZZ" |
B,121,25,R,"ZZV" |
B,122,29,R,"ZZM" |
B,123,32,R,"ZZF" |
B,124,39,R,"ZT" | }
```

## Placing the Graphic in a Format

---

To include a graphic within a format:

1. Design the graphic image as shown in “Designing Bitmapped Images.”
2. If you are using RAM, place a graphic field in the format file to reference the graphic. See the following section, “Defining the Graphic Field,” for more information.

**Note:** If you are using temporary storage, you do not need a graphic field in your format to reference the graphic image.

3. Download all the necessary packets (check digit, format, etc.).
4. Send the graphic file to the printer, if you have not already done so. See “Creating a Graphic Packet” for more information.

## Defining the Graphic Field

---

The graphic field in a format references the graphic image by the `graphID` in the graphic header. **This field is required only if the graphic will be stored in RAM.**

**Syntax** `G,graphID,row,col,mode,rotation |`

**G1. G** Graphic Field.

**G2. graphID** Unique number from **1** to **999** to identify the graphic image.

**G3. row** Distance between the *bottom* of the print area on the supply to the bottom of the graphic image. Measured in selected units.

English	<b>0 - 1200</b>
Metric	<b>0 - 3045</b>
Dot	<b>0 - 2436</b>

The row specified in the constant text, bitmap, line, or box field is added to the *row* value above to determine the actual position in the format.

**G4. column** Distance between the *left edge* of the print area on the supply and the left edge of the graphic. Measured in selected units. The column specified in the constant text, bitmap, line, or box field is added to the *col* value above to determine the actual position in the format.

English	<b>0 - 189</b>
Metric	<b>0 - 479</b>
Dots	<b>0 - 383</b>

G5. mode            Imaging mode. Enter 0.

G6. rotation        The orientation of the graphic on the supply. Enter 0.

*Example*            G,57,0,0,0,0 †

Defines a graphic field that is identified by the number 57. The image begins at 0,0. The imaging mode is 0 and there is no rotation.

## Sample Bitmap Graphic Image

---

The following format shows the graphic packets (hex and run length) in a sample format.

```
{F,2,A,R,E,400,400,"FMT2" †
G,99,227,35,0,0 †
Q,240,15,300,125,10," " †
T,1,5,V,285,137,0,10,2,2,B,L,0,0,0 †
T,2,5,V,255,137,0,10,2,2,B,L,0,0,0 †
T,3,15,V,180,25,0,10,1,2,B,L,0,0,0 †
T,4,15,V,121,35,0,1,3,1,B,L,0,0,0 †
L,S,94,15,94,235,10,"" †
B,5,12,F,50,65,1,2,40,1,L,0 † }
```

## Sample Batch Packet

```
{B,2,N,1 †
1,"Pat's" †
2,"Parts" †
3,"3/8 inch Wire" †
4,"3.55/8 Pack" †
5,"345911871209" † }
```



# PRINTING



This chapter describes how to

- define the batch header, batch control, and batch data files
- enter batch data for the Quick Response (QR) bar code.

It also list the various downloading methods.

## Defining the Batch Header

---

Batch data is the actual information printed on the supply. Batch data fills in the format's text and bar code fields.

A batch packet contains the following three parts:

**batch header** identifies the format and how many labels to print.

**batch control** defines the print job.

**batch data (optional)** defines the actual information printed on the label.

A batch header begins the file. It tells which format the batch uses and how many labels to print. To record batch data, make a copy of the worksheet in Appendix D, "Format Design Tools."

*Syntax* {B, format#, N/U, quantity |

*B1. B* Batch Header.

*B2. format#* Format number (1 to 999) to use.

*B3. N/U* Controls how image is generated.

**N** New (default). Erase image and re-image all fields using online data. Any missing fields will be blank.

**U** Update last image with one or more fields.

All other fields remain the same as the last queued batch.

*B4. quantity* Quantity to print (0 to 999). Using 0 pre-images the field to reduce the imaging time for labels. See "Batch Quantity Zero Method" for more information.

*Example* {B, 1, N, 1 |

Defines a batch header that uses format #1 and reimages all fields using the online data. One label is printed with this batch.

## Defining the Batch Control Field

---

The batch header must precede this field. The batch control field defines the print job and **applies only to the batch that immediately follows**.

**Syntax**                    `E,feed_mode,batch_sep,print_mult,multi_part |`

*E1. E*                    Batch Control Field.

*E2. feed\_mode*        Feed Mode. Options:  
                  **0**        Continuous Feed (default)  
                  **1**        On-Demand

*E3. batch\_sep*        Batch Separator. Use **0** (no separator).

*E4. print\_mult*        Number of tags (**1 to 999**) with the same image. 0 is the default.

*E5. multi\_part*        Number of identical parts on one tag (**1 to 5**). 0 is the default.

**Example**                `E,0,1,1 |`

Defines a batch control field. Continuous feed mode is used and no separator prints between batches.

## Defining Batch Data Fields

---

Batch data fields should be sent in field number order. Use continuation fields for large amounts of data. If you are using **N** (New) in the batch header, you must list all fields with your data in sequence. If you are using **U**, you need to list only those fields and data that changes from the last printed batch.

**Syntax**                    `field#,"data string" |`  
                  `C,"continuation" |`

*field#*                    Identifies the text, bar code, or non-printable text field in which to insert the following data. Range: **1 to 999**.

*"data string"*            Provides the actual information to appear in fields. Enclose in quotation marks. Length: **0 to 2710** characters.

*C*                        Identifies information to be appended to the data string. This parameter is optional.

*"continuation"* Provides the actual information to be added to the batch packet. Enclose in quotation marks. Use this option to break up longer fields. Length: **0** to **2710** characters. This parameter is optional.

*Example*            1, "Size 12" |  
                      2, "" |  
                      3, "Blue" |  
                      C, "and this would be appended." |

Defines a batch data field. "Size 12" prints in field #1, a blank line appears in field #2, "Blue and this would be appended" prints in field #3.

## Using Special Characters in Batch Data

There are two ways to specify special characters in batch data:

Place a tilde (~) before each character

Use a tilde with the decimal ASCII equivalent

For example, you can use "" or ~034 to print the " character in your batch data; otherwise, the tilde characters are ignored. You can also use ~XXX where XXX is the decimal equivalent of an unprintable character.

### Sample Batch Data with Special Characters

{B,1,N,1	Decimal Character	What Prints
1,"123~034456789"	~034 is "	123"456789
2,"~094983~'126LG4451"	~094 is ^ ~126 is ~	^983~'LG4451

### Merged or Sub-Fields

If a field is completely filled by data copied from other fields, use quotation marks without spaces between them for the *"data string"* parameter.

### Incrementing Fields

In incrementing fields, the first number in the sequence must contain the same number of digits as the highest number to be counted. For example, to increment the numbers in a field from **1** to **999**, enter the starting number in the batch as **001**.

## Entering Batch Data for QR Code

---

Quick Response (QR Code) is a two-dimensional bar code, which is made up of square modules arranged in an overall square pattern. A unique finder pattern is located at three corners of the symbol. Four levels of error correction are available, along with a wide range of symbol sizes.

Model 1 is the original specification.

Model 2 is an enhanced form that includes additional features.

The maximum number of characters depends on the type of characters entered for the batch data and differs for the two models of QR Code.

Data Type	Model1	Model2
Numeric data	1167	2710
Alphanumeric data	707	2710
8-Bit data	486	2710
Kanji data	299	1817

QR Code can accommodate Japanese *Kana* and *Kanji* characters and has a variety of applications, including marking spark plugs, radiators, printed circuit boards, and test tubes. Refer to the *AIM International Symbology Specification* for more details about data requirements.

QR Code requires certain parameters at the beginning of all batch data.

**Syntax**            "error\_cor mask# data\_input, char"

**error\_cor**        Level of error correction. Some damaged bar codes may still be scannable if the error correction is high enough. Options:

- H**        Ultra high reliability level
- Q**        High reliability level
- M**        Standard level
- L**        High density level

**Note:**        As you increase the error correction level, the maximum number of characters (in the field) decreases.

**mask#**            Mask number. Undefined. Leave blank or use **0**.

*data\_input* Type of data input. Options:  
**A** Automatic  
**M** Manual

*char* Type of characters. Options:  
**A** Alphanumeric  
**B** Binary  
**K** Kanji  
**N** Numeric

**Note:** In binary mode, the number of characters must be represented by the 4-digit number in decimal.

*Example* 1, "HM, N0123456789012345" | }

Defines the following batch data for the QR Code: The error correction level is **H**, which provides very high reliability. Leave the mask number blank. The data input mode is **Manual**. The type of characters are **Numeric** and the data is **0123456789012345**.

### *QR Code Packet*

```
{ F, 1, A, R, E, 200, 200, "QR CODE" |  
B, 1, 200, V, 50, 50, 36, 0, 100, 2, B, 0 |  
{ B, 1, N, 1 |  
1, "HM, N0123456789012345" | }
```



## Structured Append Mode

QR Code offers a mode called structured append (or concatenated) that allows you to collect data from multiple QR Code symbols and use that data elsewhere. For example, the components of a sub-assembly can have individual QR Codes and the QR Code for the entire assembly contains all the data from the individual codes. This mode also requires certain parameters at the beginning of all batch data.

**Syntax**                    "mode\_id code# #of\_div parity, error\_cor mask#  
                             data\_input char"

*mode\_id*                    Mode identifier. Use **D** to indicate the structured append (or concatenated) mode.

*code#*                     Code number of the individual symbol in the concatenated set. You must use a two-digit number in decimal.

*#of\_div*                    Total number of symbols in this concatenated set. You must use a two-digit number in decimal.

*parity*                    Parity byte. You must use a two-digit number in hexadecimal. There is no standard parity byte.

*error\_cor*                 Level of error correction. Some damaged bar codes may still be scannable if the error correction is high enough. Options:

- H**        Ultra high reliability level
- Q**        High reliability level
- M**        Standard level
- L**        High density level

**Note:**    As you increase the error correction level, the maximum number of characters (in the field) decreases.

*mask#*                     Mask number. Undefined. Leave blank or use **0**.

*data\_input*                Type of data input. Options:

- A**        Automatic
- M**        Manual

*char*                      Type of characters. Options:

- A**        Alphanumeric
- B**        Binary
- K**        Kanji
- N**        Numeric

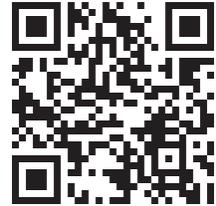
**Note:**    In binary mode, the number of characters must be represented by the 4-digit number in decimal.

*Example*            1, "D0205E9,Q0A," |  
                      C, "B006qrcode," | }

Defines the structured append mode (**D**) for QR Code. This is symbol (**02**) of a concatenated set containing (**05**) symbols. The parity byte is **E9**. The error correction level is **Q**, which provides a high reliability. Use **0** for the mask number. The data input mode is **Automatic**. The type of characters are binary (**B**) and there will be six (**06**) data characters (**qrcode**).

## Structured Append QR Code Packet

```
{F,2,A,R,E,200,200,"QRCODE2" |  
B,1,200,V,50,50,36,0,100,2,B,0 | }  
{B,2,N,1 |  
1,"D0202E9,Q0A" |  
C,"0123456789ABCD+__â~129~064~159~252~224~064" | }
```



## Downloading Methods

---

You can download the format and batch data using one of three methods: sequential, batch, and batch quantity zero.

### Sequential Method

Using the sequential method, you send all your format and batch data at one time. Use this method when your application does not require operator intervention to input data. All data is sent down at one time, and the printer then images each field. As soon as the last field is imaged, your labels begin to print.

*Example*            {Format}  
                      {Batch Packet}

### Batch Method

This is similar to the sequential method, but it is used when you want to send multiple batches. All data for the first batch is sent at one time, and the printer then images each field. As soon as the last field for the first batch is imaged, labels begin to print. This process is repeated for each subsequent batch.

*Example*            {Format}  
                          {Batch Packet}  
                          {Batch Packet}

## **Batch Quantity Zero Method**

You may use the batch quantity zero method when your application requires operator intervention to enter data. While the operator is entering data, the previous field is sent with a batch quantity of zero. The printer images the field, but does not print it. After the operator enters the data for the last field, the batch quantity can be specified. The last remaining field is imaged, and the label prints almost immediately.

To use the batch quantity zero method:

1. Send the format and a batch header in one file. The first time you send the batch header, use the parameter **N** (new batch), and the parameter **0** for (zero quantity). This ensures the label is properly positioned.

The printer images constant text, line, and box fields, but does not print them.

2. Input data for each field, and send it with a batch header using the parameter **U** (batch update) and a quantity of zero. When the printer receives the data, it immediately images the field, but does not print it.

At this time, the printer is imaging all associated fields, including fields that copy from other fields.

3. Repeat step 2 for each field except the last one.
4. For the last field, input data and send a batch header with the quantity of labels you want printed. When the printer receives input for the last field, it immediately prints the labels. See “Reducing Imaging Time” in Chapter 9 for an example using the batch quantity zero method.

## **Modifying Formats**

---

The optional entry method is a quick way to modify your format fields, check digit fields and configuration packets.

### **Optional Entry Method**

This method enables you to reset only the parameters you want to change. Commas act as placeholders for unchanged parameters. The optional entry method reduces file size and increases the speed at which files are sent to the printer.

# STATUS POLLING



This chapter explains how to use status polling.

There are two types of Status Polling:

**Inquiry Request**—information about the readiness of the printer.

**Job Request**—information about the current (or last received) job downloaded to the printer.

## Inquiry Request (ENQ)

---

An ENQ character acts as a request for printer status information. You can send an ENQ in front of, in the middle of, or immediately following any packet downloaded to the printer. An ENQ is a command that can be executed as part of a packet or sent on its own (using a communications program). An ENQ is processed immediately. The ENQ character is user defined.

The ENQ character does not appear as a visible character; however, we are representing the ENQ character as `^N`.

### **Inquiry Response**

Printer status is returned to the host in a 3-byte (3-character) sequence. The first byte is the non-printable user-defined ENQ character, which is not visible on the response. The second and third bytes are printer status codes. See the ENQ Reference Tables for the meaning of bytes 2 and 3.

*Example:* `^N AB`

The status codes (A and B in this case) are ASCII equivalents to the hexadecimal bits that represent the various types of status responses. This response indicates that the printer is online (Character A) and that there is a stock fault (Character B).

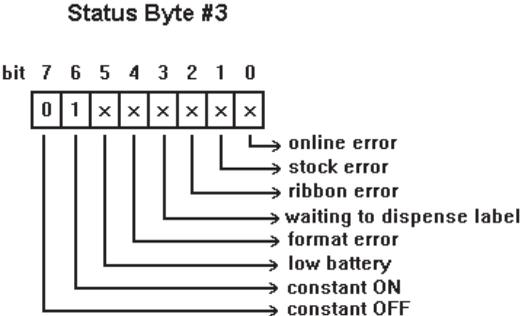
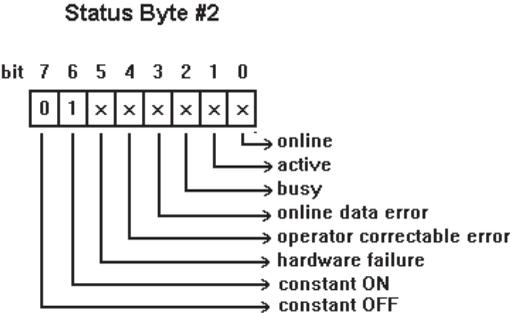
*Example:* `^N ??`

Indicates that this is the first ENQ response since the printer was turned on. Send another ENQ immediately to receive the printer's status.

*Example:* `^N @@`

Indicates the printer is offline.

The following graphics can be used as a quick reference for the Status of Byte #2 and Byte #3. Byte #1 is the non-printable user-defined ENQ character.



## ENQ Reference Table - Byte #2

Char	Const. OFF	Const. ON	Comp. Failure	Corr. Error	Online Data Error	Busy	Active	Online
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
@	0	1	0	0	0	0	0	0
A	0	1	0	0	0	0	0	1
B	0	1	0	0	0	0	1	0
C	0	1	0	0	0	0	1	1
D	0	1	0	0	0	1	0	0
E	0	1	0	0	0	1	0	1
F	0	1	0	0	0	1	1	0
G	0	1	0	0	0	1	1	1
H	0	1	0	0	1	0	0	0
I	0	1	0	0	1	0	0	1
J	0	1	0	0	1	0	1	0
K	0	1	0	0	1	0	1	1
L	0	1	0	0	1	1	0	0
M	0	1	0	0	1	1	0	1
N	0	1	0	0	1	1	1	0
O	0	1	0	0	1	1	1	1
P	0	1	0	1	0	0	0	0
Q	0	1	0	1	0	0	0	1
R	0	1	0	1	0	0	1	0
S	0	1	0	1	0	0	1	1
T	0	1	0	1	0	1	0	0
U	0	1	0	1	0	1	0	1
V	0	1	0	1	0	1	1	0
W	0	1	0	1	0	1	1	1
X	0	1	0	1	1	0	0	0
Y	0	1	0	1	1	0	0	1
Z	0	1	0	1	1	0	1	0
[	0	1	0	1	1	0	1	1
\	0	1	0	1	1	1	0	0
]	0	1	0	1	1	1	0	1
^	0	1	0	1	1	1	1	0
_	0	1	0	1	1	1	1	1
`	0	1	1	0	0	0	0	0

**Note:** A "1" indicates the bit is turned on. A "0" indicates the bit is off.

## ENQ Reference Table - Byte #2 (continued)

Char	Const. OFF	Const. ON	Comp. Failure	Corr. Error	Online Data Error	Busy	Active	Online
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
a	0	1	1	0	0	0	0	1
b	0	1	1	0	0	0	1	0
c	0	1	1	0	0	0	1	1
d	0	1	1	0	0	1	0	0
e	0	1	1	0	0	1	0	1
f	0	1	1	0	0	1	1	0
g	0	1	1	0	0	1	1	1
h	0	1	1	0	1	0	0	0
i	0	1	1	0	1	0	0	1
j	0	1	1	0	1	0	1	0
k	0	1	1	0	1	0	1	1
l	0	1	1	0	1	1	0	0
m	0	1	1	0	1	1	0	1
n	0	1	1	0	1	1	1	0
o	0	1	1	0	1	1	1	1
p	0	1	1	1	0	0	0	0
q	0	1	1	1	0	0	0	1
r	0	1	1	1	0	0	1	0
s	0	1	1	1	0	0	1	1
t	0	1	1	1	0	1	0	0
u	0	1	1	1	0	1	0	1
v	0	1	1	1	0	1	1	0
w	0	1	1	1	0	1	1	1
x	0	1	1	1	1	0	0	0
y	0	1	1	1	1	0	0	1
z	0	1	1	1	1	0	1	0
{	0	1	1	1	1	0	1	1
	0	1	1	1	1	1	0	0
}	0	1	1	1	1	1	0	1
~	0	1	1	1	1	1	1	0
Dec 127	0	1	1	1	1	1	1	1

**Note:** A "1" indicates the bit is turned on. A "0" indicates the bit is off.

## ENQ Reference Table - Byte #3

Char	Const. OFF	Const. ON	Low Battery	Format Error	Waiting to Dispense Label	Ribbon Fault	Stock Fault	Online Error
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
@	0	1	0	0	0	0	0	0
A	0	1	0	0	0	0	0	1
B	0	1	0	0	0	0	1	0
C	0	1	0	0	0	0	1	1
D	0	1	0	0	0	1	0	0
E	0	1	0	0	0	1	0	1
F	0	1	0	0	0	1	1	0
G	0	1	0	0	0	1	1	1
H	0	1	0	0	1	0	0	0
I	0	1	0	0	1	0	0	1
J	0	1	0	0	1	0	1	0
K	0	1	0	0	1	0	1	1
L	0	1	0	0	1	1	0	0
M	0	1	0	1	1	0	0	1
N	0	1	0	0	1	1	1	0
O	0	1	0	0	1	1	1	1
P	0	1	0	1	0	0	0	0
Q	0	1	0	1	0	0	0	1
R	0	1	0	1	0	0	1	0
S	0	1	0	1	0	0	1	1
T	0	1	0	1	0	1	0	0
U	0	1	0	1	0	1	0	1
V	0	1	0	1	0	1	1	0
W	0	1	0	1	0	1	1	1
X	0	1	0	1	1	0	0	0
Y	0	1	0	1	1	0	0	1
Z	0	1	0	1	1	0	1	0
[	0	1	0	1	1	0	1	1
\	0	1	0	1	1	1	0	0
]	0	1	0	1	1	1	0	1
^	0	1	0	1	1	1	1	0
_	0	1	0	1	1	1	1	1
`	0	1	1	0	0	0	0	0

**Note:** A "1" indicates the bit is turned on. A "0" indicates the bit is off.

## ENQ Reference Table - Byte #3 (continued)

Char	Const. OFF	Const. ON	Low Battery	Format Error	Waiting to Dispense Label	Ribbon Fault	Stock Fault	Online Error
	Bit 7	Bit 6	Bit 5	Bit 4	Bit 3	Bit 2	Bit 1	Bit 0
a	0	1	1	0	0	0	0	1
b	0	1	1	0	0	0	1	0
c	0	1	1	0	0	0	1	1
d	0	1	1	0	0	1	0	0
e	0	1	1	0	0	1	0	1
f	0	1	1	0	0	1	1	0
g	0	1	1	0	0	1	1	1
h	0	1	1	0	1	0	0	0
i	0	1	1	0	1	0	0	1
j	0	1	1	0	1	0	1	0
k	0	1	1	0	1	0	1	1
l	0	1	1	0	1	1	0	0
m	0	1	1	0	1	1	0	1
n	0	1	1	0	1	1	1	0
o	0	1	1	0	1	1	1	1
p	0	1	1	1	0	0	0	0
q	0	1	1	1	0	0	0	1
r	0	1	1	1	0	0	1	0
s	0	1	1	1	0	0	1	1
t	0	1	1	1	0	1	0	0
u	0	1	1	1	0	1	0	1
v	0	1	1	1	0	1	1	0
w	0	1	1	1	0	1	1	1
x	0	1	1	1	1	0	0	0
y	0	1	1	1	1	0	0	1
z	0	1	1	1	1	0	1	0
{	0	1	1	1	1	0	1	1
	0	1	1	1	1	1	0	0
}	0	1	1	1	1	1	0	1
~	0	1	1	1	1	1	1	0
Dec 127	0	1	1	1	1	1	1	1

**Note:** A "1" indicates the bit is turned on. A "0" indicates the bit is off.

## Job Request

---

A Job Request returns status information about the most recently processed print job. You can send a job request after an ENQ or batch. You can send two levels of Job Requests:

Numeric Error Codes Only (0, 1, or 2)

Verbose (3 or 4)

*Syntax*                    { J, # }

Field Type	Valid Options	Description
Identifier	J	Job Status Request
request#	0 1 2 3 4	Returns ASCII coded strings or numeric error codes  Returns error number Returns number of labels printed in batch

*Example*                    { J, 3 }

The job response may not be immediate. If the printer has an error (out of supplies, ribbon problem, etc.), is in pause mode, or has insufficient memory, correct the problem and then resend the job request. If the problem is not corrected, no response is returned. If a formatting error has occurred, the job request will return the status. The printer must first interpret the format and batch data before returning the response.

**Note:** You may need to press  before the job response is returned.

To clear an error, press the left  button. An ENQ can also clear errors numbered less than 500. Once the error is corrected, a job request can be sent. The printer cannot accept another job request until the error is resolved.

## Job Response

The Job Response varies, depending on the type of request sent to the printer. The following syntax is the response for a Job 0, 1, or 2 request.

*Syntax*                    {J, Status1, Status2, "FMT-1", "BCH-2"}

**Status1**                    These errors stop the print job. Examples include out of stock, supply faults, or data formatting errors. These errors are numbered less than 24 on the "Job Status 0, 1, 2 Response Table," later in this chapter.

**Status2**                    These are errors in the syntax of the MPCL data stream. Printing does not stop, but the information may not print properly. These errors are numbered greater than 24 on the "Job Status 0, 1, 2 Response Table," later in this chapter.

**FMT-1/BCH-2**                The format or batch number is returned.

Here is an example of a response returned to a J 0, 1, 2 request:

```
{J,8,0,"FMT-1","BCH-2"}
```

Indicates that a portion of the format extends off the tag in format 1, batch 2. Refer to the "Job Status 0, 1, 2 Response Table" later in this chapter for brief explanations for J, 0, 1, 2 requests. In the above example, refer to error 8 for an explanation.

The following syntax is the response for a Job 3 request. You may need to press  before the job response is returned.

*Syntax*                    {J, "Status1 A,B", "Status2  
A,B,C,D,E", "FMT-1", "BCH-2" }

**“Status1 A,B”**            Status1 A contains the field number, in the format or batch, where an error was found. If the error is not in the format or batch, a “0” is returned.

                                 Status1 B contains an error number, which represents the actual printer error. The error numbers can be found in Chapter 8, "Diagnostics and Errors."

*Example*                    {J, "2, 612", }

**2** is the field number where an error was found. **612** is the error number, indicating that data is missing or does not match the format definition for that field.

**Note:** Error numbers found in Status1 B, always have a value equal to or greater than 500. These are considered very serious errors.

**“Status2 A,B,C,D,E”** contains the packet type, field type, field number, parameter, and error number.

**Status2**                    represents the MPCLII packet that the error occurred on. The packet could be Format (**F**), Batch (**B**), Check Digit (**A**), Graphic (**G**), or Font (**W**).

**Status2**                    represents the MPCLII field that the error occurred on. If the packet has no fields, Status2 A will be replicated. If the error occurs before the field is identified a question mark is sent. Since the batch data is variable, a **D** is sent to indicate data.

**Status2**                    represents the field number within each packet. The packet header is the first field and each subsequent field is indicated by the field separator.

**Status2 D- Parameter** represents the parameter within the field that the error occurred. The numbering begins after the field identifier.

**Status2 E- Error Number** is the error that coincides with the error numbers presented in Chapter 8, "Diagnostics and Errors."

**"FMT-1/BCH-2"** The format or batch number is returned.

**Note:** If more than one error occurred, only the most serious error is acknowledged.

```
{J,"", "F,B,4,6,33", "FMT-1", "BCH-2"}
```

Indicates that an error occurred on a bar code (**B**) field within a format (**F**) packet. The bar code field is the fourth (**4**) field in the packet. The error occurred in the sixth (**6**) parameter of the field. Error number **33** means the bar code density is invalid.

To clear an error, press the left  button. An ENQ can also clear errors numbered less than 500. Once the error is corrected, a job request can be sent. The printer cannot accept another job request until the error is resolved.

The following syntax is the response for a Job 4 request.

*Syntax* {J,printed,total,"FMT-1","BCH-2"}

**printed** the number of tags or labels already printed in the batch.

**total** the total number of tags or labels to be printed in the current batch.

**"FMT-1/BCH-2"** The format or batch number is returned.

*Example* {J,8,25,"FMT-3","Bch-2"}

**8** out of **25** tags or labels have been printed from format number **3**.

Use a Job Request 4 when printing in the on-demand mode with a large number of tags or labels from a single batch. A Job Request 4 may not be accurate if tags or labels are printed in continuous mode, because of the response time involved. A Job Request 4 is not useful in single ticket batches (printing 1 of 1) or multiple single ticket batches.

**Note:** A batch has to be printing when you send the job request. You cannot use this job request on batches printing formats with incrementing fields.

### Job Status 0, 1, 2 Response Table (Status 1 Codes)

Number	Meaning
0	No error
1	Stacker fault
2	Supply problem
4	Hot printhead
5	Printhead open
6	Insufficient memory
7	Ribbon problem
8	Field ## extends off tag
9	Field ## has a bad font/bar code
10	Field ## contains invalid data
11	Field ## has a graphic missing
12	Invalid communication channel
13	Invalid file type
14	All communication channels are busy
15	Receive overrun error
16	Receive parity error
17	Receive framing error
18	Receive buffer full
19	Label waiting
21	Bad dots (verifier detected a failure)
23	Low battery
24	Memory configuration packet error

Numbers 25 through 50 are not currently in use.

## Job Status 0, 1, 2 Response Table (Status 2 Codes)

Number	Meaning
51	Invalid command
52	Invalid separator value
53	Graphic not found
54	Format for batch not found
55	Quantity/Multiples out-of-range
56	Name descriptor too long
57	Invalid cut value
58	Invalid number-of-parts value
59	Invalid orientation value
60	Invalid thickness value
61	Invalid text field
62	Invalid bar code field
63	Data string too long
64	Invalid data field
65	Row greater than stock length
66	Row greater than format length
67	Column greater than printhead width
68	Column greater than format width
69	Invalid label length
70	Invalid label width
71	Invalid increment/decrement value
72	Identifier out-of-range
73	No field to create format
74	Stop location of a line is out of range
75	Syntax error
80	Can't use offline format for online batch
81	Can't queue graphic batch
82	Can't store online format
83	Can't queue online batch
84	Can't queue online clear command



# DIAGNOSTICS AND ERRORS

## 8

This chapter explains how to

- print test labels
- reset the printer
- call Technical Support.

Before you call Service, print a test label. The label contains information to help diagnose mechanical and setup problems.

This chapter also provides explanations of your printer's errors. The errors are classified by type and are listed in order. If you have trouble loading supplies or performing maintenance, refer to the *Operator's Handbook*.

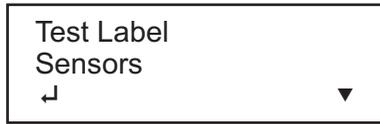
Some errors numbered 400-438 and 500-574 are internal software errors. Errors numbered 703-758 are supply errors. Follow the directions provided with the error description to correct the problem. Errors numbered 900-999 are Hard Printer Failures. If you cannot clear an error, turn off the printer, wait several seconds and then turn on the printer. Call Technical Support if you receive any error message not listed in this chapter.

To clear a data error, press the left  button. If a formatting error occurs, the label prints; but data may be missing. Correct the format or batch and resend them to the printer.

## Printing a Test Label

---

1. From the Diagnostics menu, select Printer. You will see:

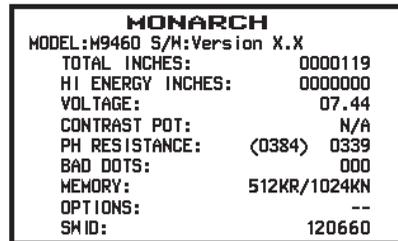
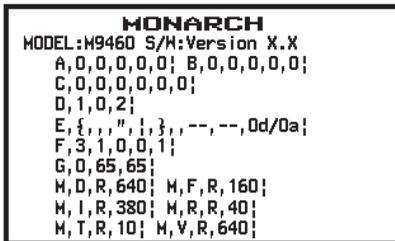


2. From the Printer menu, select Test Label.

After you select Test Label, you will see:



From the Test Label menu, select Diag Label.



Two test labels print and you return to the Test Label menu. The diagnostic labels show the printer's configuration, as well as the model number and software version number. With version 2.8 or greater software, the printer supports symbol set 102 (Unicode character mapping).

**Note:** See the *System Administrator's Guide* to learn how to print two other types of diagnostics labels: the test pattern and the grey scale.

## **Reading a Test Label**

---

The first test label shows the model number, software version, and the printer's configuration by packet. See Chapter 2, "Configuring the Printer" for more information about the printer's configuration.

The second test label shows the model number, software version, total number of inches printed, voltage, print contrast, printhead resistance, number of bad dots, and memory. In the example above:

The printer has printed 119 inches of regular supplies.

The printer has printed no linerless (high-energy) supplies.

No options are set

CONTRAST POT does not apply.

## **Resetting Printers**

---

Sometimes the printer receives mixed signals and loses its ability to communicate. If this happens, reset the printer and attempt communication again. To reset the printer, turn off the printer, wait 15 seconds, and turn it back on.

When you turn off the printer, all the information set through the online configuration packets (A-M) is saved. See the sections in Chapter 2, "Configuring the Printer," for more information about each packet.

## **If You Receive an Error Message**

---

Any time you receive a message that is not described in this manual, or the recommended action does not solve the problem, call Technical Support. Some errors are the result of communication problems. In this case, reset your printer and reboot your computer. If you change any of the online configuration packets, resend the format packet to the printer, so the configuration changes take effect.

## **If the PC and Printer Are Not Communicating**

If your PC is having trouble communicating with your printer, follow these steps:

Check any messages that occur at the printer and at the computer. See the following error message listing in this chapter for more information.

Make sure you are using the correct printer cable.

Make sure the cable is plugged into the correct port on the computer.

Compare your printer's communications settings (especially flow control) with the settings on your PC. Your printer and PC communications should match. Print a test label to identify the printer's communication settings.

Make sure the printer is online (ready to receive data).

If all of the above are correct, reset your printer. Try the function again. If you still can not establish communications, call Technical Support.

## **Calling Technical Support**

Technical support representatives are available Monday through Friday during regular business hours. Follow these steps before you call:

1. Make sure your PC and printer are properly connected.
2. Record any error messages that occurred.
3. Recreate the problem, if you can.
4. Check your port settings. Your problem may be corrected simply by changing the communication settings.
5. List any changes that have recently been made to the system. Try to record what you were doing when the problem occurred.
6. Reset your printer. For information on resetting your printer, see "Resetting Printers."
7. Reboot your computer. Refer to your computer documentation for specific instructions.
8. Print a test label, see "Printing a Test Label" for more information.

Have the following information ready before you call: computer brand name and model, version of DOS, printer model, other peripheral devices on your system, support agreement, contract number, or invoice information, customer number, and printer serial number.

## **Additional Diagnostics Information**

For detailed printer diagnostics information, refer to the *Operator's Handbook*. See Chapter 7, "Status Polling," for information on requesting printer and job status. See the following error message listing in this chapter for more information.

## **Data Errors**

Errors 001 to 499 are data errors. These errors are returned in response to a J,3 request. See Chapter 7, "Status Polling," for more information. A data error indicates that incorrect data was received from the host, causing the printer to ignore the entire print job. After checking the packet and correcting the problem, transmit the print job again.

The following is a list of data errors. These errors occur because data in the format, batch, check digit, font, or graphic packet is invalid.

### **Format Errors**

<b>Error Code</b>	<b>Description</b>
001	Packet ID number must be <b>1</b> to <b>99</b> .
002	Name must be <b>1</b> to <b>8</b> characters (excluding non-printable control characters) inside quotes.
003	Action must be <b>A</b> (add) or <b>C</b> (clear).
004	Supply length is invalid. See "Defining the Format Header" in Chapter 3 for valid lengths.
005	Supply width is invalid. See "Defining the Format Header" in Chapter 3 for valid widths.
006	Storage device must be <b>F</b> (Flash), <b>R</b> (volatile RAM), or <b>T</b> (temporary for graphics).

- 007 Unit of measure must be **E** (English), **M** (Metric), or **G** (Dots). See “Defining the Format Header” in Chapter 3 for more information.
- 010 Field ID number is outside the range **0** to **999**.
- 011 Field length exceeds **2710**.
- 012 Row field position is greater than the maximum stock dimension. See “Defining Text Fields” in Chapter 3 for valid row lengths.
- 013 Column field position is greater than the maximum stock dimension. See “Defining Text Fields” in Chapter 3 for valid column widths.
- 014 Font style must be **1**, **2**, **3**, **4**, **5**, **6**, **10**, **11**, or **50**. See “Defining Text Fields” in Chapter 3 or Appendix B, “Fonts,” for more information.
- 015 Character rotation must be **0** (0 degree), **1** (90 degree), **2** (180 degree), or **3** (270 degree). See “Defining Text Fields” in Chapter 3 for more information.
- 016 Field rotation must be **0** (0 degree), **1** (90 degree), **2** (180 degree), or **3** (270 degree). See “Defining Text Fields” in Chapter 3 for more information.
- 017 Field restriction must be **V** (variable) or **F** (fixed).
- 018 Code page/symbol set selection defined in the field must be **0** (Internal), **1** (ANSI), **102** (Unicode), **437** (DOS Page 437), **850** (DOS Page 850), **852** (Latin 2), **855** (Russian), **857** (Turkish), **860** (Portuguese), **1250** (Latin 2), **1251** (Cyrillic), **1252** (Latin 1), **1253** (Greek), **1254** (Turkish), **1255** (Hebrew), **1256** (Arabic), **1257** (Baltic), or **1258** (Vietnamese). See “Defining Text Fields” in Chapter 3 for more information.
- 020 Vertical magnification must be **1** to **7** or **4** to **255** (point size) for the scalable or downloaded TrueType fonts.
- 021 Horizontal magnification must be **1** to **7** or **4** to **255** (point size) for the scalable or downloaded TrueType fonts.

- 022 Color must be **A, B, D, E, F, N, O, R, S, T,** or **W**. See “Defining Text Fields” in Chapter 3 for more information.
- 023 Intercharacter gap must be **0** to **99** dots.
- 024 Field justification must be **B** (balanced), **C** (centered), **E** (end), **L** (left), or **R** (right). See “Defining Text Fields” in Chapter 3 for more information.
- 025 String length is outside the range **0** to **2710**.
- 030 Bar code height must be at least **20** (English), **51** (Metric), **41** (Dots), or is not within the supply dimensions.
- 031 Human readable option must be
- 0** default
  - 1** no CD or NS
  - 5** NS at bottom, no CD
  - 6** CD at bottom, no NS
  - 7** CD and NS at bottom
  - 8** no text
- 032 Bar code type is invalid. See “Defining Bar Code Fields” in Chapter 3 for valid options.
- 033 Bar code density is invalid. See “Defining Bar Code Fields” in Chapter 3 for the bar code density chart.
- 040 Line thickness must be **0** to **99** dots.
- 041 Line direction must be **0, 90, 180,** or **270**.
- 042 End row is invalid. Line segment or box end row is defined outside of printable area.
- 043 End column is invalid. Line segment or box end column is defined outside of printable area.
- 044 Dot pattern for line or box must be “”.
- 045 Line length is defined beyond the maximum length. See “Defining Line Fields” in Chapter 3 for valid lengths.
- 046 Line type must be **S** (segment) or **V** (vector).

051 Imaging mode in the graphic header must be **0**.

## Batch Errors

<b>Error Code</b>	<b>Description</b>
101	The format referenced by batch is not in memory.
102	Print quantity is outside the range <b>0</b> to <b>24</b> .
104	Batch mode must be <b>N</b> (new) or <b>U</b> (update).
105	Batch separator in a batch control field must be <b>0</b> (Off).
106	Print multiple is outside the range <b>1</b> to <b>24</b> .
107	Cut multiple is outside the range <b>0</b> to <b>999</b> . Only valid for printers with a knife.
108	Multiple part supply is outside the range <b>1</b> to <b>5</b> .
109	Cut type is outside the range <b>0</b> to <b>5</b> . Only valid for printers with a knife.

## Option Errors

<b>Error Code</b>	<b>Description</b>
200	Option number must be <b>1, 2, 4, 30, 31, 42, 50, 51, 52, 60, or 61</b> .
201	Copy length is outside the range <b>0</b> to <b>2710</b> .
202	Copy start position must be <b>1</b> to <b>2710</b> .
203	Destination start position must be <b>1</b> to <b>2710</b> .
204	Source field must be <b>0</b> to <b>999</b> .
205	Copy type must be <b>1</b> (copy after rules) or <b>2</b> (copy before rules).

- 206 Increment/Decrement selection must be **I** (increment) or **D** (decrement).
- 207 Incrementing start position must be **0** to **2710**.
- 208 Incrementing end position must be **0** to **2710**.
- 209 The incrementing amount must be **0** to **999**.
- 210 Security value for a PDF-417 bar code must be **0** to **8**. Correct the value and resend the format to the printer.
- 211 Narrow element value is less than **1** or greater than **99**. Correct the value and resend the format to the printer.
- 212 Wide element value is less than **1** or greater than **99**. Correct the value and resend the format to the printer.
- 213 Dimension must be **1** to **30** for a column or **3** to **90** for a row on a PDF417 bar code.
- 214 Truncation code must be **S** (standard) or **T** (truncated bar code).
- 215 Aspect code must be **C** (columns) or **R** (rows).
- 216 Option definition must be **S** (set) or **T** (template).
- 217 Input device device must be **D** (Default), **H** (Host), **K** (Keyboard), **N** (None), or **S** (Scanner).
- 218 Pad direction must be **L** (from left) or **R** (from right).
- 219 Pad character is outside the range **0** to **255**.
- 220 Check digit selection must be **G** to generate check digit.
- 221 Primary or secondary price format is outside the range **1** to **16**.
- 222 Data type restriction is outside the range of **1** to **6**.
- 223 Option is not valid for the field.

224 Bar code intercharacter gap must be **0** to **99** dots. (This is also known as the additional character gap when using Option 50, Defining Bar Code Densities.)

## Online Configuration Errors

<b>Error Code</b>	<b>Description</b>
251	Power up mode must be <b>0</b> (online).
252	Language selection must be <b>0</b> (English), <b>1</b> (French), <b>2</b> (German), or <b>3</b> (Spanish-ES).
253	Batch separator must be <b>0</b> (off).
254	Slash zero selection must be <b>0</b> (standard zero) or <b>1</b> (slashed zero).
255	Supply type must be <b>0</b> (black mark), <b>1</b> (die cut), or <b>2</b> (non-indexed).
256	Printhead energy selection must be <b>0</b> (standard supplies), <b>1</b> (fax paper) or <b>2</b> (linerless/synthetic supplies).
257	Feed mode must be <b>0</b> (continuous) or <b>1</b> (on-demand, if the option is used).
258	Supply position must be <b>-99</b> to <b>99</b> dots.
259	Contrast adjustment must be <b>-28</b> to <b>40</b> dots.
260	Print adjustment (position) must be <b>-99</b> to <b>99</b> dots.
261	Margin adjustment (position) must be <b>-99</b> to <b>99</b> dots.
262	Speed adjustment must be <b>0</b> (default), <b>20</b> (2.0 ips), or <b>30</b> (3.0 ips).
263	Primary monetary symbol must be <b>0</b> (None), <b>1</b> (Dollar), <b>2</b> (Pound), <b>3</b> (Yen), <b>4</b> (Deutsche Mark), <b>5</b> (Franc), <b>6</b> (Peseta), <b>7</b> (Lira), <b>8</b> (Krona), <b>9</b> (Markka), <b>10</b> (Schilling), <b>11</b> (Rupee), <b>12</b> (Ruble), <b>13</b> (Won), <b>14</b> (Baht), <b>15</b> (Yuan), or <b>16</b> (Eurodollar).

- 264 Secondary symbol selection must be **0** (none) or **1** (print secondary sign).
- 265 Monetary decimal places must be **0** to **3**.
- 266 Character string length in the control characters packet must be **5** (MPCL control characters) or **7** (ENQ/IMD command character).
- 267 Baud rate selection must be **0** (1200), **1** (2400), **2** (4800), **3** (9600), **4** (19200), or **5** (38400). Resend the communication settings packet.
- 268 Word length selection must be **0** (7 bits), or **1** (8 bits). Resend the communication settings packet.
- 269 Stop bits selection must be **0** (1 bit), or **1** (2 bits). Resend the communication settings packet.
- 270 Parity selection must be **0** (none), **1** (odd), or **2** (even). Resend the communication settings packet.
- 271 Flow control selection must be **0** (none), **1** (DTR), **2** (CTS/RTS), or **3** (XON/XOFF). Resend the communication settings packet.
- 272 Symbol set (code page) in the System Setup packet must be **0** (Internal), **1** (ANSI), **2** (DOS 437), **3** (DOS 850), **4** (1250- Latin 2), **5** (1251- Cyrillic), **6** (1252- Latin 1), **7** (1253- Greek), **8** (1254- Turkish), **9** (1255- Hebrew), **10** (1256- Arabic), **11** (1257- Baltic), **12** (1258- Vietnamese), **13** (852- Latin 2), **14** (855- Russian), **15** (857- IBM Turkish), **16** (860- DOS Portuguese), **17** (Wingdings), **18** (Macintosh), or **19** (Unicode).
- 282 RS232 Trailer string is too long. Use a maximum of **3** characters.
- 283 ENQ Trailer string is too long. Use a maximum of **3** characters.
- 284 The buffer type must be **D** (Downloadable Fonts), **F** (Format), **I** (Image), **R** (Receive), **T** (Transmit), or **V** (Scalable Fonts).
- 285 The storage device type in the memory configuration packet must be **F** (flash) or **R** (volatile RAM).
- 286 The buffer size is invalid.

- 287      The printhead width must be **0**.
- 290      Action must be **0** (disable) or **1** (enable) for the backfeed control packet or the printer is active.
- 291      Dispense position must be **0**, **10** to **200** dots, or the printer is active.
- 292      Backfeed distance must be **0**, **10** to **200** dots, or the printer is active. The backfeed distance can not be greater than the dispense position.

### **Check Digit Errors**

<b>Error Code</b>	<b>Description</b>
310	Check digit scheme number must be <b>1</b> to <b>10</b> .
311	Modulus must be <b>2</b> to <b>11</b> .
314	Check digit algorithm must be <b>D</b> (sum of digits) or <b>P</b> (sum of products).

### **Graphic Errors**

<b>Error Code</b>	<b>Description</b>
325	Duplicating direction must be <b>0</b> (insert after) or <b>1</b> (insert before) in duplicate fields for graphics.
327	Amount of row adjustment must be <b>0</b> to <b>999</b> dots in duplicate fields for graphics.
328	Duplicate count must be <b>0</b> to <b>999</b> .
340	Bitmap line encoding must be <b>H</b> (hex) or <b>R</b> (run length).
350	Font selector must be <b>1</b> to <b>9999</b> .
351	Font data length must be <b>68</b> to <b>16384</b> .

- 352 Insufficient font memory is available for the downloaded font.
- 380 Job request is outside the range **0** to **4**.
- 400 The character immediately following { is invalid.
- 402 Field separator is not in the expected location.
- 403 Field separator was not found.
- 404 The number (greater than five digits/732,000), string (greater than **2710**), or tilde sequence (greater than **255**) currently being processed is out of range.
- 405 Too many fields exist in the format. You cannot have more than **200** fields in the format. Lines, boxes, and constant text fields count as fields.
- 406 Parser error. Format or graphic is already in use. Make sure your packet not missing | or {} characters.

## Communication Errors

<b>Error Code</b>	<b>Description</b>
409	The printer memory is full. Delete unnecessary formats or graphics from memory. If you are using a graphic file that is very large, consider using another mapping method (such as run length encoding) to reduce the required memory.
410	Parity on the printer does not match the parity on the host. Check the parity setting under SETUP options.

- 411 Framing error. The printer cannot communicate with the host. Make sure the host is turned on, communication cables are connected correctly, port settings are correct, and communications are active. Check the baud rate, word length, and stop bits to make sure they match those at the host. Do not toggle between Microsoft Windows and MS-DOS while using the COPY command, or you will receive a framing error. Exit Windows **before** using the COPY command. Re-transmit the data.
- 412 There is a problem with flow control between the printer and the host. Make sure the printer and the host flow control settings match (both are DTR or both are XON/XOFF). If the error persists, call Technical Support.
- 413 Online receive buffer is full. Check your printer's XON/XOFF or DTR SETUP values to be sure there is not a flow control problem.
- 414 The internal keyboard buffer is full or you need a new keypad. Call Technical Support.
- 415 The buffer size you defined exceeds the total available in your machine.
- 420 Internal software list error. Call Technical Support.
- 421 Internal software list error. Call Technical Support.
- 422 Duplicate internal name. Call Technical Support.
- 423 Internal software error. Call Technical Support.
- 424 Internal software list error. Call Technical Support.
- 425 Internal software list error. Call Technical Support.
- 426 Internal software list error. Call Technical Support.
- 427 Format name is invalid. Valid name is **1** to **8** characters inside quotes or "" for a printer-assigned name. Press the left  button and try to continue. If the error reappears, call Technical Support.

- 428 Batch name is invalid or graphic not found. Press the left  button and try to continue. If the error reappears, call Technical Support.
- 429 A field number appears more than once in a format.
- 433 The batch references a field number that does not exist in the format.
- 497 An error occurred during the loop back test on the parallel port. Call Service. Only valid for printers with a parallel port.
- 499 An error occurred during the loop back test on the serial port. Call Service.

## **Data Formatting Failures**

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Formatting errors indicate that a field will print incorrectly. After you have checked the data stream and corrected the data, retransmit the format and batch.

**Note:** For errors 571-622, the batch still prints, but the field, font, bar code, or density may be incomplete, missing or contain incorrect data.

<b>Error Code</b>	<b>Description</b>
571	UPC or EAN bar code data length is invalid. The bar code data length in the batch does not fit the format.
572	A copy field, padded field, or incrementing field length is invalid. The field length in the batch does not fit the format or the field contains blanks. Or, the fixed length field does not contain the specified number of characters.
573	Price field length is invalid. The price field length in the batch does not fit the format or the field contains blanks.
574	No CD scheme or room for CD. The CD scheme in the batch does not fit the format or the field contains blanks.

- 575 The graphic included in your format could not be found. Resend the graphic packet. If the error persists, call Technical Support.
- 600 The printer could not image the batch, because the batch was refused. Call Technical Support.
- 601 An error occurred while the batch was imaging. Resend the format, batch, font, and/or any graphic packets. If the error persists, call Technical Support.
- 603 The batch was not found while imaging. Resend the batch packet. If the error persists, call Technical Support.
- 611 Font, bar code or density is invalid. The font, bar code or density in the batch does not fit the format.
- 612 The data in this line of the batch is either missing or does not match the format.
- 613 Reference point off tag.
- 614 Portion of field off tag. There may be an invalid character in the packet. Make sure you did not enter **O** for **Ø**.
- 615 Bar code width is greater than 16 inches or the number of keywords for your PDF 417 bar code exceeds **928**. Decrease the density or shorten the amount of data to print the bar code.
- 616 A bad dot falls on a bar code and the dot cannot be shifted. A gray box is printed instead of the bar code.
- 618 Magnification must be **1** to **7** or **4** to **255** (point size) for the scalable font.
- 619 The JIS (16-bit) code for Kanji is invalid.
- 620 Font and printhead dot density mismatch. A 300 dpi font is specified in the format, but a 203 dpi printhead is used in the printer or vice-versa. Check the font or change the printhead to correct the error. Only valid for printers with a 300 dpi printhead.
- 621 An error occurred opening the TrueType font file. Select a different font to download. If the error message persists, call Technical Support.

- 622 Not enough memory to create the downloaded TrueType characters in the scalable (vector) fonts buffer. Reconfigure the printer's memory and increase the scalable (vector) fonts buffer. Resend the font, format, and batch packet after reconfiguring the memory. If the error message persists, call Technical Support.

## Machine Faults

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These errors occur when there is a problem with the printer.

<b>Error Code</b>	<b>Description</b>
703	The printer sensed a calibration of different-sized black marks. Make sure the correct supply is loaded.
704	Printer has not sensed a supply mark within the specified number of inches or out of supplies. Check the  supply tracking supply marks black mark sensor position supply roll for binding.  Press the left  button. If the error continues to appear, change the supply.
710	Band out of data. Call Technical Support.
711	UART receiving communication error (framing, parity, etc.). Call Technical Support.
712	Receiving failure or command overrun error. Call Technical Support.
713	Receiving failure or illegal command. Call Technical Support.
714	Receiving failure or undefined command. Call Technical Support.

- 730 A memory allocation error occurred during initialization.
- 750 Printhead is overheated. Turn off the printer to let the printhead cool. If the error persists, call Technical Support.
- 751 Printer did not sense a black mark when expected. The supply may be jammed. For errors 751-753, check the
- supply tracking
  - supply marks
  - black mark sensor position
  - supply roll for binding.
- Press the left  button and try to continue printing. If the error continues to appear, change the supply
- 752 Printer sensed a mark in the wrong place.
- 753 Printer sensed a mark that is too long.
- 754 Printer has a ribbon problem. Check the ribbon for a jam or remove any slack by turning the take-up reel clockwise. Load a new ribbon.
- 755 Printhead is open. Close the printhead before continuing. If the error persists, call Technical Support.
- 756 The printer is out of supplies. Load supplies.
- 757 Load supplies. The calibrated supply length differs by plus or minus .25 inches from the format. Press  to print on the current supply or load new supply and press .
- 758 Check supply. Either the supply is not seen, or the on-demand sensor is broken (purchase optional). Check for a label jam. Clear the supply path or reload supplies. This error may occur if you remove a label too quickly in on-demand mode. The printer does not recalibrate after this error.
- 762 Low battery. Recharge the battery.
- 763 Waiting to dispense label. Press .

- 766 Backfeed error. There is a problem with the backfeed or overfeed distance.
- 767 Incorrect AD value. Call Technical Support.
- 768 Printhead has more than **10** bad dots within the format area or is not connected. Make sure the printhead is connected.
- 769 The printhead is not receiving enough volts. Call Technical Support.
- 770 The print motor is not ready. Call Technical Support.
- 771 The format specified by the application was not found. Reload your application and format, and try again. If the problem continues, call Technical Support.
- 781 The voltage is too low. Call Technical Support.
- 782 The voltage is too high. Call Technical Support.
- 790 The printer is busy. Wait until the printer is idle (no batch waiting to print or not receiving data) before you send any packets. This error may occur when you try to print a test label if the printer is busy. Turn off the printer. Wait two seconds and turn it back on. Resend the packets. If the problem continues, call Technical Support.
- 791 The printer has an error pending. Turn off the printer. Wait 15 seconds and turn it back on. Resend the packets. If the problem continues, call Technical Support.
- 792 The printer is not initialized. Call Technical Support.
- 793 The printer job queue is full. Turn off the printer. Wait 15 seconds and turn it back on. Resend the packets. If the problem continues, call Technical Support.
- 794 The backfeed mode is not set.
- 795 Print engine lock-up. Call Technical Support.

## Flash Memory Errors

---

These errors occur when there a problem occurs with the printer's flash memory.

<b>Error Code</b>	<b>Description</b>
800	A directory in flash memory is full.
801	Flash memory is full.
802	A directory in flash memory cannot be found.
803	There is no directory in flash memory.
810	A file in flash memory is not open.
811	A file in flash memory is already open.
812	The file in flash memory is full.
813	You cannot access flash memory.
820	An error occurred in the flash program.
821	An error occurred while erasing flash memory.
822	There is a flash ID error.

## **Hard Printer Failure Errors**

---

These errors are hard printer failures. Call Technical Support if you receive these messages.

<b>Error Code</b>	<b>Description</b>
900	RAM test failure.
901	ROM/EPROM checksum failure.
902	Software timer failure.
903	Software interrupt failure.
904	No memory for native layer.
905	Illegal interrupt.
906	Non-maskable interrupt. Check format packet for font clear or format clear packets.
907	Low RAM error.
908	Non Volatile RAM checksum failure.
909	RAM corrupted.
910	Warm restart.

911 Version string mismatch.

**SYSTEM ERROR**    ## can be:  
**VECTOR ##**        2 Bus Error  
                      3 Address Error  
                      4 Illegal Instruction  
                      5 Zero Division  
                      6 CHK, CHK2 Instructions  
                      7 TRAP Instructions  
                      8 Privilege Violation  
                      9 Trace  
                     10 Line 1010 Emulator  
                    48 User-defined vectors (48-255)

This error is fatal. If you receive it, reset and/or reflash the printer. If the error persists, call Technical Support. If you need to return the printer, use the original packaging and this address:

Printer Systems Division, ERC  
200 Monarch Lane  
Door 39  
Miamisburg, OH 45342

930 Flash erase error.  
931 Flash write error.  
932 RAM write error.  
933 Parity error.  
934 Framing error.  
935 Buffer overrun.  
936 Invalid record type.  
937 Invalid hex data.  
938 Invalid checksum.  
939 Invalid record count.  
940 Invalid flash address.

# PRINTER OPTIMIZATION



This chapter provides information on how to improve your printer's performance by

- adjusting the print quality
- reducing the imaging time for printing
- providing general tips and hints for designing formats.

This printer uses “smart imaging” to image and print fields on supplies. Smart imaging remembers the exact boundaries and locations of each field and places a boundary box (white space) around each field. When a field changes that particular boundary box is cleared and the new field data is imaged. However, the new field data may require a larger boundary box than the previous field did. In some cases, neighboring fields that do not change may be covered with white space from the changing field's boundary box. To prevent existing fields from being covered by a changing field, see “Option 61 (Reimage Field)” in Chapter 4.

## Adjusting the Print Quality

---

Many factors affect print quality: type of supplies, print speed, print contrast, and the type of printer's application. This printer supports both thermal transfer and thermal direct supplies. The type of supply should match the printer's application.

If you want to print at high speeds, you should use premium supplies. Using premium supplies reduces smudged images, hard to read labels, and faded print. Supply type, print speed, and print contrast work together to improve the print quality of labels. Contact your Sales Representative for more information.

Select the print speed based on desired throughput and print quality. If print quality is more important, reduce the print speed, because a lower print speed increases the print quality of labels. If throughput is more important, increase the print speed as high as it will go to give you the needed print performance. See "Increasing Throughput" for more information.

If the print quality is too light or too dark, adjust the print contrast. The correct contrast setting is important because it effects how well your bar codes scan and how long the printhead lasts.

Be sure to check the print quality of bar codes with a bar code verifier or scanner. If you do not have a verifier or scanner, check the bar code visually. A bar code that is **IN SPEC** has complete bars and clear spaces. Small alphanumeric characters look complete. A bar code that is **IN SPEC** may not look as good as one that is too dark, but it does have the highest scan rate.

**Note:** For highest scan rates, make sure there is adequate white space before and after the bar code. Also, a darker bar code does not mean it will scan better.

BROADWAY SYSTEMS



DAYTON, OHIO

**Dark**

BROADWAY SYSTEMS



DAYTON, OHIO

**IN SPEC**

BROADWAY SYSTEMS



DAYTON, OHIO

**Light**

## Reducing Imaging Time

---

Imaging time is the time it takes the printer to image the data for the first label after the printer receives the format and batch packet. There are several ways to reduce the imaging time: send formats and configurations once, use a batch quantity of zero, or update batch fields.

If the formats use the same check digit scheme, you only need to send the check digit scheme once.

Send formats once and use the batch update field to change information on the label. Using a batch update field reduces the imaging time, because only the fields that change are imaged. All other fields remain the same as the last queued batch.

Use the batch quantity zero method when your application requires operator intervention to enter data. While the operator is entering data, the previous field is sent with a batch quantity of zero. The printer images the field, but does not print it. After the operator enters the data for the last field, the batch quantity can be specified. The last remaining field is imaged, and the label prints almost immediately.

To pre-image a label:

1. Send the format and a batch header in one file. The first time you send the batch header, use the parameter **N** (new batch), and the parameter **0** for (zero quantity).

*Example*            {B,1,N,0 | }

The printer images constant text, line, box, and graphic fields, but does not print them.

2. Input data for each field, and send it with a batch header using the parameter **U** (update) and a quantity of zero. When the printer receives the data, it immediately images the field, but does not print it.

*Example*            {B,1,U,0 |  
1,"RODGER DIST CTR" | }  
                      {B,1,U,0 |  
2,"8292" | }

At this time, the printer is imaging all associated fields, including fields that copy from other fields.

3. Repeat step 2 for each field except the last one.

```
{B,1,U,0 |  
3,"BROADWAY" | }  
{B,1,U,0 |  
4,"555 WEST OAK AVE." | }
```

4. For the last field, input data and send it with the quantity of labels you want printed. When the printer receives input for the last field, it immediately prints the labels.

*Example*            {B,1,U,10 |  
                      5,"DAYTON, OHIO" | }

### Increasing Throughput

Reducing the imaging time increases throughput. You can also increase the baud rate to increase the transmission time and increase throughput. Make sure the communication settings at the printer match those at the host. Using a baud rate of 19200 is almost twice as fast as 9600 baud. Using a baud rate of 38400 is almost twice as fast as 19200 baud.

## General Format Tips and Hints

---

The following tips and hints are helpful to keep in mind when designing MPCLII formats.

### With Packets

Leave parameters blank that you do not need to change when sending online configuration packets. For example, {**I**,A,,,,1 |} prints a slashed zero and uses the last sent online system setup parameters.

You can group fields with similar parameters. For example

```
T,1,10,V,250,50,1,1,1,1,B,C,0,0 |  
T,2,15,,,,75|  
T,3,,,,100|
```

The first text field sets all the parameters for that field. The second text field's number of characters and column location changes from what was defined in the first field. In the third text field, only the column location is changed. This method can be used on bar code and constant text fields as well.

**Note:** You should understand the basics of each field before using this method.

After you modify any fields or parameters with the optional entry method, resend the format, batch, or configuration packet to the printer.

### **With Bar Codes**

Be careful when rotating or placing a UPC/EAN bar code with human readable characters, because the bottom reference point is at the bottom of the bars, **not** at the bottom of the human readable characters.

### **With Fields**

Data that remains the same for each label should be in a constant text field. Data that varies for each label should be in a text field.

Check for trailing spaces in text or constant text fields if you receive a “field off tag” error. An easy way to see trailing spaces is to print the field in the reverse font.

Make sure if you magnify a field, it does not go off the label or cover another field. Magnifying a field increases the distance between the printed character and the edge of the cell.

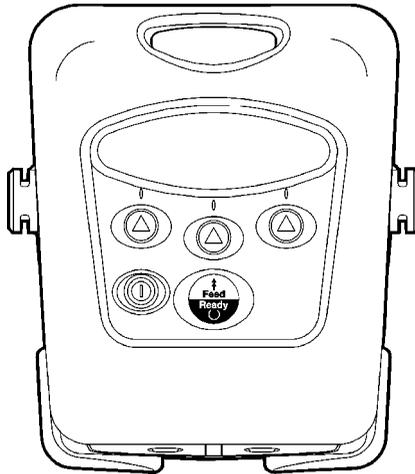


# SAMPLES



This appendix contains sample formats. You can customize any of these formats to meet your needs.

These samples are oriented as if you are looking at the keypad, watching supplies print in the feed direction shown.



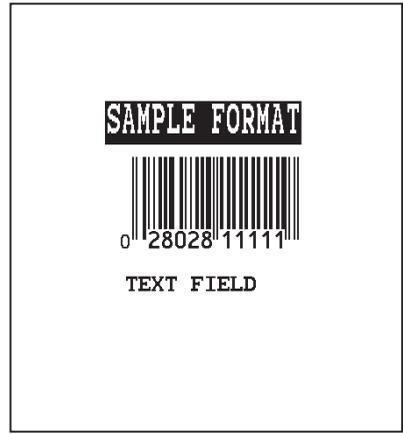
## Sample UPCA Format Packet

---

```
{F,25,A,R,E,200,200,"Fmt 25" |  
C,140,40,0,1,2,1,W,C,0,0,"SAMPLE FORMAT" |  
B,1,12,F,85,40,1,2,40,5,L,0 |  
T,2,18,V,50,50,1,3,1,1,B,L,0,0 | }
```

## Sample Batch Packet

```
{B,25,N,1 |  
1,"02802811111" |  
2,"TEXT FIELD" | }
```



## Sample MaxiCode Packets

---

MaxiCode is a two-dimensional bar code developed by UPS (United Parcel Service, Inc.). Data must be defined in a specific way for UPS. Refer to the *Guide to Bar Coding with UPS* or the *AIM MaxiCode Specification* for more details about data requirements.

The printer supports modes 0, 1, 2, and 3. Contact us for information about additional MaxiCode modes.

Mode	Description
0	Obsolete
1	Obsolete
2	Structured Message
3	Structured Message

You can select which mode to use in the bar code field or allow the printer to auto-select the mode (0, 2, or 3) based on your data. See “Defining a Bar Code Field” for more information. MaxiCode automatically pads data with the “!” character.

**Note:** MaxiCode does not support the NULL character.

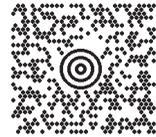
Modes 2 and 3 are defined by the way the postal code, class of service, and country code fields are arranged. (The postal code, class of service, and country code are required fields.) Begin with the message header, then the primary data (15 characters), followed by the secondary message (up to 78 characters). Or, begin with the primary data, then the message header, followed by the secondary data. If the postal code data characters are all numeric then the MaxiCode symbol is set to Mode 2. If the characters are alphanumeric, or only contain ASCII characters 65 to 90, then the MaxiCode symbol is set to Mode 3.

If you receive an error 612, check your MaxiCode data. You may have not correctly structured or left out one of the three required fields (postal code, class of service, and country code) or the “~029” character.

## Mode 0 (Obsolete) Sample

```
{F,1,A,R,E,0200,0200,"MAXICODE" |  
B,1,93,V,020,20,33,7,0,8,L,0 | }  
{B,1,N,1 |  
1,"450660000" |  
  
C,"001" |  
C,"840" |  
C,"[]~030" |  
C,"01~02996" |  
C,"1Z12345678~029" |  
C,"UPSN~029" |  
C,"12345A~029" |  
C,"070~029" |  
C,"~029" |  
C,"1/1~029" |  
C,"15~029" |  
C,"Y~029" |  
C,"60 SADDLEBROOK CT.~029" |  
C,"DAYTON~029" |  
C,"OH~030" |  
C,"~004" | }
```

MaxiCode bar code (33)  
Batch header  
Postal code- zip code  
(This field determines Mode)  
Country code  
Class of service  
Message header  
Transportation header  
Tracking number  
Origin carrier SCAC  
UPS shipper number  
Julian day of pickup  
Shipment ID (empty)  
Package count  
Weight (lb.)  
Address validation  
Street address (empty)  
City (empty)  
State  
EOT



## Mode 2 Sample

```
{F,1,A,R,E,200,200,"MAXI_M2" |
B,1,93,V,020,020,33,7,0,8,L,0 | }
{B,1,N,1 |
1,"[]>~030" |
C,"01~02996" |
C,"068100000~029" |

C,"840~029" |
C,"001~029" |
C,"1Z12345675~029" |
C,"UPSN~029" |
C,"12345E~029" |
C,"089~029" |
C,"~029" |
C,"1/1~029" |
C,"10~029" |
C,"Y~029" |
C,"~029" |
C,"~029" |
C,"CT~030" |
C,"~004" | }
```

MaxiCode bar code (33)

Message header

Transportation header

Postal Code

(This field determines Mode)

Country code

Class of service

Tracking number

Origin carrier SCAC

UPS shipper number

Julian day of pickup

Shipment ID (empty)

Package count

Weight (lb.)

Address validation

Street address (empty)

City (empty)

State

EOT



## Mode 3 Sample

```
{F,1,A,R,E,200,200,"MAXI_M3" |
B,1,93,V,020,020,33,7,0,8,L,0 | }
{B,1,N,1 |
1,"[]>~030" |
C,"01~02996" |
C,"M5E1G45~029" |

C,"124~029" |
C,"066~029" |
C,"1Z12345679~029" |
C,"UPSN~029" |
C,"12345E~029" |
C,"089~029" |
C,"~029" |
C,"1/1~029" |
C,"10~029" |
C,"Y~029" |
C,"~029" |
C,"TORONTO~029" |
C,"ON~030" |
C,"~004" | }
```

MaxiCode bar code (33)

Message header

Transportation header

Postal Code

(This field determines Mode)

Country code

Class of service

Tracking number

Origin carrier SCAC

UPS shipper number

Julian day of pickup

Shipment ID (empty)

Package count

Weight (lb.)

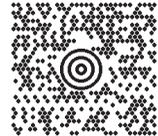
Address validation

Street address (empty)

City (empty)

State

EOT



## Sample Data Matrix Packets

---

Data Matrix (ECC-200) is a two-dimensional bar code which is made up of square modules arranged within a perimeter finder pattern. There are 24 square symbol sizes available ranging from 10 rows by 10 columns to 144 rows by 144 columns. There are six rectangular symbol sizes available ranging from 8 rows by 8 columns to 16 rows by 48 columns. The symbol size is data dependent. Data Matrix automatically pads data.

Make sure you do not overlay other fields when designing your Data Matrix symbol. Smart imaging is automatically disabled on formats with a Data Matrix bar code. You should also allow a 3 or 4 dot "quiet zone" (blank space around the bar code's perimeter) for scanning. See "Defining a Bar Code Field" for more information.

### Sample Batch Data with Special Characters

To use this character in the bar code	enter these characters in the batch data
null character	~~@
~ (tilde)	~126~126
FNC1	~~1

### Square Data Matrix Packet

```
{ F, 36, A, R, E, 400, 400, "DTMTRX1" |  
B, 1, 50, V, 50, 100, 35, 0, 100, 8, L, 0 | }
```



```
{ B, 36, N, 1 |  
1, "1234567890ABCDEFGHIJKLMNQRST" | }
```

This example prints a one-inch wide by one-inch tall (**100**) square Data Matrix symbol using the default density (**0**) without any field rotation (**0**).

### Rectangular Data Matrix Packet

```
{ F, 36, A, R, E, 400, 400, "DTMTRX2" |  
B, 1, 400, V, 100, 200, 35, 29, 50, 8, L, 1 | }
```



```
{ B, 36, N, 1 |  
1, "1234567890ABCDEFGHIJKLMNQRST" | }
```

This example prints a one-inch by a half-inch tall (**50**) rectangular 16 rows by 36 columns (density **29**) Data Matrix symbol rotated 90 (**1**).

## Sample Data Matrix with Function 1

```
{F,36,A,R,E,400,400,"DTMTRX1" |  
B,1,50,V,10,50,35,0,50,8,L,0 |}
```

```
{B,36,N,1 |  
1,"~~110012345678902" |}
```



This example prints a 0.50-inch wide by 0.50-inch tall (**50**) square Data Matrix symbol using the default density (**0**) without any field rotation (**0**). FNC1 appears in the batch data as **~~1**.

## HangTag Example

---

```
{F,1,A,R,E,275,125,"1TAG01" |  
C,228,20,0,50,8,8,A,L,0,0,"0047896320",1 |  
C,203,20,0,50,8,8,A,L,0,0,"045",1 |  
C,203,55,0,50,8,8,A,L,0,0,"12",1 |  
C,203,85,0,50,8,8,A,L,0,0,"099",1 |  
C,178,20,0,50,8,8,A,L,0,0,"00654113",1 |  
C,178,85,0,50,8,8,A,L,0,0,"1158",1 |  
C,54,37,0,50,14,14,A,L,0,0,"$49.99",1 |}
```

### Sample Batch Packet

```
{B,1,N,1|E,0,0,1,1,0,1|}
```

0047896320

045 12 099

00654113 1158

**\$49.99**

## Tag Example

---

```
{F,1,A,R,E,200,150,"1LAB1520" |  
C,44,40,0,50,9,9,A,L,0,0,"PEANUTS",1 |  
B,1,12,F,125,25,1,2,50,7,L,0 |  
R,1,"028400067362" |  
C,20,34,0,50,8,8,A,L,0,0,"*SALT FREE*",1 |  
C,84,45,0,50,14,14,A,L,0,0,"$1.19",1 |}
```

### Sample Batch Packet

```
{B,1,N,1|E,0,0,1,1,0,1|}
```



## Label Example

```
{F,1,A,R,E,300,150,"1LAB1530"!
C,100,90,0,50,10,10,A,L,0,1,"BATTERY PACK",1!
C,20,130,0,50,10,10,A,L,0,1,"1452-99311",1!
C,230,128,0,50,12,10,A,L,0,1,"$5.99",1!
B,1,9,F,75,55,4,7,40,8,L,1!
R,5,N!
R,1,"031535512"!
T,2,9,V,125,67,0,50,8,8,A,L,0,1,1!
R,4,1,1,9,1,1!}
```



## Sample Batch Packet

```
{B,1,N,1!E,0,0,1,1,0,1!
 1,"AAAAAAAAAA"!
 2,"KKKKKKKKK"!}
```

## Receipt Format Example

```
{F,1,A,R,E,300,175,"1Garage"!
C,277,15,0,50,10,18,A,L,0,0,"KRAMER'S",1!

C,223,4,0,50,8,8,A,L,0,0,"Can Opener",1!
C,202,4,0,50,8,8,A,L,0,0,"Travel Iron",1!
C,179,4,0,50,8,8,A,L,0,0,"Total",1!
C,163,81,0,50,8,8,A,L,0,0,"Tax",1!
C,140,32,0,50,8,8,A,L,0,0,"TOTAL SALE",1!
C,86,47,0,50,9,9,A,L,0,0,"* * P A I D * *",1!
C,60,45,0,50,9,9,A,L,0,0,"THANK YOU!",1!
C,256,35,0,50,10,10,A,L,0,0,"GARAGE SALE",1!
C,223,122,0,50,8,8,A,L,0,0,"$2.50",1!
C,202,122,0,50,8,8,A,L,0,0,"$1.50",1!
C,182,122,0,50,8,8,A,L,0,0,"$4.00",1!
C,163,122,0,50,8,8,A,L,0,0,"$0.26",1!
C,140,123,0,50,8,8,A,L,0,0,"$4.26",1!}
```

<b>KRAMER'S GARAGE SALE</b>	
<b>Can Opener</b>	<b>\$2.50</b>
<b>Travel Iron</b>	<b>\$1.50</b>
<b>Total</b>	<b>\$4.00</b>
<b>Tax</b>	<b>\$0.26</b>
<b>TOTAL SALE</b>	<b>\$4.26</b>
<b>** P A I D **</b>	
<b>THANK YOU!</b>	

## Sample Batch Packet

```
{B,1,N,1!E,0,0,1,1,0,1!}
```

## Label Sample 2

---

{F,1,A,R,E,110,200,"1LAB2011"}  
C,92,70,0,50,7,7,A,L,0,0,"PRETZELS",1}  
B,1,12,F,45,50,1,2,40,7,L,0}  
R,1,"028400067362"}  
C,18,105,0,50,10,10,A,L,0,0,"\$.79",1}



### Sample Batch Packet

{B,1,N,1,E,0,0,1,1,0,1}

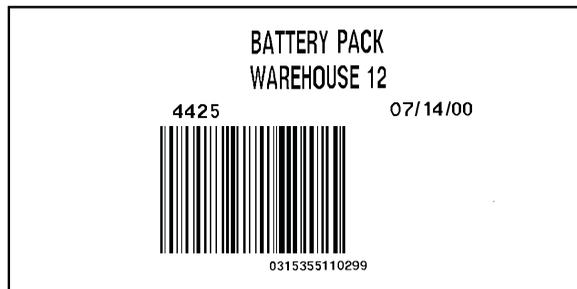
## Label Sample 3

---

{F,1,A,R,E,400,200,"1LAB2040"}  
C,150,21,0,50,14,12,A,L,0,1,"BATTERY PACK",1}  
C,150,46,0,50,14,12,A,L,0,1,"WAREHOUSE 12",1}  
C,285,70,0,50,10,10,A,L,0,1,"07/14/00",1}  
C,110,70,0,50,10,10,A,L,0,1,"4425",1}  
B,1,13,F,95,165,8,6,90,8,L,1}  
R,5,N}  
R,1,"0315355110299"}  
T,2,13,V,214,176,0,50,7,9,A,L,0,1,1}  
R,4,1,1,13,1,1}

### Sample Batch Packet

{B,1,N,1,E,0,0,1,1,0,1}  
1,"AAAAAAAAAAAAAAAA"}  
2,"KKKKKKKKKKKKKK"}  
}



# FONT S



Our printers support two types of fonts: Bitmapped (traditional printer fonts such as Standard and Reduced) and Scalable/TrueType® (Font 50). This appendix gives a brief overview of each type of font and how your printer interprets fonts. It also shows examples of the fonts loaded in your printer.

Number	Font Size and Appearance	Type of Spacing	# of Dots Between Characters
1	Standard	monospaced	3 (203 dpi) 5 (300 dpi)
2	Reduced	monospaced	1 (203 dpi) 2 (300 dpi)
3	Bold	monospaced	3 (203 dpi) 5 (300 dpi)
4	OCRA-like	monospaced	3 (203 dpi) 5 (300 dpi)
5	HR1 - only for numeric data	monospaced	2 (203 dpi) 3 (300 dpi)
6	HR2 - only for numeric data	monospaced	1 (203 dpi) 2 (300 dpi)
10	CG Triumvirate™ Typeface Bold (9 pt. at 203 dpi or 8 pt. at 300 dpi)	proportional	varies w/ each letter
11	6 pt. CG Triumvirate™ Typeface	proportional	varies w/ each letter
50	EFF Swiss Bold (TrueType®)	scalable	varies w/each letter

\* The CG Triumvirate™ typefaces support only ANSI and DOS Code Page 437 and 850 Symbol Sets. The scalable font does not support Code Page 1256 (Arabic).





## Bitmap Font Information

---

Our bitmap fonts are either monospaced (each character occupies the same amount of space) or proportional (each character is a different width). Use monospaced fonts for price fields and data you want to list in a column. With proportionally spaced fonts, you may be able to place more characters on a line. However, you may need to experiment with these fonts and adjust field measurements in your format. The bitmapped fonts (either monospaced or proportional) appear jagged when magnified. The magnification range is 1 to 7.

Use the MONARCH® MPCL™ Toolbox (Soft Font Utility), available on our Web site, to convert a bitmap font to Hex or Run-Length encoding for the printer. Select the point size and characters to print. Bitmap fonts may image faster than a TrueType font, but you are limited to the point size and characters you downloaded.

## Monospaced Font Magnification

---

Monospaced characters occupy the same amount of space within a magnification. Use monospaced fonts for price fields and data you want to list in a column. Decide how wide and tall you want the characters to appear on the labels. The following two tables show the width and height of each of the monospaced fonts after magnification.

This table includes the default (3 dots for Standard, 1 dot for Reduced, 3 dots for Bold) spacing.

Width Mag.		Standard		Reduced		Bold	
	Units	Character Width	Sample	Character Width	Sample	Character Width	Sample
1x	1/100 in.	8.37		3.9		13.3	
	1/10 mm	21.26	A	9.9	A	33.78	A
	Dots	17		8		27	
7x	1/100 in.	49.75		24.63		84.24	
	1/10 mm	126.37		62.56		214	
	Dots	101		50		171	

Only the 1x width can be scanned with the OCRA-like font. Using a printhead with 203 dpi, the character widths are as follows: 7.9 (English), 20.1 (Metric), and 16 (Dots).

To calculate other font widths, multiply the font dots (14 dots for Standard, 7 dots for Reduced, 24 dots for Bold) by the magnification and add the default spacing (3 dots for Standard, 1 dot for Reduced, 3 dots for Bold) between characters.

### B-4 Fonts

*Example*

14 (Standard font dots) x 5 (magnification) = 70 + 3 (default spacing between characters). There are 73 dots in the Standard font at 5x.

Standard	1x	<b>A</b>	7x	
1/100 in.		10.8	75.9	
1/10 mm		27.4	192.8	
dots		22	154	

Reduced	1x	<b>A</b>	7x	
1/100 in.		6.9	48.28	
1/10 mm		17.5	122.6	
dots		14	98	

Bold	1x	<b>A</b>	7x	
1/100 in.		16.7	117.24	
1/10 mm		42.4	297.8	
dots		34	238	

OCRA-like (1x only)

1/100 in.	11.8
1/10 mm	30
dots	24

**A**

## Proportional Font Magnification

Each character in a proportionally spaced font is a different height and width. You may be able to place more characters on a line using proportionally spaced fonts. You may want to experiment with these fonts and adjust field measurements in your format as needed. The bitmapped fonts (either monospaced or proportional) appear jagged when magnified. The magnification range is 1 to 7. The following tables provide height and width magnification of sample characters.

### CG Triumvirate™ Typeface Bold (9 pt.)

Width Mag.		Minimum	Average	Maximum
1x	1/100 in.	1.48	6.4	10.8
	1/10 mm	3.76	16.26	27.4
	Dots	3	13	22
		i	L	W
7x	1/100 in.	10.3	44.8	75.9
	1/10 mm	26.2	114	192.8
	Dots	21	91	154
		■	■	■

To calculate other font widths, multiply the font dots (3 dots for Minimum, 13 dots for Average, 22 dots for Maximum) by the magnification.

#### Example

13 (Average font dots) x 5 (magnification) = 65 dots in an average letter of the CG Triumvirate™ Typeface Bold at 5x.

### Height Magnification

CG Triumvirate Typeface Bold	1x	W	7x	
1/100 in.	8.87		56	
1/10 mm	22.5		158	
dots	18		126	

## CG Triumvirate Typeface (6 pt.)

Width Mag.		Minimum	Average	Maximum
1x	1/100 in.	.99	2.96	5.9
	1/10 mm	2.51 	7.52 	15 
	Dots	2	6	12
7x	1/100 in.	6.9	20.7	41.4
	1/10 mm	17.5 	52.6 	105.2 
	Dots	14	42	84

## Height Magnification

CG Triumvirate Typeface	1x	7x
1/100 in.	5.9	41.38
1/10 mm	14.99	105.1
dots	12	84

## Scalable Font Information

---

The scalable font is smooth at any point size. There are no jagged edges because the font is created from an equation every time it is used. The field width varies with each letter.

When you define formats using scalable fonts, remember to set the character rotation to **0**, because it is not supported. However, field rotation is supported for text or constant text fields using the scalable font. **The scalable font does not print a slashed zero.**

Scalable fonts perform better in constant text fields, because those fields are imaged only once per batch, not once per label as in text fields. The transparent overlay allows closer field placement when using scalable fonts.

To use large point sizes (greater than 60), you must reconfigure memory and increase the size of the scalable (vector) fonts buffer.

The height and width magnification are defined in point size. 72 points = one inch. One inch = cell size. The cell size is the built-in space around the individual characters of the scalable font. The point size range is **4** to **255**. If the height and width are not set to the same point size, the printed characters look tall and thin or short and thick, which allows for greater flexibility in the appearance of the font.

The 72 point EFF Swiss Bold sample shows the one inch cell size.

6pt      Sample

10pt    Sample

24pt    Sample

48pt    Sample

---

72pt    Sample      1"

---

## **TrueType Font Information**

---

TrueType fonts follow the TrueType outline font standard. These fonts are smooth at any point size. There are no jagged edges, because the font is created from an equation every time it is used. The height and width magnification are defined in point size. 72 points = one inch. One inch = cell size. The cell size is the built-in space around the individual characters of the scalable font. The point size range is **4** to **255**. The field width varies with each letter. The printer can accept downloaded TrueType fonts.

## **Downloading TrueType Fonts**

---

The MONARCH® MPCL™ Toolbox (Font Utility) is available on our Web site and converts TrueType fonts to Hex or Run-Length encoding for the printer.

When downloading a TrueType font, you download the entire font, not particular characters or one point size. You can print a variety of symbol sets with International (Turkish, Latin, Spanish, etc.) characters. TrueType fonts are designed to be regionally specific; therefore, all symbol sets may not be supported in a given font.

These font files are large and may image slower than bitmap fonts. The size of the font file, in bytes, is the minimum amount of memory you must have available for fonts in the printer's downloadable fonts buffer.

You may need to reallocate memory to use downloaded TrueType fonts. After reallocating memory, resend the font, format, and batch packets. See "Defining the Memory Configuration Packet" in Chapter 2 for more information. Also, Chapter 2 lists some special considerations when defining memory for downloaded TrueType fonts.

## Using International Fonts

---

International fonts are available as bitmap or TrueType fonts. See "Bitmap Font Information" or "TrueType Font Information" for more details. To use these fonts, you must purchase the memory expansion option and download the font to the printer.

To use International fonts, consider the following information:

All fonts contain an internal character mapping. The mapping is organized by one or more standards, such as BIG5. These mapping standards can provide over 65,000 characters, which are not represented in this manual.

The printer supports several mapping standards:

Unicode (UCS-2)

BIG5

GB2312

SJIS

Specify a symbol set based on the characters to print and one that is compatible with the font's character mapping. For example, to print Japanese characters, select symbol set 932 (Japanese Shift JIS) and a font compatible with that symbol set. See "Selecting a Symbol Set" for more information.

To enter batch data, use the method specified by the font's character mapping and a compatible symbol set.

## Selecting a Symbol Set

Specify a symbol set based on the characters to print and one that is compatible with the font's character mapping. The symbol set parameter identifies the character mapping used in the text field or constant text field, for example, Unicode, BIG5, etc. If no symbol set is selected, the default symbol set (Internal Symbol Set) is used.

The printer automatically translates some character mappings to others. For example, if you need a BIG5 font, it is possible to use Unicode text data. Use Unicode in the symbol set parameter to indicate the text mapping and select the BIG5 font needed in the font parameter (T8 or C5). The printer automatically translates the Unicode character values into BIG5 values before printing the character.

The following table lists the compatible mappings and symbol sets.

Font Character Mapping		Symbol Set Parameter (T15, C13, or A6)
Batch Data*	TrueType Font Character Mapping	use in text or constant text fields
Unicode	BIG5	102 - Unicode If you are unsure which character mapping to select, use this symbol set, because the printer automatically translates the character mappings.
Unicode	SJIS	
Unicode	KSC5601	
Unicode	GB2312	
Unicode	Unicode	

\* Characters in batch data must be entered based on their mapping (Unicode, BIG5, etc.).

**Note:** Symbol set 102 requires a downloaded International TrueType font.

## International Font Sample

```
{F,3,A,R,E,150,200,"SIMPLE" |  
T,1,5,V,10,10,0,100,30,30,B,L,0,0,102 | }
```

Symbol Set Parameter

```
{B,3,U,1 |  
1,"~125~000~125~002~125~004~125~005" | }
```

FontNumber

This example prints these four characters with Unicode batch data of ~125~000, ~125~002, ~125~004 and ~125~005.

紀 紂 約 紅

Refer to the Internet for a listing of the characters in each code page. Search on a particular code page, such as "codepage 936" to view the characters in that code page.

## Licensing Your Fonts

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We provide you with tools to create and download TrueType fonts. However, it is your responsibility to purchase and license any fonts you download to your printer. Contact your font supplier for licensing information. Additional fonts that are compatible with the printer can be purchased from:

The Electronic Font Foundry  
11 Silwood Road; Ascot; SL5 OPY; England  
(0)1344 875 201  
[www.eff.co.uk](http://www.eff.co.uk)

Korean, Chinese, and Japanese fonts can be purchased from:

Dynalab Inc.  
2055 Gateway Place; Suite 400; San Jose, CA 95110  
408-490-4224  
[www.dynalab.com](http://www.dynalab.com)





# SYMBOL SETS/CODE PAGES



This appendix contains a listing of the symbol sets, code pages, and extended character sets the printer supports.

Use the charts in this appendix to convert dot sequences from the image dot pattern to codes you can use in the fields. Use the Binary to Hex Conversion Chart to convert Binary dot sequences to Hexadecimal numbers for bitmap files. Use the Dot to Run Length Encoding Chart to convert dot sequences to alphabetic characters for bitmap files.

## **Supported Symbol Sets and Code Pages**

---

The printers support these symbol sets and code pages: Internal, ANSI, Bold, OCRA Character Set, DOS Code Page 437 and 850. Additional Code Pages are supported with downloaded TrueType or Unicode (double-byte) fonts.

The printer defaults to the internal symbol set. See “Defining the System Setup Packet” in Chapter 2 to change the symbol set.

### **Selecting a Symbol Set or Code Page**

The CG Triumvirate™ typefaces support only the ANSI and DOS Code Page 437 and 850 Symbol Sets. These fonts print a slashed zero when using the ANSI symbol set.

<b>Internal</b>	Use this symbol set to print international monetary symbols, the trademark (™) symbol, and for formats that may be used on other MPCLII printers.
<b>ANSI</b>	Use this symbol set with proportionally spaced fonts.
<b>DOS Code Pages 437 or 850</b>	Use this symbol set for extended and international characters with proportionally spaced fonts.

## Using Code 128 Function Codes

---

This table lists the characters for Bar Code 128 function codes. These functions are used with scanners.

Code	Function Code
~201	F1
~202	F2
~203	F3
~204	F4

## Entering Extended Characters

---

When using extended characters in your batch data file, type a tilde in front of the three-digit code. For example, if you want to include the character Å in a text field using the Internal Symbol Set, type:

1, "~142" |

## Using International Character Sets/Code Pages

---

Symbol sets 852-860, and 1250-1258 may only be used with the scalable font (font#50) or downloaded TrueType fonts. TrueType fonts are designed to be regionally specific; therefore, all symbol sets may not be supported in a given font. For example, to print Hebrew characters, you need to find a font (such as Arial) that supports Hebrew characters; convert, and then download the font to your printer. Make sure the correct symbol set for Hebrew characters is selected.

Font 50 does not print the slashed zero or support Code Page 1256 (Arabic). The Euro-dollar symbol at position ~192 is only available in the Standard, Reduced, and Bold fonts.

Code page 102 contains thousands of characters, which are not represented in this manual. These code pages require additional memory and a downloaded International TrueType font.

The Code Pages (437 and greater) on the following pages were printed using Arial or a similar downloaded TrueType font. To determine the character code, add the column number and row number for the character. For example, to produce the ÿ character with the ANSI character set, you would press Alt 255 (column 15 + row 240).



## ANSI Symbol Set

240	ð	ñ	ò	ó	ô	õ	ö	÷	ø	ù	ú	û	ü	ý	þ	ÿ
224	à	á	â	ã	ä	å	æ	ç	è	é	ê	ë	ì	í	î	ï
208	Ð	Ñ	Ò	Ó	Ô	Õ	Ö	×	Ø	Ù	Ú	Û	Ü	Ý	Þ	ÿ
192	À	Á	Â	Ã	Ä	Å	Æ	Ç	È	É	Ê	Ë	Ì	Í	Î	Ï
176	°	±	²	³	´	µ	¶	·	¸	¹	º	»	¼	½	¾	¿
160	¡	¢	£	¤	¥	¦	§	¨	©	ª	«	¬	­	®	¯	
144	‘	’														
128																
112	p	q	r	s	t	u	v	w	x	y	z	{		}	~	⌘
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n	o
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^	_
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	>	?
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/	
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

## Bold Character Set

240																
224																
208																
192	€															
176	\$	£	¥	¤	¢	₹	₠	₡	₢	₣	₤	₥	₦	₧	₨	₪
160												½				
144												¢				
128																
112																
96																
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^	_
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	>	?
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/	
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

# OCRA Character Set

240																
224																
208																
192																
176	¢	£	¥	¤	F	P	L	K	¤	¢	£	¤	¥			
160																
144										◊						
128																
112																
96																
80	P	Q	R	S	T	U	V	W	X	Y	Z					
64	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	
48	0	1	2	3	4	5	6	7	8	9	<	>				
32		"	¢	£						+	-	.	/			
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

# Code Page 437 (Latin U.S.)

240	≡	±	≥	≤			÷	≈	°	.	.	√	n	²	■	
224	α	β	Γ	π	Σ	σ	μ	τ	Φ	Θ	Ω	δ	∞	φ	ε	∩
208	⊥	⊞	⊠	⊡	⊢	⊣	⊤	⊥	⊦	⊧	⊨	⊩	⊪	⊫	⊬	⊭
192	L	⊥	⊤	⊢	⊣	⊤	⊥	⊦	⊧	⊨	⊩	⊪	⊫	⊬	⊭	⊮
176	⊞	⊠	⊡		⊢	⊣	⊤	⊥	⊦	⊧	⊨	⊩	⊪	⊫	⊬	⊭
160	á	í	ó	ú	ñ	Ñ	ª	º	¿	¬	¼	½	¾	¡	«	»
144	É	æ	Æ	ô	ö	ò	û	ù	ÿ	Ö	Ü	¢	£	¥	Ps	f
128	Ç	ü	é	â	ä	à	â	ç	ê	ë	è	ï	î	í	Ä	Å
112	p	q	r	s	t	u	v	w	x	y	z	{		}	~	
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n	o
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^	_
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	>	?
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/	
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

## Code Page 850 (Latin 1)

240	-	±	=	¾	¶	§	÷	,	°	¨	·	¹	³	²	■	
224	Ó	ß	Ô	Ò	ö	Õ	µ	þ	ƒ	Ú	Û	Ü	ý	Ý	´	
208	ø	Ð	Ê	Ë	È	Í	Î	Ï	Ɔ	Ɔ	■	■	ı	ı	■	
192	Ł	ł	Ť	ť	-	†	ã	Ã	Ł	ł	Ł	ł	Ł	ł	Ł	
176	■	■	■		†	Á	Â	À	©	¶	¶	¶	¶	¶	¶	
160	á	í	ó	ú	ñ	Ñ	ª	º	¿	®	¬	½	¼	ı	«	
144	É	æ	Æ	ô	ö	ò	û	ù	ÿ	Ö	Ü	ø	£	Ø	×	
128	Ç	ü	é	â	ä	à	å	ç	ê	ë	è	ï	î	ì	Ä	
112	p	q	r	s	t	u	v	w	x	y	z	{		}	~	
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n	
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^	
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N	
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	>	
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/	
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

## Code Page 852 (Latin 2)

240	-	˘	ˇ	ˇ	§	÷	,	°	¨	·	ú	Ř	ř	■		
224	Ó	ß	Ô	Ń	ń	ň	Š	š	Ř	Ú	ř	Û	ý	Ý	ť	
208	đ	Ð	Ď	Ě	ď	Ň	í	î	ě	Ɔ	Ɔ	■	■	Ť	Ú	
192	Ł	ł	Ť	ť	-	†	Ǻ	ǻ	Ł	ł	Ł	ł	Ł	ł	Ł	
176	■	■	■		†	Á	Â	Ě	§	¶	¶	¶	¶	¶	¶	
160	á	í	ó	ú	Ǻ	ǻ	Ž	ž	Ę	ę	¬	ż	Č	š	«	
144	É	Ł	Í	ô	ö	ł	ł	Ś	ś	Ö	Ü	Ť	ť	ł	×	
128	Ç	ü	é	â	ä	û	ć	ç	ł	ë	Ö	ó	î	Ž	Ä	
112	p	q	r	s	t	u	v	w	x	y	z	{		}	~	
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n	
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^	
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N	
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	>	
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/	
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

## Code Page 855 (Russian)

240	-	ы	Ы	з	З	ш	Ш	э	Э	щ	Щ	ч	Ч	§	■
224	Я	я	Р	С	Т	У	У	Ж	Ж	В	В	Ь	Ь	№	
208	л	Л	М	М	н	Н	о	О	п	┘	Г	■	■	П	Я
192	┘	┘	┘	┘	┘	┘	┘	┘	┘	┘	┘	┘	┘	┘	┘
176	■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
160	а	А	б	Б	ц	Ц	д	Д	е	Е	ф	Ф	г	Г	«
144	ь	Ь	ъ	Ъ	ћ	Ѓ	ќ	Ќ	ђ	Ђ	ю	Ю	ъ	Ъ	
128	ђ	Ђ	ѓ	Ѓ	ё	Ё	є	Є	ѕ	Ѕ	і	І	ї	Ї	ј
112	р	q	r	s	t	u	v	w	x	y	z	{		}	~
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	>
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/
16															
0															
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14

## Code Page 857 (IBM Turkish)

240	-	±	¾	¶	§	÷	,	°	¨	.	1	3	2	■
224	Ó	ß	Ô	Ò	õ	Õ	μ	×	Ú	Û	Ü	ı	ÿ	˘
208	°	ª	Ê	Ë	È	Í	Î	Ï	┘	Г	■	■	ı	İ
192	┘	┘	┘	┘	┘	┘	┘	┘	┘	┘	┘	┘	┘	┘
176	■	■	■	■	■	■	■	■	■	■	■	■	■	■
160	á	í	ó	ú	ñ	Ñ	Ğ	ğ	ı	®	¼	¼	ı	«
144	É	æ	Æ	ô	ö	ò	û	ù	İ	Ö	Ü	ø	£	Ø
128	Ç	ü	é	â	ä	à	â	ç	ê	ë	è	ï	î	ı
112	ř	q	r	s	t	u	v	w	x	y	z	{		}
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.
16														
0														
	0	1	2	3	4	5	6	7	8	9	10	11	12	13

## Code Page 860 (MS-DOS Portuguese)

240	≡	±	≥	≤	[	]	÷	≈	°	.	·	√	n	²	■	
224	α	β	Γ	π	Σ	σ	μ	τ	Φ	Θ	Ω	δ	∞	φ	ε	∩
208	⊥	⊞	⊠	⊡	⊢	⊣	⊤	⊥	⊦	⊧	⊨	⊩	⊪	⊫	⊬	
192	L	⊥	T	⊥	⊥	⊥	⊥	⊥	⊥	⊥	⊥	⊥	⊥	⊥	⊥	
176	⊠	⊡	⊢	⊣	⊤	⊥	⊦	⊧	⊨	⊩	⊪	⊫	⊬	⊭	⊮	
160	á	í	ó	ú	ñ	Ñ	ª	º	¿	Ò	¬	½	¼	¡	«	»
144	É	À	È	ô	õ	ò	Ú	ù	Ì	Ö	Ü	£	Ù	Ps	Ó	
128	Ç	ü	é	â	ã	à	Á	ç	ê	Ê	è	Í	Ô	ì	Ã	Â
112	p	q	r	s	t	u	v	w	x	y	z	{		}	~	
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n	o
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^	_
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	>	?
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/	
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

## Code Page 1250 (Latin 2)

240	đ	ń	ň	ó	ô	õ	÷	ř	ů	ú	ů	ü	ý	ţ	·	
224	í	á	â	ă	ä	í	ć	ç	č	é	ę	ë	ě	í	î	d'
208	Đ	Ń	Ň	Ó	Ô	Õ	×	Ř	Ů	Ú	Ů	Ü	Ý	Ț	β	
192	Ŕ	Á	Â	Ă	Ä	Í	Ć	Ç	Č	É	Ę	Ë	Ě	Í	Î	Ď
176	°	±	·	ł	´	μ	¶	·	·	ą	ś	»	Ł	”	ł	ż
160	˘	˘	ł	×	Ą	!	§	·	·	©	§	«	¬	-	®	Ż
144	\	'	"	"	•	—	—	™	š	>	ś	ł	ż	ż	ż	
128	€	,	„	„	...	†	‡	‰	Š	<	Ś	Ŧ	Ž	Ž	Ž	
112	p	q	r	s	t	u	v	w	x	y	z	{		}	~	
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n	o
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^	_
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	>	?
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/	
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

## Code Page 1251 (Cyrillic)

240	р	с	т	у	ф	х	ц	ч	ш	щ	ъ	ы	ь	э	ю	я
224	а	б	в	г	д	е	ж	з	и	й	к	л	м	н	о	п
208	Р	С	Т	У	Ф	Х	Ц	Ч	Ш	Щ	Ъ	Ы	Ь	Э	Ю	Я
192	А	Б	В	Г	Д	Е	Ж	З	И	Й	К	Л	М	Н	О	П
176	°	±	І	і	Ҁ	μ	¶	·	ё	№	є	»	ј	Ѕ	ѕ	ї
160	Ў	ў	Ј	ј	Ґ	ґ	§	Є	©	€	«	¬	-	®	İ	
144	ћ	`	'	"	"	•	-	-	™	љ	>	њ	ќ	ћ	џ	
128	Ђ	ђ	,	ѓ	„	…	†	‡	€	‰	Љ	<	Њ	Ќ	џ	
112	p	q	r	s	t	u	v	w	x	y	z	{		}	~	
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n	o
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^	_
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	>	?
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/	
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

## Code Page 1252 (Latin 1)

240	ð	ñ	ò	ó	ô	õ	ö	÷	ø	ù	ú	û	ü	ý	þ	ÿ
224	à	á	â	ã	ä	å	æ	ç	è	é	ê	ë	ì	í	î	ï
208	Ð	Ñ	Ò	Ó	Ô	Õ	Ö	×	Ø	Ù	Ú	Û	Ü	Ý	Þ	ÿ
192	À	Á	Â	Ã	Ä	Å	Æ	Ç	È	É	Ê	Ë	Ì	Í	Î	Ï
176	°	±	²	³	´	μ	¶	·	¸	¹	º	»	¼	½	¾	¿
160	ı	¢	£	¤	¥	¦	§	¨	©	ª	«	¬	-	®	¯	
144	`	'	"	"	•	-	-	~	™	š	>	œ	ž	ÿ		
128	€	,	f	„	…	†	‡	^	‰	Š	<	Œ	Ž			
112	p	q	r	s	t	u	v	w	x	y	z	{		}	~	
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n	o
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^	_
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	>	?
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/	
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

## Code Page 1253 (Greek)

240	π	ρ	ς	σ	τ	υ	φ	χ	ψ	ω	ï	ü	ó	ú	ώ
224	Û	α	β	γ	δ	ε	ζ	η	θ	ι	κ	λ	μ	ν	ξ ο
208	Π	Ρ		Σ	Τ	Υ	Φ	Χ	Ψ	Ω	Ï	ÿ	ά	έ	ή ι
192	Ï	Α	Β	Γ	Δ	Ε	Ζ	Η	Θ	Ι	Κ	Λ	Μ	Ν	Ξ Ο
176	°	±	²	³	´	μ	¶	·	¸	¹	º	»	¼	½	¾ Υ Ω
160	ˆ	À	£	¤	¥	¦	§	¨	©	ª	«	¬	-	®	—
144	`	'	"	"	•	-	-	™	>						
128	€	,	f	„	…	†	‡	‰	<						
112	p	q	r	s	t	u	v	w	x	y	z	{		}	~
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n o
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^ _
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N O
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	> ?
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/
16															
0															
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14 15

## Code Page 1254 (Turkish)

240	ğ	ñ	ò	ó	ô	õ	ö	÷	ø	ù	ú	û	ü	ı	ş	ÿ
224	à	á	â	ã	ä	å	æ	ç	è	é	ê	ë	ì	í	î	ï
208	Ğ	Ñ	Ò	Ó	Ô	Õ	Ö	×	Ø	Ù	Ú	Û	Ü	İ	Ş	ß
192	À	Á	Â	Ã	Ä	Å	Æ	Ç	È	É	Ê	Ë	Ì	Í	Î	Ï
176	°	±	²	³	´	μ	¶	·	¸	¹	º	»	¼	½	¾	¿
160	ı	ç	£	¤	¥	¦	§	¨	©	ª	«	¬	-	®	—	
144	`	'	"	"	•	-	-	~	™	š	>	œ			ÿ	
128	€	,	f	„	…	†	‡	^	‰	Š	<	Œ				
112	p	q	r	s	t	u	v	w	x	y	z	{		}	~	
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n o	
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^ _	
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N O	
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	> ?	
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/	
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14 15	



## Code Page 1257 (Baltic)

240	š	ń	ņ	ó	ō	õ	ö	÷	ų	ł	ś	ū	ü	ž	ž	.
224	ą	į	ā	ć	ä	ā	ę	ē	č	é	ž	ė	ğ	ķ	ī	ļ
208	Š	Ń	Ņ	Ó	Ō	Õ	Ö	×	Ų	Ł	Ś	Ū	Ü	Ž	Ž	β
192	Ą	Į	Ā	Ć	Ä	Ā	Ę	Ē	Č	É	Ž	Ė	Ğ	Ķ	Ī	Ļ
176	°	±	²	³	´	μ	¶	·	ø	¹	²	»	¼	½	¾	æ
160		¢	£	¤	¥	¦	§	¨	©	ª	«	¬	-	®	¯	Æ
144	`	'	"	"	•	-	-	™	>							
128	€	,	„	...	†	‡	‰	‰	<	ˆ	˜	˘	˙	˚	˛	˜
112	p	q	r	s	t	u	v	w	x	y	z	{		}	~	
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n	o
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^	_
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	>	?
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/	
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

## Code Page 1258 (Vietnamese)

240	đ	ñ	.	ó	ô	ơ	ö	÷	ø	ù	ú	û	ü	ư	đ	ÿ
224	à	á	â	ã	ä	å	æ	ç	è	é	ê	ë	í	î	ï	
208	Đ	Ñ	.	Ó	Ô	Ơ	Ö	×	Ø	Ù	Ú	Û	Ü	Ư	~	β
192	À	Á	Â	Ã	Ä	Å	Æ	Ç	È	É	Ê	Ë	Í	Î	Ï	
176	°	±	²	³	´	μ	¶	·	ø	¹	º	»	¼	½	¾	¿
160		¢	£	¤	¥	¦	§	¨	©	ª	«	¬	-	®	¯	ÿ
144	`	'	"	"	•	-	-	™	>	œ						
128	€	,	f	„	...	†	‡	‰	‰	<	ˆ	˜	˘	˙	˚	˛
112	p	q	r	s	t	u	v	w	x	y	z	{		}	~	
96	`	a	b	c	d	e	f	g	h	i	j	k	l	m	n	o
80	P	Q	R	S	T	U	V	W	X	Y	Z	[	\	]	^	_
64	@	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O
48	0	1	2	3	4	5	6	7	8	9	:	;	<	=	>	?
32	!	"	#	\$	%	&	'	(	)	*	+	,	-	.	/	
16																
0																
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

## ASCII to Hexadecimal Conversion Chart

---

Use the chart below to translate the characters printed on your test label. The chart lists ASCII characters and their hexadecimal and decimal equivalents.

Char.	Hex	Decimal	Char.	Hex	Decimal
NUL	00	0	DC2	12	18
SOH	01	1	DC3	13	19
STX	02	2	DC4	14	20
ETX	03	3	NAK	15	21
EOT	04	4	SYN	16	22
ENQ	05	5	ETB	17	23
ACK	06	6	CAN	18	24
BEL	07	7	EM	19	25
Backspace	08	8	SUB	1A	26
Tab	09	9	Escape	1B	27
linefeed	0A	10	cursor right	1C	28
home	0B	11	cursor left	1D	29
form feed	0C	12	cursor up	1E	30
carriage return	0D	13	cursor down	1F	31
SO	0E	14	space	20	32
SI	0F	15	!	21	33
DLE	10	16	"	22	34
DC1	11	17	#	23	35

## ASCII to Hexadecimal Conversion Chart (continued)

Char.	Hex	Decimal	Char.	Hex	Decimal
\$	24	36	;	3B	59
%	25	37	<	3C	60
&	26	38	=	3D	61
'	27	39	>	3E	62
(	28	40	?	3F	63
)	29	41	@	40	64
*	2A	42	A	41	65
++	2B	43	B	42	66
,	2C	44	C	43	67
-	2D	45	D	44	68
.	2E	46	E	45	69
/	2F	47	F	46	70
0	30	48	G	47	71
1	31	49	H	48	72
2	32	50	I	49	73
3	33	51	J	4A	74
4	34	52	K	4B	75
5	35	53	L	4C	76
6	36	54	M	4D	77
7	37	55	N	4E	78
8	38	56	O	4F	79
9	39	57	P	50	80
:	3A	58	Q	51	81

## ASCII to Hexadecimal Conversion Chart (continued)

Char.	Hex	Decimal	Char.	Hex	Decimal
R	52	82	i	69	105
S	53	83	j	6A	106
T	54	84	k	6B	107
U	55	85	l	6C	108
V	56	86	m	6D	109
W	57	87	n	6E	110
X	58	88	o	6F	111
Y	59	89	p	70	112
Z	5A	90	q	71	113
[	5B	91	r	72	114
\	5C	92	s	73	115
]	5D	93	t	74	116
^^	5E	94	u	75	117
_	5F	95	v	76	118
`	60	96	w	77	119
a	61	97	x	78	120
b	62	98	y	79	121
c	63	99	z	7A	122
d	64	100	{	7B	123
e	65	101		7C	124
f	66	102	}	7D	125
g	67	103	~	7E	126
h	68	104	delete	7F	127

## Binary to Hex Conversion Chart

---

Binary	Hex	Binary	Hex
00000000	00	00100000	20
00000001	01	00100001	21
00000010	02	00100010	22
00000011	03	00100011	23
00000100	04	00100100	24
00000101	05	00100101	25
00000110	06	00100110	26
00000111	07	00100111	27
00001000	08	00101000	28
00001001	09	00101001	29
00001010	0A	00101010	2A
00001011	0B	00101011	2B
00001100	0C	00101100	2C
00001101	0D	00101101	2D
00001110	0E	00101110	2E
00001111	0F	00101111	2F
00010000	10	00110000	30
00010001	11	00110001	31
00010010	12	00110010	32
00010011	13	00110011	33
00010100	14	00110100	34
00010101	15	00110101	35
00010110	16	00110110	36
00010111	17	00110111	37
00011000	18	00111000	38
00011001	19	00111001	39
00011010	1A	00111010	3A
00011011	1B	00111011	3B
00011100	1C	00111100	3C
00011101	1D	00111101	3D
00011110	1E	00111110	3E
00011111	1F	00111111	3F

## Binary to Hexadecimal Conversion Chart (continued)

<b>Binary</b>	<b>Hex</b>	<b>Binary</b>	<b>Hex</b>
01000000	40	01100000	60
01000001	41	01100001	61
01000010	42	01100010	62
01000011	43	01100011	63
01000100	44	01100100	64
01000101	45	01100101	65
01000110	46	01100110	66
01000111	47	01100111	67
01001000	48	01101000	68
01001001	49	01101001	69
01001010	4A	01101010	6A
01001011	4B	01101011	6B
01001100	4C	01101100	6C
01001101	4D	01101101	6D
01001110	4E	01101110	6E
01001111	4F	01101111	6F
01010000	50	01110000	70
01010001	51	01110001	71
01010010	52	01110010	72
01010011	53	01110011	73
01010100	54	01110100	74
01010101	55	01110101	75
01010110	56	01110110	76
01010111	57	01110111	77
01011000	58	01111000	78
01011001	59	01111001	79
01011010	5A	01111010	7A
01011011	5B	01111011	7B
01011100	5C	01111100	7C
01011101	5D	01111101	7D
01011110	5E	01111110	7E
01011111	5F	01111111	7F

## Binary to Hexadecimal Conversion Chart (continued)

<b>Binary</b>	<b>Hex</b>	<b>Binary</b>	<b>Hex</b>
10000000	80	10100000	A0
10000001	81	10100001	A1
10000010	82	10100010	A2
10000011	83	10100011	A3
10000100	84	10100100	A4
10000101	85	10100101	A5
10000110	86	10100110	A6
10000111	87	10100111	A7
10001000	88	10101000	A8
10001001	89	10101001	A9
10001010	8A	10101010	AA
10001011	8B	10101011	AB
10001100	8C	10101100	AC
10001101	8D	10101101	AD
10001110	8E	10101110	AE
10001111	8F	10101111	AF
10010000	90	10110000	B0
10010001	91	10110001	B1
10010010	92	10110010	B2
10010011	93	10110011	B3
10010100	94	10110100	B4
10010101	95	10110101	B5
10010110	96	10110110	B6
10010111	97	10110111	B7
10011000	98	10111000	B8
10011001	99	10111001	B9
10011010	9A	10111010	BA
10011011	9B	10111011	BB
10011100	9C	10111100	BC
10011101	9D	10111101	BD
10011110	9E	10111110	BC
10011111	9F	10111111	BF

## Binary to Hexadecimal Conversion Chart (continued)

Binary	Hex	Binary	Hex
11000000	C0	11100000	E0
11000001	C1	11100001	E1
11000010	C2	11100010	E2
11000011	C3	11100011	E3
11000100	C4	11100100	E4
11000101	C5	11100101	E5
11000110	C6	11100110	E6
11000111	C7	11100111	E7
11001000	C8	11101000	E8
11001001	C9	11101001	E9
11001010	CA	11101010	EA
11001011	CB	11101011	EB
11001100	CC	11101100	EC
11001101	CD	11101101	ED
11001110	CE	11101110	EE
11001111	CF	11101111	EF
11010000	D0	11110000	F0
11010001	D1	11110001	F1
11010010	D2	11110010	F2
11010011	D3	11110011	F3
11010100	D4	11110100	F4
11010101	D5	11110101	F5
11010110	D6	11110110	F6
11010111	D7	11110111	F7
11011000	D8	11111000	F8
11011001	D9	11111001	F9
11011010	DA	11111010	FA
11011011	DB	11111011	FB
11011100	DC	11111100	FC
11011101	DD	11111101	FD
11011110	DE	11111110	FE
11011111	DF	11111111	FF

## Dot to Run Length Encoding Chart

---

### ON (Black) Dots

# of Dots	Code	# of Dots	Code
1	A	14	N
2	B	15	O
3	C	16	P
4	D	17	Q
5	E	18	R
6	F	19	S
7	G	20	T
8	H	21	U
9	I	22	V
10	J	23	W
11	K	24	X
12	L	25	Y
13	M	26	Z

### OFF (White Dots)

# of Dots	Code	# of Dots	Code
1	a	14	n
2	b	15	o
3	c	16	p
4	d	17	q
5	e	18	r
6	f	19	s
7	g	20	t
8	h	21	u
9	i	22	v
10	j	23	w
11	k	24	x
12	l	25	y
13	m	26	z

# FORMAT DESIGN TOOLS



Use copies of these worksheets and grids to create formats, batch data, and check digit schemes. You may want to keep copies of the completed forms for your records:

Online Configuration Worksheet

Batch Worksheet

Check Digit Worksheet

Supply Layout Grids (English, Metric, Dots)

Format Worksheet

Sample Format Worksheet

# Online Configuration Worksheet

## ONLINE HEADER

<b>I</b>	HEADER
----------	--------

## SYSTEM SETUP

<b>A</b>	HEADER
	POWERUP MODE
	LANGUAGE
	SEPARATOR
	SLASH ZERO
	SYMBOL SET

## SUPPLY SETUP

<b>B</b>	HEADER
	SUPPLY TYPE
	PRINTHEAD ENERGY
	FEED MODE
	SUPPLY POSN

## PRINT CONTROL

<b>C</b>	HEADER
	CONTRAST
	PRINT ADJUST
	MARGIN ADJUST
	SPEED ADJUST
	PRINTHD WIDTH

## MONETARY FORMATTING

<b>D</b>	HEADER
	CURRENCY SYMBOL
	SECONDARY
	DECIMALS

## CONTROL CHARACTERS

<b>F</b>	HEADER
	START OF HEADER
	PARAMETER SEPARATOR
	CHAR. STRING
	FIELD SEPARATOR
	END OF TRANSMISSION
	DATA ESCAPE
	IMMED. COMMAND
	STATUS REQUEST
	JOB REQUEST

## COMMUNICATION SETUP

<b>H</b>	HEADER
	BAUD
	WORD LENGTH
	STOP BITS
	PARITY
	FLOW CONTROL

## BACK FEED CONTROL

<b>G</b>	HEADER
	ACTION
	DISPENSE POSITION
	BACK FEED DISTANCE

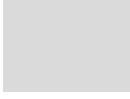
## BUFFER ALLOCATION

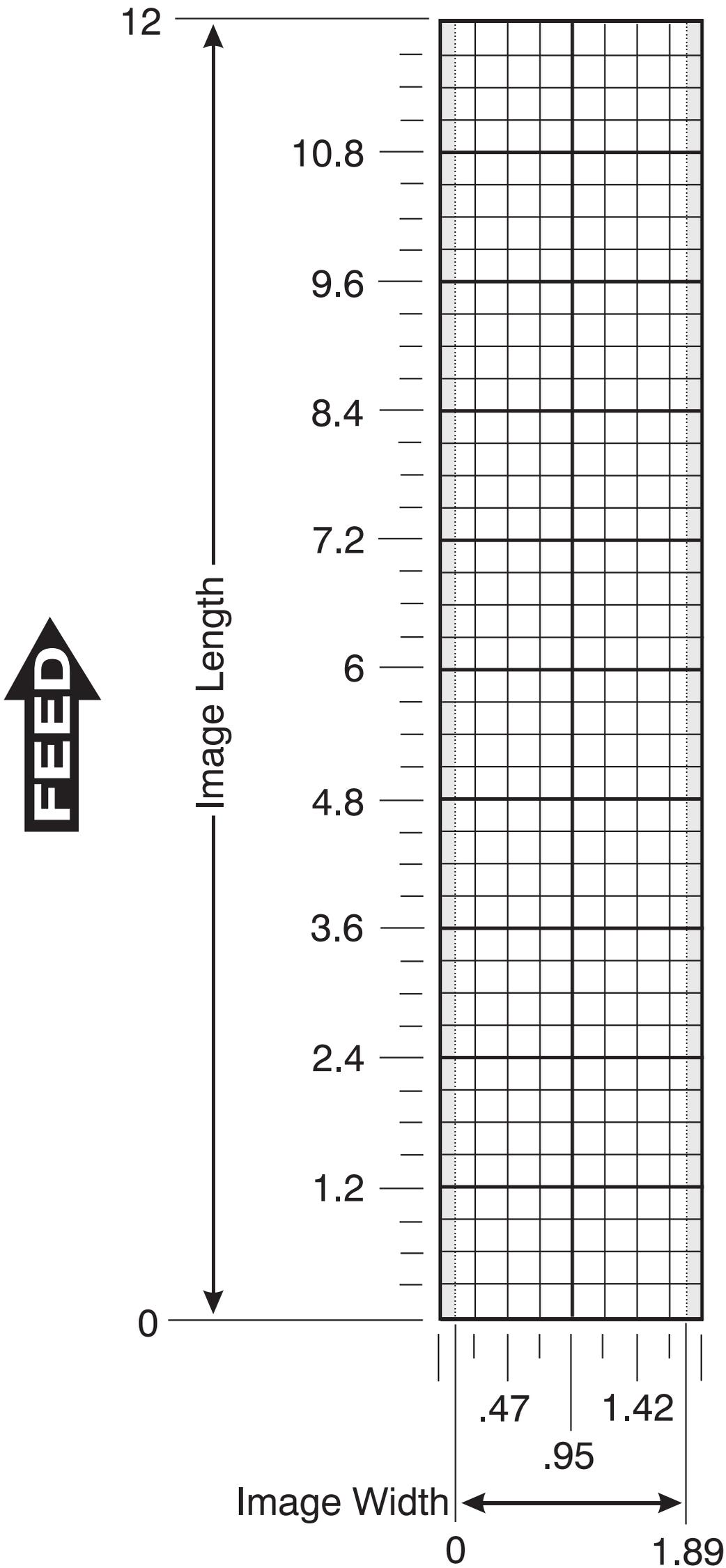
<b>M</b>	HEADER
	BUFFER
	DEVICE
	BUFFER SIZE





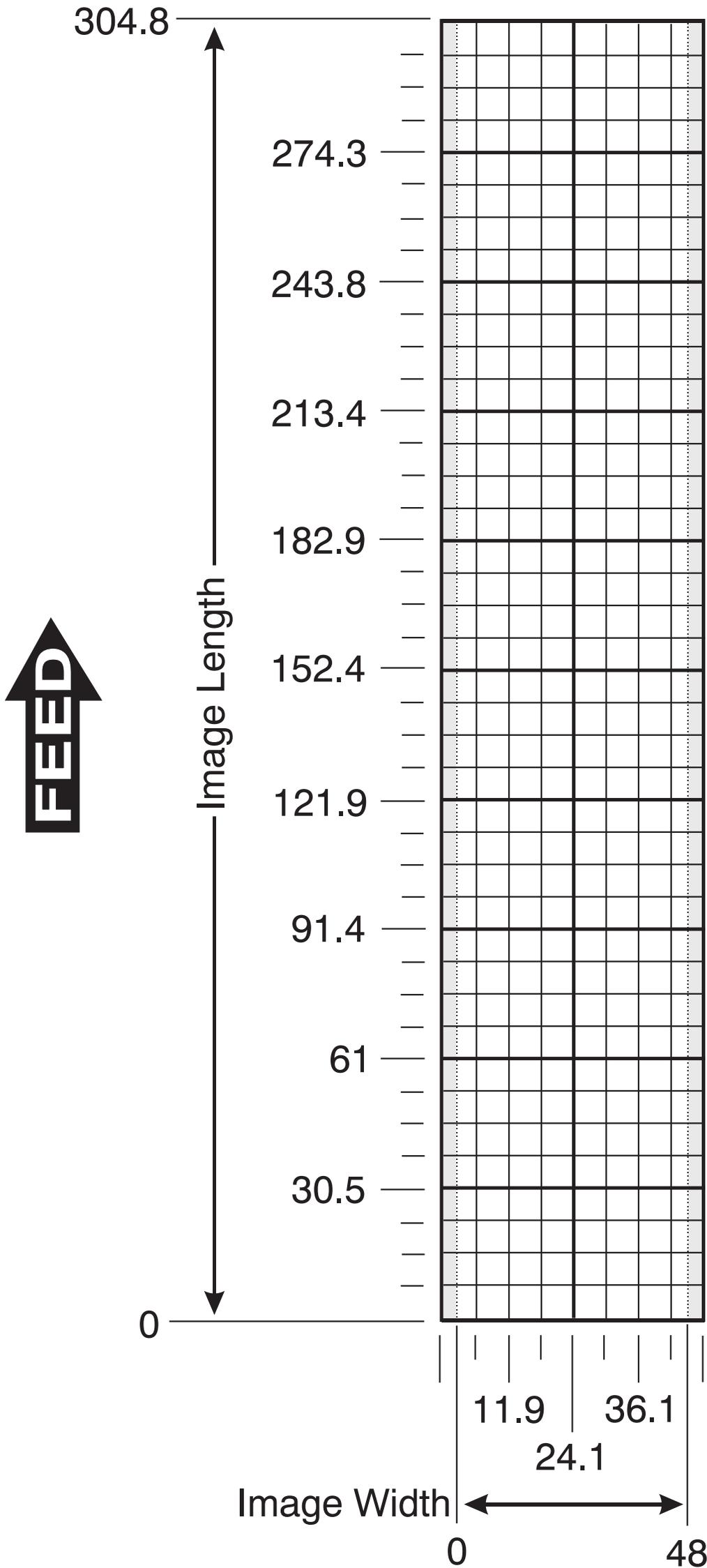
# Supply Layout (Inches)

 - Indicates no-print area



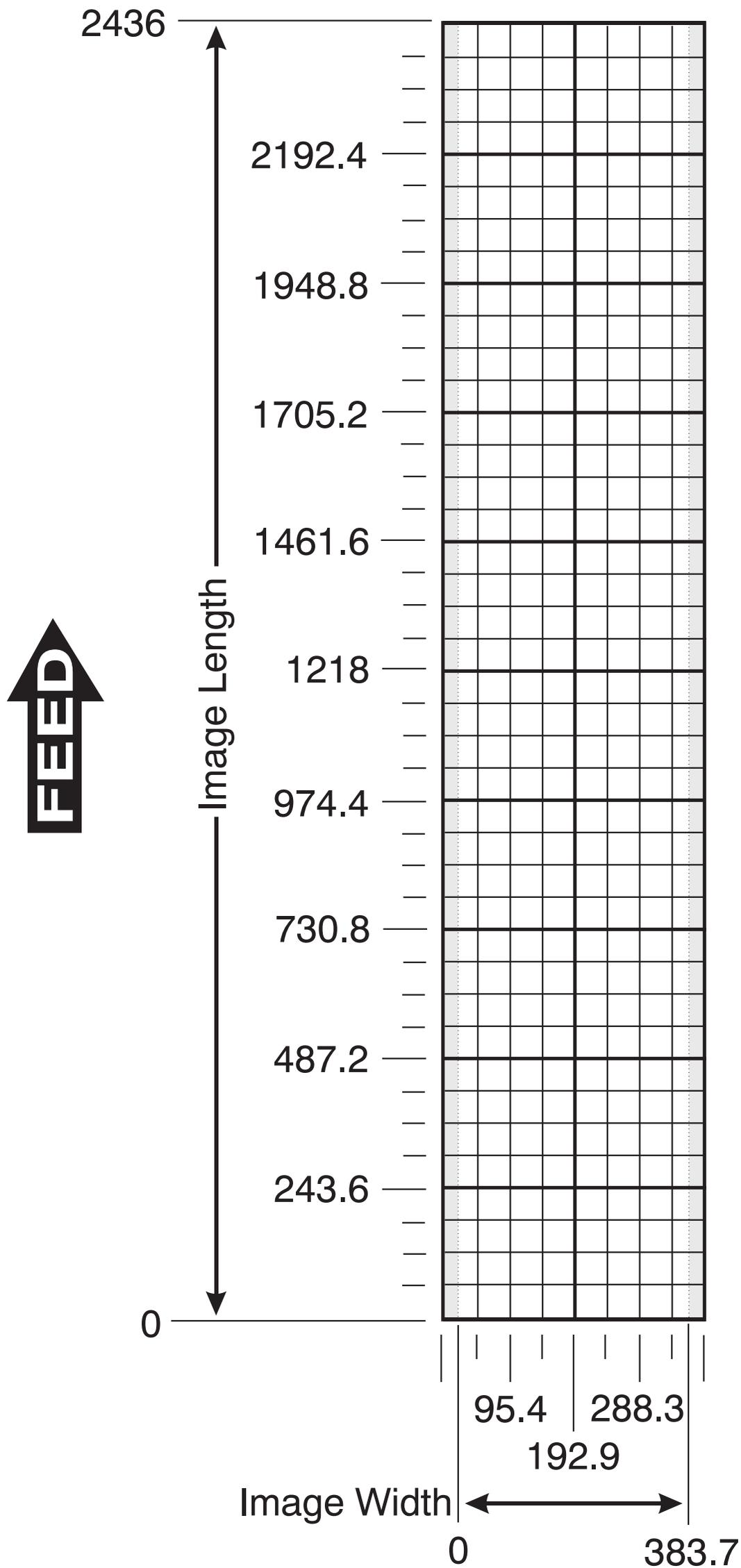
# Supply Layout (Metric)

 - Indicates no-print area



# Supply Layout (Dots)

 - Indicates no-print area





**CONSTANT TEXT FIELDS**

C1	C1 HEADER
C2	C2 ROW
C3	C3 COLUMN
C4	C4 GAP
C5	C5 FONT
C6	C6 HGT. MAG.
C7	C7 WID. MAG.
C8	C8 COLOR
C9	C9 ALIGNMENT
C10	C10 CHAR. ROT.
C11	C11 FIELD ROT.
C12	C12 FIXED CHAR. ("IN QUOTES")
C13	C13 SYM. SET

**LINES**

L1	L1 HEADER
L2	L2 TYPE
L3	L3 ROW
L4	L4 COLUMN
L5	L5 ANGLE/END ROW
L6	L6 LENGTH/END COL.
L7	L7 THICKNESS
L8	L8 PATTERN

**BOXES**

Q1	Q1 HEADER
Q2	Q2 ROW
Q3	Q3 COLUMN
Q4	Q4 END ROW
Q5	Q5 END COLUMN
Q6	Q6 THICKNESS
Q7	Q7 PATTERN

**NON-PRINTABLE TEXT FIELDS**

D1	D1 HEADER
D2	D2 FIELD #
D3	D3 # OF CHAR.
D4	D4 R1 HEADER
D5	D5 R2 CODE #
D6	D6 OPTION #1 Fixed Characters
D7	D7 R3 FIXED CHAR. ("IN QUOTES")
D8	D8 OPTION #4 Copy Data from Previous Field
D9	D9 R1 HEADER
D10	D10 R2 CODE #
D11	D11 R3 SRC FIELD
D12	D12 R4 SRC START
D13	D13 R5 # TO COPY
D14	D14 R6 DEST. START
D15	D15 R7 COPY CODE

**GRAPHICS FIELDS**

G1	G1 HEADER
G2	G2 GRAPH ID
G3	G3 ROW
G4	G4 COLUMN
G5	G5 MODE
G6	G6 ROTATION

**BAR CODE FIELDS**

B1	B1 HEADER
B2	B2 FIELD #
B3	B3 # OF CHAR.
B4	B4 FIX/VAR
B5	B5 ROW
B6	B6 COLUMN
B7	B7 FONT
B8	B8 DENSITY
B9	B9 HEIGHT
B10	B10 TEXT
B11	B11 ALIGNMENT
B12	B12 FIELD ROT.
B13	B13 OPTION #4 Copy Data from Previous Field
B14	B14 R2 CODE #
B15	B15 R3 SRC FIELD
B16	B16 R4 SRC START
B17	B17 R5 # TO COPY
B18	B18 R6 DEST. START
B19	B19 R7 COPY CODE
B20	B20 OPTION #30 Pad Data
B21	B21 R1 HEADER
B22	B22 R2 CODE #
B23	B23 R3 L / R
B24	B24 R4 CHARACTER
B25	B25 OPTION #31 Define Check Digit
B26	B26 R1 HEADER
B27	B27 R2 CODE #
B28	B28 R3 GEN/VER
B29	B29 R4 CHECK DIGIT #
B30	B30 OPTION #50 Bar Code Densities
B31	B31 R1 HEADER
B32	B32 R2 CODE #
B33	B33 R3 DOT WIDTH NAR. ELEMENT
B34	B34 R4 DOT WIDTH WIDE ELEMENT
B35	B35 R5 ADDITIONAL CHAR. GAP
B36	B36 R6 ADDITIONAL NAR. SPACE
B37	B37 R7 ADDITIONAL WIDE SPACE
B38	B38 OPTION #51 PDF417 Security / Truncation
B39	B39 R1 HEADER
B40	B40 R2 CODE #
B41	B41 R3 SECURITY LEVEL
B42	B42 R4 STANDARD /DEFAULT
B43	B43 OPTION #52 PDF417 Aspect Ratio
B44	B44 R1 HEADER
B45	B45 R2 CODE #
B46	B46 R3 ROW /COLUMN
B47	B47 R4 DIMENSION NUMBER
B48	B48 OPTION #60 Incrementing Data
B49	B49 R1 HEADER
B50	B49 R2 CODE #
B51	B50 R3 I /D
B52	B50 R4 AMOUNT
B53	B50 R5 L POS
B54	B50 R6 R POS

**FORMAT HEADER**

F1	F1 HEADER
F2	F2 FORMAT #
F3	F3 ACTION
F4	F4 DEVICE
F5	F5 MEASURE
F6	F6 LENGTH
F7	F7 WIDTH
F8	F8 NAME. ("IN QUOTES")

**TEXT FIELDS**

T1	T1 HEADER
T2	T2 FIELD #
T3	T3 # OF CHAR.
T4	T4 FIX/VAR
T5	T5 ROW
T6	T6 COLUMN
T7	T7 GAP
T8	T8 FONT
T9	T9 HGT. MAG.
T10	T10 WID. MAG.
T11	T11 COLOR
T12	T12 ALIGNMENT
T13	T13 CHAR. ROT.
T14	T14 FIELD ROT.
T15	T15 SYM. SET
T16	T16 OPTION #2 Data Type Restrictions
T17	T16 R1 HEADER
T18	T16 R2 CODE #
T19	T16 R3 CHAR CODE
T20	T16 OPTION #4 Copy Data from Previous Field
T21	T16 R1 HEADER
T22	T16 R2 CODE #
T23	T16 R3 SRC FIELD
T24	T16 R4 SRC START
T25	T16 R5 # TO COPY
T26	T16 R6 DEST. START
T27	T16 R7 COPY CODE
T28	T16 OPTION #30 Pad Data
T29	T16 R1 HEADER
T30	T16 R2 CODE #
T31	T16 R3 L / R
T32	T16 R4 CHARACTER

# FORMAT WORKSHEET

Format Name \_\_\_\_\_

Format # \_\_\_\_\_

Date \_\_\_\_\_

Supply Size \_\_\_\_\_

Supply Type \_\_\_\_\_

Customer Name \_\_\_\_\_

Software Version \_\_\_\_\_

CONSTANT TEXT FIELDS

C1	HEADER	
C2	ROW	030
C3	COLUMN	010
C4	GAP	0
C5	FONT	1
C6	HGT. MAG.	1
C7	WID. MAG.	1
C8	COLOR	0
C9	ALIGNMENT	L
C10	CHAR. ROT.	0
C11	FIELD ROT.	0
C12	FIXED CHAR. ("IN QUOTES")	"MADE IN USA"
C13	SYM. SET	0

LINES

L1	HEADER	
L2	TYPE	S
L3	ROW	110
L4	COLUMN	030
L5	ANGLE/END ROW	110
L6	LENGTH/END COL.	150
L7	THICKNESS	10
L8	PATTERN	" "

BOXES

Q1	HEADER	
Q2	ROW	240
Q3	COLUMN	030
Q4	END ROW	210
Q5	END COLUMN	150
Q6	THICKNESS	3
Q7	PATTERN	" "

NON-PRINTABLE TEXT FIELDS

D1	HEADER	
D2	FIELD #	4
D3	# OF CHAR.	8
R1	HEADER	"
R2	CODE #	1
R3	FIXED CHAR. ("IN QUOTES")	"-----"
R4	HEADER	
R5	CODE #	4
R6	SRC FIELD	3
R7	SRC START	1
R8	# TO COPY	3
R9	DEST. START	1
R10	COPY CODE	1

GRAPHICS FIELDS

G1	HEADER	
G2	GRAPH ID	5
G3	ROW	010
G4	COLUMN	200
G5	MODE	0
G6	ROTATION	0

BAR CODE FIELDS

B1	HEADER	
B2	FIELD #	3
B3	# OF CHAR.	12
B4	FIX/VAR	V
B5	ROW	150
B6	COLUMN	040
B7	FONT	1
B8	DENSITY	2
B9	HEIGHT	80
B10	TEXT	1
B11	ALIGNMENT	L
B12	FIELD ROT.	0
R1	HEADER	R
R2	CODE #	4
R3	SRC FIELD	3
R4	SRC START	1
R5	# TO COPY	3
R6	DEST. START	1
R7	COPY CODE	1
R8	HEADER	R
R9	CODE #	30
R10	L/R	R
R11	CHARACTER	5
R12	HEADER	R
R13	CODE #	31
R14	GEN/VER	G
R15	CHECK DIGIT #	5
R16	HEADER	R
R17	CODE #	50
R18	DOT WIDTH NAR. ELEMENT	4
R19	DOT WIDTH WIDE ELEMENT	8
R20	ADDITIONAL CHAR. GAP	5
R21	ADDITIONAL NAR. SPACE	1
R22	ADDITIONAL WIDE SPACE	1
R23	HEADER	R
R24	CODE #	51
R25	SECURITY LEVEL	2
R26	STANDARD /DEFAULT	S
R27	HEADER	R
R28	CODE #	52
R29	ROW /COLUMN	C
R30	DIMENSION NUMBER	10
R31	HEADER	R
R32	CODE #	60
R33	I/D	I
R34	AMOUNT	5
R35	L POS	6
R36	R POS	1

FORMAT HEADER

F1	HEADER	
F2	FORMAT #	A
F3	ACTION	R
F4	DEVICE	R
F5	MEASURE	R
F6	LENGTH	300
F7	WIDTH	400
F8	NAME ("IN QUOTES")	"TEXTILES"

TEXT FIELDS

T1	HEADER	
T2	FIELD #	2
T3	# OF CHAR.	10
T4	FIX/VAR	V
T5	ROW	250
T6	COLUMN	050
T7	GAP	0
T8	FONT	1
T9	HGT. MAG.	1
T10	WID. MAG.	1
T11	COLOR	0
T12	ALIGNMENT	L
T13	CHAR. ROT.	0
T14	FIELD ROT.	0
T15	SYM. SET	0
R1	HEADER	R
R2	CODE #	2
R3	CHAR CODE	N
R4	HEADER	R
R5	CODE #	4
R6	SRC FIELD	3
R7	SRC START	1
R8	# TO COPY	3
R9	DEST. START	1
R10	COPY CODE	1
R11	HEADER	R
R12	CODE #	30
R13	L/R	L
R14	CHARACTER	X

# (SAMPLE) FORMAT WORKSHEET

Format Name TEXTILES  
 Format # 1  
 Date 09/08/00  
 Supply Size 4" x 3"  
 Supply Type THERMAL DIRECT  
 Customer Name ACE INDUSTRIES  
 Software Version V2.0

# GLOSSARY

<b>Batch Data</b> 2,"Monarch"	Defines the actual information (as fields within { }) printed on the label.
<b>Batch Control</b> E,0,1,4,2	Defines the print job (as a field).
<b>Batch Header</b> {B,1,N,1}	First line of a batch, immediately following ({}). Identifies the format and batch quantity.
<b>Batch Packet</b> {B,1,N,1   2,"Monarch"   }	Contains a batch header and the batch data. Enclosed within { }.
<b>Bitmapped Fonts</b>	Reside in the printer's memory. If you change the point size, you have changed the font. Magnifying these fonts causes some jaggedness to occur.
<b>Buffer</b>	Storage area in the printer's memory that holds specific data (images, formats, etc).
<b>Field</b>	Can be text, bar codes, lines, boxes, constant, or non-printable text. It is the result of a field definition.
<b>Field Definition</b>	Any string of parameters that pertain to one field. A field definition begins with a field identifier (such as T, B, D, C, etc.).  T,1,10,V,250,50,0,1,1,1,B,C,0
<b>Field Parameters</b>	Parameters that apply to a field and are separated by commas. (In the above example, <b>B</b> is a field element for black print on a white background.)
<b>Flash Memory</b>	Contains information that is <b>SAVED</b> when the printer is turned off.
<b>Format</b>	Layout or design for your printed label.

**Format Header** First line of a format, immediately following the start of packet (`{`). A format header must begin with **F**, followed by various header elements.

```
{ F, 1, A, R, E, 200, 200, "Fmt-1" }
```

**Monospaced Fonts** All characters have the same width and are easy to center justify. (Standard, bold, and reduced are monospaced.)

**Non-volatile RAM** Contains information that is **SAVED** when the printer is turned off.

**Option** Any line within a format that applies special formatting to a field. This line always begins with **R** and must immediately follow the field it applies to.  
**R,4,6,1,3,1** |

**Packet** Any string of characters within (`{ }`).  
**{B,1,N,1** |  
**2,"Monarch" }** }

**Pre-image** A way to optimize the printer, because it images the fields while data is collected. After the last field is imaged, the label prints almost immediately.

**Proportionally Spaced Fonts** All characters have different widths and are difficult to center justify (CG Triumvirate™ Typefaces).

**Scalable Fonts** All characters are scalable and smooth at any point size. There are no jagged edges at any point size because the font is created from an equation every time it is used.

**Soft (Downloaded) Fonts** Reside in the printer's RAM. They can be erased or overwritten.

**TrueType Fonts** All characters follow the TrueType outline font standard. All characters are scalable and smooth at any point size.

**Volatile RAM** Contains information that is **LOST** when the printer is turned off.

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