Aura - 6800
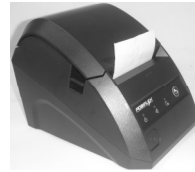# THERMAL PRINTER
USER'S MANUAL

Rev.: A1

FCC Notes:

This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instructions manual, may cause interference to radio communications. It has been tested and found to comply with limits for a Class A digital device pursuant to subpart J of Part 15 of FCC Rules, which are designed to provide reasonable protection against interference when operated in a commercial environment. Operation of this equipment in a residential area is likely to cause interference in which case the user at his own expense will be required to take whatever measures to correct the interference.

CE manufacturer's Declaration of Conformity
(EC Council Directive 89/336/EEC of 3 May 1989)

This product has been designed and manufactured in accordance with the International Standards EN50081-1/01.92 and EN50082-1/01.92 following the provisions of the Electro Magnetic Compatibility Directive of the European Communities as of May 1989

Warranty Limits:

Warranty terminates automatically when any person other than the authorized technicians opens the machine. The user should consult his/her dealer for the problem happened. Warranty voids if the user does not follow the instructions in application of this merchandise. The manufacturer is by no means responsible for any damage or hazard caused by improper application.

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P/N: 19780900030

GETTING START

PRODUCT BRIEFING

Posiflex Aura-6800 series is an easy loading, low noise, high resolution, and trustworthy thermal printer. Additionally, clearing a paper jam in the Posiflex Aura-6800 series printer is an easiest thing. The paper jams (in most cases) can be solving by push the "Hood Release Button" directly.

This series of printers has been elegantly design for Point-Of-Sale, kitchen & kiosk application. The Aura-6800 series comply with UPOS 1.8 standards under Posiflex UPOS driver support. This printer series uses thermal sensitive paper in form of a roll at a width of 80 mm (standard) or 58mm (option). These Aura series printers serve the stand-alone desktop application as well as the application within a Posiflex integrated POS system equally perfect.

Aura-6800 series support four types of interface input through different sub-codes to the model number. The basic model of Aura-6800 is serial interface, and for Aura-6800P is parallel interface. The Aura-6800L connects to a LAN port of Posiflex POS systems. The Aura-6800U connects to USB port of Posiflex POS systems, simulates a RS232 device through driver, and performs thermal printing particularly designed for POS applications. The Aura-6800W connects to a Posiflex POS system through wireless connection and support 802.11 b/g/n. The Aura-6800 series is already **WEPOS** (Windows Embedded for Point Of Service) compliant.

The Aura -6800 series support a guillotine type auto-cutter for paper partial cut and a manual cut mechanism. The Aura series also supports user's company LOGO downloading for superior performance. Furthermore, it can be use to drive a separately purchased **kitchen bell** for reminder function in noisy environment. This series make beeping sound as response to Paper End or Paper Near End signals. 20 plus code pages are supported in the standard model for application convenience.

UNPACKING

Followings items you may find when you unpack the carton carefully that delivers Aura-6800 printer. If there is any discrepancy or problem, contact your dealer immediately. **Please keep the packing materials in case that the printer needs to be shipped.**
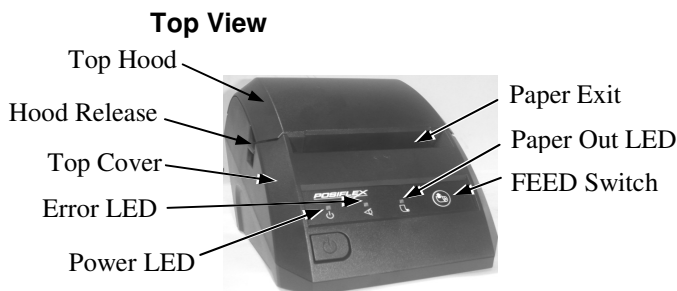
1). An Aura-6800 printer.

2). One tests thermal paper roll 80 mm wide.

3). 58 mm paper spacing plate (P/N: 19710303013/6).

4). One of the interface cables:

    a. Serial cable with 9 pin D sub Female to 9 pin D sub Male connectors for Aura-6800 serial model

    b. Parallel cable with 25 pin D sub Male to 25 pin D sub Female connectors for Aura-6800P parallel model

    c. No interface cable for Aura-6800L

    d. USB cable for Aura-6800U

5). One of the power sources:

    a. Power adaptor + power cord (depend on country type ordered)

    b. Power supply cable (when no power adaptor and no powered USB cable ordered)

6). User's Manual.

7). Driver CD for Aura-6800U, Aura-6800W and Aura-6800L.

OPTIONS

* Kitchen bell (Alarm type KL-100 or buzzer type KZ-200)

* Wall Mount Kit.

* Parallel Interface Kit.

* USB Interface Kit.

* LAN Interface Kit.

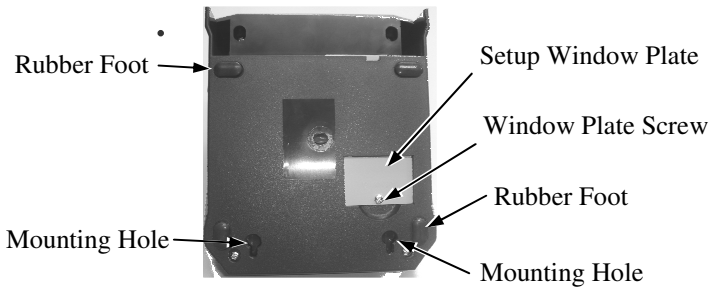Language to add in standard model: Japanese Kanji, Korean, Simplified Chinese or Traditional Chinese
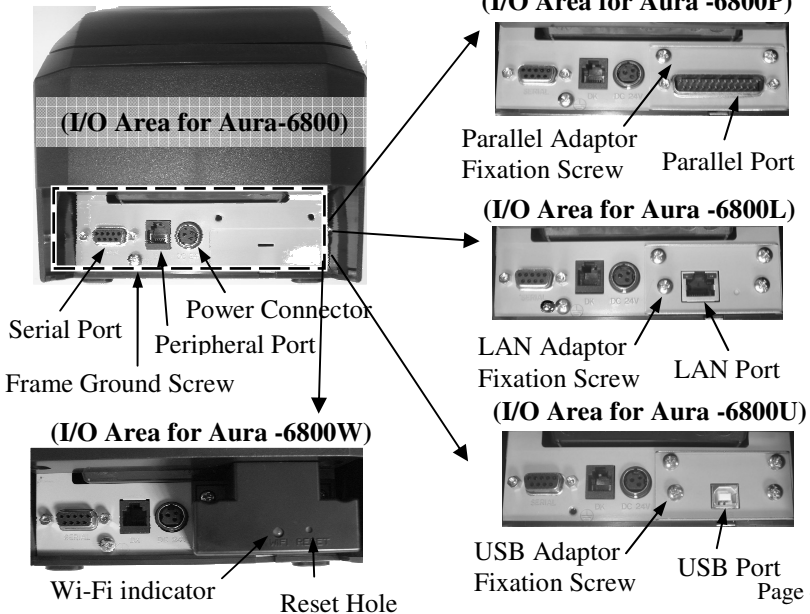
PRODUCT PICTURES

Top View

Top Hood

Hood Release

Top Cover

Error LED

Power LED

Paper Exit

Paper Out LED

FEED Switch

Front View

Power Switch

Bottom Cover

Bottom View

Rubber Foot

Setup Window Plate

Window Plate Screw

Rubber Foot

Mounting Hole

Mounting Hole

Rear View

(I/O Area for Aura -6800P)

Parallel Adaptor
Fixation Screw

Parallel Port

(I/O Area for Aura-6800)

(I/O Area for Aura -6800L)

Serial Port

Power Connector
Peripheral Port

Frame Ground Screw

LAN Adaptor
Fixation Screw

LAN Port

(I/O Area for Aura -6800U)

(I/O Area for Aura -6800W)

USB Adaptor
Fixation Screw

USB Port

Wi-Fi indicator

Reset Hole

INDICATORS

* Power LED: Green.
* Error LED: Red (brief lit indicates printer busy).
* Paper out LED: Red.

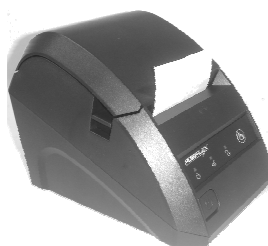# QUICK START-UP

LOADING PAPER

Desk Top Application

Release Button

Pix. 1   **Pix. 2**   **Pix. 3**

Press down the hood release button to release the top hood as in **Pix. 1**.
Raise the released hood wide open manually as in **Pix. 2**.
Drop the thermal paper roll inside the printer in orientation as shown in **Pix. 2**.
Close the hood back by press the center of hood front end; and leaving the tail of the paper roll coming out of the opening between the hood and the top cover as in **Pix. 3**.
Tear off excessive paper.

When to Replace Paper

Whenever the printer gives paper out signal or a red line appears on the thermal paper, it is the proper timing for replacing the paper. Do not wait till the print engine is dragging the paper roll at the very end. Remove the leftover and replace a new paper roll as illustrated above to prevent excessive paper dust in the printer and consequently possibility for paper jam.

Furthermore, during the standby mode (not in the power off mode), it can straight to replace the paper roll. The printer will automatically cut the unnecessary paper right after the top hood closed.

CONNECTING CABLES

Serial Connection

All the external connectors are in the recessed area at the rear bottom for Aura-6800 series. The serial connector is a 9-PIN D sub Female connector at the left in this area. Apply the male connector of RS232 cable to this port for serial application. The default protocol used in serial connection is 115,200 bps, none parity, 8 data bits, 1 stop bit.

Parallel Connection

The parallel connector is a 25-PIN D sub Male connector at the leftmost location in the connector area for Aura-6800P. Apply the female end of the parallel cable at this port for parallel application. Please note that when parallel connection is used, there must be no cable connection at the serial port on the printer.

LAN Connection

The LAN connector is an 8-PIN RJ45 type modular connector at the position left to the power connector in the connector area for Aura-6800L. Please use a LAN cable of CAT 5 with proper length to connect the LAN connector on the printer to the LAN HUB as appropriate. Please note that for Aura-6800L, there must be no cable connection at the serial port on the printer. The LAN port is 10/100BaseT compliant.

USB Connection

The USB connector on Aura-6800U is a type B USB connector at lower right position below the serial port. Use the normal USB Cable as in the left picture to connect the type A end to a normal USB port of host system. Please visit our web site *http://www.posiflex.com* or *http://www.posiflex.com.tw* for detailed information

Type A   **Type B**

Normal USB

of the USB driver installation if required. Please note that for Aura-6800U, there must be no cable connection at the serial ports on the printer.

Peripheral Connection

The peripheral controller is a 6-pin RJ11 type modular jack. With use of Posiflex cash drawer cable come with cash drawer, this port can control a Posiflex cash drawer CR3100 or CR3200 or CR4000 or CR4100 or CR-6310. If a Posiflex special split cable is used instead, this port can control two cash drawers of above models. When the printer is used as a kitchen printer, please use this port for kitchen bell connection instead.

Wi-Fi Connection

To use Wi-Fi connection, please set up through official utility - Posiflex Wi-Fi POS Printer Manager. There are two interfaces to organize Aura-6800W which are RS-232 and internet. When the first time use Aura-6800W, please set the host terminal's Wi-Fi configuration to AD-HOC (peer to peer) mode.

Power Connection

The power connector is a 3-PIN jack between the peripheral connector and the parallel connector for Aura-6800P. Either a Posiflex supplied power adaptor or a printer power cable from a Posiflex POS system can be connected to this connector to supply power for this printer. During insertion of the power plug, be sure to hear the click to obtain a firm contact.
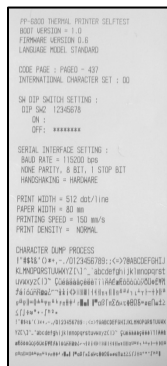
CAUTION: **Before doing the insertion or extraction of the power plug, be sure to pull the outer sleeve of the plug backward to release the internal latch. Failure to do this could damage the power plug. Such damage is considered as an artificial destruction and is not covered by the warranty.**

Power On

When all the above cable connections are made correctly, you may connect your power adaptor to the wall outlet. Make sure that the type of power cord to meet the local power conditions. Now the printer is ready for power on.

Self Test

Press and hold down the feed button while turning on the power switch. The printer will then perform a self-test mode. A sample slip of self-test result is printed as in the sample at right. Please note that both serial and parallel interfaces are indicated. That means the printer is working on an auto-sensing and auto-select algorithm.
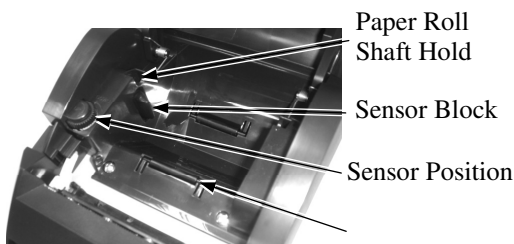
The header is printed in text mode and the rest part of this slip is printed in page mode. If FEED button is pressed at this moment, a font table will be printed in text mode again. To exit the test printing, please turn the printer off and on again.
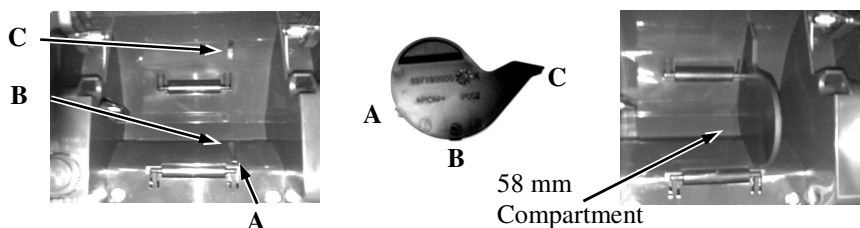
SPECIAL ADJUSTMENTS

Paper Near End Sensor

The near end sensor for paper roll in the printer is able to have the printer work with paper rolls of several bobbin sizes. Please refer to the picture at right for the inside of the paper roll compartment that there are a plastic

Paper Roll Shaft Hold

Sensor Block

Sensor Position

thumb wheel for bobbin size adjustment and a sensor block in the wall. Turn the thumb wheel to adjust the proper position of sensor block. For desktop application, the sensor block should be above the bobbin seating on the 2 support rollers on bottom of paper compartment when paper near end. The acceptable paper roll bobbin outer diameter is between 18 and 24 mm.

58mm Paper Spacing Plate

C

B

A

C

A

B

58 mm Compartment

The application of 58 mm width paper roll in this printer can be achieved through adoption of an option spacing plate and an internal DIP switch setting. Please refer to the last chapter of this manual for the DIP switch setting. Please refer to the middle picture above for the 58 mm paper spacing plate with its flange at top edge showing out. Insert the noted corners of the spacing plate into the 3 dents inside the paper roll compartment as arrowed in the left picture above with point **A** goes in first. Then the 58 mm paper roll sub compartment is formed as in the right picture above.

Paper Cutting

Generally, after paper printed and automatically cut every time, printer will retract the paper roll in order to reduce the paper loss. When the auto-cut function enable, the printer will leave the advance paper in 4.8 mm long. Incase the user applies cut without paper feed through DIP switch and setting change to have something such as a logo printed on top of each slip, the advance paper will be in 4.8 mm. It is also highly suggested to print the logo and necessary paper feeding to make 4.8 mm paper advance right after each cut to prevent curling up and jamming of paper front edge inside the paper exit slot.

INSTALLING DRIVER

There will be a Posiflex Product Information CD or DVD or a separate CD of similar nature, which is specifically create for the Aura-6800U and Aura-6800L. Please find the appropriate subfolder from the non-specific Posiflex Product Information CD or DVD and please find the information document such as "read me" or installation guide or application guide and follow the instructions inside.

LAN and Wi-Fi PRINTER SPECIFIC ISSUES

Web Manager for Aura-6800L

The default static IP for the Aura-6800L is 192.168.192.168 and default listen port is 9100. User may set his own IP to the same network segment and use any browser to connect to the printer IP to configure the LAN setup of the Aura-6800L including changing the printer IP for application according to his network administrator's request. However, **DHCP is not support**.

Reset Pin Hole

As the setup for the Aura-6800L/W can be set freely, the changes are not well registered some troubles could be introduced. Therefore, in Aura-6800L/W, there is a "Reset pin hole" near the LAN connector or Wi-Fi Module. Use something like a ball pen tip or straightened end of paper clip to push and hold for at least 5 seconds into this hole will reset the LAN / Wi-Fi setup of the printer back to the default values at delivery so the user may re-do all setup. The LAN setup can be viewed in second paragraph of self-test printout for the Aura-6800L.

LAN POS Printer Manager

This utility can be used to manage multiple Aura-6800L's connected in same network under Windows as long as there is no conflicting IP in the network. This utility can assign to each LAN printer a different device name for easy recognition. In case of confusion, please check the MAC addresses listed in this utility against the MAC address label you can find under each printer.

Any PC connected in same network can use TCP/IP to use Aura-6800L in the way like a directly connected local printer. So, for direct I/O control by tools like "HyperTerminal" all commands applicable to the serial or parallel interface model can work on Aura-6800L in the same way, as Aura-6800 except the port must be TCP/IP with the IP address of the printer. Similarly, for Windows printer driver setup, please "Add Printer" and select for "Local printer" and select port "TCP/IP" with the printer IP address then uses the same Windows printer driver of Aura-6800L.

Posiflex Wi-Fi POS Printer Manager for Aura-6800W

Please set the host system to the AD-HOC mode and the IP in the same network segment with Aura-6800 which in the 192.168.192.XXX. The Posiflex Wi-Fi POS Printer Manager (PP68WMgr.exe) must use with Microsoft Comm control 6.0(MSCOMM32.ocx), therefore, please ensure that MSCOMM32.ocx installed before start the utility. Please set the Aura-6800 into normal mode that can be search by this utility. After start the software, it will automatically search printer by Broadcast or search by IP modes and show as a list. After Aura-6800 showed in the list, the setting can modify. For modify the printer setting through UART and UDP modes, please connect the cable to serial port. Please notice that Aura-6800 will reboot automatically right after change or update setting.

OPERATION GUIDE

MAINTENANCE GUIDE LINES

* Please turn off and disconnect power before opening the cover.

* The areas around the print head and motor become very hot during and just after printing, DO NOT touch them.

* When handling the interior of the thermal printer, please pay attention not to be hurt by any sharp edge of the metal parts.

GENERAL CLEANING

Please use soft hairbrush or compressed air to clear away any dust or paper scraps accumulation inside the printer. Check also the area of the auto-cutter regularly.
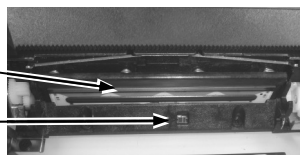
PRINT HEAD CLEANING

The print head is located underneath the roll paper passage at the exit as in the picture below. You can

Thermal Elements

Paper Sensor

clean the thermal elements of the print head and paper sensor gently using a cotton swab moistened with isopropyl alcohol solvent. Before putting back the paper roll for printing, alcohol solvent must be dry completely.

NOTE: Never do this when print head is still hot. Do not touch the print head thermal elements and scratch the print head

TROUBLE SHOOTING

This section gives solutions to some printer problems you may have.

General Problems

No LED lights up on control panel when switched on –Make sure that the power supply cables are correctly plugged into the printer, the power adaptor and to the power outlet. Make sure that power is supplied to the power outlet. If a switch or timer controls the outlet, try using another outlet

Printing Problems

Nothing can be printed with ERROR LED flashing – Most possible cause for the flashing Error LED is that the printer has been printing for quite a period of time and the print head temperature become too high. After few minutes under normal ventilation, the print head should be able to cool down and the Error LED will stop flashing. Printing will resume after cooled down. If this is not the case, contact a qualified service person.

Nothing can be printed with ERROR LED ON – Check the Paper Out LED. If it is ON, most probably either the paper roll is not installed or the paper roll is at or near the end. Install a new paper roll. If the Paper Out LED is OFF, please check if the print hood is properly closed. There are 2 internal checkpoints inside the printer to assure the locking of the hood for a decent printing.

Therefore any dislocation of the hood may cause an error status and inhibition to printing. **Press down the hood at middle of the opening** when closing it till it audibly clicks into place. If both situations are not the cause, please try pulling the hood lock forward. If the top hood won't release automatically, **check for paper jam** described in next item.

If there is no paper jam and the print head is not overheated, turn off the printer and wait for half a minute then turn it back on. If the problem still remains, contact a qualified service person.

Nothing can be printed with ERROR LED OFF – Try to run self-test according to previous chapter to check if the printer itself works properly. If the self-test passes, check the following:

1). Check the connection of the interface cable at both the printer and computer ends. Also make sure that this cable meets the specification required for both the printer and the computer.
2). Check the printer data communication settings against the computer. The printer settings can be found easily on the self-test print out.

If the problem remains or the self-test fails, contact your dealer or a qualified service person.
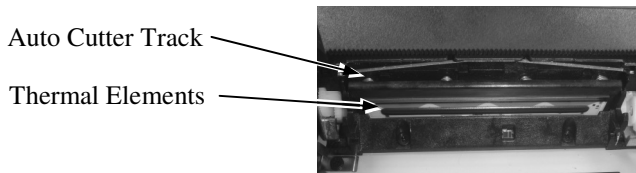
Poor printing quality – Contaminants like paper scraps and dusts on the thermal print head can lower the print quality drastically. Clean the print head as described in previous section.

Paper Jam Problems
Paper is jammed inside the printer – Push down the hood release button then the top hood can be released. Remove the jammed paper and reinstall the paper roll. Close the hood properly and firmly for operation.

If the auto cutter is also jammed, the top hood will be locked. However, in most of the situations the cutter will retract automatically when the hood

release button is pressed. Should the cutter jam be so serious to interfere the hood release operation, please re-close the hood and try opening it again. **Never force open the top hood.** Please also clear away any contaminants accumulated in the cutter track above the thermal elements.

Auto Cutter Track

Thermal Elements

Advanced Analysis Tool

This printer supports **Hexadecimal Dump** for experienced user to view exactly what data the printer receives. This can be useful in finding software problems.

To start the dump mode: Turn off printer; Open print hood; Hold down FEED button while turning printer on; Close the hood.

To stop the dump mode: Press the FEED button to print out the last line; Turn off the printer.

During dump mode: All commands except **DLE EOT** and **DLE ENQ** are disabled.

USEFUL TIPS

* Please note that only those qualified technicians may adjust several jumpers for some technical settings. Please visit our web site *http://www.posiflex.com* or *http://www.posiflex.com.tw* for details of the technical information such as driver installation, DIP switch settings and command sets etc. if required.

* Place the printer on a sturdy, level surface.

* Choose a place that is well ventilated and free of excessive dust, smoke or fume.

* Do not put the printer under direct sunlight or near a heater.

* Ideal room temperature is from 5ºC to 40ºC. Ideal humidity is from 20% to 85% RH (no condensation).

* Do not set any liquid or drinks such as coffee on the printer case.

* Do not touch any metal part to avoid possible electrostatic damage.

* Do not touch the areas around the print head and motor during or right after printing. It can be very hot.

* Do not allow the cut receipt to slide back into the cutter during the operation. As this would lead to multiple cutting at the lower edge of a receipt and the multiple cut thin slips tend to cause mechanical malfunction.

* Use a grounded AC power outlet with only the power cord and power adaptor furnished with the printer.

* Do not use a power outlet of a circuit shared with any equipment that uses a lot of power or causes great electrical noises, such as a copier, electric motors or a coffee maker.

* Do not use thermal paper containing Sodium (Na+), Potassium (K+) and Chlorine (Cl-) ions that can harm the print head thermal elements.

* If the surface of thermal paper is scratched with a hard object such as a nail, the paper may become discolored.

* If thermal paper touches diazzo copy paper immediately after copying, the printed surface may be discolored.

* Use only water paste, starch paste, polyvinyl paste or CMC paste when gluing thermal paper.

* If thermal paper touches anything containing ophthalmic acid ester plasticizer for a long time, the image formation ability may be reduced or the printed image may fade.

* Use of volatile organic solvents such as alcohol, ester and ketone or some adhesive tapes on thermal paper can cause discoloration.

* Thermal paper must not be stored with the printed surfaces against each other as the printing may be transferred between the surfaces.

* Since the paper roll is highly thermal sensitive, please keep them in a dark place that is 20º and 65% RH when not installed in the printer. Avoid extended exposure to direct light. Use only products made from polyethylene, polypropylene or polyester for storage of thermal paper.

SPECIFICATIONS

PRINTER

ITEM	SPECIFICATION
Printing method	Thermal sensitive line dot method
Effective printing width	64 mm(Maximum 72mm)

Thermal head configuration	512 dots / line(Maximum 576 dots/line)
Printing speed	150 mm / sec. max.
Paper feed method	Friction auto-feed
Paper load method	Drop and use
Auto-cutter capability	Partial cut (1 point at center left)
Manual cutter	Saw tooth blade
Dot Pitch	0.125 x 0.125 mm
Input power type	DC
Input voltage	24 V + / - 5 %
Dimension (mm)	150 (W) x 187 (D) x 140 (H)
Weight	0.95 Kg net

PAPER

PAPER TYPE	THERMAL ROLL PAPER
Paper roll formation	External side is heat-sensitive side
Paper width	80 (or 58) + 0 / - 1 mm
Paper roll outer diameter	80 mm max.
Paper roll inner diameter	12 + 1 / - 0 mm
Paper thickness	60 ~ 80 um

POWER ADAPTOR

ITEM	REQUIREMENT
Input voltage	100 V AC ~ 240 V AC
Input frequency	50 ~ 60 HZ
Input current	1.8 A MAX. @ 115 V AC
Output voltage	+ 24 V DC
Output power	50 W
Output regulation	+ / - 5 %
MTBF	30,000 HRS
EMI standards	VDE – A, FCC – A, VCCI – A

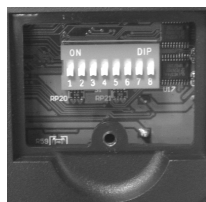# FURTHER TECHNICAL INFORMATION

PRINTER SETUP

There are two difference way to setup Aura-6800. Firstly, one is the DIP Switch in the bottom of printer for setup the function such as baud rate, paper width and others. Another switch is setup trough software to adjust such as

printer density and others. Following explanation is going to descript these two switches setting.

DIP Switch

On bottom cover of the Aura-6800 series thermal printer, there is screwed a metal plate for setup window. In this window, there is an 8-position DIP switch for printer setup. Please use proper tool to change the switch setting when necessary. The switch position counting starts from the nearest edge of printer. The functions of each position may evolve with the revisions of the firmware. The information below applies to the latest version to the date of print of this manual.

The 8-position SW1 DIP switch works as following:

Switch position	ON	OFF
1	Baud rate definition (ref. separate table below)	
2		
3	Paper Width 58mm	Paper Width 80mm
4	Line format (for 80 mm paper) at 576 Dot/Line	Line format (for 80 mm paper) at 512 Dot/Line
5	Busy on "buffer full"	Busy on "buffer full" and/or "off line"
6	Cut without paper feed	Cut with auto paper feed
7	Auto Cutter Disable	Auto Cutter enable
8	Firmware Update Enable	Firmware Update Disable

Effect of positions 1 & 2 on baud rate is defined as in table below:

SW1 Pos. 1	OFF	OFF	ON	ON
SW1 Pos. 2	OFF	ON	OFF	ON
Baud rate setup	19200 bps	115200 bps	9600 bps	38400 bps

Switch position 3 defines the paper width. When it place in "ON", the paper width will be 58mm. In other words, if it needs the paper width at 80mm then please set to "OFF". The application of 58 mm width paper roll in this printer can be achieved through an optional spacing plate. For the installation, Please refer to the earlier chapter of "SPECIAL ADJUSTMENTS".

Switch position 4 is usually set to OFF for ESC/POS command application that prints at 512 dots / line. Only technical users shall set this switch to ON and make the printer work in the 576 dots / line format.

For switch position 5, if the switch is set to "ON", the busy signal set to host only when input buffer is full. When it is set to "OFF", busy signal is sent to host whenever the input buffer is full or an off line status occurs. Therefore, signals including the paper near end detect will generate busy signal to the host. Moreover, the printer will keep on beeping at Paper End (completely no paper) till paper is replaced when S1-5 is "ON". When S1-5 is "OFF", the printer will keep on beeping every 3 seconds at Paper Near End (still long paper in replace) till paper is replaced.

For switch position 6, when it set to "OFF", the paper will feed before cutting when software does not define this point and there will be a further paper feeding after cutting to prevent paper jam. Before setting this switch to "ON", please make sure that your software will take care of enough paper feed for the paper jam prevention issue.

Switch position 7 defines the auto cutter. When needs to enable the paper auto cut function, it have to place to "Off". On the other hands, the auto cutter function will disable when it place at "On".

Switch position 8 defines the firmware update function. If the printer needs to update the firmware, please set to "ON" position. In order to operating perfectly, please set in "OFF" when the printer do not needs to update the firmware or in normal situation.

The factory default for each position listed as below:

Switch 1 Position	1	2	3	4	5	6	7	8
Default setup for Aura-6800L	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
Default setup for Aura -6800/P/U	OFF	ON	OFF	OFF	OFF	OFF	OFF	OFF

Software switch
Another method to setup Aura-6800 is through the software switch setting, which means other functions must be change by software utility. The information below applies to the latest version to the date of print of this manual. Please visit our web site *http://www.posiflex.com* or *http://www.posiflex.com.tw* for download the **Aura-6800 software switch utility.** Software switch has divided into **SW2** and **SW3**. Following information is going to describe these settings.

SW2 software switch works as following:

Switch position	ON	OFF
1	Print Density (Normal, High Quality or Light)	
2		
3	Enable paper auto-cut at top hood close and switch on the printer.	Disable paper auto-cut at top hood close and switch on the printer.
4	Full-cut mode.	Partial-cut mode.
5	Raster Bitmap Print by line print.	Raster Bitmap Print by buffer batch.
6	Even parity	None parity
7	XON/XOFF handshaking	DSR/DTR handshaking
8	CR code (0Dh) effective	CR code (0Dh) invalid

Effect of positions 1 & 2 of Print Density is defined as in table below:

SW2 Pos. 1	OFF	ON	ON
SW2 Pos. 2	OFF	OFF	ON
Print Density	Normal	High Quality (low speed mode)	Light

For the switch position 3, it is recommended to place at ON. In this way, the printer performs an automatic paper cut each time when the top hood is closed (e.g. after paper roll loaded) with the printer in operating condition. However, if it placing in OFF and the manual cutter can be engage whenever necessary. As well as it will automatically cut paper when switch on the printer when this switch position place at ON.

When switch position 4 set to "ON", the paper will fully cut after paper printed. If the printed-paper do not needs to completely cut, please set this switch to "OFF" then the printed paper will be partially cut and left a tiny piece that user needs to rip the printed paper. When the printer set to full-cut mode, please notice that the paper should be take away immediately right after printed. Otherwise, the last paper will cut again with the next printed-paper cut. Please notice that when it place to ON, the paper will retract 6 mm before it start to print.

For switch position 5, it defines the printing behavior of the printer on graphic printing. When it is set to ON, the printer prints on each printing command received immediately. However, the printer may have to engage brake frequently waiting for next command resulting in trembling. When this switch is set to OFF, the printer starts printing only when more graphical data are collected thus performing a much smoother printing operation.

Switch position 6 defines the parity check regulation in serial interface. In Aura-6800, it is selectable between even and none.

For switch position 7 can choice the handshaking method in serial interface. When it is set to ON, the printer transmits an "XOFF" for busy and sends an "XON" for not busy. When it is set to OFF, the printer signifies the busy status over hardware signals that can be detected by the host as "DSR" or "CTS". When parallel interface is used, both switch positions 3 and 4 should be set to OFF.

For switch position 8, when it is set to ON, the printer responds to a carriage return command (CR code or 0Dh) with also a line feed (LF code or 0Ah) action. Then if the text editor always expresses the change to a new line with both the CR and LF codes, there will be an extra line advance than expected. However it works for some old editors that express the change to a new line with only either one of the LF code or the CR code.

The factory default for each position listed as below:

Switch 2 Position	1	2	3	4	5	6	7	8
Default setup for all Aura-6800 interface models	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF

SW3 software switch controlled the retractable function **WHEN SW2-4 SET TO OFF**. When this switch set to OFF, printer will enable to retract paper 6 mm before it start to print with the aim of reduce paper loss. In contrast, it will straight to print when this switch place to ON. Please notice that the factory default of this switch is OFF.

MULTIPLE INTERFACE ISSUE
For model Aura-6800, there is only 1 connector for host connection through RS232. For Aura-6800P, there are 2 connectors for host connection: RS232 and in addition to parallel port. For Aura-6800U, there are 2 connectors for host connection: RS232 and in addition to the USB port. For Aura-6800L, there are 2 connectors for host connection: RS232 and in addition to the LAN port. Please always connect **only one interface at a time**. Simultaneous multiple host connections could result in unexpected results!

UPOS CONCERNS
The UPOS compliance and WEPOS compliance ability of the Aura-6800 series dictates the printer to perform certain internal affairs such as counter

refreshment periodically. When the printer is engaged in such operations there will be a brief period of time that the printer is busy without externally apprehensible cause. In other words, the printer will lit the ERROR LED briefly once in a while even when no external communication is in process and that is definitely normal.