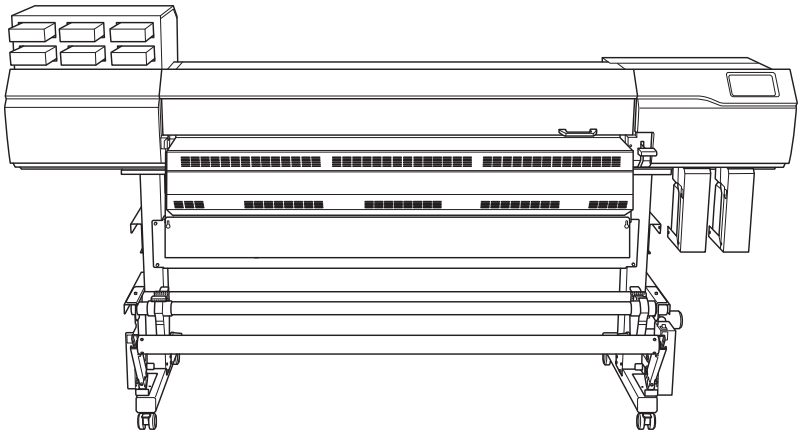
TrueVIS AP-640

User's Manual



Thank you very much for purchasing this product.

- To ensure correct and safe usage with a full understanding of this product's performance, please be sure to read through this manual completely.
- Unauthorized copying or transferal, in whole or in part, of this manual is prohibited.
- The specifications of this product and the contents of this operation manual are subject to change without notice.
- The operation manual and the product have been prepared and tested as much as possible. If you find any misprints or errors, please inform us.
- Roland DG Corporation assumes no responsibility for any direct or indirect loss or damage that may occur through use of this product, regardless of any failure to perform on the part of this product.
- Roland DG Corporation assumes no responsibility for any direct or indirect loss or damage that may occur with respect to any article made using this product.

FA03985/R5-240131
https://www.rolanddg.com/
Copyright © 2023-2024 Roland DG Corporation

Roland DG Corporation

Contents

Basic Handling Methods 6

Basic Information 7
- Part Names and Functions 8
  - Printer Unit 8
  - Take-up Unit 13
  - Operation Panel 14
- About the Media Used 19
  - Types of Media 19
  - Conditions for Usable Media 0
- Take-up Unit 20
  - Take-up Unit Use Conditions 20
  - About the Paper Tube 20

Basic Operations 21
- Power Supply Operations 22
  - Turning the Power On 23
  - Turning the Power Off 24
  - Sleep Mode (Power-saving Feature) 25
- Setup of New Media 26
  - Setup of Roll Media 26
  - Setup of Sheet Media 47
- Setup of Registered Media 59
  - Setup of Roll Media 59
  - Setup of Sheet Media 78
- Checking before Output 88
  - LAN (Local Area Network) Settings 88
- Pausing and Canceling Output 89
  - Pausing and Resuming Output 89
  - Canceling Output 90
- Separating the Media 91
- Removing Media from the Take-up Unit 94
- Ink Pouch Replacement 96
  - Out-of-ink Warnings 96
  - Ink Pouch Replacement 97
- Cleaning Liquid Replenishment 103
  - Out-of-cleaning-liquid Warnings 103
  - Cleaning Liquid Replenishment Method 104

Output Method 106

Printing Method 107
- Preparations before Printing Output 108
  - Step 1: Performing a Nozzle Drop-out Test 108
  - Step 2: Performing Normal Cleaning 109
- Printing Output 111

Optimizing Quality and Efficiency 112

Optimizing the Output Quality 113
- Using the Correction Functions 114
  - Automatically Making Required Adjustments 114
  - Manual Adjustment: Reducing Horizontal Bands (Feed Correction) 115
  - Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment) 117
- Configuring Settings to Match the Properties of the Media 119

Changing the Print Head Height 119
Using Media That Wrinkles Easily/Does Not Move Smoothly 121
Using Sticky Media 122
Using Heat-resistant Media with Minimal Waste 123
Setting the Take-up Unit 124
Adjusting the Ink-drying Method 126
Setting the Print Heater Temperature 127
Setting the Dryer Temperature 128
Setting the Temperature during Standby 129

Optimizing Work Efficiency 130
Managing the Media Settings 131
Changing the Media Settings 131
Checking the Registered Media Settings 132
Changing the Media Name 133
Duplicating Media Settings 134
Deleting Media Settings 135
Adjusting the Output-start Location 136
Setting the Base Point 136
Reducing Output Time 138
Speeding Up Output for Narrow Media 138
Other Useful Functions 139
Using the Print Light (Interior Light) 139
Performing Printing Tests Arranged Horizontally 140

Optimizing Operation Management 141
Managing the Operations Appropriately and Efficiently 142
Setting the Current Date/Time and Using It for Maintenance 142
Checking the Remaining Media 143
Showing/Hiding Notifications 145
Setting the Activation Interval for Sleep Mode (Power-saving Feature) 146
Managing the Basic Settings of the Printer 147
Changing the Display Language 147
Changing the Units of Measurement 148
Viewing Printer Information 149
Viewing Network Information 150
Adjusting the Brightness of the Operation Panel 151
Turning Off Operation Panel Sounds 152
Returning All Settings to Factory Defaults 153

Maintenance 154

Introduction 155
Important Notes on Handling and Use 156
Printer 156
Ink Pouches 157
Basic Maintenance Knowledge 158
Types and Timing of Maintenance 158
Measures When the Printer Is Not in Use for a Prolonged Period 159

Regular Maintenance 160
Print Head Check before Printing 161
Performing a Nozzle Drop-out Test 161
Cleaning the Machine 162
Cleaning the Media Path 162
Cleaning the Knife Carriage Roller 163
Cleaning around the Print Heads 164
Cleaning the Print Head Caps and Flushing Frames 166

Cleaning the Nozzle Guards 171

Disposing of Discharged Fluid 174
Precautions for Disposing of Discharged Fluid 175
If the Discharged Fluid Disposal Message Appears 176

Advanced Maintenance 178
When Dot Drop-out or Dot Displacement Occurs 179
Performing Normal Cleaning 179
When Normal Cleaning Is Not Effective 181
Medium Cleaning Method 181
Powerful Cleaning Method 183
Cleaning the Wiper Tray 185
Handling Severe Dot Drop-out and Dot Displacement 186
Ink Renewal Inside Heads Method 186
Emergency Measure) Cleaning the Print Head Surface 190
When the Operation Panel Is Dirty 191
Operation Panel Cleaning Method 191

Replacing Consumable Parts 192
Replacing Parts for Maintenance 193
Replacing the Wipers 193
Flushing Pad Replacement 196
Replacing the Separating Knife 201

Troubleshooting Methods 204

Output Quality Problems 205
Printed results are coarse or contain horizontal stripes 206
Do the print heads cause dot drop-out? 206
Is the print head height appropriate? 206
Have you carried out [**Feed Correction**]? 206
Have you carried out [**Media Gap Adjustment**] (ink landing position correction)? 206
Is the printer installed in a level and stable location? 206
Is the print heater at a suitable temperature? 207
Is the print mode suitable? 207
Is the media loaded correctly? 207
Are the [**Media Settings**] appropriate? 207
The media becomes soiled when printed 208
Do the print heads come into contact with the media? 208
Are the print heads dirty? 208
Are the pinch rollers or the media clamps dirty? 208
Colors are unstable or uneven 209
Have you tried mixing the ink by shaking the pouch trays? 209
Is the media wrinkled? 209
Was printing paused partway through? 209
Is the printer installed in a level and stable location? 209
Is the media loaded correctly? 209
Are the operating parameters set to appropriate values? 209
Are the [**Media Settings**] appropriate? 210

Media Feed Problems 211
Media Wrinkles 212
Is the media loaded and set up straight and securely? 212
Was loaded media allowed to stand for some time? 212
Are the media clamps attached? 212
Was the media loaded while the print heater was hot? 212
Is the temperature of the dryer too high? 212

Is [**Pullback After Printing**] enabled? 212
Have you stored the media in a low-temperature room? 212
Is the humidity of the room too high? 213
Is the media sagging? 213
Media Feeding Is Not Straight 214
Is the media loaded and set up straight and securely? 214
Media Feeding Is Not Smooth 215
Is some other object coming into contact with the media? 215
Is the media too thick? 215
Are the grit rollers dirty? 215
A Media Jam Occurs! 216
Is an error message displayed? 216
Is the media warped or wrinkled? 216
Is the height of the print heads too low? 216
Are the grit rollers dirty? 216
Are the media clamps installed? 216
Is the media loaded and set up straight and securely? 216
Is some other object coming into contact with the media? 217
Is the media too thick? 217

Machine Problems 218
The Print Heads Do Not Move 219
What to Do First 219
If the Print Heads Still Do Not Move 219
The printer unit does not run 221
Is the power switched on? 221
Is [**Output possible.**] displayed? 221
Are any covers open? 221
Is the message [**Output is currently paused.**] displayed on the screen? 221
Is a message displayed on the screen? 221
Are the cables connected? 221
Is the LAN routing appropriate? 222
Are the LAN settings correct? 222
Did the software RIP end abnormally? 222
Is an [**Ink Pouch Tray Error**] displayed? 222
The Print Heater/Dryer Does Not Become Hot 224
Is the media loaded? 224
Is the temperature of the room too low? 224
Cannot Separate the Media 225
Is the separating knife installed? 225

Messages on the Operation Panel 226
Messages 227
[**When output, cleaning, and other operations are completed, discard the discharged fluid.**] 227
[**The time for manual cleaning has arrived.**] 227
[**The time for wiper replacement has arrived.**] 227
[**The time for flushing pad replacement has arrived.**] 227
[**Print head protection mode has activated.**] 227
[**Fill the cleaning liquid tank with cleaning liquid.**] 228
[**Operation of the take-up unit stopped.**] 228
[**Install the media clamps correctly.**] 228
[**Media clamps could not be detected.**] 228
[**The LAN cable is not connected.**] 229
[**Connection is requiring too much time. Manually setting the IP address will improve the connection speed.**] 229
[**There is ink that has expired.**] 229
[**The temperature around the machine is too low. Adjust the room temperature.**] 229
[**The temperature around the machine is too high. Adjust the room temperature.**] 229
Error Messages 230

[Ink Pouch Tray Error] 230
[Cover Open Error] 230
[Media End Error] 230
[Pinch Lever Error] 231
[Media Loading Error] 231
[Loose Media Error] 232
[Drain Bottle Error] 232
[Unable to Fill Wiper Cleaning Liquid] 232
[Print Head Height Mismatch] 232
[Insufficient Media Width] 233
[Ink Supply Error] 233
[Temperature Increase Timeout Error] 233
[Motor Error] 233
[Print Head Dry-out Error] 234
[Low Temperature Error] 234
[High Temperature Error] 234
[Take-up Unit Communication Error] 234
[Dryer Error] 235
[Service Call] 235
[Software error] 235

Appendix 236

Operations When Moving the Unit 237
Preparing to Move the Machine 238
Step 1: Removing the Media 238
Step 2: Discharging the Tray Cleaning Liquid 239
Step 3: Securing the Carriage in Place Using the Retainer 240
Step 4: Removing the Dryer 241
Step 5: Reinstalling the Machine 242

Main Specifications 244
Maximum Printing Area and Margins 245
Maximum Printing Area When Using Crop Marks 247
Media Separation Location during Continuous Printing 248

Memo 249

Basic Handling Methods

Basic Information

Part Names and Functions 8
- Printer Unit 8
- Take-up Unit 13
- Operation Panel 14

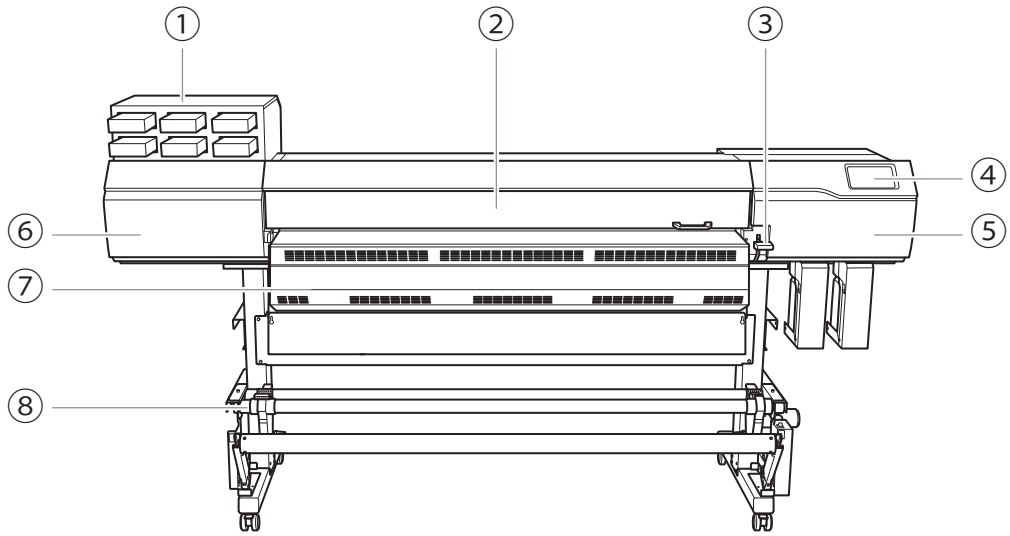
About the Media Used 19
- Types of Media 19
- Conditions for Usable Media 0

Take-up Unit 20
- Take-up Unit Use Conditions 20
- About the Paper Tube 20

Part Names and Functions

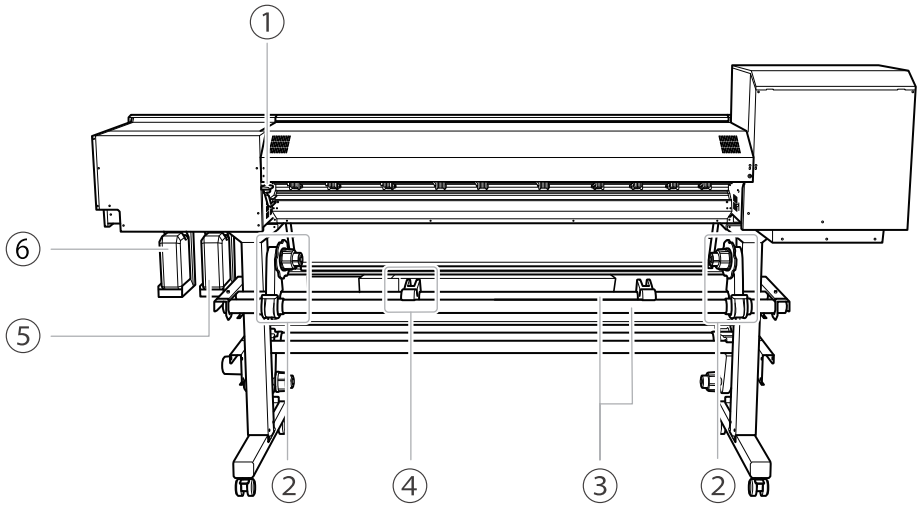
Printer Unit

Front



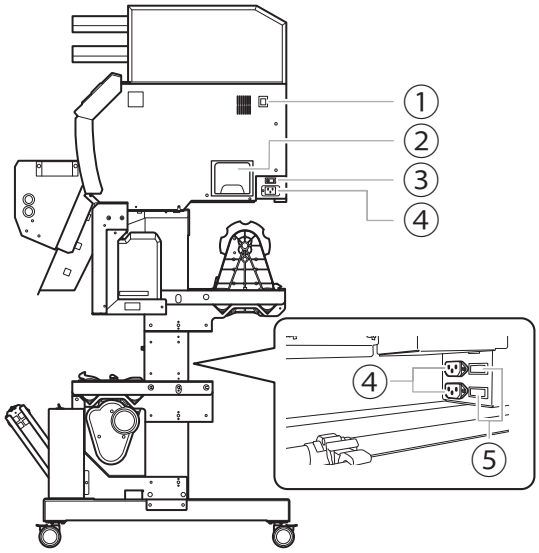
No.	Name	Function overview
①	Ink slots	The slots in which the pouch trays are inserted.
②	Front cover	Open this when necessary, such as when loading media. In all other situations, keep the front cover closed.
③	Loading lever (front)	Operate this when you load media.
④	Operation panel	The panel used to operate the machine. P. 14 Operation Panel
⑤	Right cover	Open this when you perform maintenance.
⑥	Left cover	Open this when you perform maintenance.
⑦	Dryer	Dries the ink after printing. ⚠ WARNING **High Temperature** The areas inside the dryer, under the dryer, and near the extension apron become hot. Exercise caution to avoid burns.
⑧	Take-up Unit	Takes up the media after printing. P. 13 Take-up Unit

Rear



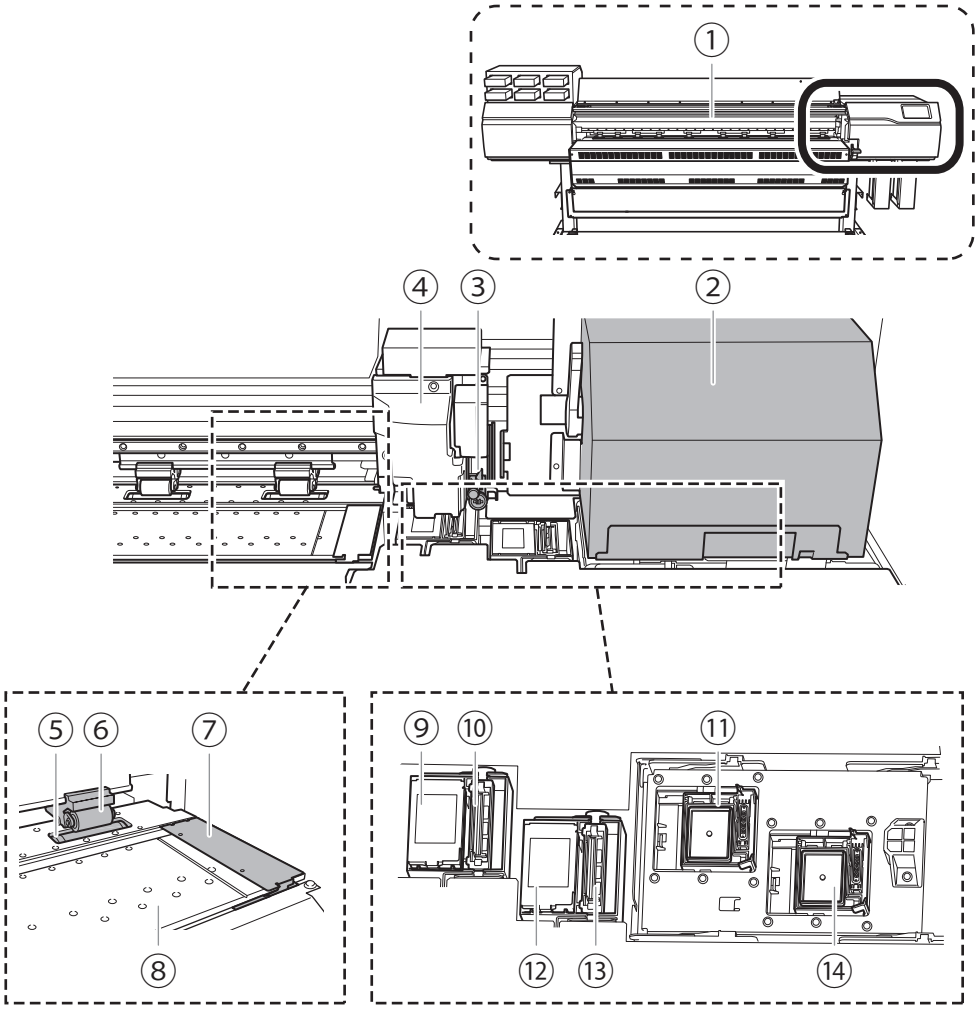
No.	Name	Function overview
①	Loading lever (rear)	Operate this when you load media.
②	Media holders	Operate this when you load media.
③	Shafts	
④	Media stays	
⑤	Drain bottle (optimizer ink section)	Discharged fluid is stored in this bottle. **IMPORTANT** Make sure that the optimizer ink and color ink section drain bottles are installed correctly. If the optimizer ink and color ink mix, the ink may harden and cause a malfunction.
⑥	Drain bottle (color ink section)	

Side



No.	Name	Function overview
①	Ethernet connector	Use this to connect an Ethernet cable.
②	Cleaning liquid tank	Holds the cleaning liquid used during maintenance.
③	Main power switch	Switches the main power on or off.
④	Power-cord connector	Use this to connect the power cable.
⑤	Dryer power switch	Switches the dryer power on or off.

Front Cover Interior/Print Head Area



No.	Name	Function overview
①	Print light	This light illuminates the front cover interior. This makes it easier to see the printing status. It flashes if a serious error occurs.
②	Print-head carriage	The print heads are inside here.
③	Separating knife	This separates the media.
④	Sub carriage	Moves independently of the print-head carriage, for example when setting the base point.
⑤	Grit roller	This is one of these rollers that feed the media.
⑥	Pinch roller	This clamps the media when the loading lever is lowered.
⑦	Media clamp	This clamps the edge of the media to keep it from coming loose. It also prevents fuzz on the cut edge of the media from touching the print heads.
⑧	Platen	This is the path over which the media passes. A suction fan that keeps the media from coming loose and a print heater that helps fix the ink are built in.
⑨	Flushing pad (optimizer ink section)	To maintain print quality, ink discharged from the heads is absorbed.
⑩	Wiper (optimizer ink section)	Cleans the print heads during automatic cleaning and in similar situations. The tray houses the cleaning liquid used to clean the wiper.

No.	Name	Function overview
⑪	Print head cap (optimizer ink section)	Protects the head surfaces and suctions ink during head cleaning.
⑫	Flushing pad (color ink section)	To maintain print quality, ink discharged from the heads is absorbed.
⑬	Wiper (color ink section)	Cleans the print heads during automatic cleaning and in similar situations. The tray houses the cleaning liquid used to clean the wiper.
⑭	Print head cap (color ink section)	Protects the head surfaces and suctions ink during head cleaning.

RELATED LINKS

- P. 12 Serious Errors Indicated by the Print Light

Serious Errors Indicated by the Print Light

If an error that may lead to serious damage to the printer occurs, the print light blinks.

This indicates one of the situations shown below.

When the print light blinks, the error also appears on the operation panel's display screen.

Display screen	Error overview
[Print Head Dry-out Error]	The print heads were about to dry out. The print heads may be damaged if allowed to dry out.
[Motor Error]	An excessive load was applied to the motor. If this error is not addressed, the print heads may be damaged.
[Low Temperature Error]	The ambient temperature in the printer's installation location has fallen below the temperature in which operation is possible. If this error is not addressed, the printer may malfunction.
[High Temperature Error]	The ambient temperature in the printer's installation location has risen above the temperature in which operation is possible. If this error is not addressed, the printer may malfunction.
[Service Call]	An unrecoverable error or an error that requires a part replacement has occurred.

RELATED LINKS

- P. 230 Error Messages

If a Cover Opens during Operation

If the front cover, left cover, or right cover (hereinafter referred to as "cover") opens during an output operation or while setting up the media, the machine makes an emergency stop. When an emergency stop occurs, a message prompting you to close the cover appears on the screen. Close the covers as directed in the instructions shown on the screen.

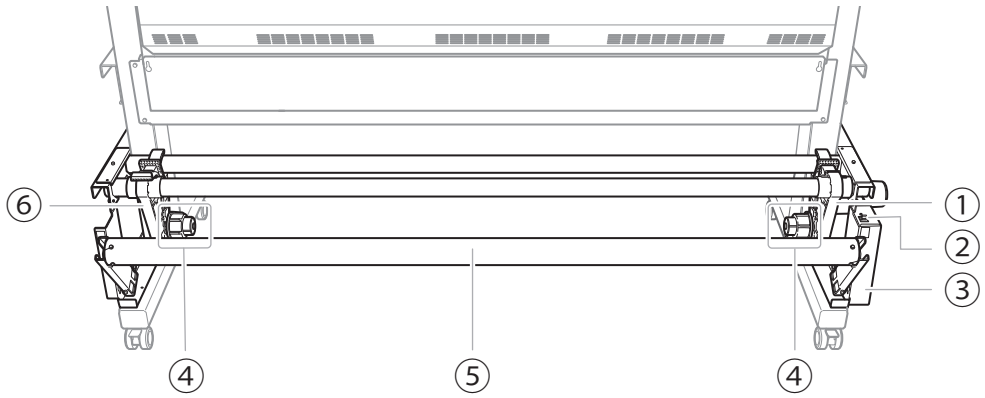
When the cover is closed, you will be able to continue the operation.

If you cannot continue the operation even after you close the cover, a nonrecoverable error may have occurred.

RELATED LINKS

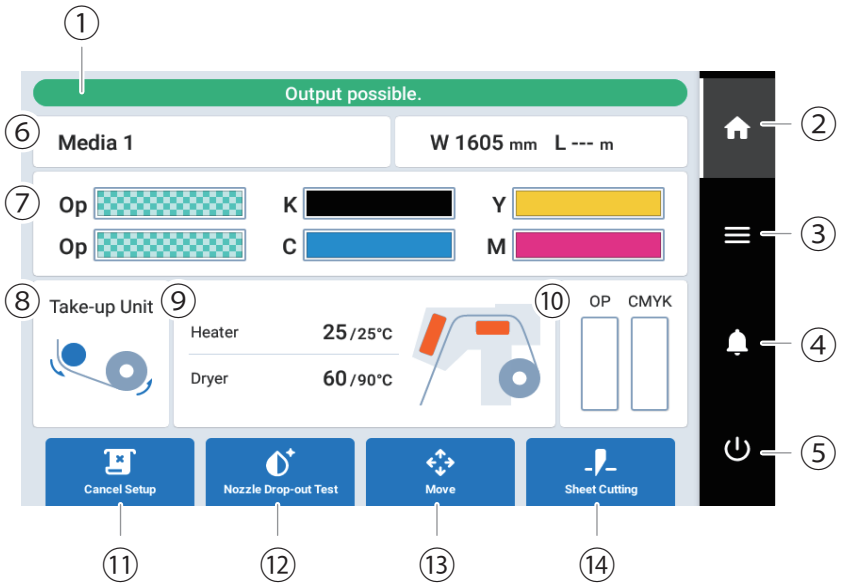
- P. 230 Error Messages

Take-up Unit



No.	Name	Function overview
①	Motorized media holder	This is used when loading the paper tube for take-up. A built-in motor rotates the tube.
②	MANUAL switch	Used when taking up media manually, not with the operation panel.
③	Control box	This controls the media take-up.
④	End caps	These are used when loading the paper tube for take-up.
⑤	Dancer roller	This keeps the media tension constant.
⑥	Left media holder	This is used when loading the paper tube for take-up.

Operation Panel



No.	Name	Details
①	Status bar	Displays the printer status and indicates the next operation.
②	Home	Displays the home screen.
③	Menu	Displays various setting menus.
④	Notifications	Displays important information. When there are notifications, their number is displayed next to the icon.
⑤	Sub power	Controls the power to the operation panel.
⑥	Media information	Displays the media name, media width (W), and remaining media (L). This information is only displayed when media has been set up and there is media remaining. Tap the media width (W) or the remaining media (L) to display the [**Remaining Media Management**] screen on which you can set the remaining media. P. 143 Checking the Remaining Media
⑦	Amount of ink remaining	Displays the amount of ink remaining for each ink type. If it is time to replace ink,  is displayed next to the corresponding type. Tap this icon to display the detailed information for the ink.
⑧	Take-up Unit	Displays the status of the take-up unit. Tap this icon to display the [**Take-up**] screen on which you can set the [**Take-up Method**] and [**Take-up Direction**].
⑨	Heater and dryer temperatures	The print heater and dryer temperatures are displayed as current temperature/set temperature. Tap one of these items to display a screen for: • Turning [**Print Heater**] on/off and setting its temperature. • Temperature of [**Dryer**]

No.	Name	Details
⑩	Discharged Ink	Displays the amount of discharged fluid. When it is necessary to discard discharged fluid,  appears. • [OP]: Amount of discharged fluid in the optimizer ink section • [CMYK]: Amount of discharged fluid in the color ink section P. 9 Rear P. 174 Disposing of Discharged Fluid
⑪	[Setup]/[Cancel Setup]	Starts/cancels the setting up of the media. P. 26 Setup of New Media P. 59 Setup of Registered Media
⑫	[Cleaning]/[Nozzle Drop-out Test]	Displays the menu related to the printing test and cleaning for the nozzle drop-out check.
⑬	[Move]	Feeds the media and moves the carriage. You can also set the position moved to as the right edge of the output area (the base point). P. 136 Adjusting the Output-start Location
⑭	[Sheet Cutting]	Activates the separating knife to separate the media. You can also perforate the media to take it up and separate it at a later time.

Menu List

Tap  to display the following list of operations to perform from the screen.

MEMO

[**Media Settings**] only appears when media is loaded.

Level 1	Level 2	Level 3	Level 4	Details
[**Media Settings**]	[**List of Media Settings**]			Lists the settings of the media that has been set up. Tap a setting to move to a screen for changing this setting.
	[**Printing Settings**]	[**Print Head Height**]		Checks/changes the head height.
		[**Batch Automatic Correction**]		Adjustments are performed in the following order: [**Multi Sensor Adjustment**], [**Media Gap Adjustment**], then [**Feed Correction**].
		[**Feed Correction**]	[**Simple Correction (Auto)**]	Adjusts the media feed amount during printing. With [**Simple Correction (Auto)**], a test pattern is printed and then read with a sensor to automatically set the correction value.
			[**Detailed Correction (Manual)**]	Adjusts the media feed amount during printing. With [**Detailed Correction (Manual)**], a test pattern is printed, and then the correction value is entered manually after the printed correction value is checked visually.
		[**Media Gap Adjustment**]	[**Simple Correction (Auto)**]	Corrects the ink landing position. With [**Simple Correction (Auto)**], a test pattern is printed and then read with a sensor to automatically set the correction value.
			[**Detailed Correction (Manual)**]	Corrects the ink landing position. With [**Detailed Correction (Manual)**], a test pattern is printed, and then the correction value is entered manually after the printed correction value is checked visually.
	[**Heater Settings**]	[**Heater Temperature**]	[**Print Heater**]	Switches the print heater on/off and changes the set temperature.
			[**Dryer**]	Changes the set temperature of the dryer.
		[**Pullback After Printing**]		Switches on/off the function that pulls back onto the platen the media dried with the dryer after printing.
	[**Other Media Settings**]	[**Multi Sensor Adjustment**]		Optimizes the status of the multi sensor used with the automatic correction function.
		[**Media Suction Force**]		Adjusts the media suction force of the platen.
		[**Printing Movement Range**]		Select the carriage movement range during printing from [**Output Data Width**], [**Media Width**], and [**Full Width**].
		[**Media Sticking Prevention**]		When set to [**Enable**], the media is peeled off before printing.
	[**Batch Media Settings**]			The minimum settings required for media setup can be configured by following the on-screen instructions on the operation panel.
[**Media Management**]				Displays a list of registered media. Up to 20 media names can be saved, and the following operations on media settings are possible. • Checking setting details in a list • Changing media names • Copying media settings • Deleting media settings

Level 1	Level 2	Level 3	Level 4	Details
[Cleaning]	[Printing Test]			Before printing, use [**Nozzle Drop-out Test**] to check whether ink is discharged from the print heads correctly. If nozzle drop-out is present, perform cleaning appropriate for the severity of the drop-out. In the [**Nozzle Drop-out Test**], there is a printing test in which media is dried by the dryer and a printing test in which media is not dried by the dryer.
	[Normal Cleaning]			If dot drop-out or dot displacement occurs, select the nozzle and then perform cleaning of the print heads. If the problem cannot be fixed, perform more powerful cleaning.
	[Medium Cleaning]			
	[Powerful Cleaning]			
	[Manual Cleaning]			Use cleaning liquid and a cleaning stick to clean the area around the print heads.
[Maintenance]	[Wiper Replacement]			Replace the wipers.
	[Separating Knife Replacement]			Replaces the separating knife used in media separation.
	[Flushing Pad Replacement]			Replaces the flushing pad.
	[Wiper Tray Cleaning]			Use this operation to clean the wiper tray.
	[Tray Cleaning Liquid Discharge]			Use this operation to discharge the cleaning liquid from the wiper tray and flushing pad tray.
	[Ink Renewal Inside Heads]			Perform this operation when ink discharge issues or uneven colors are not resolved even after [**Normal Cleaning**], [**Medium Cleaning**], [**Powerful Cleaning**], and [**Manual Cleaning**]. However, this operation consumes a large amount of ink, so do not perform it more than necessary.
	[Drain Bottle]			A message appears when discharged fluid has collected in the drain bottle. Use this menu item to discard this fluid.
[Preferences]	[Print Light]			Select [**On**], [**Off**], or [**Auto**] for the print light. Select [**Auto**] to automatically turn the light on/off according to the status of the printer.
	[Take-up]			Sets the [**Take-up Method**] and [**Take-up Direction**] for the take-up unit.
	[Remaining Media Management]			Sets the amount of remaining media that has been set up and displays this amount. This amount can also be printed on the media.
	[Skewing Correction Support at Setup]			Provides support, preventing skewed installation of the media by making a sound and operating an automatic suction fan during setup.
	[Printing Test Position]			Sets the direction for test pattern printing: [**Feed**] or [**Scan**].
	[Perforated Sheet Cutting]			Sets the perforated sheet cutting conditions.
	[Standby Heater Temperature]			Sets the heater temperature when media has not been set up.
	[Notifications On/Off]			When [**Enable**] is selected, notifications are displayed at the appropriate times. • [**Ink Expiration Date Notification**] • [**Media Clamp Placement Notification**]
	[Sleep Time]			Sets the time until sleep mode (the state in which the power-saving features operate) activates.
	[Reset to Factory Defaults]			Returns all settings other than [**Language**] and [**Units**] to their factory default values.

Level 1	Level 2	Level 3	Level 4	Details
[System Information]	[Machine Information]			Displays the [Model], [Serial Number], [Ink Type], [Firmware Version], and [MAC Address].
	[Network]			Sets the [Obtain IP Address Automatically], [IP Address], [Subnet Mask], and [Default Gateway] to connect the machine to a computer.
	[Units]			Sets the [Length] and [Temperature].
	[Language]			Sets the language. Languages that can be set are Japanese, English, French, Italian, German, European Spanish, South American Spanish, South American Portuguese, and Simplified Chinese.
	[Date/Time]			Sets the current year, month, day, hour, minute, and second.
	[Screen Brightness]			Sets the brightness of the operation panel's screen.
	[Screen Operation Sound]			Turns the operation sound of the operation panel on/off.
	[License]			Displays the license information of the operation panel.

About the Media Used

Types of Media

In this manual, the paper used for output is called "media." The two main types of media used in this machine are shown below.

- Roll media: Media wound onto a paper tube
- Sheet media: Media not wound onto a paper tube such as standard-size media

Various paper types of roll media and sheet media are selectable according to your purpose. For detailed information about each media, contact your media supplier.

Take-up Unit

Take-up Unit Use Conditions

Never pull the media with excessive force.

If the media is pulled with excessive force, the protection function will activate and cause an error. Make sure to observe the following to prevent the media from being pulled with excessive force.

- **Do not operate the manual switch on the take-up unit while leaving media secured with the loading lever.**

  It may cause an error because the media is pulled with excessive force.

Never use the automatic separation function for media.

If automatic cut-off of media is set in the software RIP, the media will be cut off after each page is printed. When continually printing and taking up multiple pages, disable the automatic cut-off function in the software RIP. If the media is separated, take-up will be interrupted at that point.

MEMO

Perforated sheet cutting can be set with the software RIP. With this type of cutting, the media is not separated, so the take-up unit can be used.

About the Paper Tube

Paper tubes are consumable items.

Paper tubes are components that wear out. Although replacement timing will vary depending on use, watch the condition of the paper tube and replace at an appropriate time so that the media can be taken up in good working order.

Use the paper tube of the media you are using. To purchase the included paper tube, contact your authorized dealer or visit our website (https://www.rolanddg.com/).

Basic Operations

Power Supply Operations 22
- Turning the Power On 23
- Turning the Power Off 24
- Sleep Mode (Power-saving Feature) 25

Setup of New Media 26
- Setup of Roll Media 26
- Setup of Sheet Media 47

Setup of Registered Media 59
- Setup of Roll Media 59
- Setup of Sheet Media 78

Checking before Output 88
- LAN (Local Area Network) Settings 88

Pausing and Canceling Output 89
- Pausing and Resuming Output 89
- Canceling Output 90

Separating the Media 91

Removing Media from the Take-up Unit 94

Ink Pouch Replacement 96
- Out-of-ink Warnings 96
- Ink Pouch Replacement 97

Cleaning Liquid Replenishment 103
- Out-of-cleaning-liquid Warnings 103
- Cleaning Liquid Replenishment Method 104

Power Supply Operations

IMPORTANT

Always keep the main power switched on.

Never switch off the main power. Leaving the main power enables automatic maintenance to be carried out periodically. If the automatic maintenance is not carried out, it may result in the breakdown of this machine, such as the breakdown of the print heads.

Never switch off the main power or unplug the power cord suddenly while operation is in progress.

Switching off the main power or unplugging the power cord suddenly while operation is in progress may damage the print heads. Be sure to first switch off the sub power. If the main power is accidentally switched off, immediately turn the main power and sub power back on.

Turning the Power On

⚠ WARNING

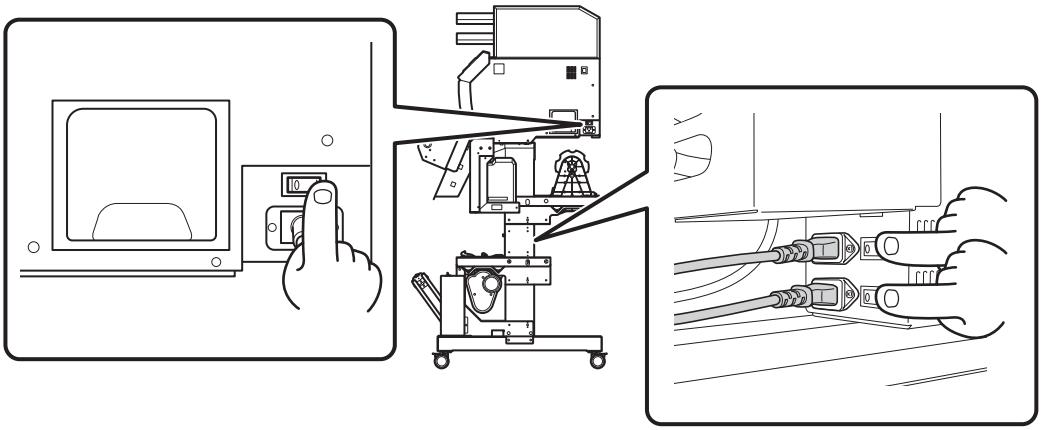
When output is not being performed, remove any loaded media or switch off the sub power.

The continued application of heat at a single location may cause the release of toxic gases from the media or pose a fire hazard.

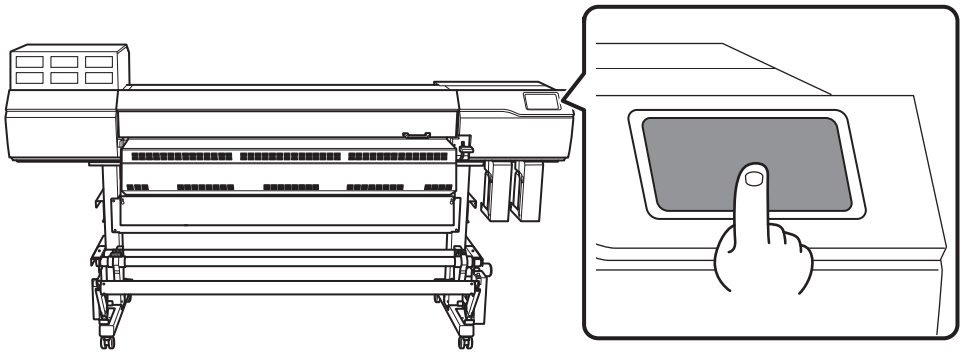
Procedure

1. **Close the front cover.**

2. **Switch on the main power switch for the two dryers and the printer.**



3. **Tap the operation panel.**



4. **When instructions appear on the screen, tap the operation panel again.**

   The power to the operation panel is switched on.

Turning the Power Off

⚠ WARNING

When output is not being performed, remove any loaded media or switch off the sub power.

The continued application of heat at a single location may cause the release of toxic gases from the media or pose a fire hazard.

Procedure

1. **When printing is complete, tap  on the operation panel.**

   The confirmation screen appears.

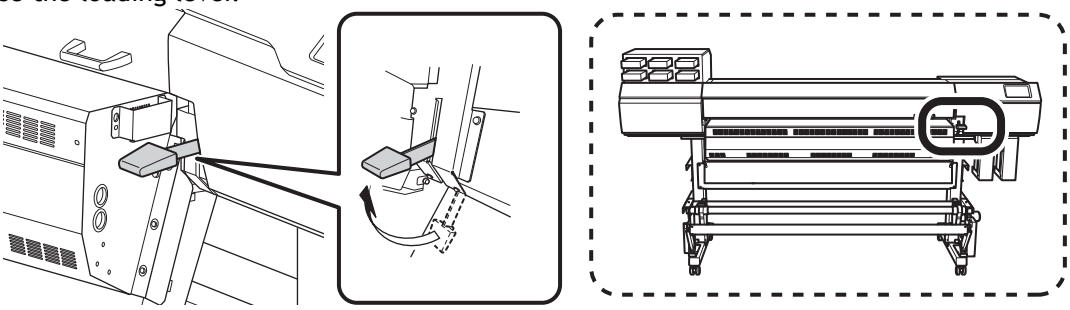
2. **Tap [Yes].**

   The sub power switches off automatically.

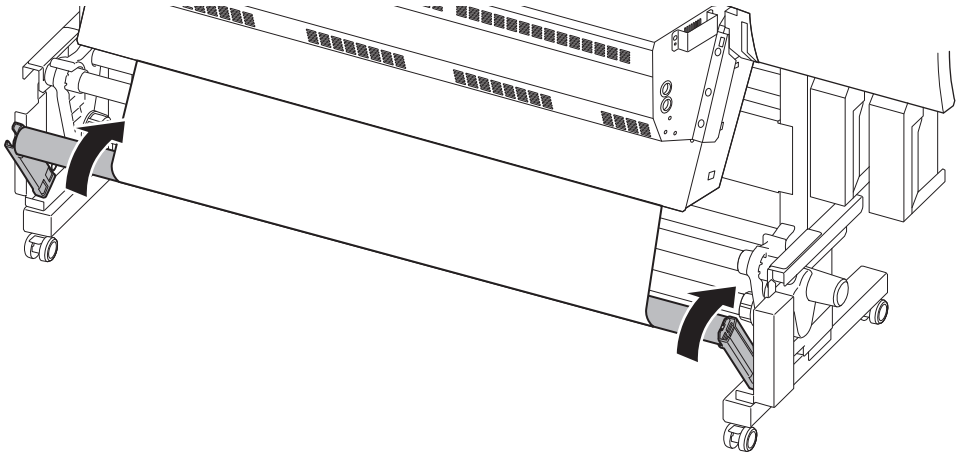
3. **Raise the loading lever and remove the media.**

   If you will leave the sub power on while not using the machine, set it as shown below.

   - Raise the loading lever.



   - Lower the dancer roller toward the rear.



Sleep Mode (Power-saving Feature)

This machine is provided with a power-saving feature that switches to a low-power "sleep mode" when a fixed interval passes with no operation. The factory default for the time after which the machine switches to sleep mode is 30 minutes. The operation panel turns off when the machine enters sleep mode. Using the operation panel or performing operations such as sending print data from the computer restores the machine to its normal mode.

This sleep mode setting can be changed. However, we recommend setting the activation time for sleep mode to 30 minutes or less to reduce power consumption and prevent problems such as overheating.

RELATED LINKS

- P. 146 Setting the Activation Interval for Sleep Mode (Power-saving Feature)

Setup of New Media

⚠ CAUTION

Do not touch the dancer roller needlessly.

The media take-up unit and feeder may move suddenly, which may result in injury.

Setup of Roll Media

Load the roll media on the printer. When the loading is finished, [**Output possible.**] is displayed as the status. This work is referred to as "Setup of Media."

⚠ CAUTION

Load the roll media correctly.

Otherwise the media may fall and cause injury.

⚠ CAUTION

The roll media is approximately 45 kg (99 lb.).

To avoid injury, handle the roll media with care.

⚠ CAUTION

Never load media that weighs over 45 kg (99 lb.).

The machine may fail to withstand the weight and tip over or cause the media to fall.

1. Install the media on the media holders.

The media holders of this machine are designed to be used with a paper tube (core) with an inner diameter of 2 inches or 3 inches.

⚠ WARNING

Handling roll media is an operation that must be performed by 2 persons or more, and care must be taken to prevent falls.

Attempting to lift heavy media in a manner that taxes your strength may cause physical injury. Also, if dropped, such items may cause injury.

Procedure

1. **Tap  on the operation panel.**

   The sub power is switched on.

2. **When using a take-up unit, use the following procedure to set it.**

   (1) **Tap .**

   (2) **Tap [Preferences]>[Take-up]>[Take-up Direction].**

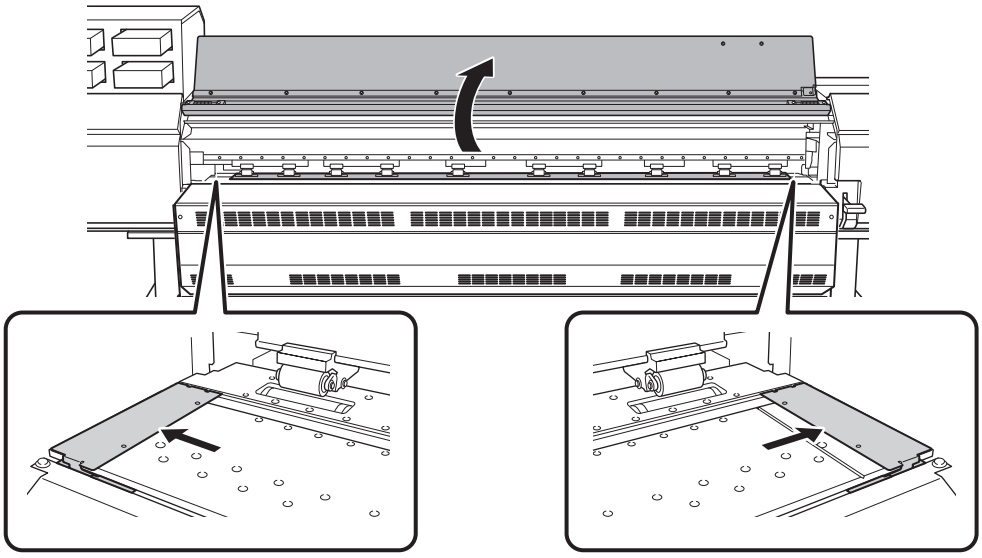
(3) Select [Backward] or [Forward].

(4) Tap [Save].

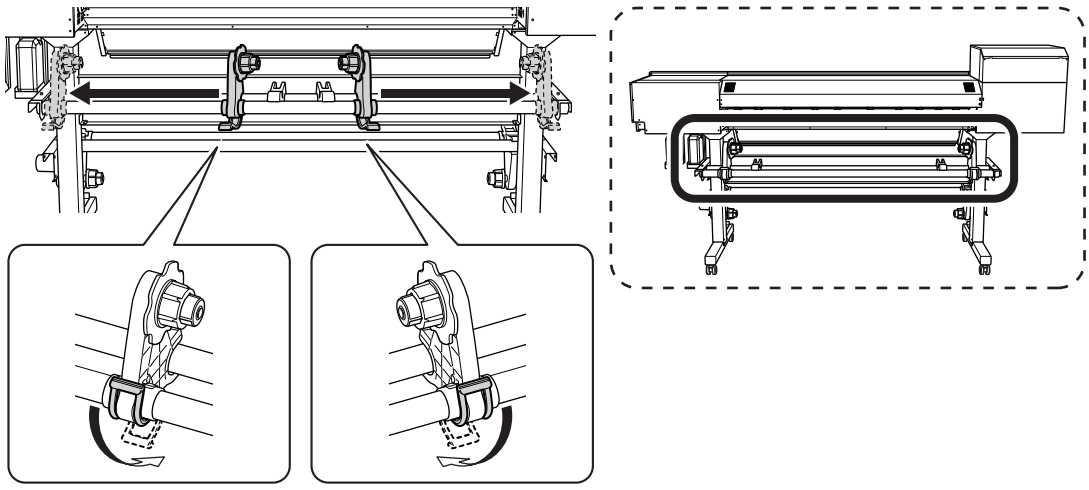
(5) Tap  to go back to the original screen.

3. Open the front cover.

4. Move the media clamps to the outside of the grit rollers on the left and right edges respectively.



5. Release the locking mechanisms of the media holders, and then draw them to the left and right ends respectively.



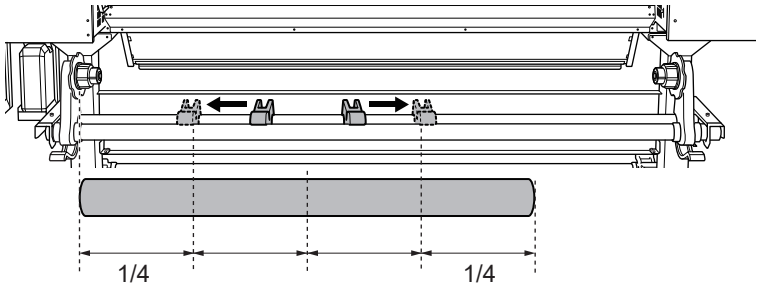
6. Place the media on the machine.

IMPORTANT

Do not leave media on the media stays or the pipes for a long period of time. The media may become deformed. Exercise caution.

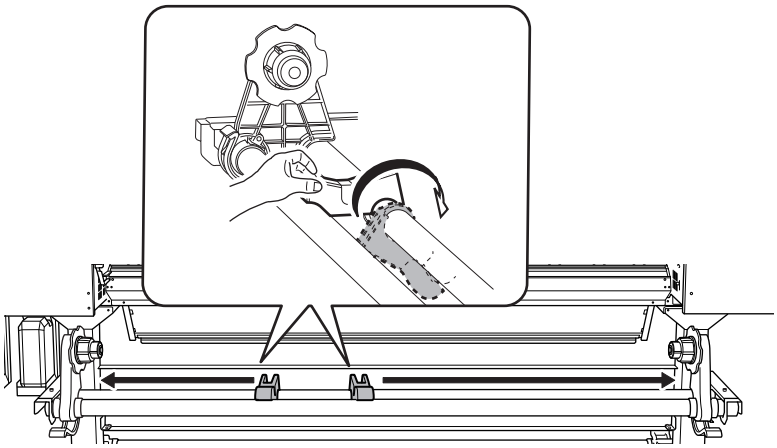
- **Media with an outer diameter of 220 mm (8.66 in.) or less**

  Place the media stays at positions that are 1/4 the length of the media from each end of the media, and then load the media.

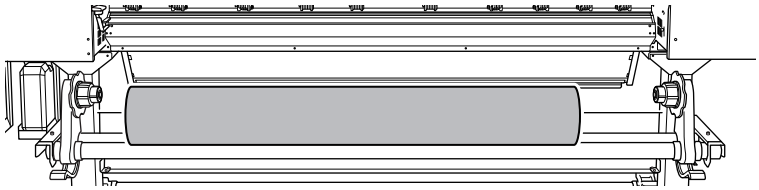


- **Media with an outer diameter exceeding 220 mm (8.67 in.)**

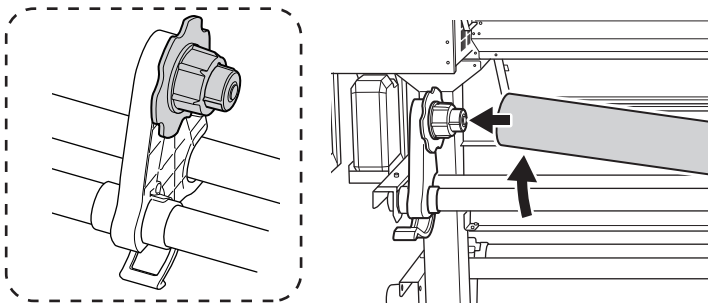
  a. Rotate the media stays to draw them to the media holders.



  b. Place the media directly between the two pipes.

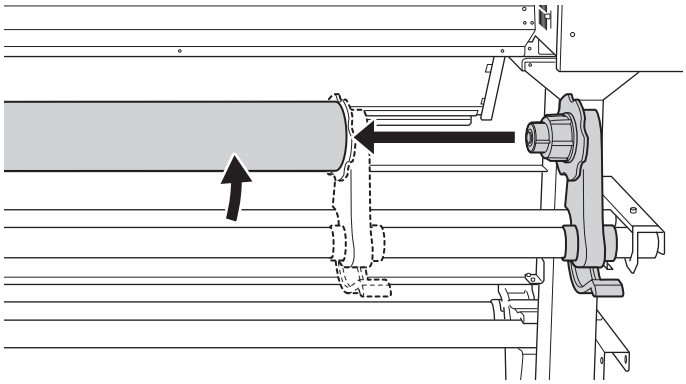


7. **Fit the paper tube (core) of the media onto the end cap of the left media holder.**



8. **Move the right media holder to fit its end cap onto the paper tube (core) of the media.**

Fit the paper tube onto the media holders securely to prevent the media from moving easily.



IMPORTANT

Do not secure the media holders in place just yet.

In the following procedure, you will adjust the positions of the media holders before securing them in place. Do not secure them in place just yet.

The next operation to perform varies depending on the media type. Proceed as shown below.

- Opaque media: 2. A: Determine the positions of the media (opaque media).(P. 30)
- Transparent media, etc.: 2. B: Determine the positions of the media (transparent media, etc.).(P. 34)

2. A: Determine the positions of the media (opaque media).

This section describes how to use the suction fan to prevent media skewing.
By default, **[Skewing Correction Support at Setup]** is set to **[Enable]**.

Procedure

1. **Set the [Skewing Correction Support at Setup].**

(1) **Tap**  **.**

(2) **[Preferences]>[Skewing Correction Support at Setup]**

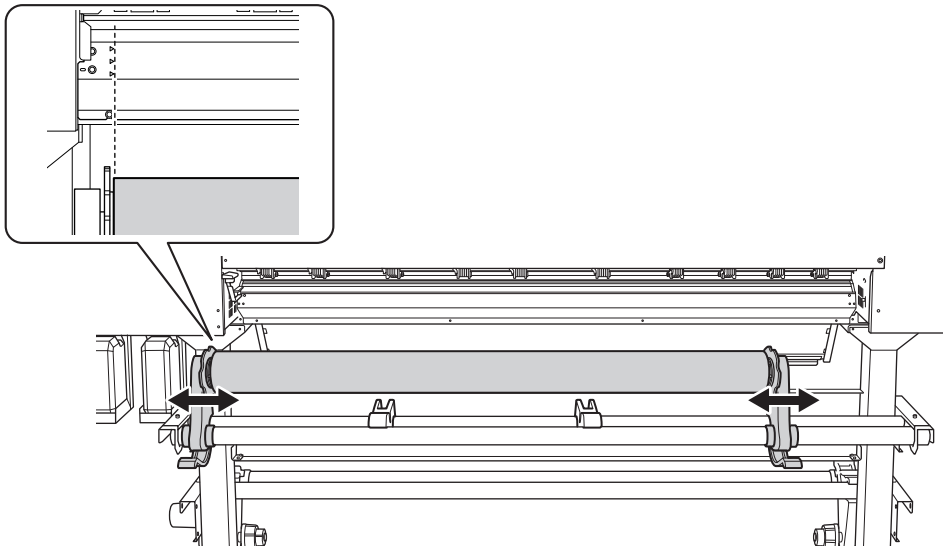
(3) **Select [Enable] and tap [Save].**

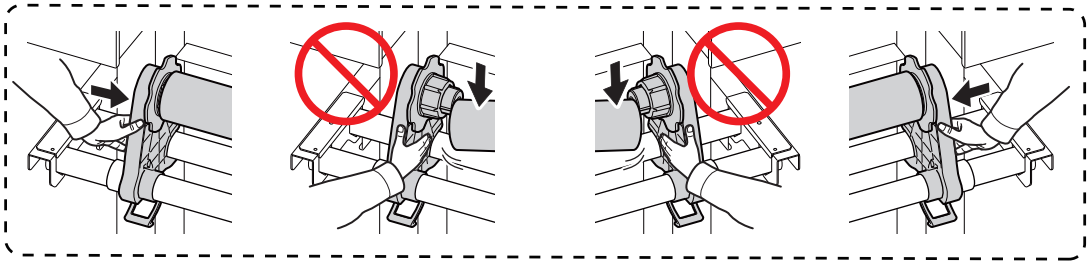
(4) **Tap**  **to go back to the original screen.**

2. **Align the left edge of the media with the mark.**

Note the following points when determining the positions.

- Hold the media holders from the outside and move them.
- Move the media holders so that the edge of the media is on the right side of the mark.





⚠ CAUTION

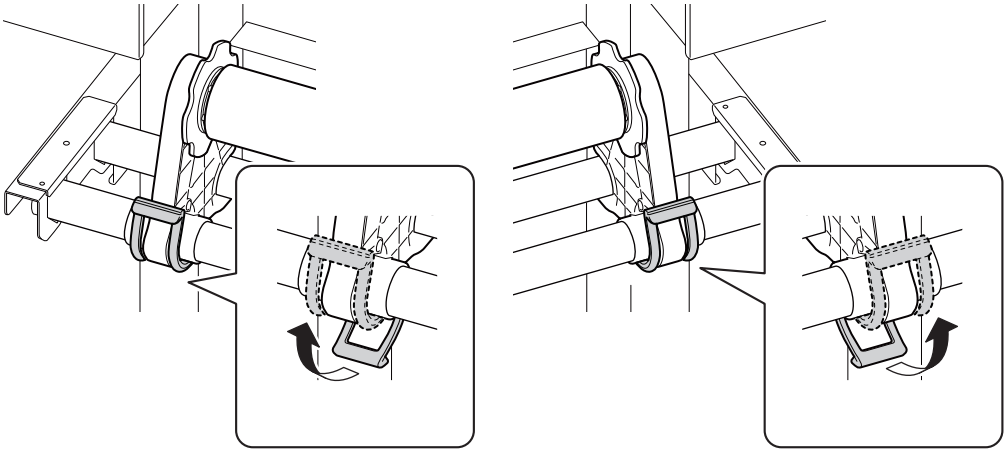
Do not hold places other than those instructed. Do not move the media by holding it directly.
Otherwise the media may fall off the media holder and cause injury.

IMPORTANT

Firmly decide the left and right side positions of the media at this point.

After this procedure is completed, if the left and right side positions do not fit the proper positions when securing the media with pinch rollers, you will have to go back to this step to redo this procedure. If you just hold the media to readjust its position forcibly, the media will be skewed during printing, which will have an adverse effect on the printing results.

3. **Secure the media holders.**



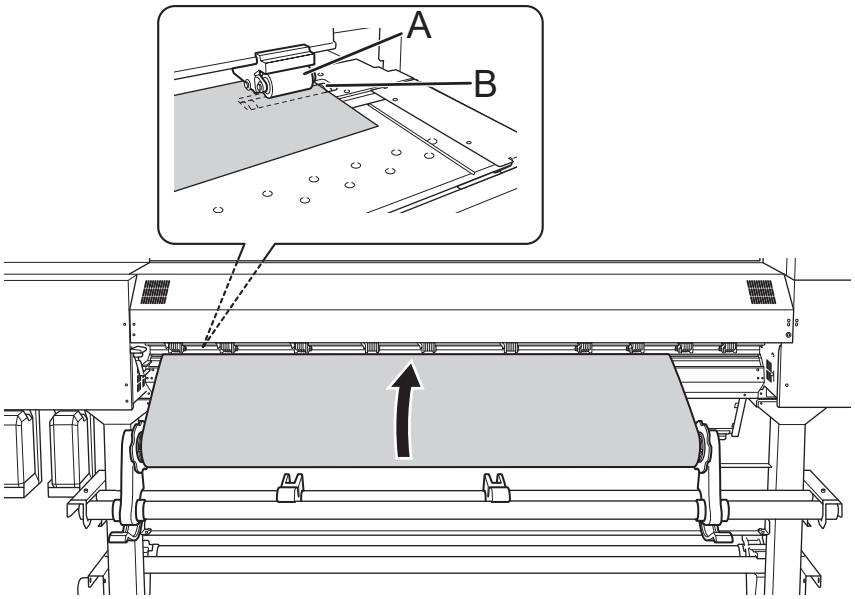
4. **Use the following procedure to load the media.**

Doing so will prevent media skewing.

IMPORTANT

If the leading edge of the media is bent, cut the bent part before loading the media, as it may be difficult for the media to enter the dryer entrance.

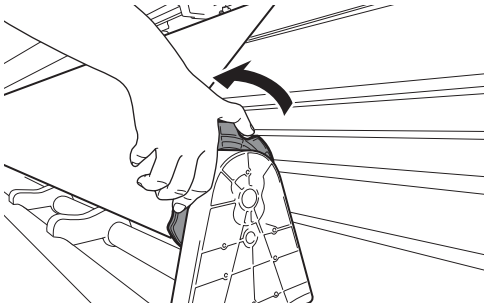
(1) **Pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**



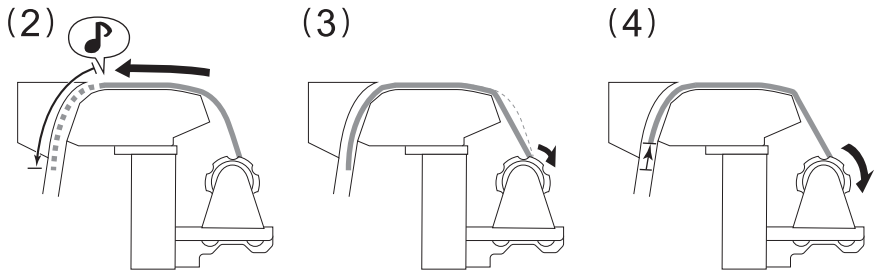
(2) **Feed the media until you hear a beep, and then additionally feed approximately 30 cm (11.81 in.) of the media.**

You will hear a beep. Approximately 5 seconds later, you will hear two beeps, and then the suction fan will activate. While this fan is operating, the position of the media will be maintained even if you remove your hands from it.

(3) **Hold the media holder flange, turning it in the take-up direction to eliminate the slack in the media.**



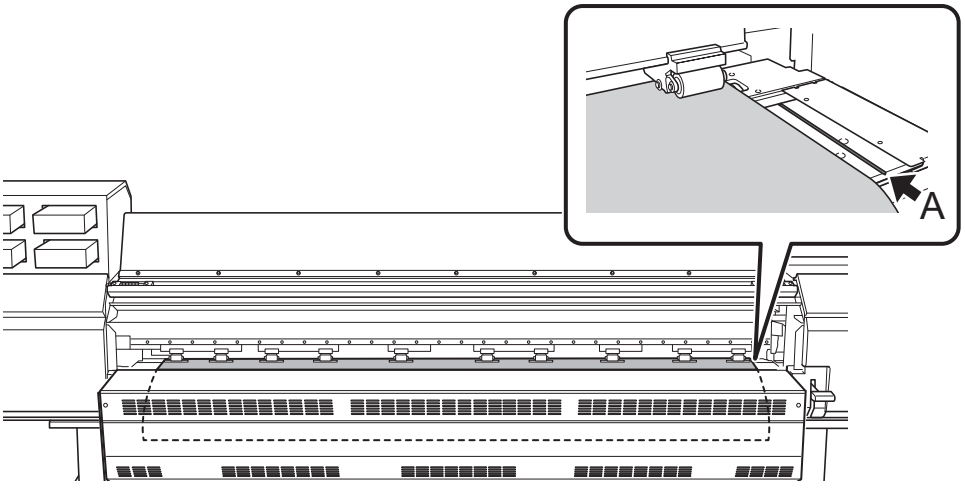
(4) **Once the media is taut, additionally take up approximately 10 cm (3.94 in.) of media.**



MEMO

If you take up too much media, you will hear two short beeps and the suction fan will stop. Take up the media, and then redo the procedure from step (1).

5. (Move to the front of the printer.) Make sure the right edge of the media is in line with the guide line (A).

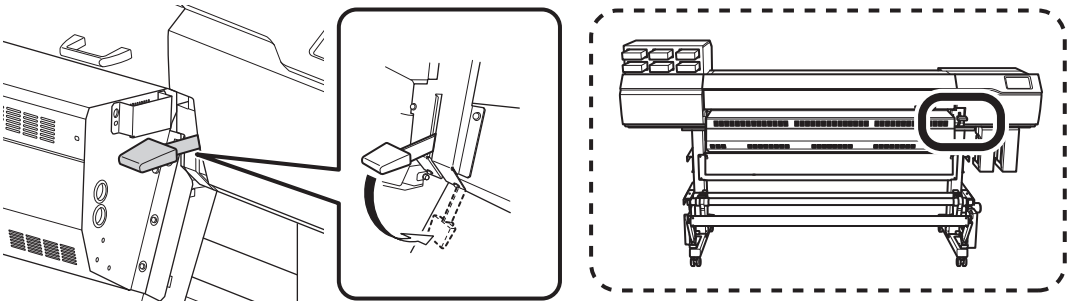


IMPORTANT

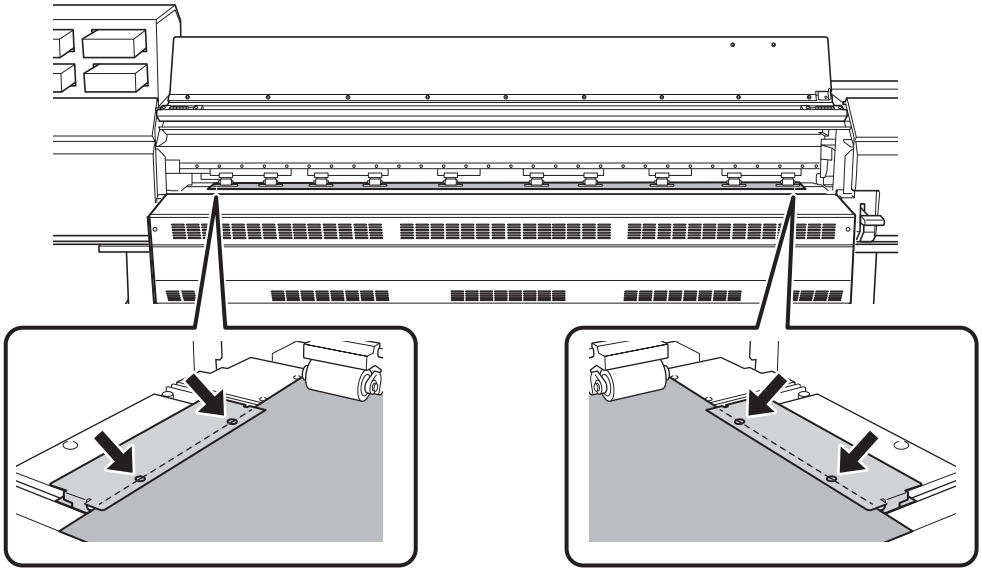
If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from step 1. If you just stand at the front of the printer and hold the media to readjust its position forcibly, the media will be skewed during printing or will come loose, which will affect the printing quality.

6. Lower the loading lever (front).

The media is held in place.



7. **Line up the edges of the media with the centers of the holes of the left and right media clamps.**



IMPORTANT

Be sure to use the media clamps when you load media.

If you attach the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

8. **Close the front cover.**

2. B: Determine the positions of the media (transparent media, etc.).

This section describes how to determine the positions of the media without using the suction fan. Refer to this information when using transparent media and media with high reflectance, whose edges cannot be detected.

Procedure

1. **Set the [Skewing Correction Support at Setup].**

(1) Tap .

(2) **[Preferences]>[Skewing Correction Support at Setup]**

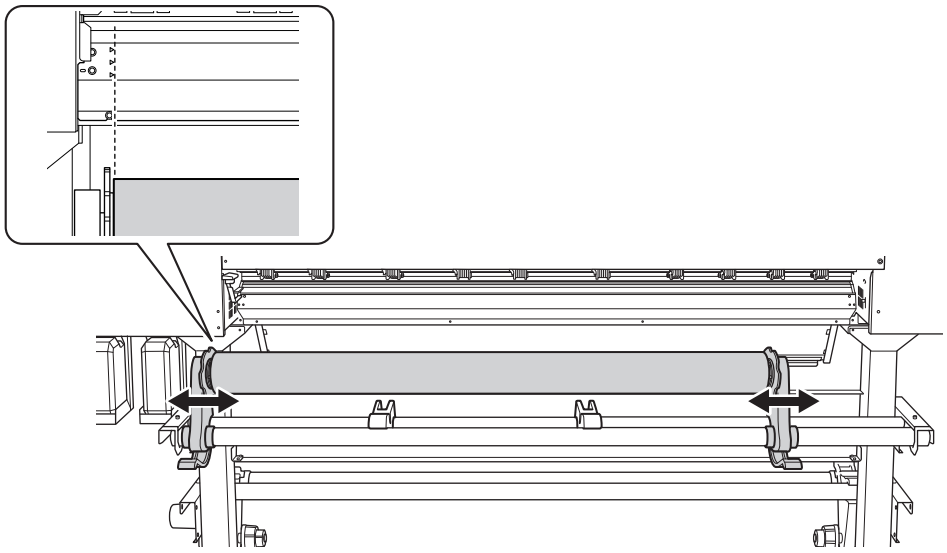
(3) **Select [Disable] and tap [Save].**

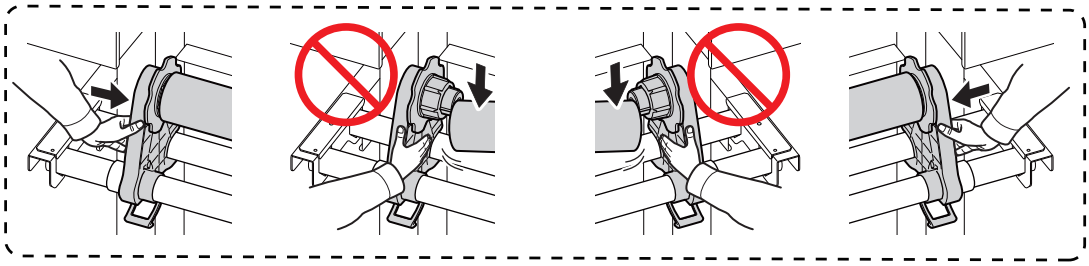
(4) Tap  **to go back to the original screen.**

2. **Align the left edge of the media with the mark.**

Note the following points when determining the positions.

- Hold the media holders from the outside and move them.
- Move the media holders so that the edge of the media is on the right side of the mark.





⚠ CAUTION

Do not hold places other than those instructed. Do not move the media by holding it directly.

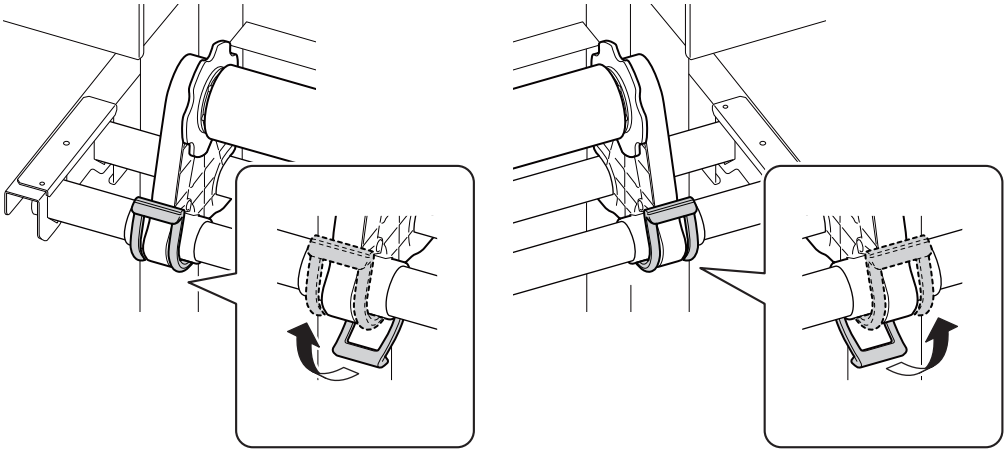
Otherwise the media may fall off the media holder and cause injury.

IMPORTANT

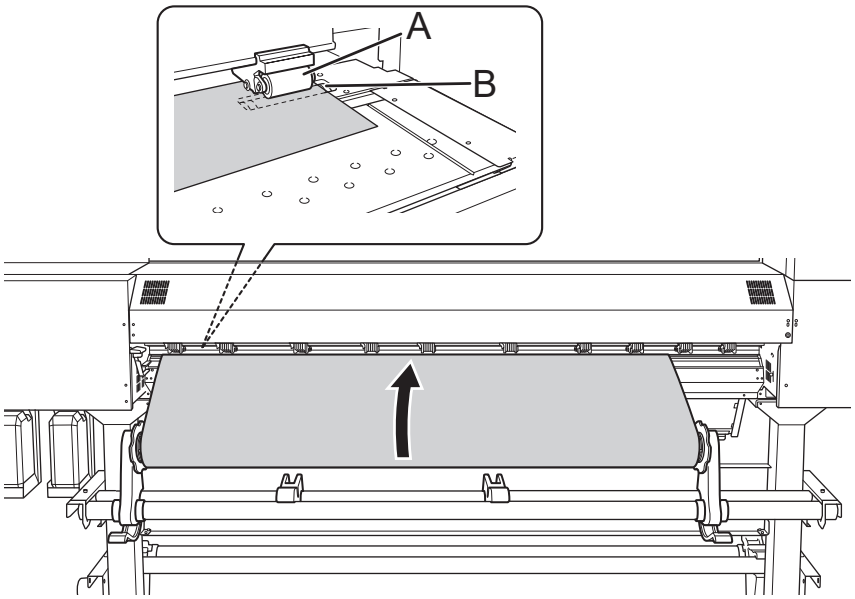
Firmly decide the left and right side positions of the media at this point.

After this procedure is completed, if the left and right side positions do not fit the proper positions when securing the media with pinch rollers, you will have to go back to this step to redo this procedure. If you just hold the media to readjust its position forcibly, the media will be skewed during printing, which will have an adverse effect on the printing results.

3. **Secure the media holders.**

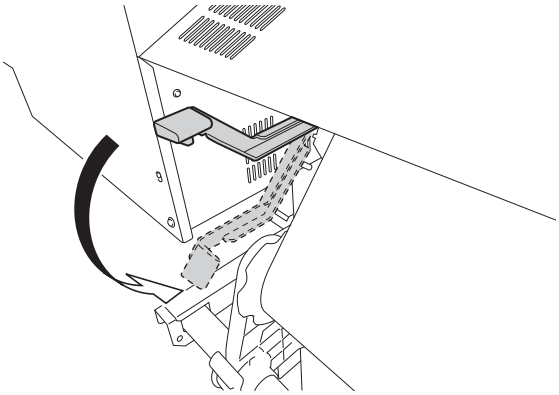


4. **Pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**

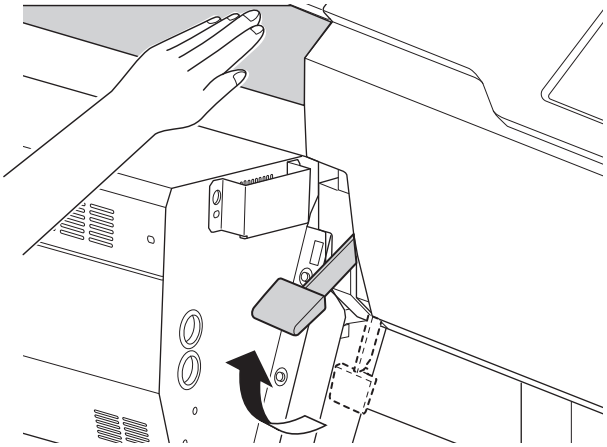


5. **Lower the loading lever (rear).**

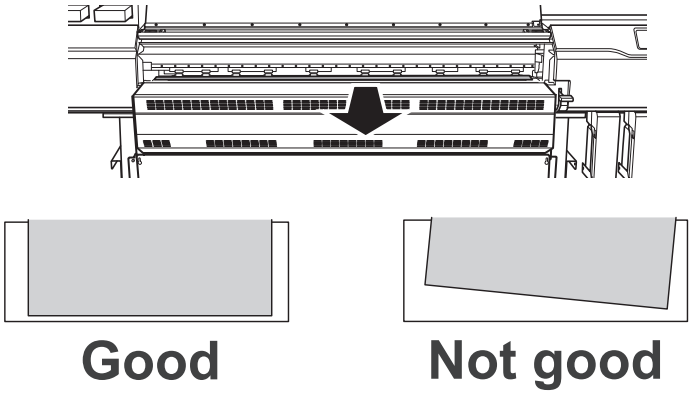
The media is held in place.



6. **(Move to the front of the printer.) Gently hold down the media and raise the loading lever (front).**
   The media is released.

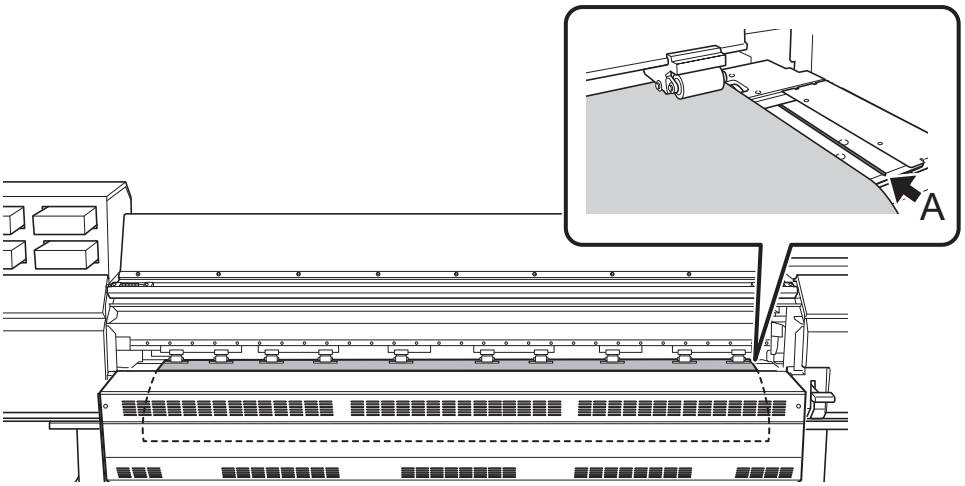


7. **Hold the media at the center and pull it out, being sure to keep it straight and all areas of the media to be taut.**



8. **Insert the leading edge of the media into the dryer.**

9. **Make sure the right edge of the media is in line with the guide line (A).**

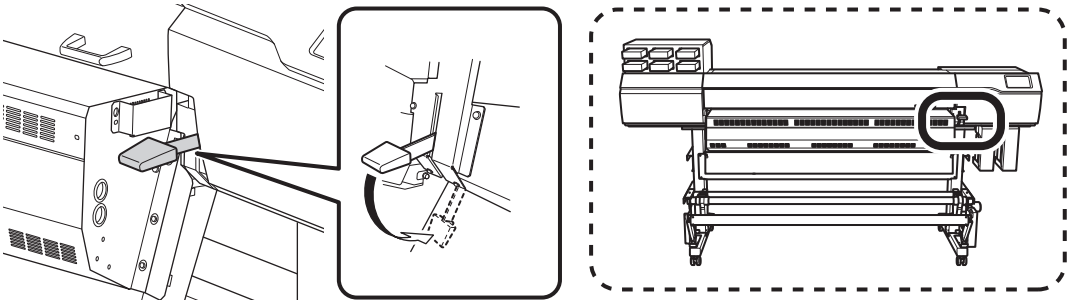


IMPORTANT

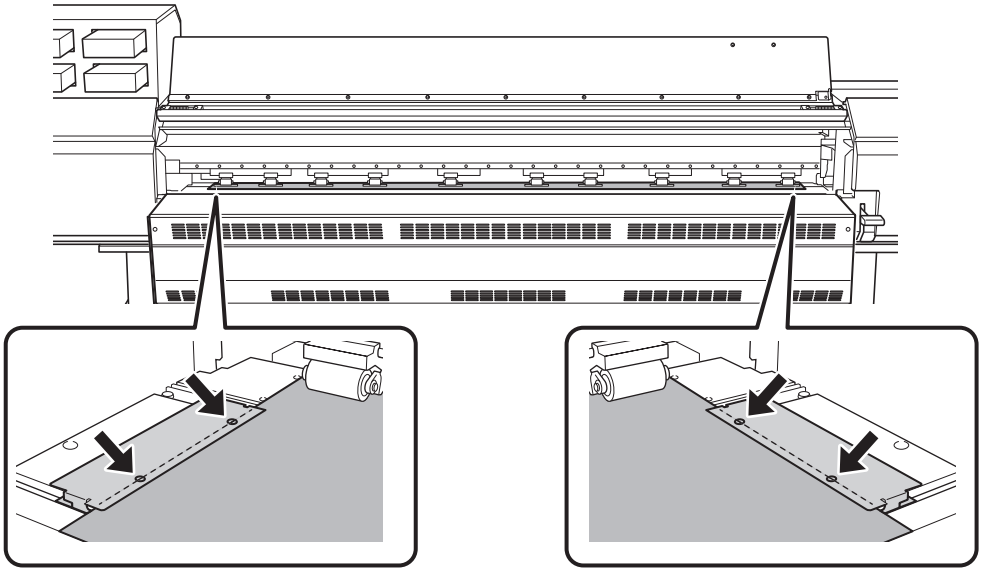
If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from step 1. If you just stand at the front of the printer and hold the media to readjust its position forcibly, the media will be skewed during printing or will come loose, which will affect the printing quality.

10. **Lower the loading lever (front).**

The media is held in place.



11. **Line up the edges of the media with the centers of the holes of the left and right media clamps.**



IMPORTANT

Be sure to use the media clamps when you load media.

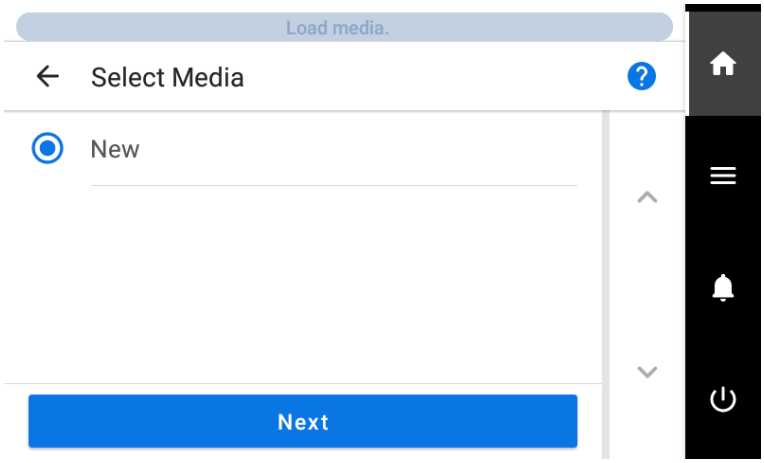
If you attach the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

12. **Close the front cover.**

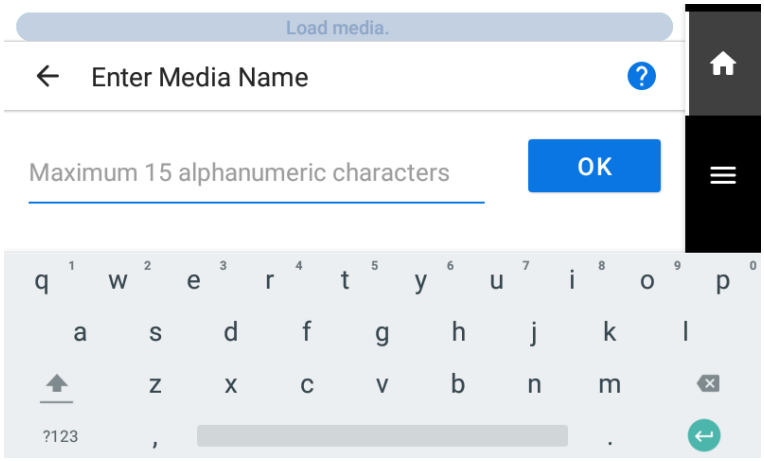
3. Register the media.

Procedure

1. Tap [Setup].
2. Select [New].
3. Tap [Next].



4. Enter a new media name and tap [OK].



5. Tap [Next].
6. On the [Select Sheet Type] screen, select [Opaque]/[Transparent] and tap [Next].
7. The [Sheet Settings] screen appears. Configure the settings as shown below depending on the sheet type.
   - **For opaque media**
     a. Tap [**Side Margin**] to set the margin.
        You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
     b. Tap [**OK**].
   - **For transparent media, etc.**
     - [**Sheet Width**] setting

a. Tap  next to [**Sheet Width**].

b. Enter the sheet width and tap [**OK**].

- [**Sheet Right Edge**] setting
  a. Tap [**Change**] next to [**Sheet Right Edge**].
  b. Tap  or  to move the carriage's base point mark to the right edge of the media, and then tap [**OK**].
- [**Side Margin**] setting
  a. Tap [**Side Margin**] to set the margin.
  You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
  b. Tap [**OK**].

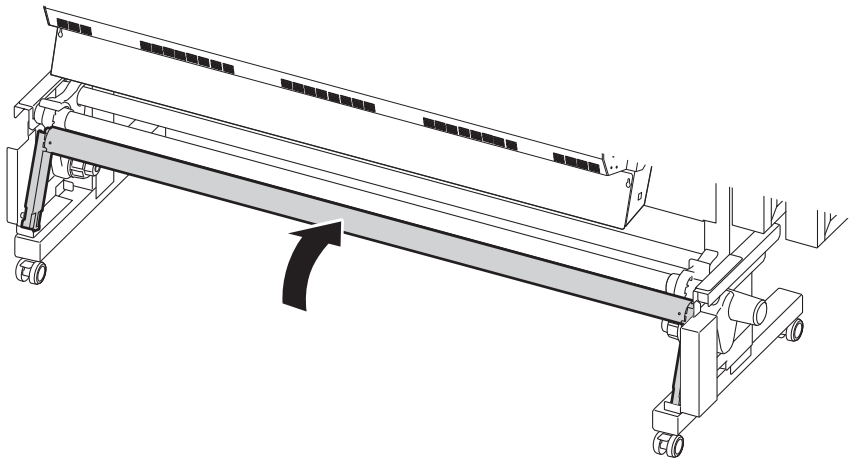
8. **On the [Setup Method] screen, select [Do Not Use Take-up Unit]/[Use Take-up Unit] and tap [Start Setup].**

4. Load the media in the take-up unit.

If you will not use the take-up unit, proceed to 5. Configure settings to match the media.(P. 45).

Procedure

1. Lower the dancer roller toward the rear.



2. Follow the procedure below to load a paper tube on the media holders of the take-up unit.

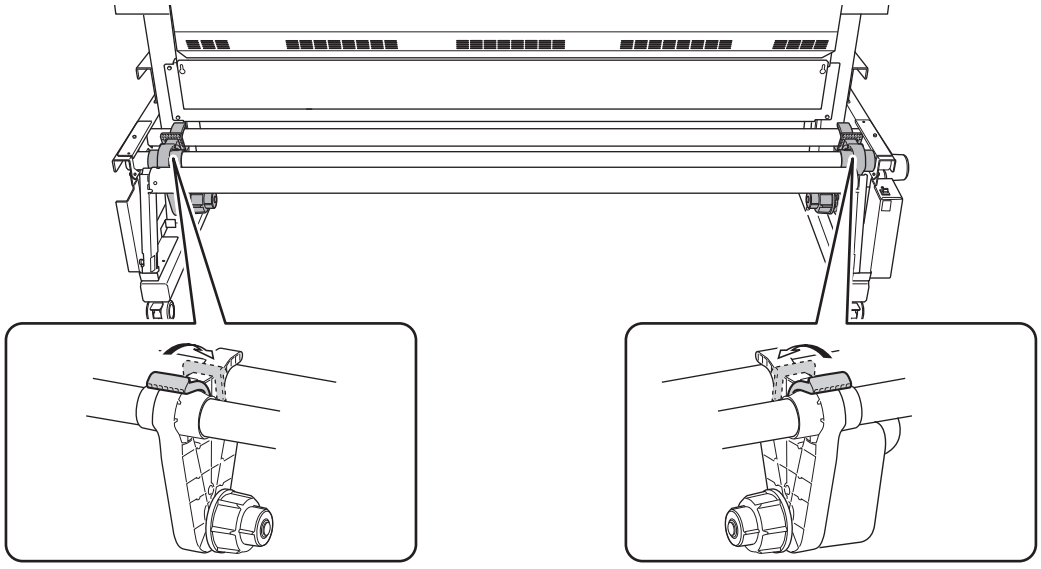
Prepare a paper tube wider than the media that has been set up.

IMPORTANT

Paper tubes are consumable items.

Watch the condition of the paper tube and replace at an appropriate time so that the media can be taken up in good working order.

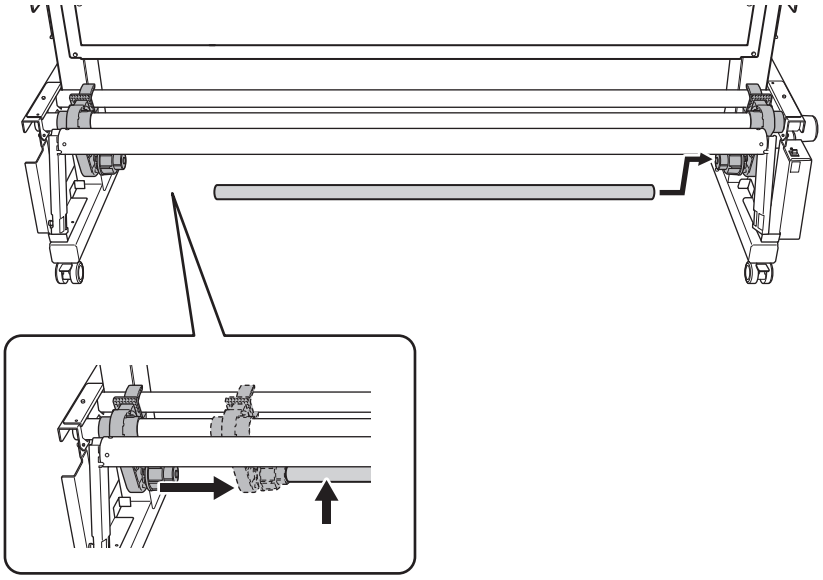
(1) **Release the media holders to enable their movement.**



(2) **Fit the paper tube onto the right end cap.**

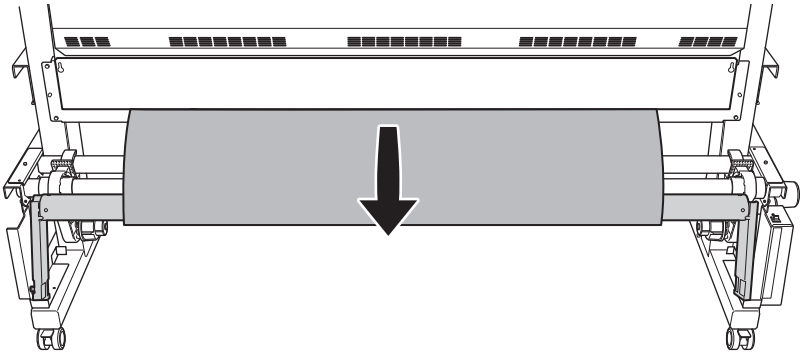
Fit the paper tube securely right to the end of the end cap.

(3) **Push the left media holder into the paper tube.**



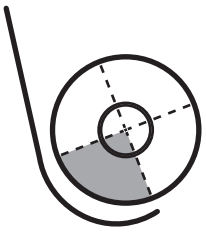
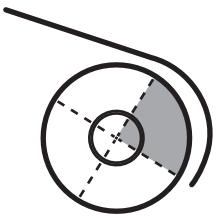
3. **Hold down ▼ on the operation panel to feed out the media until the tip of the media reaches the paper tube.**

Media is fed out 10 mm (0.39 in.) each time you hold down this button. Holding down the button lets you feed out paper continuously.



MEMO

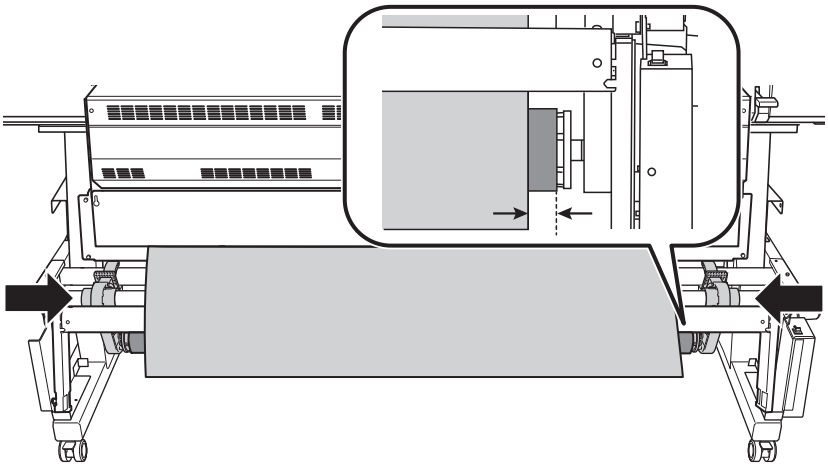
Feed out the media until it can wrap around at least 1/4 of the paper tube.

When using the FORWARD setting	When using the BACKWARD setting
	

4. **Follow the procedure below to adjust the positions of the media holders.**

(1) **Move both media holders so that it is possible to see the paper tube from the right edge of the media.**

Hold the media holders from the outside and move them.



(2) **Secure the left and right media holders.**

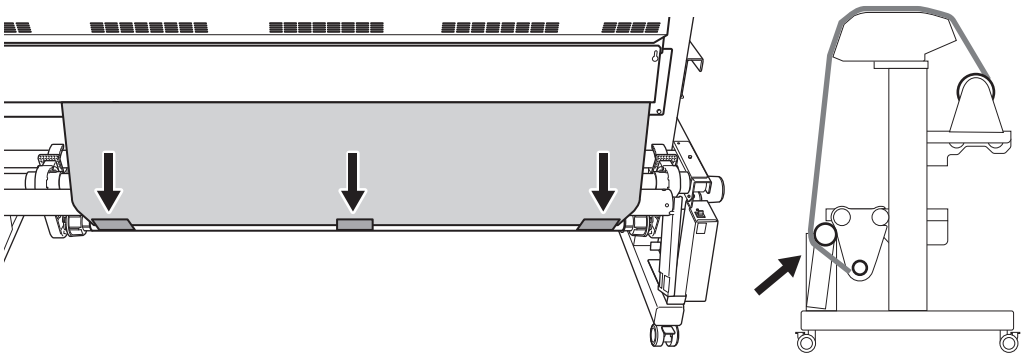
5. **Follow the procedure below to secure the media on the paper tube.**

Secure the media in the [**Take-up Direction**] set in step 2 of 1. Install the media on the media holders.(P. 26).

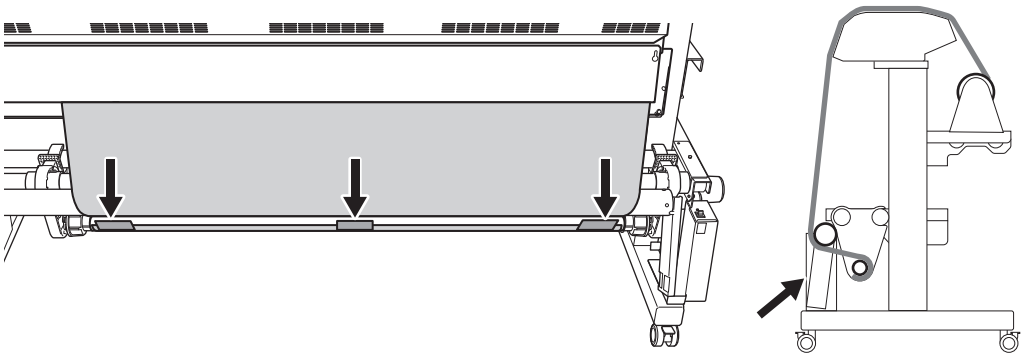
(1) **While pulling the media so that it does not sag, secure the center of the media on the paper tube with adhesive tape.**

(2) **While pulling the media from the center toward the outer edges, secure the left and right edges of the media on the paper tube with adhesive tape.**

- **When using the FORWARD setting**



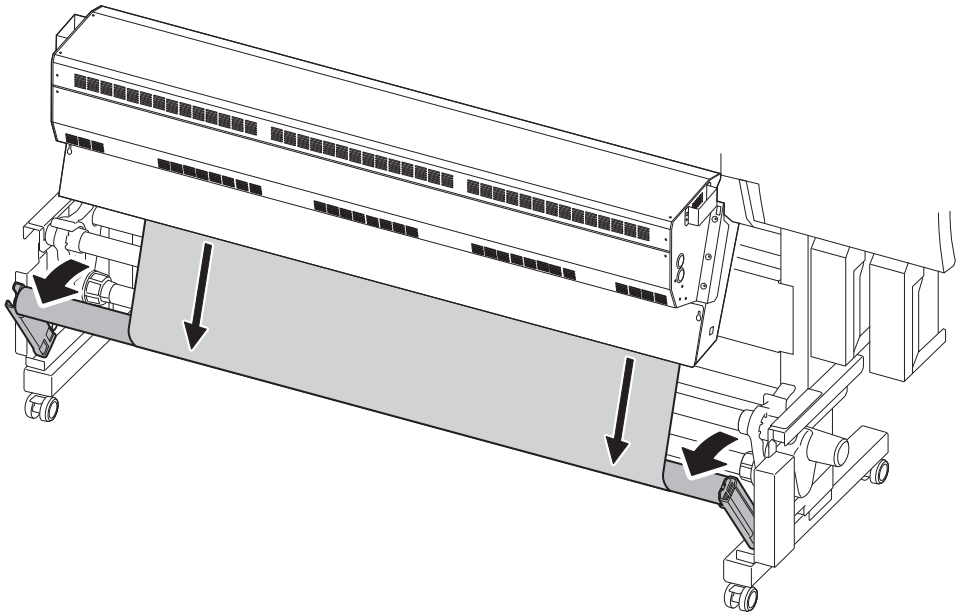
- **When using the BACKWARD setting**



6. **Tap [OK].**

A small amount of the media is fed out.

7. **Lower the dancer roller toward the front.**



8. Tap [OK].

5. Configure settings to match the media.

To ensure the optimal output according to the media size and type, you can set the minimal amount of items. All items set here can be set individually as well.

Procedure

1. **Adjust the print head height using [Print Head Height].**
   - If this is not necessary, tap [**Next**].
   - Follow the procedure below to make adjustments.
     a. Tap [**Change**]
     b. Open the front cover.
     c. Move the height-adjustment lever to adjust the head height.
     d. Close the front cover.
     e. Tap [**OK**].
     f. Tap [**Next**].

   For details on this work, refer to Changing the Print Head Height(P. 119).

2. **On the [Nozzle Drop-out Test] screen, configure the [Printing Test] or [Printing Test (Drying Enabled)] and [Output Start Location] settings.**
   - If this is not necessary, tap [**Next**].
   - To perform a [**Printing Test**], tap [**Printing Test**]>[**Execute**] or [**Printing Test (Drying Enabled)**]>[**Execute**].

   MEMO

   [**Printing Test**] is recommended. However, the ink will not dry, so if you want to dry the ink, select [**Printing Test (Drying Enabled)**].

   For details on what to do after the printing test, refer to Step 2: Performing Normal Cleaning(P. 109).

3. **On the [Select Media Adjustment Method] screen, select the adjustment method.**

   Here, the media feed correction for reducing horizontal bands and the correction of the landing position of the ink will be adjusted. Select manual adjustment for transparent media and media with high reflectance, whose edges cannot be detected.

   MEMO

   [**Simple Correction (Auto)**] is the recommended adjustment. You can determine the correction values with [**Detailed Correction (Manual)**].

   - **Follow the procedure below to make automatic adjustments.**
     a. Tap [**Simple Correction (Auto)**]>[**Next**].
     b. Tap [**Execute**] on the [**Batch Automatic Correction**] screen.

     On successful completion of automatic adjustment, the home screen appears. This completes the settings.

     For more information, refer to Automatically Making Required Adjustments(P. 114).
   - **Follow the procedure below to make manual adjustments.**
     a. Tap [**Detailed Correction (Manual)**]>[**Next**].
     b. Perform a printing test on the [**Detailed Feed Correction (Manual)**] screen.

Set the correction value from the printing test result. For more information, refer to Manual Adjustment: Reducing Horizontal Bands (Feed Correction)(P. 115).

c. Tap [**Save and Proceed**].

d. Perform a printing test on the [**Detailed Media Gap Adjustment (Manual)**] screen.

Set the correction value from the printing test result. For more information, refer to Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)(P. 117).

e. Tap [**Save and Exit**].

This completes the setup of the media.

Setup of Sheet Media

Load the sheet media on the printer. When the loading is finished, [**Output possible.**] is displayed as the status. This work is referred to as "Setup of Media."

1. A: Determine the positions of the media (opaque media).

This section describes how to use the suction fan to prevent media skewing.

By default, [**Skewing Correction Support at Setup**] is set to [**Enable**].

Procedure

1. **Tap  on the operation panel.**

   The sub power is switched on.

2. **Set the [Skewing Correction Support at Setup].**

   (1) **Tap .**

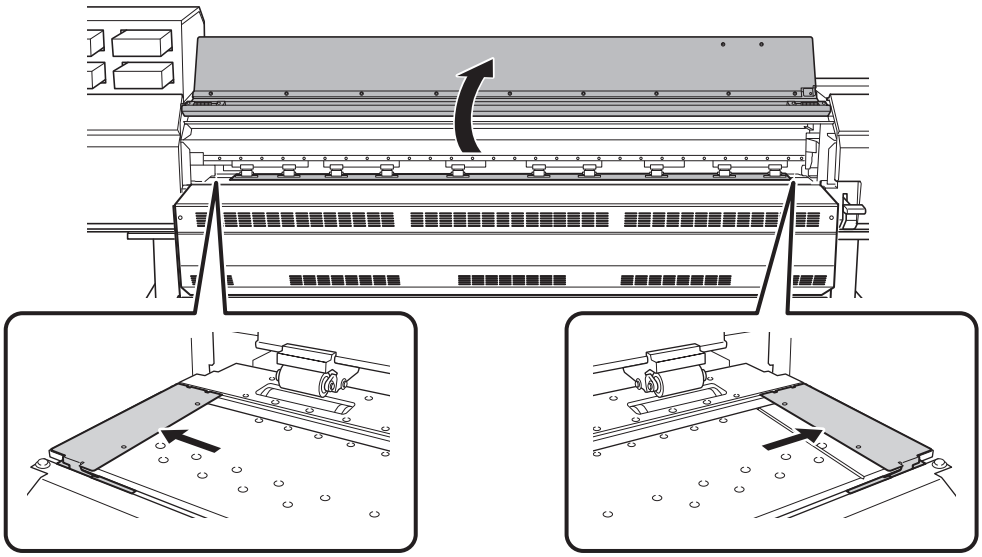
   (2) **[Preferences]>[Skewing Correction Support at Setup]**

   (3) **Select [Enable] and tap [Save].**

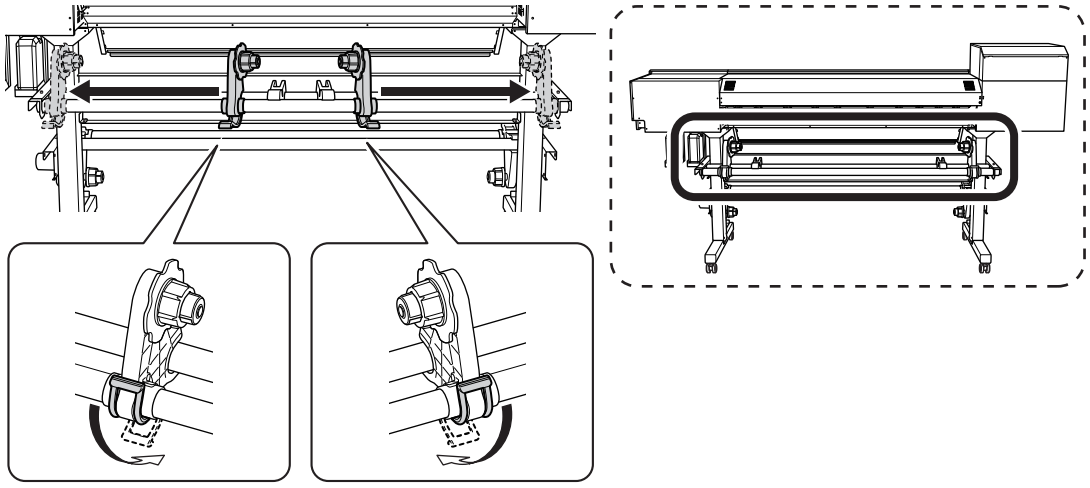
   (4) **Tap  to go back to the original screen.**

3. **Open the front cover.**

4. **Move the media clamps to the outside of the grit rollers on the left and right edges respectively.**



5. **(Move to the rear of the printer.) Release the locking mechanisms of the media holders, and then draw them to the left and right ends respectively.**

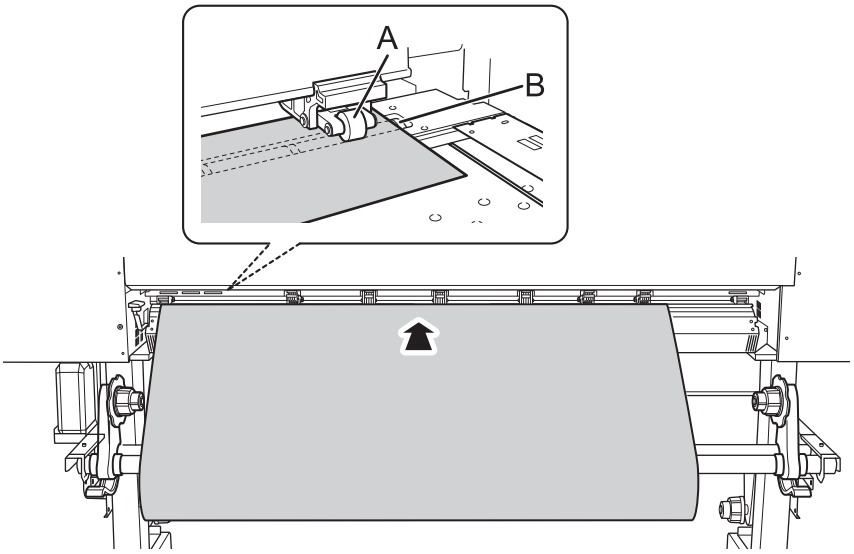


6. **From the rear of the printer, pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**

> **IMPORTANT**
>
> If the leading edge of the media is bent, cut the bent part before loading the media, as it may be difficult for the media to enter the dryer entrance.

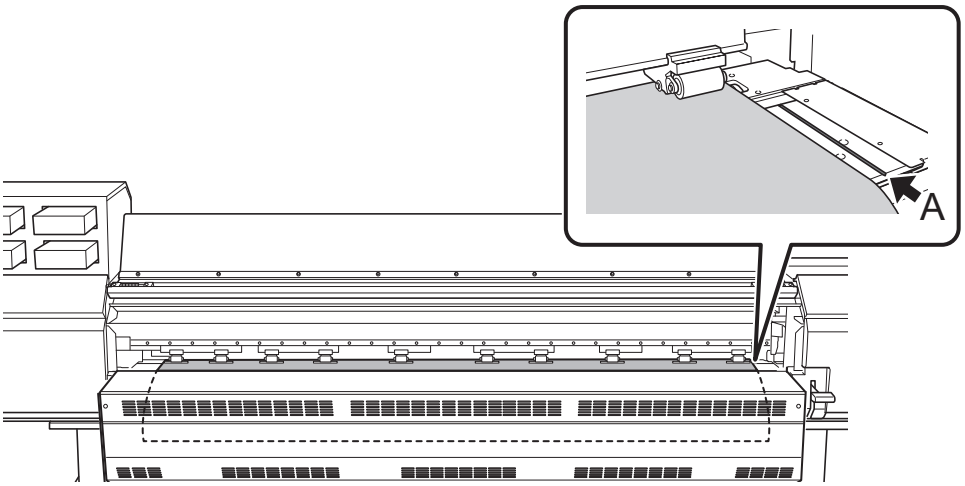
You will hear a beep. Approximately 5 seconds later, you will hear two beeps, and then the suction fan will activate. While this fan is operating, the media will not move backward even if you remove your hands from it.

When loading the media from the front of the printer, feed the leading edge of the media (the side where printing will start) over the platen, and then pull the media to the front to activate the suction fan.



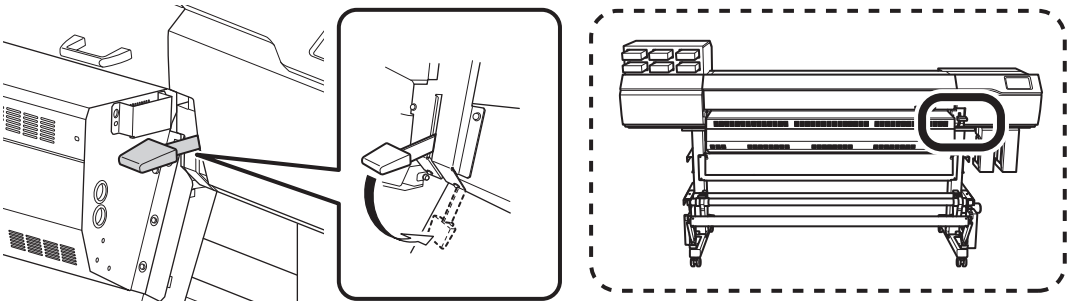
7. **(Move to the front of the printer.) Insert the leading edge of the media into the dryer.**

8. **Make sure the right edge of the media is in line with the guide line (A).**

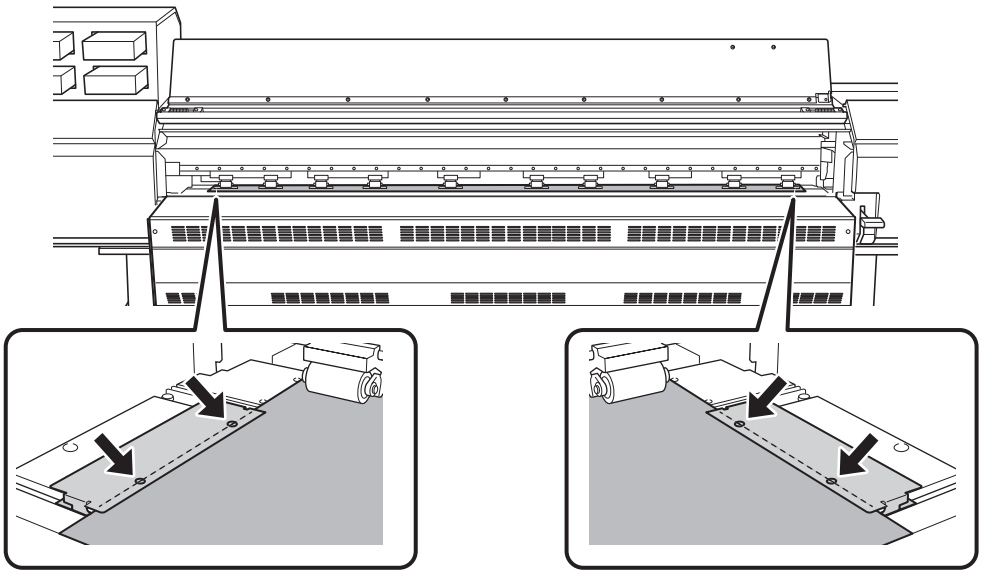


9. **Lower the loading lever (front).**

The media is held in place.



10. **Line up the edges of the media with the centers of the holes of the left and right media clamps.**



IMPORTANT

Be sure to use the media clamps when you load media.

If you attach the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

11. Close the front cover.

1. B: Determine the positions of the media (transparent media, etc.).

Use the following procedure to determine the positions of the media when using transparent media and media with high reflectance, whose edges cannot be detected.

Procedure

1. **Set the [Skewing Correction Support at Setup].**

(1) **Tap**  **.**

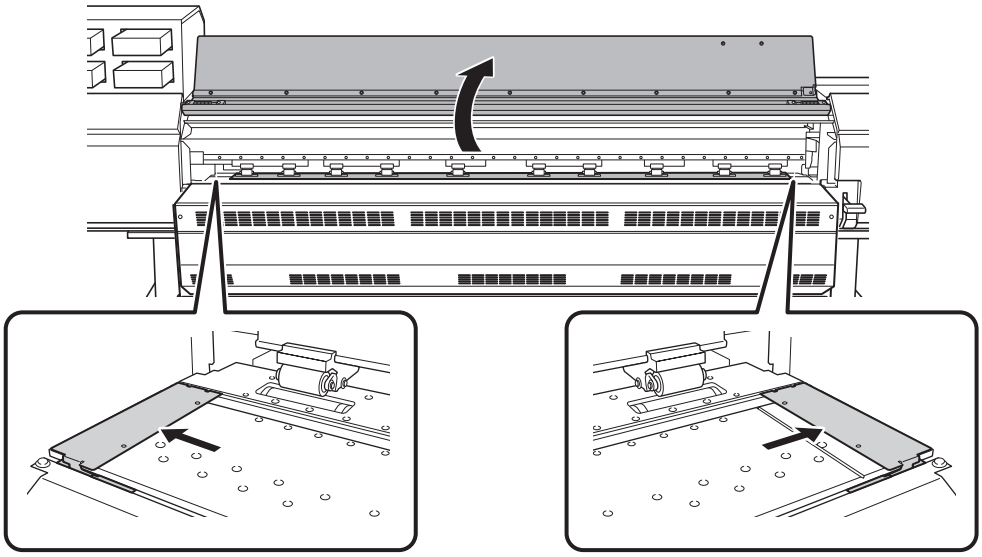
(2) **[Preferences]>[Skewing Correction Support at Setup]**

(3) **Select [Disable] and tap [Save].**

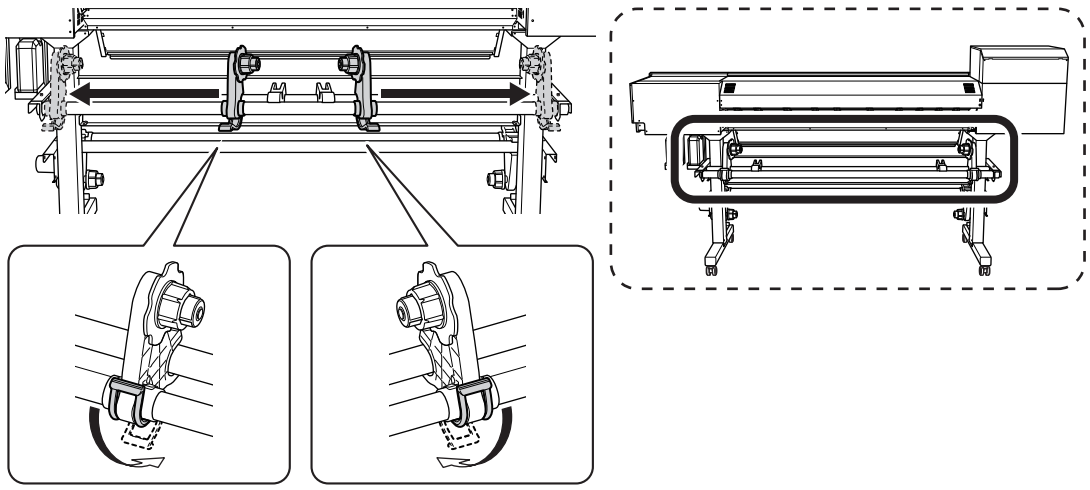
(4) **Tap**  **to go back to the original screen.**

2. **Open the front cover.**

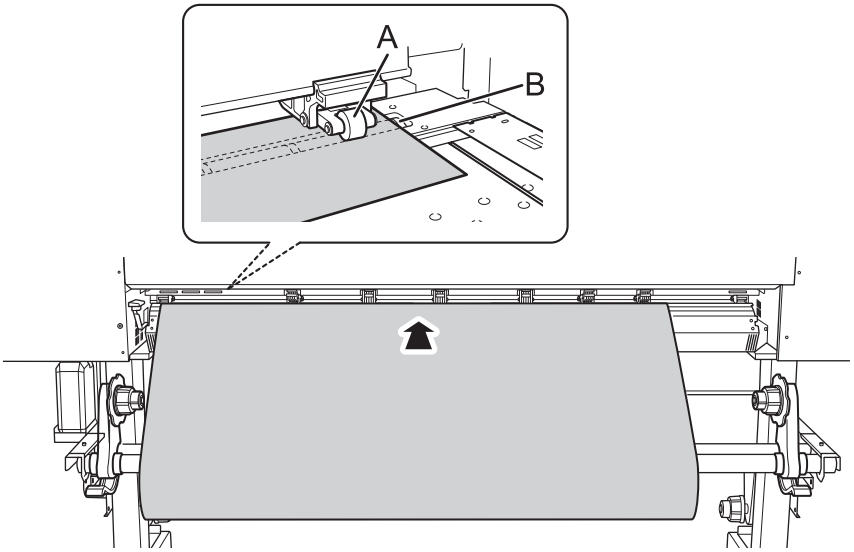
3. **Move the media clamps to the outside of the grit rollers on the left and right edges respectively.**



4. **(Move to the rear of the printer.) Release the locking mechanisms of the media holders, and then draw them to the left and right ends respectively.**

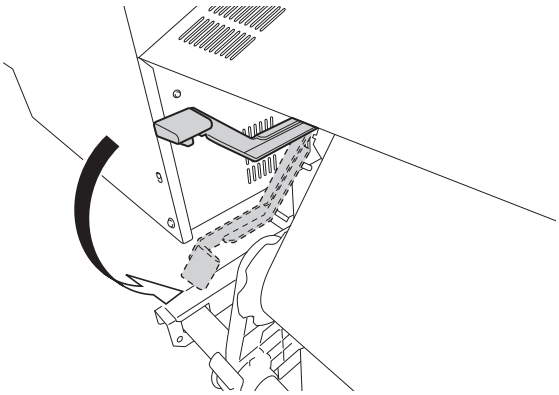


5. **Pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**



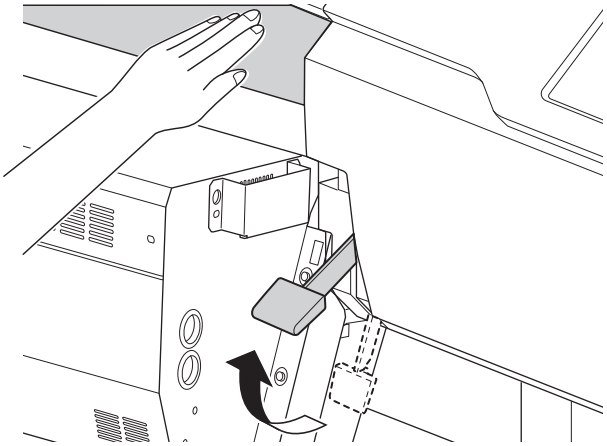
6. **Lower the loading lever (rear).**

The media is held in place.



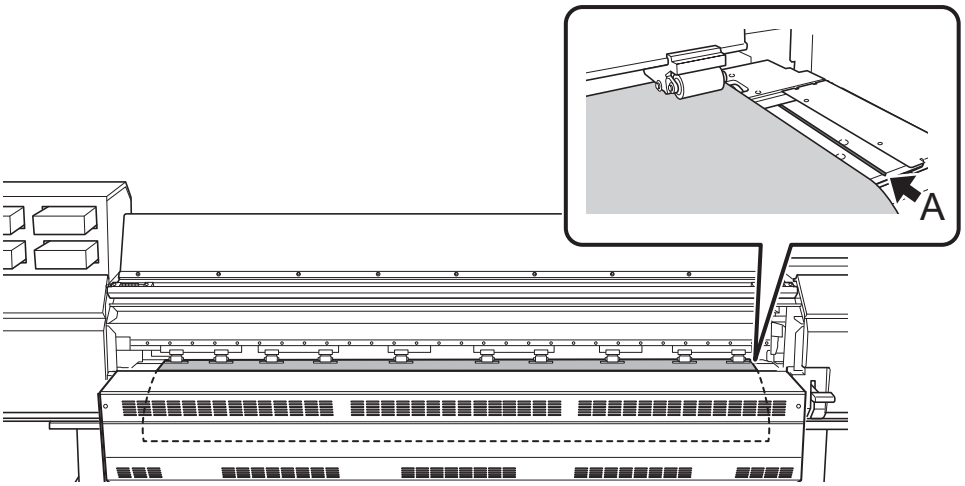
7. **(Move to the front of the printer.) Gently hold down the media and raise the loading lever (front).**

The media is released.



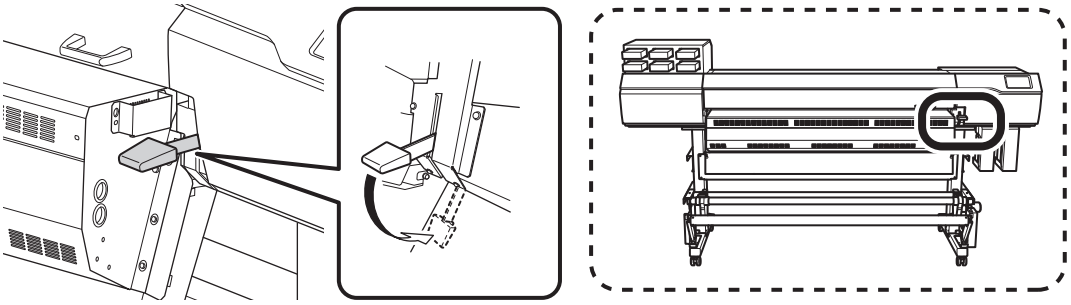
8. **Insert the leading edge of the media into the dryer.**

9. **Make sure the right edge of the media is in line with the guide line (A).**

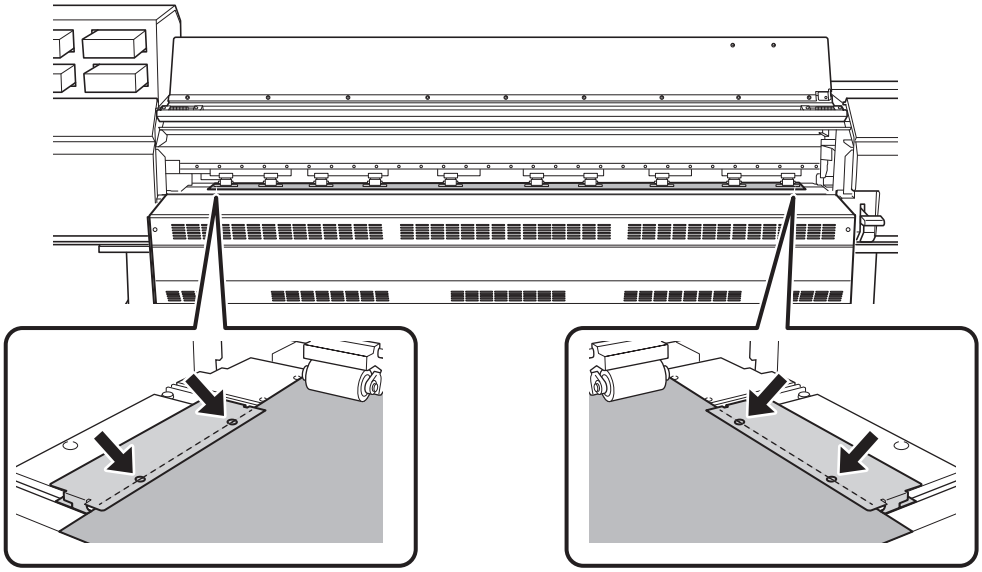


10. **Lower the loading lever (front).**

The media is held in place.



11. **Line up the edges of the media with the centers of the holes of the left and right media clamps.**



IMPORTANT

Be sure to use the media clamps when you load media.

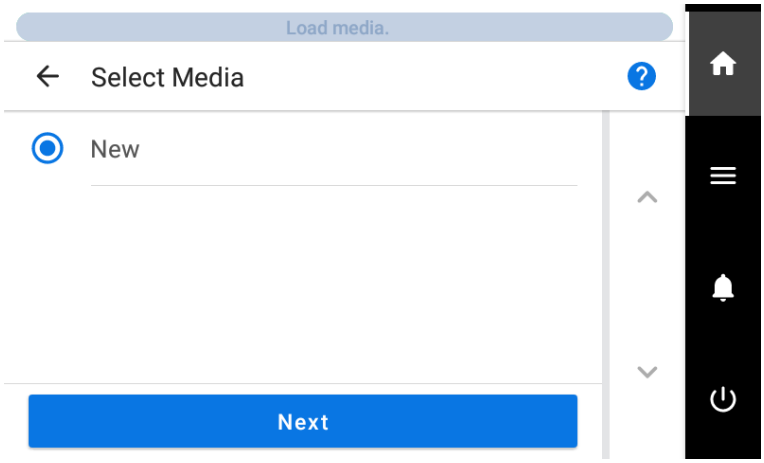
If you attach the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

12. Close the front cover.

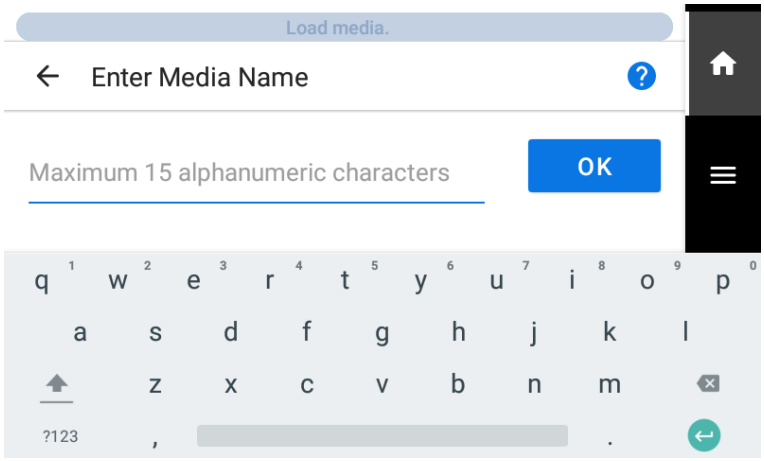
2. Register the media.

Procedure

1. Tap  [Setup].
2. Select [New].
3. Tap [Next].



4. Enter a new media name and tap [OK].



5. Tap [Next].
6. On the [Select Sheet Type] screen, select [Opaque]/[Transparent] and tap [Next].
7. The [Sheet Settings] screen appears. Configure the settings as shown below depending on the sheet type.
   - **For opaque media**
     a. Tap [**Side Margin**] to set the margin.
        You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
     b. Tap [**OK**].
   - **For transparent media, etc.**
     - [**Sheet Width**] setting

a. Tap  next to [**Sheet Width**].

b. Enter the sheet width and tap [**OK**].

- [**Sheet Right Edge**] setting
  a. Tap [**Change**] next to [**Sheet Right Edge**].
  b. Tap  or  to move the carriage's base point mark to the right edge of the media, and then tap [**OK**].
- [**Side Margin**] setting
  a. Tap [**Side Margin**] to set the margin.
  You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
  b. Tap [**OK**].

8. **On the [Setup Method] screen, select [Do Not Use Take-up Unit]/[Use Take-up Unit] and tap [Start Setup].**

3. Configure settings to match the media.

To ensure the optimal output according to the media size and type, you can set the minimal amount of items. All items set here can be set individually as well.

Procedure

1. **Adjust the print head height using [Print Head Height].**
   - If this is not necessary, tap [**Next**].
   - Follow the procedure below to make adjustments.
     a. Tap [**Change**]
     b. Open the front cover.
     c. Move the height-adjustment lever to adjust the head height.
     d. Close the front cover.
     e. Tap [**OK**].
     f. Tap [**Next**].

   For details on this work, refer to Changing the Print Head Height(P. 119).

2. **On the [Nozzle Drop-out Test] screen, configure the [Printing Test] or [Printing Test (Drying Enabled)] and [Output Start Location] settings.**
   - If this is not necessary, tap [**Next**].
   - To perform a [**Printing Test**], tap [**Printing Test**]>[**Execute**] or [**Printing Test (Drying Enabled)**]>[**Execute**].

   MEMO

   [**Printing Test**] is recommended. However, the ink will not dry, so if you want to dry the ink, select [**Printing Test (Drying Enabled)**].

   For details on what to do after the printing test, refer to Step 2: Performing Normal Cleaning(P. 109).

3. **On the [Select Media Adjustment Method] screen, select the adjustment method.**

   Here, the media feed correction for reducing horizontal bands and the correction of the landing position of the ink will be adjusted. Select manual adjustment for transparent media and media with high reflectance, whose edges cannot be detected.

   MEMO

   [**Simple Correction (Auto)**] is the recommended adjustment. You can determine the correction values with [**Detailed Correction (Manual)**].

   - **Follow the procedure below to make automatic adjustments.**
     a. Tap [**Simple Correction (Auto)**]>[**Next**].
     b. Tap [**Execute**] on the [**Batch Automatic Correction**] screen.

     On successful completion of automatic adjustment, the home screen appears. This completes the settings.

     For more information, refer to Automatically Making Required Adjustments(P. 114).
   - **Follow the procedure below to make manual adjustments.**
     a. Tap [**Detailed Correction (Manual)**]>[**Next**].
     b. Perform a printing test on the [**Detailed Feed Correction (Manual)**] screen.

Set the correction value from the printing test result. For more information, refer to Manual Adjustment: Reducing Horizontal Bands (Feed Correction)(P. 115).

c. Tap [**Save and Proceed**].

d. Perform a printing test on the [**Detailed Media Gap Adjustment (Manual)**] screen.

Set the correction value from the printing test result. For more information, refer to Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)(P. 117).

e. Tap [**Save and Exit**].

This completes the setup of the media.

Setup of Registered Media

⚠ CAUTION

Do not touch the dancer roller needlessly.

The media take-up unit and feeder may move suddenly, which may result in injury.

Setup of Roll Media

Load the roll media on the printer. When the loading is finished, [**Output possible.**] is displayed as the status. This work is referred to as "Setup of Media."

⚠ CAUTION

Load the roll media correctly.

Otherwise the media may fall and cause injury.

⚠ CAUTION

The roll media is approximately 45 kg (99 lb.).

To avoid injury, handle the roll media with care.

⚠ CAUTION

Never load media that weighs over 45 kg (99 lb.).

The machine may fail to withstand the weight and tip over or cause the media to fall.

1. Install the media on the media holders.

The media holders of this machine are designed to be used with a paper tube (core) with an inner diameter of 2 inches or 3 inches.

⚠ WARNING

Handling roll media is an operation that must be performed by 2 persons or more, and care must be taken to prevent falls.

Attempting to lift heavy media in a manner that taxes your strength may cause physical injury. Also, if dropped, such items may cause injury.

Procedure

1. **Tap  on the operation panel.**

The sub power is switched on.

2. **When using a take-up unit, use the following procedure to set it.**

(1) **Tap [Preferences]>[Take-up]>[Take-up Direction].**

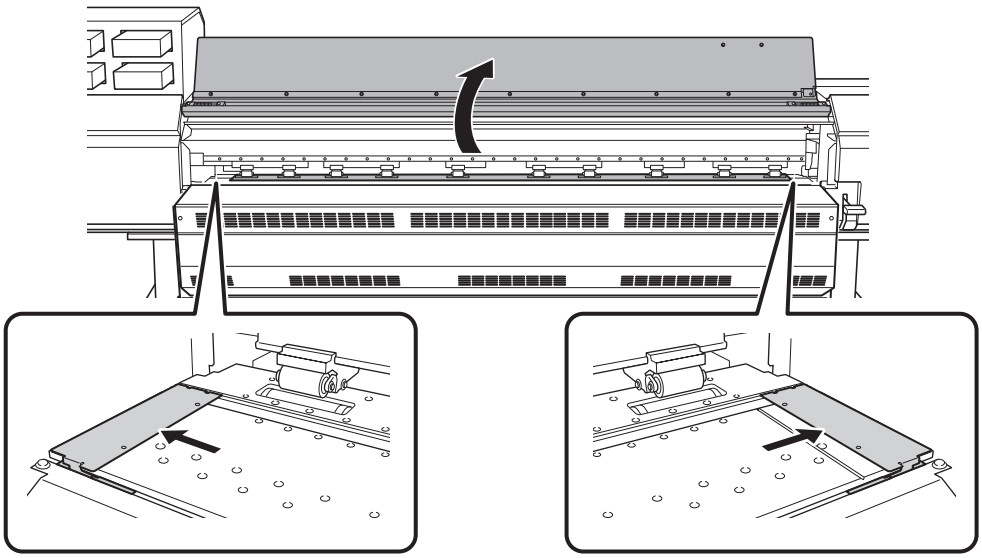
(2) **Select [Backward] or [Forward].**

(3) **Tap [Save].**

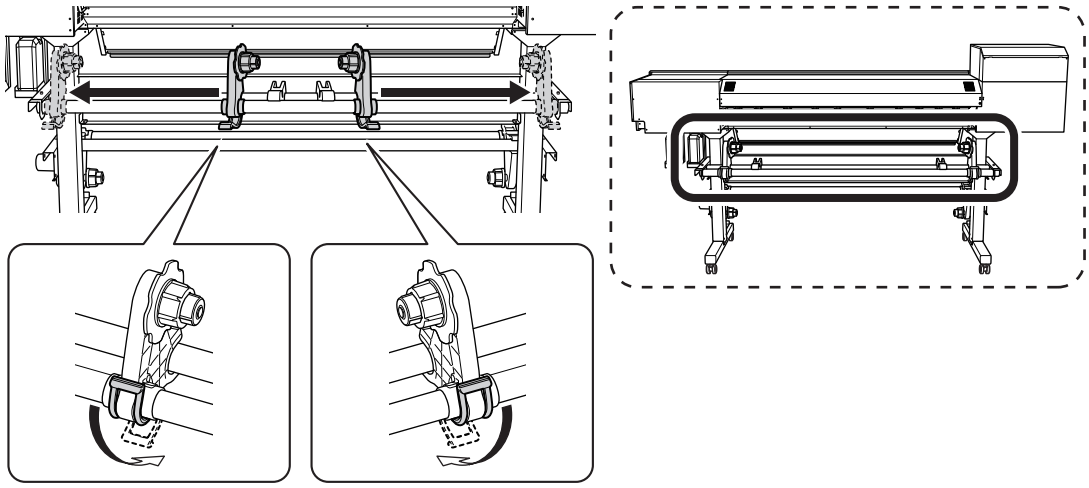
(4) Tap  to go back to the original screen.

3. Open the front cover.

4. Move the media clamps to the outside of the grit rollers on the left and right edges respectively.



5. Release the locking mechanisms of the media holders, and then draw them to the left and right ends respectively.



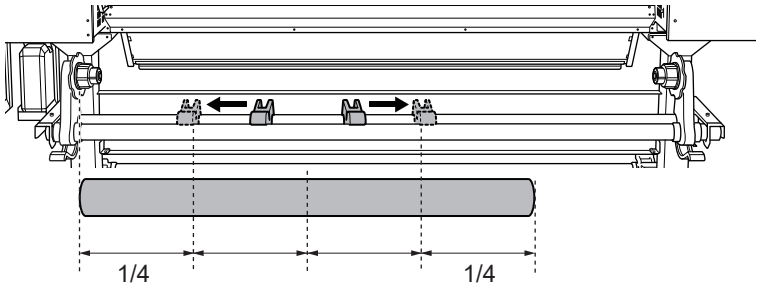
6. Place the media on the machine.

IMPORTANT

Do not leave media on the media stays or the pipes for a long period of time. The media may become deformed. Exercise caution.

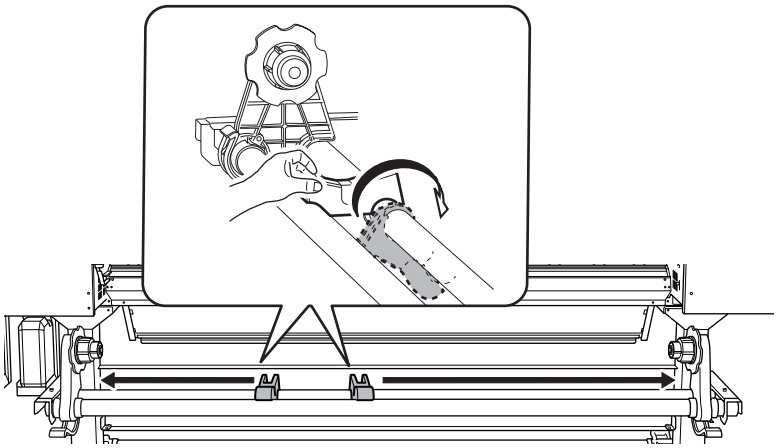
- **Media with an outer diameter of 220 mm (8.66 in.) or less**

  Place the media stays at positions that are 1/4 the length of the media from each end of the media, and then load the media.

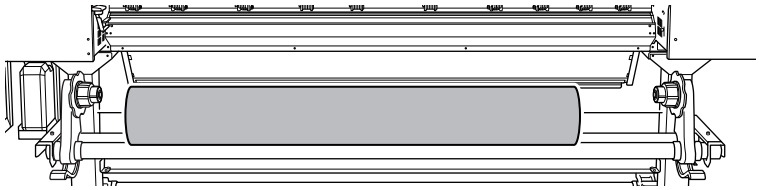


- **Media with an outer diameter exceeding 220 mm (8.67 in.)**

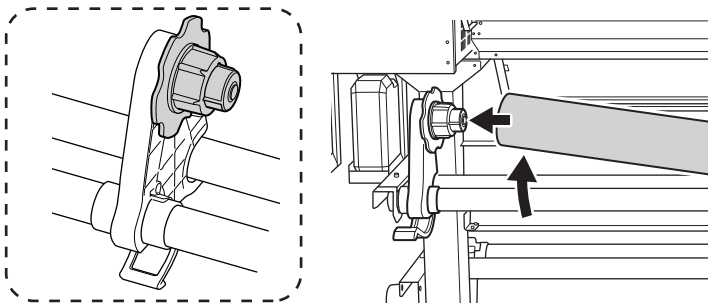
  a. Rotate the media stays to draw them to the media holders.



  b. Place the media directly between the two pipes.

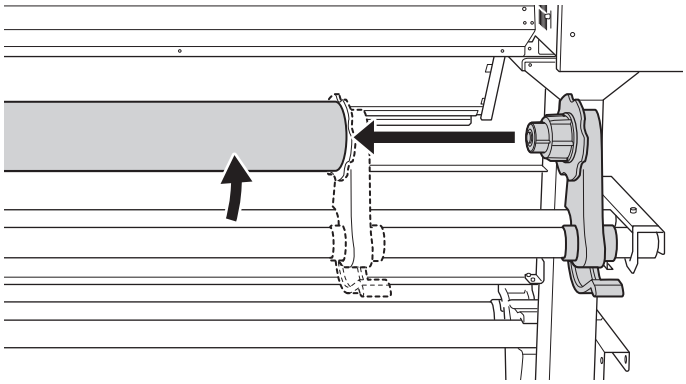


7. **Fit the paper tube (core) of the media onto the end cap of the left media holder.**



8. **Move the right media holder to fit its end cap onto the paper tube (core) of the media.**

Fit the paper tube onto the media holders securely to prevent the media from moving easily.



IMPORTANT

Do not secure the media holders in place just yet.

In the following procedure, you will adjust the positions of the media holders before securing them in place. Do not secure them in place just yet.

The next operation to perform varies depending on the media type and the Preferences. Proceed as shown below.

- Opaque media: 2. A: Determine the positions of the media (opaque media).(P. 63)
- Transparent media, etc.: 2. B: Determine the positions of the media (transparent media, etc.).(P. 67)

2. A: Determine the positions of the media (opaque media).

This section describes how to use the suction fan to prevent media skewing.
By default, **[Skewing Correction Support at Setup]** is set to **[Enable]**.

Procedure

1. Set the [Skewing Correction Support at Setup].

(1) Tap .

(2) **[Preferences]>[Skewing Correction Support at Setup]**

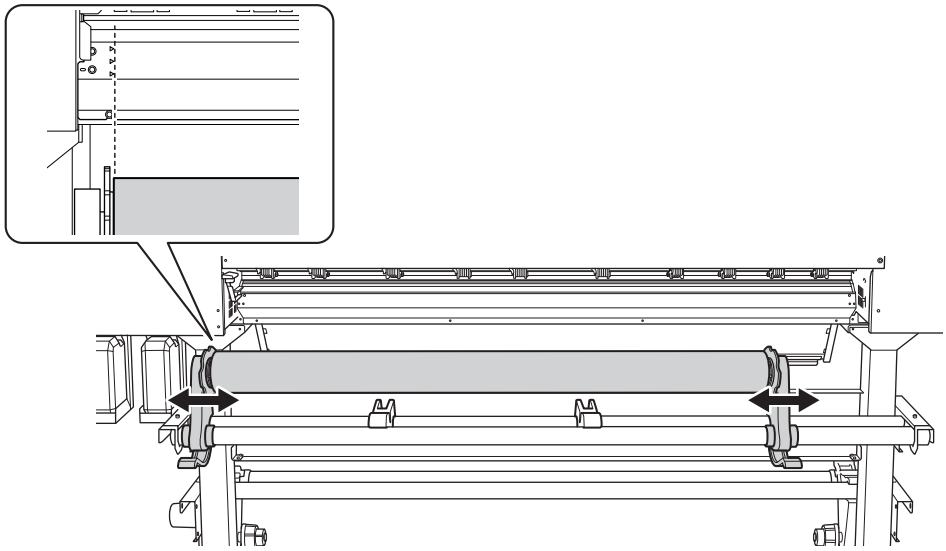
(3) **Select [Enable] and tap [Save].**

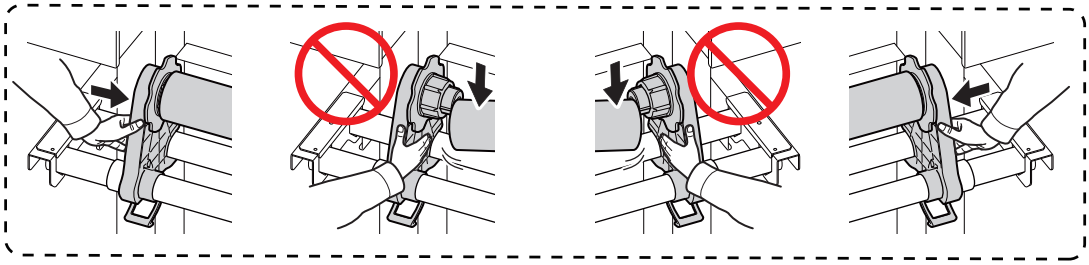
(4) Tap  **to go back to the original screen.**

2. Align the left edge of the media with the mark.

Note the following points when determining the positions.

- Hold the media holders from the outside and move them.
- Move the media holders so that the edge of the media is on the right side of the mark.





⚠ CAUTION

Do not hold places other than those instructed. Do not move the media by holding it directly.

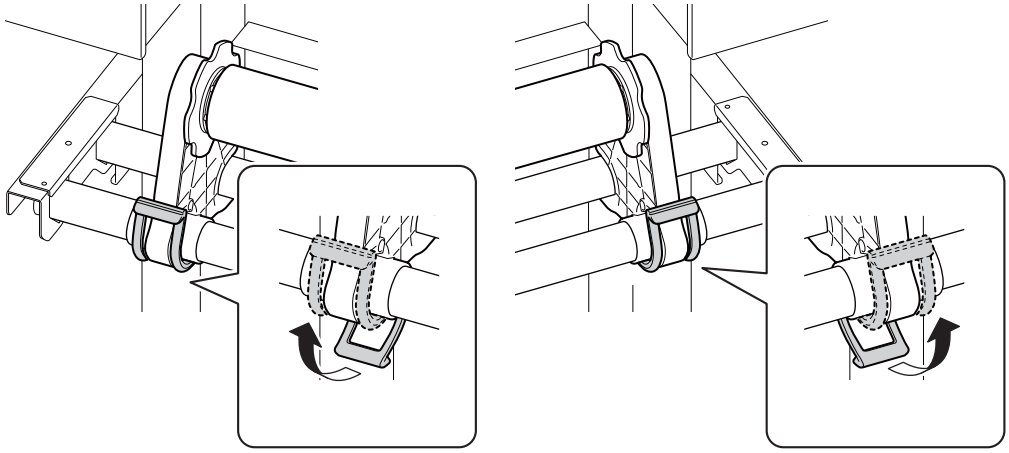
Otherwise the media may fall off the media holder and cause injury.

IMPORTANT

Firmly decide the left and right side positions of the media at this point.

After this procedure is completed, if the left and right side positions do not fit the proper positions when securing the media with pinch rollers, you will have to go back to this step to redo this procedure. If you just hold the media to readjust its position forcibly, the media will be skewed during printing, which will have an adverse effect on the printing results.

3. **Secure the media holders.**



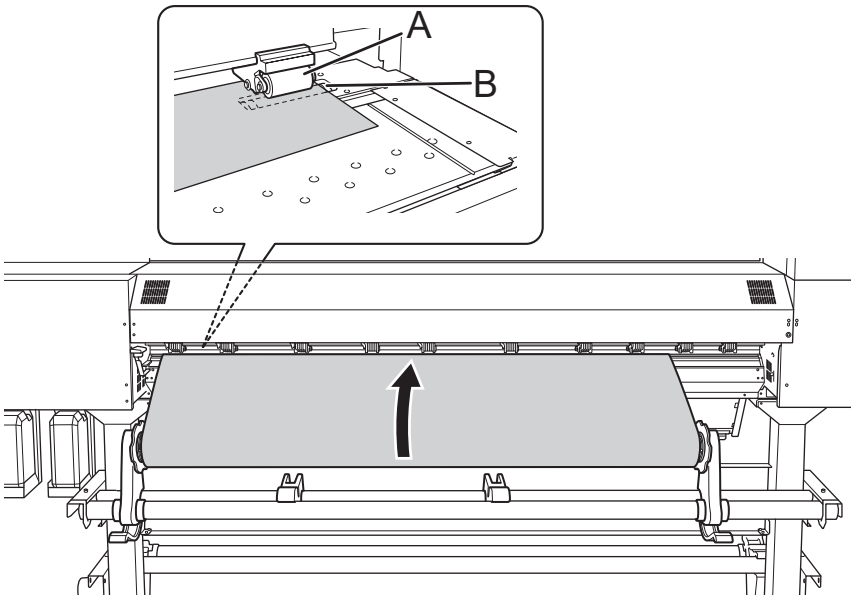
4. **Use the following procedure to load the media.**

Doing so will prevent media skewing.

IMPORTANT

If the leading edge of the media is bent, cut the bent part before loading the media, as it may be difficult for the media to enter the dryer entrance.

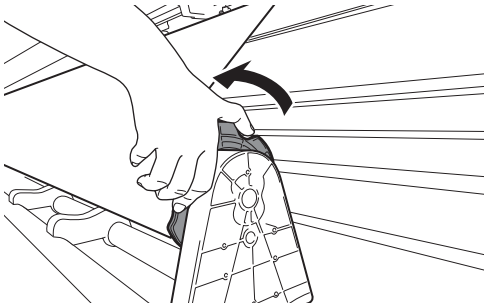
(1) **Pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**



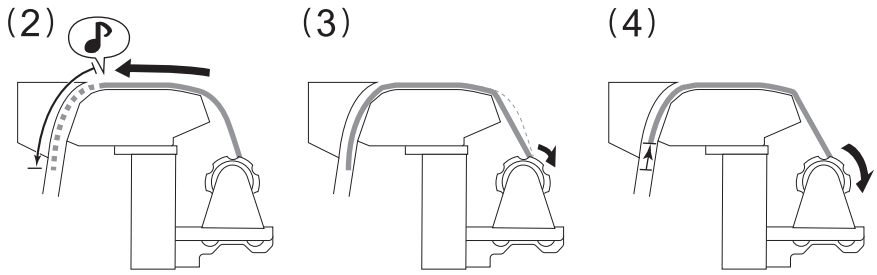
(2) **Feed the media until you hear a beep, and then additionally feed approximately 30 cm (11.81 in.) of the media.**

You will hear a beep. Approximately 5 seconds later, you will hear two beeps, and then the suction fan will activate. While this fan is operating, the position of the media will be maintained even if you remove your hands from it.

(3) **Hold the media holder flange, turning it in the take-up direction to eliminate the slack in the media.**



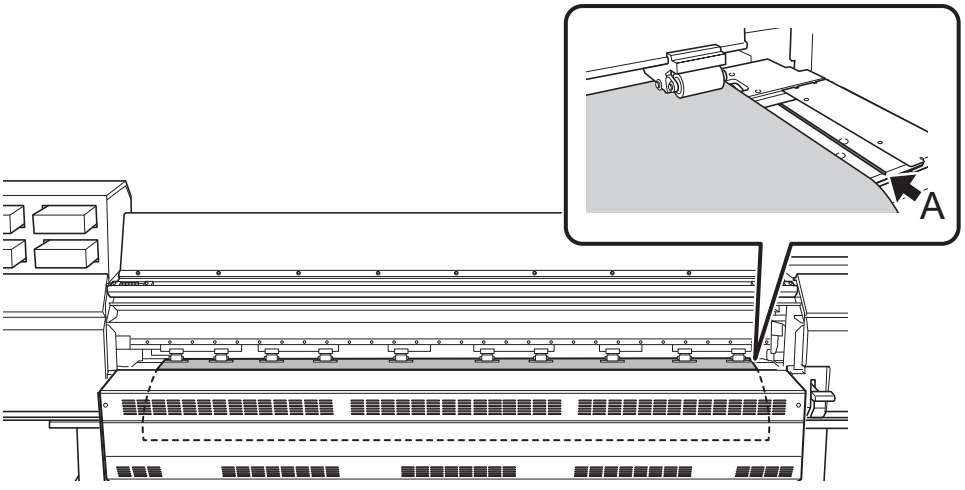
(4) **Once the media is taut, additionally take up approximately 10 cm (3.94 in.) of media.**



MEMO

If you take up too much media, you will hear two short beeps and the suction fan will stop. Take up the media, and then redo the procedure from step (1).

5. **(Move to the front of the printer.) Make sure the right edge of the media is in line with the guide line (A).**

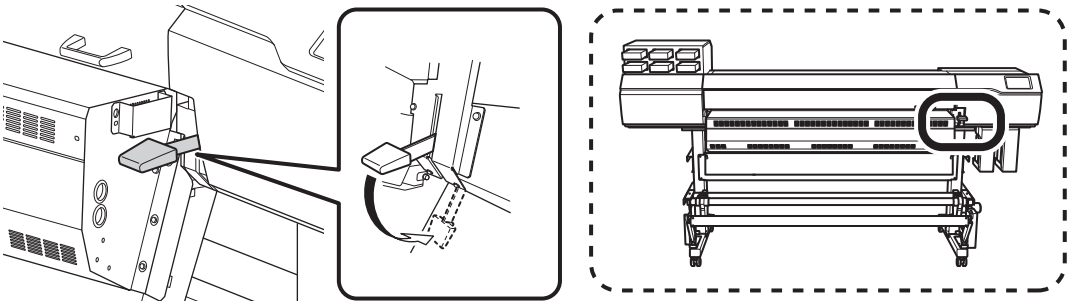


IMPORTANT

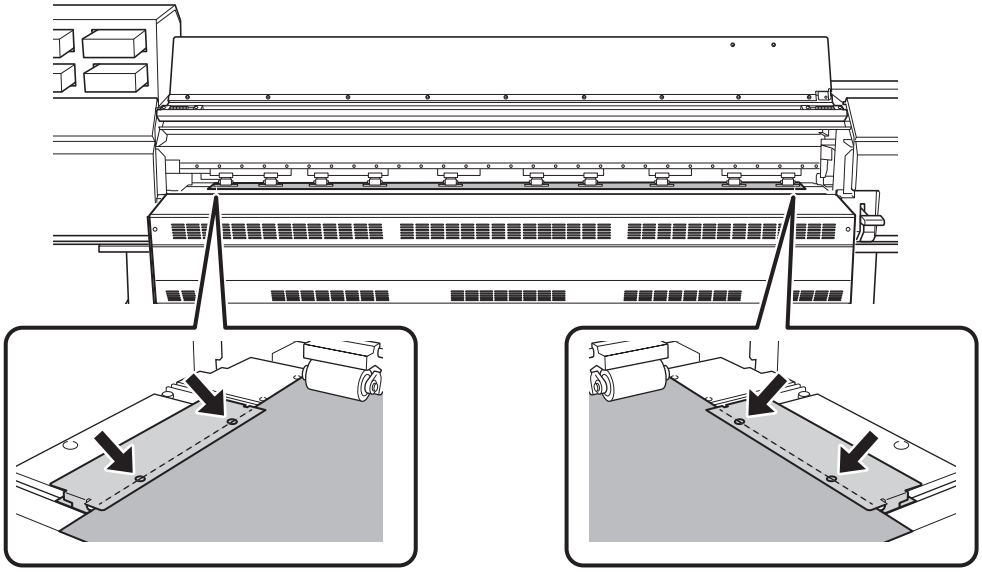
If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from step 1. If you just stand at the front of the printer and hold the media to readjust its position forcibly, the media will be skewed during printing or will come loose, which will affect the printing quality.

6. **Lower the loading lever (front).**

The media is held in place.



7. **Line up the edges of the media with the centers of the holes of the left and right media clamps.**



IMPORTANT

Be sure to use the media clamps when you load media.

If you attach the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

8. **Close the front cover.**

2. B: Determine the positions of the media (transparent media, etc.).

This section describes how to determine the positions of the media without using the suction fan. Refer to this information when using transparent media and media with high reflectance, whose edges cannot be detected.

Procedure

1. **Set the [Skewing Correction Support at Setup].**

(1) **Tap**  **.**

(2) **[Preferences]>[Skewing Correction Support at Setup]**

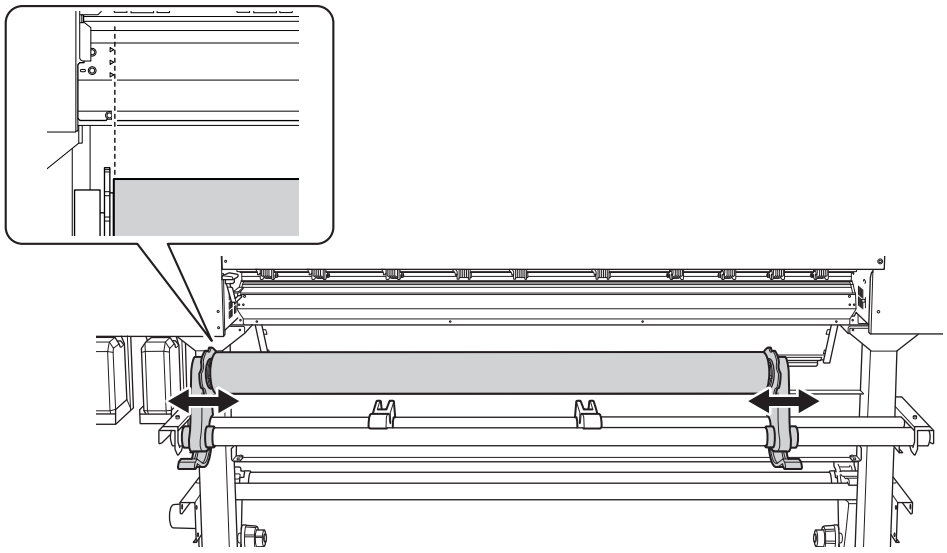
(3) **Select [Disable] and tap [Save].**

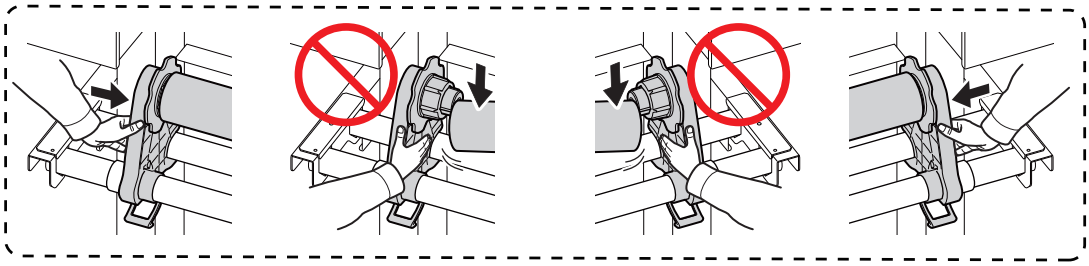
(4) **Tap**  **to go back to the original screen.**

2. **Align the left edge of the media with the mark.**

Note the following points when determining the positions.

- Hold the media holders from the outside and move them.
- Move the media holders so that the edge of the media is on the right side of the mark.





⚠ CAUTION

Do not hold places other than those instructed. Do not move the media by holding it directly.

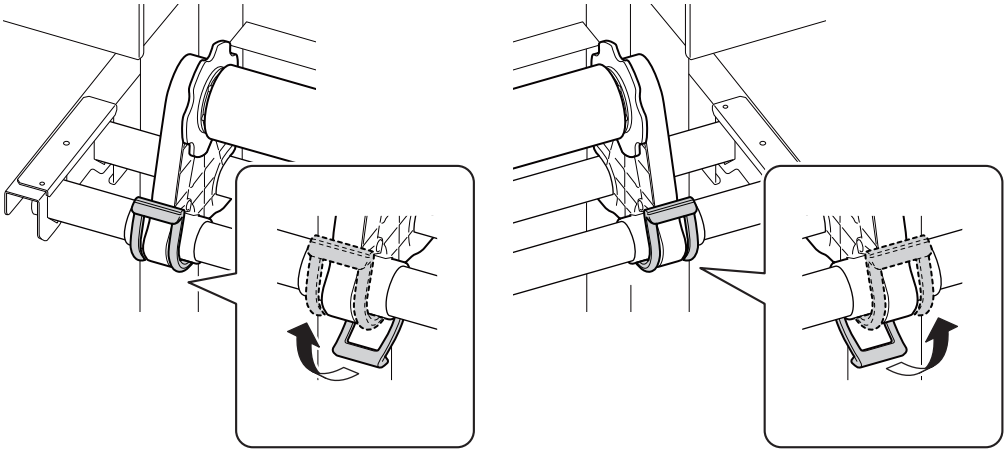
Otherwise the media may fall off the media holder and cause injury.

IMPORTANT

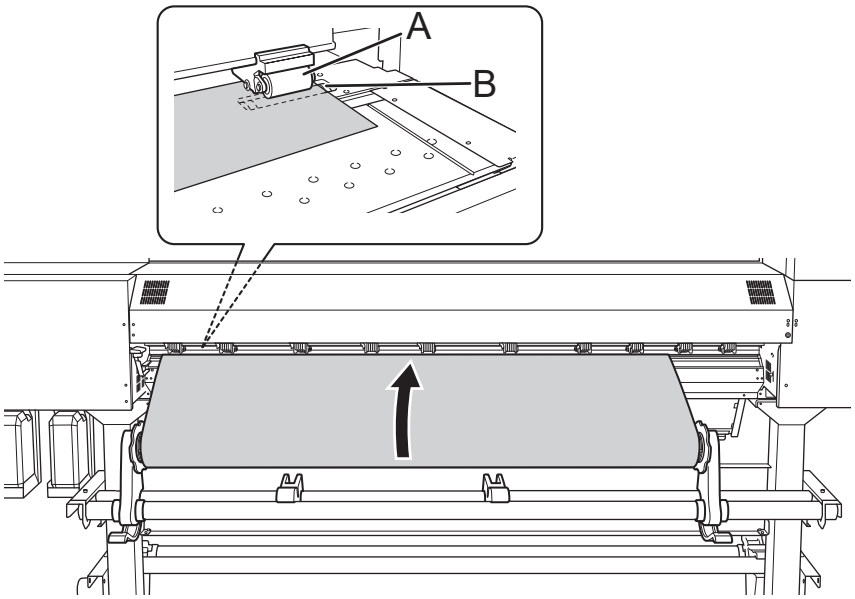
Firmly decide the left and right side positions of the media at this point.

After this procedure is completed, if the left and right side positions do not fit the proper positions when securing the media with pinch rollers, you will have to go back to this step to redo this procedure. If you just hold the media to readjust its position forcibly, the media will be skewed during printing, which will have an adverse effect on the printing results.

3. **Secure the media holders.**

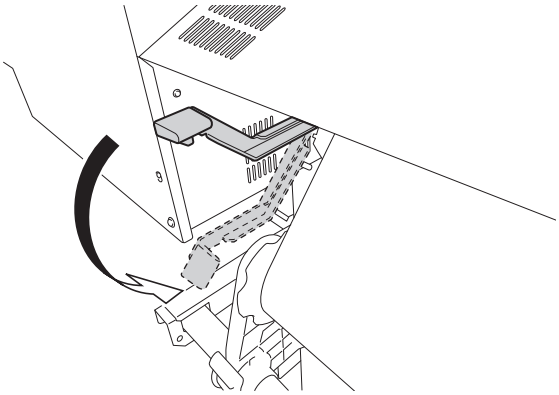


4. **Pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**



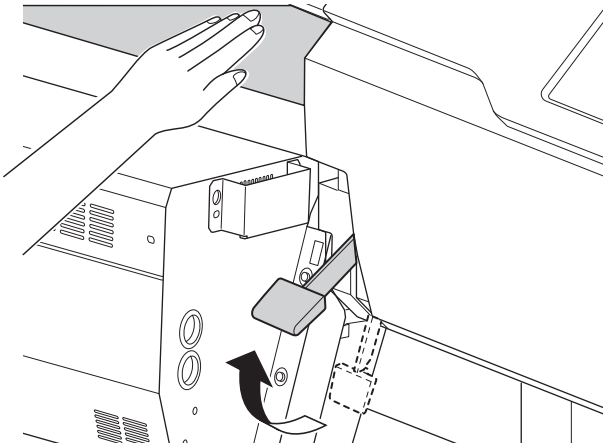
5. **Lower the loading lever (rear).**

The media is held in place.

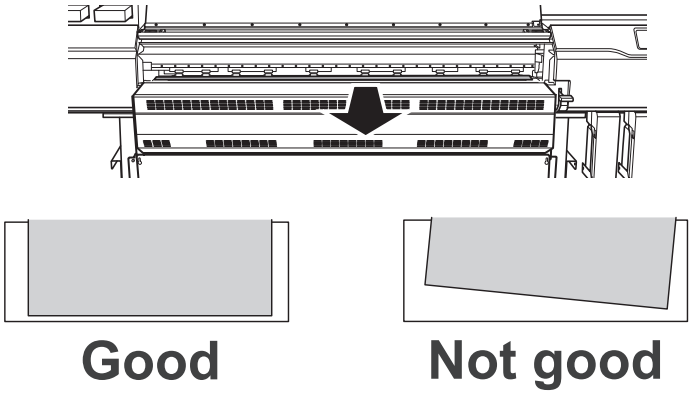


6. **(Move to the front of the printer.) Gently hold down the media and raise the loading lever (front).**

The media is released.

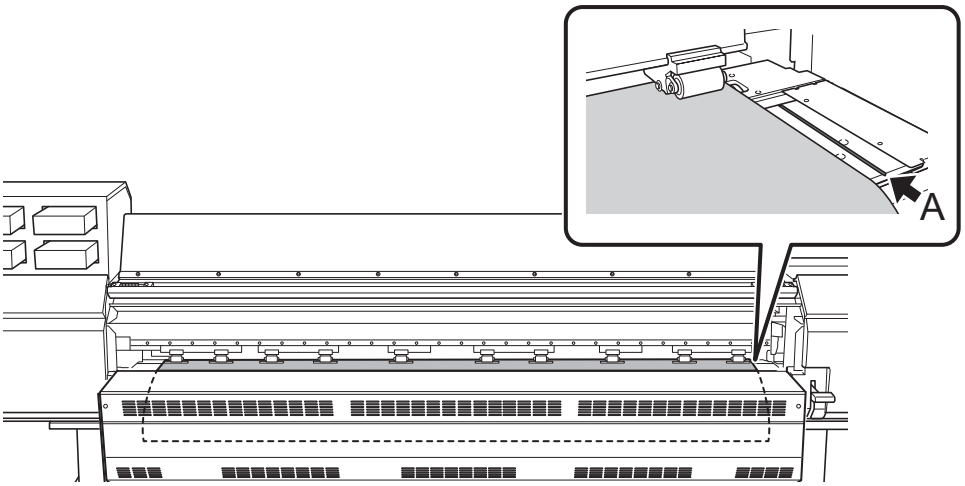


7. **Hold the media at the center and pull it out, being sure to keep it straight and all areas of the media to be taut.**



8. **Insert the leading edge of the media into the dryer.**

9. **Make sure the right edge of the media is in line with the guide line (A).**

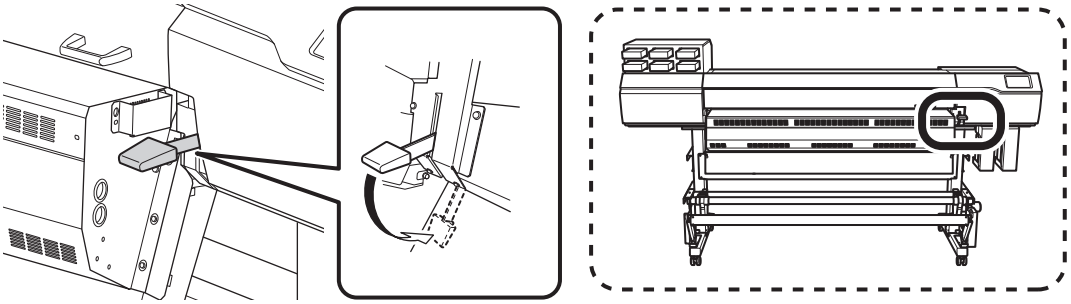


IMPORTANT

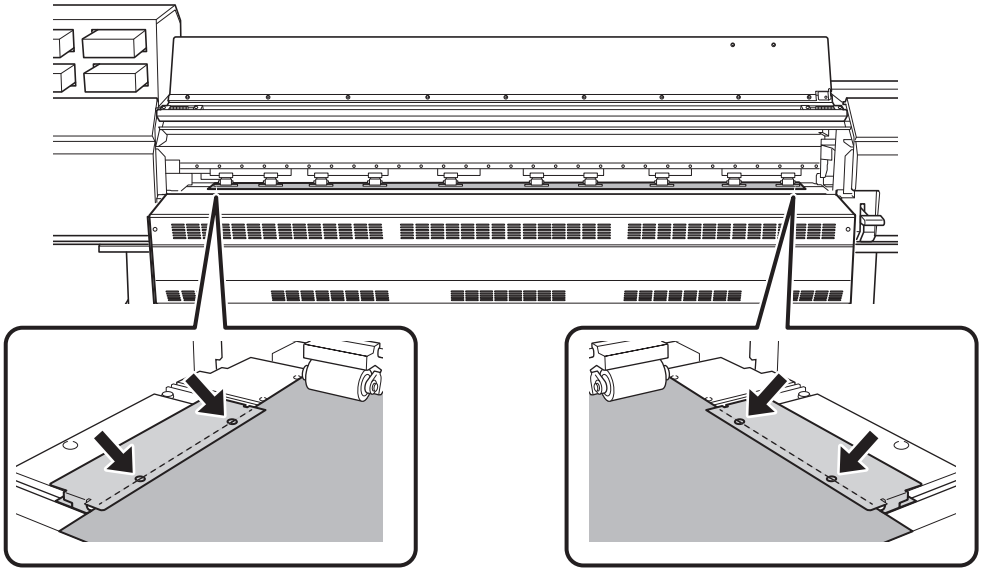
If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from step 1. If you just stand at the front of the printer and hold the media to readjust its position forcibly, the media will be skewed during printing or will come loose, which will affect the printing quality.

10. **Lower the loading lever (front).**

The media is held in place.



11. **Line up the edges of the media with the centers of the holes of the left and right media clamps.**



IMPORTANT

Be sure to use the media clamps when you load media.

If you attach the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

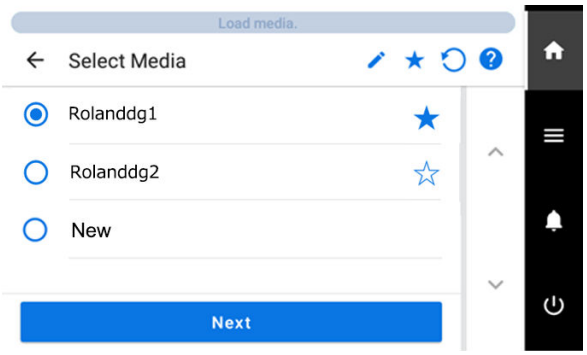
12. **Close the front cover.**

3. Select the media.

Procedure

1. Tap [Setup].

   The registered media is displayed in a list.



2. **Select the media name to use.**

   MEMO

   - Tapping makes it possible to search the registered media by keyword.

     To reset the entered keyword, tap .
   - Tapping to the right of the media name will change the symbol to , and the media will be registered to Favorites.

     Tap the Favorites filter ( ) at the top of the operation panel to turn the filter on ( ) and show only favorited media.

     Tap to turn the Favorites filter off.

     Tap to turn the Favorites filter off ( ) and reset all keywords.
   - Keyword searching and the Favorites filter can be used at the same time.

3. **Tap [Next].**

4. **The [Sheet Settings] screen appears. Configure the settings as shown below depending on the media.**
   - **For opaque media**
     a. Tap [**Side Margin**] to set the margin.
        You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
     b. Tap [**OK**].
   - **For transparent media, etc.**
     - [**Sheet Width**] setting

a. Tap  to the right of [**Sheet Width**].

b. Enter the sheet width and tap [**OK**].

- [**Sheet Right Edge**] setting
  a. Tap [**Change**] to the right of [**Sheet Right Edge**].
  b. Tap  or  to move the carriage's base point mark to the right edge of the media, and then tap [**OK**].
- [**Side Margin**] setting
  a. Tap [**Side Margin**] to set the margin.
  You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
  b. Tap [**OK**].

5. **The [Setup Method] screen appears. Select whether to use the take-up unit.**

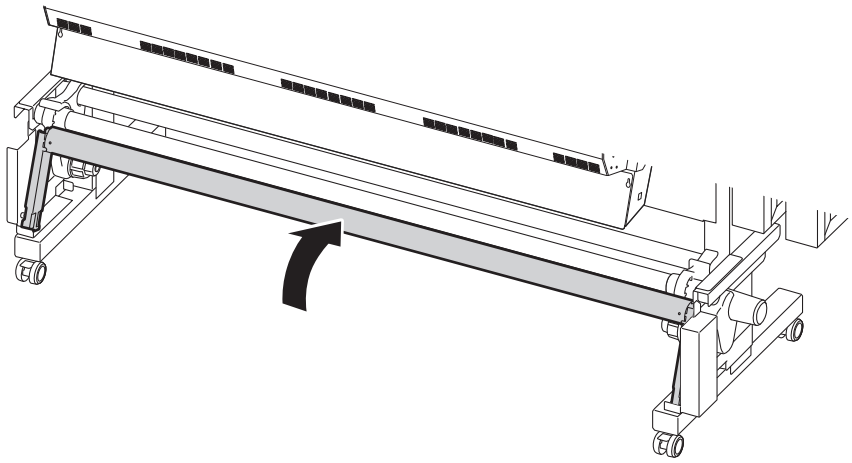
6. **Tap [Start Setup].**

4. Load the media in the take-up unit.

If you will not use the take-up unit, setup is complete.

Procedure

1. **Lower the dancer roller toward the rear.**



2. **Follow the procedure below to load a paper tube on the media holders of the take-up unit.**

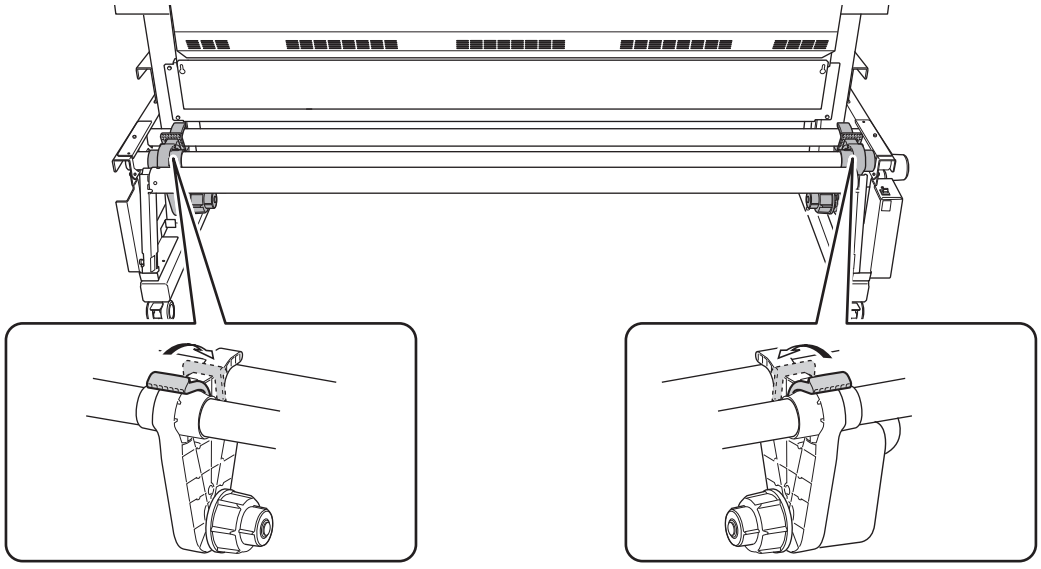
Prepare a paper tube wider than the media that has been set up.

IMPORTANT

Paper tubes are consumable items.

Watch the condition of the paper tube and replace at an appropriate time so that the media can be taken up in good working order.

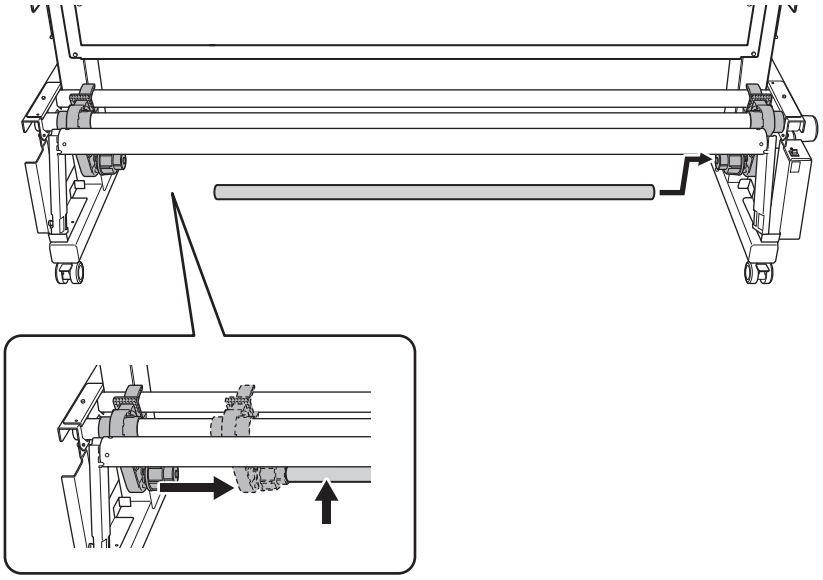
(1) **Release the media holders to enable their movement.**



(2) **Fit the paper tube onto the right end cap.**

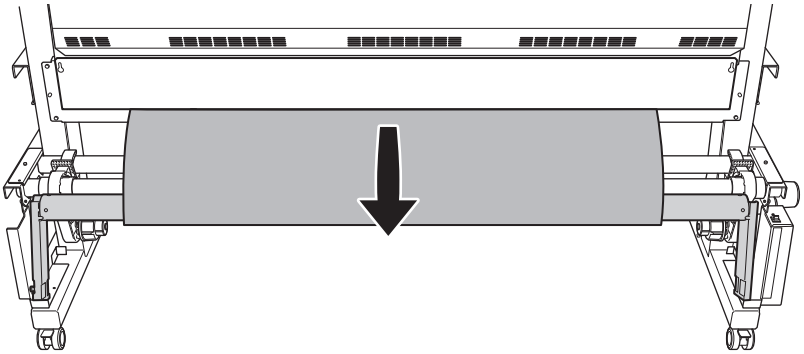
Fit the paper tube securely right to the end of the end cap.

(3) **Push the left media holder into the paper tube.**



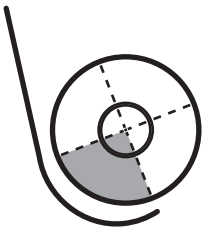
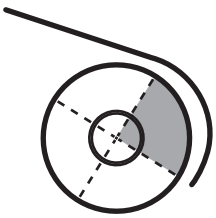
3. **Hold down [▼] on the operation panel to feed out the media until the tip of the media reaches the paper tube.**

Media is fed out 10 mm (0.39 in.) each time you hold down this button. Holding down the button lets you feed out paper continuously.



MEMO

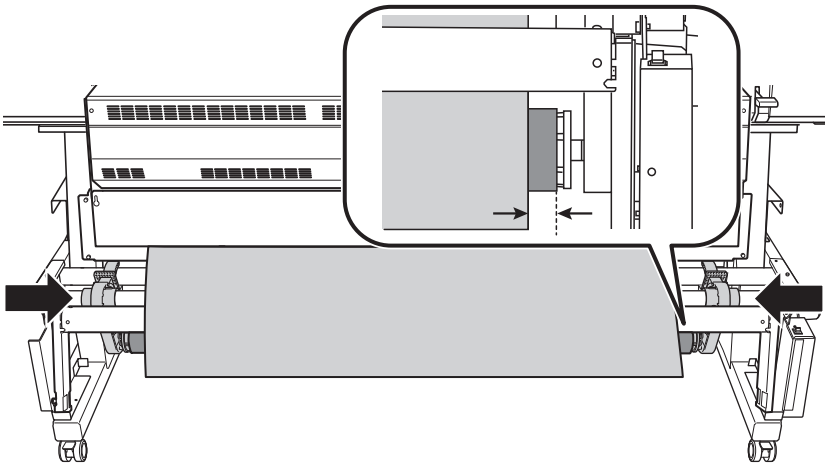
Feed out the media until it can wrap around at least 1/4 of the paper tube.

When using the FORWARD setting	When using the BACKWARD setting
	

4. **Follow the procedure below to adjust the positions of the media holders.**

(1) **Move both media holders so that it is possible to see the paper tube from the right edge of the media.**

Hold the media holders from the outside and move them.



(2) **Secure the left and right media holders.**

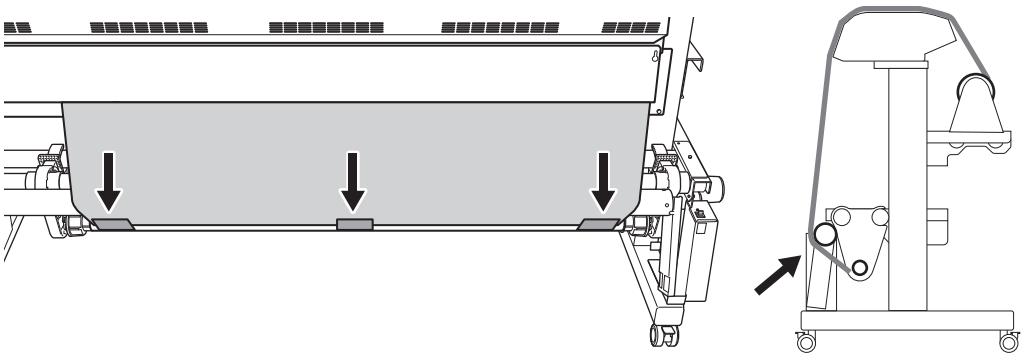
5. **Follow the procedure below to secure the media on the paper tube.**

Secure the media in the [**Take-up Direction**] set in step 2 of 1. Install the media on the media holders.(P. 26).

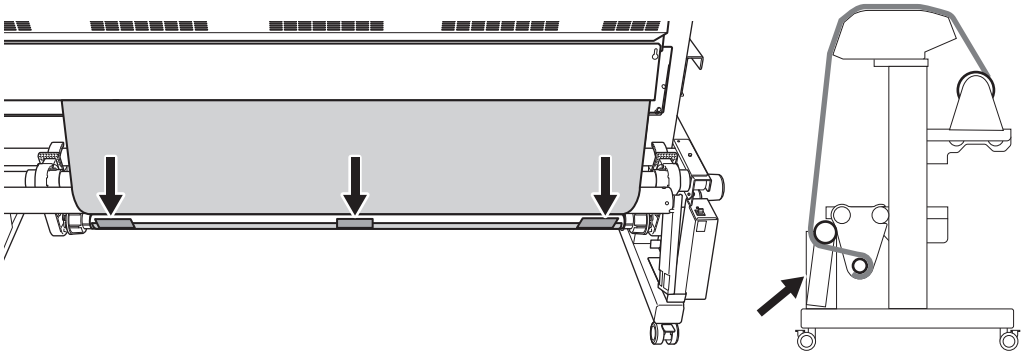
(1) **While pulling the media so that it does not sag, secure the center of the media on the paper tube with adhesive tape.**

(2) **While pulling the media from the center toward the outer edges, secure the left and right edges of the media on the paper tube with adhesive tape.**

- **When using the FORWARD setting**



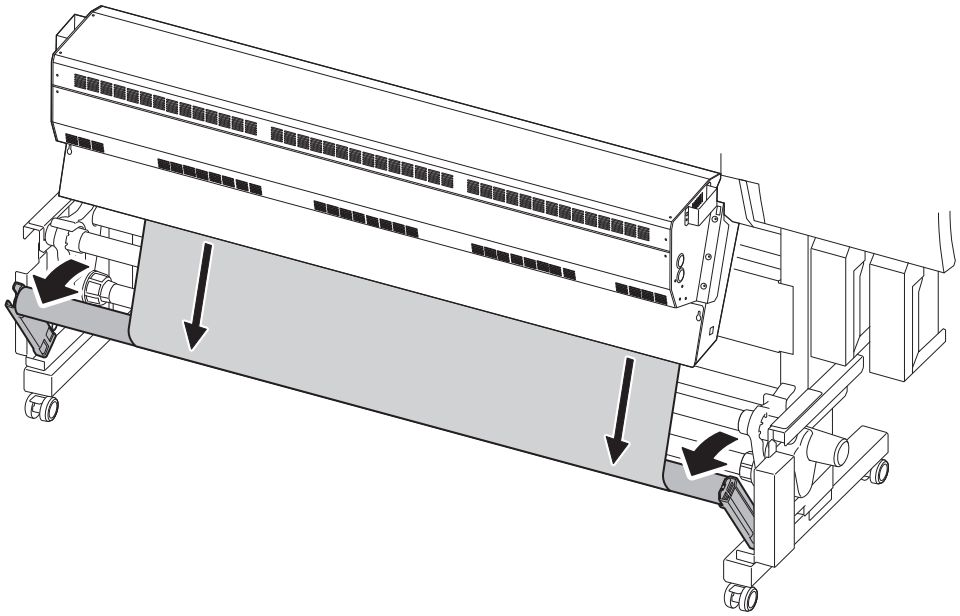
- **When using the BACKWARD setting**



6. **Tap [OK].**

A small amount of the media is fed out.

7. **Lower the dancer roller toward the front.**



8. Tap [OK].

Setup of Sheet Media

Load the sheet media on the printer. When the loading is finished, [**Output possible.**] is displayed as the status. This work is referred to as "Setup of Media."

1. A: Determine the positions of the media (opaque media).

This section describes how to use the suction fan to prevent media skewing.

By default, [**Skewing Correction Support at Setup**] is set to [**Enable**].

Procedure

1. **Tap  on the operation panel.**

   The sub power is switched on.

2. **Set the [Skewing Correction Support at Setup].**

   (1) **Tap .**

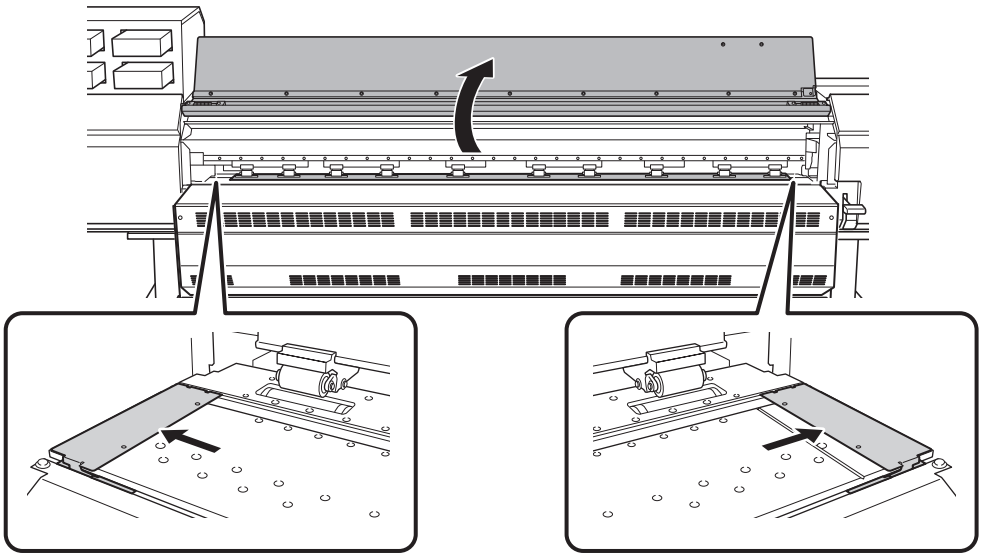
   (2) **[Preferences]>[Skewing Correction Support at Setup]**

   (3) **Select [Enable] and tap [Save].**

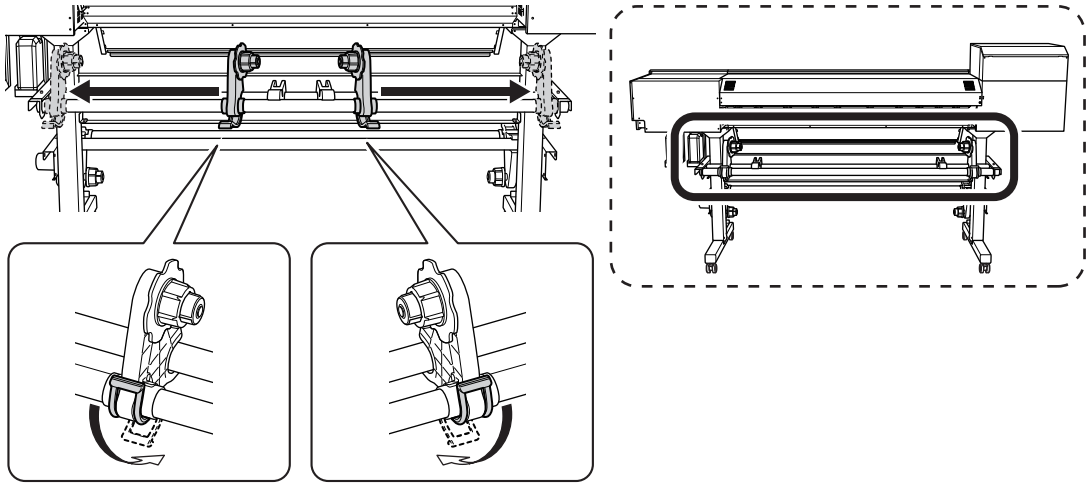
   (4) **Tap  to go back to the original screen.**

3. **Open the front cover.**

4. **Move the media clamps to the outside of the grit rollers on the left and right edges respectively.**



5. **(Move to the rear of the printer.) Release the locking mechanisms of the media holders, and then draw them to the left and right ends respectively.**



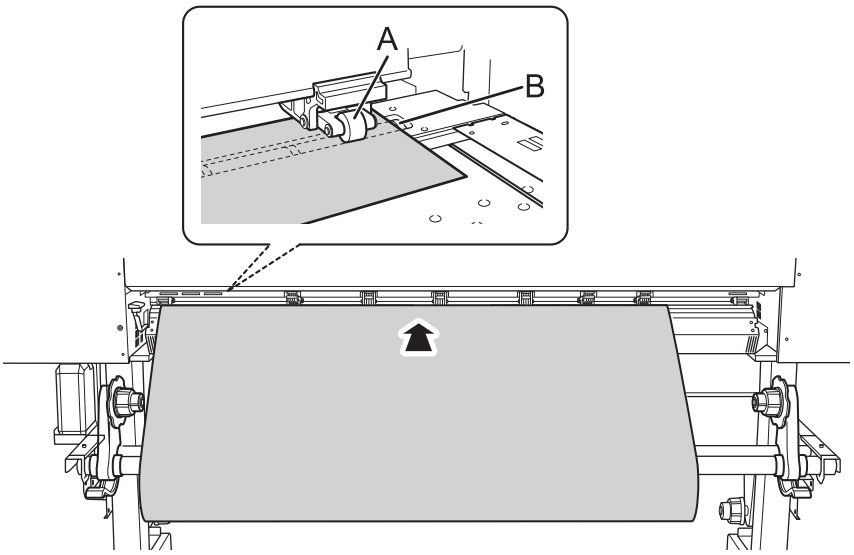
6. **From the rear of the printer, pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**

IMPORTANT

If the leading edge of the media is bent, cut the bent part before loading the media, as it may be difficult for the media to enter the dryer entrance.

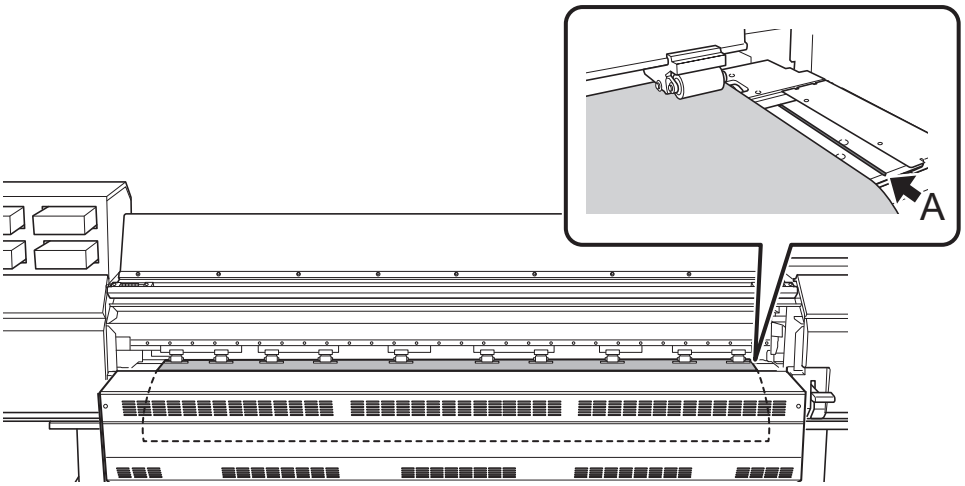
You will hear a beep. Approximately 5 seconds later, you will hear two beeps, and then the suction fan will activate. While this fan is operating, the media will not move backward even if you remove your hands from it.

When loading the media from the front of the printer, feed the leading edge of the media (the side where printing will start) over the platen, and then pull the media to the front to activate the suction fan.



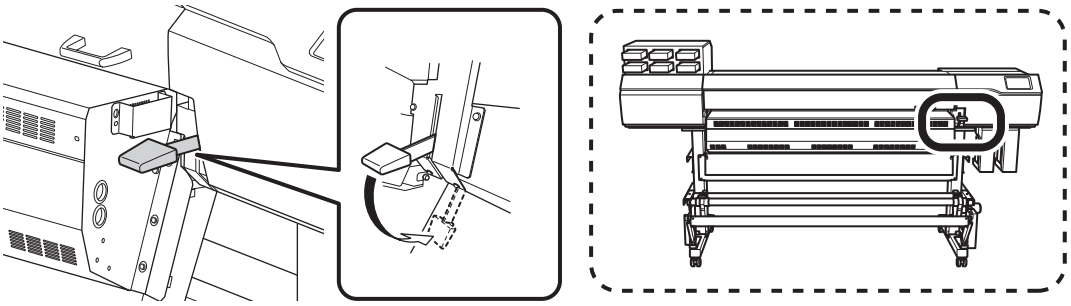
7. **(Move to the front of the printer.) Insert the leading edge of the media into the dryer.**

8. **Make sure the right edge of the media is in line with the guide line (A).**

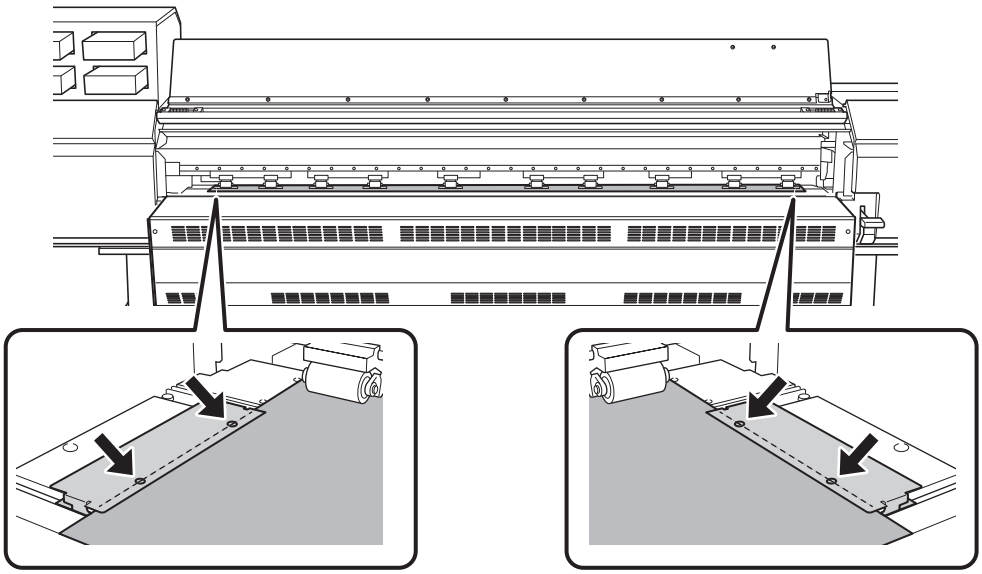


9. **Lower the loading lever (front).**

The media is held in place.



10. **Line up the edges of the media with the centers of the holes of the left and right media clamps.**



IMPORTANT

Be sure to use the media clamps when you load media.

If you attach the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

11. Close the front cover.

1. B: Determine the positions of the media (transparent media, etc.).

Use the following procedure to determine the positions of the media when using transparent media and media with high reflectance, whose edges cannot be detected.

Procedure

1. Tap  on the operation panel.

   The sub power is switched on.

2. Set the [Skewing Correction Support at Setup].

   (1) Tap .

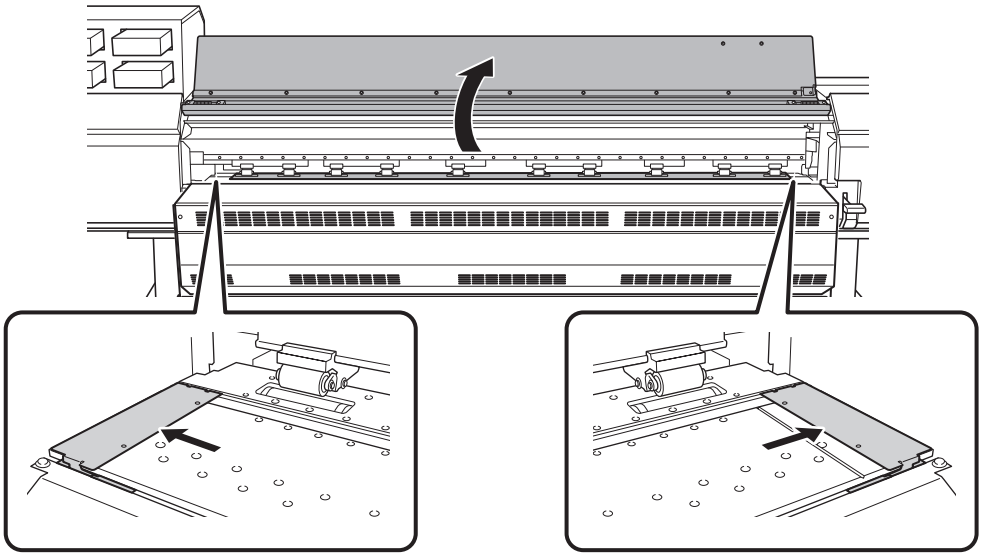
   (2) [Preferences]>[Skewing Correction Support at Setup]

   (3) Select [Disable] and tap [Save].

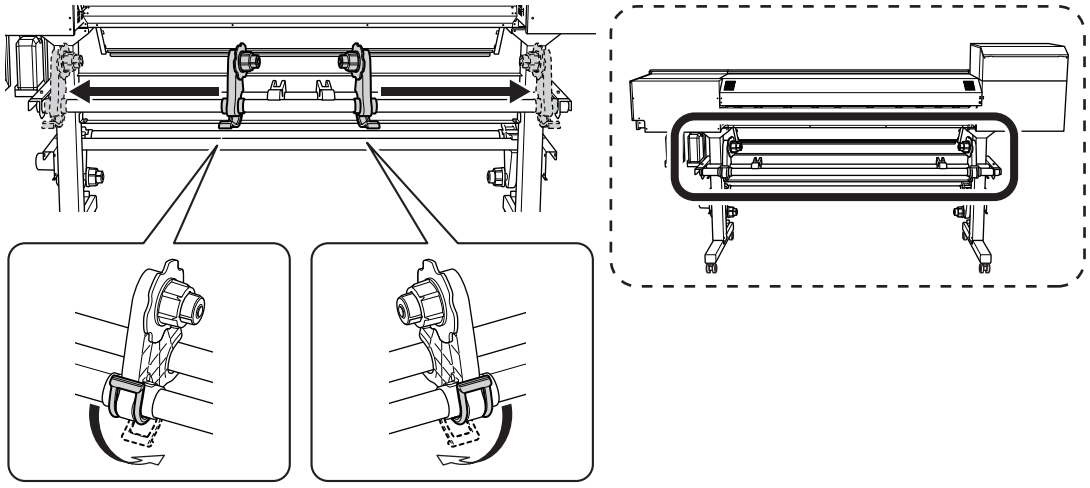
   (4) Tap  to go back to the original screen.

3. Open the front cover.

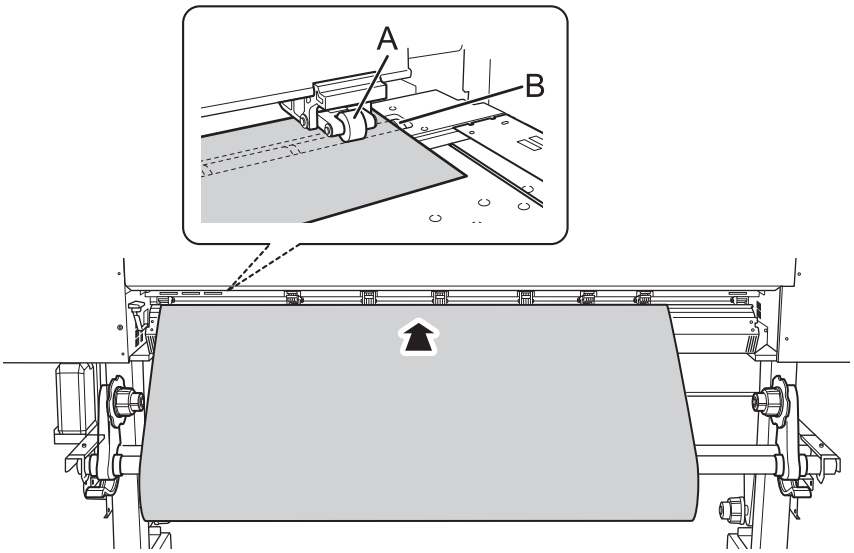
4. Move the media clamps to the outside of the grit rollers on the left and right edges respectively.



5. (Move to the rear of the printer.) Release the locking mechanisms of the media holders, and then draw them to the left and right ends respectively.

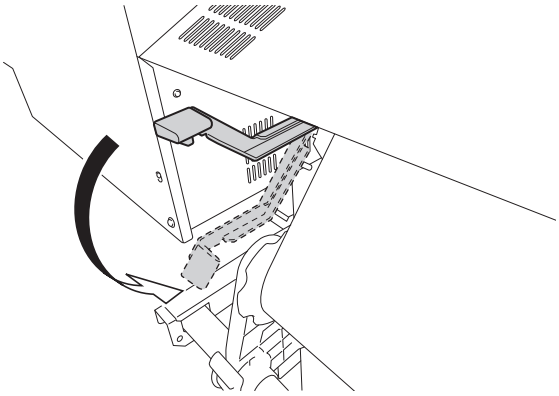


6. **Pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**



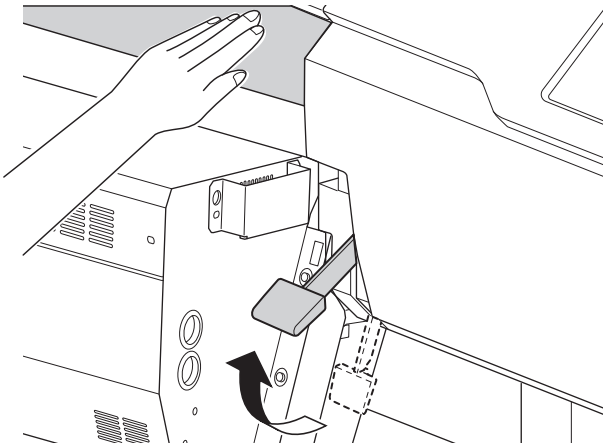
7. **Lower the loading lever (rear).**

The media is held in place.



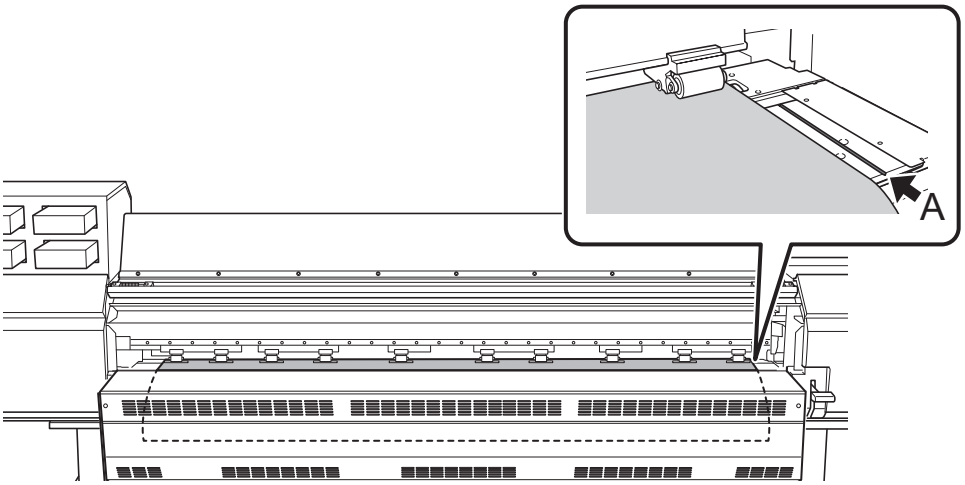
8. **(Move to the front of the printer.) Gently hold down the media and raise the loading lever (front).**

The media is released.



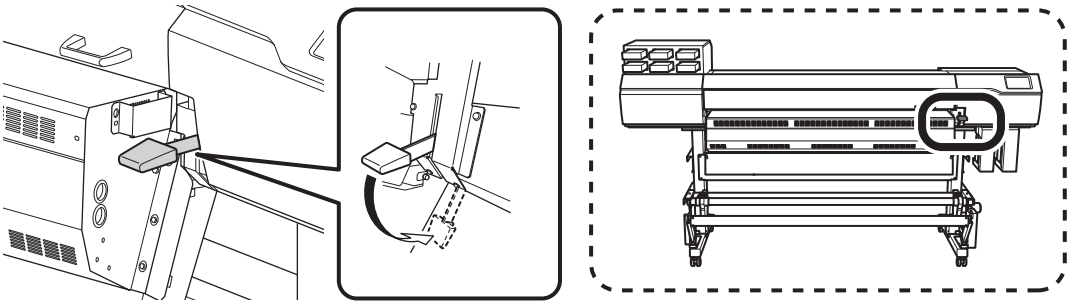
9. **Insert the leading edge of the media into the dryer.**

10. **Make sure the right edge of the media is in line with the guide line (A).**

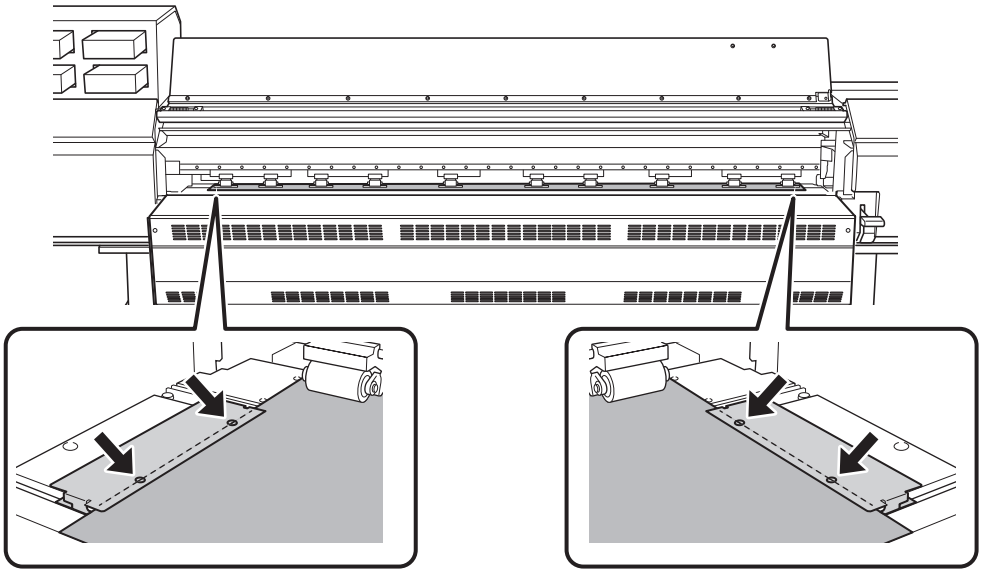


11. **Lower the loading lever (front).**

The media is held in place.



12. **Line up the edges of the media with the centers of the holes of the left and right media clamps.**



IMPORTANT

Be sure to use the media clamps when you load media.

If you attach the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

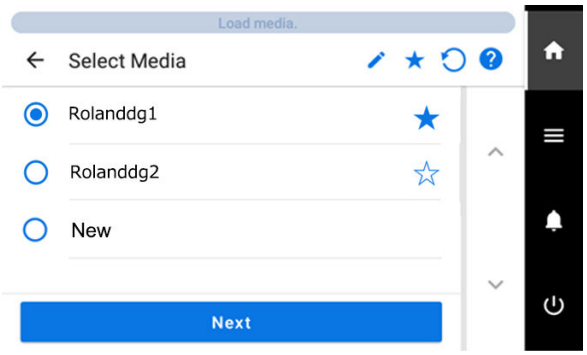
13. **Close the front cover.**

2. Select the media.

Procedure

1. Tap [Setup].

   The registered media is displayed in a list.



2. **Select the media name to use.**

   MEMO

   - Tapping makes it possible to search the registered media by keyword.

     To reset the entered keyword, tap .
   - Tapping to the right of the media name will change the symbol to , and the media will be registered to Favorites.

     Tap the Favorites filter ( ) at the top of the operation panel to turn the filter on ( ) and show only favorited media.

     Tap to turn the Favorites filter off.

     Tap to turn the Favorites filter off ( ) and reset all keywords.
   - Keyword searching and the Favorites filter can be used at the same time.

3. **Tap [Next].**

4. **The [Sheet Settings] screen appears. Configure the settings as shown below depending on the media.**
   - **For opaque media**
     a. Tap [**Side Margin**] to set the margin.
        You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
     b. Tap [**OK**].
   - **For transparent media, etc.**
     - [**Sheet Width**] setting

a. Tap  to the right of [**Sheet Width**].

b. Enter the sheet width and tap [**OK**].

- [**Sheet Right Edge**] setting
  a. Tap [**Change**] to the right of [**Sheet Right Edge**].
  b. Tap  or  to move the carriage's base point mark to the right edge of the media, and then tap [**OK**].
- [**Side Margin**] setting
  a. Tap [**Side Margin**] to set the margin.
  You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
  b. Tap [**OK**].

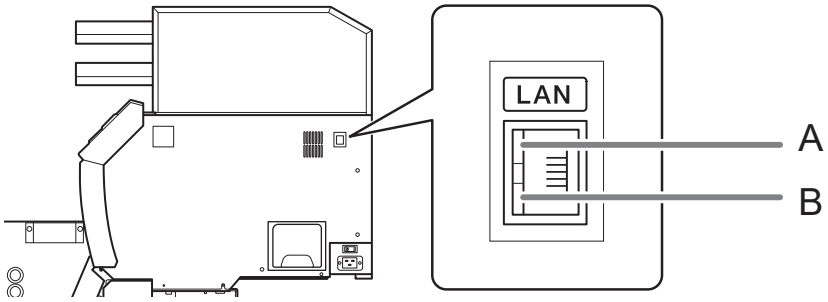
5. **The [Setup Method] screen appears. Select whether to use the take-up unit.**

6. **Tap [Start Setup].**

LAN (Local Area Network) Settings

Check that you can perform communication through the LAN (Local Area Network).

The LAN is enabled if the status LED (B) on the LAN connector located on the side of the printer is lit in green.



A	Activity LED	This flashes orange while data is being received from the network.
B	Status LED	This indicates the status of the communication function. When it lights in green, communication is possible.

Pausing and Canceling Output

You can pause and cancel output before it finishes.

Pausing and Resuming Output

IMPORTANT

We do not recommend resuming printing because horizontal bands and uneven colors are produced at the place where printing was paused.

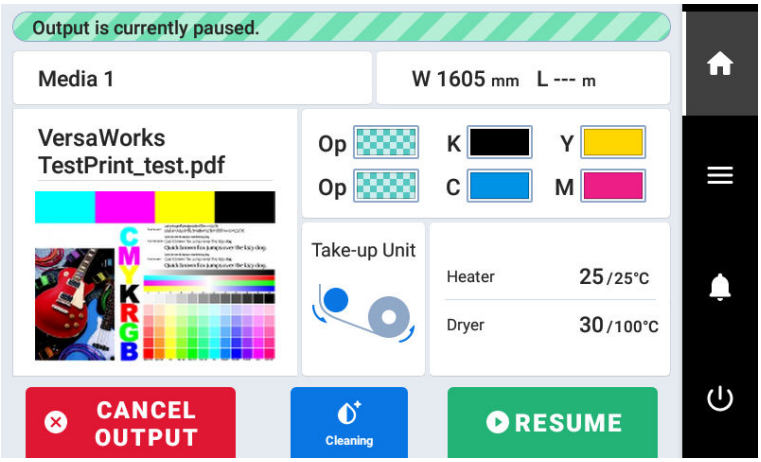
MEMO

Some menu items can be operated during output, but return to the home screen before pausing output.

Procedure

1. **During output, tap [Pause].**
   This pauses the printing operation.

2. **Tap [Resume].**



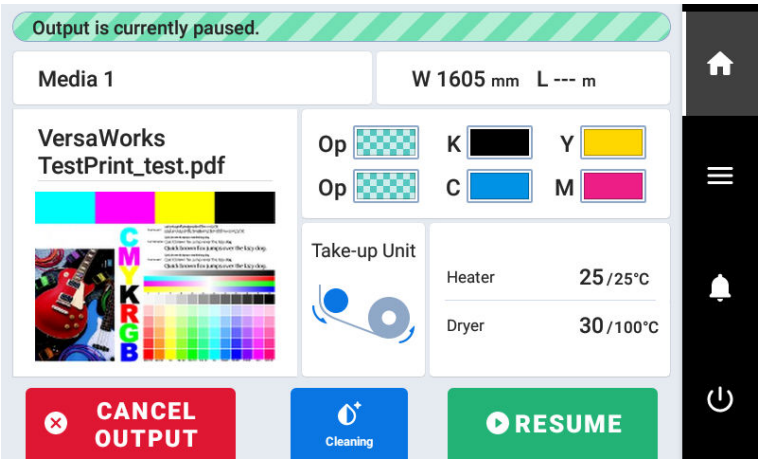
The printing operation resumes.

Canceling Output

Procedure

1. **During output, tap [Pause].**
   This pauses the printing operation.

2. **Tap [Cancel Output] when the following screen appears.**



   The confirmation screen for drying appears.

3. **Tap [Yes] or [No].**

> **IMPORTANT**
> Select [**Yes**] to feed the media to the dryer. Parts exposed to the dryer may suffer damage such as deformation or deterioration, which may result in poor printing quality.

4. **Stop sending the output data from the computer.**

Separating the Media

Separate the media after printing.

When continuously using the set up roll media, use [**Perforated Sheet Cutting**] to separate the media under the dryer after cutting.

When removing the roll media after printing, use [**Sheet Cutting**] to separate the media.

IMPORTANT

Separation Operations

- If the distance from the end of the media to the separation location is short, separation may not be performed smoothly.

When Using a Take-up Unit

- Do not operate the manual switch on the take-up unit leaving the loading lever lowered. Tension is applied to the media by the take-up unit, so avoid operations that pull the media with excessive force.

Give Attention to the Media Composition

- For some types of media, separation is not possible.
- Some types of media may remain on the platen after separation. If the media remains on the platen, remove it by hand.

MEMO

- When using a take-up unit, take-up may be interrupted by media separation, so turn off the automatic separation function or insert perforated sheet cutting with the included software RIP to ensure the media is not separated.
- You can configure settings in the software RIP for automatic media separation after output has finished. For information on how to configure the settings, refer to the documentation for the software RIP you are using.

Procedure

1. **Close the front cover.**

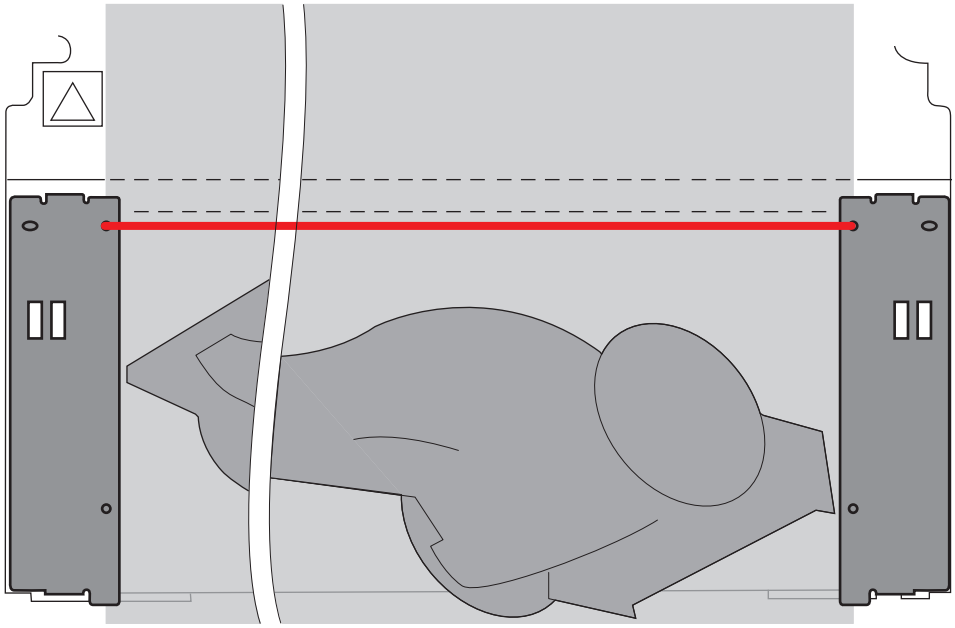
2. **If necessary, use the following procedure to set the separation position.**

   (1) **Tap**  **.**

   (2) **Tap**  **[Move].**

   (3) **Tap**  **or**  **to set the media to the separation position.**

   The media is separated at the position in the following figure. Use the media clamp holes as a guideline for this position.



(4) **Tap [Set Base Point Here].**

The separation position is set, and you are returned to the home screen.

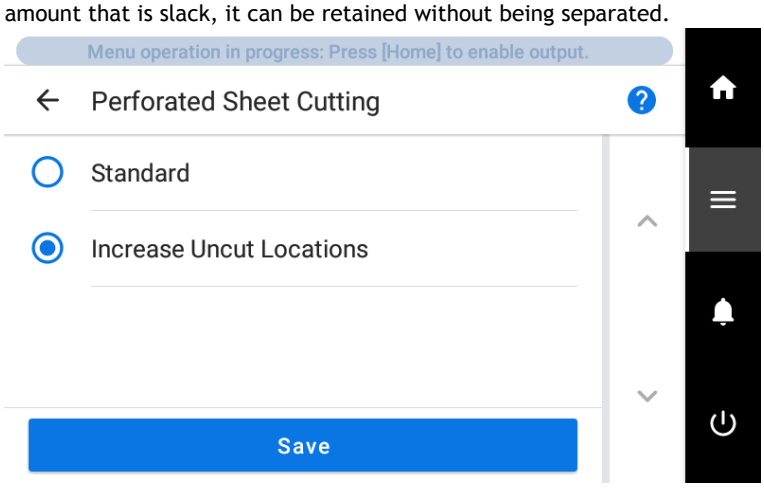
3. Tap  **[Sheet Cutting] on the operation panel.**

4. **Select the sheet cutting method.**

- When continuously using the set up roll media: [**Perforated Sheet Cutting**]
- When removing the roll media after sheet cutting: [**Sheet Cutting**]

MEMO

If the media is separated even after you select [**Perforated Sheet Cutting**], use [**Preferences**]>[**Perforated Sheet Cutting**] to change to the [**Increase Uncut Locations**] setting. If the media is heavy or has a large amount that is slack, it can be retained without being separated.



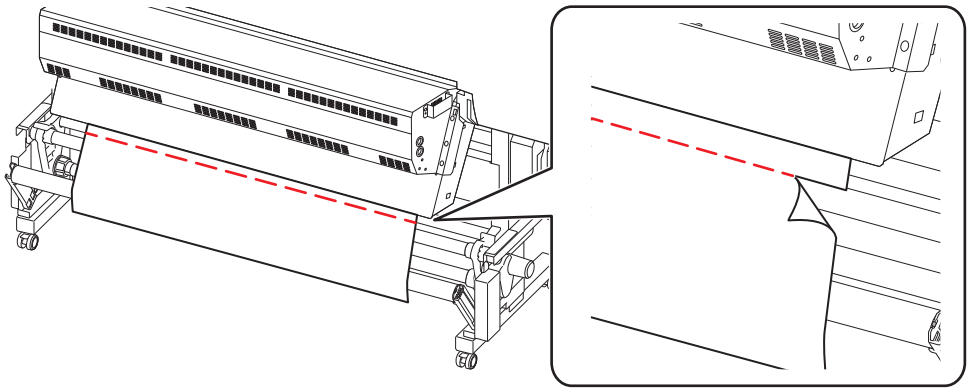
5. **Tap [Execute].**

The media is separated or perforated.

6. **Remove the printed media.**

If you performed a [**Perforated Sheet Cutting**], click  to feed the media under the dryer.

Then, separate the media.



IMPORTANT

If you separate the media before the dryer, such as above the platen, the leading edge of the media may get caught in the dryer or at its entrance the next time printing is performed.

Removing Media from the Take-up Unit

When output is complete, separate the media, take up the media manually, and then remove the media.

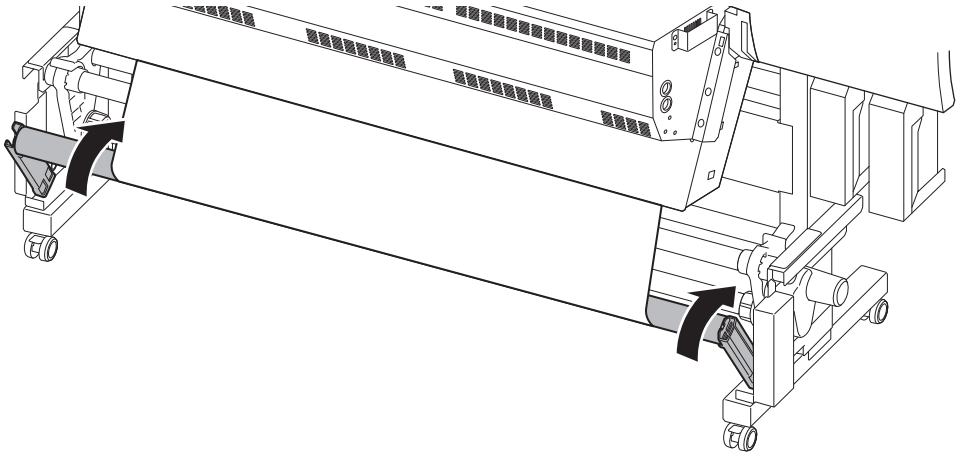
⚠ WARNING

Handling roll media is an operation that must be performed by 2 persons or more, and care must be taken to prevent falls.

Attempting to lift heavy media in a manner that taxes your strength may cause physical injury. Also, if dropped, such items may cause injury.

Procedure

1. **Lower the dancer roller toward the rear.**



2. **Close the front cover.**

3. **With the media held down, tap  [Sheet Cutting] on the operation panel.**

⚠ WARNING

High Temperature

The areas inside the dryer, under the dryer, and near the extension apron become hot. Exercise caution to avoid burns.

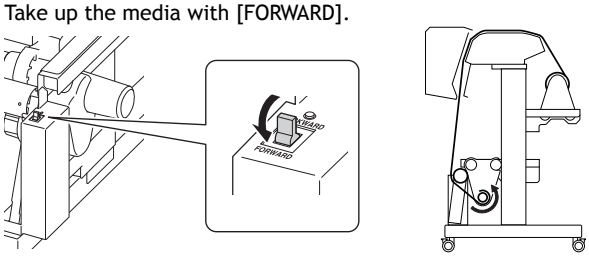
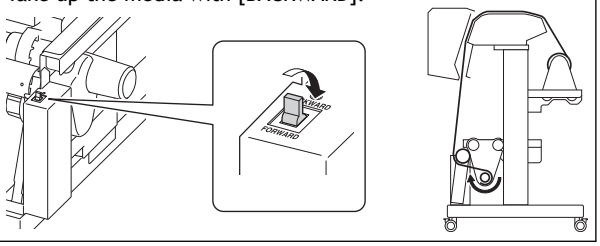
4. **Select [Sheet Cutting] and tap [Execute].**

IMPORTANT

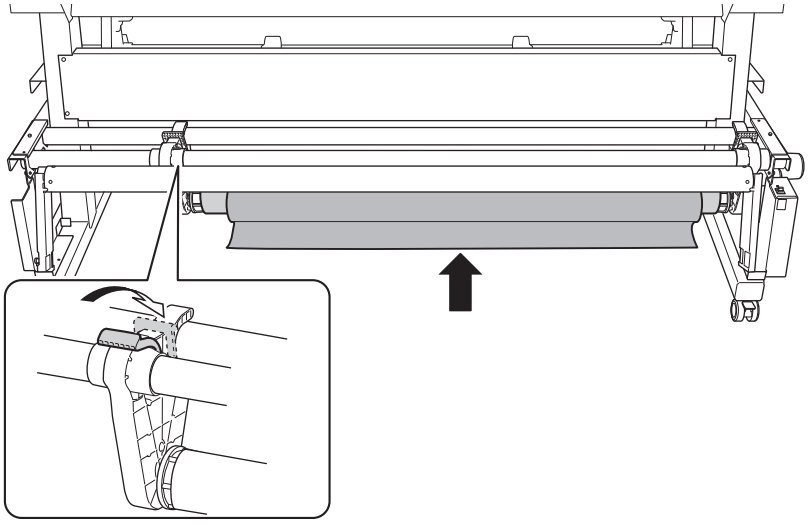
Give Attention to the Media Composition

- For some types of media, separation is not possible.
- Some types of media may remain on the platen after separation. If the media remains on the platen, remove it by hand.

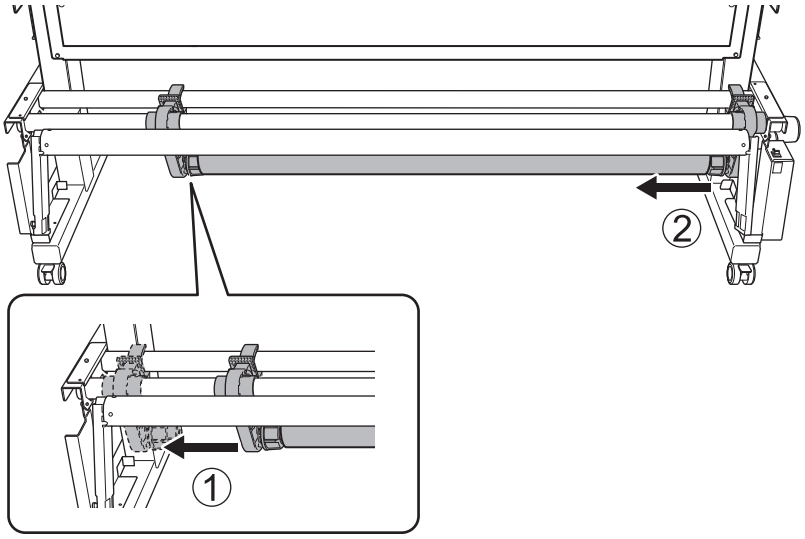
5. **Use the MANUAL switch to take-up the media.**

When using the FORWARD setting	When using the BACKWARD setting
Take up the media with [FORWARD]. 	Take up the media with [BACKWARD]. 

6. **While supporting the media from below, loosen the securing lever on the left media holder.**



7. **With the media supported, pull the paper tube and media from the end cap.**



Ink Pouch Replacement

Out-of-ink Warnings

When an ink pouch runs out, printing pauses and a warning beep sounds. Also, the screen [**Ink has run out.**] will be displayed on the operation panel to request that you replace the ink.

IMPORTANT

Never reuse an ink pouch when the machine shows a sign indicating no ink.

Occasionally the machine will show a sign indicating no ink even if there is a small amount of ink remaining in the pouch, but nevertheless do not use it. Such an ink pouch is in a state where drawing ink from it is impossible. Using it in such a state may force air into the ink path and cause printer malfunctions.

RELATED LINKS

- P. 97 Ink Pouch Replacement

Ink Pouch Replacement

⚠ WARNING

Never store ink, cleaning liquid, or discharged fluid in any of the following locations.

- **Any location where high temperature may occur**
- **Near bleach or any other such oxidizing agent or explosive material**
- **Any location within the reach of children**

Accidental ingestion by children may pose a health hazard.

IMPORTANT

Precautions regarding ink pouch replacement

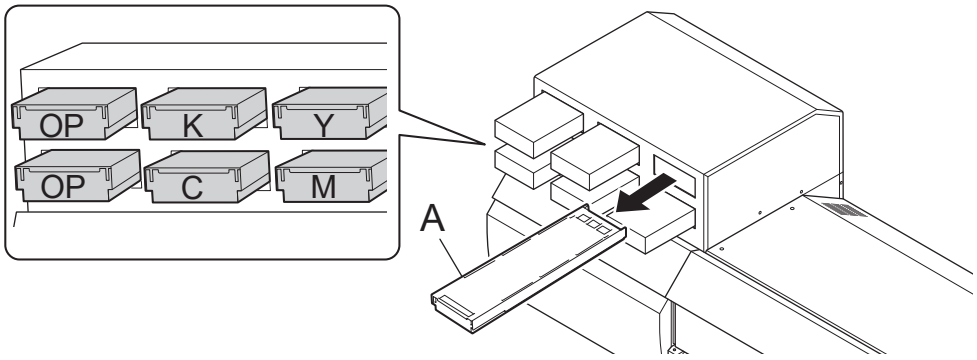
- Be sure to replace each pouch with an item of identical type and color.
- Never use an ink pouch that has already been used in another machine even if it is an identical type.
- Never mix different types of items.
- Never leave the machine with a pouch tray removed. The print heads may become clogged.
- Do not insert or remove pouch trays unless necessary. Ink may leak.
- Set the pouch trays in their correct locations. Check that the color names indicated on the ink slot labels match the color names indicated on the pouch tray labels.
- Handle ink pouches carefully to prevent them from dropping and rupturing.
- Use ink before its expiration date.

Procedure

1. Remove the pouch tray (A) for the color that you will replace.

MEMO

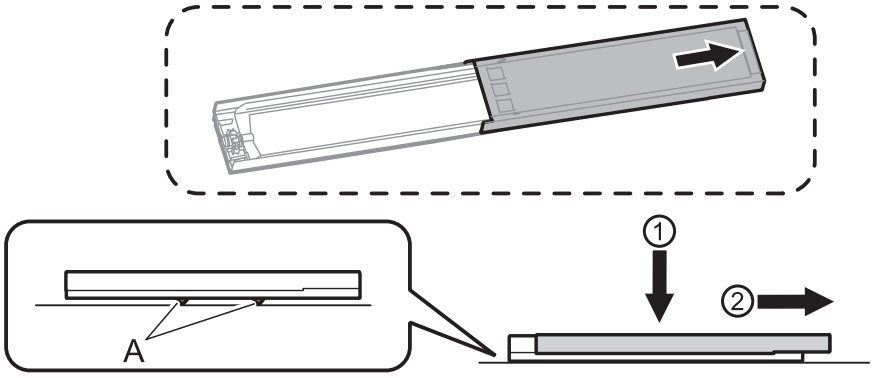
The bottoms of the pouch trays may be dirty with ink. Periodically clean them.



2. Place the pouch tray on a flat surface.

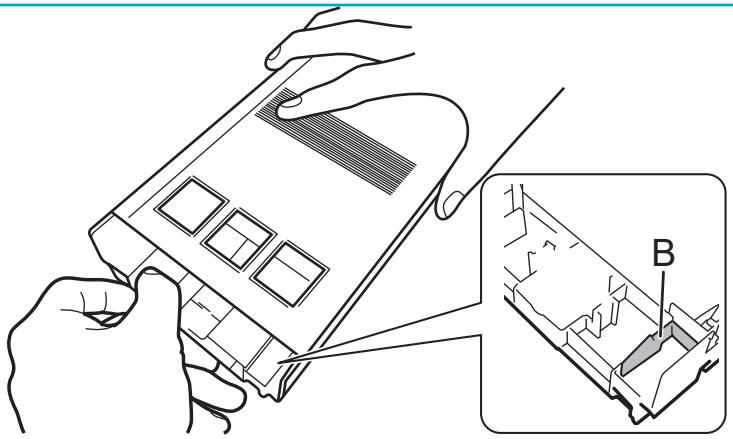


3. Push in the hooks (A) on the bottom of the pouch tray ①, and then slide the lid ② to open it fully.

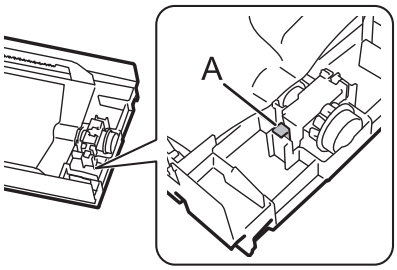


IMPORTANT

When opening the lid, hold it as shown in the figure and do not touch (B). Doing so may cause damage.



4. **Pinch the hook (A) at the tip of the ink pouch, and then remove the ink pouch from the pouch tray.**

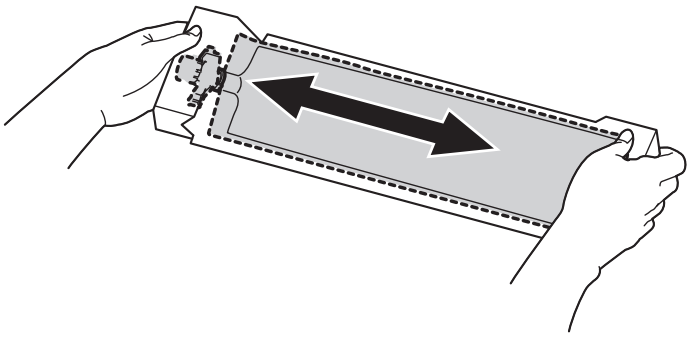


MEMO

Wipe off the ink at the tip of the pouch tray. Alternatively, periodically clean the pouch tray.

5. **Remove the inner box from the ink pouch packing box, and then gently shake the inner box.**

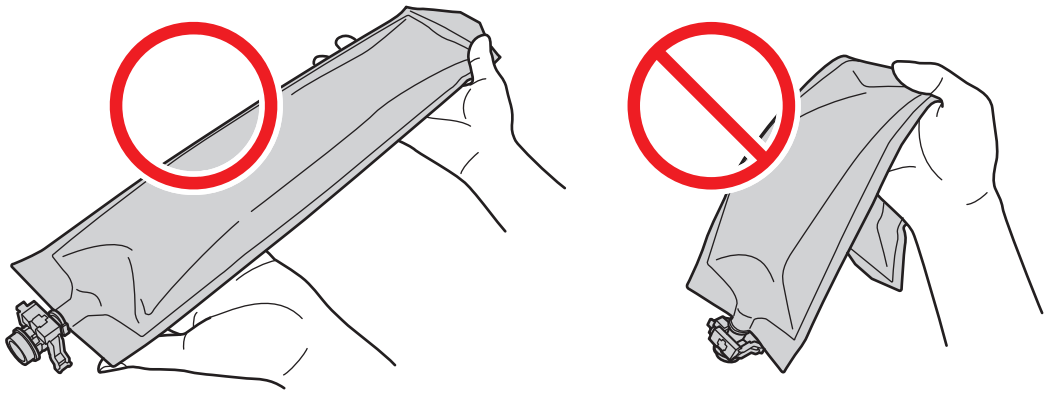
To protect the ink pouch, shake it while it is still inside the inner box.



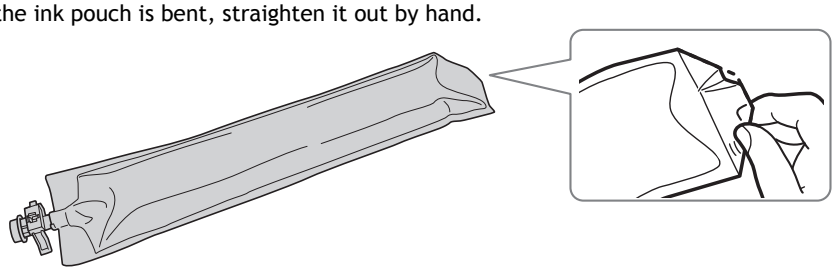
6. **Remove the new ink pouch from the inner box and the plastic bag.**

IMPORTANT

- When taking the ink pouch out of the plastic bag, do not use a utility knife or any other sharp object. Doing so may lead to accidentally cutting the ink pouch.
- Handle ink pouches carefully. They may rupture if they are bent or dropped or if they catch on a sharp object.



- If the tip of the ink pouch is bent, straighten it out by hand.

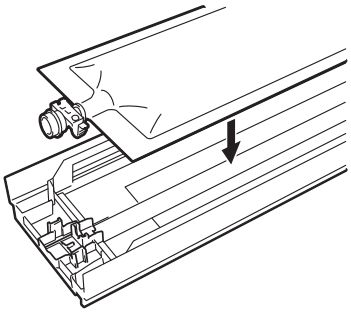


MEMO

The expiration date sticker should be found in the plastic bag. Keep this safe until you need it for a later task.

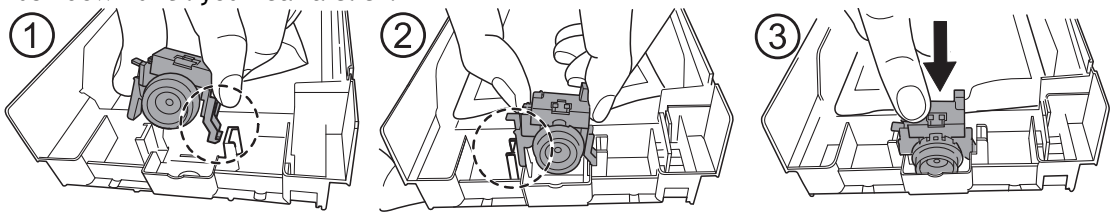
7. **Set the ink pouch in the pouch tray.**

(1) **Set the ink pouch on top of the pouch tray.**

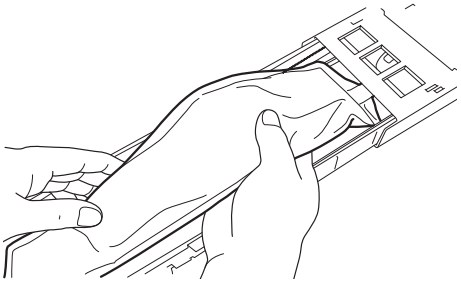


(2) **Follow the procedure below to attach the tip of the ink pouch to the pouch tray.**

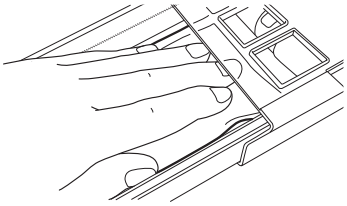
Push down until you hear a click.



(3) **Insert the ink pouch into the pouch tray.**

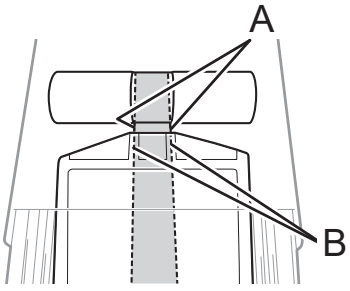


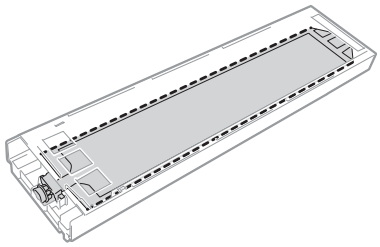
(4) **Insert the back end of the ink pouch into the underside of the pouch tray roller, ensuring that this end is straight.**



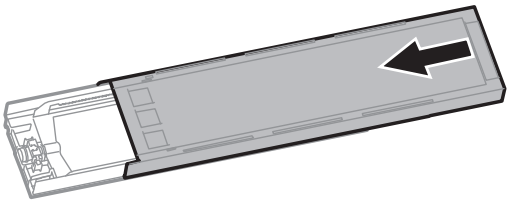
(5) **Check that the ink pouch has been set in the correct position.**

Match the pouch tray lines (A) with the ink pouch lines (B). Check that the ink pouch is lined up straight with the pouch tray.





(6) **Close the pouch tray lid until you hear a click.**

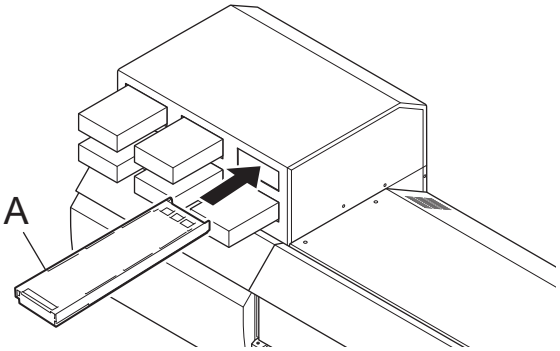


(7) **Affix the ink pouch's expiration date sticker (A), included with the ink pouch, to the right side of the pouch tray ink label.**



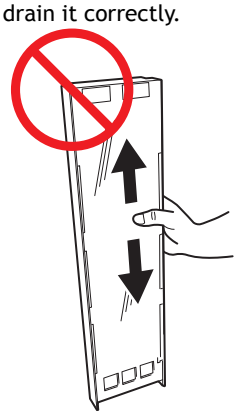
8. Set the pouch tray (A) in the ink slot.

Insert the pouch tray as far as it will go. If the inserted ink is not recognized and does not show up on the operation panel, remove it and insert it again.

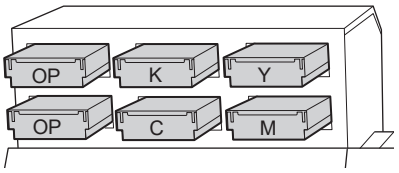


IMPORTANT

- Do not insert empty pouch trays. Doing so may force air into the ink path and cause printer malfunctions.
- After setting an ink pouch in a pouch tray, do not shake the tray with it held vertically. The ink pouch may wrinkle, making it impossible to wind and drain it correctly.



- Check the color names indicated on the ink slots and the ink pouches to set all the pouch trays in their correct positions.


OP
K
Y
OP
C
M

Cleaning Liquid Replenishment

Out-of-cleaning-liquid Warnings

If the cleaning liquid runs out, [**Fill the cleaning liquid tank with cleaning liquid.**] appears on the screen. Tap [**OK**] to close this message.

You can also check the message by tapping .

RELATED LINKS

- P. 104 Cleaning Liquid Replenishment Method

Cleaning Liquid Replenishment Method

⚠ WARNING

Never store ink, cleaning liquid, or discharged fluid in any of the following locations.

- **Any location where high temperature may occur**
- **Near bleach or any other such oxidizing agent or explosive material**
- **Any location within the reach of children**

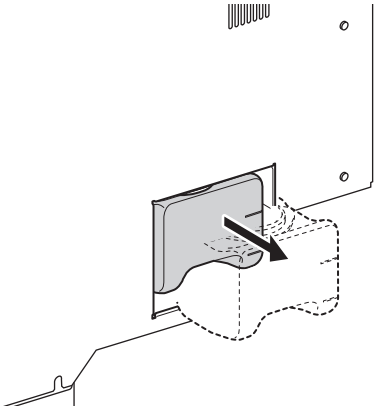
Accidental ingestion by children may pose a health hazard.

IMPORTANT

- Be sure to use cleaning liquid that has not expired.
- Never, under any circumstances, use anything other than the specified type of cleaning liquid.
- The cleaning liquid must be purchased separately. Contact your authorized dealer or visit our website (https://www.rolanddg.com/).

Procedure

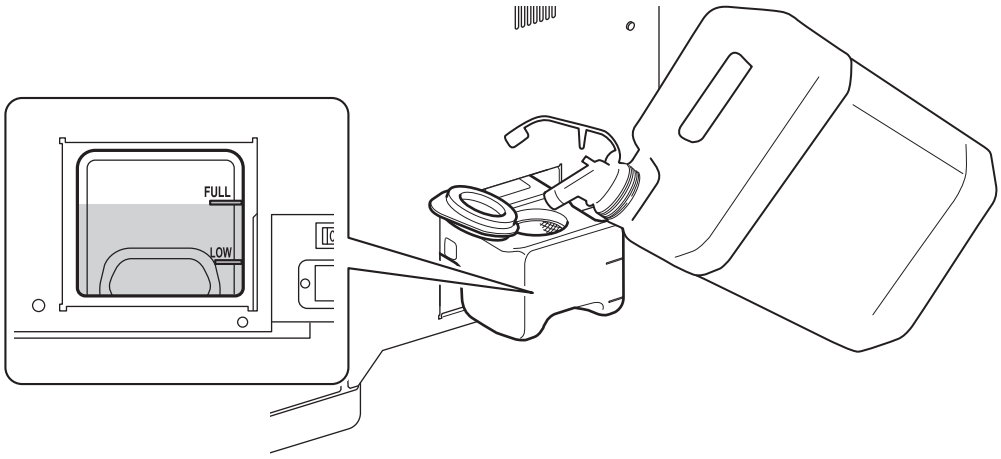
1. **Pull the cleaning liquid tank out from the side of the printer.**



2. **Open the lid of the cleaning liquid tank, and then fill it with cleaning liquid to the "Full" line.**

IMPORTANT

Do not fill past the "Full" line.



3. Close the lid of the cleaning liquid tank, and then slowly return this tank to its position in the printer.

Output Method

Printing Method

Preparations before Printing Output 108
Step 1: Performing a Nozzle Drop-out Test 108
Step 2: Performing Normal Cleaning 109
Printing Output 111

Preparations before Printing Output

Step 1: Performing a Nozzle Drop-out Test

Before you carry out actual printing, perform a printing test to ensure no dot drop-out or dot displacement occurs. If dot drop-out or dot displacement occurs, perform cleaning of the print heads (normal cleaning).

MEMO

When performing printing tests successively, you can select [**Feed**] (vertical printing) or [**Scan**] (horizontal printing) as the printing position for the second and later tests in comparison to the first test.

P. 140 Performing Printing Tests Arranged Horizontally

Procedure

1. **Load the media.**

   P. 26 Setup of New Media

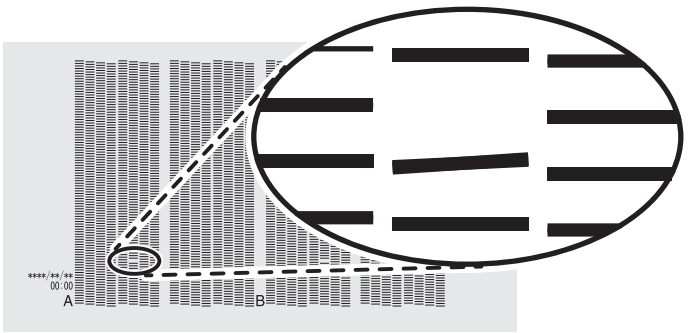
2. **Tap**  **[Nozzle Drop-out Test] on the home screen.**

3. **Tap [Execute] next to [Printing Test].**

   Printing of the test pattern starts.

4. **Check whether there is dot drop-out or dot displacement in the test pattern.**

   Missing blocks indicate dot drop-out. Collapsed or inclined blocks indicate dot displacement.

   IMPORTANT

   Depending on the media, locations on which optimizer ink is printed may be difficult to check. If it is difficult to see the optimizer ink, switch to a different media and perform the printing test again.

5. **If you have opened the front cover, close it.**

   If no dot drop-out or dot displacement occurs, this operation is finished. Press  to go back to the original screen.

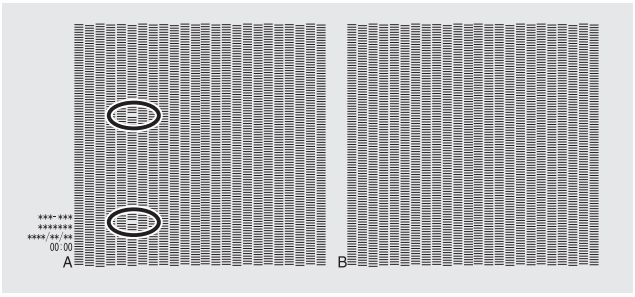
RELATED LINKS

- P. 179 When Dot Drop-out or Dot Displacement Occurs

Step 2: Performing Normal Cleaning

Procedure

1. **Check for the group with dot drop-out or dot displacement by viewing the results of the printing test.**
   The space from "A" to "B" is group A. The space from "B" to the right side is group B.



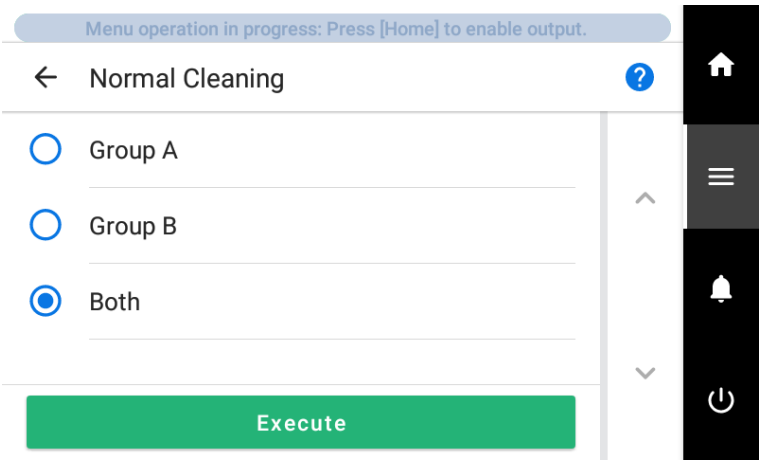
MEMO

If the printing-test results are difficult to interpret

- Check the results in a bright location, changing your line of vision. They are visible using the reflection of the light.
- Depending on the media, locations on which optimizer ink is printed may be difficult to check. If it is difficult to see the optimizer ink, switch to a different media and perform the printing test again.

2. **Tap** .

3. **Tap [Cleaning]>[Normal Cleaning].**
   The screen shown below appears.



4. **Select the group of print heads to clean.**

5. **Tap [Execute].**
   Cleaning will start. The status is displayed as [**Normal cleaning in progress.**] at the top of the operation panel.
   On completion, you will return to the original screen.

6. **Tap** ←.

7. **Perform a printing test again.**

8. **Check to make sure the dot drop-out or dot displacement has been corrected.**

If the problem persists, try performing normal cleaning again. If the printer has been used for a long period, dot drop-outs may not be fixed even after performing normal cleaning two or three times. If this is the case, clean using a different method.

RELATED LINKS

- P. 108 Performing a Nozzle Drop-out Test
- P. 181 When Normal Cleaning Is Not Effective

Printing Output

⚠ CAUTION

Never touch the print-head carriage while output is in progress.

The print-head carriage moves at high speed. Coming into contact with the moving carriage may cause injury.

Procedure

1. **Close the front cover.**
2. **Make sure [Output possible.] is displayed at the top of the operation panel.**
3. **Send the output data from the computer.**

   For information on how to create the output data, refer to the documentation for the included software RIP.

MEMO

When you send the output data, [**Cleaning liquid filling in progress.**] or [**Maintenance in progress.**] may be displayed on the screen. These indicate the preparation operations performed before output. Output will begin after the time displayed on the screen elapses.

IMPORTANT

Output Is Not Possible in These Situations

- The machine does not run when a cover (front, left, or right) is open.
- Data from the computer is not accepted when [**Load media.**] is displayed.
- If the print heater and dryer do not reach the set temperature, the output will not start. Wait until the set temperature is reached.
- On menu screens where [**Menu operation in progress: Press [Home] to enable output.**] is displayed, output doesn't start even when data is sent from the computer. When you return to a menu item where output is possible or tap  to return to the home screen, output starts.

Points that must be observed

- Never open a cover (front, left, or right) while output is in progress. Doing so interrupts printing.
- When you are performing printing, clamp the edges of the media with the media clamps. Otherwise, the edges of the media may warp and catch on the print heads.
- During output, do not touch the media. Doing so may obstruct the media feed or cause the media to rub against the print heads, which may result in a paper jam or damage to the heads.
- Keep the loading lever raised when the machine is not in use.

When not using the machine, remove any media and store it in a suitable environment.

- If the machine is left with the media loaded, the media may be damaged, which may adversely affect printing. When not using the machine, remove any media and store it in a suitable environment.

RELATED LINKS

- P. 128 Setting the Dryer Temperature

Optimizing Quality and Efficiency

Optimizing the Output Quality

Using the Correction Functions 114
Automatically Making Required Adjustments 114
Manual Adjustment: Reducing Horizontal Bands (Feed Correction) 115
Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment) 117
Configuring Settings to Match the Properties of the Media 119
Changing the Print Head Height 119
Using Media That Wrinkles Easily/Does Not Move Smoothly 121
Using Sticky Media 122
Using Heat-resistant Media with Minimal Waste 123
Setting the Take-up Unit 124
Adjusting the Ink-drying Method 126
Setting the Print Heater Temperature 127
Setting the Dryer Temperature 128
Setting the Temperature during Standby 129

Using the Correction Functions

To optimize the output quality, it is effective to use some correction functions.

Automatically Making Required Adjustments

To optimize the output quality, corrections must match the media and printing conditions.

Depending on the printing conditions, the ink landing position may be misaligned and the movement distance may change subtly during media feeding. Automatically correct these issues to match the media.

First, print a test pattern. Then read this pattern with the multi sensor and automatically enter the correction values.

Executing automatic correction prints a test pattern, reads this pattern, and enters the correction values for the following operations.

- Multi sensor adjustment (adjusting to the optimal condition the sensor used in correction)
- Media gap adjustment (correcting the ink landing position)
- Feed correction (to reduce horizontal bands)

Procedure

1. **Load the media.**
2. **Close the front cover.**
3. **Tap** .
4. **Tap [Media Settings]>[Printing Settings]>[Batch Automatic Correction].**
5. **Tap [Execute].**

   Test patterns are printed and correction values are entered for the following operations.
   - Multi Sensor Adjustment
   - Feed Correction
   - Media Gap Adjustment
6. **Tap [OK] when the completion screen appears.**
7. **Perform the operations shown below according to the [Result].**
   - If **[Successful]** is displayed on the operation panel, tap  to go back to the original screen.
   - If **[Failed]** is displayed on the operation panel, carry out manual adjustment.

RELATED LINKS

- P. 115 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)
- P. 117 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)

Manual Adjustment: Reducing Horizontal Bands (Feed Correction)

Perform corrections to make the band-shaped "stripes" on the printed surface less noticeable.

The band-shaped "stripes" are called "horizontal bands" or "banding." Horizontal bands are caused by the subtle changes in the movement distance that occur when feeding the media depending on the media's thickness and type. We recommend making corrections to match the media you are using.

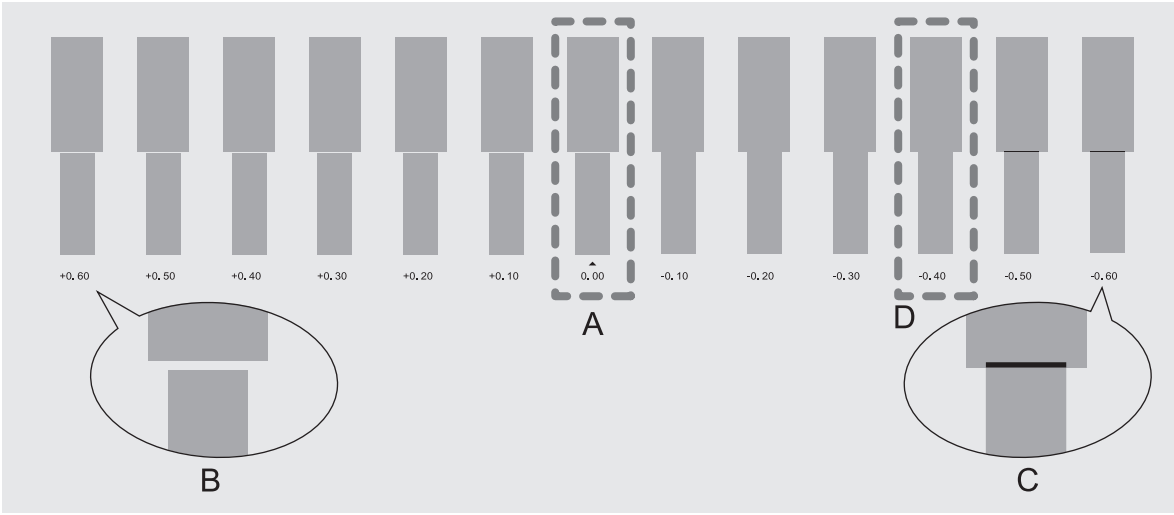
First, print a test pattern, and then determine and enter the correction value. After entering the correction value, print a test pattern again and check the correction results. Repeat the process of printing a test pattern and entering a correction value several times to find the optimal correction value.

Procedure

1. **Load the media.**
2. **Close the front cover.**
3. **Tap**  **.**
4. **Tap [Media Settings]>[Printing Settings]>[Feed Correction].**
5. **Select [Detailed Correction (Manual)] and tap [Next].**
6. **Tap [Execute] next to [Printing Test].**

   Printing of the test pattern starts.
7. **Check the printed test pattern, and then tap**  **or**  **to enter the correction value.**

   The current correction value (A) is that of the figure indicated by "▲." Select the value to make the gap (B) and overlap (C) between the upper/lower squares smallest. In the case of the following figure, select "−0.40" (D). When you cannot choose between two sequential numbers, specify a value that is between them.



MEMO

- If the test pattern is difficult to see, tap  or  next to [**Media Feed**] to move the media to a position where it is easier to see.
- If you want to hold the media to check the test pattern, tap [**Execute**] next to [**Sheet Cutting**] to separate the media.

8. **Tap [Save].**

The entered correction value is saved.

9. **Tap [Execute] next to [Printing Test].**

The test pattern is printed again.

10. **Check the test pattern to see whether the correction was successful.**

Check that the gap and overlap are the smallest for the figure indicated by "▲" (that is, the current correction value). If the gap and overlap are smaller for another figure, set the correction value again.

11. **When you have successfully performed the correction, tap  to go back to the original screen.**

Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)

This adjusts the landing position of the ink discharged from the print heads. The landing position varies according to the print head height and the thickness of the media, so we recommend that you make corrections to match the media you are using.

First, print a test pattern, and then determine and enter the correction value. After entering the correction value, print a test pattern again and check the correction results.

This adjustment must be performed in the following cases.

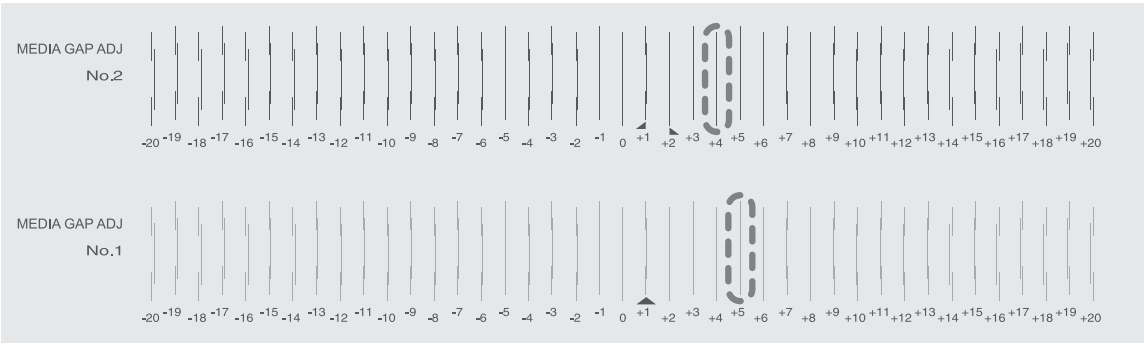
- When using this machine for the first time
- When changing the media to use
- When you have changed the print-head height

Procedure

1. **Load the media.**
2. **Close the front cover.**
3. **Tap**  **.**
4. **Tap [Media Settings]>[Printing Settings]>[Media Gap Adjustment].**
5. **Select [Detailed Correction (Manual)] and tap [Next].**
6. **Tap [Execute] next to [Printing Test].**

   Printing of the test pattern starts.
7. **Check the printed test pattern, and then tap**  **or**  **to enter the No. 1 and No. 2 correction values.**

   Select the value that gives the least misalignment between the two lines. In the case of the following figure, select "+5" for No. 1 and "+4" for No. 2. When you cannot choose between two sequential numbers, select a value that is between them (you can set correction values in units of "0.5").



MEMO

- If the test pattern is difficult to see, tap  or  next to [**Media Feed**] to move the media to a position where it is easier to see.
- If you want to hold the media to check the test pattern, tap [**Execute**] next to [**Sheet Cutting**] to separate the media.
  P. 91 Separating the Media

8. **Tap [Save].**

The entered correction values are saved.

9. **Tap [Execute] next to [Printing Test].**

The test pattern is printed again.

10. **Check the test pattern to see whether the correction was successful.**

For all the correction values, check that the misalignment is minimized for the two vertical lines indicated by "▲" (that is, the current correction value). If the misalignment is smaller for another set of vertical lines, set the correction value again.

11. **When you have successfully performed the correction, tap  to go back to the original screen.**

Configuring Settings to Match the Properties of the Media

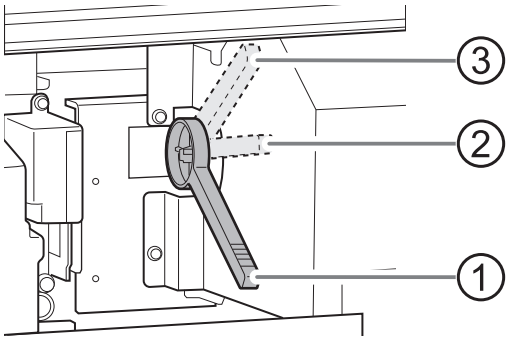
Changing the Print Head Height

This adjusts the print head height to prevent media that is wrinkled or comes loose from the platen from contacting the print heads.

You can select the print head height from [**Low**], [**Medium**], and [**High**]. Printing quality when the print head height is set to [**Medium**] or [**High**] may be coarser or otherwise lower than when set to [**Low**].

Procedure

1. **Load the media.**
2. **Tap** .
3. **Tap [Media Settings]>[Printing Settings]>[Print Head Height].**
4. **Tap [Change].**
   The print heads move to a position where they can be operated.
5. **Open the front cover.**
6. **Move the height-adjustment lever to adjust the print head height.**
   When you change the position of the height-adjustment lever, the display screen will change.



Position	Operation panel display	Description
①	[**Low**]	Normally set the height-adjustment lever to [**Low**].
②	[**Medium**]	For media that is wrinkled or comes loose from the platen during printing, set the height-adjustment lever to [**Medium**].
③	[**High**]	For media that is wrinkled or comes loose from the platen during printing even when the height-adjustment lever is set to [**Medium**], set the lever to [**High**].

IMPORTANT

The printing quality degrades as the distance between the media and the print heads increases. Do not move the height-adjustment lever to [**Medium**] or [**High**] needlessly.

7. **Close the front cover.**
8. **Tap [OK].**

The print heads move to their original position.

9. Tap  to go back to the original screen.

MEMO

- Default setting: **[Low]**
- If degradation of printing quality occurs after raising the print head height, refer to the following information and try optimizing the quality.

RELATED LINKS

- P. 114 Automatically Making Required Adjustments
- P. 117 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)

Using Media That Wrinkles Easily/Does Not Move Smoothly

The platen uses suction to grip the media and keep it stable. The suction force can be adjusted corresponding to the nature and condition of the media.

Procedure

1. **Load the media.**
2. **Tap**  **.**
3. **Tap [Media Settings]>[Other Media Settings]>[Media Suction Force].**
4. **Tap**  **or**  **to enter the value.**

0 to 100%	When the media is flimsy and cannot move smoothly, decreasing this value (reducing the suction force) may correct the problem.
Auto	The suction force is automatically adjusted to the optimal level for the media width

5. **Tap [Save] to confirm your entry.**
6. **Tap**  **to go back to the original screen.**

MEMO

- Default setting: [**Auto**]
- Depending on the software RIP you are using, you can also make this setting in the software RIP. When you have made the setting in the software RIP, the machine's setting is ignored.

Using Sticky Media

This setting is used to peel off the media before starting printing when using media that sticks easily to the platen. This setting is effective to prevent media jams.

Note, however, that peeling off the media may cause unstable media feed. Leave this menu item set to [**Disable**] unless you specifically need to change it.

Procedure

1. **Load the media.**
2. **Tap**  **.**
3. **Tap [Media Settings]>[Other Media Settings]>[Media Sticking Prevention].**
4. **Select [Enable].**
5. **Tap [Save] to confirm your entry.**
6. **Tap**  **to go back to the original screen.**

MEMO

- Default setting: [**Disable**]

Using Heat-resistant Media with Minimal Waste

This machine feeds media to dry the ink until it passes through the dryer after printing. Since parts exposed to the dryer may suffer damage such as deformation or deterioration, which may result in poor printing quality, they are normally left as a margin without printing.

However, for heat-resistant media, there is little heat impact, so you can set the media to be pulled back and print to the part that was exposed to the dryer. If you want to configure this setting, perform a printing test on the media you are using to see if the printing quality is valid.

Procedure

1. **Load the media.**
2. **Tap**  **.**
3. **Tap [Media Settings]>[Heater Settings]>[Pullback After Printing].**
4. **Select [Enable].**

[Enable]	After printing, media is fed to the dryer to dry. The media is then pulled back to start the next printing operation.
[Disable]	After printing, media is fed to the dryer to dry, and then the next printing operation starts. The margin between the print-end position and the next print-start position is set to a value of 420 mm (16.54 in.).

5. **Tap [Save] to confirm your entry.**
6. **Tap**  **to go back to the original screen.**

MEMO

Default setting: [**Disable**]

IMPORTANT

When this function is set to [**Enable**], be sure to check the following points related to printing quality.

- Is the media wrinkled or deformed after being pulled back?
  If wrinkles are occurring, set this function to [**Disable**] and stop pulling back the media. This can cause jamming of the media.
- Is the print quality deteriorating after printing?

Setting the Take-up Unit

When using a take-up unit, make sure the following settings match the take-up method and output method of the actual media.

The settings will have to be changed from the defaults when:

- When using weak media.
- Taking-up the media with inward curl.

Procedure

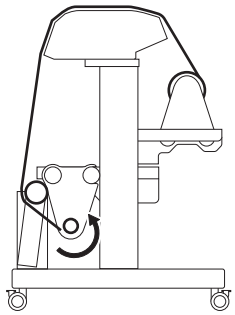
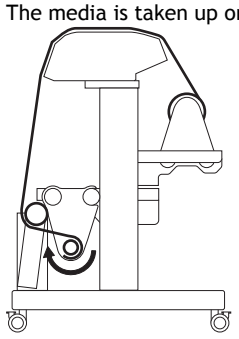
1. **Tap** .
2. **Tap [Preferences]>[Take-up].**
3. **Tap [Take-up Method].**
4. **Select the setting from those shown below and tap [Save].**

[Loose Winding]	The media is taken up with some slack. This is suited to PVC and other such stiff or slippery media.
[Tension Winding]	The media is stretched and taken up. This is suited to tarpaulin and other such weak media and media that does not slip easily.

MEMO

- Default setting: **[Loose Winding]**

5. **Tap [Take-up Direction].**
6. **Select the setting from those shown below and tap [Save].**

[Forward]	The media is taken up onto the paper tube with the printed surface on the outside. 
[Backward]	The media is taken up onto the paper tube with the printed surface on the inside. 

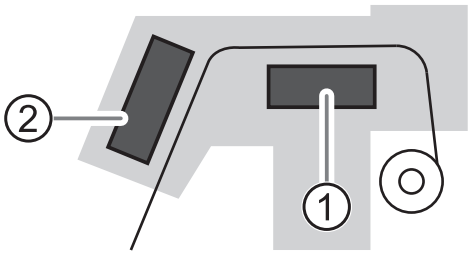
MEMO

- Default setting: **[Forward]**

7. Tap  to go back to the original screen.

Adjusting the Ink-drying Method

This machine is equipped with functions to improve ink adhesion and also to dry the ink. You can adjust the temperature settings to match the type of media and the printing speed.



①	**[Print Heater]**	This heater is used mainly to improve ink adhesion.
②	**[Dryer]**	This is used to dry the ink.

⚠ WARNING

High Temperature

The areas inside the dryer, under the dryer, and near the extension apron become hot. Exercise caution to avoid burns.

⚠ WARNING

When output is not being performed, remove any loaded media or switch off the sub power.

The continued application of heat at a single location may cause the release of toxic gases from the media or pose a fire hazard.

⚠ WARNING

Never use media that cannot withstand heat.

Doing so may result in fire or the release of toxic gases or may degrade the media.

⚠ WARNING

Never use the platen or dryer for any purpose for which they are not intended, such as to dry clothing.

Doing so may cause overheating, resulting in fire or accident.

Setting the Print Heater Temperature

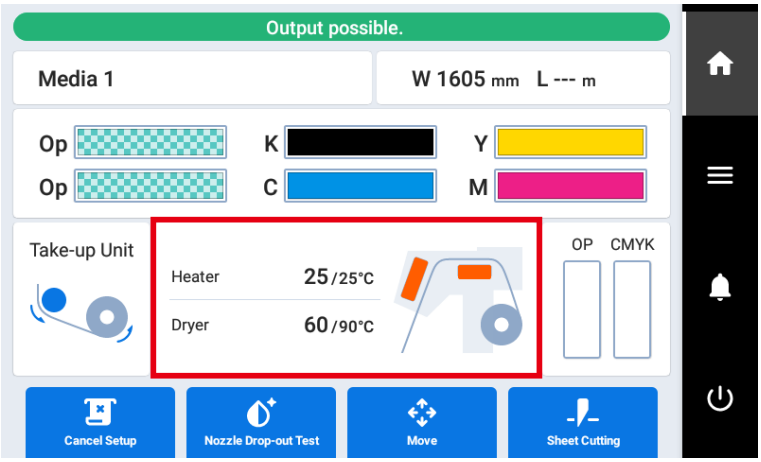
Setting the temperature of the print heater appropriately improves ink adhesion and inhibits smudging.

- With the default settings, simply switching on the power does not make the dryer warm up to the set temperature. On completion of media setup, the temperature rises to the set value.
- Depending on the usage environment, the temperature of the dryer may become higher than the set temperature, but this does not represent a problem.

Procedure

1. **Load the media.**

2. **Tap the following location on the home screen.**



The [**Heater Temperature**] screen appears.

3. **Tap**  **or**  **to set the [Print Heater] temperature.**

If the ink forms lumps or smudges, raise the temperature. Note, however, that a temperature that is too high may degrade the media or cause it to wrinkle.

4. **Tap [Save] to confirm your entry.**

5. **Tap**  **to go back to the original screen.**

MEMO

- Default setting: 25°C (77°F)
- You can also make this setting in the software RIP. When you have made the setting in the software RIP, the software RIP's setting is used.

Setting the Dryer Temperature

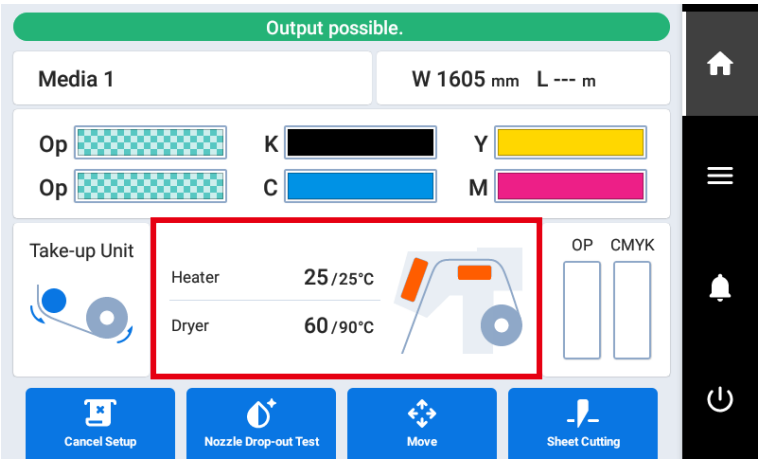
Setting the temperature of the dryer appropriately dries the ink.

- Basically, use the software RIP (color profile) settings for temperature. Even if you use the software RIP settings, if you need to adjust the temperature, such as when there is smudging or poor drying, change the temperature in the machine settings.
- High temperatures make it easier to dry the ink, but temperatures that are too high can damage the media by deforming or deteriorating it. Select settings appropriate for the media.

Procedure

1. **Load the media.**

2. **Tap the following location on the home screen.**



The [**Heater Temperature**] screen appears.

3. **Tap**  **or**  **to set the [Dryer] temperature.**

When ink drying is poor, set the temperature to a higher value. Note, however, that a temperature that is too high may degrade the media or cause it to wrinkle.

4. **Tap [Save] to confirm your entry.**

5. **Tap**  **to go back to the original screen.**

MEMO

- Default setting: 90°C (194°F)
- You can also make this setting in the software RIP. When you have made the setting in the software RIP, the software RIP's setting is used.

Setting the Temperature during Standby

Set the print heater temperature used when the main power and the sub power are switched on and the loading of the media is not complete. For the dryer, set the temperature used when the loading of the media is complete.

Procedure

1. Tap .
2. Tap [Preferences]>[Standby Heater Temperature].
3. Tap  or  next to [Print Heater] or [Dryer] to set the temperature.

   When this is set to  (off), each setting is switched off during standby.
4. Tap [Save] to confirm your entry.
5. Tap  to go back to the original screen.

MEMO

- Default settings
  [**Print Heater**]: 25°C (77°F)
  [**Dryer**]: 60°C (140°F)

Optimizing Work Efficiency

Managing the Media Settings 131
- Changing the Media Settings 131
- Checking the Registered Media Settings 132
- Changing the Media Name 133
- Duplicating Media Settings 134
- Deleting Media Settings 135

Adjusting the Output-start Location 136
- Setting the Base Point 136

Reducing Output Time 138
- Speeding Up Output for Narrow Media 138

Other Useful Functions 139
- Using the Print Light (Interior Light) 139
- Performing Printing Tests Arranged Horizontally 140

Managing the Media Settings

When you set up media, register the settings that are appropriate for the media with any name. You can delete registered media or check the settings on a list here. You can also duplicate registered media and register it as new media.

Changing the Media Settings

Use the following procedure to change the media settings. These settings can only be changed for the media being set up.

Procedure

1. **Load the media.**
2. **Tap**  **.**
3. **Tap [Media Settings]>[List of Media Settings].**
4. **Tap the setting to change to move to the screen for editing this setting.**

   The media settings that can be changed are as follows.

Menu item	Reference page
[Print Head Height]	P. 119 Changing the Print Head Height
[Feed Correction]	P. 115 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)
[Media Gap Adjustment]	P. 117 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)
[Heater Temperature]	P. 127 Setting the Print Heater Temperature P. 128 Setting the Dryer Temperature
[Pullback After Printing]	P. 123 Using Heat-resistant Media with Minimal Waste
[Multi Sensor Adjustment]	Adjusts the sensor used to make corrections to the optimal condition.
[Media Suction Force]	P. 121 Using Media That Wrinkles Easily/ Does Not Move Smoothly
[Printing Movement Range]	P. 138 Speeding Up Output for Narrow Media
[Media Sticking Prevention]	P. 122 Using Sticky Media

5. **If you have changed a setting, tap [Save].**
6. **Tap**  **to go back to the original screen.**

Checking the Registered Media Settings

Procedure

1. Tap .

2. **Tap [Media Management].**
   The registered media settings are displayed in a list.

3. **Tap a media setting.**

4. **Tap [List of Media Settings].**
   The registered media setting values are displayed in a list.

Menu item	Reference page
[Print Head Height]	P. 119 Changing the Print Head Height
[Feed Correction]	P. 115 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)
[Media Gap Adjustment]	P. 117 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)
[Heater Temperature]	P. 127 Setting the Print Heater Temperature P. 128 Setting the Dryer Temperature
[Pullback After Printing]	P. 123 Using Heat-resistant Media with Minimal Waste
[Multi Sensor Adjustment]	Adjusts the sensor used to make corrections to the optimal condition.
[Media Suction Force]	P. 121 Using Media That Wrinkles Easily/ Does Not Move Smoothly
[Printing Movement Range]	P. 138 Speeding Up Output for Narrow Media
[Media Sticking Prevention]	P. 122 Using Sticky Media

5. **Tap  to go back to the original screen.**

Changing the Media Name

Procedure

1. Tap .
2. **Tap [Media Management].**
   The registered media settings are displayed in a list.
3. **Tap the media whose name you want to change.**
4. Tap .
5. **Tap the input field and enter the media name.**
   You can use up to 15 alphanumeric characters.
6. **Tap [OK] to confirm your entry.**
7. Tap  **to go back to the original screen.**

Duplicating Media Settings

Use the following procedure to duplicate existing media settings.

Procedure

1. Tap .
2. **Tap [Media Management].**
   The registered media settings are displayed in a list.
3. **Tap the media setting to duplicate.**
4. **Tap [Duplicate Media].**
   A screen for entering the name of the duplicated media appears. To create this name, [**COPY**] is added at the start of the name of the media being duplicated.
5. **Enter the media name and tap [OK].**
6. **Tap  to go back to the original screen.**

Deleting Media Settings

Use the following procedure to delete existing media settings.

MEMO

This operation cannot be performed on the media being set up. To perform this operation, first cancel media setup.

Procedure

1. Tap .
2. **Tap [Media Management].**
   The registered media settings are displayed in a list.
3. **Tap the media to be deleted.**
4. **Tap [Delete Media].**
5. **Tap [Yes] when the confirmation screen appears.**
   The media settings are deleted, and you are returned to the screen listing the registered media settings.
6. **Tap  to go back to the original screen.**

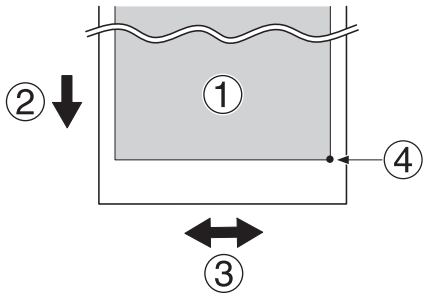
Adjusting the Output-start Location

Setting the Base Point

Set the base point in order to determine the area on the loaded media in which to print (the output area).

The base point (④) indicates the right edge of the output area (①). (②: Media feed direction, ③: print-head carriage movement direction) You can print without setting the base point, but setting the output area enables you to use media without being wasteful and also to print on the targeted location.

Set the base point for each individual page. When the printing of one page finishes, the base point returns to its default value.



IMPORTANT

When the media is set up, the dryer temperature rises to the standby temperature (Setting the Temperature during Standby(P. 129)). For some media, parts exposed to the dryer in the process of setting the base point may suffer damage such as deformation or deterioration, which may result in poor printing quality, so leave these parts in the margin and do not print on them. In the unlikely event that you use that area, check that the media is not wrinkled or deformed before printing, and that the print quality is not degraded after printing.

MEMO

- Note that the left and right positions are not restored to their defaults for test patterns.

Procedure

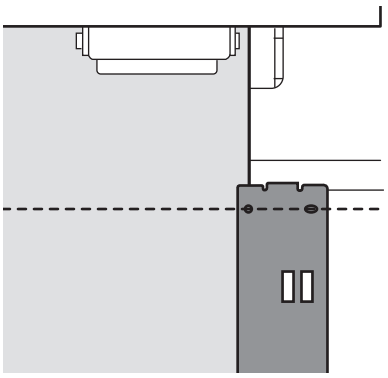
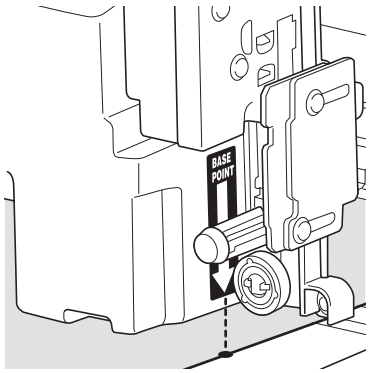
1. **Tap** .

2. **Tap**  **[Move].**

   The movement screen appears.

3. **Set the base point as follows.**

Printing-start position in feed direction (forward-backward)	Printing-start position in scan direction (left-right)
Move the media using  or  to adjust the feed direction. The media clamp holes are the starting position in the feed direction.	Move the sub carriage using  or  to adjust the scan direction. The base point mark on the right side is the start position in the scan direction.

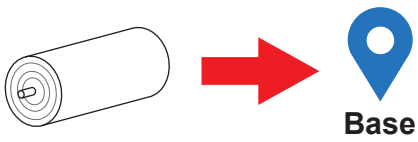
Printing-start position in feed direction (forward-backward)	Printing-start position in scan direction (left-right)
	

4. **Once the position has been decided, tap [Set Base Point Here] to confirm it.**

The base point position is updated, and you are returned to the home screen.

MEMO

The display of the icon on the home screen changes to indicate that the base point position has been updated.



Reducing Output Time

Speeding Up Output for Narrow Media

This shortens output time by reducing the width of head movement to the minimum necessary. This is effective when the width of the media or the output data is narrow, but in general set to [**Full Width**] because the ink may not dry.

Procedure

1. **Load the media.**
2. **Tap**  **.**
3. **Tap [Media Settings]>[Other Media Settings]>[Printing Movement Range].**
4. **Specify the range of print head movement during printing.**

[**Output Data Width**]	Matches the range of print head movement to the output data. Movement is limited to the minimum amount necessary, and this can be expected to yield the fastest output. Note, however, that because the speed of media movement is no longer constant, colors may be uneven.
[**Media Width**]	Matches the range of print head movement to the width of the media.
[**Full Width**]	The print heads move from one end of the machine to the other. Makes the speed of media movement constant at all times and produces the most stable printing result.

IMPORTANT

If [**Output Data Width**] or [**Media Width**] is selected, there may not be sufficient drying time in the dryer and the ink may not dry.

5. **Tap [Save] to confirm your entry.**
6. **Tap**  **to go back to the original screen.**

MEMO

- Default setting: [**Full Width**]

Other Useful Functions

Using the Print Light (Interior Light)

You can select the status of the light that shines on the platen.

Procedure

1. Tap .
2. Tap [Preferences]>[Print Light].
3. Select the status of the print light.

[Auto]	The light is turned on/off automatically according to the status of the printer.
[On]	The light is on at all times.
[Off]	The light is off at all times.

4. Tap [Save] to confirm your entry.
5. Tap  to go back to the original screen.

MEMO

- Default setting: [Auto]

Performing Printing Tests Arranged Horizontally

When performing printing tests successively, you can select [**Feed**] (vertical printing) or [**Scan**] (horizontal printing) as the print position for the second and later tests in comparison to the first test.

IMPORTANT

This setting is disabled because media is fed to the dryer if [**Execute**] is selected for [**Printing Test (Drying Enabled)**].

Procedure

1. Tap .
2. Tap [Preferences]>[Printing Test Position].
3. Select [Scan].
4. Tap [Save] to confirm your entry.
5. Tap  to go back to the original screen.

MEMO

Default setting: [**Feed**]

Optimizing Operation Management

Managing the Operations Appropriately and Efficiently 142
Setting the Current Date/Time and Using It for Maintenance 142
Checking the Remaining Media 143
Showing/Hiding Notifications 145
Setting the Activation Interval for Sleep Mode (Power-saving Feature) 146
Managing the Basic Settings of the Printer 147
Changing the Display Language 147
Changing the Units of Measurement 148
Viewing Printer Information 149
Viewing Network Information 150
Adjusting the Brightness of the Operation Panel 151
Turning Off Operation Panel Sounds 152
Returning All Settings to Factory Defaults 153

Managing the Operations Appropriately and Efficiently

Setting the Current Date/Time and Using It for Maintenance

Use the following procedure to set the current date and time. By setting this, when you perform a printing test the printing test date and time will be printed alongside the printed test pattern. Notifications prompting you to perform maintenance will also be displayed at appropriate times.

Procedure

1. Tap .
2. Tap [System Information]>[Date/Time].
3. Tap  or  to set the date and time.
4. Tap [Save] to confirm your entry.
5. Tap  to go back to the original screen.

Checking the Remaining Media

You can display how much of the media in use is left. By setting the amount of media currently remaining at the start, the amount remaining will be constantly displayed on the screen until it reaches zero.

Because the amount of media remaining is not updated automatically when you change the media, redo the setting whenever you change the media.

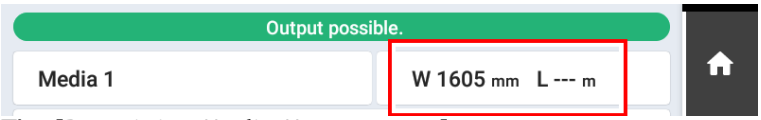
MEMO

The remaining amount that is displayed is only an estimate. Accuracy is not assured.

Procedure

1. **Load the media.**

2. **Tap the following location on the home screen.**



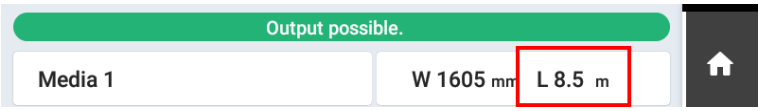
The [**Remaining Media Management**] screen appears.

3. **Tap**  **or**  **to enter the length of the remaining media.**

4. **Tap [Save] to confirm your entry.**

5. **Tap**  **to go back to the original screen.**

The remaining media is displayed.



Printing the Amount of Remaining Media

Print the amount of remaining media, which is displayed on the home screen.

Use this when you want to make a record of the remaining length of the media currently in use. Printing the amount of media remaining before you change the media enables you to refer to the printed record and use the value to make the setting for the remaining amount the next time you use the media.

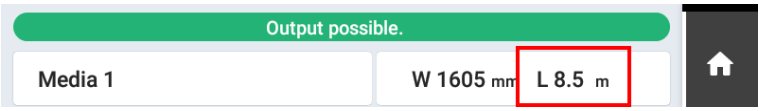
Note, however, that if you continue printing of the test pattern, the printing operation will start on top of the portion where the amount of remaining media is printed. If you want to perform a printing test, separate the media before starting the printing operation.

Procedure

1. **Check that the amount of remaining media is displayed on the home screen.**

   If it is not, set the amount of remaining media by referring to Checking the Remaining Media(P. 143).

2. **Tap the following location on the home screen.**

   The [**Remaining Media Management**] screen appears.

3. **Tap [Printing Remaining Media Amount]>[Execute].**

   The amount of remaining media is printed.

Showing/Hiding Notifications

Use the following procedure to show/hide the following notifications, which prompt operators to perform proper operations.

Procedure

1. Tap .
2. Tap [Preferences]>[Notifications On/Off].
3. Tap  to show/hide the notifications.

	Displayed notification	Description
[Ink Expiration Date Notification]	[The expiration date has passed. Replace the expired product.]	Advises the user to replace expired ink pouches. When enabled, this message appears when the ink has expired.
[Media Clamp Placement Notification]	[Install the media clamps correctly.]	Prompts you to correctly place the media clamps to prevent the media from coming loose. When enabled, this message appears when the media clamps are not placed at the edges of the media.
	[Media clamps could not be detected.]	This message appears when the media clamps cannot be detected because they are hidden by the media or are dirty with, for example, ink.

4. Tap [Save] to confirm your entry.
5. Tap  to go back to the original screen.

IMPORTANT

- Default settings
  - [Ink Expiration Date Notification]:[On]
  - [Media Clamp Placement Notification]:[On]

Setting the Activation Interval for Sleep Mode (Power-saving Feature)

This setting is used to set how long it should take until the machine goes into sleep mode (the state in which the power-saving feature is working) when no output data is received and no operations are performed for a continued length of time.

Procedure

1. Tap .
2. Tap [Preferences]>[Sleep Time].
3. Tap  or  to set the time.
4. Tap [Save] to confirm your entry.
5. Tap  to go back to the original screen.

MEMO

- Default setting: [**30 min.**]

Managing the Basic Settings of the Printer

Changing the Display Language

This feature sets the language displayed on the display screen of the operation panel.

Procedure

1. Tap .
2. Tap [System Information]>[Language].
3. Tap [Language].
4. Select the display language.
5. Tap [OK].
6. Tap [Save] to confirm your entry.
   The display language is changed, and you are returned to the home screen.

MEMO

Default settings

- [Language]: ENGLISH

Changing the Units of Measurement

Use the following procedure to set the units of measurement displayed on the display screen of the operation panel.

Procedure

1. Tap .
2. Tap [System Information]>[Units].
3. Tap [Length].
4. Select the unit.
5. Tap [Save] to confirm your entry.
6. Tap [Temperature].
7. Select the unit.
8. Tap [Save] to confirm your entry.
9. Tap  to go back to the original screen.

MEMO

- Default settings
  - [**Length**]: mm
  - [**Temperature**]: ˚C

Viewing Printer Information

This is a method for viewing information of this machine, such as serial number and ink type.

Procedure

1. **Tap** .

2. **Tap [System Information]>[Machine Information].**
   You can check the following information:
   - [**Model**]: Model name
   - [**Serial Number**]: Serial number
   - [**Ink Type**]: Ink type
   - [**Firmware Version**]
   - [**MAC Address**]

3. **Tap**  **to go back to the original screen.**

Viewing Network Information

Use the following procedure to view network information such as the IP address and default gateway.

Procedure

1. Tap .

2. **Tap [System Information]>[Network].**
   You can check the following information:
   - **[Obtain IP Address Automatically]**: Enables/disables the automatic obtaining of IP addresses via DHCP. When this is disabled, tap  to change the following settings.
   - **[IP Address]**
   - **[Subnet Mask]**
   - **[Default Gateway]**

3. **Tap  to go back to the original screen.**

MEMO

- For information on how to set up a network, see the "Setup Guide."

RELATED LINKS

- AP-640 Setup Guide

Adjusting the Brightness of the Operation Panel

Procedure

1. Tap .
2. Tap [System Information]>[Screen Brightness].
3. Tap  or  to adjust the brightness.

   The larger the value, the brighter the screen.
4. Tap [Save] to confirm your entry.
5. Tap  to go back to the original screen.

MEMO

- Default setting: [50%RH]

Turning Off Operation Panel Sounds

Use the following procedure to turn off the sound when you tap the operation panel.

Procedure

1. Tap .
2. Tap [System Information]>[Screen Operation Sound].
3. Tap [Off].
   The operation sound turns off.
4. Tap [Save] to confirm your entry.
5. Tap  to go back to the original screen.

MEMO

- Default setting: [On]

Returning All Settings to Factory Defaults

This menu returns all settings to the same as their factory defaults.
The settings for [**Language**] and [**Units**] are not returned to their factory default values.

Procedure

1. Tap .
2. Tap [Preferences]>[Reset to Factory Defaults].
3. Tap [Reset].
4. Tap [Yes] on the confirmation screen.
5. Tap  to go back to the original screen.

Maintenance

Introduction

Important Notes on Handling and Use 156
Printer 156
Ink Pouches 157
Basic Maintenance Knowledge 158
Types and Timing of Maintenance 158
Measures When the Printer Is Not in Use for a Prolonged Period 159

Important Notes on Handling and Use

Printer

- This machine is a precision device.
  - Never subject the machine to impacts or excessive force.
  - Never needlessly put your hand or fingers inside the cover, the ink-pouch ports, or other internal areas of the machine.
- Install the machine in a suitable location.
  - Install the machine in a location having the specified temperature and relative humidity.
  - Install the machine in a quiet, stable location offering good operating conditions.
- Leave the printer's main power switched on 24 hours a day.
  - Automatic maintenance may be performed even during standby. Never switch off the main power.
- The print heads are delicate.
  - Never needlessly touch or allow media to scrape them.
  - The print heads may be damaged if allowed to dry out. The machine prevents desiccation automatically, but improper operation may render this feature inoperative. Operate properly, as specified in this manual.
  - Never leave the machine with an ink pouch removed. Remaining ink in the printer may harden and clog the print heads.
  - Depending on the situation, the print heads require various types of cleaning. Read this manual thoroughly and perform the appropriate maintenance at the appropriate times.
  - The print heads are components that wear out. Periodic replacement is required, with the frequency of replacement depending on use.
- This machine becomes hot.
  - Never cover the ventilation holes with cloth, tape, or anything else.
  - If the machine is used for a long time, the temperature in the room will also become hot. In order to maintain the specified temperature, use ventilation or air conditioning to avoid overheating the room.

Ink Pouches

- Ink pouches come in various types.
  - Use a type that is compatible with the printer.
- Never subject the ink pouches to impacts or attempt to disassemble them.
  - Never drop the ink pouches or shake them forcefully. The impact may rupture the internal pouches and cause the ink to leak.
  - Never attempt to disassemble.
  - Never attempt to refill the ink.
  - If ink gets on your hands or clothing, wash it off as soon as possible. Removal may become difficult if allowed to stand.
- Storage
  - Store ink pouches unopened in a well-ventilated location at a temperature of 5 to 30°C (41 to 86°F) and avoid direct sunlight. However, do not store the ink cartridges for a prolonged period of time in low or high temperature environments.
  - Use ink pouches before their expiration dates.
- Other handling
  - Always insert the pouch tray into the ink slot with the ink pouch set. Leaving the ink slot empty may cause printer malfunctions, such as the ink adhered to the needle inside dries out and causes clogging.

Basic Maintenance Knowledge

Types and Timing of Maintenance

To use this machine under its optimal conditions, it is important to perform the appropriate maintenance at the appropriate times.

Regular Maintenance

These are the maintenance items that are required on a daily basis.

Timing	Category	Item
Before daily operations	Print head check	P. 108 Step 1: Performing a Nozzle Drop-out Test
After daily operations	Cleaning the Machine	P. 162 Cleaning the Media Path
		P. 163 Cleaning the Knife Carriage Roller
If a message appears	Cleaning around the print heads	P. 164 Cleaning around the Print Heads
If the discharged fluid disposal message appears	Disposing of discharged fluid	P. 176 If the Discharged Fluid Disposal Message Appears

Advanced Maintenance

Maintenance that is performed in an emergency. Some of this maintenance consumes a large amount of ink, so thoroughly read the explanation, and then perform the operation at the appropriate point in time.

Timing	Category	Item
When dot drop-out or dot displacement occurs	Checking and cleaning the print heads	P. 108 Performing a Nozzle Drop-out Test
		P. 109 Performing Normal Cleaning
		P. 181 Medium Cleaning Method
		P. 183 Powerful Cleaning Method
		P. 185 Cleaning the Wiper Tray
		P. 164 Cleaning around the Print Heads
When the above operations are not effective	Cleaning of the print heads*1	P. 186 Ink Renewal Inside Heads Method
When the operation panel is dirty	Cleaning the operation panel	P. 191 Operation Panel Cleaning Method

*1 This cleaning consumes a large amount of ink.

Replacing Consumable Parts

Thoroughly read the explanation, and then perform the operation at the appropriate point in time.

Timing	Category	Item
When a replacement message appears	Replacing consumable parts for maintenance • Wiper • Flushing pad	P. 193 Replacing the Wipers
		P. 196 Flushing Pad Replacement
When a cutting edge becomes dull	Replacing consumable parts	P. 201 Replacing the Separating Knife

Measures When the Printer Is Not in Use for a Prolonged Period

Be sure to follow the instructions shown below when the printer is not in use for a prolonged period.

IMPORTANT

- Never switch off the main power. Doing so may damage the printer.
- If you are unable to maintain power, contact your authorized dealer in advance.
- Switch off the dryer power.

- **Empty the drain bottle in advance.**

  If you know that you will not use the machine for a prolonged period, empty the drain bottle. When the main power is on, the machine periodically performs automatic maintenance in which fluid is discharged. Check once a month if the discharged fluid is full.

- **Do not allow the machine to run out of ink or cleaning liquid.**

  The machine discharges ink and cleaning liquid during the automatic maintenance that is performed periodically. Set in the machine ink pouches having sufficient remaining ink and refill the cleaning liquid to the "Full" line once a month. The machine cannot perform automatic maintenance if it has run out of ink or cleaning liquid.

- **Keep the machine at a constant temperature and relative humidity.**

  Even when the machine is not in use, keep it at a temperature of 5 to 40°C (41 to 104°F) and a relative humidity of 20 to 80% (with no condensation). Temperatures that are too high may degrade the ink and cause malfunctions. Temperatures that are too low may cause the ink to freeze and damage the print heads.

- **Switch on the sub power once a month.**

  Switch on the sub power once a month. When you turn on the power, the machine automatically performs operations such as those to keep the print heads from drying out. Leaving the machine unused for a prolonged period may damage the print heads, so be sure to switch on the power to perform these automatic operations.

- **Check the nozzle periodically.**

  Perform a printing test and clean the print heads if there are discharge issues. When the cleaning is complete, perform a printing test again to make sure the print heads are working properly.

- **Clean the area around the print heads periodically.**

  Clean the print head caps and the area around them, as well as the nozzle guards.

RELATED LINKS

- P. 174 Disposing of Discharged Fluid
- P. 97 Ink Pouch Replacement
- P. 104 Cleaning Liquid Replenishment Method
- P. 108 Performing a Nozzle Drop-out Test
- P. 164 Cleaning around the Print Heads

Regular Maintenance

Print Head Check before Printing 161
Performing a Nozzle Drop-out Test 161
Cleaning the Machine 162
Cleaning the Media Path 162
Cleaning the Knife Carriage Roller 163
Cleaning around the Print Heads 164
Cleaning the Print Head Caps and Flushing Frames 166
Cleaning the Nozzle Guards 171

Print Head Check before Printing

Performing a Nozzle Drop-out Test

Before you carry out actual printing, perform a printing test to ensure no dot drop-out or dot displacement occurs. If dot drop-out or dot displacement occurs, perform cleaning of the print heads (normal cleaning).

MEMO

When performing printing tests successively, you can select [**Feed**] (vertical printing) or [**Scan**] (horizontal printing) as the printing position for the second and later tests in comparison to the first test.

P. 140 Performing Printing Tests Arranged Horizontally

Procedure

1. **Load the media.**

   P. 26 Setup of New Media

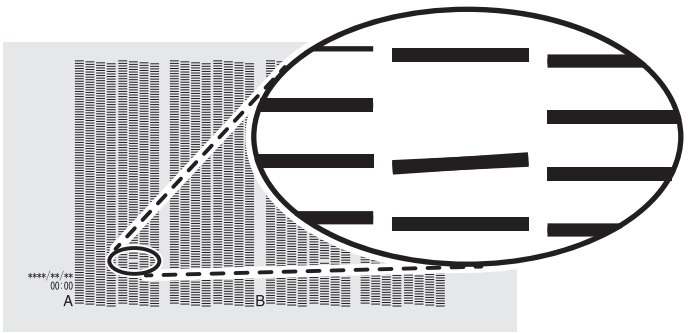
2. **Tap**  **[Nozzle Drop-out Test] on the home screen.**

3. **Tap [Execute] next to [Printing Test].**

   Printing of the test pattern starts.

4. **Check whether there is dot drop-out or dot displacement in the test pattern.**

   Missing blocks indicate dot drop-out. Collapsed or inclined blocks indicate dot displacement.

   IMPORTANT

   Depending on the media, locations on which optimizer ink is printed may be difficult to check. If it is difficult to see the optimizer ink, switch to a different media and perform the printing test again.

5. **If you have opened the front cover, close it.**

   If no dot drop-out or dot displacement occurs, this operation is finished. Press  to go back to the original screen.

RELATED LINKS

- P. 179 When Dot Drop-out or Dot Displacement Occurs

Cleaning the Machine

Cleaning the Media Path

Wipe away any ink or grime on the media path and other areas as part of the daily cleaning procedure. It is easy for ink or grime to affix to the media path, and, if left unattended, this will contaminate new media and have a negative effect on the transport of media when it is output. Pinch rollers, grit rollers, and the platen are particularly prone to the buildup of grime.

⚠ WARNING

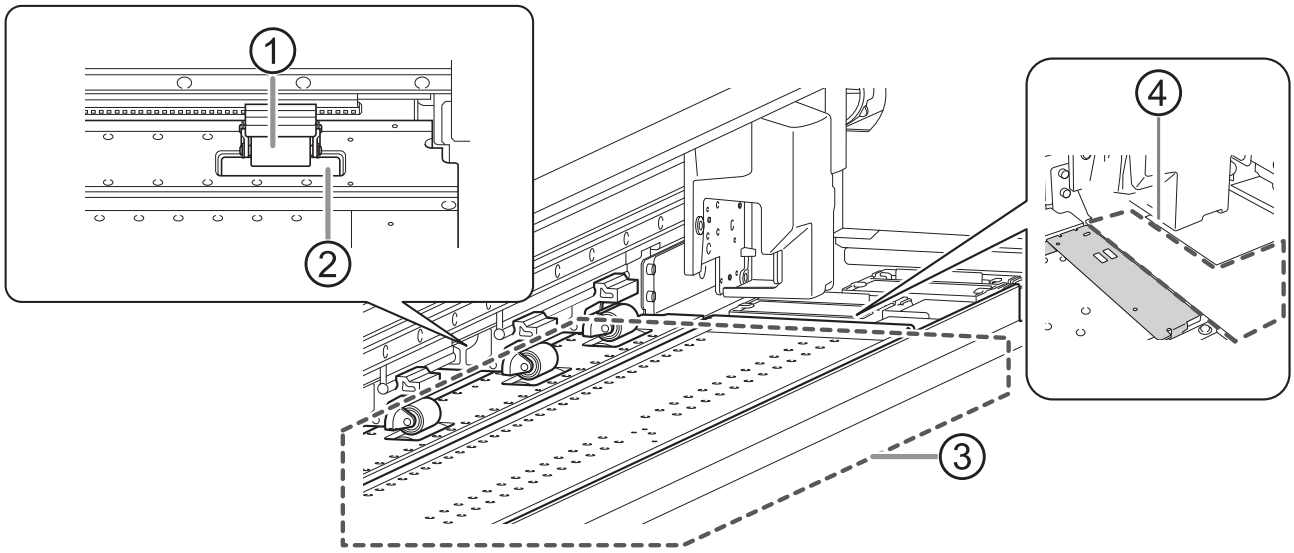
Never use a solvent such as gasoline, alcohol, or thinner to perform cleaning.
Doing so may cause a fire.

⚠ CAUTION

Before attempting cleaning, switch off the sub power and wait until the platen and dryer cool (approximately 30 minutes).
Sudden movement of the machine may cause injury, or hot components may cause burns.

IMPORTANT

- This machine is a precision device and is sensitive to dust and dirt. Perform cleaning on a daily basis.
- Never attempt to oil or lubricate the machine.



Clean by wiping with a cloth moistened by neutral detergent diluted with water then wrung dry.

①	Pinch roller	These are the positions where the media is fixed in place or transported, so it is easy for ink and grime to affix to these positions. Failure to clean this part properly may result in the transfer of grime to the surface of media.
②	Grit roller	These are the positions where the media is fixed in place or transported, so it is easy for grime to affix to these positions. Remove buildup of media scraps and other material using a brush. Never use a metal brush.
③	Platen	Wipe away any buildup of ink, grime, or cut media on the media path and in the grooves.
④	Near the wiper tray	Wipe away any cut media that sprays onto the area around the wiper tray during media cutting.

Cleaning the Knife Carriage Roller

Paper dust affixes to the separating knife carriage roller during media separation. Periodically wipe the area clean.

⚠ WARNING

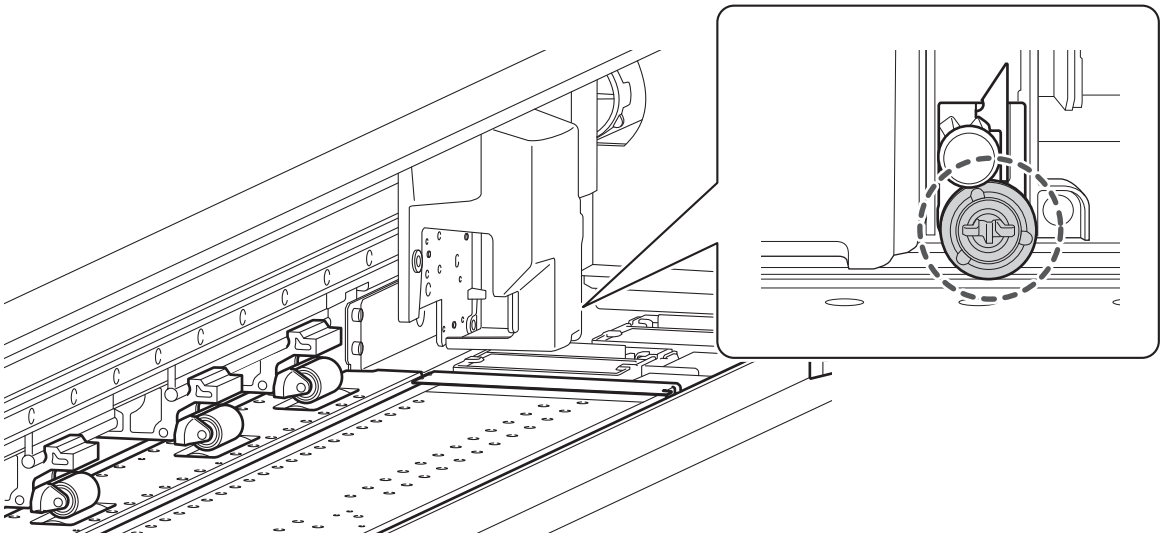
Never use a solvent such as gasoline, alcohol, or thinner to perform cleaning.
Doing so may cause a fire.

⚠ CAUTION

Before attempting cleaning, switch off the sub power and wait until the platen and dryer cool (approximately 30 minutes).
Sudden movement of the machine may cause injury, or hot components may cause burns.

IMPORTANT

- This machine is a precision device and is sensitive to dust and dirt. Perform cleaning on a daily basis.
- Never attempt to oil or lubricate the machine.



Open the right cover and clean by wiping with a cloth moistened by neutral detergent diluted with water then wrung dry.

Cleaning around the Print Heads

The print heads are important components that discharge ink and require periodic and appropriate maintenance. Cleaning around the print heads is known as "manual cleaning."

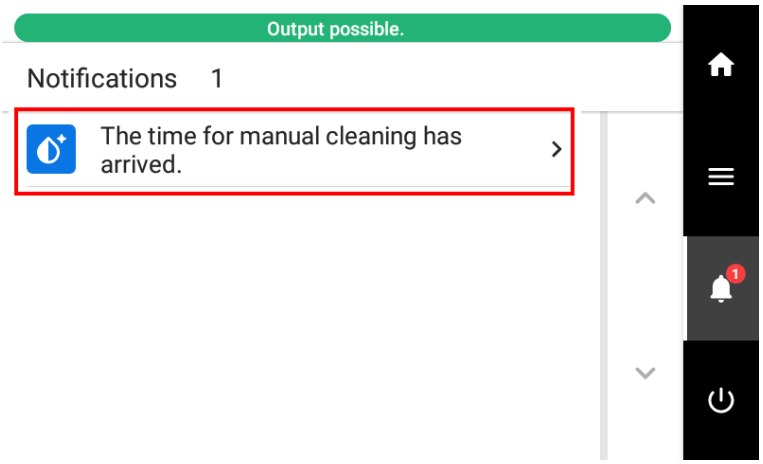
- If you use up the cleaning sticks and cleaning liquid used for this work, contact your authorized dealer or visit our website (https://www.rolanddg.com/).
- The print heads are components that wear out. Periodic replacement is required, with the frequency of replacement depending on use. Contact your authorized dealer.

IMPORTANT

- Be sure to use different cleaning sticks in the color ink section and the optimizer ink section. Using the same cleaning stick may lead to the optimizer ink and color ink mixing, resulting in ink hardening and discharge issues.
- To prevent the print heads from drying out, finish this procedure in 30 minutes or less. After 30 minutes, the alarm will sound, so pause the procedure and perform the following operations.
  - Close all the covers.
  - Tap [**Finish All**] to end manual cleaning.
  - Restart the cleaning procedure from the beginning.

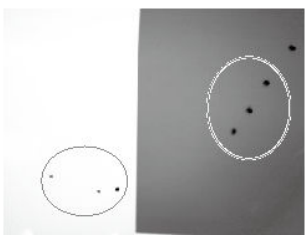
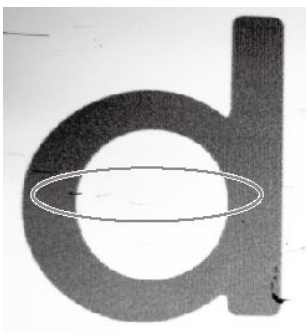
When a Message Appears

When a message appears, you can tap  on the home screen to check the notification details. Tap the notification to display the manual cleaning menu screen.



When symptoms of ink drips or dragging dirt occur

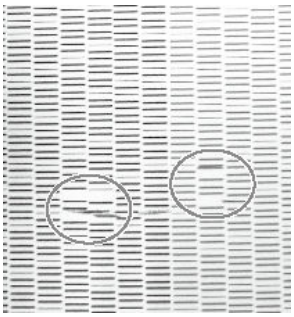
When any of the symptoms given below occur, clean around the print heads.

Ink drips	Dragging dirt
	

Ink pools in dust or dirt adhered to the print heads, and drips onto the media.	The phenomenon where dirt or dust accumulates on the print heads.

When symptoms that cannot be improved with wiper tray cleaning occur

When any of the symptoms given below occur and wiper tray cleaning after performing cleaning functions (normal, medium, or powerful) is not effective, clean around the print heads.

Dot drop-out/Dot displacement

Dust or other foreign matter adheres to the print heads and impedes correct ink discharge.

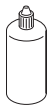
MEMO

Wiper replacement may also be effective in improving these symptoms.

RELATED LINKS

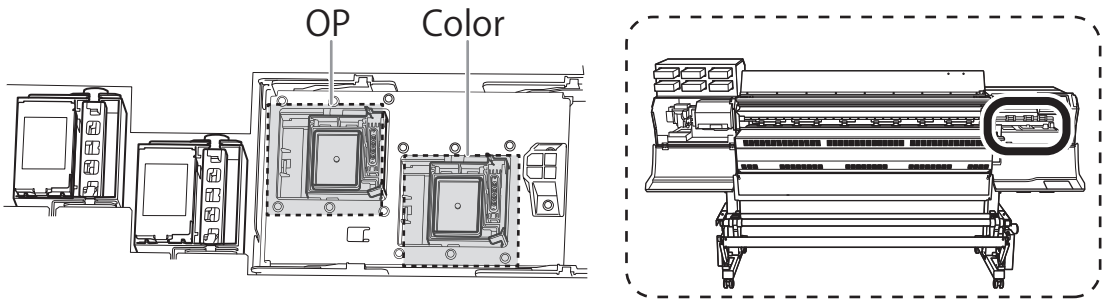
- P. 193 Replacing the Wipers

Cleaning the Print Head Caps and Flushing Frames

Required items	
	
Cleaning stick (2)	Cleaning liquid bottle for maintenance

Locations to clean with this work

- Color: Locations to clean in the color ink section
- OP: Locations to clean in the optimizer ink section



IMPORTANT

- Be sure to use different cleaning sticks in the color ink section and the optimizer ink section. Using the same cleaning stick may lead to the optimizer ink and color ink mixing, resulting in ink hardening and discharge issues.
- Do not touch the tips of the cleaning sticks with your hands. Skin oil affixing to the print head caps may lead to malfunctions.
- Use a clean pair of tweezers to remove clumps of ink.
- Do not use cleaning liquid other than the included cleaning liquid.
- If you add cleaning liquid while cleaning a given location, do not dip the cleaning stick into the cleaning liquid bottle. Instead, drip the cleaning liquid onto the cleaning stick.

Procedure

1. **Remove any media.**
2. **Tap**  **on the operation panel.**
3. **Tap [Cleaning]>[Manual Cleaning].**
4. **Tap [Execute].**

MEMO

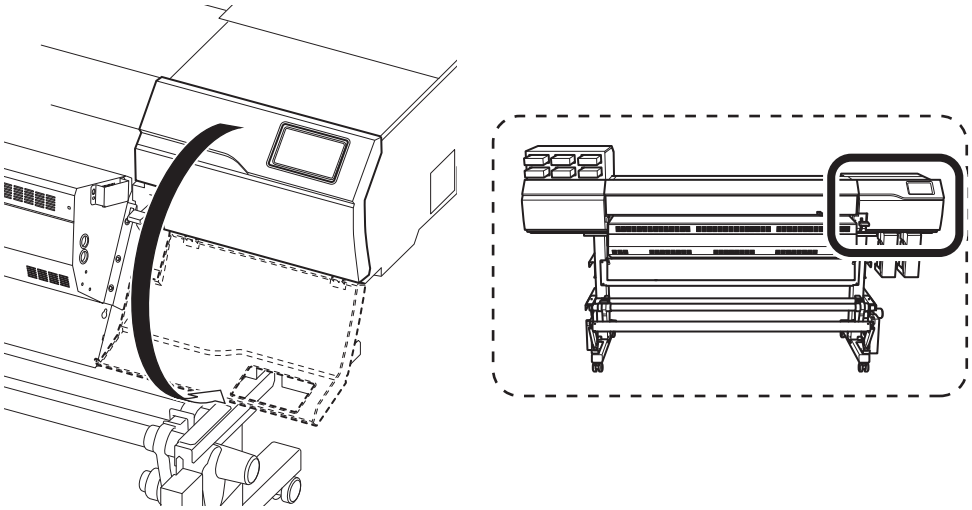
The procedure is displayed on the operation panel.

- Tap  or to check the procedure.
- If you complete the work without viewing the instructions, tap **[Finish All]**.

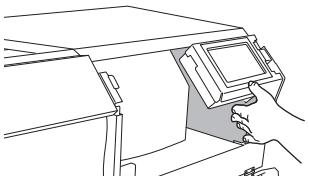
5. **Tap [OK].**

The print heads move to the left end of the machine.

6. **Open the right cover.**



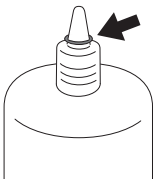
7. **Touch the location shown in the figure to discharge any static electricity.**

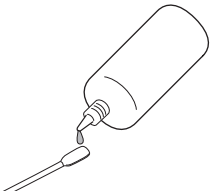


8. **Drip one drop of cleaning liquid onto a cleaning stick.**

IMPORTANT

Open the lid of the cleaning liquid bottle, and then dispose of the ring in the following figure.





9. **Use the cleaning stick to wipe off location A (the tip) shown in the following figure in the color ink section.**

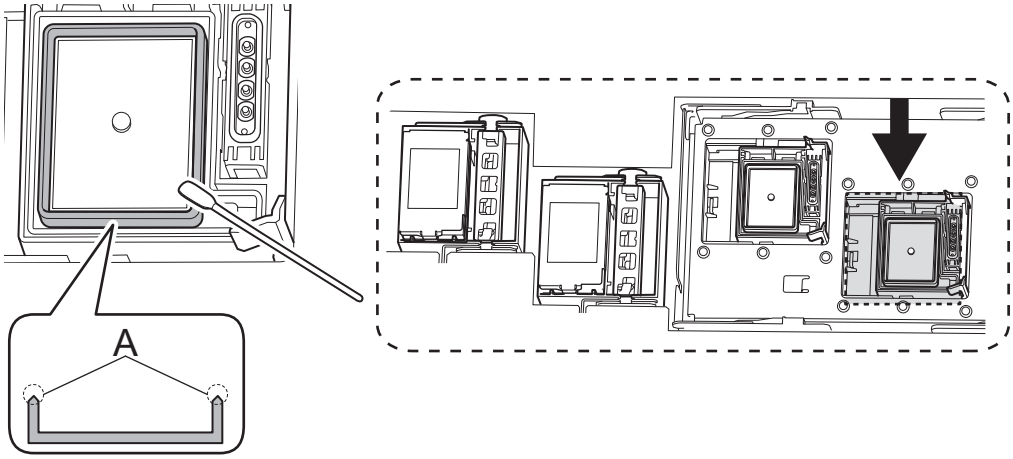
IMPORTANT

- Remove all ink, even ink that has hardened. Remaining ink may cause the print heads to dry out, leading to discharge issues.

- Do not pinch the part indicated by A. Doing so may damage this location, decreasing its airtightness and leading to discharge issues.

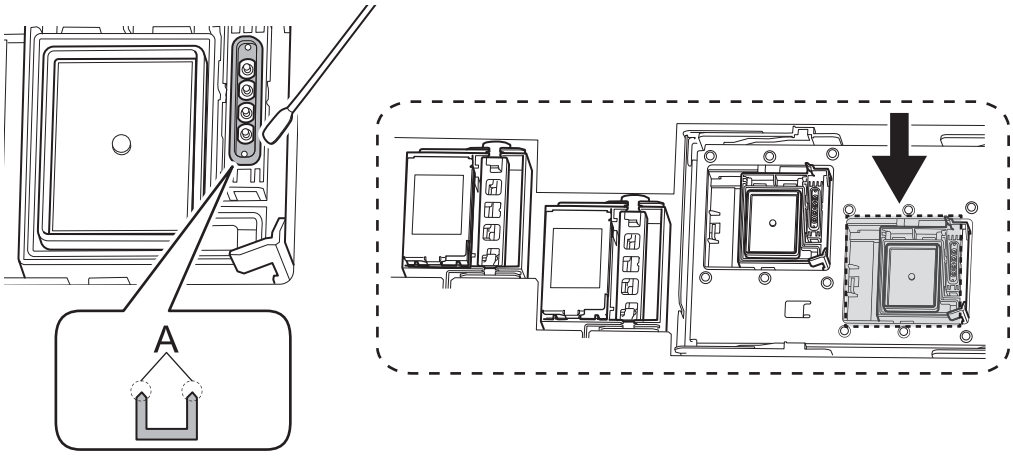
IMPORTANT

If you add cleaning liquid while cleaning, do not dip the cleaning stick into the tip of the cleaning liquid bottle. Instead, drip the cleaning liquid onto the cleaning stick.

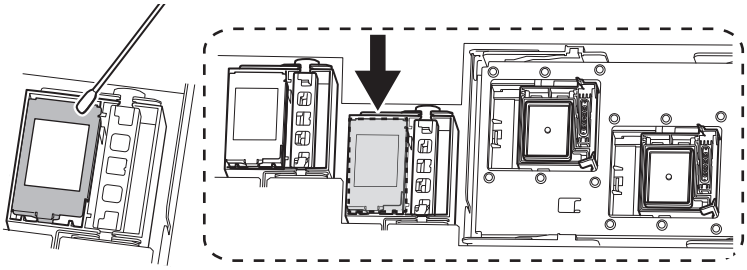


10. **Use the cleaning stick to wipe off location A (the tip) shown in the following figure in the color ink section.**

Cleaning liquid may remain within the caps, but this is not a problem.



11. **Use the same cleaning stick to wipe off the flushing frame in the color ink section.**



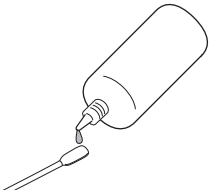
12. **Dispose of the cleaning stick used in the cleaning described above.**

Clean the optimizer ink section with a new cleaning stick.

IMPORTANT

Be sure to clean with a new cleaning stick from this point. Using the same cleaning stick may lead to the optimizer ink and color ink mixing, resulting in ink hardening and discharge issues.

13. **Drip one drop of cleaning liquid onto a cleaning stick.**



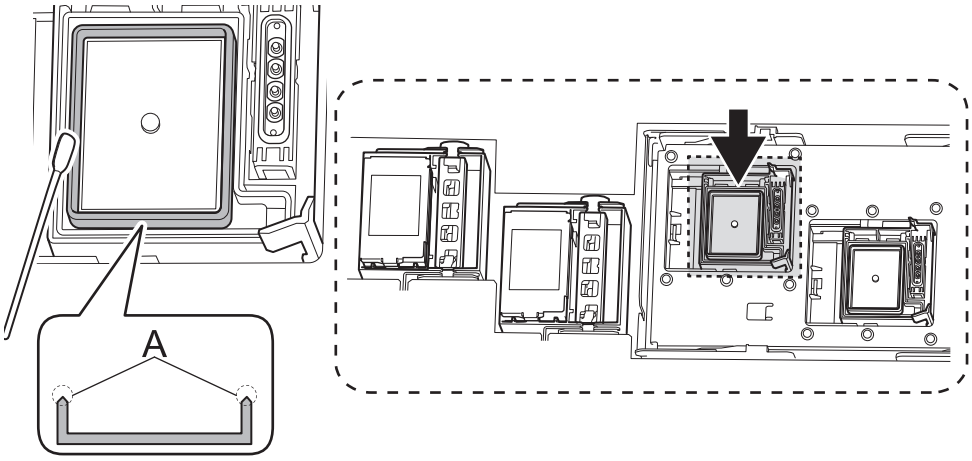
14. **Use the cleaning stick to wipe off location A (the tip) shown in the following figure in the optimizer ink section.**

IMPORTANT

- Remove all ink, even ink that has hardened. Remaining ink may cause the print heads to dry out, leading to discharge issues.
- Do not pinch the part indicated by A. Doing so may damage this location, decreasing its airtightness and leading to discharge issues.

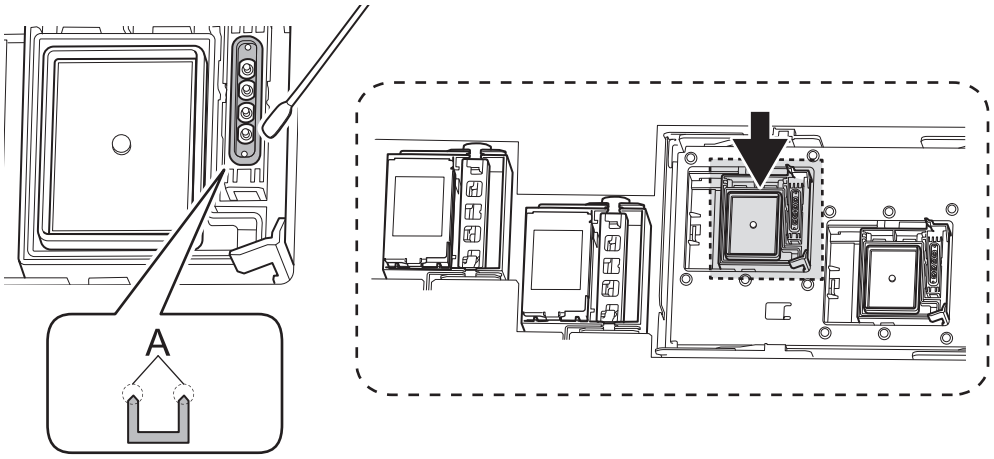
IMPORTANT

If you add cleaning liquid while cleaning, do not dip the cleaning stick into the tip of the cleaning liquid bottle. Instead, drip the cleaning liquid onto the cleaning stick.

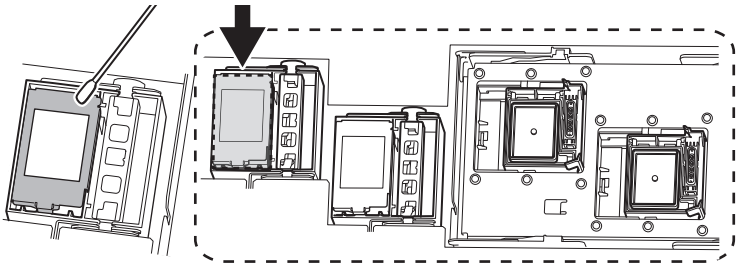


15. **Use the cleaning stick to wipe off location A (the tip) shown in the following figure in the optimizer ink section.**

Cleaning liquid may remain within the caps, but this is not a problem.



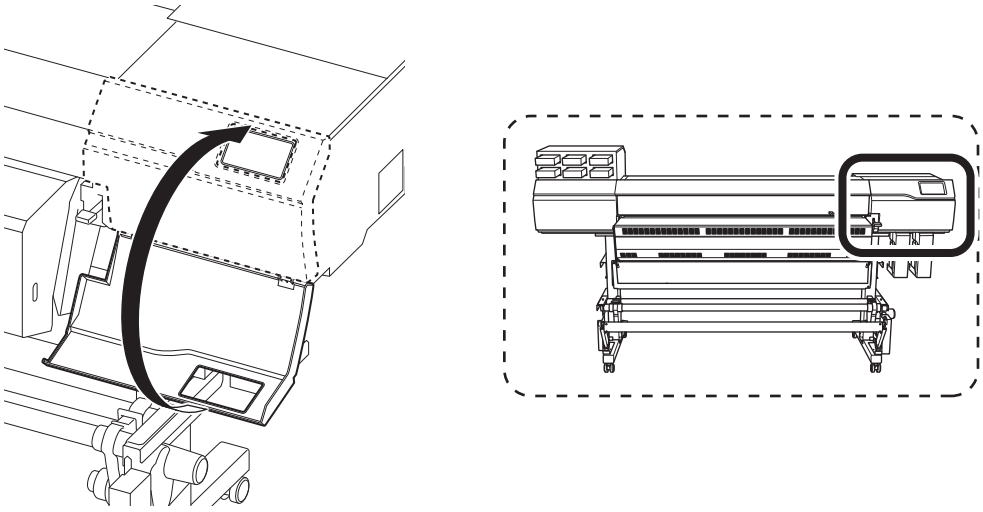
16. **Use the same cleaning stick to wipe off the flushing frame in the optimizer ink section.**



17. **Dispose of the cleaning stick used in the cleaning described above.**

Clean the following location with a new cleaning stick.

18. **Close the right cover.**

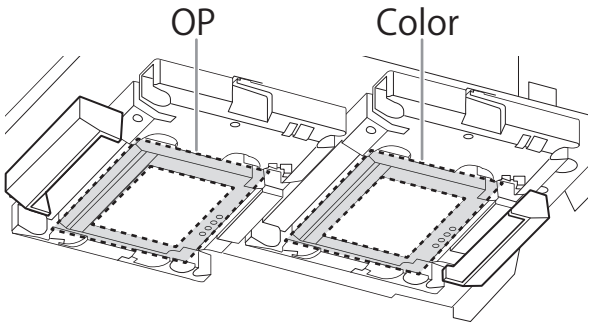


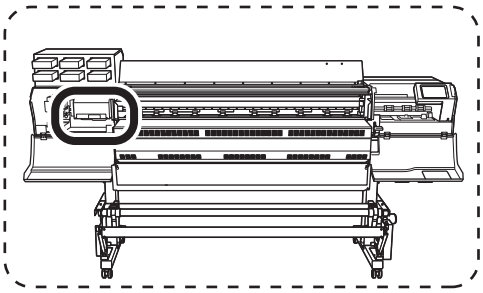
Cleaning the Nozzle Guards

Required items	
	
Cleaning stick (2)	Cleaning liquid bottle for maintenance

Locations to clean with this work

- Color: Locations to clean in the color ink section
- OP: Locations to clean in the optimizer ink section



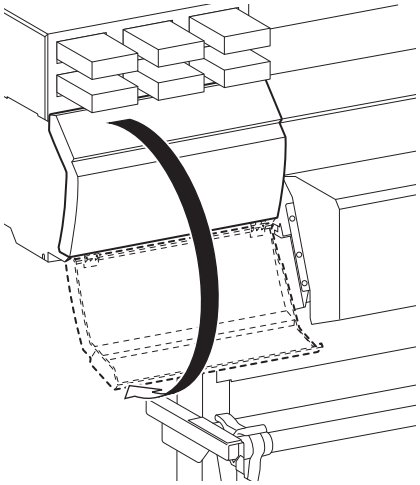


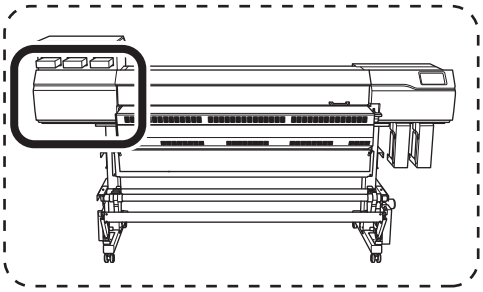
IMPORTANT

- Always use new cleaning sticks.
- Be sure to use different cleaning sticks in the color ink section and the optimizer ink section. Using the same cleaning stick may lead to the optimizer ink and color ink mixing, resulting in ink hardening and discharge issues.
- Do not touch the tips of the cleaning sticks with your hands. Skin oil affixing to the nozzle guards may lead to malfunctions.
- Do not use cleaning liquid other than the included cleaning liquid.

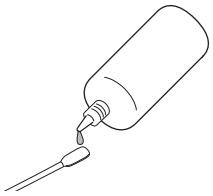
Procedure

1. **Open the left cover.**



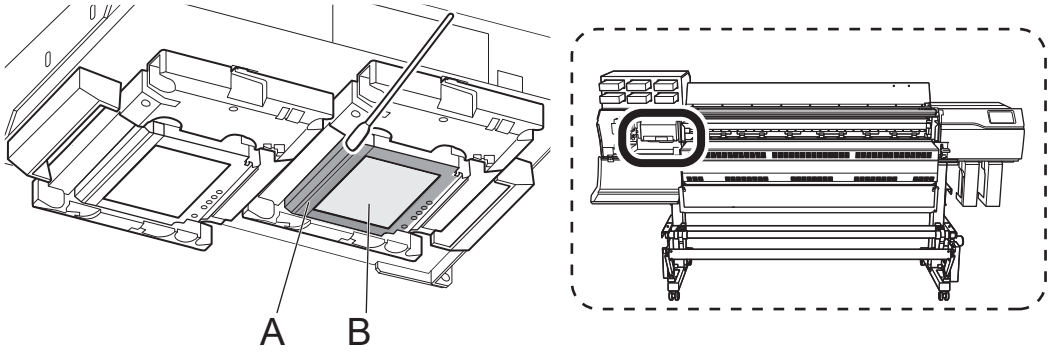


2. **Drip one drop of cleaning liquid onto a cleaning stick.**

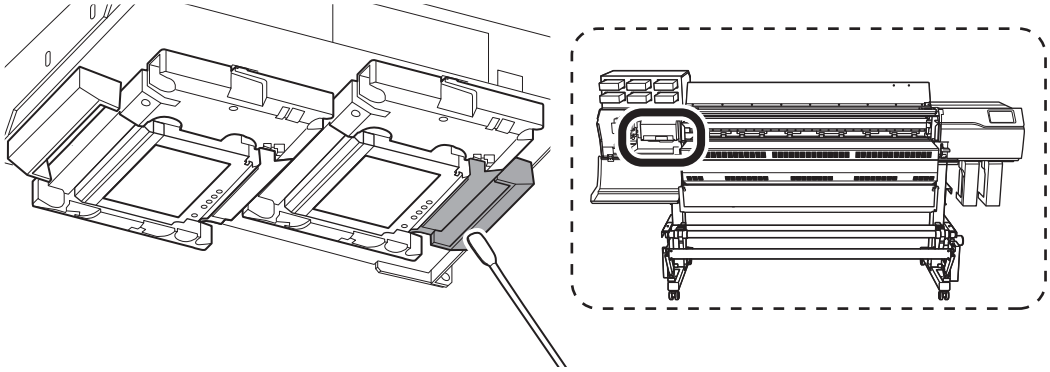


3. **Clean the location (A) in the color ink section shown in the following figure.**

Do not touch location B.



4. **Clean the locations shown in the following figure.**



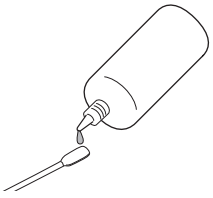
5. **Dispose of the cleaning stick used in the cleaning described above.**

Clean the optimizer ink section with a new cleaning stick.

IMPORTANT

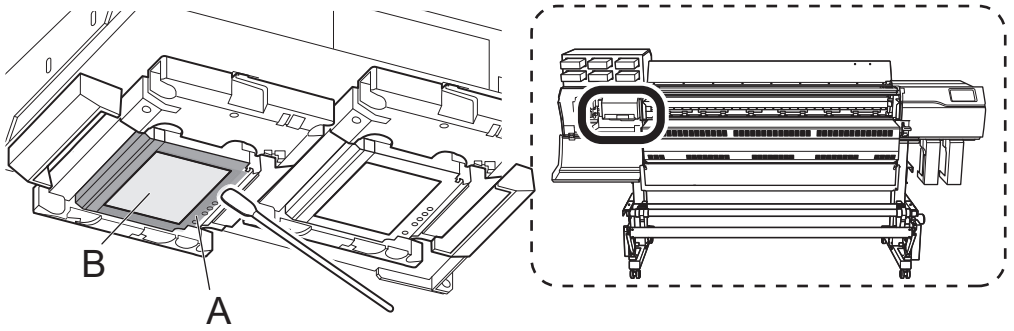
Be sure to clean with a new cleaning stick from this point. Using the same cleaning stick may lead to the optimizer ink and color ink mixing, resulting in ink hardening and discharge issues.

6. **Drip one drop of cleaning liquid onto a cleaning stick.**

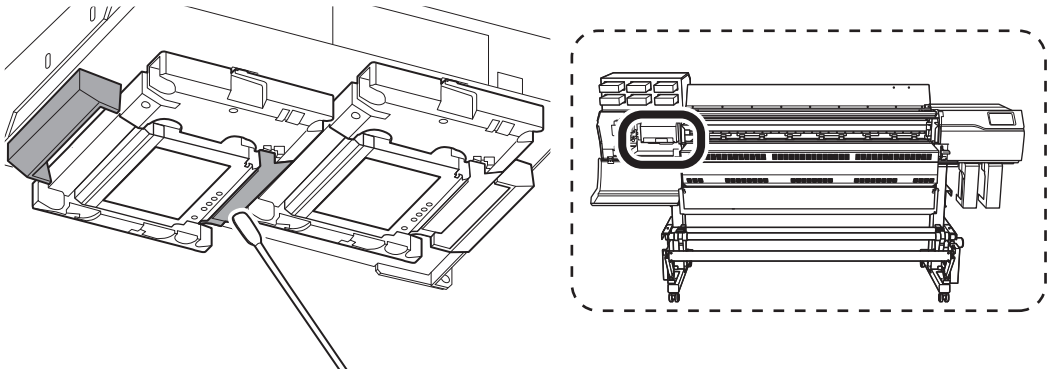


7. **Clean the location (A) in the optimizer ink section shown in the following figure.**

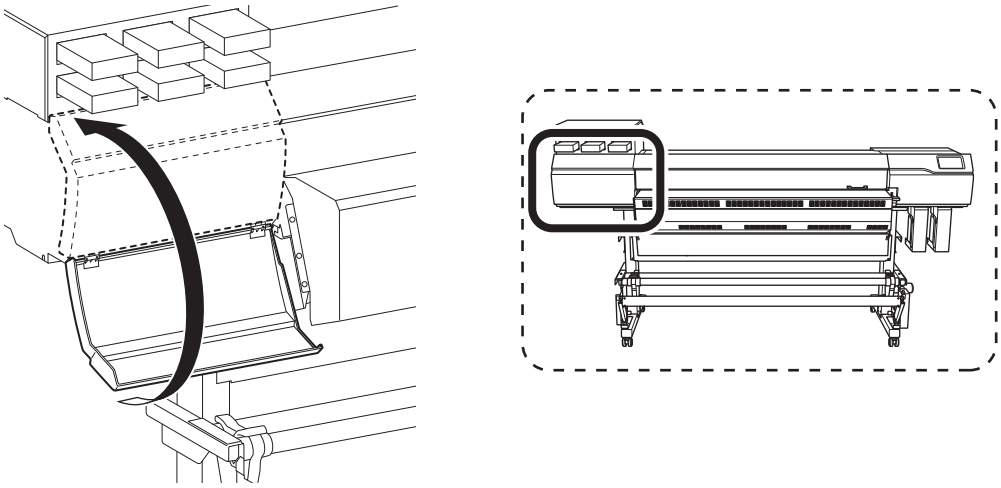
Do not touch location B.



8. **Clean the locations shown in the following figure.**



9. **When you have finished cleaning, close the left cover.**



10. **Tap [Finish All].**

The print heads move to the right side.
[**Maintenance in progress.**] is displayed at the top of the screen, and cleaning starts. The (approximate) remaining time for the procedure is displayed on the screen.

11. **Dispose of the cleaning stick used in the cleaning described above.**

12. **Tap**  **to go back to the original screen.**

Disposing of Discharged Fluid

Precautions for Disposing of Discharged Fluid 175
If the Discharged Fluid Disposal Message Appears..... 176

Precautions for Disposing of Discharged Fluid

IMPORTANT

Do not store discharged fluid in a location where it is exposed to direct sunlight.

When temporarily storing discharged fluid in the included drain bottle, do not store it in a location that is exposed to direct sunlight. The discharged fluid may harden, making the drain bottle unusable. The drain bottle may also deteriorate, leading to discharged fluid leaks.

IMPORTANT

Dispose of discharged fluid properly, in accordance with the laws in effect in your locale.

If the Discharged Fluid Disposal Message Appears

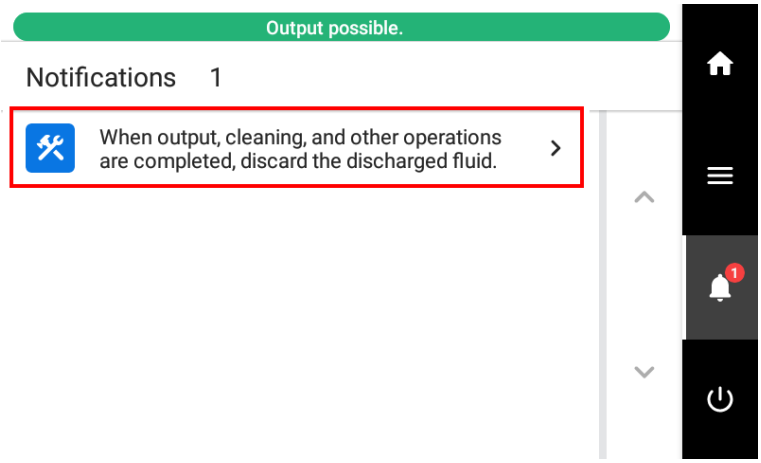
The [**When output, cleaning, and other operations are completed, discard the discharged fluid.**] message appears when a certain amount of discharged fluid has collected in the bottle. If this message appears, dispose of the discharged fluid.

Procedure

1. **When the message [When output, cleaning, and other operations are completed, discard the discharged fluid.] appears, tap [OK].**

2. **Tap**  **to display the notification.**

3. **Tap the following notification.**



The [**Drain Bottle**] screen appears.

MEMO

You can dispose of discharged fluid even if the above message has not appeared.
Use the following operations to display the drain bottle screen, and then dispose of discharged fluid according to the procedure starting from step 4.

1. Tap .
2. Tap [**Maintenance**]>[**Drain Bottle**].

4. **Tap [Execute] on the drain bottle ([Group A (OP)] or [Group B (CMYK)]) that displays** ❗**.**

5. **Tap [OK].**

6. **Remove the drain bottle and discard the discharged fluid.**



⚠ CAUTION

Before you detach the drain bottle, be sure to wait for the screen to display [Discard the discharged fluid in the bottle.]. After discarding the discharged fluid, promptly attach the drain bottle to the machine.

Failing to follow this procedure may cause discharged fluid to flow out of the tube and spill, soiling your hands or the floor.

IMPORTANT

When you remove the drain bottle, a few drops of discharged fluid may come out of the machine. Exercise caution to prevent this fluid from soiling your hands or the floor.

7. **Quickly attach the emptied bottle to the machine once more.**

IMPORTANT

When installing, take care that you do not mix up the drain bottle on the color ink section and the drain bottle on the optimizer ink section by mistake. If you install an incorrect drain bottle and the optimizer ink and color ink are mixed, the discharged fluid will harden.

8. **Tap [Finish].**

9. **Tap  to go back to the original screen.**

Advanced Maintenance

When Dot Drop-out or Dot Displacement Occurs 179
Performing Normal Cleaning..... 179
When Normal Cleaning Is Not Effective 181
Medium Cleaning Method 181
Powerful Cleaning Method 183
Cleaning the Wiper Tray..... 185
Handling Severe Dot Drop-out and Dot Displacement 186
Ink Renewal Inside Heads Method 186
Emergency Measure) Cleaning the Print Head Surface 190
When the Operation Panel Is Dirty..... 191
Operation Panel Cleaning Method 191

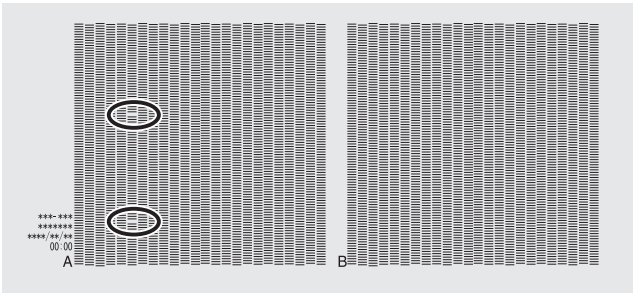
When Dot Drop-out or Dot Displacement Occurs

If dot drop-out or dot displacement occurs, perform cleaning of the print heads (normal cleaning).

Performing Normal Cleaning

Procedure

1. **Check for the group with dot drop-out or dot displacement by viewing the results of the printing test.**
   The space from "A" to "B" is group A. The space from "B" to the right side is group B.



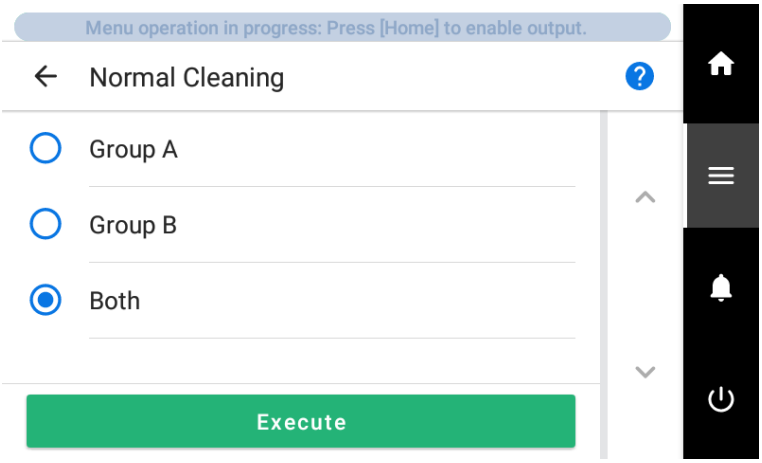
MEMO

If the printing-test results are difficult to interpret

- Check the results in a bright location, changing your line of vision. They are visible using the reflection of the light.
- Depending on the media, locations on which optimizer ink is printed may be difficult to check. If it is difficult to see the optimizer ink, switch to a different media and perform the printing test again.

2. **Tap** .

3. **Tap [Cleaning]>[Normal Cleaning].**
   The screen shown below appears.



4. **Select the group of print heads to clean.**

5. **Tap [Execute].**
   Cleaning will start. The status is displayed as **[Normal cleaning in progress.]** at the top of the operation panel.

On completion, you will return to the original screen.

6. Tap ←.

7. **Perform a printing test again.**

8. **Check to make sure the dot drop-out or dot displacement has been corrected.**

   If the problem persists, try performing normal cleaning again. If the printer has been used for a long period, dot drop-outs may not be fixed even after performing normal cleaning two or three times. If this is the case, clean using a different method.

RELATED LINKS

- P. 108 Performing a Nozzle Drop-out Test
- P. 181 When Normal Cleaning Is Not Effective

When Normal Cleaning Is Not Effective

Medium Cleaning Method

The print heads are important components that discharge ink. They require periodic and appropriate maintenance. When problems such as dot drop-out are not resolved by normal cleaning, perform the more forceful "medium cleaning" to remove clogging from the print heads.

IMPORTANT

Medium cleaning consumes more ink than normal cleaning, and overly frequent use may damage the print heads themselves. Avoid performing this operation more than necessary.

Procedure

1. **Load the media.**

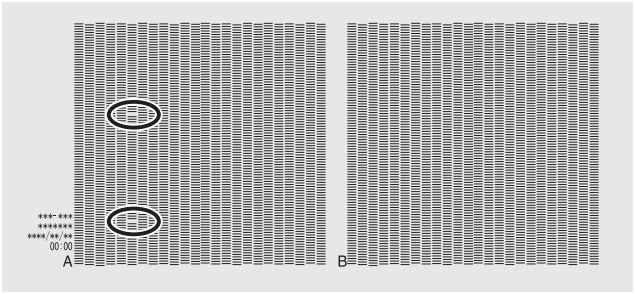
   P. 26 Setup of New Media

2. **Tap**  **.**

3. **Tap [Cleaning]>[Medium Cleaning].**

4. **Check for the group with dot drop-out or dot displacement by viewing the results of the printing test.**

   The space from "A" to "B" is group A. The space from "B" to the right side is group B.

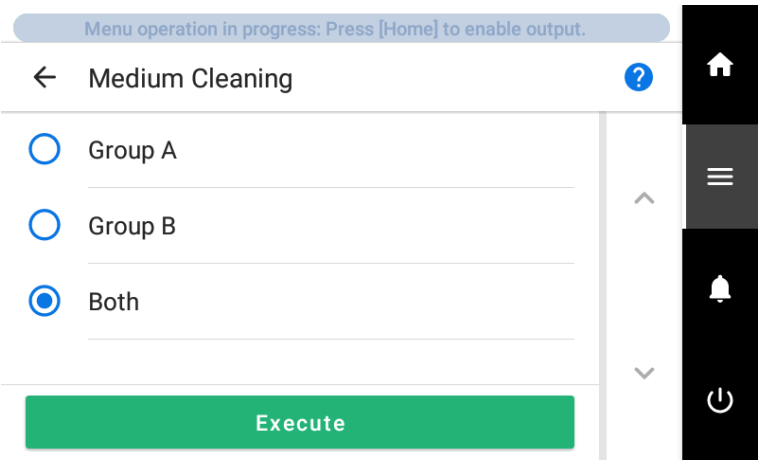
   

   MEMO

   If the printing-test results are difficult to interpret

   - Check the results in a bright location, changing your line of vision. They are visible using the reflection of the light.
   - Depending on the media, locations on which optimizer ink is printed may be difficult to check. If it is difficult to see the optimizer ink, switch to a different media and perform the printing test again.

5. **Select the group of print heads to clean.**



6. **Tap [Execute].**

   Cleaning will start. On completion, you will return to the original screen.

7. **Tap ←.**

8. **Tap [Printing Test].**

9. **Select [Nozzle Drop-out Test] and tap [Execute].**

   Perform a printing test again to check whether the dot drop-out and dot displacement have been corrected.

MEMO

- If the problem persists, try performing medium cleaning again.
- If problems such as dot drop-out and dot displacement persist even after you have performed medium cleaning several times, perform "powerful cleaning."
- This cleaning can be effective when carried out periodically, according to the frequency of use.

RELATED LINKS

- P. 183 Powerful Cleaning Method

Powerful Cleaning Method

The print heads are important components that discharge ink. They require periodic and appropriate maintenance. When problems such as dot drop-out are not resolved by medium cleaning, perform the more forceful "powerful cleaning" to remove clogging from the print heads.

IMPORTANT

Powerful cleaning consumes more ink than medium cleaning, and overly frequent use may damage the print heads themselves. Avoid performing this operation more than necessary.

Procedure

1. **Load the media.**

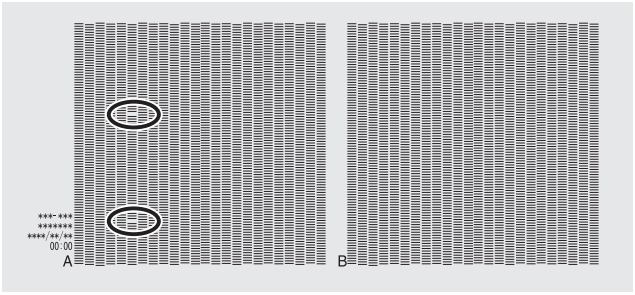
   P. 26 Setup of New Media

2. **Tap** .

3. **Tap [Cleaning]>[Powerful Cleaning].**

4. **Check for the group with dot drop-out or dot displacement by viewing the results of the printing test.**

   The space from "A" to "B" is group A. The space from "B" to the right side is group B.

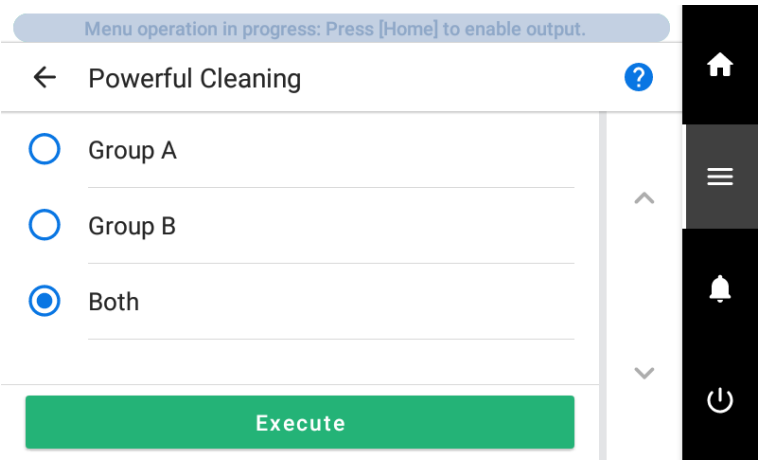
   

   MEMO

   If the printing-test results are difficult to interpret

   - Check the results in a bright location, changing your line of vision. They are visible using the reflection of the light.
   - Depending on the media, locations on which optimizer ink is printed may be difficult to check. If it is difficult to see the optimizer ink, switch to a different media and perform the printing test again.

5. **Select the group of print heads to clean.**



6. **Tap [Execute].**

Cleaning will start. On completion, you will return to the original screen.

7. **Tap ←.**

8. **Tap [Printing Test].**

9. **Select [Nozzle Drop-out Test] and tap [Execute].**

Perform a printing test again to check whether the dot drop-out and dot displacement have been corrected.

MEMO

- If the problem persists, try performing powerful cleaning again.
- This cleaning can be effective when carried out periodically, according to the frequency of use.
- If problems such as dot drop-out and dot displacement persist even after you have performed powerful cleaning several times, perform "wiper tray cleaning."

RELATED LINKS

- P. 185 Cleaning the Wiper Tray

Cleaning the Wiper Tray

If problems such as dot drop-out persist even after you have performed powerful cleaning, wash the wiper tray.

⚠ WARNING

Be sure to perform operations as specified by the instructions, and never touch any area not specified in the instructions.
Sudden movement of the machine may cause injury.

Procedure

1. **Tap** .

2. **Tap [Maintenance]>[Wiper Tray Cleaning].**
   The [**Wiper Tray Cleaning**] screen appears.

3. **Tap [Execute] for the group that needs to be cleaned.**
   Wiper tray cleaning starts.

   IMPORTANT

   At this time, if the cleaning liquid is empty, an error will be displayed. Refill the cleaning liquid, and then tap [**Execute**] again.

   When the discharging of the liquid in the wiper tray is complete, the tray is filled with cleaning liquid. [**Cleaning liquid filling in progress.**] and the (approximate) remaining time are displayed at the top of the operation panel.

   If the cleaning liquid runs out during filling, [**Unable to Fill Wiper Cleaning Liquid**] is displayed at the top of the operation panel. Replace the cleaning liquid pouch.

   P. 104 Cleaning Liquid Replenishment Method

4. **Tap**  **to go back to the original screen.**

   If dot drop-out or dot displacement does not improve even after printing test is performed again, perform cleaning around the print heads (manual cleaning).

RELATED LINKS

- P. 164 Cleaning around the Print Heads

Handling Severe Dot Drop-out and Dot Displacement

Ink Renewal Inside Heads Method

Perform "Ink Renewal Inside Heads" in the following situation.

- When ink discharge issues such as dot drop-out are not corrected after performing cleaning using the cleaning function (normal, medium, powerful), wiper tray cleaning, and cleaning around the print heads

IMPORTANT

A large amount of ink will be discharged during ink renewal inside heads. Perform this operation only when ink discharge issues such as dot drop-out, dot displacement, and uneven colors cannot be corrected.

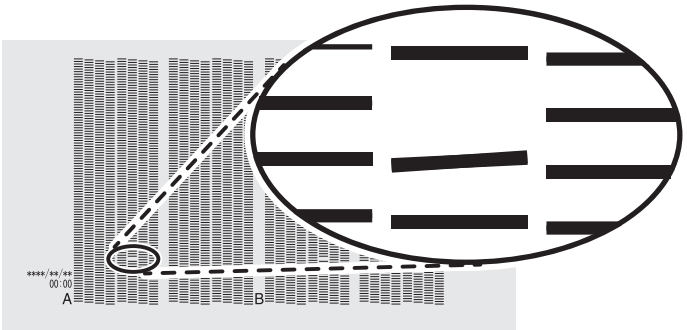
RELATED LINKS

- P. 109 Performing Normal Cleaning
- P. 181 Medium Cleaning Method
- P. 183 Powerful Cleaning Method
- P. 185 Cleaning the Wiper Tray
- P. 164 Cleaning around the Print Heads

Step 1: Performing a Printing Test

Procedure

1. **Load the media.**
   P. 26 Setup of New Media
2. **Tap  [Nozzle Drop-out Test] on the home screen.**
3. **Tap [Execute] next to [Printing Test].**
   Printing of the test pattern starts.
4. **Check whether there is dot drop-out or dot displacement in the test pattern.**
   Missing blocks indicate dot drop-out. Collapsed or inclined blocks indicate dot displacement.



IMPORTANT

Depending on the media, locations on which optimizer ink is printed may be difficult to check. If it is difficult to see the optimizer ink, switch to a different media and perform the printing test again.

5. If you have opened the front cover, close it.

If no dot drop-out or dot displacement occurs, this operation is finished. Press  to go back to the original screen.

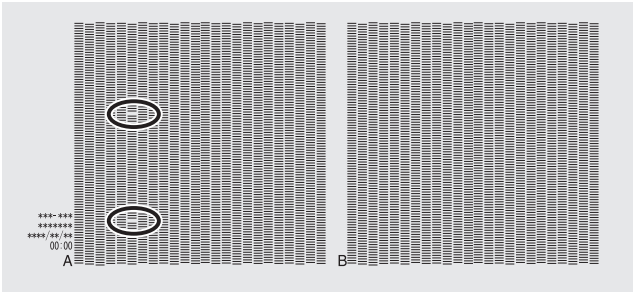
Step 2: Start the [Ink Renewal Inside Heads] menu.

Procedure

1. Tap .

2. **Tap [Maintenance]>[Ink Renewal Inside Heads].**

3. **Check for the group with dot drop-out or dot displacement by viewing the results of the printing test.**
   The space from "A" to "B" is group A. The space from "B" to the right side is group B.



MEMO

If the printing-test results are difficult to interpret

- Check the results in a bright location, changing your line of vision. They are visible using the reflection of the light.
- Depending on the media, locations on which optimizer ink is printed may be difficult to check. If it is difficult to see the optimizer ink, switch to a different media and perform the printing test again.

4. **Tap [Execute] on the group of print heads that needs to be cleaned.**
   Ink renewal inside heads starts. On completion, you will return to the original screen.

5. **Tap  to go back to the original screen.**

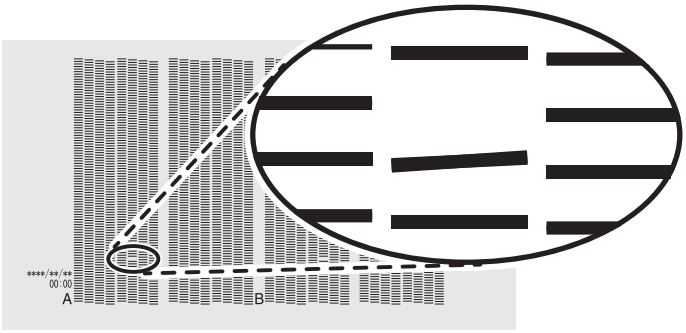
Step 3: Perform a printing test to check the results.

Procedure

1. **Tap  [Nozzle Drop-out Test] on the home screen.**

2. **Tap [Execute] next to [Printing Test].**
   Printing of the test pattern starts.

3. **Check whether there is dot drop-out or dot displacement in the test pattern.**
   Missing blocks indicate dot drop-out. Collapsed or inclined blocks indicate dot displacement.



IMPORTANT

Depending on the media, locations on which optimizer ink is printed may be difficult to check. If it is difficult to see the optimizer ink, switch to a different media and perform the printing test again.

4. **If you have opened the front cover, close it.**

   If no dot drop-out or dot displacement occurs, this operation is finished. Press  to go back to the original screen.

If the dot drop-out or dot displacement location is different, perform powerful cleaning another two or three times. If dot drop-out or dot displacement occurs in the same location on the test pattern, contact your authorized dealer.

Emergency Measure) Cleaning the Print Head Surface

When dot drop-out or dot deflection is not improved even if cleaning is performed several times, you can clean the surface of the print heads as an emergency measure. The print head surface (nozzle surface) is a very delicate mechanism, so work must be performed carefully and cautiously.

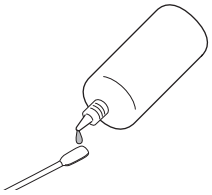
This operation is an emergency measure. It may damage defect-free parts depending on the symptoms, worsening the symptoms. If you have any questions, contact your authorized dealer.

IMPORTANT

- Be sure to use different cleaning sticks in the color ink section and the optimizer ink section. Using the same cleaning stick may lead to the optimizer ink and color ink mixing, resulting in ink hardening and discharge issues.
- Do not touch the tips of the cleaning sticks with your hands. Skin oil affixing to the print head caps may lead to malfunctions.
- Do not use cleaning liquid other than the included cleaning liquid.
- If you add cleaning liquid while cleaning a given location, do not dip the cleaning stick into the cleaning liquid bottle. Instead, drip the cleaning liquid onto the cleaning stick.

Procedure

1. **Apply a large amount of cleaning liquid to the cleaning stick.**



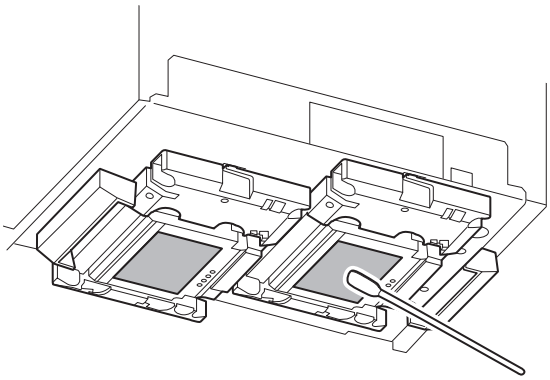
2. **Tap  on the operation panel.**

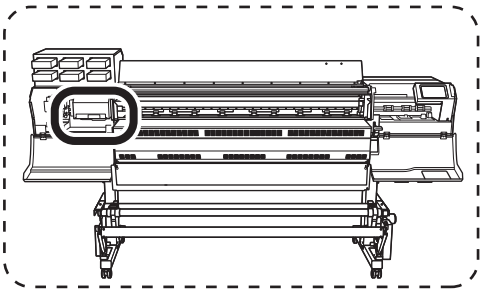
3. **Tap [Cleaning]>[Manual Cleaning].**

4. **Tap [Execute].**

5. **Very gently touch the cleaning stick against the print head surface (nozzle surface).**

   Very softly press the cleaning stick against the print head so that cleaning liquid soaks into the print head surface (nozzle surface). Never rub the stick on the surface or press it forcibly.





6. **When you have finished cleaning, tap [Finish All].**

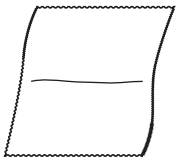
When the Operation Panel Is Dirty

Operation Panel Cleaning Method

IMPORTANT

Important notes on this procedure

- The cloths, alcohol, and similar items used in cleaning are not included with the product.
- Be sure to use a cloth when cleaning the operation panel. Liquid entering into the operation panel through its gaps may cause printer malfunctions.

Required items	
	
Anhydrous ethanol or isopropyl alcohol	Cloth (that is not fluffy)

⚠ CAUTION

When using anhydrous ethanol or isopropyl alcohol, be sure to follow the product's usage precautions.

Exercise caution regarding items such as fire, ventilation, and rashes.

⚠ CAUTION

Only use anhydrous ethanol or isopropyl alcohol.

Using chemicals (or similar substances) other than anhydrous ethanol or isopropyl alcohol may lead to operation panel damage.

Procedure

1. **Wipe off the operation panel with a cloth soaked in anhydrous ethanol or isopropyl alcohol.**

   Wipe slowly and gently to remove the grime.

Replacing Consumable Parts

Replacing Parts for Maintenance 193
Replacing the Wipers 193
Flushing Pad Replacement 196
Replacing the Separating Knife 201

Replacing Parts for Maintenance

Replacing the Wipers

The wipers are components that you use when cleaning the print heads.

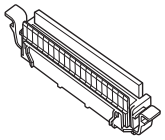
When it is time to replace the wiper, the message [**The time for wiper replacement has arrived.**] appears. In this situation, replace the wiper.

For information about purchasing wipers, contact your authorized dealer or visit our website (https://www.rolanddg.com/).

⚠ WARNING

Be sure to perform operations as specified by the instructions, and never touch any area not specified in the instructions.

Sudden movement of the machine may cause injury.

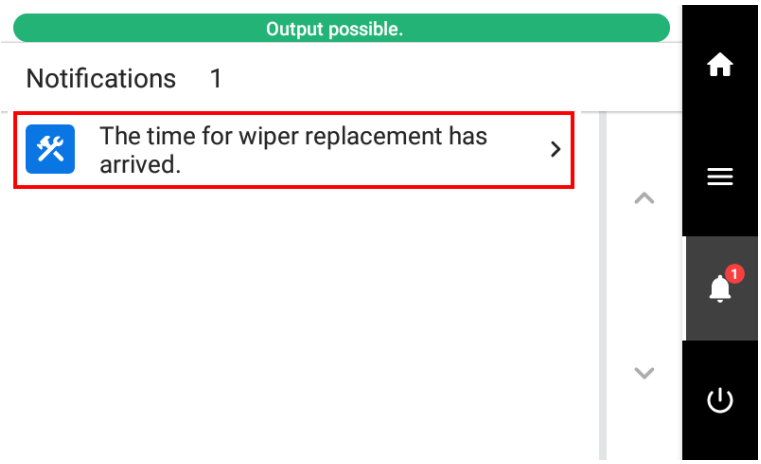
Required item

Wiper

MEMO

If the inside of the printer is dirty, refer to Cleaning the Machine(P. 162) and perform cleaning.

Procedure

1. **When the message [The time for wiper replacement has arrived.] appears, tap [OK].**
2. **Remove any media.**
3. **Tap  to display the messages.**
4. **Tap [The time for wiper replacement has arrived.].**

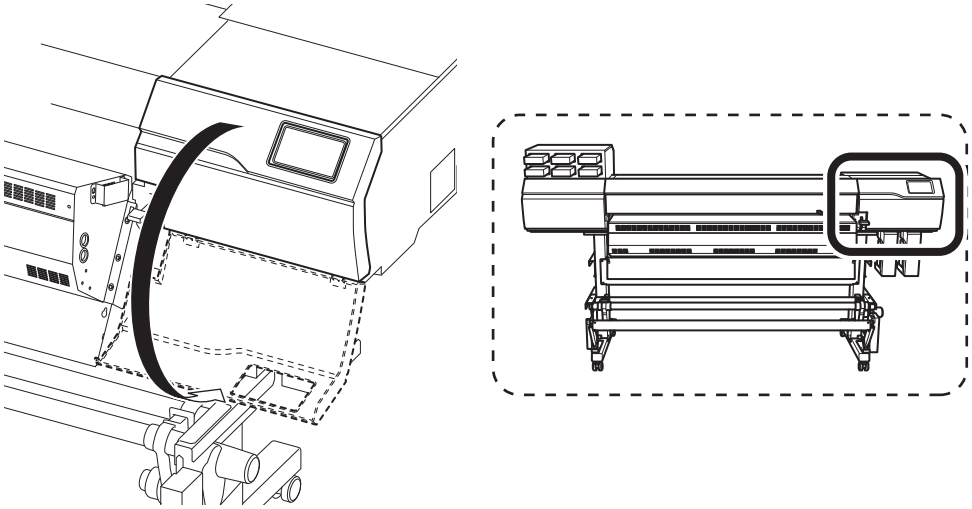


The [**Wiper Replacement**] screen appears.

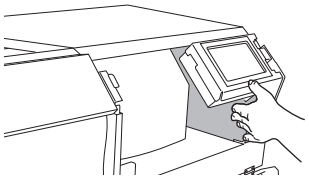
5. **Tap [Execute] for either the target optimizer ink section or the color ink section.**

6. **Tap [OK].**

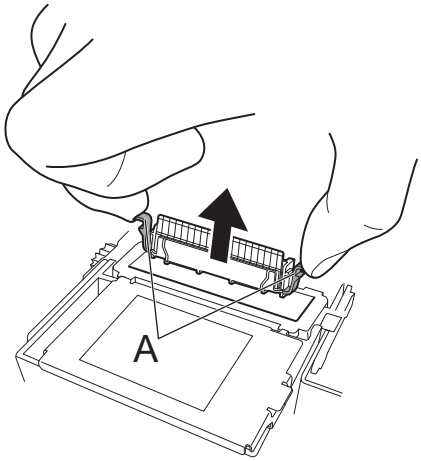
7. **When [Open the right cover.] appears, open the right cover.**



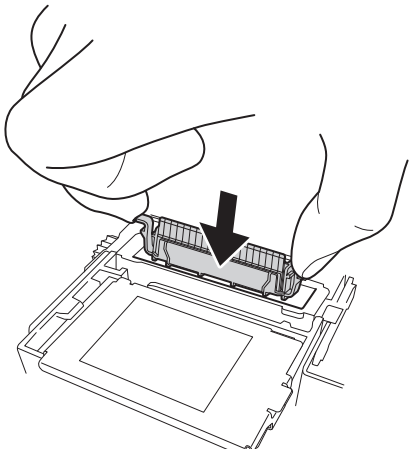
8. **Touch the location shown in the figure to discharge any static electricity.**



9. **Pinch the parts indicated by A, and then pull the old wiper up to remove it.**

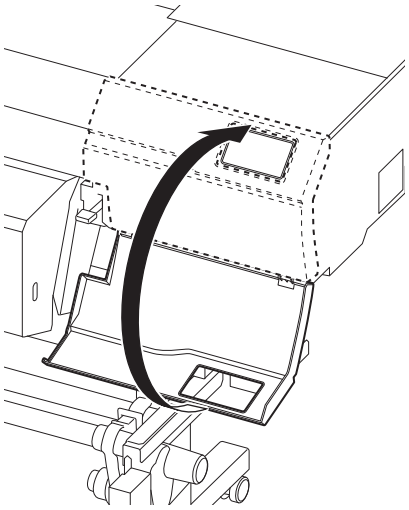


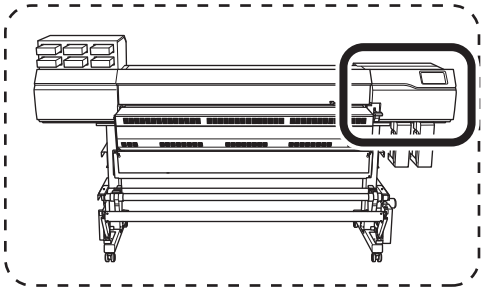
10. **Attach the new wiper by inserting it from above.**



11. **When the replacement of the wiper is complete, tap [Finish All].**

12. **When [Close the cover.] appears, close the right cover.**





When you close the right cover, you are returned to the original screen.

13. **Tap  to go back to the original screen.**

Flushing Pad Replacement

The flushing pad is used when the print heads spray ink in the home position.

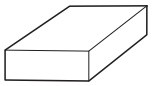
When it is time to replace the flushing pad, the message [**The time for flushing pad replacement has arrived.**] appears. In this situation, replace the flushing pad.

For information about purchasing flushing pads, contact your authorized dealer or visit our website (https://www.rolanddg.com/).

⚠ WARNING

Be sure to perform operations as specified by the instructions, and never touch any area not specified in the instructions.

Sudden movement of the machine may cause injury.

Required items		
		
Flushing pad (optimizer ink section, color ink section: 1 each)	Cleaning stick (2)	Cleaning liquid bottle for maintenance

IMPORTANT

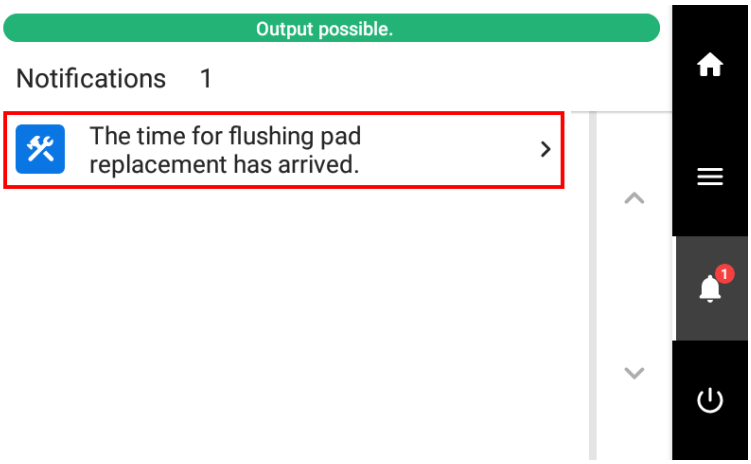
- Always use separate cleaning sticks and cleaning liquid with the optimizer ink and color ink sections. If the optimizer ink and color ink mix, the ink may harden and cause discharge issues.
- Use a new cleaning liquid bottle for maintenance.

MEMO

If the inside of the printer is dirty, refer to Cleaning the Machine(P. 162) and perform cleaning.

Procedure

1. **When the message [The time for flushing pad replacement has arrived.] appears, tap [OK].**
2. **Remove any media.**
3. **Tap  to display the messages.**
4. **Tap [The time for flushing pad replacement has arrived.].**

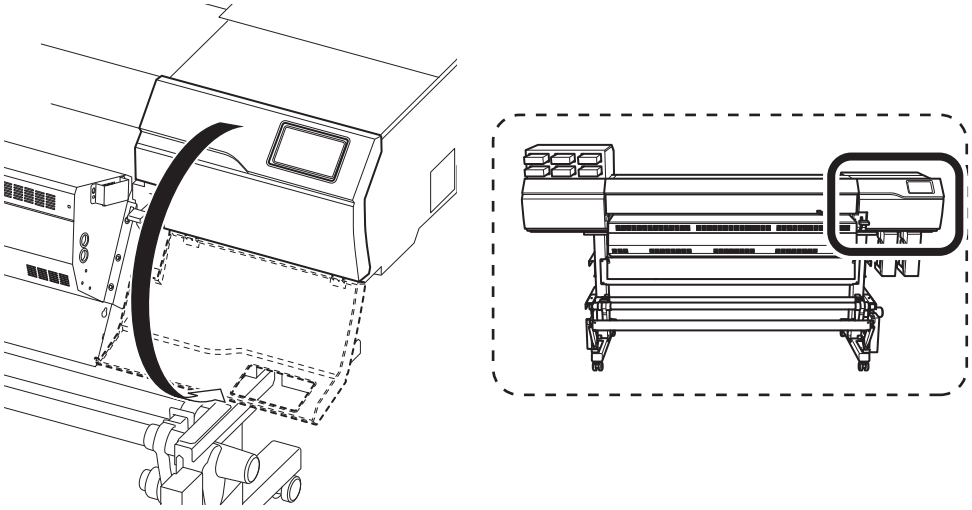


The [**Flushing Pad Replacement**] screen appears.

5. **Tap [Execute] for either the target optimizer ink section or the color ink section.**

6. **Tap [OK].**

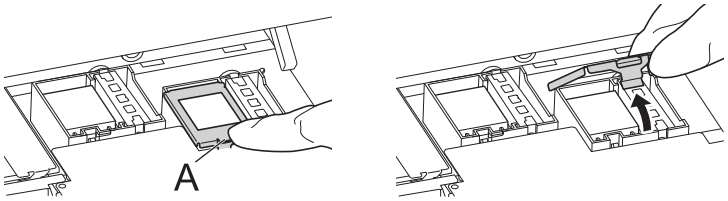
7. **When [Open the right cover.] appears, open the right cover.**



8. **Remove the frame to be replaced.**

Place your finger on A and lift it up to remove it. If the flushing pad is attached to the frame, remove it with your finger and remove only the frame.

The following figure is an example of the color ink section [**Group B (CMYK)**].



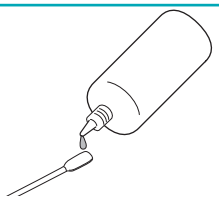
IMPORTANT

During the work, store the optimizer ink section frame and the color ink section frame in such a way that you can identify them, so that you can install the frames in their original locations after replacement.

9. **Drip one drop of cleaning liquid onto a cleaning stick.**

IMPORTANT

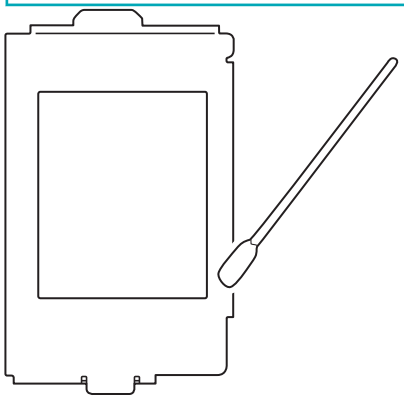
If you add cleaning liquid while cleaning, do not dip the cleaning stick into the tip of the cleaning liquid bottle. Instead, drip the cleaning liquid onto the cleaning stick.



10. **Clean off any ink on the frame.**

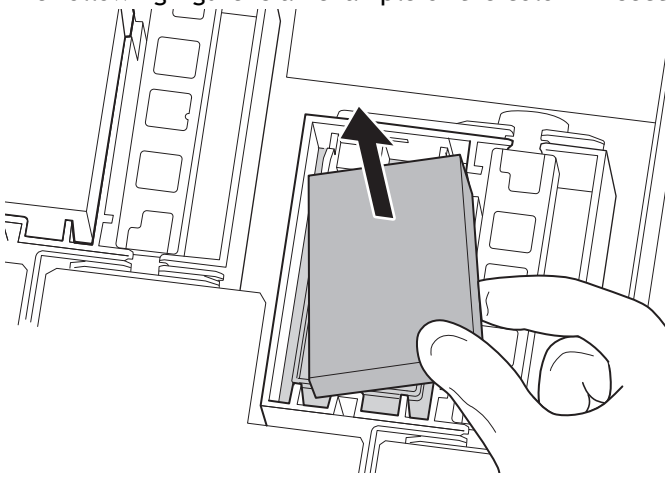
IMPORTANT

Always use separate cleaning sticks when cleaning the optimizer ink and color ink sections at the same time. Using the same cleaning stick may lead to the optimizer ink and color ink mixing, resulting in ink hardening.



11. **Remove the flushing pad from the flushing receptacle.**

The following figure is an example of the color ink section [**Group B (CMYK)**].



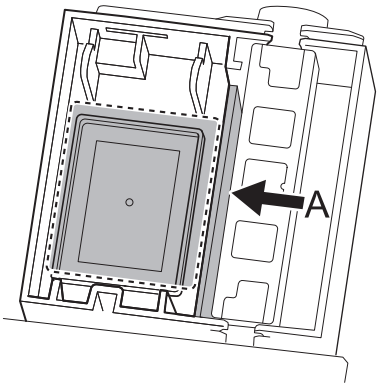
12. **Attach the new flushing pad to the flushing receptacle.**

To avoid damaging the flushing pad, do not use tweezers.

IMPORTANT

Check the following points.

- The flushing pad should be placed within the frame shown in the figure below.
- There should be no flushing pad on the partition (A) with the wiper.

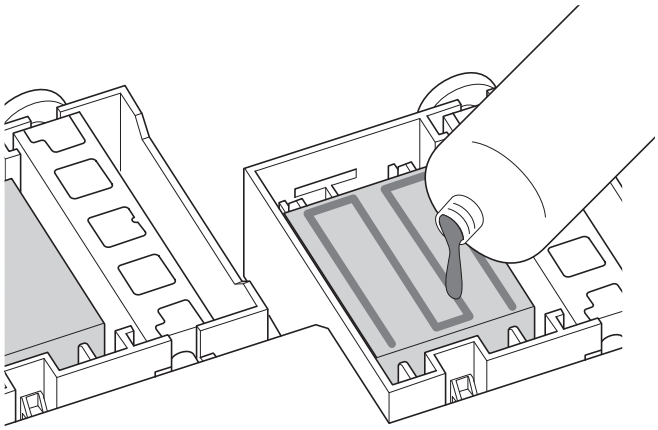


13. **In the case of the flushing pad on the color ink section, fully soak in cleaning liquid using the following procedure.**

MEMO

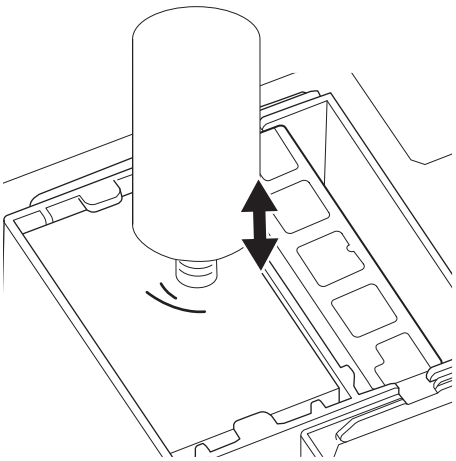
The flushing pad on the **optimizer ink section** does not need to be soaked in cleaning liquid.

(1) **Remove the nozzle from the cleaning liquid bottle and pour the whole cleaning liquid into the flushing pad.**



(2) **Press the tip of the cleaning liquid bottle against the flushing pad, and then soak the flushing pad in cleaning liquid all the way to the bottom of the pad.**

Press the cleaning liquid bottle until the cleaning liquid soaks the entire flushing pad.

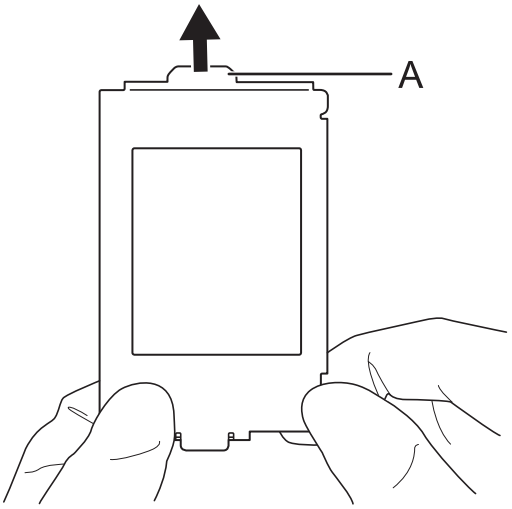


14. **Attach the frame.**

IMPORTANT

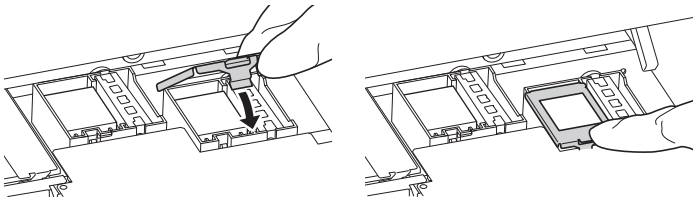
Install the optimizer ink section and color ink section frames in their original locations.

(1) **Insert the hook (A) into the back.**



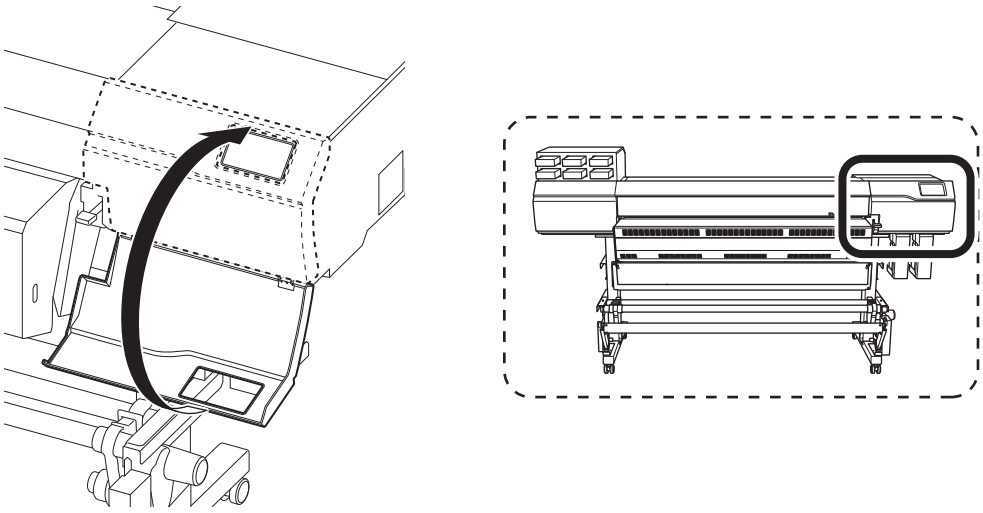
(2) **Lower the front of the frame.**

The following figure is an example of the color ink section [**Group B (CMYK)**].



15. **When the work is complete, tap [Finish All].**

16. **When [Close the cover.] appears, close the right cover.**



When you close the right cover, you are returned to the original screen.

17. **Tap**  **to go back to the original screen.**

Replacing the Separating Knife

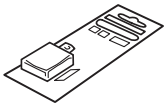
If the separating knife becomes dull, replace it with the included replacement knife.

⚠ WARNING

Be sure to perform operations as specified by the instructions, and never touch any area not specified in the instructions.
Sudden movement of the machine may cause injury.

⚠ CAUTION

Do not touch the tip of the separating knife.
Doing so may result in injury.

Required item

Replacement blade for separating knife

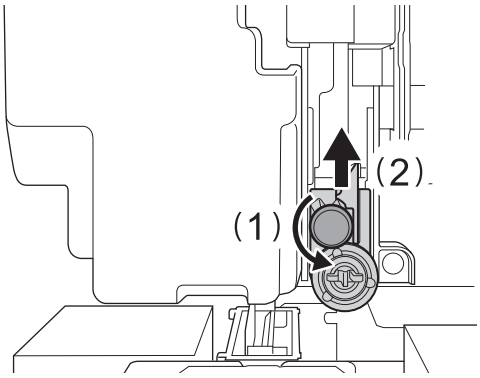
Procedure

1. **Remove any media.**
2. **Tap**  **.**
3. **Tap [Maintenance]>[Separating Knife Replacement].**
   The [**Separating Knife Replacement**] screen appears.
4. **Tap [Execute].**
   The sub carriage moves to a position where separating knife replacement is possible.
5. **When [Open the front cover.] appears, open the front cover.**

   MEMO

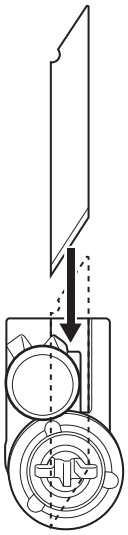
   The procedure is displayed on the operation panel.

   - Tap  or  to check the procedure.
   - If you complete the work without viewing the instructions, tap [**Finish All**].
6. **Remove the separating knife.**
   (1) **Loosen the screw until it slips out.**
   (2) **Grasp the screw portion, and slowly pull in the direction of the arrow.**
   When doing this, do not pull it back toward you.

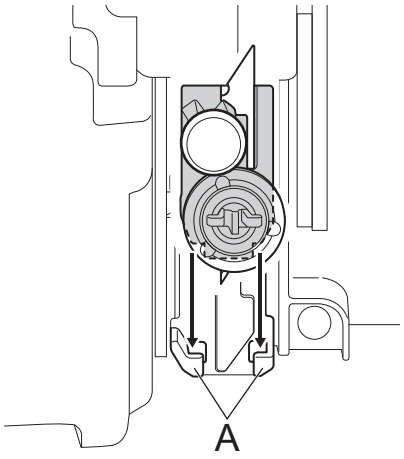


7. **Install a new knife.**

Slide the knife, as far as it will go, to align it with the groove.

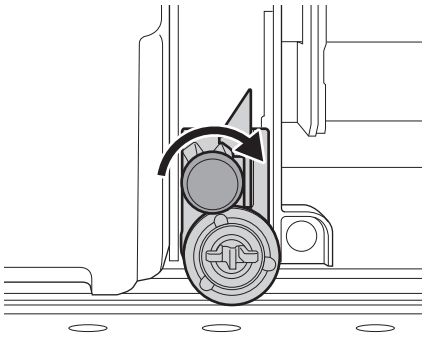


8. **Slowly insert the knife into the groove (A).**



9. **Tighten the screw.**

Take care to ensure that the knife does not slip out of position at this time.



10. **When the separating knife replacement is finished, tap [Finish All].**

11. **When [Close the cover.] appears, close the front cover.**
When you close the front cover, you are returned to the original screen.

12. **Tap  to go back to the original screen.**

Troubleshooting Methods

Output Quality Problems

Printed results are coarse or contain horizontal stripes 206
- Do the print heads cause dot drop-out? 206
- Is the print head height appropriate? 206
- Have you carried out [**Feed Correction**]? 206
- Have you carried out [**Media Gap Adjustment**] (ink landing position correction)? 206
- Is the printer installed in a level and stable location? 206
- Is the print heater at a suitable temperature? 207
- Is the print mode suitable? 207
- Is the media loaded correctly? 207
- Are the [**Media Settings**] appropriate? 207

The media becomes soiled when printed 208
- Do the print heads come into contact with the media? 208
- Are the print heads dirty? 208
- Are the pinch rollers or the media clamps dirty? 208

Colors are unstable or uneven 209
- Have you tried mixing the ink by shaking the pouch trays? 209
- Is the media wrinkled? 209
- Was printing paused partway through? 209
- Is the printer installed in a level and stable location? 209
- Is the media loaded correctly? 209
- Are the operating parameters set to appropriate values? 209
- Are the [**Media Settings**] appropriate? 210

Printed results are coarse or contain horizontal stripes

Do the print heads cause dot drop-out?

Carry out a printing test and make sure no dot drop-out or dot displacement occurs. If dot drop-out or dot displacement is present, perform head cleaning.

RELATED LINKS

- P. 108 Performing a Nozzle Drop-out Test
- P. 109 Performing Normal Cleaning

Is the print head height appropriate?

Printing when the [**Print Head Height**] menu item is set to [**High**] or to [**Medium**] is coarser than when set to [**Low**]. Keep this set to [**Low**] except when changing it is necessary, such as when you are using thick media.

RELATED LINKS

- P. 119 Changing the Print Head Height

Have you carried out [Feed Correction]?

Large misalignment in the amount of feed of the media may result in printing that seems coarse or contains horizontal bands. Either make the setting in the software RIP to match the type of media you are using, or make the setting for correction on the printer.

RELATED LINKS

- P. 114 Automatically Making Required Adjustments
- P. 115 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)

Have you carried out [Media Gap Adjustment] (ink landing position correction)?

The optimal adjustment value varies depending on the thickness of the media. Set an adjustment value that is suitable for the media. When further correction is required, such as when adjustment made using [**Simple Correction (Auto)**] does not enhance printing, use [**Detailed Correction (Manual)**] to make the correction.

RELATED LINKS

- P. 114 Automatically Making Required Adjustments
- P. 117 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)

Is the printer installed in a level and stable location?

Never install the machine in a location where it is tilted or where it may wobble or experience vibration. Also make sure that the print heads are not exposed to moving air. These factors may lead to dot drop-out or reduced printing quality.

Is the print heater at a suitable temperature?

If the ink forms lumps or smudges, raise the temperature. Note, however, that a temperature that is too high may degrade the media or cause it to wrinkle.

RELATED LINKS

- P. 127 Setting the Print Heater Temperature

Is the print mode suitable?

If attractive printing is impossible even when the print heater is at a high temperature, try using a higher-quality print mode. Depending on the media, smudging may occur when using a high-quality print mode, and results may also vary greatly depending on the settings of your software RIP (such as the color-profile selection). Select settings appropriate for the media you are using.

Is the media loaded correctly?

If the media is not loaded correctly or the media feed is not smooth, printing may be adversely affected. Load the media correctly.

RELATED LINKS

- P. 26 Setup of New Media
- P. 59 Setup of Registered Media

Are the [Media Settings] appropriate?

If the settings are not suitable for the type of media, printing may be adversely affected. Choose settings optimized for the media you are using.

RELATED LINKS

- P. 131 Managing the Media Settings

The media becomes soiled when printed

Do the print heads come into contact with the media?

The height of the print heads may be too low. Also, if the media is not loaded and set up correctly, it may wrinkle or come loose and contact the print heads.

RELATED LINKS

- P. 119 Changing the Print Head Height
- P. 26 Setup of New Media
- P. 59 Setup of Registered Media

Are the print heads dirty?

The following may cause ink to drip on the media during printing.

- Buildup of fibrous dust (lint) around the heads
- Ink transferred to the heads due to rubbing against the media

  If this happens, perform manual cleaning. We recommend carrying out periodic head cleaning.
- Too low humidity

  Use the machine in an environment with a humidity of 40 to 60%RH (no condensation).

RELATED LINKS

- P. 164 Cleaning around the Print Heads

Are the pinch rollers or the media clamps dirty?

Periodically clean them.

RELATED LINKS

- P. 162 Cleaning the Machine

Colors are unstable or uneven

Have you tried mixing the ink by shaking the pouch trays?

If colors are uneven, remove the pouch trays, and then shake them gently.

If uneven color issues with ink occur even after shaking the pouch tray to mix the ink, perform "Ink Renewal Inside Heads."

RELATED LINKS

- P. 186 Ink Renewal Inside Heads Method

Is the media wrinkled?

If the media is wrinkled and comes loose from the platen, colors may be uneven or the printing quality may suffer. If the media is wrinkled, load it again. Also, if the dryer temperature is too high the media may wrinkle depending on its characteristics.

RELATED LINKS

- P. 26 Setup of New Media
- P. 59 Setup of Registered Media

Was printing paused partway through?

When printing is paused, the coloring at the seam may be altered when printing resumes. Avoid pausing printing. Before you perform lengthy printing, check the amount of ink remaining in the ink pouches. Printing may also pause when data is not sent from the computer quickly enough. We recommend not performing any other tasks with the computer while printing is in progress.

Is the printer installed in a level and stable location?

Never install the machine in a location where it is tilted or where it may wobble or experience vibration. Also make sure that the print heads are not exposed to moving air. These factors may lead to dot drop-out or reduced printing quality.

Is the media loaded correctly?

If the media is not loaded correctly or the media feed is not smooth, printing may be adversely affected. Load the media correctly.

RELATED LINKS

- P. 26 Setup of New Media
- P. 59 Setup of Registered Media

Are the operating parameters set to appropriate values?

Depending on the setting for the [**Other Media Settings**]>[**Printing Movement Range**] menu item, uneven colors may occur. If the setting has been changed, try restoring it to its default value.

RELATED LINKS

- P. 138 Speeding Up Output for Narrow Media

Are the [Media Settings] appropriate?

If the settings are not suitable for the type of media, printing may be adversely affected. Choose settings optimized for the media you are using.

RELATED LINKS

- P. 131 Managing the Media Settings

Media Feed Problems

Media Wrinkles 212
- Is the media loaded and set up straight and securely? 212
- Was loaded media allowed to stand for some time? 212
- Are the media clamps attached? 212
- Was the media loaded while the print heater was hot? 212
- Is the temperature of the dryer too high? 212
- Is **[Pullback After Printing]** enabled? 212
- Have you stored the media in a low-temperature room? 212
- Is the humidity of the room too high? 213
- Is the media sagging? 213

Media Feeding Is Not Straight 214
- Is the media loaded and set up straight and securely? 214

Media Feeding Is Not Smooth 215
- Is some other object coming into contact with the media? 215
- Is the media too thick? 215
- Are the grit rollers dirty? 215

A Media Jam Occurs! 216
- Is an error message displayed? 216
- Is the media warped or wrinkled? 216
- Is the height of the print heads too low? 216
- Are the grit rollers dirty? 216
- Are the media clamps installed? 216
- Is the media loaded and set up straight and securely? 216
- Is some other object coming into contact with the media? 217
- Is the media too thick? 217

Media Wrinkles

Is the media loaded and set up straight and securely?

Feeding is not smooth when the media is not straight or is tensioned unevenly on the left and right. Reload the media.

RELATED LINKS

- P. 26 Setup of New Media
- P. 59 Setup of Registered Media

Was loaded media allowed to stand for some time?

Media may shrink or wrinkle if it is heated for an extended time. When printing ends, switch off the sub power and remove the media.

Are the media clamps attached?

When you are performing printing, be sure to attach the media clamps.

Was the media loaded while the print heater was hot?

Loading media after the print heater has warmed up causes the temperature of the media to rise suddenly, which may cause the media to shrink or wrinkle during printing. Before loading media, switch off the sub power and allow the platen to cool.

RELATED LINKS

- P. 126 Adjusting the Ink-drying Method

Is the temperature of the dryer too high?

If the dryer temperature is too high, the media may deform and wrinkle. Set the temperatures to suitable values for the type of media.

RELATED LINKS

- P. 126 Adjusting the Ink-drying Method

Is [Pullback After Printing] enabled?

Media that has passed once through the dryer may wrinkle depending on its characteristics.

Disable [**Media Settings**]>[**Heater Settings**]>[**Pullback After Printing**] when using media that is prone to wrinkling caused by the dryer.

Have you stored the media in a low-temperature room?

If the media is loaded while it is still cold, it may wrinkle due to the temperature difference with the print heater. Before printing, allow the media to come to room temperature.

Is the humidity of the room too high?

Use the machine in an environment with a humidity of 40 to 60%RH (no condensation).
High humidity can cause the media to sag. If sagging media is used, it may come out wrinkled.

Is the media sagging?

If sagging media is used, it may come out wrinkled.

Media Feeding Is Not Straight

Is the media loaded and set up straight and securely?

Feeding is not smooth when the media is not straight or is tensioned unevenly on the left and right. Reload the media.

RELATED LINKS

- P. 26 Setup of New Media
- P. 59 Setup of Registered Media

Media Feeding Is Not Smooth

Is some other object coming into contact with the media?

Make sure the media does not touch anything else. This may affect output, even when the feed appears to be smooth.

RELATED LINKS

- P. 26 Setup of Roll Media
- P. 47 Setup of Sheet Media

Is the media too thick?

Media that is too thick may not only cause an unstable feed but may scrape the print heads, resulting in a malfunction. Never use such media.

Are the grit rollers dirty?

Check to make sure the grit rollers are free of buildup of foreign material such as media scraps.

RELATED LINKS

- P. 162 Cleaning the Machine

A Media Jam Occurs!

Is an error message displayed?

If an error message is displayed because the media has jammed, immediately correct the problem. Doing so may damage the print heads.

RELATED LINKS

- P. 233 [Motor Error]

Is the media warped or wrinkled?

Many factors can cause warping or wrinkling. Refer to the following and correct the problem.

RELATED LINKS

- P. 212 Media Wrinkles

Is the height of the print heads too low?

Try raising the print heads higher. First, try setting the height to [**Medium**]. If the media is still jammed, change the height to [**High**]. Media may inevitably warp or wrinkle slightly, so adjust the height of the print heads to take this into account.

RELATED LINKS

- P. 119 Changing the Print Head Height

Are the grit rollers dirty?

Check to make sure the grit rollers are free of buildup of foreign material such as media scraps.

RELATED LINKS

- P. 162 Cleaning the Machine

Are the media clamps installed?

When you are performing printing, be sure to install the media clamps.

Is the media loaded and set up straight and securely?

Feeding is not smooth when the media is not straight or is tensioned unevenly on the left and right. Reload the media.

RELATED LINKS

- P. 26 Setup of New Media
- P. 59 Setup of Registered Media

Is some other object coming into contact with the media?

Make sure the media does not touch anything else. This may affect output, even when the feed appears to be smooth.

RELATED LINKS

- P. 26 Setup of Roll Media
- P. 47 Setup of Sheet Media

Is the media too thick?

Media that is too thick may not only cause an unstable feed but may scrape the print heads, resulting in a malfunction. Never use such media.

Machine Problems

The Print Heads Do Not Move 219
What to Do First 219
If the Print Heads Still Do Not Move 219
The printer unit does not run 221
Is the power switched on? 221
Is [**Output possible.**] displayed? 221
Are any covers open? 221
Is the message [**Output is currently paused.**] displayed on the screen? 221
Is a message displayed on the screen? 221
Are the cables connected? 221
Is the LAN routing appropriate? 222
Are the LAN settings correct? 222
Did the software RIP end abnormally? 222
Is an [**Ink Pouch Tray Error**] displayed? 222
The Print Heater/Dryer Does Not Become Hot 224
Is the media loaded? 224
Is the temperature of the room too low? 224
Cannot Separate the Media 225
Is the separating knife installed? 225

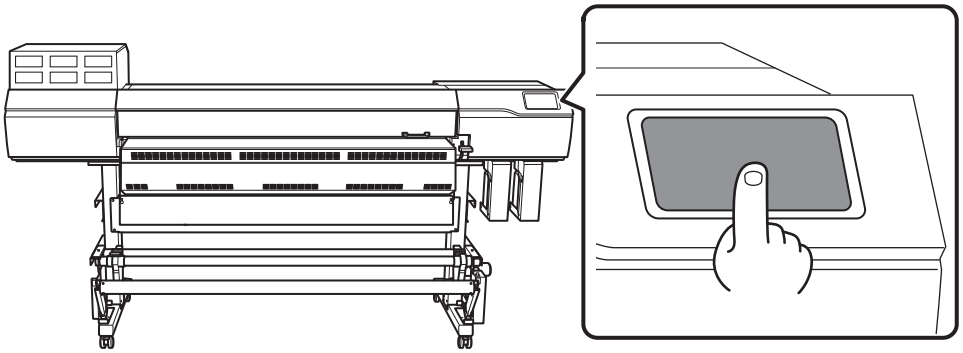
The Print Heads Do Not Move

If the print-head carriage stops over the platen, take action immediately to prevent the heads from drying out.

What to Do First

Switch the sub power off and then back on again. If the media is jammed, also remove the media.

If the print heads move to the home position (inside the right cover), it means the operation has ended successfully.



If the Print Heads Still Do Not Move

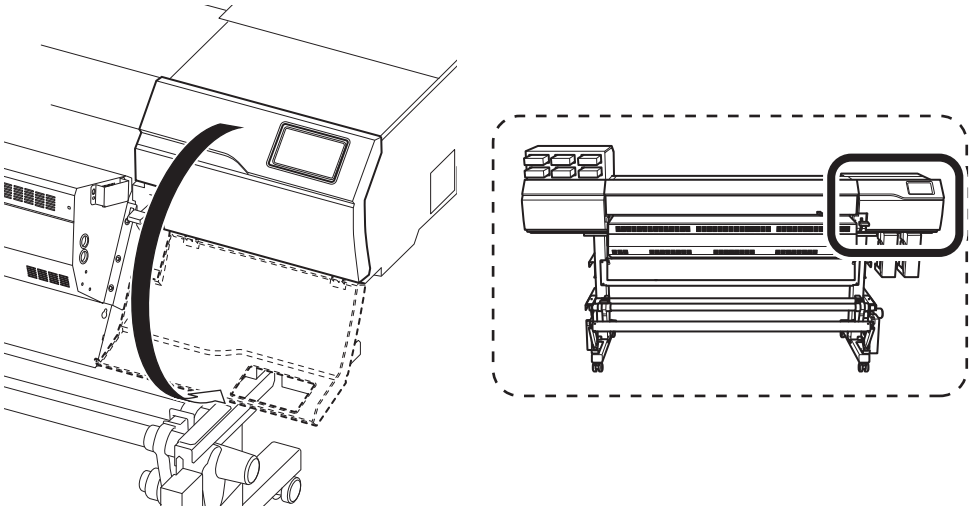
Try switching off the sub power, followed by the main power, then switching on the main power again, followed by the sub power.

If the Print Heads Still Do Not Move

If the heads still do not move, carry out the following emergency response measure, and then contact your authorized dealer.

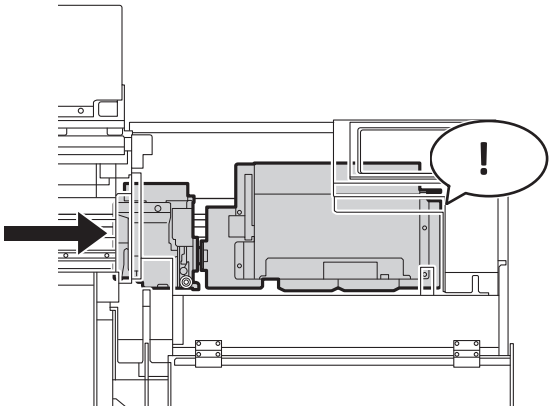
Procedure

1. **Switch off the sub power.**
2. **Switch off the main power, and then open the front cover.**
3. **Open the right cover.**



4. **Gently move the print-head carriage to the home position by hand.**

Stopping at the place where the audible click is heard locks the print-head carriage in place.



5. **Gently apply pressure from the right side to make sure the print-head carriage does not move to the left.**

If the print-head carriage moves to the left, move it again slowly by applying pressure from the left side and make sure it locks in place.

The printer unit does not run

Is the power switched on?

Switch on the printer's main power, followed by the sub power and make sure the home screen appears.

RELATED LINKS

- P. 23 Turning the Power On

Is [Output possible.] displayed?

Output is not performed when [**Output possible.**] is not displayed at the top of the operation panel. After loading the media and lowering the loading lever, tap  [**Setup**]. Follow the instructions on the screen to finish setting up the media. Also, when operating the setting menu, output doesn't start when data is sent from the computer with some menu items. When you return to a menu item where output is possible or tap  to return to the home screen, output starts.

RELATED LINKS

- P. 111 Printing Output

Are any covers open?

Close the front, left, and right covers.

Is the message [Output is currently paused.] displayed on the screen?

When [**Output is currently paused.**] is displayed on the screen, operation is paused. To resume, tap [**Resume**].

RELATED LINKS

- P. 89 Pausing and Canceling Output

Is a message displayed on the screen?

RELATED LINKS

- P. 227 Messages
- P. 230 Error Messages

Are the cables connected?

Connect the cables securely.

RELATED LINKS

- AP-640 Setup Guide

Is the LAN routing appropriate?

Check whether or not the network routing is appropriate. Try connecting the computer and the machine to the same hub or connecting them directly using a cable. If this makes it possible to perform output, it means the problem may be in the network itself.

Are the LAN settings correct?

If the cable connections are secure and no problem is found in the network itself, make sure that the IP address and other such settings are appropriate. The settings on both the machine and the computer must be appropriate. Redo the settings, checking to ensure that the IP address does not conflict with the IP address for another device on the network, that the port setting for the software RIP specifies the IP address set on the machine, that the settings have no typing errors, and for other such problems.

RELATED LINKS

- P. 149 Viewing Printer Information
- AP-640 Setup Guide

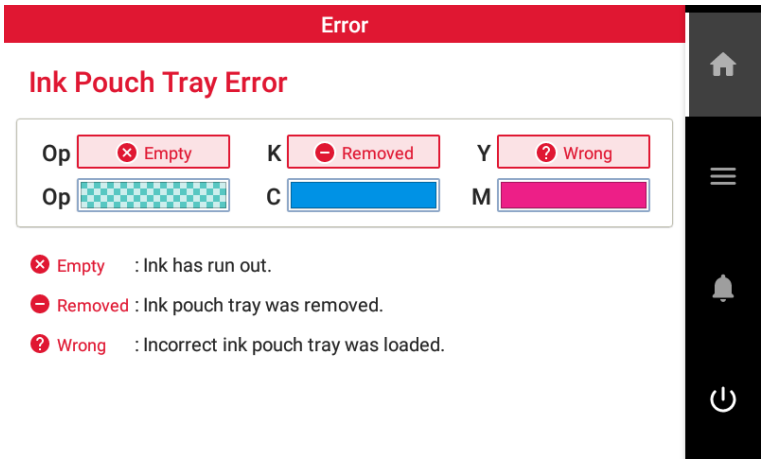
Did the software RIP end abnormally?

Make sure the software RIP is running correctly, and then switch the sub power switch off and back on.

RELATED LINKS

- VersaWorks manual (https://downloadcenter.rolanddg.com/VersaWorks6)

Is an [Ink Pouch Tray Error] displayed?



When an [**Ink Pouch Tray Error**] appears on the display screen, output data cannot be accepted. If there is data that has not yet been output remaining in the machine, output resumes when the error is cleared. If there is unsent data in the computer, output resumes when the data is resent.

When ink runs out

Replace the ink pouch with a new one.

When an ink pouch tray with the incorrect color is loaded

Remove the ink pouch tray that was loaded incorrectly and load the appropriate ink pouch tray.

When an ink pouch tray is removed or has not been securely loaded

Securely load the ink pouch tray by pushing it all the way to the back.

RELATED LINKS

- P. 97 Ink Pouch Replacement
- P. 230 [**Ink Pouch Tray Error**]
- P. 233 [**Ink Supply Error**]

The Print Heater/Dryer Does Not Become Hot

Is the media loaded?

By default, simply switching on the power does not make the media heating system warm up to the preset temperature. Load the media and wait for the machine to warm up.

RELATED LINKS

- P. 126 Adjusting the Ink-drying Method

Is the temperature of the room too low?

The print heater and dryer may not warm up sufficiently when the ambient temperature is less than 20°C (68°F). Also, even when they reach their set temperatures, adequate effectiveness may not be apparent if the media is thoroughly chilled. Before printing, allow the media to come to room temperature.

Cannot Separate the Media

Is the separating knife installed?

If the separating knife is not installed, you cannot separate the media.

RELATED LINKS

- P. 201 Replacing the Separating Knife

Messages on the Operation Panel

Messages 227
- **[When output, cleaning, and other operations are completed, discard the discharged fluid.]** 227
- **[The time for manual cleaning has arrived.]** 227
- **[The time for wiper replacement has arrived.]** 227
- **[The time for flushing pad replacement has arrived.]** 227
- **[Print head protection mode has activated.]** 227
- **[Fill the cleaning liquid tank with cleaning liquid.]** 228
- **[Operation of the take-up unit stopped.]** 228
- **[Install the media clamps correctly.]** 228
- **[Media clamps could not be detected.]** 228
- **[The LAN cable is not connected.]** 229
- **[Connection is requiring too much time. Manually setting the IP address will improve the connection speed.]** 229
- **[There is ink that has expired.]** 229
- **[The temperature around the machine is too low. Adjust the room temperature.]** 229
- **[The temperature around the machine is too high. Adjust the room temperature.]** 229

Error Messages 230
- **[Ink Pouch Tray Error]** 230
- **[Cover Open Error]** 230
- **[Media End Error]** 230
- **[Pinch Lever Error]** 231
- **[Media Loading Error]** 231
- **[Loose Media Error]** 232
- **[Drain Bottle Error]** 232
- **[Unable to Fill Wiper Cleaning Liquid]** 232
- **[Print Head Height Mismatch]** 232
- **[Insufficient Media Width]** 233
- **[Ink Supply Error]** 233
- **[Temperature Increase Timeout Error]** 233
- **[Motor Error]** 233
- **[Print Head Dry-out Error]** 234
- **[Low Temperature Error]** 234
- **[High Temperature Error]** 234
- **[Take-up Unit Communication Error]** 234
- **[Dryer Error]** 235
- **[Service Call]** 235
- **[Software error]** 235

Messages

These are the main messages that appear on the machine's display to prompt correct operation. These messages are not errors, so you can close them and perform other work. To check messages again or to carry out their corresponding actions, tap  to display the list of messages. Tap a message to display the menus and procedure required for the action. Perform operations according to the on-screen instructions.

[When output, cleaning, and other operations are completed, discard the discharged fluid.]

This message appears when a certain amount of discharged fluid collects in the drain bottle.

Tap [**When output, cleaning, and other operations are completed, discard the discharged fluid.**]>[**Execute**] to discard this fluid.

RELATED LINKS

- P. 176 If the Discharged Fluid Disposal Message Appears

[The time for manual cleaning has arrived.]

This message appears when it is time to perform manual cleaning.

Tap [**The time for manual cleaning has arrived.**]>[**Execute**] to perform manual cleaning.

RELATED LINKS

- P. 164 Cleaning around the Print Heads

[The time for wiper replacement has arrived.]

This message appears when it is time to replace the wiper.

Tap [**The time for wiper replacement has arrived.**]>[**Execute**] to replace the wiper.

RELATED LINKS

- P. 193 Replacing the Wipers

[The time for flushing pad replacement has arrived.]

This message appears when it is time to replace the flushing pad.

Tap [**Flushing Pad Replacement**]>[**Execute**] to replace the flushing pad.

RELATED LINKS

- P. 196 Flushing Pad Replacement

[Print head protection mode has activated.]

This message appears when the ink in use may not be a product specified by Roland DG Corporation.

If the ink is not a product specified by Roland DG Corporation, the speed and quality of printing will be affected by operations for preventing head malfunctions. To obtain optimal performance, we recommend that you use ink specified by Roland DG Corporation. To purchase ink, contact your authorized dealer.

[Fill the cleaning liquid tank with cleaning liquid.]

Only a small amount of cleaning liquid remains.

Refill the cleaning liquid tank with cleaning liquid.

RELATED LINKS

- P. 104 Cleaning Liquid Replenishment Method

[Operation of the take-up unit stopped.]

This message appears and the take-up unit stops when it is not possible to detect the position of the dancer roller for a continuous length of time during media feeding or pull back.

Tap [**Operation of the take-up unit stopped.**] and follow the instructions on the screen to recover the take-up unit.

[Install the media clamps correctly.]

This message appears when the media clamps are not placed at the predetermined positions.

Check the loading status of the media and that the pinch rollers have been positioned correctly, and then correctly set the media clamps at the ends of the media.

RELATED LINKS

- P. 26 Setup of New Media
- P. 59 Setup of Registered Media

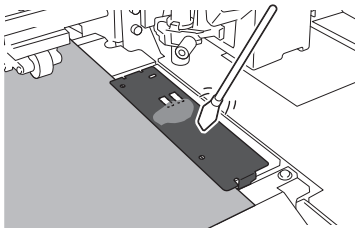
[Media clamps could not be detected.]

This message appears when the media clamps cannot be detected because they are hidden by the media.

Check the loading status of the media and that the pinch rollers have been positioned correctly, and then correctly set the media clamps at the ends of the media.

This message appears when the media clamps cannot be detected because their parts that are read are dirty with, for example, ink.

Use cleaning liquid and a cleaning stick to clean the white parts on the media clamps.



It may not be possible to detect the media clamps because the multi sensor is dirty with ink due to reasons such as the media striking it immediately after printing.

Install the media clamps correctly and clean their parts that are read. If this message still appears, contact your authorized dealer.

RELATED LINKS

- P. 26 Setup of New Media
- P. 59 Setup of Registered Media

[The LAN cable is not connected.]

This message appears when the machine and a computer are not connected with a LAN cable.

Properly connect the LAN cable.

[Connection is requiring too much time. Manually setting the IP address will improve the connection speed.]

This message appears when automatic IP address acquisition is enabled and the machine connects to a network on which no DHCP server exists while this automatic acquisition is in progress.

Connect to a network on which a DHCP server exists or disable automatic IP address acquisition and set a fixed IP address.

[There is ink that has expired.]

Ink has expired.

Replace with an ink pouch that is within its expiration date.

RELATED LINKS

- P. 97 Ink Pouch Replacement

[The temperature around the machine is too low. Adjust the room temperature.]

The internal temperature of the machine has fallen below that at which it can operate.

This message appears when the temperature falls to 19°C (66.2°F) or lower during startup or operation (when recovering from sleep mode).

Bring the installed location to a temperature at which operation is possible (20 to 30°C [68 to 86°F]) and allow the machine to come to room temperature.

[The temperature around the machine is too high. Adjust the room temperature.]

The internal temperature of the machine has risen above that at which it can operate.

This message appears when the temperature rises to 35°C (95°F) or higher during startup or operation (when recovering from sleep mode).

Bring the installed location to a temperature at which operation is possible (20 to 30°C [68 to 86°F]) and allow the machine to come to room temperature.

Error Messages

This section describes the error messages that may appear on the machine's display and how to take action to remedy the problem.

If an error message appears, all screen operations other than switching the power off are disabled. Follow the instructions on the screen to clear the error or switch the power off before starting to operate the machine again.

If the action displayed on the screen does not correct the problem or if an error message not described here appears, contact your authorized dealer.

[Ink Pouch Tray Error]

This message appears when one of the following ink pouch tray errors is detected.

MEMO

When an error occurs, the ⊗, ⊖, or ? icon is displayed next to the corresponding ink pouch tray on the screen.

Implement appropriate countermeasures according to the error.

- **When ink runs out**

  ⊗[Empty][Ink has run out.]

  Replace the ink pouch with a new one, and then load the ink pouch tray.

- **When an ink pouch tray is removed**

  ⊖[Removed][Ink pouch tray was removed.]

  Load the ink pouch tray that was removed.

- **When an ink pouch tray with the incorrect color is loaded**

  ?[Wrong][Incorrect ink pouch tray was loaded.]

  Remove the ink pouch tray that was loaded incorrectly and load the correct ink pouch tray.

  When an incorrectly loaded ink pouch tray is removed, ⊖ [Removed] [Ink pouch tray was removed.] is displayed.

[Cover Open Error]

The front, right, or left cover is open.

For safety, the machine stops if a cover is opened during operation.

Close the open cover.

[Media End Error]

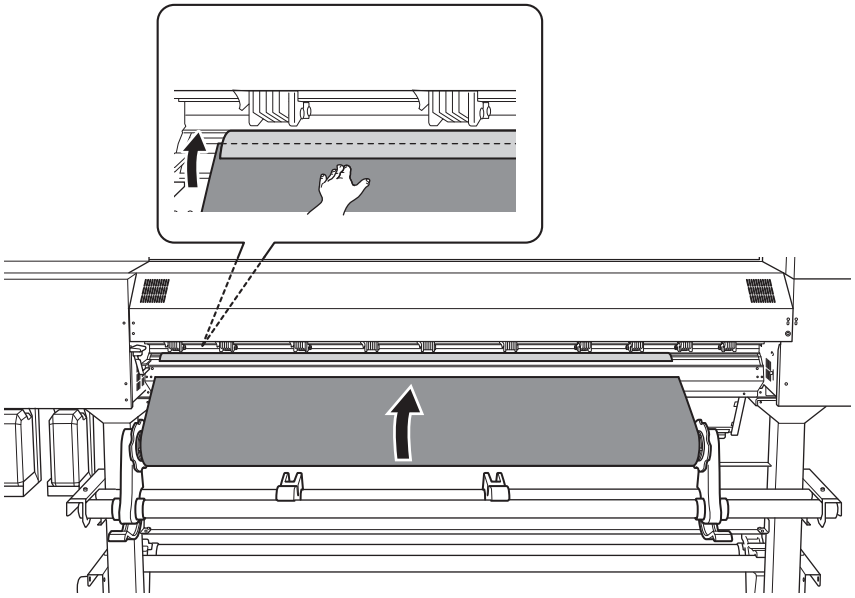
This message appears when one of the following situations is detected.

- Insufficient remaining media during take-up unit setup or printing output
- No media during media feeding

To dry the printed area, the media must be added and sent to the drying feed. Follow the procedure below to add the media.

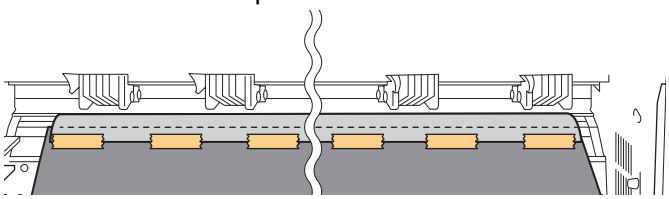
Procedure

1. **Insert the media to add under the loaded media.**



2. **Secure the pieces of media to each other with tape.**

   Use heat-resistant tape.



[Pinch Lever Error]

The loading lever was raised during media setup or after completing this setup.

Lower the loading lever and redo setup.

[Media Loading Error]

This message appears when media that cannot be detected, such as transparent media, is loaded even though [Select Sheet Type] has been set to [Opaque].

Raise the loading lever, and then select [**Transparent**] for [**Select Sheet Type**] to match the media being used.

For the setup method when [**Select Sheet Type**] is set to [**Transparent**], refer to the following.

- Roll media:2. B: Determine the positions of the media (transparent media, etc.).(P. 34)
- Sheet media:1. B: Determine the positions of the media (transparent media, etc.).(P. 51)

This message appears when opaque media whose width is insufficient is loaded.

Raise the loading lever, prepare media that are 259 mm (10.2 in.) or more in width, and then set up the media again.

This message appears when opaque media is caught and loose at the entrance of the dryer.

Raise the loading lever, remove the cause of the media becoming loose, and then set up the media again.

IMPORTANT

- If the leading edge of the media is bent, cut the bent part before loading the media, as it may be difficult for the media to enter the dryer entrance.
- If this does not work, start the media setup with the leading edge of the media at the entrance of the dryer.

This message appears when the length of opaque media is insufficient.

The media is not long enough to be detected. Raise the loading lever, prepare media that is 290 mm (11.42 in.) or more in length, and then set up the media again.

[Loose Media Error]

Media may be caught and become loose at the entrance of the dryer.

Check which locations are causing the media to become loose and eliminate this problem.

Media may become loose because it has stuck to the inside of the dryer.

When you cancel the output, the temperature of the dryer cools. Check that the dryer has cooled down, and then pull the media out from the top of the dryer while exercising caution regarding parts of the media that are not dry.

[Drain Bottle Error]

This message appears when the drain bottle has reached its limit for discharged fluid.

Discard the discharged fluid in the drain bottle, and then attach this bottle again.

MEMO

When the drain bottle is detached, the error message changes to [**Install the drain bottle.**].

This message appears when the drain bottle is misaligned.

Install the drain bottle again.

[Unable to Fill Wiper Cleaning Liquid]

The required cleaning cannot be performed because the cleaning liquid tank is empty and the wiper tray cannot be refilled with cleaning liquid.

Refill the cleaning liquid tank with cleaning liquid.

[Print Head Height Mismatch]

The set print head height and the actual print head height are different.

Follow the instructions on the screen to change the print head height. When you change this height, [**OK**] is displayed on the screen. Tap [**OK**] to resume printing.

If 10 minutes elapse after the print head carriage moves, this carriage is capped and the data is canceled to prevent the heads from drying out.

RELATED LINKS

- P. 119 Changing the Print Head Height

[Insufficient Media Width]

[The print data is larger than the media width. Continue output?]

This message appears when the size of the printing data is larger than the printing area of the loaded media.

To continue performing output without making corrections, tap [**Continue Output**]. At this time, the portion extending beyond the printing area is not output.

To cancel output, tap [**Cancel**]. Make the printing area wider, for example, by replacing the media with a larger piece of media, and then send the data again.

[Crop marks cannot be added because the print data is larger than the media width. Continue output?]

This message appears when one of the following situations is detected.

- The size of the data with crop marks is larger than the printing area of the loaded media.
- The width of the printing data is less than 60 mm (2.36 in.).

To continue performing output without making corrections, tap [**Continue Output**]. The data is output without printing the crop marks.

To cancel output, tap [**Cancel**]. Make the printing area wider, for example, by replacing the media with a larger piece of media, and then send the data again.

The size of the data being output is too small.

Make the horizontal-direction (scan-direction) size of the data at least 60 mm (2.6 in.). To continue performing output without making corrections, tap [**Continue Output**]. At this time, the data is output without printing the crop marks.

To cancel output, tap [**Cancel**]. Increase the size of the data, and then send the data again.

[Ink Supply Error]

This message appears when no ink has been supplied.

Remove the relevant ink pouch tray and set the ink pouch again if sufficient ink remains in it. If only a little ink remains, replace the ink pouch with a new one.

RELATED LINKS

- P. 97 Ink Pouch Replacement

[Temperature Increase Timeout Error]

A problem occurred while the temperature of the dryer was increasing and timeout occurred.

The dryer does not rise to the set temperature. Tap [**OK**] to reload the media.

[Motor Error]

A motor error occurred.

Operation cannot be continued. Turn off the sub power. Next, eliminate the cause of the error, then immediately switch on the sub power.

If the machine is allowed to stand with the error uncorrected, the print heads may dry out and become damaged. This error may be caused by such factors as a mistake in loading the media, a media jam, or an operation that pulls the media with excessive force.

The media has jammed.

Carefully remove the jammed media. The print heads may also be damaged. Perform head cleaning, and then perform a printing test and check the results.

Has the media been pulled with excessive force?

Excessive tension was applied to the media, and additional action is necessary to recover from this state. First, raise the loading lever and adjust the media to create a small amount of slack, and then switch on the sub power.

[Print Head Dry-out Error]

This message appears when the print heads are forced to the home position to prevent them from drying out.

Operation cannot be continued. Switch the sub power off, and then back on.

[Low Temperature Error]

The internal temperature of the machine has fallen below that at which it can operate.

This message appears when the temperature falls below 17°C (62.6°F) during startup or below 15°C (59°F) during operation.

Operation cannot be continued. Turn off the sub power.

Bring the installed location to a temperature at which operation is possible (20°C to 30°C [68°F to 86°F]), allow the machine to come to room temperature, and then turn on the power.

RELATED LINKS

- P. 22 Power Supply Operations

[High Temperature Error]

The internal temperature of the machine has risen above that at which it can operate.

This message appears when the temperature exceeds 36°C (96.8°F) during startup or exceeds 45°C (113°F) during operation (when recovering from sleep mode).

Operation cannot be continued. Turn off the sub power.

Bring the installed location to a temperature at which operation is possible (20°C to 30°C [68°F to 86°F]), allow the machine to come to room temperature, and then turn on the power.

RELATED LINKS

- P. 22 Power Supply Operations

[Take-up Unit Communication Error]

This message appears when an error such as the connection being lost during take-up unit setup occurs.

Operation cannot be continued. Switch off the sub power, followed by the main power. Check that the take-up unit is properly connected, and then once more switch on the main power, followed by the sub power.

[Dryer Error]

[Power Supply Error]

Power is not supplied to the dryer.

Check whether power is supplied to the dryer, such as if the power switch is on, the power cord is connected, the power breaker is not tripped, etc.

[Temperature Increase Error]

A problem occurred while the temperature of the dryer was increasing.

The dryer does not rise to the set temperature. Reload the media and output again.

Other than the above

There may be a problem with the dryer unit.

Try switching off the sub power, followed by the main power, then switching on the main power again, followed by the sub power.

[Service Call]

An unrecoverable error occurred or part replacement that must be performed by a service technician is required.

After turning the power off, contact your authorized dealer.

[Software error]

An error occurred in the internal communication or applications of the machine or part replacement that must be performed by a service technician is required.

Switch off the main power. Then, switch on the main power again, followed by the sub power. If the error still occurs, contact your authorized dealer.

Appendix

Operations When Moving the Unit

Preparing to Move the Machine 238
Step 1: Removing the Media 238
Step 2: Discharging the Tray Cleaning Liquid 239
Step 3: Securing the Carriage in Place Using the Retainer 240
Step 4: Removing the Dryer 241
Step 5: Reinstalling the Machine 242

Preparing to Move the Machine

Before moving the machine, dispose of the discharged fluid, secure the print-head carriage in place, remove the dryer, and perform any other necessary preparations. Attempting to move the machine without first performing these preparations may result in damage to internal components due to leaking ink or damage to the print heads or other components of the machine.

IMPORTANT

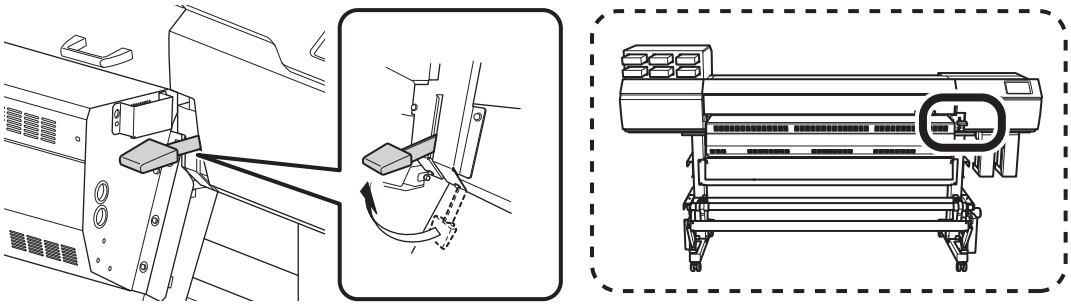
- Some work must be performed by a suitably qualified worker. Contact your authorized dealer for help before moving the machine.
- Once the preparations for moving the machine are complete, move the machine promptly and turn on the machine as soon as possible after the machine is relocated. If you leave the machine alone without turning it on, the precipitated ink will coagulate and result in problems such as the clogging of the print heads.
- When moving the machine, keep it at a temperature from 5 to 40°C (41 to 104°F) and at a humidity from 20 to 80% (with no condensation). Failure to do so may result in a breakdown.
- Handle the machine with care when moving it, keeping it level (not tilted at an angle) and preventing it from striking other objects.

Step 1: Removing the Media

Procedure

1. **Remove any media.**

   If no media is loaded, raise the loading lever.



Step 2: Discharging the Tray Cleaning Liquid

Discharge the cleaning liquid that has accumulated in the wiper tray and the flushing tray.

Procedure

1. Tap .
2. **Tap [Maintenance]>[Tray Cleaning Liquid Discharge].**
3. **Tap [Execute].**

   The cleaning liquid in the wiper tray and flushing tray is discharged. On completion, the sub power switches off.
4. **Remove the drain bottle and discard the discharged fluid.**

   IMPORTANT

   When you remove the drain bottle, a few drops of discharged fluid may come out of the machine. Exercise caution to prevent this fluid from soiling your hands or the floor.

   IMPORTANT

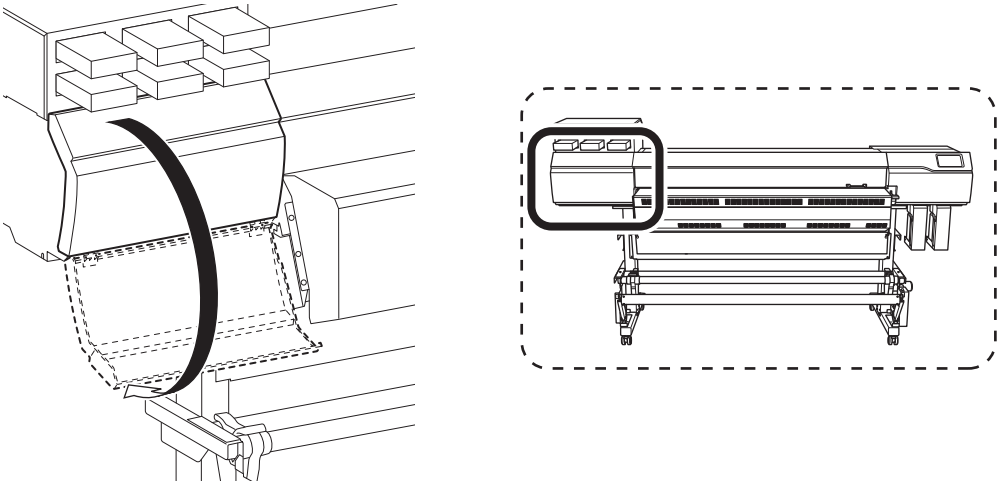
   Dispose of discharged fluid properly, in accordance with the laws in effect in your locale.
5. **Quickly attach the emptied drain bottle to the machine once more.**
6. **Turn off the main power switch.**

Step 3: Securing the Carriage in Place Using the Retainer

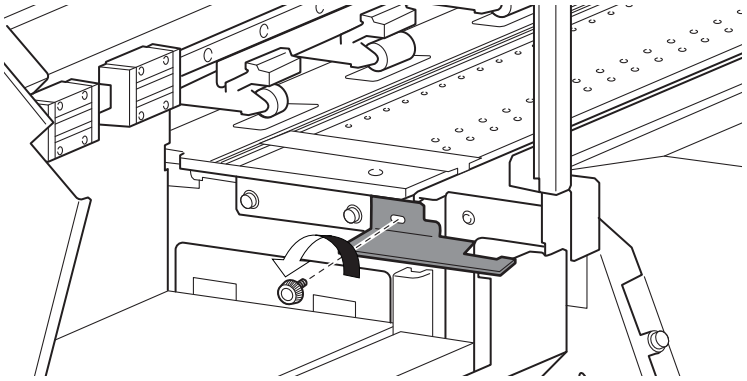
Use the retainer that was attached to the machine during its installation.

Procedure

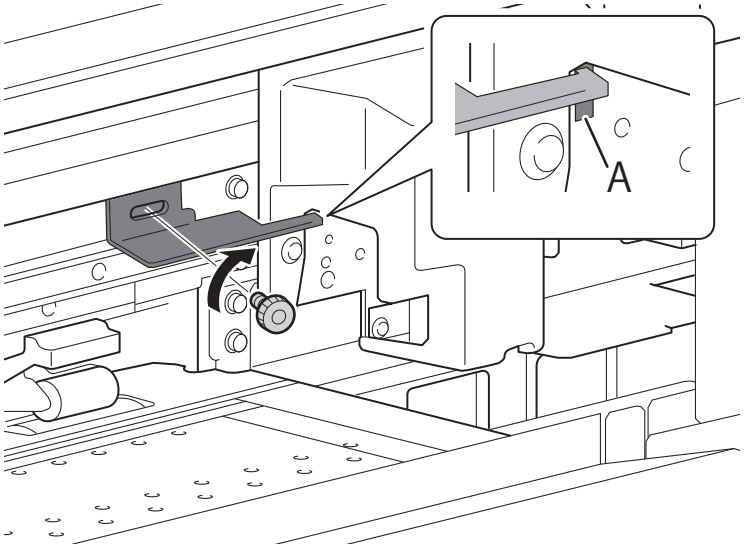
1. **Open the left cover.**



2. **Remove the retainer from inside the left cover of the machine.**



3. **Catch the retainer on hole A, and then use the screw to secure the retainer in the position shown in the figure.**



Step 4: Removing the Dryer

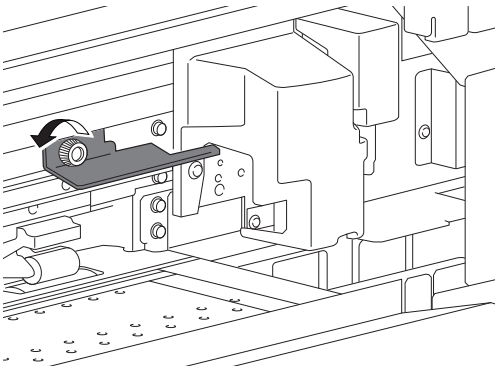
This work must be performed by a suitably qualified worker. Never attempt to perform this work yourself.

Step 5: Reinstalling the Machine

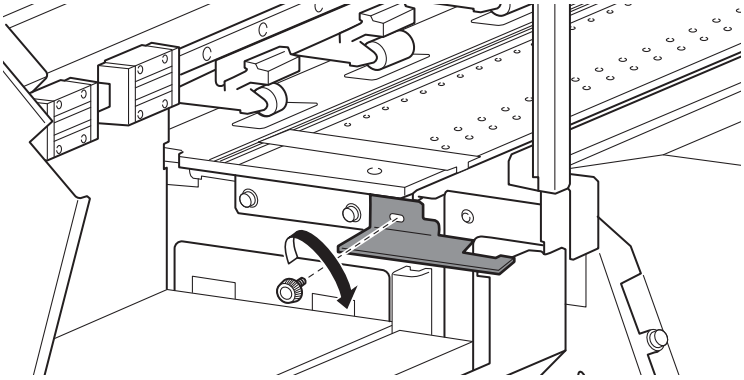
Procedure

1. **Once the preparations are complete, move the machine with as little delay as possible.**

2. **Reinstall the printer immediately, and then remove the retainer securing the print heads in place.**



3. **Install the retainer at the position indicated in the figure for storage.**



4. **Turn on the main power switch.**

> **IMPORTANT**
>
> To prevent the print heads from being damaged, move the machine with as little delay as possible and switch on the main power as soon as possible after moving the machine. To install the machine again, follow the procedure in the Setup Guide.

5. **Press the sub power button.**

The home screen appears, and then the machine is filled with cleaning liquid.

6. **Check that the print heads are not dirty.**

If they are dirty, follow the procedure below to clean them.

(1) **Tap**  **on the operation panel.**

(2) **Tap [Cleaning]>[Manual Cleaning].**

(3) **Tap [Execute].**

The print heads move to the left end of the machine. Check that the areas around the print heads are not dirty. If they are dirty, perform manual cleaning.

RELATED LINKS

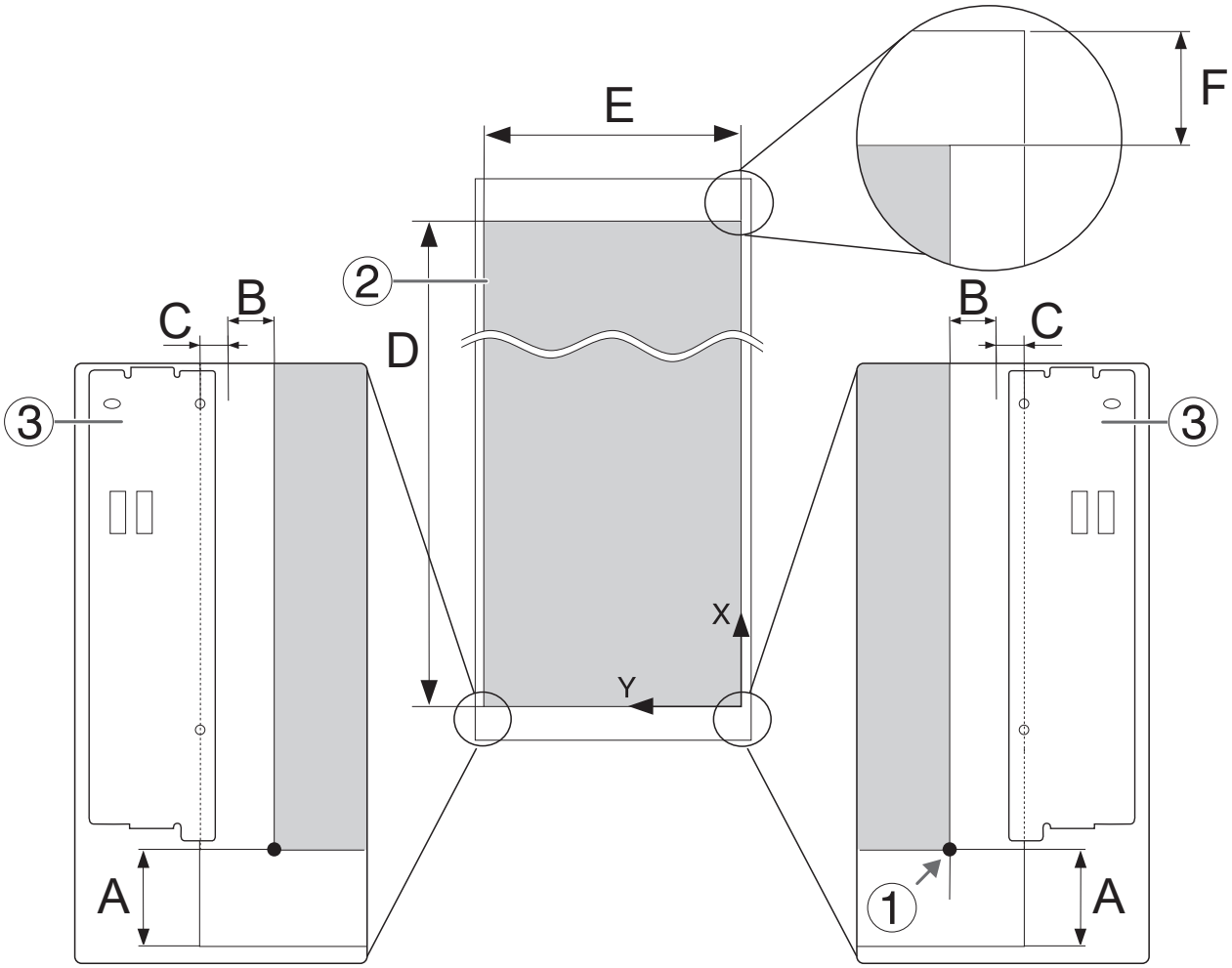
- P. 104 Cleaning Liquid Replenishment Method
- P. 164 Cleaning around the Print Heads

Main Specifications

Maximum Printing Area and Margins 245
Maximum Printing Area When Using Crop Marks 247
Media Separation Location during Continuous Printing 248

Maximum Printing Area and Margins

The printing area along the horizontal plane of the loaded media (the direction in which the carriages move) is determined by the margin setting.



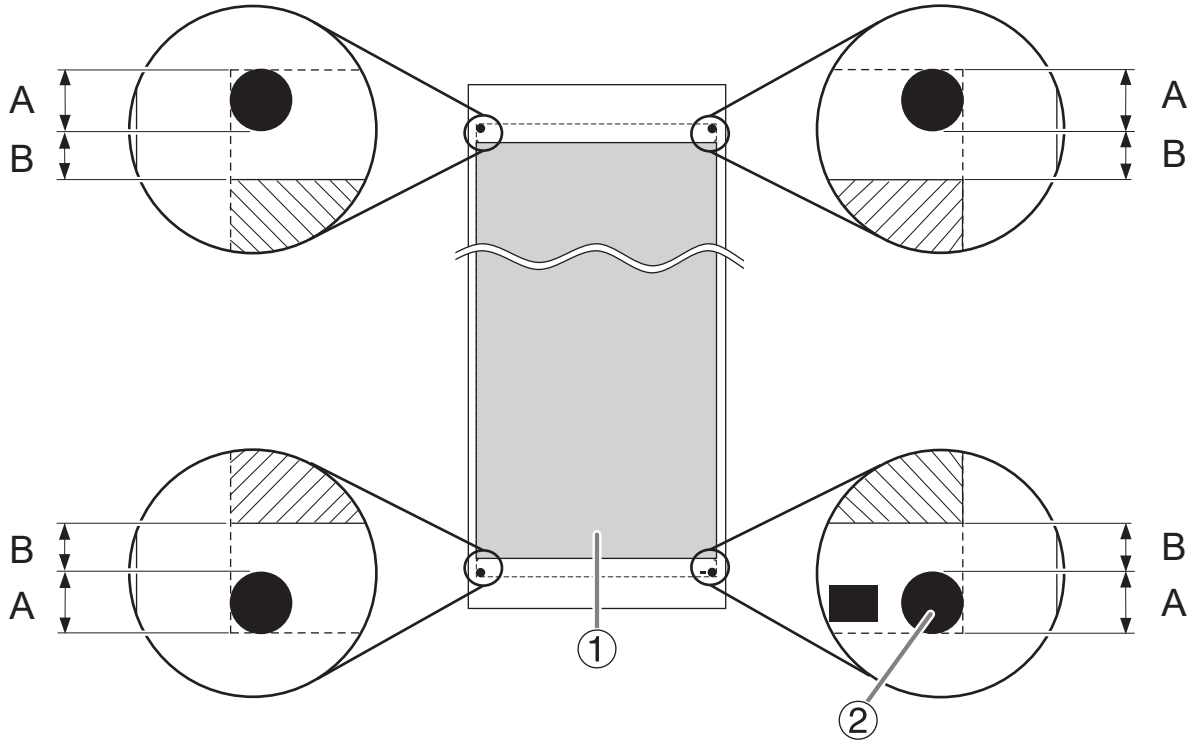
①	Origin of printing coordinates
②	Printing area
③	Media clamp
A	When the **[Sheet Cutting]** method after the previous printing operation is **[Sheet Cutting]**: 370 mm (14.6 in.) **[Perforated Sheet Cutting]**: 70 mm (2.76 in.)
B	**[Side Margin]** setting value
C	Width clamped by each media clamp: 4 mm (0.16 in.)
B + C	Actual margin value*1
D	Max. 200,000 mm (7,874 in.)
E	Max. 1,615 mm (63.6 in.) * When printing with the media clamps removed
F	When **[Pullback After Printing]** is • **[Disable]**: 370 mm (14.57 in.)*2 • **[Enable]**: Software RIP value (default setting: 80 mm (3.15 in.)

*1 When the media is set up without attaching the media clamps, B (the margin setting value) alone is used for the margin value without considering C (the width clamped by each media clamp).

*2 In order to allow the printing area to dry, media must be fed to the dryer up to the trailing edge of the printing area. When preparing media, leave at least 400 mm (15.75 in.) of margin from the printing area.

Maximum Printing Area When Using Crop Marks

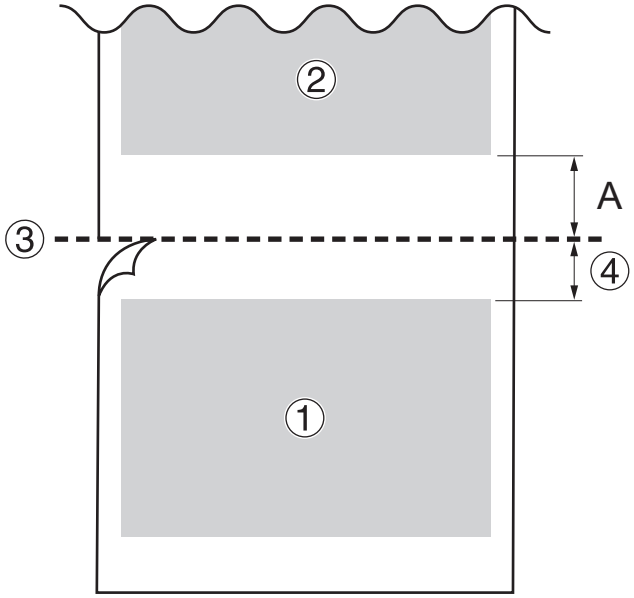
The maximum printing area when crop marks are used is reduced from the maximum printing area when crop marks are not used by an amount equal to the crop marks.



①	Maximum printing area
②	Crop mark
A	12.5 mm (0.5 in.)
B	10 mm (0.4 in.)

Media Separation Location during Continuous Printing

When a command for separating the media is sent from the computer, the separation location on the media is as shown in the figure below.



①	First page
②	Second page
③	Separation location
④	When **[Pullback After Printing]** is • **[Disable]**: 370 mm (14.57 in.)*1 • **[Enable]**: Software RIP value (default setting: 80 mm (3.15 in.)
A	When the **[Sheet Cutting]** method after the printing of the first page is **[Sheet Cutting]**: 370 mm (14.6 in.) **[Perforated Sheet Cutting]**: 70 mm (2.76 in.)

*1 In order to allow the printing area to dry, media must be fed to the dryer up to the trailing edge of the printing area. When preparing media, leave at least 400 mm (15.75 in.) of margin from the printing area.

Memo

This product is equipped with an "eT-Kernel Compact" eT-Kernel and a "PrCONNECT(R)/Pro" TCP/IP protocol stack, both made by eSOL Co., Ltd. eT-kernel and PrCONNECT are registered trademarks of eSOL Co., Ltd.

Redistribution and use in source and binary forms, with or without modification, are permitted provided that the following conditions are met:

- Redistributions in binary form must reproduce the above copyright notice, this list of conditions, and the following disclaimer in the documentation and/or other materials provided with the distribution.

THIS SOFTWARE IS PROVIDED BY THE COPYRIGHT HOLDERS AND CONTRIBUTORS "AS IS" AND ANY EXPRESS OR IMPLIED WARRANTIES, INCLUDING, BUT NOT LIMITED TO, THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE DISCLAIMED. IN NO EVENT SHALL THE COPYRIGHT HOLDER OR CONTRIBUTORS BE LIABLE FOR ANY DIRECT, INDIRECT, INCIDENTAL, SPECIAL, EXEMPLARY, OR CONSEQUENTIAL DAMAGES (INCLUDING, BUT NOT LIMITED TO, PROCUREMENT OF SUBSTITUTE GOODS OR SERVICES; LOSS OF USE, DATA, OR PROFITS; OR BUSINESS INTERRUPTION) HOWEVER CAUSED AND ON ANY THEORY OF LIABILITY, WHETHER IN CONTRACT, STRICT LIABILITY, OR TORT (INCLUDING NEGLIGENCE OR OTHERWISE) ARISING IN ANY WAY OUT OF THE USE OF THIS SOFTWARE, EVEN IF ADVISED OF THE POSSIBILITY OF SUCH DAMAGE.

Company names and product names are trademarks or registered trademarks of their respective holders.


Roland