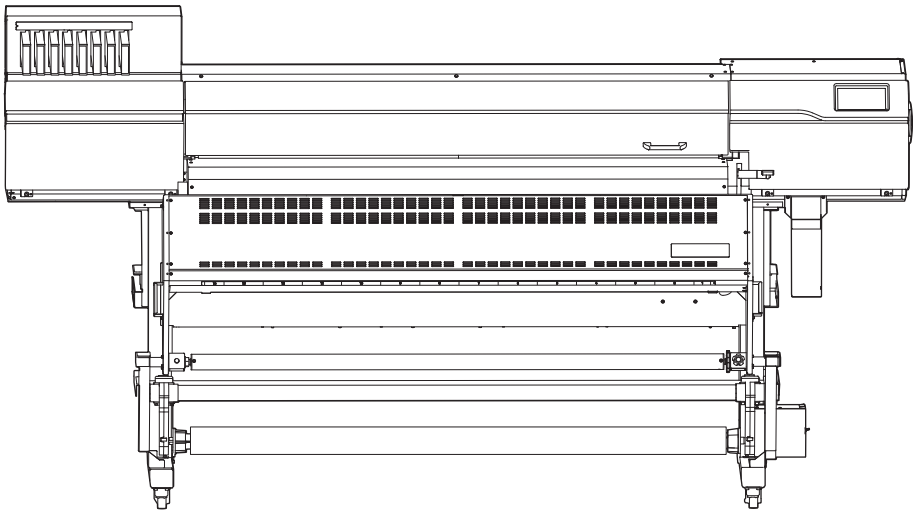
Roland

DIMENSE

DA-640

User's Manual



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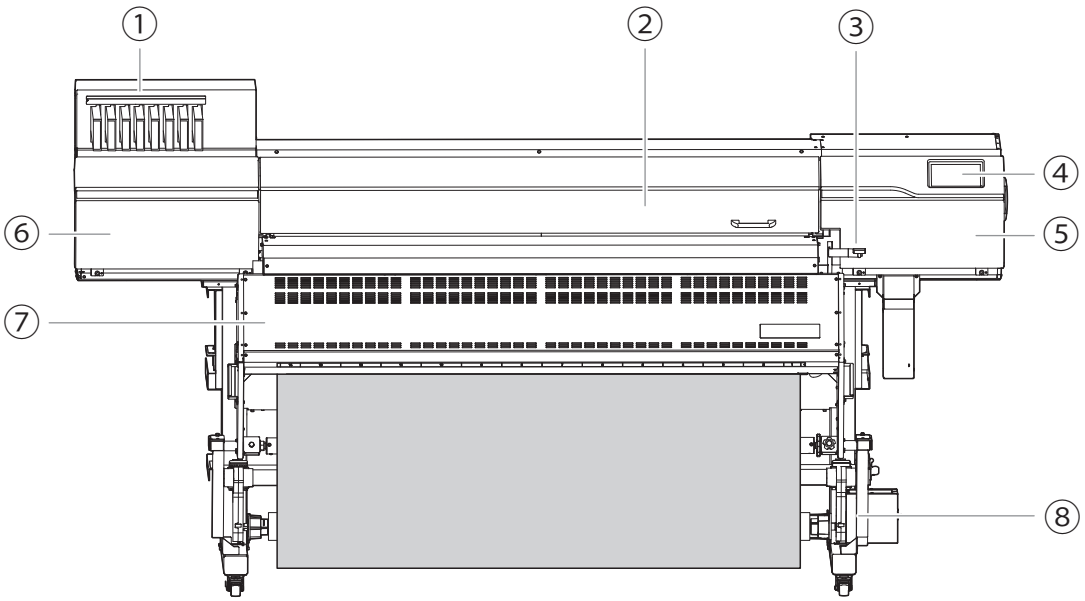
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Part Names and Functions

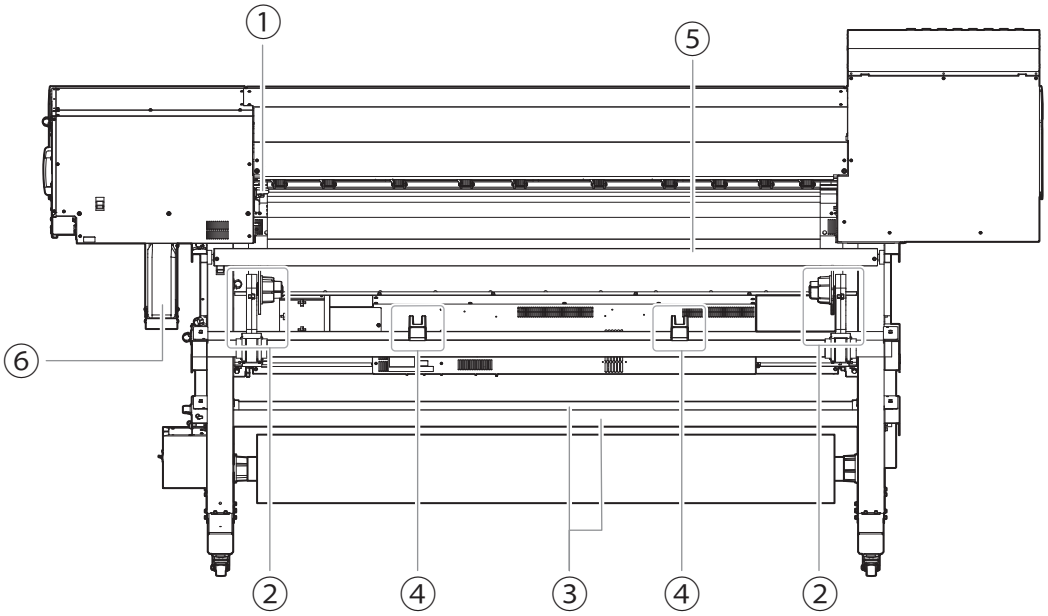
Printer Unit

Front



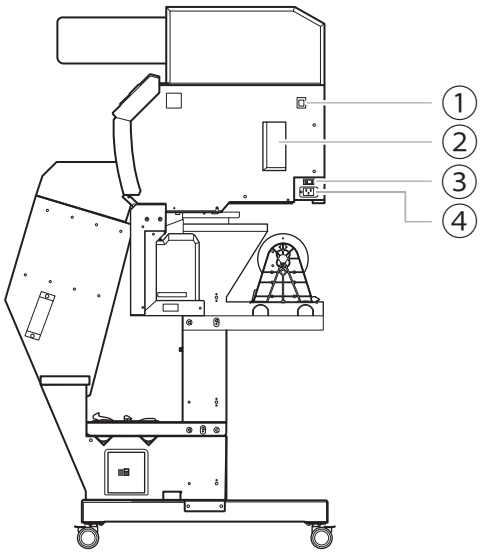
No.	Name	Function overview
①	Ink slots	Ink cartridges are inserted into these slots.
②	Front cover	Open this when necessary, such as when loading media. In all other situations, keep the front cover closed.
③	Loading lever (front)	Operate this when you load media.
④	Operation panel	The panel used to 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	Oven	Heats the media after printing. ⚠ WARNING **High Temperature** The inside and back of the oven, media immediately after it is heated by the oven, exhaust from the oven, and the hose close to the exhaust port all become hot. Exercise caution to avoid burns.
⑧	Take-up Unit	Takes up the media after heating or processing. P. 13 Take-up Unit

Rear



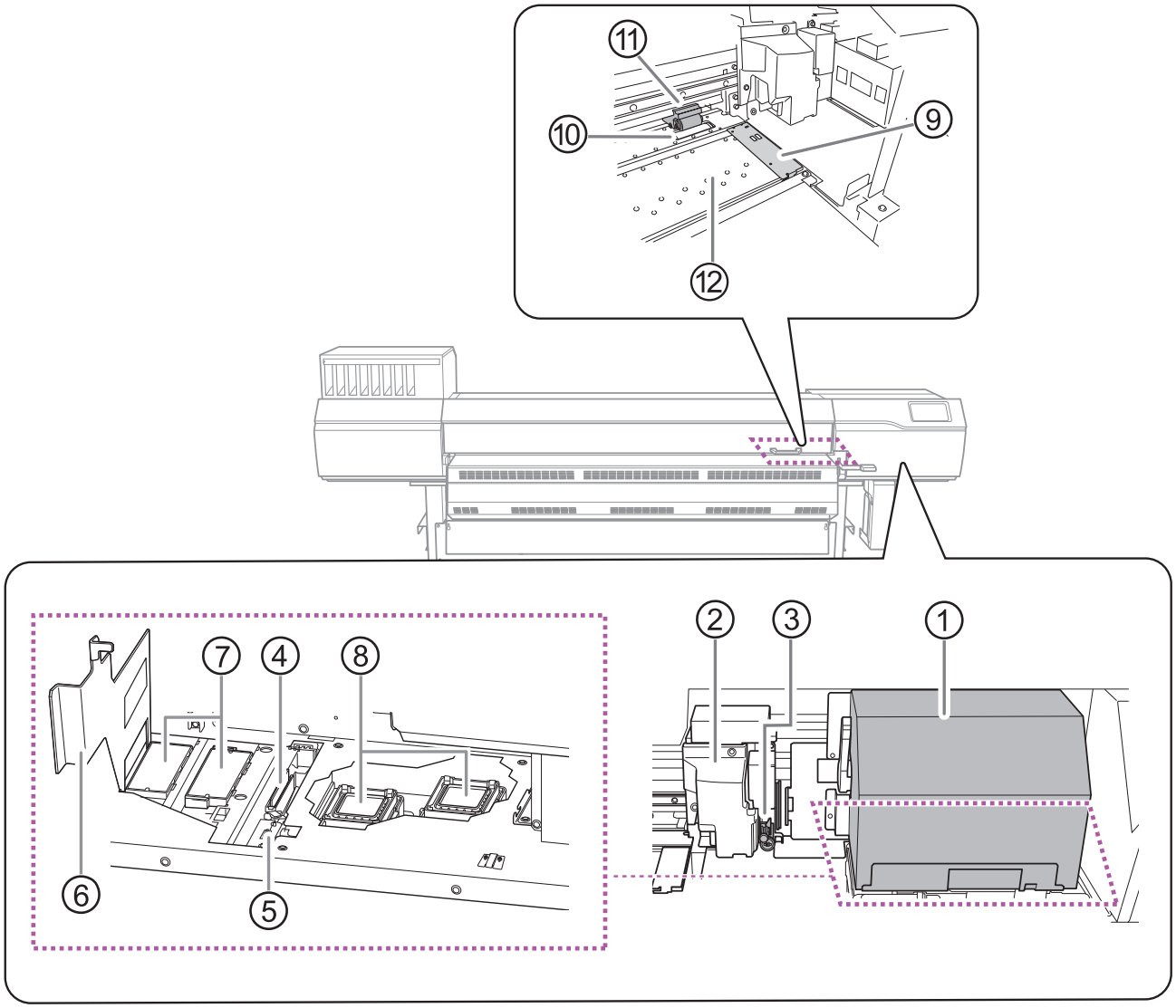
No.	Name	Function overview
①	Loading lever (rear)	Secures the media in place and releases it. Use this lever when working at the back of the machine. Lowering the lever secures the media in place.
②	Media holders	Hold the roll media. Fit the paper tube of the media onto the end caps of the media holders.
③	Shafts	Used to adjust the positions of the media stays and media holders. The media stays and media holders are moved to the left or right along these shafts to match the width of the media.
④	Media stays	Temporarily hold the roll media in place. Temporarily place the roll media on these stays when loading this media on the media holders.
⑤	Rear tension bar	This bar is used to maintain a constant tension in the media from the roll to the take-up unit.
⑥	Drain bottle	Discharged fluid is stored in this bottle.

Side



No.	Name	Function overview
①	Ethernet connector	Use this to connect an Ethernet cable.
②	Cleaning liquid slot	Use this to insert the cleaning cartridge.
③	Main power switch	Switches the main power on or off.
④	Power-cord connector	Use this to connect the power cable.

Front Cover Interior/Print Head Area



No.	Name	Function overview
①	Print-head carriage	The print heads are inside here.
②	Sub carriage	Moves independently of the print-head carriage, for example when setting the base point.
③	Separating knife (for the media)	This separates the media.
④	Wiper	Cleans the print heads. Removes dirt and excess ink that have adhered to these heads.
⑤	Wiper cleaner	Removes ink and dirt that have adhered to the wiper.

No.	Name	Function overview
⑥	Flushing cover	Open this cover when cleaning around the print heads and when replacing the flushing sponge. Leave this cover closed when not cleaning around the print heads or replacing the flushing sponge.
⑦	Flushing sponges	Absorb ink flushed from the print heads. (Flushing refers to the act of discharging a small amount of ink from the print heads to prevent ink discharge issues caused by ink clogging. The sponges used to receive the ink discharged during flushing are called the flushing sponges.) In the figure, the right side is for the CMYK ink print heads, and the left side is for the structural ink print heads.
⑧	Print head caps	Prevent the print heads from drying out. Seals to the print heads to protect the ink emission surface when the print heads are at the right side of the machine, such as when waiting for printing. In the figure, the right side is for the CMYK ink print heads, and the left side is for the structural ink print heads.
⑨	Media clamp	This clamps the left and right edges of the media. Each clamp holds down the left or right edge of the media, keeping the media from coming loose and preventing fuzz on the cut edge of the media from touching the print heads.
⑩	Grit roller	Transports the media.
⑪	Pinch roller	Each pinch roller is lowered/raised according to the operation of the loading levers. Lowering a loading lever lowers the pinch rollers, clamping the media.
⑫	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.

RELATED LINKS

- P. 11 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 printer's temperature has fallen below the temperature in which operation is possible. If this error is not addressed, the printer may malfunction.
[High Temperature Error]	The printer's temperature has risen above the temperature in which operation is possible. If this error is not addressed, the printer may malfunction.
[Pump Stop Error]	An ink cartridge was pulled out during cleaning or another operation where ink was absorbed, and the cartridge remained outside the machine. If this error is not addressed, the printer may malfunction.
[Take-up Unit Communication Error]	There is no response from the take-up unit. The take-up unit may not be connected correctly.

Display screen	Error overview
[Oven Error]	The oven temperature has risen too high, the oven temperature is not increasing, or power is not supplied to the oven. Check the error details shown on the operation panel screen and take appropriate measures.
[Service Call]	An unrecoverable error or an error that requires a part replacement has occurred.

RELATED LINKS

- P. 176 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.

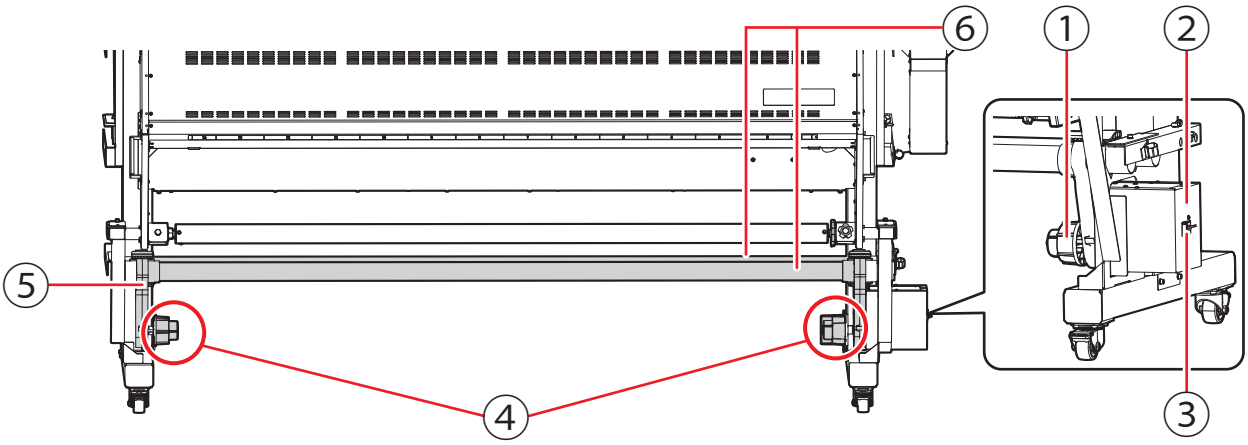
When the cover is closed, you will be able to continue the operation.

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

RELATED LINKS

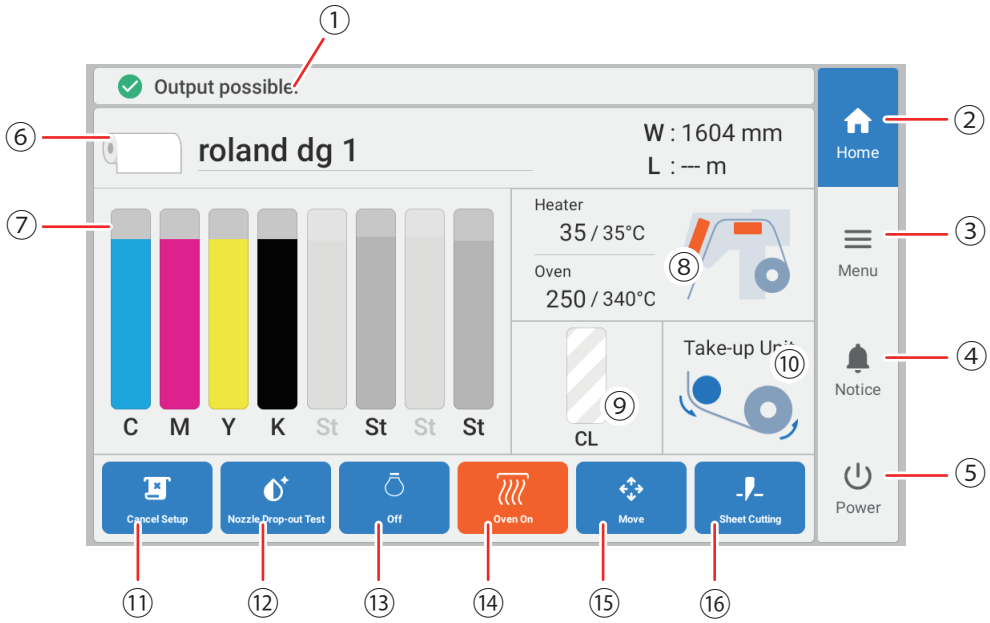
- P. 176 Error Messages

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	Control box	This controls the media take-up.
③	MANUAL switch	Used when taking up media manually.
④	End caps	These are used when loading the paper tube for take-up.
⑤	Left media holder	This is used when loading the paper tube for take-up.
⑥	Shafts	Adjust the position of the media holders. The media holders are moved to the left or right along these shafts to match the width of the media.

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)*1. 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. 105 Checking the Remaining Media
⑦	Amount of ink remaining	Displays the amount of ink remaining in each ink cartridge. If it is time to replace an ink cartridge, ! is displayed next to the corresponding cartridge. Tap this icon to display the detailed information for the ink.
⑧	Heater/oven temperature	The print heater and oven 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. • Setting the temperature of **[Oven]**.
⑨	Amount of cleaning liquid remaining	Displays the amount of cleaning liquid remaining. When the time for replacement arrives, ! is displayed.
⑩	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 Mode]** and **[Take-up Method]**.
⑪	**[Setup]**/**[Cancel Setup]**	Starts/cancels the setting up of the media. P. 26 Setup of New Media P. 46 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.

No.	Name	Details
⑬	[Print light]/[Black Light]/[Off]	Switches the type of light that shines on the media close to the platen and turns the light off. To check the printing status of CMYK ink, select [**Print light**]. To check the printing status of structural ink, select [**Black Light**].
⑭	[Oven on]/[Oven off]	Operates the power supply of the heating unit (oven) for the foaming media.
⑮	[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. 102 Adjusting the Output-start Location
⑯	[Sheet Cutting]	Activates the separating knife to separate the media. To take-up media that is being heated and then separate it, select [**Feed + Sheet Cutting**].

*1 This information is only displayed when media and the amount of remaining media have been set.

Menu List

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

MEMO

[**Media Settings**] only appears when media has been set up.

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 print head height.
		[Batch Automatic Correction]		Adjustments are performed in the following order: [**Multi Sensor Adjustment**] then [**Media Gap Adjustment**].
		[Feed Correction]		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. 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 Temperature]	[Print Heater]		Switches the print heater on/off and changes the set temperature.
		[Oven]		Changes the temperature setting of the oven.
		[Advanced Oven Settings]		Changes the individual oven set temperatures. [**Advanced Oven Settings**] under [**Preferences**] appears.
	[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.
		[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.

Level 1	Level 2	Level 3	Level 4	Details
[**Media Management**]				Displays a list of registered media (up to 50 entries). The following operations are available. • Checking setting details in a list • Changing media names • Copying media settings • Deleting media settings
[**Cleaning**]	[**Printing Test**]			Before printing, use [**Nozzle Drop-out Test**] to check whether ink is discharged from the print heads correctly. If dot drop-out is present, perform cleaning appropriate for the severity of the drop-out. If faulty ink discharge cannot be improved, the problematic nozzle can be identified with [**Nozzle Mask Test**], making it possible to stop using this nozzle.
	[**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. [**Powerful Cleaning**] also has the effect of improving uneven colors. If the media has already been set up, the [**After cleaning, perform a printing test.**] menu appears. When this is turned on, a printing test is performed after 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.
	[**Cap Replacement**]			Replaces the print head caps, which are used to protect the print heads from drying out and from dust.
	[**Wiper Cleaner Replacement**]			Replaces the wiper cleaner used to wipe away dirt from the wiper.
	[**Flushing sponge**]			To replace the flushing sponges used to absorb the flushed ink, tap [**Execute**] next to [**Replacing the Flushing Sponges**]. To drip cleaning liquid on the flushing sponge used for CMYK ink, tap [**Execute**] next to [**Cleaning Liquid Replenishment**].
	[**Ink Renewal**]			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 and may damage the print heads, so do not perform it more than necessary.
	[**Light Choke Cleaning**]			Perform this operation when ink discharge issues or uneven colors are not resolved even after [**Ink Renewal**].
	[**Drain bottle**]			Use this menu to discard discharged fluid at any desired time, regardless of any notifications or errors.

Level 1	Level 2	Level 3	Level 4	Details
[Preferences]	[Embossing Light]			Select [On], [Off], or [AUTO] for the embossing light (the light that is near the take-up unit and is used to check the foaming status of the media after heating). Select [AUTO] to automatically turn the light on/off according to the status of the printer.
	[Take-up]	[Take-up Mode]		Select [On], [Off], or [AUTO] for the operation of the take-up unit.
		[Take-up Method]		Select either [Tension Winding] or [Slack Winding] for the media take-up method. These options result in either constant tension or a little slack during media take-up.
	[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.
	[Standby Heater Temperature]			Sets the heater temperature and oven temperature when media has not been set up.
	[Advanced Oven Settings]			Separately adjusts the temperature setting of the oven's built-in heater. The adjustment range is ±30°C (±54°F) in relation to the internal temperature setting.
	[Internal Temperature at the Start of Printing]			If the internal temperature of the oven is not the same as the set temperature, printing will not start even if print data is sent to the machine. When using media that does not foam if the internal temperature is too low, set this item.
	[Heating regulation due to the internal temperature of the oven]			At the start of heating, the temperature of the heater in the oven will be fine-tuned according to the temperature of the media. The temperature of the media at the start of heating varies according to the internal temperature of the oven and the thermal conductivity of the media.
	[Ink Empty Mode]			This menu lets you determine the operation that takes place when an ink cartridge becomes empty during printing. The print quality will be affected by the selected operation.
	[Notifications On/Off]			When this is set to on, notifications are displayed at the appropriate times. • [Media Clamp Placement Notification]
	[Sleep Time]			Sets the time until sleep mode (the state in which the power-saving features operate) activates.
	[Stopping the Warning Beep]			Sets the duration of the warning beep that sounds when, for example, an error occurs.
	[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 unit] and [Temperature unit].
	[Language]			Sets the language.
	[Date/Time]			Sets the current year, month, day, hour, minute, and second.
	[Screen Appearance]			Selects the color scheme of the operation panel's screen.
	[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 media used by this machine is roll media, which is wound onto a paper tube or something similar.

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

Conditions for Usable Media

This machine cannot print on every kind of media. When selecting media, be sure to carry out testing in advance to make sure that satisfactory printing results are obtained.

Size

	DA-640
Width	259 to 1,625 mm*1 (10.2 to 64.0 in.)
Maximum media thickness (including backing paper)	1.0 mm (39.37 mil)
Maximum roll outer diameter	180 mm (7.08 in.)
Paper tube (core) inner diameter	76.2 mm (3.0 in.) or 50.8 mm (2.0 in.)

*1 When using media with a width smaller than 275 mm (10.82 in.), load the media with the media clamps removed.

Maximum Roll Weight

- 30 kg (66.2 lb.)

Other Conditions

Media such as the following cannot be used.

- Media that is severely warped or that has a strong tendency to reroll
- Media that cannot withstand the heat of the oven
- Media whose paper tube (core) is bent or crushed
- Media that bends under its own weight when loaded
- Media on a sagging roll
- Media that is rolled unevenly

RELATED LINKS

- P. 185 Maximum Printing Area and Margins

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.

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/).

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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

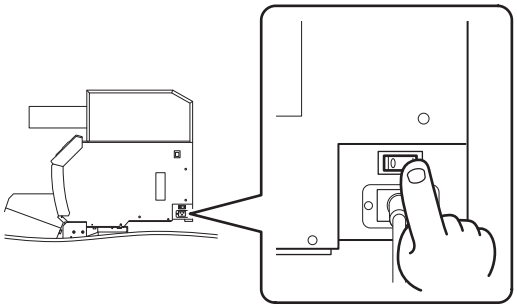
⚠ WARNING

Remove any loaded media or switch off the sub power when printing is not being performed.

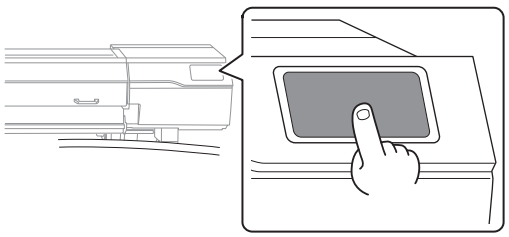
The continued application of heat at a single location may cause the release of toxic gases from the media or pose a fire hazard.

Procedure

1. **Close the front cover.**
2. **Switch on the main power switch.**



3. **Tap the operation panel.**



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

Turning the Power Off

⚠ WARNING

Remove any loaded media or switch off the sub power when printing is not being performed.

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. **Tap [Sheet Cutting].**

2. **Tap [Execute] on the [Sheet Cutting] screen.**

   The media is separated from the roll.

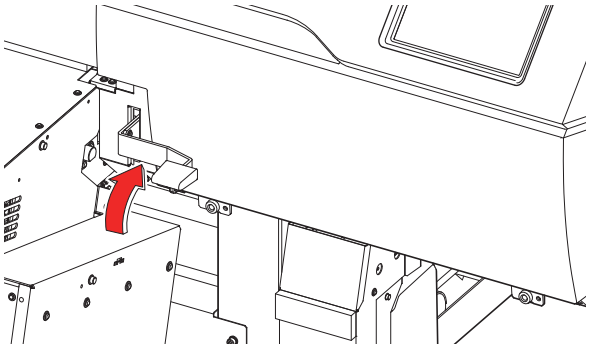
   ⚠ WARNING

   High Temperature

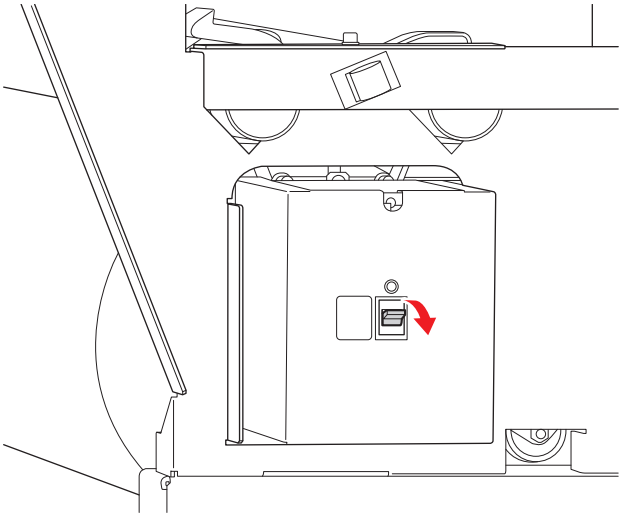
   Immediately after coming out of the oven, the separated media is very hot. Leave the media alone for at least 10 seconds, only touching it after it cools down.

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

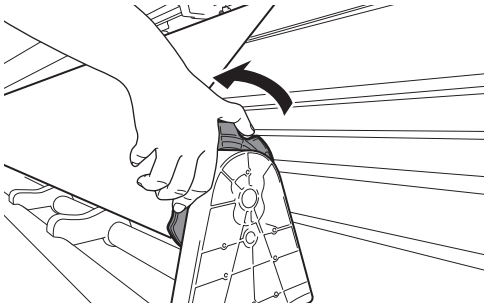
   (1) **Raise the loading lever.**

   (2) **Press the manual switch on the take-up unit to take up all the excess media.**

(3) **Hold the media holder flange on the back of the printer, turning this flange in the take-up direction to take up all the media fed out from the roll.**



(4) **Remove the media from the media holder and store the media.**

Store the media in a location with low humidity. You are recommended to implement countermeasures against moisture such as by covering the media with a vinyl sheet containing desiccant.

4. **Tap on the operation panel.**

The confirmation window appears.

5. **Tap [Yes].**

Cool the oven. The sub power switches off after the oven cools to the prescribed temperature.

Depending on the temperature of the oven, this cooling may take 10 minutes or more.

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

Setup of New 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 30 kg (66.2 lb.).
To avoid injury, handle the roll media with care.

⚠ CAUTION

Never load media that weighs over 30 kg (66.2 lb.).
The machine may fail to withstand the weight and tip over or cause the media to fall.

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.

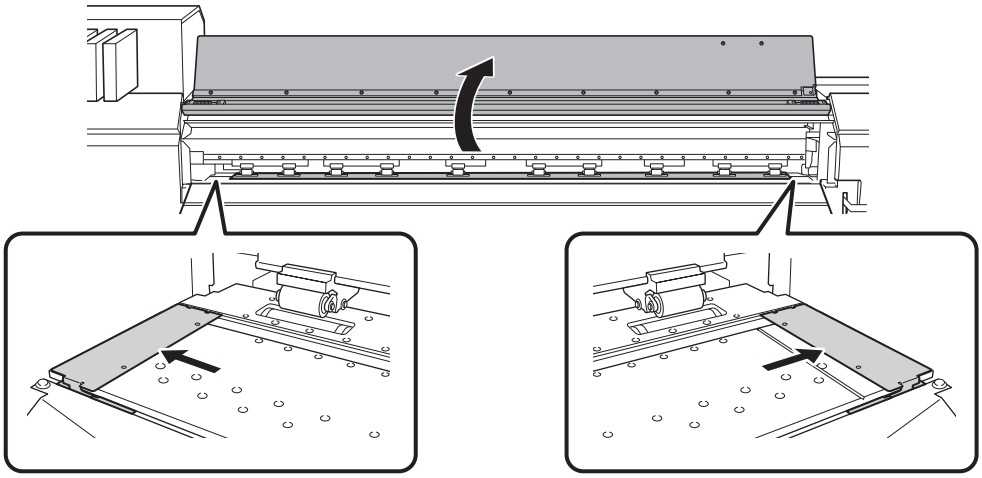
Procedure

1. **If the sub power is off, tap ⏻ on the operation panel.**

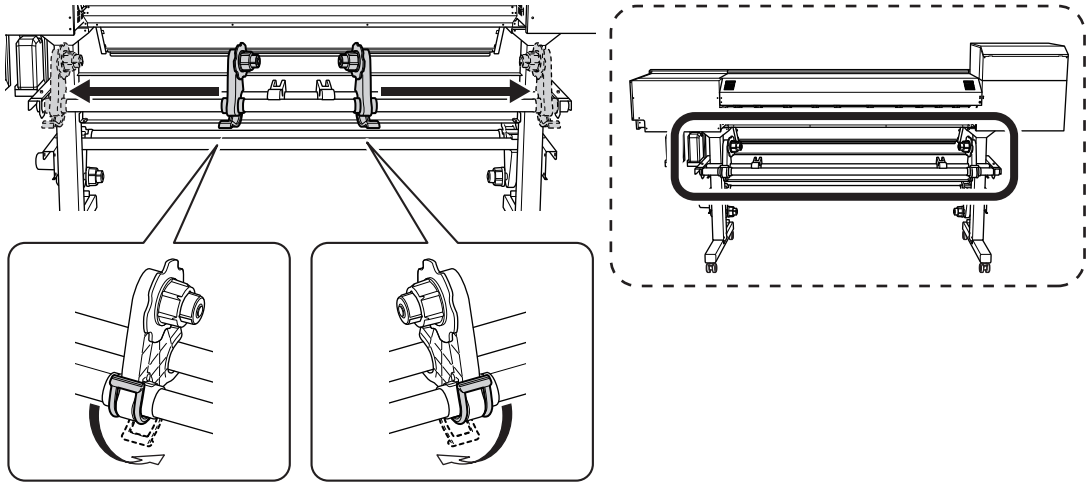
   The sub power is switched on.

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

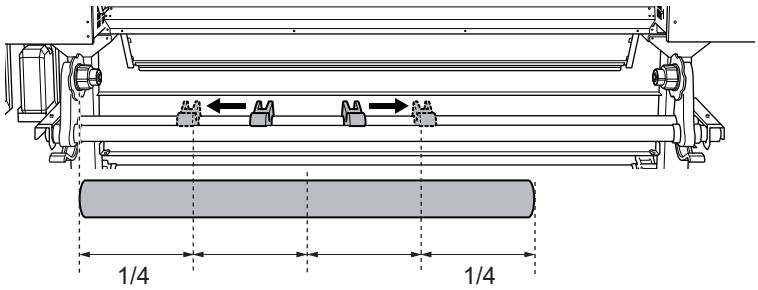


5. **Place the media on the machine.**

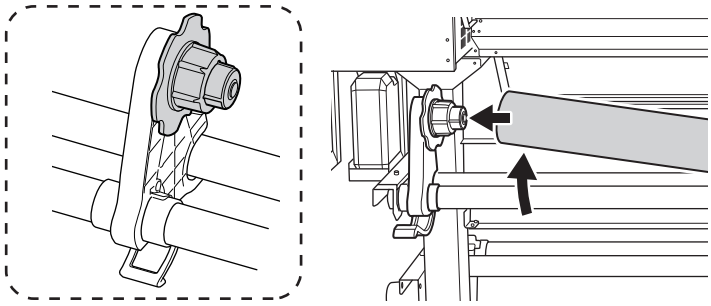
IMPORTANT

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

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.

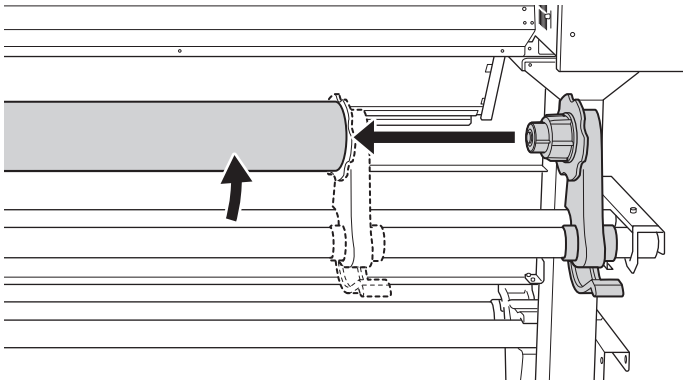


6. **Fit the paper tube (core) of the media onto the end cap of the left media holder.**



7. **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: A: Determine the positions of the media (opaque media).(P. 29)
- Transparent media, etc.: B: Determine the positions of the media (transparent media, etc.).(P. 33)

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].**

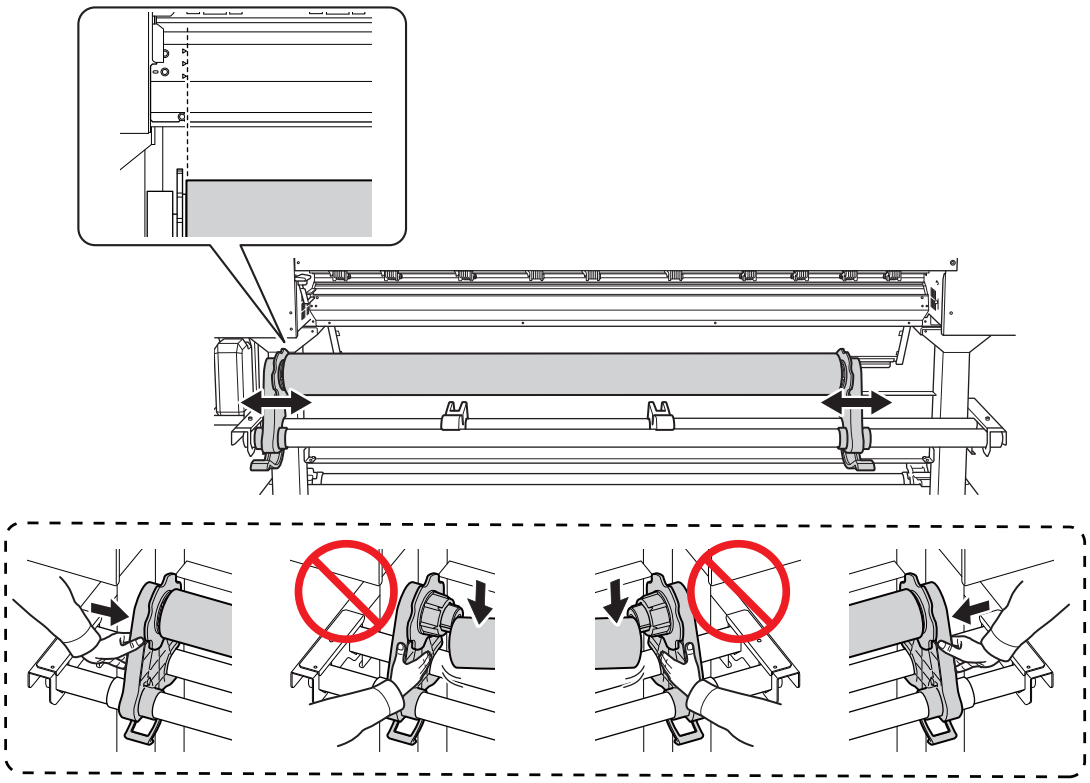
(4) **Tap** ⌂.

The home screen appears.

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.



⚠ WARNING

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

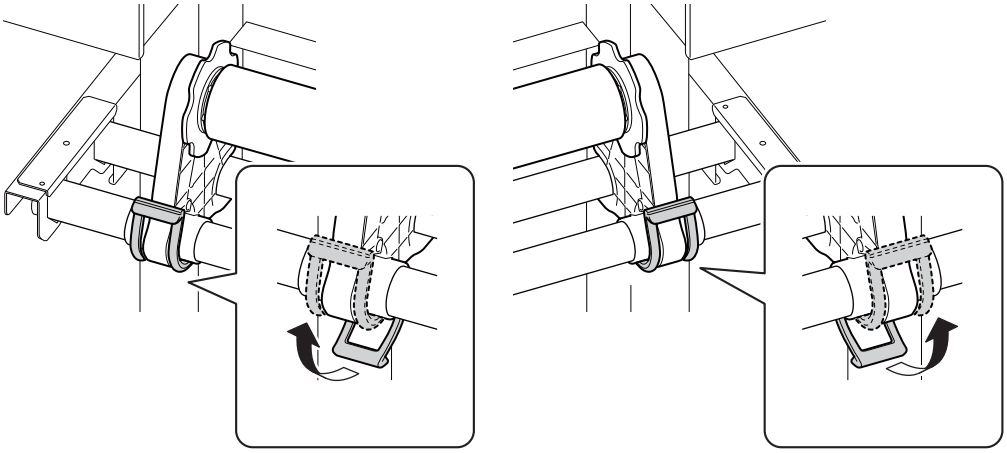
Doing so may cause the media to fall off the media holder and cause injury.

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.**



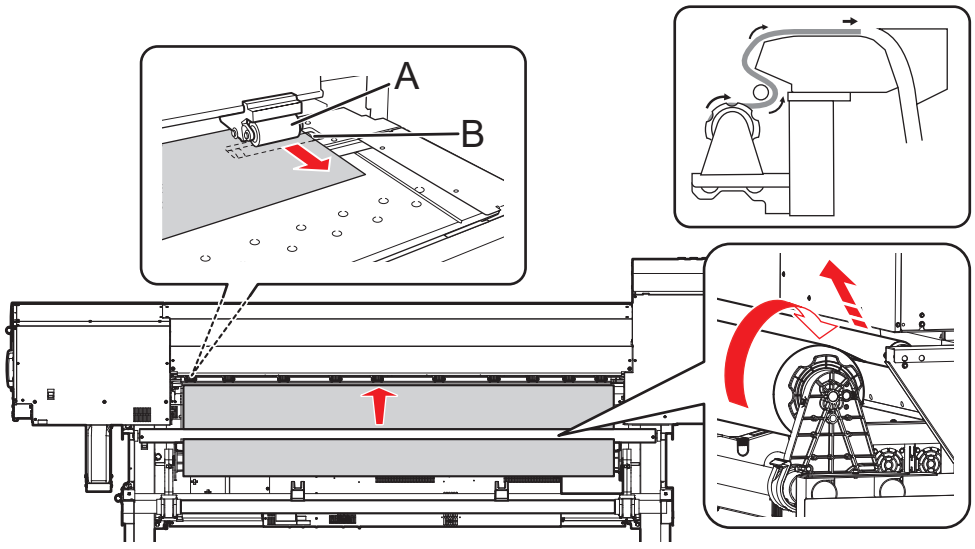
4. **Use the following procedure to load the media.**

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 oven entrance.

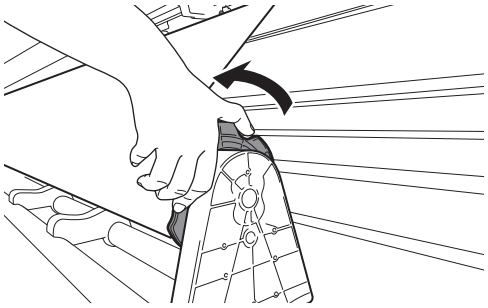
(1) **Pass the leading edge of the media through the back of the rear tension bar and between the pinch roller (A) and the grit roller (B).**



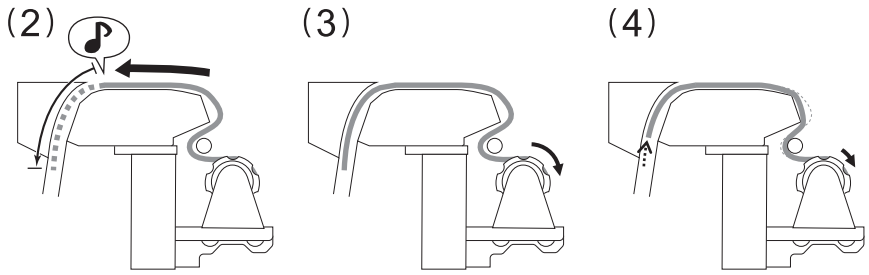
(2) **Feed the media until you hear a beep, and then additionally feed approximately 30 cm (11.81 in.) of the media.**

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.**



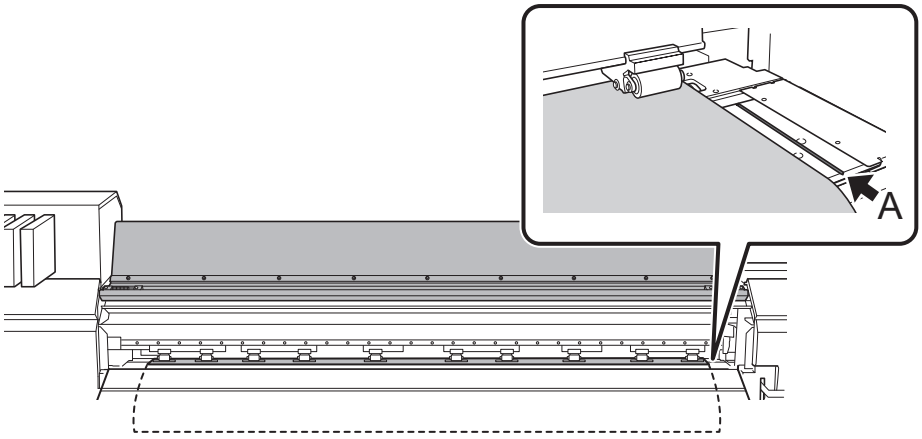
(4) **Once the media is taut, additionally take up approximately 10 cm (3.94 in.) of media.**



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).**

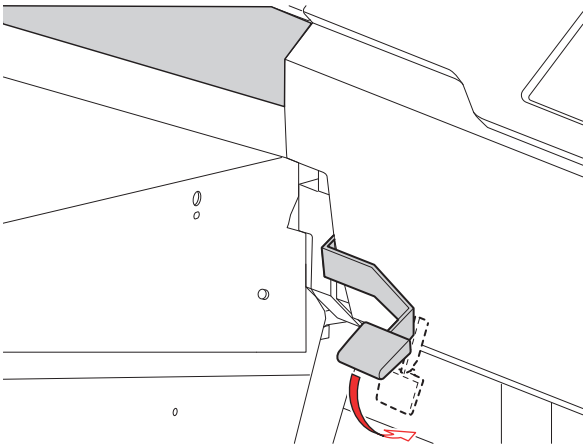


IMPORTANT

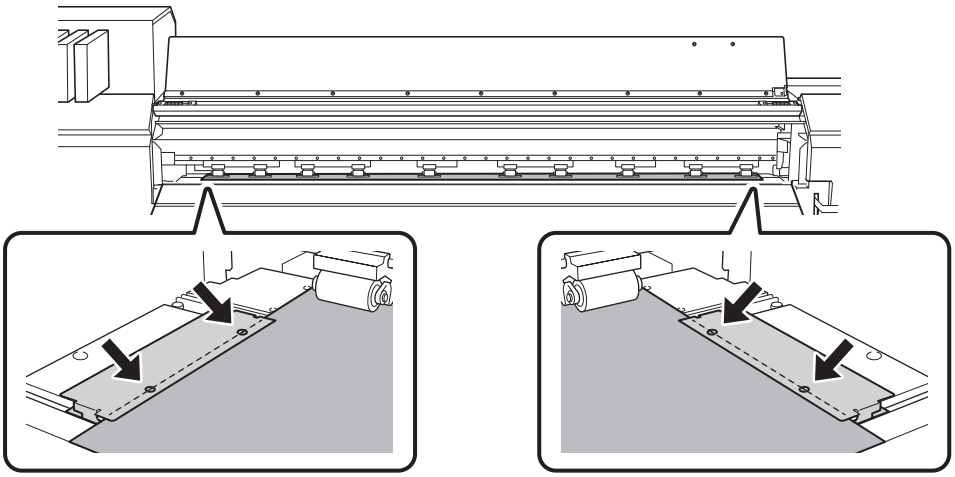
If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from step 1. If you just stand at the front of the printer and hold the media to readjust its position forcibly, the media will be skewed during printing or will come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

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].**

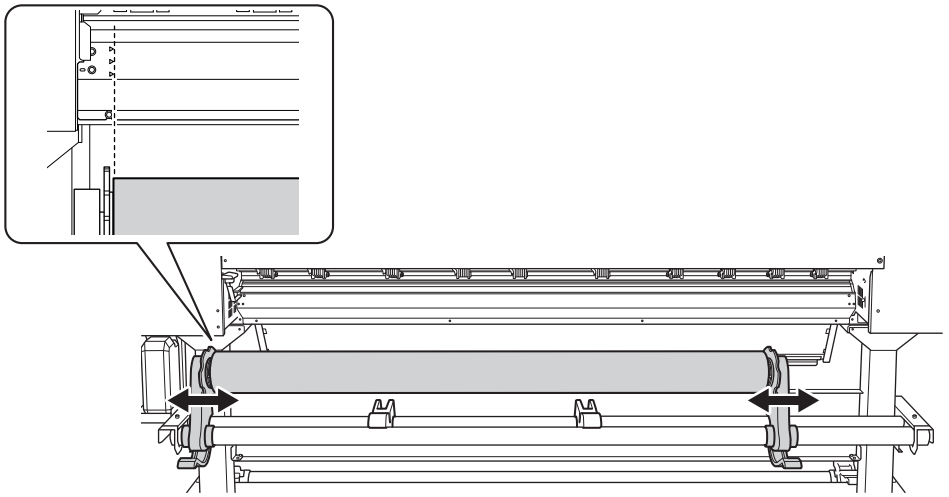
(4) **Tap** ⌂.

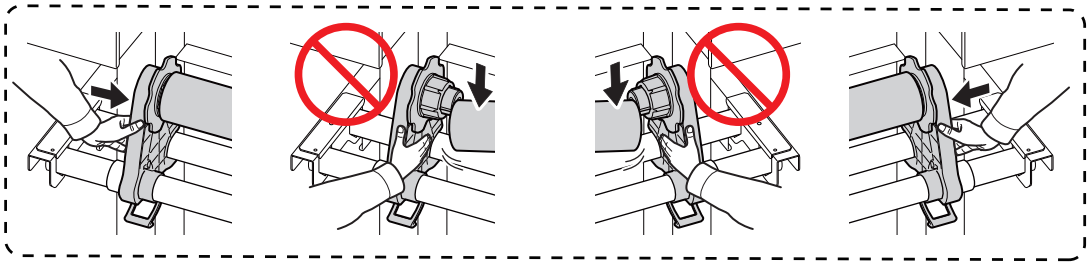
The home screen appears.

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.





⚠ WARNING

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

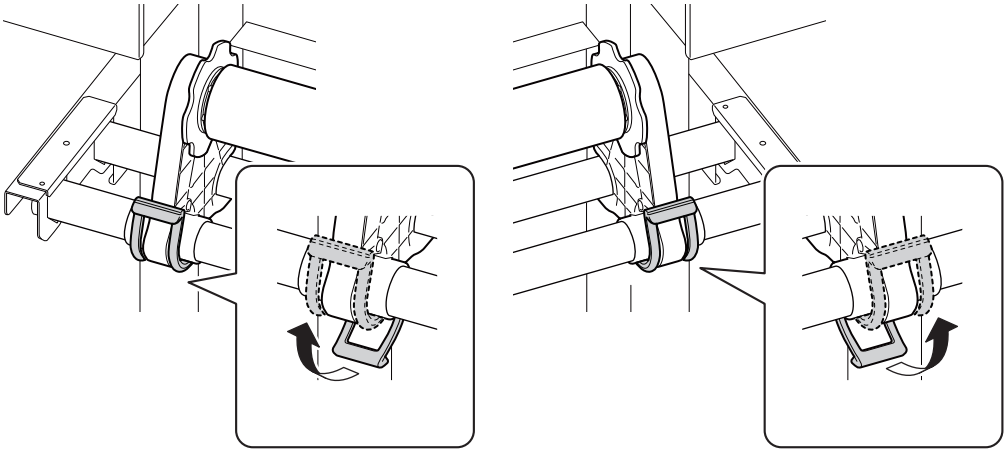
Doing so may cause the media to fall off the media holder and cause injury.

IMPORTANT

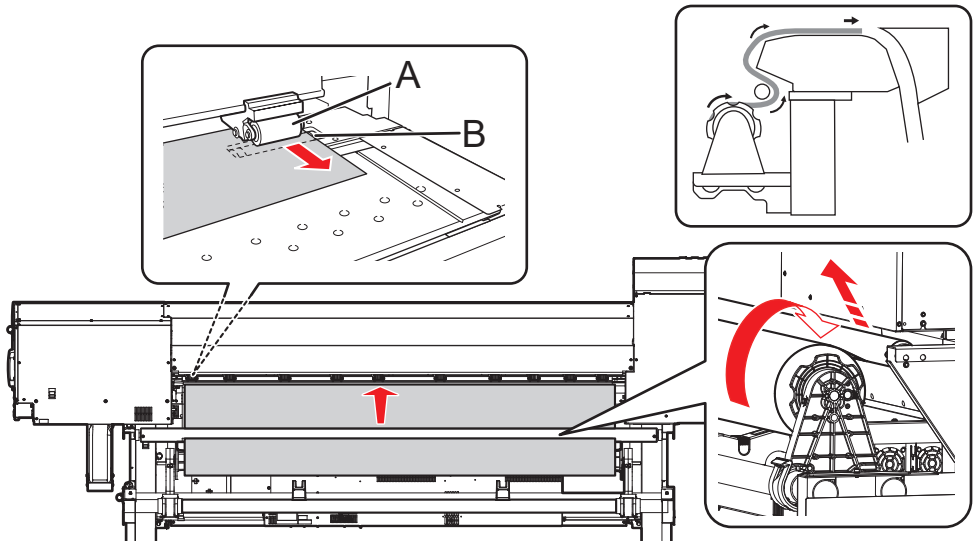
Firmly decide the left and right side positions of the media at this point.

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.**

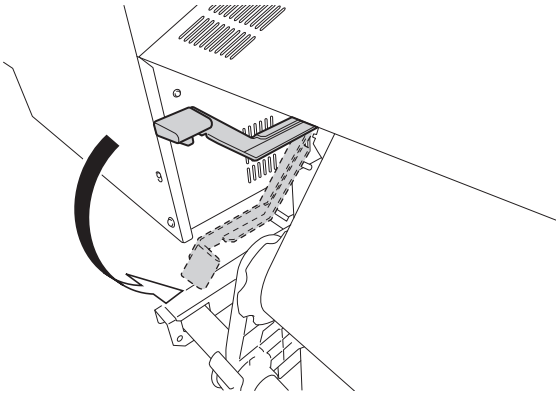


4. **Pass the leading edge of the media through the back of the rear tension bar and between the pinch roller (A) and the grit roller (B).**

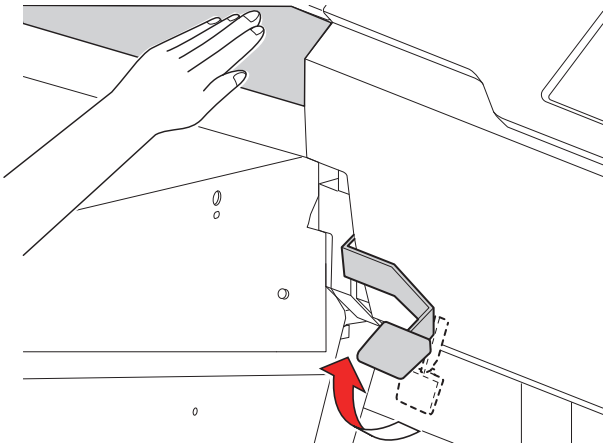


5. **Lower the loading lever (rear).**

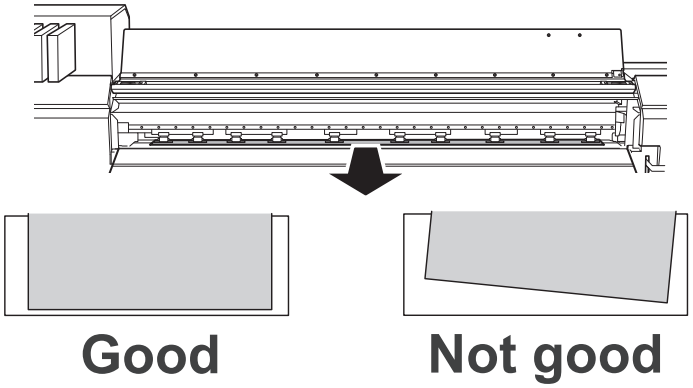
The media is held in place.



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

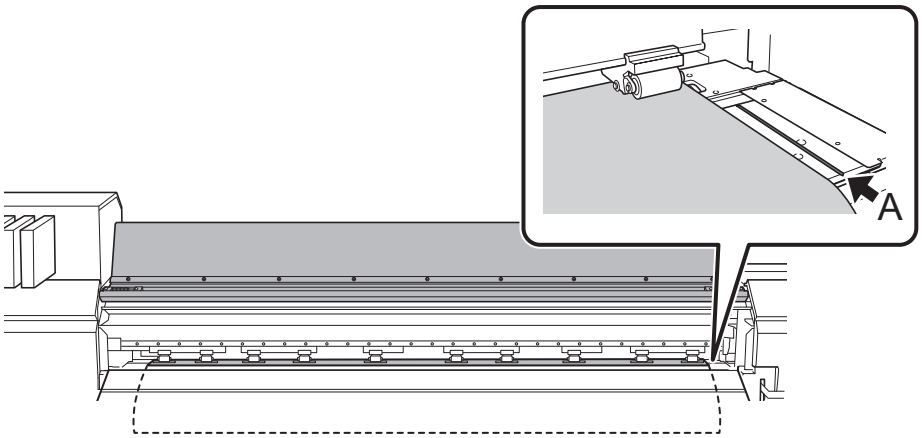


7. **Hold the media at the center and pull it out, being sure to keep it straight and all areas of the media to be taut.**



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

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

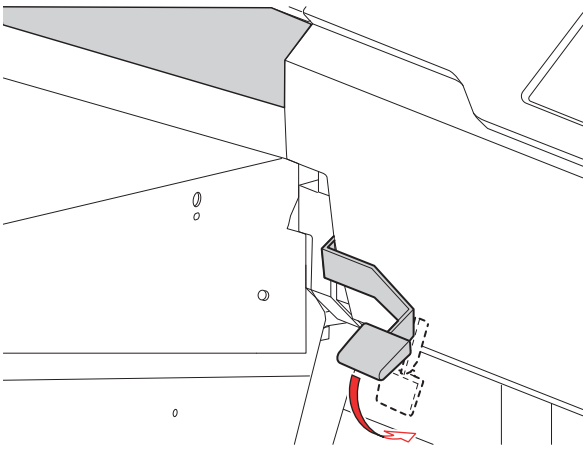


IMPORTANT

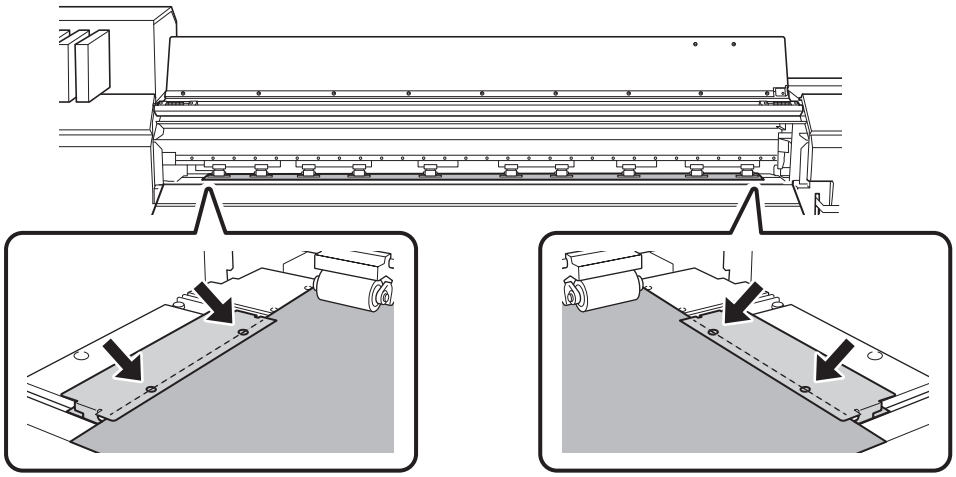
If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from step 1. If you just stand at the front of the printer and hold the media to readjust its position forcibly, the media will be skewed during printing or will come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

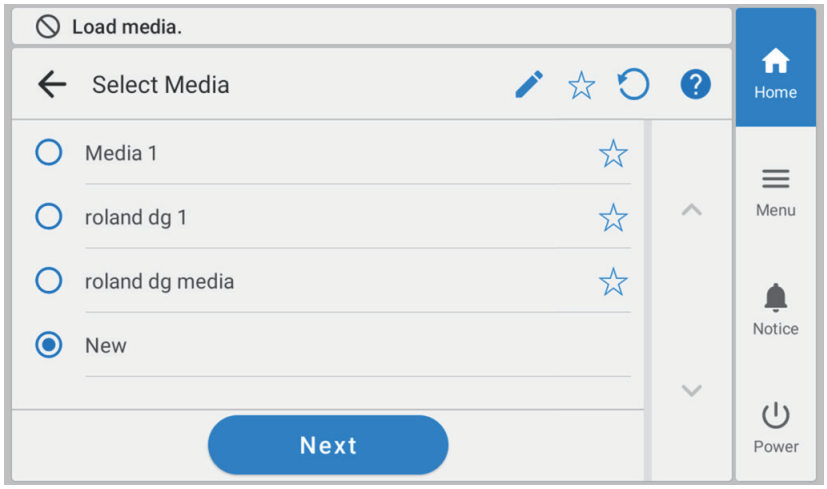
If you attach the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

12. **Close the front cover.**

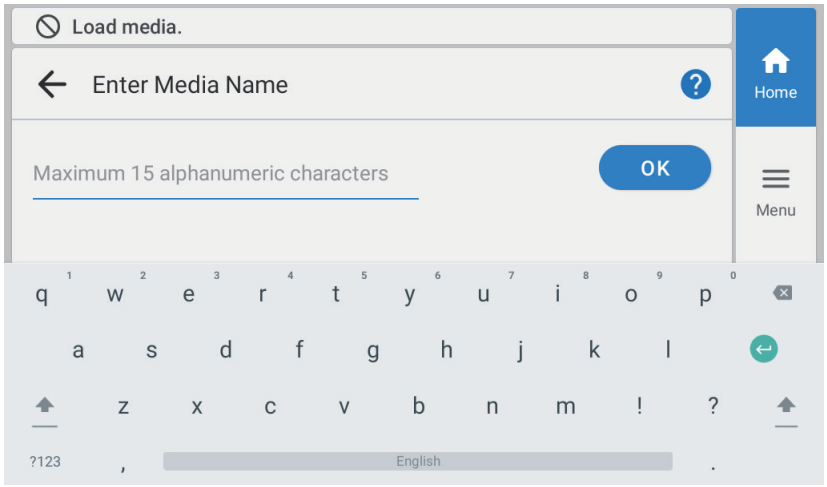
Register the media.

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. **Tap [Next].**

9. **Tap [Start Setup].**

Load the media in the take-up unit.

Procedure

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

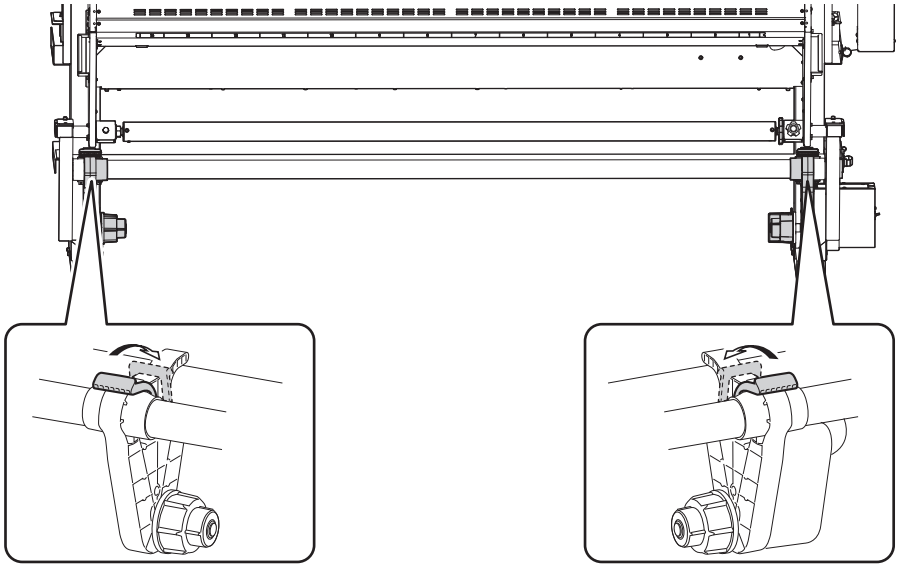
Prepare a paper tube wider than the media that has been set up.

IMPORTANT

Paper tubes are consumable items.

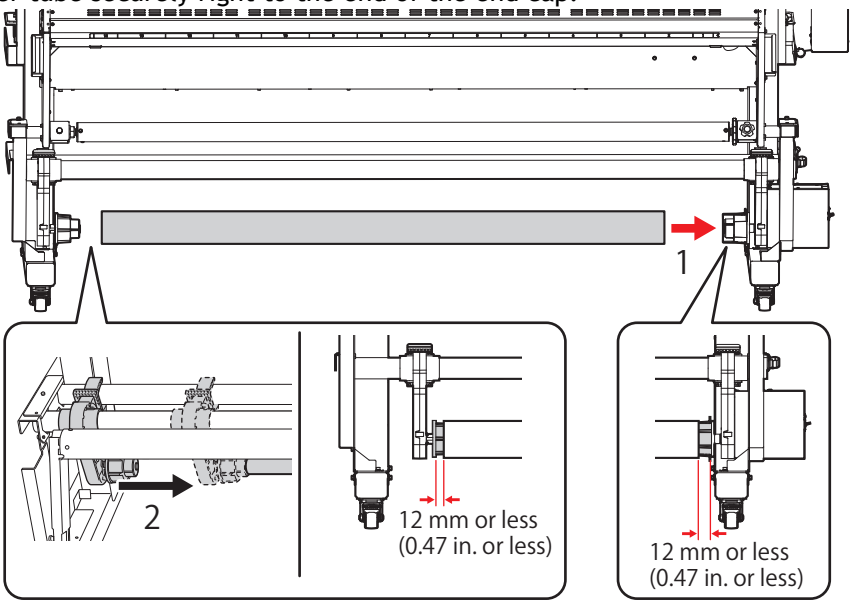
Watch the condition of the paper tube and replace at an appropriate time so that the media can be taken up in good working order.

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



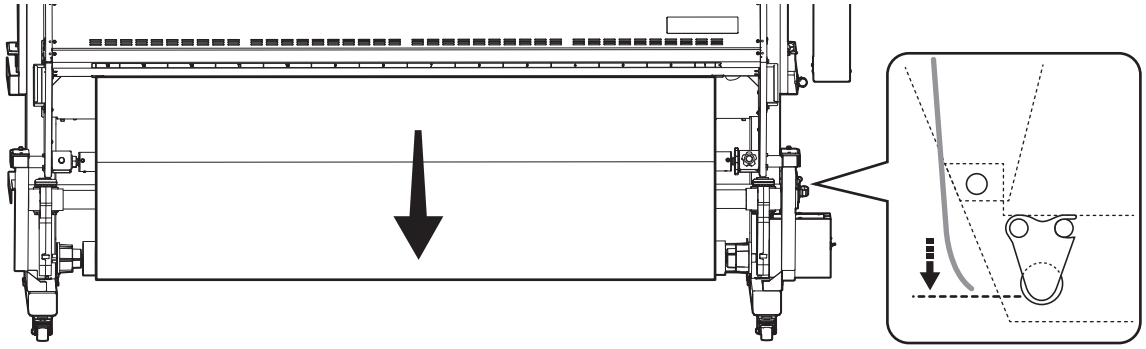
(2) **Fit the paper tube onto the right end cap, and then push the left media holder into the paper tube.**

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



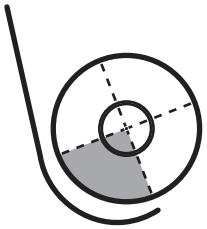
2. **Hold down ⌄ on the operation panel to feed out the media until the tip of the media reaches the paper tube.**

Media is fed out 30 mm (1.18 in.) each time you press this button. Holding down the button lets you feed out paper continuously.



MEMO

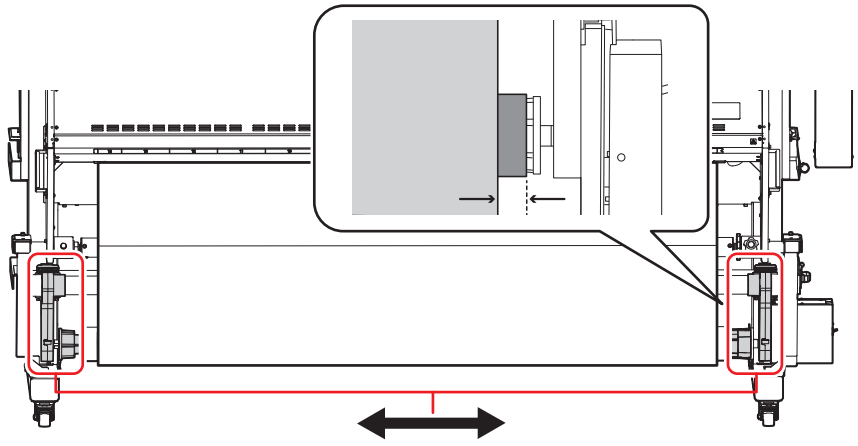
Feed out the media until it can wrap around at least 1/4 of the paper tube.



3. **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 both edges of the media.**

Hold the media holders from the outside and move them.



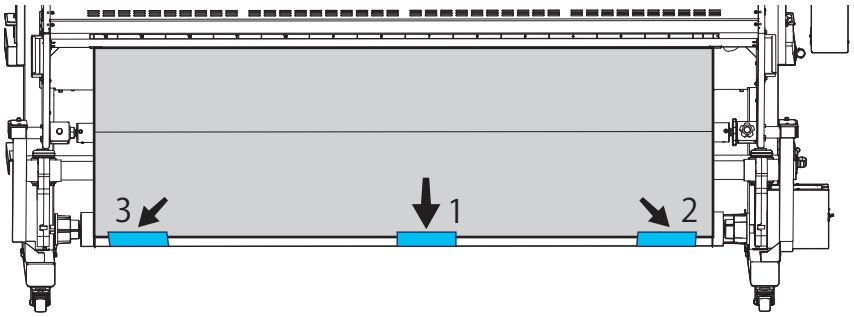
(2) **Secure the left and right media holders.**

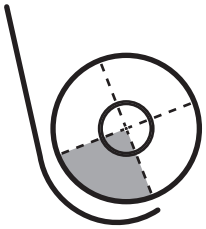
4. **Follow the procedure below to secure the media on the paper tube.**

Secure the media in place so it is fed forward.

(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.**

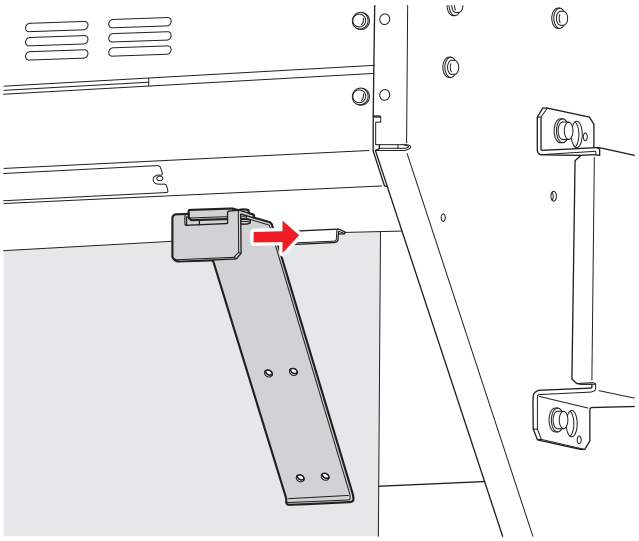




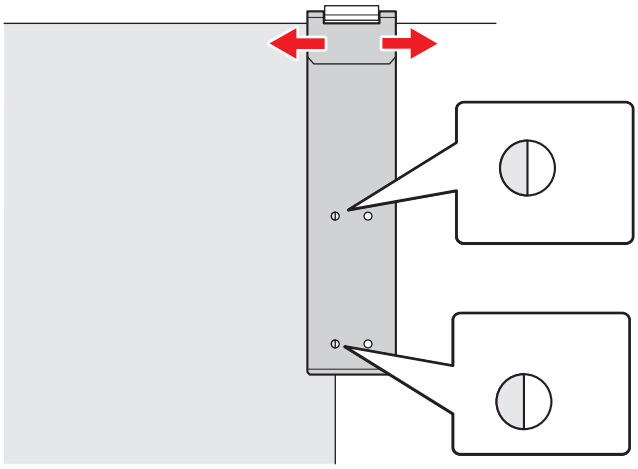
5. Tap [OK].

6. Attach the media guide near the right end of the media.

(1) Press the media guide against the notch in the figure, and then use the magnet to secure the guide against the top plate.

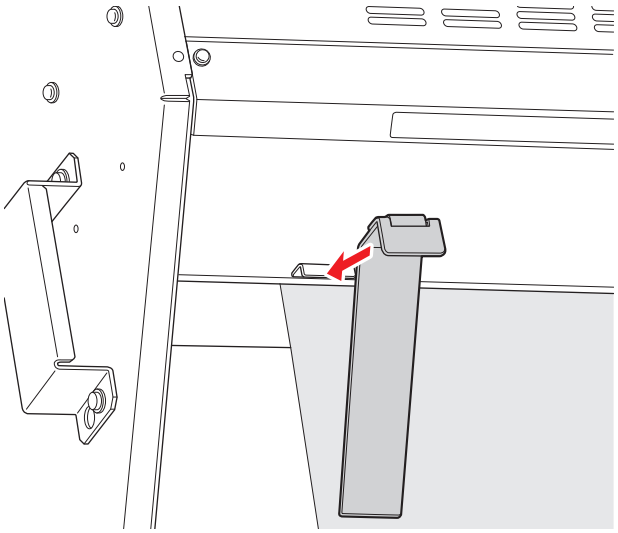


(2) Slide the media horizontally until its right end is positioned to pass through the holes on the left side of the media guide.

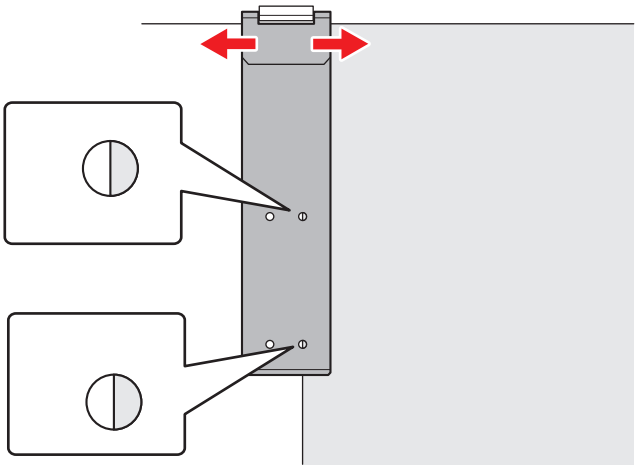


7. In the same manner, attach the media guide near the left end of the media.

(1) Press the media guide against the notch in the figure, and then use the magnet to secure the guide against the top plate.



(2) Slide the media horizontally until its left end is positioned to pass through the holes on the right side of the media guide.



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. Use [Heater Temperature] to set the temperatures of the print heater and oven.

(1) **When you are using the print heater, tap [Print Heater] to turn it on.**

With the print heater on, tap − or + to set the temperature.

(2) **Tap − or + next to [Oven] to set the temperature.**

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

2. 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. Check that the print head has stopped moving, and then 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. 87).

3. On the [Nozzle Drop-out Test] screen, configure the [Printing Test] and [Output Start Location] settings.

- If this is not necessary, tap [**Next**].
- To perform a [**Printing Test**], tap [**Printing Test**]>[**Execute**].

For details on what to do after the printing test, refer to Performing Normal Cleaning(P. 129).

4. On the [Select Media Adjustment Method] window, 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 [**Feed Correction**] screen appears.

  For more information, refer to Automatically Making Required Adjustments(P. 83).

  When automatic adjustment is performed, feed correction is not performed. If you want to perform feed correction, perform the following manual adjustments.
- **Follow the procedure below to make manual adjustments.**
  a. Tap [**Detailed Correction (Manual)**]>[**Next**].

b. Tap [**Execute**] on the [**Multi Sensor Adjustment**] screen.

c. Tap [**Next**].

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

   Set the correction values from the printing test result. For more information, refer to Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)(P. 85).

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

f. Perform a printing test on the [**Feed Correction**] screen.

   Set the correction values from the printing test result. For more information, refer to Manual Adjustment: Reducing Horizontal Bands (Feed Correction)(P. 83).

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

This completes the setup of the media.

Setup of Registered 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 30 kg (66.2 lb.).
To avoid injury, handle the roll media with care.

⚠ CAUTION

Never load media that weighs over 30 kg (66.2 lb.).
The machine may fail to withstand the weight and tip over or cause the media to fall.

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.

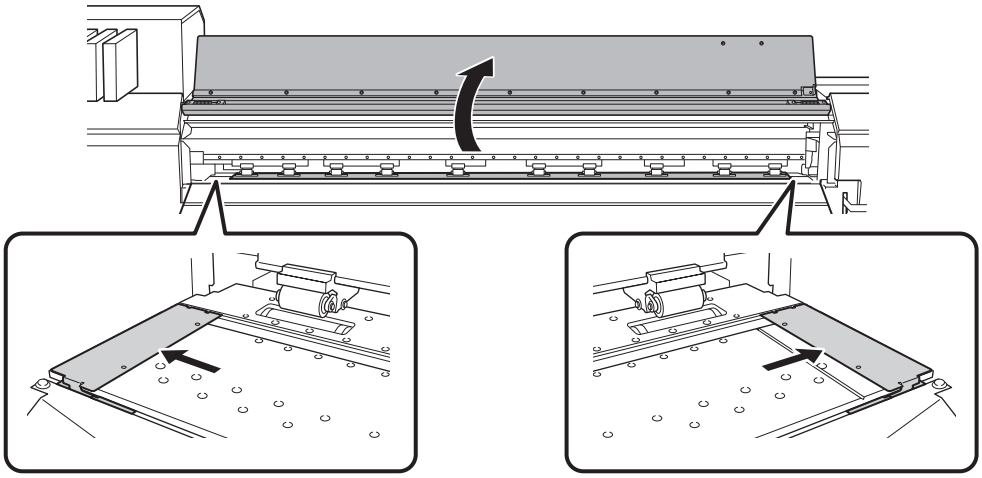
Procedure

1. **If the sub power is off, tap ⏻ on the operation panel.**

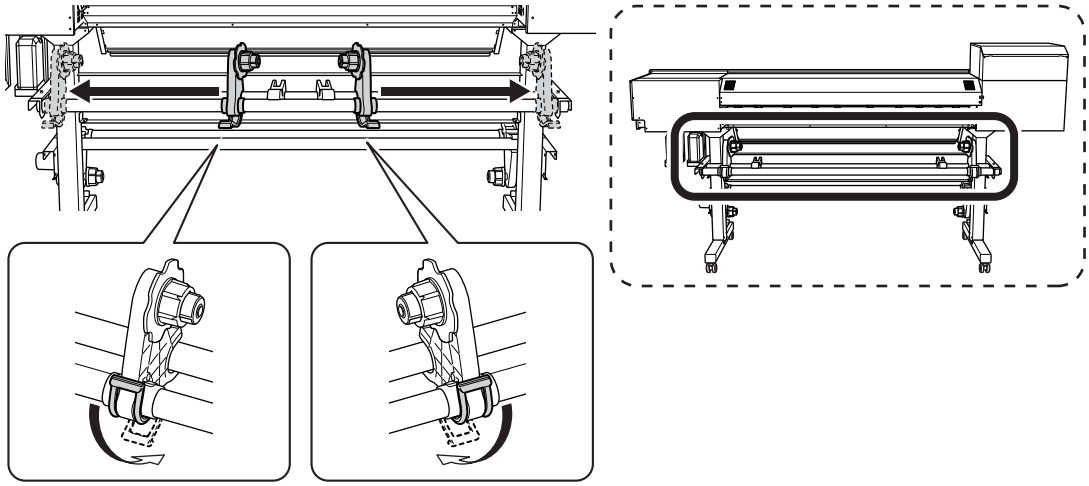
   The sub power is switched on.

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

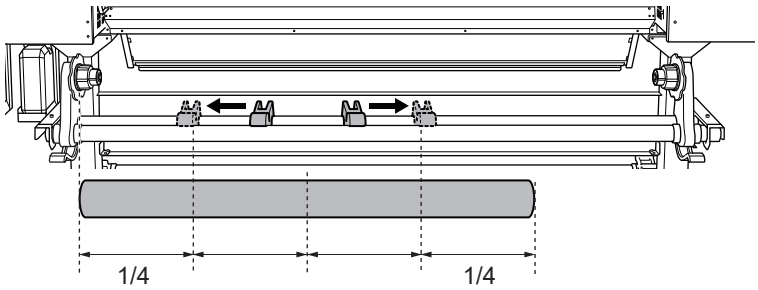


5. **Place the media on the machine.**

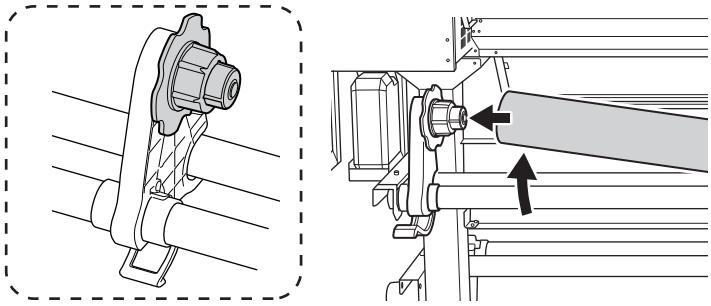
IMPORTANT

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

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.

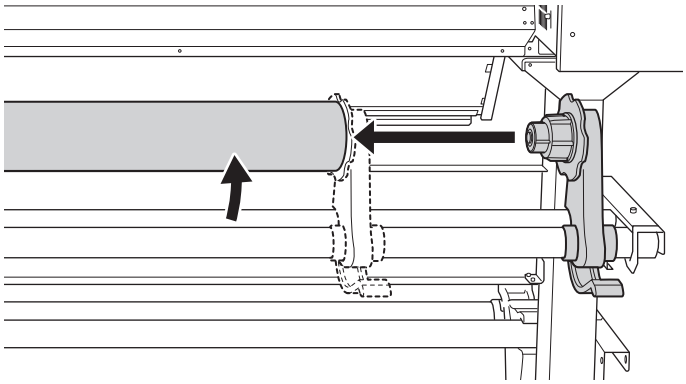


6. **Fit the paper tube (core) of the media onto the end cap of the left media holder.**



7. **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: A: Determine the positions of the media (opaque media).(P. 49)
- Transparent media, etc.: B: Determine the positions of the media (transparent media, etc.).(P. 53)

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].**

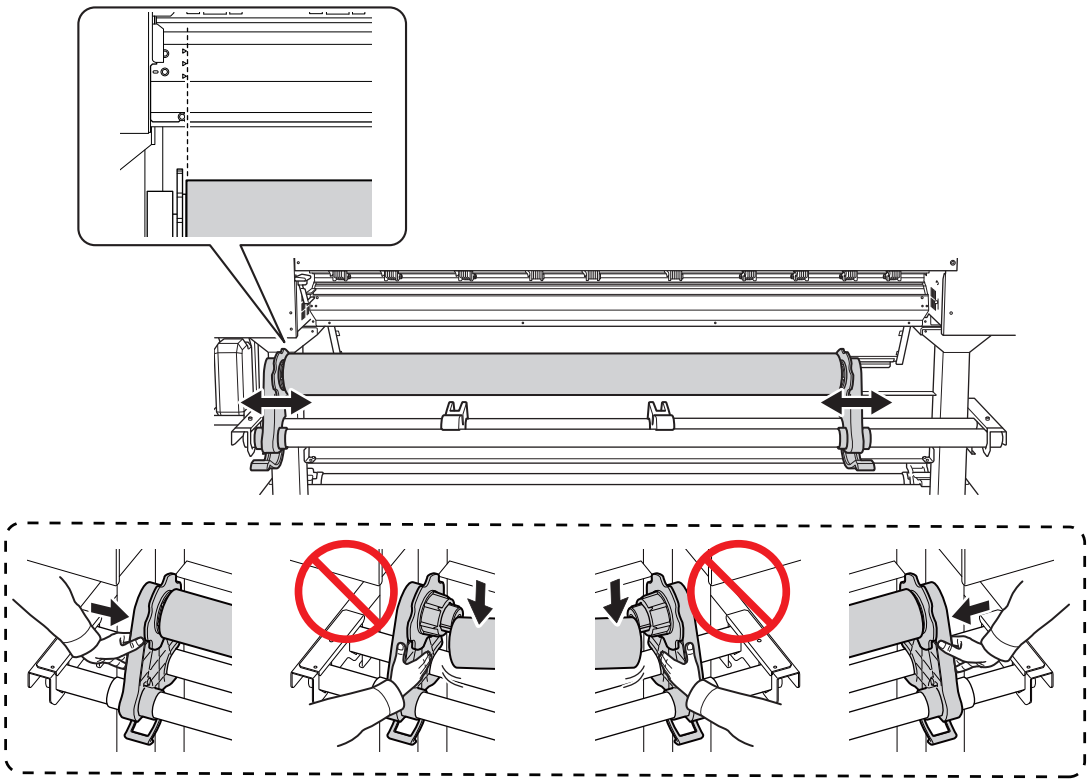
(4) **Tap** ⌂.

The home screen appears.

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.



⚠ WARNING

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

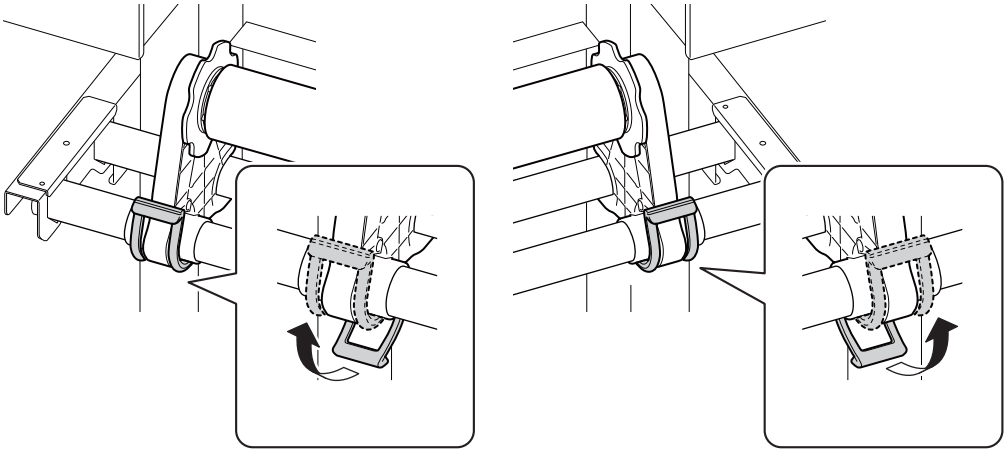
Doing so may cause the media to fall off the media holder and cause injury.

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.



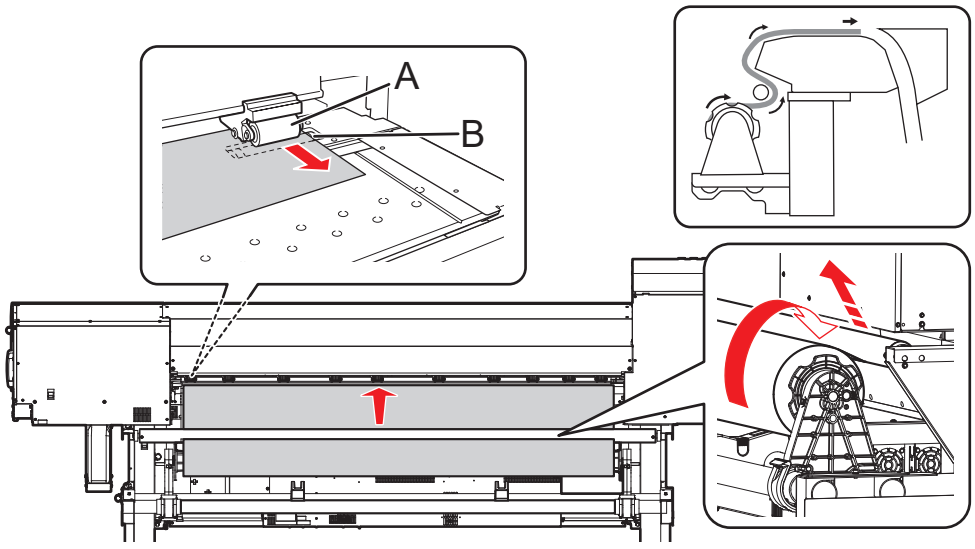
4. Use the following procedure to load the media.

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 oven entrance.

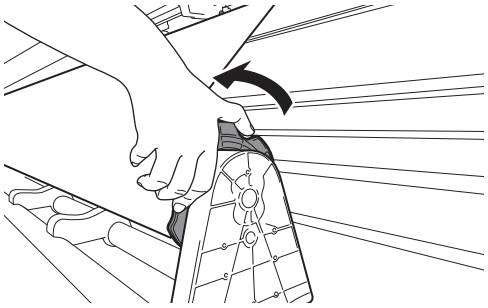
(1) **Pass the leading edge of the media through the back of the rear tension bar and between the pinch roller (A) and the grit roller (B).**



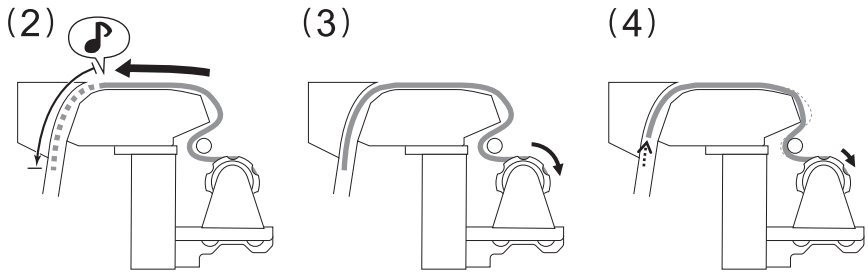
(2) **Feed the media until you hear a beep, and then additionally feed approximately 30 cm (11.81 in.) of the media.**

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.**



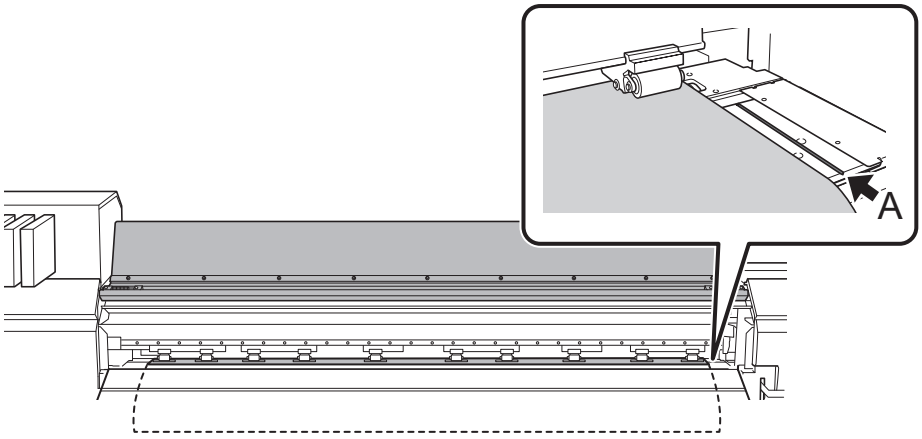
(4) **Once the media is taut, additionally take up approximately 10 cm (3.94 in.) of media.**



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).**

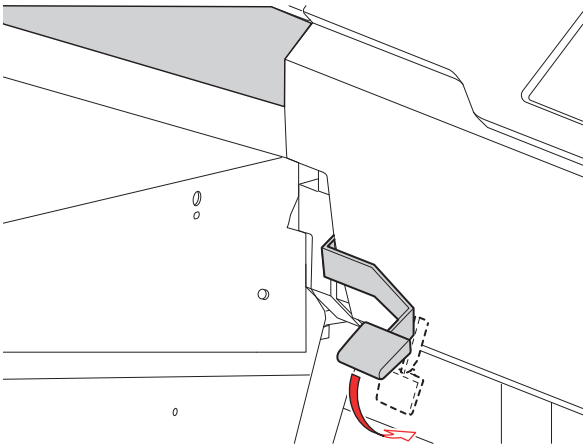


IMPORTANT

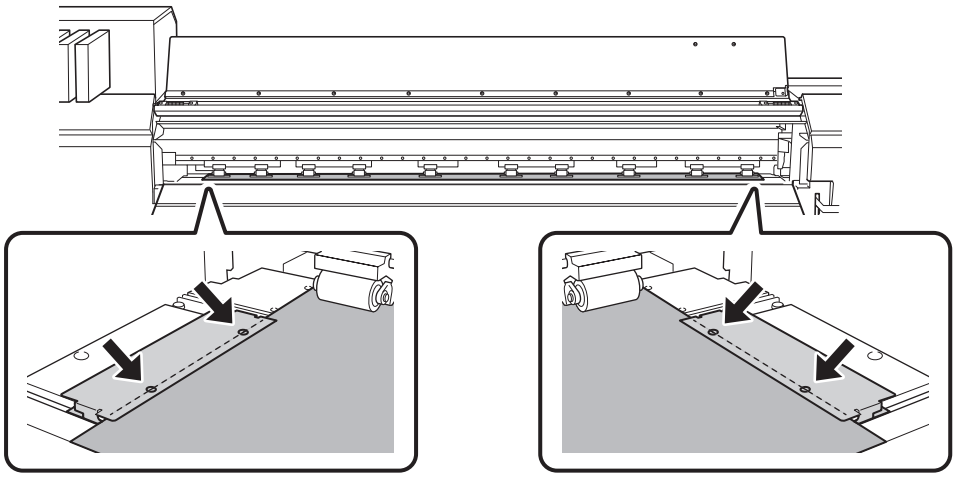
If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from step 1. If you just stand at the front of the printer and hold the media to readjust its position forcibly, the media will be skewed during printing or will come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

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].**

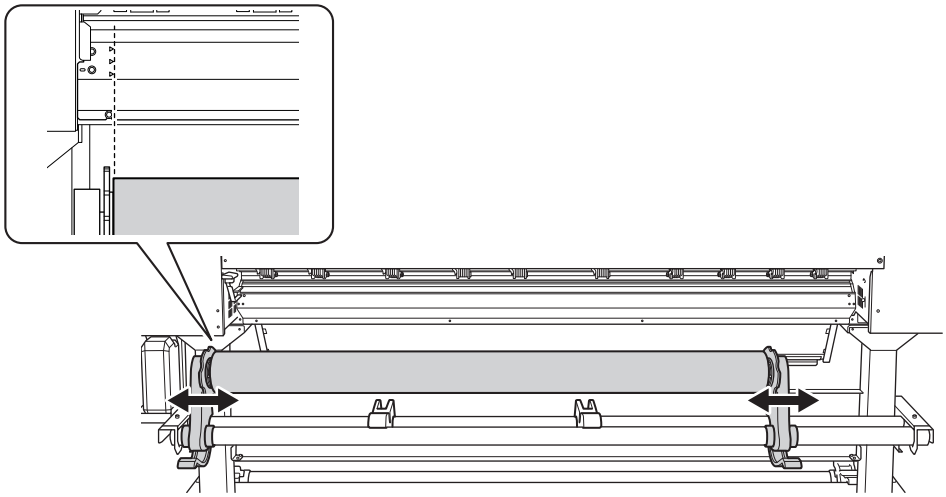
(4) **Tap** ⌂.

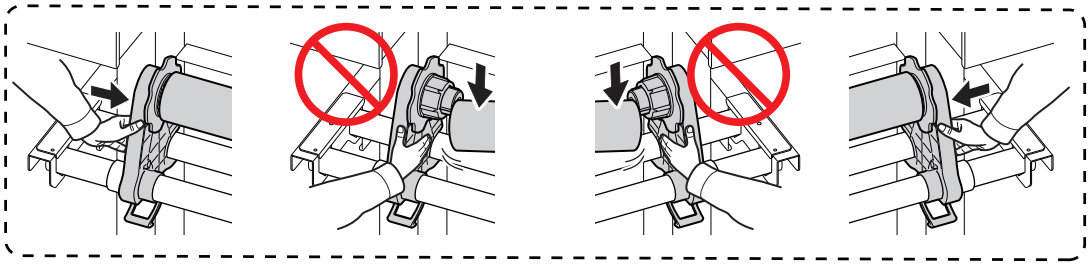
The home screen appears.

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.





⚠ WARNING

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

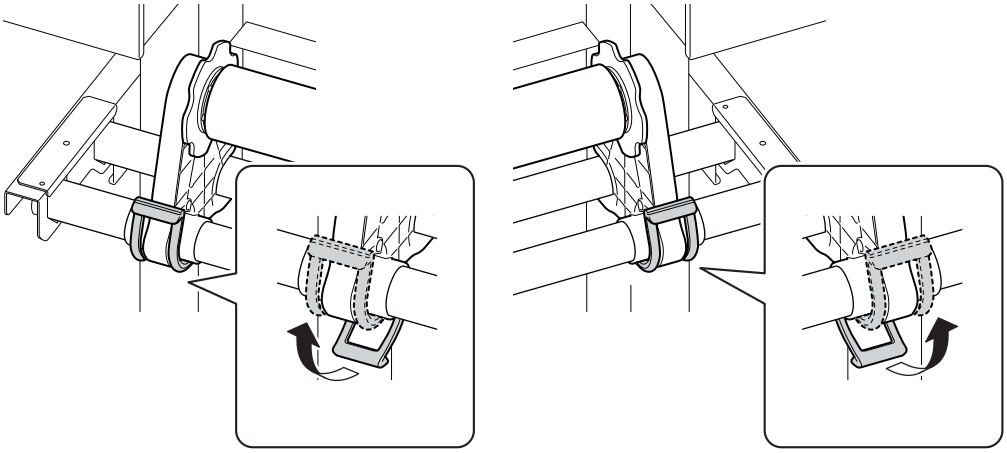
Doing so may cause the media to fall off the media holder and cause injury.

IMPORTANT

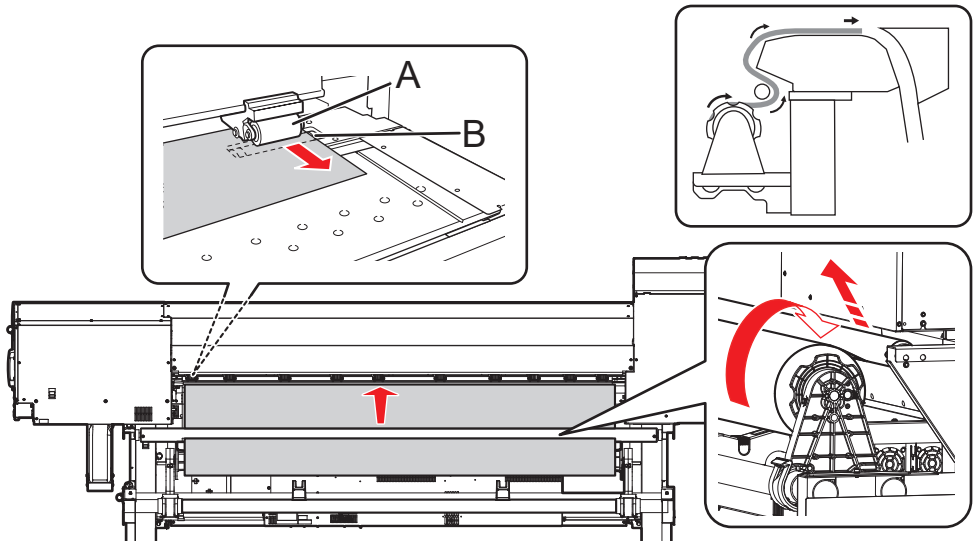
Firmly decide the left and right side positions of the media at this point.

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.**

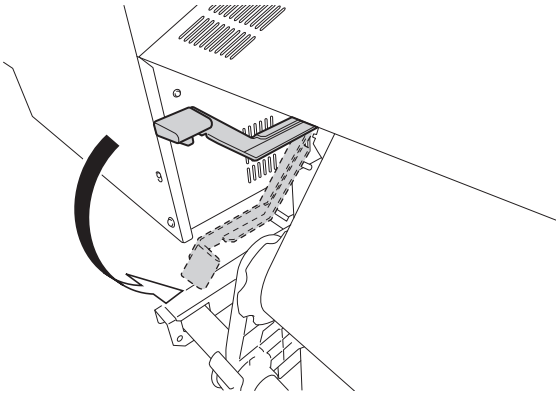


4. **Pass the leading edge of the media through the back of the rear tension bar and between the pinch roller (A) and the grit roller (B).**



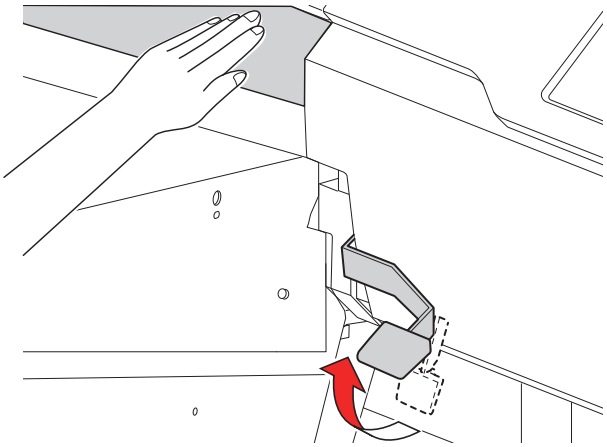
5. **Lower the loading lever (rear).**

The media is held in place.

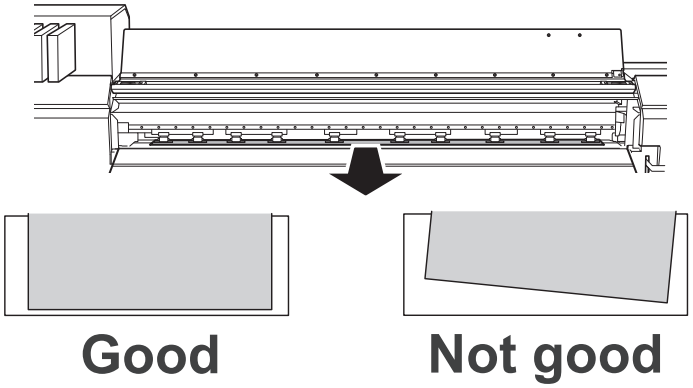


6. **(Move to the front of the printer.) Gently hold down the media and raise the loading lever (front).**

The media is released.

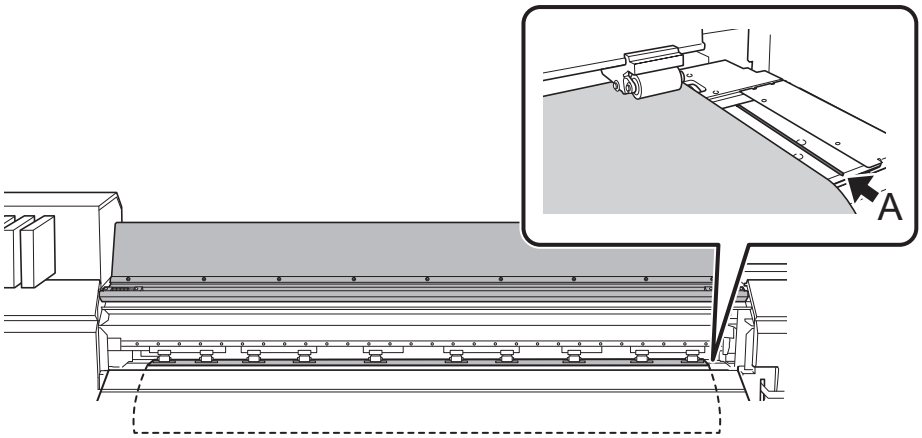


7. **Hold the media at the center and pull it out, being sure to keep it straight and all areas of the media to be taut.**



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

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

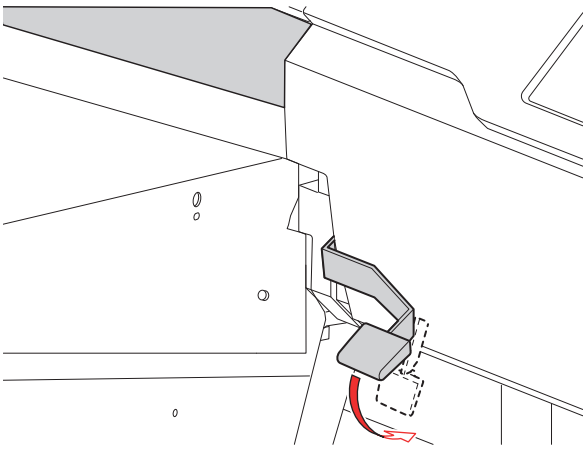


IMPORTANT

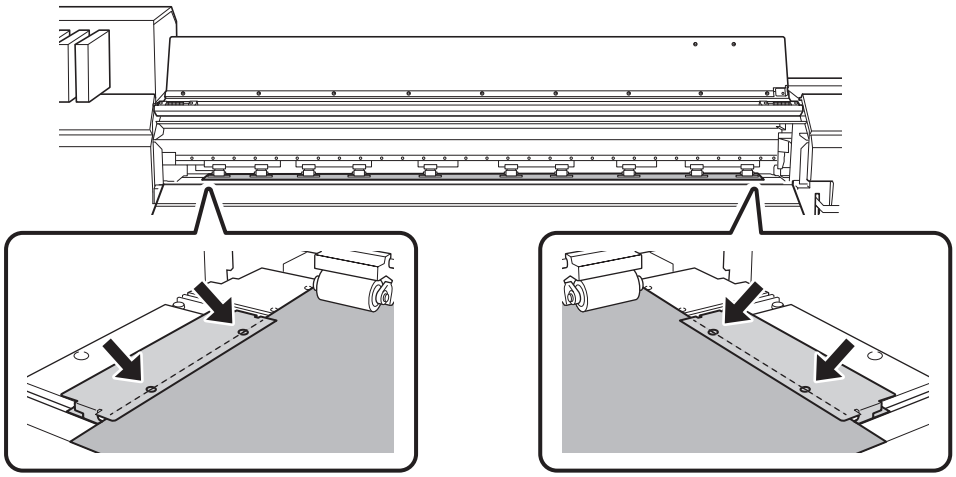
If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from step 1. If you just stand at the front of the printer and hold the media to readjust its position forcibly, the media will be skewed during printing or will come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

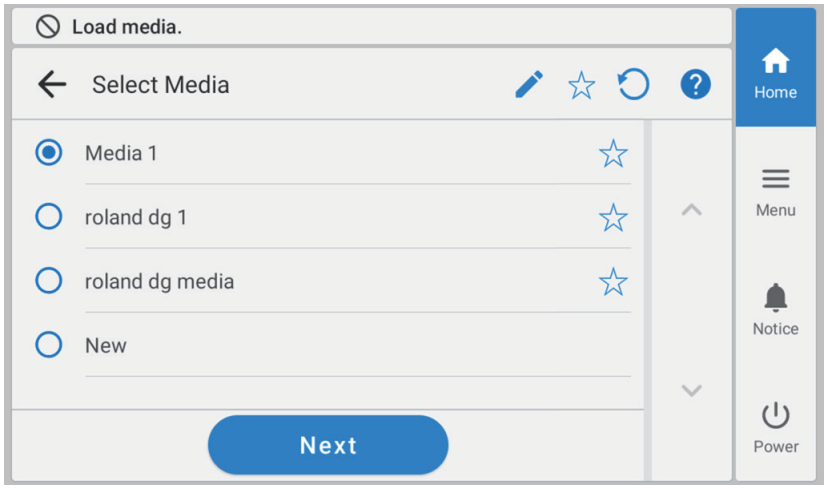
12. **Close the front cover.**

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. **Tap [Start Setup].**

Load the media in the take-up unit.

Procedure

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

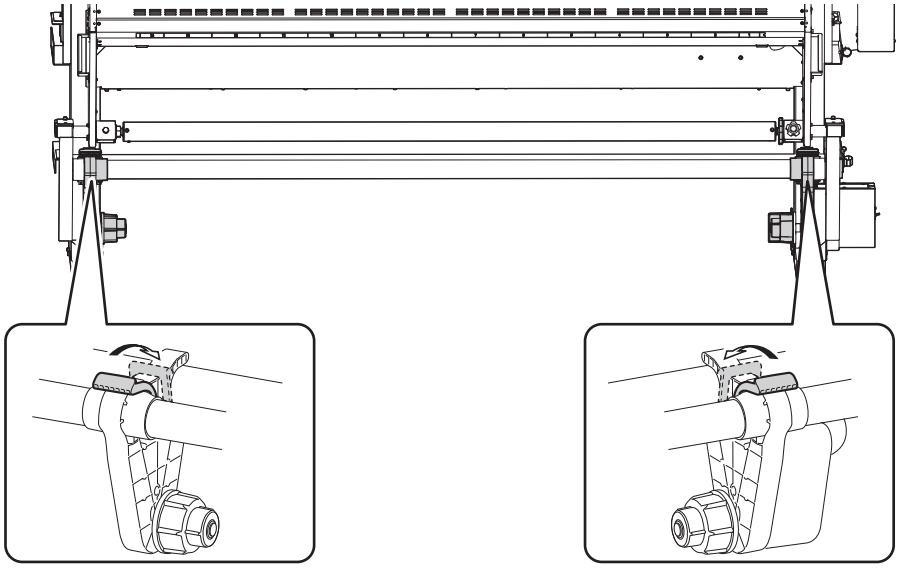
Prepare a paper tube wider than the media that has been set up.

IMPORTANT

Paper tubes are consumable items.

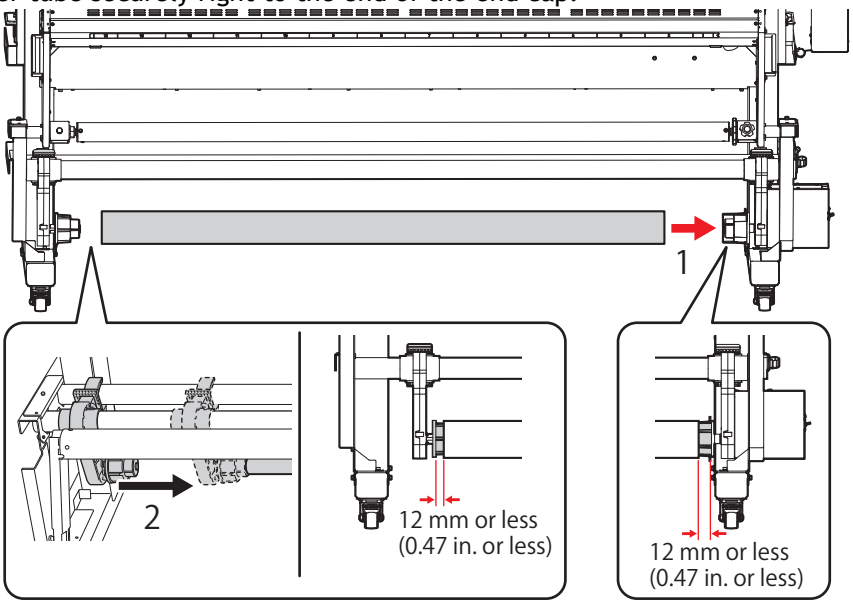
Watch the condition of the paper tube and replace at an appropriate time so that the media can be taken up in good working order.

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



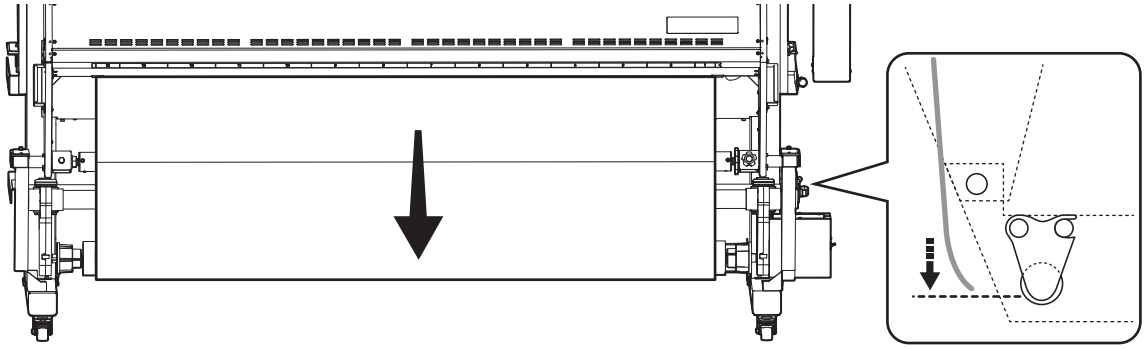
(2) **Fit the paper tube onto the right end cap, and then push the left media holder into the paper tube.**

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



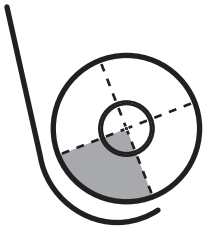
2. **Hold down ⌄ on the operation panel to feed out the media until the tip of the media reaches the paper tube.**

Media is fed out 30 mm (1.18 in.) each time you press this button. Holding down the button lets you feed out paper continuously.



MEMO

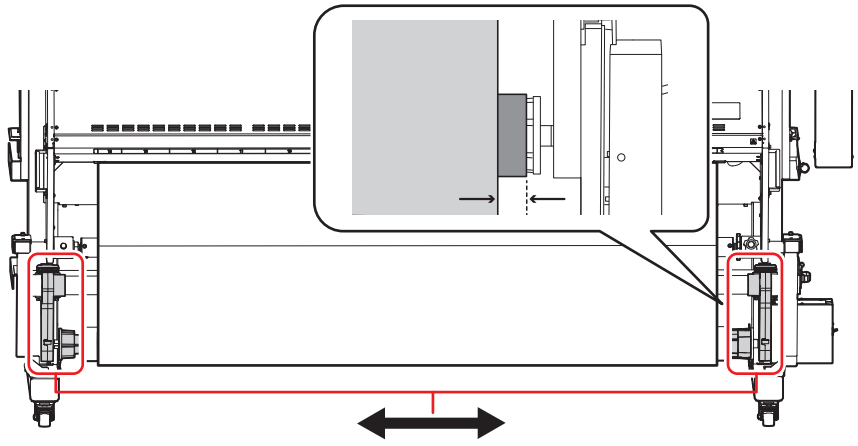
Feed out the media until it can wrap around at least 1/4 of the paper tube.



3. **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 both edges of the media.**

Hold the media holders from the outside and move them.



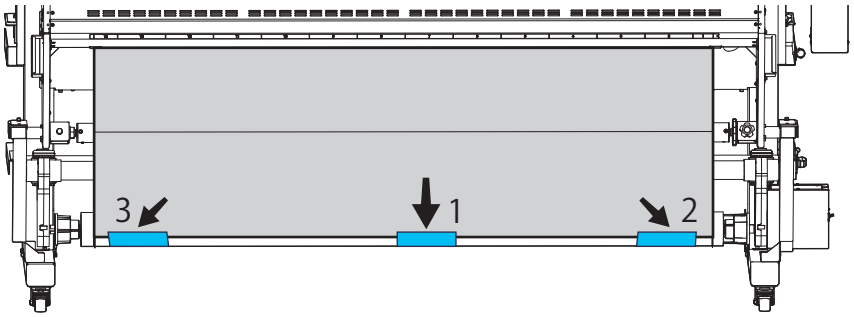
(2) **Secure the left and right media holders.**

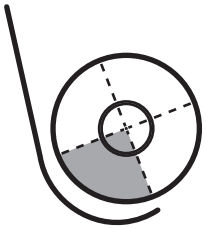
4. **Follow the procedure below to secure the media on the paper tube.**

Secure the media in place so it is fed forward.

(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.**

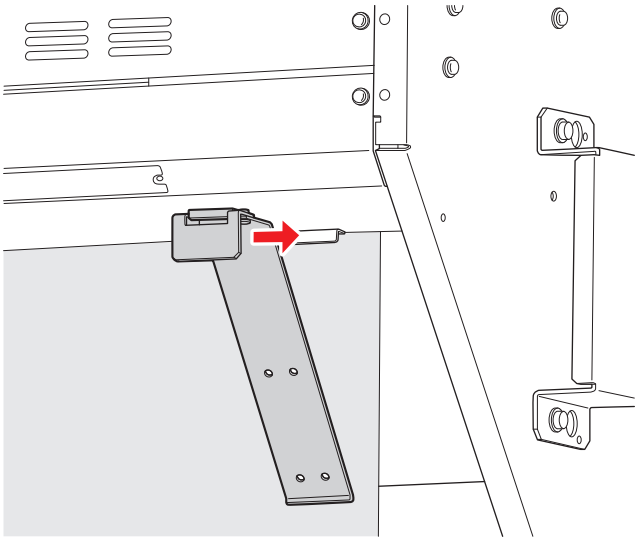




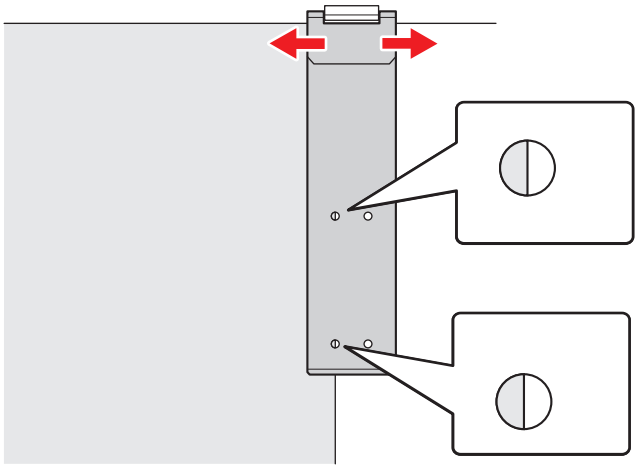
5. Tap [OK].

6. Attach the media guide near the right end of the media.

(1) Press the media guide against the notch in the figure, and then use the magnet to secure the guide against the top plate.

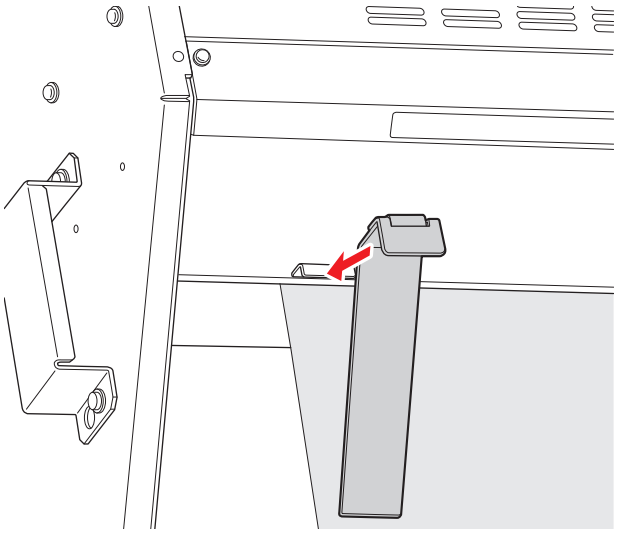


(2) Slide the media horizontally until its right end is positioned to pass through the holes on the left side of the media guide.

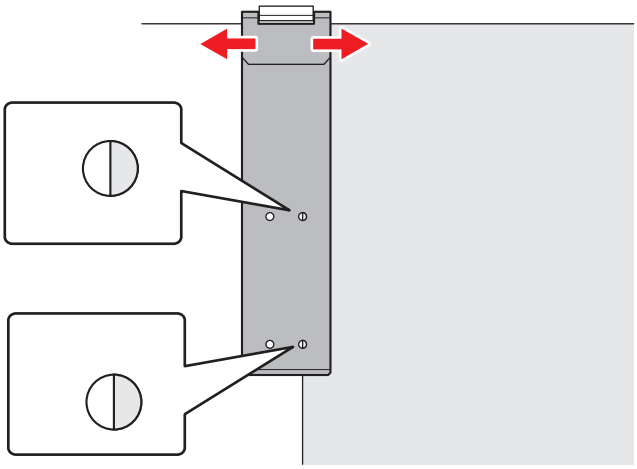


7. In the same manner, attach the media guide near the left end of the media.

(1) Press the media guide against the notch in the figure, and then use the magnet to secure the guide against the top plate.



(2) Slide the media horizontally until its left end is positioned to pass through the holes on the right side of the media guide.

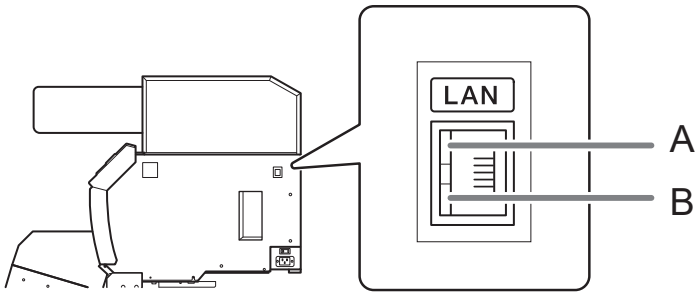


Checking before Output

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

Media being heated in the oven may be discolored if output is paused. We do not recommend resuming printing because horizontal bands and uneven colors may be produced at the place where output was paused.

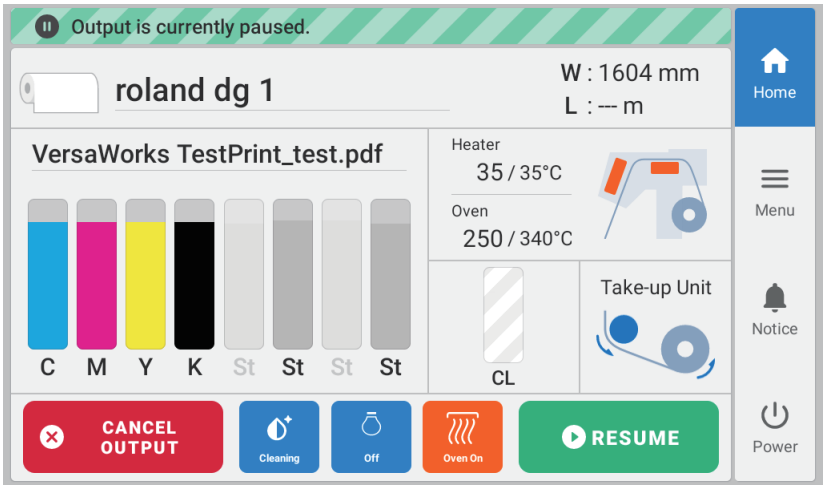
MEMO

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].**



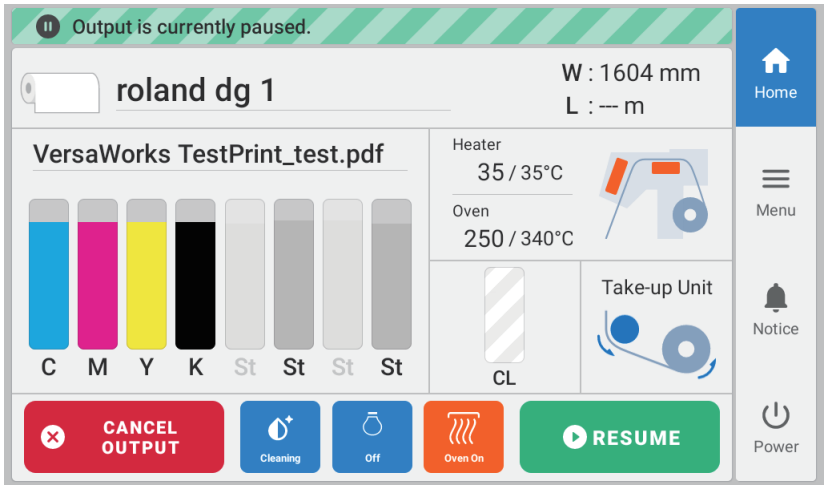
The printing operation resumes.

Canceling Output

Procedure

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

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



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

How to Remove Taken-up Media

Separating the Media

Separate the media after printing.

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

Procedure

1. **Close the front cover.**
2. **Tap [Sheet Cutting] on the operation panel.**
3. **Tap [Feed + Sheet Cutting].**
4. **Tap [Execute].**

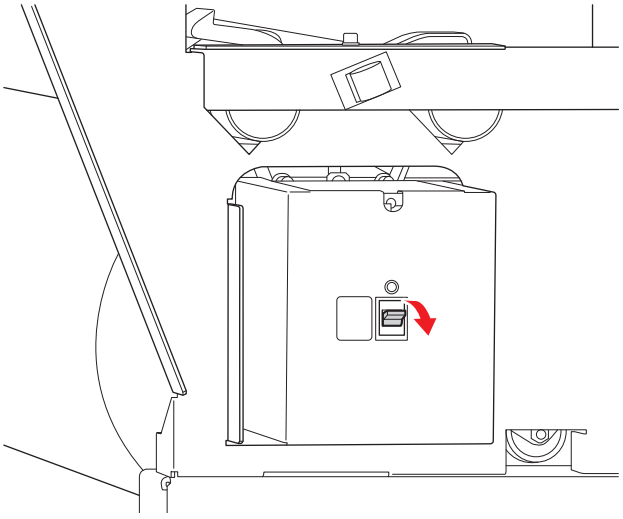
   After the printed media is taken up by the take-up unit (with a feed amount of 600 mm [23.62 in.]), the media is separated from the roll.

   ⚠ WARNING

   High Temperature

   Immediately after coming out of the oven, the separated media is very hot. Leave the media alone for at least 10 seconds, only touching it after it cools down.

5. **Press the manual switch on the take-up unit to take up the excess media.**



6. **If necessary, remove the media from the take-up unit.**

   Removing Media from the Take-up Unit(P. 68)

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. **Close the front cover when it is open.**
2. **Tap [Sheet Cutting] on the operation panel.**
3. **Tap [Feed + Sheet Cutting].**
4. **Tap [Execute].**

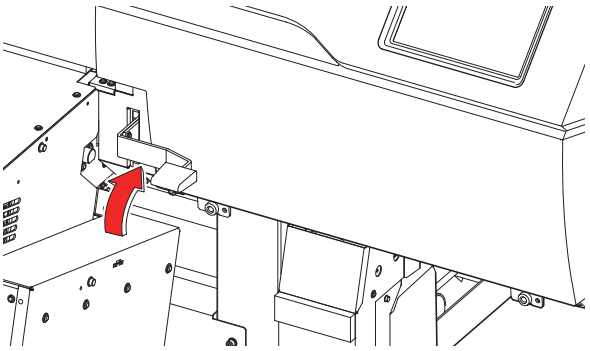
   After the printed media is taken up by the take-up unit (with a feed amount of 600 mm [23.62 in.]), the media is separated from the roll.

   ⚠ WARNING

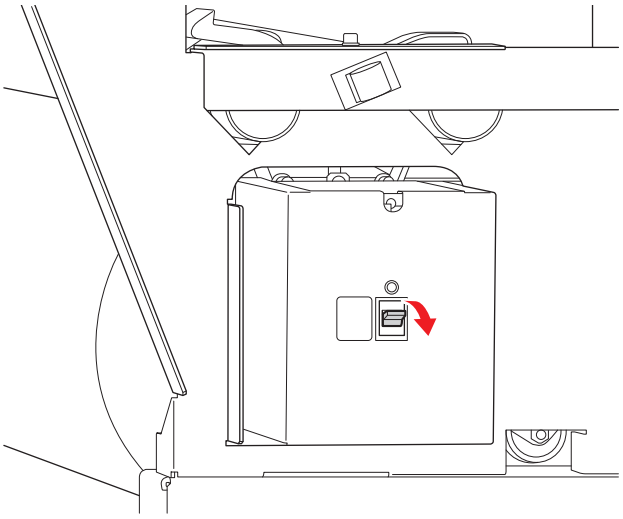
   High Temperature

   Immediately after coming out of the oven, the separated media is very hot. Leave the media alone for at least 10 seconds, only touching it after it cools down.

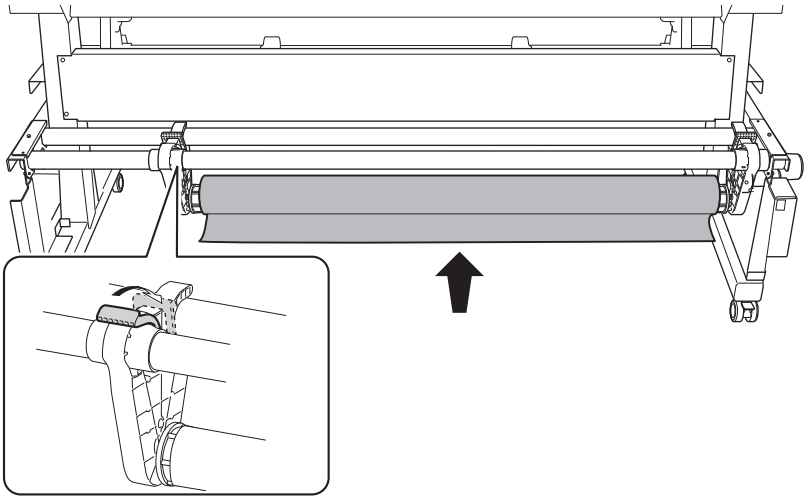
5. **If the loading lever is lowered, raise it.**



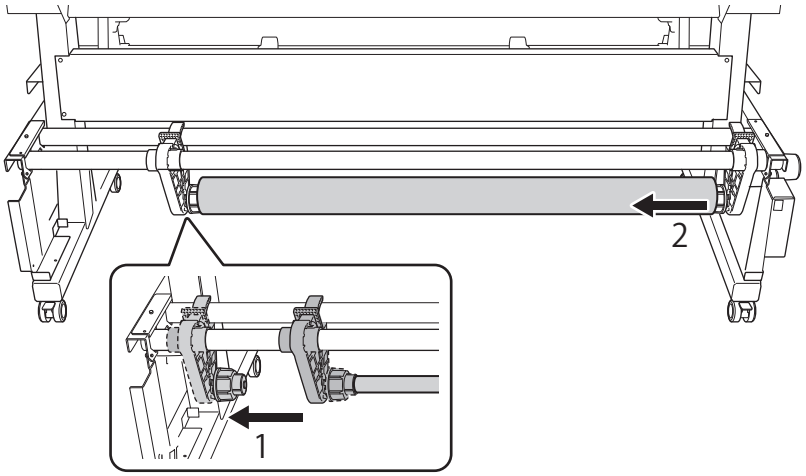
6. **Press the manual switch on the take-up unit to take up all the excess media.**



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



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



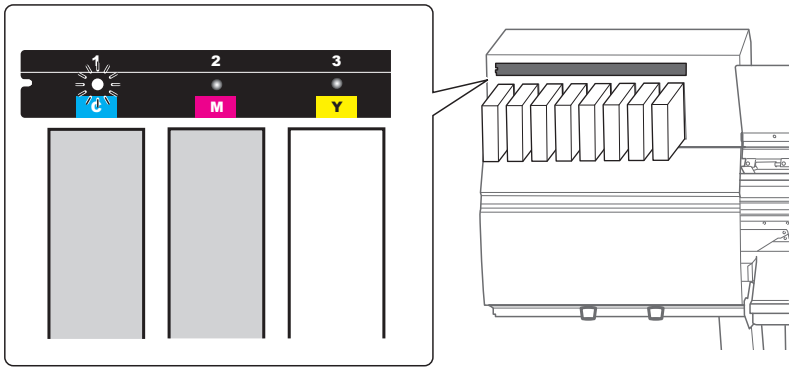
Store the media in a location with low humidity. You are recommended to implement countermeasures against moisture such as by covering the media with a vinyl sheet containing desiccant.

Replacing Ink Cartridges

Out-of-ink Warnings

When an ink pouch runs out, printing pauses and a warning beep sounds. For structural ink, slot 5 is paired with slot 6, and slot 7 is paired with slot 8. If one slot in a pair runs out of ink, the ink from the other slot is automatically supplied. Printing with structural ink only pauses when both slots in a pair run out of ink.

When printing pauses, the [**Ink has run out.**] screen is displayed on the operation panel to prompt you to replace the ink. Also, when ink runs out, its ink slot LED blinks, as shown in the following figure.



Pull out the empty ink cartridge and insert a new one. Printing is resumed.

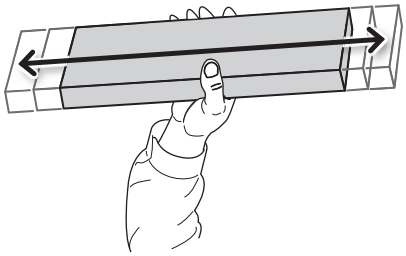
IMPORTANT

Never reuse an ink cartridge for which 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 cartridge, but nevertheless do not use it. Such an ink cartridge 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.

Preventing Sedimentation in Inks

The precipitation of the ingredients in the ink disables printing in normal color. Be sure to gently shake the ink cartridges so that the ink mixes well. Ink cartridges do not need to be shaken before every operation, but be sure to shake them when installing new ones.



Replacing the Cleaning Liquid

Out-of-cleaning-liquid Warnings

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

You can also check the message by tapping .

RELATED LINKS

- P. 71 Cleaning Liquid Pouch Replacement

Cleaning Liquid Pouch Replacement

Prepare the cleaning liquid pouch, then set the pouch in cleaning cartridge.

⚠ 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

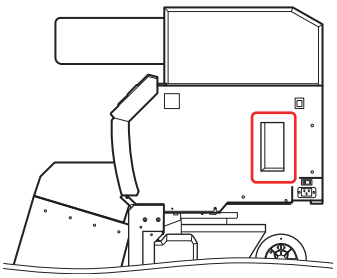
Accidental ingestion by children may pose a health hazard.

IMPORTANT

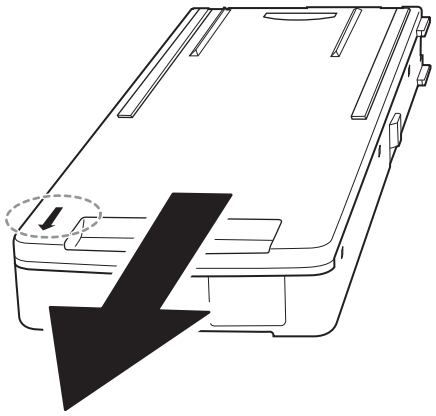
- Be sure to use a new cleaning liquid pouch.
- Never, under any circumstances, use anything other than the specified type of cleaning liquid.
- Cleaning liquid pouches and cleaning cartridges are consumable items. To purchase consumable items, contact your authorized Roland DG Corporation dealer or visit our website (https://www.rolanddg.com/).

Procedure

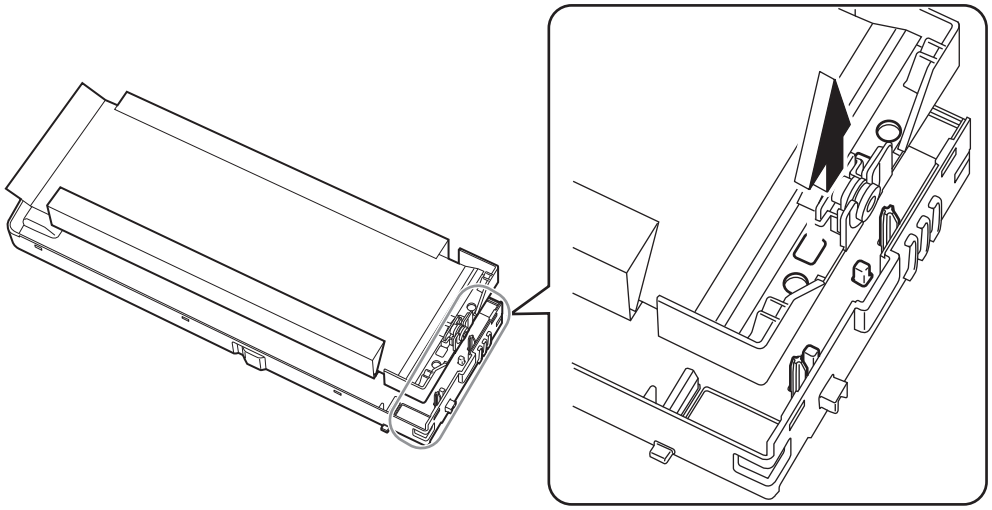
1. **Pull the cleaning cartridge from the cleaning liquid slot on the side of the printer.**



2. **Remove the cover of the cleaning cartridge.**
   a. Keep the side with the arrow face up.
   b. Remove the cover by sliding it in the direction indicated by the arrow.



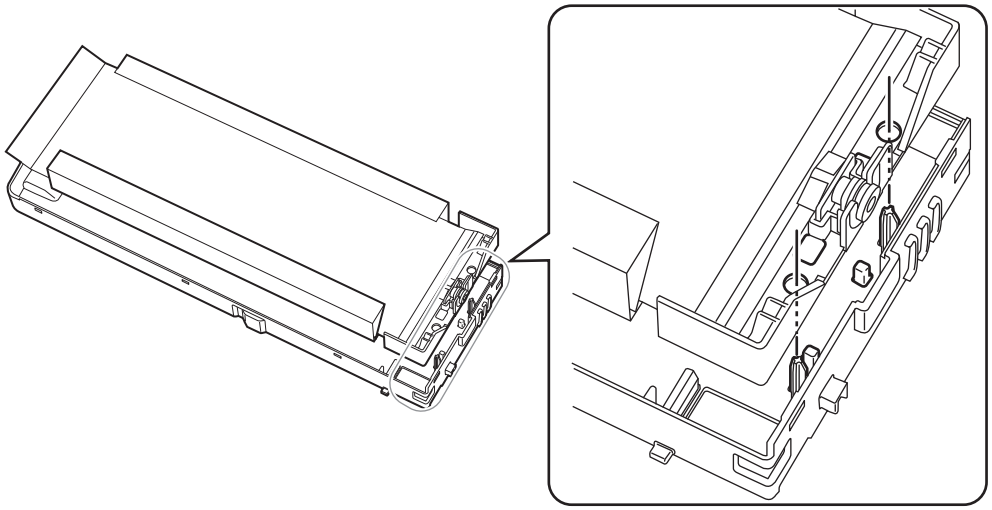
3. **Remove the used cleaning liquid pouch from the cartridge case.**



4. **Set the cleaning liquid pouch into the cartridge case.**

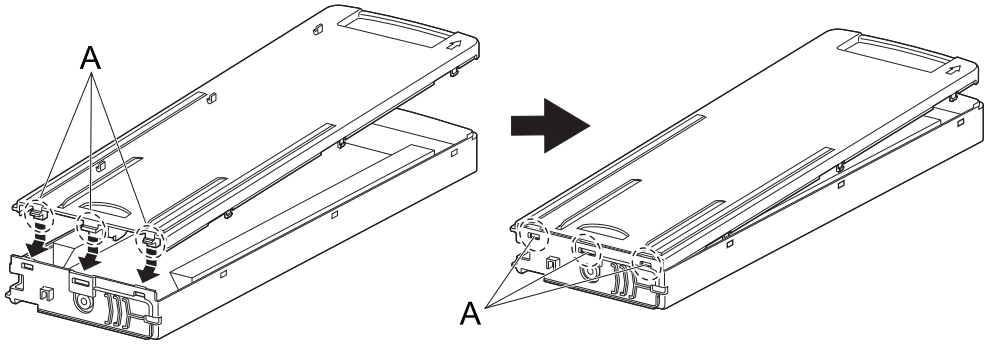
MEMO

To set the pouch in the correct position, pass the protrusions on the cartridge case through the holes in the pouch.



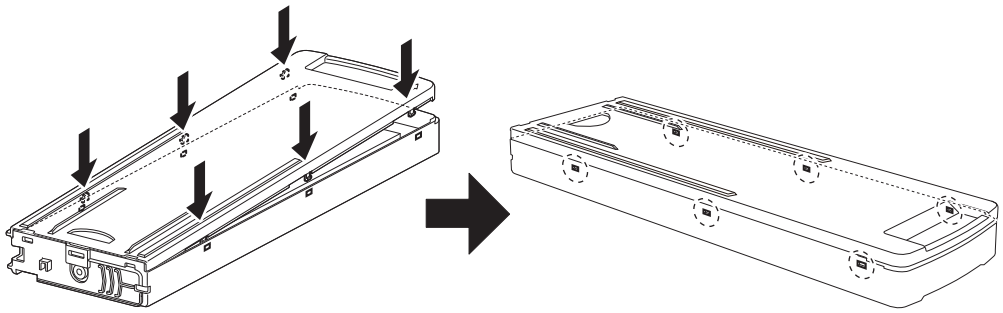
5. **Attach the cover to the cartridge case.**

a. Insert the protrusions (A) at the back of the cover into the holes in the cartridge case.



b. Push the cover to fit its hooks into the holes in the cartridge case.

There are hooks in six locations. Check that all the hooks are seated in the holes and that the cover does not come loose from the cartridge case.



6. **Set the cleaning cartridge in the cleaning liquid slot.**

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

When the inserted cleaning cartridge is recognized, a confirmation message is displayed on the operation panel, so tap [**Yes**].

Output Method

Printing Method

Preparations before Printing Output.....76
Performing a Nozzle Drop-out Test 76
Performing Normal Cleaning.....77
Printing Output 79

Preparations before Printing Output

IMPORTANT

If a number is displayed on the notifications button on the main screen (display example:), there is something that the printer needs you to do or there is something that the printer needs to tell you. Examples include telling you when it is time to perform cleaning and when it is time to replace consumable parts. Printing without first handling the notified problems may negatively affect the print quality. When a notification is available, check and follow its details to perform the appropriate work.

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, the second and subsequent printing positions are printed vertically in relation to the first printing position.

Procedure

1. **Set up the media.**

   P. 26 Setup of New Media
   P. 46 Setup of Registered Media

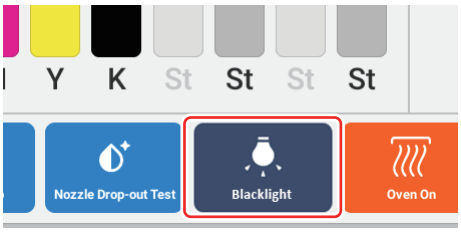
2. **Tap [Nozzle Drop-out Test] on the home screen.**

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

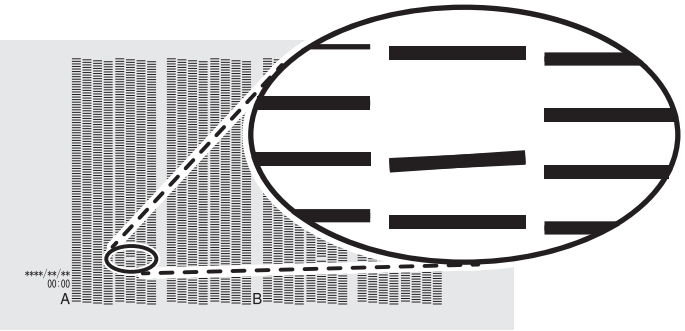
   Printing of the test pattern starts.

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

   You can check the discharge status of the CMYK ink with [**Print light**] and the discharge status of the structural ink with [**Black Light**]. Check these statuses while switching the light as necessary. Use the operation panel's home screen to switch the light.

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



5. **If you have opened the front cover, close it.**
   If no dot drop-out or dot displacement occurs, this operation is finished.

6. **Tap** .
   The home screen appears.

RELATED LINKS

- P. 129 When Dot Drop-out or Dot Displacement Occurs

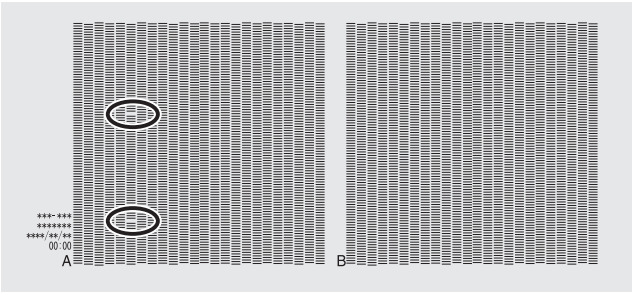
Performing Normal Cleaning

MEMO

- **Printing tests after cleaning**
  If the media has already been set up, the **[After cleaning, perform a printing test.]** menu appears on the **[Normal Cleaning]** screen. When this setting is turned on, a printing test is performed after cleaning.
- **Aborting cleaning**
  To abort cleaning or the printing test after cleaning, tap to return to the home screen, and then cancel the cleaning or the printing test.

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.

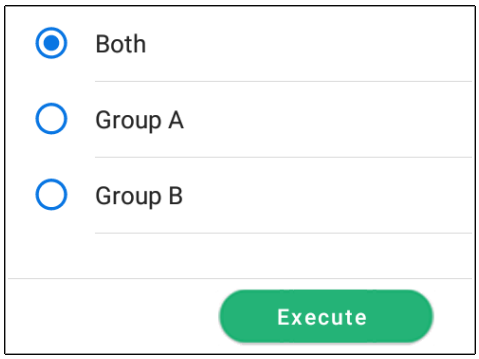


2. **Tap** .

3. **Tap [Cleaning]>[Normal Cleaning].**

4. **Select the [After cleaning, perform a printing test.] checkbox.**

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



6. **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.

7. **Tap ←.**

8. **Perform a printing test again.**

9. **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. 76 Performing a Nozzle Drop-out Test
- P. 131 When Normal Cleaning Is Not Effective

Printing Output

⚠ WARNING

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.

⚠ WARNING

High Temperature

The inside and back of the oven, media immediately after it is heated by the oven, exhaust from the oven, and the hose close to the exhaust port all become hot. Exercise caution to avoid burns.

⚠ WARNING

If there is a foreign object inside the oven, immediately disconnect the power plug.

If a small media fragment remains inside the oven and cannot be removed, do not forcibly attempt to remove it. Instead, immediately disconnect the power plug and contact your authorized dealer.

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 or the design software.

MEMO

When you send the output data, [**Heater warm up in progress. Please wait.**] or [**Maintenance in progress.**] may be displayed on the screen. These indicate the preparation operations performed before output. You may be able to cancel or skip these operations, but doing so is not recommended. When preparation finishes, output starts.

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 oven 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. 93 Setting the Oven Temperature

Optimizing Quality and Efficiency

Optimizing the Output Quality

Using the Correction Functions 83
- Automatically Making Required Adjustments 83
- Manual Adjustment: Reducing Horizontal Bands (Feed Correction) 83
- Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment) 85

Configuring Settings to Match the Properties of the Media 87
- Changing the Print Head Height 87
- Using Media That Wrinkles Easily/Does Not Move Smoothly 88
- Using Sticky Media 88

Setting the Take-up Unit 90

Adjusting the Ink-drying Temperature and the Media-heating Temperature 92
- Setting the Print Heater Temperature 92
- Setting the Oven Temperature 93
- Adjusting the Heater Temperature According to the Internal Temperature 96
- Setting the Oven's Internal Temperature When Printing Starts 96
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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.

Misalignment of the ink landing position due to the printing conditions is automatically corrected 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)

Procedure

1. **Set up 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
   - 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 home screen.
   - If **[Failed]** is displayed on the operation panel, carry out manual adjustment.

RELATED LINKS

- P. 83 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)
- P. 85 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)

Manual Adjustment: Reducing Horizontal Bands (Feed Correction)

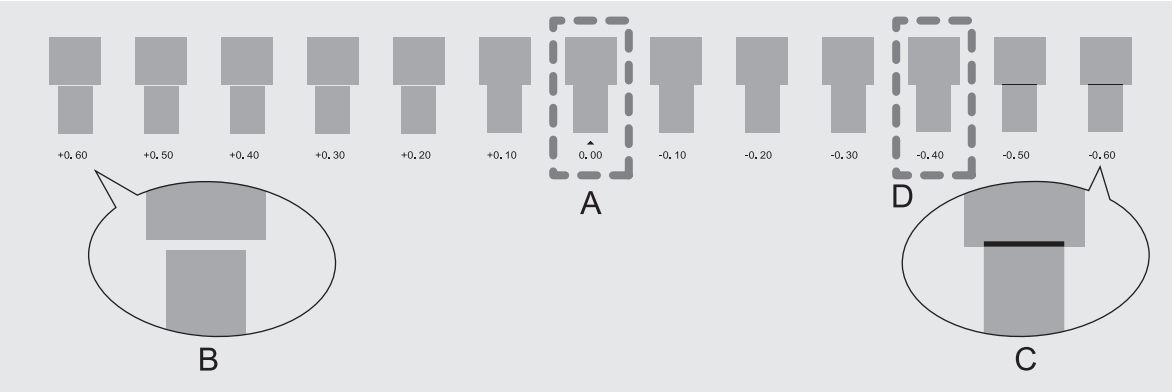
Perform corrections to make the band-shaped "stripes" on the printed surface less noticeable.

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. **Set up the media.**
2. **Close the front cover.**
3. **Tap** ☰.
4. **Tap [Media Settings]>[Printing settings]>[Feed Correction].**
5. **Tap [Execute] next to [Printing Test].**
   Printing of the test pattern starts.
6. **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 v 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.

7. **Tap [Save].**
   The entered correction value is saved.
8. **Tap [Execute] next to [Printing Test].**
   The test pattern is printed again.
9. **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.

10. When you have successfully performed the correction, tap .

    The home screen appears.

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.

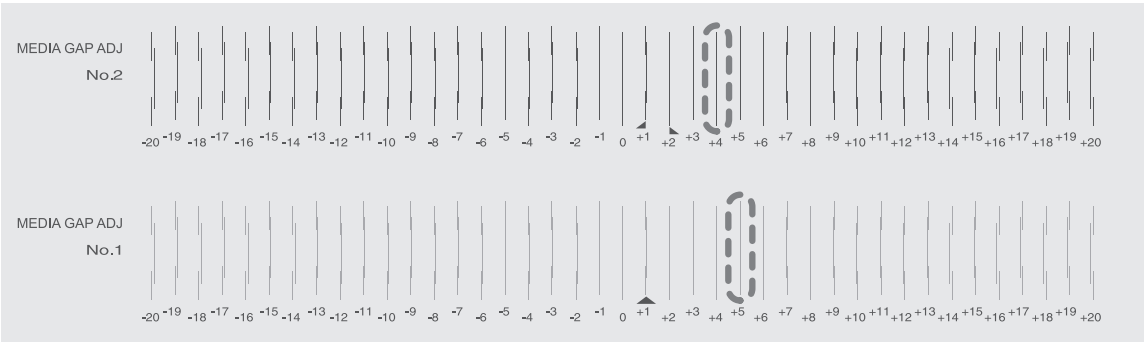
- When using this machine for the first time
- When changing the media to use
- When you have changed the print-head height

Procedure

1. Set up 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 v 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. 67 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 .**

The home screen appears.

Configuring Settings to Match the Properties of the Media

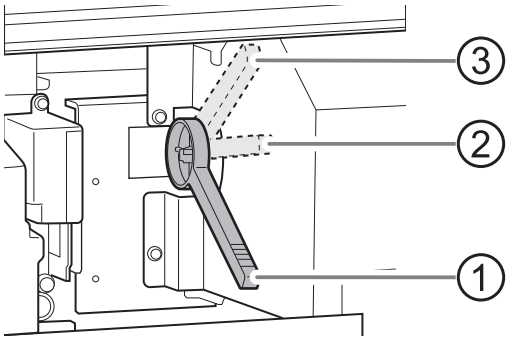
Changing the Print Head Height

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. **Set up 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]*1	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**].

*1 Default settings

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.

If degradation of printing quality occurs after raising the print head height, refer to "Related information" and try optimizing the quality.

7. **Close the front cover.**

8. **Tap [OK].**
   The print heads move to their original position.

9. **Tap** .
   The home screen appears.

RELATED LINKS

- P. 83 Automatically Making Required Adjustments
- P. 85 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. **Set up 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*1	The suction force is automatically adjusted to the optimal level for the media width.

*1 Default setting

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

6. **Tap** .

MEMO

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.

The home screen appears.

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. Set up the media.
2. Tap .
3. Tap [Media Settings]>[Other Media Settings]>[Media Sticking Prevention].
4. Select [Enable].

   MEMO

   - Default setting: **[Disable]**
5. Tap [Save] to confirm your entry.
6. Tap .

   The home screen appears.

Setting the Take-up Unit

Before using the take-up unit, check whether the settings are appropriate for the media or print data.

- Turn take-up on or off or turn it on only during media setup.
- Select the media take-up method (constant tension or a little slack).

Procedure

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

[On]	When [**Tension Winding**] is selected, the media is taken up when the tension falls below the value set with [**Take-up Tension**]. During media unsetup, the take-up operation is also performed even when the tension is slack due to the media being pulled out from the roll manually. When [**Slack Winding**] is selected, take-up will be performed slowly with only a little force when not printing, regardless of whether the media is set up or not. During printing, the operation for "Take-up after a certain length is printed" is repeatedly performed.
[Off]	The media is not taken up. In this situation, implement countermeasures to prevent the print surface from directly touching the floor.
[AUTO]*1	When [**Tension Winding**] is selected, if the media has been set up, it is taken up when the tension falls below the value set with [**Take-up Tension**]. When [**Slack Winding**] is selected, take-up will be performed slowly with only a little force when not printing. During printing, the operation for "Take-up after a certain length is printed" is repeatedly performed.

*1 Default settings

5. Select one of the following take-up methods, and configure the necessary settings.

[Tension Winding]*2	The media is stretched and taken up. The tension strength can be set in [**Take-up Tension**]. For media that stretches easily when it is pulled, set the tension to a small value or turn off the take-up unit. Adjust the tension according to the media type. MEMO • Default setting: 40 N
[Slack Winding]	The media is slightly slackened, and the operation for "Take-up after a certain length is printed" is repeatedly performed. Try this take-up method if banding or other print quality problems occur. The take-up strength can be set in [**Strength**]. Adjust the take-up strength if the take-up is too loose and causes problems in processes after the media has been taken up and removed. MEMO • Default setting: Strength 1

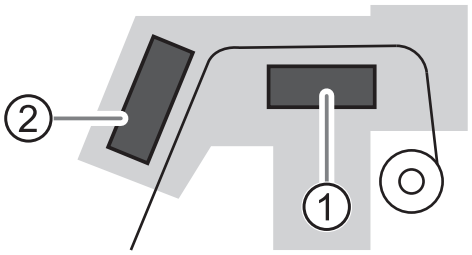
*2 Default settings

6. Tap [Save].
7. Tap .

The home screen appears.

Adjusting the Ink-drying Temperature and the Media-heating Temperature

Set the heater temperature used to dry the ink and adjust the oven temperature used to heat the media and cause it to foam. You can adjust the temperature settings to match the type of media and the printing speed.



①	**[Print Heater]**	This is used to dry the CMYK ink after printing, preventing the colors from smudging even when structural ink is printed on top of the CMYK ink.
②	**[Oven]**	This is used to heat foaming media.

⚠ WARNING

High Temperature

The inside and back of the oven, media immediately after it is heated by the oven, exhaust from the oven, and the hose close to the exhaust port all become hot. Exercise caution to avoid burns.

⚠ WARNING

Remove any loaded media or switch off the sub power when printing is not being performed.

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 oven for any purpose for which it is not intended, such as heating something other than media.

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

Setting the Print Heater Temperature

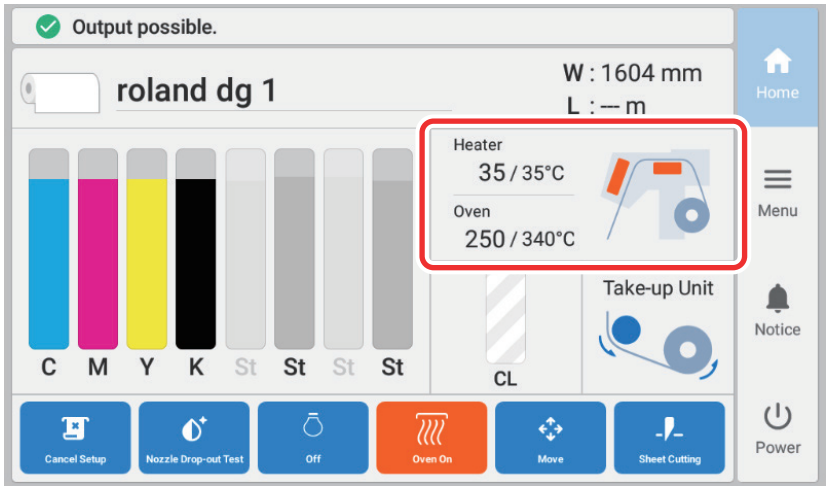
Setting the temperature of the print heater appropriately improves ink adhesion and inhibits smudging.

- 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. **Set up the media.**

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



The [**Heater Temperature**] window 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.

MEMO

- Default setting: 35°C (94°F)

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

5. **Tap** .

MEMO

- 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.

The home screen appears.

Setting the Oven Temperature

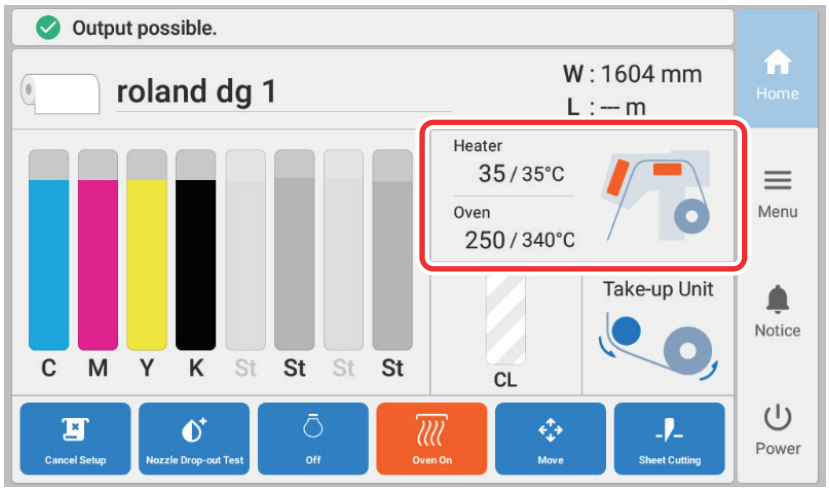
Setting the oven temperature appropriately allows for a reasonable media foaming condition and reduces the surface roughness of the media.

- Basically, use the software RIP (color profile) settings for temperature. Even if you use the settings of the software RIP, if you need to adjust the temperature, such as when the intended foaming condition is not obtained, change the temperature in the machine settings.
- The temperature must not be too high or too low. Set a temperature that is reasonable for the media. If the temperature is too low, foaming will not proceed far enough, resulting in unclear height differences. Conversely, if the temperature is too high, foaming will proceed too far, resulting in not only unclear height differences (the same as when the temperature is too low) but also in a rough surface on the media.

Procedure

1. **Set up the media.**

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



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

3. **Tap − or + to set the [Oven] temperature.**

When media foaming is insufficient, increase the temperature. When media foaming is excessive, decrease the temperature.

MEMO

- Default setting: 340°C (644°F)

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

5. **Tap .**

MEMO

- 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.

The home screen appears.

Setting the Temperature of Each Heater in the Oven

You can set the temperature of each heater in the oven. If a part of the media foaming has progressed too far or not far enough, you can fine-tune the temperature of the heater that heated the part in question.

MEMO

The pattern may make it difficult to identify or see the numbers of the heaters that require temperature adjustment. A test pattern that makes it easy to identify the numbers of the heaters that require adjustment is available. Download this test pattern from the following link as necessary.

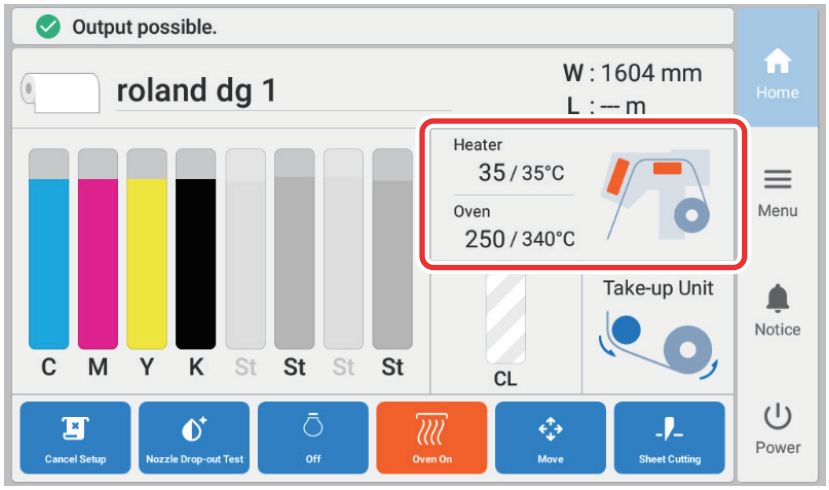
File in PDF format (size: 1,550 mm × 315 mm [61.02 in. × 12.4 in.])

Load this file into VersaWorks, turn on [**Center on the Media**], and then perform output. Check the foaming condition and the surface roughness of the media.

Procedure

1. **Set up the media.**

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



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

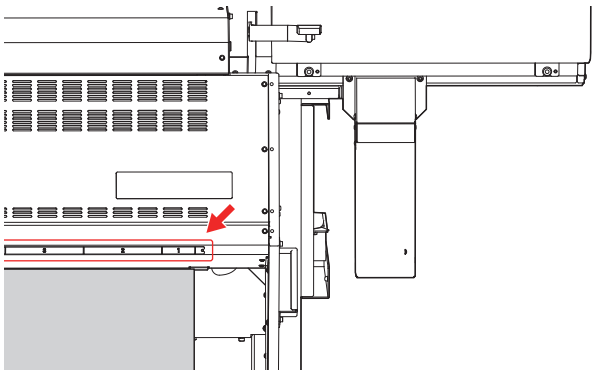
3. **Tap [Advanced Oven Settings].**

The [**Advanced Oven Settings**] window appears.

4. **Tap − or + to set the temperature of each heater.**

You can set the temperature increase/decrease in relation to the set temperature of the oven. When media foaming is insufficient, increase the temperature. When media foaming is excessive, decrease the temperature.

The number of the temperature setting displayed on the operation panel indicates the number of the heater. The placement location of the heater is displayed on the machine.



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

6. **Tap .**

The home screen appears.

Adjusting the Heater Temperature According to the Internal Temperature

The internal temperature of the oven gradually increases due to the heating provided by the heater. Even after the heater reaches the set temperature, the internal temperature continues to increase, converging at the prescribed temperature that has a balance between the air cooling provided by the surrounding air and the heating provided by the heater. The media first comes into contact with the hot air inside the oven and then is heated directly by the heater. However, the media is warmed by the hot, internal air while it moves from the oven entrance to the position where it is heated by the heater.

When printing is performed continuously, the internal temperature differs between the start of printing and all subsequent printing operations, so try using the function for fine-tuning the heater temperature. Doing so may allow you to maintain a more stable foaming condition.

Procedure

1. **Tap ☰.**
2. **Tap [Preferences]>[Heating regulation due to the internal temperature of the oven].**
3. **If you will not fine-tune the temperature, select [Off]. If you will fine-tune the temperature, select the size of the adjustment width.**

   It is best to select the adjustment width according to the thermal conductivity of the media. Generally, it is a good idea to select "Small" when the thermal conductivity is low and "Large" when the thermal conductivity is high. However, this does not guarantee the suitability of the combination of the media and the adjustment width. Try checking the consistency of this combination by viewing the actual foaming condition.

   MEMO

   - Default setting
     - [Off]

Setting the Oven's Internal Temperature When Printing Starts

When the print data is received from the computer, if the oven's internal temperature is lower than the set temperature, the internal temperature is increased. Printing starts when the set temperature is reached. If you are using media that does not foam unless the internal temperature exceeds the predetermined temperature, set an internal temperature that meets this condition.

However, if it is determined that the internal temperature will not reach the set temperature due to insufficient heat source power, this setting is ignored. The reason is to prevent the situation in which printing is not possible due to the inability to increase the internal temperature to the set temperature. If the media does not foam, review the temperature setting of the oven heater.

Procedure

1. **Tap ☰.**
2. **Tap [Preferences]>[Internal Temperature at the Start of Printing].**
3. **Tap − or + to set the temperature.**

MEMO

- Default setting
  150°C (302°F)

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

5. **Tap** .
   The home screen appears.

RELATED LINKS

- P. 93 Setting the Oven Temperature

Setting the Temperature during Standby

Set the print heater and oven temperature used when the main power and the sub power are switched on and printing is not in progress.

Procedure

1. **Tap** .

2. **Tap [Preferences]>[Standby Heater Temperature].**

3. **Tap** − **or** + **next to [Print Heater] or [Oven] to set the temperature.**
   When this is set to (off), [**Print Heater**] is switched off during standby.

MEMO

- Default settings
  [**Print Heater**]: 25°C (76°F)
  [**Oven**]: 250°C (482°F)

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

5. **Tap** .
   The home screen appears.

Optimizing Work Efficiency

Managing the Media Settings.....99
Changing the Media Settings 99
Checking the Registered Media Settings 99
Changing the Media Name 100
Duplicating Media Settings..... 100
Deleting Media Settings 101
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Setting the Base Point 102

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. **Set up 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. 87 Changing the Print Head Height
[Feed Correction]	P. 83 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)
[Media Gap Adjustment]	P. 85 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)
[Heater Temperature]	P. 92 Setting the Print Heater Temperature P. 93 Setting the Oven Temperature
[Multi Sensor Adjustment]	Adjusts the sensor used to make corrections to the optimal condition.
[Media Suction Force]	P. 88 Using Media That Wrinkles Easily/Does Not Move Smoothly
[Media Sticking Prevention]	P. 88 Using Sticky Media

5. **If you have changed a setting, tap [Save].**
6. **Tap** ⌂.
   The home screen appears.

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. 87 Changing the Print Head Height
[Feed Correction]	P. 83 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)
[Media Gap Adjustment]	P. 85 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)
[Heater Temperature]	P. 92 Setting the Print Heater Temperature P. 93 Setting the Oven Temperature
[Multi Sensor Adjustment]	Adjusts the sensor used to make corrections to the optimal condition.
[Media Suction Force]	P. 88 Using Media That Wrinkles Easily/Does Not Move Smoothly
[Media Sticking Prevention]	P. 88 Using Sticky Media

5. **Tap** .
   The home screen appears.

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** .
   The home screen appears.

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 ⌂.
   The home screen appears.

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 ⌂.
   The home screen appears.

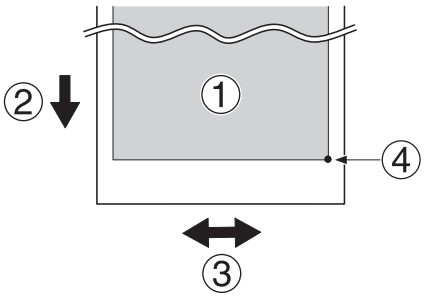
Adjusting the Output-start Location

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.



MEMO

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

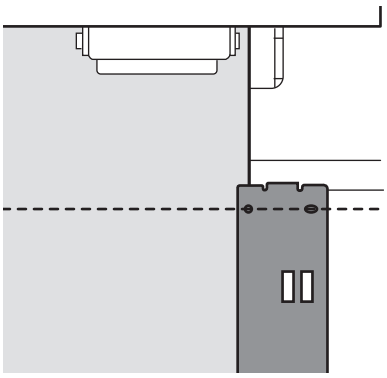
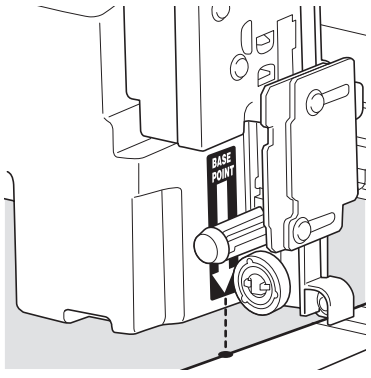
Procedure

1. **Tap** .

2. **Tap [Move].**

   The movement screen appears.

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

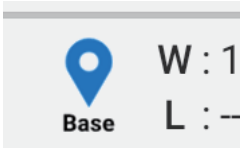
Printing-start position in feed direction (forward-backward)	Printing-start position in scan direction (left-right)
Move the media using ^ or v to adjust the feed direction. The media clamp holes are the starting position in the feed direction.	Move the sub carriage using < or > to adjust the scan direction.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

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

When the base point position is updated, the following icon is displayed on the home screen.



Optimizing Operation Management

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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 ⌂.
   The home screen appears.

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.

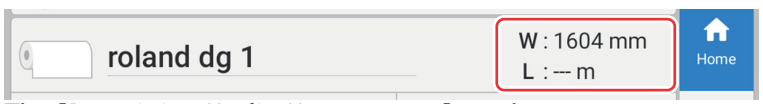
Because the amount of media remaining is not updated automatically when you change the media, redo the setting whenever you change the media.

MEMO

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

Procedure

1. Set up the media.
2. Tap the following location on the home screen.



   The [**Remaining Media Management**] window appears.
3. Tap − or + to enter the length of the remaining media.
4. Tap [Save] to confirm your entry.
5. Tap ⌂.
   The home screen appears, and the amount of media remaining is displayed.



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
[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 turned on, 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.

IMPORTANT

- Default settings
  [Media Clamp Placement Notification]: [On]

4. Tap [Save] to confirm your entry.
5. Tap ⌂.
   The home screen appears.

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.

MEMO

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

4. **Tap [Save] to confirm your entry.**
5. **Tap** .
   The home screen appears.

Setting the Duration of the Warning Beep

This feature sets the duration of the warning beep that sounds when, for example, an error occurs. If you turn this timer off, the warning beep will continue until the cause of the problem is eliminated.

Procedure

1. **Tap** .
2. **Tap [Preferences]>[Stopping the Warning Beep].**
3. **Tap**  **to switch the setting.**
4. **Tap**  **or**  **to set the time.**
5. **Tap [Save] to confirm your entry.**
6. **Tap** .

MEMO

- Default setting: **[Off]**

The home screen appears.

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 unit].**
4. **Select the unit.**

MEMO

- Default settings
  - **[Length unit]**: mm

5. **Tap [Save] to confirm your entry.**
6. **Tap [Temperature unit].**
7. **Select the unit.**

MEMO

- Default settings
  - [**Temperature unit**]: °C

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

9. **Tap** .
   The home screen appears.

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** .
   The home screen appears.

Viewing Network Information

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

MEMO

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

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 .
   The home screen appears.

RELATED LINKS

- DA-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.

   MEMO

   - Default setting: [50%RH]

4. Tap [Save] to confirm your entry.
5. Tap .
   The home screen appears.

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].

   MEMO

   - Default setting: [On]

   The operation sound turns off.

4. Tap [Save] to confirm your entry.

5. Tap .
   The home screen appears.

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].**
   The confirmation window appears.
4. **Tap [Yes].**
5. Tap .
   The home screen appears.

Maintenance

Introduction

Important Notes on Handling and Use 114
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Ink Cartridges 114
Smoke Absorber and Ventilation Unit 115
Basic Maintenance Knowledge 116
Types and Timing of Maintenance 116
Measures When the Printer Is Not in Use for a Prolonged Period 117

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-cartridge 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 cartridge removed. Remaining ink in the printer may harden and clog the print heads.
  - The print heads require daily maintenance and various types of cleaning that depend on the situation. 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 or exhaust ports 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 Cartridges

- Ink cartridges come in various types.
  - Use a type that is compatible with the printer. Also, be sure to use only genuine items from Roland DG Corporation.
- 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 you leave such adhered ink untreated.
- Storage
  - Use up the ink before the expiration date printed on the ink cartridge.

  - Store ink cartridges unopened in a well-ventilated location at a temperature of 5°C to 40°C (41°F to 104°F) and avoid direct sunlight. However, do not store the ink cartridges for a prolonged period of time in low or high temperature environments.
- Other handling
  - Leave ink cartridges inserted in the ink slots at all times. Leaving the ink slot empty may cause printer malfunctions, such as the ink adhered to the needle inside dries out and causes clogging.
  - Always insert the cleaning cartridge into the cleaning liquid slot with the cleaning liquid pouch set. Leaving the cleaning liquid slot empty may cause printer malfunctions, such as the cleaning liquid adhered to the needle inside drying out and causing clogging.

Smoke Absorber and Ventilation Unit

- Leave the ventilation unit in the installation location switched on 24 hours a day.
- Switch on the smoke absorber when printing.
  - White smoke is generated from media heated by the oven. Use the smoke absorber to release this smoke to the air.
- Perform periodic and appropriate maintenance on the smoke absorber and ventilation unit.
  - Filters and other parts need to be replaced periodically. Do so appropriately according to their correct replacement schedules and their frequency of use. Maintain the smoke absorber to ensure its correct performance at all times. Additionally, for the maintenance of the smoke absorber, refer to its documentation.
  - For the maintenance of the ventilation unit, refer to its documentation.

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. 76 Performing a Nozzle Drop-out Test
After daily operations	Cleaning the machine	P. 121 Cleaning the Media Path
		P. 122 Cleaning the Knife Carriage Roller
	Removing media	P. 67 How to Remove Taken-up Media
If a message appears	Cleaning around the print heads	P. 123 Cleaning around the Print Heads
If the discharged fluid disposal message appears	Disposing of discharged fluid	P. 126 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. 76 Performing a Nozzle Drop-out Test
		P. 129 Performing Normal Cleaning
		P. 131 Medium Cleaning Method
		P. 132 Powerful Cleaning Method
		P. 123 Cleaning around the Print Heads
When the above operations are not effective	Cleaning of the print heads*1	P. 135 Light Choke Cleaning Method
		P. 137 Ink Renewal Method
When the operation panel is dirty	Cleaning the operation panel	P. 142 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 • Print head caps • Wiper cleaner • Flushing sponge	P. 143 Replacing the Wiper
		P. 144 Replacing the Print Head Caps
		P. 145 Replacing the wiper cleaner
		P. 146 Replacing the Flushing Sponges
When a cutting edge becomes dull	Replacing consumable parts	P. 147 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.

- **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 cartridges having sufficient remaining ink. 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 the sub power on once every week.**

  Switch on the sub power once a week. 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.

RELATED LINKS

- P. 126 Disposing of Discharged Fluid
- P. 70 Replacing Ink Cartridges
- P. 71 Replacing the Cleaning Liquid
- P. 76 Performing a Nozzle Drop-out Test
- P. 123 Cleaning around the Print Heads

Regular Maintenance

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Performing a Nozzle Drop-out Test 119
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Cleaning the Media Path 121
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Cleaning around the Print Heads 123
Cleaning and Maintaining the Flushing Sponges 124
Manual Cleaning Method 125
Disposing of Discharged Fluid 126
Precautions for Disposing of Discharged Fluid 126
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Preparations 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, the second and subsequent printing positions are printed vertically in relation to the first printing position.

Procedure

1. **Set up the media.**

   P. 26 Setup of New Media
   P. 46 Setup of Registered Media

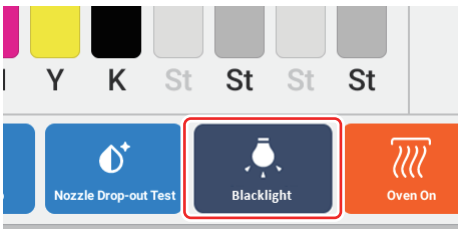
2. **Tap [Nozzle Drop-out Test] on the home screen.**

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

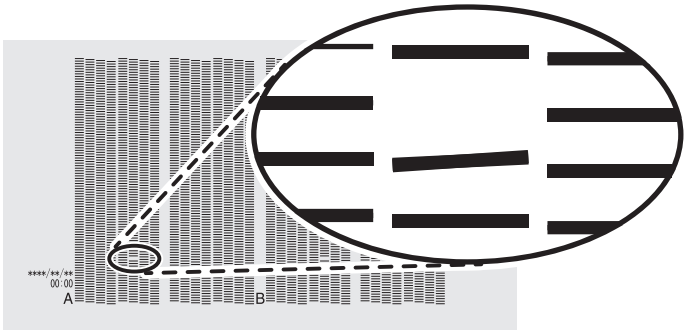
   Printing of the test pattern starts.

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

   You can check the discharge status of the CMYK ink with [**Print light**] and the discharge status of the structural ink with [**Black Light**]. Check these statuses while switching the light as necessary. Use the operation panel's home screen to switch the light.

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

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

   If no dot drop-out or dot displacement occurs, this operation is finished.

6. **Tap .**

   The home screen appears.

RELATED LINKS

- P. 129 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.

Switch off the sub power before performing cleaning.

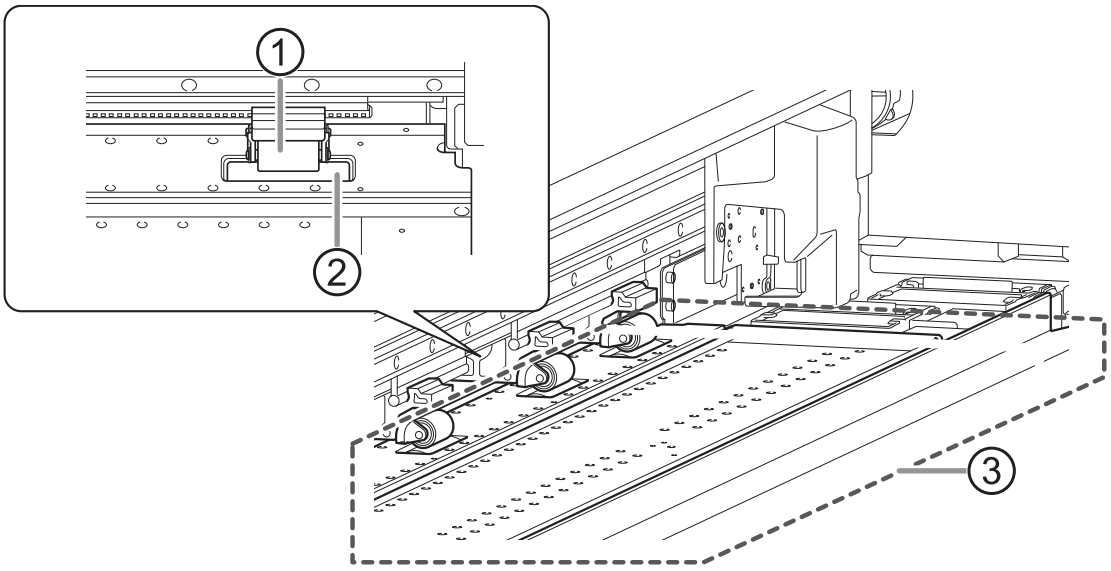
⚠ WARNING

Never use a solvent such as gasoline, alcohol, or thinner to perform cleaning.

Doing so may cause a fire.

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 with 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 and media clamp	Wipe away any buildup of ink, grime, or cut media on the media path and in the grooves.

Cleaning the Knife Carriage Roller

Dust and media scraps may affix to the separating knife carriage roller during media separation. Periodically wipe the area clean.

Switch off the sub power before cleaning the roller.

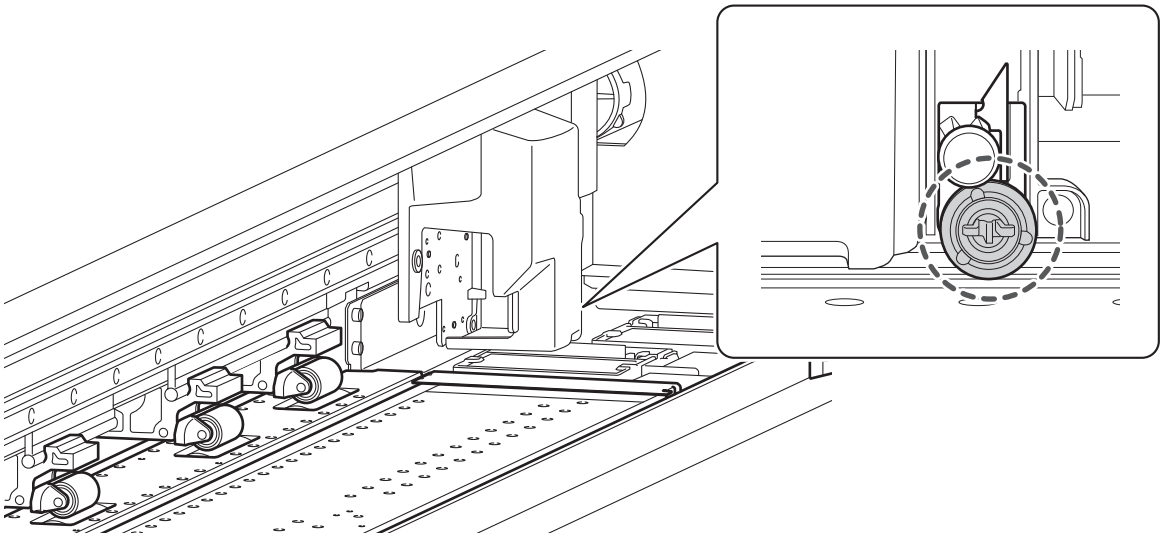
⚠ WARNING

Never use a solvent such as gasoline, alcohol, or thinner to perform cleaning.

Doing so may cause a fire.

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 head caps seal the nozzle surfaces of the print heads, preventing these surfaces from drying out and preventing dust from adhering to them. The wiper cleans the nozzle surface of the print heads, and the wiper cleaner cleans the wiper. The flushing sponge absorbs flushed ink to maintain nozzle spray performance.

These are important components that ensure the performance of the printer and require appropriate maintenance. The operation panel displays guidance (notifications) regarding when maintenance is required.

- 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 structural ink section. Using the same cleaning stick may lead to the structural ink and color ink mixing, resulting in ink hardening and discharge issues.
- Never use any implements other than the included cleaning sticks. Cotton swabs or other lint-producing items may damage the print heads.
- Do not use a dropper or cleaning liquid other than those included.
- Be sure to use new cleaning sticks. Reusing cleaning sticks will adversely affect the printing results.
- Do not put a cleaning stick that has been used for cleaning into the cleaning liquid. Doing so will deteriorate the cleaning liquid.
- When you perform manual cleaning, finish the work within 30 minutes to prevent the print heads from drying out. 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 the message [**The time for manual cleaning has arrived.**] or [**Fill the flushing sponge with cleaning liquid.**] appears, you can tap  on the home screen to check the notification details. Tap the notification to display a screen for performing the work.

RELATED LINKS

- P. 124 Cleaning and Maintaining the Flushing Sponges
- P. 125 Manual Cleaning Method

Cleaning and Maintaining the Flushing Sponges

When a message appears on the operation panel, clean around the flushing sponges and replenish the cleaning liquid in the color-section sponge.

IMPORTANT

- Be sure to use different cleaning sticks in the color ink side and the structural ink side. Using the same cleaning stick may lead to the structural ink and color ink mixing, resulting in ink hardening and discharge issues.
- Never use any implements other than the included cleaning sticks. Cotton swabs or other lint-producing items may damage the print heads.
- Do not use a dropper or cleaning liquid other than those included.
- Be sure to use new cleaning sticks. Reusing cleaning sticks will adversely affect the printing results.
- Do not put a cleaning stick that has been used for cleaning into the cleaning liquid. Doing so will deteriorate the cleaning liquid.

Required item			
			
Cleaning stick (2)	Dropper	Tweezers	Cleaning liquid bottle for maintenance

Procedure

1. **Tap ☰ on the operation panel.**
2. **Tap [Cleaning]>[Flushing sponge].**
3. **Tap [Execute] next to [Cleaning Liquid Replenishment].**
4. **Follow the instructions on the operation panel to perform the work.**

   After finishing the instructed work, tap › to display the next step. In this manner, perform each step of the work in order. If you want to check the previous step or perform it again, tap ‹.

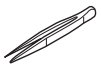
   When you finish the last step, tap [**Finish All**].
5. **Tap ⌂.**

   The home screen appears.

Manual Cleaning Method

IMPORTANT

- Be sure to use different cleaning sticks in the color ink side and the structural ink side. Using the same cleaning stick may lead to the structural ink and color ink mixing, resulting in ink hardening and discharge issues.
- Never use any implements other than the included cleaning sticks. Cotton swabs or other lint-producing items may damage the print heads.
- Do not use a dropper or cleaning liquid other than those included.
- Be sure to use new cleaning sticks. Reusing cleaning sticks will adversely affect the printing results.
- Do not put a cleaning stick that has been used for cleaning into the cleaning liquid. Doing so will deteriorate the cleaning liquid.
- 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.

Required item			
			
Cleaning sticks (5)	Dropper	Tweezers	Cleaning liquid bottle for maintenance

Procedure

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

   The first step is displayed on the operation panel. Finish the work within 30 minutes to prevent the print heads from drying out. After 30 minutes, a warning message appears.
5. **Follow the instructions on the operation panel to perform the work.**

   After finishing the instructed work, tap › to display the next step. In this manner, perform each step of the work in order. If you want to check the previous step or perform it again, tap ‹.

   When you finish the last step, tap [**Finish All**]. When print-head cleaning finishes after this work, the cleaning is finished. Dispose of used cleaning sticks.
6. **Tap ⌂.**

   The home screen appears.

Disposing of Discharged Fluid

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

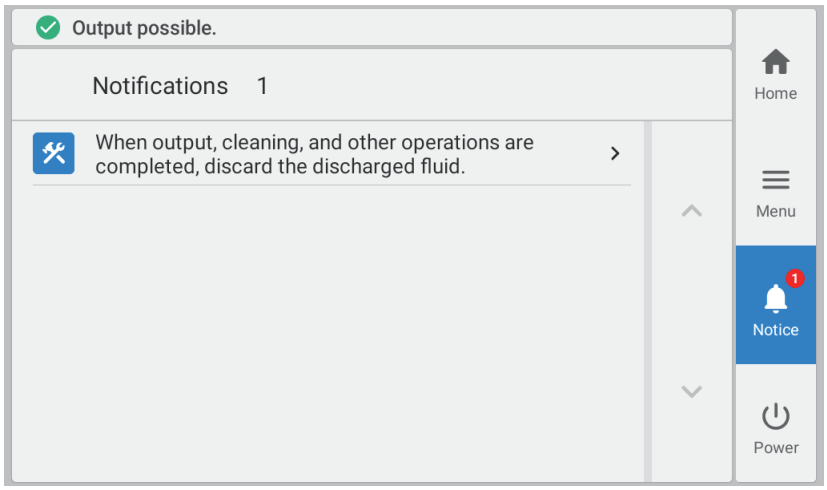
The [**When output, cleaning, and other operations are completed, discard the discharged fluid.**] message appears when a certain amount of discharged fluid has collected in the bottle. If this message appears, dispose of the discharged fluid.

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**] window 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].**

5. **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.

6. **Quickly attach the emptied bottle to the machine once more.**

7. **Tap [Finish].**

8. **Tap**  **.**

The home screen appears.

Advanced Maintenance

When Dot Drop-out or Dot Displacement Occurs 129
Performing Normal Cleaning 129
When Normal Cleaning Is Not Effective 131
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Powerful Cleaning Method 132
If Colors Are Uneven 135
Light Choke Cleaning Method 135
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Emergency Measure) Cleaning the Print Head Surface 139
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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

MEMO

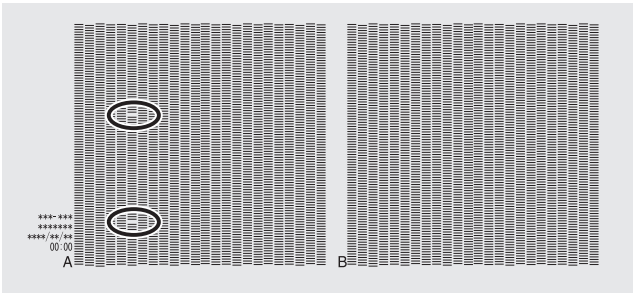
- **Printing tests after cleaning**
  If the media has already been set up, the **[After cleaning, perform a printing test.]** menu appears on the **[Normal Cleaning]** screen. When this setting is turned on, a printing test is performed after cleaning.
- **Aborting cleaning**
  To abort cleaning or the printing test after cleaning, tap to return to the home screen, and then cancel the cleaning or the printing test.

Procedure

1. **If media has not been loaded, set it up.**
   P. 26 Setup of New Media
   P. 46 Setup of Registered Media

2. **If a printing test has not been performed, perform one.**
   P. 76 Performing a Nozzle Drop-out Test

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

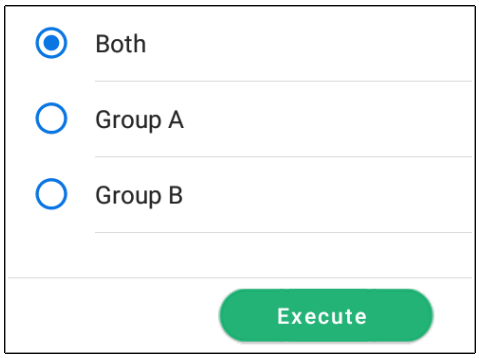
If the printing-test results are difficult to interpret

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

4. **Tap .**

5. **Tap [Cleaning]>[Normal Cleaning].**

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



7. **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.

8. **Tap ←.**

9. **Perform a printing test again.**

10. **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. 76 Performing a Nozzle Drop-out Test
- P. 131 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.

MEMO

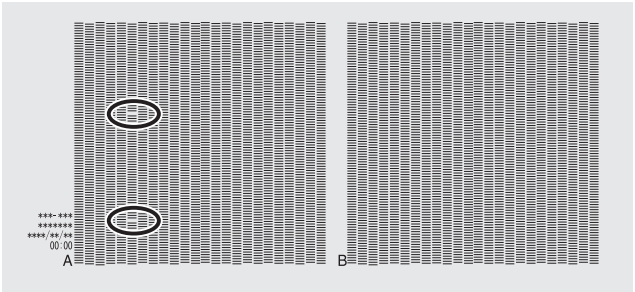
- **Printing tests after cleaning**
  If the media has already been set up, the [**After cleaning, perform a printing test.**] menu appears on the [**Medium Cleaning**] screen. When this setting is turned on, a printing test is performed after cleaning.
- **Aborting cleaning**
  To abort cleaning or the printing test after cleaning, tap to return to the home screen, and then cancel the cleaning or the printing test.

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. **If media has not been loaded, set it up.**
   P. 26 Setup of New Media
   P. 46 Setup of Registered Media
2. **If a printing test has not been performed, perform one.**
   P. 76 Performing a Nozzle Drop-out Test
3. **Tap** .
4. **Tap [Cleaning]>[Medium Cleaning].**
5. **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.



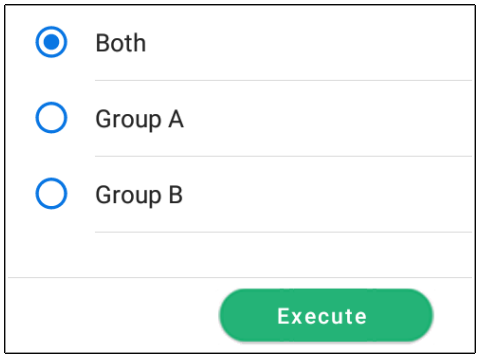
MEMO

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.

- Shine a black light on the printed media to check for the locations on which structural ink was printed. Depending on the media, these locations may be difficult to check. If it is difficult to see this ink, switch to a different media and perform the printing test again.

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



7. **Tap [Execute].**

Cleaning will start. On completion, you will return to the original screen.

8. **Tap ←.**

9. **Tap [Printing Test].**

10. **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. 132 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.

MEMO

- **Printing tests after cleaning**

If the media has already been set up, the [**After cleaning, perform a printing test.**] menu appears on the [**Powerful Cleaning**] screen. When this setting is turned on, a printing test is performed after cleaning.

- **Aborting cleaning**

  To abort cleaning or the printing test after cleaning, tap  to return to the home screen, and then cancel the cleaning or the printing test.

Procedure

1. **If media has not been loaded, set it up.**

P. 26 Setup of New Media
P. 46 Setup of Registered Media

2. **If a printing test has not been performed, perform one.**

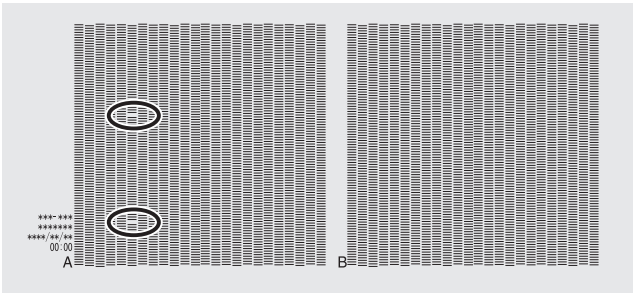
P. 76 Performing a Nozzle Drop-out Test

3. **Tap** **.**

4. **Tap [Cleaning]>[Powerful Cleaning].**

5. **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.

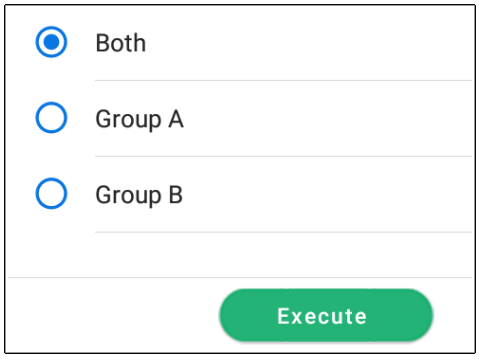


MEMO

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.
- Shine a black light on the printed media to check for the locations on which structural ink was printed. Depending on the media, these locations may be difficult to check. If it is difficult to see this ink, switch to a different media and perform the printing test again.

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



7. **Tap [Execute].**

   Cleaning will start. On completion, you will return to the original screen.

8. **Tap ←.**

9. **Tap [Printing Test].**

10. **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 "manual cleaning."

RELATED LINKS

- P. 123 Cleaning around the Print Heads

If Colors Are Uneven

Light Choke Cleaning Method

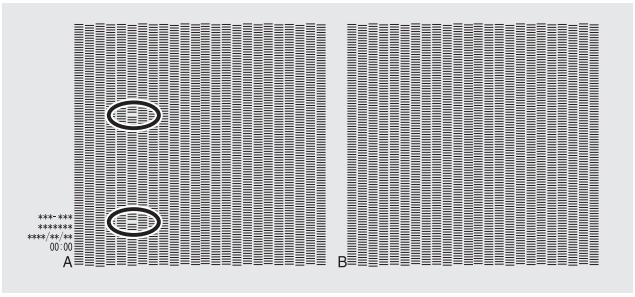
Perform this cleaning when printed colors are unstable or uneven, e.g., when color density is inconsistent, even if the same data is printed with the same settings. This will stabilize the output colors by agitating the ink.

IMPORTANT

Light choke cleaning consumes a lot of ink, and overly frequent use may damage the print heads themselves. Avoid performing this operation more than necessary.

Procedure

1. **If media has not been loaded, set it up.**
   P. 26 Setup of New Media
   P. 46 Setup of Registered Media
2. **If a printing test has not been performed, perform one.**
   P. 76 Performing a Nozzle Drop-out Test
3. **Tap** ☰**.**
4. **Tap [Maintenance]>[Light Choke Cleaning].**
5. **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.

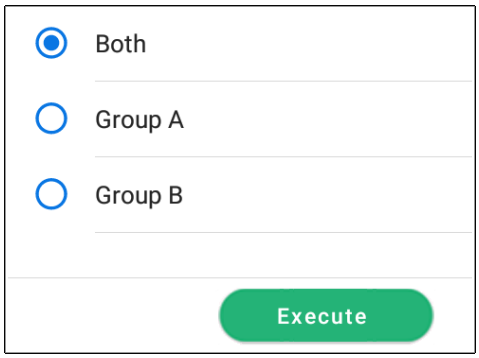


MEMO

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.
- Shine a black light on the printed media to check for the locations on which structural ink was printed. Depending on the media, these locations may be difficult to check. If it is difficult to see this ink, switch to a different media and perform the printing test again.

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



7. **Tap [Execute].**

Cleaning will start. On completion, you will return to the original screen.

8. **Tap ← twice.**

9. **Tap [Cleaning]>[Printing Test].**

10. **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.

11. **To finish cleaning, tap .**

The home screen appears.

RELATED LINKS

- P. 137 Ink Renewal Method

Handling Severe Dot Drop-out and Dot Displacement

Ink Renewal Method

Perform "Ink Renewal" in the following situations.

- When ink discharge issues such as dot drop-out are not corrected after performing cleaning using the cleaning function (normal, medium, powerful) and cleaning around the print heads

IMPORTANT

A large amount of ink will be discharged during ink renewal. Perform this operation only when ink discharge issues such as dot drop-out, dot displacement, and uneven colors cannot be corrected even after performing cleaning using the other cleaning functions (normal, medium, powerful, and manual).

RELATED LINKS

- P. 129 Performing Normal Cleaning
- P. 131 Medium Cleaning Method
- P. 132 Powerful Cleaning Method
- P. 123 Cleaning around the Print Heads

Perform a printing test.

Procedure

1. **Set up the media.**

   P. 26 Setup of New Media

   P. 46 Setup of Registered Media

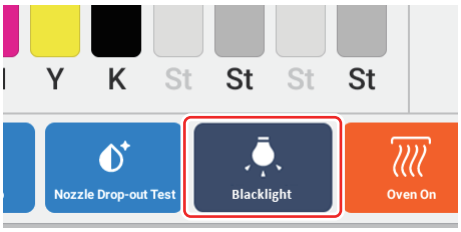
2. **Tap [Nozzle Drop-out Test] on the home screen.**

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

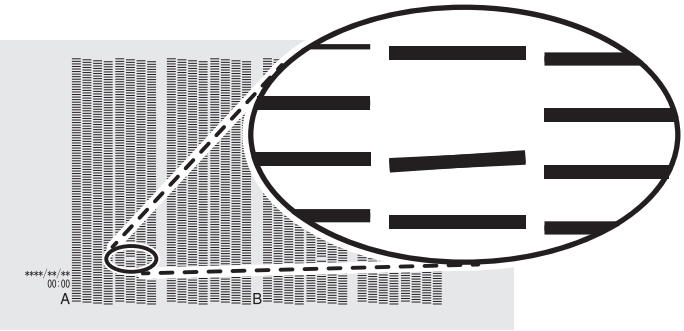
   Printing of the test pattern starts.

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

   You can check the discharge status of the CMYK ink with [**Print light**] and the discharge status of the structural ink with [**Black Light**]. Check these statuses while switching the light as necessary. Use the operation panel's home screen to switch the light.

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



5. **Close the front cover.**
   If no dot drop-out or dot displacement occurs, this operation is finished.

6. **Tap** .
   The home screen appears.

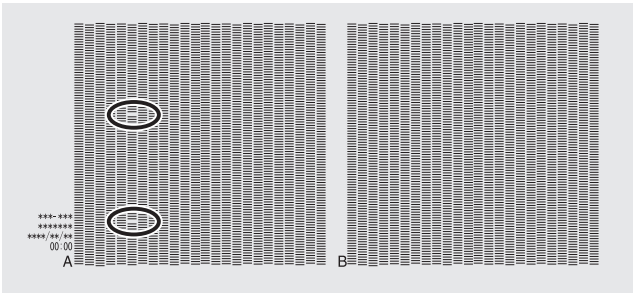
Start the [Ink Renewal] menu.

Procedure

1. **Tap** .

2. **Tap [Maintenance]>[Ink Renewal].**

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.
- Shine a black light on the printed media to check for the locations on which structural ink was printed. Depending on the media, these locations may be difficult to check. If it is difficult to see this ink, switch to a different media and perform the printing test again.

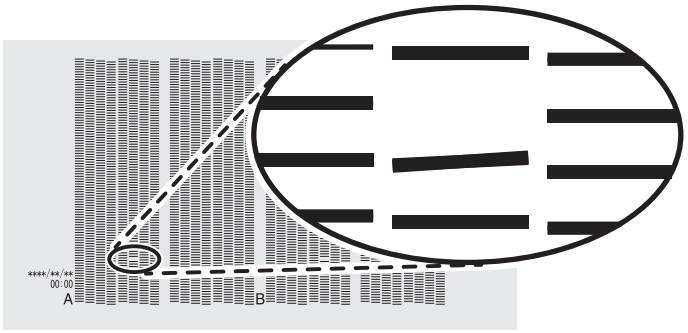
4. **Tap [Execute] on the group of print heads that needs to be cleaned.**
   Ink renewal inside heads starts. On completion, you will return to the original screen.

5. **Tap** .
   The home screen appears.

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.



4. If you have opened the front cover, close it.
   If no dot drop-out or dot displacement occurs, this operation is finished.
5. Tap .
   The home screen appears.

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.

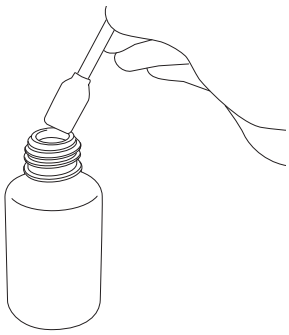
This operation is an emergency measure. It may damage defect-free parts depending on the symptoms, worsening the symptoms. If you have any questions, contact your authorized dealer.

IMPORTANT

- Be sure to use different cleaning sticks in the color ink section and the structural ink section. Using the same cleaning stick may lead to the structural 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.**



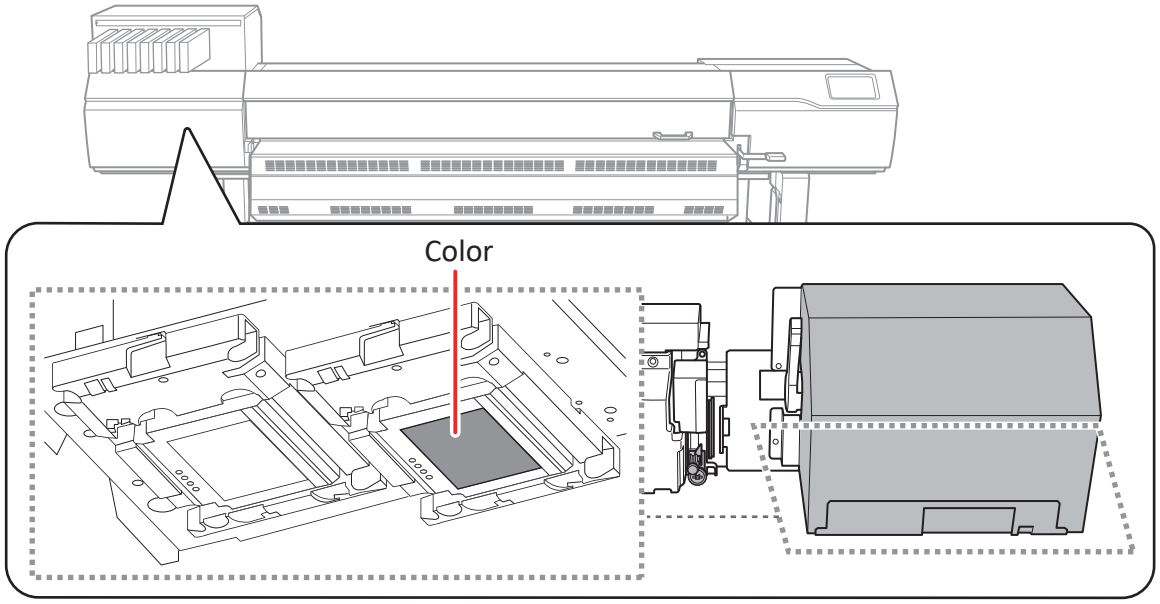
2. **Tap on the operation panel.**

3. **Tap [Cleaning]>[Manual Cleaning].**

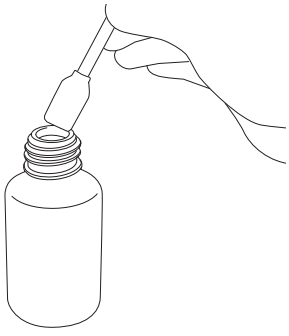
4. **Tap [Execute].**

5. **Very gently touch the cleaning stick against the print head surface (Color: color ink section).**

   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.

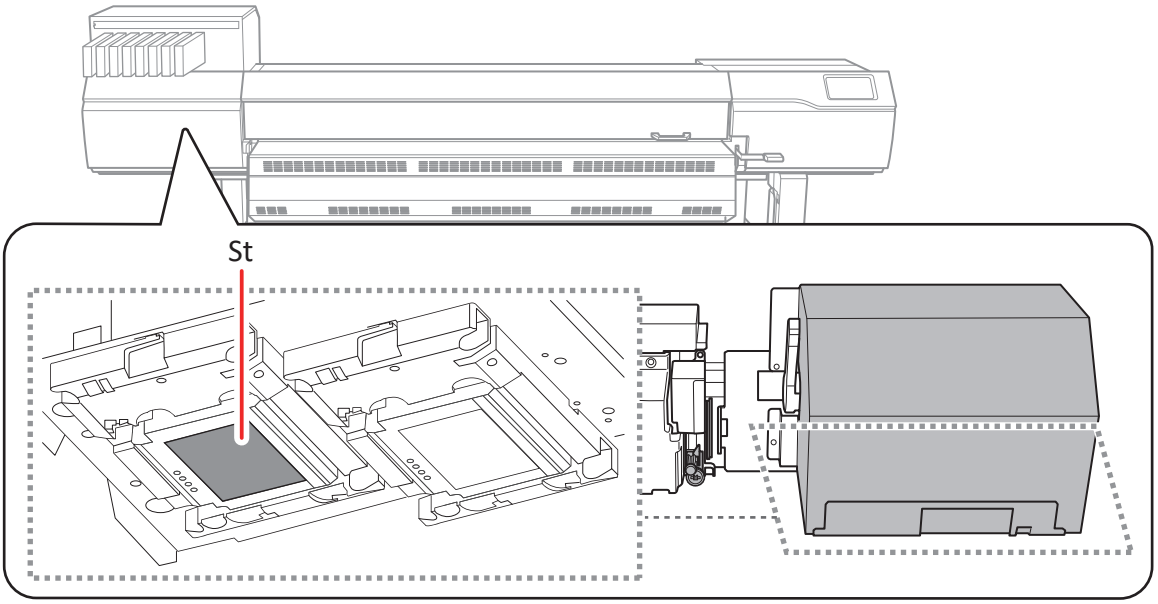


6. **Apply a large amount of cleaning liquid to a new cleaning stick.**



7. **Very gently touch the cleaning stick against the print head surface (St: structural ink section).**

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.



8. **When you have finished cleaning, tap [Finish All].**

9. **Tap** .

The home screen appears.

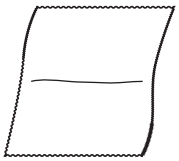
When the Operation Panel Is Dirty

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 skin irritation.

⚠ 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 the Wiper

The wiper is a component that you use when cleaning the print heads.

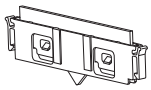
When it is time to replace the wiper, the message [**The time for wiper replacement has arrived.**] appears. In this situation, replace the wiper.

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	Cleaning stick	Cleaning liquid bottle for maintenance

MEMO

If the inside of the printer is dirty, refer to Cleaning the Machine(P. 121) 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**] window appears.
5. **Tap [Execute].**

   The first step is displayed on the operation panel. Finish the work within 30 minutes to prevent the print heads from drying out. After 30 minutes, a warning message appears.
6. **Follow the instructions on the operation panel to replace the wiper.**

   After finishing the instructed work, tap [›] to display the next step. (There are some procedures where the next step is displayed automatically as you perform the work. In these situations, there is no need to tap the button.) In this manner, perform each step of the work in order. If you want to check the previous step or perform it again, tap [‹].

   When you finish the last step, tap [**Finish All**]. Close the cover to finish the replacement. Dispose of the removed component.

7. Tap .

   The home screen appears.

Replacing the Print Head Caps

The print head caps seal the nozzle surfaces of the print heads, preventing these surfaces from drying out and preventing dust from adhering to them.

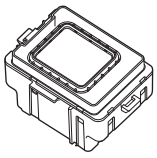
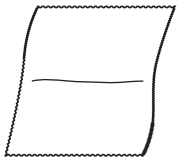
When it is time to replace a print head cap, the message [**The time for cap replacement has arrived.**] appears. In this situation, replace the print head cap.

For information about purchasing print head caps, 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		
		
Print head cap	Cloth (that is not fluffy)	Cleaning stick

MEMO

If the inside of the printer is dirty, refer to Cleaning the Machine(P. 121) and perform cleaning.

Procedure

1. **When the message [The time for cap replacement has arrived.] appears, tap [OK].**

2. **Remove any media.**

3. **Tap to display the messages.**

4. **Tap [The time for cap replacement has arrived.].**

   The [**Cap Replacement**] window appears.

5. **Tap [Execute].**

   The first step is displayed on the operation panel. Finish the work within 30 minutes to prevent the print heads from drying out. After 30 minutes, a warning message appears.

6. **Follow the instructions on the operation panel to replace the print head cap.**

   After finishing the instructed work, tap › to display the next step. (There are some procedures where the next step is displayed automatically as you perform the work. In these situations, there is no need to tap the button.) In this manner, perform each step of the work in order. If you want to check the previous step or perform it again, tap ‹.

When you finish the last step, tap [**Finish All**]. Close the cover to finish the replacement. Dispose of the removed component.

7. Tap .

   The home screen appears.

Replacing the wiper cleaner

The wiper cleaner is a component that removes ink, dust, and similar substances that have adhered to the wiper.

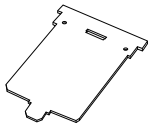
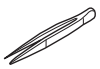
When it is time to replace the wiper cleaner, the message [**The time for wiper cleaner replacement has arrived.**] appears. In this situation, replace the wiper cleaner.

For information about purchasing wiper cleaners, 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			
			
Wiper cleaner	Tweezers	Dropper	Cleaning liquid bottle for maintenance

MEMO

If the inside of the printer is dirty, refer to Cleaning the Machine(P. 121) and perform cleaning.

Procedure

1. **When the message [The time for wiper cleaner replacement has arrived.] appears, tap [OK].**
2. **Remove any media.**
3. **Tap to display the messages.**
4. **Tap [The time for wiper cleaner replacement has arrived.].**

   The [**Wiper Cleaner Replacement**] window appears.
5. **Tap [Execute].**

   The first step is displayed on the operation panel. Finish the work within 30 minutes to prevent the print heads from drying out. After 30 minutes, a warning message appears.
6. **Follow the instructions on the operation panel to replace the wiper cleaner.**

After finishing the instructed work, tap › to display the next step. (There are some procedures where the next step is displayed automatically as you perform the work. In these situations, there is no need to tap the button.) In this manner, perform each step of the work in order. If you want to check the previous step or perform it again, tap ‹.

When you finish the last step, tap [**Finish All**]. Close the cover to finish the replacement. Dispose of the removed component.

7. Tap .

The home screen appears.

Replacing the Flushing Sponges

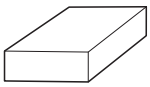
The flushing sponges are components that absorb the ink discharged to prevent clogging of the print heads.

When it is time to replace the flushing sponges, the message [**The time for flushing sponge replacement has arrived.**] appears. In this situation, replace the flushing sponges.

For information about purchasing flushing sponges, 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 sponge (structural ink section and color ink section: 1 each)	Tweezers

IMPORTANT

- Always use separate cleaning sticks and cleaning liquid with the structural ink and color ink sections. The structural ink and color ink mixing will result in ink hardening and discharge issues.

MEMO

If the inside of the printer is dirty, refer to Cleaning the Machine(P. 121) and perform cleaning.

Procedure

1. When the message [The time for flushing sponge replacement has arrived.] appears, tap [OK].
2. Remove any media.
3. Tap to display the messages.

4. **Tap [The time for flushing sponge replacement has arrived.].**
   The [**Replacing the Flushing Sponges**] window appears.

5. **Tap [Execute].**
   The first step is displayed on the operation panel. Finish the work within 30 minutes to prevent the print heads from drying out. After 30 minutes, a warning message appears.

6. **Follow the instructions on the operation panel to replace the flushing sponges.**
   After finishing the instructed work, tap › to display the next step. (There are some procedures where the next step is displayed automatically as you perform the work. In these situations, there is no need to tap the button.) In this manner, perform each step of the work in order. If you want to check the previous step or perform it again, tap ‹.
   When you finish the last step, tap [**Finish All**]. Close the cover to finish the replacement. Dispose of the removed components.

7. **Tap** .
   The home screen appears.

Replacing the Separating Knife

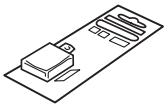
If the separating knife becomes dull, replace it with the included replacement knife.

⚠ 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. **Follow the instructions on the operation panel to replace the separating knife.**

After finishing the instructed work, tap › to display the next step. (There are some procedures where the next step is displayed automatically as you perform the work. In these situations, there is no need to tap the button.) In this manner, perform each step of the work in order. If you want to check the previous step or perform it again, tap ‹.

When you finish the last step, tap [**Finish All**]. Close the cover to finish the replacement. Dispose of the removed component.

6. **Tap** .

The home screen appears.

Troubleshooting Methods

Output Quality Problems

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Printed results are coarse or contain horizontal bands

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 occurs, perform cleaning of the print heads.

RELATED LINKS

- P. 76 Performing a Nozzle Drop-out Test
- P. 77 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. 87 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. 83 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. 83 Automatically Making Required Adjustments
- P. 85 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. 92 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. 46 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. 99 Managing the Media Settings

Have you tried [Slack Winding]?

If banding or other print quality problems occur, try **[Slack Winding]**.

RELATED LINKS

- P. 90 Setting the Take-up Unit

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 or if the humidity in the usage environment exceeds the allowable range, the media may wrinkle or come loose and contact the print heads.

RELATED LINKS

- P. 87 Changing the Print Head Height
- P. 26 Setup of New Media
- P. 46 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%RH to 60%RH (no condensation).

RELATED LINKS

- P. 123 Cleaning around the Print Heads

Are the pinch rollers or the media clamps dirty?

Periodically clean them.

RELATED LINKS

- P. 121 Cleaning the Machine

Colors are unstable or uneven

Did you try to mix the ink by shaking the ink cartridges?

If colors are uneven, remove the ink cartridges, and then shake them gently.

RELATED LINKS

- P. 128 Advanced Maintenance

Is the media wrinkled?

If the media is wrinkled or the humidity in the usage environment exceeds the allowable range and the media comes loose from the platen, colors may be uneven or the printing quality may suffer. If the media is wrinkled, load it again.

RELATED LINKS

- P. 26 Setup of New Media
- P. 46 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 cartridges. 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. 46 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. 99 Managing the Media Settings

Uneven Foaming

Is the temperature of the oven too high or too low?

Check whether the oven temperature setting is appropriate for the foaming media to use. An oven temperature that is too high or too low will negatively affect the foaming condition. If the heating temperature is not appropriate, foaming may proceed too far or not far enough, the foaming condition may be varied, and the media surface may be rough.

RELATED LINKS

- P. 93 Setting the Oven Temperature
- P. 94 Setting the Temperature of Each Heater in the Oven

The Media Doesn't Foam

Is the Oven Heater Temperature Setting Appropriate?

Check whether the oven temperature setting is appropriate for the foaming media to use. An oven temperature that is too high or too low will negatively affect the foaming condition. If the heating temperature is not appropriate, foaming may not occur or may proceed too far or not far enough, the foaming condition may be varied, and the media surface may be rough.

Due to the heater temperature setting being too low, printing may start even if the internal temperature setting is not reached. With media that foams depending on the internal temperature, exercise caution with the set temperature of the heater.

RELATED LINKS

- P. 93 Setting the Oven Temperature

Is the Internal Temperature at the Start of Printing Setting Appropriate?

The media may not foam if the internal temperature is too low. Check the foaming conditions of the media, and then increase the set internal temperature.

RELATED LINKS

- P. 96 Setting the Oven's Internal Temperature When Printing Starts

Media Feed Problems

Media Wrinkles 159
- Is the media loaded and set up straight and securely? 159
- Was loaded media allowed to stand for some time? 159
- Are the media clamps attached? 159
- Was the media loaded while the print heater was hot? 159
- Have you stored the media in a low-temperature room? 159
- Is the humidity of the room too high? 159
- Is the media sagging? 159

Media Feeding Is Not Straight 160
- Is the media loaded and set up straight and securely? 160

Media Feeding Is Not Smooth 161
- Is some other object coming into contact with the media? 161
- Is the media too thick? 161
- Are the grit rollers dirty? 161

A Media Jam Occurs! 162
- Is an error message displayed? 162
- Is the media warped or wrinkled? 162
- Is the height of the print heads too low? 162
- Are the grit rollers dirty? 162
- Are the media clamps installed? 162
- Is the media loaded and set up straight and securely? 162
- Is some other object coming into contact with the media? 163
- Is the media too thick? 163
- Was the media loaded while the oven was hot? 163

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. 46 Setup of Registered Media

Was loaded media allowed to stand for some time?

Foaming media has high absorbency and may be damaged if allowed to stand for some time even within environmental humidity. When printing ends, switch off the sub power and remove the media. Insert the removed media into a vinyl bag with desiccant and store the media in a low-humidity environment.

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. 92 Setting the Print Heater Temperature

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%RH to 60%RH (no condensation).

High humidity can cause the media to sag or become loose. If sagging media is used, it may come out wrinkled. If loose media is used, it may come into contact with the heads, damaging them and negatively affecting the printing result.

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. 46 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 New Media
- P. 46 Setup of Registered 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. 121 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. 176 Error Messages

Is the media warped or wrinkled?

Many factors can cause warping or wrinkling. Refer to the following and correct the problem.

RELATED LINKS

- P. 159 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. 87 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. 121 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. 46 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 New Media
- P. 46 Setup of Registered 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.

Was the media loaded while the oven was hot?

If you load the media while the oven is hot, sudden temperature increases may cause the media to shrink into a ball, clogging the inside of the oven. Allow the oven to cool off before loading the media.

Machine Problems

Why Has the Print-Head Carriage Stopped Moving? 165
What to Do First 165
If the Print Heads Still Do Not Move 165
The printer unit does not run 167
Is the power switched on? 167
Is [**Output possible.**] displayed? 167
Are any covers open? 167
Is the message [**Output is currently paused.**] displayed on the screen? 167
Is a message displayed on the screen? 167
Are the cables connected? 167
Is the LAN routing appropriate? 168
Are the LAN settings correct? 168
Did the software RIP end abnormally? 168
Is an [**Ink Cartridge Error**] displayed? 168
The Print Heater/Oven Does Not Become Hot 170
Has the media been set up? 170
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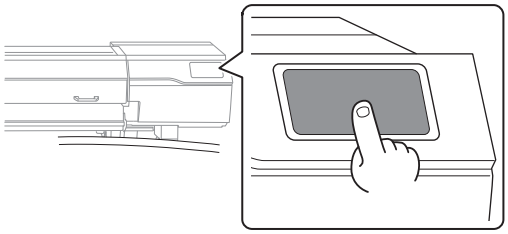
Why Has the Print-Head Carriage Stopped Moving?

If the print-head carriage stops over the platen, take action immediately to prevent the print 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-head carriage moves to the home position (inside the right cover), it means the operation has ended successfully.



If the print-head carriage still does not move

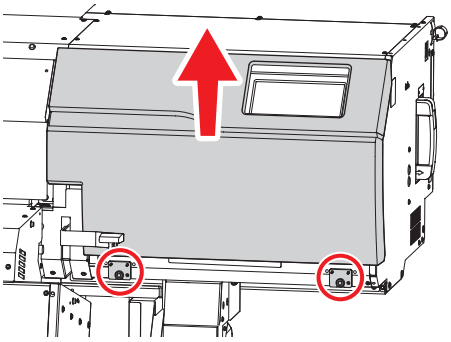
Try switching off the sub power, followed by the main power, then switching on the main power again, followed by the sub power.

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.

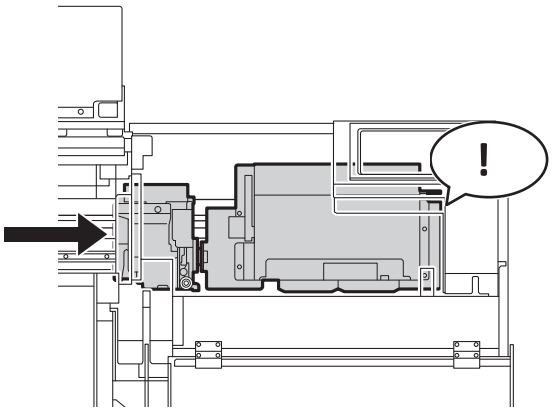
Procedure

1. **Switch off the sub power.**
2. **Switch off the main power, and then open the front cover.**
3. **Loosen the screws and 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. 22 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. 79 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. 65 Pausing and Canceling Output

Is a message displayed on the screen?

RELATED LINKS

- P. 173 Messages
- P. 176 Error Messages

Are the cables connected?

Connect the cables securely.

RELATED LINKS

- DA-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. 109 Viewing Network Information
- DA-640 Setup Guide

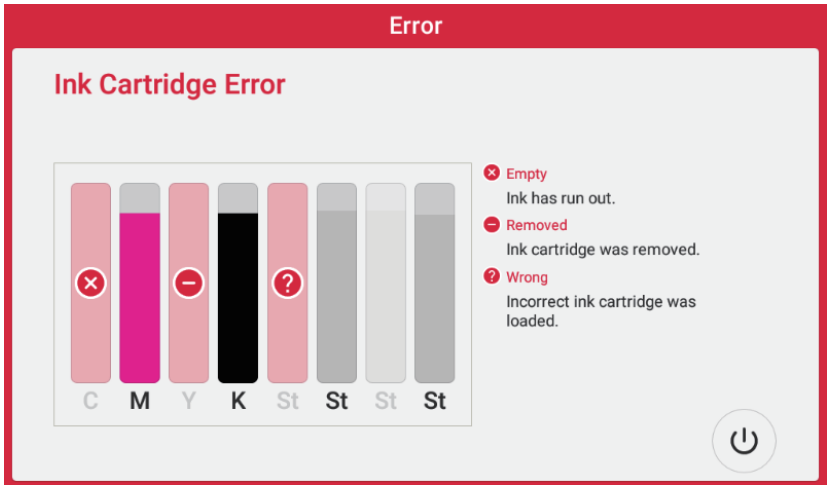
Did the software RIP end abnormally?

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/VersaWorks7)

Is an [Ink Cartridge Error] displayed?



When an [**Ink Cartridge 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 empty ink cartridge with a new one.

When an ink cartridge with the incorrect color is loaded

Remove the ink cartridge that was loaded incorrectly and load the ink cartridge with the appropriate color.

When an ink cartridge is removed or has not been securely loaded

Securely load the ink cartridge by pushing it all the way to the back.

RELATED LINKS

- P. 70 Replacing Ink Cartridges
- P. 176 [**Ink Cartridge Error**]

The Print Heater/Oven Does Not Become Hot

Has the media been set up?

By default, simply switching on the power does not make the media heating system warm up to the preset temperature. Set up the media and wait for the machine to warm up.

RELATED LINKS

- P. 92 Adjusting the Ink-drying Temperature and the Media-heating Temperature

Is the temperature of the room too low?

The print heater and oven 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. 147 Replacing the Separating Knife

Messages on the Operation Panel

Messages 173
- **[When output, cleaning, and other operations are completed, discard the discharged fluid.]** 173
- **[Fill the flushing sponge with cleaning liquid.]** 173
- **[The time for manual cleaning has arrived.]** 173
- **[The time for wiper replacement has arrived.]** 173
- **[The time for cap replacement has arrived.]** 173
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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. 126 If the Discharged Fluid Disposal Message Appears

[Fill the flushing sponge with cleaning liquid.]

This message appears when it is time to replenish the cleaning liquid in the flushing sponge.

Tap [**Fill the flushing sponge with cleaning liquid.**]>[**Execute**] to replenish the cleaning liquid.

RELATED LINKS

- P. 124 Cleaning and Maintaining the Flushing Sponges

[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. 123 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. 143 Replacing the Wiper

[The time for cap replacement has arrived.]

This message appears when it is time to replace the print head caps.

Tap [**The time for cap replacement has arrived.**]>[**Execute**] to replace the print head caps.

RELATED LINKS

- P. 144 Replacing the Print Head Caps

[The time for wiper cleaner replacement has arrived.]

This message appears when it is time to replace the wiper cleaner.

Tap [**The time for wiper cleaner replacement has arrived.**]>[**Execute**] to replace the wiper cleaner.

RELATED LINKS

- P. 145 Replacing the wiper cleaner

[The time for flushing sponge replacement has arrived.]

This message appears when it is time to replace the flushing sponge.

Tap [**The time for flushing sponge replacement has arrived.**]>[**Execute**] to replace the flushing sponge.

RELATED LINKS

- P. 146 Replacing the Flushing Sponges

[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.

[Replace the cleaning liquid pouch.]

This message appears if the cleaning liquid runs out or if no cleaning liquid has been inserted.

Replace or insert the cleaning liquid pouch, and then tap [**Replace the cleaning liquid pouch.**]>[**Install the cleaning liquid pouch.**]>[**Yes**].

[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. 46 Setup of Registered Media

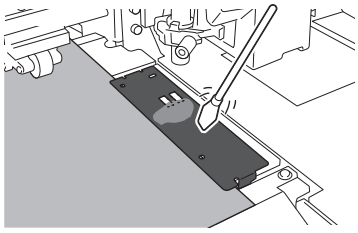
[Media clamps could not be detected.]

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. 46 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.

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 Cartridge Error]

This message appears when one of the following ink cartridge errors is detected.

MEMO

When an error occurs, the ⊗, ⊖, or ? icon is displayed next to the corresponding ink cartridge on the screen.

Implement appropriate countermeasures according to the error.

- **When ink runs out**

  ⊗[Empty][Ink has run out.]

  Install the new ink cartridge.

- **When an ink cartridge is removed**

  ⊖[Removed][Ink cartridge was removed.]

  Load the removed ink cartridge.

- **When an ink cartridge with the incorrect color is loaded**

  ?[Wrong][Incorrect ink cartridge was loaded.]

  Remove the incorrectly loaded ink cartridge, and then load the correct ink cartridge.

  When an incorrectly loaded ink cartridge is removed, ⊖ [Removed] [Ink cartridge was removed.] is displayed.

RELATED LINKS

- P. 70 Out-of-ink Warnings

[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

If the printing of the job is in progress, set up new media and output again.

RELATED LINKS

- P. 67 How to Remove Taken-up Media
- P. 26 Setup of New Media

[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 set up 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.

- B: Determine the positions of the media (transparent media, etc.).(P. 33)

This message appears when opaque media whose width is insufficient is set up.

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 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.

[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 there is no cleaning liquid.

Replace the cleaning liquid pouch in the cleaning cartridge with a new pouch, and then insert this cartridge into the printer.

[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, the print head carriage is capped and the data is canceled to prevent the print heads from drying out.

RELATED LINKS

- P. 87 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 (2.37 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.

[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 cleaning of the print heads, 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 to 16°C (60.8°F) or lower during startup or to 14°C (57.2°F) or lower 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 rises to 40°C (104°F) or higher during startup or to 42°C (107.6°F) or higher 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

[Pump Stop Error]

This message appears when an ink cartridge is pulled out during pump operation, such as during cleaning, or when the machine has no ink for 10 minutes or more.

Operation cannot be continued. Switch the sub power off, and then back on.

[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.

[Oven Error]

[Power Supply Error]

Power is not supplied to the oven.

Check whether power is supplied to the oven, such as if the power switch is on and the power cord is connected.

[Temperature Increase Error]

A problem occurred while the temperature of the oven was increasing.

The temperature of the built-in heater does not rise to the set value. Set up the media and output again.

Other than the above

There may be a problem with the oven 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.

Appendix

Operations When Moving the Unit

Contacting Your Authorized Dealer When Moving the Machine..... 183

Contacting Your Authorized Dealer When Moving the Machine

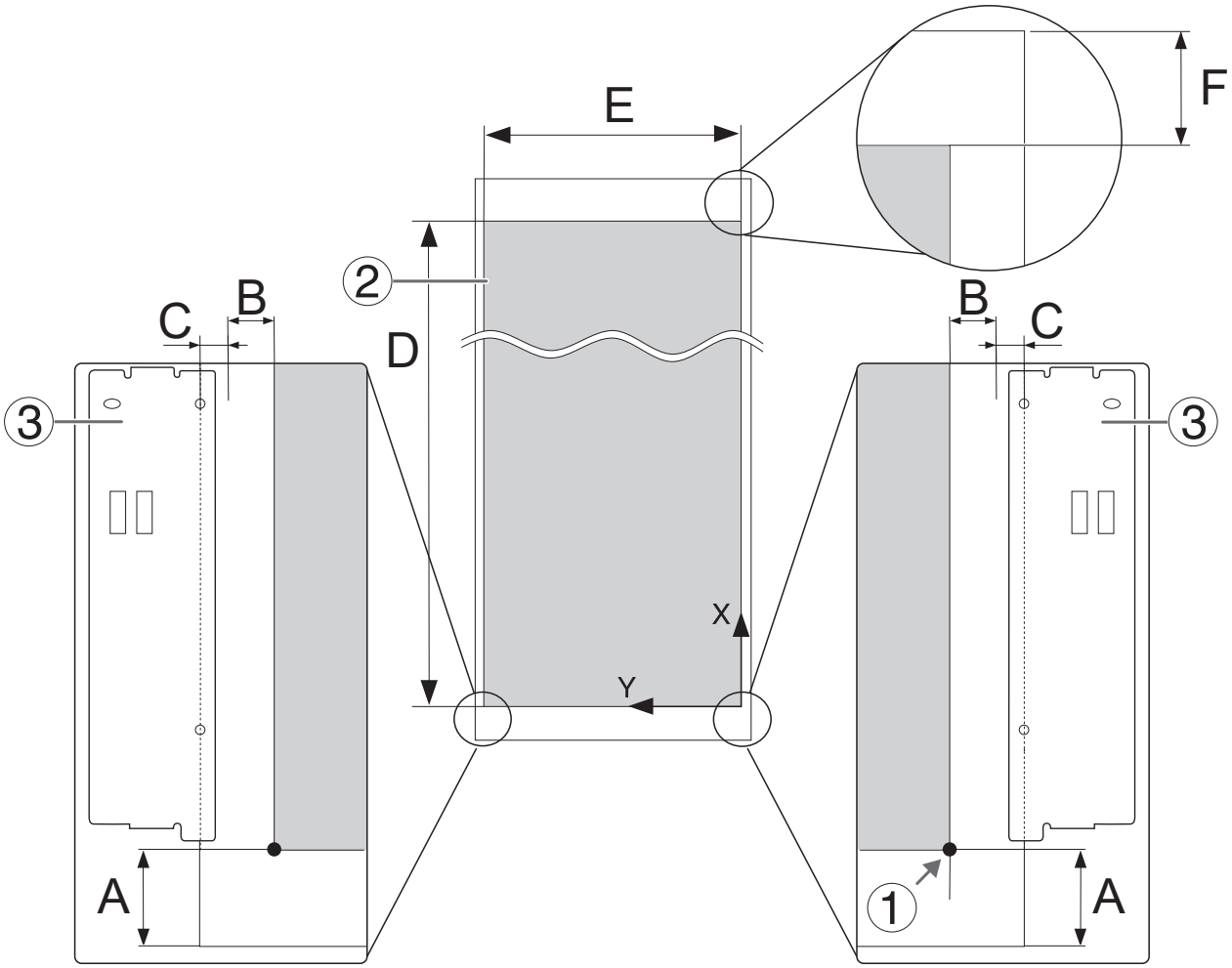
This machine must be moved by a suitably qualified worker. Contact your authorized dealer for help before moving the machine.

Main Specifications

Maximum Printing Area and Margins 185

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	130 mm (5.12 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 (7,874.01 in.)
E	Max. 1,615 mm (63.58 in.) * When printing with the media clamps removed
F	650 mm (25.59 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).

Memo

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