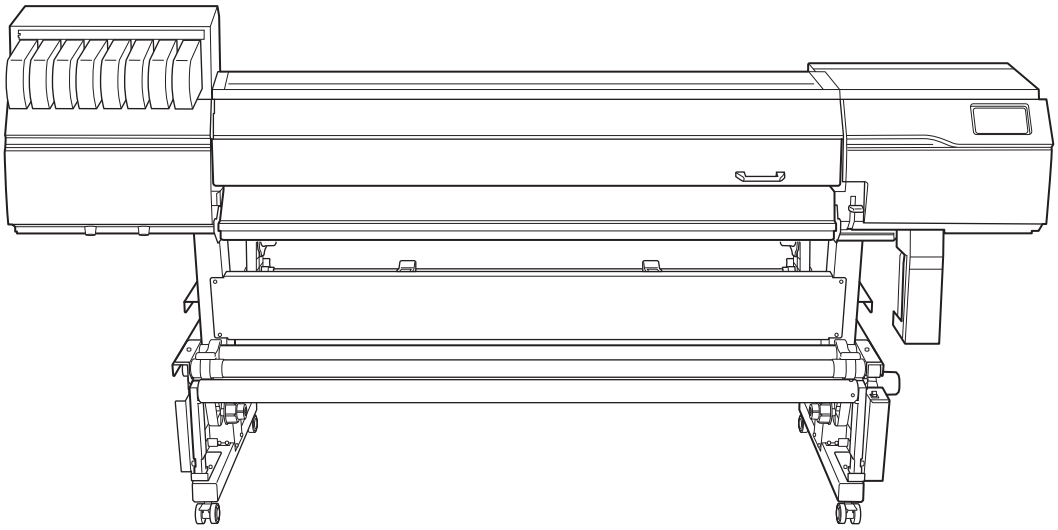
TrueVIS MG2-640/MG2-300

User's Manual



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Basic Handling Methods

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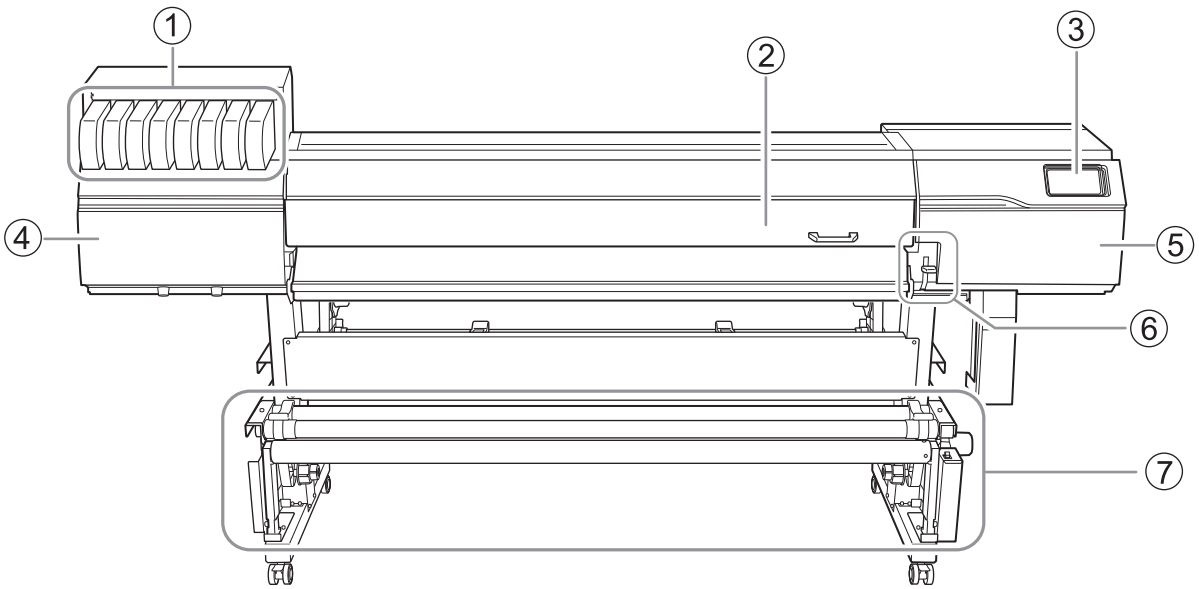
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Part Names and Functions

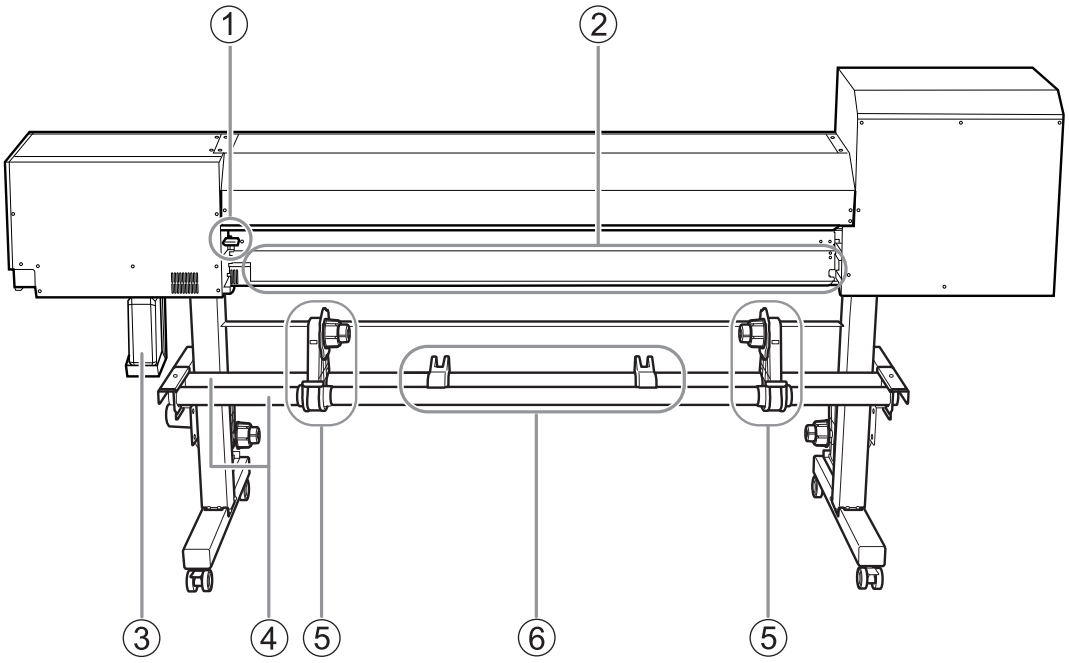
Printer Unit

Front



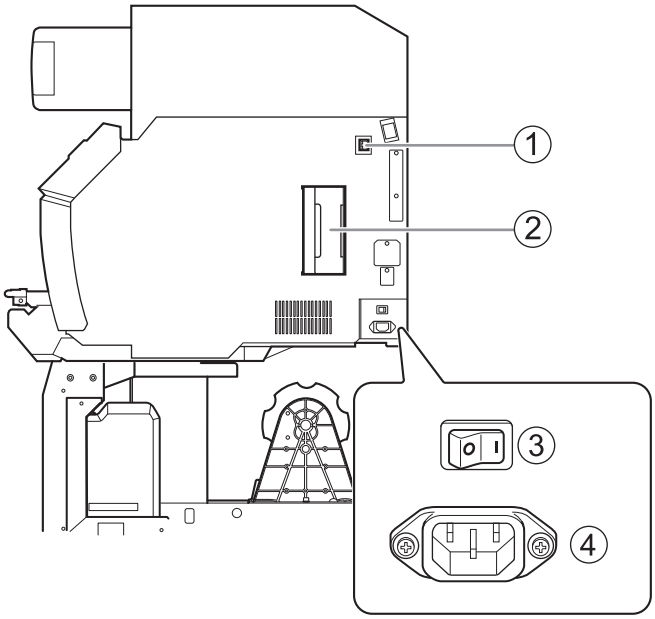
No.	Name	Function overview
①	Cartridge slots	Insert ink cartridges in which ink pouches have been loaded.
②	Front cover	Prevents contact with the print heads and other such fast-moving parts when the machine is operating. This cover also blocks ultraviolet light from the UV lamp and prevents dust from entering the machine. Keep this cover closed when not loading media or performing maintenance.
③	Operation panel	The panel used to operate the machine. P. 15 Operation Panel
④	Left cover	Provides access to the interior of the left side of the machine. Open this cover when performing maintenance such as cleaning around the print heads.
⑤	Right cover	Provides access to the interior of the right side of the machine. Open this cover when performing maintenance such as cleaning.
⑥	Loading lever (front)	Secures the media in place and releases it. Use this lever when working at the front of the machine. Lowering the lever secures the media in place.
⑦	Take-up unit	Takes up the media after printing. This prevents the printed media from touching the floor.

Rear



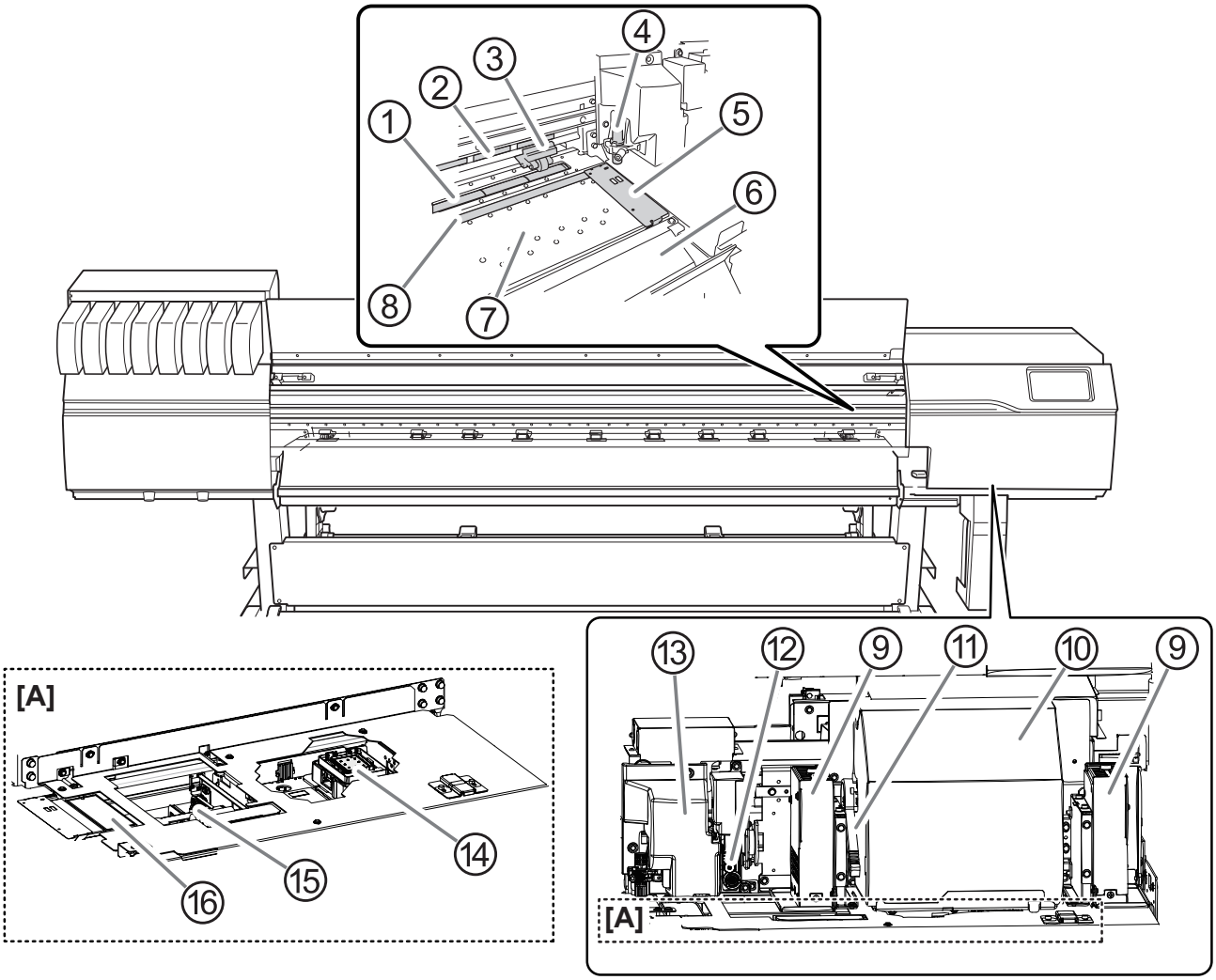
No.	Name	Function overview
①	Loading lever (rear)	Secures the media in place and releases it. Use this when working behind the machine. Lowering the lever secures the media in place.
②	Rear UV shield	Blocks the light from the UV lamp during printing. Open this shield when you load the media and close it when you are finished loading the media. Printing is not possible with the UV shield open.
③	Drain bottle	Discharged fluid is stored in this bottle. A message prompting you to dispose of discharged fluid appears when a certain amount of discharged fluid has collected in the bottle. P. 283 Disposing of Discharged Fluid
④	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.
⑤	Media holders	Hold the roll media. Fit the paper tube of the media onto the end caps of the media holders.
⑥	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.

Side



No.	Name	Function overview
①	Ethernet connector	Connects an Ethernet cable.
②	Cleaning liquid cartridge slot	Stores a cleaning liquid cartridge containing a cleaning liquid pouch.
③	Main power switch	Switches the main power to the machine on or off.
④	Power-cord connector	Used to connect the power cable from which power is supplied to the machine.

Front Cover Interior/Print Head Carriage Area



[A]: With the print-head carriage moved to the left during manual cleaning or other maintenance

No.	Name	Function overview
①	Grit roller	Transports the media.
②	Grit pattern	Indicates the location of a grit roller. When loading media, be sure to place the pinch rollers within the ranges indicated by these patterns.
③	Pinch roller	Clamps the media together with the grit roller for transporting. The roller can be raised or lowered by moving the loading lever up or down.
④	Blade holder	Houses the blade used during cutting.
⑤	Media clamp	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.
⑥	Apron	This is the path over which the media passes. A front heater that heats the media to prevent it from coming loose is built in.
⑦	Platen	This is the path over which the media passes. A suction fan that keeps the media from coming loose is built in.

No.	Name	Function overview
⑧	Blade protector	Protects the cutter blade as it penetrates the media during cutout.
⑨	UV-LED device	Irradiates the ultraviolet light after printing to cure the ink.
⑩	Print-head carriage	Transports the built-in print heads.
⑪	Height-adjustment lever	You can adjust the print-head height.
⑫	Separating knife	This separates the media.
⑬	Cutting carriage	The blade and the separating knife are inside here.
⑭	Print head cap	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.
⑮	Wiper	Cleans the print heads. Removes dirt and excess ink that have adhered to these heads.
⑯	Flushing sponge	Absorbs the ink being discharged (flushed) to prevent clogging.

If a Cover Opens during Operation

If the front cover, left cover, right cover, or rear UV shield (hereinafter these items are all referred to as the "cover") opens during an output operation, 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.

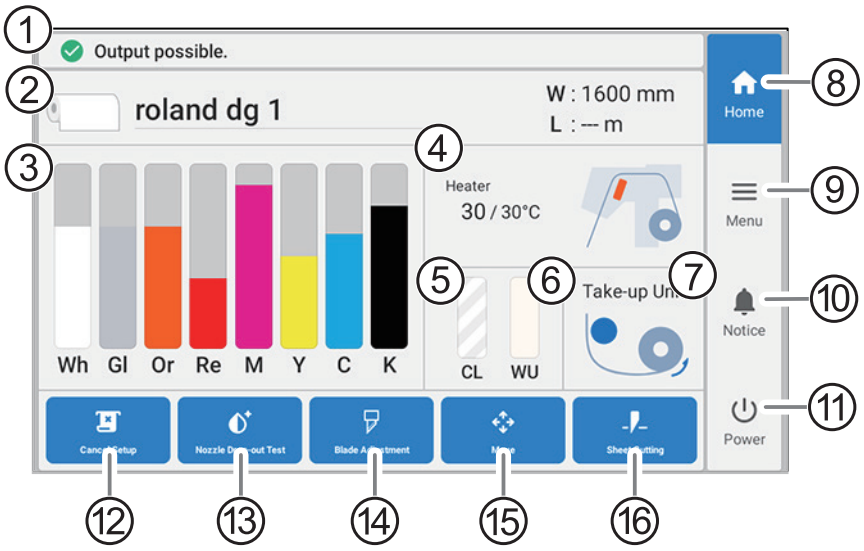
If you cannot continue the operation even after you close the cover, a nonrecoverable error may have occurred.

Additionally, if you open a cover during operation, the carriage may move slowly.

RELATED LINKS

- P. 355 Error Messages

Operation Panel



No.	Name	Details
①	Status bar	Displays the printer status and indicates the next operation. The following is displayed during printing. •  During printing, the number of copies to print is indicated with */*. The left side indicates the number of the copy currently being output. The right side indicates the total number of copies. •  During printing, the layers are indicated with */*. The left side indicates the layer currently being output. The right side indicates the total number of layers. • 00:10 Displays the remaining output time (approximate).
②	Media information	Displays the media name and media width (W) for media that has been set up. If the remaining media setting has been configured, the remaining media (L) is also displayed. 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. 251 Checking the Remaining Media When the base point is changed,  appears. Base
③	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.
④	Front heater temperature	The front heater temperature is displayed as current temperature/set temperature. Tapping one of these items displays a screen for the following settings. • When media is set up • **[Heater Temperature]** setting • When no media is set up • **[Standby Heater Temperature]** setting
⑤	Amount of cleaning liquid remaining	Displays the amount of cleaning liquid remaining. When the amount remaining is low,  is displayed. When there is none left,  is displayed. When the cleaning liquid cartridge is pulled out,  is displayed.

No.	Name	Details
⑥	Amount of wiper remaining	Displays the amount of wiper remaining. When the amount remaining is low, is displayed. When there is none left, is displayed.
⑦	Take-up unit	Displays the status of the take-up unit. Tap to display the **[Take-up]** screen, where you can set **[Take-up during Cutting]**, **[Take-up Method]**, and **[Take-up Direction]**. When **[Take-up during Cutting]**>**[Enabled]** is set, is displayed.
⑧	Home	Displays the home screen.
⑨	Menu	Displays various setting menus.
⑩	Notifications	Displays important information. When there are notifications, their number is displayed next to the icon.
⑪	Sub power	Turn off the sub power. Tap the operation panel to turn the sub power back on.
⑫	**[Setup]**/**[Cancel Setup]**	Starts/cancels the setting up of the media. P. 32 Setup of New Media P. 76 Setup of Registered Media
⑬	**[Cleaning]**/**[Nozzle Drop-out Test]**	Displays the menu related to the printing test and cleaning for the nozzle drop-out check.
⑭	**[Blade Adjustment]**	Sets cutting conditions. This is only enabled when media has been set up. P. 196 Fine-tuning the Cutting Conditions
⑮	**[Move]**	The media can be fed and the cutting carriage can be moved. You can also set the position moved to as the right edge of the printing area (the base point). P. 238 Adjusting the Output-start Location
⑯	**[Sheet Cutting]**	Activates the separating knife to separate the media. You can also perforate the media to take it up and separate it at a later time. This is only enabled when media has been set up. P. 122 Separating the Media

Menu List

Tap ☰ to display the list of operations.

MEMO

[**Media Settings**] only appears when media has been set up. When [**Menu operation in progress: Press [Home] to enable output.**] is displayed in the status bar, the display will automatically return to the home screen after 5 minutes.

Level 1	Level 2	Level 3	Level 4	Details
[Job Management]	[Direct Printing]			Outputs the job via Roland DG Connect Hub.
	[Printing Log]			Displays the printing history. You can check the [**Job Properties**] for the last five jobs. You can also check the [**Total Time**] and [**Total Area**] for printing that excludes cutting jobs.
[Media Settings][*1]	[List of Media Settings]			Lists the settings of the media that has been set up. Tap a setting to switch 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**], [**Feed Correction**], then [**Media Gap Adjustment**].
		[Feed Correction]	[Simple Correction (Auto)]	Adjusts the media feed amount during printing. With [**Simple Correction (Auto)**], a printed test pattern is read with a sensor to automatically set correction values.
			[Detailed Correction (Manual)]	Adjusts the media feed amount during printing. With [**Detailed Correction (Manual)**], the printed test pattern must be checked visually and the correction values entered manually.
		[Media Gap Adjustment]	[Simple Correction (Auto)]	Corrects the ink landing position. With [**Simple Correction (Auto)**], a printed test pattern is read with a sensor to automatically set correction values.
			[Detailed Correction (Manual)]	Corrects the ink landing position. With [**Detailed Correction (Manual)**], the printed test pattern must be checked visually and the correction values entered manually.
	[Cutting Settings]	[Blade Adjustment]		Sets cutting conditions such as [**Blade Force**] and [**Cutting Speed**].
		[Print & Cut Position Adjustment]		Corrects misalignment in the printing position and the cutting position during printing and cutting.
		[Crop Cut Position Adjustment]		Corrects misalignment in the crop mark positions and the cutting position when cutting with crop marks.
		[Cutting Distance Correction]		Corrects misalignment in the cutting line length due to changes in the media movement distance.
		[Over Cut]		Cutting the corners of the border of the cutting line slightly longer makes it possible to cut the corners attractively.
	[Heater Settings]	[Heater Temperature]		Sets the front heater temperature when media has been set up.

Level 1	Level 2	Level 3	Level 4	Details
	[Other Media Settings]	[Multi Sensor Adjustment]		Optimizes the status of the multi sensor used when reading the media width and with the automatic correction function.
		[Media Suction Force]		Adjusts the media suction force to prevent the media from coming loose or sticking.
		[Printing Movement Range]		Sets the print head carriage movement range during printing.
		[Media Sticking Prevention]		Performs media peel-off before printing.
		[Middle Pinch Auto Raise/Lower]		The middle pinch rollers go up automatically during pull-back printing or printing and cutting.
	[Batch Media Settings]			The minimum settings required for media setup can be configured by following the on-screen instructions on the operation panel.
[Media Management]				Displays a list of registered media. Up to 50 media names can be saved, and the following operations on media settings are possible. • Checking setting details in a list • Changing media names • Copying media settings • Duplicate as Media for Cutting • 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, clean the print heads. If the problem cannot be fixed, perform more powerful cleaning. 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.

Level 1	Level 2	Level 3	Level 4	Details
[Maintenance]	[UV Lamp Manual Cleaning]			Cleans dirt from the glass surface of the UV-LED device.
	[Wiper Replacement]			Replace the wipers.
	[Blade Replacement]			Replaces the blade used in cutting.
	[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.
	[Flushing Sponge Replacement]			Replaces the flushing sponge used to absorb the ink discharged (flushed) to prevent clogging.
	[Ink Renewal]			Perform this operation when ink discharge issues are not resolved after performing the work below. • [Normal Cleaning] • [Medium Cleaning] • [Powerful Cleaning] • [Manual Cleaning] Perform this operation when uneven color issues (except for white ink) are not resolved after performing the work below. • Ink mixing • [Light Choke Cleaning] Perform this operation when uneven color issues (white ink) are not resolved after performing the work below. • Ink mixing • [Ink Circulation] • [Light Choke Cleaning] However, this operation consumes a large amount of ink and may damage the print heads, so do not perform it more than necessary.
	[Ink Circulation]*2			If white ink uneven color is not resolved even after mixing the ink, circulate the ink. 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 [**Ink Circulation**].
	[Light Choke Cleaning]			Perform this operation when uneven color issues (except for white ink) are not resolved after performing the work below. • Ink mixing Perform this operation when uneven color issues (white ink) are not resolved after performing the work below. • Ink mixing • [Ink Circulation] However, this operation consumes a large amount of ink and may damage the print heads, so do not perform it more than necessary.
	[Drain Bottle]			Use this menu to discard discharged fluid at any desired time, regardless of any notifications or errors.
	[Automatic Maintenance]			Sets the [**Type**] and [**Frequency**] for each maintenance item that is performed automatically according to the printer service environment, types of products that are frequently output, and other factors. A maximum of five settings for automatic maintenance can be saved.
	[Automatic Sub Power On Settings]			This can be set so that the printer sub power is automatically turned on for each day of the week. Set the time at wihich to switch on sub power automatically, and you can also specify days when the sub power will not automatically be turned on.

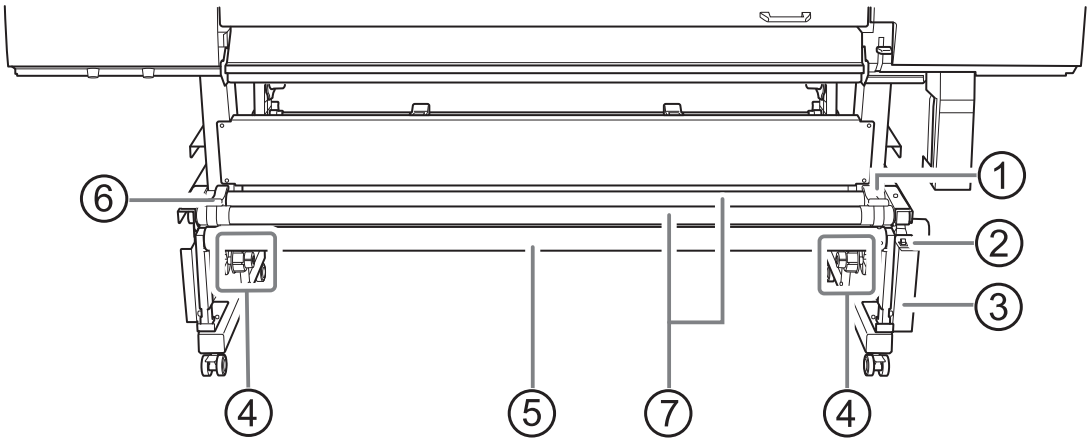
Level 1	Level 2	Level 3	Level 4	Details
[Preferences]	[Media Edge Detection]			Sets whether to detect the leading and trailing edges of the media. When using transparent media, whose edges cannot be detected, the media can be set up without detecting the edges by selecting [**Disable**].
	[Take-up]			Sets the [**Take-up during Cutting**], [**Take-up Method**], and [**Take-up Direction**] for the take-up unit.
	[Remaining Media Management]			Sets the amount of remaining media that has been set up and displays this amount. This amount can also be printed on the media.
	[Skewing Correction Support at Setup]			Sets whether to use sound and suction fans to assist in the setup process so that the media is not installed at an angle to the feed direction. When using transparent media or other media that the sensor does not work on, set to [**Disable**].
	[Printing Test Position]			Sets the direction for test pattern printing: [**Feed**] or [**Scan**].
	[Perforated Sheet Cutting]			Sets the perforated sheet cutting conditions.
	[Standby Heater Temperature]			Sets the heater temperature when media has not been set up.
	[Prefeeding at Output]			Determines whether to advance the media before output so that when the printer pulls out the media such as for cutting, the media will not be pulled forcibly, causing misalignment or distortion of the cut position.
	[Priority for Cutting Settings]			Sets whether to prioritize the cutting settings of the machine or the RIP software.
	[Notifications On/Off]			When this is set to on, notifications are displayed at the appropriate times. • [**Ink Mixing Notification**]*2 • [**Middle Pinch Roller Placement Notification**] • [**Media Clamp Placement Notification**] • [**Ink Expiration Date Notification**]
	[Sound at End of Printing]			Selects whether to play a sound at the end of printing.
	[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**], including registered media, to their factory default values.

Level 1	Level 2	Level 3	Level 4	Details
[System Information]	[Machine Information]			Displays the [Model], [Serial Number], [Ink Type], [Firmware Version], and [MAC Address].
	[Network]			Sets the [Obtain IP Address Automatically], [IP Address], [Subnet Mask], and [Default Gateway] to connect the machine to a computer.
	[Units]			Sets the length and temperature units.
	[Language]			Sets the language.
	[Date/Time]			Sets the current year, month, day, hour, minute, and second.
	[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.
	[2D Codes]	[User's Manual]		Displays the 2D code for accessing the website for viewing manuals.
		[Roland DG Connect]		Displays the 2D code for accessing [Roland DG Connect].
	[License]			Displays the software license information.

*1 This setting only appears when media has been set up.

*2 This menu item is only displayed on machines when the ink type includes white ink.

Take-up Unit



No.	Name	Function overview
①	Motorized media holder	Holds the right side of the paper tube for take-up. Move this part to the right or left to match the width of the paper tube and insert this tube to the appropriate positions on the end caps. The media holder's built-in motor rotates the end caps to take up the media.
②	MANUAL switch	Use this switch when manually taking up the media.
③	Control box	This controls the media take-up.
④	End caps	Hold the paper tube for take-up. Insert this tube to the appropriate positions on the end caps.
⑤	Dancer roller	Adjusts the tension applied to the media to ensure there is no slack in the media and that it is not too tight. Lower this roller to the rear when not using the take-up unit.
⑥	Left media holder	Holds the left side of the paper tube for take-up. Move this part to the right or left to match the width of the paper tube and insert this tube to the appropriate positions on the end caps.
⑦	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.

About the Media Used

Types of Media

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

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

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

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

	64-inch model	30-inch model
Width *1	335 to 1,625 mm (13.19 to 63.97 in.)	182 to 762 mm (7.17 to 30 in.)
Cuttable media thickness*1	0.08 to 0.22 mm (3.15 to 8.66 mil; depends on the material of the media)	
Maximum media thickness (including backing paper)*1	When performing printing only: 1.0 mm (39.37 mil) When performing cutting: 0.4 mm (15.75 mil)	
Maximum roll outer diameter	250 mm (9.84 in.)	
Paper tube (core) inner diameter	76.2 mm (3.0 in.) or 50.8 mm (2.0 in.)	

*1 Applies to both roll and sheet media

Maximum Roll Weight

- 64-inch model: 45 kg (99.21 lb.)
- 30-inch model: 30 kg (66.2 lb.)

MEMO

If using the take-up unit, this specification depends on the conditions of the take-up unit.

Other Conditions

Media such as the following cannot be used.

- Media whose end is attached to the paper tube (core)
- Media that is severely warped or that has a strong tendency to reroll
- 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
- Media that cannot withstand the heat of the front heater

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

MEMO

Depending on the RIP software you are using, you can set the perforated sheet cutting in the RIP software. With this type of cutting, the media is not separated, so the take-up unit can be used.

About the Paper Tube

Paper tubes are consumable items.

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

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

Drain Bottle

Precautions for Disposing of Discharged Fluid

⚠ WARNING

Never place discharged fluid or ink near an open flame.

Doing so may cause a fire.

⚠ CAUTION

To store discharged fluid temporarily, place it in the included drain bottle or in a durable sealed container such as a metal can or polyethylene tank, and cap the container tightly.

Any spillage or vapor leakage may cause fire, odor, or physical distress.

IMPORTANT

Dispose of discharged fluid properly, in accordance with the laws in effect in your locale.

Discharged fluid is flammable and contains toxic ingredients. Never attempt to incinerate discharged fluid or discard it with ordinary trash. Also, do not dispose of it in sewer systems, rivers, or streams. Doing so may have an adverse impact on the environment.

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.

Removing the Drain Bottle

Do not remove the drain bottle during maintenance operations and output.

Doing so may lead to unstable machine operation or dripping discharged fluid.

Only remove the drain bottle from the machine when:

- The message [**Discard the discharged fluid.**] appears and you are disposing of discharged fluid.
- You are disposing of discharged fluid by tapping [**Maintenance**]>[**Drain Bottle**] accessed with ☰.

Basic Operations

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Power Supply Operations

Turning the Power On

⚠ WARNING

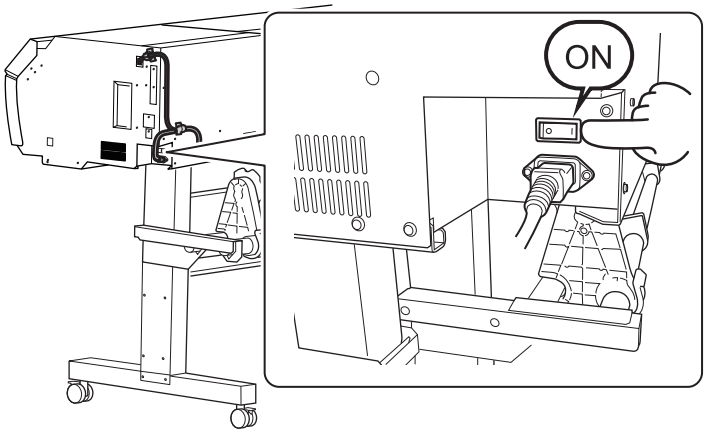
Remove any loaded media or switch off the sub power when printing is not being performed.

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

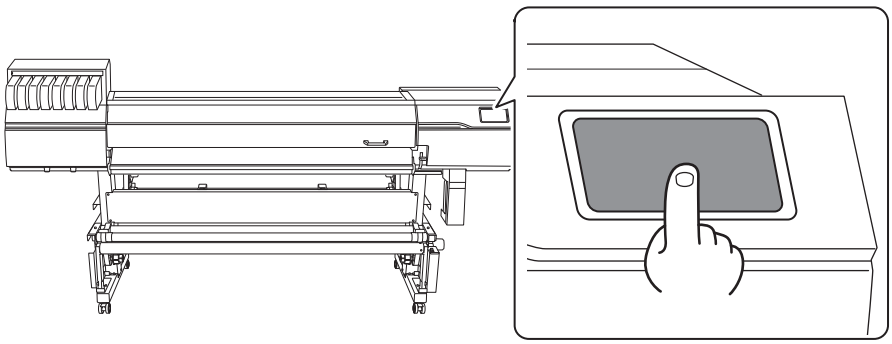
Procedure

1. **Close the front cover.**

2. **Turn on the main power switch.**



3. **Tap the operation panel.**



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

   The machine sub power is switched on.

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

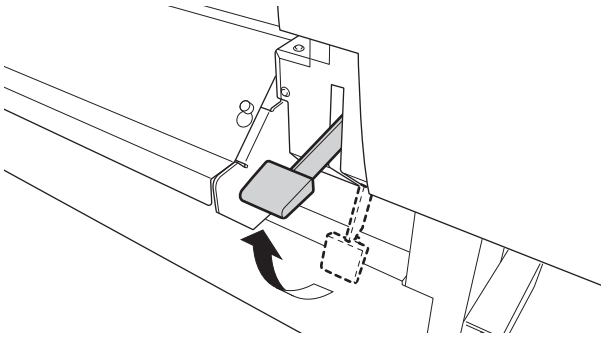
   The confirmation screen appears.

2. **Tap [Yes].**

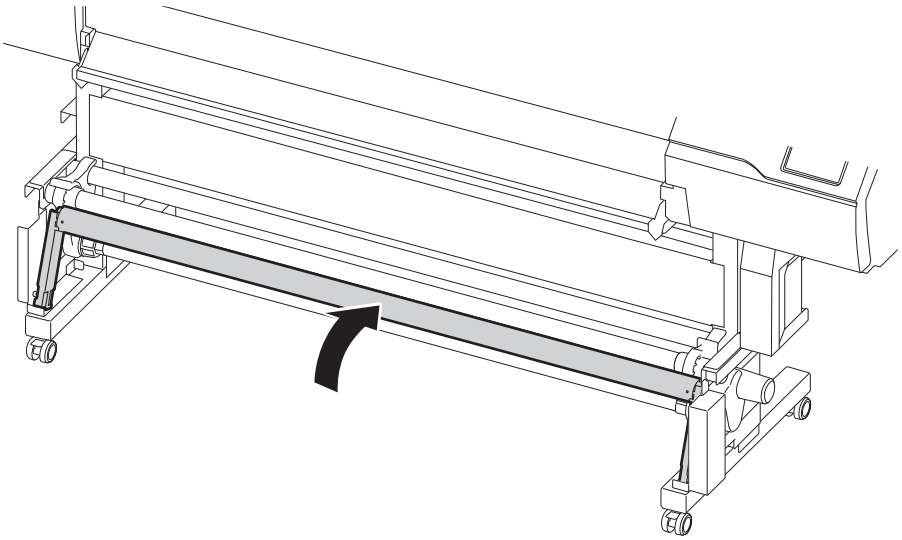
   The machine sub power is switched off.

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

   - When not using the machine, raise the loading lever even if the sub power is on.



   - Lower the dancer roller toward the rear.



Precautions When Operating the Power Supply

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.

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. Tapping the operation panel, opening or closing a cover, inserting or removing a cartridge, operating the pinch lever, or performing a similar action restores the machine to the normal mode. Note that when the machine is in sleep mode with media set up, sending print data from the computer restores the machine to the normal mode.

RELATED LINKS

- P. 255 Setting the Activation Interval for Sleep Mode (Power-saving Feature)

Setup of New Media

⚠ CAUTION

Do not touch the dancer roller needlessly.
The media take-up unit and feeder may move suddenly, which may result in injury.

Setup of Roll Media

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

⚠ CAUTION

Load the roll media correctly.
Otherwise the media may fall and cause injury.

⚠ CAUTION

The roll media is approximately 45 kg [99.21 lb.], 30-inch model: 30 kg [66.1 lb.]).
To avoid injury, handle the roll media with care.

⚠ CAUTION

Never load media that weighs over 45 kg [99.21 lb.], 30-inch model: 30 kg [66.1 lb.]).
The machine may fail to withstand the weight and tip over or cause the media to fall.

1. Installing the Media on the Media Holders

⚠ WARNING

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

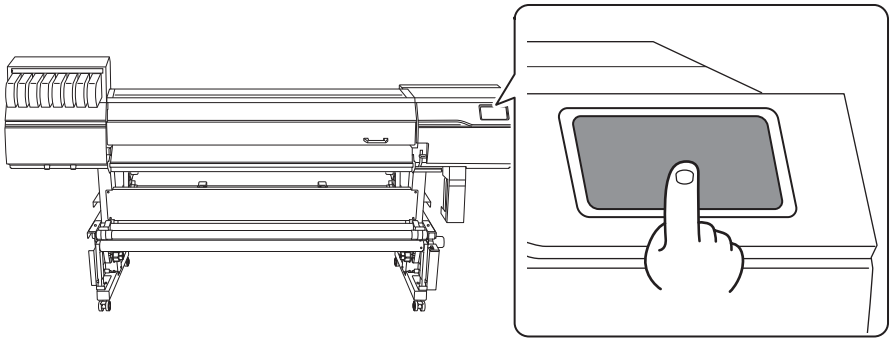
Attempting to lift heavy media in a manner that taxes your strength may cause physical injury. Also, if dropped, such items may cause injury.

MEMO

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.

Procedure

1. **Tap the operation panel.**

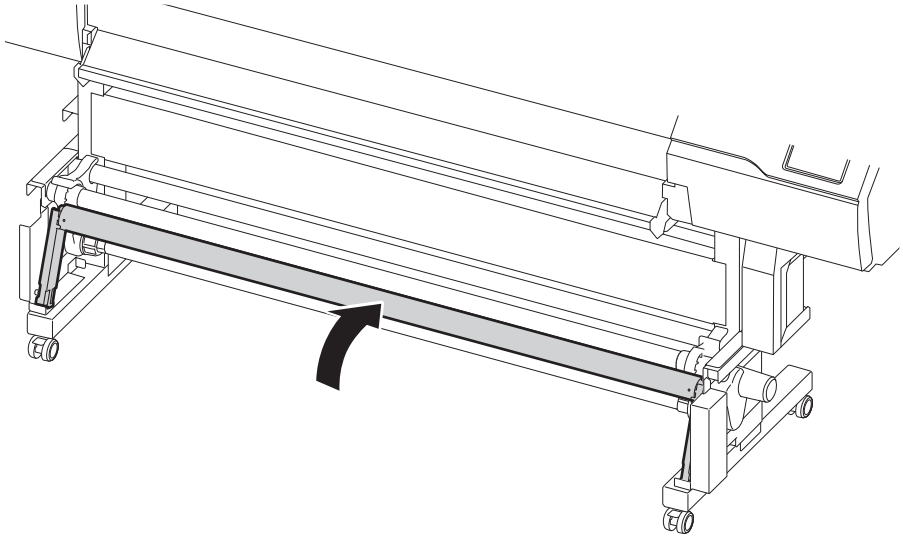


2. **When instructions appear on the screen, tap the operation panel again.**

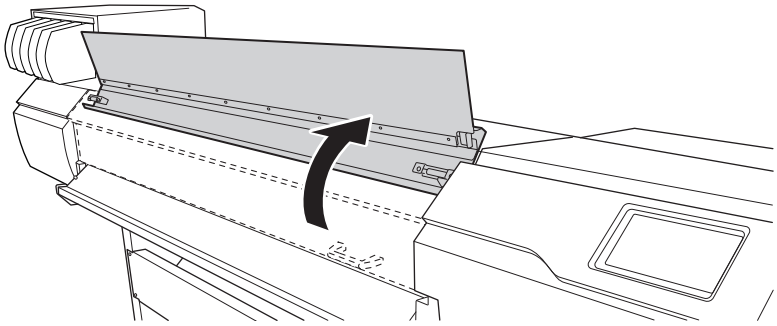
   The machine sub power is switched on.

3. **If you are using the take-up unit, perform the procedure under** **Setting the Take-up Unit(P. 190)****.**

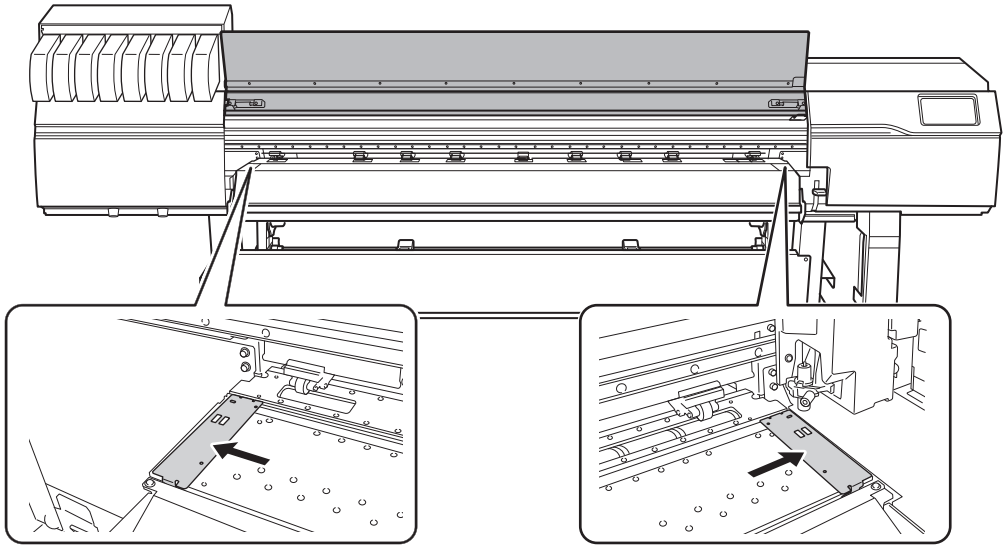
4. **Check that the dancer roller has lowered toward the rear.**



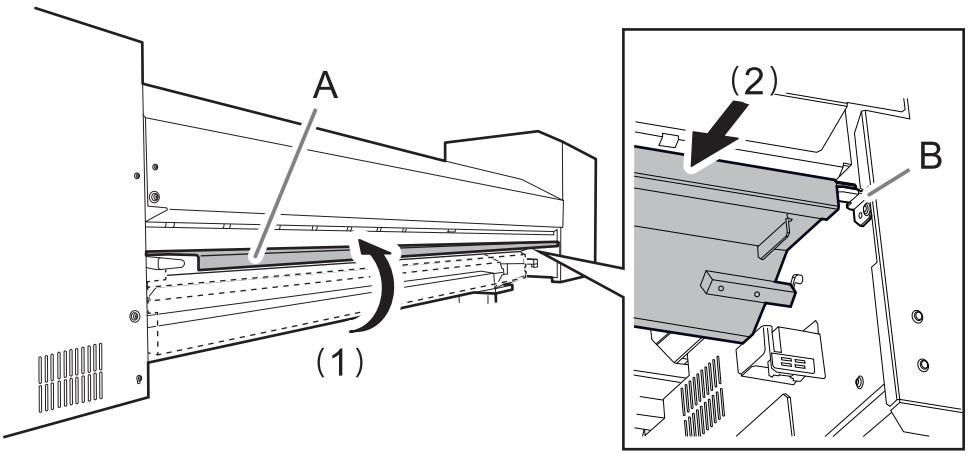
5. **Open the front cover.**



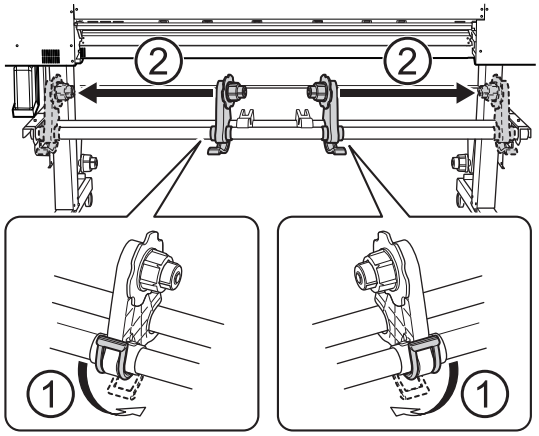
6. Move the media clamps to the outside of the grit rollers on the left and right edges respectively.



7. Move to the rear of the printer and open the rear UV shield.
   (1) Open the rear UV shield (A).
   (2) Push the rear UV shield to the front of the machine, and then place this shield on the left and right stoppers (B).



8. Move the media holders to the outside.



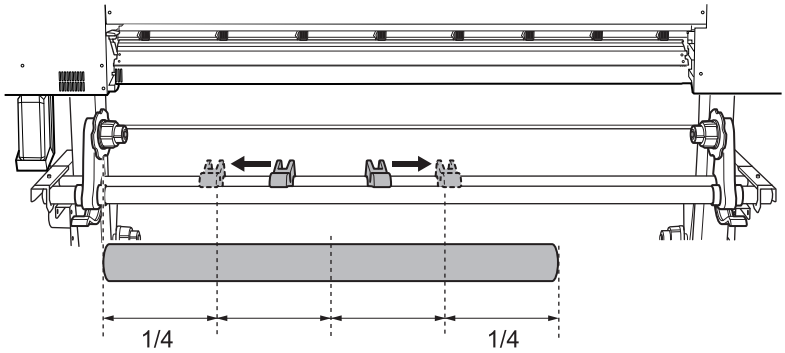
9. **Place the media on the machine.**

IMPORTANT

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

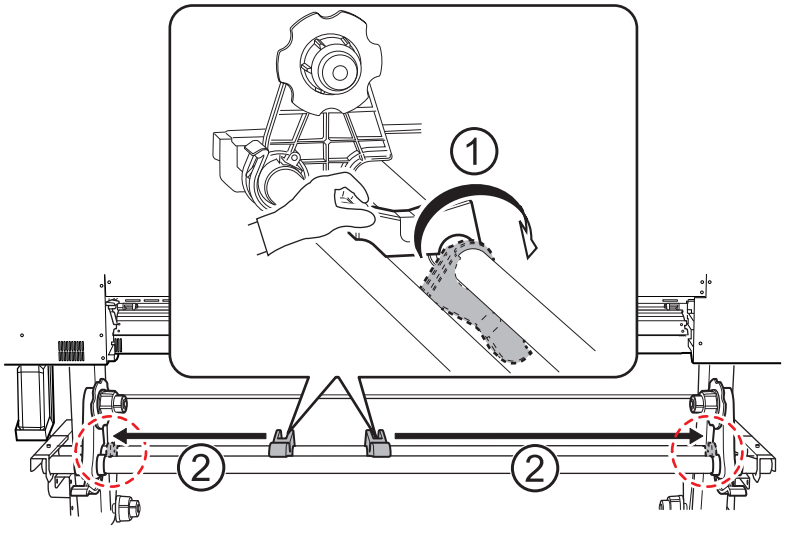
- Roll media with an outer diameter of 220 mm (8.66 in.) or less

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

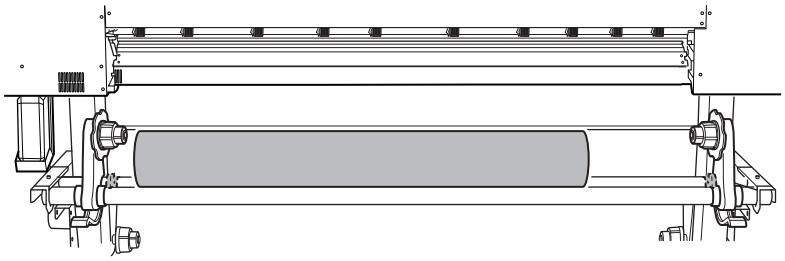


- Roll media with an outer diameter exceeding 220 mm (8.67 in.)

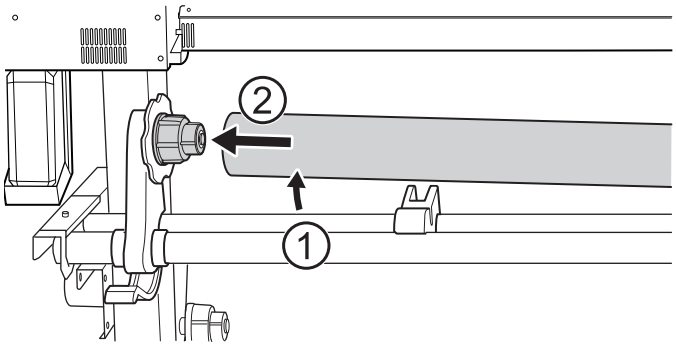
  a. Rotate the media stays to draw them to the media holders.



  b. Place the media directly between the two shafts.



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



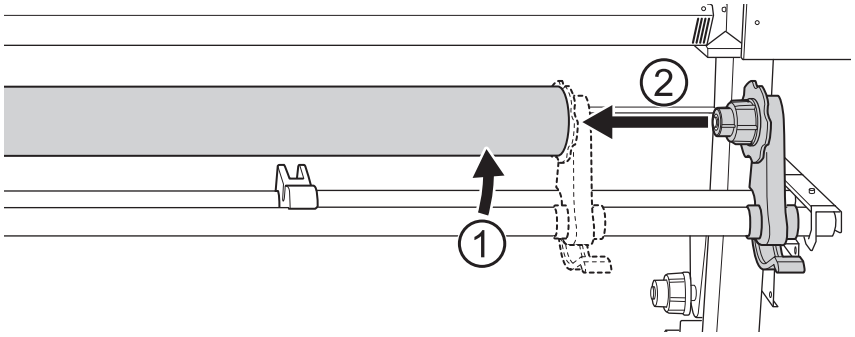
11. **Move the right media holder to fit its end cap onto the paper tube (core) of the media.**

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.

- For general media: 2. A: Determining the Positions of the Media(P. 37)
- For transparent media or if **[Preferences]**>**[Media Edge Detection]** is set to **[Disable]**: 2. B: Determining the Positions of Media (If **[Media Edge Detection]**: **[Disable]**)(P. 43)

2. A: Determining the Positions of the Media

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

Because the suction fan does not operate, the following procedure cannot be used to load media when using transparent media or media with high reflectance whose edges cannot be detected, or when **[Disable]** is set for **[Preferences]**>**[Media Edge Detection]**. In these cases, refer to 2. B: Determining the Positions of Media (If [Media Edge Detection]: [Disable])(P. 43).

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

Procedure

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

(1) **Tap** ☰.

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

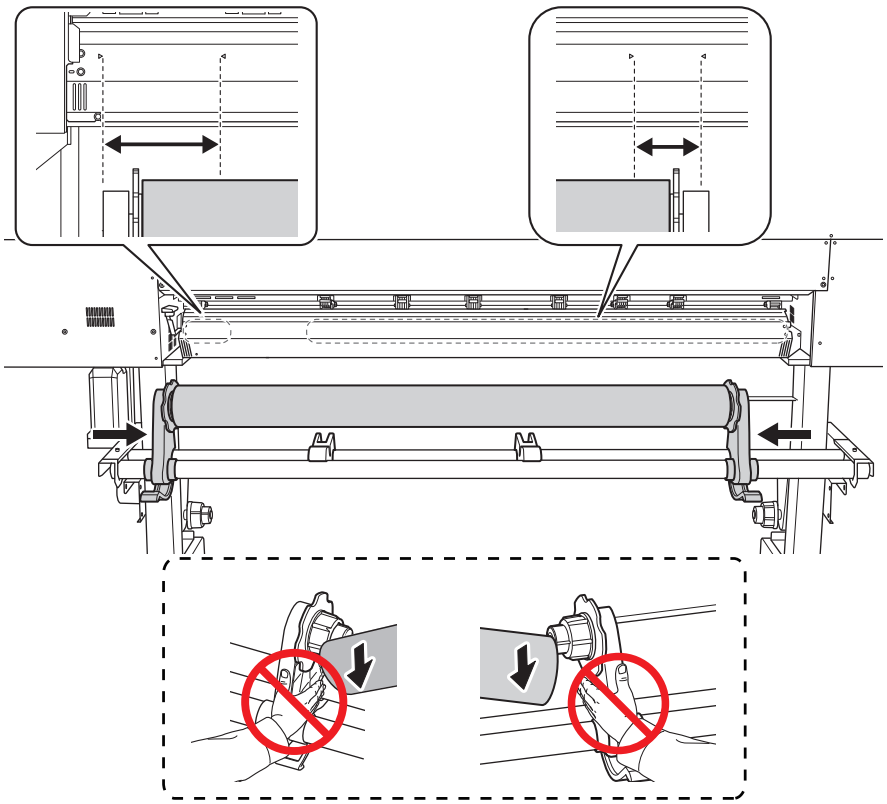
(3) **Select [Enable] and tap [Save].**

(4) **Press** ⌂ **to return to the home screen.**

2. **Determine the left and right positions of the media with the grit patterns used as the reference.**

Note the following points when determining the positions.

- Hold the media holders from the outside and move them.
- Ensure that the left edge of the media is positioned so that it is within the range of the grit pattern of the left edge.
- Ensure that the right edge of the media is positioned so that it is within the range of one of the grit patterns.



⚠ WARNING

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

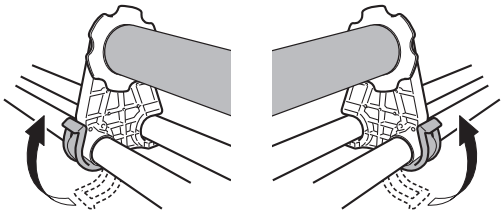
Doing so may cause the media to fall off the media holder and cause injury.

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.

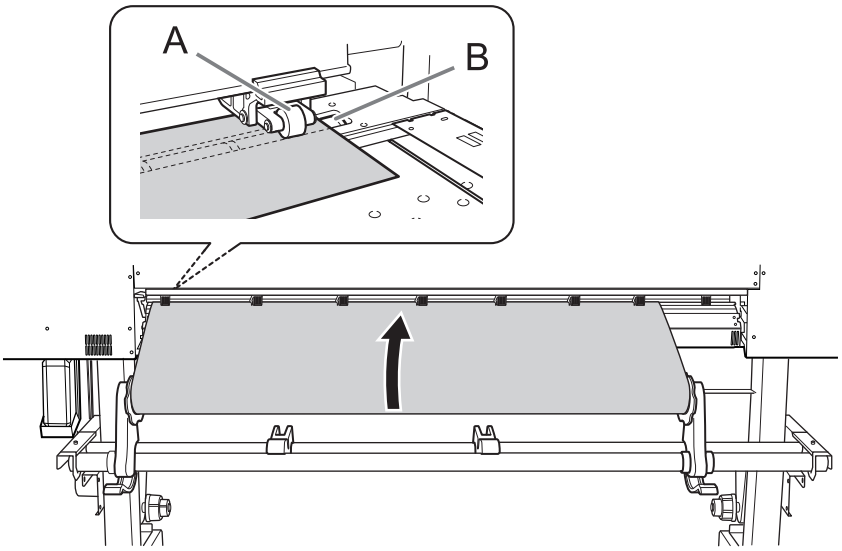
3. **Secure the media holders.**



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

Doing so will prevent media skewing.

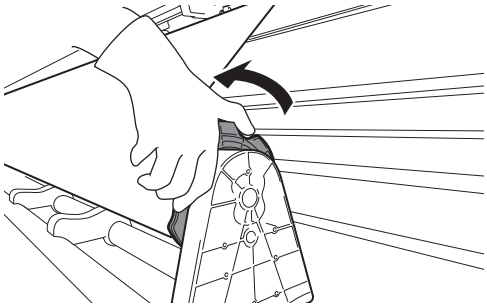
(1) **Pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**



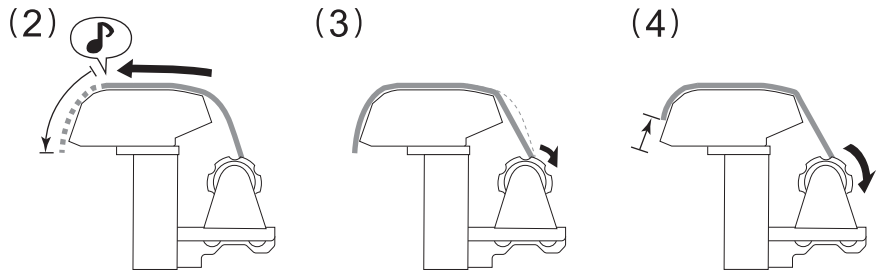
(2) **Feed the media until you hear a beep, and then additionally feed approximately 20 cm (7.87 in.) of the media.**

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.**



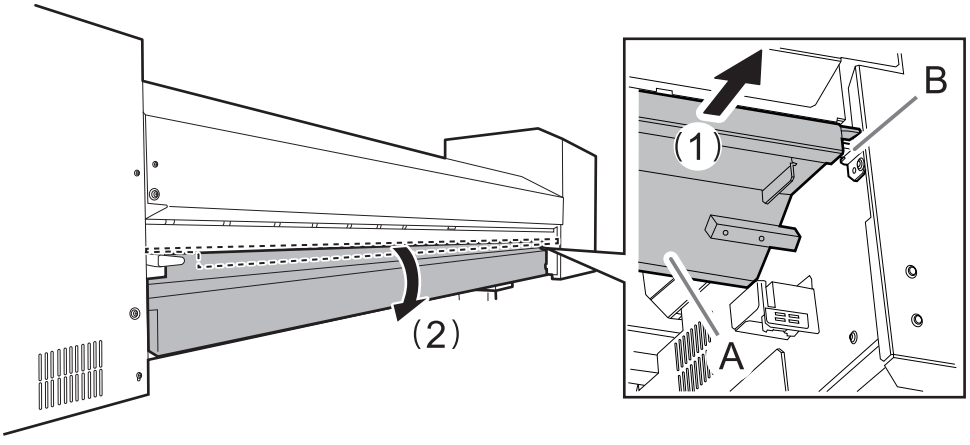
MEMO

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. **Close the rear UV shield.**

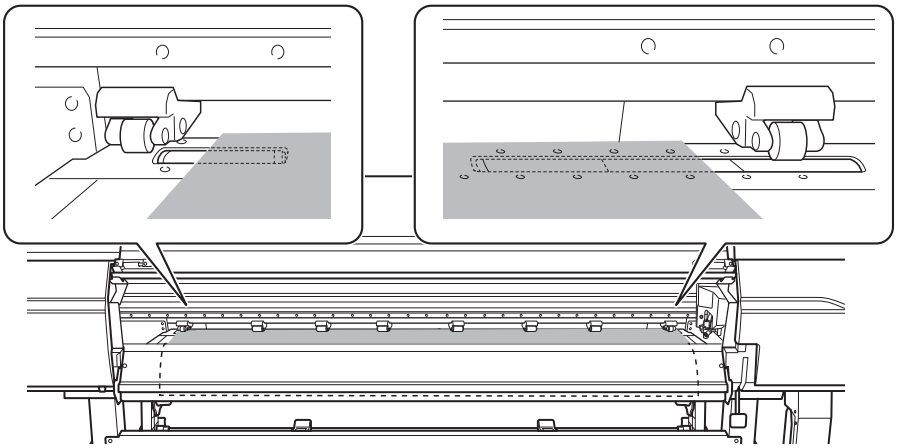
(1) **Pull the rear UV shield (A) to the back of the machine, and then remove this shield from the left and right stoppers (B).**

(2) **Close the rear UV shield.**



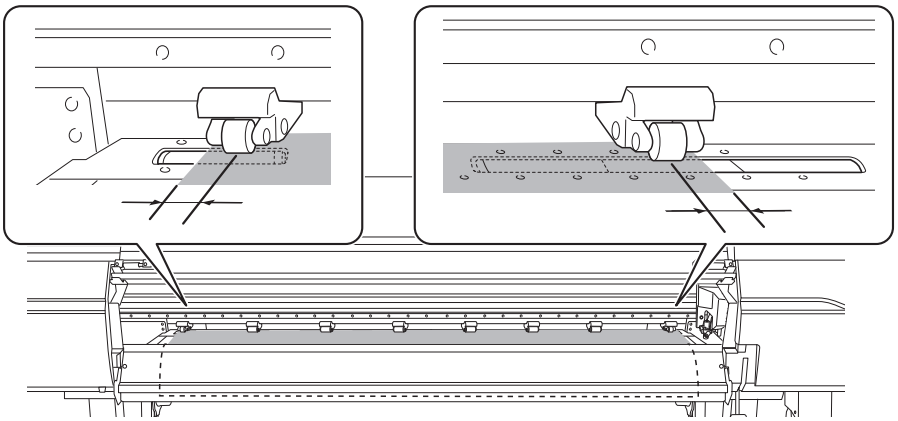
6. **(Move to the front of the printer.) Make sure both edges of the media are above the grit rollers.**

Be sure to place the right edge of the media on the right-end grit roller.



7. **Move the left and right pinch rollers, placing them on both edges of the media.**

Position them approximately 10 mm (0.39 in.) from each edge of the media.



IMPORTANT

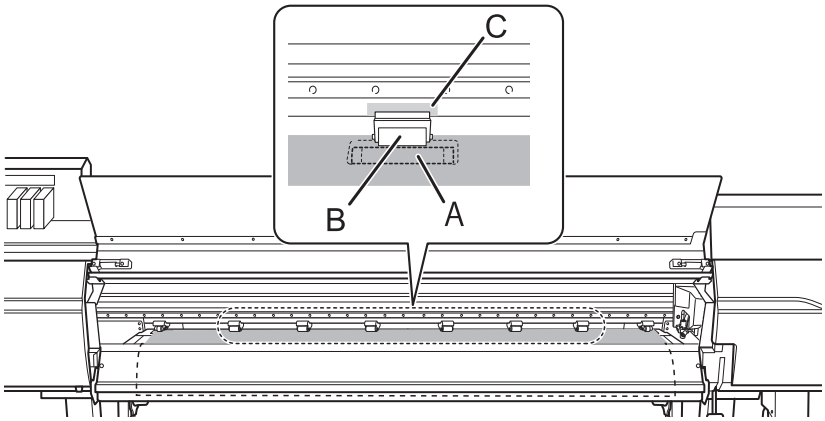
- Be sure to use the left and right pinch rollers. The force with which the media is pinched varies between the middle pinch rollers and the left and right pinch rollers. Using the middle pinch rollers to pinch the media edges will lead to unstable media feeding.
- If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from Step 2. 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.

MEMO

To smoothly move the pinch rollers, push down close to the rail.

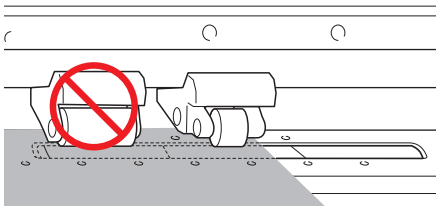
8. **Move the middle pinch rollers (B) over all the remaining grit rollers (A) covered by the media.**

There are grit patterns (C) wherever there are grit rollers.

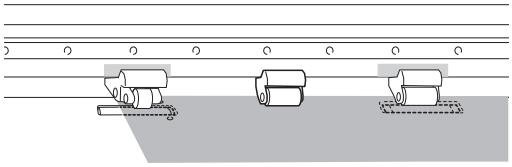


IMPORTANT

- Place the middle pinch rollers over all the grit patterns within the media width. If you have forgotten to place the middle pinch rollers, the media will be skewed during printing or will come loose, which will have an effect on the printing quality.
- The middle pinch roller will not lower onto the three grit rollers from the right end. Place the middle pinch roller on a grit roller other than these three.

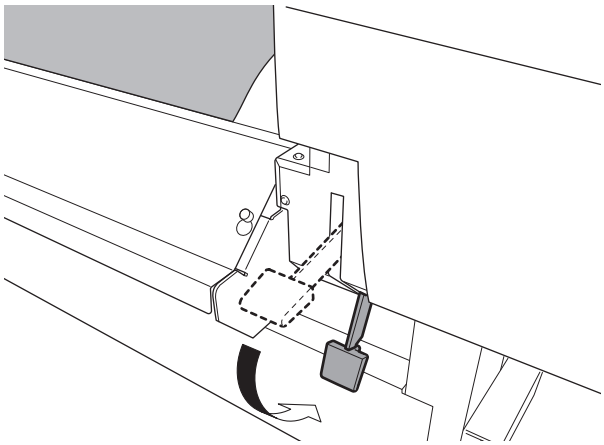


- There may be extra middle pinch rollers depending on the width of the media being used. Move the extra middle pinch rollers to positions where no grit patterns are present. Where no grit patterns are present, the middle pinch rollers will not come down.



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

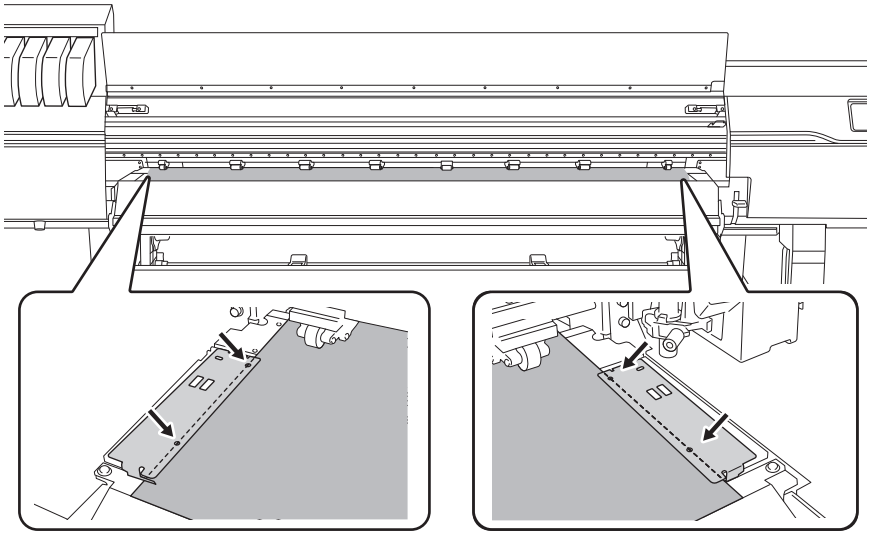
The media is held in place.



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 2. 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. **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 set up media.
If you load the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

11. **Close the front cover.**

2. B: Determining the Positions of Media (If [Media Edge Detection]: [Disable])

Use the following procedure to determine the positions of the media when using transparent media or media with high reflectance whose edges cannot be detected, and when [**Preferences**]>[**Media Edge Detection**] is set to [**Disable**].

Procedure

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

(1) **Tap** ☰.

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

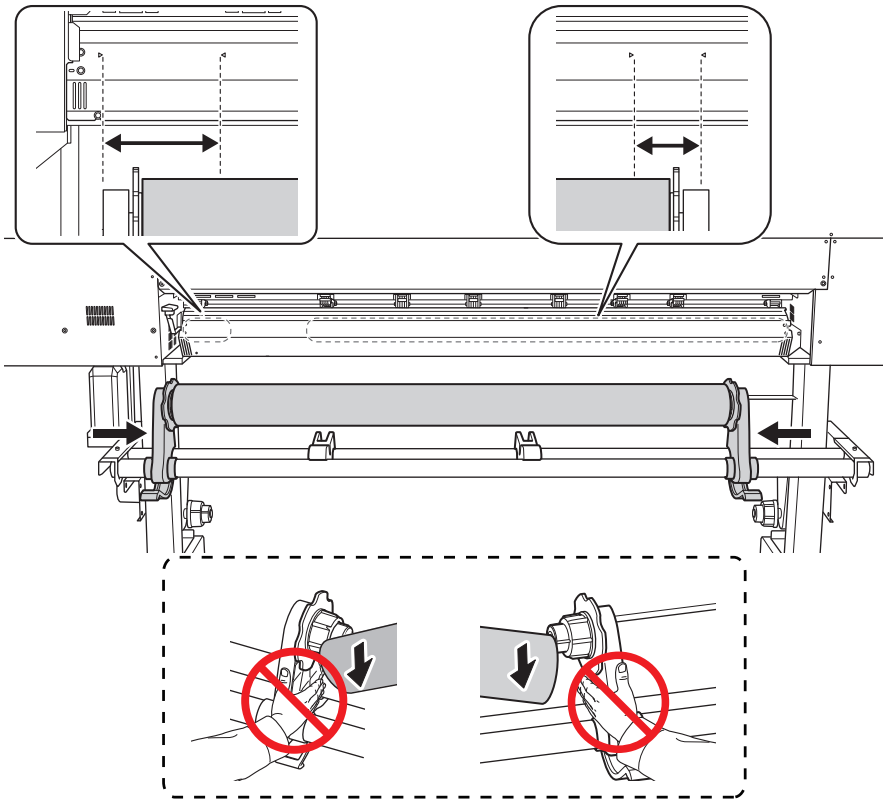
(3) **Select [Disable] and tap [Save].**

(4) **Press** ⌂ **to return to the home screen.**

2. **Determine the left and right positions of the media with the grit patterns used as the reference.**

Note the following points when determining the positions.

- Hold the media holders from the outside and move them.
- Ensure that the left edge of the media is positioned so that it is within the range of the grit pattern of the left edge.
- Ensure that the right edge of the media is positioned so that it is within the range of one of the grit patterns.



⚠ WARNING

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

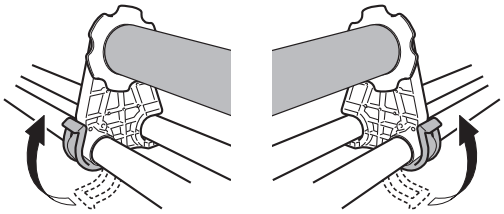
Doing so may cause the media to fall off the media holder and cause injury.

IMPORTANT

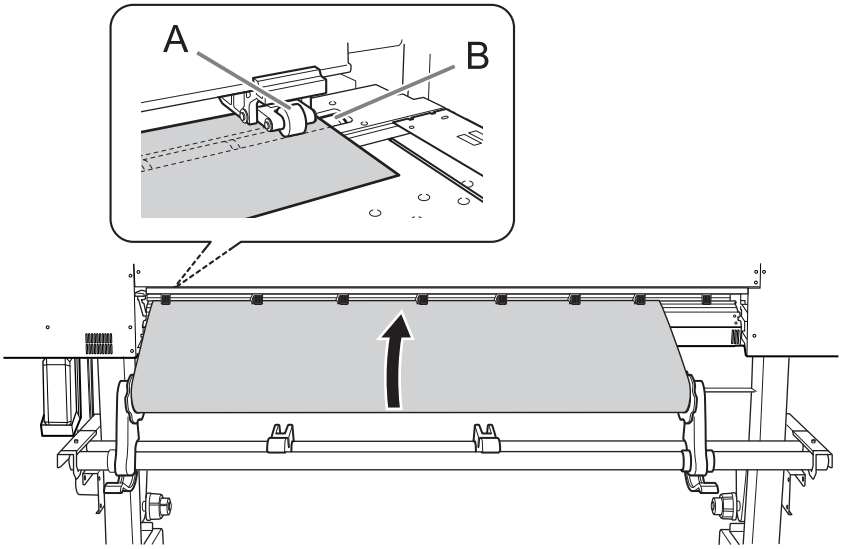
Firmly decide the left and right side positions of the media at this point.

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.**

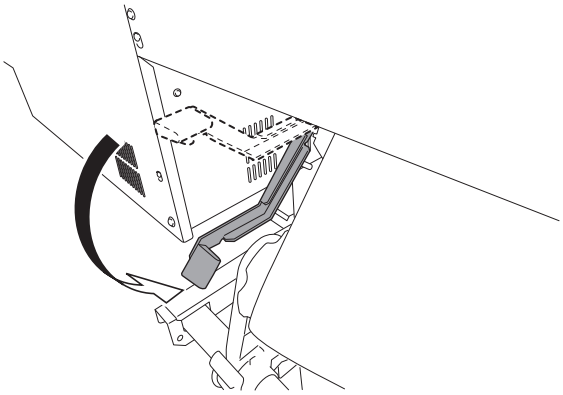


4. **Pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**



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

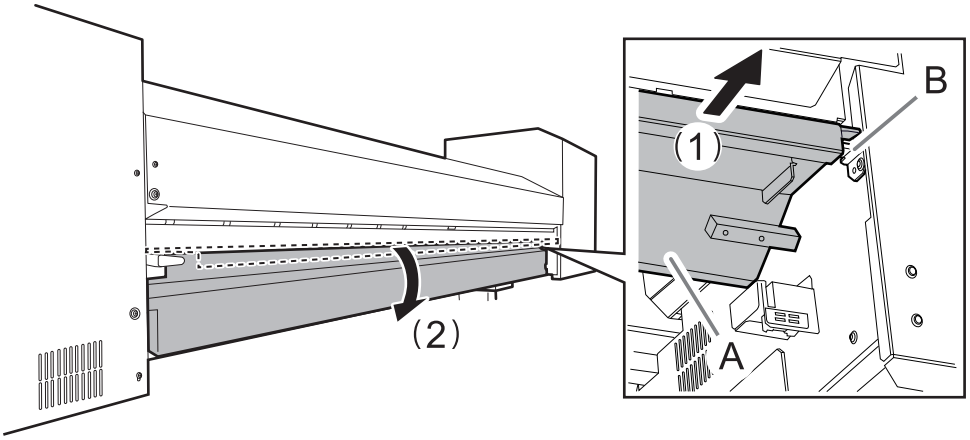
The media is held in place.



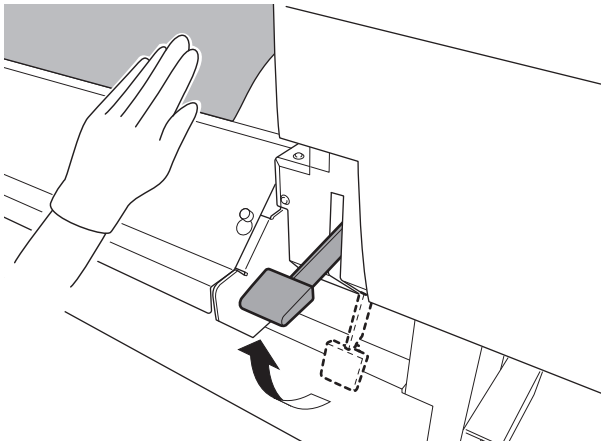
6. **Close the rear UV shield.**

(1) **Pull the rear UV shield (A) to the back of the machine, and then remove this shield from the left and right stoppers (B).**

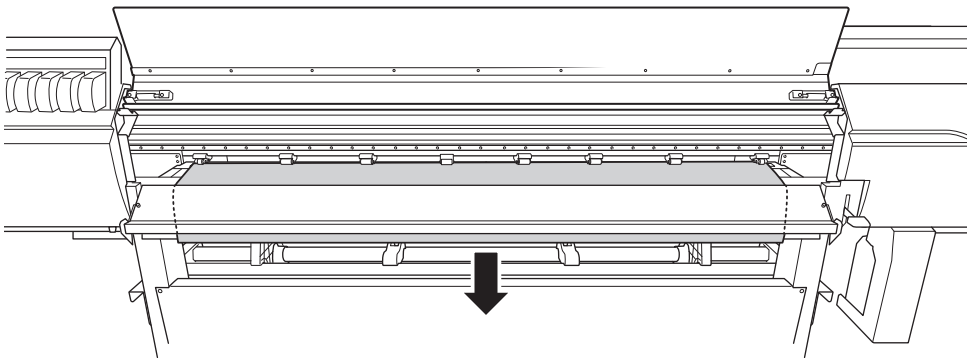
(2) **Close the rear UV shield.**



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

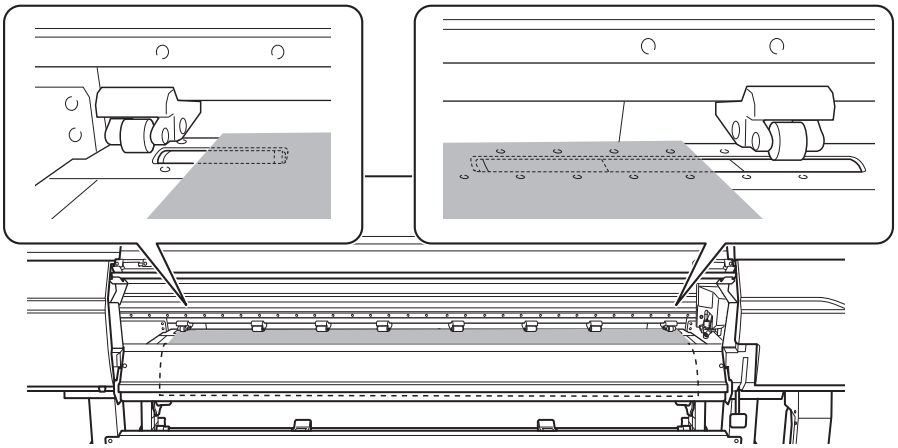


8. **Pull out the media over the apron.**



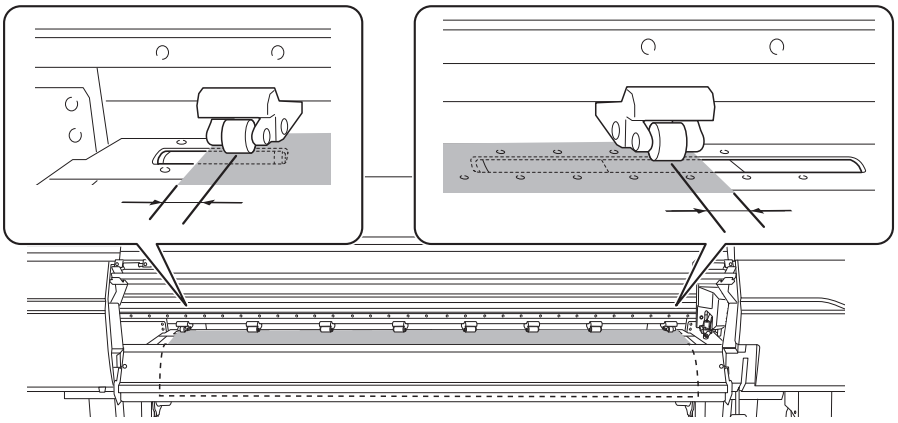
9. **Make sure both edges of the media are above the grit rollers.**

Be sure to place the right edge of the media on the right-end grit roller.



10. **Move the left and right pinch rollers, placing them on both edges of the media.**

Position them approximately 10 mm (0.39 in.) from each edge of the media.



IMPORTANT

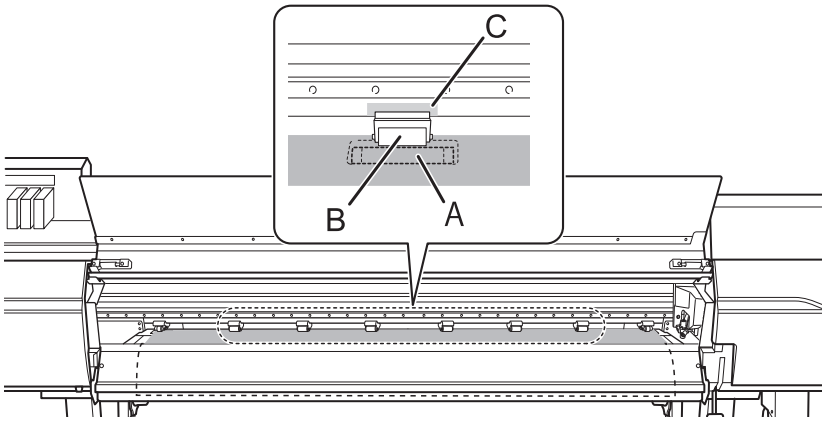
- Be sure to use the left and right pinch rollers. The force with which the media is pinched varies between the middle pinch rollers and the left and right pinch rollers. Using the middle pinch rollers to pinch the media edges will lead to unstable media feeding.
- If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from Step 2. 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.

MEMO

To smoothly move the pinch rollers, push down close to the rail.

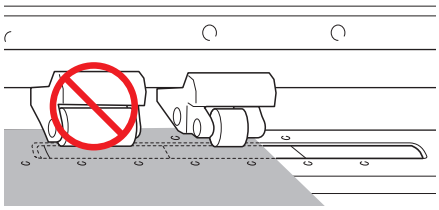
11. **Move the middle pinch rollers (B) over all the remaining grit rollers (A) covered by the media.**

There are grit patterns (C) wherever there are grit rollers.

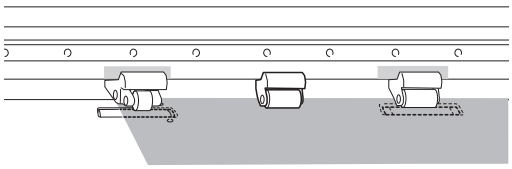


IMPORTANT

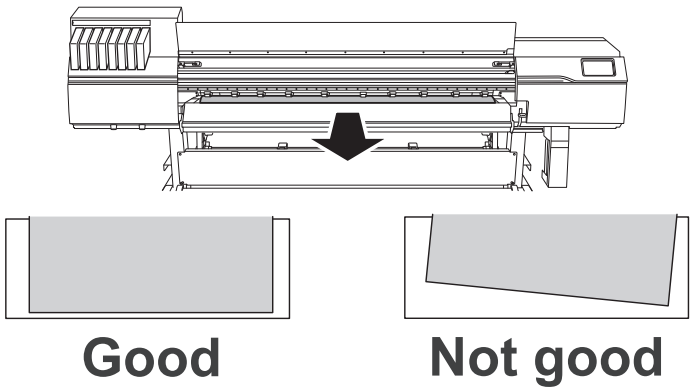
- Place the middle pinch rollers over all the grit patterns within the media width. If you have forgotten to place the middle pinch rollers, the media will be skewed during printing or will come loose, which will have an effect on the printing quality.
- The middle pinch roller will not lower onto the three grit rollers from the right end. Place the middle pinch roller on a grit roller other than these three.



- There may be extra middle pinch rollers depending on the width of the media being used. Move the extra middle pinch rollers to positions where no grit patterns are present. Where no grit patterns are present, the middle pinch rollers will not come down.

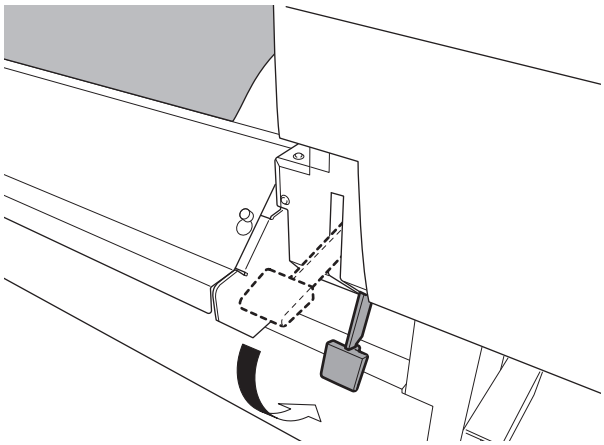


12. **Hold the media at the center and pull it out, being sure to keep it straight and all areas of the media to be taut.**

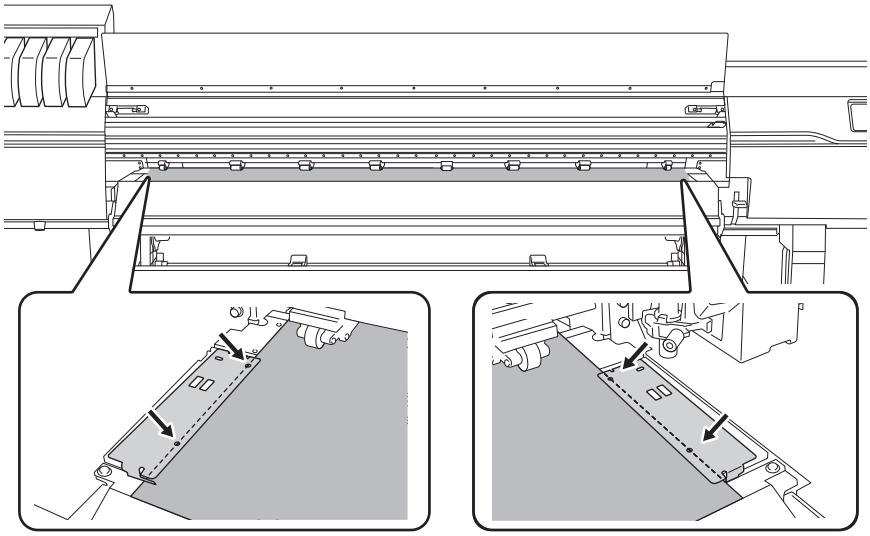


13. **Lower the loading lever (front).**

The media is held in place.



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



IMPORTANT

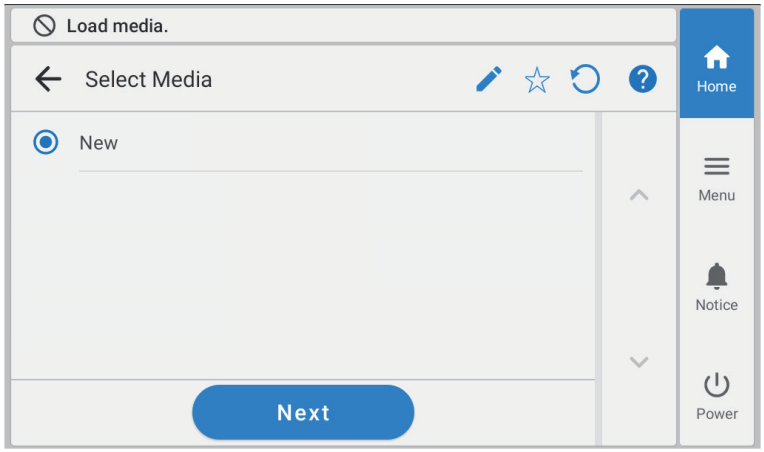
Be sure to use the media clamps when you set up media.
If you load the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

15. **Close the front cover.**

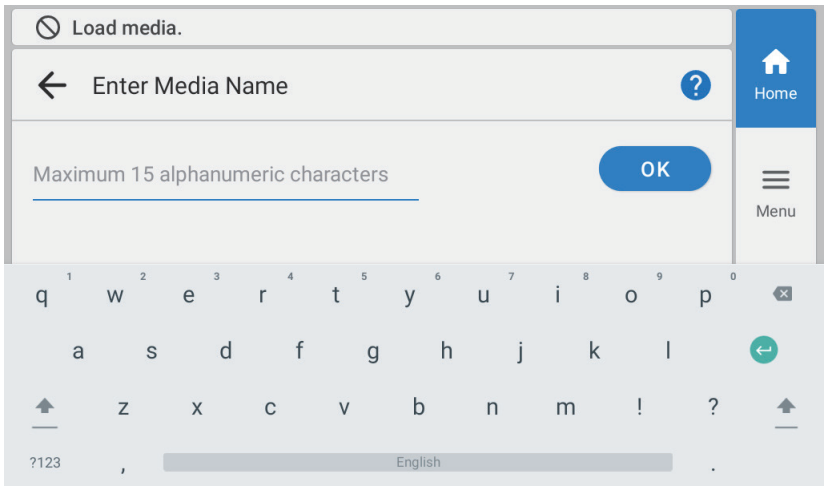
3. Registering the Media

Procedure

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



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



5. Check the name you have entered and tap [Next] if it is correct.
   To make corrections, tap the name you entered.
6. The [Setup Method] screen appears. Select whether to use the take-up unit.
7. Tap [Start Setup].
   The cutting carriage moves and detects the width of the media and the positions of the media clamps. This operation is called initialization.
   - [Use Take-up Unit]
     Proceed to 4. Loading the Media in the Take-up Unit(P. 52).
   - [Do Not Use Take-up Unit]

Proceed to 5. Configuring Settings to Match the Media(P. 56).

8. **If the [The media could not be detected automatically. Manually set the printing area.]screen appears, carry out the following procedure.**

It may not be possible to detect the media width with highly reflective media. Manually set the media width.

MEMO

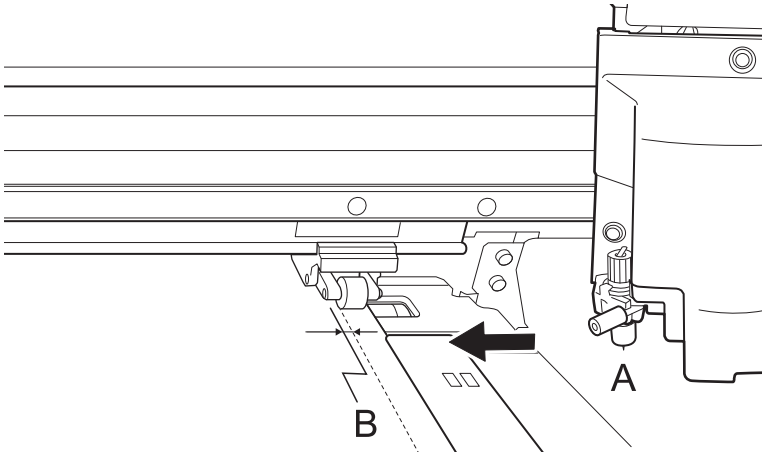
In the case of media where automatic media width detection was not possible after new media was registered, the screen automatically changes to the [**Printing Area Settings**] screen in Step (2).

(1) **Tap [OK].**

(2) **Tap [Change] on the [Printing Area] screen.**

The [**Set the right edge of the printing area within the area specified by the pinch rollers.**] screen appears.

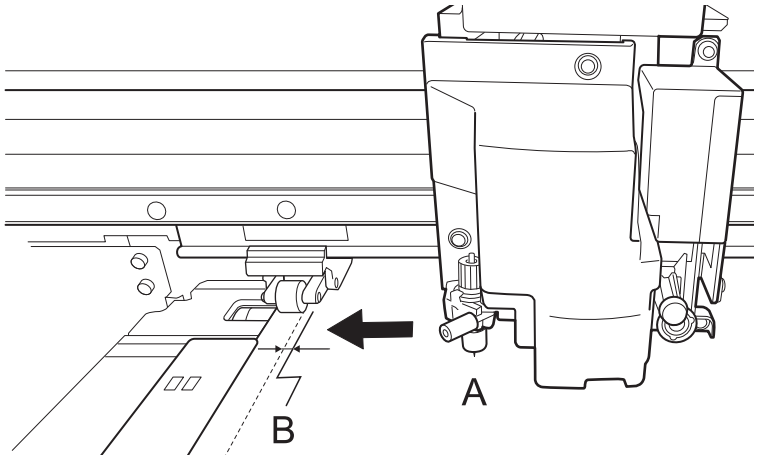
(3) **Hold down ‹ or › to move the center of the blade (A) approximately 2 mm (0.08 in.) to the inside (B) from the left edge of the right pinch roller.**



(4) **Tap [OK].**

The [**Set the left edge of the printing area within the area specified by the pinch rollers.**] screen appears.

(5) **Hold down ‹ or › to move the center of the blade (A) approximately 2 mm (0.08 in.) to the inside (B) from the right edge of the left pinch roller.**



(6) **Tap [OK].**

The set left and right positions are applied to the [**Printing Area (Width)**].

(7) **Tap [OK].**

4. Loading the Media in the Take-up Unit

If you will not use the take-up unit, proceed to 5. Configuring Settings to Match the Media(P. 56).

Procedure

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

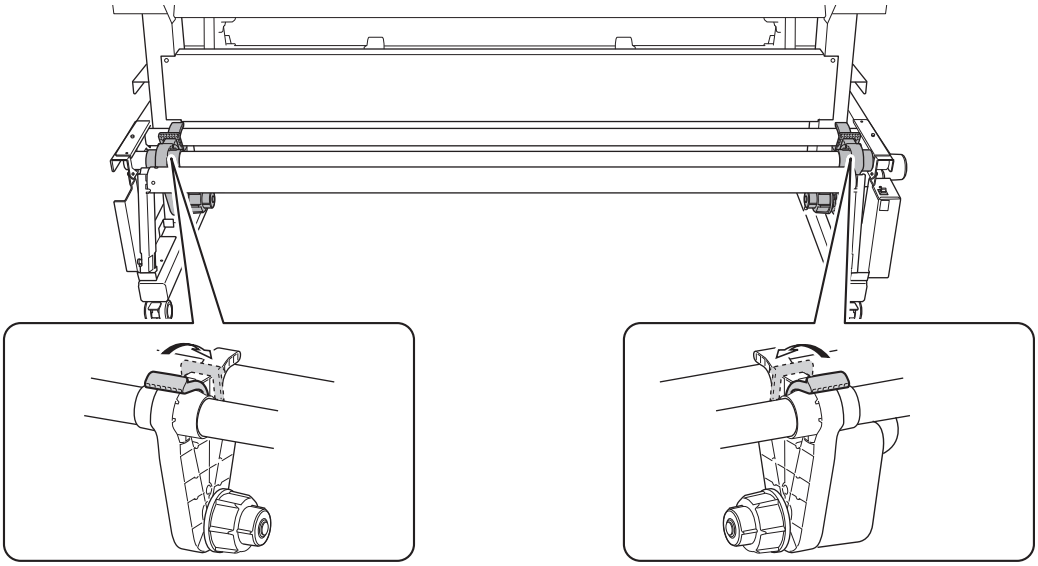
Prepare a paper tube wider than the media that has been set up.

IMPORTANT

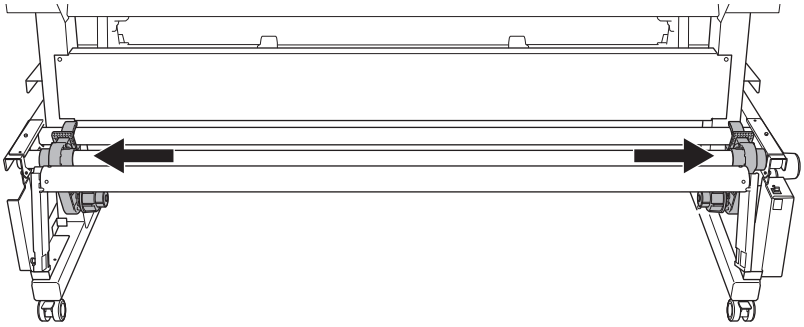
Paper tubes are consumable items.

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.**



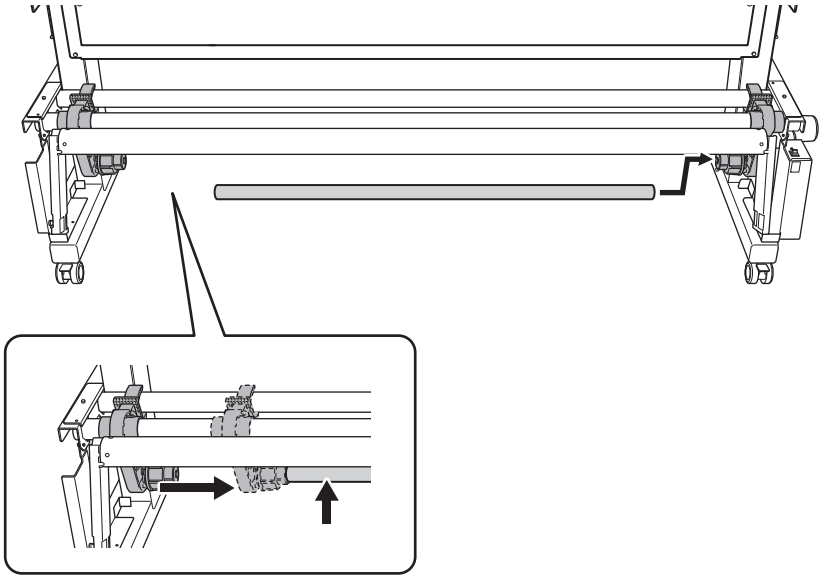
(2) **Draw the media holders to both left and right ends respectively.**



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

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

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

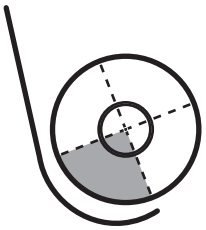
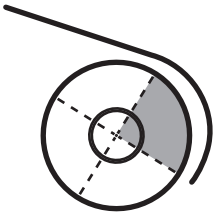


2. **Tap ⌄ on the operation panel to feed out the media until the tip of the media reaches the paper tube.**

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

MEMO

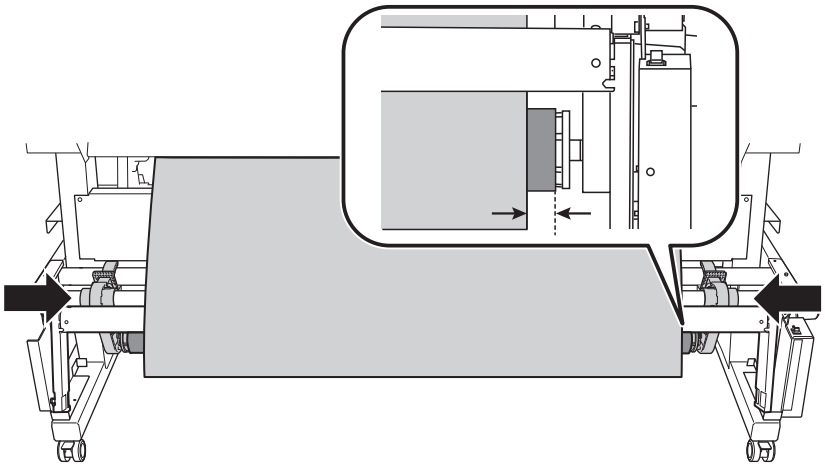
Feed out the media until it can wrap around at least 1/4 of the paper tube (or at least halfway around when rewinding during cutting).

When using the FORWARD setting	When using the BACKWARD setting
	

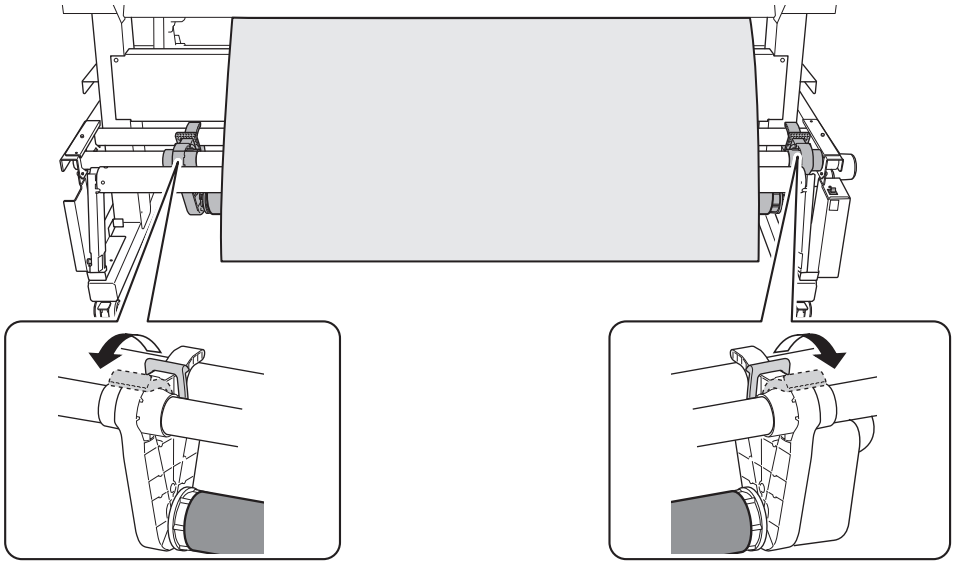
3. **Follow the procedure below to adjust the positions of the media holders.**

(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.**



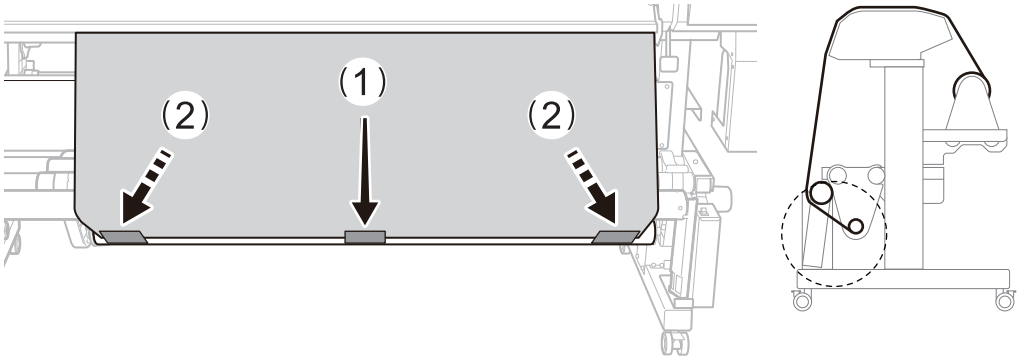
4. **Follow the procedure below to secure the media on the paper tube.**

Secure the media in the take-up direction set in step 3 of 1. Installing the Media on the Media Holders(P. 33).

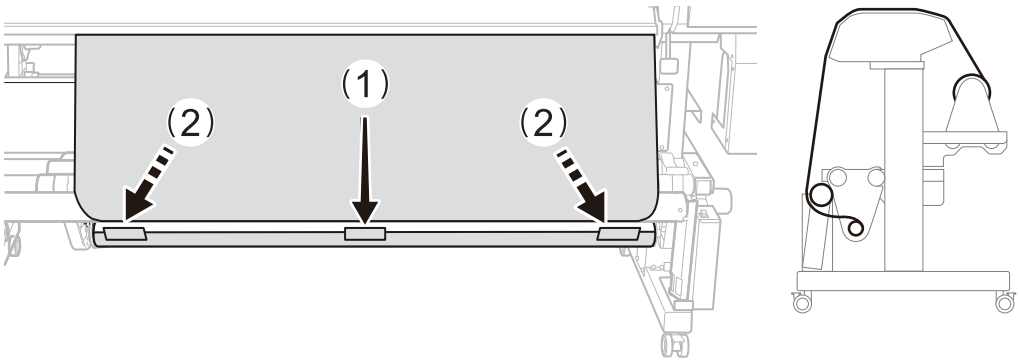
(1) **While pulling the media so that it does not sag, secure the center of the media on the paper tube with adhesive tape.**

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

- **When using the FORWARD setting**



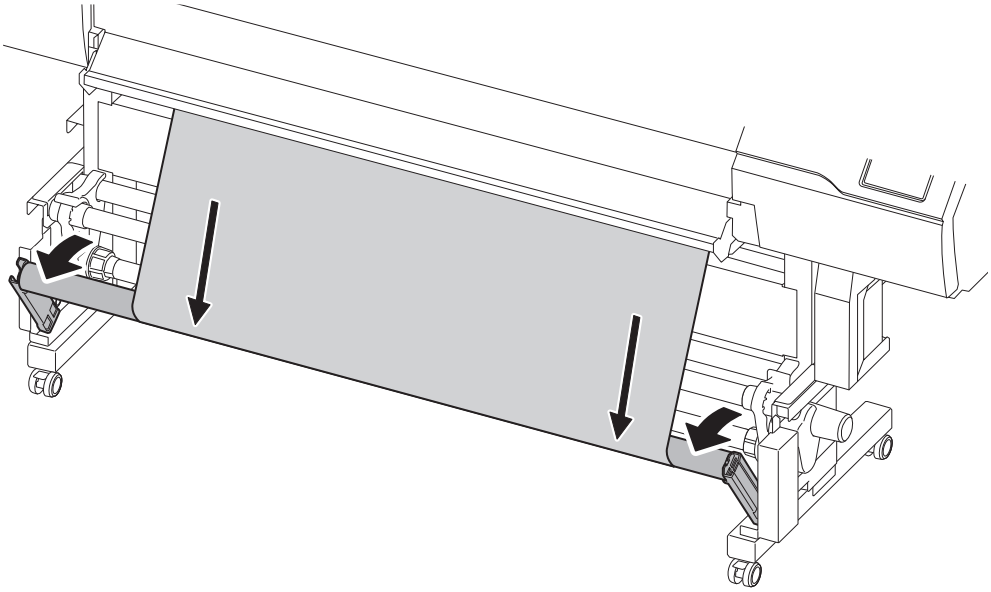
- When using the BACKWARD setting



5. Tap [OK].

A small amount of the media is fed out.

6. Lower the dancer roller toward the front.



7. Tap [OK].

5. Configuring Settings to Match the Media

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

In this step, perform a printing test for adjustment. Load media which can secure the printing area for the printing test. The printing test width is the following.

- [**Simple Correction (Auto)**]: Approx. 290 mm (11.42 in.)
- [**Detailed Correction (Manual)**]: Approx. 375 mm (14.76 in.)

Procedure

1. **On the [Select Media Output Type] screen, select the output type and tap [Next].**

- [**Print Only/Print & Cut**]

  Proceed to step 2.
- [**Cut Only**]

  Switch to the [**Multi Sensor Adjustment**] screen. Tap [**Execute**] to perform automatic adjustment, then tap [**OK**]. This completes the settings for [**Cut Only**].

2. **On the [Heater Temperature] screen, adjust the temperature of the front heater.**

- If this is not necessary, tap [**Next**].
- Follow the procedure below to make adjustments.
  a. Tap − or + to set the [**Front Heater**] temperature.
  b. Tap [**Next**].

  For details on this work, refer to Setting the Front Heater Temperature(P. 195).

3. **Use the [Print Head Height] screen to adjust the print head height.**

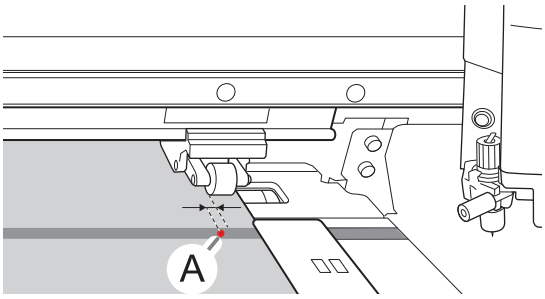
- If this is not necessary, tap [**Next**].
- Follow the procedure below to make adjustments.
  a. Tap [**Change**]
  b. Open the front cover.
  c. Move the height-adjustment lever to adjust the head height.
  d. Close the front cover.
  e. Tap [**OK**].
  f. Tap [**Next**].

  For details on this work, refer to Changing the Print Head Height(P. 182).

4. **Set the [Printing Test] and [Output Start Location] on the [Nozzle Drop-out Test] screen.**

- If this is not necessary, tap [**Next**].
- Follow the procedure below to set [**Output Start Location**].

  If this setting is not configured, the base point (A) will be set to the following location.
  - Feed direction: Blade protector position
  - Scan direction: About 2 mm (0.08 in.) from the left edge of the right pinch roller



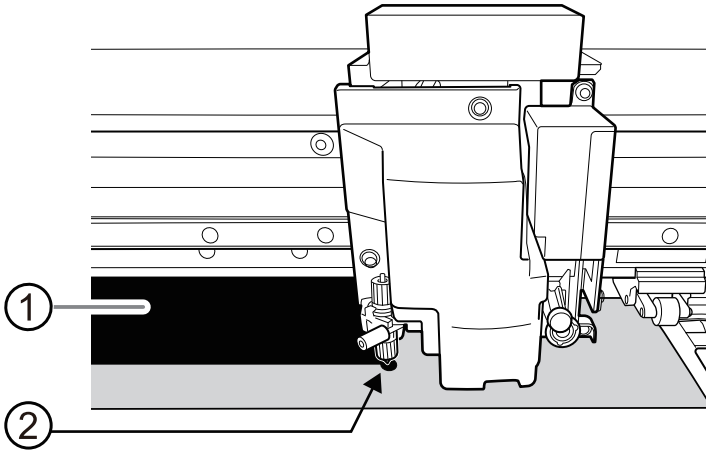
a. Tap [**Output Start Location**]>[**Change**].

b. Tap ‹.

The cutting carriage moves to the current base point.

c. Tap ^ ˇ ‹ › and move the cutter center to the position where you want to start cutting.

Tap ^ or ˇ to move the media in the feed direction (forward-back). Tap ‹ or › to move the cutting carriage in the scan direction (left-right).



- ①: Printing area
- ②: Base point (right edge of the printing area)

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

The base point position is updated.

- Follow the procedure below to perform [**Printing Test**].

Tap [**Execute**] next to [**Printing Test**]. For details on what to do after the printing test, refer to Performing Normal Cleaning(P. 288).

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

Here, the media feed correction for reducing horizontal bands and the correction of the landing position of the ink will be adjusted.

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.

Check the printing area required for the printing test before executing the test.

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

For more information, refer to Automatically Making Required Adjustments(P. 177).

- **Follow the procedure below to make manual adjustments.**
  a. Tap [**Detailed Correction (Manual)**]>[**Next**].
  b. Tap [**Execute**] on the [**Multi Sensor Adjustment**] screen.

     Adjust the reading sensor to the optimal condition. If the adjustment failed, respond to the failure according to the information in Correcting the Reading Sensor(P. 219).
  c. Tap [**Next**].
  d. Tap [**Execute**] for [**Printing Test**] on the [**Detailed Feed Correction (Manual)**] screen. Check the printing area required for the printing test before executing the test.

     Set the correction values from the printing test result. For more information, refer to Manual Adjustment: Reducing Horizontal Bands (Feed Correction)(P. 178).
  e. Tap [**Save and Proceed**].
  f. Tap [**Execute**] for [**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. 180).
  g. Tap [**Save and Exit**].

This completes the setup.

Setup of Sheet Media

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

1. A: Determining the Positions of the Media

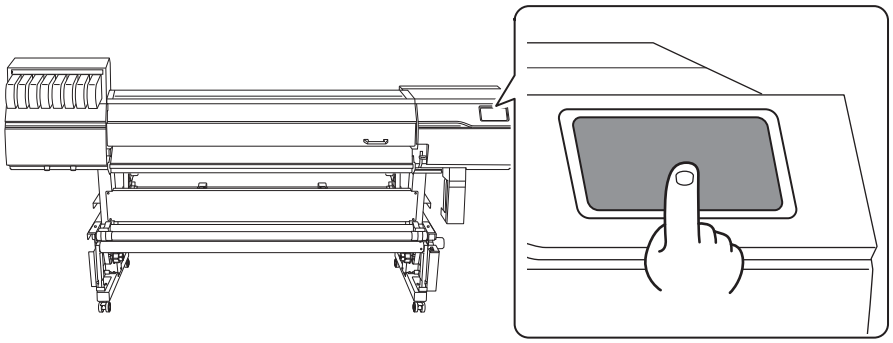
This section describes how to use the suction fan to prevent media skewing.

Because the suction fan does not operate, the following procedure cannot be used to load media when using transparent media or media with high reflectance whose edges cannot be detected, or when [**Disable**] is set for [**Preferences**]>[**Media Edge Detection**]. In these cases, refer to 1. B: Determining the Positions of Media (If [Media Edge Detection]: [Disable])(P. 65).

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

Procedure

1. **Tap the operation panel.**



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

   The machine sub power is switched on.

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

   (1) **Tap** ☰.

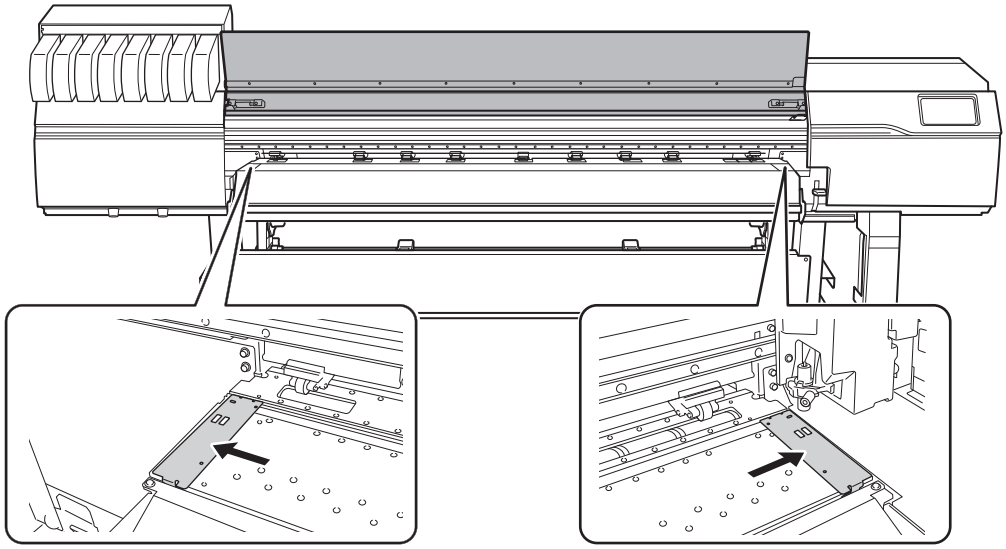
   (2) **Tap [Preferences]>[Skewing Correction Support at Setup].**

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

   (4) **Press** ⌂ **to return to the home screen.**

4. **Open the front cover.**

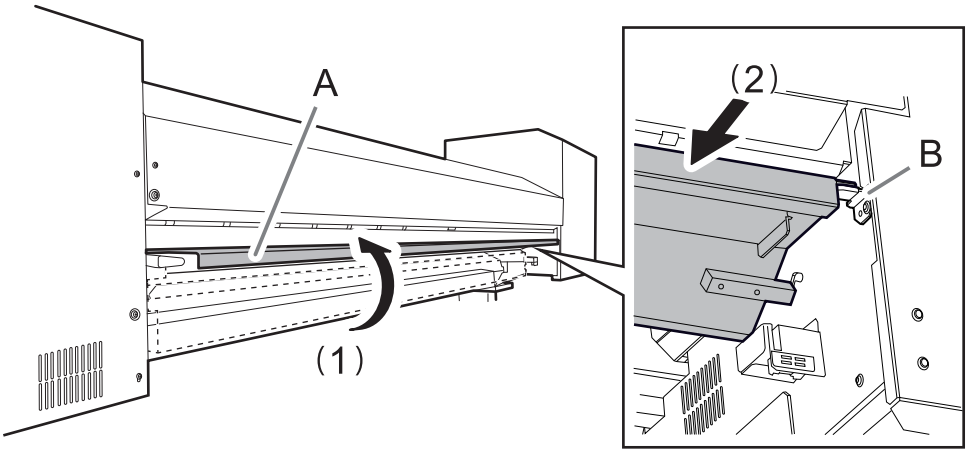
5. **Move the media clamps to the outside of the grit rollers on the left and right edges respectively.**



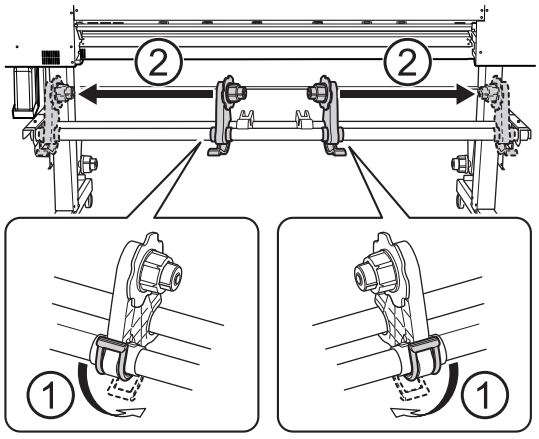
6. **Move to the rear of the printer and open the rear UV shield.**

(1) **Open the rear UV shield (A).**

(2) **Push the rear UV shield to the front of the machine, and then place this shield on the left and right stoppers (B).**



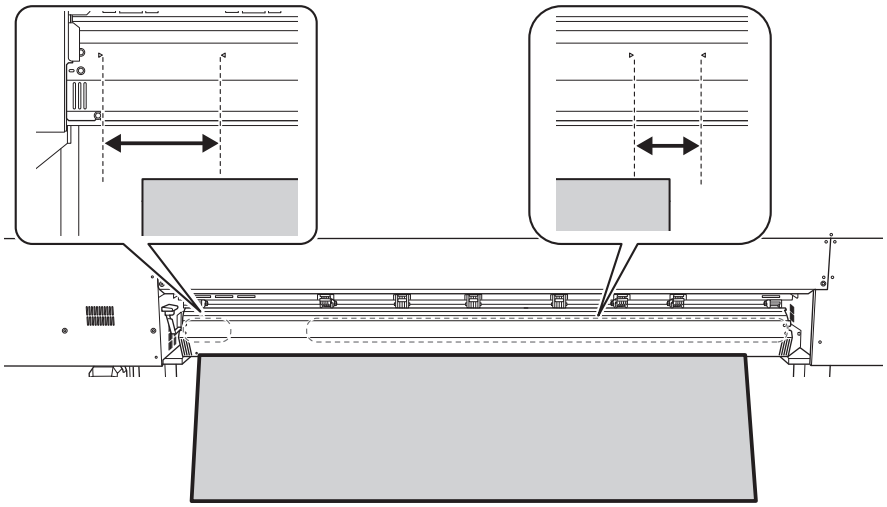
7. **Move the media holders to the outside.**



8. **Determine the left and right positions of the media with the grit patterns used as the reference.**

Note the following points when determining the positions.

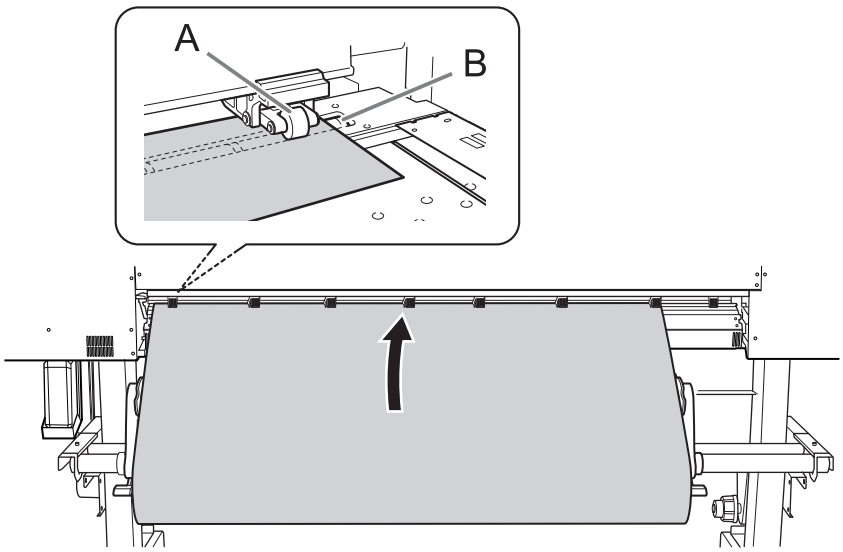
- Ensure that the left edge of the media is positioned so that it is within the range of the grit pattern of the left edge.
- Ensure that the right edge of the media is positioned so that it is within the range of one of the grit patterns.



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

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

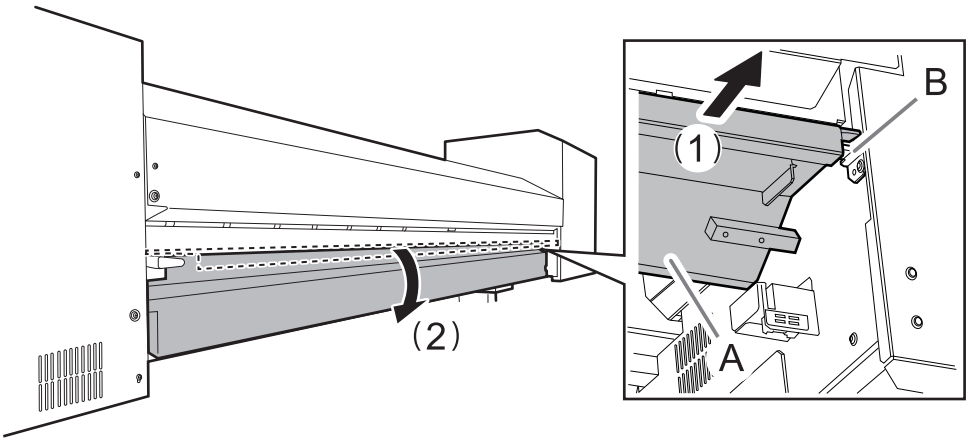
When loading the media from the front of the printer, feed the leading edge of the media (the side where printing will start) over the platen, and then pull the media to the front to activate the suction fan.



10. **Close the rear UV shield.**

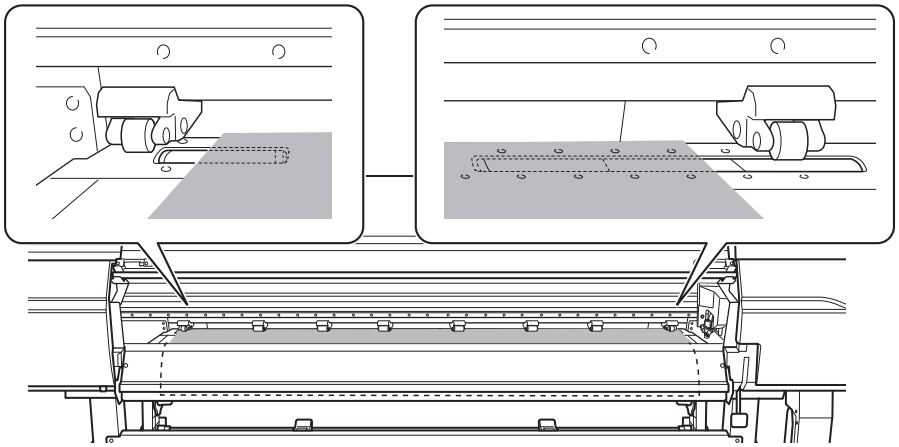
(1) **Pull the rear UV shield (A) to the back of the machine, and then remove this shield from the left and right stoppers (B).**

(2) **Close the rear UV shield.**



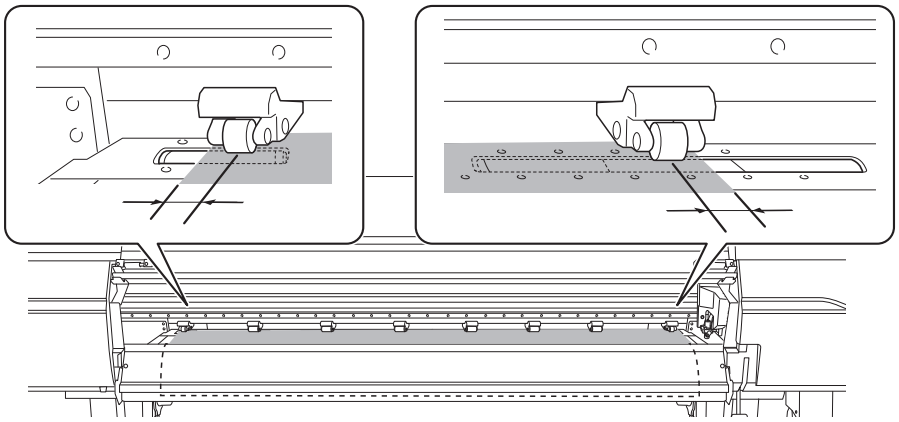
11. **(Move to the front of the printer.) Make sure both edges of the media are above the grit rollers.**

Be sure to place the right edge of the media on the right-end grit roller.



12. **Move the left and right pinch rollers, placing them on both edges of the media.**

Position them approximately 10 mm (0.39 in.) from each edge of the media.



IMPORTANT

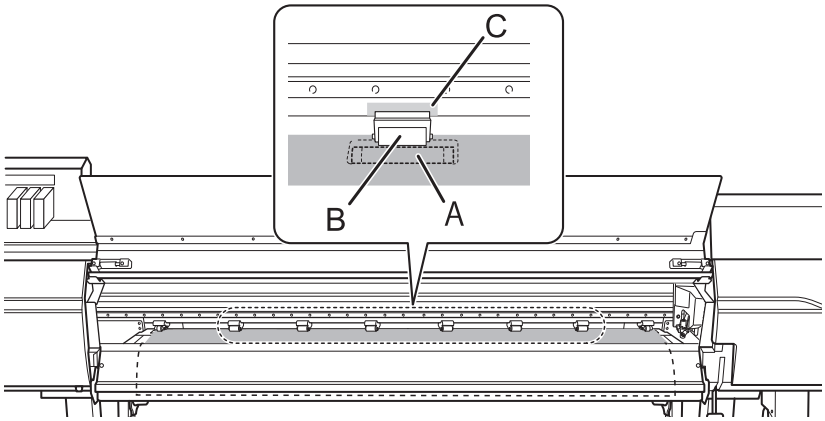
- Be sure to use the left and right pinch rollers. The force with which the media is pinched varies between the middle pinch rollers and the left and right pinch rollers. Using the middle pinch rollers to pinch the media edges will lead to unstable media feeding.
- If you want to readjust the media position before securing it in place, redo the procedure from step 7.

MEMO

To smoothly move the pinch rollers, push down close to the rail.

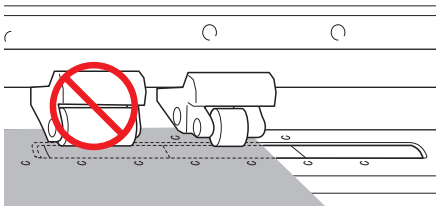
13. **Move the middle pinch rollers (B) over all the remaining grit rollers (A) covered by the media.**

There are grit patterns (C) wherever there are grit rollers.

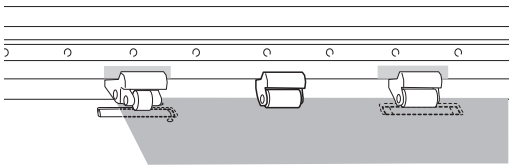


IMPORTANT

- Place the middle pinch rollers over all the grit patterns within the media width. If you have forgotten to place the middle pinch rollers, the media will be skewed during printing or will come loose, which will have an effect on the printing quality.
- The middle pinch roller will not lower onto the three grit rollers from the right end. Place the middle pinch roller on a grit roller other than these three.

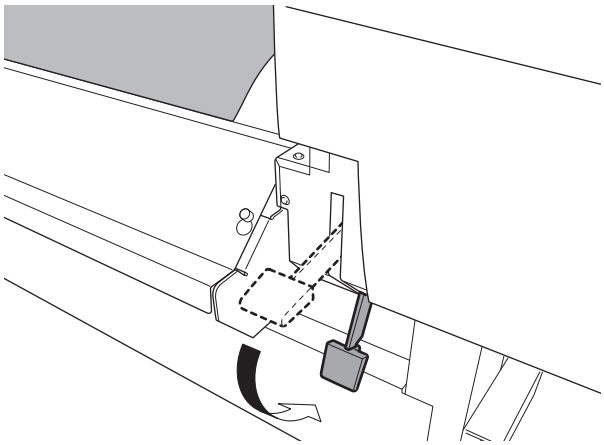


- There may be extra middle pinch rollers depending on the width of the media being used. Move the extra middle pinch rollers to positions where no grit patterns are present. Where no grit patterns are present, the middle pinch rollers will not come down.



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

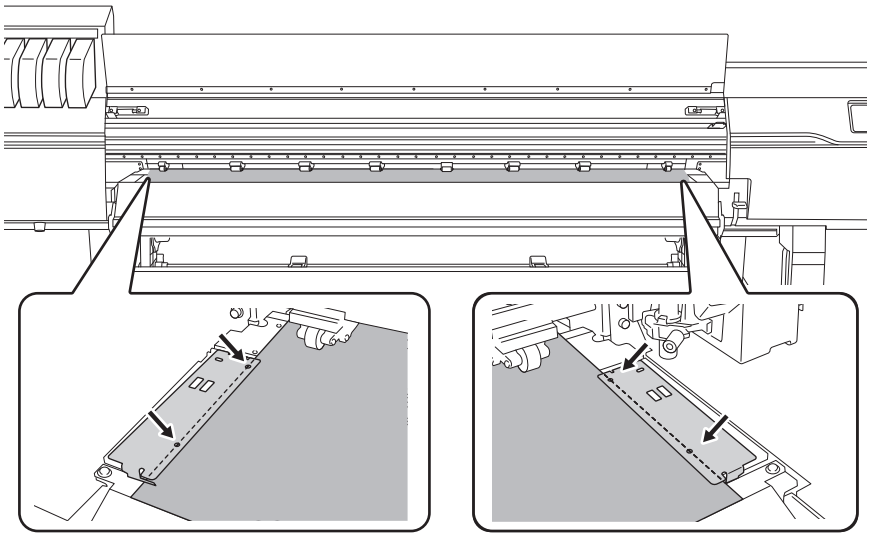
The media is held in place.



IMPORTANT

If you want to readjust the media position before securing it in place, redo the procedure from step 7.

15. **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 set up media.

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

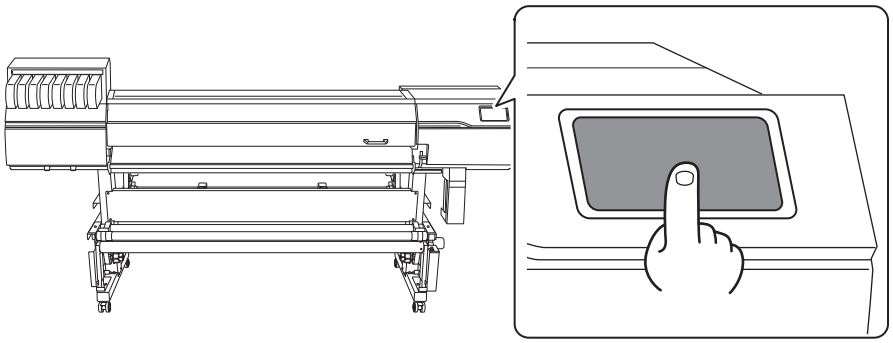
16. **Close the front cover.**

1. B: Determining the Positions of Media (If [Media Edge Detection]: [Disable])

Use the following procedure to determine the positions of the media when using transparent media or media with high reflectance whose edges cannot be detected, and when [**Preferences**]>[**Media Edge Detection**] is set to [**Disable**].

Procedure

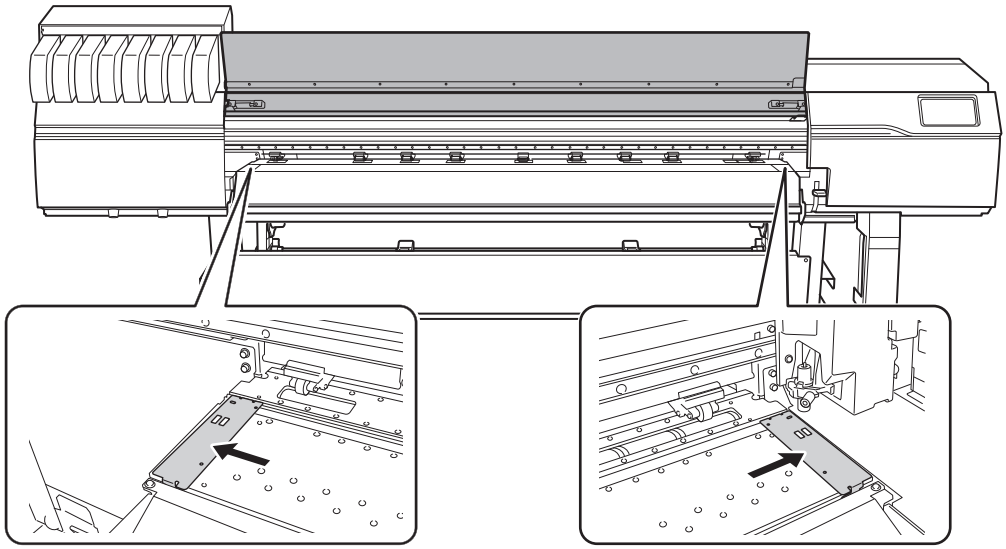
1. **Tap the operation panel.**



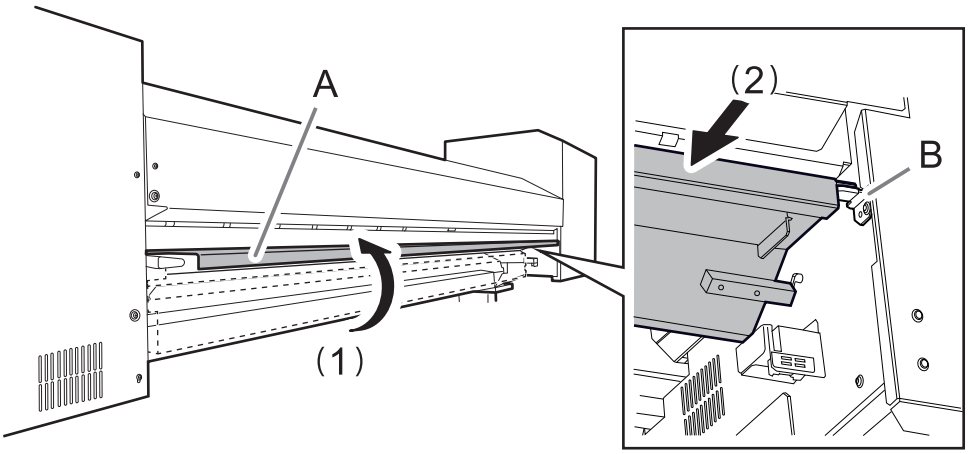
2. **When instructions appear on the screen, tap the operation panel again.**
   The machine sub power is switched on.

3. **Open the front cover.**

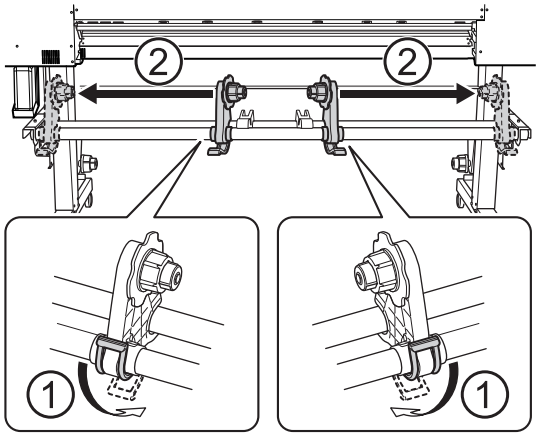
4. **Move the media clamps to the outside of the grit rollers on the left and right edges respectively.**



5. **Move to the rear of the printer and open the rear UV shield.**
   (1) **Open the rear UV shield (A).**
   (2) **Push the rear UV shield to the front of the machine, and then place this shield on the left and right stoppers (B).**



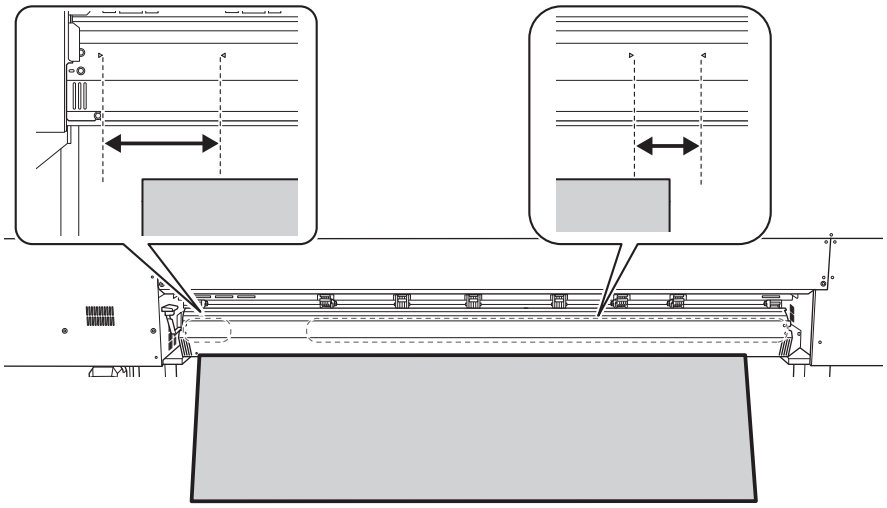
6. **Move the media holders to the outside.**



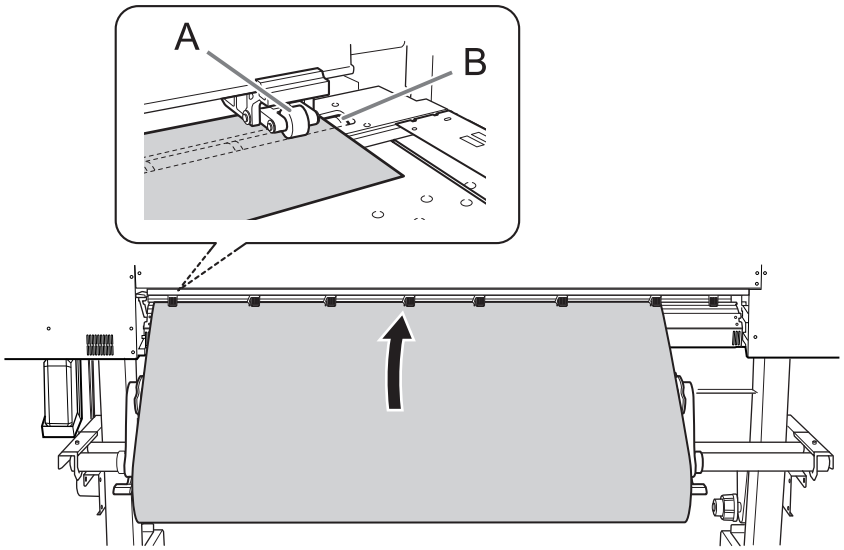
7. **Determine the left and right positions of the media with the grit patterns used as the reference.**

Note the following points when determining the positions.

- Ensure that the left edge of the media is positioned so that it is within the range of the grit pattern of the left edge.
- Ensure that the right edge of the media is positioned so that it is within the range of one of the grit patterns.

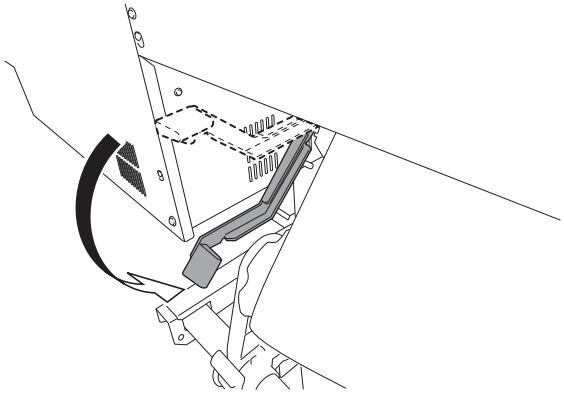


8. **Pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**



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

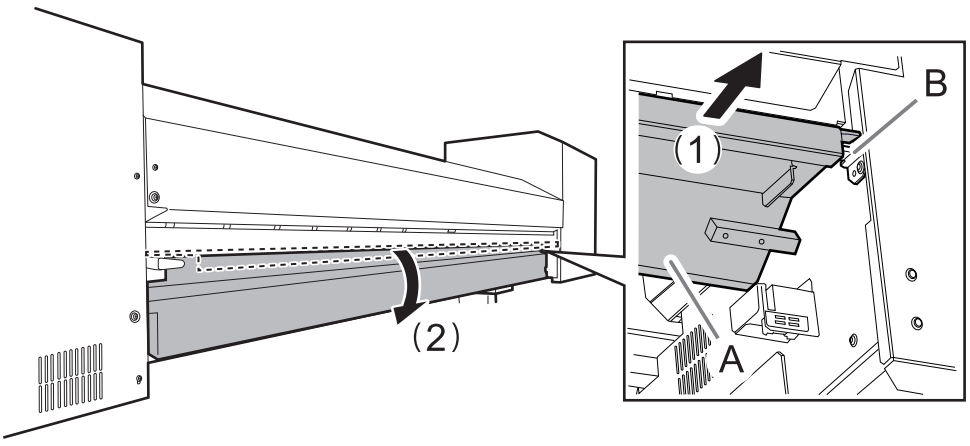
The media is held in place.



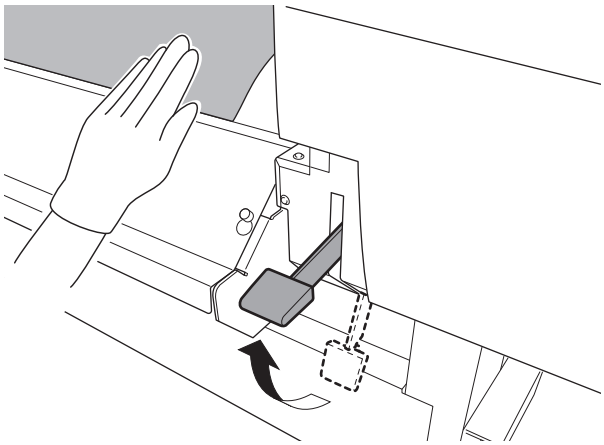
10. **Close the rear UV shield.**

(1) **Pull the rear UV shield (A) to the back of the machine, and then remove this shield from the left and right stoppers (B).**

(2) **Close the rear UV shield.**

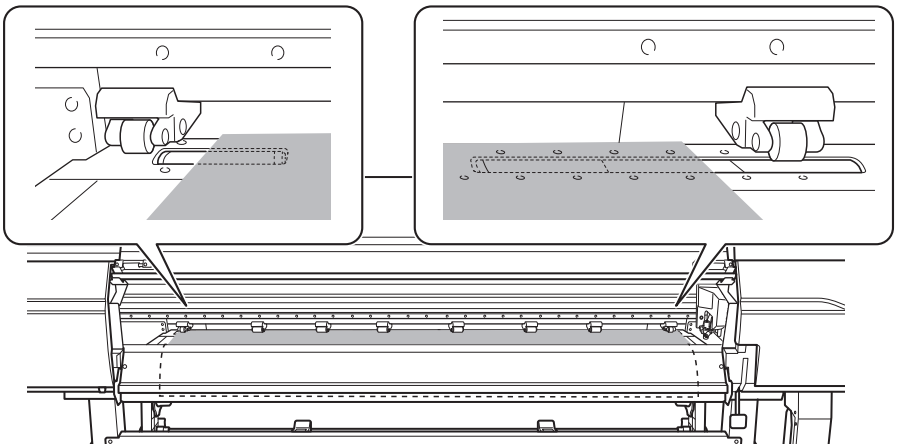


11. **(Move to the front of the printer.) Gently hold down the media and raise the loading lever (front).**



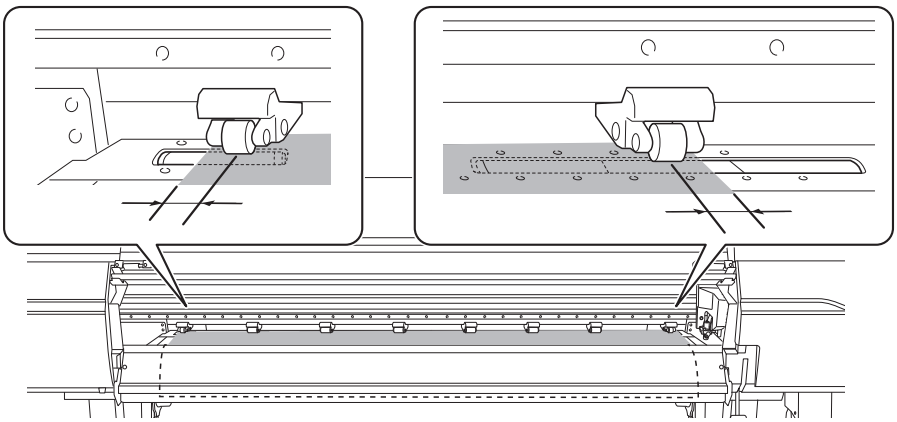
12. **Make sure both edges of the media are above the grit rollers.**

Be sure to place the right edge of the media on the right-end grit roller.



13. **Move the left and right pinch rollers, placing them on both edges of the media.**

Position them approximately 10 mm (0.39 in.) from each edge of the media.



IMPORTANT

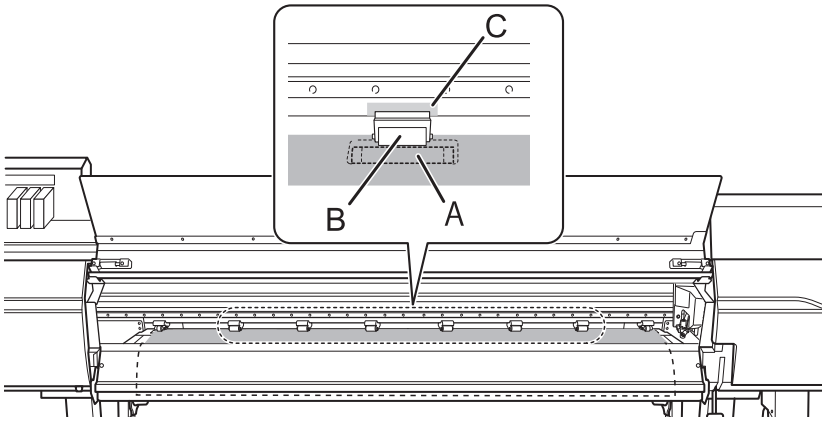
Be sure to use the left and right pinch rollers. The force with which the media is pinched varies between the middle pinch rollers and the left and right pinch rollers. Using the middle pinch rollers to pinch the media edges will lead to unstable media feeding.

MEMO

To smoothly move the pinch rollers, push down close to the rail.

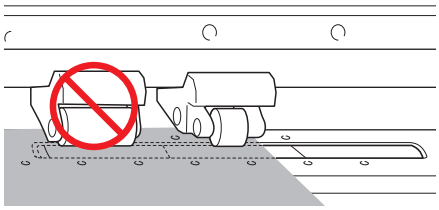
14. **Move the middle pinch rollers (B) over all the remaining grit rollers (A) covered by the media.**

There are grit patterns (C) wherever there are grit rollers.

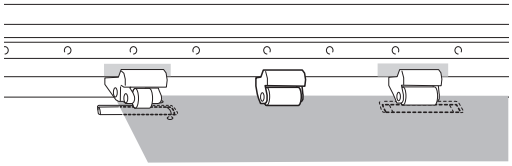


IMPORTANT

- Place the middle pinch rollers over all the grit patterns within the media width. If you have forgotten to place the middle pinch rollers, the media will be skewed during printing or will come loose, which will have an effect on the printing quality.
- The middle pinch roller will not lower onto the three grit rollers from the right end. Place the middle pinch roller on a grit roller other than these three.

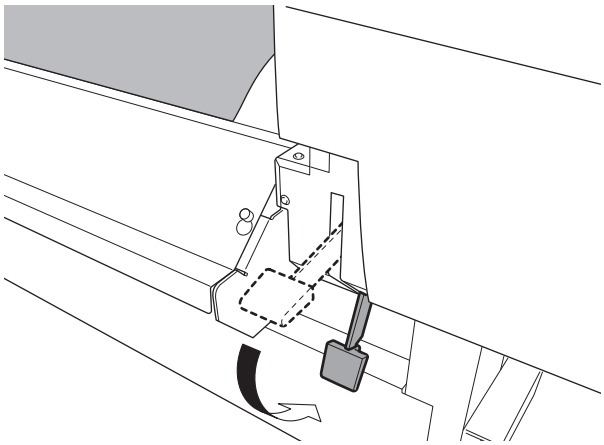


- There may be extra middle pinch rollers depending on the width of the media being used. Move the extra middle pinch rollers to positions where no grit patterns are present. Where no grit patterns are present, the middle pinch rollers will not come down.



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

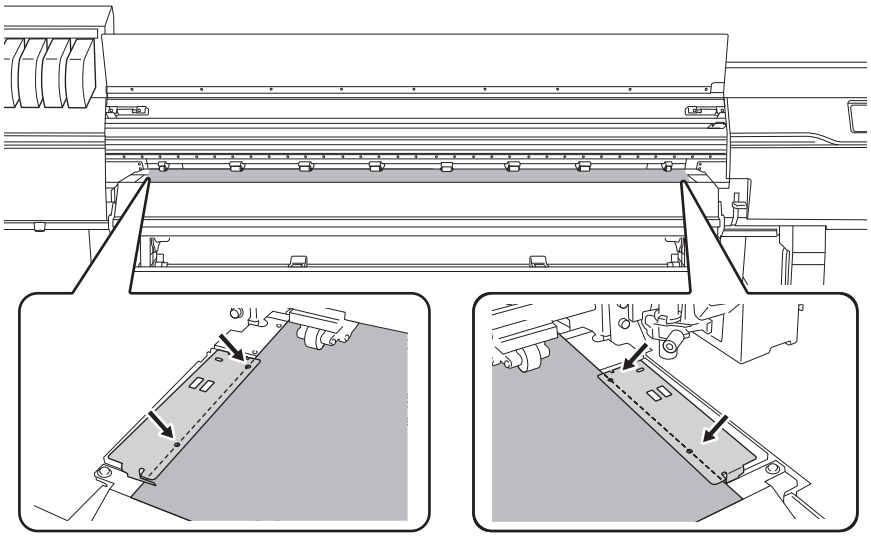
The media is held in place.



IMPORTANT

If you want to readjust the media position before securing it in place, redo the procedure from step 11.

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



IMPORTANT

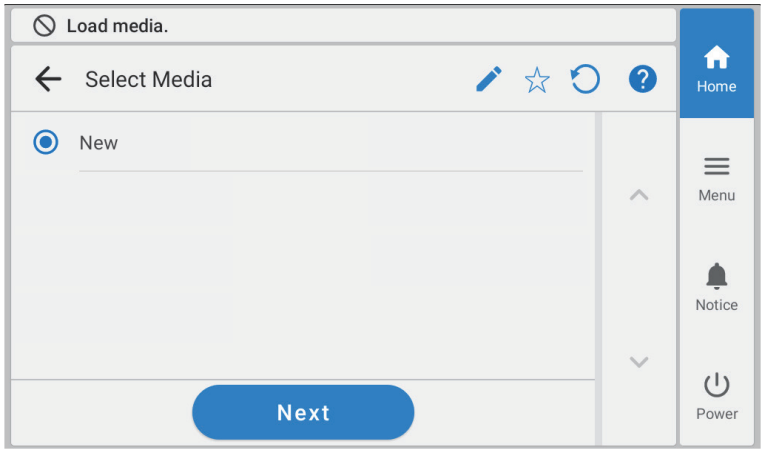
Be sure to use the media clamps when you set up media.
If you load the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

17. **Close the front cover.**

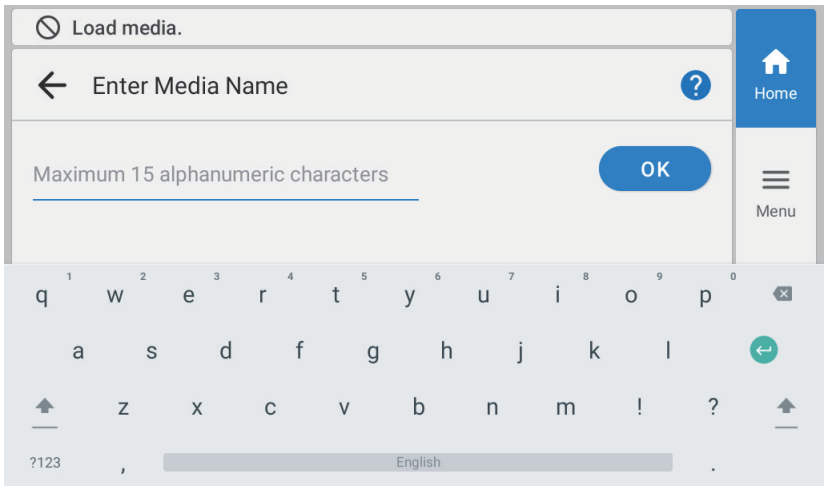
2. Registering the Media

Procedure

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



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



5. Check the name you have entered and tap [Next] if it is correct.
   To make corrections, tap the name you entered.
6. The [Setup Method] screen appears. Select whether to use the take-up unit.
7. Tap [Start Setup].
   The cutting carriage moves and detects the width of the media and the positions of the media clamps. This operation is called initialization.
8. If the [The media could not be detected automatically. Manually set the printing area.]screen appears, carry out the following procedure.

It may not be possible to detect the media width with highly reflective media. Manually set the media width.

MEMO

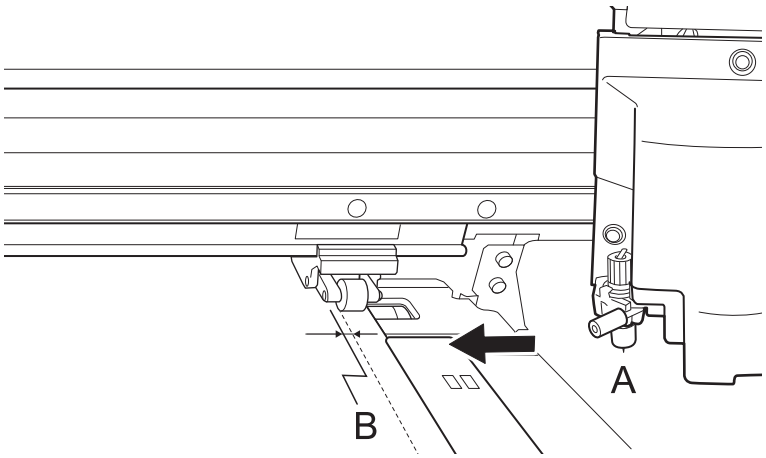
In the case of media where automatic media width detection was not possible after new media was registered, the screen automatically changes to the [**Printing Area Settings**] screen in Step (2).

(1) **Tap [OK].**

(2) **Tap [Change] on the [Printing Area] screen.**

The [**Set the right edge of the printing area within the area specified by the pinch rollers.**] screen appears.

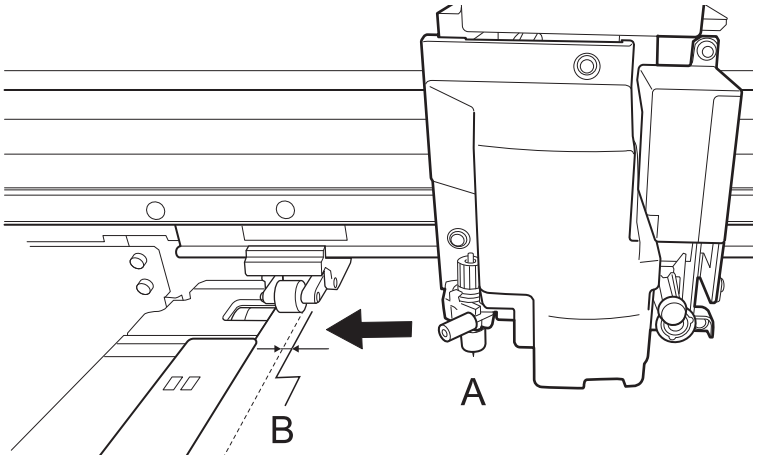
(3) **Hold down ‹ or › to move the center of the blade (A) approximately 2 mm (0.08 in.) to the inside (B) from the left edge of the right pinch roller.**



(4) **Tap [OK].**

The [**Set the left edge of the printing area within the area specified by the pinch rollers.**] screen appears.

(5) **Hold down ‹ or › to move the center of the blade (A) approximately 2 mm (0.08 in.) to the inside (B) from the right edge of the left pinch roller.**



(6) **Tap [OK].**

The set left and right positions are applied to the [**Printing Area (Width)**].

(7) **Tap [OK].**

3. Configuring Settings to Match the Media

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

In this step, perform a printing test for adjustment. Load media which can secure the printing area for the printing test. The printing test width is the following.

- **[Simple Correction (Auto)]**: Approx. 290 mm (11.42 in.)
- **[Detailed Correction (Manual)]**: Approx. 375 mm (14.76 in.)

Procedure

1. **On the [Select Media Output Type] screen, select the output type and tap [Next].**

- **[Print Only/Print & Cut]**

  Proceed to step 2.
- **[Cut Only]**

  Switch to the **[Multi Sensor Adjustment]** screen. Tap **[Execute]** to perform automatic adjustment, then tap **[OK]**. This completes the settings for **[Cut Only]**.

2. **Use the [Print Head Height] screen to adjust the print head height.**

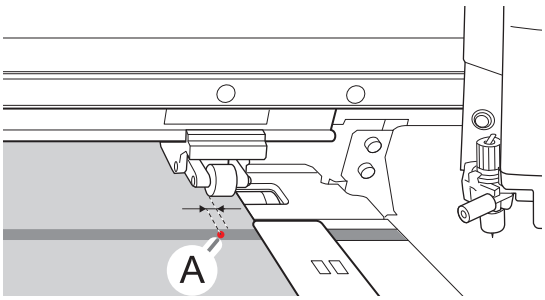
- If this is not necessary, tap **[Next]**.
- Follow the procedure below to make adjustments.
  a. Tap **[Change]**
  b. Open the front cover.
  c. Move the height-adjustment lever to adjust the head height.
  d. Close the front cover.
  e. Tap **[OK]**.
  f. Tap **[Next]**.

For details on this work, refer to Changing the Print Head Height(P. 182).

3. **Set the [Printing Test] and [Output Start Location] on the [Nozzle Drop-out Test] screen.**

- If this is not necessary, tap **[Next]**.
- Follow the procedure below to set **[Output Start Location]**.

  If this setting is not configured, the base point (A) will be set to the following location.
  - Feed direction: Blade protector position
  - Scan direction: About 2 mm (0.08 in.) from the left edge of the right pinch roller

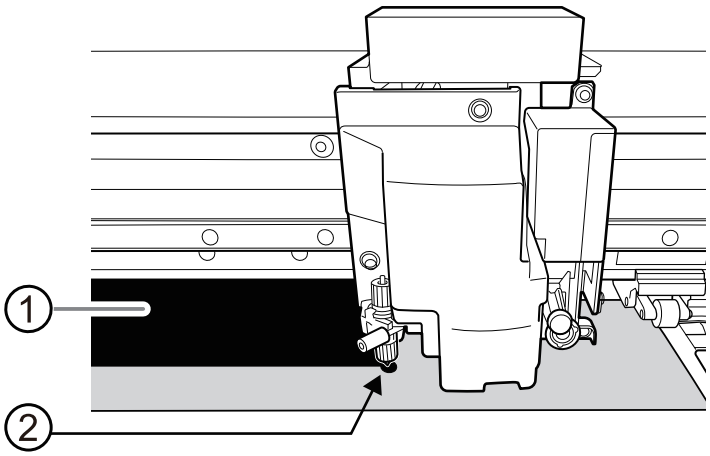


a. Tap **[Output Start Location]**>**[Change]**.
b. Tap ‹.

The cutting carriage moves to the current base point.

c. Tap ^ v < > and move the cutter center to the position where you want to start cutting.

Tap ^ or v to move the media in the feed direction (forward-back). Tap < or > to move the cutting carriage in the scan direction (left-right).



- ①: Printing area
- ②: Base point (right edge of the printing area)

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

The base point position is updated.

- Follow the procedure below to perform [**Printing Test**].

Tap [**Execute**] next to [**Printing Test**]. For details on what to do after the printing test, refer to Performing Normal Cleaning(P. 288).

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

Here, the media feed correction for reducing horizontal bands and the correction of the landing position of the ink will be adjusted.

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.

Check the printing area required for the printing test before executing the test.

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

For more information, refer to Automatically Making Required Adjustments(P. 177).

- **Follow the procedure below to make manual adjustments.**

a. Tap [**Detailed Correction (Manual)**]>[**Next**].

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

Adjust the reading sensor to the optimal condition. If the adjustment failed, respond to the failure according to the information in Correcting the Reading Sensor(P. 219).

c. Tap [**Next**].

d. Tap [**Execute**] for [**Printing Test**] on the [**Detailed Feed Correction (Manual)**] screen. Check the printing area required for the printing test before executing the test.

   Set the correction values from the printing test result. For more information, refer to Manual Adjustment: Reducing Horizontal Bands (Feed Correction)(P. 178).

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

f. Tap [**Execute**] for [**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. 180).

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

This completes the setup.

Setup of Registered Media

⚠ CAUTION

Do not touch the dancer roller needlessly.
The media take-up unit and feeder may move suddenly, which may result in injury.

Setup of Roll Media

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

⚠ CAUTION

Load the roll media correctly.
Otherwise the media may fall and cause injury.

⚠ CAUTION

The roll media is approximately 45 kg [99.21 lb.], 30-inch model: 30 kg [66.1 lb.]).
To avoid injury, handle the roll media with care.

⚠ CAUTION

Never load media that weighs over 45 kg [99.21 lb.], 30-inch model: 30 kg [66.1 lb.]).
The machine may fail to withstand the weight and tip over or cause the media to fall.

1. Installing the Media on the Media Holders

⚠ WARNING

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

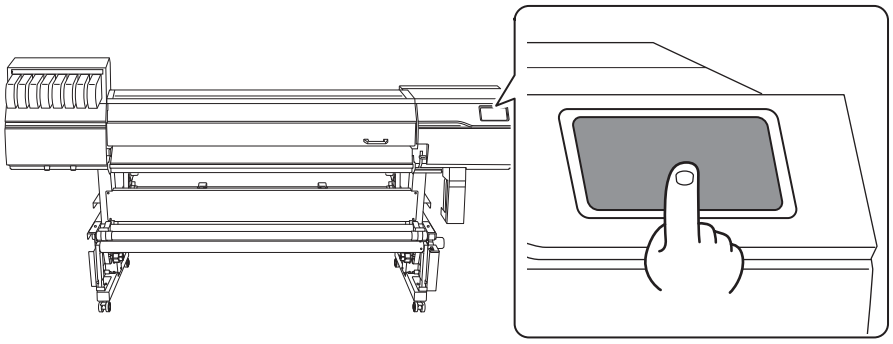
Attempting to lift heavy media in a manner that taxes your strength may cause physical injury. Also, if dropped, such items may cause injury.

MEMO

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.

Procedure

1. **Tap the operation panel.**



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

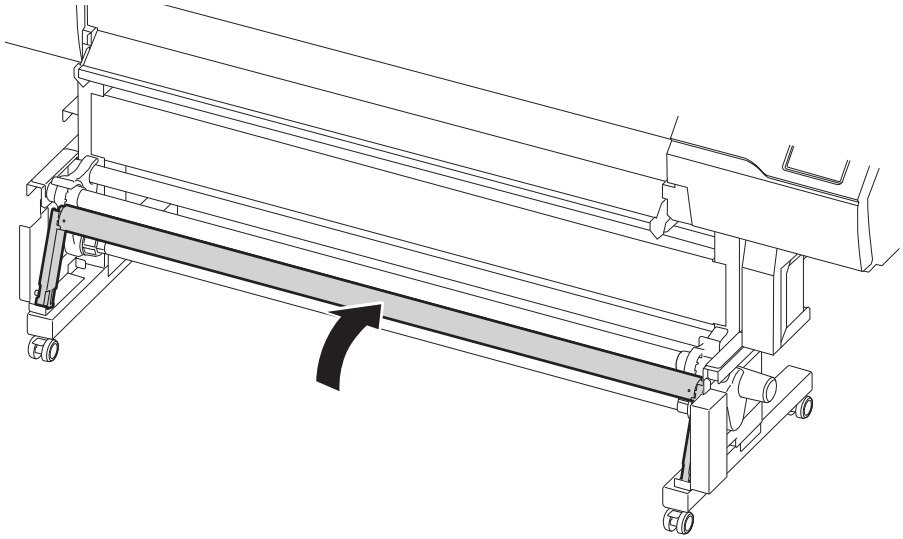
The machine sub power is switched on.

3. **When using a take-up unit, perform the procedure under**
P. 190 Setting the Take-up Unit
as necessary.

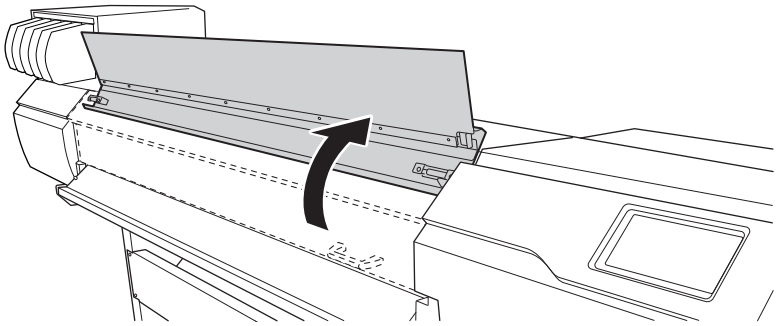
Check the settings in the following cases.

- Using weak media
- Taking up the media with an inward curl
- Taking up the media during cutting process in the Print & Cut mode

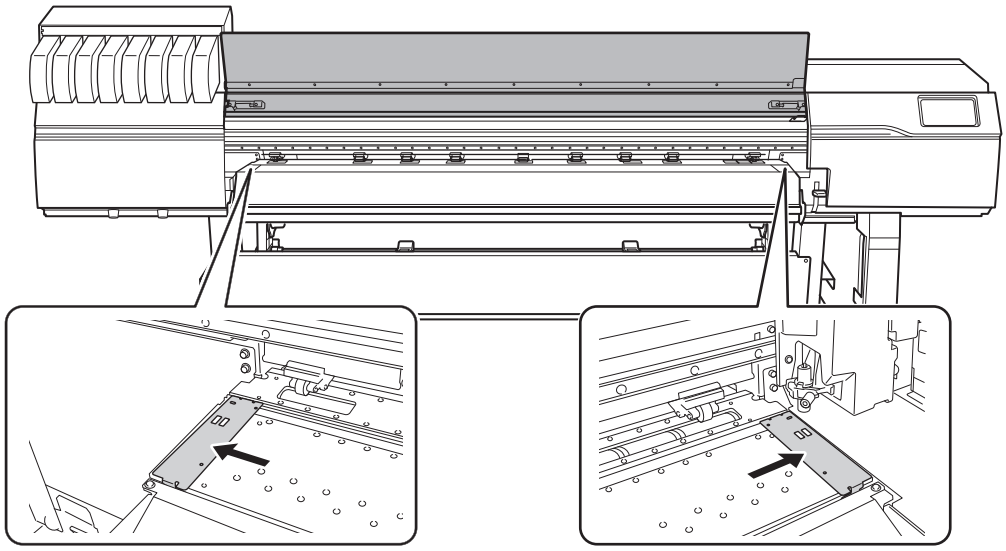
4. **Check that the dancer roller has lowered toward the rear.**



5. Open the front cover.



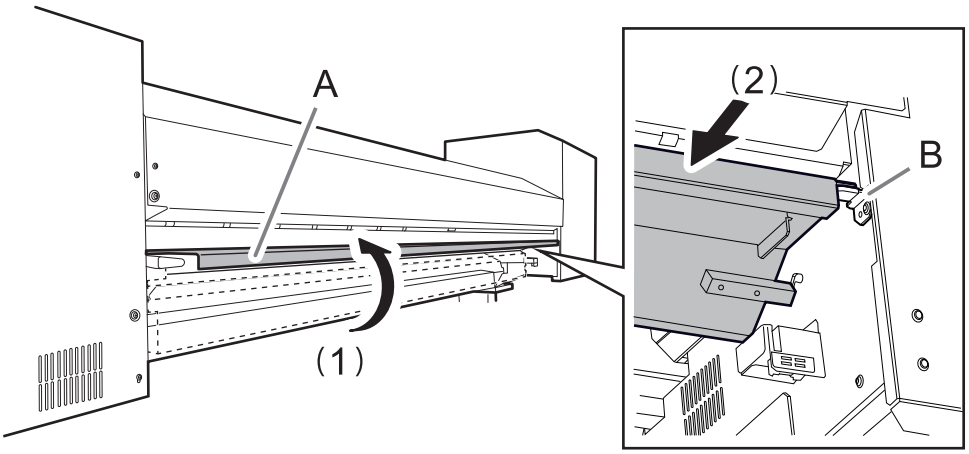
6. Move the media clamps to the outside of the grit rollers on the left and right edges respectively.



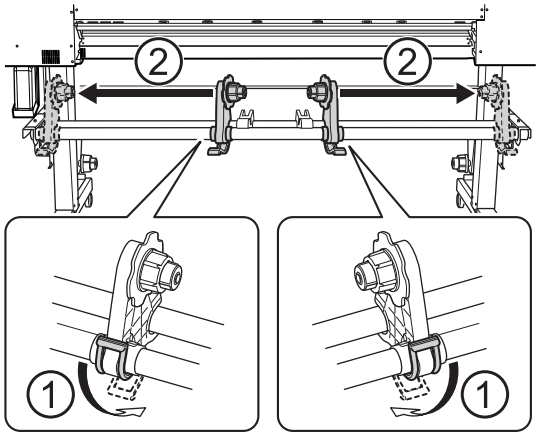
7. Move to the rear of the printer and open the rear UV shield.

(1) Open the rear UV shield (A).

(2) Push the rear UV shield to the front of the machine, and then place this shield on the left and right stoppers (B).



8. **Move the media holders to the outside.**



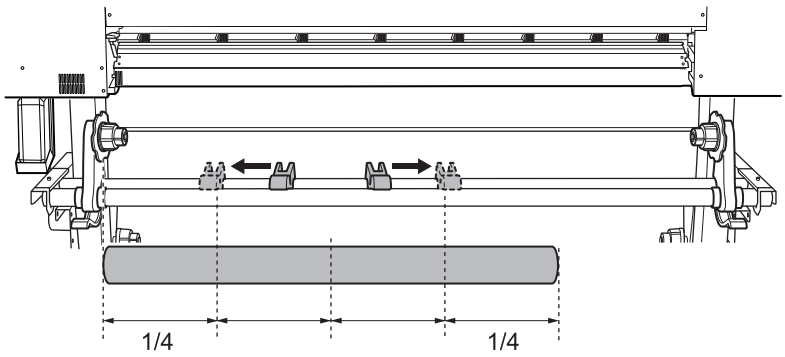
9. **Place the media on the machine.**

IMPORTANT

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

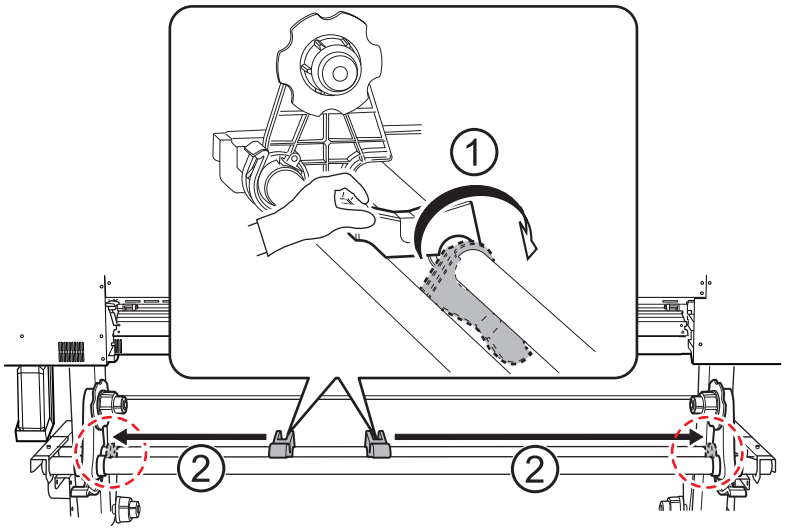
- Roll media with an outer diameter of 220 mm (8.66 in.) or less

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

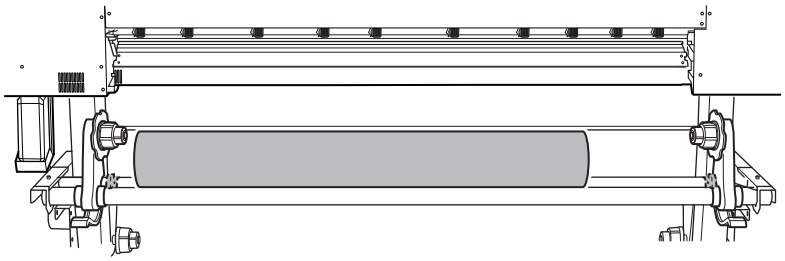


- Roll media with an outer diameter exceeding 220 mm (8.67 in.)

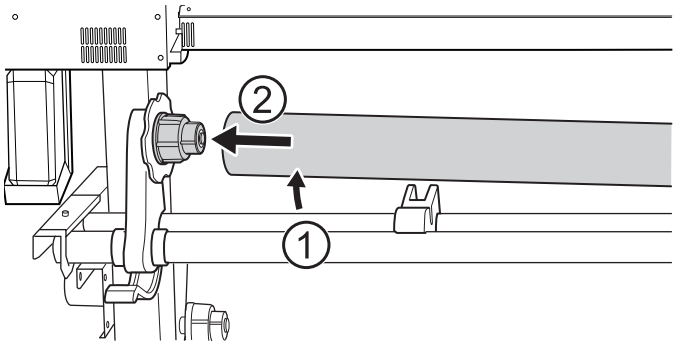
  a. Rotate the media stays to draw them to the media holders.



b. Place the media directly between the two shafts.



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



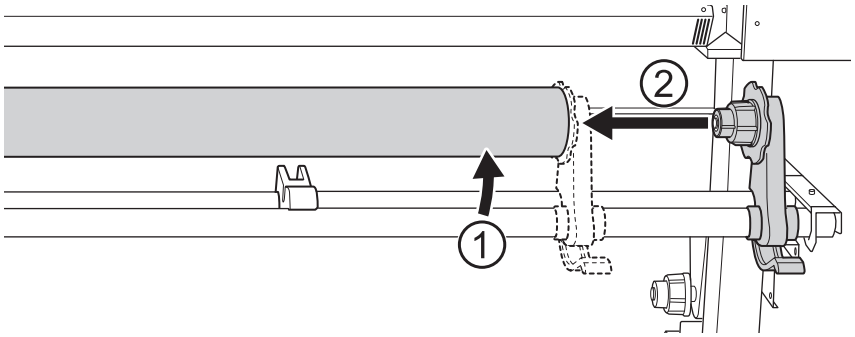
11. **Move the right media holder to fit its end cap onto the paper tube (core) of the media.**

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.

- For general media: 2. A: Determining the Positions of the Media(P. 82)
- For transparent media or if **[Preferences]**>**[Media Edge Detection]** is set to **[Disable]**: 2. B: Determining the Positions of Media (If **[Media Edge Detection]**: **[Disable]**)(P. 88)

2. A: Determining the Positions of the Media

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

Because the suction fan does not operate, the following procedure cannot be used to load media when using transparent media or media with high reflectance whose edges cannot be detected, or when **[Disable]** is set for **[Preferences]**>**[Media Edge Detection]**. In these cases, refer to 2. B: Determining the Positions of Media (If [Media Edge Detection]: [Disable])(P. 88).

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

Procedure

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

(1) **Tap** ☰.

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

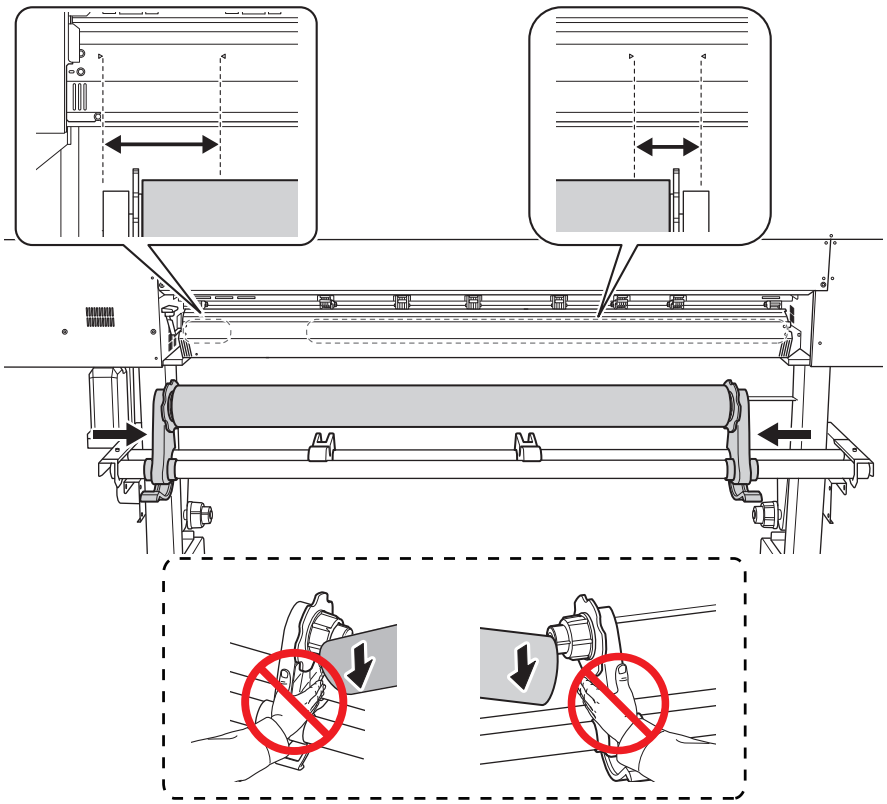
(3) **Select [Enable] and tap [Save].**

(4) **Press** ⌂ **to return to the home screen.**

2. **Determine the left and right positions of the media with the grit patterns used as the reference.**

Note the following points when determining the positions.

- Hold the media holders from the outside and move them.
- Ensure that the left edge of the media is positioned so that it is within the range of the grit pattern of the left edge.
- Ensure that the right edge of the media is positioned so that it is within the range of one of the grit patterns.



⚠ WARNING

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

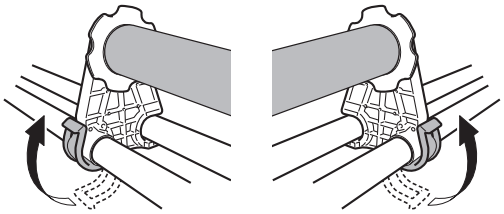
Doing so may cause the media to fall off the media holder and cause injury.

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.

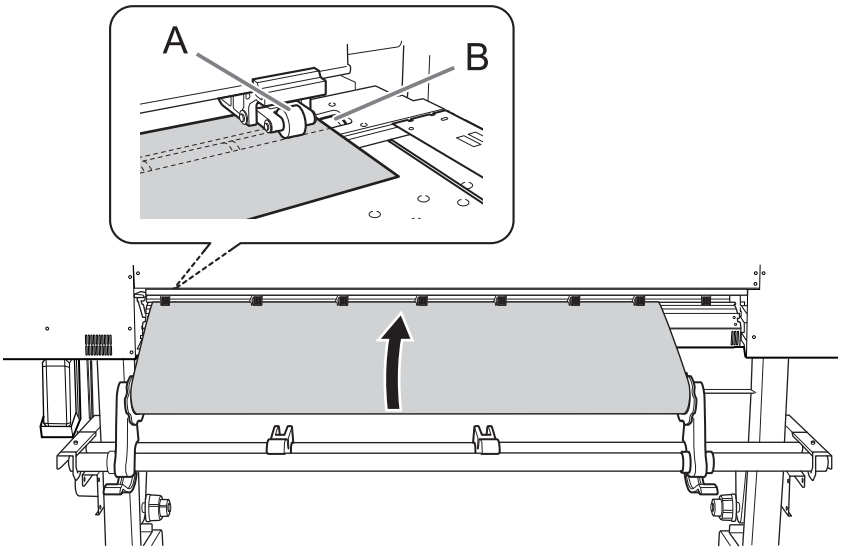
3. **Secure the media holders.**



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

Doing so will prevent media skewing.

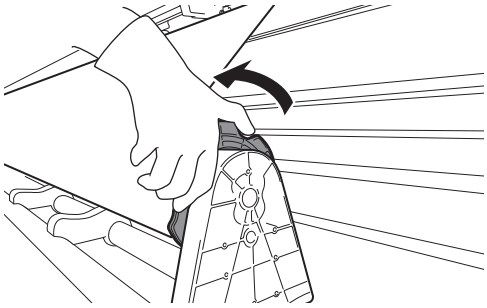
(1) **Pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**



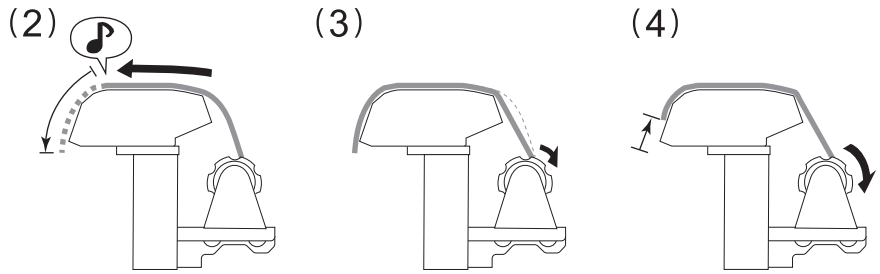
(2) **Feed the media until you hear a beep, and then additionally feed approximately 20 cm (7.87 in.) of the media.**

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.**



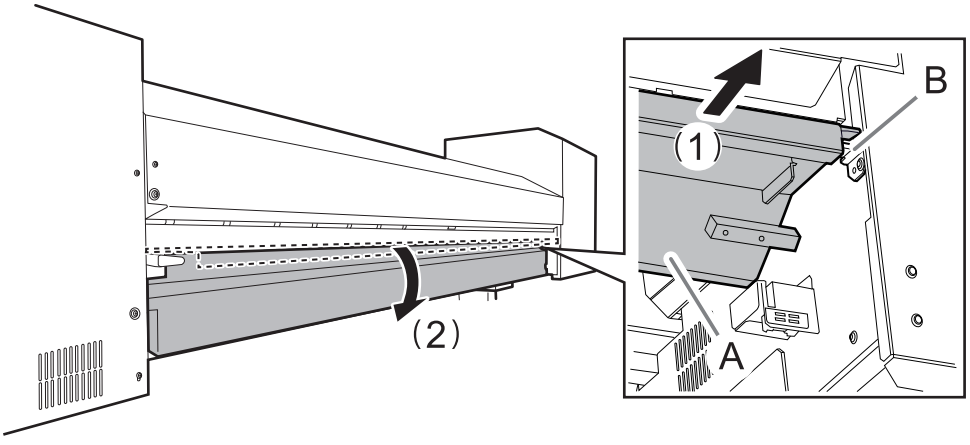
MEMO

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. **Close the rear UV shield.**

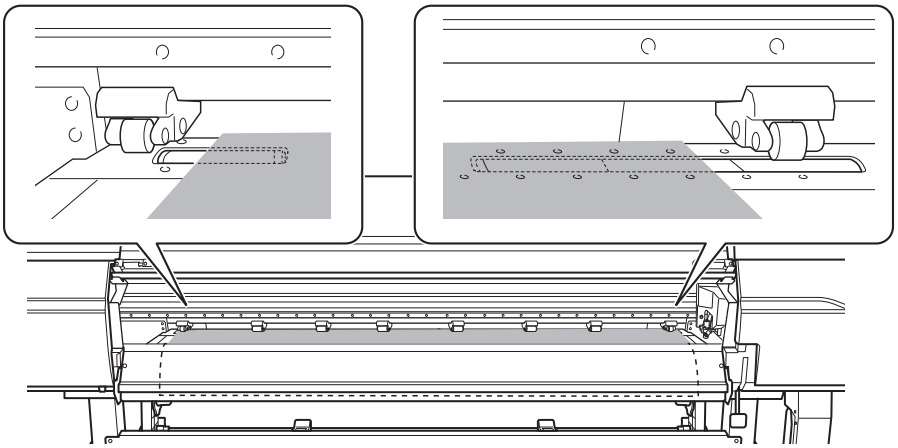
(1) **Pull the rear UV shield (A) to the back of the machine, and then remove this shield from the left and right stoppers (B).**

(2) **Close the rear UV shield.**



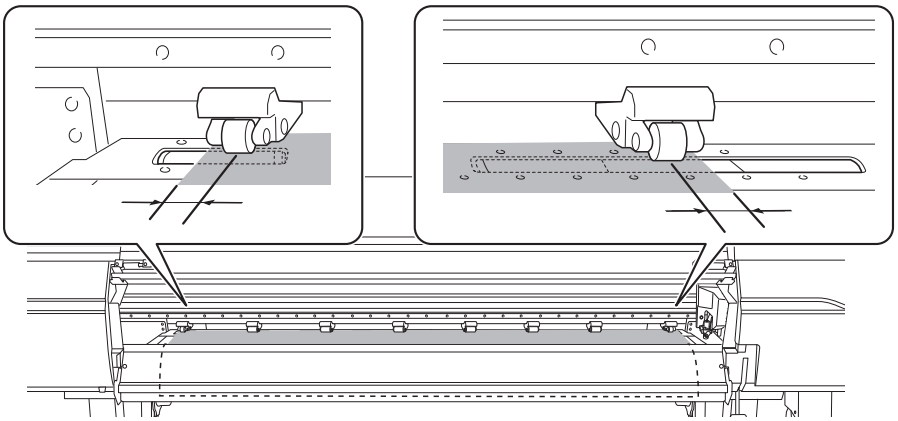
6. **(Move to the front of the printer.) Make sure both edges of the media are above the grit rollers.**

Be sure to place the right edge of the media on the right-end grit roller.



7. **Move the left and right pinch rollers, placing them on both edges of the media.**

Position them approximately 10 mm (0.39 in.) from each edge of the media.



IMPORTANT

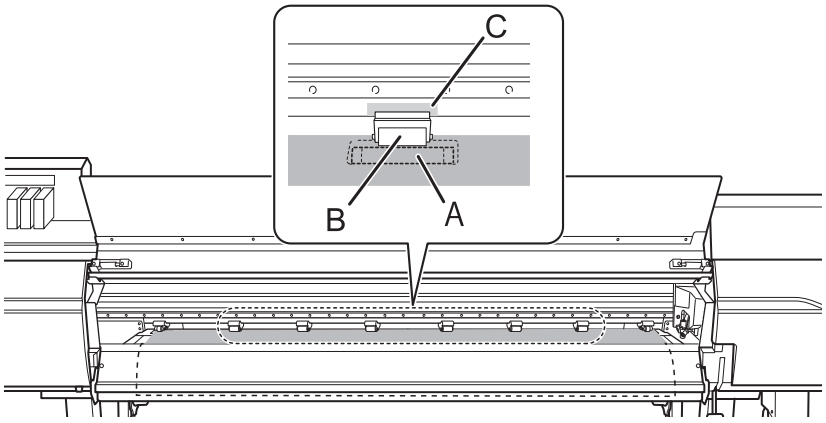
- Be sure to use the left and right pinch rollers. The force with which the media is pinched varies between the middle pinch rollers and the left and right pinch rollers. Using the middle pinch rollers to pinch the media edges will lead to unstable media feeding.
- If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from Step 2. 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.

MEMO

To smoothly move the pinch rollers, push down close to the rail.

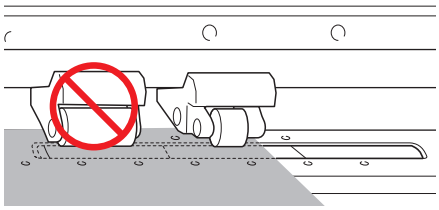
8. **Move the middle pinch rollers (B) over all the remaining grit rollers (A) covered by the media.**

There are grit patterns (C) wherever there are grit rollers.

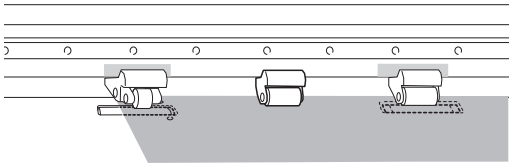


IMPORTANT

- Place the middle pinch rollers over all the grit patterns within the media width. If you have forgotten to place the middle pinch rollers, the media will be skewed during printing or will come loose, which will have an effect on the printing quality.
- The middle pinch roller will not lower onto the three grit rollers from the right end. Place the middle pinch roller on a grit roller other than these three.

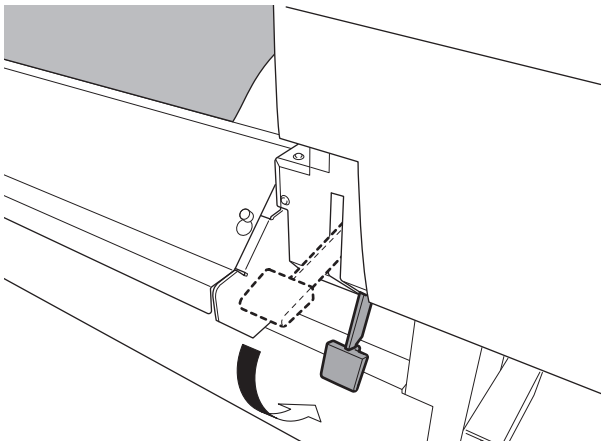


- There may be extra middle pinch rollers depending on the width of the media being used. Move the extra middle pinch rollers to positions where no grit patterns are present. Where no grit patterns are present, the middle pinch rollers will not come down.



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

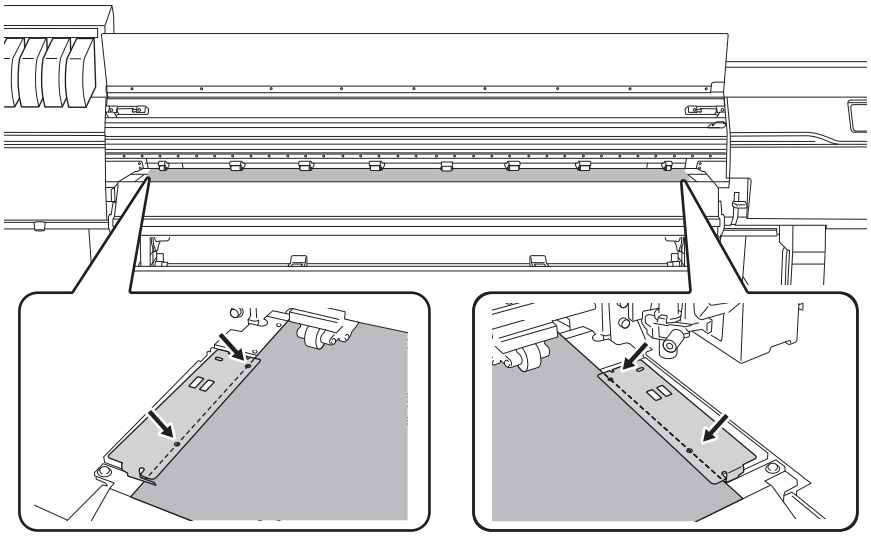
The media is held in place.



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 2. 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. **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 set up media.

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

11. **Close the front cover.**

2. B: Determining the Positions of Media (If [Media Edge Detection]: [Disable])

Use the following procedure to determine the positions of the media when using transparent media or media with high reflectance whose edges cannot be detected, and when [**Preferences**]>[**Media Edge Detection**] is set to [**Disable**].

Procedure

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

(1) **Tap** ☰.

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

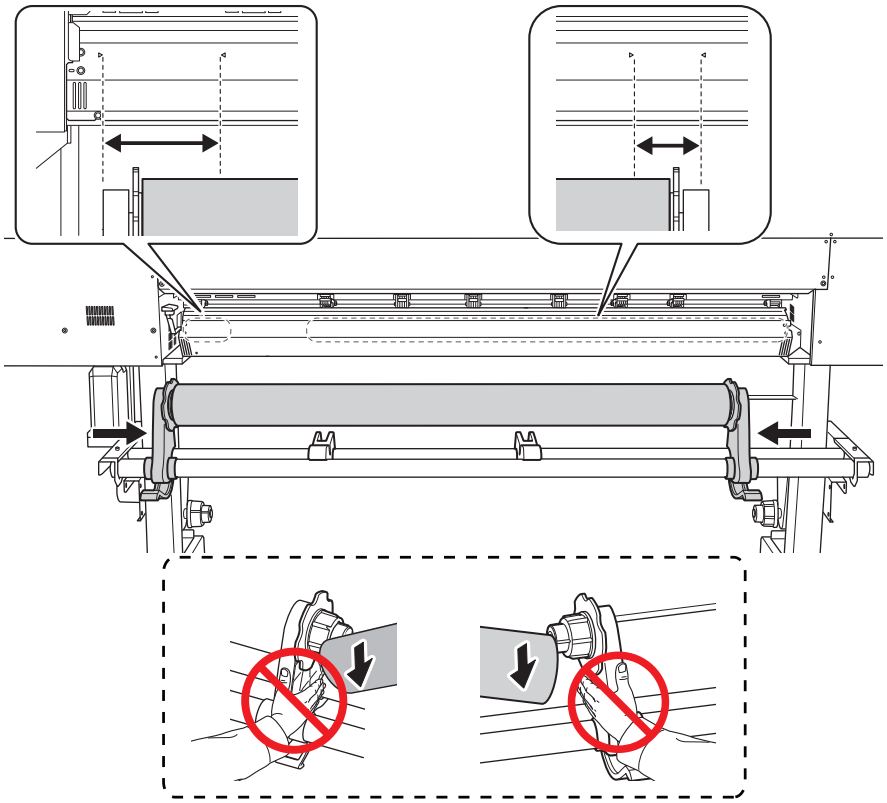
(3) **Select [Disable] and tap [Save].**

(4) **Press** ⌂ **to return to the home screen.**

2. **Determine the left and right positions of the media with the grit patterns used as the reference.**

Note the following points when determining the positions.

- Hold the media holders from the outside and move them.
- Ensure that the left edge of the media is positioned so that it is within the range of the grit pattern of the left edge.
- Ensure that the right edge of the media is positioned so that it is within the range of one of the grit patterns.



⚠ WARNING

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

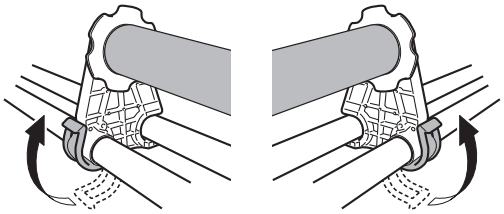
Doing so may cause the media to fall off the media holder and cause injury.

IMPORTANT

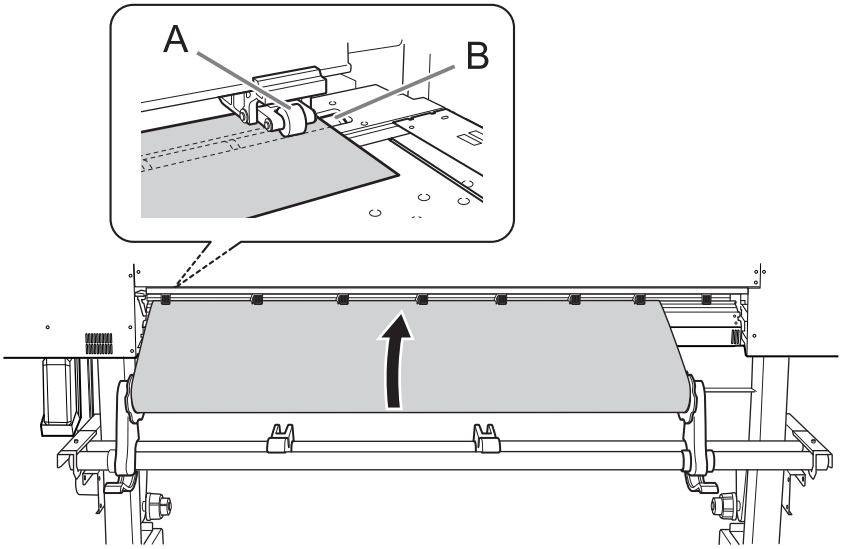
Firmly decide the left and right side positions of the media at this point.

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.**

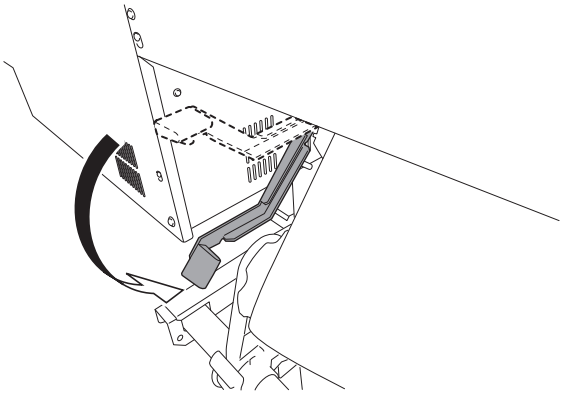


4. **Pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**



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

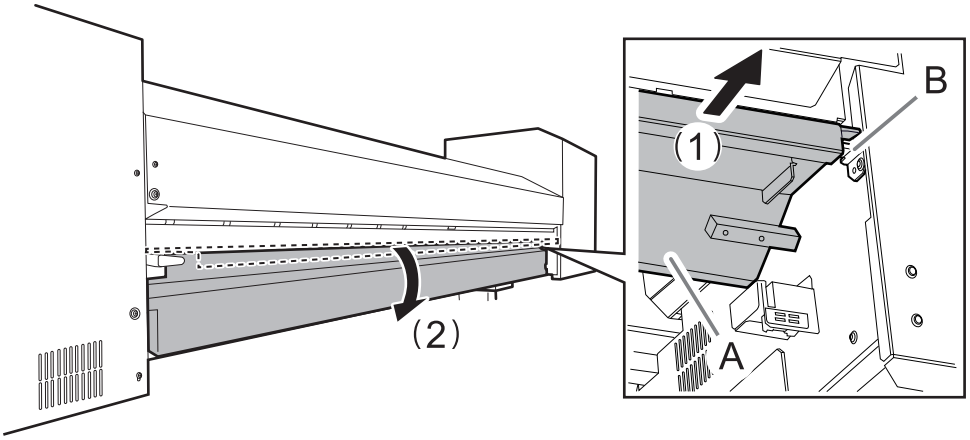
The media is held in place.



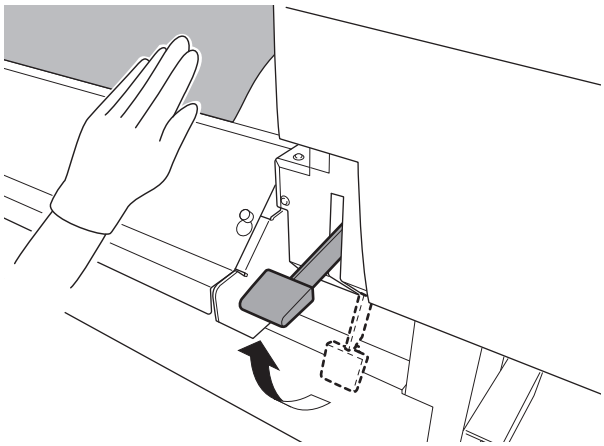
6. **Close the rear UV shield.**

(1) **Pull the rear UV shield (A) to the back of the machine, and then remove this shield from the left and right stoppers (B).**

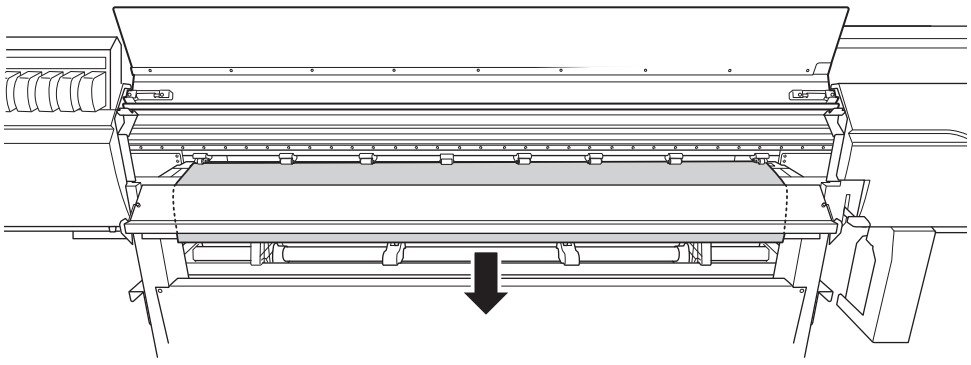
(2) **Close the rear UV shield.**



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

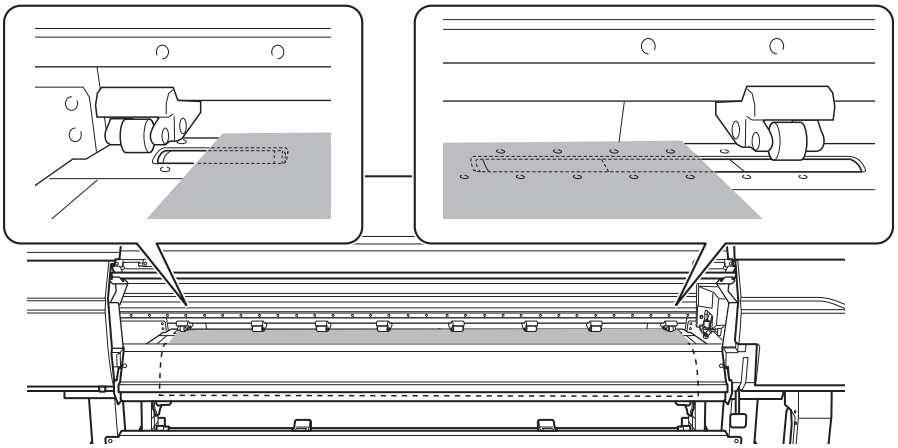


8. **Pull out the media over the apron.**



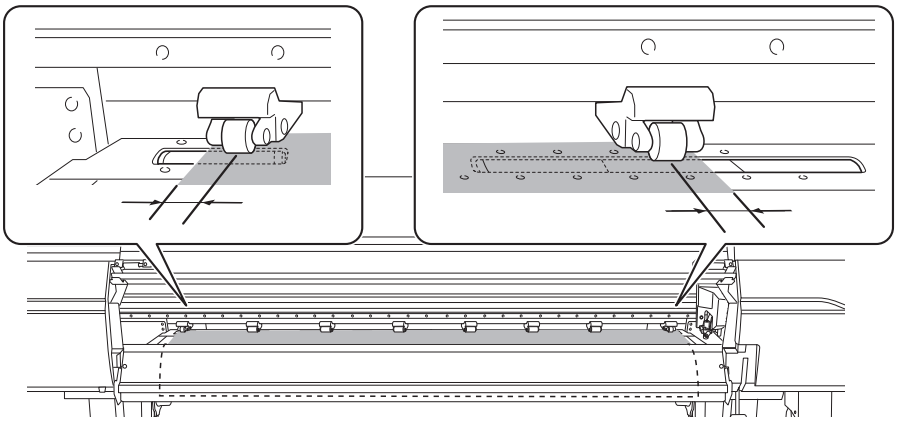
9. **Make sure both edges of the media are above the grit rollers.**

Be sure to place the right edge of the media on the right-end grit roller.



10. **Move the left and right pinch rollers, placing them on both edges of the media.**

Position them approximately 10 mm (0.39 in.) from each edge of the media.



IMPORTANT

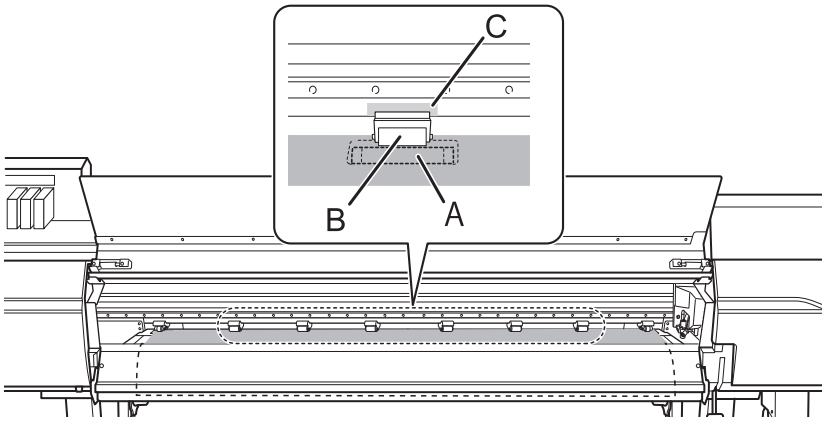
- Be sure to use the left and right pinch rollers. The force with which the media is pinched varies between the middle pinch rollers and the left and right pinch rollers. Using the middle pinch rollers to pinch the media edges will lead to unstable media feeding.
- If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from Step 2. 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.

MEMO

To smoothly move the pinch rollers, push down close to the rail.

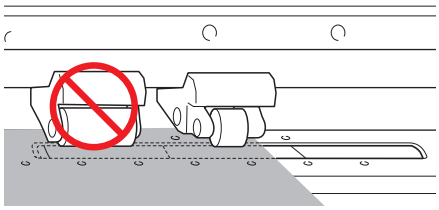
11. **Move the middle pinch rollers (B) over all the remaining grit rollers (A) covered by the media.**

There are grit patterns (C) wherever there are grit rollers.

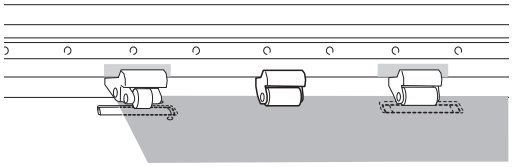


IMPORTANT

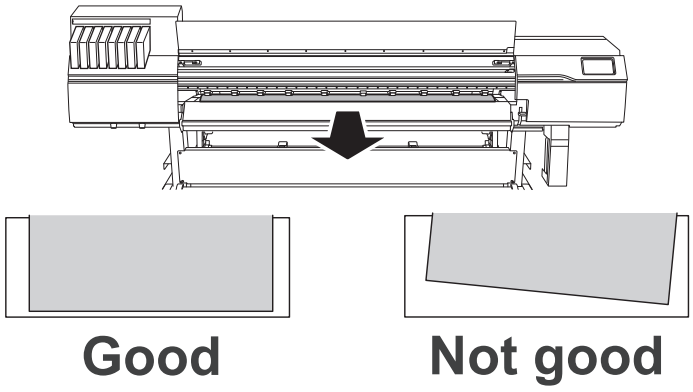
- Place the middle pinch rollers over all the grit patterns within the media width. If you have forgotten to place the middle pinch rollers, the media will be skewed during printing or will come loose, which will have an effect on the printing quality.
- The middle pinch roller will not lower onto the three grit rollers from the right end. Place the middle pinch roller on a grit roller other than these three.



- There may be extra middle pinch rollers depending on the width of the media being used. Move the extra middle pinch rollers to positions where no grit patterns are present. Where no grit patterns are present, the middle pinch rollers will not come down.

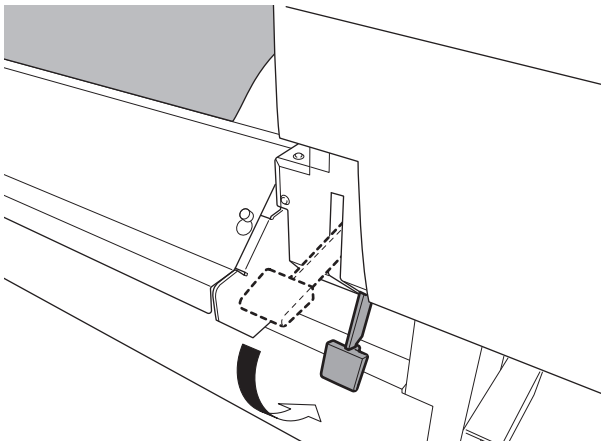


12. Hold the media at the center and pull it out, being sure to keep it straight and all areas of the media to be taut.

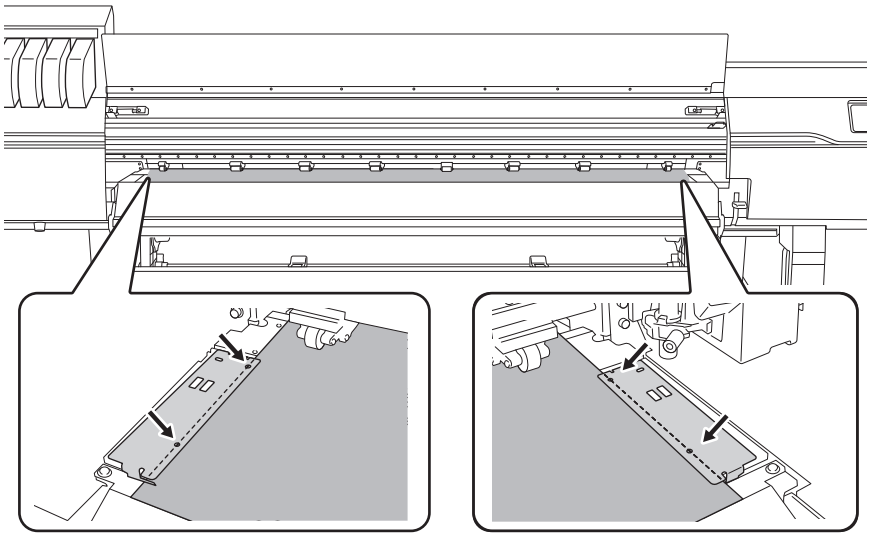


13. Lower the loading lever (front).

The media is held in place.



14. **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 set up media.
If you load the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

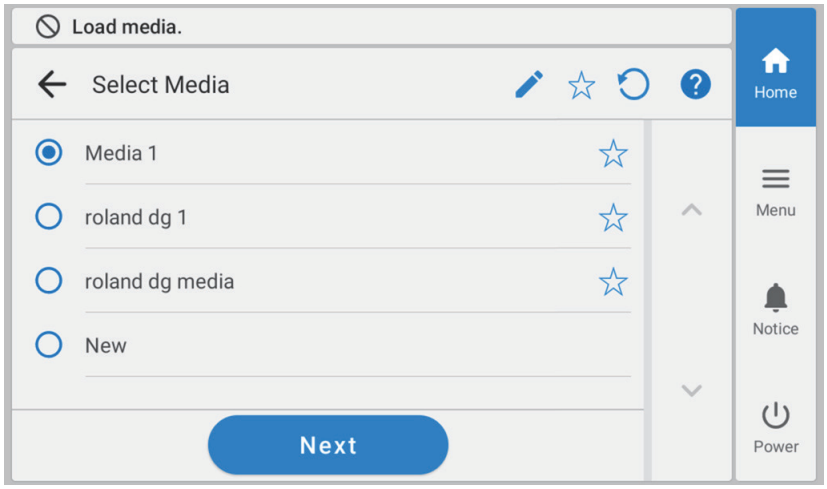
15. **Close the front cover.**

3. Selecting the Media

Procedure

1. Tap [Setup].

The registered media is displayed in a list.

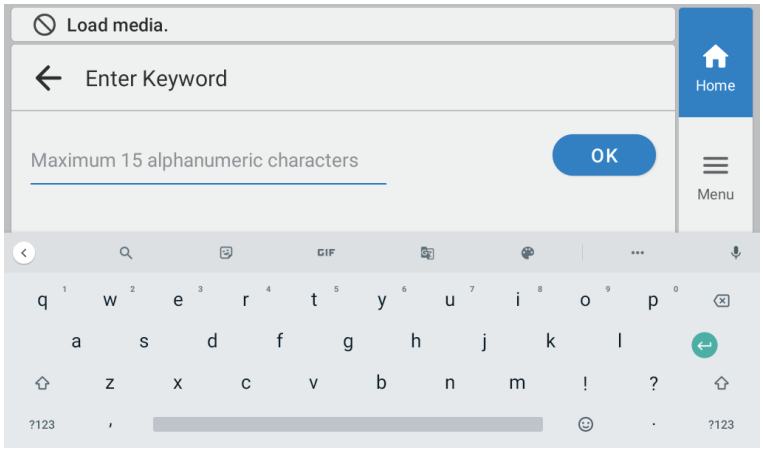


2. Select the media to use.

MEMO

You can search for media in the media list by keyword and register media as favorites. The media list can also be set to show only media registered as favorites. Keyword searching and favorites registration can be used at the same time.

- **Searching for keywords in the media list**
  1. Tap .
  2. Enter the media to search for.
     Searching for partial matches instead of exact matches is also possible.



  3. Tap [OK].
     Media filtered according to the keywords will be displayed.
  4. Select the media to use from the search results.
- **Registering media to favorites and showing only media registered as favorites**

  Tap ☆ for the media to register it to favorites.

  The icon for the favorited media will be displayed as ★.

To show only media registered as favorites, tap the icon indicated below.



To reset the keyword search or favorites registration, tap .

When using both the keyword search and favorites registration, each function can also be reset individually.

To reset the keyword search, tap to delete the keyword.

To reset the favorites registration, tap for the media you want to reset.

3. **Tap [Next].**

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

5. **Tap [Start Setup].**

The cutting carriage moves and detects the width of the media and the positions of the media clamps. This operation is called initialization.

6. **If the [The media could not be detected automatically. Manually set the printing area.] screen appears, carry out the following procedure.**

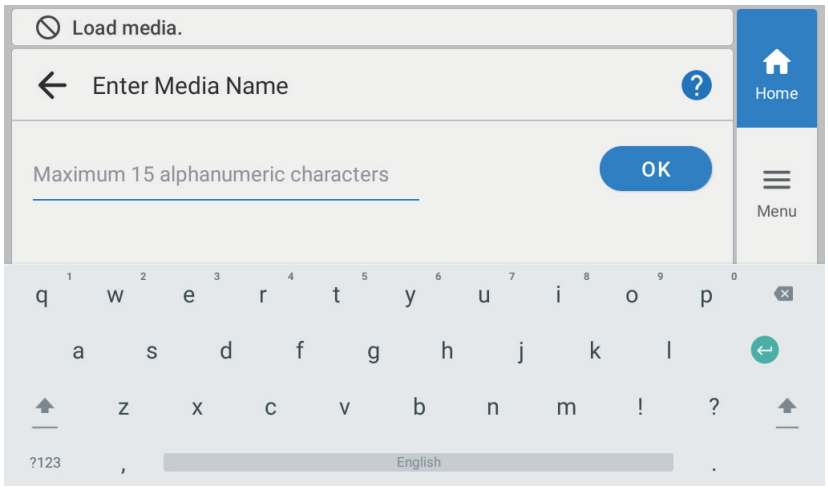
It may not be possible to detect the media width with highly reflective media. Manually set the media width.

MEMO

If automatic media width detection is not possible and the printing area is set manually when new media is registered, the screen automatically changes to the **[Printing Area Settings]** screen in Step (3).

(1) **Tap [OK].**

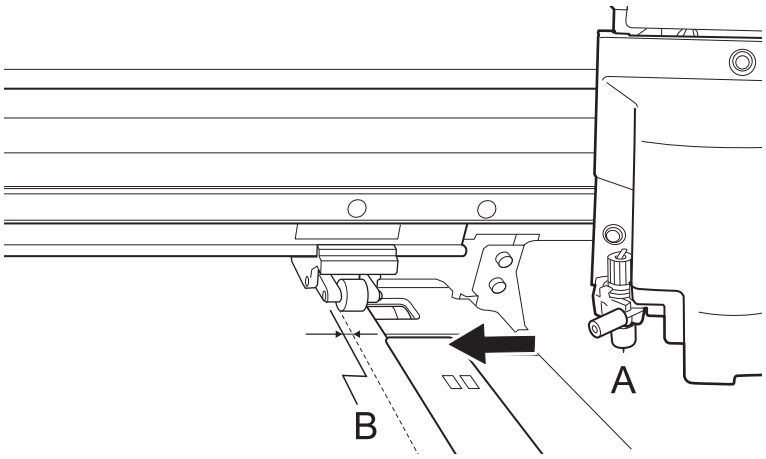
(2) **Enter a new media name and tap [OK].**



(3) **Tap [Change] on the [Printing Area Settings] screen.**

The **[Set the right edge of the printing area within the area specified by the pinch rollers.]** screen appears.

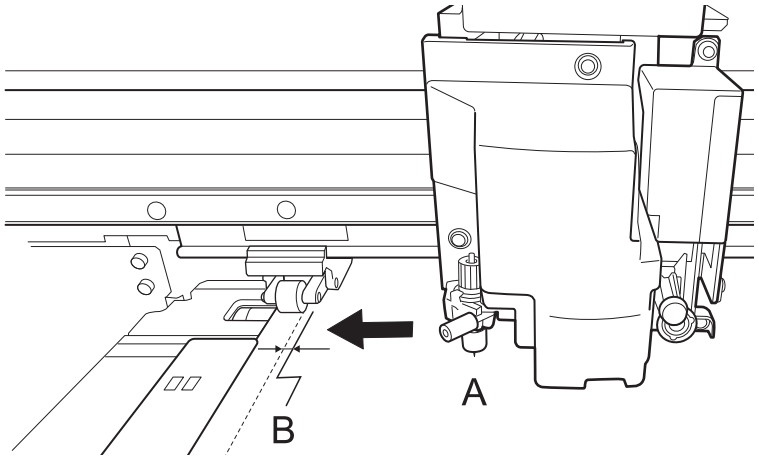
(4) **Hold down ‹ or › to move the center of the blade (A) approximately 2 mm (0.08 in.) to the inside (B) from the left edge of the right pinch roller.**



(5) **Tap [OK].**

The **[Set the left edge of the printing area within the area specified by the pinch rollers.]** screen appears.

(6) **Hold down ‹ or › to move the center of the blade (A) approximately 2 mm (0.08 in.) to the inside (B) from the right edge of the left pinch roller.**



(7) **Tap [OK].**

The set left and right positions are applied to the [**Printing Area (Width)**].

(8) **Tap [OK].**

If the take-up unit is not used, setup is now completed.

4. Loading the Media in the Take-up Unit

Procedure

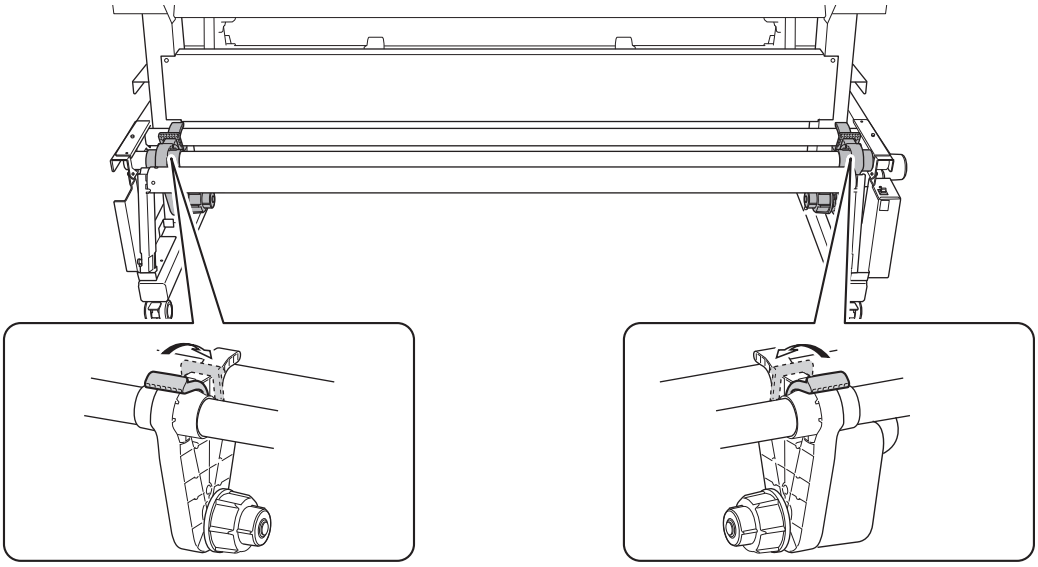
1. Follow the procedure below to load a paper tube on the media holders of the take-up unit.

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

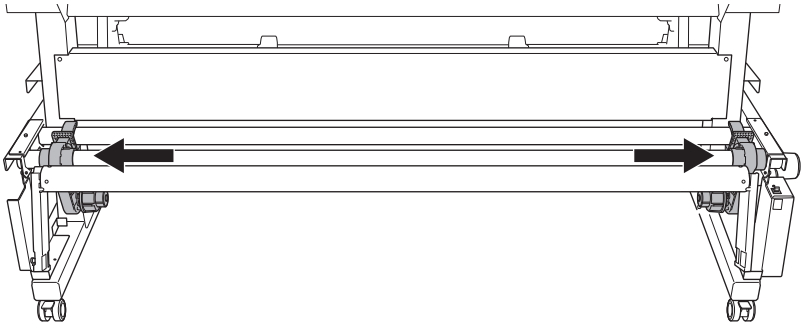
IMPORTANT

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.**



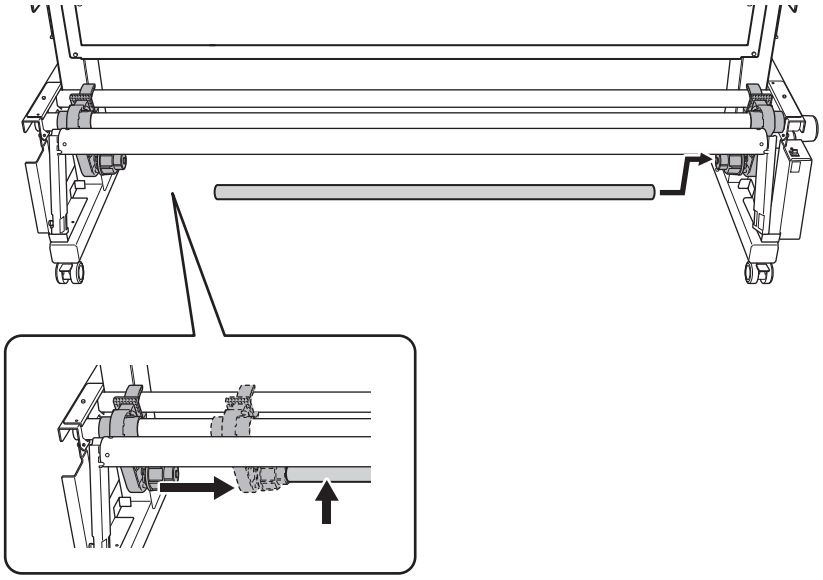
(2) **Draw the media holders to both left and right ends respectively.**



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

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

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

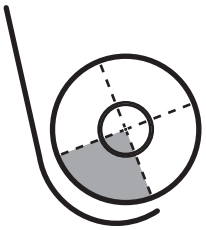
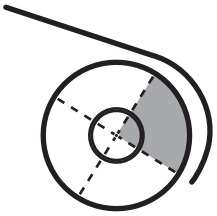


2. **Tap ⌄ on the operation panel to feed out the media until the tip of the media reaches the paper tube.**

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

MEMO

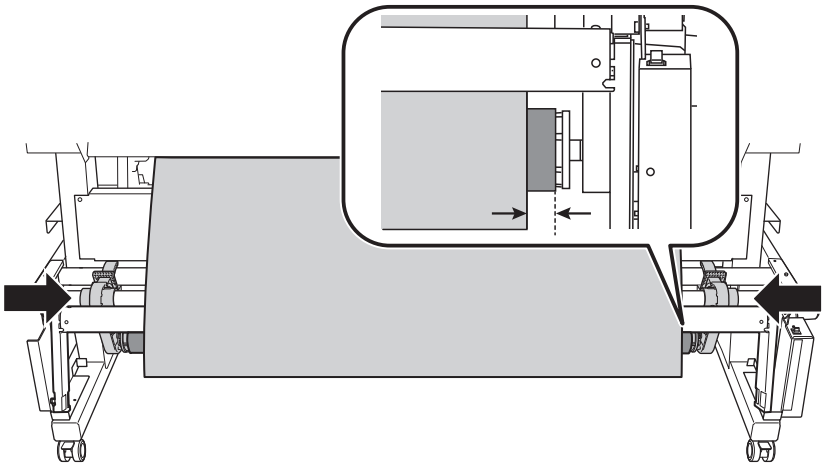
Feed out the media until it can wrap around at least 1/4 of the paper tube (or at least halfway around when rewinding during cutting).

When using the FORWARD setting	When using the BACKWARD setting
	

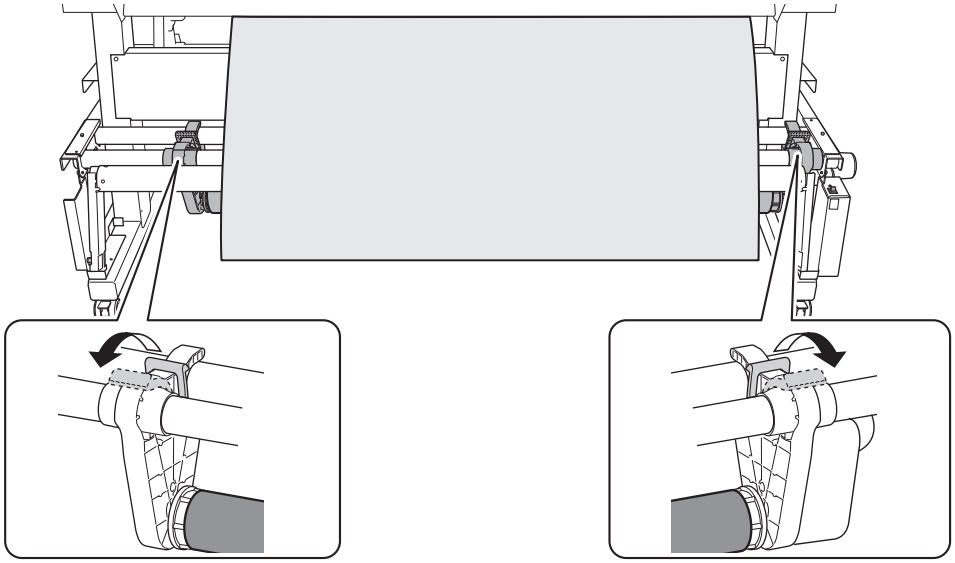
3. **Follow the procedure below to adjust the positions of the media holders.**

(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.**



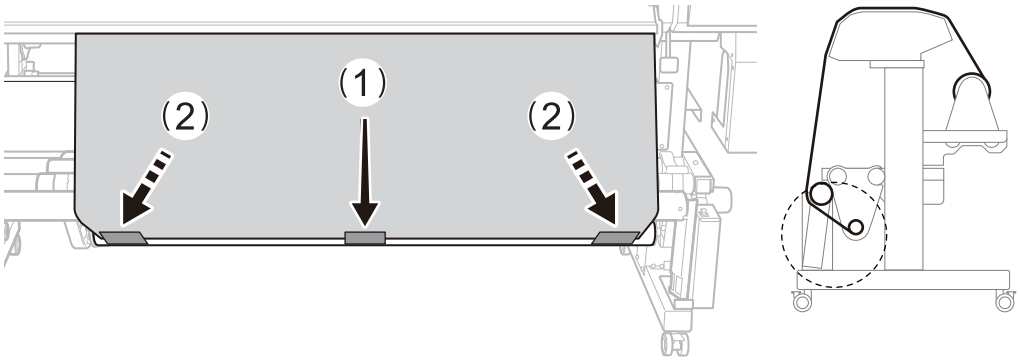
4. **Follow the procedure below to secure the media on the paper tube.**

Secure the media in the take-up direction set in step 3 of 1. Installing the Media on the Media Holders(P. 77).

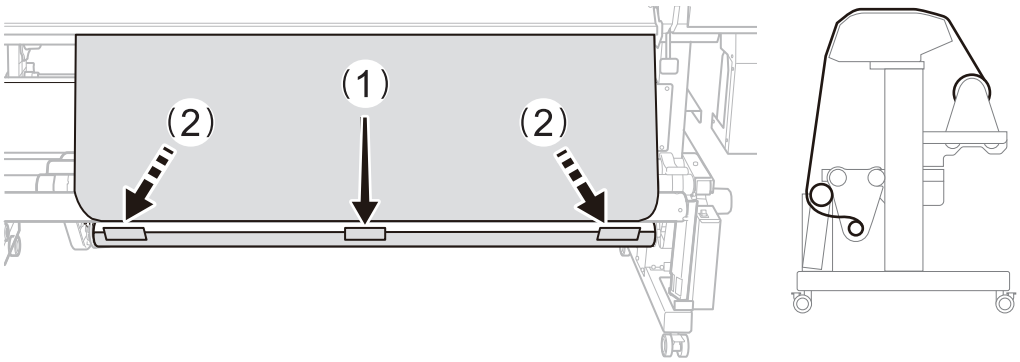
(1) **While pulling the media so that it does not sag, secure the center of the media on the paper tube with adhesive tape.**

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

- **When using the FORWARD setting**

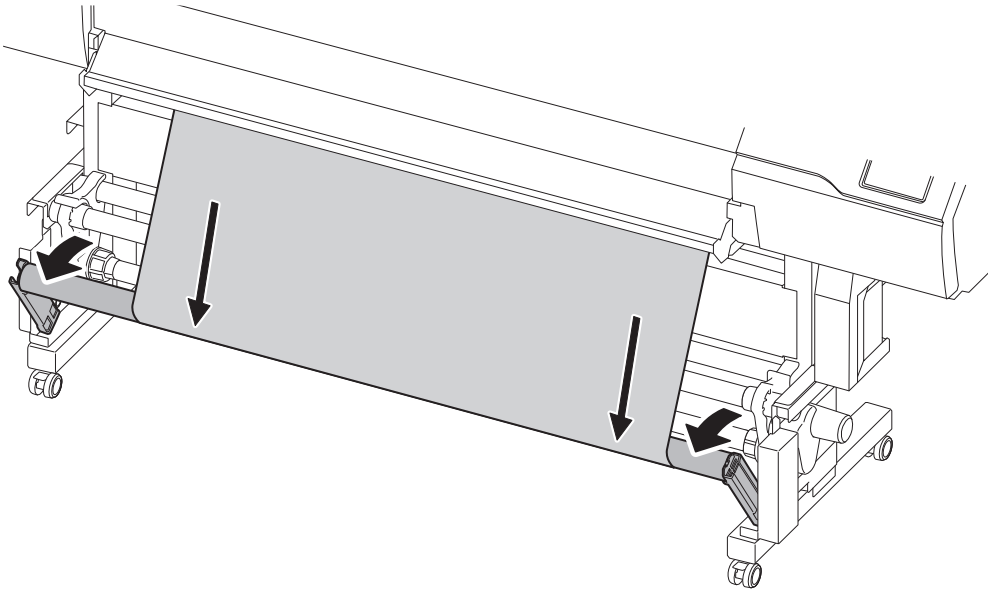


- **When using the BACKWARD setting**



5. **Tap [OK].**
A small amount of the media is fed out.

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



7. **Tap [OK].**
This completes the setup.

Setup of Sheet Media

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

1. A: Determining the Positions of the Media

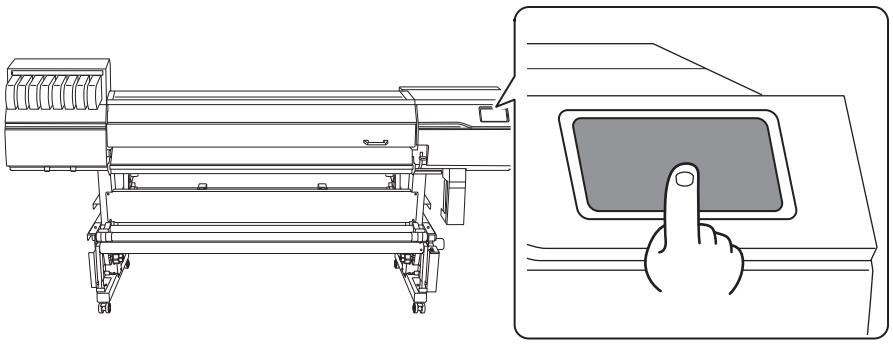
This section describes how to use the suction fan to prevent media skewing.

Because the suction fan does not operate, the following procedure cannot be used to load media when using transparent media or media with high reflectance whose edges cannot be detected, or when [**Disable**] is set for [**Preferences**]>[**Media Edge Detection**]. In these cases, refer to 1. B: Determining the Positions of Media (If [Media Edge Detection]: [Disable])(P. 108).

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

Procedure

1. **Tap the operation panel.**



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

   The machine sub power is switched on.

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

   (1) **Tap** ☰.

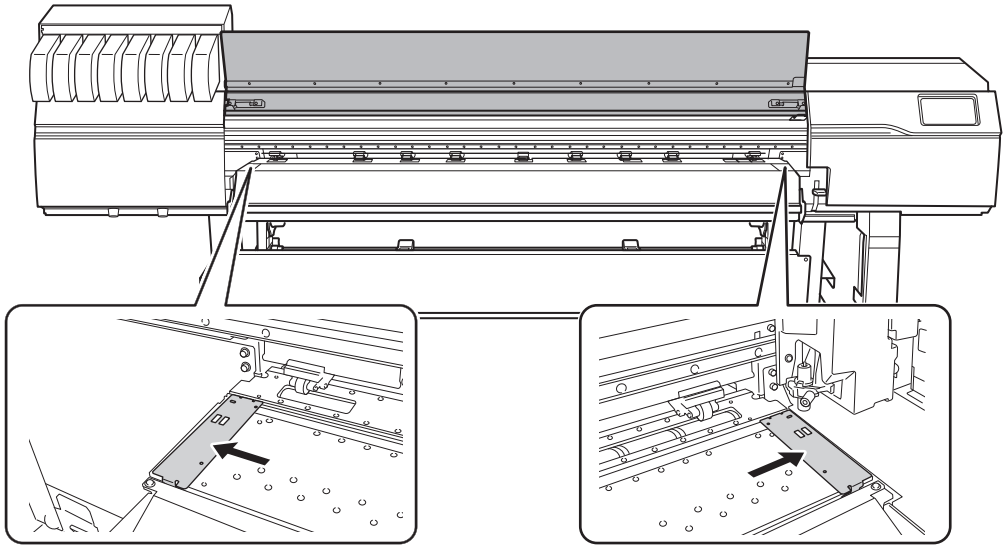
   (2) **Tap [Preferences]>[Skewing Correction Support at Setup].**

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

   (4) **Press** ⌂ **to return to the home screen.**

4. **Open the front cover.**

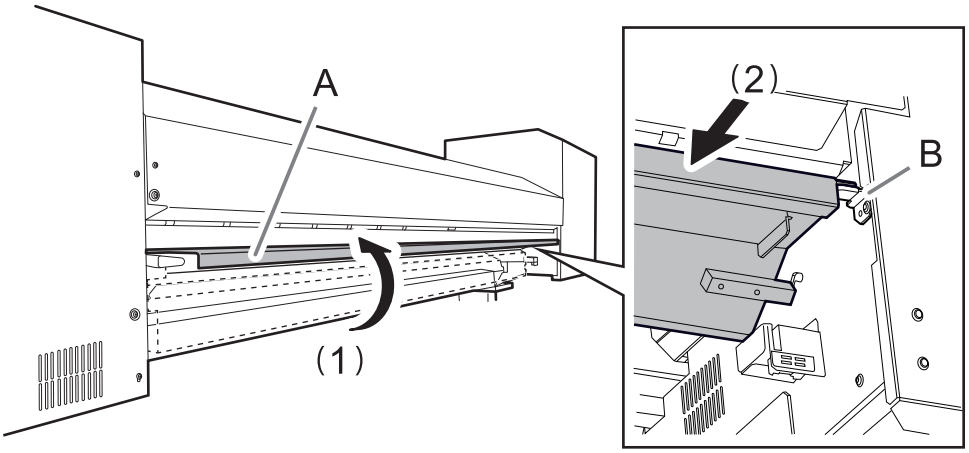
5. **Move the media clamps to the outside of the grit rollers on the left and right edges respectively.**



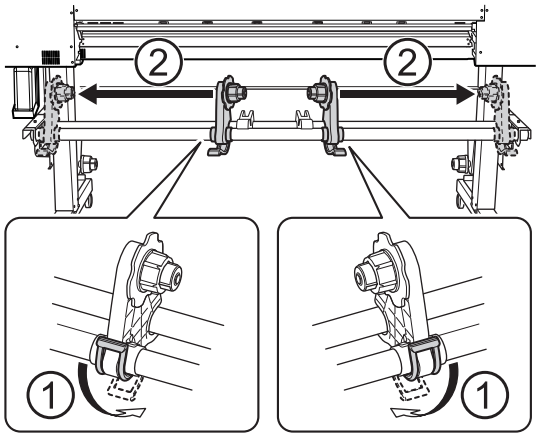
6. **Move to the rear of the printer and open the rear UV shield.**

(1) **Open the rear UV shield (A).**

(2) **Push the rear UV shield to the front of the machine, and then place this shield on the left and right stoppers (B).**



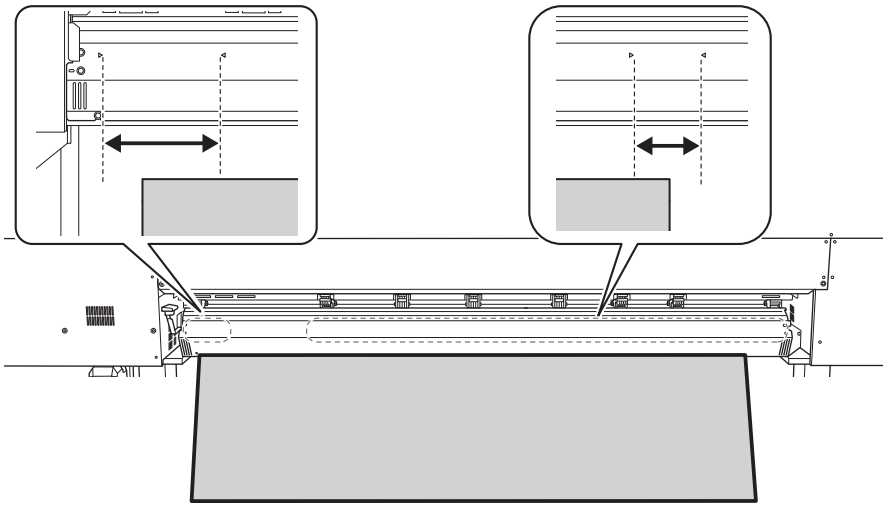
7. **Move the media holders to the outside.**



8. **Determine the left and right positions of the media with the grit patterns used as the reference.**

Note the following points when determining the positions.

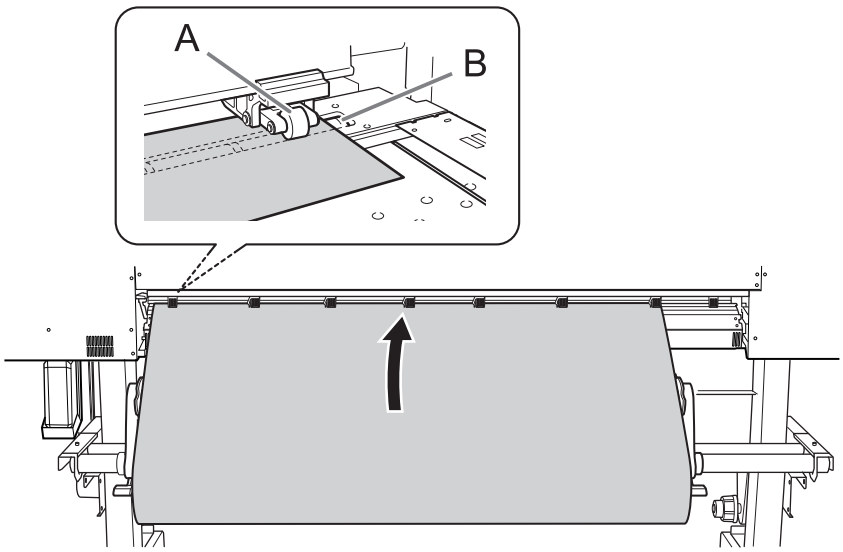
- Ensure that the left edge of the media is positioned so that it is within the range of the grit pattern of the left edge.
- Ensure that the right edge of the media is positioned so that it is within the range of one of the grit patterns.



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

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

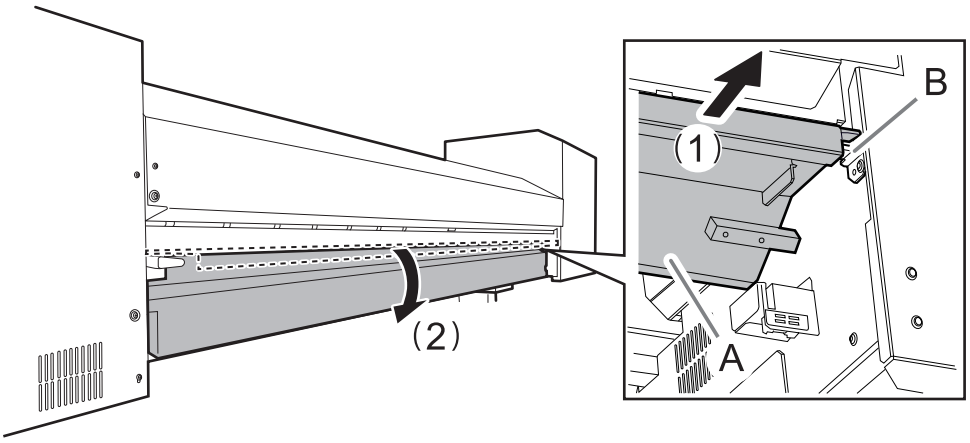
When loading the media from the front of the printer, feed the leading edge of the media (the side where printing will start) over the platen, and then pull the media to the front to activate the suction fan.



10. **Close the rear UV shield.**

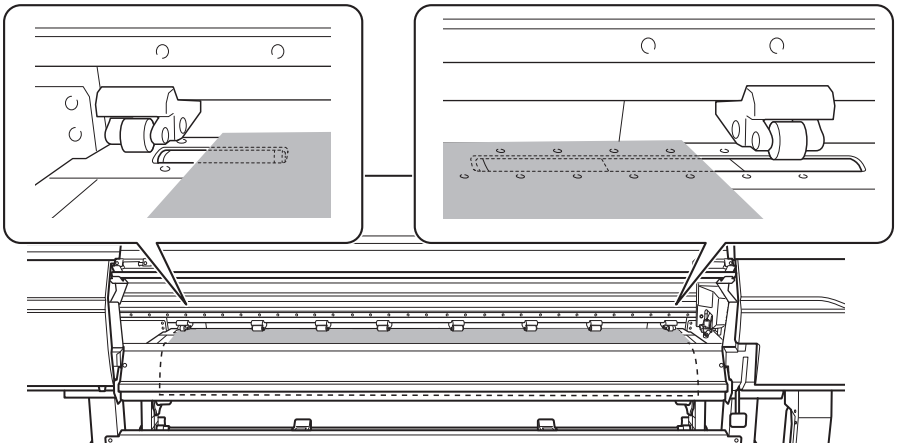
(1) **Pull the rear UV shield (A) to the back of the machine, and then remove this shield from the left and right stoppers (B).**

(2) **Close the rear UV shield.**



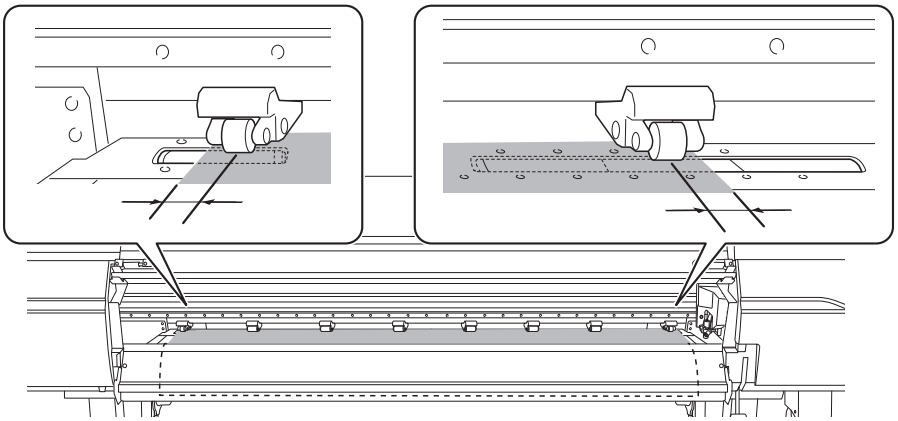
11. **(Move to the front of the printer.) Make sure both edges of the media are above the grit rollers.**

Be sure to place the right edge of the media on the right-end grit roller.



12. **Move the left and right pinch rollers, placing them on both edges of the media.**

Position them approximately 10 mm (0.39 in.) from each edge of the media.



IMPORTANT

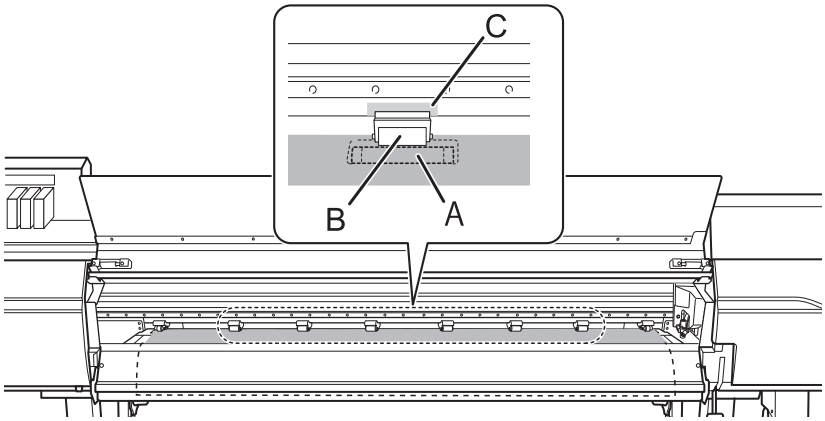
- Be sure to use the left and right pinch rollers. The force with which the media is pinched varies between the middle pinch rollers and the left and right pinch rollers. Using the middle pinch rollers to pinch the media edges will lead to unstable media feeding.
- If you want to readjust the media position before securing it in place, redo the procedure from step 7.

MEMO

To smoothly move the pinch rollers, push down close to the rail.

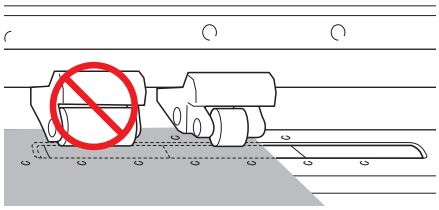
13. **Move the middle pinch rollers (B) over all the remaining grit rollers (A) covered by the media.**

There are grit patterns (C) wherever there are grit rollers.

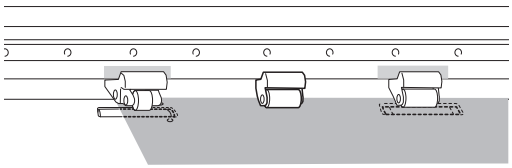


IMPORTANT

- Place the middle pinch rollers over all the grit patterns within the media width. If you have forgotten to place the middle pinch rollers, the media will be skewed during printing or will come loose, which will have an effect on the printing quality.
- The middle pinch roller will not lower onto the three grit rollers from the right end. Place the middle pinch roller on a grit roller other than these three.

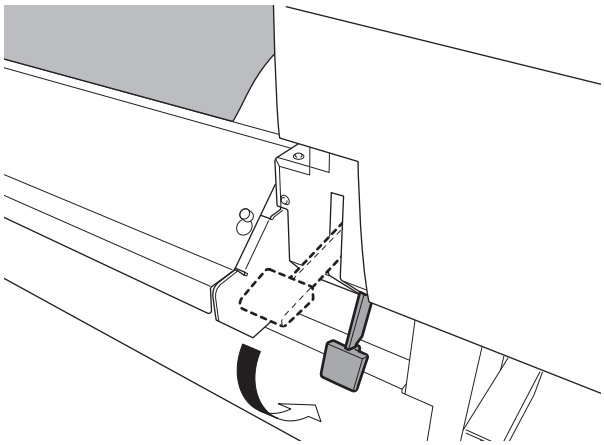


- There may be extra middle pinch rollers depending on the width of the media being used. Move the extra middle pinch rollers to positions where no grit patterns are present. Where no grit patterns are present, the middle pinch rollers will not come down.



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

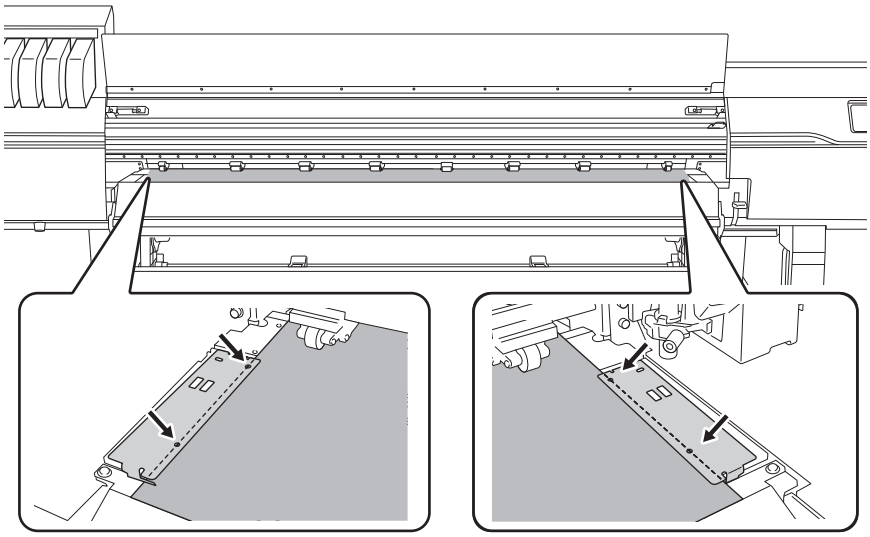
The media is held in place.



IMPORTANT

If you want to readjust the media position before securing it in place, redo the procedure from step 7.

15. **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 set up media.
If you load the media clamps directly before printing after the media setup is complete, the machine may print on the media clamps.

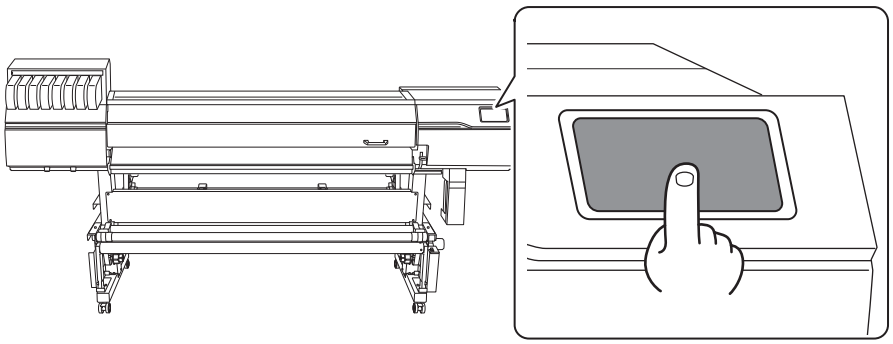
16. **Close the front cover.**

1. B: Determining the Positions of Media (If [Media Edge Detection]: [Disable])

Use the following procedure to determine the positions of the media when using transparent media or media with high reflectance whose edges cannot be detected, and when [**Preferences**]>[**Media Edge Detection**] is set to [**Disable**].

Procedure

1. **Tap the operation panel.**



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

The machine sub power is switched on.

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

(1) **Tap** ☰.

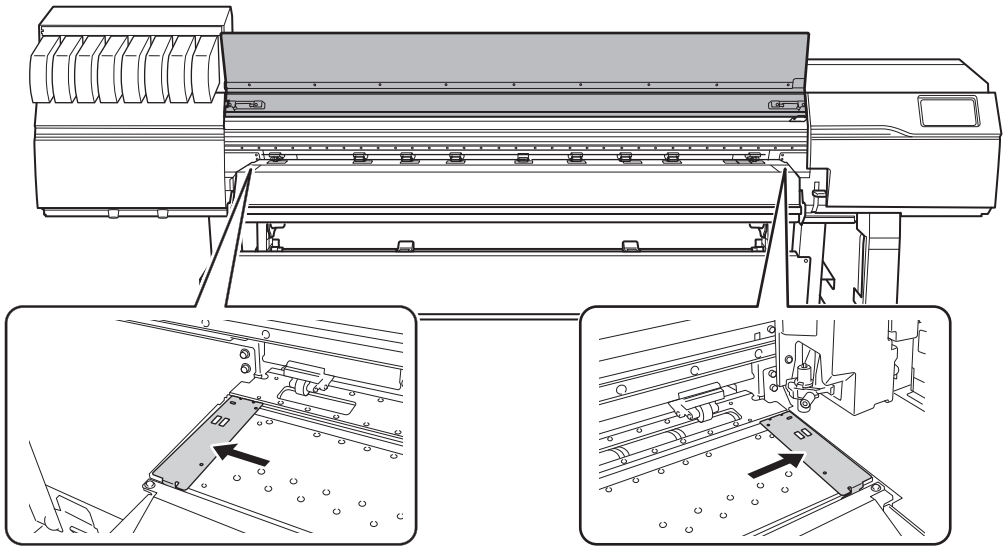
(2) **Tap [Preferences]>[Skewing Correction Support at Setup].**

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

(4) **Press** ⌂ **to return to the home screen.**

4. **Open the front cover.**

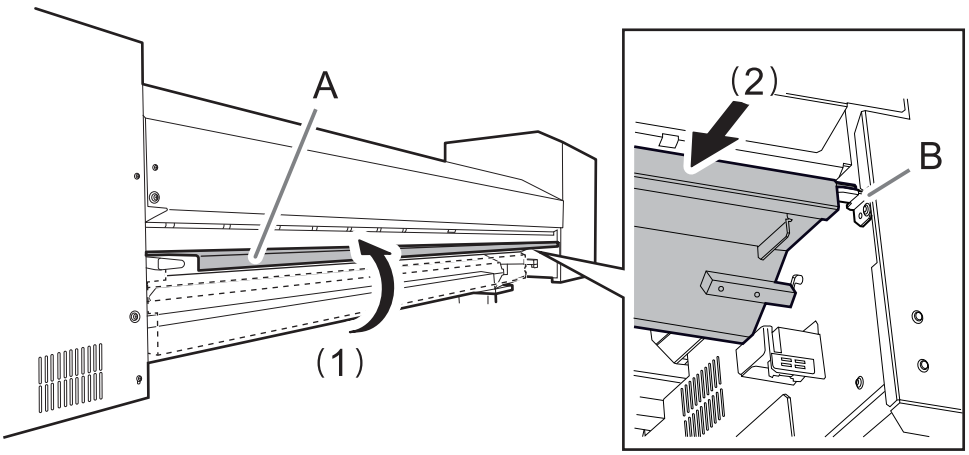
5. **Move the media clamps to the outside of the grit rollers on the left and right edges respectively.**



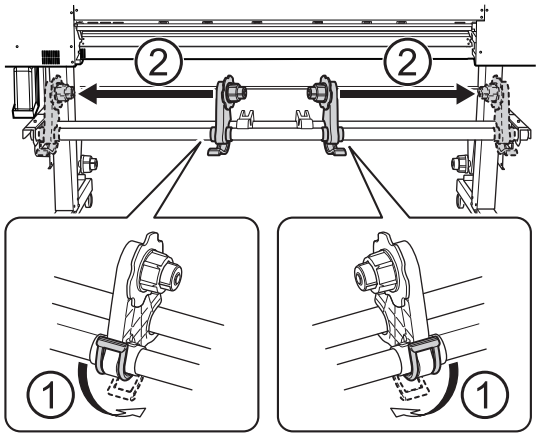
6. **Move to the rear of the printer and open the rear UV shield.**

(1) **Open the rear UV shield (A).**

(2) **Push the rear UV shield to the front of the machine, and then place this shield on the left and right stoppers (B).**



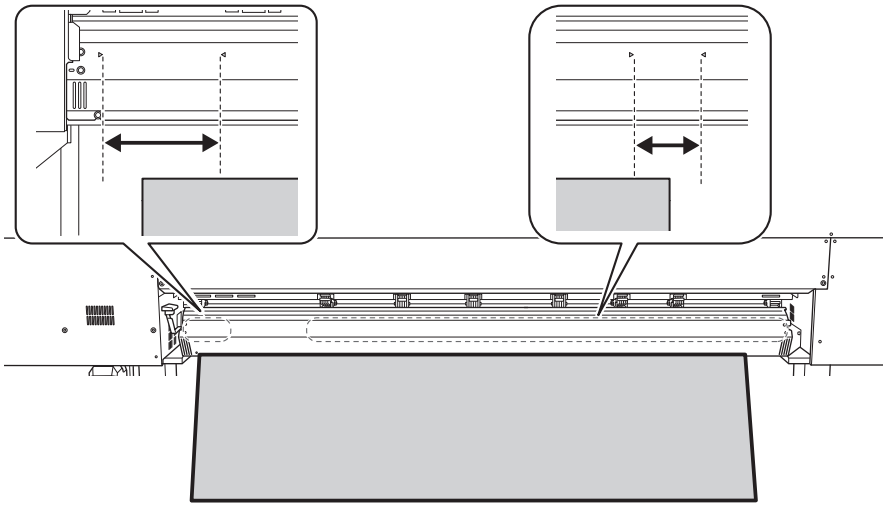
7. **Move the media holders to the outside.**



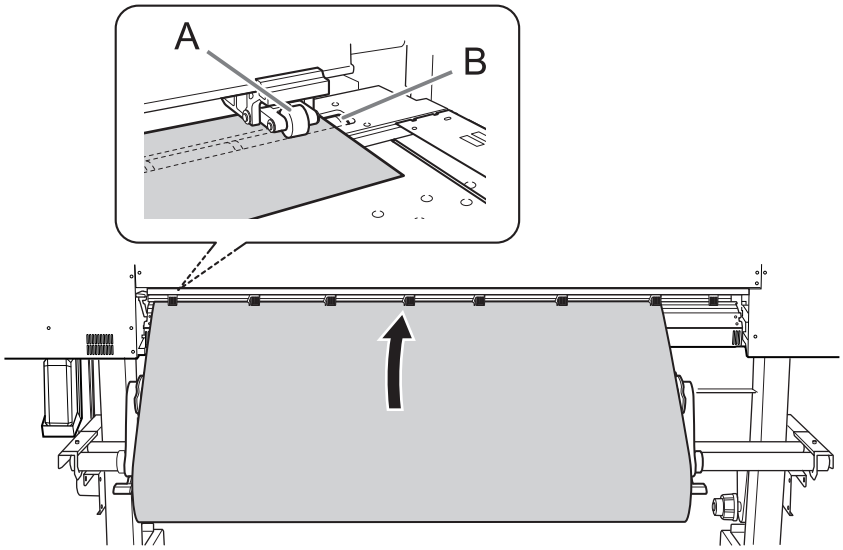
8. **Determine the left and right positions of the media with the grit patterns used as the reference.**

Note the following points when determining the positions.

- Ensure that the left edge of the media is positioned so that it is within the range of the grit pattern of the left edge.
- Ensure that the right edge of the media is positioned so that it is within the range of one of the grit patterns.

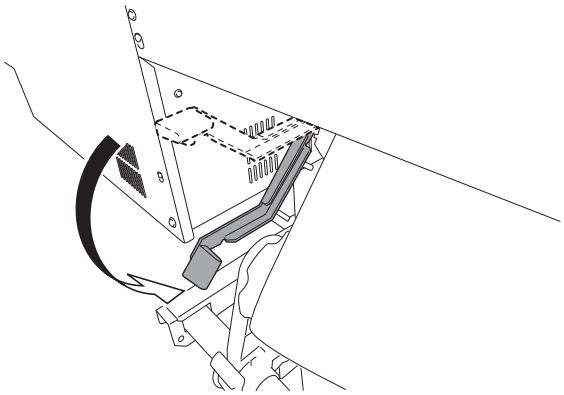


9. **Pass the leading edge of the media between the pinch rollers (A) and the grit rollers (B).**



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

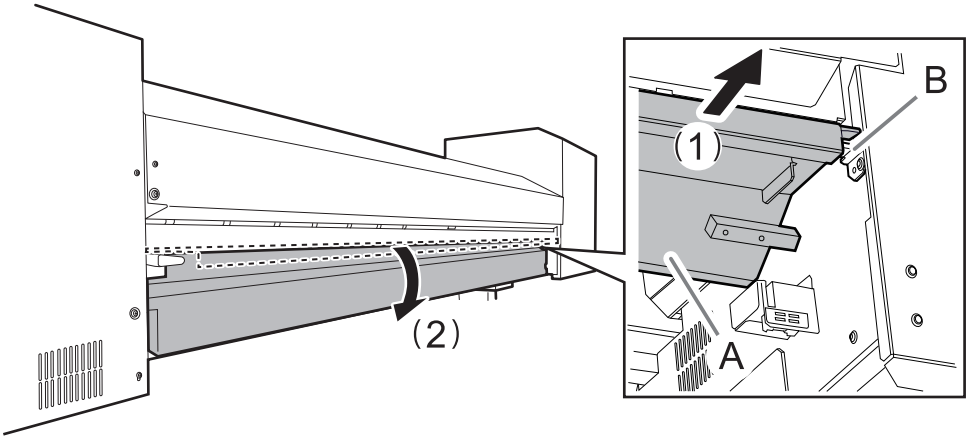
The media is held in place.



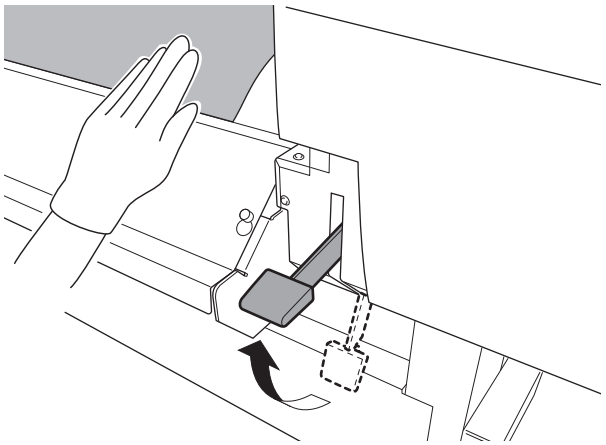
11. **Close the rear UV shield.**

(1) **Pull the rear UV shield (A) to the back of the machine, and then remove this shield from the left and right stoppers (B).**

(2) **Close the rear UV shield.**

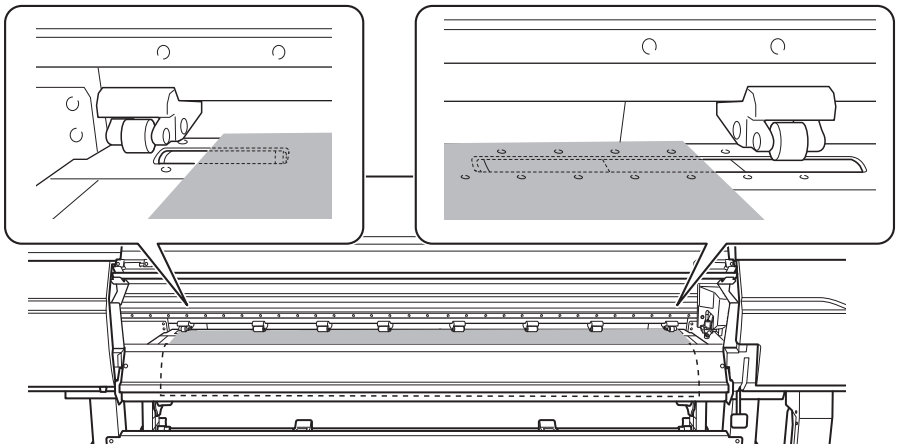


12. **(Move to the front of the printer.) Gently hold down the media and raise the loading lever (front).**



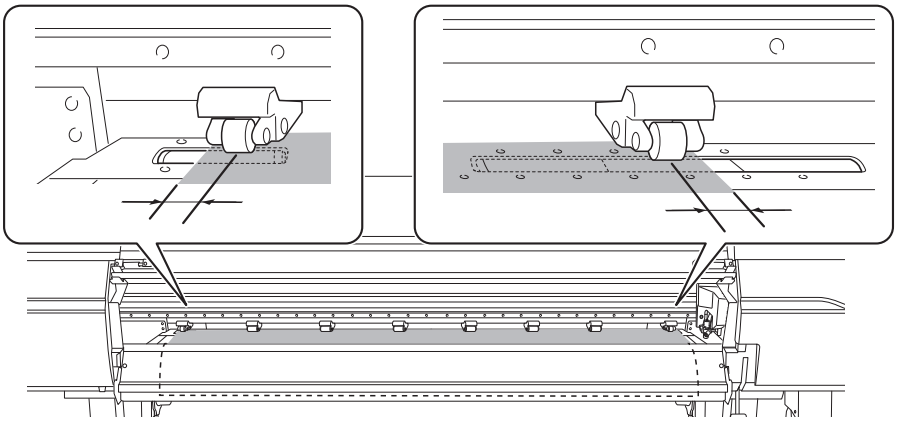
13. **Make sure both edges of the media are above the grit rollers.**

Be sure to place the right edge of the media on the right-end grit roller.



14. **Move the left and right pinch rollers, placing them on both edges of the media.**

Position them approximately 10 mm (0.39 in.) from each edge of the media.



IMPORTANT

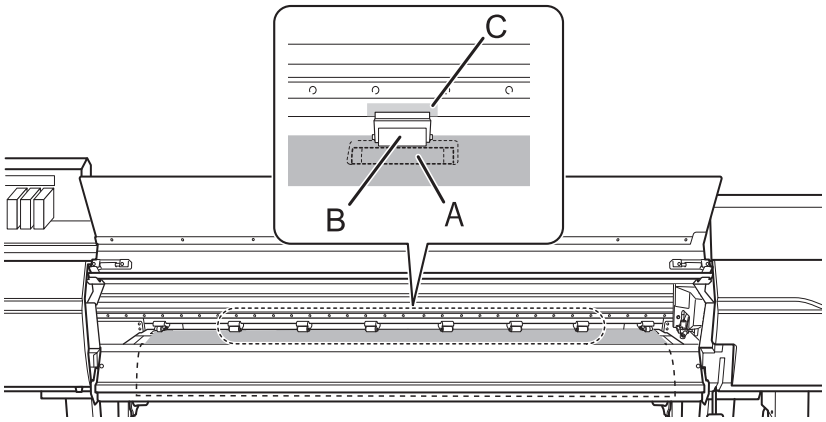
Be sure to use the left and right pinch rollers. The force with which the media is pinched varies between the middle pinch rollers and the left and right pinch rollers. Using the middle pinch rollers to pinch the media edges will lead to unstable media feeding.

MEMO

To smoothly move the pinch rollers, push down close to the rail.

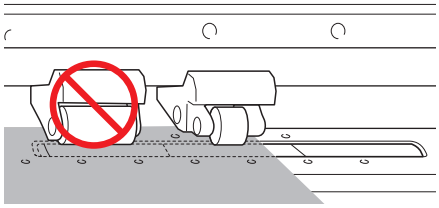
15. Move the middle pinch rollers (B) over all the remaining grit rollers (A) covered by the media.

There are grit patterns (C) wherever there are grit rollers.

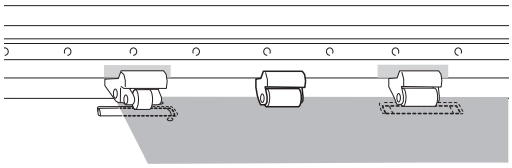


IMPORTANT

- Place the middle pinch rollers over all the grit patterns within the media width. If you have forgotten to place the middle pinch rollers, the media will be skewed during printing or will come loose, which will have an effect on the printing quality.
- The middle pinch roller will not lower onto the three grit rollers from the right end. Place the middle pinch roller on a grit roller other than these three.

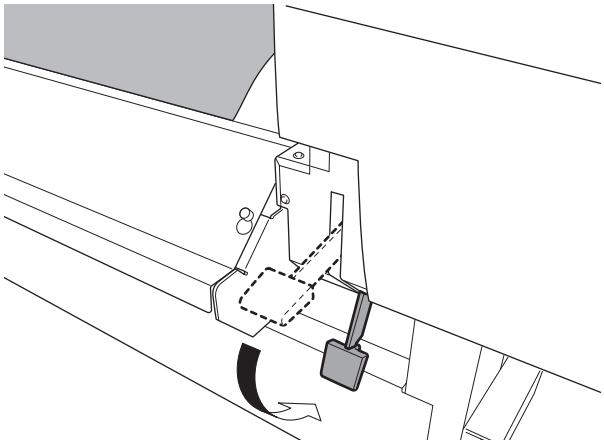


- There may be extra middle pinch rollers depending on the width of the media being used. Move the extra middle pinch rollers to positions where no grit patterns are present. Where no grit patterns are present, the middle pinch rollers will not come down.



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

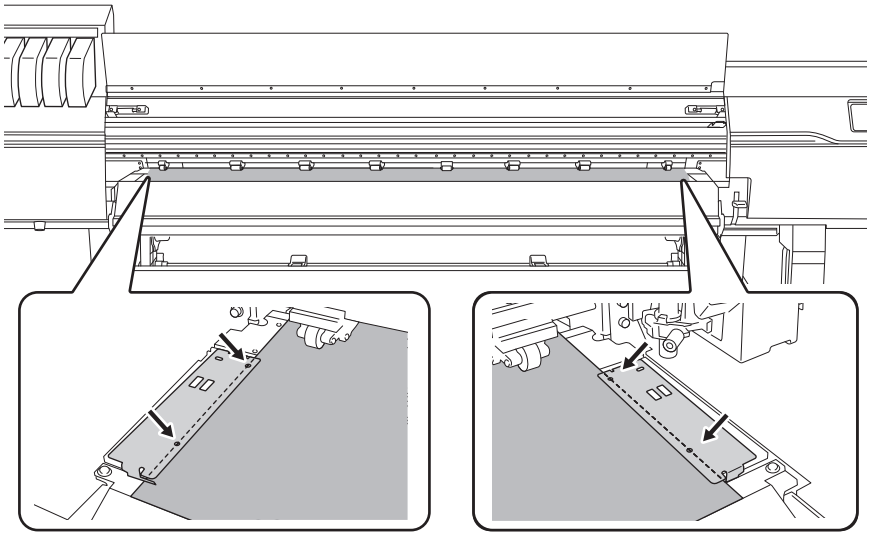
The media is held in place.



IMPORTANT

If you want to readjust the media position before securing it in place, redo the procedure from step 11.

17. **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 set up media.

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

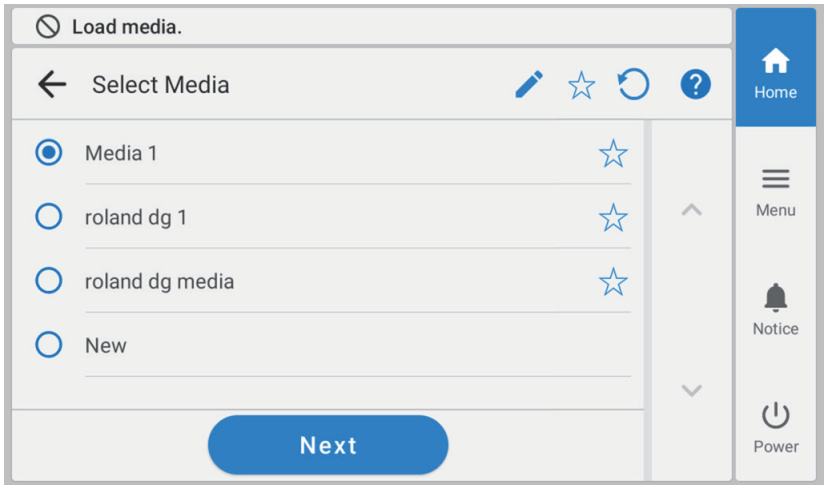
18. **Close the front cover.**

2. Selecting the Media

Procedure

1. **Tap [Setup].**

The registered media is displayed in a list.

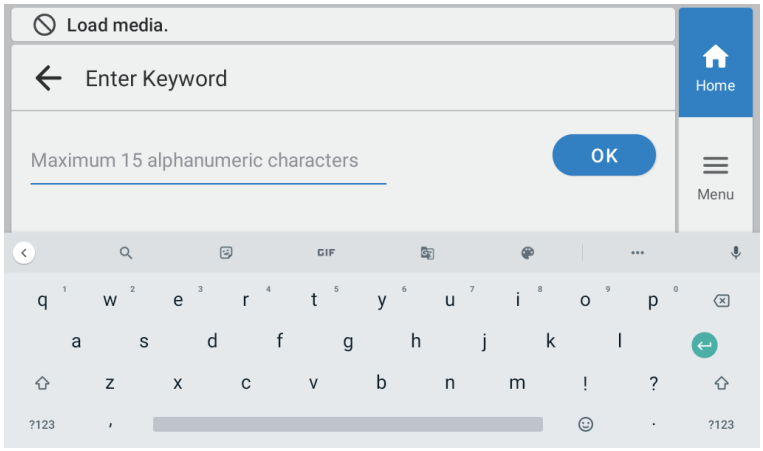


2. **Select the media name to use.**

MEMO

You can search for media in the media list by keyword and register media as favorites. The media list can also be set to show only media registered as favorites. Keyword searching and favorites registration can be used at the same time.

- **Searching for keywords in the media list**
  1. Tap .
  2. Enter the media to search for.
     Searching for partial matches instead of exact matches is also possible.



  3. Tap [OK].
     Media filtered according to the keywords will be displayed.
  4. Select the media to use from the search results.
- **Registering media to favorites and showing only media registered as favorites**

  Tap ☆ for the media to register it to favorites.

  The icon for the favorited media will be displayed as ★.

To show only media registered as favorites, tap the icon indicated below.



To reset the keyword search or favorites registration, tap .

When using both the keyword search and favorites registration, each function can also be reset individually.

To reset the keyword search, tap to delete the keyword.

To reset the favorites registration, tap for the media you want to reset.

3. **Tap [Next].**

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

5. **Tap [Start Setup].**

The cutting carriage moves and detects the width of the media and the positions of the media clamps. This operation is called initialization.

6. **When [The media could not be detected automatically. Manually set the printing area.] screen appears, use the following procedure to configure the settings.**

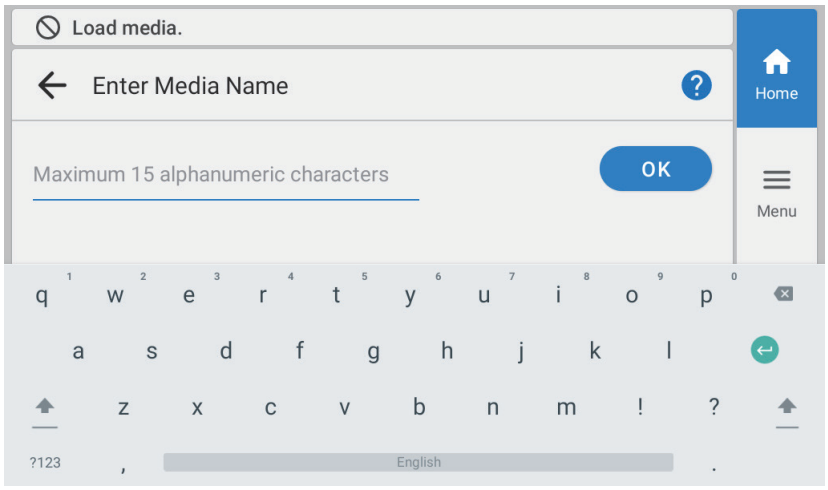
It may not be possible to detect the media width with highly reflective media. Manually set the media width.

MEMO

If automatic media detection is not possible and the printing area is set manually when new media is registered, the screen automatically changes to the [**Printing Area Settings**] screen in Step (3).

(1) **Tap [OK].**

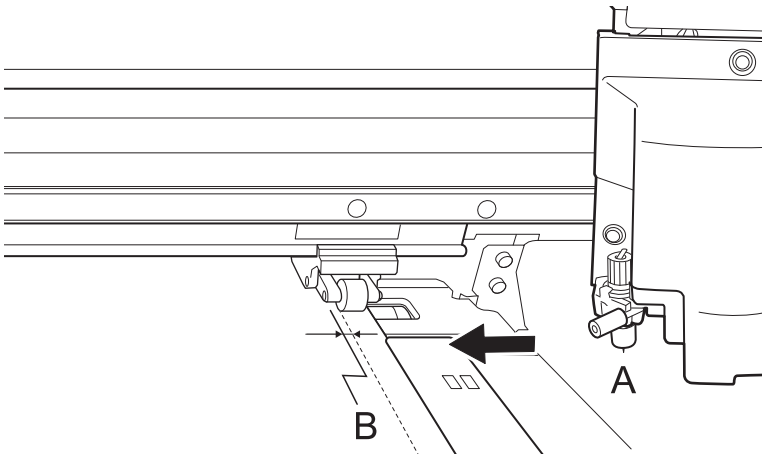
(2) **Enter a new media name and tap [OK].**



(3) **Tap [Change] on the [Printing Area Settings] screen.**

The **[Set the right edge of the printing area within the area specified by the pinch rollers.]** screen appears.

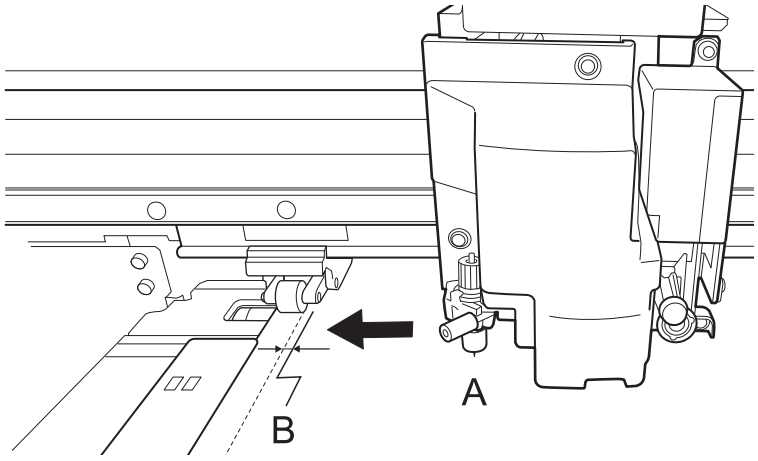
(4) **Hold down ‹ or › to move the center of the blade (A) approximately 2 mm (0.08 in.) to the inside (B) from the left edge of the right pinch roller.**



(5) **Tap [OK].**

The **[Set the left edge of the printing area within the area specified by the pinch rollers.]** screen appears.

(6) **Hold down ‹ or › to move the center of the blade (A) approximately 2 mm (0.08 in.) to the inside (B) from the right edge of the left pinch roller.**



(7) **Tap [OK].**

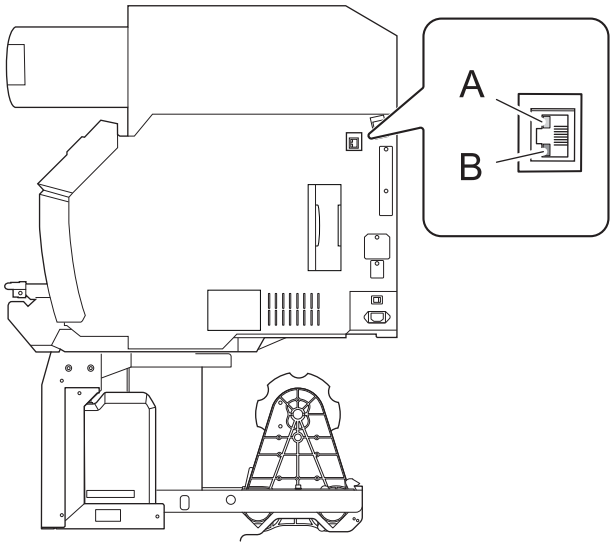
The set left and right positions are applied to the [**Printing Area (Width)**].

(8) **Tap [OK].**

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 lights up or 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.

Preventing Sedimentation in Inks

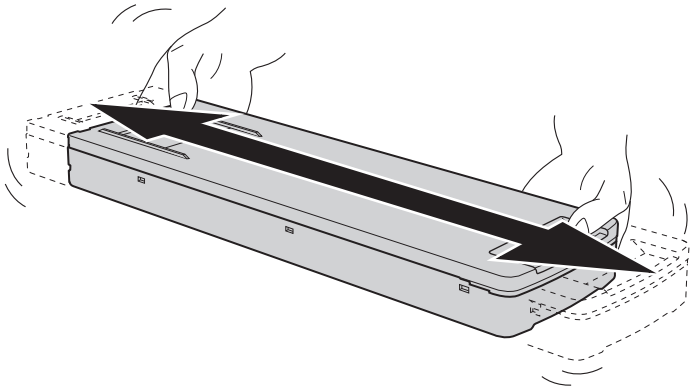
The precipitation of the ingredients in the ink disables printing in normal color. So that the ink mixes well, shake the ink cartridge horizontally with a stroke length of around 5 cm (1.97 in.) from each end of the ink cartridge.

Shake the ink cartridges:

- All inks: When replacing an ink cartridge with a new one.
- White ink: Each day (before starting the day's operations).

  Remove the white ink cartridge, shake it 50 times (about 20 seconds), and then reinsert this cartridge.

  The ingredients in white ink tend to settle. Each day, before starting the day's operations, be sure to shake this cartridge. Allowing the ink to stand can cause the settled material to harden, resulting in malfunctions or other problems.



IMPORTANT

- **The ingredients in white ink tend to settle.**
  Allowing the ink to stand without shaking it can cause the settled material to harden, resulting in malfunction or other problems.
- **Before shaking the ink cartridge, wipe off any ink from around its mouth.**
  If you do not wipe off the ink, it may splatter when you shake the ink cartridge.
- **When you have finished mixing the ink, reattach the ink cartridge immediately.**
  Taking time to reattach the ink cartridge will adversely affect the ink path.
- **Firmly hold the ink cartridge with both hands when shaking it.**
  When shaking the ink cartridge, firmly hold it with both hands to prevent the ink cartridge cover from coming loose. The cover or ink pouch coming loose and falling may cause damage or printer malfunctions.
- **Shake the white ink cartridge once a week.**
  Even if you are not using the printer, shake the white ink cartridge 50 times (about 20 seconds) once a week.

MEMO

To prevent ink precipitation, you can make the machine periodically display a message prompting you to mix the ink.
P. 253 Showing/Hiding Notifications

Pausing and Canceling Output

You can pause and cancel output before it finishes.

Pausing and Resuming Output

IMPORTANT

We do not recommend resuming printing because horizontal bands may be produced at the place where printing was paused.

Procedure

1. **If you are performing menu operations, tap .**
   You are returned to the home screen.
2. **During output, tap [Pause].**
   This pauses the printing operation.
3. **Tap [Resume].**
   The printing operation resumes.

Canceling Output

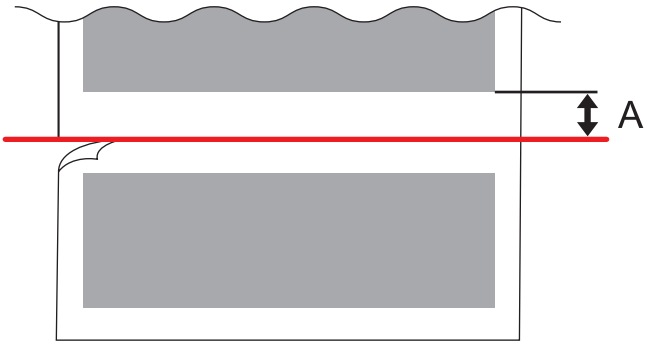
Procedure

1. **During output, tap [Pause].**
   This pauses the printing operation.
2. **Tap [Cancel Output].**
   Output is canceled.
3. **Stop sending the output data from the computer.**

Separating the Media

After printing, use [**Sheet Cutting**] or [**Perforated Sheet Cutting**] to separate the media.

You can use [**Margin After Sheet Cutting**] to set the margin (A) from the location where sheet cutting is performed to the next printing-start position. You can set the margin between 35 and 75 mm (1.38 and 2.95 in.). The margin is 75 mm (2.95 in.) in the default settings.



IMPORTANT

- Reducing the margin may result in the front of the media becoming loose and coming into contact with and possibly damaging the print heads. Be cautious when changing the margin.
- It may not be possible to separate some types of media. Some types of media may remain on the platen after separation. If the media remains on the platen, remove it by hand.
- If you are using the take-up unit, do not operate the manual switch on the take-up unit leaving the loading lever lowered. Tension is applied to the media by the take-up unit, so avoid operations that pull the media with excessive force.

MEMO

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

Procedure

1. Close the front cover.

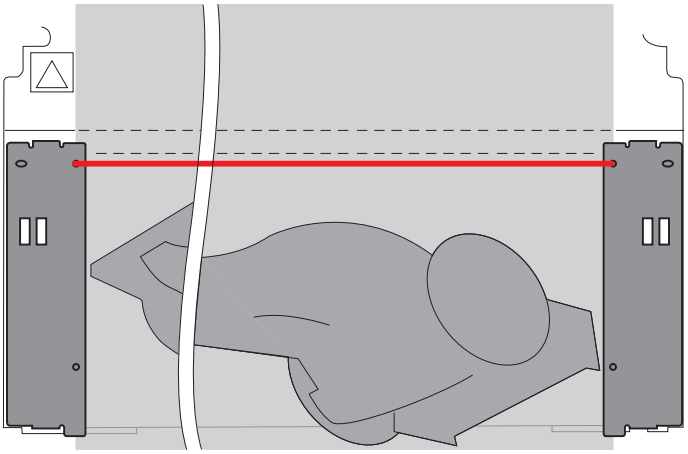
2. If necessary, use the following procedure to set the separation position.

(1) **Tap** .

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

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

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



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

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

MEMO

The [**Base**] icon (Base) is added to the home screen to indicate that the base point position has been set.

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

4. **Set the margin after media separation as necessary.**

(1) **Tap [Margin After Sheet Cutting].**

(2) **Tap + or − to set the margin.**

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

(4) **Tap ←.**

The screen returns to the sheet cutting screen.

5. **Select the sheet cutting method.**

- **[Sheet Cutting]**

  This separates the media. Media setup will be canceled.
- **[Perforated Sheet Cutting]**

  The media is perforated without being separated. Media setup will not be canceled.

MEMO

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

6. **Tap [Execute].**

The media is separated.

- Some RIP software can be set to automatically separate the media after output has finished. For information on how to configure the settings, refer to the manual for the RIP software you are using.

- When using a take-up unit, take-up may be interrupted by media separation. Use VersaWorks to set the [Cut Sheet after Output] setting to [Perforated Sheet Cutting], ensuring that media is not separated.

Removing Media from the Take-up Unit

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

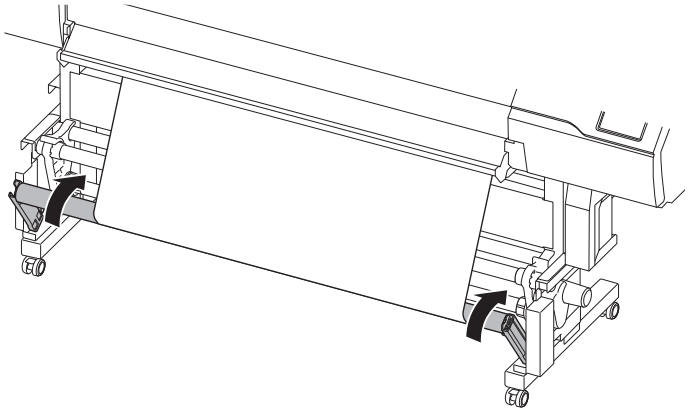
⚠ WARNING

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

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

Procedure

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

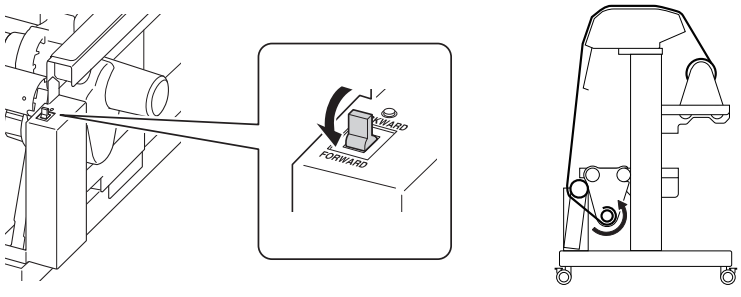


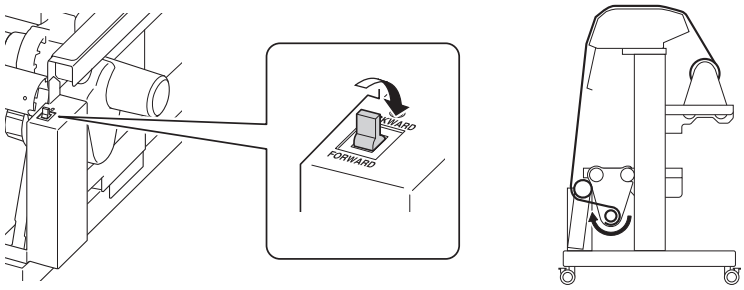
2. **Close the front cover.**

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

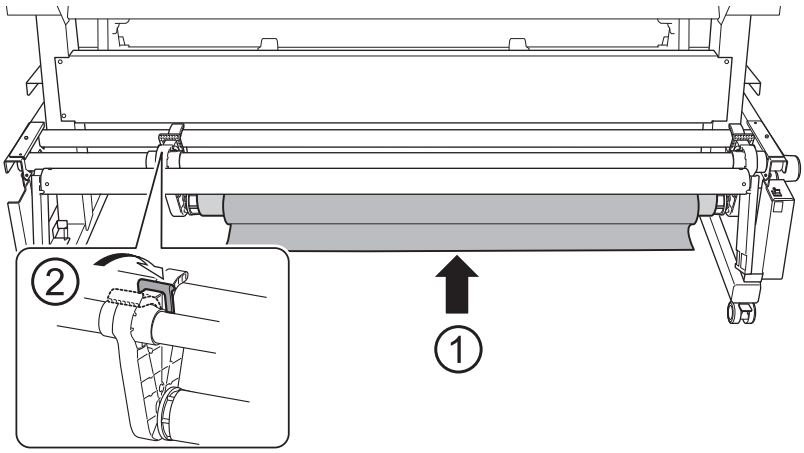
   For more information on sheet cutting, refer to Separating the Media(P. 122).

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

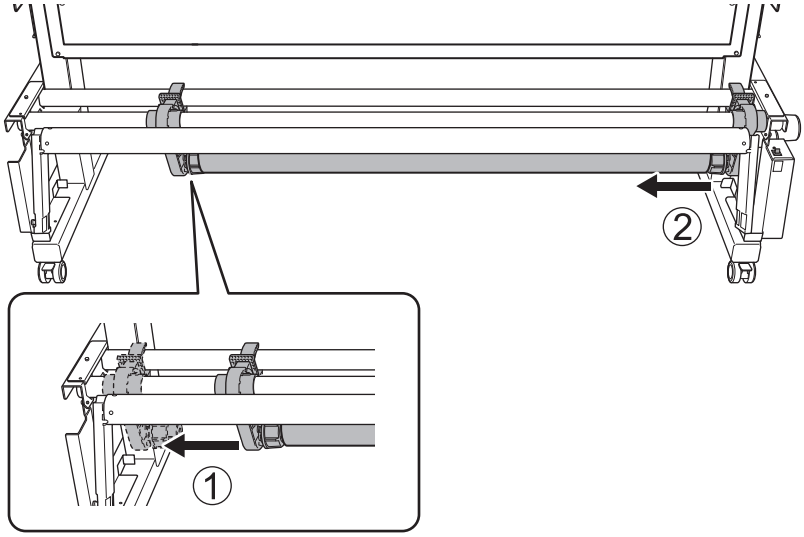
When using the FORWARD setting	Take up the media with [**FORWARD**]. 

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

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



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



Replacing Ink

Timing of Ink Replacement

When a small amount of ink remains in an ink cartridge

is displayed next to the corresponding ink on the home screen. It is also displayed if the shelf life is about to expire or has expired.

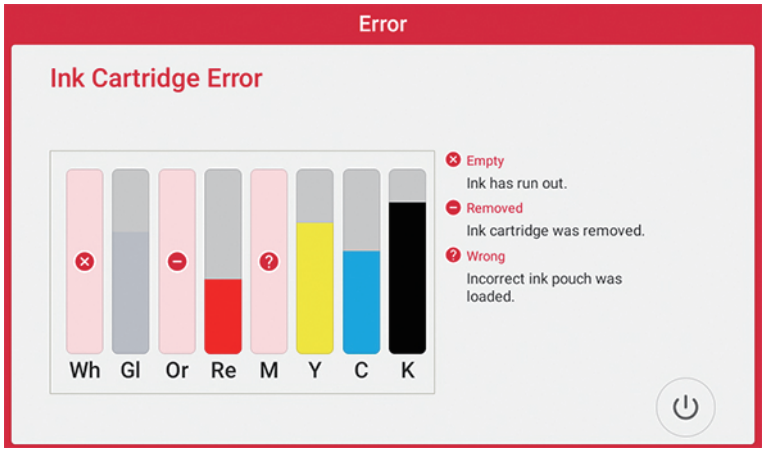
Prepare a new ink cartridge. Alternatively, we recommend replacing ink in advance as needed, using VersaWorks' ink usage amounts as a reference.

IMPORTANT

To prevent the ink from hardening, place any partially used ink pouches that have been removed back into their original packing boxes, and store them away from UV light.

When an ink cartridge runs out

The message [**Ink Cartridge Error**] appears, and is displayed next to the empty ink cartridge.



IMPORTANT

- When an ink cartridge runs out during printing, printing pauses and a warning beep sounds.
  Refer to the screen display on the operation panel, pull out the empty cartridges, and insert new ones. Printing resumes.
- Never reuse a pouch within 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 pouch, but nevertheless do not reuse it. Such an ink pouch is in a state where drawing ink from it is impossible. Using it in such a state may force air into the ink path and cause printer malfunctions.
- If an ink cartridge runs out of ink during cleaning, replace the cartridge immediately.
  If a certain amount of time passes with [**Ink Cartridge Error**] displayed, cleaning will be stopped. Refer to [Pump Stop Error] (P. 360) and resume cleaning.

Replacing Ink

⚠ WARNING

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

- Any location exposed to open flame
- 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

Fire may be a danger. Accidental ingestion by children may pose a health hazard.

IMPORTANT

Precautions regarding ink pouch replacement

- Be sure to replace each pouch with an item of identical type and color.
- Never use an ink cartridge that has already been used in another machine even if it is an identical type.
- Never mix different types of items.
- Never leave the machine with an ink cartridge removed. The print heads may become clogged.
- Do not remove or insert ink cartridges during printing, cleaning, or ink circulation. Ink may leak.
- If the cover of an ink cartridge does not lock securely, this cartridge needs to be replaced.

  For information about purchasing ink cartridges, contact your authorized dealer or visit our website (https://www.rolanddg.com/).

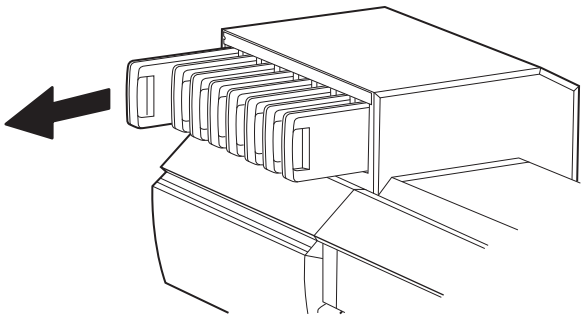
IMPORTANT

Never reuse an ink pouch within 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 pouch. Such an ink pouch is in a state where drawing ink from it is impossible. Do not use these ink pouches because doing so may force air into the ink path and cause printer malfunctions.

Procedure

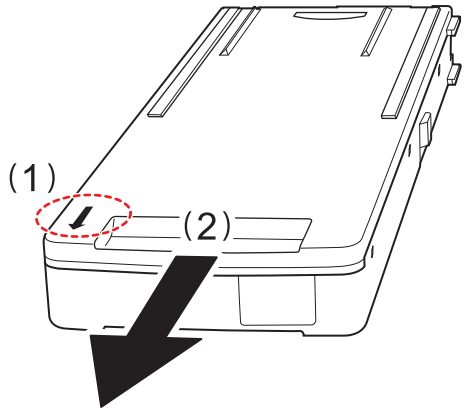
1. Pull out from the machine the ink cartridge of the color to replace.



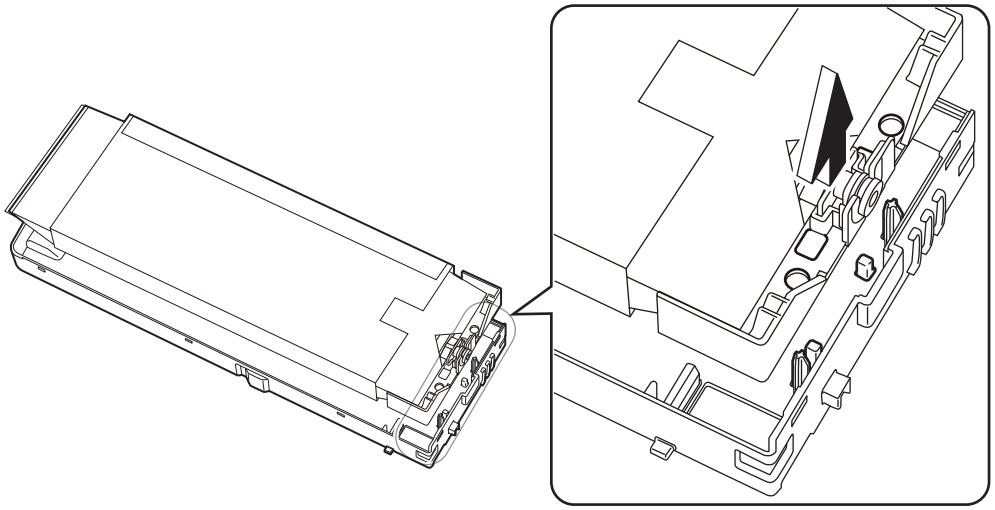
2. Remove the cover of the cartridge.

(1) **Keep the side with the arrow mark face up.**

(2) **Remove the cover by sliding it in the direction indicated by the arrow.**



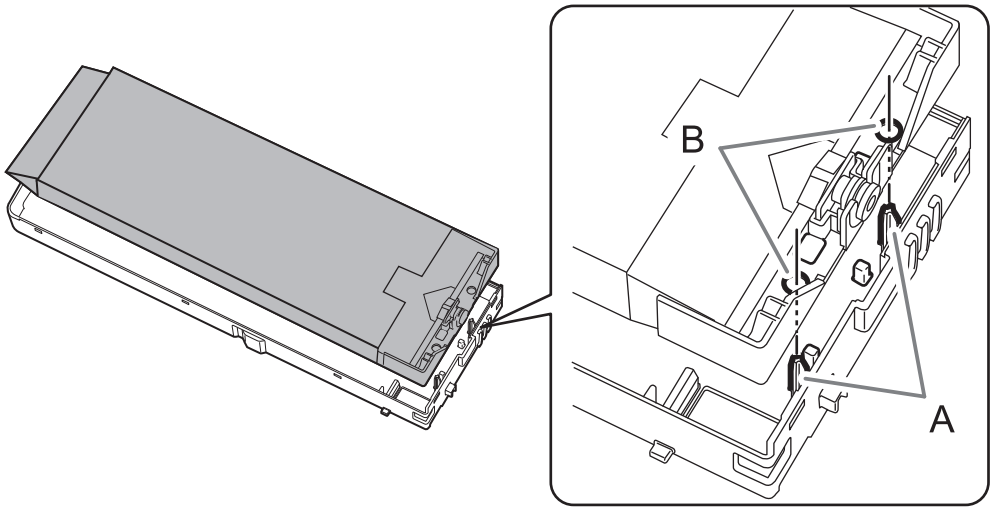
3. **Remove the used ink pouch from the cartridge case.**



4. **Load a new ink pouch in the cartridge case.**

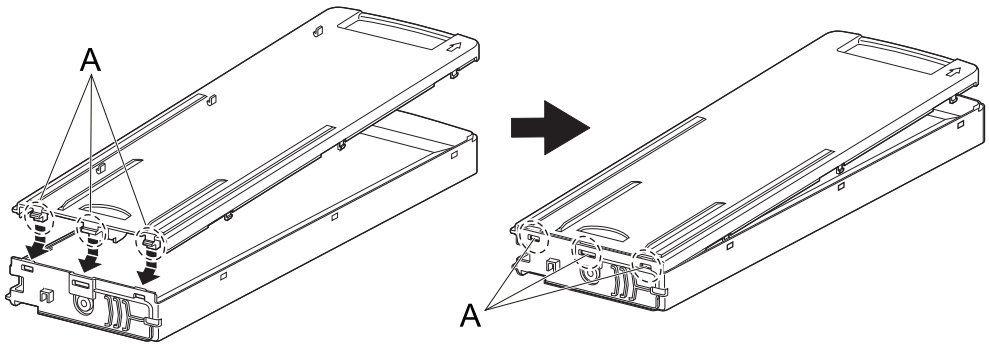
MEMO

Pass the protrusions (A) on the cartridge case through the holes (B) on the ink pouch to load it in the correct position.



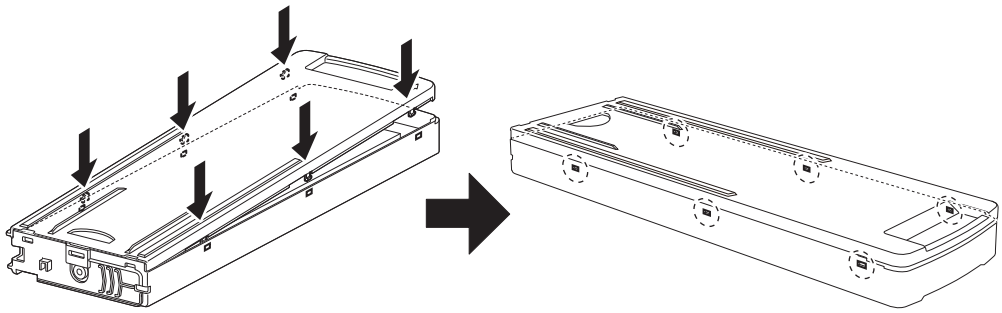
5. **Attach the cover to the cartridge case.**

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.

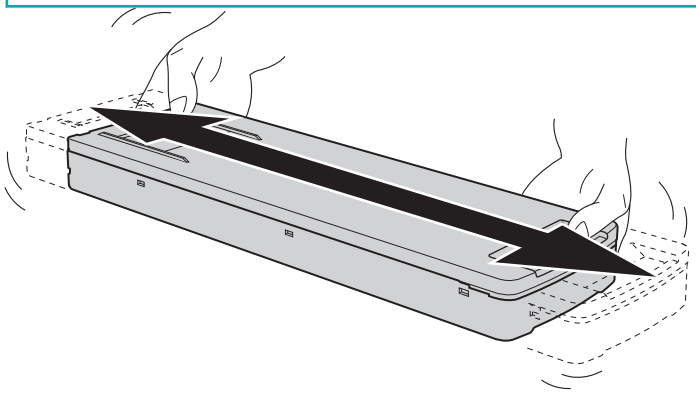


6. Gently shake the ink cartridge.

Shake the ink cartridge 50 times (for approximately 20 seconds) horizontally with a stroke length of 5 cm (1.97 in.) from each end of the cartridge.

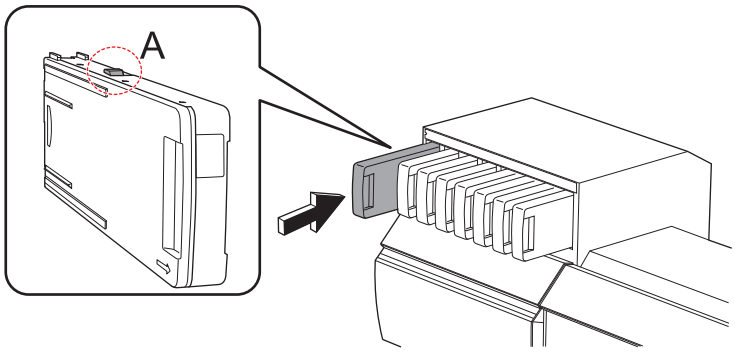
IMPORTANT

When shaking the ink cartridge, firmly hold it with both hands to prevent the ink cartridge cover from coming loose. The cover or ink pouch coming loose and falling may cause damage or printer malfunctions.



7. Insert the ink cartridge in the ink slot.

Orient the cartridge so its protrusion (A) is face up, and then, while keeping the cartridge level, insert the cartridge as far as it will go.



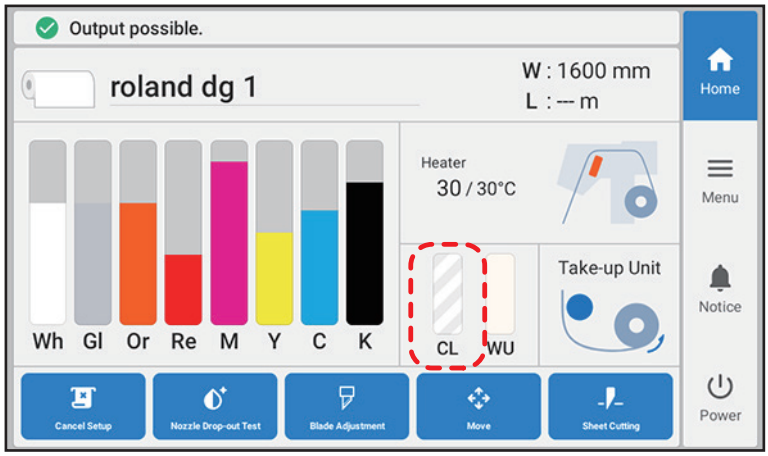
IMPORTANT

- If an ink cartridge contains an empty ink pouch, do not insert this cartridge into its ink slot. Doing so may force air into the ink path and cause printer malfunctions.
- Check the color names indicated on the ink slots and the ink cartridges to load these cartridges in their correct positions.

Cleaning Liquid Pouch Replacement

Cleaning Liquid Pouch Replacement Timing

You can check the remaining amount of cleaning liquid from the [**CL**] bar on the home screen.



The icons displayed in the bar are shown below.

- : The amount of cleaning liquid remaining is low.
- : The cleaning liquid has run out.
- : The cleaning liquid cartridge has been pulled out.

If is displayed, replace the cleaning liquid pouch.

Replacing the Cleaning Liquid Pouch

⚠ WARNING

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

- Any location exposed to open flame
- 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

Fire may be a danger. Accidental ingestion by children may pose a health hazard.

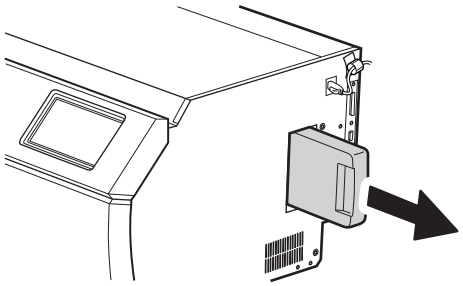
IMPORTANT

Precautions regarding cleaning liquid pouch replacement

- Never insert or remove the cleaning liquid cartridge with undue force. Cleaning liquid may leak.
- If the cover of the cleaning liquid cartridge does not lock securely, the cleaning liquid cartridge needs to be replaced.
  For information about purchasing cleaning liquid cartridges, contact your authorized dealer or visit our website (https://www.rolanddg.com/).

Procedure

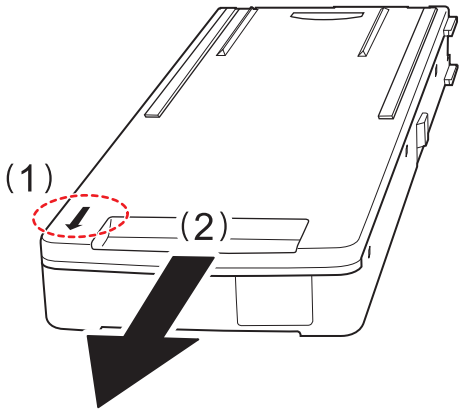
1. **Pull out the cleaning liquid cartridge from the machine.**



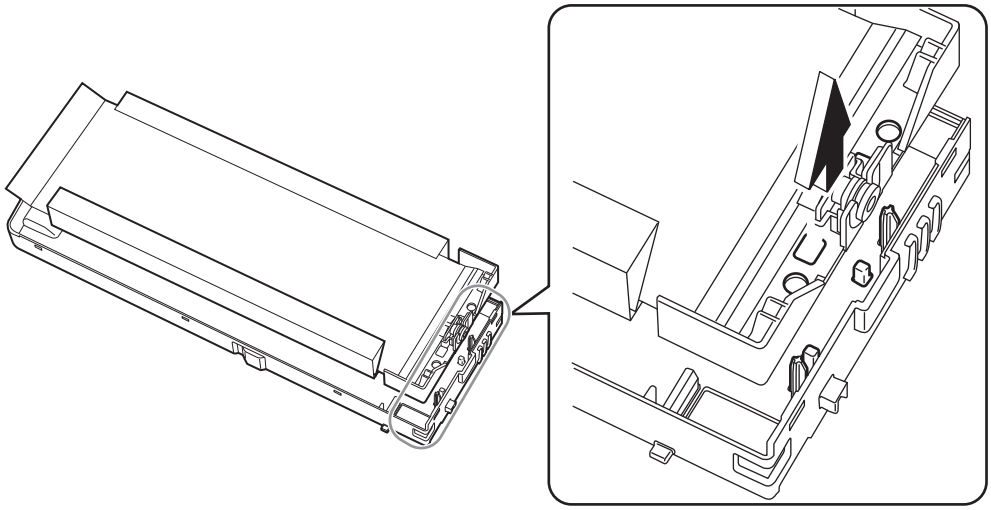
2. **Remove the cover of the cleaning liquid cartridge.**

(1) **Keep the side with the arrow mark face up.**

(2) **Remove the cover by sliding it in the direction indicated by the arrow.**



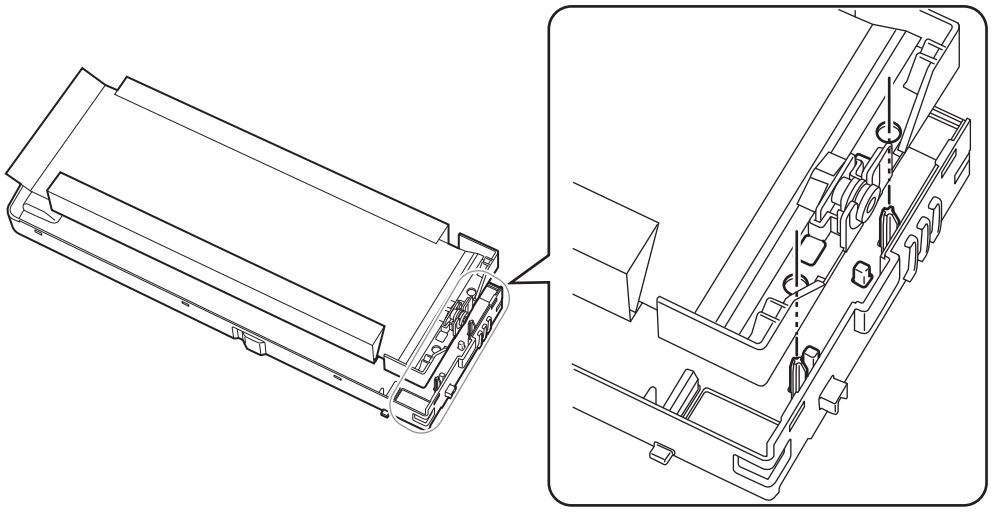
3. **Remove the used cleaning liquid pouch from the cartridge case.**



4. **Load a new cleaning liquid pouch in the cartridge case.**

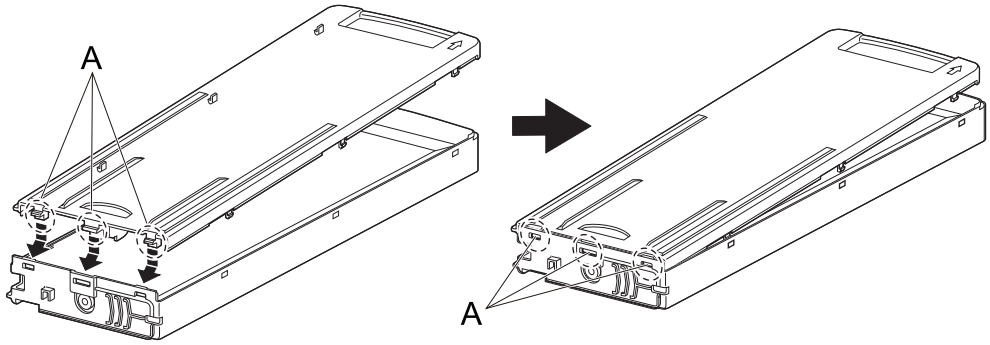
MEMO

Pass the protrusions (A) on the cartridge case through the holes (B) on the cleaning liquid pouch to load it in the correct position.



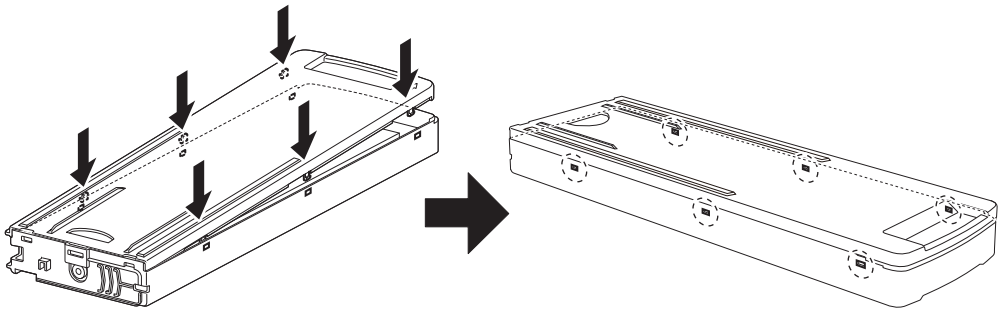
5. **Attach the cover to the cartridge case.**

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



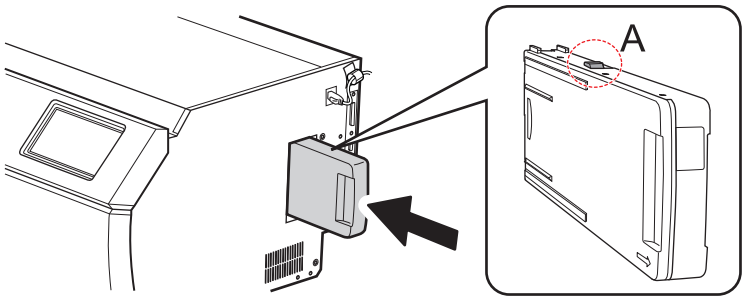
(2) **Push the cover to fit its hooks into the holes in the cartridge case.**

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. **Insert the cleaning liquid cartridge into the cleaning liquid cartridge slot.**

Orient the cartridge so its protrusion (A) is face up, and then, while keeping the cartridge level, insert the cartridge as far as it will go.



7. **Tap [Yes] when the cleaning liquid pouch replacement confirmation screen appears.**

If you tap [**Yes**] to reset the amount of cleaning liquid remaining, the cleaning liquid pouch will be identified as a new product.

MEMO

If you tap [**Yes**] on the cleaning liquid pouch replacement confirmation screen even though you have not replaced the cleaning liquid pouch, the amount of cleaning liquid remaining is reset. In this situation, no notification will appear even if the amount of cleaning liquid remaining is very small, and the message [**Replace the cleaning liquid pouch.**] will appear when the cleaning liquid runs out. To ensure you have enough time to prepare the replacement cleaning liquid, tap [**No**] if you have not replaced the cleaning liquid.

Output Method

Preparations for Output and Output Methods

Preparations before Daily Operations 138
Checking the Daily Workflow 138

Preparations before Daily Operations

Checking the Daily Workflow

This section explains the basic workflow of daily operations.

Performing appropriate maintenance at the correct times can help prevent malfunction as well as bring out the full potential of this machine.

Before the start of operations

1. Preventing Sedimentation in Inks(P. 119)
2. Turning the Power On(P. 28)
3. Step 1: Performing a Nozzle Drop-out Test(P. 140)
   - If no dot drop-out or dot displacement occurs: Start operation.
   - If dot drop-out or dot displacement occurs: Perform normal cleaning. If dot drop-out or dot displacement is not corrected after you perform normal cleaning, take action according to the information in When Normal Cleaning Is Not Effective(P. 289).

During work

If dot drop-out or dot displacement occurs during work, carry out the following procedure to try to improve the situation.

1. Step 1: Performing a Nozzle Drop-out Test(P. 140)
   - Dot drop-out and dot displacement are eliminated when you perform normal cleaning: Resume operation.
   - Dot drop-out and dot displacement are not eliminated even after performing normal cleaning: Proceed to the next step.
2. Refer to When Normal Cleaning Is Not Effective(P. 289) and perform medium cleaning/powerful cleaning.
   - Dot drop-out and dot displacement are eliminated when you perform medium cleaning/powerful cleaning: Resume operation.
   - Dot drop-out and dot displacement are not eliminated even after performing powerful cleaning: Proceed to the next step.
3. Performing Manual Cleaning(P. 279)
   - Dot drop-out and dot displacement are eliminated when you perform [**Manual Cleaning**]: Resume operation.
   - Dot drop-out and dot displacement are not eliminated even after you perform [**Manual Cleaning**]: Proceed to the next step.
4. Renewing Ink(P. 296)
   - Dot drop-out and dot displacement are eliminated when you perform [**Ink Renewal**]: Resume operation.
   - Dot drop-out and dot displacement are not eliminated even after you perform [**Ink Renewal**]: Proceed to the next step.
5. Performing Medium Cleaning(P. 289)
   - Dot drop-out and dot displacement are eliminated when you perform medium cleaning: Resume operation.
   - Dot drop-out and dot displacement are not eliminated even after performing medium cleaning: Contact your authorized dealer.

After operations

Perform Cleaning the Machine(P. 277), and then turn off the sub power.

Printing Method

Preparations for Printing Output 140
Step 1: Performing a Nozzle Drop-out Test 140
Step 2: Performing Normal Cleaning 141
Starting Output 142

Preparations for Printing Output

Step 1: Performing a Nozzle Drop-out Test

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

MEMO

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

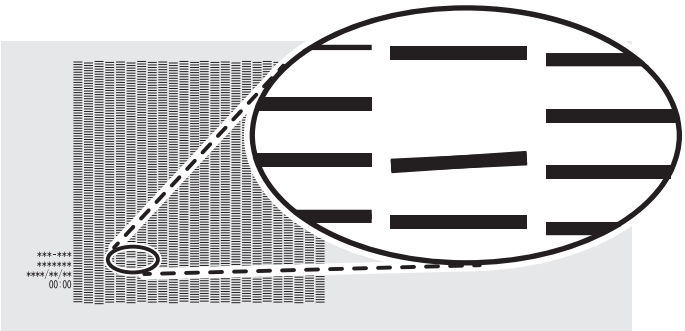
P. 244 Performing Printing Tests Arranged Horizontally

Procedure

1. **Set up the media.**
2. **Tap [Nozzle Drop-out Test] on the home screen.**
3. **Tap [Execute] next to [Printing Test].**
   Printing of the test pattern starts.

   MEMO

   To change the start position for the printing test, tap [**Output Start Location**]>[**Change**] and change the output start location. For details on this work, refer to Changing the Base Point(P. 238).
4. **Check whether there is dot drop-out or dot displacement in the test pattern.**
   Missing blocks indicate dot drop-out. Collapsed or inclined blocks indicate dot displacement.

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

- If no dot drop-out or dot displacement occurs: Preparations for output are finished. Tap to return to the home screen.
- If dot drop-out or dot displacement occurs: Step 2: Performing Normal Cleaning(P. 141)

Step 2: Performing Normal Cleaning

MEMO

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.

Procedure

1. **If the front cover is open, close it.**
2. **Tap [Cleaning].**
3. **Tap [Normal Cleaning].**
4. **Tap [Execute].**

   Cleaning will start. The details of the operation in progress and the (approximate) remaining time of that work are displayed in the status bar at the top of the screen. When the work is finished, the status bar returns to its original display.
5. **Tap ←.**
6. **Tap [Printing Test].**
7. **Select [Nozzle Drop-out Test] and tap [Execute].**
8. **Check to make sure the dot drop-out or dot displacement has been corrected.**

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

   You are returned to the home screen.

RELATED LINKS

- P. 289 When Normal Cleaning Is Not Effective

Starting 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.

⚠ CAUTION

Do not touch the dancer roller needlessly.

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

Perform the procedure under Checking the Daily Workflow(P. 138), and then start output.

Procedure

1. **If the front cover is open, close it.**
2. **Check that [Output possible.] is displayed in the status bar on the home screen.**
3. **Send the output data from the computer.**

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

MEMO

- When you send the output data, [**Normal cleaning in progress.**] may be displayed on the screen. These indicate the preparation operations performed before output. Output will begin after the time displayed on the screen elapses.
- If [**Heater warm up in progress. Please wait.**] is displayed, wait until the set temperature is reached.
- The data being output can be viewed as an image. Tap ^ shown in the following figure to switch to the remaining ink screen. Tap it again to return to the screen for checking the data being output. However, this functionality is limited to RIP software that supports the display of the output data image (thumbnail).



IMPORTANT

Output is not possible in these situations

- The machine does not run when a cover (front, left, right, or the rear UV shield) is open.
- Data from the computer is not accepted when [**Load media.**] is displayed.
- Output does not start while [**Heater warm up in progress. Please wait.**] is displayed.
- 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

- Do not open a cover (front, left, right, or the rear UV shield) 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.

Points that must be observed after output

- 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.
- Keep the loading lever raised when the machine is not in use.

Cutting Method

Preparations for Cutting Output 145
Step 1: Switching Off the Heater 145
Step 2: Preventing Pulling of the Media with Undue Force 146
Step 3: Adjusting Cutting 147
Starting Output 149

Preparations for Cutting Output

Step 1: Switching Off the Heater

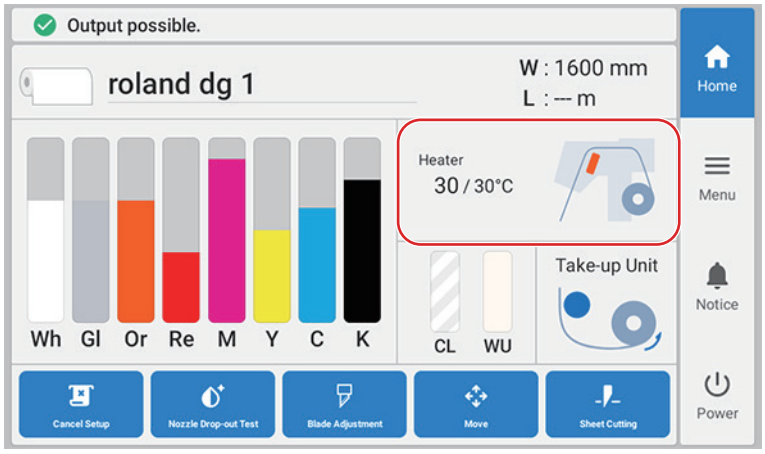
MEMO

This work is not necessary when [**Cut Only**] was selected for [**Select Media Output Type**], or when the media was created with Duplicating Media Settings for Cutting(P. 236).

Procedure

1. **Set up the media.**

2. **Tap the following location.**



3. **Switch off the front heater.**

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

5. **Tap** .

   You are returned to the home screen.

Step 2: Preventing Pulling of the Media with Undue Force

Configure the settings shown below to prevent the media from being pulled forcibly and causing misalignment or distortion of the cut position when the printer pulls the media out such as for cutting.

Procedure

1. Tap .
2. Tap [Preferences]>[Prefeeding at Output].
3. Select [Enable].
4. Tap [Save] to confirm your entry.
5. Tap .
   You are returned to the home screen.

Step 3: Adjusting Cutting

For high-quality cutting, carry out a cutting test to check the cutting quality for the media before you perform actual cutting. As a guideline, the blade should pierce the media with the blade tip extending slightly. Adjust the blade force depending on the cutting quality.

The media thickness varies due to lamination and similar processing, so adjust cutting with the media in the same state as when you perform cutting with crop marks.

Procedure

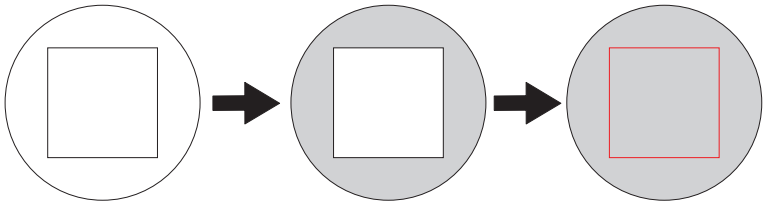
1. **Tap [Blade Adjustment] on the home screen.**
2. **Tap [Change] next to [Output Start Location].**
3. **Tap .**

   The cutting carriage moves to the current base point.
4. **Tap , , , or to move the cutting carriage to the location where you want to carry out the cutting test.**

   You can freely set the location for the cutting test.
5. **Tap [Set Base Point Here].**
6. **Tap [Execute] next to [Cutting Test].**

   The test pattern is cut.
7. **Peel off the cut shapes and change the [Blade Adjustment]>[Blade Force] according to the cutting quality.**

   Check that the two shapes are peeled off separately, a blade trace (red line) remains on the backing paper, and the backing paper is not cut.

   - **Two shapes are peeled off separately**
     You do not need to perform the setting because the blade force is appropriate.
   - **Two shapes are peeled off together**

     Increase the blade force.
   - **Backing paper is also cut**

     Decrease the blade force.
8. **Tap [Save].**

   The changed settings are saved.
9. **Tap [Execute] next to [Cutting Test].**

   The test pattern is cut.
10. **Check whether the correction was successful.**

In the [**Blade Adjustment**] menu, you can also make settings for other cutting conditions in addition to the blade force.

RELATED LINKS

- P. 196 Accurately Adjusting the Cutting Settings

Starting Output

⚠ WARNING

Never touch the cutting carriage while output is in progress.

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

⚠ CAUTION

Do not touch the dancer roller needlessly.

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

Procedure

1. **Close the front cover.**
2. **Tap** .
3. **Check that [Output possible.] is displayed in the status bar.**
4. **Send the output data from the computer.**

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

MEMO

The data being output can be viewed as an image. Tap shown in the following figure to switch to the remaining ink screen. Tap it again to return to the screen for checking the data being output. However, this functionality is limited to RIP software that supports the display of the output data image (thumbnail).



IMPORTANT

Output is not possible in these situations

- The machine does not run when a cover (front, left, right, or the rear UV shield) is open.
- Data from the computer is not accepted when **[Load media.]** is displayed.
- 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

- Do not open a cover (front, left, right, or the rear UV shield) while output is in progress. Doing so interrupts printing.
- During output, do not touch the media. Doing so may obstruct the media feed or cause the media to rub against the cutting carriage, which may result in a paper jam or damage to the carriage.
- Keep the loading lever raised when the machine is not in use.

Points that must be observed after output

- 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.
- Keep the loading lever raised when the machine is not in use.

Printing and Cutting Method

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Preparations before Printing and Cutting Output

Step 1: Performing a Nozzle Drop-out Test

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

MEMO

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

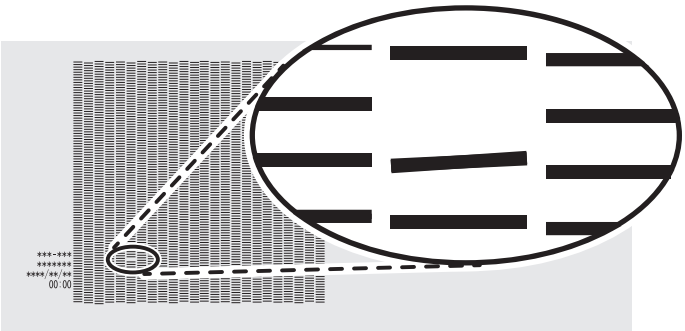
P. 244 Performing Printing Tests Arranged Horizontally

Procedure

1. **Set up the media.**
2. **Tap [Nozzle Drop-out Test] on the home screen.**
3. **Tap [Execute] next to [Printing Test].**
   Printing of the test pattern starts.

   MEMO

   To change the start position for the printing test, tap [**Change**] for [**Output Start Location**] and change the output start location. For details on this work, refer to Changing the Base Point(P. 238).
4. **Check whether there is dot drop-out or dot displacement in the test pattern.**
   Missing blocks indicate dot drop-out. Collapsed or inclined blocks indicate dot displacement.

   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.
5. **If dot drop-out or dot displacement is present, perform normal cleaning.**

   P. 154 Step 2: Performing Normal Cleaning

   If there is no dot drop-out or dot displacement, proceed to the next step.
6. **If you have opened the front cover, close it.**

If no dot drop-out or dot displacement occurs, preparations for output are finished.

7. **Tap** .

You are returned to the home screen.

RELATED LINKS

- P. 288 When Dot Drop-out or Dot Displacement Occurs

Step 2: Performing Normal Cleaning

MEMO

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.

Procedure

1. **If the front cover is open, close it.**
2. **Tap [Cleaning]>[Normal Cleaning].**
3. **Tap [Execute].**

   Cleaning will start. The details of the operation in progress and the (approximate) remaining time of that work are displayed in the status bar at the top of the screen. When the work is finished, the status bar returns to its original display.
4. **Tap ←.**
5. **Tap [Printing Test].**
6. **Select [Nozzle Drop-out Test] and tap [Execute].**
7. **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.
8. **Tap ⌂.**

   You are returned to the home screen.

Step 3: Adjusting Cutting

For high-quality cutting, carry out a cutting test to check the cutting quality for the media before you perform actual cutting. As a guideline, the blade should pierce the media with the blade tip extending slightly. Adjust the blade force depending on the cutting quality.

The media thickness varies due to lamination and similar processing, so adjust cutting with the media in the same state as when you perform cutting with crop marks.

Procedure

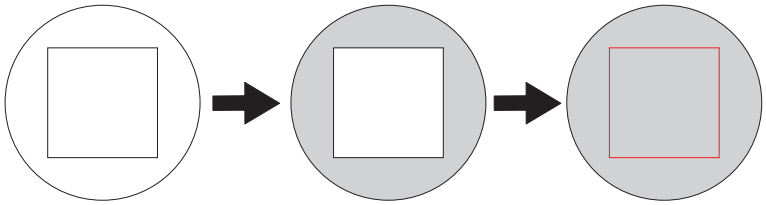
1. **Tap [Blade Adjustment] on the home screen.**
2. **Tap [Change] next to [Output Start Location].**
3. **Tap .**

   The cutting carriage moves to the current base point.
4. **Tap , , , or to move the cutting carriage to the location where you want to carry out the cutting test.**

   You can freely set the location for the cutting test.
5. **Tap [Set Base Point Here].**
6. **Tap [Execute] next to [Cutting Test].**

   The test pattern is cut.
7. **Peel off the cut shapes and change the [Blade Adjustment]>[Blade Force] according to the cutting quality.**

   Check that the two shapes are peeled off separately, a blade trace (red line) remains on the backing paper, and the backing paper is not cut.

   - **Two shapes are peeled off separately**
     You do not need to perform the setting because the blade force is appropriate.
   - **Two shapes are peeled off together**

     Increase the blade force.
   - **Backing paper is also cut**

     Decrease the blade force.
8. **Tap [Save].**

   The changed settings are saved.
9. **Tap [Execute] next to [Cutting Test].**

   The test pattern is cut.
10. **Check whether the correction was successful.**

In the [**Blade Adjustment**] menu, you can also make settings for other cutting conditions in addition to the blade force.

RELATED LINKS

- P. 196 Accurately Adjusting the Cutting Settings

Step 4: Correcting the Misalignment of Printing and Cutting

Procedure

1. Tap .

2. **Tap [Media Settings]>[Cutting Settings]>[Print & Cut Position Adjustment].**

3. **Tap [Execute] next to [Printing Test 1 (Misalignment Check)].**

   Printing Test 1 is printed and cut. The test pattern is printed at each edge of the media.

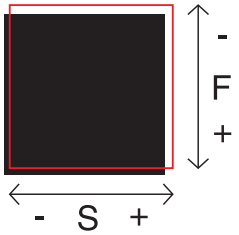
   MEMO

   If the media is tilted, the positions at the edges will be misaligned. You can also adjust for misalignments due to the media being tilted by printing the test pattern at each edge.

4. **Check the result of Printing Test 1.**

   Check whether the printing position (shaded part) and the cutting position (red line) are aligned. An example of the printing position and the cutting position being misaligned is shown in the following figure.

   [F] indicates the feed direction of the media (the feed direction) and [S] indicates the direction of print head carriage movement (the scan direction).

   If the printing position and the cutting position are aligned, no corrections are necessary. Proceed to step 10.

   If the printing position and the cutting position are not aligned, proceed to the next procedure.

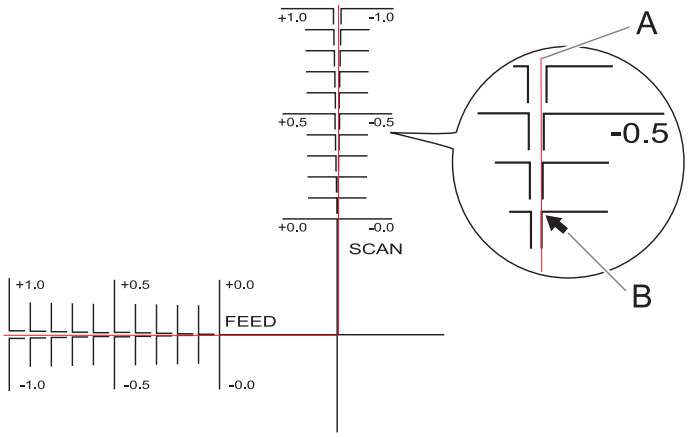
5. **Tap [Execute] next to [Printing Test 2 (Correction Values)].**

   Printing Test 2 is printed and cut.

6. **Check the correction values from the Printing Test 2 condition.**

   The point where the cutting line (A) intersects the correction-value scale (B) is the correction value. In the following figure, the correction value is "−0.3."

   Check the media feed direction (the feed direction) and the direction of print-head carriage movement (the scan direction).



7. **Set the correction values in the feed direction of the media (the feed direction) and the direction of print-head carriage movement (the scan direction).**

(1) **Tap − or + next to [Correction Value (Feed)] to set the correction value in the feed direction of the media (the feed direction).**

(2) **Tap − or + next to [Correction Value (Scan)] to set the correction value in the direction of print head carriage movement (the scan direction).**

8. **Tap [Save].**

The correction values are saved.

9. **Tap [Execute] next to [Printing Test 1 (Misalignment Check)].**

Printing Test 1 is printed and cut. If the printing and cutting lines are aligned, adjustment is complete. If further adjustment is needed, tap − or + next to [**Correction Value (Feed)**] and [**Correction Value (Scan)**] to fine-tune the printing and cutting position, and then [**Save**] the values.

MEMO

Default settings

- [**Correction Value (Feed)**] (correction value of the media feed direction): 0.00 mm
- [**Correction Value (Scan)**] (correction value of the print-head carriage movement direction): 0.00 mm

10. **Tap to return to the home screen.**

Starting 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.

⚠ CAUTION

Do not touch the dancer roller needlessly.

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

Perform the procedure under Checking the Daily Workflow(P. 138), and then start output.

Procedure

1. **If the front cover is open, close it.**
2. **Check that [Output possible.] is displayed in the status bar on the home screen.**
3. **Send the output data from the computer.**

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

MEMO

- When you send the output data, [**Normal cleaning in progress.**] may be displayed on the screen. These indicate the preparation operations performed before output. Output will begin after the time displayed on the screen elapses.
- If [**Heater warm up in progress. Please wait.**] is displayed, wait until the set temperature is reached.
- The data being output can be viewed as an image. Tap ^ shown in the following figure to switch to the remaining ink screen. Tap it again to return to the screen for checking the data being output. However, this functionality is limited to RIP software that supports the display of the output data image (thumbnail).



IMPORTANT

Output is not possible in these situations

- The machine does not run when a cover (front, left, right, or the rear UV shield) is open.
- Data from the computer is not accepted when [**Load media.**] is displayed.
- Output does not start while [**Heater warm up in progress. Please wait.**] is displayed.
- 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

- Do not open a cover (front, left, right, or the rear UV shield) 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.

Points that must be observed after output

- 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.
- Keep the loading lever raised when the machine is not in use.

How to Cut with Crop Marks

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Preparations before Cutting with Crop Marks

What Is Cutting with Crop Marks?

If you are removing the printed media and setting it up again in order to cut it (for example, if you are processing the media, such as laminating after printing, and then setting up this media again for cutting), you have to align the printing and cutting positions. By printing the data together with crop marks, you can make it possible to align the positions using the crop marks when you set up the media again to cut it. In this manual, this printing method is referred to as "cutting with crop marks."

"Crop marks" are marks used to align positions. They are also called "alignment marks."

Step 1: Performing a Nozzle Drop-out Test

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

MEMO

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

P. 244 Performing Printing Tests Arranged Horizontally

Procedure

1. **Set up the media.**
2. **Tap [Nozzle Drop-out Test] on the home screen.**
3. **Tap [Execute] next to [Printing Test].**

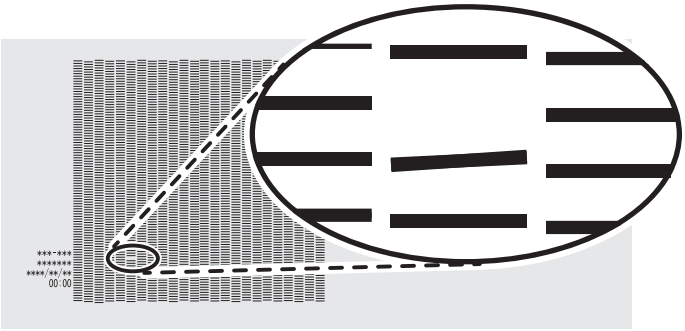
   Printing of the test pattern starts.

   MEMO

   To change the start position for the printing test, tap [**Change**] for [**Output Start Location**] and change the output start location. For details on this work, refer to Changing the Base Point(P. 238).

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

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



   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.

5. **If dot drop-out or dot displacement is present, perform normal cleaning.**

P. 164 Step 2: Performing Normal Cleaning

If there is no dot drop-out or dot displacement, proceed to the next step.

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

If no dot drop-out or dot displacement occurs, preparations for output are finished.

7. **Tap** .

You are returned to the home screen.

RELATED LINKS

- P. 288 When Dot Drop-out or Dot Displacement Occurs

Step 2: Performing Normal Cleaning

MEMO

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.

Procedure

1. **If the front cover is open, close it.**
2. **Tap [Cleaning]>[Normal Cleaning].**
3. **Tap [Execute].**

   Cleaning will start. The details of the operation in progress and the (approximate) remaining time of that work are displayed in the status bar at the top of the screen. When the work is finished, the status bar returns to its original display.
4. **Tap ←.**
5. **Tap [Printing Test].**
6. **Select [Nozzle Drop-out Test] and tap [Execute].**
7. **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.
8. **Tap ⌂.**

   You are returned to the home screen.

RELATED LINKS

- P. 289 When Normal Cleaning Is Not Effective

Step 3: Adjusting Cutting

For high-quality cutting, carry out a cutting test to check the cutting quality for the media before you perform actual cutting. As a guideline, the blade should pierce the media with the blade tip extending slightly. Adjust the blade force depending on the cutting quality.

The media thickness varies due to lamination and similar processing, so adjust cutting with the media in the same state as when you perform cutting with crop marks.

Procedure

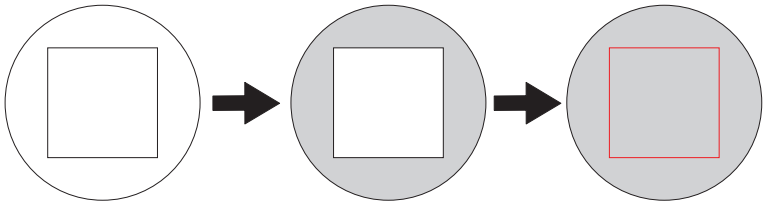
1. **Tap [Blade Adjustment] on the home screen.**
2. **Tap [Change] next to [Output Start Location].**
3. **Tap .**

   The cutting carriage moves to the current base point.
4. **Tap , , , or to move the cutting carriage to the location where you want to carry out the cutting test.**

   You can freely set the location for the cutting test.
5. **Tap [Set Base Point Here].**
6. **Tap [Execute] next to [Cutting Test].**

   The test pattern is cut.
7. **Peel off the cut shapes and change the [Blade Adjustment]>[Blade Force] according to the cutting quality.**

   Check that the two shapes are peeled off separately, a blade trace (red line) remains on the backing paper, and the backing paper is not cut.

   - **Two shapes are peeled off separately**
     You do not need to perform the setting because the blade force is appropriate.
   - **Two shapes are peeled off together**

     Increase the blade force.
   - **Backing paper is also cut**

     Decrease the blade force.
8. **Tap [Save].**

   The changed settings are saved.
9. **Tap [Execute] next to [Cutting Test].**

   The test pattern is cut.
10. **Check whether the correction was successful.**

In the [**Blade Adjustment**] menu, you can also make settings for other cutting conditions in addition to the blade force.

RELATED LINKS

- P. 196 Accurately Adjusting the Cutting Settings

Step 4: Correcting the Misalignment of Printing and Cutting with Crop Marks at the Same Time

Use the following procedure to print the crop marks and cut the media, checking for misalignment in the positions. In this section, the crop marks are printed simply, and then the crop marks are read and a cutting test is performed without removing the media. To simulate the actual process—printing crop marks, removing the media, and then performing post-processing such as laminating—before loading the media and checking for cutting position misalignment, turn on **[Separate Test for Printing/Cutting with Crop Marks]**. For more information, refer to Correcting the Misalignment of Printing and Cutting with Crop Marks (Separate Test for Printing and Cutting with Crop Marks)(P. 214).

Procedure

1. **Tap** .
2. **Tap [Media Settings]>[Cutting Settings]>[Crop Cut Position Adjustment].**
3. **Tap next to [Separate Test for Printing/Cutting with Crop Marks] to turn it off.**
4. **Tap [Execute] next to [Printing Test 1 (Misalignment Check)].**

   Printing Test 1 is printed and cut. One test pattern is printed on the media.

   IMPORTANT

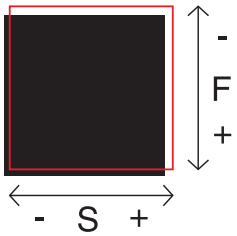
   Printing (crop marks) may not be readable with transparent media, silver or other light-reflective media, or black or other dark-colored media, which may prevent cutting from being performed. Try the following if **[Crop Mark Detection Error]** is displayed.

   - Are You Using Black Crop Marks with Transparent Media?(P. 330)
   - Are you using media that is likely to reflect light or has deep colors?(P. 330)

5. **Check Printing Test 1.**

   Check whether the printing position (shaded part) and the cutting position (red line) are aligned. An example of the printing position and the cutting position being misaligned is shown in the following figure.

   [F] indicates the feed direction of the media (the feed direction) and **[S]** indicates the direction of print head carriage movement (the scan direction).

   If the printing position and the cutting position are aligned, no corrections are necessary. Proceed to step 11.

   If the printing position and the cutting position are not aligned, proceed to the next procedure.

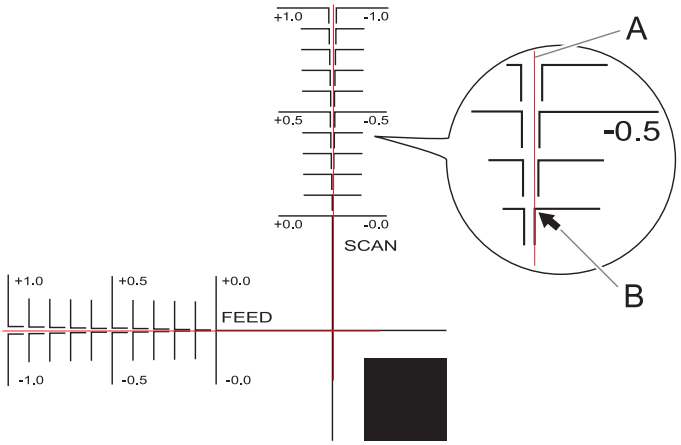
6. **Tap [Execute] next to [Printing Test 2 (Correction Values)].**

   Printing Test 2 is printed and cut.

7. **Check the correction values from the Printing Test 2 condition.**

The point where the cutting line (A) intersects the correction-value scale (B) is the correction value. In the following figure, the correction value is "−0.3."

Check the media feed direction (the feed direction) and the direction of print-head carriage movement (the scan direction).



8. Set the correction values in the feed direction of the media (the feed direction) and the direction of print-head carriage movement (the scan direction).

(1) **Tap − or + next to [Correction Value (Feed)] to set the correction value in the feed direction of the media (the feed direction).**

(2) **Tap − or + next to [Correction Value (Scan)] to set the correction value in the direction of print head carriage movement (the scan direction).**

9. Tap [Save].

The correction values are saved.

10. Tap [Execute] next to [Printing Test 1 (Misalignment Check)].

Printing Test 1 is printed and cut. If the printing and cutting lines are aligned, adjustment is complete. If further adjustment is needed, tap − or + next to [**Correction Value (Feed)**] and [**Correction Value (Scan)**] to fine-tune the printing and cutting position, and then [**Save**] the values.

MEMO

- Default settings
  [**Correction Value (Feed)**] (correction value of the media feed direction): 0.00 mm (0.00 in.)
  [**Correction Value (Scan)**] (correction value of the print-head carriage movement direction): 0.00 mm (0.00 in.)
- Depending on the changes in the condition of media caused by laminating and the loading position of the media before cutting, the positioning of cutting may be misaligned. In such cases, correct the misalignment of printing and cutting with crop marks.

11. Tap to return to the home screen.

RELATED LINKS

• P. 214 Correcting the Misalignment of Printing and Cutting with Crop Marks (Separate Test for Printing and Cutting with Crop Marks)

Starting 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.

⚠ CAUTION

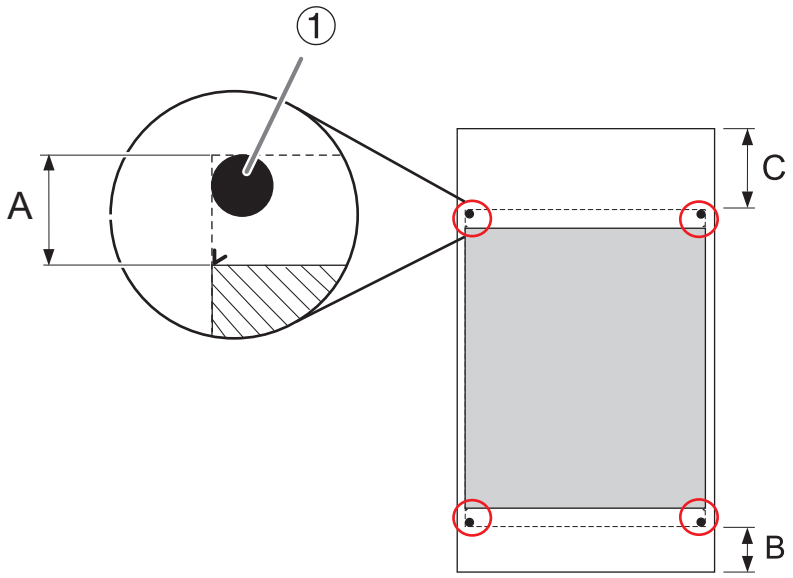
Do not touch the dancer roller needlessly.

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

MEMO

When printing with crop marks, a printing area for printing the crop marks (①) and a margin for cropping and cutting must be secured.

- Crop mark printing area
  Secure a crop mark printing area (A) of 22.5 mm (0.89 in.) both before and after the print data when printing crop marks.
- Margin for cropping and cutting
  Secure a margin of 75 mm (2.96 in.; B) or more before the crop marks and 130 mm (5.12 in.; C) or more after the crop marks for reading and cutting crop marks.



Perform the procedure under Checking the Daily Workflow(P. 138), and then start output.

Procedure

1. **If the front cover is open, close it.**
2. **Check that [Output possible.] is displayed in the status bar on the home screen.**
3. **Send the output data with crop marks from the computer.**

For information on how to set crop marks, refer to the documentation for the RIP software.

MEMO

- When you send the output data, [**Normal cleaning in progress.**] may be displayed on the screen. These indicate the preparation operations performed before output. Output will begin after the time displayed on the screen elapses.
- If [**Heater warm up in progress. Please wait.**] is displayed, wait until the set temperature is reached.
- The data being output can be viewed as an image. Tap shown in the following figure to switch to the remaining ink screen. Tap it again to return to the screen for checking the data being output. However, this functionality is limited to RIP software that supports the display of the output data image (thumbnail).



IMPORTANT

Output is not possible in these situations

- The machine does not run when a cover (front, left, right, or the rear UV shield) is open.
- Data from the computer is not accepted when [**Load media.**] is displayed.
- Output does not start while [**Heater warm up in progress. Please wait.**] is displayed.
- 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

- Do not open a cover (front, left, right, or the rear UV shield) 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.

Points that must be observed after output

- 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.
- Keep the loading lever raised when the machine is not in use.

Remove the media, and then perform lamination and any other necessary processing.

RELATED LINKS

- P. 195 Setting the Front Heater Temperature
- P. 145 Switching Off the Heater

Preparations for Cutting Output

Step 1: Setting Up Media with Crop Marks

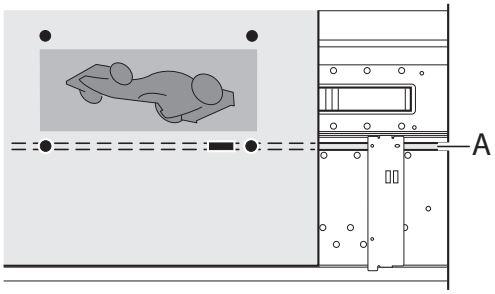
Procedure

1. **Load the media on which crop marks have been printed.**

   Place the front left and right crop marks so they are straight and aligned with the blade protector (A).

   IMPORTANT

   Ensure that the crop marks are not angled by more than 5 degrees. Crop marks cannot be read at higher angles.

2. **Finish the media setup and check that the home screen is displayed.**

   This completes the setup of the media with crop marks.

Step 2: Switching Off the Heater

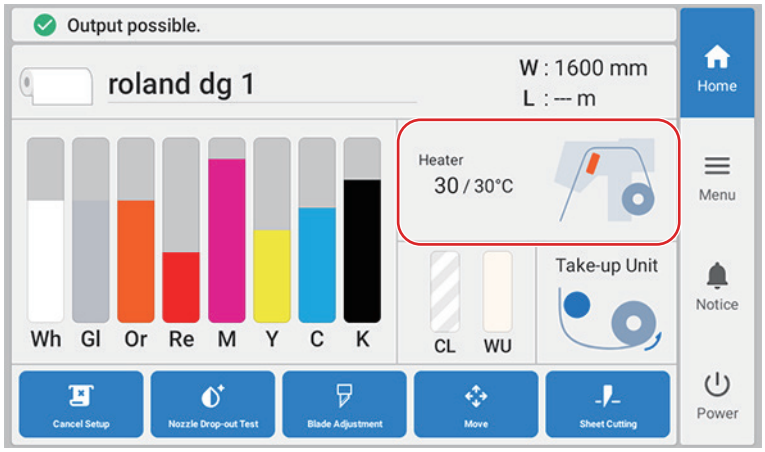
MEMO

This work is not necessary when [**Cut Only**] was selected for [**Select Media Output Type**], or when the media was created with Duplicating Media Settings for Cutting(P. 236).

Procedure

1. **Set up the media.**

2. **Tap the following location.**



3. **Switch off the front heater.**

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

5. **Tap** .

   You are returned to the home screen.

Step 3: Preventing Pulling of the Media with Undue Force

Configure the settings shown below to prevent the media from being pulled forcibly and causing misalignment or distortion of the cut position when the printer pulls the media out such as for cutting.

Procedure

1. Tap .
2. Tap [Preferences]>[Prefeeding at Output].
3. Select [Enable].
4. Tap [Save] to confirm your entry.
5. Tap .
   You are returned to the home screen.

Starting Cutting Output

⚠ WARNING

Never touch the cutting carriage while output is in progress.

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

⚠ CAUTION

Do not touch the dancer roller needlessly.

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

Procedure

1. **Check that [Output possible.] is displayed in the status bar on the home screen.**

2. **Send cutting data.**

   Read the crop marks and send the data to cut.

IMPORTANT

Output is not possible in these situations

- The machine does not run when a cover (front, left, right, or the rear UV shield) is open.
- Data from the computer is not accepted when **[Load media.]** is displayed.
- 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

- Do not open a cover (front, left, right, or the rear UV shield) while output is in progress. Doing so interrupts printing.
- 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.

Points that must be observed after output

- 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.
- Keep the loading lever raised when the machine is not in use.

Optimizing Quality and Efficiency

Optimizing the Output Quality

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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.

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

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

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

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

MEMO

The printing test width is approximately 290 mm (11.42 in.). Check that a printing area which can be printed has been secured, then perform the printing test.

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
   - Feed Correction
   - Media Gap Adjustment
6. **Tap [OK] when the completion screen appears.**
7. **Perform the operations shown below according to the [Result].**
   - If **[Successful]** is displayed on the operation panel, tap ⌂ to go back to the home screen.
   - If **[Failed]** is displayed on the operation panel, carry out manual adjustment.

RELATED LINKS

- P. 178 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)
- P. 180 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 the temperature of the front heater. We recommend that you make corrections to match the media you are using and the set temperature of the front heater.

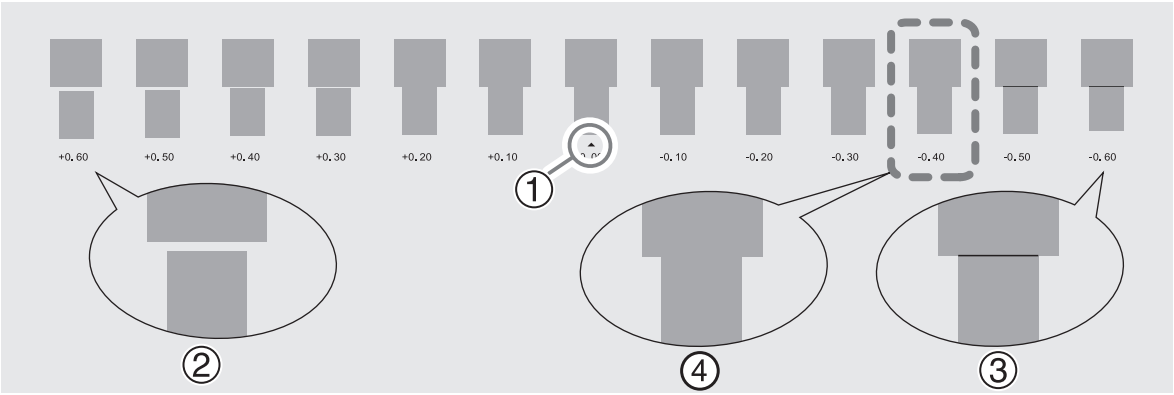
First, print a test pattern (approximate width: 375 mm [14.76 in.]), and then determine and enter the correction value. After entering the correction value, print a test pattern again and check the correction results. Repeat the process of printing a test pattern and entering a correction value several 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. **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 change the correction value.**

   The current correction value ① is that of the figure indicated by "▲." Select the value to make the gap ② and overlap ③ between the upper/lower squares smallest. In the case of the following figure, select "−0.40." (④). 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.

8. **Tap [Save].**

   The entered correction value is saved.

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

   The test pattern is printed again.

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

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

11. **When you have successfully performed the correction, tap .**

    You are returned to the home screen.

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

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

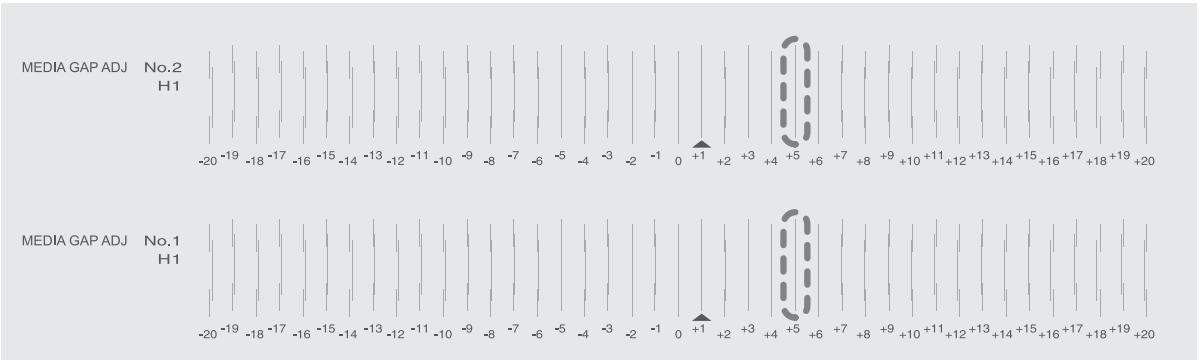
First, print a test pattern (approximate width: 200 mm [7.87 in.]), and then determine and enter the correction value. After entering the correction value, print a test pattern again and check the correction results.

This adjustment must be performed in the following cases.

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

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 change the No. 1 and No. 2 H1 correction values.**
   Select the value that gives the least misalignment between the three lines. In the case of the following figure, select "+5" for H1 of No. 1 and 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.

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 three 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 .**

    You are returned to the home screen.

Configuring Settings to Match the Properties of the Media

Changing the Print Head Height

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

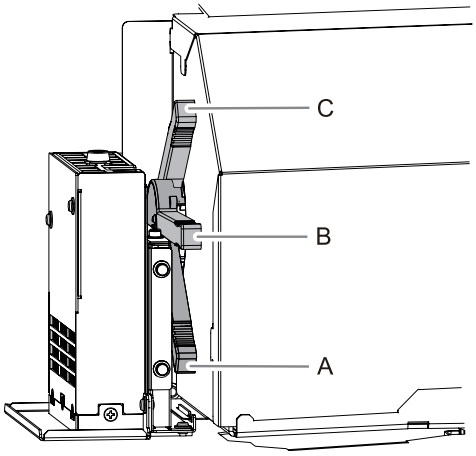
You can select the print head height from [**Low**], [**Medium**], and [**High**]. Printing quality when the print head height is set to [**Medium**] or [**High**] may be coarser or otherwise lower than when set to [**Low**].

Procedure

1. **Set up the media.**
2. **Tap** .
3. **Tap [Media Settings]>[Printing Settings]>[Print Head Height].**
4. **Tap [Change].**

   The print head carriage moves to a position where they can be operated.
5. **Open the front cover.**
6. **Move the height-adjustment lever to adjust the head height.**

   When you change the position of the height-adjustment lever, the screen changes and the buzzer sounds at the same time.



Position	Operation panel display	Description
A	[**Low**]	Normally set the height-adjustment lever to [**Low**].
B	[**Medium**]	For media that is wrinkled or comes loose from the platen during printing, set the height-adjustment lever to [**Medium**].
C	[**High**]	If the media still hits the print head even after setting to [**Medium**], set to [**High**].

IMPORTANT

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

7. **Close the front cover.**

8. **Tap [OK].**

   The print head carriage moves to their original position.

9. **Tap** .

   You are returned to the home screen.

MEMO

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

RELATED LINKS

- P. 177 Automatically Making Required Adjustments
- P. 180 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 change the value.**

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

5. **Tap [Save] to confirm your entry.**
6. **Tap** ⌂ **to return to the home screen.**

MEMO

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

Using Sticky Media

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

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

Procedure

1. **Set up the media.**
2. **Tap** .
3. **Tap [Media Settings]>[Other Media Settings]>[Media Sticking Prevention].**
4. **Select [Enable].**
5. **Tap [Save] to confirm your entry.**
6. **Tap**  **to return to the home screen.**

MEMO

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

Using Transparent Media

If you are using transparent media, it is not possible to detect the front and back of the media during media setup. Therefore, set [**Media Edge Detection**] to [**Disable**]. With this setting, the printer will not perform the [**Skewing Correction Support at Setup**] action.

When setting up transparent media, see "Determine the positions of the media ([**Media Edge Detection**]: [**Disable**])" to perform media setup.

Procedure

1. Tap .
2. Tap [Preferences]>[Media Edge Detection].
3. Select [Disable] and tap [Save].
4. Tap .
   You are returned to the home screen.

- Default setting: [**Enable**]

RELATED LINKS

- P. 43 B: Determining the Positions of Media (If [**Media Edge Detection**]: [**Disable**])
- P. 65 B: Determining the Positions of Media (If [**Media Edge Detection**]: [**Disable**])

Preventing the Suction Fan from Operating During Media Setup

Follow the procedure below to prevent the suction fan from operating during media setup.

Procedure

1. Tap .
2. Tap [Preferences]>[Skewing Correction Support at Setup].
3. Select [Disable] and tap [Save].
4. Tap .
   You are returned to the home screen.

MEMO

- Default setting: **[Enable]**

Making It Easier to Check White Ink with Nozzle Drop-Out Tests

Depending on the color of the media, it may be difficult to check the white ink test pattern. To perform a nozzle drop-out test with white media, print a base in black under the white ink test pattern. This black base makes it easier to check for dot drop-out and dot displacement in the white ink.

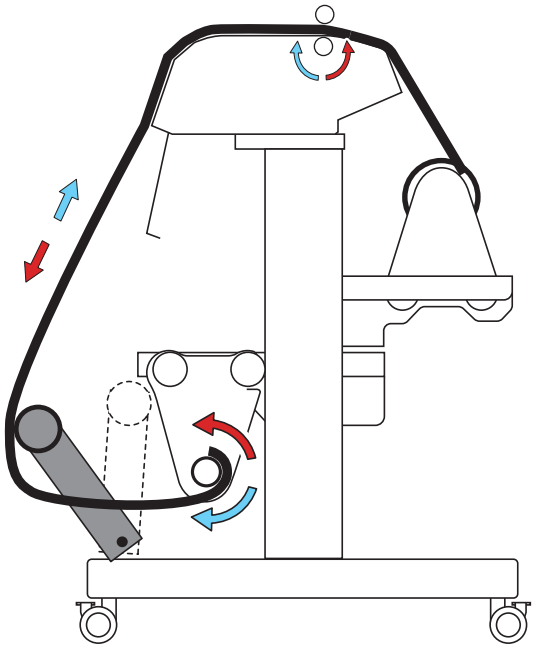
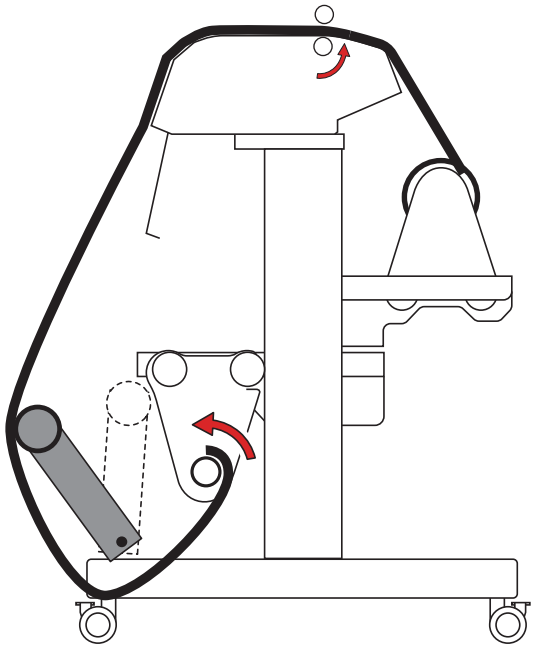
Procedure

1. **Set up the media.**
2. **Tap [Nozzle Drop-out Test] on the home screen.**
3. **Tap [Cleaning]>[Printing Test] to select [Nozzle Drop-out Test (Base: Black)].**
4. **Tap [Execute].**
   The white ink test pattern is printed on a black base.

Take-up Unit Settings

The following three take-up unit settings are available.

- **[Take-up during Cutting]**

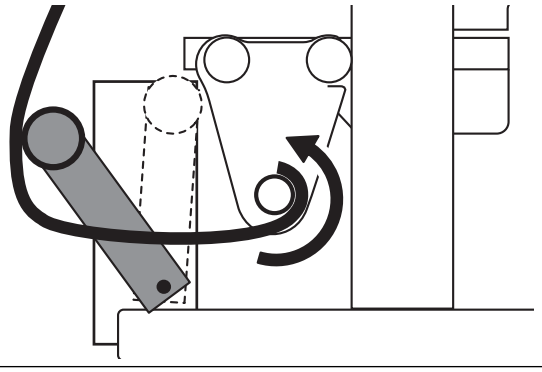
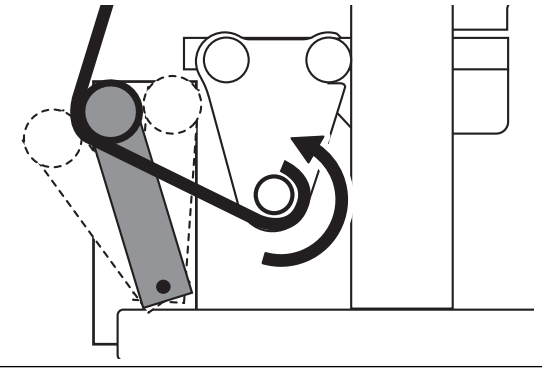
[Enabled]	[Disabled]
The media is taken up during cutting while slack is being created. This prevents the media from touching the floor, but the cutting time becomes longer.	The media is taken up after all cutting finishes. Although the cutting time is shorter than with **[Enabled]**, the media will touch the floor with longer cutting data.
	

MEMO

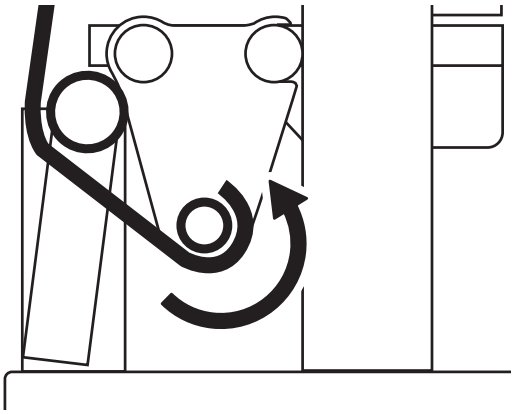
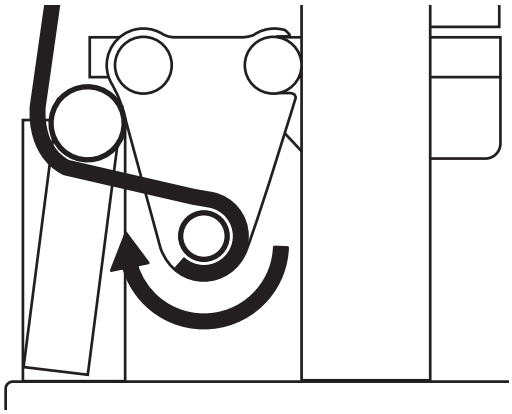
If you have selected **[Enabled]**, note the following points.

- To preserve cutting quality, the speed may be limited to the optimum speed for **[Cutting Speed]** and **[Rise Movement Speed]** depending on the set media.
- Take-up is not performed during cutting for the **[Blade Adjustment]**, **[Print & Cut Position Adjustment]**, and **[Crop Cut Position Adjustment]** printing tests.

- **[Take-up Method]**

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

- **[Take-up Direction]**

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

Setting the Take-up Unit

Procedure

1. Tap ☰.
2. Tap [Preferences]>[Take-up].
3. Tap [Take-up during Cutting] to select one of the following options.
   - [Enabled]

     The media is taken up during cutting while slack is being created. This prevents the media from touching the floor, but the cutting time becomes longer.

     Set up the media with it wrapped at least halfway around the paper tube of the take-up unit.
   - [Disabled]

     The media is taken up after all cutting finishes. Although the cutting time is shorter than with [Enabled], the media will touch the floor with longer cutting data.

     When performing cutting immediately after attaching the media to the paper tube, first feed enough media to carry out take-up a few times and set the base point.
4. Tap [Save].
5. Tap [Take-up Method] to select one of the following options.
   - [Loose Winding]

     The media is taken up with some slack. This is suited to PVC and other such stiff or slippery media.
   - [Tension Winding]

     The media is stretched and taken up. This is suited to tarpaulin and other such weak media and media that does not slip easily.

   MEMO

   Even if [Tension Winding] is set, if [Enabled] is enabled, the media is taken up while slack is being created.
6. Tap [Save].

7. **Tap [Take-up Direction] to select one of the following options.**
   - **[Forward]**
     The media is taken up onto the paper tube with the printed surface on the outside.
   - **[Backward]**
     The media is taken up onto the paper tube with the printed surface on the inside.

8. **Tap [Save].**

9. **Tap** **.**
   You are returned to the home screen.

MEMO

Default settings

- **[Take-up during Cutting]: [Disabled]**
- **[Take-up Method]: [Loose Winding]**
- **[Take-up Direction]: [Forward]**

Preventing Misaligned Media

Use Middle Pinch Rollers When Pulling Back or Feeding Media

Set the setting that causes the middle pinch rollers to go up automatically during pullback printing or printing and cutting to [**Disable**]. Holding down media that is not straight or comes loose is effective in preventing misalignment during printing and cutting.

[**Middle Pinch Auto Raise/Lower**] is a function that causes the middle pinch rollers to automatically rise when media is pulled back, performs overprinting and cutting while they are raised. However, if you are performing lengthy printing or using non-resilient media, the media will be skewed or will come loose, which may have an effect on the output quality.

If you set [**Middle Pinch Auto Raise/Lower**] to [**Disable**], the middle pinch rollers will press down on the media while moving, thus preventing skewing or coming loose. However, because the middle pinch rollers are pressed against the printed surface, it is easier for the rollers to leave a trace on the printed surface.

Procedure

1. **Set up the media.**
2. **Tap** .
3. **Tap [Media Settings]>[Other Media Settings]>[Middle Pinch Auto Raise/Lower].**
4. **Select [Disable].**

   The middle pinch rollers will lower during media feeding and pullback, pressing down on the media while moving.
5. **Tap [Save] to confirm your entry.**
6. **Tap** .

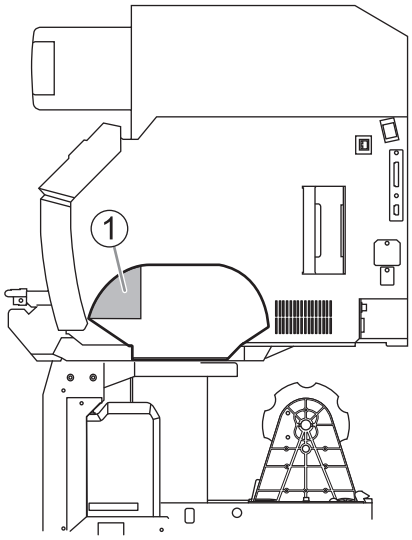
   You are returned to the home screen.

MEMO

- Default setting: [**Enable**]

Heating the Media to Prevent It from Coming Loose

This machine's apron is equipped with a front heater (①), which heats the media. Heating the media makes it flexible, preventing the media from coming loose. You can adjust the temperature settings to match the type of media and the printing speed.



⚠ WARNING

High Temperature

Areas such as the heater 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 degrade the media, or may result in fire or the release of toxic gases.

⚠ WARNING

Never use the heater for any purpose for which it is not intended, such as to dry clothing.

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

Setting the Standby Heater Temperature

Set the heater temperature used when the main power and the sub power are switched on and the setup of the media is not complete.

Procedure

1. Tap .
2. Tap [Preferences]>[Standby Heater Temperature].
3. Tap to turn it on.
4. Tap − or + to set the temperature.

   If you set this to (off), the front heater will be off during standby.
5. Tap [Save] to confirm your entry.
6. Tap .

   You are returned to the home screen.

MEMO

- Default setting: Off

Setting the Front Heater Temperature

Setting the temperature of the front heater appropriately minimizes temperature changes in the media during and after printing, thereby preventing the media from coming loose.

When the sub power is on, the front heater rises to the [**Standby Heater Temperature**] (off by default). On completion of media setup, the temperature rises to the value set for [**Front Heater**].

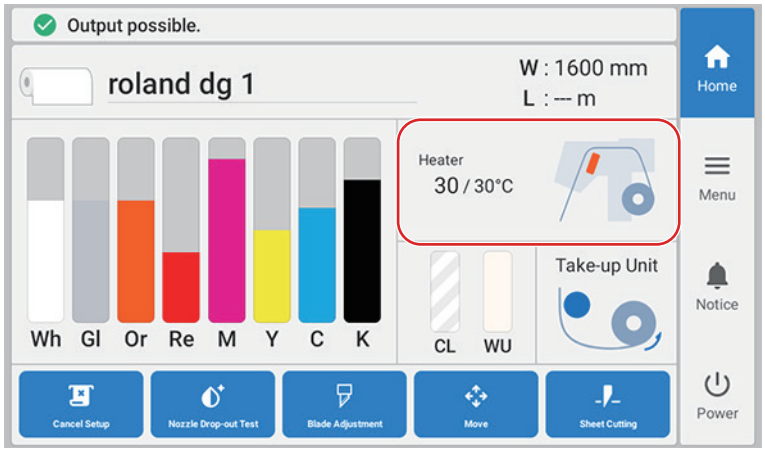
MEMO

- Depending on the usage environment, the temperature of the dryer may become higher than the set temperature, but this does not represent a problem.
- Temperature settings are not possible when [**Front Heater**] accessed from [**Media Settings**]>[**Heater Settings**]>[**Heater Temperature**] is off.

Procedure

1. **Set up the media.**

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



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

3. **Check that [Front Heater] is turned on ( ).**

4. **Tap − or + to set the [Front Heater] temperature.**

   A temperature that is too high may degrade the media or cause it to wrinkle.

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

6. **Tap .**

   You are returned to the home screen.

MEMO

- Default settings
  - [**Heater Power**]: On
  - [**Front Heater**]: 30°C
- Depending on the RIP software you are using, you can also configure this setting in the RIP software. If you have configured the setting in the RIP software, the RIP software setting is used.

Accurately Adjusting the Cutting Settings

Fine-tuning the Cutting Conditions

You can accurately set items such as the blade force, movement speed, and blade offset to match the nature of the media and the shape to cut. First, perform a cutting test, and then determine and enter the setting values. After entering the setting values, perform a cutting test again and check the results. Repeat the process of performing a cutting test and making the settings several times to find the optimal setting values.

Procedure

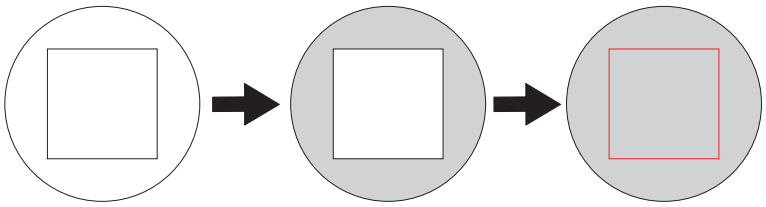
1. **Set up the media.**
2. **Tap [Blade Adjustment] on the home screen.**
3. **Tap [Change] next to [Output Start Location].**
4. **Tap .**

   The cutting carriage moves to the current base point.
5. **Tap , , , or to move the cutting carriage to the location where you want to carry out the cutting test.**

   You can freely set the location for the cutting test.
6. **Tap [Set Base Point Here].**
7. **Tap [Execute] next to [Cutting Test].**

   The test pattern is cut.
8. **Check the results of the cutting test.**

   Check that the two shapes are peeled off separately, a blade trace (red line) remains on the backing paper, and the backing paper is not cut.



Check item	Result	Setting item	Adjustment
Check the shape.	The cut shape is distorted.	[Cutting Speed]	Reduce
Peel off the circle.	The square also peels off.	[Blade Force]	Increase
	Some uncut areas remain.	[Cutting Speed]	Reduce
Peel off the square.	The blade leaves faint traces on the backing paper.	[Blade Force]	No change
	The blade trace is indistinct.		Increase
	The blade trace is too deep and cuts into the backing paper.		Reduce

Check item	Result		Setting item	Adjustment
Check the shape of the square you have peeled off.		The corners are not rounded and do not have "horns."	[Blade Offset]	No change
		The corners are rounded.		Increase
		The corners have "horns."		Reduce

9. **Tap − or + to change the settings.**

Setting item	Setting details	Default setting
[Blade Force]	Set the force (pressure) of the blade.	50 gf (0.11 lbf)
[Cutting Speed]	Set the speed of cutting.	30 cm/s (11.81 in./s)
[Blade Offset]	Set the blade offset. Enter the listed offset value for the blade. The offset value for the included blade is 0.250 mm (9.8 mil).	0.250 mm (9.84 mil)
[Rise Movement Speed]	Set the blade's up speed during cutting (the speed at which the blade travels when it moves to the next cutting line after cutting one cutting line). If the media comes loose during no-load feed and the blade damages the surface of the media, reduce the speed.	30 cm/s (11.81 in./s)

10. **Tap [Save].**

11. **To check the set values, tap [Execute] for [Cutting Test].**

The test pattern is cut on the left side.

12. **Check the results of the cutting test.**

If the two shapes are peeled off separately, a blade trace (red line) remains on the backing paper, and the backing paper is not cut, the adjustment is finished.

13. **Tap .**

You are returned to the home screen.

Adjusting the Amount of Blade Extension

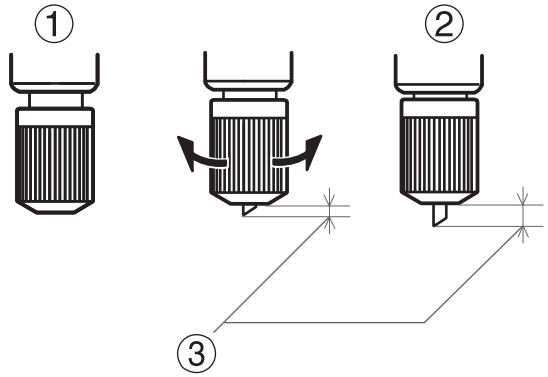
Adjustment When Not Cutting the Backing Paper (Normal Cut)

When you want to perform accurate and fine adjustment of the cutting-in amount, such as when cutting media with thin backing paper, you can obtain good results by adjusting the amount of blade extension (③).

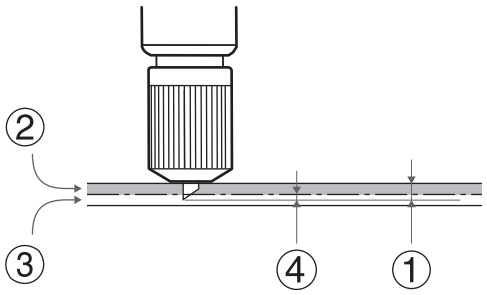
Turn the cap portion of the blade holder to adjust the amount of blade extension. Each indicator tick corresponds to 0.1 millimeters, and adjustment for 0.5 millimeters can be made by rotating the cap one full turn.

Note that making the amount of blade extension too small may cause the tip of the blade holder cap to touch the printed surface, soiling and damaging it. It is important to be especially careful about this when you are using media that has poor ink-adhesion properties.

The amount of blade extension (③) is 0 mm (0 in.) (①) at minimum and 2.5 mm (0.09 in.) (②) at maximum.



Set the amount of blade extension (①) to an amount that is the sum of the thickness of the media portion (②) and half (④) the thickness of the backing paper (③).



Adjustment when Cutting the Backing Paper (Perforated Cut)

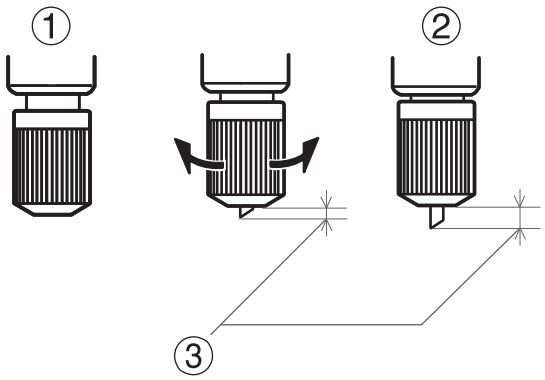
In cases when you want to cut out the printed part, or other cases when you want to cut through the backing paper, use perforated cutting.

IMPORTANT

This function specifies the location to perform perforated cutting in the print data, and performs cutting. This is different from the perforated sheet cutting that cuts to the backing paper at fixed intervals during sheet cutting used when separating the media.

Turn the cap portion of the blade holder to adjust the amount of blade extension. Each indicator tick corresponds to 0.1 mm (3.9 mil), and adjustment for 0.5 mm (19.7 mil) can be made by rotating the cap one full turn.

The amount of blade extension (③) is 0 mm (0 in.) (①) at minimum and 2.5 mm (0.09 in.) (②) at maximum.



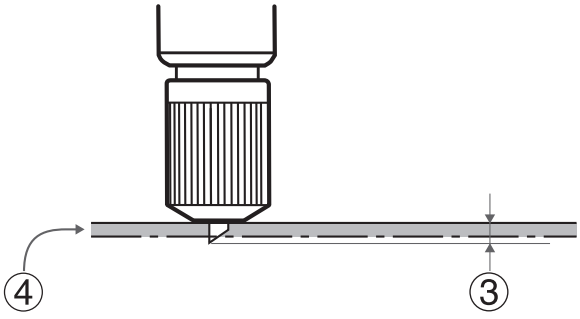
Set the amount of blade extension (③) so that when the cutter pierces the media (④), the blade extends slightly.

For information about the output settings for cutting perforated lines, refer to the documentation for VersaWorks.

https://downloadcenter.rolanddg.com/VersaWorks7

IMPORTANT

Pushing the blade out too far will damage the blade and blade protector and hasten their deterioration, so exercise caution.



Making Adjustments When Cutting the Print Surface

Hardened ink is thick. Therefore, the cutting conditions vary between cutting the printed surface and cutting parts that have not been printed on. When cutting the print surface, use this [**Printing for Cutting Test**] function to adjust the cutting conditions.

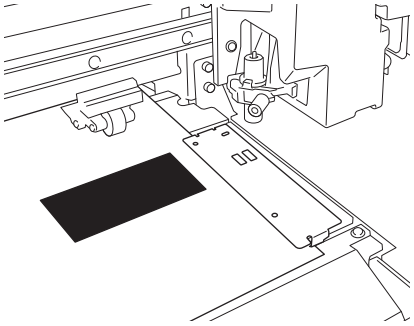
This adjustment is only an estimate. Accuracy is not assured.

1. Printing for Cutting Test and Performing the Cutting Test

Procedure

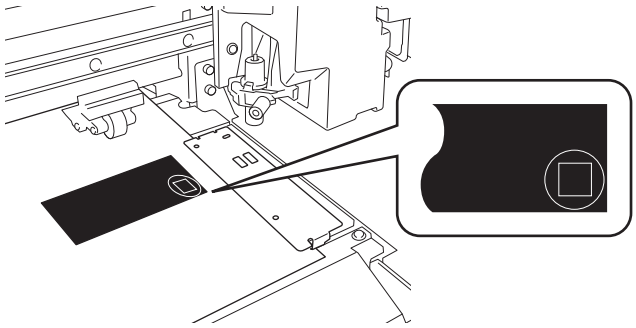
1. **Set up the media.**
2. **Tap** ☰.
3. **Tap [Media Settings]>[Cutting Settings]>[Blade Adjustment].**
4. **Tap [Execute] next to [Printing for Cutting Test].**

   A test pattern is printed.



5. **Tap [Execute] next to [Cutting Test].**

   The test pattern is cut.

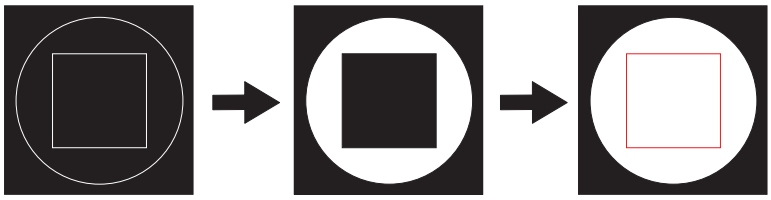


2. Checking the Results of the Cutting Test and Adjusting the Cutting Conditions

Procedure

1. Open the front cover.

2. Check the results of the cutting test.



Check item	Result		Setting item	Adjustment
Check the shape.	The cut shape is distorted.		[Cutting Speed]	Reduce
Peel off the circle.	The square also peels off.		[Blade Force]	Increase
	Some uncut areas remain.		[Cutting Speed]	Reduce
Peel off the square.	The blade leaves faint traces on the backing paper.		[Blade Force]	No change
	The blade trace is indistinct.			Increase
	The blade trace is too deep and cuts into the backing paper.			Reduce
Check the shape of the square you have peeled off.		The corners are not rounded and do not have "horns."	[Blade Offset]	No change
		The corners are rounded.		Increase
		The corners have "horns."		Reduce

3. Tap − or + to change the settings.

Display screen (cutting conditions)	Setting details	Default settings
[Blade Force]	Set the force (pressure) of the blade.	50 gf (0.11 lbf)
[Cutting Speed]	Set the speed of cutting.	30 cm/s (11.81 in./s)
[Blade Offset]	Set the blade offset. Enter the listed offset value for the blade. The offset value for the included blade is 0.250 mm (9.8 mil).	0.250 mm (9.84 mil)
[Rise Movement Speed]	Set the blade's up speed during cutting (the speed at which the blade travels when it moves to the next cutting line after cutting one cutting line). If the media comes loose during no-load feed and the blade damages the surface of the media, reduce the speed.	30 cm/s (11.81 in./s)

4. Tap [Save] to confirm your entry.

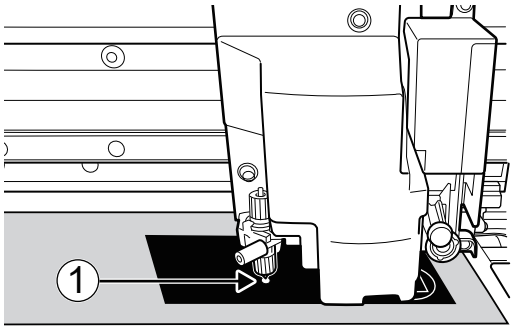
3. Checking the Adjustment Results

Procedure

1. **Tap [Execute] next to [Output Start Location].**

2. **Tap [^], [v], [<] or [>] to move the center of the blade to the position that you want to set as the base point.**

   Tap [^] or [v] to move the media. Tap [<] or [>] to move the cutting carriage.

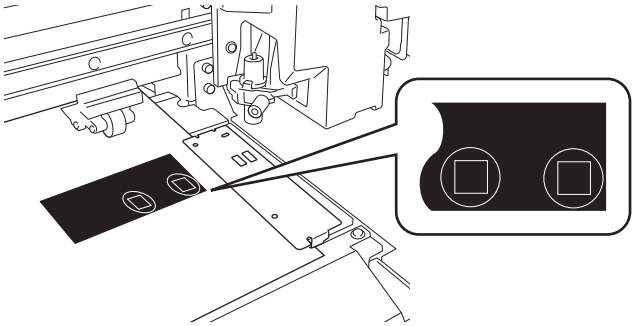
   - ①: Base point (right edge of the output area)

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

4. **Close the front cover.**

5. **Tap [Execute] next to [Cutting Test].**

   The test pattern is cut.

6. **Open the front cover.**

7. **Check the results of the cutting test again.**

8. **When you have finished making adjustments, tap [home].**

   The display returns to the original screen.

Performing Distance Correction during Cutting

This correction is performed when you want to accurately align the lengths of cut lines when cutting. This setting is applied to both cutting only and printing and cutting.

The movement distance of the media changes subtly depending on the media's thickness. This means that the length of a line when cut may differ from the length setting in the data.

Procedure

1. **Set up the media.**
2. **Tap .**
3. **Tap [Media Settings]>[Cutting Settings]>[Cutting Distance Correction].**
4. **Tap − or + to change the correction values.**

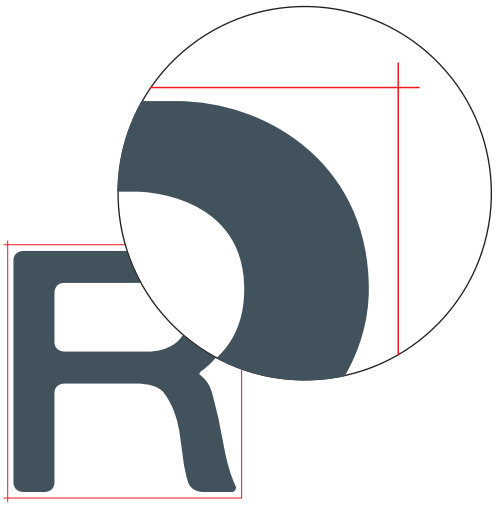
Setting item	Setting details	Default settings
[Correction Value (Feed)]	(correction value of media feed direction)	0.00%
[Correction Value (Scan)]	Correction value of the print-head carriage movement direction	0.00%

5. **Tap [Save] to confirm your entry.**
6. **Tap to return to the home screen.**

Cutting to Make It Possible to Cut Corners Attractively (Over Cut)

The corners of the border of the cutting line can be cut slightly longer so that the corners can be cut attractively.

This is effective when using laminated or thick media, or non-resilient media. It also has the effect of making stickers easier to peel off.

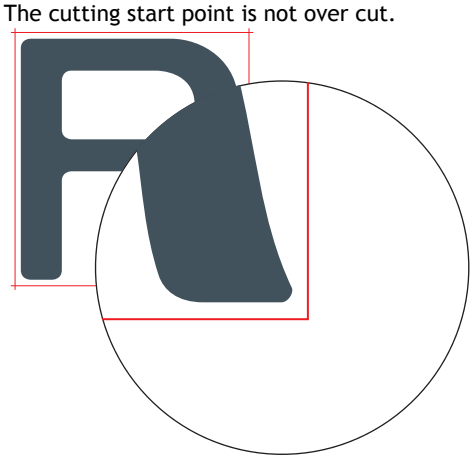


Procedure

1. Set up the media.
2. Tap .
3. Tap [Media Settings]>[Cutting Settings]>[Over Cut].
4. Tap [Enable].
5. Tap [Save] to confirm your entry.
6. Tap to return to the home screen.

MEMO

- Default setting: **[Disable]**
- The cutting start point is not over cut.



Prioritizing the Cutting Settings of This Machine over the RIP Software Settings

This setting is used to prioritize the cutting conditions set on the machine over the RIP software settings. Depending on the RIP software, you can also configure the settings for the cutting conditions, and normally the RIP software settings are given priority.

Procedure

1. Tap .
2. Tap [Preferences]>[Priority for Cutting Settings].
3. Select [Machine Priority].
4. Tap [Save] to confirm your entry.
5. Tap to return to the home screen.

MEMO

- Default setting: [Software RIP Priority]

Accurately Adjusting the Settings for Printing and Cutting

Correcting the Misalignment of Printing and Cutting

This is a correction method performed when printing followed immediately by cutting yields positioning for printing and cutting that is slightly misaligned.

Print alignment marks, perform detection of the printed marks, and then correct the discrepancy. Subtle misalignment between the printing and cutting positions may occur due to the thickness of the media or the print head height. We recommend that you make corrections to match the media you are using.

1. Adjusting the Misalignment of the Ink Landing Position

Procedure

1. **Set up the media to print and cut or to cut with crop marks.**
2. **Tap** ☰.
3. **Tap [Media Settings]>[Printing Settings]>[Media Gap Adjustment].**
4. **Select [Simple Correction (Auto)] and tap [Next].**
5. **Tap [Execute].**
   The test pattern is printed and the media gap is adjusted automatically.
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 ⌂.
   - If **[Failed]** is displayed on the operation panel, perform the procedure under Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)(P. 180).

2. Correcting the Misalignment of Printing and Cutting

Procedure

1. Tap .

2. **Tap [Media Settings]>[Cutting Settings]>[Print & Cut Position Adjustment].**

3. **Tap [Execute] next to [Printing Test 1 (Misalignment Check)].**

   Printing Test 1 is printed and cut. The test pattern is printed at each edge of the media.

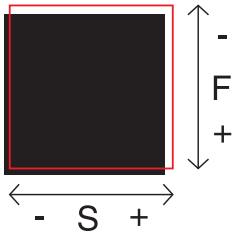
   MEMO

   If the media is tilted, the positions at the edges will be misaligned. You can also adjust for misalignments due to the media being tilted by printing the test pattern at each edge.

4. **Check the result of Printing Test 1.**

   Check whether the printing position (shaded part) and the cutting position (red line) are aligned. An example of the printing position and the cutting position being misaligned is shown in the following figure.

   [F] indicates the feed direction of the media (the feed direction) and [S] indicates the direction of print head carriage movement (the scan direction).

   If the printing position and the cutting position are aligned, no corrections are necessary. Proceed to step 10.

   If the printing position and the cutting position are not aligned, proceed to the next procedure.

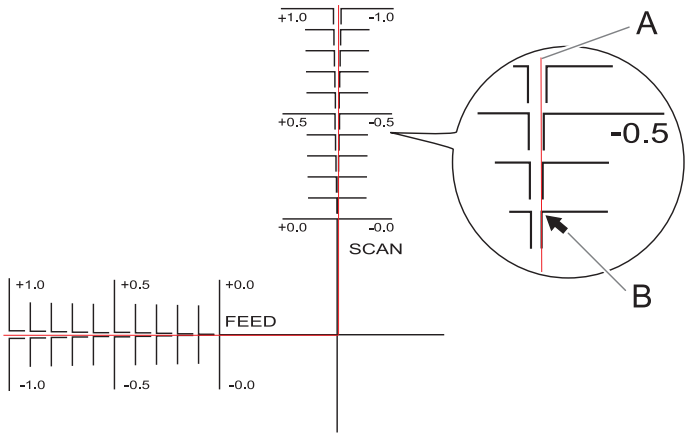
5. **Tap [Execute] next to [Printing Test 2 (Correction Values)].**

   Printing Test 2 is printed and cut.

6. **Check the correction values from the Printing Test 2 condition.**

   The point where the cutting line (A) intersects the correction-value scale (B) is the correction value. In the following figure, the correction value is "−0.3."

   Check the media feed direction (the feed direction) and the direction of print-head carriage movement (the scan direction).



7. **Set the correction values in the feed direction of the media (the feed direction) and the direction of print-head carriage movement (the scan direction).**

(1) **Tap − or + next to [Correction Value (Feed)] to set the correction value in the feed direction of the media (the feed direction).**

(2) **Tap − or + next to [Correction Value (Scan)] to set the correction value in the direction of print head carriage movement (the scan direction).**

8. **Tap [Save].**

The correction values are saved.

9. **Tap [Execute] next to [Printing Test 1 (Misalignment Check)].**

Printing Test 1 is printed and cut. If the printing and cutting lines are aligned, adjustment is complete. If further adjustment is needed, tap − or + next to [**Correction Value (Feed)**] and [**Correction Value (Scan)**] to fine-tune the printing and cutting position, and then [**Save**] the values.

MEMO

Default settings

- [**Correction Value (Feed)**] (correction value of the media feed direction): 0.00 mm
- [**Correction Value (Scan)**] (correction value of the print-head carriage movement direction): 0.00 mm

10. **Tap to return to the home screen.**

Correcting the Misalignment of the Printing and Cutting Positions during Cutting

This method pauses a cutting operation to correct the misalignment of the cutting positions (A) when this misalignment is found during cutting after printing. The correction values set here are applied to the media settings currently set up.



If the printing and cutting positions are misaligned, normally adjust the positions while checking a test pattern.

Procedure

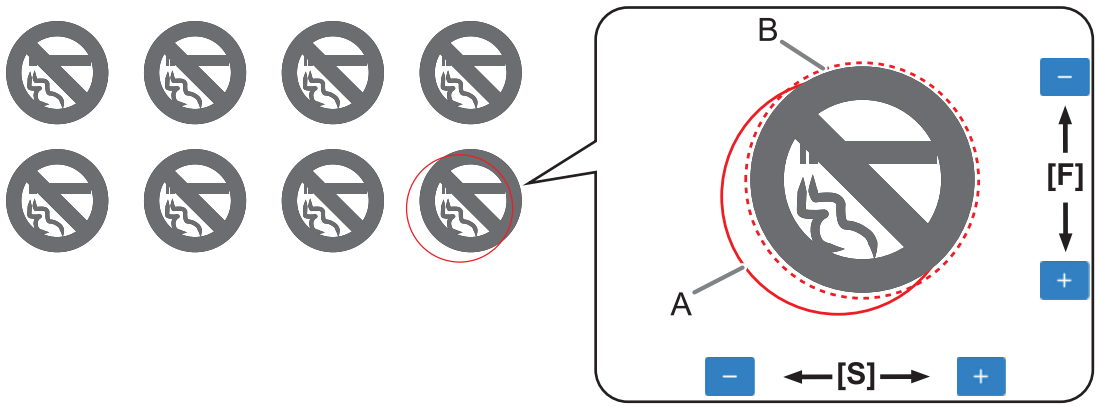
1. **During cutting, tap [Pause].**
   The cutting operation is paused.
2. **Tap ☰.**
3. **Tap [Media Settings]>[Cutting Settings]>[Print & Cut Position Adjustment].**
4. **Determine the correction value for the cutting position.**

MEMO

To decide a correction value

In the following figure, move the solid line (A), representing the current cutting position, to the dashed line (B).

[F] indicates the feed direction of the media (the feed direction) and [S] indicates the direction of print head carriage movement (the scan direction).



- **Media feed direction misaligned in the positive direction**

- Move the cutting position in the negative direction.

- **Print head carriage movement direction (the scan direction) is misaligned in the negative direction.**
  - Move the cutting position in the positive direction.

5. **Set the correction values in the feed direction of the media (the feed direction) and the direction of print-head carriage movement (the scan direction).**

(1) **Tap − or + next to [Correction Value (Feed)] to set the correction value in the feed direction of the media (the feed direction).**

(2) **Tap − or + next to [Correction Value (Scan)] to set the correction value in the direction of print head carriage movement (the scan direction).**

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

7. **Tap to return to the home screen.**

8. **Tap [Resume] to restart the cutting operation.**

Tap [**Cancel Output**] to cancel the cutting operation.

MEMO

Default settings

- [**Correction Value (Feed)**] (correction value of the media feed direction): 0.00 mm
- [**Correction Value (Scan)**] (correction value of the print-head carriage movement direction): 0.00 mm

RELATED LINKS

- P. 206 Correcting the Misalignment of Printing and Cutting

Accurately Adjusting the Settings for Cutting with Crop Marks

Correcting the Misalignment of Printing and Cutting with Crop Marks (Concurrent Test for Printing and Cutting with Crop Marks)

Depending on the composition of the media, the positioning of printing and cutting may be misaligned even when you are using crop marks. Make corrections for misaligned printing and cutting for the media you are using.

In cutting with crop marks, the media is removed after printing and then cut. However, with this method, you can make corrections of printing and cutting positions at the same time without removing the media.

1. Adjusting the Misalignment of the Ink Landing Position

Procedure

1. **Set up the media to print and cut or to cut with crop marks.**
2. **Tap** ☰.
3. **Tap [Media Settings]>[Printing Settings]>[Media Gap Adjustment].**
4. **Select [Simple Correction (Auto)] and tap [Next].**
5. **Tap [Execute].**
   The test pattern is printed and the media gap is adjusted automatically.
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 ⌂.
   - If **[Failed]** is displayed on the operation panel, perform the procedure under Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)(P. 180).

2. Correcting the Misalignment of Printing and Cutting with Crop Marks at the Same Time

Use the following procedure to print the crop marks and cut the media, checking for misalignment in the positions. In this section, the crop marks are printed simply, and then the crop marks are read and a cutting test is performed without removing the media. To simulate the actual process—printing crop marks, removing the media, and then performing post-processing such as laminating—before loading the media and checking for cutting position misalignment, turn on [**Separate Test for Printing/Cutting with Crop Marks**]. For more information, refer to Correcting the Misalignment of Printing and Cutting with Crop Marks (Separate Test for Printing and Cutting with Crop Marks)(P. 214).

Procedure

1. **Tap** .
2. **Tap [Media Settings]>[Cutting Settings]>[Crop Cut Position Adjustment].**
3. **Tap next to [Separate Test for Printing/Cutting with Crop Marks] to turn it off.**
4. **Tap [Execute] next to [Printing Test 1 (Misalignment Check)].**

   Printing Test 1 is printed and cut. One test pattern is printed on the media.

   IMPORTANT

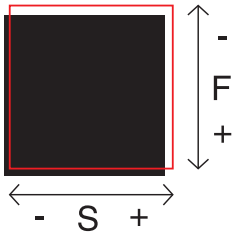
   Printing (crop marks) may not be readable with transparent media, silver or other light-reflective media, or black or other dark-colored media, which may prevent cutting from being performed. Try the following if [**Crop Mark Detection Error**] is displayed.

   - Are You Using Black Crop Marks with Transparent Media?(P. 330)
   - Are you using media that is likely to reflect light or has deep colors?(P. 330)

5. **Check Printing Test 1.**

   Check whether the printing position (shaded part) and the cutting position (red line) are aligned. An example of the printing position and the cutting position being misaligned is shown in the following figure.

   [**F**] indicates the feed direction of the media (the feed direction) and [**S**] indicates the direction of print head carriage movement (the scan direction).

   If the printing position and the cutting position are aligned, no corrections are necessary. Proceed to step 11.

   If the printing position and the cutting position are not aligned, proceed to the next procedure.

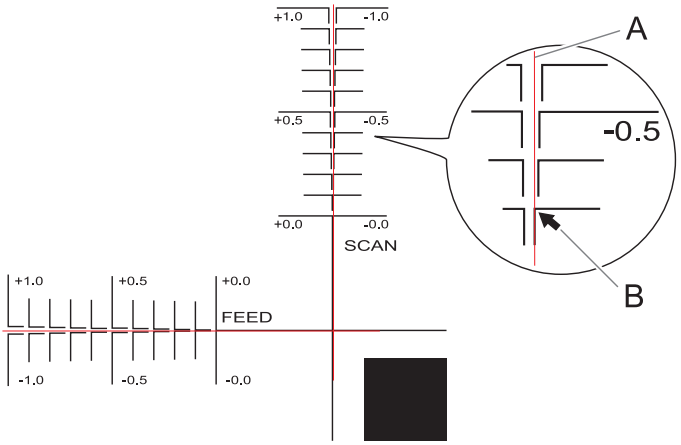
6. **Tap [Execute] next to [Printing Test 2 (Correction Values)].**

   Printing Test 2 is printed and cut.

7. **Check the correction values from the Printing Test 2 condition.**

The point where the cutting line (A) intersects the correction-value scale (B) is the correction value. In the following figure, the correction value is "−0.3."

Check the media feed direction (the feed direction) and the direction of print-head carriage movement (the scan direction).



8. **Set the correction values in the feed direction of the media (the feed direction) and the direction of print-head carriage movement (the scan direction).**

(1) **Tap − or + next to [Correction Value (Feed)] to set the correction value in the feed direction of the media (the feed direction).**

(2) **Tap − or + next to [Correction Value (Scan)] to set the correction value in the direction of print head carriage movement (the scan direction).**

9. **Tap [Save].**

The correction values are saved.

10. **Tap [Execute] next to [Printing Test 1 (Misalignment Check)].**

Printing Test 1 is printed and cut. If the printing and cutting lines are aligned, adjustment is complete. If further adjustment is needed, tap − or + next to [**Correction Value (Feed)**] and [**Correction Value (Scan)**] to fine-tune the printing and cutting position, and then [**Save**] the values.

MEMO

- Default settings
  [**Correction Value (Feed)**] (correction value of the media feed direction): 0.00 mm (0.00 in.)
  [**Correction Value (Scan)**] (correction value of the print-head carriage movement direction): 0.00 mm (0.00 in.)
- Depending on the changes in the condition of media caused by laminating and the loading position of the media before cutting, the positioning of cutting may be misaligned. In such cases, correct the misalignment of printing and cutting with crop marks.

11. **Tap to return to the home screen.**

RELATED LINKS

• P. 214 Correcting the Misalignment of Printing and Cutting with Crop Marks (Separate Test for Printing and Cutting with Crop Marks)

Correcting the Misalignment of Printing and Cutting with Crop Marks (Separate Test for Printing and Cutting with Crop Marks)

Due to changes in the thickness of media caused by laminating and misalignment of the loading position of the media before and after cutting, the positioning of printing and cutting may be misaligned even when you are using crop marks. Make corrections for misaligned printing and cutting for the media you are using and its condition.

In this test, so as to create the same conditions as the actual operation, print only the crop marks, remove the media, load the media again, and then cut the media.

MEMO

- The required pre-print margin for [**Separate Test for Printing/Cutting with Crop Marks**] is at least 75 mm (2.96 in.), and the required post-print margin is at least 130 mm (5.12 in.).

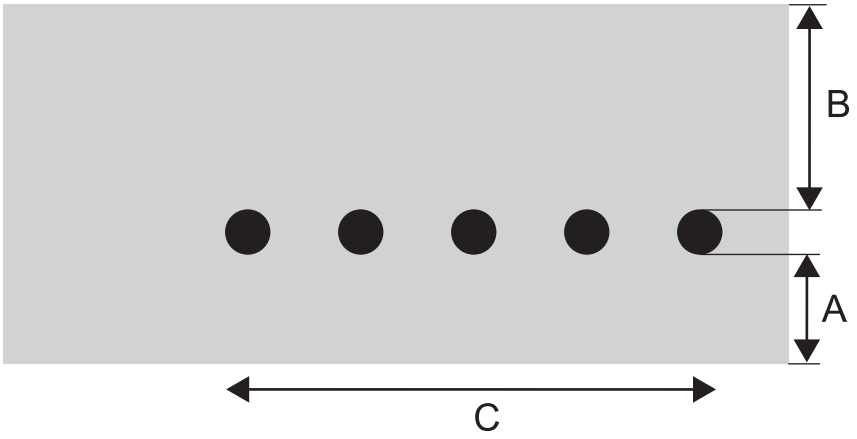
1. Adjusting the Misalignment of the Ink Landing Position

Procedure

1. **Set up the media to print and cut or to cut with crop marks.**
2. **Tap** ☰.
3. **Tap [Media Settings]>[Printing Settings]>[Media Gap Adjustment].**
4. **Select [Simple Correction (Auto)] and tap [Next].**
5. **Tap [Execute].**
   The test pattern is printed and the media gap is adjusted automatically.
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 ⌂.
   - If [**Failed**] is displayed on the operation panel, perform the procedure under Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)(P. 180).

2. Printing Only the Crop Marks

Print the following crop marks. A margin is required before and after each crop mark.



A	75 mm (2.95 in.)	B	130 mm (5.12 in.)	C	Approximately 120 mm (4.72 in.)

MEMO

You can also perform the procedure under Printing Crop Marks in White(P. 241).

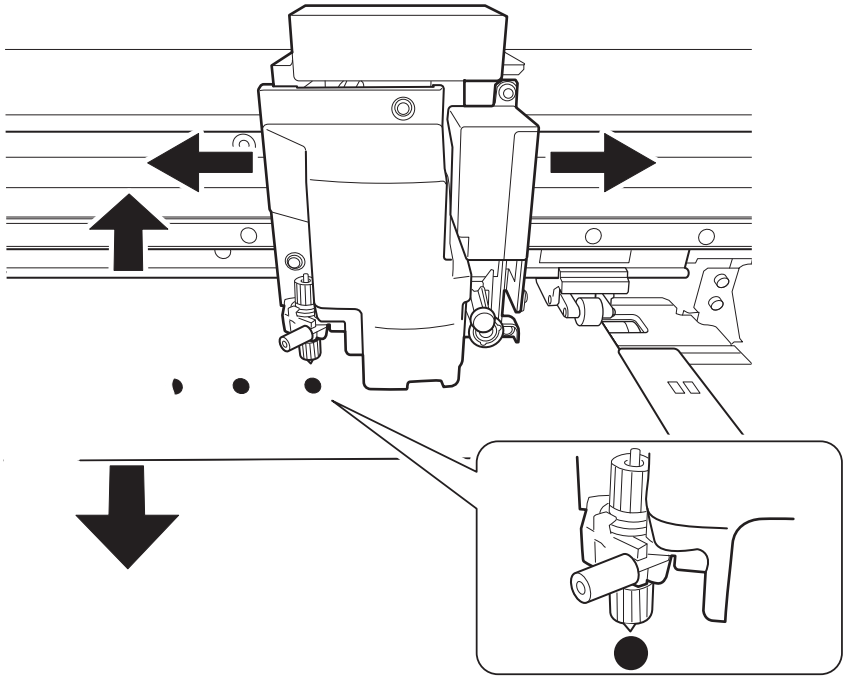
Procedure

1. **Take the margins into account and set the printing-start position.**
   P. 238 Changing the Base Point
2. **Tap ☰.**
3. **Tap [Media Settings]>[Cutting Settings]>[Crop Cut Position Adjustment].**
4. **Tap next to [Separate Test for Printing/Cutting with Crop Marks] to turn it on.**
5. **Tap [Execute] next to [Printing Test].**
   The crop marks are printed.
6. **Set the margins and separate the media.**
   P. 122 Separating the Media
7. **Laminate or otherwise process the separated media as necessary before the cutting output of cutting with crop marks.**

3. Performing a Cutting Test

Procedure

1. **Set up the media that has been laminated or otherwise processed before cutting with crop marks.**
2. **Tap** ☰.
3. **Tap [Media Settings]>[Cutting Settings]>[Crop Cut Position Adjustment].**
4. **Tap** ⬭ **next to [Separate Test for Printing/Cutting with Crop Marks] to turn it on.**
5. **Tap [Execute] next to [Cutting Test].**
   The [**Move the blade over a crop mark.**] screen appears.
6. **Tap** ^, **v**, **<**, **or** **>** **to move the center of the blade over the crop marks to use in the cutting test.**
   The center of the blade should only be over the crop marks, and does not need to be aligned with the center of the crop marks.



7. **Tap [Execute].**
   The cutting test starts.

IMPORTANT

Transparent media, light-reflective media, or dark-colored media may prevent the reading of crop marks, making it impossible to perform the cutting test. Try the following if [**Crop Mark Detection Error**] is displayed.

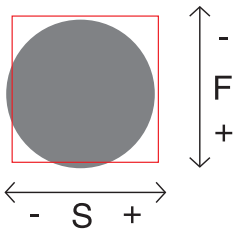
- Are You Using Black Crop Marks with Transparent Media?(P. 330)
- Are you using media that is likely to reflect light or has deep colors?(P. 330)

4. Setting the Correction Values

Procedure

1. View the results of the cutting test to determine the correction values.

Check whether the crop mark (shaded part) and the cutting position (red line) are aligned. An example of the crop mark and the cutting position being misaligned is shown in the following figure.



- If the test printed crop marks are inside the cutting line, correction is not necessary. Proceed to step 5.
- If the test printed crop marks are extending beyond the cutting line, correction is necessary.

[F] indicates the feed direction of the media (the feed direction) and [S] indicates the direction of print-head carriage movement (the scan direction). ("F," "S," "+," "−," and the arrows are not displayed on the actual test pattern.)

MEMO

Determine the values so as to correct the misalignment of the cutting position. In the case of the above figure, feed direction [F] is misaligned in a negative direction and scan direction [S] in a positive direction. Therefore, set the correction values for the feed direction [F] to positive values and the scan direction [S] to negative values. Measure the actual misalignment amount when determining the value.

2. Set the correction values in the feed direction of the media (the feed direction) and the direction of print-head carriage movement (the scan direction).

(1) **Tap − or + next to [Correction Value (Feed)] to set the correction value in the feed direction of the media (the feed direction).**

(2) **Tap − or + next to [Correction Value (Scan)] to set the correction value in the direction of print head carriage movement (the scan direction).**

3. Tap [Save].

4. Perform steps 5 to 7 of 3. Performing a Cutting Test(P. 216) again to check whether the correction was successful.

- If the test printed crop marks are inside the cutting line, correction is complete.
- If the test printed crop marks are extending beyond the cutting line, redo the correction.

5. Tap to return to the home screen.

MEMO

- Default settings
  [**Correction Value (Feed)**] (correction value of the media feed direction): 0.00 mm
  [**Correction Value (Scan)**] (correction value of the print-head carriage movement direction): 0.00 mm

- You can also make corrections of printing and cutting positions at the same time without removing the media.

RELATED LINKS

• P. 211 Correcting the Misalignment of Printing and Cutting with Crop Marks (Concurrent Test for Printing and Cutting with Crop Marks)

Correcting the Reading Sensor

Depending on the characteristics of the media, such as reflectivity and colors, the machine may not be able to read the media width. In such cases, correct the sensor for reading the media.

Procedure

1. **Set up the media.**
2. **Tap** .
3. **Tap [Media Settings]>[Other Media Settings]>[Multi Sensor Adjustment].**
4. **Tap [Execute].**
5. **Perform the operations shown below according to the [Adjustment Result].**
   - If [**Successful**] is displayed on the operation panel, proceed to the next procedure.
   - If [**Failed**] is displayed on the operation panel, the following causes are possible, so take countermeasures and redo [**Multi Sensor Adjustment**].

Cause	Countermeasures
The lighting in the room where the printer is installed or vicinity of the printer is too bright.	Adjust the lighting in the room.
Correction failed for some reason.	Redo [**Multi Sensor Adjustment**].
Crop marks cannot be recognized due to the characteristics (reflectivity and colors) of the media.	To cut with crop marks, try the following. • Are you using media that is likely to reflect light or has deep colors?(P. 330) • Are You Using Black Crop Marks with Transparent Media?(P. 330)
There is ink on the multi sensor because, for example, the media strikes it immediately after printing.	Contact your authorized dealer.

6. **Tap** .

   You are returned to the home screen.

Optimizing Work Efficiency

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Batch Settings for Output

This section explains how to change media settings as a batch during setup.

To ensure the optimal output according to the media size and type, you can configure various settings on this machine. However, it is hard work to configure these settings one at a time. Use [**Batch Media Settings**] to configure the absolute minimum of necessary items as a batch.

Note that you can set all the items set here individually as well.

To cancel the [**Batch Media Settings**] at any time, tap to return to the home screen.

Changing Media Settings in a Batch

Procedure

1. **Start the [Batch Media Settings].**

(1) **Set up the media whose settings you will change.**

(2) **Tap** .

(3) **Tap [Media Settings]>[Batch Media Settings].**

2. **Change the [Heater Temperature].**

If you will not change it, tap [**Save and Proceed**].

(1) **Check that [Heater Power] is turned on ( ).**

(2) **Tap** **or** **to change the [Front Heater] temperature.**

A temperature that is too high may degrade the media or cause it to wrinkle.

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

3. **Change the [Print Head Height].**

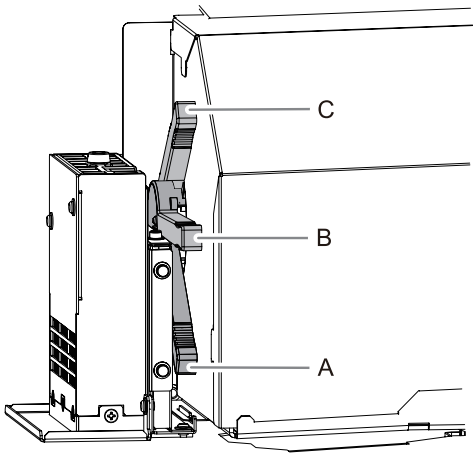
If you will not change it, tap [**Next**].

(1) **Tap [Change].**

The print head carriage moves to a position where they can be operated.

(2) **Open the front cover.**

(3) **Move the height-adjustment lever to change the print head height.**



Position	Operation panel display	Description
A	[Low]	Normally set the height-adjustment lever to [Low].
B	[Medium]	For media that is wrinkled or comes loose from the platen during printing, set the height-adjustment lever to [Medium].
C	[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].

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

4. **Change the [Media Suction Force].**

If you will not change it, tap [**Save and Proceed**].

(1) **Tap − or + to change the value.**

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

(2) **Tap [Save and Proceed].**

5. **Change the [Media Sticking Prevention].**

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.

If you will not change it, tap [**Save and Proceed**].

(1) **Select [Enable] or [Disable].**

(2) **Tap [Save and Proceed].**

6. **Change the [Middle Pinch Auto Raise/Lower].**

Change the setting that causes the middle pinch rollers to go up automatically during pullback printing or printing and cutting.

If you will not change it, tap [**Save and Proceed**].

(1) **Select [Enable] or [Disable].**

(2) **Tap [Save and Proceed].**

7. **Change the [Nozzle Drop-out Test]>[Output Start Location].**

If you will not change it, tap [**Next**].

(1) **Tap [Output Start Location]>[Change].**

(2) **Tap ‹.**

(3) **Tap ^, ˅, ‹ or › to move the center of the blade to the position that you want to set as the base point.**

(4) **Once the position has been decided, tap [Set Base Point Here].**

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

8. **Change the [Detailed Feed Correction (Manual)].**

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

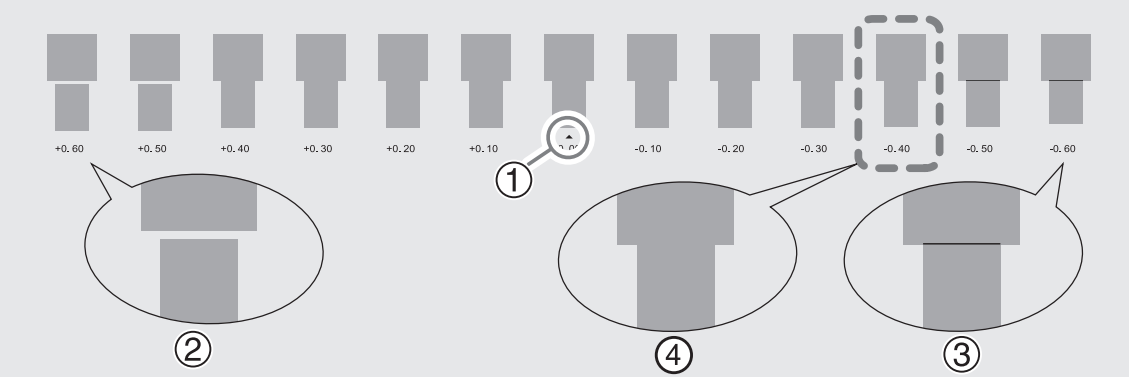
If you will not change it, tap [**Save and Proceed**].

(1) **Tap [Execute] next to [Printing Test].**

Printing of the test pattern starts.

(2) **Check the printed test pattern, and then tap − or + to change the correction value.**

The current correction value ① is that of the figure indicated by "▲." Select the value to make the gap ② and overlap ③ between the upper/lower squares smallest. In the case of the following figure, select "−0.40." (④). 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.

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

The entered correction value is saved.

(4) **Tap [Execute] next to [Printing Test].**

The test pattern is printed again.

(5) **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.

(6) **When you have successfully performed the correction, tap [Save and Proceed].**

9. Change the [Detailed Media Gap Adjustment (Manual)].

This adjusts the landing position of the ink discharged from the print heads.

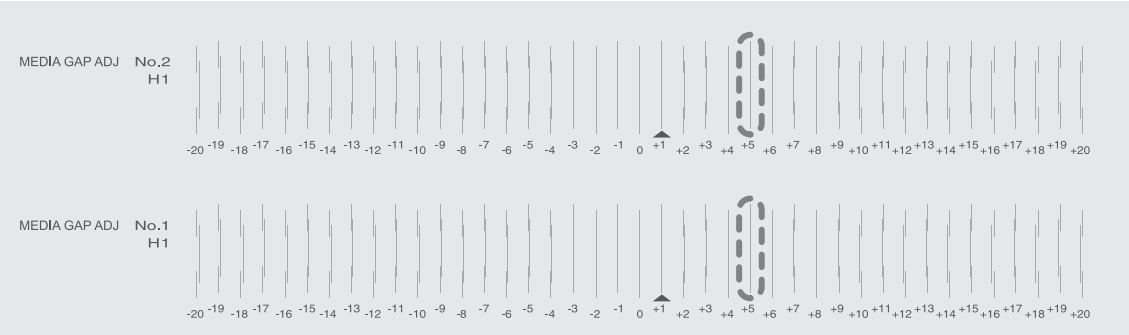
If you will not change it, tap [**Save and Proceed**].

(1) **Tap [Execute] next to [Printing Test].**

Printing of the test pattern starts.

(2) **Check the printed test pattern, and then tap − or + to change the No. 1 and No. 2 H1 correction values.**

Select the value that gives the least misalignment between the three lines. In the case of the following figure, select "+5" for H1 of No. 1 and 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.

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

The entered correction values are saved.

(4) **Tap [Printing Test]>[Execute].**

The test pattern is printed again.

(5) **Check the test pattern to see whether the correction was successful.**

For all the correction values, check that the misalignment is minimized for the three 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.

(6) **When you have successfully performed the correction, tap [Save and Proceed].**

10. Configure the [Blade Adjustment].

You can accurately set items such as the blade force, movement speed, and blade offset to match the nature of the media and the shape to cut.

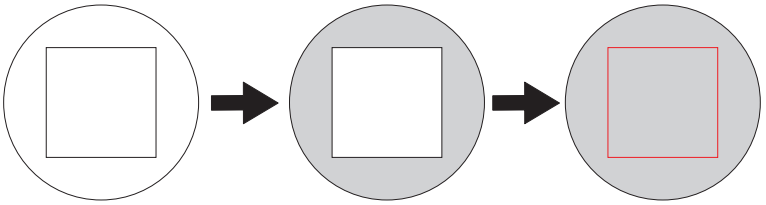
If you will not make adjustments, tap [**Save and Proceed**].

(1) **Tap [Execute] next to [Cutting Test].**

The test pattern is cut.

(2) **Check the results of the cutting test.**

Check that the two shapes are peeled off separately, a blade trace (red line) remains on the backing paper, and the backing paper is not cut.



Check item	Result	Setting item	Adjustment
Check the shape.	The cut shape is distorted.	[Cutting Speed]	Reduce
Peel off the circle.	The square also peels off.	[Blade Force]	Increase
	Some uncut areas remain.	[Cutting Speed]	Reduce

Check item	Result		Setting item	Adjustment
Peel off the square.	The blade leaves faint traces on the backing paper.		[Blade Force]	No change
	The blade trace is indistinct.			Increase
	The blade trace is too deep and cuts into the backing paper.			Reduce
Check the shape of the square you have peeled off.		The corners are not rounded and do not have "horns."	[Blade Offset]	No change
		The corners are rounded.		Increase
		The corners have "horns."		Reduce

(3) **Tap − or + to change the settings.**

Setting item	Setting details	Default setting
[Blade Force]	Set the force (pressure) of the blade.	50 gf (0.11 lbf)
[Cutting Speed]	Set the speed of cutting.	30 cm/s (11.81 in./s)
[Blade Offset]	Set the blade offset. Enter the listed offset value for the blade. The offset value for the included blade is 0.250 mm (9.8 mil).	0.250 mm (9.84 mil)
[Rise Movement Speed]	Set the blade's up speed during cutting (the speed at which the blade travels when it moves to the next cutting line after cutting one cutting line). If the media comes loose during no-load feed and the blade damages the surface of the media, reduce the speed.	30 cm/s (11.81 in./s)

(4) **Repeat the cutting test and adjustment to obtain optimal values.**

(5) **Tap [Save and Proceed].**

11. Configure the [Multi Sensor Adjustment].

Depending on the characteristics of the media, such as reflectivity and colors, the machine may not be able to read the media width. In such cases, correct the sensor for reading the media.

If you will not make adjustments, tap [**Next**].

(1) **Tap [Execute].**

(2) **Perform the operations shown below according to the [Adjustment Result].**

- If [**Successful**] is displayed on the operation panel, proceed to the next procedure.
- If [**Failed**] is displayed on the operation panel, the following causes are possible, so take countermeasures and redo [**Multi Sensor Adjustment**].

Cause	Countermeasures
The lighting in the room where the printer is installed or vicinity of the printer is too bright.	Adjust the lighting in the room.
Correction failed for some reason.	Redo [**Multi Sensor Adjustment**].

Cause	Countermeasures
Crop marks cannot be recognized due to the characteristics (reflectivity and colors) of the media.	To cut with crop marks, try the following. • Are you using media that is likely to reflect light or has deep colors?(P. 330) • Are You Using Black Crop Marks with Transparent Media?(P. 330)
There is ink on the multi sensor because, for example, the media strikes it immediately after printing.	Contact your authorized dealer.

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

12. Configure the [Print & Cut Position Adjustment].

This is a correction method performed when printing followed immediately by cutting yields positioning for printing and cutting that is slightly misaligned.

If you will not make adjustments, tap [**Save and Proceed**].

(1) **Tap [Execute] next to [Printing Test 1 (Misalignment Check)].**

Printing Test 1 is printed and cut. The test pattern is printed at each edge of the media.

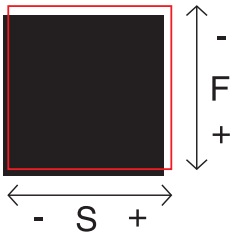
MEMO

If the media is tilted, the positions at the edges will be misaligned. You can also adjust for misalignments due to the media being tilted by printing the test pattern at each edge.

(2) **Check the result of Printing Test 1.**

Check whether the printing position (shaded part) and the cutting position (red line) are aligned. An example of the printing position and the cutting position being misaligned is shown in the following figure.

[**F**] indicates the feed direction of the media (the feed direction) and [**S**] indicates the direction of print head carriage movement (the scan direction).



If the printing position and the cutting position are aligned, no corrections are necessary. Tap [**Save and Proceed**].

If the printing position and the cutting position are not aligned, proceed to the next procedure.

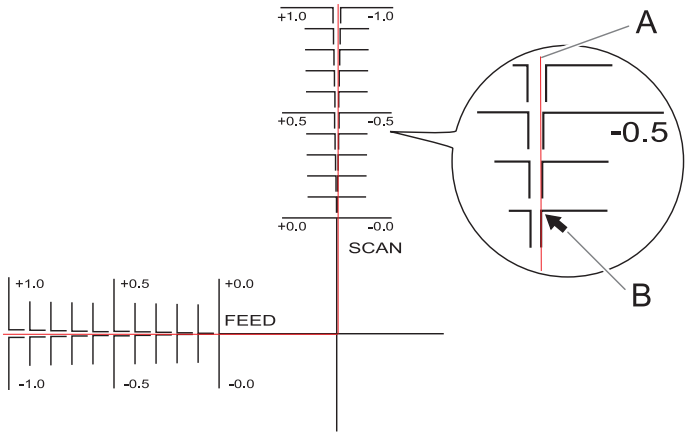
(3) **Tap [Execute] next to [Printing Test 2 (Correction Values)].**

Printing Test 2 is printed and cut.

(4) **Check the correction values from the Printing Test 2 condition.**

The point where the cutting line (A) intersects the correction-value scale (B) is the correction value. In the following figure, the correction value is "−0.3."

Check the media feed direction (the feed direction) and the direction of print-head carriage movement (the scan direction).



(5) **Set the correction values in the feed direction of the media (the feed direction) and the direction of print-head carriage movement (the scan direction).**

i. Tap − or + next to [**Correction Value (Feed)**] to set the correction value in the feed direction of the media (the feed direction).

ii. Tap − or + next to [**Correction Value (Scan)**] to set the correction value in the direction of print head carriage movement (the scan direction).

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

The correction values are saved.

(7) **Tap [Execute] next to [Printing Test 1 (Misalignment Check)].**

Printing Test 1 is printed and cut. If the printing and cutting lines are aligned, adjustment is complete. If further adjustment is needed, tap − or + next to [**Correction Value (Feed)**] and [**Correction Value (Scan)**] to fine-tune the printing and cutting position, and then [**Save**] the values.

(8) **Tap [Save and Proceed].**

13. Configure the [Crop Cut Position Adjustment].

Use the following procedure to print the crop marks and cut the media, checking for misalignment in the positions. In this section, a cutting test is performed after the crop marks are printed, without removing the media.

So as to create the same conditions as the actual operation, you can also perform a [**Separate Test for Printing/Cutting with Crop Marks**] in which you print only the crop marks, remove the media, load the media again, and then cut the media. For information on this setting method, refer to Correcting the Misalignment of Printing and Cutting with Crop Marks (Separate Test for Printing and Cutting with Crop Marks)(P. 214).

If you will not make adjustments, tap [**Save and Proceed**].

(1) **Tap next to [Separate Test for Printing/Cutting with Crop Marks] to turn it off.**

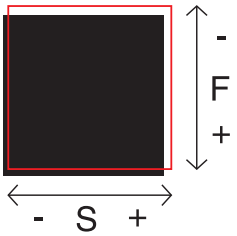
(2) **Tap [Execute] next to [Printing Test 1 (Misalignment Check)].**

Printing Test 1 is printed and cut. One test pattern is printed on the media.

(3) **Check Printing Test 1.**

Check whether the printing position (shaded part) and the cutting position (red line) are aligned. An example of the printing position and the cutting position being misaligned is shown in the following figure.

[**F**] indicates the feed direction of the media (the feed direction) and [**S**] indicates the direction of print head carriage movement (the scan direction).



If the printing position and the cutting position are aligned, no corrections are necessary. Tap [**Save and Proceed**].

If the printing position and the cutting position are not aligned, proceed to the next procedure.

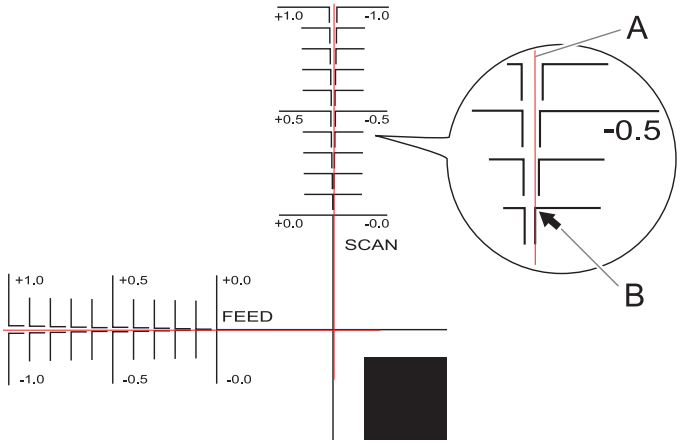
(4) **Tap [Execute] next to [Printing Test 2 (Correction Values)].**

Printing Test 2 is printed and cut.

(5) **Check the correction values from the Printing Test 2 condition.**

The point where the cutting line (A) intersects the correction-value scale (B) is the correction value. In the following figure, the correction value is "−0.3."

Check the media feed direction (the feed direction) and the direction of print-head carriage movement (the scan direction).



(6) **Set the correction values in the feed direction of the media (the feed direction) and the direction of print-head carriage movement (the scan direction).**

i. Tap − or + next to [**Correction Value (Feed)**] to set the correction value in the feed direction of the media (the feed direction).

ii. Tap − or + next to [**Correction Value (Scan)**] to set the correction value in the direction of print head carriage movement (the scan direction).

iii. Tap [**Save**].

The correction values are saved.

(7) **Tap [Execute] next to [Printing Test 1 (Misalignment Check)].**

Printing Test 1 is printed and cut. If the printing and cutting lines are aligned, adjustment is complete. If further adjustment is needed, tap − or + next to [**Correction Value (Feed)**] and [**Correction Value (Scan)**] to fine-tune the printing and cutting position, and then [**Save**] the values.

(8) **Tap [Save and Proceed].**

14. **Change the [Over Cut].**

Set it to [**Enable**] to allow the corners of the border of the cutting line to be cut slightly longer so that the corners can be cut attractively.

If you will not change it, tap [**Save and Proceed**].

(1) **Tap [Enable] or [Disable].**

(2) **Tap [Save and Proceed].**

15. **Change the [Printing Movement Range].**

This shortens output time by reducing the width of print-head carriage movement to the minimum necessary. This is effective when the width of the media or the output data is narrow.

If you will not change it, tap [**Save and Exit**].

(1) **Specify the range of print-head carriage movement during printing.**

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

(2) **Tap [Save and Exit].**

16. **Tap**  **.**

You are returned to the home screen.

Managing the Media Settings

Checking the Settings of Registered Media

Follow the procedure below to check the settings of registered media. After checking these settings, to change them, refer to Changing the Settings of Registered Media(P. 232).

Procedure

1. Tap .
2. Tap [Media Management].
   The registered media 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. 182 Changing the Print Head Height
[Feed Correction]	P. 178 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)
[Media Gap Adjustment]	P. 180 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)
[Blade Adjustment]	P. 196 Fine-tuning the Cutting Conditions
[Print & Cut Position Adjustment]	P. 206 Correcting the Misalignment of Printing and Cutting
[Crop Cut Position Adjustment]	P. 211 Correcting the Misalignment of Printing and Cutting with Crop Marks (Concurrent Test for Printing and Cutting with Crop Marks) P. 214 Correcting the Misalignment of Printing and Cutting with Crop Marks (Separate Test for Printing and Cutting with Crop Marks)
[Over Cut]	P. 204 Cutting to Make It Possible to Cut Corners Attractively (Over Cut)
[Heater Temperature]	P. 195 Setting the Front Heater Temperature
[Multi Sensor Adjustment]	P. 219 Correcting the Reading Sensor
[Media Suction Force]	P. 184 Using Media That Wrinkles Easily/Does Not Move Smoothly
[Printing Movement Range]	P. 240 Reducing the Output Time for Narrow Media
[Middle Pinch Auto Raise/Lower]	P. 192 Use Middle Pinch Rollers When Pulling Back or Feeding Media
[Media Sticking Prevention]	P. 185 Using Sticky Media

5. Tap .

   You are returned to the home screen.

Changing the Settings of Registered Media

Follow the procedure below to change the media settings of registered media. These settings can only be changed for the media being set up.

You can also perform the procedure under Changing Media Settings in a Batch(P. 221).

Procedure

1. **Set up the media whose settings you will change.**
2. **Tap** ☰.
3. **[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. 182 Changing the Print Head Height
[Feed Correction]	P. 178 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)
[Media Gap Adjustment]	P. 180 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)
[Blade Adjustment]	P. 196 Fine-tuning the Cutting Conditions
[Print & Cut Position Adjustment]	P. 206 Correcting the Misalignment of Printing and Cutting
[Crop Cut Position Adjustment]	P. 211 Correcting the Misalignment of Printing and Cutting with Crop Marks (Concurrent Test for Printing and Cutting with Crop Marks) P. 214 Correcting the Misalignment of Printing and Cutting with Crop Marks (Separate Test for Printing and Cutting with Crop Marks)
[Over Cut]	P. 204 Cutting to Make It Possible to Cut Corners Attractively (Over Cut)
[Heater Temperature]	P. 195 Setting the Front Heater Temperature
[Multi Sensor Adjustment]	P. 219 Correcting the Reading Sensor
[Media Suction Force]	P. 184 Using Media That Wrinkles Easily/Does Not Move Smoothly
[Printing Movement Range]	P. 240 Reducing the Output Time for Narrow Media
[Middle Pinch Auto Raise/Lower]	P. 192 Use Middle Pinch Rollers When Pulling Back or Feeding Media
[Media Sticking Prevention]	P. 185 Using Sticky Media

5. **If you have changed a setting, tap [Save].**

6. Tap .

   You are returned to the home screen.

Changing the Name of Registered Media

Procedure

1. Tap .
2. Tap [Media Management].
   The registered media 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.
6. Tap [OK] to confirm your entry.
7. Tap .
   You are returned to the home screen.

Duplicating Registered Media

Follow the procedure below to duplicate the media settings of registered media.

Procedure

1. **Tap** .
2. **Tap [Media Management].**
   The registered media are displayed in a list.
3. **Tap the media 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** .
   You are returned to the home screen.

Duplicating Media Settings for Cutting

Follow the procedure below to duplicate the media settings of registered media for cutting.

Procedure

1. Tap .
2. **Tap [Media Management].**
   The registered media are displayed in a list.
3. **Tap the media to duplicate.**
4. **Tap [Duplicate as Media for Cutting].**
   - 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.
   - The media setting is duplicated with the settings configured so the heater power is off.
5. **Enter the media name and tap [OK].**
6. Tap .
   You are returned to the home screen.

Deleting Registered Media

This deletes registered media.

MEMO

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

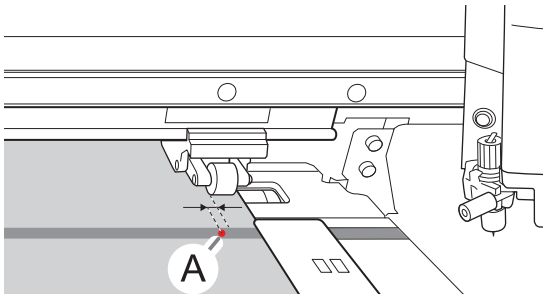
Procedure

1. **Tap** ☰.
2. **Tap [Media Management].**
   The registered media 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** ⌂.
   You are returned to the home screen.

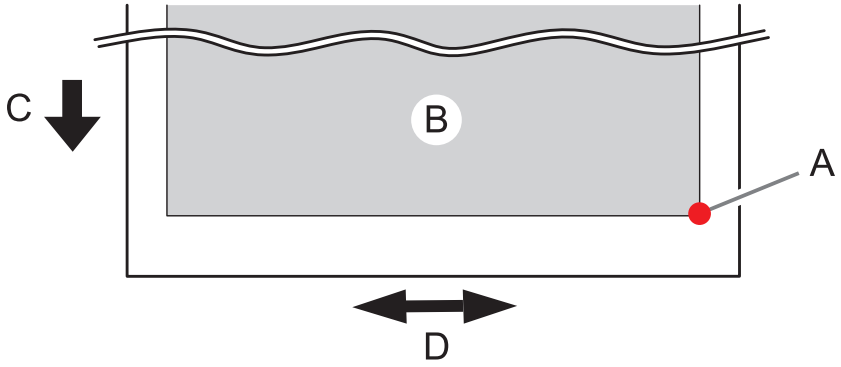
Adjusting the Output-start Location

Changing the Base Point

When you set up media, the base point (A) is set to the blade protector position in the feed direction and to approximately 2 mm (0.08 in.) to the left of the left edge of the right pinch roller in the scan direction (this is the initial state).



The base point (A) indicates the right edge of the printing area (B). (C: media feed direction, D: print-head carriage movement direction) You can change the base point to print on the targeted location, enabling you to use media without being wasteful.



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

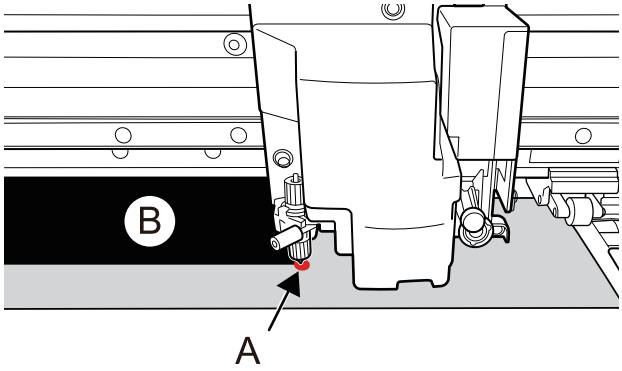
MEMO

Performing Printing Tests Arranged Horizontally(P. 244) is possible with printing tests. When you select **[Feed]**, the position moves in the feed direction to match the printing test size, but the set position is maintained in the scan direction.

Procedure

1. **Set up the media.**
2. **Tap [Move] on the home screen.**
   The [Move] screen appears.
3. **Tap .**
   The cutting carriage moves to the current base point.
4. **Tap and move the cutter center to the position where you want to start cutting.**

Tap [^] or [v] to move the media in the feed direction (forward-back). Tap [<] or [>] to move the cutting carriage in the scan direction (left-right).



- A: Base point (right edge of the printing area)
- B: Printing area

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

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

MEMO

The base point setting icon (Base) is displayed on the home screen to indicate that the base point position has been updated.

Reducing Output Time

Reducing the Output Time for Narrow Media

This shortens output time by reducing the width of print-head carriage movement to the minimum necessary. This is effective when the width of the media or the output data is narrow.

Procedure

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

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

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

   You are returned to the home screen.

MEMO

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

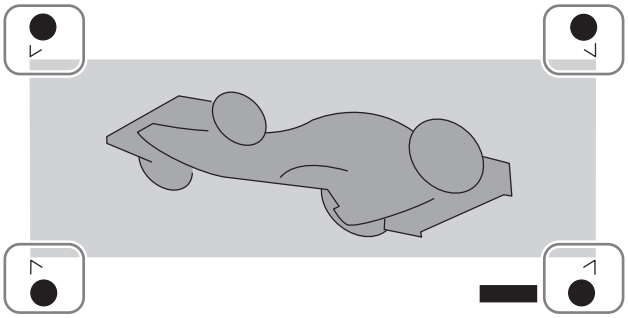
Printing with Crop Marks

Use your RIP software to configure the settings for printing crop marks. For information on how to configure the settings, refer to the documentation for the RIP software you are using.

IMPORTANT

Alignment marks and symbols drawn using graphics software cannot be used as crop marks.

When using VersaWorks, the crop marks are printed as shown in the figure.



Printing Crop Marks in White

When using transparent media or dark-colored media and cutting it with crop marks, follow the procedure below to print the crop marks in white.

Procedure

1. **Set up the media.**
2. **Tap** ☰.
3. **Tap [Media Settings]>[Cutting Settings]>[Crop Cut Position Adjustment].**
4. **Tap [Crop Mark Color].**
5. **Tap [White].**
6. **Tap [Save] to confirm your entry.**
7. **Tap** ⌂.

   You are returned to the home screen.

   MEMO

   - Default setting: **[Black]**

Perform How to Cut with Crop Marks(P. 161).

Managing VersaWorks Jobs

Outputting a Job from the Operation Panel

Follow the procedure below to operate VersaWorks from the operation panel and output a job. This **[Direct Printing]** is performed via Roland DG Connect Hub. The following conditions must be met.

- The Roland DG Connect Hub version is 3.2.6 or later.
- You are signed in to Roland DG Connect.
- Roland DG Connect Hub and VersaWorks are running.

Procedure

1. **Set up the media.**
2. **Tap** .
3. **Tap [Job Management]>[Direct Printing].**

   The list of computer names (the names of computers on which VersaWorks is installed and that have been set in Connect Hub) is displayed.
4. **Tap the name of the target computer.**

   A list of the queue folders is displayed.
5. **Tap the desired queue folder.**

   The job list is displayed.

   Tap to update the job and get the latest job status information.
6. **Tap the job to output.**
7. **Tap** .
8. **Enter the print count.**

   MEMO

   The print count is output with the print count set in VersaWorks as a unit of one.
   If the print count in VersaWorks is set to two times, the actual output count according to the instructions on the operation panel is as follows.
   - With "One time" specified on the operation panel: The print count is output twice.
   - With "Two times" specified on the operation panel: The print count is output four times.
9. **Tap [Execute].**

   The job is output.

Displaying the [Printing Log]

Displays [**Printing Log**].

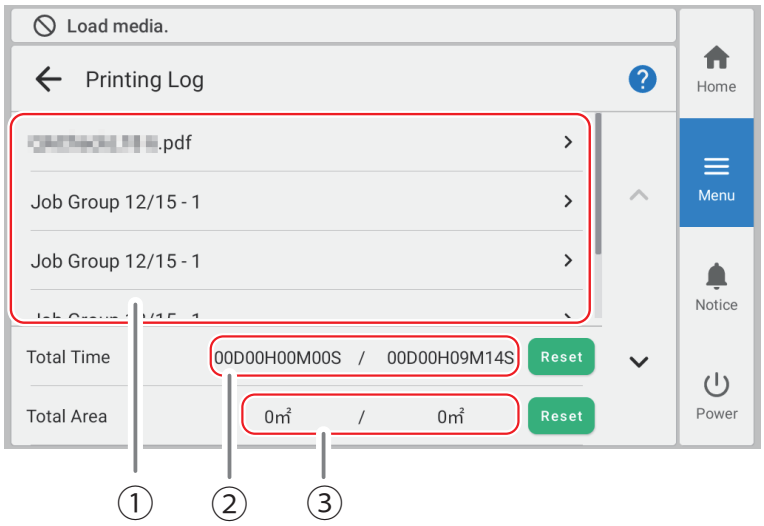
You can check the [**Job Properties**] for the last five jobs. You can also check the [**Total Time**] and [**Total Area**] for jobs (excluding cutting jobs).

Procedure

1. **Tap** ☰.

2. **Tap [Job Management]>[Printing Log].**

   The following screen appears.



①	**[Printing Log]** The names of the last five jobs are displayed. Tap a job name to display the detailed job log.
②	**[Total Time]** The left side is the trip printing time, and the right side is the total printing time. • The trip printing time is the time after [**Reset**]. You can check the printing time for any period of time, such as daily or weekly. Tap [**Reset**] when you wish to start measurement. • The total shows the cumulative printing time. This function cannot be reset.
③	**[Total Area]** The left side is the trip printing area, and the right side is the total printing area. • The trip printing area is the area after [**Reset**]. You can check the printing area for any period of time, such as daily or weekly. Tap [**Reset**] when you wish to start measurement. • The total shows the cumulative printing area. This function cannot be reset.

3. **To check the [Job Properties] of a job, tap its name.**

   The [**Job Properties**] appears.

4. **Tap** ⌂.

   You are returned to the home screen.

Other Useful Functions

Performing Printing Tests Arranged Horizontally

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

Procedure

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

   You are returned to the home screen.

MEMO

- Default setting: [**Feed**]

Changing the Operation Panel Color Theme

Follow the procedure below to change the operation panel color scheme to [**Dark**] or [**Light**].

Procedure

1. **Tap** ☰.
2. **Tap [System Information]>[Appearance].**
3. **Select [Dark] or [Light].**
4. **Tap [Save] to confirm your entry.**
   You are returned to the home screen.

MEMO

Default setting: [**Light**]

Displaying the 2D Code for Viewing the Manual on the Operation Panel

Displays the 2D code for accessing the website for viewing manuals.

Procedure

1. Tap .
2. **Tap [System Information]>[2D Codes]>[User's Manual].**
   The 2D code is displayed. Read the 2D code with a terminal equipped with a 2D code reader to access the website listing the manuals for this model.
3. **Tap [OK].**
4. Tap .
   You are returned to the home screen.

Displaying the Roland DG Connect 2D Code on the Operation Panel

Follow the procedure below to display the 2D code for accessing [**Roland DG Connect**].

Procedure

1. Tap .
2. **Tap [System Information]>[2D Codes]>[Roland DG Connect].**
   The 2D code is displayed. Read the 2D code with a terminal equipped with a 2D code reader to access the [**Roland DG Connect**] website.
3. **Tap [OK].**
4. Tap .
   You are returned to the home screen.

Optimizing Operation Management

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Managing the Operations Appropriately and Efficiently

Sounding a Buzzer to Notify the User of the End of Printing

Follow the procedure below to configure the settings so that the user is notified of the end of printing with a buzzer.

Procedure

1. Tap .
2. Tap [Preferences]>[Sound at End of Printing].
3. Tap [On].
4. Tap [Save] to confirm your entry.
5. Tap .

   You are returned to the home screen.

MEMO

- Default setting: [Off]

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 manual cleaning and mix the ink will also be displayed at appropriate times.

Procedure

1. Tap .
2. Tap [System Information]>[Date/Time].
3. Tap − or + to set the date and time.
4. Tap [Save] to confirm your entry.
5. Tap to return to the home screen.

Checking the Remaining Media

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

If you remove the media or cancel media loading by raising the loading lever, the amount remaining at that time flashes on the screen. Because the amount of media remaining is not updated automatically when you change the media, redo the setting whenever you change the media. You can also set the machine to display this menu automatically whenever you change the media.

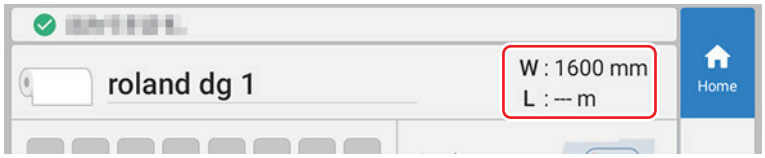
MEMO

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.**



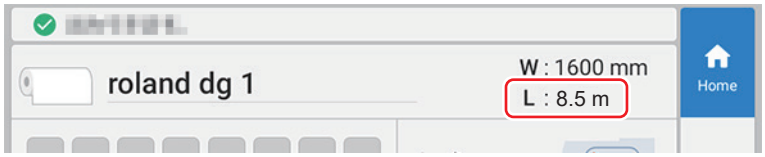
The [**Remaining Media Management**] screen appears.

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

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

5. **Tap** .

The amount of remaining media that you entered is displayed on the home screen.



Printing the Amount of Remaining Media

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

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

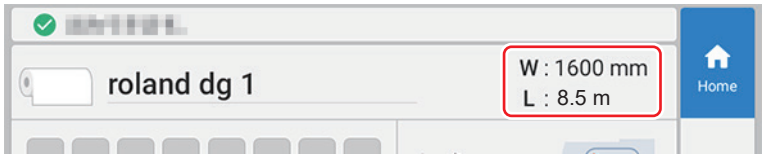
Note, however, that if you continue printing, the next printing operation will start on top of the portion where the amount of remaining media is printed. If you want to continue printing, separate the media before starting the next printing operation.

Procedure

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

   If it is not, set the amount of remaining media by referring to Checking the Remaining Media(P. 251).

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

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

3. **Tap [Execute] next to [Printing Remaining Media Amount].**

   The amount of remaining media is printed.

4. **Tap** .

   You are returned to the home screen.

Showing/Hiding Notifications

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

- **[Ink Mixing Notification]**
- **[Middle Pinch Roller Placement Notification]**
- **[Media Clamp Placement Notification]**
- **[Ink Expiration Date Notification]**

Procedure

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

	Displayed notification	Description
[Ink Mixing Notification][*1]	**[The time for ink mixing has arrived.]**	Prompts you to mix the ink cartridge to prevent ink precipitation. When this is on, a message recommending mixing the ink is displayed once a day.
[Middle Pinch Roller Placement Notification]	**[Place the middle pinch rollers over all the grit rollers.]**	Prompts you to use the middle pinch rollers, improving media feeding accuracy and preventing the media from coming loose. When this is on, the message appears when the middle pinch rollers have not been placed.
[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 this is on, the message appears when the media clamps are not placed appropriately 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.
[Ink Expiration Date Notification]	**[There is ink that has expired.]**	Ink has expired. Replace the ink as soon as possible.

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

   You are returned to the home screen.

MEMO

Default setting:

- **[Ink Mixing Notification]**: On[*1]
- **[Middle Pinch Roller Placement Notification]**: On
- **[Media Clamp Placement Notification]**: On

*1 This menu item is only displayed when the machine ink type includes white ink.

- [Ink Expiration Date Notification]: On

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

This sets how long it takes until the machine goes into sleep mode (state in which the power-saving feature is active) when no print data is received and no operations are performed for a continued length of time.

Procedure

1. Tap .
2. Tap [Preferences]>[Sleep Time].
3. Tap − or + to set the time.
4. Tap [Save] to confirm your entry.
5. Tap to return to the home screen.

MEMO

- Default setting: [30 min.]

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 .

   You are returned to the home screen.

MEMO

- Default setting: [Off]

Set the [Automatic Sub Power On].

Set the day of the week and the time at which to automatically switch the printer sub power on. You can also set the ink circulation[*1] and cleaning when the sub power switches on automatically.

Even if you have configured the settings to switch the sub power on, you can use the calendar to specify days (such as holidays) on which to not switch the sub power on.

Switching the Sub Power On Automatically on Specified Days at Specified Times

Procedure

1. Tap .
2. Tap [Maintenance]>[Automatic Sub Power On Settings].
3. Tap one of the following items.
   - When setting all days of the week from Monday to Sunday
     [**Collective Settings**]
   - When setting only the required days of the week
     [**Monday**] to [**Sunday**]

   The [**Automatic Sub Power On Settings**] screen appears.
4. Set the following.
   - [**Automatic Sub Power On**]
     Set whether to switch on the sub power automatically.
   - [**Time at Which to Automatically Turn Sub Power On**]
     Set the time at which to switch on the sub power automatically. Set [**Hour**] and [**Minute**], and then tap [**OK**].
   - [**Circulation When Sub Power Automatically Turns On**]
     Set whether to perform [**Ink Circulation**] when the sub power switches on automatically.
   - [**Cleaning When Sub Power Automatically Turns On**]
     Set whether to perform cleaning when the sub power switches on automatically.
   - [**Type**]
     Set the type of cleaning (, [**Medium Cleaning**], or [**Powerful Cleaning**]) to perform when the sub power switches on automatically. After you configure the settings, tap [**OK**].
5. Tap [**Save**].
6. Tap .
   You are returned to the home screen.

MEMO

- Default settings
  - [**Automatic Sub Power On**]: Off
  - [**Time at Which to Automatically Turn Sub Power On**]: 0:00

*1 This menu item is only displayed when the machine ink type includes white ink.

- [Circulation When Sub Power Automatically Turns On]: Off
- [Cleaning When Sub Power Automatically Turns On]: Off
- [Type]: [Medium Cleaning]

Setting Days on Which to Not Switch the Sub Power on Automatically

Even if you have configured the settings to switch on the sub power on given days of the week, you can set days (such as holidays and extended periods of days off) on which not to switch on the sub power. You can configure these settings for up to 12 months ahead of the current month.

Procedure

1. **Tap** .
2. **Tap [Maintenance]>[Automatic Sub Power On Settings].**
3. **Tap [Exception Dates].**
   The calendar for the current month appears.
4. **Select the days on which to not switch the sub power on automatically.**
5. **Tap [Save].**
6. **Tap** .
   You are returned to the home screen.

Managing the Basic Settings of the Printer

Set the display language

This feature sets the language displayed on 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 setting

- **[Language]**: ENGLISH

Changing the Units of Measurement

This feature sets the length and temperature units displayed on the operation panel.

Procedure

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

MEMO

- Default setting
  - [Length]: mm
  - [Temperature]: ˚C

Viewing Printer Information

This is the procedure for viewing machine information such as the 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 .
   You are returned to the home screen.

Viewing Network Information

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

Procedure

1. Tap .

2. **Tap [System Information]>[Network].**

   You can check the following information:

   - **[Obtain IP Address Automatically]**: Enables/disables the automatic obtaining of IP addresses via DHCP. When this is disabled, tap to change the following settings.
   - **[IP Address]**
   - **[Subnet Mask]**
   - **[Default Gateway]**

   If you changed any of the settings, tap **[Save]**.

3. **Tap** .

   You are returned to the home screen.

MEMO

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

RELATED LINKS

- MG2-640 Setup Guide

Adjusting the Brightness of the Operation Panel

The brightness of the operation panel's screen can be adjusted.

Procedure

1. **Tap** .
2. **Tap [System Information]>[Screen Brightness].**
3. **Tap** **or** **to adjust the brightness.**
   The larger the value, the brighter the screen.
4. **Tap [Save] to confirm your entry.**
5. **Tap** .
   You are returned to the home screen.

MEMO

- Default setting: **[100%]**

Turning Off Operation Panel Sounds

The touch sounds for the operation panel can be turned off.

Procedure

1. **Tap** .
2. **Tap [System Information]>[Screen Operation Sound].**
3. **Tap [Off].**
   The operation sound turns off.
4. **Tap [Save] to confirm your entry.**
5. **Tap** .
   You are returned to the home screen.

MEMO

- Default setting: **[On]**

Returning All Settings to Factory Defaults

This menu returns all settings, including registered media, to their factory defaults.
The settings for [**Language**] and [**Units**] are not returned to their factory default values.

Procedure

1. Tap .
2. Tap [Preferences]>[Reset to Factory Defaults].
3. Tap [Reset].
4. Tap [Yes] on the confirmation screen.
   The setting is reset and the screen returns to the home screen.

Maintenance

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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.
- **The print heads and the UV-LED device are delicate devices.**
  - Avoid needlessly touching them, allowing them to scrape against the media, or similar acts. Failure to handle with care may cause damage.
  - 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.
  - Daily maintenance as well as various types of maintenance depending on the status must be performed. 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.
- **Keep the operation panel clean.**
  - If dirt or ink adheres to the operation panel, immediately wipe it clean with dry, soft fabric.
- **This machine becomes hot.**
  - Never cover the ventilation holes with cloth, tape, or anything else.

Ink Cartridges

⚠ WARNING

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

- Any location exposed to open flame
- 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

Fire may be a danger. Accidental ingestion by children may pose a health hazard.

- **The ink pouches inside ink cartridges come in various types and have various expiration dates.**
  - Use a type that is compatible with the printer. Also, be sure to use only genuine items from Roland DG Corporation.
  - Use up the ink before the expiration date printed on the ink pouch. Also, do not use ink pouches whose expiration dates have passed.
- **Never subject ink cartridges and ink pouches to impacts and never attempt to disassemble ink pouches.**

- Never drop the ink bottles or shake them forcefully. The impact may rupture the internal pouches and cause the ink to leak.
- Never attempt to disassemble ink pouches.
- Never attempt to refill the ink in ink pouches.
- 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**
  - Store the ink bottle in a location that is not subject to direct sunlight or strong illumination.
  - Store ink cartridges unopened in a well-ventilated location at a temperature of 5°C to 30°C (41°F to 86°F) and with a humidity of 20%RH to 80%RH.

IMPORTANT

To prevent the ink from hardening, place any partially used ink pouches that have been removed back into their original packing boxes, and store them away from UV light.

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	Item	Corresponding page
Before daily operations	1. Mix the white ink.	Remove just the white ink cartridge, shake it 50 times (about 20 seconds), and then reinsert this cartridge. P. 119 Preventing Sedimentation in Inks
	2. Perform a nozzle drop-out test.	P. 140 Preparations for Printing Output
After daily operations	Clean the machine.	P. 277 Cleaning the Media Path
		P. 278 Cleaning the Cutting Carriage Roller
If a message appears	Perform manual cleaning.	P. 279 Cleaning around the print heads
	Clean the UV-LED device.	P. 281 Cleaning the UV-LED Device
	Dispose of the discharged fluid.	P. 285 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	Item	Corresponding page
When dot drop-out or dot displacement occurs	Perform various types of cleaning.	P. 288 Performing Normal Cleaning
		P. 289 Performing Medium Cleaning
		P. 290 Performing Powerful Cleaning
		P. 279 Performing Manual Cleaning
When dot drop-out and dot displacement are not resolved even by performing the above operations	Replace the ink in all ink paths.	P. 296 Renewing Ink
When uneven color issues occur (other than white ink)	1. Mix the ink in the ink cartridges.	P. 119 Preventing Sedimentation in Inks
	2. Replace the ink in the ink path in the periphery of the print heads.	P. 293 Performing Light Choke Cleaning
	3. Replace the ink in all ink paths.	P. 296 Renewing Ink

Timing	Item	Corresponding page
When uneven color issues occur (white ink)	1. Mix the white ink.	P. 119 Preventing Sedimentation in Inks
	2. Circulate the ink in the white ink path.	P. 291 Circulating the Ink
	3. Replace the ink in the ink path in the periphery of the print heads.	P. 293 Performing Light Choke Cleaning
	4. Replace the ink in all ink paths.	P. 296 Renewing Ink

Operations are listed in the following sequence in ascending order of ink consumption. Also, performing these operations frequently may damage the print heads themselves.

Normal cleaning < medium cleaning < powerful cleaning < light choke cleaning < ink renewal

Replacing Consumable Parts

These items are for replacement of consumable parts. Thoroughly read the explanation, and then perform the operation at the appropriate point in time.

Timing	Corresponding page
When a replacement message appears	P. 305 Replacing the Wiper
	P. 308 Replacing the Flushing Sponges
	P. 307 Replacing the Print Head Caps
When a cutting edge becomes dull	P. 309 Replacing the Blade
	P. 315 Replacing the Separating Knife

Automatic Maintenance Feature and Notes

This machine has a feature that automatically performs maintenance periodically.

Set the maintenance items, [**Type**], and [**Frequency**] that are performed automatically according to the printer service environment, types of products that are frequently output, and other factors. A maximum of five settings for automatic maintenance can be saved.

IMPORTANT

If the automatic maintenance settings are configured without an adequate understanding, the maintenance results may not be as the customer wanted. Before configuring the automatic maintenance settings, be sure to contact your authorized dealer.

List of automatic maintenance settings

Setting item	Contents	Setting value
[**Cleaning When the Sub Power Turns On**]	Set [**Type**] and [**Frequency**] for cleaning that is performed when the sub power is turned on.	[Type] • [**Medium Cleaning**] • [**Powerful Cleaning**] [Frequency] • [**None**] • [**Periodically**]: 1 to 24 hours
[**Ink Circulation when Sub Power Turns On**]*1	Set [**Frequency**] for [**Ink Circulation**] performed when the sub power is turned on.	[Frequency] • [**None**] • [**Periodically**]: 1 to 24 hours
[**Cleaning before Printing Starts**]	Set [**Type**] and [**Frequency**] for the cleaning that is performed at the start of printing.	[Type] • [**Normal Cleaning**] • [**Medium Cleaning**] • [**Powerful Cleaning**] [Frequency] • [**None**] • [**Periodically**]: 0.5 to 12 hours • [**Each Time**]
[**Cleaning during Printing**]	Set the [**Type**] and [**Frequency**] of the cleaning during printing.	[Type] • [**Normal Cleaning**] • [**Medium Cleaning**] • [**Powerful Cleaning**] [Frequency] • [**No Cleaning**] • [**Periodically**]: 0.5 to 12 hours
[**Cleaning after Printing Finishes**]	Set [**Type**] and [**Frequency**] for the cleaning that is performed when printing ends.	[Type] • [**Normal Cleaning**] • [**Medium Cleaning**] • [**Powerful Cleaning**] [Frequency] • [**None**] • [**Periodically**]: 0.5 to 12 hours • [**Each Time**]
[**Ink Circulation before Printing Starts**]*1	Set [**Frequency**] for the ink circulation that is performed before the start of printing.	[Frequency] • [**None**] • [**Periodically**]: 1 to 24 hours • [**Each Time**]

Setting item	Contents	Setting value
[**Ink Discharge before Printing Starts**]*1	Set [**Type**] and [**Frequency**] for the discharge of ink that cannot be mixed by ink circulation at the start of printing.	[**Type**] • [**Short**] • [**Full**] [**Frequency**] • [**Disable**] • [**Enable**]
[**Periodic Ink Circulation**]*1	Set [**Frequency**] for the ink circulation that is performed after the previous ink circulation.	[**Frequency**] • [**Periodically**]: 1 to 6 hours
[**Periodic Cleaning**]	Set [**Type**] and [**Frequency**] for the cleaning that is performed periodically.	[**Type**] • [**Normal Cleaning**] • [**Medium Cleaning**] • [**Powerful Cleaning**] [**Frequency**] • [**Periodically**]: 1 to 24 hours

*1 White ink only

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. If the message [**When output, cleaning, and other operations are completed, discard the discharged fluid.**] appears, quickly discard the discharged fluid.
- **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. Load sufficient amounts of ink and cleaning liquid in the machine. The machine cannot perform automatic maintenance if it has run out of ink or cleaning liquid.
- **Switch the sub power on at least once every two weeks.**

  Switch the sub power on at least once every two weeks. 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. Also, check for notifications and perform the required maintenance.
- **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.

RELATED LINKS

- P. 285 If the Discharged Fluid Disposal Message Appears
- P. 128 Replacing Ink
- P. 132 Replacing the Cleaning Liquid Pouch
- P. 140 Performing a Nozzle Drop-out Test

Regular Maintenance

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Cleaning the Machine

Cleaning the Media Path

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

⚠ WARNING

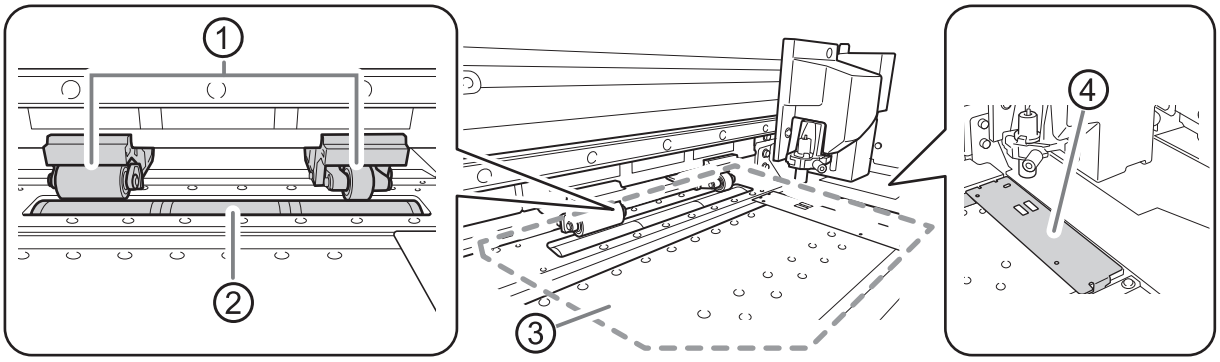
Never use a solvent such as gasoline, alcohol, or thinner to perform cleaning.
Doing so may cause a fire.

⚠ CAUTION

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

IMPORTANT

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



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

①	Pinch roller	These are the positions where the media is fixed in place, 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 transported, so it is easy for grime to affix to these positions. Remove buildup of media scraps and other material using a brush. Never use a metal brush.
③	Platen	Wipe away any buildup of ink, grime, or cut media on the media path and in the grooves.
④	Media clamp	Wipe away ink and grime.

Cleaning the Cutting Carriage Roller

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

⚠ WARNING

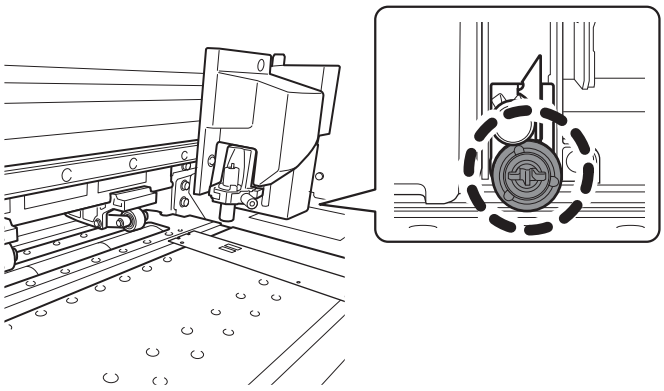
Never use a solvent such as gasoline, alcohol, or thinner to perform cleaning.
Doing so may cause a fire.

⚠ CAUTION

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

IMPORTANT

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



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

Cleaning around the print heads

The print heads are important components that discharge ink. They require periodic and appropriate maintenance. Cleaning around the print heads is known as "manual cleaning." Be sure to perform manual cleaning in the following situations.

- When one of the following messages appears.

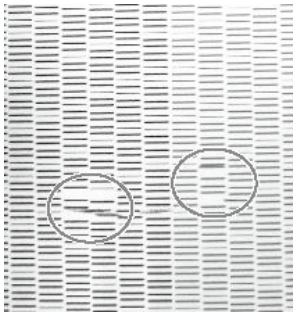
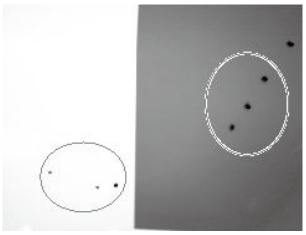
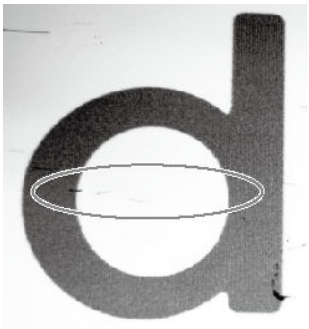
  [The time for manual cleaning has arrived.]

  [Maintenance must be performed. Perform manual cleaning.]

  When the message appears, check the message details, and tap **[OK]**.

  Tap on the home screen, and then tap the notification to display the manual cleaning menu screen.
- Before performing unattended printing for long periods at night
- When symptoms that cannot be improved with powerful cleaning occur

  When any of the symptoms given below occur and powerful cleaning is not effective, perform manual cleaning.

Dot drop-out/Dot displacement	Ink drips	Dragging dirt
		
Dust or other foreign matter adheres to the print heads and impedes correct ink discharge.	Ink pools in dust or dirt adhered to the print heads, and drips onto the media.	The phenomenon where dirt or dust accumulates on the print heads.

Performing Manual Cleaning

⚠ 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 or burns.

IMPORTANT

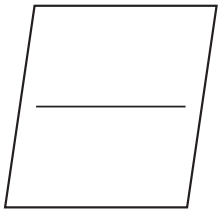
Important notes on this procedure

- Before attempting this operation, remove any media.
- To prevent the print heads from drying out, finish this procedure in 10 minutes or less. A warning beep sounds after 10 minutes.
- 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 cleaning liquid other than the included cleaning liquid.
- 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.
- Never rub the print head surface (nozzle surface).
- Stroke the sponges very gently, applying as little pressure as possible. Never rub, scrape, or crush them.

- If you use up the cleaning sticks or cleaning liquid, contact your authorized dealer or visit our website (https://www.rolanddg.com/).
- Prepare your own cleaning sheets for wiping off ink.

If a warning beep sounds during cleaning

- A warning beep sounds 10 minutes after operation starts. Stop work, close all the covers, and then press [**Finish All**] to end the manual cleaning mode. After that, restart the procedure from the beginning.

Required items		
		
Cleaning sticks	Cleaning liquid	Cleaning sheets

Procedure

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

   You are returned to the home screen.

Cleaning the UV-LED Device

The UV-LED device is an important component for ink adhesion. It requires periodic and appropriate maintenance. The cleaning of the UV-LED device is referred to as "UV lamp manual cleaning." Be sure to perform UV lamp manual cleaning in the following situations.

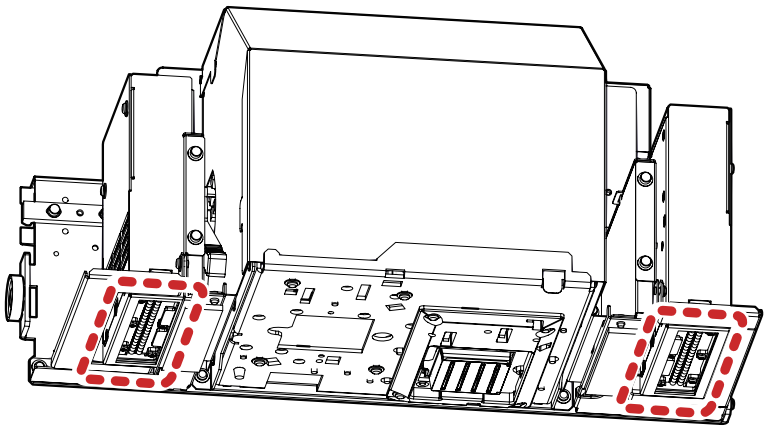
- **When a message appears**

  When the message [**The time for UV lamp manual cleaning has arrived.**] appears, you can tap  on the home screen to check the notification details. Tap the notification to display the screen for starting UV lamp manual cleaning.

- **When there is a lot of scattered ink mist and the inside of the machine is soiled**

  Perform this cleaning every day when frequently printing with the print heads at a distance from the print surface or when ink is emitted to locations that protrude from the print surface. If the scattered ink mist is allowed to harden, it may cause malfunctions.

- **When the bases and irradiation windows of the UV-LED device are dirty**



MEMO

For hardened ink and other such dirt that cannot be completely cleaned away, contact your authorized dealer.

Cleaning the UV-LED Device

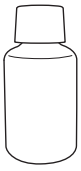
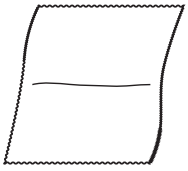
IMPORTANT

Important notes on this procedure

- Before attempting this operation, remove any media.
- To prevent the print heads from drying out, finish this procedure in 10 minutes or less.
- The cloths, alcohol, and similar items used in cleaning are not included with the product.

When a warning beep sounds during cleaning

A warning beep sounds 10 minutes after operation starts. Stop work, close all the covers, and then tap [**Finish All**]. After that, restart the procedure from the beginning.

Required items	
	
Anhydrous ethanol or isopropyl alcohol	Cloth (that is not fluffy)

⚠ CAUTION

Do not perform cleaning immediately after printing has finished. (Wait approximately 15 minutes after printing finishes.)

The area around the UV-LED device is hot and may cause burns.

⚠ 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 UV-LED device damage.

⚠ CAUTION

Use cloth that is not fluffy to wipe off the parts. Do not use a hard material such as metal.

Using cloth that is fluffy or a hard material such as metal may lead to UV-LED device damage.

Procedure

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

   You are returned to the home screen.

Disposing of Discharged Fluid

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Precautions for Disposing of Discharged Fluid

⚠ WARNING

Never place discharged fluid or ink near an open flame.

Doing so may cause a fire.

⚠ CAUTION

To store discharged fluid temporarily, place it in the included drain bottle or in a durable sealed container such as a metal can or polyethylene tank, and cap the container tightly.

Any spillage or vapor leakage may cause fire, odor, or physical distress.

IMPORTANT

Dispose of discharged fluid properly, in accordance with the laws in effect in your locale.

Discharged fluid is flammable and contains toxic ingredients. Never attempt to incinerate discharged fluid or discard it with ordinary trash. Also, do not dispose of it in sewer systems, rivers, or streams. Doing so may have an adverse impact on the environment.

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.

If the Discharged Fluid Disposal Message Appears

The message [**When output, cleaning, and other operations are completed, discard the discharged fluid.**] 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 [When output, cleaning, and other operations are completed, discard the discharged fluid.].**
4. **Tap the following notification.**

   The [**Drain Bottle**] replacement screen appears.

   MEMO

   You can dispose of discharged fluid even if the above message has not appeared.
   Use the following operations to display the drain bottle screen, and then dispose of discharged fluid according to the procedure starting from step 4.

   1. Tap .
   2. Tap [**Maintenance**]>[**Drain Bottle**].

5. **Tap [Execute].**
6. **Follow the on-screen instructions to discard the discharged fluid.**

   ⚠ CAUTION

   Before you detach the drain bottle, be sure to wait for the screen to display [Discard the discharged fluid in the bottle.]. After discarding the discharged fluid, promptly attach the drain bottle to the machine.
   Failing to follow this procedure may cause discharged fluid to flow out of the tube and spill, soiling your hands or the floor.

   IMPORTANT

   When you remove the drain bottle, a few drops of discharged fluid may come out of the machine. Exercise caution to prevent this fluid from soiling your hands or the floor.



7. **Quickly attach the emptied drain bottle to the machine.**

8. **Tap [Finish].**
   The display returns to the original screen.

9. **Tap**  **.**
   You are returned to the home screen.

Advanced Maintenance

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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

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.

Procedure

1. **Set up the media.**
2. **Tap** ☰.
3. **Tap [Cleaning]>[Normal Cleaning].**
4. **Tap [Execute].**

   Cleaning will start. The details of the operation in progress and the (approximate) remaining time of that work are displayed in the status bar at the top of the screen. When the work is finished, the status bar returns to its original display.
5. **Tap** ←.
6. **Tap [Printing Test].**
7. **Tap [Nozzle Drop-out Test]>[Execute].**
8. **Check to make sure the dot drop-out or dot displacement has been corrected.**

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

   You are returned to the home screen.

RELATED LINKS

- P. 289 When Normal Cleaning Is Not Effective

When Normal Cleaning Is Not Effective

Performing Medium Cleaning

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 even after performing normal cleaning, perform the more forceful "medium cleaning" to remove clogging from the print heads.

IMPORTANT

Medium cleaning consumes more ink than normal cleaning, and overly frequent use may damage the print heads themselves. Avoid performing this operation more than necessary.

MEMO

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.

Procedure

1. **Set up the media.**
2. **Tap** ☰.
3. **Tap [Cleaning]>[Medium Cleaning].**
4. **Tap [Execute].**

   Cleaning will start. The details of the operation in progress and the (approximate) remaining time of that work are displayed in the status bar at the top of the screen. When the work is finished, the status bar returns to its original display.
5. **Tap** ←.
6. **Tap [Printing Test].**
7. **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 problems such as dot drop-out and dot displacement persist even after performing medium cleaning, perform "powerful cleaning."
8. **Tap** ⌂.

   You are returned to the home screen.

RELATED LINKS

- P. 290 Performing Powerful Cleaning

Performing Powerful Cleaning

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 performing 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

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.

Procedure

1. **Set up the media.**
2. **Tap** ☰.
3. **Tap [Cleaning]>[Powerful Cleaning].**
4. **Tap [Execute].**

   Cleaning will start. The details of the operation in progress and the (approximate) remaining time of that work are displayed in the status bar at the top of the screen. When the work is finished, the status bar returns to its original display.
5. **Tap** ←.
6. **Tap [Printing Test].**
7. **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 problems such as dot drop-out and dot displacement persist even after performing powerful cleaning, perform "manual cleaning."
8. **Tap** ⌂.

   You are returned to the home screen.

RELATED LINKS

- P. 279 Performing Manual Cleaning

If Colors Are Uneven

If Uneven Color Issues Occur with Ink Other than White Ink

Perform the following operations.

1. Shake the ink cartridge to mix the ink.

   If the uneven color issues are not resolved even after you perform Preventing Sedimentation in Inks(P. 119), proceed to Step 2.
2. Performing Light Choke Cleaning

   If the uneven color issues are not resolved even after you perform [**Light Choke Cleaning**], proceed to Step 3.
3. Renewing Ink

   If the uneven color issues are not resolved even after you perform [**Ink Renewal**], contact your authorized dealer.

If Uneven Color Issues Occur with White Ink

Perform the following operations.

1. Shake the ink cartridge to mix the ink.

   If the uneven color issues are not resolved even after you perform Preventing Sedimentation in Inks(P. 119), proceed to Step 2.
2. Circulating the Ink

   If the uneven color issues are not resolved even after you perform [**Ink Circulation**], proceed to Step 3.
3. Performing Light Choke Cleaning

   If the uneven color issues are not resolved even after you perform [**Light Choke Cleaning**], proceed to Step 4.
4. Renewing Ink

   If the uneven color issues are not resolved even after you perform [**Ink Renewal**], contact your authorized dealer.

Circulating the Ink

If uneven color issues with white ink are not resolved even after shaking the ink cartridges to mix the ink, perform [**Ink Circulation**].

Uneven colors refers to the symptom of printed colors being uneven (such as the color density being inconsistent) even when the same data is printed with the same settings.

MEMO

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

Procedure

1. Tap ☰.
2. Tap [Maintenance]>[Ink Circulation].

   The [**Ink Circulation**] screen appears.
3. Tap [Execute].

Ink circulation starts. The details of the operation in progress and the (approximate) remaining time of that work are displayed in the status bar at the top of the screen. When the work is finished, the status bar returns to its original display.

4. Tap .

   You are returned to the home screen.

Performing Light Choke Cleaning

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.
- When performing [**Light Choke Cleaning**], replace the ink pouch in the ink cartridge with a new one. If the ink runs out during cleaning, a [**Cleaning Error (Ink Cartridge)**] will occur and cleaning will stop.
  The removed ink pouches can still be used for printing (other than [**Light Choke Cleaning**]) and other purposes.

Procedure

1. Tap ☰.
2. Tap [Maintenance]>[Light Choke Cleaning].
3. Tap [Execute].
   Cleaning will start. The details of the operation in progress and the (approximate) remaining time of that work are displayed in the status bar at the top of the screen. When the work is finished, the status bar returns to its original display.

MEMO

If [**Discard the discharged fluid in the bottle.**] appears after tapping [**Execute**]

1. Remove the drain bottle and discard the discharged fluid.



2. Quickly attach the emptied drain bottle to the machine once more.
3. Tap [**Finish**].

⚠ WARNING

Never place discharged fluid or ink near an open flame.
Doing so may cause a fire.

⚠ 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.

⚠ CAUTION

To store discharged fluid temporarily, place it in the included drain bottle or in a durable sealed container such as a metal can or polyethylene tank, and cap the container tightly.
Any spillage or vapor leakage may cause fire, odor, or physical distress.

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.
- Dispose of discharged fluid properly, in accordance with the laws in effect in your locale.
- Discharged fluid is flammable and contains toxic ingredients. Never attempt to incinerate discharged fluid or discard it with ordinary trash. Also, do not dispose of it in sewer systems, rivers, or streams. Doing so may have an adverse impact on the environment.

4. Tap .

You are returned to the home screen.

Handling Severe Ink Discharge Issues and Uneven Colors

The handling of cases where ink discharge issues of dot drop-out and dot displacement are not resolved differs depending on the situation.

If the position of the dot drop-out or dot displacement changes at each printing test

1. Performing Normal Cleaning

   If dot drop-out and dot displacement are not resolved even after performing [**Normal Cleaning**], proceed to Step 2.
2. Performing Medium Cleaning

   If dot drop-out and dot displacement are not resolved even after performing [**Medium Cleaning**], proceed to Step 3.
3. Performing Powerful Cleaning

   If dot drop-out and dot displacement are not resolved even after performing [**Powerful Cleaning**], proceed to Step 4.
4. Performing Manual Cleaning

   If dot drop-out and dot displacement are not resolved even after you perform [**Manual Cleaning**], proceed to Step 5.
5. Renewing Ink

   If dot drop-out and dot displacement are not resolved even after you perform [**Ink Renewal**], proceed to Step 6.
6. Performing Medium Cleaning

   If dot drop-out and dot displacement are not corrected even after performing [**Medium Cleaning**], contact your authorized dealer.

If the position of the dot drop-out or dot displacement does not change at each printing test

1. Performing Normal Cleaning

   If dot drop-out and dot displacement are not resolved even after performing [**Normal Cleaning**], proceed to Step 2.
2. Performing Medium Cleaning

   If dot drop-out and dot displacement are not resolved even after performing [**Medium Cleaning**], proceed to Step 3.
3. Performing Powerful Cleaning

   If dot drop-out and dot displacement are not resolved even after performing [**Powerful Cleaning**], proceed to Step 4.
4. Performing Manual Cleaning

   If dot drop-out and dot displacement are not resolved even after you perform [**Manual Cleaning**], proceed to Step 5.
5. Renewing Ink

   If the dot drop-out and dot displacement are not resolved even after you perform [**Ink Renewal**], contact your authorized dealer.

Renewing Ink

When ink discharge issues and uneven colors are not resolved, perform ink renewal.

However, ink renewal will discharge a large amount of ink. Only perform ink renewal in the following cases when ink discharge issues and uneven colors cannot be corrected.

When ink discharge issues are not resolved after performing the work below

- **[Normal Cleaning]**
- **[Medium Cleaning]**
- **[Powerful Cleaning]**
- **[Manual Cleaning]**

When uneven color issues (except for white ink) are not resolved after performing the work below

- Ink mixing
- **[Light Choke Cleaning]**

When uneven color issues (white ink) are not resolved after performing the work below

- Ink mixing
- **[Ink Circulation]**
- **[Light Choke Cleaning]**

Procedure

1. Tap ☰.
2. Tap **[Maintenance]**>**[Ink Renewal]**.
3. Tap **[Execute]**.

   Starts the **[Ink Renewal]** function. The details of the operation in progress and the (approximate) remaining time of that work are displayed in the status bar at the top of the screen. When the work is finished, the status bar returns to its original display.

MEMO

If **[Discard the discharged fluid in the bottle.]** appears after tapping **[Execute]**

1. Remove the drain bottle and discard the discharged fluid.



2. Quickly attach the emptied drain bottle to the machine once more.
3. Tap **[Finish]**.

⚠ WARNING

Never place discharged fluid or ink near an open flame.

Doing so may cause a fire.

⚠ 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.

⚠ CAUTION

To store discharged fluid temporarily, place it in the included drain bottle or in a durable sealed container such as a metal can or polyethylene tank, and cap the container tightly.

Any spillage or vapor leakage may cause fire, odor, or physical distress.

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.
- Dispose of discharged fluid properly, in accordance with the laws in effect in your locale.
- Discharged fluid is flammable and contains toxic ingredients. Never attempt to incinerate discharged fluid or discard it with ordinary trash. Also, do not dispose of it in sewer systems, rivers, or streams. Doing so may have an adverse impact on the environment.

4. Tap .

You are returned to the home screen.

Partially Restricting the Print Heads Used for Printing

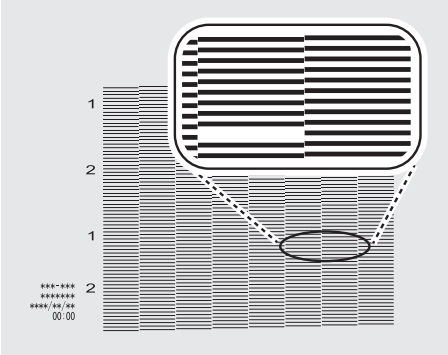
When dot drop-out or dot displacement is not improved even after renewing the ink, partially restrict the print heads to use for printing (i.e. prevent the use of the print heads that are causing discharge issues). This operation is called the "nozzle mask," and while it slows down printing speed, it also allows you to decrease the impact of dot drop-out or dot displacement.

First print a test pattern, and then select the nozzle group to use by viewing the test results. After that, use VersaWorks to select the nozzle group used for printing.

1. Performing a Printing Test for the Nozzle Mask

Procedure

1. **Set up the media.**
2. **Tap** ☰.
3. **Tap [Cleaning]>[Printing Test].**
4. **Select [Nozzle Mask Test] and tap [Execute].**
   Printing of the test pattern starts.
5. **Check for dot drop-out and dot displacement by viewing the results of the printing test.**



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.

6. **If you have opened the front cover, close it.**
7. **Tap** ⌂ **to return to the home screen.**

2. Limiting Print Heads Used for Printing: [Nozzle Mask]

Use VersaWorks to select the nozzle group used for printing. For the detailed procedure, see the VersaWorks Master Guide.

VersaWorks manual

Emergency Measure) Cleaning the Print Head Surface

When dot drop-out or dot displacement 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.

⚠ 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 or burns.

IMPORTANT

Important notes on this procedure

- Before attempting this operation, remove any media.
- To prevent the print heads from drying out, finish this procedure in 10 minutes or less. A warning beep sounds after 10 minutes.
- 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 cleaning liquid other than the included cleaning liquid.
- 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.
- Never rub the print head surface (nozzle surface).
- If you use up the cleaning sticks or cleaning liquid, contact your authorized dealer or visit our website (https://www.rolanddg.com/).

If a warning beep sounds during cleaning

- A warning beep sounds 10 minutes after operation starts. Stop work, close all the covers, and then press **[Finish All]** to end the manual cleaning mode. After that, restart the procedure from the beginning.

Required items	
	
Cleaning stick	Cleaning liquid

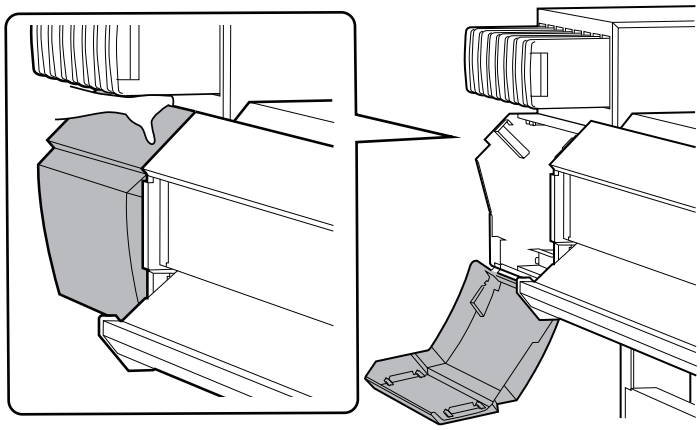
Procedure

1. **Remove any media.**
2. **Tap ☰.**
3. **Tap [Cleaning]>[Manual Cleaning].**
4. **Tap [Execute].**
5. **Tap [OK].**

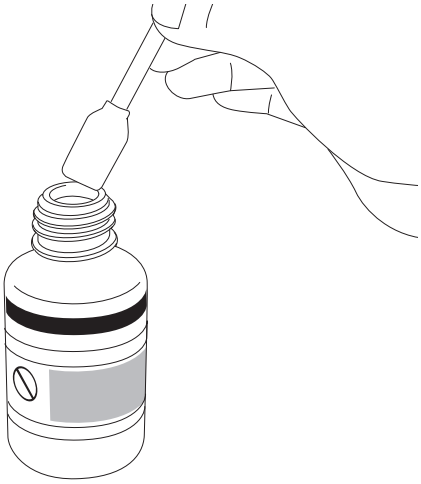
   The print head carriage moves to the left end of the machine.

The following procedure explains the procedure for emergency measures. Be aware that the procedure is different from ordinary manual cleaning.

6. **Open the left cover.**

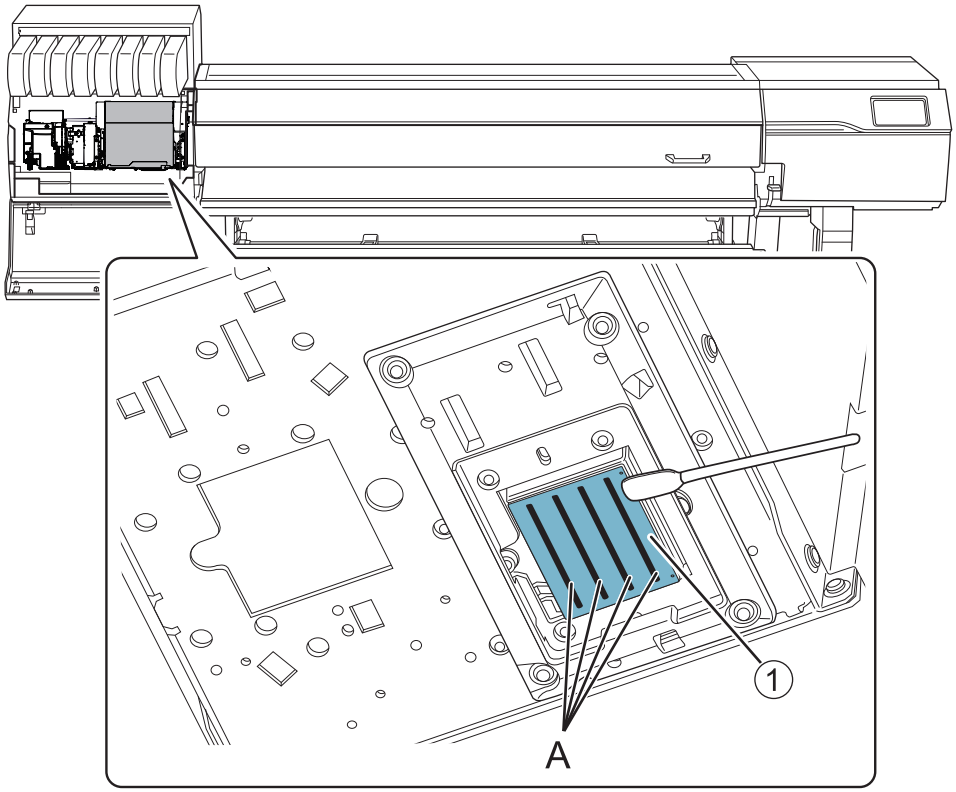


7. **Moisten a new cleaning stick with the cleaning liquid.**



8. **Very gently touch the cleaning stick against the print head surface (nozzle surface).**

- Very softly press the cleaning stick against the print head so that cleaning liquid soaks into the nozzle surface of the print head (①). Never rub the stick on the surface or press it forcibly.
- Press the cleaning stick against the grooves (A) in the same manner as you pressed the cleaning stick against the nozzle surface.



9. **Close the left cover.**

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

Cleaning will start. The details of the operation in progress and the (approximate) remaining time of that work are displayed in the status bar at the top of the screen. When the work is finished, the status bar returns to its original display.

11. **Tap** .

You are returned to the home screen.

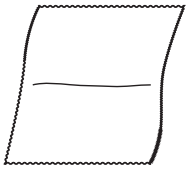
When the Operation Panel Is Dirty

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.
- Put on gloves before cleaning the operation panel. Also, be sure to use a cloth. 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. **Turn off the sub power followed by the main power.**
2. **Wipe off the operation panel with a cloth soaked in anhydrous ethanol or isopropyl alcohol.**

   Wipe slowly and gently to remove the grime.
3. **Turn on the main power switch.**

Replacing Consumable Parts

Replacing Parts for Maintenance 305
Replacing the Wiper 305
Replacing the Print Head Caps 307
Replacing the Flushing Sponges 308
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Replacing Parts for Maintenance

Replacing the Wiper

The wiper periodically cleans the surface of the print heads.

Replacement is necessary if the [**The time for wiper replacement has arrived.**] message appears.

⚠ 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 or burns.

IMPORTANT

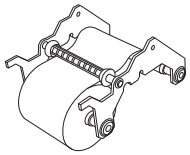
To prevent the print heads from drying out, finish this procedure in 10 minutes or less. After 10 minutes, the alarm will sound, so pause the procedure and perform the following operations.

1. Close all the covers.
2. Tap [**Finish All**] to finish the work.
3. Restart the procedure from the beginning.

IMPORTANT

If the message [**There are not many wipers remaining. Immediately stock up on wipers. Leaving the printer in a state in which it does not have a wiper will lead to head damage.**] appears, have a replacement wiper ready.

If the message [**Replace the wiper immediately. Leaving the printer in a state in which it does not have a wiper will lead to head damage.**] appears, immediately replace the wiper.

Required items

Wiper

Procedure

1. **When the message [The time for wiper replacement has arrived.] appears, tap [OK].**
2. **Remove any media.**
3. **Tap  to display the messages.**
4. **Tap [The time for wiper replacement has arrived.].**
   The [**Wiper Replacement**] screen appears.
5. **Tap [Execute].**
6. **Follow the instructions on the operation panel to replace the wiper.**
   - Tap < or > to check the procedure.

- If you complete the work without viewing the instructions, tap [**Finish All**].

7. **When the replacement of the wiper is complete, tap [Finish All].**

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.

Replacement is necessary if the [**The time for cap replacement has arrived.**] message appears.

⚠ WARNING

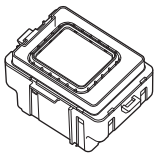
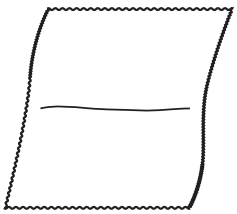
Be sure to perform operations as specified by the instructions, and never touch any area not specified in the instructions.

Sudden movement of the machine may cause injury or burns.

IMPORTANT

To prevent the print heads from drying out, finish this procedure in 10 minutes or less. After 10 minutes, the alarm will sound, so pause the procedure and perform the following operations.

1. Close all the covers.
2. Tap [**Finish All**] to finish the work.
3. Restart the procedure from the beginning.

Required items		
		
Print head cap	Cloth (that is not fluffy)	Cleaning stick

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**] screen appears.
5. **Tap [Execute].**
6. **Follow the instructions on the operation panel to replace the print head caps.**
   - Tap ‹ or › to check the procedure.
   - If you complete the work without viewing the instructions, tap [**Finish All**].
7. **When the print head cap replacement is finished, tap [Finish All].**

Replacing the Flushing Sponges

The flushing sponge absorbs the discharged ink or cleaning liquid to prevent clogging of the print heads.

Replacement is necessary if the [**The time for flushing sponge replacement has arrived.**] message appears.

IMPORTANT

To prevent the print heads from drying out, finish this procedure in 10 minutes or less. After 10 minutes, the alarm will sound, so pause the procedure and perform the following operations.

1. Close all the covers.
2. Tap [**Finish All**] to finish the work.
3. Restart the procedure from the beginning.

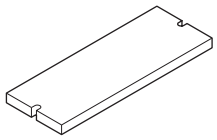
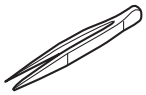
IMPORTANT

If the flushing sponge is not replaced after the message appears, the flushing sponge may not sufficiently absorb ink or cleaning liquid, resulting in discharged fluid overflowing.

⚠ 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 or burns.

Required items	
	
Flushing sponge	Tweezers

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 [**Flushing Sponge Replacement**] screen appears.
5. **Tap [Execute].**
6. **Follow the instructions on the operation panel to replace the flushing sponge.**
   - Tap ‹ or › to check the procedure.
   - If you complete the work without viewing the instructions, tap [**Finish All**].
7. **When the flushing sponge replacement is finished, tap [Finish All].**

Replacing the Blade/Separating Knife

Replacing the Blade

If the blade becomes dull, if the edge of the blade is chipped, or if the cutting quality is lowered, replace the blade with a new blade.

⚠ 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 or burns.

⚠ CAUTION

Never touch the tip of the knife.
Doing so may result in injury. The cutting performance of the blade will also be impaired.

Required item

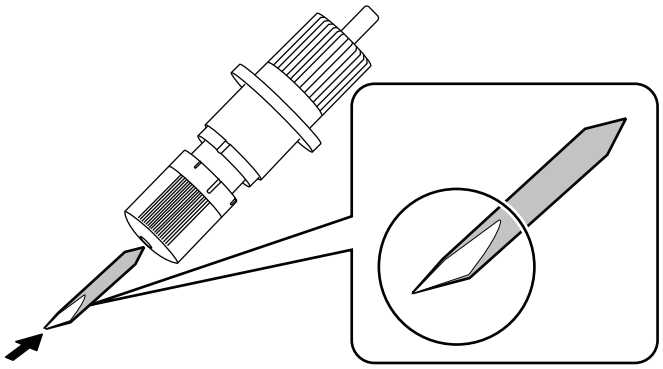
Replacement blade

1. Replacing the Blade

Procedure

1. **Remove any media.**
2. **Tap** ☰.
3. **Tap [Maintenance]>[Blade Replacement].**
   The [**Blade Replacement**] screen appears.
4. **Tap [Execute].**
   The cutting carriage moves to a position where blade replacement is possible.
5. **Follow the instructions on the operation panel to replace the blade.**
   - Tap ‹ or › to check the procedure.
   - If you complete the work without viewing the instructions, tap [**Finish All**].

   MEMO
   When attaching the blade, orient its tip correctly.



6. **When the replacement of the blade is complete, tap [Finish All].**

7. **When [Close the cover.] appears, close the front cover.**
   When you close the front cover, you are returned to the original screen.

8. **Tap to return to the home screen.**

2. Making Adjustments According to the New Blade

Procedure

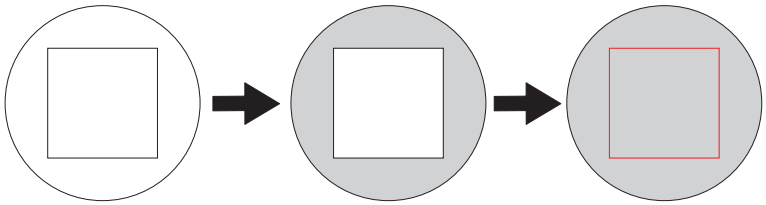
1. **Set up the media.**
2. **Tap** .
3. **Tap [Change] next to [Output Start Location].**
4. **Tap** , , , **or**  **to move the cutting carriage to the location where you want to carry out the cutting test.**

   You can freely set the location for the cutting test.
5. **Tap [Set Base Point Here].**

   You are returned to the home screen.
6. **Tap** .
7. **Tap [Media Settings]>[Cutting Settings]>[Blade Adjustment].**
8. **Tap [Execute] next to [Cutting Test].**

   The test pattern is cut.
9. **Check the results of the cutting test.**

   Check that the two shapes are peeled off separately, a blade trace (red line) remains on the backing paper, and the backing paper is not cut.



Check item	Result	Setting item	Adjustment
Check the shape.	The cut shape is distorted.	[Cutting Speed]	Reduce
Peel off the circle.	The square also peels off.	[Blade Force]	Increase
	Some uncut areas remain.	[Cutting Speed]	Reduce
Peel off the square.	The blade leaves faint traces on the backing paper.	[Blade Force]	No change
	The blade trace is indistinct.		Increase
	The blade trace is too deep and cuts into the backing paper.		Reduce

Check item	Result		Setting item	Adjustment
Check the shape of the square you have peeled off.		The corners are not rounded and do not have "horns."	[Blade Offset]	No change
		The corners are rounded.		Increase
		The corners have "horns."		Reduce

10. Tap − or + to change the settings.

Setting item	Setting details	Default setting
[Blade Force]	Set the force (pressure) of the blade.	50 gf (0.11 lbf)
[Cutting Speed]	Set the speed of cutting.	30 cm/s (11.81 in./s)
[Blade Offset]	Set the blade offset. Enter the listed offset value for the blade. The offset value for the included blade is 0.250 mm (9.8 mil).	0.250 mm (9.84 mil)
[Rise Movement Speed]	Set the blade's up speed during cutting (the speed at which the blade travels when it moves to the next cutting line after cutting one cutting line). If the media comes loose during no-load feed and the blade damages the surface of the media, reduce the speed.	30 cm/s (11.81 in./s)

11. Press [Save] to confirm your entry.

12. Repeatedly perform the cutting test and adjust the cutting conditions until the settings are optimized.

Repeat steps 8 to 11 to adjust the cutting conditions.

13. Tap  to return to the home screen.

3. Adjusting the Amount of Blade Extension

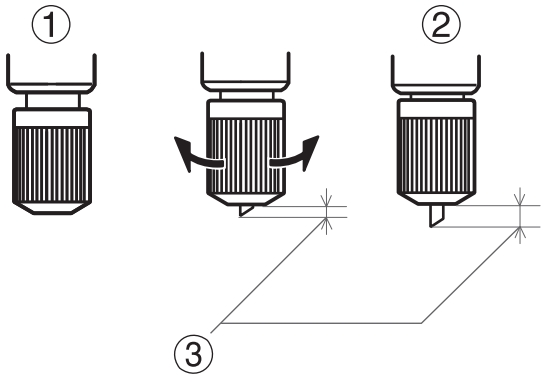
Adjustment When Not Cutting the Backing Paper (Normal Cut)

When you want to perform accurate and fine adjustment of the cutting-in amount, such as when cutting media with thin backing paper, you can obtain good results by adjusting the amount of blade extension (③).

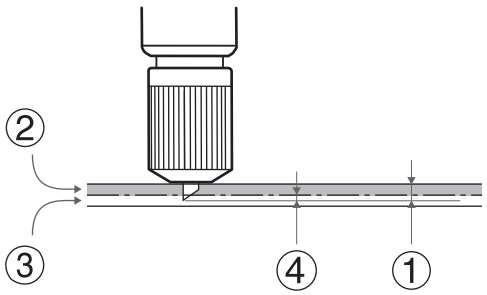
Turn the cap portion of the blade holder to adjust the amount of blade extension. Each indicator tick corresponds to 0.1 millimeters, and adjustment for 0.5 millimeters can be made by rotating the cap one full turn.

Note that making the amount of blade extension too small may cause the tip of the blade holder cap to touch the printed surface, soiling and damaging it. It is important to be especially careful about this when you are using media that has poor ink-adhesion properties.

The amount of blade extension (③) is 0 mm (0 in.) (①) at minimum and 2.5 mm (0.09 in.) (②) at maximum.



Set the amount of blade extension (①) to an amount that is the sum of the thickness of the media portion (②) and half (④) the thickness of the backing paper (③).



Adjustment when Cutting the Backing Paper (Perforated Cut)

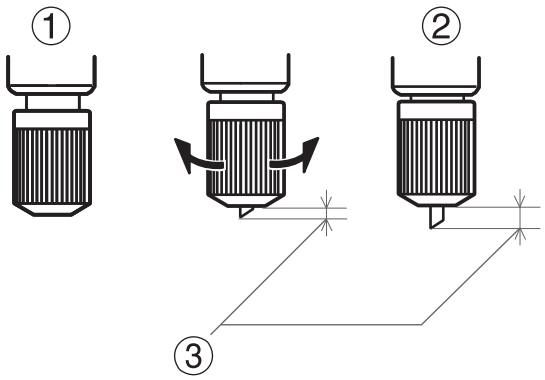
In cases when you want to cut out the printed part, or other cases when you want to cut through the backing paper, use perforated cutting.

IMPORTANT

This function specifies the location to perform perforated cutting in the print data, and performs cutting. This is different from the perforated sheet cutting that cuts to the backing paper at fixed intervals during sheet cutting used when separating the media.

Turn the cap portion of the blade holder to adjust the amount of blade extension. Each indicator tick corresponds to 0.1 mm (3.9 mil), and adjustment for 0.5 mm (19.7 mil) can be made by rotating the cap one full turn.

The amount of blade extension (③) is 0 mm (0 in.) (①) at minimum and 2.5 mm (0.09 in.) (②) at maximum.



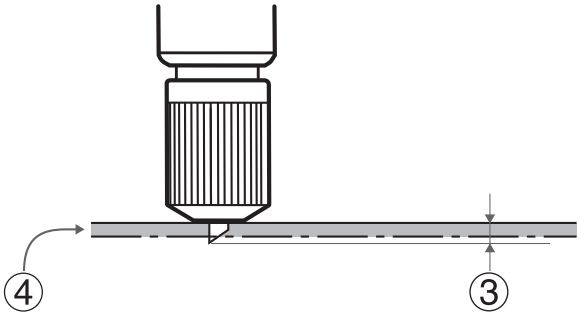
Set the amount of blade extension (③) so that when the cutter pierces the media (④), the blade extends slightly.

For information about the output settings for cutting perforated lines, refer to the documentation for VersaWorks.

https://downloadcenter.rolanddg.com/VersaWorks7

IMPORTANT

Pushing the blade out too far will damage the blade and blade protector and hasten their deterioration, so exercise caution.



Replacing the Separating Knife

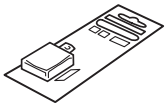
If the separating knife becomes dull, replace it with the included replacement knife.

⚠ 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 or burns.

⚠ CAUTION

Do not touch the tip of the separating knife.
Doing so may result in injury.

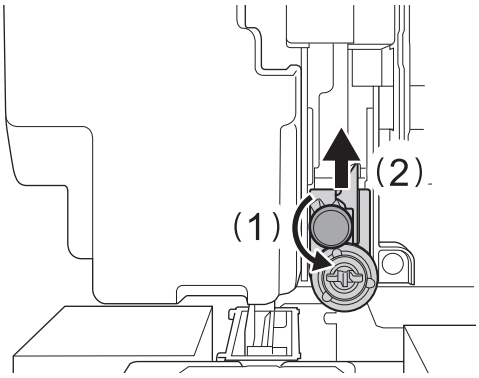
Required item

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 cutting carriage moves to a position where separating knife replacement is possible.
5. **Follow the instructions on the operation panel to replace the separating knife.**
   - Tap ‹ or › to check the procedure.
   - If you complete the work without viewing the instructions, tap [**Finish All**].

IMPORTANT

Use the following procedure to remove the separating knife.
1. Loosen the screw until it slips out.
2. Grasp the screw portion, and slowly pull in the direction of the arrow.
   When doing this, do not pull it back toward you.



6. When the separating knife replacement is finished, tap [Finish All].

7. When [Close the cover.] appears, close the front cover.
   When you close the front cover, you are returned to the original screen.

8. Tap to return to the home screen.

Inquiries for Consumable Parts and Products

Items That You Can Purchase or Perform by Yourself

To purchase the following consumable parts or products, contact your authorized dealer or visit our website (https://www.rolanddg.com/).

Item	Related page
Wiper	P. 305 Replacing the Wiper
Print head caps	P. 307 Replacing the Print Head Caps
Flushing sponge	P. 308 Replacing the Flushing Sponges
Cleaning sticks	P. 279 Performing Manual Cleaning
Cleaning liquid	
Blade	P. 309 Replacing the Blade
Separating knife	P. 315 Replacing the Separating Knife

Items That Require Inquiries before Replacement

When replacing the following consumable parts, contact your authorized dealer.

Item	Related page
Print heads	P. 279 Cleaning around the print heads

Troubleshooting Methods

Output Quality Problems

Printed results are coarse or contain horizontal stripes 320
Do the Print Heads Cause Dot Drop-out? 320
Is the print head height appropriate? 320
Have you carried out [**Feed Correction**]? 320
Have you carried out [**Media Gap Adjustment**] (ink landing position correction)? 320
Is the printer installed in a level and stable location? 321
Is the printer installed in a location that is not exposed to direct sunlight? 321
Is the Print Mode Suitable? 321
Is the media loaded correctly? 321
Are the [**Media Settings**] appropriate? 321
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Printed results are coarse or contain horizontal stripes

Do the Print Heads Cause Dot Drop-out?

Carry out a printing test and make sure no dot drop-out or dot displacement occurs. If dot drop-out or dot displacement is present, perform cleaning.

RELATED LINKS

- P. 140 Performing a Nozzle Drop-out Test
- P. 288 Performing Normal Cleaning
- P. 289 When Normal Cleaning Is Not Effective

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. 182 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 configure the setting in the RIP software to match the type of media you are using, or configure the setting for correction on the printer. 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. 177 Automatically Making Required Adjustments
- P. 178 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)

Have you carried out [Media Gap Adjustment] (ink landing position correction)?

The optimal adjustment varies depending on the height of the print heads and 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. 177 Automatically Making Required Adjustments
- P. 180 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 printer installed in a location that is not exposed to direct sunlight?

Never install the machine in a location that is exposed to direct sunlight. Doing so may result in dot drop-out or other problems with reduced printing quality, or may even result in malfunction.

Is the Print Mode Suitable?

If attractive printing is impossible, 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 RIP software (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, output may be adversely affected. Load the media correctly.

RELATED LINKS

- P. 32 Setup of New Media
- P. 76 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. 232 Changing the Settings of Registered Media

The media becomes soiled when printed

Do the print heads come into contact with the media?

The height of the print heads may be too low. Also, if the media is not loaded and set up correctly, it may wrinkle or come loose and contact the print heads.

RELATED LINKS

- P. 182 Changing the Print Head Height
- P. 32 Setup of New Media
- P. 76 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 print heads
- Ink transferred to the print heads due to rubbing against the media

If this happens, perform manual cleaning. We recommend carrying out periodic cleaning of the print heads.

RELATED LINKS

- P. 279 Cleaning around the print heads

Are the pinch rollers or the media clamps dirty?

Periodically clean them.

RELATED LINKS

- P. 277 Cleaning the Machine

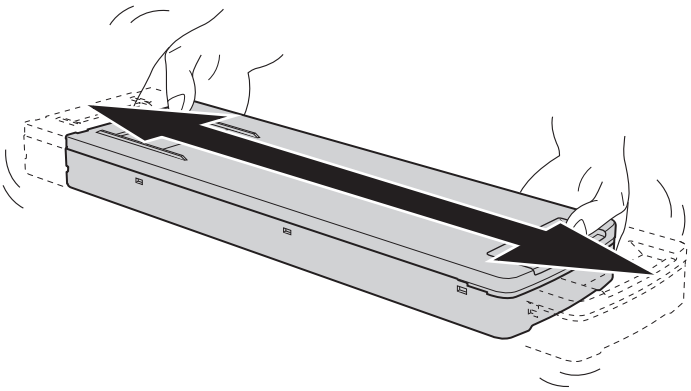
Is the humidity of the room too low?

Use the machine in an environment with a humidity of 35 to 80% RH (no condensation).

Colors are unstable or uneven

Did You Shake the Ink Cartridges before Installing Them?

Shake the ink cartridge 50 times (about 20 seconds), and then reinsert the cartridge. The precipitation of the ingredients in the ink disables printing in normal color. So that the ink mixes well, shake the ink cartridge horizontally with a stroke length of around 5 cm (1.97 in.) from each end of the ink cartridge.



Shake the ink cartridges:

- White ink: Each day (before starting the day's operations).
- Ink other than white ink: When replaced with a new cartridge or when uneven color issues occur

IMPORTANT

- **The ingredients in white ink tend to settle.**
  Allowing the ink to stand without shaking it can cause the settled material to harden, resulting in malfunction or other problems.
- **Before shaking the ink cartridge, wipe off any ink from around its mouth.**
  If you do not wipe off the ink, it may splatter when you shake the ink cartridge.
- **When you have finished mixing the ink, reattach the ink cartridge immediately.**
  Taking time to reattach the ink cartridge will adversely affect the ink path.

MEMO

To prevent ink precipitation, you can make the machine periodically display a message prompting you to mix the ink.
P. 253 Showing/Hiding Notifications

RELATED LINKS

- P. 127 Replacing Ink

Are colors still uneven after mixing the ink by shaking the ink cartridges?

If colors are still uneven after mixing the ink by shaking the ink cartridges, perform the procedure below.

- White ink
  1. Perform [**Ink Circulation**].
     If the uneven color issue is not corrected after performing [**Ink Circulation**], perform the following procedure.
  2. Perform [**Light Choke Cleaning**].

If the uneven color issue is not corrected after performing [**Light Choke Cleaning**], perform the following procedure.

3. Perform [**Ink Renewal**].
4. If the uneven color issue is not corrected after performing the above work, contact your authorized dealer.

- Ink other than white ink
  1. Perform [**Light Choke Cleaning**].

     If the uneven color issue is not corrected after performing [**Light Choke Cleaning**], perform the following procedure.
  2. Perform [**Ink Renewal**].
  3. If the uneven color issue is not corrected after performing the above work, contact your authorized dealer.

RELATED LINKS

- P. 291 Circulating the Ink
- P. 293 Performing Light Choke Cleaning
- P. 296 Renewing Ink

Is the media wrinkled?

If the media is wrinkled and comes loose from the platen, colors may be uneven or the printing quality may suffer.

RELATED LINKS

- P. 32 Setup of New Media
- P. 76 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. 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.

Was cleaning performed during printing?

Performing cleaning during printing can affect the print quality. Set [**Cleaning during Printing**] for [**Automatic Maintenance**] appropriately according to the object.

RELATED LINKS

- P. 273 Automatic Maintenance Feature and Notes

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, output may be adversely affected. Load the media correctly.

RELATED LINKS

- P. 32 Setup of New Media
- P. 76 Setup of Registered Media

Are the Operating Parameters Set to Appropriate Values?

Depending on the [**Printing Movement Range**] and [**Cleaning during Printing**] setting, uneven colors may occur. If the settings have been changed, try restoring them to their default values.

RELATED LINKS

- P. 240 Reducing the Output Time for Narrow Media
- P. 273 Automatic Maintenance Feature and Notes

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. 232 Changing the Settings of Registered Media

Are the irradiation windows of the UV-LED devices dirty?

If the irradiation windows are dirty, this can reduce ink adhesion and the quality of the printed materials. Check the level of dirt and clean at the appropriate times.

RELATED LINKS

- P. 281 Cleaning the UV-LED Device

Is the printer being used in a location subject to severe changes in the operating environment?

Large fluctuations in temperature or humidity while printing is in progress may cause the colors to change partway through the printing. When printing, use the machine in a location where the temperature and humidity are stable.

Cutting Is Misaligned or Skewed

Is the media loaded correctly?

If the media is not loaded correctly or the media feed is not smooth, output may be adversely affected. Load the media correctly.

RELATED LINKS

- P. 32 Setup of New Media
- P. 76 Setup of Registered Media

Are the settings for the cutting conditions appropriate?

Misalignment or skewing may occur if the cutting speed is too fast or the blade force is too high. Try changing the cutting conditions. With media having a strong adhesive layer, the adhesive layer reattaches to itself immediately after cutting. However, if a cutting test shows that the peeling of the media and the blade traces on the backing paper are optimal, the media is being cut properly. Be careful not to make the blade force too high.

RELATED LINKS

- P. 196 Accurately Adjusting the Cutting Settings

Is the length of output too long?

For printing followed immediately by cutting in particular, the longer the page length (that is, the longer the distance the media is returned after printing), the greater the chance of misalignment occurring. It is a good idea to keep the size of each single page to the minimum necessary.

Are you using media that exhibits large expansion and contraction?

When you are performing printing followed immediately by cutting, misalignment occurs if the media expands or contracts. If this happens, try performing printing with crop marks followed by cutting. The cutting position will be corrected to match the expansion and contraction of the media.

RELATED LINKS

- P. 211 Accurately Adjusting the Settings for Cutting with Crop Marks

Is the setting for the [Cutting Distance Correction] menu item (under [Cutting Settings]) correct?

When you are performing printing followed immediately by cutting, go to [**Cutting Settings**] and set the [**Cutting Distance Correction**] correction value to 0.00%.

RELATED LINKS

- P. 203 Performing Distance Correction during Cutting

Are the pinch rollers placed on the proper locations?

Be sure to place the pinch rollers on the grit rollers. If the pinch rollers are not placed on the proper locations, misalignment of the media may occur.

RELATED LINKS

- P. 32 Setup of New Media
- P. 76 Setup of Registered Media

Have you corrected the misalignment of printing and cutting?

Misalignment between the printing and cutting positions may occur due to the thickness of the media or the print head height. Make corrections for misaligned printing and cutting for the media you are using.

RELATED LINKS

- P. 206 Accurately Adjusting the Settings for Printing and Cutting
- P. 182 Changing the Print Head Height

Is the blade holder installed appropriately?

When installing the blade holder, firmly tighten the screw and check that the blade holder is fixed in place.

RELATED LINKS

- P. 309 Replacing the Blade

Is the blade worn?

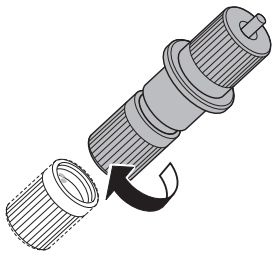
A worn or chipped blade will negatively affect the cutting quality. Check the status of the blade and replace it with a new one if necessary.

RELATED LINKS

- P. 309 Replacing the Blade

Is There Any Buildup of Pieces of Material or Dust Inside the Blade Holder?

Remove the blade holder, and then take off the cap part of the blade holder and remove any pieces of material or dust inside.



After cleaning, adjust the amount of blade extension.

RELATED LINKS

- P. 198 Adjusting the Amount of Blade Extension

Problems in Cutting with Crop Marks

Automatic Detection of Crop Marks Fails 330
Are the margins from the pinch rollers to the crop marks too small? 330
Is the media wrinkled or warped? 330
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Are you using media that is likely to reflect light or has deep colors? 330
Are You Using Black Crop Marks with Transparent Media? 330
Is the color of the printed crop mark different from the color of the crop mark set on the machine? 331
Printing and Cutting Are Misaligned 332
Have you corrected the misalignment of printing and cutting with crop marks? 332

Automatic Detection of Crop Marks Fails

Are the margins from the pinch rollers to the crop marks too small?

If the margins are too small or the pinch roller locations are not correct, it may not be possible to detect the crop marks. Check the margins and set the pinch rollers in the correct locations.

Is the media wrinkled or warped?

Wrinkled or warped media may cause crop mark detection to fail. Avoid using wrinkled or warped media.

Is the media size too large?

Large media may lead to large errors, which may cause crop mark detection to fail.

When you want to use lengthy media, we recommend performing output with the data separated into sizes that are as short as possible.

Are you using media that is likely to reflect light or has deep colors?

When black crop marks are printed on light-reflective media, it may not be possible to read the crop marks.

First, perform [**Multi Sensor Adjustment**]. If the machine still fails to read the crop marks, try changing to white crop marks.

Procedure

1. **Execute [Media Settings]>[Other Media Settings]>[Multi Sensor Adjustment] to correct the sensor for reading crop marks.**
2. **Tap [Media Settings]>[Cutting Settings]>[Crop Cut Position Adjustment].**
3. **Select [High] for [Crop Mark Detection Sensitivity].**

   [**Standard**] is set by default. When set to [**High**], [**Crop Mark Detection Sensitivity**] becomes higher.
4. **Detect the crop marks.**
   - When the machine successfully reads the crop marks: Cut with crop marks.
   - When the machine fails to read the crop marks: Print the crop marks in white. If the crop marks still cannot be read, change the media you are using.

RELATED LINKS

- P. 219 Correcting the Reading Sensor
- P. 241 Printing Crop Marks in White

Are You Using Black Crop Marks with Transparent Media?

With transparent media, the machine cannot read black crop marks. Print the crop marks in white.

RELATED LINKS

- P. 241 Printing Crop Marks in White

Is the color of the printed crop mark different from the color of the crop mark set on the machine?

If the set crop mark color is different from the actual printed crop mark color, crop mark detection may not be possible. Set the crop mark color to the same color as the crop mark being read.

RELATED LINKS

- P. 241 Printing with Crop Marks

Printing and Cutting Are Misaligned

Have you corrected the misalignment of printing and cutting with crop marks?

Depending on the composition of the media, the positioning of printing and cutting may be misaligned even when you are using crop marks. Make corrections for misaligned printing and cutting for the media you are using.

RELATED LINKS

- P. 211 Correcting the Misalignment of Printing and Cutting with Crop Marks (Concurrent Test for Printing and Cutting with Crop Marks)
- P. 214 Correcting the Misalignment of Printing and Cutting with Crop Marks (Separate Test for Printing and Cutting with Crop Marks)

Media Feed Problems

Media Wrinkles or Shrinks 334
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- Was loaded media allowed to stand for some time? 334
- Are the media clamps installed? 334
- Was the Media Loaded While the Front Heater Was Hot? 334
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- Is the humidity of the room too high? 334
- Is the media sagging? 334

Media Feeding Is Not Straight 335
- Is the media loaded and set up straight and securely? 335

Media Feeding Is Not Smooth 336
- Is some other object coming into contact with the media? 336
- Is the media too thick? 336
- Are the grit rollers dirty? 336

A Media Jam Occurs! 337
- Is an error message displayed? 337
- Is the media warped or wrinkled? 337
- Is the height of the print heads too low? 337
- Are the grit rollers dirty? 337
- Are the media clamps installed? 337
- Is the media loaded and set up straight and securely? 337
- Is some other object coming into contact with the media? 338
- Is the media too thick? 338

Media Wrinkles or Shrinks

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. 32 Setup of New Media
- P. 76 Setup of Registered Media

Was loaded media allowed to stand for some time?

Media may wrinkle if it is heated for an extended time. When printing ends, switch off the sub power and remove the media.

Are the media clamps installed?

When you are performing printing, be sure to install the media clamps.

Was the Media Loaded While the Front Heater Was Hot?

Setting up media after the front heater has turned on and warmed up causes the temperature of the media to rise suddenly, which may cause the media to wrinkle during printing. Before loading media, switch off the sub power and allow the apron to cool.

RELATED LINKS

- P. 193 Heating the Media to Prevent It from Coming Loose

Is the temperature of the front heater too high?

Set the temperatures to suitable values for the type of media.

RELATED LINKS

- P. 193 Heating the Media to Prevent It from Coming Loose

Is the humidity of the room too high?

Use the machine in an environment of 35 to 80%RH (no condensation).

High humidity can cause the media to sag. If sagging media is used, it may come out wrinkled.

Is the media sagging?

If sagging media is used, it may come out wrinkled.

Media Feeding Is Not Straight

Is the media loaded and set up straight and securely?

Feeding is not smooth when the media is not straight or is tensioned unevenly on the left and right. Reload the media.

RELATED LINKS

- P. 32 Setup of New Media
- P. 76 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. 32 Setup of New Media
- P. 76 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.

RELATED LINKS

- P. 378 Specifications

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. 277 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. 359 [Motor Error]

Is the media warped or wrinkled?

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

RELATED LINKS

- P. 334 Media Wrinkles or Shrinks

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. 182 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. 277 Cleaning the Machine

Are the media clamps installed?

Install the media clamps when performing printing.

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. 32 Setup of New Media
- P. 76 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. 32 Setup of New Media
- P. 76 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.

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- P. 378 Specifications

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Cannot Separate the Media 346
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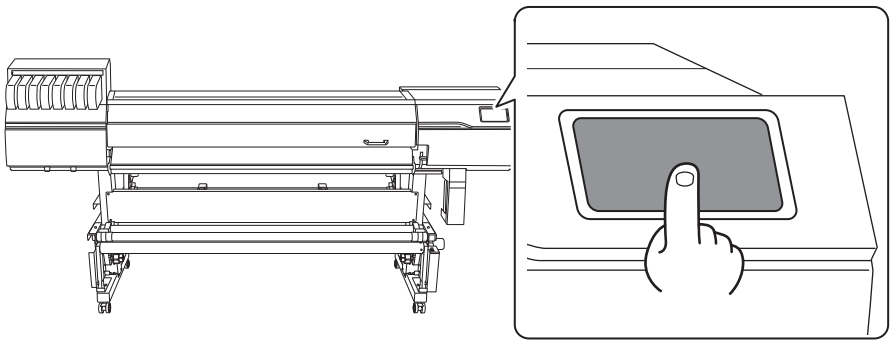
Why Has the Print-Head Carriage Stopped Moving?

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

Switch off the sub power, followed by the main power. Then, switch on the main power again, followed by the sub power.

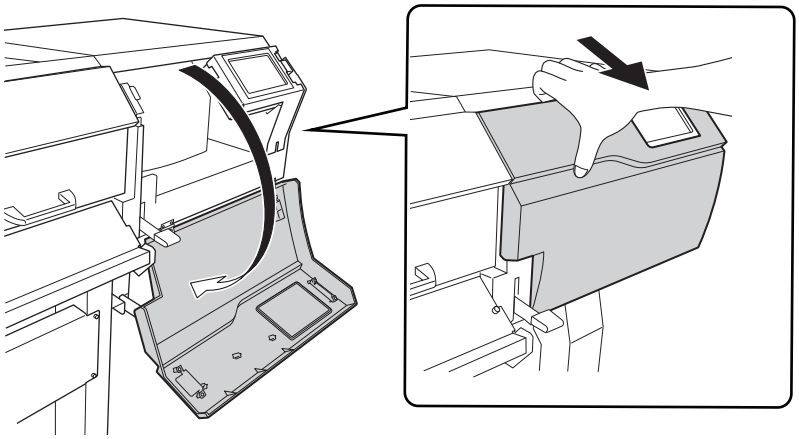
If the Print Heads Still Do Not Move

If the heads still do not move, carry out the following emergency response measure, and then contact your authorized dealer.

Procedure

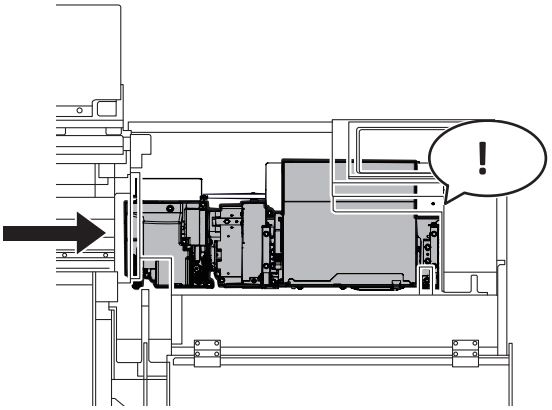
1. **Switch off the sub power, followed by the main power. Then, open the front cover.**

2. **Open the right cover.**



3. **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.



4. **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. 28 Turning the Power On

Is the Temperature of the Room Too Low?

The [**Temperature Too Low to Start**] screen may appear and printer startup may not be possible if the internal temperature is low when the sub power is turned on or when the unit returns from sleep mode.

Warm up the room or otherwise increase the internal temperature of the printer so that it can start.

Is the Message [Output possible.] Displayed?

If the printer does not operate even though you have sent print data, check that the media has been set up and that [**Output possible.**] is displayed in the status bar.

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. 142 Starting Output

Are Any Covers Open?

Close the front, left, and right covers and the rear UV shield.

Is a message displayed on the screen?

Follow the prompts and take action accordingly.

RELATED LINKS

- P. 349 Messages
- P. 355 Error Messages

Are the cables connected?

Connect the cables securely.

For details on cable connections, see the "Setup Guide."

RELATED LINKS

- MG2-640 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. Reconfigure 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 RIP software specifies the IP address set on the machine, that the settings have no typing errors, and for other such problems.

For details on the LAN settings, see the "Setup Guide."

RELATED LINKS

- P. 263 Viewing Network Information
- MG2-640 Setup Guide

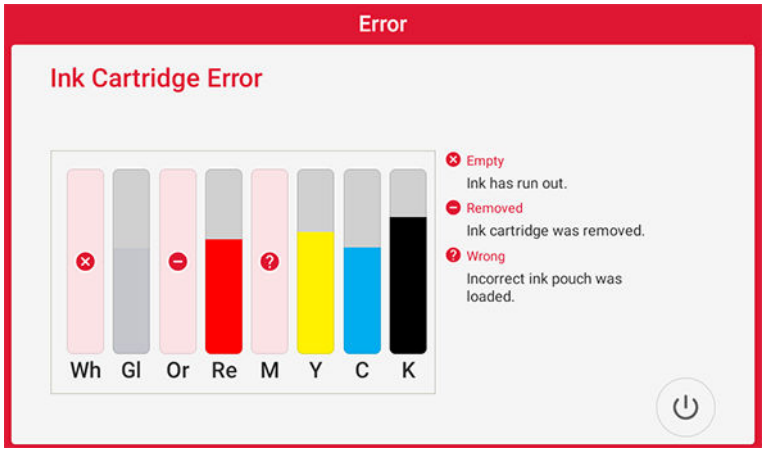
Did the RIP Software End Abnormally?

Make sure the RIP software is running correctly, then switch the sub power off and back on.

RELATED LINKS

- VersaWorks manual

Is an [Ink Cartridge Error] displayed?



When the screen shown in the figure is displayed, output data cannot be accepted. If there is data that has not yet been output remaining in the machine, output resumes when the error is cleared. If there is unsent data in the computer, output resumes when the data is resent.

When ink runs out

Replace the ink pouch in the ink cartridge with a new ink pouch.

When an ink cartridge with the incorrect color is loaded

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

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. 355 [Ink Cartridge Error]
- P. 127 Replacing Ink

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. 120 Pausing and Canceling Output

The Front Heater 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. 195 Setting the Front Heater Temperature

Is [Front Heater] turned on?

Set [**Front Heater**] to [**On**].

RELATED LINKS

- P. 195 Setting the Front Heater Temperature

Is the Temperature of the Room Too Low?

The front heater may not warm up sufficiently when the ambient temperature is less than 20°C (68°F). Also, even when the front heater reaches its set temperature, 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?

Check that the separating knife is installed.

RELATED LINKS

- P. 315 Replacing the Separating Knife

Messages on the Operation Panel

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- **[Print head protection mode has activated.]** 350
- **[Replace the cleaning liquid pouch.]** 350
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Messages

These are the main messages that appear on the machine's operation panel 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. 285 If the Discharged Fluid Disposal Message Appears

[The time for manual cleaning has arrived.]

This message appears when more than 1 week has elapsed since manual cleaning was last performed.

Tap [**The time for manual cleaning has arrived.**]>[**Execute**] to perform manual cleaning.

RELATED LINKS

- P. 279 Performing Manual Cleaning

[The time for UV lamp manual cleaning has arrived.]

This message appears when a certain length of time has passed since the last time UV lamp manual cleaning was performed.

Tap this notification to perform UV lamp manual cleaning.

RELATED LINKS

- P. 281 Cleaning the UV-LED Device

[Replace the wiper immediately. Leaving the printer in a state in which it does not have a wiper will lead to head damage.]

This message appears when there is no wiper.

Tap this notification to replace the wiper.

RELATED LINKS

- P. 305 Replacing the Wiper

[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. 305 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. 307 Replacing the Print Head Caps

[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. 308 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.

The printing time and the amount of ink consumed will both increase. To obtain optimal performance, we recommend that you use ink specified by Roland DG Corporation.

[Replace the cleaning liquid pouch.]

This message appears when the cleaning liquid runs out.

Replace the empty cleaning liquid pouch.

After inserting the cleaning liquid cartridge, the cleaning liquid pouch replacement confirmation screen appears.

- If you have replaced the cleaning liquid pouch, tap [**Yes**]. The amount of cleaning liquid remaining is reset.
- If you have not replaced the cleaning liquid pouch, tap [**No**]. The amount of cleaning liquid remaining is not changed.

MEMO

If you tap [**Yes**] on the cleaning liquid pouch replacement confirmation screen even though you have not replaced the cleaning liquid pouch, the amount of cleaning liquid remaining is reset. In this situation, no notification will appear even if the amount of cleaning liquid remaining is very small, and the message [**Replace the cleaning liquid pouch.**] will appear when the cleaning liquid runs out. To ensure you have enough time to prepare the replacement cleaning liquid, tap [**No**] if you have not replaced the cleaning liquid.

RELATED LINKS

- P. 132 Cleaning Liquid Pouch Replacement

[Install the cleaning liquid pouch.]

This is displayed when the cleaning liquid cartridge is removed from the machine, or when a cleaning liquid cartridge that does not contain a cleaning liquid pouch is loaded.

Immediately install a new cleaning liquid pouch or immediately insert the cleaning liquid cartridge.

After inserting the cleaning liquid cartridge, the cleaning liquid pouch replacement confirmation screen appears.

- If you have replaced the cleaning liquid pouch, tap [**Yes**]. The amount of cleaning liquid remaining is reset.
- If you have not replaced the cleaning liquid pouch, tap [**No**]. The amount of cleaning liquid remaining is not changed.

MEMO

If you tap [**Yes**] on the cleaning liquid pouch replacement confirmation screen even though you have not replaced the cleaning liquid pouch, the amount of cleaning liquid remaining is reset. In this situation, no notification will appear even if the amount of cleaning liquid remaining is very small, and the message [**Replace the cleaning liquid pouch.**] will appear when the cleaning liquid runs out. To ensure you have enough time to prepare the replacement cleaning liquid, tap [**No**] if you have not replaced the cleaning liquid.

RELATED LINKS

- P. 132 Cleaning Liquid Pouch Replacement

[The time for ink mixing has arrived.]

This message appears when it is time to mix the ink.

When [**Ink Mixing Notification**] accessed with [**Preferences**]>[**Notifications On/Off**] is on, this message appears when 24 hours elapse from the last time the ink was mixed.

Tap [**The time for ink mixing has arrived.**] to display the confirmation screen.

Remove just the ink cartridge for the white ink, shake it 50 times (about 20 seconds), and then reinsert this cartridge. On completion, tap [**Yes**].

[Operation of the take-up unit stopped.]

This message appears and the take-up unit stops when it is not possible to detect the position of the dancer roller for a continuous length of time during media feeding or pull back.

Tap [**Operation of the take-up unit stopped.**] and follow the instructions on the screen to recover the take-up unit.

[Place the middle pinch rollers over all the grit rollers.]

This message appears when the middle pinch rollers have not been properly placed.

Position these pinch rollers properly between the left and right pinch rollers.

RELATED LINKS

- P. 32 Setup of New Media
- P. 76 Setup of Registered Media

[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. 32 Setup of New Media
- P. 76 Setup of Registered Media

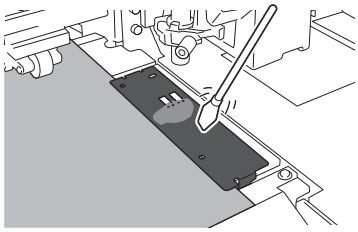
[Media clamps could not be detected.]

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. 32 Setup of New Media
- P. 76 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.

[There is ink that has expired.]

Ink has expired.

Replace with an ink pouch that is within its expiration date.

RELATED LINKS

- P. 128 Replacing Ink

[The media could not be detected automatically. Manually set the printing area.]

This message appears when a pinch roller position cannot be read, such as when media with high reflectance is set up. Manually set the printing area.

- To perform setup again: Tap [**Cancel**].
- To manually set the printing area: Tap [**OK**].

[Turn on the power. Cleaning will start.]

This message appears when the following situations occur 24 hours or more after the previous cleaning.

- **An ink cartridge is empty or is not inserted.**
- **The message [Discard the discharged fluid in the bottle.] appears.**

Check the ink cartridges or dispose of discharged fluid, and then switch on the sub power.

RELATED LINKS

- P. 127 Replacing Ink
- P. 283 Disposing of Discharged Fluid

[Printing could not start.]

[Check the status of VersaWorks. (When printing is already in progress or when the print data is larger than the printing area.)]

This message is displayed when a printing area error or a pop-up window indicating, for example, that the remaining ink is low is displayed in VersaWorks.

Check VersaWorks.

[Check the status of VersaWorks. (One possibility is that the job could not be found.)]

This message is displayed when no job is found in VersaWorks even though you have executed [Direct Printing].

Check the VersaWorks job list.

[Failed to connect to VersaWorks.]

[Restart VersaWorks.]

This message is displayed when communication with VersaWorks fails.

Restart VersaWorks on the computer.

[Communication with Roland DG Connect Hub was not possible.]

[Check the status of the connection between Roland DG Connect Hub and VersaWorks.]

This message is displayed when the printer and Roland DG Connect Hub cannot communicate with each other.

Check the network connection of the printer and computer. Then, verify that Roland DG Connect Hub and VersaWorks are running.

[Try again later.]

This message is displayed when Roland DG Connect Hub cannot establish an external connection.

Wait some time, and then try again.

Error Messages

This section describes the error messages that may appear on the machine's operation panel and how to take action to remedy the problem.

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 of an incorrect color or incorrect type is loaded**

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

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

  When an ink cartridge is removed, − **[Ink cartridge was removed.]** is displayed.

[Cover Open Error]

The front, left, or right cover or the rear UV shield is open.

For safety, some carriage operations are limited while a cover is open. Close the front, left, and right covers and the rear UV shield.

[Media End Error]

This is displayed if the amount of remaining media is insufficient when feeding media during printing output.

Switch to new media, and then send the data again.

[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 Edge Detection] is set to [Enable] and media has not been fed with the pinch rollers set incorrectly.**

Raise the loading lever, set the pinch rollers correctly, and then set up the media again.

This message appears when **[Media Edge Detection] is set to [Enable] and the media is too short.**

The media is not long enough to be detected. Raise the loading lever, set [**Media Edge Detection**] to [**Disable**], and then set up the media again.

For the setup method when [**Media Edge Detection**] is set to [**Disable**], refer to 1. B: Determining the Positions of Media (If [Media Edge Detection]: [Disable])(P. 65).

RELATED LINKS

- P. 32 Setup of New Media
- P. 76 Setup of Registered Media

[Drain Bottle Error]

[Discard the discharged fluid in the drain bottle.]

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.**].

[Install the drain bottle.]

This message appears when the drain bottle is removed or has shifted out of place.

Install or reinstall the drain bottle.

[Crop Mark Detection Error]

[Crop marks could not be detected.]

The machine may not be able to read crop marks printed on media that is likely to reflect light or has deep colors. Perform the following operations.

Procedure

1. **Execute [Media Settings]>[Other Media Settings]>[Multi Sensor Adjustment] to correct the sensor for reading crop marks.**
2. **Tap [Media Settings]>[Cutting Settings]>[Crop Cut Position Adjustment].**
3. **Select [High] for [Crop Mark Detection Sensitivity].**

   [**Standard**] is set by default. When set to [**High**], [**Crop Mark Detection Sensitivity**] becomes higher.

   If the crop marks still cannot be read, change the media you are using.

[Crop marks were detected however the size or position was incorrect.]

Load the media at the correct position and perform detection of crop marks again. If repeating automatic crop-mark detection also results in an error, start over again from the printing of crop marks.

RELATED LINKS

- P. 32 Setup of New Media
- P. 76 Setup of Registered Media
- P. 161 How to Cut with Crop Marks
- P. 219 Correcting the Reading Sensor
- P. 330 Are you using media that is likely to reflect light or has deep colors?

[Wiper Error]

[Replace the wiper.]

This message appears when there is no wiper during cleaning.

Replace the wiper.

[Load the wiper correctly.]

This message appears when it is not possible to take up the wiper after wiper replacement.

Reattach the wiper.

[Unable to Fill Wiper Cleaning Liquid]

[Replace the cleaning liquid pouch.]

The cleaning liquid pouch ran out while supplying this liquid for cleaning or to the wiper tray.

Quickly replace this cleaning liquid pouch with a new one.

[Install the cleaning liquid pouch.]

Install the cleaning liquid pouch into the cleaning liquid cartridge, and insert the cleaning liquid cartridge into the slot.

[Pinch Roller Error]

The left (right) pinch roller is positioned at a location where it cannot pinch the media.

Raise the loading lever and move the pinch roller to the correct location.

RELATED LINKS

- P. 32 Setup of New Media
- P. 76 Setup of Registered Media

[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 heads are capped and the data is canceled to prevent the heads from drying out.

RELATED LINKS

- P. 182 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 wider piece of media, and then send the data again.

MEMO

There is no limitation on the size of the data in the media-feed (FEED) direction.

[Crop marks cannot be added because the print data is larger than the media width. Continue output?]

The printing area is not large enough for print data with crop marks. This message also appears when the print data width is 60 mm (2.36 in.) or less.

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**]. Replace the media with a wider one. Alternatively, change the print data width to 60 mm (2.37 in.) or more, and then send the data again.

[ConnectHub communication error]

This is displayed when the remaining media management function is used and any of the following has occurred.

- Roland DG Connect Hub has not been launched on the computer.
- This machine is not registered in Roland DG Connect Hub.
- Roland DG Connect Hub cannot communicate with the outside.
- A subscription for Roland DG Connect has not been made.

Eliminate the cause of the error, and then tap [**OK**]. The [Remaining Media Management] screen appears.

[Barcode scanning error]

This is displayed when reading the remaining media barcode fails during roll media setup.

Reload the media correctly, and then tap [**OK**]. The [Remaining Media Management] screen appears.

RELATED LINKS

- P. 32 Setup of New Media
- P. 76 Setup of Registered Media

[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.

[Motor Error]

This message appears when an error such as the motor being under load occurs.

Operation cannot be continued. First, 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 media jam, an operation that pulls the media with excessive force, or the media not being loaded correctly.

- If a media jam occurs

  Carefully remove the jammed media. The print heads may also be damaged. Perform cleaning, and then perform a printing test and check the results.
- If the media is pulled with excessive force

  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 the ambient temperature at which it can operate.

Operation cannot be continued. Turn off the sub power.

The displayed temperature is the current temperature inside the machine. Bring the installed location to a temperature at which operation is possible (20°C to 32°C [68°F to 89.6°F]), allow the machine to come to room temperature, and then turn on the power.

RELATED LINKS

- P. 28 Power Supply Operations

[High Temperature Error]

The internal temperature of the machine has risen above the ambient temperature at which it can operate.

Operation cannot be continued. Turn off the sub power.

The displayed temperature is the current temperature inside the machine. Bring the installed location to a temperature at which operation is possible (20°C to 32°C [68°F to 89.6°F]), allow the machine to come to room temperature, and then turn on the power.

RELATED LINKS

- P. 28 Power Supply Operations

[Pump Stop Error]

This message appears in situations such as when an ink cartridge is pulled out during pump operation, such as during cleaning, and is left in this state for 10 minutes or more.

Operation cannot be continued. Resolve any issues that may cause the pump to stop, such as by inserting any removed ink cartridges. Then, switch the sub power off and 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.

[Cleaning Error (Ink Cartridge)]

This message appears in the following situations:

- An ink cartridge is pulled out or becomes empty during [**Light Choke Cleaning**].
- A cartridge is pulled out during the initial ink filling.

Operation cannot be continued.

For [**Light Choke Cleaning**], perform the following.

1. Check that the ink cartridges are inserted and that there is sufficient ink. Replace any empty ink cartridges.
2. Switch the sub power off and back on.
3. Perform [**Ink Renewal**].
4. Perform [**Light Choke Cleaning**].

When performing ink filling for the first time, install the cartridge, switch the sub power off and then back on, and then restart the ink filling procedure.

RELATED LINKS

- P. 293 Performing Light Choke Cleaning
- P. 296 Renewing Ink

[Cleaning Error (Drain Bottle)]

This message appears when the amount of waste liquid exceeds the specified limit during [Light Choke Cleaning] or the first ink filling procedure for the machine, or when the drain bottle is removed.

Operation cannot be continued.

For [**Light Choke Cleaning**], perform the following.

1. Discard the discharged fluid in the drain bottle, and then attach this bottle again.
2. Check that the ink cartridges are inserted and that there is sufficient ink.
3. Switch the sub power off and back on.

4. Perform [**Ink Renewal**].
5. Perform [**Light Choke Cleaning**].

When performing ink filling for the first time, attach the drain bottle, switch the sub power off and then back on, and then restart the ink filling procedure.

RELATED LINKS

- P. 293 Performing Light Choke Cleaning
- P. 296 Renewing Ink

[Print Head Error]

This is displayed when an unusable print head is installed.

After turning the power off, contact your authorized dealer.

[Printer start failed.]

This message appears when the printer fails to start.

Switch off the main power, then switch on the main power, followed by the sub power.

Appendix

Operations When Moving the Unit

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Preparing to Move the Machine

Before moving the machine, dispose of the discharged fluid and secure the print-head carriage in place. Also, when using white ink, performing [**Ink Circulation**] will be necessary. Attempting to move the machine without proper preparation may result in damage to the print heads or damage to internal components due to leaking ink.

IMPORTANT

- Once the preparations for moving the machine are complete, move the machine promptly and turn on the machine as soon as possible after the machine is relocated. If you leave the machine alone without turning it on, the precipitated ink will coagulate and result in problems such as the clogging of the print heads.
- When moving the machine, keep it at a temperature from 5 to 40°C (41 to 104°F) and at a humidity from 20 to 80% RH (with no condensation). Failure to do so may result in a breakdown.
- Handle the machine with care when moving it, keeping it level (not tilted at an angle) and preventing it from striking other objects.

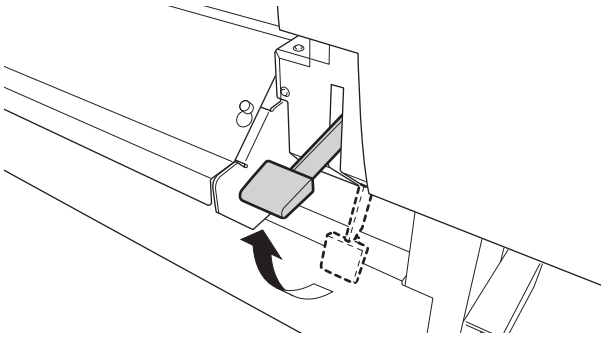
Step 1: Removing Media and the Blade Holder

MEMO

The procedure for replacing the blade is displayed on the operation panel, but this section only describes the work for removing the blade.

Procedure

1. **Remove any media.**
2. **Raise the loading lever.**



3. **Tap** ☰.
4. **Tap [Maintenance]>[Blade Replacement].**
   The [**Blade Replacement**] screen appears.
5. **Tap [Execute].**
   The cutting carriage moves to a position where blade replacement is possible.
6. **When [Open the front cover.] appears, open the front cover.**
7. **Detach the blade holder.**
8. **Tighten the screw.**

9. Tap [Finish All].

10. Close the front cover.

Step 2: Circulating the Ink (Only When Using White Ink)

This operation is not required for the four color (cyan, magenta, yellow, and black) ink type. Proceed to Step 3: Discarding the Discharged Fluid(P. 367).

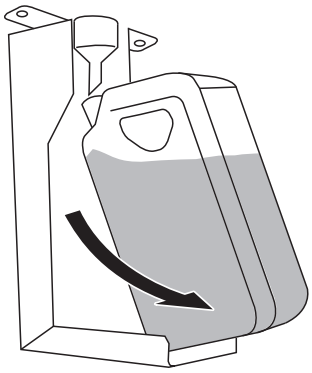
Procedure

1. **Tap** .
2. **Tap [Maintenance]>[Ink Circulation].**
   The [**Ink Circulation**] screen appears.
3. **Tap [Execute].**
   Ink circulation starts.

Step 3: Discarding the Discharged Fluid

Procedure

1. Tap ☰.
2. Tap [Maintenance]>[Drain Bottle].
3. Tap [Execute].
4. Tap [OK].
5. Remove the drain bottle and discard the discharged fluid.



IMPORTANT

When you remove the drain bottle, a few drops of discharged fluid may come out of the machine. Exercise caution to prevent this fluid from soiling your hands or the floor.

⚠ WARNING

Never place discharged fluid or ink near an open flame.
Doing so may cause a fire.

⚠ CAUTION

To store discharged fluid temporarily, place it in the included drain bottle or in a durable sealed container such as a metal can or polyethylene tank, and cap the container tightly.
Any spillage or vapor leakage may cause fire, odor, or physical distress.

IMPORTANT

Dispose of discharged fluid properly, in accordance with the laws in effect in your locale.
Discharged fluid is flammable and contains toxic ingredients. Never attempt to incinerate discharged fluid or discard it with ordinary trash. Also, do not dispose of it in sewer systems, rivers, or streams. Doing so may have an adverse impact on the environment.

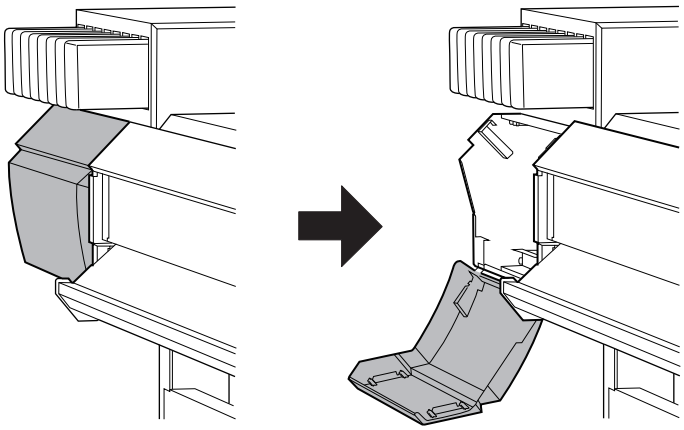
6. Quickly attach the emptied drain bottle to the machine once more.
7. Tap [Finish].

8. Turn off the sub power followed by the main power.

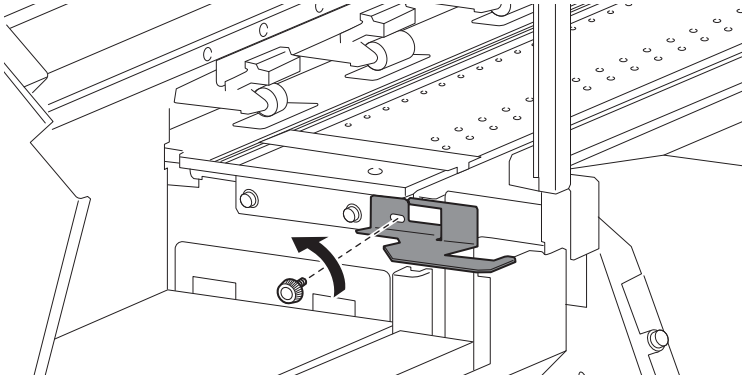
Step 4: Securing the Print-head Carriage in Place Using the Retainer

Procedure

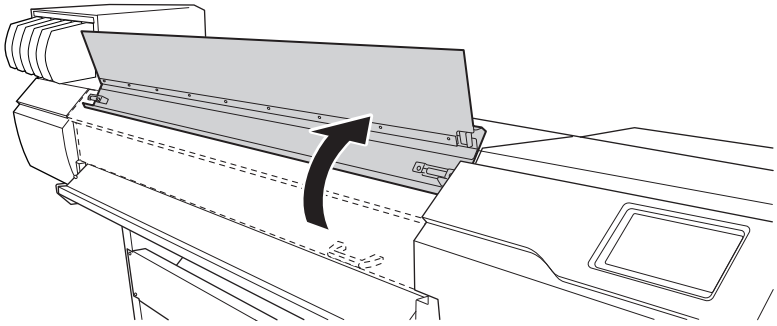
1. Open the left cover.



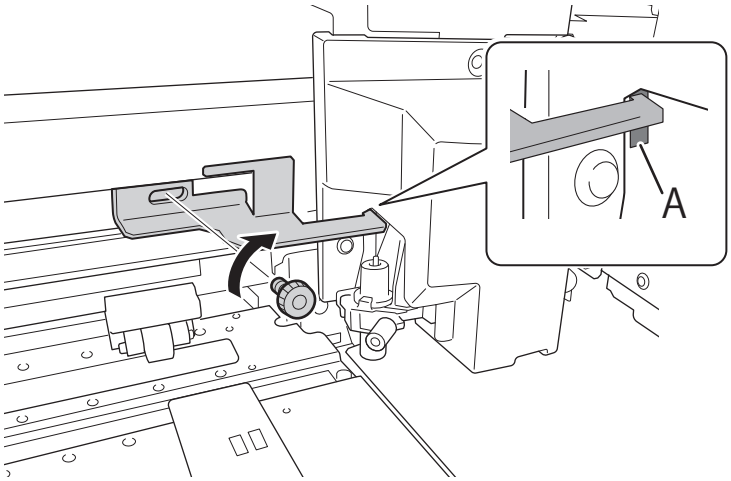
2. Remove retainer C.



3. Open the front cover.



4. Hook the removed retainer C into hole A, then fasten with a screw at the position shown in the figure to fasten the cutting carriage in place.

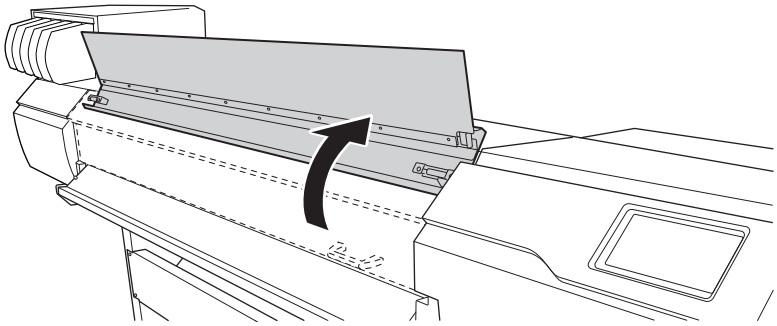


5. **Close the front and left covers.**

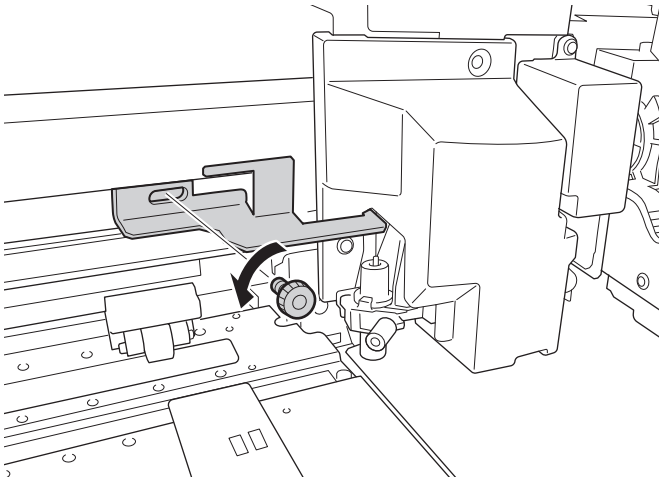
Step 5: Reinstalling the Machine

Procedure

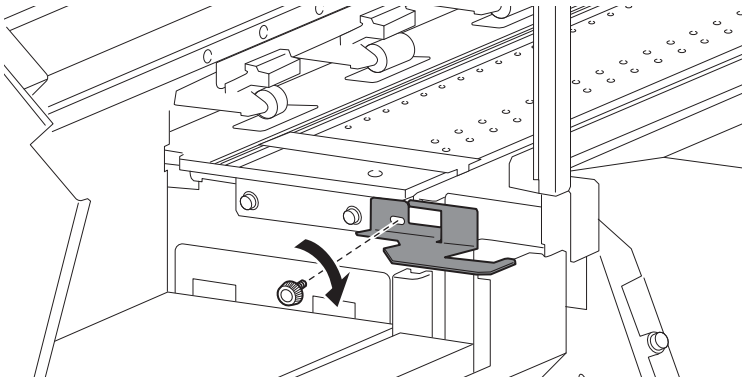
1. Once the preparations are complete, move the machine with as little delay as possible.
2. Immediately reinstall the machine, and then open the front cover.



3. Remove retainer C that was fastening the cutting carriage.



4. Open the left cover.
5. Install retainer C at the position indicated in the figure for storage.



6. Close the front and left covers.
7. Turn on the main power switch.

IMPORTANT

To prevent the print heads from being damaged, move the machine with as little delay as possible and switch on the main power as soon as possible after moving the machine. To install the machine again, follow the procedure in the Setup Guide.

8. **Press the sub power button.**

The home screen appears.

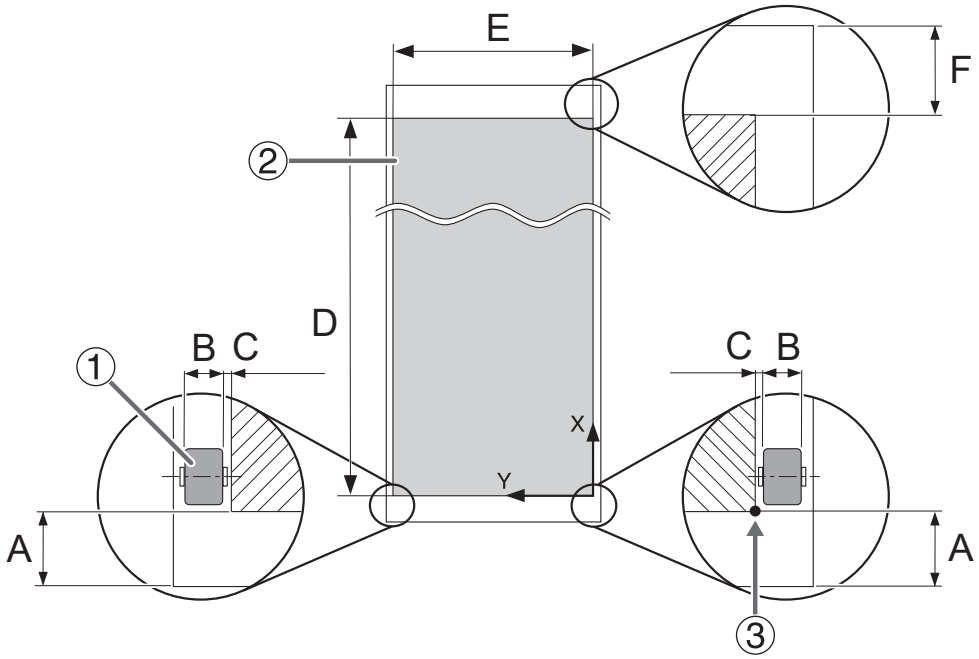
Main Specifications

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Printing/Cutting Area

Maximum Area

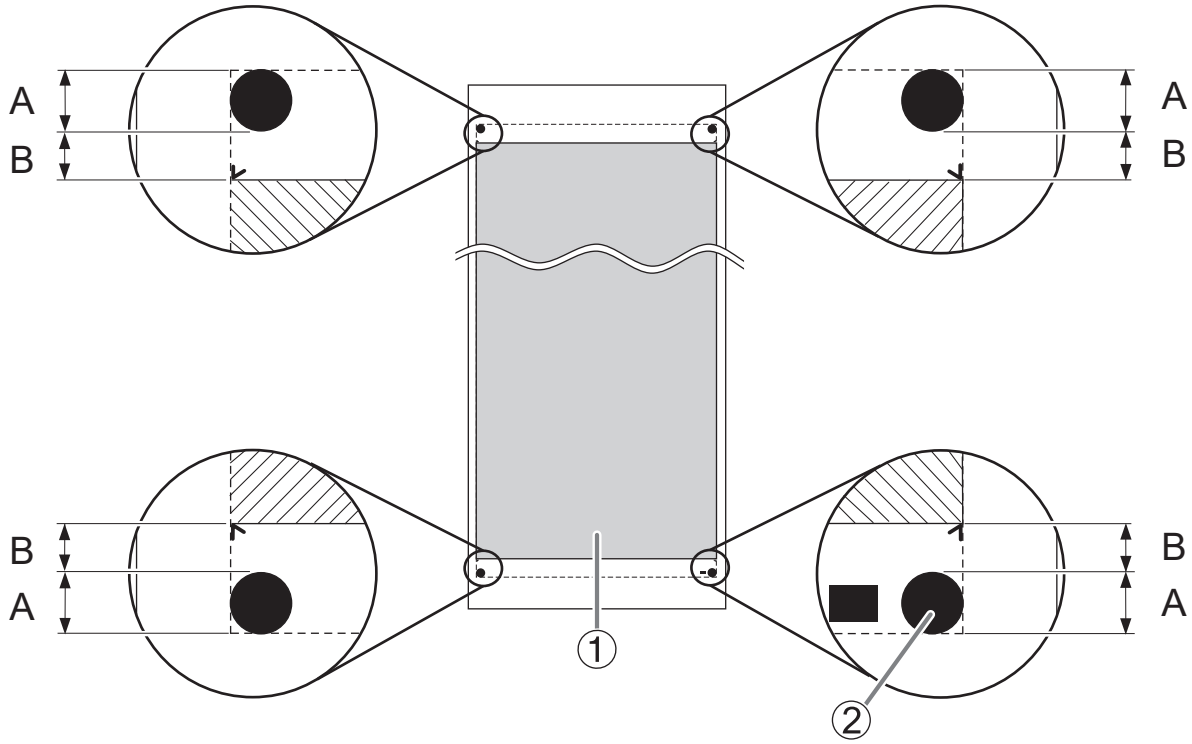
The printing or cutting area along the horizontal plane of the loaded media (the direction in which the print-head carriage moves: Y) is determined by the positions of the pinch rollers.



①	Pinch roller
②	Printing or cutting area
③	Printing or cutting coordinates origin (0,0)
A	75 mm (2.95 in.)
B	10 mm (0.39 in.)
C	1.5 mm (0.06 in.)
D	Max. 24,998 mm (984.17 in.)
E	64-inch model: Max. 1,600 mm (63 in.) 30-inch model: Max. 736 mm (28.97 in.)
F	160 mm (6.3 in.)

Maximum Printing Area When Using Crop Marks

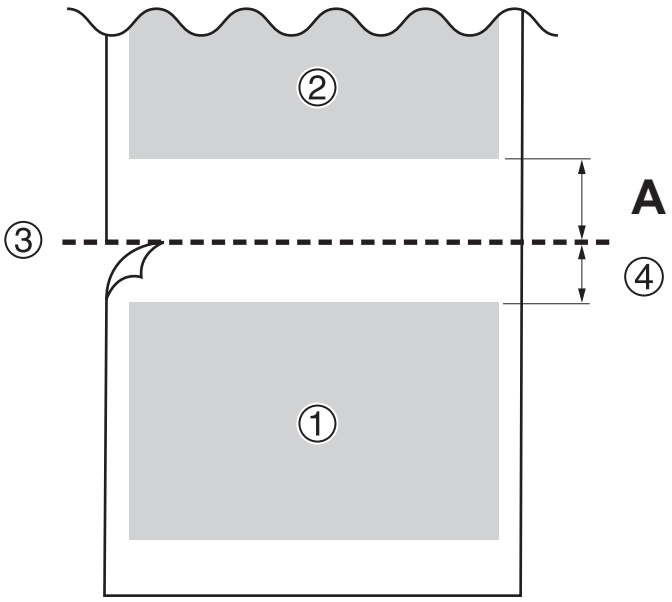
The maximum printing area when crop marks are used is reduced from the maximum printing area when crop marks are not used by an amount equal to the crop marks.



①	Printing or cutting area
②	Crop mark
A	12.5 mm (0.5 in.)
B	10 mm (0.4 in.)

Media Separation Location during Continuous Printing

When a command for separating the media is sent from the computer, the separation location on the media is as shown in the figure below.



①	First page
②	Second page
③	Separation location
④	Margin (RIP software value)
A	35 to 75 mm (1.38 to 2.95 in.) (Default value: 75 mm (2.95 in.))

About the Blade

The cutting conditions and the service life of the blade change according to the media and the operating environment, even when you're using identical blades. The service life also differs according to the type of blade. A rough guide is shown below.

Blade	Media	Blade force	Amount of blade offset (amount of blade tip correction)	Blade life (general guide)*1
ZEC-U5032	General Signage Vinyl	30 to 100 gf	0.25 mm (0.01 in.)	8,000 mm (26,246.7 ft.)
ZEC-U5025	General Signage Vinyl	30 to 100 gf	0.25 mm (0.01 in.)	4,000 mm (13,123.4 ft.)
	Fluorescent Vinyl	120 to 200 gf	0.25 mm (0.01 in.)	4,000 mm (13,123.4 ft.)
	Fluorescent Vinyl	100 to 200 gf	0.25 mm (0.01 in.)	4,000 mm (13,123.4 ft.)

*1 The values for "Blade life" are estimates for when an identical type of media is used.

When uncut areas remain even when the blade force is increased to a value that is higher than the values shown in this chart by 50 to 60 gf, replace the blade.

Specifications

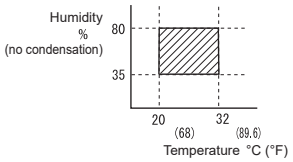
		MG2-640	MG2-300
Printing method		Piezo ink-jet method	
Media	Width	335 to 1,625 mm (13.19 to 64 in.)	182 to 762 mm (7.2 to 30 in.)
	Thickness	Maximum 1.0 mm (39.3 mil) with liner, for printing Maximum 0.4 mm (15.7 mil) with liner and 0.22 mm (8.6 mil) without liner, for cutting	
	Roll outer diameter	Max. 250 mm (9.8 in.)	
	Roll weight	Max. 45 kg (99 lb.)	Max. 30 kg (66 lb.)
	Core diameter	76.2 mm (3 in.) or 50.8 mm (2 in.)	
Printing/cutting width[*1]		Max. 1,600 mm (62.9 in.)	Max. 736 mm (28.9 in.)
Ink	Type	UV Ink (EUV5EP) 1,000 mL pouch	
	Color	Eight colors (Cyan, Magenta, Yellow, Black, Gloss, White, Orange, and Red) Seven colors (Cyan, Magenta, Yellow, Black, White (2 pouches), Orange, and Red) Six colors (Cyan, Magenta, Yellow, Black, Gloss (2 pouches), and White (2 pouches)) Four colors (Cyan (2 pouches), Magenta (2 pouches), Yellow (2 pouches), and Black (2 pouches))	
Ink-curing unit		Built-in UV-LED lamps	
Printing resolution (dots per inch)		Max. 1,800 dpi	
Cutting speed		10 to 300 mm/s (0.39 to 11.8 in./s)	
Blade force[*2]		30 to 500 gf	
Blade	Type	Roland CAMM-1 series compatible	
	Offset	0.000 to 1.500 mm (0.0 to 59 mil)	
Software resolution (when cutting)		0.025 mm/step (0.98 mil/step)	
Media heating system[*3]		Front heater set temperature: 30 to 55°C (86 to 131°F)	
Connectivity		Ethernet (100BASE-TX/1000BASE-T, automatic switching)	
Power-saving function		Automatic sleep feature	
Rated input		100–120/220–240 VAC, 50/60 Hz, 5.3/2.7 A	100–120/220–240 VAC, 50/60 Hz, 4.1/2.0 A
Power consumption	During operation	Approx. 700 W	Approx. 550 W
	Sleep mode	Approx. 65 W	
Acoustic noise level	During operation	66 dB (A) or less	
	During standby	62 dB (A) or less	
Dimensions (Width × Depth × Height)		2,902 mm × 748 mm × 1,412 mm (114.3 in. × 29.5 in. × 55.6 in.)	2,038 mm × 748 mm × 1,412 mm (80.3 in. × 29.5 in. × 55.6 in.)
Weight		210 kg (463 lb.)	165 kg (364 lb.)
Environment	During operation[*4]	Temperature: 20 to 32°C (68 to 89.6°F), humidity: 35 to 80%RH (no condensation)	
	Not operating	Temperature: 5 to 40°C (41 to 104°F), humidity: 20 to 80%RH (no condensation)	
Included items		Dedicated stand, power cord, media take-up unit, media holders, replacement blade for separating knife, cleaning liquid bottle for maintenance, drain bottle, User's Manual, download version of software (VersaWorks, Roland DG Connect Hub), etc.	

*1 The length of printing or cutting is subject to the limitations of the application software.

*2
- 500 gf is the maximum instantaneous blade force.
- The blade force must be adjusted according to details such as the media thickness.

*3
- Warm-up is required after power up. This may require 5 to 20 minutes, depending on the operating environment.
- Depending on the ambient temperature and the media width, the set temperature may not be reached.

*4 Operating environment (Use the machine in an operating environment within these ranges.)


Humidity
%
(no condensation)
80
35
20
(68)
32
(89.6)
Temperature °C (°F)

Memo

Software 381

Software

This product is equipped with an "eT-Kernel Multi-Core Edition" eT-Kernel and a "PrCONNECT(R)/Pro" TCP/IP protocol stack, both made by eSOL Co., Ltd. eT-Kernel and PrCONNECT are registered trademarks of eSOL Co., Ltd.

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