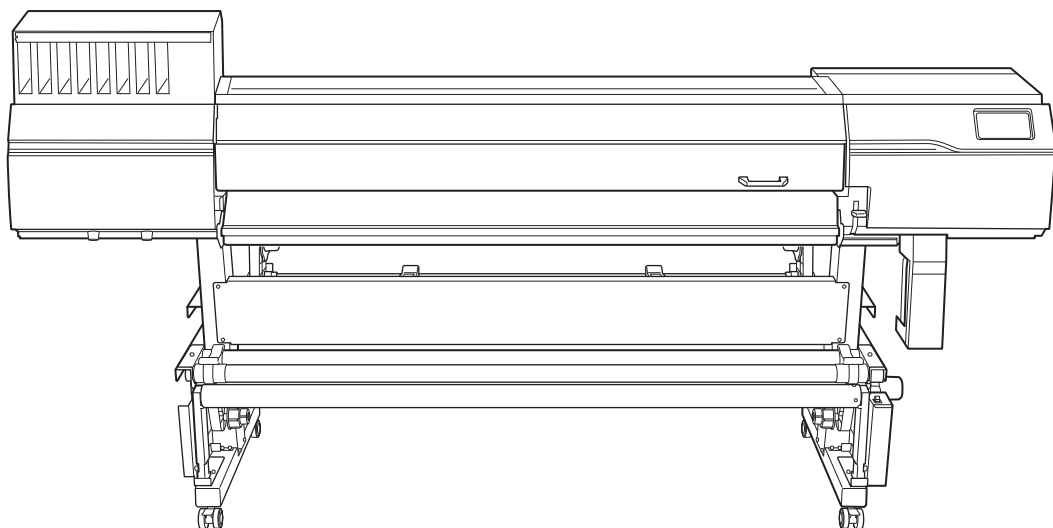


TrueVIS XP-640

User's Manual



Thank you very much for purchasing this product.

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

<https://www.rolanddg.com/>

Contents

Basic Handling Methods	7
Basic Information	8
Part Names and Functions	9
Printer Unit	9
Operation Panel	15
Take-up Unit	20
About the Media Used	21
Types of Media	21
Conditions for Usable Media	22
Take-up Unit	23
Take-up Unit Use Conditions	23
About the Paper Tube	23
Drain Bottle	24
Precautions for Disposing of Discharged Fluid	24
Basic Operations	25
Power Supply Operations	26
Turning the Power On	26
Turning the Power Off	27
Precautions When Operating the Power Supply	28
Sleep Mode (Power-saving Feature)	29
Setup of New Media	30
Setup of Roll Media	30
Setup of Sheet Media	53
Setup of Registered Media	65
Setup of Roll Media	65
Setup of Sheet Media	86
Separating the Media	96
Removing Media from the Take-up Unit	98
Checking before Output	101
LAN (Local Area Network) Settings	101
Pausing and Canceling Output	102
Pausing and Resuming Output	102
Canceling Output	103
Replacing Ink Cartridges	104
Out-of-ink Warnings	104
Preventing Sedimentation in Inks	105
Output Method	106
Preparations before Output	107
Step 1: Performing a Printing Test	108
Step 2: Performing Normal Cleaning	110
Starting Output	112
Optimizing Quality and Efficiency	114
Optimizing the Output Quality	115
Using the Correction Functions	116
Automatically Making Required Adjustments	116
Manual Adjustment: Reducing Horizontal Bands (Feed Correction)	117
Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)	120
Configuring Settings to Match the Properties of the Media	122

Changing the Print Head Height.....	122
Using Hard-to-Dry Media	124
Using Media That Wrinkles Easily/Does Not Move Smoothly	125
Using Sticky Media.....	126
Preventing Ink Discharge Issues.....	127
Preventing Soiling of the Media, Dot Drop-out, and Dot Displacement	127
Take-up Unit Settings	128
Setting the Take-up Unit	128
Adjusting the Ink-drying Method	130
What Is the Media Heating System?.....	130
Setting the Print Heater Temperature	132
Setting the Dryer Temperature.....	134
Hints and Tips for Temperature Control	136
Setting the Temperature during Standby	137
Drying the Trailing Edge of the Printing Area on the Dryer	138
Using an Auxiliary Drying Unit (DU3)	139
Accurately Adjusting Media Reading.....	140
Correcting the Reading Sensor	140
Optimizing Work Efficiency	141
Batch Settings for Printing	142
Step 1: Configuring [Batch Media Settings].....	142
Step 2: Setting the Heater Temperature.....	143
Step 3: Changing the Print Head Height	144
Step 4: Setting the Media Suction Force	146
Step 5: Configuring Media Sticking Prevention Settings	147
Step 6: Adjusting the Output-start Location	148
Step 7: Performing a Printing Test	149
Step 8: Performing Feed Correction (Reducing Horizontal Stripes).....	151
Step 9: Adjusting the Misalignment of the Ink Landing Position	153
Step 10: Configuring the Settings to Dry the Trailing Edge of the Printing Area.....	155
Step 11: Setting the Ink Drying Time	156
Step 12: Correcting the Reading Sensor.....	157
Step 13: Setting the Printing Movement Range	158
Managing the Media Settings.....	159
Changing the Media Settings.....	159
Checking the Registered Media Settings	160
Changing the Media Name	161
Duplicating Media Settings.....	162
Deleting Media Settings	163
Adjusting the Output-start Location.....	164
Setting the Base Point	164
Reducing Output Time	166
Speeding Up Output for Narrow Media.....	166
Printing with Crop Marks.....	167
Other Useful Functions.....	168
Using the Print Light (Interior Light)	168
Performing Printing Tests Arranged Horizontally	169
Optimizing Operation Management	170
Managing the Operations Appropriately and Efficiently	171
Setting the Current Date/Time and Using It for Maintenance.....	171
Checking the Remaining Media	172
Printing the Amount of Remaining Media	173
Showing/Hiding Notifications.....	174
Determining What Happens When Ink Runs Out	175
Setting the Activation Interval for Sleep Mode (Power-saving Feature)	176
Setting the Duration of the Warning Beep.....	177

Managing the Basic Settings of the Printer	178
Set the display language	178
Changing the Units of Measurement	179
Viewing Printer Information	180
Viewing Network Information	181
Adjusting the Brightness of the Operation Panel	182
Turning Off Operation Panel Sounds	183
Returning All Settings to Factory Defaults	184

Maintenance 185

Introduction	186
Important Notes on Handling and Use	187
Printer	187
Ink Cartridges	187
Basic Maintenance Knowledge	189
Types and Timing of Maintenance	189
Automatic Maintenance Feature and Notes	191
Measures When the Printer Is Not in Use for a Prolonged Period	192
Regular Maintenance	193
Print Head Check before Printing	194
Performing a Printing Test	194
Cleaning the Machine	195
Cleaning the Media Path	195
Cleaning the Sub Carriage Roller	197
Cleaning around the Print Heads	198
Manual Cleaning Method	199
Consumable Products and Parts Related to Manual Cleaning	209
Disposing of Discharged Fluid	210
Precautions for Disposing of Discharged Fluid	211
If the Discharged Fluid Disposal Message Appears	212
Advanced Maintenance	214
When Dot Drop-out or Dot Displacement Occurs	215
Normal Cleaning Method	215
When Normal Cleaning Is Not Effective	217
Medium Cleaning Method	217
Powerful Cleaning Method	219
If Colors Are Uneven	221
Light Choke Cleaning Method	221
Handling Severe Dot Drop-out, Dot Displacement, and Uneven Colors	223
Ink Renewal Method	223
Partially Restricting the Print Heads Used for Printing	226
Emergency Measure) Cleaning the Print Head Surface	228
Operation Panel Cleaning Method	232
Replacing Consumable Parts	233
Replacing Parts for Maintenance	234
Replacing the Wiper	234
Replacing the Wiper Cleaner	239
Replacing the Print Head Caps	244
Replacing the Flushing Sponges	248
Replacing the Blade/Separating Knife	253
Replacing the Separating Knife	253
Inquiries for Consumable Parts and Products	256
Items That You Can Purchase and Replace by Yourself	256

Items That Require Inquiries before Replacement	256
Troubleshooting Methods.....	257
Output Quality Problems	258
Printed results are coarse or contain horizontal stripes	259
Do the print heads cause dot drop-out?	259
Is the print head height appropriate?	259
Have you carried out [Feed Correction]?	259
Have you carried out [Media Gap Adjustment] (ink landing position correction)?	259
Is the printer installed in a level and stable location?	260
Is the media heating system at a suitable temperature?	260
Is the temperature of the room too low?	260
Is the print mode suitable?	260
Is the media loaded correctly?	260
Are the [Media Settings] appropriate?	260
The media becomes soiled when printed	261
Do the print heads come into contact with the media?	261
Are the print heads dirty?	261
Are the pinch rollers or the media clamps dirty?	261
Colors are unstable or uneven	262
Did you shake the ink cartridges before installing them?	262
Is the media wrinkled?	262
Was printing paused partway through?	262
Is the printer installed in a level and stable location?	262
Is the media loaded correctly?	262
Are the operating parameters set to appropriate values?	263
Are the [Media Settings] appropriate?	263
Media Feed Problems	264
Media Wrinkles or Shrinks	265
Is the media loaded and set up straight and securely?	265
Was loaded media allowed to stand for some time?	265
Are the media clamps installed?	265
Was the media loaded while the print heater and dryer were hot?	265
Is the temperature of the room too low?	265
Is the humidity of the room too high?	265
Is the media sagging?	265
Media Feeding Is Not Straight	266
Is the media loaded and set up straight and securely?	266
Media Feeding Is Not Smooth	267
Is some other object coming into contact with the media?	267
Is the media too thick?	267
Are the grit rollers dirty?	267
A Media Jam Occurs!	268
Is an error message displayed?	268
Is the media warped or wrinkled?	268
Is the height of the print heads too low?	268
Are the grit rollers dirty?	268
Are the media clamps installed?	268
Is the media loaded and set up straight and securely?	268
Is some other object coming into contact with the media?	269
Is the media too thick?	269
Machine Problems	270
Why Has the Print-Head Carriage Stopped Moving?	271
What to Do First	271
If the Print Heads Still Do Not Move	271

The printer unit does not run	273
Is the power switched on?	273
Is [Output possible.] displayed?	273
Are any covers open?	273
Is a message displayed on the screen?	273
Are the cables connected?	273
Is the LAN routing appropriate?	274
Are the LAN settings correct?	274
Did the Software RIP End Abnormally?	274
Is an [Ink Cartridge Error] displayed?	274
Cannot Separate the Media	276
Is the separating knife installed?	276
Messages on the Operation Panel	277
Messages	278
[When output, cleaning, and other operations are completed, discard the discharged fluid.]	278
[The time for manual cleaning has arrived.]	278
[Maintenance must be performed. Perform manual cleaning.]	278
[The time for wiper replacement has arrived.]	278
[The time for wiper cleaner replacement has arrived.]	278
[The time for cap replacement has arrived.]	279
[The time for flushing sponge replacement has arrived.]	279
[Print head protection mode has activated.]	279
[The extended dryer is not connected.]	279
[Operation of the take-up unit stopped.]	279
[Follow the instructions in the figure and correct the error.]	279
[Install the media clamps correctly.]	280
[Media clamps could not be detected.]	280
[The LAN cable is not connected.]	280
[Connection is requiring too much time. Manually setting the IP address will improve the connection speed.]	280
[The media could not be detected automatically. Manually set the printing area.]	281
[Turn on the power. Cleaning will start.]	281
Error Messages	282
[Ink Cartridge Error]	282
[Cover Open Error]	282
[Media End Error]	282
[Pinch Lever Error]	282
[Media Loading Error]	283
[Drain Bottle Error]	283
[Maintenance Cleaning]	283
[Print Head Height Mismatch]	283
[Insufficient Media Width]	284
[Motor Error]	284
[Print Head Dry-out Error]	285
[Low Temperature Error]	285
[High Temperature Error]	285
[Pump Stop Error]	285
[Cleaning Error (Ink Cartridge)]	285
[Take-up Unit Communication Error]	286
[Service Call]	286
[Software error]	286
Appendix	287
Operations When Moving the Unit	288
Preparing to Move the Machine	289
Step 1: Removing the Media	289
Step 2: Discarding the Discharged Fluid	290

Step 3: Securing the Print-head Carriage in Place Using the Retainer	291
Step 4: Reinstalling the Machine	293
Main Specifications	295
Printing area	296
Maximum Printing Area and Margins.....	296
Maximum Printing Area When Using Crop Marks.....	297
Media Separation Location during Continuous Printing.....	298
Specifications	299
Memo.....	299
Software.....	301

Basic Handling Methods

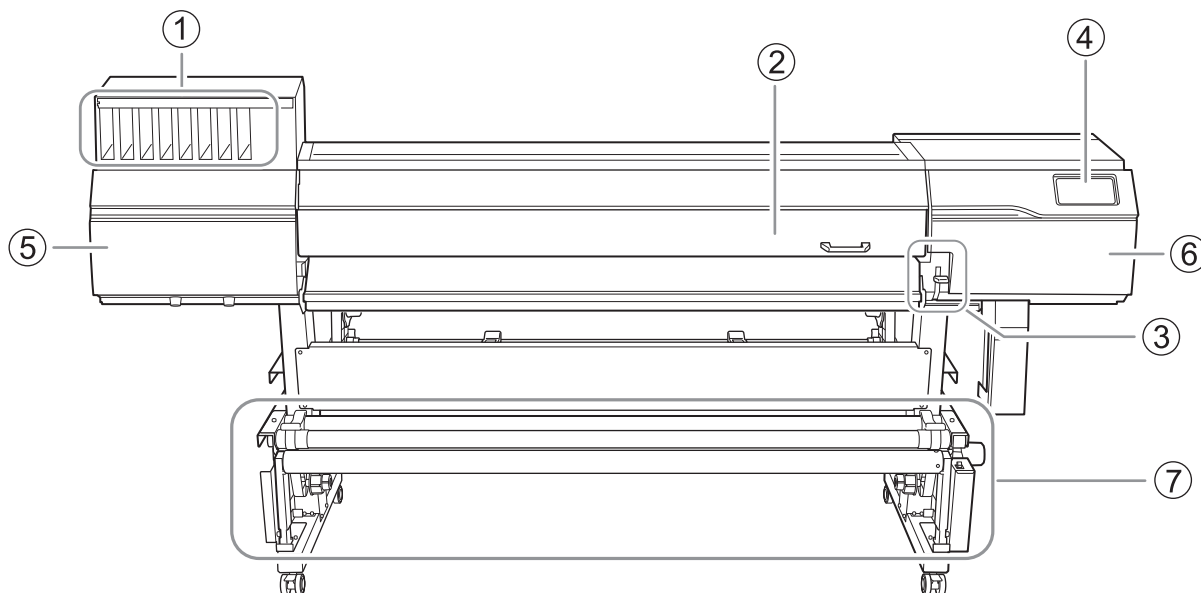
Basic Information

Part Names and Functions.....	9
Printer Unit.....	9
Operation Panel	15
Take-up Unit	20
About the Media Used	21
Types of Media	21
Conditions for Usable Media	22
Take-up Unit.....	23
Take-up Unit Use Conditions.....	23
About the Paper Tube.....	23
Drain Bottle	24
Precautions for Disposing of Discharged Fluid	24

Part Names and Functions

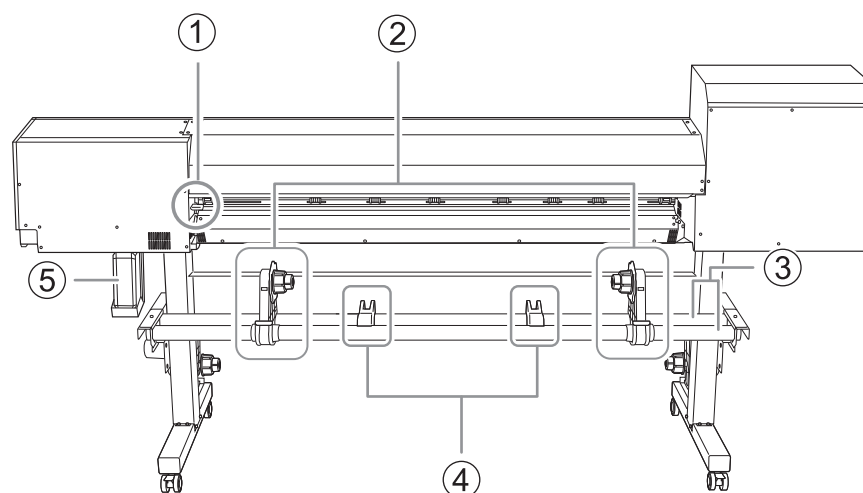
Printer Unit

Front



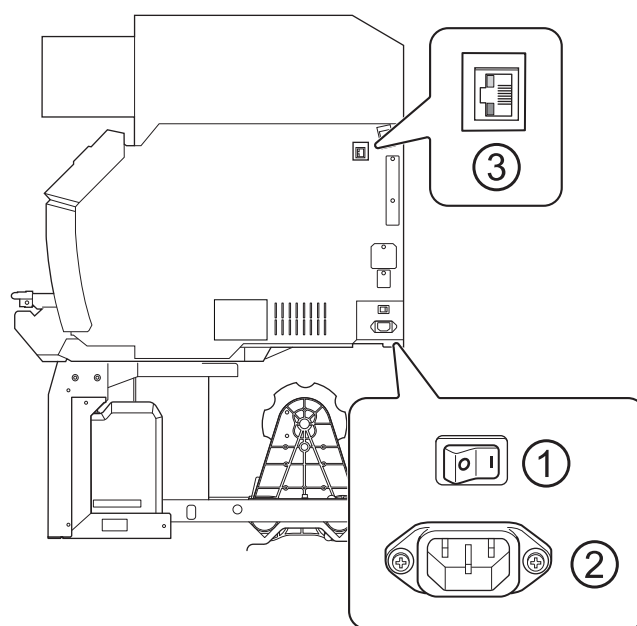
No.	Name	Function overview
①	Cartridge slots	The location where ink cartridges are installed.
②	Front cover	Open this when necessary, such as when loading media. Keep this cover closed when not loading media or performing maintenance.
③	Loading lever (front)	Secures the media in place and releases it. Use this lever when working at the front of the machine. Lowering the lever secures the media in place.
④	Operation panel	The panel containing the buttons used to operate the machine. P. 15 Operation Panel
⑤	Left cover	Open this when you perform maintenance.
⑥	Right cover	Open this when you perform maintenance.
⑦	Take-up Unit	Takes up the media after printing. This prevents the printed media from touching the floor.

Rear



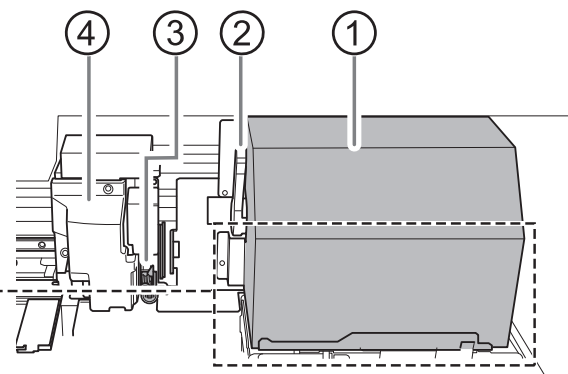
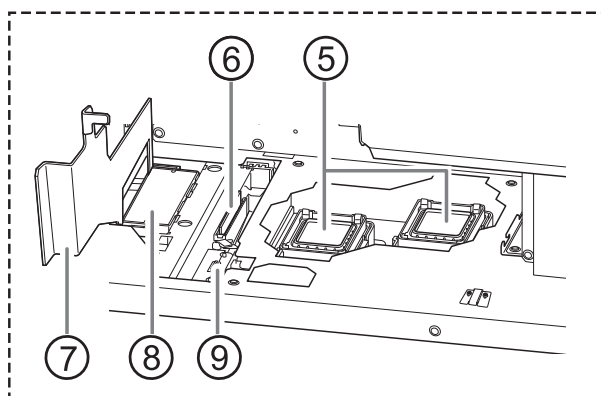
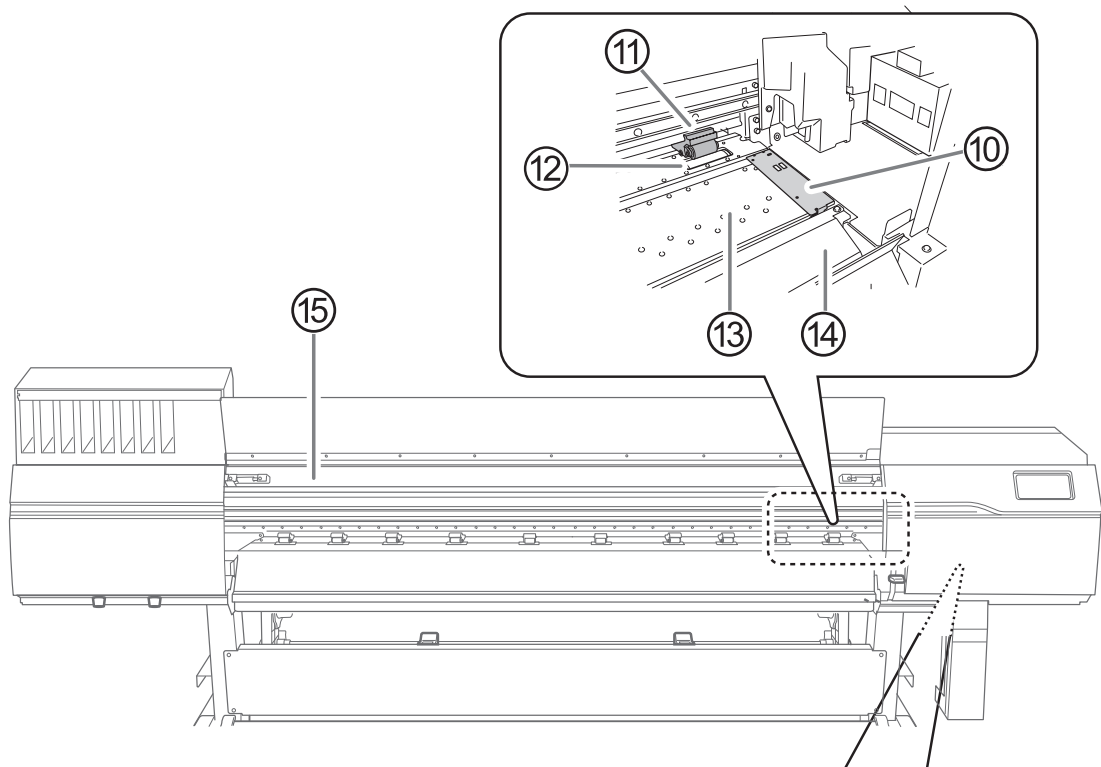
No.	Name	Function overview
①	Loading lever (rear)	Operate this when you load media.
②	Media holders	Use these when you load media.
③	Shafts	
④	Media stays	
⑤	Drain bottle	Discharged fluid is stored in this bottle. When discharged fluid is nearly overflowing from the bottle, an error is displayed and printing is not possible.

Side



No.	Name	Function overview
①	Main power switch	Switches the main power of the machine on/off.
②	Power-cord connector	Used to connect the power cable from which power is supplied to the machine.
③	Ethernet connector	Use this to connect an Ethernet cable.

Front Cover Interior/Print Head Carriage Area



No.	Name	Function overview
①	Print-head carriage	Transports the built-in print heads.
②	Height-adjustment lever	You can adjust the head height.
③	Separating knife	The knife used to separate the media.
④	Sub carriage	The separating knife is inside here.
⑤	Print head caps	Prevent the print heads from drying out by sealing 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.
⑥	Wiper	Cleans the print heads, removing dirt and excess ink that have adhered to these heads.

No.	Name	Function overview
⑦	Flushing cover	Open this cover when cleaning around the print heads and when replacing the flushing sponge. Leave this cover closed when not cleaning around the print heads or replacing the flushing sponge.
⑧	Flushing sponge	Absorbs ink flushed from the print heads.
⑨	Wiper cleaner	Removes ink and dirt that have adhered to the wiper.
⑩	Media clamp	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.
⑪	Pinch roller	Lowering a loading lever lowers the pinch rollers, clamping the media.
⑫	Grit roller	Transports the media.
⑬	Platen	This is the path over which the media passes. The platen has a built-in suction fan and heater (print heater) that keep the media from coming loose.
⑭	Apron	This is the path over which the media passes. The apron has a built-in heater (dryer) that heats the media and prevents it from coming loose.
⑮	Print light	This light illuminates the front cover interior. This makes it easier to see the printing status. It flashes if a serious error occurs.

Serious Errors Indicated by the Print Light

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

This indicates one of the situations shown below.

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

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

RELATED LINKS

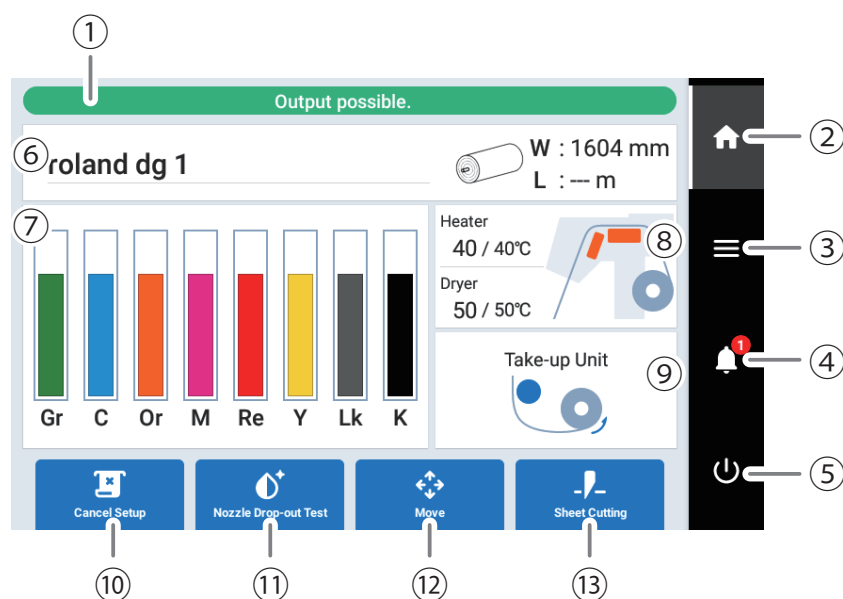
- [P. 282 Error Messages](#)

If a Cover Opens during Operation

IMPORTANT

Even if the front cover, left cover, or right cover (hereinafter these items are all referred to as the "cover") opens during an output operation, the print-head carriage may still move slowly. Exercise caution.

Operation Panel



No.	Name	Details
①	Status bar	Displays the printer status and indicates the next operation.
②	Home	Displays the home screen.
③	Menu	Displays various setting menus.
④	Notifications	Displays important information. When there are notifications, their number is displayed next to the icon.
⑤	Sub power	Controls the power to the operation panel.
⑥	Media information	Displays the media name 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. 172 Checking the Remaining Media
⑦	Amount of ink remaining	Displays the amount of ink remaining in each ink cartridge. If it is time to replace an ink cartridge, is displayed next to the corresponding cartridge. Tap this icon to display the detailed information for the ink.
⑧	Heater Temperature	The print heater and dryer temperatures are displayed as current temperature/set temperature. Tap one of these items to display a screen for: - When media is set up - Turning [Heater Power] on/off. - Turning [Print Heater] on/off and setting its temperature. [Dryer] - When no media is set up - Turning [Standby Heater Temperature] on/off and setting its temperature.
⑨	Take-up Unit	Displays the status of the take-up unit. Tap this icon to display the [Take-up] screen on which you can set the [Take-up Method] and [Take-up Direction] .
⑩	[Setup]/[Cancel Setup]	Starts/cancels the setting up of the media. P. 30 Setup of New Media P. 65 Setup of Registered Media
⑪	[Cleaning]/[Nozzle Drop-out Test]	Displays the menu related to the printing test and cleaning for the nozzle drop-out check.

Part Names and Functions

No.	Name	Details
⑫	[Move]	Feeds the media and moves the sub carriage. You can also set the position moved to as the right edge of the output area (the base point). P. 164 Adjusting the Output-start Location
⑬	[Sheet Cutting]	Activates the separating knife to separate the media. You can also perforate the media to take it up and separate it at a later time.

Menu List

Tap  to display the 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.

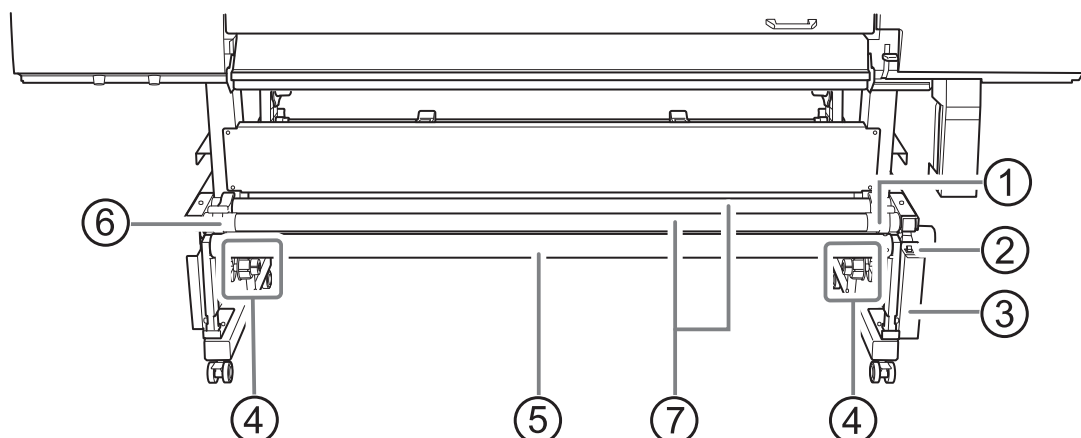
Level 1	Level 2	Level 3	Level 4	Details
[Media Set-tings]**1	[List of Media Settings]			Lists the settings of the media that has been set up. Tap a setting to move to a screen for changing this setting.
	[Printing Set-tings]	[Print Head Height]		Checks/changes the head height.
		[Batch Automatic Correction]		Adjustments are performed in the following order: [Multi Sensor Adjustment], [Media Gap Adjustment], then [Feed Correction].
		[Feed Correc-tion]	[Simple Correc-tion (Auto)]	Adjusts the media feed amount during printing. With [Simple Correction (Auto)], a test pattern is printed and then read with a sensor to automatically set the correc-tion value.
			[Detailed Correc-tion (Manual)]	Adjusts the media feed amount during printing. With [Detailed Correction (Manual)], a test pattern is print-ed, and then the correction value is entered manually after the printed correction value is checked visually.
		[Media Gap Ad-justment]	[Simple Correc-tion (Auto)]	Corrects the ink landing position. With [Simple Correc-tion (Auto)], a test pattern is printed and then read with a sensor to automatically set the correction value.
			[Detailed Correc-tion (Manual)]	Corrects the ink landing position. With [Detailed Correc-tion (Manual)], a test pattern is printed, and then the correction value is entered manually after the printed correction value is checked visually.
	[Heater Set-tings]	[Heater Temper-ature]	[Print Heater]	Switches the print heater on/off and changes the set temperature.
			[Dryer]	Switches the dryer on/off and changes the set tempera-ture.
		[Dry After Printing]		Switches on/off the function that moves the media to and dries the media with the dryer after printing and sets the drying time.
	[Other Media Settings]	[Multi Sensor Adjustment]		Optimizes the status of the multi sensor used when read-ing the media width and with the automatic correction function.
		[Drying Time Per Scan]		Sets the drying time per scan operation of the print-head carriage.
		[Media Suction Force]		Adjusts the media suction force of the platen.
		[Printing Movement Range]		During printing, select the movement range of the print-head carriage from [Output Data Width], [Media Width], or [Full Width].
		[Media Sticking Prevention]		When set to [Enable], the media is peeled off before printing.
	[Batch Media Settings]			The minimum settings required for media setup can be configured by following the on-screen instructions on the operation panel.

Level 1	Level 2	Level 3	Level 4	Details
[Media Management]				Displays a list of registered media. Up to 20 media names can be saved, and the following operations on media settings are possible. • Checking setting details in a list • Changing media names • Copying media settings • Deleting media settings
[Cleaning]	[Printing Test]			Before printing, use [Nozzle Drop-out Test] to check whether ink is discharged from the print heads correctly. If nozzle drop-out is present, perform cleaning appropriate for the severity of the drop-out. If faulty ink discharge cannot be improved, the problematic nozzle can be identified with [Nozzle Mask Test], making it possible to stop using this nozzle.
	[Normal Cleaning]			If dot drop-out or dot displacement occurs, select the nozzle from [Group A], [Group B], and [Both], and then perform cleaning of 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.
[Maintenance]	[Wiper Replacement]			Replaces the wiper and tray pad.
	[Separating Knife Replacement]			Replaces the separating knife used in media separation.
	[Cap Replacement]			Replaces the print head caps, which are used to protect the print heads from drying out and from dust.
	[Wiper Cleaner Replacement]			Replaces the wiper cleaner used to wipe away dirt from the wiper.
	[Flushing Sponge Replacement]			Replaces the flushing sponge used to absorb the flushed ink.
	[Ink Renewal]			Perform this operation when ink discharge issues or uneven colors are not resolved even after [Normal Cleaning], [Medium Cleaning], [Powerful Cleaning], and [Manual Cleaning]. However, this operation consumes a large amount of ink and may damage the print heads, so do not perform it more than necessary.
	[Light Choke Cleaning]			Perform this cleaning when printed colors are unstable or uneven, e.g., when color density is inconsistent, even if the same data is printed with the same settings. 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]			A message appears when discharged fluid has collected in the drain bottle. Use this menu item to discard this fluid.

Level 1	Level 2	Level 3	Level 4	Details
[Preferences]	[Print Light]			Select [On], [Off], or [Auto] for the print light. Select [Auto] to automatically turn the light on/off according to the status of the printer.
	[Take-up]			Sets the [Take-up Method] and [Take-up Direction] for the take-up unit.
	[Remaining Media Management]			Sets the amount of remaining media that has been set up and displays this amount. This amount can also be printed on the media.
	[Extended Dryer]			These settings are required when using an auxiliary drying unit. Set them individually to [Enable] and [Disable].
	[Blower Fan]			
	[Skewing Correction Support at Setup]			Provides support, preventing skewed installation of the media by making a sound and operating an automatic suction fan during setup.
	[Printing Test Position]			Sets the direction for test pattern printing: [Feed] or [Scan].
	[Perforated Sheet Cutting]			Sets the perforated sheet cutting conditions.
	[Cleaning during Printing]			Selects the frequency of cleaning during printing from [No Cleaning], [Every Page], [Periodically (Job Priority)], and [Periodically (Time Priority)]. After selecting [Periodically (Job Priority)] or [Periodically (Time Priority)], set the time from the previous cleaning to the next cleaning.
	[Standby Heater Temperature]			Sets the heater temperature when media has not been set up.
	[Ink Empty Mode]			This sets whether printing should continue or stop if the ink runs out during printing.
	[Notifications On/Off]			When [Enable] is selected, notifications are displayed at the appropriate times. • [Media Clamp Placement Notification]
	[Sleep Time]			Sets the time until sleep mode (the state in which the power-saving features operate) activates.
	[Stopping the Warning Beep]			Sets the duration of the warning beep that sounds when, for example, an error occurs.
	[Reset to Factory Defaults]			Returns all settings other than [Language] and [Units] to their factory default values.
[System Information]	[Machine Information]			Displays the [Model], [Serial Number], [Ink Type], [Firmware Version], and [MAC Address].
	[Network]			Sets the [Obtain IP Address Automatically], [IP Address], [Subnet Mask], and [Default Gateway] to connect the machine to a computer.
	[Units]			Sets the [Length] and [Temperature].
	[Language]			Sets the language. Languages that can be set are Japanese, English, French, Italian, German, European Spanish, and South American Spanish.
	[Date/Time]			Sets the current year, month, day, hour, minute, and second.
	[Screen Brightness]			Sets the brightness of the operation panel's screen.
	[Screen Operation Sound]			Turns the operation sound of the operation panel on/off.
	[License]			Displays the license information of the operation panel.

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

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 taking up the media. Use it when you cannot reach the operation panel.
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

	XP-640
Width *1	259 to 1,625 mm (10.2 to 64 in.)
Maximum media thickness (including backing paper) *1	1.0 mm (39.5 mil)
Maximum roll outer diameter	250 mm (9.8 in.)
Paper tube (core) inner diameter	76.2 mm (3 in.) or 50.8 mm (2 in.)

*1 Applies to both roll and sheet media

Maximum Roll Weight

45 kg (99 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 media heating system

Take-up Unit

Take-up Unit Use Conditions

Never pull the media with excessive force.

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

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

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

Never use the automatic separation function for media.

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

MEMO

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

About the Paper Tube

Paper tubes are consumable items.

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

Use the paper tube of the media you are using. To purchase the included paper tube, contact your authorized 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.

Basic Operations

Power Supply Operations	26
Turning the Power On	26
Turning the Power Off	27
Precautions When Operating the Power Supply	28
Sleep Mode (Power-saving Feature)	29
Setup of New Media	30
Setup of Roll Media	30
Setup of Sheet Media	53
Setup of Registered Media	65
Setup of Roll Media	65
Setup of Sheet Media	86
Separating the Media	96
Removing Media from the Take-up Unit	98
Checking before Output	101
LAN (Local Area Network) Settings	101
Pausing and Canceling Output	102
Pausing and Resuming Output	102
Canceling Output	103
Replacing Ink Cartridges	104
Out-of-ink Warnings	104
Preventing Sedimentation in Inks	105

Power Supply Operations

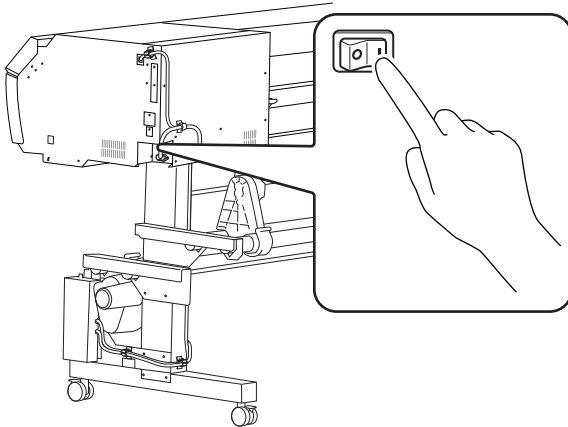
Turning the Power On

WARNING

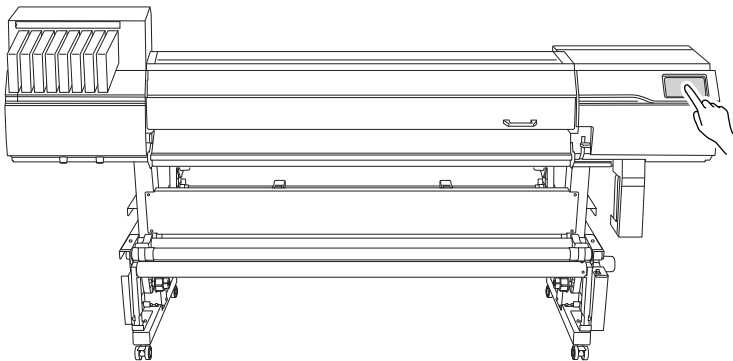
Remove any loaded media or switch off the sub power when printing is not being performed.
The continued application of heat at a single location may cause the release of toxic gases from the media or pose a fire hazard.

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  on the operation panel.

The power to the operation panel 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.

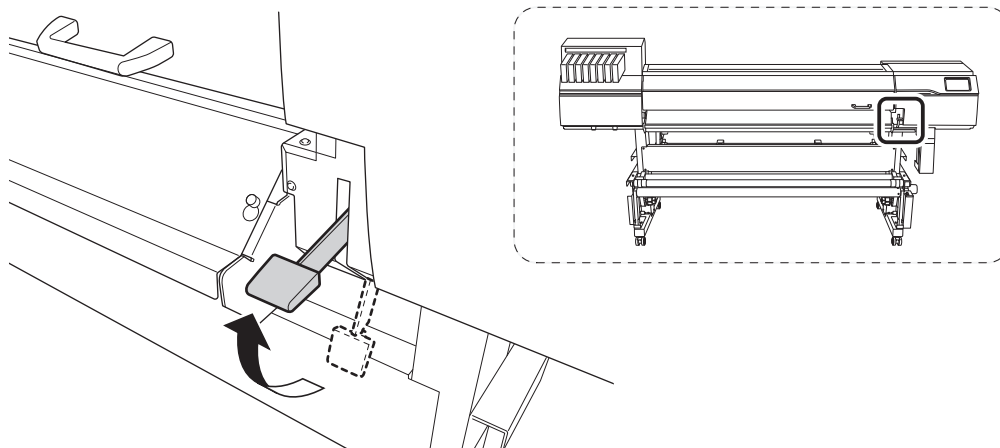
The confirmation screen appears.

2. Tap [Yes].

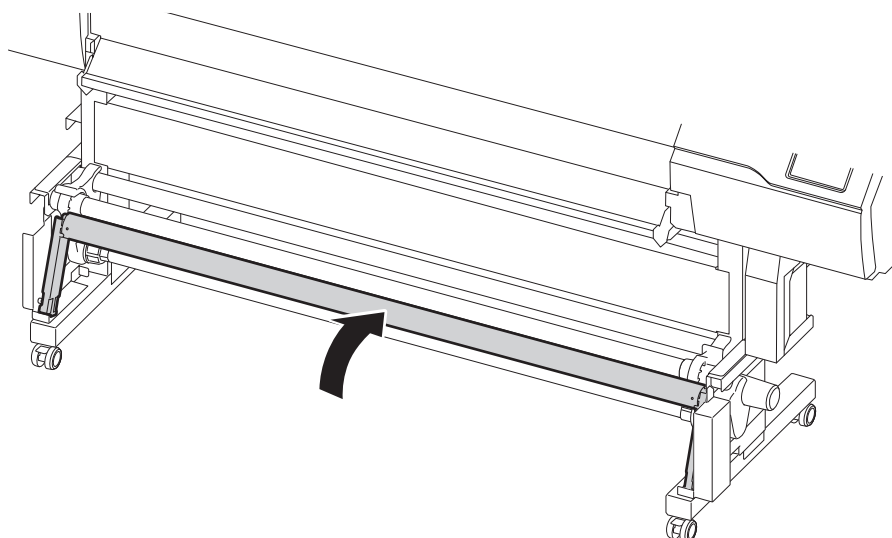
The sub power switches off automatically.

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. When the machine is in the sleep mode, the sub power icon flashes slowly. Using the operation panel or performing operations such as sending print data from the computer restores the machine to its normal mode.

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

RELATED LINKS

- [P. 176 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.).

To avoid injury, handle the roll media with care.

CAUTION

Never load media that weighs over 45 kg (99.21 lb.).

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

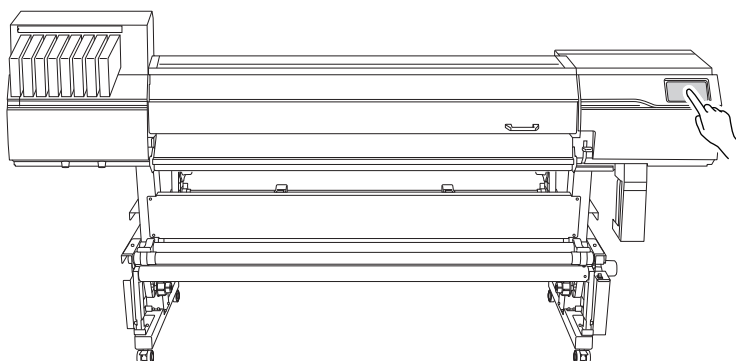
1. Set the take-up unit.

If you will not use the take-up unit, proceed to [2. Install the media on the media holders.](#)(P. 33).
Make sure the following settings match the loading method and output method of the actual media.
The settings will have to be changed from the defaults when:

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

Procedure

1. Tap the operation panel.



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

The power to the operation panel is switched on.

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

(1) Tap .

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

(3) Select [Loose Winding] or [Tension Winding].

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

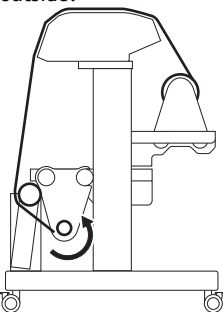
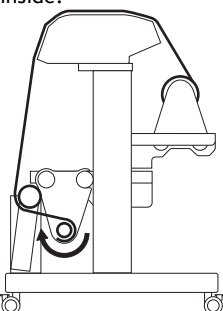
MEMO

- Default setting: [Loose Winding]

(4) Tap [Save].

(5) Tap [Take-up Direction].

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

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

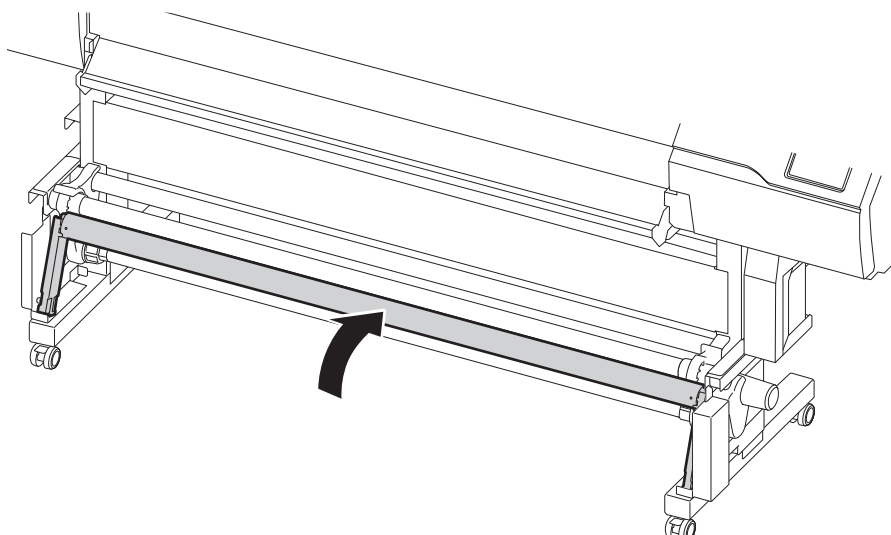
MEMO

- Default setting: [Forward]

(7) Tap [Save].

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

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



2. Install 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.

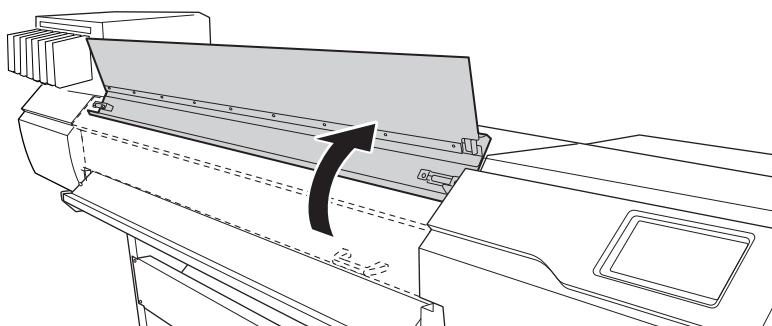
Attempting to lift heavy media in a manner that taxes your strength may cause physical injury. Also, if dropped, such items may cause injury.

MEMO

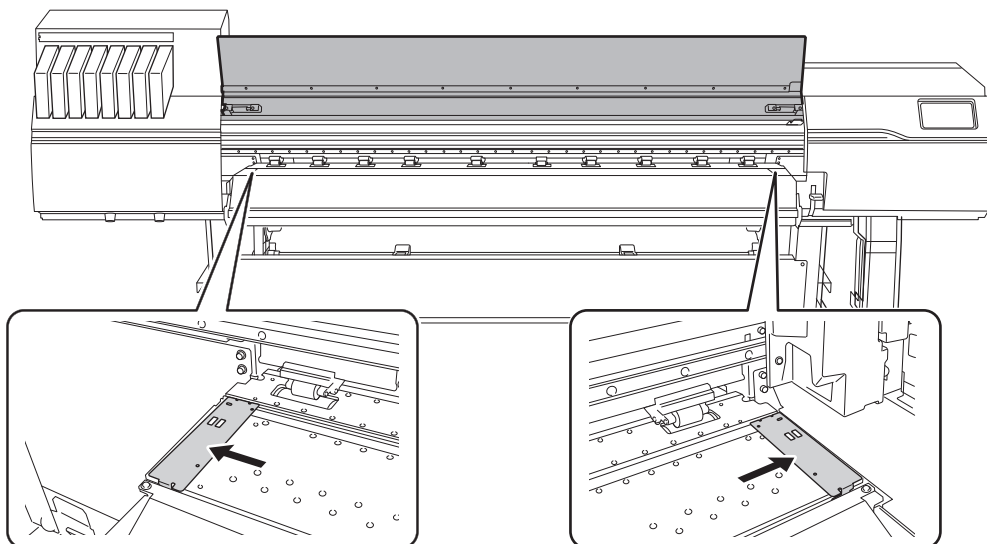
The media holders of this machine are designed to be used with a paper tube (core) with an inner diameter of 2 inches or 3 inches.

Procedure

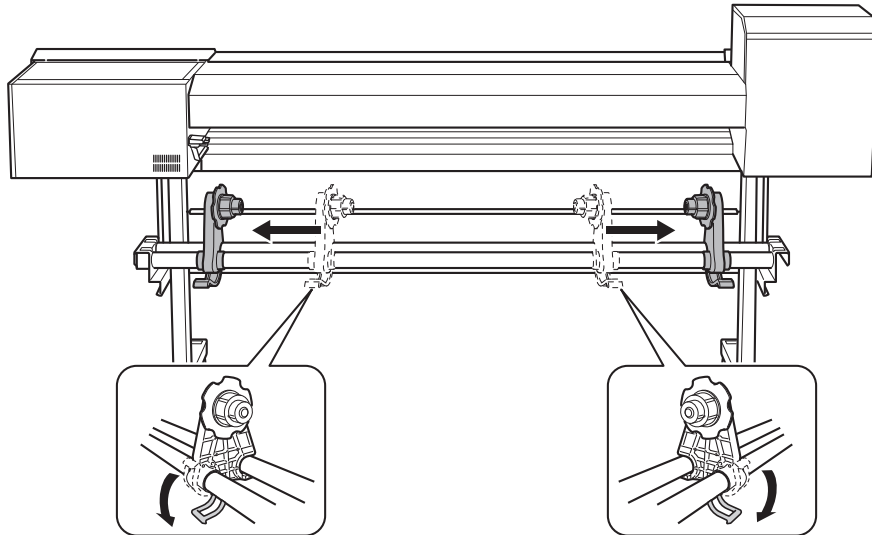
1. Open the front cover.



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



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

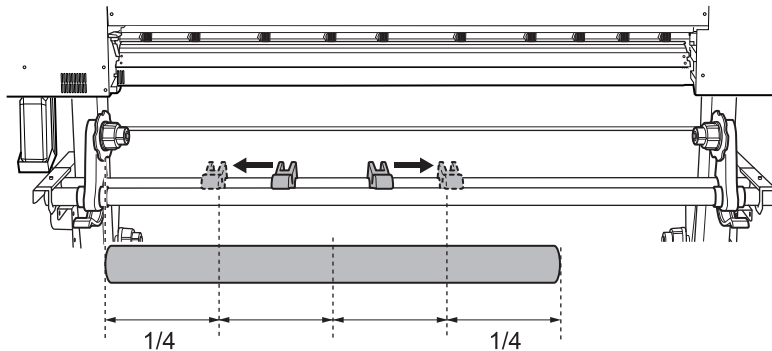


4. Place the media on the machine.

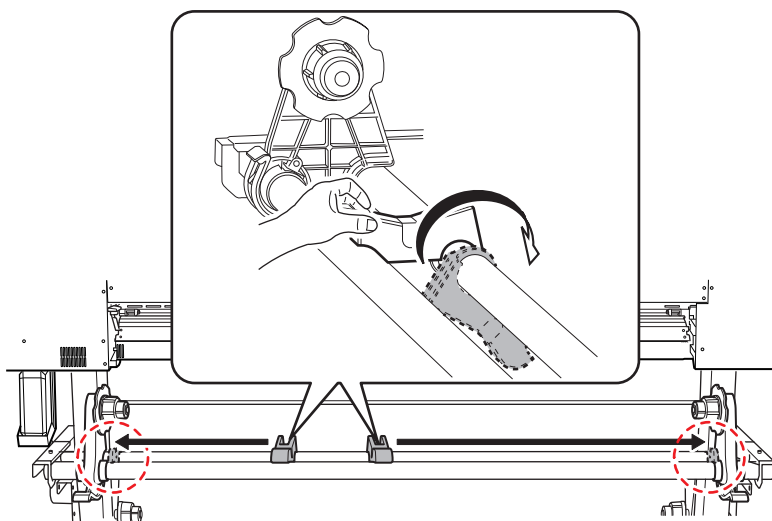
IMPORTANT

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

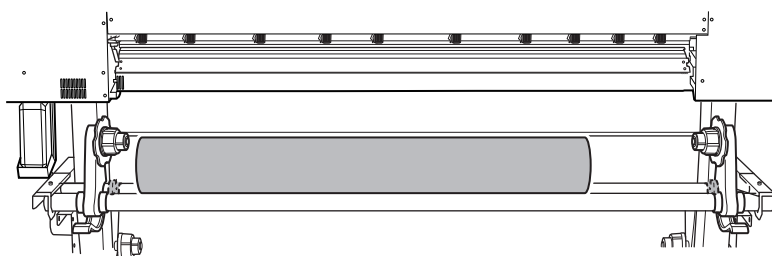
- Roll media with an outer diameter of 220 mm (8.66 in.) or less
Place the media stays at positions that are $\frac{1}{4}$ the length of the media from each end of the media, and then load the media.



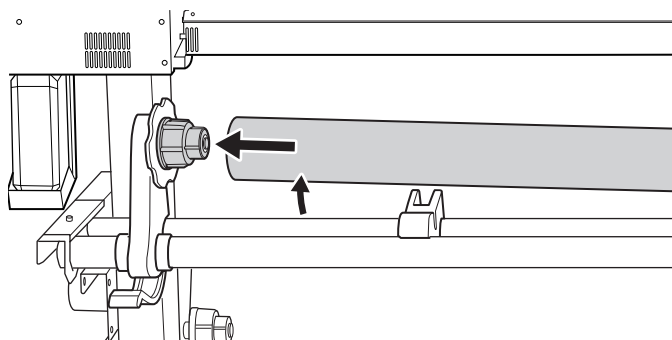
- Roll media with an outer diameter exceeding 220 mm (8.67 in.)
a. Rotate the media stays to draw them to the media holders.



- b. Place the media directly between the two pipes.



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

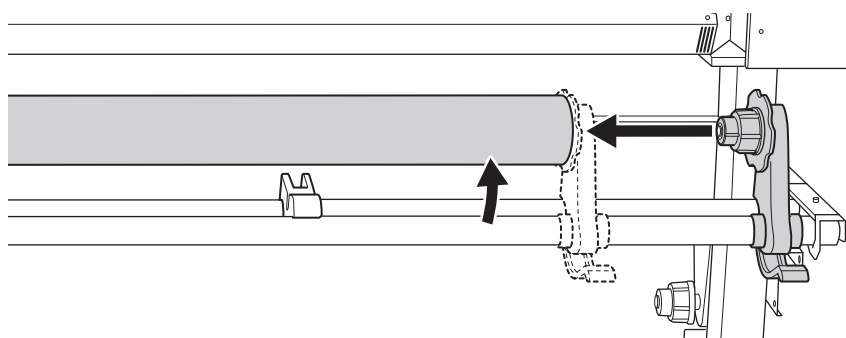


6. Move the right media holder to fit its end cap onto the paper tube (core) of the media.
Fit the paper tube onto the media holders securely to prevent the media from moving easily.

IMPORTANT

Do not secure the media holders in place just yet.

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



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

- Opaque media: [3. A: Determine the positions of the media \(opaque media\).\(P. 37\)](#)
- Transparent media, etc.: [3. B: Determine the positions of the media \(transparent media, etc.\).\(P. 41\)](#)

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

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

Procedure

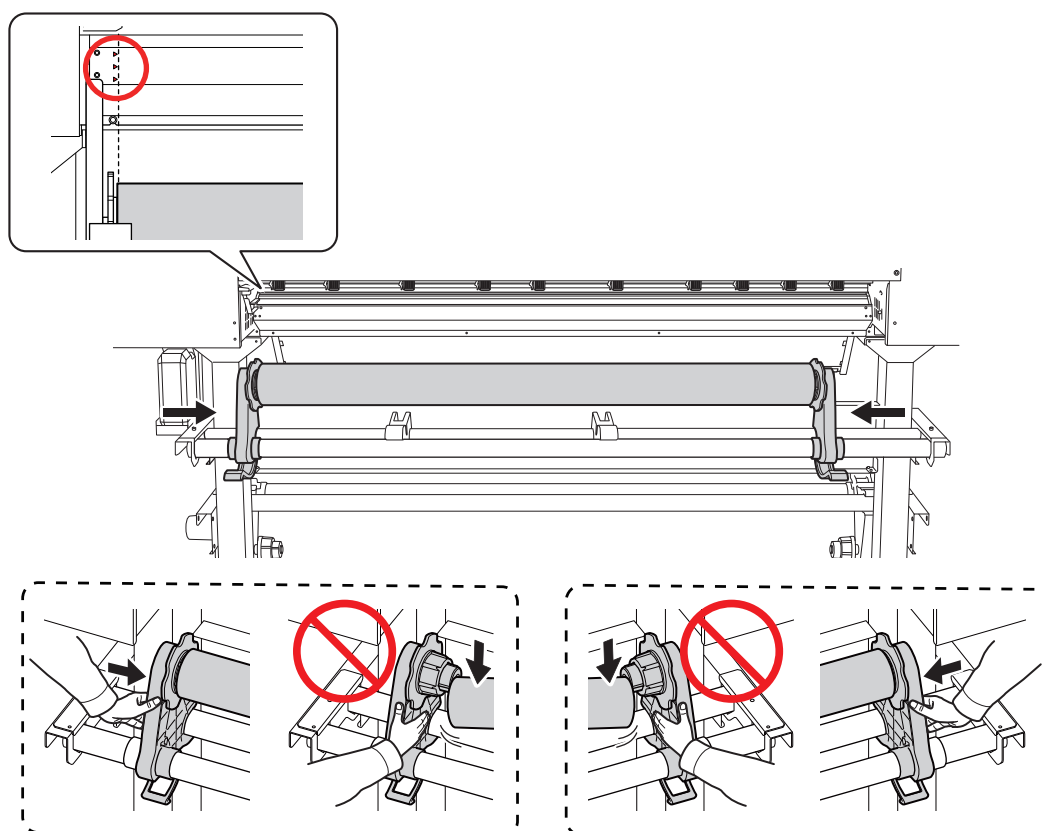
1. Set the [Skewing Correction Support at Setup].

- (1) Tap .
- (2) Tap [Preferences]>[Skewing Correction Support at Setup].
- (3) Select [Enable] and tap [Save].
- (4) Press  to return to the original screen.

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

Note the following points when determining the positions.

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



⚠ CAUTION

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

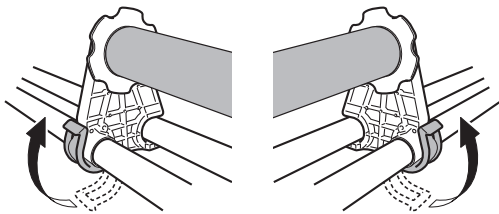
Otherwise the media may fall off the media holder and cause injury.

IMPORTANT

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

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

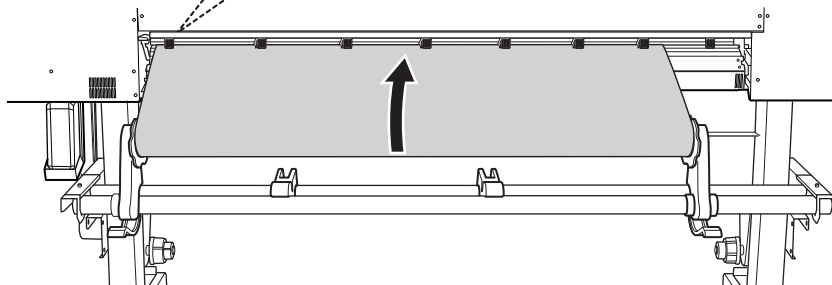
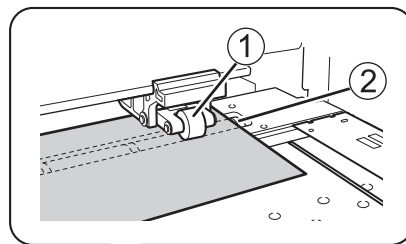
3. Secure the media holders.



4. Use the following procedure to load the media.

Doing so will prevent media skewing.

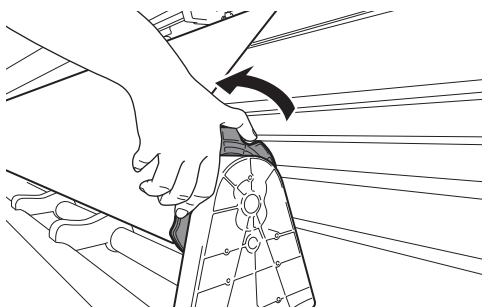
- (1) Pass the leading edge of the media between the pinch rollers (①) and the grit rollers (②).



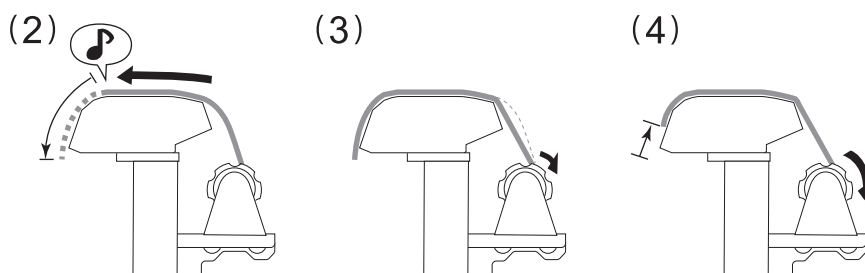
- (2) Feed the media until you hear a beep, and then additionally feed approximately 20 cm (7.87 in.) of the media.

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.



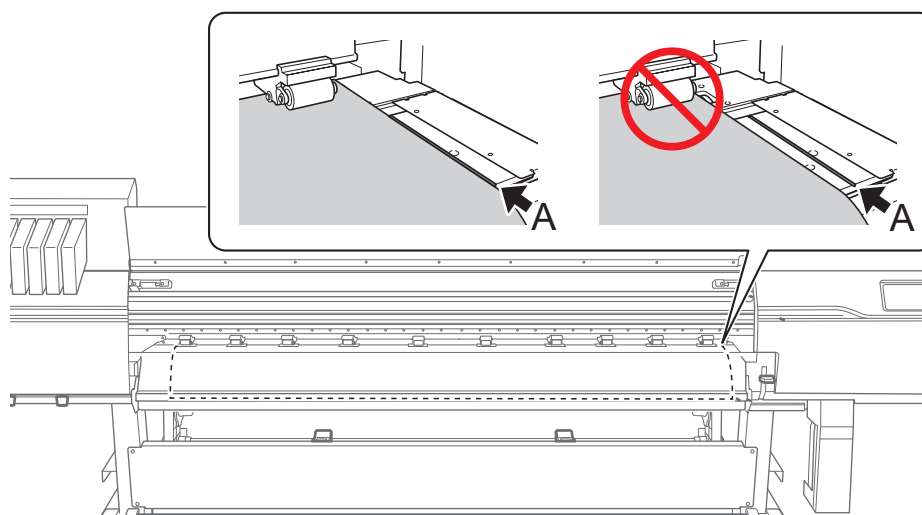
- (4) Once the media is taut, additionally take up approximately 10 cm (3.94 in.) of media.



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

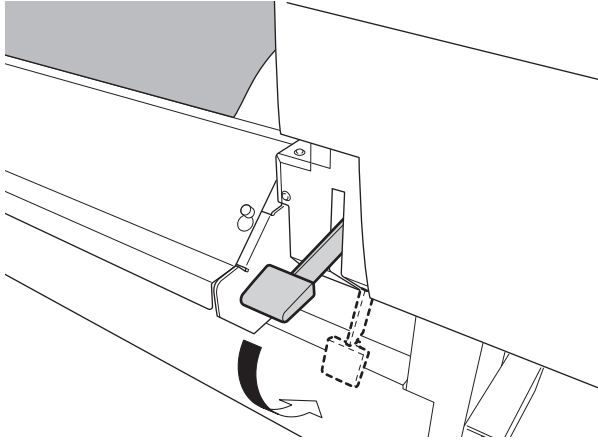


IMPORTANT

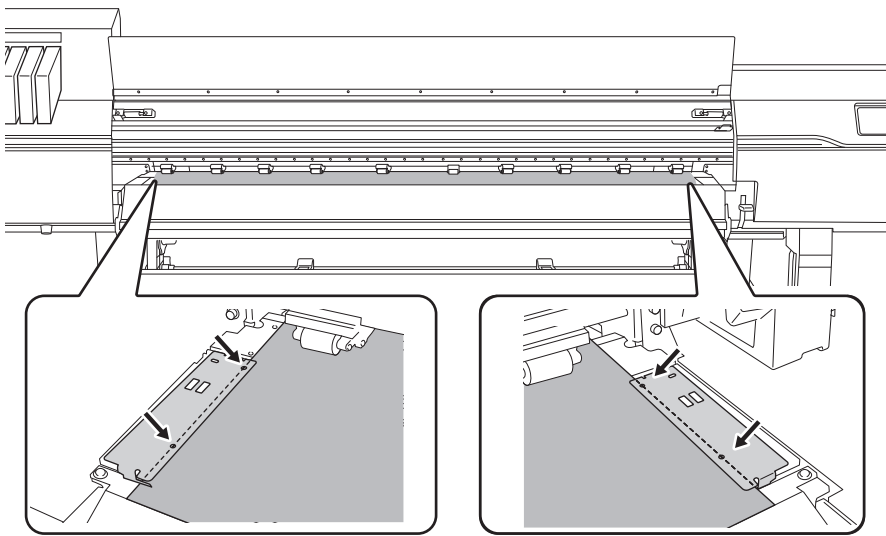
If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from Step 2. If you just stand at the front of the printer and hold the media to readjust its position forcibly, the media will be skewed during printing or will come loose, which will affect the printing quality.

6. Lower the loading lever (front).

The media is held in place.



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



IMPORTANT

Be sure to use the media clamps when you 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.

8. Close the front cover.

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

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

Procedure

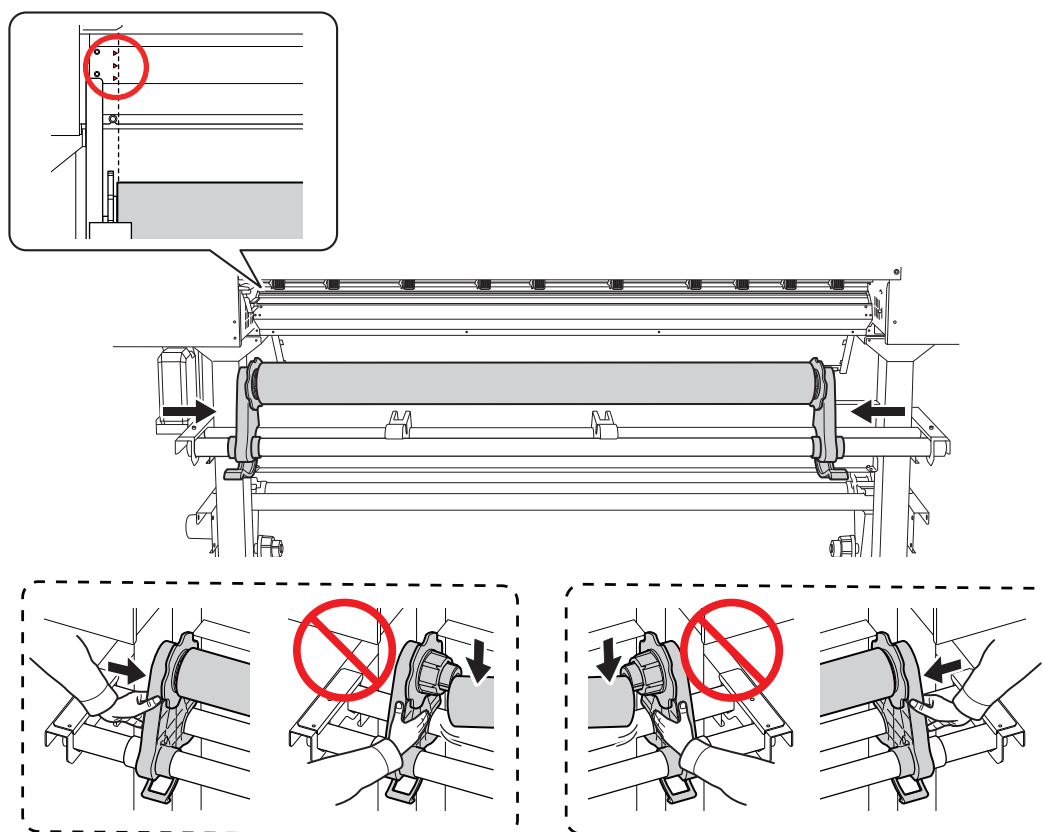
1. Set the [Skewing Correction Support at Setup].

- (1) Tap .
- (2) Tap [Preferences]>[Skewing Correction Support at Setup].
- (3) Select [Disable] and tap [Save].
- (4) Press  to return to the original screen.

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

Note the following points when determining the positions.

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



⚠ CAUTION

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

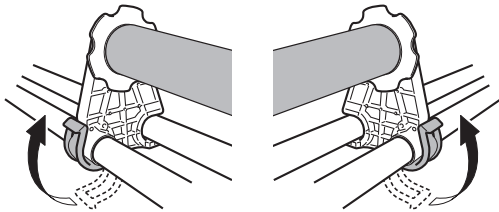
Otherwise the media may fall off the media holder and cause injury.

IMPORTANT

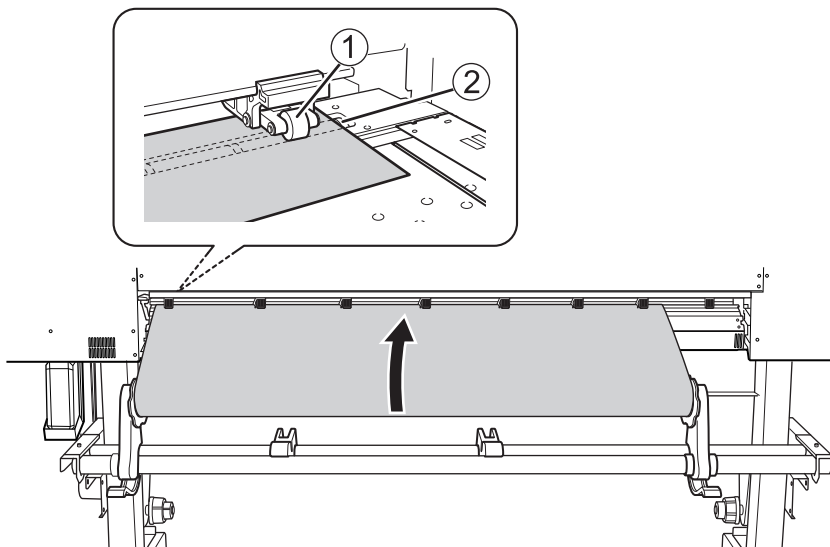
Firmly decide the left and right side positions of the media at this point.

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

3. Secure the media holders.

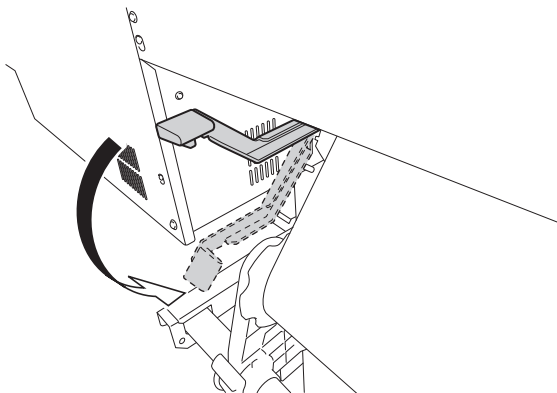


4. Pass the leading edge of the media between the pinch rollers (①) and the grit rollers (②).

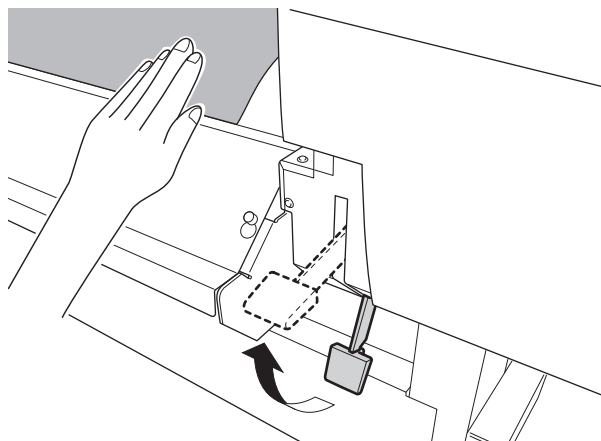


5. Lower the loading lever (rear).

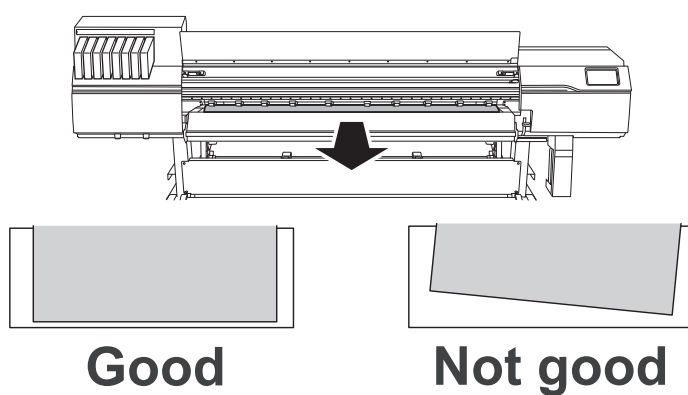
The media is held in place.



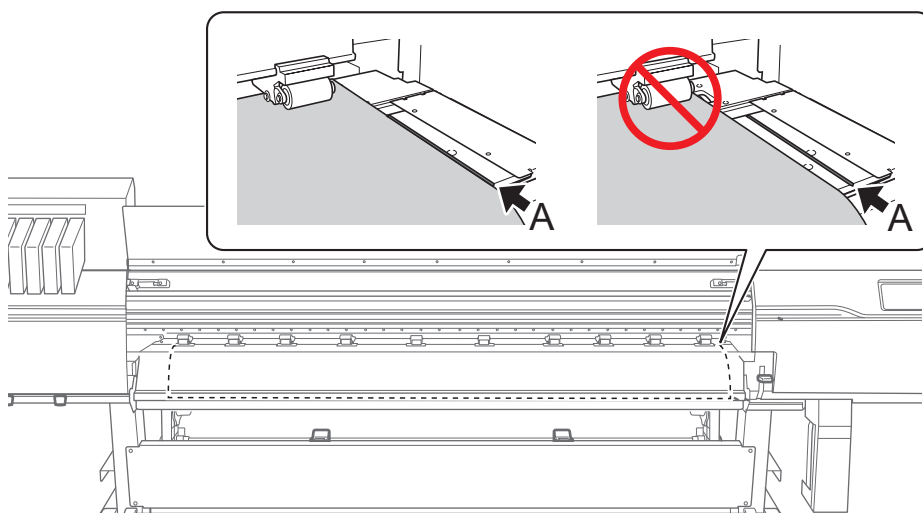
6. (Move to the front of the printer.) Gently hold down the media and raise the loading lever (front).



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



8. If an auxiliary drying unit (DU3) is installed, insert the leading edge of the media into the dryer.
9. Make sure the right edge of the media is in line with the guide line (A).



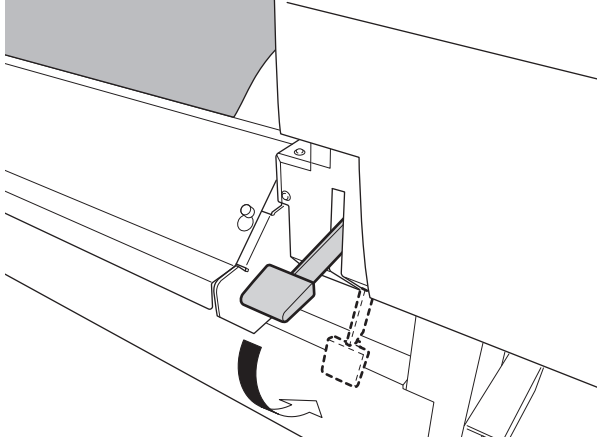
IMPORTANT

If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from Step 2. If you just stand at the front of the printer and hold the media to

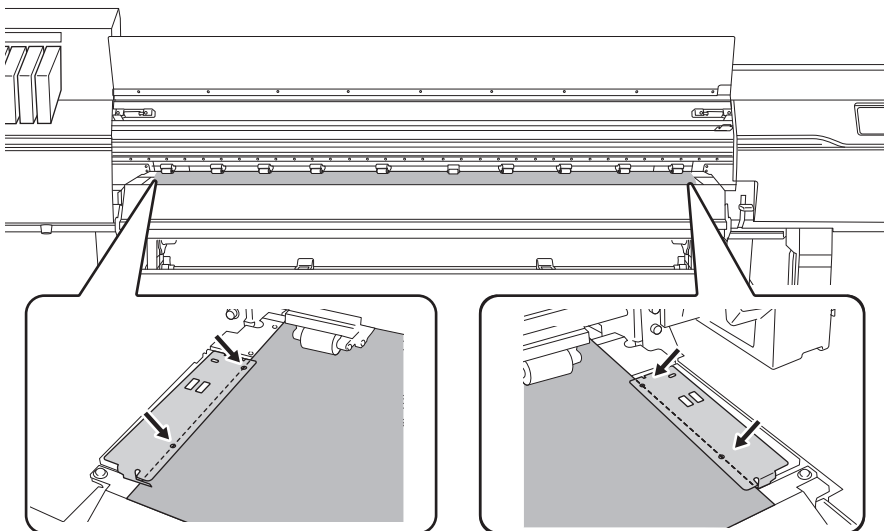
readjust its position forcibly, the media will be skewed during printing or will come loose, which will affect the printing quality.

10. Lower the loading lever (front).

The media is held in place.



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



IMPORTANT

Be sure to use the media clamps when you 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.

12. Close the front cover.

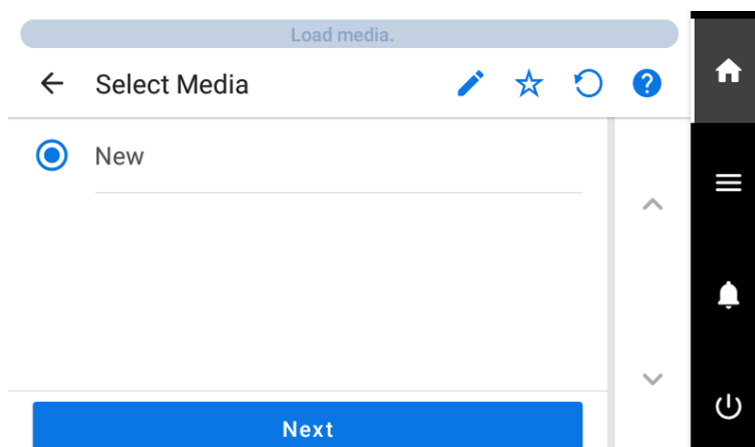
4. Register the media.

Procedure

1. Tap  [Setup].

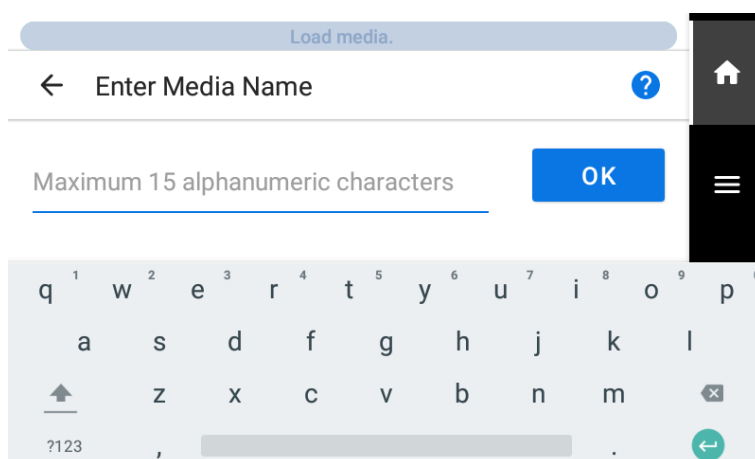
2. Select [New].

3. Tap [Next].



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

Tap the keyboard displayed on the screen to enter the name.
You can use up to 15 alphanumeric characters.



5. Check the name you have entered and tap [Next] if it is correct.

To make corrections, tap the name you entered.

6. On the [Select Sheet Type] screen, select [Opaque]/[Transparent] and tap [Next].

7. The [Sheet Settings] screen appears. Configure the settings as shown below depending on the sheet type.

- For opaque media

- a. Tap [Side Margin] to set the margin.

You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).

- b. Tap [OK].
 - For transparent media, etc.
 - [Sheet Width] setting
 - a. Tap  to the right of [Sheet Width].
 - b. Enter the sheet width and tap [OK].
 - [Sheet Right Edge] setting
 - a. Tap [Change] to the right of [Sheet Right Edge].
 - b. Tap  or  to move the sub carriage's base point mark to the right edge of the media, and then tap [OK].
 - [Side Margin] setting
 - a. Tap [Side Margin] to set the margin.

You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
 - b. Tap [OK].
8. Tap [Next].
9. On the [Setup Method] screen, select [Do Not Use Take-up Unit]/[Use Take-up Unit] and tap [Start Setup].
 - When not using the take-up unit: Proceed to [6. Configure settings to match the media.](#)(P. 51).
 - When using the take-up unit: Proceed to [5. Load the media in the take-up unit.](#)(P. 47).

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

Procedure

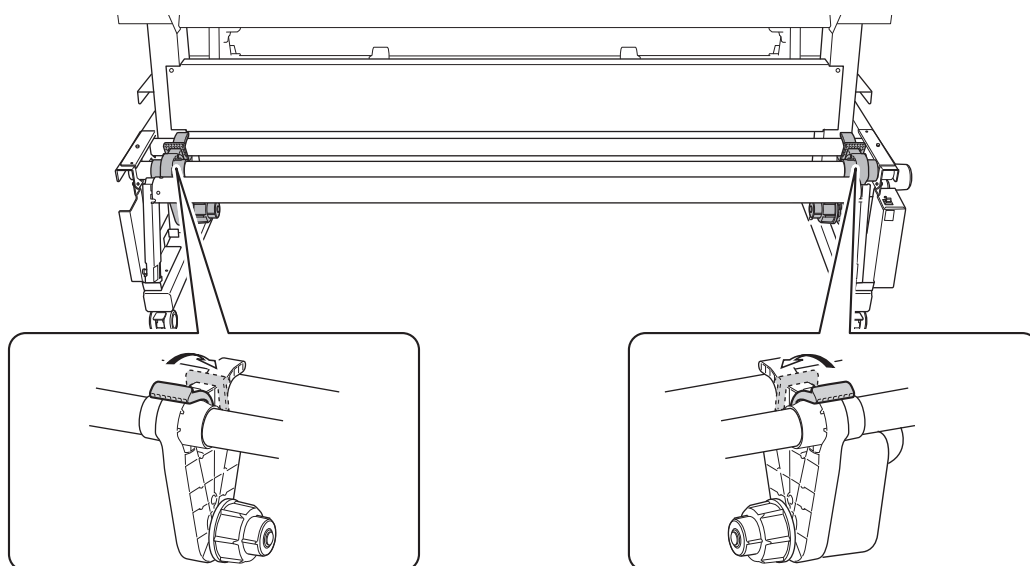
1. Follow the procedure below to load a paper tube on the media holders of the take-up unit.
Prepare a paper tube wider than the media that has been set up.

IMPORTANT

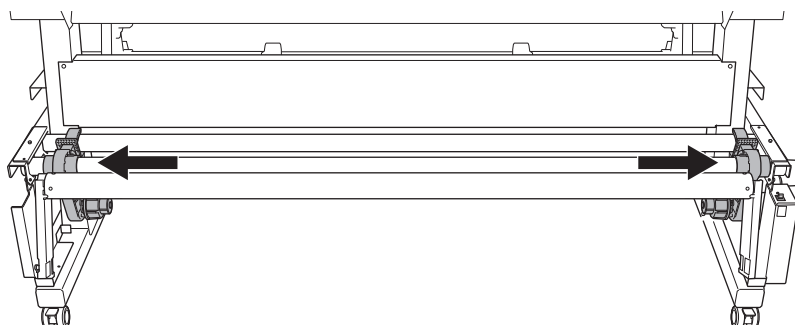
Paper tubes are consumable items.

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

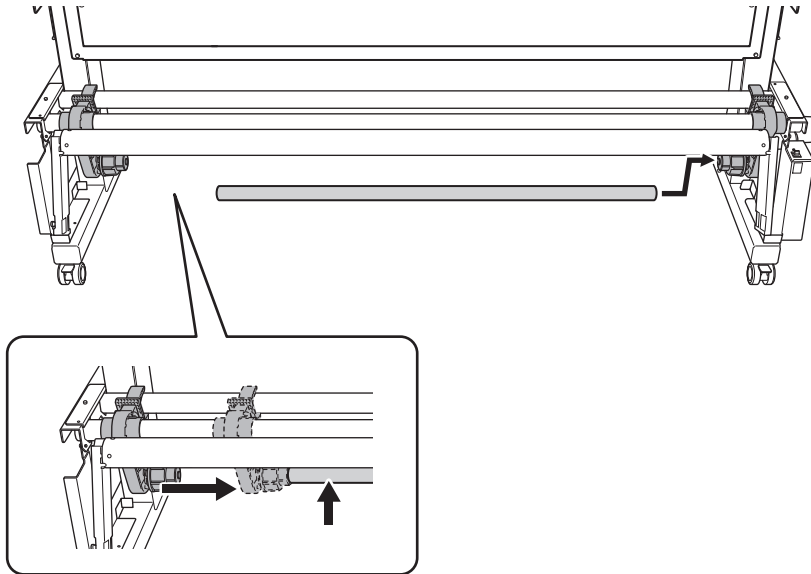
- (1) Release the media holders to enable their movement.



- (2) 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.

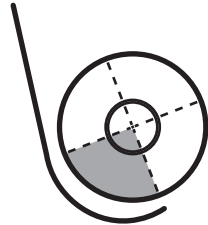
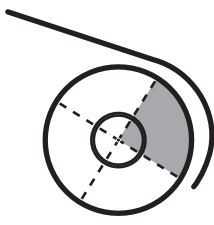


2. Tap  on the operation panel to feed out the media until the tip of the media reaches the paper tube.

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

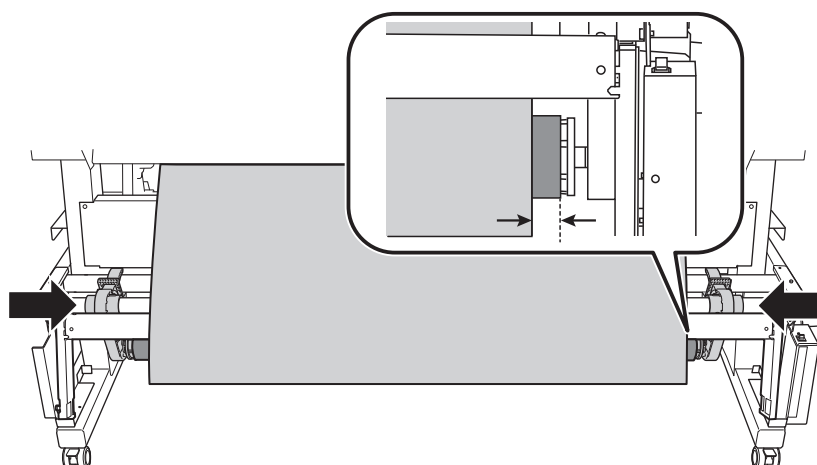
MEMO

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

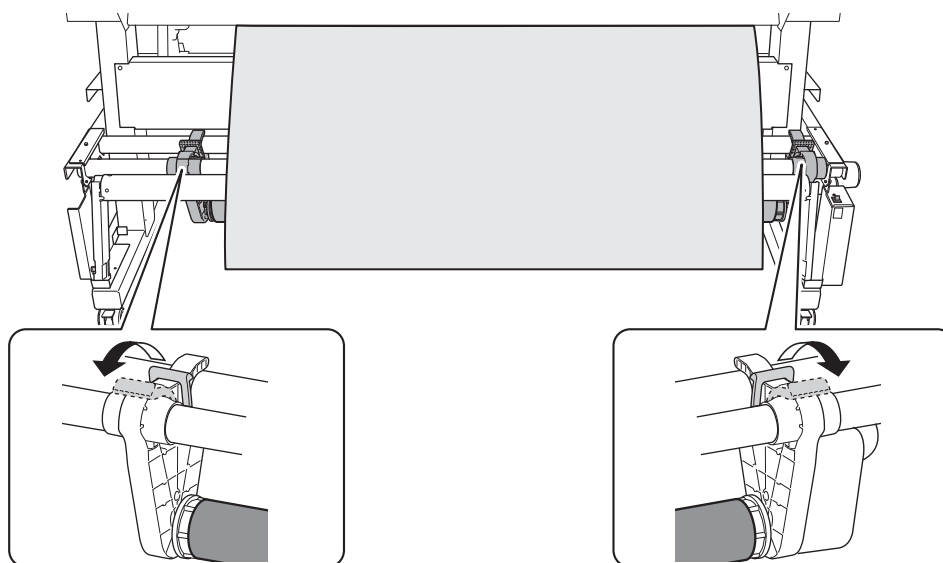
When using the FORWARD setting	When using the BACKWARD setting
	

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 the right edge of the media.

Hold the media holders from the outside and move them.



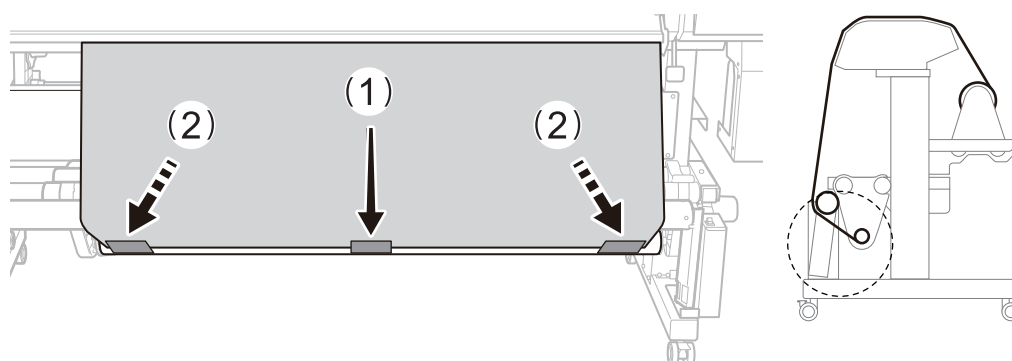
(2) Secure the left and right media holders.



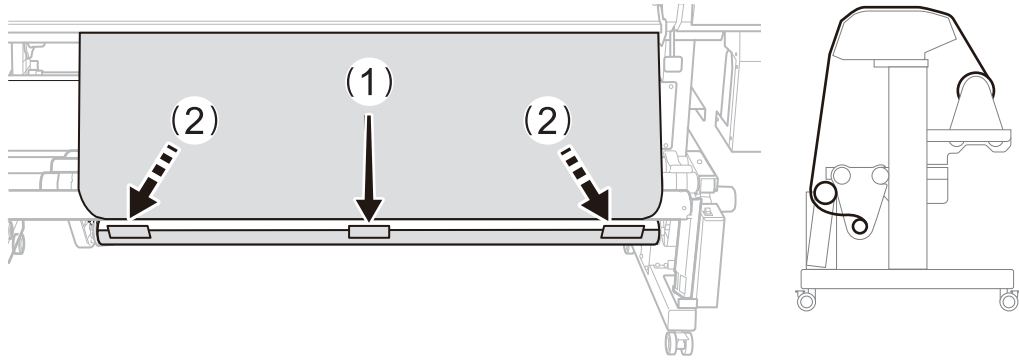
4. Follow the procedure below to secure the media on the paper tube.

Secure the media in the take-up direction set in step 3 of 1. [Set the take-up unit.](#)(P. 31).

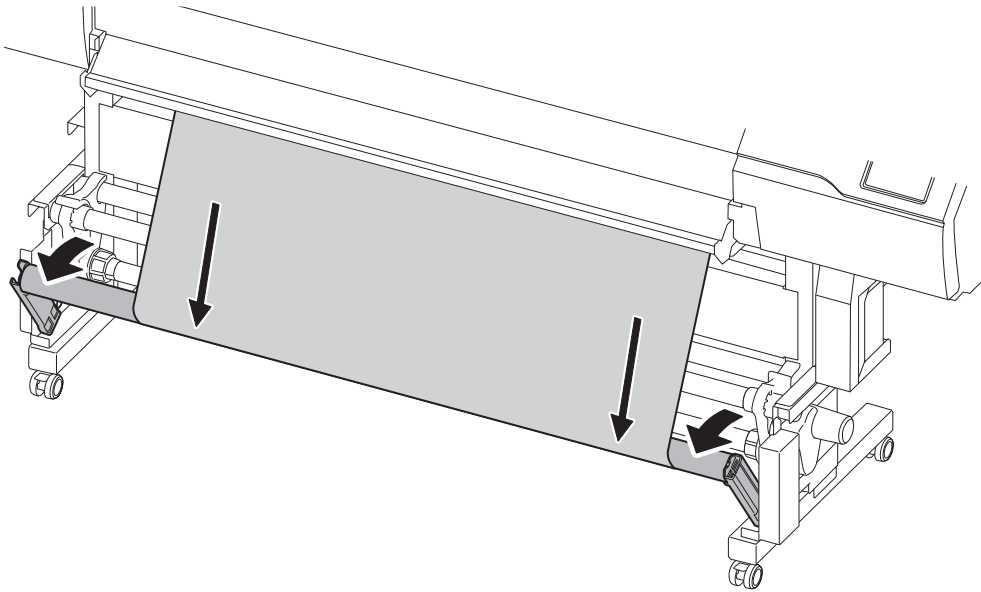
- (1) While pulling the media so that it does not sag, secure the center of the media on the paper tube with adhesive tape.
 - (2) While pulling the media from the center toward the outer edges, secure the left and right edges of the media on the paper tube with adhesive tape.
- When using the FORWARD 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].

IMPORTANT

Remove when not using roll media.

Do not leave roll media loaded on the machine for a long period of time. Be sure to remove and store the media when not in use. Leaving the roll media loaded on the machine for a long period of time will cause the media to sag, which may deteriorate the printing quality and may also lead to motor errors.

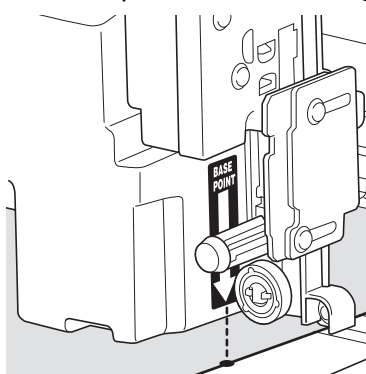
6. Configure settings to match the media.

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.

Procedure

1. On the [Heater Temperature] screen, adjust the [Print Heater] and [Dryer] temperatures.
 - If this is not necessary, tap [Next].
 - Follow the procedure below to make changes.
 - a. Tap  or  to set the [Print Heater] or [Dryer] temperature.
 - b. Tap [Next].
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\(P. 122\)](#).
3. Set the [Printing Test] and [Output Start Location] on the [Nozzle Drop-out Test] screen.
 - Proceed to step 4 if this step is not necessary.
 - Follow the procedure below to set [Output Start Location].
 - a. Tap [Output Start Location]>[Change].
 - b. Use the following operations to move the base point mark to the position you want to use to start output.



Use  or  to move the sub carriage in the scan direction (left and right). Use  or  to move the media in the feed direction (forward and backward).

- c. 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 **[Printing Test]>[Execute]**. For details on what to do after the printing test, refer to [Normal Cleaning Method\(P. 215\)](#).

4. Tap [Next].

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. Make sure the printing area required for the printing test is at least 290 mm (11.42 in.) wide before performing adjustment.

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

For more information, refer to [Automatically Making Required Adjustments\(P. 116\)](#).

- 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\(P. 140\)](#).
- c. Tap **[Next]**.
- d. Tap **[Printing Test]>[Execute]** on the **[Detailed Feed Correction (Manual)]** screen. Make sure the printing area required for the printing test is at least 375 mm (14.77 in.) wide before performing adjustment.
Set the correction value from the printing test result. For more information, refer to [Manual Adjustment: Reducing Horizontal Bands \(Feed Correction\)\(P. 117\)](#).
- e. Tap **[Save and Proceed]**.
- f. Tap **[Printing Test]>[Execute]** 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 \(Media Gap Adjustment\)\(P. 120\)](#).
- g. Tap **[Save and Exit]**.

This completes the setup.

Setup of Sheet Media

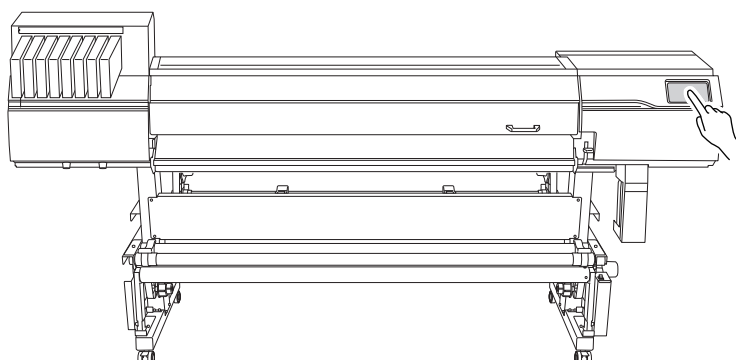
Load the sheet media on the printer. When the loading is finished, [Output possible.] is displayed as the status. This work is referred to as "Setup of Media."

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

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

Procedure

1. Tap the operation panel.



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

The power to the operation panel is switched on.

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

(1) Tap .

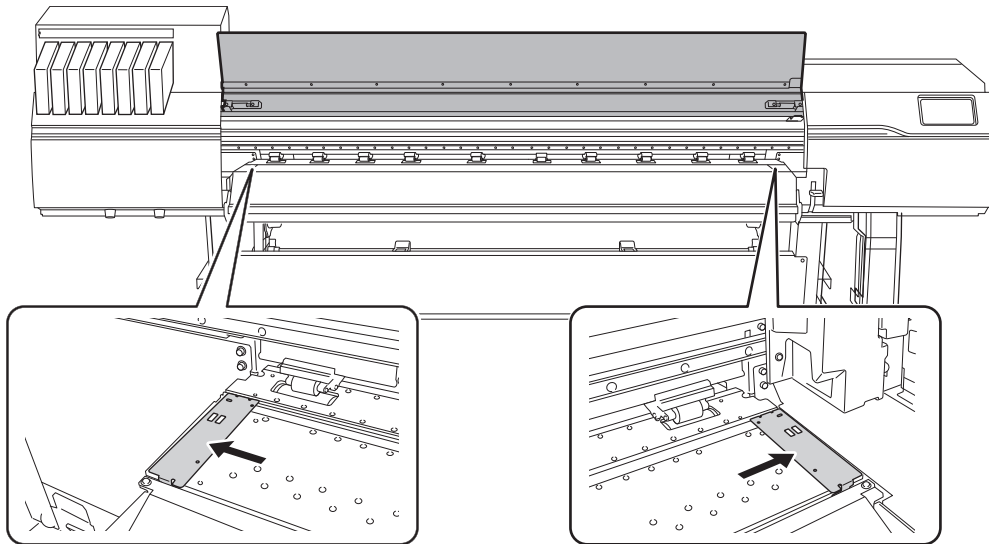
(2) Tap [Preferences]>[Skewing Correction Support at Setup].

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

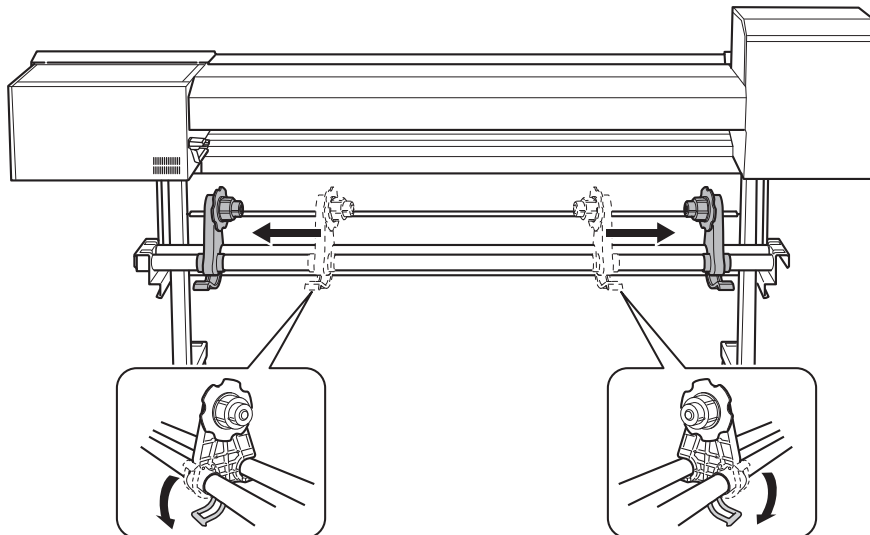
(4) Press  to return to the original screen.

4. Open the front cover.

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



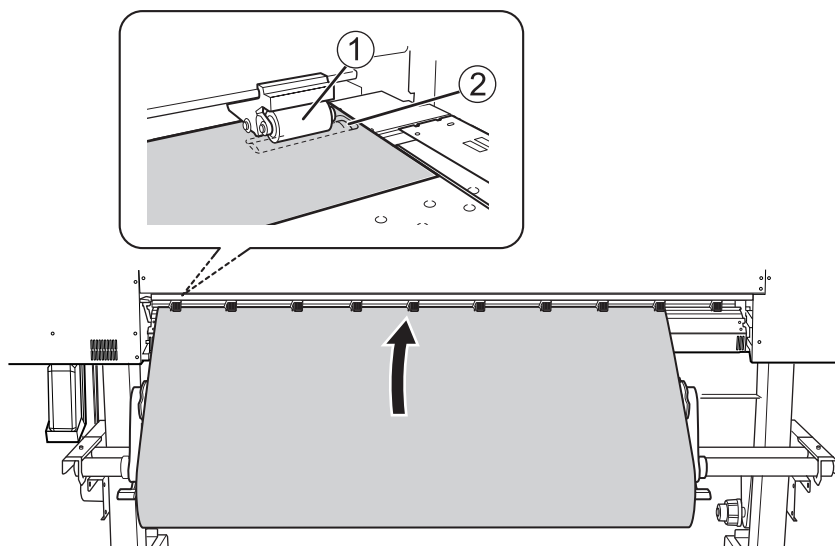
6. Move to the rear of the printer. Release the locking mechanisms of the media holders, and then draw them to the left and right ends respectively.



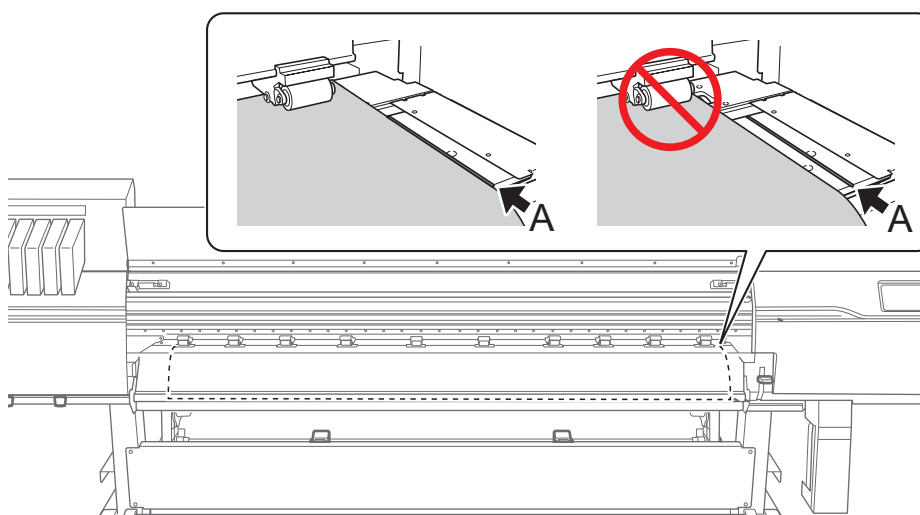
7. From the rear of the printer, pass the leading edge of the media between the pinch rollers (①) and the grit rollers (②).

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.

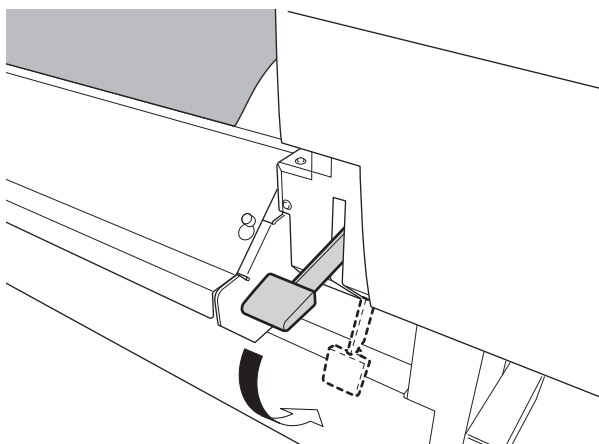
When loading the media from the front of the printer, feed the leading edge of the media (the side where printing will start) over the platen, and then pull the media to the front to activate the suction fan.



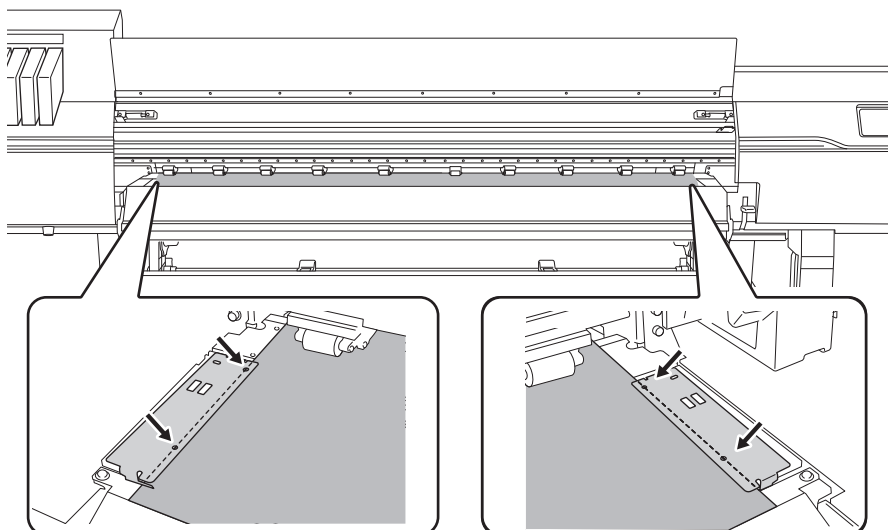
8. Make sure the right edge of the media is in line with the guide line (A).



9. Lower the loading lever (front).
The media is held in place.



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



IMPORTANT

Be sure to use the media clamps when you 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.

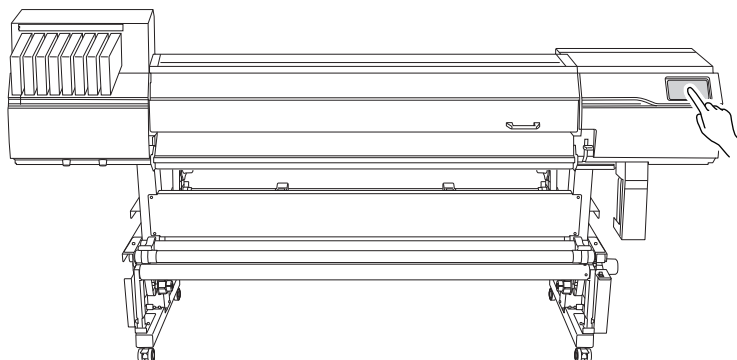
11. Close the front cover.

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

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

Procedure

1. Tap the operation panel.



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

The power to the operation panel is switched on.

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

(1) Tap .

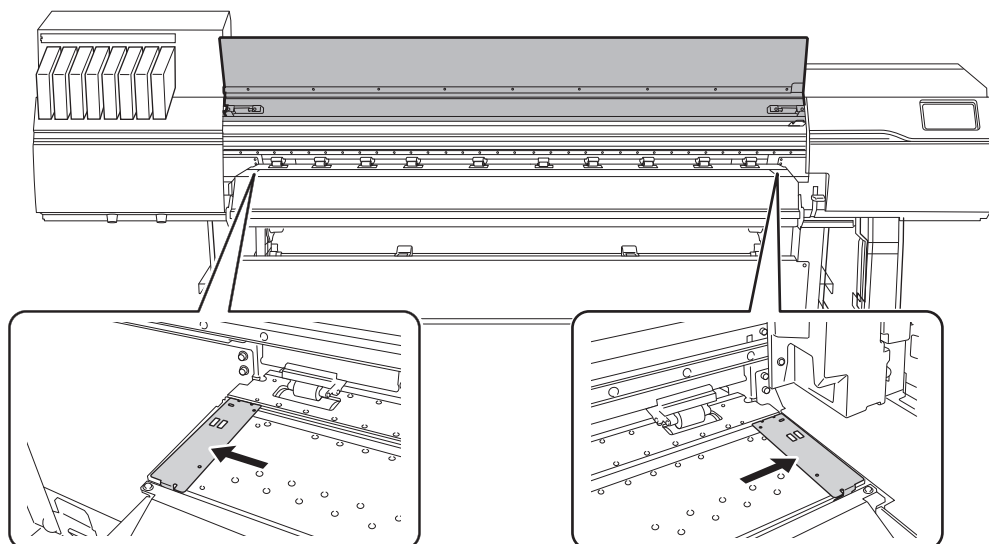
(2) Tap [Preferences]>[Skewing Correction Support at Setup].

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

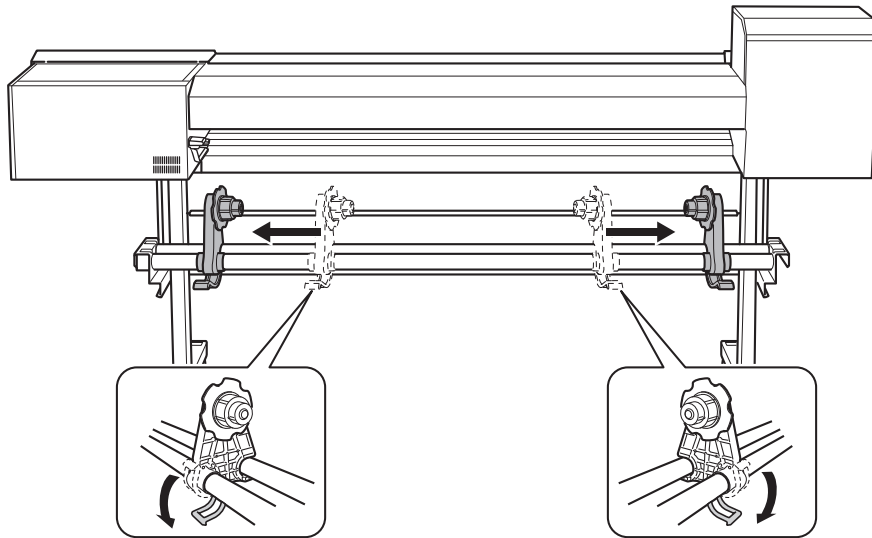
(4) Press  to return to the original screen.

4. Open the front cover.

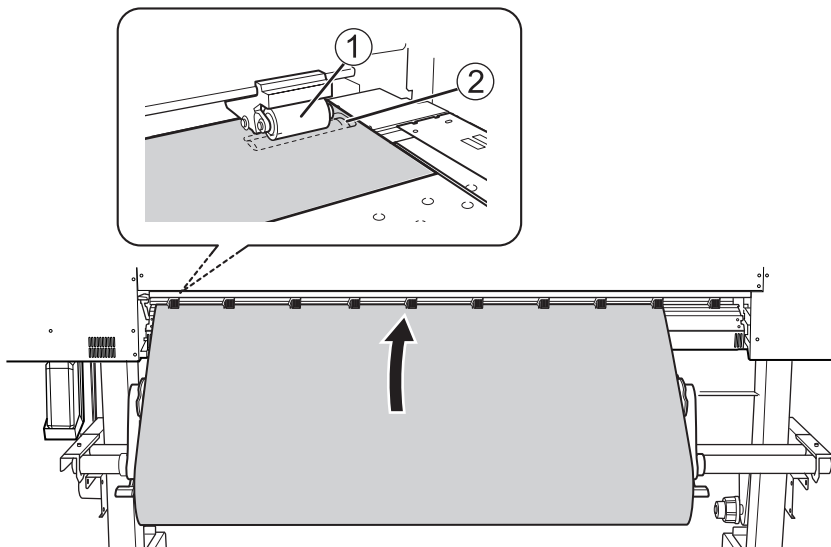
5. Move the media clamps to the outside of the grit rollers on the left and right edges respectively.



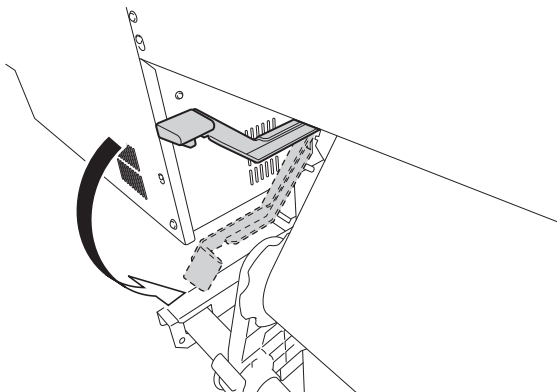
6. Move to the rear of the printer. Release the locking mechanisms of the media holders, and then draw them to the left and right ends respectively.



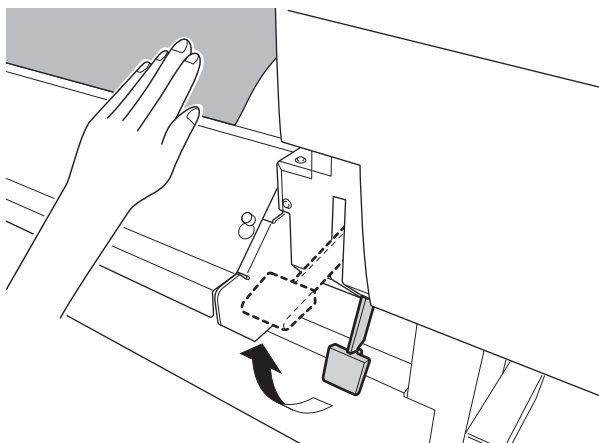
7. Pass the leading edge of the media between the pinch rollers (①) and the grit rollers (②).



8. Lower the loading lever (rear).
The media is held in place.

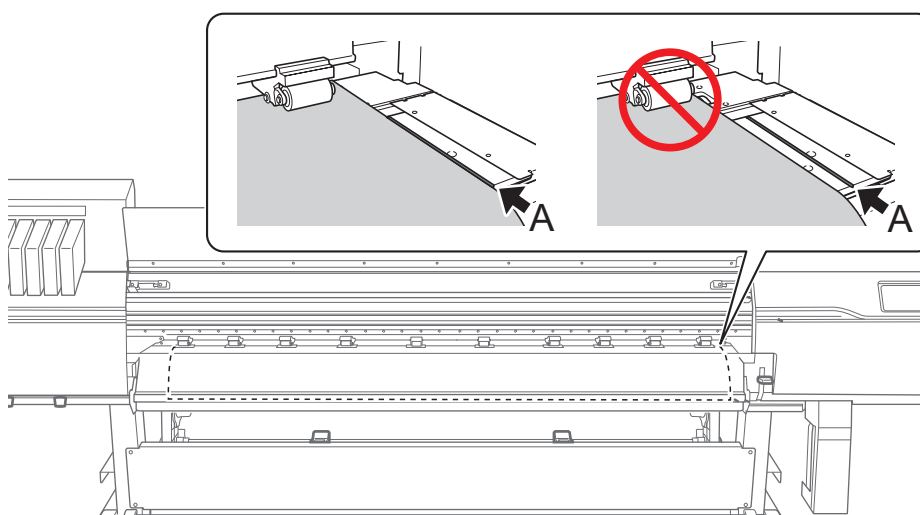


9. (Move to the front of the printer.) Gently hold down the media and raise the loading lever (front).

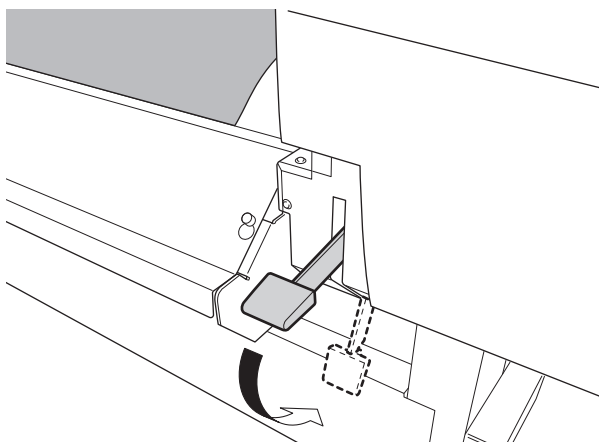


10. If an auxiliary drying unit (DU3) is installed, insert the leading edge of the media into the dryer.

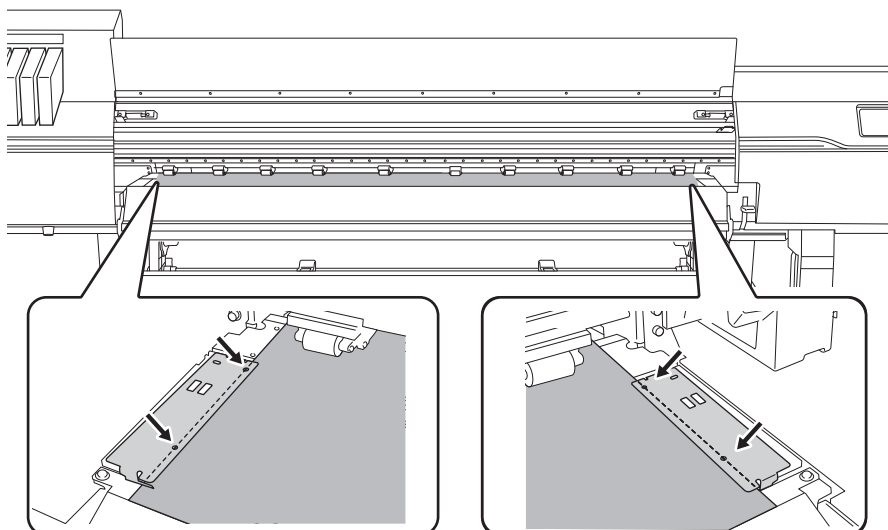
11. Make sure the right edge of the media is in line with the guide line (A).



12. Lower the loading lever (front).
The media is held in place.



13. 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.

14. Close the front cover.

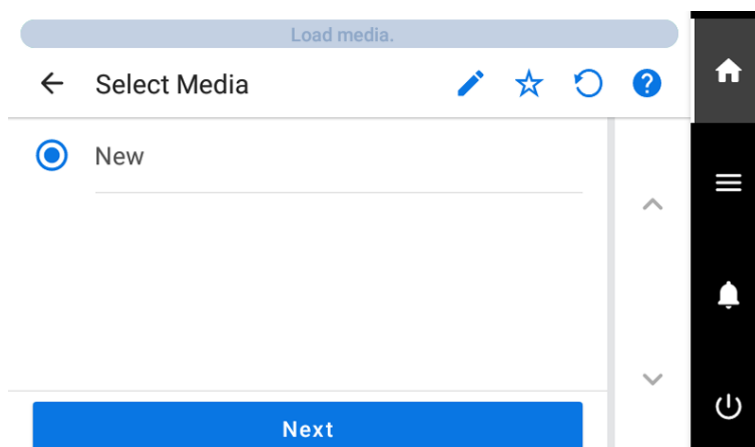
2. Register the media.

Procedure

1. Tap  [Setup].

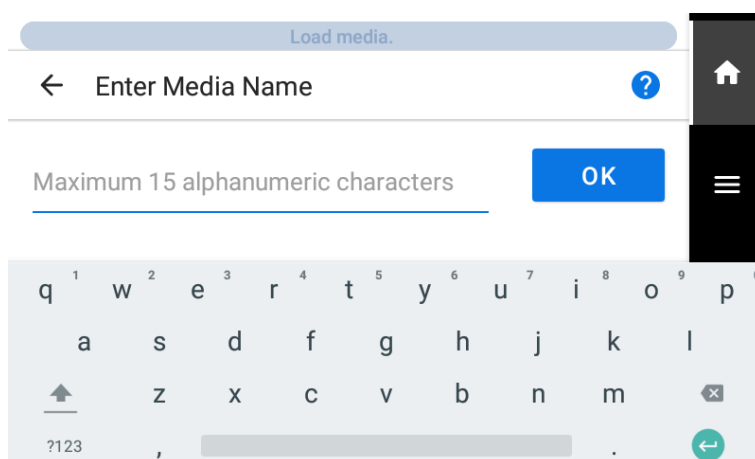
2. Select [New].

3. Tap [Next].



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

Tap the keyboard displayed on the screen to enter the name.
You can use up to 15 alphanumeric characters.



5. Check the name you have entered and tap [Next] if it is correct.

To make corrections, tap the name you entered.

6. On the [Select Sheet Type] screen, select [Opaque]/[Transparent] and tap [Next].

7. The [Sheet Settings] screen appears. Configure the settings as shown below depending on the sheet type.

- For opaque media

- a. Tap [Side Margin] to set the margin.

You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).

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

8. Tap [Next].

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

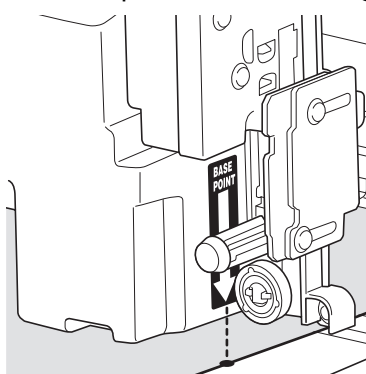
3. Configure settings to match the media.

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

Procedure

1. On the [Heater Temperature] screen, adjust the [Print Heater] and [Dryer] temperatures.
 - If this is not necessary, tap [Next].
 - Follow the procedure below to make changes.
 - a. Tap  or  to set the [Print Heater] or [Dryer] temperature.
 - b. Tap [Next].
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\(P. 122\)](#).
3. Set the [Printing Test] and [Output Start Location] on the [Nozzle Drop-out Test] screen.
 - Proceed to step 4 if this step is not necessary.
 - Follow the procedure below to set [Output Start Location].
 - a. Tap [Output Start Location]>[Change].
 - b. Use the following operations to move the base point mark to the position you want to use to start output.



Use  or  to move the sub carriage in the scan direction (left and right). Use  or  to move the media in the feed direction (forward and backward).

- c. 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 **[Printing Test]>[Execute]**. For details on what to do after the printing test, refer to [Normal Cleaning Method\(P. 215\)](#).

4. Tap [Next].

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.

- Tap **[Simple Correction (Auto)]>[Next]**.
- Tap **[Execute]** on the **[Batch Automatic Correction]** screen. Make sure the printing area required for the printing test is at least 290 mm (11.42 in.) wide before performing adjustment.

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

For more information, refer to [Automatically Making Required Adjustments\(P. 116\)](#).

- Follow the procedure below to make manual adjustments.

- Tap **[Detailed Correction (Manual)]>[Next]**.
- 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\(P. 140\)](#).
- Tap **[Next]**.
- Tap **[Printing Test]>[Execute]** on the **[Detailed Feed Correction (Manual)]** screen. Make sure the printing area required for the printing test is at least 375 mm (14.77 in.) wide before performing adjustment.
Set the correction value from the printing test result. For more information, refer to [Manual Adjustment: Reducing Horizontal Bands \(Feed Correction\)\(P. 117\)](#).
- Tap **[Save and Proceed]**.
- Tap **[Printing Test]>[Execute]** 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 \(Media Gap Adjustment\)\(P. 120\)](#).
- 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.).

To avoid injury, handle the roll media with care.

CAUTION

Never load media that weighs over 45 kg (99.21 lb.).

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

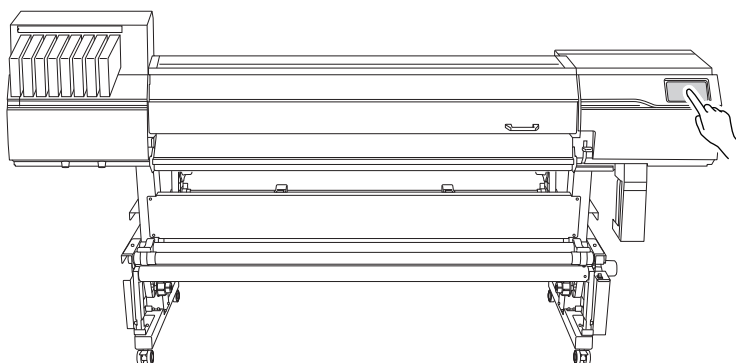
1. Set the take-up unit.

If you will not use the take-up unit, proceed to [2. Installing the Media on the Media Holders\(P. 68\)](#). Make sure the following settings match the loading method and output method of the actual media. The settings will have to be changed from the defaults when:

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

Procedure

1. Tap the operation panel.



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

The power to the operation panel is switched on.

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

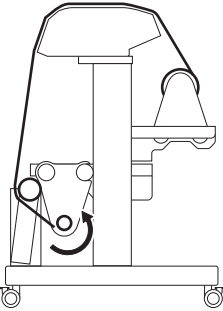
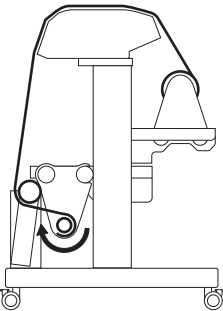
- (1) Tap .
- (2) Tap [Preferences]>[Take-up]>[Take-up Method].
- (3) Select [Loose Winding] or [Tension Winding].

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

MEMO

- Default setting: [Loose Winding]

- (4) Tap [Save].
- (5) Tap [Take-up Direction].
- (6) Select [Backward] or [Forward].

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

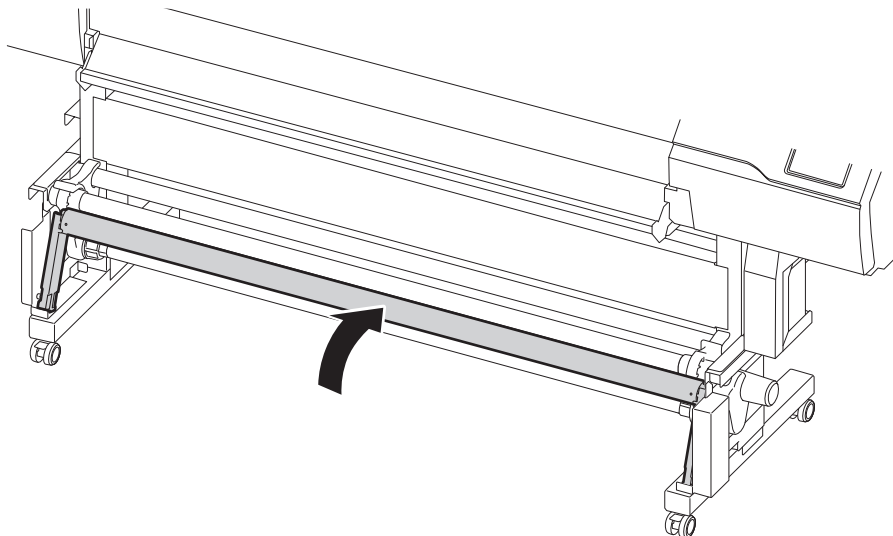
MEMO

- Default setting: [Forward]

(7) Tap [Save].

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

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



2. 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.

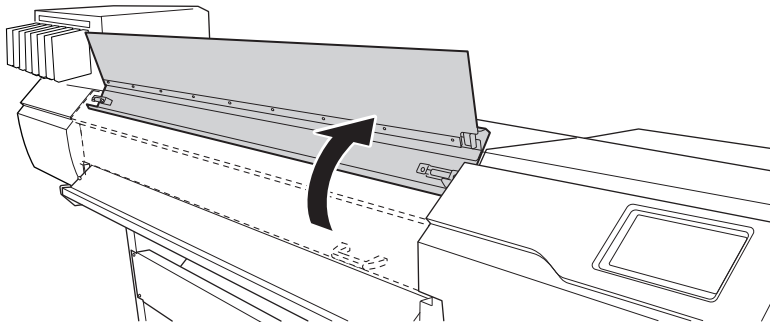
Attempting to lift heavy media in a manner that taxes your strength may cause physical injury. Also, if dropped, such items may cause injury.

MEMO

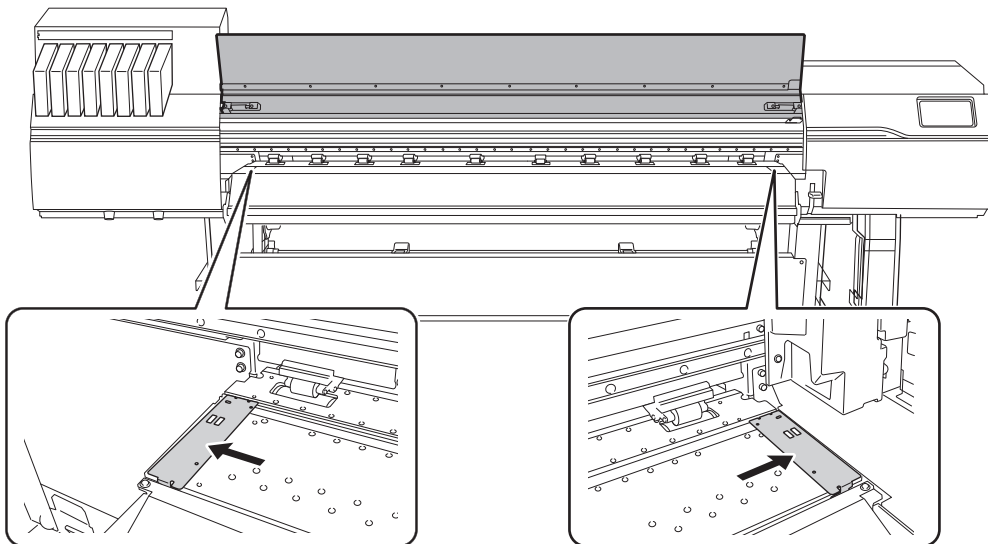
The media holders of this machine are designed to be used with a paper tube (core) with an inner diameter of 2 inches or 3 inches.

Procedure

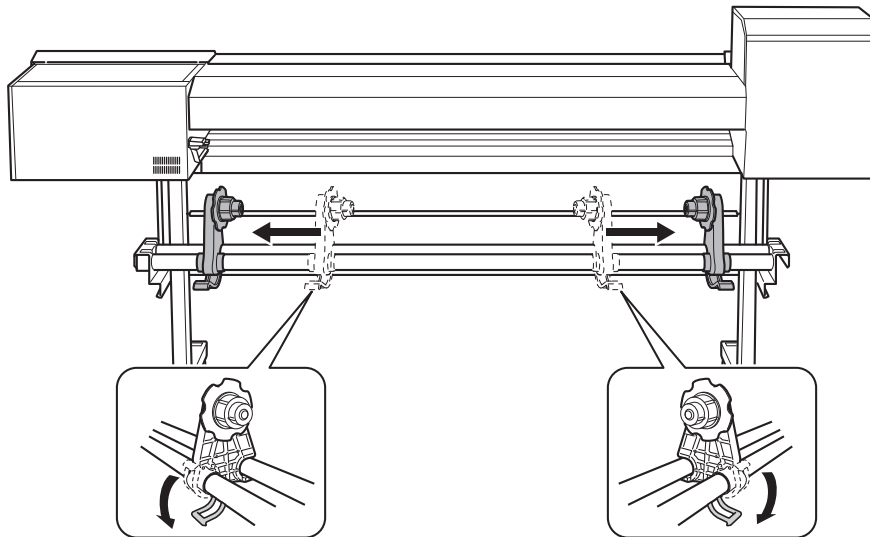
1. Open the front cover.



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



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



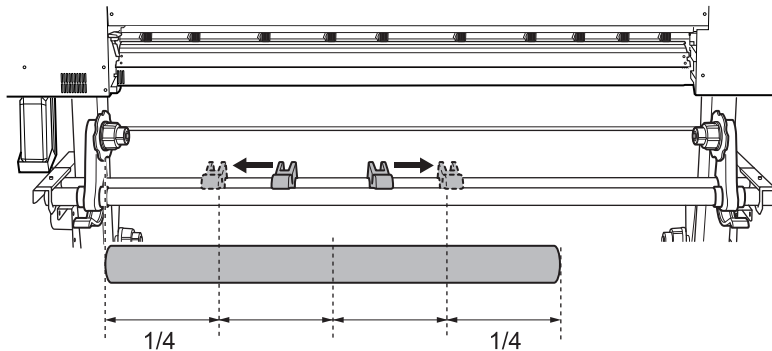
4. Place the media on the machine.

IMPORTANT

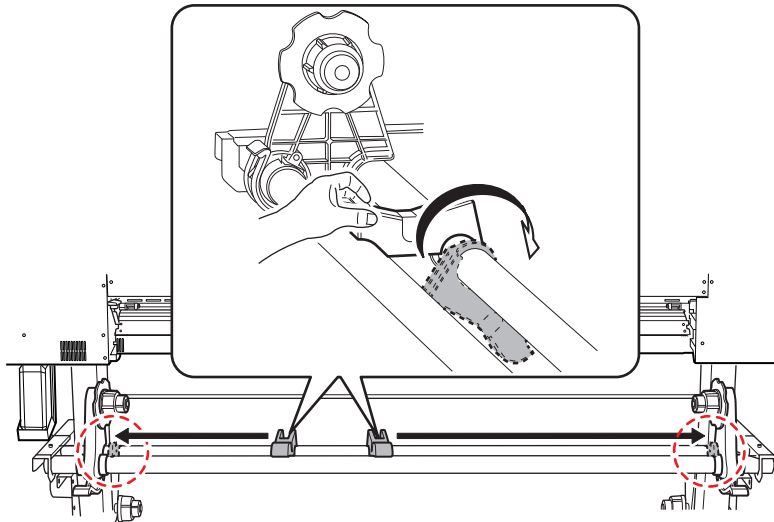
Do not leave media on the media stays or the pipes for a long period of time. The media may become deformed. Exercise caution.

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

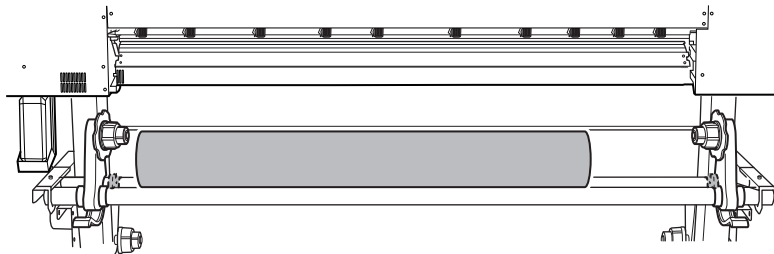
Place the media stays at positions that are $\frac{1}{4}$ the length of the media from each end of the media, and then load the media.



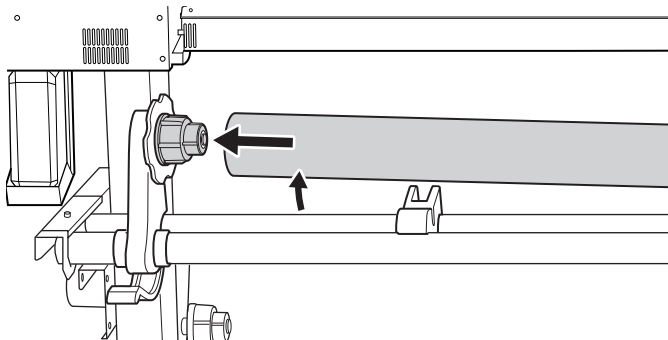
- Roll media with an outer diameter exceeding 220 mm (8.67 in.)
 - a. Rotate the media stays to draw them to the media holders.



- b. Place the media directly between the two pipes.



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

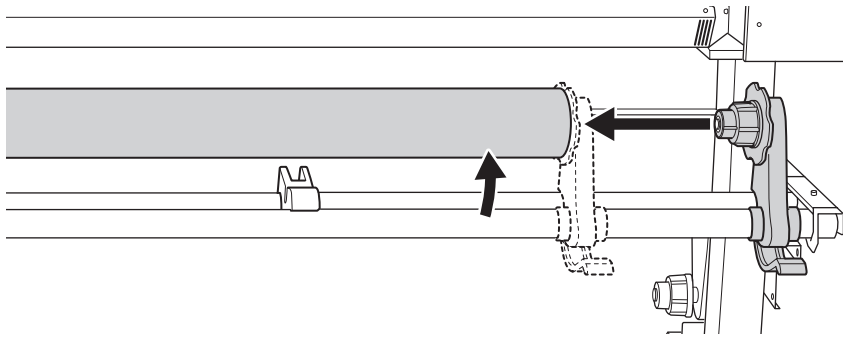


6. Move the right media holder to fit its end cap onto the paper tube (core) of the media.
Fit the paper tube onto the media holders securely to prevent the media from moving easily.

IMPORTANT

Do not secure the media holders in place just yet.

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



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

- Opaque media: [3. A: Determine the positions of the media \(opaque media\).\(P. 72\)](#)
- Transparent media, etc.: [3. B: Determine the positions of the media \(transparent media, etc.\).\(P. 76\)](#)

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

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

Procedure

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

(1) Tap .

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

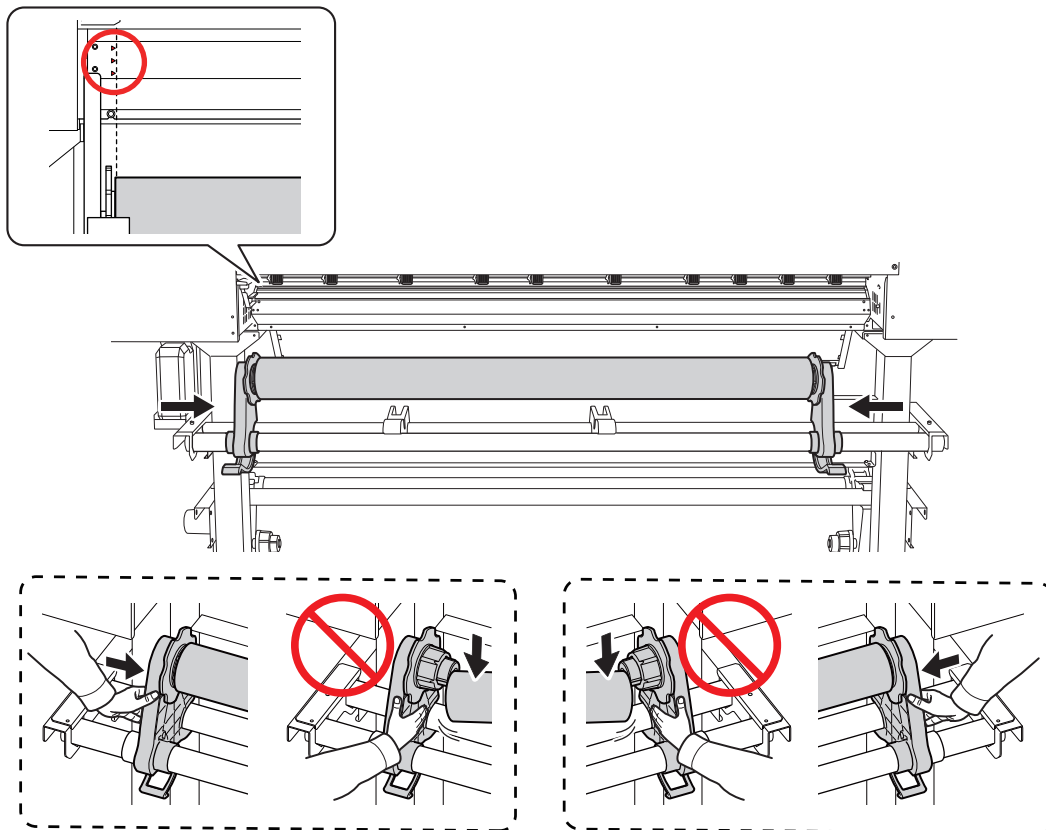
(3) Select [Enable] and tap [Save].

(4) Press  to return to the original screen.

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

Note the following points when determining the positions.

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



⚠ CAUTION

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

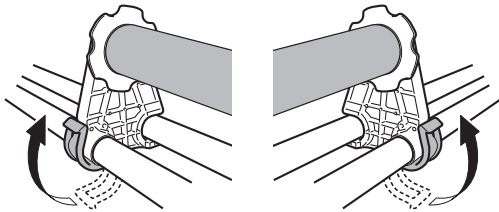
Otherwise the media may fall off the media holder and cause injury.

IMPORTANT

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

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

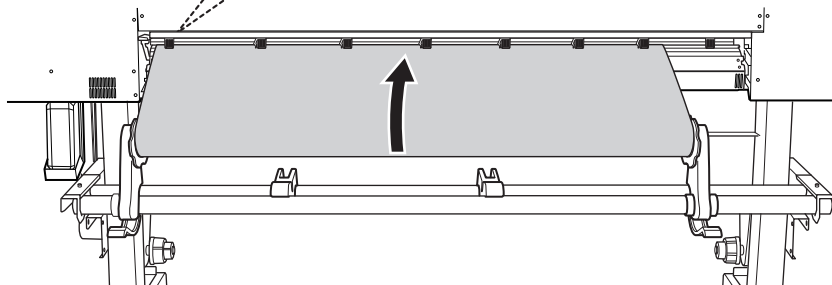
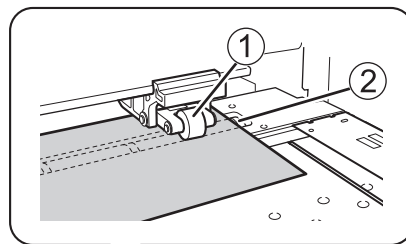
3. Secure the media holders.



4. Use the following procedure to load the media.

Doing so will prevent media skewing.

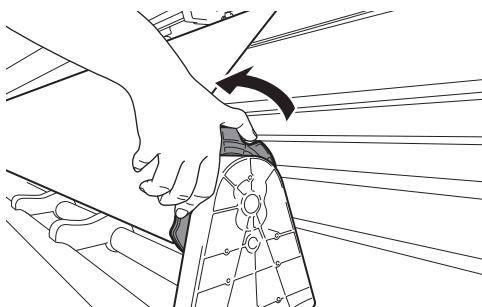
- (1) Pass the leading edge of the media between the pinch rollers (①) and the grit rollers (②).



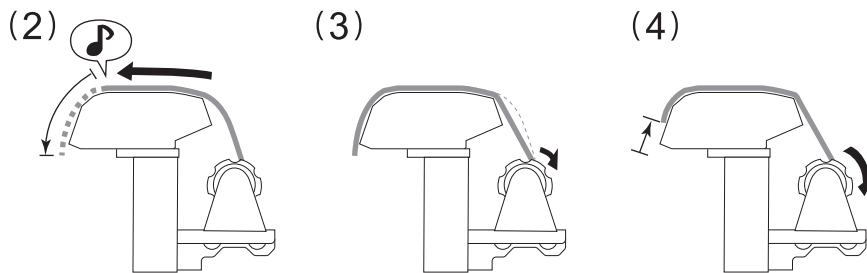
- (2) Feed the media until you hear a beep, and then additionally feed approximately 20 cm (7.87 in.) of the media.

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.



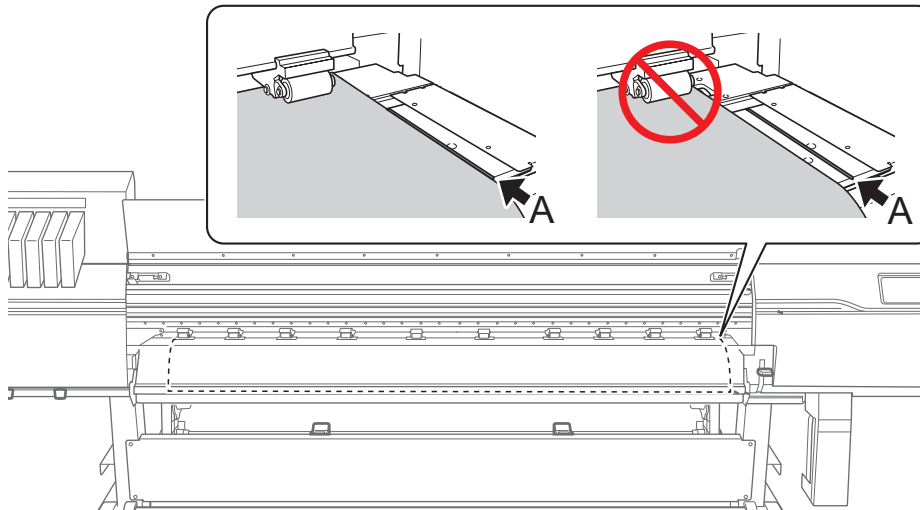
- (4) Once the media is taut, additionally take up approximately 10 cm (3.94 in.) of media.



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).

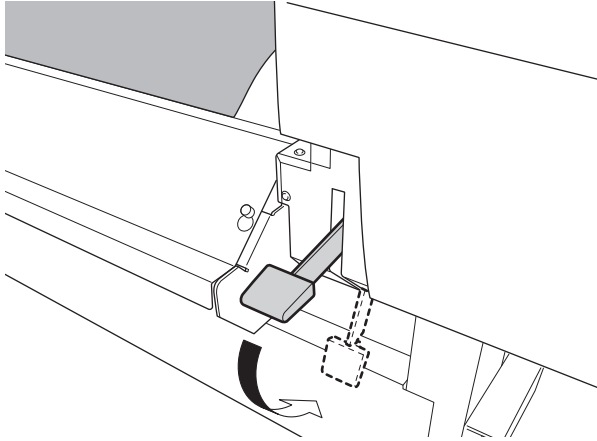
5. (Move to the front of the printer.) Make sure the right edge of the media is in line with the guide line (A).



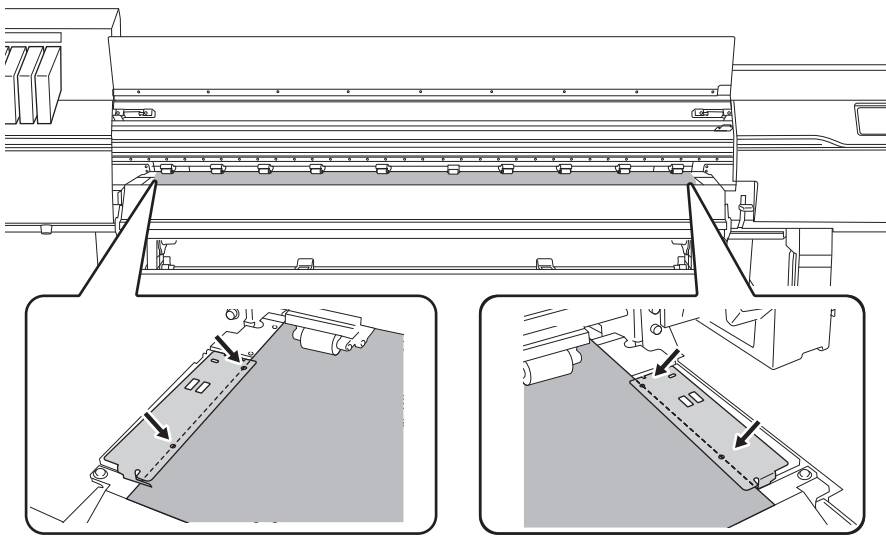
IMPORTANT

If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from Step 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.

6. Lower the loading lever (front).
The media is held in place.



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



IMPORTANT

Be sure to use the media clamps when you 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.

8. Close the front cover.

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

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

Procedure

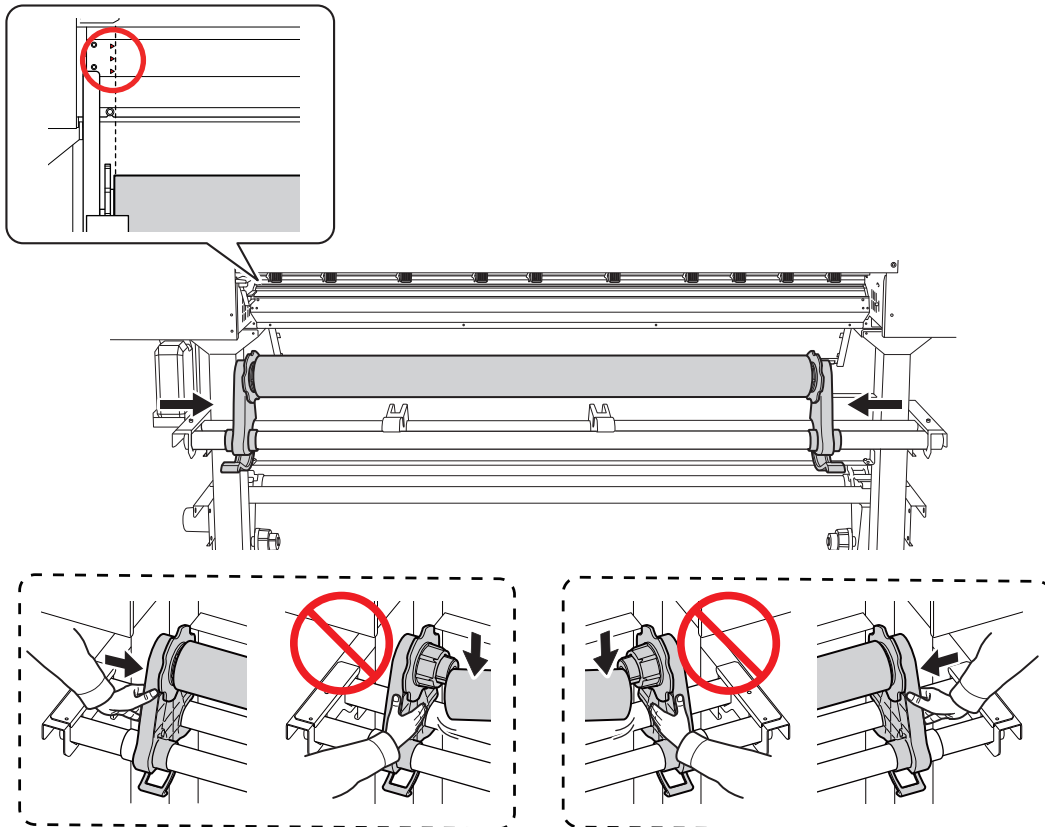
1. Set the [Skewing Correction Support at Setup].

- (1) Tap .
- (2) Tap [Preferences]>[Skewing Correction Support at Setup].
- (3) Select [Disable] and tap [Save].
- (4) Press  to return to the original screen.

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

Note the following points when determining the positions.

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



⚠ CAUTION

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

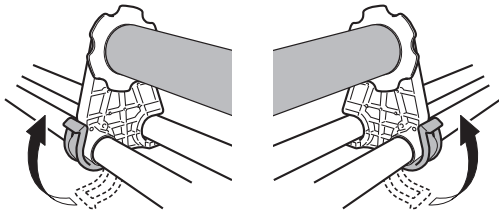
Otherwise the media may fall off the media holder and cause injury.

IMPORTANT

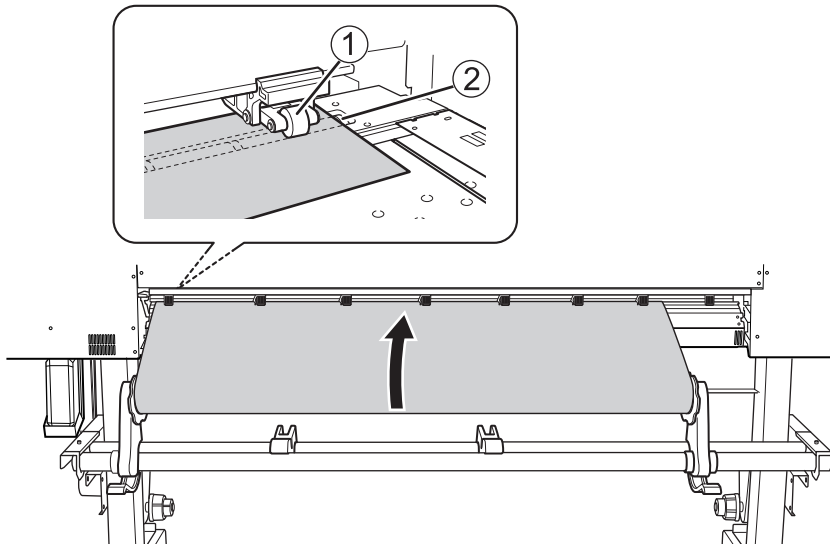
Firmly decide the left and right side positions of the media at this point.

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

3. Secure the media holders.

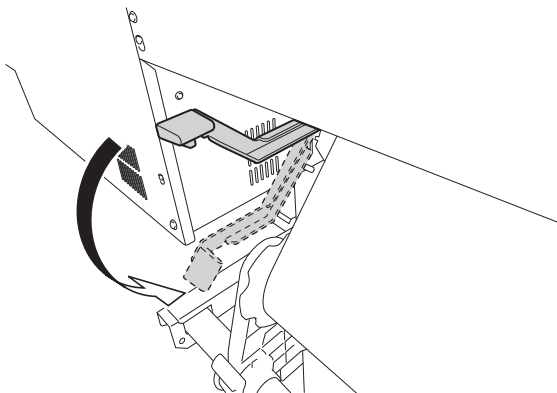


4. Pass the leading edge of the media between the pinch rollers (①) and the grit rollers (②).

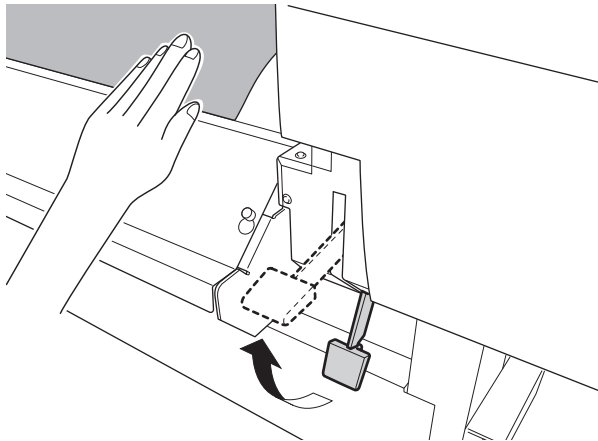


5. Lower the loading lever (rear).

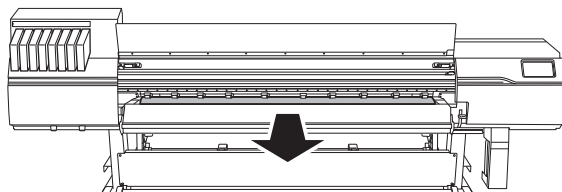
The media is held in place.



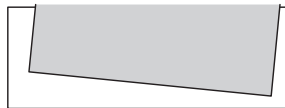
6. (Move to the front of the printer.) Gently hold down the media and raise the loading lever (front).



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

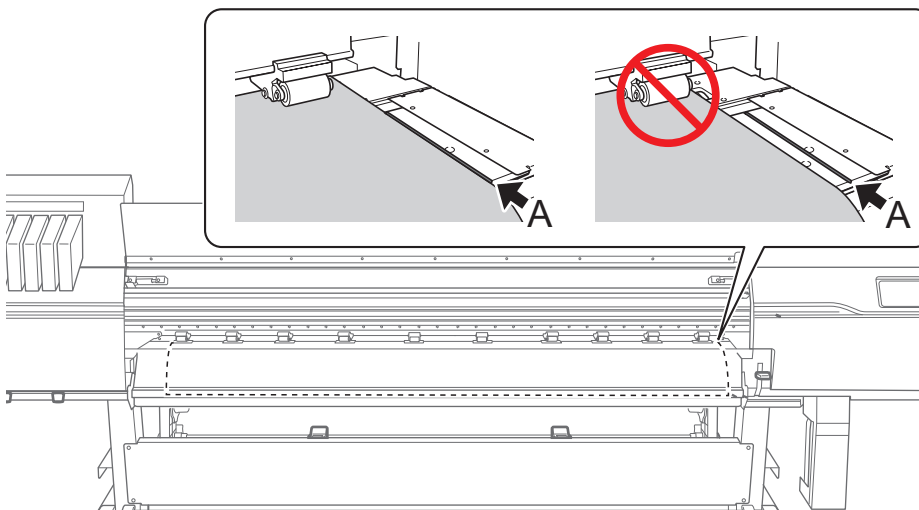


Good



Not good

8. If an auxiliary drying unit (DU3) is installed, insert the leading edge of the media into the dryer.
9. Make sure the right edge of the media is in line with the guide line (A).



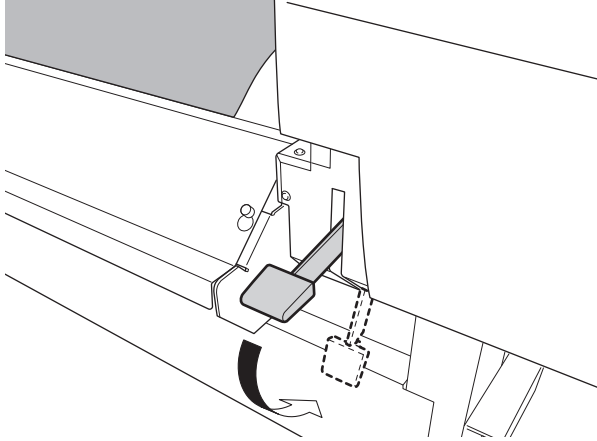
IMPORTANT

If you want to readjust the media position, return to the back of the printer, release the media holders, and then redo the procedure from Step 2. If you just stand at the front of the printer and hold the media to

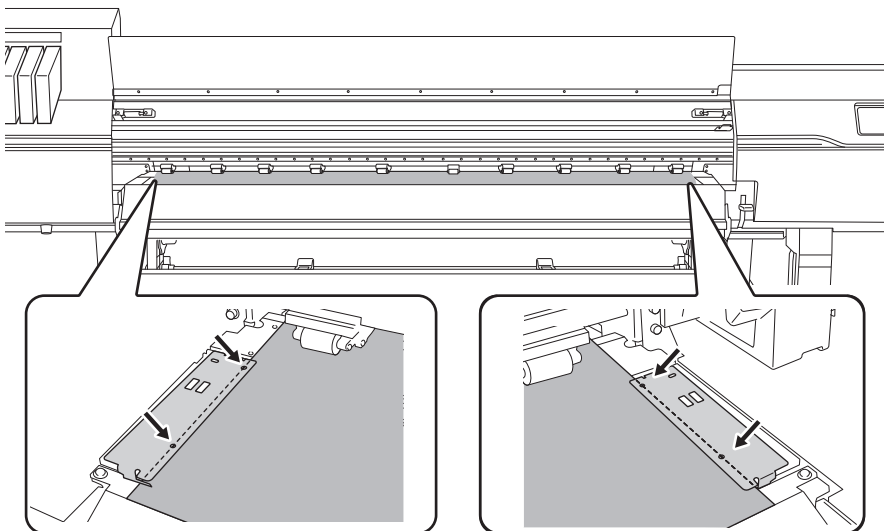
readjust its position forcibly, the media will be skewed during printing or will come loose, which will affect the printing quality.

10. Lower the loading lever (front).

The media is held in place.



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



IMPORTANT

Be sure to use the media clamps when you 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.

12. Close the front cover.

4. Select 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.

The procedure is as follows.

- **Searching for keywords in the media list**

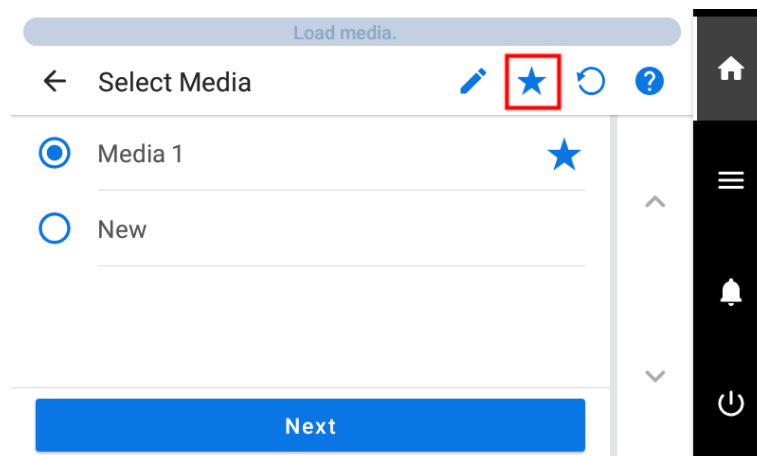
1. Tap .
2. Tap the input field.
You can use up to 15 alphanumeric characters.
Searching for partial matches instead of exact matches is also possible.
3. Enter the keyword to search for and tap [OK].

- **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 [Sheet Settings] screen appears. Configure the settings as shown below depending on the sheet type.
 - For opaque media
 - a. Tap [Side Margin] to set the margin.
You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
 - b. Tap [OK].
 - For transparent media, etc.
 - [Sheet Width] setting
 - a. Tap  to the right of [Sheet Width].
 - b. Enter the sheet width and tap [OK].
 - [Sheet Right Edge] setting
 - a. Tap [Change] to the right of [Sheet Right Edge].
 - b. Tap  or  to move the sub carriage's base point mark to the right edge of the media, and then tap [OK].
 - [Side Margin] setting
 - a. Tap [Side Margin] to set the margin.
You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
 - b. Tap [OK].
5. Tap [Next].
6. The [Setup Method] screen will appear. Select [Do Not Use Take-up Unit] or [Use Take-up Unit].
7. Tap [Start Setup].
 - When not using the take-up unit:
This completes the setup.
 - When using the take-up unit:
Proceed to 5. [Load the media in the take-up unit.\(P. 82\).](#)

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

Procedure

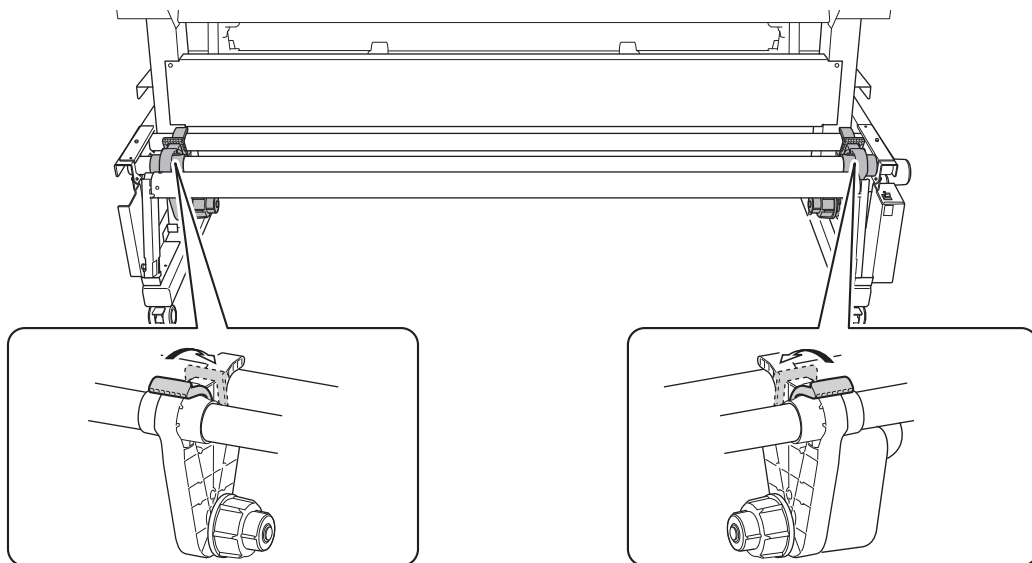
1. Follow the procedure below to load a paper tube on the media holders of the take-up unit.
Prepare a paper tube wider than the media that has been set up.

IMPORTANT

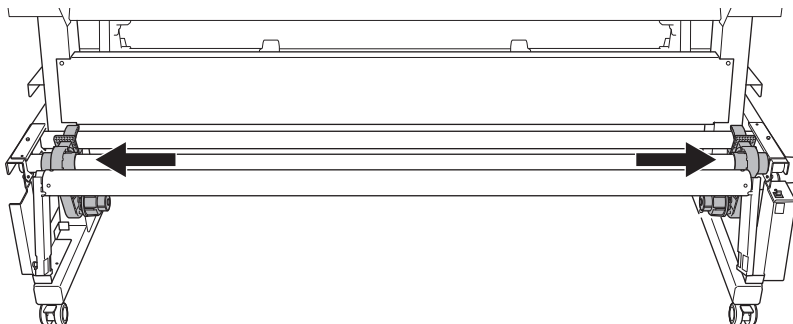
Paper tubes are consumable items.

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

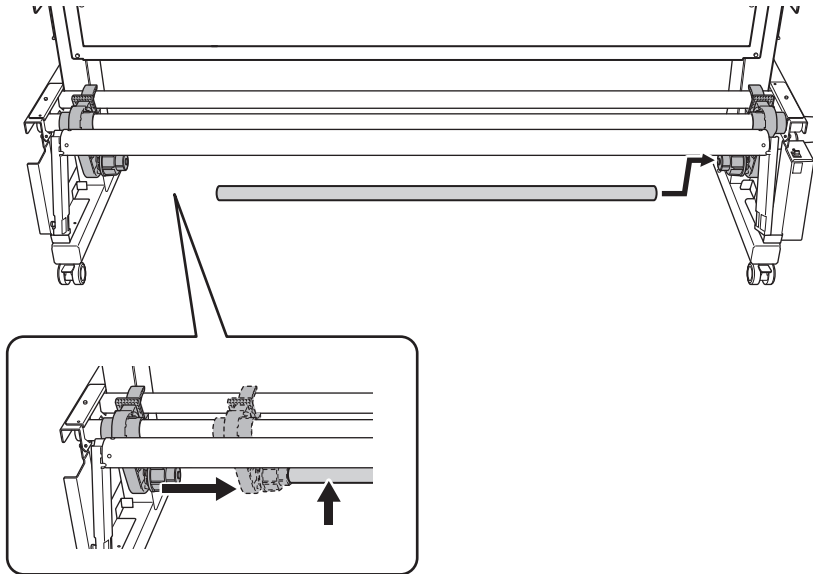
- (1) Release the media holders to enable their movement.



- (2) 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.

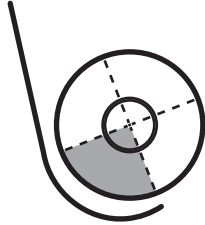
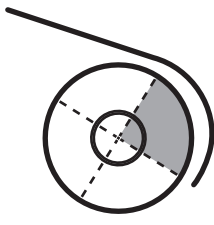


2. Tap  on the operation panel to feed out the media until the tip of the media reaches the paper tube.

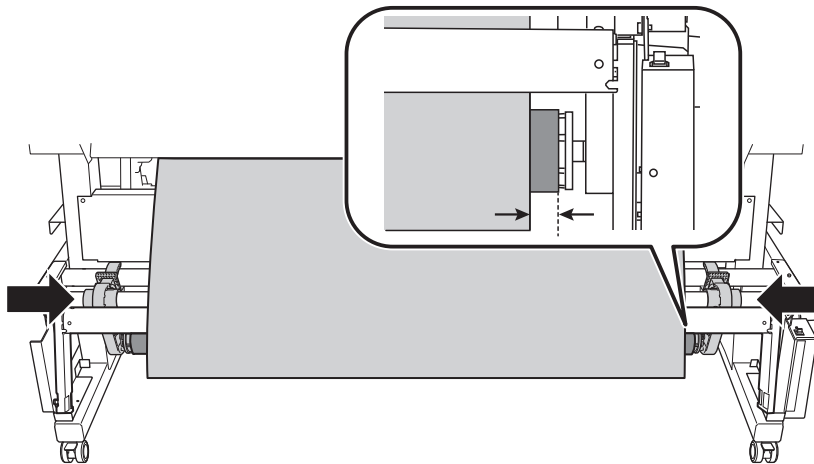
Media is fed out 10 mm (0.39 in.) each time you press this button. Holding down the button lets you feed out paper continuously.

MEMO

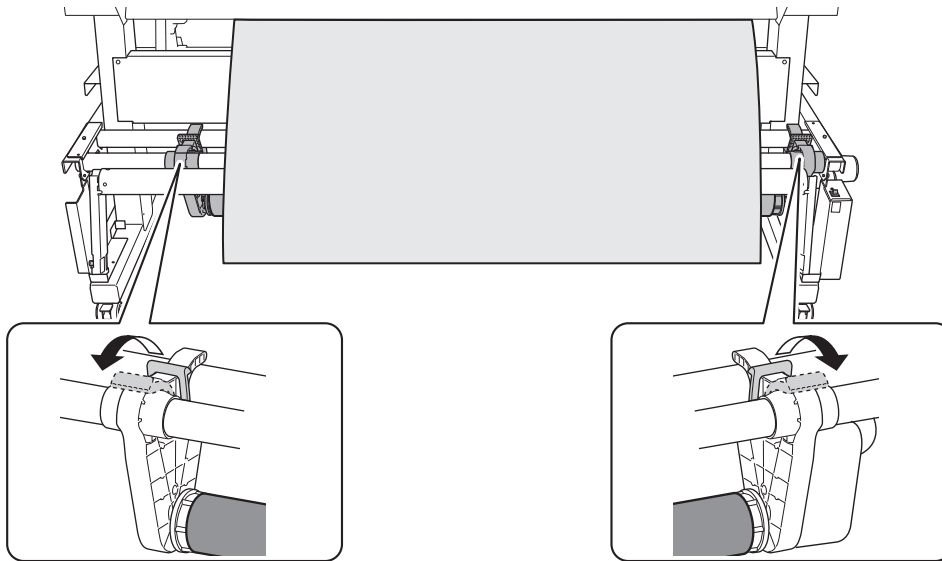
Feed out the media until it can wrap around at least 1/4 of the paper tube.

When using the FORWARD setting	When using the BACKWARD setting
	

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 the right edge of the media.
Hold the media holders from the outside and move them.



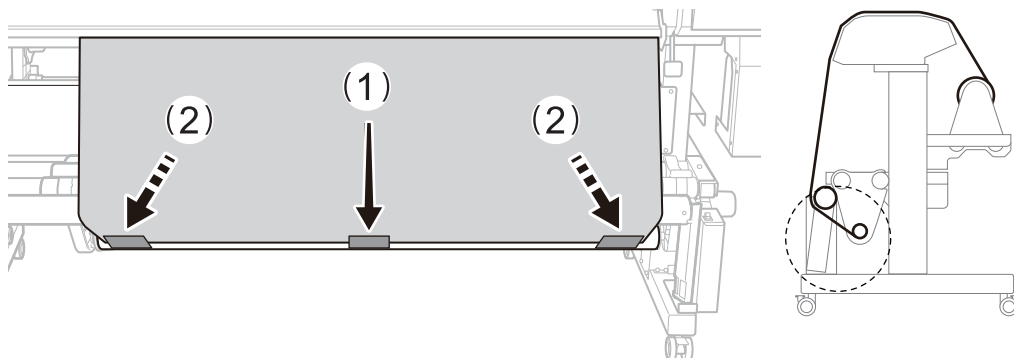
(2) Secure the left and right media holders.



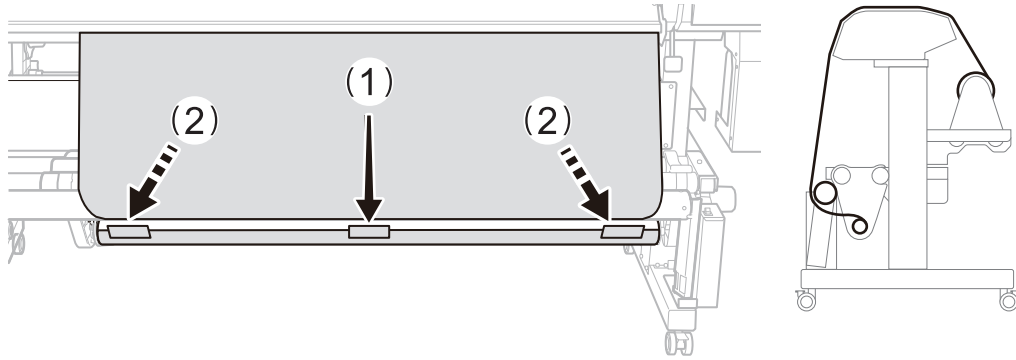
4. Follow the procedure below to secure the media on the paper tube.

Secure the media in the take-up direction set in step 3 of 1. [Set the take-up unit.](#)(P. 66).

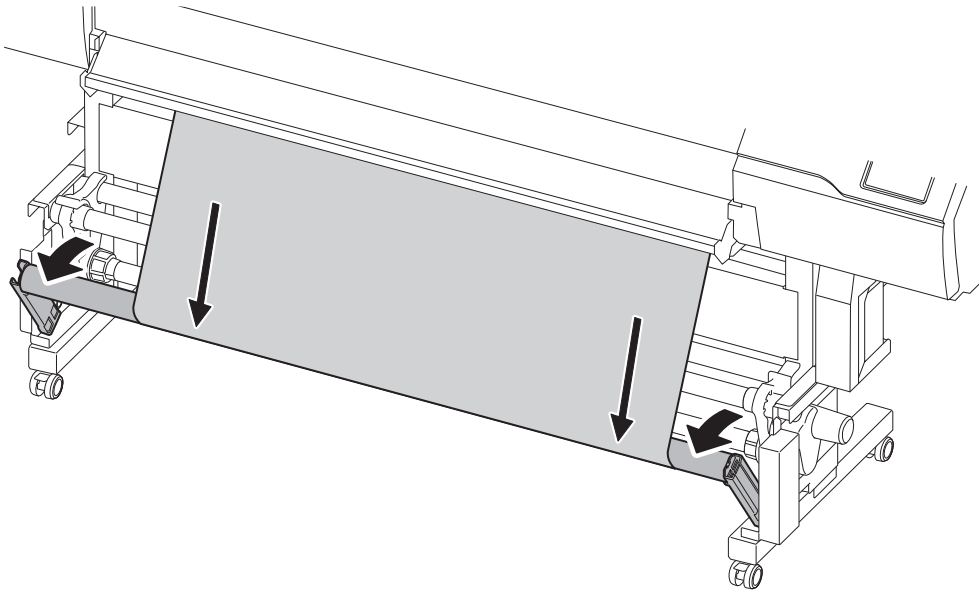
- (1) While pulling the media so that it does not sag, secure the center of the media on the paper tube with adhesive tape.
 - (2) While pulling the media from the center toward the outer edges, secure the left and right edges of the media on the paper tube with adhesive tape.
- When using the FORWARD 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].

IMPORTANT**Remove when not using roll media.**

Do not leave roll media loaded on the machine for a long period of time. Be sure to remove and store the media when not in use. Leaving the roll media loaded on the machine for a long period of time will cause the media to sag, which may deteriorate the printing quality and may also lead to motor errors.

This completes the setup.

Setup of Sheet Media

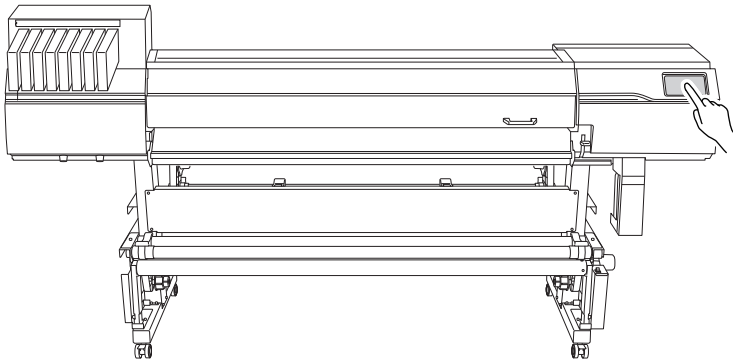
Load the sheet media on the printer. When the loading is finished, [Output possible.] is displayed as the status. This work is referred to as "Setup of Media."

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

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

Procedure

1. Tap the operation panel.



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

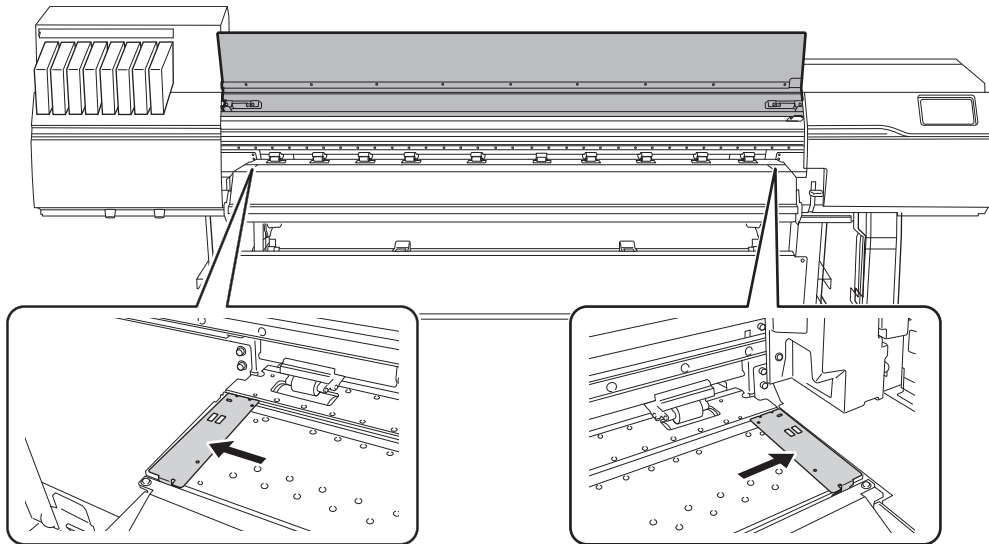
The power to the operation panel is switched on.

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

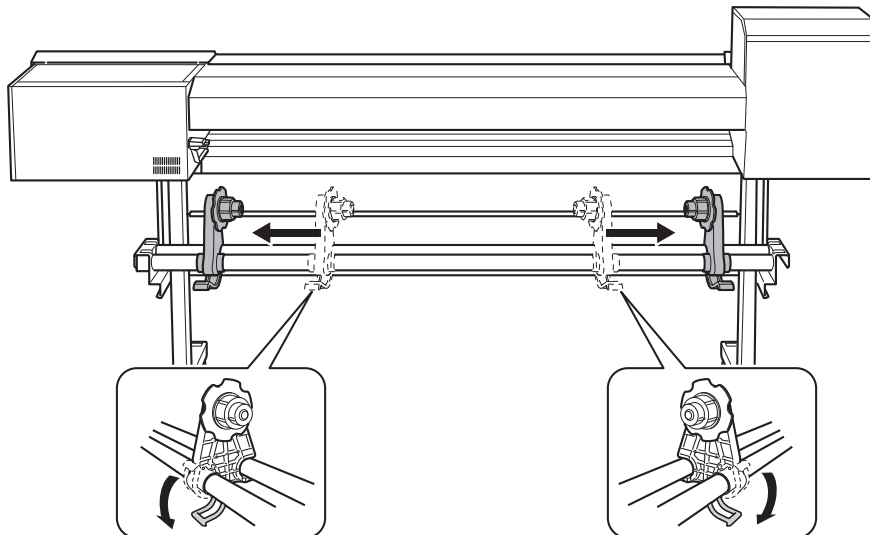
- (1) Tap .
- (2) Tap [Preferences]>[Skewing Correction Support at Setup].
- (3) Select [Enable] and tap [Save].
- (4) Press  to return to the original screen.

4. Open the front cover.

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



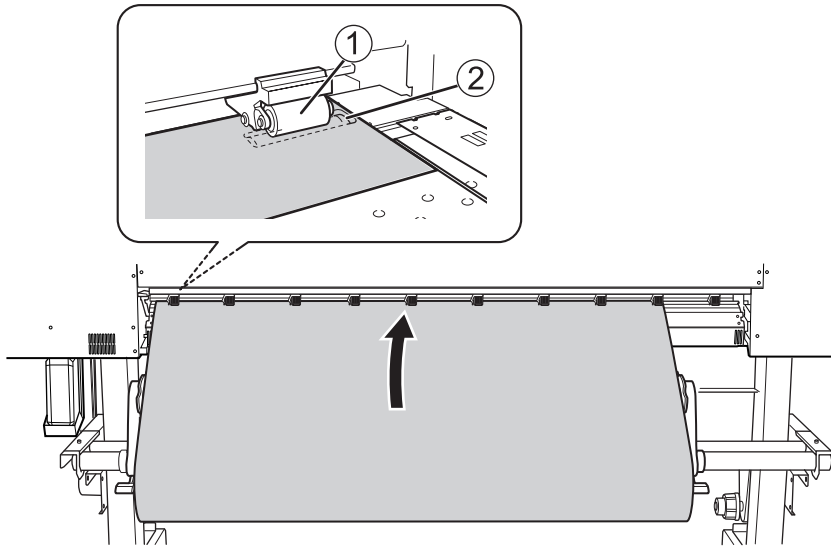
6. Move to the rear of the printer. Release the locking mechanisms of the media holders, and then draw them to the left and right ends respectively.



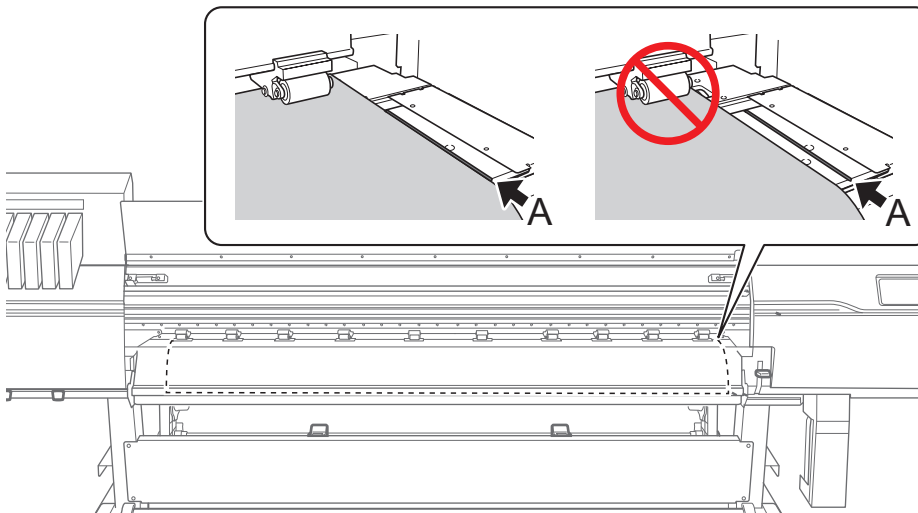
7. From the rear of the printer, pass the leading edge of the media between the pinch rollers (①) and the grit rollers (②).

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.

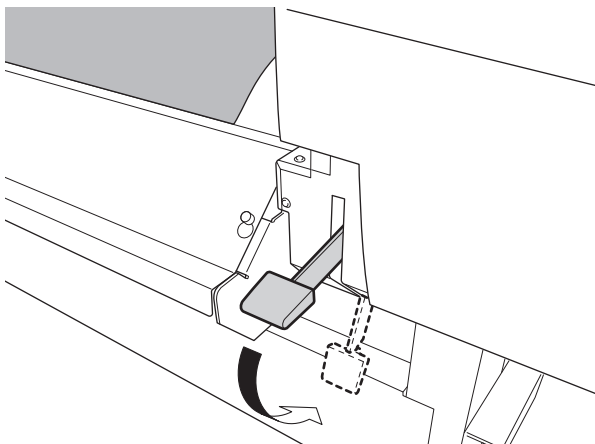
When loading the media from the front of the printer, feed the leading edge of the media (the side where printing will start) over the platen, and then pull the media to the front to activate the suction fan.



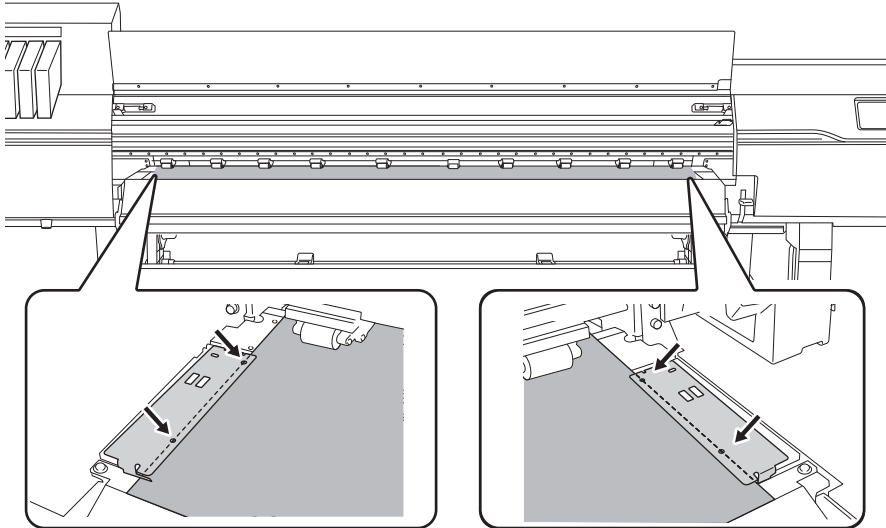
8. Make sure the right edge of the media is in line with the guide line (A).



9. Lower the loading lever (front).
The media is held in place.



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

**IMPORTANT**

Be sure to use the media clamps when you 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.

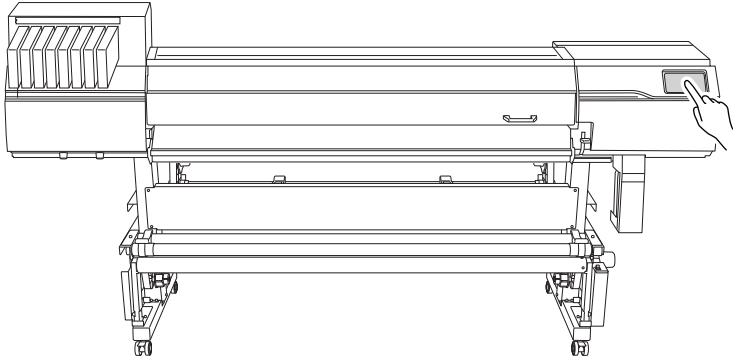
11. Close the front cover.

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

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

Procedure

1. Tap the operation panel.



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

The power to the operation panel is switched on.

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

(1) Tap .

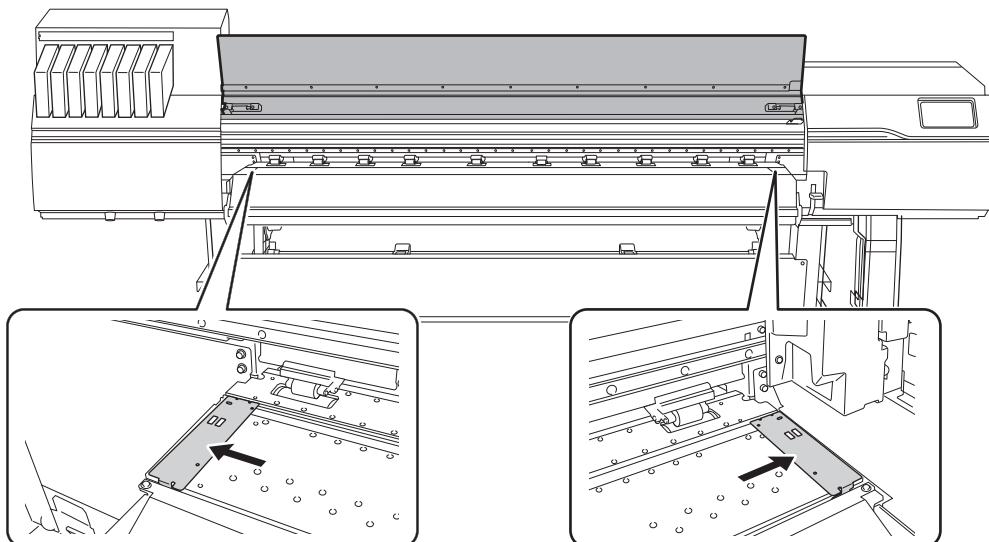
(2) Tap [Preferences]>[Skewing Correction Support at Setup].

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

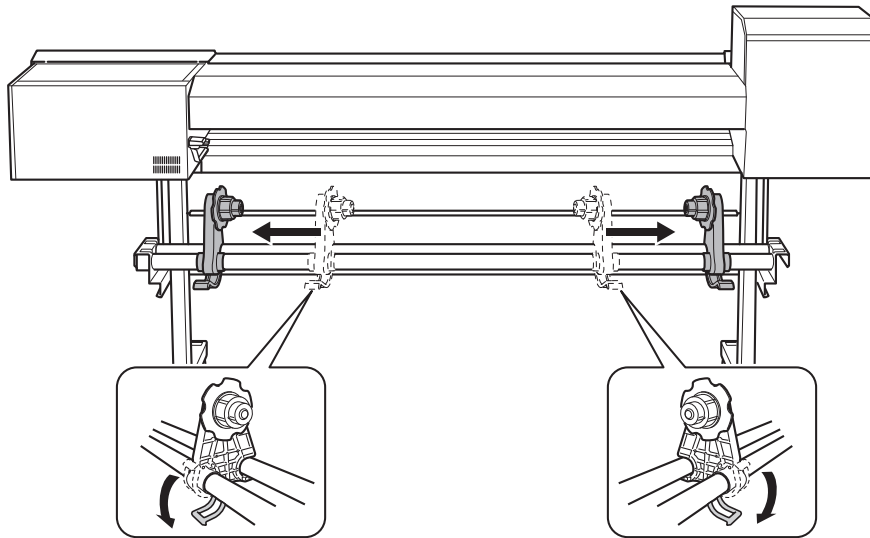
(4) Press  to return to the original screen.

4. Open the front cover.

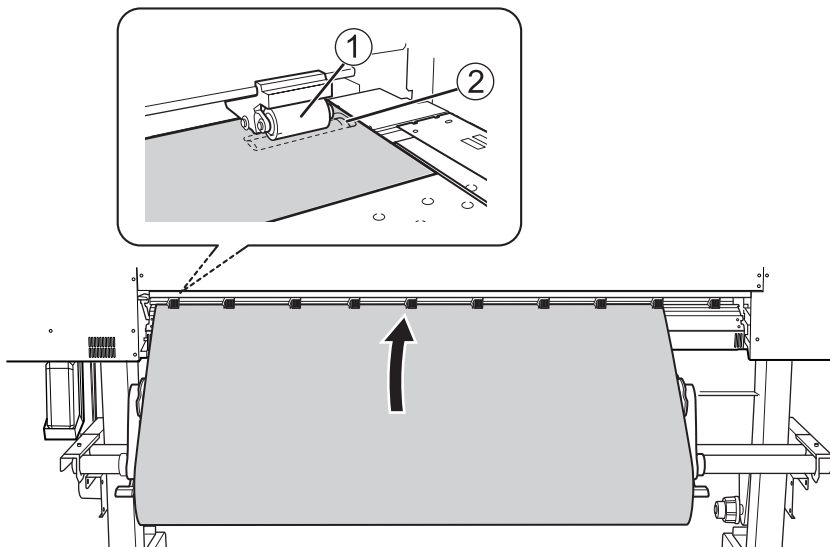
5. Move the media clamps to the outside of the grit rollers on the left and right edges respectively.



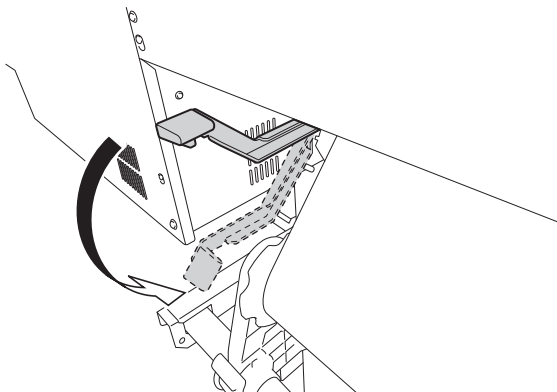
6. Move to the rear of the printer. Release the locking mechanisms of the media holders, and then draw them to the left and right ends respectively.



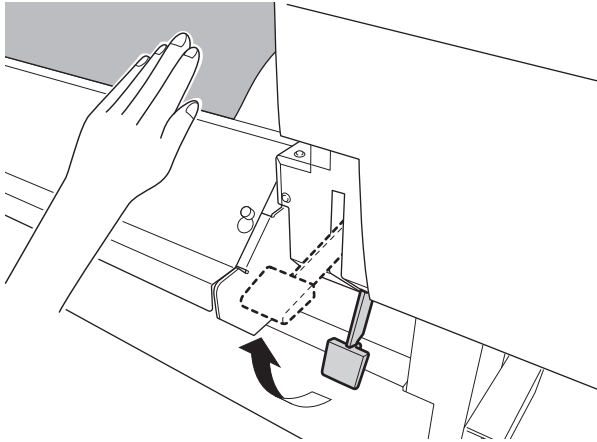
7. Pass the leading edge of the media between the pinch rollers (①) and the grit rollers (②).



8. Lower the loading lever (rear).
The media is held in place.

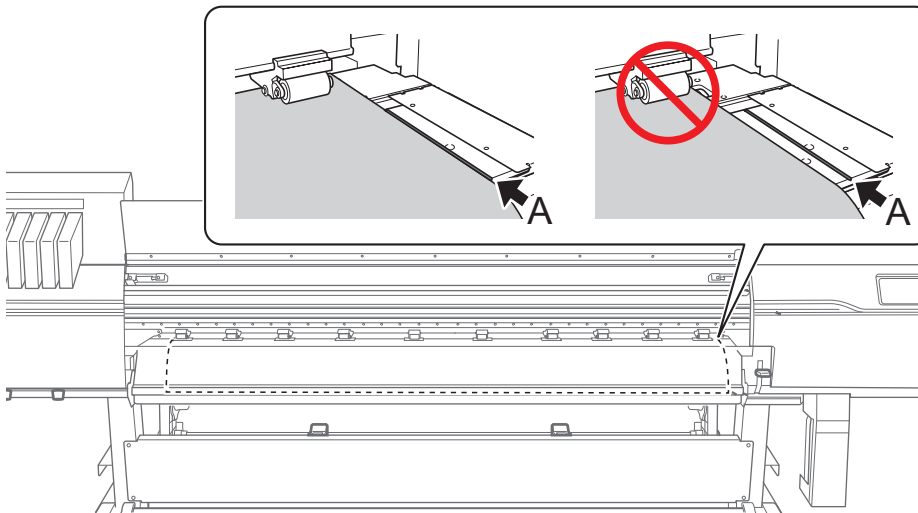


9. (Move to the front of the printer.) Gently hold down the media and raise the loading lever (front).

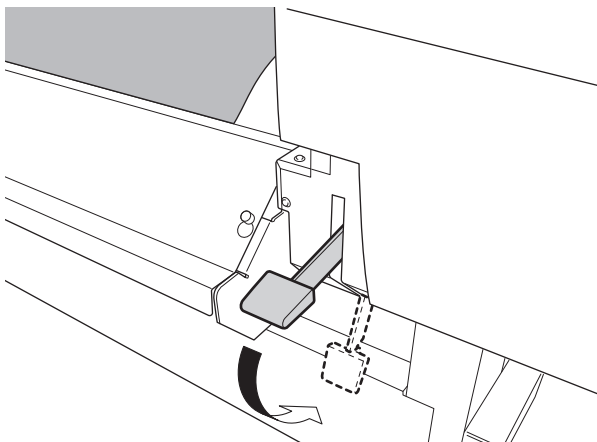


10. If an auxiliary drying unit (DU3) is installed, insert the leading edge of the media into the dryer.

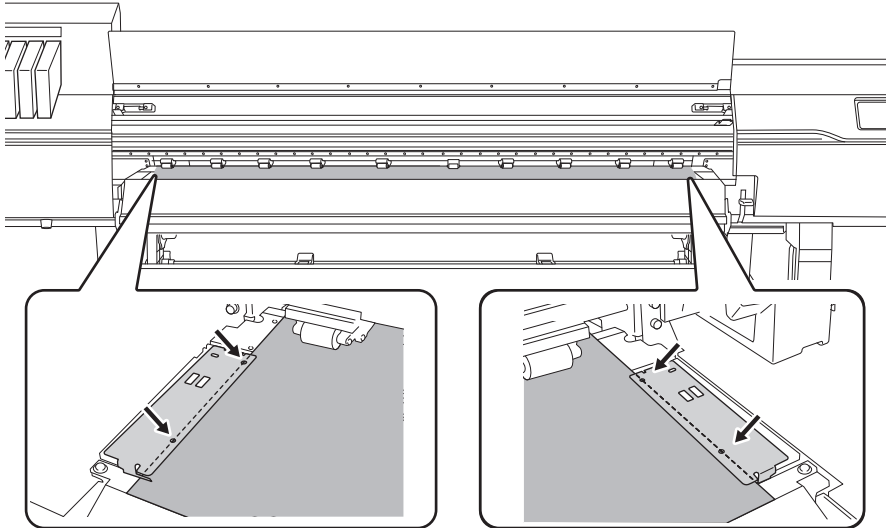
11. Make sure the right edge of the media is in line with the guide line (A).



12. Lower the loading lever (front).
The media is held in place.



13. 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.

14. Close the front cover.

2. Select the media.

Procedure

1. Tap  [Setup].

The registered media is displayed in a list.

2. Select the media name to use.

MEMO

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.

The procedure is as follows.

- **Searching for keywords in the media list**

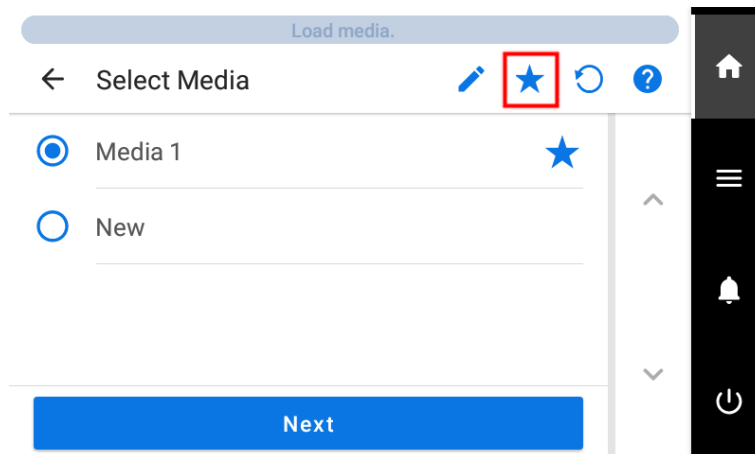
1. Tap .
2. Tap the input field.
You can use up to 15 alphanumeric characters.
Searching for partial matches instead of exact matches is also possible.
3. Enter the keyword to search for and tap [OK].

- **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 [Sheet Settings] screen appears. Configure the settings as shown below depending on the sheet type.
 - For opaque media
 - a. Tap [Side Margin] to set the margin.
You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
 - b. Tap [OK].
 - For transparent media, etc.
 - [Sheet Width] setting
 - a. Tap  to the right of [Sheet Width].
 - b. Enter the sheet width and tap [OK].
 - [Sheet Right Edge] setting
 - a. Tap [Change] to the right of [Sheet Right Edge].
 - b. Tap  or  to move the sub carriage's base point mark to the right edge of the media, and then tap [OK].
 - [Side Margin] setting
 - a. Tap [Side Margin] to set the margin.
You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
 - b. Tap [OK].
5. Tap [Next].
6. The [Setup Method] screen will appear. Select [Do Not Use Take-up Unit].
7. Tap [Start Setup].
This completes the setup.

Separating the Media

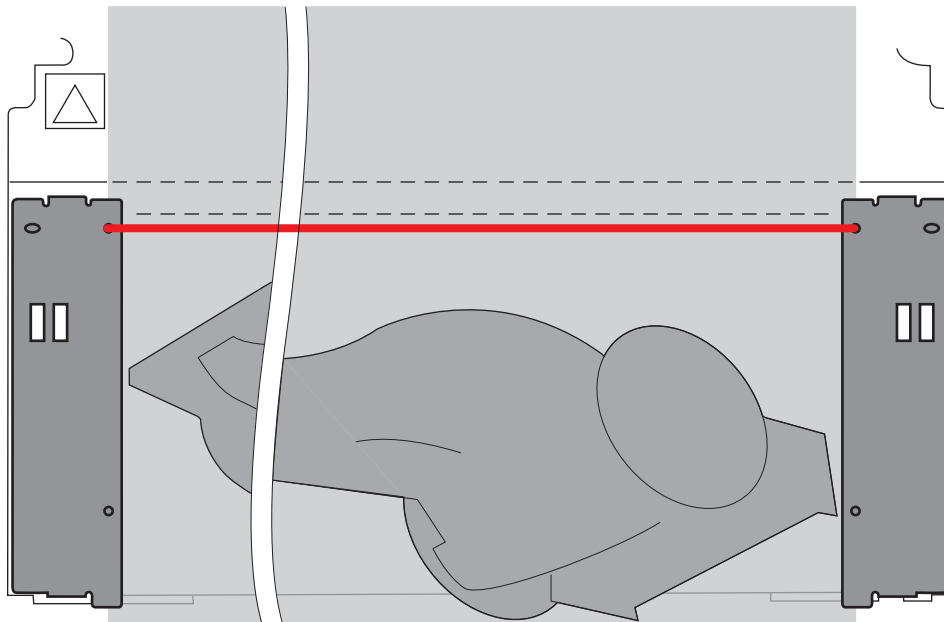
After printing, use sheet cutting or perforated sheet cutting to separate the media.

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 move the media to the separation position.

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



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

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

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

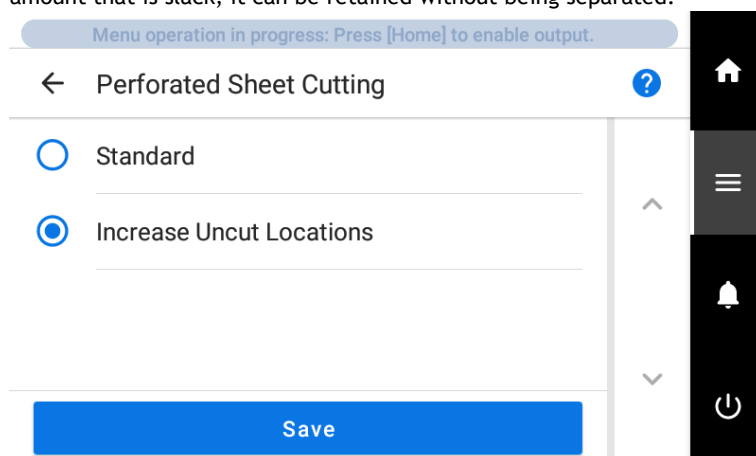
4. Select the sheet cutting method.

[Sheet Cutting]	This separates the media.
[Perforated Sheet Cutting]	The media is perforated without being separated.

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.

Menu operation in progress: Press [Home] to enable output.

**5. Tap [Execute].**

The media is separated. If **[Perforated Sheet Cutting]** was selected in step 4, the media is perforated.

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

IMPORTANT**Separation Operations**

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

When Using a Take-up Unit

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

Give Attention to the Media Composition

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

Removing Media from the Take-up Unit

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

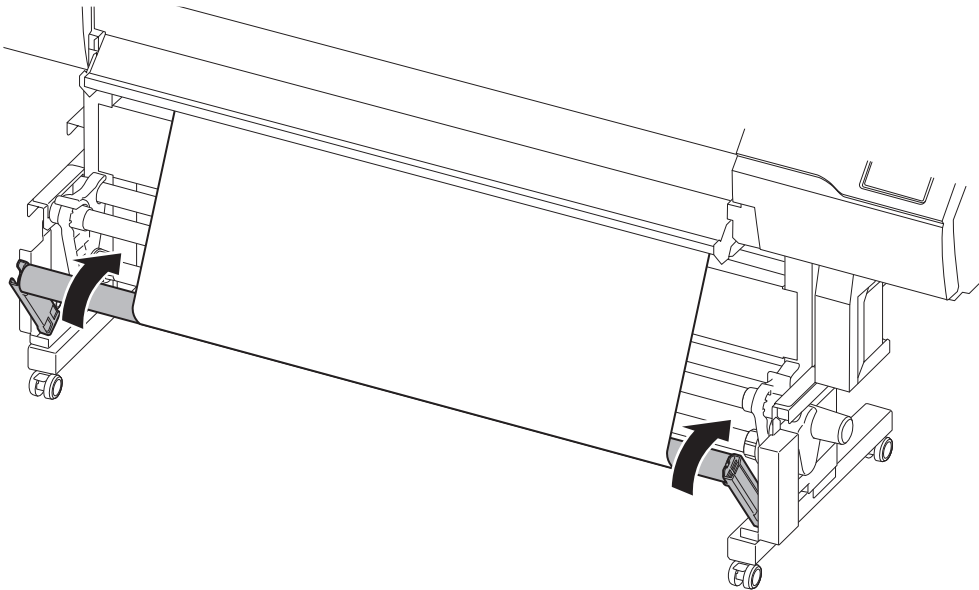
⚠ WARNING

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.

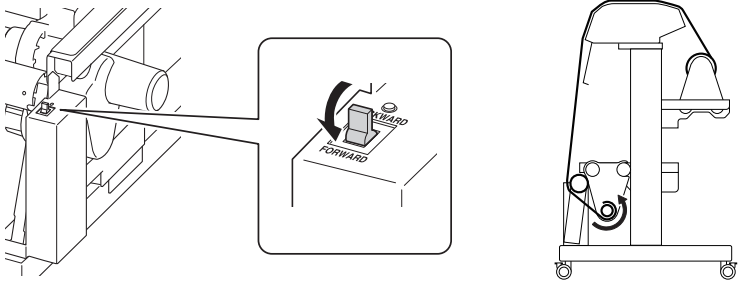
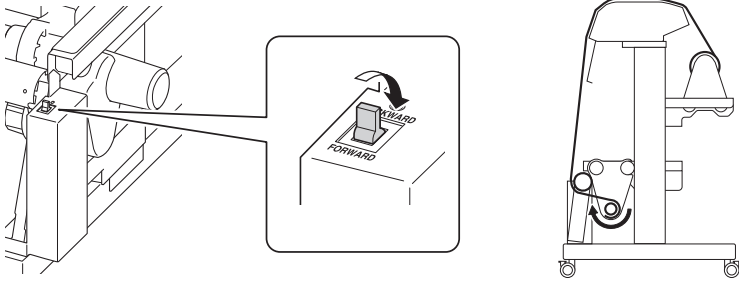
[P. 96 Separating the Media](#)

IMPORTANT

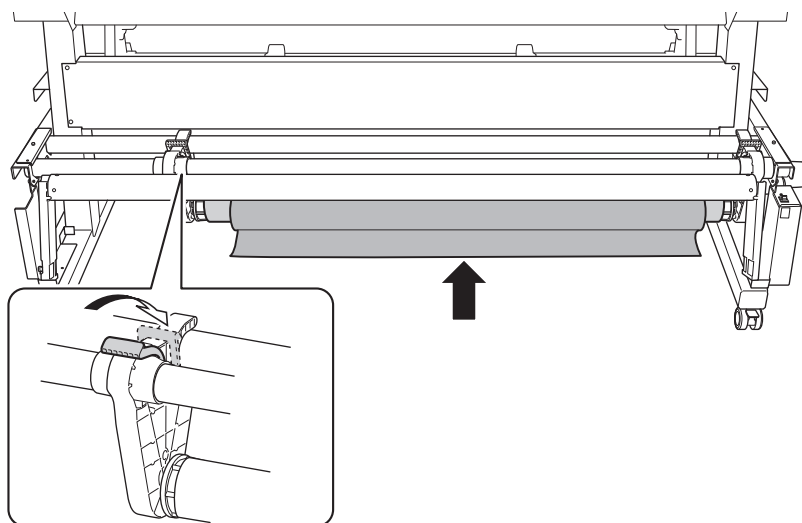
Give Attention to the Media Composition

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

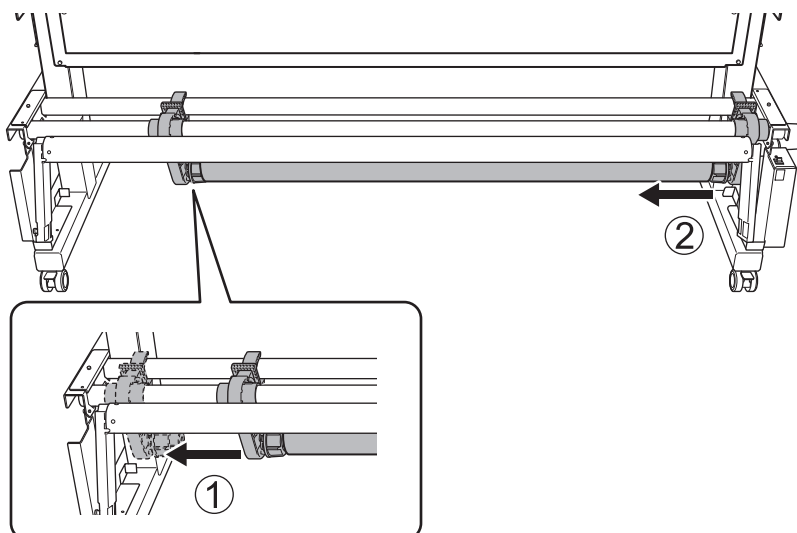
4. Use the MANUAL switch to take-up the media.

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.

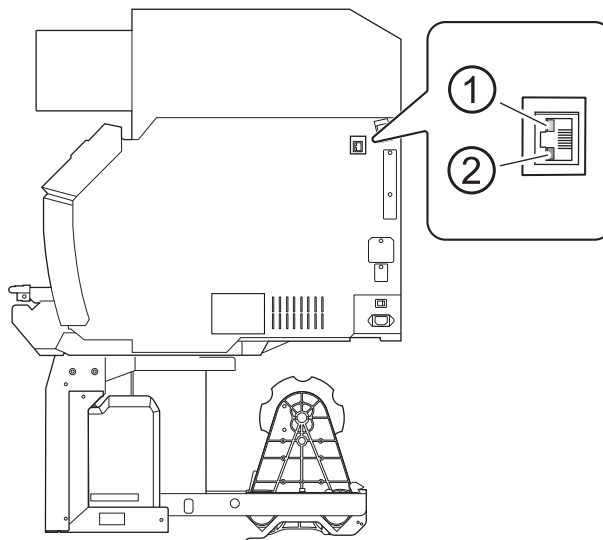


Checking before Output

LAN (Local Area Network) Settings

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

The LAN is enabled if the status LED (②) on the LAN connector located on the side of the printer is lit in green.



①	Activity LED	This flashes orange while data is being received from the network.
②	Status LED	This indicates the status of the communication function. When it lights in green, communication is possible.

Pausing and Canceling Output

You can pause and cancel output before it finishes.

Pausing and Resuming Output

IMPORTANT

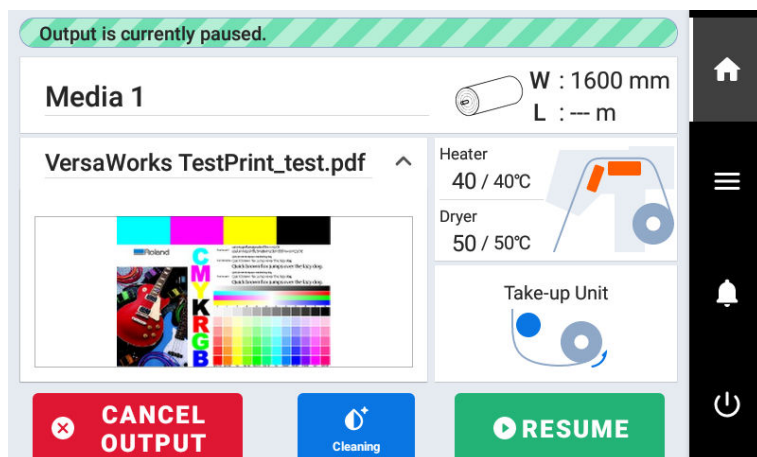
We do not recommend resuming printing because horizontal bands are produced at the place where printing was paused.

MEMO

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

Procedure

1. During output, tap [Pause].
This pauses the printing operation.
2. Tap [Resume].

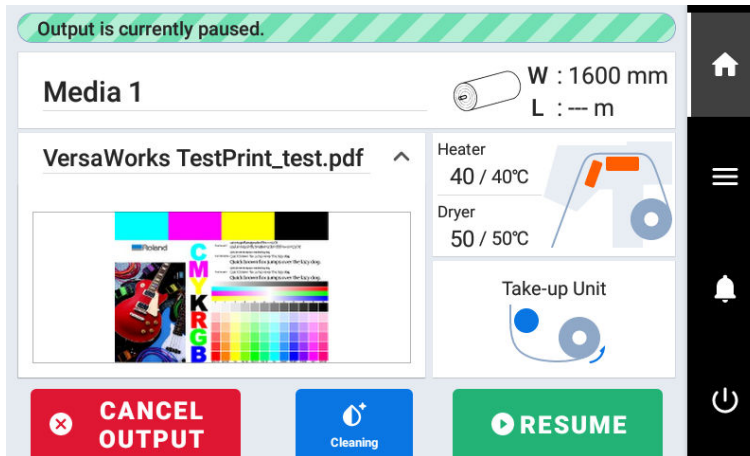


The printing operation resumes.

Canceling Output

Procedure

1. During output, tap [Pause].
This pauses the printing operation.
2. Tap [Cancel Output] when the following screen appears.



Output is canceled.

3. Stop sending the output data from the computer.

Replacing Ink Cartridges

Out-of-ink Warnings

If Using 4 Colors (CMYK)

- If two ink cartridges with the same color run out of ink: Printing pauses and a warning beep sounds. Refer to the screen display on the operation panel and the displays of the ink cartridge LEDs, pull out the empty cartridges, and insert new ones. Printing resumes.
- If one cartridge runs out of ink but there is still another cartridge with the same color: The operation panel screen continues displaying **[Printing output in progress.]**, and printing continues. Refer to the displays of the ink cartridge LEDs and pull out the empty cartridge.

If Using 8 Colors (CMYKLkReOrGr)

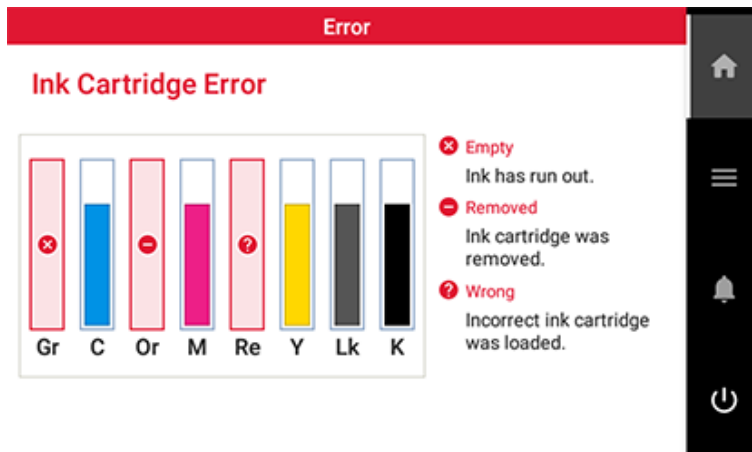
- When an ink pouch runs out, printing pauses and a warning beep sounds. Refer to the screen display on the operation panel and the displays of the ink cartridge LEDs, pull out the empty cartridges, and insert new ones. Printing resumes.

IMPORTANT

- See [Determining What Happens When Ink Runs Out\(P. 175\)](#) if you do not want printing to be paused.
- [Ink Empty Mode] is set to [Stop] by default. When changed to [Continue], printing will not be paused.
- If ink runs out during cleaning, cleaning is canceled.
- Never reuse an ink cartridge for which the machine shows a sign indicating no ink. Occasionally the machine will show a sign indicating no ink even if there is a small amount of ink remaining in the ink cartridge. Nevertheless, do not reuse the ink cartridge. Such an ink cartridge is in a state where drawing ink from it is impossible. Using it in such a state may force air into the ink path and cause printer malfunctions.

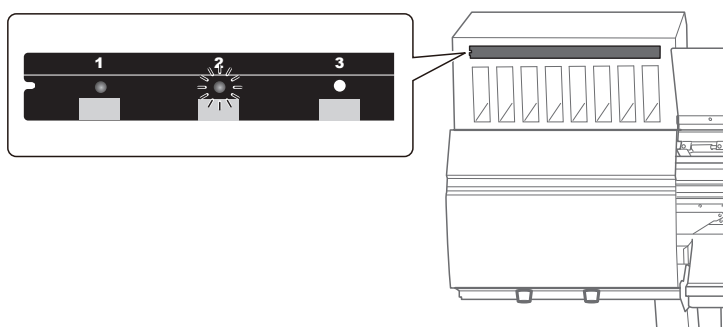
Operation panel screen display

[Ink Cartridge Error] is displayed, and [Empty] is displayed for ink that has run out.



Ink cartridge LED displays

The numbers of the color that has run out flash.

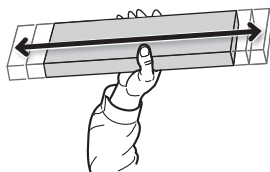


●	Lit	Indicates that the ink cartridge is currently in use.
☀	Flashing	Indicates that the ink cartridge is empty or no ink cartridge is inserted.
○	Off *1	Indicates that the ink cartridge is not currently in use.

*1 If using 4 colors (CMYK)

Preventing Sedimentation in Inks

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



Output Method

Preparations before Output

Step 1: Performing a Printing Test	108
Step 2: Performing Normal Cleaning.....	110

Step 1: Performing a Printing 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.

When performing horizontal printing, see [Performing Printing Tests Arranged Horizontally](#)(P. 169).

Procedure

1. Set up the media.

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

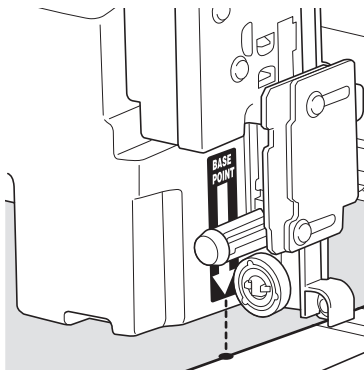
3. Tap next to **[Printing Test]>[Execute]**.

Printing of the test pattern starts.

MEMO

To change the start position for the printing test, configure the following settings.

1. Tap **[Output Start Location]>[Change]**.
2. Use the following operations to move the base point mark to the position you want to use to start output.
The base point mark on the right side is the start position.

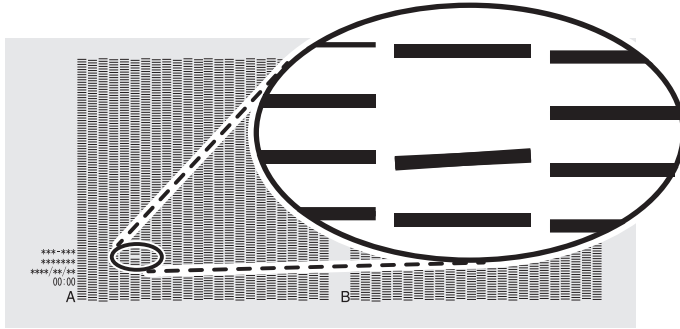


Use  or  to move the sub carriage in the scan direction (left and right). Use  or  to move the media in the feed direction (forward and backward).

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

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.



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

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

RELATED LINKS

- [P. 215 When Dot Drop-out or Dot Displacement Occurs](#)

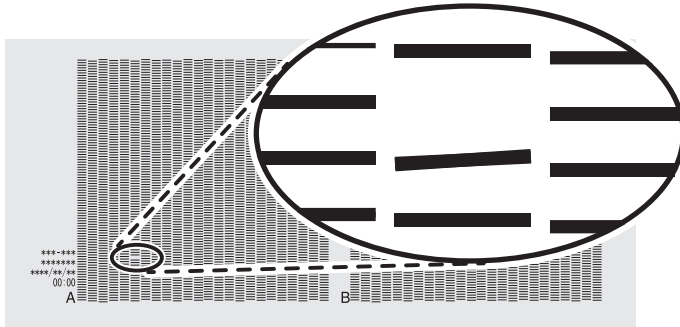
Step 2: Performing Normal Cleaning

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



MEMO

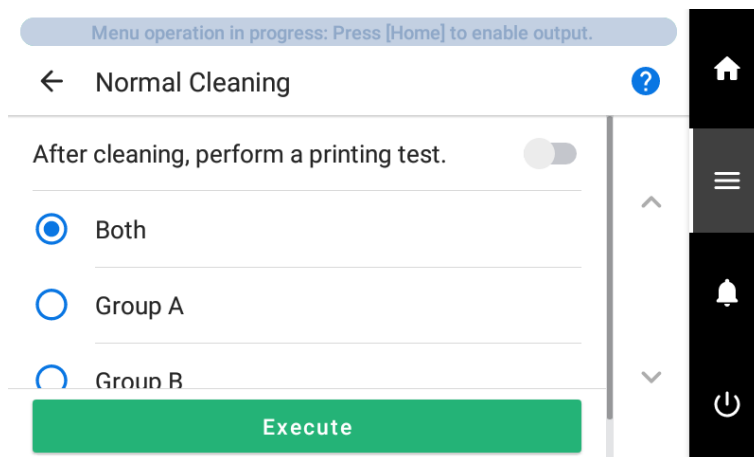
If the printing-test results are difficult to interpret

Check the results in a bright location, changing your line of vision. They are visible using the reflection of the light.

2. Tap [Cleaning].

3. Tap [Normal Cleaning].

The screen shown below appears.



4. Select the group of print heads to clean.

5. 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.

6. Tap .

7. Tap [Printing Test].

8. Tap [Nozzle Drop-out Test]>[Execute].

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

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

RELATED LINKS

- [P. 194 Performing a Printing Test](#)
- [P. 217 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.

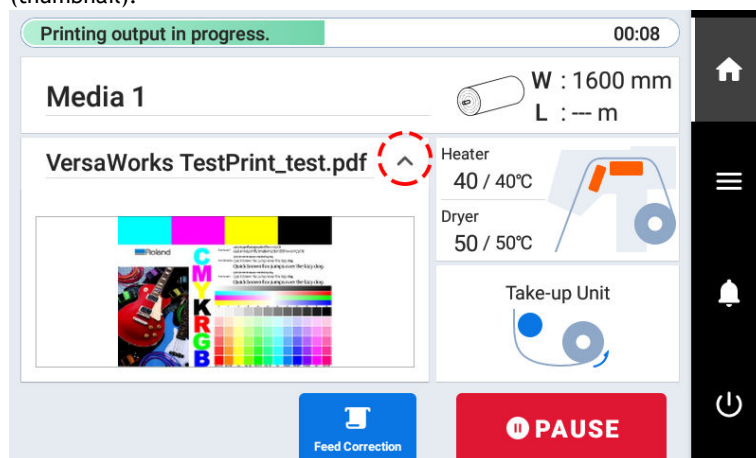
Procedure

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

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

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 this icon again to return to the screen for checking the data being output. However, this functionality is limited to software RIPs that support 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, or right) 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

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

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

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

RELATED LINKS

- [P. 132 Setting the Print Heater Temperature](#)
- [P. 134 Setting the Dryer Temperature](#)

Optimizing Quality and Efficiency

Optimizing the Output Quality

Using the Correction Functions.....	116
Automatically Making Required Adjustments	116
Manual Adjustment: Reducing Horizontal Bands (Feed Correction)	117
Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)	120
Configuring Settings to Match the Properties of the Media	122
Changing the Print Head Height	122
Using Hard-to-Dry Media	124
Using Media That Wrinkles Easily/Does Not Move Smoothly	125
Using Sticky Media	126
Preventing Ink Discharge Issues	127
Preventing Soiling of the Media, Dot Drop-out, and Dot Displacement	127
Take-up Unit Settings	128
Setting the Take-up Unit	128
Adjusting the Ink-drying Method	130
What Is the Media Heating System?	130
Setting the Print Heater Temperature	132
Setting the Dryer Temperature.....	134
Hints and Tips for Temperature Control	136
Setting the Temperature during Standby	137
Drying the Trailing Edge of the Printing Area on the Dryer	138
Using an Auxiliary Drying Unit (DU3)	139
Accurately Adjusting Media Reading.....	140
Correcting the Reading Sensor	140

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.

Make sure the printing area required for the printing test is at least 290 mm (11.42 in.) wide before performing the printing test.

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

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

Procedure

1. 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 original screen.
- If [Failed] is displayed on the operation panel, carry out manual adjustment.

RELATED LINKS

- [P. 117 Manual Adjustment: Reducing Horizontal Bands \(Feed Correction\)](#)
- [P. 120 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.

Manual adjustment can be performed either while output is stopped or while output is in progress. The procedure is as follows.

Performing Feed Correction before Output

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

Make sure the printing area required for the printing test is at least 375 mm (14.77 in.) wide before performing the printing test.

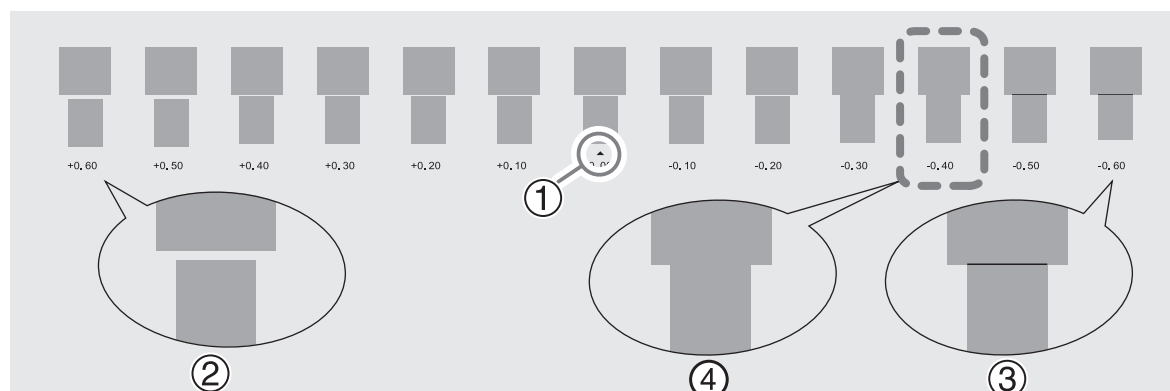
Procedure

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 [Printing Test]>[Execute].

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  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 **[Printing Test]>[Execute]**.

The test pattern is printed again.

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

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

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

Performing Feed Correction during Output

Feed correction may result in reduced print quality, depending on when it is performed. Perform this operation at the appropriate timing.

Procedure

1. Tap [Feed Correction].



2. Check the printed surface. If noticeable overlapping is present, tap  to change the correction value.

If noticeable gaps are present, tap .

3. Tap [Save].
The entered correction value will be applied to printing.

4. Tap  to go back to the original screen.

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

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

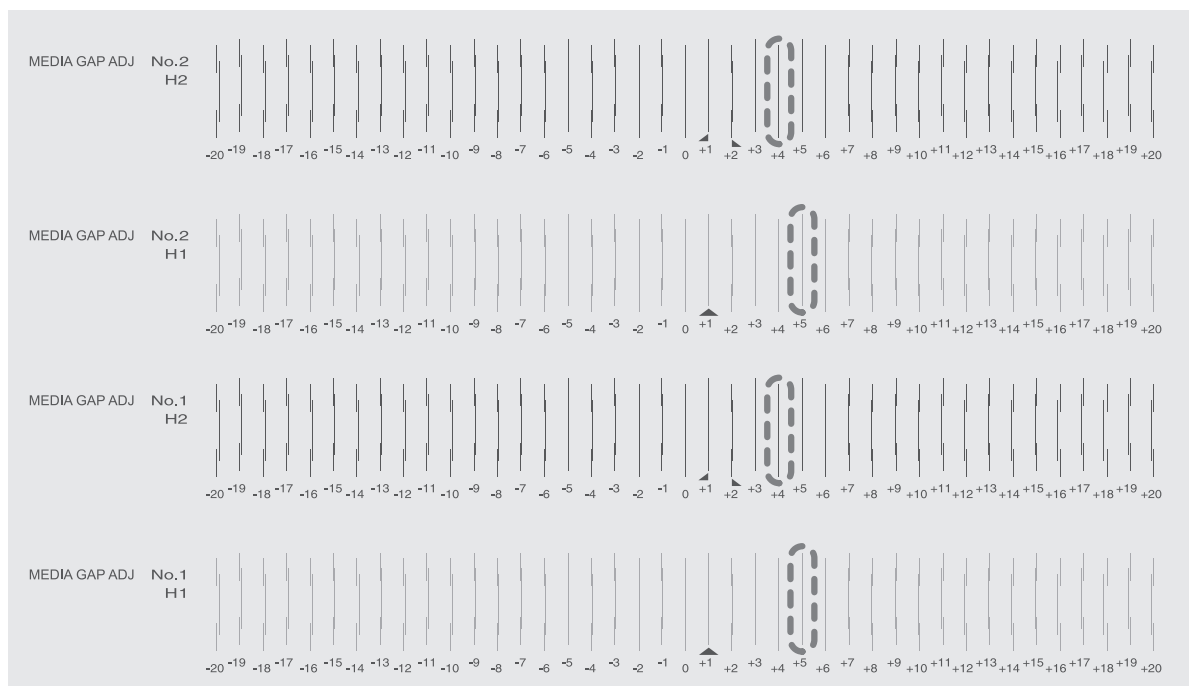
First, print a test pattern, and then determine and enter the correction value. After entering the correction value, print a test pattern again and check the correction results.

This adjustment must be performed in the following cases.

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

Procedure

1. 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 [Printing Test]>[Execute].
Printing of the test pattern starts.
7. Check the printed test pattern, and then tap  or  to change the H1 and H2 correction values for No. 1 and the H1 and H2 correction values for No. 2.
Select the value that gives the least misalignment between the two lines. In the case of the following figure, select "+5" for H1 for No. 1 and No. 2 and "+4" for H2 for 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  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 [Printing Test]>[Execute].

The test pattern is printed again.

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

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

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

Configuring Settings to Match the Properties of the Media

Changing the Print Head Height

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

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

Procedure

1. Set up the media.

2. Tap .

3. Tap [Media Settings]>[Printing Settings]>[Print Head Height].

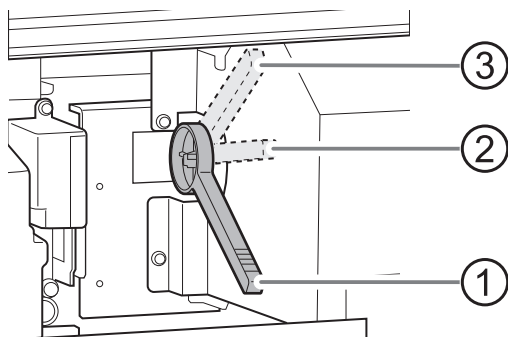
4. Tap [Change].

The print heads move to a position where they can be operated.

5. Open the front cover.

6. Move the height-adjustment lever to adjust the head height.

When you change the position of the height-adjustment lever, the display screen changes and the buzzer sounds at the same time.



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

IMPORTANT

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

7. Close the front cover.

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

9. Tap  to go back to the original screen.

MEMO

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

RELATED LINKS

- [P. 116 Automatically Making Required Adjustments](#)
- [P. 120 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position \(Media Gap Adjustment\)](#)
- [P. 215 When Dot Drop-out or Dot Displacement Occurs](#)

Using Hard-to-Dry Media

This setting is used to extend the drying time when the ink dries poorly even if the dryer is used.

Procedure

1. Set up the media.
2. Tap .
3. Tap [Media Settings]>[Other Media Settings]>[Drying Time Per Scan].
4. Tap  or  to change the value.
Larger values cause the media to move more slowly, extending the drying time accordingly.
5. Tap [Save] to confirm your entry.
6. Tap  to go back to the original screen.

MEMO

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

RELATED LINKS

- [P. 130 Adjusting the Ink-drying Method](#)

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 go back to the original screen.

MEMO

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

Using Sticky Media

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

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

Procedure

1. 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 go back to the original screen.

MEMO

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

Preventing Ink Discharge Issues

Preventing Soiling of the Media, Dot Drop-out, and Dot Displacement

Removing the ink buildup on the print head surface before or during printing prevents soiling of the media, dot drop-out, and dot displacement.

In the following cases, ink tends to collect on the surface of the print heads.

- When you use media prone to static electricity buildup.
- When the ambient temperature is low.
- When the print-head height is set to [High].

Procedure

1. Tap .

2. Tap [Preferences]>[Cleaning during Printing].

3. Tap a setting to select it.

If you select [Periodically (Job Priority)] or [Periodically (Time Priority)], set the time and tap [OK].

[No Cleaning]	Automatic cleaning is not performed.
[Every Page]	Automatic cleaning is performed each time prior to the start of printing.
[Periodically (Job Priority)]	Automatic cleaning is performed when the cumulative printing time reaches the value you set here. However, if this time is reached during printing, automatic cleaning is performed before the next printing operation starts. Because printing is not paused, uneven color issues due to paused operation do not occur.
[Periodically (Time Priority)]	Automatic cleaning is performed when the cumulative printing time reaches the value you set here. When this time is reached during printing, printing pauses and so colors may be uneven.

4. Tap [Save] to confirm your entry.

5. Tap  to go back to the original screen.

MEMO

- Default setting: [No Cleaning]
- Settings other than [No Cleaning] result in longer printing times.

Take-up Unit Settings

Setting the Take-up Unit

Make sure the following settings match the loading method and output method of the actual media.
The settings will have to be changed from the defaults when:

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

Procedure

1. Tap  on the operation panel.

The sub power is switched on.

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

- (1) Tap .

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

- (3) Select [Loose Winding] or [Tension Winding].

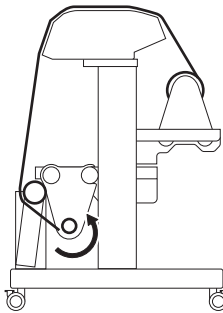
[Loose Winding]	The media is taken up with some slack. This is suited to PVC and other such stiff or slippery media.
[Tension Winding]	The media is stretched and taken up. This is suited to tarpaulin and other such weak media and media that does not slip easily.

MEMO

- Default setting: [Loose Winding]

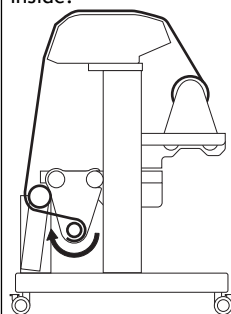
- (4) Tap [Preferences]>[Take-up]>[Take-up Direction].

- (5) Select [Backward] or [Forward].

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

[Backward]

The media is taken up onto the paper tube with the printed surface on the inside.



MEMO

- Default setting: [Forward]

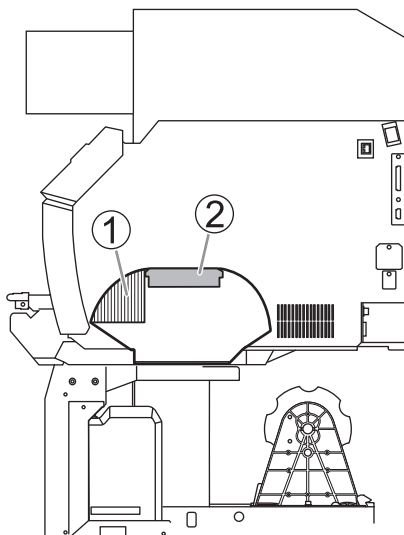
(6) Tap [Save].

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

Adjusting the Ink-drying Method

What Is the Media Heating System?

This machine is equipped with a media heating system that warms the media. You use this mainly to improve ink adhesion and dry the ink. You can adjust the temperature settings to match the type of media and the printing speed.



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

⚠ WARNING

High Temperature

The platen and dryer become hot. Exercise caution to avoid burns.

IMPORTANT

⚠ 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 platen or dryer for any purpose for which they are not intended, such as to dry clothing.

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

IMPORTANT

Use the machine in an environment with an ambient temperature of 20 to 32°C (68 to 89.6°F).

If the machine is used at an ambient temperature lower than 20°C (68°F), then depending on the type or width of the media, wrinkling or temperature-caused unevenness may occur. If this happens, try lowering the temperature of the media heating system by about 2°C. To obtain stable printing results, however, use the machine in an environment with an ambient temperature of 20 to 32°C (68 to 89.6°F).

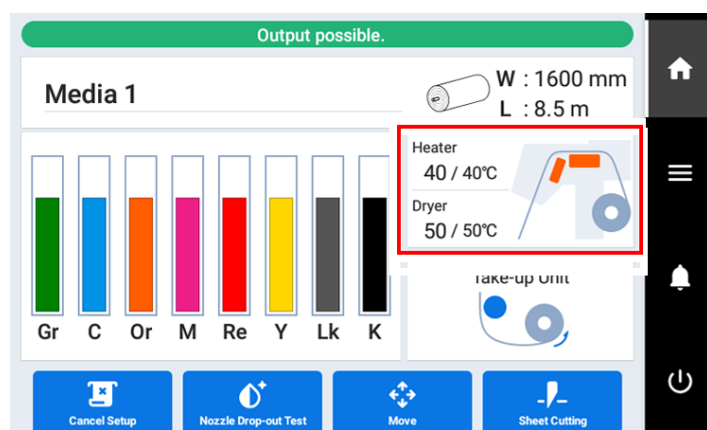
Setting the Print Heater Temperature

Setting the temperature of the print heater appropriately improves ink adhesion and inhibits smudging. An applicable application is changing the set temperature of registered media.

- With the default settings, the temperature rises to the [Standby Heater Temperature] when the power turns on. On completion of media setup, the temperature rises to the set value.
- Depending on the usage environment, the temperature of the dryer may become higher than the set temperature, but this does not represent a problem.
- Temperature settings are not possible when [Heater Power] accessed from [Media Settings]>[Heater Settings]>[Heater Temperature] is off.

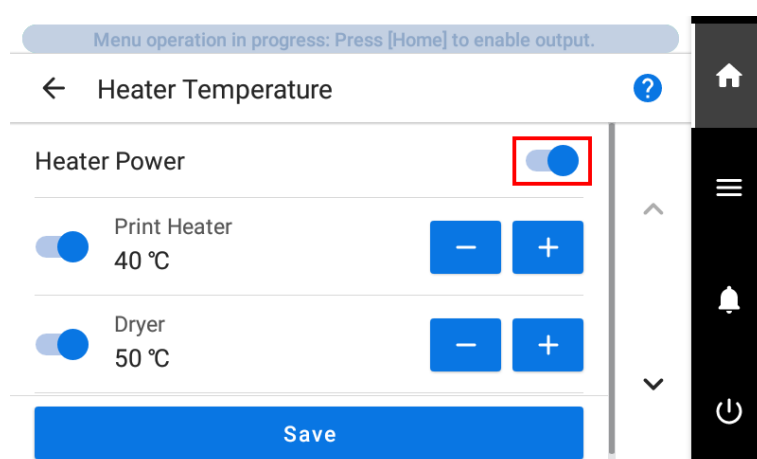
Procedure

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



The [Heater Temperature] screen appears.

3. Check that the [Heater Power] check box is selected.



4. Tap  or  to set the [Print Heater] temperature.

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

5. Tap [Save] to confirm your entry.

6. Tap  to go back to the original screen.

MEMO

- Default setting: 40°C (104°F)
- You can also make this setting in the software RIP. When you have made the setting in the software RIP, the software RIP's setting is used.

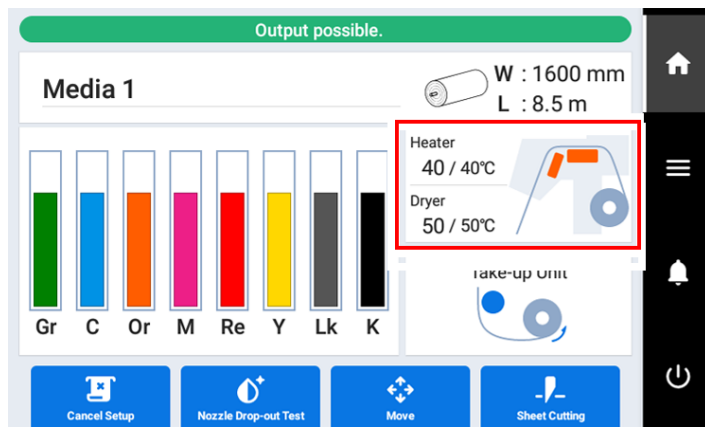
Setting the Dryer Temperature

Setting the temperature of the dryer appropriately makes the ink dry fast. An applicable application is changing the set temperature of registered media.

- With the default settings, the temperature rises to the [Standby Heater Temperature] when the power turns on. On completion of media setup, the temperature rises to the set value.
- Depending on the usage environment, the temperature of the dryer may become higher than the set temperature, but this does not represent a problem.
- Temperature settings are not possible when [Heater Power] accessed from [Media Settings]>[Heater Settings]>[Heater Temperature] is off.

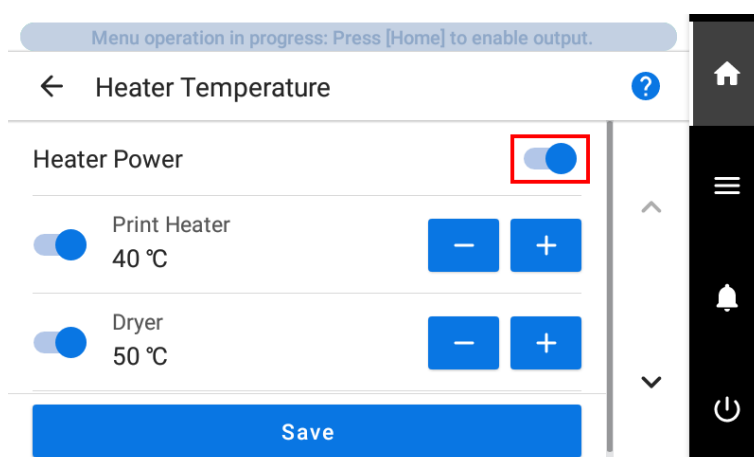
Procedure

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



The [Heater Temperature] screen appears.

3. Check that the [Heater Power] check box is selected.



4. Tap  or  to set the [Dryer] temperature.

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

5. Tap [Save] to confirm your entry.

6. Tap  to go back to the original screen.

MEMO

- Default setting: 50°C (122°F)
- You can also make this setting in the software RIP. When you have made the setting in the software RIP, the software RIP's setting is used.

Hints and Tips for Temperature Control

The optimal temperature for the media heating system varies according to such factors as the type of media and the settings of the software RIP.

Relationship between the quality settings of the software RIP and temperature

If smudging or poor drying occur even after raising the temperature, try setting the printing quality of the software RIP to higher image quality. Conversely, if you want to use a faster print quality, raise the temperature.

Amount of ink

When you change the amount of ink using the settings for your software RIP, adjusting this may yield better results. If problems such as smudging persist even after raising the temperature, try reducing the amount of ink.

Other points to remember

When recommended settings for temperature, printing quality, and other values are given for your media, use the suggested settings.

Setting the Temperature during Standby

Preheating: State in which the main power and the sub power are switched on and [SETUP] is not lit (state in which the media setup is not completed).

Procedure

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

3. Tap  or  to set the temperature.

When this is set to  (off), the media heating system is switched off during standby.

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

MEMO

- Default setting: 30°C

Drying the Trailing Edge of the Printing Area on the Dryer

To dry the ink thoroughly, configure the settings so that the media is fed until the trailing edge of the printed area is put on the dryer after the printing is finished.

Procedure

- 1. Set up the media.
- 2. Tap .
- 3. Tap [Media Settings]>[Heater Settings]>[Dry After Printing].
- 4. Tap  to turn it on.

[Drying Feed]	This setting applies to output data designed only for printing. The margin between the print-end position and the next print-start position is set to a value of 130 mm (5.12 in.) when [Extended Dryer] is set to [Disable] and 310 mm (12.2 in.) when it is set to [Enable].
 (On)	Media feed is performed until the trailing edge of the printing area is positioned on the dryer.
 (Off)	Media feed stops when printing ends. This means that the trailing edge of the printing area is not fed to the dryer unless you continue with a subsequent printing operation.

- 5. Tap  or  to set the [Drying Feed] drying time.

MEMO

Drying Time

- The next operation is not started until the set time elapses.
- Tap [Skip] during drying to finish the drying time and start the next operation.
- When the drying time has been set in the software RIP, priority is given to the software RIP's setting.
- If [Drying Time] is set to a value other than [0 min] and [Drying Feed] is off, the machine waits for the set time at the print-end position before starting the next operation.

- 6. Tap [Save] to confirm your entry.
- 7. Tap  to go back to the original screen.

MEMO

Default setting:

- [Drying Feed]: Off
- [Drying Time]: [0 min.]

Using an Auxiliary Drying Unit (DU3)

This setting is required when using an auxiliary drying unit (DU3). When [Extended Dryer] is set to [Enable], the temperature is set to the same temperature as the printer's dryer. When [Blower Fan] is set to [Enable], the blower fan turns during printing.

Procedure

1. Set up the media.
2. Tap .
3. When using [Extended Dryer], configure the settings as shown below.
 - (1) Tap [Preferences]>[Extended Dryer].
 - (2) Select [Enable].
 - (3) Tap [Save] to confirm your entry.
4. When using [Blower Fan], configure the settings as shown below.
 - (1) Tap  to go back to the original screen.
 - (2) Tap [Blower Fan].
 - (3) Select [Enable].
 - (4) Tap [Save] to confirm your entry.
5. Tap  to go back to the original screen.

MEMO

- Default settings
 - [Extended Dryer]:[Disable]
 - [Blower Fan]:[Disable]
- For information about the DU3, contact your authorized dealer or visit our website (<https://www.ro-landdg.com>).
- For details on how to use the DU3, refer to its documentation.

RELATED LINKS

- [DU-3 User's Manual](#)

Accurately Adjusting Media Reading

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 the correction.

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 the correction.
The media being used cannot be recognized.	Change the media type.
There is ink on the multi sensor because, for example, the media strikes it immediately after printing.	Contact your authorized dealer.

6. Tap  to go back to the original screen.

Optimizing Work Efficiency

Batch Settings for Printing	142
Step 1: Configuring [Batch Media Settings]	142
Step 2: Setting the Heater Temperature.....	143
Step 3: Changing the Print Head Height	144
Step 4: Setting the Media Suction Force	146
Step 5: Configuring Media Sticking Prevention Settings	147
Step 6: Adjusting the Output-start Location	148
Step 7: Performing a Printing Test	149
Step 8: Performing Feed Correction (Reducing Horizontal Stripes)	151
Step 9: Adjusting the Misalignment of the Ink Landing Position	153
Step 10: Configuring the Settings to Dry the Trailing Edge of the Printing Area	155
Step 11: Setting the Ink Drying Time	156
Step 12: Correcting the Reading Sensor	157
Step 13: Setting the Printing Movement Range	158
Managing the Media Settings.....	159
Changing the Media Settings	159
Checking the Registered Media Settings	160
Changing the Media Name	161
Duplicating Media Settings.....	162
Deleting Media Settings	163
Adjusting the Output-start Location.....	164
Setting the Base Point	164
Reducing Output Time	166
Speeding Up Output for Narrow Media.....	166
Printing with Crop Marks	167
Other Useful Functions	168
Using the Print Light (Interior Light)	168
Performing Printing Tests Arranged Horizontally	169

Batch Settings for Printing

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.

Step 1: Configuring **[Batch Media Settings]**

Procedure

1. Set up the media.
2. Tap .
3. Tap **[Media Settings]>[Batch Media Settings]**.

Step 2: Setting the Heater Temperature

The print heater and dryer temperatures can be set as needed.

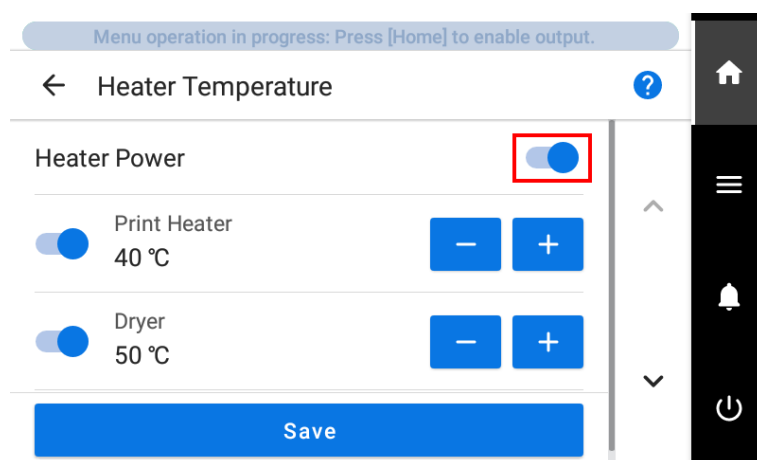
Setting the temperature of the print heater appropriately improves ink adhesion and inhibits smudging.

Setting the temperature of the dryer appropriately also makes the ink dry fast.

- With the default settings, the temperature rises to the **[Standby Heater Temperature]** when the power turns on. On completion of media setup, the temperature rises to the set value.
- Depending on the usage environment, the temperature of the dryer may become higher than the set temperature, but this does not represent a problem.

Procedure

1. Check that the **[Heater Power]** check box is selected.



2. Tap **—** or **+** to set the **[Print Heater]** or **[Dryer]** temperature.

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

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

MEMO

- Default setting:
 - **[Print Heater]**: 40 °C (104 °F)
 - **[Dryer]**: 50 °C (122 °F)
- You can also make this setting in the software RIP. When you have made the setting in the software RIP, the software RIP's setting is used.

Step 3: 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

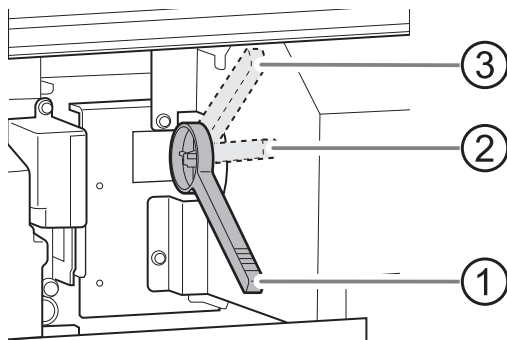
1. Tap [Change].

The print heads move to a position where they can be operated.

2. Open the front cover.

3. Move the height-adjustment lever to adjust the head height.

When you change the position of the height-adjustment lever, the display screen changes and the buzzer sounds at the same time.



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

IMPORTANT

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

4. Close the front cover.

5. Tap [OK].

The print head carriage moves to their original position.

6. Tap [Next].

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.

Step 4: Setting the Media Suction Force

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. 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].

MEMO

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

Step 5: Configuring Media Sticking Prevention Settings

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. Select **[Enable]**.
2. Tap **[Save and Proceed]**.

MEMO

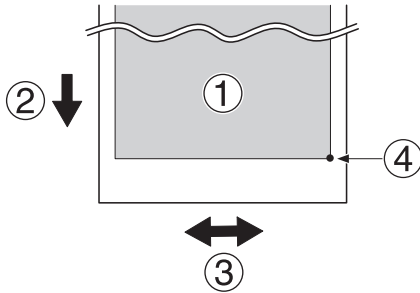
- Default setting: **[Disable]**
- Depending on the software RIP you are using, you can also make this setting in the software RIP. When you have made the setting in the software RIP, the machine's setting is ignored.

Step 6: Adjusting the Output-start Location

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

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

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

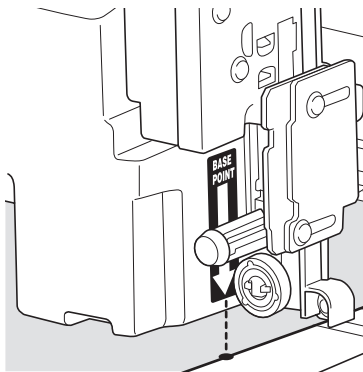


MEMO

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

Procedure

1. Tap [Output Start Location]>[Change].
The movement screen appears.
2. Use the following operations to move the base point mark to the position you want to use to start output.
The base point mark on the right side is the start position.



Use  or  to move the sub carriage in the scan direction (left and right). Use  or  to move the media in the feed direction (forward and backward).

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

Step 7: Performing a Printing Test

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

MEMO

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

[P. 169 Performing Printing Tests Arranged Horizontally](#)

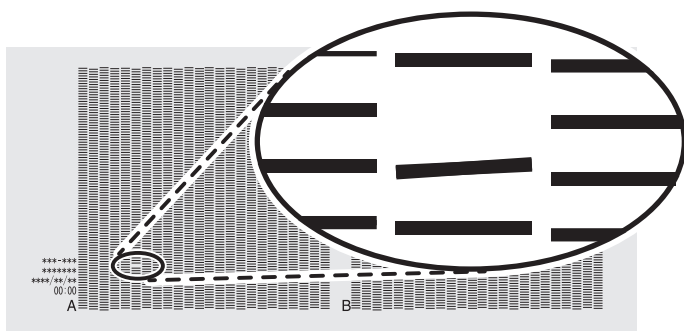
Procedure

1. Tap **[Printing Test]>[Execute]**.

Printing of the test pattern starts.

2. 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.



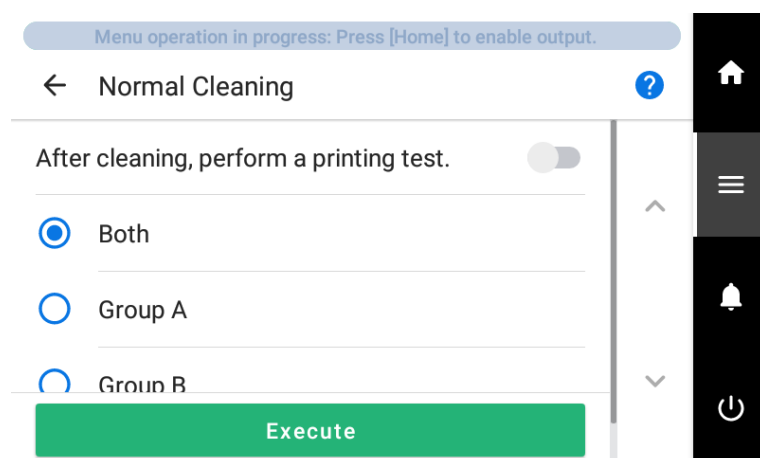
3. If you have opened the front cover, close it.

If dot drop-out or dot displacement is present in the printing test, follow the procedure below to perform normal cleaning.

If there is no dot drop-out or dot displacement, proceed to Step 4.

- (1) Tap **[Cleaning]>[Normal Cleaning]**.

The screen shown below appears.

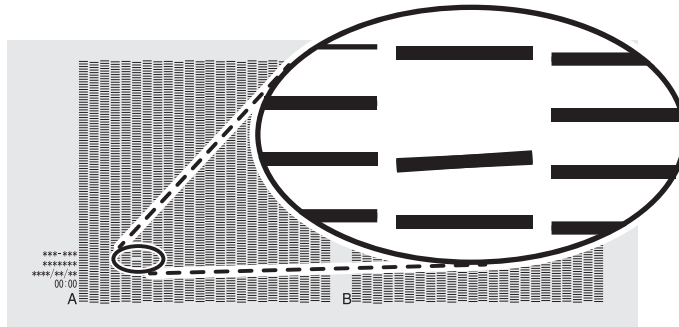


MEMO

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.

- (2) Check for the group with dot drop-out or dot displacement by viewing the results of the printing test.

The space from "A" to "B" is group A. The space from "B" to the right side is group B.

**IMPORTANT**

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.

- (3) Select the group of print heads to clean.

- (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  twice.

- (6) Tap [Printing Test]>[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. In such cases, refer to [When Normal Cleaning Is Not Effective\(P. 217\)](#).

If there is no dot drop-out or dot displacement, proceed to Step 4.

4. Tap [Next].

Step 8: Performing Feed Correction (Reducing Horizontal Stripes)

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, 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.

Make sure the printing area required for the printing test is at least 375 mm (14.77 in.) wide before performing the printing test.

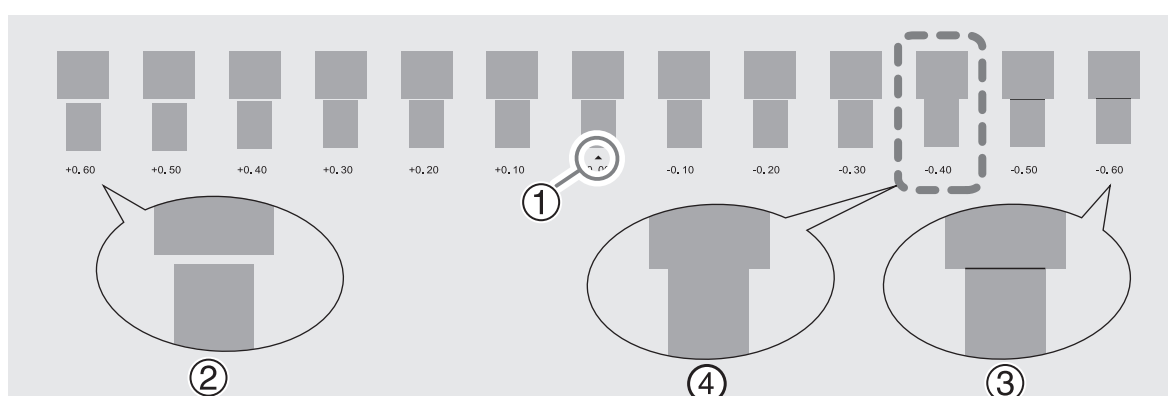
Procedure

1. Tap [Printing Test]>[Execute].

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  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 [Printing Test]>[Execute].

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].

Step 9: Adjusting the Misalignment of the Ink Landing Position

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

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

This adjustment must be performed in the following cases.

- When changing the media to use
- When you have changed the print-head height

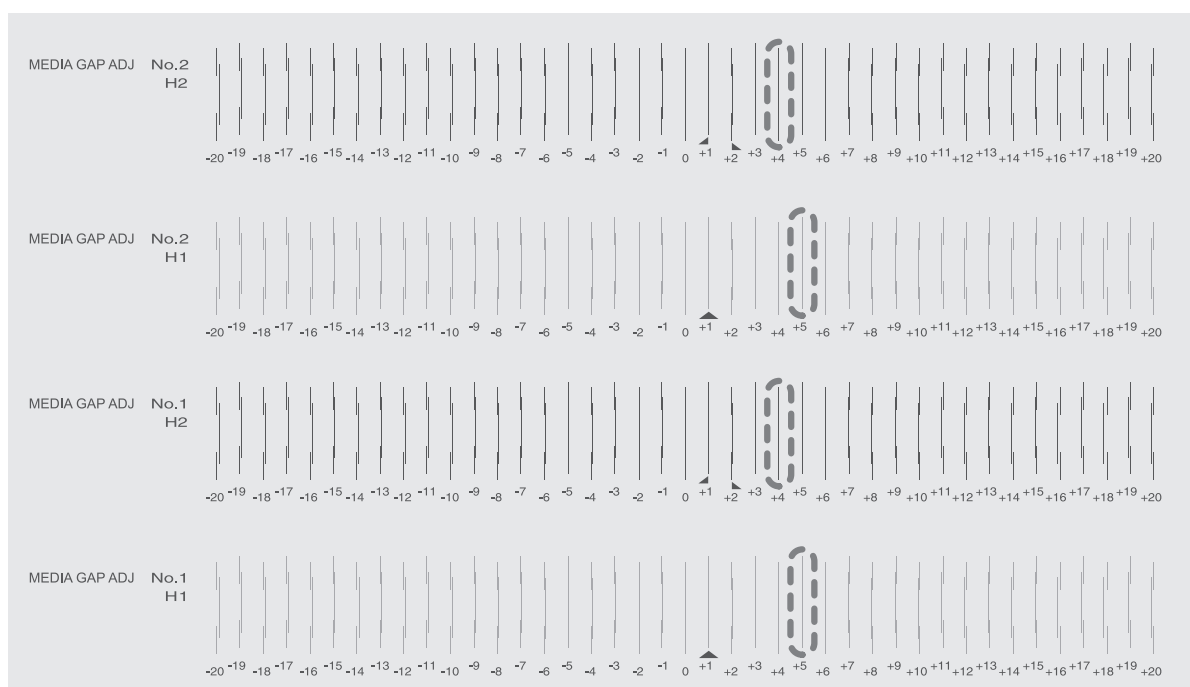
Procedure

1. Tap [Printing Test]>[Execute].

Printing of the test pattern starts.

2. Check the printed test pattern, and then tap  or  to change the H1 and H2 correction values for No. 1 and the H1 and H2 correction values for No. 2.

Select the value that gives the least misalignment between the two lines. In the case of the following figure, select "+5" for H1 for No. 1 and No. 2 and "+4" for H2 for 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  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 two vertical lines indicated by "▲" (that is, the current correction value). If the misalignment is smaller for another set of vertical lines, set the correction value again.
6. When you have successfully performed the correction, tap [Save and Proceed].

Step 10: Configuring the Settings to Dry the Trailing Edge of the Printing Area

To dry the ink thoroughly, configure the settings so that the media is fed until the trailing edge of the printed area is put on the dryer after the printing is finished.

Procedure

1. Tap  to turn the setting on or off.

[Drying Feed]	This setting applies to output data designed only for printing. The margin between the print-end position and the next print-start position is set to a value of 130 mm (5.12 in.) when [Extended Dryer] is set to [Disable] and 310 mm (12.2 in.) when it is set to [Enable].
 (On)	Media feed is performed until the trailing edge of the printing area is positioned on the dryer.
 (Off)	Media feed stops when printing ends. This means that the trailing edge of the printing area is not fed to the dryer unless you continue with a subsequent printing operation.

2. Tap  or  to set the [Drying Feed] drying time.

MEMO

Drying Time

- The next operation is not started until the set time elapses.
- Tap [Skip] during drying to finish the drying time and start the next operation.
- When the drying time has been set in the software RIP, priority is given to the software RIP's setting.
- If [Drying Time] is set to a value other than [0 min] and [Drying Feed] is off, the machine waits for the set time at the print-end position before starting the next operation.

3. Tap [Save and Proceed] to confirm your entry.

MEMO

Default setting:

- [Drying Feed]: [Off]
- [Drying Time]: [0 min.]

Step 11: Setting the Ink Drying Time

This setting is used to extend the drying time when the ink dries poorly even if the dryer is used.

Procedure

1. Tap  or  to change the value.

Larger values cause the media to move more slowly, extending the drying time accordingly.

2. Tap [Save and Proceed] to confirm your entry.

MEMO

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

Step 12: 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. 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 the correction.

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 the correction.
The media being used cannot be recognized.	Change the media type.
There is ink on the multi sensor because, for example, the media strikes it immediately after printing.	Contact your authorized dealer.

3. Tap [Next].

Step 13: Setting the Printing Movement Range

This shortens output time by reducing the width of head movement to the minimum necessary. This is effective when the width of the media or the output data is narrow.

Procedure

1. Specify the range of print head movement during printing.

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

2. Tap [Save and Exit].
The [Media Settings] screen appears.

MEMO

- Default setting: [Full Width]

3. Tap  to go back to the original screen.

Managing the Media Settings

Changing the Media Settings

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

Procedure

1. Set up the media.

2. Tap .

3. [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. 122 Changing the Print Head Height
[Feed Correction]	P. 117 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)
[Media Gap Adjustment]	P. 120 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)
[Heater Temperature]	P. 132 Setting the Print Heater Temperature P. 134 Setting the Dryer Temperature
[Dry After Printing]	P. 138 Drying the Trailing Edge of the Printing Area on the Dryer
[Multi Sensor Adjustment]	P. 140 Correcting the Reading Sensor
[Drying Time Per Scan]	P. 124 Using Hard-to-Dry Media
[Media Suction Force]	P. 125 Using Media That Wrinkles Easily/Does Not Move Smoothly
[Printing Movement Range]	P. 166 Speeding Up Output for Narrow Media
[Media Sticking Prevention]	P. 126 Using Sticky Media

5. If you have changed a setting, tap [Save].

6. Tap  to go back to the original screen.

Checking the Registered Media Settings

Procedure

1. Tap .
2. Tap [Media Management].
The registered media settings are displayed in a list.
3. Tap a media setting.
4. Tap [List of Media Settings].
The registered media setting values are displayed in a list.

Menu item	Reference page
[Print Head Height]	P. 122 Changing the Print Head Height
[Feed Correction]	P. 117 Manual Adjustment: Reducing Horizontal Bands (Feed Correction)
[Media Gap Adjustment]	P. 120 Manual Adjustment: Adjusting the Misalignment of the Ink Landing Position (Media Gap Adjustment)
[Heater Temperature]	P. 132 Setting the Print Heater Temperature P. 134 Setting the Dryer Temperature
[Dry After Printing]	P. 138 Drying the Trailing Edge of the Printing Area on the Dryer
[Multi Sensor Adjustment]	P. 140 Correcting the Reading Sensor
[Drying Time Per Scan]	P. 124 Using Hard-to-Dry Media
[Media Suction Force]	P. 125 Using Media That Wrinkles Easily/Does Not Move Smoothly
[Printing Movement Range]	P. 166 Speeding Up Output for Narrow Media
[Media Sticking Prevention]	P. 126 Using Sticky Media

Changing the Media Name

Procedure

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

Duplicating Media Settings

Use the following procedure to duplicate existing media settings.

Procedure

1. Tap .
2. Tap [Media Management].
The registered media settings are displayed in a list.
3. Tap the media setting to duplicate.
4. Tap [Duplicate Media].
A screen for entering the name of the duplicated media appears. To create this name, [COPY] is added at the start of the name of the media being duplicated.
5. Enter the media name and tap [OK].
You can use up to 15 alphanumeric characters.
6. Tap  to go back to the original screen.

Deleting Media Settings

Use the following procedure to delete existing media settings.

MEMO

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

Procedure

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

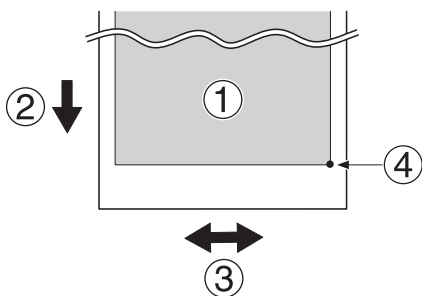
Adjusting the Output-start Location

Setting the Base Point

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

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

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



MEMO

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

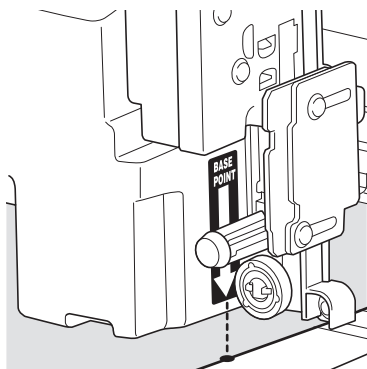
Procedure

1. Tap .

2. Tap  [Move].

The movement screen appears.

3. Use the following operations to move the base point mark to the position you want to use to start output. The base point mark on the right side is the start position.

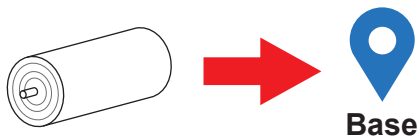


Use  or  to move the sub carriage in the scan direction (left and right). Use  or  to move the media in the feed direction (forward and backward).

4. Once the position has been decided, tap [Set Base Point Here] to confirm it.
The base point position is updated, and you are returned to the home screen.

MEMO

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



Reducing Output Time

Speeding Up Output for Narrow Media

This shortens output time by reducing the width of head movement to the minimum necessary. This is effective when the width of the media or the output data is narrow.

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 movement during printing.

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

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

MEMO

- Default setting: [Full Width]

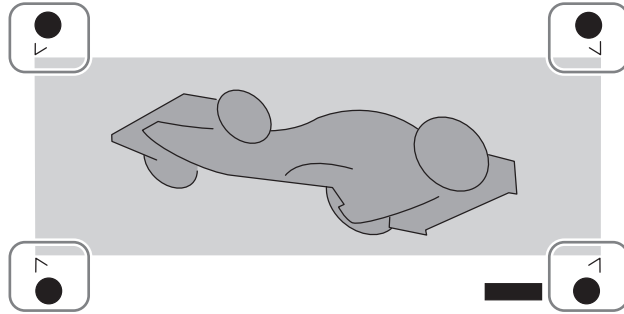
Printing with Crop Marks

Use your software RIP to configure the settings for printing crop marks. For information on how to make the settings, refer to the documentation for the software RIP 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.



Other Useful Functions

Using the Print Light (Interior Light)

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

Procedure

1. Tap .

2. Tap [Preferences]>[Print Light].

3. Select the status of the print light.

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

4. Tap [Save] to confirm your entry.

5. Tap  to go back to the original screen.

MEMO

- Default setting: [Auto]

Performing Printing Tests Arranged Horizontally

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

Procedure

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

MEMO

- Default setting: **[Feed]**

Optimizing Operation Management

Managing the Operations Appropriately and Efficiently	171
Setting the Current Date/Time and Using It for Maintenance.....	171
Checking the Remaining Media.....	172
Printing the Amount of Remaining Media.....	173
Showing/Hiding Notifications	174
Determining What Happens When Ink Runs Out	175
Setting the Activation Interval for Sleep Mode (Power-saving Feature)	176
Setting the Duration of the Warning Beep	177
Managing the Basic Settings of the Printer	178
Set the display language	178
Changing the Units of Measurement	179
Viewing Printer Information	180
Viewing Network Information	181
Adjusting the Brightness of the Operation Panel.....	182
Turning Off Operation Panel Sounds.....	183
Returning All Settings to Factory Defaults	184

Managing the Operations Appropriately and Efficiently

Setting the Current Date/Time and Using It for Maintenance

Use the following procedure to set the current date and time. By setting this, when you perform a printing test the printing test date and time will be printed alongside the printed test pattern. Notifications prompting you to perform 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 go back to the original screen.

Checking the Remaining Media

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

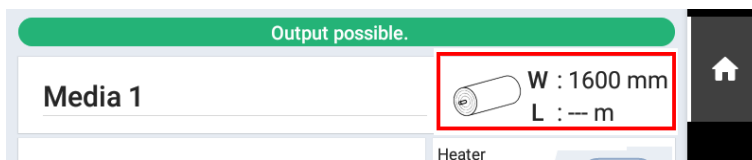
If you remove the media or cancel media loading by raising the loading lever, the amount remaining at that time flashes on the screen. Because the amount of media remaining is not updated automatically when you change the media, redo the setting whenever you change the media. You can also set the machine 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

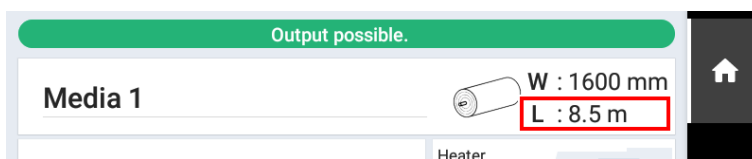
1. Set up the media.
2. Tap the following location on the home screen.



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  to go back to the original screen.

The remaining media is displayed.



Printing the Amount of Remaining Media

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

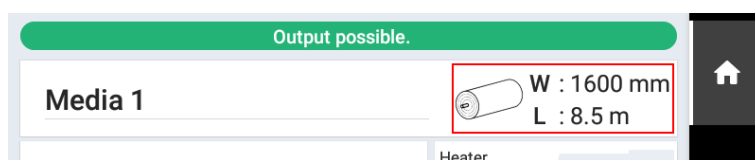
Use this when you want to make a record of the remaining length of the media currently in use. Printing the amount of media remaining before you change the media enables you to refer to the printed record and use the value to make the setting for the remaining amount the next time you use the media.

Note, however, that if you continue printing, 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](#).

2. Tap the following location on the home screen.



The [Remaining Media Management] screen appears.

3. Tap [Printing Remaining Media Amount]>[Execute].
The amount of remaining media is printed.

4. Tap  to go back to the original screen.

Showing/Hiding Notifications

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

Procedure

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

	Displayed notification	Description
[Media Clamp Placement Notification]	[Install the media clamps correctly.]	Prompts you to correctly place the media clamps to prevent the media from coming loose. When enabled, this message appears when the media clamps are not placed at the edges of the media.
	[Media clamps could not be detected.]	This message appears when the media clamps cannot be detected because they are hidden by the media or are dirty with, for example, ink.

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

MEMO

Default setting: [Media Clamp Placement Notification]: On

Determining What Happens When Ink Runs Out

This menu lets you determine the operation that takes place when an ink cartridge becomes empty during printing. The print quality will be affected by the selected operation.

Procedure

1. Tap .

2. Tap [Preferences]>[Ink Empty Mode]>[Stop].

[Ink Empty Mode]	Description
[Stop]	Printing is paused immediately when an ink cartridge becomes empty. Printing pauses, so colors may be uneven. To prevent uneven colors, ensure that a sufficient amount of ink remains before you begin printing.
[Continue]	A buzzer sounds when an ink cartridge becomes empty. Printing continues until all the data that this machine has received is printed. In this case, it is also possible to press [PAUSE] and pause printing.

3. Tap [Save] to confirm your entry.

4. Tap  to go back to the original screen.

MEMO

Default setting: [Stop]

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

This setting is used to set how long it should take until the machine goes into sleep mode (the state in which the power-saving feature is working) when no 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 go back to the original 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  to go back to the original screen.

MEMO

- Default setting: Off

Managing the Basic Settings of the Printer

Set the display language

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

Procedure

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

MEMO

Default settings

- [Language]: ENGLISH

Changing the Units of Measurement

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

Procedure

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

MEMO

- Default settings
 - [Length]: mm
 - [Temperature]: °C

Viewing Printer Information

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

Procedure

1. Tap .
2. Tap [System Information]>[Machine Information].
You can check the following information:
 - [Model]: Model name
 - [Serial Number]: Serial number
 - [Ink Type]: Ink type
 - [Firmware Version]
 - [MAC Address]
3. Tap  to go back to the original screen.

Viewing Network Information

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

Procedure

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

MEMO

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

RELATED LINKS

- [XP-640 Setup Guide](#)

Adjusting the Brightness of the Operation Panel

Procedure

1. Tap .
2. Tap [System Information]>[Screen Brightness].
3. Tap  or  to adjust the brightness.
The larger the value, the brighter the screen.
4. Tap [Save] to confirm your entry.
5. Tap  to go back to the original screen.

MEMO

- Default setting: [50%RH]

Turning Off Operation Panel Sounds

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

Procedure

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

MEMO

- Default setting: [On]

Returning All Settings to Factory Defaults

This menu returns all settings to the same as their factory defaults.

The settings for [Language] and [Units] are not returned to their factory default values.

Procedure

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

Maintenance

Introduction

Important Notes on Handling and Use	187
Printer	187
Ink Cartridges	187
Basic Maintenance Knowledge	189
Types and Timing of Maintenance	189
Automatic Maintenance Feature and Notes	191
Measures When the Printer Is Not in Use for a Prolonged Period	192

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 in a suitable location.**
 - Install the machine in a location having the specified temperature and humidity.
 - Install the machine in a quiet, stable location offering good operating conditions.
- **The print heads are delicate.**
 - Never needlessly touch or allow the object to be printed on to scrape them. Failure to handle these items 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 the machine 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.

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.

- **Ink cartridges come in various types.**
 - Use a type that is compatible with the printer. Also, be sure to use only genuine items from Roland DG Corporation.
- **Never subject to impact or attempt to disassemble.**
 - Never drop the ink cartridges or shake them forcefully. The impact may rupture the internal pouch and cause the ink to leak.
 - Never attempt to disassemble the ink pouches.
 - Never attempt to refill the ink.
 - If ink gets on your hands or clothing, wash it off as soon as possible. Removal may become difficult if you leave such adhered ink untreated.
- **Storage**

- Be sure to store ink cartridges horizontally.
Storing ink cartridges vertically for a long period of time may cause the internal pouches to deform, leading to ink leakage.
- Use up the ink before the expiration date printed on the ink cartridge.
- Store the ink cartridges 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 40°C (41°F to 104°F).

Basic Maintenance Knowledge

Types and Timing of Maintenance

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

Regular Maintenance

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

Timing	Category	Item
Before daily operations	Cleaning of the print heads	P. 194 Print Head Check before Printing
After daily operations	Cleaning the machine	P. 195 Cleaning the Media Path
		P. 197 Cleaning the Sub Carriage Roller
If a message appears	Cleaning around the print heads	P. 205 Clean the print heads.
If the discharged fluid disposal message appears	Disposing of discharged fluid	P. 212 If the Discharged Fluid Disposal Message Appears

Advanced Maintenance

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

Timing	Category	Item
When dot drop-out or dot displacement occurs	Checking and cleaning the print heads	P. 194 Print Head Check before Printing
		P. 217 Medium Cleaning Method
		P. 219 Powerful Cleaning Method
		P. 199 Manual Cleaning Method
When colors are uneven	Eliminating drops in ink concentration	P. 221 Light Choke Cleaning Method
When uneven color, dot drop-out, and dot displacement issues are not resolved even by performing the above operations	Replacing the ink in all the ink paths ^{*1}	P. 223 Ink Renewal Method

^{*1} This cleaning consumes a large amount of ink.

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	Category	Item
When a replacement message appears	Replacing consumable parts • Wiper • Wiper cleaner • Flushing sponge • Print head caps	P. 234 Replacing the Wiper
		P. 239 Replacing the Wiper Cleaner
		P. 248 Replacing the Flushing Sponges
		P. 244 Replacing the Print Head Caps
When a cutting edge becomes dull	• Separating knife	P. 253 Replacing the Separating Knife

Automatic Maintenance Feature and Notes

This machine has a feature that automatically performs maintenance periodically.

This function performs operations for preventing the print heads from drying out, so:

- Always keep the main power switched on.
- Do not leave the front cover open for a long time.
- Return to the home screen after specifying settings in the menus.

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.

- **Empty the drain bottle.**

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.

The drain bottle is filled when the following periods elapse. To perform automatic maintenance, discard the discharged fluid during these periods.

- Approximately 2 weeks after the message [**When output, cleaning, and other operations are completed, discard the discharged fluid.**] is displayed
- Approximately 150 days after the drain bottle is emptied
- **Do not allow the machine to run out of ink.**

The machine discharges ink during the automatic maintenance that is performed periodically. Set in the machine ink cartridges having sufficient remaining ink. The machine cannot perform automatic maintenance if it has run out of ink or cleaning liquid.

- **Switch the sub power on once every two weeks.**

Switch the sub power on once every two weeks. 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). Failure to do so may result in malfunction.

RELATED LINKS

- [P. 212 If the Discharged Fluid Disposal Message Appears](#)

Regular Maintenance

Print Head Check before Printing	194
Performing a Printing Test	194
Cleaning the Machine	195
Cleaning the Media Path	195
Cleaning the Sub Carriage Roller	197
Cleaning around the Print Heads	198
Manual Cleaning Method	199
Consumable Products and Parts Related to Manual Cleaning.....	209

Print Head Check before Printing

Performing a Printing Test

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

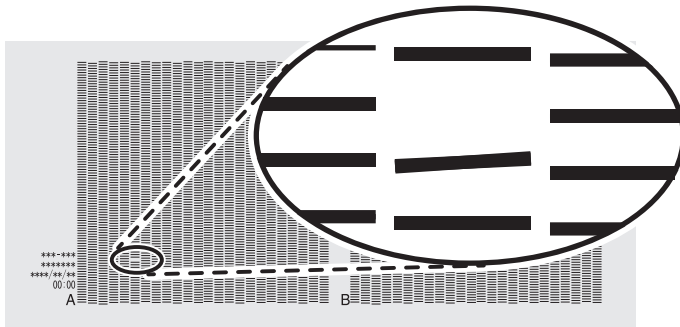
MEMO

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

[P. 169 Performing Printing Tests Arranged Horizontally](#)

Procedure

1. Tap  [Nozzle Drop-out Test] on the home screen.
2. Tap [Printing Test]>[Execute].
Printing of the test pattern starts.
3. Check whether there is dot drop-out or dot displacement in the test pattern.
Missing blocks indicate dot drop-out. Collapsed or inclined blocks indicate dot displacement.



4. If you have opened the front cover, close it.
If no dot drop-out or dot displacement occurs, preparations for output are finished.

RELATED LINKS

- [P. 215 When Dot Drop-out or Dot Displacement Occurs](#)

Cleaning the Machine

Cleaning the Media Path

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

⚠ WARNING

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

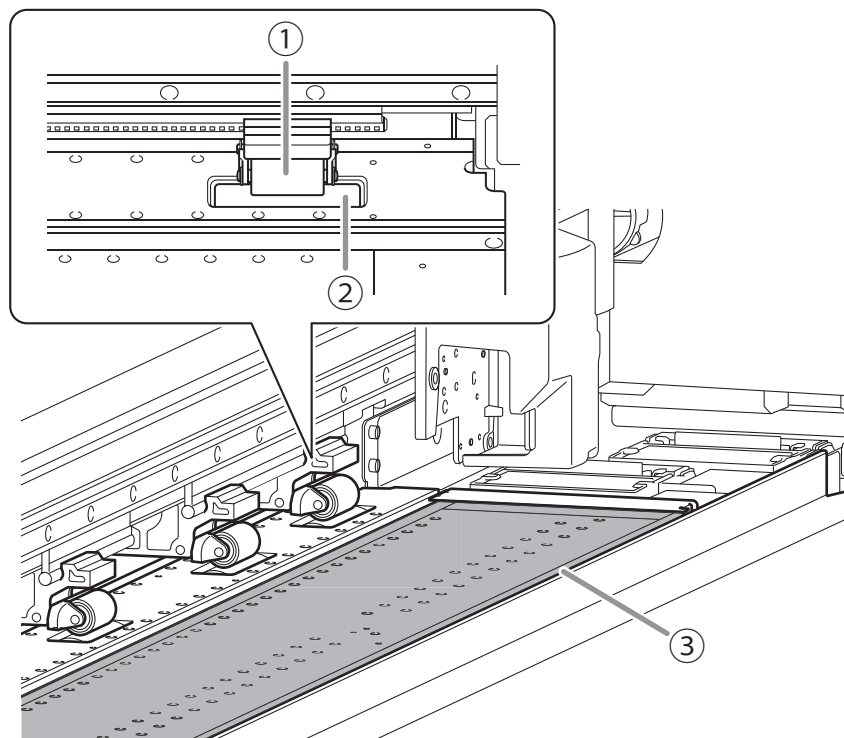
⚠ CAUTION

Before attempting cleaning, switch off the sub power and wait until the platen and dryer cool (approximately 30 minutes).

Sudden movement of the machine may cause injury, or hot components may cause burns.

IMPORTANT

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



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

①	Pinch roller	These are the positions where the media is fixed in place or transported, so it is easy for ink and grime to affix to these positions. Failure to clean this part properly may result in the transfer of grime to the surface of media.
---	--------------	---

Cleaning the Machine

②	Grit roller	These are the positions where the media is fixed in place or transported, so it is easy for grime to affix to these positions. Remove buildup of media scraps and other material using a brush. Never use a metal brush.
③	Platen	Wipe away any buildup of ink, grime, or cut media on the media path and in the grooves.

Cleaning the Sub Carriage Roller

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

⚠ WARNING

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

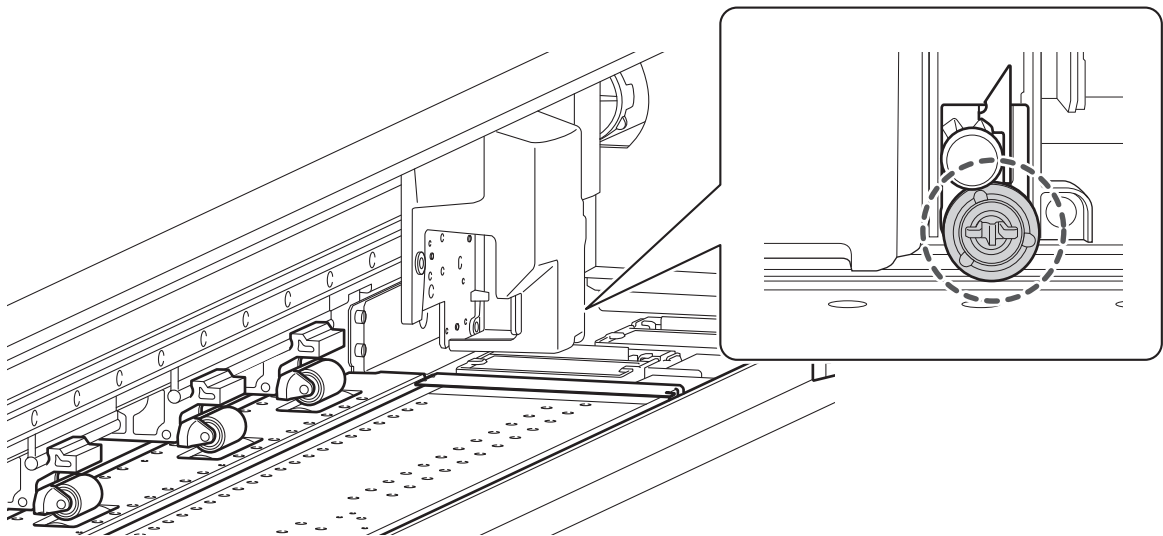
⚠ CAUTION

Before attempting cleaning, switch off the sub power and wait until the platen and dryer cool (approximately 30 minutes).

Sudden movement of the machine may cause injury, or hot components may cause burns.

IMPORTANT

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



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.]

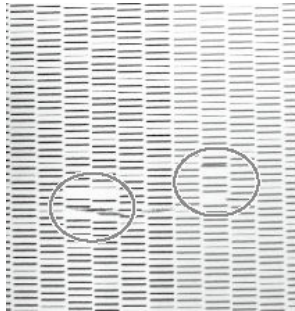
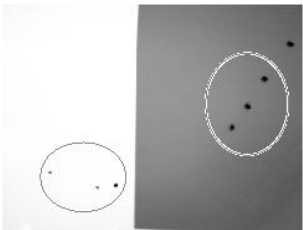
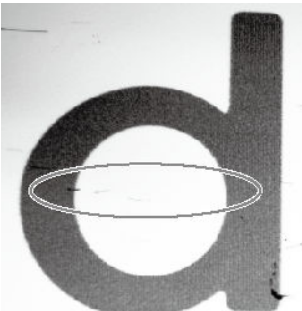
[Maintenance must be performed. Perform manual cleaning.]

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 sending the print data if you want to perform unmanned printing 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.

MEMO

Wiper replacement may also be effective in improving these symptoms.

RELATED LINKS

- [P. 234 Replacing the Wiper](#)

Manual Cleaning Method

⚠ 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.

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 30 minutes or less. A warning beep sounds after 30 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 a dropper or cleaning liquid other than those included.
- Be sure to use new cleaning sticks. Reusing cleaning sticks will adversely affect the printing results.
- Do not put a cleaning stick that has been used for cleaning into the cleaning liquid. Doing so will deteriorate the cleaning liquid.
- 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>).

When an alarm sounds during cleaning

- A warning beep sounds 30 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	Dropper	Cleaning liquid

1. Clean the print head caps.

Procedure

1. Remove any media.
2. Tap .
3. Tap [Cleaning]>[Manual Cleaning].
4. Tap [Execute].

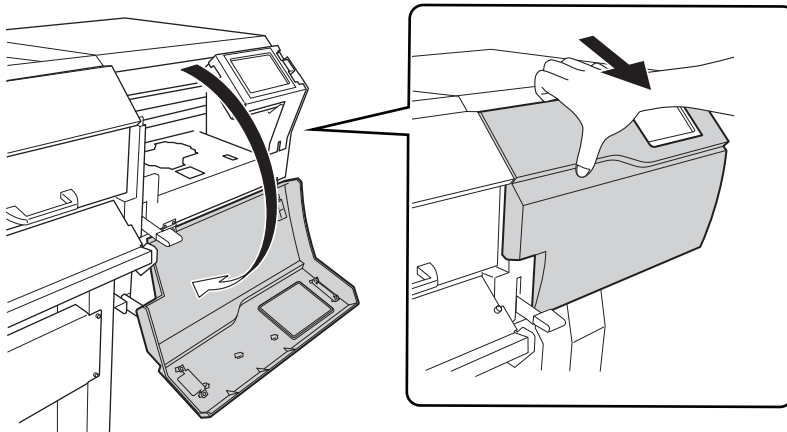
MEMO

The procedure is displayed on the operation panel.

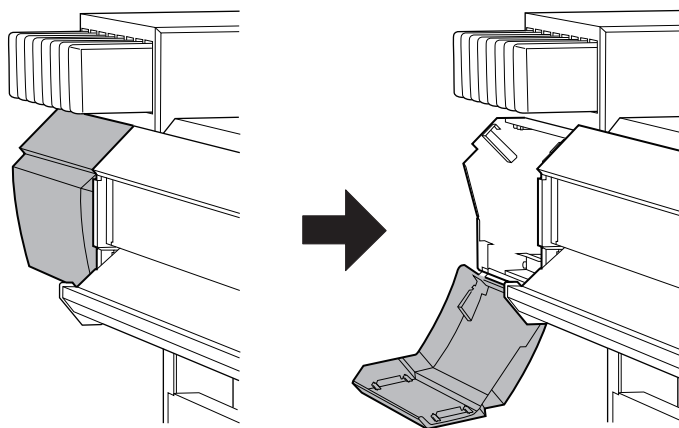
- Tap  or  to check the procedure.
- If you complete the work without viewing the instructions, tap [Finish All].

The print head carriage moves to the left end of the machine.

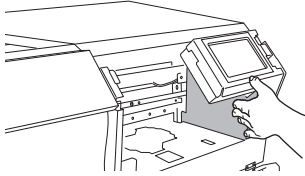
5. Open the right cover.



6. Open the left cover.



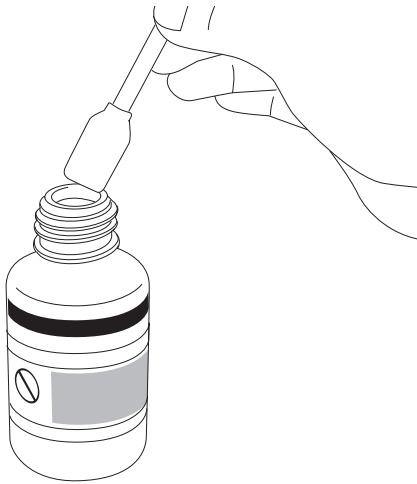
7. Touch the location shown in the figure to discharge any static electricity.



8. Moisten a new cleaning stick with the cleaning liquid.

MEMO

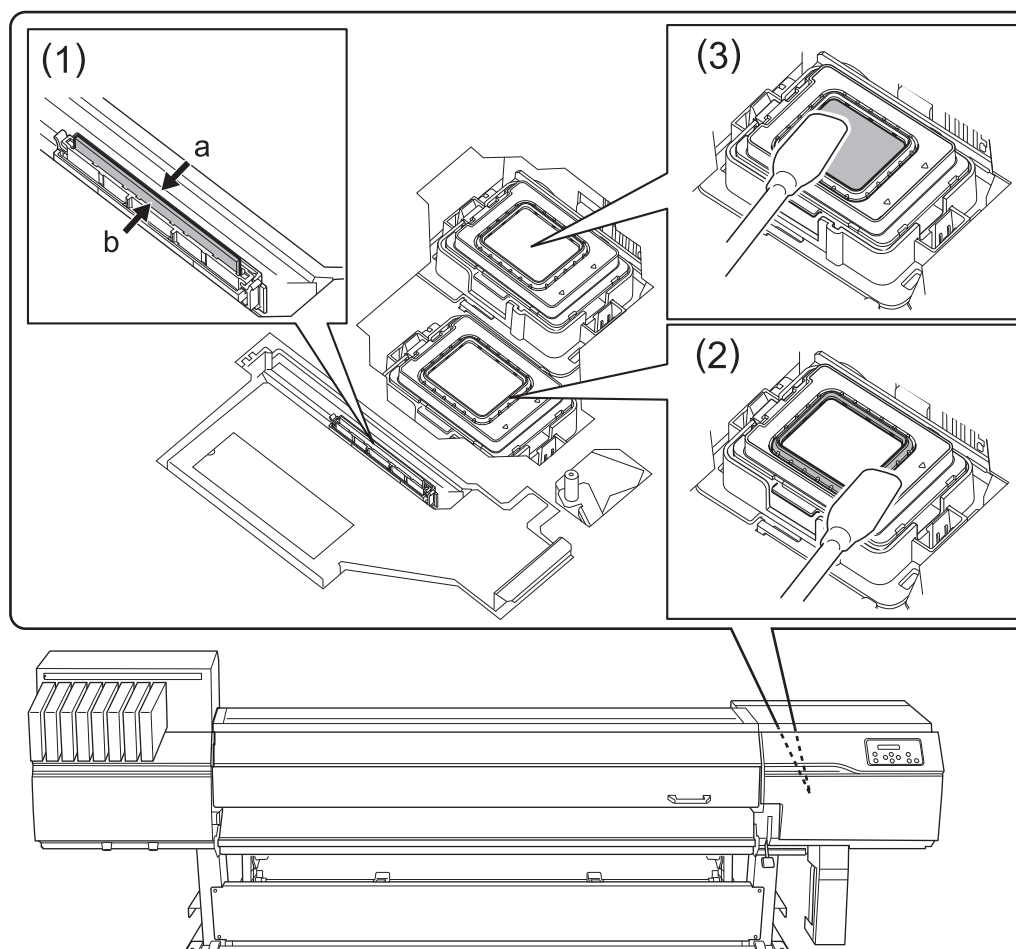
1. Be sure to use one of the included cleaning sticks.
2. Do not use a previously used cleaning stick.
3. Do not put a previously used cleaning stick into the cleaning liquid.



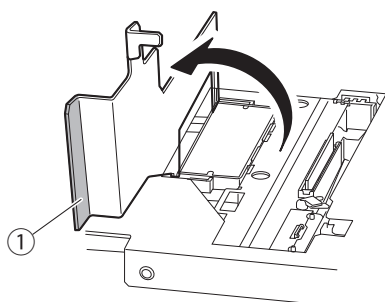
9. Clean the locations shown in the following figure.

Be especially careful to clean away any fibrous dust (lint).

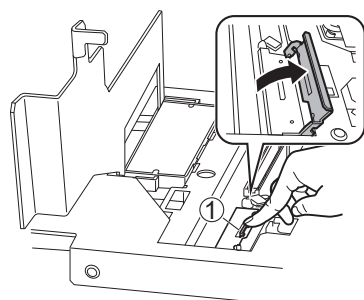
- (1) Wipe off wiper surfaces a and b with the cleaning stick.
- (2) Wipe off the area in the figure with a cleaning stick.
- (3) Use the wide surface of the cleaning stick, pressing the cleaning stick down while sliding between locations to clean up dirt.



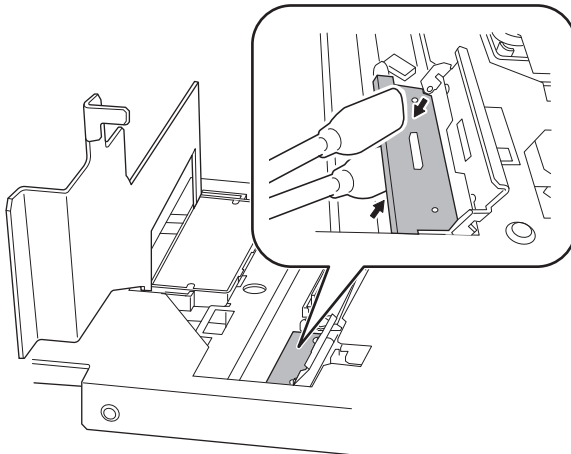
10. Grasping the part indicated by ①, open the flushing cover.



11. While pressing the lock (①) down, open the wiper cleaner cover.



- 12.** Push the cleaning stick against the top and bottom surfaces of the wiper cleaner to apply the cleaning liquid.



- 13.** Suction out some cleaning liquid with the dropper, and then drip this cleaning liquid in one of the locations indicated in the following figure.

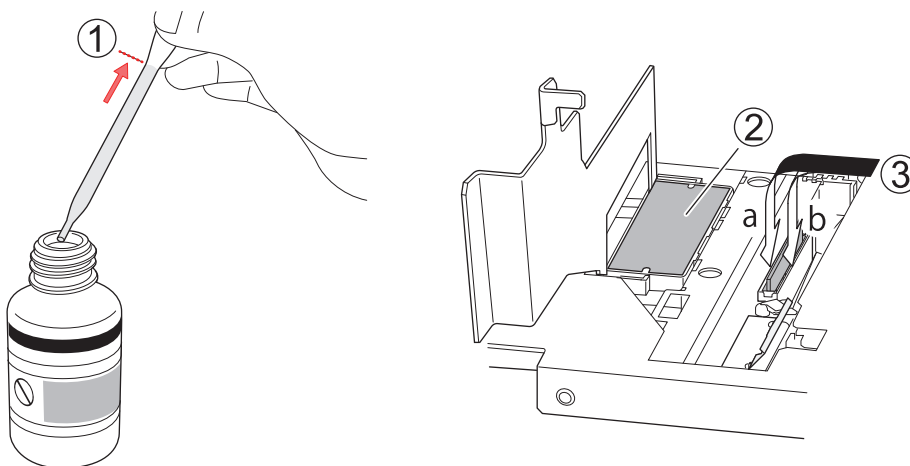
Use the included dropper.

Firmly squeezing the dropper and suctioning out the cleaning liquid ① fills the dropper with enough cleaning liquid for one location. In each location, use all the suctioned out cleaning liquid. In this procedure, drip the cleaning liquid in three locations.

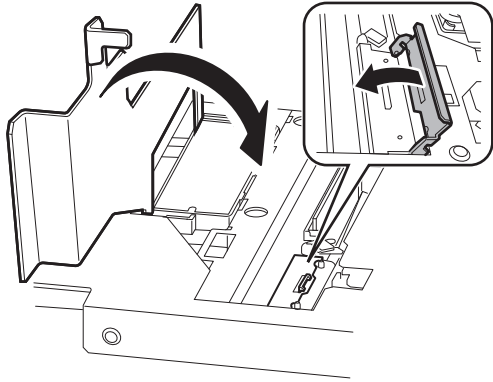
Drip the cleaning liquid equally across the entire surface of ②. For ③, alternate between the sides of the wiper (a and b), dripping one drop into the grooves on each side at a time.

IMPORTANT

- A low amount of cleaning liquid in these locations may lead to poor printing quality.
 - When dripping the cleaning liquid, ensure that the tip of the dropper does not come into contact with the locations.
- If it does, wipe away any dirt from the tip of the dropper before the next time you suction out cleaning liquid.



- 14.** Close the wiper cleaner cover and the flushing cover.
Firmly push the flushing cover closed to ensure that it is locked.



15. Close the right cover.

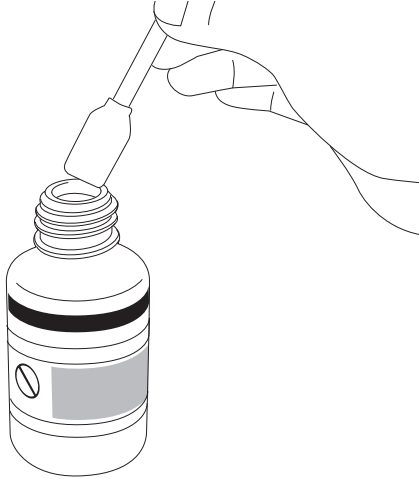
2. Clean the print heads.

Procedure

1. Moisten a new cleaning stick with the cleaning liquid.

IMPORTANT

1. Be sure to use one of the included cleaning sticks.
2. Do not use a previously used cleaning stick.
3. Do not put a previously used cleaning stick into the cleaning liquid.



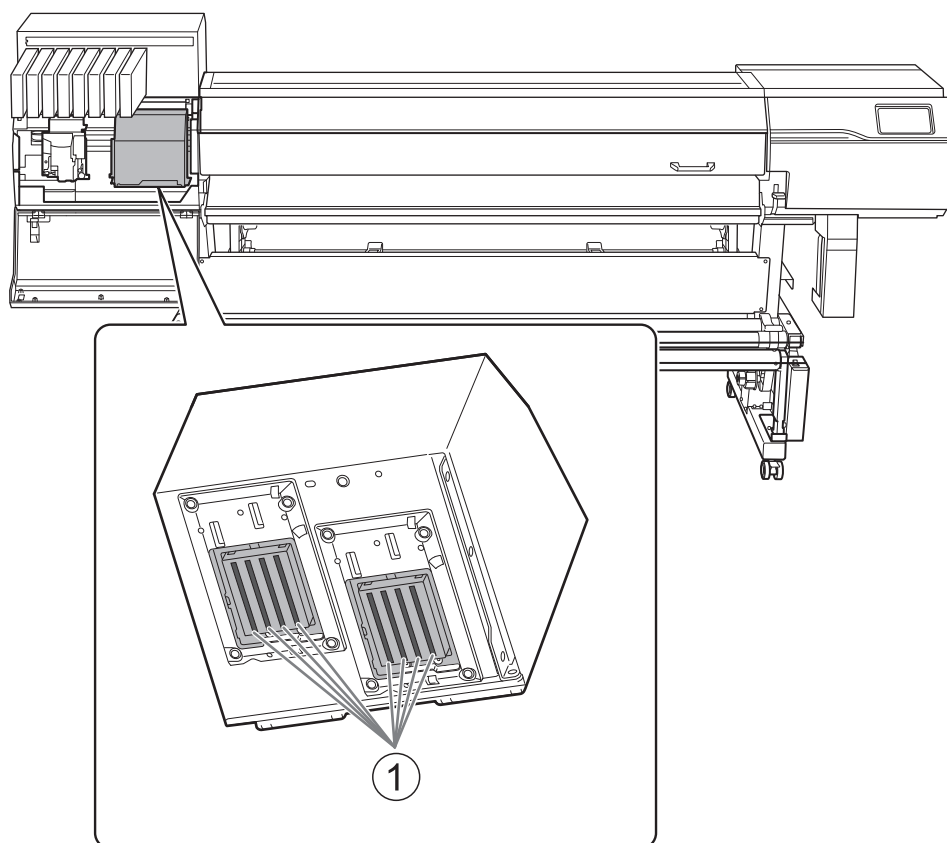
2. Use the wide surface of the cleaning stick to wipe away any dirt from the locations shown in the following figure.

Be especially careful to clean away any fibrous dust (lint). Also wipe with the opposite, clean surface, ensuring that dirt from the dirty surface does not adhere to the head.

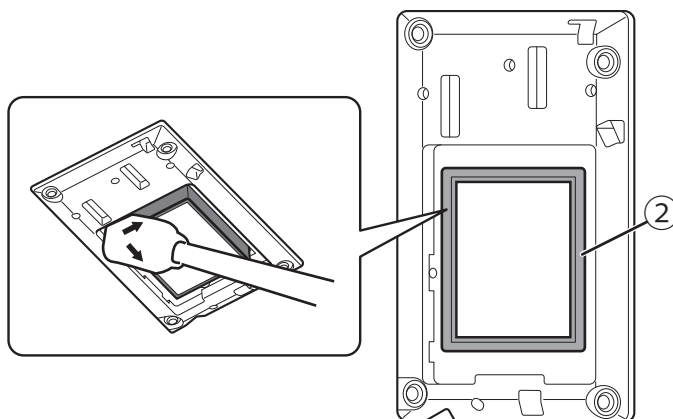
- Head

IMPORTANT

Be careful not to wipe off the grooves on the head surface (①).

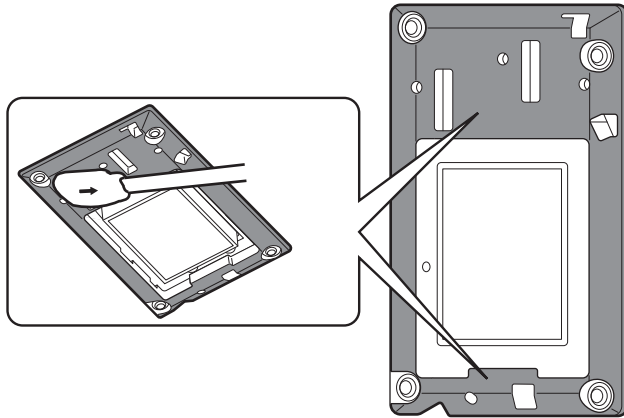


- Edges and sides of the head (②)



- Around the head

If this area has any ink or cleaning liquid that appears likely to drip, use a dry cloth that is not fluffy to gently wipe away the ink or cleaning liquid.



3. Close the left cover.
4. Tap [Finish All].
[Normal cleaning in progress.] is displayed at the top of the screen, and cleaning starts.
The (approximate) remaining time for the procedure is displayed on the screen.
5. Tap  to go back to the original screen.

3. Perform a printing test to check the results.

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

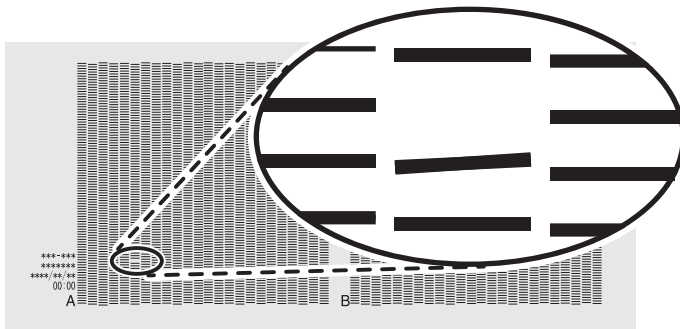
MEMO

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

[P. 169 Performing Printing Tests Arranged Horizontally](#)

Procedure

1. Tap  [Nozzle Drop-out Test] on the home screen.
2. Tap [Printing Test]>[Execute].
Printing of the test pattern starts.
3. Check whether there is dot drop-out or dot displacement in the test pattern.
Missing blocks indicate dot drop-out. Collapsed or inclined blocks indicate dot displacement.



4. If you have opened the front cover, close it.
If no dot drop-out or dot displacement occurs, preparations for output are finished.

RELATED LINKS

- [P. 215 When Dot Drop-out or Dot Displacement Occurs](#)

Consumable Products and Parts Related to Manual Cleaning

The cleaning sticks, cleaning liquid, and print heads are consumable products or consumable parts.

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

Disposing of Discharged Fluid

Precautions for Disposing of Discharged Fluid	211
If the Discharged Fluid Disposal Message Appears.....	212

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

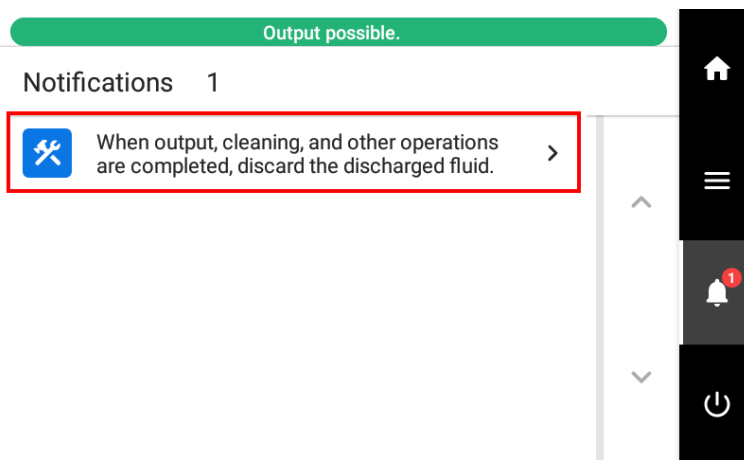
The [When output, cleaning, and other operations are completed, discard the discharged fluid.] message appears when a certain amount of discharged fluid has collected in the bottle and the sub power is turned on. If this message appears, dispose of the discharged fluid.

Procedure

1. When the message [When output, cleaning, and other operations are completed, discard the discharged fluid.] appears, tap [OK].

2. Tap  to display the notification.

3. Tap the following notification.



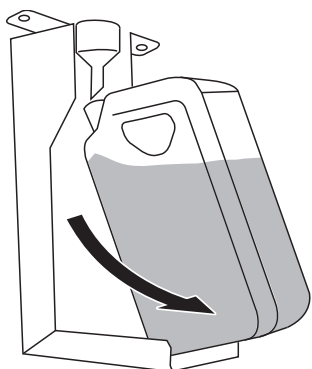
The [Drain Bottle] screen appears.

MEMO

You can dispose of discharged fluid even if the above message has not appeared. Use the following operations to display the drain bottle screen, and then dispose of discharged fluid according to the procedure starting from step 4.

1. Tap .
2. Tap [Maintenance]>[Drain Bottle].

4. Tap [Execute].
5. Remove the drain bottle and discard the discharged fluid.



⚠ CAUTION

Before you detach the drain bottle, be sure to wait for the screen to display [Discard the discharged fluid in the bottle.]. After discarding the discharged fluid, promptly attach the drain bottle to the machine.

Failing to follow this procedure may cause discharged fluid to flow out of the tube and spill, soiling your hands or the floor.

IMPORTANT

When you remove the drain bottle, a few drops of discharged fluid may come out of the machine. Exercise caution to prevent this fluid from soiling your hands or the floor.

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

7. Tap [Finish].

The display returns to the original screen.

8. Tap  to go back to the original screen.

Advanced Maintenance

- When Dot Drop-out or Dot Displacement Occurs 215
 - Normal Cleaning Method 215
- When Normal Cleaning Is Not Effective 217
 - Medium Cleaning Method 217
 - Powerful Cleaning Method 219
- If Colors Are Uneven 221
 - Light Choke Cleaning Method 221
- Handling Severe Dot Drop-out, Dot Displacement, and Uneven Colors 223
 - Ink Renewal Method 223
 - Partially Restricting the Print Heads Used for Printing 226
 - Emergency Measure) Cleaning the Print Head Surface 228
 - Operation Panel Cleaning Method 232

When Dot Drop-out or Dot Displacement Occurs

If dot drop-out or dot displacement occurs, perform cleaning of the print heads (normal cleaning).

Normal Cleaning Method

MEMO

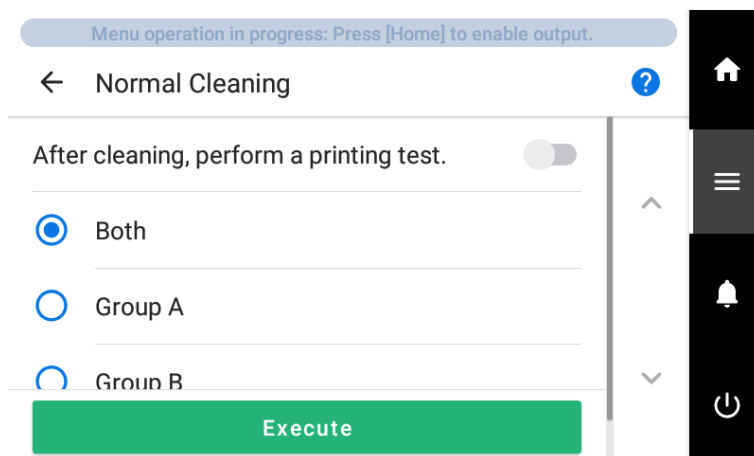
If the media has already been set up, the [After cleaning, perform a printing test.] menu appears on the [Normal Cleaning] screen. When this setting is turned on, a printing test is performed after cleaning.

Procedure

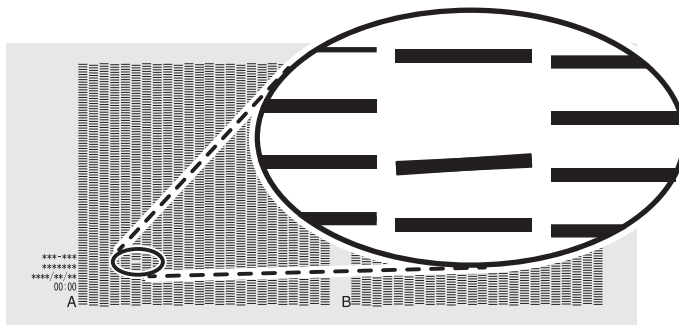
1. Set up the media.

2. Tap .

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



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



IMPORTANT

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. Select the group of print heads to clean.

6. 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.

7. Tap .

8. Tap [Printing Test].

9. Tap [Nozzle Drop-out Test]>[Execute].

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

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

RELATED LINKS

- [P. 217 When Normal Cleaning Is Not Effective](#)

When Normal Cleaning Is Not Effective

Medium Cleaning Method

The print heads are important components that discharge ink. They require periodic and appropriate maintenance. When problems such as dot drop-out are not resolved by normal cleaning, perform the more forceful "medium cleaning" to remove clogging from the print heads.

IMPORTANT

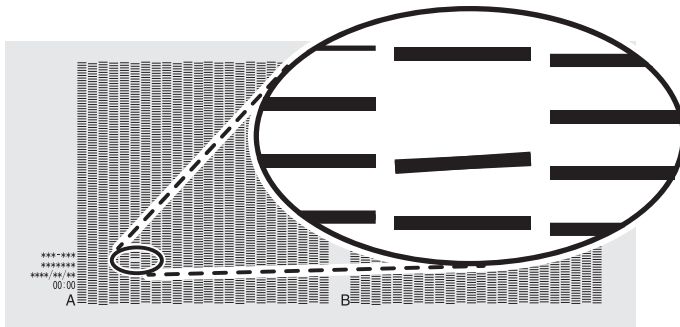
Medium cleaning consumes more ink than normal cleaning, and overly frequent use may damage the print heads themselves. Avoid performing this operation more than necessary.

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]>[Medium Cleaning].
4. Check for the group with dot drop-out or dot displacement by viewing the results of the printing test. The space from [A] to [B] is group A. The space from [B] to the right side is group B.

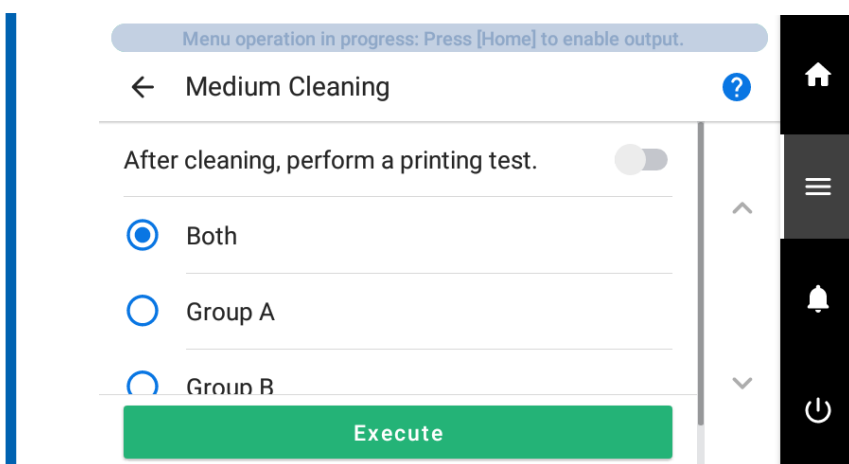


IMPORTANT

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. Select the group of print heads to clean.



6. 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.

7. Tap .

8. Tap [Printing Test].

9. Select [Nozzle Drop-out Test] and tap [Execute].

Perform a printing test again to check whether the dot drop-out and dot displacement have been corrected.

MEMO

- If the problem persists, try performing medium cleaning again.
- If problems such as dot drop-out and dot displacement persist even after you have performed medium cleaning several times, perform "powerful cleaning."
- This cleaning can be effective when carried out periodically, according to the frequency of use.

RELATED LINKS

- [P. 219 Powerful Cleaning Method](#)

Powerful Cleaning Method

The print heads are important components that discharge ink. They require periodic and appropriate maintenance. When problems such as dot drop-out are not resolved by medium cleaning, perform the more forceful "powerful cleaning" to remove clogging from the print heads.

IMPORTANT

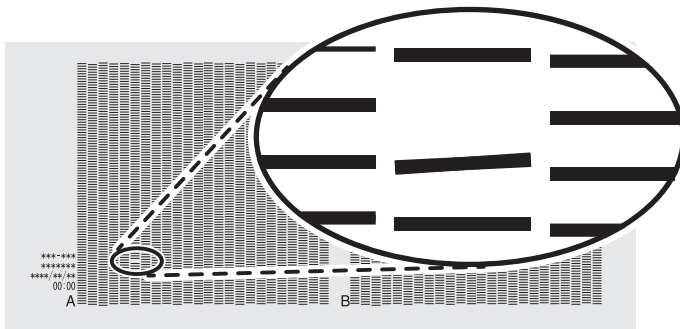
Powerful cleaning consumes more ink than medium cleaning, and overly frequent use may damage the print heads themselves. Avoid performing this operation more than necessary.

MEMO

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]>[Powerful Cleaning].
4. Check for the group with dot drop-out or dot displacement by viewing the results of the printing test. The space from "A" to "B" is group A. The space from "B" to the right side is group B.

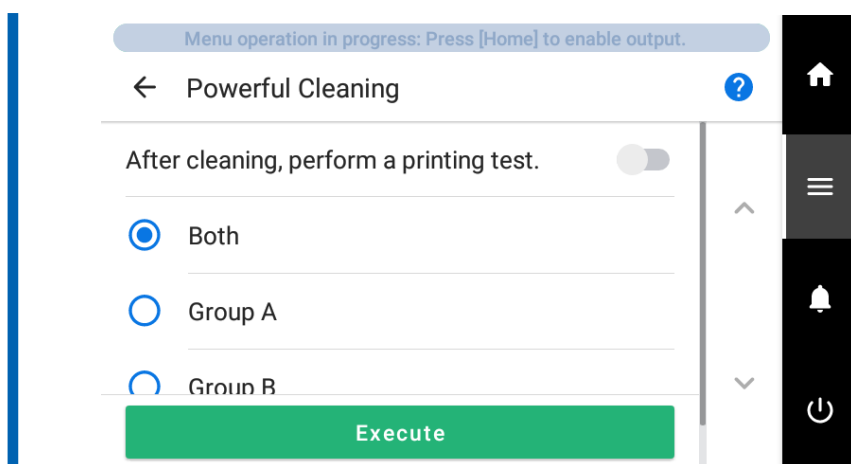


IMPORTANT

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. Select the group of print heads to clean.



6. 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.

7. Tap .

8. Tap [Printing Test].

9. Select [Nozzle Drop-out Test] and tap [Execute].

Perform a printing test again to check whether the dot drop-out and dot displacement have been corrected.

MEMO

- If the problem persists, try performing powerful cleaning again.
- This cleaning can be effective when carried out periodically, according to the frequency of use.
- If problems such as dot drop-out and dot displacement persist even after you have performed powerful cleaning several times, perform "manual cleaning."

RELATED LINKS

- [P. 199 Manual Cleaning Method](#)

If Colors Are Uneven

Light Choke Cleaning Method

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

IMPORTANT

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

Procedure

1. Tap .
2. Tap [Maintenance]>[Light Choke Cleaning].
3. Tap [Execute].

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  to go back to the original screen.

RELATED LINKS

- [P. 223 Ink Renewal Method](#)

Handling Severe Dot Drop-out, Dot Displacement, and Uneven Colors

Ink Renewal Method

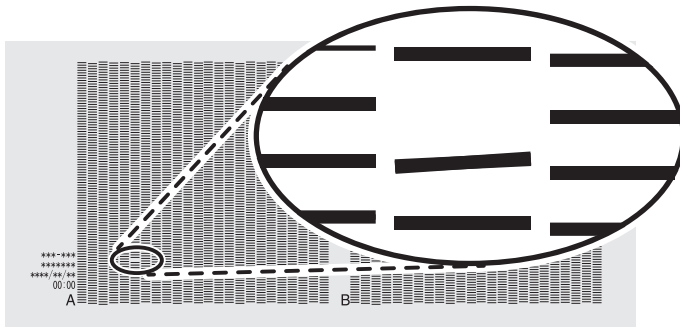
Perform the procedure below if ink discharge issues such as dot drop-out are not corrected after performing cleaning using the cleaning function (normal, medium, powerful) or manual cleaning.

IMPORTANT

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

Procedure

1. Tap .
2. Tap [Maintenance]>[Ink Renewal].
3. Check for the group with dot drop-out, dot displacement, or uneven colors by viewing the results of the printing test.
The space from "A" to "B" is group A. The space from "B" to the right side is group B.

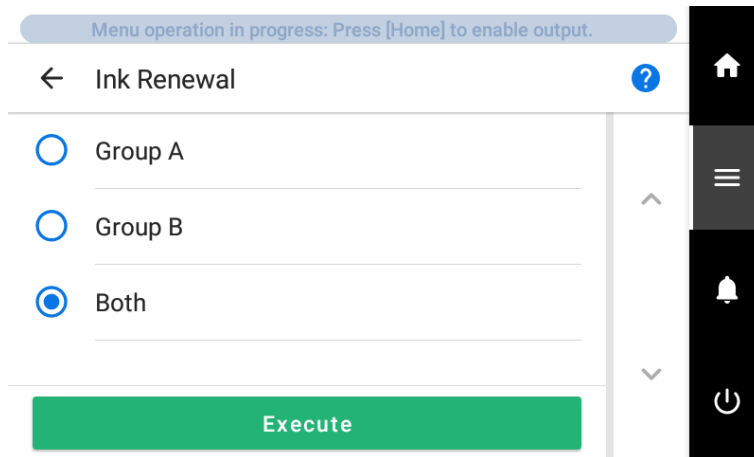


MEMO

If the printing-test results are difficult to interpret

Check the results in a bright location, changing your line of vision. They are visible using the reflection of the light.

4. Select the group of print heads to renew the ink of.

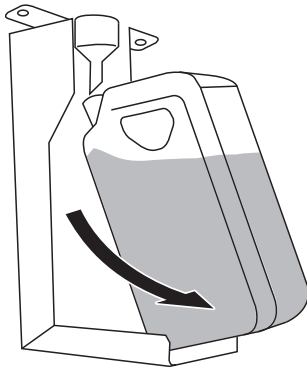


5. Tap [Execute].

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.

6. Tap  to go back to the original screen.

RELATED LINKS

- [P. 215 When Dot Drop-out or Dot Displacement Occurs](#)
- [P. 217 Medium Cleaning Method](#)
- [P. 219 Powerful Cleaning Method](#)

Partially Restricting the Print Heads Used for Printing

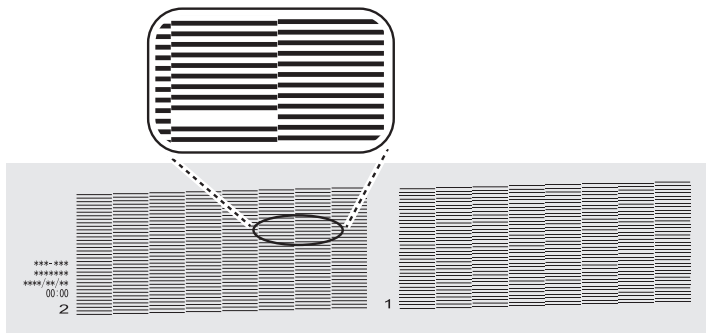
When dot drop-out or dot displacement is not improved even after renewing the ink, partially restrict the print heads to use for printing (i.e. prevent the use of the print heads that are causing discharge issues). This operation is called the "nozzle mask," and while it slows down printing speed, it 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. Perform 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 the nozzle group with dot drop-out or dot displacement by viewing the results of the printing test.
"1" or "2" is the nozzle group. The following shows a dot drop-out in nozzle group 2.



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 go back to the original screen.

2. Limit the print heads used for printing.

Use VersaWorks to select the nozzle group used for printing. For the detailed procedure, see the VersaWorks Master Guide.

RELATED LINKS

- [VersaWorks manual](#)

Emergency Measure) Cleaning the Print Head Surface

When dot drop-out or dot deflection is not improved even if cleaning is performed several times, you can clean the surface of the print heads as an emergency measure. The print head surface (nozzle surface) is a very delicate mechanism, so work must be performed carefully and cautiously.

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

⚠ 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.

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 30 minutes or less. A warning beep sounds after 30 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 a dropper or cleaning liquid other than those included.
- Use one cleaning stick per cleaning session, and then discard the stick after use. 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>).

When an alarm sounds during cleaning

- A warning beep sounds 30 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].

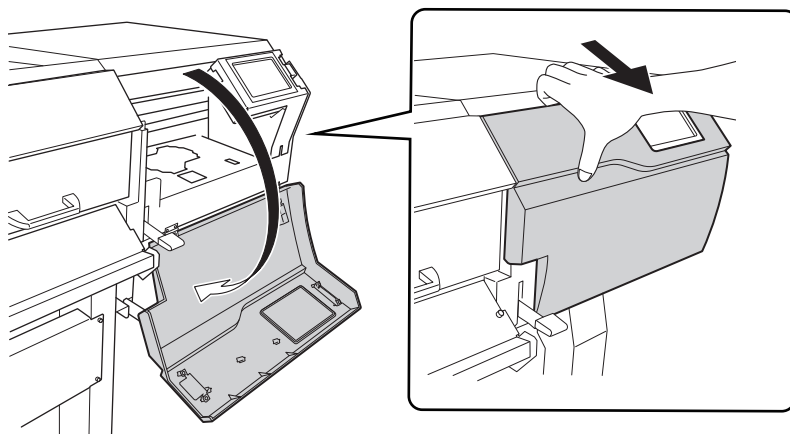
MEMO

The procedure is displayed on the operation panel.

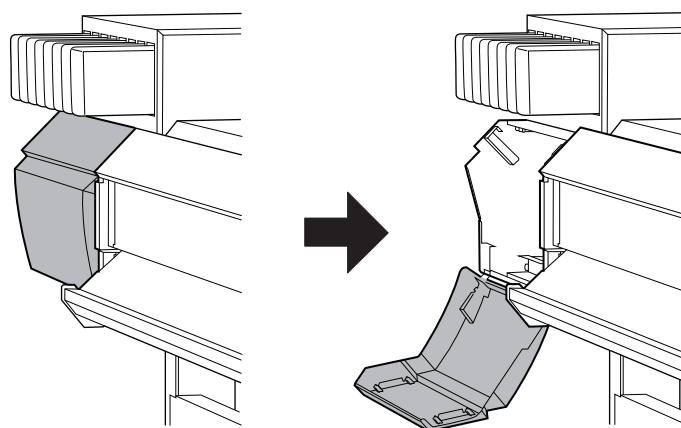
- Tap  or  to check the procedure.
- If you complete the work without viewing the instructions, tap [Finish All].

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

5. Open the right cover.



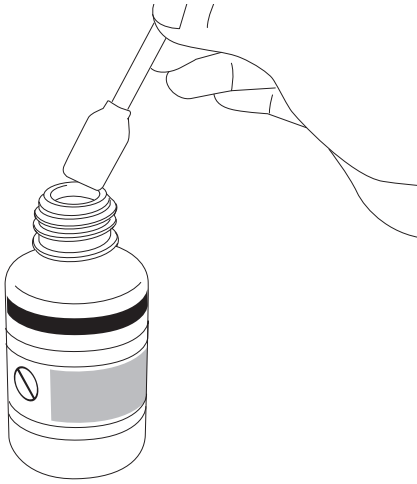
6. Open the left cover.



7. Moisten a new cleaning stick with the cleaning liquid.

IMPORTANT

- Be sure to use one of the included cleaning sticks.
- Do not use a previously used cleaning stick.
- Do not put a previously used cleaning stick into the cleaning liquid.

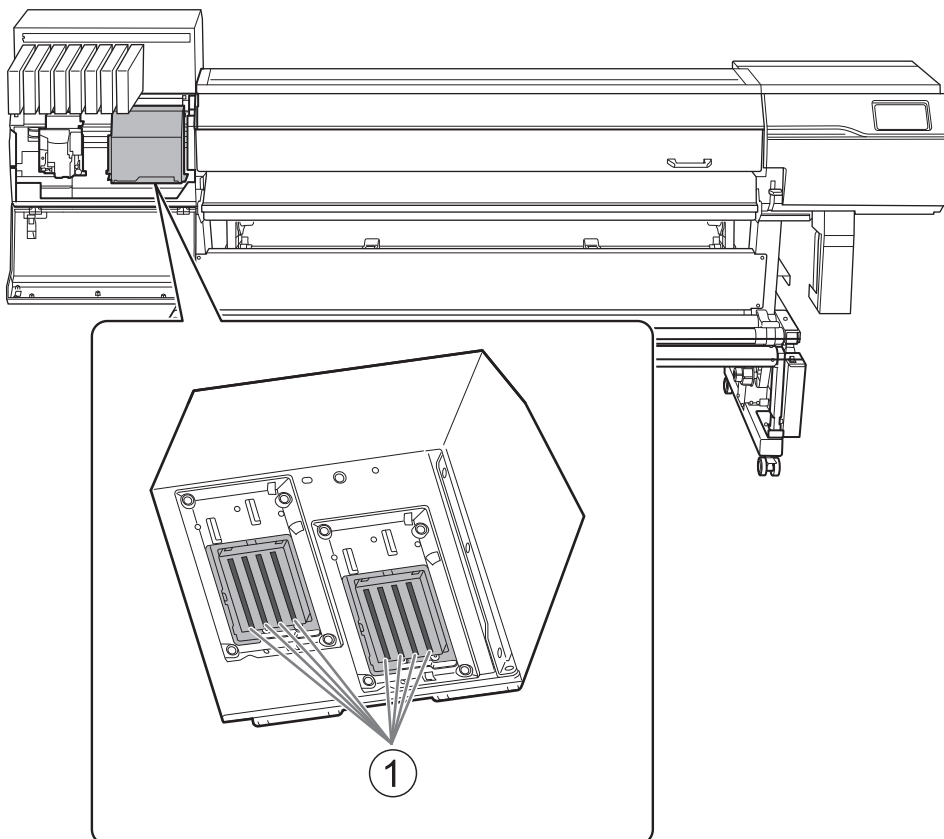


8. Very gently touch the cleaning stick against the print head surface (nozzle surface).

Very softly press the cleaning stick against the print head so that cleaning liquid soaks into the print head surface (nozzle surface). Never rub the stick on the surface or press it forcibly.

IMPORTANT

Mainly push the cleaning stick into the grooves on the head surface (①).



9. Close the left and right covers.

10. Tap [Finish All].

[Normal cleaning in progress.] is displayed at the top of the screen, and cleaning starts.

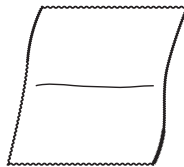
11. Tap  to go back to the original screen.

Operation Panel Cleaning Method

IMPORTANT

Important notes on this procedure

- The cloths, alcohol, and similar items used in cleaning are not included with the product.
- Be sure to use a cloth when cleaning the operation panel. Liquid entering into the operation panel through its gaps may cause printer malfunctions.

Required items	
	
Anhydrous ethanol or isopropyl alcohol	Cloth (that is not fluffy)

⚠ CAUTION

When using anhydrous ethanol or isopropyl alcohol, be sure to follow the product's usage precautions.

Exercise caution regarding items such as fire, ventilation, and rashes.

⚠ CAUTION

Only use anhydrous ethanol or isopropyl alcohol.

Using chemicals (or similar substances) other than anhydrous ethanol or isopropyl alcohol may lead to operation panel damage.

Procedure

1. Switch off the sub 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.

Replacing Consumable Parts

Replacing Parts for Maintenance	234
Replacing the Wiper	234
Replacing the Wiper Cleaner	239
Replacing the Print Head Caps	244
Replacing the Flushing Sponges	248
Replacing the Blade/Separating Knife.....	253
Replacing the Separating Knife	253
Inquiries for Consumable Parts and Products	256
Items That You Can Purchase and Replace by Yourself	256
Items That Require Inquiries before Replacement	256

Replacing Parts for Maintenance

Replacing the Wiper

The wiper periodically cleans the surface of the print heads.

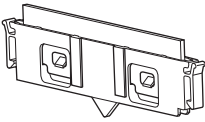
Replacement is necessary if the [The time for wiper replacement has arrived.] message appears.

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

⚠ WARNING

Be sure to perform operations as specified by the instructions, and never touch any area not specified in the instructions.

Sudden movement of the machine may cause injury.

Required items		
		
Wiper	Cleaning stick	Cleaning liquid

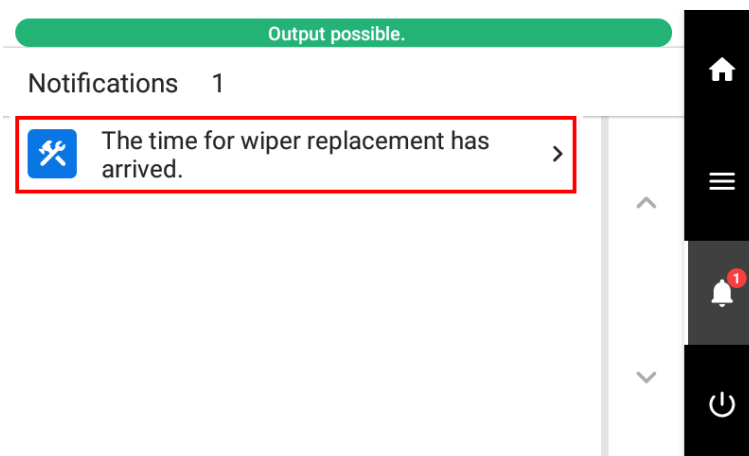
Procedure

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.].

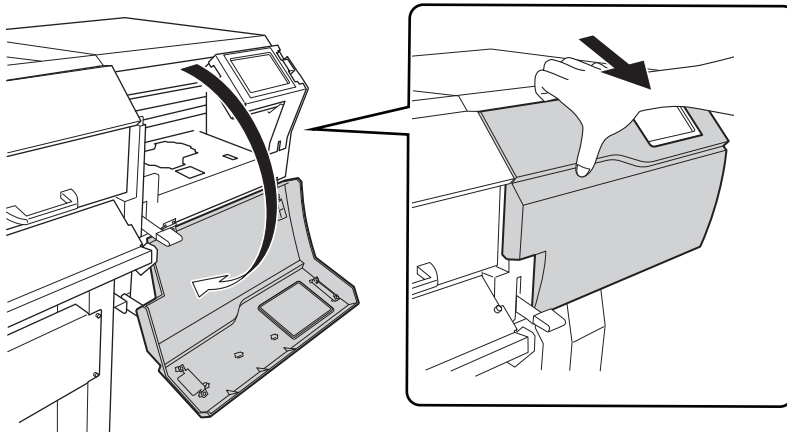


The [Wiper Replacement] screen appears.

5. Tap [Execute].

The print-head carriage moves to a location where wiper replacement is possible.

6. When [Open the right cover.] appears, open the right cover.

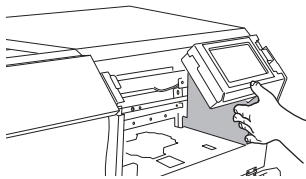


MEMO

The procedure is displayed on the operation panel.

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

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

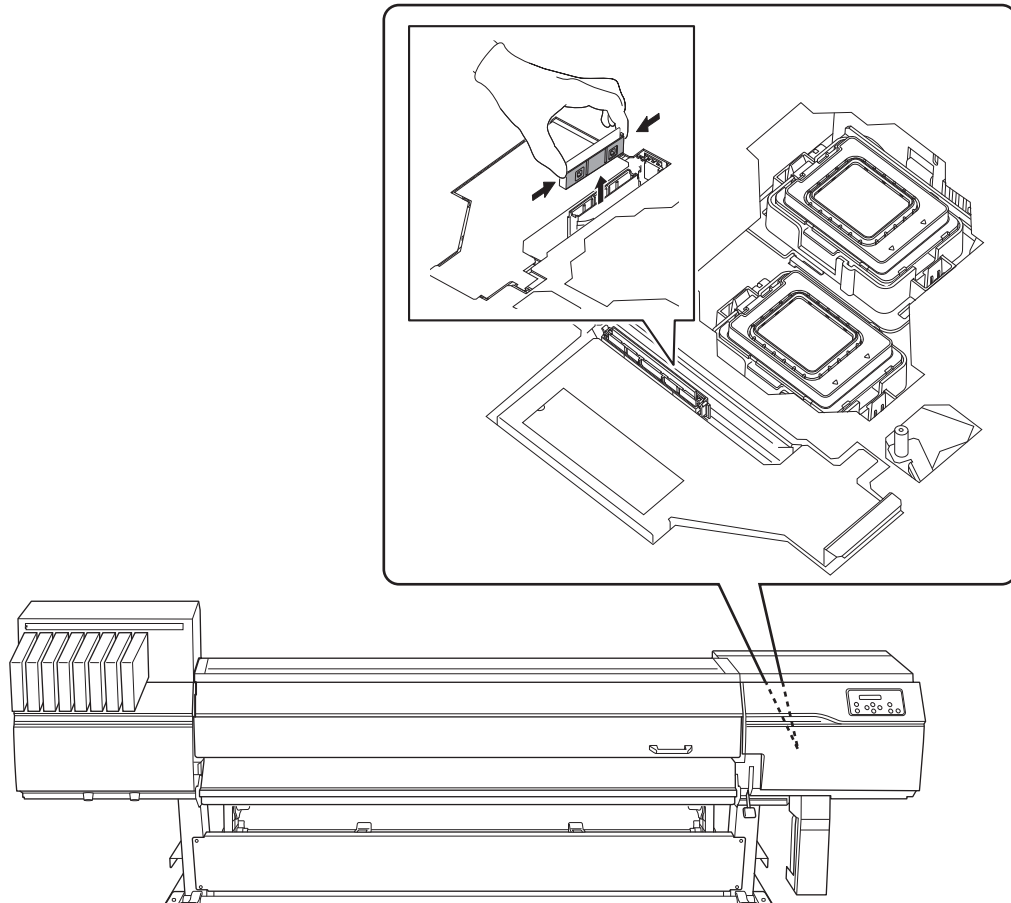


8. Tap [Finish All].

9. Replace the wiper.

- (1) Detach the old wiper.

While pressing the hooks on the left and right sides to release the locks, pull the wiper up and out.



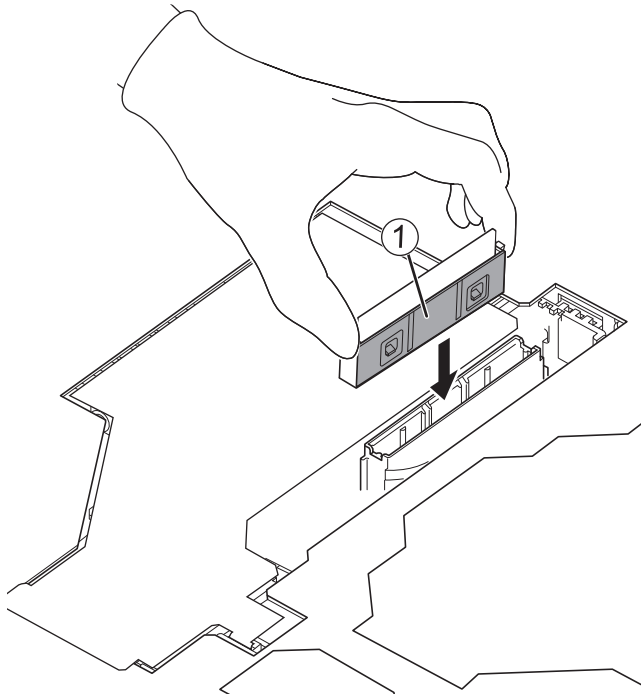
(2) Dispose of the detached, old wiper.

(3) Attach the new wiper.

Insert the wiper as shown in the figure. Hold the hooks on the left and right sides, pressing in just enough so that the locks are not released. Then, gently pull the wiper up and check that it is not removed.

MEMO

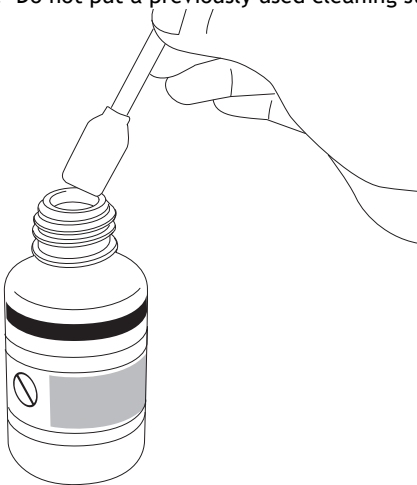
Install the wiper so that surface (1) faces to the right.



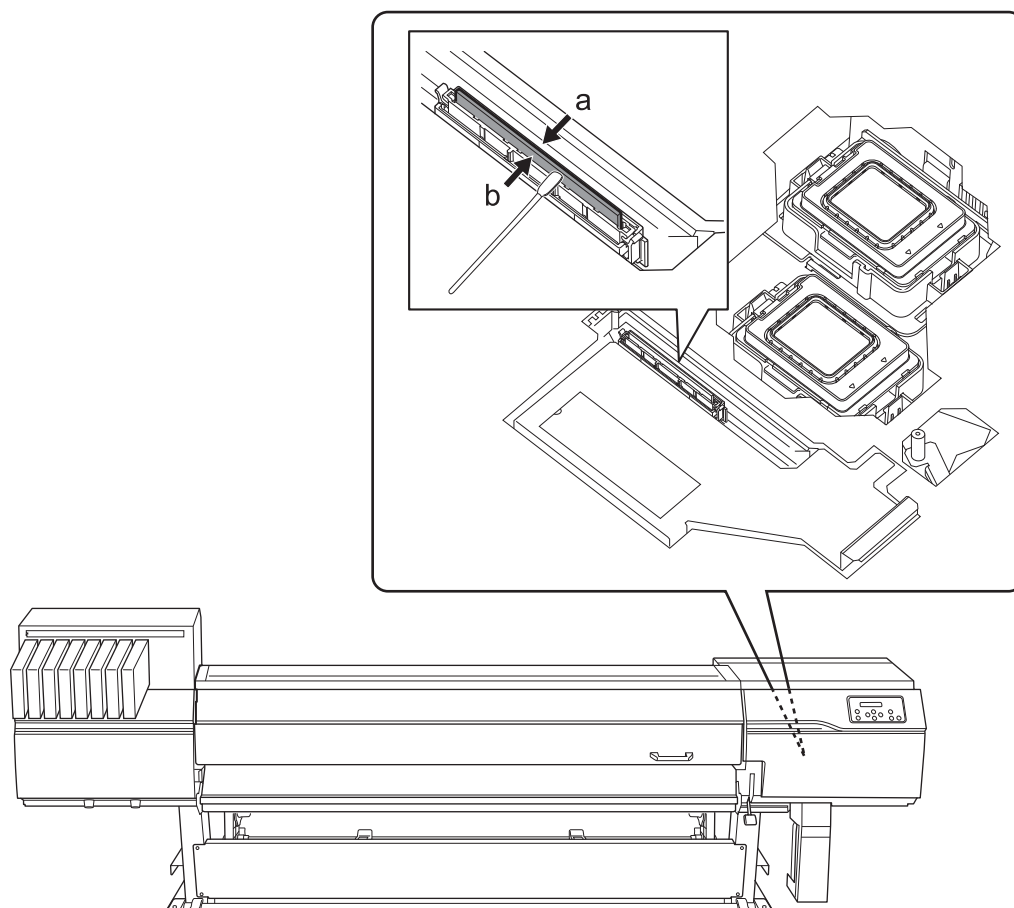
- 10. Moisten a new cleaning stick with the cleaning liquid.**

IMPORTANT

1. Be sure to use one of the included cleaning sticks.
2. Do not use a previously used cleaning stick.
3. Do not put a previously used cleaning stick into the cleaning liquid.



- 11. Wipe off wiper surfaces a and b with the cleaning stick.**



12. When the replacement of the wiper is complete, tap [Finish All].
13. When [Close the cover.] appears, close the right cover.
When you close the right cover, you are returned to the original screen.
14. Tap  to go back to the original screen.

Replacing the Wiper Cleaner

The wiper cleaner removes ink, dust, and similar substances that have adhered to the wiper during cleaning.

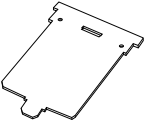
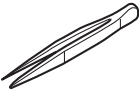
Replacement is necessary if the [The time for wiper cleaner replacement has arrived.] message appears.

For information about purchasing wiper cleaners, contact your authorized dealer or visit our website (<https://www.rolanddg.com>).

⚠ WARNING

Be sure to perform operations as specified by the instructions, and never touch any area not specified in the instructions.

Sudden movement of the machine may cause injury.

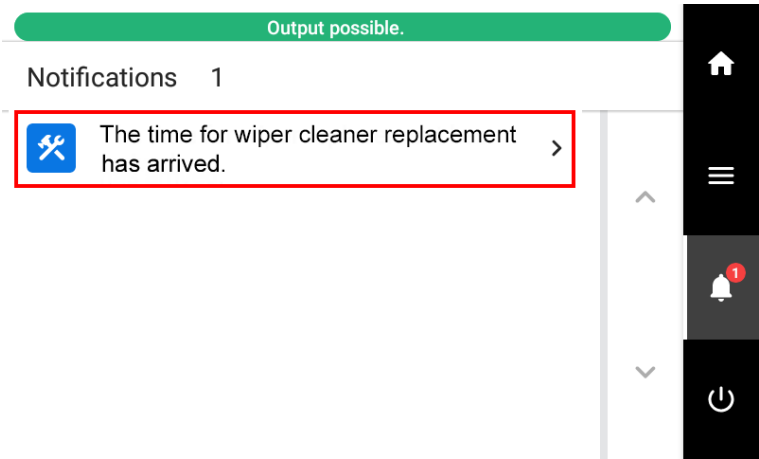
Required items			
			
Wiper cleaner	Tweezers	Cleaning stick	Cleaning liquid

Procedure

1. When the message [The time for wiper cleaner replacement has arrived.] appears, tap [OK].
2. Remove any media.

3. Tap  to display the messages.

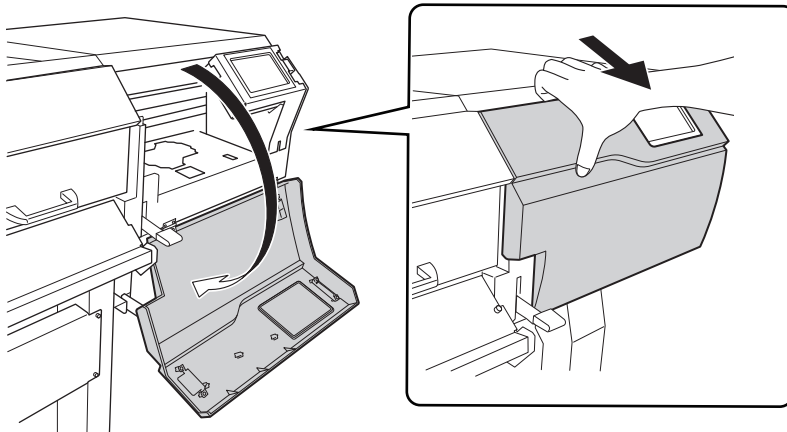
4. Tap [The time for wiper cleaner replacement has arrived.].



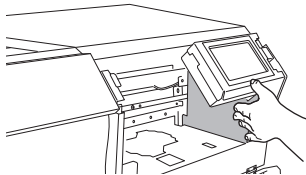
The [Wiper Cleaner Replacement] window appears.

5. Tap [Execute].
- The print-head carriage moves to a location where wiper cleaner replacement is possible.

6. When [Open the right cover.] appears, open the right cover.

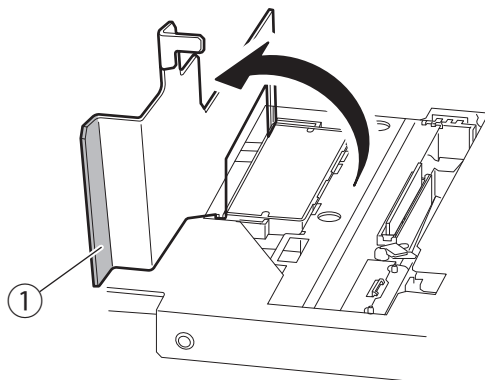


7. Touch the location shown in the figure to discharge any static electricity.



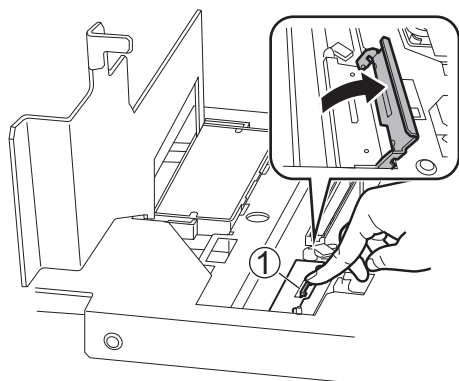
8. Tap [Finish].

9. When [Open the flushing cover.] is displayed, open the flushing cover while grasping the part indicated by ①.



10. Use a pair of tweezers to replace the wiper cleaner.

(1) While pressing the lock (①) down, open the wiper cleaner cover.

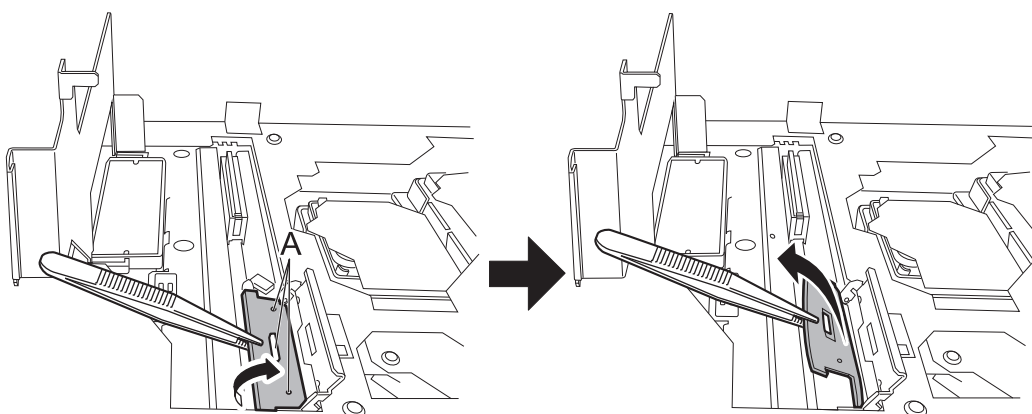


MEMO

The procedure is displayed on the operation panel.

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

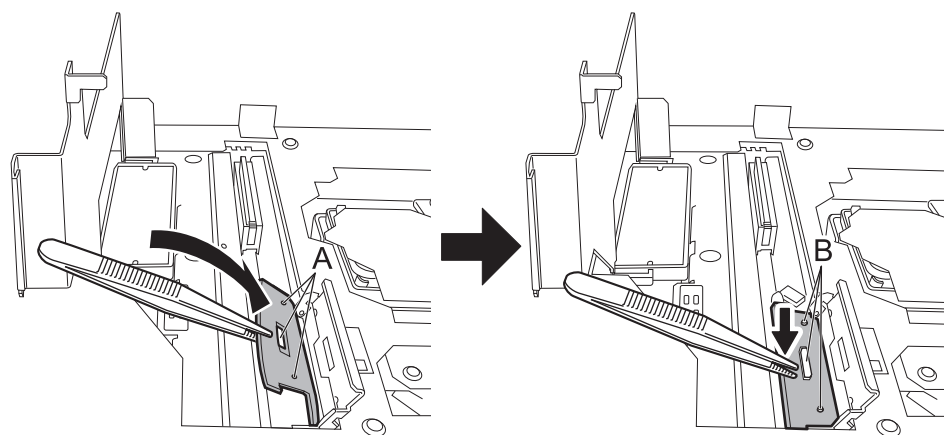
- (2) Remove the wiper cleaner from the protrusions (A) used for positioning, and then pull the cleaner up and out.



- (3) Dispose of the detached wiper cleaner.

- (4) Attach the new wiper cleaner.

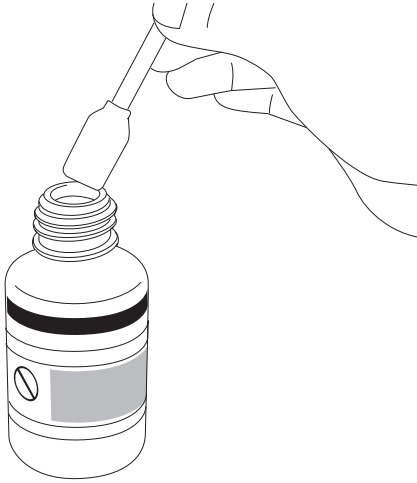
Insert the wiper cleaner so the holes (A) match the protrusions (B). The wiper cleaner does not have a specified front or back. They can be attached with either orientation.



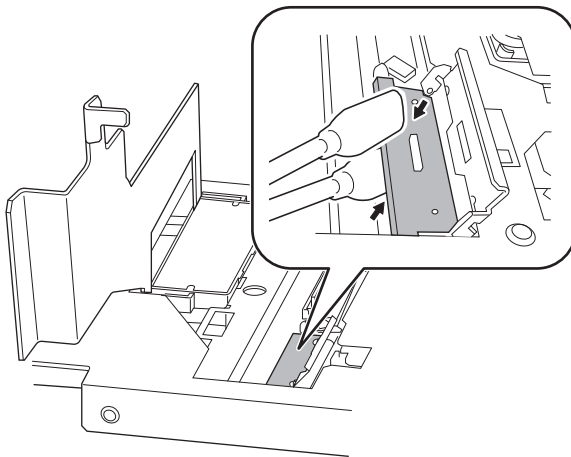
11. Moisten a new cleaning stick with the cleaning liquid.

MEMO

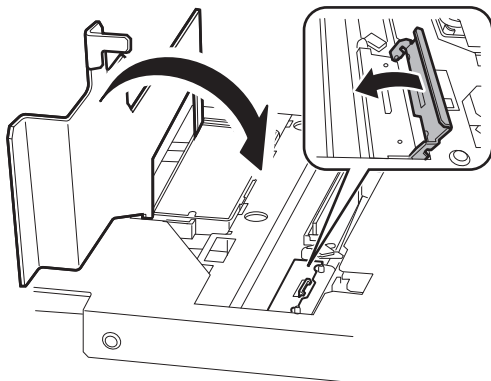
1. Be sure to use one of the included cleaning sticks.
2. Do not use a previously used cleaning stick.
3. Do not put a previously used cleaning stick into the cleaning liquid.



12. Push the cleaning stick against the top and bottom surfaces of the wiper cleaner to apply the cleaning liquid.



13. Close the wiper cleaner cover and the flushing cover.
Firmly push the flushing cover closed to ensure that it is locked.



14. When the replacement of the wiper is complete, tap [Finish All].

-
15. When [Close the cover.] appears, close the right cover.

When you close the right cover, you are returned to the original screen.

16. Tap  to go back to the original screen.

Replacing the Print Head Caps

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

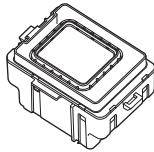
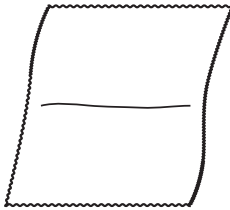
Replacement is necessary if the [The time for cap replacement has arrived.] message appears.

For information about purchasing print head caps, contact your authorized dealer or visit our website (<https://www.rolanddg.com>).

⚠ WARNING

Be sure to perform operations as specified by the instructions, and never touch any area not specified in the instructions.

Sudden movement of the machine may cause injury.

Required items		
		
Print head caps (2)	Cloth (that is not fluffy)	Cleaning stick

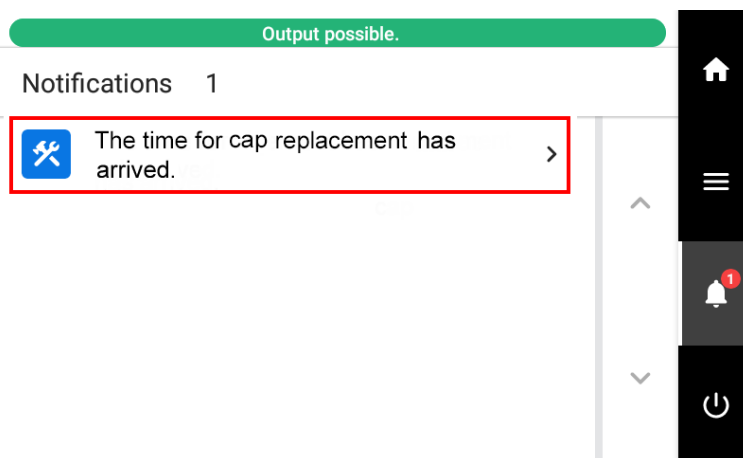
Procedure

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.].

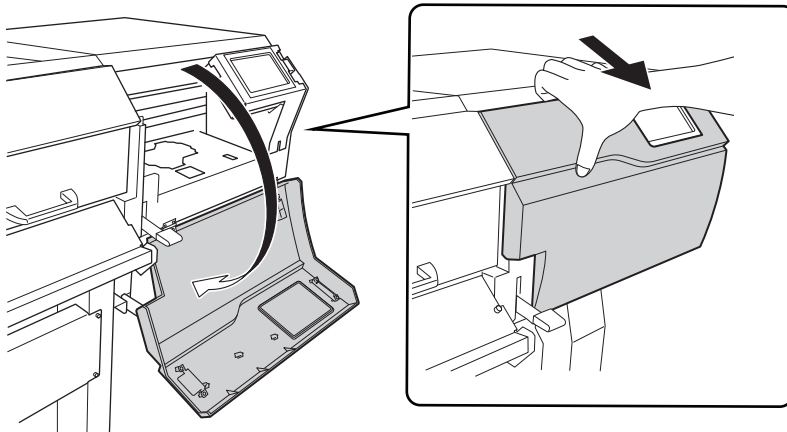


The [Cap Replacement] screen appears.

5. Tap [Execute].

The print-head carriage moves to a location where print head cap replacement is possible.

6. When [Open the right cover.] appears, open the right cover.

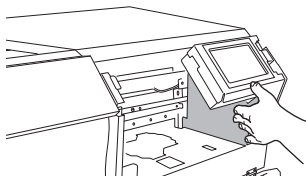


MEMO

The procedure is displayed on the operation panel.

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

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



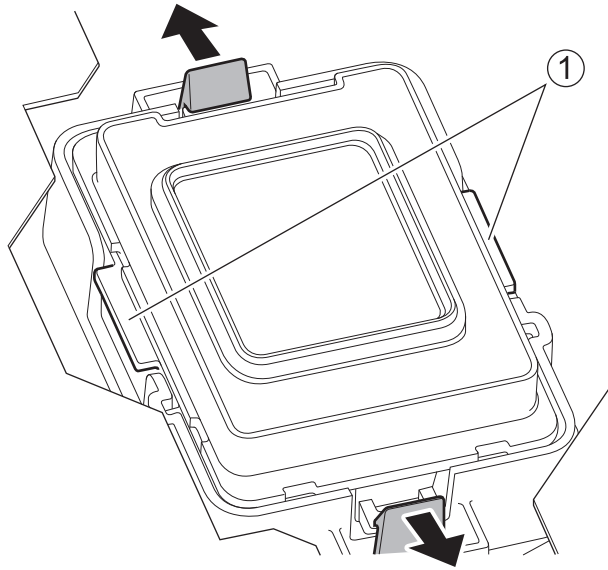
8. Replace the print head cap.

- (1) Grasp the protrusions on the print head cap (①), release the two hooks while gently pulling up, and then remove the print head cap.

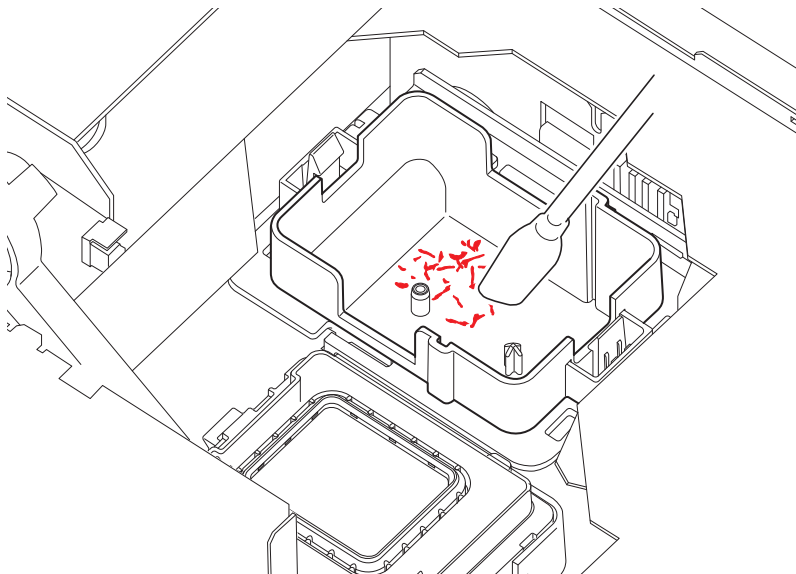
IMPORTANT

Ink may drip from the removed print head cap. Exercise caution to prevent this fluid from soiling your hands or the floor.

To prevent ink from adhering to your hands, the machine, or the floor, cover the bottom surface of the removed print head cap with paper towels or something similar.

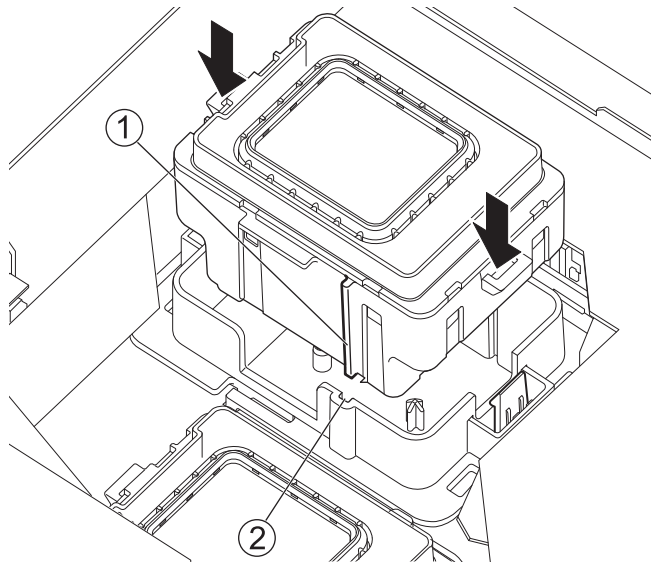


- (2) Dispose of the removed print head cap.
- (3) Wipe the print head cap case and the area around it free of dirt and ink with a cleaning stick or a cloth.



- (4) Align the protrusions on the new print head cap (①) with the slots (②), and then push the new cap in until it clicks.

Gently pull the print head cap up and check that it is not removed.



(5) Repeat steps (1) to (4) to replace the other print head cap.

9. When the print head cap replacement is finished, tap [Finish All].
10. When [Close the cover.] appears, close the right cover.
When you close the right cover, you are returned to the original screen.
11. Tap  to go back to the original screen.

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

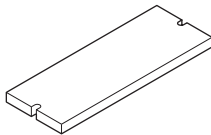
If the flushing sponge is not replaced after the message appears, the flushing sponge may not sufficiently absorb ink or cleaning liquid, resulting in an overflow.

For information about purchasing flushing sponges, contact your authorized dealer or visit our website (<https://www.rolanddg.com>).

⚠ WARNING

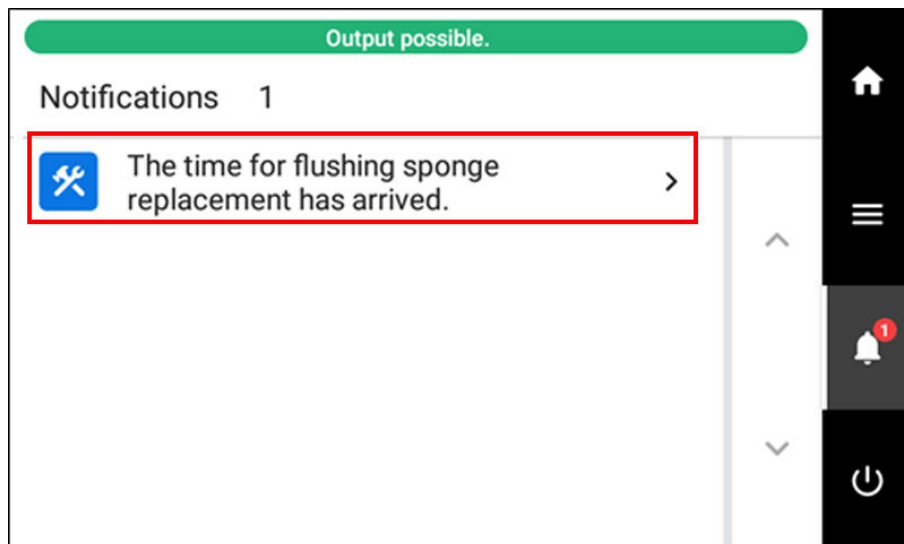
Be sure to perform operations as specified by the instructions, and never touch any area not specified in the instructions.

Sudden movement of the machine may cause injury.

Required items			
			
Flushing sponge	Tweezers	Dropper	Cleaning liquid

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.].

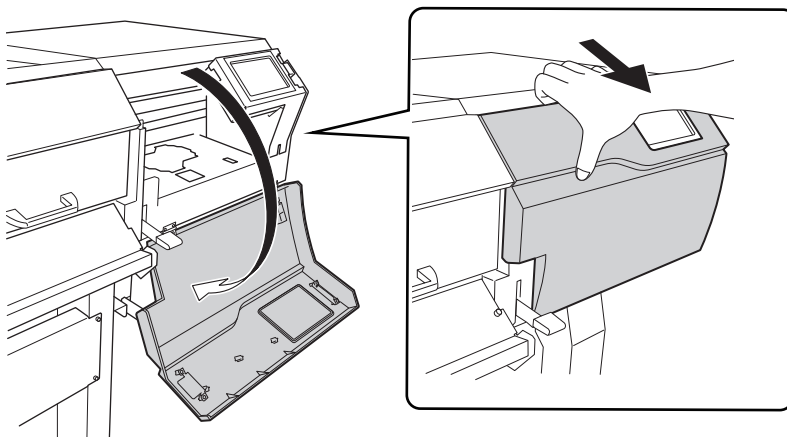


The [Flushing Sponge Replacement] window appears.

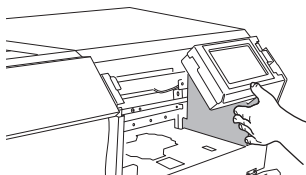
5. Tap [Execute].

The sub carriage moves to a location where flushing sponge replacement is possible.

6. When [Open the right cover.] appears, open the right cover.

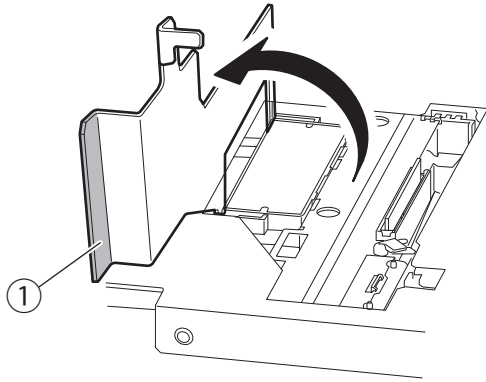


7. Touch the location shown in the figure to discharge any static electricity.



8. Tap [Finish].

9. When [Open the flushing cover.] is displayed, open the flushing cover while grasping the part indicated by ①.



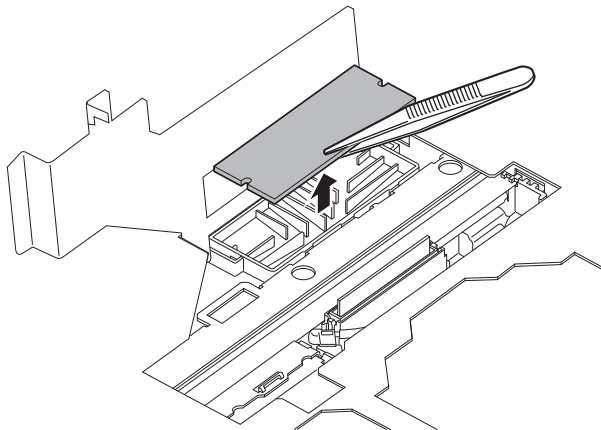
MEMO

The procedure is displayed on the operation panel.

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

10. Replace the flushing sponge.

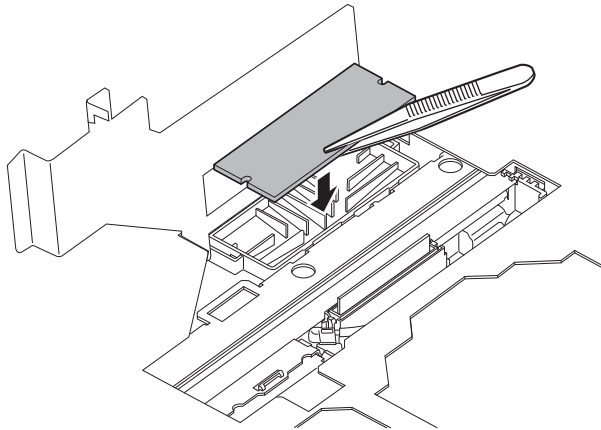
- (1) Using tweezers, remove the old flushing sponge.



- (2) Dispose of the removed flushing sponge.
- (3) Using tweezers, attach a new flushing sponge.

IMPORTANT

Flushing sponges do not have a specified front or back. They can be attached with either orientation.



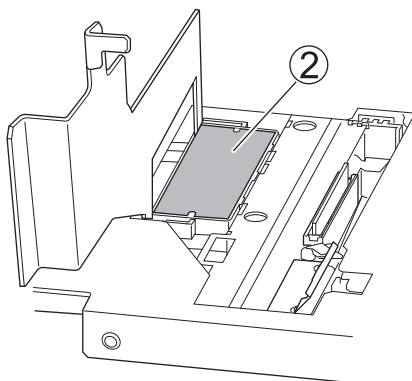
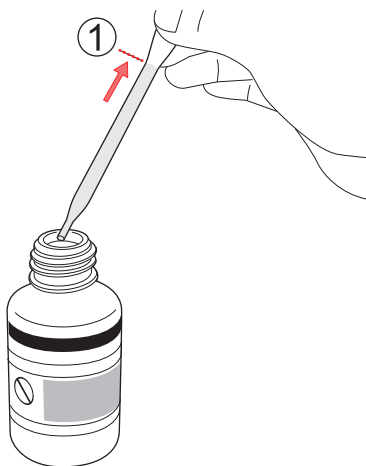
11. Suction out some cleaning liquid with the dropper, and then drip this cleaning liquid in the location indicated in the following figure.

Use the included dropper.

Firmly squeezing the dropper and suctioning out the cleaning liquid (①) fills the dropper with enough cleaning liquid for one location. In each location, use all the suctioned out cleaning liquid. In this procedure, drip the cleaning liquid in one location. Drip the cleaning liquid on the surface (②) of the flushing sponge.

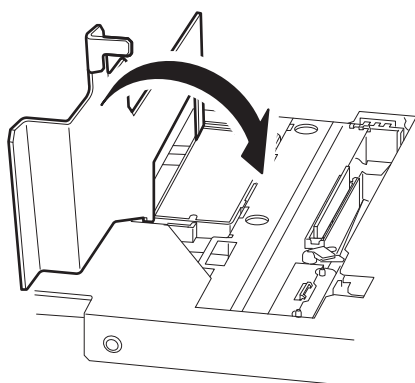
IMPORTANT

A low amount of cleaning liquid in this location may lead to poor printing quality.



12. When the flushing sponge replacement is finished, tap [Finish All].

- 13.** When [Close the cover.] is displayed, close the flushing cover.



- 14.** Close the right cover.

When you close the right cover, you are returned to the original screen.

- 15.** Tap  to go back to the original screen.

Replacing the Blade/Separating Knife

Replacing the Separating Knife

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

⚠ CAUTION

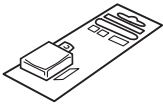
Be sure to perform operations as specified by the instructions, and never touch any area not specified in the instructions.

Otherwise sudden movement of the machine may cause injury.

⚠ CAUTION

Do not touch the tip of the separating knife.

Doing so may result in injury.

Required item

Replacement blade for separating knife

Procedure

1. Remove any media.
2. Tap .
3. Tap [Maintenance]>[Separating Knife Replacement].
The [Separating Knife Replacement] screen appears.
4. Tap [Execute].
The sub carriage moves to a position where separating knife replacement is possible.
5. When [Open the front cover.] appears, open the front cover.

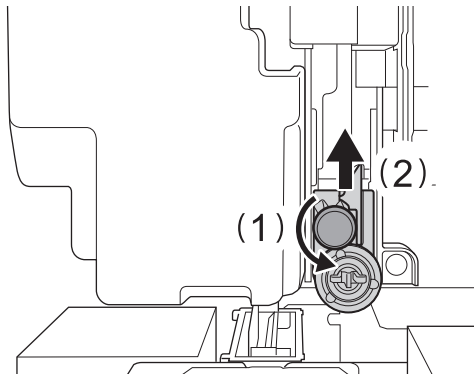
MEMO

The procedure is displayed on the operation panel.

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

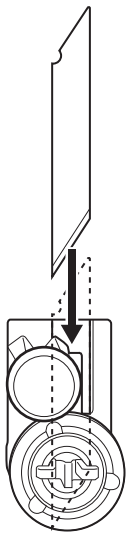
6. Remove the separating knife.
 - (1) Loosen the screw until it slips out.
 - (2) Grasp the screw portion, and slowly pull in the direction of the arrow.

When doing this, do not pull it back toward you.

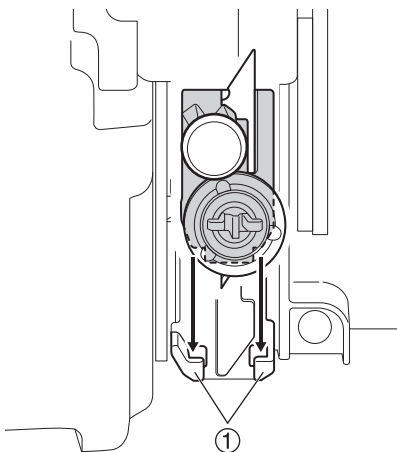


7. Install a new knife.

Slide the knife to align it with the groove.

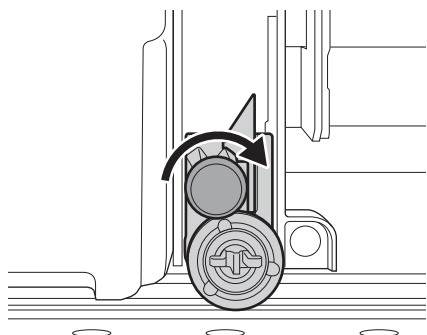


8. Slowly insert the separating knife holder into the grooves indicated with ①.



9. Tighten the screw.

Take care to ensure that the knife does not slip out of position at this time.

**MEMO**

Do not overtighten the screw.

10. When the separating knife replacement is finished, tap [Finish All].
11. When [Close the cover.] appears, close the front cover.
When you close the front cover, you are returned to the original screen.
12. Tap  to go back to the original screen.

Inquiries for Consumable Parts and Products

Items That You Can Purchase and Replace 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. 234 Replacing the Wiper
Wiper cleaner	P. 239 Replacing the Wiper Cleaner
Print head caps	P. 244 Replacing the Print Head Caps
Flushing sponge	P. 248 Replacing the Flushing Sponges
Cleaning sticks	P. 199 Manual Cleaning Method
Cleaning liquid	
Dropper	
Separating knife	P. 253 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. 198 Cleaning around the Print Heads

Troubleshooting Methods

Output Quality Problems

Printed results are coarse or contain horizontal stripes.....	259
Do the print heads cause dot drop-out?	259
Is the print head height appropriate?	259
Have you carried out [Feed Correction] ?	259
Have you carried out [Media Gap Adjustment] (ink landing position correction)?.....	259
Is the printer installed in a level and stable location?	260
Is the media heating system at a suitable temperature?	260
Is the temperature of the room too low?	260
Is the print mode suitable?	260
Is the media loaded correctly?	260
Are the [Media Settings] appropriate?	260
The media becomes soiled when printed	261
Do the print heads come into contact with the media?	261
Are the print heads dirty?.....	261
Are the pinch rollers or the media clamps dirty?	261
Colors are unstable or uneven.....	262
Did you shake the ink cartridges before installing them?	262
Is the media wrinkled?	262
Was printing paused partway through?	262
Is the printer installed in a level and stable location?	262
Is the media loaded correctly?	262
Are the operating parameters set to appropriate values?	263
Are the [Media Settings] appropriate?	263

Printed results are coarse or contain horizontal stripes

Do the print heads cause dot drop-out?

Carry out a printing test and make sure no dot drop-out or dot displacement occurs.

If dot drop-out or dot displacement is present, perform head cleaning.

RELATED LINKS

- [P. 194 Performing a Printing Test](#)
- [P. 215 Normal Cleaning Method](#)
- [P. 217 When Normal Cleaning Is Not Effective](#)

Is the print head height appropriate?

Printing when the [Print Head Height] menu item is set to [High] 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. 122 Changing the Print Head Height](#)

Have you carried out [Feed Correction]?

Large misalignment in the amount of feed of the media may result in printing that seems coarse or contains horizontal bands. Either make the setting in the software RIP to match the type of media you are using, or make the setting for correction on the printer.

RELATED LINKS

- [P. 116 Automatically Making Required Adjustments](#)
- [P. 117 Manual Adjustment: Reducing Horizontal Bands \(Feed Correction\)](#)

Have you carried out [Media Gap Adjustment] (ink landing position correction)?

The optimal adjustment value varies depending on the thickness of the media. Set an adjustment value that is suitable for the media. When further correction is required, such as when adjustment made using [Simple Correction (Auto)] does not enhance printing, use [Detailed Correction (Manual)] to make the correction.

RELATED LINKS

- [P. 116 Automatically Making Required Adjustments](#)
- [P. 120 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 media heating system at a suitable temperature?

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

RELATED LINKS

- [P. 132 Setting the Print Heater Temperature](#)
- [P. 134 Setting the Dryer Temperature](#)

Is the temperature of the room too low?

The media heating system may not warm up sufficiently when the ambient temperature is less than 20°C (68°F). Also, even when the media heating system reaches its set temperatures, adequate effectiveness may not be apparent if the media is thoroughly chilled. Before printing, allow the media to come to room temperature.

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 software RIP (such as the color-profile selection). Select settings appropriate for the media you are using.

Is the media loaded correctly?

If the media is not loaded correctly or the media feed is not smooth, printing may be adversely affected. Load the media correctly.

RELATED LINKS

- [P. 30 Setup of New Media](#)
- [P. 65 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. 159 Changing the Media Settings](#)

The media becomes soiled when printed

Do the print heads come into contact with the media?

The height of the print heads may be too low. Also, if the media is not loaded and set up correctly, it may wrinkle or come loose and contact the print heads.

RELATED LINKS

- [P. 122 Changing the Print Head Height](#)
- [P. 30 Setup of New Media](#)
- [P. 65 Setup of Registered Media](#)

Are the print heads dirty?

The following may cause ink to drip on the media during printing.

- Buildup of fibrous dust (lint) around the heads
- Ink transferred to the heads due to rubbing against the media

If this happens, perform manual cleaning. We recommend carrying out periodic head cleaning.

- Too low humidity

Use the machine in an environment of 35 to 80% RH (no condensation).

RELATED LINKS

- [P. 198 Cleaning around the Print Heads](#)

Are the pinch rollers or the media clamps dirty?

Periodically clean them.

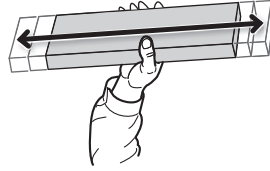
RELATED LINKS

- [P. 195 Cleaning the Machine](#)

Colors are unstable or uneven

Did you shake the ink cartridges before installing them?

Before installing a new ink cartridge, be sure to shake it gently.



RELATED LINKS

- [P. 104 Replacing Ink Cartridges](#)

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. 30 Setup of New Media](#)
- [P. 65 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.

Is the printer installed in a level and stable location?

Never install the machine in a location where it is tilted or where it may wobble or experience vibration. Also make sure that the print heads are not exposed to moving air. These factors may lead to dot drop-out or reduced printing quality.

Is the media loaded correctly?

If the media is not loaded correctly or the media feed is not smooth, printing may be adversely affected. Load the media correctly.

RELATED LINKS

- [P. 30 Setup of New Media](#)
- [P. 65 Setup of Registered Media](#)

Are the operating parameters set to appropriate values?

Depending on the settings for [Printing Movement Range] and [Cleaning during Printing], uneven colors may occur. If the settings have been changed, try restoring them to their default values.

RELATED LINKS

- [P. 166 Speeding Up Output for Narrow Media](#)
- [P. 127 Preventing Soiling of the Media, Dot Drop-out, and Dot Displacement](#)

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. 159 Changing the Media Settings](#)

Media Feed Problems

Media Wrinkles or Shrinks	265
Is the media loaded and set up straight and securely?	265
Was loaded media allowed to stand for some time?	265
Are the media clamps installed?	265
Was the media loaded while the print heater and dryer were hot?	265
Is the temperature of the room too low?	265
Is the humidity of the room too high?	265
Is the media sagging?	265
Media Feeding Is Not Straight	266
Is the media loaded and set up straight and securely?	266
Media Feeding Is Not Smooth	267
Is some other object coming into contact with the media?	267
Is the media too thick?	267
Are the grit rollers dirty?	267
A Media Jam Occurs!	268
Is an error message displayed?	268
Is the media warped or wrinkled?	268
Is the height of the print heads too low?	268
Are the grit rollers dirty?	268
Are the media clamps installed?	268
Is the media loaded and set up straight and securely?	268
Is some other object coming into contact with the media?	269
Is the media too thick?	269

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. 30 Setup of New Media](#)
- [P. 65 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?

Install the media clamps when performing printing.

Was the media loaded while the print heater and dryer were hot?

Loading media after the print heater and dryer have 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 platen and apron to cool.

RELATED LINKS

- [P. 130 Adjusting the Ink-drying Method](#)

Is the temperature of the room too low?

The media heating system may not warm up sufficiently when the ambient temperature is less than 20°C (68°F). Also, even when the media heating system reaches its set temperatures, adequate effectiveness may not be apparent if the media is thoroughly chilled. Before printing, allow the media to come to room temperature.

Is the humidity of the room too high?

Use the machine in an environment of 35 to 80%RH (no condensation).

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. 30 Setup of New Media](#)
- [P. 65 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. 30 Setup of New Media](#)
- [P. 65 Setup of Registered Media](#)

Is the media too thick?

Media that is too thick may not only cause an unstable feed but may scrape the print heads, resulting in a malfunction. Never use such media.

Are the grit rollers dirty?

Check to make sure the grit rollers are free of buildup of foreign material such as media scraps.

RELATED LINKS

- [P. 195 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. 284 \[Motor Error\]](#)

Is the media warped or wrinkled?

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

RELATED LINKS

- [P. 265 Media Wrinkles or Shrinks](#)

Is the height of the print heads too low?

If the media jams, set the print heads to the **[High]** position. Media may inevitably warp or wrinkle slightly, so adjust the height of the print heads to take this into account.

RELATED LINKS

- [P. 122 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. 195 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. 30 Setup of New Media](#)
- [P. 65 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. 30 Setup of New Media](#)
- [P. 65 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.

Machine Problems

Why Has the Print-Head Carriage Stopped Moving?	271
What to Do First	271
If the Print Heads Still Do Not Move	271
The printer unit does not run.....	273
Is the power switched on?	273
Is [Output possible.] displayed?	273
Are any covers open?	273
Is a message displayed on the screen?	273
Are the cables connected?	273
Is the LAN routing appropriate?	274
Are the LAN settings correct?	274
Did the Software RIP End Abnormally?	274
Is an [Ink Cartridge Error] displayed?	274
Cannot Separate the Media	276
Is the separating knife installed?	276

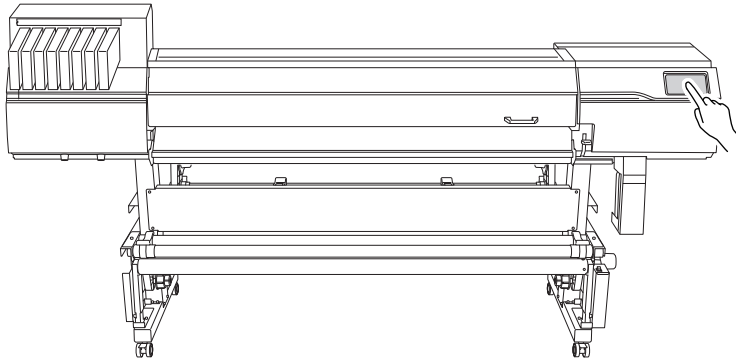
Why Has the Print-Head Carriage Stopped Moving?

If the print-head carriage stops over the platen, take action immediately to prevent the heads from drying out.

What to Do First

Switch the sub power off and then back on again. If the media is jammed, also remove the media.

If the print-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

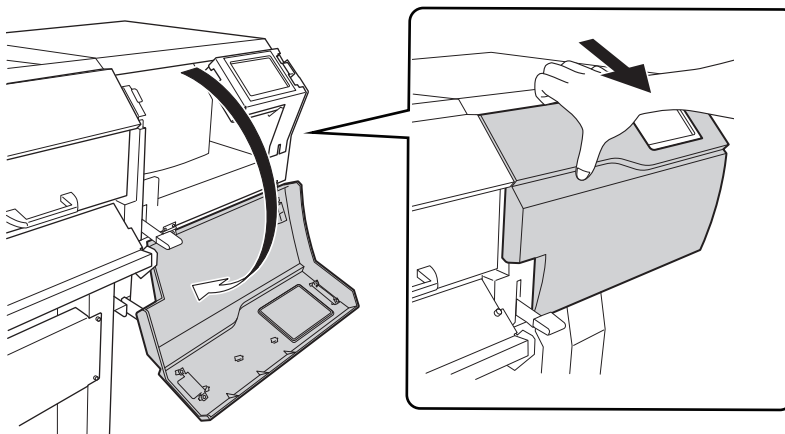
Switch off the sub power, followed by the main power. Then, switch on the main power again, followed by the sub power.

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.

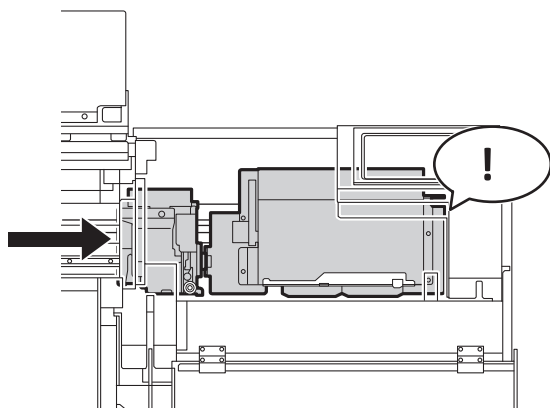
Procedure

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, and then switch on the sub power and make sure the sub power icon lights.

RELATED LINKS

- [P. 26 Turning the Power On](#)

Is [Output possible.] displayed?

Output is not performed when [Output possible.] is not displayed at the top of the operation panel. After loading the media and lowering the loading lever, tap  [Setup]. Follow the instructions on the screen

to finish setting up the media. Also, when operating the setting menu, output doesn't start when data is sent from the computer with some menu items. When you return to a menu item where output is possible

or tap  to return to the home screen, output starts.

RELATED LINKS

- [P. 112 Starting Output](#)

Are any covers open?

Close the external covers (front, left, and right covers) and flushing cover.

Is a message displayed on the screen?

Follow the prompts and take action accordingly.

RELATED LINKS

- [P. 278 Messages](#)
- [P. 282 Error Messages](#)

Are the cables connected?

Connect the cables securely.

For details on cable connections, see the "Setup Guide."

RELATED LINKS

- [Setup Guide](#)

Is the LAN routing appropriate?

Check whether or not the network routing is appropriate. Try connecting the computer and the machine to the same hub or connecting them directly using a cable. If this makes it possible to perform output, it means the problem may be in the network itself.

Are the LAN settings correct?

If the cable connections are secure and no problem is found in the network itself, make sure that the IP address and other such settings are appropriate. The settings on both the machine and the computer must be appropriate. Redo the settings, checking to ensure that the IP address does not conflict with the IP address for another device on the network, that the port setting for the software RIP specifies the IP address set on the machine, that the settings have no typing errors, and for other such problems.

For details on the LAN settings, see the "Setup Guide."

RELATED LINKS

- [P. 180 Viewing Printer Information](#)
- [Setup Guide](#)

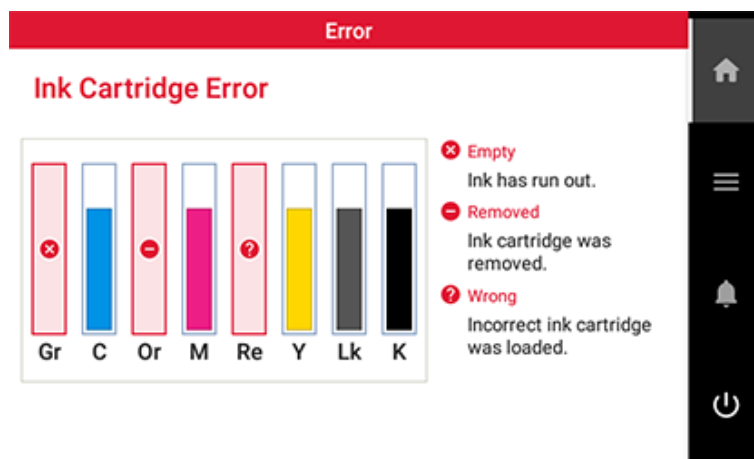
Did the Software RIP End Abnormally?

Make sure the software RIP is running correctly, then switch the sub power switch 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. The error can be resolved by replacing the ink cartridge with a new one. If there is data that has not yet been output remaining in the machine, output resumes. If there is unsent data in the computer, output resumes when the data is resent.

When ink runs out

Replace the empty ink cartridge with a new one.

When an ink cartridge with the incorrect color is loaded

Remove the ink cartridge that was loaded incorrectly and load the 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. 282 \[Ink Cartridge Error\]](#)
- [P. 104 Replacing Ink Cartridges](#)

Cannot Separate the Media

Is the separating knife installed?

If the separating knife is not installed, you cannot separate the media.

RELATED LINKS

- [P. 253 Replacing the Separating Knife](#)

Messages on the Operation Panel

Messages	278
[When output, cleaning, and other operations are completed, discard the discharged fluid.]	278
[The time for manual cleaning has arrived.]	278
[Maintenance must be performed. Perform manual cleaning.]	278
[The time for wiper replacement has arrived.]	278
[The time for wiper cleaner replacement has arrived.]	278
[The time for cap replacement has arrived.]	279
[The time for flushing sponge replacement has arrived.]	279
[Print head protection mode has activated.]	279
[The extended dryer is not connected.]	279
[Operation of the take-up unit stopped.]	279
[Follow the instructions in the figure and correct the error.]	279
[Install the media clamps correctly.]	280
[Media clamps could not be detected.]	280
[The LAN cable is not connected.]	280
[Connection is requiring too much time. Manually setting the IP address will improve the connection speed.]	280
[The media could not be detected automatically. Manually set the printing area.]	281
[Turn on the power. Cleaning will start.]	281
Error Messages	282
[Ink Cartridge Error]	282
[Cover Open Error]	282
[Media End Error]	282
[Pinch Lever Error]	282
[Media Loading Error]	283
[Drain Bottle Error]	283
[Maintenance Cleaning]	283
[Print Head Height Mismatch]	283
[Insufficient Media Width]	284
[Motor Error]	284
[Print Head Dry-out Error]	285
[Low Temperature Error]	285
[High Temperature Error]	285
[Pump Stop Error]	285
[Cleaning Error (Ink Cartridge)]	285
[Take-up Unit Communication Error]	286
[Service Call]	286
[Software error]	286

Messages

These are the main messages that appear on the machine's display to prompt correct operation. They do not indicate any error. Follow the prompts and take action accordingly.

[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. 212 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. 199 Manual Cleaning Method](#)

[Maintenance must be performed. Perform manual cleaning.]

This message appears when more than 2 weeks have elapsed since manual cleaning was last performed.

If you do not perform manual cleaning, you will not be able to perform setup of media or any cleaning other than manual cleaning.

Tap **[Maintenance must be performed. Perform manual cleaning.]>[Execute]** to perform manual cleaning.

RELATED LINKS

- [P. 199 Manual Cleaning Method](#)

[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. 234 Replacing the Wiper](#)

[The time for wiper cleaner replacement has arrived.]

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

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

RELATED LINKS

- [P. 239 Replacing the Wiper Cleaner](#)

[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. 244 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. 248 Replacing the Flushing Sponges](#)

[Print head protection mode has activated.]

This message appears when the ink in use may not be a product specified by Roland DG Corporation.

If the ink is not a product specified by Roland DG Corporation, a larger amount of ink will be consumed, and drying will be performed frequently. To obtain optimal performance, we recommend that you use ink specified by Roland DG Corporation. To purchase ink, contact your authorized dealer.

[The extended dryer is not connected.]

This message appears when the extended dryer is not connected and [Media Settings]>[Heater Settings] is set to [Enable].

Switch the sub power and main power off, and then connect the extended dryer to the printer. When not using the extended dryer, set Extended Dryer to [Disable] in the Media Settings.

[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.

[Follow the instructions in the figure and correct the error.]

This message is displayed when the media holders are not properly attached to the paper tube or when it is not possible to detect the position of the dancer roller for a continuous length of time.

Follow the instructions on the screen to set the media holders or take-up unit.

[Install the media clamps correctly.]

This message appears when the media clamps are not placed at the predetermined positions.

Check the loading status of the media and that the pinch rollers have been positioned correctly, and then correctly set the media clamps at the ends of the media.

RELATED LINKS

- [P. 30 Setup of New Media](#)
- [P. 65 Setup of Registered Media](#)

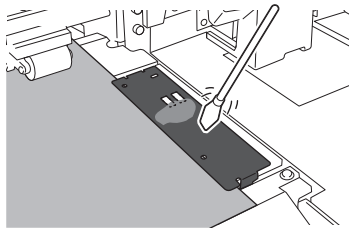
[Media clamps could not be detected.]

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. 30 Setup of New Media](#)
- [P. 65 Setup of Registered Media](#)

[The LAN cable is not connected.]

This message appears when the machine and a computer are not connected with a LAN cable.

Properly connect the LAN cable.

[Connection is requiring too much time. Manually setting the IP address will improve the connection speed.]

This message appears when automatic IP address acquisition is enabled and the machine connects to a network on which no DHCP server exists while this automatic acquisition is in progress.

Connect to a network on which a DHCP server exists or disable automatic IP address acquisition and set a fixed IP address.

[The media could not be detected automatically. Manually set the printing area.]

This message appears when media with high reflectance is set up. Manually set the printing area.

The [Sheet Settings] screen appears. Configure the settings as shown below depending on the sheet type.

- [Sheet Width] setting
 1. Tap [Sheet Width].
 2. Enter the sheet width and tap [OK].
- [Sheet Right Edge] setting
 1. Tap [Change] next to [Sheet Right Edge].
 2. Tap  or  to move the sub carriage's base point mark to the right edge of the media.
 3. Tap [OK].
- [Side Margin] setting
 1. Tap [Side Margin] to set the margin.
You can select 5 mm (0.2 in.), 10 mm (0.39 in.), or 25 mm (0.98 in.).
 2. Tap [OK].

[Turn on the power. Cleaning will start.]

This message appears when the following situations occur 8 hours or more after the previous cleaning.

- An ink cartridge is empty or an ink cartridge has not been 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. 104 Replacing Ink Cartridges](#)
- [P. 210 Disposing of Discharged Fluid](#)

Error Messages

This section describes the error messages that may appear on the machine's display, and how to take action to remedy the problem. If the action described here does not correct the problem or if an error message not described here appears, contact your authorized Roland DG Corporation 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.]

Replace the ink cartridge with a new one.

- When an ink cartridge is removed

 **[Ink cartridge was removed.]**

Load the removed ink cartridge.

- When an ink cartridge with the incorrect color is loaded

 **[Incorrect ink cartridge was loaded.]**

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

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

[Cover Open Error]

An external cover (front, left, or right cover) or the flushing cover is open.

For safety, some carriage operations are limited while a cover is open. Close all external covers (front, left, and right covers) and the flushing cover.

[Media End Error]

This message appears when one of the following situations is detected.

- Insufficient remaining media during take-up unit setup or printing output
- No media during media feeding

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 error is displayed for one of the following reasons.

- This message appears when opaque media whose width is insufficient is loaded.
Raise the loading lever, prepare media that are 259 mm (10.2 in.) or more in width, and then set up the media again.
- This message appears when opaque media is caught and loose at the entrance of the dryer.
Raise the loading lever, remove the cause of the media becoming loose, and then set up the media again.

RELATED LINKS

- [P. 30 Setup of New Media](#)
- [P. 65 Setup of Registered Media](#)

[Drain Bottle Error]

This message appears when the drain bottle has reached its limit for discharged fluid.

Discard the discharged fluid in the drain bottle, and then attach this bottle again.

MEMO

When the drain bottle is detached, the error message changes to [Install the drain bottle.].

This message appears when the drain bottle is misaligned.

Install the drain bottle again.

[Maintenance Cleaning]

This message appears when more than 2 weeks have elapsed since manual cleaning was last performed.

Media setup cannot be completed if manual cleaning is not performed.

Perform manual cleaning.

RELATED LINKS

- [P. 199 Manual Cleaning Method](#)

[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. 122 Changing the Print Head Height](#)

[Insufficient Media Width]

[The print data is larger than the media width. Continue output?]

This message appears when the size of the printing data is larger than the printing area of the loaded media.

To continue performing output without making corrections, tap **[Continue Output]**. At this time, the portion extending beyond the printing area is not output.

To cancel output, tap **[Cancel]**. Make the printing area wider, for example, by replacing the media with a larger piece of media, and then send the data again.

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?]

This message appears when one of the following situations is detected.

- The size of the data with crop marks is larger than the printing area of the loaded media.
- The width of the printing data is 60 mm (2.36 in.) or less.

To continue performing output without making corrections, tap **[Continue Output]**. The data is output without printing the crop marks.

To cancel output, tap **[Cancel]**. Make the printing area wider, for example, by replacing the media with a larger piece of media, and then send the data again.

The size of the data being output is too small.

Make the horizontal-direction (scan-direction) size of the data at least 60 mm (2.6 in.). To continue performing output without making corrections, tap **[Continue Output]**. At this time, the data is output without printing the crop marks.

To stop output, stop sending data from the computer, and then raise the loading lever. Increase the size of the data, and then send the data again.

MEMO

There is no limitation on the size of the data in the media-feed (FEED) direction.

[Motor Error]

A motor error occurred.

Operation cannot be continued. Turn off the sub power. Next, eliminate the cause of the error, then immediately switch on the sub power.

If the machine is allowed to stand with the error uncorrected, the print heads may dry out and become damaged. This error may be caused by such factors as a mistake in loading the media, a media jam, or an operation that pulls the media with excessive force.

The media has jammed.

Carefully remove the jammed media. The print heads may also be damaged. Perform head cleaning, and then perform a printing test and check the results.

Has the media been pulled with excessive force?

Excessive tension was applied to the media, and additional action is necessary to recover from this state. First, raise the loading lever and adjust the media to create a small amount of slack, and then switch on the sub power.

[Print Head Dry-out Error]

This message appears when the print heads are forced to the home position to prevent them from drying out.

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

[Low Temperature Error]

The temperature of the location where the machine is installed has fallen below the ambient temperature at which the machine can operate.

Operation cannot be continued. Turn off the sub power.

The displayed temperature is the current ambient temperature of the installation location. 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. 26 Power Supply Operations](#)

[High Temperature Error]

The temperature of the location where the machine is installed has risen above the ambient temperature at which the machine can operate.

Operation cannot be continued. Turn off the sub power.

The displayed temperature is the current ambient temperature of the installation location. 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. 26 Power Supply Operations](#)

[Pump Stop Error]

This message appears 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. Insert the removed ink cartridge. Switch the sub power off, and then back on.

[Cleaning Error (Ink Cartridge)]

The printer made an emergency stop for one of the following reasons.

- Ink ran out during [Light Choke Cleaning].
- A cartridge was removed during [Light Choke Cleaning].
- A cartridge was pulled out during the initial ink filling.

Operation cannot be continued. Before turning the sub power off and then back on, check that the ink cartridges are inserted and that there is sufficient ink.

RELATED LINKS

- [P. 221 Light Choke Cleaning Method](#)

[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.

[Service Call]

An unrecoverable error occurred or part replacement that must be performed by a service technician is required.

After turning the power off, contact your authorized dealer.

[Software error]

An error occurred in the internal communication or applications of the machine or part replacement that must be performed by a service technician is required.

Switch off the main power. Then, switch on the main power again, followed by the sub power. If the error still occurs, contact your authorized dealer.

Appendix

Operations When Moving the Unit

- Preparing to Move the Machine..... 289
 - Step 1: Removing the Media 289
 - Step 2: Discarding the Discharged Fluid 290
 - Step 3: Securing the Print-head Carriage in Place Using the Retainer 291
 - Step 4: Reinstalling the Machine 293

Preparing to Move the Machine

Before moving the machine, dispose of the discharged fluid and secure the print-head carriage in place. Attempting to move the machine without first performing these preparations may result in damage to internal components due to leaking ink or damage to the print heads.

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.

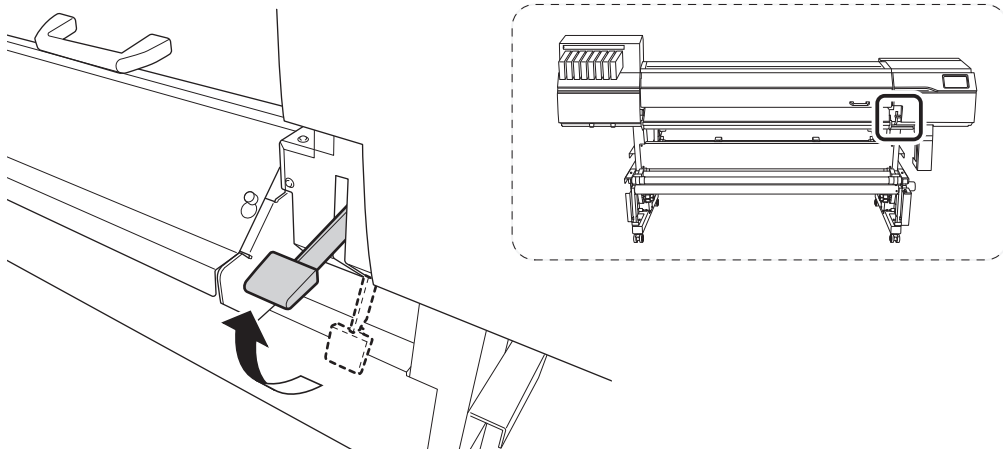
Step 1: Removing the Media

Procedure

1. Remove any media.

MEMO

If no media is loaded, raise the loading lever.



2. Close the front cover.

Step 2: Discarding the Discharged Fluid

Procedure

1. Tap .
2. Tap [Maintenance]>[Drain Bottle].
3. Tap [Execute].
4. Remove the drain bottle and discard the discharged fluid.



IMPORTANT

When you remove the drain bottle, a few drops of discharged fluid may come out of the machine. Exercise caution to prevent this fluid from soiling your hands or the floor.

⚠ 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

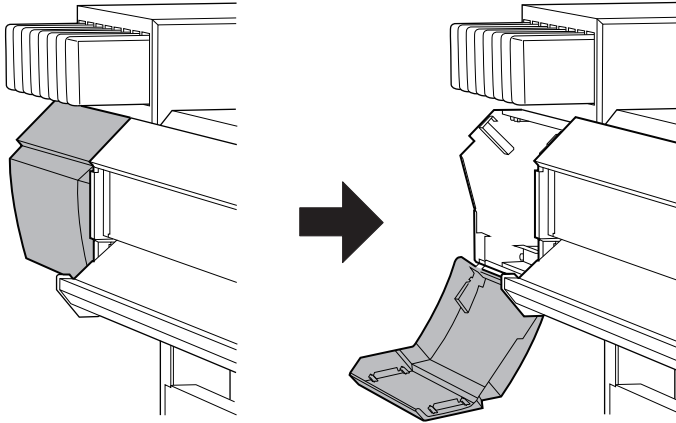
Dispose of discharged fluid properly, in accordance with the laws in effect in your locale. Discharged fluid is flammable and contains toxic ingredients. Never attempt to incinerate discharged fluid or discard it with ordinary trash. Also, do not dispose of it in sewer systems, rivers, or streams. Doing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

5. Quickly attach the emptied drain bottle to the machine once more.
6. Tap [Finish].
7. Turn off the sub power followed by the main power.

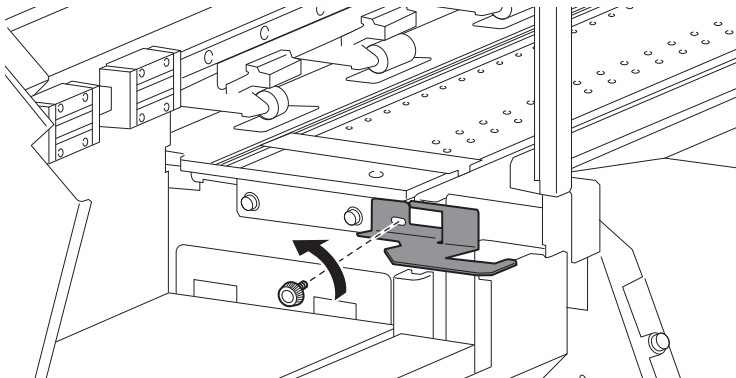
Step 3: Securing the Print-head Carriage in Place Using the Retainer

Procedure

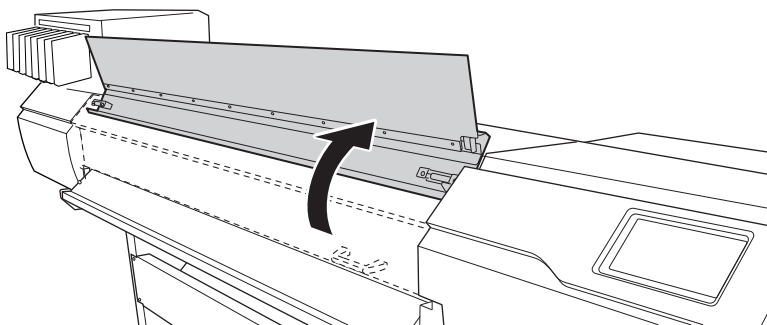
1. Open the left cover.



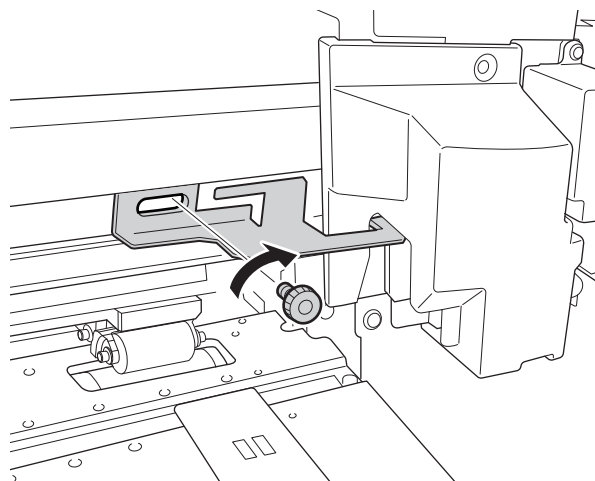
2. Remove retainer C.



3. Open the front cover.



4. Secure the sub carriage in place using retainer C removed above.

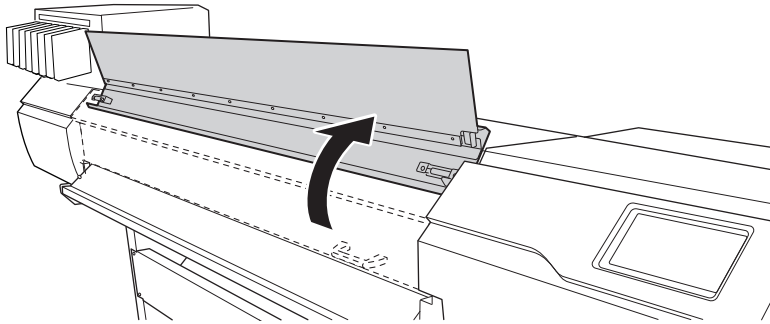


5. Close the front and left covers.

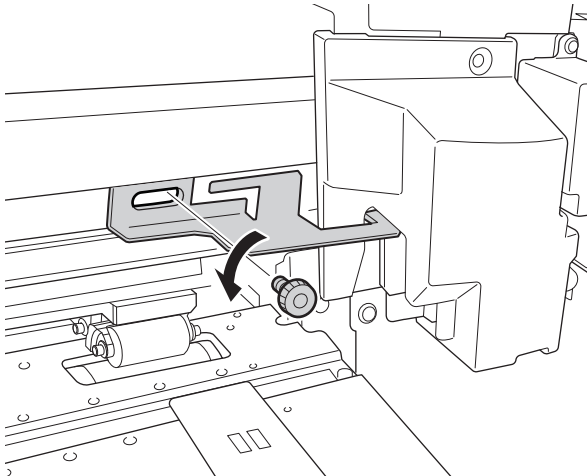
Step 4: Reinstalling the Machine

Procedure

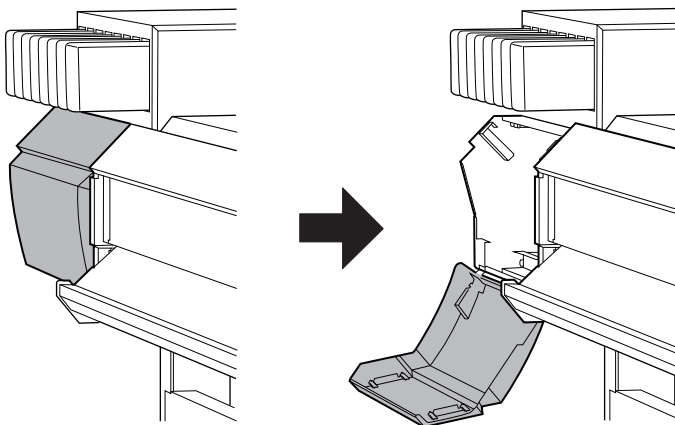
1. Once the preparations are complete, move the machine with as little delay as possible.
2. Immediately reinstall the machine, and then open the front cover.



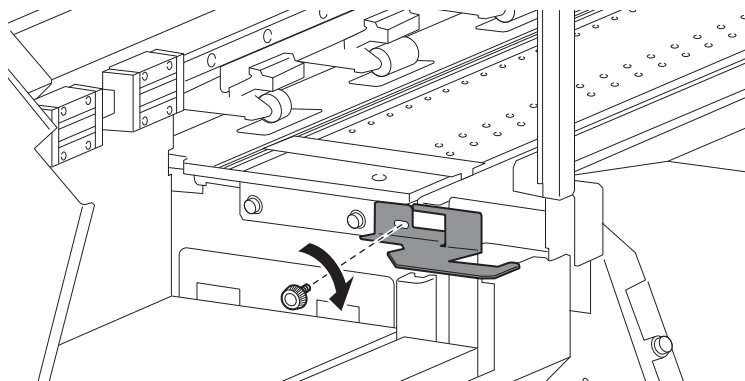
3. Remove retainer C, which secures the sub carriage in place.



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.

MEMO

If the initial setup or the ink filling is not complete, the language selection screen will appear. Follow the instructions on the screen to carry out the initial setup and ink filling.

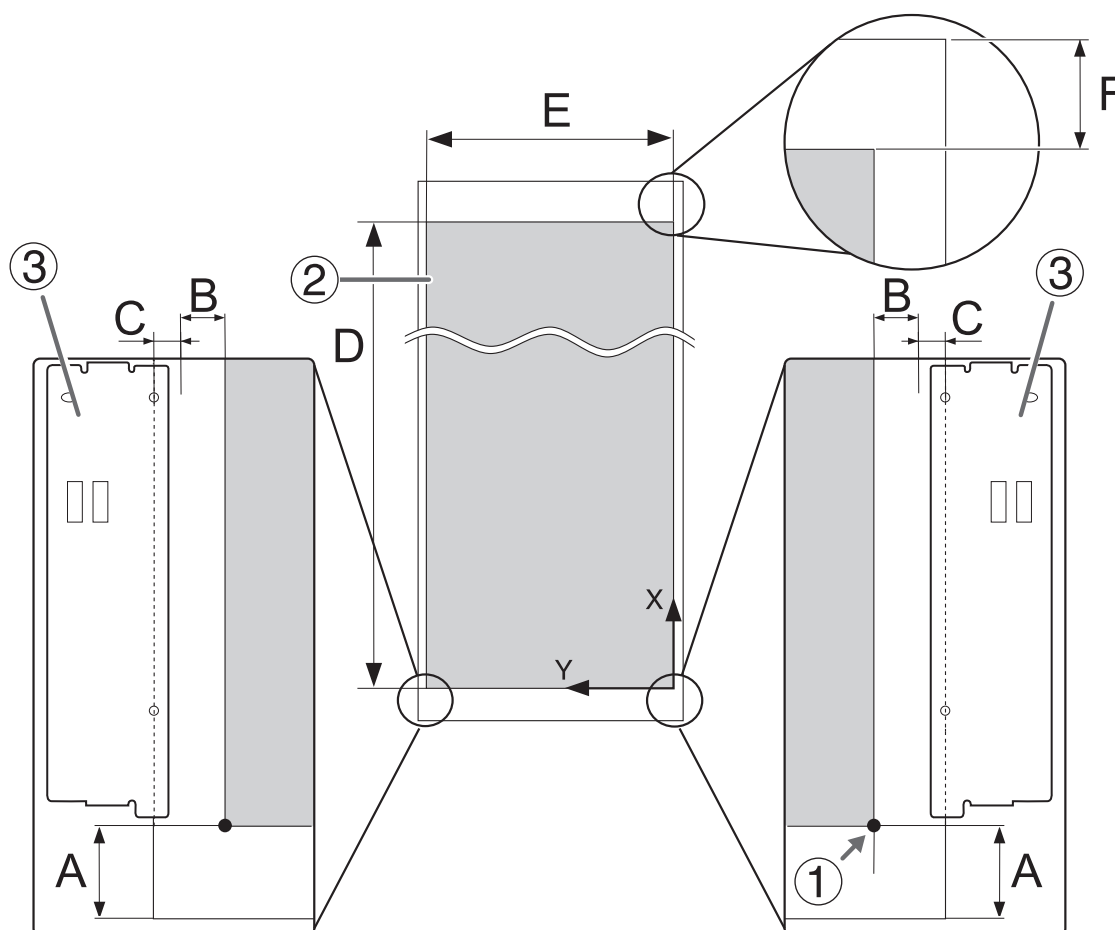
Main Specifications

- Printing area..... 296
 - Maximum Printing Area and Margins 296
 - Maximum Printing Area When Using Crop Marks..... 297
 - Media Separation Location during Continuous Printing..... 298

Printing area

Maximum Printing Area and Margins

The printing area along the horizontal plane of the loaded media (the direction in which the print-head carriage moves) is determined by the positions of the pinch rollers.

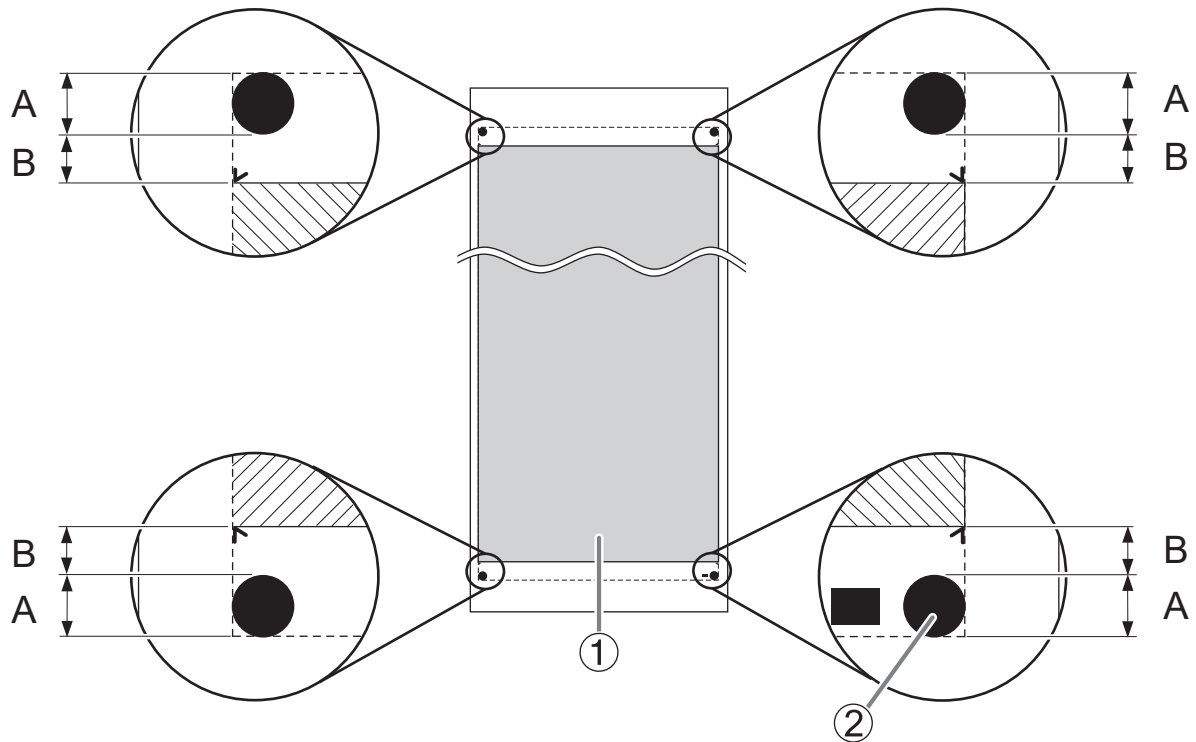


①	Origin of printing coordinates
②	Printing area
③	Media clamp
A	75 mm (3 in.)
B	Horizontal margin setting
C	Width clamped by each media clamp: 4 mm (0.16 in.)
B + C	Actual margin value* ¹
D	Max. 200,000 mm (7,874 in.)
E	Max. 1,615 mm (63.6 in.) * When printing with the media clamps removed
F	Max. 132 mm (5.19 in.)

*¹ When the media is set up without attaching the media clamps, B (the margin setting value) alone is used for the margin value without considering C (the width clamped by each media clamp).

Maximum Printing Area When Using Crop Marks

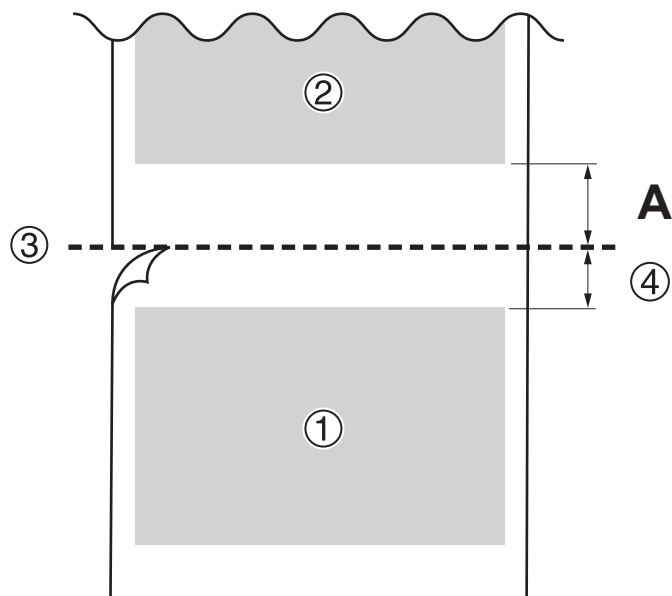
The maximum printing area when crop marks are used is reduced from the maximum printing area when crop marks are not used by an amount equal to the crop marks.



①	Maximum printing area
②	Crop mark
A	12.5 mm (0.5 in.)
B	10 mm (0.39 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 (software RIP value)
A	75 mm (3 in.)

Specifications

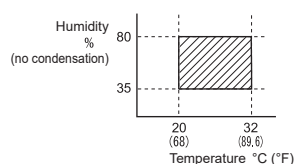
Printing method		Piezo ink-jet method
Media	Width	259 to 1,625 mm (10.2 to 64 in.)
	Thickness	Max. 1.0 mm (39.3 mil) with liner
	Roll outer diameter	Max. 250 mm (9.8 in.)
	Roll weight	Max. 45 kg (99 lb.)
	Core diameter	76.2 mm (3 in.) or 50.8 mm (2 in.)
Printing width ^{*1}		Max. 1,615 mm (63.5 in.)
Ink	Type	Eco-Solvent Ink (TH), 500 ml cartridge
	Color	Eight colors (cyan, magenta, yellow, black, light black, green, orange, and red) Four colors (cyan, magenta, yellow, and black)
Printing resolution (dots per inch)		Max. 1,800 dpi
Media heating system ^{*2}		Print heater set temperature: 30 to 45°C (86 to 113°F) Dryer 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 Va.c. 50/60 Hz 8.9/4.5 A
Power consumption	During operation	Approx. 1,180 W
	Sleep mode	Approx. 50 W
Acoustic noise level	During operation	66 dB (A) or less
	During standby	53 dB (A) or less
Dimensions (width × depth × height)		2,886 mm (113.7 in.) × 748 mm (29.5 in.) × 1,415 mm (55.8 in.)
Weight		189 kg (417 lb.)
Environment	During operation ^{*3}	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, software (VersaWorks, Roland DG Connect), etc.

*1 The length of printing is subject to the limitations of the application software.

*2

- 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.

*3 Operating environment (Use the machine in an operating environment within these ranges.)



Memo

Software	301
----------------	-----

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.

Company names and product names are trademarks or registered trademarks of their respective holders.

