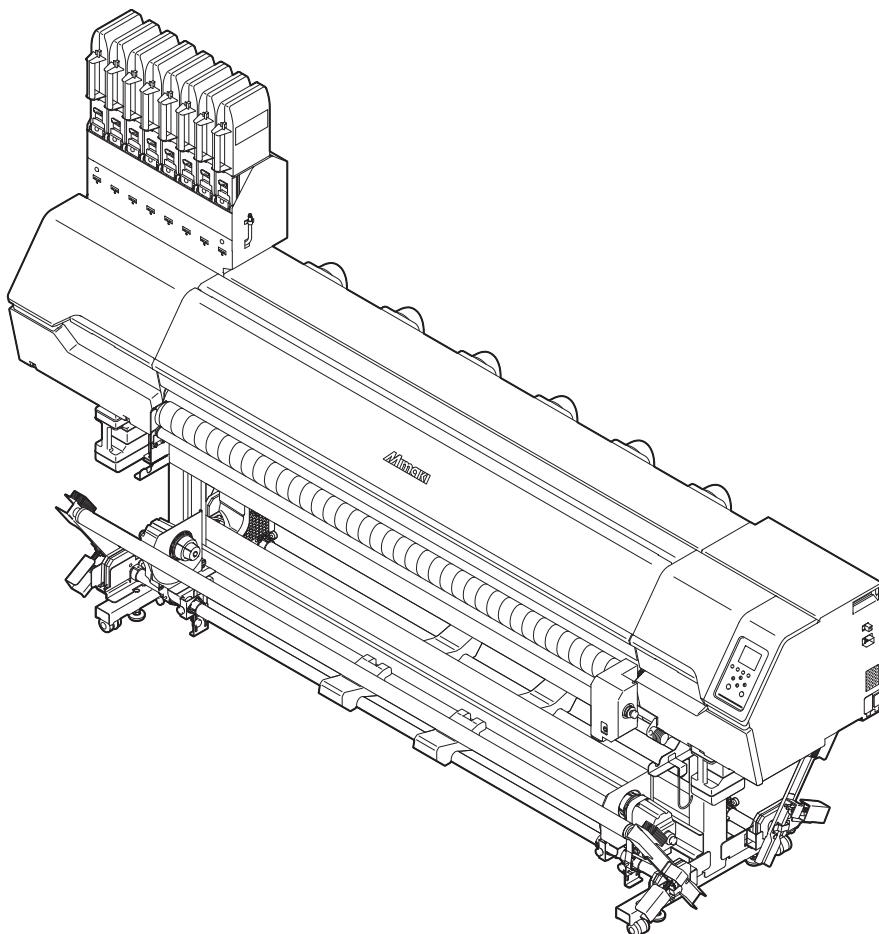


Operation Manual

INKJET PRINTER
TX330-1800

Operation Manual



You can also download the latest manual from official website.

MIMAKI ENGINEERING CO., LTD.

<https://mimaki.com/>

D203878-14
Original instructions

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Introduction

Thank you for purchasing the Inkjet printer Tx330-1800.

Read this operating manual ("this document" hereinafter) thoroughly and make sure you understand its contents to ensure safe and correct use of the product.

Please note that the illustrations contained in this manual are intended to show functions, procedures, or operations and may sometimes differ slightly from the actual machine.

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● DISCLAIMERS

- MIMAKI ENGINEERING REJECTS ALL LIABILITY FOR DAMAGE ARISING DIRECTLY OR INDIRECTLY FROM THE USE OF THE Tx330-1800 ("THIS MACHINE" HEREINAFTER), WHETHER OR NOT THE PRODUCT IS FAULTY.
- MIMAKI ENGINEERING REJECTS ALL LIABILITY FOR DAMAGE, DIRECT OR INDIRECT, TO MATERIALS CREATED WHILE USING THIS MACHINE.
- USING THIS MACHINE IN CONJUNCTION WITH DEVICES OTHER THAN THOSE RECOMMENDED BY MIMAKI ENGINEERING MAY RESULT IN FIRE OR ACCIDENTS. SUCH INCIDENTS ARE NOT COVERED BY THE PRODUCT WARRANTY. MIMAKI ENGINEERING REJECTS ALL LIABILITY FOR DAMAGE, DIRECT OR INDIRECT, ARISING FROM SUCH INCIDENTS.
- USE ONLY GENUINE MIMAKI ENGINEERING INK AND MAINTENANCE LIQUID. USE OF OTHER PRODUCTS MAY RESULT IN FAILURES OR REDUCE PRINT QUALITY. SUCH INCIDENTS ARE NOT COVERED BY THE PRODUCT WARRANTY. MIMAKI ENGINEERING REJECTS ALL LIABILITY FOR DAMAGE, DIRECT OR INDIRECT, ARISING FROM SUCH INCIDENTS.
- DO NOT ATTEMPT TO REFILL THE INK PACKS WITH UNAUTHORIZED INK. SUCH INCIDENTS ARE NOT COVERED BY THE PRODUCT WARRANTY. MIMAKI ENGINEERING REJECTS ALL LIABILITY FOR DAMAGE, DIRECT OR INDIRECT, ARISING FROM SUCH INCIDENTS.

● TV and radio interference



- The machine emits high-frequency electromagnetic radiation while operating. Under certain circumstances, this may result in TV or radio interference. We make no guarantee that this machine will not affect special radio or TV equipment.

If radio or TV interference occurs, check the radio or TV reception after turning off the machine. If the interference disappears when the power is turned off, the machine is likely to be the cause of the interference.

Try any of the following solutions or combinations of these solutions:

- Change the orientation of the TV or radio antenna to find a position where interference does not occur.
- Move the TV or radio away from this machine.

● FCC (Federal Communications Commission) regulations

The machine has been tested and certified to comply with restrictions applying to Class A digital devices under Part 15 of the FCC regulations. These restrictions are designed to provide suitable protection from harmful interference when the printer is used in commercial environments.

This product may generate, use, or emit radio frequency energy and may cause harmful interference with radio communications if not installed or used in accordance with the operating manual.

Use of this product in residential areas may cause harmful interference. If so, the user is responsible for rectifying such interference.

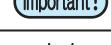


- Use only the cables recommended by Mimaki Engineering when connecting to the machine. Use of other cables may cause the product to exceed the restrictions stipulated by FCC regulations. To maintain compliance with FCC regulations, use the cables recommended by Mimaki Engineering.

To Ensure Safe Use

Symbol Marks

This document uses symbol marks to explain precautions when operating the machine. Make sure you fully understand the meaning of each mark to ensure safe and correct use of the machine.

Explanation		
 WARNING	Warning	Indicates a potential hazard that may result in death or serious injury if handled improperly or if instructions are disregarded.
 CAUTION	Caution	Indicates a potential hazard that may result in minor or moderate injury if handled improperly or if instructions are disregarded.
 NOTICE	Notice	Indicates a potential hazard that may result in property damage if handled improperly or if instructions are disregarded.
	Warning sign	Indicates something that requires attention. Warning specifics are drawn inside the symbol.
	Mandatory action sign	Indicates an action that must be carried out. The specifics of the mandatory action are drawn inside the symbol.
	Prohibition sign	Indicates a prohibited action. The specifics of the prohibited action are drawn inside the symbol.
 Important!	Important	Indicates important information related to use of this machine.
	Tip	Indicates useful reference information.
	Reference information	Indicates the corresponding page for related information.

Usage Precautions

● In the event of abnormal conditions

WARNING



- In the event of abnormal conditions such as smoke or unusual odor, turn off the main power immediately and turn off the breaker. Continuing to use the machine under these conditions may result in failure, electric shock, or fire. Once you have confirmed that smoke is no longer being emitted, contact your local dealer or our service office. Never attempt to repair the machine yourself, which is hazardous.

CAUTION



- Immediately wipe off any ink, maintenance liquid, waste ink, or other liquid used with the product that comes into contact with your skin. Then wash using soap, and rinse with plenty of water. Failure to wash off ink may result in skin inflammation. If your skin becomes irritated or painful, seek medical attention immediately.
- If ink, maintenance liquid, waste ink, or any other liquid used in the product comes into contact with your eyes, rinse immediately with plenty of clean water. Rinse for at least 15 minutes. If you wear contact lenses and they can be easily removed, remove after rinsing for at least 15 minutes with clean water. Be sure to also rinse the undersides of your eyelids. Failure to rinse off ink may result in blindness or impaired vision. If your eyes become irritated or painful, seek medical attention immediately.
- If ink, maintenance liquid, waste ink, or any other liquid used in the product enters your mouth or is swallowed, gargle with water immediately. Do not induce vomiting. Seek medical attention promptly. Inducing vomiting may cause liquid to enter the airway.
- If a large amount of vapor is inhaled, move to a well-ventilated area, keep warm, and rest in a posture that allows easy breathing. If the condition does not improve, seek medical attention promptly.

NOTICE



- If an ink leak occurs, turn off the main power immediately and turn off the breaker. Then, contact your local dealer or our service office.

● Power supply precautions

WARNING



- Do not damage or modify the power cable. Do not place heavy objects on, heat or stretch it. Doing so may damage the cable, leading to electric shock or fire.
- Do not use the power cable if it is damaged or broken or if the core wire is exposed. Otherwise there is a risk of failure, electric shock, or fire.

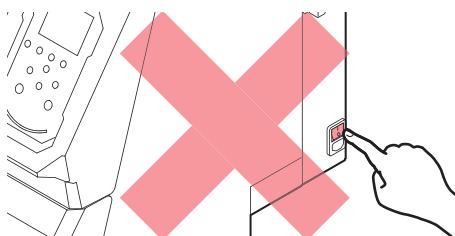


- Always connect the machine to a switchboard with grounded polarity. Otherwise there is a risk of failure, electric shock, or fire. All electrical work (Class C grounding work; formerly Type 3 grounding work) must be handled by a licensed electrician.

NOTICE



- Do not turn off the main power supply. Turning off the main power supply will disable the automatic maintenance function (including nozzle clogging prevention function and ink discharge channel cleaning function). This increases the risk of ejection failures (such as nozzle clogging or deflection).



- Use the machine with a power supply that meets specifications.
- When connecting the power cable, check the input voltage of the power outlet and the capacity of the breaker. Also, connect each cable to a separate power source with an independent breaker. Connecting to power outlets linked with the same breaker will cause the breaker to trip.

● Caution regarding moving parts

⚠ CAUTION



- Keep parts of the body such as the face and hands away from moving parts. Also keep clothing (e.g., loose clothing and accessories) that may impede work away from the machine. Failure to do so may result in injury.
- Long hair should be tied back. Failure to do so may result in injury.



● Do not disassemble or repair

⚠ WARNING



- Do not attempt to disassemble or repair this machine. Otherwise there is a risk of failure, electric shock, or fire.

● Other usage precautions

⚠ WARNING



- Keep children away from the machine.

NOTICE



- Do not hold the acrylic part when opening the front cover. Doing so may damage the acrylic.



- Do not pull the media when the clamp lever is lowered (the media is clamped). Doing so may damage the machine.

(Important!)

- The underside of the media may be soiled depending on how the printed media has been stored (due to weight when laying printed media rolls horizontally, for example) and the media type. Perform a test beforehand to check that the media does not transfer ink to the underside of the adjacent media.



- Condensation may form on the print head nozzle surface depending on the ambient temperature and humidity. The formation of condensation may cause ejection failures (e.g., nozzle clogging or deflection). Perform head cleaning if any ejection failures (e.g., nozzle clogging or deflection) occur during printing.  "Head Cleaning"(P. 96)

● Disposing of the product

⚠ CAUTION



- Please contact your local retailer or service agent.
- When disposing of the product yourself, contact an industrial waste disposal operator or dispose of the product in accordance with local laws and regulations.

Notes on Handling Ink or any Other Liquid Used with the Machine

Precautions regarding ink, maintenance liquid, or other liquids used with this machine are included with the containers. Thoroughly read them and make sure you understand the contents.

- Be sure to read the safety data sheet (SDS) before use. <https://mimaki.com/supply/sds/>



⚠ CAUTION

- Pay close attention to ventilation and be sure to wear safety glasses, gloves, and a mask when handling ink, maintenance liquid, waste ink, or other solutions used with the machine. Leaking ink may adhere to the skin or get into the eyes or mouth.



- Do not subject cases containing ink to strong shock or violent shaking. Do not attempt to refill the ink. Leaking ink may adhere to the skin or get into your eyes or mouth.



- Do not disassemble cases containing ink. Leaking ink may adhere to the skin or get into your eyes or mouth.



- Do not store ink, maintenance liquid, or other liquids used with the machine in locations where children may enter.



- When disposing of ink, maintenance liquid or other liquid used with the product, or containers or non-woven fabric contaminated with ink or other liquid, contact an industrial waste disposal operator or dispose of the product in accordance with the local laws and regulations.

NOTICE



- Do not store ink, maintenance liquid, or other liquids used with the machine in locations exposed to direct sunlight.
- Do not store ink, maintenance liquid, or other liquids used with the machine in environments where cutting fluid or other volatile substances (such as amines or modified amine alcohol) are present in significant quantities. Storage in such places increases the risk of failure or ejection failures (e.g., nozzle clogging or deflection).
- Do not use ink, maintenance liquid, or other liquids used with this machine with other printers. Doing so may cause failure.



- Be sure to store them in a low place no higher than 1 m above the floor. Otherwise there is a risk of scattering if the containers fall.
- Store in tightly sealed containers.
- Store in a cool, dark place.
 - (1) Store ink in a place where ink does not freeze. Using defrosted ink may deteriorate ink constituents and reduce print quality.
 - (2) When ink is moved from a cold place to a warm place, leave it in the environment where the machine is installed for at least three hours before using it.
 - (3) Open the container just before installing it, and use it up as quickly as possible. If it is opened and left for an extended period of time, print quality may be reduced.



- Do not touch the metal parts of the ink IC chip. Static electricity may damage the ink IC chip, and dirt or damage may cause the ink IC chip read error.



- Printing is disabled if a different ink IC chip is used.

Ink Specifications

Item		Tx330-1800		
Type	Special Sublimation Transfer Ink Sb411 (Mimaki Engineering product)		Special Dye Sublimation Ink Sb420 (Mimaki Engineering product)	Special Pigment Transfer Ink TP410 (Mimaki Engineering product)
Color	Blue (BL) Magenta (M) Yellow (Y) Black (K)		Blue (BL) Magenta (M) Yellow (Y) Black (K) Light blue (Lb) Light magenta (Lm)	Cyan (C) Magenta (M) Yellow (Y) Black (K) Red (R) Blue (BL) Green (GR) Light black (Lk)
Form	Aluminum pack			
Ink capacity	2,000 ml			
Expiration date	As indicated on the ink pack. However, after opening, it should be consumed within one month, even if before the expiration date.			
Storage temperature ^{*1}	When stored	10 to 35 °C (daily mean temperature)		
	During transportation	0 to 40 °C		

*1. Ink quality may deteriorate if stored outside this temperature range.

Restrictions Concerning the Expiration Date of Ink Used in the Machine

Example: When the expiration date is April 20xx

- May 20xx: Replace with new ink or use up as quickly as possible. Printing is possible.
- June 20xx: Replace with new ink or use up as quickly as possible. Printing is possible.
- July 20xx: Printing is not possible.



- The message appears on the display.

(Important!)

- The ink expiration date is indicated on the ink containers. Expired ink may cause ejection failures or alter the color tone. Printing is possible even if the ink has passed its expiration date. Nevertheless, we recommend replacing with new ink or using up as quickly as possible.

Installation Precautions

⚠ WARNING



- Do not install the machine in a place close to fire.
- Do not place flower vases, pots, cups, containers containing cosmetics, chemicals or water, or small metal items on or close to the machine. If they enter the machine, there is a risk of failure, electric shock, or fire.



- Do not install this machine in humid locations or locations where it may be exposed to splashing water. Otherwise there is a risk of failure, electric shock, or fire.



- Do not install the machine in a place where children may enter.

⚠ CAUTION



- A ventilation system must be provided if this machine is installed in a poorly ventilated area or sealed room.
- Be sure to observe the following points when installing an extractor outlet:
 - (1) The extractor outlet must be installed in accordance with applicable local EHS (environmental, health, and safety) guidelines.
 - (2) If the extractor outlet is fitted with a shutoff valve, the valve must be open when this machine is in use.

NOTICE



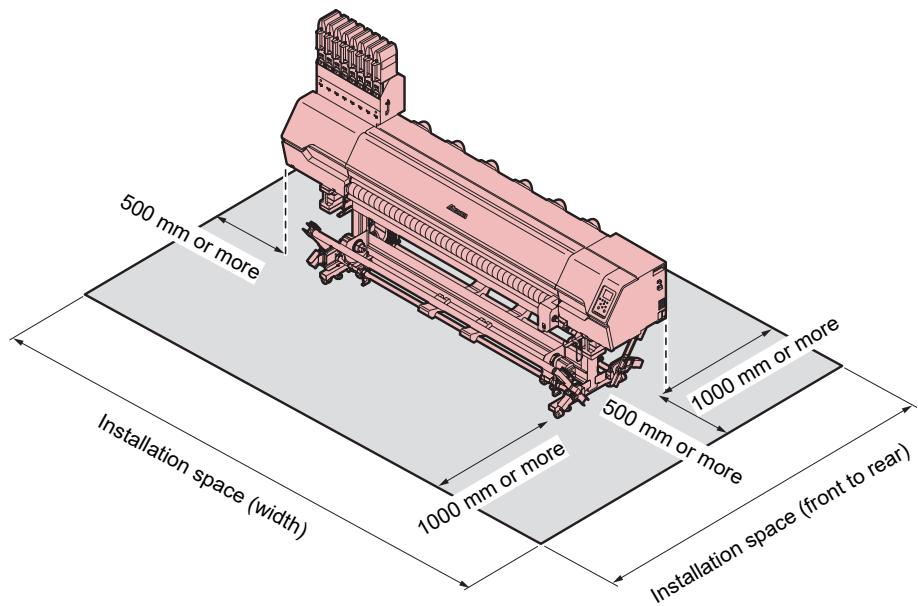
- Do not install this machine in locations where dust or powder is present. Failure or printing defects may result (e.g., nozzle clogging, deflection) if dust gets inside this machine.
- Do not install this machine in locations exposed to drafts (e.g., from air conditioning). Disregarding this precaution may result in dust or powder getting inside this machine.
- Do not install this machine in unstable locations or locations subject to vibration. This will increase the risk of failure or printing defects (e.g., nozzle clogging, deflection).
- Do not install this machine in locations exposed to direct sunlight.
- Do not install this machine in locations subject to sudden temperature changes. This will increase the risk of failure or printing defects (e.g., nozzle clogging, deflection).
- Do not install this machine in locations exposed to excessive noise from large machinery.
- Do not install this machine in locations where photographic fixing agents generate vapor or acid gas (e.g., acetic acid, hydrochloric acid) or locations filled with metal working fluids or highly volatile substances (e.g., amines, amine-modified alcohols). Malfunctions or printing defects may result (e.g., nozzle clogging, deflection) as print head ink is more likely to harden under such environments.



- Operating environment: 20 to 30 °C (68 to 86 °F), 35 to 65 %RH (no condensation)
- Temperature range in which accuracy is guaranteed: 20 to 25 °C (68 to 77 °F)

Installation Space

Provide the following space around the machine to allow safe and proper replacement of ink and media:



● Tx330-1800

Size	Tx330-1800
Width ^{*1}	At least 4,230 mm (3,230 mm)
Depth ^{*1}	At least 2,965 mm (965 mm)
Height ^{*1}	(1,857 mm) ^{*2}
Weight	291 kg

*1. The figures in parentheses indicate machine dimensions.

*2. With ink eco-cases loaded.

When Relocating This Machine

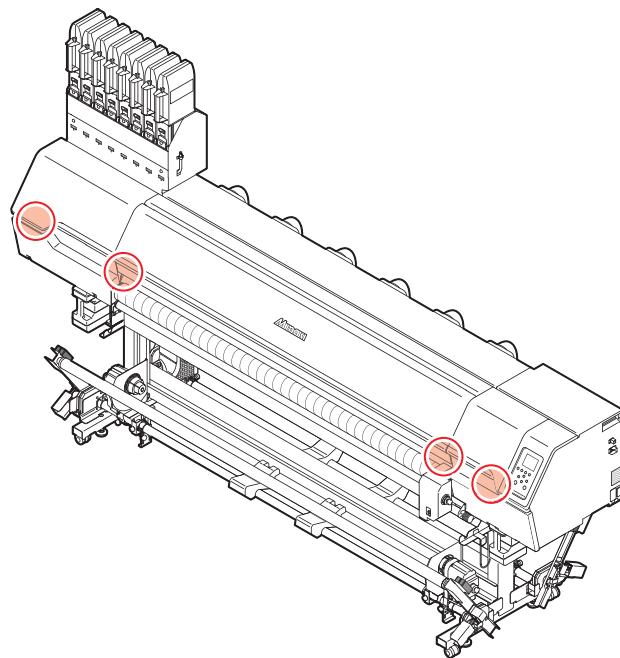
Contact your local dealer or our service office. Attempting to handle relocation yourself may result in failure or damage.

Safety Interlocks

The machine is equipped with interlocks to ensure safety during use.

Printing will abort if you open the covers while printing is underway. The RIP data will need to be resent.

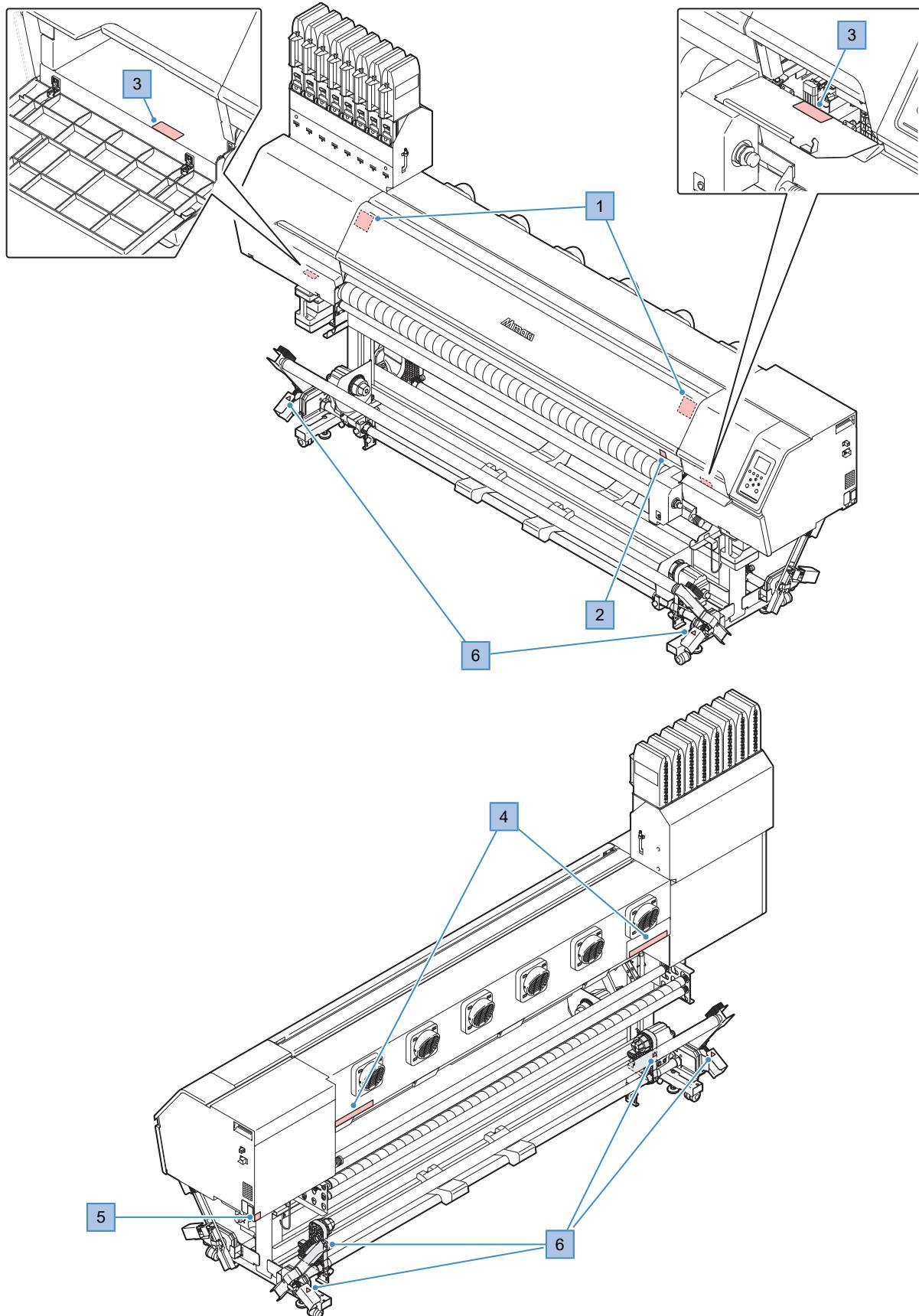
- Safety interlock locations



Warning Label

Make sure you fully understand the details indicated on the various warning labels.

If any of the warning labels becomes dirty and illegible or peel off, contact your local dealer or our service office to request new warning labels.



No.	Order code	Label	Details
1	M910931		Beware of opening and closing parts. Injury may result if hands become trapped.
2	M907833		Indicates dangerous moving parts.
3	M903330		Wear safety glasses and gloves while working.
4	M905811		Indicates dangerous moving parts.
5	M907935		Indicates dangerous live parts.
6	M918910		Indicates dangerous moving parts.

Chapter 1 Before Use



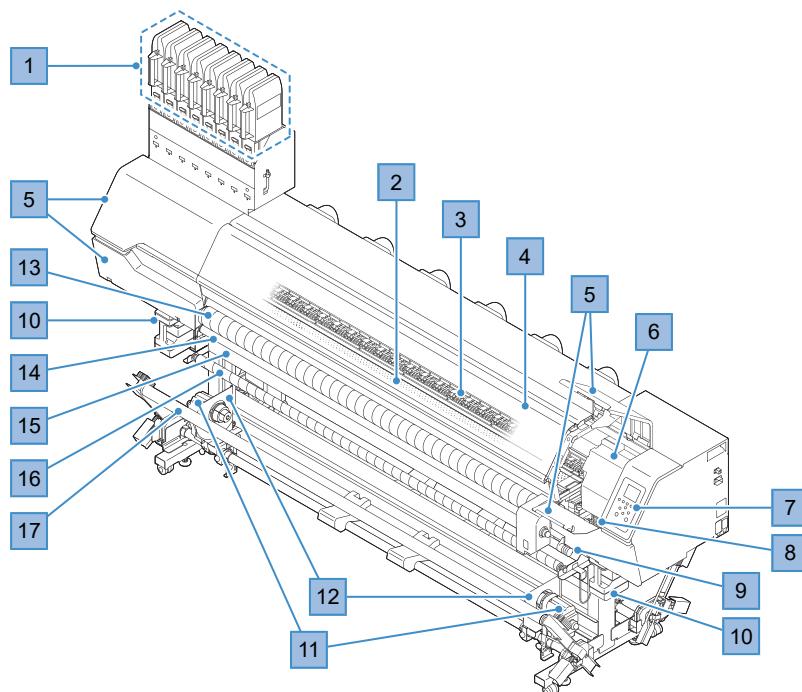
This chapter

This chapter describes information essential before use, such as part names.

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1.1 Part Names and Functions

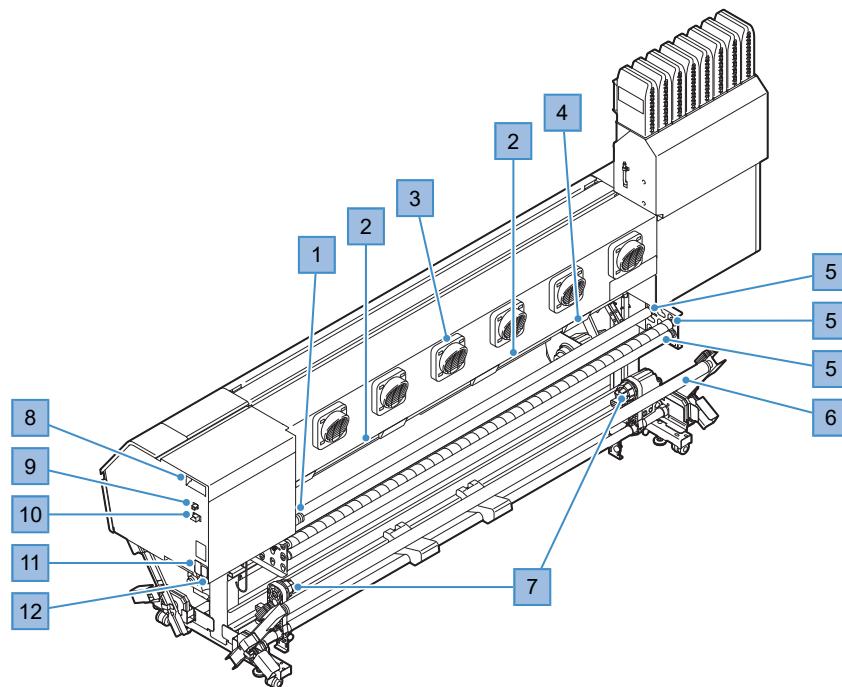
Front



No.	Name	Overview
1	Ink Supply Unit	Each tank contains an ink of a particular color. "Ink Supply Unit"(P. 25)
2	Platen	Print area. "Platen"(P. 26)
3	Pinch roller Grit roller	The pinch rollers and grit rollers are used to grip and feed the media. "Pinch Rollers and Grit Rollers"(P. 27)
4	Front cover	Open the cover to load media, perform maintenance near the platen, or replace consumables. Printing and automatic maintenance are not possible while the covers are open.
5	Maintenance cover	Open the cover to perform maintenance on locations such as the carriage underside. Printing and automatic maintenance are not possible while the covers are open.
6	Carriage	Consists of components such as the print head and jam sensor. "Carriage"(P. 26)
7	Operating Panel	Includes operating keys and displays indicating various settings and other items. "Operating Panel"(P. 30)
8	Station	Includes caps and wipers for protecting print heads. "Station"(P. 26)
9	Clamp lever	Lowering the clamp lever secures the media. Raising the clamp lever releases the media. Linked to the clamp lever at the rear.
10	Waste Ink Tank	Container for waste ink. "Waste Ink Tank Replacement"(P. 158)
11	Media Edge Guides	In some cases, roll media may shift sideways and start to curl inwards. Using the media edge guides prevents the roll media from becoming offset. "Using media edge guides"(P. 69)
12	Take-up unit	Rolls up the printed roll media. "Take-up unit"(P. 62)
13	Tension roller	Roller for feeding the media. "Preparing the Tension Roller"(P. 58)

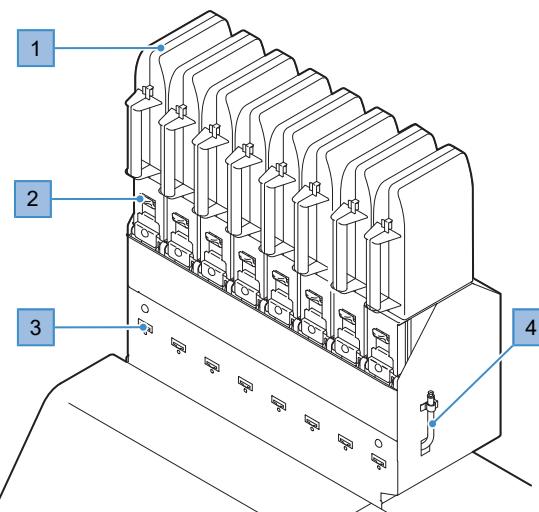
No.	Name	Overview
14	Cloth-wound roller	Helps keep cloth media clean by removing any ink on the tension roller.  "Setting Up the Fabric Roller"(P. 59)
15	Platen holder	Used to store the platen detached when printing on cloth media.  "Platen holder"(P. 27)
16	Take-up reversing bar	Stabilizes tension of wound media.  "Adjusting the reversing bars"(P. 79)
17	Take-up tension bar	Adjusts tension of wound media.  "Using the tension bars"(P. 71)

Rear and Right Side View



No.	Name	Overview
1	Clamp lever	Linked to the clamp lever at the front.
2	Media Sensor	Detects whether media is present. "Media Sensor"(P. 28)
3	Blowing fan	Blows air to dry ink after printing. "Blowing Fan Filter Replacement"(P. 150)
4	Exhaust fan box	Discharges air for holding down the media.
5	Feeding reversing bars	Stabilizes feeding tension of media. "Adjusting the reversing bars"(P. 79)
6	Feeding tension bar	Adjusts feeding tension of media. "Using the tension bars"(P. 71)
7	Feeding unit	Feeds roll media to the front of the machine. "Feeding unit"(P. 70)
8	Maintenance liquid cartridge	Used to automatically feed maintenance liquid to the cap, and to prevent ink solidifying inside the ink discharge channel during maintenance.
9	USB port	Connects to PC via a USB interface cable. "Using a USB Cable"(P. 37)
10	LAN port	Connects to PC via a LAN cable. "Using a LAN Cable"(P. 36)
11	Main power switch	The main power supply for the machine. To prevent ejection failures attributable to the print head (e.g., nozzle clogging or deflection), do not turn off the main power supply. "Power Supply Switch"(P. 29) "Turning On the Power"(P. 33) "Turning Off the Power"(P. 34)
12	AC inlet	Use the power cable provided. "Connecting the Power Cable"(P. 33)

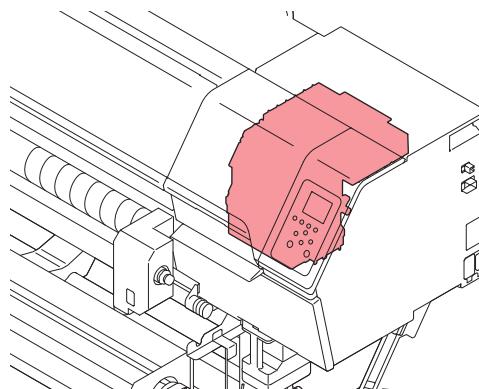
Ink Supply Unit



No.	Name	Overview
1	Ink Eco-case	The ink eco-cases are mounted here.  "Mounting the ink"(P. 45)
2	Ink lever	Push down the lever to remove the ink eco-cases.
3	Ink IC chip slot	Insert the ink IC chips provided with the ink. This manages the ink information.
4	Ink leak check tube	When ink is in the tube, contact your local distributor, our sales office, or service center. .

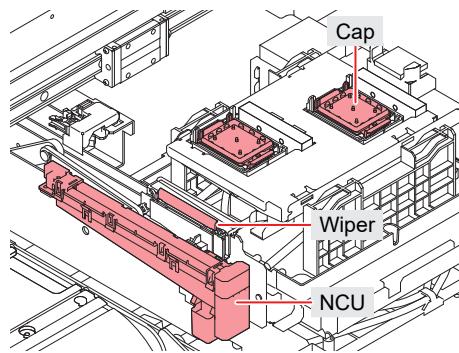
Carriage

The carriage includes a print head for ejecting ink, and a jam sensor for stopping the carriage when media clogs. Printing occurs as ink is ejected while traversing left and right.



Station

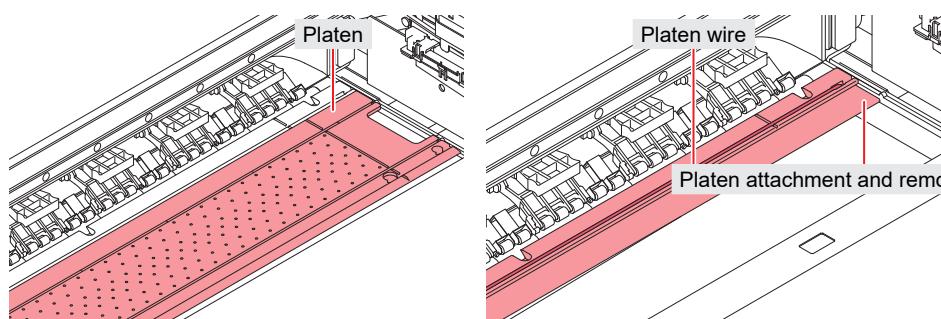
The station includes a cap for preventing the print head nozzle surface from drying out, and a wiper required for print head maintenance.



Platen

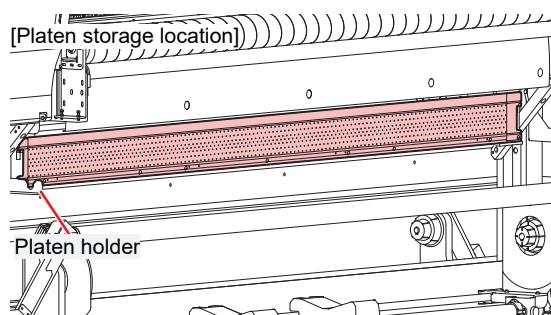
When printing on paper media, platens are used to secure the media under vacuum pressure.  ["When using paper media"\(P. 53\)](#)

Remove the platens when printing on cloth media.  ["When using cloth media"\(P. 52\)](#)



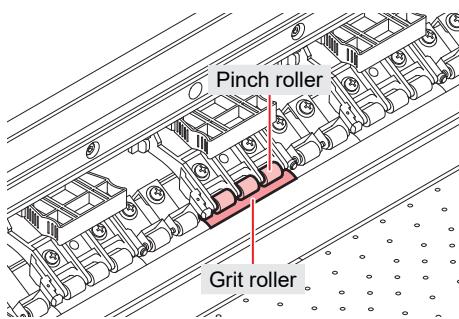
Platen holder

When printing on cloth media, the platen is removed and stored in the platen holder.



Pinch Rollers and Grit Rollers

The pinch rollers and grit rollers are used to grip and feed the media.

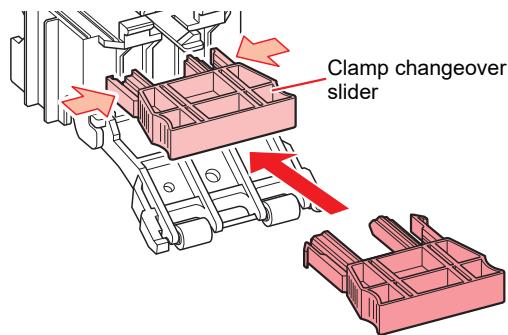


! When the machine is not in use, raise the clamp lever to separate the pinch rollers from the grit rollers.

- Leaving the pinch rollers lowered may cause them to become deformed and prevent media from being fed correctly.
- Leaving media loaded will subject it to force from the pinch rollers, which may leave pinch roller marks on it.

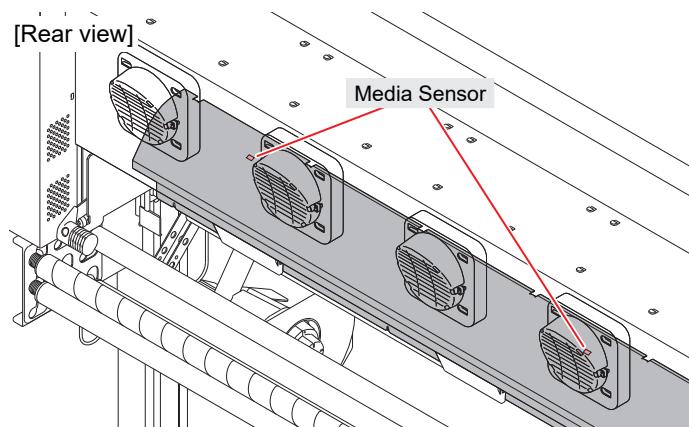


- Attach the clamp changeover sliders to the pinch rollers at the left and right-hand ends of the media. The pinch rollers can be raised by attaching clamp changeover sliders. (Do not raise pinch rollers other than those at the left and right edges of the media.) This prevents gripping the left and right-hand ends of the media for consistent feeding.



Media Sensor

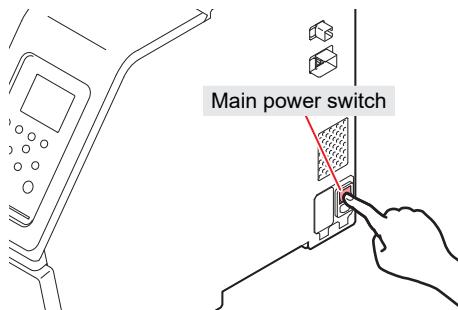
The media sensor detects the presence/absence of media. The sensor must be covered by the media to detect the media width. Two sensors are located on top of the pre-cover (at the rear).



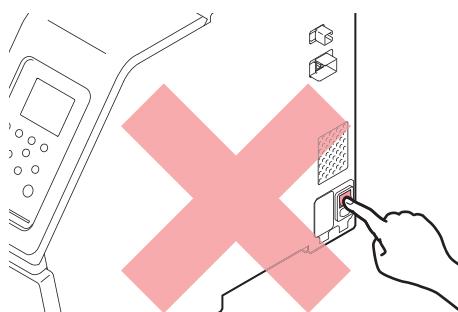
Power Supply Switch

● Main power switch

This is located at the rear on the right-hand side of the product.



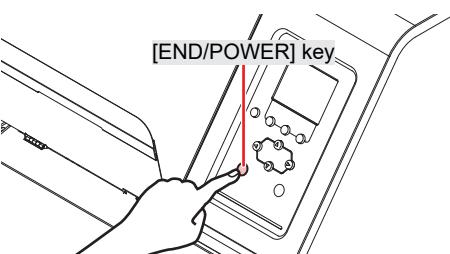
- Do not turn off the main power supply. Turning off the main power supply will disable the automatic maintenance function (including nozzle clogging prevention function and ink discharge channel cleaning function). This increases the risk of ejection failures (such as nozzle clogging or deflection).



● [END/POWER] key

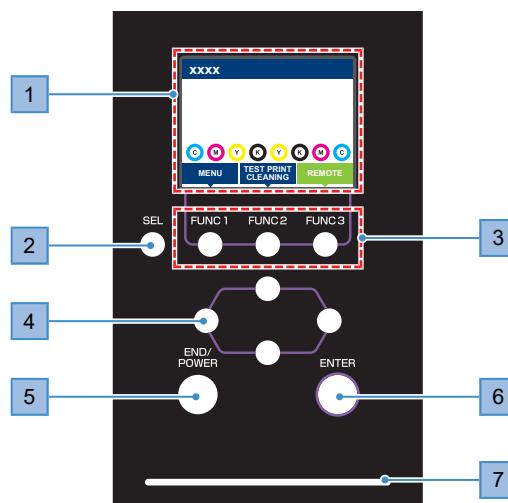
The [END/POWER] key is the key normally used to turn the power on and off.

To turn off the power, hold down the [END/POWER] key. Press the [ENTER] key once the instructions appear on the display.



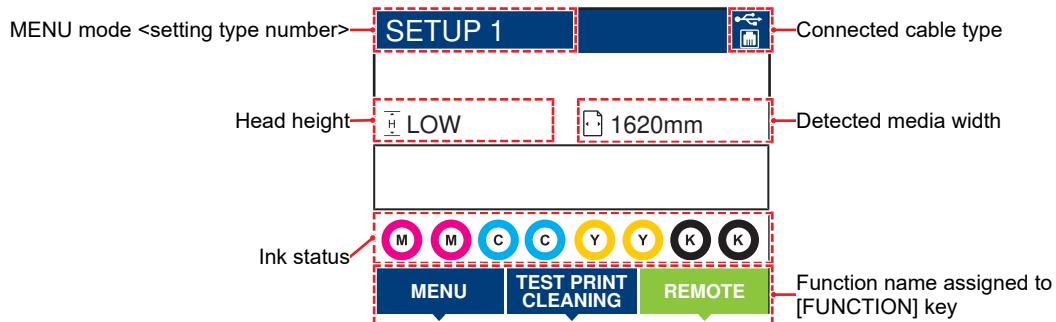
Operating Panel

This is used to control the product and make/change settings.



No.	Name	Overview	
1	Display	"Display"(P. 31)	
2	[SEL] key	Selects the function for the corresponding [FUNCTION] key.	
3	[FUNCTION] key	Used for test printing, head cleaning, and editing settings. "[FUNCTION] key"(P. 32)	
4	[JOG] key (▲▼◀▶)	Used to move the carriage, feed media, and select settings	
5	[END/POWER] key	Used to cancel the last setting entered, return to the previous level of the setting menu, or to turn power on and off <ul style="list-style-type: none"> • Illuminates in blue when the power is on. "Turning On the Power"(P. 33) • To turn off the power, hold down the key. "Turning Off the Power"(P. 34) 	
6	[ENTER] key	Used to move to the next level menu and to confirm settings. This can also be used to display product information. "Displaying Machine Information (Local Guidance)"(P. 32)	
7	Status lamp	This lamp indicates the machine status.	
		Off	Indicates LOCAL mode. Used for test printing, maintenance, and settings
		Light blue Illuminated	Indicates REMOTE mode. The product is in standby to receive print data.
		Light blue Flashing	Indicates that printing is in progress. This also flashes to indicate test printing—for example, when printing built-in patterns.
		Blue Illuminated	Indicates that data remains to be printed. Switch to REMOTE mode and start printing
		Green Flashing	Indicates that maintenance is underway. Some functions will be limited until maintenance has ended.
		Yellow Flashing	Ink Near End status (very little ink remains). "When Ink Near End is Displayed"(P. 41)
		Red Flashing	An error has occurred. Refer to the error code list and take appropriate action. "Error Message"(P. 171)
		Red Illuminated	A system error (SYSTEM HALT) has occurred. Contact our service office. "SYSTEM HALT"(P. 177)

Display



MENU mode

Four menu modes are available.

Name	Overview
LOCAL mode	Used for test printing, maintenance, and settings
REMOTE mode	Prints the print data received from a PC.
MENU mode	Press the [MENU] on the LOCAL mode screen to switch to MENU mode. This is used to set various functions.
NOT-READY mode	Status before media is detected

Ink status

The ink pack status such as remaining ink levels and ink errors are indicated by icons.

Icon	Overview
	Displays remaining ink levels using a 9-stage icon.
	Full
	1/8 used
	1/4 used
	3/8 used
	1/2 used
	5/8 used
	3/4 used
	7/8 used
	Very little ink remains. Prepare fresh ink.
	Printing is not possible. Displayed when ink is depleted or an ink error has occurred. "Ink Error"(P. 170)

[FUNCTION] key

This section describes the functions and roles assigned to the [FUNCTION] key.

Icon	Overview
	Displays the various menu screens. "Setup"(P. 107)
	Displays maintenance functions such as test printing and cleaning.
	Switches from LOCAL mode to REMOTE mode.
	Displays adjustment functions such as feed adjustment and drop position adjustment.
	Displays the Heater Temperature Setup screen.
	Clears received data.
	Used to switch from REMOTE mode to LOCAL mode
	Used to move to the previous menu screen
	Used to move to the next menu screen
	Used to close the confirmation screen in response to prompts or other messages
	Used to disable functions
	Indicates that the function is assigned. Displays settings and functions.
	Used to enable or disable multiple items

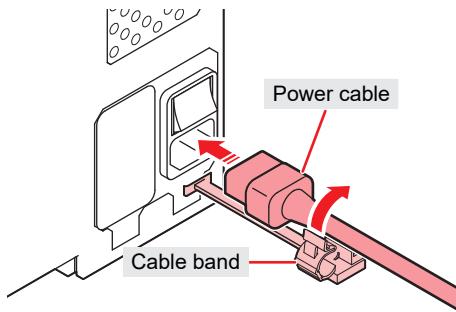
Displaying Machine Information (Local Guidance)

Press the [ENTER] key on the LOCAL mode screen to display the following information.

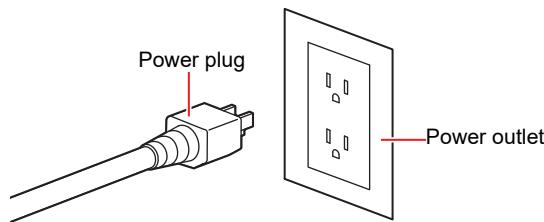
- Ink information: Displays ink type, remaining ink levels, and ink errors.
- Information: Displays information such as media width, head height, product serial number, firmware version, command version, and LAN connection status.

1.2 Connecting the Power Cable

- 1** Check to confirm that the main power supply is turned off.
- 2** Connect the cable band to the machine.
- 3** Connect the power cable to the inlet of the machine.
- 4** Secure the power cable to the cable band.
 - Pass the power cable through the clamp and clamp until it clicks into place.



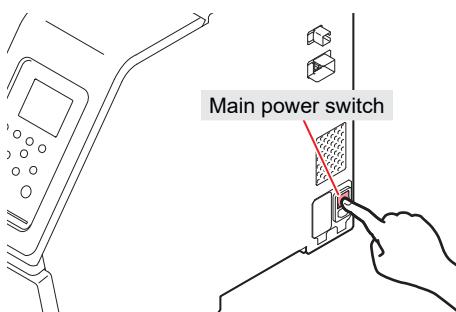
- 5** Plug the power plug into the power outlet.



- Do not handle the power plug with wet hands. Disregarding this precaution may result in electric shock.

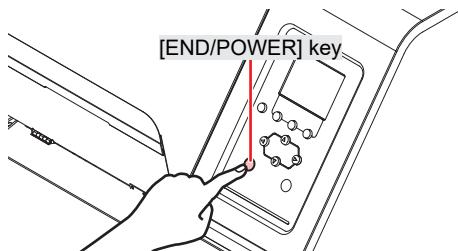
Turning On the Power

- 1** Check to confirm that the main power supply is turned on.
 - If the main power supply switch is not turned on, set to "I".



2 Press the [END/POWER] key to turn on power.

- The firmware version appears on the display, and the initial operation is executed. The machine will then enter the Media Select mode, and is ready for use.

**3** Turn on the power for the connected PC.

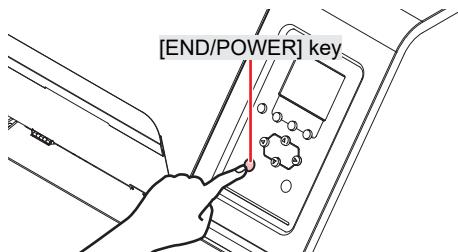
- Close the front cover and maintenance covers. Leaving any of the covers open will disable the automatic maintenance function (including nozzle clogging prevention function and waste ink draining channel cleaning function). This will increase the risk of failure or ejection failures (e.g., nozzle clogging or deflection).

Turning Off the Power

- Check the following when turning off power:
 - The front cover and maintenance covers are closed.
 - Leaving any of the covers open will disable the automatic maintenance function (including nozzle clogging prevention function and waste ink draining channel cleaning function).
 - The carriage has returned to the capping station.
 - If not, the print head nozzle may dry out, resulting in ejection failures (such as nozzle clogging or deflection).
 - Data is not being received
 - No errors have occurred.
 -  "Problems Causing Messages to Appear"(P. 168)

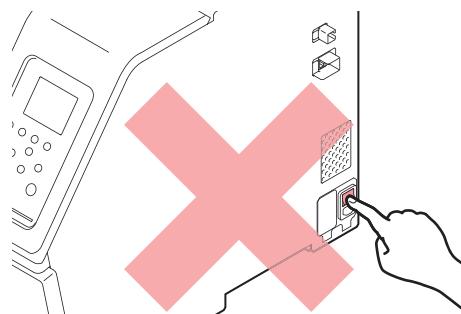
1 Turn off the power to the PC connected.**2** Hold down the [END/ POWER] key.

- A power off confirmation screen appears. Press the [ENTER] key to turn the power off.





- Do not turn off the main power supply. Turning off the main power supply will disable the automatic maintenance function (including nozzle clogging prevention function and ink discharge channel cleaning function). This increases the risk of ejection failures (such as nozzle clogging or deflection).



1.3 Connecting a PC to the Product

Connect the machine to the RIP PC. The following cables can be used:

1.  "Using a LAN Cable"(P. 36) **(Recommended)**
2.  "Using a USB Cable"(P. 37)

(Important!) When using the USB cable

- Data may be transferred to the machine too slowly, causing the carriage to pause at the left-hand or right-hand end during printing.

Using a LAN Cable

Connect a PC to this product using a LAN cable. Insert a LAN cable until it engages with a click.

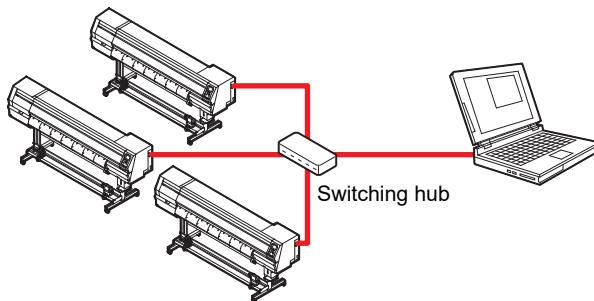


- Do not unplug the cable while data is being transferred.

● Network Connection Precautions

Make sure the network is set up as follows: Printing is not possible if the network is not set up correctly.

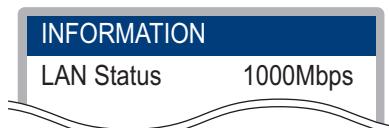
- Use a Category 6 or higher LAN cable.
- The PC used to transfer print data must be located on the same network as this product. This product cannot be connected via a router.
- Use a 1000BASE-T compatible computer or switching hub. Printing requires 1000BASE-T support.



● Checking the LAN connection

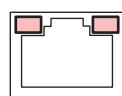
1 Check the display on this product.

- Local guidance can be used for checking.  "Displaying Machine Information (Local Guidance)"(P. 32) Printing is not possible if "100Mbps", "10Mbps", or "No Connect" is displayed.



2 Check the lamp on the LAN connector.

- The LAN connector lamp illuminates when the machine is running.



Color	Status	Overview
Green	Illuminated	Connected via 1000BASE-T
	Off	Connected via a network other than 1000BASE-T • 1,000 Mbps is not supported if only the orange lamp is illuminated or flashing. Check the specifications for the PC, peripheral devices, and cable.
Orange	Illuminated	Linked up (connected).
	Flashing	Data being received
	Off	Link down (not connected)

Using a USB Cable

Connect a PC to this product using a USB interface cable.



- Do not unplug the cable while data is being transferred.



- Use RIP software that supports the USB interface.



- If the computer has no USB port, contact your local dealer or our service office.

(Important!) When using the USB cable

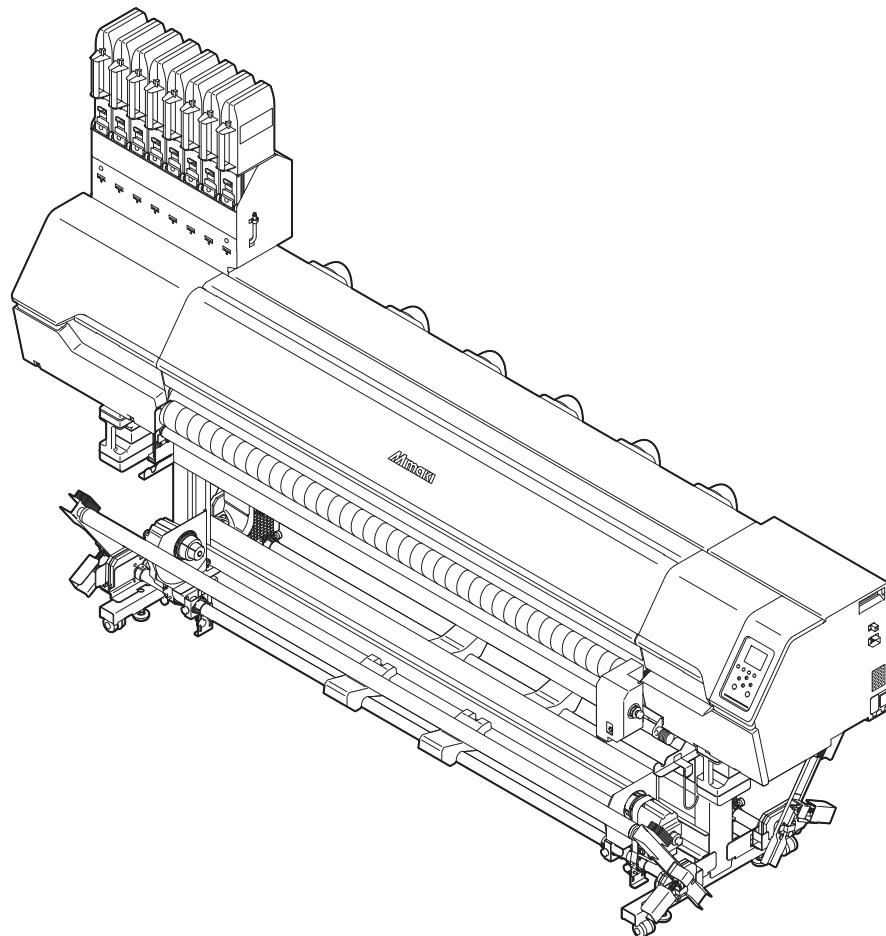
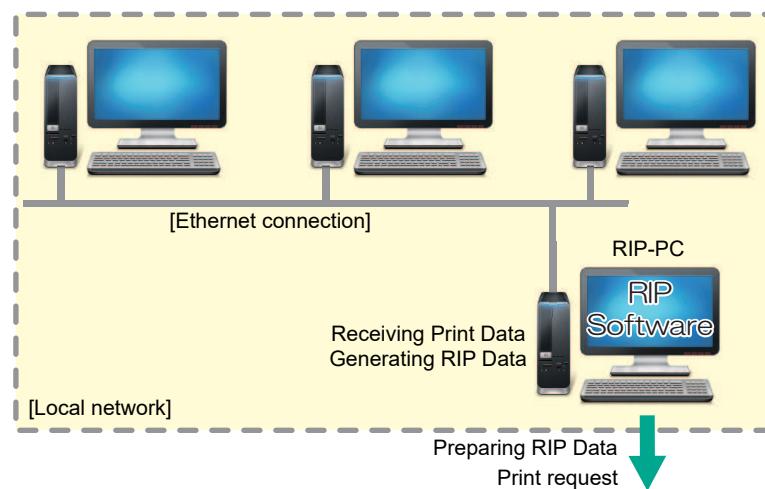
- Data may be transferred to the machine too slowly, causing the carriage to pause at the left-hand or right-hand end during printing.

● USB Connection Precautions

- When connecting more than one Tx330-1800 to a PC
 - If the PC has more than one USB port, try connecting to a different USB port to check whether the product is correctly recognized. If the product is still unrecognized even when connected to a different USB port, use a commercially-available USB active repeater cable.
- When extending the USB cable
 - Use a commercially-available USB active repeater cable. However, make sure that the combined length of the USB cable and the USB active repeater cable does not exceed 20 m.
 - If the USB cable is extended, this may reduce the data transfer speed to the machine, causing the carriage to pause at the left-hand or right-hand end during printing.
- USB high-speed mode peripheral devices
 - It may not be possible to recognize USB peripheral devices if USB high-speed mode peripheral devices (e.g., USB memory, USB HDD devices) are connected to the PC to which the product is connected. If external USB hard disk drives or other similar devices are connected, this may reduce the data transfer speed to the machine, causing the carriage to pause at the left-hand or right-hand end during printing.
- Unplugging USB memory devices
 - When unplugging USB memory devices from the PC to which this product is connected, use "Stop" in "Safely removing hardware" before unplugging. Otherwise, an [ERROR 201 Command Error] will occur.

1.4 System Configuration

Use RIP software to request to print data created using applications like Illustrator or Photoshop.



Installing the Mimaki Driver

1 Download the Mimaki driver from our website.

- <https://mimaki.com/download/inkjet.html>
[Tx330-1800] > [Driver/Utility]

2 Install the MIMAKI driver.

Installing RIP Software

The explanation here applies to MIMAKI RIP software (RasterLink).

Important! • If using TxLink, refer to the TxLink operating manual.

1 Install RasterLink.

- The following icon appears on the PC desktop once the software has been installed.



- For more information, refer to the RasterLink installation guide. <https://mimaki.com/download/software.html>



- Once installed, activate the license for Rasterlink. Otherwise, "Profile Update" will not start.

Obtaining Color Profiles

Print quality (e.g., tone, bleeding) will vary depending on the media and ink set. To maintain consistent print quality, select a color profile that suits the media and ink set.

- The RasterLink Series includes a function allowing color profiles to be downloaded and installed directly from the Internet. For more information, refer to "Installing Profiles" in the RasterLink Series installation guide.
<https://mimaki.com/download/software.html>
[RasterLink Series used] > [Manuals]
- Color profiles for Mimaki RIP software (RasterLink) are available on the Mimaki website.
<https://mimaki.com/download/inkjet.html>
[Tx330-1800] > [Profile]

Setting Up RIP Software

The explanation here applies to MIMAKI RIP software (RasterLink).

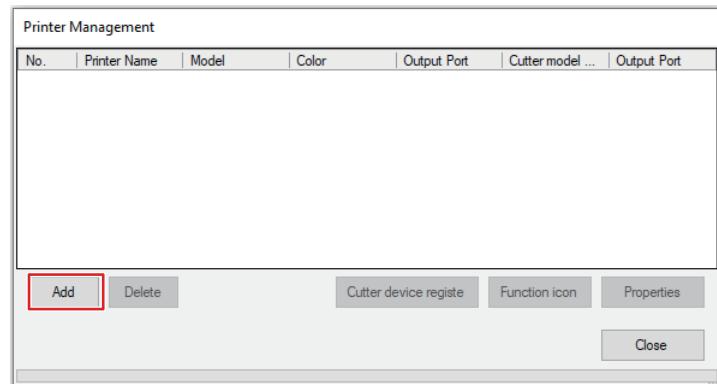
Important! • If using TxLink, refer to the TxLink operating manual.

1 Launch RasterLink.

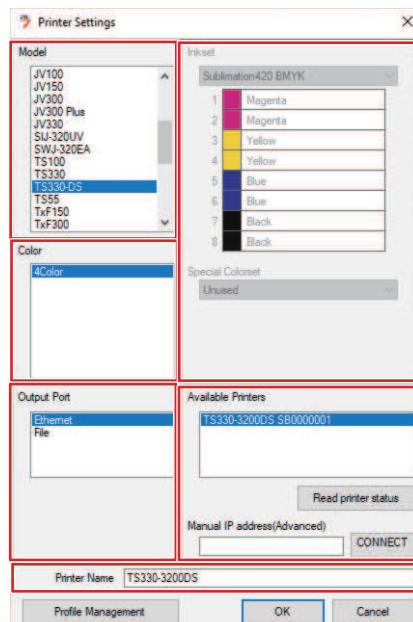
- The [Printer Management] screen appears.
- To add a new model, launch RasterLink, then select [Environment] > [Printer Management].

2 Register Tx330-1800.

(1) Click [Add].



(2) Set the specifics for Tx330-1800.



- Model: Select the model.
For models using normal ink sets, select [Tx330]. For models using hybrid ink sets, select [Tx330-Hybrid].
- Color: Select the ink set filled.
- Output Port: Select the cable connected.
- Available Printers: Select Tx330-1800 connected.
- Printer: Enter a name as required.

(3) Click [OK].

- A confirmation screen appears.

(4) Click [Yes].

- Printer registration starts.



- For more information, refer to the RasterLink installation guide. <https://mimaki.com/download/software.html>

1.5 Ink Replacement Method

When Ink Near End is Displayed

Ink levels are low. We recommend replacing with new ink as soon as possible, because the ink packs are nearly empty. Printing is still possible but continuous printing is not, and some maintenance functions such as cleaning are disabled. Note that ink may run out during printing.

To check which color ink needs to be replaced, press the [ENTER] key on the LOCAL mode screen.  "Displaying Machine Information (Local Guidance)"(P. 32)

When Ink End is Displayed

The ink has run out. Replace with new ink.

Thoroughly read the following and make sure you understand its contents.

 "Notes on Handling Ink or any Other Liquid Used with the Machine"(P. 12)

- Pay close attention to ventilation and be sure to wear safety glasses, gloves, and a mask when handling ink, maintenance liquid, waste ink, or other solutions used with the machine. Leaking ink may adhere to the skin or get into the eyes or mouth.

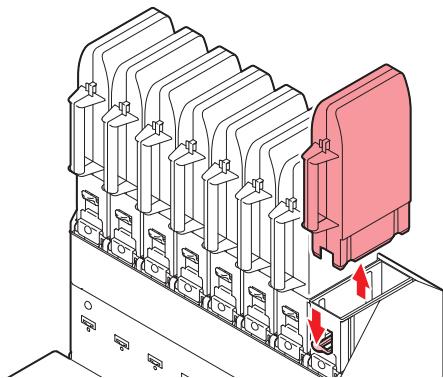


Replacing Ink

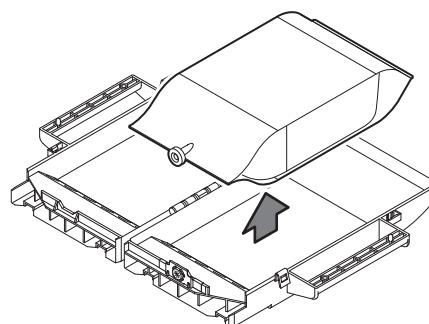
Ink replacement procedure

● Removing Ink Eco-cases

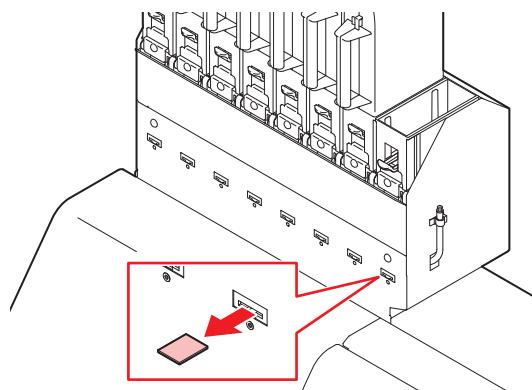
- 1 Push down the lever on the pedestal, and remove the ink Eco-case.



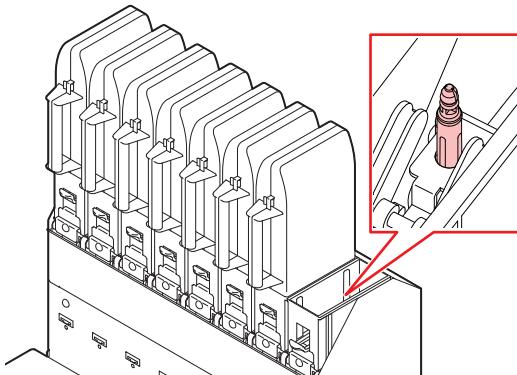
- 2 Open the ink eco-case, then remove the ink pack.



- 3 Remove the ink IC chip.



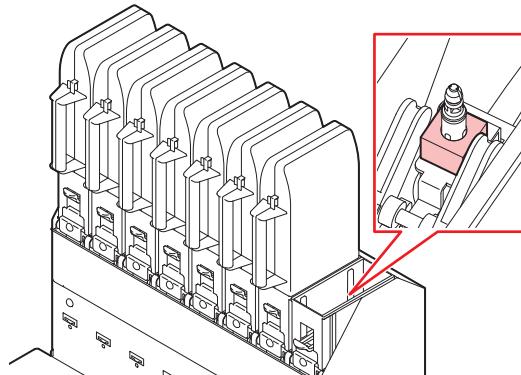
4 Wipe off any ink adhering to the ink eco-case opening.



- Check to confirm no foreign matter such as dust or paper towel matter is adhered to the opening. If foreign matter is present, this may block the ink path and lead to leakage.



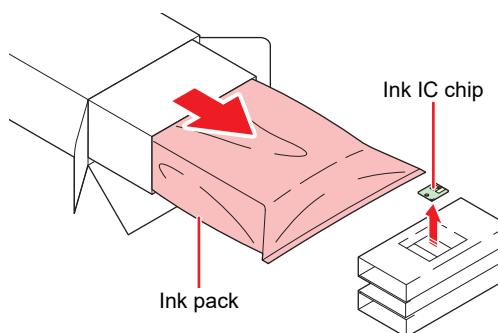
- We recommend replacing the ink absorber each time you replace the ink pack, to prevent dirt building up on the pedestal of the ink supply unit.



- When disposing of ink, maintenance liquid or other liquid used with the product, or the container or paper towel to which ink or other liquid is attached, contact an industrial waste disposal operator or dispose of the product in accordance with the local laws and regulations.

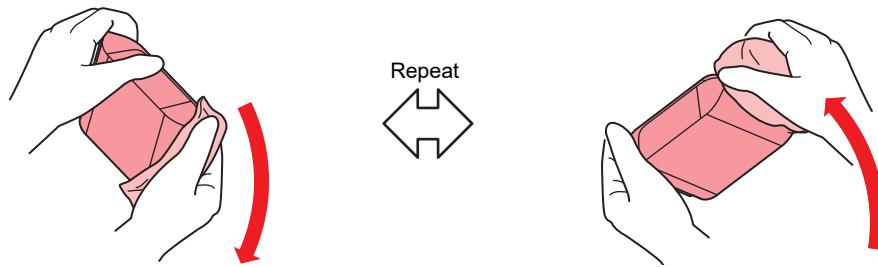
● Preparing the Ink

1 Pull out the ink pack and ink IC chip from the ink package.



2 Shake the ink pack to the left and right slowly at least 20 times.

- Shake the bottle slowly from left to right to ensure that the ink moves inside, holding the ink pack opening with a paper towel.

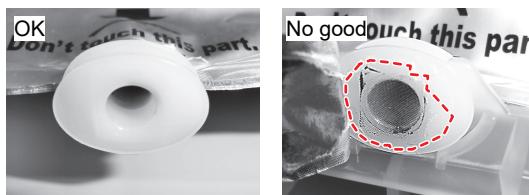


- When using an ink pack with ink remaining, hold a paper towel over the ink eco-case opening and shake slowly with the ink eco-case tilted upright.

3 Remove the seal attached to the ink pack opening.

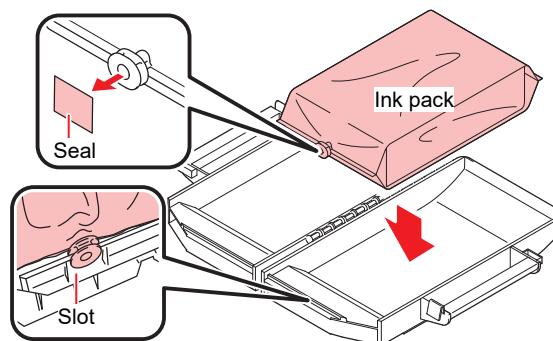


- Remove the seal completely. If any parts of the seal remain, ink may leak when the ink eco-case is removed from the base.



4 Place the ink pack inside the ink eco-case.

- Push the ink pack connector into the ink eco-case slot. Ink may not be supplied if the connector is out of position.
- Position the pack as indicated on the label on the ink eco-case.



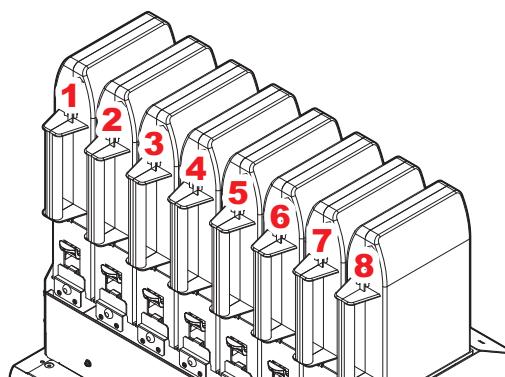
5 Close the ink eco-case gently to avoid pinching the ink pack.



- Be careful to avoid catching your hands or fingers.

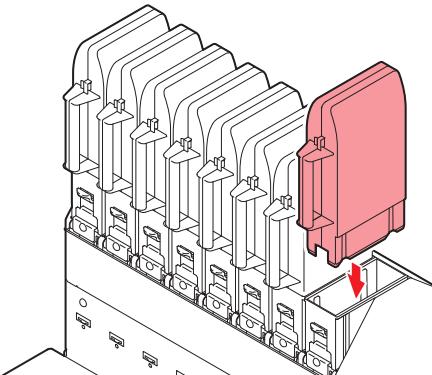
● Mounting the ink

The order of the ink eco-cases to be set varies depending on the ink set you are currently using. Check the ink slot numbers, then insert the correct color ink eco-cases.



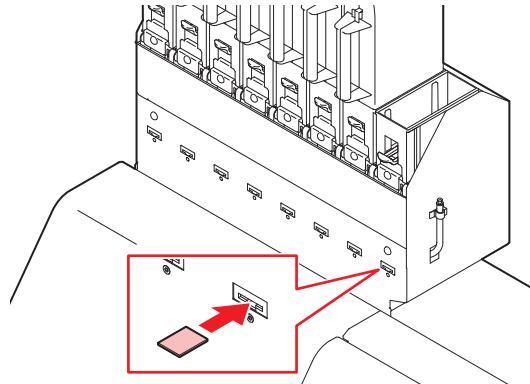
Ink set	Ink positions							
	1	2	3	4	5	6	7	8
Sb420 (4-color)	M	M	Y	Y	BL	BL	K	K
Sb420 (6-color)	M	LM	Y	LBL	BL	BL	K	K
TP410 (4-color)	M	M	C	C	K	Y	K	Y
TP410 (8-color)	M	R	C	BL	Lk	G	K	Y
Sb411/Sb420 (4-color, hybrid)	Sb411				Sb420			
Sb411, Sb420/TP410 (4-color, hybrid)	Sb411, Sb420				TP410			
	M	Y	BL	K	M	Y	BL	K

1 Set an eco-case on the base.



- Fully push in the eco-case. Otherwise, ink may not be fed properly.

2 Insert the new ink IC chip into the ink IC chip slot.

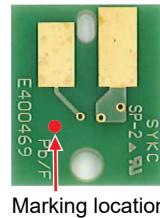


- Insert the ink IC chip with the metal side facing up. Inserting it in the wrong way may cause failure of the machine or damage the ink IC chip.



- Do not touch the metal parts of the ink IC chip. Static electricity may damage the ink IC chip, and dirt or damage may cause the ink IC chip read error.

- Ink IC chips:** The marking on the ink IC chip indicates the color information.



Ink Color	Marking
Cyan	● (One blue circle)
Magenta	● (One red circle)
Yellow	● (One yellow circle)
Black	● (One black circle)
Light cyan	●● (Two blue circles)
Light magenta	●● (Two red circles)
Light black	●● (Two black circles)
Orange	● (One orange circle)
White	○ (One white circle)
Blue	●● (One blue circle/one red circle)
Light blue	●●● (Two blue circles/one red circle)
Red	●● (One red circle/one yellow circle)
Green	● (One green circle)



- Insert the ink IC chip included in the package with the ink. The ink IC chip stores information such as the ink color, remaining amount, and expiration date. Printing is not possible if an incorrect ink IC chip is inserted.

Chapter 2 Printing



This chapter

This chapter describes printing procedures and settings.

Print Process	48	Test Printing	94
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2.1 Print Process

1. Attaching or Removing the Platens

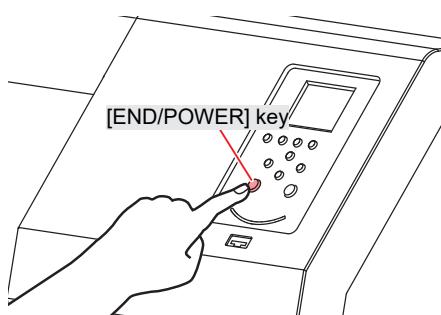
 "Attaching or Removing the Platens"(P. 51)

2. Attaching the Ink-Receiving Pan Spacers

 "Attaching the Ink-Receiving Pan Spacers"(P. 54)

3. Turn on the power.

 "Turning On the Power"(P. 33)



4. Connect a RIP PC to the machine.

 "Using a USB Cable"(P. 37)

 "Using a LAN Cable"(P. 36)

5. Setting Up RIP Software

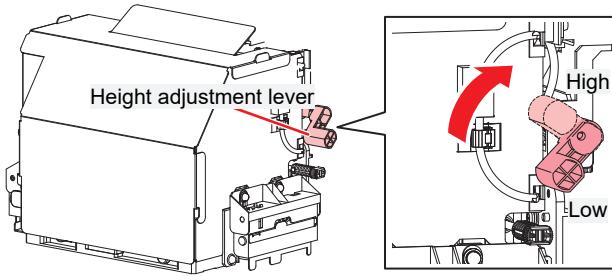
 "Installing RIP Software"(P. 39) (required first time only)

 "Obtaining Color Profiles"(P. 39)

 "Setting Up RIP Software"(P. 39) (required first time only)

6. Adjusting Print Head Height

Adjust the height adjustment lever to suit the media.  ["Adjusting Print Head Height"\(P. 56\)](#)



7. Prepare the tension roller.

 ["Preparing the Tension Roller"\(P. 58\)](#)

- This is performed when printing on cloth media.

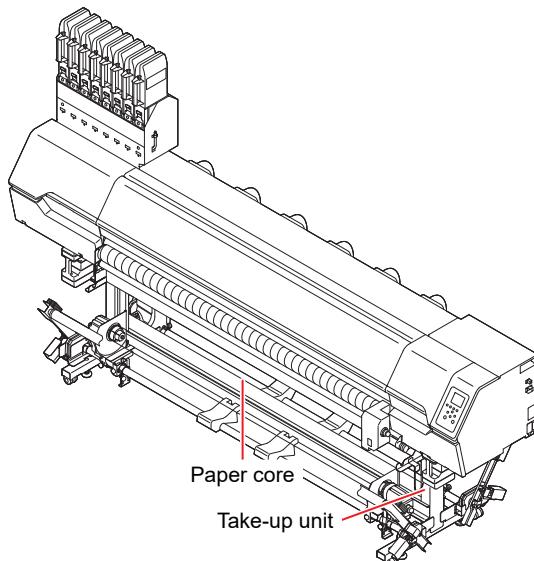
8. Setting Up the Fabric Roller

 ["Setting Up the Fabric Roller"\(P. 59\)](#)

- This is performed when printing on cloth media.

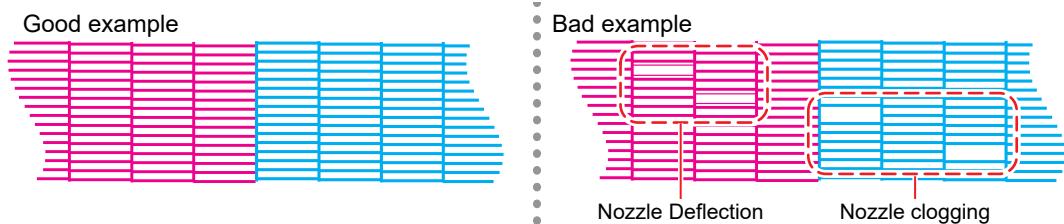
9. Loading the Media

This machine can be used with roll media and leaf media.  ["Loading the Media"\(P. 61\)](#)



10. Check the state of the print head nozzles.

 "Test Printing"(P. 94)

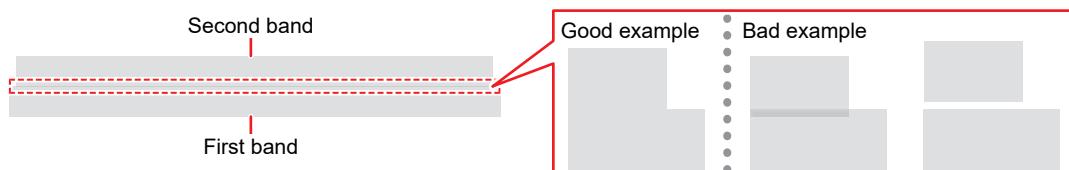


11. Clean the head to clear malfunctioning nozzles.

There are three different head cleaning methods. Choose the head cleaning method based on test print results.  "Head Cleaning"(P. 96)

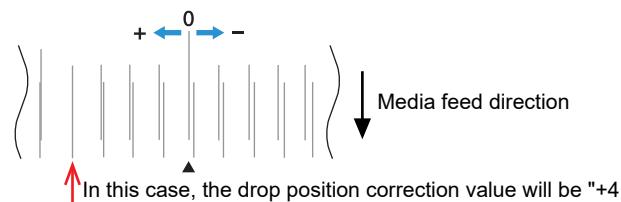
12. Adjust the media feed amount.

 "Feed Correction"(P. 97)



13. Adjust the drop position for bi-directional printing.

 "Correcting the Drop Position"(P. 99)



14. Preparing RIP data

 "Preparing RIP data"(P. 101)

15. Printing RIP data

 "Printing"(P. 103)

2.2 Attaching or Removing the Platens

The Tx330-1800 supports printing on both cloth media and paper media (decalcomania paper). Attach or remove the platens to suit the media being used.



- Be sure to turn off the main power supply before attaching or removing the platens.
- Be sure to clean the platens before removing if they are dirty.
- Take care to avoid getting ink on your hands or clothes.



- If the media is already loaded, first remove the media before attaching or removing the platens.



- When using cloth or transfer paper that does not bleed through, set the platens for use with paper media. "When using paper media"(P. 53)

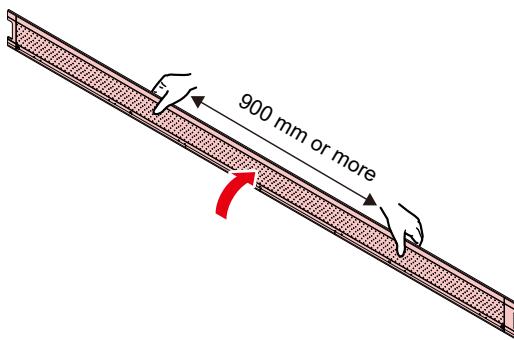
Holding the platens

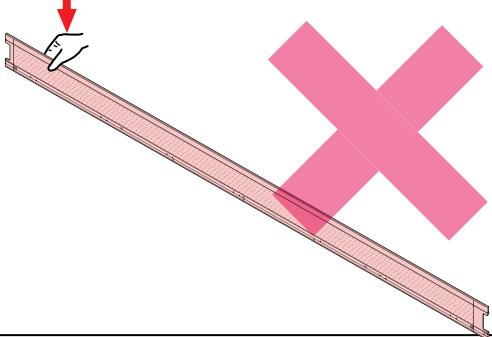
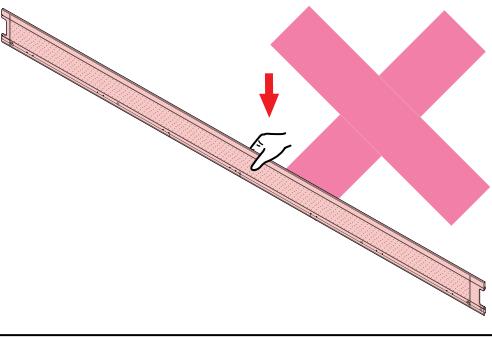


- The platens consist of thin sheet metal. Wear gloves and take care to avoid cutting your hands.
- Take care not to hit other people or objects when carrying the platens.

Hold the platens with two hands in the center at least 900 mm part.

Hold the platens raised 90 degrees forward from when they are attached flat on the main unit.



Not Acceptable	
	
Holding at only one end	Holding at only one point in center

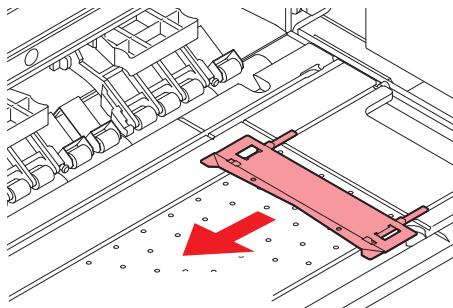
When using cloth media

When using cloth media, remove the platens and use ink-receiving pan spacers.

● Procedure

1 Open the front cover.

2 Remove the left and right media holders from the platen (one on each side).

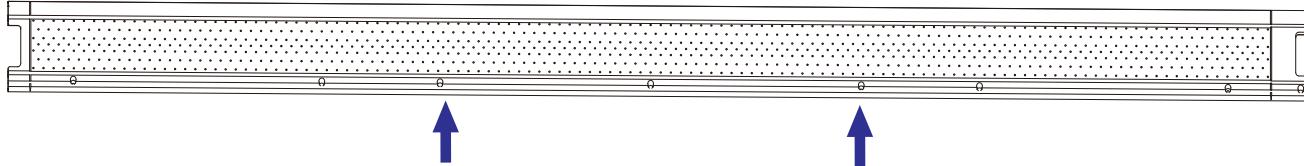


3 Lift up the platens.

- The platens are firmly secured with magnets. Lift up from the platen attachment and removal section as follows:

(1) Insert the platen removal jig provided between the platen attachment and removal section and the platens.

[Platen removal jig insertion positions]



(2) Use the platen removal jig to push up and lift the platens from the platen attachment and removal section.

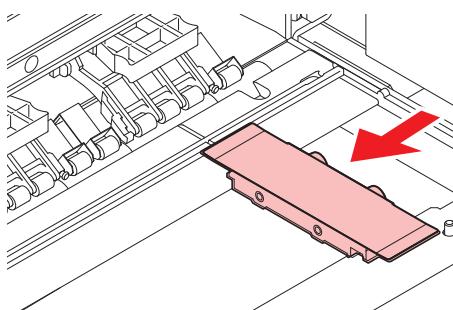


- Take care when lifting the platens, as they are secured with magnets, and may spring up.
- Do not use excessive force when inserting the platen removal jigs. Doing so may damage parts.

4 Pull the raised platens forward to remove them from the platen attachment and removal section.

5 After removing them, store the platens in the platen holder underneath.  "Platen holder"(P. 27)  "Holding the platens"(P. 51)

6 Attach the left and right cloth holders (one on each side).

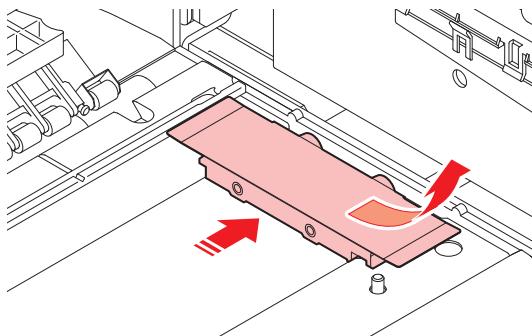


When using paper media

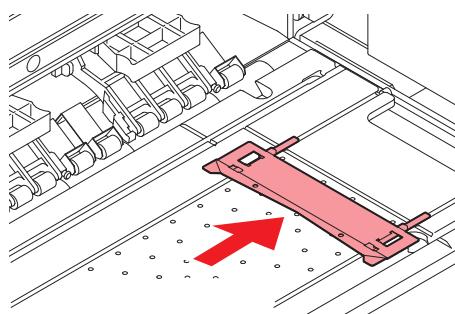
When using paper media, remove the ink-receiving pan spacers and install the platens.

● Procedure

- 1** Open the front cover.
- 2** Remove the left and right cloth holders (one on each side).
 - Move toward the maintenance space to remove them.
 - Remove the ink-receiving pan spacer, if fitted.



- 3** Remove the platens from the platen holder. ["Platen holder"\(P. 27\)](#) ["Holding the platens"\(P. 51\)](#)
- 4** Align the end of the platen with the right edge of the platen attachment and removal section, butted against it.
- 5** Align the pin at the end of the platen with the groove on the platen attachment and removal section and fully insert it.
- 6** Attach the left and right media holders (one on each side) to the platens.



- Take care to ensure that no paper scraps or threads are trapped when pushing the platens up flush.
- Remove any paper scraps or threads before proceeding.
- Take care not to trap your fingers when attaching the platens, as the magnets are powerful.
- Install carefully, so that the media holders do not get caught.



- Check to confirm that the platens are securely installed and do not lift up.
- Clean the platens after installation if they are dirty. ["Platen and Platen Wire Cleaning"\(P. 135\)](#)

2.3 Attaching the Ink-Receiving Pan Spacers



- This is performed when printing on cloth media.

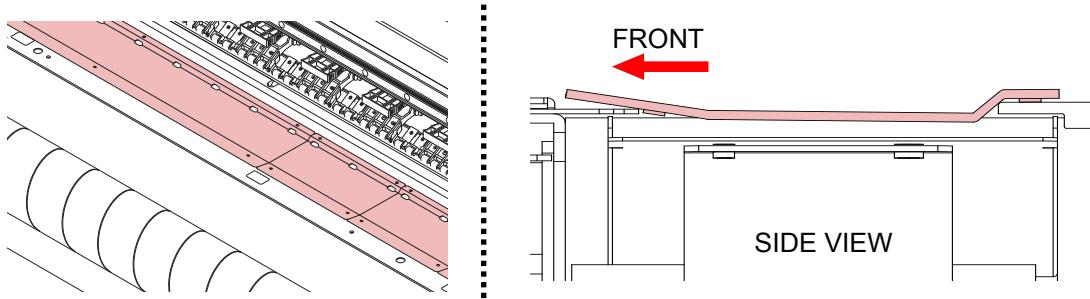


- Be sure to attach the ink-receiving pan spacers to prevent the media from being made dirty by the ink mist when printing.

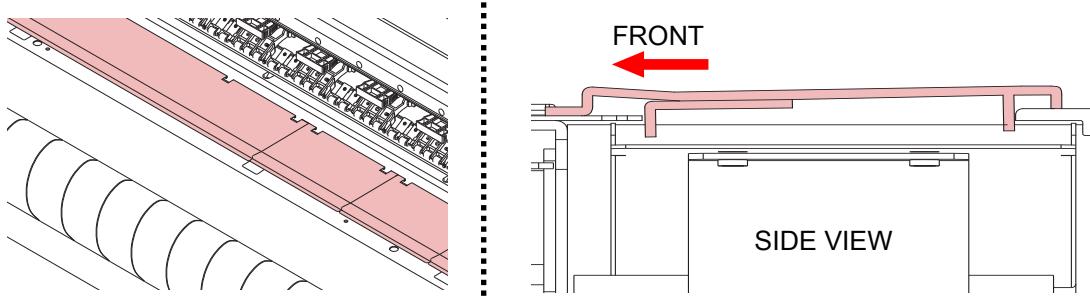
● Information about the ink-receiving pan spacers

Two types of ink-receiving pan spacers are provided as standard.

- Ink-receiving pan spacer 1 (650 wide × 2, 130 mm wide × 5)



- Ink-receiving pan spacer 2 (650 wide × 2, 130 mm wide × 5)



- When printing on media with a coarse texture (mesh media) in a low-humidity (35 %RH or less) environment, use the ink-receiving pan spacer 2.

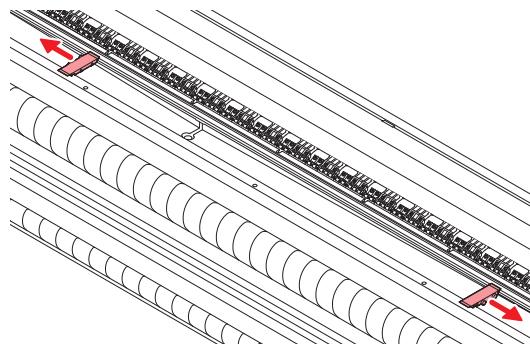


Note the following when using the ink-receiving pan spacer 2:

- Keep the media tensioned, to avoid ink adhering to the underside.
- Use the tension bar and tension roller.
- The media may sag if it comes into contact with the tension bar, causing ink to adhere to the underside.
- When removing prints, use the key or white space function to feed the media out first.

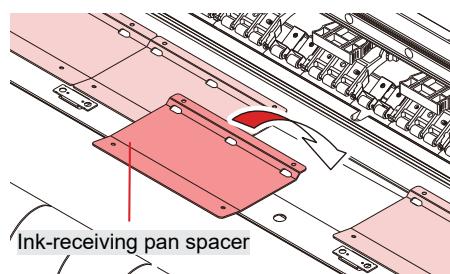
- Ink-receiving pan spacer attachment and removal procedure

1 Move the cloth holders to the left and right sides.



2 Attach the ink-receiving pan spacers.

- Determine how many ink-receiving pan spacers to attach based on the width of images to print.



Guidelines for attaching the ink-receiving pan spacers

- Select so that the width of the ink-receiving pan spacers is not narrower than the width of the image being printed.
- Adjust the number of spacers to ensure a margin of at least 10 mm from both the left and right edges of the image.
- If overprinting, lay out the ink-receiving pan spacers so that they extend beyond the width of the media.

2.4 Adjusting Print Head Height

Adjust the height of the print head according to the thickness of the media you are using.



- Be sure to correct the dot position after altering the print head height. "Correcting the Drop Position"(P. 99)

(Important!)

- With inkjet printers, if the gap between the print head and media increases, the ink droplets tend to vaporize before they reach the media. Vaporized ink may adhere to the print head nozzle surface and media, affecting print quality and causing failure of the print head. Adjust the print head height to suit the media.

1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

2 Select [Station Maint.] > [Carriage Out] > [Move To Platen Right End], then press the [ENTER] key.

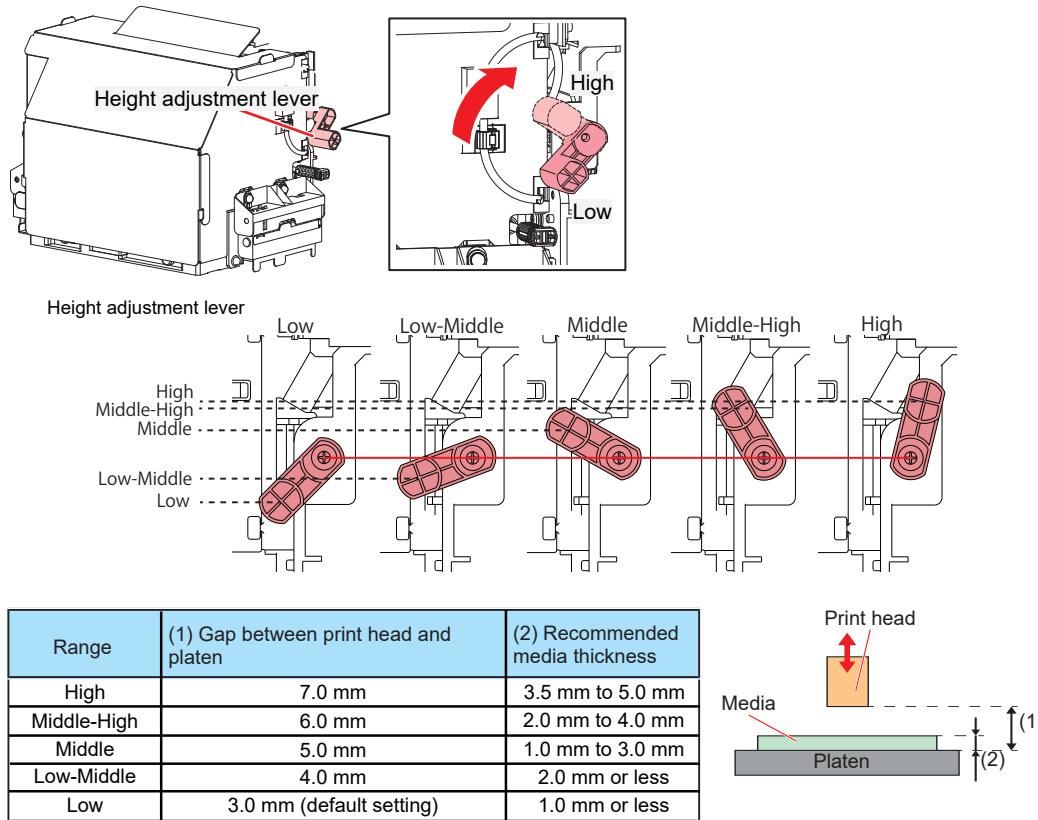
- The carriage moves over the platen.

3 Open the front cover.

4 Use the height adjustment lever to adjust the height.

(Important!)

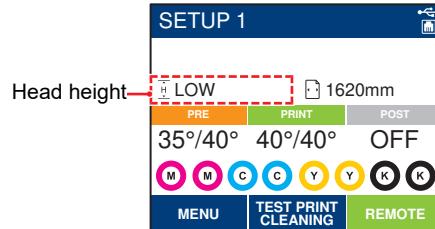
- Set the height adjustment lever so that the desired height is at the top. If the lever is not set to the correct position, problems such as media jamming and misting may occur, resulting in impaired print quality.
- When doing this at High, be careful not to push the lever too far to the rear.



5 Once adjustment is complete, close the cover, then press the [ENTER] key.



- Check the head height indicated on the display. Readjust the height using the height adjustment lever if it is not at the set height.



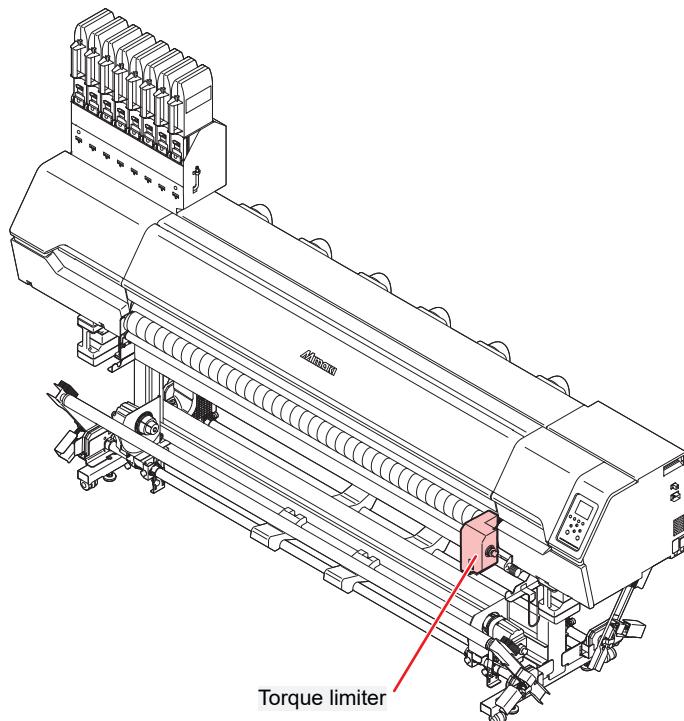
2.5 Preparing the Tension Roller

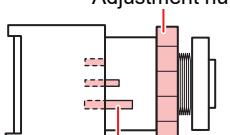
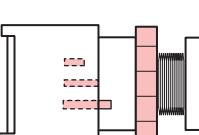
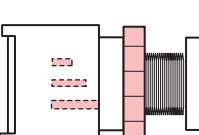


- This is performed when printing on cloth media.

Adjusting the torque limiter

The tension roller is fitted with a torque limiter. Turn the torque limiter adjustment nut to adjust the force with which the roller turns.



Min	Mid (recommended)	Max
 Adjustment nut	 Mid (recommended)	 Max

- Clockwise: Increases the tension (thicker media)
- Counterclockwise: Reduces the tension (lighter media)



- If the torque limiter adjustment is too weak, the media will tend to meander and print quality will be reduced.
- If the torque limiter adjustment is too strong, this may cause wrinkling in some media and print quality will be reduced.



If the tension roller spins when the media is loaded

- The torque limiter adjustment is too strong. Either weaken the torque limiter or increase the weight of the tension bar.
- The tension roller torque limiter should be set to "Mid" when printing on cloth media.



2.6 Setting Up the Fabric Roller

When printing on to coarse cloth, ink remaining on the back of the cloth may adhere to the tension roller and dirty the cloth media.

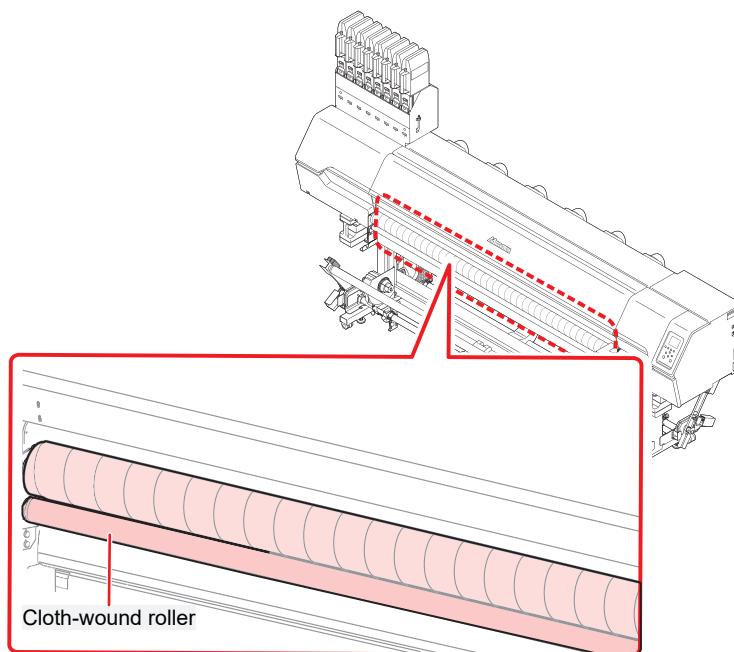
Attaching the fabric roller helps to prevent the cloth media from becoming dirty by removing any ink adhering to the tension roller.

(Important!)

- The fabric roller is not shipped with cloth wound on it. Prepare suitably absorbent cloth that meets the following conditions.
- Adjust the length etc., to suit the cloth used. (Make sure that the fabric roller is in contact with the tension roller at the center and ends.)
 - (1) Material: Cotton jersey, cotton broadcloth, etc.
 - (2) Size: 195 cm × 70 cm (approximate)

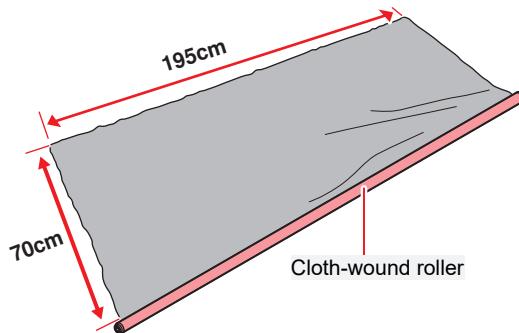
1 Remove the fabric wound roller.

- The fabric roller is located below the tension roller.

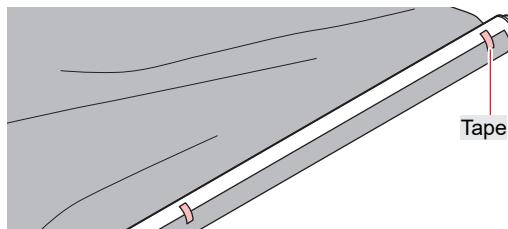


2 Wind cloth around the fabric roller.

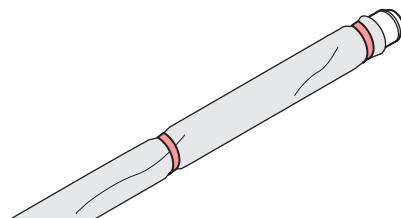
- (1) Align the cloth with the roller.



- (2) Secure the cloth to the roller with adhesive tape.

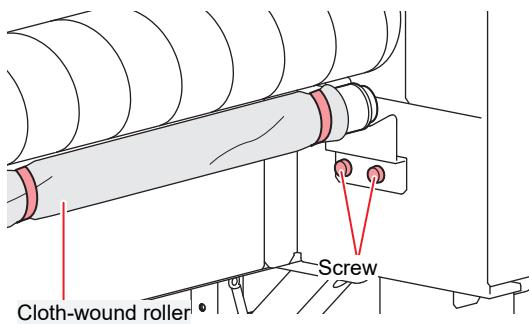


- (3) Wind the cloth around the roller, then secure with adhesive tape.



3 Attach the fabric roller with the cloth wound on it.

- Mount the fabric roller in the groove below the tension roller.
- Adjust the positions of the bearings at both ends of the fabric roller.
Loosen the screws on the bearing, then adjust so that the fabric roller makes contact with the tension roller.



(Important!)

- Clamp in place so that the fabric roller is in contact with the tension roller at the center and both ends.
If the rollers are not in contact at the center and both ends, the size of the cloth wound on to the fabric roller should be changed accordingly.

4 Rotate the tension roller by hand to confirm that it turns smoothly.

- If the tension roller does not turn smoothly, check the mounting position of the fabric roller.

2.7 Loading the Media



- Adjust the head height before loading media. Moving the carriage after the media has been loaded may result in the print head coming into contact with the media and being damaged.

Media

● Media handling precautions



- Use Mimaki-approved media to ensure consistent high-quality printing.

⚠ WARNING



- Assign at least two persons to load roll media. (Assign up to six persons to this task depending on the media weight.)
- When loading roll media, be careful to avoid dropping it on your feet. Also be careful to avoid catching your fingers. Disregarding this precaution may result in injury due to the weight of media.

NOTICE



- When using a lifter to load media, prepare a suitable one by checking the specifications.



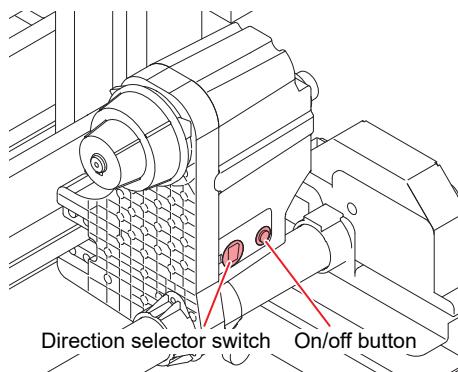
- Do not leave the media in the machine when not in use. Otherwise dust may accumulate on the media. Do not use media that has been wiped free of dust. Wiping media can generate static electricity, possibly affecting print quality.
- Do not use media immediately after removing it from the package. The media may expand or contract depending on the temperature and humidity of the location in which it was stored. Allow the media to stand for at least 24 hours in the same indoor environment as the machine before loading it.
- Do not use media if it is curled. Curled media may not only damage the print head, but may also affect print quality.



- Avoid storing unopened media in hot or humid places, or in direct sunlight.
- After opening, be careful not to touch the surface (especially the printing surface).

Take-up unit

Use the switch on the take-up unit to change the media take-up direction.



Name	Overview	
Direction selector switch	Up (reverse)	Taken up with the printed surface inside
	Down (forward)	Taken up with the printed surface outside
On/off button	Activates/deactivates take-up. <ul style="list-style-type: none"> With a torque limiter attached: Pressing the button activates the take-up unit, which continues the take-up operation until you press the button again. ^{*1} With a direct-connection unit attached: Activates take-up only while the button is pressed. 	

*1. If you want to configure settings so that the feeding operation is performed only while you are pressing the on/off button, use the feeding/take-up switch settings in the options for roll unit selection. With setup menu margins set to the minimum (5 mm) on either side.  "Function Setting Menu"(P. 116)

Replacing the direct-connection unit/torque limiter

The take-up/feeding unit should be replaced with a direct-connection unit when tension bars are used, or with a torque limiter when tension bars are not used.

The torque limiter can change the strength of take-up/feeding operations. (As shipped, the torque limiter is set to medium.)

Reduce the level of this setting if there is too much tension for lightweight media.

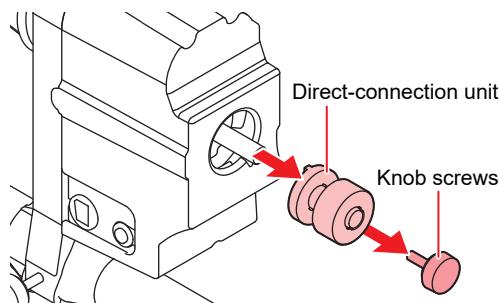
- For paper media (transfer paper), use the torque limiter.

● Torque limiter attachment

For media take-up without using tension bars, the direct-connection unit must be replaced with the torque limiter.

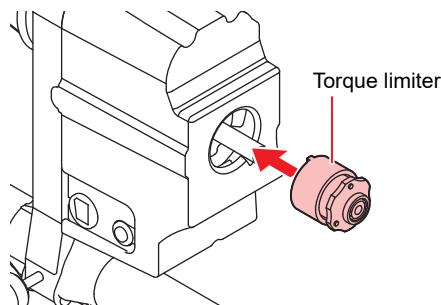
1 Remove the direct-connection unit.

- Remove the knob screw, then remove the direct-connection unit.



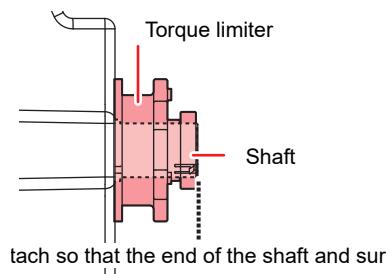
2 Attach the torque limiter.

(1) Insert the torque limiter.

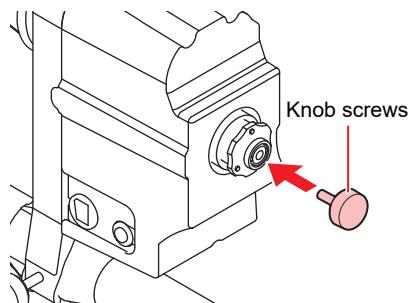


(2) Attach the torque limiter so that the surface is flush with the end of the feeding/take-up unit shaft, as shown.

- Efficient media take-up is not possible unless the end of the shaft and the torque limiter surface are flush.



(3) Tighten the knob screw to secure the torque limiter.

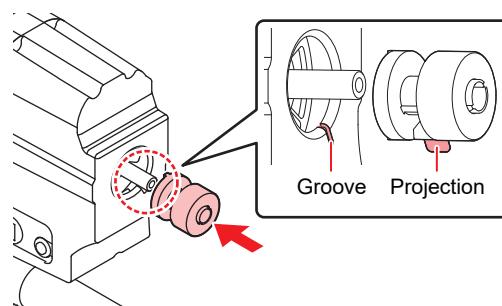


● Direct-connection unit attachment

Also refer to the instructions for torque limiter replacement when replacing the torque limiter with the direct-connection unit.

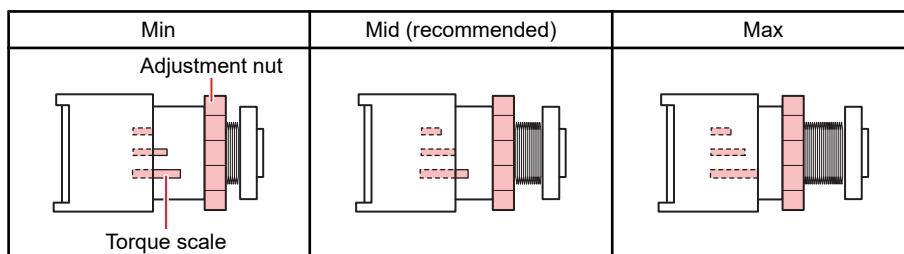


- Attach the direct-connection unit so that the lug on it is aligned with the groove of the feeding/take-up unit.



Adjusting the torque limiter

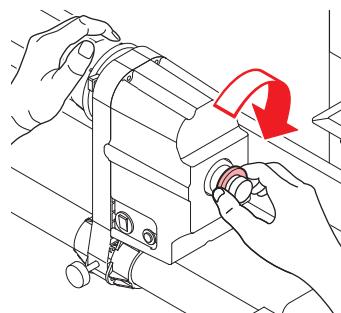
Turn the torque limiter adjustment nut to adjust take-up tension. When adjusting the torque limiters, be sure to adjust to the same torque for both the left and right take-up units.



- For normal printing: Adjust the torque to "Mid".
- Depending on the media, increasing the torque may cause image defects due to the pinch roller and grit rollers failing to grip the media. Reduce the torque if the media slips.

● Increase tension (clockwise)

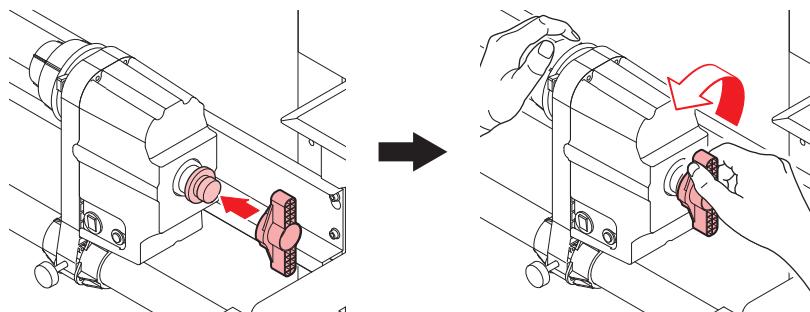
Increase tension when using with heavy or thick media, such as tarpaulin. Perform adjustments manually.



- Do not use the torque adjustment handle. Using the torque adjustment handle will cause overtightening. Overtightening may damage the take-up unit.

● Decrease tension (counterclockwise).

Decrease tension when using lightweight media. Use the "torque adjustment handle" provided.



Adjusting tension bar weight

Various types of media are available which feature a variety of thread thicknesses and are woven in different ways. Even with the same media, elasticity varies depending on pretreatment and other factors. To ensure correct tension when printing on such diverse media, the take-up/feeding tension bar must be weighted correctly using tension bar weights and weight-adjustment springs, and reversing bars must be mounted in the correct positions.

● Counterweights and weight-adjustment springs

You can adjust the weight of tension bars based on where you attach counterweights and how you attach weight-adjustment springs.



- Perform feed correction as described in "Feed Correction"(P. 97) before attaching counterweights or springs.

Media/printing conditions	Action
<ul style="list-style-type: none"> • The print surface is tautly tensioned. • Printing is consistent. • Minimal sagging or wrinkling is seen in the media. 	The media is correctly tensioned. No weight adjustment is required for the tension bar.
<ul style="list-style-type: none"> • Wrinkling occurs in the media feed direction. • The media meanders during printing. 	The media is excessively tensioned. Reduce the counterweights to reduce the weight on the tension bar to suit the media being used.
• The media sags and is not taken up smoothly.	The media is insufficiently tensioned. Increase the counterweights to increase the weight on the tension bar to suit the media being used.

(Important!) Counterweights

- The machine is not shipped with counterweights attached.
- A maximum of 700 g can be attached at each position. Check the media tension and attach a suitable amount of weight.
- Counterweights can be attached at four places: two on the feeding side and two on the take-up side (left and right, in both positions). Attach the same amount of weight at each of the four positions. Uneven weighting may bend tension bars and affect print quality.
- Keep unused counterweights in the box to avoid losing them.

(Important!) Weight-adjustment springs

- The machine is shipped with the green spring attached. Tension bar weight can be adjusted by removing springs or switching to a different type.
- Weight can also be adjusted by attaching weight-adjustment springs at two positions on the feeding side, at left and right. Set the springs in both positions to the same level. Uneven levels may bend the tension bars and affect print quality.
- Wear gloves when replacing or removing the springs. The shafts to which the springs are attached are greased. Do not wipe off the grease on a shaft.

● Tension bar adjustment

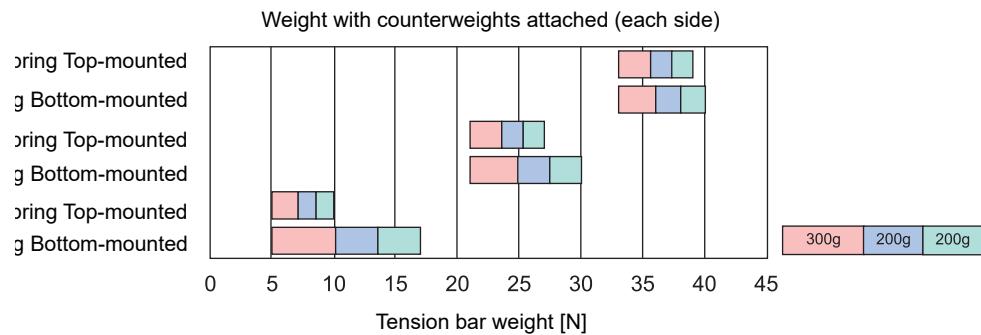
1 To adjust tension bar weight, change the weight-adjustment springs.

2 Add or remove counterweights to make tension bars heavier or lighter.

- When adjusting the weight, change it gradually.
- Keep unused weight-adjustment springs in the box to avoid losing them.

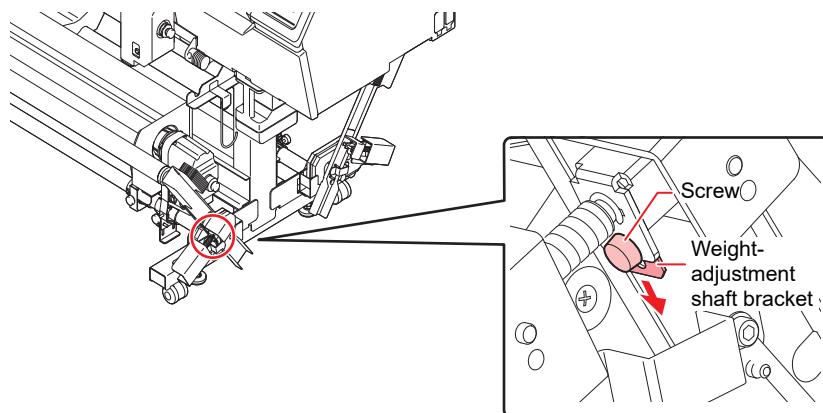


- For reference, this chart shows the combined effect of counterweights and weight-adjustment springs.



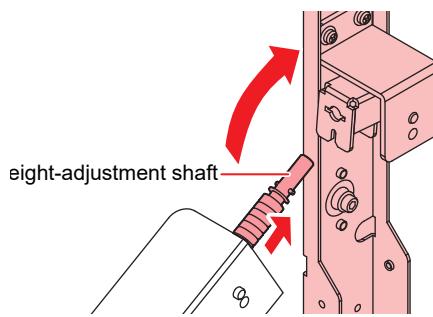
Attaching weight-adjustment springs

1 Loosen the screw and remove the bracket holding the weight-adjustment shaft.



2 Pull out the weight-adjustment shaft.

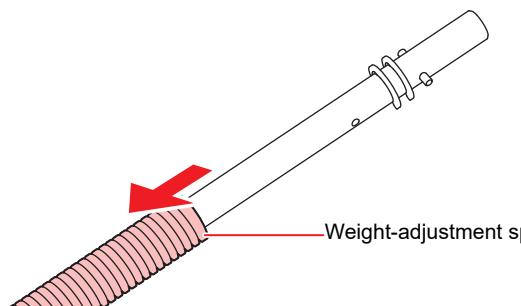
- Rotate the hole on the weight-adjustment shaft sideways, then raise the tension bar.



2

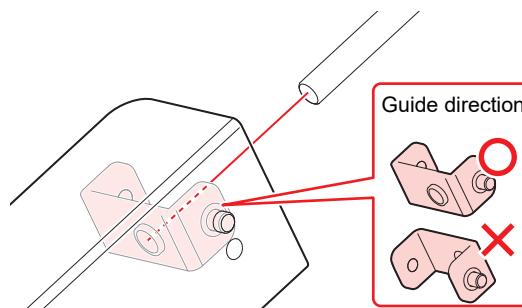
3 Remove the weight-adjustment spring currently attached.

- Otherwise, replace the current spring with a different one.

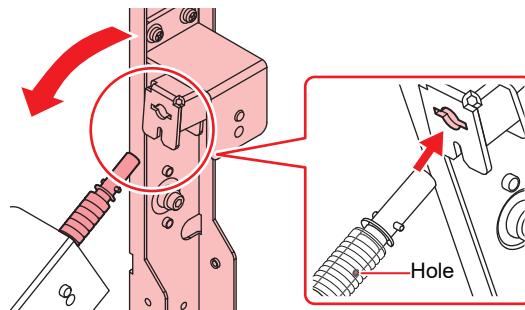


4 Attach the weight-adjustment shaft.

- When attaching the weight-adjustment shaft, make sure the guide is facing the correct way.



5 With the hole of the weight-adjustment shaft facing the side, insert the shaft and push the bracket all the way in.

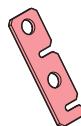


6 Tighten the screw.

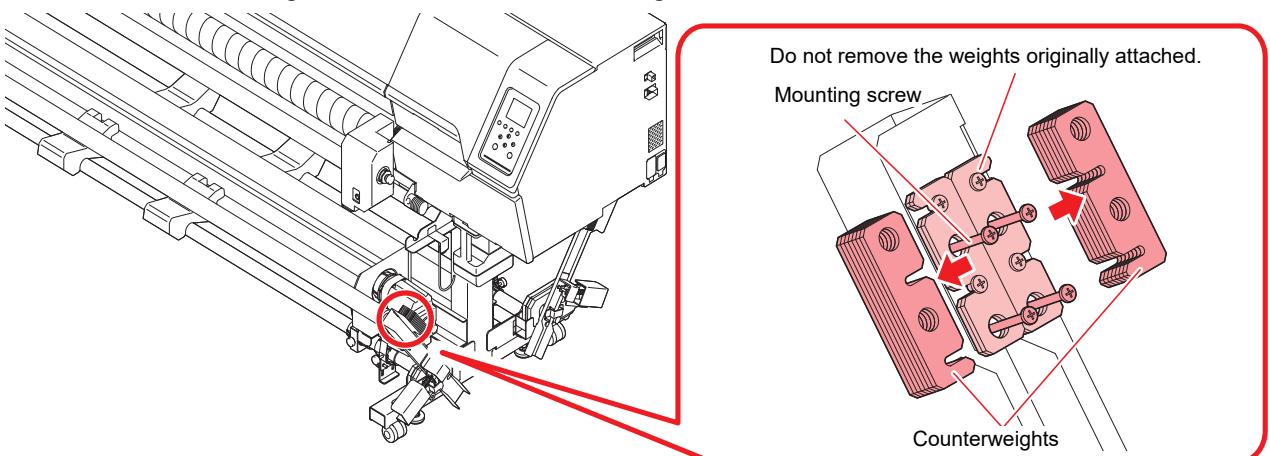
Attaching counterweights for tension bar weight adjustment



- If the counterweights shown below are included (28 weights, 50 g each), they can be attached as follows.
- Check the media tension and attach a suitable amount of weight.



- Consider media characteristics when deciding whether to attach counterweights.
- Up to 14 counterweights can be attached on each side, at left and right.
- Loosen the mounting screws to remove counterweights.



- When you will attach or remove the last counterweight in the stack, be sure to sufficiently loosen the mounting screws. If the screws are not sufficiently loose, the counterweight may catch on the screws of the weights originally attached, preventing removal.

Removing the roll media after printing

● Procedure

1 Cut the media.

- Use scissors or the like to cut away the printed portion.



- With paper media, be careful to avoid paper cuts from the cut edge.

2 Use the switch on the take-up unit to take up the printed media.

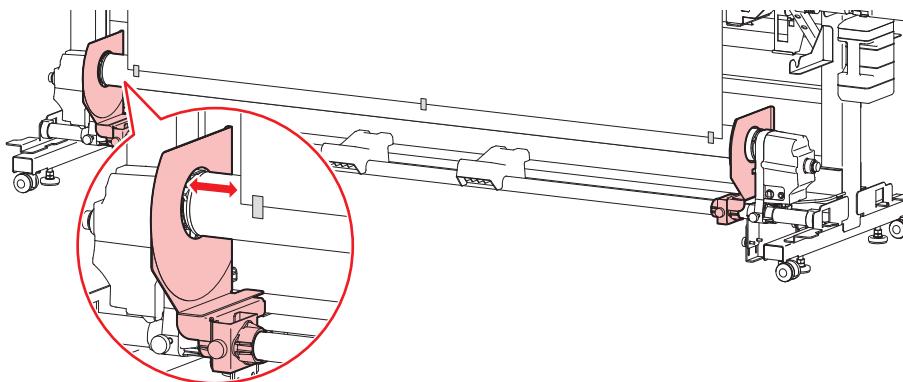
- For instructions on the take-up unit, refer to "Take-up unit"(P. 62).



- When continuing to use remaining cloth media, cut away any loose threads on the cut edge, so that the edge is neat. Loose threads may become caught in the pinch rollers and prevent correct media feeding.

Using media edge guides

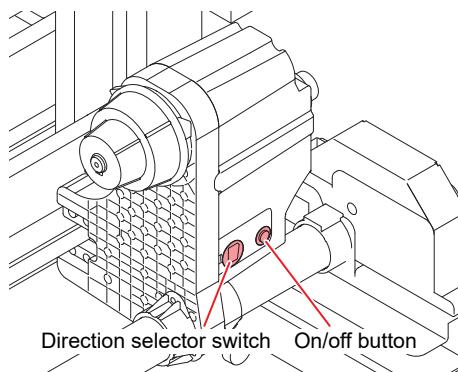
Adjust the media edge guide positions to suit the roll media diameter.



Media diameter	Distance between media edge guide and media edge
Not more than $\varnothing 120$ mm	1 mm
$\varnothing 121$ mm to $\varnothing 160$ mm	3 mm
$\varnothing 161$ mm to $\varnothing 200$ mm	5 mm

Feeding unit

The switches on the feeding unit can be used to change the media feed direction.

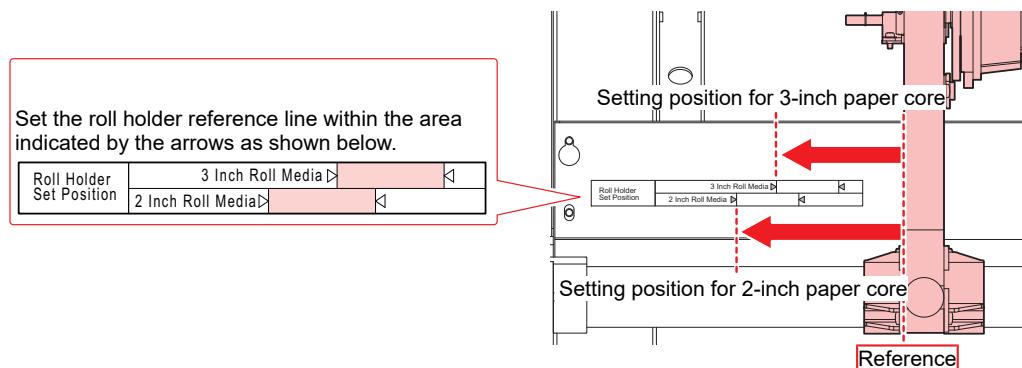


Name	Overview	
Direction selector switch	Up (reverse)	<ul style="list-style-type: none"> With a torque limiter attached: To apply tension to media printed on the outer surface, without using a tension bar. With a direct-connection unit attached: To feed media printed on the inner surface, using the tension bar.
	Down (forward)	<ul style="list-style-type: none"> With a torque limiter attached: To apply tension to media printed on the inner surface, without using a tension bar. With a direct-connection unit attached: To feed media printed on the outer surface, using the tension bar.
On/off button	<p>Activates/deactivates feeding.</p> <ul style="list-style-type: none"> With a torque limiter attached: Pressing the button activates the feeding unit, which continues the feeding operation until you press the button again. ^{*1} With a direct-connection unit attached: Activates feeding only while the button is pressed. 	

*1. If you want to configure settings so that the feeding operation is performed only while you are pressing the on/off button, use the feeding/take-up switch settings in the options for roll unit selection.  "Function Setting Menu"(P. 116)

Roll holder setting position

A label showing the roll holder setting position is placed on the leg stay. Use it as a reference to move the roll holder, then secure using the knob screw.



Loading Rolls of Cloth Media

Rolls of cloth media can be loaded on the printer with or without using tension bars. The media is detected as you load it.



- Remove the platens and set the machine for cloth media.
- When loading the media in the center, use the take-up extension cable.
- Adjust the head height to suit the intended use.
- When replacing cloth media after printing, refer to "Replacing Cloth Media After Printing"(P. 92).

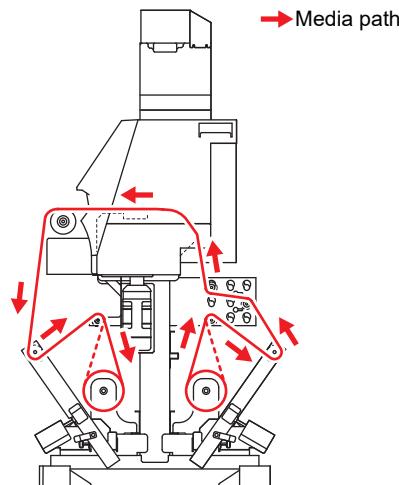
Using the tension bars

Follow these instructions to load media using tension bars for take-up and feeding.

The media path when loading cloth media with tension bars is shown in the following figure. Understanding the media path before loading will make loading easier.

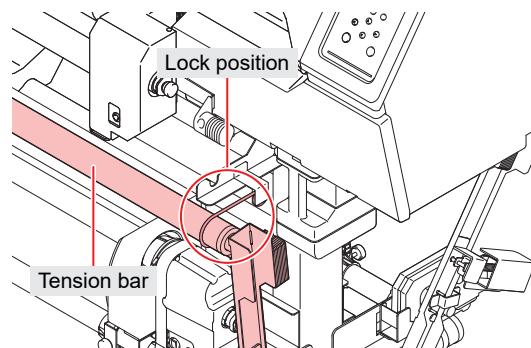


- Make sure the setting for selecting use of tension bars is set correctly.
- Before loading cloth media, make sure the area around the grit roller is clean. Clean this area if it is dirty.
- Before using the tension bar to load media, check that the direct-connection unit is attached to the feeding/take-up unit. If a torque limiter is attached, replace it with a direct-connection unit as described in "Replacing the direct-connection unit/torque limiter"(P. 62).



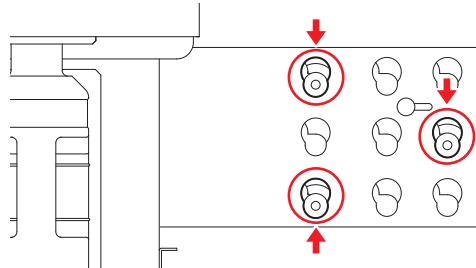
2

1 Secure the feeding and take-up tension bars by setting them in the locked position.

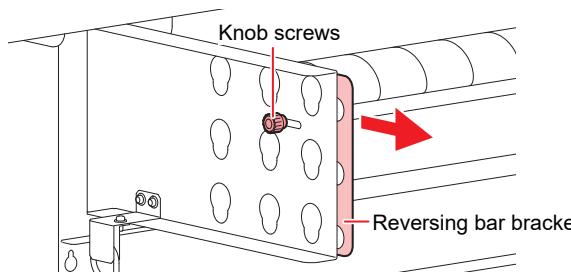


2 Attach reversing bars to suit the media you will load.

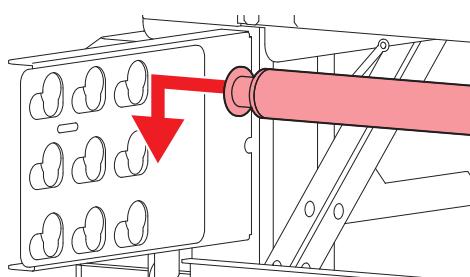
- To stabilize feeding-side tension, attach reversing bars at suitable positions for the media you will load.
- Recommended positions are shown below. If the media is loose or vertically wrinkled with the reversing bars in these positions, refer to  "Loading roll media without using tension bars"(P. 80) to set the tension appropriate for the media.



- (1) Loosen the knob screw on the outer surface of the reversing bar brackets on the left and right.
 - You can now move the reversing bar bracket freely.
- (2) While holding the knob screw, move the reversing bar bracket toward you.
 - Move the bracket until it reaches the stopper.



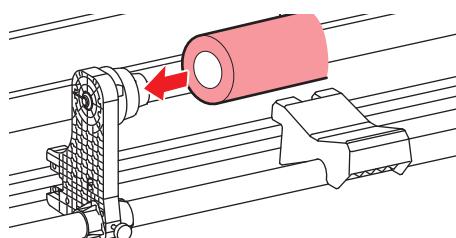
- (3) Insert and lower reversing bars.
 - Fit the reversing bars into the bottom notch of the hole.
 - Make sure the reversing bars are mounted in the correct positions. Mounting bars in the wrong position will prevent you from securing them.

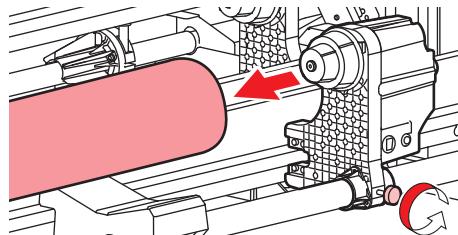


- (4) Move the reversing bar bracket toward the machine and secure it.
 - Do this for the reversing bar brackets on the left and right.

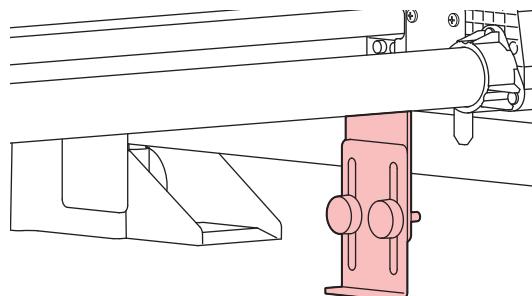
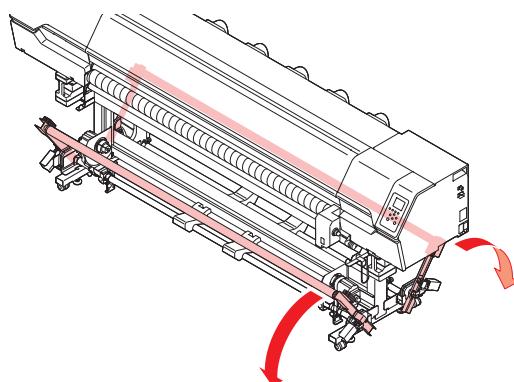
3 Push the core of the roll media onto the left roll holder.

- Push the roll media fully onto the roll holder until it is held securely.

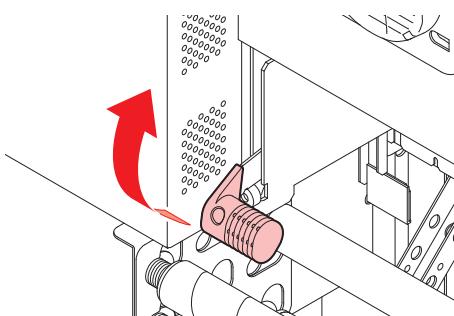


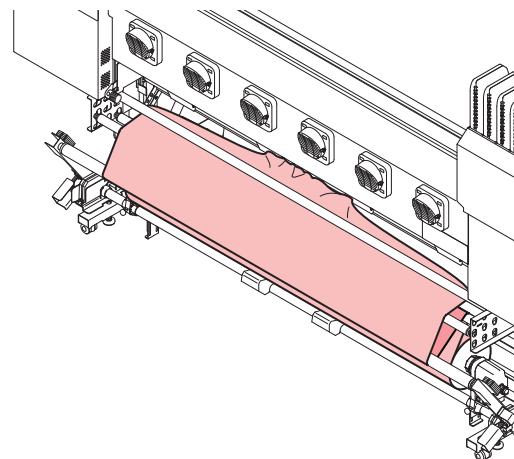
4 Loosen the screw on the right of the feeding unit and insert this side into the paper core.**5** Adjust the feeding legs to stabilize them on the floor.

- Be sure to stabilize the feeding legs on the floor to prevent feeding unit shafts from warping under the weight of loaded media.

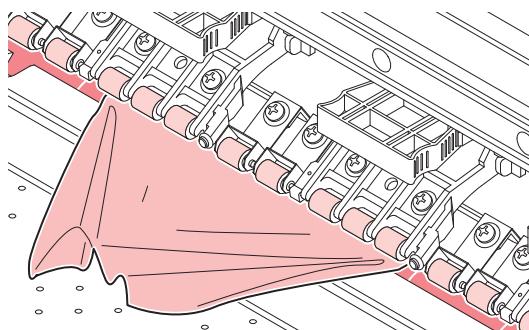
**6** Lower the feeding and take-up tension bars.**7** Raise the clamp lever on the rear of the machine.

- Leaving the clamp lever lowered will keep the feeding unit locked and prevent you from pulling out media in step 11 and later.



8 Insert the roll media into the machine.

- (1) Pull out enough media to reach the edge of the platen.
- (2) Pass the media over the feeding tension bar and reversing bars to ensure suitable tension.
- (3) Insert the media between the platen and the pinch rollers.
 - Feed enough media from the roll to be able to hold it from the front of the machine.



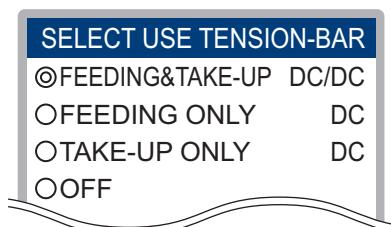
- (4) Lower the clamp lever on the rear of the machine.
 - The media is now held in place.

9 Close the front cover and make sure the clamp lever is lowered.

- A screen is displayed for selecting use of tension bars.

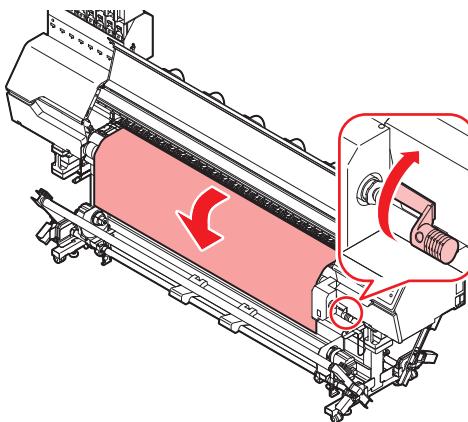
10 Select how tension bars will be used, which is based on how the media is loaded.

- In this case, select the option for both feeding and take-up.
(DL: direct-connection unit, TL: torque limiter, --: unit off)
- Press **▲▼** to select feeding and take-up, then press the [ENTER] key.



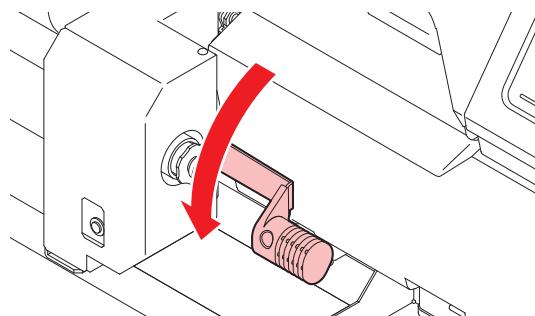
11 Open the front cover and pull out the edge of the roll.

- (1) Open the front cover.
- (2) Raise the clamp lever on the front of the machine.
 - Before raising the clamp lever, hold the media in place to prevent it from slipping back toward the feeding side.
- (3) Gently pull out the edge of the roll.
 - Pull out the media diagonally upward. Pulling the media out horizontally may catch it on the grit rollers and scratch the media.
 - Pull the media out far enough to cover the tension roller.



12 Smooth out any wrinkles in the media, then lower the clamp lever.

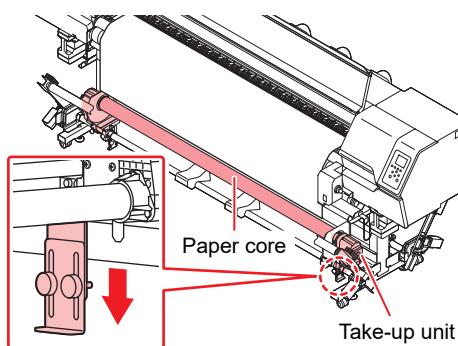
- Lightly pull the media in a few areas to remove wrinkles, and make sure the edges are generally straight before lowering the clamp lever.



13 Close the front cover.

14 Load the empty paper core in the take-up unit and adjust the take-up legs to stabilize them on the floor.

- After mounting the paper core, set up the take-up legs on the floor.



15 Make sure the media is loaded correctly on the feeding side, then press the Enter key.

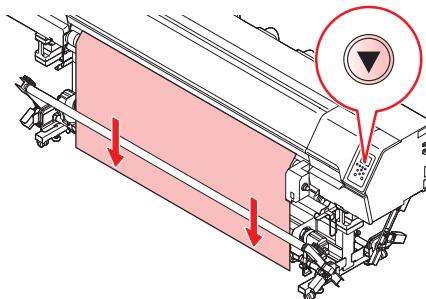
- The feeding tension bar is activated to detect and adjust media tension on the feeding side.
- If the media is not detected, raise the clamp lever and repeat this process from step 9.



- Load media so it is not loose.
If the media is loose, a feeding tension bar error may occur.
- Confirm that the rotation direction switch is set to the correct direction.
Media printed on the inner surface: Up (reverse)
Media printed on the outer surface: Down (forward)

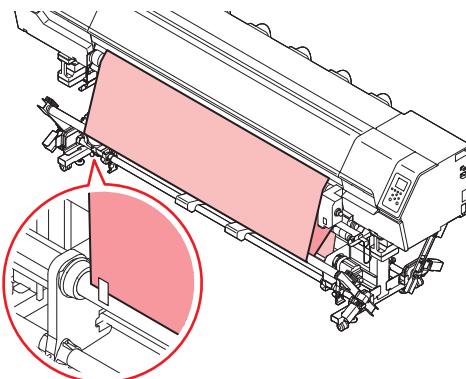
16 Secure the media on the take-up unit.

- (1) Press to feed enough media to reach the floor.



- (2) Route the media past the take-up tension bar and then from behind the reversing bar.
- (3) Secure the middle of the media with adhesive tape.
- (4) Secure the left and right sides the same way.

- Pull the left and right sides of the media evenly, making sure the media is not too loose or wrinkled, then secure it with tape.

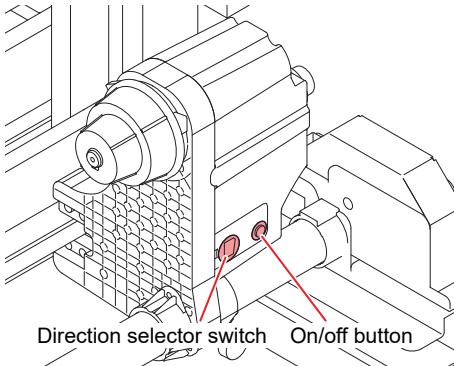


- (5) Lower the clamp lever on the rear of the machine.
- The media is now held in place.



- Secure wide media in at least five positions with tape or the like. The more positions secured, the more even the media tension will be.
- If the paper core is misaligned with the cloth as loaded, loosen the roll holder screw and adjust to bring the core into position.
- From a low line of sight with the feeding roll visible, make sure both media edges are aligned with both edges of the feeding roll.

17 Press the take-up unit switch to take up the media a little, about one revolution, onto the paper core.



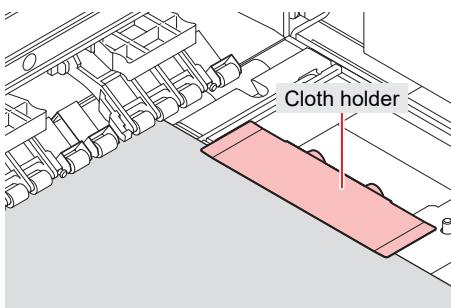
- (1) Take up the media by setting the take-up direction selector switch at left and then pressing the on/off button at right to activate it.
- (2) Once the media is taut, stop take-up by pressing the on/off button at right off.
 - The take-up unit should revolve at least once as you take up media.
 - If not, press again to feed the media and take it up with the take-up unit.



- If there is not enough media to wrap around the paper core, be sure to press to feed the media before taking it up with the take-up unit.
- Forcing take-up without enough media may damage the machine.

18 Open the front cover and lightly insert the media under the cloth holders.

- Position the media so that it does not extend to the right of the v-groove on the platen.
- For thick media, perform the procedure in "Adjusting the cloth holders"(P. 79).

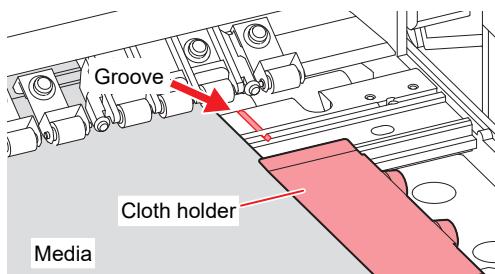


Be sure to use cloth holders. Using cloth holders has the following effects:

- Prevents curled, warped, or frayed edges of the cloth from lifting up.
- Prevents bleed-through ink mist during printing.



- When loading media, align the right edge with the groove on the platen. Placing media farther right than the groove will make it rise up if it moves obliquely, which may damage the head.
- A notification reading "Media Set Position R" will appear after media width detection if the media is too far to the right of the specified position. Reload media in the specified position.



19 Close the front cover and press [ENTER].

- The take-up tension bar is activated to detect and adjust media tension on the take-up side.
- After media detection on the take-up side, the media take-up diameter is detected. >
- If the media is not detected, repeat this process from step 2.

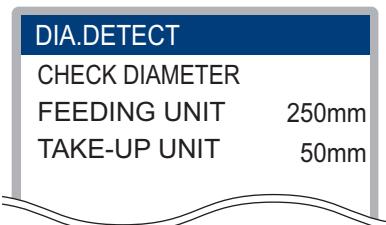


- Load media so it is not loose.
If the media is loose, a take-up tension bar error may occur.
- Confirm that the rotation direction switch is set to the correct direction.
Media printed on the inner surface: Up (reverse)
Media printed on the outer surface: Down (forward)

20 Set the take-up diameter.

- When the take-up diameter detection in the options is set to "AUTO" (☞ P. 116), the media take-up diameter is automatically detected after the media is loaded.

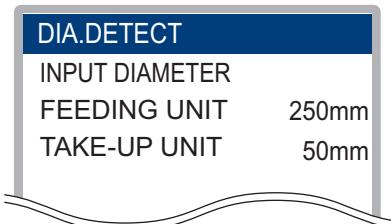
(1) After the take-up diameter is automatically detected, a screen appears to confirm the detected



take-up diameter.

(2) Check the actual take-up diameter, and if there is no problem, press the [FUNC3] key (OK).

- If there is a difference between the displayed and the actual take-up diameters, press the [FUNC1] key (No Good) and correct the take-up diameter.



(1) Enter the take-up diameter of the feeding unit.

- Press Δ ∇ to select the feeding unit, then press the [ENTER] key.
- Press Δ ∇ to enter the media outer diameter (diameter) of the feeding unit, then press [ENTER] key.

(2) Enter the take-up diameter of the take-up unit.

- Press Δ ∇ to select the take-up unit, then press the [ENTER] key.
- Press Δ ∇ to enter the media outer diameter (diameter) of the take-up unit, then press [ENTER] key.

(3) Press the [FUNC3] key (OK) when you have made the correction.

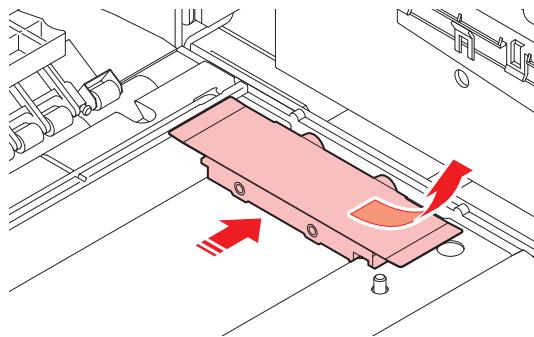
- When the take-up diameter detection in the options is set to "MANUAL" (☞ P. 116), enter the take-up diameter using the procedure above.

Adjusting the cloth holders

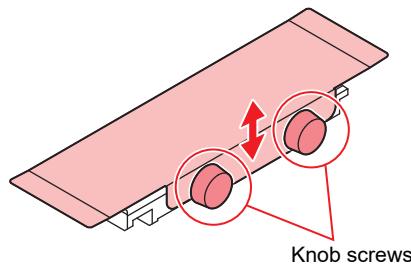
Adjust the height of the stainless steel plates to suit the cloth thickness.

1 Remove the cloth holders.

- Slide the cloth holders to the edge of the platen and remove them.



2 Loosen the knob screws and adjust the plate height to suit the cloth thickness.



- The head height should also be adjusted to suit the cloth thickness when thick cloth is held by the cloth holders. Leaving the head low may damage it.

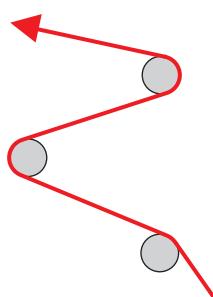
2

Adjusting the reversing bars

To print with suitable tension for the media, adjust the positions and quantity of reversing bars.

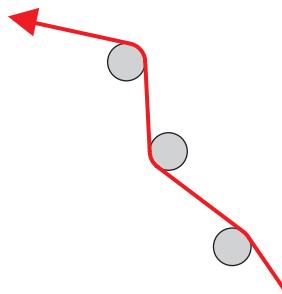
● Adjustment if media is too loose

Make the wrap angle larger. This will increase media tension.



● Adjustment if media is too taut

Make the wrap angle smaller. This will decrease media tension.



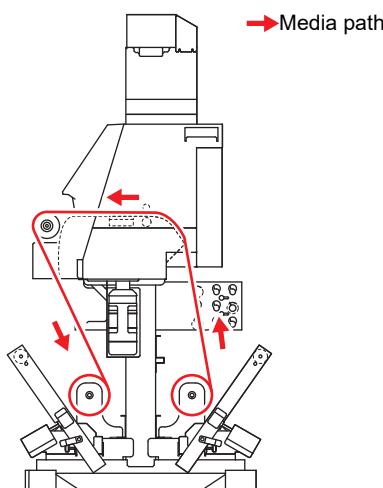
Loading roll media without using tension bars

Follow these instructions to load media without using tension bars. When setting media, read the following notes carefully.



- When loading media without using tension bars, replace the direct-connection unit on the feeding/take-up unit with an included torque limiter.  "Replacing the direct-connection unit/torque limiter"(P. 62)
- Continuous printing without tension bars is limited to about 10 m. For continuous printing longer than 10 m, use tension bars to load the media.

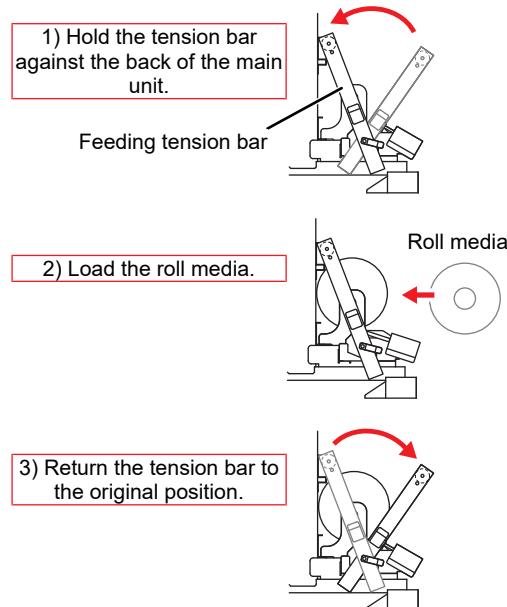
The media path when loading cloth media without tension bars is shown in the following figure. Understanding the media path before loading will make loading easier.



- Before loading cloth media, make sure the area around the grit roller is clean. Clean this area if it is dirty.
- When loading roll media without using tension bars, adjust media tension with reversing bars and torque limiters.

1 Load the media on the feeding side.

- Follow steps 4–8 in  "Using the tension bars"(P. 71).
- The feeding tension bar must be moved temporarily.



2 Close the front cover and make sure the clamp lever is lowered.

- A screen is displayed for selecting use of tension bars.

3 Select how tension bars will be used, which is based on how the media is loaded.

- In this case, select OFF.
(DL: direct-connection unit, TL: torque limiter, --: unit off)
- Press   to select OFF, then press the [ENTER] key.



- The screen for selecting use of tension bars is not displayed if both the feeding and take-up tension bar settings are set to OFF in the options for roll unit selection. (The media selection screen is displayed.)

4 Feed the media to the take-up side and load an empty paper core in the take-up unit.

- Follow steps 10–15 in  "Using the tension bars"(P. 71).

5 Secure the media on the paper core, and then set the cloth holders.

- Follow steps 17–19 in  "Using the tension bars"(P. 71).

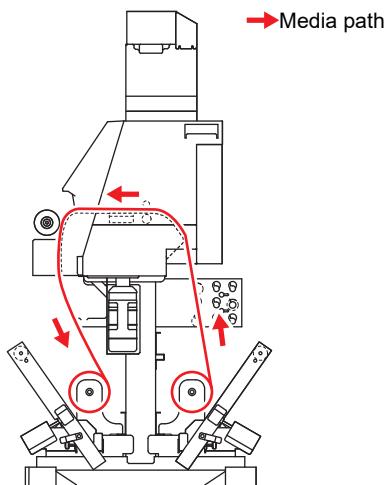
Loading Roll Media (Transfer Paper)

Loading paper media does not require use of tension bars. When setting media, read the following notes carefully.



- Replace the direct-connection unit on the feeding/take-up unit with an included torque limiter.
☞ "Replacing the direct-connection unit/torque limiter"(P. 62)
- Continuous printing without tension bars is limited to about 10 m. For continuous printing longer than 10 m, use tension bars to load the media.

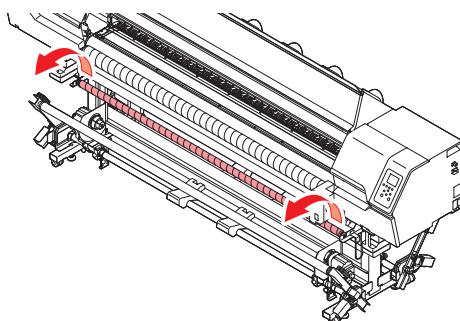
The media path when loading paper media (transfer paper) is shown in the following figure. Understanding the media path before loading will make loading easier.



- Pass the media between the tension roller and the main unit.
- Set reversing bars in holes where they will not interfere with the media.

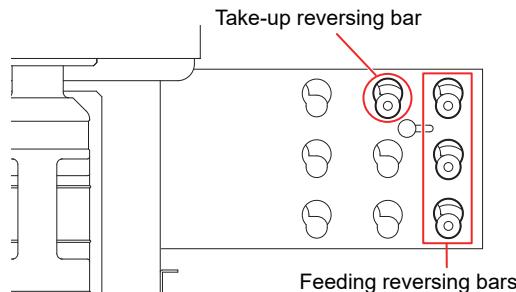
1 Remove take-up reversing bars.

- Remove take-up reversing bars to avoid interfering with the media.



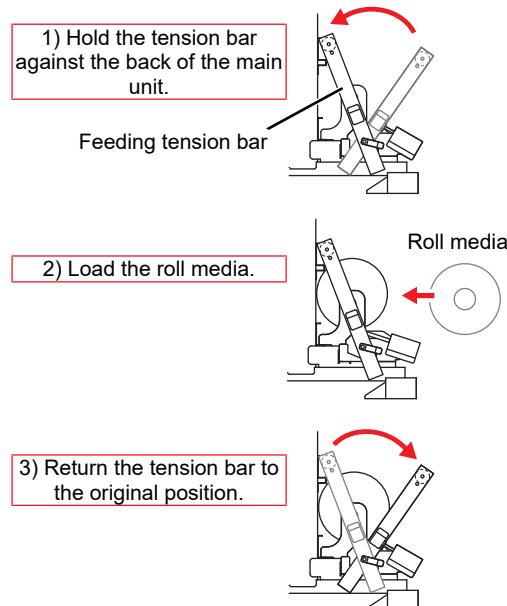
2 Mount take-up reversing bars in the reversing bar bracket on the feeding side.

- Mount the take-up reversing bars you removed in the reversing bar bracket on the feeding side in the rear.
- Mount the take-up and feeding reversing bars in the following positions.



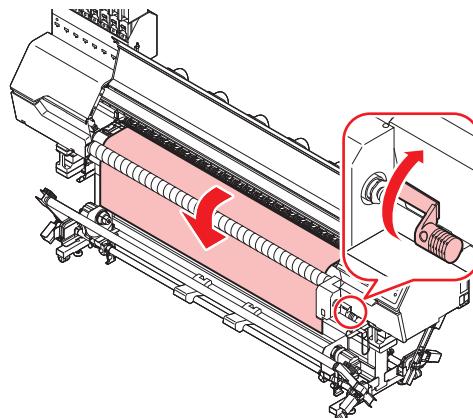
3 Load the media on the feeding side.

- The feeding tension bar must be moved.



4 Pull out the edge of the roll.

- (1) Open the front cover.
- (2) Raise the clamp lever on the front of the machine.
- (3) Gently pull out the edge of the roll.

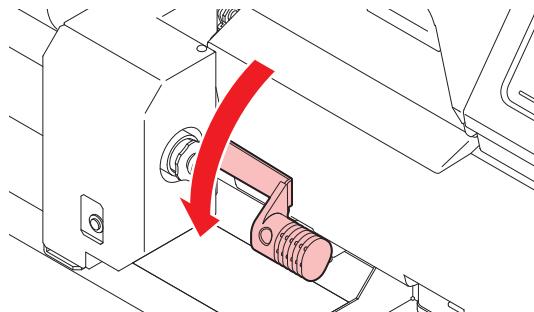




- Pass the media between the tension roller and the main unit.

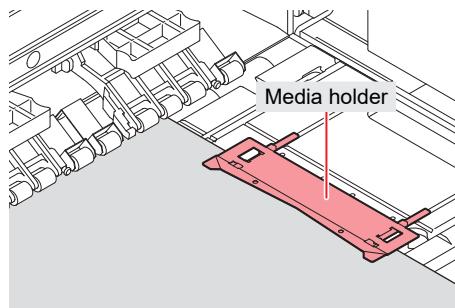
5 Ensure that the roll media is uniformly loaded, then lower the clamp lever.

- Lightly pull the media in a few areas and make sure that it has been pulled out uniformly, then lower the clamp lever.

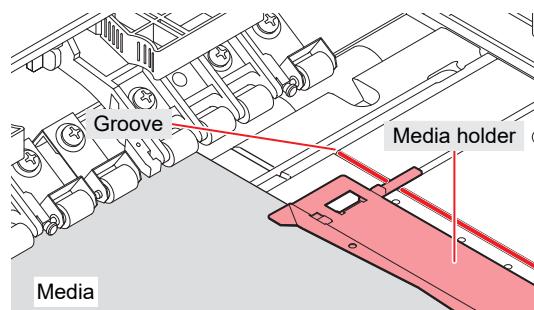


6 Use the media holders to hold the media in place lightly.

- Position the media so that it does not protrude on the right end beyond the rightmost pinch roller.
- When using thick media, remove the media holders from the media before printing.



- When loading media, align the right edge with the groove on the platen. Placing media farther right than the groove will make it rise up if it moves obliquely, which may damage the head.
- A notification reading "Media Set Position R" will appear after media width detection if the media is too far to the right of the specified position. Reload media in the specified position.



7 Close the front cover and make sure the clamp lever is lowered.

- A screen is displayed for selecting use of tension bars.

8 Select how tension bars will be used, which is based on how the media is loaded.

- In this case, select OFF.
(DL: direct-connection unit, TL: torque limiter, --: unit off)
- Press to select OFF, then press the [ENTER] key.



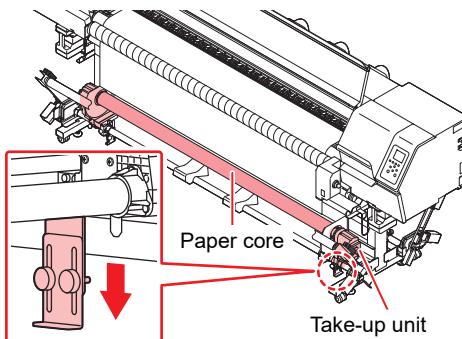
- The screen for selecting use of tension bars is not displayed if both the feeding and take-up tension bar settings are set to OFF in the options for roll unit selection. (The media selection screen is displayed.)

9 Set the take-up diameter.

- Follow step 20 in "Using the tension bars"(P. 71).

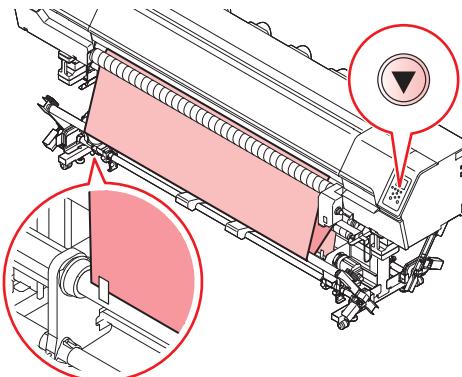
10 Load an empty paper core on the take-up unit.

- After mounting the paper core, set up the take-up legs on the floor.



11 Secure the media on the take-up unit.

- (1) Press the [FUNC3] key.
- (2) Press to feed enough media to reach the paper core in the take-up unit.
- (3) Secure the middle of the media with adhesive tape.
- (4) Secure the left and right sides the same way.
 - Pull the left and right sides of the media evenly, making sure the media is not too loose or wrinkled, then secure it with tape.



Loading Leaf Media (Cloth Media)

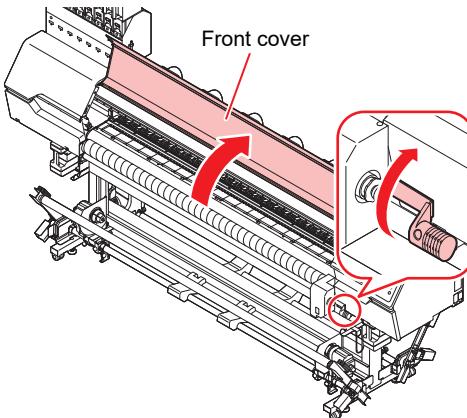
Unlike roll media, leaf media does not need to be retained with the roll holders.



- Remove the platens for paper media and install the ink-receiving pan spacers, checking that the machine is set for cloth media.

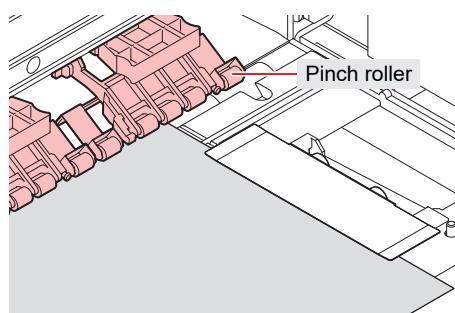
1 Set both the feeding and the take-up units to OFF in the options for roll unit selection.

2 Open the front cover and raise the clamp lever.



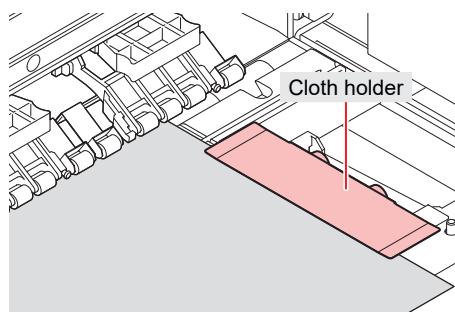
3 Insert leaf media between the pinch rollers and platen, then lower the clamp lever.

- Set the media so that no media sticks out from the right end pinch roller to the right side.



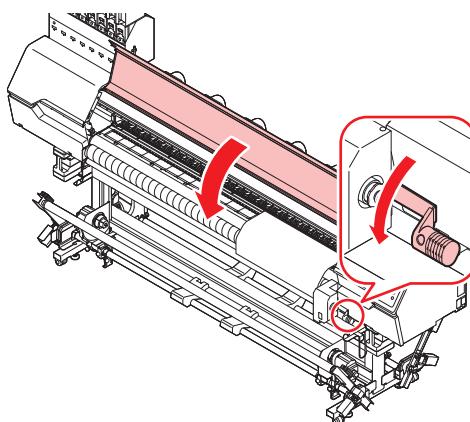
4 Use the cloth holders to hold the media in place lightly.

- Position the media so that it does not extend to the right of the v-groove on the platen.
- When using thick media, remove the cloth holders from the media before printing.



5 Close the front cover.

- Set the media straight.



- Only use leaf media that has some stiffness.
Because the take-up unit is not used with leaf media, the printing surface of flimsy media may not be flat, which may cause it to jam.
- Load media that is long enough to cover the tension roller. Media shorter than this may become caught between the tension roller and cloth-wound roller and get jammed.

Loading Leaf Media (Transfer Paper)

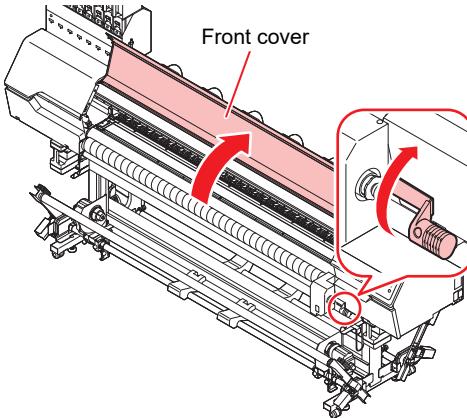
Unlike roll media, leaf media does not need to be retained with the roll holders.



- Check that the platens for paper media are installed and that the machine is set for paper media.

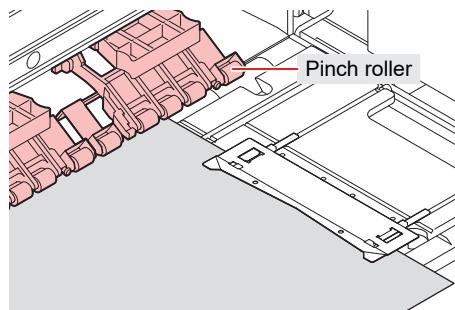
1 Set both the feeding and the take-up units to OFF in the options for roll unit selection.

2 Open the front cover and raise the clamp lever.



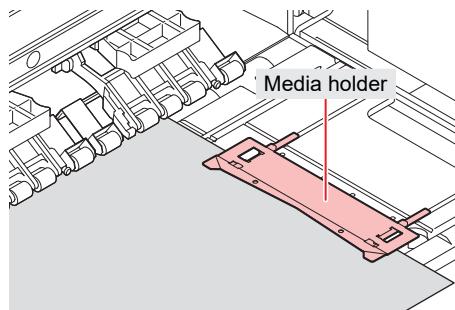
3 Insert leaf media between the pinch rollers and platen, then lower the clamp lever.

- Set the media so that no media sticks out from the right end pinch roller to the right side.



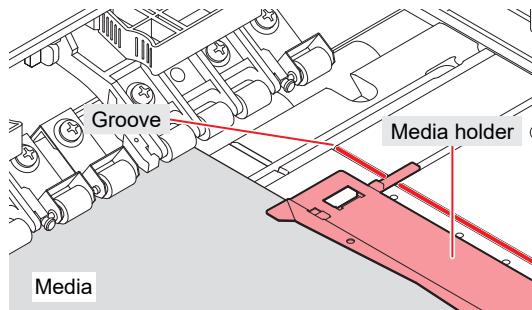
4 Use the media holders to hold the media in place lightly.

- Position the media so that it does not extend to the right of the v-groove on the platen.



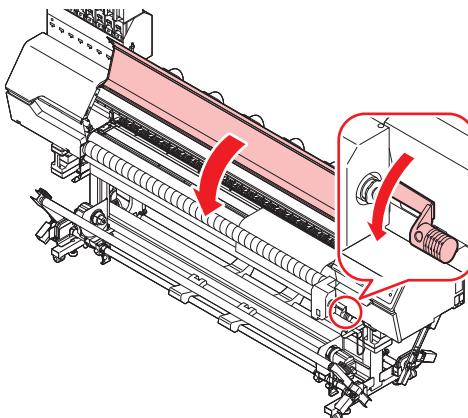


- When loading media, align the right edge with the groove on the platen. Placing media farther right than the groove will make it rise up if it moves obliquely, which may damage the head.
- A notification reading "Media Set Position R" will appear after media width detection if the media is too far to the right of the specified position. Reload media in the specified position.

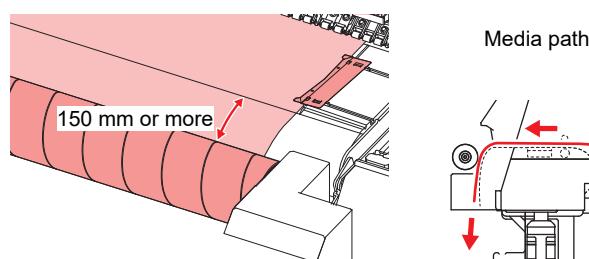


5 Close the front cover.

- Set the media straight.



- When loading media, have at least 150 mm over the platen and pass it between the tension roller and main unit. If media is not routed correctly, it may lift up and damage the head.



- Only use leaf media that has some stiffness. Because the take-up unit is not used with leaf media, the printing surface of flimsy media may not be flat, which may cause it to jam.

Registering the Media

When the clamp lever is lowered with media being loaded, the Select Use Media screen is displayed. Registration is required to use media that is not registered on the machine.

1 Select [Unregistered].

Media selection	1/2
● PVC	1300 mm
○ Tarpaulin	1600 mm
○ Unregistered	
○ Unregistered	
○ Unregistered	

2 Select the media type.

Media Type
● Decalcomania paper (thin)
○ Decalcomania paper (mid)
○ Decalcomania paper (thick)
○ Cloth/fabric
○ Synthetic paper

3 Select the media width detection type.

- AUTO: The media width is automatically detected with the sensor.
- MANUAL: The media width is manually set.

Media Detection Type
Please Select.
AUTO
MANUAL



- Media width may not be detected correctly for certain colors or types of media. When media width cannot be detected correctly, set the media width detection method to "MANUAL".

4 Select the method for managing the media remaining amount.

- Select whether or not to manage the media remaining amount with the machine.

Media Registration
Media Remain Manage
Please Select.
ON
OFF

5 Enter the name to be displayed.

- If you do not register the name, press the [ENTER] key.

Media Name Change
Media 3
will be changed
(maximum 10 characters)

6 Select whether or not to register the set information.

do you optimize setting?	Execute
	Do not



- You can change the settings later.  ["Media Setting Menu"\(P. 108\)](#)

● Media optimization settings

Optimizing the settings sets the various items as follows, depending on media type:

Settings	Default	Transfer paper	Cloth
MAPS	Auto	Auto	Auto
Vacuum fan strength	Strong	Strong	Strong ^{*1}
Vacuum fan constant operation	On	On	On ^{*1}
Feed speed (%)	Host	100	100
Pre Feed	Host	Off	Off

*1. When the removable platens are not fitted (cloth media), the vacuum fan will remain off regardless of the setting.

Reset the Media

If you change the setting of the print area without raising the clamp lever or re-perform the media detection, please perform the following operation.

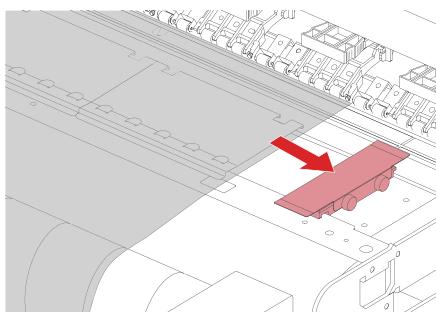
- 1** Press the [SEL] key in the local mode, and then press [FUNC2 (MEDIA)].
- 2** Press the **▲** or **▼** key to select the method of resetting the media, and then press [ENTER].
 - Media resetting can be selected from two methods.
(1) Width only: Sets only PRINT AREA [WIDTH].
(2) All: Resets all media sensor information.
- 3** Press the [ENTER] key.

Replacing Cloth Media After Printing

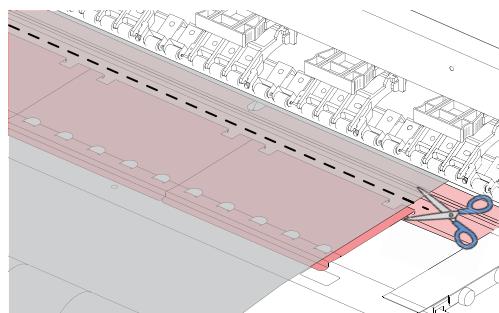
When cutting the cloth media after printing, the cloth media comes into contact with the ink-receiving pan spacers and gets dirty.

This section describes how to help prevent cloth media from getting dirty during cutting.

- 1** Remove the cloth holders from the media. (Left/right)

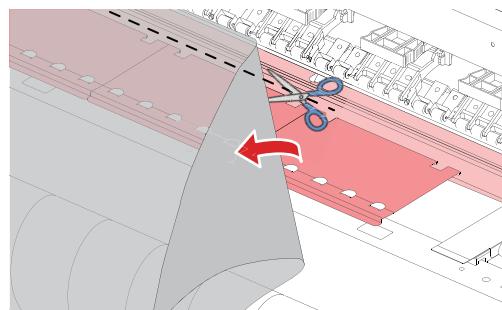


- 2** While lifting the cloth media, cut the back side (between the ink-receiving pan spacer and the R platen).



3 Cut all of the cloth media as you place it on the peeling roller.

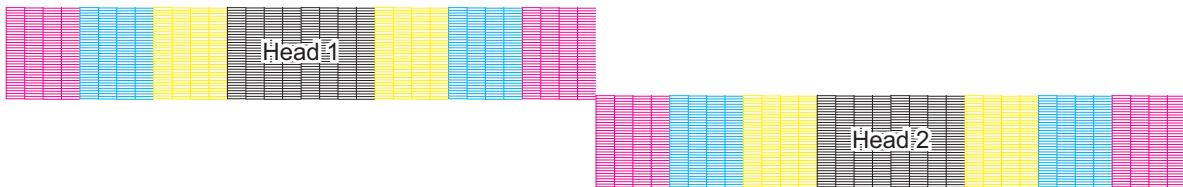
- Lift up the cloth media as you cut it so that the cut cloth media does not touch the ink-receiving pan spacer.

**4** Clean the ink-receiving pan spacers.  "Ink-Receiving Pan Spacer Cleaning"(P. 130)**5** Load new media.

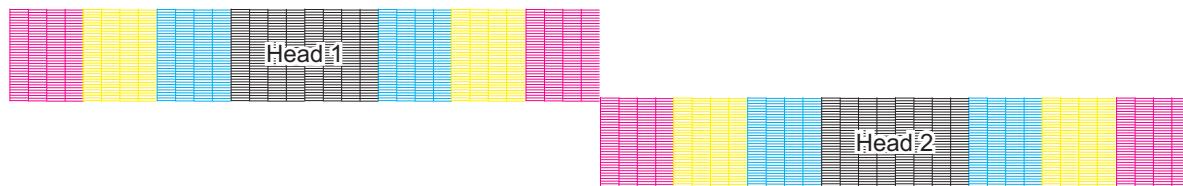
2.8 Test Printing

Print a test pattern to confirm that the ink prints correctly. Perform head cleaning if you observe any ejection failures (e.g., nozzle clogging or deflection).  ["Head Cleaning"\(P. 96\)](#)

[For Sb411 ink]



[For Sb420 ink]



Check beforehand

- Was the print head adjusted?  ["Adjusting Print Head Height"\(P. 56\)](#)
- Is media loaded?  ["Loading the Media"\(P. 61\)](#)



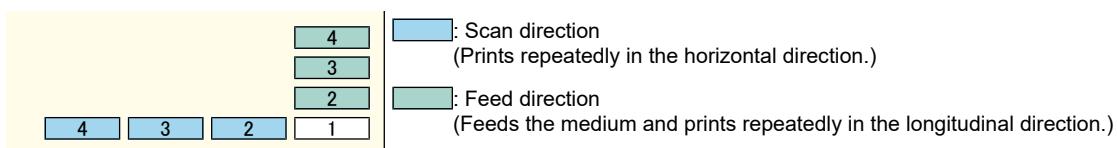
- Load media at least 500 mm wide. You cannot print the entire pattern if media less than 500 mm wide is used.



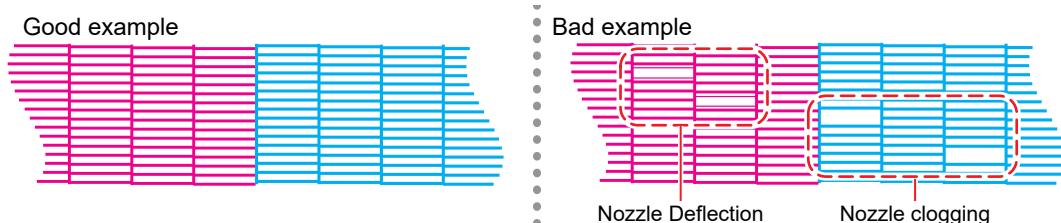
- Select [Maintenance] > [Nozzle Recovery] > [Test Print], then select "ON" to perform nozzle recovery and test printing.
Registration is required to perform nozzle recovery.  ["Registering Nozzle Recovery"\(P. 114\)](#)

Changing the Layout Direction for Test Printing

You can change the layout direction for test printing.



- 1 On the LOCAL mode screen, select [TEST PRINT/CLEANING] > [Test Print], then press the [ENTER] key.
 - The Test Print menu is displayed.
- 2 Select [Scan Dir.] or [Feed Dir.], then press the [ENTER] key.
 - Test printing starts.

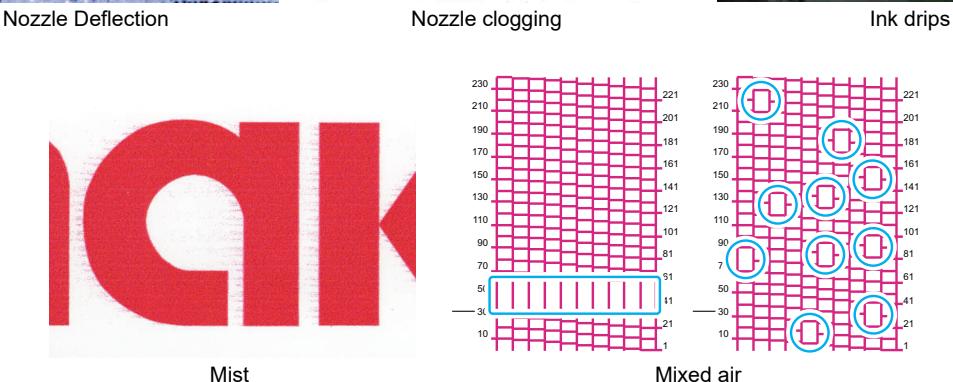
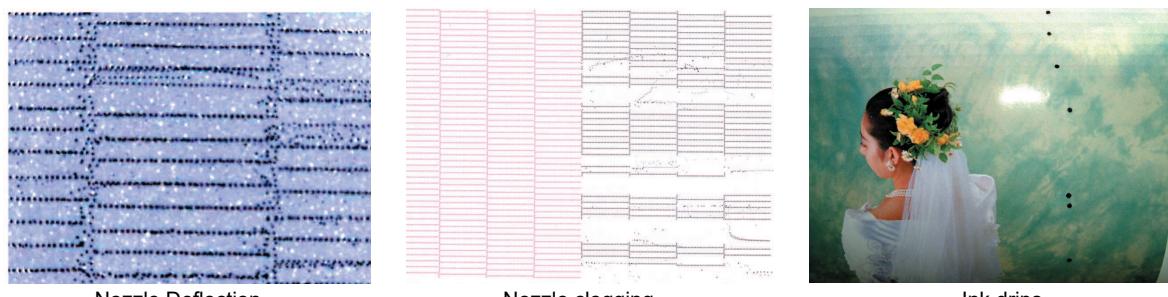


- 3 Check the print results.

Ejection Failures

2

Typical examples of ejection failures (e.g., nozzle clogging, deflection) are as shown below. In order to prevent printing in such a state, check whether the ink has been properly ejected regularly before printing.



2.9 Head Cleaning

The following head cleaning methods are available. Choose the method based on test results. Cleaning is not possible when the [Ink Near End] or [Ink End] errors are displayed. Replace with new ink.  ["Replacing Ink"\(P. 42\)](#)

Item	Details
Soft	If the print shows a bent line (Nozzle deflection)
Normal	If the print shows a missing line (nozzle clogging)
Hard	If soft cleaning and normal cleaning fail to resolve ejection failures (e.g., nozzle clogging or deflection).

- 1 On the LOCAL mode screen, select [TEST PRINT/CLEANING] > [Cleaning], then press the [ENTER] key.
 - The Cleaning menu is displayed.
- 2 Select the cleaning type, then press the [ENTER] key.
- 3 Select the head to be cleaned, then press the [ENTER] key.
 - Check the check box. Heads with checked check boxes will be cleaned.
- 4 Run another test print and check the print results.
 - Repeat the cleaning and test printing process until the print results appear normal.

 • Do the following if head cleaning fails to resolve the ejection failures (e.g., nozzle clogging or deflection).

 ["Cap Rubber Cleaning"\(P. 124\)](#)

 ["Print Head Nozzle Washing"\(P. 166\)](#)

 ["Wiper Cleaning"\(P. 126\)](#)

2.10 Feed Correction

Changing the media may affect the feed amount due to various factors, including the weight and thickness of the media and whether the take-up unit is used. Correct the drop position to suit the type of media used. Image defects (e.g., dark or light streaks) will result if the feed is not properly corrected.

Check beforehand

- Is media loaded?  "Loading the Media"(P. 61)
- For roll media, is the rear roll media free of sagging?
- When using the take-up unit, is the media mounted on the paper core of the take-up unit?  "Loading Rolls of Cloth Media"(P. 71)  "Loading Roll Media (Transfer Paper)"(P. 82)

Feed Correction Procedure

Print a correction pattern, then enter the correction value. The value corrected here will also be updated on the Media Setting menu.



- When using the take-up unit, load media on the take-up unit before correcting.
- Set the media aligning the center datum with the media setting position guide plate.  "Roll holder setting position"(P. 70)

Check and adjust around the center of the machine.

1 On the LOCAL mode screen, select [ADJUST].

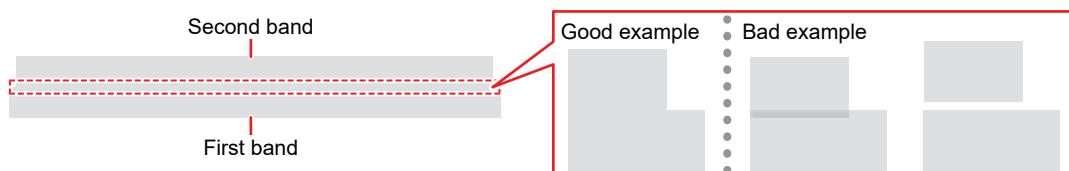


2 Select [Feed Comp.], then press the [ENTER] key.

- Correction pattern printing starts.

3 Check the print results.

- A correction value input screen appears.
- Adjust the bands so that the region between them is evenly colored.



4 Enter the correction value, then press the [ENTER] key.

- "+" input: Increases the separation between bands.
- "-" input: Reduces the separation between bands.
- Increment the correction value by "30" to move the bands by approximately 0.1 mm.

5 Press the [ENTER] key.

- Print another correction pattern to check.

Correcting the Media Feed During Printing

You can also correct the media feed amount in REMOTE mode or during printing.

1 Press [ADJUST] in REMOTE mode or during printing.

2 Enter the correction value, then press the [ENTER] key.

- Correction value: -9999 to 9999
- The value entered here will be updated immediately.

2.11 Correcting the Drop Position

Changing the media and print head height and temperature changes around the print head will also alter the drop positions. Correct the drop position to suit the type of media used. Image defects (e.g., overlaid lines or blurred images) will result if the drop position is not properly corrected.

Check beforehand

- Was the print head adjusted?  "Adjusting Print Head Height"(P. 56)
- Is media loaded?  "Loading the Media"(P. 61)



- Load media at least 500 mm wide. You cannot print the entire pattern if media less than 500 mm wide is used.

Drop Position Correction Procedure

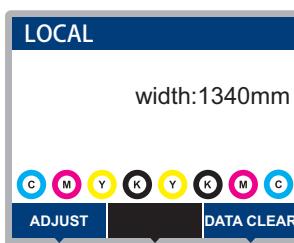
Print a correction pattern, then enter the correction value. The value corrected here will also be updated on the Media Setting menu. This must be adjusted for each print resolution.



- Set the media aligning the center datum with the media setting position guide plate.  "Roll holder setting position"(P. 70)

Check and adjust around the center of the machine.

1 On the LOCAL mode screen, select [ADJUST].



2 Select [Drop.PosCorrect], then press the [ENTER] key.

3 Select the resolution, then press the [ENTER] key.

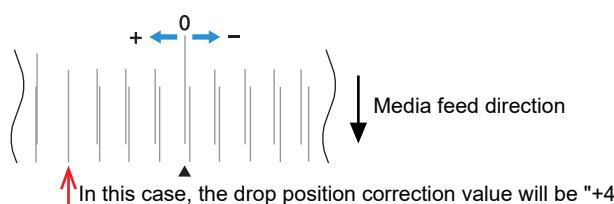
- Select the resolution to be adjusted. When "All" is selected, correction patterns for all resolutions will be printed.  "Media Setting Menu"(P. 108)



- The indicated resolutions are those in the scan direction.

4 Check the print results.

- A correction value input screen appears.
- Enter the position where the two upper and lower lines coincide.



5 Enter the correction value, then press the [ENTER] key.

- Correction value: -40 to 40



- If the lines do not coincide when the correction value is within the range -40 to 40, the print head height may have been improperly adjusted. Adjust the print head height.
 ["Adjusting Print Head Height"\(P. 56\)](#)

6 Enter the correction value in the same way for pattern 2 and subsequent patterns.

2.12 Preparing RIP data

The explanation here applies to MIMAKI RIP software (RasterLink).



- Prepare suitable image data for printing.

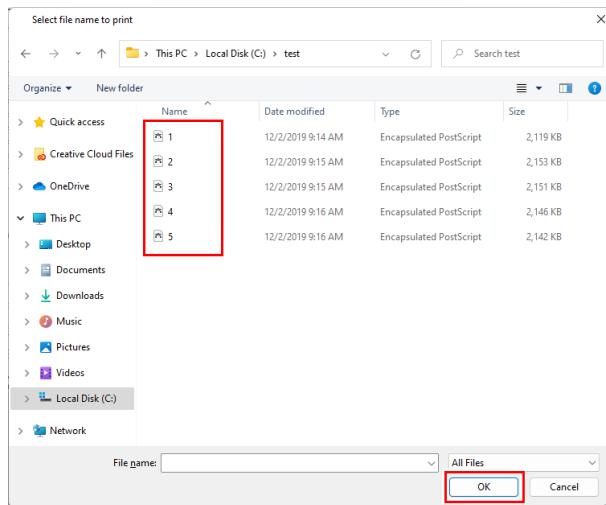
1 Launch RasterLink.

- Click the icon on the PC desktop.



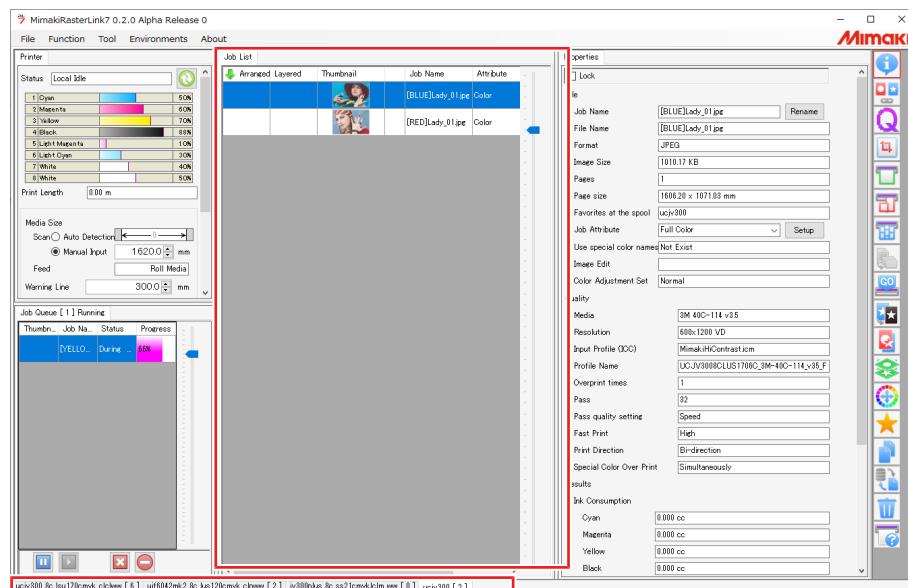
2 Select the image data to print.

- (1) Select [File] > [Open].
- (2) Select the desired image data, then click [Open].
 - If multiple printers are registered, select Tx330-1800 in "Printer Name".



3 Select the image data imported.

- The image data is added in the tab for Tx330-1800 selected in "Printer Name".



4 Edit the image.

- Specify the following settings by clicking the function icons shown on the right-hand side of the screen:
 -  (General Print): Specifies settings like enlargement/reduction and rotation.
 -  (Quality): Selects a color profile for the media and ink set loaded in this machine.



- For more information, refer to the RasterLink reference guide. <https://mimaki.com/download/software.html>

5 Print image data.

-  "Starting Printing"(P. 104)

- (1) Click  (Execution) from the function icons on the right-hand side of the screen.
- (2) Select "Immediate Print" or "RIP and Print", then click [Start].



- Media width must be reacquired after replacing media.

- (1) Select the tab for Tx330-1800 in the main window.
- (2) Click  (Update the printer status) in the Printer tab.

2.13 Printing

Check beforehand

- Was the print head adjusted? ["Adjusting Print Head Height"\(P. 56\)](#)
- Is media loaded? ["Loading the Media"\(P. 61\)](#)
- For roll media, is the rear roll media free of sagging?
- When using the take-up unit, was the media mounted on the paper core of the take-up unit? ["Loading Rolls of Cloth Media"\(P. 71\)](#) ["Loading Roll Media \(Transfer Paper\)"\(P. 82\)](#)

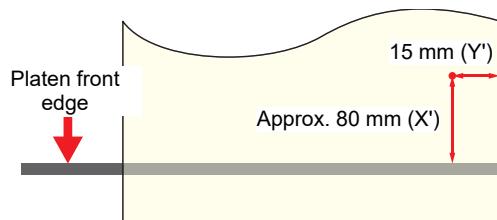


- Condensation may form on the print head nozzle surface depending on the ambient temperature and humidity. The formation of condensation may cause ejection failures (e.g., nozzle clogging or deflection). Perform head cleaning if any ejection failures (e.g., nozzle clogging or deflection) occur during printing. ["Head Cleaning"\(P. 96\)](#)

Changing the origin

The print start position can be altered. Use the LED pointer to set the origin.

- Print origin default value
 - Feed (longitudinal, X') direction: Approx. 80 mm to rear from platen front edge
 - Scan (lateral, Y') direction: 15 mm from right edge of media



1 On the LOCAL mode screen, press $\triangle\triangledown\blacktriangleleft\blacktriangleright$.

- The Origin Setup screen appears.

2 Press $\triangle\triangledown\blacktriangleleft\blacktriangleright$ to move the origin to the desired position.

- The carriage moves left and right and feeds the medium.

(Important!) • The media cannot be fed backward when using cloth media (with the platens not fitted).

3 Press the [ENTER] key.

- The origin is updated.

Starting Printing

1 Send the RIP data from the PC.

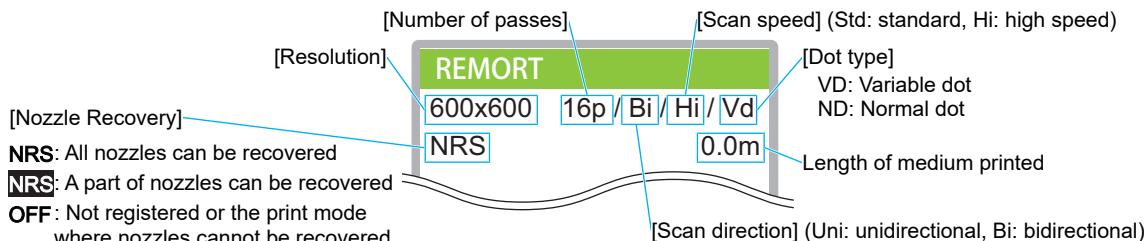
-  "Preparing RIP data"(P. 101)



- If the message "Attention20A Driver version" appears, install the latest Mimaki driver.
<https://mimaki.com/download/inkjet.html>

2 Start printing.

- Printing starts once RIP data is received.



- Print speeds may differ for the same image data, depending on the width of the medium loaded, print origin position, and resolution.
- If an error occurs, the machine switches to LOCAL mode once printing is completed. Further printing is not possible.

Pausing Printing

1 Press [LOCAL] while printing is in progress.

- Printing is paused.
- If data is being sent from a PC, data transmission is paused at the PC.

2 Press [REMOTE].

- Printing resumes.



- No other functions can be used when printing is paused.

Stopping Printing (Data Clear)

1 On the LOCAL mode screen, select [DATA CLEAR].



2 Press the [ENTER] key to clear the received data.

- The receive buffer is cleared.

Chapter 3 Setup



This chapter

This chapter describes the [MENU] functions.

Media Setting Menu	108	Function Setting Menu	116
Maintenance Menu	111	Environment Setting Menu	118
Registering Nozzle Recovery.....	114	Machine Status Menu.....	120
Nozzle Check.....	115		

3.1 Media Setting Menu

When you use the machine for the first time, the Select Use Media screen is displayed.  ["Registering the Media"\(P. 90\)](#) The media Information and correction value can be saved in advance for specific media.

The user can select to prioritize the settings on the machine or the settings on the PC. Setting individual menus to "Host" prioritizes PC settings. To prioritize settings for this machine, select a setting other than "Host".



- For more information on how to specify RIP software, refer to the RIP software operating manual.

● Menu List

Item	Setting		Details
	*1	*2	
Feed Comp.	-9999 to <u>0</u> to 9999	-	Corrects the media feed amount. Print a pattern and enter the correction amount.  "Feed Correction"(P. 97)
Drop.PosCorrect	-	-	Corrects the drop position for bi-directional printing.  "Correcting the Drop Position"(P. 99)
(Resolution)	*	-	Select the resolution to be corrected. When "All" is selected, correction patterns will be printed for all resolutions. * The available resolutions vary according to the model.
	(Correction Value)	-40.0 to <u>0</u> to 40.0	Check the pattern and enter correction values.
Auto-correction	-	-	The auto-correction function (DAS: Dot Adjustment System) detects a correction pattern with the sensor and automatically corrects the drop position.
All	-	-	When "All" is selected, "Feed Comp." and "Drop.PosCorrect" are corrected.
	Feed Comp.	-	<ul style="list-style-type: none"> Check to confirm that the media does not lift up. Load white and clean media. Media such as synthetic paper, tarpaulin, or cloth media may not be detected. Do not send RIP data from the PC during pattern printing. If automatic correction is unsuccessful, correct the position manually. [MENU] > [Media Setting] > [Feed Comp.] or [Drop.PosCorrect]
	Drop.PosCorrect	-	<ul style="list-style-type: none"> Check to confirm that the media does not lift up. Load white and clean media. Media such as synthetic paper, tarpaulin, or cloth media may not be detected. Do not send RIP data from the PC during pattern printing. If automatic correction is unsuccessful, correct the position manually. [MENU] > [Media Setting] > [Feed Comp.] or [Drop.PosCorrect]
(Resolution)	*	-	Select the resolution to be corrected. When "All" is selected, correction patterns will be printed for all resolutions, and the drop position is corrected automatically. * The available resolutions vary according to the model.
	External Heater	ON/ <u>OFF</u>	Turns the external heater on or off.
MAPS4*	-	-	MAPS: Mimaki Advanced Pass System This function disperses the boundaries between passes to make feed streaks between passes less visible. Altering MAPS may alter the color. This function may be less effective with certain types of images. * The MAPS version will vary according to the model.

Item	Setting		Details
	*1	*2	
MAPS*	<u>AUTO</u> / MANUAL	-	This should normally be set to "AUTO". When set to "MANUAL", the following items are displayed:
	Speed	50 to 100 %	Reducing speed will make streaks less visible. However, printing will be slower.
	Smoothing Level (Color)	0 to 100 %	Increasing smoothing makes streaks less visible. Make separate settings for color and spot color (white).
Media Information	-	-	Enter the media information.
Media Type	-	-	Select the media type to be used. The available media types vary depending on the model.
Media Width	-	-	Sets the media width detection method.
Detection Type	<u>AUTO</u> / MANUAL		<ul style="list-style-type: none"> AUTO: The media width is automatically detected with the sensor. MANUAL:  Press  to set the media width manually. – When media width cannot be detected correctly, set the media width detection method to "MANUAL".
Media Remain	-	-	The remaining roll media amount can be displayed and printed out in REMOTE mode. The print length will be displayed when leaf media is in use.
Media Remain Manage	<u>ON</u> / <u>OFF</u>	-	<ul style="list-style-type: none"> ON: An input screen appears once the media width is detected.  Press  to set the media length. Press the [FUNC3] key on the "Origin Setup" screen to print the date and remaining media amount. OFF: The remaining media amount is not displayed.
Length			Enter the roll media length.
Stop Printing	<u>ON</u> / <u>OFF</u>		Setting to "ON" stops printing when the Media Remain value reaches 0.
Detail Setting	-	-	This is used to set various functions.
Vacuum Fan	<u>Strong</u> / <u>Weak</u> / <u>Standard</u> / <u>Host</u>	Strong	Sets the force with which the medium is held down. <ul style="list-style-type: none"> This can be used to prevent media jamming and print head damage caused by the media lifting up.
Continuous Running	<u>ON</u> / <u>OFF</u>		<ul style="list-style-type: none"> ON: The media is constantly held down under vacuum. OFF: The media is held down by vacuum only when required, such as during printing and feeding.
Feed Speed	<u>Host</u> /10 to 100 to 200 %	100	Sets the media feed speed. <ul style="list-style-type: none"> Depending on print conditions, the speed may not vary for certain settings. Setting to 100 % or more reduces the time required to complete printing but may affect print quality due to insufficient drying time.
Pre Feed	-	-	Sets the conditions for media feeding before printing.
Drying Feed	<u>OFF</u> /100 to 1000 mm	OFF	Sets the distance for media feeding after printing.
Media Name Change	-	-	You can change the name of a setting type. The name can include alphanumeric characters or symbols.

Item	Setting		Details
	*1	*2	
Delete MediaInfo	-	-	Delete the set media information.

*1. The default settings are shown underlined.

*2. Settings applied if no settings can be made in the RIP software (host) or if this machine is prioritized.

3.2 Maintenance Menu

This menu is used for maintenance actions. It also lets the user perform nozzle recovery if nozzle clogging persists even after cleaning and nozzle washing.

● Menu List

Item	Setting *1	Details
Station Maint.	-	This moves the carriage to allow station and print head maintenance.
Carriage Out	-	
Move To Platen Right End	-	Cleans around the station, including caps and wipers, and changes the head height. ☞ "Cap Rubber Cleaning"(P. 124) ☞ "Wiper Cleaning"(P. 126) ☞ "Adjusting Print Head Height"(P. 56)
Move To Maint. Space	-	Cleans around the print head. ☞ "Carriage Underside Cleaning"(P. 125) ☞ "Media Sensor Cleaning"(P. 132) ☞ "DAS (Automatic Correction Function) Sensor Cleaning"(P. 129)
Nozzle Wash	1 to 99 min	Washes the print head nozzle surface with maintenance liquid to resolve ejection failures (e.g., nozzle clogging or deflection). ☞ "Print Head Nozzle Washing"(P. 166)
Pump Tube Cleaning	-	Washes the suction pump tube (below the cap). ☞ "Ink Discharge Channel Cleaning"(P. 131)
Custody Wash	1 to 99 min	Perform this step if the machine will not be used for extended periods. The function washes nozzles and drainage channels to maintain the machine in optimal condition. ☞ "When this Printer is Left Unused for a Long Time"(P. 139)
Replace Wiper	-	Use this function when replacing the wiper. Replacing the wiper resets the wiper usage counter. ☞ "Wiper Replacement"(P. 143)
Cap Replacement	-	Use this function when replacing the cap. Replacing the cap resets the cap usage time stored in the machine. ☞ "Cap Replacement"(P. 146)
Test Printing	-	Print a test pattern to confirm that the ink prints correctly. Perform head cleaning if you observe any ejection failures (e.g., nozzle clogging or deflection). ☞ "Test Printing"(P. 94)
Cleaning	-	Several head cleaning methods are available. Choose the head cleaning method based on test print results. ☞ "Head Cleaning"(P. 96)
Nozzle Recovery	-	Allows other nozzles to be used for printing if maintenance actions like nozzle washing fail to resolve print defects (e.g., nozzle clogging, deflection).
Print	-	Prints a pattern to check nozzle condition and register the nozzle. ☞ "Registering Nozzle Recovery"(P. 114)
Entry	-	Registers the nozzle without printing a pattern.
Reset	-	Initializes the details set.
Test Printing	ON/ <u>OFF</u>	Sets whether to perform nozzle recovery before test printing.
Nozzle Check	-	☞ "Nozzle Check"(P. 115)

Item	Setting *1	Details
Printing Check	<u>ON/OFF</u>	Performs nozzle clogging detection before printing starts.
Check Interval	Check Interval	- Sets the nozzle clogging detection timing.
	Length	0.1 to <u>30.0</u> to 100.0 m Performs nozzle clogging detection after the length set is reached and before the next print starts.
	File	1 to <u>30</u> to 1,000 files Performs nozzle clogging detection after the preset number of files has been printed and before the next print starts.
	Continuation Print	<u>Stop</u> /Continuous Select whether to stop or continue printing if "Nozzle clogging" is detected.
	Action	Off/1 to <u>10</u> to 100 Performs nozzle recovery (cleaning followed by nozzle checking) if "nozzle clogging" is detected.
	Cleaning	<u>Soft</u> /Normal/Hard Sets the cleaning type.
	Retry Count	<u>0</u> to 3 times Performs nozzle recovery (cleaning followed by nozzle checking) for the specified number of times.
	Auto Nozzle Recovery	<u>ON/OFF</u> Performs nozzle recovery automatically if "nozzle clogging" is detected. See below if you wish to perform nozzle recovery manually.  "Registering Nozzle Recovery"(P. 114)
	Judgment Condition	OFF / <u>1</u> to 64 nozzles Set the number of nozzles to be detected as clogged before "nozzle clogging" is detected. Up to 16 nozzles per row can be set. The next print will not start if "nozzle clogging" is detected during continuous printing.
	Auto Maint.	- Sets various maintenance actions to be performed automatically. Set the interval between individual maintenance actions. <ul style="list-style-type: none"> If the warning message "Replace Wasteinktank" appears, the automatic maintenance function is disabled.  "Waste Ink Tank Replacement"(P. 158)
Refresh	0.5/ <u>1.0</u> h	Sets the refresh interval (when a small amount of ink is ejected from the print head nozzles).
	OFF/ <u>48h</u> /1 to 168 h	Sets the interval for washing the suction pump tube (below the cap).
	1 to <u>48</u> h	Sets print head cleaning intervals. This will help prevent nozzle clogging.
	<u>Normal</u> /Soft/Hard	Sets the cleaning type for head cleaning.
Print Maint.		- Sets the maintenance to be performed automatically midway during printing.
Auto Cleaning	Auto Cleaning	- Sets the conditions to perform head cleaning after the preset number of files are printed.
	Setup	File/Length/ <u>Time</u> /OFF Sets the conditions to perform head cleaning.
	Interval	- Sets head cleaning intervals.
	(File)	1 to 1,000 Cleaning starts when the set number of files is exceeded.
	(Length)	1 to 1,000.0 m Cleaning starts when the set print length is exceeded.
	(Time)	10 to 240 min Cleaning starts when the set print time is exceeded.

Item		Setting *1	Details
	Type	<u>Normal</u> /Soft/ Hard	Sets the cleaning type for head cleaning.
	Cleaning Check	ON/ <u>OFF</u>	Sets whether nozzle checking is performed after head cleaning is completed.
	Interval Wiping	<u>OFF</u> /3 to 255 min	Wiping starts when the set print time is exceeded.
	Refresh	<u>Weak</u> / Standard/ Strong	Select the refresh (flushing) time during printing.
Waste Ink Tank		-	Resets or corrects the waste ink tank usage count.  "Waste Ink Tank Replacement"(P. 158)
	Reset Waste Ink Tank Volume	-	Resets the waste ink tank usage count.  "Replacing the lower-left waste ink tank"(P. 158)
	Adjust Waste Ink Volume	-	Corrects the waste ink tank usage count.  "When "Check Waste Ink Tank" message appears"(P. 158)
	Tank Capacity	-	Displays the waste ink tank capacity.
Air PG		-	Expels any air in the ink paths. <ul style="list-style-type: none"> Use this if Ink End is still displayed after ink replacement.

*1. The default settings are shown underlined.

Registering Nozzle Recovery

Allows other nozzles to be used for printing if maintenance actions like nozzle washing fail to resolve ejection failures (e.g., nozzle clogging or deflection).



- Nozzle recovery can be specified for up to 20 nozzles per row. The time taken for printing remains unchanged even when nozzle recovery is set.



- Load media at least 500 mm wide. You cannot print the entire pattern if media less than 500 mm wide is used.

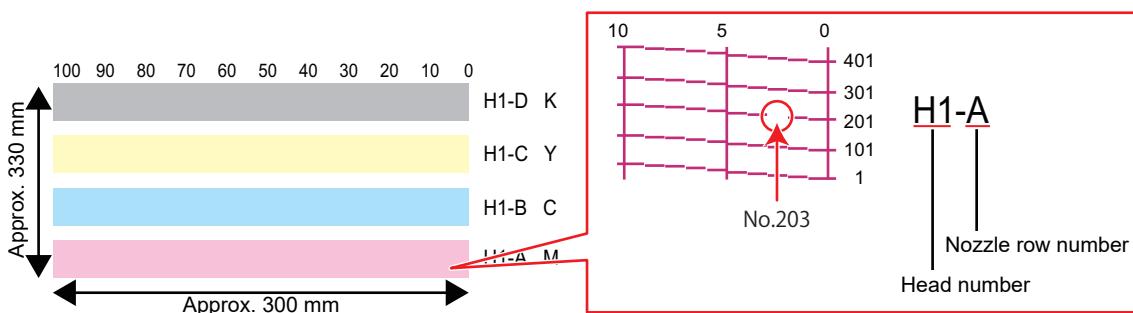
1 Position the media.

2 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

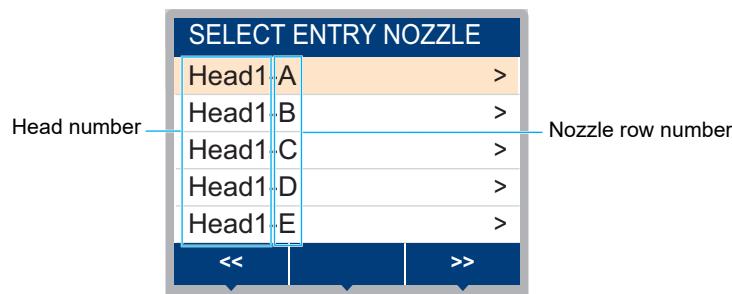
- The Maintenance menu is displayed.

3 Select [Nozzle Recovery] > [Print], then press the [ENTER] key.

- Print a nozzle recovery pattern.
- The Select Entry Nozzle screen appears once printing is complete.

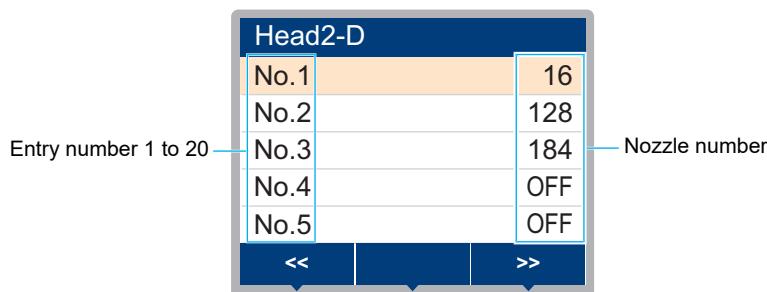


4 Select the "head number and nozzle row" for nozzle recovery, then press the [ENTER] key.



5 Enter the "nozzle number" for nozzle recovery, then press the [ENTER] key.

- Select the entry number before entering the nozzle number.
- Nozzle recovery is set.



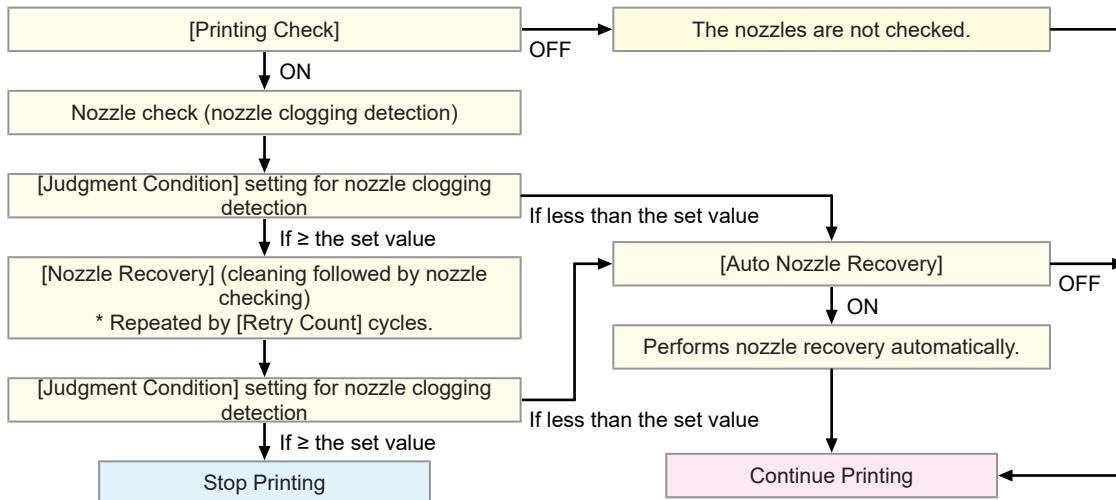
6 Press the [ENTER] key once entry is complete.



- Select [Maintenance] > [Nozzle Recovery] > [Test Print], then select "ON" to perform nozzle recovery and test printing. ["Test Printing"\(P. 94\)](#)

Nozzle Check

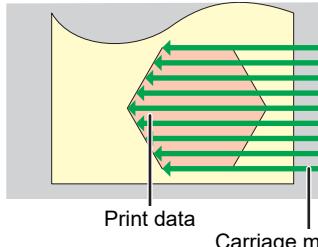
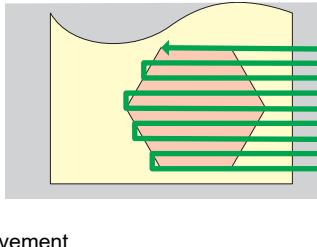
This is used to check for nozzle clogging before printing starts. Sets whether to perform maintenance functions automatically if nozzle clogging is detected.



3.3 Function Setting Menu

This is used to set various operations to ensure optimal machine performance.

● Menu List

Item	Setting ^{*1}	Details
Logical Seek	<u>Host</u> /OFF/ON	<p>Sets the range of carriage movement.</p> <ul style="list-style-type: none"> ON: Print data area <p>Unidirectional printing</p>  <p>Bi-directional printing</p> 
Option Roll Unit Select	-	Selects the roll unit used.
Feeding unit	<u>ON</u> /OFF	Set to "OFF" if the feeding unit is not used.
Feed tension bar	<u>ON</u> /OFF	Displayed when the feeding unit is on. Set to "OFF" if the feeding tension bar is not used.
Take-up Unit	<u>ON</u> /OFF	Set to "OFF" if the take-up unit is not used.
Take-up tension bar	<u>ON</u> /OFF	Displayed when the take-up unit is on. Set to "OFF" if the take-up tension bar is not used.
Feeding/take-up switch	<u>Continuous</u> / Temporary	<p>Set the operation to assign to the feeding/take-up switch.</p> <ul style="list-style-type: none"> Continuous: Operation continues until the switch is pressed again. Temporary: Operates only while the switch is pressed. <p>When the direct-connection unit is attached, feeding/take-up only continues as long as the switch is pressed, regardless of the continuous/temporary setting.</p>
Tension roller	ON/ <u>OFF</u>	<ul style="list-style-type: none"> ON: The tension roller operates for printing even when the platens are used. ^{*2}
Take-up diameter detection	<u>AUTO</u> / MANUAL	Sets the method for detecting the media outer diameter for the take-up unit and feeding unit.
Drying Time	-	Sets the time for ink to dry.
Scan	<u>Host</u> /0.0 to 9.9 sec	<p>Sets the stop time of the carriage after each scan.</p> <ul style="list-style-type: none"> The MIMAKI RIP software (RasterLink) indicates this as "Pause Time per Scan".
Print End	<u>Host</u> /0 to 120 min	<p>Sets the stop time after printing. The next data is printed once the set time has elapsed.</p> <ul style="list-style-type: none"> The Mimaki RIP software (RasterLink) does not allow the user to specify Print End. If the machine is set to "HOST", the time will be "0".
Power Setting	-	Sets the times to turn the power on and off automatically.
Auto Power-off	5 to <u>15</u> to 60 min	Sets the time until the power is automatically turned off.
Auto Power-on	-	Sets the time to automatically turn on the power.

Item	Setting ^{*1}	Details		
Power On Settings	Setup	<u>ON/OFF</u>	Sets whether to turn on or off the power.	
	Time	<u>0:00</u> to 23:59	Sets the time to turn on the power.	
	Day	Monday to Sunday	Sets whether to turn on or off the power on each day of the week.	
	Nozzle Check	<u>ON/OFF</u>	Automatically executes the nozzle check function when the machine is started with auto power-on. Performs nozzle recovery (cleaning followed by nozzle checking) if "nozzle clogging" is detected.	
	Cleaning	<u>Soft</u> /Normal/ Hard	Sets the cleaning type.	
	Retry Count	<u>0</u> to 3 times	Performs nozzle recovery (cleaning followed by nozzle checking) for the specified number of times.	
Top Blower		<u>ON/OFF</u>	Sets the blowing fan operation during printing.	
Strength		<u>AUTO</u> /Low/ High	Sets the blowing fan wind strength.	
WhiteSpace Setting		-	Sets the offset value from the media left and right standard margins (15 mm). <ul style="list-style-type: none"> The left and right margins should be set to at least -5 mm when using the media holder. This eliminates the risk of printing on top of the media holder. The Mimaki RIP software (RasterLink) does not allow the user to specify margins. If the machine is set to "Host", the offset value will be "0 mm" for the left and right margins. 	
Margin		-	<ul style="list-style-type: none"> Reducing the space length may cause media sagging, resulting in discrepancies in the distance the media is fed. 	
Space Btwn PP.		<u>None</u> /10 to 500 mm		
Space Feed Mode		<u>Intermittent</u> / Continuous	Alters the feed method for blank space included in the image data. <ul style="list-style-type: none"> Intermittent: Uses intermittent feeding based on the timing of a fraction of the pass. Continuous: Feeds forward by skipping blank parts. 	
View Feed		<u>ON/OFF</u>	Sets whether or not to feed the media forward to view the print results—for example, during test printing.	
Auto Remote		<u>ON/OFF</u>	Sets whether to automatically switch to REMOTE mode and start printing if data is received locally.	

*1. The default settings are shown underlined.

*2. If the platens are not fitted, the tension roller will operate regardless of this setting.

3.4 Environment Setting Menu

This is used to set various operations to ensure optimal machine performance.

● Menu List

Item	Setting *1	Details
LANGUAGE	<u>English</u> / 日本語 / Deutsch / Português / Español / Italiano / Korean	Sets the display language.
Time Set	-20 to <u>0</u> to +4 h	Sets the current time and date. (With respect to JST) <ul style="list-style-type: none"> This can be set within the range of -20 to +4 hours.
Key Buzzer	<u>ON</u> /OFF	Sets an audible tone when keys are pressed. <ul style="list-style-type: none"> Audible signals indicating errors, warnings, and operation end cannot be muted, even if "OFF" is selected for this setting.
Unit Setting	-	Set the display units.
Temp.	<u>°C</u> /°F	Sets the display unit for temperature (Celsius/Fahrenheit).
Length	<u>mm</u> /inch	Sets the display units for length and area. <ul style="list-style-type: none"> Some items are displayed in "mm" even if "inch" is selected.
Network	-	Sets the network address. The machine must be restarted to enable this setting.
Check IP Address	-	Displays the machine's current IP address. <ul style="list-style-type: none"> It may take some time to determine the IP address. If the IP address cannot be determined, the display will indicate "0.0.0.0".
Check MAC Address	-	Displays the machine's current MAC address.
DHCP	<u>ON</u> /OFF	Select "ON" to use the IP address assigned by the DHCP server.
AutoIP	<u>ON</u> /OFF	Select "ON" to use the IP address set by the AutoIP protocol. Note that DHCP takes priority if DHCP is set to "ON".
Ip Address	-	Sets the IP address used by the machine. <ul style="list-style-type: none"> This can be set when both [DHCP] and [AutoIP] are disabled.
Default Gateway	-	Sets the default gateway used by the machine. <ul style="list-style-type: none"> This can be set when both [DHCP] and [AutoIP] are disabled.
DNS Address	-	Sets the DNS server address used by the machine. <ul style="list-style-type: none"> This can be set when both [DHCP] and [AutoIP] are disabled.
Sub Net Mask	-	Sets the subnet mask used by the machine. <ul style="list-style-type: none"> This can be set when both [DHCP] and [AutoIP] are disabled.
Remote Control	-	An application (MRA: Mimaki Remote Access) is required to use the remote control function. MRA is a remote access tool installed on a computer or smartphone that allows viewing of product information and panel operation from a remote location away from the machine (within the same network segment).
Setup	<u>Enable</u> /Disable	Enable/disable remote control.

Item	Setting ^{*1}	Details
PIN code	<u>0000</u> to 9999	Enter the same PIN code as MRA. The PIN code is used for authentication between the machine and MRA. <ul style="list-style-type: none">When the machine is set to "0000", MRA can access the machine with any PIN code.
KeyLife	5 to <u>30</u> to 120 min	Sets the time interval before disconnecting the machine and MRA if no operations are performed using MRA.
Machine Reset	-	Initializes the details set.

*1. The default settings are shown underlined.

3.5 Machine Status Menu

This is used to check machine information.

● Menu List

Item		Details
Usage	WIPING	<p>The number of wiping cycles is displayed.</p> <ul style="list-style-type: none"> To reset the number of wiping cycles, press the [FUNC2] key while the level is displayed.
	Print Length	Displays the total length printed.
	Print Area	Displays the total area printed.
	Use Time	Displays the total time the power has been turned on.
	Capping Use Days	Displays the number of days since the cap was replaced.
	Waste Ink Tank	<p>Displays the approximate level of waste ink in the waste ink tank as a percentage.</p> <p>To reset waste ink levels, press the [FUNC1] key while the level is displayed.</p>
Maintenance History	Maintenance	<p>Displays a record of maintenance function execution (up to 10).</p> <ul style="list-style-type: none"> Cleaning  P. 96, Pump Tube Cleaning  P. 131, Nozzle Washing  P. 166
	Replace Wiper	Displays a record of wiper replacement (up to 5).  P. 143
	Ink replacement	<p>Displays a record of ink pack replacement for each ink slot (up to 5).  "Replacing Ink"(P. 42)</p> <ul style="list-style-type: none"> Slot 1 to 8
	Cap Replacement	Displays a head cap replacement history.  "Cap Replacement"(P. 146)
Version		Displays the machine firmware and other versions.
Error History		<p>Displays the error and warning history.</p> <ul style="list-style-type: none"> These are listed in chronological order. Use the keys to cycle through occurrence time/date and error/warning information.
List		This is used to print machine information.

Chapter 4 Maintenance



This chapter

To ensure years of precise performance, maintain the machine periodically based on frequency of use.

Read the maintenance precautions thoroughly before maintaining this product.

Maintenance Precautions	122	Replacement of Consumable Item	142
Maintenance Methods	123	Consumable Item Replacement Timing	142
Maintenance Items and Timing	123	Wiper Replacement	143
Ink Maintenance	124	Wiper Cleaner Replacement	144
Cap Rubber Cleaning	124	Cap Replacement	146
Carriage Underside Cleaning	125	Replacing the Absorber Around the Station	148
Wiper Cleaning	126	Exhaust Fan Filter Replacement	150
NCU Cleaning	128	Blowing Fan Filter Replacement	150
DAS (Automatic Correction Function) Sensor Cleaning	129	Pinch Roller Replacement	151
Ink-Receiving Pan Spacer Cleaning	130	Media Holder and Cloth Holder Replacement	153
Ink Slope Cleaning	131	Ink Supply Unit Ink Absorber Replacement	157
Ink Discharge Channel Cleaning	131	Waste Ink Tank Replacement	158
Media Sensor Cleaning	132		
Media Holder and Cloth Holder Cleaning	132		
Jam Sensor Detecting Plate Cleaning	134		
Platen and Platen Wire Cleaning	135		
Pinch Roller and Grit Roller Cleaning	135		
Tension Roller Cleaning	136		
Blowing Fan Filter Cleaning	137		
Cover (Exterior) Cleaning	139		
When this Printer is Left Unused for a Long Time	139		

4.1 Maintenance Precautions



- This machine includes parts that must be replaced periodically. We therefore recommend taking out a maintenance contract. Carry out maintenance periodically and replace consumable items to prevent quality defects and accidents.

⚠ WARNING



- Clean periodically. Debris and dust will accumulate on electrical components when the machine is used for extended periods. There is a risk of failure, electric shock, or fire due to current leakage.
- Do not clean by blowing—e.g., avoid using air blowers. Doing so may lead to failure, electric shock, or fire involving the machine if airborne debris or dust gets inside electrical components. Wipe using a soft cloth soaked in diluted neutral detergent and thoroughly wrung out. A vacuum cleaner may also be used for cleaning.
- Be careful to prevent liquids from getting inside the machine. Otherwise there is a risk of failure, electric shock, or fire.

⚠ CAUTION



- For heavy soiling, wipe using a soft cloth soaked in diluted neutral detergent and thoroughly wrung out.
- Pay close attention to ventilation and be sure to wear safety glasses, gloves, and a mask when handling ink, maintenance liquid, waste ink, or other solutions used with the machine. Leaking ink may adhere to the skin or get into the eyes or mouth.



NOTICE



- Never touch the print head nozzle surface. Do not allow water or alcohol to come into contact with the print nozzle surface. This will increase the risk of machine failure or ejection failures (e.g., nozzle clogging or deflection).
- Do not use cotton swabs to clean around the head or carriage. Fibers from cotton swabs may adhere to the head nozzle surface and lead to ejection failures (e.g., nozzle clogging or deflection).
- Do not splash ink or maintenance liquid on the covers. Exposure to splashing ink or maintenance liquid may damage or deform the cover.
- Do not use benzine, thinner, or any chemical agent containing abrasives. Use of these chemicals may result in damage to or deformation of parts.
- Do not use organic solvents such as acetone and IPA. Doing so may damage the machine.
- Do not move the carriage by hand. To move the carriage, use the carriage out function on the menu.

4.2 Maintenance Methods

Maintenance Items and Timing

Timing	Item
Every day after work	Clean around the wiper.  "Wiper Cleaning"(P. 126)
Every three days, at the start of the work	Shake the ink.  "Ink Maintenance"(P. 124)
Every three days after work	Dispose of ink in the waste ink tank in the lower left of the machine.  "Waste Ink Tank Replacement"(P. 158)
At the end of the week's work	Clean the cap rubber.  "Cap Rubber Cleaning"(P. 124)
	Clean the underside of the carriage.  "Carriage Underside Cleaning"(P. 125)
	Check the waste ink levels in the waste ink tank.  "When 'Check Waste Ink Tank' message appears"(P. 158)
	Clean the ink discharge channel.  "Ink Discharge Channel Cleaning"(P. 131)
At the end of two weeks' work	Clean the blowing fan filter.  "Blowing Fan Filter Replacement"(P. 150)
When the media is replaced	Clean the ink-receiving pan spacers.  "Ink-Receiving Pan Spacer Cleaning"(P. 130)
	Clean the tension roller.  "Tension Roller Cleaning"(P. 136)
	Clean the ink slope.  "Ink Slope Cleaning"(P. 131)
Every month	Clean the NCU.  "NCU Cleaning"(P. 128)
	Clean the DAS sensor.  "DAS (Automatic Correction Function) Sensor Cleaning"(P. 129)
	Clean the media sensor.  "Media Sensor Cleaning"(P. 132)
	Clean the media holders and cloth holders.  "Media Holder and Cloth Holder Cleaning"(P. 132)
	Clean the jam sensor detecting plate.  "Jam Sensor Detecting Plate Cleaning"(P. 134)
	Clean the platen.  "Platen and Platen Wire Cleaning"(P. 135)
	Clean the pinch rollers and grit rollers.  "Pinch Roller and Grit Roller Cleaning"(P. 135)
When not used for more than a week	Clean the cover (exterior).  "Cover (Exterior) Cleaning"(P. 139)
	Clean the cap and wash the ink discharge channels. After cleaning, store without turning off the main power supply.  "When this Printer is Left Unused for a Long Time"(P. 139)

Items Required for Maintenance

To order replacement consumable items, contact your local dealer or our service office. For more information on consumable items, refer to our website (<https://mimaki.com/supply/inkjet.html>).



- Do not store consumable items in locations where children may enter.

Ink Maintenance

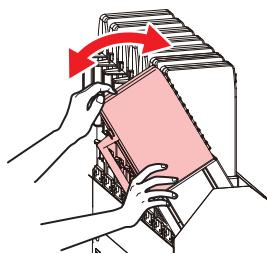
If ink constituents are sedimented, the ink density may become uneven. We recommend shaking the ink periodically to keep printing consistent.

Once every three days.

(Important!) • **Shake taking care that the ink eco-cases do not become detached from the ink supply unit.**
Ink may leak out if the ink eco-cases become detached.

1 Shake the ink eco-cases slowly approximately 10 times.

- Shake the ink eco-cases back and forth while holding the top.



- Be sure to shake the ink eco-case back and forth by holding its top. Ink may leak out if the top is not held and the ink eco-cases become detached.

Cap Rubber Cleaning

The cap prevents the print head nozzle surface from drying out. Continuing to use a dirty cap may affect ink take-up and lead to ejection failures (such as nozzle clogging or deflection).

! • Be careful to avoid leaving fragments from the cleaning stick behind when cleaning. These fragments will increase the risk of ejection failures (e.g., nozzle clogging or deflection).

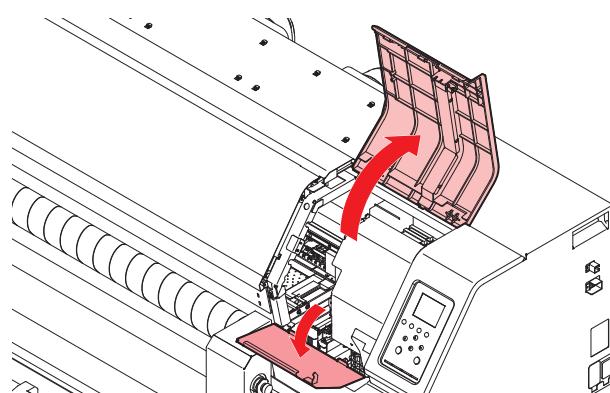
1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

2 Select [Station Maint.] > [Carriage Out] > [Move To Platen Right End], then press the [ENTER] key.

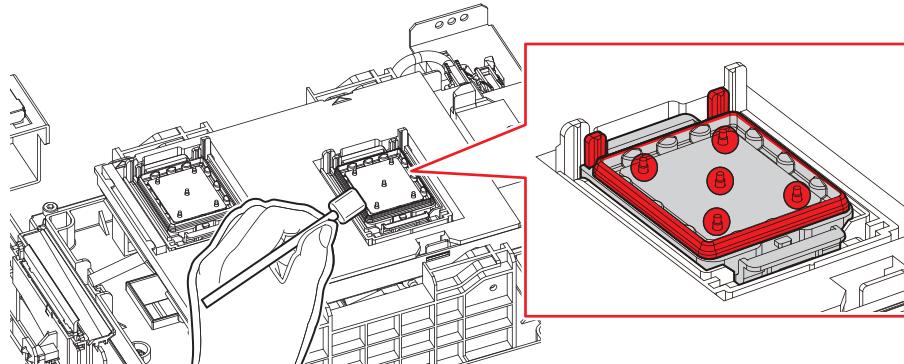
- The carriage moves over the platen.

3 Open the maintenance cover on the right side.



4 Clean the cap rubber.

- Wipe off any ink and dust adhering using a cleaning stick moistened with maintenance liquid. Wipe off the maintenance liquid. Make sure none remains.
- Clean the areas indicated in red in the diagram (the entire interior and exterior of the cap rubber, the tabs, and the mesh retainers).



5 Close the maintenance cover, then press the [ENTER] key.

Carriage Underside Cleaning

The underside of the carriage becomes coated with ink wiped off by the wiper. Continuing to use the dirty carriage underside will rub dried ink and attached dust on to the media, resulting in contaminated prints.

The print head uses an extremely delicate mechanism. Take great care when handling it.



- Be careful to avoid leaving fragments from the cleaning stick behind when cleaning. These fragments will increase the risk of ejection failures (e.g., nozzle clogging or deflection).

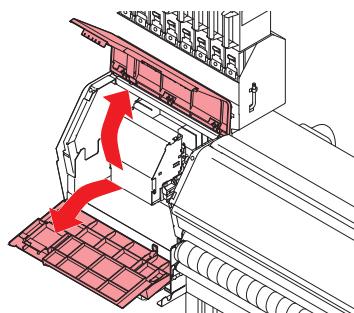
1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

2 Select [Station Maint.] > [Carriage Out] > [Move To Maint. Space], then press the [ENTER] key.

- The carriage moves to the maintenance space.

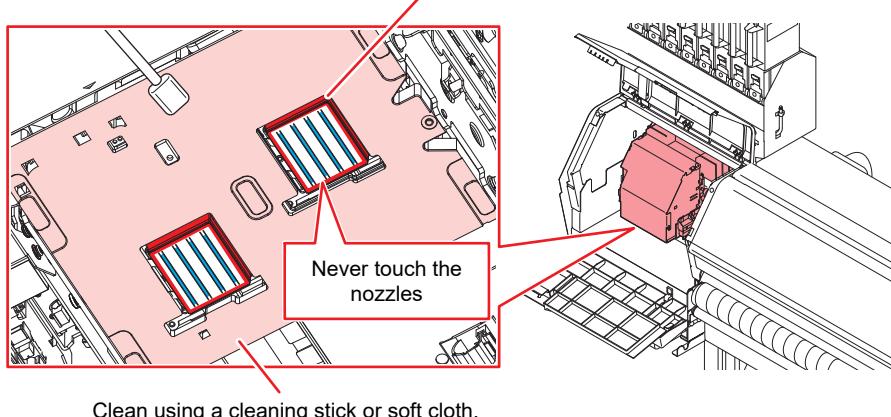
3 Open the maintenance cover on the left side.



4 Clean around the print head.

- Wipe off any ink and dust adhering using a cleaning stick moistened with maintenance liquid. Wipe off the maintenance liquid. Make sure none remains.

Clean the print head sides and all around the nozzle plate using a cleaning stick.



- Never touch the print head nozzles (areas indicated in blue in the diagram).

5 Once cleaning is complete, close the cover, then press the [ENTER] key.**Wiper Cleaning**

The wiper wipes off ink adhering to the print head nozzle surface. Continuing to use with a dirty wiper will cause dried ink and attached dust to rub against the head nozzle surface, and lead to ejection failures (e.g., nozzle clogging or deflection).



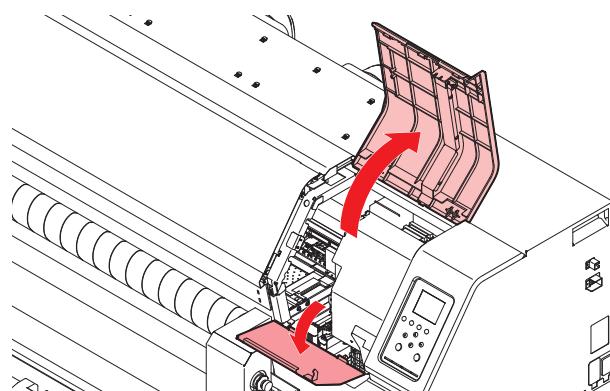
- Be careful to avoid leaving fragments from the cleaning stick behind when cleaning. These fragments will increase the risk of ejection failures (e.g., nozzle clogging or deflection).

1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

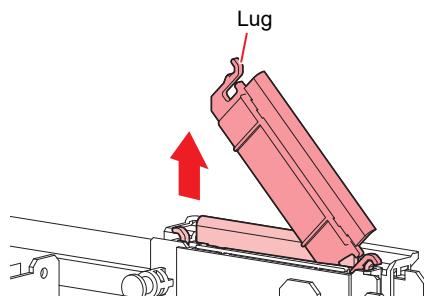
2 Select [Station Maint.] > [Carriage Out] > [Move To Platen Right End], then press the [ENTER] key.

- The carriage moves over the platen.

3 Open the maintenance cover on the right side.

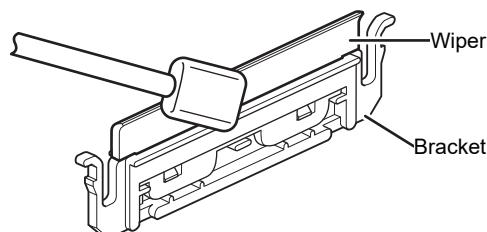
4 Remove the wiper.

- Hold the lug at the rear of the wiper bracket, then pull out the wiper.



5 Clean the wiper and bracket.

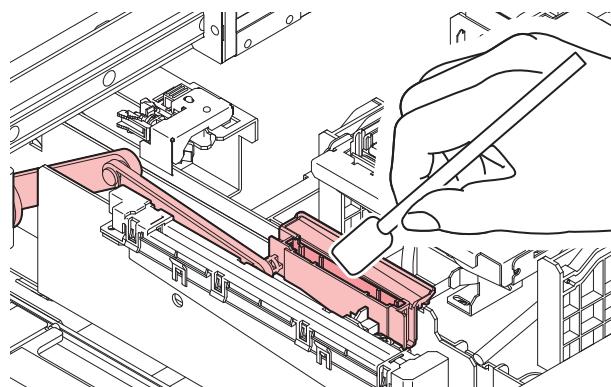
- Wipe off any ink and dust adhering using a cleaning stick moistened with maintenance liquid. Wipe off the maintenance liquid. Make sure none remains.



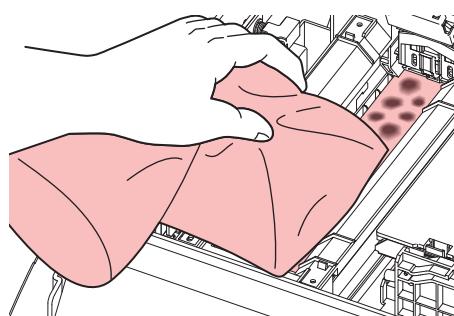
- Replace dirty or warped wipers with new ones. Wiper Replacement

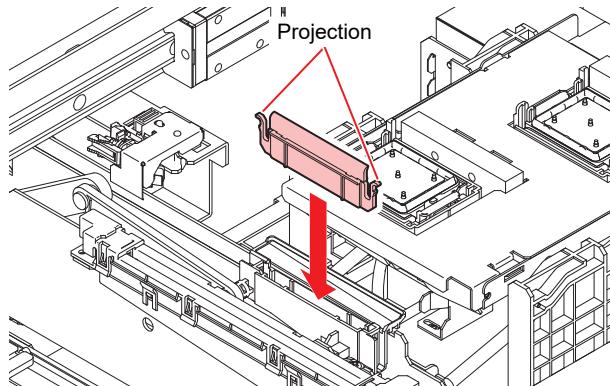
6 Clean the wiper slider.

- Wipe off any ink and dust adhering using a cleaning stick moistened with maintenance liquid. Wipe off the maintenance liquid. Make sure none remains.



- If there is a lot of ink in the pad case, use absorbent paper or the like to absorb it.



7 Reattach the wiper at the original position.**8** Once cleaning is complete, close the cover, then press the [ENTER] key.**NCU Cleaning**

The NCU uses a sensor to monitor the ink droplets ejected from the print head nozzles. Continuing to use the dirty NCU may prevent the nozzle check function from operating correctly.



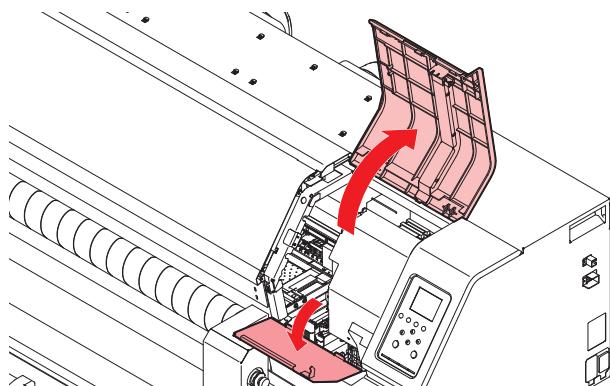
- Be careful to avoid leaving fragments from the cleaning stick behind when cleaning. These fragments will increase the risk of ejection failures (e.g., nozzle clogging or deflection).

1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

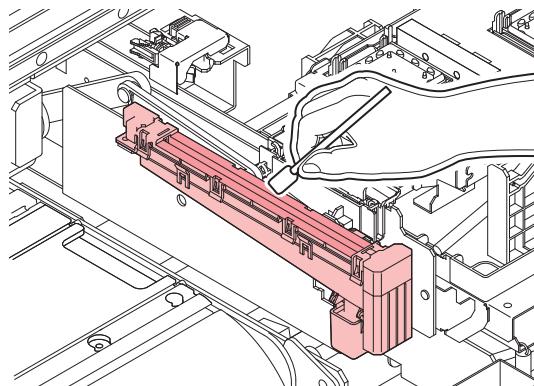
2 Select [Station Maint.] > [Carriage Out] > [Move To Platen Right End], then press the [ENTER] key.

- The carriage moves over the platen.

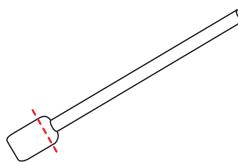
3 Open the maintenance cover on the right side.

4 Clean the NCU.

- Wipe off any ink and dust adhering using a cleaning stick moistened with maintenance liquid. Wipe off the maintenance liquid. Make sure none remains.



- Insert the cleaning stick as far as the line shown in the illustration.



5 Once cleaning is complete, close the cover, then press the [ENTER] key.

DAS (Automatic Correction Function) Sensor Cleaning

The DAS sensor is located on the carriage underside. If dust or debris accumulates on the sensor, DAS (☞ P. 108) may not function.

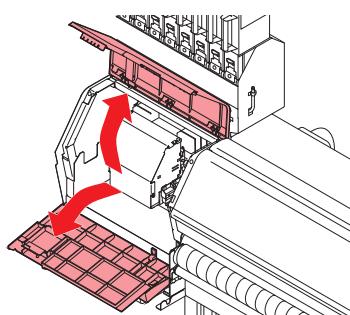
1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

2 Select [Station Maint.] > [Carriage Out] > [Move To Maint. Space], then press the [ENTER] key.

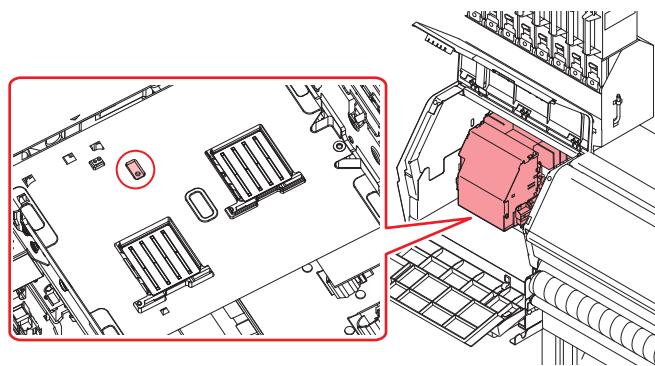
- The carriage moves to the maintenance space.

3 Open the maintenance cover on the left side.



4 Clean the DAS sensor.

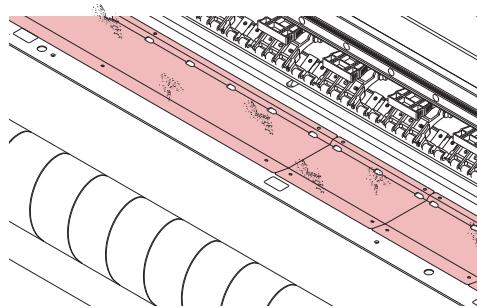
- Wipe clean using cotton swabs or a soft cloth.



- For heavy soiling, wipe using a soft cloth soaked in diluted neutral detergent and thoroughly wrung out.

5 Once cleaning is complete, close the cover, then press the [ENTER] key.**Ink-Receiving Pan Spacer Cleaning**

Remove the spacers and wash them to remove any ink adhering to the ink-receiving pan spacers, for example when replacing the media.



- Be careful to prevent liquids from getting inside the machine. Otherwise there is a risk of failure, electric shock, or fire.
- Do not pour water directly over the ink-receiving pan spacers while they are mounted on the machine.**

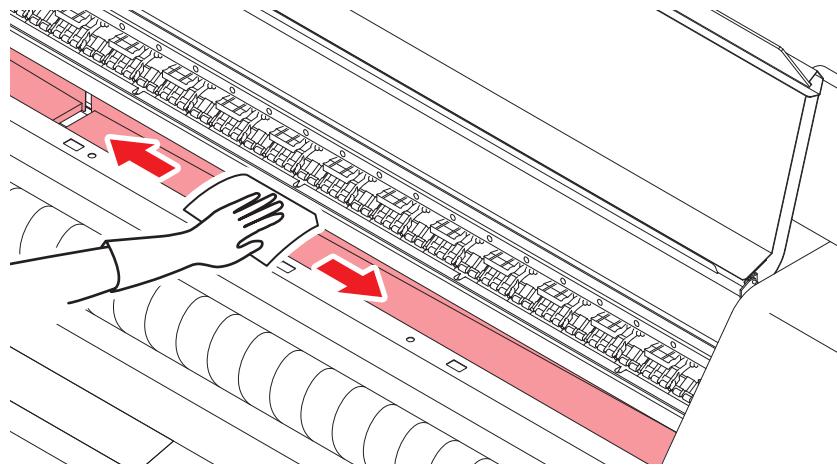


- For heavy soiling, remove the ink-receiving pan spacers, then wipe using a soft cloth soaked in diluted neutral detergent and thoroughly wrung out.



- Do not use organic solvents such as acetone and IPA. Doing so may damage the machine.

Ink Slope Cleaning



- Be careful to prevent liquids from getting inside the machine. Otherwise there is a risk of failure, electric shock, or fire.
- **Do not pour water directly over the ink slope.**



- For heavy soiling, wipe using a soft cloth soaked in diluted neutral detergent and thoroughly wrung out.



- Do not use organic solvents such as acetone and IPA. Doing so may damage the machine.

Ink Discharge Channel Cleaning

Clean the ink discharge channel regularly to prevent clogging of the ink discharge channel below the cap.

1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

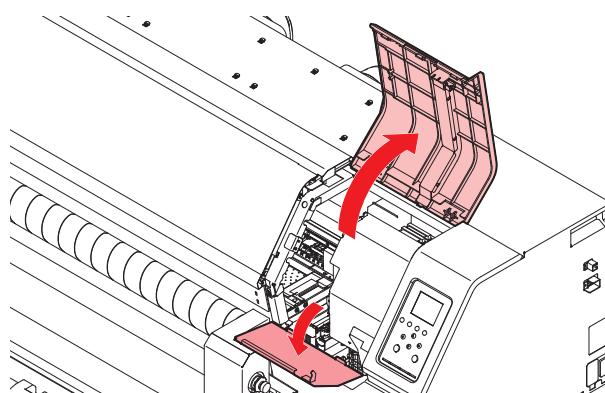
2 Select [Station Maint.] > [Pump tube cleaning], then press the [ENTER] key.

- The cap is filled with maintenance liquid.



- Close the cover. The cap cannot be filled with maintenance liquid while the cover is open. This is also true if the maintenance liquid cartridge is empty.

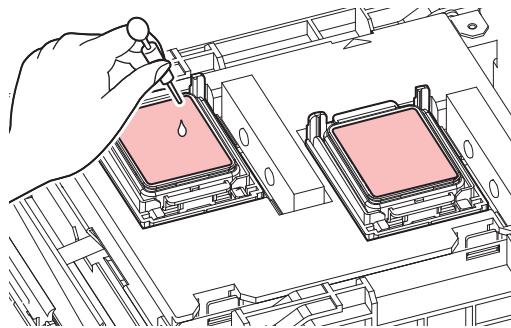
3 Open the maintenance cover on the right side.



- Check to confirm that approximately half a capful of maintenance liquid remains.



- If not, use a syringe to draw up some maintenance liquid and drip in approximately half a capful.



- Check to confirm that there is approximately half a capful of maintenance liquid inside.



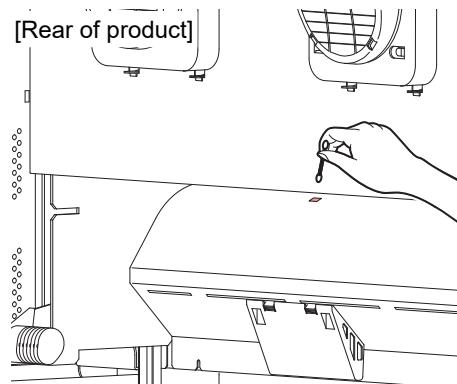
- If not, use a syringe to draw up some maintenance liquid and drip in approximately half a capful.

4 Close the maintenance cover, then press the [ENTER] key.

- Pump tube (ink discharge channel below the cap) washing starts.

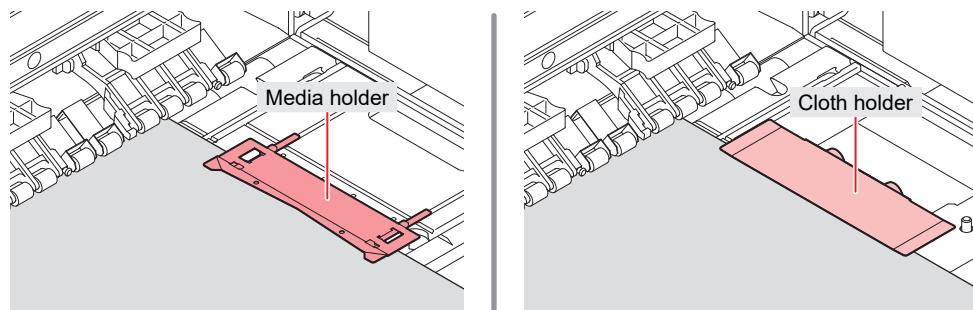
Media Sensor Cleaning

Media sensors are located on the rear pre-covers (2 locations). The media cannot be detected correctly if dust or debris accumulates on the sensors. Remove any debris using cotton swabs or a soft cloth.



Media Holder and Cloth Holder Cleaning

Continuing to use the dirty platen will prevent proper feeding of the media. It will also cause dried ink and attached dust to rub against the head nozzle surface and lead to ejection failures (e.g., nozzle clogging or deflection).





- Turn off the main power supply and unplug the power cable before carrying out maintenance.



- Be careful to prevent liquids from getting inside the machine. Otherwise there is a risk of failure, electric shock, or fire.



- For heavy soiling, wipe using a soft cloth soaked in diluted neutral detergent and thoroughly wrung out.

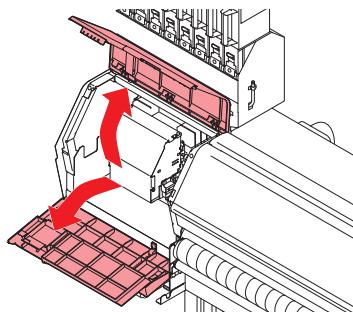


- Do not use organic solvents such as acetone and IPA. Doing so may damage the machine.

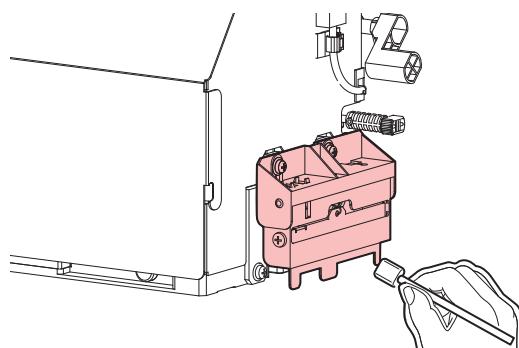
Jam Sensor Detecting Plate Cleaning

Continuing to use the dirty carriage underside will rub dried ink and attached dust on to the media, resulting in contaminated prints.

- 1** On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.
 - The Maintenance menu is displayed.
- 2** Select [Station Maint.] > [Carriage Out] > [Move To Maint. Space], then press the [ENTER] key.
 - The carriage moves to the maintenance space.
- 3** Open the maintenance cover on the left side.



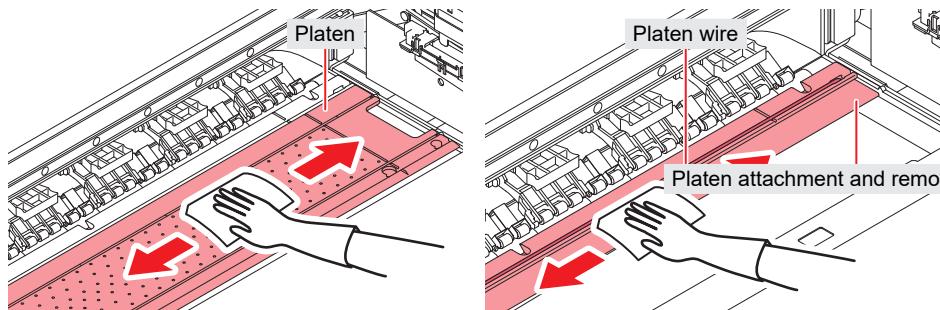
- 4** Clean the jam sensor detecting plate.
 - Clean the jam sensor detecting plate underside at the left and right sides of the carriage.
 - Wipe off any ink and dust adhering using a cleaning stick moistened with maintenance liquid. Wipe off the maintenance liquid. Make sure none remains.



- 5** Once cleaning is complete, close the cover, then press the [ENTER] key.

Platen and Platen Wire Cleaning

Continuing to use the dirty platen will prevent proper feeding of the media. It will also cause dried ink and attached dust to rub against the head nozzle surface and lead to ejection failures (e.g., nozzle clogging or deflection).



- Turn off the main power supply and unplug the power cable before carrying out maintenance.



- Be careful to prevent liquids from getting inside the machine. Otherwise there is a risk of failure, electric shock, or fire.
- Do not pour water directly over the platens.**



- The grooves in which the media holder slides and the media is cut are susceptible to dust accumulation. Remove any debris carefully.



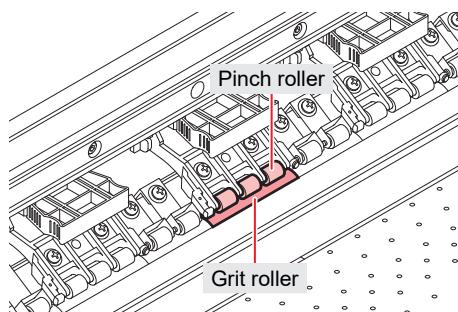
- For heavy soiling, wipe using a soft cloth soaked in diluted neutral detergent and thoroughly wrung out.



- Do not use organic solvents such as acetone and IPA. Doing so may damage the machine.

Pinch Roller and Grit Roller Cleaning

Continuing to use the dirty platen will prevent proper feeding of the media. It will also cause dried ink and attached dust to rub against the head nozzle surface and lead to ejection failures (e.g., nozzle clogging or deflection).



- Turn off the main power supply and unplug the power cable before carrying out maintenance.



- Be careful to prevent liquids from getting inside the machine. Otherwise there is a risk of failure, electric shock, or fire.



- Do not use organic solvents such as acetone and IPA. Doing so may damage the machine.

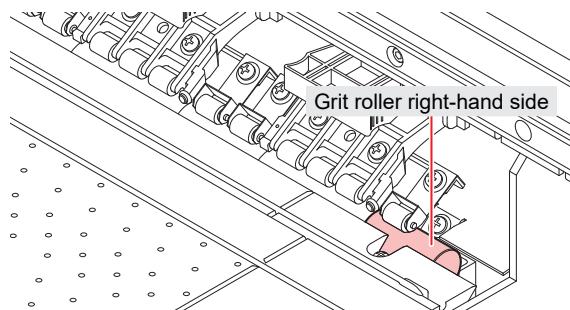
● For grit rollers

1 Open the front cover.

2 Raise the clamp lever.

3 Remove any dirt from the grit rollers by gently brushing several times with a plastic brush.

- Brush the entire circumference by rotating the right-hand side of the grit rollers with your fingers.



- Wipe the ends of the dirt brush clean with a dry cloth.
- If the dirt resists removal, wet the brush with water.

Important!

- Be sure to use a plastic brush to clean the grit rollers. Wiping with cloth or paper towels will result in fibers catching and adhering to the rough surfaces. Using a wire brush will damage the grit rollers and prevent correct feeding.
- After brushing with water, feed a piece of scrap media through to remove any moisture.

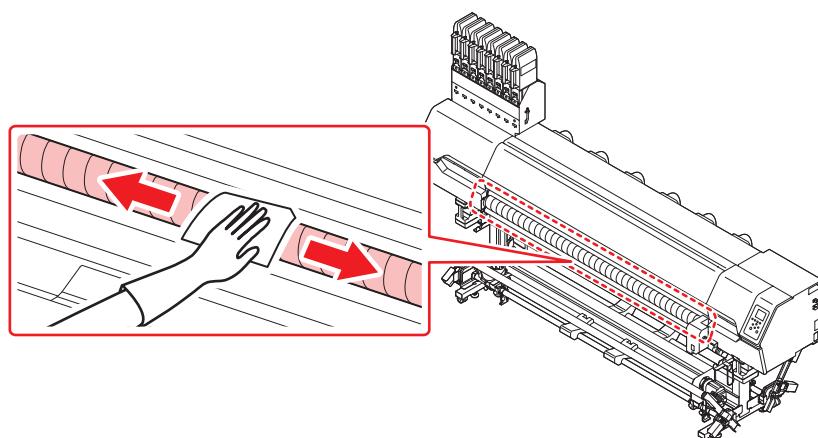
● For pinch rollers

Use a cloth to remove any ink or other dirt from the pinch roller surfaces.



- For heavy soiling, wipe using a soft cloth soaked in diluted neutral detergent and thoroughly wrung out.

Tension Roller Cleaning



- For heavy soiling, wipe using a soft cloth soaked in diluted neutral detergent and thoroughly wrung out.

Blowing Fan Filter Cleaning

Wash the blowing fan filter in water if it is dirty.

● Recommended cleaning guide

(Important!)

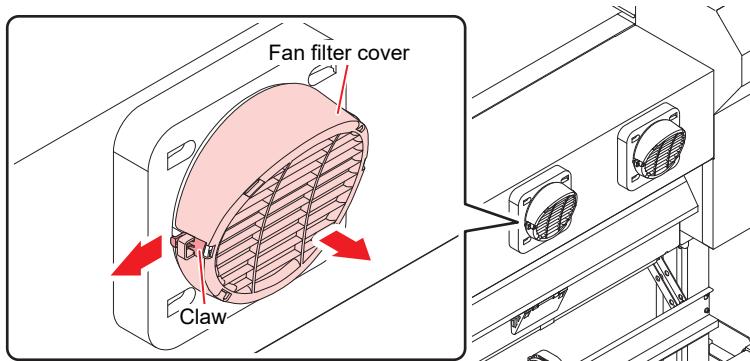
- Check the filter for dirt every two weeks, and wash.
- Replace the filter every three months.  "Blowing Fan Filter Replacement"(P. 150)



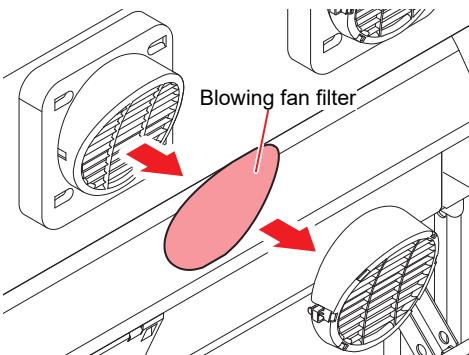
- Turn off the main power and unplug the power cable before replacement.

1 Remove the fan filter cover.

- Push the fan filter cover claw outward, and pull the cover to the front.



2 Remove the filter.



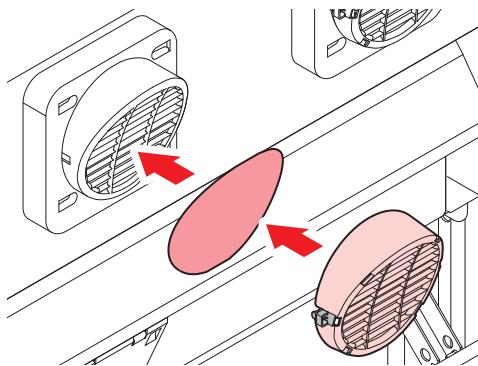
3 Wash the filter.



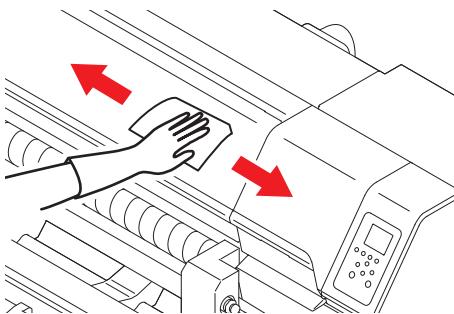
- Dry the filter after washing.

4 Attach the dry filter together with the fan filter cover.

- Push in the fan filter cover until the tab clicks.



Cover (Exterior) Cleaning



- Be careful to prevent liquids from getting inside the machine. Otherwise there is a risk of failure, electric shock, or fire.



- For heavy soiling, wipe using a soft cloth soaked in diluted neutral detergent and thoroughly wrung out.

When this Printer is Left Unused for a Long Time

Clean as follows if the product is not used for one week or longer:

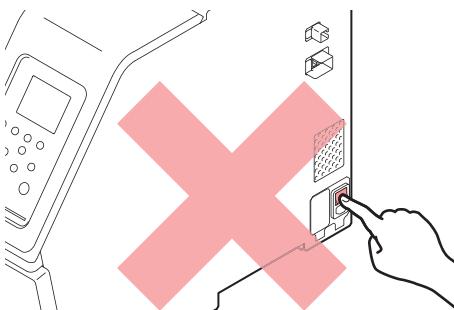
Check beforehand

Is [Near End] or [Ink End] displayed?

- Maintenance liquid and ink is aspirated during the washing operation. Washing is not possible if an error occurs during this process. Replace with new ink.



- Do not turn off the main power supply. Turning off the main power supply will disable the automatic maintenance function (including nozzle clogging prevention function and ink discharge channel cleaning function). This increases the risk of ejection failures (such as nozzle clogging or deflection).



- Do not leave media loaded on the platen. This may leave irregularities or ripples in the media.



When the machine is not in use, raise the clamp lever to **separate the pinch rollers from the grit rollers**.

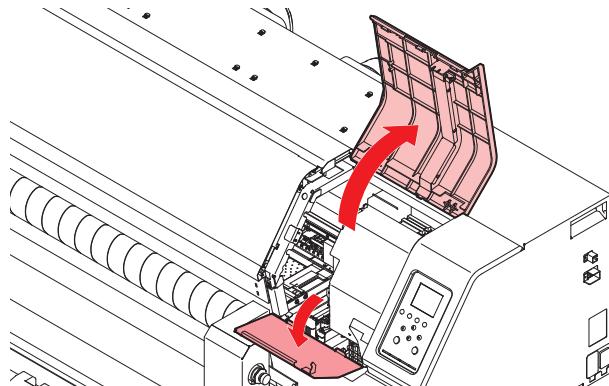
- Leaving the pinch rollers lowered may cause them to become deformed and prevent media from being fed correctly.
- Leaving media loaded will subject it to force from the pinch rollers, which may leave pinch roller marks on it.



- If Check Waste Ink is displayed, dispose of ink in the waste ink tanks on the left and right of the machine.

"Waste Ink Tank Replacement"(P. 158)

- 1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.
 - The Maintenance menu is displayed.
- 2 Select [Station Maint.] > [Custody Wash], then press the [ENTER] key.
 - The carriage moves over the platen.
- 3 Open the maintenance cover on the right side.

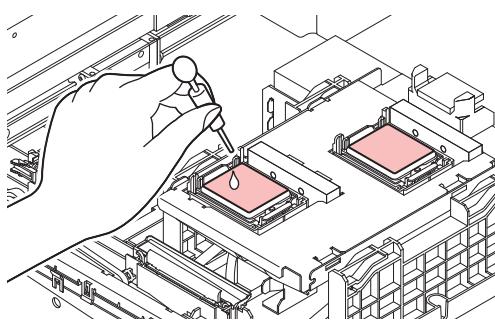


- 4 Clean the cap rubber.
 -  "Cap Rubber Cleaning"(P. 124)
- 5 Once cleaning is complete, close the cover, then press the [ENTER] key.
 - The cap is filled with maintenance liquid.

! • Close the cover. The cap cannot be filled with maintenance liquid while the cover is open.
This is also true if the maintenance liquid cartridge is empty.

- 6 Open the maintenance cover on the right side.
 - Check to confirm that the cap is filled with maintenance liquid.

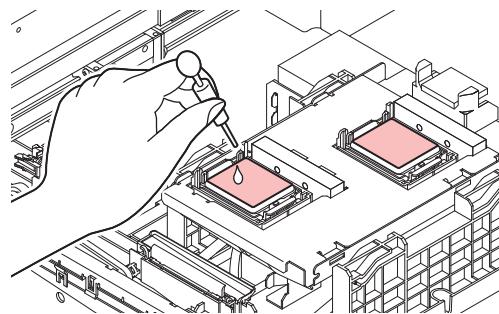
 • If not, use a syringe to draw up some maintenance liquid and fill until it almost overflows from the cap.



- 7 Close the maintenance covers.
- 8 Set the exposure time, then press the [ENTER] key.
 - Cleaning is performed automatically once print nozzle washing has ended.
 - The cap is filled with maintenance liquid.
- 9 Open the maintenance cover on the right side.
 - Check to confirm that there is approximately half a capful of maintenance liquid inside.



- If not, use a syringe to draw up some maintenance liquid and drip in approximately half a capful.



10 Close the maintenance cover, then press the [ENTER] key.

- Pump tube (ink discharge channel below the cap) washing starts.

4.3 Replacement of Consumable Item

To order replacement consumable items, contact your local dealer or our service office. For more information on consumable items, refer to our website (<https://mimaki.com/supply/inkjet.html>).



- Do not store consumable items in locations where children may enter.



- When disposing of consumable items, contact an industrial waste disposal operator or dispose of the product in accordance with the local laws and regulations.

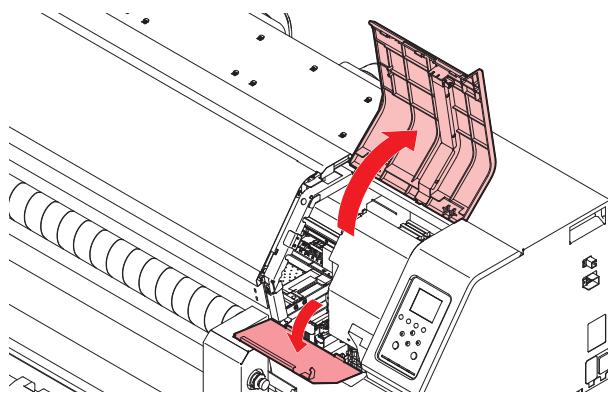
Consumable Item Replacement Timing

Timing	Item
When dirty	"Replacing the Absorber Around the Station"(P. 148) "Wiper Replacement"(P. 143) "Exhaust Fan Filter Replacement"(P. 150) "Blowing Fan Filter Replacement"(P. 150)
When ejection failures cannot be remedied	"Cap Replacement"(P. 146) "Wiper Replacement"(P. 143)
When damaged	"Wiper Replacement"(P. 143) "Cap Replacement"(P. 146) "Pinch Roller Replacement"(P. 151) "Media Holder and Cloth Holder Replacement"(P. 153)
When replacing ink	"Ink Supply Unit Ink Absorber Replacement"(P. 157)
When "Replace Wiper" appears on the display	"Wiper Replacement"(P. 143)
When "Check Waste Ink Tank" appears on the display	"Waste Ink Tank Replacement"(P. 158)
Once a year	"Wiper Cleaner Replacement"(P. 144)

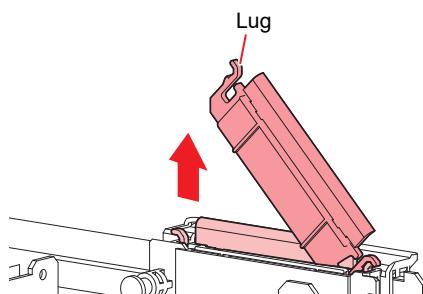
Wiper Replacement

The machine maintains a count of the number of wiping cycles. The "Replace Wiper" message appears when a preset count is reached. Replace dirty or warped wipers with new ones.

- 1** "Replace Wiper" appears on the display.
- 2** On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.
 - The Maintenance menu is displayed.
- 3** Select [Station Maint.] > [Replace Wiper], then press the [ENTER] key.
 - The carriage moves over the platen.
- 4** Open the maintenance cover on the right side.

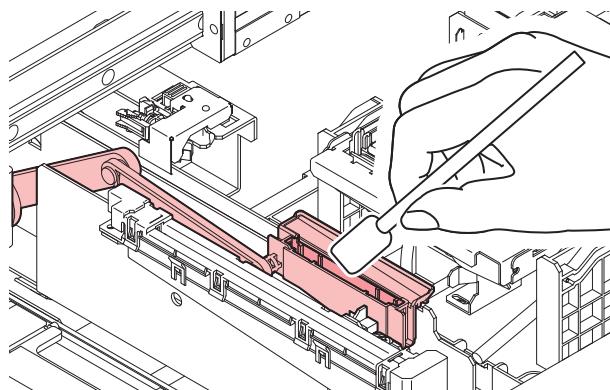
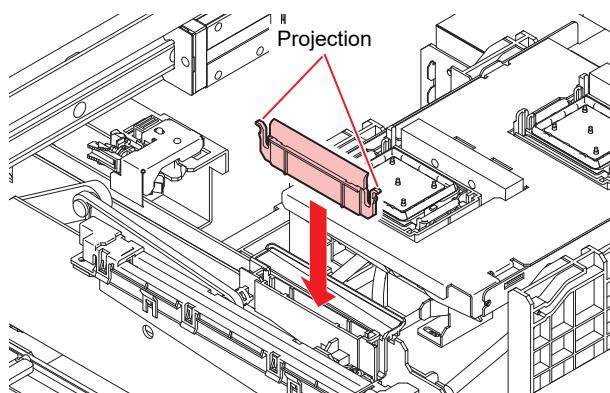


- 5** Remove the wiper.
 - Hold the lug at the rear of the wiper bracket, then pull out the wiper.



6 Clean the wiper slider.

- Wipe off any ink and dust adhering using a cleaning stick moistened with maintenance liquid. Wipe off the maintenance liquid. Make sure none remains.

**7** Mount a new wiper.**8** Once replacement is complete, close the cover, then press the [ENTER] key.

- The wiper usage count is reset.

Wiper Cleaner Replacement

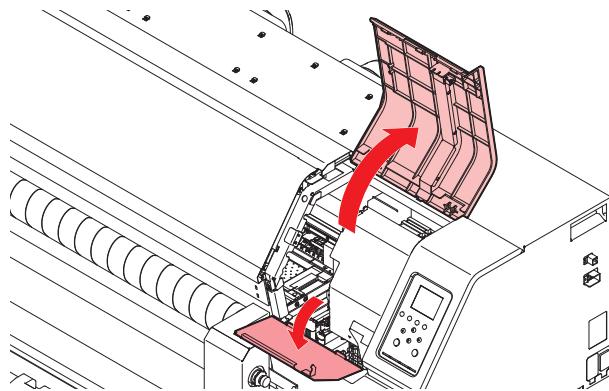
Replace with a new wiper cleaner (SPC-0243) once a year.

1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

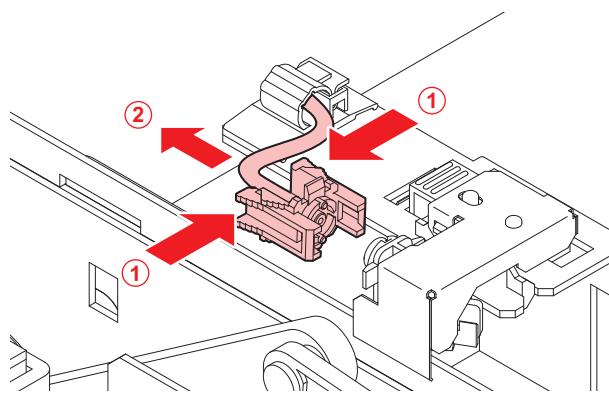
- The Maintenance menu is displayed.

2 Select [Station Maint.] > [Carriage Out] > [Move To Platen Right End], then press the [ENTER] key.

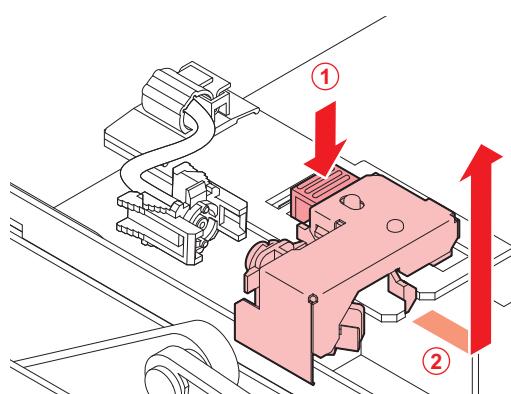
- The carriage moves over the platen.

3 Open the maintenance cover on the right side.**4** Remove the fitting.

- Hold the lugs on the fitting, then pull off.
- Take care to avoid losing the rubber seal.

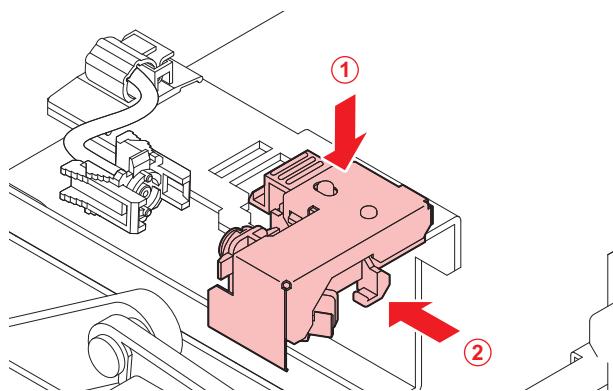
**5** Remove the wiper cleaner.

- Slide forward to remove.

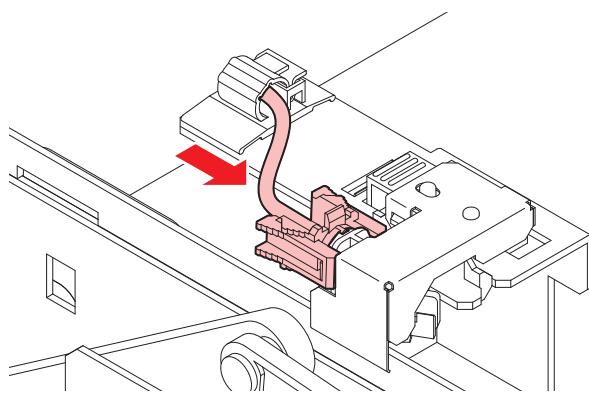


6 Mount a new wiper cleaner.

- Slide to the rear to attach it.

**7** Reattach the fitting.

- Improper attachment may result in leaking maintenance solution.

**8** Once replacement is complete, close the cover, then press the [ENTER] key.**Cap Replacement**

If ejection failures (e.g., nozzle clogging or deflection) remain unresolved even after cleaning, replace with a new cap.

- Be sure to replace the cap if you observe any scratches or other damage on the rim.



- When using Sb or TP ink for extended periods, the cap surface is susceptible to drying out, which can lead to path clogging. If this occurs, either replace the cap or remove and wash it.



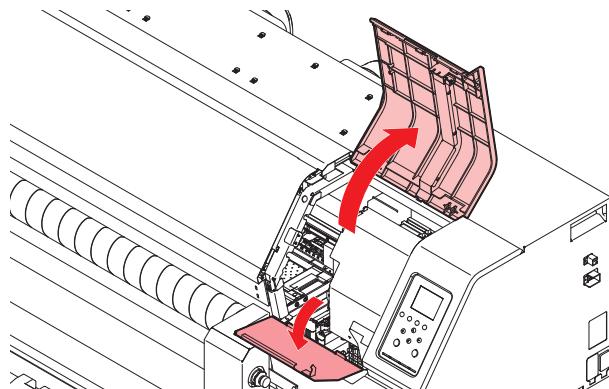
- We recommend replacing the cap every six to twelve months.
(TP ink: every six months, other ink: every twelve months)

1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

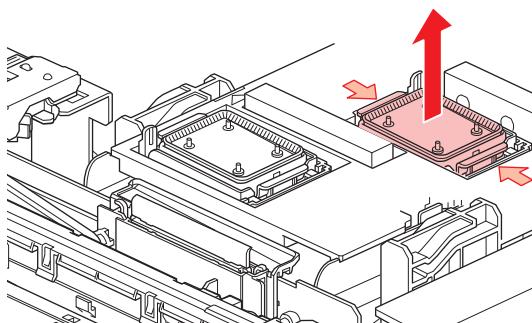
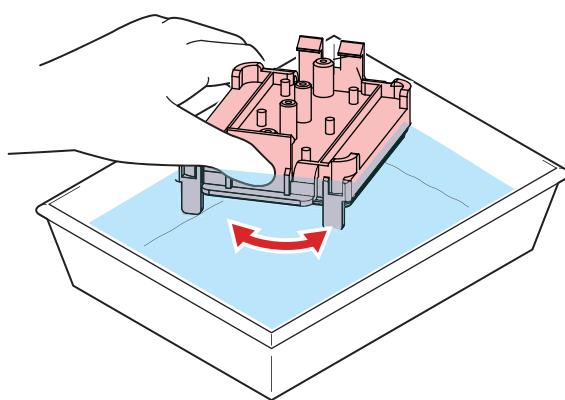
- The Maintenance menu is displayed.

2 Select [Station Maint.] > [Replace Cap], then press the [ENTER] key.

- The carriage moves over the platen.

3 Open the maintenance cover on the right side.**4** Remove the cap.

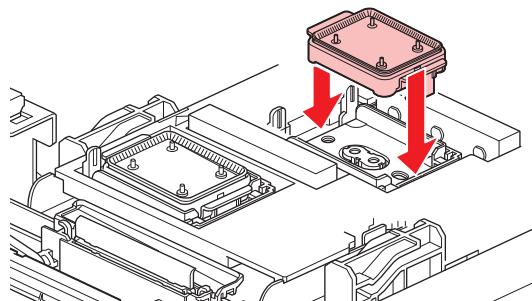
- Squeeze the lugs on either side of the cap and pull off.

**5** [When using Sb ink and TP ink] Rinse the cap with the mesh side facing downward in a container filled with maintenance liquid. Remove, then wipe clean the resin part thoroughly.**6** Apply maintenance liquid.

- Use a syringe to apply two or three drops of maintenance liquid to the hole at the front.

7 Mount a new cap or a cap that has been washed.

- Position with the slot at the front and push in until it clicks.

**8 Once replacement is complete, close the cover, then press the [ENTER] key.****Replacing the Absorber Around the Station**

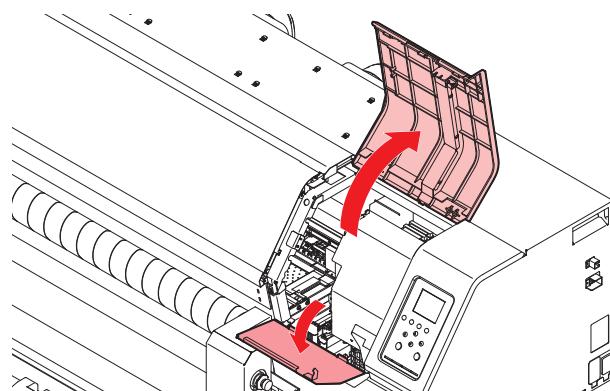
If the cap absorber or maintenance liquid absorber is very dirty or if ink drips on to the media, replace with a new cap absorber.

1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

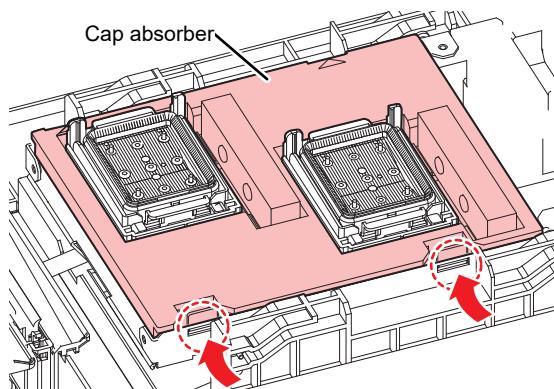
2 Select [Station Maint.] > [Carriage Out] > [Move To Platen Right End], then press the [ENTER] key.

- The carriage moves over the platen.

3 Open the maintenance cover on the right side.

4 Remove the two screws, then remove the cap cover.

- Slide to the rear to detach the tabs at the front.



5 Remove the cap absorber.



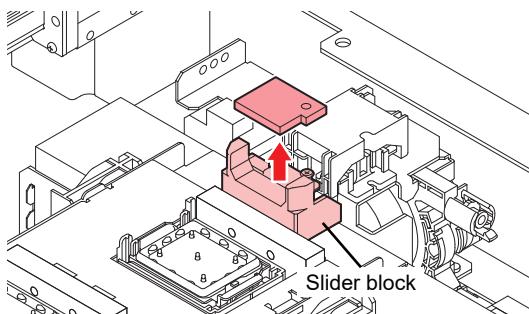
- Avoid ink dripping when removing the cap absorbers.

6 Mount a new cap absorber.



- Insert the tabs on the plate into the slits in the cap absorber.
- Check to confirm that the cap absorber does not become detached.

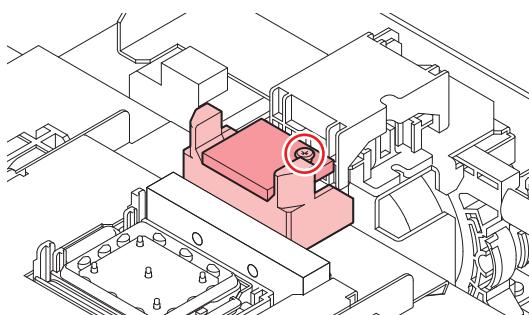
7 Remove the maintenance liquid absorber.



8 Wipe away any maintenance liquid from around the slider block.

9 Mount a new maintenance liquid absorber.

- Push firmly on to the protrusion.



10 Check to confirm that the absorber is not lifting or curved.

11 Insert the two screws to secure the cap cover in place.

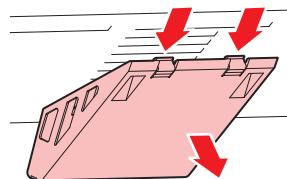
12 Once replacement is complete, close the cover, then press the [ENTER] key.

Exhaust Fan Filter Replacement

Check the exhaust fan filter condition. Replace if very dirty.

1 Remove the exhaust fan box.

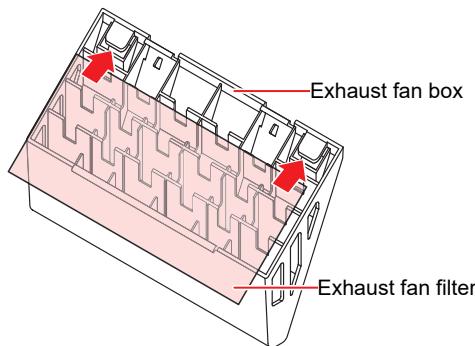
- Push the tabs at the front to remove the exhaust fan box.



- Replace the very dirty exhaust fan box with new one.

2 Mount a new exhaust fan filter in the exhaust fan box.

- Press the exhaust fan filter into the space under the tabs of the exhaust fan box.



3 Mount the exhaust fan box.

- Insert the tabs of the exhaust fan box into the slits of the machine, and clip in the tabs at the front.

Blowing Fan Filter Replacement

Replace the blowing fan filter if it is dirty.

(Important!) If sublimation transfer ink is used

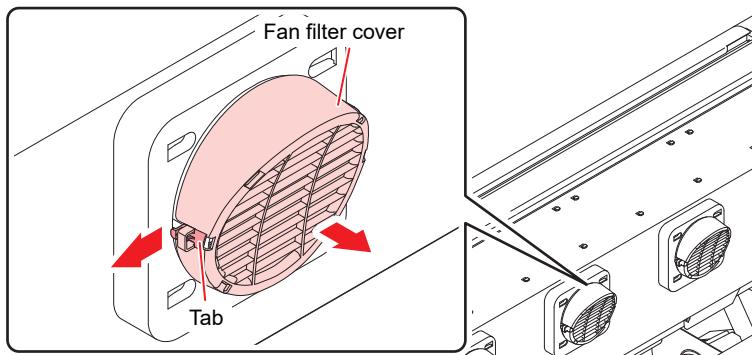
- Replace the filter every three months.

- Turn off the main power and unplug the power cable before replacement.

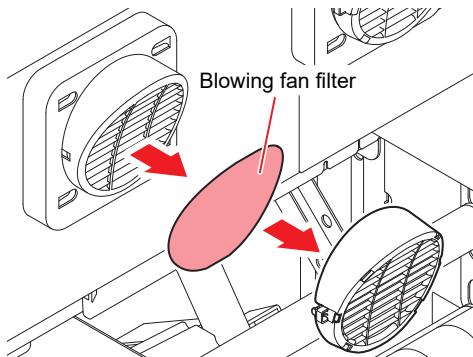


1 Remove the fan filter cover.

- Push the fan filter cover claw outward, and pull the cover to the front.

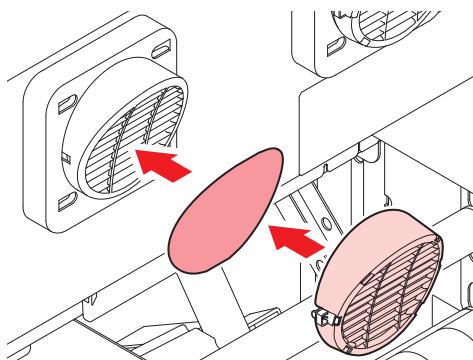


2 Remove the filter.



3 Mount a new filter and the fan filter cover.

- Push in the fan filter cover until the tab clicks.



Pinch Roller Replacement

Replace worn or dirty pinch rollers with new ones.

(Important!) If sublimation transfer ink is used

- Replace the pinch rollers every month if used for approximately 12 hours per day.
- Replace the pinch rollers every two weeks if used 24 hours per day.

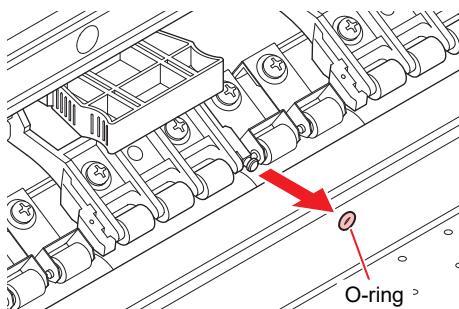
- Turn off the main power and unplug the power cable before replacement.



1 Open the front cover.

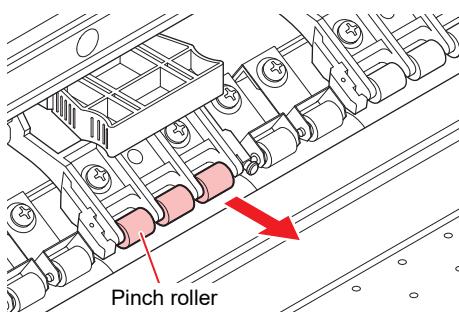
2 Raise the clamp lever.

3 Remove the O-ring retaining the pinch rollers.



- The pinch rollers are small. Be careful to avoid dropping them into the product interior.

4 Remove the pinch rollers or the pinch roller spindle.

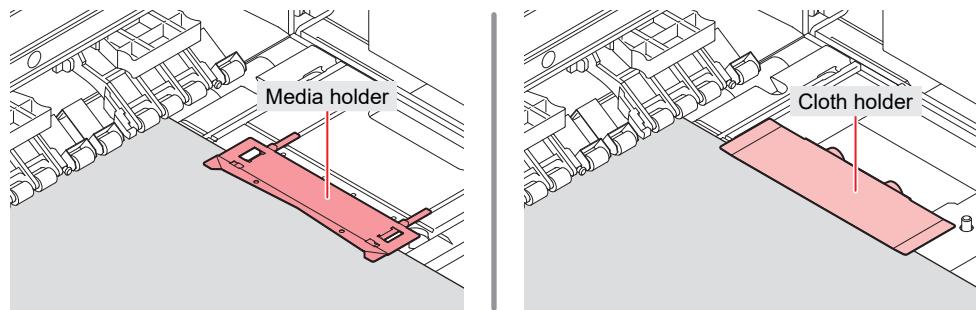


5 Mount new pinch rollers, and secure them using the O-ring.

6 Close the front cover.

Media Holder and Cloth Holder Replacement

If the media holders or cloth holders become deformed and touch the carriage or print head, replace with new media holders or cloth holders.

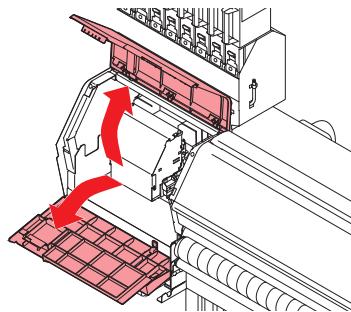


- Turn off the main power and unplug the power cable before replacement.

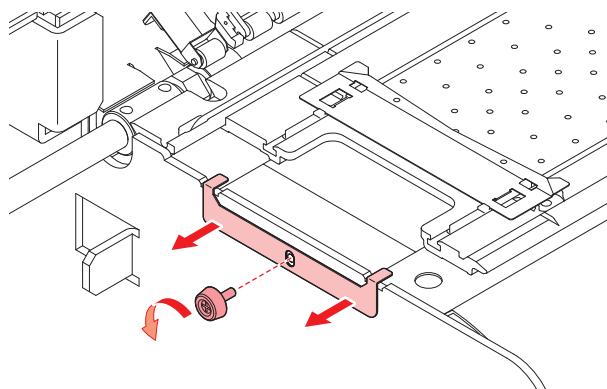
● For media holders

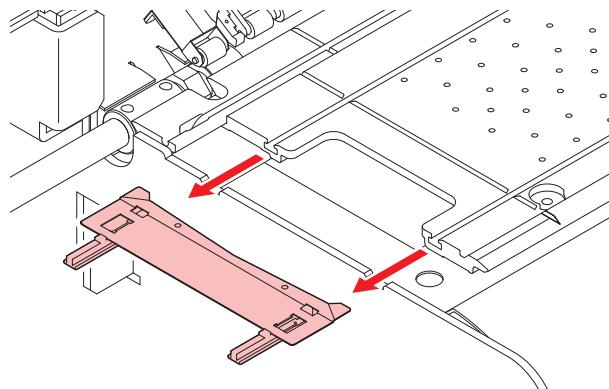
This is the procedure for replacing the left-hand media holder. Replace the right-hand media holder in the same way.

1 Open the maintenance cover on the left side.

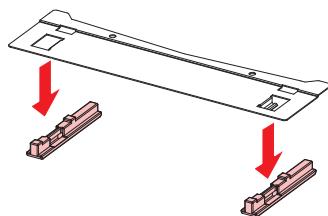


2 Remove the side screw, and detach the media holder stopper.

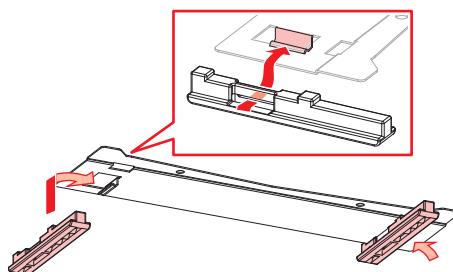
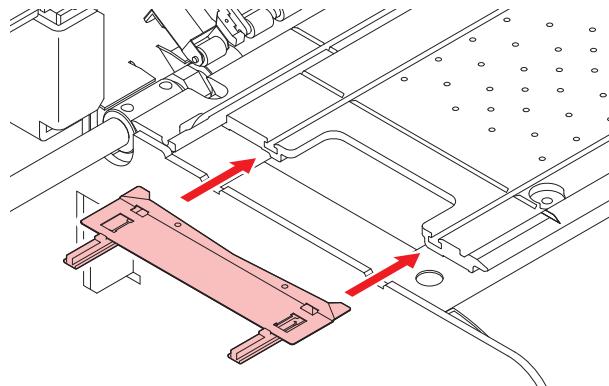


3 Remove the media holder.**4** Remove the sliders from the media holder.

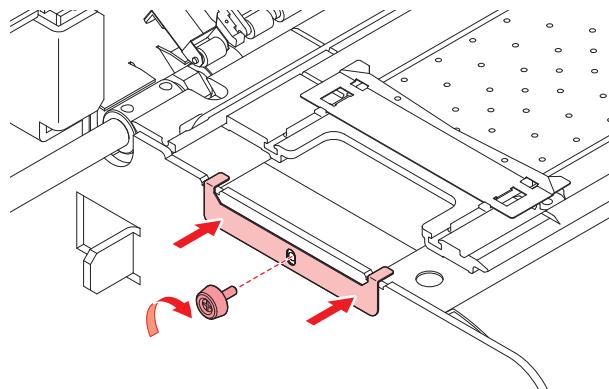
- Be careful to avoid misplacing the sliders.

**5** Mount the sliders on to the new media holder.

- Engage the holes in the sliders on to the lugs on the media holder.

**6** Mount the new media holder on to the platen.

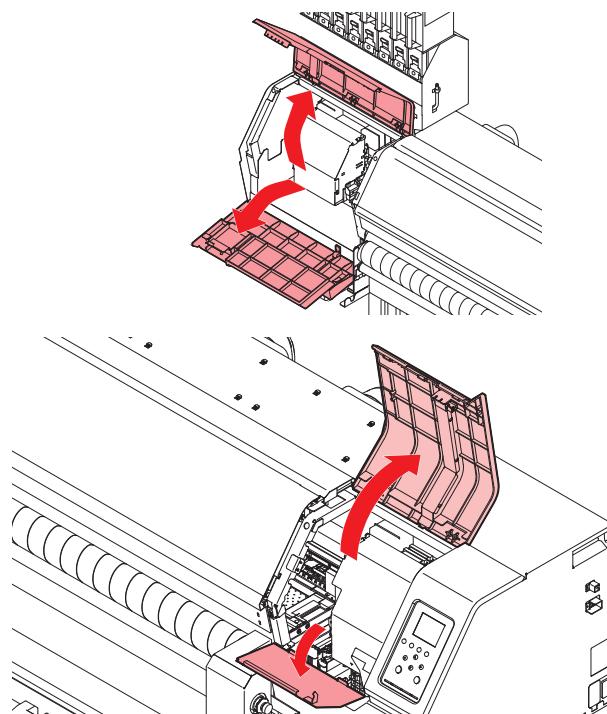
7 Secure the media holder stopper with the screw.



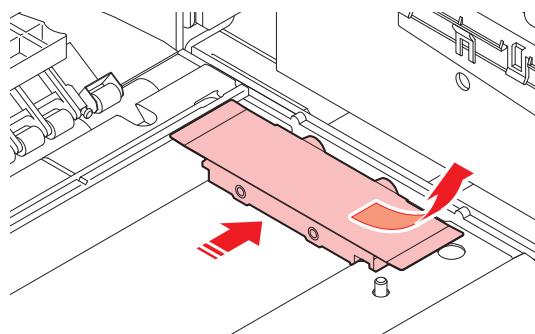
8 Close the maintenance covers.

- For cloth holders

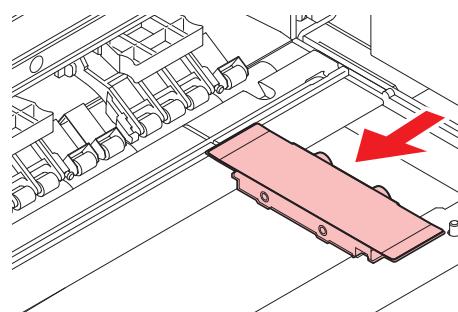
1 Open the left and right maintenance covers.



2 Remove the left and right cloth holders.



3 Mount new cloth holders.



- Note the orientation of the left and right cloth holders. Attach so that the screws are facing outward. Note also that the cloth holders are shaped differently at the front and rear.

4 Close the maintenance covers.

Ink Supply Unit Ink Absorber Replacement

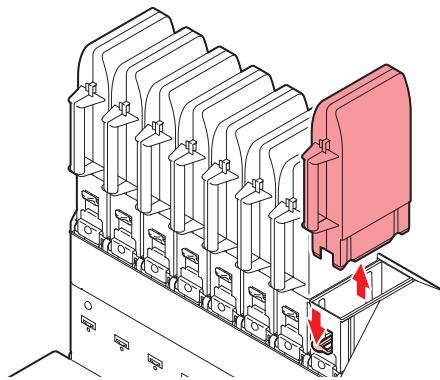
We recommend replacing the ink absorber each time you replace the ink pack, to prevent dirt building up on the pedestal of the ink supply unit.



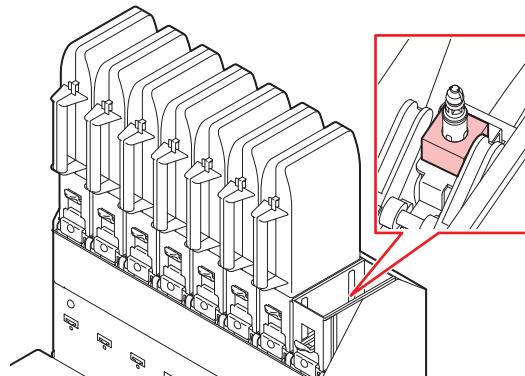
- Pay close attention to ventilation and be sure to wear safety glasses, gloves, and a mask when handling ink, maintenance liquid, waste ink, or other solutions used with the machine. Leaking ink may adhere to the skin or get into the eyes or mouth.



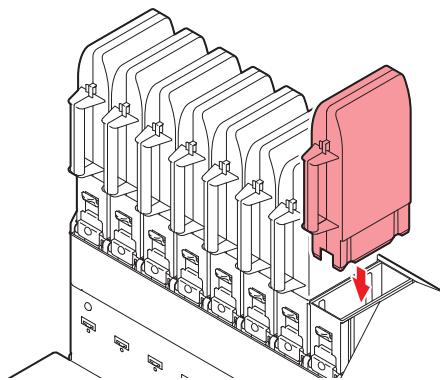
1 Push down the lever on the pedestal, and remove the ink Eco-case.



2 Remove the ink absorber, and replace with a new one.



3 Set an eco-case on the base.



4

Waste Ink Tank Replacement

The ink used in printing and head cleaning is stored in the waste ink tanks on the right and left sides of the machine.



- For a 2-liter tank, the preset level is 80 % (1.6 L).
- Continuing to use the product without disposing of the waste ink may result in waste ink overflowing from the waste ink tank. Visually check ink levels in the waste ink tank about once a week.

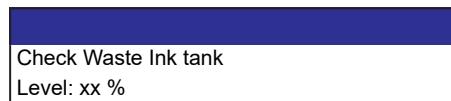


- Pay close attention to ventilation and be sure to wear safety glasses, gloves, and a mask when handling ink, maintenance liquid, waste ink, or other solutions used with the machine. Leaking ink may adhere to the skin or get into the eyes or mouth.



When "Check Waste Ink Tank" message appears

1 The "Check Waste Ink Tank" message appears on the display.



2 Check the waste ink levels in the waste ink tank.

- If you note any discrepancies from actual levels, proceed to the next step.
- If there is no discrepancy, replace (dispose of) the waste ink tank referring to "Replacing the lower-left waste ink tank"(P. 158).

3 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

4 Select [Waste Ink Tank], then press the [ENTER] key.

5 Select [Adjust Waste Ink Volume], then press the [ENTER] key.

6 Press to adjust the level.

7 Press the [ENTER] key once adjustment is complete.

Replacing the lower-left waste ink tank

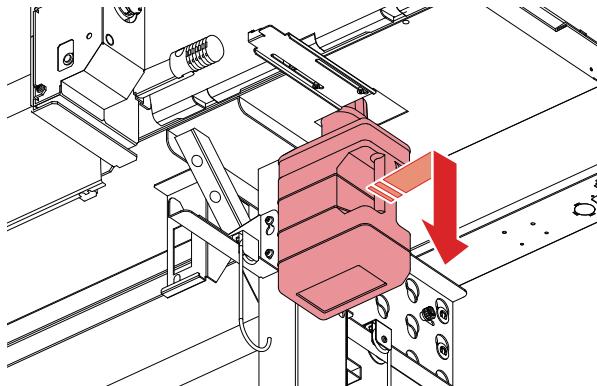
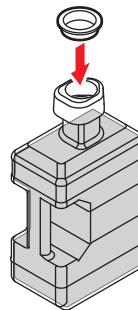
● Lower-right waste ink tank replacement

1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

2 Select [Waste Ink Tank], then press the [ENTER] key.

3 Select [Reset Waste Ink Volume], then press the [ENTER] key.

4 Hold the handle on the waste ink tank and slide out.**5** Attach the cap to the removed waste ink tank, and use tape to prevent leakage of waste ink.

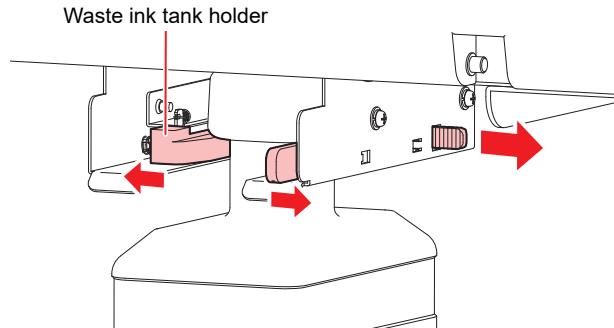
- When disposing of ink, maintenance liquid or other liquid used with the product, or containers or non-woven fabric contaminated with ink or other liquid, contact an industrial waste disposal operator or dispose of the product in accordance with the local laws and regulations.

Replacing the lower-right waste ink tank

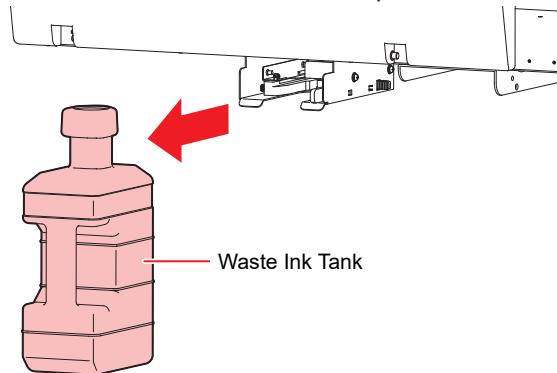
● Lower-right waste ink tank replacement

1 Remove the waste ink tank.

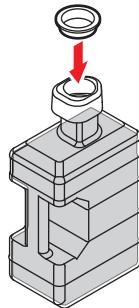
(1) Pull the lug of the waste ink tank holder and push the holder open.



(2) Hold the waste ink tank handle and pull it forward to remove it.

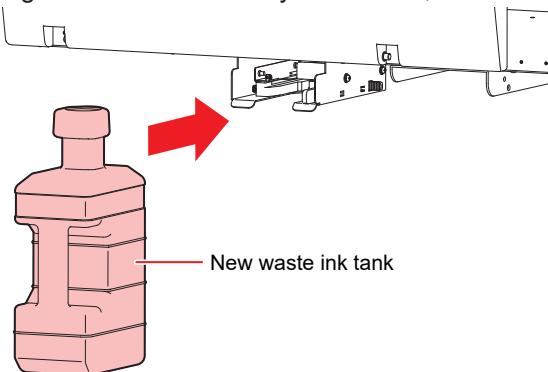


 Put a cap on the removed waste ink tank.



2 Replace the waste ink tank.

- (1) Prepare a new waste ink tank (SPA-0277).
- (2) Holding the waste ink tank by the handle, insert it in the holder.



- When disposing of ink, maintenance liquid or other liquid used with the product, or containers or non-woven fabric contaminated with ink or other liquid, contact an industrial waste disposal operator or dispose of the product in accordance with the local laws and regulations.

Chapter 5 Troubleshooting



This chapter

This chapter describes corrective actions for troubleshooting and messages on the display.

Troubleshooting	164	Problems Causing Messages to Appear	168
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Printing is not possible	164	Ink Error	170
The media jams or the media is dirty	164	Error Message	171
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The ink has leaked out	167		

5.1 Troubleshooting

For information on troubleshooting, refer to this chapter. Refer to our website (<https://mimaki.com/support/>) for frequently asked questions (FAQs) about this product and customer support videos.

If the recommended corrective action does not resolve the problem, contact your local dealer or our service office.

The power does not turn on.

Points to check	Corrective action
Is the power cable connected to the machine?	Insert the power socket until it clicks into place.
Are you using the power cable provided?	Use the power cable provided.
Is the main power supply turned on?	Turn on the main power supply.  "Turning On the Power"(P. 33)
Is the [END/POWER] key on the operating panel turned on?	Turn the power on.  "Turning On the Power"(P. 33)

Printing is not possible.

Points to check	Corrective action
Is a USB interface cable connected?	Connect the cable securely to the USB 2.0 port.  "Using a USB Cable"(P. 37)
Is a LAN cable connected?	Connect the cable securely to the LAN port.  "Using a LAN Cable"(P. 36)
Are you using a LAN cable approved by Mimaki?	Check the LAN cable type.  "Using a LAN Cable"(P. 36)
Is the status lamp on the operating panel illuminated or flashing red?	An error has occurred. Check the message on the display.  "Operating Panel"(P. 30)

The media jams or the media is dirty.

Points to check	Corrective action
Are you using the recommended media?	Make sure you are using the recommended media. https://mimaki.com/supply/inkjet.html
Are you using curled media?	Do not use curled media or media with folded ends.
Is the media skewed?	Use the take-up unit to adjust the media or reload the media.  "Loading the Media"(P. 61)

Points to check	Corrective action
Does the media have ripples/surface irregularities or lift up?	<p>If you are using roll media, use a smooth section of the media for initial feeding. You can also improve this problem by attaching the NITOFLON® tape provided on the platen.</p> <p>For more information, refer to the description on transporting media on the platen. https://mimaki.com/download/inkjet.html</p>

Image defects occur.

Symptom	Corrective action
White streaks, blurriness, and dark streaks occur. (Carriage scan direction)	<ol style="list-style-type: none"> 1. Remove any paper scraps or other debris adhering to areas over which the head passes (e.g., media holders). "Media Holder and Cloth Holder Cleaning"(P. 132) "Platen and Platen Wire Cleaning"(P. 135) 2. Perform the procedure described in "Head Cleaning"(P. 96). 3. Perform the procedure described in "Feed Correction"(P. 97). 4. Perform the procedure described in "Cap Rubber Cleaning"(P. 124). 5. Perform the procedure described in "Carriage Underside Cleaning"(P. 125).
Text is double- or triple-printed in the media feed direction.	<ol style="list-style-type: none"> 1. Perform the procedure described in "Feed Correction"(P. 97).
Offsetting occurs during bidirectional printing.	<ol style="list-style-type: none"> 1. Perform the procedure described in "Correcting the Drop Position"(P. 99).
Ink droplets drip during printing.	<ol style="list-style-type: none"> 1. Perform the procedure described in "Cap Rubber Cleaning"(P. 124). 2. Perform the procedure described in "Carriage Underside Cleaning"(P. 125). 3. Perform the procedure described in "Head Cleaning"(P. 96). 4. Set auto maintenance. "Maintenance Menu"(P. 111)
Nozzles are clogged.	<ol style="list-style-type: none"> 1. Perform the procedure described in "Head Cleaning"(P. 96). 2. Perform the procedure described in "Print Head Nozzle Washing"(P. 166). 3. Perform the procedure described in "Registering Nozzle Recovery"(P. 114).
Are the print heads too high?	<p>Adjust the print head height. "Adjusting Print Head Height"(P. 56)</p> <p>If the print heads cannot be lowered, increase the refresh level of maintenance during printing ("Maintenance Menu"(P. 111)) to Standard or Strong and perform regular test printing to check for nozzle clogging.</p>
Are there any ink colors that aren't used much?	<p>Discharge from infrequently used nozzles tends not to be consistent. Although increasing the refresh level of maintenance during printing ("Maintenance Menu"(P. 111)) to Standard or Strong will enable more frequent nozzle use, note that this will also increase ink consumption.</p>

Symptom	Corrective action
Are you using media easily affected by static electricity?	Increase the refresh level of maintenance during printing (☞ "Maintenance Menu"(P. 111)) to Standard or Strong and perform regular test printing to check for nozzle clogging.
Is the machine installed in a location with low humidity?	Increase the humidity by installing a humidifier or similar equipment. When printing continuously, also increase the refresh level of maintenance during printing (☞ "Maintenance Menu"(P. 111)) to Standard or Strong and perform regular test printing to check for nozzle clogging.
Is the machine installed in a location where dust or powder is present?	Install the machine in a location free of dust or powder (office equivalent: dust level 0.15 mg/m ³).

Print Head Nozzle Washing

If ejection failures (e.g., nozzle clogging or deflection) remain unresolved even after head cleaning (☞ "Head Cleaning"(P. 96)), apply nozzle wash to the print head.

1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

2 Select [Station Maint.] > [Nozzle Wash], then press the [ENTER] key.

- The carriage moves over the platen.

3 Open the maintenance cover on the right side.

4 Clean the cap rubber.

- ☞ "Cap Rubber Cleaning"(P. 124)

5 Once cleaning is complete, close the cover, then press the [ENTER] key.

- The cap is filled with maintenance liquid.



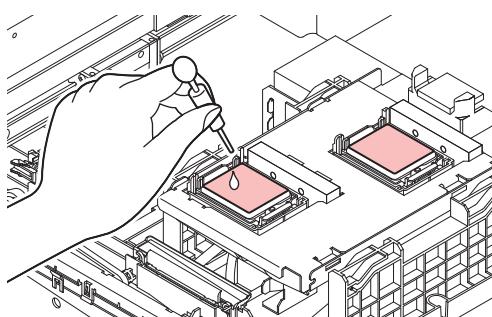
- Close the cover. The cap cannot be filled with maintenance liquid while the cover is open. This is also true if the maintenance liquid cartridge is empty.

6 Open the maintenance cover on the right side.

- Check to confirm that the cap is filled with maintenance liquid.



- If not, use a syringe to draw up some maintenance liquid and fill until it almost overflows from the cap.



7 Close the maintenance covers.

8 Set the exposure time, then press the [ENTER] key.

- Cleaning is performed automatically once print nozzle washing has ended.



- If ejection failures (e.g., nozzle clogging or deflection) remain unresolved even after washing the nozzles several times, contact your local dealer or our service office.

The ink has leaked out

- If an ink leak occurs, turn off the main power immediately and unplug the power cable. Then, contact your local dealer or our service office.

5.2 Problems Causing Messages to Appear

If a problem arises, the buzzer sounds and a message appears on the display.

You can also check the local guidance.  "Displaying Machine Information (Local Guidance)"(P. 32)

Take the appropriate action in accordance with the content of the message. If a message reappears even after taking the prescribed action, contact your local dealer or our service office.

Warning Messages

Message	Cause	Corrective action
Replace NCU Ink Pad	<ul style="list-style-type: none"> The ink absorber needs to be replaced. 	<ul style="list-style-type: none"> The NCU ink absorber must be replaced. Contact your local dealer or our service office.
Replace NCU	<ul style="list-style-type: none"> A problem was detected with the nozzle clogging assessment. 	<ul style="list-style-type: none"> Clean the NCU.  "NCU Cleaning"(P. 128) Replace the NCU if the error does not clear. Contact your local dealer or our service office.
NCU Sensor Lv Low	<ul style="list-style-type: none"> The sensor's sensitivity is impaired. 	
NCU Sens Adj Err H	<ul style="list-style-type: none"> Sensor sensitivity adjustment failed. 	
NCU Sens Adj Err L		
NCU Connect	<ul style="list-style-type: none"> A problem was detected with the NCU connection. 	<ul style="list-style-type: none"> Turn off the main power and wait a while before turning back on.
Ink Error	<ul style="list-style-type: none"> An ink error occurred. 	<ul style="list-style-type: none"> Check the ink error details.  "Ink Error"(P. 170)
COVER OPEN	<ul style="list-style-type: none"> The cover is open. 	<ul style="list-style-type: none"> Close the cover.
Lower the clamp lever	<ul style="list-style-type: none"> The clamp lever is raised. 	<ul style="list-style-type: none"> Lower the clamp lever.  "Front"(P. 22)
Data Remain	<ul style="list-style-type: none"> Print (RIP) data was received. 	<ul style="list-style-type: none"> Switch to REMOTE mode and start printing or clear the data and abort printing.
Temporary Suspension	<ul style="list-style-type: none"> Printing has been paused. 	<ul style="list-style-type: none"> Switch to REMOTE mode and resume printing or clear the data and abort printing.
Printing not possible/ink IC	<ul style="list-style-type: none"> An unusable ink IC chip is used. 	<ul style="list-style-type: none"> Replace with new ink and a new ink IC chip.  "Replacing Ink"(P. 42)
Cap Replacement	<ul style="list-style-type: none"> The cap usage count has exceeded the specified amount. 	<ul style="list-style-type: none"> Replace the cap.  "Cap Replacement"(P. 146)
Replace Wiper	<ul style="list-style-type: none"> The wiping count has exceeded the specified amount. 	<ul style="list-style-type: none"> Replace the wiper.  "Wiper Replacement"(P. 143)
No Media	<ul style="list-style-type: none"> No media is loaded, or the sensors are faulty. 	<ul style="list-style-type: none"> Load the media.  "Loading the Media"(P. 61) Clean the media sensor.  "Media Sensor Cleaning"(P. 132)

Message	Cause	Corrective action
Please load media		<ul style="list-style-type: none"> Load the media.  "Loading the Media"(P. 61)
Media Undetected	<ul style="list-style-type: none"> The media width has not been detected. 	<ul style="list-style-type: none"> Detect the media width.  "Loading the Media"(P. 61)
Wiper Move Failure	<ul style="list-style-type: none"> The wiper is not operating correctly. 	<ol style="list-style-type: none"> Clean the wiper and around the wiper.  "Wiper Cleaning"(P. 126) Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
Replace Wasteinktank	<ul style="list-style-type: none"> The waste ink tank count exceeded the specified value (90%), disabling the automatic maintenance function. 	<ol style="list-style-type: none"> Check the waste ink levels in the waste ink tank.  "When 'Check Waste Ink Tank' message appears"(P. 158) Replace the waste ink tank, then reset the waste ink level.  "Replacing the lower-left waste ink tank"(P. 158)
Check Waste Ink tank	<ul style="list-style-type: none"> The waste ink tank count exceeded the preset value (80%). 	
WashLiquidCart.None	<ul style="list-style-type: none"> No maintenance liquid cartridge is loaded. 	<ul style="list-style-type: none"> Load the maintenance liquid cartridge.
Please replace wash liquid cartridge	<ul style="list-style-type: none"> The maintenance liquid has run out. 	<ul style="list-style-type: none"> Replace with a new maintenance liquid cartridge.
Washing liquid end		
High ambient temp ** ° C	<ul style="list-style-type: none"> Ambient temperatures are too high. 	<ul style="list-style-type: none"> Adjust ambient temperatures to temperatures within the specified range. Optimum print quality may not be possible unless ambient conditions are within the specified range.  "Installation Precautions"(P. 16)
Low ambient temp ** ° C	<ul style="list-style-type: none"> Ambient temperatures are too low. 	
Auto-correction failed	<ul style="list-style-type: none"> White media is not used. The media is dirty. The media lifts up. There is dirt around the sensor. 	<ul style="list-style-type: none"> Load white and clean media. Load media so it does not lift up. Clean the area around the sensor.  "DAS (Automatic Correction Function) Sensor Cleaning"(P. 129) If automatic correction fails repeatedly, correct the position manually.  "Feed Correction"(P. 97)  "Correcting the Drop Position"(P. 99)
Take-Up LimitDetect	<ul style="list-style-type: none"> The take-up tension bar was detected at the upper limit position. 	<ul style="list-style-type: none"> Lower the take-up tension bar.
Feeding LimitDetect	<ul style="list-style-type: none"> The feeding tension bar was detected at the upper limit position. 	<ul style="list-style-type: none"> Lower the feeding tension bar.
Take-up Wrong	<ul style="list-style-type: none"> The take-up tension bar has not moved from the lower limit position. 	<ul style="list-style-type: none"> Press  to feed the media and confirm that the take-up unit operates correctly.
Feeding Wrong	<ul style="list-style-type: none"> The feeding tension bar has not moved from the lower limit position. 	<ul style="list-style-type: none"> Press  to feed the media and confirm that the feeding unit operates correctly.
No Platen	<ul style="list-style-type: none"> No platens are mounted on the machine. 	<ul style="list-style-type: none"> Attach the platens, then print.  "Platen"(P. 26)

Message	Cause	Corrective action
Check Direct-Connection Unit	<ul style="list-style-type: none"> Installation of the direct-connection unit/torque limiter does not match the tension bar setting. 	<ul style="list-style-type: none"> When using tension bars, attach a direct-connection unit, or otherwise attach a torque limiter.

Ink Error

Message	Cause	Corrective action
Ink End	<ul style="list-style-type: none"> The ink has run out. 	<ul style="list-style-type: none"> Replace with new ink.  "When Ink End is Displayed"(P. 41) If you use UISS, you may perform cleaning.
Ink Near End	<ul style="list-style-type: none"> Ink levels are low. 	<ul style="list-style-type: none"> The ink will run out soon. Have new ink ready.  "When Ink Near End is Displayed"(P. 41)
Non Ink IC	<ul style="list-style-type: none"> No ink IC chip was detected. 	<ol style="list-style-type: none"> Insert the ink IC chip.  "Replacing Ink"(P. 42) Check to confirm the ink IC chip was inserted correctly.  "Mounting the ink"(P. 45) Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
Wrong Ink IC	<ul style="list-style-type: none"> An error occurred with the information on the ink IC chip. 	<ol style="list-style-type: none"> Check to confirm the ink IC chip was inserted correctly.  "Mounting the ink"(P. 45) Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34) Replace with new ink.  "Replacing Ink"(P. 42)
Ink Color	<ul style="list-style-type: none"> The ink color registered on the IC chip is different from the ink color filled. 	<ul style="list-style-type: none"> Insert an ink IC chip for the correct ink color.  "Mounting the ink"(P. 45)
Ink Type	<ul style="list-style-type: none"> The ink type registered on the IC chip is different from the ink type filled. 	<ul style="list-style-type: none"> Insert an ink IC chip for the correct ink type.  "Mounting the ink"(P. 45)
Expiration Near	<ul style="list-style-type: none"> The ink has expired. The ink is one month past its expiration date. 	<ul style="list-style-type: none"> Replace with new ink or use up as quickly as possible. Printing is possible.  "When Ink End is Displayed"(P. 41)
Expiration Over	<ul style="list-style-type: none"> The ink is two months past its expiration date and cannot be used. 	<ul style="list-style-type: none"> Replace with new ink. Printing is not possible.  "When Ink End is Displayed"(P. 41)

Error Message

Error number	Message	Cause	Corrective action
04	PARAM ROM	• A problem was detected with the main PCB.	
108	HD CONNECT[12]	• A problem was detected with the print head connection.	
108	HD MEM EMP[12]	• A problem was detected with the print head.	
10e	FROM CLEAR	• A problem was detected with the main PCB.	
10f	FROM WRITE		
115	PCB MAIN-F1		
122	CHECK:SDRAM	• A problem was detected with the SDRAM.	
122	PRAM NONE		
123	PRAM DATA	• A problem was detected with the main PCB.	
124	PRAM ADDR		
127	POWER OFF		
128	HDC FIFO OVER / HDC FIFO UNDER	• A problem was detected with the print head control PCB.	
129	Battery Exchange	• The internal clock battery is spent and must be replaced.	• Contact your local dealer or our service office.
12a	HDC SPEED	• A problem was detected with the print head control.	
12d	PCB MAIN-F4	• A problem was detected with the main PCB.	
130	HD DATA SEQ	• A problem was detected with the print head control.	
147	DS-IC BUSY	• Ink IC control abnormality detected.	
148	E-LOG SEQ	• A log control abnormality was detected.	
151	Main PCB V1R2	• A problem was detected with the main PCB power supply circuit.	
152	Main PCB V2R5		
153	Main PCB V3R3		
154	Main PCB V05		
155	Main PCB V42-1		
15f	HEAD DRIVE HOT	• The HDCE PCB COM driver is hot.	
171	NEW HEAD CONNECT	• A new print head connection was detected.	
186	HDC OVERFLOW/HDC UNDERFLOW	• A problem was detected with the print head control.	

Error number	Message	Cause	Corrective action
187	HDC SLEW RATE		
188	HDC MEMORY		
18c	Main PCB V12	<ul style="list-style-type: none"> A problem was detected with the main PCB power supply circuit. 	
18e	FLS NOT COMP	<ul style="list-style-type: none"> A problem was detected with the print head control. 	
18f	OFFSET START / END [12]	<ul style="list-style-type: none"> A problem was detected with the print head control. 	
1b5	SLIDER CONNECT	<ul style="list-style-type: none"> The HDCE PCB could not be detected. 	<ul style="list-style-type: none"> Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
1bf	PCB MAIN-F2	<ul style="list-style-type: none"> A problem was detected with the main PCB. 	
1d8	HEAD XHOT[12]	<ul style="list-style-type: none"> A problem was detected with the print head. 	
1e6	PRAM Size Shortage	<ul style="list-style-type: none"> Insufficient memory 	
201	Command Error	<ul style="list-style-type: none"> Data other than print (RIP) data was received, or a problem was detected with the print (RIP) data received. 	<ol style="list-style-type: none"> Clear the data and resend. Check the USB/Ether cable connection.  "Connecting a PC to the Product"(P. 36) Use a compatible cable.  "Connecting a PC to the Product"(P. 36) Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
202	Parameter Error	<ul style="list-style-type: none"> A problem was detected with the print (RIP) data received. 	
206	Print Mode Error	<ul style="list-style-type: none"> Print (RIP) data was received with print parameters that do not allow printing. 	<ul style="list-style-type: none"> Change the output parameters and profile using RIP software.
20A	Driver Version	<ul style="list-style-type: none"> Printing is not possible because the Mimaki driver version is old. 	<ul style="list-style-type: none"> Install the latest Mimaki driver available from: https://mimaki.com/download/inkjet.html
303	PCB MAIN ET	<ul style="list-style-type: none"> A problem was detected with the main PCB. 	<ul style="list-style-type: none"> Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
304	USB INIT ERR	<ul style="list-style-type: none"> A problem was detected with the USB cable connection. 	<ol style="list-style-type: none"> Check the USB cable connection.  "Using a USB Cable"(P. 37) Use a compatible cable.  "Using a USB Cable"(P. 37) Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
305	USB TIME OUT		
318	SDcard Connection ERR	<ul style="list-style-type: none"> A problem was detected with the SD card. 	<ol style="list-style-type: none"> Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
401	Motor X	<ul style="list-style-type: none"> The X motor was overloaded. 	<ol style="list-style-type: none"> Check to confirm the media is loaded correctly.  "Loading the Media"(P. 61)
402	Motor Y	<ul style="list-style-type: none"> The Y motor was overloaded. 	

Error number	Message	Cause	Corrective action
403	X Current	• An overcurrent error was detected in the X motor.	2. Open the front cover and check for anything that may obstruct carriage movement. 3. Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
404	Y Current	• An overcurrent error was detected in the Y motor.	
406	Wiper Move Failure	• The wiper origin could not be detected.	1. Clean the wiper and around the wiper.  "Wiper Cleaning"(P. 126) 2. Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
423	Take-up tension bar	• Take-up tension bar position initialization failed.	1. Lower the take-up tension bar. 2. Check which way the take-up unit rotation direction switch is set.  "Take-up unit"(P. 62) 3. Check to confirm the media is loaded correctly.
424	Feed tension bar	• Feeding tension bar position initialization failed.	1. Lower the feeding tension bar. 2. Check which way the feeding unit rotation direction switch is set.  "Feeding unit"(P. 70) 3. Check to confirm the media is loaded correctly.
425	Take-up Wrong	• The take-up tension bar has not moved from the lower limit position.	1. Check which way the take-up unit rotation direction switch is set. 2. Check to confirm the media is loaded correctly.
426	Feeding Wrong	• The feeding tension bar has not moved from the lower limit position.	1. Check which way the feeding unit rotation direction switch is set. 2. Check to confirm the media is loaded correctly.
429	Take-Up LimitDetect	• The take-up tension bar was detected at the upper limit position.	1. Lower the take-up tension bar. 2. Check which way the take-up unit rotation direction switch is set.  "Take-up unit"(P. 62) 3. Check to confirm the media is loaded correctly.
42a	Feeding LimitDetect	• The feeding tension bar was detected at the upper limit position.	1. Lower the feeding tension bar. 2. Check which way the feeding unit rotation direction switch is set.  "Feeding unit"(P. 70) 3. Check to confirm the media is loaded correctly.
44f	Take-up Roll Sns Err	• A problem was detected with the take-up unit sensor spindle.	1. Check to confirm the [Function Setting] > [Option Roll Unit Select] > [Take-up Unit] setting is "ON".  "Function Setting Menu"(P. 116) 2. Check to confirm the media is loaded correctly.  "Loading Rolls of Cloth Media"(P. 71) 3. Check to confirm the take-up unit switch functions properly.  "Take-up unit"(P. 62)

Error number	Message	Cause	Corrective action
450	Feeding Roll Sns Err	<ul style="list-style-type: none"> A problem was detected with the feeding unit sensor spindle. 	<ol style="list-style-type: none"> Check to confirm the [Function Setting] > [Option Roll Unit Select] > [Feeding Unit] setting is "ON".  "Function Setting Menu"(P. 116) Check to confirm the media is loaded correctly.  "Loading Rolls of Cloth Media"(P. 71) Check to confirm the feeding unit switch functions properly.  "Feeding unit"(P. 70)
48b	Y MOTOR COM	<ul style="list-style-type: none"> Y motor communication is not possible. 	<ul style="list-style-type: none"> Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
48c	Y MTR I2C COM	<ul style="list-style-type: none"> Y motor communication is not possible at startup. 	
496	Y MOTOR DIR	<ul style="list-style-type: none"> The Y motor operating direction cannot be specified. 	<ul style="list-style-type: none"> Lower the clamp lever.
504	CLAMP UP	<ul style="list-style-type: none"> The clamp lever is lifted. 	
505	Media Jam	<ul style="list-style-type: none"> The media jam sensor was triggered. 	<ol style="list-style-type: none"> Remove the media in contact with the carriage and reload with fresh media.  "Loading the Media"(P. 61) Open the front cover and check for anything that may obstruct carriage movement.
507	HEADHEIGHT ERR	<ul style="list-style-type: none"> A problem was detected in head height (Low to High) acquisition. 	<ul style="list-style-type: none"> Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
509	HDC POSCNT	<ul style="list-style-type: none"> A problem was detected with position control. 	<ul style="list-style-type: none"> Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
50a	Y Org Detect Error	<ul style="list-style-type: none"> A problem was detected with Y origin detection (initialization). 	
50c	Check Media With Sensor	<ul style="list-style-type: none"> A problem was detected with media width detection. 	<ol style="list-style-type: none"> Check the media loading position.  "Loading the Media"(P. 61) Clean the media width sensor.  "Media Sensor Cleaning"(P. 132)
50f	L-SCALE BLACK	<ul style="list-style-type: none"> A problem was detected with the linear scale. 	<ul style="list-style-type: none"> Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
516	Media Set Position R (L)	<ul style="list-style-type: none"> The media was loaded outside the range of valid positions. 	<ol style="list-style-type: none"> Check the media loading position.  "Loading the Media"(P. 61) Clean the media width sensor.  "Media Sensor Cleaning"(P. 132)
530	Station Origin	<ul style="list-style-type: none"> The station control origin is not set. 	<ul style="list-style-type: none"> Contact your local dealer or our service office.
54c	Vacuum Fan Err	<ul style="list-style-type: none"> A problem was detected with the vacuum fan. 	<ul style="list-style-type: none"> Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
54d	HDCE Cooling Fan Err	<ul style="list-style-type: none"> An HDCE cooling fan rotation abnormality was detected. 	

Error number	Message	Cause	Corrective action
602	Ink End	<ul style="list-style-type: none"> The ink has run out. 	<ul style="list-style-type: none"> Replace with new ink.  "When Ink End is Displayed"(P. 41)
608	Wrong Ink IC	<ul style="list-style-type: none"> An error occurred with the information on the ink IC chip. 	<ol style="list-style-type: none"> Check to confirm the ink IC chip was inserted correctly.  "Mounting the ink"(P. 45) Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34) Replace with new ink.  "Replacing Ink"(P. 42)
60a	Excess Ink Usage	<ul style="list-style-type: none"> The ink usage amount stored in the ink IC chip exceeded the preset value. The ink IC chip was not replaced during ink replacement. (The same chip continued to be used.) 	<ul style="list-style-type: none"> Replace with new ink.  "When Ink End is Displayed"(P. 41)
60c	Ink Type	<ul style="list-style-type: none"> The ink type registered on the IC chip is different from the ink type filled. 	<ul style="list-style-type: none"> Insert an ink IC chip for the correct ink type.  "Mounting the ink"(P. 45)
629	Expiration Near	<ul style="list-style-type: none"> The ink has expired. The ink is one month past its expiration date. 	<ul style="list-style-type: none"> Replace with new ink or use up as quickly as possible. Printing is possible.  "When Ink End is Displayed"(P. 41)
62a	Expiration Over	<ul style="list-style-type: none"> The ink is two months past its expiration date and cannot be used. 	<ul style="list-style-type: none"> Replace with new ink. Printing is not possible.  "When Ink End is Displayed"(P. 41)
631	Ink Color	<ul style="list-style-type: none"> The ink color registered on the IC chip is different from the ink color filled. 	<ul style="list-style-type: none"> Insert an ink IC chip for the correct ink color.  "Mounting the ink"(P. 45)
637	INK LEAK _	<ul style="list-style-type: none"> The ink leak sensor detected an ink leak. 	<ul style="list-style-type: none"> Contact your local dealer or our service office.
801	(C) OPCODE	<ul style="list-style-type: none"> A problem was detected with the main PCB. 	<ul style="list-style-type: none"> Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
802	(C) SWI		
803	(C)PFTCHABRT		
804	(C)DATAABRT		
806	FW/SIO bit	<ul style="list-style-type: none"> A communication error was detected between the boards. 	
808	FW/STP-MTR**	<ul style="list-style-type: none"> A problem was detected with the main PCB. 	
80f	FW/SIO Vch	<ul style="list-style-type: none"> A communication error was detected between the boards. 	
811	FW/SIO read ****	<ul style="list-style-type: none"> A communication error was detected between the boards. 	

Error number	Message	Cause	Corrective action
81b	FW/STACK OV	• A problem was detected with the main PCB.	
828	PRG ERR L*****		
901	Operation Error	• The function is disabled due to an error.	• Check the error details.
902	Data Remain	• Print (RIP) data was received.	• Switch to REMOTE mode and start printing or clear the data and abort printing.
90f	Print Area Short	• The media is too small for the print.	• Replace with wider or longer media. • If the printable area is reduced due to a shift in the origin, move the origin to increase the size of the printable area.
b1a	PCB BaselIO1	• A communication error was detected between the boards.	• Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
b1b	BaselIO PCB Vpow-s	• A problem was detected with the Base IO PCB power supply.	
b1c	BaselIO PCB V24		
b1e	PCB BaselIO-F**	• The Base IO PCB fuse blow was detected.	• The fuse must be replaced. Contact your local dealer or our service office.
b36	PCB INKIO	• A communication error was detected between the boards.	• Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
b3f	BaselIO Unconform	• The PCB could not be detected.	
b48	PCB HDCE*	• A communication error was detected between the boards.	
b49	PCB HDCE-VHVFET[12]	• A problem was detected with the HDCE PCB power supply.	
b4a	PCB HDCE*-F*	• A blown fuse on the HDCE PCB was detected.	• Contact your local dealer or our service office.
b4b	HDCE* PCB V1R2	• A problem was detected with the HDCE PCB power supply.	• Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34)
b4c	HDCE* PCB V2R5		
b4d	HDCE* PCB V3R3		
b51	BaselIO PCB V24adj	• A problem was detected with the Base IO PCB power supply.	
d1b	COM VOLT[12]	• A problem was detected with the HDCE PCB voltage.	

SYSTEM HALT



- If a SYSTEM HALT number is displayed, turn off the main power and wait a while before turning back on.

Chapter 6 Appendix



This chapter

This chapter describes the machine specifications.

Specifications	180	Options	183
		Relay Box	183

6.1 Specifications

Item		Tx330-1800
Print head	Type	On-demand piezo head
	Specifications	Two staggered heads with 400 nozzles × 8 rows each
	Resolution	Y 300 dpi, 600 dpi X 600 dpi, 900 dpi, 1,200 dpi, 1,800 dpi
Ink Type		Sb420, Sb411, TP410
Ink set	Sb420	4-color: M, Bl, Y, K 6-color: C, M, Bl, Y, K, Lb, Lm
	TP410	4-color: M, C, Y, K 8-color: M, C, Y, K, R, G, Bl, Lk
	Hybrid	Sb411: M, Bl, Y, K / TP410: M, C, Y, K Sb420: M, Bl, Y, K / TP410: M, C, Y, K Sb411: M, Bl, Y, K / Sb420: M, Bl, Y, K
Media	Type	Decalcomania paper, fabric
	Maximum printing width ^{*1}	1,940 mm (decalcomania paper), 1,910 mm (fabric)
	Maximum width	1,950 mm (decalcomania paper), 1,920 mm (fabric)
	Minimum width	210 mm
	Thickness	Max. 5.0 mm
	Roll external diameter ^{*2}	Max. 250 mm
	Roll weight ^{*2, 3}	Max. 40 kg
	Paper core internal diameter	2 inches or 3 inches
	Printing face	Exterior/interior
Print margins	Roll end	Taped or loosely affixed to paper core
	Left/right	15 mm (default), minimum: 5 mm
Distance accuracy ^{*4}	Absolute accuracy	±0.3 mm or ±0.3 % of specified distance, whichever is greater
	Duplicability	±0.2 mm or ±0.1 % of specified distance, whichever is greater
Perpendicularity		±0.5 mm/1,000 mm
Media skew		Not more than 5 mm/10 m
Printing gap		Manual, five settings (3.0–7.0 mm)
Origin alignment		LED pointer
Ink supply		Ink eco-case (ink pack)
Maintenance liquid feed		Cartridge
Waste Ink Tank		Bottle type (2,000 ml × 2)
Take-up unit		Provided

Item		Tx330-1800
Feeding unit		Provided
Media heater		-
NCU (Nozzle clogging detection)		Provided
DAS (Automatic correction function)		Provided
Interface	Data transfer function	Ethernet 1000BASE-T (recommended)^{*5, 6}, USB 2.0 Hi-speed^{*6, 7}
Command		MRL-V
Languages		English, Japanese, Chinese, Turkish, Portuguese, Spanish, Italian, Korean
Noise levels	During standby	Not more than 54 dB (FAST-A, 1 m on all sides)
	Continuous operation	Not more than 59 dB (FAST-A, 1 m on all sides)
	Non-continuous operation	Not more than 65 dB (FAST-A, 1 m on all sides)
Compliance with standards		VCCI Class A, FCC Class A, IEC 62368-1 ETL compliance, CE marking (EMC Directive, Low Voltage Directive, Machinery Directive, RoHS Directive), CB certified, REACH, EnergyStar, RCM marking, KC certified, UKCA marking
Power supply specifications ^{*8}		Single-phase 100 to 120V AC / 200 to 240 V AC ±10 %/3 A, 50/60 Hz ±1 Hz
Power consumption	Maximum ^{*9}	300 W or less
	Standard	170 W
	Minimum ^{*10}	4.5 W or less
Installation environment ^{*11}	Permissible ambient temperature	20 to 30 °C
	Relative humidity	35 to 65 %RH (no condensation)
	Temperature range in which accuracy is guaranteed	20 to 25 °C
	Temperature gradient	Not more than ±10 °C/h
	Dust	0.15 mg/m ³ (typical office)
	Maximum operating altitude	2,000 m
External dimensions ^{*12}	Width	3,230 mm (3,590 mm)
	Depth	965 mm (1,010 mm)
	Height	1,857 mm (1,165 mm)

Item	Tx330-1800
Weight ^{*12}	291 kg (394 kg)

- *1. With setup menu margins set to the minimum (5 mm) on either side.
- *2. External diameter and weight after winding media.
- *3. Free of sagging due to weight.
- *4. Excluding media size variation and initial loading fluctuations.
- *5. Printing is not possible if local guidance shows any speed other than "1000Mbps". Using a LAN Cable
- *6. The print speed may be decreased depending on the connection environment or print data. Connecting a PC to the Product
- *7. Data may be transferred to the machine too slowly, causing the carriage to pause at the left-hand or right-hand end during printing.
- *8. Excluding options.
- *9. Varies depending on print mode.
- *10. In sleep.
- *11. Ink ejection consistency may decrease in conditions outside this range.
- *12. The figures in parentheses indicate package dimensions.

6.2 Options

Name	Code	Reference
Small Relay Box	OPT-J0370	
Relay Box 2	OPT-J0407	
Slip Sheet Holder Unit	OPT-J0405	
1-inch Holder Unit	OPT-J0399	
OPT-DsubBKT	OPT-01012	
Slip Sheet Unit Mounting BKT	OPT-01013	
Drying Fan Connection Kit	OPT-J0512	

Relay Box



- A fire may occur if another manufacturer's external drying heater is used. Be sure to connect to the machine using either the compact relay box or relay box 2 specified as options.



- The Tx330-1800 allows only one relay box (OPT-J0370 or OPT-J0407) to be connected.



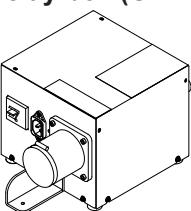
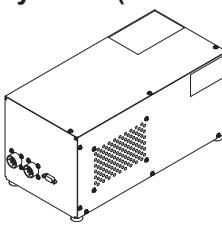
- The optional connection relay cable (OPT-J0512 drying fan connection kit) and the mounting bracket (OPT-01012 OPT-DsubBKT) are required when using a relay box.

● Overview

The relay box switches the heater power on and off automatically in conjunction with the machine operations.

- The heater is turned off when printing stops to prevent heating while the machine is not moving.
- The relay box cannot function to control the temperature of an external drying heater. The temperature should be set on the external heater itself.

● Specifications

Small relay box (OPT-J0370) 	Power supply specifications	Single-phase 100 V to 120 V AC, 12 A, single-phase 200 V to 240 V AC, 8 A, 50/60 Hz, single-circuit main power supply
	Type	Resistance heater or electric heater using lamp
Relay box 2 (OPT-J0407) 	Power supply specifications	Single-phase 100 V to 240 V AC, 30 A, 50/60 Hz, single-circuit main power supply
	Type	Resistance heater or electric heater using lamp

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Operation manual

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