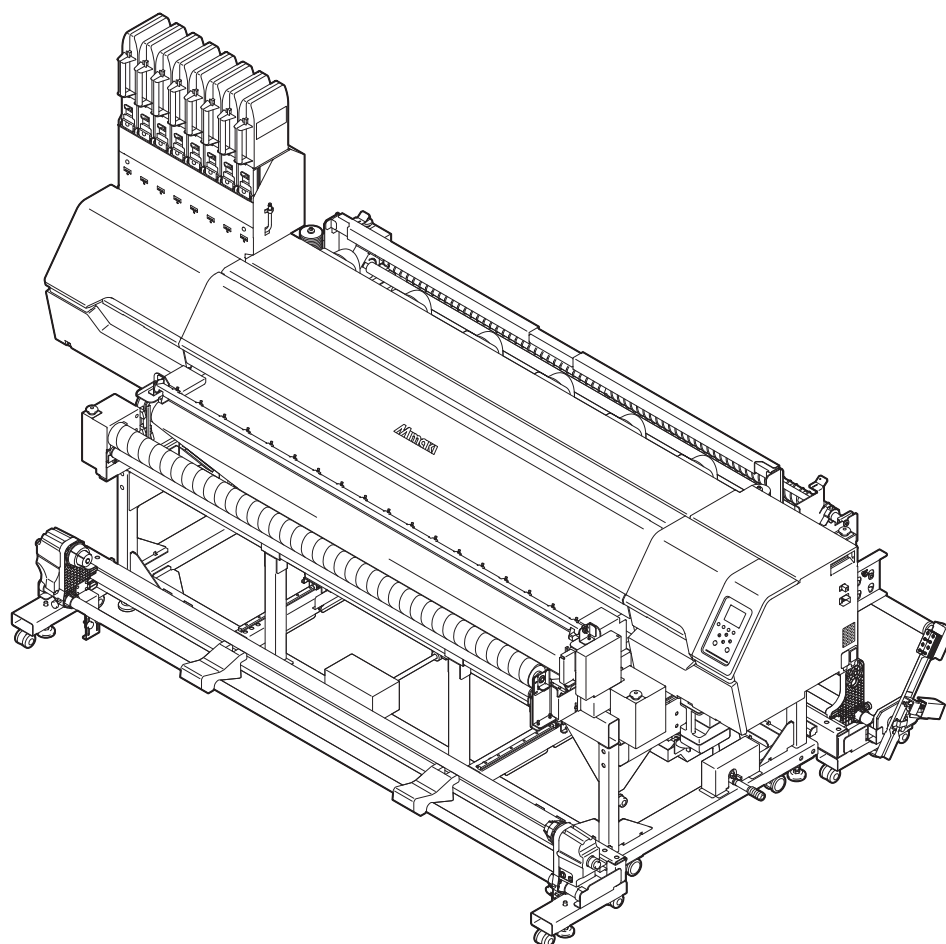


Operation Manual

INKJET PRINTER **TX330-1800B**

Operation Manual



You can also download the latest manual from official website.

MIMAKI ENGINEERING CO., LTD.

<https://mimaki.com/>

D203884-12
Original instructions

TABLE OF CONTENTS

Introduction	6
To Ensure Safe Use	8
Symbols	8
Usage Precautions	9
Usage Restrictions	12
Notes on Handling Ink or any Other Liquid Used with the Machine	13
Ink Specifications	15
Restrictions Concerning the Expiration Date of Ink Used in the Machine	16
Restrictions Concerning Ink Set Changes	16
Installation Precautions	17
Installation Space	18
When Relocating This Machine	18
Safety Interlocks	19
Emergency Stop Switches	20
Warning Label	21

Chapter 1 Before Use

1.1 Part Names and Functions	24
Front	24
Rear and Right Side View	26
Ink Supply Unit	27
Carriage	28
Station	28
Power Supply Switch	29
Operating Panel	30
1.2 Connecting the Power Cable	33
Turning On the Power	33
Turning Off the Power	34
1.3 Connecting a PC to the Product	36
Using a LAN Cable	36
Using a USB Cable	37
1.4 System Configuration	38
Installing the Mimaki Driver	39
Installing RIP Software	39
Obtaining Color Profiles	39
Setting Up RIP Software	39
1.5 Ink Replacement Method	41
When Ink Near End is Displayed	41
When Ink End is Displayed	41
Replacing Ink	42

Chapter 2 Printing

2.1 Print Process	48
2.2 Adjusting Print Head Height	51

2.3 Setting Up the Fabric Roller.....	53
2.4 Loading the Media	55
Media	55
Take-up unit.....	56
Feeding unit	60
Loading the Roll Media	66
Registering the Media.....	87
2.5 Test Printing.....	89
Changing the Layout Direction for Test Printing	90
Ejection Failures	90
2.6 Head Cleaning	91
2.7 Feed Correction	92
Feed Correction Procedure	92
2.8 Correcting the Drop Position.....	94
Drop Position Correction Procedure	94
2.9 Preparing RIP data	96
2.10 Printing.....	98
Changing the origin.....	98
Starting Printing	99
Stopping Printing (Data Clear).....	100

Chapter 3 Setup

3.1 Media Setting Menu.....	102
3.2 Maintenance Menu	104
Registering Nozzle Recovery	107
Nozzle Check.....	108
3.3 Function Setting Menu.....	109
3.4 Environment Setting Menu	111
3.5 Machine Status Menu	113

Chapter 4 Maintenance

4.1 Maintenance Precautions	116
-----------------------------------	-----

4.2 Maintenance Methods	117
Maintenance Items and Timing.....	117
Ink Maintenance	118
Cap Rubber Cleaning	118
Carriage Underside Cleaning	119
Wiper Cleaning	120
NCU Cleaning.....	122
DAS (Automatic Correction Function) Sensor Cleaning	123
Ink Discharge Channel Cleaning	124
Jam Sensor Detecting Plate Cleaning	126
Peeling Roller Cleaning	127
Belt Correction Unit Cleaning	127
Blowing Fan Filter Cleaning.....	129
Washing Water Replacement.....	130
Washing Unit Maintenance.....	131
Reapplying Adhesive	136
Cleaning the Washing Tray and Brush	146
Cleaning the Feeding Belt	147
Cleaning the Peeling Sensor	148
Resetting the Counter.....	149
Cover (Exterior) Cleaning	150
When this Printer is Left Unused for a Long Time	150
4.3 Replacement of Consumable Item	153
Consumable Item Replacement Timing.....	153
Wiper Replacement	154
Wiper Cleaner Replacement.....	155
Cap Replacement.....	157
Replacing the Absorber Around the Station	159
Blowing Fan Filter Replacement.....	161
Ink Supply Unit Ink Absorber Replacement	162
Waste Ink Tank Replacement.....	163

Chapter 5 Troubleshooting

5.1 Troubleshooting	166
The power does not turn on.....	166
Printing is not possible.....	166
The media jams or the media is dirty.....	166
Image defects occur.	166
The ink has leaked out.....	168
5.2 Problems Causing Messages to Appear	169
Warning Messages	169
Ink Error	171
Error Message	172
SYSTEM HALT	178

Chapter 6 Appendix

6.1 Specifications.....	180
-------------------------	-----

6.2 Options	183
Relay Box	183

Introduction

Thank you for purchasing the Inkjet printer Tx330-1800B.

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 Tx330-1800B ("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.
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- 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

Symbols

In this manual, symbols indicate and explain precautions. Make sure you fully understand the meaning of each symbol and use the machine safely and correctly.

Explanation		
	Warning	Indicates a potential hazard that may result in death or serious injury if handled improperly or if instructions are disregarded.
	Caution	Indicates a potential hazard that may result in minor or moderate injury if handled improperly or if instructions are disregarded.
	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	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.

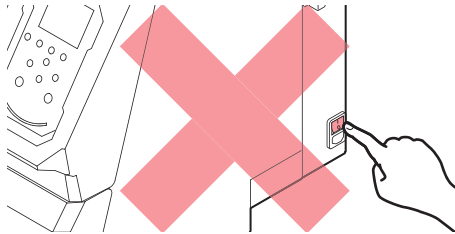


- Always connect the machine to a switchboard with grounded polarity. Otherwise there is a risk of failure, electric shock, or fire. All electrical work (Class C grounding work; formerly Type 3 grounding work) must be handled by a licensed electrician.

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.



- 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"\(P. 91\)](#)

● 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.

Usage Restrictions

Usage Restrictions

WARNING



- The machine poses significant safety hazards from parts that move at high speeds. The machine must only be used by operators who are fully aware of these hazards.

Operator Restrictions

WARNING



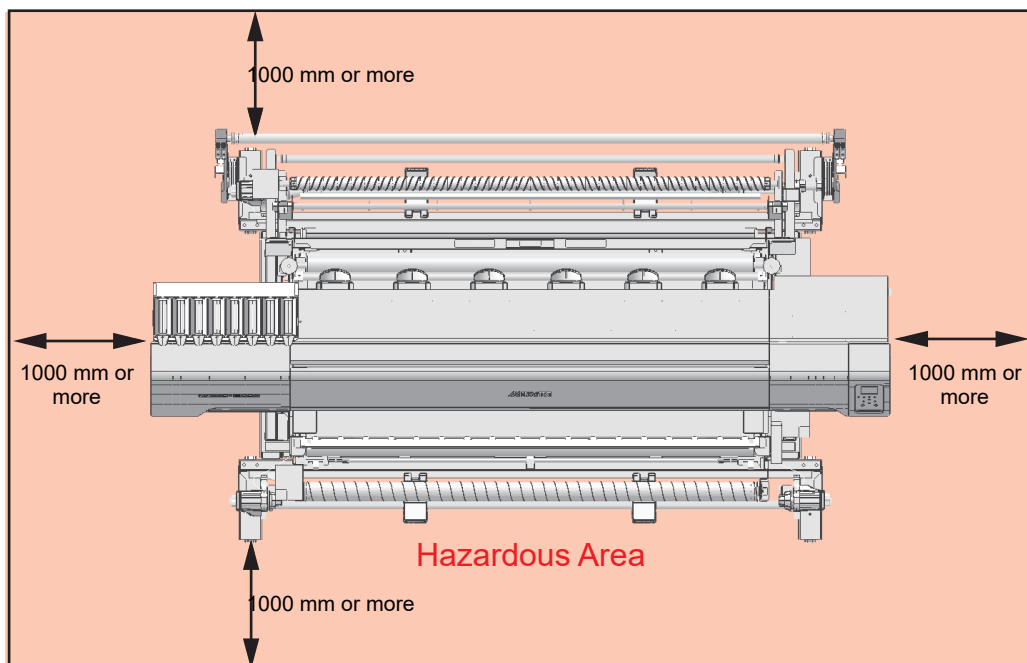
- The machine must only be operated by persons who have received Mimaki safety training or who have been trained by them.

Area Restrictions

WARNING



- Persons other than users who have received the appropriate training are prohibited from approaching the machine. Set area restrictions within the range shown in the following figure. The area restrictions must make it clear that the area is hazardous. For example, install the machine in a dedicated room or set up a barrier around it.
- Take steps to keep people other than those who have received Mimaki safety training or who have been trained by them out of the hazardous area. There is a danger of injury from moving parts such as the carriage or tension bar while printing is in progress if untrained personnel are allowed within the restricted area while the machine is operating.



- Physically separate the machine, for example, by placing in a special room or in an area surrounded by a safety fence. It must be clear that this is a hazardous area.
 - (1) Any special room provided should incorporate a door that can be locked or has a safety interlock
 - (2) Any safety fences used must conform to the EN ISO 13857 standards.

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		Tx330-1800B	
Type		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) 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.



- The ink expiration date is indicated on the ink container. 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.

Restrictions Concerning Ink Set Changes

When filling with ink sets other than Sb420 (Sb420_4C/6C), specifically, with TP410_4C/8C, or hybrid ink Sb420/TP410, the following options are required separately from the main unit. (The same applies when changing to a different type of ink set.)

Type	Ink set	Option no.
A	Sb420 4C/6C	None (not required)
B	TP410_4C	OPT-01007
C	TP410_8C	OPT-01008
D (hybrid)	Sb420/TP410	OPT-01010

Installation Precautions

WARNING



- Adhesive and releasing agents may contain flammable constituents such as thinner. This machine is not explosion proof. There is a risk of explosions.



- 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 the machine is installed in a poorly ventilated area or sealed room.
- Be sure to observe the following points regarding exhaust port installation:
 - (1) Exhaust port installation must conform to local environmental, health, and safety (EHS) guidelines.
 - (2) If the exhaust port is fitted with a shutoff valve, the valve must be open when the machine is in use.

NOTICE



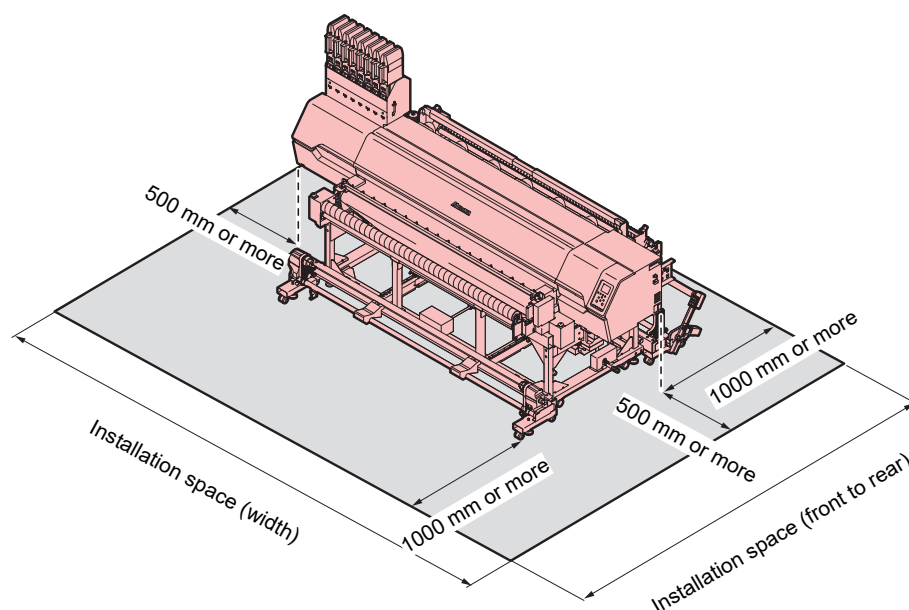
- Do not install this machine in locations where dust or powder is present. Failure or printing defects may result (e.g., nozzle clogging, deflection) if dust gets inside this machine.
- Do not install this machine in locations exposed to drafts (e.g., from air conditioning). Disregarding this precaution 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:



● Tx330-1800B

Size	Tx330-1800B
Width ^{*1}	At least 4,230 mm (3,230 mm)
Depth ^{*1}	At least 3,912 mm (1,912 mm)
Height ^{*1}	(1,900 mm) ^{*2}
Weight	622 kg

*1. The figures in parentheses indicate machine dimensions.

*2. With ink eco-cases loaded.

When Relocating This Machine

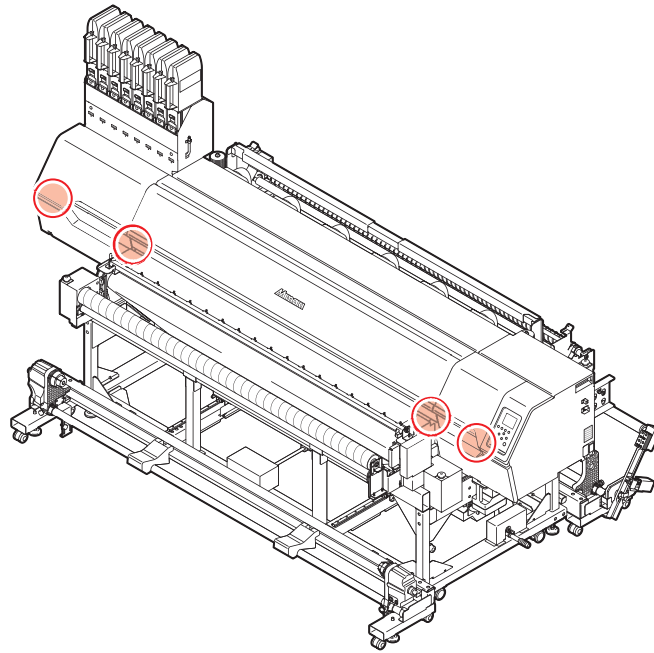
Contact your local dealer or our service office. Attempting to handle relocation yourself may result in failure or damage.

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.

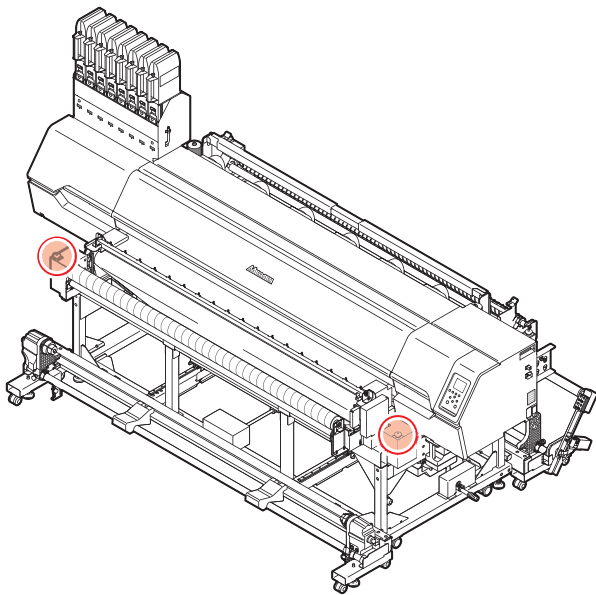
- Safety interlock locations



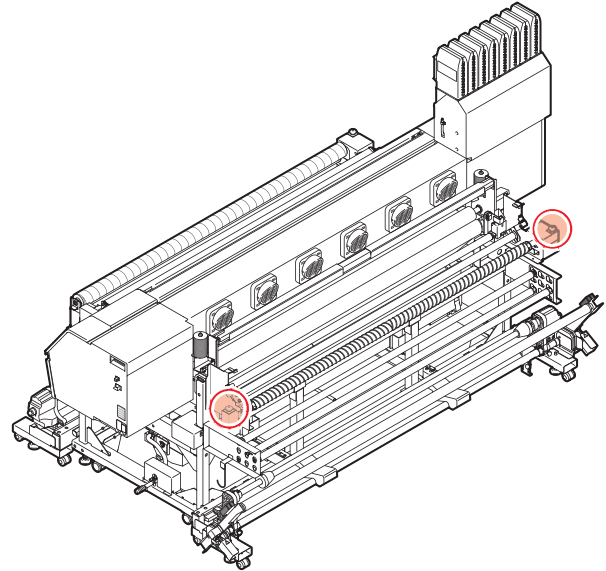
Emergency Stop Switches

Press one of the switches to stop the machine immediately for safety. Two emergency stop switches are located at the front of the machine and two at the rear.

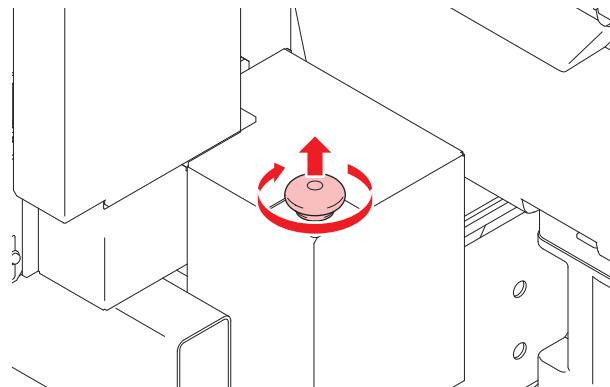
Front



Rear

**Important!**

- Do the following after an emergency stop switch has been pressed.
 - (1) Unplug the machine from the power outlet and resolve the problem.
 - (2) After confirming safety, deactivate the emergency stop switch.

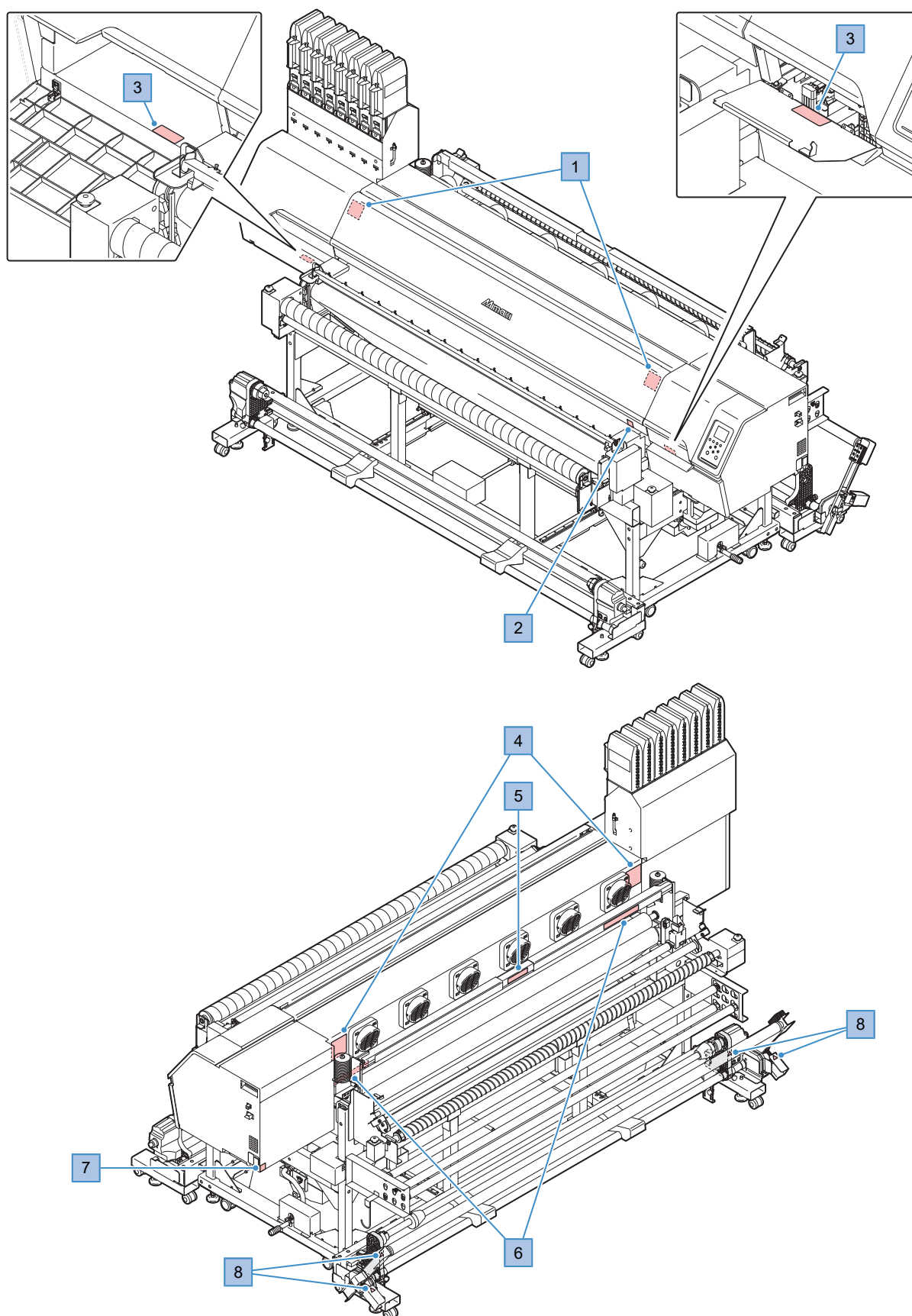


- (3) Plug the machine into the power outlet.

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	M913867		Indicates dangerous moving parts.
5	M913939		Indicates dangerous moving parts.
6	M905811		Indicates dangerous moving parts.
7	M907935		Indicates dangerous live parts.
8	M918910		Indicates dangerous moving parts.

Chapter 1 Before Use



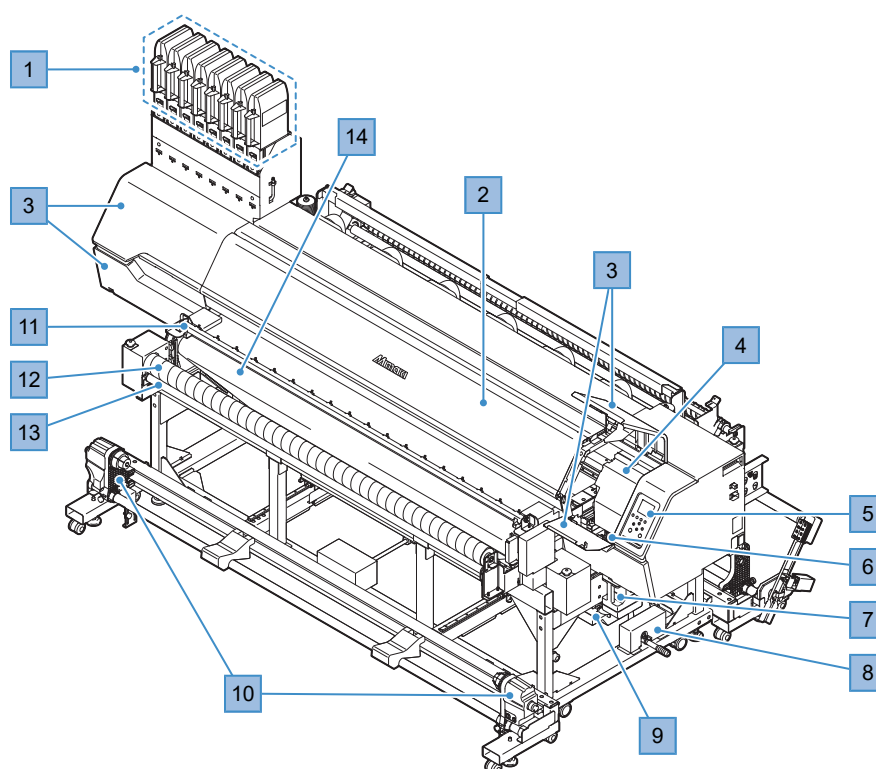
This chapter

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



Part Names and Functions	24	Connecting a PC to the Product.....	36
Front.....	24	Using a LAN Cable	36
Rear and Right Side View	26	Using a USB Cable	37
Ink Supply Unit.....	27	System Configuration	38
Carriage	28	Installing the Mimaki Driver	39
Station.....	28	Installing RIP Software.....	39
Power Supply Switch	29	Obtaining Color Profiles	39
Operating Panel	30	Setting Up RIP Software	39
Connecting the Power Cable.....	33	Ink Replacement Method	41
Turning On the Power	33	When Ink Near End is Displayed	41
Turning Off the Power	34	When Ink End is Displayed	41
		Replacing Ink	42

1.1 Part Names and Functions

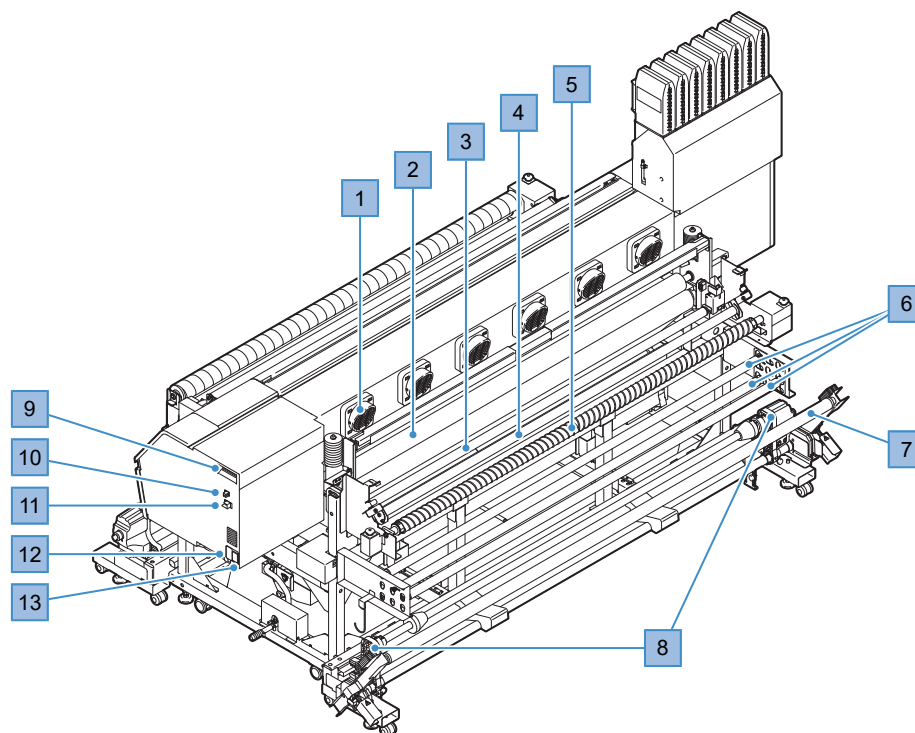
Front



No.	Name	Overview
1	Ink Supply Unit	Each tank contains an ink of a particular color. 🖨️ "Ink Supply Unit"(P. 27)
2	Front cover	Open the cover to load media or replace consumables. Printing and automatic maintenance are not possible while the covers are open.
3	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.
4	Carriage	Consists of components such as the print head and jam sensor. 🖨️ "Carriage"(P. 28)
5	Operating Panel	Includes operating keys and displays indicating various settings and other items. 🖨️ "Operating Panel"(P. 30)
6	Station	Includes caps and wipers for protecting print heads. 🖨️ "Station"(P. 28)
7	Waste Ink Tank	Container for waste ink. 🖨️ "Waste Ink Tank Replacement"(P. 163)
8	Water supply valve	Valve for supplying washing water. The valve opens and closes automatically, but the water supply can be adjusted with a cock if necessary. 🖨️ "Washing Water Replacement"(P. 130)
9	Belt Washing Unit	Cleans the feeding belt. 🖨️ "Cleaning the Feeding Belt"(P. 147)
10	Take-up unit	Rolls up the printed roll media. 🖨️ "Take-up unit"(P. 56)
11	Doctor	Used when reapplying adhesive. 🖨️ "Reapplying Adhesive"(P. 136)
12	Peeling roller	Peels cloth media from the feeding belt. 🖨️ "Loading media when using peeling"(P. 78)

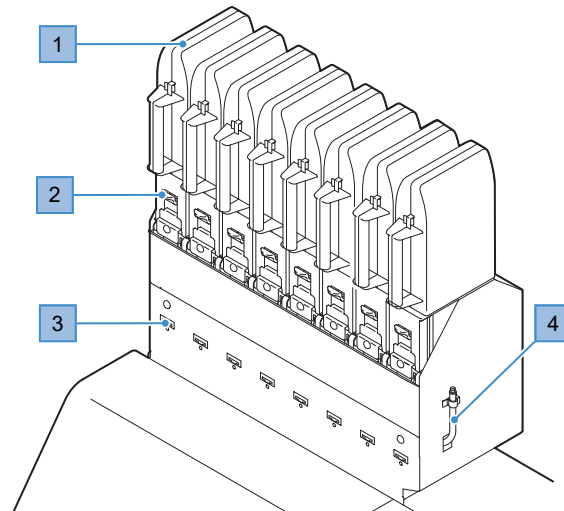
No.	Name	Overview
13	Cloth-wound roller	Helps keep cloth media clean by removing any ink on the peeling roller.  "Setting Up the Fabric Roller"(P. 53)
14	Feeding belt	Feeds cloth media.  "Cleaning the Feeding Belt"(P. 147)


Rear and Right Side View



No.	Name	Overview
1	Blowing fan	Blows air to dry ink after printing. "Blowing Fan Filter Replacement"(P. 161)
2	Pressure roller	Applies pressure to keep media adhering to the feeding belt.
3	Cloth-wound roller	Helps keep cloth media clean by removing any ink on the feeding belt. "Setting Up the Fabric Roller"(P. 53)
4	Curved bar	Makes sagging cloth media taut. "Using the curved bar to make sagging media taut"(P. 83)
5	Smoothing roller	Smooths wrinkled cloth media. "Removing the smoothing roller and shifting coils"(P. 84)
6	Reversing bar	Stabilizes feeding tension of media. "Adjusting the reversing bars"(P. 76)
7	Feeding tension bar	Adjusts feeding tension of media. "Using the tension bars"(P. 66)
8	Feeding unit	Feeds roll media toward the front of the machine. "Feeding unit"(P. 60)
9	Maintenance liquid cartridge	Used to automatically feed maintenance liquid to the cap, and to prevent ink solidifying inside the ink discharge channel during maintenance.
10	USB port	Connects to PC via a USB interface cable. "Using a USB Cable"(P. 37)
11	LAN port	Connects to PC via a LAN cable. "Using a LAN Cable"(P. 36)
12	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)
13	AC inlet	Use the power cable provided. "Connecting the Power Cable"(P. 33)

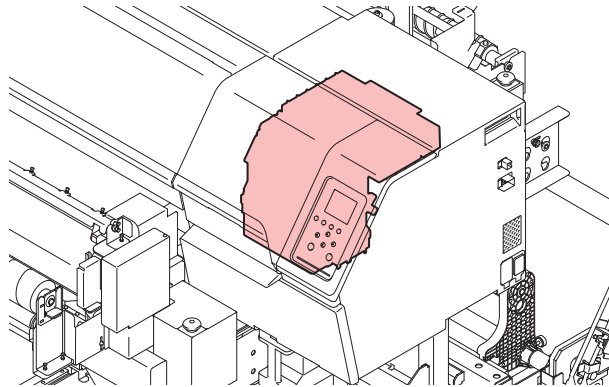
Ink Supply Unit



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. .

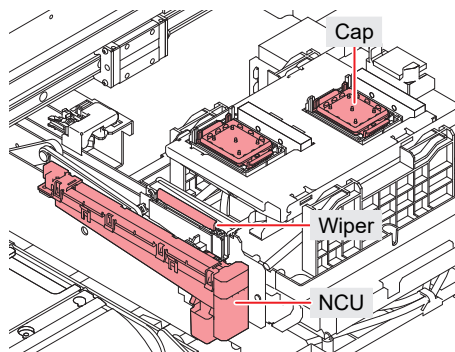
Carriage

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

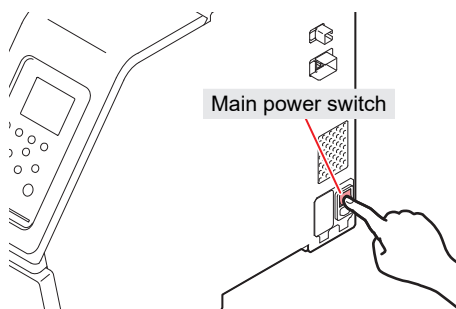
The station includes a cap for preventing the print head nozzle surface from drying out, and a wiper required for print head maintenance.



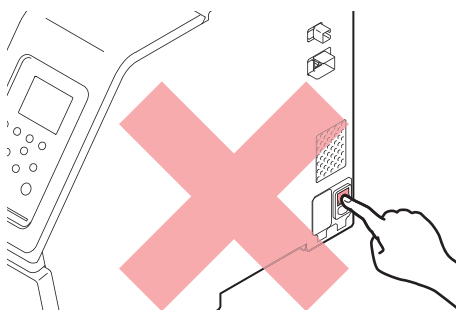
Power Supply Switch

● Main power switch

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



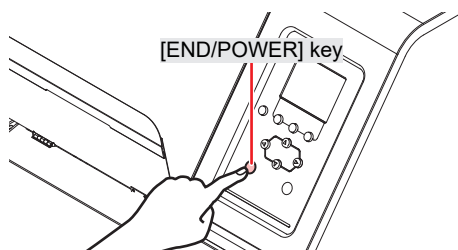
- Do not turn off the main power supply. Turning off the main power supply will disable the automatic maintenance function (including nozzle clogging prevention function and ink discharge channel cleaning function). This increases the risk of ejection failures (such as nozzle clogging or deflection).



● [END/POWER] key

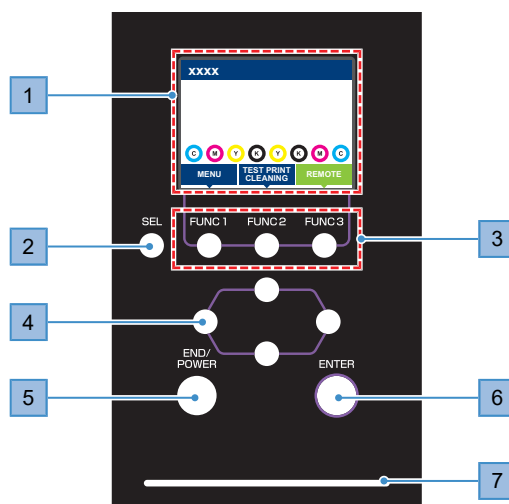
The [END/POWER] key is the key normally used to turn the power on and off.

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



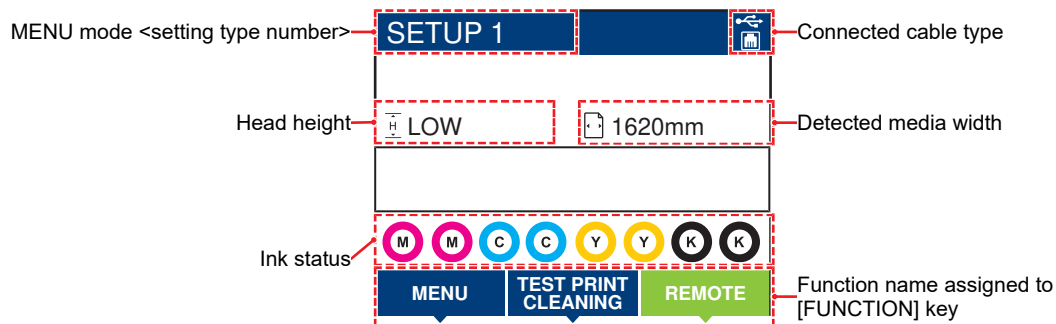
Operating Panel

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.
		Flashin g 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 Flashin g Indicates that maintenance is underway. Some functions will be limited until maintenance has ended.
		Yellow Flashin g Ink Near End status (very little ink remains). "When Ink Near End is Displayed"(P. 41)
		Red Flashin g An error has occurred. Refer to the error code list and take appropriate action. Error Message
		Illuminated A system error (SYSTEM HALT) has occurred. Contact our service office. "SYSTEM HALT"(P. 178)

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.
	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. 171)

[FUNCTION] key

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

Icon	Overview
	Displays the various menu screens.  "Setup"(P. 101)
	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

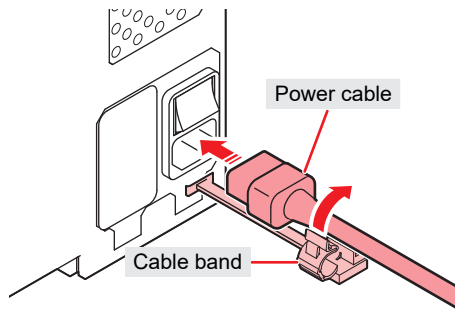
Displaying Machine Information (Local Guidance)

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

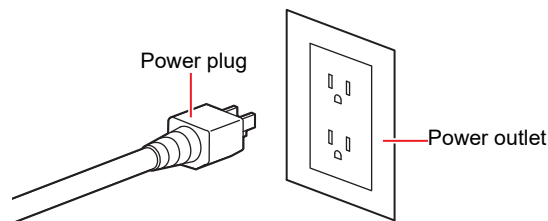
- Ink information: Displays ink type, remaining ink levels, and ink errors.
- Information: Displays information such as media width, head height, product serial number, firmware version, command version, and LAN connection status.

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.



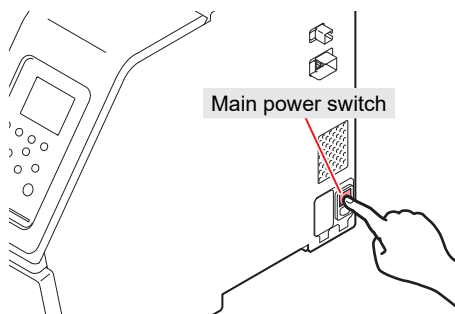
- 5** Plug the power plug into the power outlet.



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

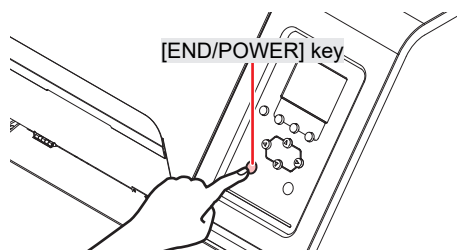
Turning On the Power

- 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

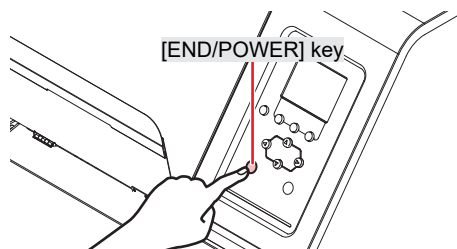


- Check the following when turning off power:
 - (1) The front cover and maintenance covers are closed.
 - Leaving any of the covers open will disable the automatic maintenance function (including nozzle clogging prevention function and waste ink draining channel cleaning function).
 - (2) The carriage 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).
 - (3) Data is not being received
 - (4) No errors have occurred.
 - ["Problems Causing Messages to Appear"\(P. 169\)](#)

1 Turn off the power to the PC connected.

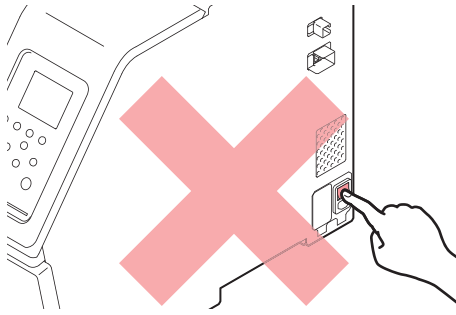
2 Hold down the [END/ POWER] key.

- 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"\(P. 37\)](#)



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.

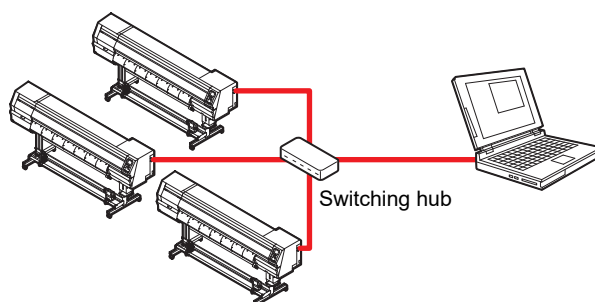


- Do not unplug the cable while data is being transferred.

● Network Connection Precautions

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

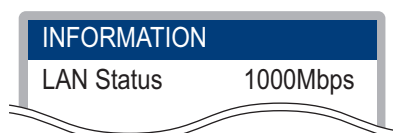
- Use a Category 6 or higher LAN cable.
- The PC used to transfer print data must be located on the same network as this product. This product cannot be connected via a router.
- Use a 1000BASE-T compatible computer or switching hub. Printing requires 1000BASE-T support.



● Checking the LAN connection

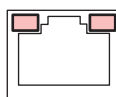
1 Check the display on this product.

- 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 <ul style="list-style-type: none"> 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.



When using the USB cable

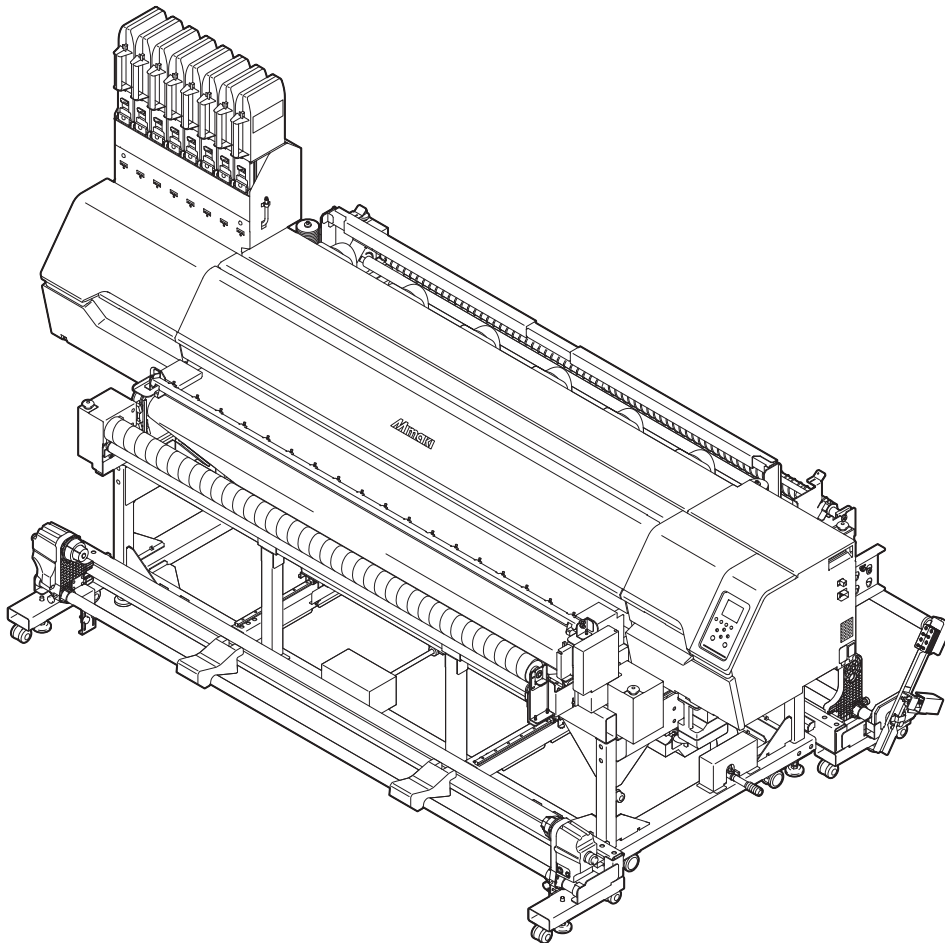
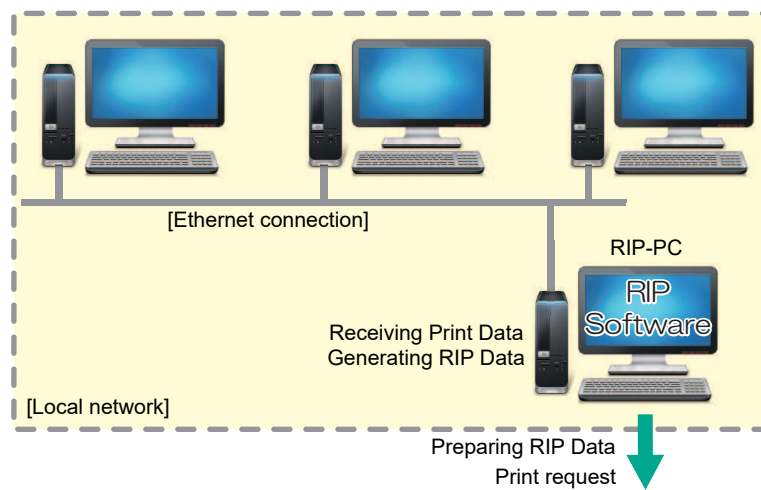
- Data may be transferred to the machine too slowly, **causing the carriage to pause at the left-hand or right-hand end** during printing.

● USB Connection Precautions

- When connecting more than one Tx330-1800B 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>
[Tx330-1800B] > [Driver/Utility]

2 Install the MIMAKI driver.

Installing RIP Software

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



- 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>
[Tx330-1800B] > [Profile]

Setting Up RIP Software

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



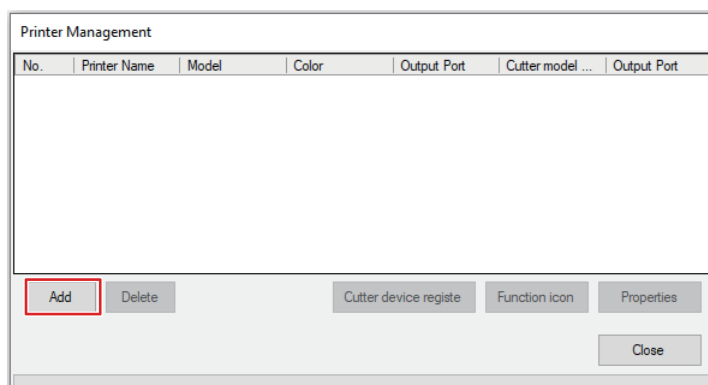
- If using TxLink, refer to the TxLink operating manual.

1 Launch RasterLink.

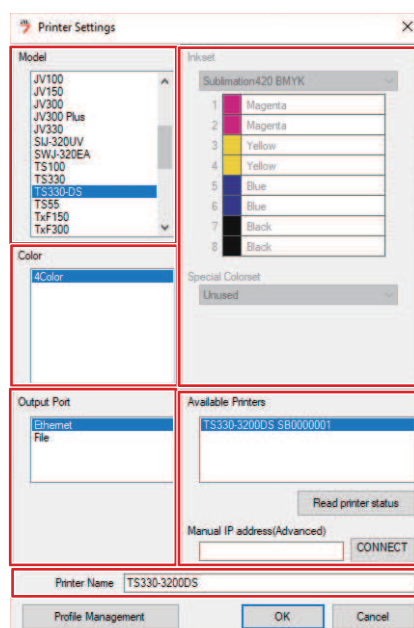
- The [Printer Management] screen appears.
- To add a new model, launch RasterLink, then select [Environment] > [Printer Management].

2 Register Tx330-1800B.

(1) Click [Add].



(2) Set the specifics for Tx330-1800B.



- 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 Tx330-1800B 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"\(P. 13\)](#)



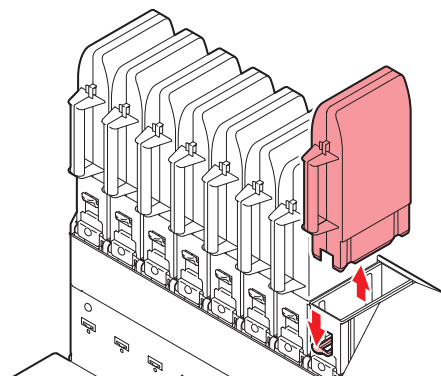
- Pay close attention to ventilation and be sure to wear safety glasses, gloves, and a mask when handling ink, maintenance liquid, waste ink, or other solutions used with the machine. Leaking ink may adhere to the skin or get into the eyes or mouth.

Replacing Ink

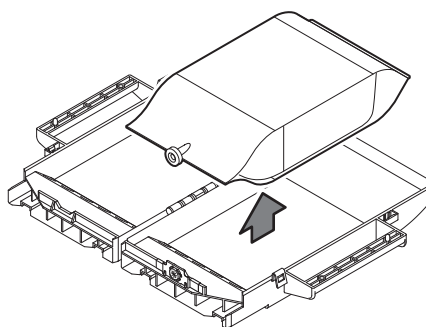
Ink replacement procedure

- Removing Ink Eco-cases

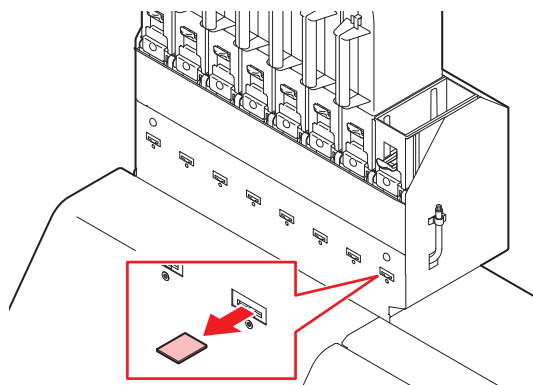
- 1 Push down the lever on the pedestal, and remove the ink Eco-case.



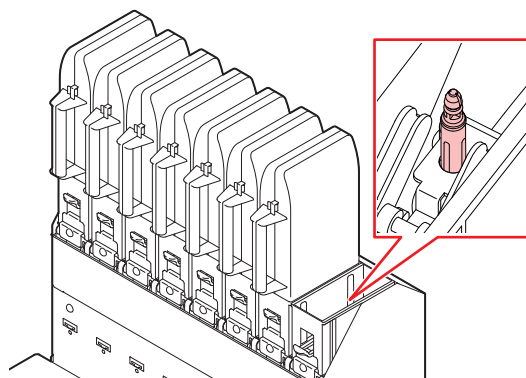
- 2 Open the ink eco-case, then remove the ink pack.



- 3 Remove the ink IC chip.



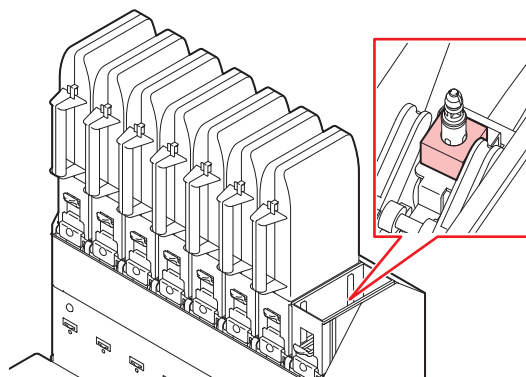
4 Wipe off any ink adhering to the ink eco-case opening.



- 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.



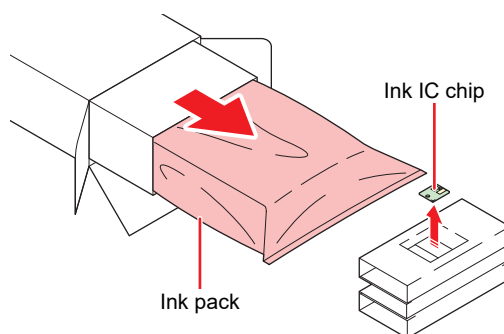
- We recommend replacing the ink absorber each time you replace the ink pack, to prevent dirt building up on the pedestal of the ink supply unit.



- 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.

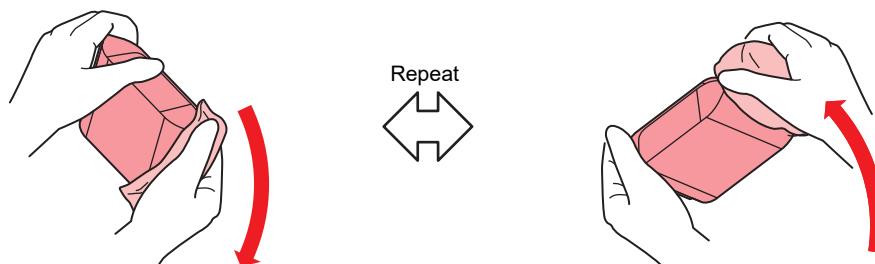
● Preparing the Ink

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.

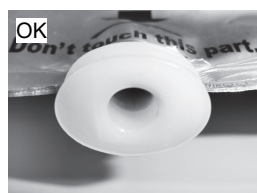


- When using an ink pack with ink remaining, hold a paper towel over the ink eco-case opening and shake slowly with the ink eco-case tilted upright.

3 Remove the seal attached to the ink pack opening.

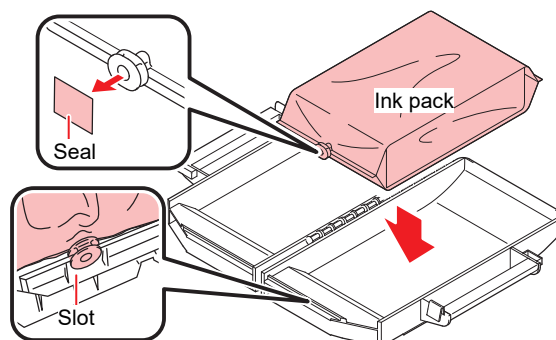


- Remove the seal completely. If any parts of the seal remain, ink may leak when the ink eco-case is removed from the base.



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.



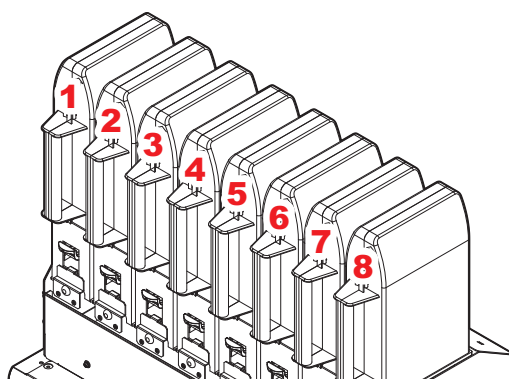
5 Close the ink eco-case gently to avoid pinching the ink pack.



- Be careful to avoid catching your hands or fingers.

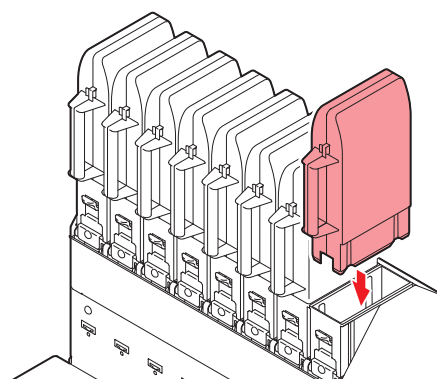
● Mounting the ink

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.



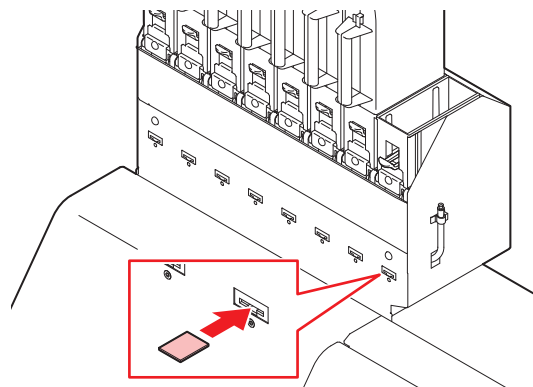
Ink set	Ink positions							
	1	2	3	4	5	6	7	8
Sb420 (4-color)	M	M	Y	Y	Bl	Bl	Bk	Bk
Sb420 (6-color)	M	Lm	Y	Lb	Bl	Bl	Bk	Bk
TP410 (4-color)	M	M	C	C	Bk	Y	Bk	Y
TP410 (8-color)	M	R	C	Bl	Lk	G	Bk	Y
Sb420/TP410 (4-color, hybrid)	Sb420				TP410			
	M	Y	Bl	Bk	M	C	Bk	Y

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.

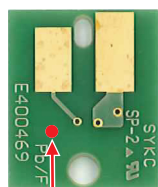


- Insert the ink IC chip with the metal side facing up. Inserting it in the wrong way may cause failure of the machine or damage the ink IC chip.



- 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.



Marking location

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

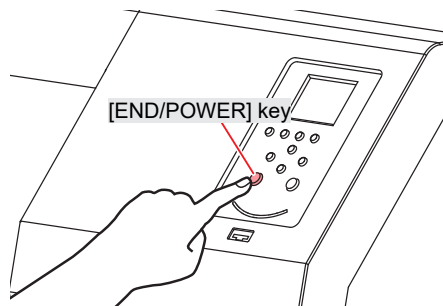
This chapter describes printing procedures and settings.

Print Process	48	Head Cleaning.....	91
Adjusting Print Head Height	51	Feed Correction.....	92
Setting Up the Fabric Roller	53	Feed Correction Procedure.....	92
Loading the Media	55	Correcting the Drop Position	94
Media	55	Drop Position Correction Procedure	94
Take-up unit	56	Preparing RIP data.....	96
Feeding unit	60	Printing	98
Loading the Roll Media	66	Changing the origin.....	98
Registering the Media	87	Starting Printing	99
Test Printing	89	Stopping Printing (Data Clear).....	100
Changing the Layout Direction for Test			
Printing	90		
Ejection Failures.....	90		

2.1 Print Process

1. Turn on the power.

 ["Turning On the Power"\(P. 33\)](#)



2. Connect a RIP PC to the machine.


 ["Using a USB Cable"\(P. 37\)](#)

 ["Using a LAN Cable"\(P. 36\)](#)


3. Setting Up RIP Software

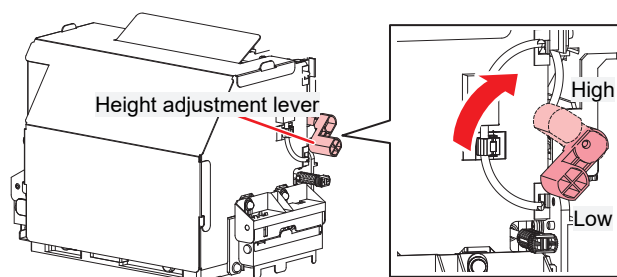
 ["Installing RIP Software"\(P. 39\)](#) (required first time only)

 ["Obtaining Color Profiles"\(P. 39\)](#)

 ["Setting Up RIP Software"\(P. 39\)](#) (required first time only)

4. Adjusting Print Head Height

Adjust the height adjustment lever to suit the media.  ["Adjusting Print Head Height"\(P. 51\)](#)



5. Setting Up the Cloth-wound Roller (Two Positions)

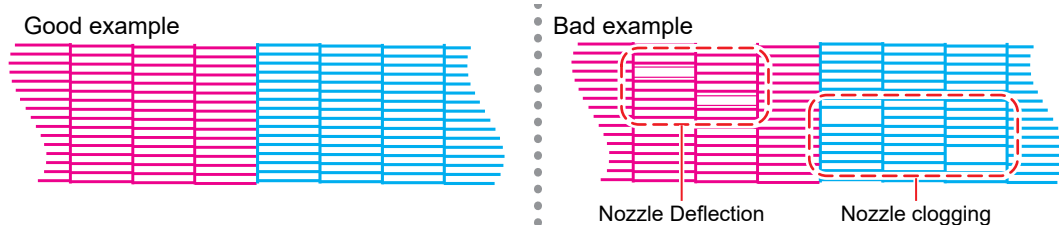
 ["Setting Up the Fabric Roller"\(P. 53\)](#)

6. Loading the Media

["Loading the Media"\(P. 55\)](#)

7. Check the state of the print head nozzles.

["Test Printing"\(P. 89\)](#)

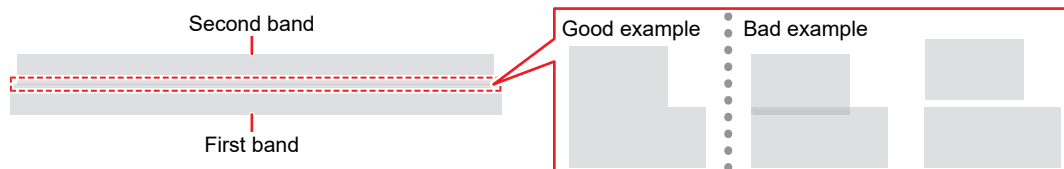


8. Clean the head to clear malfunctioning nozzles.

There are three different head cleaning methods. Choose the head cleaning method based on test print results. ["Head Cleaning"\(P. 91\)](#)

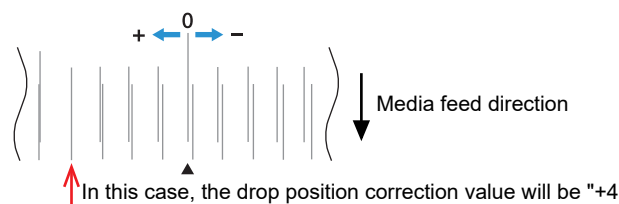
9. Adjust the media feed amount.

["Feed Correction"\(P. 92\)](#)



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

["Correcting the Drop Position"\(P. 94\)](#)



11. Preparing RIP data

["Preparing RIP data"\(P. 96\)](#)

12. Printing RIP data

👉 "Printing"(P. 98)

2.2 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. 94)

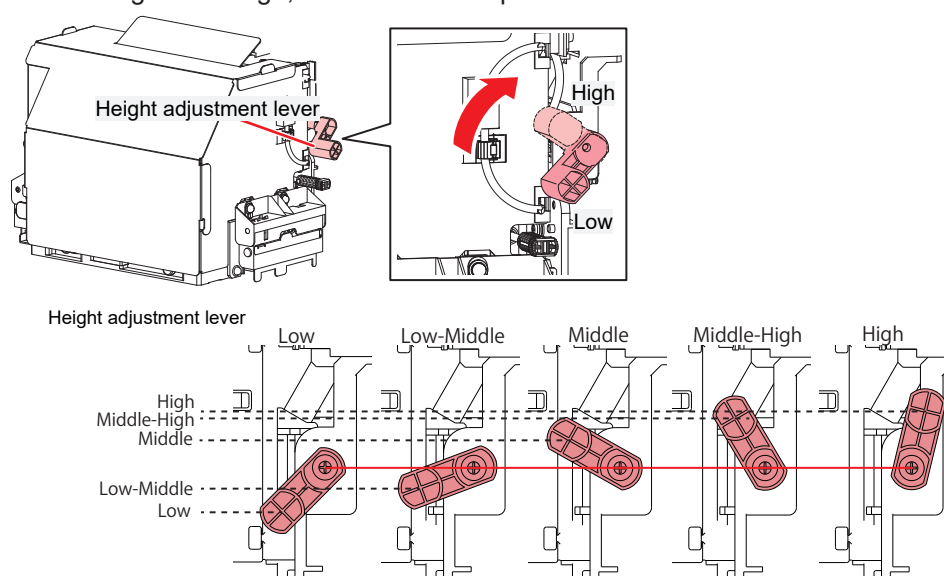


- With inkjet printers, if the gap between the print head and media increases, the ink droplets tend to vaporize before they reach the media. Vaporized ink may adhere to the print head nozzle surface and media, affecting print quality and causing failure of the print head. Adjust the print head height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

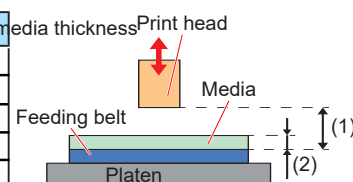
- 1 On the **LOCAL** mode screen, select **[MENU] > [Maintenance]**, then press the **[ENTER]** key.
 - The Maintenance menu is displayed.
- 2 Select **[Station Maint.] > [Carriage Out] > [Move To Platen Right End]**, then press the **[ENTER]** key.
 - The carriage moves over the feeding belt.
- 3 Open the front cover.
- 4 Use the height adjustment lever to adjust the height.



- 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.



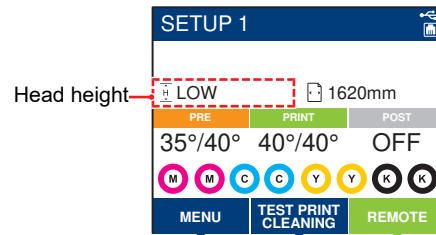
Range	(1) Gap between print head and feeding belt	(2) Recommended media thickness
High	7.0 mm	3.5 mm to 5.0 mm
Middle-High	6.0 mm	2.0 mm to 4.0 mm
Middle	5.0 mm	1.0 mm to 3.0 mm
Low-Middle	4.0 mm	2.0 mm or less
Low	3.0 mm (default setting)	1.0 mm or less



- 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.



2.3 Setting Up the Fabric Roller

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

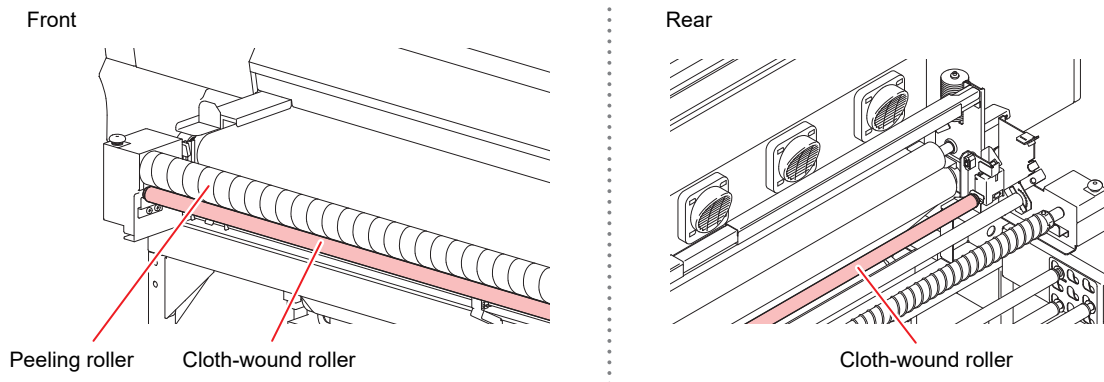
Attaching the cloth-wound roller helps to prevent the cloth media from becoming dirty by removing any ink adhering to the peeling roller.

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 cloth-wound roller is in contact with the peeling roller at the center and ends.)
 - (1) Material: Cotton jersey, cotton broadcloth, etc.
 - (2) Size: 195 cm × 70 cm (approximate)

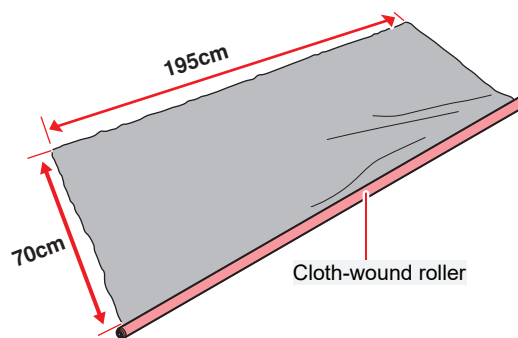
1 Remove the fabric wound roller.

- One cloth-wound roller is below the peeling roller in the front of the machine and another is used in contact with the belt surface in the back.

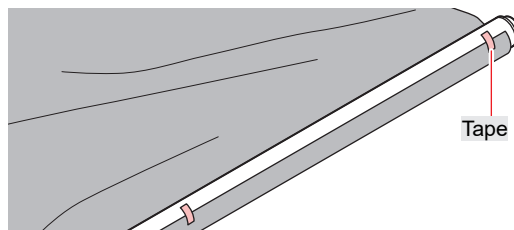


2 Wind cloth around the fabric roller.

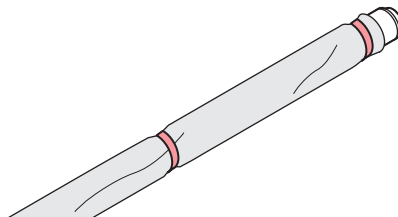
(1) Align the cloth with the roller.



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



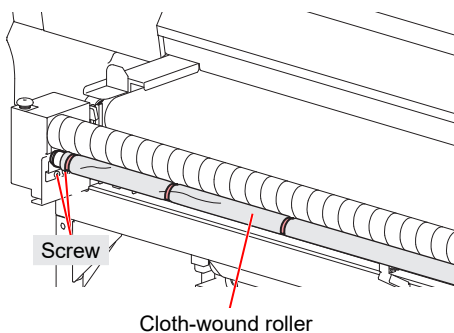
(3) Wind the cloth around the roller, then secure with adhesive tape.



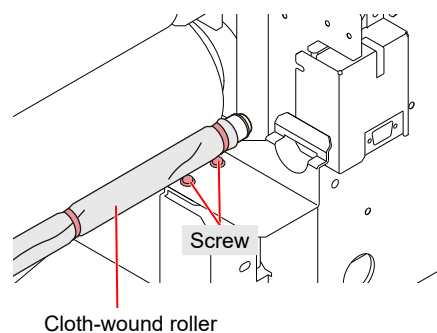
3 Attach the fabric roller with the cloth wound on it.

- Mount the fabric roller in the groove below the bracket.
- Adjust the positions of the bearings at both ends of the fabric roller.
Loosen the bearing screws and adjust so that the fabric roller touches the peeling roller.

Front



Rear



Important!

- Clamp in place so that the cloth-wound roller is in contact with the peeling 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 peeling roller by hand to confirm that it turns smoothly.

- If the peeling roller does not turn smoothly, check the mounting position of the cloth-wound roller.

2.4 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.



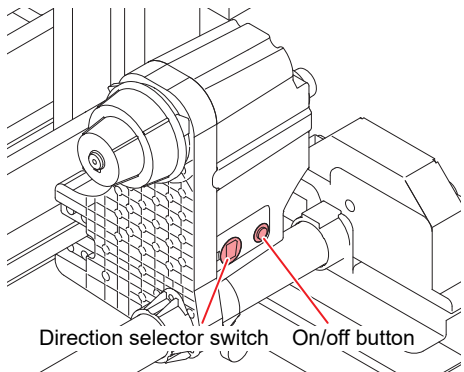
- Do not leave the media in the machine when not in use. Otherwise dust may accumulate on the media. Do not use media that has been wiped free of dust. Wiping media can generate static electricity, possibly affecting print quality.
- Do not use media immediately after removing it from the package. The 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"\(P. 109\)](#)

Replacing the direct-connection unit/torque limiter

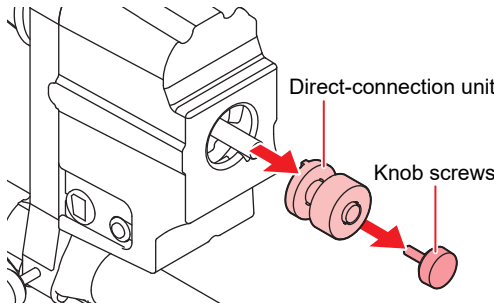
The take-up unit should be replaced with a direct-connection unit when the peeling function is used, or with a torque limiter when it is not used.
The feeding unit should be replaced with a direct-connection unit when tension bars are used, or with a torque limiter when they are not used.
The torque limiter can change the strength of feeding/take-up 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.

● Torque limiter attachment

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

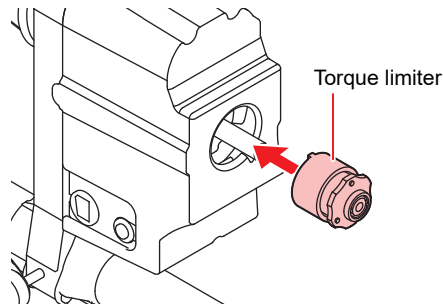
1 Remove the direct-connection unit.

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



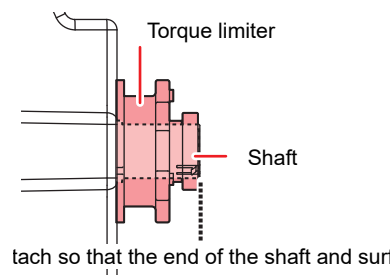
2 Attach the torque limiter.

- (1) Insert the torque limiter.

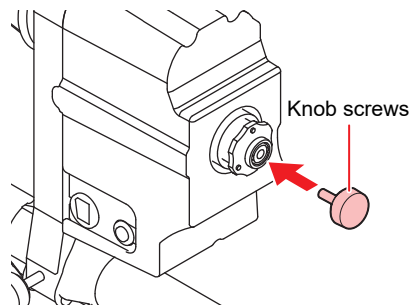


- (2) Attach the torque limiter so that the surface is flush with the end of the feeding/take-up unit shaft, as shown.

- 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.

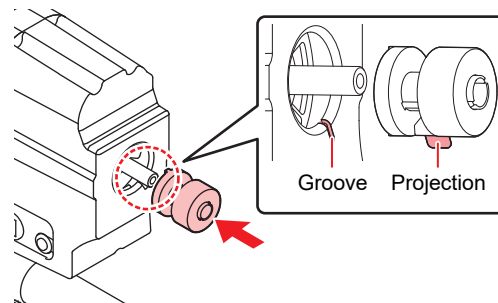


● Direct-connection unit attachment

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

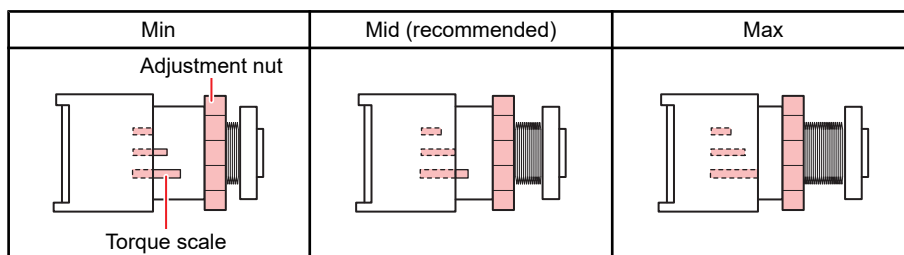


- Attach the direct-connection unit so that the lug on it is aligned with the groove of the feeding/take-up unit.



Adjusting the torque limiter

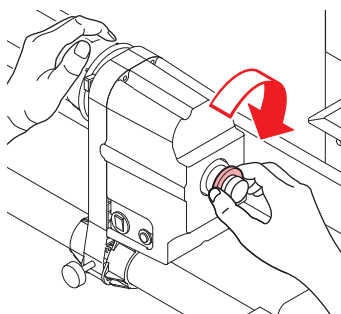
Turn the torque limiter adjustment nut to adjust take-up tension. When adjusting the torque limiters, be sure to adjust to the same torque for both the left and right take-up units.



- For normal printing: Adjust the torque to "Mid".

● Increase tension (clockwise)

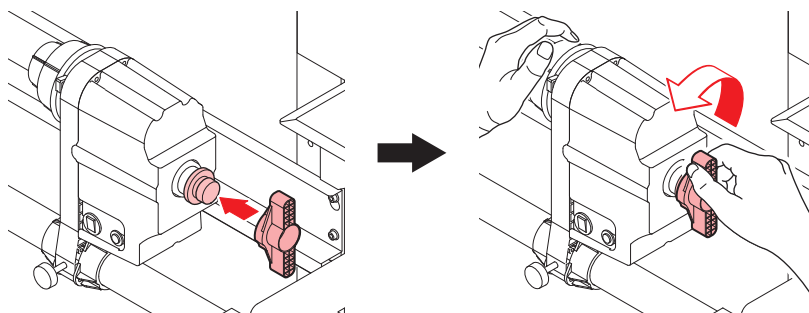
Increase tension when using with heavy or thick media, such as tarpaulin. Perform adjustments manually.



- 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.




Removing the roll media after printing

● Procedure

1 Cut the media.

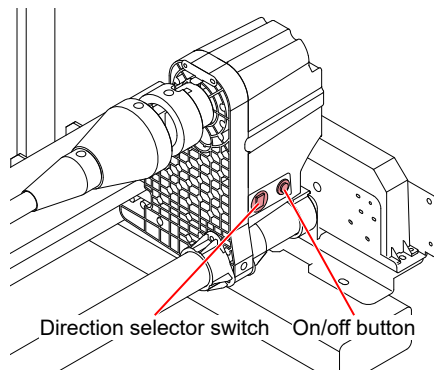
- Use scissors or the like to cut away the printed portion.

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"\(P. 56\)](#).

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	Activates/deactivates feeding. <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"\(P. 109\)](#)

Adjusting tension bar weight

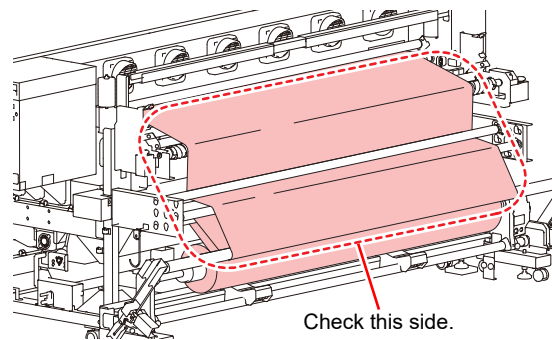
Various types of media are available which feature a variety of thread thicknesses and are woven in different ways. Even with the same media, elasticity varies depending on pretreatment and other factors. To ensure correct tension when printing on such diverse media, the take-up tension bar must be weighted 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.



- Load the media as described in "Loading the Roll Media"(P. 66) 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 tension bar does not rise or the paper core slips. 	The media is excessively tensioned. Reduce the counterweights to reduce the weight on the tension bar to suit the media being used.
<ul style="list-style-type: none"> • The media sags and is not taken up smoothly. • The media sags and the surface is not flat. 	The media is insufficiently tensioned. Increase the counterweights to increase the weight on the tension bar to suit the media being used.



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 two places on the feeding side (left and right). Attach the same amount of weight at each position. Uneven weighting may bend tension bars and affect print quality.
- Keep unused counterweights in the box to avoid losing them.



Weight-adjustment springs

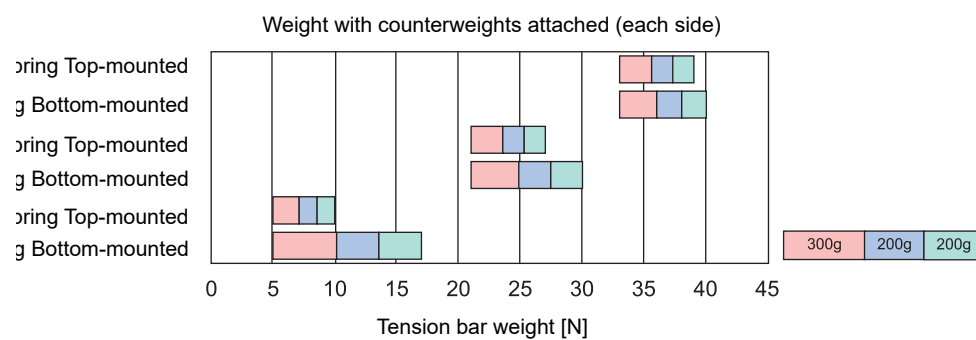
- The machine is shipped with the green spring attached. Tension bar weight can be adjusted by removing springs or switching to a different type.
- Weight can also be adjusted by attaching weight-adjustment springs at two positions on the feeding side, at left and right. Set the springs in both positions 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.

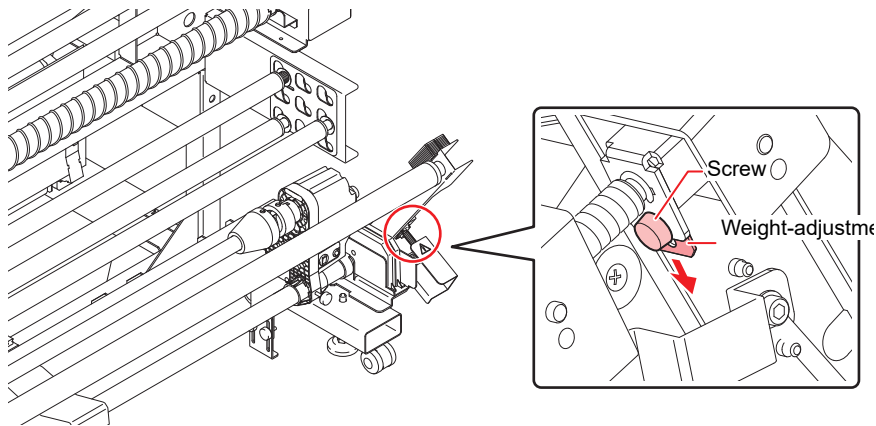


- For reference, this chart shows the combined effect of counterweights and weight-adjustment springs.



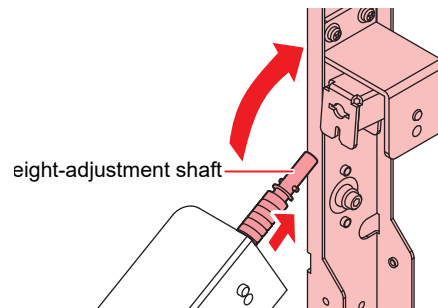
Attaching weight-adjustment springs

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



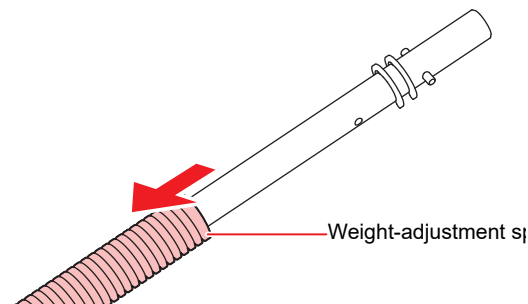
- 2 Pull out the weight-adjustment shaft.

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



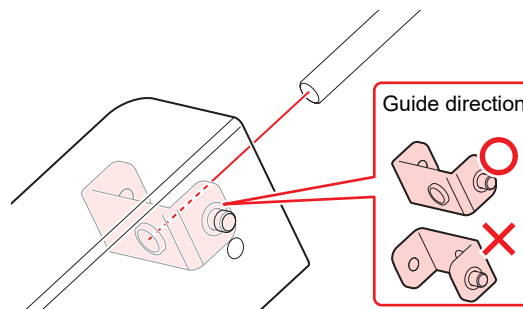
- 3 Remove the weight-adjustment spring currently attached.

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

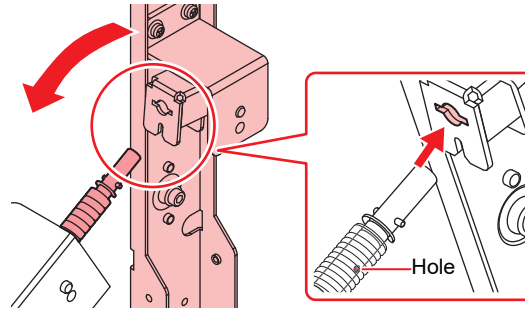


- 4 Attach the weight-adjustment shaft.

- 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.

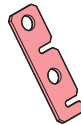


- 6** Tighten the screw.

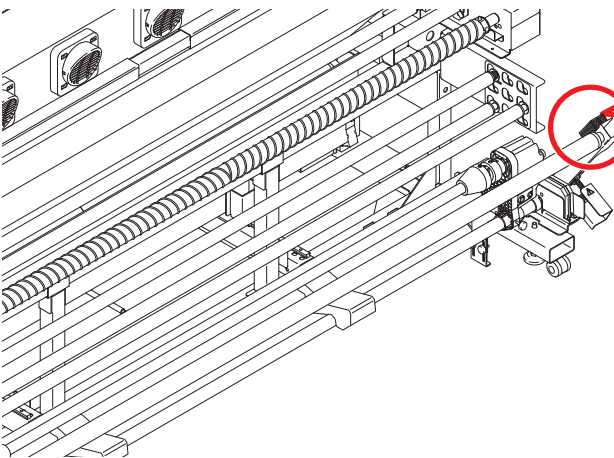
Attaching counterweights for tension bar weight adjustment



- 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.



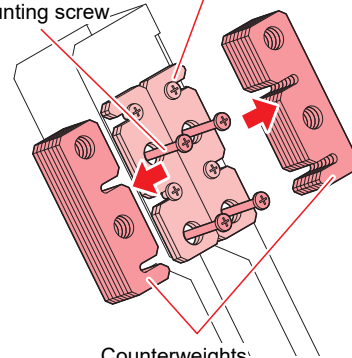
- Consider media characteristics when deciding whether to attach counterweights.
- Up to 14 counterweights can be attached on each side, at left and right.
- Loosen the mounting screws to remove counterweights.



Do not remove the weights originally attached.

Mounting screw

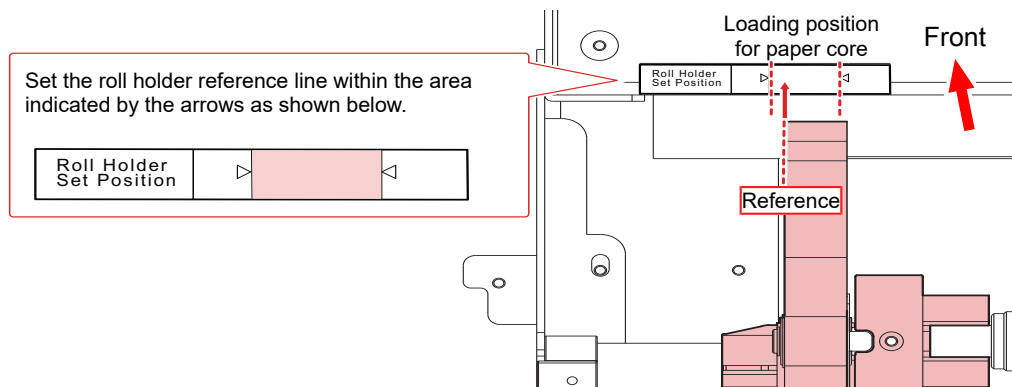
Counterweights



- 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.

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 the Roll 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.



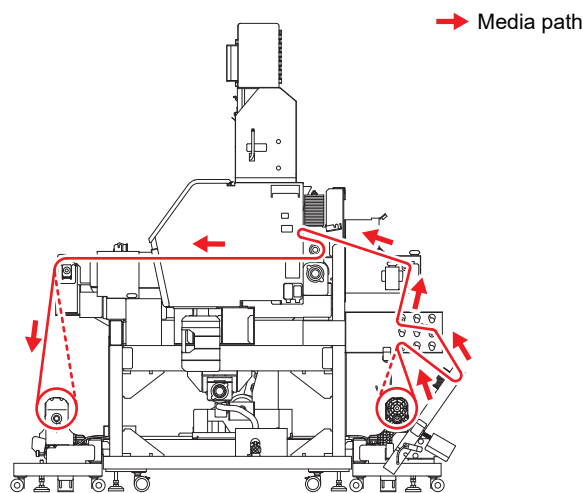
- When loading the media in the center, use the take-up extension cable.
- Adjust the head height to suit the intended use.

Using the tension bars

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



- Confirm that parts that come into contact with the media path are clean. Clean this area if it is dirty.
- Before loading media using tension bars, make sure the direct-connection unit is attached to the feeding unit. If a torque limiter is attached, replace it with a direct-connection unit as described in ["Replacing the direct-connection unit/torque limiter"\(P. 56\)](#).

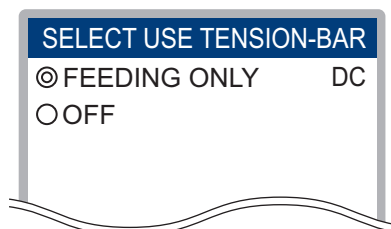


1 Close the front cover and press the [FUNC2 (MEDIA)] key.

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

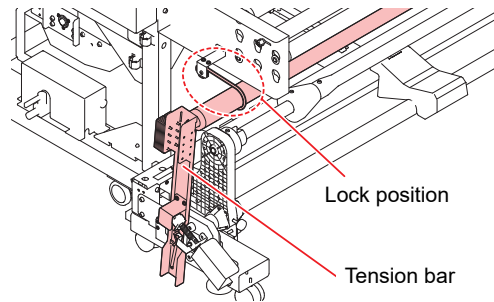
2 Select how tension bars will be used, which is based on how the media is loaded.

- In this case, select the option for feeding only.
(DC: direct-connection unit, TL: torque limiter, --: unit off)
- Press to select feeding only, then press the [ENTER] key.



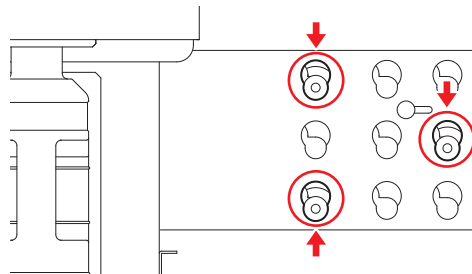
- This screen is not displayed if the feeding unit is set to OFF in the options for roll unit selection.

3 Secure the feeding tension bar by setting it in the locked position.

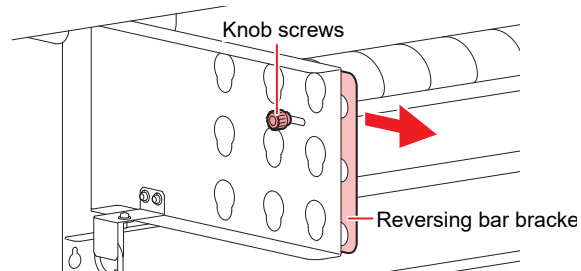


4 Attach reversing bars to suit the media you will load.

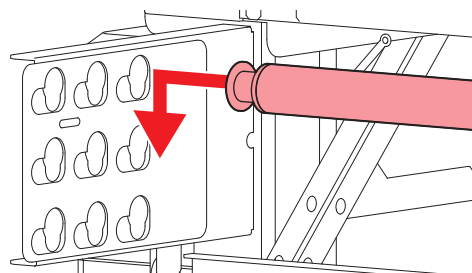
- To stabilize feeding-side tension, attach reversing bars at suitable positions for the media you will load.
- Recommended positions are shown below. If the media is loose or vertically wrinkled with the reversing bars in these positions, refer to ["Loading roll media without using tension bars"\(P. 76\)](#) 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.



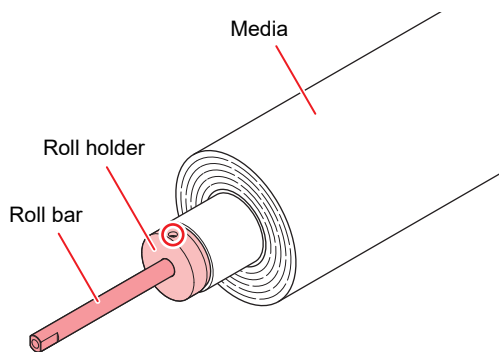
- (3) Insert and lower reversing bars.
 - Fit the reversing bars into the bottom notch of the hole.
 - Make sure the reversing bars are mounted in the correct positions. Mounting bars in the wrong position will prevent you from securing them.



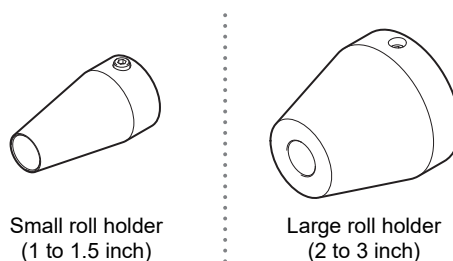
- (4) Move the reversing bar bracket toward the machine and secure it.
 - Do this for the reversing bar brackets on the left and right.

5 Insert a roll bar through the roll.

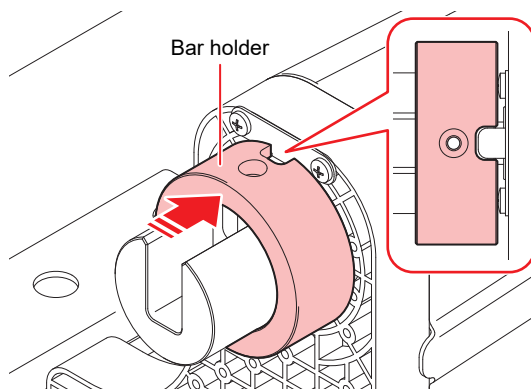
- Insert a roll holder that fits the paper core and tighten the screws.



- Be sure to insert the roll holder all the way in. Incorrect insertion may cause the paper core to be gouged.
- Two types of roll holders are available. Choose one that matches the paper tube of the media used. (See the following figure.)

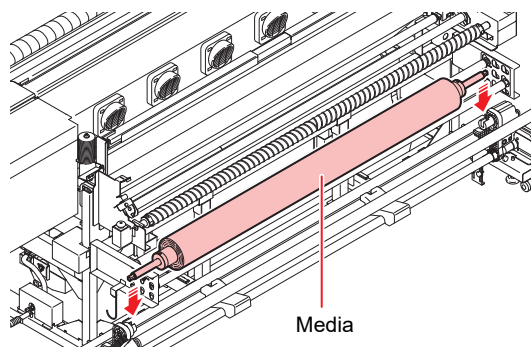


6 Set the bar holder to the locked position.



- Press the bar holder all the way in and make sure it does not rotate.

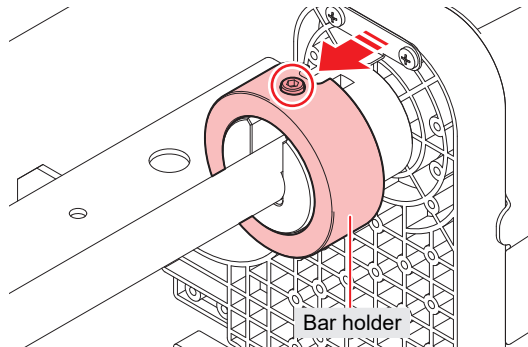
7 Load media on the bar holder.



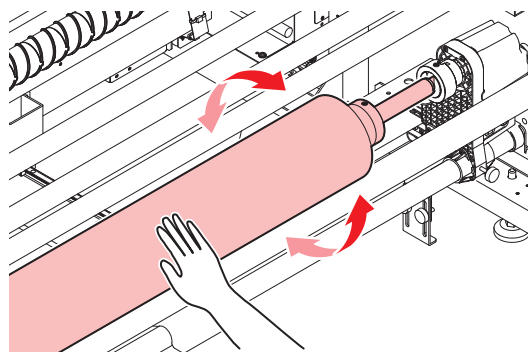


- When loading roll media, be careful to avoid dropping it on your feet. Heavy media may cause injury.
- At least two people should load roll media. The weight of the roll media can injure your back.

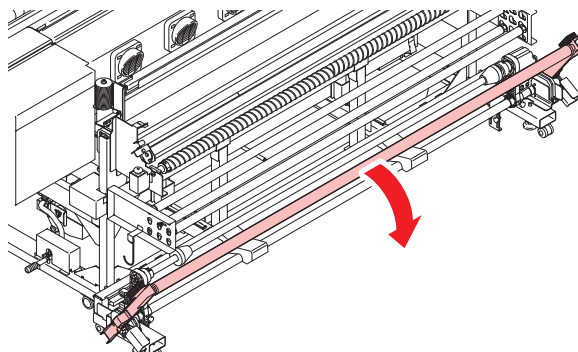
8 Slide the bar holder and tighten the screws.



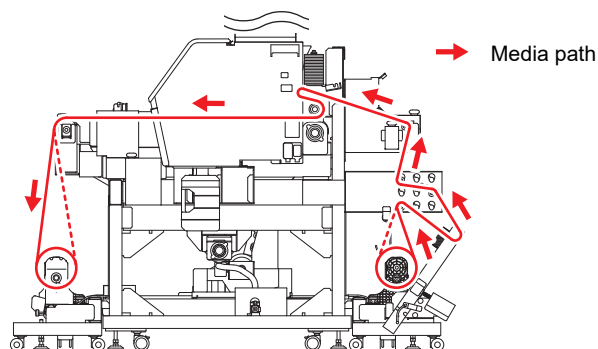
9 Rotate the media by hand and confirm that it turns without problems.



10 Lower the feeding tension bar.

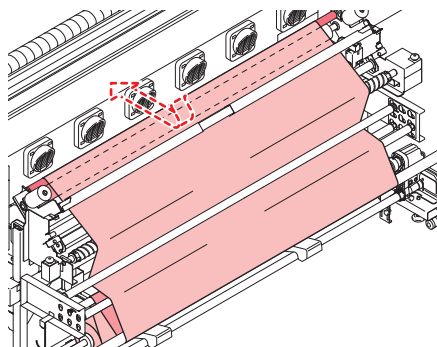


11 Load the media in the machine.

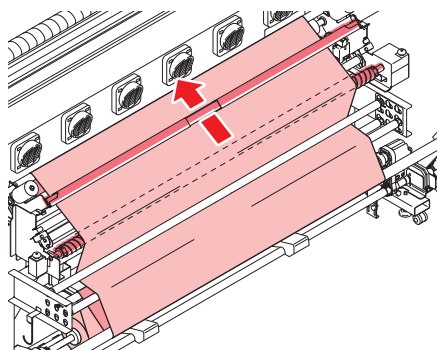


(1) Load media, referring to the media path.

- Pass the media over the tension and reversing bars to ensure suitable tension.

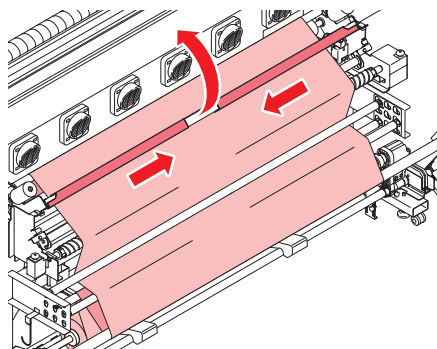


- Pass the media over the smoothing roller and curved bar, then under the pressure roller handle.



(2) Holding the handle with both hands, slide the locking sliders on the left and right inward, then slowly lower the pressure roller.

- The media is now held in place.



- If you are not using the smoothing roller, refer to ["Removing the smoothing roller and shifting coils"\(P. 84\)](#), or if you are not using the curved bar, refer to ["Using the curved bar to make sagging media taut"\(P. 83\)](#).



- Be careful when handling the pressure roller, which is heavy.

12 Press the [ENTER] key.

- The feeding tension bar is activated to detect and adjust media tension on the feeding side.
- After media detection on the feeding side, the media take-up diameter is detected.



- 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)

13 Smooth out any wrinkles in the media and configure peeling settings.

- Press to select ON or OFF, then press the [ENTER] key.



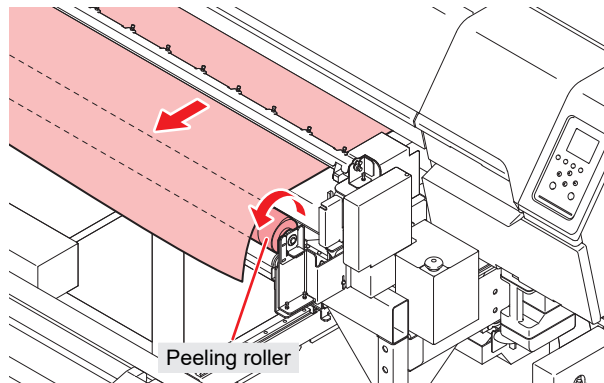
- "Loading media when using peeling"(P. 78)
- "Loading media without using peeling"(P. 79)



- This screen is not displayed if the take-up unit is set to OFF in the options for roll unit selection.

14 When a message indicates to load media in the take-up unit, press .

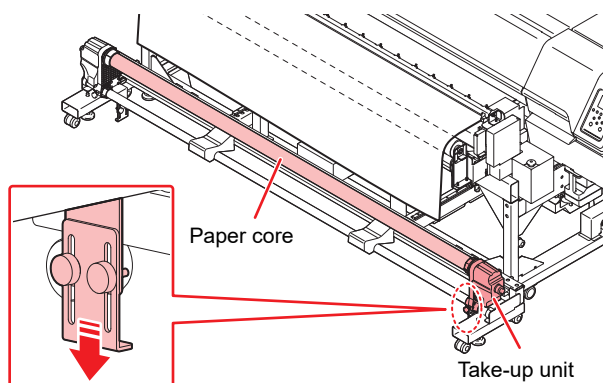
- The feeding belt moves, and media is fed toward the front of the machine.
- Feed media while manually rotating the peeling roller.



15 When the media reaches the take-up unit, release to stop feeding the media.

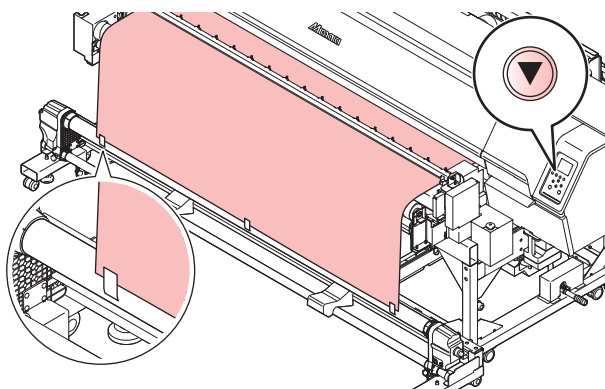
16 Load the empty paper core in the take-up unit and adjust the take-up legs to stabilize them on the floor.

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



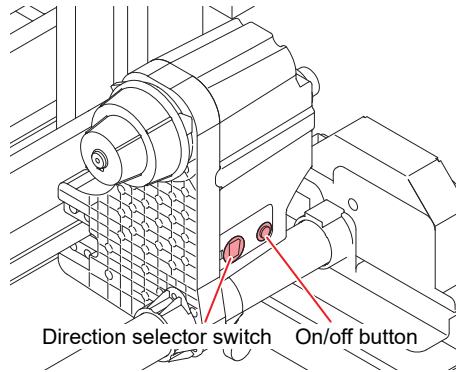
17 Secure the media on the take-up unit.

- (1) Secure the middle of the media with adhesive tape.
 - If necessary, press ▼ to feed the media.
- (2) Secure the left and right sides the same way.
 - Pull the left and right sides of the media evenly, making sure it is not loose or wrinkled, then secure it with tape.



- 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.

18 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 switching off the on/off button at right.
 - 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.

19 Press the [ENTER] key.

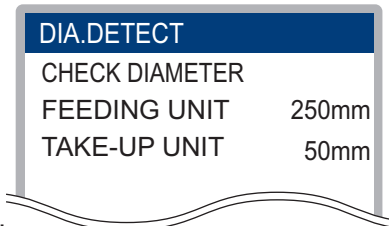


- After loading media, print a job and confirm that tension is applied to the media correctly. White or black streaks in printed images indicate that the tension is not suitable for the media loaded.
Reposition the reversing bar or adjust the weight of feeding tension bar. Keep checking until these parts are correctly positioned.

20 Set the take-up diameter.

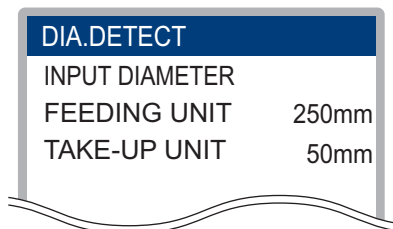
- When the take-up diameter detection in the options is set to "AUTO" (☞ P. 109), the media take-up diameter is automatically detected after the media is loaded.

(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.

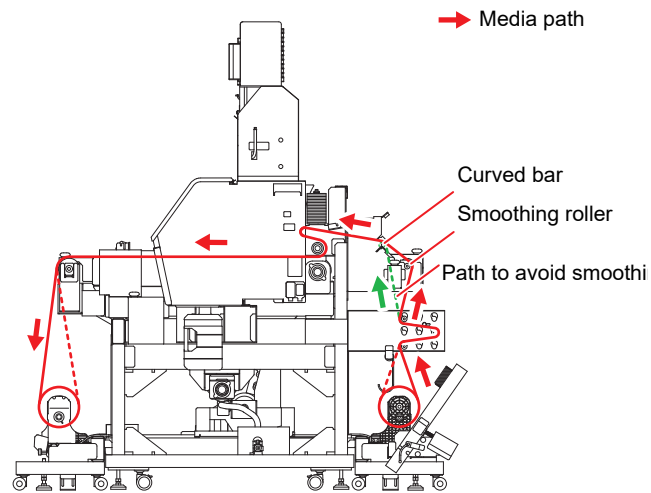


- (1) Enter the take-up diameter of the feeding unit.
- Press ▲▼ to select the feeding unit, then press the [ENTER] key.
 - Press ▲▼ to enter the media outer diameter (diameter) of the feeding unit, then press [ENTER] key.
- (2) Enter the take-up diameter of the take-up unit.
- Press ▲▼ to select the take-up unit, then press the [ENTER] key.
 - Press ▲▼ 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. 109), enter the take-up diameter using the procedure above.

● When using media that does not stretch easily



- It is advisable not to use the smoothing roller with media that does not stretch easily. Remove the smoothing roller before loading the media. ["Removing the smoothing roller and shifting coils"\(P. 84\)](#)
Otherwise, you can load the media to follow a path that bypasses the smoothing roller.

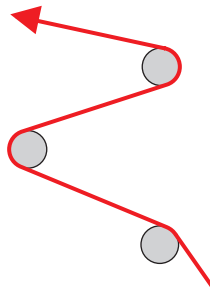


Adjusting the reversing bars

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

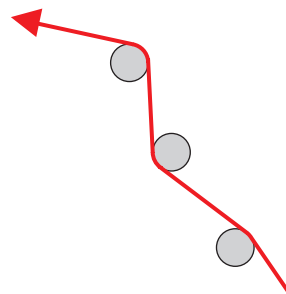
● Adjustment if media is too loose

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.



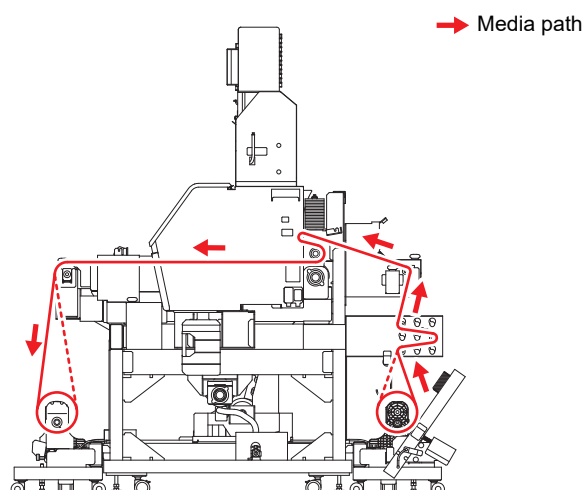
Loading roll media without using tension bars

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



- When loading roll media without using tension bars, replace the direct-connection unit on the feeding unit with an included torque limiter. ["Replacing the direct-connection unit/torque limiter"\(P. 56\)](#)
- 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 feeding belt 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. ["Adjusting the reversing bars"\(P. 76\)](#)

- 1 Close the front cover and press the [FUNC2 (MEDIA)] key.**
 - A screen is displayed for selecting use of tension bars.
- 2 Select how tension bars will be used, which is based on how the media is loaded.**
 - In this case, select OFF.
 - (DC: direct-connection unit, TL: torque limiter, --: unit off)
 - Press to select OFF, then press the [ENTER] key.

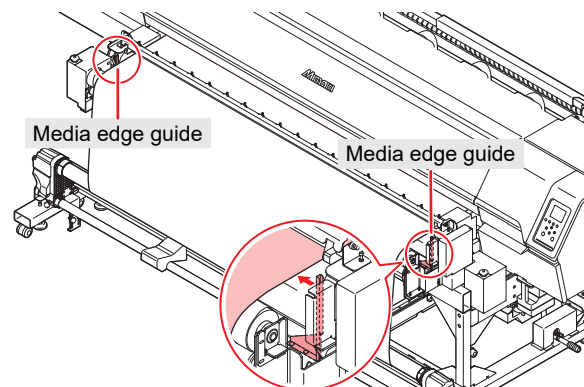


- This screen is not displayed if the feeding unit is set to OFF in the options for roll unit selection.

- 3 Load the media on the feeding side.**
 - Follow steps 3–9 in ["Using the tension bars"\(P. 66\)](#).
- 4 Feed the media to the take-up side and load an empty paper core in the take-up unit.**
 - Follow steps 11–16 in ["Using the tension bars"\(P. 66\)](#).
- 5 Secure the media to the paper core.**
 - Follow steps 17–19 in ["Using the tension bars"\(P. 66\)](#).
- 6 Set the take-up diameter.**
 - Follow step 20 in ["Using the tension bars"\(P. 66\)](#).

Setting the media edge guides

- 1 After loading media, move the media edge guides on the left and right sides until they touch the edges of the media lightly.**






- Set the guides so that the media edges rise 5 to 10 mm.
- Be careful not to overtighten media end guide knob screws, which may bring the guides into contact with the belt.

Loading media when using peeling





- When using peeling with the take-up unit, make sure a direct-connection unit is attached to the take-up unit. If a torque limiter is attached, replace it with a direct-connection unit as described in the following section.
 ["Replacing the direct-connection unit/torque limiter"\(P. 56\)](#)
- Interfering with the peeling sensor when loading media may cause an error to be displayed or may activate the take-up unit.
- Using media that clings strongly to rubber tape may cause feeding problems. In this case, peel off the rubber tape before use.

● Loading media in the take-up unit

1 Press the [FUNC2 (MEDIA)] key and load the media in the feeding unit.

- For details, refer to the following section.
 ["Using the tension bars"\(P. 66\)](#) or  ["Loading roll media without using tension bars"\(P. 76\)](#)

2 Activate the peeling function.

- Press   to select ON, then press the [ENTER] key.



- This screen is not displayed if the take-up unit is set to OFF in the options for roll unit selection.

Loading media without using peeling



- Take-up using a torque limiter may not be possible when using media that clings strongly, or if the paper core on the take-up side is warped due to heavy media. In this case, we recommend activating peeling and using a direct-connection unit for take-up.
- When using the take-up unit without peeling, replace the direct-connection unit attached to the take-up unit with a torque limiter. ["Replacing the direct-connection unit/torque limiter"\(P. 56\)](#)

● Loading media in the take-up unit

1 Press the [FUNC2 (MEDIA)] key and load the media in the feeding unit.

- For details, refer to the following section.
 ["Using the tension bars"\(P. 66\)](#) or ["Loading roll media without using tension bars"\(P. 76\)](#)

2 Deactivate the peeling function.

- Press to select OFF, then press the [ENTER] key.



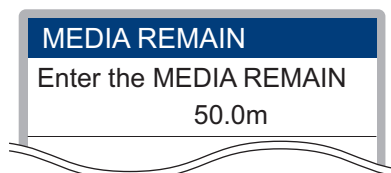
- This screen is not displayed if the take-up unit is set to OFF in the options for roll unit selection.

3 Secure the media on the take-up unit.

- For details, refer to steps 12 to 17 in ["Using the tension bars"\(P. 66\)](#).

● Entering the remaining amount of media

1 Display the screen for entering the remaining amount of media.



2 Press to enter the amount of media remaining.

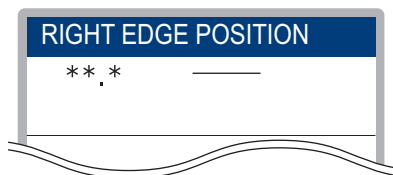
3 Press the [ENTER] key.

● Media width setting

Set the media width as follows.

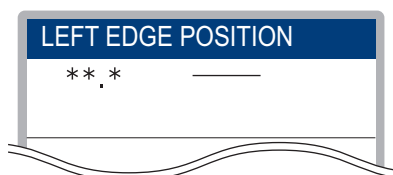
1 Press ◀▶ to move the LED pointer to the right edge of the media.

- Press ◀▶ to move the carriage and align the light from the built-in LED pointer with the right edge of the media.



2 Press the [ENTER] key.

- Next, a screen is displayed for entering the position of the left edge of the media. This screen is not displayed and the setting is finished if you select media width input mode in step 2.



3 Press ◀▶ to move the LED pointer to the left edge of the media.

- As in step 3, align the light from the LED pointer with the left edge of the media.

4 Press the [ENTER] key.



- If you are not using overprinting, be careful not to set the position outside of the media area, which may result in printing off the media surface.

● Resetting media settings

Do the following before loading media again if you will change the print area setting or use different media.

1 In local mode, press the [SEL] key, then press [FUNC2 (MEDIA)].

2 Press the ▲▼ keys to select how to reset the media, then press the [ENTER] key.

- The following two options are available for resetting media settings.
 - (1) Width only: Reset only the print area (width) setting.
 - (2) All: Reset all media detection information.

3 Press the [ENTER] key.

Adjusting pressure roller weight

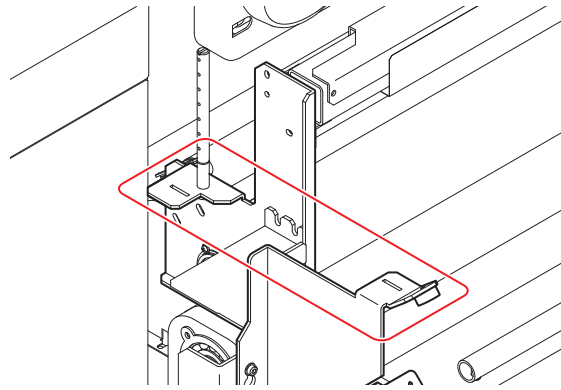
Adjust the pressure roller weight if the media clings strongly and cannot be peeled off, or if it clings weakly and lifts up.

● Adjustment if media clings strongly

Attach the included springs in the area outlined in red in the figure (at left and right).

- Springs for strong pressure roller adjustment: 2 pcs.

- Springs for slight pressure roller adjustment: 2 pcs.



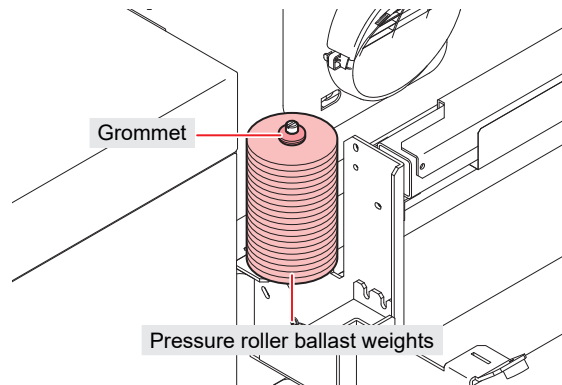
● Adjustment if media clings weakly

Attach the included weights in the area outlined in red in the figure (at left and right).

- Pressure roller ballast weights: 40 pcs. (20 for each side)



- Always attach the included grommet after loading weights.

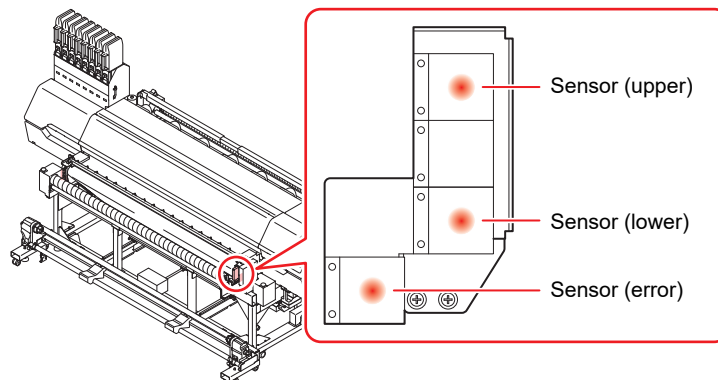


Adjusting the peeling sensor position

Depending on the type of media and the condition of the adhesive, media may not be peeled off correctly. Check the positions of the peeling sensors and adjust them as needed.

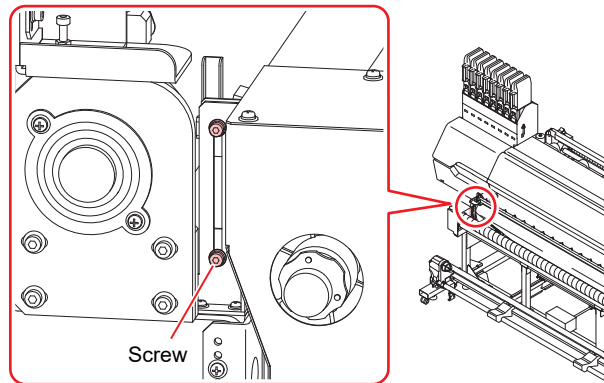
1 Check the positions of the peeling sensors.

- Check where light from the peeling sensors strikes the reflectors on the right side of the machine.



2 Reposition the sensors as needed.

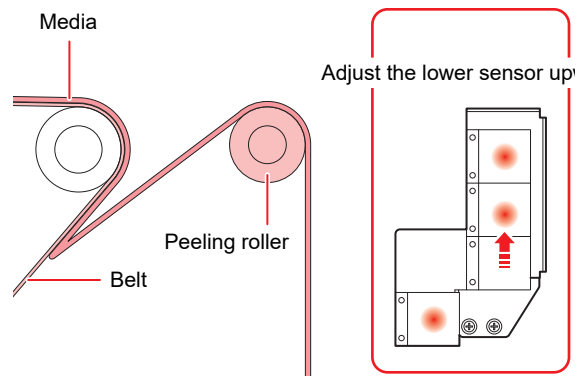
- Referring to the figures, loosen the two screws on the peeling sensor section and reposition the sensors.



Recommended sensor positions

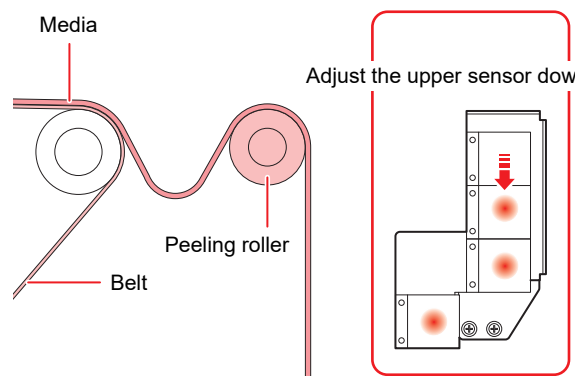
● Adjustment if media clings strongly

Adjust the lower sensor upward to avoid false detection of sensor errors.



● Adjustment if media clings weakly (especially with large-diameter rolls)

Adjust the upper sensor downward.



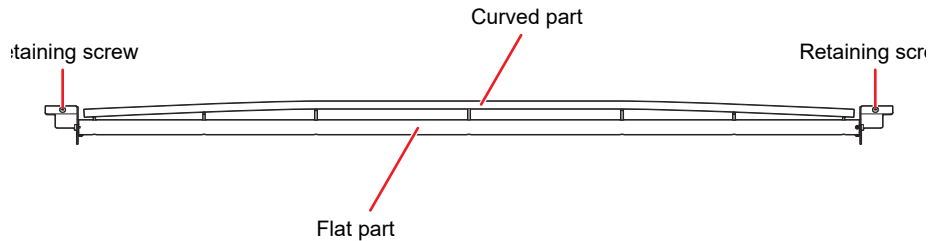
- For consistent detection, adjust sensor positions so that the light shines within approx. 5 mm from the edge of each reflector.

Using the curved bar to make sagging media taut

Always use the curved bar to make sagging cloth media taut if gummed left and right media edges are quite short compared to the center. (In this case, the center sags significantly when the media is spread out on the floor).



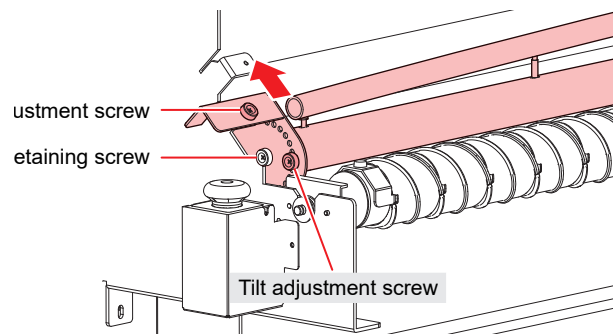
Angular adjustment of the curved bar



- The position of the curved part of the bar (which determines the angle it forms) must be adjusted to suit the condition of cloth media.
- With cloth media loaded, adjust so that the left and right edges of media sag only slightly by the curved bar.
- Change the angle formed by the curved bar to suit the condition of the media.
 - (1) Flat part: Normally, this part is used.
 - (2) Curved part: Used for cloth media that sags in the center.



- When using the curved bar, load the media based on the center.



- (1) Height adjustment screw: Sets the curved bar one level higher if the bar does not eliminate sagging in the center of the media.
- (2) Tilt adjustment screw: Adjusts the angle of the curved bar according to the condition of the media.

1 Remove the tilt adjustment screw on the side of the curved bar and adjust the bar angle.

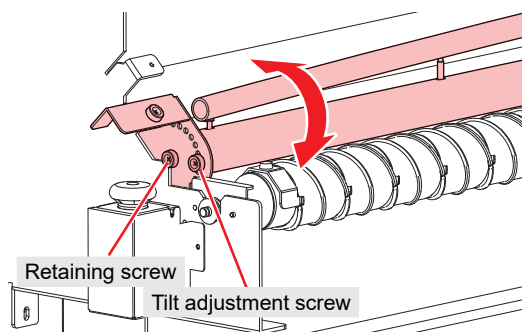
- (1) Remove the tilt adjustment screw and loosen the retaining screw.
- (2) Rotate the curved bar to adjust the amount in contact with media.
- (3) Secure the curved bar with the tilt adjustment and retaining screws.

2 Set the curved bar one level higher if the bar does not eliminate sagging in the center of the media.

● When the curved bar is not used



- If the curved bar will not be used, remove both tilt adjustment screws (at left and right) and loosen the retaining screws (at left and right). Next, rotate the curved bar so that it no longer touches the media, then retighten the screws.



- Do not remove the curved bar, even when it is not used. This may allow media surfaces to interfere with each other when the pressure roller is lowered.

Removing the smoothing roller and shifting coils

The smoothing roller prevents wrinkles from forming when cloth media is applied to the feeding belt by the pressure roller. Normally, cloth media is placed in the center. Even narrow cloth should always be placed in the center of the feeding belt.

However, in the following cases, you can reposition the center of the cloth by shifting smoothing roller coils.

- To reduce printing time by loading cloth toward the right side
- To extend the useful life of adhesive by loading cloth normally used at widths of 800 mm or less toward the left or right edge



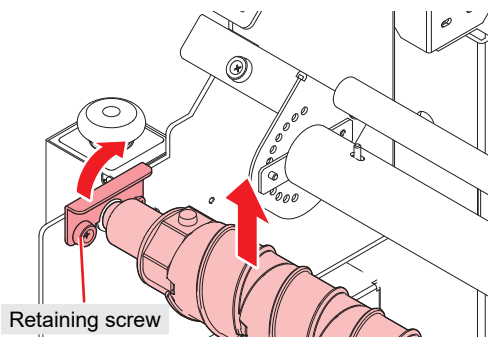
- Keep your hands and clothes away from the smoothing roller while it is in use. Getting caught in the roller poses a risk of fractures or other injury.



- Wide cloth media with thin or frayed edges poses a risk of getting caught on the thumbscrews at each end of the smoothing roller. Cut the edges of this media before loading it.

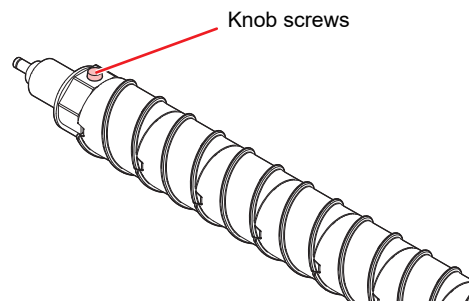
1 Remove the smoothing roller thumbscrew on the left side of the back of the machine, then remove the smoothing roller.

- To remove, lift and slide left.



- Tilt the end of the shaft up when removing. Otherwise, the smoothing roller may come off and damage the machine.

- 2** Loosen the knob screws on the left and right ends of the smoothing roller and shift the coils as needed.

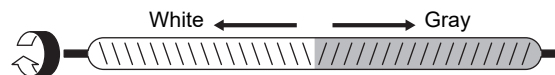


- See "Shifting Coils" for details on shifting coils.

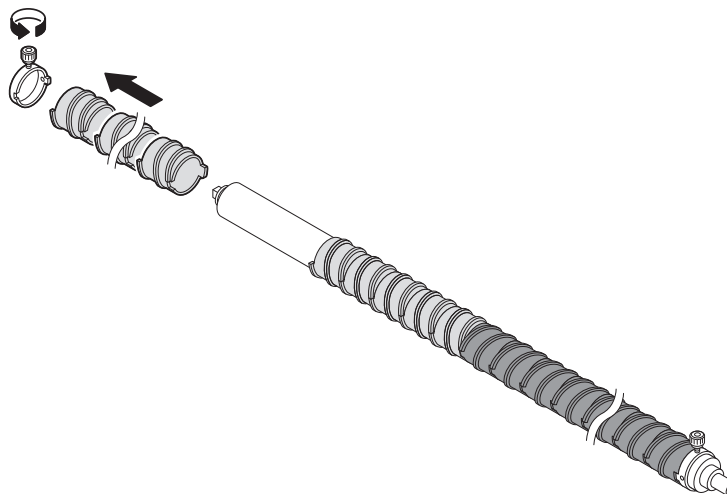
- 3** Reinstall the smoothing roller.

● Shifting coils

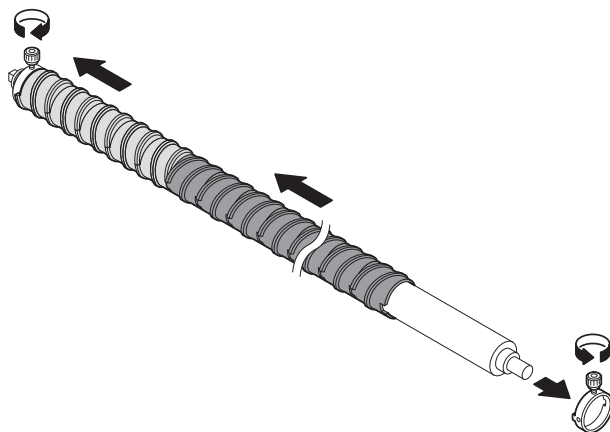
You can reposition the central area of the coils as shown in the following figure. Smoothing coils are color-coded based on the direction of rotation.



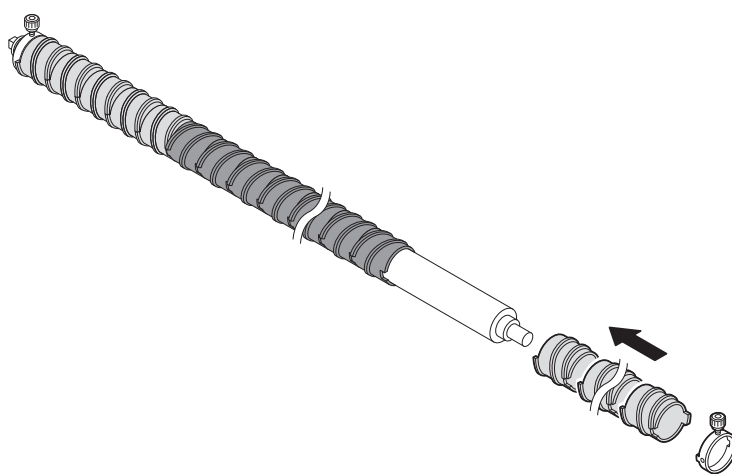
- 1** Remove knob screws, then remove enough coils from the left end to reposition the center as desired.



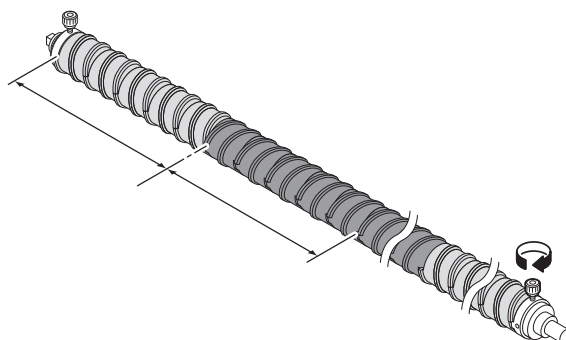
- 2** Slide coils left to fill up the empty space, tighten the knob screw, then remove the knob screw on the right end.



- 3** Using the coils removed in step 1, add the coils to the shaft from the right end.



- 4** Tighten the knob screw.



The central area of the coils has now been repositioned.

Registering the Media

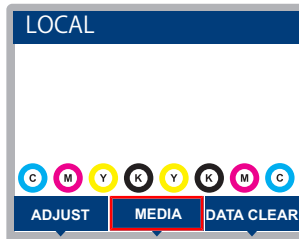
Registration is required to use media that is not registered on the machine.



- To set print conditions for a single use, select "Temporary". The conditions set in "Temporary" are cleared when the machine is restarted.

1 Perform a media reset to reconfigure the media.

- (1) On the LOCAL mode screen, select [MEDIA].

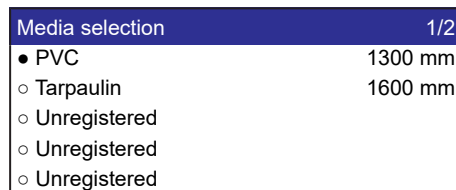


- (2) Select [Width only] as the media reset method.



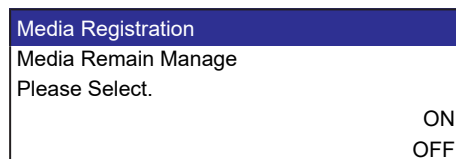
- Width only: Initializes origin information only.
- All: Initializes the media type and other settings.

2 Select [Unregistered].



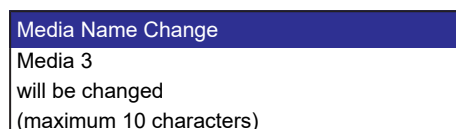
3 Select the method for managing the media remaining amount.

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

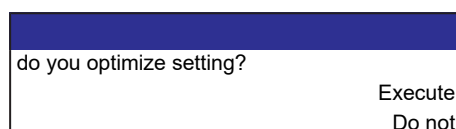


4 Enter the name to be displayed.


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




5 Select whether or not to register the set information.



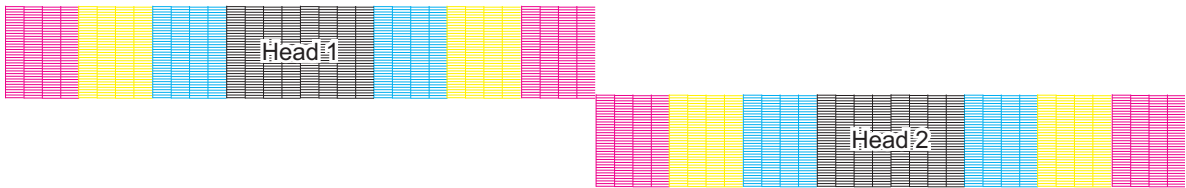




- You can change the settings later.  ["Media Setting Menu"\(P. 102\)](#)
-




2.5 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"\(P. 91\)](#)

[For Sb420 ink]

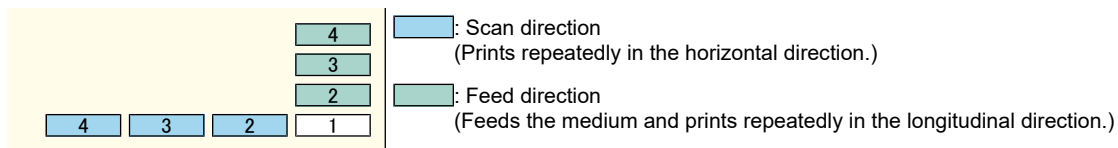


Check beforehand
<ul style="list-style-type: none">• Was the print head adjusted?  "Adjusting Print Head Height"(P. 51)• Is media loaded?  "Loading the Media"(P. 55)

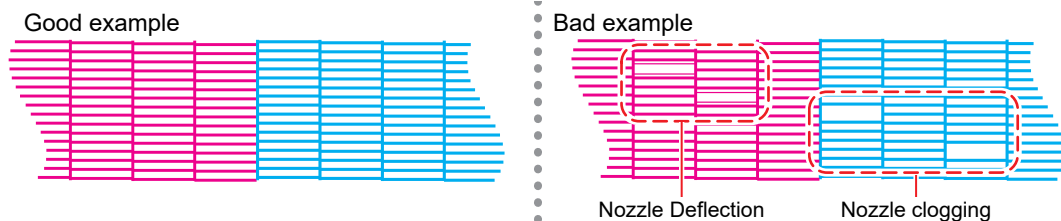
- 
 - Load media at least 500 mm wide. You cannot print the entire pattern if media less than 500 mm wide is used.
- 
 - Select [Maintenance] > [Nozzle Recovery] > [Test Print], then select "ON" to perform nozzle recovery and test printing.
Registration is required to perform nozzle recovery.  ["Registering Nozzle Recovery"\(P. 107\)](#)

Changing the Layout Direction for Test Printing

You can change the layout direction for test printing.



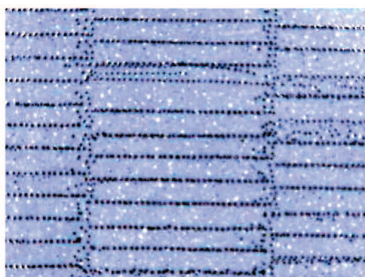
- 1** On the LOCAL mode screen, select [TEST PRINT/CLEANING] > [Test Print], then press the [ENTER] key.
 - The Test Print menu is displayed.
- 2** Select [Scan Dir.] or [Feed Dir.], then press the [ENTER] key.
 - Test printing starts.



- 3** Check the print results.

Ejection Failures

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.



Nozzle Deflection



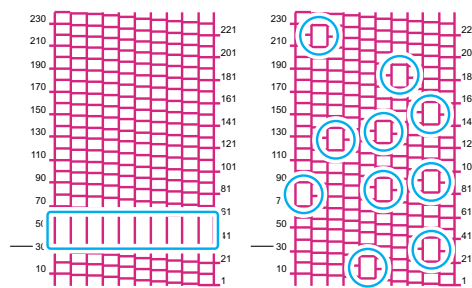
Nozzle clogging



Ink drips




Mist



Mixed air

2.6 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"\(P. 118\)](#)

Print Head Nozzle Washing

 ["Wiper Cleaning"\(P. 120\)](#)

2.7 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"\(P. 55\)](#)
- 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 the Roll Media"\(P. 66\)](#)

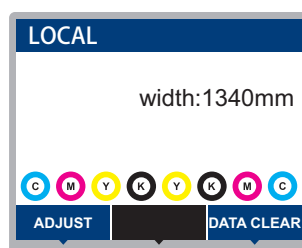
Feed Correction Procedure

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"\(P. 65\)](#)
Check and adjust around the center of the machine.

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

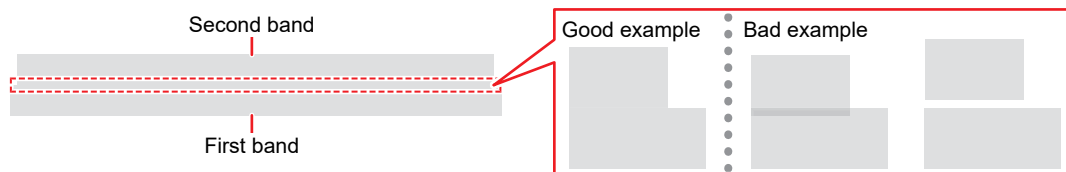


2 Select [Feed Comp.], then press the [ENTER] key.

- 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.

2.8 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
<ul style="list-style-type: none">Was the print head adjusted? "Adjusting Print Head Height"(P. 51)Is media loaded? "Loading the Media"(P. 55)

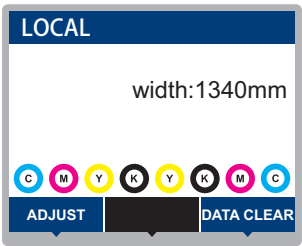
-
- Load media at least 500 mm wide. You cannot print the entire pattern if media less than 500 mm wide is used.

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"\(P. 65\)](#)
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.

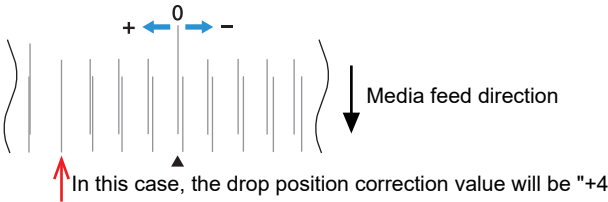
3 Select the resolution, then press the [ENTER] key.

- Select the resolution to be adjusted. When "All" is selected, correction patterns for all resolutions will be printed. ["Media Setting Menu"\(P. 102\)](#)

-
- 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"\(P. 51\)](#)
-

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

2.9 Preparing RIP data

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



- Prepare suitable image data for printing.

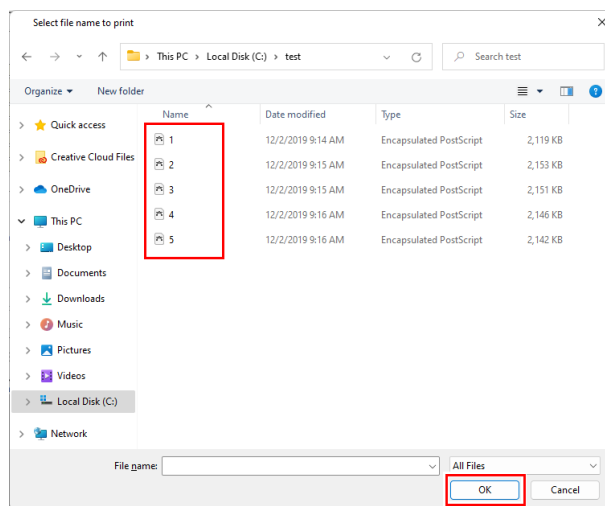
1 Launch RasterLink.

- Click the icon on the PC desktop.



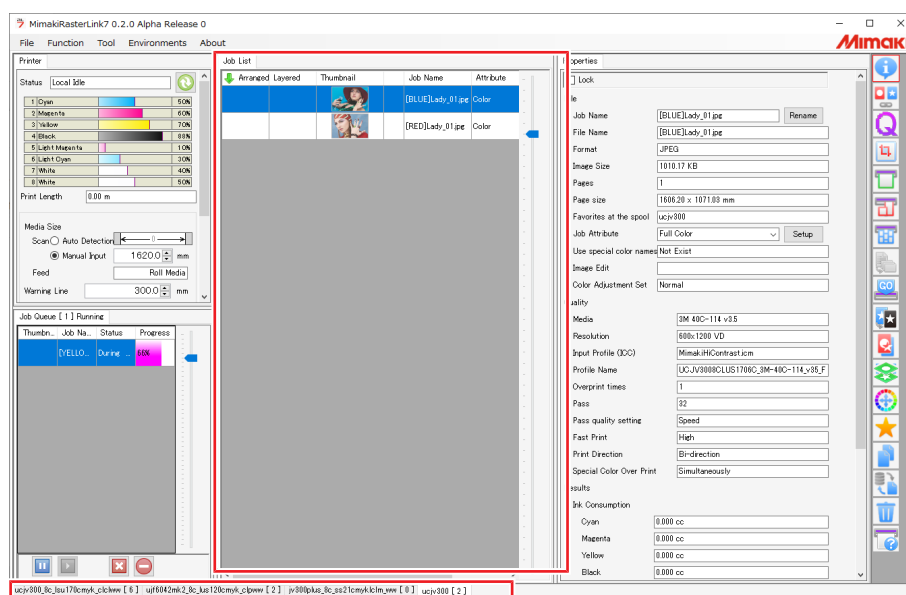
2 Select the image data to print.

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



3 Select the image data imported.

- The image data is added in the tab for Tx330-1800B 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"\(P. 99\)](#)

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



- Media width must be reacquired after replacing media.
 - Select the tab for Tx330-1800B in the main window.
 - Click  (Update the printer status) in the Printer tab.

2.10 Printing

Check beforehand

- Was the print head adjusted? 🛠️ ["Adjusting Print Head Height"\(P. 51\)](#)
- Is media loaded? 🛠️ ["Loading the Media"\(P. 55\)](#)
- 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 the Roll Media"\(P. 66\)](#)

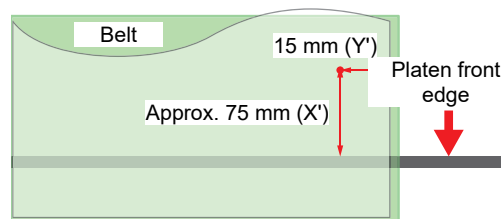


- Condensation may form on the print head nozzle surface depending on the ambient temperature and humidity. The formation of condensation may cause ejection failures (e.g., nozzle clogging or deflection). Perform head cleaning if any ejection failures (e.g., nozzle clogging or deflection) occur during printing. 🛠️ ["Head Cleaning"\(P. 91\)](#)

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. 75 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 ▲▼◀▶.

- The Origin Setup screen appears.

2 Press ▲▼◀▶ to move the origin to the desired position.

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



- The machine cannot feed media backward.

3 Press the [ENTER] key.

- The origin is updated.

Starting Printing

1 Send the RIP data from the PC.

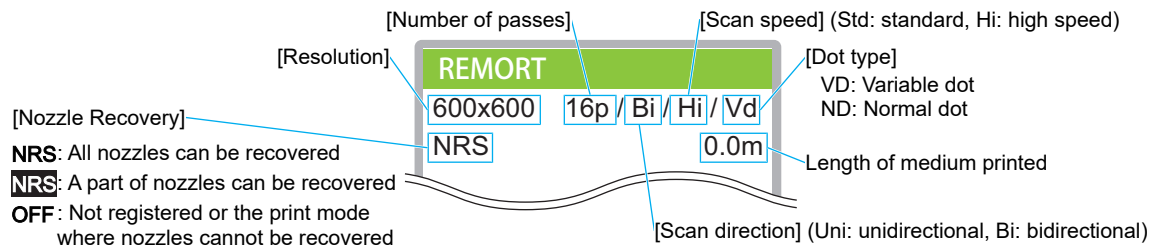
-  "Preparing RIP data"(P. 96)



- 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].

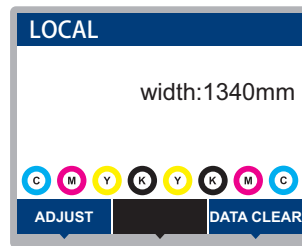
- Printing resumes.



- 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	102	Function Setting Menu	109
Maintenance Menu	104	Environment Setting Menu	111
Registering Nozzle Recovery	107	Machine Status Menu	113
Nozzle Check	108		

3.1 Media Setting Menu



When you use the machine for the first time, the Select Use Media screen is displayed.  ["Registering the Media"\(P. 87\)](#) 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. 92)
Drop.PosCorrect		-	-	Corrects the drop position for bi-directional printing.  "Correcting the Drop Position"(P. 94)
	(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. <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]
	Feed Comp.	-	-	
	Drop.PosCorrect	-	-	
	(Resolution)	*	-	
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 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/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	0 to 500 m	-	Enter the roll media length.
	Stop Printing	<u>ON/OFF</u>		Setting to "ON" stops printing when the Media Remain value reaches 0.
Detail Setting		-	-	This is used to set various functions.
	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.
	Belt Comp.	<u>ON/OFF</u>		Set to reduce uneven feeding and improve print quality.
	Belt Wash			
	Belt Wash	<u>ON/OFF</u>		Sets whether belt washing is performed automatically.
	Belt Feed Speed	<u>Normal</u> /Low		Sets the feed speed for purposes other than printing, such as feeding activated by the ▼ key, or checking the feed.
	Counter Limit			
	Adhesive	<u>OFF</u> , 1 to 30000 m		Sets the approximate replacement time.
	Absorption Roller	<u>OFF</u> , 1 to 30000 m		Sets the approximate replacement time.
	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.
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. 118)  "Wiper Cleaning"(P. 120)  "Adjusting Print Head Height"(P. 51)
	Move To Maint. Space	-	Cleans around the print head.  "Carriage Underside Cleaning"(P. 119)  "DAS (Automatic Correction Function) Sensor Cleaning"(P. 123)
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
Pump Tube Cleaning		-	Washes the suction pump tube (below the cap).  "Ink Discharge Channel Cleaning"(P. 124)
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. 150)
Replace Wiper		-	Use this function when replacing the wiper. Replacing the wiper resets the wiper usage counter.  "Wiper Replacement"(P. 154)
Cap Replacement		-	Use this function when replacing the cap. Replacing the cap resets the cap usage time stored in the machine.  "Cap Replacement"(P. 157)
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. 89)
Cleaning		-	Several head cleaning methods are available. Choose the head cleaning method based on test print results.  "Head Cleaning"(P. 91)
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. 107)
	Entry	-	Registers the nozzle without printing a pattern.
	Reset	-	Initializes the details set.
	Test Printing	ON/ OFF	Sets whether to perform nozzle recovery before test printing.
Nozzle Check		-	 "Nozzle Check"(P. 108)
Printing Check		ON/ OFF	Performs nozzle clogging detection before printing starts.

Item		Setting ^{*1}	Details
	Check Interval	-	Sets the nozzle clogging detection timing.
	Length	0.1 to 30.0 to 100.0 m	Performs nozzle clogging detection after the length set is reached and before the next print starts.
	File	1 to 30 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	Stop / Continuous	Select whether to stop or continue printing if "Nozzle clogging" is detected.
	Action	Off/1 to 10 to 100	Performs nozzle recovery (cleaning followed by nozzle checking) if "nozzle clogging" is detected.
	Cleaning	Soft /Normal/ Hard	Sets the cleaning type.
	Retry Count	0 to 3 times	Performs nozzle recovery (cleaning followed by nozzle checking) for the specified number of times.
	Auto Nozzle Recovery	ON/ OFF	Performs nozzle recovery automatically if "nozzle clogging" is detected. See below if you wish to perform nozzle recovery manually.  "Registering Nozzle Recovery"(P. 107)
Judgment Condition		OFF / 1 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. 163)
	Refresh	0.5/ 1.0 h	Sets the refresh interval (when a small amount of ink is ejected from the print head nozzles).
	Pump Tube Cleaning	OFF/ 48h /1 to 168 h	Sets the interval for washing the suction pump tube (below the cap).
	Cleaning Interval	1 to 48 h	Sets print head cleaning intervals. This will help prevent nozzle clogging.
	Type	Normal /Soft/ Hard	Sets the cleaning type for head cleaning.
Print Maint.		-	Sets the maintenance to be performed automatically midway during printing.
	Auto Cleaning	-	Sets the conditions to perform head cleaning after the preset number of files are printed.
	Setup	File/Length/ Time /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.
	Type	Normal /Soft/ Hard	Sets the cleaning type for head cleaning.

Item		Setting ^{*1}	Details
	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. 163)
	Reset Waste Ink Tank Volume	-	Resets the waste ink tank usage count. "Replacing the lower-left waste ink tank"(P. 163)
	Adjust Waste Ink Volume	-	Corrects the waste ink tank usage count. "When "Check Waste Ink Tank" message appears"(P. 163)
	Tank Capacity	-	Displays the waste ink tank capacity.
Air PG		-	Expels any air in the ink paths. • Use this if Ink End is still displayed after ink replacement.
Belt Maintenance		-	
	Belt Washing Unit	-	Moves the washing unit to the maintenance position and cleans the washing brush and inside the tray. "Washing Unit Maintenance"(P. 131)
	Belt Adhesive	-	"Reapplying Adhesive"(P. 136)
	Peeling Off Adhesive	-	Performs the steps for peeling off the adhesive.
	Applying Adhesive	-	Performs the steps for applying adhesive.
Belt Cleaning		-	Cleans the feeding belt. "Cleaning the Feeding Belt"(P. 147)
Replace Water		-	"Washing Water Replacement"(P. 130)
	Drain	-	Drains washing water from the washing unit.
	Supply	-	Supplies washing water to the washing unit.
	Cleaning Wash Tray	-	Cleans the washing tray and brush.
Counter Reset		-	"Resetting the Counter"(P. 149)
	Adhesive	-	Initializes the counter for notification.
	Absorption Roller	-	Initializes the counter for notification.

*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).

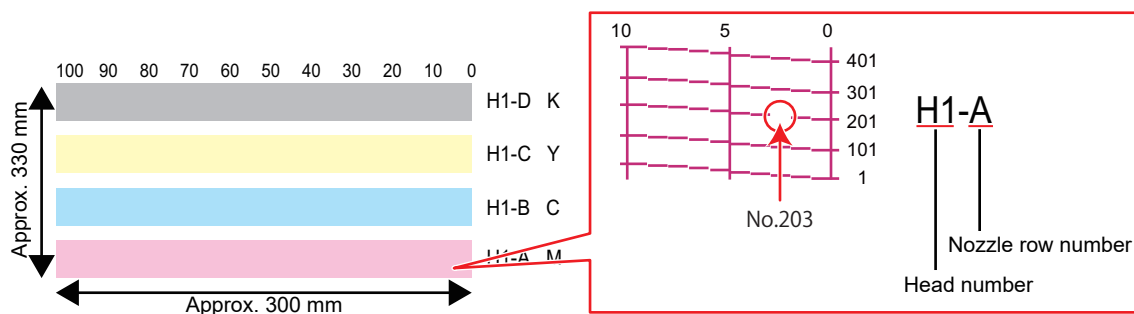


- Nozzle recovery can be specified for up to 20 nozzles per row. The time taken for printing remains unchanged even when nozzle recovery is set.

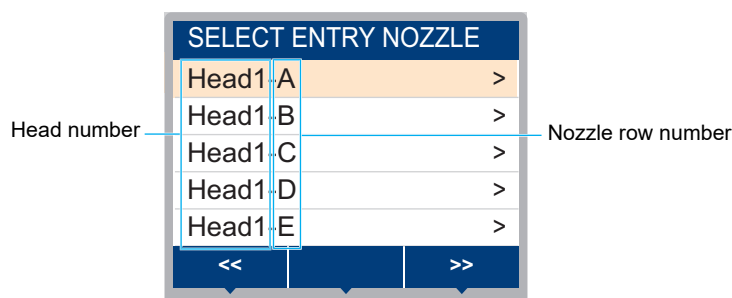


- Load media at least 500 mm wide. You cannot print the entire pattern if media less than 500 mm wide is used.

- 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.

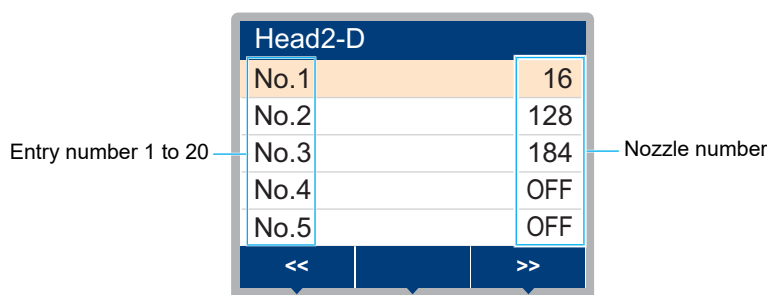


- 4 Select the "head number and nozzle row" for nozzle recovery, then press the [ENTER] key.**



- 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.



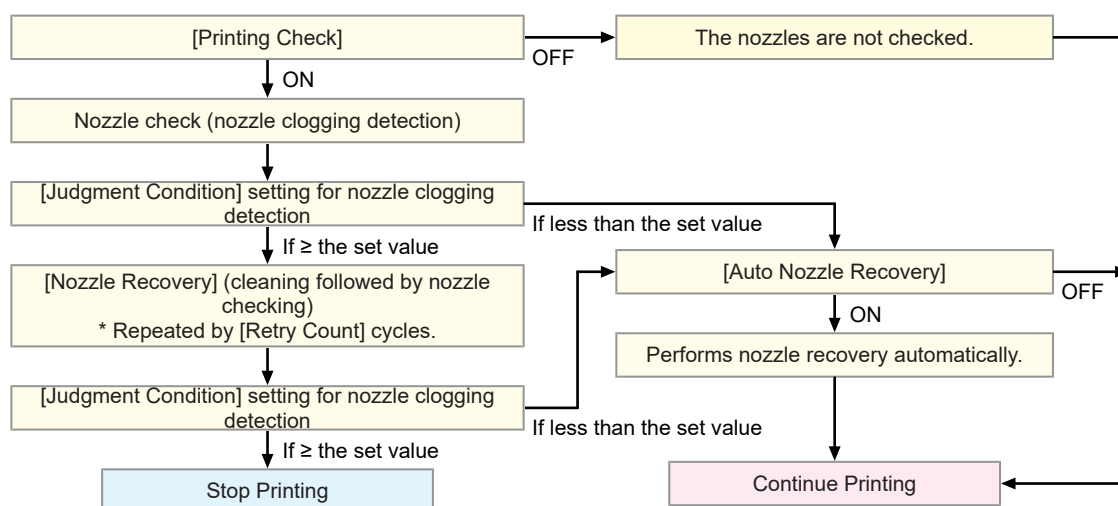
6 Press the [ENTER] key once entry is complete.



- Select [Maintenance] > [Nozzle Recovery] > [Test Print], then select "ON" to perform nozzle recovery and test printing. ["Test Printing"\(P. 89\)](#)

Nozzle Check

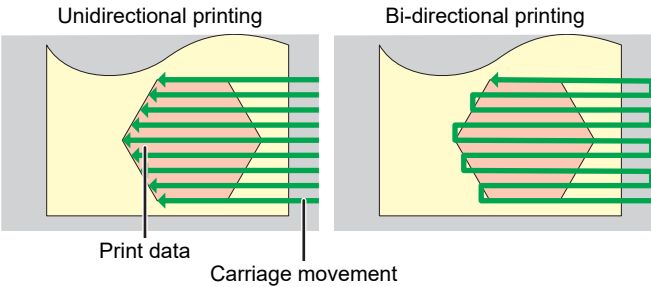
This is used to check for nozzle clogging before printing starts. Sets whether to perform maintenance functions automatically if nozzle clogging is detected.



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 <div>  </div>
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.
Peeling	<u>ON</u> /OFF	Displayed when the take-up unit is on. Set to "OFF" if peeling is not performed.
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>
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 15 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.
Setup	<u>ON</u> / <u>OFF</u>	Sets whether to turn on or off the power.
Time	0:00 to 23:59	Sets the time to turn on the power.

Item			Setting ^{*1}	Details	
		Day	Monday to Sunday	Sets whether to turn on or off the power on each day of the week.	
		Nozzle Check		<u>ON</u> /OFF	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</u> /OFF	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 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		-		
		Margin/Left	<u>Host</u> /-10 to 85 mm		
		Margin/Right			
View Feed			<u>ON</u> /OFF	Sets whether or not to feed the media forward to view the print results—for example, during test printing.	
Auto Remote			<u>ON</u> /OFF	Sets whether to automatically switch to REMOTE mode and start printing if data is received locally.	

*1. The default settings are shown underlined.

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) • 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. • 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. • 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. • 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. • This can be set when both [DHCP] and [AutoIP] are disabled.
Default Gateway	-	Sets the default gateway used by the machine. • This can be set when both [DHCP] and [AutoIP] are disabled.
DNS Address	-	Sets the DNS server address used by the machine. • This can be set when both [DHCP] and [AutoIP] are disabled.
Sub Net Mask	-	Sets the subnet mask used by the machine. • 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	The number of wiping cycles is displayed. <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.
	Waste Ink Tank	Displays the approximate level of waste ink in the waste ink tank as a percentage. To reset waste ink levels, press the [FUNC1] key while the level is displayed.
	Capping Use Days	Displays the number of days since the cap was replaced.
	Adhesive	Displays the feed distance since adhesive was applied.
	Absorption Roller	Displays the distance representing use of the absorption roller.
Maintenance History	Maintenance	Displays a record of maintenance function execution (up to 10). <ul style="list-style-type: none"> Cleaning  P. 91, Pump Tube Cleaning  P. 124, Nozzle Washing Print Head Nozzle Washing
	Replace Wiper	Displays a record of wiper replacement (up to 5).  P. 154
	Ink replacement	Displays a record of ink pack replacement for each ink slot (up to 5).  "Replacing Ink"(P. 42) <ul style="list-style-type: none"> Slot 1 to 8
	Cap Replacement	Displays a head cap replacement history.  "Cap Replacement"(P. 157)
Version		Displays the machine firmware and other versions.
Error History		Displays the error and warning history. <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	116	Replacement of Consumable Item	153
Maintenance Methods	117	Consumable Item Replacement Timing	153
Maintenance Items and Timing	117	Wiper Replacement	154
Ink Maintenance	118	Wiper Cleaner Replacement	155
Cap Rubber Cleaning	118	Cap Replacement	157
Carriage Underside Cleaning	119	Replacing the Absorber Around the Station	159
Wiper Cleaning	120	Blowing Fan Filter Replacement	161
NCU Cleaning	122	Ink Supply Unit Ink Absorber Replacement	162
DAS (Automatic Correction Function) Sensor Cleaning	123	Waste Ink Tank Replacement	163
Ink Discharge Channel Cleaning	124		
Jam Sensor Detecting Plate Cleaning	126		
Peeling Roller Cleaning	127		
Belt Correction Unit Cleaning	127		
Blowing Fan Filter Cleaning	129		
Washing Water Replacement	130		
Washing Unit Maintenance	131		
Reapplying Adhesive	136		
Cleaning the Washing Tray and Brush	146		
Cleaning the Feeding Belt	147		
Cleaning the Peeling Sensor	148		
Resetting the Counter	149		
Cover (Exterior) Cleaning	150		
When this Printer is Left Unused for a Long Time	150		

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. 120)
	Replace the washing water. "Washing Water Replacement"(P. 130)
Every three days, at the start of the work	Shake the ink. "Ink Maintenance"(P. 118)
At the end of the week's work	Clean the cap rubber. "Cap Rubber Cleaning"(P. 118)
	Clean the underside of the carriage. "Carriage Underside Cleaning"(P. 119)
	Check the waste ink levels in the waste ink tank. "When "Check Waste Ink Tank" message appears"(P. 163)
	Clean the peeling roller. "Peeling Roller Cleaning"(P. 127)
	Clean the belt correction unit. "Belt Correction Unit Cleaning"(P. 127)
	Clean the washing unit. "Washing Unit Maintenance"(P. 131) "Resetting the Counter"(P. 149)
	Clean the feeding belt. "Cleaning the Feeding Belt"(P. 147)
	Clean the peeling sensor. "Cleaning the Peeling Sensor"(P. 148)
At the end of two weeks' work	Clean the blowing fan filter. "Blowing Fan Filter Replacement"(P. 161)
Every month	Clean the NCU. "NCU Cleaning"(P. 122)
	Clean the DAS sensor. "DAS (Automatic Correction Function) Sensor Cleaning"(P. 123)
	Clean the jam sensor detecting plate. "Jam Sensor Detecting Plate Cleaning"(P. 126)
	Clean the cover (exterior). "Cover (Exterior) Cleaning"(P. 150)
When not used for more than a week	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. 150)
When the adhesive strength of the feeding belt has decreased	Reapply the adhesive. "Reapplying Adhesive"(P. 136) "Cleaning the Washing Tray and Brush"(P. 146) "Resetting the Counter"(P. 149)

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.

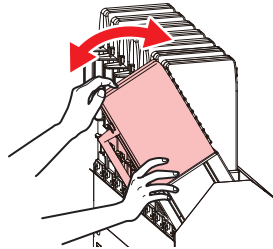
Once every three days.



- **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).

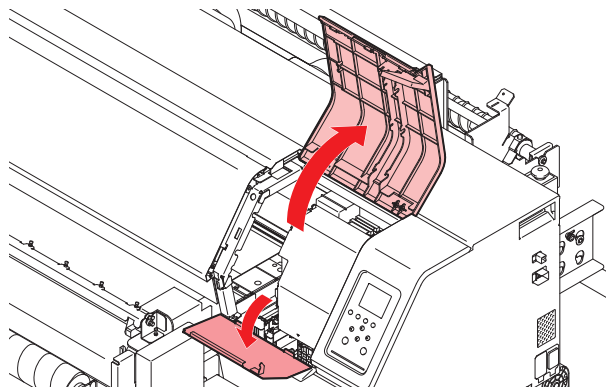
1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

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

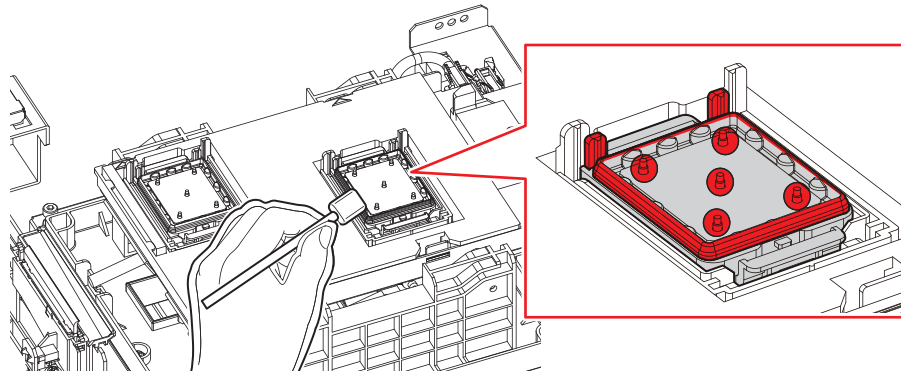
- The carriage moves over the feeding belt.

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).

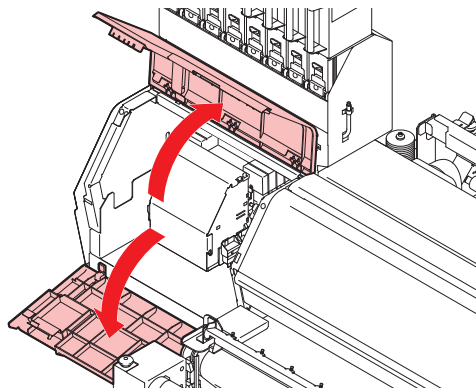
1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- 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.

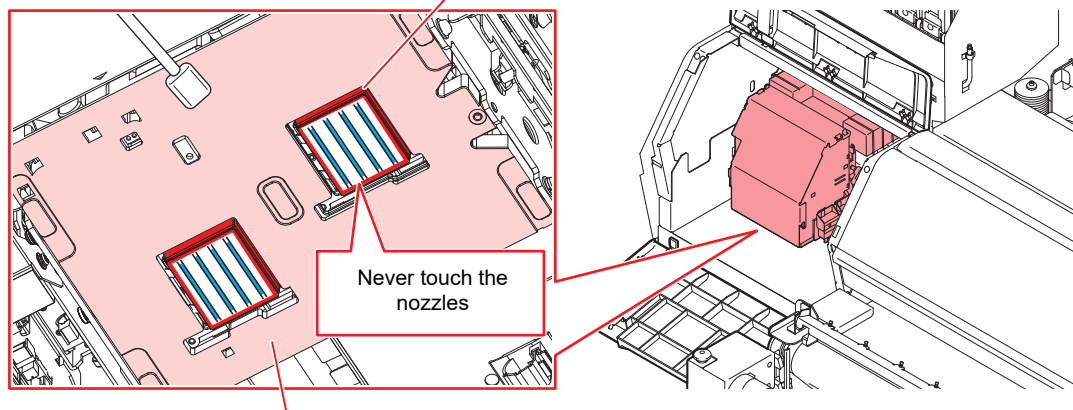
3 Open the maintenance cover on the left side.



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.



Clean using a cleaning stick or soft cloth.



- 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.

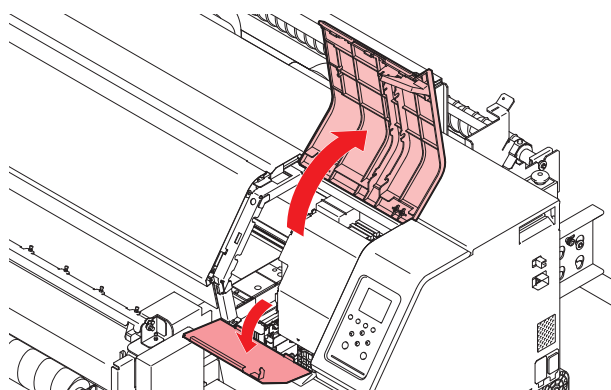
Wiper Cleaning

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).



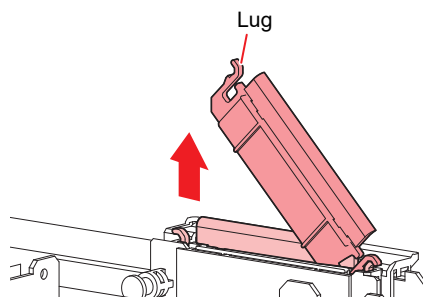
- Be careful to avoid leaving fragments from the cleaning stick behind when cleaning. These fragments will increase the risk of ejection failures (e.g., nozzle clogging or deflection).

- On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.
 - The Maintenance menu is displayed.
- Select [Station Maint.] > [Carriage Out] > [Move To Platen Right End], then press the [ENTER] key.
 - The carriage moves over the feeding belt.
- Open the maintenance cover on the right side.



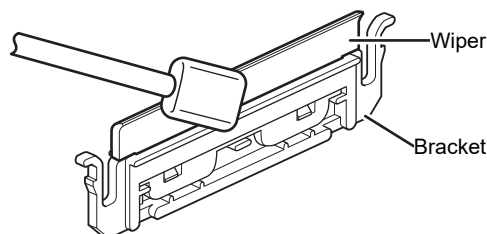
4 Remove the wiper.

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



5 Clean the wiper and bracket.

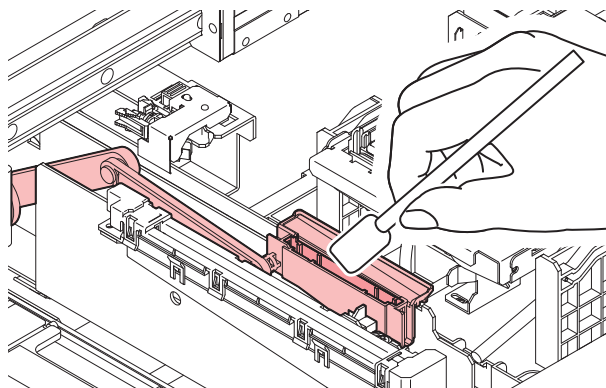
- Wipe off any ink and dust adhering using a cleaning stick moistened with maintenance liquid. Wipe off the maintenance liquid. Make sure none remains.



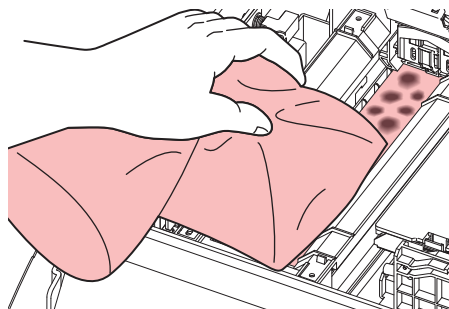
- Replace dirty or warped wipers with new ones. Wiper Replacement

6 Clean the wiper slider.

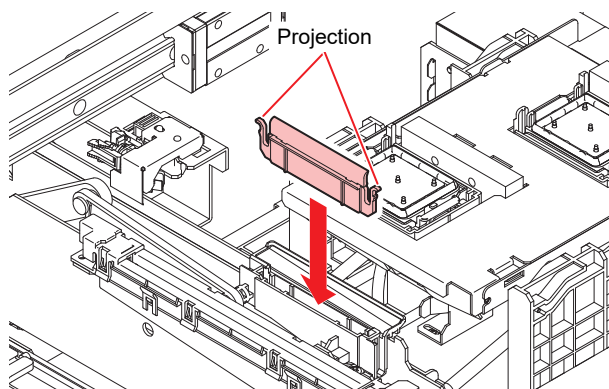
- Wipe off any ink and dust adhering using a cleaning stick moistened with maintenance liquid. Wipe off the maintenance liquid. Make sure none remains.



- 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).

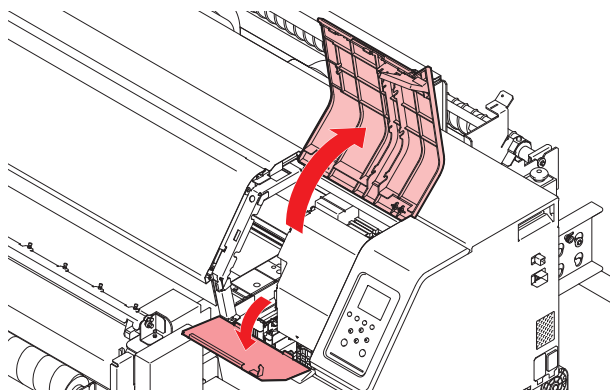
1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

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

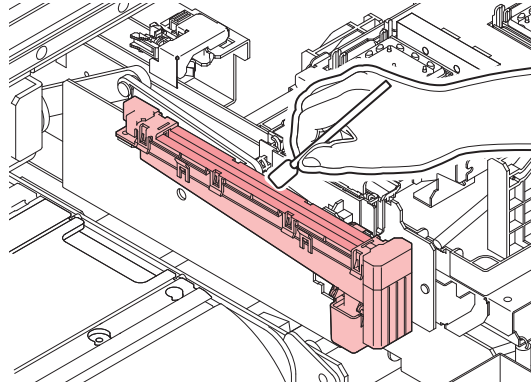
- The carriage moves over the feeding belt.

3 Open the maintenance cover on the right side.

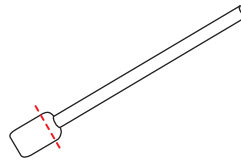


4 Clean the NCU.

- 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.

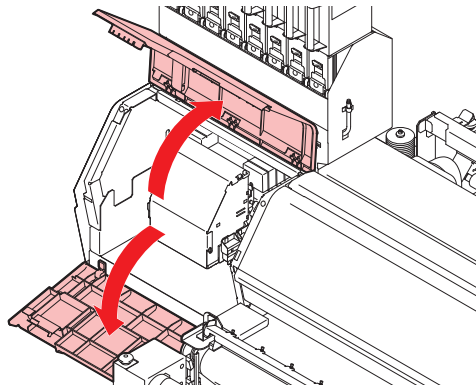


5 Once cleaning is complete, close the cover, then press the [ENTER] key.

DAS (Automatic Correction Function) Sensor Cleaning

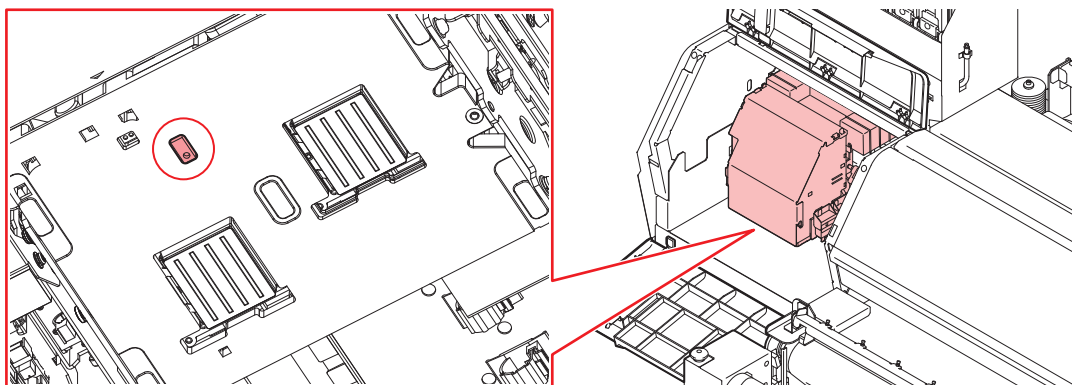
The DAS sensor is located on the carriage underside. If dust or debris accumulates on the sensor, DAS (P. 102) may not function.

- 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 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.

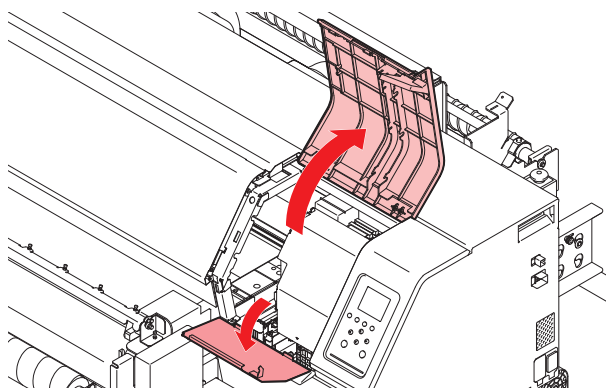
2 Select [Station Maint.] > [Pump tube cleaning], then press the [ENTER] key.

- 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.

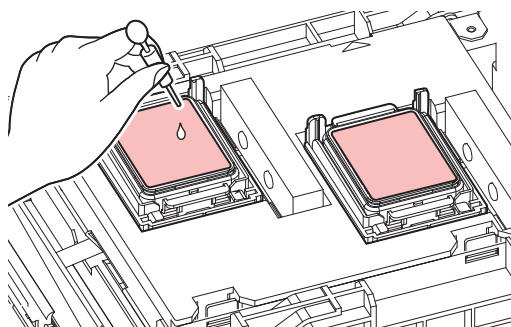
3 Open the maintenance cover on the right side.



- 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.

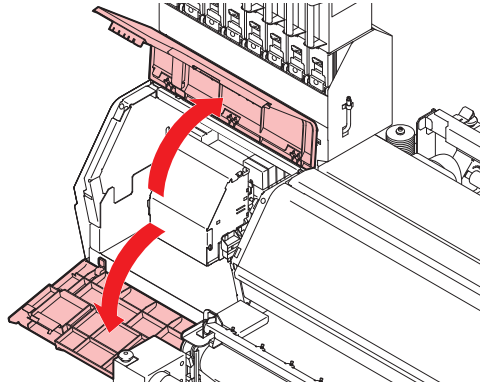
4 Close the maintenance cover, then press the [ENTER] key.

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

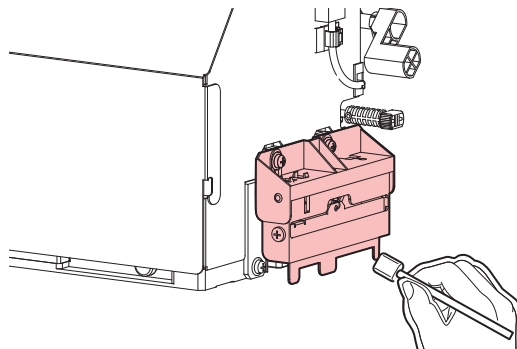
Jam Sensor Detecting Plate Cleaning

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.

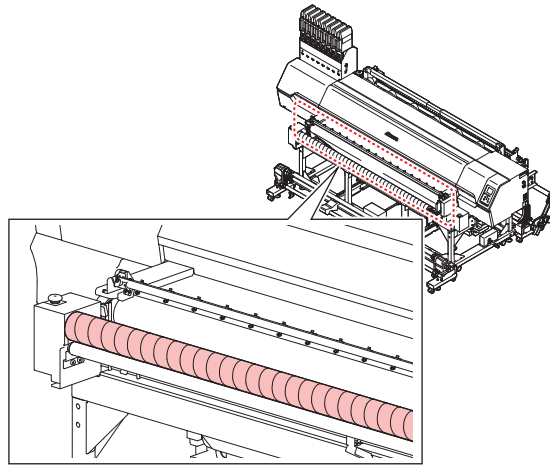


- 4** Clean the jam sensor detecting plate.
 - Clean the jam sensor detecting plate underside at the left and right sides of the carriage.
 - Wipe off any ink and dust adhering using a cleaning stick moistened with maintenance liquid. Wipe off the maintenance liquid. Make sure none remains.



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

Peeling Roller Cleaning



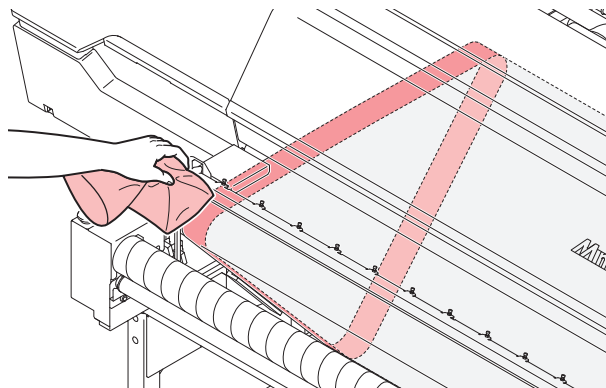
- For heavy soiling, wipe using a soft cloth soaked in diluted neutral detergent and thoroughly wrung out.

Belt Correction Unit Cleaning

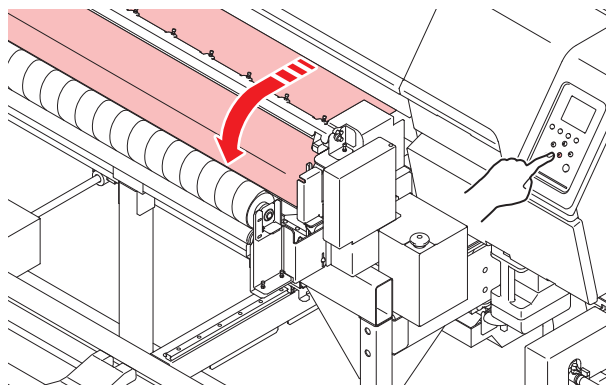
Adhesive applied to the feeding belt may adhere to the rubber gripper on the belt correction unit. Any adhesive on the rubber gripper may cause the belt correction unit to slip and affect printing quality. Regularly clean (about once a week) the rubber gripper of the belt correction unit and the 30 mm portion at the edge of the feeding belt (all around the left side, as viewed from the front).

1 Clean the edge of the feeding belt.

- Wipe the 30 mm portion of the feeding belt's left edge with a waste cloth soaked in alcohol.



2 Feed the belt by specifying the count in [Maintenance] > [Belt Maintenance] > [Belt Cleaning].



3 Repeat steps 1 and 2 to clean the entire length of the belt.

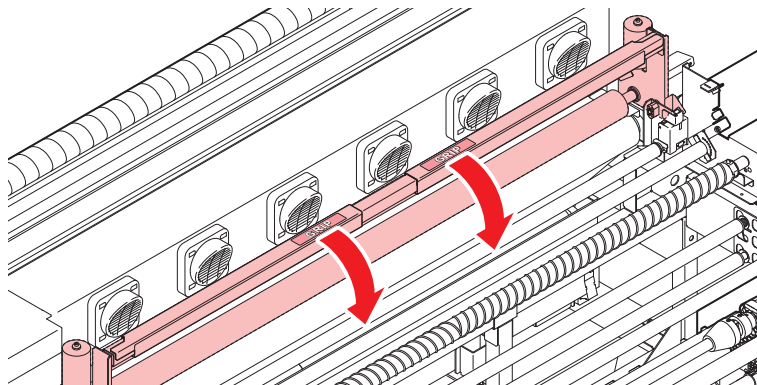
4 Turn off the main power supply.



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

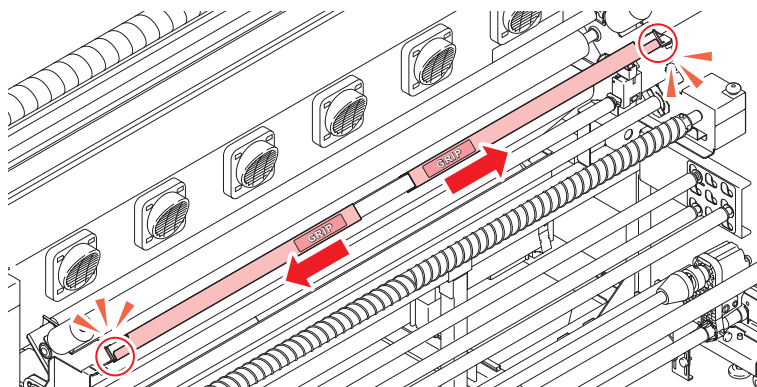
5 Raise the pressure roller.

- Holding the sections labeled GRIP with both hands, pull toward you.

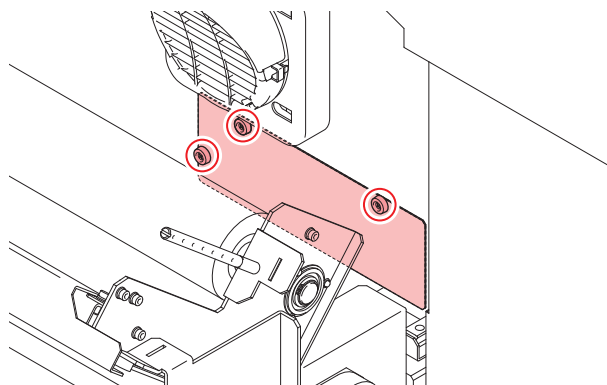


6 Lock the pressure roller.

- Holding the sections labeled GRIP with both hands, slide the two sections outward.
- Make sure the left and right sides are securely locked.

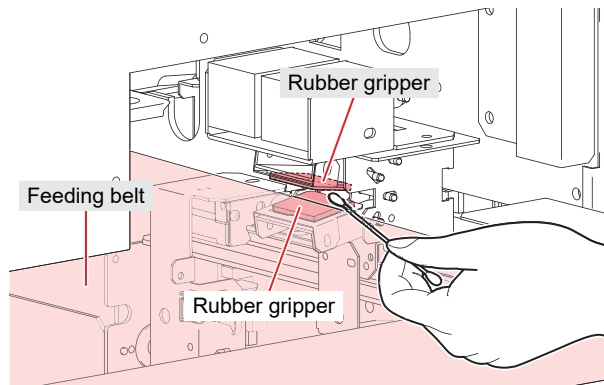


7 Remove the maintenance cover.



8 Clean the rubber gripper.

- Using a cloth soaked in alcohol, wipe the rubber gripper above and below the feeding belt.



9 Attach the maintenance cover.

Blowing Fan Filter Cleaning

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

● Recommended cleaning guide

Important!

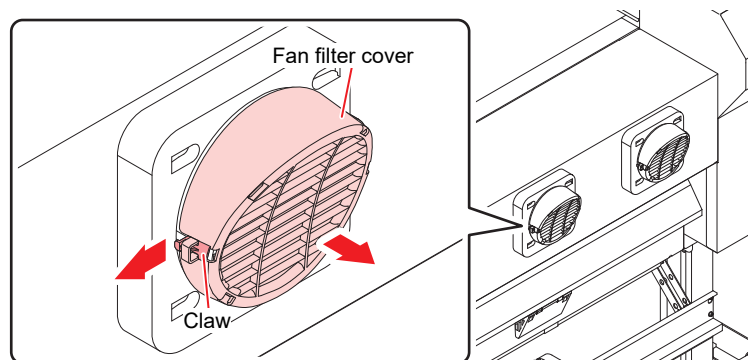
- Check the filter for dirt every two weeks, and wash.
- Replace the filter every three months. ["Blowing Fan Filter Replacement"\(P. 161\)](#)



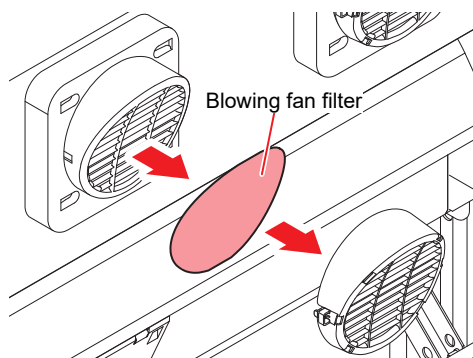
- Turn off the main power and unplug the power cable before replacement.

1 Remove the fan filter cover.

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



2 Remove the filter.



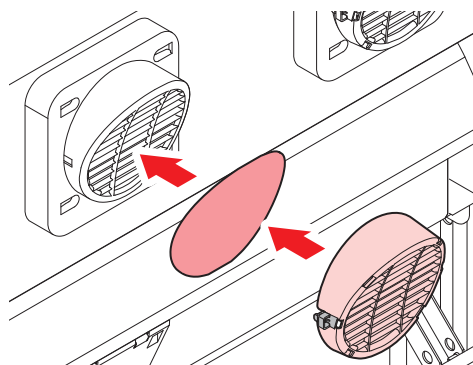
3 Wash the filter.



- 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.



Washing Water Replacement

If the feeding belt is still dirty after belt washing, replace the washing water. Replace the washing water every day if the belt is not cleaned under flowing water.

1 In local mode, press [FUNC1 (MENU)] > ▼ > [ENTER] key.

- The Maintenance menu is displayed.

2 Press ▲▼ to select [Belt Maintenance], then press the [ENTER] key.

3 Press ▲▼ to select "REPLACE WATER," then press the [ENTER] key.

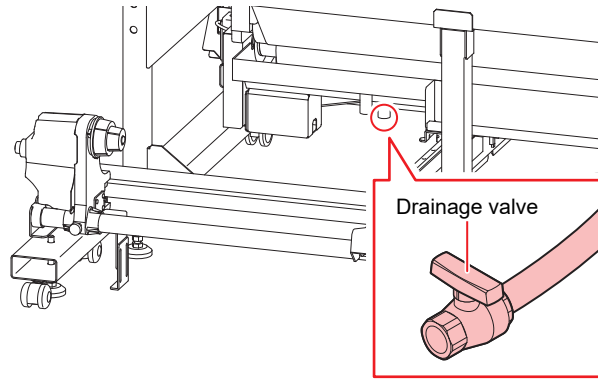
- The Washing Water Replacement Setup screen appears.

4 Press ▲▼ to select "DRAIN," then press the [ENTER] key.

5 Press the [ENTER] key.

- A message is displayed indicating that the washing unit is moving and requesting you to wait.

- 6** When a message requests you to open the drainage valve because water will be drained, place a bucket or the like under the valve and open the valve.



- 7** Press the [ENTER] key.

- Draining begins, as indicated by a message requesting you to wait.

- 8** After a message indicates that draining is finished, close the valve.

- 9** Press the [ENTER] key.

- A message now asks if you wish to supply washing water.

- 10** Press the [ENTER] key.

- A message indicates that water supply will start and asks you to close the drainage valve.

- 11** Close the valve and press the [ENTER] key.

- 12** Press the [ENTER] key once "Start to supply water" appears on the display.

- Water supply starts, and "Supplying water. Please wait" appears on the display.



- Adjust the amount of water with the cock of the water supply valve if the amount of water is too much or too little.

- 13** Press the [ENTER] key once "Completed to supply water" appears on the display.

- 14** Press the [ENTER] key.

- "Reset the wash unit. Please wait" appears on the display.
- When the washing unit returns to the standby position, the Washing Water Replacement Setup screen appears.

Washing Unit Maintenance

Cleaning the Belt Washing Unit

Move the belt washing unit to the maintenance position and clean the washing brush and inside the tray.

- 1** In local mode, press [FUNC1 (MENU)] > ▼ > [ENTER] key.

- The Maintenance menu is displayed.

- 2** Press ▲▼ to select [Belt Maintenance], then press the [ENTER] key.

3 Press ▲▼ to select [BELT WASH UNIT], then press the [ENTER] key.

4 Press the [ENTER] key.

5 Raise the pressure roller and remove the media.

- Remove any loaded media.

6 Press the [ENTER] key.

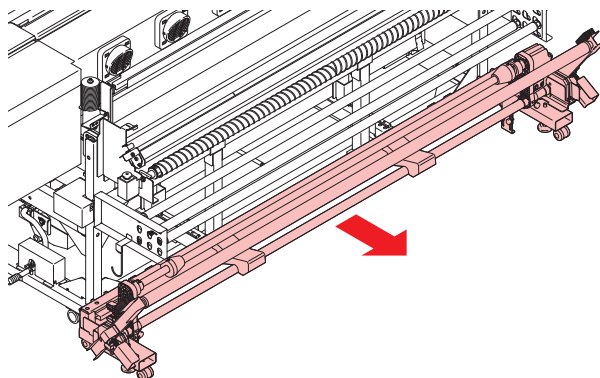
- Instructions for moving the washing unit are displayed.

7 Press the [ENTER] key.

- The washing unit is moved to the rear of the machine.

8 Remove the feeding unit.

- Remove any loaded media.
- Remove the feeding unit from the machine and move it out of the way.



- If a screen in local mode is displayed again because you accidentally held down the END key or opened a cover after removing the feeding unit, repeat the initial steps as follows.

- (1) Turn off the main power supply.
- (2) Attach the feeding unit.
- (3) Turn on the main power supply.
- (4) Start again from step 1.

9 Press the [ENTER] key.

- The water supply valve control screen is displayed.

10 Clean the washing unit.



- To allow water to flow into the washing tray, press the [ENTER] key. The water supply valve is opened and water is supplied to the washing tray.
- To stop the water, press the [ENTER] key again. The water supply valve is closed.



- Before releasing water from the water supply valve, make sure the drain hose is not clogged. Running water with the drain hose clogged may cause water to overflow the washing tray.

11 When cleaning is finished, press the [END/POWER] key.

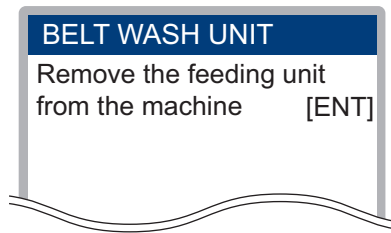
- A screen is displayed to confirm that this process is complete.

12 Attach the feeding unit.

- Reattach the feeding unit that was removed.



- Be sure to install the feeding unit while this screen is displayed.



13 Raise the tension bar manually and press the [ENTER] key.



- If the feeding unit is attached incorrectly or the tension bar was not raised, the screen for attaching the feeding unit is displayed again.

14 Press the ON/OFF button on the feeding unit.

15 Press the [ENTER] key.

- If the feeding unit does not rotate, the screen for attaching the feeding unit is displayed again.

16 Press the [ENTER] key.

- The washing unit is returned to the original position.

17 Press the [ENTER] key.

- A screen appears indicating that maintenance is finished.

18 Press the [ENTER] key.

Absorption Roller Cleaning

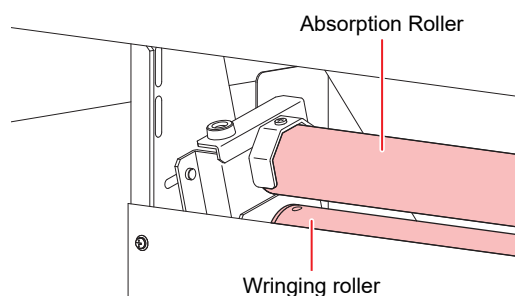
Dirt accumulates on the absorption roller when belt washing is used. To maintain good printing quality, clean the absorption roller.



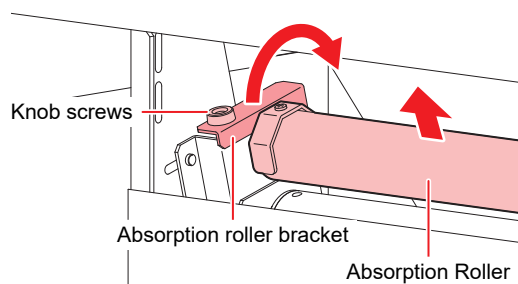
- Setting a general time to be notified of absorption roller cleaning will enable you to work without worrying about the timing of this cleaning.



- To prevent used cleaning water from getting the floor dirty, spread out a waste cloth or the like on the floor in advance.
- Before cleaning, put on rubber gloves.



- 1** In local mode, press [FUNC1 (MENU)] > ▼ > [ENTER] key.
 - The Maintenance menu is displayed.
- 2** Press ▲▼ to select [Belt Maintenance], then press the [ENTER] key.
- 3** Press ▲▼ to select [BELT WASH UNIT], then press the [ENTER] key.
- 4** Press the [ENTER] key.
- 5** Raise the pressure roller and remove the media.
 - Remove any loaded media.
- 6** Press the [ENTER] key.
 - Instructions for moving the washing unit are displayed.
- 7** Press the [ENTER] key.
 - The washing unit is moved to the rear of the machine.
- 8** Remove the knob screws and rotate the left and right absorption roller brackets.
 - The absorption roller is in the middle at the rear of the unit.



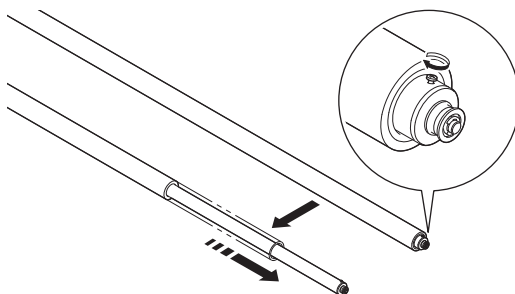
- 9** Remove the absorption roller from the machine.



- At least two people should remove the absorption roller.

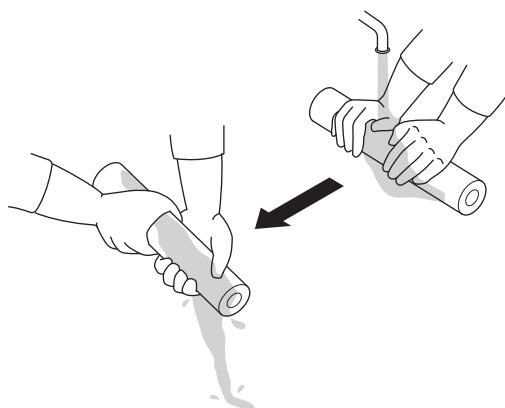
10 Rinse and then remove water from the absorption roller.

- (1) Remove the screws at each end with a screwdriver, then remove one sleeve at a time for cleaning.



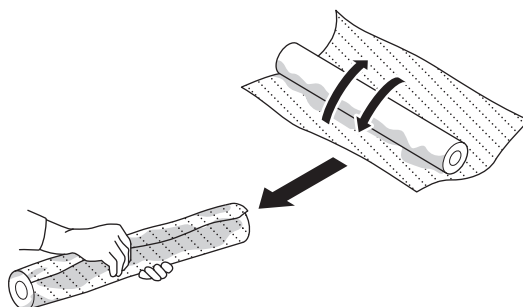
- (2) Clean the roller by rinsing it under tap water or the like.

- Do not wring out the sponge.



- (3) After cleaning by rinsing, wrap the sleeve in a waste cloth such as a Bemcot cloth to absorb the water.

- Do not wring out the sponge.



- (4) Dry well before reassembly.



- If it is still dirty, replace the absorption roller (SP-01021) with a new one.

11 Reinstall the absorption roller.

- If a warning message appears, reset the counter. 🖱️ ["Resetting the Counter"\(P. 149\)](#)



- Center the absorption roller to avoid gaps, then secure it.

12 When cleaning is finished, press the [END/POWER] key.

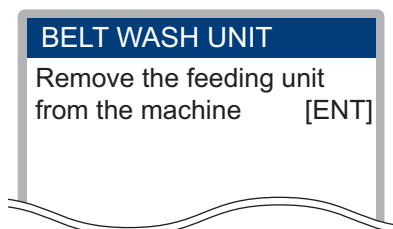
- A screen is displayed to confirm that this process is complete.

13 Attach the feeding unit.

- Reattach the feeding unit that was removed.



- Be sure to install the feeding unit while this screen is displayed.

**14** Raise the tension bar manually and press the [ENTER] key.

- If the feeding unit is attached incorrectly or the tension bar was not raised, the screen for attaching the feeding unit is displayed again.

15 Press the ON/OFF button on the feeding unit.**16** Press the [ENTER] key.

- If the feeding unit does not rotate, the screen for attaching the feeding unit is displayed again.

17 Press the [ENTER] key.

- The washing unit is returned to the original position.

18 Press the [ENTER] key.

- A screen appears indicating that maintenance is finished.

19 Press the [ENTER] key.

Reapplying Adhesive

If the adhesive strength is decreased by ink, loose threads, dust, or the like, the adhesive must be reapplied.



- When to reapply adhesive
It is time to reapply adhesive when printed media lifts up after emerging from the front cover. Promptly reapply belt adhesive when a warning message advises to reapply it.



- Genuine Mimaki adhesive is solvent-based. When applying adhesive, always wear a protective mask designed for working with organic solvents, as well as safety glasses and gloves.
- A ventilation system must be available when reapplying adhesive in a poorly ventilated area or sealed room. When using adhesive, comply with the Ordinance on Prevention of Organic Solvent Poisoning.
- Additionally, ensure that adhesive is reapplied under the supervision of someone who has completed a technical training course for those in charge where organic solvents are used, or someone appointed to supervise organic solvent work.



- The adhesive is not the cause if the media sags even before use and lifts up or sags after being applied to the feeding belt (with the pressure roller). Also note that this kind of media cannot be used.

Peeling Off Adhesive

The following items are required in order to peel off adhesive.

● Items required

- Doctor, gloves

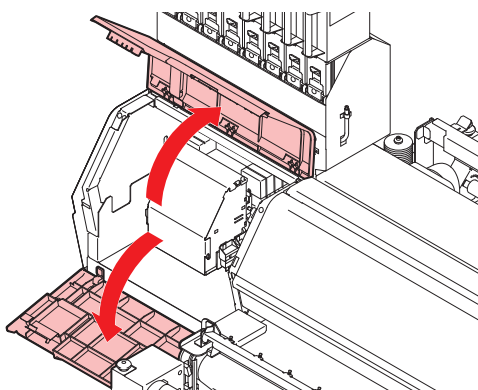
● Items to prepare

- Waste cloth
- Kerosene or light oil (approx. 500 cc)
- Ethanol (approx. 200 cc)
- Metal plate or oil-resistant plastic plate, shaped like a tray

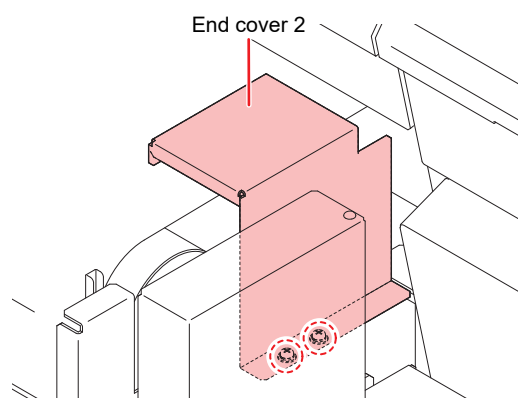
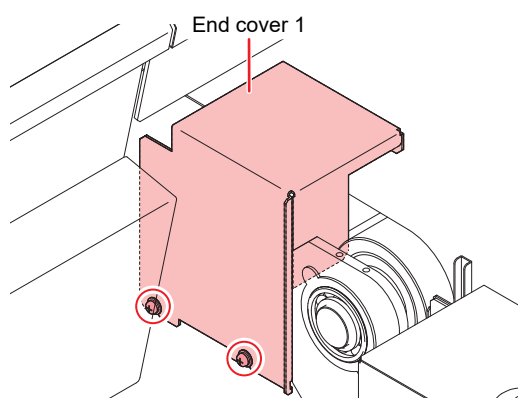


- For convenience, consider transferring the kerosene (or light oil) and ethanol into containers with a small mouth.

1 Open the maintenance cover on the left side.



2 Remove end covers 1 and 2.



3 In local mode, press [FUNC1 (MENU)] > [DOWN] > [ENTER] key.

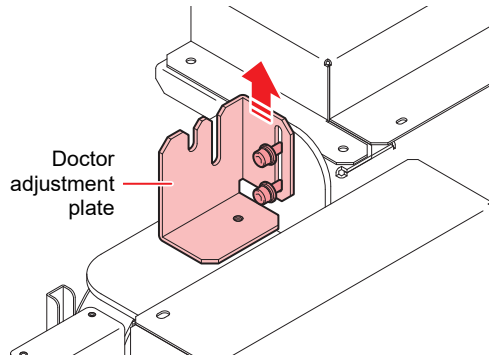
- The Maintenance menu is displayed.

4 Press [UP] [DOWN] to select [Belt Maintenance], then press the [ENTER] key.

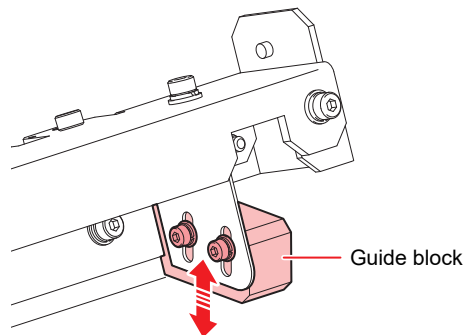
- 5** Press ▲▼ to select "BELT ADHESIVE," then press the [ENTER] key.
- 6** Press ▲▼ to select "Peeling off adhesive," then press the [ENTER] key.
- 7** After a message requests you to remove the media, make sure no media is on the feeding belt, then press the [ENTER] key.
- 8** When instructions indicate to raise the pressure roller, raise the pressure roller on the back of the machine, then press the [ENTER] key.

9 After a message requests you to set the doctor, attach the doctor on the front of the machine.

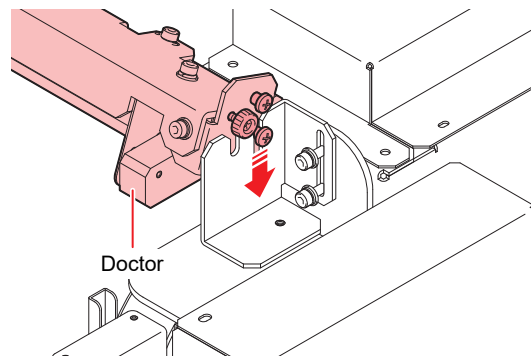
- Attach the doctor leaving a gap between it and the belt.
- (1) Loosen the doctor adjustment plates (at each end), move the point of attachment to the top, then tighten loosely.



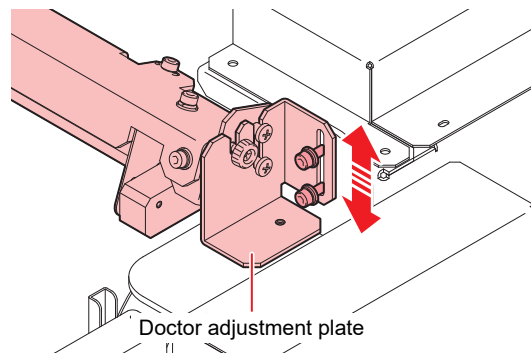
- (2) Loosen the doctor guide blocks (at each end) enough to allow the doctor to move up and down under its own weight.



- (3) Attach the doctor and secure it with screws.



- (4) Adjust the doctor adjustment plate height to around the level where the doctor blade touches the feeding belt, then secure it in place.

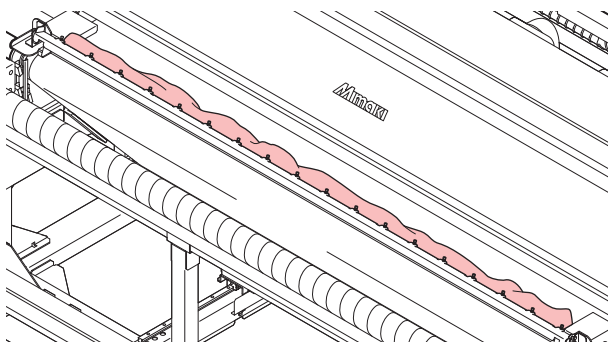


10 Press ▲▼ to set the feed speed, then press the [ENTER] key.

- Setting value: 5 to 60 [mm/s]



- 20 mm/s is recommended.

11 Place a waste cloth soaked in kerosene along the inside of the doctor on the feeding belt.**12** Press the [ENTER] key.

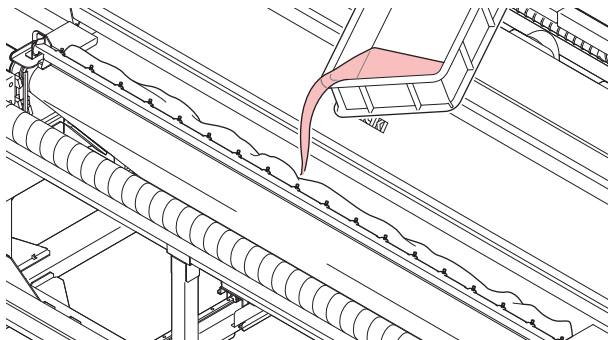
- The feeding belt now moves.




- To pause the feeding belt, press (1) the [FUNC2 (PAUSE)] key.
- (2) Press ▲▼ to select [Belt Maintenance], then press the [ENTER] key.
- To change the feed speed, adjust by pressing [FUNC1 (SPEED UP)] / [FUNC3 (SPEED DOWN)].

13 Dribble some kerosene or light oil on the back of the waste cloth.

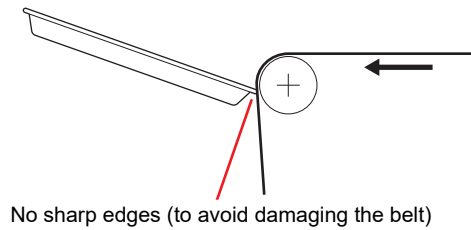
- Allow the kerosene/light oil to soak into the adhesive on the surface of the belt well.



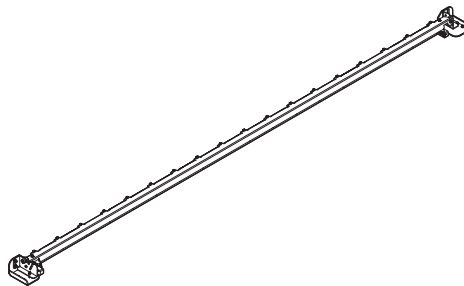
- When removing adhesive, dribbling too much kerosene/light oil may cause it to leak from the end of the doctor and drip onto the feeding belt and into the washing water holder.
- Accidentally mixing kerosene/light oil with washing water may weaken the adhesive if you are printing while washing the belt.
- Adhesive that suddenly weakens after reapplication may indicate that kerosene/light oil has been mixed into the washing water.
- After peeling off and reapplying adhesive, always check the washing tray to make sure no kerosene/light oil is mixed with the washing water.

If you discover that they are mixed together, clean the washing tray and cleaning brush by selecting "REPLACE WATER→CLEANING WASH TRAY" in the maintenance menu.  ["Cleaning the Washing Tray and Brush"\(P. 146\)](#) Then replace the water in the washing water tank with fresh water.

- 14** To remove any adhesive that has turned into a gel due to the kerosene/light oil, press the edge of the plate against the feeding belt at an outer position.



- 15** Wipe off as much kerosene/light oil as possible from the belt surface with a waste cloth.
- 16** Clean the surface of the belt by wiping off any remaining oil with a waste cloth soaked in ethanol.
- 17** Press [END/POWER] key > [ENTER] key to stop the feeding belt.
- 18** After a message about resetting the adhesive counter is displayed, press the [ENTER] key.
- The adhesive counter is reset.
- 19** Remove the doctor and wipe off any remaining adhesive or debris with kerosene/light oil and a waste cloth.



Applying Adhesive

The following items are required in order to apply adhesive.

● Items required

- Doctor, gloves
- Vinyl tape (3 cm wide)
- Adhesive (Polixresin SX 1L, sold separately)



- Genuine Mimaki adhesive is solvent-based. When applying adhesive, always wear a protective mask designed for working with organic solvents, as well as safety glasses and gloves.
- A ventilation system must be available when reapplying adhesive in a poorly ventilated area or sealed room.
- When using adhesive, comply with the Ordinance on Prevention of Organic Solvent Poisoning. Additionally, ensure that adhesive is reapplied under the supervision of someone who has completed a technical training course for those in charge where organic solvents are used, or someone appointed to supervise organic solvent work.
- Open flames are strictly prohibited when reapplying adhesives. Always turn off all nearby equipment, such as heaters. Also, be sure to ensure sufficient ventilation.



- When using a commercial adhesive, be sure to check the compatibility of the solvents it contains with the material that the belt is made of. In this case, contact your distributor or a sales office.
- Be careful to avoid getting adhesive on the contact area of the belt correction unit (on the right in the front of the machine) and near the 6 mm dia. hole. Doing so may prevent normal operation of the machine.



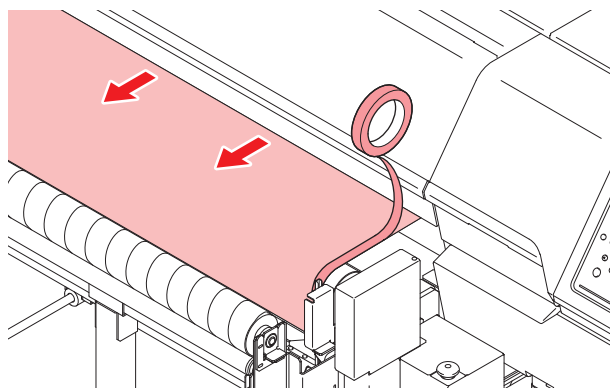
- To the extent possible, avoid applying excessive adhesive, as this may cause feeding problems.
- Adhesive should generally be reapplied once every two weeks. (Timing varies depending on usage and type of media.)

- 1** In local mode, press [FUNC1 (MENU)] > > [ENTER] key.
 - The Maintenance menu is displayed.
- 2** Press to select [Belt Maintenance], then press the [ENTER] key.
- 3** Press to select "BELT ADHESIVE," then press the [ENTER] key.
 - The belt adhesive setting screen appears.
- 4** Press to select "Applying Adhesive," then press the [ENTER] key.
- 5** After a message requests you to remove the media, make sure no media is on the feeding belt, then press the [ENTER] key.
- 6** When instructions indicate to raise the pressure roller, raise the pressure roller on the back of the machine, then press the [ENTER] key.
- 7** Cover the edges of the feeding belt with vinyl tape.



- Tape must be applied around the entire left and right edges of the feeding belt.
- If necessary, have two people do this, or repeat the process for the other edge after one edge is finished.

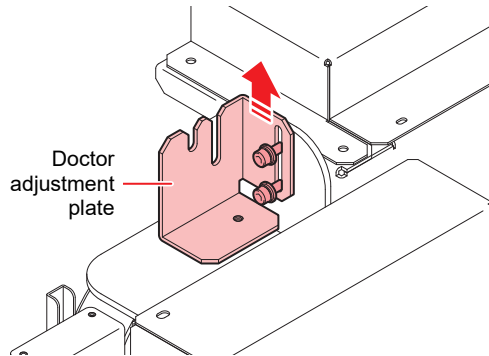
- 8** Press the [ENTER] key twice.
 - The feeding belt is activated and stops after one revolution. To pause the feeding belt, press the [FUNC2 (PAUSE)] key.
 - To change the feed speed, adjust by pressing [FUNC1 (SPEED UP)] / [FUNC3 (SPEED DOWN)].



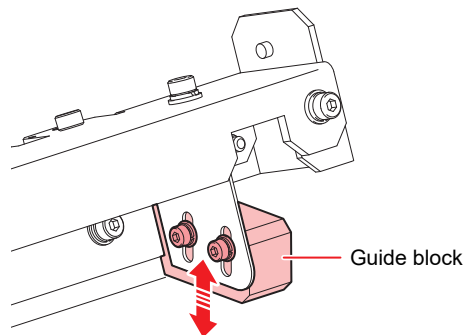
- 9** Press the [ENTER] key.
 - If tape was applied incorrectly, select [END/POWER]. After this, repeat step 8.

10 After a message requests you to set the doctor, attach the doctor on the front of the machine.

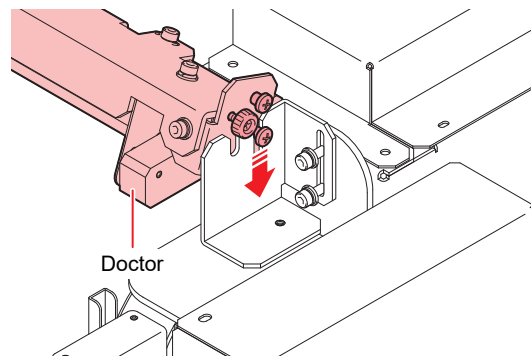
- Attach the doctor without any gap between it and the belt.
- (1) Loosen the doctor adjustment plates (at each end), move the point of attachment to the top, then tighten loosely.



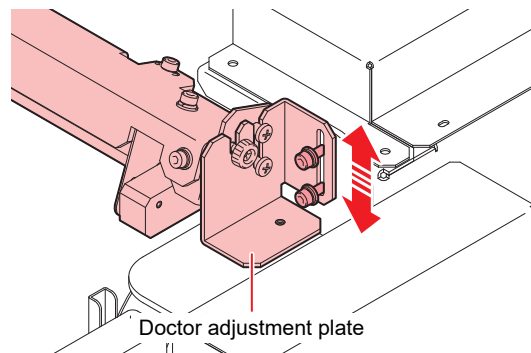
- (2) Loosen the doctor guide blocks (at each end) enough to allow the doctor to move up and down under its own weight.



- (3) Attach the doctor and secure it with screws.

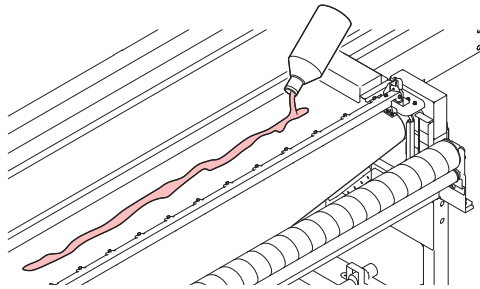


- (4) Adjust the doctor adjustment plate height to around the level where the doctor blade touches the feeding belt, then secure it in place.



11 Press ▲▼ to set the feed speed, then press the [ENTER] key.

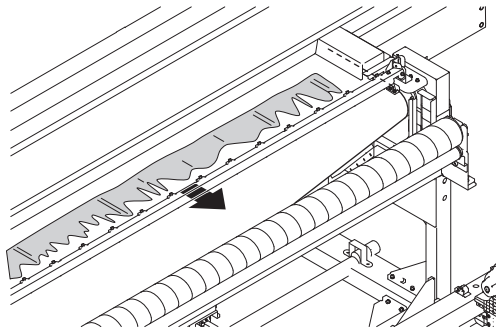
- Recommended value: 15 m/s

12 Dribble 150 to 200 cc of adhesive evenly near the edge of the doctor.**13** Press the [ENTER] key.

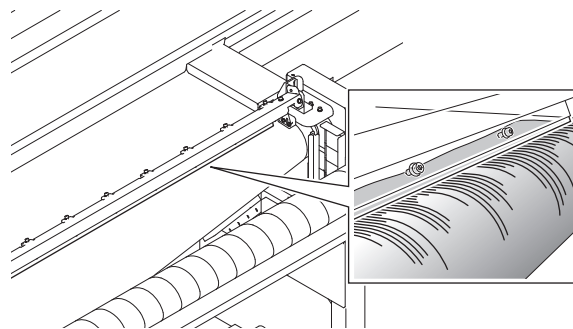
- The feeding belt now moves.



- When using adhesive that is highly viscous, increase the belt speed.
- To change the feed speed, adjust by pressing [FUNC1 (SPEED UP)] / [FUNC3 (SPEED DOWN)].
- To pause the feeding belt, press the [FUNC2 (PAUSE)] key. To resume moving the feeding belt, press the [FUNC2 (START)] key.

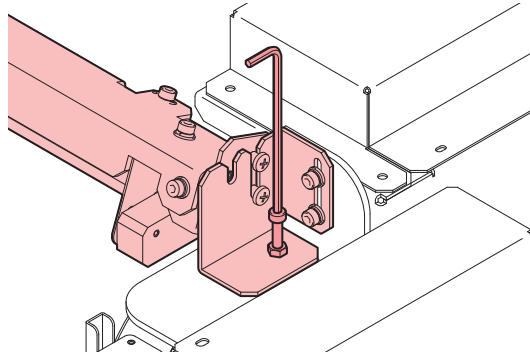


- Add more adhesive to areas on the doctor where little adhesive remains.
- Apply adhesive across the entire belt surface.
- Use up all of the adhesive.

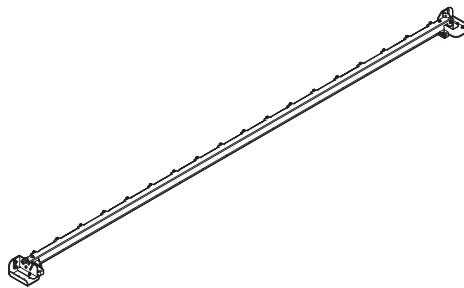




- After the level of adhesive no longer decreases, gradually increase the height of the doctor and apply a thicker coat.
- Do not lower the doctor after raising it, which will result in uneven adhesive.



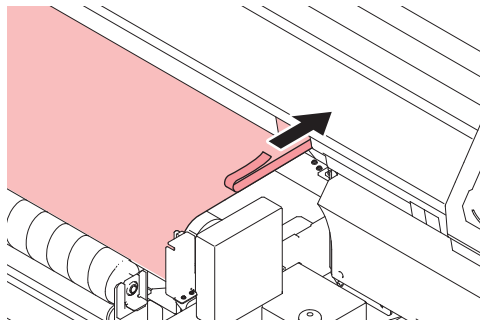
14 Remove the doctor and wipe off any remaining adhesive or debris with kerosene/light oil and a waste cloth.



15 Remove the tape around the feeding belt.



- When removing tape, peel it off toward the rear of the machine. This will allow the adhesive to separate from the tape more easily.



16 To set a drying time, press the [ENTER] key.



- If you set a drying time, the feeding belt will automatically stop after the time elapses.
- The adhesive counter is reset.

17 Press ▲▼ to set the drying time (in hours), then press the [ENTER] key.

18 Press ▲▼ to set the drying time (in minutes), then press the [ENTER] key.

- The drying time countdown is activated.
- To stop it, press the [END/POWER] key.

19 After the adhesive on the feeding belt is dry, press [END/POWER] key > [ENTER] key to stop the feeding belt.

20 After a message about resetting the adhesive counter is displayed, press the [ENTER] key.

- The adhesive counter is reset.



- If, after drying, the adhesive is too strong, wipe the belt surface with a wet waste cloth to prepare it for use. Using the belt this way may cause the media to stick to it and not come off.

Cleaning the Washing Tray and Brush

If kerosene/light oil gets into the washing water when you reapply adhesive, clean the washing tray and cleaning brush with a neutral detergent. Then replace the water in the washing water tank with fresh water.

● Items required

- Neutral detergent



- When cleaning, be sure to wear safety glasses and gloves.

1 In local mode, press [FUNC1 (MENU)] > ▼ > [ENTER] key.

- The Maintenance menu is displayed.

2 Press ▲▼ to select [Belt Maintenance], then press the [ENTER] key.**3** Press ▲▼ to select "REPLACE WATER," then press the [ENTER] key.

- The Washing Water Replacement Setup screen appears.

4 Press ▲▼ to select "CLEANING WASH TRAY," then press the [ENTER] key.**5** Press the [ENTER] key.

- The washing unit is moved to the rear of the machine.

6 When a message indicates that tray cleaning will start and the brush will be rotated, add neutral detergent to the washing tray and press the [ENTER] key.

- The brush rotates, stirring the detergent.



- The cleaning brush rotates automatically. Be careful to avoid getting your hands or clothing caught in it.

7 Clean the washing tray and brush.

- To stop the brush, press the [FUNC2 (PAUSE)] key.
- To resume moving the brush, press the [FUNC2 (START)] key.



- To allow water to flow into the washing tray, press the [ENTER] key. The water supply valve is opened and water is supplied to the washing tray.
- To stop the water, press the [ENTER] key again. The water supply valve is closed.

8 When cleaning is finished, press the [END/POWER] key.

- A screen is displayed to confirm that this process is complete.

9 Press the [ENTER] key.

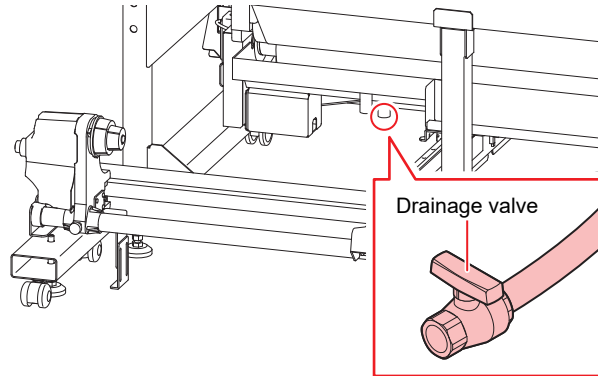
- A message now asks if you wish to drain washing water.

10 Press the [ENTER] key and select "DRAIN WATER."

- Display changes to the menu for draining the washing water.



- If you have not used neutral detergent and do not need to drain the washing water, press the [END] key to finish tray cleaning.

11 When a message requests you to open the drainage valve because water will be drained, place a bucket or the like under the valve and open the valve.**12 Press the [ENTER] key.**

- Draining begins, as indicated by a message requesting you to wait.

13 After a message indicates that draining is finished, close the valve.**14 Press the [ENTER] key.**

- A message now asks if you wish to supply washing water.

15 Press the [ENTER] key.

- A message indicates that water supply will start and asks you to close the drainage valve.

16 Close the valve and press the [ENTER] key.**17 Press the [ENTER] key once "Start to supply water" appears on the display.**

- Water supply starts, and "Supplying water. Please wait" appears on the display.



- Adjust the amount of water with the cock of the water supply valve if the amount of water is too much or too little.

18 Press the [ENTER] key once "Completed to supply water" appears on the display.**19 Press the [ENTER] key.**

- "Reset the wash unit. Please wait" appears on the display.
- When the washing unit returns to the standby position, the Washing Water Replacement Setup screen appears.

Cleaning the Feeding Belt

Clean the feeding belt as follows.



- Before cleaning, be sure to remove any media on the feeding belt.

- 1** In local mode, press **[FUNC1 (MENU)] > [▼] > [ENTER]** key.
 - The Maintenance menu is displayed.
- 2** Press **[▲][▼]** to select **[Belt Maintenance]**, then press the **[ENTER]** key.
- 3** Press **[▲][▼]** to select **[BELT CLEANING]**, then press the **[ENTER]** key.
 - The belt cleaning setting screen appears.
- 4** After a message requests you to remove the media, make sure no media is on the feeding belt, then press the **[ENTER]** key.
- 5** When instructions indicate to raise the pressure roller, raise the pressure roller on the back of the machine, then press the **[ENTER]** key.
- 6** Press **[▲][▼]** to set the number of cleaning cycles, then press the **[ENTER]** key.
 - Setting value: 1 to 99 times
 - Belt cleaning begins, and the number of cycles displayed is updated each time the belt goes around.



- To stop cleaning, press the **[END/POWER]** key, then press the **[ENTER]** key.

- 7** After a message indicates that the process is complete, press the **[ENTER]** key.
 - The Maintenance menu is displayed.

Cleaning the Peeling Sensor

To prevent peeling sensor malfunction caused by soiling, clean the peeling sensors regularly (about once a week).

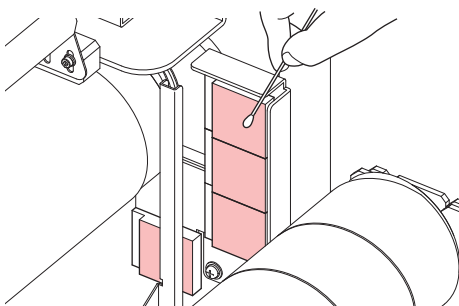


- The peeling sensors may be soiled by ink mist from printing or steam from drying media.

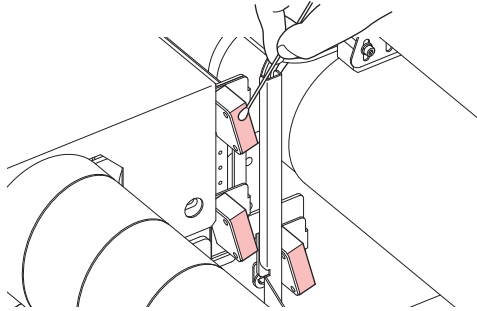
Also perform cleaning if any of the following occur.

- Media is not peeled off, and an alarm beeps.
- An alarm beeps even when media is not taken up on the belt.

- 1** Use a cotton swab soaked in maintenance liquid to wipe the reflectors.



- 2** Dry the reflectors wiped in step 1 with a dry cotton swab.
- 3** Wipe the three light-emitting surfaces of the peeling sensors with a cotton swab soaked in maintenance liquid.



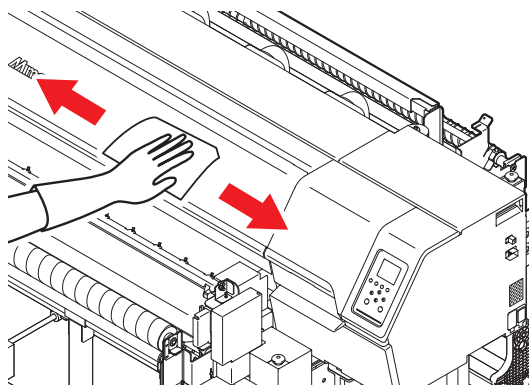
- 4** Dry the lenses wiped in step 3 with a dry cotton swab.

Resetting the Counter

Initialize counters for adhesive and the absorption roller as follows.

- 1** In local mode, press [FUNC1 (MENU)] > ▼ > [ENTER] key.
 - The Maintenance menu is displayed.
- 2** Press ▲▼ to select [Belt Maintenance], then press the [ENTER] key.
- 3** Press ▲▼ to select "COUNTER RESET," then press the [ENTER] key.
 - The counter reset setting screen appears.
- 4** Press ▲▼ to select "Adhesive" or "Absorb Roller," then press the [ENTER] key.
 - The counter is reset, and the maintenance menu is displayed.

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:

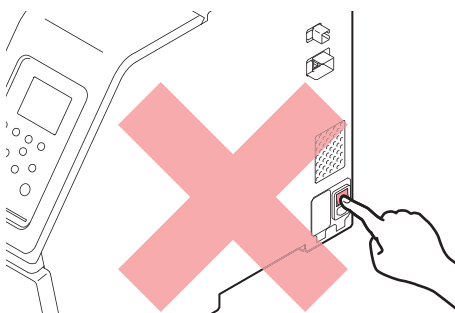
Check beforehand

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).



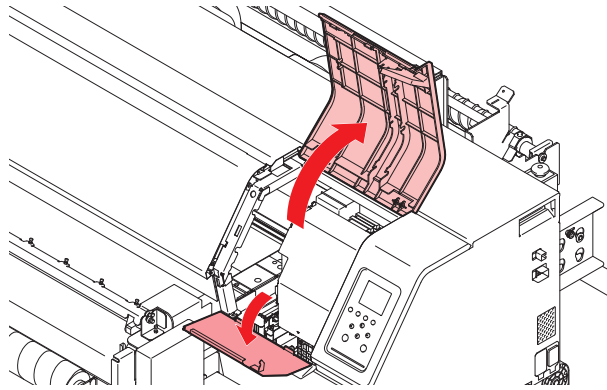
- Do not leave the media on the belt. This may leave irregularities or ripples in the media.



- If Check Waste Ink is displayed, dispose of ink in the waste ink tank on the right of the machine.
 ["Waste Ink Tank Replacement"\(P. 163\)](#)

- 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 feeding belt.

3 Open the maintenance cover on the right side.



4 Clean the cap rubber.

- "Cap Rubber Cleaning"(P. 118)

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

- The cap is filled with maintenance liquid.



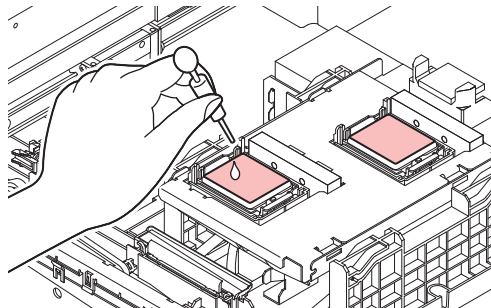
- Close the cover. The cap cannot be filled with maintenance liquid while the cover is open. This is also true if the maintenance liquid cartridge is empty.

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.

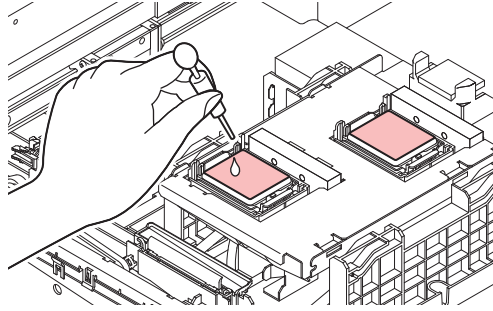
- Cleaning is performed automatically once print nozzle washing has ended.
- The cap is filled with maintenance liquid.

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.

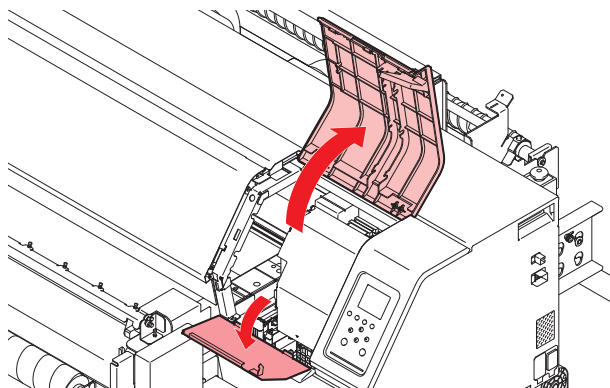
Consumable Item Replacement Timing

Timing	Item
When dirty	"Replacing the Absorber Around the Station"(P. 159) "Wiper Replacement"(P. 154) "Blowing Fan Filter Replacement"(P. 161)
When ejection failures cannot be remedied	"Cap Replacement"(P. 157) "Wiper Replacement"(P. 154)
When damaged	"Wiper Replacement"(P. 154) "Cap Replacement"(P. 157)
When replacing ink	"Ink Supply Unit Ink Absorber Replacement"(P. 162)
When "Replace Wiper" appears on the display	"Wiper Replacement"(P. 154)
When "Check Waste Ink Tank" appears on the display	"Waste Ink Tank Replacement"(P. 163)
Once a year	"Wiper Cleaner Replacement"(P. 155)

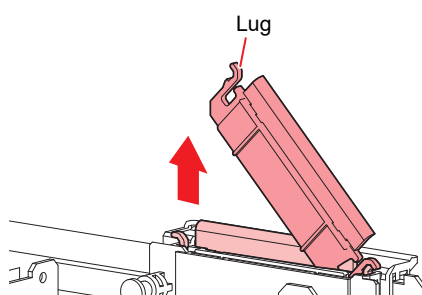
Wiper Replacement

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 feeding belt.
- 4** Open the maintenance cover on the right side.

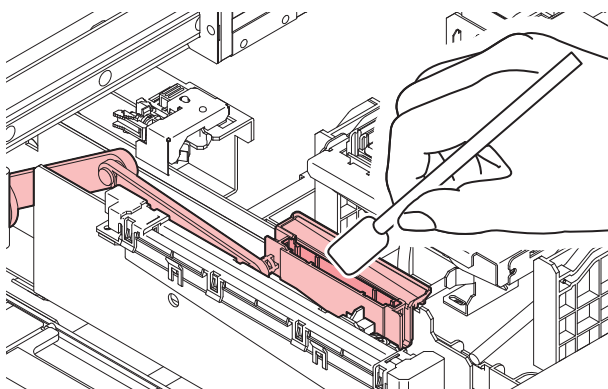


- 5** Remove the wiper.
 - Hold the lug at the rear of the wiper bracket, then pull out the wiper.

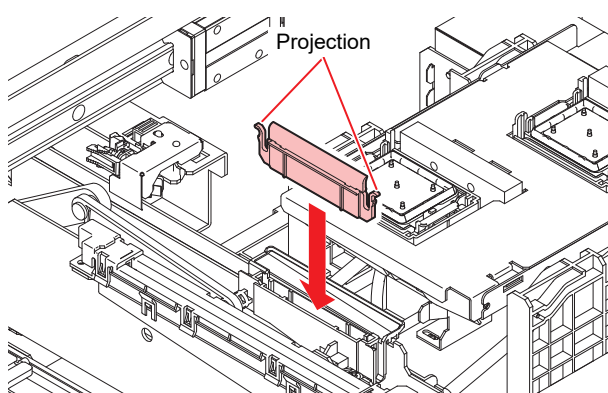


6 Clean the wiper slider.

- 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.

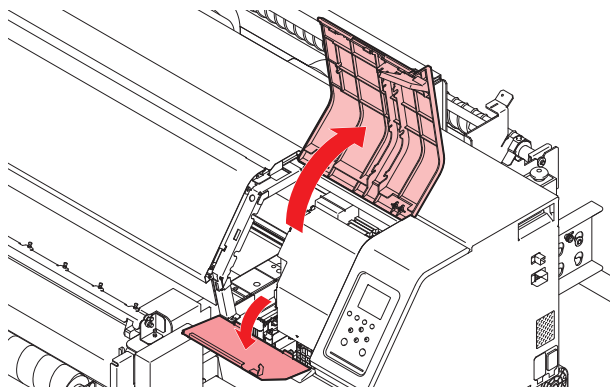
- The wiper usage count is reset.

Wiper Cleaner Replacement

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

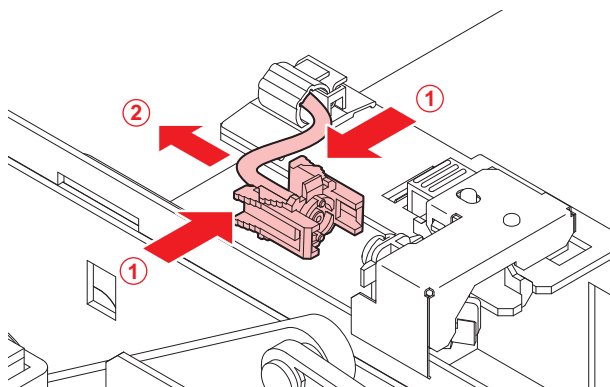
- On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.
 - The Maintenance menu is displayed.
- Select [Station Maint.] > [Carriage Out] > [Move To Platen Right End], then press the [ENTER] key.
 - The carriage moves over the feeding belt.

3 Open the maintenance cover on the right side.



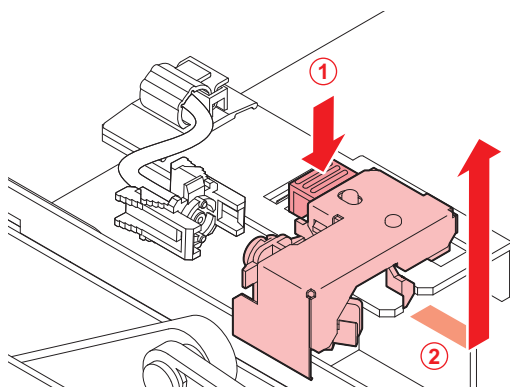
4 Remove the fitting.

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



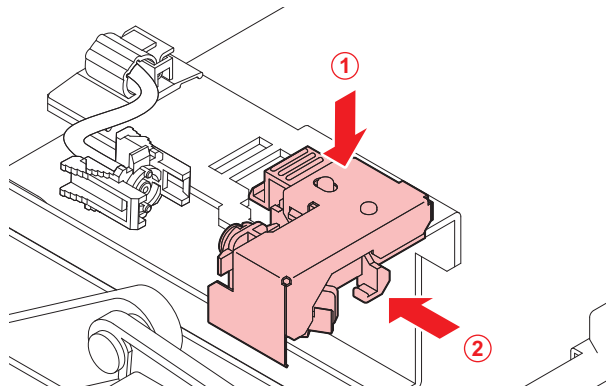
5 Remove the wiper cleaner.

- Slide forward to remove.



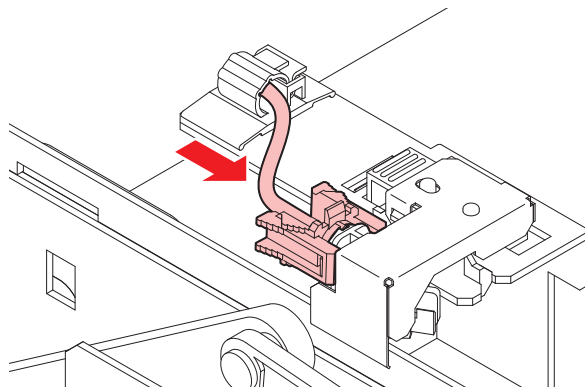
6 Mount a new wiper cleaner.

- 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.



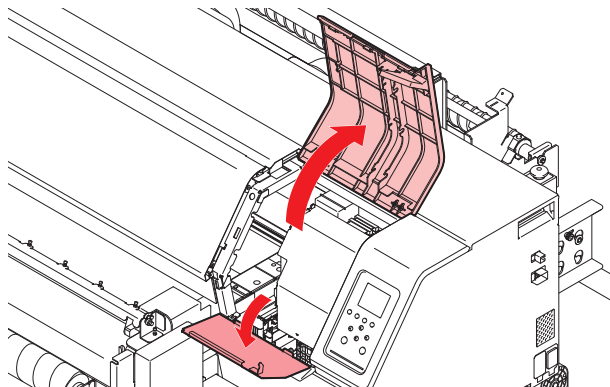
- We recommend replacing the cap every six to twelve months.
(TP ink: every six months, other ink: every twelve months)

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

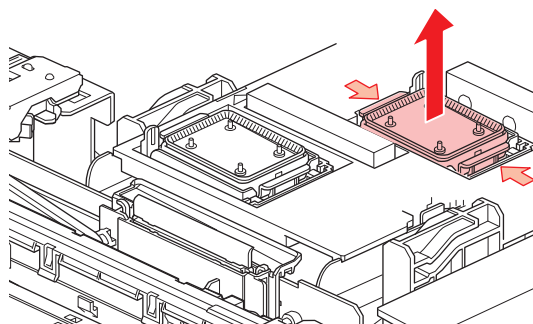
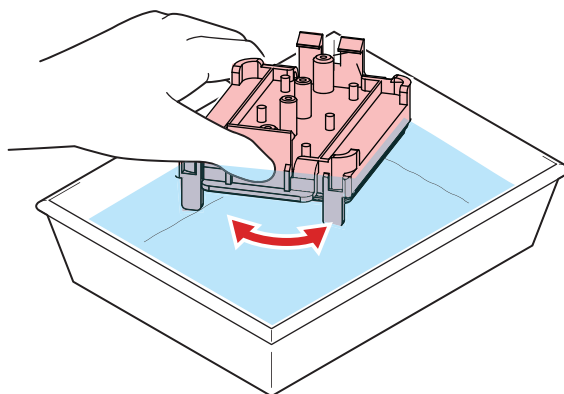
- The Maintenance menu is displayed.

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

- The carriage moves over the feeding belt.

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

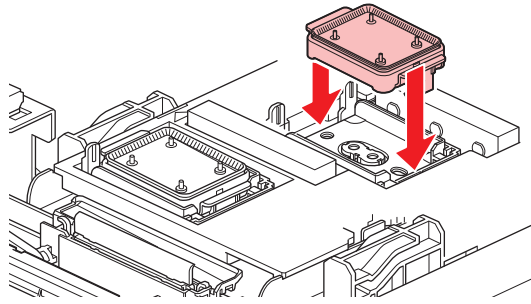
- Squeeze the lugs on either side of the cap and pull off.

**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.

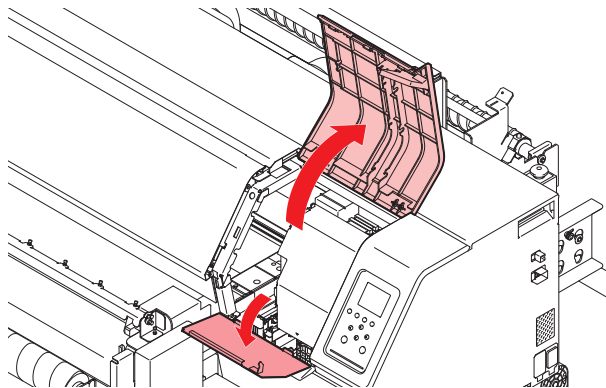
1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- The Maintenance menu is displayed.

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

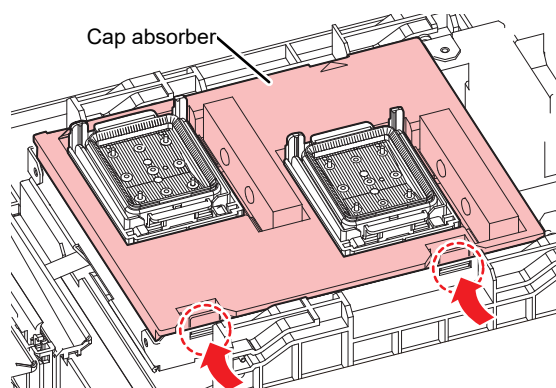
- The carriage moves over the feeding belt.

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.

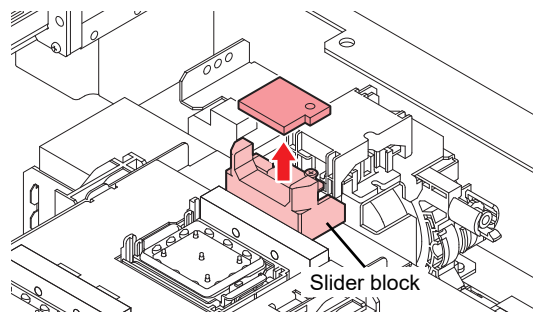
6 Mount a new cap absorber.

- Insert the tabs on the plate into the slits in the cap absorber.



- Check to confirm that the cap absorber does not become detached.

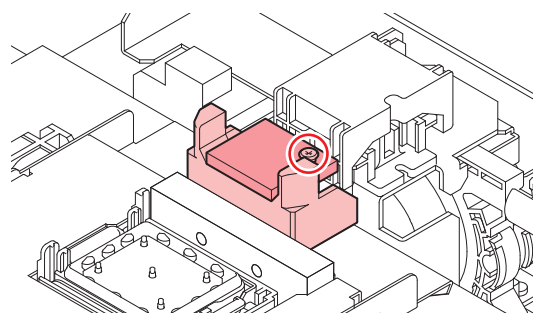
7 Remove the maintenance liquid absorber.



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.

Blowing Fan Filter Replacement

Replace the blowing fan filter if it is dirty.



If sublimation transfer ink is used

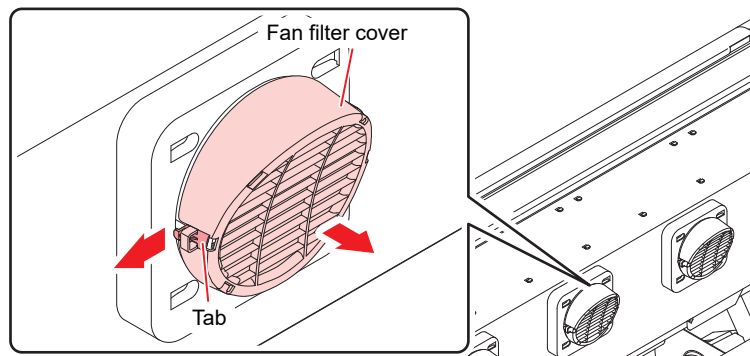
- Replace the filter every three months.



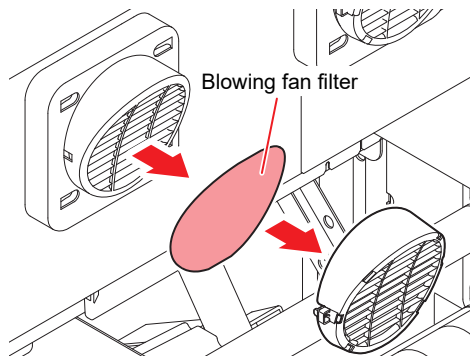
- Turn off the main power and unplug the power cable before replacement.

1 Remove the fan filter cover.

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

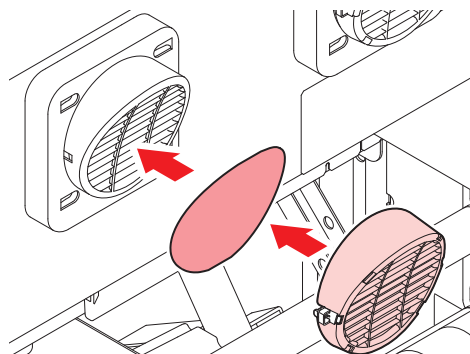


2 Remove the filter.



3 Mount a new filter and the fan filter cover.

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



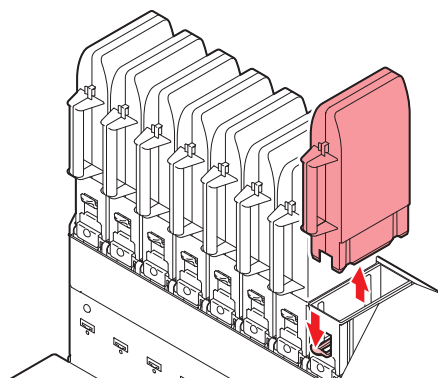
Ink Supply Unit Ink Absorber Replacement

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.

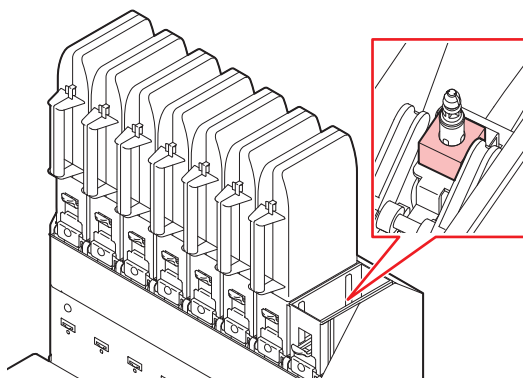


- Pay close attention to ventilation and be sure to wear safety glasses, gloves, and a mask when handling ink, maintenance liquid, waste ink, or other solutions used with the machine. Leaking ink may adhere to the skin or get into the eyes or mouth.

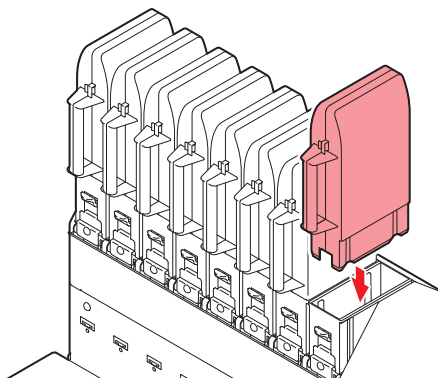
- 1 Push down the lever on the pedestal, and remove the ink Eco-case.**



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



- 3 Set an eco-case on the base.**



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.

Check Waste Ink tank Level: xx %

- 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"\(P. 163\)](#).

- 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

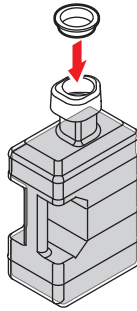
- 1 On the LOCAL mode screen, select [MENU] > [Maintenance], then press the [ENTER] key.

- 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.

Chapter 5 Troubleshooting



This chapter

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



Troubleshooting.....	166	Problems Causing Messages to Appear	169
The power does not turn on.	166	Warning Messages	169
Printing is not possible.	166	Ink Error	171
The media jams or the media is dirty.	166	Error Message	172
Image defects occur.....	166	SYSTEM HALT	178
The ink has leaked out.....	168		

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. 55)

Image defects occur.

Symptom	Corrective action
White streaks, blurriness, and dark streaks occur. (Carriage scan direction)	<ol style="list-style-type: none"> 1. Perform the procedure described in  "Head Cleaning"(P. 91). 2. Perform the procedure described in  "Feed Correction"(P. 92). 3. Perform the procedure described in  "Cap Rubber Cleaning"(P. 118).

Symptom	Corrective action
	<ol style="list-style-type: none"> Perform the procedure described in "Carriage Underside Cleaning"(P. 119). Perform the procedure described in "Cleaning the Feeding Belt"(P. 147).
Text is double- or triple-printed in the media feed direction.	<ol style="list-style-type: none"> Perform the procedure described in "Feed Correction"(P. 92).
Offsetting occurs during bidirectional printing.	<ol style="list-style-type: none"> Perform the procedure described in "Correcting the Drop Position"(P. 94).
Ink droplets drip during printing.	<ol style="list-style-type: none"> Perform the procedure described in "Cap Rubber Cleaning"(P. 118). Perform the procedure described in "Carriage Underside Cleaning"(P. 119). Perform the procedure described in "Head Cleaning"(P. 91). Set auto maintenance. "Maintenance Menu"(P. 104)
Nozzles are clogged.	<ol style="list-style-type: none"> Perform the procedure described in "Head Cleaning"(P. 91). Perform the procedure described in "Print Head Nozzle Washing"(P. 167). Perform the procedure described in "Registering Nozzle Recovery"(P. 107).
Are the print heads too high?	Adjust the print head height. "Adjusting Print Head Height" (P. 51) If the print heads cannot be lowered, increase the refresh level of maintenance during printing ("Maintenance Menu" (P. 104)) to Standard or Strong and perform regular test printing to check for nozzle clogging.
Are there any ink colors that aren't used much?	Discharge from infrequently used nozzles tends not to be consistent. Although increasing the refresh level of maintenance during printing ("Maintenance Menu" (P. 104)) to Standard or Strong will enable more frequent nozzle use, note that this will also increase ink consumption.
Are you using media easily affected by static electricity?	Increase the refresh level of maintenance during printing ("Maintenance Menu" (P. 104)) 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. 104)) 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. 91)), 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 feeding belt.
- 3 Open the maintenance cover on the right side.**

4 Clean the cap rubber.

-  ["Cap Rubber Cleaning"\(P. 118\)](#)

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

- The cap is filled with maintenance liquid.



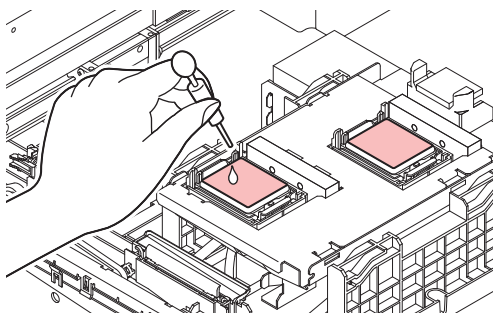
- Close the cover. The cap cannot be filled with maintenance liquid while the cover is open. This is also true if the maintenance liquid cartridge is empty.

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. 122) 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 NCU Sens Adj Err L	<ul style="list-style-type: none"> Sensor sensitivity adjustment failed. 	
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. 171)
COVER OPEN	<ul style="list-style-type: none"> The cover is open. An emergency stop switch was pressed. 	<ul style="list-style-type: none"> Close the cover. Reset the emergency stop switch.  "Emergency Stop Switches"(P. 20)
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. 157)
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. 154)
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. 55)
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. 120)

Message	Cause	Corrective action
		2. 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. 	1. Check the waste ink levels in the waste ink tank. "When "Check Waste Ink Tank" message appears"(P. 163) 2. Replace the waste ink tank, then reset the waste ink level. "Replacing the lower-left waste ink tank"(P. 163)
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. 17)
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. 123) If automatic correction fails repeatedly, correct the position manually. "Feed Correction"(P. 92) "Correcting the Drop Position"(P. 94)
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.
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.
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.
Lower Pressure Roller	<ul style="list-style-type: none"> The pressure roller is raised when printing is ready to begin. 	<ul style="list-style-type: none"> Make sure the pressure roller is lowered. If this warning is displayed even when the pressure roller is lowered, contact your local dealer or our service office.
Raise Pressure Roller	<ul style="list-style-type: none"> The pressure roller is lowered when the power was turned off or belt cleaning was executed. 	<ul style="list-style-type: none"> Make sure the pressure roller is raised. If this warning is displayed even when the pressure roller is raised, contact your local dealer or our service office.



Message	Cause	Corrective action
Check Absorption Roller	<ul style="list-style-type: none"> It is time to check the absorption roller water level. 	<ul style="list-style-type: none"> Clean the absorption roller. Reset the absorption roller counter. "Resetting the Counter"(P. 149)
Belt Adhesive 200 m Remain	<ul style="list-style-type: none"> It is almost time to replace the adhesive. 	<ul style="list-style-type: none"> Apply new adhesive. "Reapplying Adhesive"(P. 136) Reset the adhesive counter. "Resetting the Counter"(P. 149)
Reapply Belt Adhesive	<ul style="list-style-type: none"> It is time to replace the adhesive. 	
Peeling error. Check the media unit position.	<ul style="list-style-type: none"> A peeling sensor error occurred. 	<ul style="list-style-type: none"> Manually remove any loaded media. Use the take-up motor switch to take up the peeled off media.
Supply Washing Water	<ul style="list-style-type: none"> Printing stopped because there is not enough washing water in the washing unit. 	<ul style="list-style-type: none"> Supply washing water to the washing unit. "Washing Water Replacement"(P. 130)
Replace Washing Unit Water	<ul style="list-style-type: none"> One week has passed since the washing water was replaced. 	<ul style="list-style-type: none"> Drain and supply washing water to the washing unit. "Washing Water Replacement"(P. 130) <p>To avoid weaker belt cleaning, regularly replacing washing water in the washing unit is recommended.</p>






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)







Message	Cause	Corrective action
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	<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)
108	HD CONNECT[12]	<ul style="list-style-type: none">A problem was detected with the print head connection.	
108	HD MEM EMP[12]	<ul style="list-style-type: none">A problem was detected with the print head.	
10e	FROM CLEAR	<ul style="list-style-type: none">A problem was detected with the main PCB.	
10f	FROM WRITE		
115	PCB MAIN-F1		
122	CHECK:SDRAM	<ul style="list-style-type: none">A problem was detected with the SDRAM.	
122	PRAM NONE		
123	PRAM DATA	<ul style="list-style-type: none">A problem was detected with the main PCB.	
124	PRAM ADDR		
127	POWER OFF		
128	HDC FIFO OVER / HDC FIFO UNDER	<ul style="list-style-type: none">A problem was detected with the print head control PCB.	
129	Battery Exchange	<ul style="list-style-type: none">The internal clock battery is spent and must be replaced.	<ul style="list-style-type: none">Contact your local dealer or our service office.
12a	HDC SPEED	<ul style="list-style-type: none">A problem was detected with the print head 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)
12d	PCB MAIN-F4	<ul style="list-style-type: none">A problem was detected with the main PCB.	
130	HD DATA SEQ	<ul style="list-style-type: none">A problem was detected with the print head control.	
147	DS-IC BUSY	<ul style="list-style-type: none">Ink IC control abnormality detected.	
148	E-LOG SEQ	<ul style="list-style-type: none">A log control abnormality was detected.	




Error number	Message	Cause	Corrective action
151	Main PCB V1R2	<ul style="list-style-type: none">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	<ul style="list-style-type: none">The HDCE PCB COM driver is hot.	
171	NEW HEAD CONNECT	<ul style="list-style-type: none">A new print head connection was detected.	
186	HDC OVERFLOW/HDC UNDERFLOW	<ul style="list-style-type: none">A problem was detected with the print head control.	
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]		
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">1. Clear the data and resend.2. Check the USB/Ether cable connection.  "Connecting a PC to the Product"(P. 36)3. Use a compatible cable.  "Connecting a PC to the Product"(P. 36)4. 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)

Error number	Message	Cause	Corrective action
304	USB INIT ERR	<ul style="list-style-type: none"> A problem was detected with the USB cable connection. 	1. Check the USB cable connection. "Using a USB Cable"(P. 37)
305	USB TIME OUT		2. Use a compatible cable. "Using a USB Cable"(P. 37) 3. Turn off the main power and wait a while before turning back on. "Turning Off the Power"(P. 34)
318	SDcard Connection ERR	<ul style="list-style-type: none"> A problem was detected with the SD card. 	1. 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. 	1. Check to confirm the media is loaded correctly. "Loading the Media"(P. 55)
402	Motor Y	<ul style="list-style-type: none"> The Y motor was overloaded. 	2. Open the front cover and check for anything that may obstruct carriage movement.
403	X Current	<ul style="list-style-type: none"> An overcurrent error was detected in the X motor. 	3. Turn off the main power and wait a while before turning back on. "Turning Off the Power"(P. 34)
404	Y Current	<ul style="list-style-type: none"> An overcurrent error was detected in the Y motor. 	
406	Wiper Move Failure	<ul style="list-style-type: none"> The wiper origin could not be detected. 	1. Clean the wiper and around the wiper. "Wiper Cleaning"(P. 120) 2. Turn off the main power and wait a while before turning back on. "Turning Off the Power"(P. 34)
424	Feed tension bar	<ul style="list-style-type: none"> 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. 60) 3. Check to confirm the media is loaded correctly.
426	Feeding Wrong	<ul style="list-style-type: none"> 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.
42a	Feeding LimitDetect	<ul style="list-style-type: none"> 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. 60) 3. Check to confirm the media is loaded correctly.
44f	Take-up Roll Sns Err	<ul style="list-style-type: none"> 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. 109) 2. Check to confirm the media is loaded correctly. "Loading the Roll Media"(P. 66) 3. Check to confirm the take-up unit switch functions properly. "Take-up unit"(P. 56)
450	Feeding Roll Sns Err	<ul style="list-style-type: none"> A problem was detected with the feeding unit sensor spindle. 	1. Check to confirm the [Function Setting] > [Option Roll Unit Select] > [Feeding Unit] setting is "ON". "Function Setting Menu"(P. 109)

Error number	Message	Cause	Corrective action
			<ol style="list-style-type: none"> 2. Check to confirm the media is loaded correctly.  "Loading the Roll Media"(P. 66) 3. Check to confirm the feeding unit switch functions properly.  "Feeding unit"(P. 60)
46d	Wash Unit Org	<ul style="list-style-type: none"> • Cannot detect the washing unit origin. 	<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) • If this message is displayed again, contact your local dealer or our service office.
46f	Peel Sensor	<ul style="list-style-type: none"> • Failed to detect the peeling sensor (slack sensor). 	<ol style="list-style-type: none"> 1. Manually take up the media so that no media is over the peeling sensors. 2. Confirm that the take-up motor rotation direction switch is set to the correct direction. <ul style="list-style-type: none"> • If this message is displayed again, contact your local dealer or our service office.
470	Peeling warn	<ul style="list-style-type: none"> • Error during peeling (sensor ON/OFF detected continuously). 	<ol style="list-style-type: none"> 1. Make sure that both edges of the media can be peeled off evenly. 2. Confirm that the take-up motor rotation direction switch is set to the correct direction. 3. Manually peel off the media and take it up with the take-up switch.
471	Media Involvement	<ul style="list-style-type: none"> • Peeling sensor EM (bottom sensor) detection. 	<ol style="list-style-type: none"> 1. Make sure the media has not been taken up to an area near the washing unit. 2. Confirm that the take-up motor rotation direction switch is set to the correct direction. 3. Manually peel off the media and take it up with the take-up switch.
472	Displace Sensor ORG.	<ul style="list-style-type: none"> • Cannot detect the correction unit displacement sensor origin. 	<ol style="list-style-type: none"> 1. Confirm that belt correction is set to "ON."  "Media Setting Menu"(P. 102) 2. Turn off the main power and wait a while before turning back on.  "Turning Off the Power"(P. 34) <ul style="list-style-type: none"> • If this message is displayed again, contact your local dealer or our service office.
473	Grip Slip	<ul style="list-style-type: none"> • During feeding, the correction unit grip section origin did not go off, or the displacement sensor is not responding. 	<ol style="list-style-type: none"> 1. Clean adhesive off the right edge of the feeding belt. 2. Clean adhesive off the belt correction unit rubber gripper.  "Belt Correction Unit Cleaning"(P. 127)
475	Belt Comp. Error	<ul style="list-style-type: none"> • Incorrect value of the belt correction unit displacement sensor. 	<ol style="list-style-type: none"> 3. Manually peel off the media and take it up with the take-up switch. <ul style="list-style-type: none"> • If this message is displayed repeatedly, contact your local dealer or our service office.

Error number	Message	Cause	Corrective action
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. 	
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. 55) 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). 	
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. 55) Clean the DAS sensor. "DAS (Automatic Correction Function) Sensor Cleaning"(P. 123)
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.
53e	Wash Liquid Full	<ul style="list-style-type: none"> The belt washing tray is full of water. 	<ol style="list-style-type: none"> Adjust the flow rate of the washing water. Check if the washing water discharge channel is clogged.
53f	Check Wash liquid	<ul style="list-style-type: none"> There is little water in the belt washing tray. 	<ul style="list-style-type: none"> Add water to the belt washing tray.
54d	HDCE Cooling Fan Err	<ul style="list-style-type: none"> An HDCE cooling fan rotation abnormality was 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)
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)

Error number	Message	Cause	Corrective action
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 ****		
81b	FW/STACK OV	<ul style="list-style-type: none">• A problem was detected with the main PCB.	
828	PRG ERR L *****		
901	Operation Error	<ul style="list-style-type: none">• The function is disabled due to an error.	<ul style="list-style-type: none">• Check the error details.
902	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.
90f	Print Area Short	<ul style="list-style-type: none">• The media is too small for the print.	<ul style="list-style-type: none">• 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.

Error number	Message	Cause	Corrective action
b1a	PCB Baselo1	<ul style="list-style-type: none">• A communication error was detected between the boards.• A problem was detected with the Base IO PCB power supply.	<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)
b1a	PCB Baselo2		
b1b	Baselo PCB Vpow-s		
b1c	Baselo PCB V24		
b1e	PCB Baselo-F**	<ul style="list-style-type: none">• The Base IO PCB fuse blow was detected.	<ul style="list-style-type: none">• The fuse must be replaced. Contact your local dealer or our service office.
b36	PCB INKIO	<ul style="list-style-type: none">• A communication error was detected between the boards.	<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)
b3f	Baselo Unconform	<ul style="list-style-type: none">• The PCB could not be detected.	
b48	PCB HDCE*	<ul style="list-style-type: none">• A communication error was detected between the boards.	
b49	PCB HDCE-VHVFET[12]	<ul style="list-style-type: none">• A problem was detected with the HDCE PCB power supply.	
b4a	PCB HDCE*-F*	<ul style="list-style-type: none">• A blown fuse on the HDCE PCB was detected.	<ul style="list-style-type: none">• Contact your local dealer or our service office.
b4b	HDCE* PCB V1R2	<ul style="list-style-type: none">• A problem was detected with the HDCE PCB power supply.	<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)
b4c	HDCE* PCB V2R5		
b4d	HDCE* PCB V3R3		
b51	Baselo PCB V24adj	<ul style="list-style-type: none">• A problem was detected with the Base IO PCB power supply.	
d1b	COM VOLT[12]	<ul style="list-style-type: none">• 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			Tx330-1800B
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, 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		Sb420: M, Bl, Y, K / TP410: M, C, Y, K
Media	Type		Cloth
	Maximum printing width*1		1,890 mm
	Maximum width		1,900 mm
	Minimum width		210 mm
	Thickness		Max. 5.0 mm
	Roll external diameter*2		Max. 250 mm
	Roll weight*2, 3		Max. 40 kg (2 to 3-inch paper core) Max. 34 kg (1 to 1.5-inch paper core)
	Paper core internal diameter		1 to 1.5 inches, 2 to 3 inches
	Printing face		Exterior/interior
	Roll end		Taped or loosely affixed to paper core
Print margins	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			±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)
Take-up unit			Provided

Item		Tx330-1800B
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 52 dB (FAST-A, 1 m on all sides)
	Continuous operation	Not more than 56 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 $\pm 10\%$ /5 A, 50/60 Hz ± 1 Hz
Power consumption	Maximum ^{*9}	300 W or less
	Standard	190 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 (3,430 mm)
	Depth	1,912 mm (1,140 mm)
	Height	1,900 mm (2,200 mm)

Item	Tx330-1800B
Weight ^{*12}	622 kg (848 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 B	OPT-J0431	
OPT-DsubBKT	OPT-01012	
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 Tx330-1800B allows only one relay box (OPT-J0370 or OPT-J0407) to be connected.



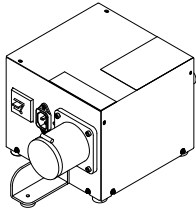
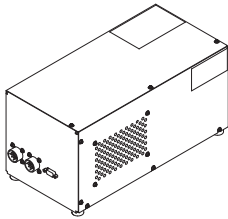
- The optional connection relay cable (OPT-J0512 drying fan connection kit) and the mounting bracket (OPT-01012 OPT-DsubBKT) are required when using a relay box.

● 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

Index

A

Absorption Roller	113, 133
Adhesive	113
Adjust Waste Ink Volume	163
Air PG	106
Auto Cleaning	105
Auto Maint.	24, 104, 105
Auto Nozzle Recovery	105
Auto Power-off	109
Auto Power-on	109
Auto Remote	110
Auto-correction (DAS)	102, 170

B

Belt Adhesive	106
Belt Cleaning	106
Belt Maintenance	106
Belt Washing Unit	24, 106
Blowing fan	26, 129, 161

C

Cancel	30
Cap	28, 117, 118, 157
Cap absorber	159
Cap Replacement	104, 113
Capping Use Days	113
Carriage	24, 28, 30, 104, 117, 119
Carriage Out	104
Cleaning	91, 104
Cloth-wound roller	25, 26
Color profile	39
Connection relay cable	183
Counter Reset	106
Curved bar	26
Custody Wash	104, 150

D

DAS (Dot Adjustment System)	102, 117, 123
Delete MediaInfo	103

Detail Setting	103
DISCLAIMERS	6
Display	30
Display language	111
Doctor	24
Drop.PosCorrect	32, 49, 94, 102
Drying Time	109

E

Ejection failures	89, 91, 104, 107, 120, 157, 166
[END/POWER] key	29, 30, 34
[ENTER] key	30
Environment Setting Menu	111
Error	30, 169
Error History	113

F

FCC	6
Feed Comp.	32, 49, 92, 102
Feed Speed	103
Feeding belt	25
Feeding tension bar	26
Feeding unit	26, 60
Front cover	24
[FUNCTION] key	30, 32
Function Setting Menu	109

H

Head Cleaning	30
Head height	51
Heater	29
Height adjustment lever	51

I

Ink absorber	43, 162
Ink discharge channel	124
Ink Eco-case	42, 44, 45
Ink End	41, 106
Ink Error	31
Ink IC chip	42, 43, 46
Ink IC chip slot	46
INK NEAR-END	41

Ink pack	42, 43
Ink replacement	113
Ink status	31
Ink Supply Unit	43, 162
Inlet	26, 33
Installation guide	39, 40
Installation Space	18
Interference	6
interlock	19

J

Jam sensor	24, 117, 126
[JOG] key	30
Judgment Condition	105

K

Key Buzzer	111
KeyLife	112

L

LAN cable	26, 36
LAN port	26
LANGUAGE	111
List	113
Local guidance	32
LOCAL mode	30, 31
Logical Seek	109

M

Machine Status Menu	113
Main power switch	26, 29, 33
Maintenance	113
Maintenance cover	24
Maintenance History	113
Maintenance liquid absorber	159
Maintenance liquid cartridge	26
Maintenance Menu	104
MAPS (Mimaki Advanced Pass System)	102
Margin	110
Media	55
Media feed	30
Media Information	103

Media Name Change	103
Media Remain	103
Media Setting Menu	102
MENU mode	31
Mimaki driver	39
MRA (Mimaki Remote Access).....	111

N

NCU (Nozzle Check Unit).....	122
Network	111
NOT-READY mode	31
Nozzle Check	108
Nozzle clogging	91, 108
Nozzle Deflection	91
Nozzle Recovery	104, 107
Nozzle Wash	104, 167

O

Operating Panel	24, 30
Option Roll Unit Select	109

P

Peeling roller	24
PIN code.....	112
Power cable.....	33
Power outlet	33
Power plug	33
Power Setting	109
Pre Feed.....	103
Pressure roller	26
Print Area	113
Print Length	113
Print Maint.	105
Print origin	98
Pump Tube Cleaning.....	104, 124

R

RasterLink	39, 40, 96, 97, 109, 110
Receive buffer	100
Reference guide	97
Refresh	106
Relay box	183

Remaining ink	31
Remote Control	111
REMOTE mode	30, 31
Replace Water	106
Replace Wiper	104, 113, 154
Reversing bar	26
Roll holder setting position label	65

S

[SEL] key	30
Smoothing Level	103
Smoothing roller	26
Station	24, 28
Station Maint.	104
Status lamp	30
Switching hub	36
Symbol	8
SYSTEM HALT	30

T

Take-up diameter detection	109
Take-up unit	24, 56
Test Printing	30, 89, 104
Time Set	111
Top Blower	110

U

Unit Setting	111
Usage	113
USB interface cable	26, 37
USB port	26
Use Time	113

V

Version	113
View Feed	110

W

Warning Label	21
Waste Ink Tank	24, 113, 117
Water supply valve	24
WhiteSpace Setting	110

Wiper 28, 104, 120, 154

Wiper cleaner 155

WIPING 113

Operation manual

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