DTF STATION

Prestige L2

User Manual

For Maintenance & Troubleshooting Videos	Looking for Tech Support? Join Slack!

Thank you for your purchase!

- To ensure proper and safe use of this product and a comprehensive understanding of its performance, be sure to read this manual thoroughly and keep it safe.

- It is forbidden to illegally copy this manual, in whole or in part, otherwise the company will be investigated for legal responsibility in accordance with the law.

- The contents of this manual and the parameters of this product are subject to change without notice.

- We have done our best to edit this operation manual and test this product. If you find any misprints or errors, please let us know. We greatly appreciate it!

June 2, 2023

Version 1.3

Chapter 1: Security Guidance

Please read the following instructions before using your DTF printer series. Please follow the warnings and instructions marked on the printer.

1.1 Important safety instructions：

- Do not block the openings in the housing of this printer.
- Do not insert any objects into the printer slots, and be careful not to spill liquids into the printer.
- Only the type of power supply identified in the printer's label can be used. Depending on the country and region, 110V or 220V AC power may be selected.
- Connect all equipment to a properly grounded outlet and avoid using outlets that are on the same circuit as copiers or air conditioning systems that regularly switch between on and off.
- Avoid using outlets that are controlled by wall switches or automatic timers.
- Keep your computer system away from potential sources of electromagnetic interference, such as speakers or cordless phone stands.
- Do not use damaged or frayed power cords.
- If using an additional power cord, remember that the total amperage of the devices plugged into that additional power cord should not exceed the amperage rating of that power source, and also remember that the total amperage of all devices plugged into the wall should not exceed the amperage rating of the wall outlet.
- Do not attempt to repair the printer yourself.
- Have experienced service personnel come in after disconnecting power when
     If the power cord or plug is damaged.
     If liquid is spilled into the printer.
     If the printer is dropped or the case is broken.
     If the printer does not operate properly or there is a noticeable change in performance.

1.2 Precautions when using the printer：

- Do not move the print head by hand, as this may damage the printer.
- Always use the power switch to turn off the printer. However, when this key is pressed, the power will be cut off. Do not unplug the printer or the data cable until the power is disconnected.
- Before handling the printer, ensure that the print head is in its initial position and that it is secured.
- The nozzle is an important part, pay attention to maintenance and use, avoid scratching or blockage, the nozzle is not covered by the warranty

1.3 Precautions for using ink bottles：

- Please keep the ink bottle out of the reach of children and do not allow children to drink or touch the ink bottle.

- If the ink sticks to your skin, rinse with soap and water. If ink splashes into your eyes, rinse off immediately with water.

- Do not shake the ink bottle, this will cause the ink to leak.

- After using the ink bottle for a period of time (usually three months), remove it immediately for thorough cleaning and drying. Replace the new ink bottle to pay attention to clean, to ensure the quality of printing.

1.4 Printer Installation Requirements

- Venue preparation

It is the customer's responsibility to comply with all

installation requirements and to implement them

during the operation of the machine. If this is not done,

there is a risk that the machine may not function properly.

The workspace is the area immediately adjacent to the DTF machine (hereinafter referred to as the equipment), as shown in the figure. It should be emphasized that users should ensure the safety of operators in this area.

Length *width*height: 1160mm*750mm*1416mm
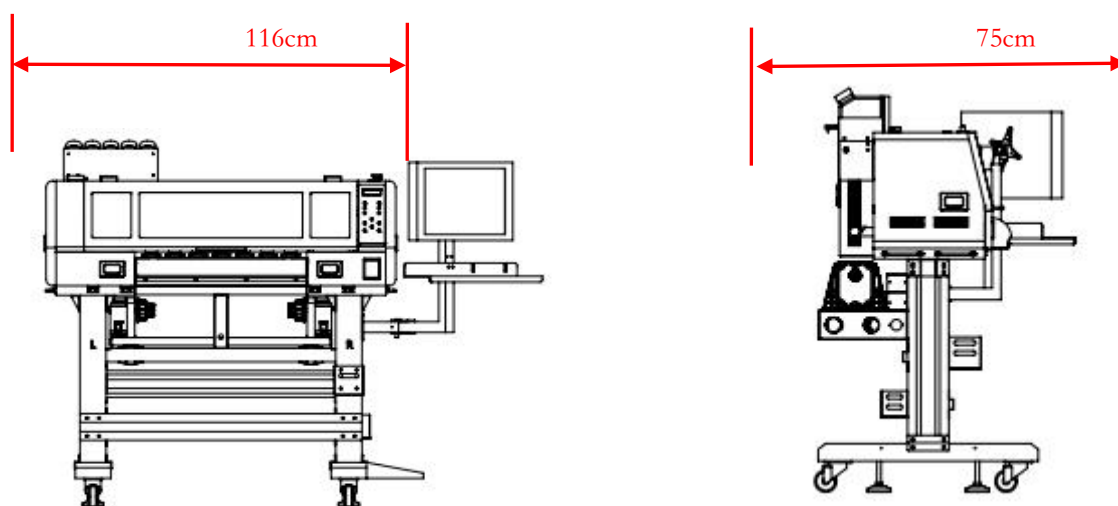
Figure 1: Schematic diagram of the workspace surrounding a DTF machine (unit: Cm)

- **Environmental requirements**

This machine belongs to high-power, high-temperature equipment, please provide suitable for the industrial power required by this equipment and suitable places

Equipment should be kept away from seam equipment (cloth feeders) or other radio frequency sources. Floors should be easy to sweep and do not generate dust and static electricity. In order to help the operator and customer judge the accuracy of the color, it should be decorated with neutral gray as much as possible and illuminated with pure white light (fluorescent lamp). Equipment should be installed in a clean, dust-free, temperature and relative humidity control environment within the following range: Altitude: Altitude: 1000 meters above sea level Operating temperature: 18 -28° C Relative humidity: 40% -60 %

- **Space reservation requirements**

The device requires a front reservation of 2.0 meters. 1.0 meters on the back and 1.0 meters on the left and right sides. In addition, the reserved space area includes a height of 3 meters above ground level. In addition, space should be left in front and behind the machine for loading and unloading screens and consumables.

- **Security requirements**

Correct use of the power supply, do not let go or touch the running part when printing, do not touch the power supply of the electrical box, if necessary, you can contact the manufacturer to guide the correct use, the use should be fixed with the foot cup

◆ **Fireproof**

Inks and solvents must be stored in a special storage cabinet or separate storage room for non-flammable liquids and must be clearly marked to comply with professional safety regulations.

Ink storage must strictly comply with local fire regulations regarding the use and storage of combustibles. Carbon dioxide and dry chemical fire extinguishers should be placed in a conspicuous and accessible location in all passages. They should be located near equipment and non-flammable liquid storage cabinets (chambers) or in accordance with local fire regulations.

◆ **Ventilation**

In order to prevent the danger of volatile gas accumulation, adequate ventilation is necessary to ensure that the air in the work area is replaced every 1 hour

About 6 to 8 times, the vents should be low enough that volatile gases cannot accumulate near the floor. As the fabric passes through the dryer, the solvent in the ink evaporates and an exhaust gas exhaust system is required to remove it. Note: The solvent gas ratio is greater than that of air and will accumulate near the floor.Electrical equipment installed near the work area must comply with GB/T standards, the provisions of the national electrical regulations on Class I and Class II sites, and be installed by a professional electrical contractor with corresponding qualifications. The regulations on the treatment of hazardous waste shall meet the specific special storage and treatment requirements of the relevant departments.

Electrical requirements **(UPS and power regulator are highly recommended)**

DTF printers use single-phase power, and the printer must be well grounded. (The ground + neutral voltage cannot be greater than 0.3V, and the ground resistance should be less than 3Ω.)

Supply voltage range 220V (±10%), AC 50Hz or 60Hz. The user must have an electrical professional or contractor install the power line output. Circuit breaker ratings are as follows:

Power Voltage	AC 220V	AC 110V
Single	10A/phase	20A/phase

The maximum power consumption is less than 2 kilowatts, and the average power consumption is 1 kilowatt. The UPS can use 2KV A to connect to other power other than heating.

The distance between the main power outlet and the power entry of the device must be no more than 2 meters.

DTF printing part power: About 1000W It is recommended to use a regulated power supply Installation of ground wire: Install the ground wire on the public connection subway board in the equipment. Then use the multimeter to hit the AC 200 range, one pin ground wire, the other hand to the neutral line at the AC input. Measured values of less than 1 are sufficient.

1.5 Warnings, cautions and notes

◆ **Warning**

◆ It must be complied with so as not to harm the human body

◆ **Admonish**

◆ It must be complied with so as not to damage the device

◆ **Note**

◆ Contains important information and useful tips for printer operation.

Chapter 2: Structural Diagrams

◆ 2.0 Features

● Automatic lifting of the bar

Note: If there is an automatic lifting rod, the automatic lifting rod must be used, and the function will be damaged by manual pulling

● Automatic paper placement

The installer needs to plug in the power supply and turn on the switch, and the automatic paper release makes the material more stable and prevents offsets
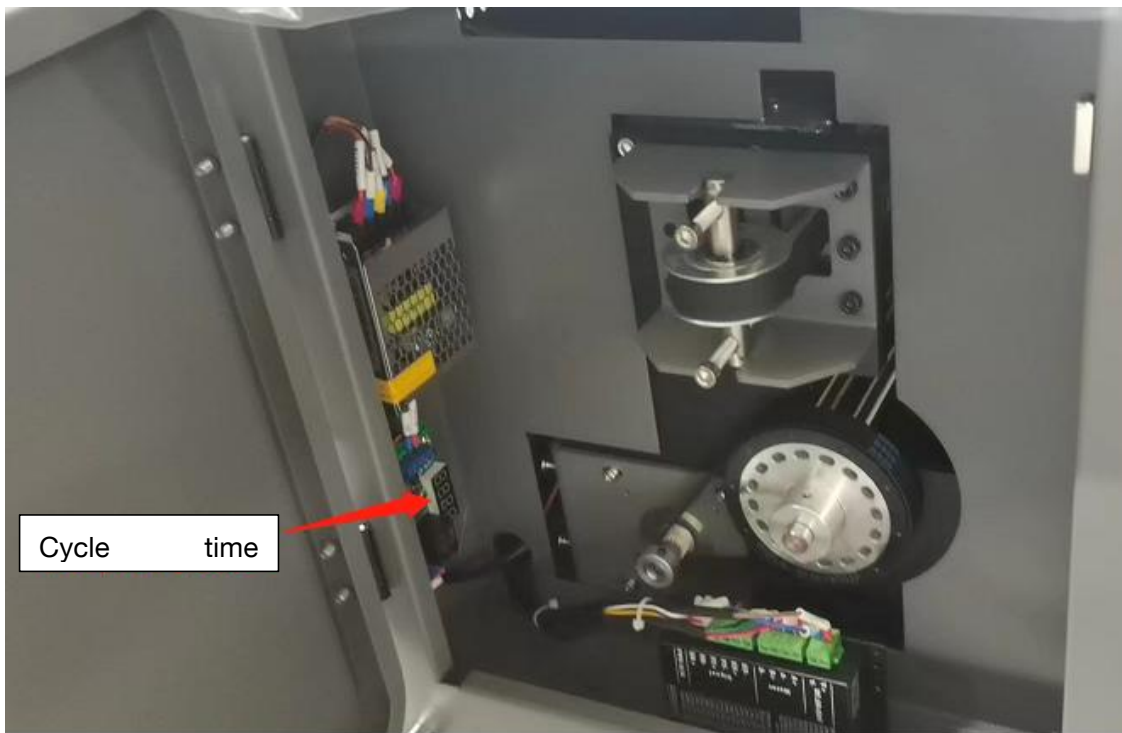
● 24-hour white ink cycle

The shutdown only turns off the emergency stop button, and the power switch retains power for 24-hour cycles

● The following illustration describes the functionality

Paper Dispenser

Cycle   time
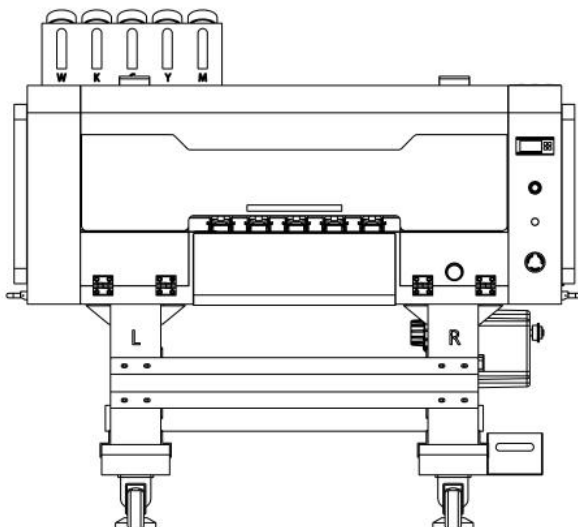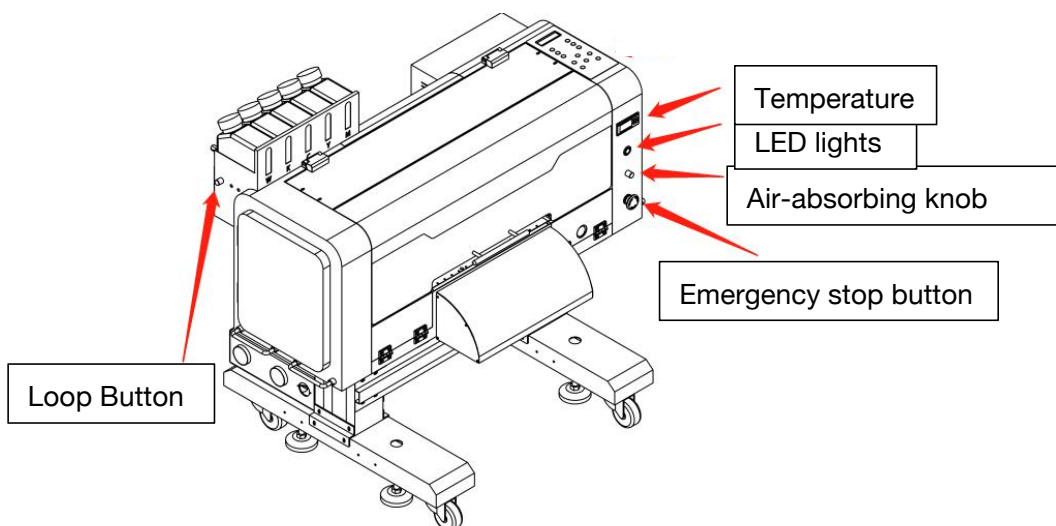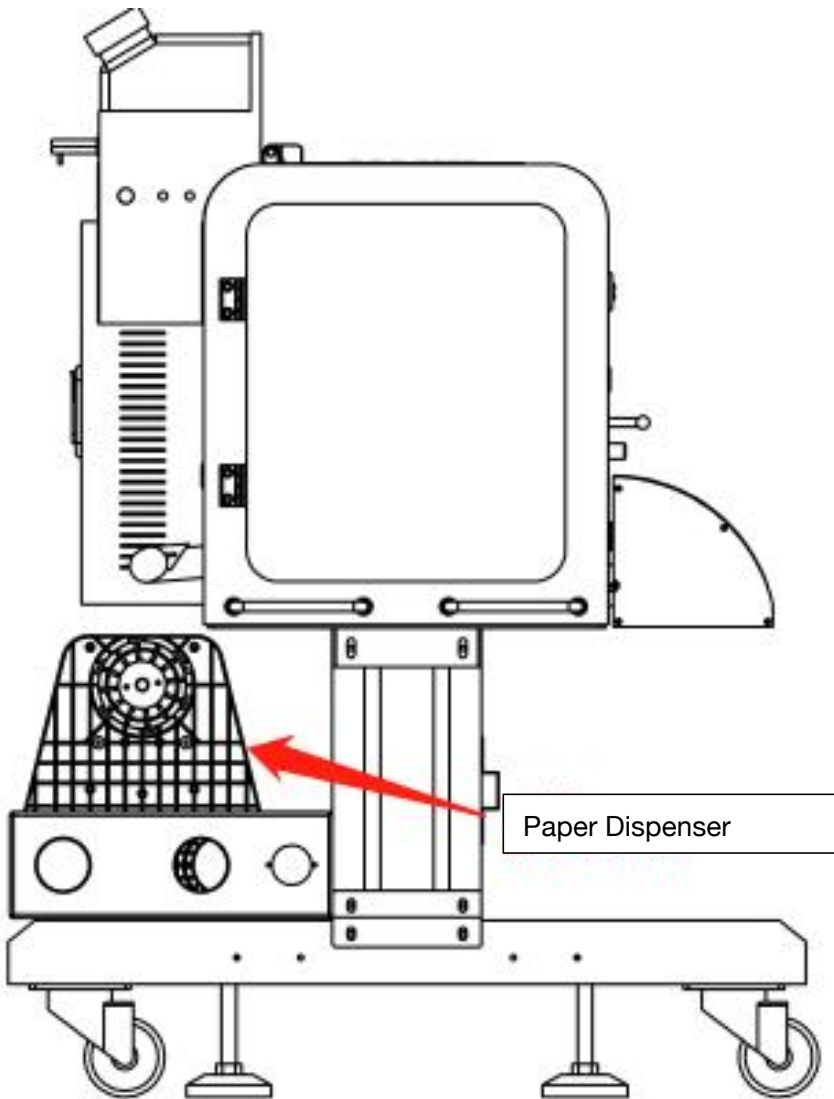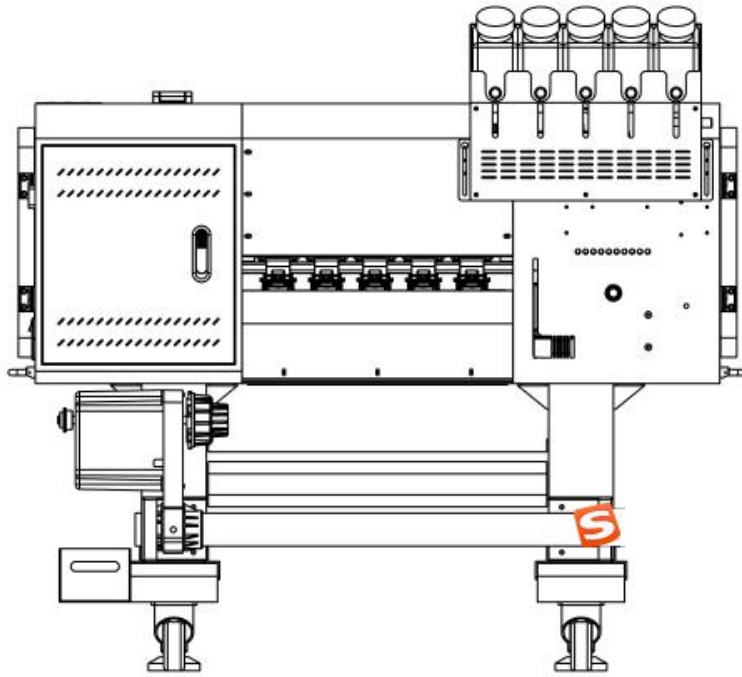
1:Press and hold the first button and change the mode to P31

2: R stop time changed to 10 seconds

3:b Working time changed to 10 seconds

4: Press the first key to determine the display (----) and then turn off the power supply to unplug the power cord, and plug in the power cord after 5 seconds to boot on

5: Note that when there is a decimal point, you can press the fourth button to cancel the decimal point.

Chapter 2: Structural Diagrams

2.1 Outline structure diagram
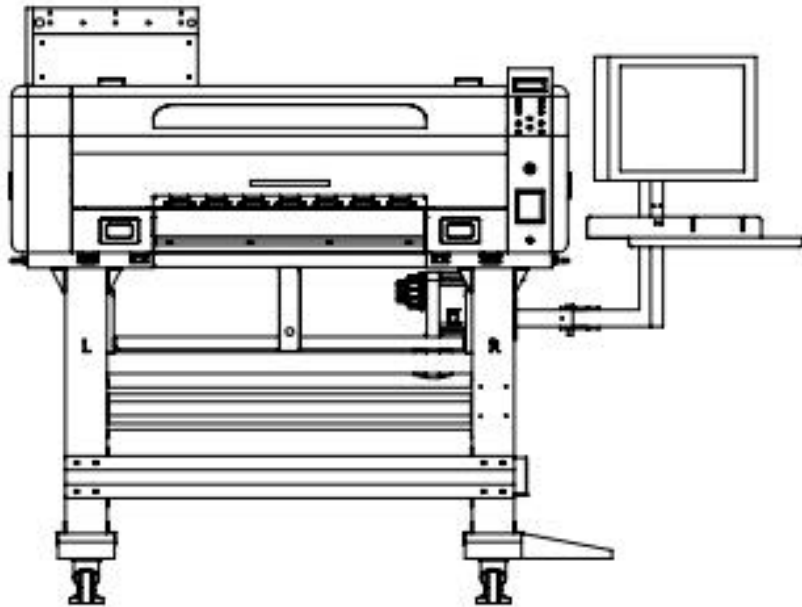
2.2 Trolley view structure diagram

K, Y, C, M

Left

color print head

Right anti-collision

White   print
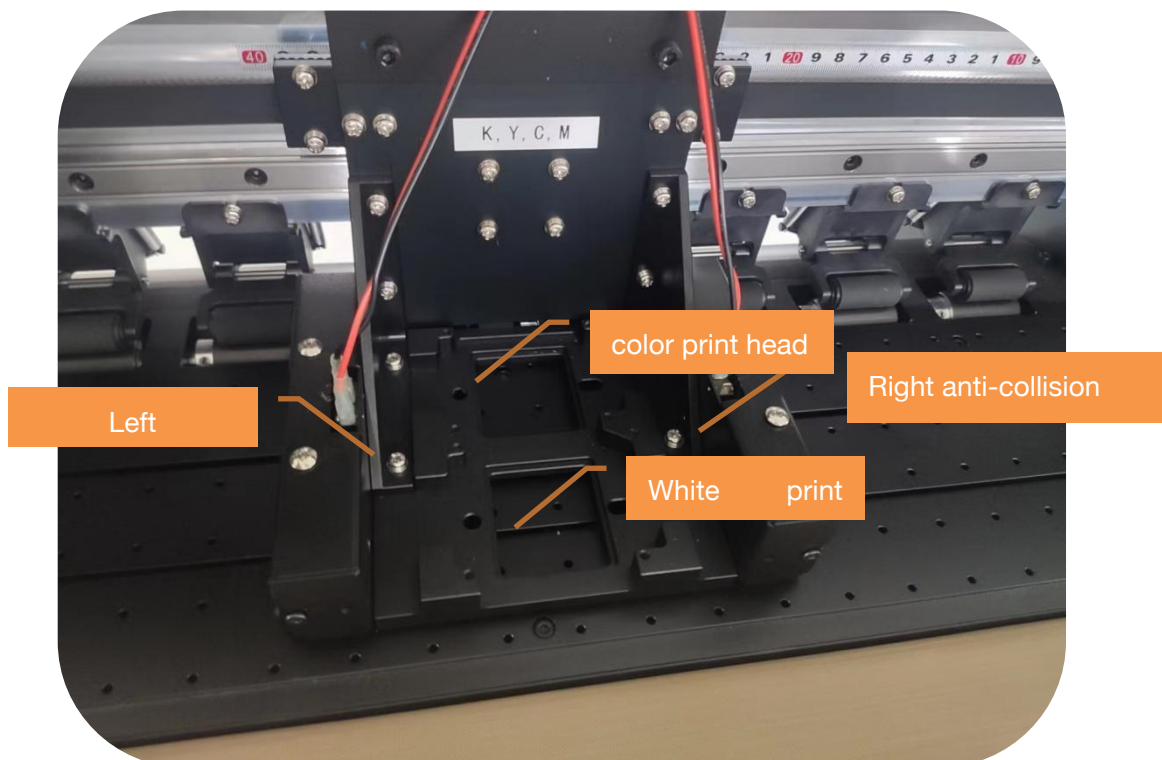
2.3 Printing the left view of the box
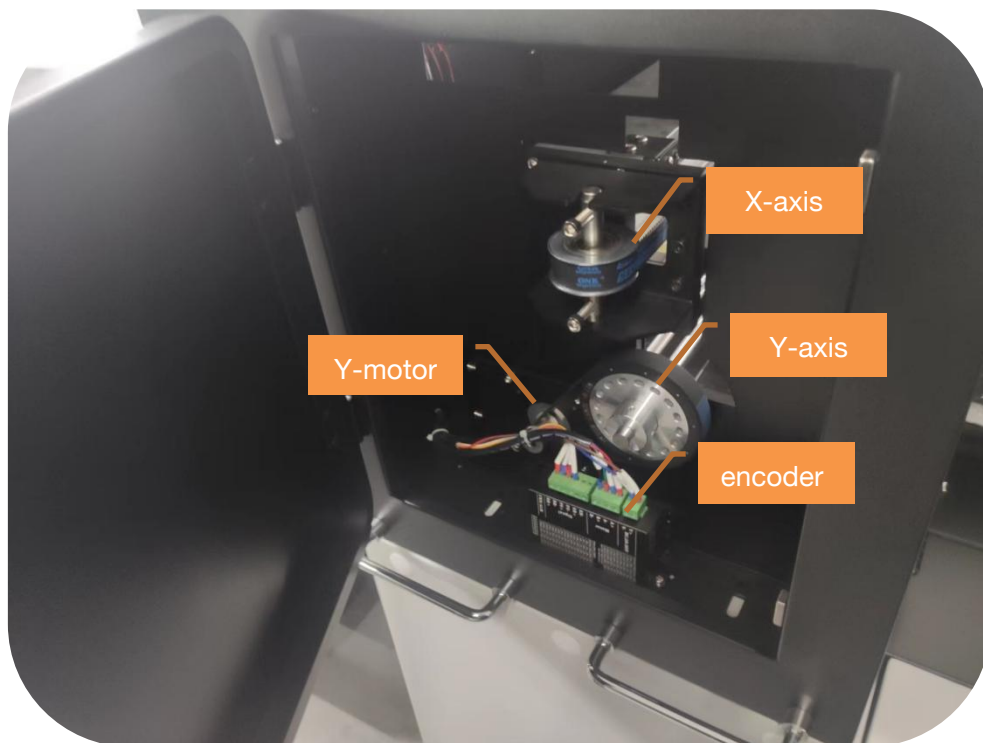
2.4 Printing the right view of the box
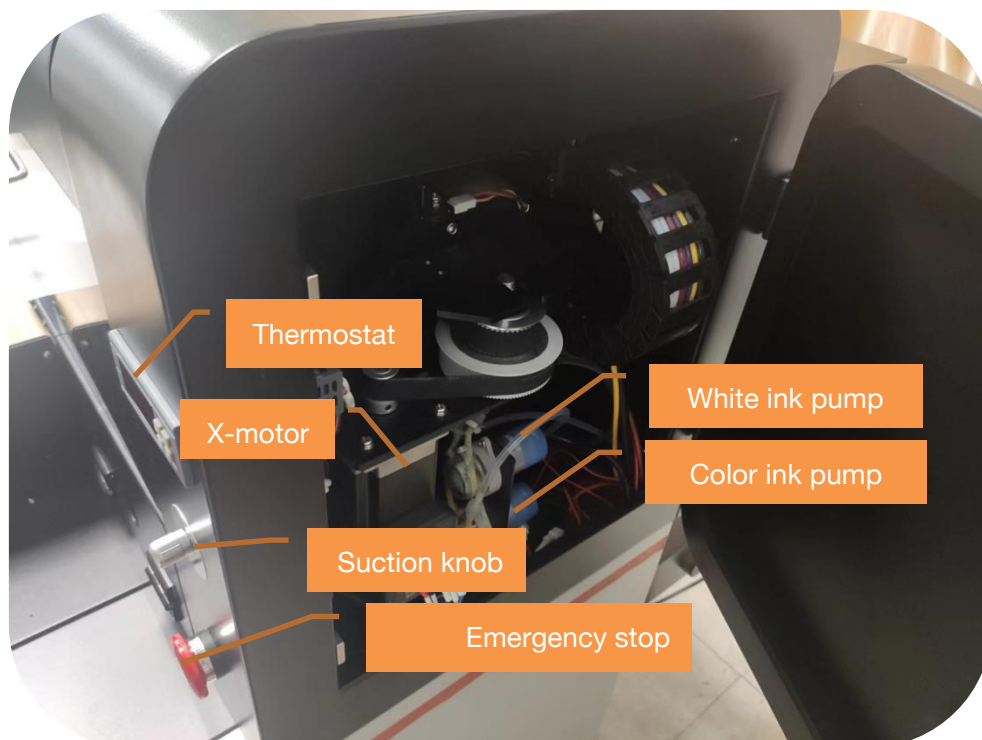
Chapter 3: Specifications

|	
Device model	Prestige L2 DTF Printer
Sprinkler type	I3200
Number of nozzles	2
Printing width	≤425mm
Print configuration	Color + White (KYCM+WWWW)
Applicable media	PET print film
Print accuracy	1400/1800/2400dpi
Print speed	6Pass 9.5 ㎡/H 8Pass 7.5 ㎡/H
Ink type	Pigment ink
RIP software	PP/ Maintop
Color management	ICC or Density Curve
Operating System	Windows 7, Windows 10
Heating and drying function	Heating of arc plates before and after printing
Trolley anti-collision function	Both ends of the trolley are equipped with touch anti-collision alarm emergency stop devices
Automatic discharge function	The discharge has probe induction automatic tension discharge
Lack of paper alarm function	The printing process is out of paper alarm, and the printing is automatically stopped
Waste ink alarm function	Automatic alarm when waste ink bottles are full
Circulating stirring function	White ink is independently powered, and it can be regularly and infinitely circulated and stirred when turned off
Ink shortage alarm function	Automatic alarm if the ink volume of the ink bottle is too low
Print platform lighting function	Print platform LED lighting
Automatic lifting rod pressing function	Platform discharge one-key automatic pressure lifting rod
PC assembly function	Comes with a combination stand for computer and monitor to save space
Platform suction	The suction size can be adjusted
Print interface	Gigabit network port
temperature	15 - 30℃
humidity	35-65%
Discharging function	Automatic induction discharge
Rated power	800W
Power input	50HZ/60HZ, 220V 3.6A
Net volume	139KG

| gross weight	Machine + wooden case 175KG
Machine size	Length*width*height 1160mm*750mm*1416mm
Package size	Length*width*height 1200mm*1000mm*711mm

Chapter 4: Hardware

4.1 Introduction to the printing system

The DTF print control system consists of three parts, namely the motherboard, the nozzle control board and the control software, using the USB2.0 port and PC connection.

4.2 Nozzle wiring and function
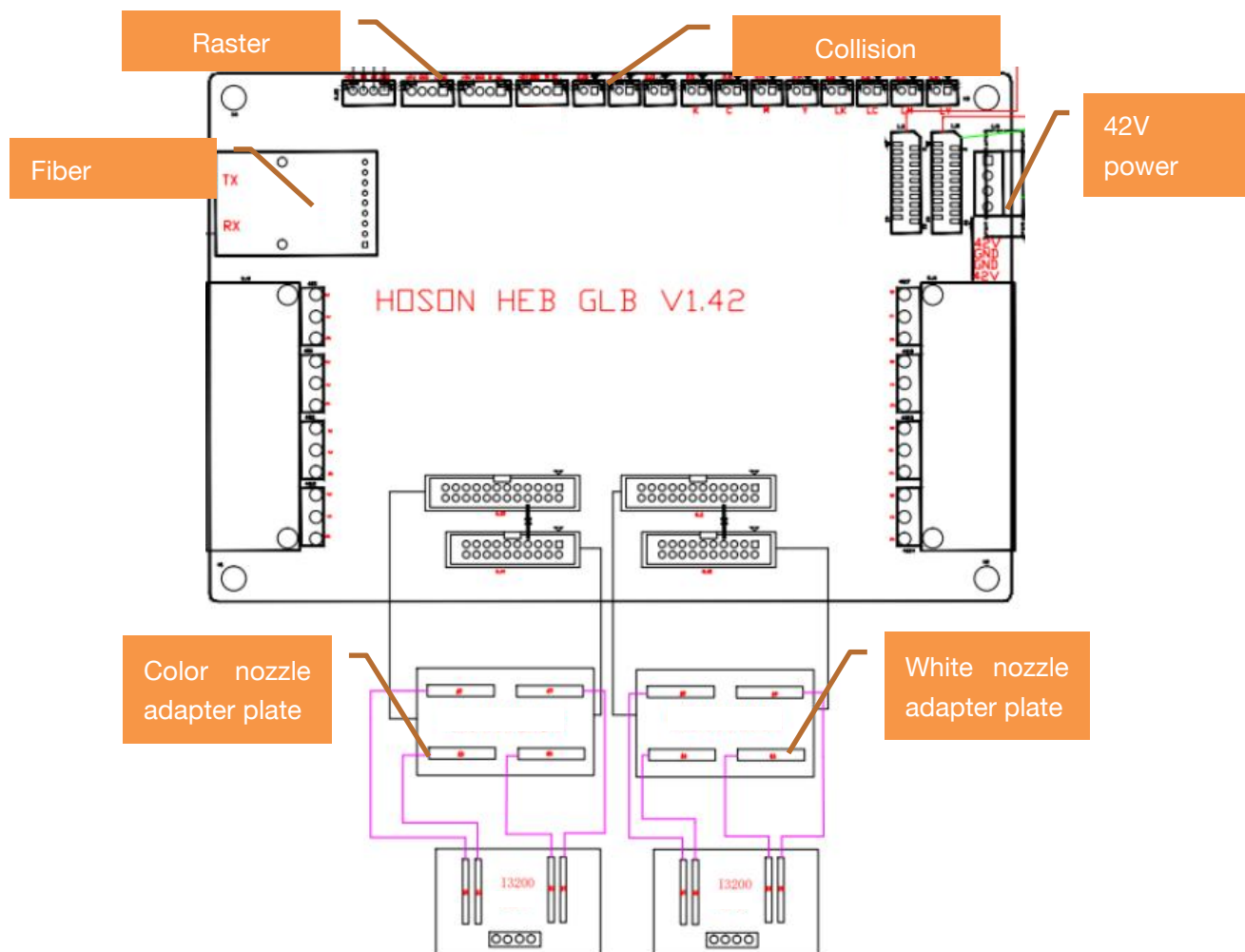
4.3 Motherboard wiring and function：
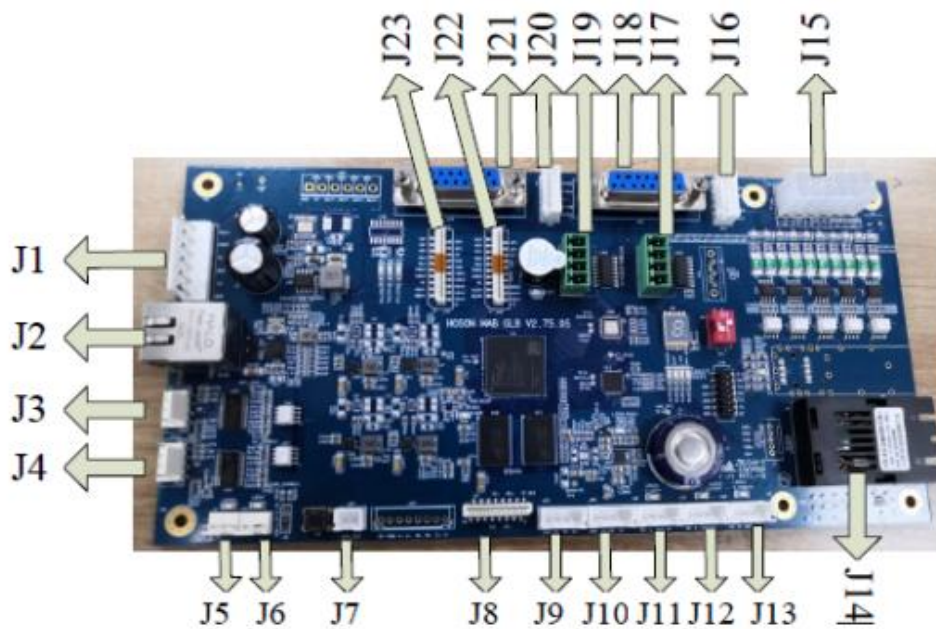
4.4 Motherboard wiring and definition

Board interface description: power supply first, high-speed communication interface, and low speed communication interface, control interface

numbering	The interface definition that	numbering	The interface definition that
J1	Power supply (24 v / 42 v) input interface	J13	Paper out signal detection interface
J2	Gigabit Ethernet interface	J14	Optical fiber interface
J3	Ink stack lifting motor interface	J15	24 v control signal output interface
J4	Ink stack blade motor interface	J16	Y motor limit interface
J5	The ink stack blade motor limit interface	J17	Y motor single-ended signal output interface
J6	The ink stack lifting motor limit interface	J18	Y motor differential signal output interface
J7	Ink reset interface.	J19	X axis motor single-ended signal output interface
J8	The control panel interface	J20	The X axis motor limit interface
J9	RS485 expand interface	J21	The X axis motor differential signal output interface
J10	The grating signal input interface	J22	Flat line 24 v power supply interface
J11	Left limit interface	J23	Flat line 24 v power supply interface
J12	The right limit interface		

Note: The motherboard design requires two 24V power supplies to ensure the stability of the motherboard operation, and the fixing screws and machine housing connection are required.

4.5 Main Board Wiring

The printer control system is divided into three parts: the motherboard, the headboard and the control software, which are connected to the computer using a network cable port
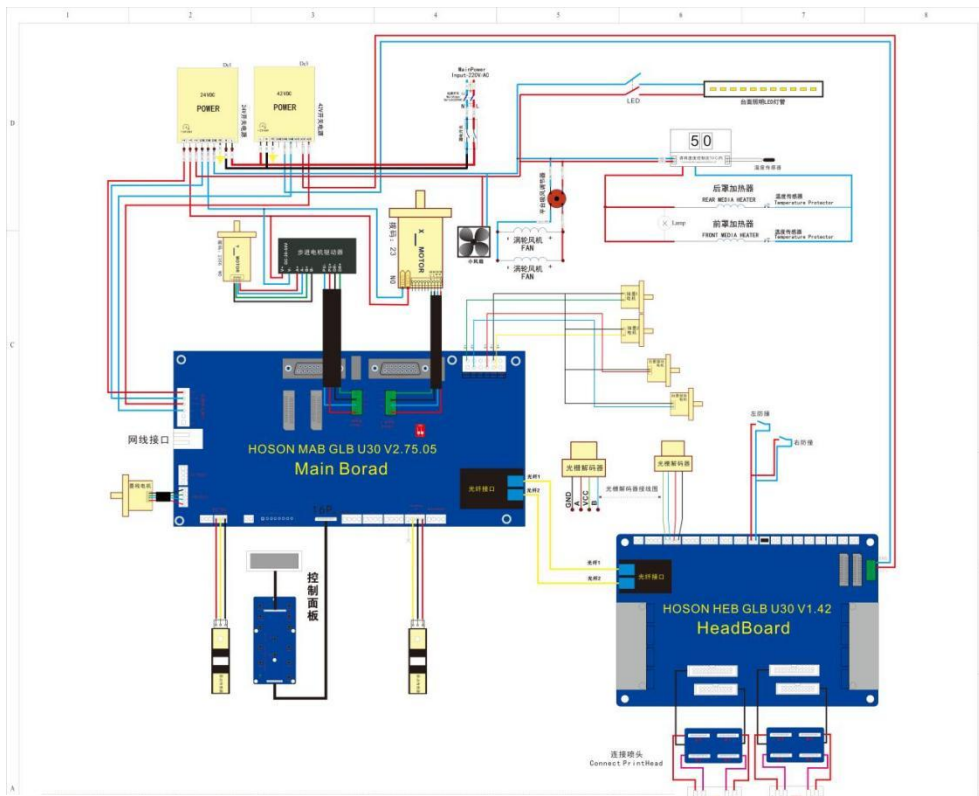
Chapter 5: Software

Print Exp_X64 software is a printer management software, mainly responsible for setting printer parameters, calibrating and adjusting printer nozzles, maintenance, cleaning nozzles and printing jobs, etc.; All operations are made through the Print Exp_X64.

5.1 Software Installation

Follow these steps to install print management software:
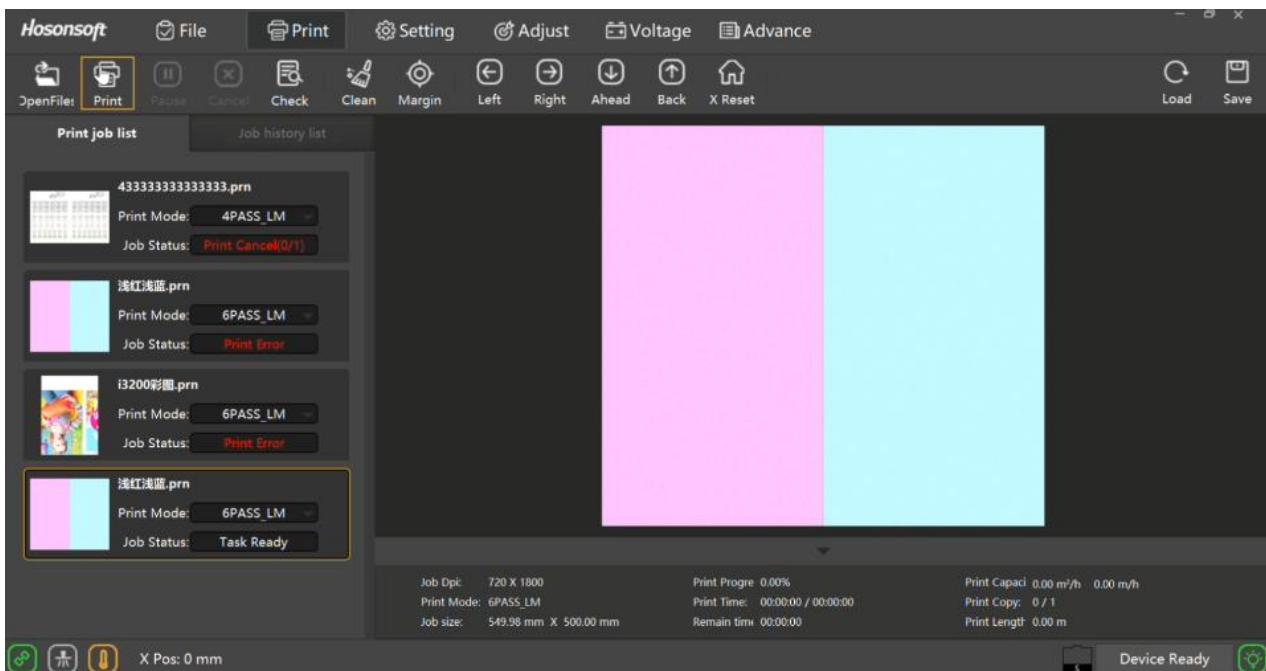Now the computer system has Win7/Win10 and so on, the installation steps are as follows:

First extract the software package
PrintExp_V5.7.6.
0.34_211008

📁 AdjCfg	📁 Config	📁 Data
📁 Lang	📁 Log	📁 resAll
📁 temp	📁 Upgrade	📄 AdjustDataProc.dll
📄 AdjustMgr.dll	📄 BroNozzCompensator.dll	📄 DevDriver.dll
📄 Device.dll	📄 DeviceManager.dll	📄 DevicePartsMgr.dll
📄 ECLProc.dll	📄 ErrorActive.dll	📄 ExpBoard.dll
📄 FileUnicode.dll	📄 FilterTemplate.dll	📄 FtyCfg.dll
📄 Halftoning.dll	📄 HardDataFill.dll	📄 hs_usb3.dll
📄 HSKRipFile.dll	📄 IDCreator.dll	📄 ImgLoader.dll
📄 InkCalMgr.dll	📄 KLog.dll	📄 ktftytp.id
📄 kthdbrd.id	📄 ktmchtp.id	📄 mfc100.dll
📄 msvcp100.dll	📄 msvcr100.dll	📄 NozzleClose.dll
🖥️ NWReceive.exe	📄 NWReceiveProc.dll	📄 PassDataProc.dll
🎨 PrintExp_X64.exe	📄 PrintExpStyle.dll	📄 PrintModule.dll
📄 Project.ini	📄 PublicApp.dll	📄 SDMCS.dll
📄 SimpleXmaste.dll	📄 StatisticsInfo.dll	📄 TaskCWC.dll
📄 TaskMgr.dll	📄 TcpIp.dll	📄 TipBox.dll
📄 UnLock.dll	📄 UpgradeMgr.dll	📄 UVLightSetting.dll
📄 VectorWaveToolUI.dll	📄 WaveShowDll.dll	📄 xmaste.dll
📄 xmaste.dll--	📄 xmaste_T.dll	📄 更新说明.txt

Open the extracted folder， Double-click to enter the main interface of the software

6.1 Arrangement of spray car plates
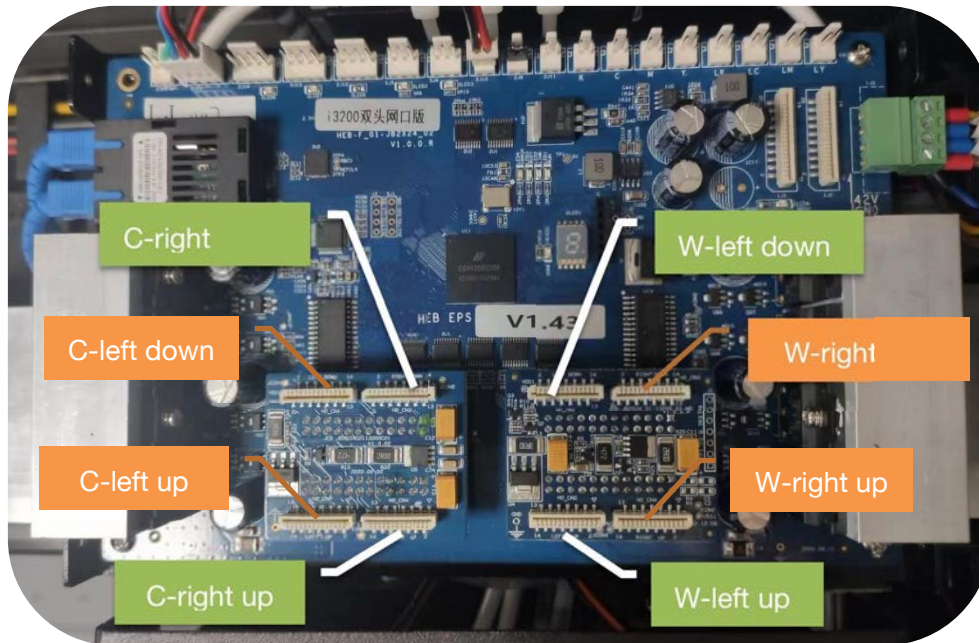
6.2 Sprinkler data cable connection method
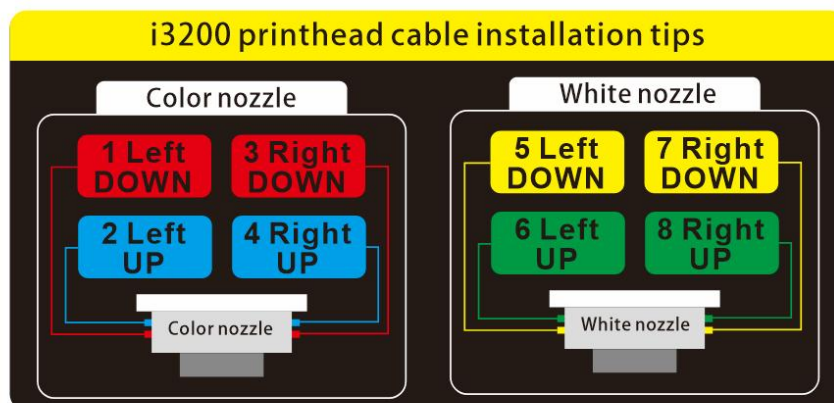
6.3 The appearance of the EPSON i3200 nozzle   **6.4** The arrangement of the nozzle inlet tube K Y C M W W W W

6.5 Sprinkler data cable interface   **6.6 Spray truck plate data line interface**
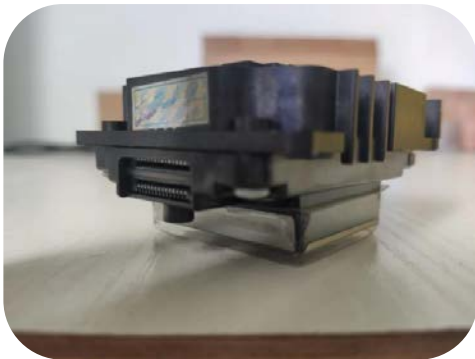
6.7 Gigabit network cable   **6.8 Ink arrangement W K C Y M**

6.9 Ink capsules (4 per nozzle)   **6.10** Data cable: 14-core flat wire for nozzle and board

Chapter 7: Computer and Software Connection Settings

7.1 Setting up computer network IP

Right-click Properties on the Network Neighborhood icon—> select Local Area Connection and right-click Properties to open this interface.
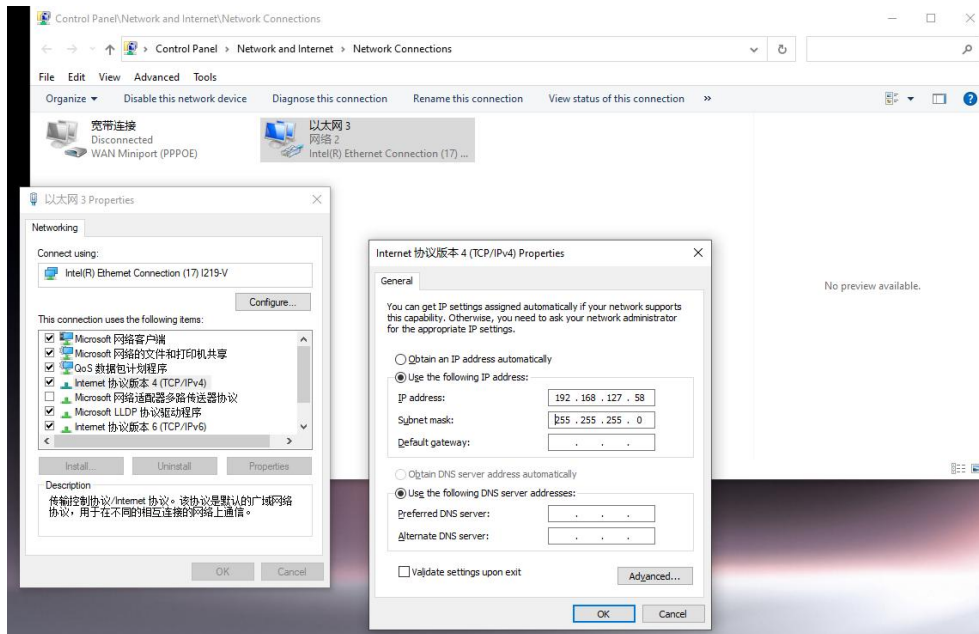
To set the computer to the network, use the custom IP address: 192.168.127.58, subnet mask (default): 255.255.255.0

7.2 Software General Settings
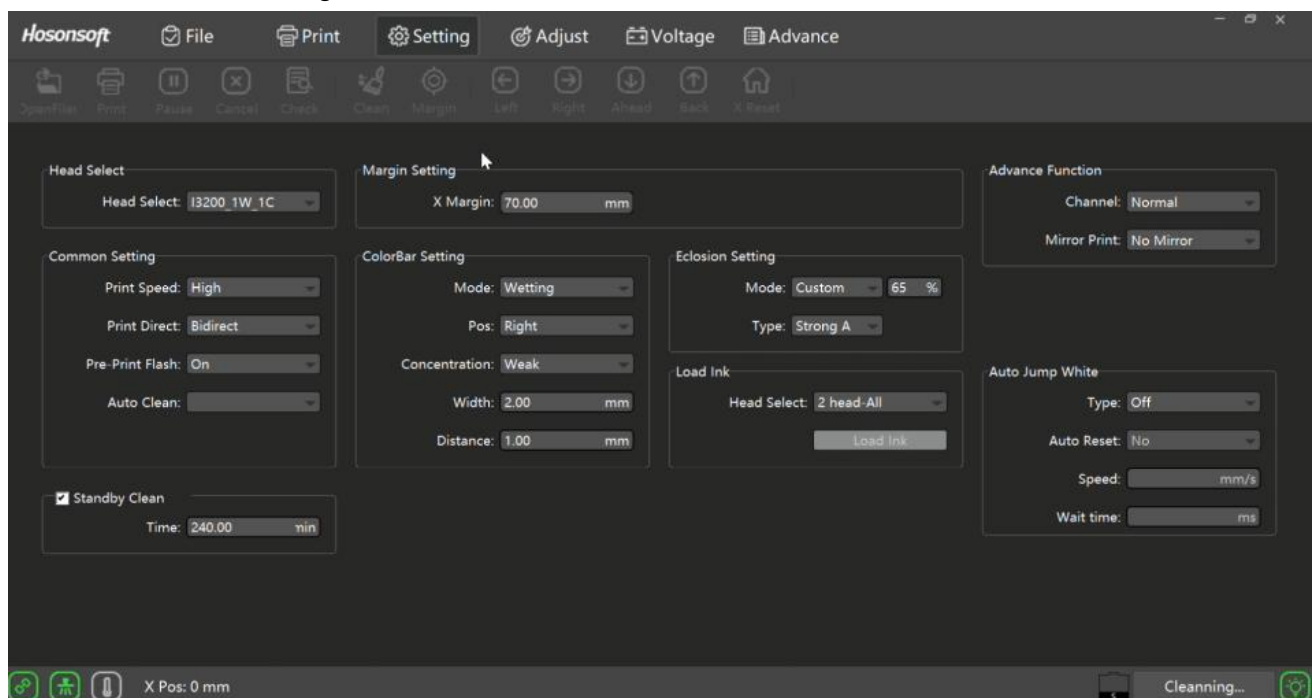
Ordinal	Title		Function description
1	Nozzle selection		In the case of specific models, there is a nozzle selection setting
2	White border settings	X-White edge	Sets the starting position of printing
		Y-White edge	Sets the starting position of printing
3	General settings	Print speed	Set the printing speed to low, medium, high
		Print orientation	Set the print direction to print left, print right, and print bidirectionally
		Prepress flash spray	Set whether to flash ink before printing
		Automatic cleaning	Set Before printing to On or Off
		Paper direction	Paper feed direction selection
4	Color bar settings	Color bar position	The position of the color bar can be set separately as the color bar on the left side, the color bar on the right, the color bar on both sides, and the color bar off.
		Color bar mode	Select the mode of color bars when printing
		Color bar concentration	Select the concentration of the color bar when printing, there are weak, medium, strong
		Color bar width	Select the width of the color bar when printing
		Color bar distance	Select the distance of the color bars from the color bars when printing
5	Feathering settings	Feathering mode	Feather mode selection
		Feather type	Feather type selection
6	Advanced features	Channel control	Control sprinkler data
		Mirror printing	Controls whether the picture is printed horizontally

7	lamp		The ink cures as it dries
8	Automatic whitewashing	Jump white way	Select the white jumping method, there are closed white jump, step white jump, and continuous white jump
		Automatic reset	Select whether to reset automatically

7.3 Go to the advanced settings→ factory settings→password 111111, here enter the internal function settings
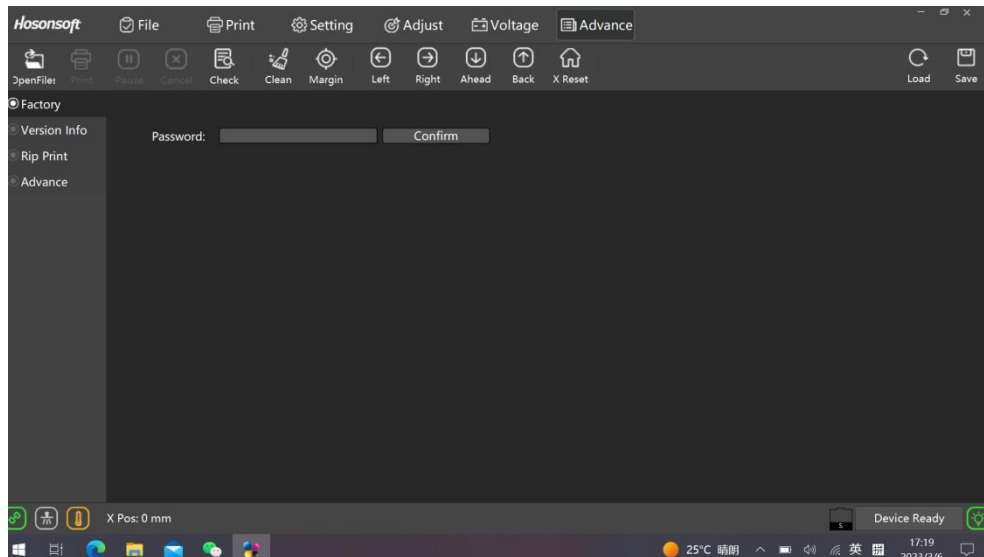
Click the ink stack, the main ink station location, you can set the head height, cleaning height, scraper height, etc.
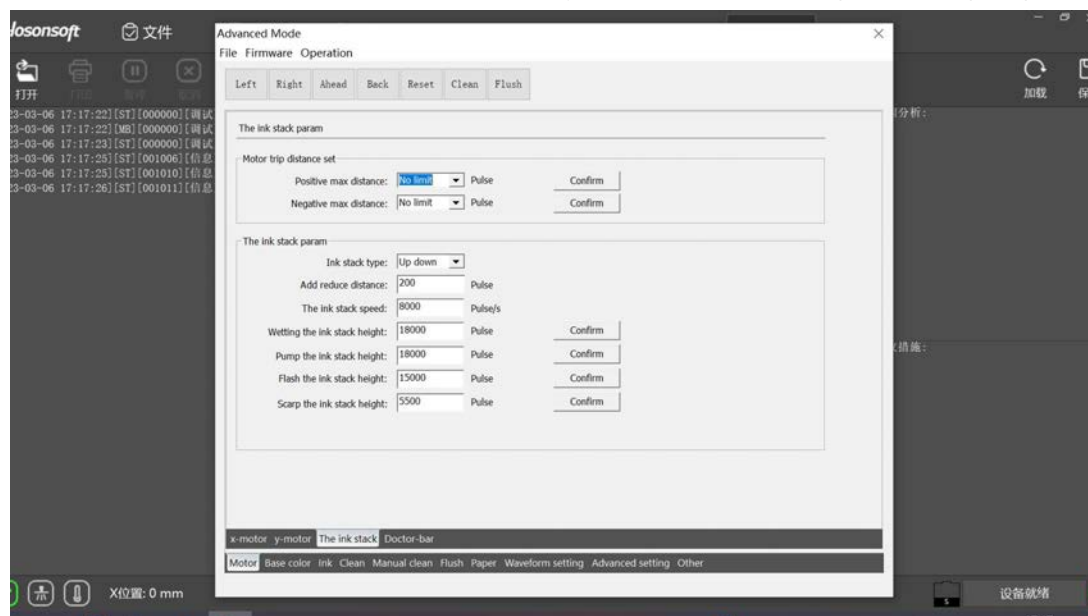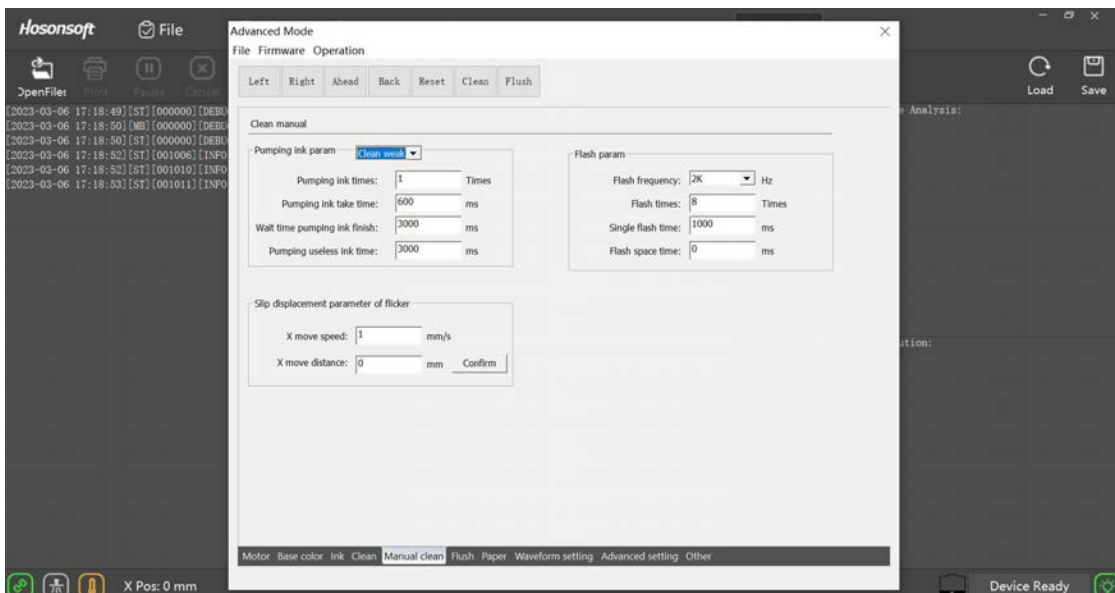
Manual cleaning here can be set to adjust cleaning parameters.

Other functions can be set by default.

7.4 Key introduction

1、 Move left and right arrow keys: Move the trolley left and right in standby mode, and flip through items in the menu state

2、 Exit feed arrow key: Enter and retract the print carrier in standby state, reduce or increase the number of items under the menu

3、The exit key in the case of a menu is to return to the previous menu.

4、The confirmation key is the button that goes into the main menu page

8.1 Nozzle detection function introduction

Click Nozzle Detection to print the nozzle pattern. :
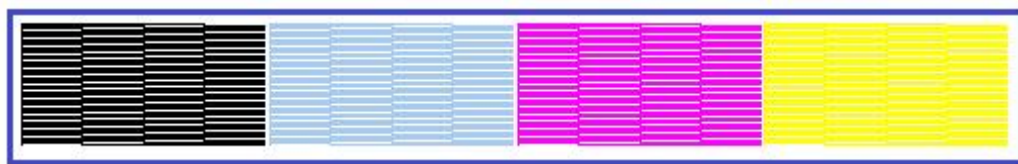
Nozzle calibration diagram

Local magnification of normal and abnormal conditions in the black state map：
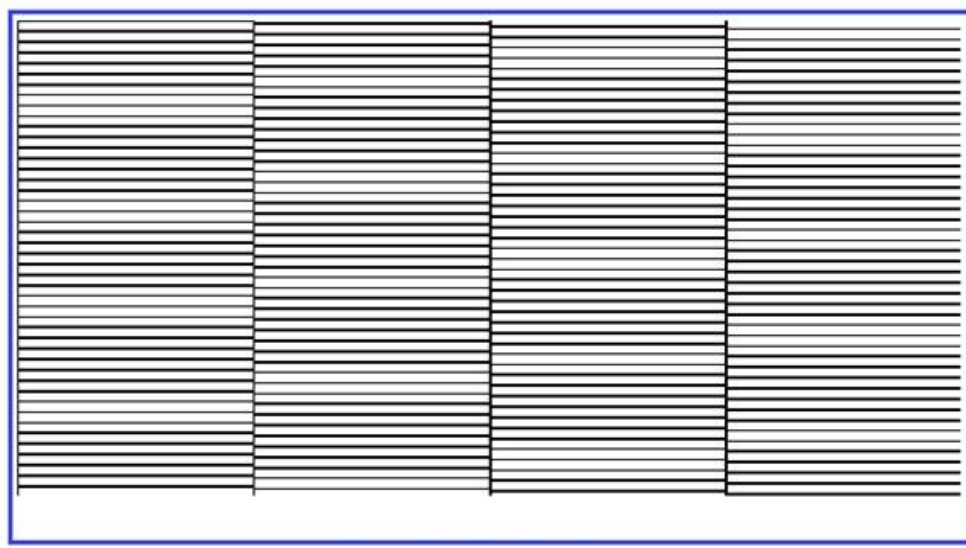
Normal nozzle status diagram

The state diagram in the case shown below may be blocked and need to be cleaned until the orifice inkjet reaches the best state.
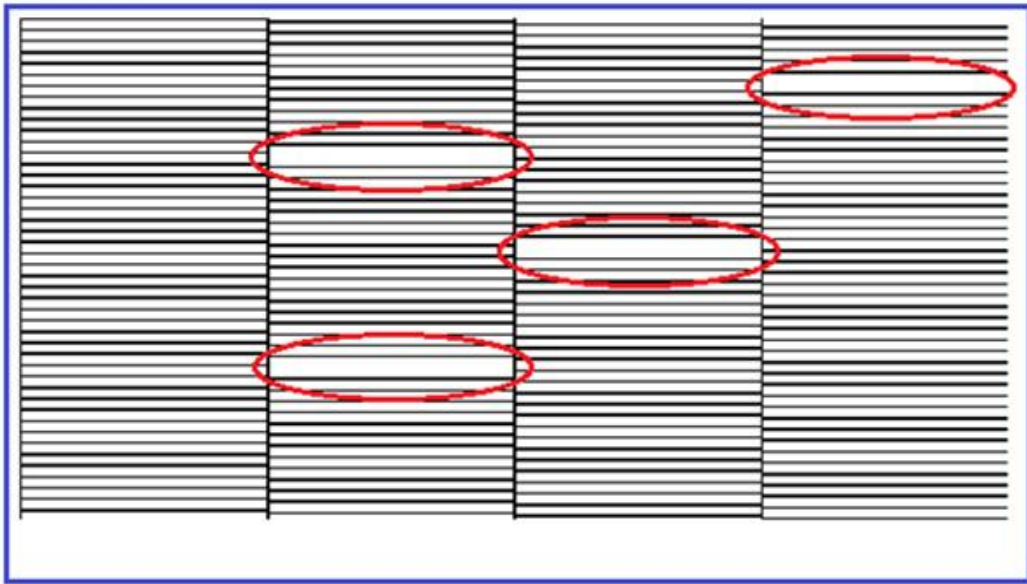
Abnormal nozzle status diagram

8.2 Step Adjust

Click "Step Adjust" to print.
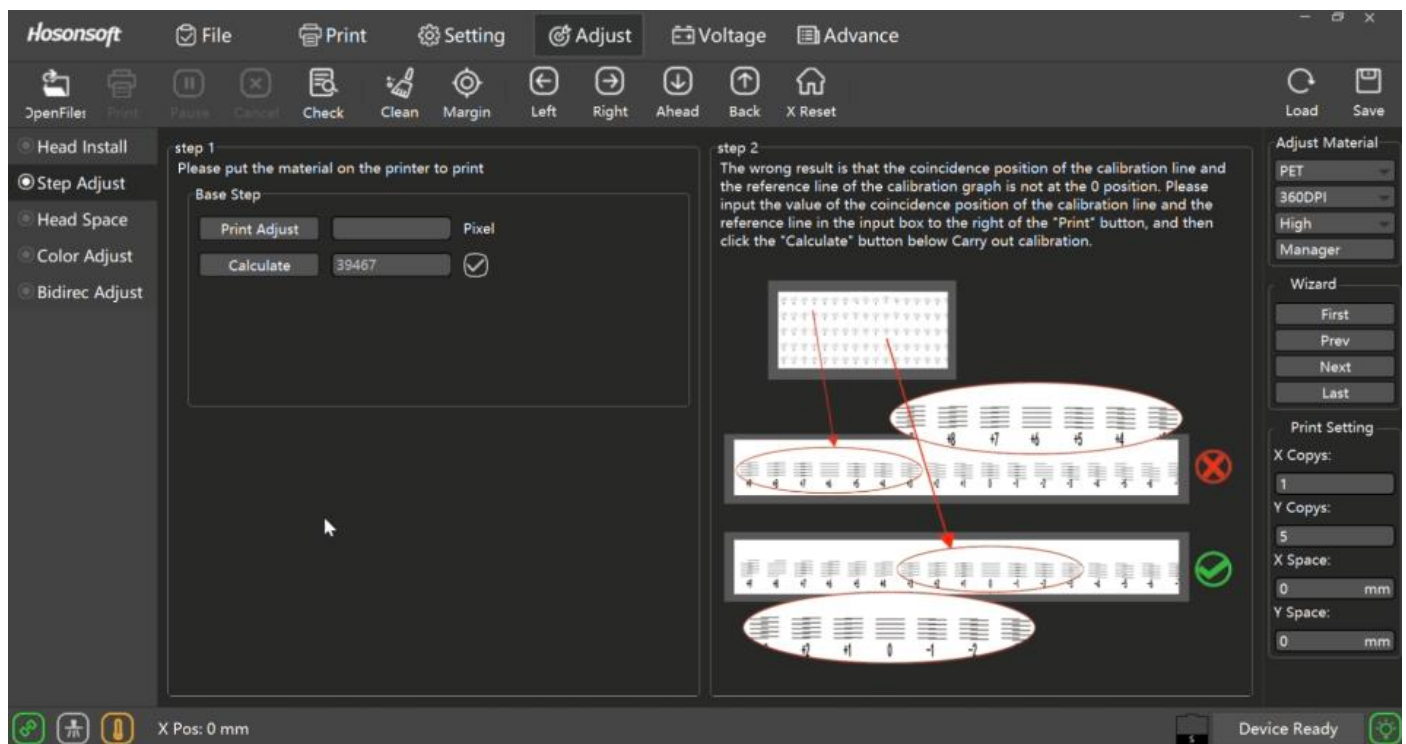
Pic 10

If the step adjustment is normal, the baseline and tick marks overlap exactly at zero. This is shown in Figure 1 of the step adjustment state.

Step adjustment state Figure 1

If the step adjustment is abnormal, the baseline and tick marks do not overlap. This is shown in Figure 2 of the step adjustment state.

Step adjustment state Figure 2

In this case, adjustments are required. Start by entering the adjustment values, click to calculate and reprint the print pattern until the baseline and tick marks overlap exactly at zero.

8.3 Horizontal Spacing

Click Nozzle Spacing to print.

Pic 11
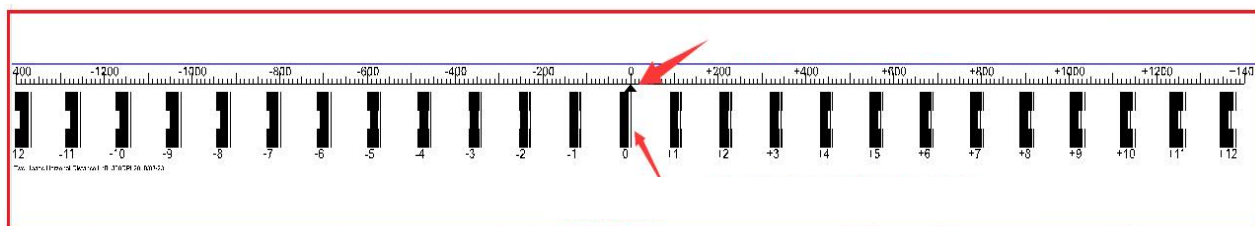
If the print head spacing is properly aligned, the print pattern will look like this.

Nozzle horizontal spacing alignment state Figure 1

If the print head spacing is misaligned, the print pattern is shown below.

Nozzle horizontal spacing alignment state Figure 2

In this case, it needs to be aligned. First enter the adjustment value at the H2 position, click to

calculate and reprint the print pattern until zero to zero in the tick mark.

8.4 Vertical Spacing

Click "Head space" to print.
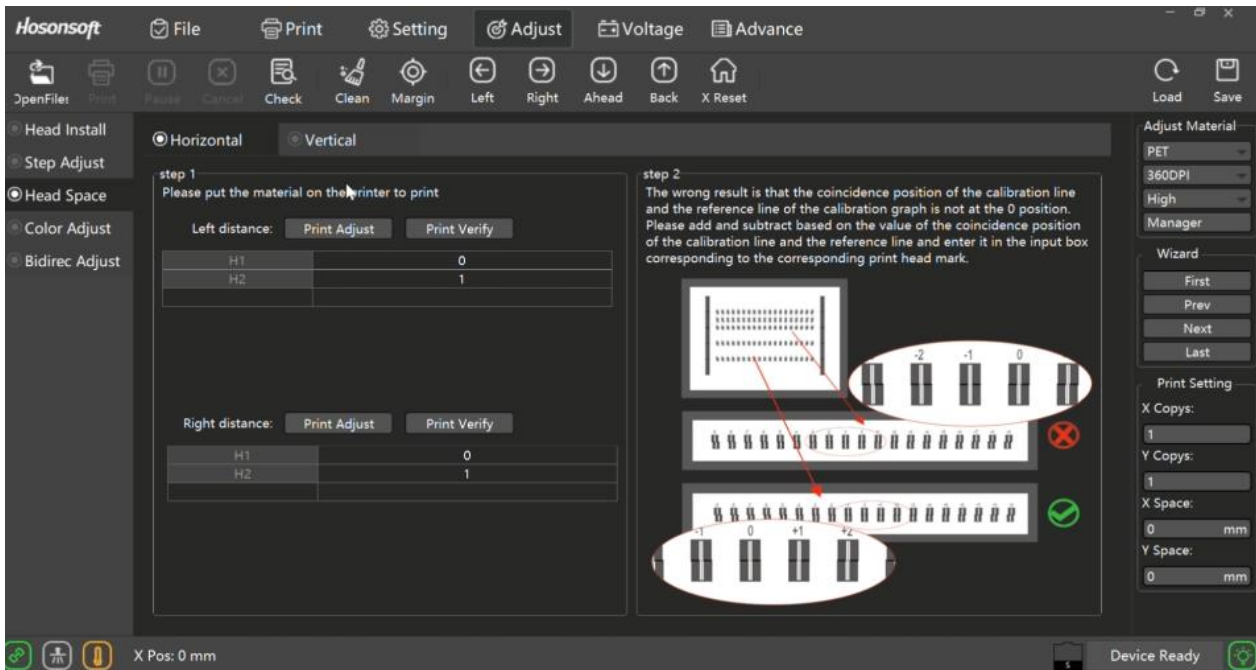
If the longitudinal spacing alignment of the nozzles is normal, all lines in the zero scale frame are parallel, while the left arrow points to the zero position. Figure 1 shows the print head portrait pitch alignment state.
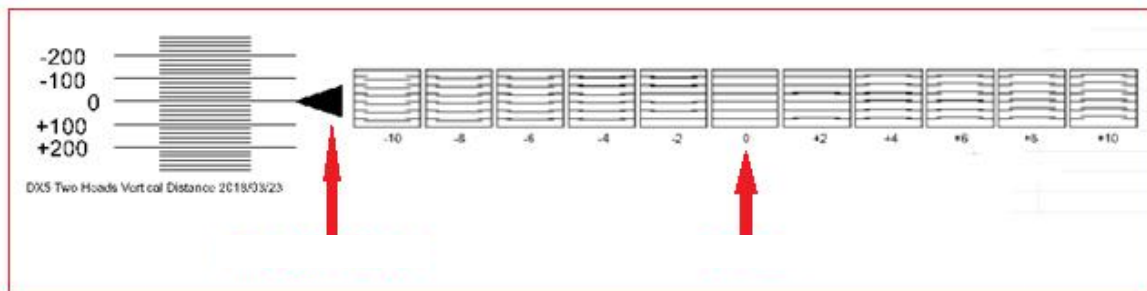
Nozzle longitudinal spacing alignment figure 1

If the longitudinal spacing adjustment of the nozzle is abnormal, all lines in the zero scale frame are parallel to the -4 position. Displays the vertical spacing alignment status of the nozzle
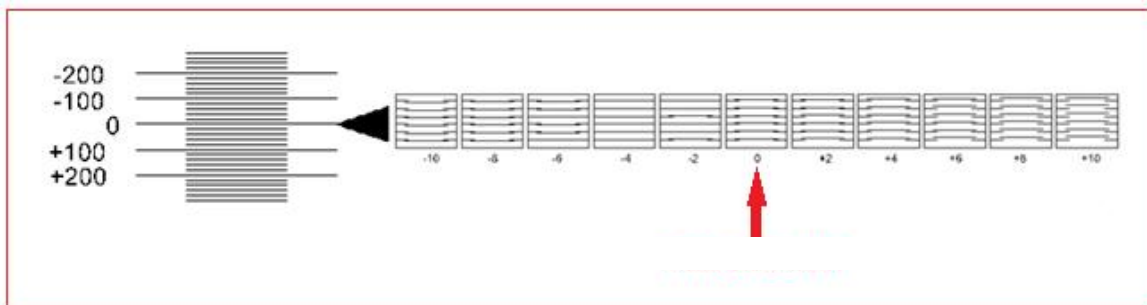
Sprinkler longitudinal pitch alignment state Figure 2

In this case, adjustments need to be made on the basis of the original adjustment datum until all lines in the zero tick frame are parallel at zero, with the left arrow pointing to the zero position.

8.5 Bidirec Adjust

Print Calibration Chart in stand-alone bidirectional calibration prints.
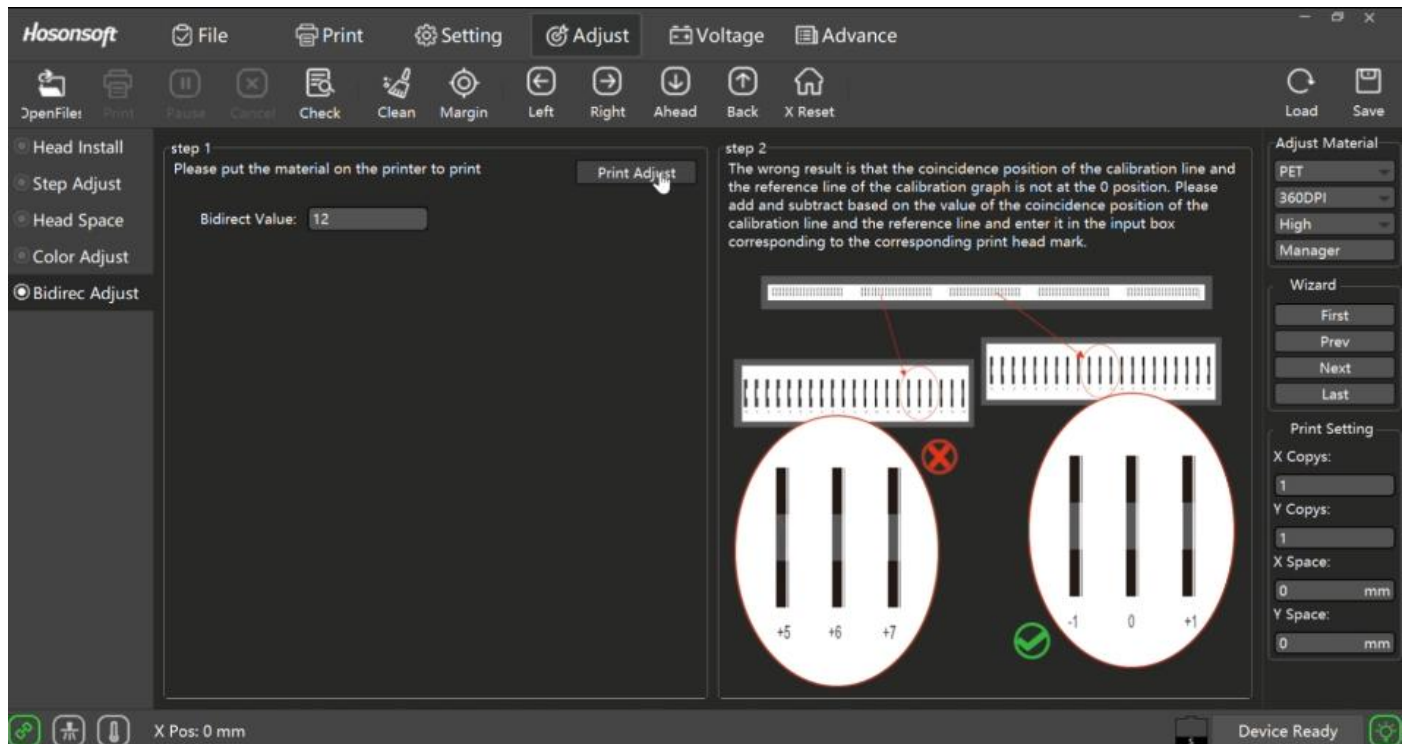
Pic 13

If bidirectional calibration is normal, the lines will overlap at the zero position, as shown below
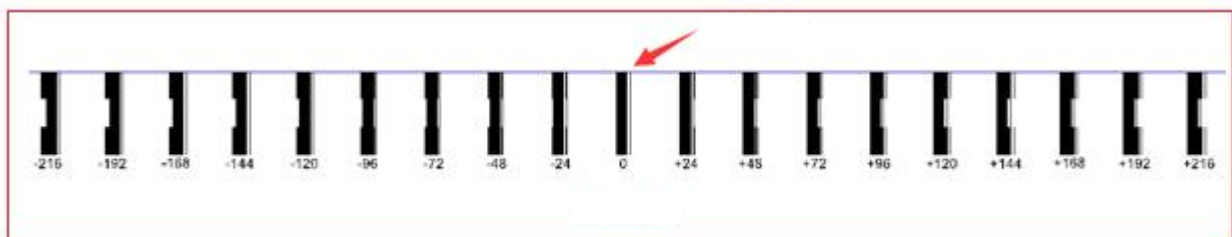
Bidirectional calibration status Figure 1

If the bidirectional calibration is abnormal, the lines will not overlap at the zero position, as shown below:
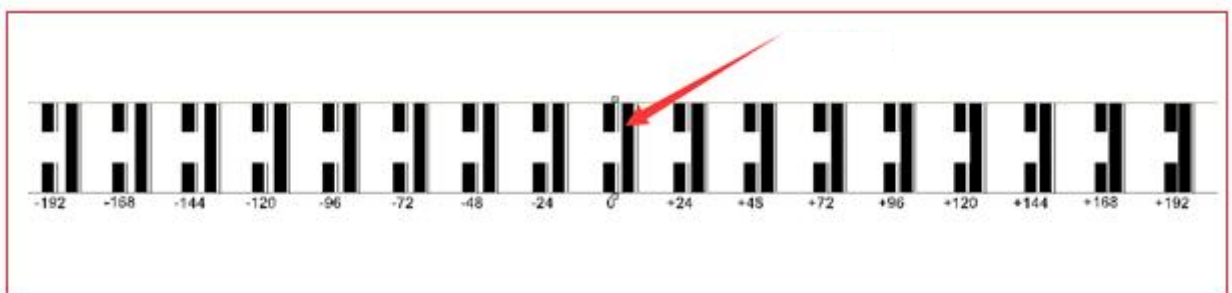
Bidirectional calibration status Figure 2

In this case, you need to enter the adjustment value to readjust.
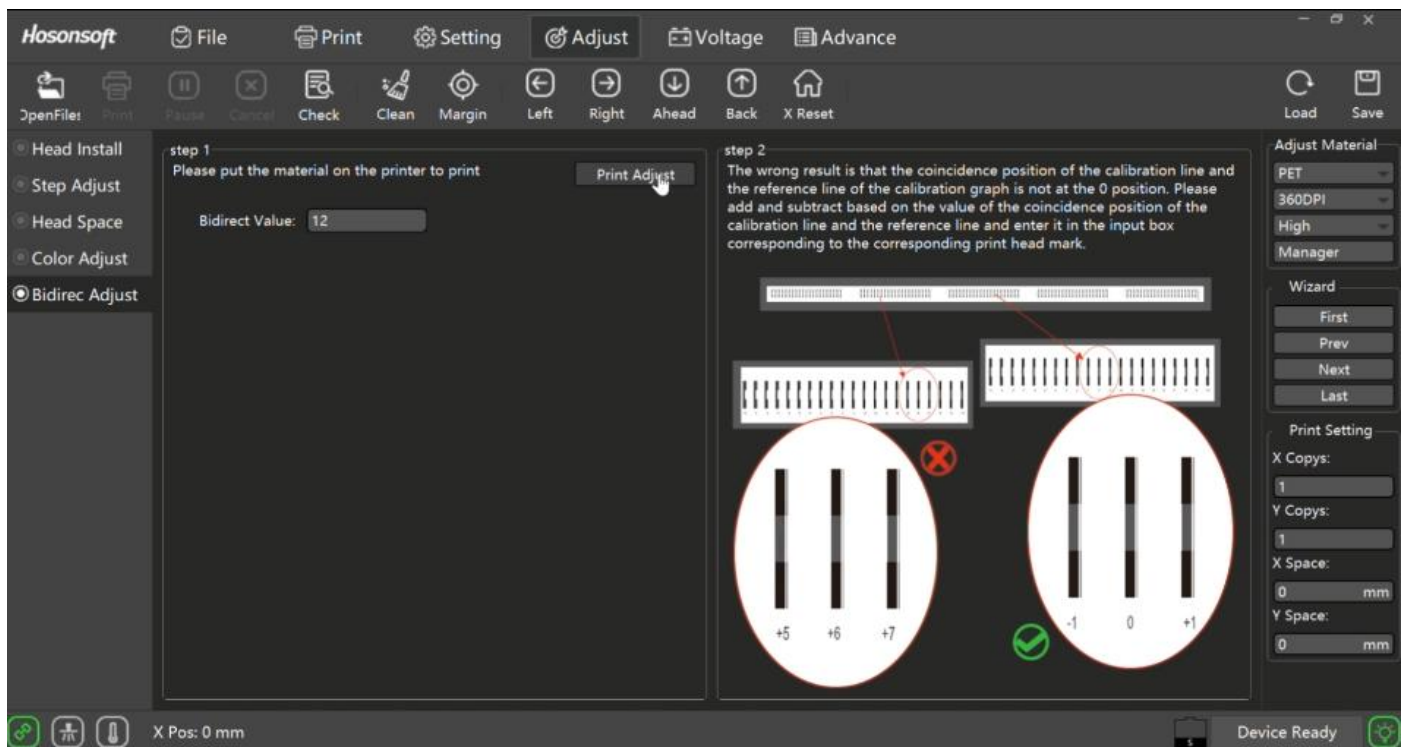
Pic 14

8.6 Color Adjust

Click "Print left/right calibration map" under the color calibration screen to print the calibration chart
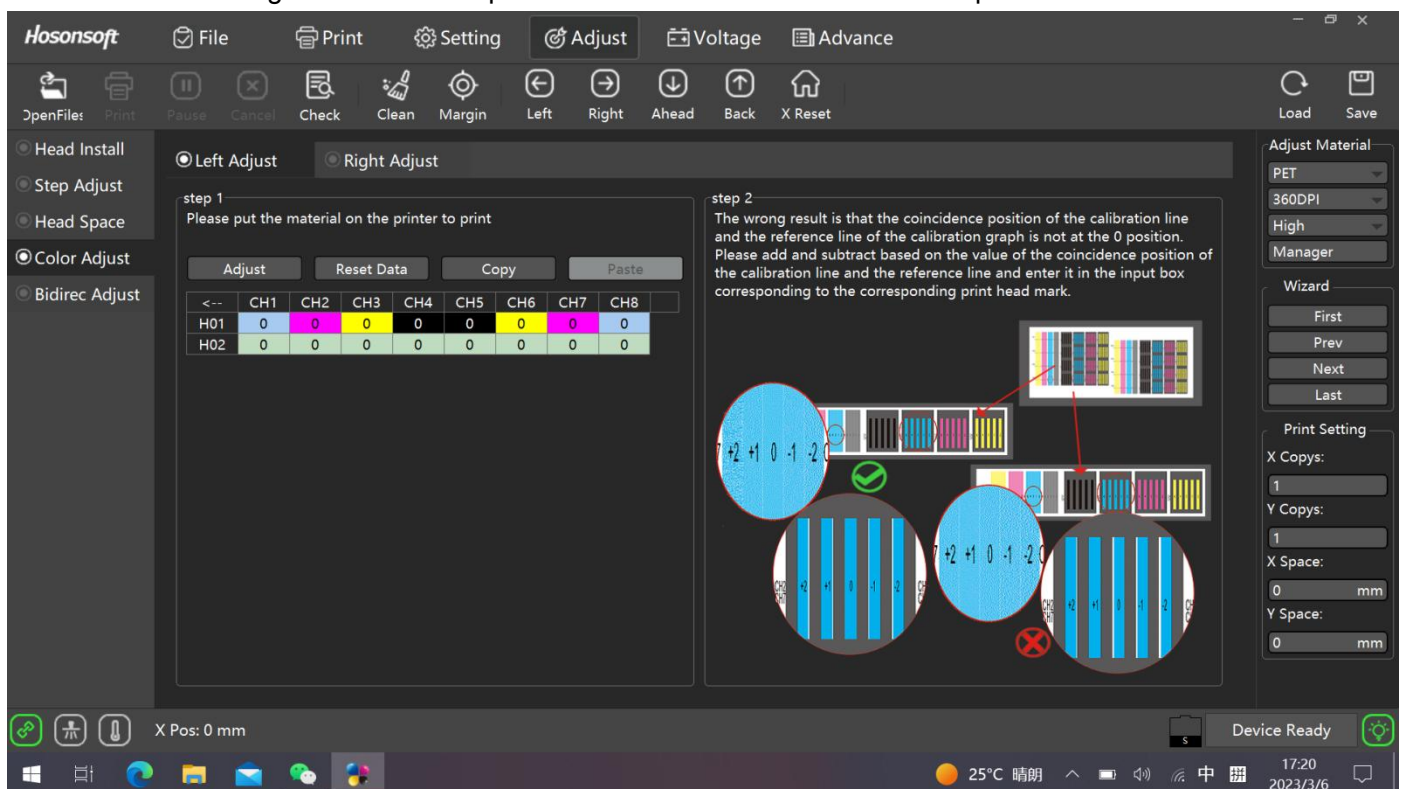
Pic 15

If the color adjustment is normal, the lines will overlap at that zero position, as shown below。
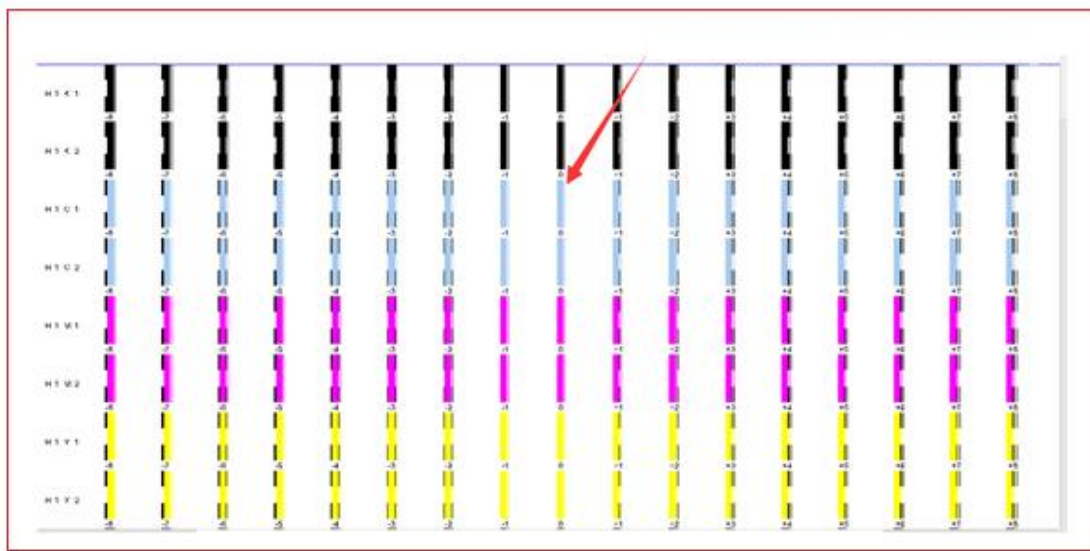
Register calibration Figure 1

If the color adjustment is abnormal, the lines will not overlap at zero, as shown below。
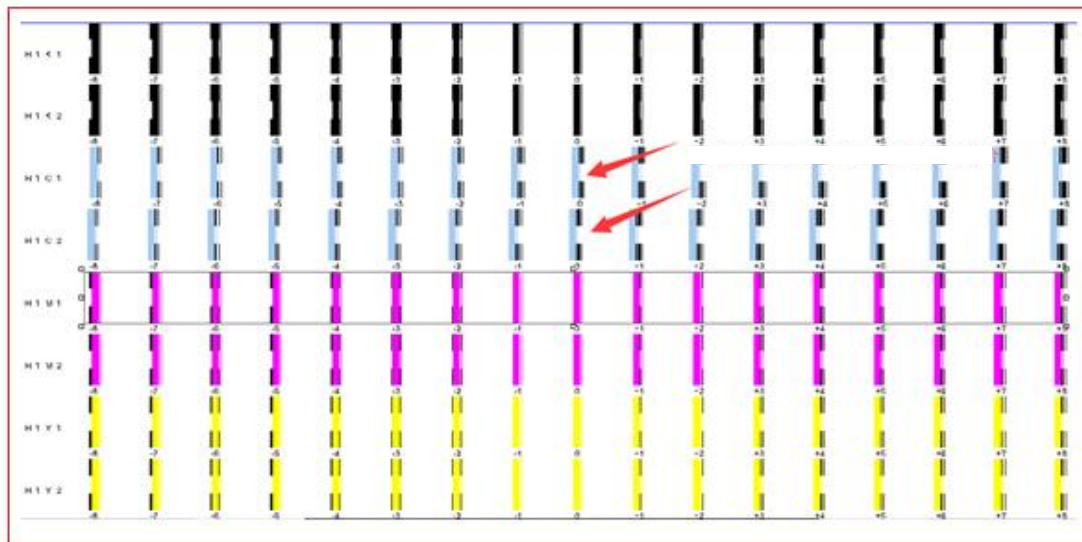
Register calibration Figure 2

In this case, you need to enter the adjustment value to readjust, as shown in the following figure：
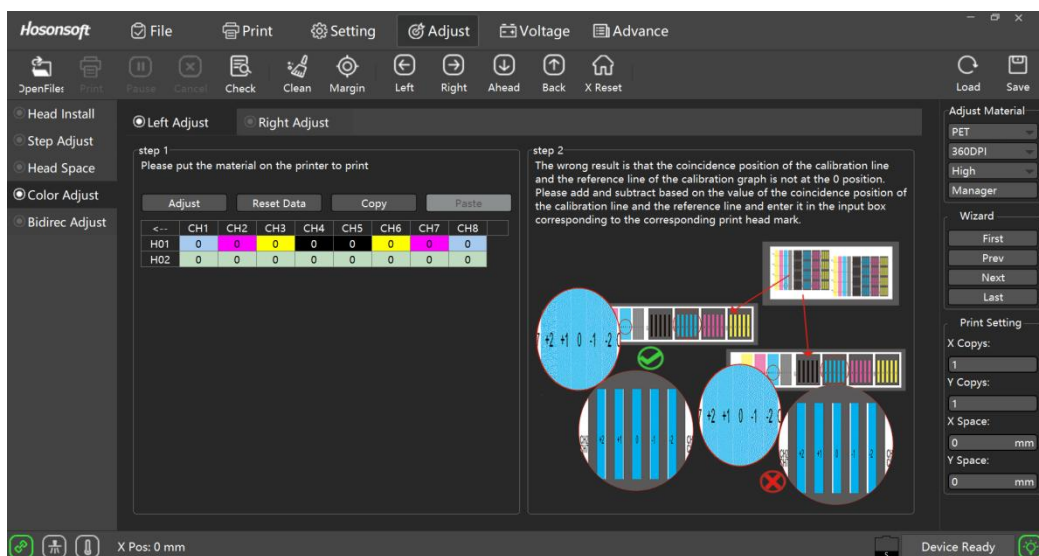
You are here: Installation

Installation

This chapter covers everything related to the installation and setup of your software.

General installation procedures

» Creating an SAi Cloud account

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Creating an SAi Cloud account

General Installation Procedures
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SAicloud.com is the platform through which Flexi software and licenses are distributed. Users create an account in SAicloud.com and activate their software to that account. Multiple licenses can be activated to the same account.

If your company has multiple licenses, choose a general business email address to create the saicloud account with. The chosen email address will be the user name of the account and all communication regarding password resets will be sent to it.

When you purchased a Version License, you received an Activation Code.

» Browse to http://saicloud.com
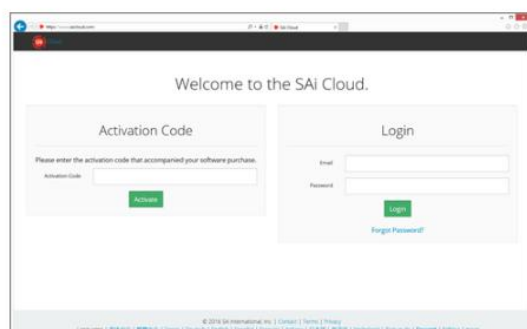
» Paste the activation code in the corresponding field and click **Activate** to continue.
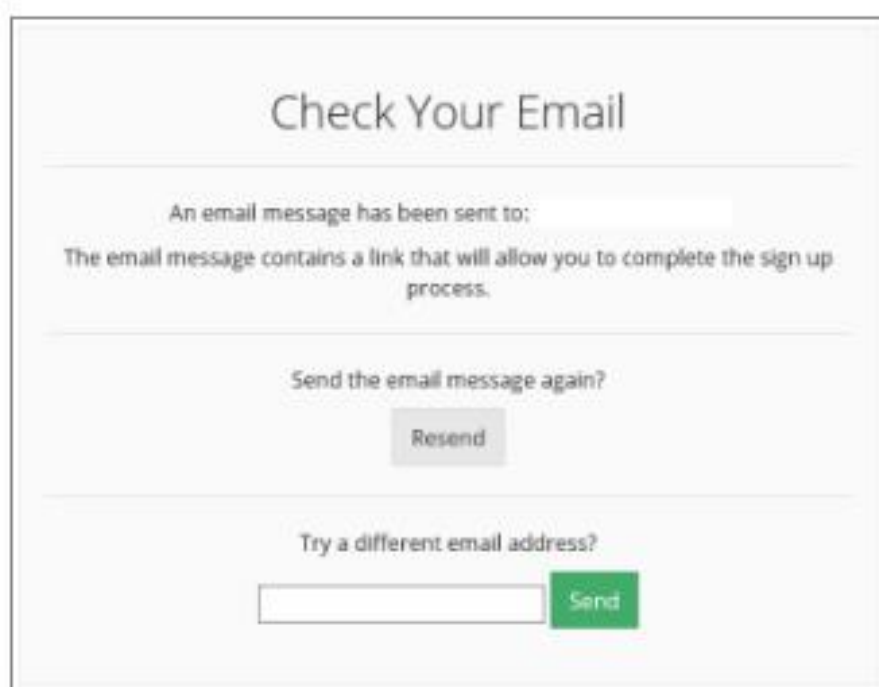
» If you **already have an saicloud account**, you can **log in** using the email address and password you previously created.

» If this is your **first time** activating an sai product, select "**I am new to the SAi Cloud**"

Create A Free SAi Cloud Account

○ I am a returning customer
◉ I am new to the SAi Cloud

Enter your email address to get started.

Important: The email address you select for this SAi Cloud account will be the owner of the software. It will be used for all SAi software services. It is recommended you use a permanent business email address.

(ex. john@example.com)

Create Account

» **Enter the email address** you want to use for your saicloud account. This will be your username.

» When you click **Create Account**, an email will be sent to you containing a link to confirm your activation.

Check Your Email

An email message has been sent to:

The email message contains a link that will allow you to complete the sign up process.

Send the email message again?

Resend

Try a different email address?

Send

Be sure to check spam or junk folders if the email did not arrive.

» Either **click the link** or copy and paste it into a browser.

Your email address will already be entered and cannot be changed at this time.

» **Choose a password** with at least 6 characters and retype it to confirm

» Enter in further details and click **Create Account**

» Read through the Terms and Conditions and **Accept.**

Activate Software

Software ID	
Product	FlexiSIGN & PRINT
License Type	PERPETUAL
Options	

Step 2. Add Software to your SAi Cloud Account

Add To SAi Cloud Account

This software license will be added to your SAi Cloud Account.

Activate Now

» Click **Activate Now** to confirm and link the license to the account.

You have now created an saicloud account and activated your software on that account. Having an saicloud account means you can log back in at any time to download software again, get updates and manage your licenses.

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You are here: *Installation* > *General Installation Procedures* > *Downloading the software*

Downloading the software

When you activate your software, or when you log into saicloud.com at a later time and select your software, the following detail page will be displayed:

General Installation Procedures
    Creating an SAi Cloud account
    Downloading the software
    Installing the software

FlexiSIGN & PRINT

Software ID	
Product	FlexiSIGN & PRINT
License Type	PERPETUAL
Language	All Languages
License Date	2016-03-14

Activation Code

Active Build - 2253

Getting Started

Step 1 - Download
Clicking on the download button below will download a small application. Run the application to download your software.

Download Now

Step 2 - Install
Once the download is complete, run the installer. The final step in the install process will run a "License Manager" application.

Step 3 - License
The "License Manager" application will ask for an activation code. Use the activation code below to license this software.

"License Manager" can't connect?

History
Software Activated
Code: ****************84Q
Software ID: 01757945
2016-03-14 22:20:06 +0000

32
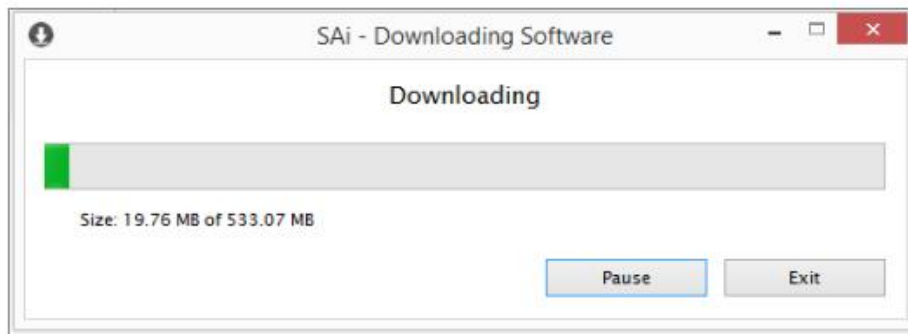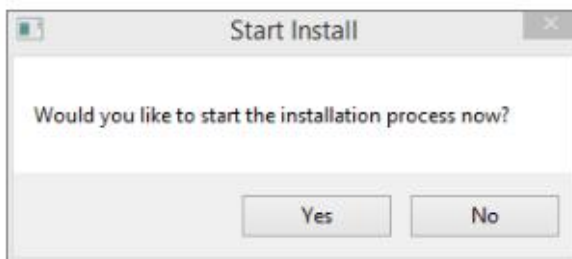
» Hit the **Download Now** button.

A small tool with the name SAi_software_download.exe will be downloaded.

» Choose to **Run** or Open this tool when the download is finished.

This will launch the Installation Tool , which will start downloading all the necessary installation files

» Once the tool has finished downloading and extracting files, the installation can begin.

» Click **Yes** and **choose the language** for your installation.

» Follow the instructions of the Installation Wizard.

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Installing the software

At the end of the download of your software, Installer will be launched automatically.

📱 **Note:** To install the software, you must have **Administrator** privileges. To use the software, you must have Administrator or Power User privileges. See your Windows user guide for more information.

» Select your language

» Click **Next** in the Welcome to the InstallShield Wizard screen.

» Select **I Accept** the Terms of the License Agreement and click **Next**.

» Click **Next** to accept the default Destination Location folder.

» Click **Next** to accept the default Select Features.

» Click **Next** to create a Program Folder to hold the program icons.

The Setup Status window appears, and the software installation process begins. When the installation completes, License Manager will launch.

» Enter your product **Activation Code** and click **Next.**

» Click **Next** when the Licensing Successful message appears.

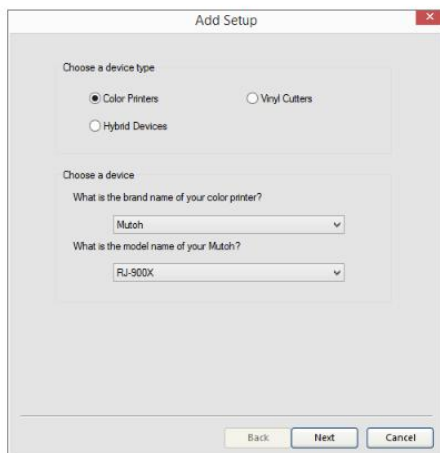» Click **Finish** in the InstallShield Wizard window. (This last window may be hidden behind other open windows.)

📱 **Note:** After the software has finished downloading, a folder with the name SAi_Installer is created on your desktop. If you interrupted the installation at any point, or if you need to reinstall, you can double click autorun.exe from within this folder to launch installer again.

Configuring a printer

You can configure multiple devices and multiple setups in your Flexi software.

» In Production Manager, Click **Setup** and then **Add Setup**

» Check **Color Printers** and then select the **brand** and **model** of your printer and click **Next** to continue.

» If your printer is connected via network (most common), this dialog will show up automatically :

» If you know the **TCPIP address** of your printer, you can type it in manually.

» If you know the **TCPIP address** of your printer, you can type it in manually.

If you do not know the TCPIP address, click the Find Printer button

If your printer is online and supports network broadcasting, you can select it from the list.
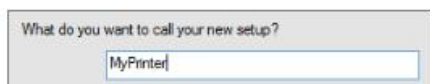
TIP : some printers are slow in responding, click the Update button to refresh the list.

» Click the Test button to verify that your configuration works.
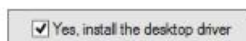
» Click **OK** to confirm.

Optional:

» Edit the setup name.

You can change the name of the setup. This is the name that will show in the setup toolbar. It will also be the name of the default hot folder.

» Install the Desktop Driver

This option installs the setup as a standard windows driver, so it is accessible from other software programs on your computer. Any jobs sent to this standard windows driver will automatically show up in the Production Manager queue.

Chapter 10: Maintenance Instructions

1. Every day before turning on printing, the nozzle inspection is carried out to check whether the nozzle is blocked, such as

If the test strip has a broken needle, it should be cleaned.

2. Working environment temperature: 20°C–30°C; Operating relative humidity: 45%–65%

3. Nozzle detection should be carried out before shutting down every day, and if there is a broken wire, it should be cleaned and then shut down.

4. When shutting down the computer every day, pay attention to the need for the print head and ink station to be aligned and fitted together.

There should be no gap between the print head and the ink station.

5. During the printing process, be sure to add color bars to prevent a certain color from being long during the printing process

Time does not spray and causes the nozzle to clog.

6. Be careful not to let the print film scratch the print head during the printing process.

7. There can be no dust on the grating strip, wipe it clean with a dust–free cloth for a week or two.

8. The rails are wiped with tailor oil for two to three weeks.

9. The scraping blades are regularly wiped clean with a dust–free cloth.

10. Clean the ink on the paper sheet in time to prevent ink accumulation and scraping on the nozzle.

11. Regularly clean the ink accumulation on the underfloor of the trolley.

12. Regularly clean the ink accumulation next to the ink stack hat to ensure that the ink stack cap is clean.

13. If the printer is not used for a long time, it is necessary to use distilled water or special paint ink

Pour the washing solution on the ink stack cap to soak the nozzle, and clamp the ink tube and the ink pump tube.

14. When the printing film is not in use, it should be wrapped with plastic wrap to prevent moisture.

15. When the hot melt powder is not in use, it should be sealed with a bag to prevent moisture.