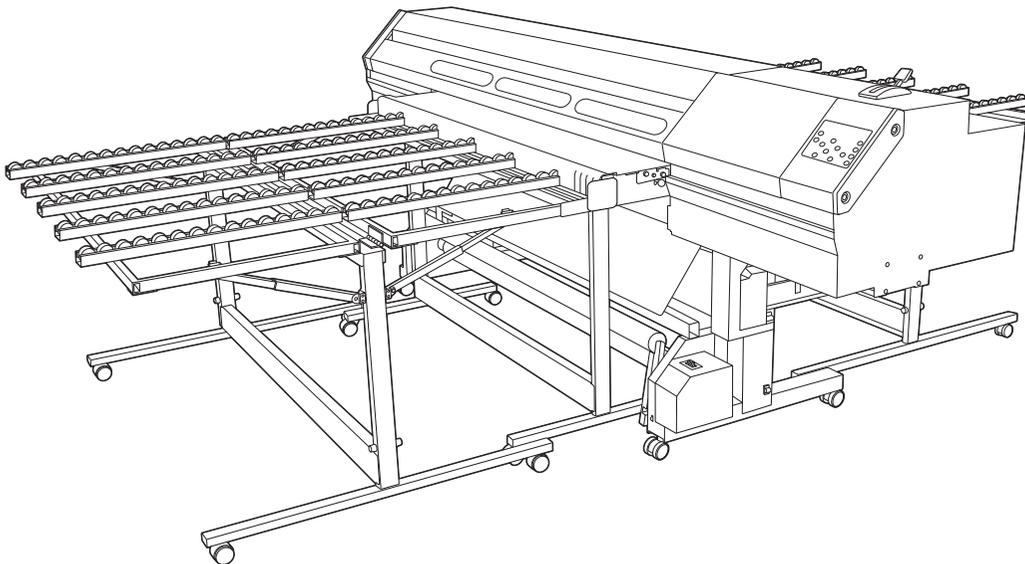


VersaUV

LEJ-640

User's Manual



Thank you very much for purchasing this product.

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

Roland DG Corporation

This product is using GNU General Public License (GPL) / GNU Lesser General Public License (LGPL) software. You have the right to acquire, modify, and distribute the source code for this GPL/LGPL software. You can obtain the GPL/LGPL source code used in this product by downloading it from the following website.

URL: <http://www.rolanddg.com/gpl/>

Roland DG Corp. has licensed the MMP technology from the TPL Group.

For the USA

FEDERAL COMMUNICATIONS COMMISSION RADIO FREQUENCY INTERFERENCE STATEMENT

NOTE: This equipment has been tested and found to comply with the limits for a Class A digital device, pursuant to Part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications. Operation of this equipment in a residential area is likely to cause harmful interference in which case the user will be required to correct the interference at his own expense.

Unauthorized changes or modification to this system can void the users authority to operate this equipment.

Use only I/O cables that have been designed and manufactured specifically for this device.

For Canada

NOTICE

This Class A digital apparatus meets all requirements of the Canadian Interference-Causing Equipment Regulations.

AVIS

Cet appareil numérique de la classe A respecte toutes les exigences du Règlement sur le matériel brouilleur du Canada.

For California



WARNING: This product can expose you to chemicals including lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov

For EU Countries

WARNING

This is a Class A product. In a domestic environment this product may cause radio interference in which case the user may be required to take adequate measures.

For EU Countries



Manufacturer:

ROLAND DG CORPORATION

1-6-4 Shinmiyakoda, Kita-ku, Hamamatsu-shi, Shizuoka-ken, 431-2103 JAPAN

The importer in the EU:

Roland DG Europe Holdings B.V.

Prof. J.H. Bavincklaan 2, 1183 AT, Amstelveen, The Netherlands

NOTICE

Grounding Instructions

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.

Repair or replace damaged or worn out cord immediately.

Operating Instructions

KEEP WORK AREA CLEAN. Cluttered areas and benches invites accidents.

DON'T USE IN DANGEROUS ENVIRONMENT. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.

DISCONNECT TOOLS before servicing; when changing accessories, such as blades, bits, cutters, and like.

REDUCE THE RISK OF UNINTENTIONAL STARTING. Make sure the switch is in off position before plugging in.

USE RECOMMENDED ACCESSORIES. Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.

NEVER LEAVE TOOL RUNNING UNATTENDED. **TURN POWER OFF.** Don't leave tool until it comes to a complete stop.

For China

产品中有毒有害物质或元素的名称及含量

部件名称	有毒有害物质或元素					
	铅 (Pb)	汞 (Hg)	镉 (Cd)	六价铬 (Cr (VI))	多溴联苯 (PBB)	多溴二苯醚 (PBDE)
印刷电路板	×	○	×	○	○	○
头部	×	○	○	○	○	○
壳体、底架	×	○	○	○	○	○
电源	×	○	×	○	○	○
其他 (电缆、附件等)	×	○	○	○	○	○

○：表示该有毒有害物质在该部件所有均质材料中的含量均在 GB/T26572-2011 标准规定的限量要求以下。
 ×：表示该有毒有害物质至少在该部件的某一均质材料中的含量超出 GB/T26572-2011 标准规定的限量要求。

环保使用期限



此标志适用于在中国国内销售的电子信息产品，表示环保使用期限的年数。所谓环保使用期限是指在自制造日起的规定期限内，产品中所含的有害物质不致引起环境污染，不会对人身、财产造成严重的不良影响。环保使用期限仅在遵照产品使用说明书，正确使用产品的条件下才有效。不当的使用，将会导致有害物质泄漏的危险。

For EU Countries



This product must be disposed of separately at your local waste recycling center. Do not dispose of in household waste bin.



Lever dit product in bij een lokaal afvalverzamelpunt. NIET met normaal huishoudelijk afval afvoeren.



Bitte führen Sie dieses Produkt separat Ihrer örtlichen Entsorgungsstelle zu. Bitte nicht mit dem normalen Hausmüll entsorgen.



Dette Produkt skal smides særskilt væk på den lokale affalds- og genbrugsstation. Må ikke smides ud sammen med almindeligt husholdningsaffald.



Ne jetez pas le produit avec vos ordures ménagères. Portez-le dans un centre recyclage des déchets.



Tätä tuotetta ei saa hävittää normaalien talousjätteiden mukana, vaan se on toimitettava ongelmajätteiden keräilypisteeseen hävitettäväksi.



Questo prodotto deve essere smaltito negli appositi contenitori per la raccolta differenziata, non buttare nel cestino dei rifiuti casalinghi.



Produkten måste kasseras separat på din lokala återvinningscentral. Släng inte produkten tillsammans med hushållssoporna.



Este producto debe devolverse al centro de reciclaje más cercano a su domicilio para su correcta eliminación. No lo tire a la basura.



Μην πετάξετε το αντικείμενο αυτό στο καλάθι των απορριμμάτων. Αφαιρέστε τις μπαταρίες και προσκομίστε το στο τοπικό κέντρο ανακύκλωσης.



Deite fora separadamente este produto no seu centro de reciclagem local. Não o deite fora no seu caixote do lixo.

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Chapter 1

Machine Highlights

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Part Names and Functions

Printer Unit

Front

Front cover 1
Be sure to close this when you perform printing.

Maintenance cover
You remove this when you perform cleaning of the print heads.

Media guide
This prevents the end of the media from striking the stays or other areas, which can cause the media to come loose.

Media hold down unit
Use these when you are using firm, rigid media. For assembly instructions, refer to "MB-640 ASSEMBLY INSTRUCTIONS."

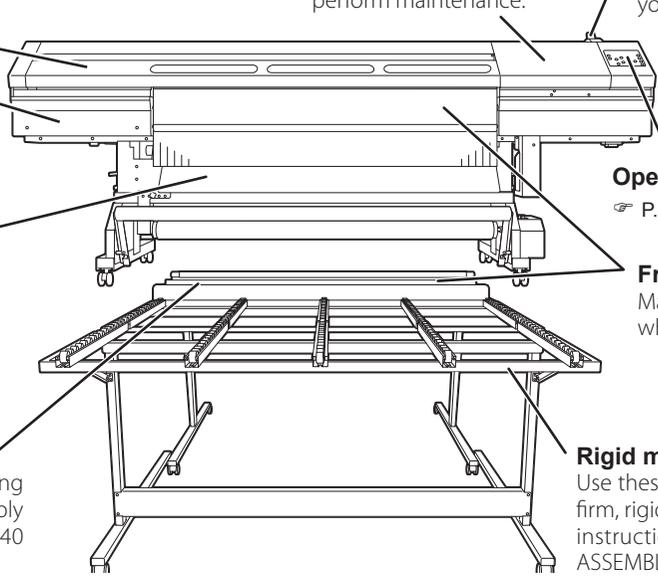
Side cover
You remove this when you perform maintenance.

Loading lever
You operate this when you load media.

Operation panel
☞ P. 10, "Operation Panel"

Front cover 2
Make sure it is attached when printing.

Rigid media tables
Use these when you are using firm, rigid media. For assembly instructions, refer to "RU-640 ASSEMBLY INSTRUCTIONS."



Rear

Link LED
This lights up green when the connection to the network is correct.

Main power switch

Power-cord connector

Status LED
This flashes yellow while data is being received from the network.

Ethernet connector
This is used to connect the printer to a network.

Ventilating equipment attachment opening
This is where air intake is performed to lessen the characteristic odor of inks. Ventilating equipment is required separately.
☞ "Setup guide"

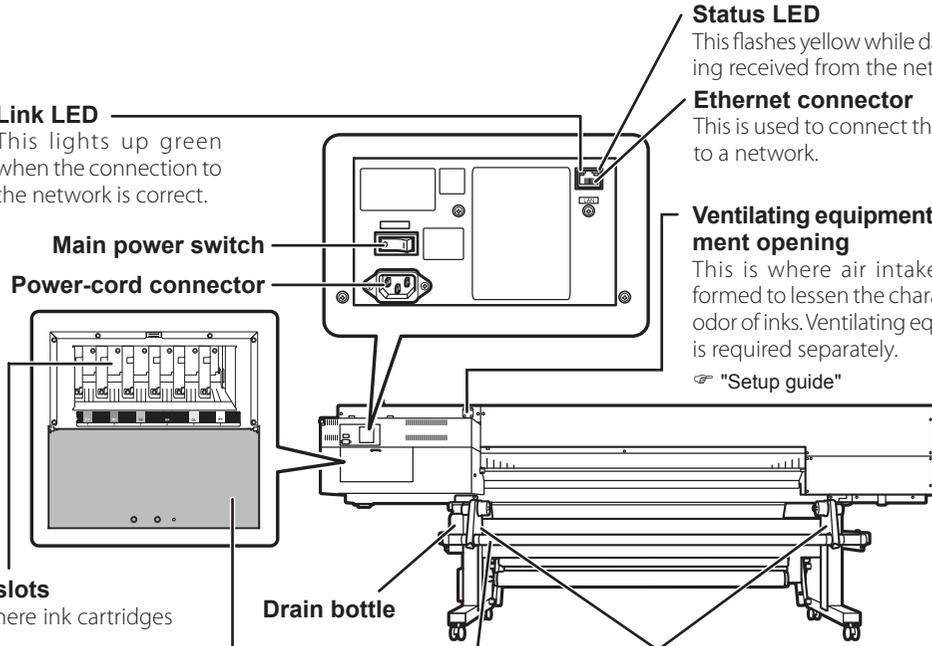
Cartridge slots
There are where ink cartridges are installed.

Ink cartridge cover
Be sure to close this cover except when absolutely necessary, such as when you are replacing ink cartridges.

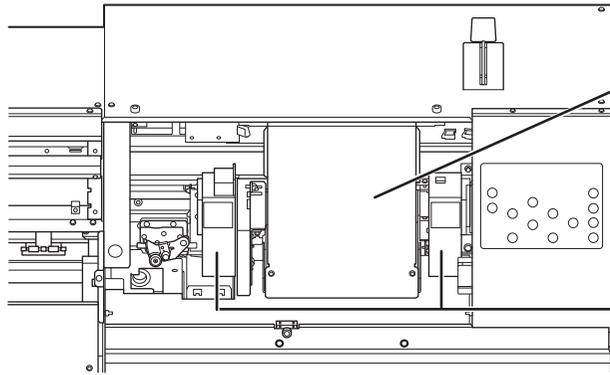
Drain bottle

Shaft

Media holders
Here is where you load roll media and secure it in place.



Print Head Periphery



Print-head carriage

The print heads are inside this.

UV emitter

This is the ultraviolet (UV) LED. It emits light only during printing.

Front Cover 1 Inside

Platen

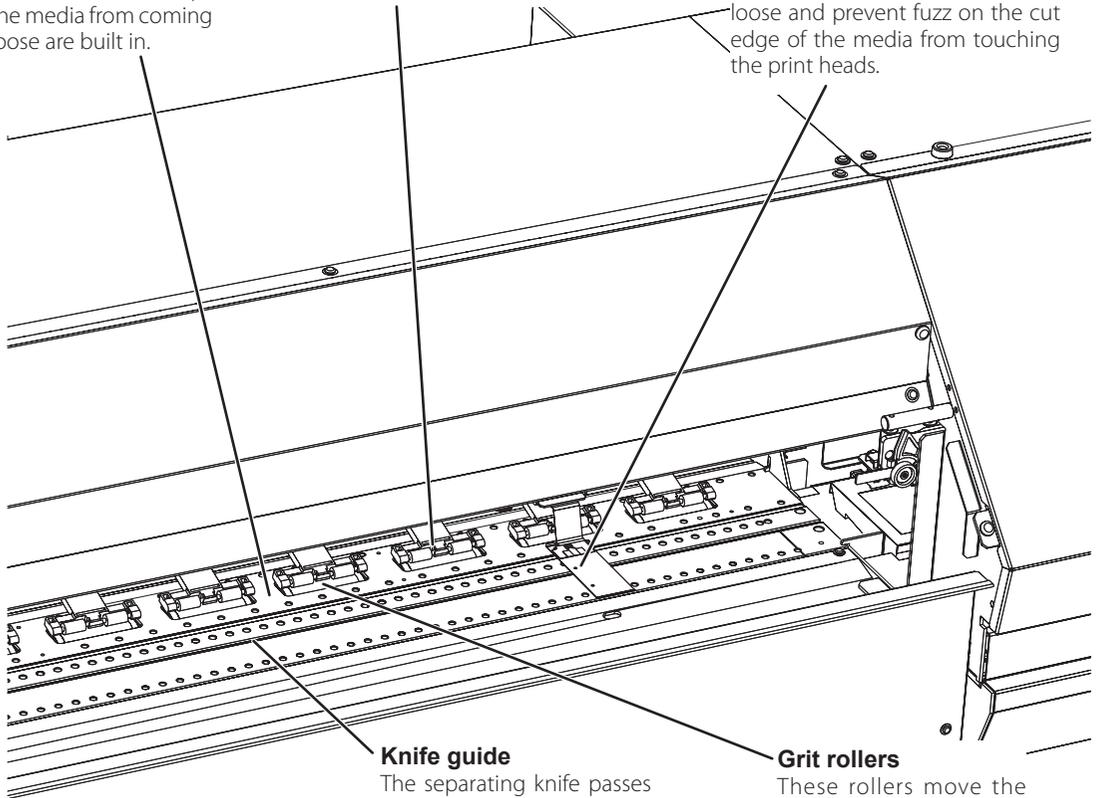
This is the path over which the media passes. A suction fan that keeps the media from coming loose are built in.

Pinch rollers

Pinches the media when you pull the loading lever toward you.

Media clamps

These keep the media from coming loose and prevent fuzz on the cut edge of the media from touching the print heads.



Knife guide

The separating knife passes through this when you perform media cutoff.

Grit rollers

These rollers move the media forward and backward.

Operation Panel

Display screen

This displays various setting menus and other information.

BUSY light

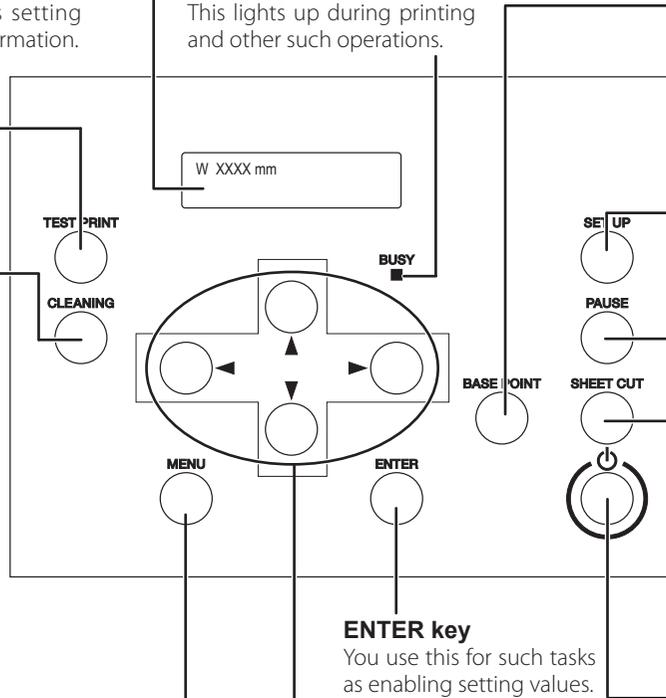
This lights up during printing and other such operations.

TEST PRINT key

Holding this down for one second or longer performs a printing test.

CLEANING key

You use this to perform cleaning of the print heads.



BASE POINT key

You use this when you want to set the output-start location. This lights up when the setting has been made.

SETUP key

You press this when you load media. This lights up when media is loaded and the machine is ready to perform output.

PAUSE key

This pauses the output operation. This lights up when operation is paused.

SHEET CUT key

Holding this down for one second or longer cuts off media.

MENU key

You press this to enter the menus for various settings.

Cursor keys

You use these to select settings for menu items, to move the media, and for other such operations.

ENTER key

You use this for such tasks as enabling setting values.

Sub power switch

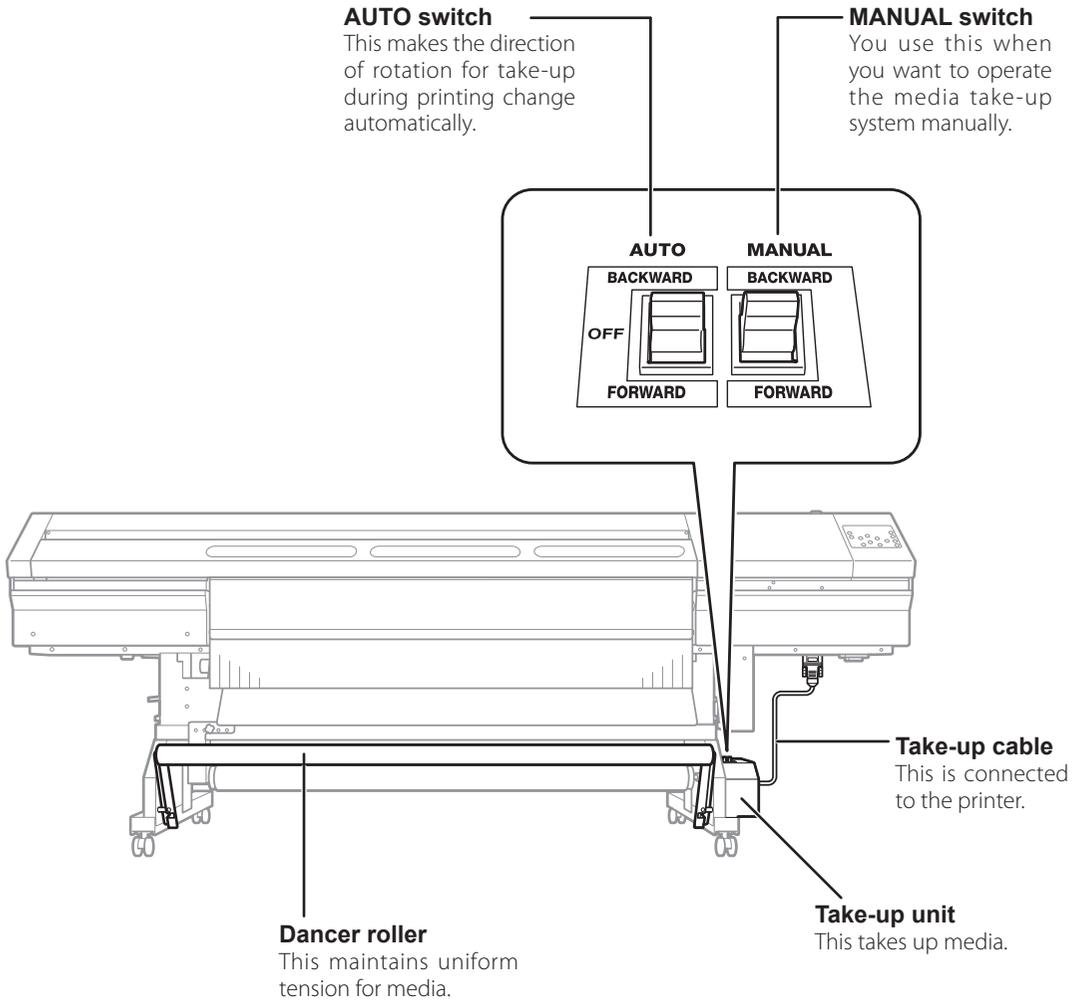
This switches the printer on and off. (To switch the printer off, you hold down the switch for one second or longer.) This flashes slowly when the machine is in the sleep mode.

Panel Notation

In this document, the keys and lights on the operation panel are indicated by the following images.

-  **MENU key**
-  **SETUP key**
-  **ENTER key**
-  **Cursor keys**
-  **PAUSE key**
-  **CLEANING key**
-  **TEST PRINT key**
-  **BASE POINT key**
-  **SHEET CUT key**

Media Take-up System

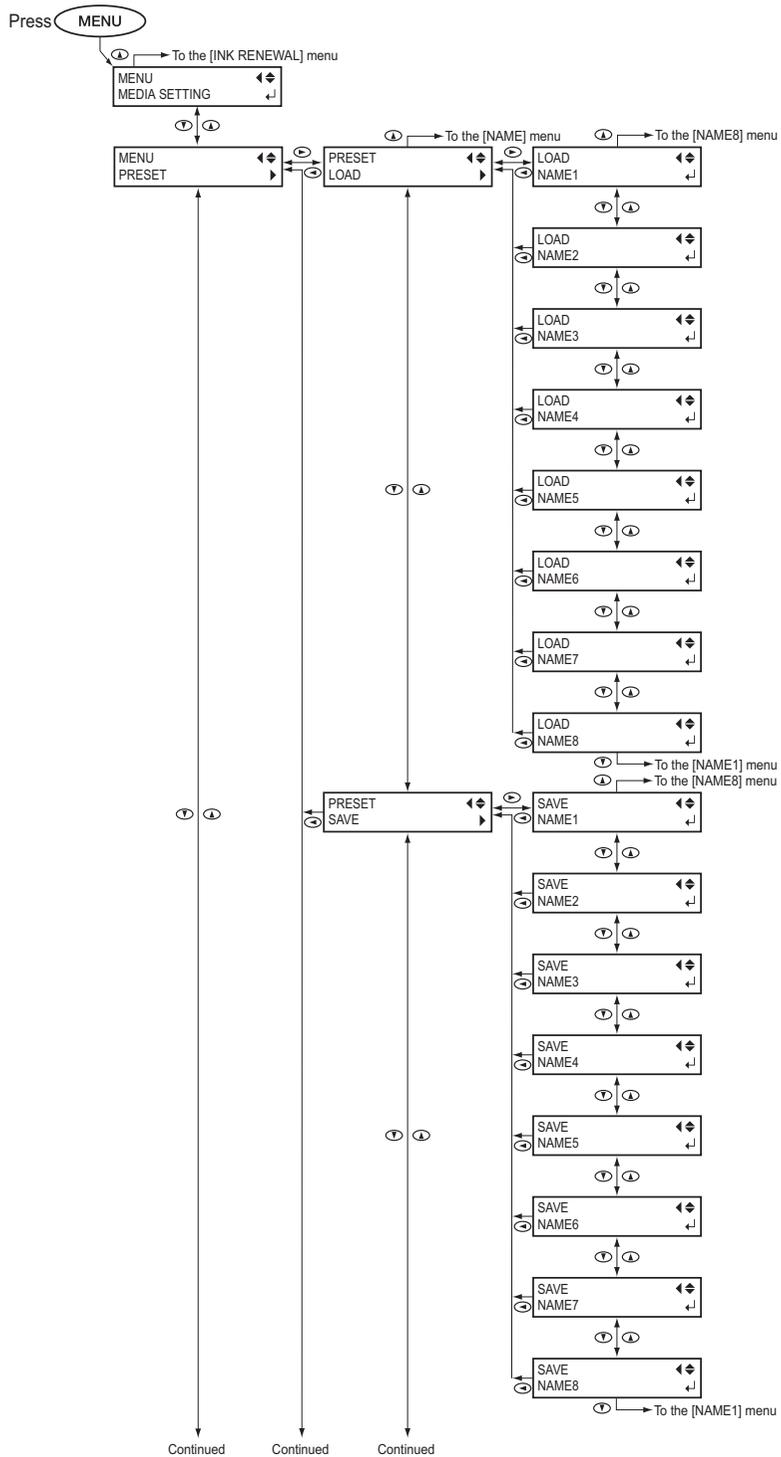


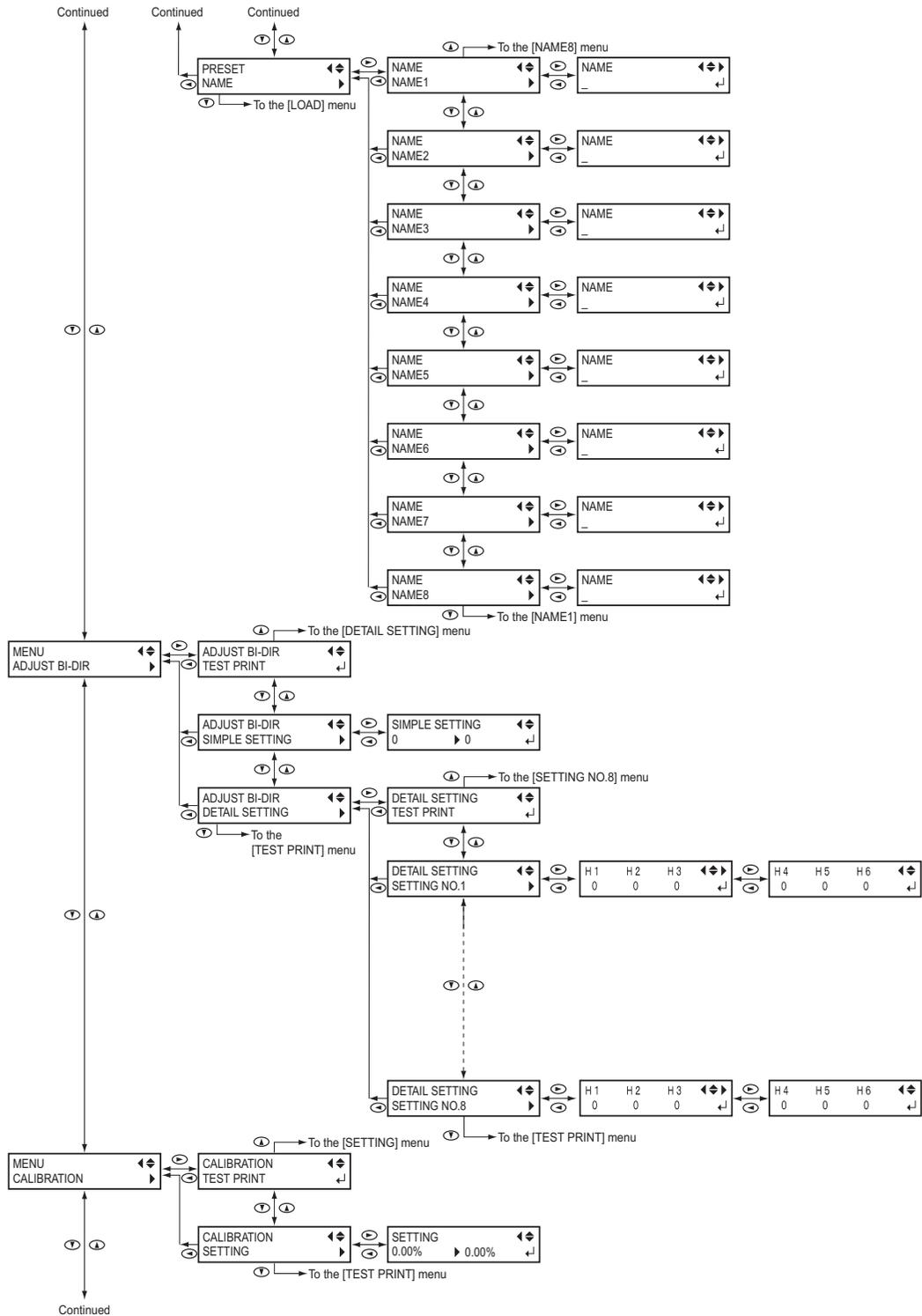
Menu List

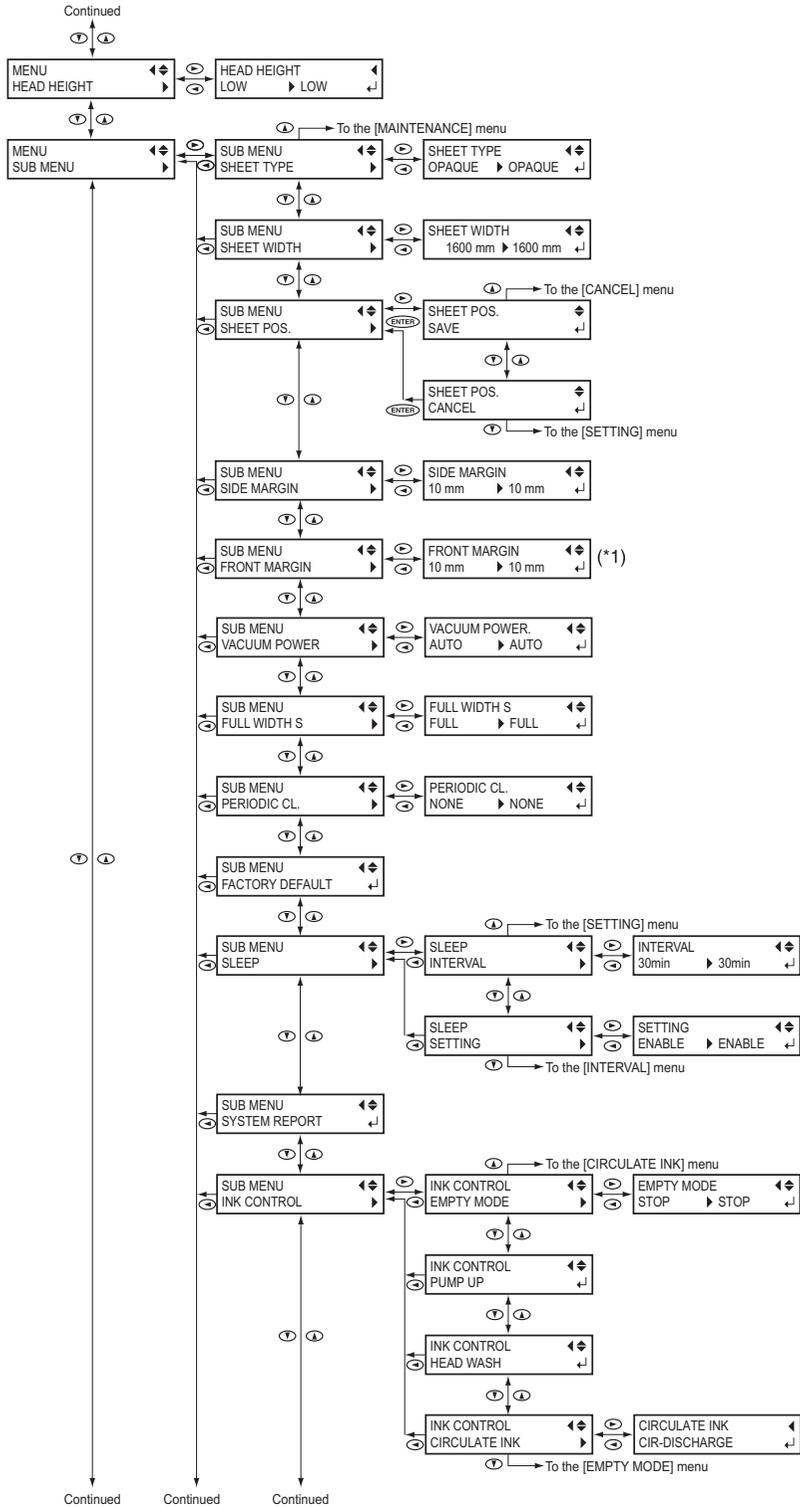
1

Machine
Highlights

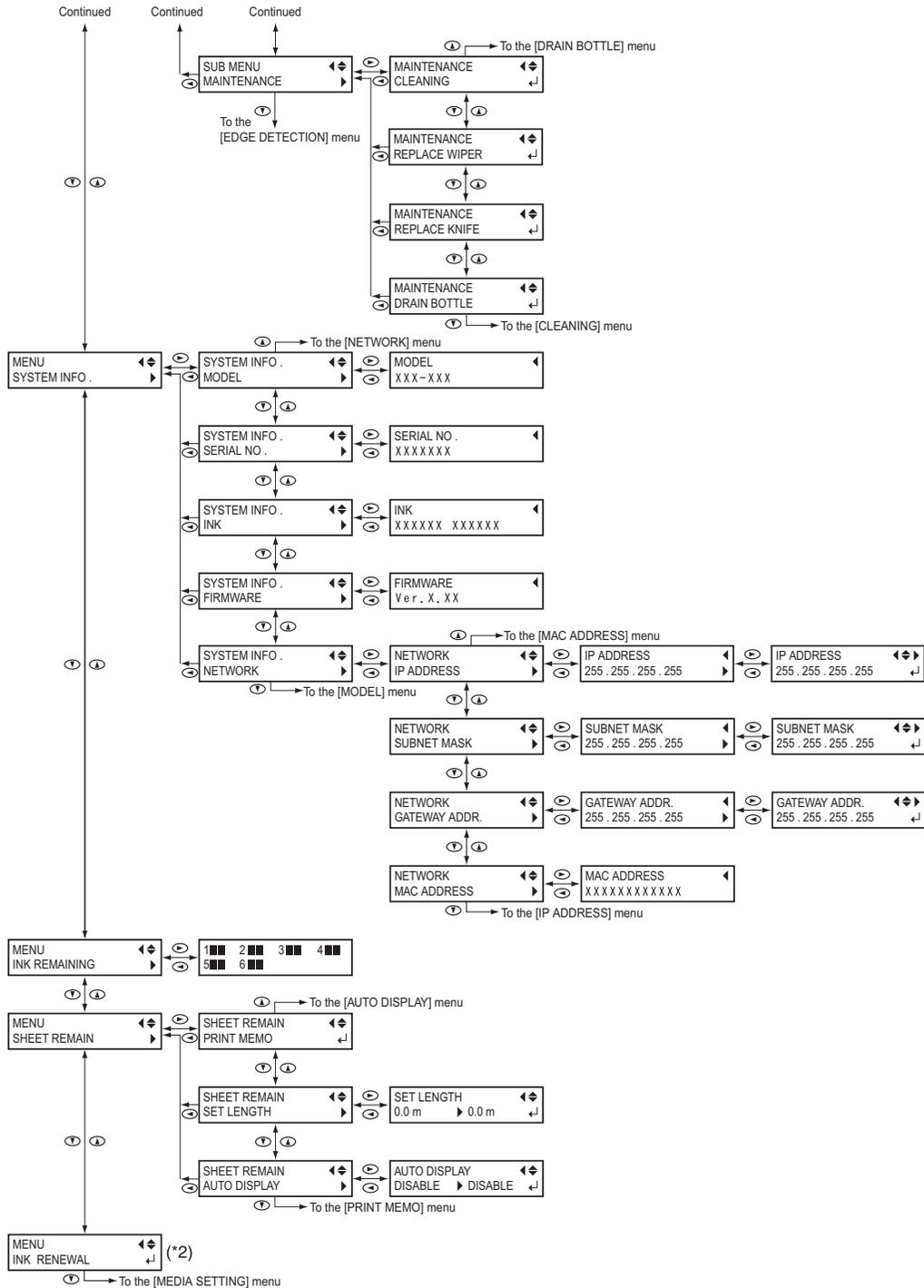
Main Menu







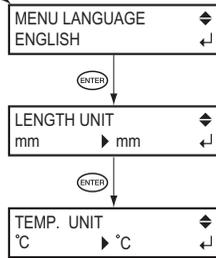
(*1) Only available when "SETUP SHEET" is set to "RIGID".



(*2) This is not displayed when "CMYKGLGI" (cyan, magenta, yellow, black, gloss, gloss) is selected as the ink mode.

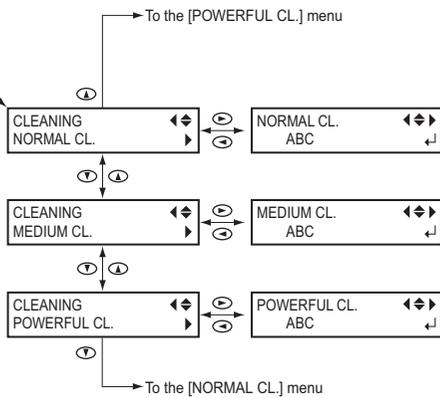
Language and Unit Menu

Hold down **MENU** and switch on the sub power.



Cleaning Menu

Press **CLEANING**.



Hold down **CLEANING** for one second or longer.

Normal cleaning for all print heads

To Ensure Safe Use

Improper handling or operation of this machine may result in injury or damage to property. Points which must be observed to prevent such injury or damage are described as follows.

About WARNING and CAUTION Notices

 WARNING	Used for instructions intended to alert the user to the risk of death or severe injury should the unit be used improperly.
 CAUTION	Used for instructions intended to alert the user to the risk of injury or material damage should the unit be used improperly. Note: Material damage refers to damage or other adverse effects caused with respect to the home and all its furnishings, as well to domestic animals or pets.

About the Symbols

	The  symbol alerts the user to important instructions or warnings. The specific meaning of the symbol is determined by the design contained within the triangle. The symbol at left means "danger of electrocution."
	The  symbol alerts the user to items that must never be carried out (are forbidden). The specific thing that must not be done is indicated by the design contained within the circle. The symbol at left means the unit must never be disassembled.
	The  symbol alerts the user to things that must be carried out. The specific thing that must be done is indicated by the design contained within the circle. The symbol at left means the power-cord plug must be unplugged from the outlet.

 **Incorrect operation may cause injury**

 **WARNING**

 **Be sure to follow the operation procedures described in this documentation. Never allow anyone unfamiliar with the usage or handling of the machine to touch it.**

Incorrect usage or handling may lead to an accident.

 **Keep children away from the machine.**
The machine includes areas and components that pose a hazard to children and may result in injury, blindness, choking, or other serious accident.

 **Never operate the machine while tired or after ingesting alcohol or any medication.**
Operation requires unimpaired judgment. Impaired judgment may result in an accident.

 **Never use the machine for any purpose for which it is not intended, or use the machine in an undue manner that exceeds its capacity.**
Doing so may result in injury or fire.

 **For accessories (optional and consumable items, power cord, and the like), use only genuine articles compatible with this machine.**
Incompatible items may lead to an accident.

 **Before attempting cleaning, maintenance, or attachment or detachment of optional items, disconnect the power cord.**
Attempting such operations while the machine is connected to a power source may result in injury or electrical shock.

 **WARNING**

 **Never attempt to disassemble, repair, or modify the machine.**
Doing so may result in fire, electrical shock, or injury. Entrust repairs to a trained service technician.

 **CAUTION**

 **Exercise caution to avoid being pinched or becoming caught.**
Inadvertent contact with certain areas may cause the hand or fingers to be pinched or become caught. Use care when performing operations.

 **Never attempt operation while wearing a necktie, necklace, or loose clothing. Bind long hair securely.**
Such items may become caught in the machine, resulting in injury.

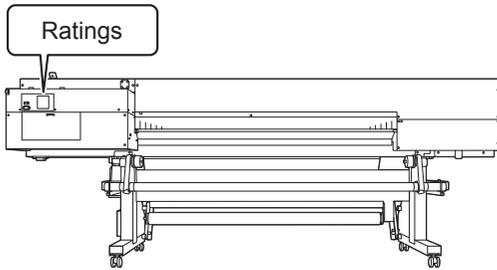
 **Conduct operations in a clean, brightly lit location.**
Working in a location that is dark or cluttered may lead to an accident, such as becoming caught in the machine as the result of an inadvertent stumble.

 **Never climb or lean on the machine.**
The machine is not made to support a person. Climbing or leaning on the machine may dislodge components and cause a slip or fall, resulting in injury.

⚠ Danger of electrical short, shock, electrocution, or fire

⚠ WARNING

! **Connect to an electrical outlet that complies with this machine's ratings (for voltage, frequency, and current).**
Incorrect voltage or insufficient current may cause fire or electrical shock.



⊘ **Never use out of doors or in any location where exposure to water or high humidity may occur. Never touch with wet hands.**
Doing so may result in fire or electrical shock.

⊘ **Never allow any foreign object to get inside. Never expose to liquid spills.**
Inserting objects such as coins or matches or allowing beverages to be spilled into the ventilation ports may result in fire or electrical shock. If anything gets inside, immediately disconnect the power cord and contact your authorized Roland DG Corp. dealer.

⊘ **Never place any flammable object nearby. Never use a combustible aerosol spray nearby. Never use in any location where gases can accumulate.**
Combustion or explosion may be a danger.

⚠ WARNING

! **Handle the power cord, plug, and electrical outlet correctly and with care. Never use any article that is damaged.**
Using a damaged article may result in fire or electrical shock.

! **When using an extension cord or power strip, use one that adequately satisfies the machine's ratings (for voltage, frequency, and current).**
Use of multiple electrical loads on a single electrical outlet or of a lengthy extension cord may cause fire.

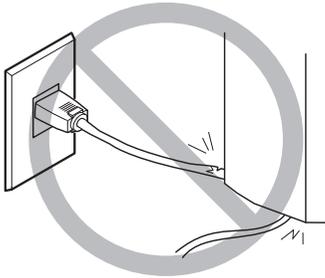
⏚ **Connect to ground.**
This can prevent fire or electrical shock due to current leakage in the event of malfunction.

! **Position so that the power plug is within immediate reach at all times.**
This is to enable quick disconnection of the power plug in the event of an emergency. Install the machine next to an electrical outlet. Also, provide enough empty space to allow immediate access to the electrical outlet.

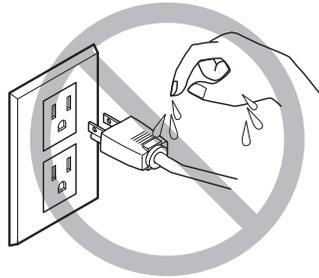
! **If sparking, smoke, burning odor, unusual sound, or abnormal operation occurs, immediately unplug the power cord. Never use if any component is damaged.**
Continuing to use the machine may result in fire, electrical shock, or injury. Contact your authorized Roland DG Corp. dealer.

! **Do not use the supplied power supply cord for other products.**

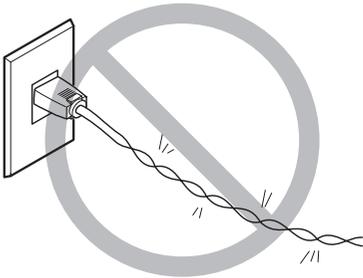
 Important notes about the power cord, plug, and electrical outlet



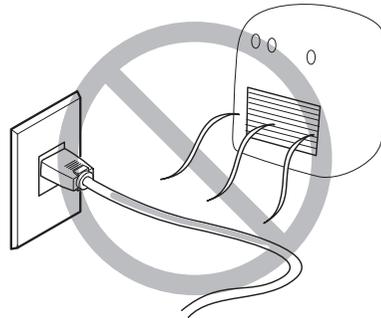
Never place any object on top or subject to damage.



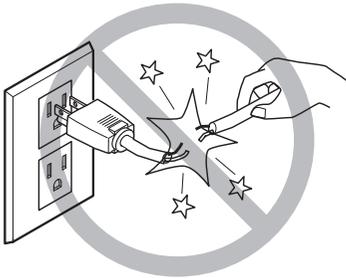
Never allow to get wet.



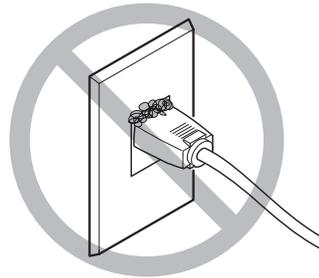
Never bend or twist with undue force.



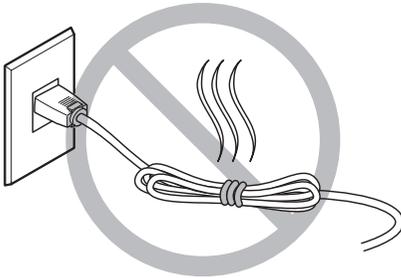
Never make hot.



Never pull with undue force.



Dust may cause fire.



Never bundle, bind, or roll up.

 **Ink, cleaning liquid, and discharged fluid are flammable and toxic**

 **WARNING**

 **Keep open flame away from the work area.**
Ink and discharged fluid are flammable.

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

- Any location exposed to open flame
- Any location where high temperature may occur
- Near bleach or any other such oxidizing agent or explosive material
- Any location within the reach of children

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

 **Never place an ink cartridge in fire.**
Ink may flow out, catch fire, and spread fire to other nearby objects.

 **WARNING**

 **Never drink or sniff ink, cleaning liquid, or discharged fluid, or allow them to come in contact with the eyes or skin.**
Doing so may be hazardous to the health.

 **CAUTION**

 **Ensure adequate ventilation for the work area.**
Failing to perform ventilation may result in a health hazard or danger of combustion due to ink fumes.

 **Never allow an ink cartridge to be subjected to impact, and never attempt to disassemble.**
Ink may leak.

 **In the event of ingestion or physical distress**

- In the event of contact with the eyes, immediately flush with water for at least 15 minutes. If eye irritation continues, seek treatment by a physician.
- In the event of contact with skin, immediately wash with soap. If irritation or inflammation occurs, seek treatment by a physician.
- In the event of ingestion, do not induce vomiting, and immediately seek treatment by a physician. Forcibly inducing vomiting may lead to danger of choking.
- If odor leads to physical distress, move to a well-ventilated location and rest quietly. If dizziness or nausea persists, seek treatment by a physician.

* Refer to the appropriate safety data sheet (SDS) for the chemical substances used in the ink and the safety related to those substances.

 This machine weighs 400 kg (882 lb.). Media weighs 40 kg (88 lb.).

 **WARNING**

 **Install the machine in a location that is level, stable, and able to bear the weight of the machine.**

The total weight of the machine may reach 400 kg (882 lb.) or more. Installation in an unsuitable location may cause a major accident, including tip over, fall, or collapse.

 **Unloading and emplacement are operations that must be performed by 6 persons or more.**

Tasks that require undue effort when performed by a small number of persons may result in physical injury. Also, if dropped, such items may cause injury.

 **Be sure to lock the stand's casters.**

If the machine should begin to topple, a major accident may result, including crushing of the appendages or the body.

 **WARNING**

 **When storing roll media, implement adequate safety measures to ensure that the stored media will not roll, fall, or topple over.**

Danger exists of becoming pinned under the media and suffering serious injury.

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

Attempting to lift heavy media in a manner that taxes your strength may cause physical injury.

 This machine uses ultraviolet light.

 **CAUTION**

 **Never look at the blue-white (ultraviolet) light emitted from the print-head area for an extended time.**

Looking directly at the ultraviolet light from up close for an extended period may result in eye injury.

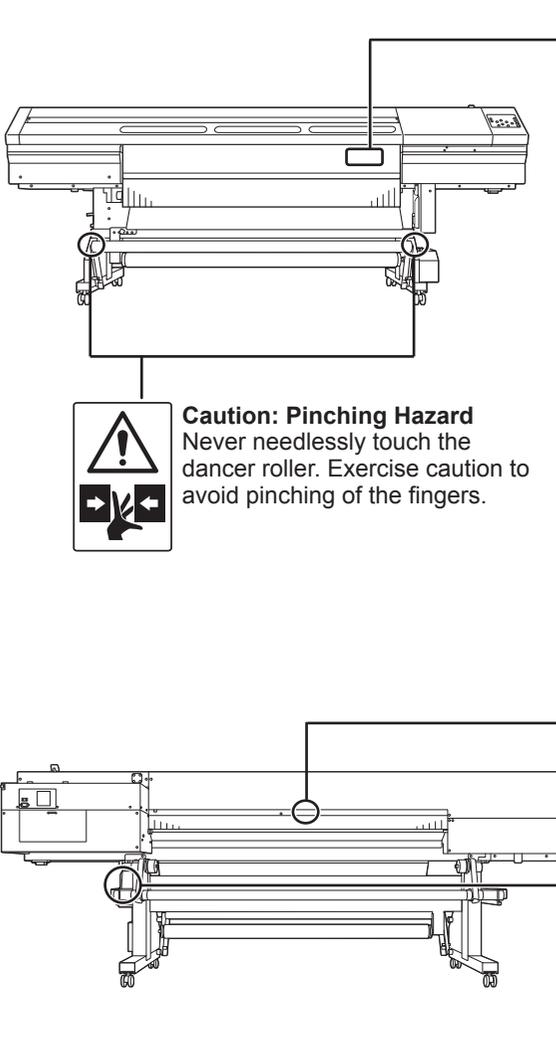
 **Caution: Ultraviolet Light**

This machine is fitted with covers to keep external leakage of ultraviolet light at low levels, but incorrect handling or operation can lead to physical injury due to ultraviolet light. The extent of injury depends on the intensity and wavelength of the ultraviolet light, and the length of time of exposure. Prolonged exposure to strong ultraviolet light of hazardous wavelengths can cause injury to the eyes or skin. Exercise caution.

⚠ Warning Labels

Warning labels are affixed to make areas of danger immediately clear. The meanings of these labels are as follows. Be sure to heed their warnings.

Also, never remove the labels or allow them to become obscured.



Caution: Pinching Hazard
Never needlessly touch the dancer roller. Exercise caution to avoid pinching of the fingers.

Flammable
Ink and discharged fluid are flammable. Keep away from open flame.

Ink Is Toxic
Ink and discharged fluid are toxic. Avoid contact with the body. Use only in a well-ventilated area.

Caution: Ultraviolet Light
Never look directly from up close for a prolonged period.

Caution: Moving Print Heads
The print heads inside the cover move at high speed and pose a hazard. Never insert the hand or fingers into the gap.

Caution: Pinching Hazard
Be careful not to allow the fingers to become pinched when loading media or closing covers.

Caution: Ultraviolet Light
Never look directly from up close for a prolonged period.

Flammable
Ink and discharged fluid are flammable. Keep away from open flame.

Ink Is Toxic
Ink and discharged fluid are toxic. Avoid contact with the body. Use only in a well-ventilated area.



Pour utiliser en toute sécurité

La manipulation ou l'utilisation inadéquates de cet appareil peuvent causer des blessures ou des dommages matériels. Les précautions à prendre pour prévenir les blessures ou les dommages sont décrites ci-dessous.

Avis sur les avertissements

 ATTENTION	Utilisé pour avertir l'utilisateur d'un risque de décès ou de blessure grave en cas de mauvaise utilisation de l'appareil.
 PRUDENCE	Utilisé pour avertir l'utilisateur d'un risque de blessure ou de dommage matériel en cas de mauvaise utilisation de l'appareil. *Par dommage matériel, il est entendu dommage ou tout autre effet indésirable sur la maison, tous les meubles et même les animaux domestiques.

À propos des symboles

	Le symbole  attire l'attention de l'utilisateur sur les instructions importantes ou les avertissements. Le sens précis du symbole est déterminé par le dessin à l'intérieur du triangle. Le symbole à gauche signifie "danger d'électrocution."
	Le symbole  avertit l'utilisateur de ce qu'il ne doit pas faire, ce qui est interdit. La chose spécifique à ne pas faire est indiquée par le dessin à l'intérieur du cercle. Le symbole à gauche signifie que l'appareil ne doit jamais être démonté.
	Le symbole  prévient l'utilisateur sur ce qu'il doit faire. La chose spécifique à faire est indiquée par le dessin à l'intérieur du cercle. Le symbole à gauche signifie que le fil électrique doit être débranché de la prise.

 **L'utilisation incorrecte peut causer des blessures**

 **ATTENTION**



S'assurer de suivre les procédures d'utilisation décrites dans la documentation. Ne jamais permettre à quiconque ne connaît pas le fonctionnement ou la manutention de l'appareil de le toucher. L'utilisation ou la manutention incorrectes peuvent causer un accident.



Garder les enfants loin de l'appareil.

L'appareil comporte des zones et des composants qui présentent un danger pour les enfants et qui pourraient causer des blessures, la cécité, la suffocation ou d'autres accidents graves.



Ne jamais faire fonctionner l'appareil après avoir consommé de l'alcool ou des médicaments, ou dans un état de fatigue.

L'utilisation de l'appareil exige un jugement sans faille. L'utilisation avec les facultés affaiblies pourrait entraîner un accident.



Ne jamais utiliser l'appareil à des fins autres que celles pour lesquelles il est conçu. Ne jamais l'utiliser de manière abusive ou d'une manière qui dépasse sa capacité.

Le non-respect de cette consigne peut causer des blessures ou un incendie.



Utiliser uniquement des accessoires d'origine (accessoires en option, articles consommables, câble d'alimentation et autres articles semblables), compatibles avec l'appareil.

Les articles incompatibles risquent de causer des accidents.

 **ATTENTION**



Débrancher le câble d'alimentation avant de procéder au nettoyage ou à l'entretien de l'appareil, et avant d'y fixer ou d'en retirer des accessoires en option.

Tenter ces opérations pendant que l'appareil est branché à une source d'alimentation peut causer des blessures ou un choc électrique.



Ne jamais tenter de démonter, de réparer ou de modifier l'appareil.

Le non-respect de cette consigne risque de provoquer un incendie, un choc électrique ou des blessures. Confier les réparations à un technicien ayant la formation requise.

 **PRUDENCE**



Faire preuve de prudence pour éviter l'écrasement ou le coincement.

La main ou les doigts peuvent être écrasés ou coincés s'ils entrent en contact avec certaines surfaces par inadvertance. Faire preuve de prudence pendant l'utilisation de l'appareil.



Ne jamais faire fonctionner l'appareil si on porte une cravate, un collier ou des vêtements amples. Bien attacher les cheveux longs.

Ces vêtements ou ces objets peuvent être coincés dans l'appareil, ce qui causerait des blessures.



Utiliser l'appareil dans un endroit propre et bien éclairé.

Travailler dans un endroit sombre ou encombré peut causer un accident; l'utilisateur risque, par exemple, de trébucher malencontreusement et d'être coincé par une partie de l'appareil.

⚠ PRUDENCE



Ne jamais grimper ni s'appuyer sur la machine.

La machine n'est pas conçue pour supporter le poids d'une personne. Grimper ou s'appuyer sur la machine peut déplacer des éléments et causer un faux pas ou une chute, ce qui causerait des blessures.



Risque de décharge ou de choc électrique, d'électrocution ou d'incendie

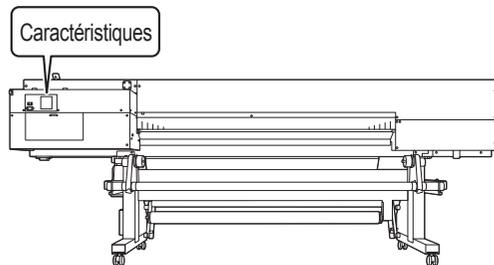


ATTENTION



Brancher à une prise électrique conforme aux caractéristiques de cet appareil (tension, fréquence et courant).

Une tension incorrecte ou un courant insuffisant peuvent causer un incendie ou un choc électrique.



ATTENTION



Ne jamais insérer d'objet étranger dans l'appareil. Ne jamais exposer l'appareil aux déversements de liquides.

L'insertion d'objets comme des pièces de monnaie ou des allumettes, ou le déversement de liquides dans les orifices de ventilation peuvent causer un incendie ou un choc électrique. Si un objet ou du liquide s'infiltré dans l'appareil, débrancher immédiatement le câble d'alimentation et communiquer avec le représentant Roland DG Corp. autorisé.



Ne jamais placer d'objet inflammable à proximité de l'appareil. Ne jamais utiliser de produit inflammable en aérosol à proximité de l'appareil. Ne jamais utiliser l'appareil dans un endroit où des gaz peuvent s'accumuler.

Une combustion ou une explosion pourraient se produire.



Ne jamais utiliser à l'extérieur ni à un endroit où l'appareil risque d'être exposé à de l'eau ou à une humidité élevée. Ne jamais toucher l'appareil avec des mains mouillées.

Le non-respect de cette consigne risque de provoquer un incendie ou un choc électrique.

 **Risque de décharge ou de choc électrique, d'électrocution ou d'incendie**

 **ATTENTION**



Manipuler le câble d'alimentation, la fiche et la prise électrique correctement et avec soin.

Ne jamais utiliser un article endommagé, car cela pourrait causer un incendie ou un choc électrique.



Si une rallonge ou une bande d'alimentation électrique sont utilisées, s'assurer qu'elles correspondent aux caractéristiques de l'appareil (tension, fréquence et courant).

L'utilisation de plusieurs charges électriques sur une prise unique ou une longue rallonge peut causer un incendie.



Mise à la terre.

La mise à la terre peut prévenir un incendie ou un choc électrique dus à une fuite de courant en cas de défaillance.



Placer l'appareil de façon à ce que la fiche soit facile d'accès en tout temps.

Ainsi, l'appareil pourra être débranché rapidement en cas d'urgence. Installer l'appareil près d'une prise électrique. En outre, prévoir suffisamment d'espace pour que la prise électrique soit facile d'accès.

 **ATTENTION**



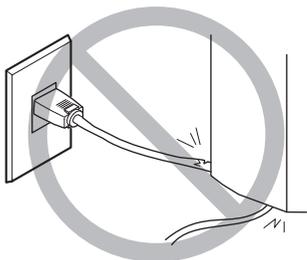
S'il se produit des étincelles, de la fumée, une odeur de brûlé, un bruit inhabituel ou un fonctionnement anormal, débrancher immédiatement le câble d'alimentation. Ne jamais utiliser si un composant est endommagé.

Continuer à utiliser l'appareil peut causer un incendie, un choc électrique ou des blessures. Communiquer avec le représentant Roland DG Corp. Autorisé.

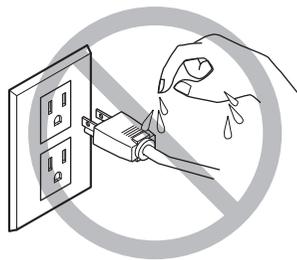


Ne pas utiliser le cordon électrique fourni avec d'autres produits.

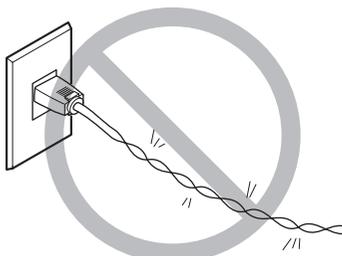
 Remarques importantes à propos du câble d'alimentation, de la fiche et de la prise électrique



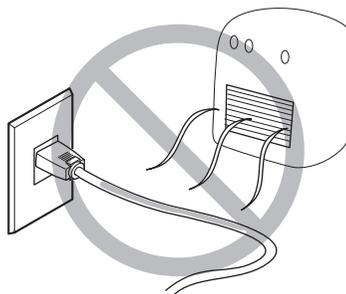
Ne jamais déposer aucun objet sur le câble, sur la fiche ou sur la prise car cela risque de les endommager.



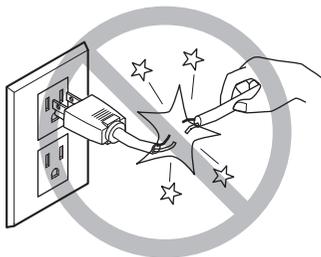
Ne jamais laisser l'eau toucher le câble, la fiche ou la prise.



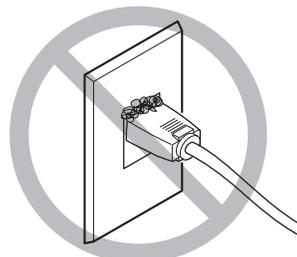
Ne jamais plier ni tordre le câble avec une force excessive.



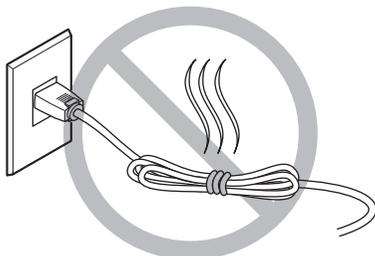
Ne jamais chauffer le câble, la fiche ou la prise.



Ne jamais tirer sur le câble ou la fiche avec une force excessive.



La poussière peut causer un incendie.



Ne jamais plier ni enrouler le câble.

 **L'encre, les liquides nettoyants et les liquides usés sont inflammables et toxiques**

 **ATTENTION**



Ne pas approcher une flamme nue de l'espace de travail.
L'encre et les liquides usés sont inflammables.



Ne jamais entreposer d'encre, de liquide de nettoyage ou des liquides usés dans les endroits suivants :

- un endroit exposé à une flamme nue;
- un endroit où il y a risque de température élevée;
- près d'eau de Javel, d'un autre agent d'oxydation ou de matériel explosif;
- tout endroit à la portée d'enfants.

Il y a risque d'incendie. L'ingestion accidentelle par un enfant peut présenter un risque pour la santé.



Ne jamais incinérer une cartouche d'encre.

De l'encre pourrait couler, s'enflammer et le feu se répandre à des objets proches.

 **ATTENTION**



Ne jamais boire l'encre, le liquide de nettoyage ni les liquides usés, ne pas en respirer les vapeurs et ne pas laisser les produits entrer en contact avec les yeux ou la peau.
Cela est dangereux pour la santé.

 **PRUDENCE**



S'assurer que le lieu de travail est bien aéré.

L'absence d'aération adéquate peut créer une situation dangereuse pour la santé ou un risque de combustion à cause des vapeurs qui émanent de l'encre.



Ne jamais soumettre une cartouche d'encre à des chocs. Ne jamais tenter d'ouvrir une cartouche d'encre.

De l'encre pourrait s'échapper.

 **En cas d'ingestion ou de trouble physique**

- En cas de contact avec les yeux : rincer immédiatement et abondamment à l'eau courante pendant au moins 15 minutes. Si les yeux sont toujours irrités, consulter un médecin.
- En cas de contact avec la peau : laver immédiatement à l'eau et au savon. En cas d'irritation ou d'inflammation de la peau : consulter un médecin.
- En cas d'ingestion : ne pas provoquer le vomissement et demander immédiatement l'aide d'un médecin. Provoquer le vomissement peut créer un risque de suffocation.
- Si l'odeur cause un trouble physique, amener la personne dans un endroit bien aéré et la faire se reposer. Si l'étourdissement ou la nausée persistent, consulter un médecin.

* Se reporter à la fiche signalétique (FS) pour connaître les renseignements concernant les produits chimiques utilisés dans l'encre et les mesures de sécurité.

 **Le poids de cet appareil est de 400 kg (882 lb.)**
Le poids du support est de 40 kg (88 lb.)

 **ATTENTION**

 **Installer l'appareil à un endroit stable et plat et capable de supporter son poids.**
Le poids total de l'appareil peut être d'au moins 400 kg (882 lb.). Installer l'appareil à un endroit inapproprié peut provoquer un accident grave comme le renversement, la chute ou l'écrasement.

 **Le déchargement et la mise en place doivent être faits par au moins six personnes.**
Les tâches qui exigent un effort trop grand si elles sont exécutées par un petit nombre de personnes peuvent être cause de blessures. La chute d'articles très lourds peut aussi causer des blessures.

 **ATTENTION**

 **S'assurer de verrouiller les roulettes de la base.**
Si l'appareil devait commencer à basculer, il s'ensuivrait un accident grave, par exemple l'écrasement de membres ou du corps.

 **Prendre les mesures de sécurité adéquates pour l'entreposage des rouleaux de support pour s'assurer qu'ils ne rouleront pas, ne tomberont pas et ne se renverseront pas.**
Il y a risque d'être écrasé par le support et de subir des blessures graves.

 **La manutention du support en rouleau doit être faite par deux personnes ou plus et il faut prendre des précautions pour éviter les chutes.**
Tenter de soulever des objets trop lourds peut causer des blessures.

 **Cet appareil utilise des rayons ultraviolets.**

 **PRUDENCE**

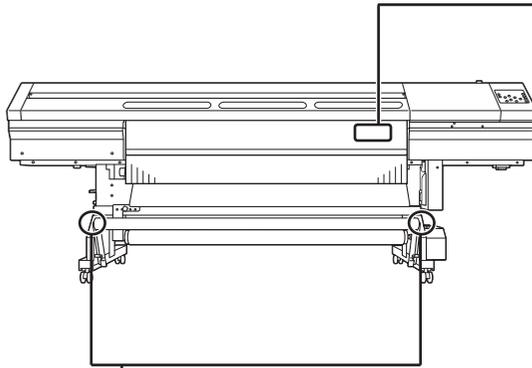
 **Ne jamais regarder pendant de longues périodes le rayonnement blanc bleuté (ultraviolet) émis par la tête d'impression.**
Le fait de regarder directement et de près le rayonnement ultraviolet pendant une période prolongée peut causer des lésions oculaires.

 **Attention : Rayonnement ultraviolet**

Cet appareil est muni de couvercles destinés à empêcher les fuites de rayonnement ultraviolet à faible niveau, mais sa manipulation ou son utilisation incorrectes peuvent causer des lésions dues au rayonnement ultraviolet. La gravité des lésions est fonction de l'intensité et de la longueur d'onde du rayonnement ultraviolet et de la durée de l'exposition. L'exposition prolongée à un fort rayonnement ultraviolet de longueur d'onde dangereuse peut causer des lésions oculaires ou cutanées. La prudence est de rigueur.

⚠ Vignettes d'avertissement

Des vignettes d'avertissement sont apposées pour qu'il soit facile de repérer les zones dangereuses. La signification des vignettes est donnée ci-dessous. Respecter les avertissements. Ne jamais retirer les vignettes et ne pas les laisser s'encrasser.



Attention : Risque de pincement
Ne jamais toucher inutilement le rouleau compensateur. Faire attention pour éviter de coincer les doigts.



Inflammable

L'encre et les liquides usés sont inflammables. Les garder loin de toute flamme nue.



L'encre est toxique

L'encre et les liquides usés sont toxiques. Éviter tout contact avec le corps. Utiliser uniquement dans un endroit bien aéré.



Attention : Rayonnement ultraviolet

Ne jamais regarder de près et directement pendant une période prolongée.



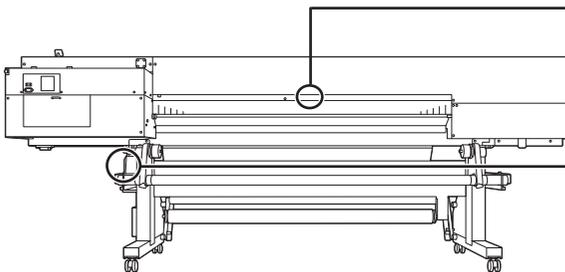
Attention : Têtes d'impression mobiles

Les têtes d'impression sous le couvercle se déplacent à haute vitesse et représentent un danger. Ne jamais insérer la main ou les doigts dans l'ouverture.



Attention : Risque de pincement

Faire attention de ne pas coincer les doigts pendant le chargement du support ou lors de la fermeture du couvercle.



Attention : Rayonnement ultraviolet

Ne jamais regarder de près et directement pendant une période prolongée.



Inflammable

L'encre et les liquides usés sont inflammables. Les garder loin de toute flamme nue.



L'encre est toxique

L'encre et les liquides usés sont toxiques. Éviter tout contact avec le corps. Utiliser uniquement dans un endroit bien aéré.

Important Notes on Handling and Use

This machine is a precision device. To ensure the full performance of this machine, be sure to observe the following important points. Failure to observe them may not only result in loss of performance, but may also cause malfunction or breakdown.

Printer Unit

This machine is a precision device.

- Handle carefully, and never subject the machine to impact or excessive force.
- Never needlessly put your hand or fingers inside the cover, the ink-cartridge ports, or other internal areas of the machine.

Install in a suitable location.

- Install in a location having the specified temperature and relative humidity.
- Install in a quiet, stable location offering good operating conditions.

The print heads and the UV emitter are delicate devices.

- Never needlessly touch or allow media to scrape them. Failure to handle with care may cause damage.
- The print heads may be damaged if allowed to dry out. The machine prevents desiccation automatically, but improper operation may render this feature inoperative. Operate properly, as specified in this manual.
- Never allow the machine to stand with an ink cartridge removed. Remaining ink in the printer may harden and clog the print heads.
- The print heads are components that wear out. Periodic replacement is required, with the frequency of replacement depending on use.

Ink Cartridges

Ink cartridges come in various types.

- Use a type that is compatible with the printer. Also, be sure to use only genuine items from Roland DG Corp.

Never subject to impact or attempt to disassemble.

- Never drop or shake forcefully. The impact may rupture the internal pouch and cause the ink to leak.
- Never attempt to disassemble.
- Never attempt to refill the ink.
- If ink gets on your hands or clothing, wash it off as soon as possible. Removal may become difficult if allowed to stand.

Storage

- Use up the ink before the expiration date printed on the ink cartridge.
- Store the ink cartridge in a location avoiding direct sunlight or strong illumination.
- Store the ink cartridge unopened in a well-ventilated location at a temperature of over 5°C (41°F) and under 35°C (95°F) and relative humidity of 20 to 80%.

Chapter 2

Basic Operation

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Prepare the Media

Type of Media

In this manual, the paper used for output is called "media." There are the following main three media types used in this machine.

- **Roll media: Media wound onto a paper tube**
- **Sheet media: Media not wound onto a paper tube such as standard-size media**
- **Rigid media: Sheet media that is rigid**

Roll media, sheet media, and rigid media of various qualities can be selected according to the application.

For detailed information about each media, contact your media supplier. Media is also available from our following website.

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

Usable Media

This machine cannot necessarily output to every kind of media. When selecting media, be sure to carry out testing in advance to make sure that satisfactory output quality is obtained.

Roll media

Size

Width

210 to 1625 mm (8.3 to 64 inches)

Maximum media thickness

1.0 mm (39 mil)

Roll outer diameter

210 mm (8.3 inches)

Paper tube (core) inner diameter

76.2 mm (3 inches) or 50.8 mm (2 inches)

Note: To use 2 inches media, the optional media flanges are required. For information about optional items, contact your authorized dealer or us.

Maximum Weight

40 kg (88 lb.)

Other Conditions

Media such as the following cannot be used.

- Media whose end is attached to the paper tube (core)
- Media which is severely warped or which has a strong tendency to reroll
- Media that cannot withstand the tensioning of the media take-up or feed system
- Media whose paper tube (core) is bent or crushed
- Media that bends under its own weight when loaded
- Media on a sagging roll
- Media that is rolled unevenly
- Media that has an electrostatic charge

Sheet media / Rigid media

Size

Width

250 to 1625 mm (9.8 to 64 inches)

Maximum media thickness

13 mm (0.5 inch)

Maximum Weight

12 kg (26 lb.)

Other Conditions

- Certain metallic and glass materials cannot be used even if they satisfy the conditions listed above.
- When using media that is warped, print quality will be affected if the ripples in the media are 0.5 mm (0.02 inch) or higher, even if the media is held down by the media hold down bar.*

* Adjusting settings can improve print quality.

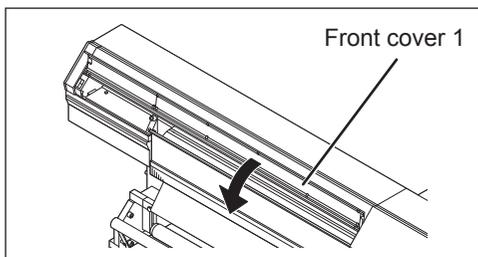
- ☞ P. 58, "Configuring Unidirectional Printing (VersaWorks Dual)"

Switch On

Switch On

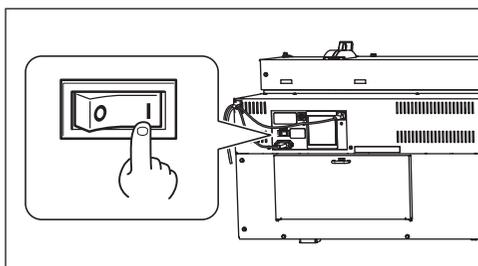
Procedure

1



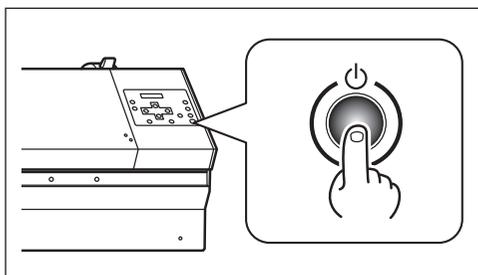
Close the front cover 1.

2



Turn on the main power switch.

3



Press the sub power button.

Note: For installation of the ink cartridge and selection of the language displayed on the display screen, refer to Setup Guide.

The Power-saving Feature (Sleep Mode)

This machine is provided with a power-saving feature that switches to a low-power "sleep mode" when a fixed interval passes with no operation. The factory default for the time after which the machine switches to the sleep mode is 30 minutes. When the machine is in the sleep mode, the sub power switch flashes slowly. Using the operation panel or performing operations such as sending print data from the computer (when media is loaded) restores the machine to its normal mode.

This setting of sleep mode can be changed. However, we recommend leaving the power-saving feature on and setting the activation time for the sleep mode to 30 minutes or less to reduce power consumption and so on.

☞ P. 140, "Setting the Interval until Activation of the Sleep Mode (Power Saving Function)."

☞ P. 141, "Deactivating the Sleep Mode (Power Saving Function)"

Loading Media

Loading Roll Media



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



Roll media weighs about 40 kg (88 lb.). Handling roll media is an operation that must be performed by two persons or more, and care must be taken to prevent falls.

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



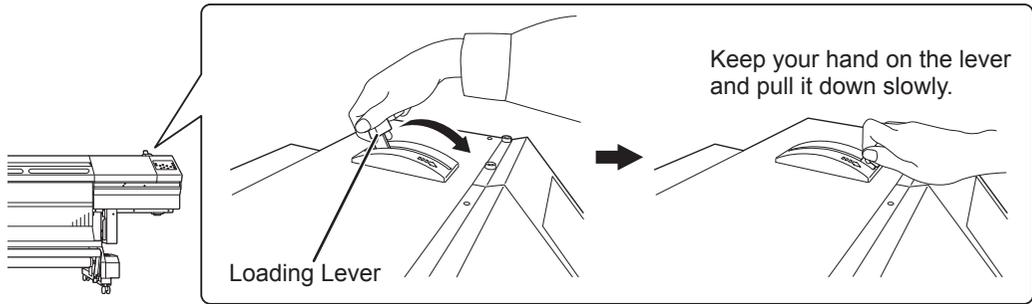
Never load media that weighs more than 40 kg (88 lb.) .

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



When pulling down the loading lever, pull the lever down gently and slowly, and keep your hand on the lever until you have pulled the lever down completely until it catches.

If you release the lever before it catches, the lever will fall down quickly and cause injury.

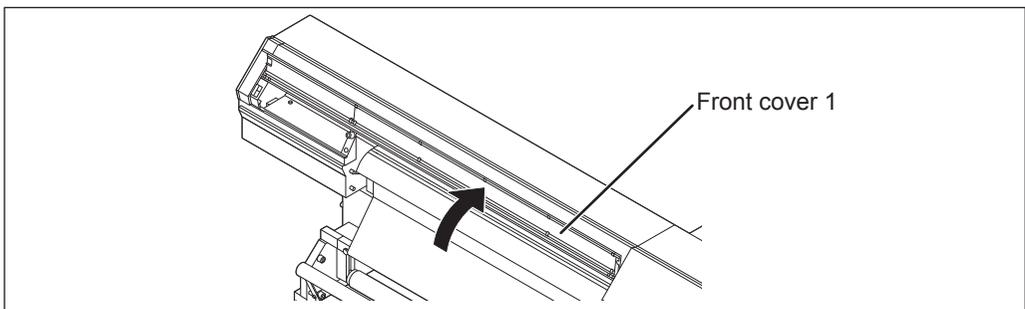


Note: Before loading roll media, remove the media hold down unit and the rigid media tables.

1. Install the media to the media holder.

Note: The media holder of this machine is exclusive use for the media of paper tube (core) inner diameter 3 inches. To use 2 inches media, the optional media flanges are required. For information about optional items, contact your authorized dealer or us.

1 Open the front cover 1.

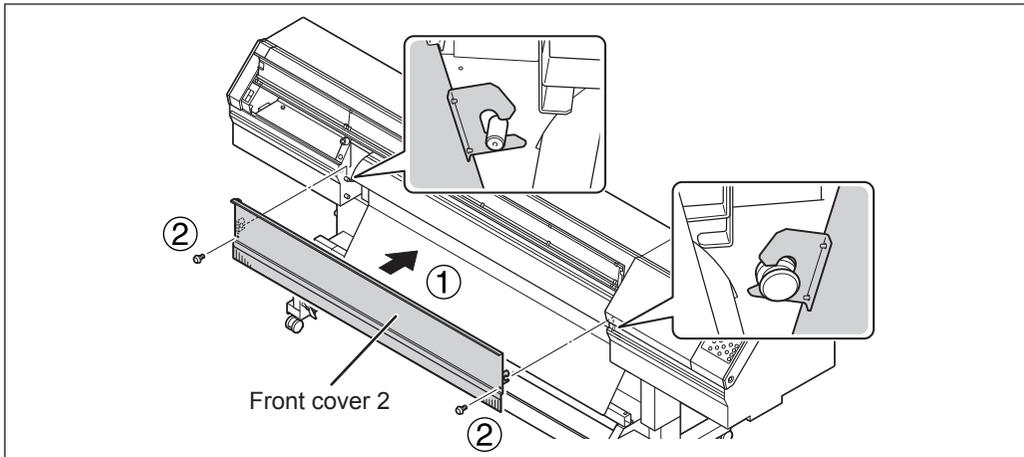


2 ① **Attach the front cover 2.**

If the front cover 2 is already attached, proceed to step **3**.

2 ② **Tighten the retaining screws.**

Make sure you secure the front cover 2 with the retaining screws.

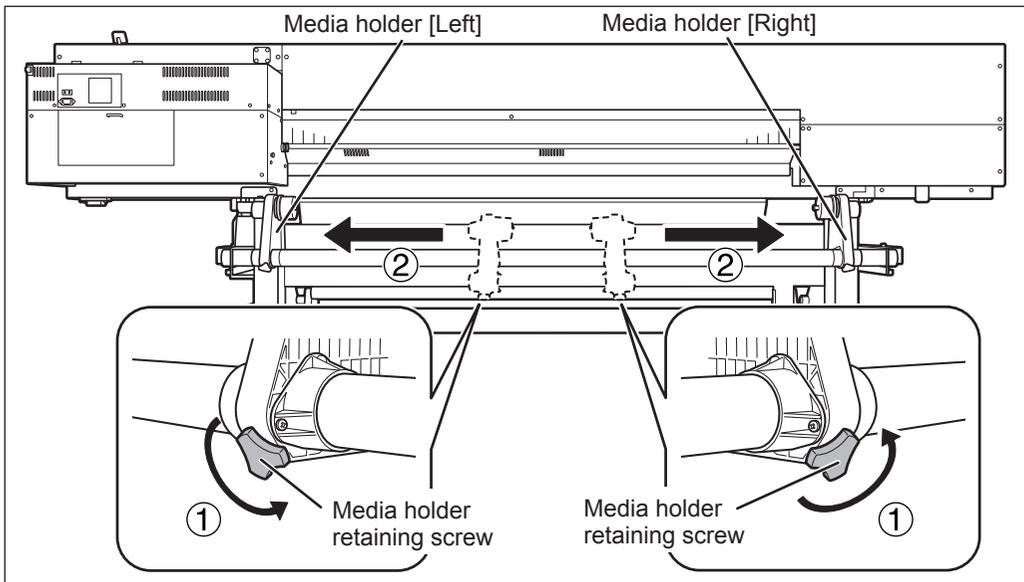


IMPORTANT! Make sure you attach the front cover 2.

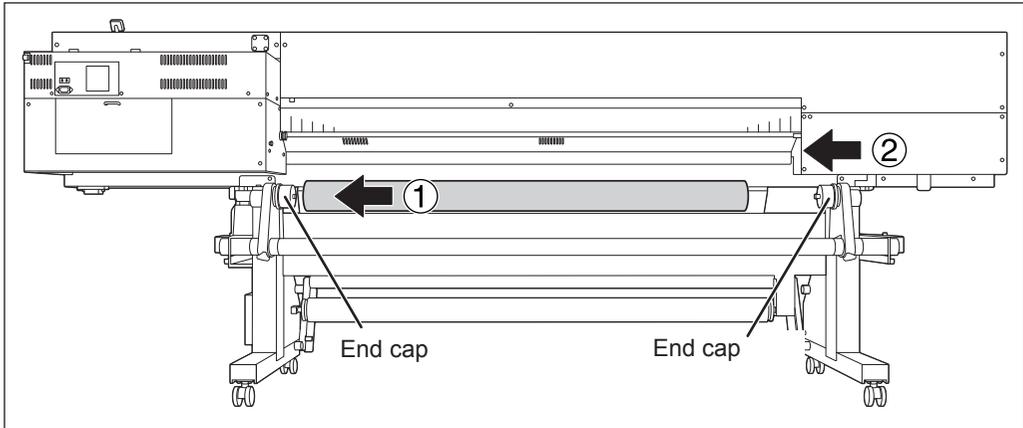
- The machine will not operate if the front cover 2 is not attached.
- Dangerous UV light will escape from the machine if the front cover 2 is not attached.

3 ① **Loosen the media holder retaining screws.**

2 ② **Move the media holders all the way to the left and right.**



- 4**
- ① Fit the paper tube (core) onto the end cap of the media holder [Left].**
Do not secure the media holder now.
 - ② Move the media holder [Right] and fit the media cap onto the paper tube core of the media.**
Fit it securely to prevent the media from easy loose.

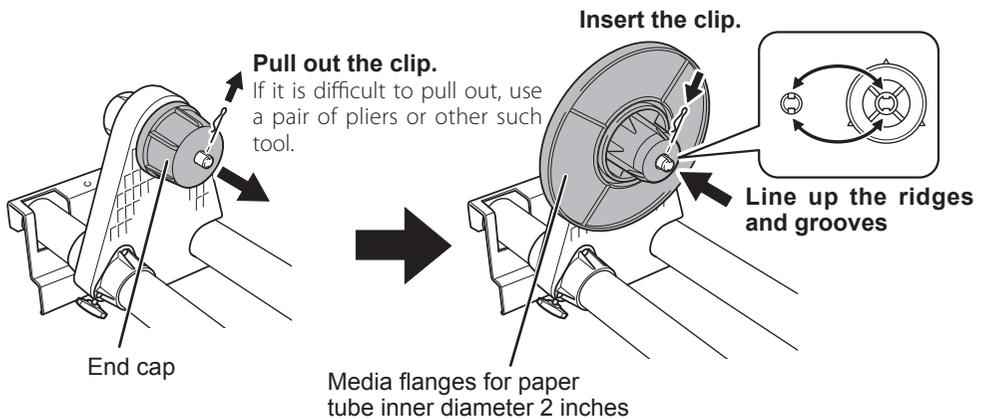


IMPORTANT! Install conforming to the procedures.

Load the media while the left media holder is positioned close to the left edge, as shown in the figure. Also, never secure the media holder in place before loading the media. Loading media without performing these steps in the proper order may make smooth media feed impossible or yield poor printing results.

How to use the media flanges for the paper tube inner diameter 2 inches

* The media flanges for the paper tube inner diameter 2 inches are optional items.



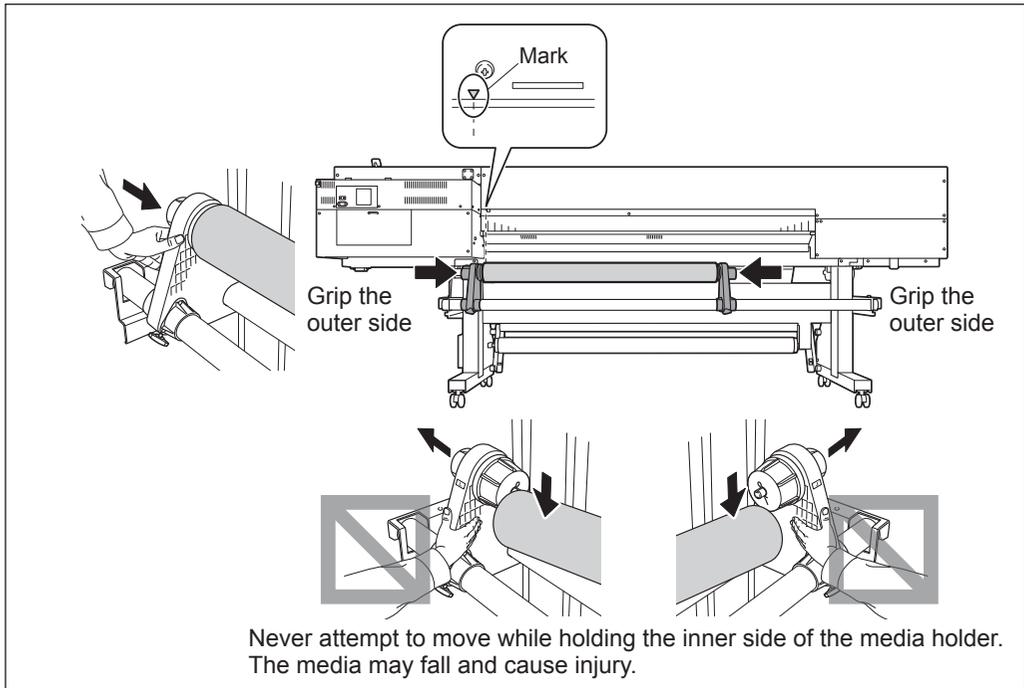
- 5 Grasp the location shown in the figure and align the left edge of the media with the mark.

If the media is moved too far to the right, grasp the right media holder at its outer side and shift it to the left.

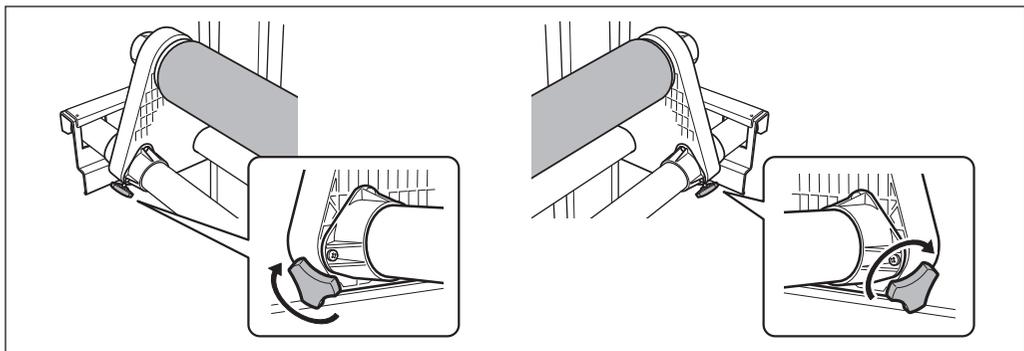
CAUTION

Never attempt this operation while holding any location other than the one specified.

The media may fall from the media holder, resulting in injury.

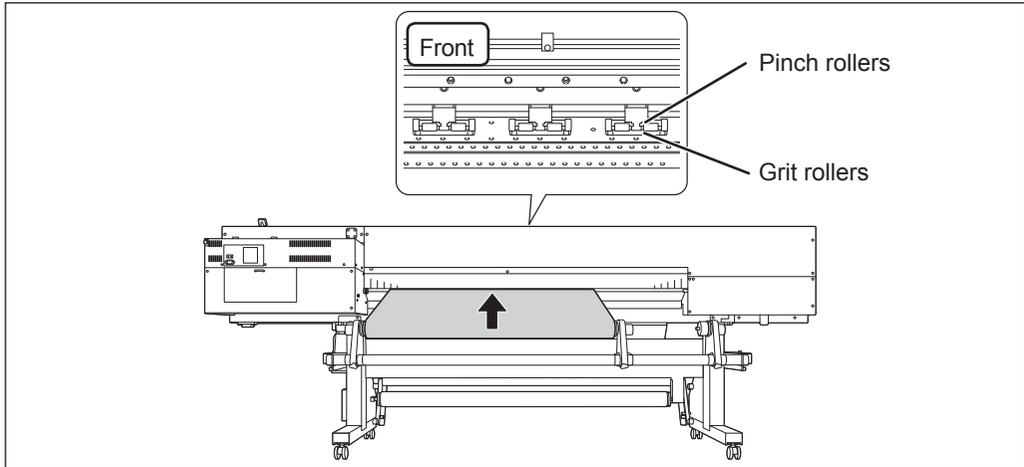


- 6 Secure the media holder by tightening the media holder retaining screws slightly.

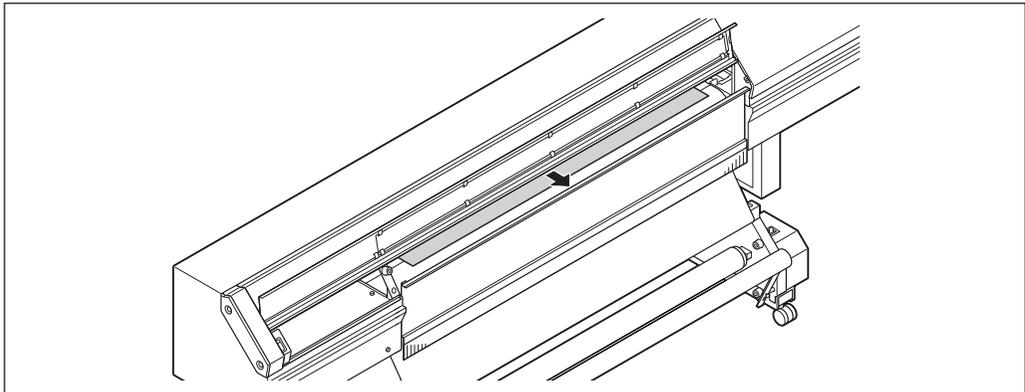


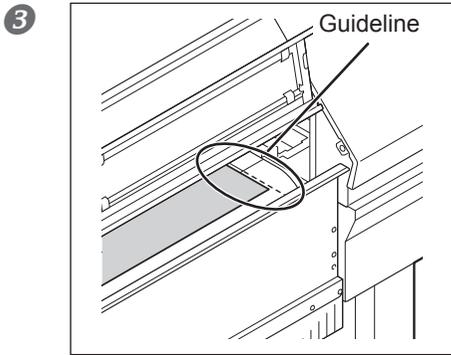
2. Pass the media through the printer and secure the media holders.

- 1 Pass the media between the pinch rollers and the grit rollers.



- 2 Pull out the media over the platen.



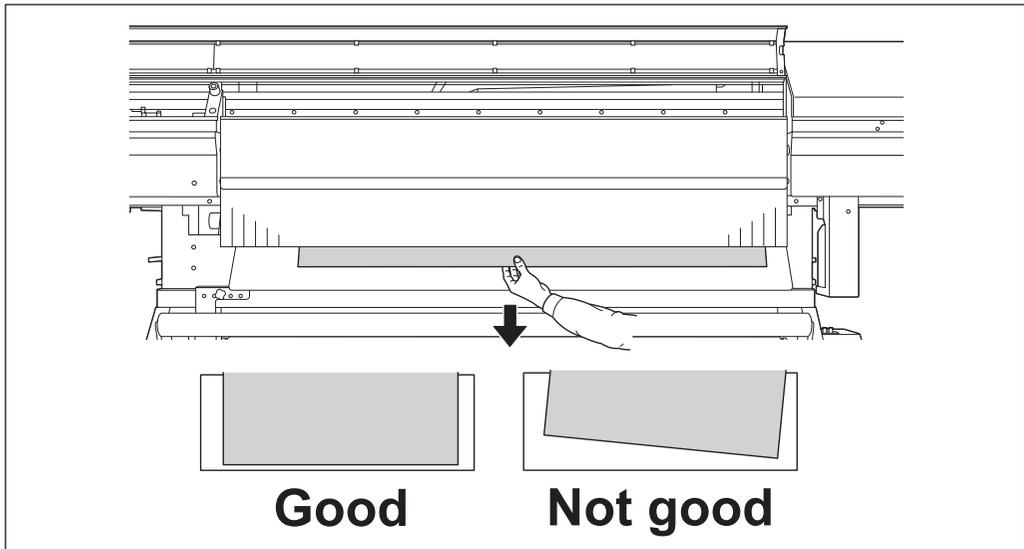


3 Confirm that the right edge of the media is aligned with the guideline.

IMPORTANT!

If you want to readjust the media position at this step, go back to the procedure 1 and redo the procedure 1. - 4. If you hold only the media and forcefully readjust the media, media may be ejected at an angle during printing and print quality may be affected.

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

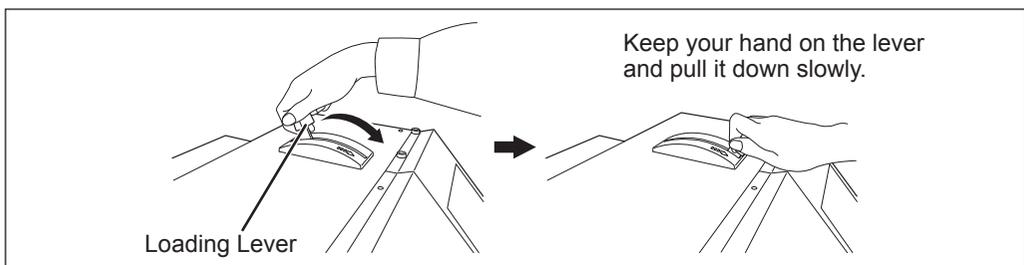


5 Pull back the loading lever.
The media is secured in place.

CAUTION

When pulling down the loading lever, pull the lever down gently and slowly, and keep your hand on the lever until you have pulled the lever down completely until it catches.

If you release the lever before it catches, the lever will fall down quickly and cause injury.



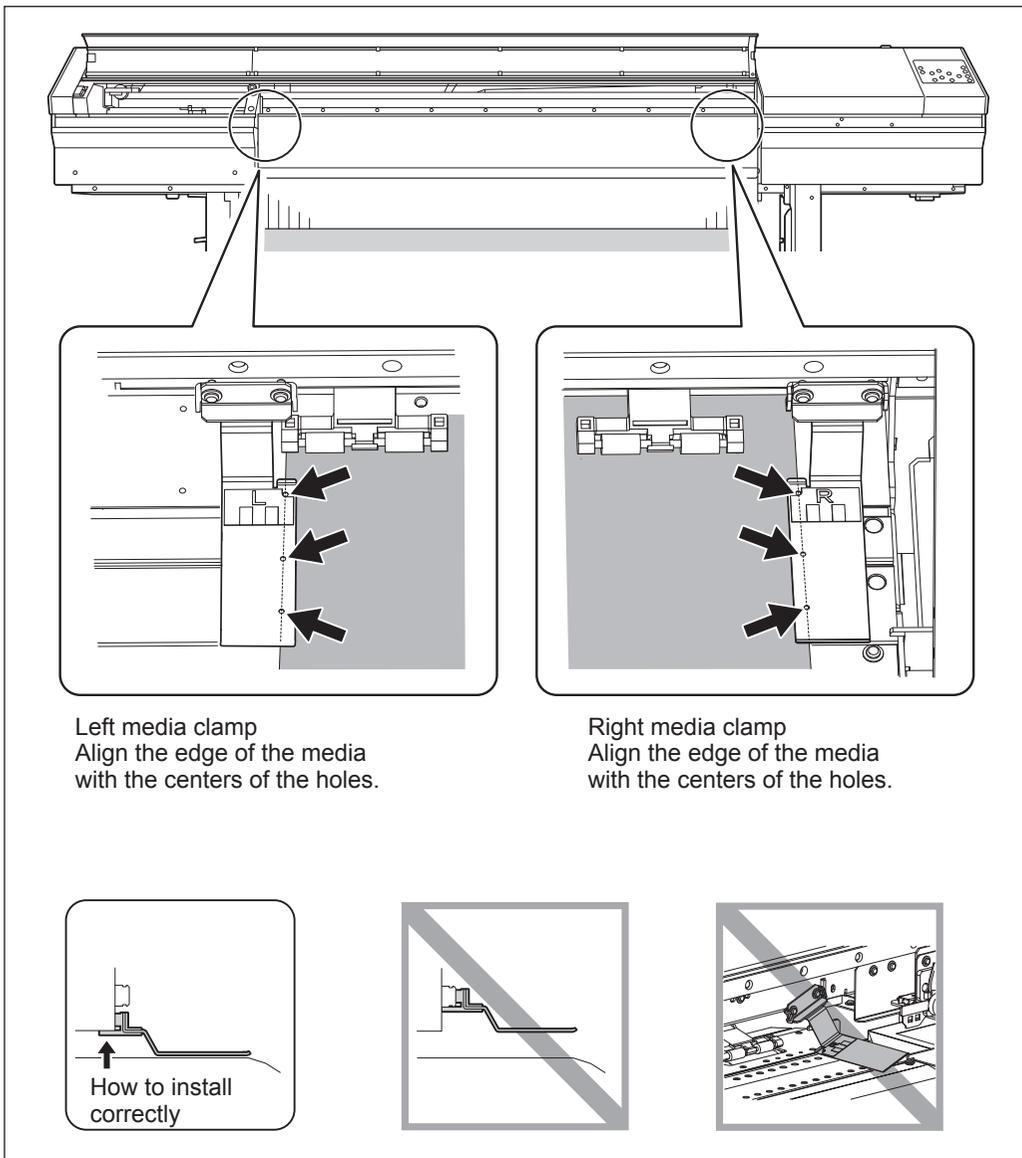
3. Clamp the edges of the media with the media clamp.

Important notice about the media clamp.

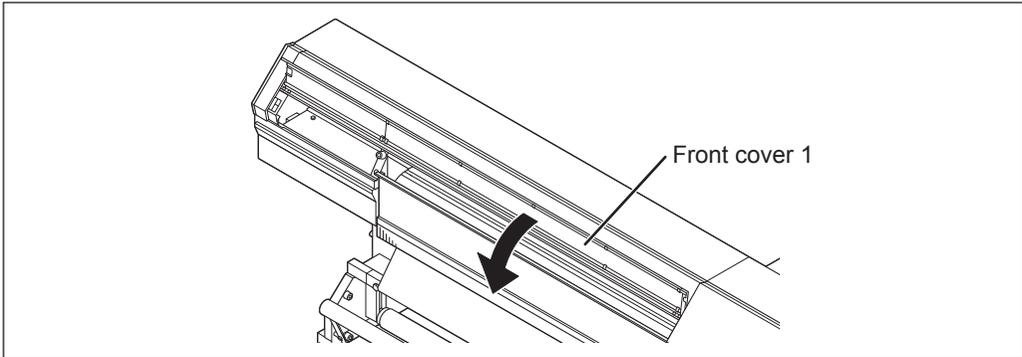
If the thickness of the media is 0.5 millimeters (0.02 inch) or more, leave the media clamps unattached. Otherwise the print heads may strike the media clamps, resulting in malfunction or other problems.

1 Attach the media clamps.

The media clamps are magnetic, and the left and right clamps are distinct. Refer to the figure and install them at the correct positions, taking care not to let the left and right clamps get mixed up.



2 Close the front cover 1.



3 SETUP SHEET
◀▶ ROLL

Press ◀ ▶ to select "ROLL."

4 Press **SET UP**.

SET UP begins flashing and the print-head carriage moves and detects the width of media. This operation is called initialization. When initialization ends **SET UP**, remains steadily lighted, and the printable width is displayed on the display screen. This completes loading of the media.

Continue to "Performing the Initial Adjustment (Correcting for Misalignment in Bidirectional Printing More Precisely)" on page 59.

IMPORTANT! Remove when not using roll media.

If roll media is allowed to stand unused in a loaded state for an extended period, the media may sag. This can cause poor printing quality and motor errors, so be sure to remove and store such media when not in use.

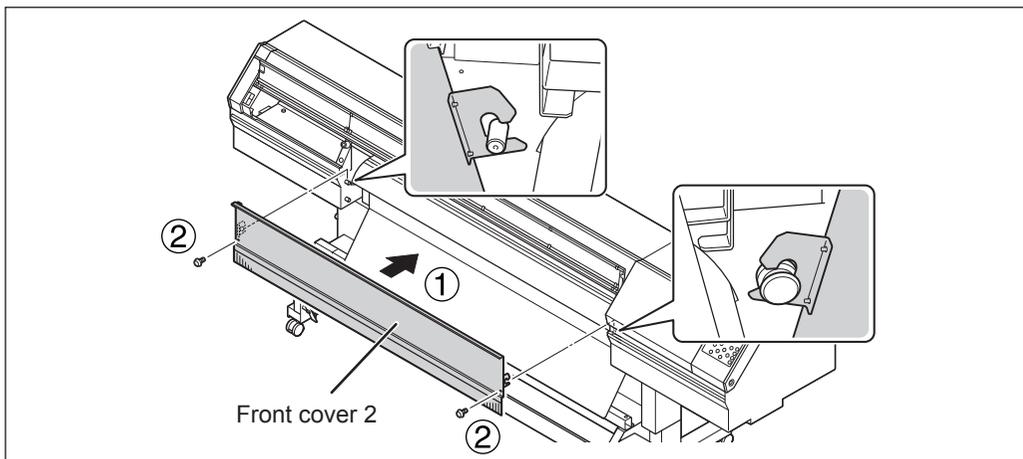
Loading Sheet Media

Use the following procedure to load standard-sized sheet media.

***Before loading sheet media, remove the media hold down unit and the rigid media tables.**

Procedure

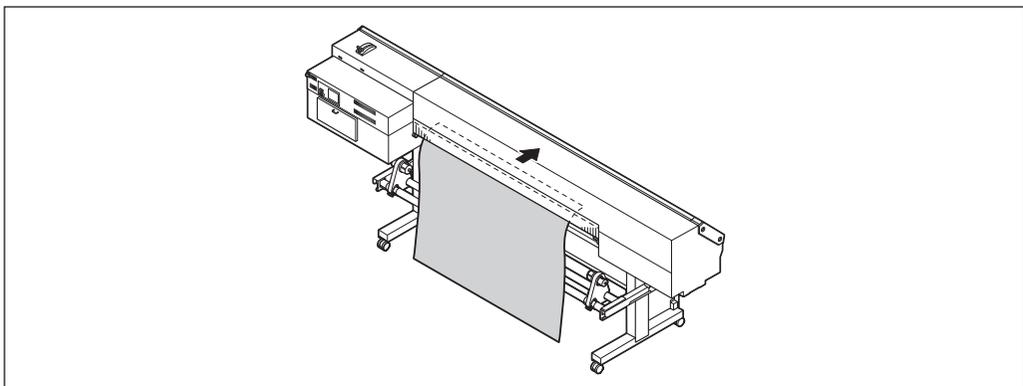
- 1 **Open the front cover 1.**
- 2 **1 Attach the front cover 2.**
If the front cover 2 is already attached, proceed to step 3.
2 Tighten the retaining screws.
Make sure you secure the front cover 2 with the retaining screws.



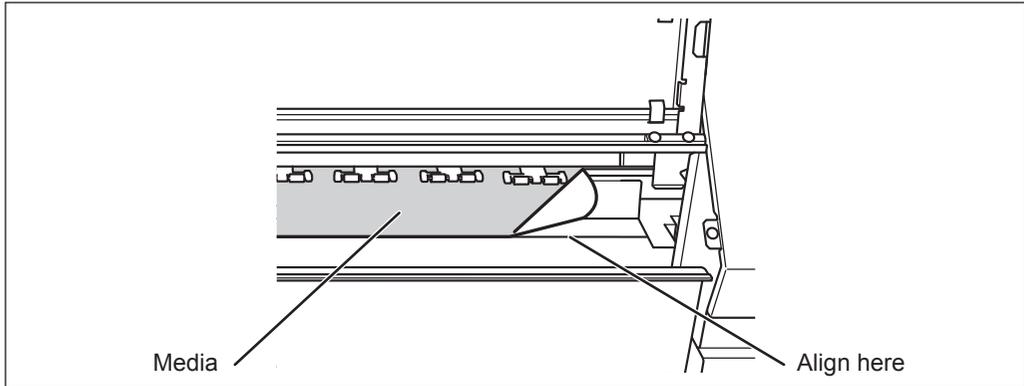
IMPORTANT! Make sure you attach the front cover 2.

- The machine will not operate if the front cover 2 is not attached.
- Dangerous UV light will escape from the machine if the front cover 2 is not attached.

- 3 **Pass the sheet media through the machine.**



- 4 Align the front edge of the media with the location shown in the figure.



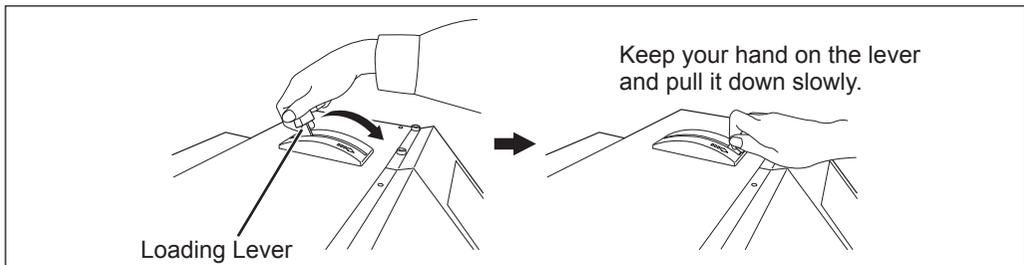
- 5 Pull back the loading lever.

The media is secured in place.

CAUTION

When pulling down the loading lever, pull the lever down gently and slowly, and keep your hand on the lever until you have pulled the lever down completely until it catches.

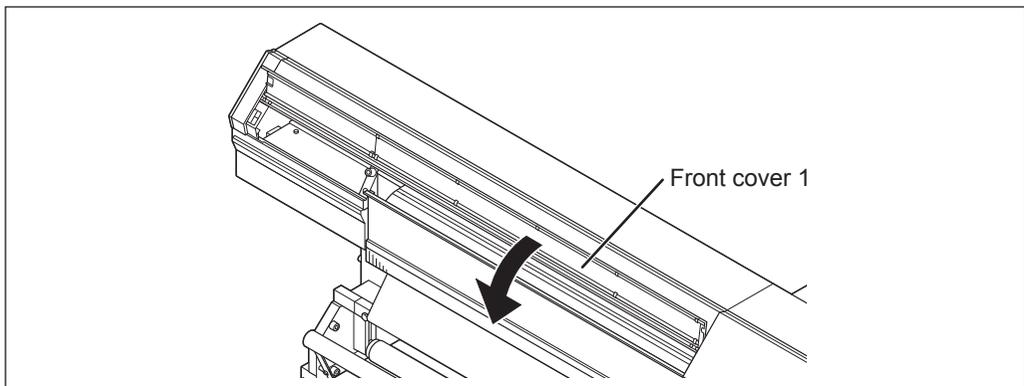
If you release the lever before it catches, the lever will fall down quickly and cause injury.



- 6 Attach the media clamps.

☞ P. 39, "Loading Roll Media" Procedure 3.

- 7 Close the front cover 1.



8  Press Key   to select "ROLL."

9 Press  .
 starts to flash. When initialization ends,  remains steadily lighted, and the printable width is displayed.

Continue to "Performing the Initial Adjustment (Correcting for Misalignment in Bidirectional Printing More Precisely)" on page 59.

Loading Rigid Media

Use the following procedure to load rigid media.

1. Attach the rigid media tables.

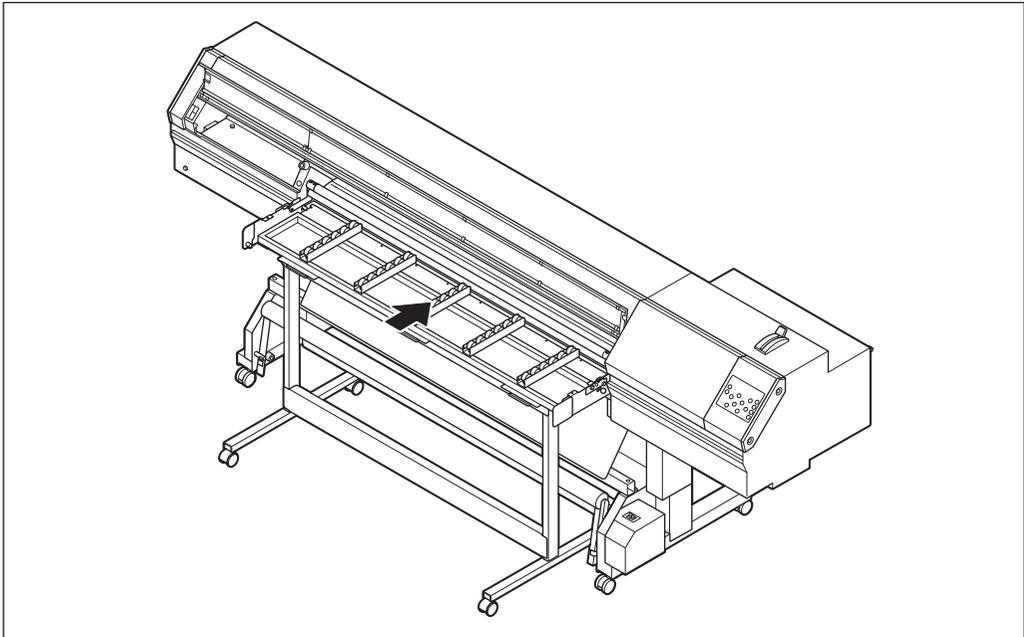
1 **Open the front cover 1.**

If the front cover 2 is attached, remove it.

2 **Attach the media hold down unit.**

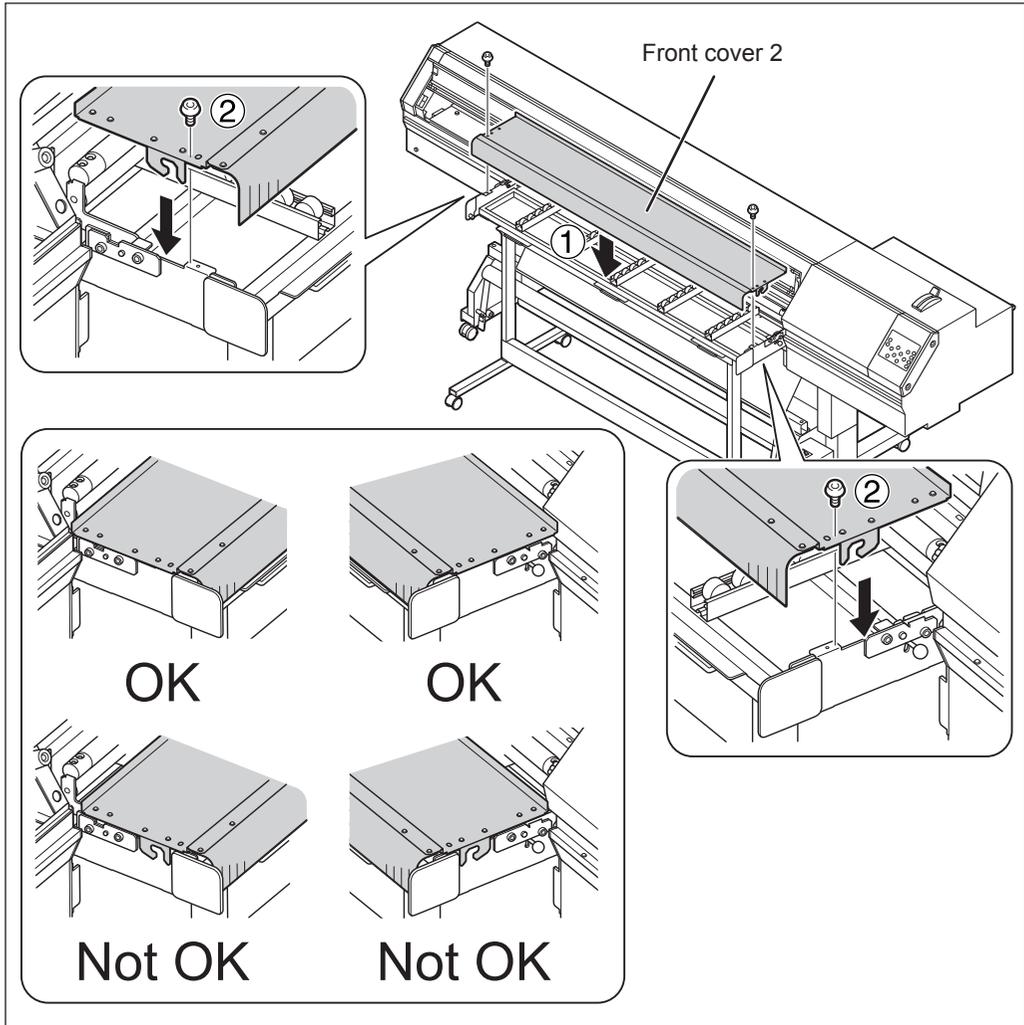
Refer to the Setup Guide for more information.

For assembly instructions, refer to "MB-640 ASSEMBLY INSTRUCTIONS."



- 3 ① Attach the front cover 2 to the media hold down unit.
 ② Tighten the retaining screws.

Make sure you secure the front cover 2 with the retaining screws.



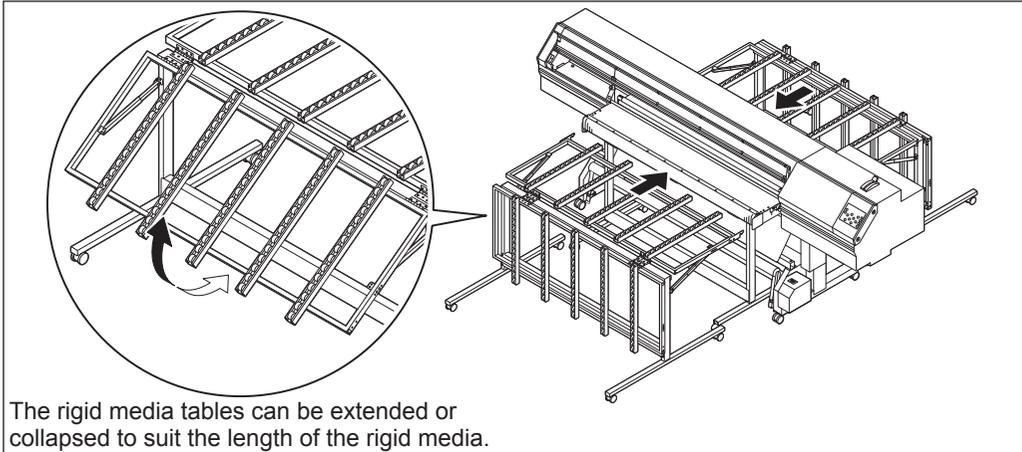
IMPORTANT! Make sure you attach the front cover 2.

- The machine will not operate if the front cover 2 is not attached.
- Dangerous UV light will escape from the machine if the front cover 2 is not attached.

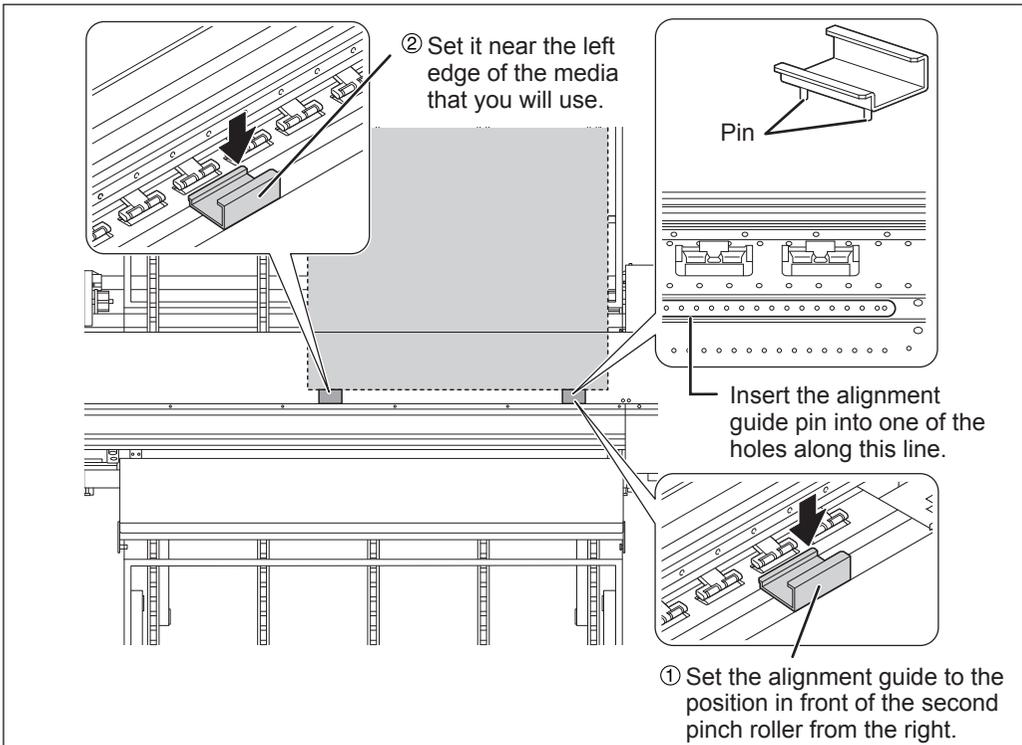
4 Attach the rigid media tables.

Refer to the Setup Guide for more information.

For assembly instructions, refer to "RU-640 ASSEMBLY INSTRUCTIONS."



5 **① Set the right edge alignment guide.**
② Set the left edge alignment guide.

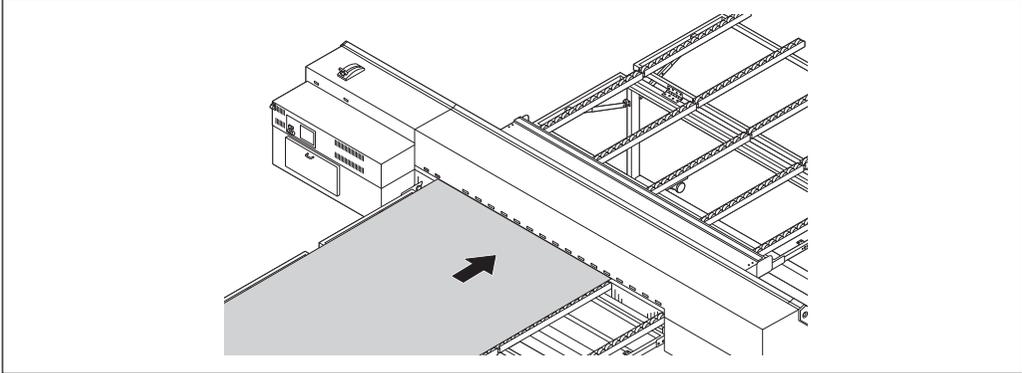


IMPORTANT!

Do not attach the media clamps.

2. Attach the rigid media.

- 1 Pass the rigid media through the machine.

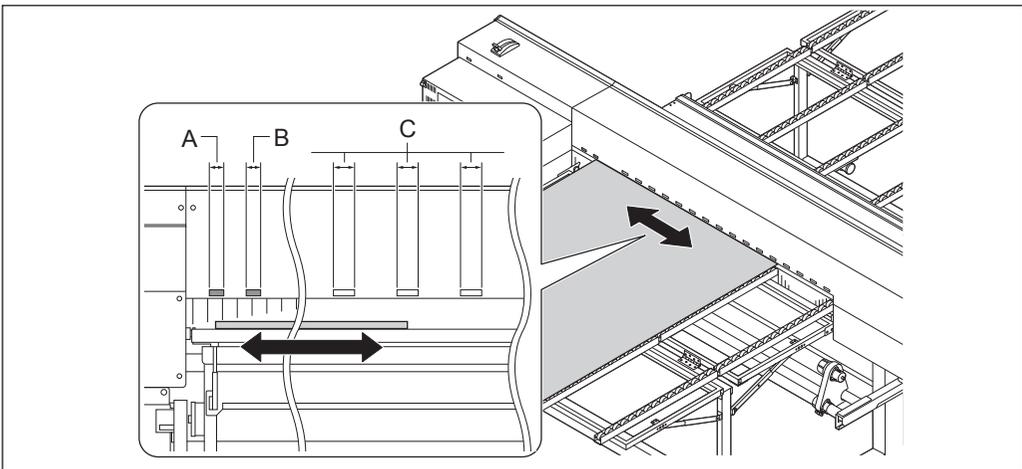


POINT!

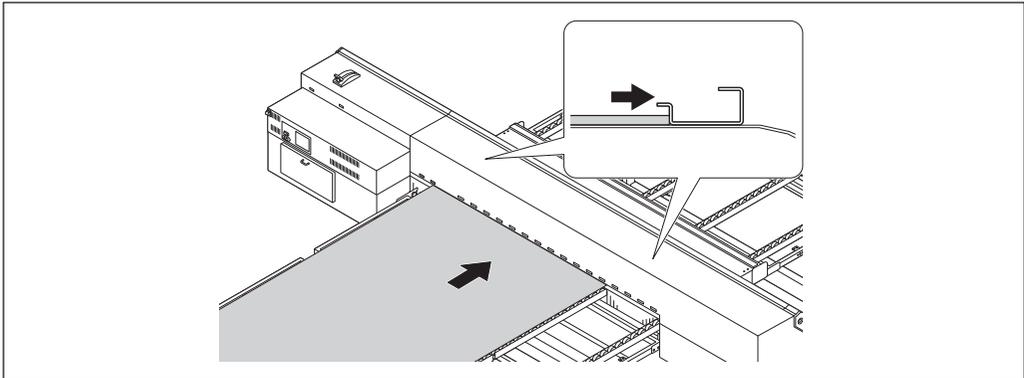
When a protective sheet is attached to the reverse side of the media, load the media without peeling off the protective sheet so that the media will pass through the machine smoothly.

- 2 Align the left and right position of the media.

Adjust the position of the media so that the right edge is positioned within one of the areas marked "C", and so that the left edge is positioned within either area "A" or area "B".



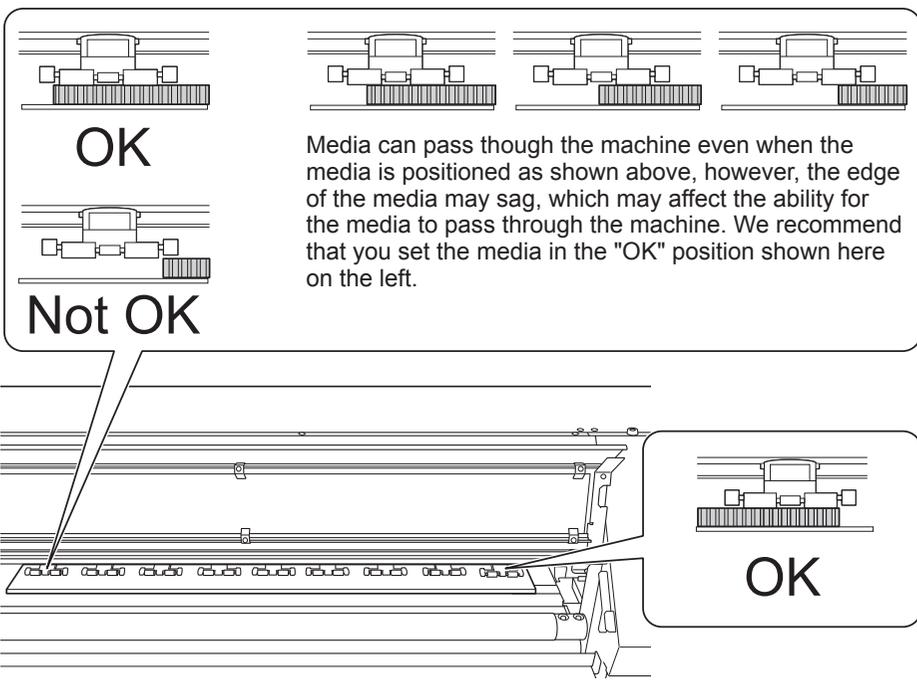
3 Push the rigid media up to the alignment guide.



IMPORTANT!

Make sure that the pinch rollers are positioned correctly on top of the media.

If the pinch rollers are not positioned correctly on top of the media, adjust the media to the left or right.



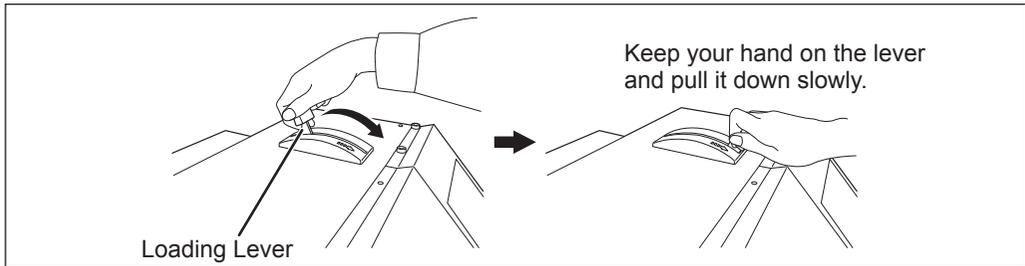
4 Pull back the loading lever.

The media is secured in place.

⚠ CAUTION

When pulling down the loading lever, pull the lever down gently and slowly, and keep your hand on the lever until you have pulled the lever down completely until it catches.

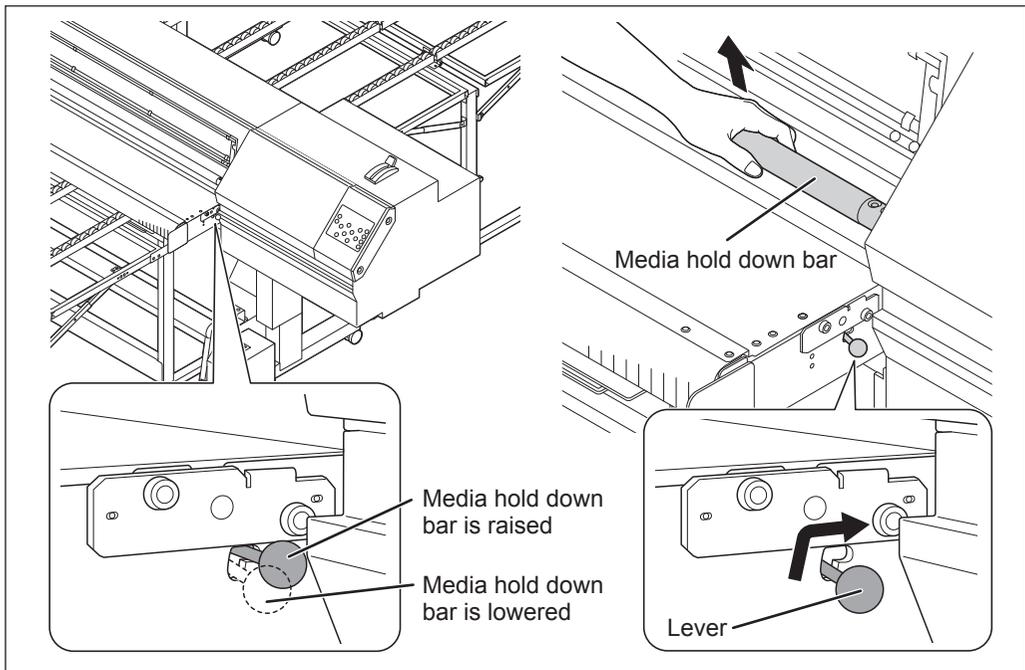
If you release the lever before it catches, the lever will fall down quickly and cause injury.



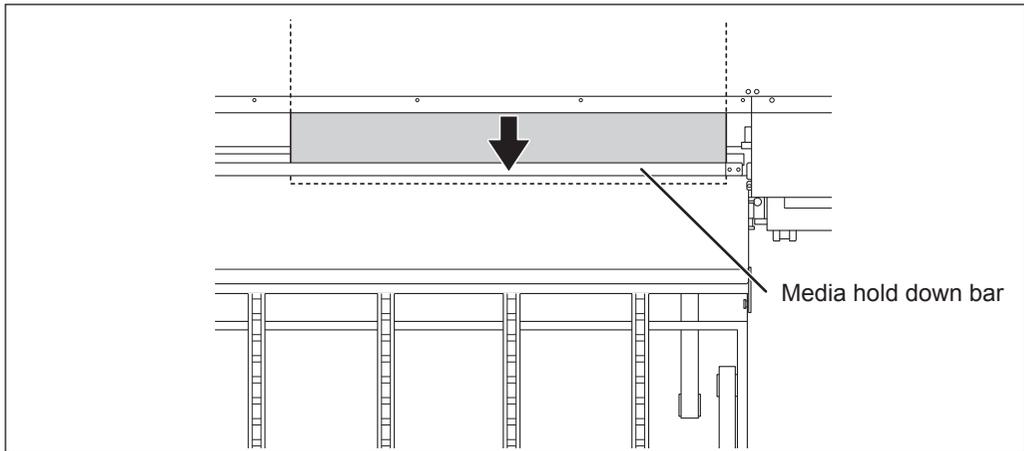
5 Remove the alignment guides.

6 Make sure that the media hold down bar is raised.

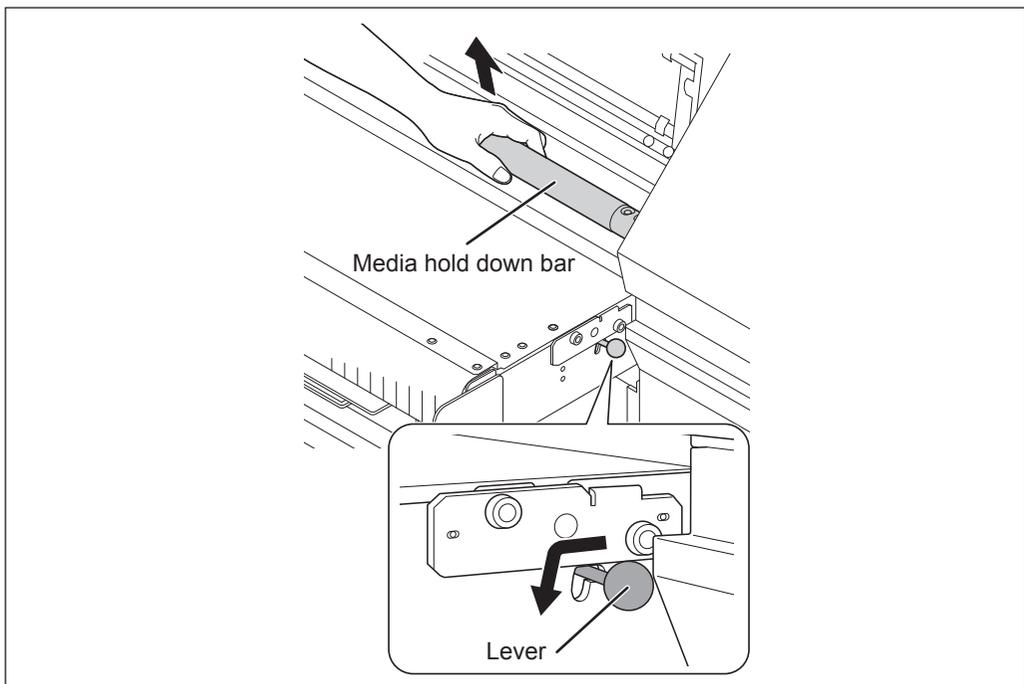
If the media hold down bar is lowered, hold the upper part of the media hold down bar and move the lever up.



- 7 Press  and feed the media until it is under the media hold down bar.



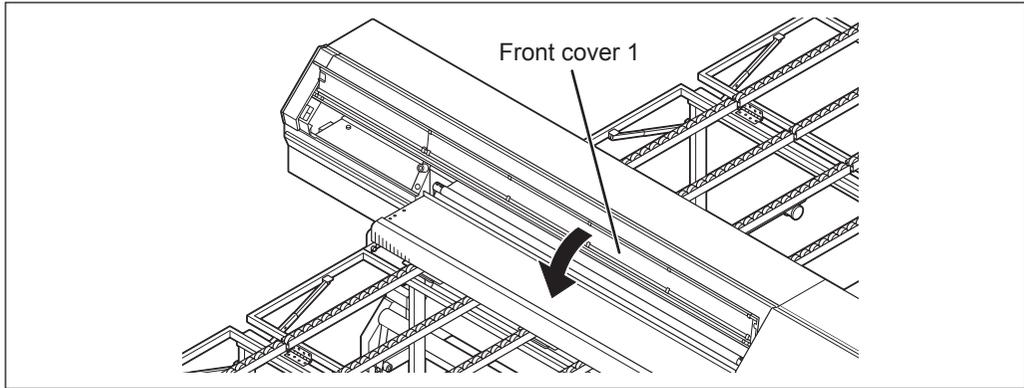
- 8 Lower the media hold down bar.
Hold the upper part of the media hold down bar and move the lever down.



IMPORTANT!

When using rigid media, make sure to use the media hold down bar whenever you are adjusting or printing.
If you make any adjustments or if you print without using the media hold down bar, print quality may be affected.

9 Close the front cover 1.



3. Enter the thickness of the rigid media.

1 SETUP SHEET
 ◀ RIGID L 99.9m

Press ◀ ▶ to select "RIGID."
 Press SET UP .

2 THICKNESS
 6.5mm ↵

Press ▲ ▼ to enter the thickness of the rigid media.

The value that was entered previously is displayed. Thickness can be set from 0.0 to 13.0 mm (0.000 to 0.5 inches). The value changes in 0.1 mm (0.005 inch) increments when ▲ is pressed, and in 1 mm (0.01 inch) increments when ▼ is pressed, and in 1 mm (0.01 inch) increments when ▲ ▼ is pressed and held.

IMPORTANT! Measure the thickness accurately and enter the thickness. Print quality will be affected if the correct value is not entered.

3 Press **ENTER**.

If the print heads do not make contact with the media, automatic detection begins and **SET UP** flashes.

Automatic Detection OK

When initialization has finished, **SET UP** lights up and the printable width is displayed.

Continue to "Performing the Initial Adjustment (Correcting for Misalignment in Bidirectional Printing More Precisely)" on page 59.

Automatic Detection NG

A warning beep sounds and an error message is displayed.

Cause of NG 1: Thickness not entered correctly.

Return to step **1**.

Cause of NG 2: Media is severely warped.

The media may be so warped that the media hold down bar cannot hold the media down. Return to step **2** and enter a thickness value that is slightly higher than the actual thickness. Adjust the value to the lowest value it can be without the warning beep sounding. Then, use Roland VersaWorks Dual (hereafter "VersaWorks Dual") to set unidirectional printing. Details are described in "Configuring Unidirectional Printing (Roland VersaWorks Dual)".

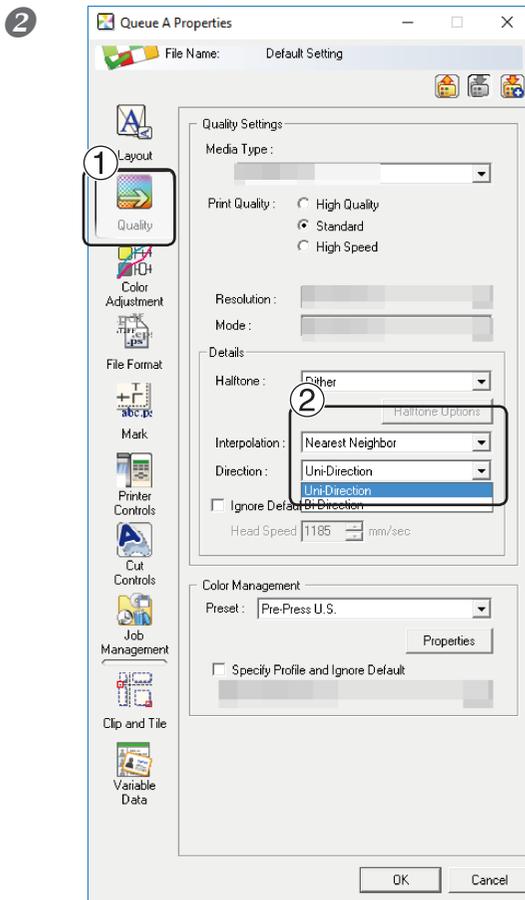
- * If the difference between the actual thickness and the entered thickness value is too high, colors may be inconsistent even if unidirectional printing is set. In that case, make sure to use media that is not warped.

Configuring Unidirectional Printing (VersaWorks Dual)

* For details about VersaWorks Dual, refer to the VersaWorks Dual instruction manual.

Procedure

- 1 Open the "Que Properties" window (or the "Job Setting" window)
Select the input folder to be used.



- 1 Click 
- 2 Select "Uni-Direction" from [Direction] under "Details".

"Que Properties" window

(The setting item and the method in "Job Setting" window are the same as this procedure.)

Proceed to "Performing the Initial Adjustment (Correcting for Misalignment in Bidirectional Printing More Precisely)".

Performing the Initial Adjustment (Correcting for Misalignment in Bidirectional Printing More Precisely)

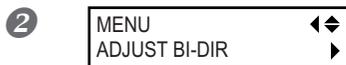
Perform the initial adjustment (correction for misalignment in bidirectional printing more precisely) of this machine. This adjustment is necessary in the following cases. When changing the print-head height, change the height before performing this adjustment.

☞ P. 122, "Adjusting the Print-Head Height to Match Media Thickness"

- **When using this machine for the first time**
- **When changing the media to use**
- **When further correction is required to improve printing, such as when simple correction is performed for misalignment in bidirectional printing.** ☞ P. 119, "Correcting for Misalignment in Bidirectional Printing"

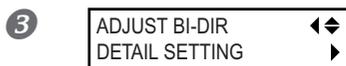
1. Output a test pattern.

1 Press **MENU**.



Press **▼** several times until the screen shown on the left appears.

Press **▶** and then **▲**.



Press **▶**.



Press **ENTER**.

A test pattern is output.

When printing ends, press **MENU** and then **◀**.

5 Remove the front cover 2.

6 Press **▼** and feed the media forward to a position where you can clearly see the condition of the test print.

This operation is not necessary when using roll media or sheet media. Proceed to step 7.



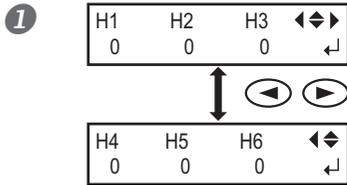
Repeat steps 1 to 3 until the screen shown on the left appears.

Press **▼**.



Press **▶**.

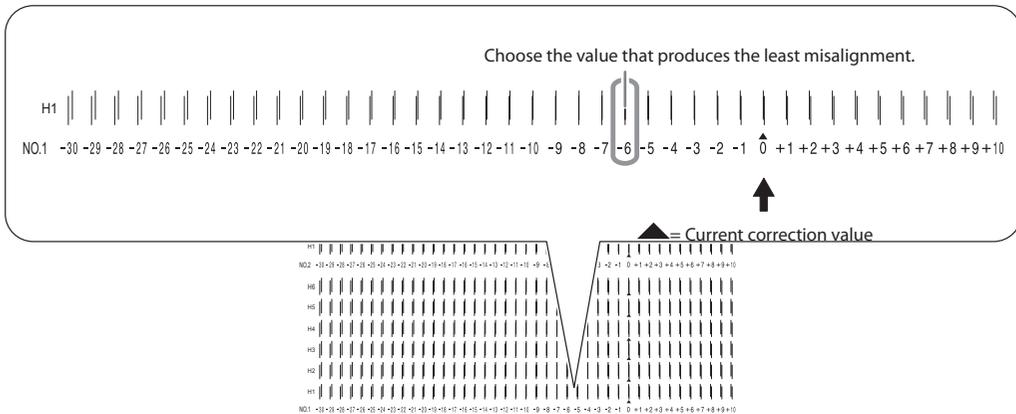
2. Enter the adjustment value.



Press to select one from H1 to H6.
 Press to decide a correction value for the selected item from H1 to H6.
 Press to finish making the settings for [SETTING NO.1].

To decide a Correction Value

Choose the value that produces the least misalignment of 2 lines. When wavering between two numbers, select half value.



If the Printing-test Results Are Difficult to Interpret

Examine the results from different angles in a well-lighted location. Take advantage of reflected light to enable visual checking.

If you cannot see "H5" or "H6" (such as when using white media with no shine)

You may not be able to see "H5" or "H6" when using certain media, such as white media with no luster. In this case, set "H5" and "H6" to the same value as "H4" ("H2" for the LEC-300/300A).



Press .



In the same manner as performed for [SETTING NO.1], repeat steps 1 to 2 to set the correction values for [SETTING NO.2] to [SETTING NO.8].

4 Attach the front cover 2.

When using rigid media, press and pull back the media to the appropriate position.



Press in this order to go back to the original screen.

Setup of Media

About [MEDIA SETTING] menu

To ensure the optimal output according to the media size and type, various setting items are provided in this machine. However, it is hard work to perform these settings one by one referring to this document. So, this machine provides the [MEDIA SETTING] menu that guides these settings in the interactive mode. Using this menu, you can set all of the basic settings only by setting according to the instructions on the display. Since the setting details can be stored as the preset menu, you can promote your operation efficiently saving the setup steps when using the same type of media. Once storing the basic settings as the preset, you can do fine adjustment according to need. The items set through the [MEDIA SETTING] menu can be also set individually.

Setup of Media ([MEDIA SETTING] menu)

Note: If any setting is not needed for each setting item, you can go to the next menu by selecting [NEXT].

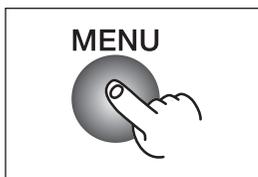
1. Starting the [MEDIA SETTING] menu.

1 Load media.

Check that no sagging is found on the media. If any sagging exists, the followed correction value settings do not work effectively.

- ☞ P. 39, "Loading Roll Media"
- ☞ P. 47, "Loading Sheet Media"
- ☞ P. 49, "Loading Rigid Media"

2



Press **MENU**.

3



When the left figure is displayed, press **ENTER**.

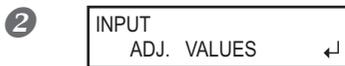
2. Perform the position correction of feed direction (Alleviate Horizontal Stripes).

POINT!

Feed direction means the feed direction of the media. Perform the correction adjusting to the media in advance because horizontal stripes are more likely to occur during printing when the movement distance of the media changes subtly depending on the kind or thickness of the media.



Press **◀** to select [SET].
 Press **ENTER** to enable the setting.
 The test pattern of feed correction is output.



When the left figure is displayed, press **ENTER**.

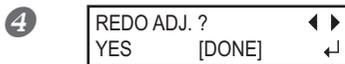
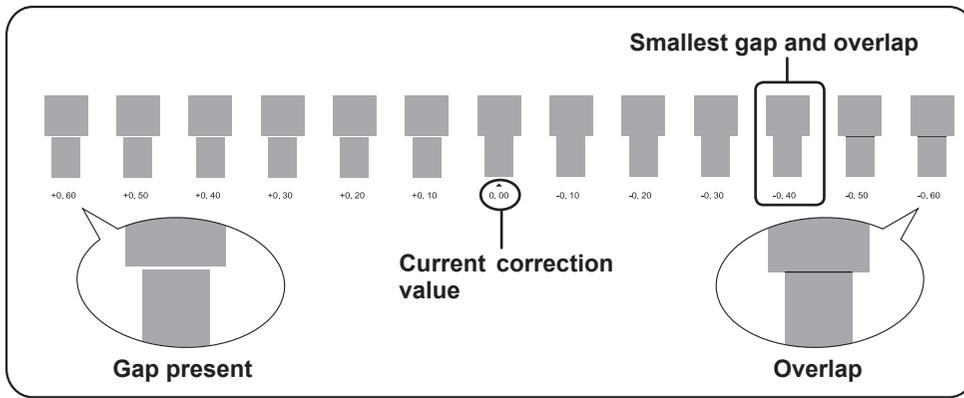


Use **▲** **▼** to set the correction value.
 Press **ENTER** to enable the setting.

Current correction value Value to be set value

To decide a Correction Value

Select the value to make the upper/lower rectangular gap and overlap smallest.



[To confirm again / adjust again]
 Press **◀** to select [YES].
 Press **ENTER** to enable the setting.
 The test pattern of feed correction is output again. Go back to the procedure 3 and set again.

[To go to the next after correction is completed]
 Press **▶** to select [DONE].
 Press **ENTER** to enable the setting.

For the individual setting method of this setting item and the description, refer to page 120 "Alleviating Horizontal Bands and the Like (feed correction function)."

To cancel the setting**Procedure**

1 Press **MENU** during the setting.

2

QUIT SETTING?	◀ ▶
[YES] NO	↵

Press **◀** to select [YES].
Press **ENTER**.

W XXXmm

The screen returns to the screen shown at the left.
By selecting [NO], the screen returns to the screen displayed when you pressed **MENU**.

3. Performing the correction for misalignment in bidirectional printing

POINT!

This machine prints by the bidirectional mode (in which the print heads perform printing during both their outbound pass and return pass). This printing method is called "Bidirectional Printing." This method offers the advantage of being able to shorten output times, but subtle misalignment occurs during the outbound and return passes. The procedure to correct this and eliminate misalignment is "Bidirectional Correction."

1

ADJUST BI-DIR	◀ ▶
[SET] NEXT	↵

Press **◀** to select [SET].
Press **ENTER** to enable the setting.

The test pattern of bidirectional correction is output.

2

INPUT	↵
ADJ. VALUES	↵

When the left figure is displayed, press **ENTER**.

3

ADJUST BI-DIR	▲ ▼
0 ▶ -6	↵

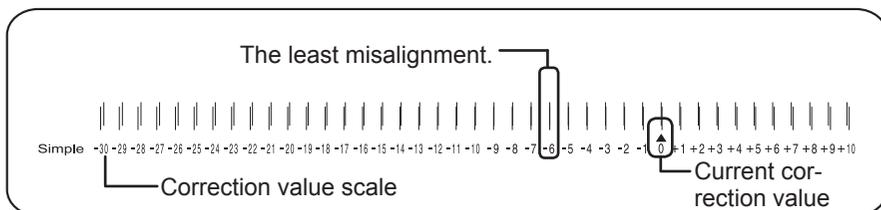
Use **▲** **▼** to set the correction value.
Press **ENTER** to enable the setting.

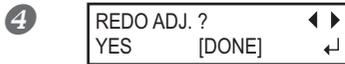
Current correction value

Value to be set

To decide a Correction Value

Choose the value that produces the least misalignment of 2lines.





[To confirm again / adjust again]

Press to select [YES].

Press to enable the setting.

The test pattern of bidirectional correction is output again. Go back to the procedure ③ and set again.

[To go to the next after correction is completed]

Press to select [DONE].

Press to enable the setting.

For the individual setting method of this setting item and the description, refer to page 119 "Correcting for Misalignment in Bidirectional Printing."

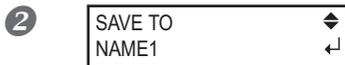
4. Saving the setting as preset



Press to select [SAVE].

Press to enable the setting.

If you select [NEXT], the performed settings are retained. However, those settings are not saved as presets.



Use to select the destination to save.

You can select one of NAME1 to 8.

Press to enable the setting.



Use to select characters.

Use to move the next character.

Select the following characters in the same way.

You can enter up to 15 characters.

Press to enable the setting.



For the individual setting method of this setting item and the description, refer to page 116 "Fully Utilizing Preset Function."

This completes the operation of the [MEDIA SETTING] menu.



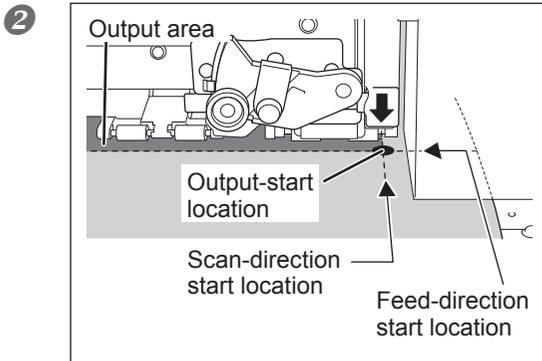
Setting the Output-start Location

You can set the output-start location at any location you prefer. (You can output if you do not set this.) Note, however, that this setting must be made for each individual page because the setting returns to the default position when output is completed for each page.*

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

Procedure

1 Open the front cover 1.



Press to move the point of the arrow to the position where output begins, as shown in the figure on the left.

3 When the location is set, press .



lights up, and setting is complete when the width that can be output at that location is displayed, as shown in the figure on the left.

Never use in the following cases.

➤ When you use the media take-up system.

The media may be pulled forcibly and result in errors or malfunctions.

➤ Before or after the feed correction is made

Slackness in the roll media can make it impossible to obtain reliable correction results. Also, slackness in the roll media after feed correction may cause slippage in the media's movement distance during printing, resulting in horizontal stripes.

☞ P. 120, "Alleviating Horizontal Bands and the Like (feed correction function)"

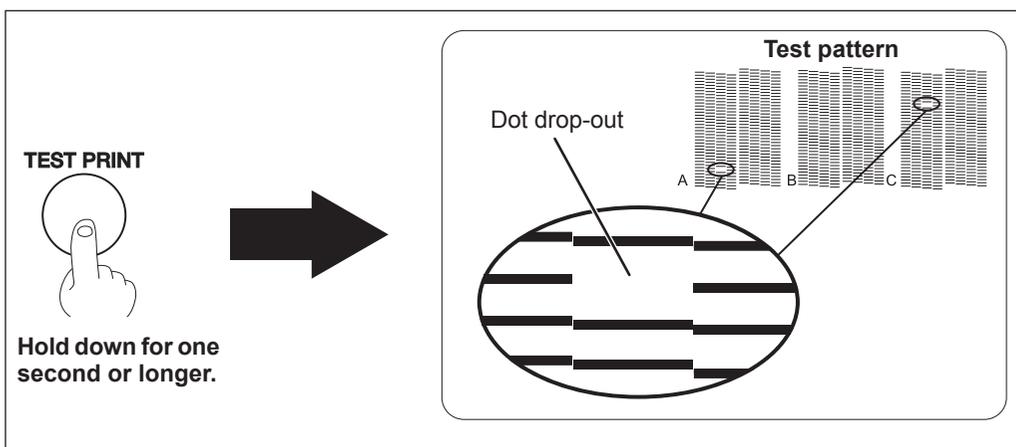
Printing Tests and Normal Cleaning

Before you carry out actual printing, we recommend performing a printing test to ensure no dot drop-out occurs. If dot drop-out occurs, perform cleaning of the print heads (Normal Cleaning).

How to Perform a Printing Test

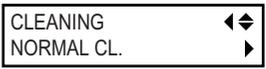
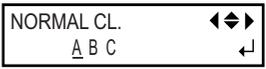
Procedure

- 1 **Setting the Output-start Location**
☞ P. 66, "Setting the Output-start Location"
- 2 **Holding down TEST PRINT for one second or longer.**
 A test pattern is printed.



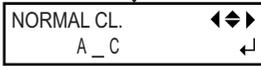
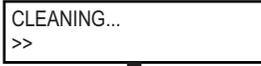
How to Perform a Normal Cleaning

Procedure

- 1 **Press CLEANING.**
- 2  **Press ▶.**
- 3  **Press ◀ ▶ to choose the group of print heads that is not to be cleaned.**
Press ▲ ▼ to get rid of the group display.
Repeat this procedure to display the groups of only the print heads that require cleaning.
 Of groups A through C, cleaning is performed only for the group displayed.



Press **ENTER**.
Normal cleaning starts.



When it finishes, the screen shown in the figure appears again.



Press **MENU** **◀** in this order to go back to the original screen.

6 Perform a printing test again to make sure the dot drop-out has been corrected.

If the problem persists, try performing cleaning a second time. If the printer has been used for a long period, the problem may persist even after two or three-cycle cleaning. Then try cleaning using a different method.

☞ P. 95, "When Normal Cleaning Is Not Effective"

If the printing-test results are difficult to interpret

Examine the results from different angles in a well-lighted location. Take advantage of reflected light to enable visual checking.

If you want to perform normal cleaning with all the print heads.

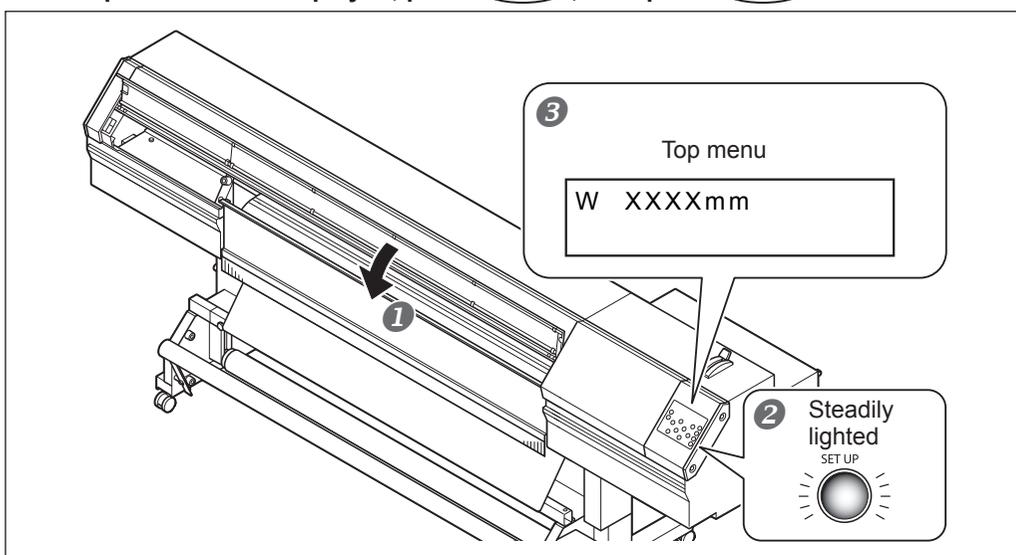
Hold down **CLEANING** for one second or longer. The normal cleaning for all the print heads starts.

Getting Ready to Receive Data from a Computer

When P. 39, "Loading Media" and P. 61, "Setup of Media" are completed, get ready to receive the data from a computer.

Procedure

- 1 Close the front cover 1.
- 2 Make sure **SET UP** stays steadily lit.
If the light does not come on, press **SET UP**.
- 3 Make sure the top menu is displayed.
If the top menu is not displayed, press **MENU**, then press **◀**.



POINT! Output is not possible in these situations.

- The machine does not run when the front cover 1 is open.
- The machine will not operate if the front cover 2 is not attached.
- Do not open the front cover 1 or remove the front cover 2 during output. Doing so interrupts output.
- Data from the computer is not accepted when **SET UP** is dark.
- Data from the computer is not accepted when you are not at the top menu.

Starting Output

When the operation of page 69 "Getting Ready to Receive Data from a Computer" is completed, you can start output. To output, the following procedure is required.

① Creating Output Data

Create the output data using the application software like Adobe Illustrator and like that. For information on how to create the data, refer to the documentation of your application software.

② Sending the Output Data to This Machine Using the Software RIP.

Use the included software RIP "Roland VersaWorks Dual." For information on how to install and use VersaWorks Dual, refer to "Roland VersaWorks Dual Installation Guide" and HELP of Roland VersaWorks Dual. If using the white ink and gloss ink, refer to "Special Color Ink (or Special Color Ink & Primer Guide)."

IMPORTANT! Points that must be observed

- Use the media clamps when using media that is less than 0.5 mm (0.02 inches) thick. Otherwise the edges of the media may warp and catch on the print heads.
- If you are using media that is less than 0.5 mm (0.02 inches) thick, do not use the media clamps if [HEAD HEIGHT] is set to [LOW]. The media clamps may catch on the print heads, damaging the machine.
 - ☞ P. 122, "Adjusting the Print-Head Height to Match Media Thickness"
- During output, never touch the media. Doing so may obstruct media feed or cause the media to rub against the print heads, which may result in a paper jam or damage to the print heads.
- Keep the loading lever raised when the machine is not in use.

POINT!

If ink runs out

When ink runs out, a warning beep sounds and a slot number of which ink runs out is displayed on the display screen.

☞ P. 87, "How to Replace Ink Cartridges"

Before you perform lengthy printing, check the amount of ink remaining in the ink cartridges.

Before you perform lengthy printing, check the amount of ink remaining in the ink cartridges. When ink runs out and printing is paused, the coloring at the seam may be altered when printing resumes.

☞ P. 86, "Checking for Remaining Ink"

When performing output involving pullback movement, make sure to wipe away any grime from the pinch rollers.

If the pinch rollers are dirty when performing output involving pullback movement, an imprint from the pinch rollers may be left behind.

Pausing and Canceling Output

You can pause and cancel output before it finishes. However, a horizontal stripe is produced at the location where output was stopped. We do not recommend resuming output.

Procedure

- 1 Press **PAUSE** before output finishes.

This pauses the output operation.

- 2 Press **PAUSE** again to resume output.

To cancel the output, go the next Procedure without pressing **PAUSE**.

- 3

TO CANCEL, HOLD
DOWN SETUP KEY

When the screen shown in the figure appears, hold down **SET UP** for one second or longer.

This cancels the output operation.

- 4 Stop sending the output data from the computer.

Cutting Off the Media

* When "SETUP SHEET" is set to "RIGID," media cannot be cutoff.

IMPORTANT!

Some media may be thick or may be composed of plastic or other hard material. For such media, never perform cutoff using **SHEET CUT**. Doing so may cause malfunction or other problems.

Procedure

- 1 Close the front cover 1.

- 2

REMOVE
MEDIA CLAMPS

Confirm that **SET UP** is lit up, and then press and hold **SHEET CUT** for about 1 second.

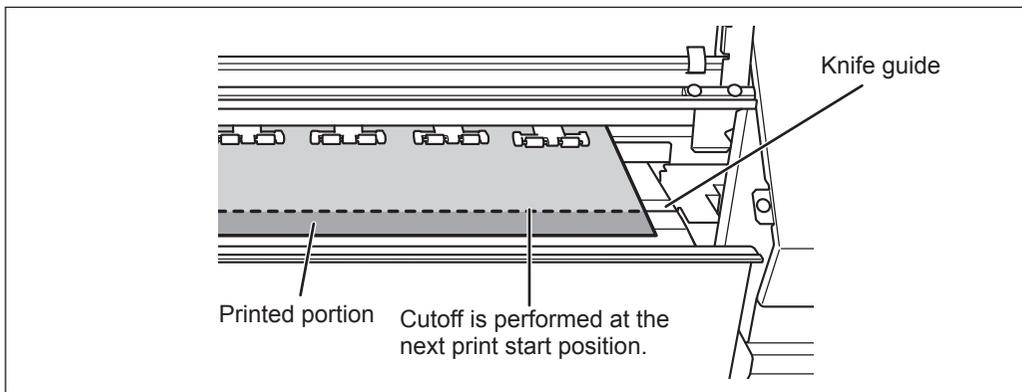
The screen shown in the figure appears.

- 3 Open the front cover 1 and remove the left and right media clamps.
- 4 Close the front cover 1.
- 5 Press **ENTER**.
The media is cut off.



When the media clamps are attached, the screen shown in the figure appears. Open the front cover 1, remove the right and left media clamps, and then press **ENTER**.

The cutoff location on the media is as shown in the figure below.



You can make the setting in the software RIP for automatic media cutoff after printing has finished. For information on how to make the setting, refer to the documentation for the software RIP you're using.

IMPORTANT!

Cut-off operations

- Be sure to detach the media clamps. Performing cutoff with the media clamps remaining attached may cause the operation to be interrupted due to detection of the media clamps.
- If the media clamps are present on the machine when the setting to execute automatic cutoff of the media is made on the software RIP, the media clamps are detected and no cutoff operation is performed
- Before you're performing cutoff, never press **▲** to pull the media back. Unless the end of the media has been pulled out to a location to the front of the platen, cutoff may not be performed smoothly.

Give attention to media composition

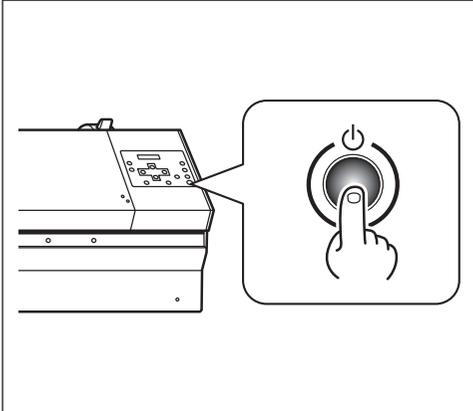
- For some types of media, cutoff is not possible.
- Some types of media may remain on the platen after cutoff. If the media remains on the platen, remove it by hand.

Switch Off

Switch Off

Procedure

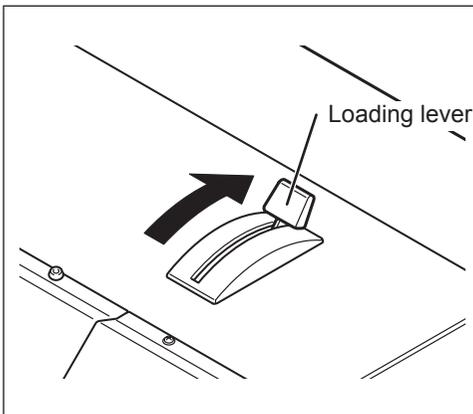
1



Hold down the sub power button for one second or longer.

The sub power is turned off. Perform this process after output is finished.

2



Press back the loading lever.

Even while the sub power is on, keep the loading lever down in the back if this machine is not being used.

IMPORTANT!

Leave the main power switched on at all times.

Never switch off the main power. By switching on the main power, the automatic maintenance function is carried out periodically. If the automatic maintenance is not carried out, it may result in breakdown of this machine such as breakdown of the print heads.

Never switch off the main power or unplug the power cord suddenly while operation is in progress.

Switching off the main power or unplugging the power cord suddenly while operation in progress may damage the print heads. Be sure to first switch off the sub power. If the main power is accidentally switched off, immediately turn the power back on.

Chapter 3

Using The Media Take-up System

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The Media Take-up System

Features of the Media Take-up System

The media take-up system makes it possible to perform output while the media is automatically taken up. This makes possible unattended operation at night and efficient printing of lengthy media.

About the Paper Tube

The included paper tube is a special part exclusively for use with this machine. Using something other than the included item may result in spinning without traction or other problems that impede media take-up. The paper tube is a part that wears out. The replacement cycle varies according to usage conditions, but to ensure good media take-up, monitor the state of the paper tube and replace it when necessary. To purchase a replacement, contact your authorized Roland DG Corp. dealer.



Take-up
System

Use Conditions of the Media Take-up System

When Performing Output without Pullback Movement (or When [TU] Is Selected)

SETUP SHEET
◀ TU

In using the media take-up system to perform output without pullback movement, select [TU] of the [SETUP SHEET] menu.

When [TU] is selected, follow the below instructions.

Never pull the media with excessive force.

If the media is pulled forcedly, it may result in interruptions during output or inaccuracy of output locations. When using the media take-up system, to avoid pulling media with undue force, be sure to observe the following points.

- Never operate the MANUAL switch for the take-up unit when the loading lever is pulled back.
- Never press  to pull the media back.
- When the computer has an activated setting to pull back the media after output, disable it.
- Set 50mm (2.0 inches) or more on the computer for the margin from the output end location to the next output start location (or the space between the pages).
- Do not perform pullback printing.

When performing continuous printing of two or more pages

When you're performing continuous printing and take-up for two or more pages, give attention to the following points.

- If the setting to execute automatic cutoff of the media can be made on the computer, then turn this setting off. Making the setting on the computer to execute automatic cutoff of the media results in media cutoff after each page is printed. Take up quits as soon as the media is cut off.

When Performing Output Involving Pullback Movement (or When [TU2] Is Selected)

SETUP SHEET
▶TU2

In using the media take-up system to perform output involving pullback movement, select [TU2] of the [SETUP SHEET] menu.

When [TU2] is selected, follow the below instructions.

Never pull the media with excessive force.

If the media is pulled forcedly, it may result in interruptions during output or inaccuracy of output locations. When using the media take-up system, to avoid pulling media with undue force, be sure to observe the following points.

- Never operate the MANUAL switch for the take-up unit when the loading lever is pulled back.
- Never press  to pull the media back.

When performing continuous printing of two or more pages

When you're performing continuous printing and take-up for two or more pages, give attention to the following points.

- If the setting to execute automatic cutoff of the media can be made on the computer, then turn this setting off. Making the setting on the computer to execute automatic cutoff of the media results in media cutoff after each page is printed. Take up quits as soon as the media is cut off.

About Length Output At One Time

If the length of output at one time is too long, the media may get soiled by touching the work floor. To avoid the media from getting soiled by touching the floor, output the media by about 300 mm (11.8 inches). To output by limiting the length, use the function of RIP software.

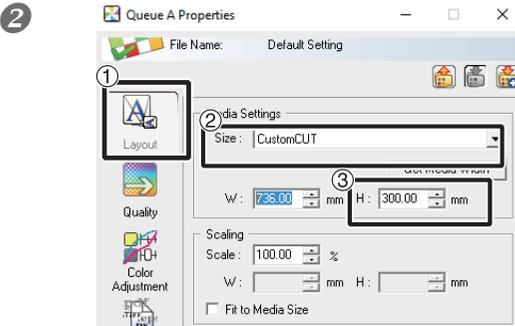
- ☞ The setting method when using VersaWorks Dual is continued on next page.

How to Output by Limiting Length (VersaWorks Dual)

This section describes "how to output by limiting the length" using VersaWorks Dual. For information on the detail usage of VersaWorks Dual, refer to the user's manual of VersaWorks Dual.

Procedure

- 1 Open "Que Properties" window (or "Job Setting" window)
Select the input folder to be used.



- 1 Click .
- 2 Select "CustomCUT" from [Size] under "Media Settings."
- 3 Set "H."

"Que Properties" window
(The setting item and the method in "Job Setting" window are the same as this procedure.)

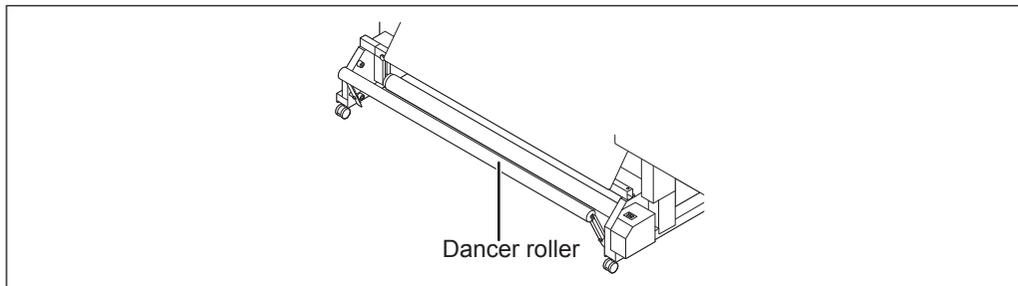


Loading the Media onto the Media Take-up System

Note: When using the media take-up system, remove the media hold down unit and the rigid media tables.

1. Pass the media through the printer.

- 1 Move the dancer roller toward the rear.



- 2 Switch on the printer's sub power.
- 3 Load the roll media onto the printer.

2. Fasten the media to the paper tube.

When you attach the paper tube, insert it securely onto the end caps on the take-up unit. For information on how to install it, refer to the Setup Guide.

- 1

SETUP SHEET
◀▶TU

[To perform output without pullback movement]
Press ◀ ▶ to select "TU."

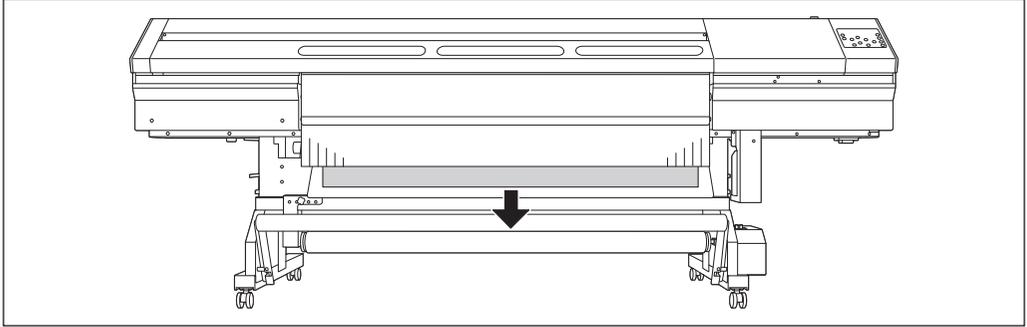
SETUP SHEET
◀▶TU2

[To perform output involving pullback movement]
Press ◀ ▶ and select [TU2].
- 2

LOAD SHEET	▼
TO TAKE-UP	↵

Press SET UP .
The screen shown in the figure appears.

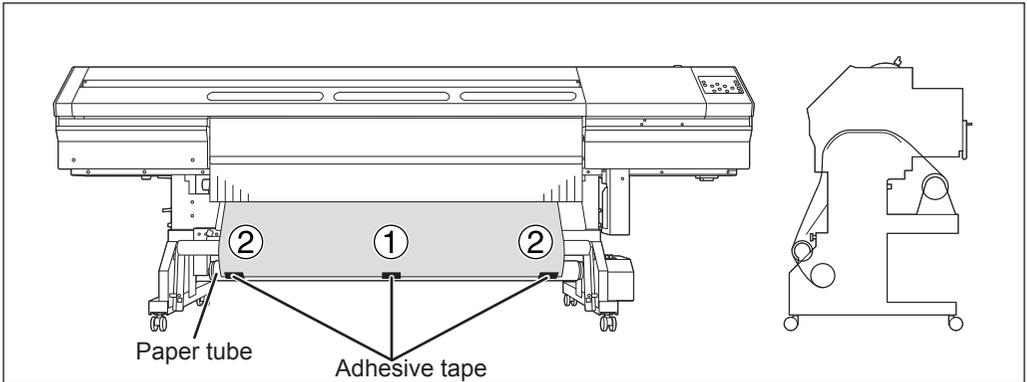
- 3 Use  to pull out the media until its leading edge reaches the paper tube.**
 You can adjust the length of the media in 10 mm (0.4 inch) steps by pressing . (To pull out media continuously, hold down the key.)



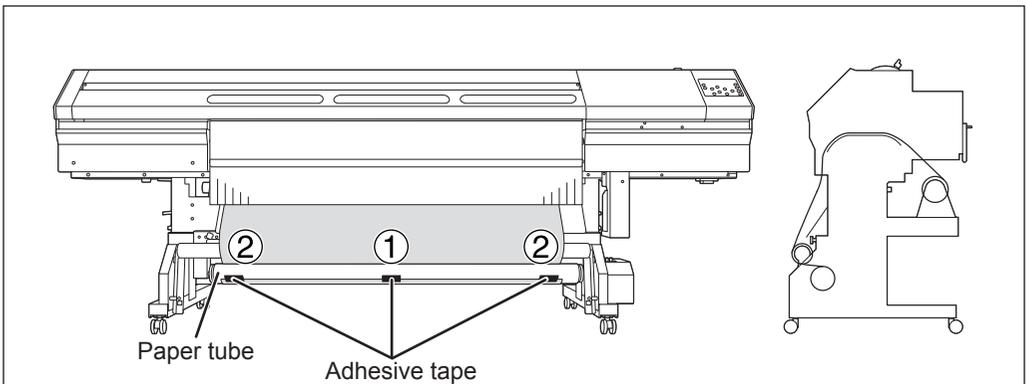
- 4 Using adhesive tape, fasten the center and side edges of the media to the paper tube (fasten a total of three locations).**

- ① Secure the center of the media in place while keeping the media stretched taut to keep it free of slack.
- ② While pulling the media from the center outward, fasten the left and right edges.

■ Take-up with outward curl



■ Take-up with inward curl

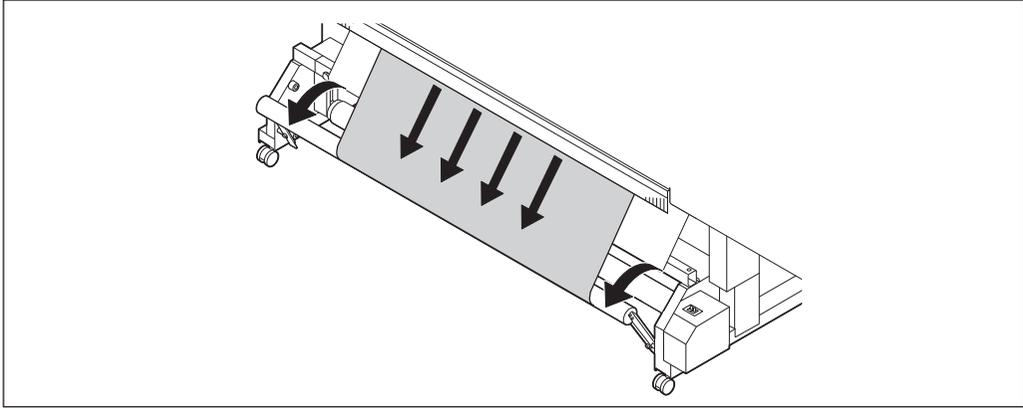


5 TILT DANCER
ROLLER TO FRONT ↵

Press **ENTER** .

The media is pulled out and the screen shown in the figure appears.

6 Pull the dancer roller back toward you.



7 CHECK
TAKE-UP SETTING ↵

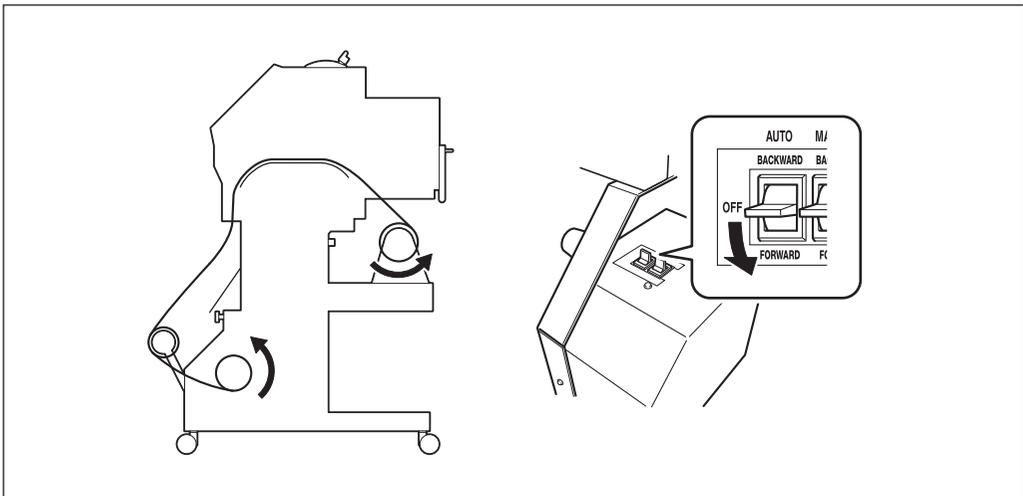
Make sure the media is stretched taut, and press **ENTER** .

The screen shown in the figure appears.

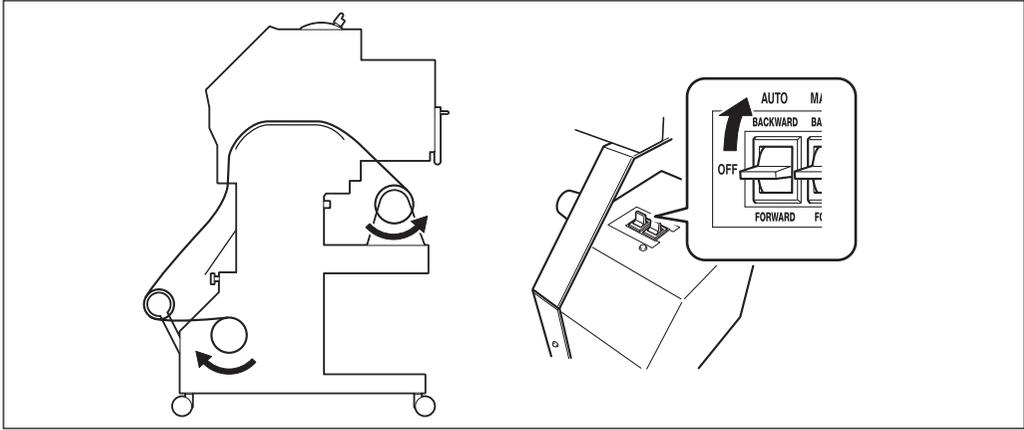
3. Make the setting for the direction of automatic take-up and perform take-up of the media onto the paper tube.

1 Make the setting for the AUTO switch on the take-up unit.

■ Take-up with outward curl



■ Take-up with inward curl



2

W XXXmm

Press **ENTER**.

When the screen shown on the left (the top menu) appears, the media-loading process is complete. XXXX indicates the width of the loaded media. With [TU2] selected, the media will be fed out until the dancer roller leans down to the front completely.

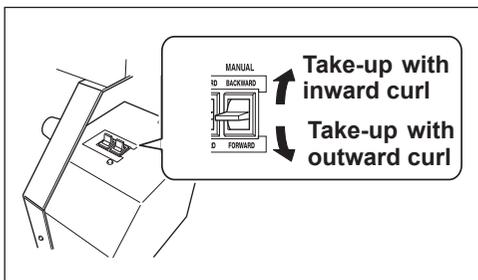
IMPORTANT!

When you begin take-up, take care to ensure that the end of the media does not become rolled or creased.

Operation till the media is taken up when [TU2] is selected

The media is not taken up during output. When output is finished, the media is pulled back to a given position, and the taking-up operation starts.

To Take up Media Manually



You can take up media by using the MANUAL switch. However, never operate the MANUAL switch while the loading lever is pulled back. Doing so may cause the media to be pulled with excessive force, actuating the protective feature and resulting in an error.

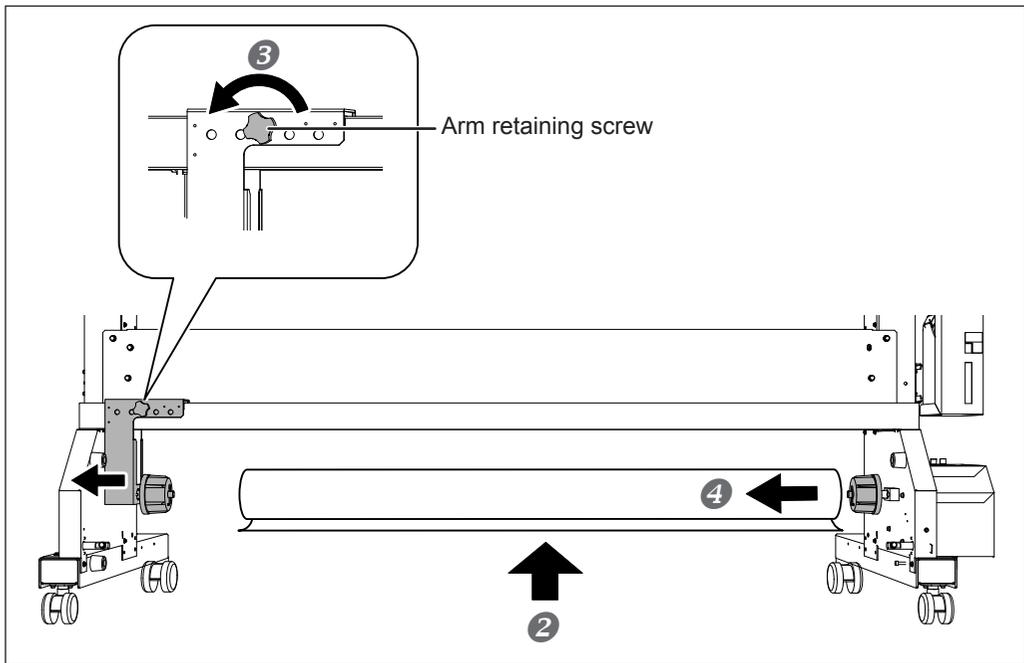
Removing Taken-up Media

⚠ CAUTION

Removal of taken-up roll media from the unit is a task which must be carried out by two or more persons.

If dropped, such items may cause injury.

- 1 **Cut off the media.**
☞ P. 71, "Cutting Off the Media"
- 2 **Support the paper tube to prevent it from falling.**
- 3 **Loosen the arm retaining screw and move the arm.**
- 4 **Detach the paper tube from the end caps.**



Chapter 4

Maintenance:

For always using the printer in the best condition

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Checking for Remaining Ink and Replacing Cartridges

Checking for Remaining Ink

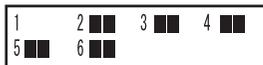
Procedure

1 Press **MENU**.

2 

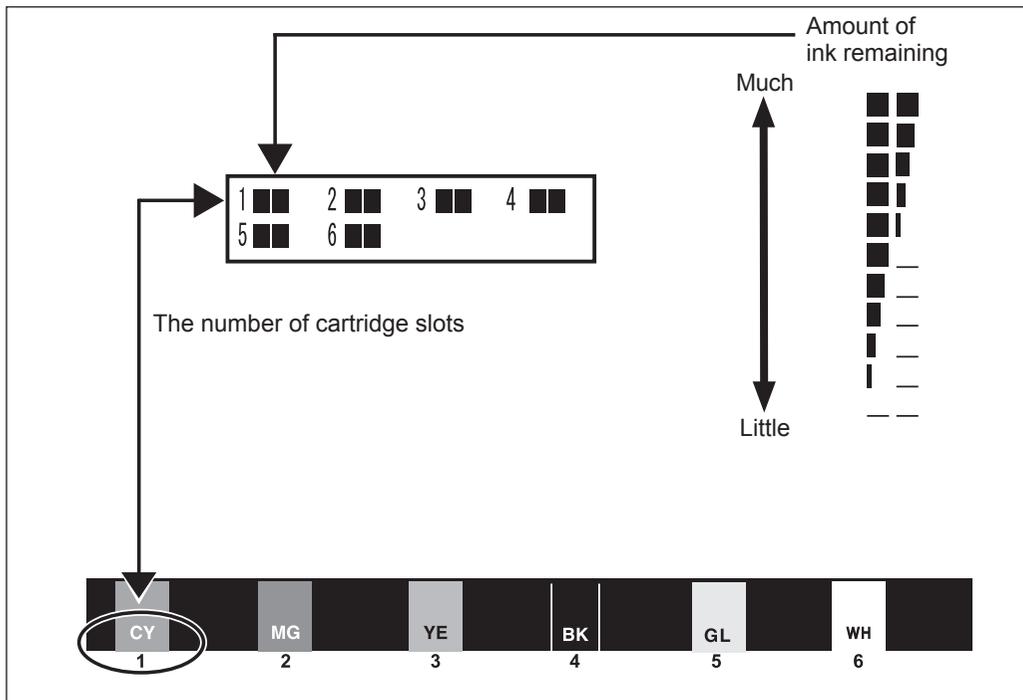
Press **▲** several times until the screen shown on the left appears.

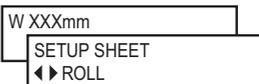
Press **▶**.



 indicates the amount of ink remaining. When there are more , the amount of ink remaining is larger.

* The display shows an approximate guide to the amount of remaining ink. It may differ somewhat from the actual amount remaining.



3 

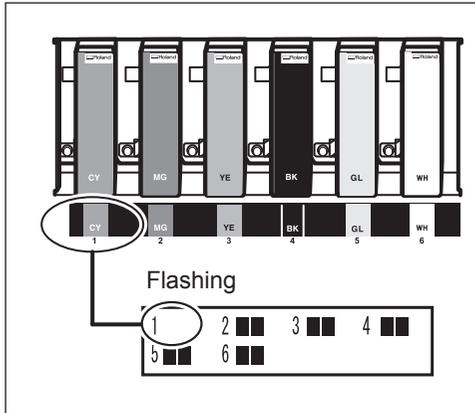
Press **MENU** **◀** in this order to go back to the original screen.

How to Replace Ink Cartridges

When ink runs out, a warning beep sounds and printing pauses (unless the default settings have been changed). Pull out the empty cartridge and insert a new one. Printing resumes.

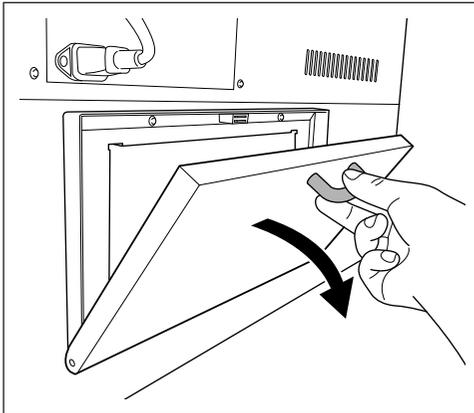
Procedure

1



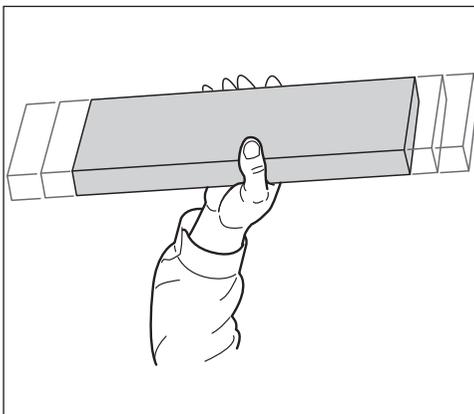
Check the number flashing on the screen.
The ink at the flashing cartridge slot number is running out.

2



Open the ink cartridge cover.

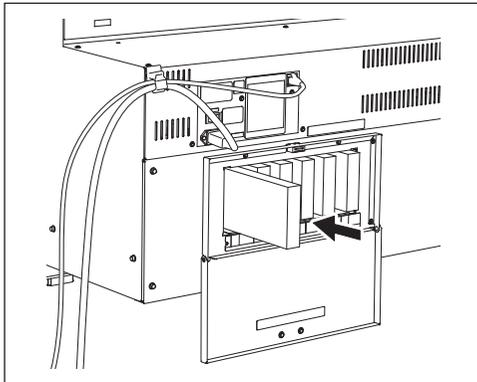
3



Before inserting ink cartridges, shake each of them 50 times (about 15 seconds).

If ink components precipitate, it will not be possible to print with correct colors. So that the ink mixes well, shake each ink cartridge horizontally with a stroke length of around 5 cm (2 in.) from each end of the ink cartridge.

4

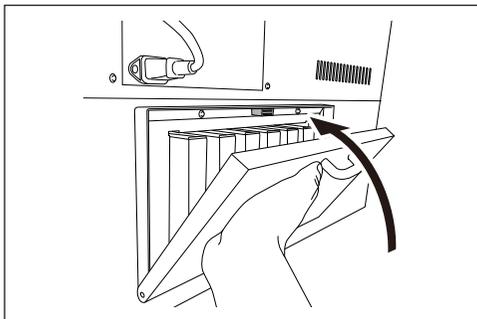


Pull out the empty ink cartridge and immediately insert the new one.

POINT!

- Keep the labeled side face up.
- Insert and remove slowly, one at a time.
- Make sure the cartridge is inserted completely.

5



Close the ink cartridge cover.

4

Maintenance

IMPORTANT! Important notes on replacing cartridges

- Make sure that the ink cartridge cover is always closed except when absolutely necessary, such as when you are replacing ink cartridges. The ink inside the cartridges will become hardened, and it may cause the printer to malfunction.
- Be sure to replace with an item of identical type.
- Never use an ink cartridge which has already been used in other machines even if it is of the identical type.
- Never mix items of different types.
- Never allow the machine to stand with an ink cartridge removed. The print heads may become clogged.
- Never insert or remove a partially used ink cartridge.
- Never remove an ink cartridge suddenly while the printer is in operation.

⚠ WARNING

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

- Any location exposed to open flame
- Any location where high temperature may occur
- Near bleach or any other such oxidizing agent or explosive material
- Any location within the reach of children

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

Automatic Maintenance Feature

Automatic Maintenance Feature and Notes

This machine is provided with a feature that automatically performs maintenance on a periodic basis. Because this performs operations that are intended to keep the print heads from drying out, be sure to observe the following matters.

- **Leave the main power on at all times.**
- **Never leave the front cover 1 open for long periods.**
- **After finishing making the settings for the various menu items, go back to the top menu.**

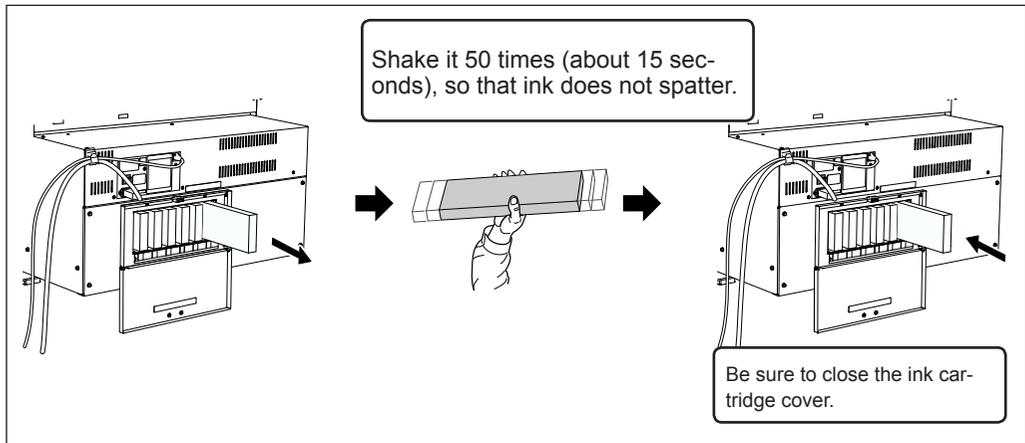
Maintenance that Should Be Performed Daily

Maintenance of Ink Cartridges

Be sure to perform the following tasks. The ink contains ingredients that have the property of becoming deposited. Particularly, the white ink contains ingredients that are highly likely to get deposited, and the settled components may get hardened and cause troubles including malfunctions of the machine if it is left untouched for a certain time.

- **Shake the new ink cartridge 50 times (about 15 seconds), before setting it in.**
- **Remove only the white ink cartridge once, shake it 50 times (about 15 seconds), and set it in before starting the operation for the day.**

☞ P. 104, "The Concentration and Dot Drop-Out of the White Ink"



Disposing of Discharged fluid

CHECK
DRAIN BOTTLE

The drain bottle collects discharged fluid. Dispose of collected material before the bottle becomes full. The message shown in the figure appears when a certain amount of discharged fluid has collected in the bottle. Follow the procedure below to discard the discharged fluid.

Procedure

1 CHECK
DRAIN BOTTLE

When the message shown in the figure appears, press **ENTER**.

2 Press **MENU**.

3 MENU
SUB MENU

Press **▼** several times to display the left figure. Press **▶** and then **▲**.

4 SUB MENU
MAINTENANCE

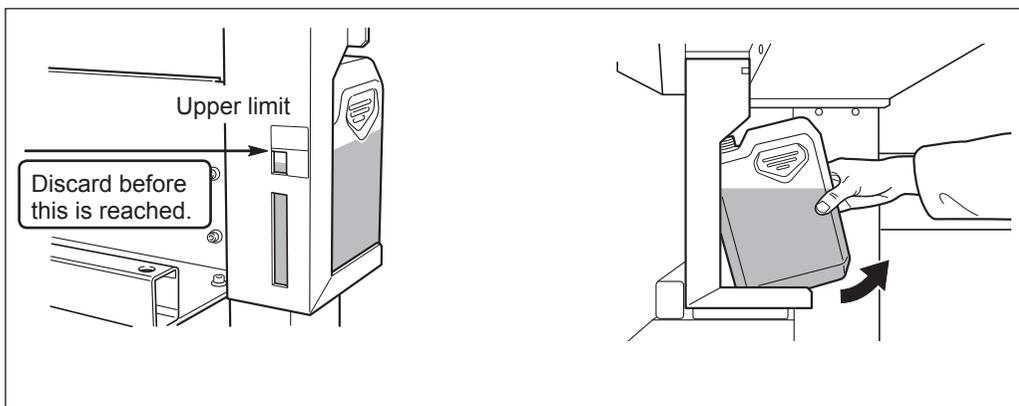
Press **▶** and then **▲**.

5 MAINTENANCE
DRAIN BOTTLE

Press **ENTER**.

6 EMPTY
DRAIN BOTTLE

When the screen shown on the left appears, detach the bottle, discard the discharged fluid to empty it.



⚠ CAUTION

Before you detach the drain bottle, be sure to wait for the screen to display **"EMPTY DRAIN BOTTLE."**

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

7

EMPTY	◀
DRAIN BOTTLE	↵

Attach the emptied drain bottle to the machine.

Press **ENTER**.

8

RESET DRAIN	◀
COUNTER	↵

Press **ENTER**.

9

W XXXmm	◀
SETUP SHEET	↵
◀▶ ROLL	

Press **MENU** **◀** in this order to go back to the original screen.

⚠ WARNING Never place discharged fluid near open flame. Doing so may cause fire.

⚠ CAUTION To store discharged fluid temporarily, place it in the included drain bottle or in a durable sealed container such as a metal can or polyethylene tank, and cap tightly. Any spillage or vapor leakage may cause fire, odor, or physical distress.

Store discharged fluid in a location not exposed to direct sunlight.

When temporarily storing discharged fluid in the included drain bottle, keep the drain bottle out of direct sunlight. Otherwise the discharged fluid may harden, making the drain bottle unusable.

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

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

Cleaning

⚠️ WARNING Never use gasoline, alcohol, thinner, or any other flammable material. Doing so may cause fire.

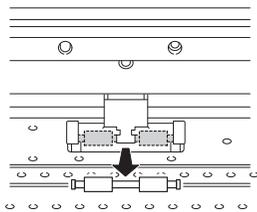
Wipe away any buildup of ink or grime on the media path and other locations as daily cleaning. In particular, the pinch rollers, grit rollers, platen, and the rubber cover on the front cover 2 are likely to get a build-up of grime. Clean by wiping with a cloth moistened by neutral detergent diluted with water then wrung dry.

POINT!

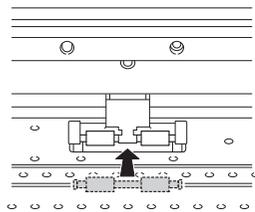
- This machine is a precision device, and is sensitive to dust and dirt. Perform cleaning on a daily basis.
- Never attempt to oil or lubricate the machine.

Pinch rollers

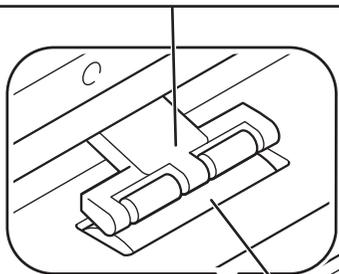
- Periodically wipe away any grime. Failure to clean properly may result in the transfer of grime to the surface of media. Additionally, if they are dirty when performing output involving pullback movement, an imprint from the pinch rollers may be left behind.
 - The pinch rollers can be removed. You can remove them for cleaning.
- *Make sure you reattach the pinch rollers before printing.



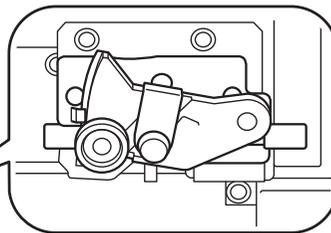
Remove the pinch rollers by gently pushing them down.



Reattach the pinch rollers by gently pushing them back up.



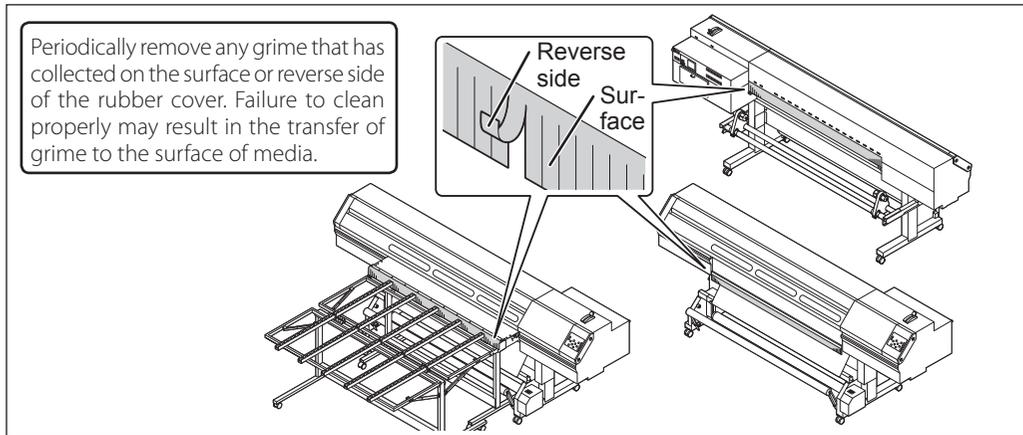
Wipe away any buildup of ink or grime on the media path.



Roller of the separating knife
Paper dust is likely to deposit on this roller. Wipe the roller regularly.

Grit rollers

Remove buildup of media and other material using a brush. Never use a metal brush.



About Care and Maintenance of Print Heads

Care of the print heads is essential to ensuring optimal printing at all times. There are daily care and periodic care.

Daily Care and Maintenance

➤ Normal cleaning

It is recommended to perform the normal cleaning before daily operation.

☞ P. 67, "Printing Tests and Normal Cleaning"

Periodic Care and Maintenance

➤ Medium cleaning/Powerful cleaning

Perform the medium cleaning or powerful cleaning when the problems such as dot drop-out are not cleared up by the normal cleaning.

☞ P. 95, "Medium/ Powerful Cleaning"

➤ Manual Cleaning

Based on your frequency of use, perform the manual cleaning periodically.

☞ P. 98, "Performing Manual Cleaning"

➤ Circulation of White ink

Perform the circulating ink when concentration of the white ink to decrease.

☞ P. 104, "Restoring White Ink Concentration"

➤ White Ink Replacement

Perform the white ink replacement when the dot drop-out cannot be cleared by conducting the cleaning features (including the normal, medium, and powerful cleaning) or the manual cleaning.

☞ P. 105, "When the Dot Drop-Out Cannot be Cleared"

* The print heads are components that wear out. Periodic replacement is required, with the frequency of replacement depending on use. Purchase them from your authorized Roland DG Corp. dealer.

When Normal Cleaning Is Not Effective

Medium/ Powerful Cleaning

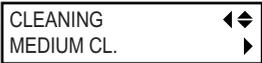
When the dot drop-out cannot be cleared by the normal cleaning ("Printing Test and Normal Cleaning" on page 67), perform a more powerful cleaning, a "medium cleaning," twice or three times. If the condition is not improved, try the even more forceful "powerful cleaning."

POINT!

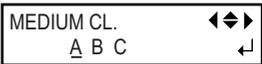
The medium cleaning consumes more ink than the normal cleaning. The powerful cleaning consumes more ink than the medium cleaning. Because the print heads are prone to get damaged if these cleanings are conducted too frequently, do not perform such cleanings more than necessary.

Procedure

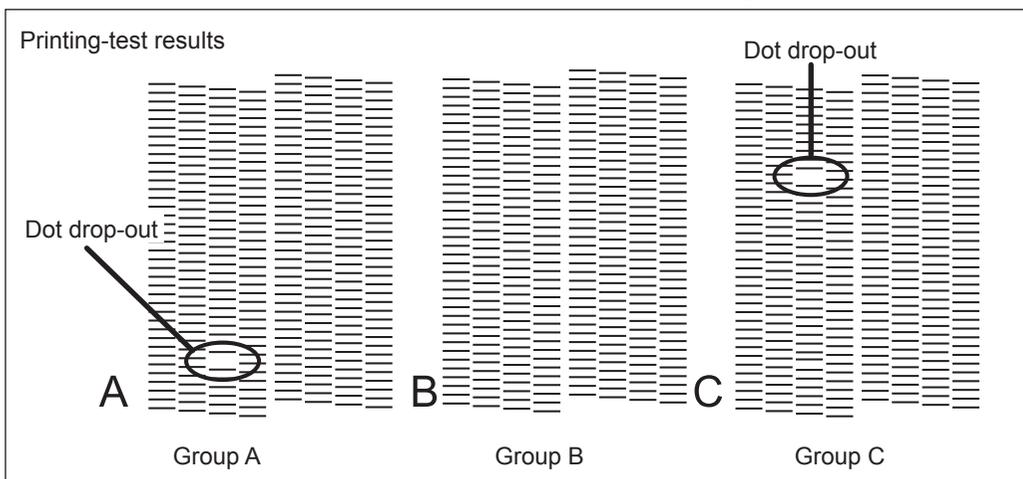
1 Press **CLEANING**.

2 

Press **▼** or **▲** and select "Medium."
When "Medium" is not effective, select "Powerful."
Press **▶**.

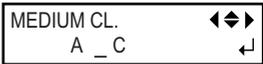
3 

Press **◀** **▶** to choose the group of print heads that is not to be cleaned.
Press **▼** **▲** to get rid of the group display.
Repeat this procedure to display the groups of only the print heads that require cleaning.

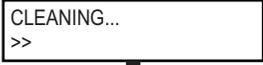


If the printing-test results are difficult to interpret

Examine the results from different angles in a well-lighted location. Take advantage of reflected light to enable visual checking.

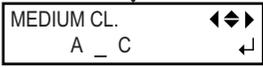
4  Press .

5 **If You Chose "MEDIUM CL."**



The screen shown in the figure appears, then cleaning starts.





When it finishes, the screen shown in the figure appears.

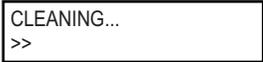
If You Chose "POWERFUL CL."



Check the drain bottle.

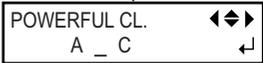
If the amount of discharged fluid is near the upper-limit line, then remove the bottle, discard the collected fluid, and reattach the bottle.

Press .

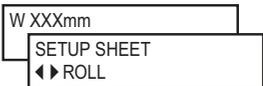


The screen shown in the figure appears.





When it finishes, the screen shown in the figure appears.

6 

Press   in this order to go back to the original screen.

Maintenance that Should Be Performed More Than Once a Month

When Manual-Cleaning Becomes Necessary

Perform The Manual Cleaning More Than Once a Month.

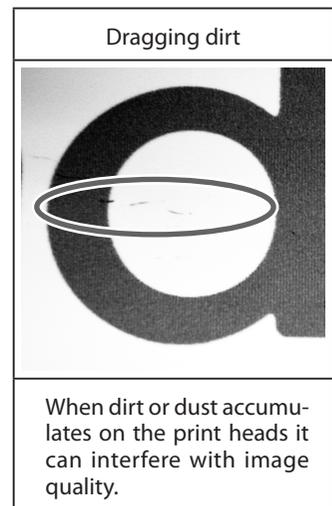
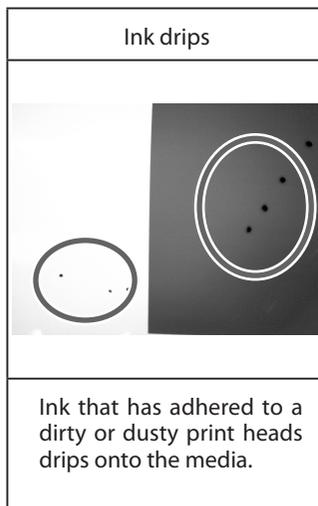
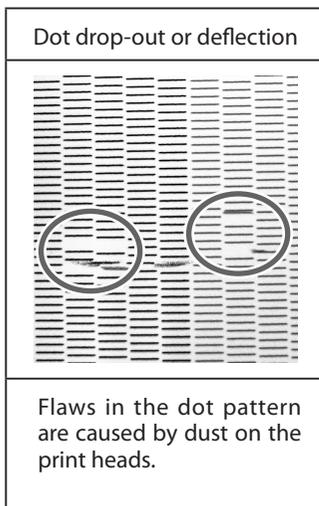
To keep the stable output condition at all times, perform the manual cleaning more than once a month.

The Manual Cleaning is Recommended When The Following Symptoms Occur.

It is recommended to perform the manual cleaning when any of the symptoms given below occurs and it cannot be solved by the automatic cleaning functions such as the normal cleaning.

For your information, replacement of the wiper is also effective to improve the symptoms.

☞ P. 107, "Replacing the Wiper"



* When the cleaning stick and cleaning liquid for the manual cleaning runs out, place an order for them with your authorized Roland DG Corp. dealer.

* The print heads are components that wear out. Periodic replacement is required, with the frequency of replacement depending on use. Purchase them from your authorized Roland DG Corp. dealer.

Performing Manual Cleaning

IMPORTANT!

Important notes on this procedure

- For the manual cleaning, the included cleaning liquid and cleaning stick are necessary. Please prepare them in advance.
- Before attempting this operation, remove any media.
- To prevent the print heads from drying out, finish this procedure in 10 minutes or less. A warning beep sounds after 10 minutes.
- Never use any implement other than the included cleaning stick. Cotton swabs or other lint-producing items may damage the print heads. If you use up the cleaning stick, purchase a new one from your authorized Roland DG Corp. dealer.
- Use one cleaning stick per cleaning session, then discard the stick after use. Reusing cleaning sticks may reduce printing quality.
- Do not put the cleaning stick used for cleaning into the cleaning liquid. It will deteriorate the fluid.
- Never rub the nozzle surface of the print heads.
- Stroke the sponges very gently, applying as little pressure as possible. Never rub, scrape, or crush them.
- Do not clean the irradiation surface (glass surface) of the UV irradiation device. Doing so may damage the UV irradiation device. For details on cleaning the irradiation surface of the UV irradiation device, contact your authorized Roland DG Corp. dealer.

When a warning beep sounds during cleaning

- A warning beep sounds after 10 minutes. At this time, stop work, attach the side cover and the maintenance cover, then close the front cover 1. Press **ENTER** to quit the manual-cleaning menu. After that, restart the procedure from the beginning.

⚠ CAUTION Be sure to perform operations as specified by the instructions above, and never touch any area not specified in the instructions. Sudden movement of the machine may cause injury.

1. Change to the print-head manual-cleaning menu.

1 Remove any media.

2 Press **MENU**.

3 

Press **▼** several times until the screen shown on the left appears.

Press **▶** and then **▲**.

4 

Press **▶**.



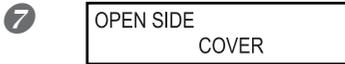
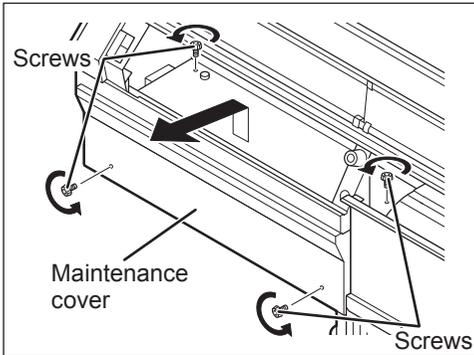
Press **ENTER**.



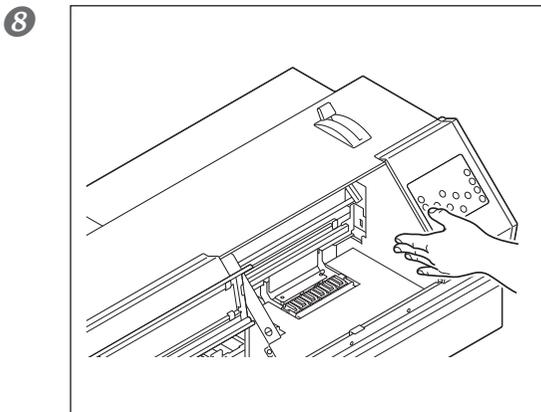
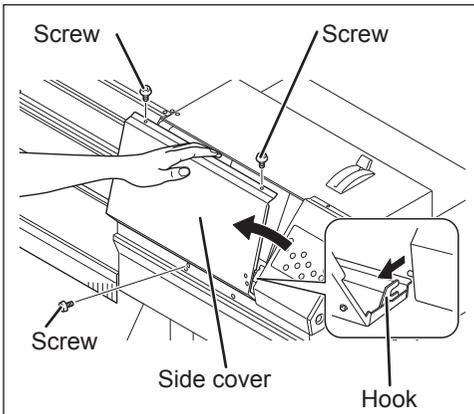
Open the front cover 1 and remove the maintenance cover.

Close the front cover 1 and press **ENTER**.

The print-head carriage moves to the left side of the machine.



When the screen shown on the left appears, open the side cover.



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

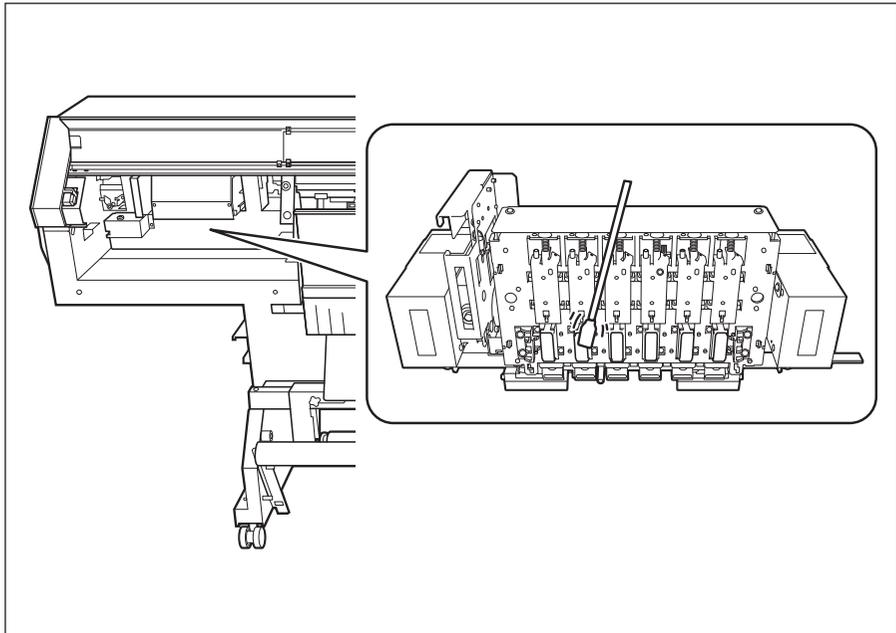
POINT! **Cleaning of the print heads surface as an emergency measure**

When dot drop-out and/or dot deflection is not improved even if cleaning is performed several times, you can clean the print heads surface as an emergency measure. Since the print heads surface (nozzle surface) has an extremely delicate mechanism, make sure to perform the operation carefully and deliberately.

Note that this operation is an emergency measure. It may damage defect-free parts depending on the symptom, deteriorating it. If you have any questions, contact your authorized Roland DG Corp. dealer.

Procedure

- 1** **Moisten the cleaning stick with the cleaning liquid.**
- 2** **Softly press the cleaning stick to the print heads surface (nozzle surface).**
Press it gently and softly so that the print heads nozzle is permeated with the cleaning liquid. Never rub the stick on the surface and press it forcibly.



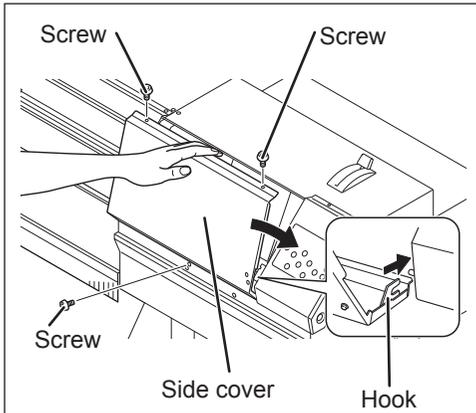
3. Quit the manual cleaning mode.

1 Press **ENTER**.

2 **CLOSE SIDE COVER** ↵

When the screen shown on the left appears, attach the side cover.

Press **ENTER**.



3 **CLOSE FRONT COVER 1** ↵

Close the front cover 1.

Press **ENTER**.

The print-head carriage moves to the right side of the machine.

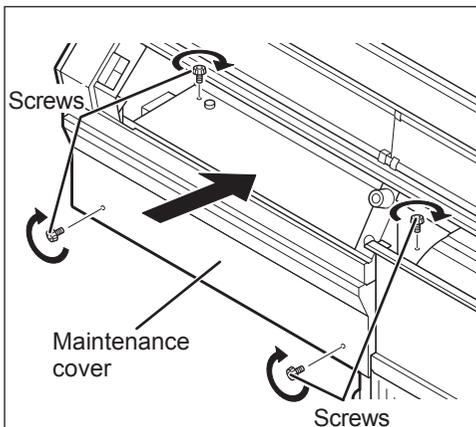
CLEANING...
>>

4 **CLOSE MAINTENANCE COVER** ↵

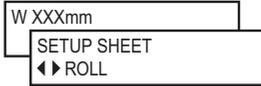
When the screen shown on the left appears, open the front cover 1, and then attach the maintenance cover.

Close the front cover 1.

Press **ENTER**.



5



Press   in this order to go back to the original screen.

4. Perform a printing test to verify the results of the procedure.

Perform a printing test to check the results.

Perform cleaning using the machine's cleaning feature several times when necessary.

☞ P. 67, "Printing Tests and Normal Cleaning"

The Concentration and Dot Drop-Out of the White Ink

Restoring White Ink Concentration

Prolonged use of this machine may cause the concentration of the white ink to decrease. This is because white ingredients in white ink easily precipitate. The "CIRCULATING INK" feature circulates the ink to eliminate white ink precipitation. However, this procedure requires some ink to be discharged, so you should not perform this procedure frequently.

IMPORTANT!

This function applies to the Version 1.50 or later of the printer firmware. For how to check the firmware version, refer to P. 142, "Viewing Information about the System of This Machine".

Procedure

- 1 Press **MENU**.
- 2  Press **▼** several times until the screen shown on the left appears.
Press **▶**.
- 3  Press **▲** several times until the screen shown on the left appears.
Press **▶** and then **▲**.
- 4  Press **▶**.
- 5  Press **ENTER**.
Ink circulation starts.

When the Dot Drop-Out Cannot be Cleared

White ink may sometimes cause abnormal discharges including the dot drop-out even when the cleaning features (such as the normal, medium, and powerful cleaning) and the manual cleaning are performed. This can occur because the ingredients in white ink tend to settle, and may harden if allowed to stand for a lengthy time. If this happens, carry out the operations described below. This operation requires two cleaning cartridges.

IMPORTANT!

A large amount of ink will be discharged during this operation. Perform this operation only when dot drop-out cannot be cleared up even after performing cleaning using the cleaning function (normal, medium, or powerful) or manual cleaning.

☞ P. 90, "Maintenance that Should Be Performed Daily"

☞ P. 95, "When Normal Cleaning Is Not Effective"

☞ P. 97, "Maintenance that Should Be Performed More Than Once a Month"

Procedure

1 Press **MENU**.

2 

Press **▲** several times until the screen shown on the left appears.

Press **ENTER**.

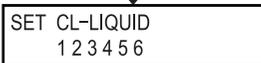
3 

Discard the discharged fluid and attach the emptied bottle.

Press **ENTER**.

4 

Number 5 and 6
flashes.



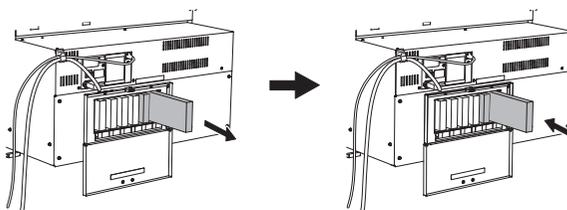
Number 5 and 6
flashes.

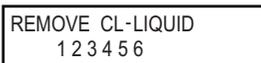


1 Open the ink cartridge cover.

2 Remove the ink cartridges from slots 5 and 6.

3 Insert SOL INK cleaning cartridges into slots 5 and 6.

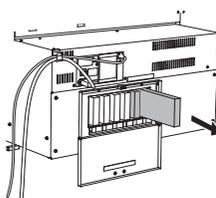


5 



When this screen appears, pull out the SOL INK cleaning cartridges from slots 5 and 6.

Carry out steps 4 and 5 as many times as indicated by the on-screen messages.



Replacing Consumable Parts

Replacing the Wiper

TIME FOR
WIPER REPLACE ↵

The wipers are components that you use when cleaning the print heads. When the screen displays a message like the one shown, it means the item needs to be replaced. Replace with new items. Regarding the purchase of the wiper, contact your authorized Roland DG Corp. dealer.

When a warning beep sounds during replacing the wiper.

A warning beep sounds after 10 minutes. At this time, stop work, attach the side cover. And then press **ENTER** to finish the wiper replacement menu. When the print-head protection operation finishes, restart the procedure from the beginning.

CAUTION

Be sure to perform operations as specified by these instructions, and never touch any area not specified in the instructions. Sudden movement of the machine may cause injury.

1. Display the [REPLACE WIPER] menu.

1

TIME FOR
WIPER REPLACE ↵

When the message shown in the figure appears, press **ENTER**.

2

Remove any media from the platen.

3

Press **MENU**.

4

MENU
SUB MENU ▶

Press **▼** several times until the screen shown on the left appears.

Press **▶** and then **▲**.

5

SUB MENU
MAINTENANCE ▶

Press **▶** and then **▼**.

6

MAINTENANCE
REPLACE WIPER ↵

Press **ENTER**.

NOW PROCESSING..



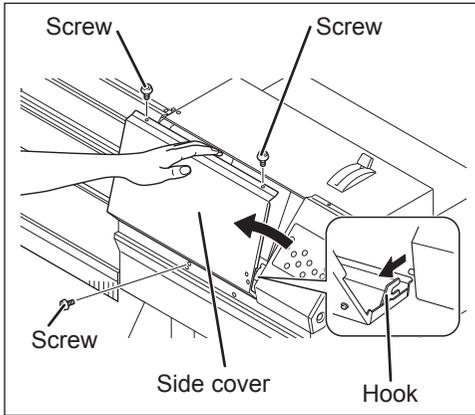
OPEN SIDE
COVER

The print-head carriage moves to a location where wiper replacement is possible, and then the screen shown in the figure appears.

4

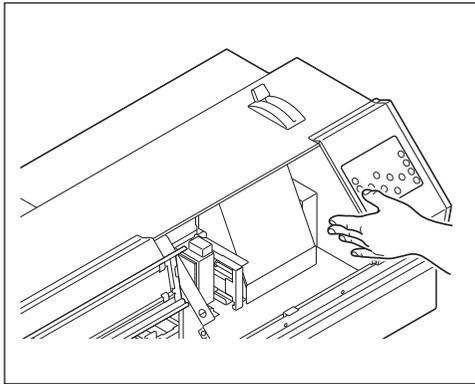
Maintenance

7



Remove the side cover.

8

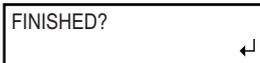


Touch the location shown in the figure to discharge any static electricity.

4

Maintenance

9

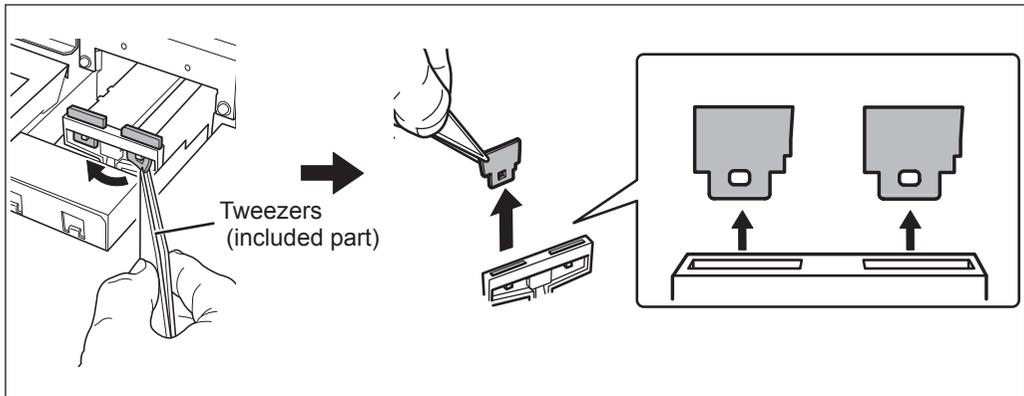


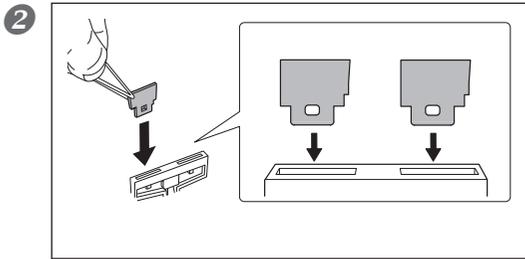
Preparations are complete when this screen appears

2. Replace the wipers.

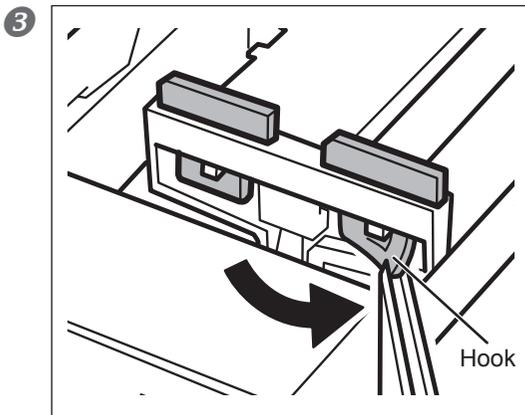
1

Detach the old wipers.
Detach the hook and pull up and out.



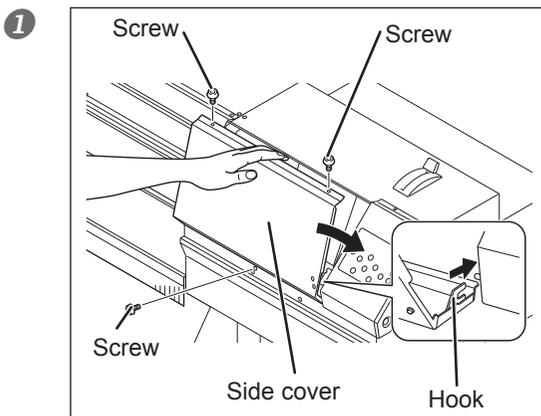


Insert the new wipers.



Attach the hook.

3. Quit the wiper replacement menu.



Attach the side cover.

2



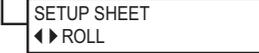
Press **ENTER**.



After the process to quit the wiper replacement mode, the screen shown in the figure appears.



3



Press **MENU** **◀** in this order to go back to the original screen.

4. Perform a printing test to verify the results of the procedure.

Perform a printing test to check the result.

☞ P. 67, "Printing Tests and Normal Cleaning"

Replacing the Separating Knife

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



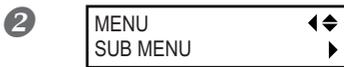
Be sure to perform operations as specified by these instructions, and never touch any area not specified in the instructions.
Sudden movement of the machine may cause injury.



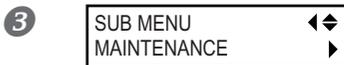
Never touch the tip of the blade with your fingers.
Doing so may result in injury.

1. Replacing the separating knife.

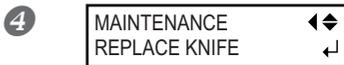
1 Press **MENU**.



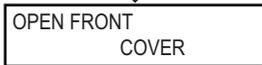
Press **▲** several times until the screen shown on the left appears.
Press **▶** and then **▲**.



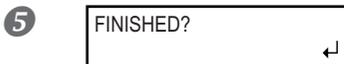
Press **▶**.
Press **▼** twice.



Press **ENTER**.

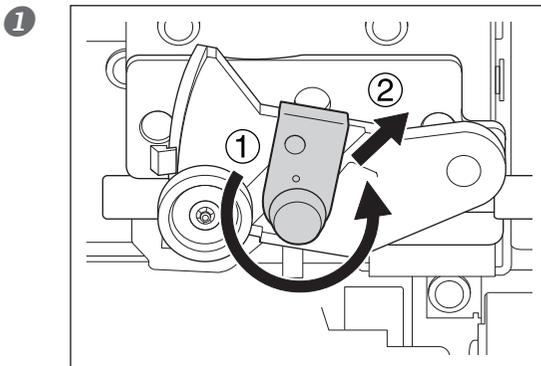


The print-head carriage moves to a location where blade replacement is possible, and then the screen shown in the figure appears.



Open the front cover 1.
Preparations are complete when this screen appears.

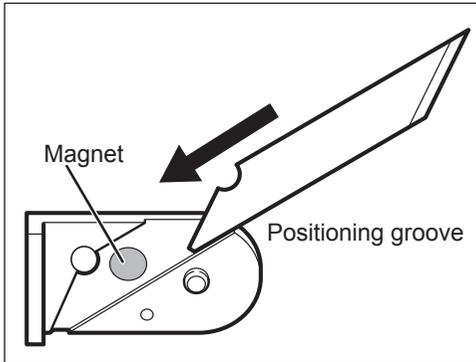
2. Replace the separating knife.



Remove the separating knife.

- ① Loosen the screw until it slips out.
- ② Grasp the screw portion, and slowly pull it out in the direction of the arrow. When doing this, do not pull it back toward you.

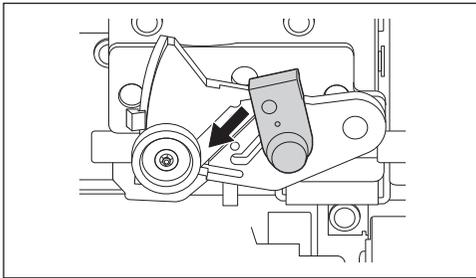
2



Install a new knife.

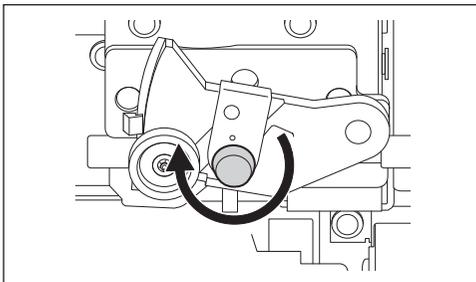
The knife is secured in place by the magnet.

3



Slowly insert it into the groove.

4

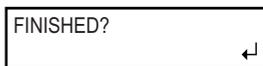


Tighten the screw.

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

3. Quit the blade replacement menu.

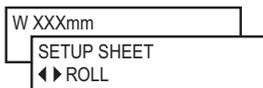
1



Close the front cover 1.

Press **ENTER**.

2



Press **MENU** **◀** in this order to go back to the original screen.

When Not in Use for a Prolonged Period

Keep Performing Maintenance

Switch on the power once every two weeks

Switch on the sub power once every two weeks. When you turn on the power, the machine automatically performs some operations such as those to keep the print heads from drying out. Allowing the machine to stand completely unused for a prolonged period may damage the print heads, so be sure to switch on the power to perform these automatic operations.

Keep at a Constant Temperature and Relative Humidity

Even when the machine is not in use, keep it at a temperature of 5 to 40°C (41 to 104°F) and a relative humidity of 20 to 80% (with no condensation). If temperatures are too high or too low, it may cause malfunction.

Alarm Feature

PRESS THE POWER
KEY TO CLEAN

This feature is to remind you to switch on the sub power once a month. When the machine remains unused for about one month, this screen appears and a warning beep sounds. If this screen appears, switch on the sub power. When maintenance operations finish, switch off the sub power.

This feature operates when the printer's main power is turned on. We recommend leaving on just the main power to the printer even when the machine is to remain out of use for a prolonged period.

Important Note on Draining Ink

INK CONTROL PUMP UP

INK CONTROL HEAD WASH

This machine has features for draining internal ink and for performing washing using SOL INK cleaning cartridges, but they should never be used except in special cases. Allowing the machine to stand without ink for a prolonged period may damage the print heads, even if internal washing is performed. Once ink has been filled, then as a rule the ink should never be drained.

Chapter 5

Part of Practice

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Fully Utilizing Preset Function

Saving the Various Settings to the Preset

Procedure

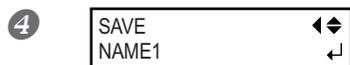
1 Press **MENU**.



Press **▼** twice to display the left figure.
Press **▶** and then **▼**.



Press **▶**.



Press **▲** **▼** to select one of NAME1 through 8.
Press **ENTER** to enable the setting.

The present menu settings are saved.



Press **MENU** **◀** in this order to go back to the original screen.

Description

Using the [PRESET] menu lets you easily change a wide variety of settings to optimize them for the media. Up to eight types of presets can be saved. You can assign a name to each one. Using media names for these may aid recognition and clarity. Making changes for each menu item every time you change the media can be troublesome. That's why it can be useful to save the menu-item settings optimized for an often-used type of media as a preset. The next time you use the media, you can change the menu-item settings to the optimal values for the media simply by loading the preset you saved. Menu items that can be saved in presets are listed below.

[ADJUST BI-DIR SIMPLE SETTING]	☞ P. 119, "Correcting for Misalignment in Bidirectional Printing"
[ADJUST BI-DIR DETAIL SETTING]	☞ P. 120, "Correcting for Misalignment in Bidirectional Printing More Precisely"
[CALIBRATION]	☞ P. 120, "Alleviating Horizontal Bands and the Like (feed correction function)"
[SHEET TYPE], [SHEET WIDTH], [SHEET POS.]	☞ P. 123, "Using Transparent or High Gloss Media"
[SIDE MARGIN], [FRONT MARGIN]	☞ P. 125, "Expanding the Printing Area by Reducing the Margins"
[VACUUM POWER]	☞ P. 126, "Using the Media Easy to be Winkled / Hard to be Fed"
[FULL WIDTH S]	☞ P. 127, "Speeding Up Output for Narrow Media"

☞ P. 117, "Loading a Saved Preset"

☞ P. 117, "Assigning a Name to a Preset"

Loading a Saved Preset

Procedure

1 Press **MENU**.

2

MENU	◀▶
PRESET	▶

Press **▼** to display the left figure.
Press **▶** twice.

3

LOAD	◀▶
NAME1	↵

Press **▲** **▼** to select a name to be called.
Press **ENTER** to enable the setting.

SETUP SHEET	◀▶
ROLL	

The settings are changed and the screen shown in the figure appears.

Description

This loads a saved preset. You can select any one of eight types of presets. (When no names have been assigned, you select from among NAME1 through NAME8.) If you load a preset while **SET UP** is illuminated, **SET UP** goes dark. When starting output, press **SET UP** again to make the output operation available.

Assigning a Name to a Preset

Procedure

1 Press **MENU**.

2

MENU	◀▶
PRESET	▶

Press **▼** to display the left figure.
Press **▶** and then **▲**.

3

PRESET	◀▶
NAME	▶

Press **▶**.

4

NAME	◀▶
NAME1	▶

Press **▲** **▼** to select one of NAME1 through 8.
Press **▶**.

5

NAME	◀▶
S_	↵

Press **▲** **▼** to enter a character.
When a character is decided, press **▶**.

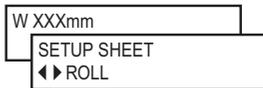
The characters you can enter are "A" through "Z," "0" through "9," and the "-" character. You can enter up to 15 characters, including spaces.

6

NAME	◀▶
SAMPLE_	↵

Press **▲** **▼** to enter a character.
Enter the following characters in the same way.
When entries are completed, press **ENTER** to enable the setting.

7



Press   in this order to go back to the original screen.

Description

This assigns a name to a saved preset. Using media names may aid recognition and clarity.

The characters you can enter are "A" through "Z," "0" through "9," and the "-" character. You can enter up to 15 characters, including spaces.

Fully Utilizing the Correction Function

Correcting for Misalignment in Bidirectional Printing

Procedure

1 Press **MENU**.

2 

Press **▼** several times to display the left figure.
Press **▶**.

3 

Press **ENTER**.

A test pattern is printed.

When printing is completed, press **▼** **▶** in this order.

4 

Press **◀** **▶** to select a select [1] or [2].

5 

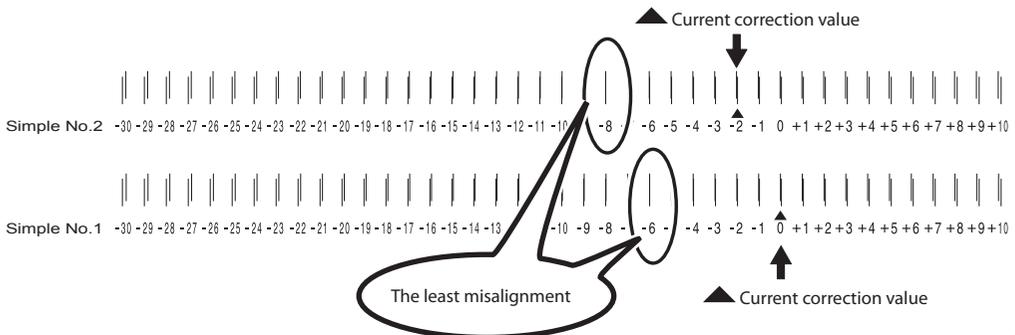
Press **▲** **▼** to select a correction value.

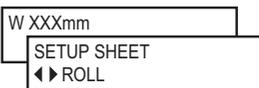
Select a correction value for "Simple No.1" in 1 and a correction value for "Simple No.2" in 2.

Press **ENTER** to enable the setting.

To decide a Correction Value

Choose the value that produces the least misalignment of 2 lines.
When wavering between two numbers, select half value.



6 

Press **MENU** **◀** in this order to go back to the original screen.

Description

This machine prints by the bidirectional mode (in which the print heads perform printing during both their outbound pass and return pass). This printing method is called "Bidirectional Printing." This method offers the advantage of being able to shorten output times, but subtle misalignment occurs during the outbound and return passes. The procedure to correct this and eliminate misalignment is "Bidirectional Correction." This misalignment varies according to the print-head height and the thickness of the media, so we recommend performing correction to match the media you're using.

Correcting for Misalignment in Bidirectional Printing More Precisely

When further correction is required, such as when adjustment made using [SIMPLE SETTING] does not enhance printing, use [DETAIL SETTING] to make corrections.

For information on operations, refer to page 59 "Performing the Initial Adjustment (Correcting for Misalignment in Bidirectional Printing More Precisely)".

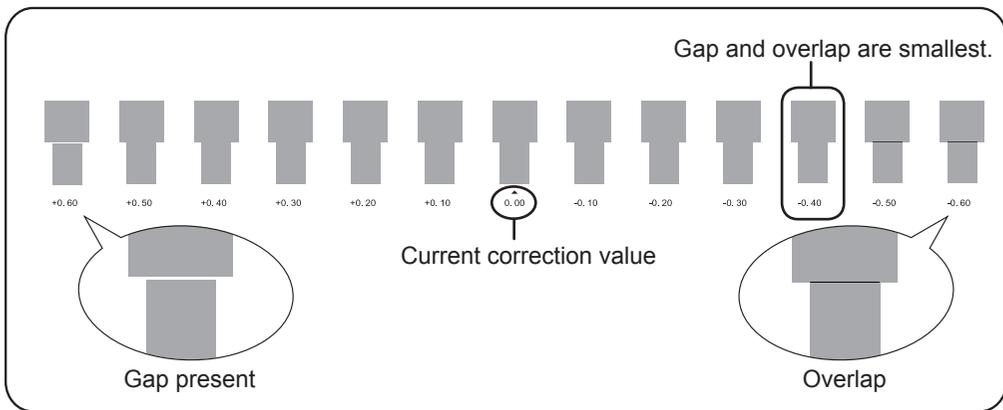
Alleviating Horizontal Bands and the Like (feed correction function)

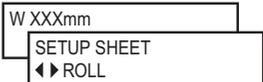
Procedure

- 1 When the roll media is used, check that no sagging is found on the media.
- 2 Press **MENU**.
- 3  Press **▼** several times to display the left figure. Press **▶**.
- 4  Press **ENTER**. A test pattern is printed. When printing is completed, press **▼** **▶** in this order.
- 5  Press **▲** **▼** to select a correction value. Press **ENTER** to enable the setting.

To decide a correction value

Select the value to make the upper/lower rectangular gap and overlap smallest.



- 6  Press **MENU** **◀** in this order to go back to the original screen.

Description

The movement distance of media experiences subtle changes due to the thickness of the media . When the movement distance becomes discrepant, horizontal stripes are more likely to occur during printing. We recommend performing correction to match the media you're using. Repeat the process of printing a test pattern and entering a correction value several times to find the optimal value.

You can also make this setting on the RIP software computer (by, for example, choosing the media type in the software RIP you are using). When you have made the setting on the software RIP, the software RIP's setting is used and the printer's setting is ignored.

Default Setting

[SETTING]: 0.00%

Accommodating to the Types and Condition of Media

Adjusting the Print-Head Height to Match Media Thickness

Procedure

1 Press **MENU**.

2

MENU	◀▶
HEAD HEIGHT	▶

Press **▼** several times to display the left figure.
Press **▶**.

3

HEAD HEIGHT	◀
MIDDLE ▶ HIGH	↵

Press **▲** **▼** to select an item.

HIGH: Use this setting when using media that may rise up.

MIDDLE: Use this setting normally (recommended).

LOW: Use this setting when you want to print small text at high resolution.

* When "HIGH" or "LOW" is selected, print quality may be affected.

See "Description" for more information.

Press **ENTER** to enable the setting.

Description

When using media that is likely to rise up, note that the media may contact the print heads. When you are using such media, adjust the print-head height to "HIGH."

When the print-head height is set to "HIGH", printing may be coarse and print quality may be affected. If this happens, refer to the pages indicated below.

- ☞ P. 119, "Correcting for Misalignment in Bidirectional Printing"
- ☞ P. 120, "Correcting for Misalignment in Bidirectional Printing More Precisely"
- ☞ P. 129, "Preventing Soiling of the Media and Dot Drop-out"

Select "LOW" when you want to print small text at high resolution. However, note that because you cannot use the media clamps, the media may rise up and contact the print heads.

Default Setting

[HEAD HEIGHT]: MIDDLE

Using Transparent or High Gloss Media

POINT!

Transparent media can be treated as opaque media by affixing an opaque sheet to the reverse side of the media.

When using transparent rigid media such as acrylic media, an opaque sheet, such as a protective sheet, may be affixed to the reverse side of the rigid media. The opaque sheet is not peeled off and the media will be treated as opaque media, therefore the settings described here are not necessary.

1. Set the media type to "CLEAR."

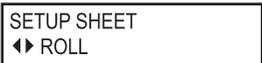
1 Press **MENU**.

2 

Press **▼** several times to display the left figure.
Press **▶** twice.

3 

Press **▲** **▼** to select "CLEAR."
Press **ENTER** to enable the setting.

4 

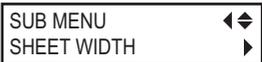
The settings are changed and the screen shown in the figure appears.

2. Set the media width.

1 Press **MENU**.

2 

Press **▼** several times until the screen shown on the left appears.
Press **▶**.

3 

Press **▼** several times until the screen shown on the left appears.
Press **▶**.

4 

Press **▼** **▲** and select a value.

Setting range

- Roll media: 210 to 1625 mm (8.3 to 64 inches)
- Rigid media, Sheet media: 250 to 1625 mm (9.8 to 64 inches)

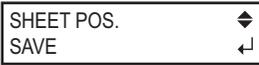
Press **ENTER** to enable the setting.

5 

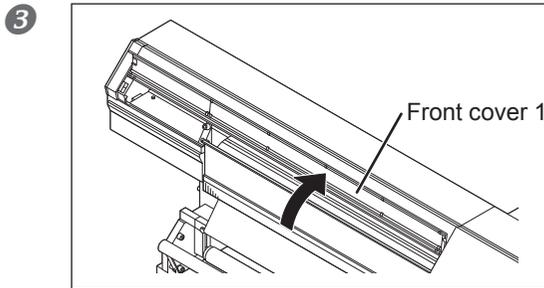
Press **◀** to return to the previous screen.

3. Set the position of the right edge of the media.

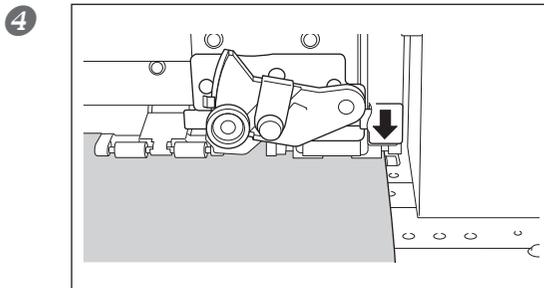
1 Press .

2  SHEET POS. SAVE

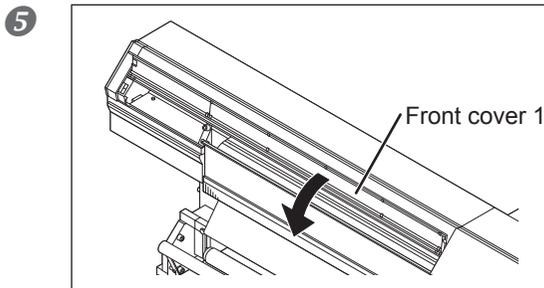
Press . The print heads move to the position now set.



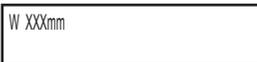
Open the front cover 1.



Press   to move the point of the arrow to the right edge of the media, as shown in the figure on the left.



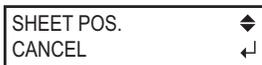
When the position has been set, close the front cover 1. Press  to enable the setting.

6  W XXXmm

Press   in this order to go back to the original screen.

Description

When using transparent media or opaque, high-gloss media, the width and loading position cannot be read automatically. Therefore they must be set manually. If they are set incorrectly, ink may be applied where there is no media.



To quit making settings at the [SHEET POS.] menu item, use to select "CANCEL," then close the front cover 1 and press .

Note that to keep the print heads from drying out, the [SHEET POS.] menu item ends automatically after a certain interval, even if you're still making settings there.

The settings for the media width and start position made here are effective only when [SHEET TYPE] is set to "CLEAR." Selecting "OPAQUE" disables the settings, although the setting values are saved in memory. Choosing "CLEAR" again enables the values set previously.

When using transparent media or opaque, high-gloss media, the machine cannot detect the edge of the media, causing the machine to continue printing even if the media runs out. Therefore when using these types of media, make sure to confirm the size of the print data and the amount of media remaining. To cancel printing, press .

Default Setting

[SHEET TYPE]: OPAQUE
[SHEET WIDTH]: 1625mm (64 inches)

Expanding the Printing Area by Reducing the Margins

Procedure

1 Press .



Press several times until the screen shown on the left appears.
Press .



Press several times until the screen shown on the left appears.
Press .



Press to select "5 mm (3/16 inch)."
Press to enable the setting.



A type of media is displayed.

When "SHEET SETUP" is set to any value other than "RIGID," the screen shown on the left appears and setting is complete.

When "SHEET SETUP" is set to "RIGID," proceed to the next step.

5 Press **MENU**.



Press **▼** several times until the screen shown on the left appears.

Press **▶**.



Press **▼** several times until the screen shown on the left appears.

Press **▶**.



Press **▲** **▼** to select "25 mm (16/16 inch)."

Press **ENTER** to enable the setting.

Only available when "SETUP SHEET" is set to "RIGID".

Description

The "SIDE MARGIN" setting determines the distance from the left or right media clamp to the corresponding left or right edge of the printing area. You can select "5 mm (3/16 inch)," "10 mm (6/16 inch)," or "25 mm (16/16 inch)." Setting this to "5 mm (3/16 inch)" lets you expand the printing area.

Note, however, that when you're using transparent media, setting this to "5 mm (3/16 inch)" may result in printing on top of the media clamps.

The "FRONT MARGIN" setting determines the distance from the front edge of the rigid media to the printing area. You can select "5 mm (3/16 inch)," "10 mm (6/16 inch)," or "25 mm (16/16 inch)." Setting this to "5 mm (3/16 inch)" lets you expand the printing area.

☞ P. 166, "Printing Area"

Default Setting

[SIDE MARGIN]: 10mm (6/16 inch)

[FRONT MARGIN]: 10mm (6/16 inch)

Using the Media Easy to be Winkled / Hard to be Fed

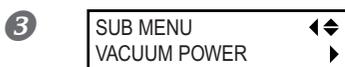
Procedure

1 Press **MENU**.



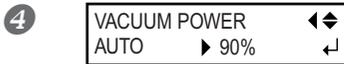
Press **▼** several times to display the left figure.

Press **▶**.



Press **▼** several times to display the left figure.

Press **▶**.



Press to select a value.
0 to 100%

A larger value produces a larger suction force. For the media easy to be loose due to warping or wrinkling, increase of the suction force may help correct the problem. When the media is flimsy and cannot move smoothly, reduction of the suction force may correct such the problem.

AUTO

The suction force is automatically adjusted to the optimal level for the media width.

Press to enable the setting.



Press in this order to go back to the original screen.

Description

The platen uses suction to grip the media and keep it stable. The suction force can be adjusted corresponding to the mature and condition of the media.

You can also make this setting on the RIP software computer. When you have made the setting on the software RIP, the software RIP's setting is used and the printer's setting is ignored.

Default Setting

[VACUUM POWER]: AUTO

Speeding Up Output for Narrow Media

Procedure

1 Press .



Press several times to display the left figure.
Press .



Press several times to display the left figure.
Press .

4



Press **▲** **▼** to select an item.
SHEET

"SHEET" matches the range of print heads movement to the width of the media.

OFF

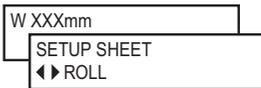
"OFF" matches the range of print heads movement to the output data. Movement is limited to the minimum amount necessary, and this can be expected to yield the fastest output. Note, however, that because the speed of media movement is no longer constant, colors may be uneven.

FULL

This makes the speed of media movement constant at all times and produces the most stable output result.

Press **ENTER** to enable the setting.

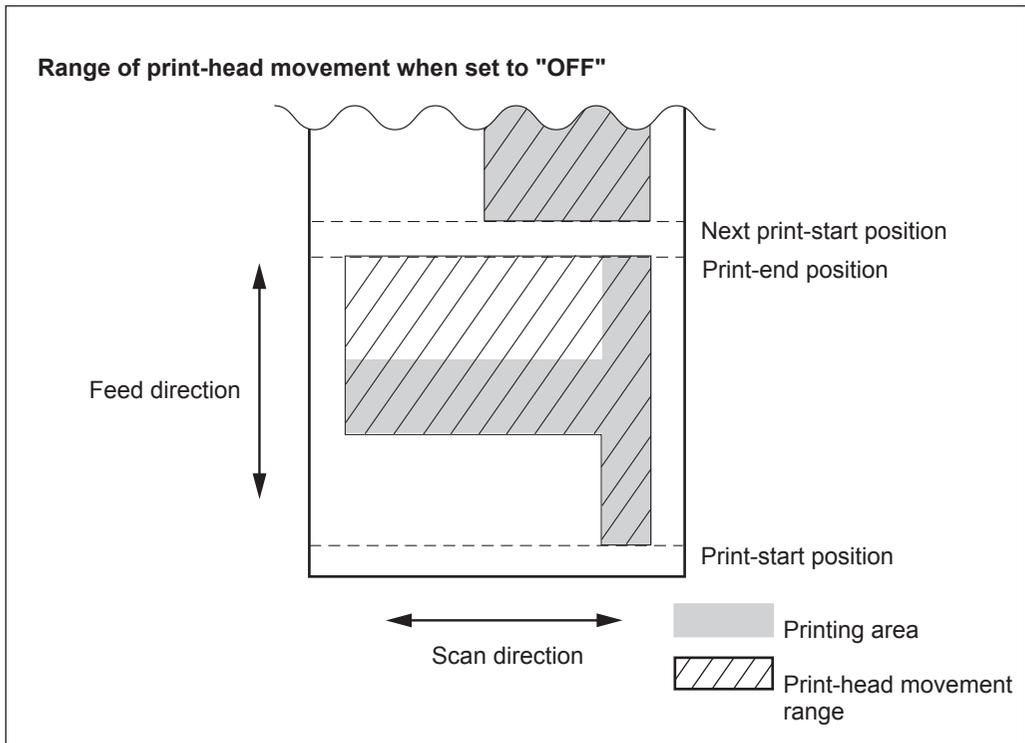
5



Press **MENU** **◀** in this order to go back to the original screen.

Description

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



Default Setting

[FULL WIDTH S]: FULL

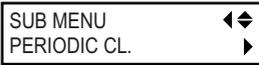
Preventing Soiling of the Media and Dot Drop-out

Procedure

1 Press **MENU**.

2 

Press  several times to display the left figure.
Press .

3 

Press  several times to display the left figure.
Press .

4 

Press   to select an item.
PAGE

Automatic cleaning is performed every time before printing starts.

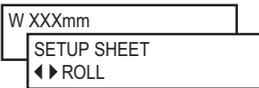
5 to 990 min

Automatic cleaning is performed when the cumulative printing time reaches the value you set here.

NONE

Automatic cleaning is not performed.

Press  to enable the setting.

5 

Press   in this order to go back to the original screen.

Description

In the following cases, Ink tends to collect on the surface of the print heads. Under some conditions, this ink may be transferred to the media or cause dot drop-out.

- When you use media prone to buildup of static charge.
- When the ambient temperature is low.
- When the print-head height is set to "HIGH."

Selecting "PAGE" or a value from "5 min" to "990 min," the ink buildup is removed before or during printing while printing is performed. Note, however, that using "PAGE" or a value from "5 min" to "990 min," results in longer printing times.

Default Setting

[PERIODIC CL.]: NONE

Printing with Crop Marks

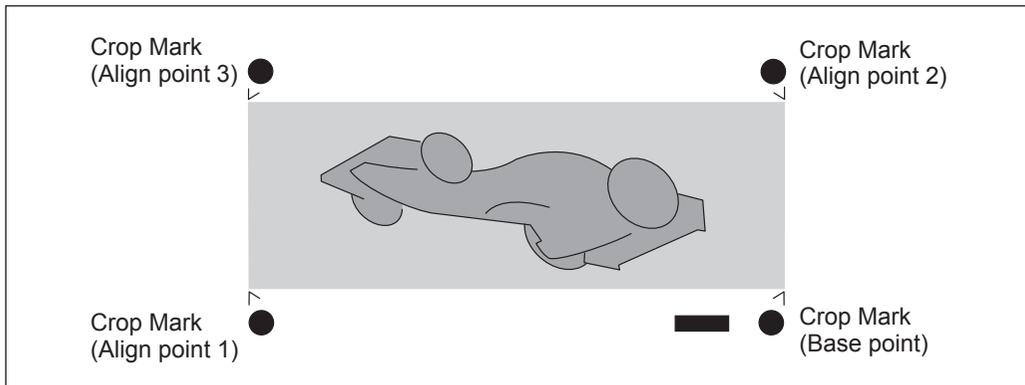
Printing with Crop Marks

Use your software RIP to make the settings for printing crop marks. For information on how to make the setting, refer to the documentation for the software RIP you're using.

IMPORTANT!

Alignment marks and symbols drawn using a graphics program cannot be used as crop marks.

The crop marks are printed as shown in the figure.



Switching the Ink Type (EUV ← → EUV3)

Method for Switching the Ink Type (EUV ← → EUV3)

This operation requires four unused SOL INK cleaning cartridges. Have these on hand before you start.

Important

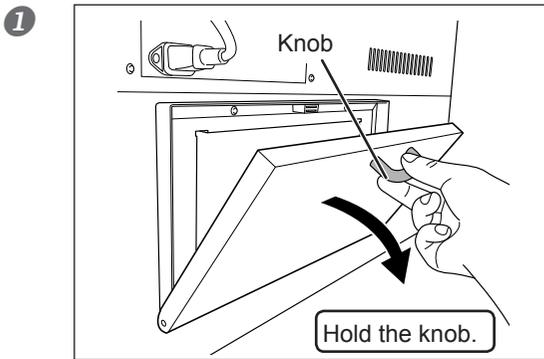
➤ You can only switch the ink type*¹ between EUV ink and EUV3 ink.

➤ You cannot switch the ink mode.*²

*¹ Ink type: Indicates the type of ink that is used. Examples include EUV ink and EUV3 ink.

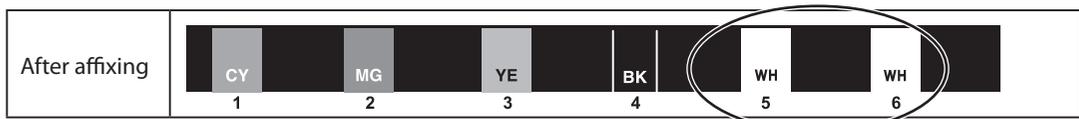
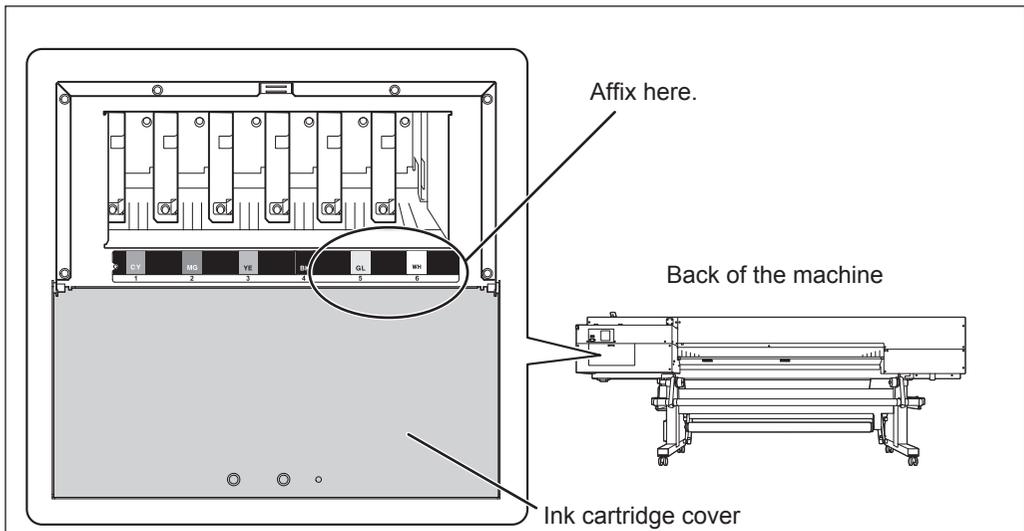
*² Ink mode: Indicates the combination of the ink colors that are used. Examples include white mode and gloss mode; the name of the special color used is included in the ink mode.

1. Affixing the cartridge-slot labels.



Open the ink cartridge cover.

2 If  is not affixed, affix it to the location shown in the figure.



2. Drain the ink and wash the interior.

IMPORTANT!

Insert each color ink cartridge into the slot labeled with the matching color. If you insert wrong cartridges when filling ink, the condition cannot be restored easily. Contact your authorized Roland DG Corp. dealer or us., if you filled ink with wrong cartridges inserted.

1 Press **MENU**.

2 

Press **▼** several times until the screen shown on the left appears.

Press **▶**.

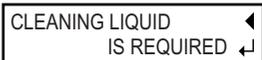
3 

Press **▲** several times until the screen shown on the left appears.

Press **▶** **▲** in this order.

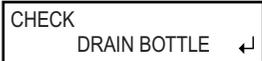
4 

Press **ENTER**.

5 

Make sure the cleaning liquid is ready.

Press **ENTER**.

6 

Discard the discharged fluid in the drain bottle.

Be sure to discard the discharged fluid.

Press **ENTER**.

7 Thereafter, follow the on-screen instructions to carry out the operations.

After cleaning has finished, the sub power is automatically switched off.

⚠ WARNING

Never put discharged fluid or ink closed to fire.

Doing so may cause the blaze.

⚠ CAUTION

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

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

Store discharged fluid in a location not exposed to direct sunlight.

When temporarily storing discharged fluid in the included drain bottle, keep the drain bottle out of direct sunlight. Otherwise the discharged fluid may harden, making the drain bottle unusable.

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

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

3. Fill with ink.

1 Press the sub power button.

2 Select the ink type.

<When switching to EUV ink>



Press to display the left figure.

Press .

<When switching to EUV3 ink>



Press to display the left figure.

Press .

3 Thereafter, follow the on-screen instructions to carry out the operations.

After finishing the operation, close the ink cartridge cover.

IMPORTANT!

When you use Roland VersaWorks Dual

Be sure to perform the following operation after filling with ink. Otherwise, you cannot use VersaWorks Dual.

Procedure

1 Windows 10

① Click the [Start] () menu.

② Click [All apps].

③ Click [All Programs] (or [Programs]) > [Roland VersaWorks Dual] > [Initialize Application].

Windows 8.1

① Click on the [Start] screen.

② Click [Initialize Application] for Roland VersaWorks Dual.

Windows 7

① Click the [Start] () menu.

② Click [All Programs] (or [Programs]) > [Roland VersaWorks Dual] > [Initialize Application].

2 Click [Yes] when a confirmation message for initialization of the application appears.

3 Click [OK] when a completion message for initialization of the application appears

4 Start Roland VersaWorks Dual.

The [Printer Settings] window is displayed. This is because the connection with the printer is initialized by performing Initialize Application.

5 Make the settings of the printer.

☞ "Printer Connection and Settings" in "Roland VersaWorks Dual Installation Guide"

When you initialize the application, the settings of Roland@NET are initialized as well. Please make the settings again.

☞ "Making the Settings for Roland@NET" in "Roland VersaWorks Dual Installation Guide"

Chapter 6

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Output Operation Management

Printing a System Report

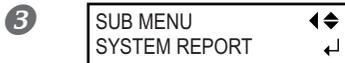
This prints system information, including a list of setting values.

Procedure

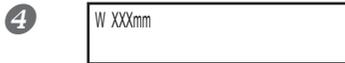
1 Press **MENU**.



Press **▼** several times to display the left figure.
Press **▶**.



Press **▼** several times to display the left figure.
Press **ENTER**.
Start printing.



Press **MENU** **◀** in this order to go back to the original screen.

Determining What Happens When Ink Runs Out

This lets you change, according to your purpose, the operation that takes place when an ink cartridge is empty.

Procedure

1 Press **MENU**.



Press **▼** several times to display the left figure.
Press **▶**.



Press **▲** several times to display the left figure.
Press **▶** twice.



Press **▲** **▼** to select.
"STOP": Printing pauses immediately when a cartridge becomes empty.
"CONT" (continue): Printing does not stop when a cartridge becomes empty. When a cartridge becomes empty, a warning beep sounds.
Press **ENTER** to enable the setting.



Press **MENU** **◀** in this order to go back to the original screen.

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To
Administrators

Description

When "STOP" is selected, printing pauses and so colors may be uneven. Ensure a sufficient amount of remaining ink before you begin printing.

When "CONT" is selected, printing does not stop even if ink runs out completely. To replace the cartridge, wait until printing ends or press **PAUSE** to pause printing.

Default Setting

[EMPTY MODE]: STOP

Displaying the Amount of Media Remaining

You can display how much of the media in use is left. First, you set the amount of media remaining, the amount remaining is displayed at the top menu until it reaches zero.

Procedure

1 Press **MENU**.

2 

Press **▲** several times to display the left figure.
Press **▶** and then **▼**.

3 

Press **▶**.

4 

Press **▲** **▼** to set the current amount of media remaining.
Press **ENTER** to enable the setting.

5 

Press **MENU** **◀** in this order to go back to the original screen.

This display is updated.



If setup has not been performed, the set value flashes.

Description

If you cancel the setup such as by removing the media or raising the loading lever, the amount remaining at that time flashes on the screen.

Because the amount of media remaining is not updated automatically when you change the media, redo the setting whenever you change the media. You can also make the setting display this menu automatically whenever you change the media. See the next section, "Making Sure to Verify the Setting for the Amount Remaining Every Time the Media Is Changed"

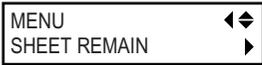
Note: The remaining amount that is displayed is only an estimate, and its accuracy is not assured.

Making Sure to Verify the Setting for the Amount Remaining Every Time the Media Is Changed

Set to display  every time when a media is changed.

Procedure

1 Press .

2 

Press  several times to display the left figure.

Press  and then .

3 

Press .

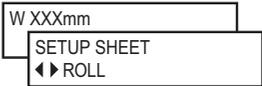
4 

Press   to select "ENABLE".

Press  to enable the setting.

If you set to "ENABLE," you must set the [SHEET TYPE] menu to "OPAQUE"

☞ P. 123, "Using Transparent or High Gloss Media"

5 

Press   in this order to go back to the original screen.

Description

Setting this menu to "ENABLE" can keep you from forgetting to redo the setting when you change the media. Be sure, however, also to set the [SHEET TYPE] menu (refer to P. 123, "Using Transparent or High Gloss Media") to "OPAQUE." When [SHEET TYPE] is set to "CLEAR," [SHEET REMAIN] is not displayed automatically.

Default Setting

[AUTO DISPLAY]: DISABLE

Printing the Amount of Remaining Media

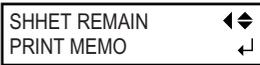
This prints the amount of media remaining that is displayed at the top menu.

Procedure

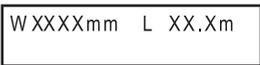
1 Press **MENU**.

2 

Press **▲** several times to display the left figure.
Press **▶**.

3 

Press **ENTER**.
Start printing.

4 

Press **MENU** **◀** in this order to go back to the original screen.

Description

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

Note, however, that continuing by performing the next output starts the output on top of the portion where the amount of remaining media is printed. After printing the amount remaining, then before you perform the next output operation, we recommend cutting off the media.

System Management of Printer

Setting for the Menu Language and the Units of Measurement

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

Procedure

- 1 Hold down **MENU** and switch on the sub power.
- 2  Use **▲** **▼** to select the display (menu) language.
Press **ENTER** to enable the setting.
- 3  Use **▲** **▼** to select the measurement unit for length.
Press **ENTER** to enable the setting.
- 4  Use **▲** **▼** to select to the measurement unit for temperature.
Press **ENTER** to enable the setting.

Default Setting

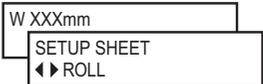
[MENU LANGUAGE]: ENGLISH

[LENGTH UNIT]: mm

[TEMP. UNIT]: °C

Setting the Interval until Activation of the Sleep Mode (Power Saving Function).

Procedure

- 1 Press **MENU**.
- 2  Press **▼** several times to display the left figure.
Press **▶**.
- 3  Press **▲** several times to display the left figure.
Press **▶** twice.
- 4  Use **▲** **▼** to make the setting.
Press **ENTER** to enable the setting.
- 5  Press **MENU** **◀** in this order to go back to the original screen.

Default Setting

[INTERVAL]: 30min

6

To
Administrators

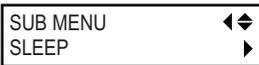
Deactivating the Sleep Mode (Power Saving Function)

Procedure

1 Press **MENU**.

2 

Press  several times to display the left figure.
Press .

3 

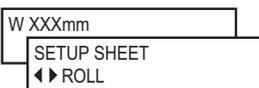
Press  several times to display the left figure.
Press  and then .

4 

Press .

5 

  to select "DISABLE."
Press  to enable the setting.

6 

Press   in this order to go back to the original screen.

Default Setting

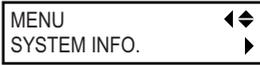
[SETTING]: ENABLE

Viewing Information about the System of This Machine

Note: For information on how to set up a network, refer to "Setup Guide."

Procedure

1 Press **MENU**.

2 

Press **▲** several times to display the left figure.

You can view the following information.

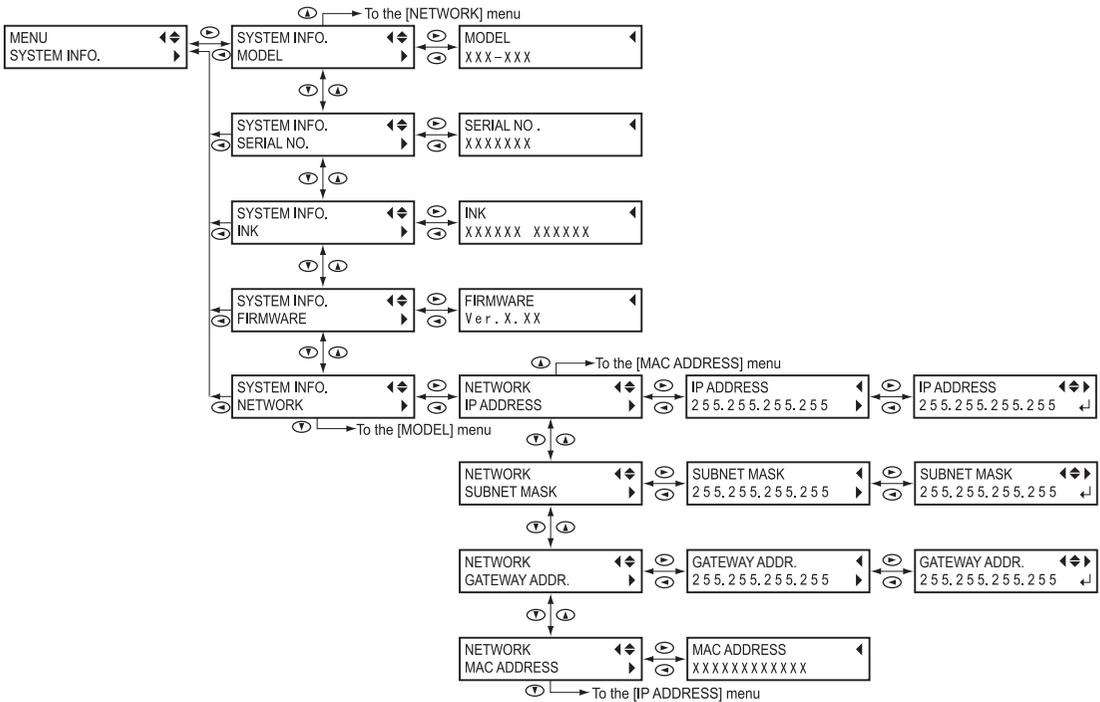
[MODEL]: Model name

[SERIAL NO.]: Serial number

[INK]: Ink type

[FIRMWARE]: Firmware version

[NETWORK]: Network configuration (IP address, etc)



6

To
Administrators

Returning All Settings to Their Initial Values

This menu returns all settings to the same as their factory defaults. However, the settings for [MENU LANGUAGE], [LENGTH UNIT], and [TEMP. UNIT] are not returned to the factory defaults.

Procedure

1 Press **MENU**.

2 

Press  several times to display the left figure.

Press .

3 

Press  several times to display the left figure.

Press  to execute.

Chapter 7

Read this chapter whenever you face a problem. (FAQ)

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The Machine Doesn't Run

The Printer Unit Doesn't Run

Is the power switched on?

Switch on the printer's main power, then press the sub power switch and make sure the sub power switch lights up.

☞ P. 38, "Switch On"

Is illuminated?

Output is not performed when  is not illuminated. Pull back the loading lever, close the front cover 1, and press .

Is the cover open?

Close front cover 1, front cover 2, side cover, and maintenance cover.

Is the top menu displayed?

Top menu



If the top menu isn't displayed, output doesn't start even when data is sent from the computer. To go to the top menu, press , then press .

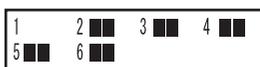
☞ P. 69, "Getting Ready to Receive Data from a Computer"

Is illuminated?

When  lights up, operation is paused. To resume, press .  goes dark and outputting resumes.

☞ P. 71, "Pausing and Canceling Output"

Has ink run out?



When printing data is sent while the screen shown in the figure is displayed, a message appears and a warning beep sounds. At the same time, operation pauses. When the ink cartridge is replaced with a new one, output or cutting starts.

☞ P. 87, "How to Replace Ink Cartridges"

☞ P. 136, "Determining What Happens When Ink Runs Out"

Is a message displayed on the screen?

☞ P. 160, "A Message Appears"

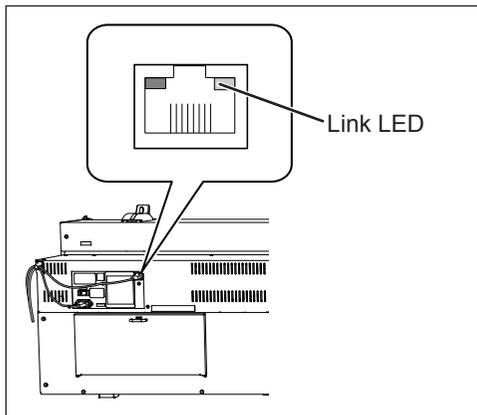
☞ P. 162, "An Error Message Appears"

Is the cable connected?

Connect the cable securely.

☞ "Setup Guide"

Is the Link LED lighted?



If the Link LED for the Ethernet connector is not lighted, it means that a correct connection to the network has not been made. Make sure the network routing is suitable. Try connecting the computer and the machine to the same hub, or connecting them directly using a crossover cable. If this makes it possible to perform output, it means the problem is in the network itself.

Are the network settings correct?

If output is impossible even though the link LED is on, make sure the IP address and other settings are correct. The settings on both the machine and the computer must be appropriate. Redo the settings, checking to ensure that the IP address doesn't conflict with the IP address for another device on the network, that the port setting for the software RIP specifies the IP address set on the machine, that the settings have no typing errors, and for other such problems.

- ☞ "Setup Guide,"
- ☞ P. 142, "Viewing Information about the System of This Machine"

Did the software RIP end abnormally?

Make sure the software RIP is running correctly, then switch the sub power switch off and back on.

- ☞ "Roland VersaWorks Dual Installation Guide"

Is the temperature of the room too low?

Use the machine in an environment where the temperature is 20 to 32°C (68 to 90°F).

Cannot cut off the media

Is the separating knife mounted?

If the separating knife is not mounted, you cannot cut off the media.

☞ P. 111, "Replacing the Separating Knife"

Is "SHEET SETUP" set to "RIGID"?

When "RIGID" is selected, the separating knife cannot be used to cut off the media.

The Media Take-up System Doesn't Run

Is the take-up unit cable connected?

Connect the take-up unit cable to the machine. To perform take-up automatically when output is in progress, also make the setting for the AUTO switch.

☞ "Setup Guide,"

☞ P. 77, "Use Conditions of the Media Take-up System"

Is the auto switch in the [OFF] position?

Change the auto switch in accordance with the direction of taking up the media.

Attractive Printing is Impossible

Printed Results Are Coarse or Contain Horizontal Stripes

Do the print heads show dot drop-out?

Carry out a printing test and make sure no dot drop-out occurs. If dot drop-out is present, perform cleaning of the print heads.

- ☞ P. 67, "Printing Tests and Normal Cleaning"
- ☞ P. 95, "When Normal Cleaning Is Not Effective"
- ☞ P. 104, "The Concentration and Dot Drop-Out of the White Ink"

Is the print-head height appropriate?

When [HEAD HEIGHT] is set to [HIGH], the print is rougher than when it is set to [MIDDLE] or [LOW]. Normally set to "MIDDLE", except when using media that is likely to rise up. (When it is set to [LOW], the ability for the media to pass through the machine may be affected because the media clamps cannot be used.)

- ☞ P. 122, "Adjusting the Print-Head Height to Match Media Thickness"

Have you carried out feed correction?

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

- ☞ P. 120, "Alleviating Horizontal Bands and the Like (feed correction function)"

Have you carried out bidirectional correction?

When you are performing bidirectional printing, use the [ADJUST BI-DIR] menu item to carry out correction. The optimal adjustment value may vary, depending mainly on the thickness of the media. Set or select an adjustment value that is suited to the media. When further correction is required, such as when adjustment made using [SIMPLE SETTING] does not enhance printing, use [DETAIL SETTING] to make correction.

- ☞ P. 119, "Correcting for Misalignment in Bidirectional Printing"
- ☞ P. 120, "Correcting for Misalignment in Bidirectional Printing More Precisely"

Is the print mode suitable?

Try a higher-quality print mode. Depending on the media, uneven colors may occur in high-quality print modes, and the results are also greatly affected by the settings of the software RIP (such as the selected color profile). Make settings suited to the media you're using.

Is the printer installed in a level and stable location?

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

Is the printer installed in a location out of direct sunlight?

Never install in a location exposed to direct sunlight. Doing so may result in dot drop-out or other problems with reduced printing quality, or may even result in malfunction.

Is the media loaded and set up correctly?

If the media is not loaded and set up correctly, media feed may not be smooth, or printing may be adversely affected. Make sure the media is loaded and set up correctly.

- ☞ P. 39, "Loading Media"
- ☞ P. 155, "Media Feed is Not Smooth"

Is the print side of the rigid media warped with wrinkles or waves more than 0.5 mm (0.02 inches) high?

Use VersaWorks Dual to set unidirectional printing. If the problem is still not resolved, the wrinkles or waves are too large. Use media with no wrinkles or waves in it.

- ☞ P. 58, "Configuring Unidirectional Printing (VersaWorks Dual)"

Are the settings for the [PRESET] menu item appropriate?

If the settings selected with the [PRESET] menu item are not suitable for the type of media, printing may be adversely affected. Choose settings optimized to the media you're using.

- ☞ P. 61, "Setup of Media"
- ☞ P. 116, "Fully Utilizing Preset Function"

Colors Are Unstable or Uneven

Did you shake the ink cartridge 50 times (about 15 seconds) before installing them?

shake new ink cartridge 50 times (about 15 seconds) before you install them.

Did you shake the white ink cartridges gently before installing them?

The ingredients in white ink tend to settle. Prolonged use of this machine may cause the concentration of the white ink to decrease.

- ☞ P. 90, "Maintenance of Ink Cartridges"
- ☞ P. 104, "The Concentration and Dot Drop-Out of the White Ink"

Is the media wrinkled?

If the media is wrinkled and comes loose from the platen, colors may be uneven or printing quality may suffer.

- ☞ P. 155, "Media Feed is Not Smooth"

Was printing paused partway through?

When printing is paused, the coloring at the seam may be altered when printing resumes. Avoid pausing printing. By default, printing pauses when ink remaining inside the machine runs out. Before you perform lengthy printing, check the amount of ink remaining in the ink cartridges. Printing may also pause when data is not sent from the computer quickly enough. We recommend not performing any other tasks with the computer while printing is in progress.

Is the printer installed in a level and stable location?

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

Are the operating parameters set to appropriate values?

Depending on the settings for such menu items as [FULL WIDTH S] and [PERIODIC CL.], uneven colors may occur. If the settings have been changed, try restoring them to their default values.

- ☞ P. 127, "Speeding Up Output for Narrow Media"
- ☞ P. 129, "Preventing Soiling of the Media and Dot Drop-out"

Is the printer being used in a location subject to severe changes in the operating environment?

Large fluctuations in temperature or humidity while printing is in progress may cause the colors to change partway through. When you're performing printing, use the machine in a location where temperature and humidity are stable.

Is the relative humidity of the environment 35% or less? Is static electricity likely to form in the environment?

Keep the machine's environment between 35% and 80% when operating the machine. Static electricity is more likely to form at lower temperatures, and the pinch rollers may become charged with static electricity, causing inconsistent colors. If the temperature of the environment is not the problem, use a device to remove the static electricity charge from the pinch rollers. If there is a high degree of static electricity, keep the operating environment at a relative humidity of 50% or higher.

Are the settings for the [PRESET] menu item appropriate?

If the settings selected with the [PRESET] menu item are not suitable for the type of media, printing may be adversely affected. Choose settings optimized to the media you're using.

- ☞ P. 116, "Fully Utilizing Preset Function"

The Media Becomes Soiled or Damaged When Printed

Do the print heads contact the media?

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

- ☞ P. 122, "Adjusting the Print-Head Height to Match Media Thickness"
- ☞ P. 155, "Media Feed is Not Smooth"

Are the print heads dirty?

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

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

If this happens, perform the manual cleaning. We recommend carrying out periodic cleaning of the print heads.

- ☞ P. 97, "Maintenance that Should Be Performed More Than Once a Month"
- Too Low Humidity.

Use this machine in the environment of 35 to 80 %RH (non condensation).

Are the pinch rollers, media clamps, grit rollers, or the rubber covers on the front of the machine or on the front cover 2 dirty?

Periodically clean them.

- ☞ P. 93, "Cleaning"

Are the pinch rollers positioned correctly on top of the rigid media?

Adjust the position of the media so that the pinch rollers are completely on top of the media. If the pinch rollers are not completely on top of the media, the media will still pass through the machine, however, depending on the characteristics of the media, an imprint from the pinch rollers may be left behind or the media may be dented.

- ☞ P. 49, "Loading Rigid Media"

Media Jam Occurs

The Media Jams

If an error message is displayed because the media has jammed, immediately correct the problem. Failure to do so may damage the print heads.

- P. 164, "[MOTOR ERROR TURN POWER OFF]"

Is the media warped or wrinkled?

Many factors can cause warping or wrinkling. Refer to the following and correct the problem.

- P. 155, "Media Feed is Not Smooth"

Is the print-head height too low?

Try raising the print-head height. Media may inevitably warp or wrinkle slightly, so adjust the print-head height to take this into account.

- P. 122, "Adjusting the Print-Head Height to Match Media Thickness"

The Media Cannot Be Taken Up Smoothly

The Media Cannot Be Taken Up Smoothly

Is media feed unstable?

Various factors can make media feed unstable. Refer to the following and correct the problem.

☞ P. 155, "Media Feed is Not Smooth"

Is the paper tube installed correctly?

Securely insert the paper tube onto the end caps. If the paper tube is not attached correctly, it may spin without traction and fail to take up the media.

☞ Setup Guide

Is the paper tube bent or sagging?

Media cannot be taken up smoothly when the paper tube is bent or sagging.

Are you using the included paper tube?

For the paper tube, use the included item. Using something other than the included item may result in spinning without traction or other problems that impede media take-up.

☞ P. 76, "About the Paper Tube"

Media Feed is Not Smooth

A variety of problems can occur if the media feed is not smooth. This can cause such problems as poor printing quality, contact with the media by the print heads, misaligned positioning, or media jams. Take action as follows.

Media Wrinkles or Shrinks

Is the media loaded and set up straight and securely?

Feed is not smooth when the media is not straight or is tensioned unevenly on the left and right. Reload the media.

☞ P. 39, "Loading Media"

Was loaded media allowed to stand for some time?

If media is loaded and left for several hours, it may wrinkle or shrink. When printing is finished, remove the media.

Are the media clamps mounted?

Be sure to mount the media clamps when printing on the media which is less than 0.5mm (0.02 inch) thick.

Is the temperature of room too low?

Use this machine in an environment having an ambient temperature of 20 to 32°C (68 to 90°F). If used in the environment where the temperature is below 20°C, the media may get wrinkled depending its type or width.

Is the using media deflected?

If using the deflected media, it cause winkle of the media.

Is the humidity of the room too high?

Use this machine in the environment of 35 to 80 %RH (non condensation).

Media Feed Is Not Straight

Is the media loaded and set up straight and securely?

Feed is not smooth when the media is not straight or is tensioned unevenly on the left and right. Reload the media.

☞ P. 39, "Loading Media"

Are the pinch rollers positioned on top of the media?

If the pinch rollers are not positioned correctly on top of the media, the media will not feed properly. Load the media again.

☞ P. 49, "Loading Rigid Media"

Is the media severely warped?

Media cannot be fed smoothly when it is warped. Do not use severely warped media.

☞ P. 36, "Usable Media"

Media Feed Is Not Smooth / Media is Not Fed

Do the media or the shafts strike some other object?

Make sure the media and the shafts do not touch anything else. This may affect print, even when feed appears to be smooth.

☞ P. 39, "Loading Media"

Are the grit rollers dirty?

Check to make sure the grit rollers are free of buildup of foreign material such as media scraps.

☞ P. 93, "Cleaning"

Is the media severely warped?

Media cannot be fed smoothly when it is warped. Do not use severely warped media.

☞ P. 36, "Usable Media"

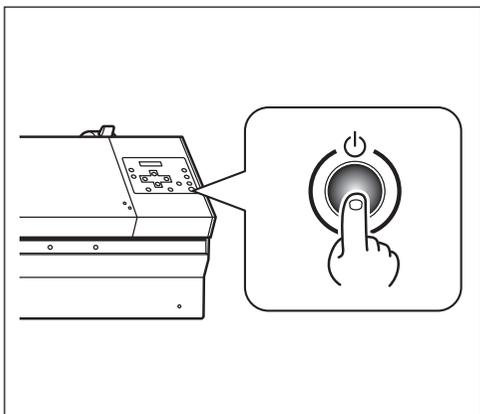
Is the media caught on the grooves of the platen or anywhere else?

The front edge of the media may become caught on the grooves of the platen or other places. In this case, flatten out the bends or wrinkles, or change the orientation of the media. If the problem persists, use different media.

The Print Heads Stopped Moving

If the print-head carriage stops over the platen, take action immediately to prevent the print heads from drying out.

What to Do First



Switch the sub power off, then back on again.
If the media is jammed, then also remove the media.
If the print-head carriage moves to the standby position (the right side of the main unit), it means the operation has ended successfully.

If the print heads still do not move

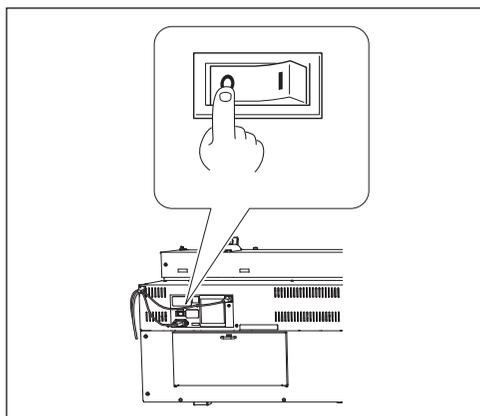
Try switching off the main power, then again switching on the main power, followed by the sub power.

If the Print Heads Still Do Not Move

If the print heads still do not move, carry out the following emergency response measure, then contact your authorized Roland DG Corp. dealer.

Procedure

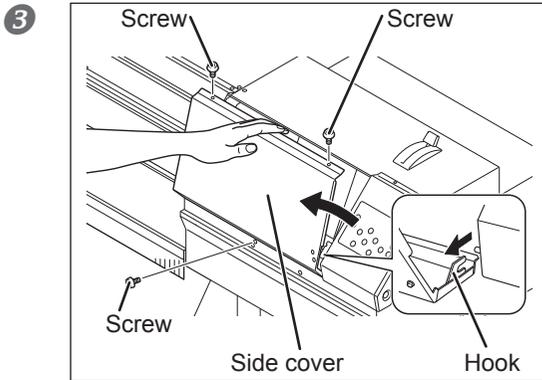
1



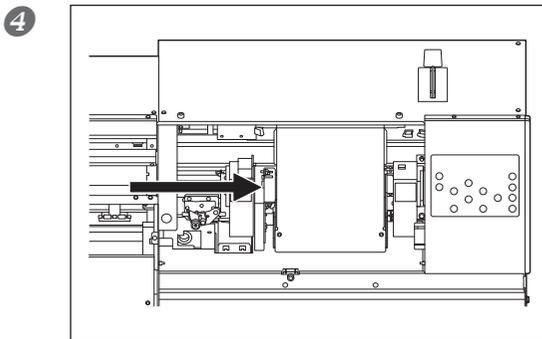
Switch off the main power.

2

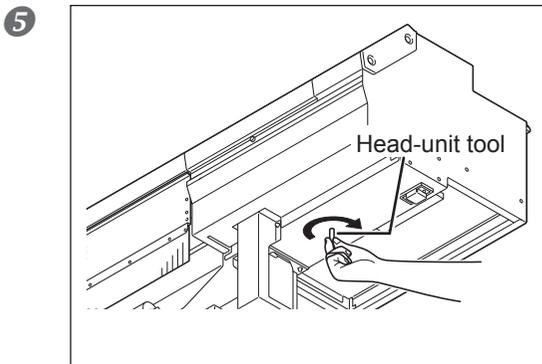
Open the front cover 1.



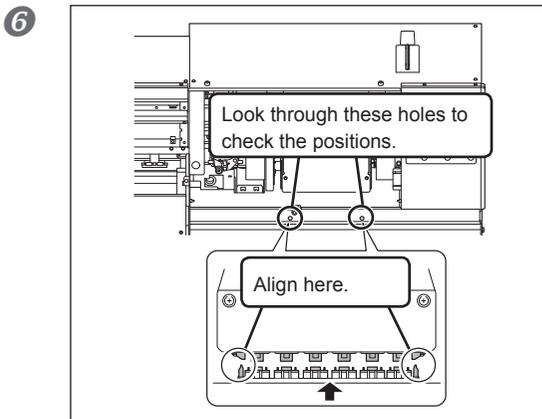
Detach the side cover.



Gently move the print heads by hand as far as the standby position.

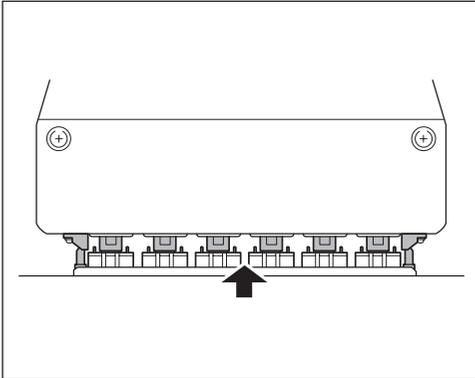


Insert the head-unit tool into the hole at the bottom of the machine and turn gently. The cap unit rises.



Make the guides at the edges of the print heads line up with the guides at the edges of the cap unit.

7



Turn the head-unit tool until the print heads make contact with the cap unit.

8

When the print heads make contact with the cap unit, turn the head-unit tool one or two turns more.

Make sure the print heads are capped tightly.

If the cap unit does not reach the print heads, contact your authorized Roland DG Corp. dealer.

A Message Appears

These are the main messages that appear on the machine's display to prompt correct operation. They do not indicate any error. Follow the prompts and take action accordingly.

[1 ■ 2 ■ 3 ■ 4 ■ 5 ■ 6 ■]

Only a small amount of ink remains. Replace the cartridge indicated by the flashing number with a new cartridge.

[PRESS THE POWER KEY TO CLEAN]

This appears when the machine has been unused for about one month. Switch on the sub power once a month.

☞ P. 113, "When Not in Use for a Prolonged Period"

[CIRCULATING INK]

The white ink is being circulated inside the machine. This is automatically performed to clear the precipitation of the white ink. Wait until the displayed message changes.

[SET CARTRIDGE]

Insert the ink cartridge indicated by the flashing number. This message appears at times such as during ink cartridge replacement.

[REMOVE CARTRIDGE]

Remove the ink cartridge indicated by the flashing number. This message appears at times such as during ink cartridge replacement.

[CLOSE THE COVER (FRONT COVER, SIDE COVER or MAINTENANCE COVER)]

Close the front cover 1, front cover 2, side cover, maintenance cover. For safety, the print-head carriage does not operate while a cover is open.

[SET CL-LIQUID]

Insert the SOL INK cleaning cartridge indicated by the flashing number. This message appears at times such as during cleaning of the print heads.

[REMOVE CL-LIQUID]

Remove the SOL INK cleaning cartridge indicated by the flashing number. This message appears at times such as during cleaning of the print heads.

[END OF THE SHEET]

The trailing edge of the media was detected during operation. Press any button on the operation panel to clear the message. Load new media.

[SHEET NOT LOADED PRESS SETUP KEY]

Load media and press . This message appears when an attempt to perform a printing test was made while no media was loaded.

[INSTALL DRAIN BOTTLE]

Check whether the drain bottle is installed. Install the drain bottle, then press **ENTER**.

[CHECK DRAIN BOTTLE]

This appears when a certain amount of discharged fluid collects in the drain bottle. To clear the message, press **ENTER**. If this screen appears, go to the [DRAIN BOTTLE] menu and discard the discharged fluid in the bottle.

☞ P. 91, "Disposing of Discharged fluid"

[CAN'T SETUP]

This is displayed when the print heads may have contacted the media and media setup is interrupted. Adjust the print-head height and set up the media again.

☞ P. 56, "Enter the thickness of the rigid media." Procedure 3.

☞ P. 122, "Adjusting the Print-Head Height to Match Media Thickness"

[REMOVE MEDIA CLAMPS]

This appears when media cutoff is attempted without first removing the media clamps. The media cutoff starts when **ENTER** is pressed after the media clamps are removed. Pressing **◀** while this message is displayed quits cutoff.

[TIME FOR MAINTENANCE]

The time has come to perform the manual cleaning. After verifying, press **ENTER**.

☞ P. 98, "Performing Manual Cleaning"

[TIME FOR WIPER REPLACE]

It is time to replace the wipers. After verifying, press **ENTER**.

☞ P. 107, "Replacing the Wiper"

An Error Message Appears

This describes the error messages that may appear on the machine's display, and how to take action to remedy the problem. If the action described here does not correct the problem, or if an error message not described here appears, contact your authorized Roland DG Corp. dealer .

[TURN POWER OFF AND SET INK MODE]

The sub power is turned on with the ink mode unset.

Turn off the sub power. Select the ink mode, and then turn on the sub power.

☞ "Setup Guide"

[CAN'T PRINT CROP CONTINUE?]

The size of the data including the crop marks is larger than the printing or cutting area of the loaded media.

To continue performing output without correcting this, press **ENTER** . At this time, the portion extending beyond the printing or cutting area and the crop marks are not output. To stop output, stop sending data from the computer, then raise the loading lever. Make the printing or cutting area wider, such as by replacing the media with a larger piece of media or by changing the positions of the pinch rollers, then send the data again.

The size of the data being output is too small.

Make the scanning-direction (movement direction of print heads) size of the data at least 65 mm (2.6 in). To continue performing output without correcting this, press **ENTER** . At this time, the data is output without printing the crop marks. To stop output, stop sending data from the computer, then hold down **SET UP** for one second or longer. Change the size of the data, then send the data again. There is no limitation in the size of the data in the media-feed direction.

[TEMPERATURE IS TOO HIGH **°C]

The temperature of the location where the machine is installed has risen above the ambient temperature at which the machine can operate.

Operation cannot be continued. Switch off the sub power. The displayed temperature is the current ambient temperature of the installation location. Bring the installed location to a temperature at which operation is possible (20 to 32°C) and allow the machine to come to room temperature, then turn on the power.

[SERVICE CALL xxxx]

An unrecoverable error occurred, or part replacement that must be performed by a service technician is required.

Note the number displayed, then switch off the sub power. After you switch off the power, inform your authorized Roland DG Corp. dealer of the number that appeared on the display screen.

[SHEET SET ERROR SET AGAIN]

SET UP was pressed even though no media is loaded.

Press any key to clear the error. Load media and pull back the loading lever, then press **SET UP**.

☞ P. 39, "Loading Media"

[SHEET TYPE] is set to "OPAQUE," but transparent media was loaded.

Flip the loading lever down to the rear, set the [SHEET TYPE] menu item to "CLEAR" then reload the media.

☞ P. 123, "Using Transparent or High Gloss Media"

The loaded media is too small.

Press any key to clear the error. Replace with media of usable size.

When [SHEET TYPE] is set to [OPAQUE] while using substrates with metallic or reflective characteristics, such as metallic film.

Move the loading lever to the rear, set [SHEET TYPE] to [CLEAR], and then set it again. When using substrates with metallic or reflective characteristics such as metallic film, light reflecting off the media prevents the machine from detecting the edge of the media. Therefore, treat these types of materials as transparent media when implementing settings.

[TEMPERATURE IS TOO LOW **°C]

The temperature of the location where the machine is installed has fallen below the ambient temperature at which the machine can operate.

Operation cannot be continued. Switch off the sub power. The displayed temperature is the current ambient temperature of the installation location. Bring the installed location to a temperature at which operation is possible (20 to 32°C) and allow the machine to come to room temperature, then turn on the power.

[DATA ERROR CANCELING...]

Output was stopped because a problem was found in the data received.

Operation cannot be continued. Check whether the data contains errors. Also, check for a problem with the connector cable or the computer, and redo the operation from the step of loading the media.

[PINCHROLL ERROR LOWER PINCHROLL]

SET UP was pressed without first lowering the pinch rollers.

Pull back the loading lever, then press **SET UP**.

The pinch rollers are lifted up during output.

Output is discontinued. Do not move the loading lever during output.

[WRONG CARTRIDGE]

A cartridge that cannot be used was installed.

Remove the cartridge to clear the error. Use a cartridge of the specified type.

[WRONG HEAD IS INSTALLED]

Unusable print heads are installed.

Switch off the sub power. After you switch off the power, inform your authorized Roland DG Corp. dealer.

[AVOIDING DRY-UP TURN POWER OFF]

The print heads were forced to standby position to prevent them from drying out.

Operation cannot be continued. Switch the sub power off, then back on. Opening the front cover while output is in progress causes an emergency stop. Never allow the print heads to remain in this state.

[MOTOR ERROR TURN POWER OFF]

A motor error occurred.

Operation cannot be continued. Switch off the sub power. Next, eliminate the cause of the error, then immediately switch on the sub power. If the machine is allowed to stand with the error uncorrected, the print heads may dry out and become damaged. This error may be caused by such factors as a mistake in loading the media, a media jam, or an operation that pulls the media with excessive force.

The media has jammed.

Carefully remove the jammed media. The print heads may also be damaged. Perform cleaning of the print heads, then perform a printing test and check the results.

The media was pulled with excessive force.

Excessive tension was applied to the media, and additional action is necessary to recover from this state. First, move the loading lever to the rear and adjust the media to create a small amount of slack, then switch on the sub power.

[CANCELED FOR MOTOR PROTECTION]

Either of the following menu items is to be started in a row within 10 minutes:

- PUMP UP
- HEAD WASH
- INK RENEWAL
- POWERFUL CLEANING

Press any key other than the sub power switch to cancel the error message. Allow the machine to stand for approximately 10 minutes before resuming operation. These menu items require the pump motor to turn for a long time. When performing these menu items in a row, take an interval of at least 10 minutes to prevent damage to the machine due to the overheating of pump motor.

However, you may continuously start "POWERFUL CLEANING" without an interval of at least 10 minutes. Doing so will not cause the error message to appear.

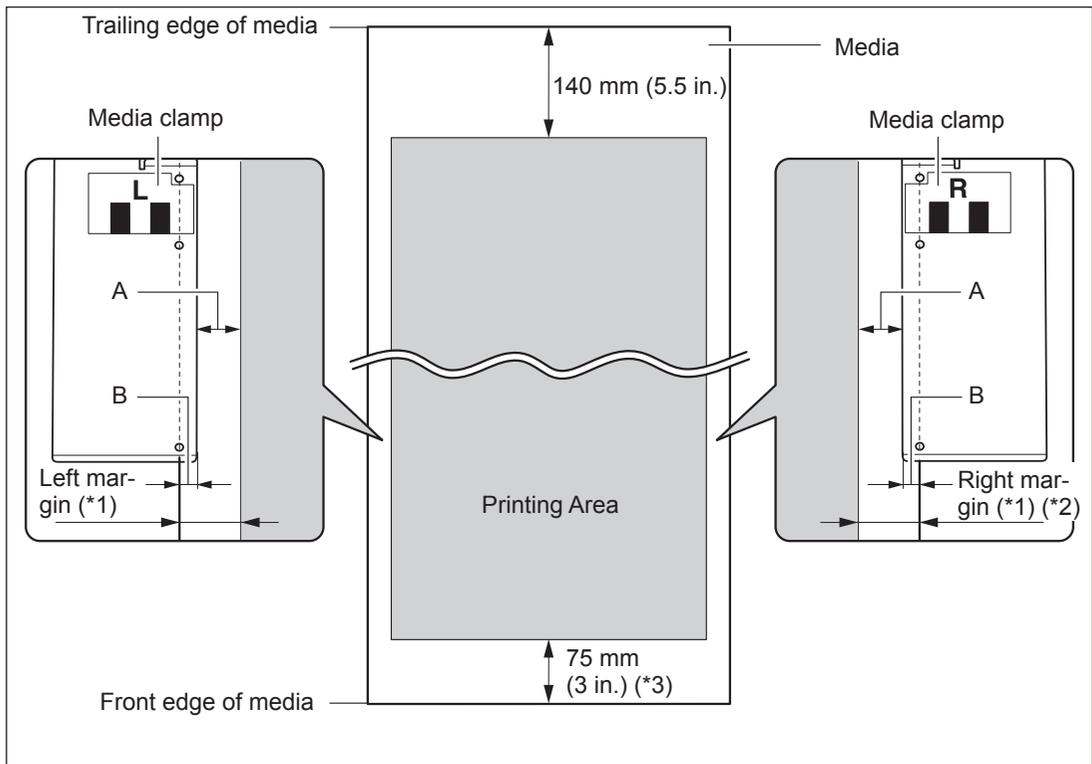
Chapter 8

Main Specifications

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Printing Area

Printing Area and Margins



A: Setting of the [SIDE MARGIN] menu item (5 mm (3/16 inch), 10mm (6/16 inch) (default setting), or 25 mm (16/16 inch))

B: Width clamped by the media clamp (approx. 5 mm (3/16 inch))

*1 The amount of the left and right margins is the total of A and B. In the following cases, however, the setting for A becomes the amount of margin without change.

- When media has been loaded without installing the media clamps
- When the [SHEET TYPE] menu item is set to [CLEAR] (regardless of whether the media clamps are present)

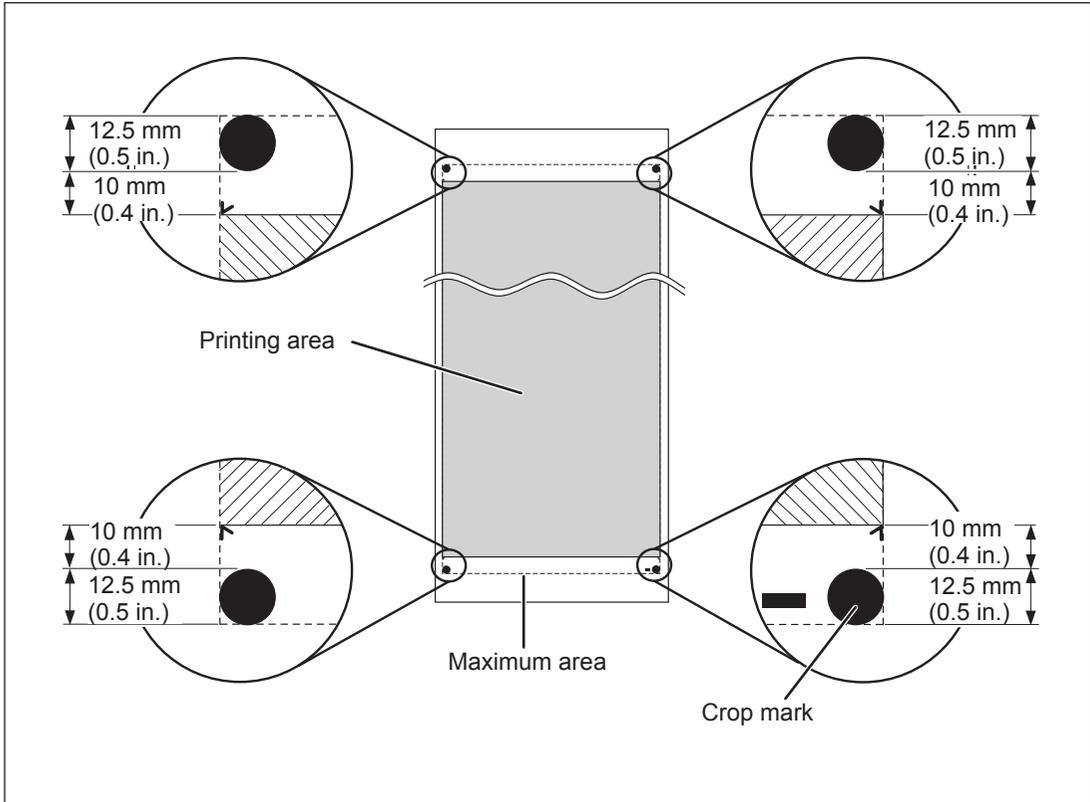
*2 The amount of right margin can be changed by using **BASE POINT**.

*3 75 mm (3 inches) is the value for when "SHEET SETUP" is set to "ROLL."

When "RIGID" is selected, this value becomes the value specified for "FRONT MARGIN." When the media hold down bar is used, about 200 mm (7.9 inches) of space is needed.

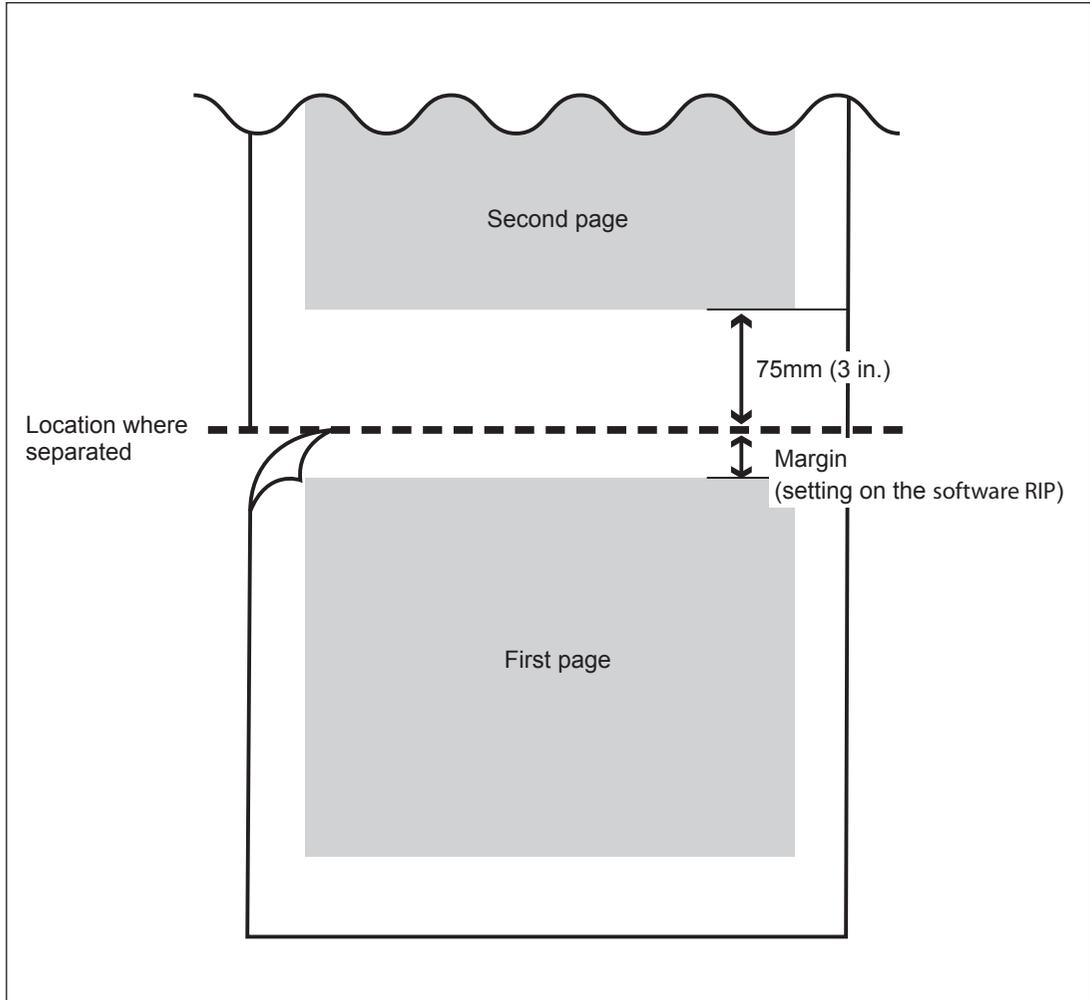
Maximum Area When Using Crop Marks

When crop marks are used, the printing area is reduced from the maximum area by an amount equal to the crop marks.



Media-cutoff Location During Continuous Printing (When "ROLL" is Selected)

When crop marks are used, the printing area is reduced from the maximum area by an amount equal to the crop marks.



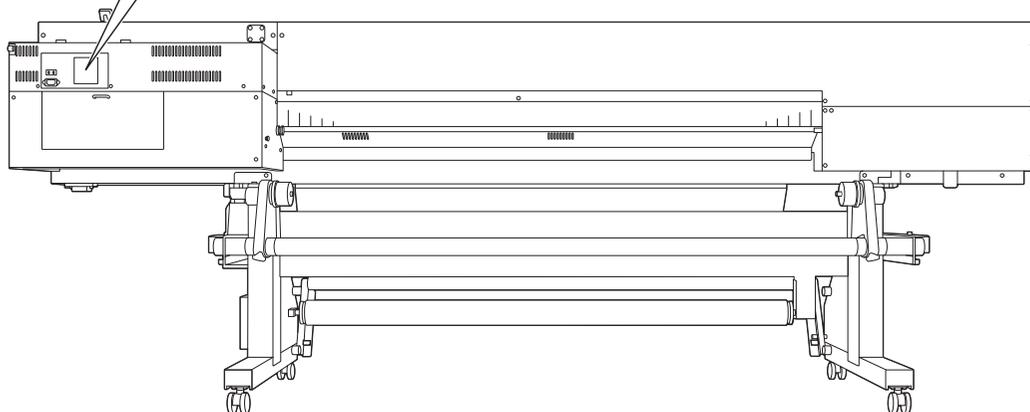
Locations of the Power Rating and Serial Number Labels

Serial Number

This is required when you seek maintenance, servicing, or support.
Never peel off the label.

Power Rating

Use an electrical outlet that meets the requirements for voltage,
frequency, and amperage given here.



Specifications

		LEJ-640
Printing method		Piezo ink-jet method
Acceptable media	Width	Roll media : 210 to 1625 mm (8.3 to 64 in.)
		Rigid media, cut media : 250 to 1625 mm (9.9 to 64 in.)
	Thickness	Roll media : Maximum 1.0 mm (39 mil) with liner
		Rigid media, cut media : Maximum 13 mm (0.51 in.)
	Weight	Roll media : Maximum 40 kg (88 lb.)
Rigid media, cut media : Maximum 12 kg (26 lb.)		
Roll outer diameter	Maximum 210 mm (8.3 in.)	
Core diameter (*1)	76.2 mm (3 in.) or 50.8 mm (2 in.)	
Printing width (*2)		Maximum 1615 mm (63.6 in.)
Ink cartridges	Types	ECO-UV, ECO-UVS
	Colors	ECO-UV (EUV EUV3 EUV4) (Cyan, Magenta, Yellow, Black, White, Gloss) ECO-UVS (Cyan, Magenta, Yellow, Black, White)
Printing resolution (dots per inch)		Maximum 1440 dpi
Distance accuracy (*3)		Error of less than $\pm 0.3\%$ of distance traveled, or ± 0.3 mm, whichever is greater
Media take-up system	Roll outer diameter allowing take-up	Maximum 210 mm (8.3 in.)
	Weight allowing take-up	Maximum 40 kg (88 lb.)
Interface		Ethernet (10BASE-T/100BASE-TX, automatic switching)
Power-saving function		Automatic sleep feature
Power requirements		AC 100V to 240 V $\pm 10\%$, 5.7 A, 50/60 Hz
Power consumption	During operation	500 W
	Sleep mode	15.2 W
Acoustic noise level	During operation	64 dB (A) or less
	During standby	40 dB (A) or less
Dimensions (with stand)		Without table unit* : 3184 (W) \times 836 (D) \times 1281 (H) mm (126 (W) \times 33 (D) \times 51 (H) in.) With table unit* : 3184 (W) \times 3658 (D) \times 1281 (H) mm (126 (W) \times 145 (D) \times 51 (H) in.)
Weight (with stand)		Without table unit* : 240 kg (530 lb.) With table unit* : 316 kg (697 lb.)
Environment	Power on (*4)	Temperature: 20 to 32°C (68 to 90°F) (22°C [72°F] or more recommended) , Relative humidity: 35 to 80% RH (no condensation)
	Power off	Temperature: 5 to 40°C (41 to 104°F), Relative humidity: 20 to 80% RH (no condensation)
Accessories		Exclusive stands, power cord, media clamps, replacement blade for separating knife, software RIP (Roland VersaWorks Dual) , User's Manual, etc.

* The "table unit" indicates RU-640 and MB-640.

(*1)

The media holder of this machine is exclusive use for the media of paper tube (core) inner diameter 3 inches. To use 2 inches media, the optional media flanges are required.

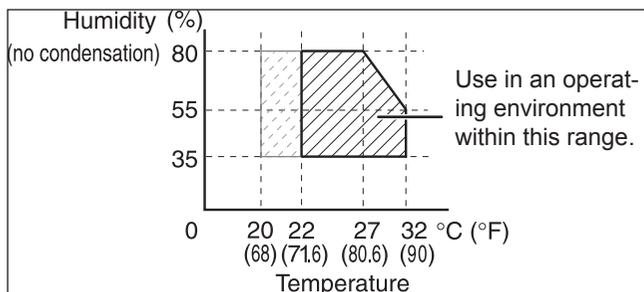
(*2)

The length of printing is subject to the limitations of the program.

(*3)

- Media type: Media specified by Roland DG Corp.
- Temperature: 25°C (77°F), humidity: 50%RH
- Roll media must be loaded correctly.
- Excluding expansion/contraction of the media
- All correction or adjustment function of this machine has been made properly.
- The grit rollers are positioned correctly on top of the media.
- With Roland PET film, print travel: 1 m
- When not using table unit

(*4)



 Roland



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