

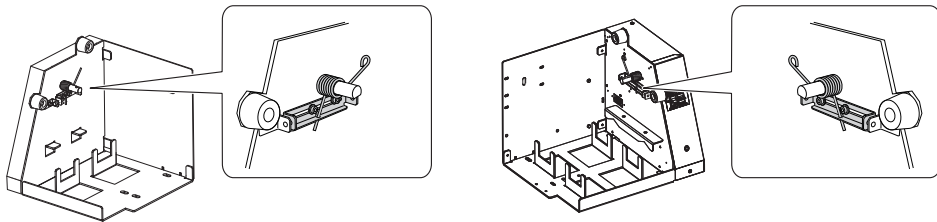
Using the Media Take-Up System

Using the Media Take-up System

- The media take-up system ("take-up system") is an optional item.
- For information on how to assemble and install the take-up system, refer to the user's manual of the take-up system.
- In this manual, instructions for loading media assume that the TUC-3 will be used.
 - ☞ From P. 24 "Load a paper tube onto the take-up system, and switch on the take-up system power." to P. 30 "Secure the media on the paper tube (core)."

Important Notice When Using the TUC-3

- If using the TUC-3 with this machine, it is necessary to make adjustments such as by removing the springs from the control box and frame of the TUC-3. For details, refer to TUC-3 documentation.



- If using the TUC-3 with this machine, do not press  and feed the media in the reverse direction. It may cause an error because the media is pulled with excessive force.
 - ☞ P. 136 "[MOTOR ERROR TURN POWER OFF]"

Chapter 5

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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**.
- 2  Press **▼** several times to display the screen shown on the left.
Press **▶**.
- 3  Press **▼** several times to display the screen shown on the left.
Press **ENTER**.
Printing starts.
- 4 Press **MENU** 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 a subtank cartridge is empty.

Procedure

- 1 Press **MENU**.
- 2  Press **▼** several times to display the screen shown on the left.
Press **▶**.
- 3  Press **▲** several times to display the screen shown on the left.
Press **▶** twice.
- 4  Press **▲** or **▼** to select a setting.
Press **ENTER** to confirm your entry.

STOP	Printing pauses immediately when a subtank cartridge becomes empty.
CONT. (continue)	Printing does not stop when a subtank cartridge becomes empty. When a subtank cartridge becomes empty, a warning beep sounds.

- 5 Press **MENU** to go back to the original screen.

Description

When "STOP" is selected, printing pauses, so colors may be uneven. Ensure that the remaining ink is sufficient before you begin printing. When "CONT" is selected, printing does not stop even if ink runs out completely. To replace an ink pouch, 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. By setting the amount of media currently remaining at the start, the amount remaining will be constantly displayed on the display screen until it reaches zero.

Procedure

- 1

Press **MENU**.
- 2

MENU
SHEET REMAIN

Press **▲** to display the screen shown on the left.
Press **▶**, then **▼**.
- 3

SHEET REMAIN
SET LENGTH

Press **▶**.
- 4

SET LENGTH
0.0m ▶ 25.0m

Press **▲** or **▼** to set the current amount of media remaining.
Press **ENTER** to confirm your entry.
- 5

W1200mm L 25.0m

Press **MENU**, then **◀** to go back to the original screen.

This display is updated.

SETUP SHEET
◀ ROLL L 25.0m

If media has not been loaded, the set value flashes.
- Description
- If you cancel media loading, for example 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 set the machine to 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."
- * The remaining amount that is displayed is only an estimate. Accuracy is not assured.
- 5 To Admin-istrators
- 112

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

Set the machine to display  every time the media is changed.

Procedure

- 1 Press .
- 2  Press  to display the screen shown on the left.
Press .
- 3  Press  twice to display the screen shown on the left.
Press .
- 4  Press  or  to select "ENABLE."
Press  to confirm your entry.
If you select "ENABLE," you must set the [SHEET TYPE] menu item to "OPAQUE."
☞ P. 101 "Using Transparent Media"
- 5 Press , then  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. However, be sure to also set the [SHEET TYPE] menu item to "OPAQUE" (P. 101 "Using Transparent Media"). 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  to display the screen shown on the left.
Press  .
- 3  Press  .
Printing starts.
- 4 Press **MENU** , then  to go back to the original screen.

Description

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

Note, however, that if you continue printing, the next printing operation will start on top of the portion where the amount of remaining media is printed. If you want to continue printing, cut off the media before starting the next printing operation.

System Management of Printer

Setting Menu Language and 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  Press **▲** or **▼** to select the display (menu) language.
Press **ENTER** to confirm your entry.
- 3  Press **▲** or **▼** to select the measurement unit for length.
Press **ENTER** to confirm your entry.
- 4  Press **▲** or **▼** to select the measurement unit for temperature.
Press **ENTER** to confirm your entry.

Default Setting

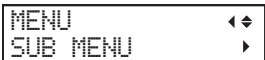
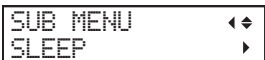
[MENU LANGUAGE]: ENGLISH

[LENGTH UNIT]: mm

[TEMP. UNIT]: °C

Setting Activation Interval for Sleep Mode (Power-Saving Feature)

Procedure

- 1 Press **MENU**.
- 2  Press **▼** several times to display the screen shown on the left.
Press **▶**.
- 3  Press **▲** several times to display the screen shown on the left.
Press **▶** twice.
- 4  Press **▲** or **▼** to select a setting.
Press **ENTER** to confirm your entry.
- 5 Press **MENU** to go back to the original screen.

Default Setting

[INTERVAL]: 30 min

Viewing System Information

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

Procedure

1 Press **MENU**.

2  MENU
SYSTEM INFO.

Press  several times to display the screen shown on the left.

You can view the following information:

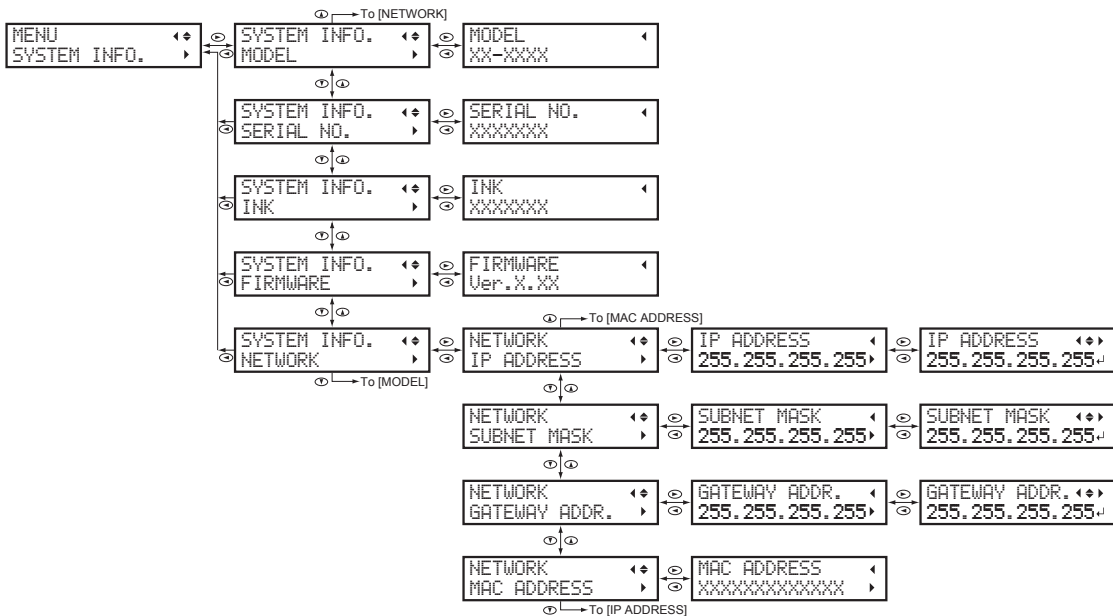
[MODEL]: Model name

[SERIAL NO.]: Serial number

[INK]: Ink type

[FIRMWARE]: Firmware version

[NETWORK]: Network settings such as the IP address

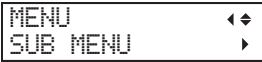


Returning All Settings to Their Factory Default Values

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

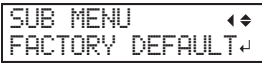
Procedure

1 Press **MENU**.

2 

Press  several times to display the screen shown on the left.

Press .

3 

Press  several times to display the screen shown on the left.

Press  to execute.

Changing Installation Location

Before changing the installation location of the machine, consult your authorized Roland DG Corporation dealer. Roland service technician will move the machine and make adjustments afterwards.

* The feed adjuster must be adjusted after the machine has been moved even if it has only been moved a short distance, e.g., to a different location on the same floor.

Chapter 6

Read This Chapter Whenever You Face a Problem (FAQ)

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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. 45 "Printing Tests and Normal Cleaning", P. 62 "When Normal Cleaning Is Not Effective"

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 are using.

☞ P. 38 "Setup of Media ("MEDIA SETTING" menu)", P. 88 "Fully Utilizing the Preset 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 suitable for the media. When further correction is required, such as when adjustment made using [SIMPLE SETTING] does not enhance printing results, use [DETAIL SETTING] to carry out correction.

☞ P. 96 "Correcting for Misalignment in Bidirectional Printing", P. 96 "Correcting for Misalignment in Bidirectional Printing More Precisely"

Have you carried out feed correction?

Large misalignment in the amount of feed of the media may result in printing results that seem coarse or contain horizontal stripes. Either make the setting in the software RIP to match the type of media you are using, or make the setting for correction on the machine.

☞ P. 97 "Reducing Horizontal Bands (Feed Correction Function)"

Is the print head height appropriate?

Printing when the [HEAD HEIGHT] menu item is set to "HIGH" produces coarser printing results than when set to "LOW." Keep this set to "LOW" except when changing it is necessary, such as when you are using thick media.

☞ P. 100 "Adjusting Print Head Height to Match Media Thickness"

Is the dryer at a suitable temperature?

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

☞ P. 92 "Setting the Temperature of the Dryer"

Is the temperature of the room too low?

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

Is the print mode suitable?

Try a higher quality print mode. Depending on the media, smudging may occur when using a high-quality print mode, and results may also vary greatly depending on the settings of your software RIP (such as the color-profile selection). Make settings suited to the media you are using.

Is the media loaded correctly?

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

☞ P. 17 "Loading Media", P. 125 "Media Feed Is Not Smooth"

Is the machine 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. Failure to do so may cause dot drop-out or adversely affect printing results.

Are the ink pouches installed appropriately?

If an ink pouch is not installed appropriately, printing results may be adversely affected.

☞ P. 56 "Ink Pouch Replacement"

Did you pause printing?

When printing is paused, the coloring at the seam may be altered when printing resumes. Avoid pausing printing. Under factory default settings, printing pauses when an ink pouch runs out. Before you perform lengthy printing, check the amount of ink remaining in the ink pouches. 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.

Colors Are Unstable or Uneven

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 are using.

☞ P. 88 "Fully Utilizing the Preset Function"

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 factory default values.

☞ P. 104 "Changing the Range of Print-head Carriage Movement", P. 106 "Preventing Soiling of the Media and Dot Drop-Out"

Is the media loaded correctly?

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

☞ P. 17 "Loading Media", P. 125 "Media Feed Is Not Smooth"

Did you shake the ink pouches gently before installing them?

Shake a new ink pouch before installing it.

☞ P. 55 "Ink Pouch Replacement"

Is the media wrinkled?

If the media is wrinkled and comes loose from the platen, colors may be uneven or printing results may be adversely affected.

☞ P. 125 "Media Wrinkles or Shrinks"

Have you not printed for a while?

If printing is not performed for several days, printed colors may become unstable or uneven, e.g., when color density is inconsistent, even if the same data is printed with the same settings.

In such cases, shaking the ink pouches, performing light choke cleaning, and refreshing the sub tanks can be effective. (The light choke cleaning and sub tank refresh procedures consume large quantities of ink. Read the instructions in this manual carefully and undertake these procedures with caution.)

☞ P. 64 "If Colors Are Uneven", P. 73 "Refreshing Sub tanks (REFRESH SUBTANKS)"

Is the machine 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. Failure to do so may cause dot drop-out or adversely affect printing results.

The Media Becomes Soiled When Printed

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 manual cleaning. We recommend carrying out periodic print head cleaning.
 - ☞ P. 67 "Manual Cleaning"
- **Too low humidity**
 - Use the machine in an environment of 35 to 65% RH (no condensation).

Are the pinch rollers or the media clamps dirty?

Periodically clean them.

☞ P. 60 "Cleaning"

Do the print heads come into contact with the media?

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

☞ P. 100 "Adjusting Print Head Height to Match Media Thickness", P. 125 "Media Feed Is Not Smooth"

Color Mixing Occurs

Has an ink pouch of the wrong color been installed by mistake?

As soon as an ink pouch is installed, ink flows out of the ink pouch into the ink path. Therefore, if an ink pouch is installed incorrectly, ink mixes inside the ink path even if the pouch is removed immediately. In the event you install an ink pouch of the wrong color, refresh the sub tanks. If this fails to resolve issues with color mixing, contact your authorized Roland DG Corporation dealer.

☞ P. 73 "Refreshing Subtanks (REFRESH SUBTANKS)"

A Media Jam Occurs!

The Media Has Jammed

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. 136 "[MOTOR ERROR TURN POWER OFF]"

Are the grit rollers dirty?

Check to make sure the grit rollers are free of buildup of foreign material such as media scraps.

☞ P. 60 "Cleaning"

Is the height of the print heads too low?

Try raising the print heads higher. Media may inevitably warp or wrinkle slightly, so adjust the height of the print heads to take this into account.

☞ P. 100 "Adjusting Print Head Height to Match Media Thickness"

Are the media clamps mounted?

When you are performing printing, be sure to attach the media clamps.

Is the media loaded 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. 17 "Loading Media"

Is some other object coming into contact with the media?

Make sure that nothing touches the media.

☞ P. 17 "Loading Media"

Is the media too thick?

Media that is too thick may not only cause an unstable feed but may scrape the print heads, resulting in a malfunction. Never use such media.

Is the media warped or wrinkled?

Many factors can cause warping or wrinkling. Refer to the following and correct the problem.

☞ P. 125 "Media Wrinkles or Shrinks"

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 results, contact with the media by the print heads, misaligned positioning, or media jams. Take action as follows.

Media Wrinkles or Shrinks

Are the media clamps attached?

When you are performing printing, be sure to attach the media clamps.

Is the media loaded 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. 17 "Loading Media"

Was loaded media allowed to stand for some time?

Media may shrink or wrinkle if it is heated for an extended time. When printing ends, switch off the sub power or remove the media. Store removed media in a suitable environment.

➤ P. 15 "Media Storage Environment"

Is the media sagging?

If sagging media is used, it may come out wrinkled.

Is the temperature of the dryer too high?

Set the temperature to suitable values for the type of media.

➤ P. 91 "Using the Dryer"

Is the temperature of the room too low?

Use the machine in an environment with an ambient temperature of 18 to 25°C (64 to 77°F). If the machine is used at an ambient temperature of less than 18°C (64°F), then depending on the type or width of the media, wrinkling or temperature-caused unevenness may occur. To obtain stable printing results, use the machine in an environment with an ambient temperature of 18 to 25°C (64 to 77°F).

Is the humidity of the room too high?

Use the machine in an environment of 35 to 65% RH (no condensation).

Media Feeding Is Not Straight

Are the grit rollers dirty?

Check to make sure the grit rollers are free of buildup of foreign material such as media scraps.

➤ P. 60 "Cleaning"

Is the media loaded 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. 17 "Loading Media"

Is some other object coming into contact with the media?

Make sure that nothing touches the media.

➤ P. 17 "Loading Media"

Is the media too thick?

Media that is too thick may not only cause an unstable feed but may scrape the print heads, resulting in a malfunction. Never use such media.

Media Feeding Is Not Smooth

Are the grit rollers dirty?

Check to make sure the grit rollers are free of buildup of foreign material such as media scraps.

➤ P. 60 "Cleaning"

Is some other object coming into contact with the media?

Make sure that nothing touches the media. This may adversely affect printing results, even when feed appears to be smooth.

➤ P. 17 "Loading Media"

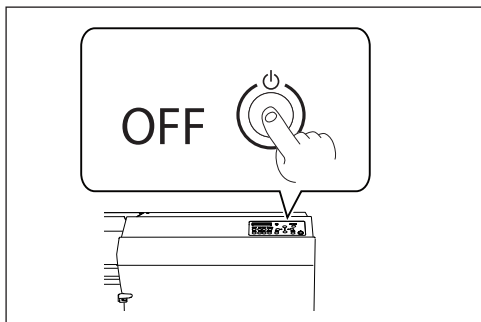
Is the media too thick?

Media that is too thick may not only cause an unstable feed but may scrape the print heads, resulting in a malfunction. Never use such media.

Why Has the Print-Head Carriage 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 and then back on again.

If the media is jammed, also remove the media.

If the print-head carriage moves to the home position (inside the right cover), it means the operation has ended successfully.

If the print-head carriage still does not move

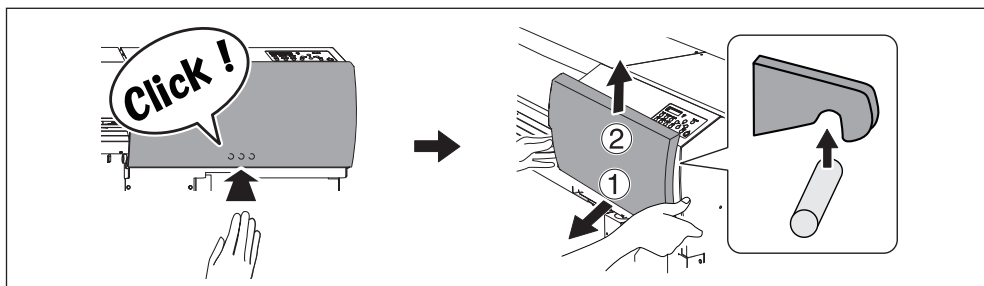
Try switching off the main power, then again switching on the main power, followed by the sub power.

If the Print-Head Carriage Still Do Not Move

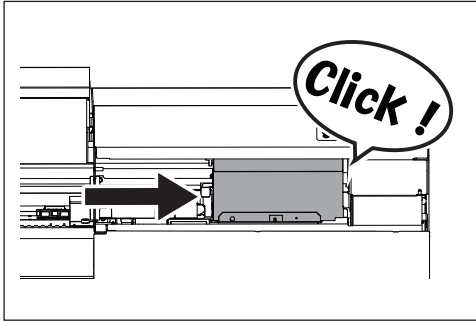
If the print-head carriage still do not move, carry out the following emergency response measure, and then contact your authorized Roland DG Corp. dealer.

Procedure

- 1 Switch off the main power and open the front cover.
- 2 Remove the right cover.



3



Gently move the print-head carriage to the home position by hand.

Stopping at the place where the audible click is heard locks the print-head carriage in place.

4

Gently apply pressure from the right side to make sure the print-head carriage does not move to the left.

If the print-head carriage moves to the left, move it again slowly by applying pressure from the left side and make sure it locks in place.

The Machine Does Not Move

Are the cables connected?

Connect the cables securely.

➤ "Setup Guide"

Is the power switched on?

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

➤ P. 16 "Switch On!"

Is a cover open?

Close the front, left, and right covers.

Is **SET UP** illuminated?

Printing is not performed when **SET UP** is not illuminated. Lower the loading lever.

➤ P. 48 "Getting Ready to Receive Data from a Computer"

Is the top menu displayed?

Top menu



If the top menu is not displayed, printing does not start even when data is sent from the computer. To go to the top menu, press **MENU**, and then press **◀**.

➤ P. 48 "Getting Ready to Receive Data from a Computer"

Is a message displayed on the screen?

➤ P. 132 "A Message Appears", P. 134 "An Error Message Appears"

Is **PAUSE** illuminated?

When **PAUSE** lights up, operation is paused. To resume, press **PAUSE**. **PAUSE** goes dark and printing resumes.

➤ P. 50 "Pausing or Canceling Printing"

Has the ink run out?



When the screen shown above is displayed, print data cannot be accepted.

If the screen shown above is displayed during printing, the behavior of the machine depends on the [EMPTY MODE] setting.

- When "STOP" is selected: The printing operation is paused.
 - When "CONT." is selected: A warning beep sounds and printing continues until the machine has finished printing the print data it has received. In this case, it is also possible to press **PAUSE** and pause printing.
- In both cases, the error can be resolved by replacing the ink pouch with a new one. If there is print data that has not yet been printed remaining in the machine, printing resumes. If there is unsent print data in the computer, printing resumes when the data is resent.

☞ P. 56 "Ink Pouch Replacement", P. 111 "Determining What Happens When Ink Runs Out"

If you are using the media take-up system (TUC-3), does the media move when pressing and holding **▲**?

If you are using the separately sold media take-up system (TUC-3), pressing and holding **▲** to move the media will cause the machine to stop for a certain length of time.

☞ P. 136 "[MOTOR ERROR TURN POWER OFF]"

Is the network routing appropriate?

Check whether the network routing is appropriate. 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 printing, it means the problem is in the network itself.

Are the network settings correct?

If the cable connections are secure and no problem is found in the network itself, make sure that the IP address and other such settings are appropriate. The settings on both the machine and the computer must be appropriate. Redo the settings while checking to ensure that the IP address does not conflict with the IP address for another device on the network, that the port setting for the software RIP specifies the IP address set on the machine, that the settings have no typing errors, and for other such problems.

☞ "Setup Guide," P. 116 "Viewing System Information"

Did the software RIP end abnormally?

Make sure the software RIP is running correctly, then switch the machine's sub power switch off and back on. For information about using the software RIP, refer to the documentation included with the software RIP.

Cannot Cut Off the Media

Is the separating knife installed?

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

➤ P. 84 "Replacing the Separating Knife"

Is the cut rail installed?

If the cut rail is not installed, you cannot cut off the media. The cut rail is removed when performing manual cleaning. If the cut rail is not installed, remove the left cover, and then install the cut rail by following step 4 in P. 72 "Reattach the left and right covers, and finish manual cleaning mode.". After installing the cut rail, be sure to attach the left cover.

Dryer Does Not Become Hot

Is the media loaded?

The media heating system does not warm up to the set temperature when  is off (by default). Load the media and wait for the machine to warm up.

➤ P. 91 "Using the Dryer"

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).

It Is Not Possible to Check the Amount of Discharged Fluid in the Drain Bottle

Is ink splattered around the inside of the drain bottle?

If ink is splattered around the inside of the drain bottle, it may not be possible to check how much discharged fluid the bottle contains.

➤ P. 59 "If It Is Not Possible to Check the Amount of Discharged Fluid in the Drain Bottle"

A Message Appears

These are the main messages that appear on the machine's display to prompt correct operation. They do not indicate any errors. Follow the prompts and take action accordingly.

[PRESS THE ENTER KEY TO CONTINUE OPERATION]

If the front cover, left cover, or right cover (hereafter collectively referred to as "covers") is opened during printing or any other operation where the print-head carriage is moving, the printer will perform an emergency stop.

☞ P. 134 "[CLOSE COVER (FRONT COVER/COVER L/COVER R)]"

When an emergency stop occurs, a message requesting the covers be closed will be displayed on the screen. Close the covers as directed in the instructions shown on the screen. After closing the covers, the above message appears on the screen. Press **ENTER** as directed in the instructions shown on the screen. Once recovery from the error is complete, you will be able to continue working.

If the message requesting the front cover be closed does not disappear even after you close the front cover, the media may be in contact with the front cover, which will prevent the front cover from closing. In this situation, try the following methods.

- Close the front cover while holding down the end of the media.
- Pull the media to the front until it is in a position where its end is not in contact with the front cover, and then close the front cover.
- Cut the end of the media so that it is not in contact with the front cover, and then close the front cover.

If the media is still in contact with the front cover even after you try these methods, change the media.

[1 ■ 2 ■ 3 ■ 4 ■ 5 ■ 6 ■ 7 ■ 8 ■]

Ink has run out. Replace the ink pouch indicated by the flashing number with a new pouch.

[PRESS THE POWER KEY TO CLEAN]

This message appears when the machine has been unused for about one month. Switch on the sub power once a month.

☞ P. 86 "When Not in Use for a Prolonged Period"

[SHEET NOT LOADED SETUP SHEET]

Load the media. This message appears when an attempt to perform a printing test was made while no media was loaded.

[END OF THE SHEET]

The trailing edge of the media was detected during operation. Press any key on the operation panel to clear the message. Load new media.

[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. 58 "Disposing of Discharged Fluid"

[INSTALL DRAIN BOTTLE]

Check whether the drain bottle is installed. Install the drain bottle, then press **ENTER**.

☞ P. 58 "Disposing of Discharged Fluid"

[NOW HEATING... NOW PROCESSING..]

Wait until the dryer reaches the set temperature. Printing starts when **HEATER** lights. You can stop printing by holding down **SET UP** for one second or longer while this is displayed. Pressing **PAUSE** makes printing start immediately without waiting to reach the set temperature.

[TIME FOR MAINTENANCE]

It is time to clean the printer heads manually. After verifying the message, press **ENTER** .
☞ P. 67 "Manual Cleaning"

[TIME FOR WIPER (FELT) REPLACE]

It is time to replace the wiper or felt wiper. After verifying the message, press **ENTER** .
☞ P. 78 "Replacing the Wiper", P. 81 "Replacing the Felt Wiper"

[REMOVE MEDIA CLAMPS]

This message appears if the media clamps are attached when you try to cut off the media. Open the front cover, remove the left and right media clamps, and press **ENTER** .

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.

[CLOSE COVER (FRONT COVER/COVER L/COVER R)]

Close the front, left, and right covers. For safety, the print-head carriage does not operate while a cover is open. If the message does not disappear even after you close the front cover, the media may be in contact with the front cover, which will prevent the front cover from closing. In this situation, try the following methods.

- Close the front cover while holding down the end of the media.
- Pull the media to the front until it is in a position where its end is not in contact with the front cover, and then close the front cover.
- Cut the end of the media so that it is not in contact with the front cover, and then close the front cover.

If the media is still in contact with the front cover even after you try these methods, change the media.

[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 printing without correcting this, press **ENTER**. At this time, the portion extending beyond the printing area and the crop marks are not printed. To stop printing, stop sending data from the computer, and then raise the loading lever. Make the printing area wider, for example, by replacing the media with a larger piece of media, and then send the data again.

The size of the data being printed is too small.

Make the scanning-direction size of the data at least 65 mm (2.6 in). To continue printing without correcting this, press **ENTER**. At this time, the data is output without printing the crop marks. To stop printing, stop sending data from the computer, and then raise the loading lever. Change the size of the data, and then send the data again.

[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 temperature of the installed location to a temperature at which operation is possible (18 to 25°C (64 to 77°F)), allow the machine to come to room temperature, and then turn on the power.

[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 temperature of the installed location to a temperature at which operation is possible (18 to 25°C (64 to 77°F)), allow the machine to come to room temperature, and then turn on the power.

[HEATING TIMEOUT CONTINUE?]

The dryer did not reach the preset temperature.

This occurs because the temperature of the location where the machine is installed is too low. We recommend

raising the temperature. To continue waiting for the temperature to rise, press **ENTER**. To start printing immediately, press **PAUSE**.

[SERVICE CALL xxxx]

An unrecoverable error occurred, or part replacement that must be performed by a service technician is required.

Note the number displayed on the display screen, then switch off the sub power. After you switch off the power, inform your authorized Roland DG Corporation dealer or call center of the number that appeared on the display.

[SHEET TOO SMALL CONTINUE?]

The size of the data is larger than the printing area of the loaded media

To continue printing without correcting this, press **ENTER**. At this time, the portion extending beyond the printing area is not printed. To stop printing, stop sending data from the computer, and then raise the loading lever. Make the printing area wider, for example, by replacing the media with a larger piece of media, and then send the data again.

[SHEET SET ERROR SET AGAIN]

The loading lever was lowered while no media was loaded

Raise the loading lever, load the media in the correct position, then lower the lever again.

➤ P. 17 "Loading Media"

[SHEET TYPE] is set to "OPAQUE," but transparent media was loaded

Raise the loading lever, set the [SHEET TYPE] menu item to "CLEAR," and then reload the media.

➤ P. 101 "Using Transparent Media"

The loaded media is too small

Press any button to clear the error. Replace the media with media of a usable size.

[DATA ERROR CANCELING...]

Printing was stopped because a problem was found in the data received.

Operation cannot be continued. Check for a problem with the connector cable or the computer, and redo the operation from the step of loading the media.

[CLEANING ERROR]

Light choke cleaning was stopped due to some kind of operation.

The operation cannot be continued. Switch the sub power off by holding down the switch for one second or longer, and then switch the sub power back on again. Afterward, redo light choke cleaning from the start.

➤ P. 64 "Light Choke Cleaning"

[CANCELED FOR PUMP PROTECTION]

The printer made an emergency stop because the following state has continued for 10 minutes or longer while cleaning (normal, medium, powerful, light choke cleaning, subtank refresh, or automatic cleaning while sub power was switched off) was in progress or during the first ink filling procedure for the machine.

➤ **The printer is out of ink.**

Operation cannot be continued. Switch off the sub power. After you switch off the power, contact your authorized Roland DG Corp. dealer.

[AVOIDING DRY-UP TURN POWER OFF]

The print heads were forced to the home position to prevent them from drying out.

Operation cannot be continued. Switch the sub power off, then back on.

[SET HEAD HEIGHT TO xxx]

The height of the print heads is lower than the height specified in the software RIP.

This warning indicates that the height of the print heads is too low for the media thickness specified in the software RIP. The print-head carriage moves to a location where you can operate the height-adjustment lever.

Adjust to the displayed height, then press **ENTER**.

☞ P. 100 "Adjusting Print Head Height to Match Media Thickness"

[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, and then immediately switch on the sub power. If the machine is left with the error uncorrected, the print heads may dry out and become damaged. This error may be caused by such factors as a mistake when loading the media, a media jam, an operation that pulls the media with excessive force, or an operation where the print heads were manually moved

The media has jammed.

Carefully remove the jammed media. The print heads may also be damaged. Perform head cleaning, and then perform a printing test and check the results.

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, raise the loading lever and adjust the media to create a small amount of slack, then switch on the sub power.

The print heads were moved manually.

This message may occur if the front cover was opened and the print heads moved manually. Close the front cover, and turn the sub power off.

[PINCHROLL ERROR LOWER PINCHROLL]

This message appears when the loading lever was raised during initialization or after the media was loaded.

The error is cleared automatically after a short wait. Load the media correctly again.

[WRONG HEAD IS INSTALLED]

An unusable print head has been installed.

Operation cannot be continued. Switch off the sub power and contact your authorized Roland DG Corporation dealer.

[CANCELED FOR MOTOR PROTECTION]

The initial ink filling operation after purchase was interrupted and restarted before 10 minutes had passed.

Press any key other than the sub power switch to clear the error message. Leave the machine alone for approximately 10 minutes before resuming operation. Initial ink filling after purchase requires the pump motor to turn for a long time. To prevent failure due to the pump overheating, wait at least 10 minutes after the operation was interrupted before restarting.

[MEMORY ERROR TURN POWER OFF]

An error occurred while data was being written to or read from memory.

The operation cannot be continued. Switch the sub power off by holding down the switch for one second or longer, and then switch the sub power back on again. Afterward, redo light choke cleaning from the start.

[Turn off the main power]

This message indicates that the machine cannot start normally due to a failure to recognize the built-in memory.

If, regardless of the sub power being on, the main power turns off due to power outages and other such unexpected causes, this message may be displayed when the power turns on again.

When this message is displayed, perform the operations explained below.

Procedure

1 Turn off the machine's main power.

2 Wait 3 seconds, and then turn on the main power.

The machine attempts to recognize the built-in memory. If there are no problems, the message disappears. In this case, perform step 3.

If the machine again fails to recognize the memory, the same error message will be displayed. In this situation, repeat steps 1 and 2 given above. If this problem is not fixed after repeating these steps five times, contact your authorized Roland DG Corporation dealer.

3 Turn on the sub power.

When the initial operations finish and the first menu is displayed on the display screen of the operation panel, the machine has started normally. Use the machine as-is.

SERVICE CALL
0011

If data loss or other problems are detected with the setting values recorded to this machine, automatic recovery work is performed using the periodically saved backup data. If the recovery work fails and a service call error is displayed, contact your authorized Roland DG Corporation dealer.

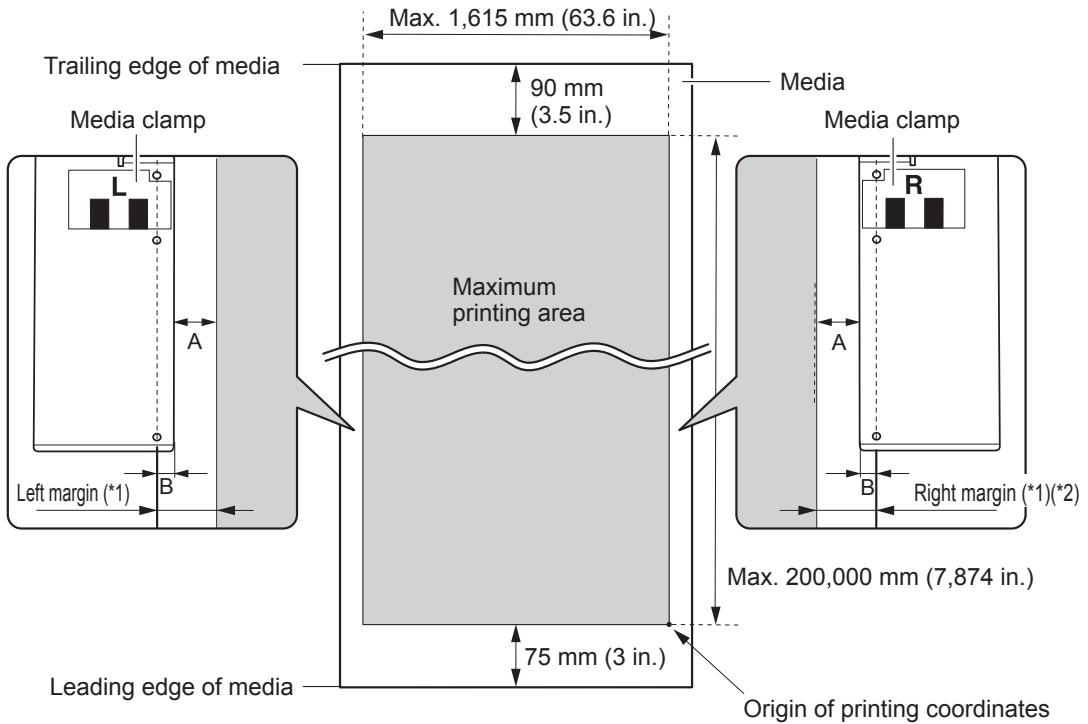
Chapter 7

Main Specifications

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Printing Area

Maximum Printing Area and Margins



A: Setting of the [SIDE MARGIN] menu item (5 mm, 10 mm [default setting], or 25 mm (0.2 in., 0.4 in. [default setting], or 1.0 in.))

B: Width clamped by the media clamp (approx. 5 mm (0.2 in.))

*1 The width of the left and right margins is the total of A and B. In the following cases, however, the setting for A itself becomes the width of the margin.

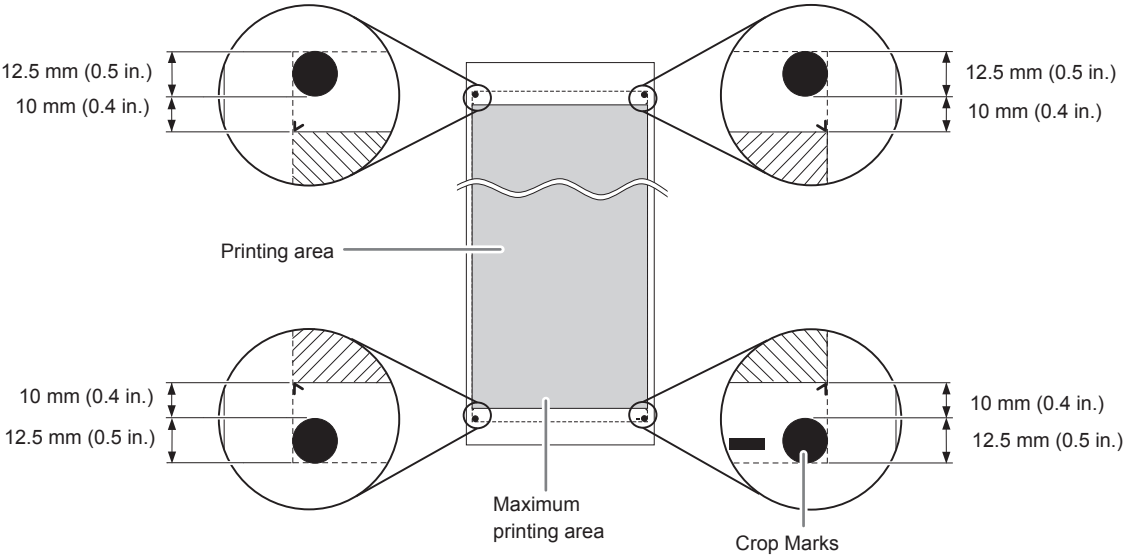
- When media has been loaded without installing the media clamps
- When the [SHEET TYPE] menu item is set to [CLEAR] (regardless of whether the media clamps are present)

*2 You can change the width of the right margin by setting the base point (printing-start location).

☞ P. 44 "Setting the Printing-start Location"

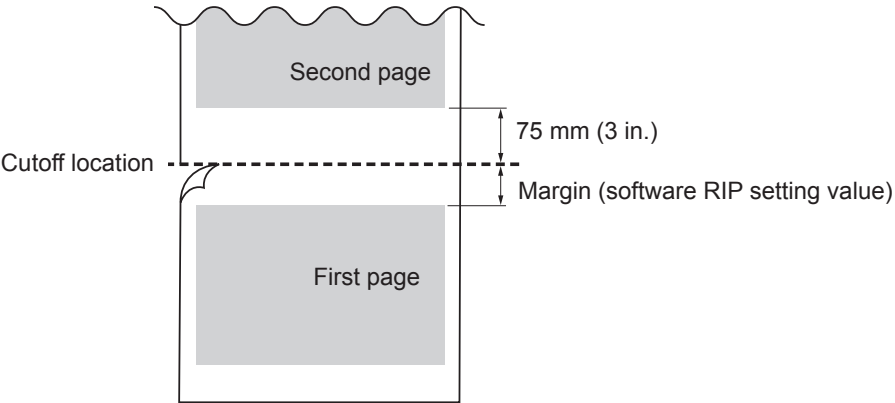
Maximum Printing Area When Using Crop Marks

The maximum printing area when crop marks are used is reduced from the maximum printing area when crop marks are not used by an amount equal to the crop marks.

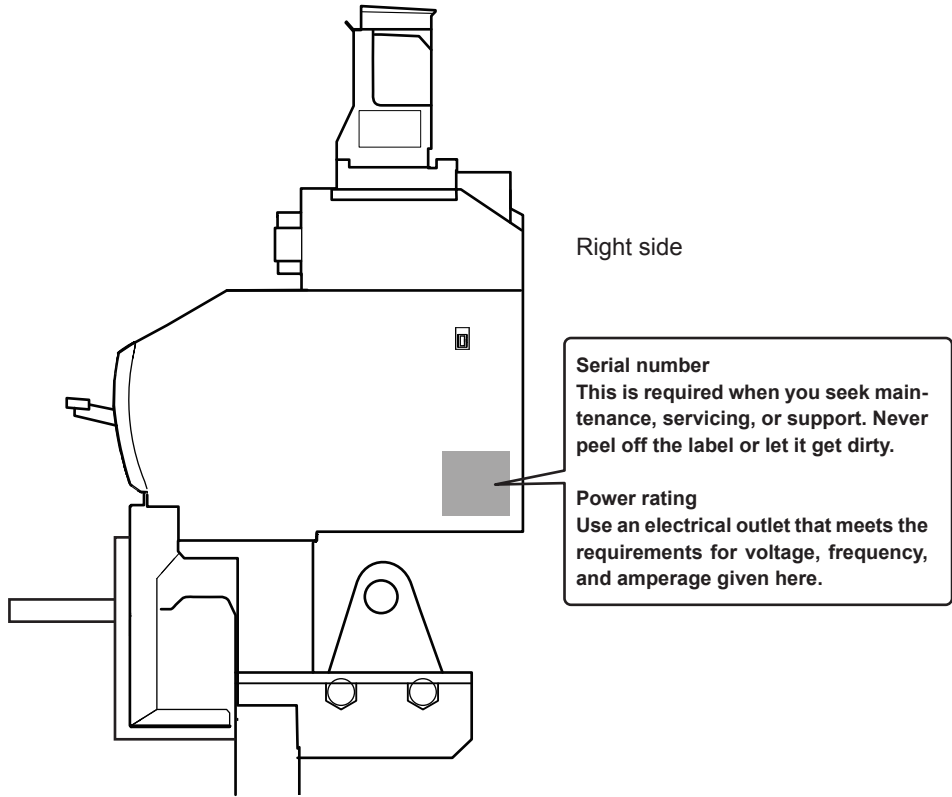


Media-Cutoff Location during Continuous Printing

When a media-cutoff command is sent from the computer, the cutoff location on the media is as shown in the figure below.



Locations of Power Rating and Serial Number Labels



Specifications

		XT-640
Printing technology		Piezoelectric inkjet
Media	Width	259 to 1,625 mm (10.2 to 64 in.)
	Thickness	Max. 1.0 mm (39 mil)
	Roll outer diameter	Maximum 210 mm (8.3 in.)
	Roll weight	Maximum 40 kg (88 lb.)
	Core diameter (*1)	76.2 mm (3 in.) or 50.8 mm (2 in.)
Printing width (*2)		Maximum 1,615 mm (63.6 in.)
Ink	Type	Dedicated sublimation ink pouches
	Colors	Four colors (cyan, magenta, yellow, and black) Eight colors (cyan, magenta, yellow, black, light cyan, light magenta, orange, and violet) Eight colors (cyan, magenta, yellow, black, fluorescent yellow, fluorescent pink, orange, and violet)
Printing resolution (dots per inch)		Maximum 1,440 dpi
Distance accuracy (*3)		Error of less than $\pm 0.3\%$ of distance traveled, or ± 0.3 mm, whichever is greater
Dryer (*4)		Dryer set temperature: 30 to 40 °C (86 to 104°F)
Connectivity		Ethernet (100BASE-TX/1000BASE-T, automatic switching)
Power-saving function		Automatic sleep feature
Power requirements		AC 100 to 120V $\pm 10\%$, 5.5A, 50/60 Hz or AC 220 to 240V $\pm 10\%$, 2.8A, 50/60 Hz
Power consumption	Power on	Approx. 750 W
	Sleep mode	Approx. 70 W
Acoustic noise level	Power on	62 dB (A) or less
	During standby	45 dB (A) or less
Dimensions (with stand)		2,835 (W) x 830 (D) x 1,650 (H) mm (111.6 [W] x 32.7 [D] x 65.0 [H] in.)
Weight (with stand)		214 kg (471.8 lb.)
Environment	Power on	Temperature: 18 to 25°C (64 to 77°F), humidity: 35 to 65% RH (non-condensing)
	Power off	Temperature: 15 to 30°C (59 to 86°F), humidity: 20 to 80% RH (non-condensing)
Included items		Dedicated stands, power cord, media clamps, media holders, replacement blade for separating knife, User's Manual, etc.

*1

The media holder of this machine is designed to be used exclusively with media that has a paper tube (core) with an inner diameter of 3 inches. To use 2-inch media, the optional media flanges are required.

*2

The length of printing is subject to the limitations of the application software.

*3

- Media type: Media specified by Roland DG Corp.
- Not guaranteed when the dryer is used.
- Temperature: 25°C (77°F), humidity: 50%
- Roll media must be loaded correctly.
- Excluding expansion/contraction of the media
- Assumes all correction and adjustment functions of the machine have been made properly.
- Print travel: 1 m

*4

- Warm-up is required after the power is turned on. This may require 5 to 20 minutes, depending on the operating environment.
- Depending on the ambient temperature and the media width, the set temperature may not be reached.
- Depending on the printing conditions, an external heater may be needed.

