

#### contents

1.	Software description	2
	1.1. Computer system and online	2
	1.2. Disable the driver signature enforcement	4
	1.3. software installation	5
2.	Software main interface window	7
	2.1. File	8
	2.2. Task	8
	2.2.1. Mission Preview Area	9
	2.2.2. Print the mission area	9
	2.2.3. Task properties area	12
	2.3. Print	12
	2.4. Stop	12
	2.5. Pause	12
	2.6. Test	13
	2.7. Clean	13
	2.8. Flash	14
	2.9. Left	14
	2.10. Right	14
	2.11. Feed	14
	2.12. Back	14
	2.13. X reset	14
	2.14. Config	15
	2.14.1. Parameter	15
	2.14.2. Calibrate	
	2.15. Voltage	21
	2.15.1. Voltage - Voltage setting	21
	2.15.2. Voltage - Temperature	21
	2.16. Advanced	22
	2.16.1. Motor	23
	2.16.2. Color	
	2.16.3. UV	29
	2.16.4. Cleaning	31
	2.16.5. Parameter	35

# **1. Software description**

(1) This printing software is a printer control software created by Huixin Technology. Control the printer inkjet and operation. Simplicity of operator, popular and easy to understand. It is mainly used in the printing of various pictures, Such as: PNG, TIF, PDF and other formats of picture printing.

(2) Once the machine has been initialized. We can complete the printing and other operations through this software.Basic use can be understood through the subsequent menu bar.

### 1.1. Computer system and online

Applicable to win7,10,11 systems.Net port version needs the computer network card for gigabit network.The 100 megabit network cannot connect to the motherboard.

Computer network card is confirmed to be a gigabit network card, Recommended Computer Settings, as following picture shows,Local connection for win7 system.

Advanced Tools		
Disable this network	device Diagnose this connection Rename this connection View	v status of this connection Change settings of this connection
iewer VPN rk cable unplugged iewer VPN Adapter	WLAN HX_002 Intel(R) Dual Band Wireless-AC 72 任therme 末识别	t 的网络 Ethernet Connection I217-, 文 Bluetooth Device (Personal Area
÷	$\rightarrow$ = $\odot$ $\odot$ $\odot$ $\odot$ $\sim$ $\cdots$ $ \sim$ x	Intel(R) Ethernet Connection I217-LM Properties
	Ethernet Properties ×	General Advanced Driver Details Events Power Management
	Networking Sharing	The following properties are available for this network adapter. Click the property you want to change on the left, and then select its value on the right.
	Connect using:	Property: <u>V</u> alue:
	Configure         This connection uses the following items:         ● Microsoft 网络客戶端         ● Intermet 协议版本 4 (TCP/IPv4)         ● Microsoft 网络适配器多路传送器协议         ● Microsoft DIP 协议驱动程序         ● Intermet 协议版本 6 (TCP/IPv6)         ● Intermet 协议版本 6 (TCP/IPv6)         ● Install         ● Description         允许你的计算机访问 Microsoft 网络上的资源。	PTP Hardware Timestamp RSS 负载平衡配置式 RSS 队列的最大数目 Software Timestamp TCP 校验和分载传输 (IPv6) UDP 校验和分载传输 (IPv6) UDP 校验和分载传输 (IPv6) UDP 校验和分载传输 (IPv6) <b>中断载洪平</b> 传统型交换器兼容模式 传输缓冲区 干兆位主从模式 协议 ARP 分载



## 1.2. Disable the driver signature enforcement

If you can't get online,Some Win10 computers need to disable the driver signature enforcement,as following picture shows,Left to right-Top to bottom order,Can be repeated several times.



## 1.3. software installation

Double-click on the installer<sup>PrintDrea</sup><sup>m</sup>, Select an installation language, Click OK, Wait for

the process...



Click **<Browse>** to select the installation destination folder,Click **<OK>**,Click **<Next>**,It can also be installed in the Program Files folder on drive D,Go straight to **<Next>**.

HXXP6002Head - InstallShield Wizard		×
<b>Choose Destination Location</b>		A second
Select folder where setup will install files.		
Setup will install HXXP6002Head in the followi	ng folder.	
To install to this folder, click Next. To install to another folder.	a different folder, clic	k Browse and select
Destination Folder		
D:\Program Files		B <u>r</u> owse
InstallShield		
	< <u>B</u> ack	Next > Cancel



Software installation complete, You can double-click the shortcut icon generated on the desktop or Double-click the icon in the installation folder to open the software methods.

# 2. Software main interface window

d HJ print control software				- • ×
File Task Print Stop Pause Te	st Clean Flash Left Ri	) I Constant Sector Sec	🧟 🔶 menu bar	
	48线条6P 48线条6P 48	pm 大王臣+W.pm 4色+W-2.pm	720(720-严 人物头像pm 360x720Gra 人物头像72	GrayBalance GrayBalance
<ul> <li>▶ 控制區板说明书220707</li> <li>● 板卡说明书220705</li> <li>● 校准館</li> <li>● 校准館文件220627</li> <li>● 波形数据FLASHI读出</li> <li>● 波形文件</li> </ul>	File nase: 4直续祭 -8P.pra Celors: 5 Color Bits per dot: 2 Bits Resolution: 720 x 720 Image width: 40.04 mm 1135 dpt			
→ Printer:Connected Printer ready v:-0.04m	Elash Tatting Off			Ink certridee status K C W V W



## 2.1. File

Double-click in the specified directory to select the PRN or PRT file that you want to print, as following picture shows, You can view the selected task information in the print task property bar.



## 2.2. Task

View or execute image parameters that need to be printed, as following picture shows.



### 2.2.1. Mission Preview Area

Displays the selected task and the printing task

### 2.2.2. Print the mission area

### 2.2.2.1. Current

**PASS the number:** Select the < PASS the number > to print **Task status:** Observe whether the task is performing a print state **Number of prints:** Observe how many copies this task will print

**A**、**Right - click the job you want to print:**In the ready state, you can <Start printing> and <Delete task>、 <The ink quantity statistics>、 <Clear list>.You can <Pause to print>, <Stop printing>, or <Interrupt tasks> in the printing state.<Interrupt tasks> is when printing multiple copies,After clicking <Interrupt tasks>,The current copy is printed,The remaining copies will not be printed.As following picture shows



Click on the image above <The ink quantity statistics...>,The percentage of ink can be observed.As following picture shows:

Ink quantity	statistics(ml)								
0.03	0.06	0.10	0.09	0.28	0.00	0.00	0.00	0.00	0.00
10.4% 10.4%	17.8%	29. 9%	27.8%	84. 3%	0.0%	0.0%	0.0%	0.0%	0.0%
K max:27.7% mid:26.3% min:46.1%	C max:30.5% mid:30.1% min:39.4%	Mnax:35.8% mid:32.3% min:31.9%	<ul> <li>Y</li> <li>max:33.8%</li> <li>mid:30.0%</li> <li>min:36.2%</li> </ul>	LC max:30.8% mid:17.1% min:2.1%	LM max:0% mid:0% min:0%	LY max:0% mid:0% min:0%	LK nax:0% nid:0% nin:0%	W max:0% mid:0% min:0%	V nax:0% nid:0% nin:0%
			100%				1	Cance1	Quit

**B、Double-click the print task:**Various properties of the print task can be set,As following picture shows:

🐳 Task configuration			×
Task attribute Cut the	ink		
Current:360x720GrayBalance220609. PASS: 6 • X Copy: 1 • X Space(mm): 0.00 • X Space(pixel): 0 • X_Limit Width: 0 • • • • • • • • • • • • • • • • • •	prn Repeat Print Times: 1 Y Copy: 1 V Space(m): 0.00 Y Space(pixel): 0 Y_Limit Width: 0 Dividing line value: 0 White Ink Back: Clope Repeat Count: 1	Regional Print         x:       1         w:       1         h:         i         i       i	
		Ok Cancel	1 Apply

PASS:	Click on the right triangle to select the number of passes to print				
Repeat print times:	Set the number of times that the task needs to be printed repeatedly				
Х сору:	Set the print amplitude in the X direction,Note the machine physics X width				
Ү сору:	Set the print amplitude in Y direction				
X Space(mm):	Set X spacing(mm) between transverse amplitudes				
Y Space(mm):	Set Y spacing(mm) between longitudinal amplitudes				
X Space(pixel):	Set X spacing(pixel) between transverse amplitudes				
Y Space(pixel):	Set Y spacing(pixel) between longitudinal amplitudes				
X_Limit Width:	Set the current task Auto Fill X print width value				
Y_Limit Width:	Set the current task auto-fill Y print height value				
Dividing line:	After printing, Print the corresponding marking line at the setting distance				
Dividing line value:	Set the printing position of the cutting line mark				
Туре:	Select color on top or color on bottom according to printing needs				
Fill White Ink:	Check this feature,In the picture does not do spot color situation,Automatic filling of paving white ink				
White Ink Back:	Select whether to roll back the print				
Repeat Count:	Number of white ink printing passes (thickness)				
X margin:	Display X print start position				
Regional print:	After the check, The mouse can be used to draw the area to be printed on the picture or fill in the print length and width.				

**Cut the ink:** After opening, you can control the amount of ink, Generally don't have to, as following picture shows

ask configuratio	'n						×
Task attribute	Cut t	he ink					
🔽 Ink Limited -							
0 % 0	§ %	0 %	0 %	0 %	0 %	0 %	0 %
İ		İ		İ	I		
K	с	M	Y	LY	LK	W	v
							Set Default
						0k Can	icel Apply

### 2.2.2.2. Past tasks

Displays printed tasks,Right-click a history print task to perform operations such as< Add to Print List>,< Delete Task>, and< Clear List>



## 2.2.3. Task properties area

			•	
File name:	360x720GrayBalance2208	09. prn	Print width:	270.02 mm
Colors:	5 Color		Print height:	145.41 mm
Bits per dot:	2 Bits	Tack properties area	Print area:	0.0393 sq.m
Resolution:	360 x 1080	Task properties area	Progress:	0% 0.00 mm
Image width:	270.02 mm 3827 dpt		Time-consuming:	0:7:59
Image height:	145.41 mm 6183 dpt		Production capacity:	0.00 m²/h

File name:	File name					
Colors:	The task displays the number of colors					
Bits per dot:	Displays the number of bits of the point					
<b>Resolution:</b> The resolution of the print task						
Image width:	The width of a single print task					
Image width: The height of a single print task						
Print width:	The actual print width is displayed in combination with the transverse amplitude					
Print height:	The actual print height is displayed in combination with the longitudinal amplitude					
Print area:	Actual print area					
Progress:	Display print progress					
Time -consuming:	Record the printing time					
Production capacity: Print the square number in 1 hour						

### 2.3. Print

Print the selected task

## 2.4. Stop

Stop printing the current task

### 2.5. Pause

Click the pause button while printing, The printing of the current task is paused. The car is reset. Clicking again will continue printing the current task

## 2.6. Test

Printing test strips(Nozzle status:Check whether the nozzle is blocked) You can view the current nozzle status by printing the test diagram.As following picture shows.



If the print head status is the same as the figure above ↑, The print head is not blocked.

If the print head status is similar to the following figure, Indicates that there is air or blockage in the nozzle of the print head, Please clean the print head in time. So as not to affect the print quality.



## 2.7. Clean

When the print head is not in good condition,Look at the picture above,Various cleaning modes can be selected to clean the print head.



Select the corresponding mode to clean the print head.

## 2.8. Flash

Turn on or off the print head standby flash Flash When the flash spray is closed, the ink stack rises. Moisturize the print head. Ink stack drops when open (You can view the current flash status in the lower left corner of the software).

**...** 

### 2.9. Left

Control the car to move left.

## 2.10. Right

Control the car to move right.

### 2.11. Feed

Control the printing material forward.

### 2.12. Back

Control the print material back

### 2.13. X reset

When the car is not at the origin, Click **<X reset>**, The car is reset to the origin.

## 2.14. Config

Attribute set

### 2.14.1. Parameter

### 2.14.1.1. Parameter -- Param

A.Printing speed: Printing task speed, low speed, medium speed, high speed

**B.Printing direction:**The printing task direction can be one-way left printing, one-way right printing, or two-way printing

C.Flash frequency: Different frequency can be selected for flash spray

Flash frequency:	64	HZ	-
	0.5	HZ	
	1	HZ	-
	-2	HZ	
	4	HZ	
X Margin:	0 16	HZ 117	
	30	ПС Н7	
	64	HZ	
	- 128	HZ	
	256	HZ	•

The higher the frequency, the greater the force of the flash, and vice versa

D.White edge :	X Margin: 43.00	X start printing position,Manually input numerical control X
nt position		

print position.

**E.Color bar option:**To add a print color bar to a print task,You can choose to add on the left, right, and both sides of the figure.

		Close Image lef Image rig	t ht
	Position:	Both Side	-
	Distance:	1	лл
	Width:	5	лл
Color bar Option			

Width:Set the width of the color bar

Distance: The distance between the color bars and the edge of the print task

#### F. Ink pad clean:

	400	nn	Onen	Close
--	-----	----	------	-------

**Open:**Click**<Open>**,Move the cart to the set value,Tick the ink pump,Drain the waste ink from the ink pad

Ink pump: Whether to open the ink pump to pump ink

HJ intelligent technology G. Fill ink:

Fill Ink				
	HEADS	- 1	Start	Stop
	HEAD1 HEAD2			
Felosion	- HEADS			

According to the need to specify the nozzle inking, cleaning nozzle Click the **Start** button to start inking and click the **stop** button to stop inking

#### H. Eclosion:

Emergence rang	;e:	0	%
	ala:		
	Strengthen eclosion:	close	-
		close	

Nozzle edge feather,Soften the PASS,The emergence effect can be adjusted according to the selection range. The larger the range, the slower the speed, the better the effect.

I. Head eclosion: For a print head mode.

**J. Strengthen eslosion:**Generally, it is opened when the nozzle is in poor condition.Turn on enhanced feathering, the print speed will be reduced, but the effect will be improved a lot,Can be printed according to the actual effect of several debugging, in order to achieve the ideal state

### 2.14.2. Calibrate

### 2.14.2.1. Calibrate - Physical

🛃 HJ print con	trol soft	ware						1000		
File Task	Print	O Stop	Pause	<b>e</b> Test	(Å) Clean	👼 Flash	Left	) Right		
• Parameter	🔮 Cal	librate	U Ve	oltage	💰 Ac	lvanced				
1 Physical		Material	selection	n <del></del>						
2 Stepping		default		<u> </u>			Attr	ibute		
3 Nozzle		Hentering	hal Caliba							
4 Color		norizoni	tal Gallbr	ation —			Pr	rint		
5 Bi-Dir		N. Alter								
6 Nozzles		Vertical Calibration — Left Right								

**A.Material selection:**Use of special models,Generally the default. **B.Horizontal Calibration :**Use of special models.



### 2.14.2.2. Calibrate - Stepping

	🖾 🔒 File Task	Frint	O Stop	Pause	Test	A Clear	n Flash	ı Le	<) ft	) Right
	• Parameter	💓 Cal	librate	U V	oltage	-	Advanced			
	1 Physical		Material	selectio	n					
	2 Stepping		default		<u> </u>				Attrik	oute
	3 Nozzle		Step Cal	ibration						
	4 Color		1 Pass	✓ 0.3	30 pixe	el 0	pı	ilse 🚺	Prir	nt
	5 Bi-Dir									
	6 Nozzles									
Ste	<b>p Calibration:(</b> (General calib Click< Print>, <i>f</i>	Calibration ration 1F As follow	on Y dire PASS be ring pictu	ection of nchmai ire shov	f the acc rk step) vs↓	uracy	of the ma	iterial		
8	7 6 5 4	4 3	2 1	+ 0 -	1 2	3	4 5	6	7	8
	If it overlaps a	t 0, no m	nore adju	ustment	s are ne	eded				
	If not, as show	n in the	following	g exam	ple↓					
8	7 6 5	4 3	2 1	+ 0 -	1 2	3	4 5	6	7	8

When other positions overlap, it is necessary to continue to adjust to the 0 position

## 2.14.2.3. Calibrate - Nozzle

d HJ print control a	oftware						
File Task Pri	nt Stop	D Pause	<b>e</b> Test	A Clean	👼 Flash	Left	Note that the second
🔹 Parameter 😻	Calibrate	U Ve	oltage	💰 A	dvanced		
1 Physical	Material	selection	1				
2 Stepping	default		<u> </u>			Attr	ribute
3 Nozzle	H-distan	ce to noz	rle 1 whe	n printin	to the le	oft	
4 Color	HEAD2	<ul> <li>✓ 3</li> </ul>		n princing		P1	rint
5 Bi-Dir	H-distan	ce to noz	zle 1 whe	n printin	g to the ri	ight —	
6 Nozzles	HEAD2	<b>_</b> 3				P1	rint
	Longitud	inal dist	ance from	each noz:	zle to nozz	zle 1 —	
	HEAD2	<b>→</b> 939				[ P1	rint

Due to the staggered ordering between multiple sprinklers,So when the nozzle is doing the printing task,There may be a situation where the drawing does not overlap or the position does not correspond.So you need to adjust the distance between the sprinklers,Until the drawing completely overlaps.As shown in the following example↓



Calibrate the distance when printing one-way to the left

B.H-distance to nozzle 1 when printing to the right:

Calibrate the distance when printing one-way to the right

C.Longitudinal distance from each nozzle to nozzle 1:

Calibrate the distance when printing lengthwise

## 2.14.2.4. Calibrate - color

🗔 🔒 📑 File Task Prin	t Stop	Pause	<b>e</b> Test	Clean	📻 Flash	Left Right	nt Feed	1 Back	X reset	Q. Config				
💓 Parameter 🜒	Calibrate	U Vo	ltage	💰 Ad	vanced									1
1 Physical	Material	selection												
2 Stepping	default		<u> </u>			Attribute								
3 Nozzle		#		H01		H02	Н	)3	H04	1	H05	H06	H07	H08
4 Color	0		KO		<b>-</b> C0		C0	•	мо	• M(	) -	YO	close0	close0 •
5 Bi-Dir		↑↓	0		0		0		0	0		0	o	0
6 Novelee			0		0		0		0	0		0	0	0
o nozzies			0		0		0		0	0		0	0	0
	j. S	G02	WO		- WO	<u>.</u>	WO	-	wo	- WC	) -	wo	close0	close0 -
			0		0		0		0	0		0	0	0
	2		0		0		0		0	0		0	0	0
		>	0		0		0		0	0		0	0	0
									Left cali	oration	Right calibration	1		

Matching color calibration: Print head color offset, It is divided into left print offset and right print offset

As following picture shows $\downarrow$ , When the cyan line completely coincides with the black line at the position of 0, there is no need to calibrate



As shown above  $\uparrow$ , The position where the cyan line completely coincides with the black line is 5, then calibration is required.

Calibrate left and right as needed.

## 2.14.2.5. Calibrate - Bi-Dir

🗔 File	<b>E</b> Task	Print	O Stop	Pause	<b>e</b> Test	A Clean	👼 Flash	Left	) Right
🔹 Par	ameter	🚸 Cal	ibrate	U V	oltage	💰 Ac	lvanced		
1 Physic	al		Material	selectio	n <del></del>				
2 Steppi	ng		default		<u> </u>			Attr	ibute
3 Nozzle			Bi-Dir (	alibratio	n ———				
4 Color			Fast	-39				Pr	int
5 Bi-Dir									
6 Nozzle	s								

Two-way calibration: Whether the positions printed back and forth overlap

Low speed, medium speed and high speed are available.When selecting these three speeds for the printing task, all three printing speeds must be calibrated

Click on the <print>,as following picture shows↓



Based on the position of zero,If it is aligned at position 0, no further adjustment is required If it's not aligned at zero,as following picture shows↓,Need to continue to adjust

ſ	Πſ	ПП	10	1 [[	1 []	I IT	Î	T	Π	Π	Π	Π	Π	Π	Π	Π	Π	Π	Π	Π	Π	Π	Π	Π	Π	Π	Π	Π	Π	m
			1	Ш	1	Ш	Ű		Ш			1	Ű	Ш						Ш	Ш	Ľ	Ш	1	Ш	1	Ш	1	1	
60	56	52	48	-44	40	36	32	28	24	20	16	12	8	4	0	-4	~8	-12	-16	-20	-24	-28	-32	-36	-40	-44	-48	-52	-56	-60

### 2.14.2.6. Calibrate - Nozzles

Use of special models

File Tas	k Print	O Stop	D Pause	e Test	Clean	👼 Flash	Left	) Right	U Feed	1 Back	X reset	Config
🤵 Paramete	r 😻 Ca	librate	U V	oltage	💰 Ac	lvanced						
1 Physical		Material	selectio	ŋ <del></del>								
2 Stepping		default		<u>.</u>			Attr	ibute				
3 Nozzle		└ Nozz1	es Adjust									
4 Color			Head		Va	alue		Hea	d		Value	
5 Bi-Dir			Head_01	0				Head_(	02	0		
6 Nozzles												Frint

Nozzles Adjust:Emergence between print heads

Jet hole adjustment array:Adjust the number of coincident holes between the spray holes,Enter the pixel Value in the Value column

## 2.15. Voltage

## 2.15.1. Voltage - Voltage setting

File Task	☐ Print ⊕ Cali	O Stop brate	Pause	Test	Clean	Flash	<b>C</b> Left	<b>N</b> ight	U Feed	1 Back	X rese	Config	y.				
1 Voltage setting			#	0.00	CH01	0.00	CH02		CH	103	(	:H04	CH05	CH06	CH07	СНО	)8
2 Temperature			H01	0.00		0.00			0.00		0.00		0.00	0.00	0.00	0.00	
	1			0.00		0.00					0.00	Refresh	Setting			0.00	

Fine tune the voltage here. Click Settings

Generally, it is only set when the ink is shallow or broken when printing

### 2.15.2. Voltage - Temperature

File Task	Frint	O Stop	Pause	e Test	Clean	👼 Flas
🥐 Parameter	🕑 Cal	librate	U	Voltage	💰 Ad	lvanced
1 Voltage setting		Temperat	ure sett	ting ——		
2 Temperature				Head1:	0.00	
				Head2:	0.00	
				Head3:	0.00	
				Head4:	0.00	
				Head5:	0.00	
				Head6:	0.00	
				Head7:	0.00	
				Head8:	0.00	
			1	Refresh	Setu	qu

Read the nozzle temperature

## 2.16. Advanced

On the advanced screen, click Manufacturer Settings.enter password: "123", Go to factory

2 Version information User pass	ward: •••• Login aS	followir	ng pi	cture shows.		
a 螨 Factory mode						
<b>M</b> otor	℃olor ��UV ★Cle	eaning (	Para	meter		
1 X motor	X-Moto Calibration			X-Moto Param Set-		
2 Y motor	Moving distance:	10000	pulse	Low Speed:	500.00	nn/s
Ink stack moto	Gear ratio:	1.961682		Normal Speed:	700.00	nn/s
		love Repos	ition	Fast Speed:	1000.00	nn/s
Scraping motor				Acce Distance:	110.00	nn
	X motor parameters are not o	commonly set—		X Move Speed:	300.00	nn/s
	X axis protection position:	0.00	nn	X Margin Width Offset:	110.00	nn
	X protection speed:	200.00	nn/s	X-Home Speed:	300.00	nn/s
	Print test chart speed:	600.00	nn/s	Return Speed:	1000.00	nn/s
	Panel set white edge offset:	60.00	nn	C Operant report is the set		a mood
	Nozzle protection time:	0.00	ns	1 One way reset is the sam	e as printin	6 Speed
	Hardware grating accuracy:	720.00				
	Software grating accuracy:	720.00				
	X-axis reset mode:	Proventation	-			

Factory mode includes Motor, Color, UV, cleaning, parameter, This will be broken down below

### 2.16.1. Motor

### 2.16.1.1. Motor - X motor

≼ Factory mode							×
🖨 Motor 🌍	Color 🍲 UV 📩 Cle	aning	Para	meter			
1 X motor	X-Motor Calibration			X-Motor Param Set			
2 Y motor	Moving distance:	10000	pulse	Low Speed:	500.00	nn/s	
Ink stack motor	Gear ratio:	1.961682		Normal Speed:	700.00	mm/s	
	и	ove Rep	position	Fast Speed:	1000.00	nn/s	
Scraping motor				Acce Distance:	110.00	nn	
	X motor parameters are not c	ommonly set		X Move Speed:	300.00	nm/s	
	A axis protection position:	0.00	mm	X Margin Width Offset:	110.00	mm	
	X protection speed:	200.00	mm/s	X-Home Speed:	300.00	mm/s	
	Print test chart speed:	600.00	mm/s	Return Speed:	1000.00	nn/s	
	Panel set white edge offset:	60.00	mm	□ One-way reset is the sam	me as printi:	ng speed	
	Nozzle protection time:	0.00	ms				
	Hardware grating accuracy:	720.00					
	Software grating accuracy:	720.00					
	X—axis reset mode:	Reposition	<u> </u>				
Import Exp	port				0k	Cancel	Apply

#### A.X - Motor Calibration

Moving distance:	10000	pulse
Gear ratio:	1.961682	

First make sure the read value of the raster decoder is normal, The car left, Observe the value of X display position in the lower left, x:=0.11as  $\rightarrow x:104.68as$ , Then click on **<X Reset>**. After confirming that it is normal, Click on **<Move>**, (Default right side is the car origin case), The car will move to the left, Click **<Reposition>** when the car stops moving. The car goes back to the origin. X gear ratio calibration completed.

#### B.X - motor param setting

Low Speed:	500.00	nn/s
Normal Speed:	700.00	nn./s
Fast Speed:	1000.00	nn./s
Acce Distance:	110.00	пл
X Move Speed:	300.00	nn./s
X Margin Width Offset:	110.00	пл
X-Home Speed:	200.00	nn./s
Return Speed:	1000.00	nn/s

#### **B1.X Motor printing speed**

The corresponding low-speed printing, medium-speed printing and high-speed printing in 2.14.1.1 are set by the figure above.Control the printing speed (as shown below).Set your desired print speed here

General			
	Printing speed:	Fast	-
	Printing direction:	Slow Normal	
	Flach frequency:	Fast	

**B2.Acce Distance :**The distance from stationary to print speed, the acceleration and deceleration of the car. The larger the value, the gentler the trolley; The smaller the value, the faster the overall car moves, but the electric machine shakes. I need to actually debug a proper value. Acceleration and deceleration begin at this parameter range of set values.

B3.X Move Speed: The moving speed of the car during the non-printing process.

**B4.X Margin Width Offset:** The starting position of the printing start. Enter a value here. When the white edge value of the printing interface is 0, it is just on the edge of the printing platform. The starting position of the current print = white edge value + white edge offset value here.

B5.X-Home Speed:Set the speed at which the car is reset to the origin.

B6.Return Speed: The speed at which the car returns during one-way reset.

#### C. X-Motor parameters are not commonly set

You are advised to contact technical support

X motor parameters are not c	ommonly set—	
X axis protection position:	0.00	nm
X protection speed:	200.00	nm/s
Print test chart speed:	600.00	nm/s
Panel set white edge offset:	60.00	nm
Nozzle protection time:	0.00	ns
Hardware grating accuracy:	720.00	
Software grating accuracy:	720.00	
X-axis reset mode:	Reposition	-

**C1.X axis protection position:**Before the car returns to the origin, in order to prevent the occurrence of inertial collision.You can set a value here to prevent inertial collisions.

**C2.X protection speed:**When the car reaches the protection position, it moves at the speed set here.

C3.Print test chart speed:Set the printing speed of the calibration chart here.

**C4.Panel set white edge offset:**Set the offset value of the white edge on the control panel;Start position of the current print = white edge value + white edge offset value.

**C5.Nozzle protection time:**Set a time value here, If the car is in a position other than the origin, it will reset the car at the set time.Protecting printer nozzle.

**C6.Hardware grating accuracy:**Raster value per inch.Adjustments are generally not recommended,The default value is 720

**C7.Software grating accuracy:**Raster value per inch,Adjustments are generally not recommended,The default value is 720

**C8.X-axis reset mode:**After the current printing task is complete,Choose to reset the cart, hold it, or return it to the guard position.(Reset is recommended).

X-axis reset mode:	Reposition	-
	Reposition	
	Do not move	
	Protection bit	

## 2.16.1.2. Motor-Y motor

X motor	Y-motor calibration			Y-motor param setting		
Y motor	Moving distance:	100.00	າມາເ	Low speed:	50.00	nn/s
	Y-run length:	100.00	ເຫ	Normal speed:	50.00	nn/s
Ink stack motor	1nn=	686.723447	pulse	Fast speed:	50.00	nm/s
Scraping motor	Y total length:	5652 *	ານາເ	Acce distance:	2.00	nn
	Tarra Cost			Y nove speed:	50.00	nn/s
	move	Surve Stroke	test	Y motor direction polarity:	default	•
	Tablet settings				ueraurt	
	Hardware raster accuracy:	720.00				
	Y margin width offset:	20.00	nn			
	B-print margin width offset:	3.00	лл			
	Y positioning mode	Limit position	i •			
	Y-axis reset mode:	shut down	-			
	Y-axis reset mode:	Limit position shut down	i •			

**A.Y** - motor calibration: Y axis gear ratio calibration, Unlike the X-axis, the printed material needs its own hand momentum to take the actual distance to calibrate

Moving distance:	100.00	mm
Y-run length:	100.00	mm
1mm=	686.723447	pulse
Y total length:	5652	mm

Make a mark with a pen on the printed material in advance,Looking for a good benchmark.And then click Move,The printed material or platform will move forward some distance.After stopping, use a tool to measure how far the printed material has actually traveled.Write the value obtained by the actual movement, click to calculate, and get the gear ratio of Y.It takes a lot of calibration.When the motion value is consistent with the measurement value, the more accurate the value is.

#### B.Y-motor param setting

Y-motor param setting		
Low speed:	50.00	mm/s
Normal speed:	50.00	mm/s
Fast speed:	50.00	mm/s
Acce distance:	2.00	nn
Y move speed:	50.00	mm/s
Y motor direction polarity:	default	•

**B1.Y-printing speed:**Low speed printing, medium speed printing, high speed printing.Control the speed at which the printed material moves during the printing process,Set parameters here to achieve your desired speed.

B2.Acce distance: Set the acceleration and deceleration distances of Y here

**B3.Y move speed:**In the process of not printing,The speed at which the printed material moves,Will be applied to the function shown below.



**B4.Y motor direction polarity:**Adjust the forward and backward direction of the printed material.Select the **<default>** to keep normal feed and return;Select **<all invert>**, will move and print material reversed;Select **<inversion movement>**, reverse only when moving.

Y motor direction polarity	default	•
	default Invert a Movement	11 inversion
C.Tablet setting		
Tablet settings		
Hardware raster accuracy:	720.00	
Y margin width offset:	20.00	mm
B-print margin width offset:	3.00	mm
Y positioning mode	Limit positi	oni 🚽
Y-axis reset mode:	shut down	<u> </u>

**C1.Hardware raster accuracy:**Raster value per inch,Adjustments are generally not recommended,The default value is 720.

**C2.Y margin width offset:** The starting position of the printing start. I usually put a value here. When the white edge value of the printing interface is 0, it is just printed on the edge of the material. The starting position of the current print = white edge value + white edge offset value here.

C3.B-Print margin width offset:Set the offset value of Y white edge when printing back.

**C4.Y positioning mode:**When using a tablet machine.Printing material may need to be positioned so that the current task is printed and then the next task is printed, or the printing position of multiple printing tasks is the same.Here we need to use positioning.



Limit positioning:It's positioned by the Y origin limit.
Code wheel positioning:Locate by the value of the code disk.
Raster positioning:Position by grating value.
Pulse positioning:Locate by pulse value.

**C5.Y-axis reset mode:**After the current printing task is complete.You can choose to reset the printing material or to reset the printing material in the opposite direction.



## 2.16.1.3. Motor-Ink stack motor

-	Factory	mode
-	ructory	mouc

🖨 Motor 🌍	Color 🙅 UV 📩 Cle	aning 🛞 Pa	arameter
1 X motor	Ink stack motor parameter set	tting —	
2 Y motor	Moving	speed: 5000	pulse
Ink stack motor	Acceleration and deceleratio	m area: 512	pulse
The stack motor	Maximum	stroke: 50000	pulse
Scraping motor	Ink stack protectio	n time: 100000	ms

A.Moving speed:Speed of ink stack movement.

**B.Acceleration and deceleration area:**Start acceleration and deceleration in the set parameter range.

**C.Maximum stroke:**Limit the maximum stroke of ink stack movement.

**D.Ink stack protection time:**The ink stack will reset within the setting time, so that the nozzle is in the moisture position.

### 2.16.1.4. Motor-Scraping motor

🗎 Motor 🖇	Color	🙅 UV	<b>d</b> Cleaning	🚻 P	aramete
X motor	Wiper mo	otor parame	ter setting		
Y motor			Moving speed:	1000	pulse
	A	1	a a		0.0100

A.Moving speed:Scraper moving speed.

**B.Acceleration and deceleration area:**Set the acceleration and deceleration to start within the parameter range.

2.16.2. Color

### 2.16.2.1. Color-Color setting



**A.Color setting:**The flash spray can be opened, and then placed under the nozzle with paper.Calibrate the color corresponding to the flash of color on the paper.

H01 corresponds to the color of flash spray in the first column.H02 corresponds to the color of spray hole flash in the second column.And so on.

G01 stands for print head 1.G02 stands for print head 2.And so on. The color selection is as follows:

#	H01
G01	Y0 -
	K0 C0
	MO YO
	WO VO
	close0

## 2.16.2.2. Color-H-calibration

Color setting	H-distance to nozzle	e 1 when printing t	o the left ——	H-distance to nozzle	e 1 when printing t	o the right -
H-calibration	HEAD1:	0		HEAD1:	0	
	HEAD2:	2		HEAD2:	2	
	HEAD3:	0		HEAD3:	0	
	HEAD4:	1750		HEAD4:	1750	
	HEAD5:	0		HEAD5:	0	
	HEAD6:	0		HEAD6:	0	
	HEAD7:	0		HEAD7:	0	
	HFAD8.	0		HEADS.	0	
	iEno.	0		iEno.	0	

Set the lateral distance between each sprinkler head and sprinkler head 1.

## 2.16.3. UV

UV lamp		Print end move Y distance:	
UV lamp from the left to nozzle: The distance between the UV lamp: Delay time: rres on both sides to increase the dist: Print compensation distance to the left: cint compensation distance to the right: Left lamp V L open L lamp	0 non non 0 non non 0 0 non 0.000 non	☐ White and co White-color print end move Y distance: Warnish print end move Y distance: Right lamp ✓ L open R lamp ✓ R open R lamp ✓ White color ✓ Warnish switch	lor auto mode 0.00 nm 0.00 mm
I R open L lamp I Vhite color I Varnish switch			

## Use of UV model

**UV lamp from the left to nozzle**:Set the distance between the left light and the lamp cap **The distance between the UV lamp**:Set the distance between two UV lamps **Delay time**:Set the advance switch time

**Pictures on both sides to increase the dist**:Sets the distance added on both sides of the image **Print compensation distance to the left**:Set the compensation distance to print left **Print compensation distance to the right**:Sets the compensation distance to print to the right

Left lamp:

L open L lamp:Left light switch when printing left

R open L lamp:Left light switch when printing right White color:Left light white color switch when printing Varnish:Left light varnish switch when printing

**Right lamp:** 

L open R lamp:Right light switch when printing left R open R lamp:Right light switch when printing to the right White color:Right light white color switch when printing Varnish:Right light varnish switch when printing

White-color print end Y move distance: Set the Y distance of UV lamp irradiation after white color printing

Varnish print end Y move distance: Set the Y distance of UV lamp irradiation after varnish printing

### 2.16.4. Cleaning

### 2.16.4.1. Clean-Automatic

🐝 Factory mode							×
Motor	℃olor 🙅UV 📩	Cleaning	🕕 Par	ameter			
1 Automatic	Cleanup			i i			
2 Manua I		□ Clean up	on printing				
<b>1</b> Flash spray	Printing interval: Cleaning mode: Frequency: Cleaning time: Free time: Flash time:	Clean up 30 Clear head 256 HZ Normal 0.10 8	when idle Pass • • • • • • • • • • • •				
Import	Export				 Ok	Cancel	Apply

These parameters can be adjusted freely when <Clean Up on printing> or <Clean Up When Idle > is selected.

### A.Clean up on printing

Cleanup		
	🔽 Clean up on prin	nting
	┌─ Clean up when ic	ile
Printing interval:	30 Pass	•
Cleaning mode:	Clear head	
Frequency:	256 HZ	-
Cleaning time:	Norma1	-
Free time:	0.10	h
Flash time:	8	s
A1.Printing inter	val:Print the	Settings (PASS) before automatic cleaning
,	Cleaning mode:	Clear head
A2 Cleaning ma	Frequency:	Flash jetting Glear head
Az.Cleaning mo	ue:	
A3.Frequency:	he frequency	of flash spray during cleaning.
	Cleaning time: N	lormal •
A4.Cleaning time	e: Free time: S	trong Choose <b><normal></normal></b> or <b><strong></strong></b> ,Set the flash spray
me of two kinds of cl	eaning respe	ctively.

**A5.Flash time:**The duration of the flash.

#### B.Clean up when idle

	□ Clean up on	printin
	☑ Clean up whe	en idle
Printing interval:	<b>30</b> Pa	SS _
Cleaning mode:	Clear head	Ţ
Frequency:	256 HZ	-
Cleaning time:	Norma1	-
Free time:	0.10	h
Flash time:	8	s

#### B1.Cleaning mode: Choose <flash jetting> or <Clear head>.

**B2.Frequency:**The frequency of flash spray during cleaning.

**B3.Cleaning time:**Choose **<Normal>** or **<Strong>**,Set the flash spray time of two kinds of cleaning respectively.

**B4.Free time:**Set the idle time to hours before cleaning **B5.Flash time:**The duration of the flash.

### 2.16.4.2. Cleaning - Manual

Automatic	Regular cleanin 🚽			X-motor		-
Manual	Pump ink tim	e1: 450	ms	Flash position: 0	nn Test	
	Pump ink tim	.e2: 0	πs		Reset	
riash spray	Punp ink tim	e3: 0	ms	Z-motor-		_
	After pump ink wait ti	me: 10000	ms	Flash height: 0	mn Test	
	Flash ti	me: 12000	ms	Pump ink height: 0	mn Test	
	Pump waste ink ti	me: 6000	ms	Scrap height: 0	mn Test	i
	Pump ink tim	es: 1			Reset	
	Ink stack			Scraping position Headl	_	_
	Flash height: 8800	pulse	Test	Scraper position:	pulse Test	
	Pump ink height: 12500	pulse	Test	<pre>( motor starting position: 7)</pre>	2 mm Test	
	Scrap height: 6000	pulse	Test	X motor end position: 1	09 mm Test	
			Reset		Reset	

#### A: Cleaning time setting

	Regular cleanin 💌		
	Pump ink timel:	450	ms
	Pump ink time2:	0	ms
	Pump ink time3:	0	ms
	After pump ink wait time:	10000	ms
	Flash time:	12000	ms
Regular cleanin 💌	Pump waste ink time:	6000	ns
Kegular cleaning Deep cleaning	Pump ink times:	1	

A1.Pump ink time1: Time required for ordinary cleaning and inking.

A2.After pump ink wait time:Set the waiting time after drawing ink

A3.Flash time: The duration of the flash.

A4.Pump waste ink time:Set the time for drawing waste ink.

A5.Pump ink times:Set the ink pumping times

**B:Flash position:**The position of the nozzle car during the flash spray.

X-motor			
Flash position:	0	mm	Test
		1	Reset

#### C: Ink stack height setting during cleaning



**C1.Flash height:**The height of the ink stack at which the flash spray occurs.

C2.Pump ink height: The height of the ink stack at which ink is drawn.

C3.Scrap height: The height of the ink stack at which ink is scraped.

#### **D:Scraping position**

Each nozzle cleaning ink scraping position



E: When cleaning, the position of Z motor

Flash height:	0	nn	Test
Pump ink height:	0	nn	Test
Scrap height:	0	nn	Test

**E1.Flash height:**Set the height of Z when flash spray.

**E2.Pump ink height:**Set the height of Z when pumping ink.

**E3.Scrap height:**Set the height of Z when scraping ink.

### 2.16.4.3. Cleaning - Flash spray

	Color	🖕 UV 📑	Cleaning	🛞 Parai	neter			
utomatic	Flash s	pray nozzle bef	ore printing. —		Nozzle flash in idle time-			
lanua l	Flas	h mode before pri	nting: Single co	ру 📩	Flash Width:	1.00	mn	
lash spray		Flash spray freq	uency: 256 HZ	<u> </u>	Ink draw interval time:	100000	ns	
		Number of fl	ashes: 10		Free ink drawing time:	10	ns	
		Each flash spray	time: 500	ns				
	Waiting	time for ink f	illing completion	n				
		Waiting	time: 10000	ms				
Import	Export					0k )	Cancel	Åpply
Import Flash	Export Spray 1	nozzlel	before p	rintir	ng:	0k )	Cancel	Αρριγ
Import Flash ash spray	Export Spray I nozzle befo	nozzle I	before p	rintir	ng:	0k )	Cancel	Apply
Import Flash ash spray Flash mod	Export Spray I nozzle befo le before prim	nozzle   reprinting.	before p	rintir	ng:	0k )	Cancel	Apply

You can choose to <close>, <single task>, or <Single copy> flash mode

ms

Flash mode before printing: Single copy 
Flash spray frequency: Single task
Single copy

Number of flashes: 10 Each flash spray time: 500

A1.Close:Do not perform flash before printing.

A2.Single task:Continuous printing only flashes once

A3.Single copy:Every print task flashes

**A4.Flash spray frequency:**The force of the ink.The larger the choice, the larger the amount of ink, and the smaller the amount of ink.

A5.Number of flashes: The number of flashes before a print task.

A6.Each flash spray time: Set the duration of each flash flash

#### B:Set the sprinkler to flash spray when idle

Nozzle flash in idle time			
Flash Width:	1.00	mm	
Ink draw interval time:	100000	ms	Waiting time for ink filling completion-
Free ink drawing time:	10	ms	Waiting time: 10000 ms

B1.Flash Width: When flash spray, the car is in the position.

B2.Ink draw interval time: When idle, draw ink once at the set time.

B3.Free ink drawing time: When idle, set the inking time.

B4.Waiting time for ink filling completion:Wait time after inking completion

### 2.16.5. Parameter

### 2.16.5.1. Parameter - Paper

per	Skip white	Feed paper before printing
hite ink	Jump white mode: Continuous Mode 🔹	Move distance to origin: 0.00 mm
humanad	Waiting time after white jump: 0 ms	Moving distance to the end: 0.00 mm.
avanceu	Set Y-speed	Auto feed after printed
eatures	Feeding speed: Fact	Paper feeding after printing: 25
PASS	Tab	
		Probe paper
	Other	$\overline{\mathbf{v}}$ Open paper detection
	<ul> <li>✓ Whether to wait for Y after printing</li> </ul>	
	☐ Open software Y reset	Y motor selection
	Limit movement Y motor	Y motor
	☐ Wait for the Y axis positioning to complete	Fallback mode
	🔽 Use different steps	Fallback mode:

**A:Skip white:**Skip the white space and start printing only where there is a picture. (When the color bar is checked, the white hop function will be disabled.

Outon has Oution				Jump white mode:	Continuous Mode 🔻
Golor bar Uption	Width: Distance:	5 1	nn nn	after white jump:	Close Step model
	Position:	Image le	• •		Continuous Model

A1.Close:White hop is not performed

**A2.Step mode1:**Follow PASS to skip the white space in the print and start printing where the image is.

**A3.Continuous Mode1:**Let the machine skip over the blank space in a row and start printing where there is a picture.

A4.Waiting time after white jump:Wait time after skipping the blank section.

Waiting time after white jump: 0 ms

**B.Set Y-speed:**The speed at which the printed material moves.You can choose low, medium or high speed

**C.Feed paper before printing:** Walk the paper before the printing task, The input value can adjust the distance to the origin or the destination.

Feed paper before printing		
Move distance to origin:	0.00	nn
Moving distance to the end:	0.00	nm

**D.Auto feed after printed:**After the print task ends, Y moves the set distance value.

Auto	feed	after	printed		
Pap	er fee	eding a	fter printing:	25	mm

E.Probe paper: Open the paper probe to detect the printed material.

Probe paper	
	🔽 Open paper detection

#### F: Other

Other
🥅 Hardware paper
🔽 Whether to wait for Y after printing
🗌 Open software Y reset
🗌 Limit movement Y motor
└─ Y reset automatically go Z
☐ Wait for the Y axis positioning to complete
🔽 Use different steps

F1.Hardware paper: Increase the speed of material removal

**F2.Whether:**After printing 1PASS, do you want to wait for the discharge to stop before printing 1PASS

F3.Open software Y reset: The moment you open the software, the printed material will reset

**F4.Limit movement Y motor:**General photo machine to use this setting.Short Y end, start to walk paper.

**F5.Y reset automatically go Z:**(flatbed machine) printing material reset. The counter sensor will automatically detect the presence or absence of occluded objects. If it is blocked, the reset of the printed material will be interrupted. Until the object is removed, then continue the reset action

**F6.Wait for the Y axis positioning to complete:**Wait until the printed material is located, and then perform the next step.

F7.Use different steps:Check the default

G.Y motor: Choose the Y motor or wiper motor. Generally, Y motor is selected.

Y	motor	selection		
		Y motor selection:	Y motor	<u> </u>

**H.Fallback mode:**Norma1 is the normal print mode;Color ink back is used to print Color ink and then white ink;End poin... Rollback is printed from the end point forward (white ink on the bottom, color ink on top).

Fallback mode-			
	Fallback mode:	Norma1	-
		Normal Color ink back	
		End poin "rollba	ick.

### 2.16.5.2. Parameter - White ink

Paper	White ink		White ink indentation		
White ink	Judgement of nozzle position:	Staggered 💌	🔽 Turn on whi	te ink inde	ntation
	Repeat print mode:	Copies 💌	White ink top indentation:	1	pixel
Advanced	Cycle W-time:	0 s	White ink bottom indentation:	1	pixel
Features	Cycle B-time:	0 s	White ink indented on the left:	1	pixel
PASS	Color ink back:	default -	White ink indented on the right:	1	pixel
	Independent white ink type:	Independent whi 🔹			
	White ink dot type:	default •			
	White ink type:	Top •			
	Intelligent filling white ink:	Shut down			
	White ink printing times:	1			

#### A:White ink

**A1.Judgement of nozzle position:**The physical location of the nozzle.Divided into side by side and error row, generally for error row.

A2.Repeat print mode: You can choose Copies, PASS or Bidirection.

Repeat print mode:	Copies	•
a 1 w	Copies	
Cycle W-time:	Pass	
	Bidirection	
C1- D +		_

A3.Copies: Print white ink first, then print color ink.

A4.Pass:No matter how many times you print with white ink, do it all at once.

**A5.Bidirection:**Bidirectional printing of white ink, color ink printing direction according to the setting of the printing direction.

**A6.Cycle W-time:**White ink is different from color ink, which precipitates faster.Therefore, it is necessary to cycle once every period of time to prevent precipitation.Set the working time of the white ink cycle here.

A7.Cycle B-time: Time to stop working after the completion of the white ink cycle.

**A8.Color ink back:**Default is white ink below, color above.**Color ink back** to color ink in the following, white ink in the top.**End Rollback** is printed in reverse, that is, from the End to the front(White ink on the bottom, color ink on the top).

Color	ink	back:	default	•
white	ink	type:	default Color ink back:	
te ink	dot	type:	End rollback	- 1

A9.Independent white ink type: Choose the type of white ink you want to print.

Independent white ink type: White ink dot type: Unified …ink type:

A10.Unified ...ink type:Unified printing only one type of white ink(for special models). A11.White ink dot type:You can choose big, small, medium.Generally choose the default.

White ink dot type: White ink type: t filling white ink: default smaller midpoint bigger

A12.Top: The white ink is printed below.

White ink type:	Top 🔹
lling white ink:	Top Botton
printing times:	Only White Only Color

A13.Botton:The color print is below.

A14.Only White: Print white ink only.

A15.Only Color: Print color ink only.

**A16.Intelligent filling white ink:** In the case of no spot color, After opening, print the white ink first. Then print color ink on white ink.

Intelligent filling white ink:	Shut down 👻
	Shut down
white ink printing times.	Turn on

**A17.White ink printing times:**When the white ink needs to be thickened, you can set the number of white ink printing here.

**B:White ink indentation:**In the case of white ink,The printed color ink does not cover the white ink, you can open the white ink indentation here.Shrink the area around the white ink to be printed.



## 2.16.5.3. Parameter - Advanced

1.1				
aper	Print		Ink stack type	
White ink	☐ Mirror print:	ing	Ink stack type: Elevation type	• •
Advanced	└─ Delete PRN a:	fter printing		
	Turn on USB :	flash to continue print	Flat lift mode	
Features		Decrypt: Close 💽	Plate lifting mode: shut down	<u> </u>
PASS	1bit to 2Bit p	oint type: Default: 🚽	Glean mode	
	Print quantity dis	play mode: Default: 👻	Cleaning mode: Default	
	White bo	rder mode: Independe 🕶	Deraut	
	Continue Pri	nting APO: Close -	Picture width limit	
	Horizontal multiple p	rint mode: Speed mod v	Horizontal width limit: 0	nn
			Vertical width limit: 0	nn
	Sharp edge			
	I√ Turn on and p	play while sharp	Color bar	
	🔽 Automatically	y start printing	Color bar mode: Default	<u> </u>
			Color has death.	1
Import	How long does rip start	printing: 50 %	Ok	Cancel App
Import S Factory mode	How long does rip start Export	Cleaning	Color oar depth: ALL	Cancel App
Import G Factory mode	How long does rip start Export Color OUV	Cleaning () print mode. Speed mod	arameter	Cancel App
Import # Factory mode Motor Paper White inter	How long does rip start Export Color OUV	Cleaning UP	Vertical width limit: 0	Cancel App
Import Factory mode Motor Paper White ink	How long does rip start Export Color OUV NOTIFICAT AUTOPORT Sharp edge Turn on and	printing:     50     %       Cleaning     Image: Speed mode        print mode:     Speed mode        play while sharp	Vertical width limit: 0 Color bar	Cancel App
Import Factory mode Motor Paper White ink Advanced	How long does rip start Export Color OUV H HOFIZOHTAL MAILING Sharp edge V Turn on and V Automatical	printing: 50 %	Vertical width limit: Color bar Color bar Default	Cancel App
Import Factory mode Motor Paper White ink Advanced Features	How long does rip start Export Color OUV NOTIONAL AUTIPUT Sharp edge IV Turn on and IV Automaticall How long does rip start	printing: 50 %	Color bar depth: ALL Ok Vertical width limit: 0 Color bar Color bar mode: Default Color bar depth: ALL	Cancel App
Import Factory mode Motor Paper White ink Advanced Features	How long does rip start Export Color OUV	printing: 50 %	Color bar depth: ALL Ok Vertical width limit: 0 Color bar Color bar mode: Default Color bar depth: ALL	Cancel App
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Import Factory mode Motor Paper White ink Advanced Features PASS	How long does rip start Export Color OUV Color UV Color Colo	printing: 50 %	Color bar depth: ALL  Ok  Arametor  Vertical width limit:  Color bar  Color bar  Color bar depth: ALL  Eclosion  F  Open the first PASS feather inder  Number of seamless feathering rows:  180 Eclosion adjustment unit: 360	Cancel App
Import Factory mode Motor Paper White ink Advanced Features PASS	How long does rip start Export Color OUV HOTEOMAT WATERPORT Sharp edge IV Turn on and V Automaticall How long does rip start Task record Print record retent History s Print mode: File name:	printing: 50 %	Color bar depth: ALL       Ok       Vertical width limit:       0       Vertical width limit:       0       Color bar       Color bar       Color bar       Default       Color bar depth:       ALL       Eclosion       Image: Color of seamless feathering rows:       180       Eclosion adjustment unit:       360	Cancel App
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Import Factory model Motor Paper White ink Advanced Features PASS	How long does rip start Export Color OUV NOTIONAL AUTIPLE Sharp edge IV Turn on and IV Automaticall How long does rip star Task record Print record retent History s Print mode: File name: Print mode:	printing:     50     %       Cleaning     ()) P       print mode.     Speed mode       play while sharp       .y start printing       t printing:     50       .y start printing       t printing:     50       .y start printing       t printing:     7       .y start printing       t printing:     7       .y start printing       t printing:     7       .y start printing       t printing:     7	Color bar depth: ALL  Ok  Arametor  Vertical width limit:  Color bar mode: Color bar mode: Color bar depth: ALL  Eclosion  Color bar depth: ALL  Color bar depth: ALL  Color bar depth: ALL  Color bar depth: Colo	Cancel App
Import Factory model Motor Paper White ink Advanced Features PASS	How long does rip start Export Color	printing:     50     %       Cleaning     P       printing:     Speed mod       play while sharp       ystart printing       t printing:     50       ion time:     7       qave time:     7       WF1       Middle_1	Color bar depth: ALL  Ok  Arametor  Vertical width limit:  Color bar  Color bar mode: Default  Color bar depth: ALL  Color bar depth: ALL  Eclosion  For Open the first PASS feather inder Number of seamless feathering rows: 180 Eclosion adjustment unit: 360  Data processing  Print pattern pattern: Frint State diagram special print mode: Normai Parity nyint V offeat:	Cancel App

Print			
└─ Mirror prim	nting		
🗌 Delete PRN	after print	ing	
☐ Turn on US	B flash to c	ontinue pr	int
	Decrypt:	Close	-
1bit to 2Bit	point type:	Default:	•
Print quantity d	isplay mode:	Default:	-
White	border mode:	Independe	<u>-</u>
Continue P	rinting APO:	Close	•
Horizontal multiple	print mode:	Speed mod	-

A1.Mirror printing: Mirror the print task before printing.

A2.Delete PRN after printing: The task of deleting the print list after the print task is complete.

**A3.Turn on USB flash to continue print:**After the USB is turned on, the printing will not be affected if the USB is not in good contact or intermittently broken.For special models.

A4.Decrypt:Unencrypt the Nozzle.This feature is usually not used.

**A5.1bit to 2bit point type:** If you need to print large and medium points, you need to switch from 1bit to 2bit.Generally choose the default.

A6.Print quantity display mode:Displays the number of print tasks completed.Generally choose the default

A7.White border mode:Some special models use this mode.

**A8.Continue Printing APO:** If open. The power went out in the middle of printing. After restarting the printer, you can continue to complete the last unfinished printing task. Use of special models.

A9.Horizontal multiple print mode: You can choose speed mode or precision mode.

When selecting precision mode. In the printing of horizontal multi-frame tasks, the distance between the intervals will not appear error; When you select speed mode. When printing a horizontal multi-frame task. The printing speed is faster, but the spacing may be a little wrong. Can choose according to need.

#### B: Sharp edge

Sharp e	edge-			
	~	Turn on and play while	e sharp	
	~	Automatically start pr	rinting	
How	long	does rip start printing:	50	%

When **<Turn on and play while sharp>** and **<Automatically start printing>** are selected simultaneously. The RIP function can be printed at the same time.

How long does rip start printing: When the RIP reaches the set value, the printing task is performed.

#### C:Task record

**Print record retention time:**Sets how long the print record needs to be kept **History save time:**Sets the time for saving printed history tasks.

Task record		
Print record retention time:	7	day
History save time:	7	day

**D:Print mode:**waveform selection.If the current selected waveform appears shallow or broken ink during the printing task.You can change the waveform here.Print again and check the print effect again.

	File name:	WF1	
	Print mode:	Middle_1	-
Pr	int speed limit:	1200.00	mm/s

D1.Print mode:Select the point where you want to use the waveform.

D2.Print speed limit: The maximum print speed of the current waveform. Generally not modified.

#### E:Ink stack type

Ink stack type	
Ink stack type:	Elevation type 🔻
	Slide type Elevation type

**E1.Slide type:**Sliding ink stack.The car moves to the origin and resets.When touching the ink stack block, the ink stack rises, and the moisturizing nozzle;The car moves out and the ink stack drops by itself.

**E2.Elevation type:**Lifting structure ink stack.

**F.Flat lift mode:** In this choice is the car head lifting or flat lifting,No Z axis is no lifting, or manual control platform lifting.

Flat lift mode		
Plate lifting mode:	shut down	•
	shut down	
Clean mode	Nose lift Flat lift No Z axis	

#### G.Picture width limit

Picture width limit		
Horizontal width limit:	0	nn
Vertical width limit:	0	nm

**G1.Horizontal width limit:**Width limit for the number of horizontal prints.When the number of horizontal tasks to print exceeds the length of the printed material, a limit on the total print width is required.

**G2.Vertical width limit:**Width limit for the number of lengthwise prints.When the number of vertical tasks to print exceeds the length of the printed material, the total print width is limited.

#### H:Clean mode

Cleaning mode:	Dofault	
	Cleaning mode:	Cleaning mode: Default

The cleaning action is default.

HJ intelligent technology I:Color bar

Color bar mode:	Default	-
Color bar depth:	Default	

**I1.Color bar mode:**After this function is enabled, color bars will be printed according to the PASS number of the current printing task.Can be printed through the color bar to check whether the nozzle is blocked, or broken ink, etc.Also can prevent in the printing process, such as broken ink.Select the default.

**I2.Color bar depth:**Print color bar ink concentration;Select ALL, the color bar is obvious;Select 1/2, color bar color half light;Choose 1/4, very light color bars.

#### **J:Eclosion**

Eclosion		
🔽 Open the first PASS feathe	r inden	tation
Number of seamless feathering rows:	180	mm
Eclosion adjustment unit:	360	mm

After printing, feather from the first PASS.The value is generally the default value.

### 2.16.5.4. Parameter - Features

I raper	Signal switch	Ink supply mode
White ink	☐ Suction	Ink supply mode: Non automatic i 🚽
Advanced Features	☐ heating ☐ Detect the end of printing paper test signal	interface
PASS	External devices Open the control panel External device mode Inking time: 3 s	<ul> <li>□ Paper width</li> <li>□ Print</li> <li>□ Moisturizing</li> <li>□ Y white border</li> </ul>
	UV lamp mode UV lamp mode: shut down	<ul> <li>✓ White ink</li> <li>✓ Print back</li> <li>✓ Flash spray switch</li> <li>✓ Ink cartridge status</li> </ul>

#### A:Signal switch

Signal switch	
□ Suction	
□ heating	
☐ Detect the end of printing	paper test signal

**A1.Suction:**Hold the material such as paper, so that the printed material is stuck on the printing platform.

A2.heating: Apply heat to printing materials, etc.

**A3.Detect the end of printing paper test signal:** You can use this function when you turn on repeat printing. After the current printing task is finished and the car is reset to the origin, detect whether the paper signal can receive data. If there is no signal, the next print will not continue. If received, the next task is printed.

#### **B:External devices**

External devices	 
$\overline{ullet}$ Open the control panel	
🗆 External device mode	

**B1.Open the control panel**: If you uncheck the box, the control panel function on the machine will be disabled.

B2.External device mode: A function of connecting to other external devices (for special models).

**C:interface:**The items selected here will be displayed in the comprehensive interface within the printing software.Special function check box.

interferen.
Interface
☐ Altitude
□ Paper width
□ Print
└ Moisturizing
└ Y white border
✓ White ink
🔽 Print back
🔽 Flash spray switch
🔽 Ink cartridge status

**C1.Altitude:**Check the height of the printing material from the nozzle.

**C2.Paper width:**Check the width of the printed material.

**C3.Print:**When multiple RIP files need to be printed simultaneously.Check Print to print all tasks in the print list.

**C4.Moisturizing:**The ink stack moisturizes the nozzle.

C5.Y white border: The starting printing position in the Y direction of the printing material.

**C6.White ink:**Check this option if you want to use white ink.

**C7.Print back:**Print the current task backwards.

C8.Flash spray switch: The button that controls the flash spray on and off.

**C9.Ink cartridge status:**Displays the current cartridge status.

### 2.16.5.5. Parameter -PASS

Paper	001 (11)			
	DPI settings			
White ink	180X180	XDPI:	180	
	360X180	YDPI:	180	
Advanced	360X360	Number of print modes:	1	
Features	360X1080	modelPASS:	1	
DACC	720X360	node2PASS:	0	
100	720X1080	node3PASS:		
	720X1440	node4Piss:	0	
	720X2160	Adden Ass.	0	
		node5PASS:	0	
	上移  下科	Add Modify	y Delete	
				_

**DPI setting:**DPI is the number of ink drops per inch.For example, 600 dpi is 600 drops per inch(The following is an example of 720X1080DPI).

XDPI: The number of horizontal ink drops is 720.

YDPI: The number of vertical ink drops is 1080.

**Number of print modes:**Corresponding to the following pattern. If you enter 1, only mode 1 is available. If you enter 5, all the following modes are enabled. It is not recommended to make any adjustment here.