

# Operation Manual

## DTF-1202D Printer



- To ensure correct and safe use of this product based on a full understanding of its performance, please read this manual thoroughly and keep it for future reference.
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- The contents of this manual and the specifications of this product are subject to change without prior notice.
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# Contents

|  |           |
|--|-----------|
| <b>Chapter 1. Printer Safety Instructions</b> .....      | <b>01</b> |
| 1.1 Important Safety Instructions .....                  | 01        |
| 1.2 Precautions When Using the Printer.....              | 01        |
| 1.3 Precautions for Ink Cartridge Usage .....            | 02        |
| 1.4 Printer Installation Requirements .....              | 02        |
| 1.5 Warnings, Cautions, and Notes.....                   | 04        |
| <b>Chapter 2. Structural Diagrams</b> .....              | <b>05</b> |
| 2.1 Function Introduction .....                          | 05        |
| 2.2 Overall Appearance Structure Diagram .....           | 05        |
| 2.3 Carriage Structure Diagram .....                     | 06        |
| 2.4 Left-side View of the Printer .....                  | 06        |
| 2.5 Right-side View of the Printer .....                 | 07        |
| <b>Chapter 3. Printer Basic Parameters</b> .....         | <b>07</b> |
| 3.1 Basic Parameters.....                                | 07        |
| <b>Chapter 4. Hardware Installation</b> .....            | <b>09</b> |
| 4.1 Introduction to the Printing System.....             | 09        |
| 4.2 Printer Control Board and Nozzle Configuration ..... | 09        |
| 4.3 Printer Control Board Interface Definition .....     | 09        |
| 4.4 Motherboard Interface.....                           | 10        |
| 4.5 Motherboard Wiring and Pin Definitions.....          | 10        |
| 4.6 Printer Board Installation and Wiring Diagram .....  | 11        |
| <b>Chapter 5. Software</b> .....                         | <b>11</b> |

|   |           |
|---|-----------|
| 5.1 Software Installation.....  | 11        |
| <b>Chapter 6. Nozzle Installation .....</b>                           | <b>13</b> |
| 6.1 Carriage Board Printhead Arrangement .....                        | 13        |
| 6.2 Printhead Data Cable Connection Methods.....                      | 14        |
| <b>Chapter 7. Computer Connection Settings for Printing Software</b>  | <b>15</b> |
| 7.1 Set Computer IP Network.....                                      | 15        |
| 7.2 General Software Settings .....                                   | 15        |
| 7.3 Control Panel Description.....                                    | 18        |
| <b>Chapter 8. Procedures for Printing Calibration Adjustment.....</b> | <b>19</b> |
| 8.1 Introduction for Nozzle Detection Function .....                  | 19        |
| 8.2 Stepping Calibration Function .....                               | 20        |
| 8.3 Calibration of the Horizontal Spacing of Nozzles.....             | 21        |
| 8.4 Calibration of Longitudinal Spacing of Nozzles.....               | 22        |
| 8.5 Bidirectional Calibration .....                                   | 23        |
| 8.6 Color Calibration .....   | 24        |
| <b>Chapter 9. Installation and Usage of RIIN Software .....</b>       | <b>26</b> |
| 9.1 RIIN Installation .....   | 26        |
| 9.2 Introduction and Usage Instructions of RIIN Interface.....        | 28        |
| <b>Chapter 10. Maintenance Guidelines .....</b>                       | <b>29</b> |

# Chapter 1. Printer Safety Instructions

Please read the following instructions before using your DTF-1202D printer series product, and observe all warnings and instructions marked on the printer.

## 1.1 Important Safety Instructions

- Do not block any openings on the printer's enclosure.
- Do not insert any objects into the slots of the printer; take care to avoid spilling liquids into the printer.
- Only use the power type specified on the printer's label. Depending on the country or region, either 110V or 220V AC power may be required.
- Connect all equipment to a properly grounded outlet. Avoid using outlets on the same circuit as devices that regularly switch on and off, such as copiers or air conditioning systems.
- Avoid using outlets controlled by wall switches or automatic timers.
- Keep your computer system away from potential sources of electromagnetic interference, such as speakers or cordless telephone bases.
- Do not use damaged or worn power cords.
- If using an additional power cord, ensure the total amperage of all devices connected to it does not exceed the cord's rated amperage. Also, ensure the total amperage of all devices plugged into the wall outlet does not exceed the outlet's rated amperage.
- Do not attempt to repair the printer yourself.
- Disconnect the power and contact qualified service personnel if any of the following occur:
  1. If the power cord or plug is damaged;
  2. If liquid is spilled into the printer;
  3. If the printer is dropped or the enclosure is damaged;
  4. If the printer does not operate normally or shows a significant change in performance.

## 1.2 Precautions When Using the Printer

- Do not move the printhead by hand, as this may damage the printer.
- Always use the power switch to turn off the printer. When the switch is pressed, the power will be cut off. Do not unplug the printer's power cord or data cable until the power has been fully disconnected.
- Before moving the printer, ensure the printhead is in its home position and secure it.

## 1.3 Precautions for Ink Cartridge Usage

- Keep ink bottles out of reach of children. Do not allow children to drink from or come into contact with the bottles.
- If ink gets on your skin, wash it off immediately with soap and water. If ink gets into your eyes, rinse them thoroughly with clean water immediately.
- Do not shake the ink bottle, as this may cause leaks.
- After using an ink bottle for a period of time (generally three months), remove it immediately for thorough cleaning and allow it to dry. When replacing with a new ink bottle, pay attention to cleaning to ensure print quality.

## 1.4 Printer Installation Requirements

- Site Preparation

The customer is responsible for complying with all installation requirements and maintaining them during the machine's operation. Failure to do so may result in improper machine function.

- Work Area

The Work Area refers to the region adjacent to the DTF-1202D printer (hereinafter referred to as the equipment), as shown in the diagram (Length × Width × Height: 850 mm x 665 mm x 500 mm / 33.46 × 26.18 × 19.69 in).

It is essential to emphasize that users must ensure the safety of personnel operating within this area.

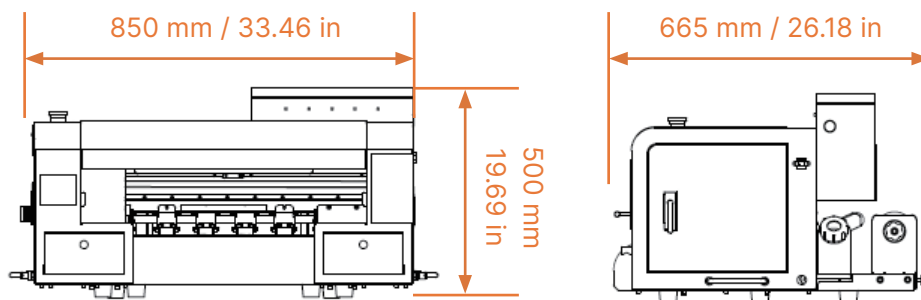


Figure 1: Work Area Diagram Surrounding the DTF-1202D Printer (Units: mm)

- Environmental Requirements

The equipment should be kept away from seaming machines (fabric splicing machines) or other radio frequency sources. The floor should be easy to clean and should not generate dust or static electricity. To assist operators and customers in accurately judging color, neutral gray finishes and pure white light (fluorescent lighting) are recommended for illumination. The equipment should be installed in a clean, dust-free environment with temperature and relative humidity controlled within the following ranges:

1. Altitude: Below 1000 meters
2. Operating Temperature: 15–30°C
3. Relative Humidity: 35%–70%

- Space Clearance Requirements

The equipment requires 2.0 meters of clearance in front, 1.0 meter at the back, and 1.0 meter on each side.

Additionally, the clearance area includes a height of 3 meters above the floor. Furthermore, space should be left in front of and behind the machine to allow for loading and unloading media and consumables.

- Safety Requirements

1. Fire Prevention

Inks and solvents must be stored in dedicated flammable-liquid storage cabinets or in separate storage rooms, clearly labeled to comply with professional safety regulations.

Ink storage must strictly adhere to local fire codes governing the use and storage of flammable materials.

Carbon dioxide (CO<sub>2</sub>) and dry chemical fire extinguishers must be placed in clearly visible and easily accessible locations along all access routes. They should be positioned near the equipment and flammable liquid storage cabinets (or rooms), or as otherwise required by local fire regulations.

2. Ventilation

Adequate ventilation is essential to prevent hazardous accumulation of volatile vapors. The air in the work area must be replaced approximately 6 to 8 times per hour. Ventilation inlets should be positioned low enough to prevent vapors from accumulating near the floor.

An exhaust system is required to remove solvent vapors released during fabric drying, as solvents in the ink evaporate when passing through the dryer.

Note: Solvent vapors are heavier than air and tend to accumulate near the floor.

Electrical equipment installed near the work area must comply with GB/T standards and relevant national electrical codes for Class I, Division 2 hazardous locations, and must be installed by a qualified, licensed electrical contractor.

Disposal of hazardous waste generated during printer operation must conform to specific storage and handling requirements mandated by relevant authorities.

### 3. Electrical Requirements (It is strongly recommended to equip the system with a UPS and a voltage stabilizer.)

The DTF-1202D printer uses single-phase power and must be properly grounded. (Voltage between ground wire and neutral wire must not exceed 0.3 V. Grounding resistance must be less than 3  $\Omega$ .)

Power supply specifications: Voltage: 220 V AC ( $\pm 10\%$ )

Frequency: 50 Hz or 60 Hz

Users must have a qualified electrician or licensed contractor install the power outlet. Circuit breaker ratings are as follows:

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

Maximum power consumption: less than 0.4 kW;

Average power consumption: approximately 0.3 kW.

Recommended Ups capacity: 2 kVA (used for all power needs except heating)

The main power outlet must be located no more than 2 meters from the equipment's power input terminal.

It is recommended to use a voltage stabilizer.

Ground Wire Installation: Connect the ground wire to the common grounding metal plate inside the equipment. Then, set a multimeter to the 200 V AC range, place one probe on the ground wire and the other on the neutral line of the AC input.

A reading below 1 V is acceptable.

## 1.5 Warnings, Cautions, and Notes

- Warning: Must be followed to prevent personal injury.
- Caution: Must be observed to avoid equipment damage.
- Note: Contains important operational information and helpful tips for using the printer.

# Chapter 2. Structural Diagrams

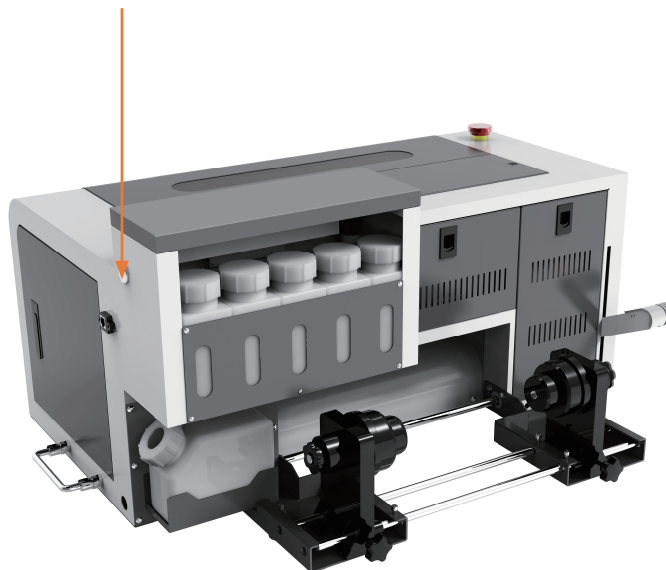
## 2.1 Function Introduction

White ink circulation at startup: power switch and emergency stop are reserved and can be cycled when powered on.

Power switch



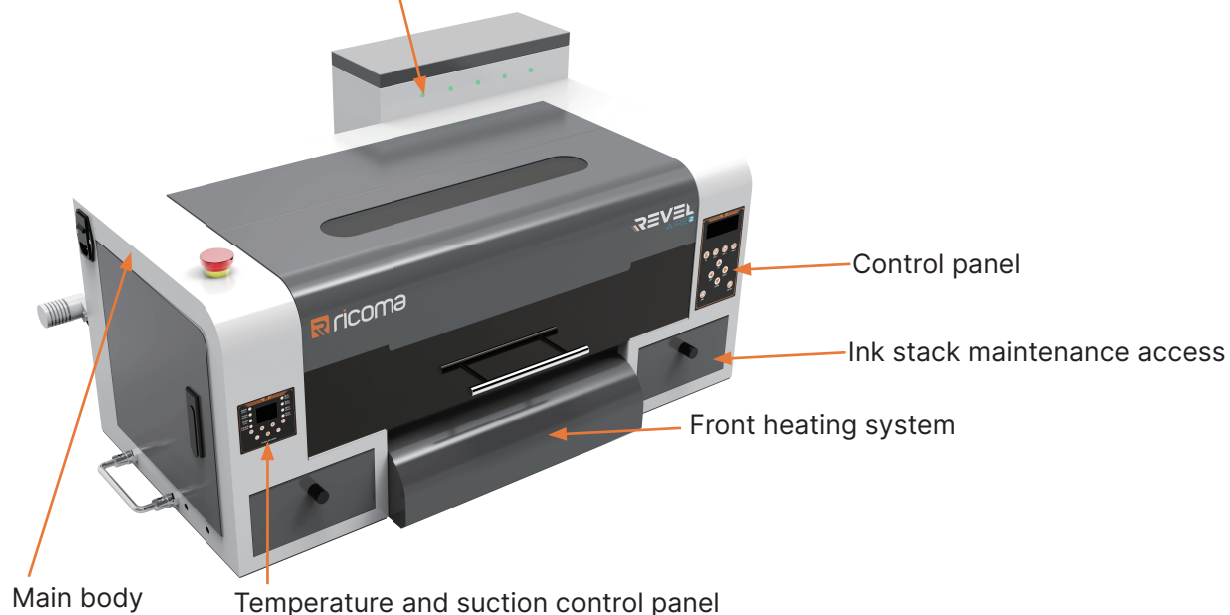
White ink circulation button



Emergency stop button

## 2.2 Overall Appearance Structure Diagram

Ink shortage alarm light



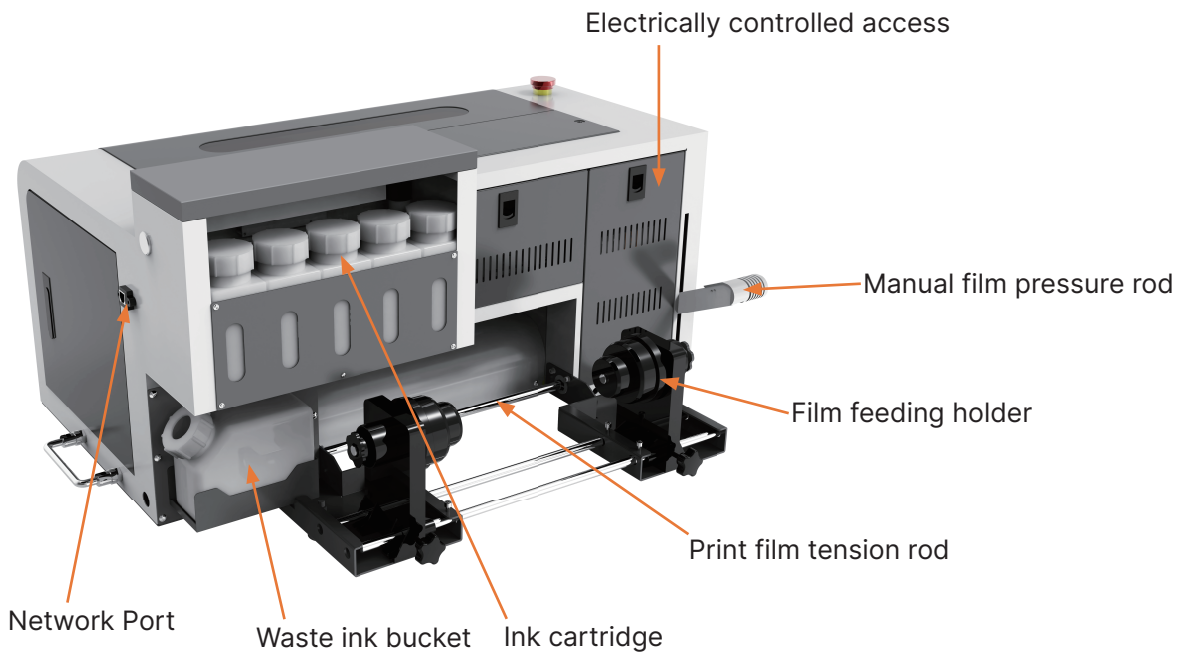
Control panel

Ink stack maintenance access

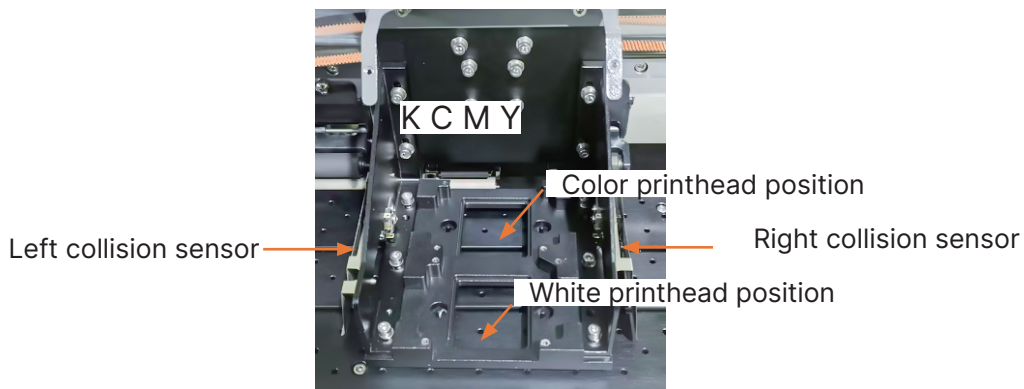
Front heating system

Main body

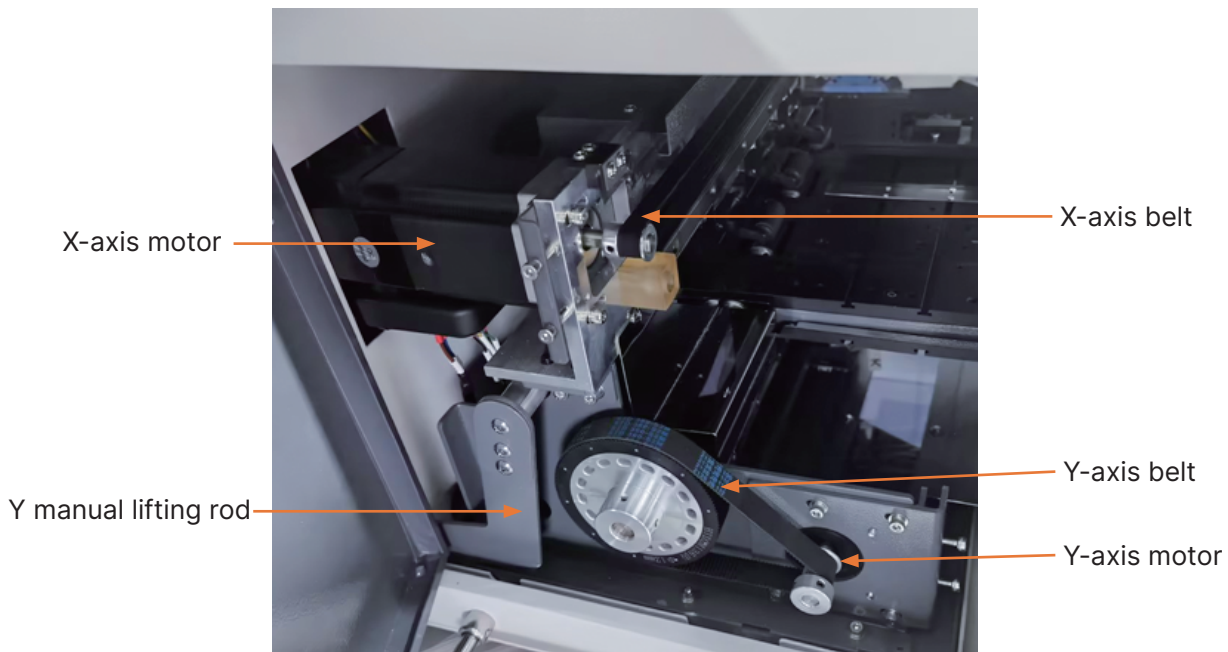
Temperature and suction control panel



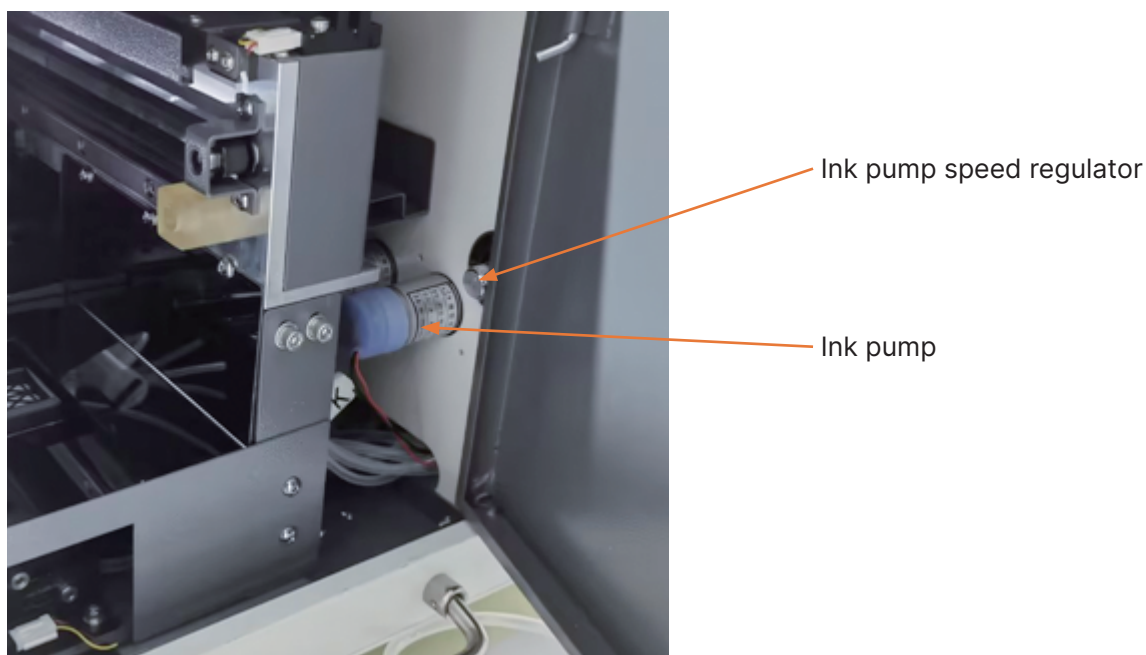
## 2.3 Carriage Structure Diagram



## 2.4 Left-side View of the Printer



## 2.5 Right-side View of the Printer



# Chapter 3. Printer Basic Parameters

## 3.1 Basic Parameters

|                          |   |
|--------------------------|---|
| Model                    | DTF-1202D   |
| Printhead Type           | I1600   |
| Number of Printheads     | 2   |
| Printable Area           | ≤300mm  |
| Printing Configuration   | Color + White (KYCM+WWWW)   |
| Compatible Media         | PET Heat Transfer Film  |
| Print Speed / Resolution | 6 Pass 720 × 1800 3.5 <sup>2</sup> /H ; 8 Pass 720 × 2400 2.0 <sup>2</sup> /H |
| Ink Type                 | Aqueous (Water-based) Ink   |
| RIP Software             | SAI Flexi (PP)/ RIIN  |
| Color Management         | ICC profiles or Density Curves  |

|   |  |
|---|--|
| Operating System                            | System Windows 7 / 10  |
| Heating and Drying Function                 | Front printing arc plate heating   |
| Carriage Collision Protection               | Emergency stop sensors with collision detection installed at both ends of the carriage |
| Film Shortage Alarm Function                | No   |
| Waste Ink Alarm                             | Automatic alert when ink level in bottle is low  |
| Ink Circulation & Agitation                 | Circular stirring when starting printing work  |
| Low Ink Alarm                               | Automatic alert when ink level in bottle is low  |
| Print Bed Lighting                          | LED illumination on print platform   |
| Automatic Rode Lifting and Film Pressing    | Boom   |
| PC Assembly                                 | No   |
| Print Platform Suction Fan Speed Controller | Adjustable platform suction  |
| Interface                                   | Gigabit Ethernet   |
| Operating Temperature                       | 15°C - 30°C  |
| Operating Humidity                          | 35% - 70%  |
| Film Receiving                              | Automatic induction receiving  |
| Rated Power Consumption                     | 300 W  |
| Power Input                                 | 50HZ / 220V 1.4A ; 60HZ / 110V 2.7A  |
| Net Weight                                  | 56.5 KG  |
| Gross Weight                                | Machine + crate package 76.5 KG  |
| Machine Dimensions                          | (L)x (W)x (H): 850 mm × 665 mm × 500 mm<br>33.46 × 26.18 × 19.69 in                    |
| Packaging Dimensions                        | (L)x (W)x (H): 1370 mm × 1210 mm × 710 mm<br>53.94 × 47.64 × 27.95 in                  |

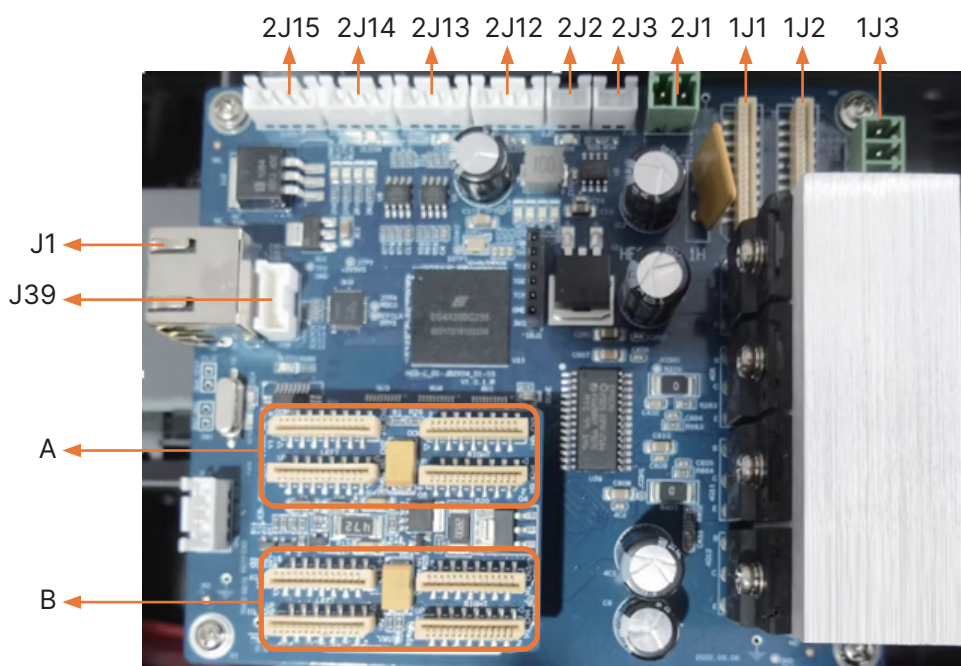
# Chapter 4. Hardware Installation

## 4.1 Introduction to the Printing System

The DTF-1202D printing control system consists of three components: the main board, the printhead board, and the control software. It connects to a PC via a USB 2.0 port.

## 4.2 Printer Control Board and Nozzle Configuration

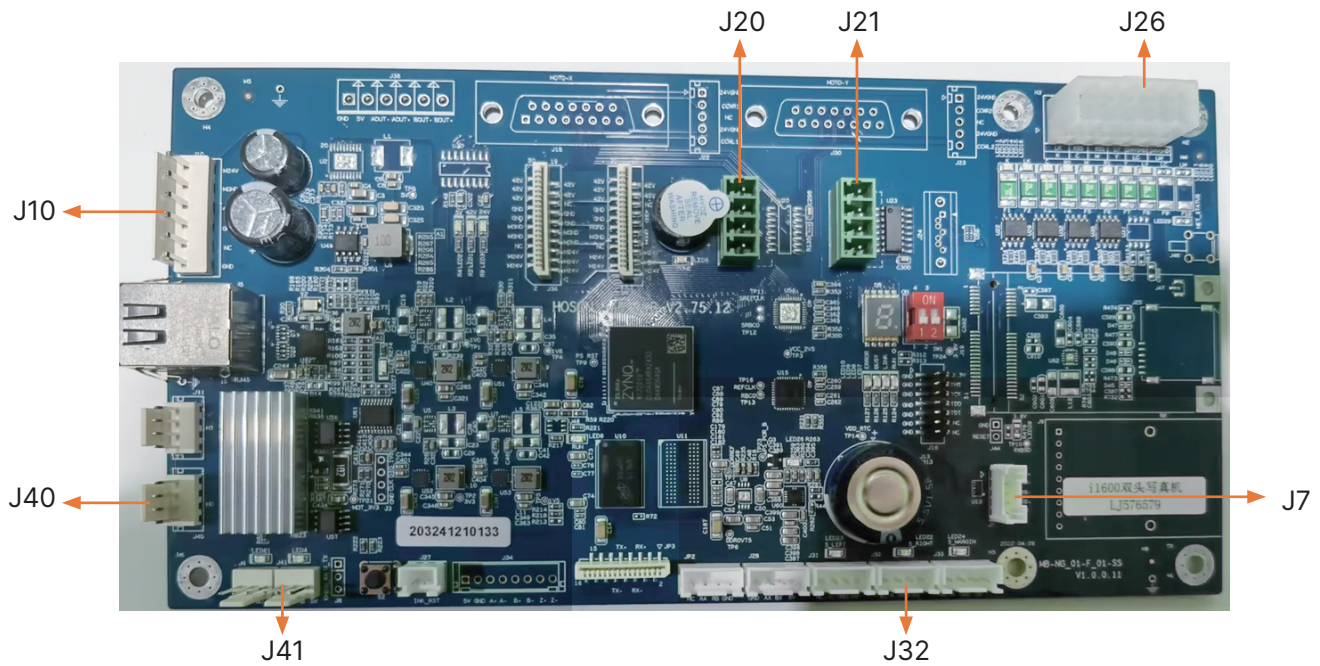
Board interface connection sequence: Power first, followed by high-speed communication interfaces, low-speed communication interfaces, and finally control interfaces.



## 4.3 Printer Control Board Interface Definition

| No.  | Interface Definition               | No. | Interface Definition                           |
|------|------------------------------------|-----|--|
| J1   | RJ45 Cable Communication Port      | 2J2 | Collision-proof Interface                      |
| J39  | 5-pin Cable Communication Port     | 2J3 | 10K NTC Thermistor Feedback Port               |
| 2J15 | Encoder Strip Interface            | 2J1 | Heated Bed Interface                           |
| 2J14 | Left Limit Switch Port             | 1J1 | FPC (Flexible Printed Circuit) Power Interface |
| 2J13 | Right Limit Switch Port            | 1J2 | FPC (Flexible Printed Circuit) Power Interface |
| 2J12 | Film Sensing Interface             | 1J3 | Power Input Port                               |
| A    | Color Ink Nozzle Adapter Interface | B   | White Ink Nozzle Adapter Interface             |

## 4.4 Motherboard Interface



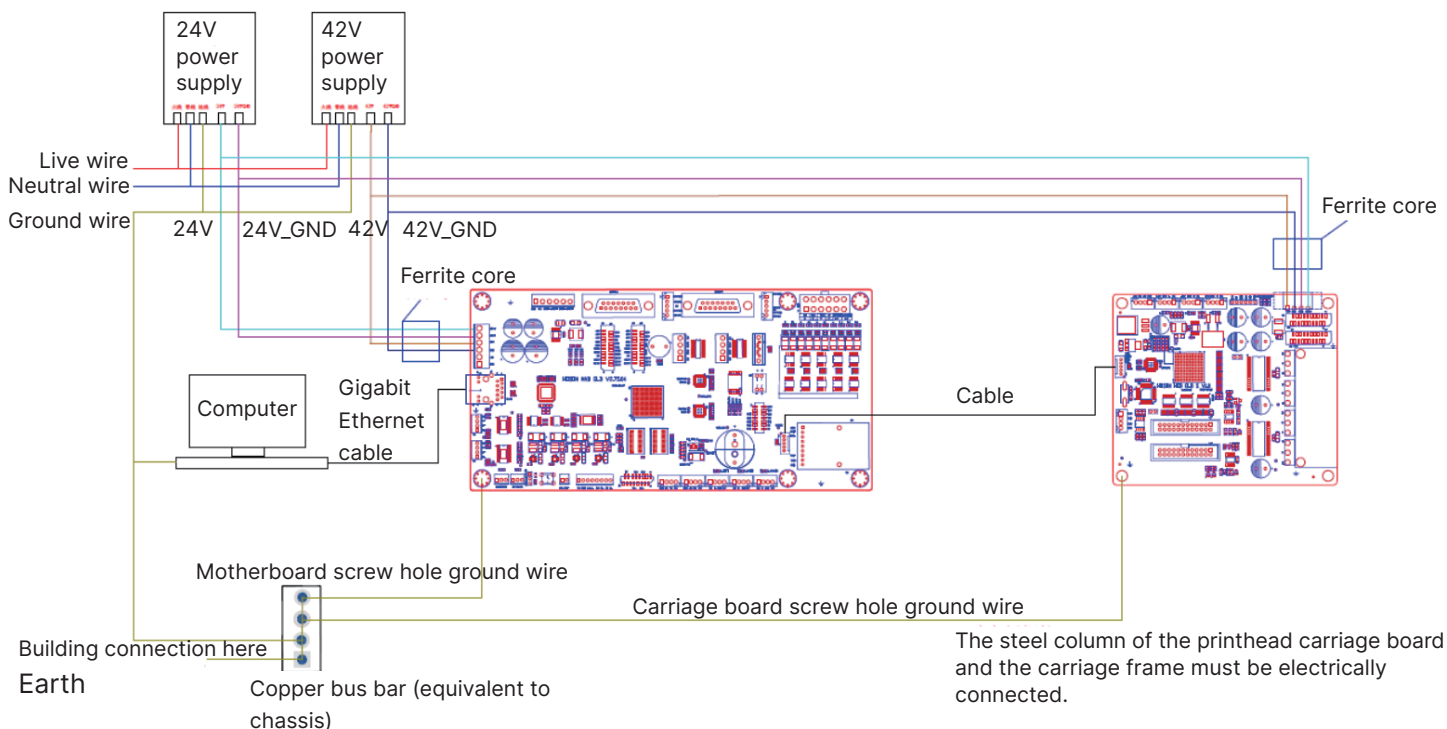
## 4.5 Motherboard Wiring and Pin Definitions

| No. | Interface Definition                              | No. | Interface Definition                    |
|-----|---|-----|---|
| J10 | Power Supply (24 V / 42 V) Input Interface        | J7  | 5-pin Cable Communication Port          |
| J20 | X-axis Motor Single-output Interface              | J32 | Carriage Origin                         |
| J21 | Y-axis Motor Differential Signal Output Interface | J40 | Ink Stack Lift Motor Interface          |
| J26 | 24V Control Signal Output Interface               | J41 | Ink Stack Lifting Motor Limit Interface |

Note: The motherboard design requires dual 24V power inputs for stable operation, and must be securely fastened to the machine chassis with screws.

## 4.6 Printer Board Installation and Wiring Diagram

The printer control system consists of three components: the main board, the printhead board, and the control software. It connects to the computer via an Ethernet port.



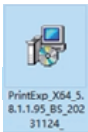
## Chapter 5. Software

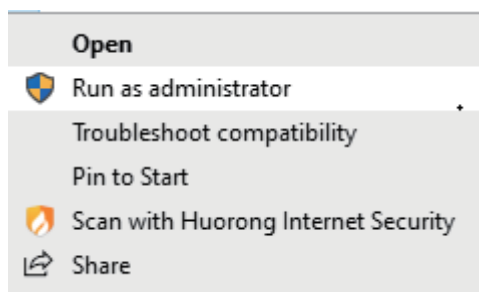
Print Exp\_X64 software is a kind of printer management software, which is mainly used to set various printer parameters, calibrate and adjust printer nozzles, maintenance, nozzle cleaning and printing operation, etc. All operation are performed using Print Exp \_ X64.

### 5.1 Software Installation

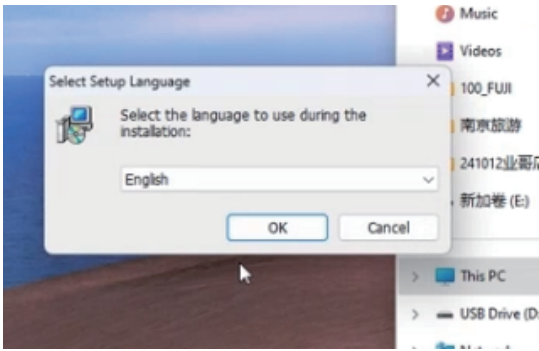
The printing management software shall be installed according to the following steps:

As the existing computer systems include Win7, Win10, Win11 etc., the installation steps are as follows:

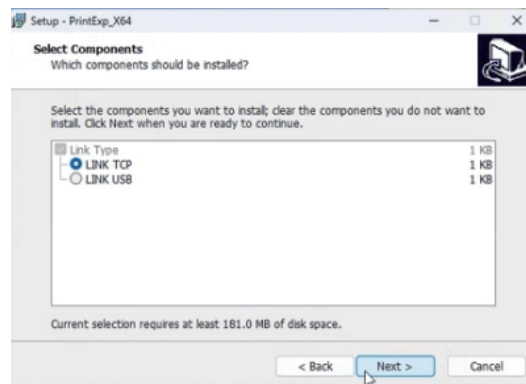
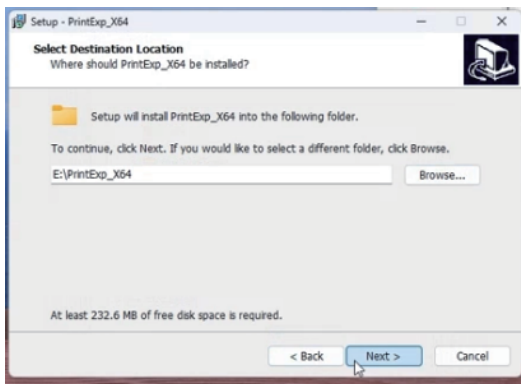
1. Elect the Print Exp\_X64 software icon:  , right-click and select "Run as administrator".



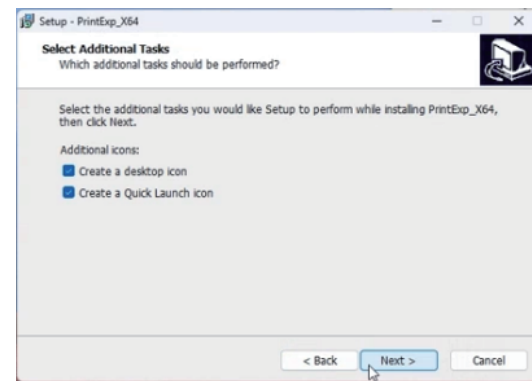
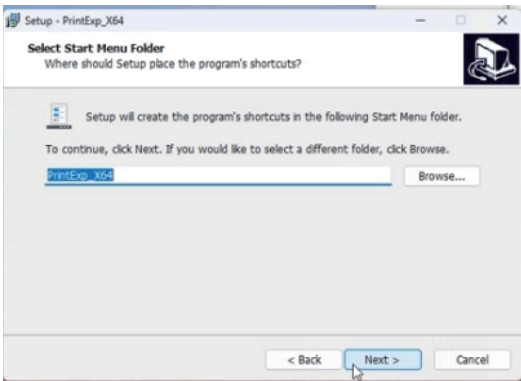
2. Select the desired language version (Chinese or English), and click OK.



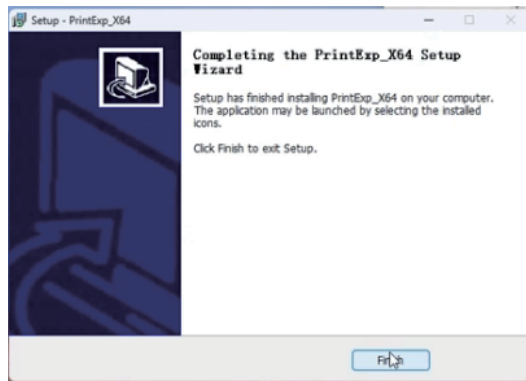
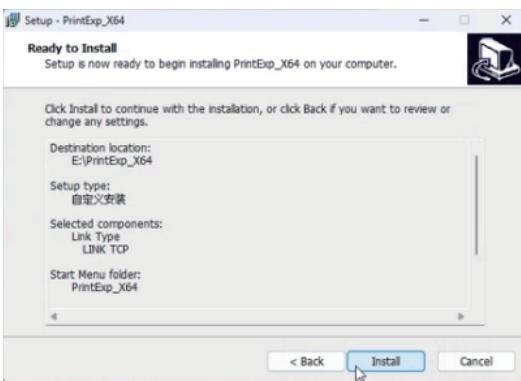
3. Select the installation disk location: Install components; LINK TCP is selected by default.



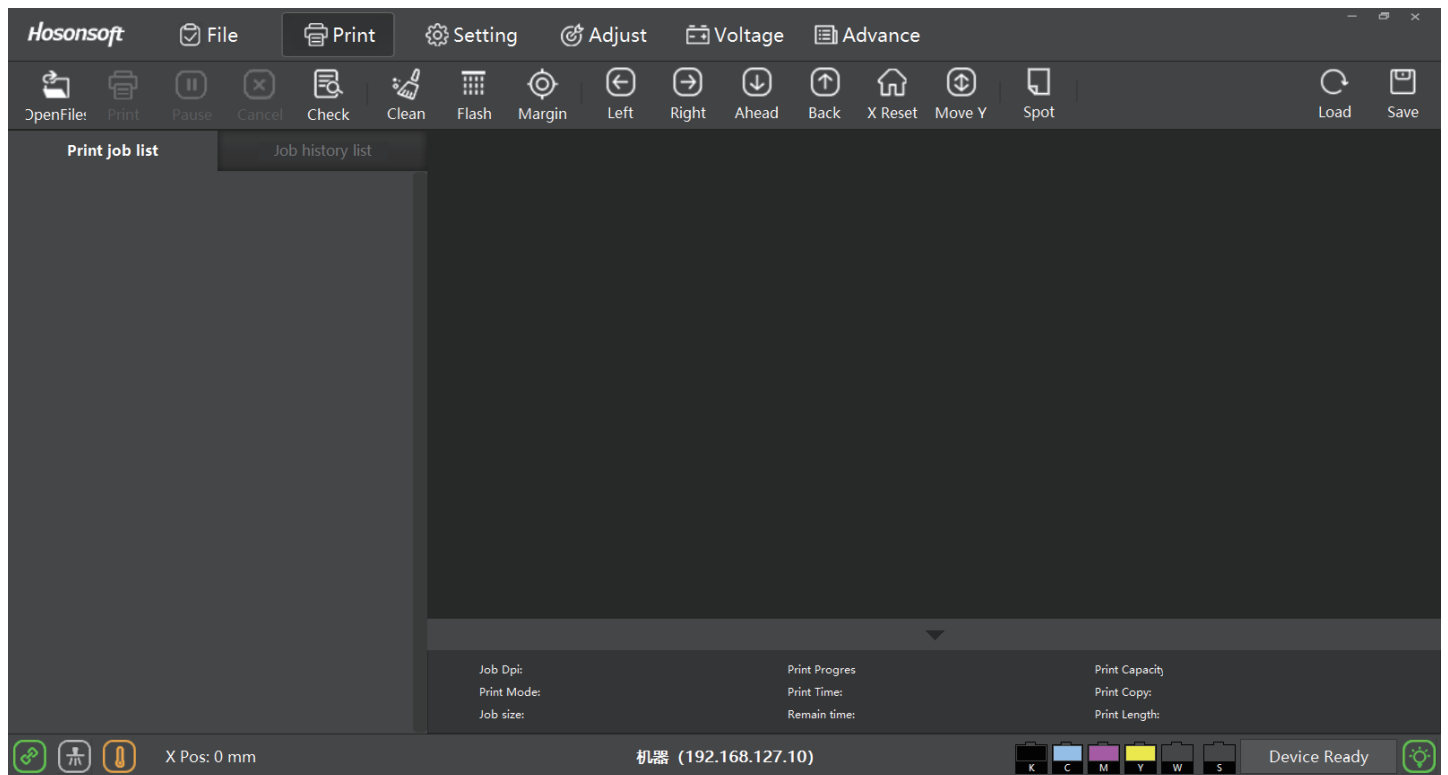
4. Select the Start Menu file location and choose to create a desktop shortcut.



5. Install the Print Exp\_X64 software, clicking "Next" or "Next" in pop-up windows until completion.

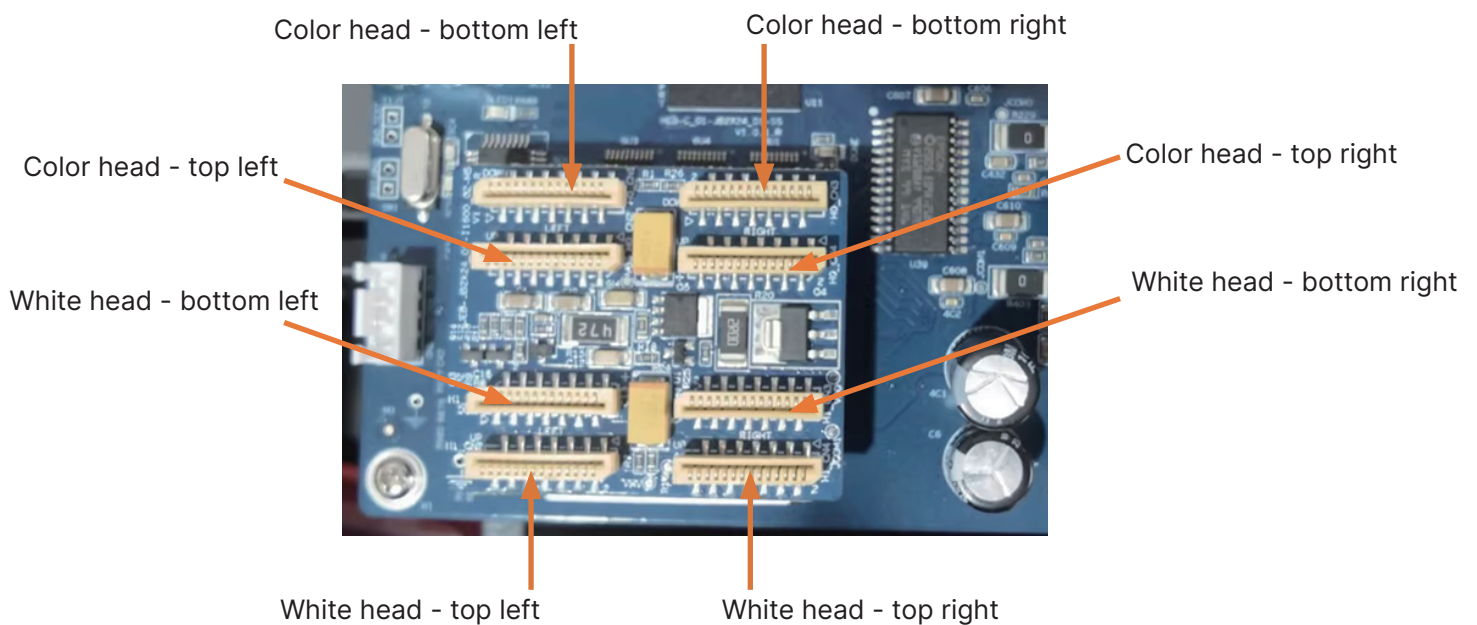


6. Open the unpacked folder, double click  Print Exp\_X64.exe to enter the main interface of the software, as shown in below figure:



## Chapter 6. Nozzle Installation

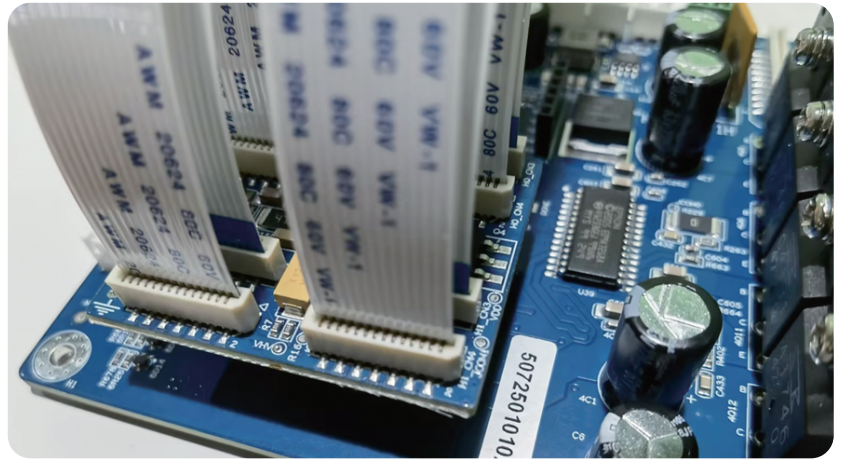
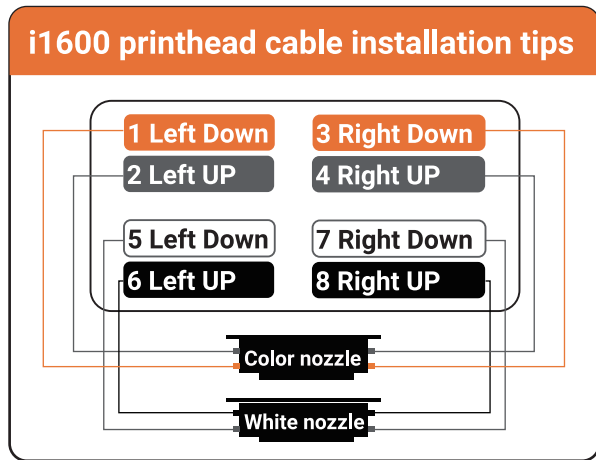
### 6.1 Carriage Board Printhead Arrangement



## 6.2 Printhead Data Cable Connection Methods

Note: Regardless of how the printhead board is installed, this connection is unique.

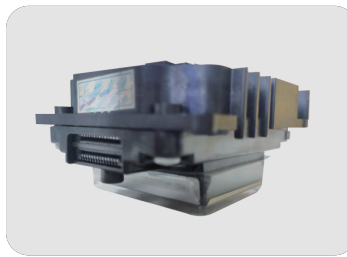
Reversing it may burn out the printhead or the board.



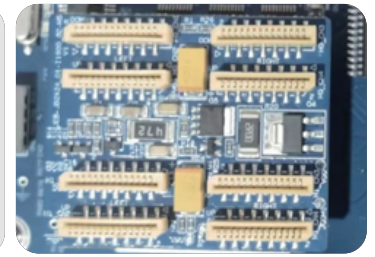
EPSON i1600 Print head



Arrangement of print head in the ink supply tube (K C M Y W W W)



Nozzle Data Cable Connector



Spray Gun Panel Data Cable Connector



Gigabit Ethernet Cable



Ink Cartridge Arrangement (K C M Y W)



Ink sac (4 required per print head)



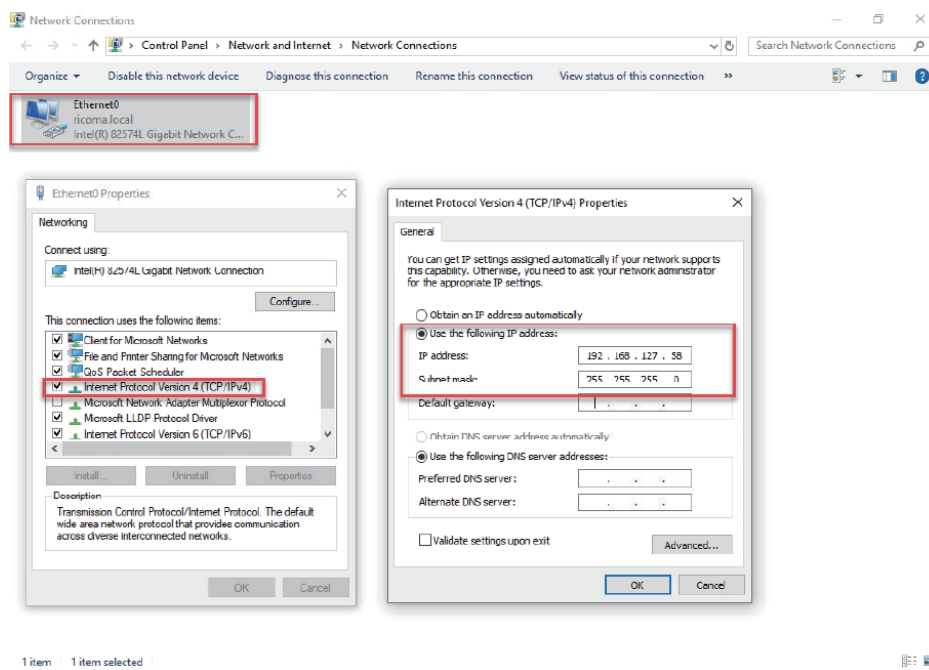
Data cable: 14-core flat cables connecting the print head to the headboard, with 4 cables required per print head.

# Chapter 7. Computer Connection Settings for Printing Software

## 7.1 Set Computer IP Network

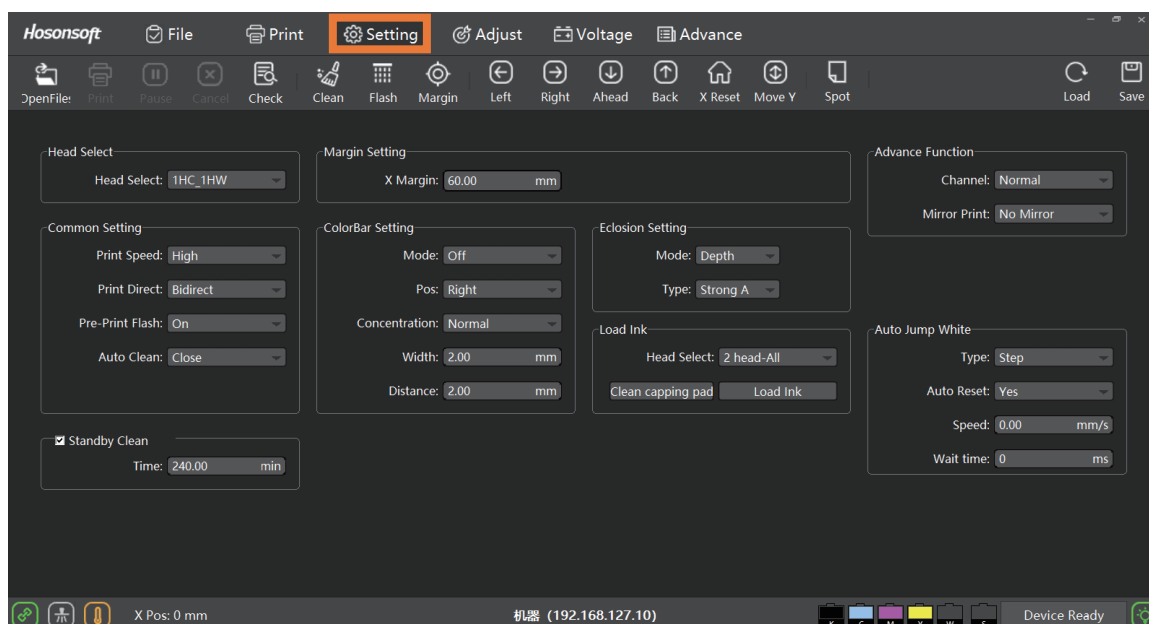
Right-click on the Network icon and select Properties → Select Local Connection, right-click Properties to open this interface .

Set up the computer to connect to the network and use the customized IP address: 192.168.127.58, subnet mask (default): 255.255.255.0.



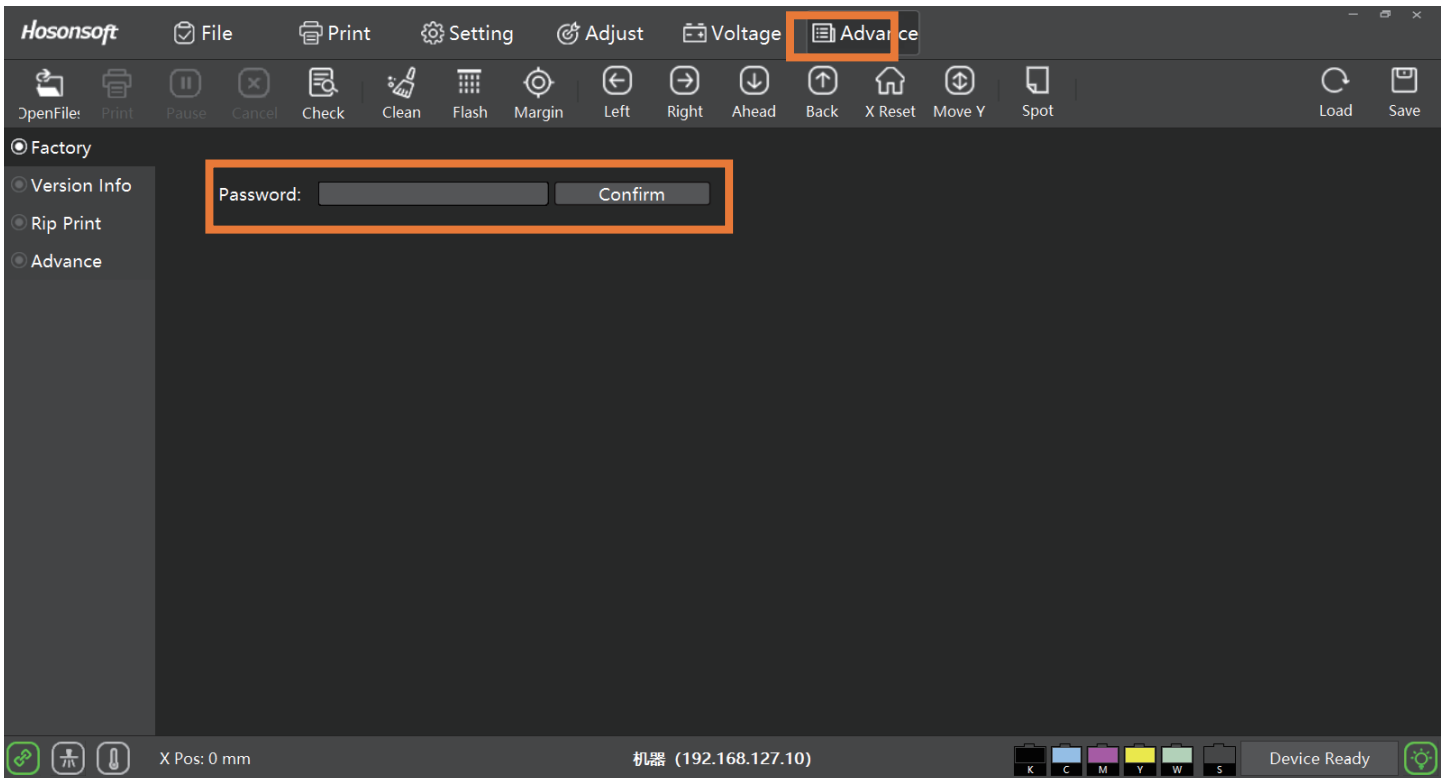
## 7.2 General Software Settings

Click Settings to access general printing settings.

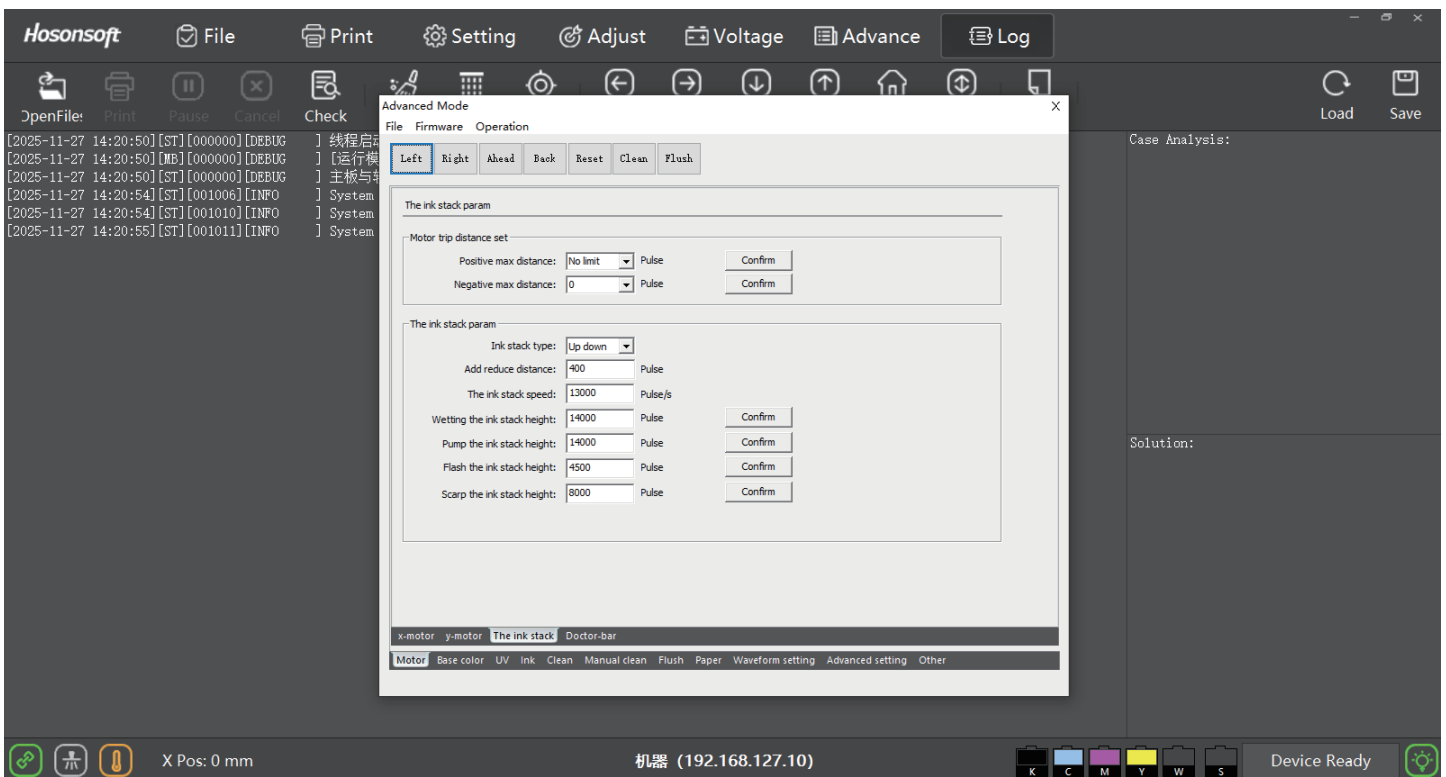


| No. | Name                 |                          | Function explanation   |
|-----|----------------------|--------------------------|--|
| 1   | Nozzle selection     |                          | The nozzle selection setting is only available under specific model conditions   |
| 2   | White border setting | White border on X        | Set the starting position for printing   |
|     |                      | White border on Y        | Set the starting position for printing   |
| 3   | General setting      | Printing speed           | Set the print speed to low speed, medium speed and high speed  |
|     |                      | Printing direction       | Set the print direction to print to the left, print to the right, and print in both directions   |
|     |                      | Pre-printing-flash spray | Set whether to flash before printing   |
|     |                      | self-cleaning            | Set it to be on or off before printing   |
|     |                      | Paper Feed Direction     | Paper Feed Direction Option  |
| 4   | Color Bar Settings   | Color Bar Position       | You can set the color bar position to output on the left side, output on the right side, output on both sides, or turn off the color bar, respectively |
|     |                      | Color Bar Mode           | Choose the mode of the color bar during printing   |
|     |                      | Color Bar Density        | Select the density of the color bar when printing, with options including Low, Medium, and High  |
|     |                      | Color Bar Width          | Specify the width of the color bar for printing  |
|     |                      | Color Bar Spacing        | Set the distance between adjacent color bars during printing   |
| 5   | Feathering setting   | Feathering mode          | Feathering mode selection  |
|     |                      | Feathering type          | Selection of feathering type   |
| 6   | Advanced Function    | Channel control          | Control the nozzle data  |
|     |                      | Mirror print             | Control whether the picture is printed horizontally flipped  |
| 7   | Light                |                          | Ink Drying & Curing  |
| 8   | Automatic white jump | Jumping white method     | Select the whitespace mode, including off whitespace, step whitespace, and continuous whitespace   |
|     |                      | Automatic reset          | Choose whether to reset automatically  |

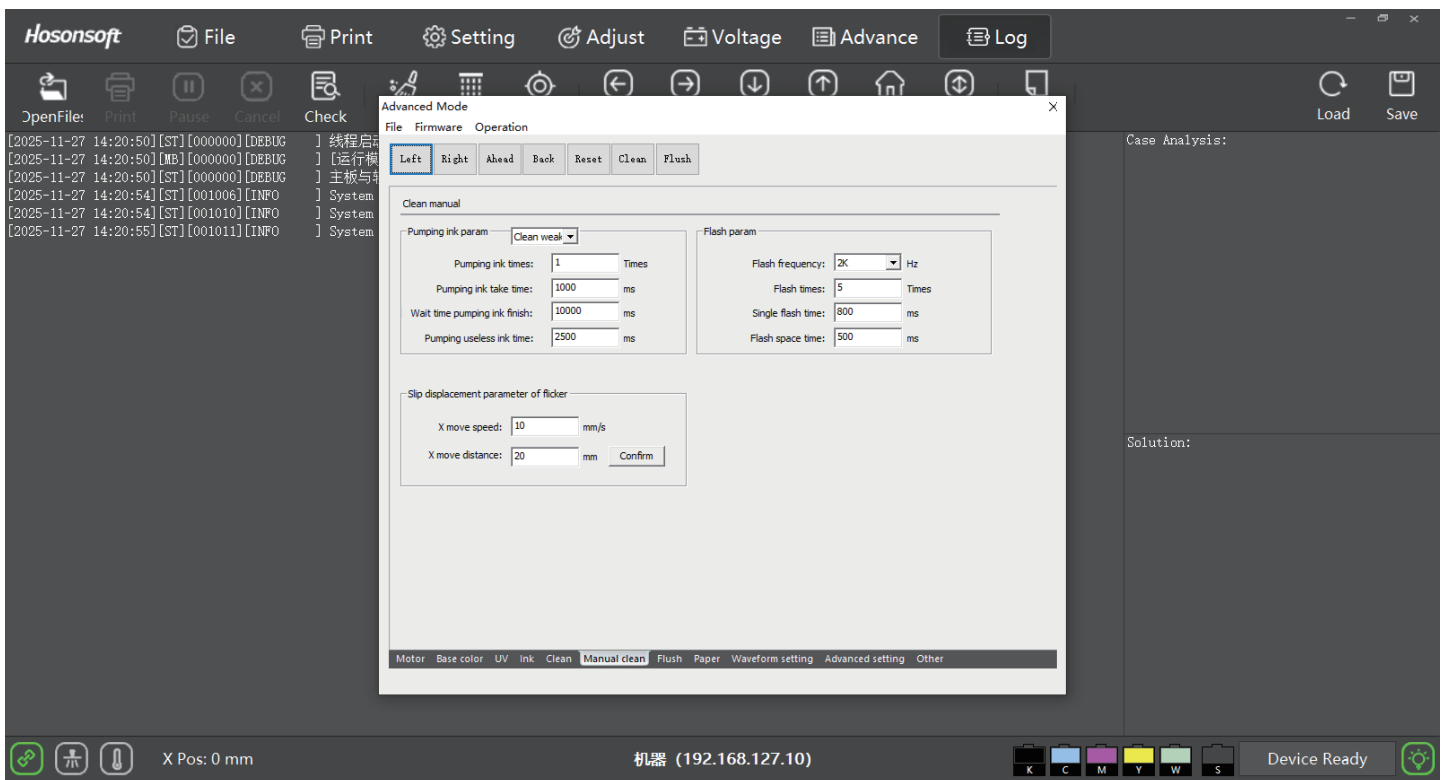
Go to Advanced Settings → Manufacturer Settings → Password 111111, enter the internal function Settings.



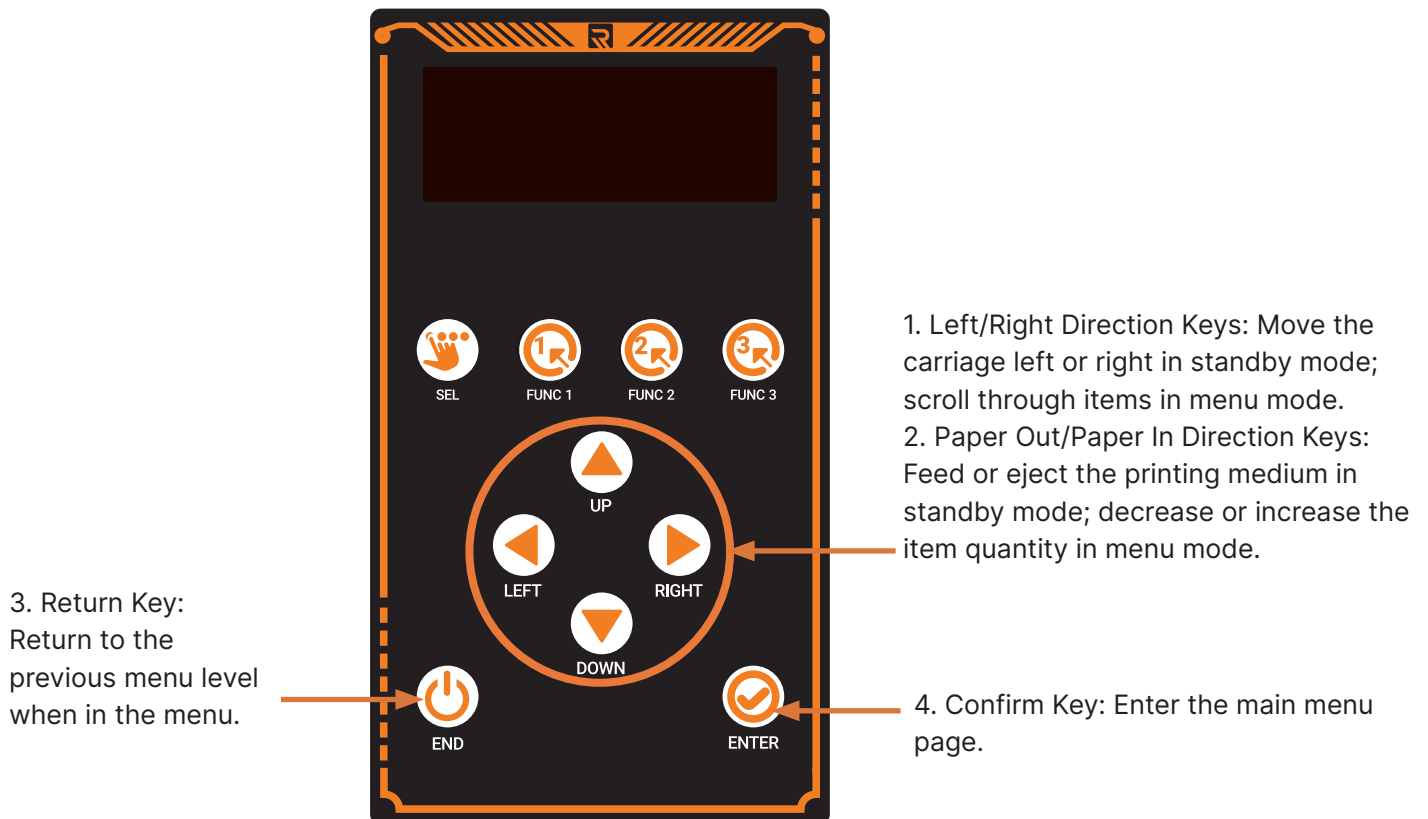
Click on the ink stack to mainly set the position parameters of the ink stack. You can set the head height, cleaning height, ink scraping height, etc.



Manual cleaning. Parameters can be adjusted here for the cleaning process. Other functions can be left at their default settings.



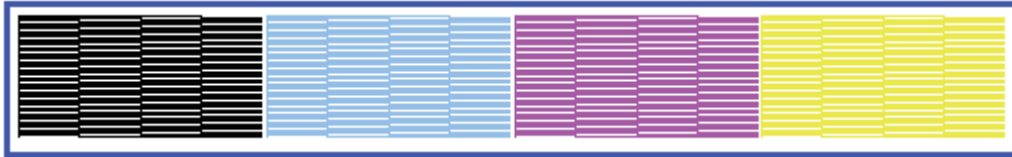
### 7.3 Control Panel Description



# Chapter 8. Procedures for Printing Calibration Adjustment

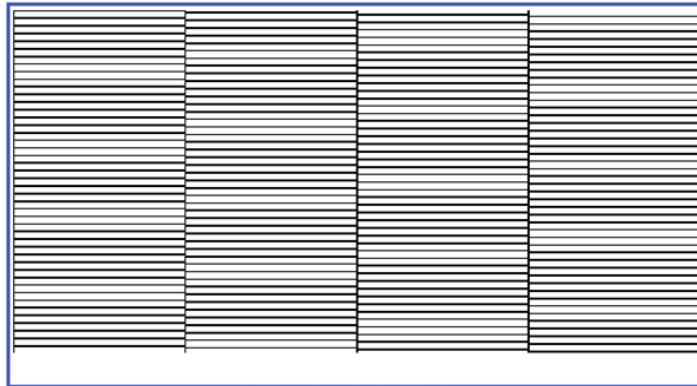
## 8.1 Introduction for Nozzle Detection Function

Click "Nozzle Detection" to print the nozzle test strip. The sample is as follows:



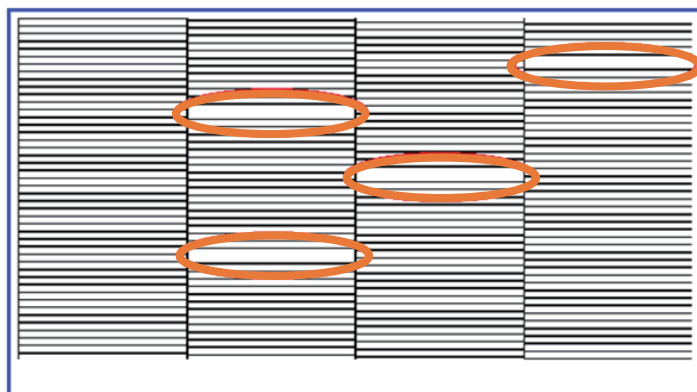
Nozzle calibration figure

Magnify the normal and abnormal conditions of the black state diagram as shown in the following figure:



Normal nozzle status figure

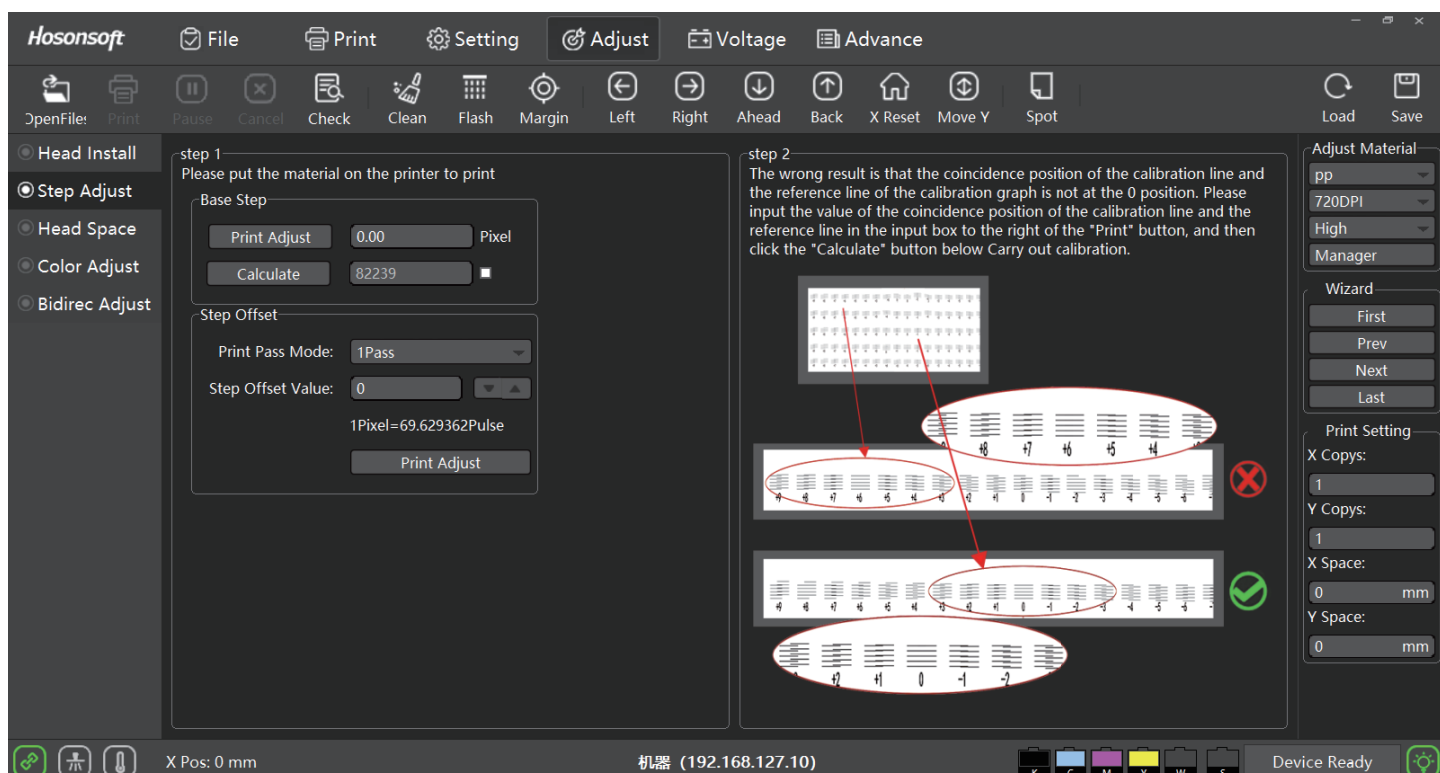
The state diagram in the following situation may be clogged and needs to be cleaned until the inkjet from the spray holes reaches the best state.



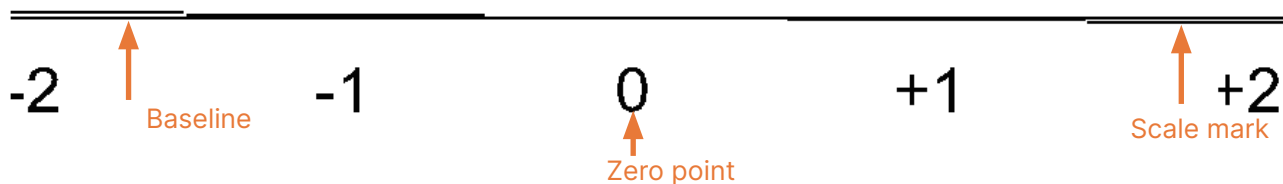
Abnormal nozzle status figure

## 8.2 Stepping Calibration Function

Click "Step Calibration" to print

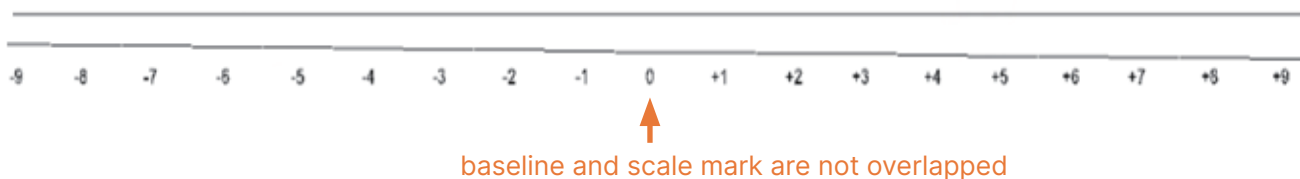


If the step adjustment is normal, the baseline and the scale mark will completely overlap at zero. As shown in the step adjustment status Figure 1.



Step adjustment status figure 1

If the step adjustment is abnormal, the baseline and the scale marks will not overlap. As shown in the step adjustment status Figure 2

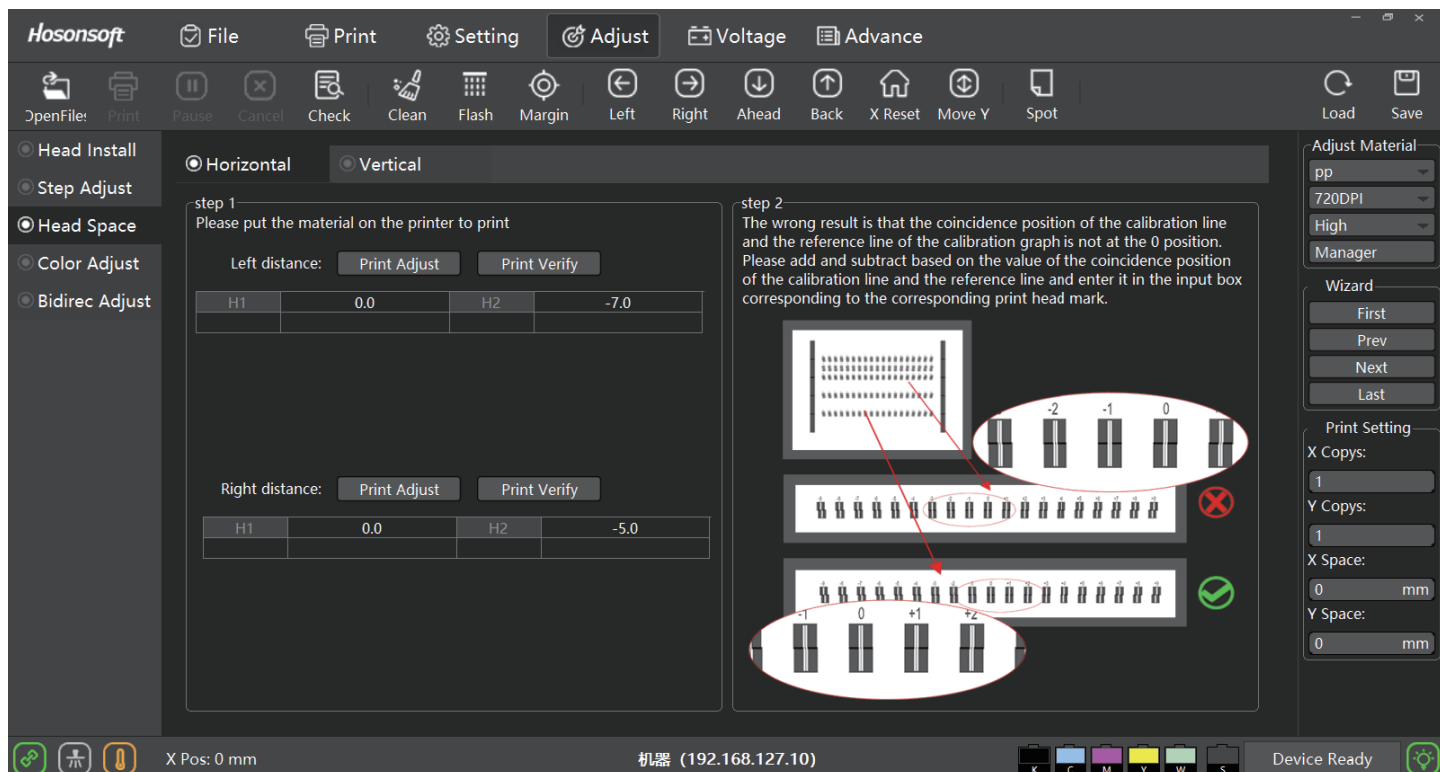


Step adjustment status figure 2

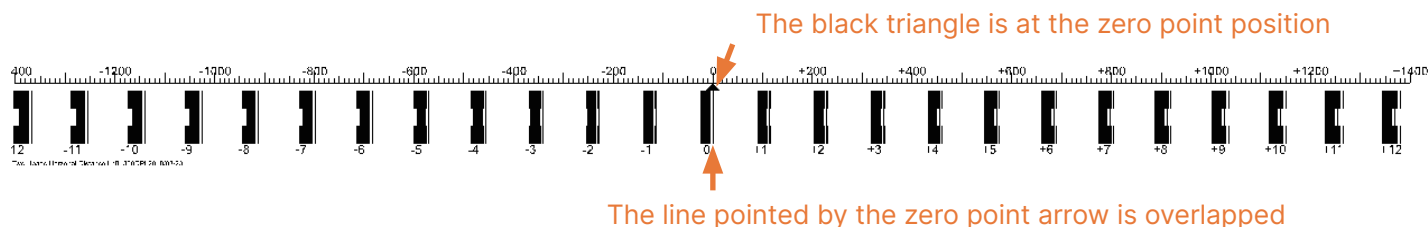
In this case, adjustments are needed. First, enter the adjustment value, click to calculate and reprint the print pattern until the baseline and the scale mark completely overlap at zero.

## 8.3 Calibration of the Horizontal Spacing of Nozzles

Click "Nozzle Spacing" to print.



If the print head spacing is properly aligned, the printed pattern will be as follows.



Nozzle horizontal spacing alignment state figure 1

If the print head spacing is abnormally aligned, the print pattern will be as follows.

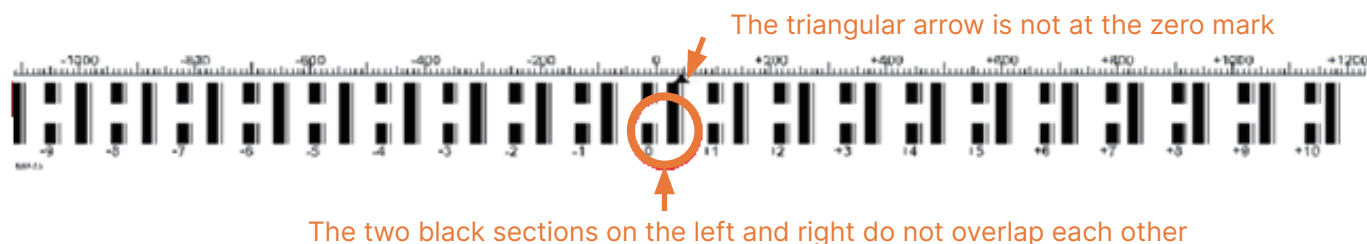
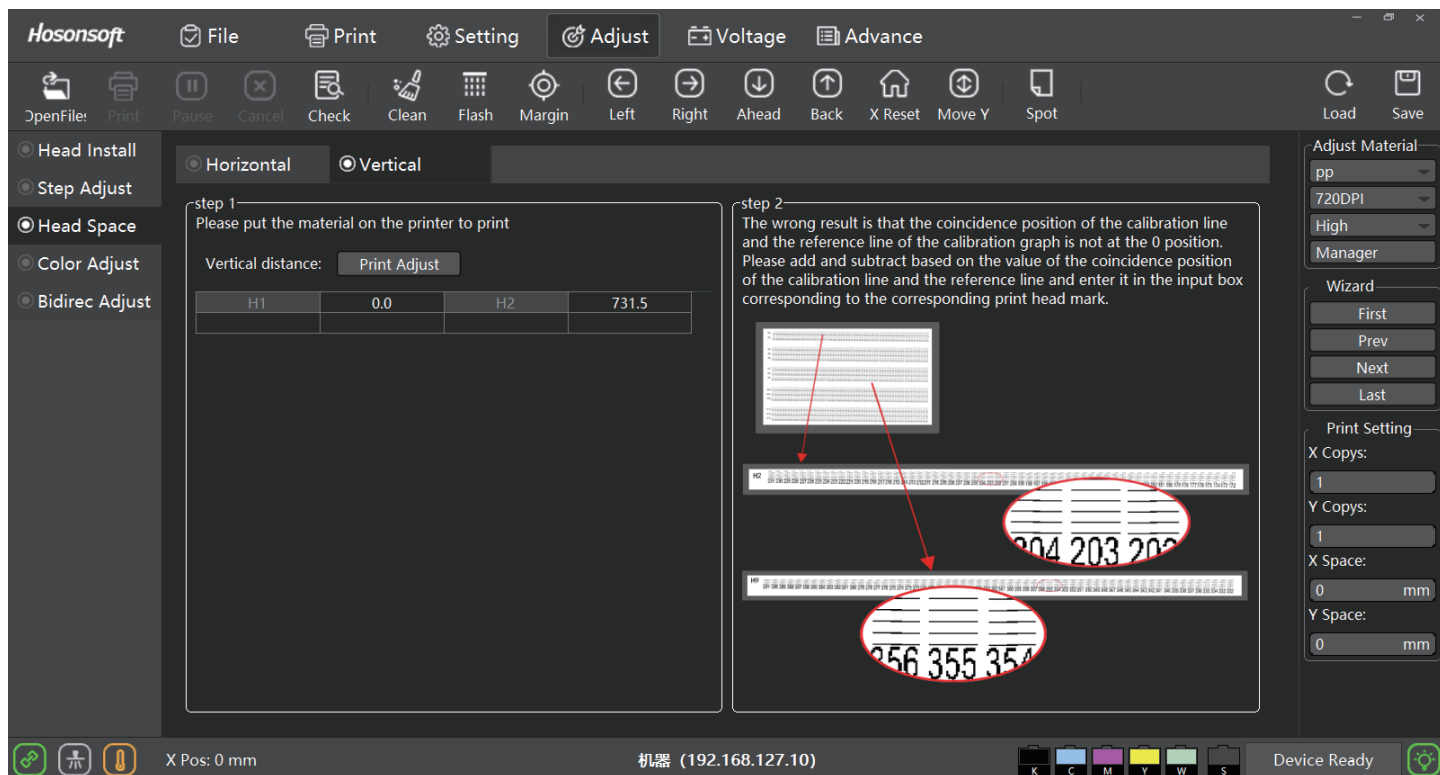


Figure 2 shows the alignment state of the horizontal spacing of the nozzles

In this case, it needs to be aligned. First, enter the adjustment value at position H2, click to calculate and reprint the print pattern until the zero point in the scale line is zero to zero.

## 8.4 Calibration of Longitudinal Spacing of Nozzles

Click "Nozzle Calibration" to print.



If the longitudinal spacing alignment of the nozzles is normal, all the lines in the zero point scale frame are parallel, and the left arrow points to the zero position. Figure 1 shows the alignment status of the print head longitudinal spacing.

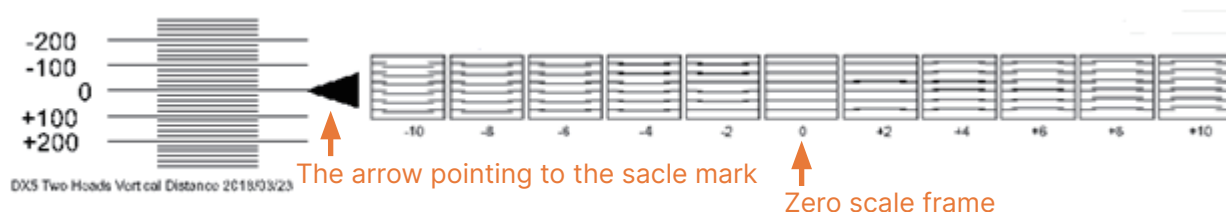


Figure 1 shows the alignment state of the longitudinal spacing of the nozzles

If the longitudinal spacing of the nozzles is adjusted abnormally, all lines in the zero point scale frame will be parallel to the -4 position. It is displayed as the longitudinal spacing alignment of the nozzles.

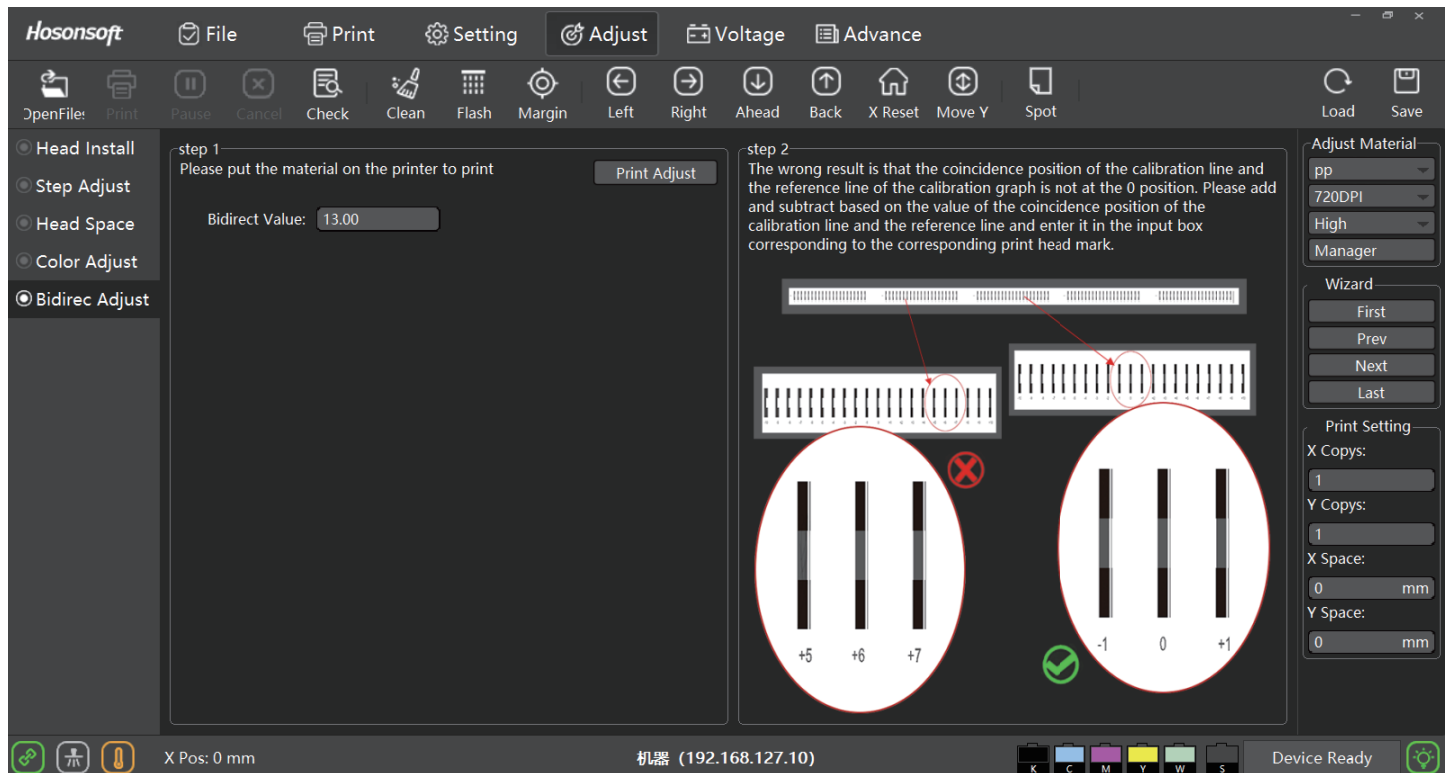


Figure 2 shows the alignment state of the longitudinal spacing of the nozzles

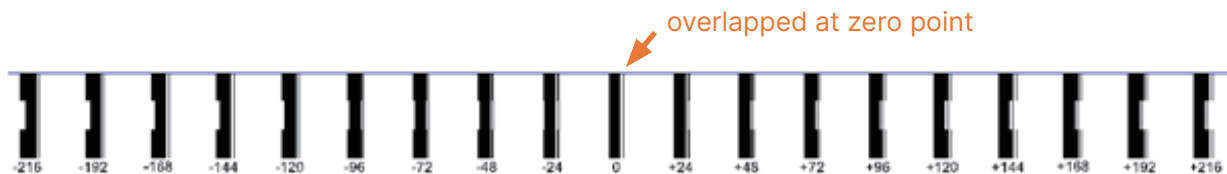
In this case, adjustments need to be made based on the original adjustment reference until all lines in the zero point scale frame are parallel at zero and the left arrow points to the zero position.

# 8.5 Bidirectional Calibration

Print "Print Calibration Diagram" in single-machine bidirectional calibration.

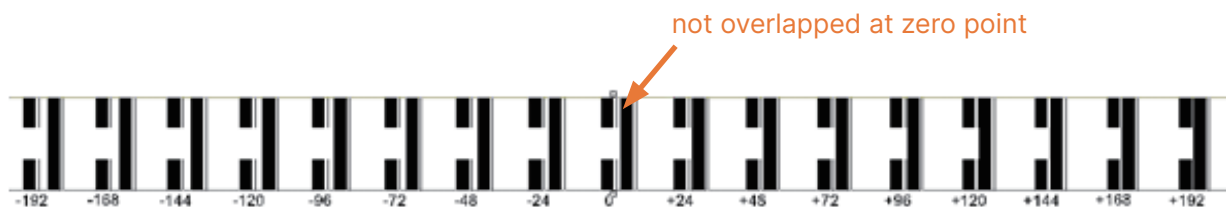


If the bidirectional calibration is normal, the lines will overlap at the zero position as shown below.



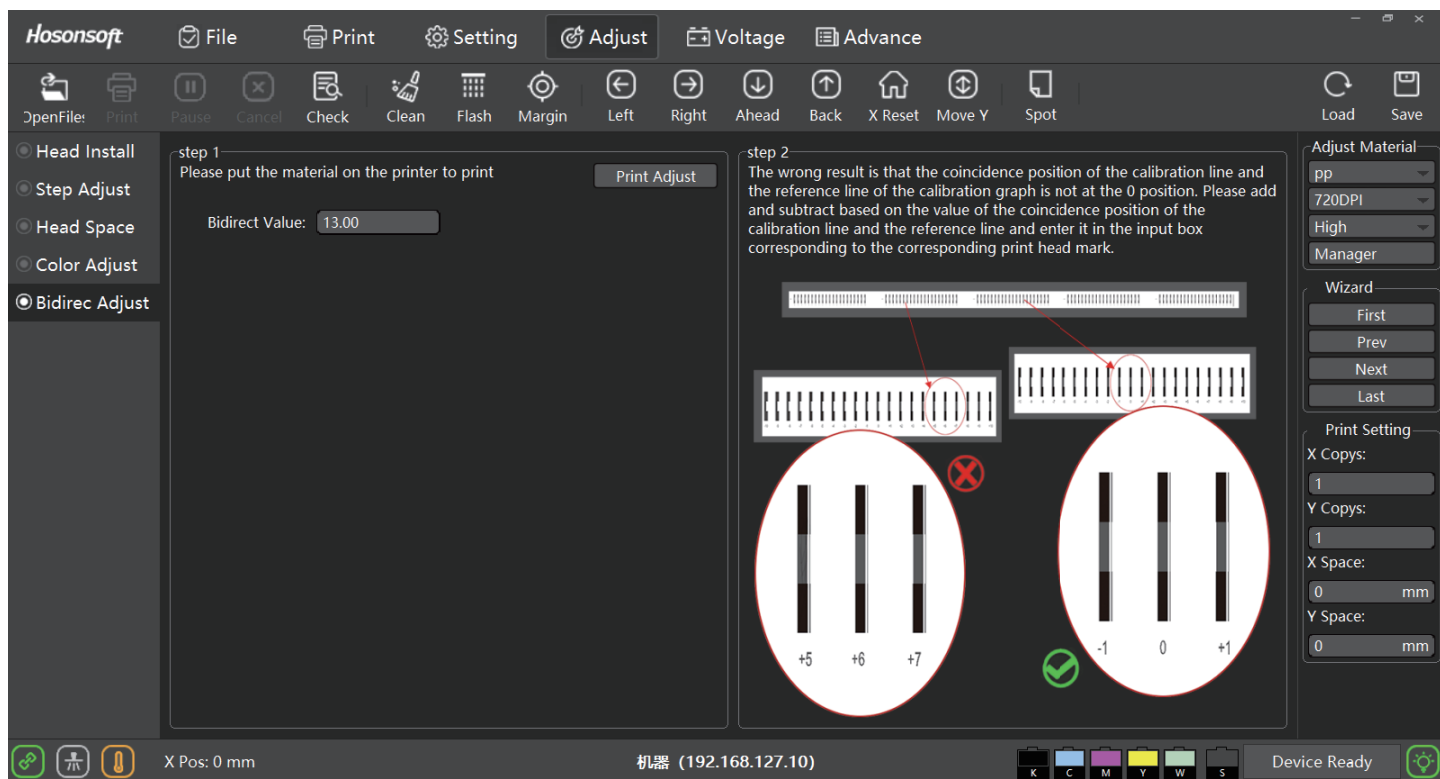
Bidirectional calibration status figure 1

If the bidirectional calibration is abnormal, the circuit will not overlap at the zero position, as shown below.



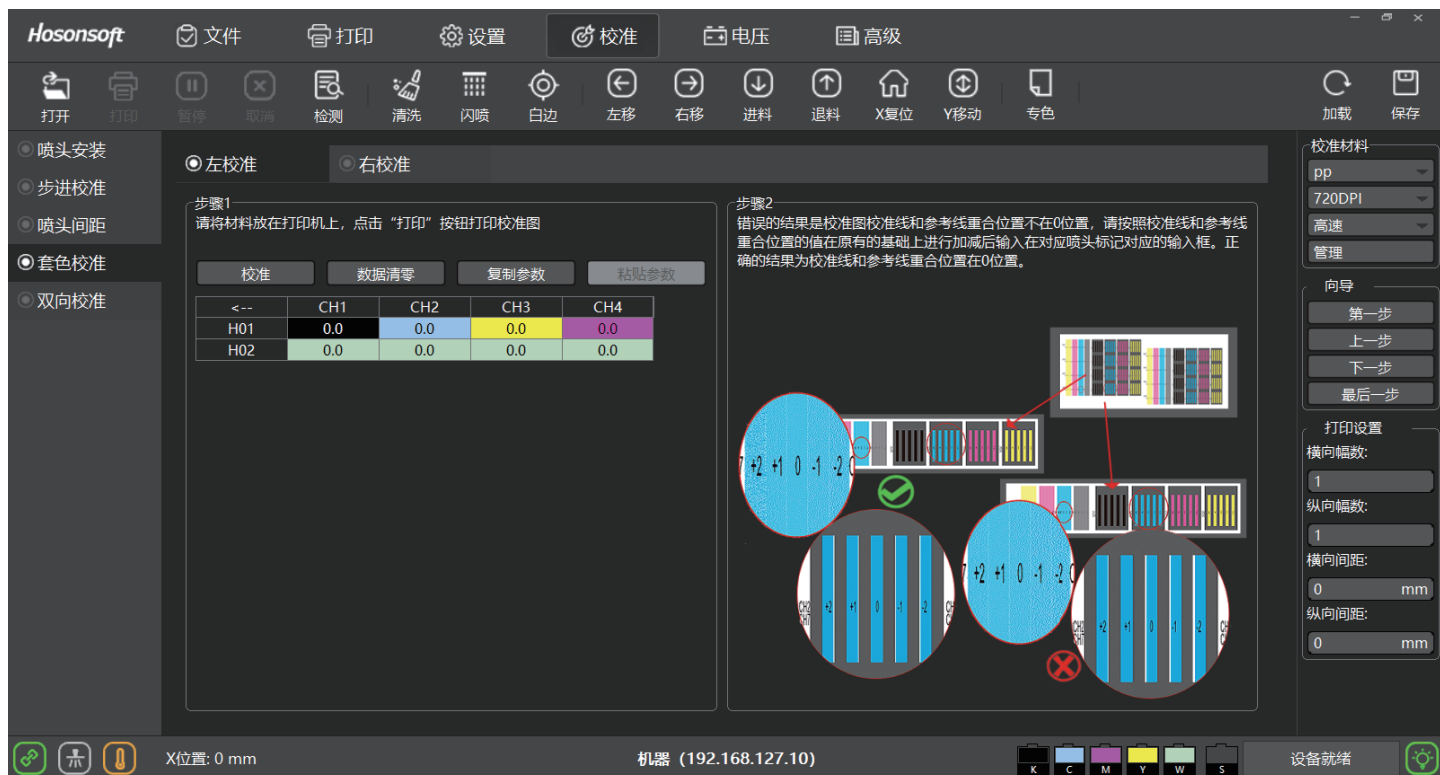
Bidirectional calibration status figure 2

In this case, it is necessary to input the adjustment values for readjustment.



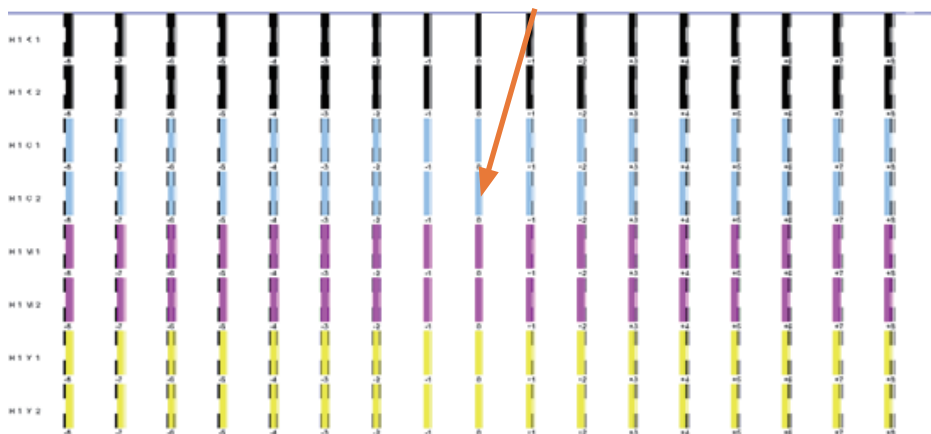
## 8.6 Color Calibration

Click on "Print Left/Right Calibration Diagram" under the color registration calibration interface to print the calibration diagram.



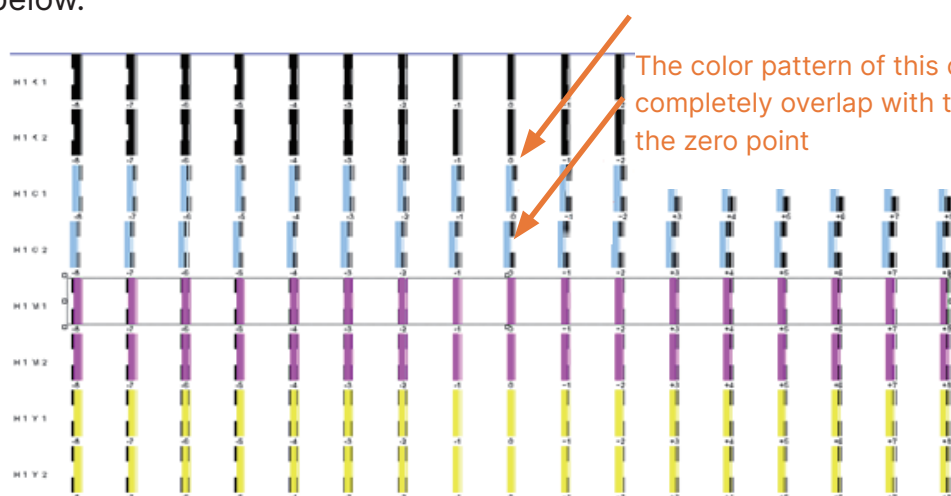
If the color adjustment is normal, the lines will overlap at this zero position, as shown below.

At zero point, the color pattern of this channel exactly coincides with the black pattern



Color registration calibration figure 1

If the color adjustment is abnormal, the lines will not overlap at the zero position as shown below.



The color pattern of this channel does not completely overlap with the black pattern at the zero point


Color registration calibration figure 2

In this case, the adjustment value needs to be entered for readjustment, as shown in the figure below:



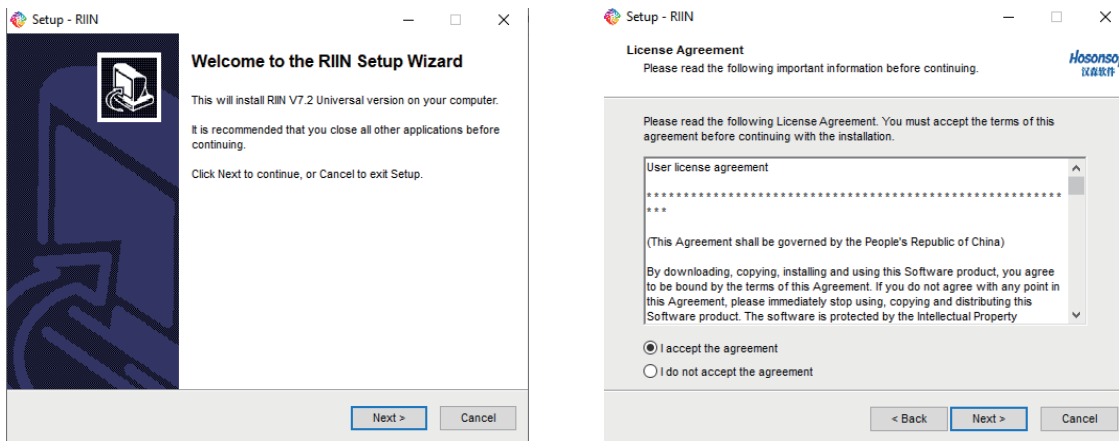
# Chapter 9. Installation and Usage of RIIN Software

## 9.1 RIIN Installation

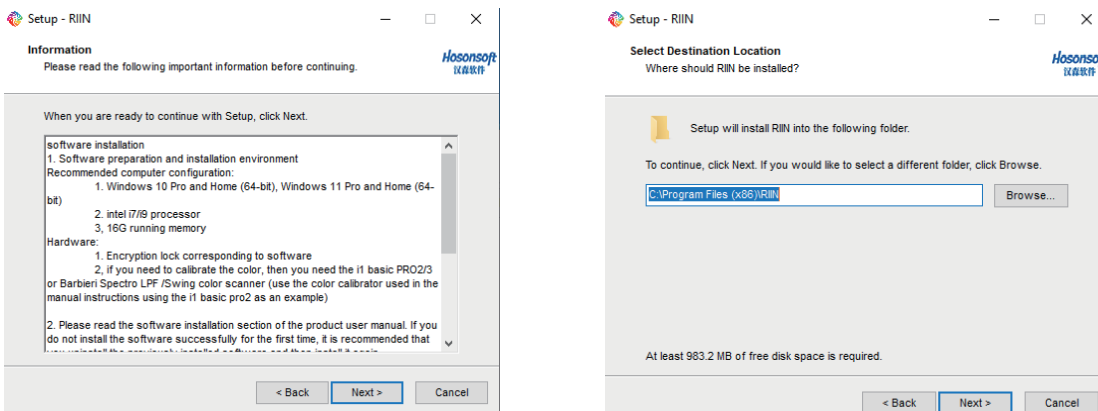
1. Take out the USB drive of the RIIN software and insert it into the computer to prepare for installing the software.
2. Right-click on the  /RIIN software installation package and select "Run as Administrator", Select the language you want to install (Chinese or English).



3. Use the RIIN installation wizard and accept the license agreement.

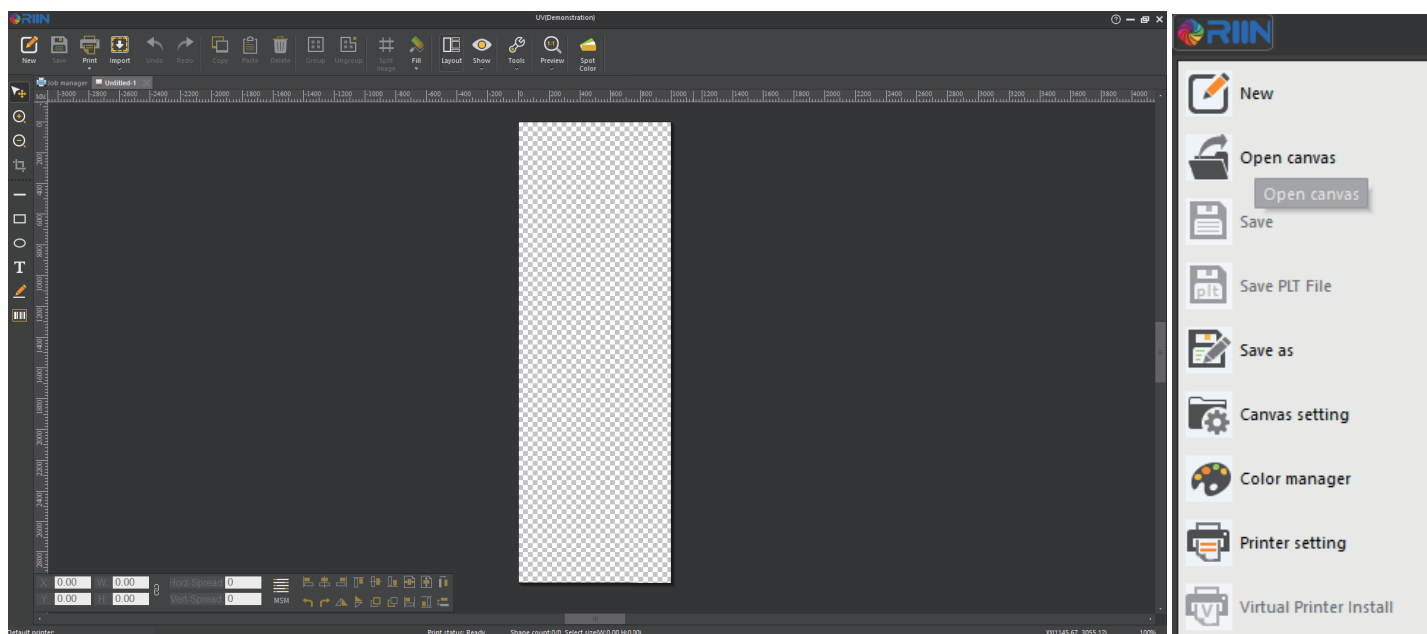


4. Read the software information and select the installation location of the software RIIN.





## 9.2 Introduction and Usage Instructions of RIIN Interface



### 1. Instructions for Using Main Interface commands:

|                   |   |            |  |
|-------------------|---|------------|--|
| New               | Create a new canvas   | Import in  | Import the picture to be printed             |
| combination       | Integrate multiple pictures into one  | dissolve   | Separate the combined pictures again         |
| split image       | Divide the picture into multiple pictures   | Fill in    | Fill in colors for the drawn closed graphics |
| composing         | After clicking, convenient layout instructions and Settings for multiple images will appear in the lower right corner. Among them, the material-saving command can be used for automatic layout |            |  |
| Display           | You can select various displays on the interface  | Tool       | Settings and processing of auxiliary images  |
| Full-page preview | Window mode and size selection  | Spot color | Setting the model of colors                  |
| Print             | Print the processed pictures  |            |  |

### 2. Drop-down Command Usage Instructions

|                    |   |                  |                                  |
|--------------------|---|------------------|----------------------------------|
| New                | Create a new canvas   | Open the canvas  | Open the previously saved canvas |
| Canvas Setting     | Set the canvas size, origin and edge white space                          | Color management | Select Curve                     |
| Printer Management | Import the printer and set the Default to "Default" in the drop-down menu |                  |                                  |

# Chapter 10. Maintenance Guidelines

1. Before starting printing each day, perform a nozzle check to verify whether the printhead is clogged. If the test pattern shows missing nozzles (skipped lines), clean the printhead immediately.
2. Operating environment: Temperature: 15°C – 30°C; Relative humidity: 35% – 70%
3. Before shutting down the printer each day, run a nozzle check. If any missing lines are detected, clean the printhead thoroughly before turning off the machine.
4. When powering off, ensure the printhead is properly aligned and fully seated onto the capping station (ink stack). There must be no gap between the printhead and the capping station.
5. During printing, enable color bars to prevent nozzle clogging caused by prolonged inactivity of a specific color channel.
6. During printing, ensure the print film does not rub against or contact the printhead to avoid damage or misalignment.
7. Keep the encoder strip clean—dust can interfere with print accuracy. Wipe it gently with a lint-free cloth every 1–2 weeks.
8. Lubricate the guide rails every 2–3 weeks using appropriate sewing machine oil.
9. Clean the wiper blade regularly with a lint-free cloth to maintain optimal capping and wiping performance.
10. Clean the ink on the paper presser promptly to prevent nozzle scratches caused by ink accumulation
11. Periodically clean accumulated ink from the bottom of the carriage (carriage base plate).
12. Regularly clean the ink accumulation around the capping station to ensure it remains clean.
13. If the printer will remain unused for an extended period: Place distilled water or a dedicated printhead cleaning solution into the capping station to soak the printhead. Clamp or pinch off the ink tubes and pump lines to prevent evaporation or back.
14. When not in use, wrap the printing film with plastic wrap to prevent moisture damage.
15. When not in use, seal the hot-melt powder tightly in a bag to prevent moisture absorption.