

EPSON

ML-18000

User's Manual

M00166500 EN
Rev.A

Original instructions

Cautions and Trademarks

Cautions

- ❑ Any reproduction of the contents of this document, in whole or in part, without permission is prohibited.
- ❑ The contents of this document are subject to change without notice.
- ❑ If you have any questions, notice any errors, or find any omissions in this document, please contact us.
- ❑ Please note that, notwithstanding the provisions of the previous section, we cannot be held responsible for the effects of operating this product.
- ❑ Please note that we cannot be held responsible for any malfunctions or issues arising from handling this product in a manner inconsistent with the instructions in this document, improper use, or repairs or modifications performed by a third party other than our company or those authorized by us.

Trademarks

Adobe and Acrobat are either registered trademarks or trademarks of Adobe in the United States and/or other countries.

The SuperSpeed USB Trident Logo is a registered trademark of USB Implementers Forum, Inc.

Apple, Mac, macOS and Safari are trademarks of Apple Inc., registered in the U.S. and other countries.

Firefox is a trademark of the Mozilla Foundation in the U.S. and other countries.

Chrome and YouTube are trademarks of Google LLC.

Intel® is a registered trademark of Intel Corporation.

Microsoft, Microsoft Edge and Windows are trademarks of the Microsoft group of companies.

QR Code is a registered trademark of DENSO WAVE INCORPORATED in Japan and other countries.

All trademarks are the property of their respective owners and used for identification purpose only.

Product Overview

The ML-18000 is a textile printing machine that uses an inkjet system. The printing speed is 250 m²/h at a resolution of 600 x 600 dpi and two passes. The ink supply unit is equipped with two dedicated ink cartridges for each color, which supply ink to the machine. 10 L ink cartridges are available.

Images in This Manual

The images used in this manual may differ from your machine.



©2025 Seiko Epson Corporation

About This Manual

About This Manual

Symbols Regarding General Information

This manual uses the following symbols.

 Important:	This symbol indicates information the user must obey when using this machine. Mishandling the machine by ignoring this symbol can result in product failures or malfunctions.
Note:	This symbol indicates a supplementary explanation or additional information that the user should know.
	This symbol indicates pages to reference with related information.
Printer Settings	Text that is displayed on the printer's control panel or on your computer is displayed in bold.

Screens in This Manual

The screens used in this manual may vary from the screens actually displayed depending on your OS and product.

Manual Organization

The manuals for the product are organized as shown below.

You can view the PDF manuals using Adobe Acrobat Reader or Preview (Mac).

Safety Precautions (Manual)	This manual explains the safety precautions. Make sure you read this manual to perform operations safely.
Standards and Approvals (Sheet)	The sheet explains the safety standards, laws, and regulations for each country. Make sure you read this manual to perform operations safely.
User's Manual (this manual)	This manual explains how to use the printer.
Epson Video Manuals (Videos)	You can watch a video of each maintenance procedure on YouTube. You can access the videos from the URL on the maintenance page or the label at the bottom left of the control panel.

Contents

Cautions and Trademarks

Cautions.	2
Trademarks.	2
Product Overview.	2
Images in This Manual.	3

About This Manual

Symbols Regarding General Information.	4
Screens in This Manual.	4
Manual Organization.	4

Before Use

Meaning of Symbols.	8
Symbols Regarding Safety.	8
Printer Parts.	9
Front (Left Side).	9
Front (Right Side).	10
Front Inside (Left Side).	12
Front Inside (Right Side).	14
Belt Cleaning Unit.	15
Ink Supply Unit.	16
Control Panel.	17
Front Panel.	18
Rear (Left Side).	19
Rear (Right Side).	20
Inside Rear.	21
Feeding Unit.	22
Water Recycling Unit (Exterior).	23
Water Recycling Unit (Interior).	25
Rear Panel.	26
Emergency Stop Button.	28
Understanding and Operating the Display.	30
Precautions When Using the Control Panel.	30
Understanding the Display.	30
Types of Buttons.	39
Notes on Usage and Storage.	40
Installation Space.	40
Notes When Using the Printer.	40
Notes When Not Using the Printer.	41
Notes on Handling Ink Cartridges.	41
Introducing the Software.	42
Supplied Software	43
Resident Software.	43

How to Use Epson Edge Dashboard.	44
Using the Software.	44
Instructions for Starting.	44
Exiting Procedure.	44
How to Use Epson Edge Print.	44
Using the Software.	44
Instructions for Starting.	45
Exiting Procedure.	45
How to Use Epson Rob file print tool.	45
Using the Software.	45
Instructions for Starting.	45
Exiting Procedure.	46
How to Use Web Config.	46
Instructions for Starting.	46
How to Set/Change the Administrator User Name/Administrator Password.	47
How to Export and Import Network Settings.	47
Exiting Procedure.	48

Basic Operations

Workflow till the Completion of Printed Materials.	49
Workflow for Proper Printing.	49
Operations Before Starting Work.	50
Inspecting and Cleaning Before Turning On the Power.	50
Checking the Exhaust Equipment.	51
Turning On the Power.	51
Checking the Operating Status of the Water Recycling Unit.	53
Inspecting and Cleaning After Turning On the Power.	53
Printing Work.	54
Checking the Status of the Fabric.	55
Installing the Fabric Roll.	56
Loading the Fabric Into the Printer.	62
Setting Fabric Information.	88
Setting the Fabric Wrinkle Detection Sensor.	89
Setting the Print Start Position.	90
Printing.	91
Replacing the Fabric.	92
Adding Fabric.	98
Work After Printing.	102
Removing the Fabric Roll.	102
Checking the Operating Status of the Water Recycling Unit.	109
Inspection and Cleaning After Printing.	109

Contents

Turning Off the Power.	110
Print Adjustments.	111
Automatic Adjustment.	112
Print Head Alignment (Manual).	114
Fabric Feed Adjustment (Manual).	116
Print Head Alignment (Auto).	117
Fabric Feed Adjustment (Auto).	118
Setting the Print Area and Print Position.	118
Print Area.	119
Belt Flushing Position.	120
Setting the Print Position.	125
Sensor Settings.	131
Slack Detection Sensor and Roll Diameter Measurement Sensor.	131
Fabric Floating Sensor.	133
Tangled Fabric Detection Sensor.	133
Using the Optional High Tension Feeding Unit.	145
Basic Instructions.	145
Other Instructions.	159

Maintenance

When to Perform Various Maintenance Operations.	181
Inspection/Cleaning.	181
Replacing Consumables.	182
Other Maintenance.	183
Required Items.	183
Precautions Regarding Maintenance.	185
Precautions for Handling Ink, Maintenance Liquid, and Waste Ink.	187
Precautions Regarding Glue and Glue Remover Checks Before Maintenance.	188
Inspection/Cleaning Procedure.	189
Inspecting Around the Operating Parts.	189
Cleaning the Area Around Operating Parts.	193
Cleaning the Lint Trap.	194
Inspecting/Adjusting the Air Pressure.	197
Inspecting and Cutting the Tension Roller Tape Cleaning the Mist Filter.	199
Cleaning the Front Cover and Maintenance Cover.	203
Cleaning the Inside Light.	205
Inspecting the Emergency Stop Device.	208
Cleaning the Cleaning Pad Blades.	209
Inspecting/Draining the Air Supply Regulator.	211
Cleaning the Suction Caps.	213
Inspecting/Cleaning the Sensors.	216
Cleaning Inside the Water Recycling Unit Tank Inspecting/Cleaning the Cleaning Pad.	218
Inspecting/Cleaning the Cleaning Pad.	221

Inspecting/Cleaning the Flushing Pad.	225
Inspecting/Cleaning Around the Print Head.	229
Drying the Sponge Roller.	232
Inspecting/Cleaning the Ink Path.	235
Cleaning the Belt Cleaning Unit.	237
Replacing Consumables.	241
Replacing the Ink Cartridges.	241
Replacing the Waste Ink Bottle.	247
Replacing the Wiper Roll.	248
Replacing the Flushing Pad.	252
Replacing the Cleaning Pad.	256
Replacing the Washing Scraper.	261
Replacing the Sponge Roller.	266
Replacing the Mist Filter.	271
Other Maintenance.	273
Cleaning the Mist Collection Fan.	273
Cleaning the Encoder Scale.	277
Print Head Nozzle Check.	281
Print Head Cleaning.	286
Capping the Print Head.	290
Adding Grease to the Scan Spindle.	297
Timing for Reapplying the Glue.	309
Removing Glue (When Using the Glue Removal Tool).	314
Removing Glue (When Using the Glue Bucket) Applying Glue.	366
Applying Glue.	402
Disposal of Used Consumables.	432

Control Panel Menu

General Settings Menu.	434
Fabric Settings Menu.	443
Maintenance Menu.	446
Supply Status Menu.	448
Replacement Part Information Menu.	449
Printer Status Menu.	450
List of Printer Settings by Operation.	450
Media Type: Fabric.	451
Media Type: Paper.	452

Problem Solver

When a Message is Displayed.	453
When an Error Message is Displayed.	454
Understanding the Status Lights on the Water Recycling Unit.	456
Troubleshooting.	458
You Cannot Print (Because the Printer Does Not Work).	458
The Printer is Working but Does Not Print.	459

Contents

The Prints Are Not What You Expected.	460
Problems with the Fabric.	462
Problems with the Belt.	464
Problems with the Water Recycling Unit.	466
Problems when Printing Using One Pass.	470
Others.	470

Appendix

Options and Consumable Products.	472
Consumables.	472
Optional.	473
Supported Fabric.	474
Print Mode and Throughput.	474
How to Read the Signal Lamps.	475
System Requirements.	476
Epson Edge Dashboard.	476
Epson Edge Print.	477
Epson Rob file print tool.	477
Web Config.	478
Moving and Transporting the Printer.	478
Specifications.	478
Printer Specifications.	478
Factory Facilities.	481
Interface Specifications.	481
Ink Specifications.	482
Precautions and Applicable Standard for This Product.	483
Restriction of Use for This Product.	483
Precautions When Using the Control Panel.	483

Before Use

Before Use












This chapter shows the meaning of symbols used in this manual and on this machine, as well as the name and function of each part.

IMPORTANT: Before using this product, make sure you read these instructions and the safety instructions in the *Safety Precautions* guide.



Meaning of Symbols

This manual and product use the following symbols to ensure the product is used safely and to prevent risks and damage. The symbols have the meanings described below.

Symbols Regarding Safety

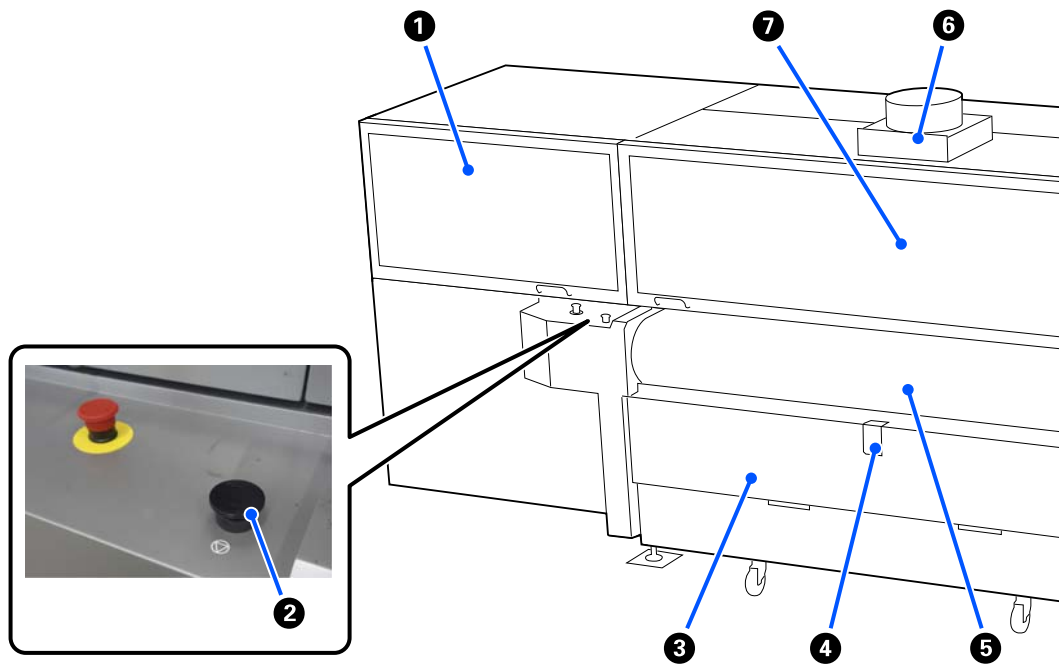
 Warning:	This symbol indicates content where mishandling the machine by ignoring this symbol can result in death or serious injuries.
 Caution:	This symbol indicates content where mishandling the machine by ignoring this symbol can result in injury or property damage.
	Indicates actions you must not do (prohibited actions).
	Indicates things you must do (instructions, actions).
	Indicates that disassembly is prohibited.
	Indicates that touching is prohibited.
	Indicates that flames are strictly prohibited.
	Indicates that eye protection must be worn.
	Indicates that protective gloves must be worn.
	Indicates that protective clothing must be worn.
	Indicates that respiratory protection must be worn.

Before Use

	Indicates that a hair net must be worn.
	Indicates that safety shoes must be worn.

Printer Parts

Front (Left Side)



1 Maintenance cover

Open this when inspecting or cleaning parts inside the printer. This must be closed when using the printer.

 [“Cleaning the Front Cover and Maintenance Cover” on page 203](#)

2 Pause button

Pauses operations for this machine. Touch the **Resume** button on the control panel to resume printing.

3 Belt cleaning unit

Open this when cleaning or replacing parts inside the belt cleaning unit.

 [“Belt Cleaning Unit” on page 15](#)

 [“Cleaning the Belt Cleaning Unit” on page 237](#)

4 Tangled fabric detection sensor

Before Use

Detects when fabric gets tangled under the belt. If the sensor detects that the fabric has become tangled, it comes to an immediate stop.

 [“Tangled Fabric Detection Sensor” on page 133](#)

5 Belt

This attaches and fixes the fabric for smooth fabric feeding.

 [“Removing Glue \(When Using the Glue Removal Tool\)” on page 314](#)

 [“Removing Glue \(When Using the Glue Bucket\)” on page 366](#)

 [“Applying Glue” on page 402](#)

6 Mist filter

Collects discharged ink mist.

 [“Cleaning the Mist Filter” on page 201](#)

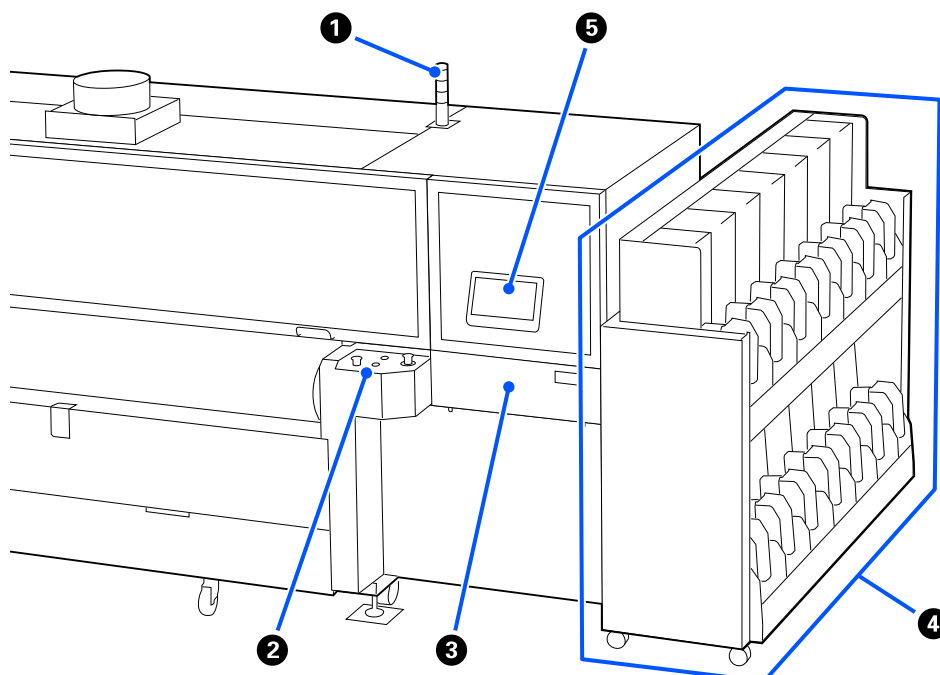
 [“Replacing the Mist Filter” on page 271](#)

7 Front cover

Open this when loading the fabric or when inspecting or cleaning parts inside the printer. This must be closed when using the printer.

 [“Cleaning the Front Cover and Maintenance Cover” on page 203](#)

Front (Right Side)



Before Use

① Signal lamp

Lamps light or flash in 3 colors to notify you of the status of the printer.

 [“How to Read the Signal Lamps” on page 475](#)

② Front panel

Use these controls to rotate the belt or temporarily pause printer operations.

 [“Front Panel” on page 18](#)

③ Maintenance cover

Open this when inspecting or cleaning parts inside the printer. This must be closed when using the printer.

④ Ink supply unit

Supplies ink to the printer.

 [“Ink Supply Unit” on page 16](#)

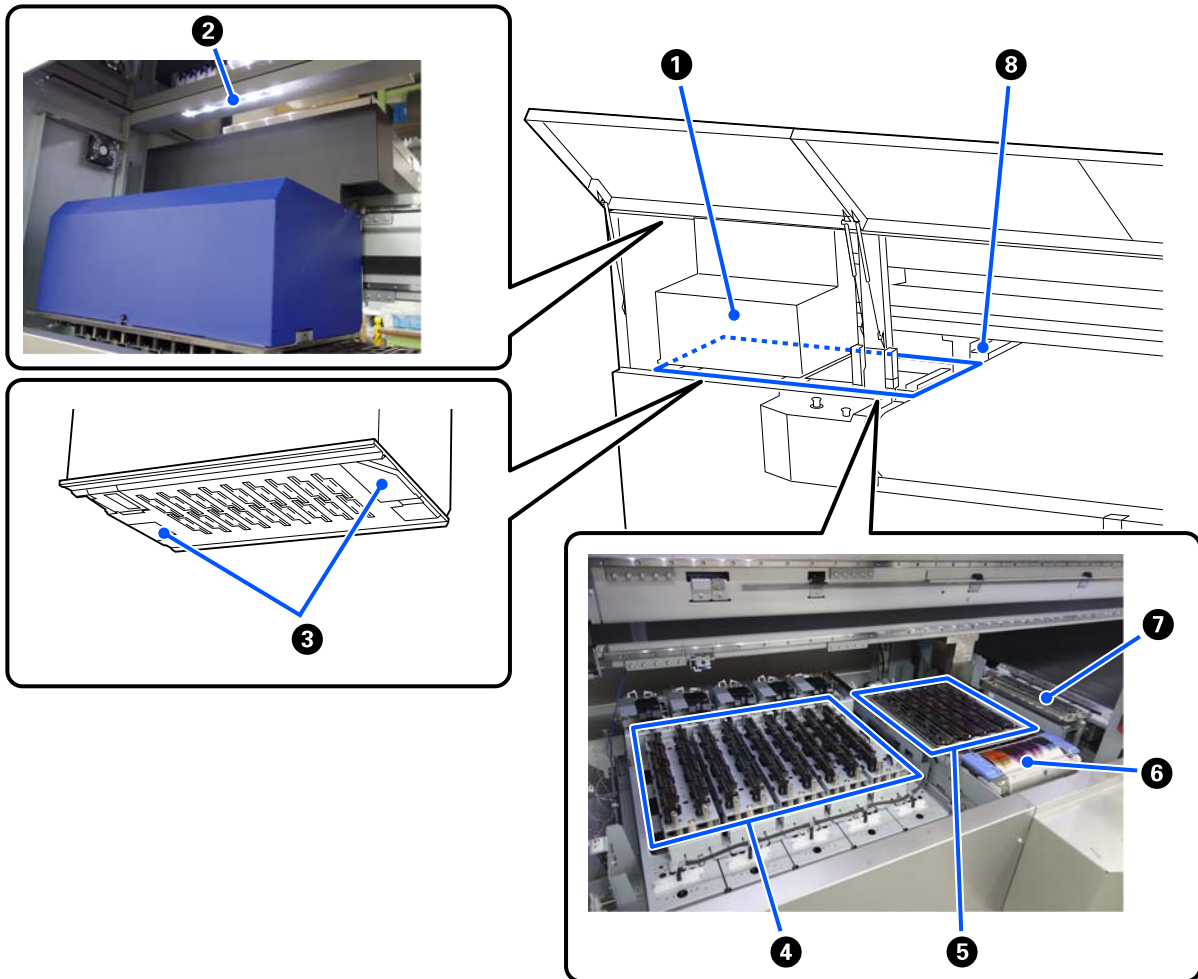
⑤ Control panel

You can check the status of the printer and perform operations.

 [“Control Panel” on page 17](#)

 [“Understanding and Operating the Display” on page 30](#)

Before Use

Front Inside (Left Side)
**1 Print head**

Prints by ejecting ink while moving left and right.

 [“Inspecting/Cleaning Around the Print Head” on page 229](#)

 [“Print Head Nozzle Check” on page 281](#)

 [“Print Head Cleaning” on page 286](#)

 [“Capping the Print Head” on page 290](#)

2 Inside light

Illuminates the inside of the printer to make it easy to check print results and areas for maintenance.

 [“Cleaning the Inside Light” on page 205](#)

3 Head strike sensor

Before Use

Detects if the fabric has curled or lifted up to prevent collisions with the print head. This is located on the bottom of the print head. If the sensor detects that the fabric has curled or lifted, the machine comes to an immediate stop.

4 Suction Cap

Ink is drawn out from the print head's nozzle with this cap.

 [“Cleaning the Suction Caps” on page 213](#)

5 Cleaning Pad

Ink is ejected here during cleaning.

 [“Inspecting/Cleaning the Cleaning Pad” on page 221](#)

 [“Replacing the Cleaning Pad” on page 256](#)

6 Wiper unit

The wiper removes ink from the surface of the print head nozzles.

 [“Replacing the Wiper Roll” on page 248](#)

7 Flushing Pad

Ink is ejected here during flushing.

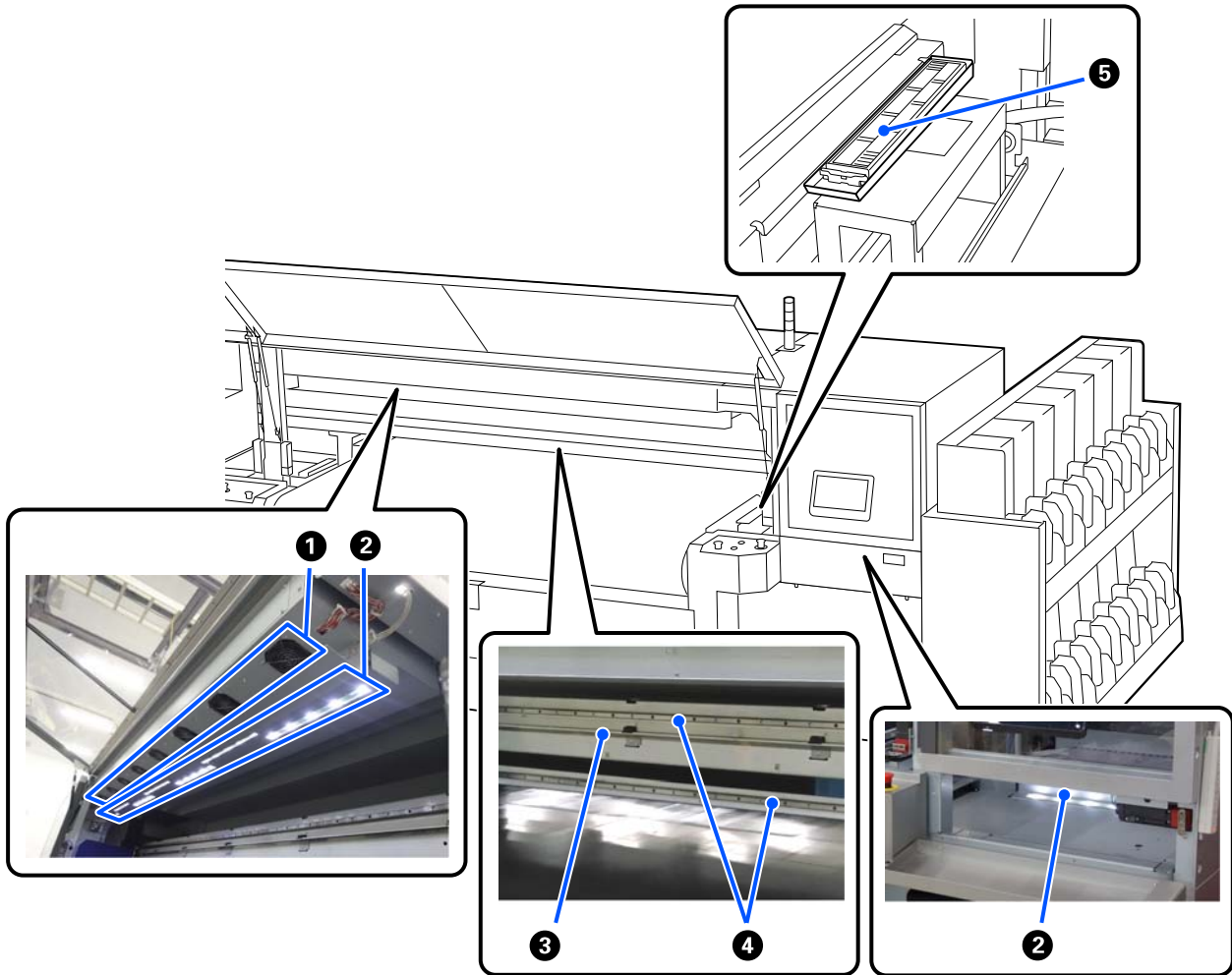
 [“Inspecting/Cleaning the Flushing Pad” on page 225](#)

 [“Replacing the Flushing Pad” on page 252](#)

8 Belt Feed Measurement Sensor

Measures the amount of belt feed.

Before Use

Front Inside (Right Side)
**❶ Mist collection fan**

Extracts ink mist generated inside the machine.

👉 [“Cleaning the Mist Collection Fan” on page 273](#)

❷ Inside light

Illuminates the inside of the printer to make it easy to check print results and areas for maintenance.

👉 [“Cleaning the Inside Light” on page 205](#)

❸ Encoder Scale

Reads the position of the print head.

👉 [“Cleaning the Encoder Scale” on page 277](#)

Before Use

4 Scan spindle

Guides the print head as it moves.

 [“Adding Grease to the Scan Spindle” on page 297](#)

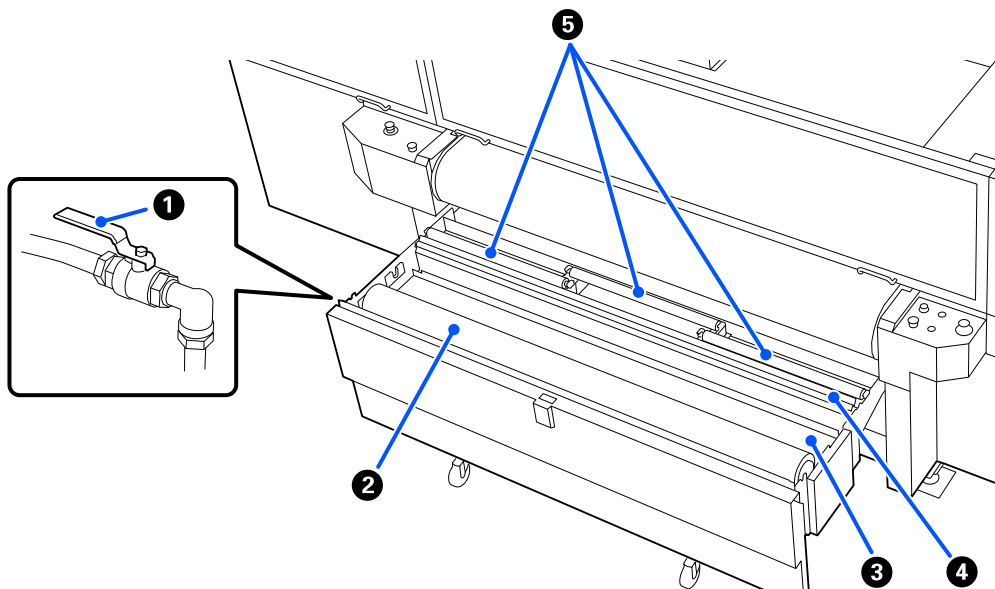
5 Flushing Pad

Ink is ejected here during flushing.

 [“Inspecting/Cleaning the Flushing Pad” on page 225](#)

 [“Replacing the Flushing Pad” on page 252](#)

Belt Cleaning Unit



1 Drain valve

Open to drain water that has accumulated in the belt cleaning unit. This must be closed when using the printer.

2 Cleaning brushes

Brushes away ink and other foreign material adhering to the belt.

 [“Cleaning the Belt Cleaning Unit” on page 237](#)

3 Belt cleaning tank

Water collects here when the belt is cleaned.

 [“Cleaning the Belt Cleaning Unit” on page 237](#)

4 Washing Scraper

Before Use

Wipes away water droplets left on the belt after belt cleaning.

 [“Cleaning the Belt Cleaning Unit” on page 237](#)

 [“Replacing the Washing Scraper” on page 261](#)

5 **Sponge Roller**

Absorbs water droplets that could not be removed by the washing scraper.

 [“Drying the Sponge Roller” on page 232](#)

 [“Replacing the Sponge Roller” on page 266](#)

Ink Supply Unit



1 **Ink cartridges**

Two ink cartridges for each color are inserted.

 [“Replacing the Ink Cartridges” on page 241](#)


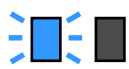



2 **Ink cartridge cover**

Prevents accidental contact with the connector on the ink cartridge. This must be closed when using the printer.

3 **Cartridge check lamp**

Lights or flashes in 2 colors to notify you of the status of the ink cartridge that is inserted.

Before Use

	Left side (blue) is lit	Ink is being supplied to the machine. Do not remove the ink cartridges.
	Left side (blue) is flashing	It is time to shake the ink cartridges. Remove the ink cartridges and shake them.
	Right side (orange) is lit	There is an error or warning. Check the details of the error or warning on the control panel's screen.
	Entire right side (orange) is flashing	An error that cannot be cleared has occurred. Check the details of the error on the control panel's screen. Turn the power for the printer off, and then turn it back on. If the error persists even after turning the power off and on, contact your dealer or Epson Support.
	Off	There are no problems. The ink cartridge can be removed, if necessary.

4 Connector

Connects the ink supply unit and the ink cartridge.

5 Ink supply port


Ink from the ink cartridge comes out of here.

Control Panel



1 light (power light)

The printer's operational status is indicated by a lit or flashing light.

On  : The power is on.

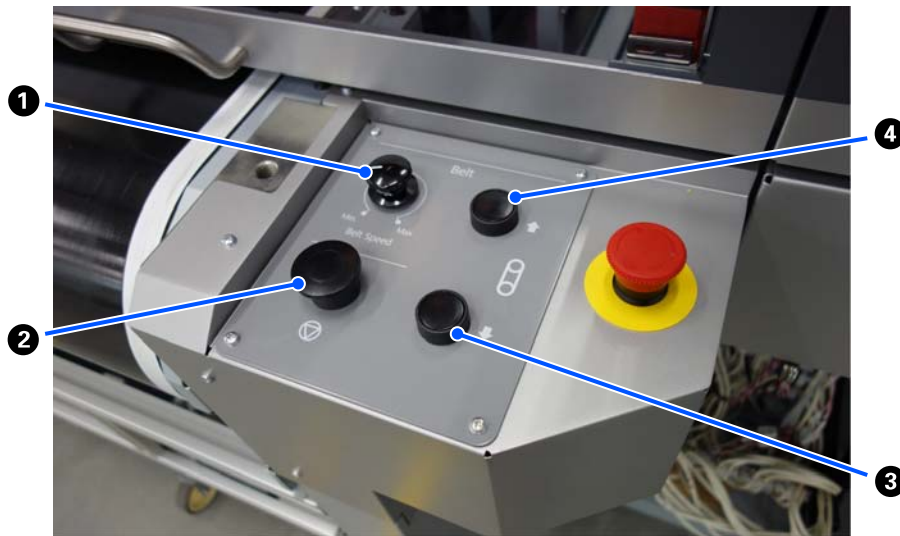
Before Use

Flashing : The printer is receiving data or performing head cleaning or other operations during shut-down.

Off : The power is off.

- ② **⏻ button (power button)**
Turns the power on and off.

Front Panel



- ① **Belt speed dial (Belt Speed)**
Use this knob to adjust the belt speed.

Turn to Min. for a slower speed, and to Max for a higher speed. The belt stops when the dial is aligned with Min.

To prevent workers from getting their fingers caught, you cannot change the belt speed for backfeed.

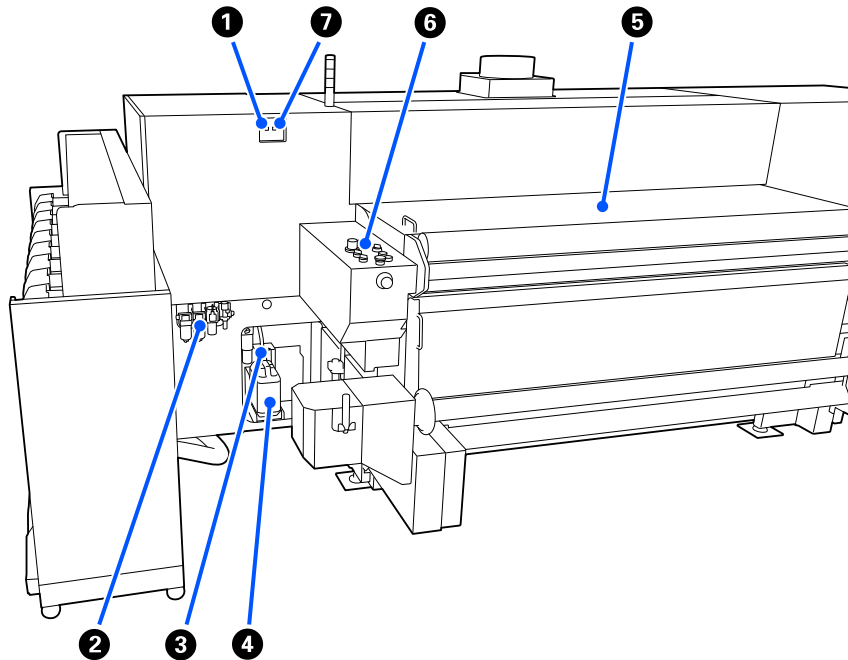
- ② **Pause button**
Pauses operations for this machine. Touch the **Resume** button on the control panel to resume printing.

- ③ **Feed button**
Press and hold this button to feed the belt in the forward direction (from rear to front).

- ④ **Backfeed button**
Press and hold this button to feed the belt in the reverse direction (from front to rear).

Before Use

Rear (Left Side)

**1 LAN port**

Connects the LAN cable.

Data lamp (Orange)

: The data lamp lights or flashes to indicate the network connection status and whether the printer is receiving data.


- On: Connected.
- Flashing: Connected. Receiving data.

Status lamp (Green)

: The color indicates the network's communication speed.

2 Air supply regulator

Supplies compressed air to the printer.

 [“Inspecting/Adjusting the Air Pressure” on page 197](#)

 [“Inspecting/Draining the Air Supply Regulator” on page 211](#)

3 Waste ink tube

Waste ink is ejected from here. Be sure the end of this tube is in the waste ink bottle while the printer is in use.

4 Waste ink bottle

Waste ink collects in this bottle.

 [“Replacing the Waste Ink Bottle” on page 247](#)

5 Rear cover

Before Use

Open this cover when loading fabric. This must be closed when using the printer.

6 Rear panel

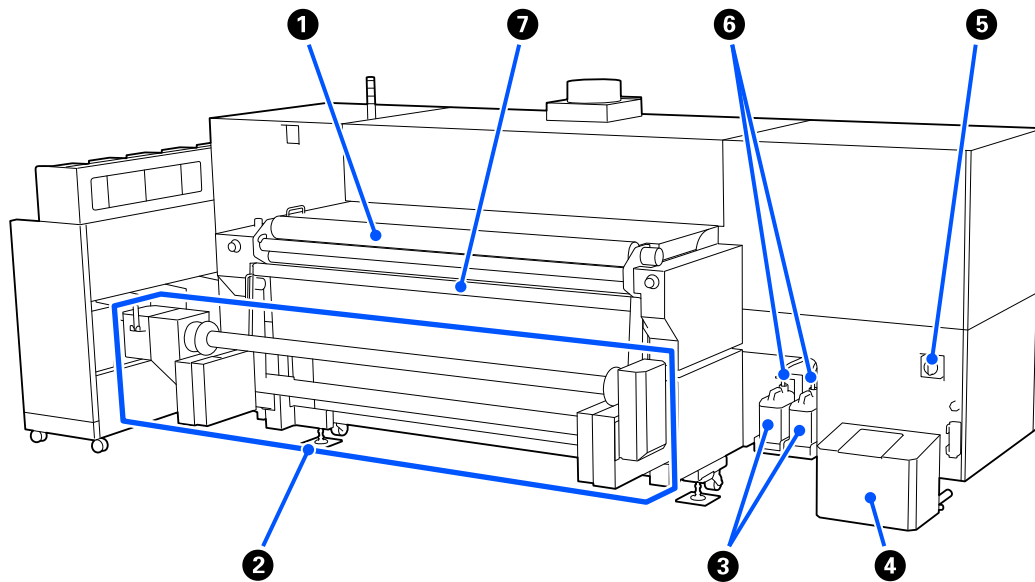
Use these controls to load fabric and so on.

 [“Rear Panel” on page 26](#)

7 USB port

Connects the USB cable.

Rear (Right Side)



1 Tension roller

Pass the fabric through the roller to apply tension when printing.

2 Feeding unit

Feeds fabric from the loaded fabric roll during printing.

 [“Feeding Unit” on page 22](#)

3 Waste ink bottle

Waste ink collects in this bottle.

 [“Replacing the Waste Ink Bottle” on page 247](#)

4 Water recycling unit

This circulates cleaning water used by the belt cleaning unit to remove lint and replace the cleaning water.

Before Use

5 Main Power Switch

Turns the main power of the machine on and off.

ON : Turns on the main power.

OFF : Turns off the main power.

6 Waste ink tube

Waste ink is ejected from here. Be sure the end of this tube is in the waste ink bottle while the printer is in use.

7 Tension bar

After loading the fabric, you can tilt this back to print while applying tension to the fabric.

Inside Rear



1 Fabric wrinkle detection sensor

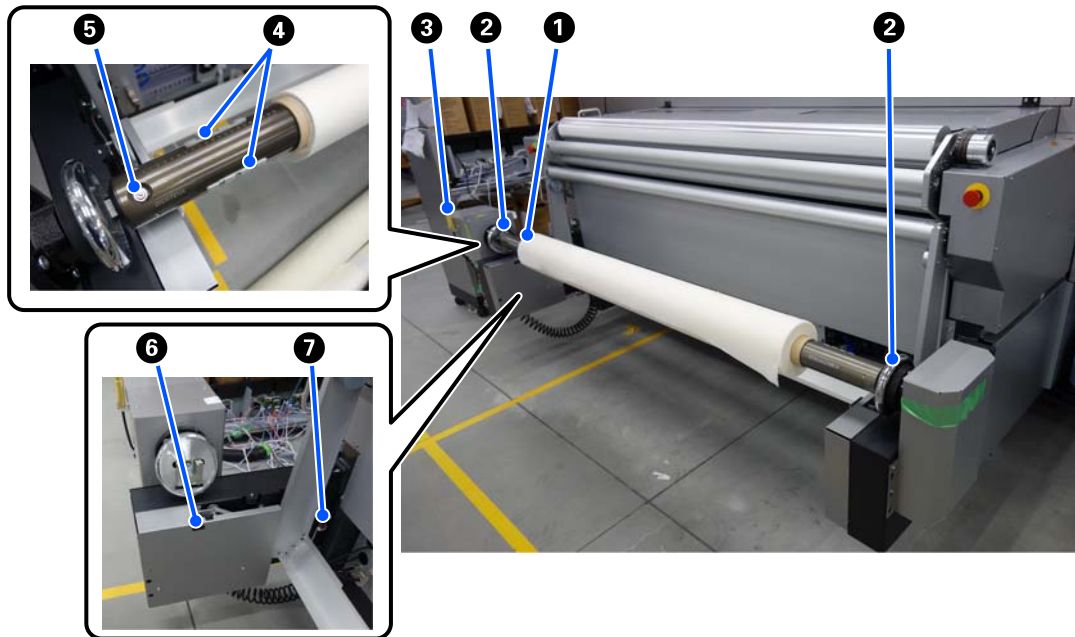
Detects curling and floating of the fabric. If the sensor detects that the fabric has curled or lifted, the machine comes to an immediate stop.

 [“Setting the Fabric Wrinkle Detection Sensor” on page 89](#)

2 Heated pressure roller

Presses down on the fabric during printing to attach it to the belt.

Before Use

Feeding Unit
**1 Feeding spindle**

Rotates during printing to feed the fabric.

 [“Installing the Fabric Roll” on page 56](#)

2 Locks

Secures the left and right of the feeding spindle.

3 Air inflating tool

Tool for supplying air to the feeding spindle. Insert this into the air inlet to use.

4 Stoppers

The feeding spindle inflates when air is supplied. These secure the fabric roll to prevent it from coming off the feeding spindle.

5 Air inlet

Air inlet for supplying air to the feeding spindle. Insert the air inflating tool to use.

6 Roll Diameter Measurement Sensor

Measures the roll diameter of the loaded fabric roll.

 [“Sensor Settings” on page 131](#)


 [“Inspecting/Cleaning the Sensors” on page 216](#)

7 Slack Detection Sensor

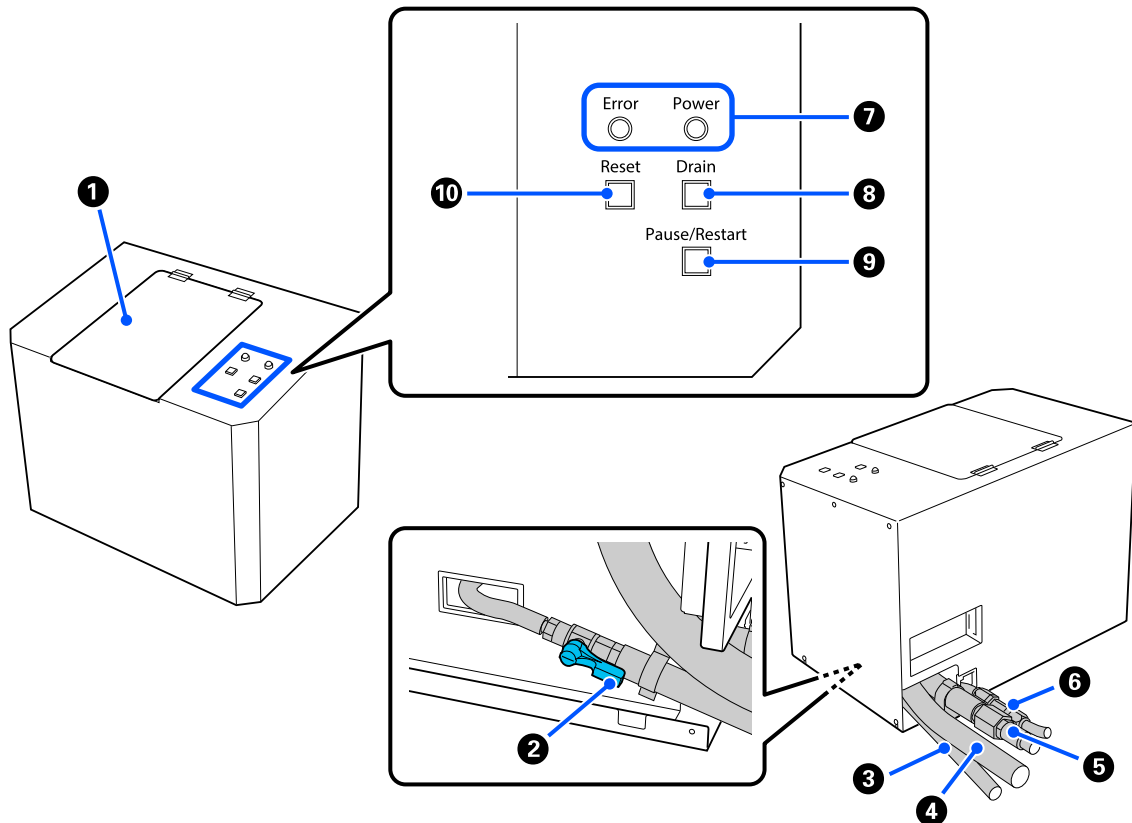
Before Use

Measures the amount of slack in the fabric.

 “Sensor Settings” on page 131

 “Inspecting/Cleaning the Sensors” on page 216

Water Recycling Unit (Exterior)



1 Maintenance cover

You can look through this cover and see the cleaning water flowing into the product during operation. Open this to perform maintenance, such as cleaning the inside of the tank.

2 Manual valve

Allows you to open and close the supply path from the product to the printer's belt cleaning tank. Use this if there is an issue with the product.

To operate this, you need to remove the cover screwed on to the right side of the product.

3 Belt cleaning tank water supply hose

Supplies cleaning water from the product to the printer's belt cleaning tank.

4 Belt cleaning tank drainage hose

Releases cleaning water from the printer's belt cleaning tank to this product.

Before Use

5 Drainage hose

Releases cleaning water discharged from the product.

6 Water supply hose

Supplies clean water to the product.

7 Status lights

You can check the product's operating status and error status.

 [“Understanding the Status Lights on the Water Recycling Unit” on page 456](#)

8 Drain Button

Press when cleaning inside the tank. The cleaning water in the tank is drained into the printer's belt cleaning tank, lowering the water level in the tank.

 [“Cleaning Inside the Water Recycling Unit Tank” on page 218](#)

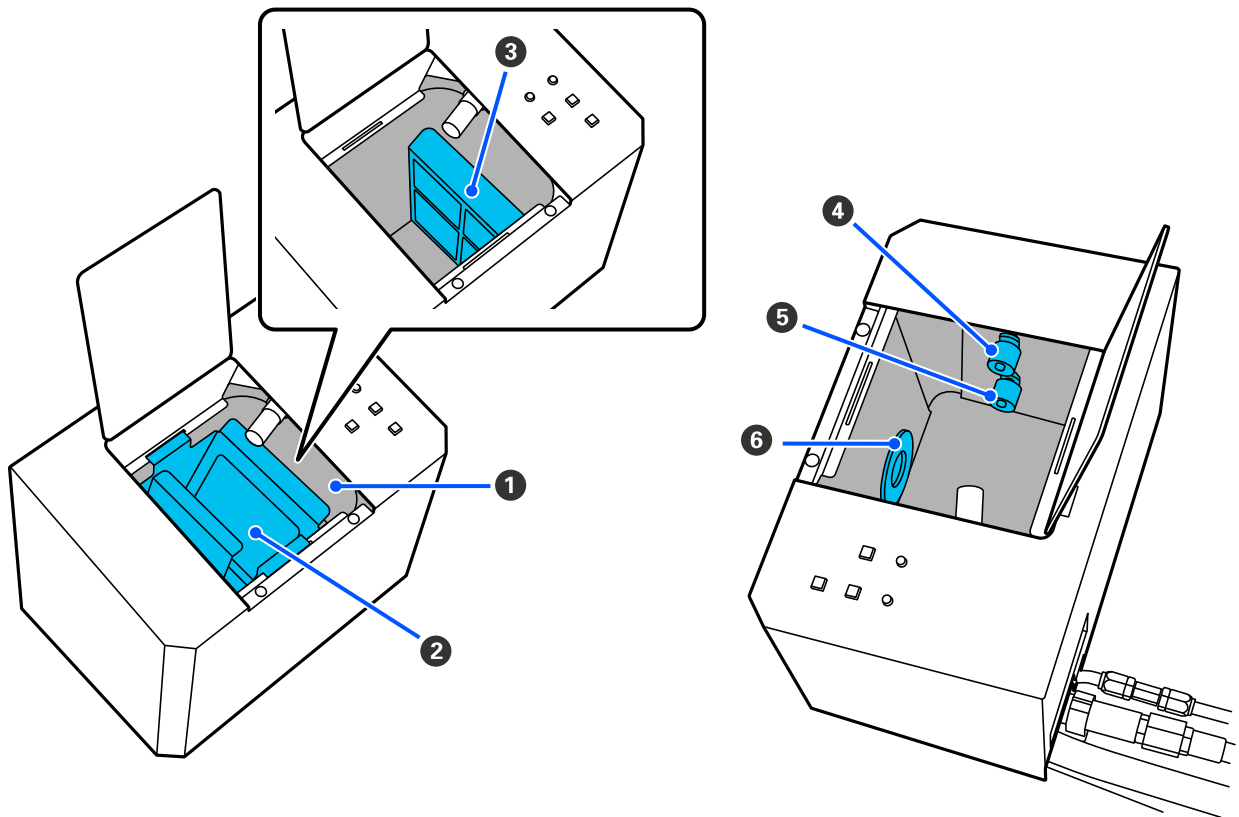
9 Pause/Restart Button



Press to pause the product. Press the button when the product is paused to restart.

10 Reset Button

Press and hold for at least three seconds to reset the product.

Water Recycling Unit (Interior)



- 1 Tank**
Collects the cleaning water that comes from the printer's belt cleaning tank.
- 2 Lint trap**
Collects the lint that comes from the printer's belt cleaning tank.
Clean this when too much lint has accumulated.
 [“Cleaning the Lint Trap” on page 194](#)
- 3 Lint filter**
Prevents lint from entering the printer's belt cleaning tank.
Clean this when too much lint has accumulated.
 [“Cleaning Inside the Water Recycling Unit Tank” on page 218](#)
- 4 Max. water level sensor**
Detects when the cleaning water in the tank has reached the maximum limit.
- 5 Min. water level sensor**

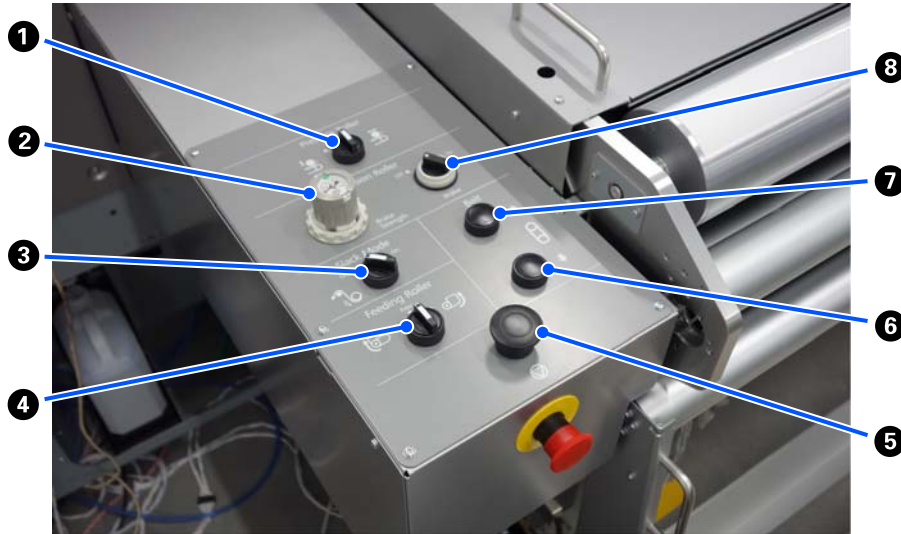
Before Use

Detects when the cleaning water in the tank has reached the minimum limit.

6 Ink density sensor

Detects the ink density in the cleaning water.

Rear Panel



1 Pressure roller switch (Pressure Roller)

Use this switch to change the operation of the heated pressure roller.

If you spin it to the left then let go, the switch automatically returns to the standby position (center).

If you spin it to the right, the switch stays in that position and continues operation. To stop operation, turn the switch to the center.

Left : The heated pressure roller lowers. The roller automatically rises up after a few seconds.

Right : When the rear cover is open, the heated pressure roller stays down a few seconds longer than when the switch is turned to the left.

When the rear cover is closed, the heated pressure roller lowers and moves back and forth.

When you turn the switch to the center, the roller stops and is raised.

Even if the heated pressure roller is lowered or moving back and forth, the heated pressure roller stops in the raised position in the following cases.

- When a certain amount of time has passed while the belt is stopped
- When the rear cover is opened

2 Tension adjustment dial (Brake Strength)

Before Use

Adjusts the tension applied to the fabric by the tension roller. The top meter indicates tension.

Pull the dial up to release the lock, and then adjust the tension.

Turn to right : Raises the tension.

Turn to left : Lowers the tension.

The default value is 0.2 MPa. If wrinkles still appear in the fabric, increase the tension to 0.45 MPa. The value is 0 MPa when the tension switch is off.

After adjusting the value, press down and lock the dial.

3 Slack detection switch (Slack Mode)

Use this switch to change the operation of the slack detection sensor.

Off : Disabled

On : Enabled

4 Feeding roller switch (Feeding Roller)

Use this switch to change the operation of the feeding roller.

Free : There is no limitation on the rotating direction of the feeding spindle.
Use this switch when attaching or removing fabric, and when connecting an external feeding device.

Left : Prints on the inner side of the fabric roll.
The feeding spindle rotates toward the rear of the printer.

Right : Prints on the outer side of the fabric roll.
The feeding spindle rotates toward the front of the printer.

5 Pause button

Pause printing. Touch the **Resume** button on the control panel to resume printing.

6 Backfeed button

Press and hold this button to feed the belt in the reverse direction (from front to rear).

7 Feed button

Press and hold this button to feed the belt in the forward direction (from rear to front).

8 Tension switch (Brake)

Switches the fabric tension for the tension roller between enabled and disabled.

Off : Disabled

Before Use

On : Enabled

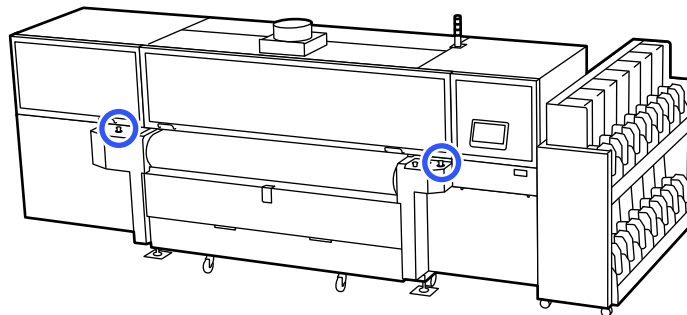
Emergency Stop Button

In the event of an emergency, press an emergency stop button on the machine. The machine comes to an immediate stop.

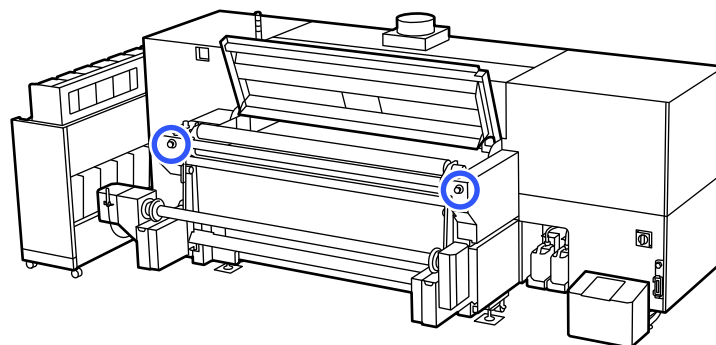


There are two emergency stop buttons on the front of the machine and two on the rear.

Front



Rear



Before Use


Releasing an emergency stop

To release the emergency stop, turn the button to the right.



Turn off the main power switch on the rear of the machine and then turn it on again. Press the power button on the control panel to restart the machine.

 [“Turning Off the Power” on page 110](#)

 [“Turning On the Power” on page 51](#)

Before Use

Understanding and Operating the Display

Precautions When Using the Control Panel

- ❑ Touch the panel with your fingers.
- ❑ Do not operate the panel with pointed objects, such as ballpoint pens or mechanical pencils. Doing so may damage the panel.

Doing so may damage the panel.
- ❑ Wipe the panel with a soft, dry cloth if it gets dirty. If it is very dirty, dampen a soft cloth with a diluted solution of mild detergent, wring it out thoroughly, wipe away the dirt, and then wipe with a dry, soft cloth. Do not use volatile chemicals such as thinner, benzene, or alcohol. Doing so may damage the surface of the panel.
- ❑ Do not use in environments subject to sudden changes in temperature or humidity. Doing so may cause condensation inside the panel, leading to a deterioration in performance.
- ❑ Do not press too hard on the panel or subject it to strong impacts. Doing so may crack the panel. If it does break, do not touch fragments or attempt to remove the panel; instead, contact your dealer or Epson Support.

Understanding the Display

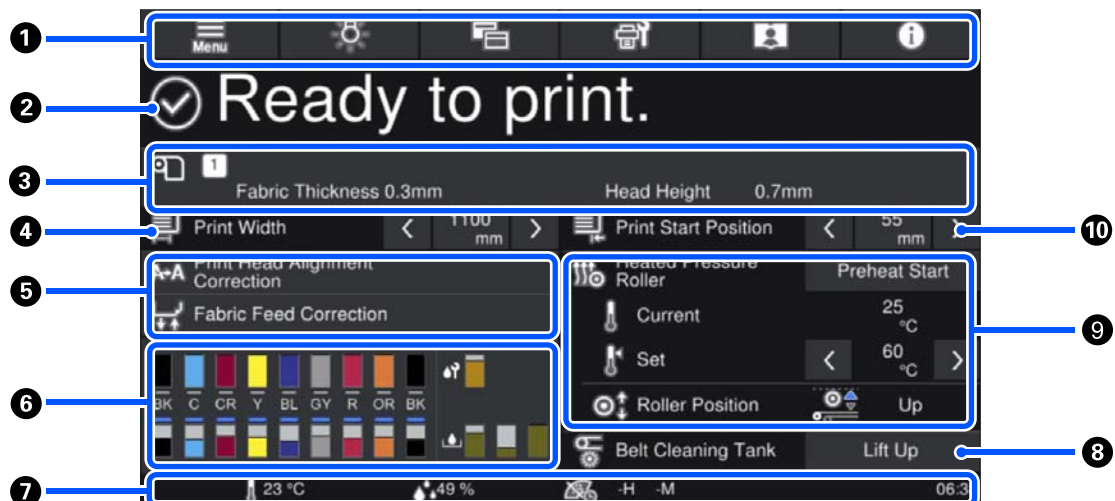
This chapter describes how to understand and operate the screen layout, using the Home screen, Menu screen, and the display for operating procedures screen as an example.

Home Screen

On the Home screen, you can switch between the Status Indicator screen and the Fabric Settings screen by touching the display switching button.

Status Indicator screen

The printer's status can be listed.



Before Use

1 Header

Displays the buttons for frequently-used functions. The functions of the buttons are shown below. The header also appears similarly on other screens.



Menu

Displays the Settings menu.



Inside light

Switches the inside light on or off. The display changes as follows, depending on the status.



: On



: Off

Setting Auto for Inside Light in the Printer Settings, turns the light on automatically when operations that need light are done, such as while printing, and turns it off when the operation is complete. However, it may not come on, depending on the condition of the printer. In these cases, the button changes to gray.

 [“General Settings Menu” on page 434](#)



(Switching displays)

The display will switch between the Status Indicator screen and the Shortcut screen every time you press this button.



Maintenance

The Maintenance Menu appears on the screen, allowing you to execute maintenance operations such as print head maintenance or replacement of consumables.





Online Manuals

A QR code will be displayed that allows direct access to the online manuals.



Printer Status

Displays the printer status. If there are any notifications, such as about running low on consumables, the  icon appears at the top right of the screen. The display that appears when you touch the button displays a Message List for matters not yet handled. Instructions appear if you touch the items, so follow the directions to resolve any issues. Once everything is resolved, the  icon disappears.

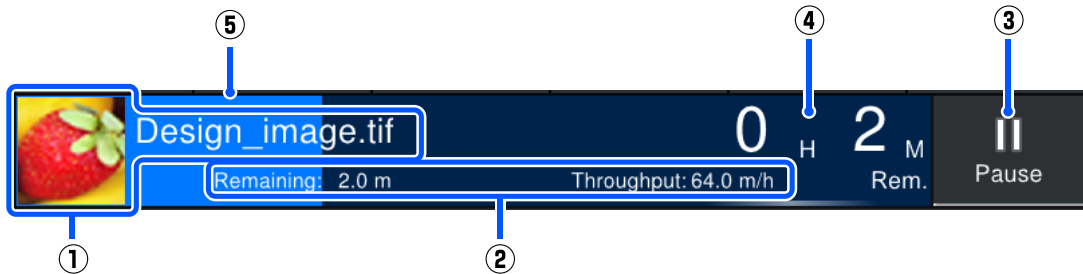
2 Messages

Before Use

Displays the printer's status and messages that give instructions.

[☞ “When a Message is Displayed” on page 453](#)

During printing, the display switches, as seen in the illustration, and shows the following information and buttons.



① : File name and preview of image being printed

Sometimes, not all file names are displayed.

② : Print Information, Throughput, and Pass Mode

Touching the display area during printing will switch the display to the selection screen. You can select up to two items to be displayed among **Print Information**, **Throughput**, and **Pass Mode**.

③ : Pause (Suspend) button

Appears as the Start button while warming up, until the heater reaches the set temperature. Touching this button starts printing, even if the heater temperature is low.

④ : Estimated time until completion

⑤ : Progress bar

Pauses printing

Touching the Pause button while printing displays a screen for selecting the timing to suspend, touch one to select it.

- Immediate pause: Stops printing immediately.
- Pause between jobs: Stops at the end of the job currently printing.

Touch **Resume** on the paused screen to continue printing. Touch **Cancel** to cancel printing.

③ Fabric information

Displays information about the fabric that is loaded. The number indicates the fabric setting number. Touch the display area to show the Fabric Settings menu.

[☞ “Fabric Settings Menu” on page 443](#)

④ Print Width

Before Use


Displays the print width of the fabric.

Touch  /  to change the print width in increments of 1 mm.

You can directly enter the value by touching the Print Width value display area. After entering the value, press **OK** to set the value.

5 Print Head Alignment Correction/Fabric Feed Correction

When banding occurs in print results, you can perform Print Head Alignment Correction and Fabric Feed Correction without interrupting the printing.

 [“Changing settings while printing” on page 36](#)

6 Supply Status

Information regarding consumables, such as ink cartridges, are displayed using the following icons and bar lengths.



Ink cartridge status

Displays the approximate level of remaining ink and the current status. If the amount of ink runs low, the bar becomes shorter.

The code at the bottom of the bar display indicates the ink color.

 [“Ink cartridges” on page 472](#)

The display changes, as shown below, if a warning or error occurs.



The amount of ink is estimated to be low. Once the ink cartridge is expended, the printer automatically switches to the other ink cartridge. Confirm that a new ink cartridge is installed on the other side.



Ink is expended. Replace the old ink cartridge with a new one. More than 30 minutes have elapsed since the ink cartridge connector was disconnected. Immediately connect the connector, because if it is left the way it is, the ink will dry out and the printer may not function normally.



It is time to shake the ink cartridges. Remove the ink cartridges and shake them.



The connector for an ink cartridge is disconnected. Insert the ink cartridge and connect the connector correctly.



Waste ink bottle status

Displays the approximate amount of space available in the waste ink bottle. If the amount of space decreases, the bar becomes shorter.

The display changes, as shown below, if a warning occurs.



The waste ink bottle is almost full. Prepare a new waste ink bottle.

Before Use



Wiper roll status

Displays the guideline for replacement of the wiper roll. As the time for replacement gets closer, the bar becomes shorter.

The display changes, as shown below, if a warning occurs.



The wiper roll will need to be replaced soon. A new wiper roll needs to be prepared.

Touching the display area shows the Supply Status screen and you can check the part numbers for consumables. You can also switch the ink cartridges to be used. (Changing the active slot)

To change the ink cartridge, touch the bar display of the one you are not using, confirm the on-screen message, and then touch Start.

7 Footer

The footer is also displayed on other screens, not just on the home screen.



- ① : Displays the temperature* around the printer.
- ② : Displays the humidity* around the printer.
- ③ : The following is displayed depending on the periodic cleaning or maintenance cleaning settings.

[“General Settings Menu” on page 434](#)


Maintenance cleaning	Periodic Cleaning	Contents
On	When set to run every time printing is performed	Whichever cleaning comes first is displayed. <ul style="list-style-type: none"> <input type="checkbox"/> Time remaining until maintenance cleaning starts <input type="checkbox"/> Remaining printing time until periodic cleaning starts
On	<input type="checkbox"/> Off <input type="checkbox"/> When set to run after a certain number of print jobs or print length is reached	The time remaining until maintenance cleaning starts is displayed.
Off	When set to run every time printing is performed	The remaining printing time until periodic cleaning starts is displayed.
Off	<input type="checkbox"/> Off <input type="checkbox"/> When set to run after a certain number of print jobs or print length is reached	Nothing is displayed.

Before Use

- ④ : When periodic cleaning is set to run after a certain number of print jobs or print length is reached, the remaining number of print jobs or remaining printing length is displayed. Nothing is displayed when it is set to run every time printing is performed or when it is turned off.

 [“General Settings Menu” on page 434](#)

- ⑤ : Displays the current time.

* If the temperature or humidity is outside the printer's operating environment range,  is displayed. For high-quality printing, use the printer within the range of the printer's operating environment.

⑧ Belt cleaning tank

Switches between raised and lowered belt cleaning unit. The display changes as follows, depending on the status.

Lift Up : Lowered status

Set Down : Raised status

- When pulling out the belt cleaning unit, lower it before pulling it out. You cannot pull it out when the unit is raised.
- When feeding the belt, raise the belt cleaning unit. If the belt is fed while the unit is lowered, water droplets will remain on the belt.

⑨ Heated pressure roller


Displays the current temperature, set value, and raised/lowered status of the heated pressure roller.


Heater Preheat Start

If you touch this when **Heater** from **Fabric Settings - Current Settings** is set to **On**, the heated pressure roller is preheated based on the value set in **Set**.

Touch the Preheat Start button when you want to start preheating before receiving a print job.

Once preheating starts, the following will be displayed until the machine reaches the set temperature.

 : Heating



 : Cooling

Current Temperature

Displays the current temperature of the heated pressure roller.

Set

Displays the set temperature of the heated pressure roller.


You can adjust the temperature by touching  /  when the **Heater** under **Fabric Settings - Current Settings** is **On**.


Before Use

Roller position

Displays the raised/lowered status of the heated pressure roller.

The display changes as follows, depending on the status.

 : Raised status

 : Lowered status

When printing, make sure that the roller is lowered.



If you print while the roller is raised, the fabric may drift up and shift the print position.

See the following if you want to raise/lower the roller.

 [“Rear Panel” on page 26](#)

10 Print Start Position

Set the distance from the edge of the belt on the right side (standard position) to the position where you want to start printing.

Touch  /  to change the print start position value in increments of 1 mm.

You can directly enter the value by touching the number display area of the Print Start Position. After entering the value, press **OK** to set the value.

Changing settings while printing

During printing, you can change the Fabric Settings displayed in the Home screen. If a problem, such as banding or wrinkles, occurs, change the Fabric Settings to fix it. During printing, you can easily solve problems because you can check the results you see as you make changes. In addition, you can make quick fixes, without stopping printing, when problems occur shortly after printing starts.

Changing the settings in the Home screen changes the content of the current Fabric Settings.

 [“Problem Solver” on page 453](#)

This section provides an example of how to change the Fabric Feed Correction or Print Head Alignment Correction to compensate for banding.

1 Touch the Print Head Alignment Correction or Fabric Feed Correction information area.

The Settings screen is displayed.


Perform fabric feed correction.

Before Use

2 Change the values by touching  /  as you check the printing results.


If the fabric feed amount is too small, black bands (dark stripes) will appear; adjust the feed amount upwards.



If, in contrast, the fabric feed amount is too large, white bands (pale stripes) will appear; adjust the feed amount downwards.


Once the print results have improved, touch  to finish the correction.


If the problem is not resolved, proceed to the next step.

Perform print head alignment correction.

3 Change the values by touching  as you check the printing results.

If the print result does not improve or becomes worse even after touching , touch  to change the value.

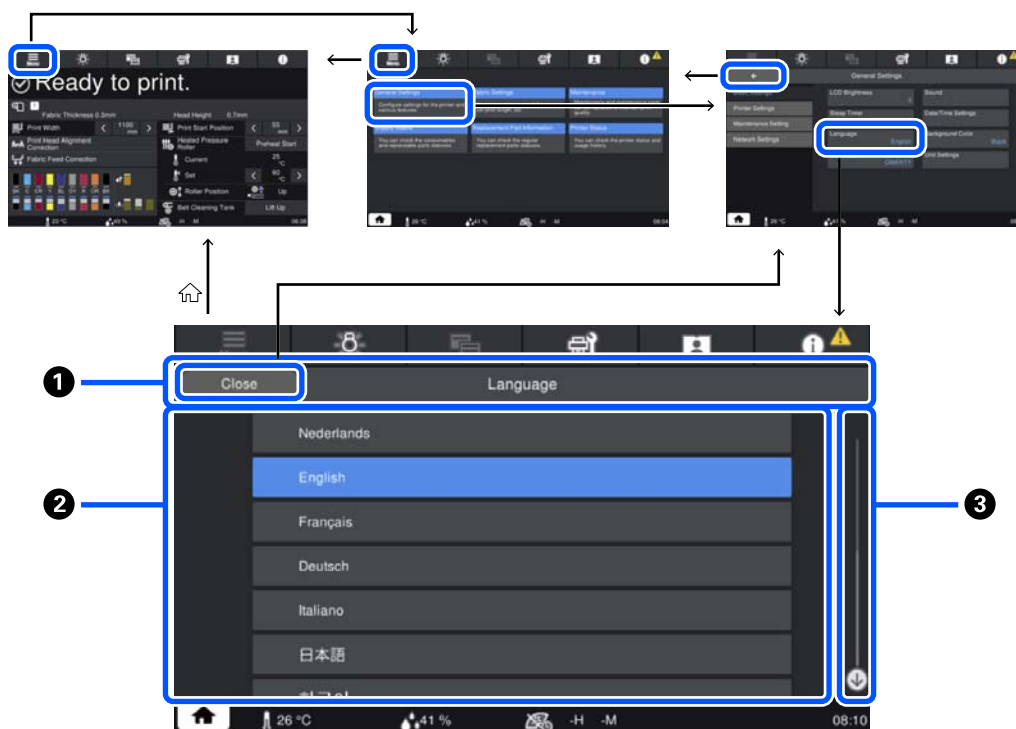
Once the print results have improved, touch  to finish the correction.

If the problem is not resolved, perform print adjustments after printing is complete. Touch  to finish the correction, and then perform **Manual(Simple)** from **Print Head Alignment**.

 [“Print Head Alignment \(Manual\)” on page 114](#)

Menu Screen

Touch  on the Home screen to display the Menu screen.



1 Screen name display area

Before Use



Displays the screen's name. Touching Close or  returns you to the previous screen.

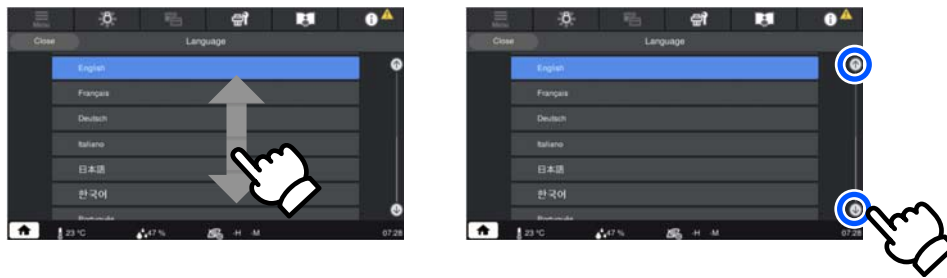
2 Operation area

Displays buttons and other items. The displayed contents vary according to the screen.

3 Scroll bar

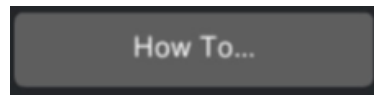
Appears when all of the options, do not fit in the operation area. If the scroll bar is shown, check the options, by scrolling up and down.

You can scroll by touching and holding the item you want to scroll and moving it up and down (slide), or by touching  /  to scroll, as shown in the illustrations below.

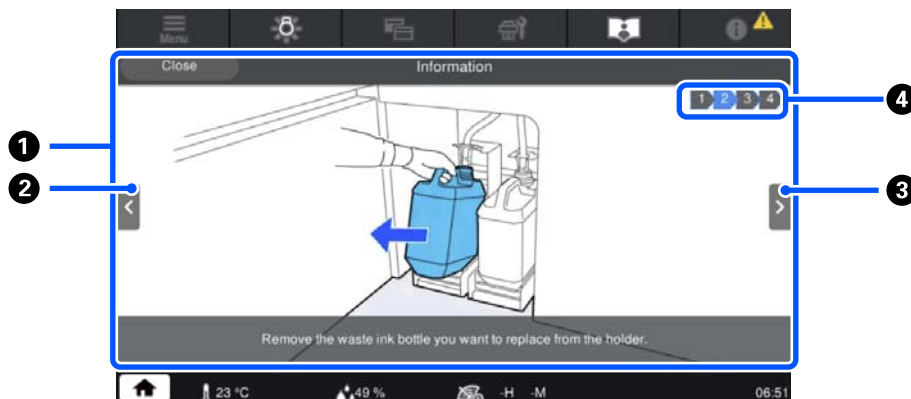


Instructions Screen

The following buttons may appear on screens on which a series of operations starts.



If you touch the buttons, the instructions are explained using illustrations for each step to make them easy to understand. Even if you do not remember the instructions, you can work while looking at the screen.



1 Instructions display area

Displays the instructions. Depending on the step, the Instructions screen may display and cycle through multiple illustrations.

2 Previous step button

Before Use

Displays the previous step.

3 Next step button

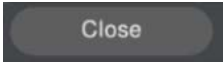
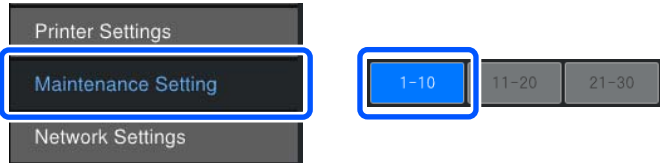
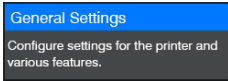

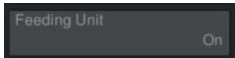
Displays the next step.

4 Step number

Displays the total number of steps. The color of the step that is currently shown changes to blue.

Types of Buttons

Depending on the screen, the following types of buttons appear. Even if they are the same buttons, how they look may change, depending on the situation.

<p>Standard buttons</p>	<p>These buttons appear the most. Example:</p>  <p>In a list of buttons of selectable items, when a button's text and background colors turn blue, it indicates that it is selected. Example:</p> 
<p>Buttons that show descriptions</p>	<p>These are buttons that display an item name on top and an explanation of the item on bottom. Example:</p> 
<p>Buttons that show setting values</p>	<p>These are buttons for setting items. The current setting value appears at the bottom-right in blue text. Example:</p> 
<p>Buttons that can be switched on/off</p>	<p>These are buttons for switching settings on and off. Touching the button switches the setting.</p>
<p>Buttons that turn gray (gray-out)</p>	<p>This indicates that the button cannot be used. These buttons turn gray only when they cannot be operated for reasons, such as items not being selectable because of unmet conditions. The conditions for being operable change depending on the button. Example:</p> 

Notes on Usage and Storage

Installation Space




Make sure that you install the product in an area that meets the work space requirements and that is clear of any other objects so that you have enough room to set fabric and replace consumables.

See the “Specifications Table” for the external dimensions of the printer or the work space.

 [“Specifications” on page 478](#)

Notes When Using the Printer

Note the following points when using this printer to avoid breakdowns, malfunctions, and print quality decline.


- ❑ When using the printer, observe the operating temperature and humidity range described in the “Specifications Table”.
 [“Specifications” on page 478](#)
Note, however, that the desired results may not be achieved if the temperature and humidity are within the limits for the printer but not within those for the fabric. Be sure the operating conditions suit the fabric. For more information, see the user’s manual for the fabric.
Also, when operating in dry areas, air conditioned environments, or under direct sunlight, be careful of drying and maintain the appropriate humidity.
- ❑ Avoid using the printer in locations with heat sources or that are exposed to direct draughts from ventilators or air conditioners. The print head nozzles could dry out and clog.
- ❑ Do not bend or tug the waste ink tube. Ink could spill inside or around the printer.
- ❑ Maintenance such as cleaning and replacement must be performed according to usage frequency or at recommended intervals. Failure to perform regular maintenance could result in loss of print quality. In the absence of the appropriate maintenance, continued use could damage the print head.
 [“When to Perform Various Maintenance Operations” on page 181](#)
- ❑ The print head may not be capped* if the printer is turned off when the fabric is jammed or an error has occurred. In this case, turn on the power and wait a while until capping is performed automatically. If capping is not performed automatically for more than 20 minutes, perform manual capping.
 [“Capping the Print Head” on page 290](#)

*: Capping is a function that automatically covers the print head to prevent it from drying out. When capped, the print head is positioned at the front left edge.
- ❑ When the power is on, do not remove the power plug from the power outlet or cut the power at the main power switch. The print head may not be capped properly. In this case, turn on the power and wait a while until capping is performed automatically.
- ❑ When **Maintenance Cleaning** is **On**, the print head is automatically cleaned at a fixed interval after printing to keep the nozzles from clogging.
Be sure that the waste ink bottle is placed whenever the printer is on.
- ❑ As well as being expended during printing, ink is used during head cleaning and other maintenance required to keep the print head in working order.

Before Use

Notes When Not Using the Printer

If you are not using it, note the following points when storing the printer. If it is not stored correctly, you may not be able to print properly the next time it is used.

- ❑ A service engineer must do pre- and post-maintenance when the machine is not used for 4 weeks or longer. Contact your dealer or Epson Support. Pre- and post-maintenance will be provided for a fee. During pre-maintenance, the ink in the ink tubes is removed, and the inside of the tubes is cleaned to prepare the machine for long-term storage. When restarting use of the printer, recharge the printer with ink. Moreover, depending on the environment and length of time stored, repairs may be required during post-maintenance even if pre-maintenance is done. If repairs are necessary, they will be done for a fee. Contact your dealer or Epson Support.
- ❑ If you have not used the printer for 2 days to 3 weeks, be sure to check the print heads for clogging before you resume printing. Execute Print Head Cleaning if the print heads are clogged.
 ["Print Head Nozzle Check" on page 281](#)
- ❑ If you leave the fabric in the machine, the heated pressure roller may crease the fabric. The fabric may also become wavy or curled, causing jams or resulting in the fabric coming into contact with the print head. Remove the fabric before putting the printer in storage.
- ❑ Store the printer after confirming that the print head has been capped (the print head is positioned at the far left). Leaving the printer for 20 minutes or longer without capping may cause the print quality to decline. If the printer is not capped, turn it off and on again.
- ❑ Close all covers before placing the printer in storage. If you are not using the printer for a long time, put an anti-static cloth or cover on the printer to prevent dust. Printer nozzles are very small. As a result, tiny particles of invisible dust may adhere to the print head causing the nozzles to clog and you may not be able to print properly.
- ❑ When storing the printer, be sure that it is level: do not store it on an angle, on end, or upside down.

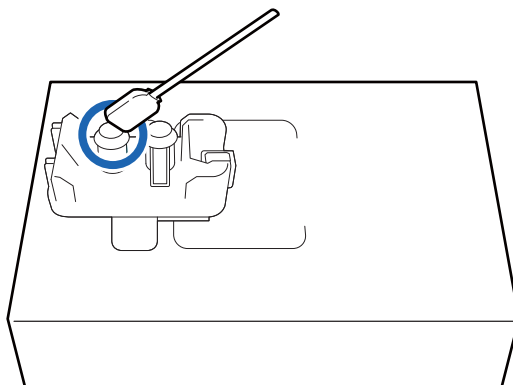
Notes on Handling Ink Cartridges

Note the following points when handling ink cartridges to maintain good print quality.

- ❑ When the printer charges the ink for the first time immediately after purchase, enough ink is consumed to fill the print head nozzles to their tips so that it is ready to print. Prepare replacement ink cartridges as soon as possible.
- ❑ Store ink cartridges at room temperature in a location that is not exposed to direct sunlight.
- ❑ To ensure print quality, use all the ink in the cartridge before the earlier of the following dates:
 - ❑ The expiration date shown on the ink cartridge packaging
 - ❑ Six months after opening the ink cartridge packaging
- ❑ If you move ink cartridges from a cold place to a warm place, leave them at room temperature for more than 18 hours before using them so the temperature of the ink can reach room temperature.
- ❑ Do not touch the IC chip on the ink cartridge. You may not be able to print properly.

Before Use

- ❑ Do not leave the printer without ink cartridges installed. The ink in the printer will dry out and the printer will not function as expected. Leave ink cartridges installed even when the printer is not in use.
- ❑ Because the green IC chip contains the cartridge's own information such as the remaining ink level, you can still reinstall and use the ink cartridge after removing it from the printer.
- ❑ Use a cleaning stick from the supplied Cleaning Kit to absorb all the ink attached to the ink supply ports of ink cartridges that have been removed from the printer before all the ink is used. Dried ink on the supply port may cause ink leaks when the cartridge is reinserted and used. Also, replace the cleaning sticks with a new one for each color.



- ❑ Store the ink cartridges that have been removed so as to keep the ink supply ports free of dust. The ink supply port has a valve in it so it does not need to be capped.
- ❑ Removed ink cartridges may have ink around the ink supply port, so be careful not to get any ink on the surrounding area when removing the cartridges.
- ❑ To maintain the quality of the print head, this printer stops printing before ink cartridges are completely expended.
- ❑ Although the ink cartridges may contain recycled materials, this does not affect printer function or performance.
- ❑ Do not dismantle or remodel ink cartridges. You may not be able to print properly.
- ❑ Do not drop the ink cartridges or subject them to strong impacts. Failure to observe this precaution could cause ink to leak from the cartridges.

Introducing the Software

This machine is supplied with the following applications as printing tools.

For information about these applications, refer to the Help section or affiliated manual for each application.

Note:

Printer drivers are not provided. A software RIP is required for printing.

Before Use

Supplied Software

Epson Edge Dashboard is compatible with Mac and Windows, but other provided software is compatible with Windows only.

Name	Summary
Epson Edge Dashboard	<p>After registering this printer in Epson Edge Dashboard, you can perform the following operations.</p> <ul style="list-style-type: none"> <input type="checkbox"/> Monitor the printer's status You can monitor the printer's operating status, ink levels, and so on. <input type="checkbox"/> Set and change media settings You can set and change media settings and load them into the printer. You can also copy media settings from other printers registered in Epson Edge Dashboard to this printer, or copy media settings from this printer to other printers. <input type="checkbox"/> Acquire the printer firmware updater You can download files to update the printer firmware. 🔗 "How to Use Epson Edge Dashboard" on page 44
Epson communications drivers	Epson communications drivers is required when using Epson Edge Dashboard, Epson Edge Print, and when connecting a computer to the printer via USB. Make sure these are installed.
Epson Edge Print (Optional item supplied)	<p>Epson's genuine software RIP. Allows you to perform easy color matching and printing that maximizes the performance of Epson printers.</p> <p>🔗 "How to Use Epson Edge Print" on page 44</p>
Epson Rob file print tool	<p>This is an application for printing data in the Rob format.</p> <p>🔗 "How to Use Epson Rob file print tool" on page 45</p>

Resident Software

This is software that is pre-installed on this printer. You can use this software by launching it from a Web browser over a network.

Name	Summary
Web Config	<p>Software for network administrators.</p> <p>You can make network security settings from Web Config. There is also an email notification function that informs you of any errors in the printer.</p> <p>🔗 "How to Use Web Config" on page 46</p>

Before Use

How to Use Epson Edge Dashboard

Using the Software

Install Epson Edge Dashboard and the Epson communications drivers on a computer connected to this printer by USB or network.

If you are using Epson Edge Print, installing Epson Edge Print and the model information file will also install Epson Edge Dashboard and the Epson communications drivers.

For more details, contact your local dealer.

Instructions for Starting

Epson Edge Dashboard is a web application.

For Windows

Start using one of the following methods.

- ❑ Click the **Epson Edge Dashboard** icon in the desktop taskbar and select **Show Epson Edge Dashboard**.



- ❑ Click the Windows start button - **All apps** - **Epson Software** - **Epson Edge Print**, in that order.

For macOS

Click the **Epson Edge Dashboard** icon in the desktop menu bar and select **Show Epson Edge Dashboard**.



For detailed usage instructions, see the help for Epson Edge Dashboard.

Exiting Procedure

Close the Web browser.

How to Use Epson Edge Print

Using the Software

To use Epson Edge Print with this printer, an Epson Edge Print PRO X2 license is required. Install Epson Edge Print and this printer's model information file on a computer connected to this printer by USB, and activate the license.

Before Use

In addition, by using Epson Edge Print PRO X WF, you can create print data for Epson Edge Print on a computer not connected to this printer by USB, and then transfer the print data to a computer connected to this printer by USB for printing.

For more details, contact your local dealer.

Instructions for Starting

Start using one of the following methods.

- Double-click the shortcut icon created on the desktop.



- Click the Windows start button - **All apps** - **Epson Software** - **Epson Edge Print**, in that order.

For detailed usage instructions, see the help for Epson Edge Print.

Exiting Procedure

Select **Exit** from **File** at the top-left of the screen.

How to Use Epson Rob file print tool

Using the Software

Install the Epson Rob file print tool for this printer on a computer connected to this printer by USB or network.

You cannot print using an Epson Rob file print tool designed for other models.

Additionally, you cannot install the Epson Rob file print tool for this printer and another model on the same computer at the same time.

If you install the Epson Rob file print tool for another model on a computer where the Epson Rob file print tool is already installed, the history information for the previously installed Epson Rob file print tool is deleted, and the tool is uninstalled.

For more details, contact your local dealer.

Instructions for Starting

Start using one of the following methods.

Before Use

- ❑ Double-click the shortcut icon created on the desktop.



- ❑ Click the Windows start button - **All apps** - **Epson Software** - **Epson Rob file print tool**, in that order.

For detailed usage instructions, see the Operation Guide for the Epson Rob file print tool.

Exiting Procedure

Click the X at the top-right of the screen.

How to Use Web Config

Instructions for Starting

Start the software in a browser on a computer connected to the same network as the printer.

- 1 Check the printer's IP address.

From the **General Settings** menu, press **Network Settings** - **Network Status** - **Wired LAN Status**, in that order.

- 2 Open a browser on a computer connected to the same network as the printer.

- 3 Enter the printer's IP address in the address bar of your browser.

IPv4: `https://printer's IP address/`
IPv6: `https://[printer's IP address]/`

Example:

IPv4: `https://192.168.100.201/`
IPv6: `https://[2001:db8::1000:1]/`

- 4 Click **Log in** at the top-right of the screen, and then enter your administrator User Name and Administrator Password.

Enter the following values when starting up for the first time or when the administrator User Name and Administrator Password have been initialized.

Leave the administrator User Name blank.

Enter the printer's serial number as the Administrator Password.

Before Use



Important:

- ❑ Do not continue to use the default Administrator Password, change it to a new one. Set your own administrator User Name.

See the following for the setting procedure.

[🔗 “If you have forgotten your administrator User Name or Administrator Password” on page 470](#)

Save the User Name and Administrator Password you set in a safe location so that you do not forget them.

- ❑ Every time you change the Fabric Settings or Network Settings, we recommend exporting or saving a copy of them. For more details on copying the Fabric Settings, see the Epson Edge Dashboard help. See the following for details on how to export network settings.

[🔗 “How to Export and Import Network Settings” on page 47](#)

How to Set/Change the Administrator User Name/Administrator Password

Make sure you change the password to prevent unauthorized external access and to ensure that only users who know the Administrator Password can operate the printer. Set your own administrator User Name.

You can set or change them from the **Change Administrator Password** menu on the **Product Security** tab.



Important:

Save the administrator User Name and Administrator Password you set or changed in a safe location so that you do not forget them.

If you forget the administrator User Name or Administrator Password, you will need to reset the printer's network settings.

[🔗 “If you have forgotten your administrator User Name or Administrator Password” on page 470](#)

How to Export and Import Network Settings

You can export and import the network settings that can be set in Web Config.

Every time you change the network settings, we recommend exporting the new settings.

How to export

1

On the **Device Management** tab, click **Export and Import Setting Value - Export File**.

2

Select the items to be exported.

3

Set a password in the **Password** and **Confirm Password** fields.

Before Use

- 4 Press **Export File**, and then select where to save the file for the exported items.
Selected items are exported.

How to import

- 1 On the **Device Management** tab, click **Export and Import Setting Value - Import**.
- 2 Click **File - Browse**, and then select the file you want to import.
- 3 Enter the password you set when exporting the file in the **Password** field.
- 4 Press **Next**.
- 5 Select the items you want to import from the selected file, and then press **Next**.
- 6 Check again that the items to be imported are selected, and then click **Settings**.
Selected items are imported.

If you want to select items again, click **Back** and start again from step 5.

Exiting Procedure

Close the browser.

Basic Operations

Workflow till the Completion of Printed Materials

This section describes the workflow till the completion of printed materials.

Create the print data

Create print data using various types of design software and register the data to the RIP software.
See the following when using Epson Edge Print.

 ["How to Use Epson Edge Print" on page 44](#)



Prepare the fabric

See the following for supported fabric.

 ["Supported Fabric" on page 474](#)



Set the fabric and print

 ["Workflow for Proper Printing" on page 49](#)






Fix the ink to the fabric

Use a dryer, steamer, washer, or similar device to fix the ink onto the printed fabric.

Prepare a dryer, steamer, washer, or similar device separately.

Workflow for Proper Printing

This section describes the operations for proper printing by dividing them into the following three parts.

- Operations before starting work
 -  ["Operations Before Starting Work" on page 50](#)
- Print
 -  ["Printing Work" on page 54](#)
- Operations before completing work
 -  ["Work After Printing" on page 102](#)

Basic Operations

Operations Before Starting Work

The workflow before starting the work is as given below.

Inspecting and cleaning before turning on the power

Perform periodic inspections and cleaning before turning on the power.

 ["Inspecting and Cleaning Before Turning On the Power" on page 50](#)

**Checking the exhaust equipment**

Exhaust is required during operation to control the temperature and humidity of the machine. Make sure that the machine is properly ventilated.

**Turning On the Power**

For details on how to turn on the power, see the following.

 ["Turning On the Power" on page 51](#)

**Checking the operating status of the water recycling unit**

Check that cleaning water is flowing from the printer's belt cleaning tank to the water recycling unit.

 ["Checking the Operating Status of the Water Recycling Unit" on page 53](#)

**Inspecting and cleaning after turning on the power**








Perform periodic inspections and cleaning after turning on the power.

 ["Inspecting and Cleaning After Turning On the Power" on page 53](#)

Inspecting and Cleaning Before Turning On the Power

The following areas should be inspected and cleaned before turning on the power.

Basic Operations

Item	Frequency		Reference
	Everyday	Every month	
Around operating parts	✓		 "Inspecting Around the Operating Parts" on page 189
Lint trap	✓		 "Cleaning the Lint Trap" on page 194
Air pressure		✓	 "Inspecting/Adjusting the Air Pressure" on page 197
Tension roller tape		✓	 "Inspecting and Cutting the Tension Roller Tape" on page 199
Mist filter		✓	 "Cleaning the Mist Filter" on page 201
Front cover and maintenance cover		✓	 "Cleaning the Front Cover and Maintenance Cover" on page 203
Inside light		✓	 "Cleaning the Inside Light" on page 205

Checking the Exhaust Equipment

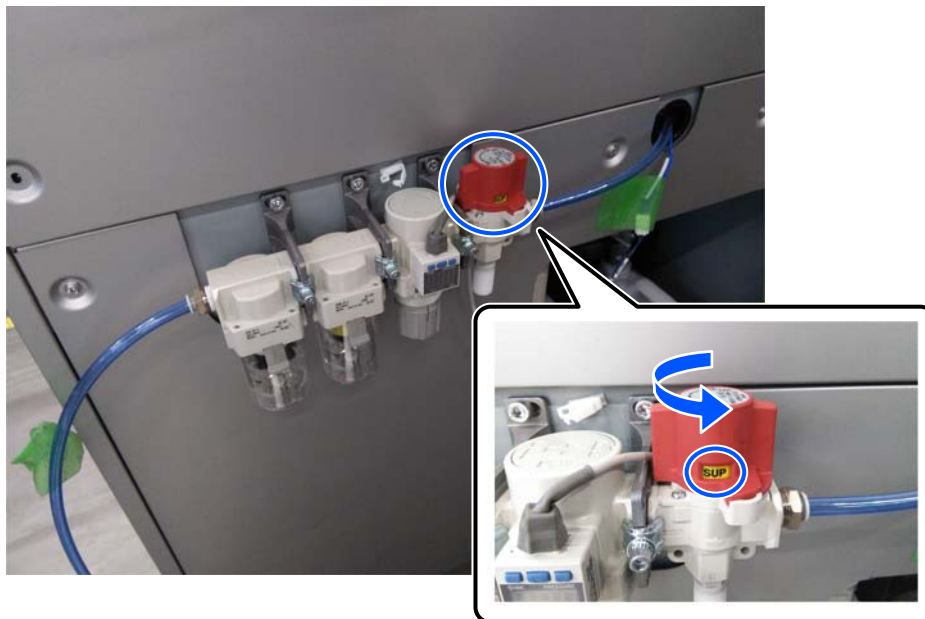
Check if the exhaust is flowing while the machine is running, in order to adjust the temperature and humidity of the machine.

The location and method of checking exhaust ducts will vary depending on the equipment that is used. For details, please check with the factory manager.

Turning On the Power

- 1 Check that the part of the air supply regulator shown in the illustration is labeled "SUP".

If it is not displayed, turn the red valve to change the valve display from "EXH" to "SUP".



Basic Operations

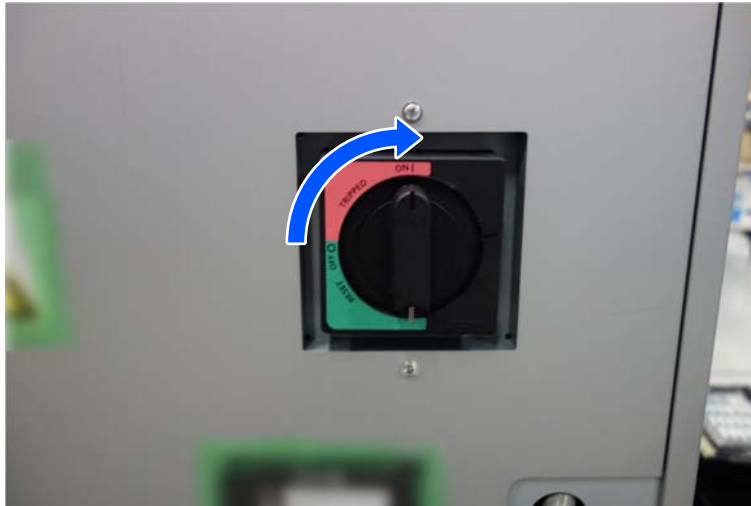
- 2 Check that all emergency stop buttons have been released.
If there is an emergency stop button that has not been released, release it.

[↗ “Emergency Stop Button” on page 28](#)

- 3 Make sure all of the following covers on the printer are closed.

- Front cover
- Left and right maintenance covers
- Rear cover

- 4 Turn ON the main power switch.



- 5 Press and hold the power button on the control panel.
The signal lamp turns green, and the machine starts up.

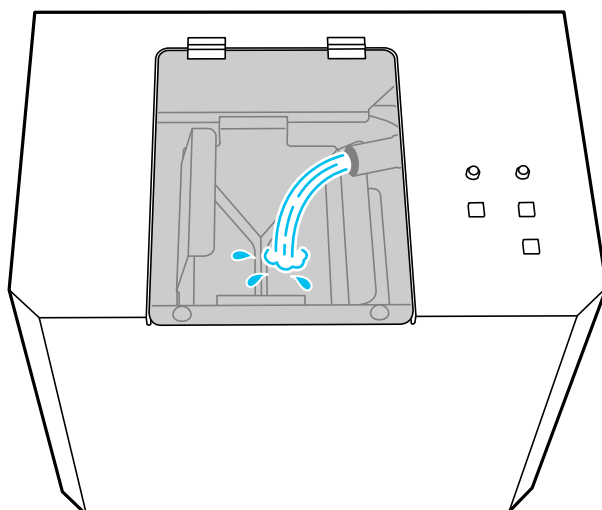


Basic Operations

Checking the Operating Status of the Water Recycling Unit

Look through the maintenance cover to confirm that cleaning water is flowing from the printer's belt cleaning tank to the water recycling unit.

If you cannot confirm that liquid is flowing after five minutes of turning on the printer, a malfunction may have occurred. Contact your dealer or Epson Support.



The water recycling unit periodically detects the ink density in the cleaning water. If the ink density in the cleaning water is high, clean water is supplied to the water recycling unit until the ink density decreases.

Inspecting and Cleaning After Turning On the Power

The following areas should be inspected and cleaned after turning on the power.

Item	Frequency				Reference
	Everyday	Every week	Every month	Once every three months	
Emergency stop device	✓				"Inspecting the Emergency Stop Device" on page 208
Cleaning pad blade		✓			"Cleaning the Cleaning Pad Blades" on page 209
Air supply regulator		✓			"Inspecting/Draining the Air Supply Regulator" on page 211
Suction Cap		✓			"Cleaning the Suction Caps" on page 213
Sensor			✓		"Inspecting/Cleaning the Sensors" on page 216
Water recycling unit				✓	"Cleaning Inside the Water Recycling Unit Tank" on page 218

Basic Operations

Printing Work

The workflow for printing is as given below.

Note:

The printer's heater takes approximately 10 minutes to reach the set temperature. When using the heater for printing, we recommend that you touch **Heated Pressure Roller - Preheat Start** on the home screen of the control panel to start preheating before starting printing.


Inspection before starting printing

Inspect the cleaning pads before starting printing. After inspection, clean or replace parts if necessary.

 ["Inspecting/Cleaning the Cleaning Pad" on page 221](#)

**Checking the Status of the Fabric**

Before installing the fabric roll, make sure that the fabric is not creased, wrinkled, or frayed.

 ["Checking the Status of the Fabric" on page 55](#)

**Installing the fabric roll**

Pass the fabric roll through the feeding spindle and install it in the feeding unit.

 ["Installing the Fabric Roll" on page 56](#)

**Loading the fabric into the printer**

Pull out the fabric end of the installed fabric roll, pass it through the tension roller, and then attach it to the belt.

 ["Loading the Fabric Into the Printer" on page 62](#)

**Setting the fabric floating sensor**

Printing will stop if the Fabric Floating Sensor detects that the fabric is floating or curling beyond the height set here.

 ["Setting the Fabric Wrinkle Detection Sensor" on page 89](#)



Basic Operations

Performing print adjustments

Perform print adjustments in the following cases.

- Using new fabric not registered to the printer
- When banding (horizontal band-shaped patterns, uneven shading, or stripes) or graininess is observed in the print result
- When the fabric type is the same but the width is different

 ["Print Adjustments" on page 155](#)



Setting fabric information

Register the Fabric Information every time you change the fabric type or fabric thickness.

 ["Setting Fabric Information" on page 88](#)



Setting the Print Start Position

Set the print start position on the control panel.

 ["Setting the Print Start Position" on page 90](#)



Printing

Start printing with the print tool.

Before printing, make sure that the heated pressure roller is lowered and the fabric is firmly attached to the belt.

 ["Printing" on page 91](#)

When the fabric is finished or when you want to change to a different fabric while there is still some fabric left, replace or add a new fabric roll.

 ["Replacing the Fabric" on page 92](#)

 ["Adding Fabric" on page 98](#)

Checking the Status of the Fabric

Before setting the fabric, be sure to confirm the following status.

- Fabric end: No creases, wrinkles, or fraying
- Seams: No creases or fraying

If there are creases or wrinkles, straighten out the fabric.



If the fabric is frayed, perform overcasting.

Basic Operations

Installing the Fabric Roll

Pass the fabric roll through the feeding spindle and install it in the feeding unit.

Use a feeding spindle corresponding to the inner diameter of the roll core of the fabric roll on the feeding spindle.

Inner diameter of the roll core	Feeding spindle
75 to 79 mm	3 inch feeding spindle 
50 to 52 mm	2 inch feeding spindle 

Follow the steps below to install the fabric roll on the feeding spindle.

See the following when replacing the fabric roll.

 [“Replacing the Fabric” on page 92](#)

Basic Operations



Caution:

When installing or removing the fabric, be sure to wear safety shoes and make sure that the procedure is performed by at least two people. When lifting the fabric roll, make sure you bend your knees sufficiently and lift in a natural position.

Fabric rolls weigh more than 30 kg (66.14 pounds) and may cause an injury if dropped. Lifting with incorrect posture can lead to injury and/or back pain.

Note:

Depending on the type of fabric used for printing and the nature of the operation, you may need to change the settings for each switch and the printer.

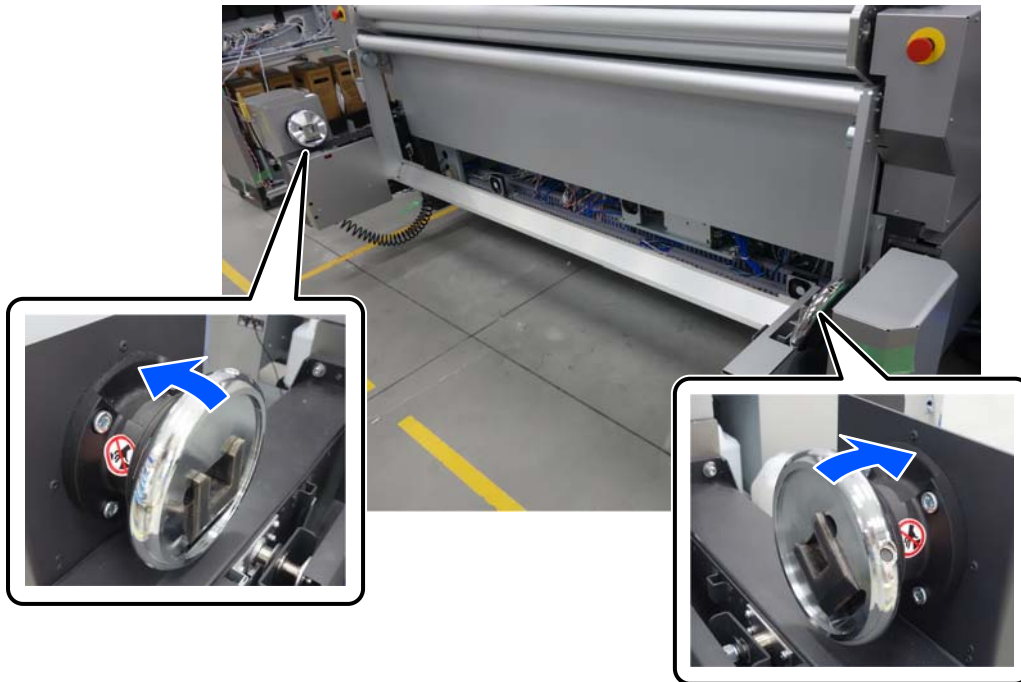
 [“List of Printer Settings by Operation” on page 450](#)

- 1 Make sure that the feeding roller switch on the rear panel is set to Free (center).



Basic Operations

- 2 Push the locks on the left and right sides of the feeding unit toward the outer sides.

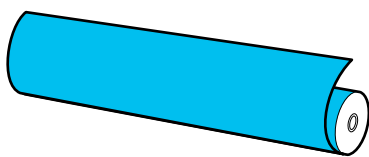


- 3 Place the fabric on the base and insert the feeding spindle into the new fabric roll.

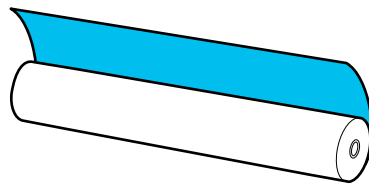
The way the feeding spindle passes through the fabric roll will differ depending on the fabric rolling specifications.

Pass it through the fabric roll so that the air inlet side of the feeding spindle is on the left side, at the back of the printer.

Printable area on the outside of the roll

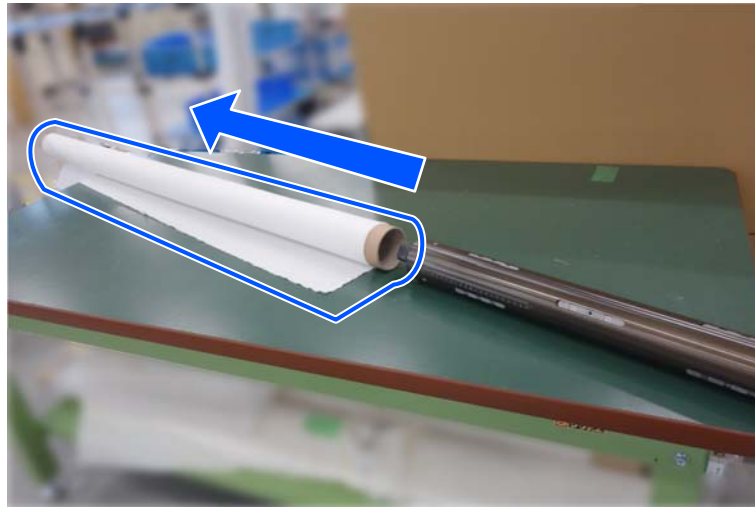


Printable area on the inside of the roll



Basic Operations

The following illustration shows the feeding spindle being passed through the fabric roll with the printing surface rolled outward.



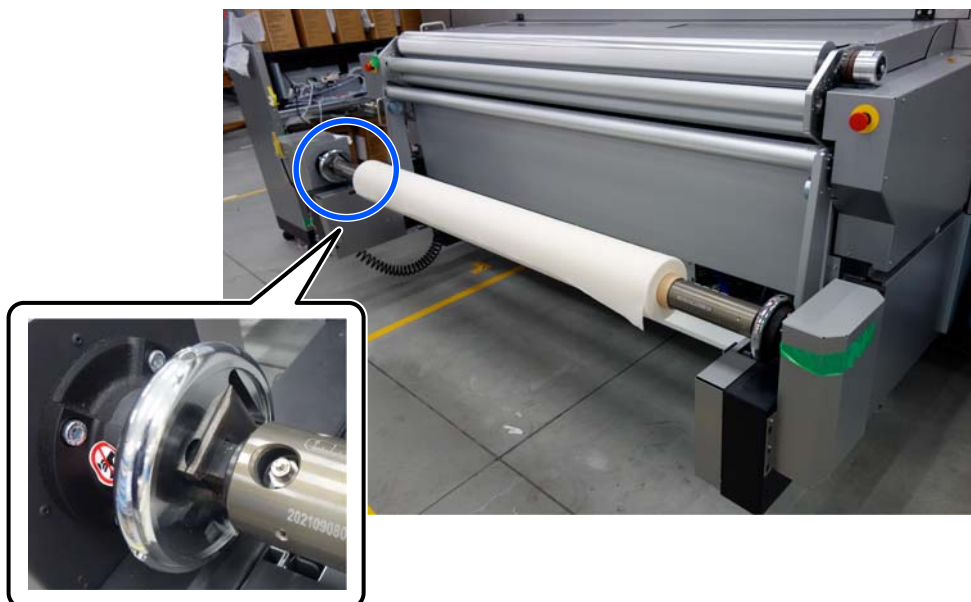
4

Insert the feeding spindle into the feeding unit so that the air inlet side of the spindle is on the left side, at the back of the printer.



Caution:

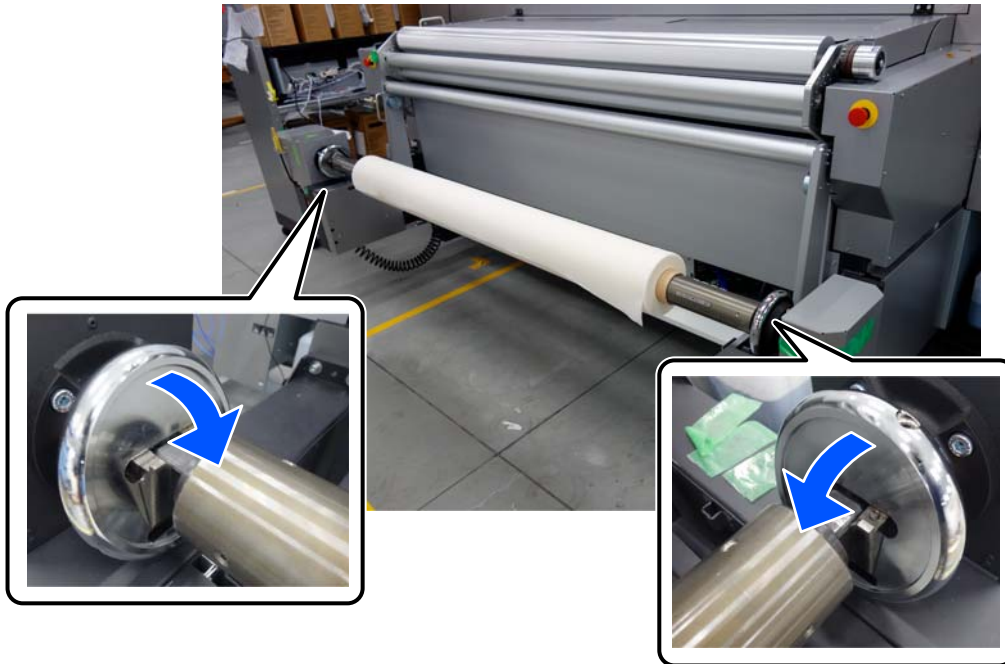
The feeding spindle weighs approximately 15 kg (33.1 pounds). When installing or transporting it, use at least two people. We recommend using a lifter if your fabric weighs more than 40 kg (88.2 pounds).



Basic Operations

- 5** Push the locks on the left and right sides of the feeding unit toward the inner sides.

This fixes the spindle.



- 6** Align the fabric with the machine center.

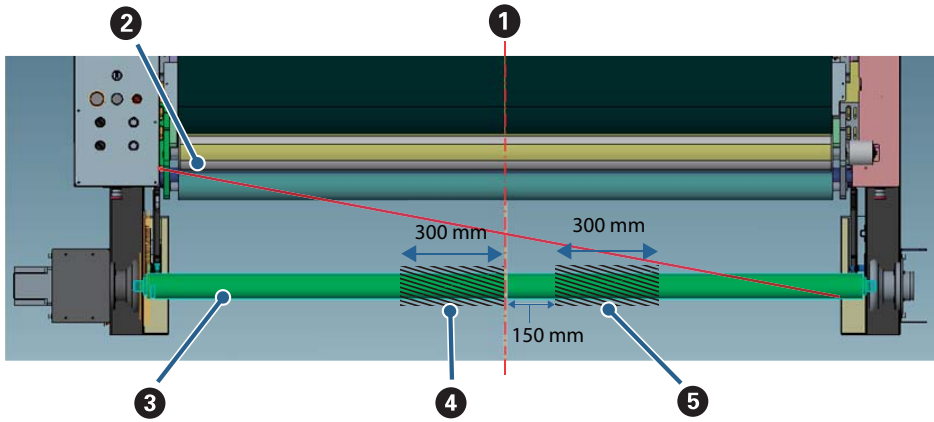


Basic Operations

Note:

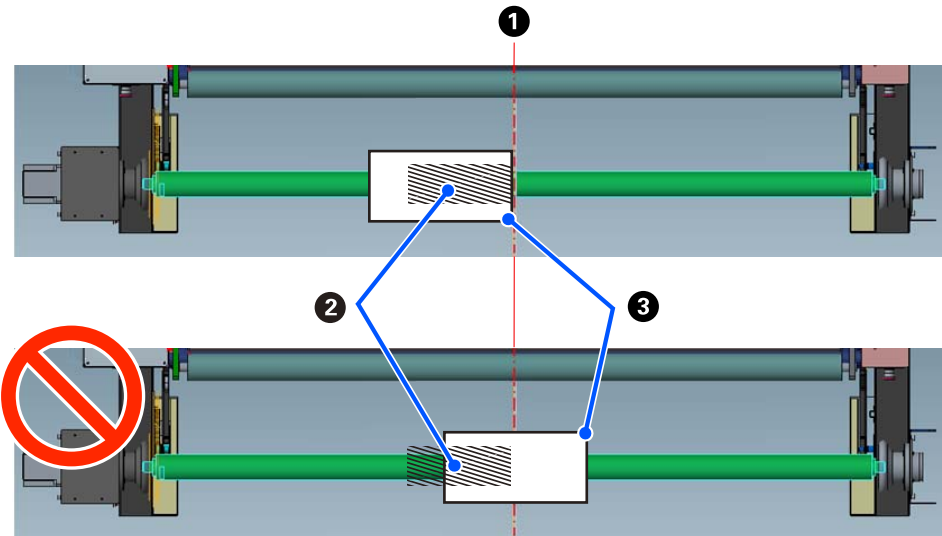
When using fabric without tension (Slack mode) and using a short fabric roll

Place the fabric roll such that it covers the shaded area shown in the illustration below.



- ① Printer center
- ② Sensor
- ③ Feeding spindle
- ④ Placement area when using a fabric roll with the printable area on the inside of the roll
- ⑤ Placement area when using a fabric roll with the printable area on the outside of the roll

<Example of placement when using a fabric roll with the printable area on the inside of the roll>



- ① Printer center
- ② Placement area
- ③ Fabric roll

Basic Operations

7

Insert the air inflating tool into the air inlet on the spindle and inject air.




Once the spindle stopper is inflated and the fabric is secured, remove the air inflating tool.



Loading the Fabric Into the Printer

Pass the fabric through the rollers on the printer and into the dryer or drying reel.

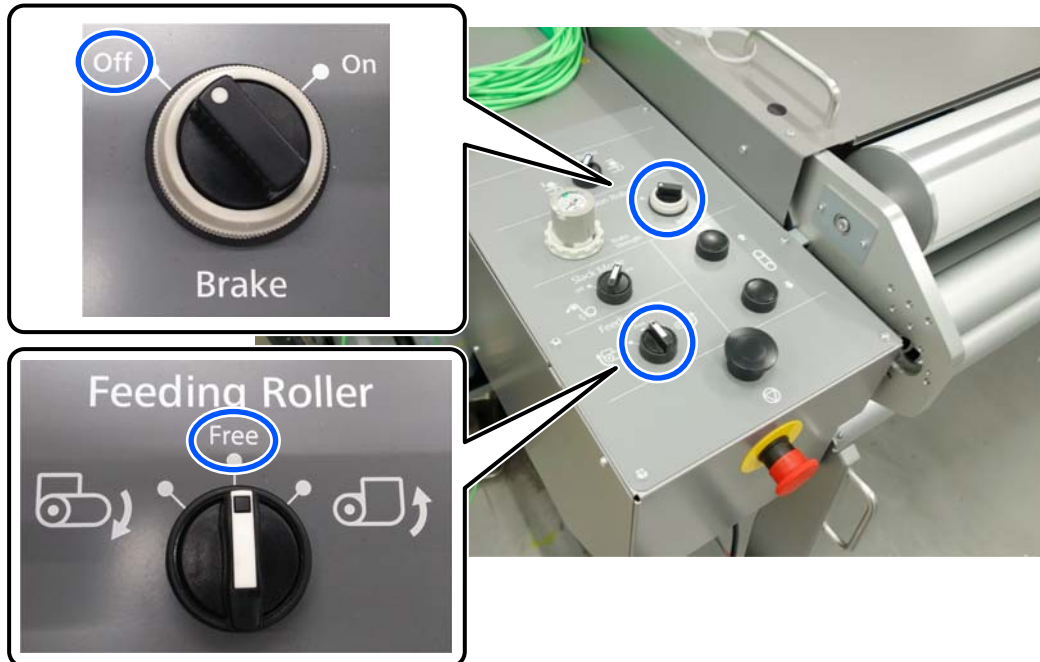
The fabric loading method differs depending on the characteristics of the fabric being printed.

Fabric Characteristics	Fabric Loading Method	Reference
Fabric with a thickness of 1 mm or less, and non-stretchable	Apply tension to the fabric and load it	 "Apply tension to the fabric and load it" on page 63
Fabric with thickness of more than 1 mm, or stretchable fabric	Load the fabric without applying tension	 "Load the fabric without applying tension" on page 74
Fabric that cannot be wound around the rollers (highly rigid, and so on), or cut fabric	Load the fabric without wrapping it around the rollers	 "Load the fabric without wrapping it around the rollers" on page 83

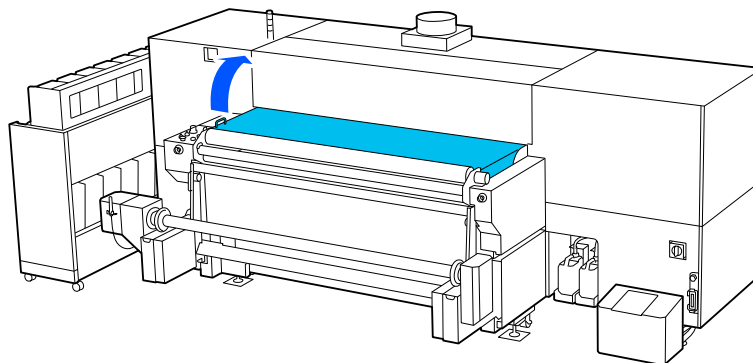
Basic Operations

Apply tension to the fabric and load it

- 1 Make sure that the tension switch on the rear panel is set to Off and the feeding roller switch is set to Free (center).



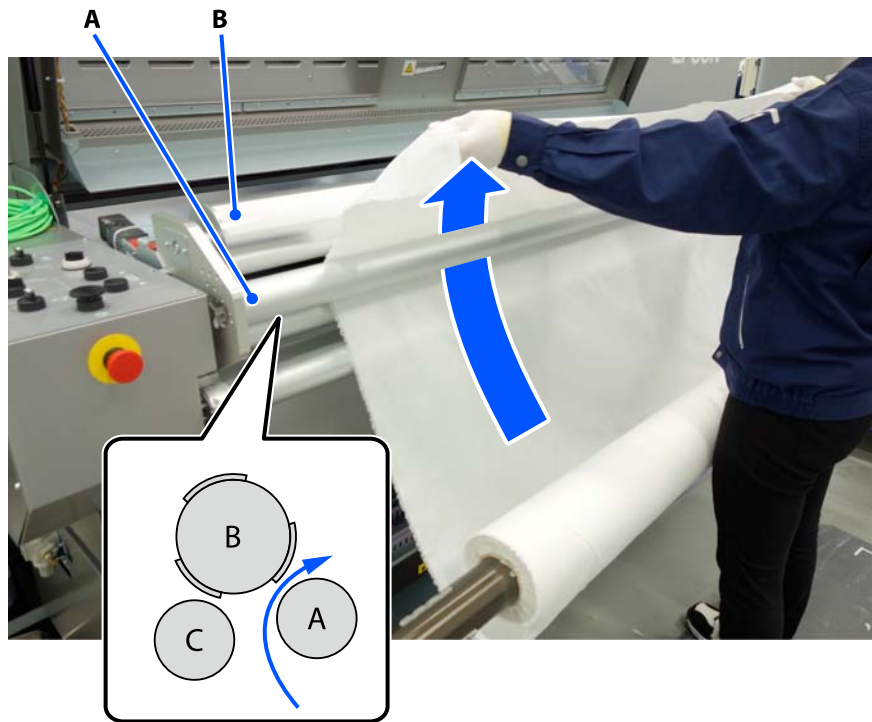
- 2 Open the rear cover.



Basic Operations

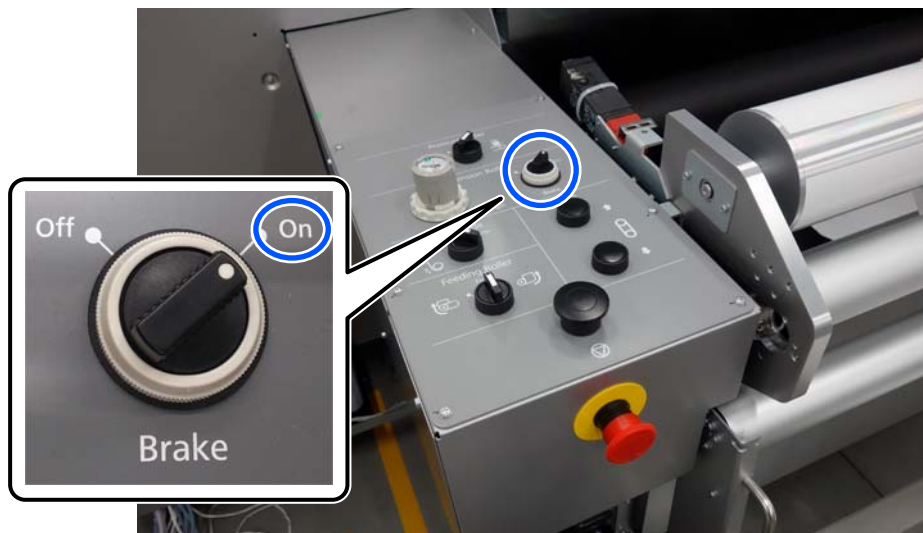
3 Feed the fabric through the rollers.

① Feed between roller A and tension roller B from below.



Note:

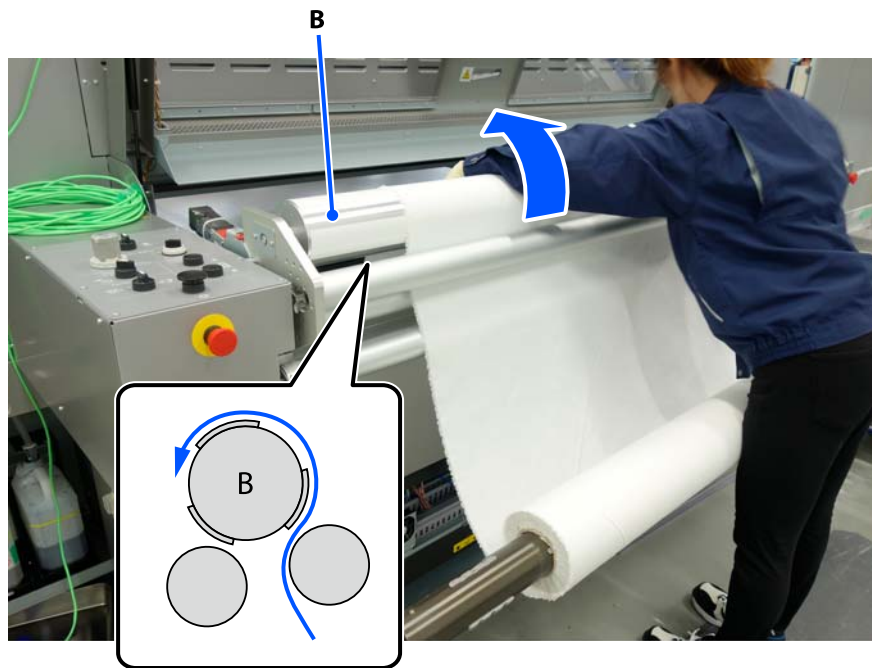
If tension roller B is rotating, making it difficult to load the fabric, set the tension switch to On. The tension roller is locked making it hard for the fabric to come off.



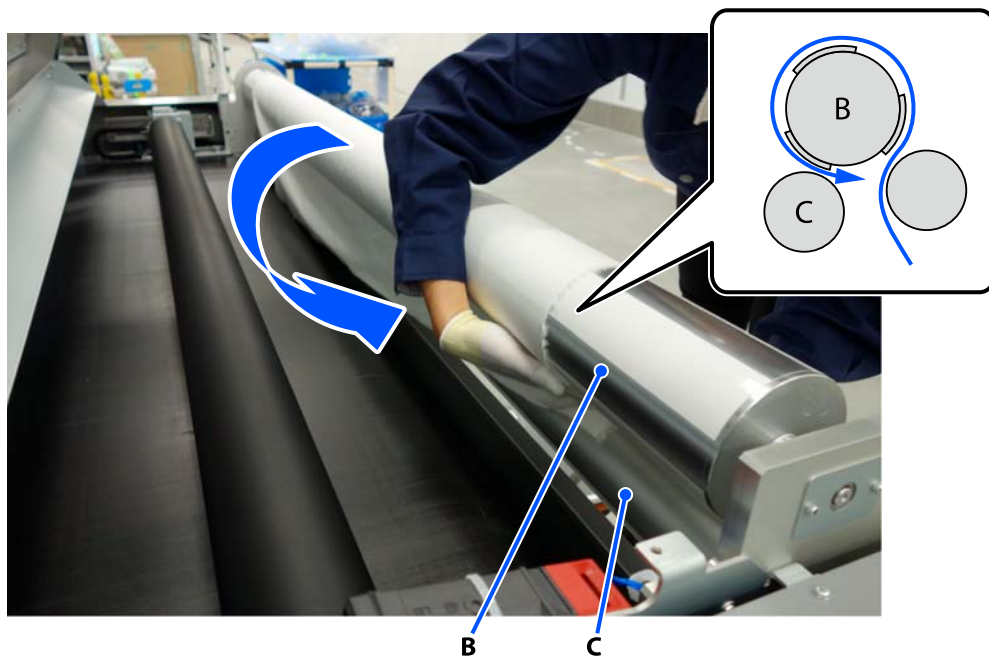
After feeding the fabric through the rollers and checking the condition of the fabric, set the tension roller to Off.

Basic Operations

- ② Feed over tension roller B.

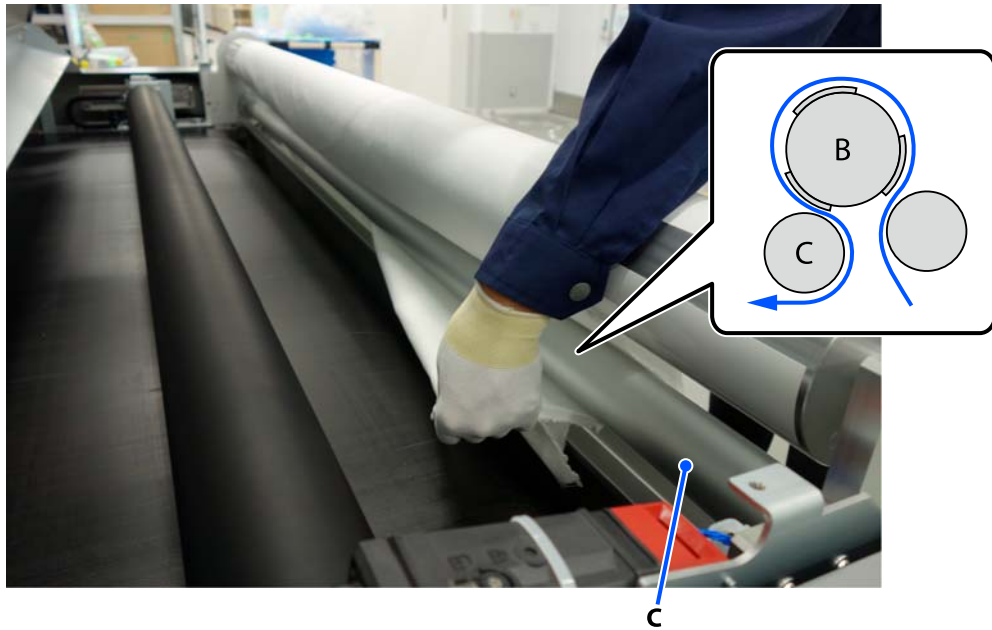


- ③ Feed the fabric between tension roller B and roller C.



Basic Operations

- ④ Feed between roller C and the belt.



- ⑤ Pull it out until it is at the front of heated pressure roller (①).



- 4** Check the following points for the fabric that has been pulled from the fabric roll and passed through the rollers.

- Check that the fabric is pulled straight toward the front of the printer

If the fabric is being pulled out at an angle, adjust it so that it is straight toward the front of the printer.

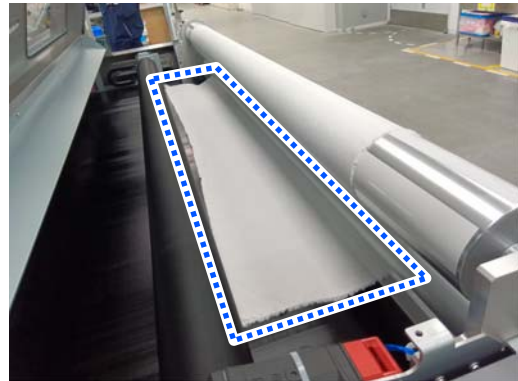
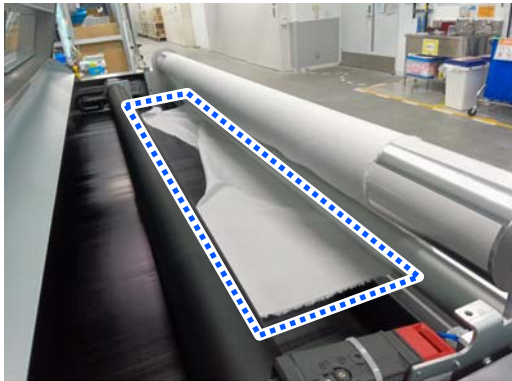
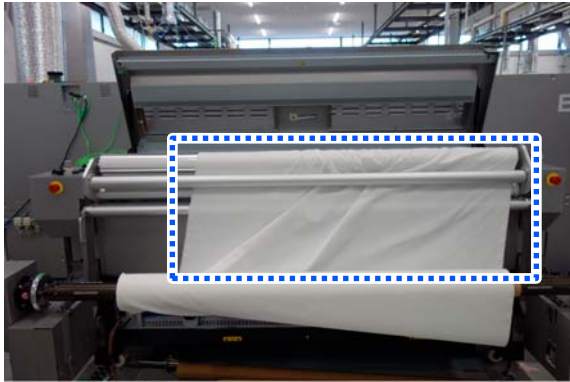
- Check that the tension is uniform

If the fabric tension is not uniform, adjust the fabric tension.

Basic Operations

- ❑ Check that there are no curls or wrinkles

If there are curls or wrinkles, smooth them out.



Note:

When loading a large roll of fabric, the feeding spindle (❶) may rotate, making it difficult to smooth out wrinkles or curls in the fabric.

If wrinkles or curls in the fabric are difficult to smooth out, turn the feeding roller switch to the left or right to lock the feeding spindle.



Basic Operations

- 5 Attach the leading edge of the fabric to the belt by hand. Make sure the fabric does not lift or wrinkle when attaching it to the belt.

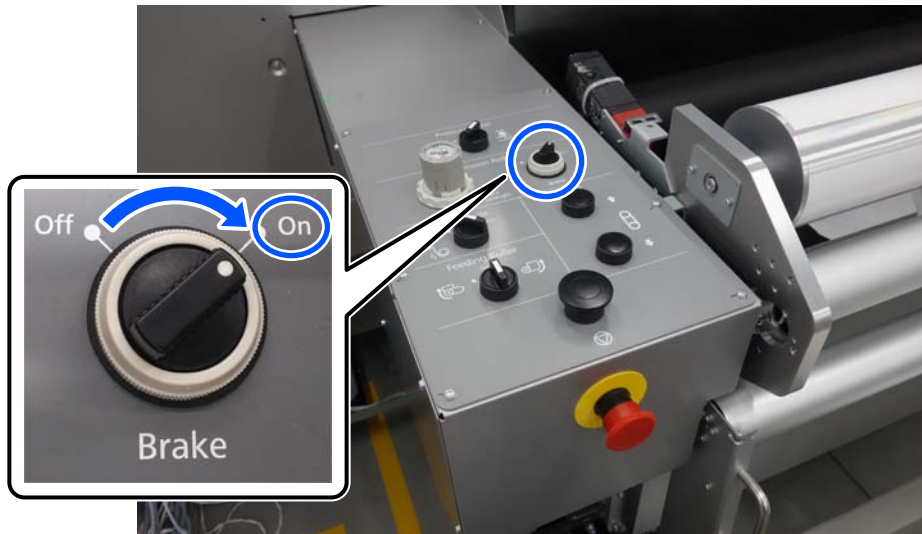


- 6 Rotate tension roller B once toward the front of the printer to loosen the fabric wrapped around the tension roller.



- 7 Set the tension switch to On.
The tension roller is locked, making it hard for the fabric passing through the rollers to come off.

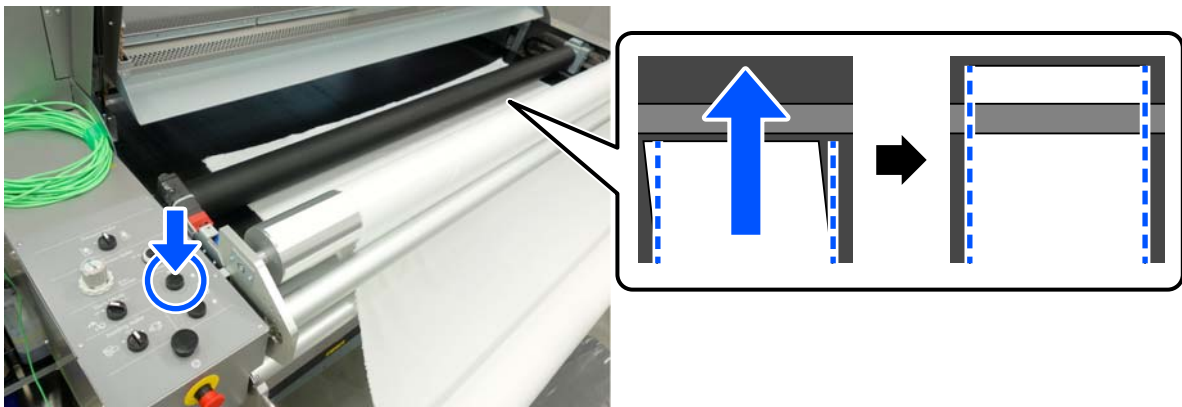
Basic Operations



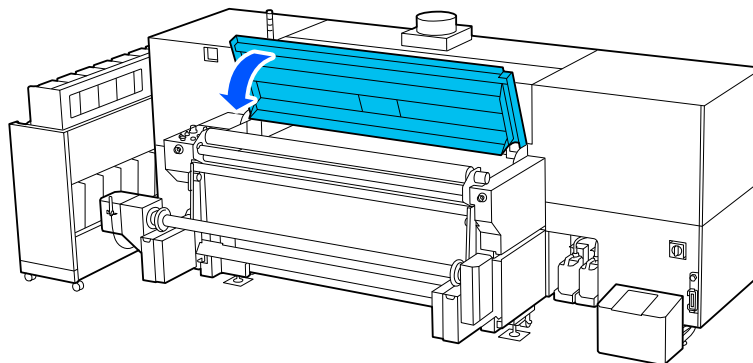
- 8 Press and hold the feed button on the rear panel for several seconds to feed the fabric.

By continuing to feed the fabric with the tension roller locked, you can correct any skew of the fabric until it is straight.

If the fabric is still skewed after completely feeding the loose fabric, continue pressing the feed button until it is straight.



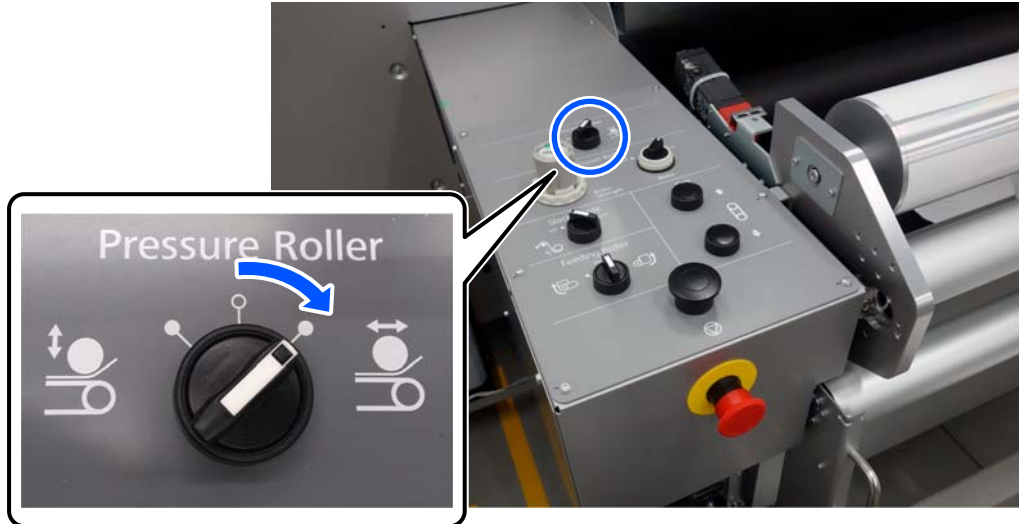
- 9 Close the rear cover.



Basic Operations

- 10 Turn the pressure roller switch to the right.

The heated pressure roller lowers and moves back and forth, applying pressure to the fabric and affixing it to the belt.



- 11 Push down the tension bar.



Note:

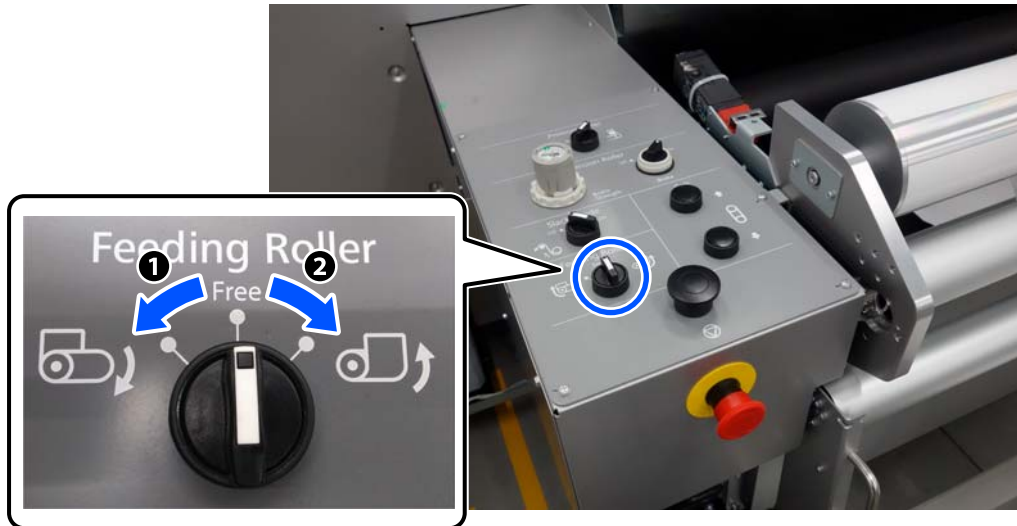
If any excess fabric is pulled out when you lower the tension bar, rotate the feeding spindle to rewind the fabric.



Basic Operations

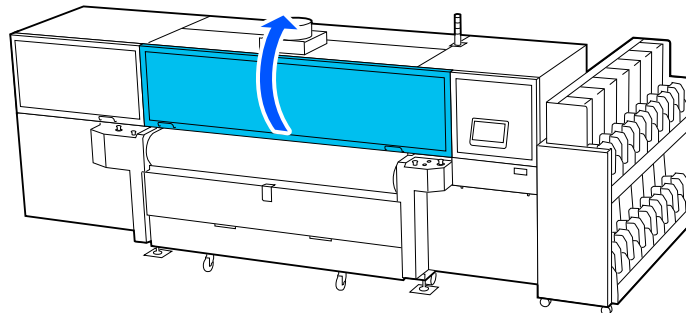
- 12** Set the feeding roller switch on the rear panel to match the print surface.

When printing on the inner side of the fabric roll, rotate in direction **1**.
When printing on the outer side of the fabric roll, rotate in direction **2**.



- 13** From the menu screen on the control panel, set **General Settings - Printer Settings - Feeding Unit** to **On**.

- 14** Go to the front of the printer and open the front cover.



- 15** Press the feed button on the front panel to feed the fabric.

The position for feeding the fabric differs depending on whether you are printing with the fabric attached to a dryer or drying reel.

Basic Operations

Printing with the fabric attached to a dryer or drying reel

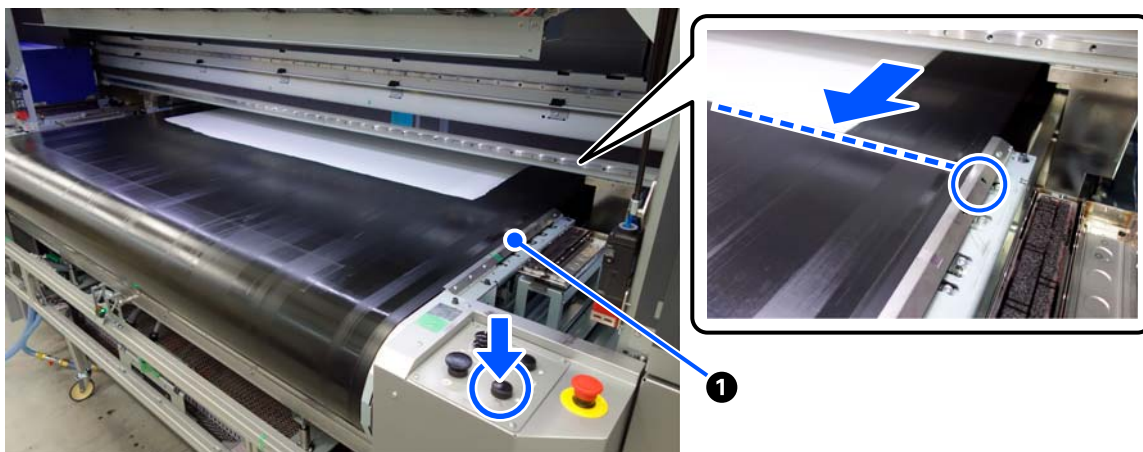
The fabric is fed to a position where it will not get caught in the belt cleaning tank.



Proceed with the following steps.

Printing without the fabric attached to a dryer or drying reel

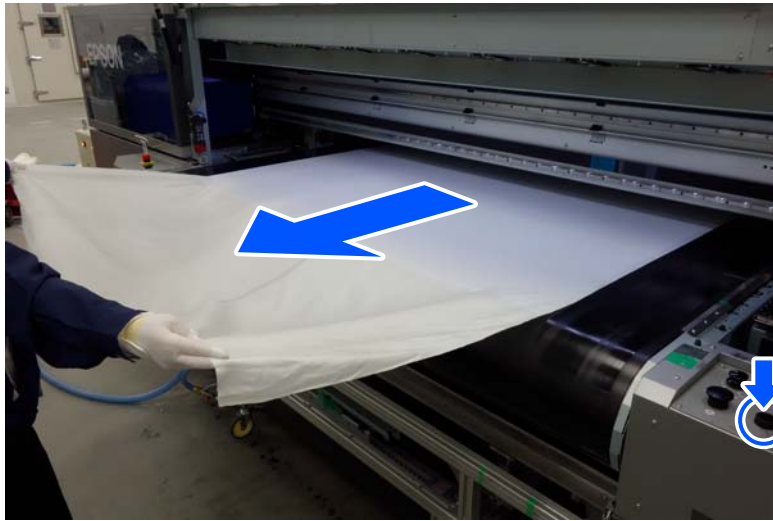
Feed the fabric to the position of the rearmost hole of the guide beside the belt (1) (the print start position).



Go to step 18.

Basic Operations

- 16** While peeling the fabric from the belt, press the feed button. Pull out the fabric until it is long enough to be loaded in the drying unit or reel.



- 17** Load the fabric in the drying unit or reel.

For instructions on using the drying unit or reel, see the manual supplied with the drying unit or reel.

- 18** Close the front cover.

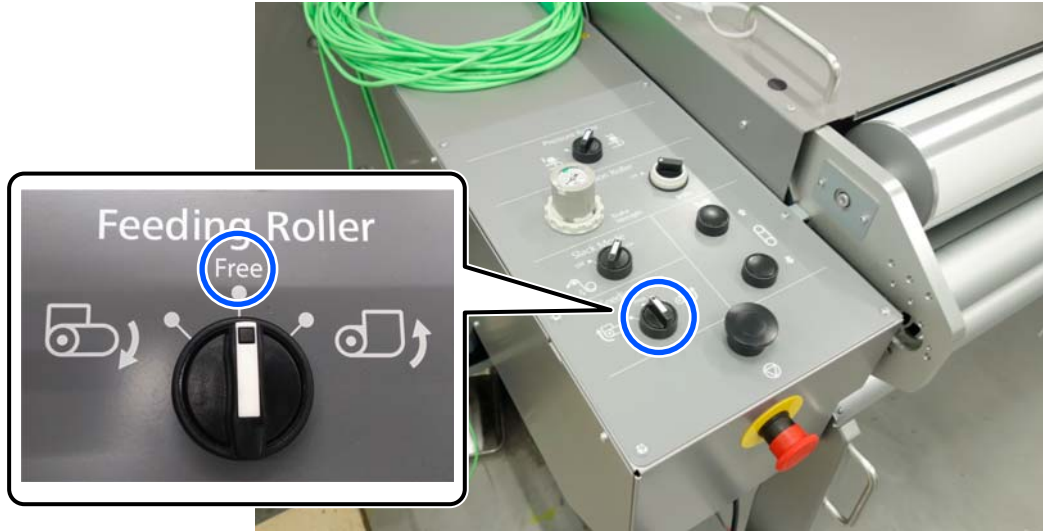


Next, set the fabric information.

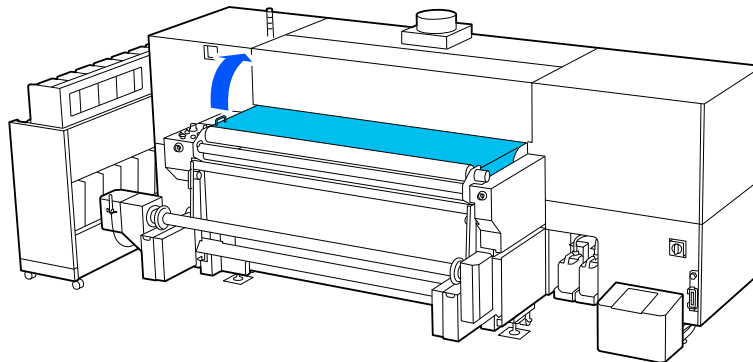
Basic Operations

Load the fabric without applying tension

- 1 Make sure that the feeding roller switch on the rear panel is set to Free (center).



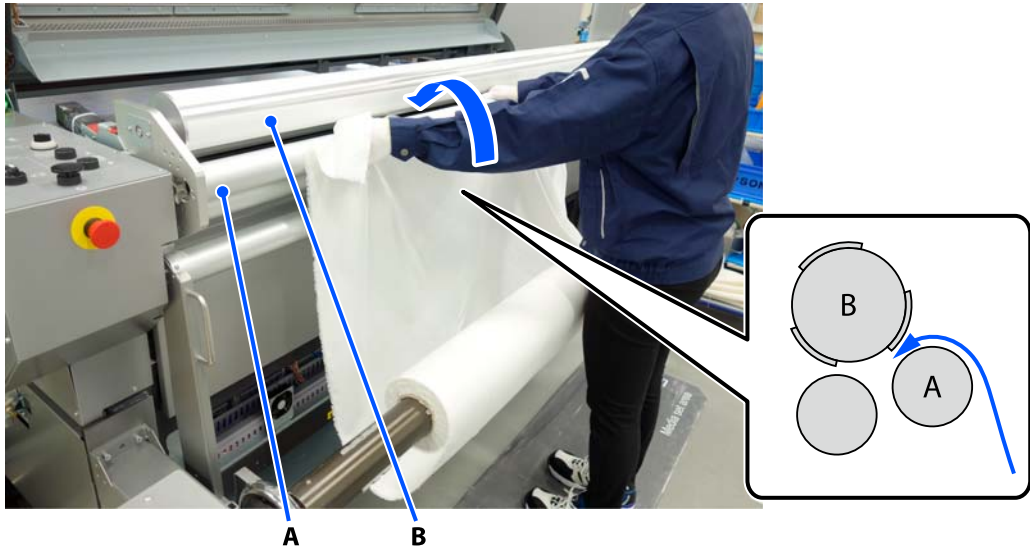
- 2 Open the rear cover.



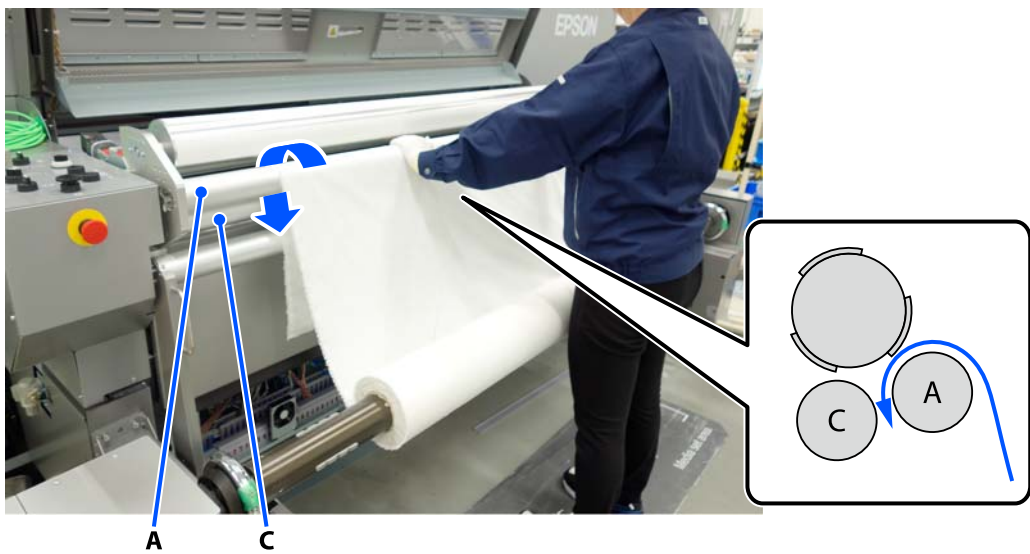
Basic Operations

3 Feed the fabric through the rollers.

- ① Feed between roller A and tension roller B from above.



- ② Feed between roller A and roller C.



Basic Operations

- ③ Feed between roller C and the belt.



- ④ Pull it out until it is at the front of the heated pressure roller (①).

Pull the fabric straight toward the front of the printer to prevent it from skewing.



4

Check the following points for the fabric that has been pulled from the fabric roll and passed through the rollers.

- Check that the fabric is pulled straight toward the front of the printer

If the fabric is being pulled out at an angle, adjust it so that it is straight toward the front of the printer.

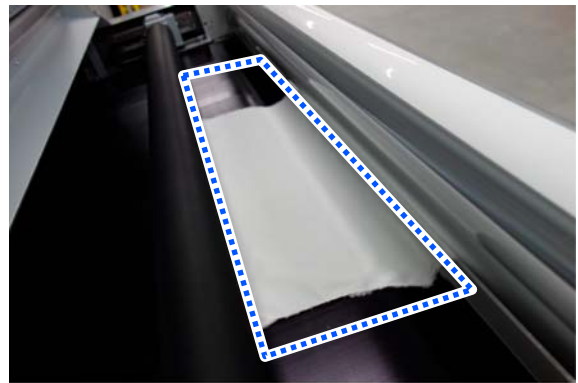
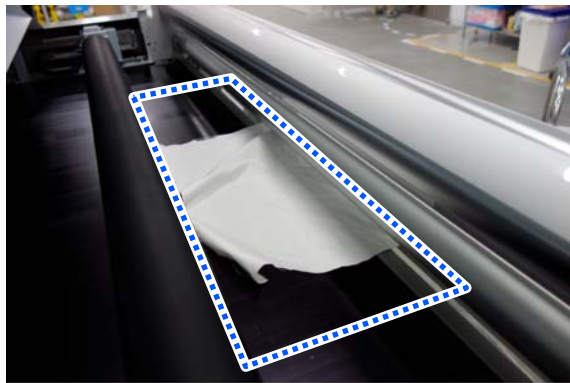
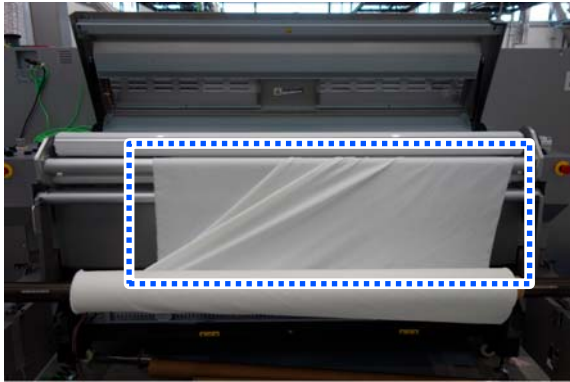
- Check that the tension is uniform

If the fabric tension is not uniform, adjust the fabric tension.

Basic Operations

- ❑ Check that there are no curls or wrinkles

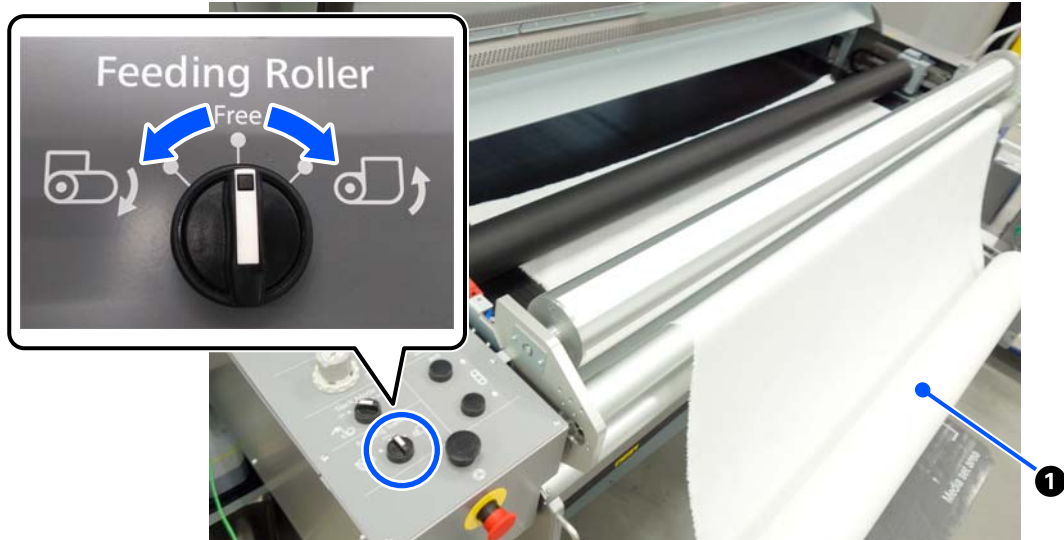
If there are curls or wrinkles, smooth them out.



Note:

When loading a large roll of fabric, the feeding spindle (❶) may rotate, making it difficult to smooth out wrinkles or curls in the fabric.

If wrinkles or curls in the fabric are difficult to smooth out, turn the feeding roller switch to the left or right to lock the feeding spindle.

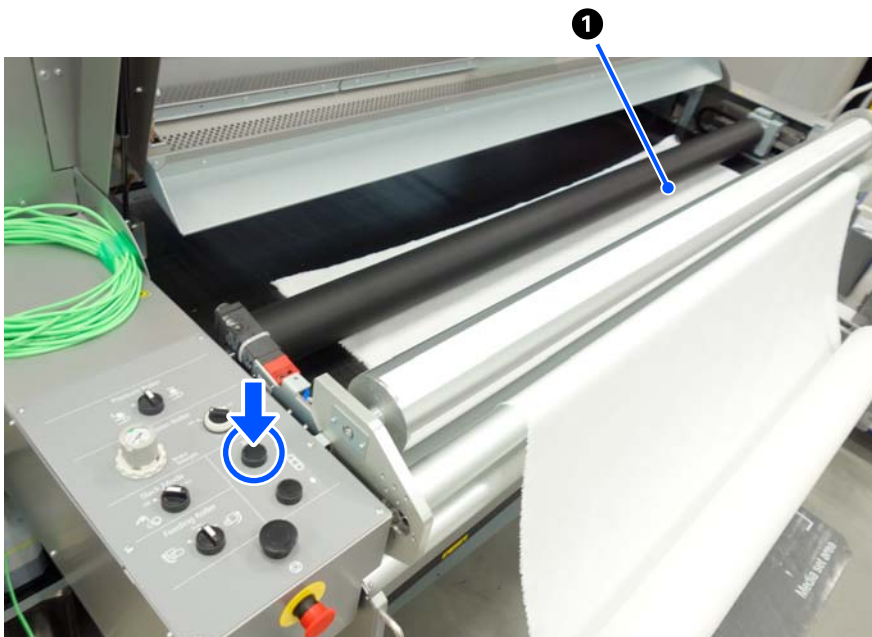


Basic Operations

- 5 Attach the leading edge of the fabric to the belt by hand.
Make sure the fabric does not lift or wrinkle when attaching it to the belt.

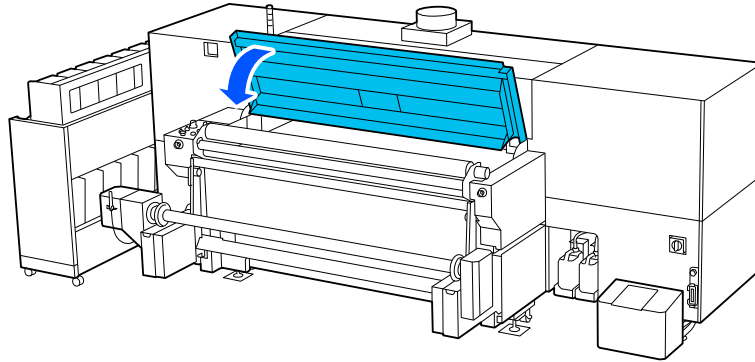


- 6 Press the feed button on the rear panel to feed the fabric until its leading edge passes under the heated pressure roller (1).



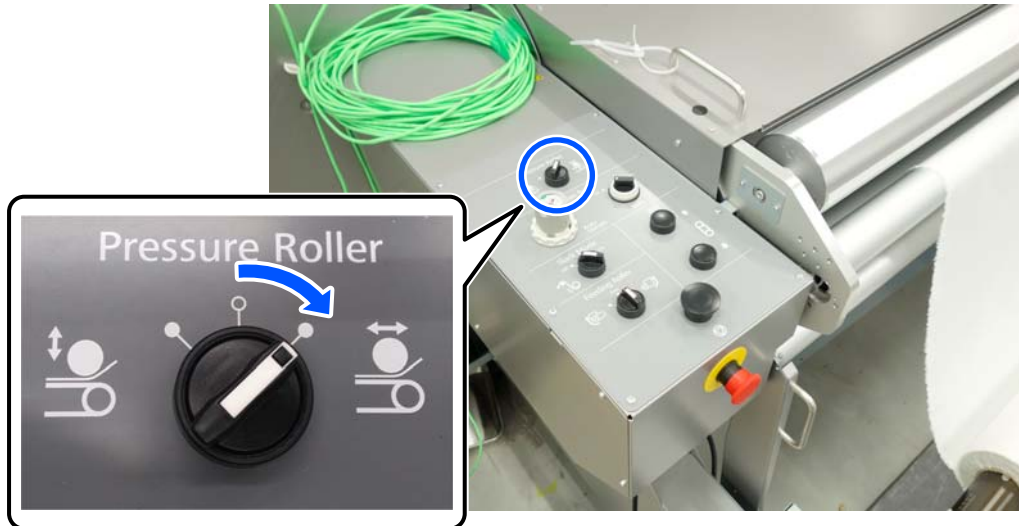
Basic Operations

- 7 Close the rear cover.

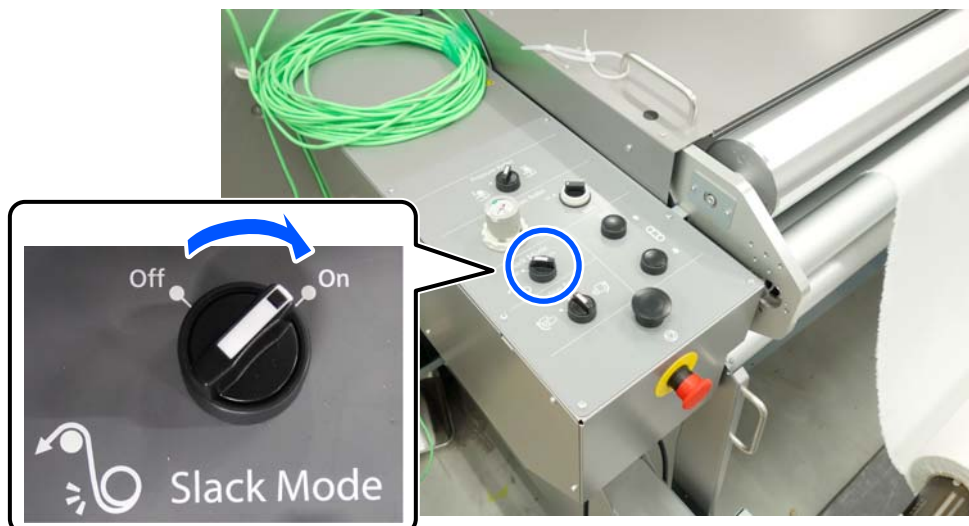


- 8 Turn the pressure roller switch to the right.

The heated pressure roller lowers and moves back and forth, applying pressure to the fabric and affixing it to the belt.

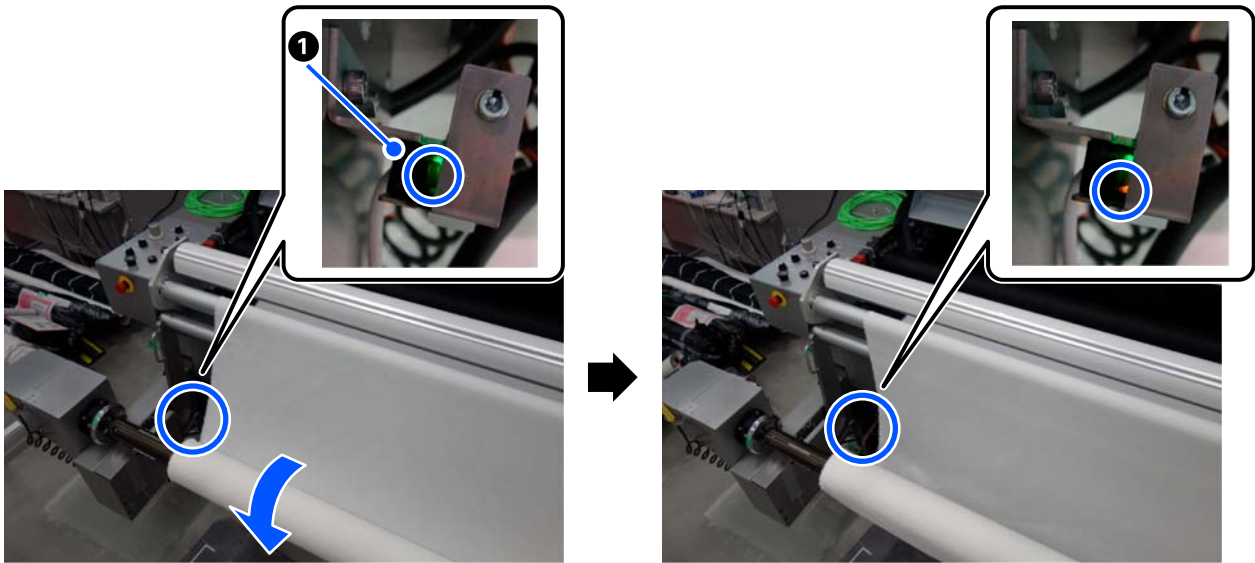


- 9 Set the slack detection switch to On.



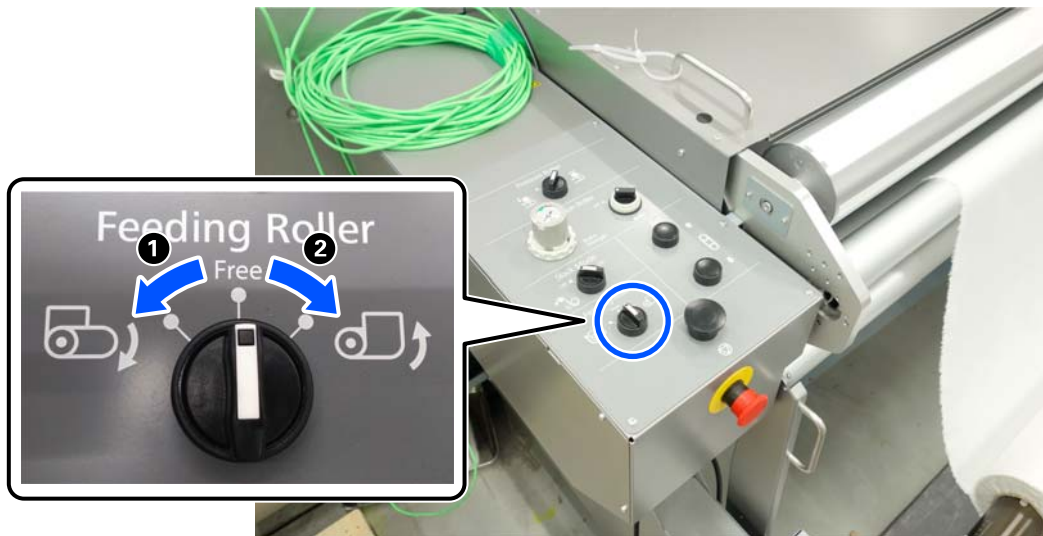
Basic Operations

- 10** Rotate the feeding spindle by hand to pull out the fabric and let it go slack until the orange light at the top of the slack detection sensor (1) turns on.



- 11** Set the feeding roller switch on the rear panel to match the print surface.

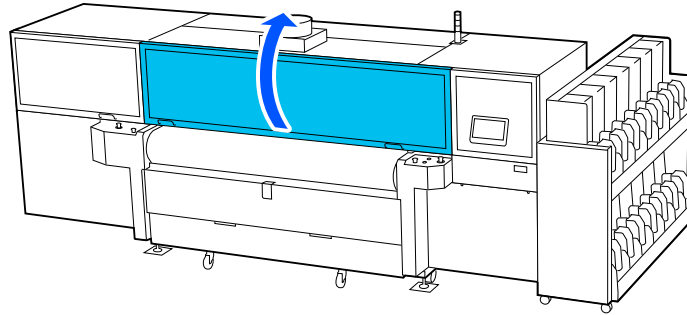
When printing on the inner side of the fabric roll, rotate in direction 1.
 When printing on the outer side of the fabric roll, rotate in direction 2.



- 12** From the menu screen on the control panel, set **General Settings - Printer Settings - Feeding Unit** to **On**.

Basic Operations

- 13** Go to the front of the printer and open the front cover.

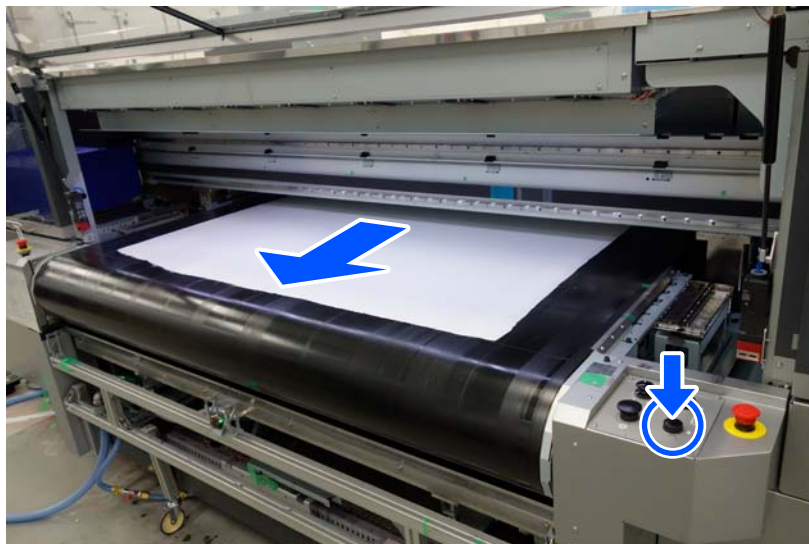


- 14** Press the feed button on the front panel to feed the fabric.

The position for feeding the fabric differs depending on whether you are printing with the fabric attached to a dryer or drying reel.

Printing with the fabric attached to a dryer or drying reel

The fabric is fed to a position where it will not get caught in the belt cleaning tank.

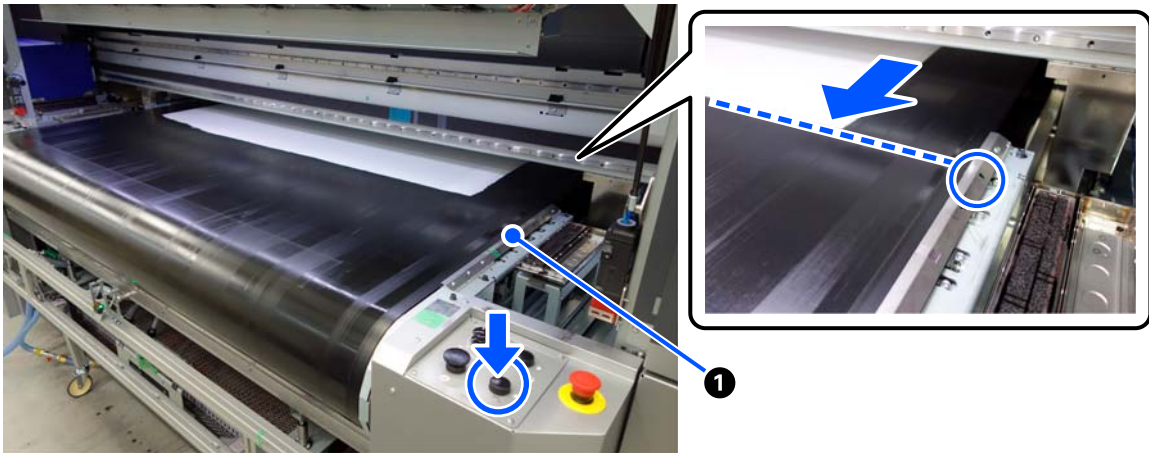


Proceed with the following steps.

Basic Operations

Printing without the fabric attached to a dryer or drying reel

Feed the fabric to the position of the rearmost hole of the guide beside the belt (❶) (the print start position).



Go to step 17.

- 15** While peeling the fabric from the belt, press the feed button. Pull out the fabric until it is long enough to be loaded in the drying unit or reel.



- 16** Load the fabric in the drying unit or reel.

For instructions on using the drying unit or reel, see the manual supplied with the drying unit or reel.

Basic Operations

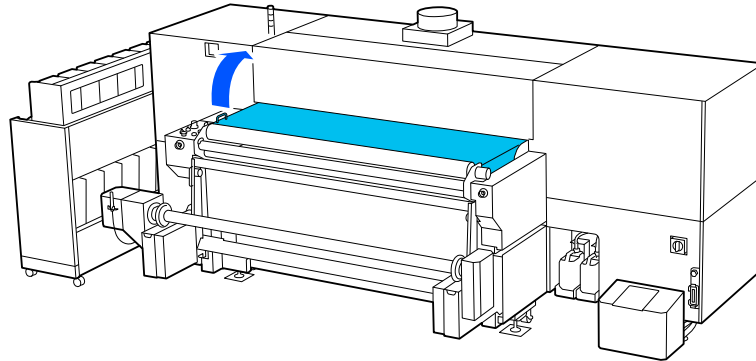
- 17 Close the front cover.



Next, set the fabric information.

Load the fabric without wrapping it around the rollers

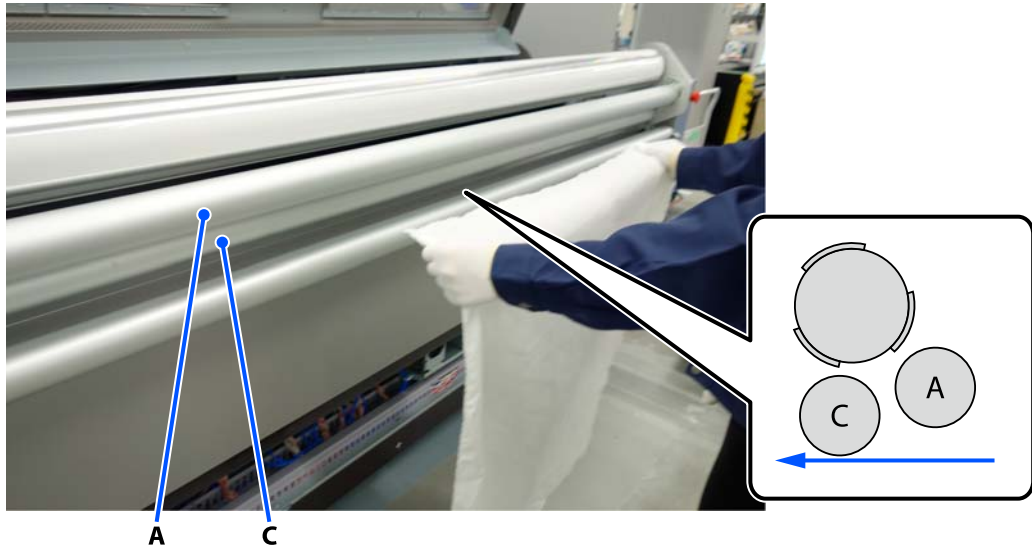
- 1 Open the rear cover.



Basic Operations

2 Pull the fabric out to the front of the heated pressure roller.

① Feed under rollers A and C.



② Pull the fabric out to the front of the heated pressure roller (①).

Pull the fabric straight toward the front of the printer to prevent it from skewing.



3 Check the following points for the loaded fabric.

Check that the fabric is loaded straight toward the front of the printer

If the fabric is being pulled out at an angle, adjust it so that it is straight toward the front of the printer.

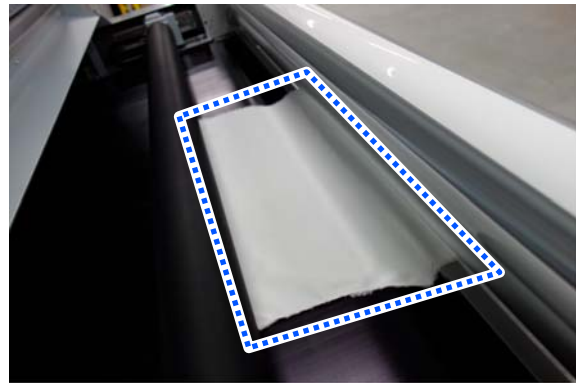
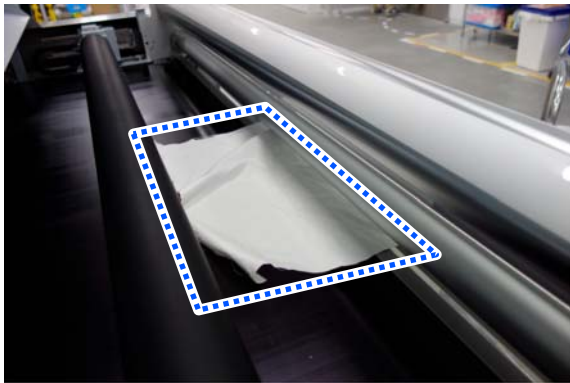
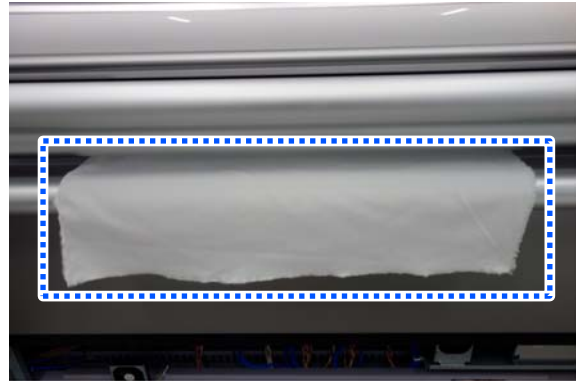
Check that the tension is uniform

Basic Operations

If the fabric tension is not uniform, adjust the fabric tension.

- ❑ Check that there are no curls or wrinkles

If there are curls or wrinkles, smooth them out.



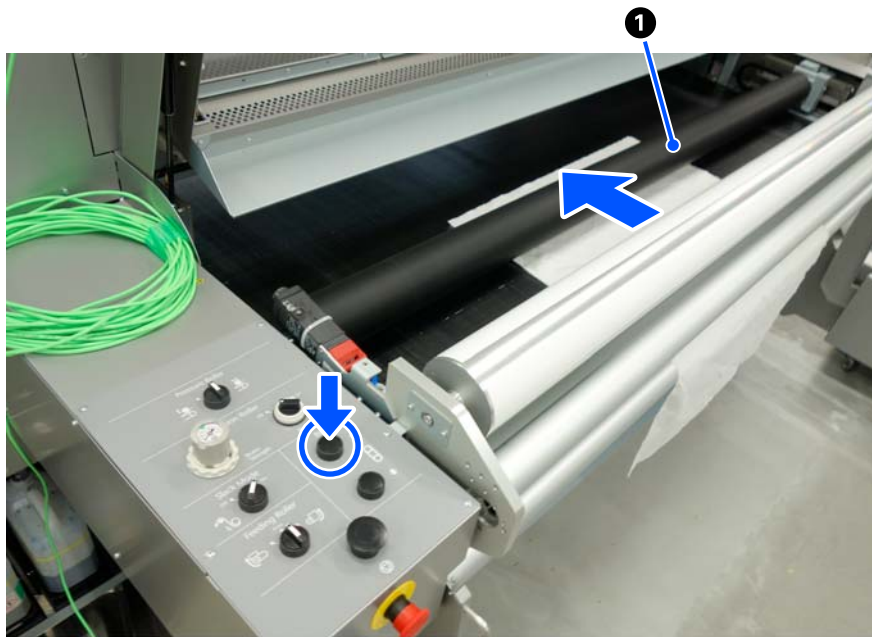
4

Attach the leading edge of the fabric to the belt by hand. Make sure the fabric does not lift or wrinkle when attaching it to the belt.

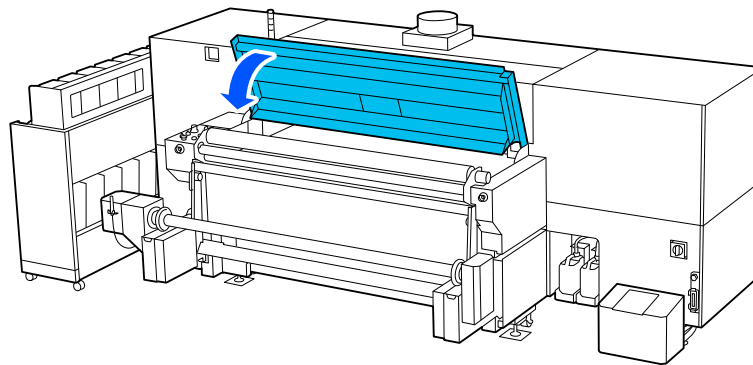


Basic Operations

- 5 Press the feed button on the rear panel to feed the fabric until its leading edge passes under the heated pressure roller (1).



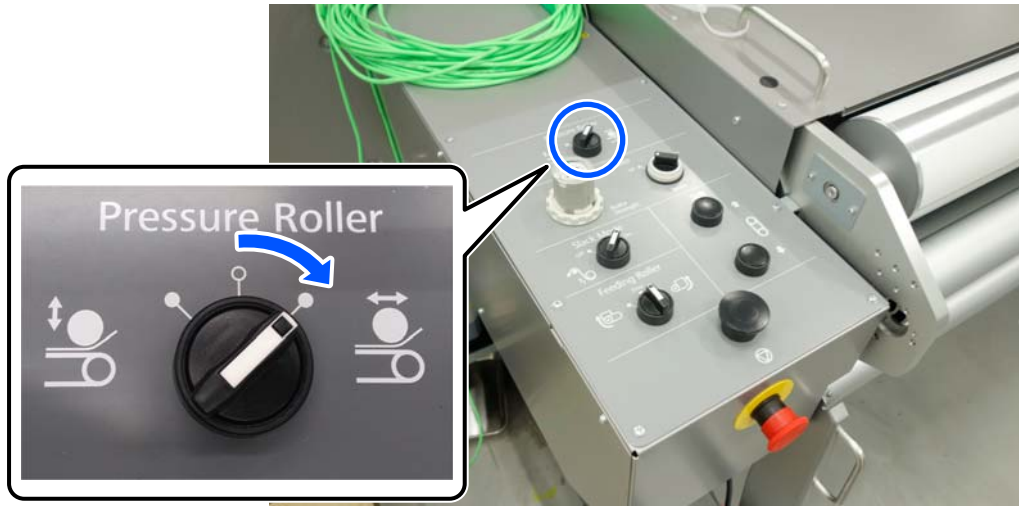
- 6 Close the rear cover.



Basic Operations

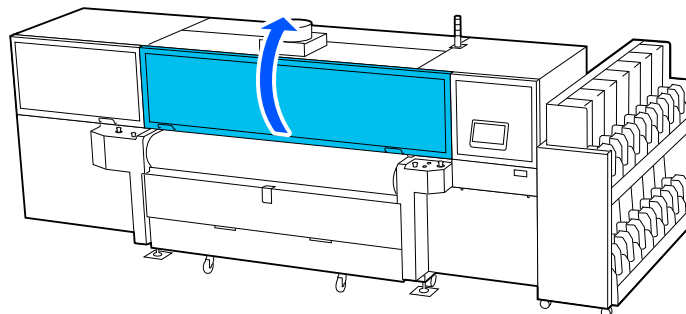
- 7 Turn the pressure roller switch to the right.

The heated pressure roller lowers and moves back and forth, applying pressure to the fabric and affixing it to the belt.

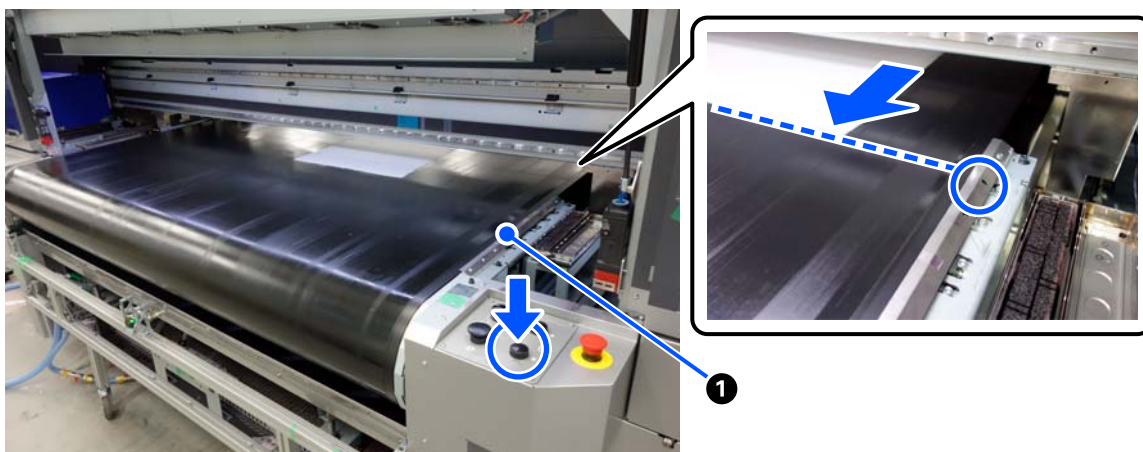


- 8 From the menu screen on the control panel, set **General Settings - Printer Settings - Feeding Unit** to **Off**.

- 9 Go to the front of the printer and open the front cover.

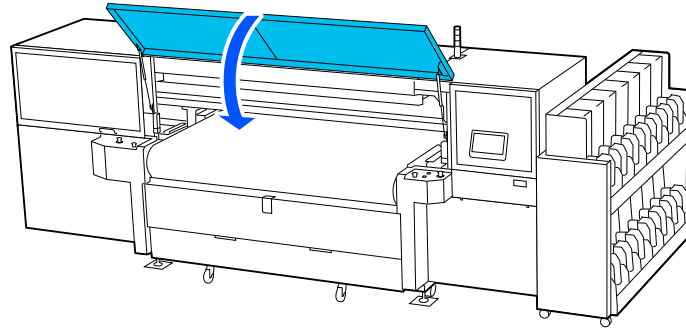


- 10 Press the feed button on the front panel to feed the fabric to the position of the rearmost hole of the guide beside the belt (1) (the print start position).



Basic Operations

- 11** Close the front cover.



Next, set the fabric information.

Setting Fabric Information

- 1** Touch the fabric information display area on the control panel.

 [“Home Screen” on page 30](#)

Displays the Fabric Settings menu.

- 2** Touch **Fabric Management** and select the desired control number.

 [“Fabric Settings Menu” on page 443](#)

- 3** Enter the information of the fabric that you have used.

Once you enter the information, the height from the belt to the print head is automatically set.



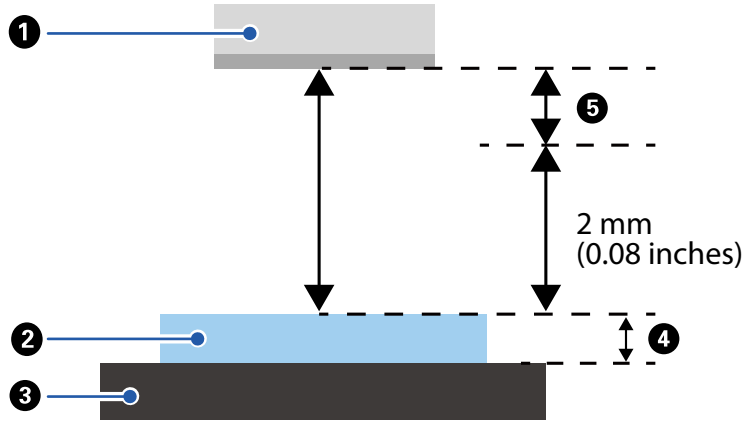
Important:

*Set the **Fabric Thickness** and **Head Height** correctly. If the settings are not configured correctly, printing problems may occur, or the print head may come into contact with the fabric and the print head may malfunction.*

Basic Operations

Fabric Thickness: If the fabric does not have a consistent height, such as for shaggy fabric, enter the average value.

Head Height: We recommend setting 0.7 mm (0.03 inches). A height of 2 mm (0.08 inches) is automatically ensured based on the thickness of the fabric.



- ① Print head
- ② Fabric
- ③ Belt
- ④ Fabric Thickness
- ⑤ Head Height

- 4 Return to the Fabric Settings menu, touch **Current Settings - Fabric**, and then select the control number to which you registered the fabric information.
- 5 Return to the Home screen, and then make sure that the fabric information you selected is displayed in the fabric Information display area.

Setting the Fabric Wrinkle Detection Sensor

The fabric wrinkle detection sensor detects whether the fabric fixed on the belt is floating or flipping over. If it is detected, the print head stops to prevent the print head from colliding with the fabric.



Set the detection position of the fabric wrinkle detection sensor based on the height of the print head from the belt (**Fabric Thickness** set value + 2 mm + **Head Height** set value) set in **Fabric Management**.

This section explains how to set the detection position.

[🔗 “Setting Fabric Information” on page 88](#)

- 1 Touch **Printer Settings** on the control panel and touch **Fabric Floating Sensor - On**.

When you touch **On**, the **Sensor Sensitivity** setting screen is displayed.

- 2 Touch / or touch the area where the numerical value is displayed, enter the numerical value, and set the detection height.

If the **Sensor Sensitivity** is set to 0 mm, detection is performed at the height of the print head from the belt (**Fabric Thickness** set value + 2 mm + **Head Height** set value).

Basic Operations

If you want to detect at a position lower than the print head height, set the value between 0 and -2 mm. If you want detection at a higher position, set it between 0 and + 2 mm.



Important:

If the detection position is set between 0 and -2 mm when the height from the belt to the print head is 2 mm or less, the printer may detect fabric even if there is nothing on the belt.

If the detection position is set between 0 and + 2 mm when the height of the print head is 10 mm or more from the belt, the printer may not detect floating fabric.

3

Touch OK.

Setting the Print Start Position

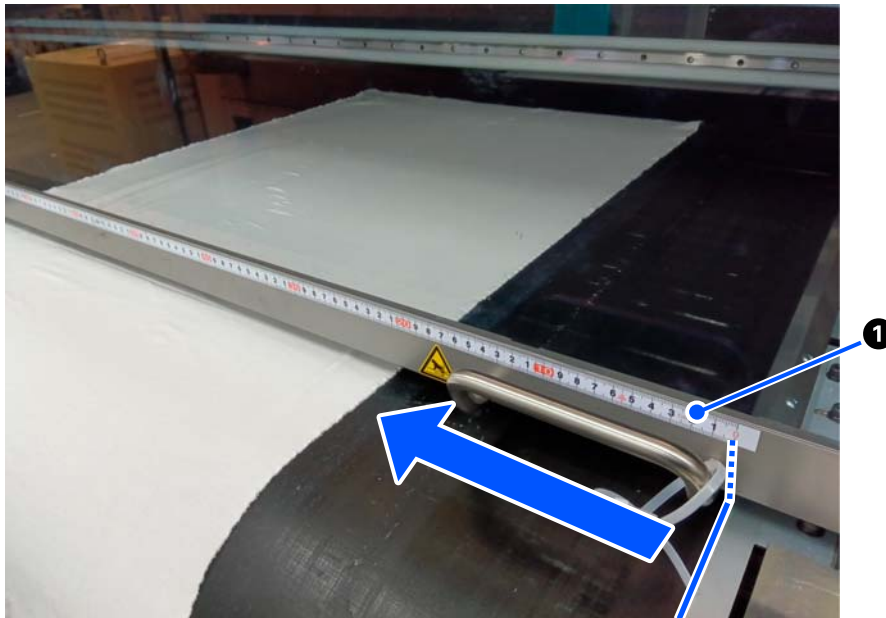
1

Use an item such as a tape measure (①) or ruler to measure any distance from the right edge of the belt (standard position) to the position where you want to start printing.

Note:

The printing position varies depending on how you print on the fabric and how you print the Fabric Edge Nozzle Check pattern, Event Marking, and so on. See the following for more details.

[☞ "Setting the Print Position" on page 125](#)



2

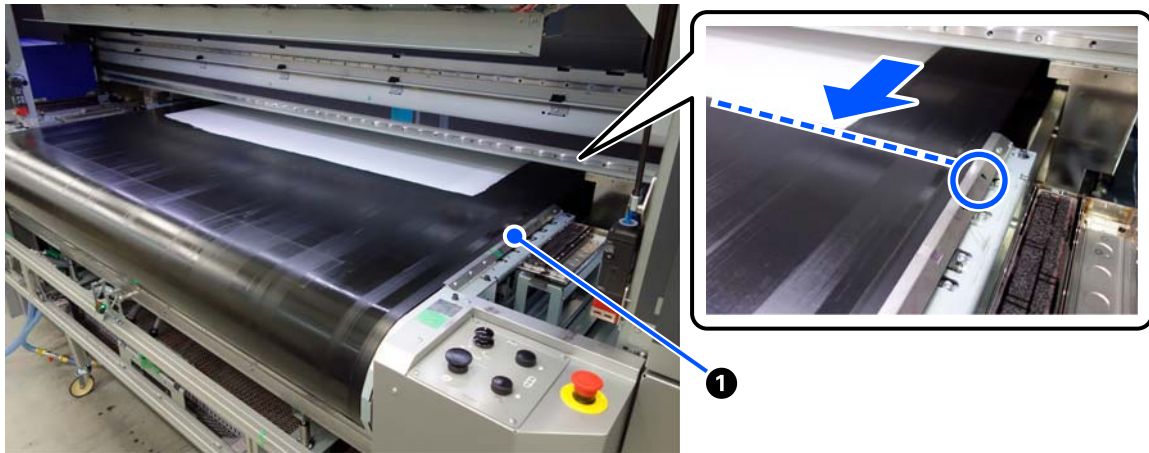
Set the **Print Start Position** on the Home screen on the control panel.

Touching **< / >** allows you to change the values.

Basic Operations

Note:

The approximate print start position in the Y direction is at the rearmost hole of the guide beside the belt. You cannot specify the print start position in the Y direction.



① Print Start Position (Y direction)

Printing

Print using your RIP software or printing application.

See the Epson Edge Print help when using Epson Edge Print.

See the Operation Guide for the Epson Rob file print tool when using Epson Rob file print tool.

! Important:

Before you start printing, make sure the heated pressure roller is lowered and the fabric is firmly attached to the belt. If you start printing while the fabric is raised, the print head could be damaged.

If the fabric is not sticking to the belt, change **Set in Heated Pressure Roller** from the home screen on the control panel to 70°C.

When not using the heated pressure roller, make sure the fabric does not come into contact with the print head.

Note:

- ❑ Depending on the type of media used for printing and the nature of the operation, you need to change the settings for each switch and the settings for the printer.

[☞ “List of Printer Settings by Operation” on page 450](#)

- ❑ If you roll up the print result without drying it, the ink may rub off and smudge. Make sure to dry the print result thoroughly before rolling it.

If you want to change to a different fabric while there is still some fabric left or the fabric is finished, replace or add a new fabric roll.

[☞ “Replacing the Fabric” on page 92](#)

Basic Operations

 [“Adding Fabric” on page 98](#)

If the following sensors are not responding well, or if errors occur even after cleaning off dirt or lifted fabric, adjust the sensitivity of each sensor or reset them.

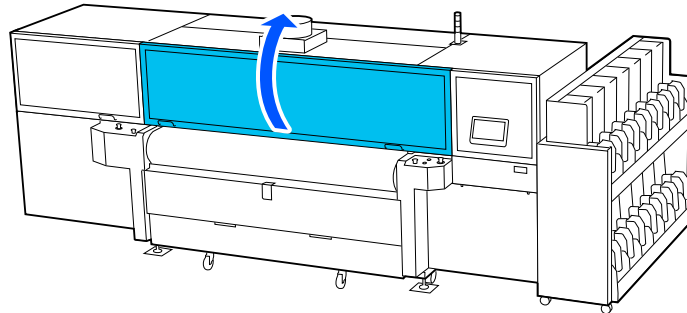
- Slack Detection Sensor
- Roll Diameter Measurement Sensor
- Fabric Floating Sensor
- Tangled Fabric Detection Sensor

 [“Sensor Settings” on page 131](#)

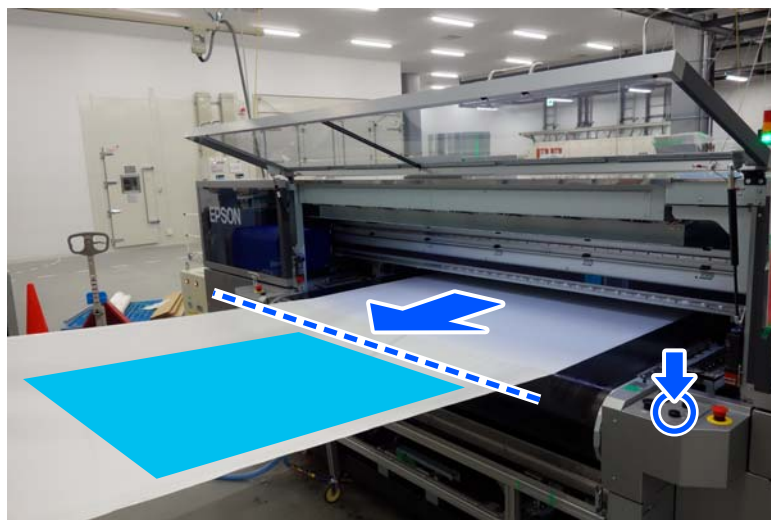
Replacing the Fabric

Replace with new fabric.

- 1** Open the front cover.

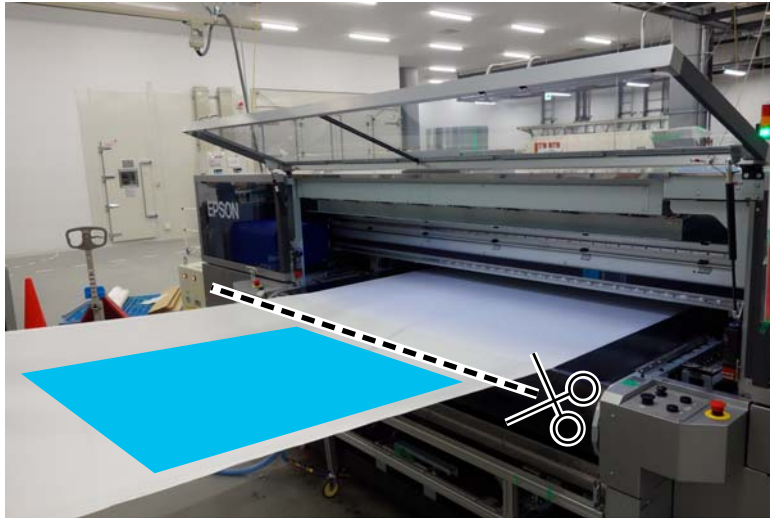


- 2** Press the feed button (forward) on the front panel until the fabric cut position is between the front of the printer and the dryer or drying reel.

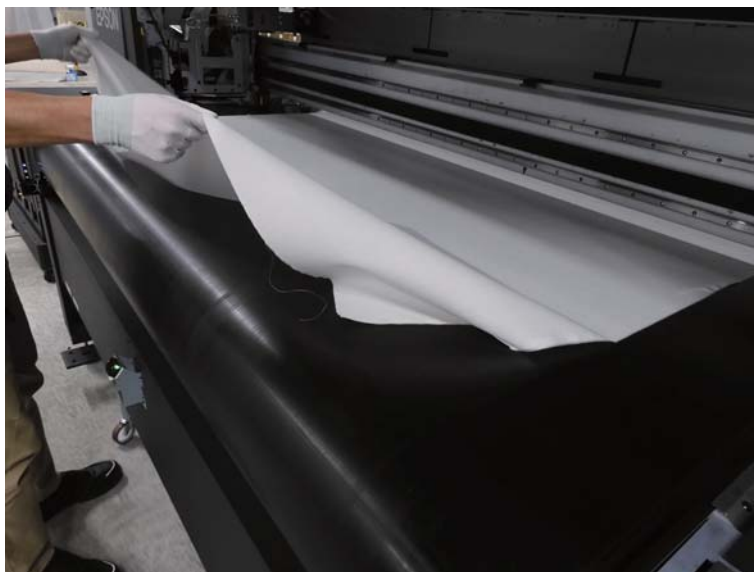


Basic Operations

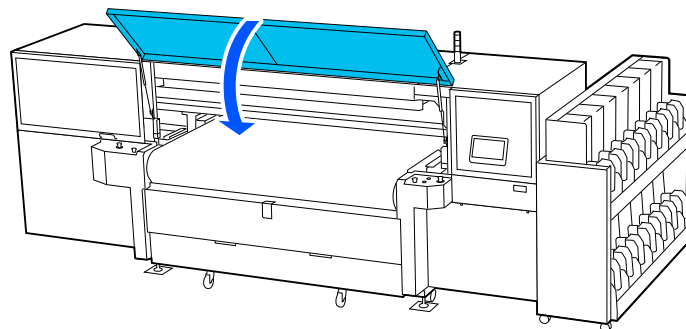
- 3 Cut the fabric using scissors or other such tools.



- 4 Remove the fabric from the belt from the front side.

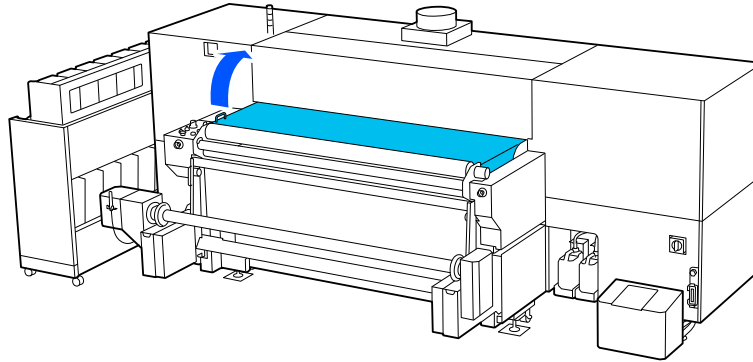


- 5 Close the front cover.



Basic Operations

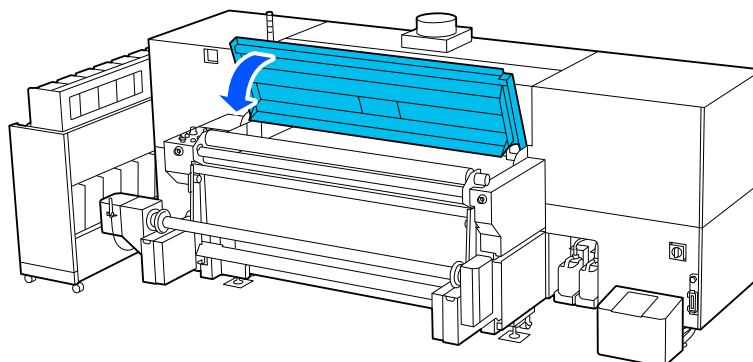
- 6** Move to the rear of the printer and open the rear cover.



- 7** Remove the fabric inside the rear cover from the belt.

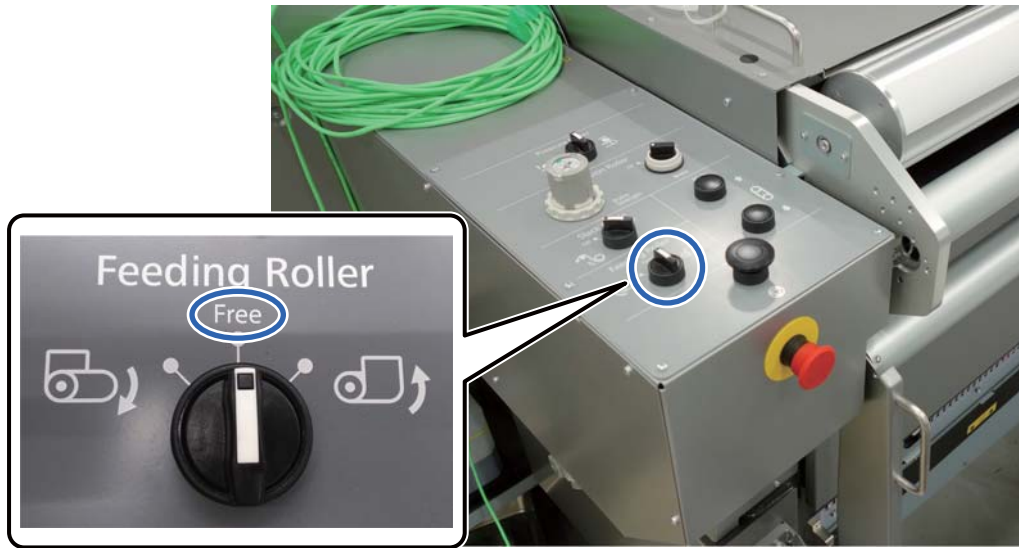


- 8** Close the rear cover.



Basic Operations

- 9 Set the feeding roller switch to Free (center).

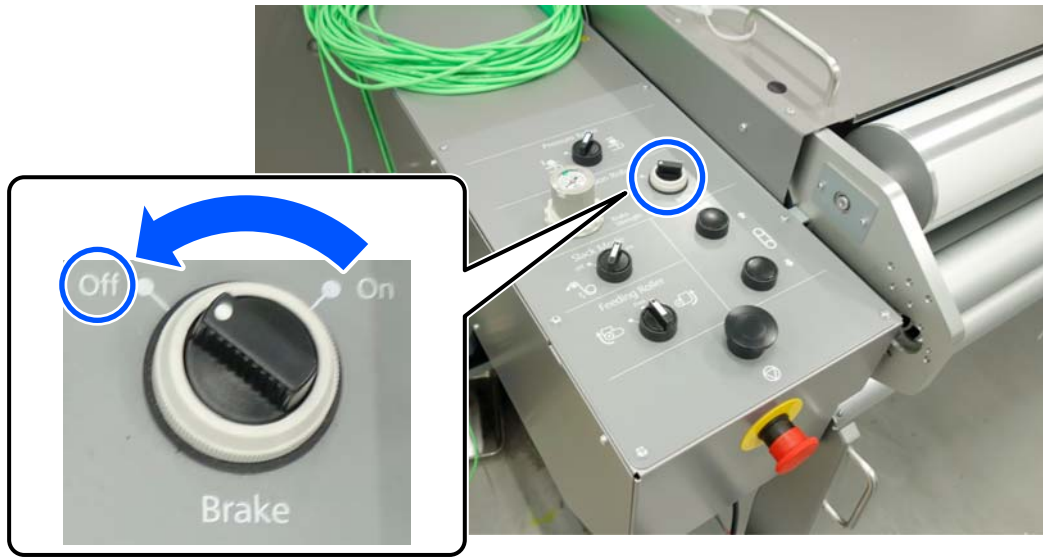


- 10 Lift up the tension bar.



Basic Operations

- 11 Set the tension switch to Off.



- 12 Manually turn the feeding spindle to roll up the fabric.



Basic Operations

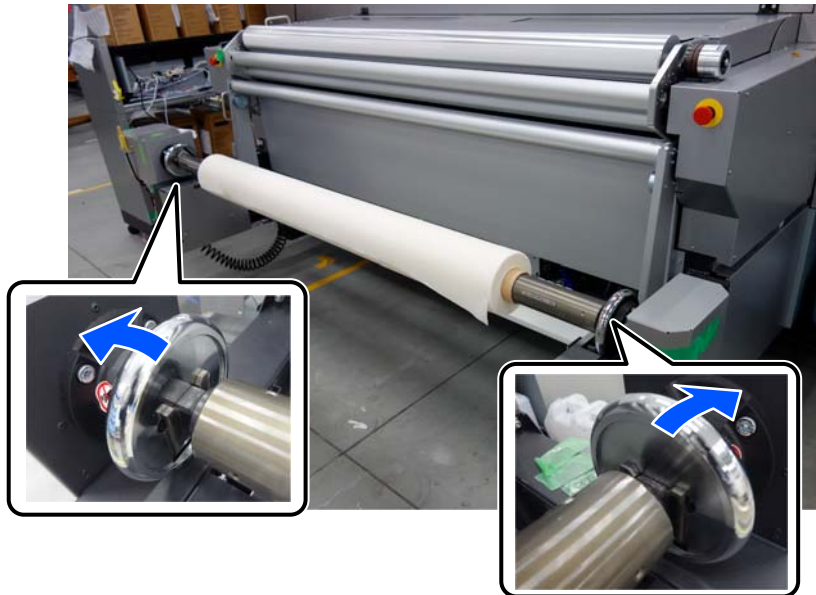
- 13** Press the center of the air inlet to release the air.

This loosens the stopper and creates a gap between the fabric roll core and the spindle.



- 14** Push the locks on the left and right sides of the feeding unit toward the outer sides.

The spindle will be unlocked.



- 15** Remove the feeding spindle.



Caution:

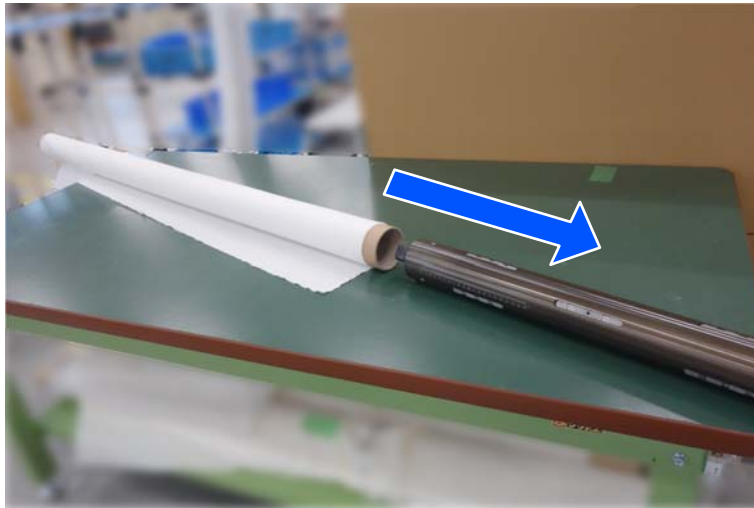
When installing or removing the fabric, be sure to wear safety shoes and make sure that the procedure is performed by at least two people. When lifting the fabric roll, make sure you bend your knees sufficiently and lift in a natural position.

Fabric rolls weigh more than 30 kg (66.14 pounds) and may cause an injury if dropped. Lifting with incorrect posture can lead to injury and/or back pain.

Basic Operations



- 16** Remove the fabric roll from the feeding spindle.



- 17** Install the new fabric in the printer.

[🔗 “Installing the Fabric Roll” on page 56](#)

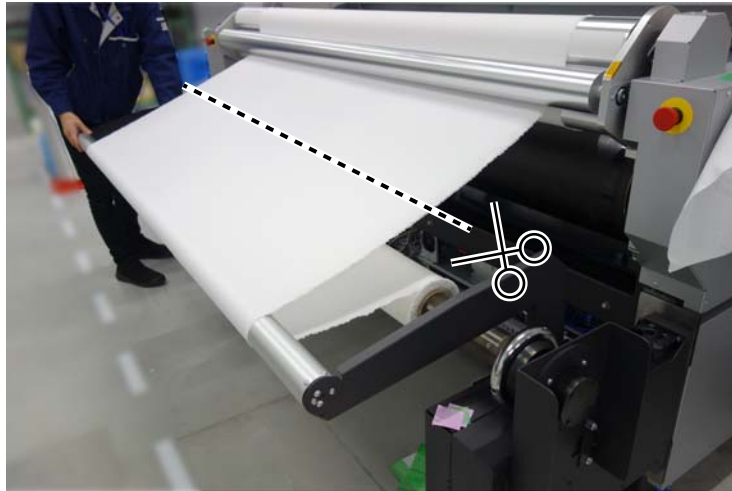
[🔗 “Loading the Fabric Into the Printer” on page 62](#)

Adding Fabric

Use the sewing machine to sew together the fabric being printed and the new fabric.

Basic Operations

- 1 Cut the fabric at the position shown in the illustration using scissors.



- 2 Press the center of the air inlet to release the air.

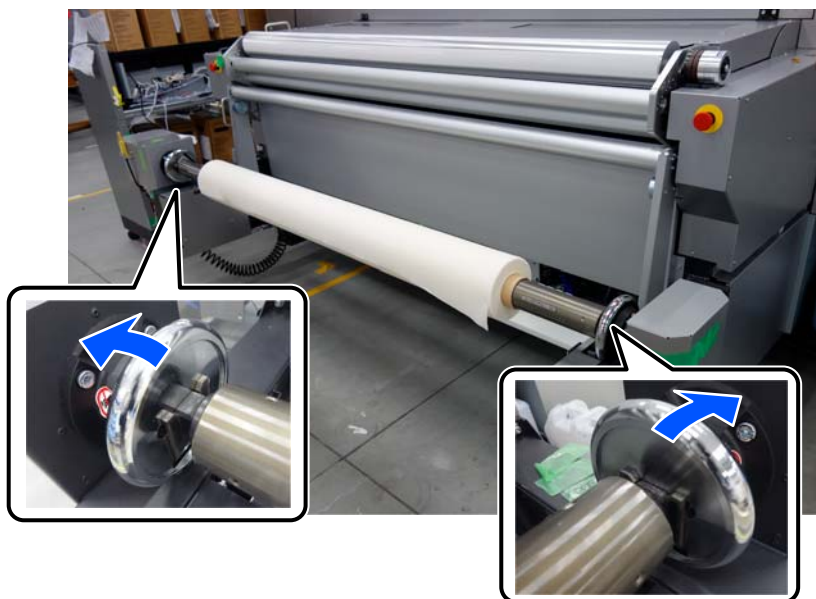
This loosens the stopper and creates a gap between the fabric roll core and the spindle.



Basic Operations

- 3** Push the locks on the left and right sides of the feeding unit toward the outer sides.

The spindle will be unlocked.



- 4** Remove the feeding spindle.

! *Caution:*

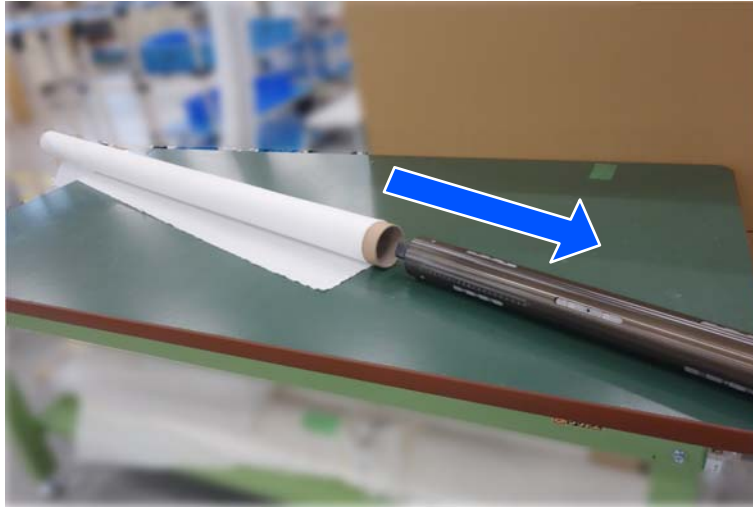
When installing or removing the fabric, be sure to wear safety shoes and make sure that the procedure is performed by at least two people. When lifting the fabric roll, make sure you bend your knees sufficiently and lift in a natural position.

Fabric rolls weigh more than 30 kg (66.14 pounds) and may cause an injury if dropped. Lifting with incorrect posture can lead to injury and/or back pain.



Basic Operations

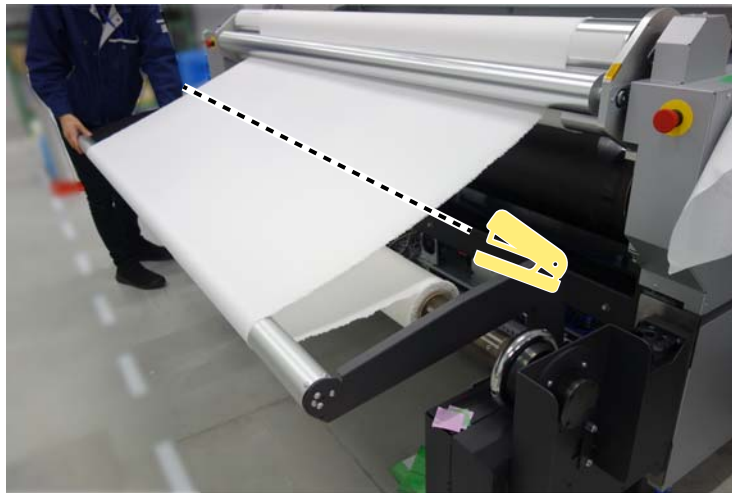
- 5 Remove the fabric roll from the feeding spindle.



- 6 Install a new fabric roll to the feeding spindle.

 [“Installing the Fabric Roll” on page 56](#)

- 7 Use the sewing machine to sew together the ending edge of the fabric being printed on and the starting edge of the new fabric.



- 8 Press the feed button (forward) on the rear panel to feed the fabric until the seam moves past the print head.



Important:

If the seam comes into contact with the print head during printing, the print head could be damaged. Be sure to check that the seam has passed by the print heads before starting printing.

- 9 Check the message on the control panel and then restart printing.

Basic Operations

Work After Printing


The workflow after printing is complete is as given below.

Removing the fabric roll

 ["Removing the Fabric Roll" on page 102](#)

**Checking the operating status of the water recycling unit**

Check that cleaning water is flowing from the printer's belt cleaning tank to the water recycling unit.

 ["Checking the Operating Status of the Water Recycling Unit" on page 109](#)

**Inspection after printing is complete**

Perform periodic inspections and cleaning after printing is complete.

 ["Inspection and Cleaning After Printing" on page 109](#)

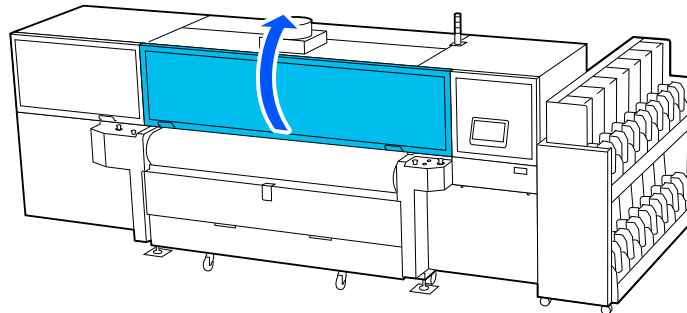
**Turning Off the Power**

See the following for details on how to turn off the power.

 ["Turning Off the Power" on page 110](#)

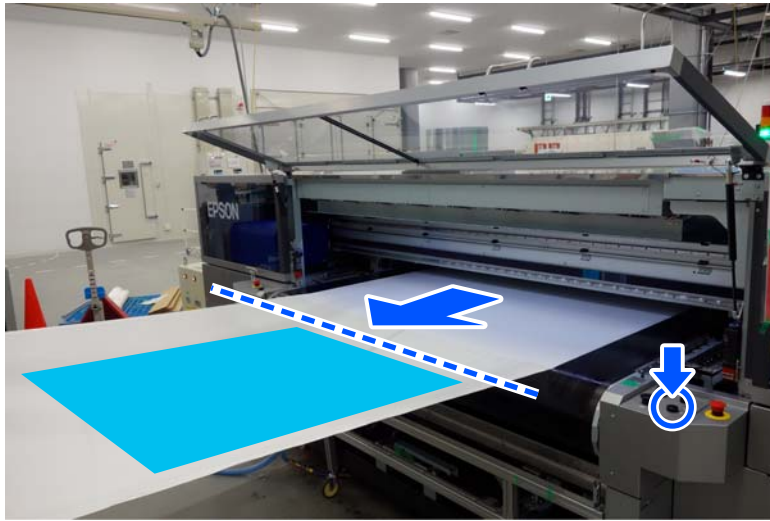
Removing the Fabric Roll

- 1 Open the front cover.

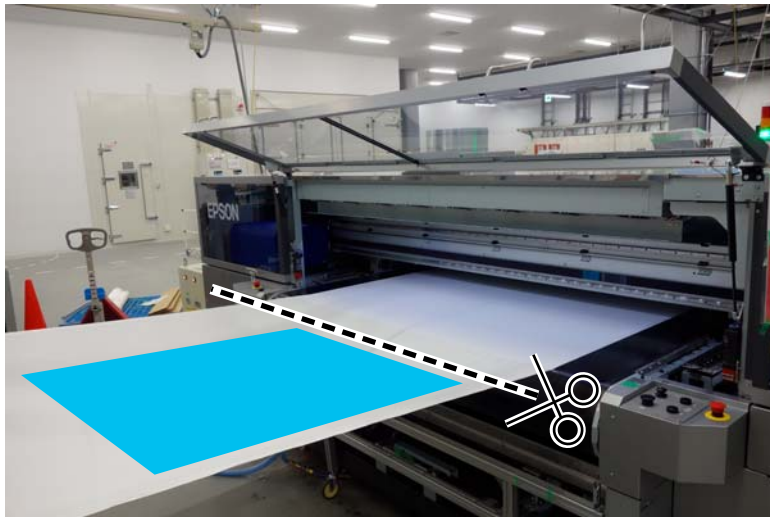


Basic Operations

- 2 Press the feed button (forward) on the front panel until the fabric cut position is between the front of the printer and the dryer or drying reel.



- 3 Cut the fabric using scissors or other such tools.

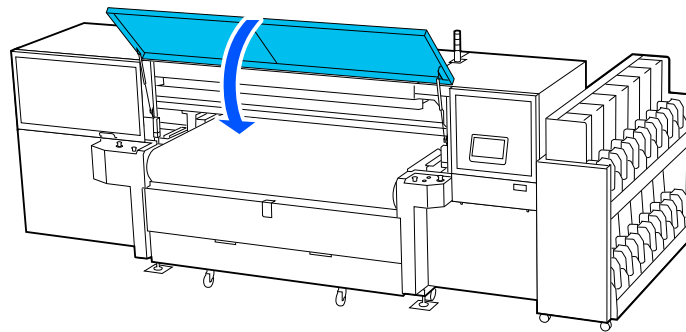


Basic Operations

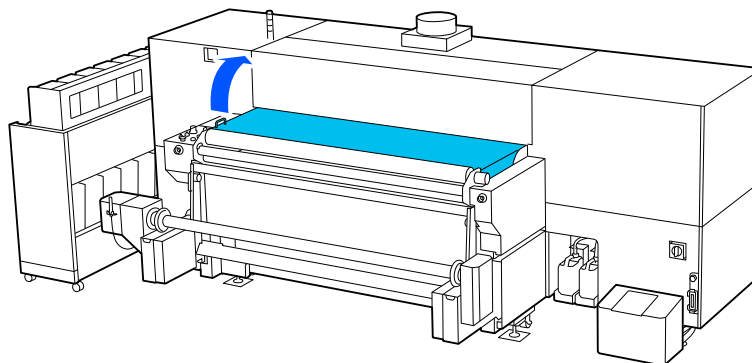
- 4** Remove the fabric from the belt from the front side.



- 5** Close the front cover.



- 6** Move to the rear of the printer and open the rear cover.

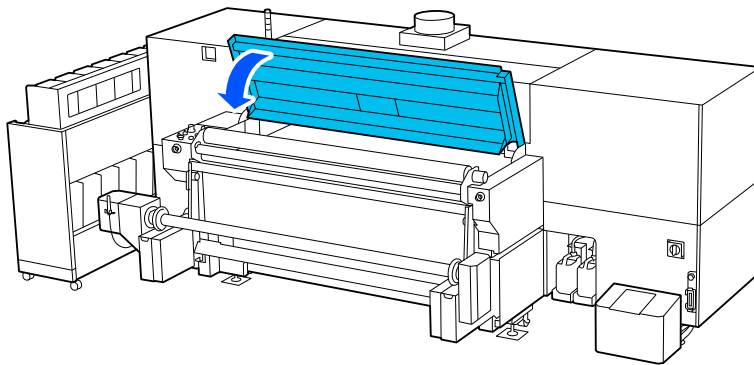


Basic Operations

- 7 Remove the fabric inside the rear cover from the belt.



- 8 Close the rear cover.



- 9 Set the feeding roller switch to Free (center).

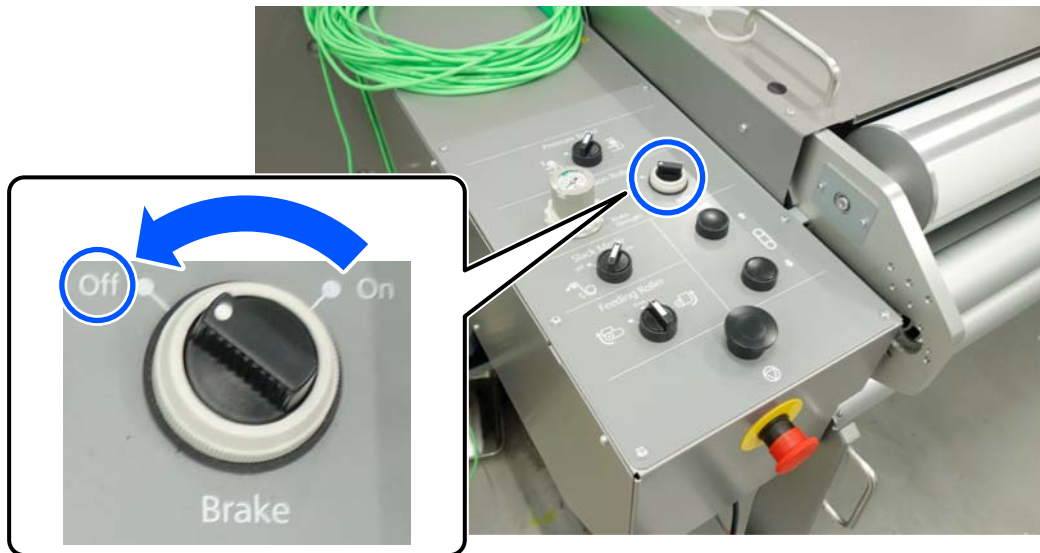


Basic Operations

- 10 Lift up the tension bar.



- 11 Set the tension switch to Off.



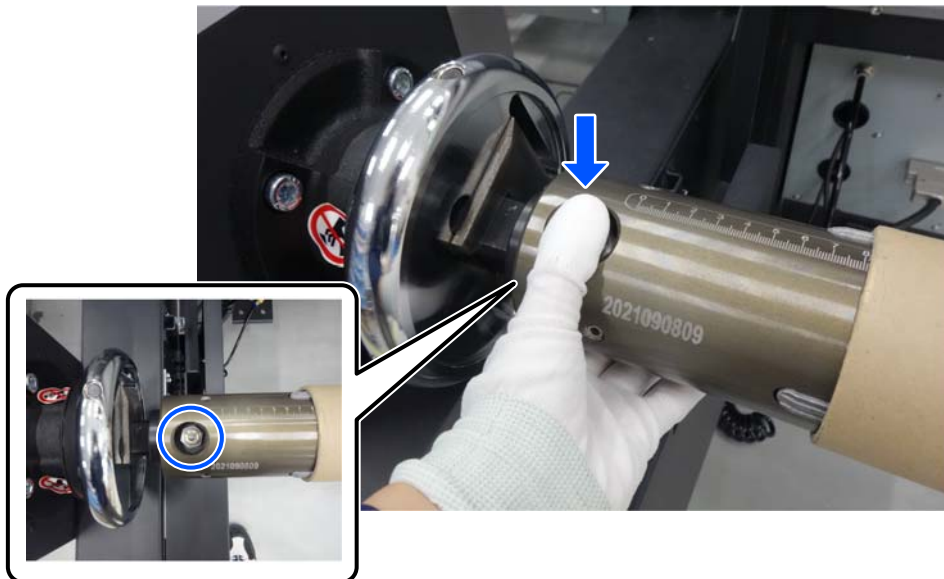
Basic Operations

- 12 Manually turn the feeding spindle to roll up the fabric.



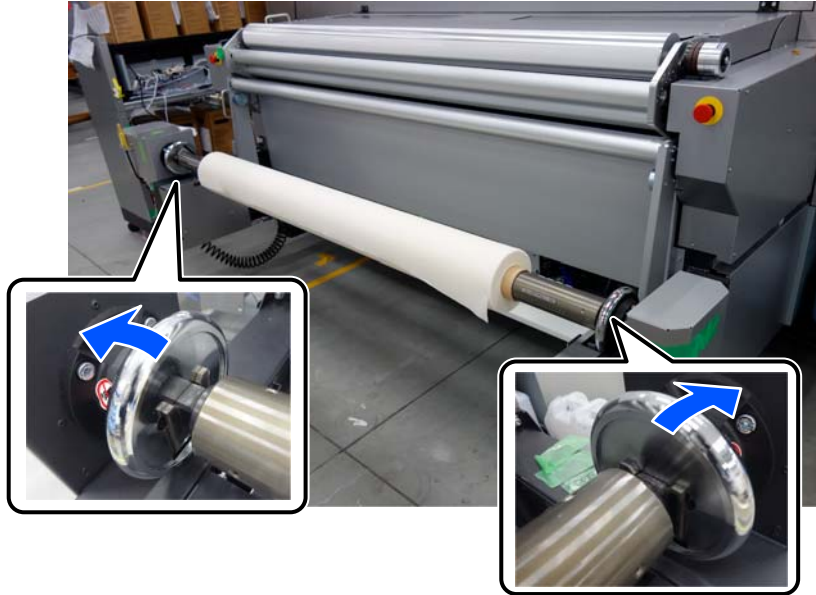
- 13 Press the center of the air inlet to release the air.

This loosens the stopper and creates a gap between the fabric roll core and the spindle.



Basic Operations

- 14** Push the locks on the left and right sides of the feeding unit toward the outer sides.
The spindle will be unlocked.



- 15** Remove the feeding spindle.

! *Caution:*

When installing or removing the fabric, be sure to wear safety shoes and make sure that the procedure is performed by at least two people. When lifting the fabric roll, make sure you bend your knees sufficiently and lift in a natural position.

Fabric rolls weigh more than 30 kg (66.14 pounds) and may cause an injury if dropped. Lifting with incorrect posture can lead to injury and/or back pain. Lifting with incorrect posture can lead to injury and/or back pain.



Basic Operations

- 16** Remove the fabric roll from the feeding spindle.




Checking the Operating Status of the Water Recycling Unit

Look through the maintenance cover on the water recycling unit to confirm that cleaning water is flowing from the printer's belt cleaning tank to the water recycling unit.

Clean the lint trap when too much lint has accumulated.

 [“Cleaning the Lint Trap” on page 194](#)




If the liquid has stopped flowing, check the status lights on the water recycling unit and take action to solve the error.

 [“Understanding the Status Lights on the Water Recycling Unit” on page 456](#)



If water is leaking from the water recycling unit, contact your dealer or Epson Support.

Inspection and Cleaning After Printing

Perform periodic inspections and cleaning before turning on the power.

Item	Frequency			Reference
	Everyday	Every week	Every month	
Flushing Pad	✓			 “Inspecting/Cleaning the Flushing Pad” on page 225
Around the print head	✓			 “Inspecting/Cleaning Around the Print Head” on page 229
Ink path	✓ Inspection		✓ Cleaning	 “Inspecting/Cleaning the Ink Path” on page 235

Basic Operations

Item	Frequency			Reference
	Everyday	Every week	Every month	
Sponge Roller	✓			 "Drying the Sponge Roller" on page 232
Belt cleaning unit		✓		 "Cleaning the Belt Cleaning Unit" on page 237

Turning Off the Power

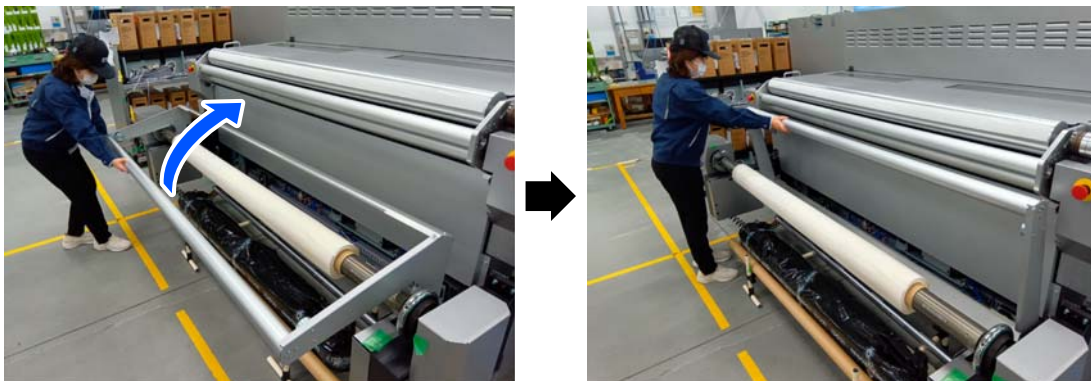
- 1 Press and hold the power button on the control panel for two seconds or more.



- 2 When the confirmation screen appears, touch **Yes**.

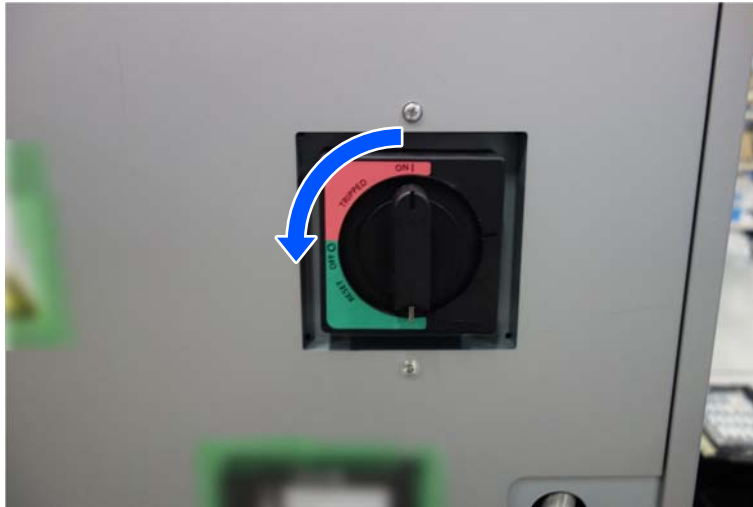
- 3 Move to the rear of the machine and raise the tension bar.

When the main power switch is turned off, the tension bar lowers and rotates the feeding spindle, which prevents the fabric from being pulled out excessively.



Basic Operations

- 4** Make sure that all signal lamps are turned off, and then turn OFF the main power switch on the back of the printer.



Print Adjustments

Perform print adjustments in the following cases.

- Using new fabric not registered to the printer
- When banding (horizontal band-shaped patterns, uneven shading, or stripes) or graininess is observed in the print result
- When using fabrics of different widths
- When changing the fabric thickness or head height

! **Important:**

When printing using one pass, turn **Off** the **Belt Feed Measurement Sensor** on the control panel before making adjustments. If you adjust the print settings while the Belt Feed Measurement Sensor is On, banding may occur during printing.

Note:

When making adjustments, we recommend that the following settings on the control panel are the same as when printing.

- Belt Cleaning
- Heated Pressure Roller
- Temperature

[☞ "General Settings Menu" on page 434](#)

[☞ "Fabric Settings Menu" on page 443](#)

Be sure to perform Automatic Adjustment when using the following fabric.

[☞ "Automatic Adjustment" on page 112](#)

Basic Operations

- Fabric with a density of 26 strands/inch or more
- Fabric without colors
- Fabric without a sheen or patterns
- Fabric that is not transparent

When using fabrics other than the above, Automatic Adjustment may fail to read the adjustment pattern.

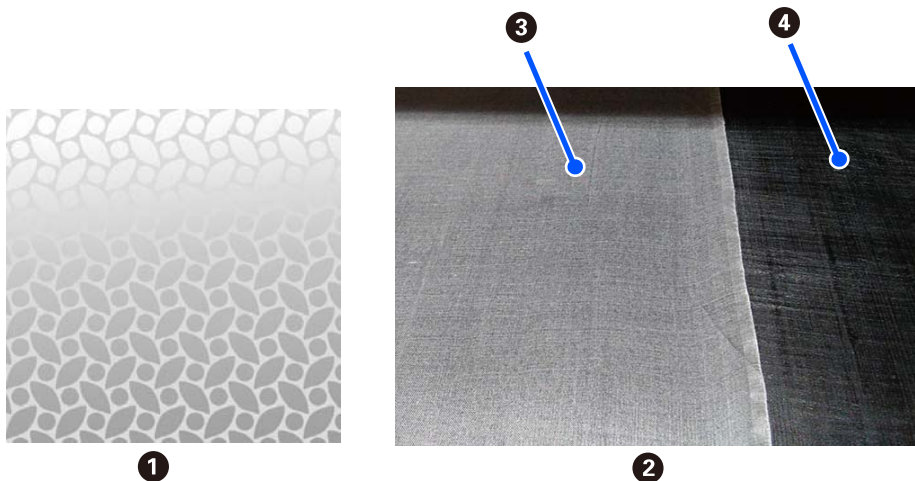
When using fabrics other than the above, or when Automatic Adjustment fails, perform Print Head Alignment (Manual) and Fabric Feed Adjustment (Manual).

 [“Print Head Alignment \(Manual\)” on page 114](#)

 [“Fabric Feed Adjustment \(Manual\)” on page 116](#)

Fabrics for which Automatic Adjustment frequently fails

Example



- ① Fabric with a sheen or patterns
- ② Transparent fabric
- ③ Fabric
- ④ Belt

Automatic Adjustment

Landing site displacement and fabric feeding are automatically adjusted while printing the pattern.

- 1 Check that the printer is ready, and load the fabric according to the actual usage conditions.
- 2 From the menu button on the control panel, touch **General Settings - Printer Settings** to set the Print Width and Print Start Position.
- 3 Touch **Fabric Settings - Print Adjustments - Automatic Adjustment**, in that order.

Basic Operations

4 Touch **Carriage Speed** to set the same carriage speed as during printing.

Check the carriage speed during printing from your RIP software or printing application.

When using Epson Edge Print, see the Epson Edge Print help for details on the carriage speed.

When using the Epson Rob file print tool, see the Operation Guide for the Epson Rob file print tool for details on the carriage speed.

5 Touch **Start**.

Auto adjust starts, and an adjustment pattern is printed. Wait until adjustment is complete.

See the following when an error occurs during Automatic Adjustment.

 [“When an error occurs during Automatic Adjustment” on page 113](#)

If banding or graininess is still visible in the print results even after performing Automatic Adjustment, perform Print Head Alignment (Auto) and Fabric Feed Adjustment (Auto).

 [“Print Head Alignment \(Auto\)” on page 117](#)

 [“Fabric Feed Adjustment \(Auto\)” on page 118](#)

Note:

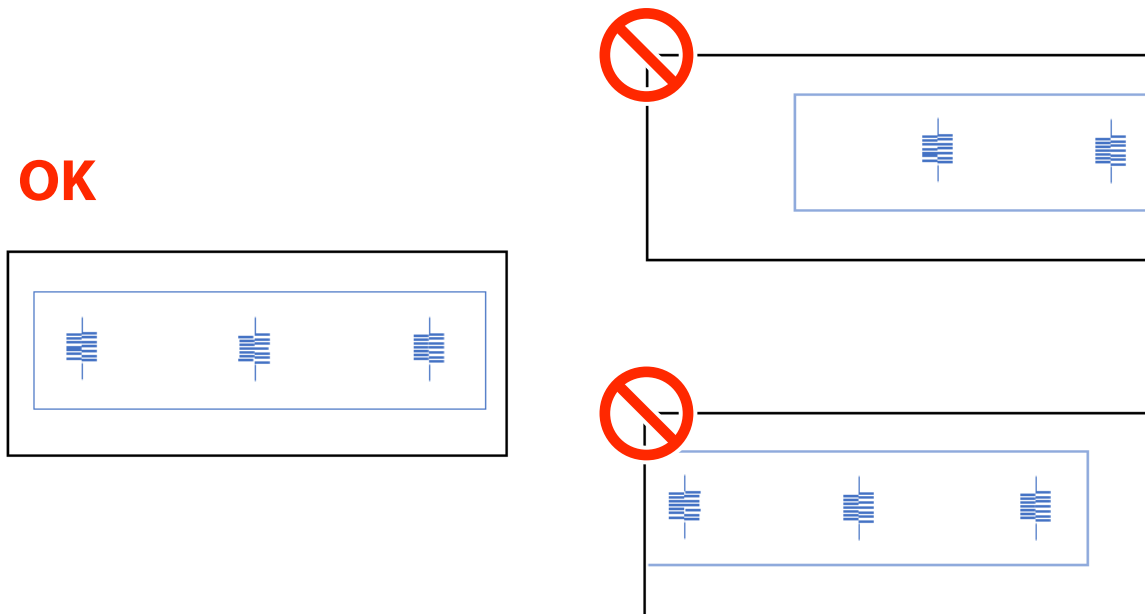
If the print results do not improve even after performing Print Adjustments, Fabric Feed Adjustment while printing, and print head alignment while printing, and if you notice one or two areas that have streaks or unevenness after printing 4 m (one rotation of the belt), you may be able to improve the print results by adjusting the belt feeding motor. For more details, contact your dealer or Epson Support.

When an error occurs during Automatic Adjustment

See the following for more details.

Basic Operations

- ❑ Are the Print Width and Print Start Position set correctly?
If these settings are incorrect, the pattern will be printed on the belt and reading the pattern may fail. If the adjustment pattern has missing parts, as shown in the illustration, start over from step 2.



- ❑ Is the fabric clean?
If the fabric is dirty, reading the pattern may fail. Make sure that the pattern printing position is clean, and start over from step 2.

If the error continues to occur even after checking the above, perform **Manual** from **Print Head Alignment** and **Manual** from **Fabric Feed Adjustment**.

- 🔗 [“Print Head Alignment \(Manual\)” on page 114](#)
- 🔗 [“Fabric Feed Adjustment \(Manual\)” on page 116](#)

Print Head Alignment (Manual)

Manually adjust the misalignment of the ink firing position.

- 1 Check that the printer is ready, and load the fabric according to the actual usage conditions.
- 2 From the menu screen on the control panel, touch **General Settings - Printer Settings** to set the Print Width and Print Start Position.
- 3 Return to the menu screen and touch **Fabric Settings - Print Adjustments - Print Head Alignment**, in that order.
- 4 Touch either **Manual(Simple)** or **Manual(Details)**.
When the fabric width is 750 mm or less
Select **Manual(Simple)**.

Basic Operations



Important:

Do not select **Manual(Details)** when the fabric width is 750 mm or less. When printing using **Manual(Details)**, the adjustment pattern may have some missing parts.

When the fabric width is more than 750 mm

Select **Manual(Simple)** when you want to make quick, simple adjustments by visually inspecting the pattern.

Select **Manual(Details)** when you want to perform adjustments equivalent to auto adjustment by visually inspecting the pattern.

5

Touch **Carriage Speed** to set the same carriage speed as during printing.

Check the carriage speed during printing from your RIP software or printing application.

When using Epson Edge Print, see the Epson Edge Print help for details on the carriage speed.

When using the Epson Rob file print tool, see the Operation Guide for the Epson Rob file print tool for details on the carriage speed.

6

Touch **Start**.

An adjustment pattern is printed. Wait until printing is complete.

7

Open the front cover to check the printed adjustment pattern.

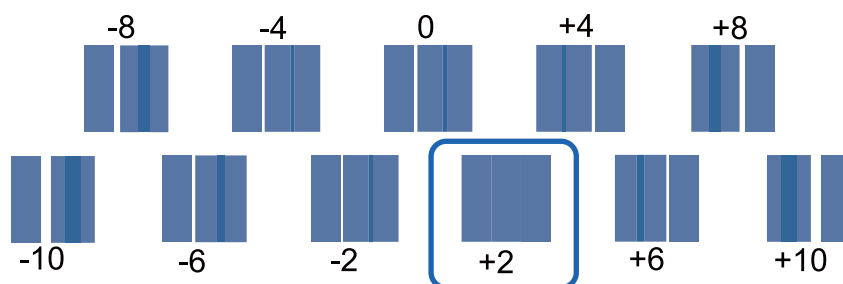
Adjustment pattern blocks are printed as shown below according to the type of manual adjustments.

Manual(Simple): 1 to 9 blocks

Manual(Details): 1 to 144 blocks

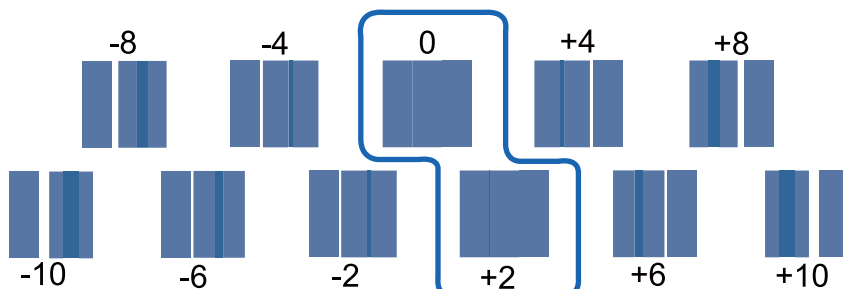
Select the pattern with the least tint unevenness for each block.

Select "+2" in the example shown below.



If there are patterns where unevenness is the same, enter the middle value in Step 9.

Set "+1" in the example shown below.



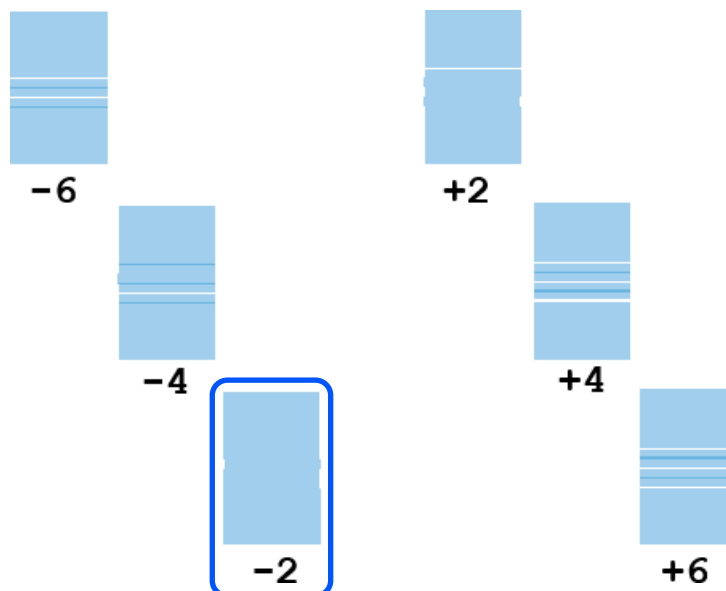
Basic Operations

- 8 Close the front cover.
The screen for entering confirmation results for the adjustment pattern is displayed.
- 9 On the entry screen of each block, set the number confirmed in Step 7 by touching **-**/**+**, and then touch **OK**.
The Fabric Settings menu is displayed when you finish the adjustments.

Fabric Feed Adjustment (Manual)

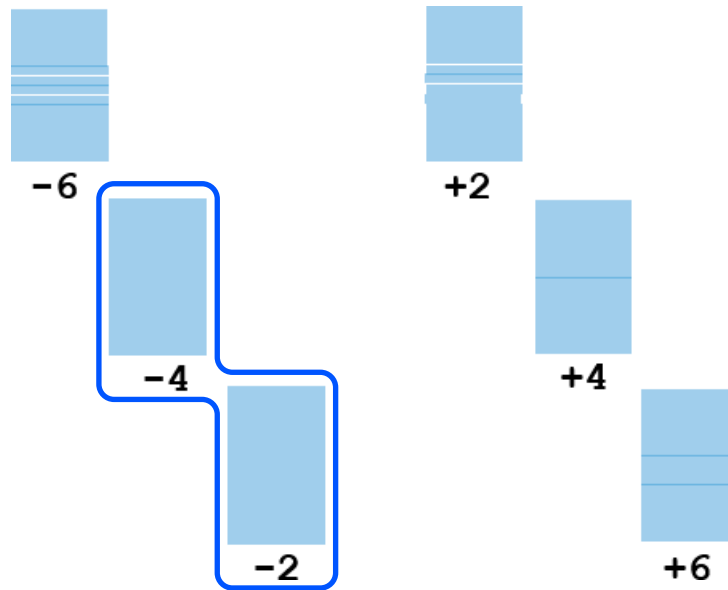
Manually adjust the fabric feed amount.

- 1 Check that the printer is ready, and load the fabric according to the actual usage conditions.
- 2 From the menu button on the control panel, touch **General Settings - Printer Settings** to set the Print Width and Print Start Position.
- 3 Touch **Fabric Settings - Print Adjustments - Fabric Feed Adjustment - Manual**, in that order.
- 4 Touch **Start**.
An adjustment pattern is printed. Wait until adjustment is complete.
- 5 Open the front cover to check the printed adjustment pattern.
Select the pattern with the least amount of overlapping or gaps. Select "-2" in the example shown below.



Basic Operations

If there are patterns where the overlapping or gaps are the same, enter the middle value in Step 7. Enter "-3" in the example shown below.



If all of the adjustment patterns contain overlaps or gaps, and you cannot narrow it down to 1, select the pattern with the least overlaps and gaps. Do Steps 2 to 5 again, and repeat them until a pattern with no overlaps or gaps is printed.

- 6** Close the front cover.
The screen for entering confirmation results for the adjustment pattern is displayed.
- 7** Set the values printed under the patterns, and then touch **OK**.

Print Head Alignment (Auto)

Automatically adjust the misalignment of the ink firing position.

Note:
Print Head Alignment (Auto) may take some time.

- 1** Check that the printer is ready, and load the fabric according to the actual usage conditions.
- 2** From the menu screen on the control panel, touch **General Settings - Printer Settings** to set the **Print Width** and **Print Start Position**.
- 3** Return to the menu screen and touch **Fabric Settings - Print Adjustments - Print Head Alignment - Auto**, in that order.
- 4** Set **Advanced** to **On**.

Basic Operations

- 5** Touch **Carriage Speed** to set the same Carriage Speed as during printing.

Check the Carriage Speed during printing from your RIP software or printing application.

When using Epson Edge Print, see the Epson Edge Print help for details on the carriage speed.

When using the Epson Rob file print tool, see the Operation Guide for the Epson Rob file print tool for details on the carriage speed.

- 6** Touch **Start**.

Print Head Alignment starts.

Fabric Feed Adjustment (Auto)

Automatically adjust the fabric feed amount.

Note:

Fabric Feed Adjustment (Auto) may take some time.

- 1** Check that the printer is ready, and load the fabric according to the actual usage conditions.
- 2** From the menu screen on the control panel, touch **General Settings - Printer Settings** to set the **Print Width** and **Print Start Position**.
- 3** Return to the menu screen and touch **Fabric Settings - Print Adjustments - Fabric Feed Adjustment - Auto**, in that order.
- 4** Set **Advanced** to **On**.
- 5** Touch **Start**.
Fabric Feed Adjustment starts.

Setting the Print Area and Print Position

The following functions are available for improving printing efficiency.

 [“Control Panel Menu” on page 434](#)

It is necessary to set the parameters on the print position to match the function settings.

- Flush on Belt

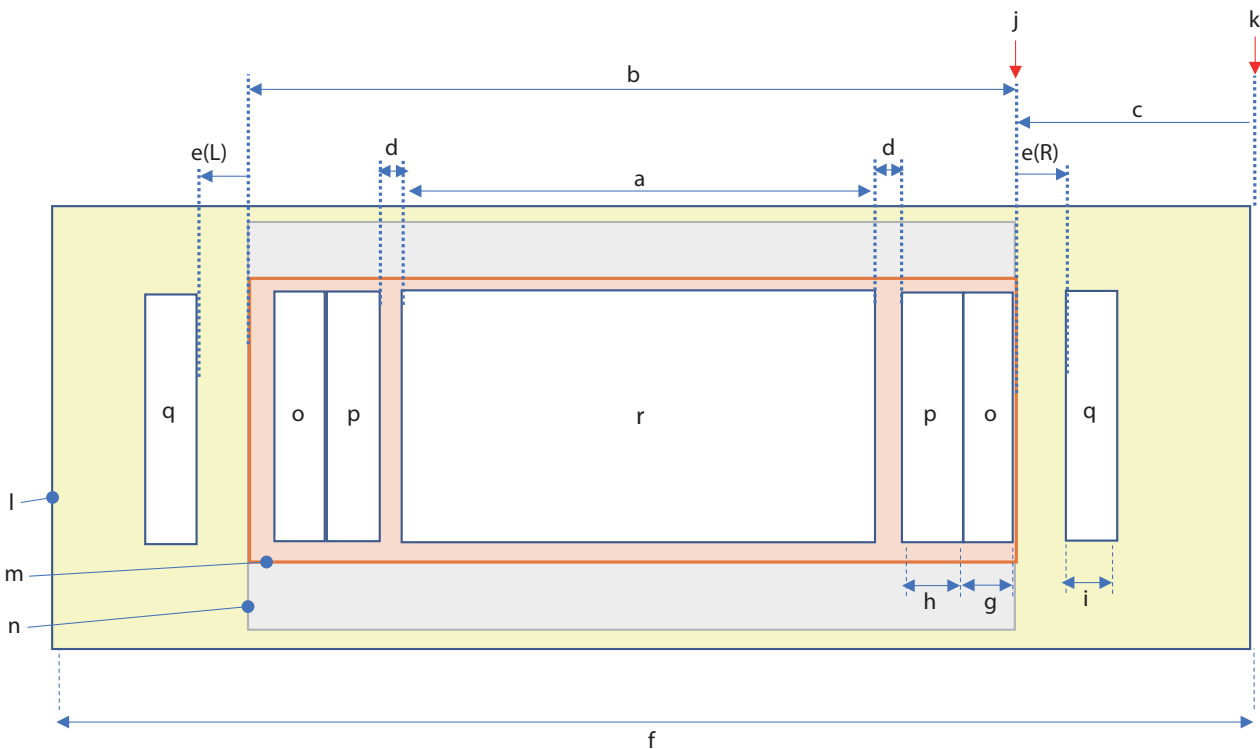
When the print width or fabric width is narrow, the print head does not move to the flushing pads on the left and right of the printer, but performs flushing on the belt. As this reduces the travel distance of the print head, it improves productivity.

The belt flushing position is determined by the print width and the distance from the edge of the belt to the print start position.

Basic Operations





- ❑ Fabric edge nozzle check pattern
When performing continuous jobs or banner printing jobs, you can check for nozzle clogs using the margins on the left and right of the fabric.
- ❑ Event Marking
If image quality changes during printing, this function prints a mark in the margin near the affected location to notify you thereof. You can efficiently discover locations with deteriorated image quality when inspecting printed products for delivery.

Print Area



Symbol	Item	Value / Range	Setting method
a	Print data width	300 to 1850 mm (11.81 to 72.83 inches)	RIP software
b	Print Width	300 to 1850 mm (11.81 to 72.83 inches) Default value: 1100 mm (43.31 inches)	Control panel ☞ "Control Panel Menu" on page 434
c	The distance from the right edge of the belt to the print start position	27 to 1000 mm (1.06 to 39.37 inches)	Control panel ☞ "Control Panel Menu" on page 434
d	The distance from the edge of the print data to the information at the edge of the fabric (event marking/nozzle check pattern printing)	5 to 999 mm (0.20 to 39.33 inches) Default value: 5 mm (0.20 inch)	Control panel ☞ "Control Panel Menu" on page 434

Basic Operations

Symbol	Item	Value / Range	Setting method
e (R)/(L)	The distance from the print area to belt flushing	This depends on the print width and the print start position.  "Belt Flushing Position" on page 120	-
f	Printable area	1912 mm (75.28 inches)	-
g	Fabric edge nozzle check pattern width	4 mm/16 mm (0.16 inch or 0.63 inch)	-
h	Event marking width	20 mm (0.79 inch)	-
i	Belt flushing width	-	-
j	Printing data end	-	-
k	Belt right edge (standard position)	-	-
l	Belt	-	-
m	Print Area	-	-
n	Fabric	-	-
o	Fabric edge nozzle check pattern	-	Control panel  "Control Panel Menu" on page 434
p	Event Marking	-	Control panel  "Control Panel Menu" on page 434
q	Flush on Belt	-	Control panel  "Control Panel Menu" on page 434
r	Print data	-	RIP software When using theEpson Edge Print, see the Epson Edge Print help.

Note:

If the print width extends beyond the printable area due to the setting for the print start position, the image is trimmed by the amount that extends beyond the printable area. If the actual print width is larger than the print width set on the machine, the image will be cropped to the specified print width. Further, if Event Marking or Fabric Edge Nozzle Check is turned ON, the area where Event Marking or Fabric Edge Nozzle Check is performed will also be cropped.

Belt Flushing Position

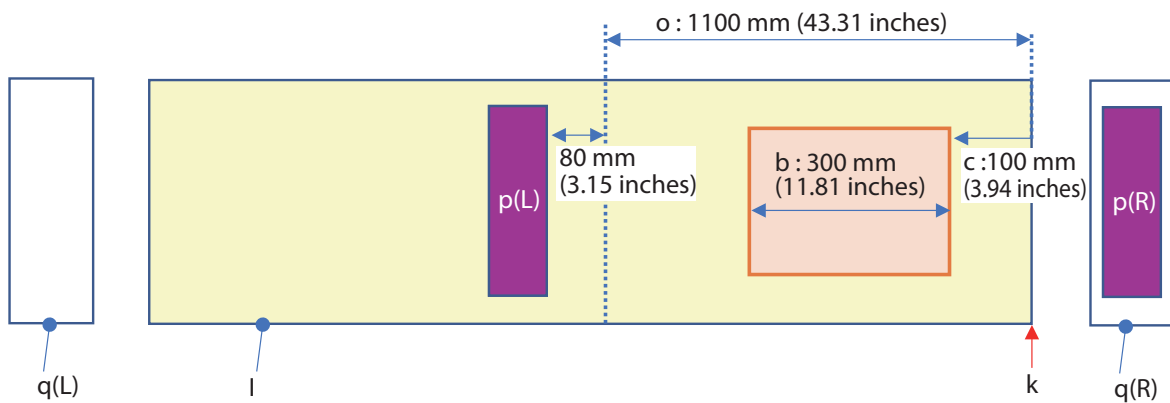
The belt flushing position is determined by the total length of the print width (b) and the distance (c) from the right edge of the belt to the print start position, and the length of the print width (b) and the distance (c) from the right edge of the belt to the print start position.

Basic Operations

By adjusting the print start position so that the print area is placed in the center of the belt, flushing is performed at the shortest distance.

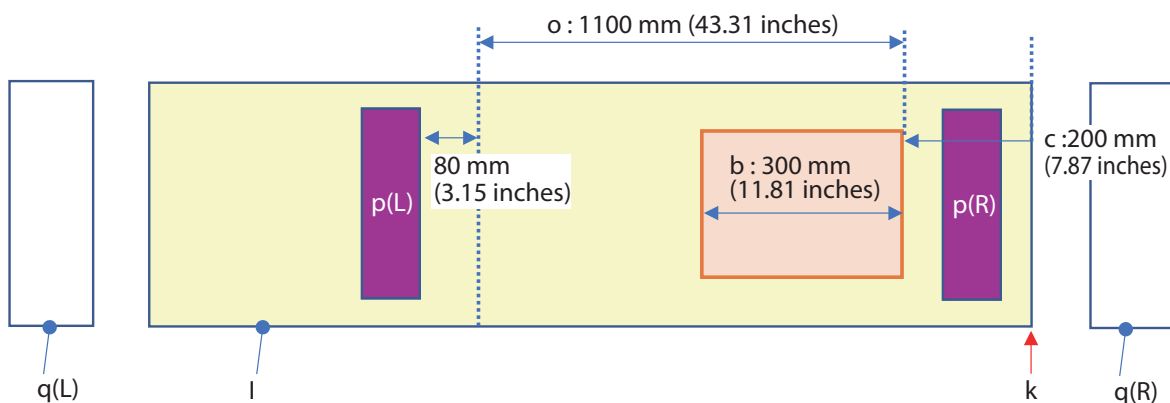
Symbol	Item	Symbol	Item
b	Print Width	o	Print head minimum movement distance
c	The distance from the right edge of the belt to the print start position	p (R)/(L)	Flushing box
k	Belt right edge (standard position)	q (R)/(L)	Flush on Belt
l	Belt		

1 When $b + c \leq 1100$ mm (43.31 inches) and $c \leq 155$ mm (6.10 inches)



- Belt flushing (right) position: On the right flushing pad
- Belt flushing (left) position: 1100 mm (43.31 inches) + 80 mm (3.15 inches)

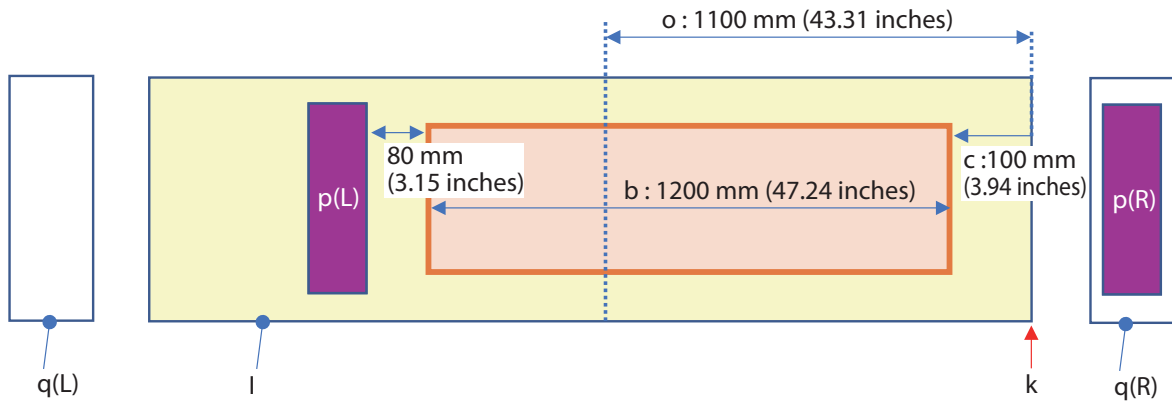
2 When $b + c \leq 1100$ mm (43.31 inches) and 850 mm (33.46 inches) $\geq c > 155$ mm (6.10 inches)



- Belt flushing (right) position: $c - 80$ mm (3.15 inches)
- Belt flushing (left) position: 1100 mm (43.31 inches) + $c + 80$ mm (3.15 inches)

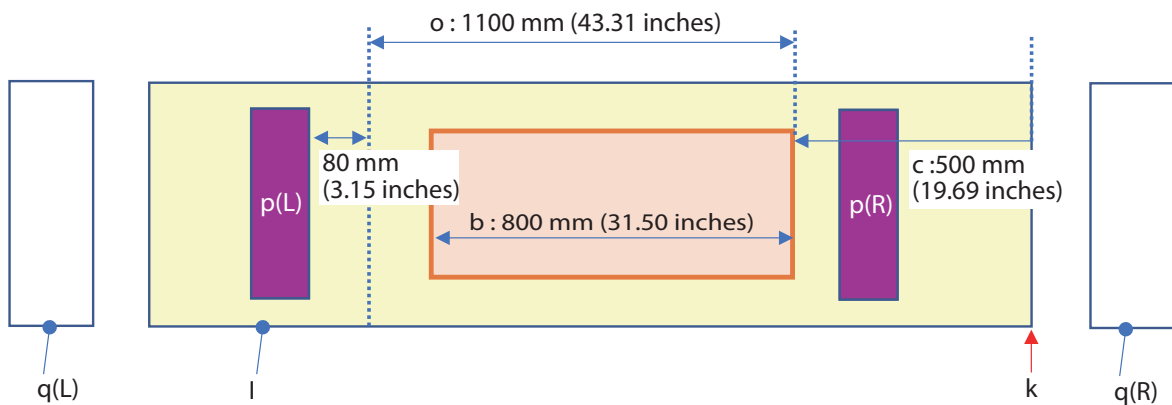
Basic Operations

3 When $1776 \text{ mm (69.92 inches)} \geq b + c > 1100 \text{ mm (43.31 inches)}$ and $c \leq 155 \text{ mm (6.10 inches)}$



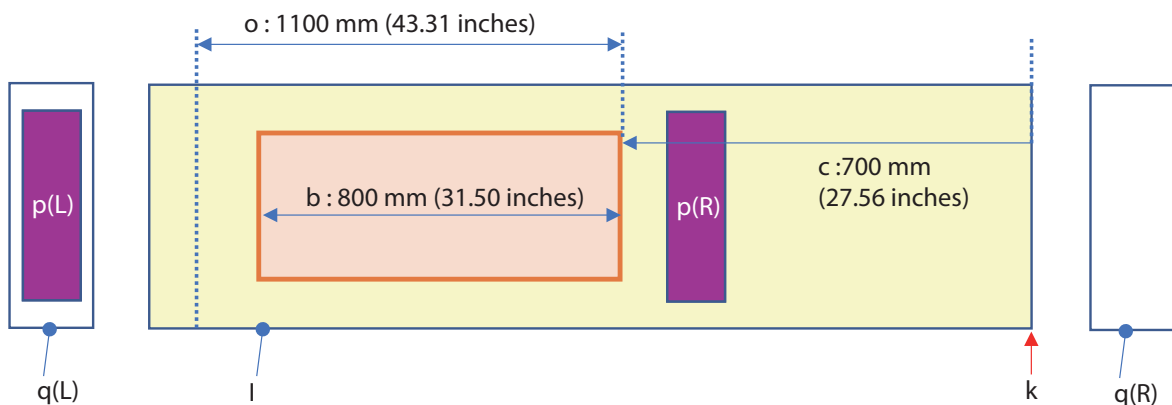
- Belt flushing (right) position: On the right flushing pad
- Belt flushing (left) position: $b + c + 80 \text{ mm (3.15 inches)}$

4 When $1776 \text{ mm (69.92 inches)} \geq b + c > 1100 \text{ mm (43.31 inches)}$ and $676 \text{ mm (26.61 inches)} \geq c > 155 \text{ mm (6.10 inches)}$ and $b \leq 1100 \text{ mm (43.31 inches)}$



- Belt flushing (right) position: $c - 80 \text{ mm (3.15 inches)}$
- Belt flushing (left) position: $1100 \text{ mm (43.31 inches)} + c + 80 \text{ mm (3.15 inches)}$

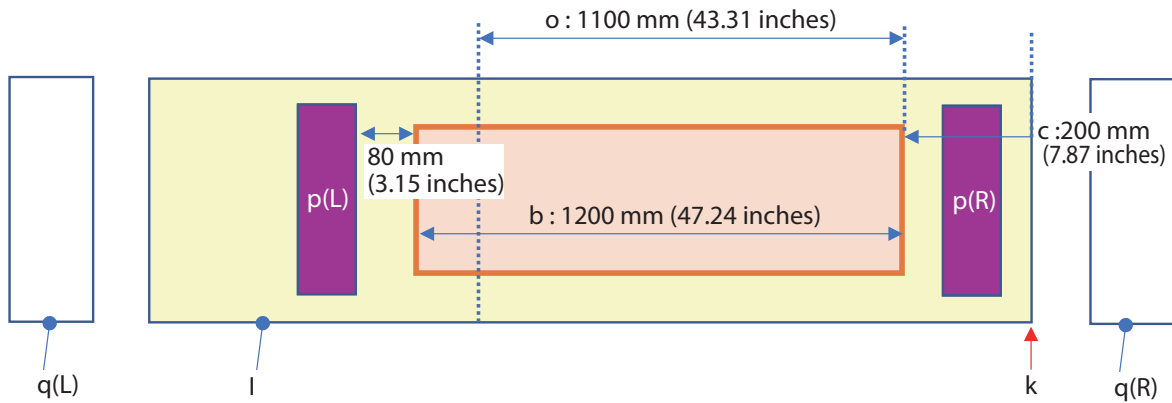
5 When $1776 \text{ mm (69.92 inches)} \geq b + c > 1100 \text{ mm (43.31 inches)}$ and $850 \text{ mm (33.46 inches)} \geq c > 676 \text{ mm (26.61 inches)}$ and $b \leq 1100 \text{ mm (43.31 inches)}$



Basic Operations

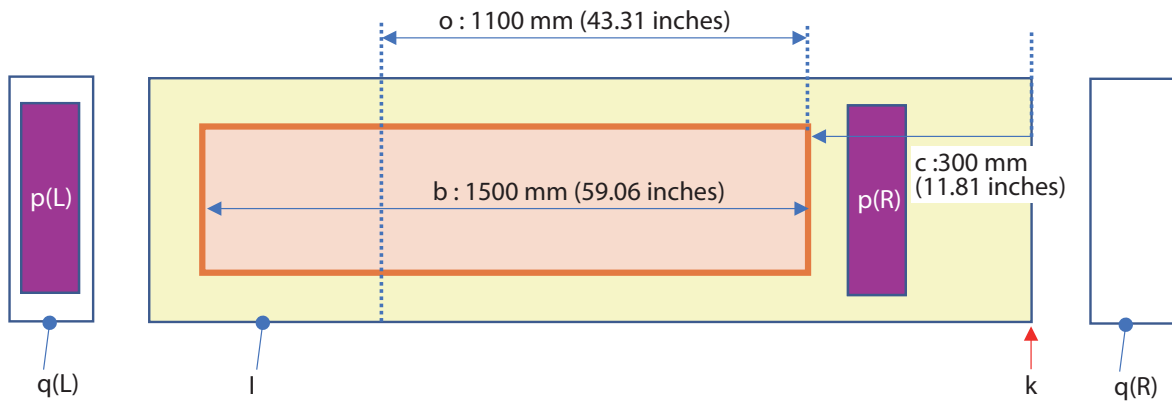
- Belt flushing (right) position: $c - 80$ mm (3.15 inches)
- Belt flushing (left) position: On the left flushing pad

6 When 1776 mm (69.92 inches) $\geq b + c > 1100$ mm (43.31 inches) and 676 mm (26.61 inches) $\geq c > 155$ mm (6.10 inches) and $b > 1100$ mm (43.31 inches)



- Belt flushing (right) position: $c - 80$ mm (3.15 inches)
- Belt flushing (left) position: $b + c + 80$ mm (3.15 inches)

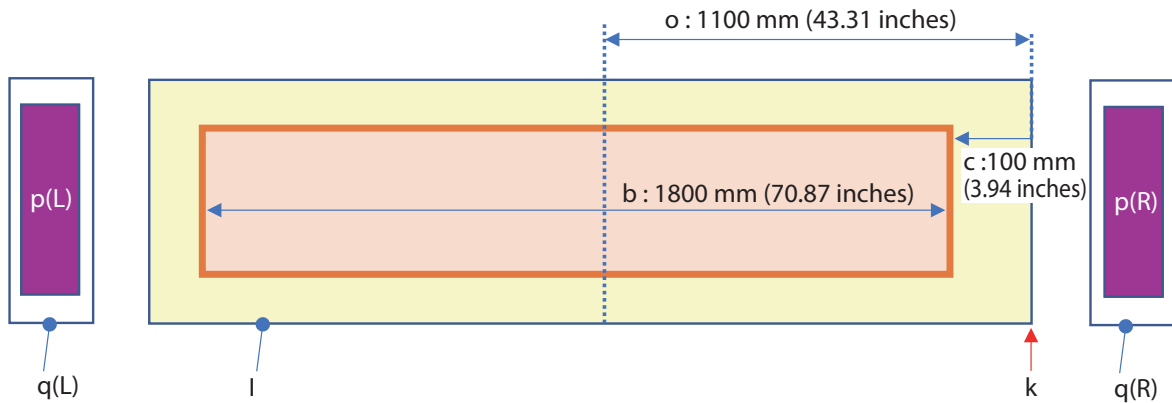
7 When $b + c > 1776$ mm (69.92 inches) and 850 mm (33.46 inches) $\geq c > 155$ mm (6.10 inches)



- Belt flushing (right) position: $c - 80$ mm (3.15 inches)
- Belt flushing (left) position: On the left flushing pad

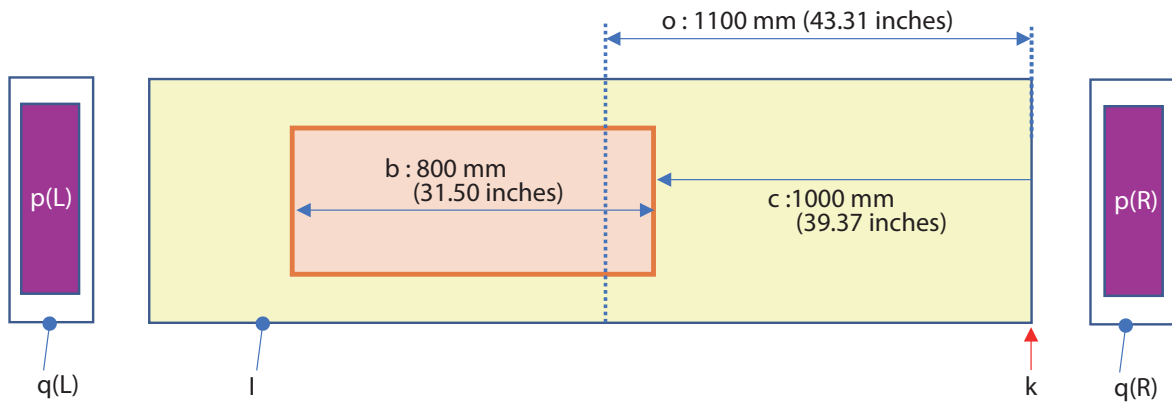
Basic Operations

8 When $b + c > 1776$ mm (69.92 inches) and $c \leq 155$ mm (6.10 inches)



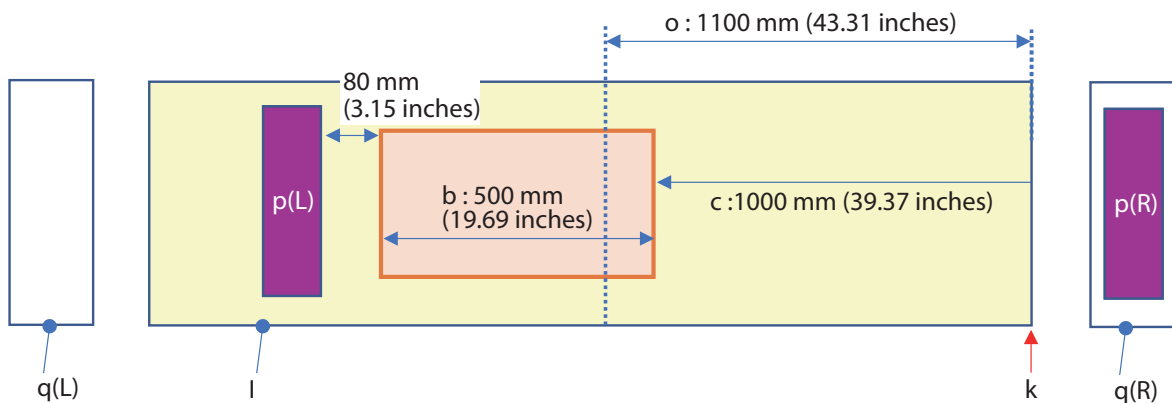
- Belt flushing (right) position: On the right flushing pad
- Belt flushing (left) position: On the left flushing pad

9 When $b + c > 1776$ mm (69.92 inches) and $c > 850$ mm (33.46 inches)



- Belt flushing (right) position: On the right flushing pad
- Belt flushing (left) position: On the left flushing pad

10 When 1776 mm (69.92 inches) $\geq b + c$ and $c > 850$ mm (33.46 inches)



Basic Operations

- Belt flushing (right) position: On the right flushing pad
- Belt flushing (left) position: $b + c + 80$ mm (3.15 inches)

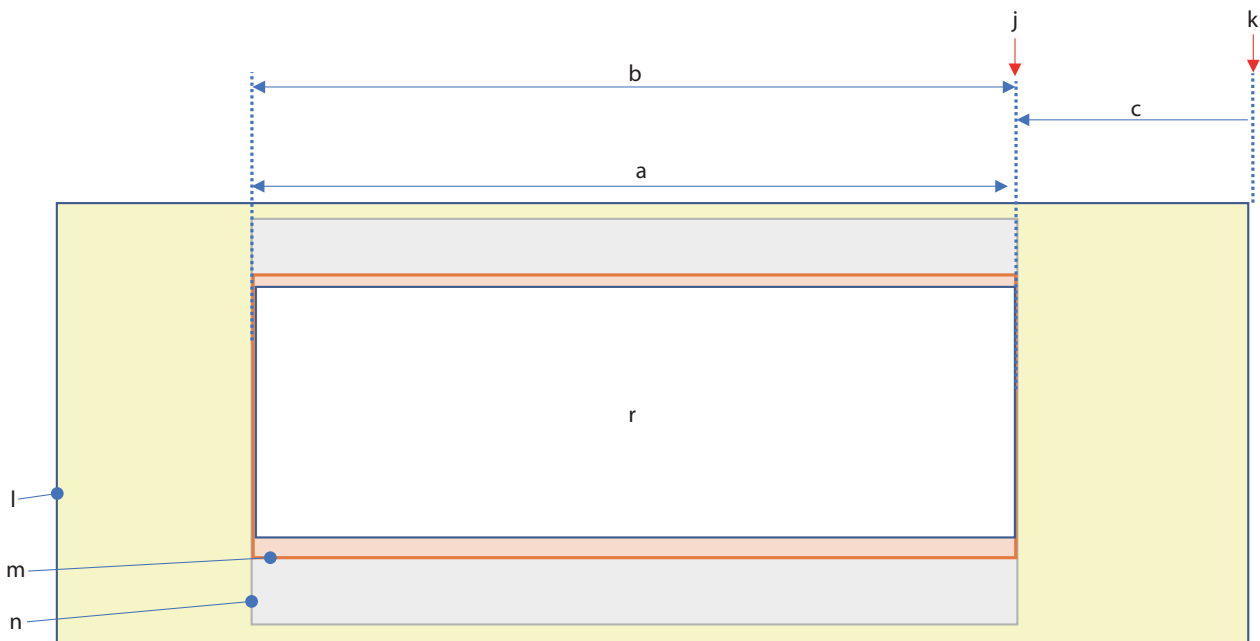
Setting the Print Position

For methods for setting a print position that matches function settings, refer to the patterns below.

	Pattern A	Pattern B	Pattern C	Pattern D
Flush on Belt	OFF	OFF	ON	ON
Fabric edge nozzle check pattern	OFF	ON	OFF	ON
Event Marking	OFF	ON	OFF	ON


Pattern A

Flush on Belt	OFF
Fabric edge nozzle check pattern	OFF
Event Marking	OFF



Symbol	Item	Setting method
a	Print data width	Specify using the RIP software. To print without exceeding the edges of the fabric, prepare print data equal to or smaller than the fabric size. To print without leaving a margin at the edges of the fabric, prepare print data larger than the fabric size. When using theEpson Edge Print, see the Epson Edge Print help.

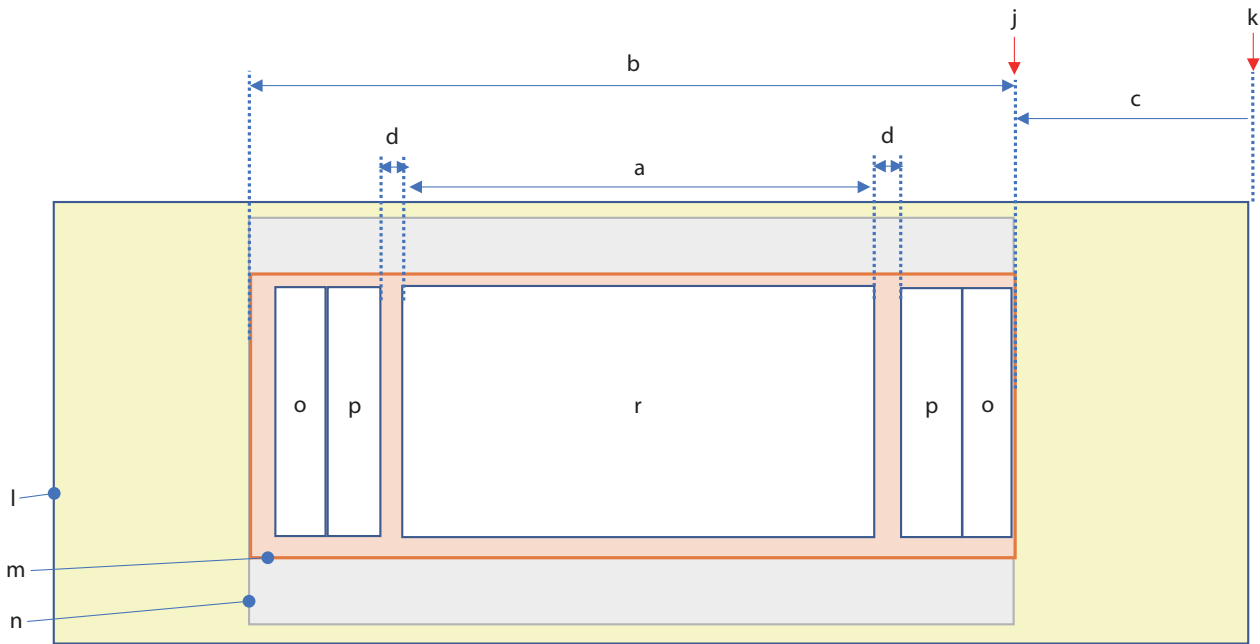
Basic Operations

Symbol	Item	Setting method
b	Print Width	<p>Specify this on the control panel or in your application.</p> <p>To print without exceeding the edges of the fabric, measure the distance from the print start position to the desired print position and set this as the print width.</p> <p>To print without leaving a margin at the edges of the fabric, measure the distance from the left edge of the fabric to the point where it exceeds the edge of the fabric and set this as the print width.</p>
c	The distance from the right edge of the belt to the print start position	<p>Specify this on the control panel.</p> <p>To print without exceeding the edges of the fabric, after attaching the fabric to the belt, measure the distance from the belt edge to the position where you want to start printing and set this as the distance.</p> <p>To print without leaving a margin at the edges of the fabric, measure the distance from the right edge of the fabric to the point where it exceeds the edge of the fabric and set this as the print start position.</p> <p> "Setting the Print Start Position" on page 90</p>
j	Printing data end	-
k	Belt right edge (standard position)	-
l	Belt	-
m	Print Area	-
n	Fabric	-
r	Print data	RIP software

Pattern B

Flush on Belt	OFF
Fabric edge nozzle check pattern	ON
Event Marking	ON

Basic Operations



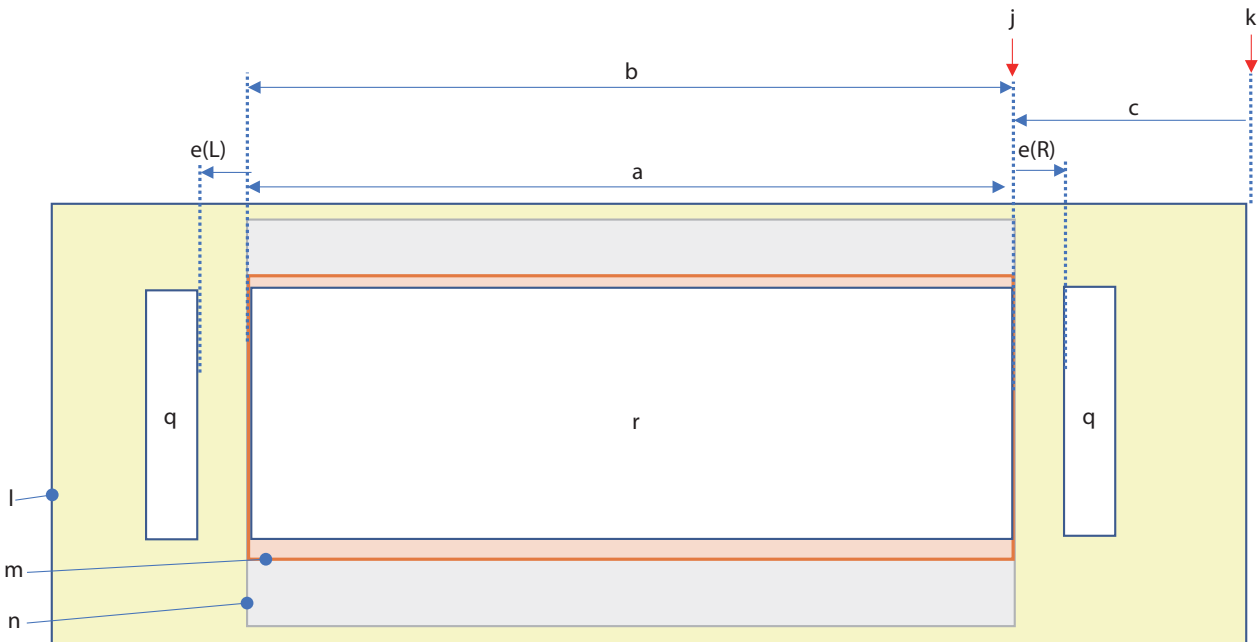
Symbol	Item	Setting method
a	Print data width	Specify using the RIP software. Ensure that the combined total width of the image (a), event marking (p), and fabric edge nozzle check pattern (o) fits within the fabric width. When using theEpson Edge Print, see the Epson Edge Print help.
b	Print Width	Specify this on the control panel. Specify the same value as the fabric width.
c	The distance from the right edge of the belt to the print start position	Specify this on the control panel. After attaching the fabric to the belt, measure the distance from the belt edge to the right edge of the fabric and set this as the distance. "Setting the Print Start Position" on page 90
d	The distance from the edge of the print data to the information at the edge of the fabric (event marking/nozzle check pattern printing)	Specify this on the control panel. If the Event Marking and fabric edge nozzle check go beyond the print width, the image size is clipped.
j	Printing data end	-
k	Belt right edge (standard position)	-
l	Belt	-
m	Print Area	-
n	Fabric	-
o	Fabric edge nozzle check pattern	Set this on the control panel. "Control Panel Menu" on page 434

Basic Operations

Symbol	Item	Setting method
p	Event Marking	Set this on the control panel. 🔗 "Control Panel Menu" on page 434
r	Print data	RIP software




Pattern C

Flush on Belt	ON
Fabric edge nozzle check pattern	OFF
Event Marking	OFF



Symbol	Item	Setting method
a	Print data width	Specify using the RIP software. To print without exceeding the edges of the fabric, prepare print data equal to or smaller than the fabric size. To print without leaving a margin at the edges of the fabric, prepare print data larger than the fabric size. When using theEpson Edge Print, see the Epson Edge Print help.
b	Print Width	Specify this on the control panel. To print without exceeding the edges of the fabric, measure the distance from the print start position to the desired print position and set this as the print width. To print without leaving a margin at the edges of the fabric, measure the distance from the left edge of the fabric to the point where it exceeds the edge of the fabric and set this as the print width.

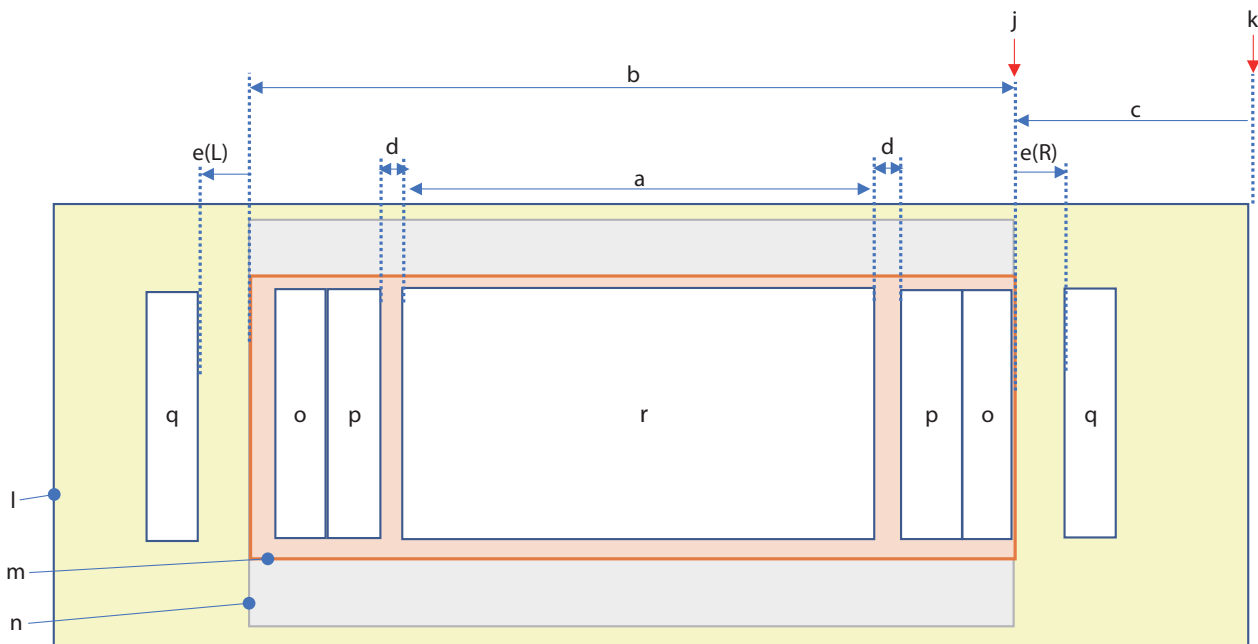
Basic Operations

Symbol	Item	Setting method
c	The distance from the right edge of the belt to the print start position	<p>Specify this on the control panel.</p> <p>After attaching the fabric to the belt, measure the distance from the belt edge to the position where you want to start printing and set this as the distance.</p> <p>To print without leaving a margin at the edges of the fabric, measure the distance from the right edge of the fabric to the point where it exceeds the edge of the belt and set this as the print start position.</p> <p> "Setting the Print Start Position" on page 90</p>
e (R)/(L)	The distance from the print area to belt flushing	<p>This depends on the print width and the print start position.</p> <p> "Belt Flushing Position" on page 120</p>
j	Printing data end	-
k	Belt right edge (standard position)	-
l	Belt	-
m	Print Area	-
n	Fabric	-
q	Flush on Belt	<p>Set this on the control panel.</p> <p> "Control Panel Menu" on page 434</p>
r	Print data	RIP software

Pattern D

Flush on Belt	ON
Fabric edge nozzle check pattern	ON
Event Marking	ON

Basic Operations



Symbol	Item	Setting method
a	Print data width	Specify using the RIP software. Ensure that the combined total width of the image (a), Event Marking (p), and fabric edge nozzle check pattern (o) fits within the fabric width. When using theEpson Edge Print, see the Epson Edge Print help.
b	Print Width	Specify this on the control panel. Specify the same value as the fabric width.
c	The distance from the right edge of the belt to the print start position	Specify this on the control panel. To print without exceeding the edges of the fabric, after attaching the fabric to the belt, measure the distance from the belt edge to the right edge of the fabric and set this as the distance. ☞ "Setting the Print Start Position" on page 90
d	The distance from the edge of the print data to the information at the edge of the fabric (event marking/nozzle check pattern printing)	Specify this on the control panel. If the Event Marking and fabric edge nozzle check go beyond the print width, the image size is clipped.
e (R)/(L)	The distance from the print area to belt flushing	This depends on the print width and the print start position. ☞ "Belt Flushing Position" on page 120
j	Printing data end	-
k	Belt right edge (standard position)	-
l	Belt	-
m	Print Area	-
n	Fabric	-

Basic Operations

Symbol	Item	Setting method
o	Fabric edge nozzle check pattern	Set this on the control panel. 🔗 "Control Panel Menu" on page 434
p	Event Marking	Set this on the control panel. 🔗 "Control Panel Menu" on page 434
q	Flush on Belt	Set this on the control panel. 🔗 "Control Panel Menu" on page 434
r	Print data	RIP software

Sensor Settings

Follow the steps below to adjust or reset the sensitivity of the sensor.

Slack Detection Sensor and Roll Diameter Measurement Sensor

Check that the sensor is not detecting any obstructions. Clean the sensors if they are dirty.

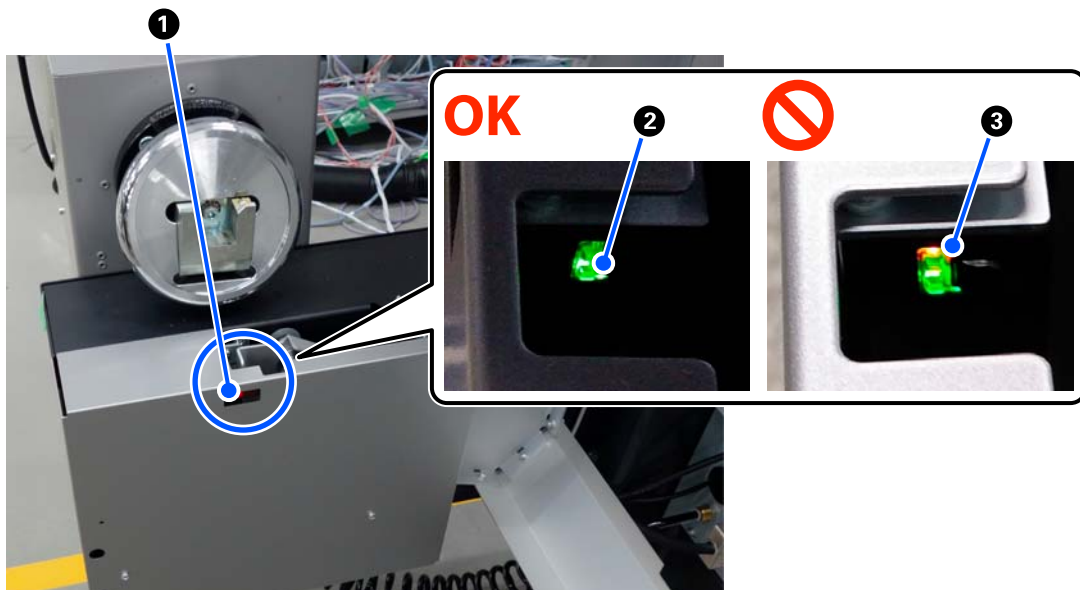
[🔗 "Inspecting/Cleaning the Sensors" on page 216](#)

If the sensors are not reacting correctly, follow the steps below to reset the sensors.

1 While no fabric is loaded, make sure the green light above the sensor you want to reset is on.

If the orange lamp is also lit, it means that an obstruction has been detected. Remove any obstructions from the sensor's optical axis.

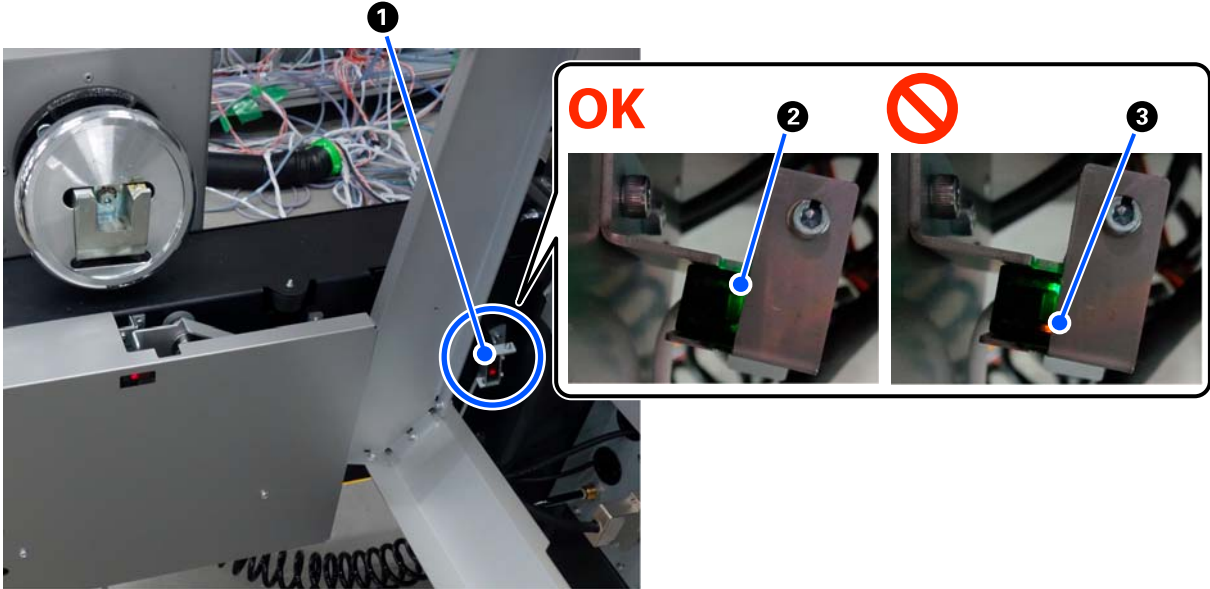
Roll Diameter Measurement Sensor



Basic Operations

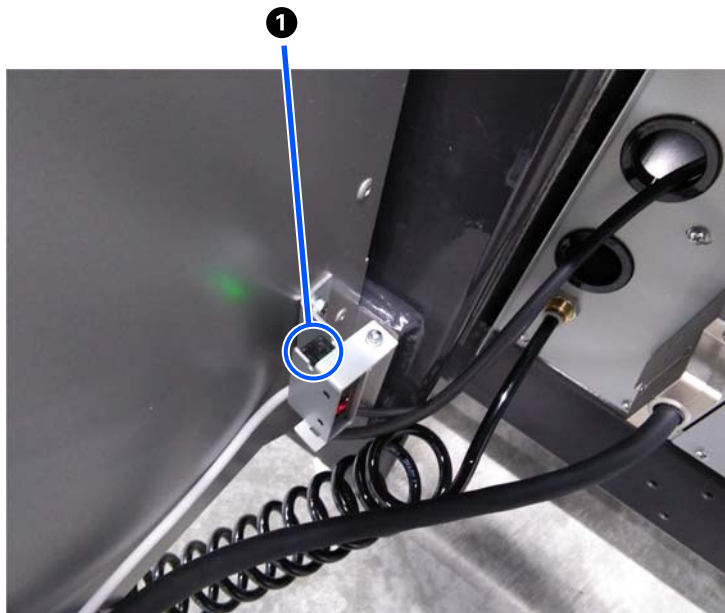
- ① Red light
- ② Green light
- ③ Orange light

Slack Detection Sensor



- ① Red light
- ② Green light
- ③ Orange light

- 2 Press and hold the button next to the green light. The light starts flashing orange quickly.



- ① Button

Basic Operations

- 3 Press the button again.
The light changes back to green and the sensor has been reset.

If the orange lamp flashes, the reset has failed. Remove any obstructions from the sensor's optical axis, and then check that the light from the sensor is hitting the reflector plates. If the problem continues to occur, contact your dealer or Epson Support.

Fabric Floating Sensor

 ["Setting the Fabric Wrinkle Detection Sensor" on page 89](#)

Tangled Fabric Detection Sensor

If there is ink, water droplets, or debris on the belt, or if the sensor's sensitivity has changed due to opening and closing covers or other operations, the sensor may incorrectly detect that the fabric is tangled.

Check for ink, water droplets, or debris near the sensor and clean them up.

If the error continues to occur even after cleaning, or if the ink penetrates to the back of the fabric when printing, perform the setting procedure to configure the sensor.

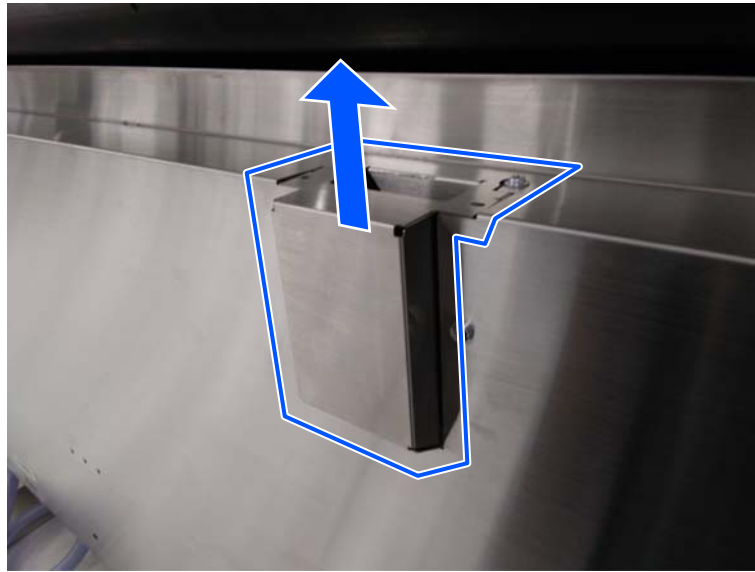
Setting method

- 1 Loosen and remove the two screws on the top of the sensor cover by hand.

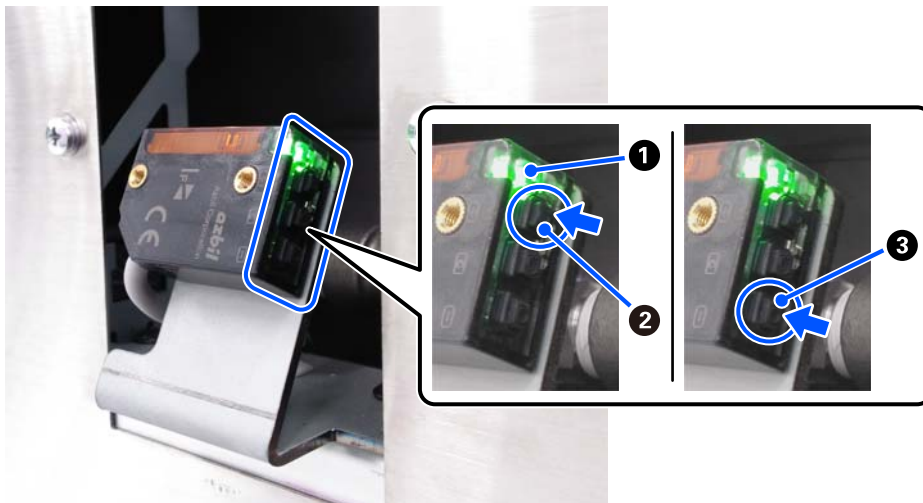


Basic Operations

- 2** Lift up the cover and remove it.



- 3** Press and hold the + or - button on the right of the sensor.
The green light flashes three times to release the lock.

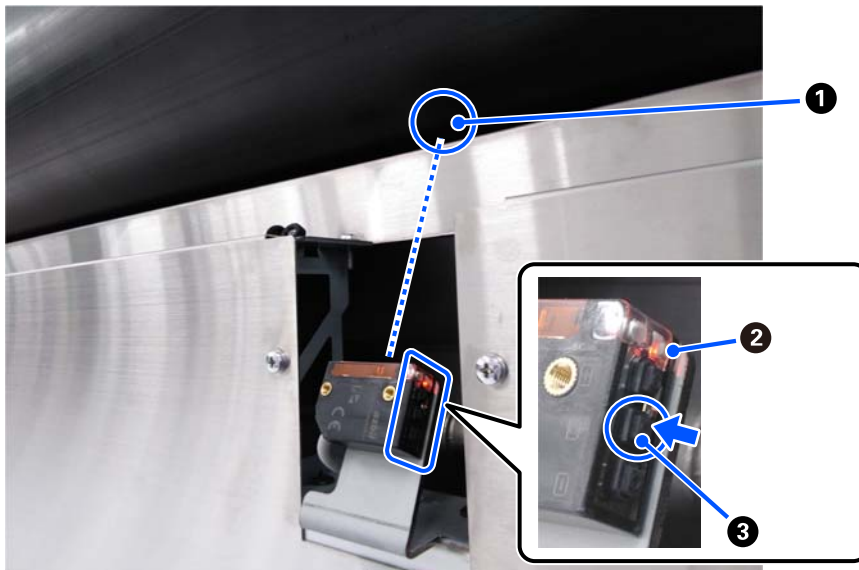


- 1** Green lamp
- 2** + Button
- 3** - Button

Basic Operations

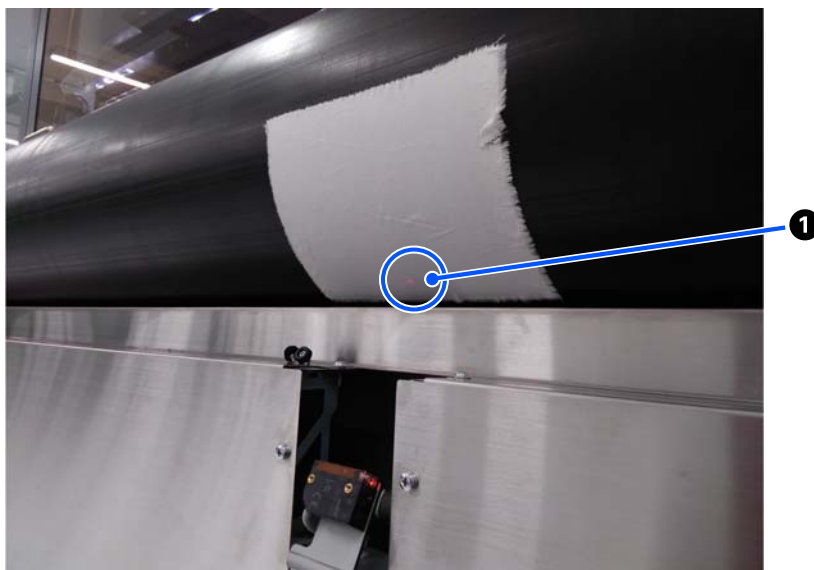
- 4** Press and hold the C button between the + button and the - button.

The orange lamp will flash and the laser will be emitted on the belt.



- ① Laser beaming position
- ② Orange light
- ③ C Button

- 5** Attach a piece of fabric to the position on the belt on which the laser beam is emitted.



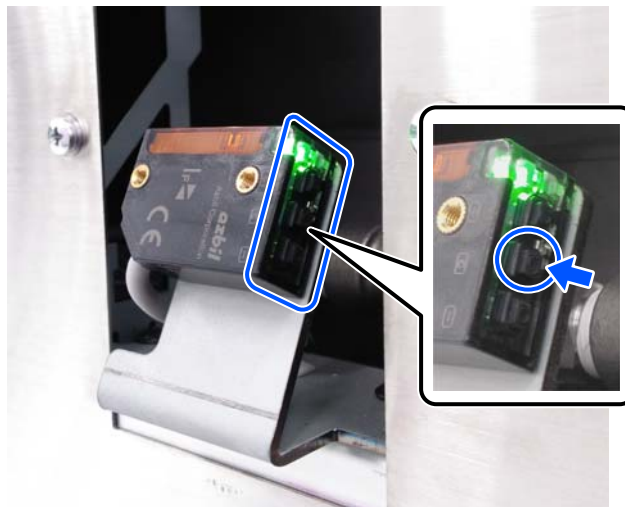
- ① Laser

- 6** Press the C button.

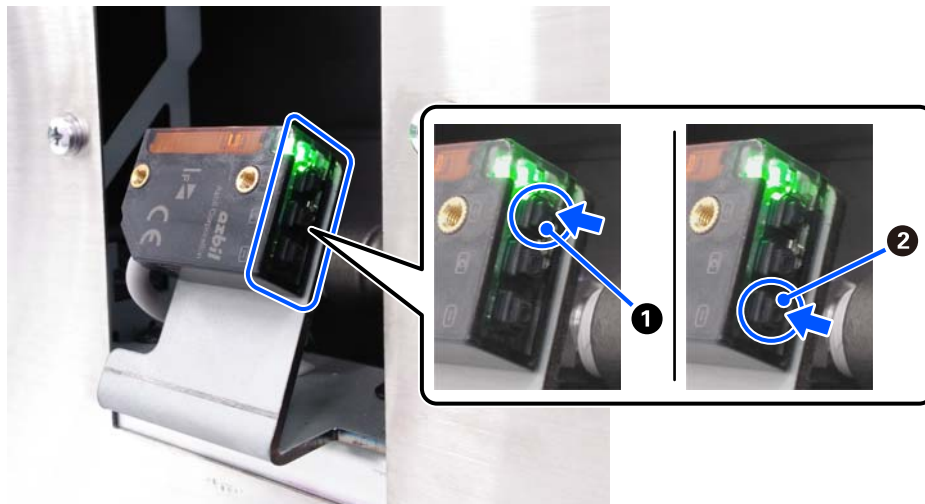
The green lamp will turn on.

Basic Operations

The position of the affixed piece of fabric is set as the reaction position.



- 7** Press the + or - button once and check that the green lamp flashes.

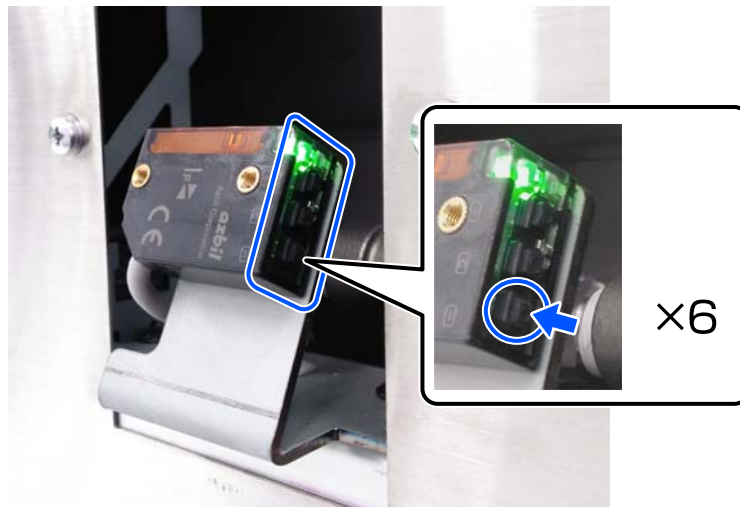


- 1** + Button
- 2** - Button

Basic Operations

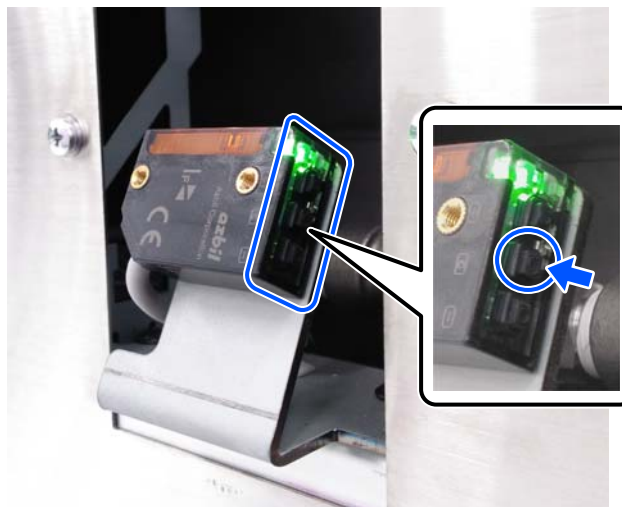
8 Press the - button six times.

Adjust the sensor reaction position.



9 Press the C button.

The green lamp lights up and the sensor reaction position is registered.

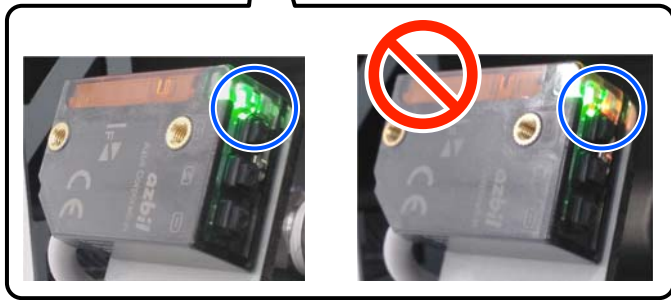
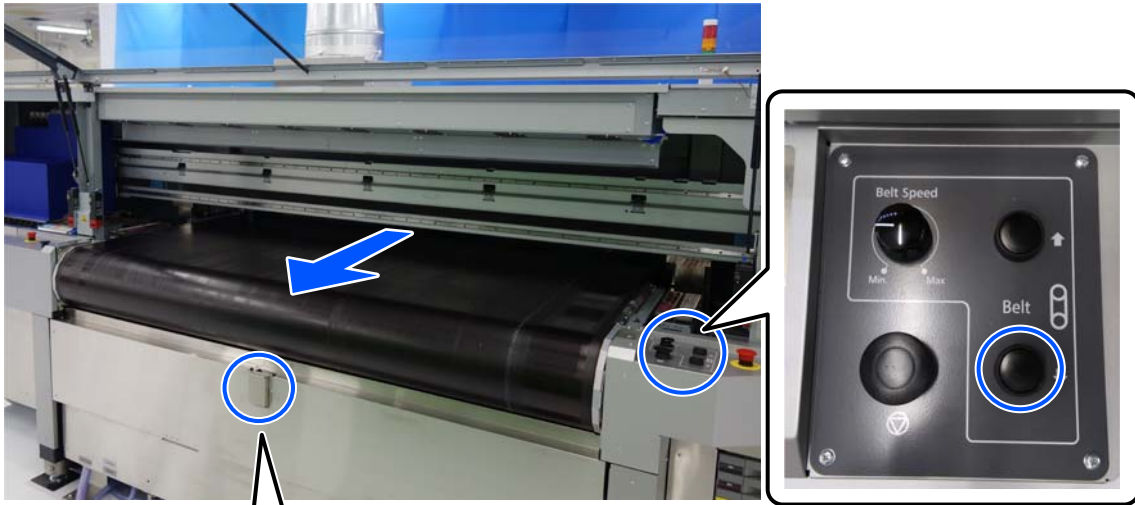


10 Press the feed button on the front panel to circle the belt once.

When the sensor reacts, the orange lamp will light up and the belt will stop.

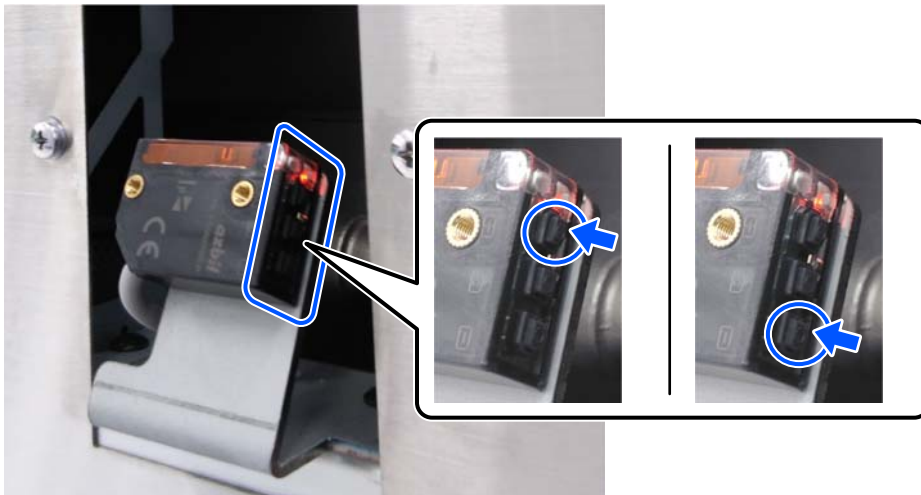
Basic Operations

When the sensor reacts, press and hold the + or - button and repeat the adjustment from Step 3.



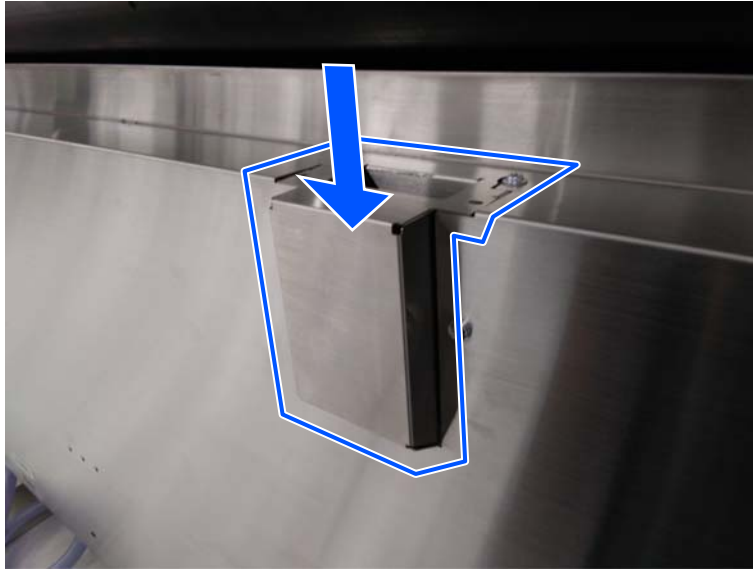
11 Press and hold the + or - button to check the adjustment results.

The orange light flashes three times to complete sensor setup.



Basic Operations

- 12** Install the sensor cover.



- 13** Tighten the two cover screws by hand.



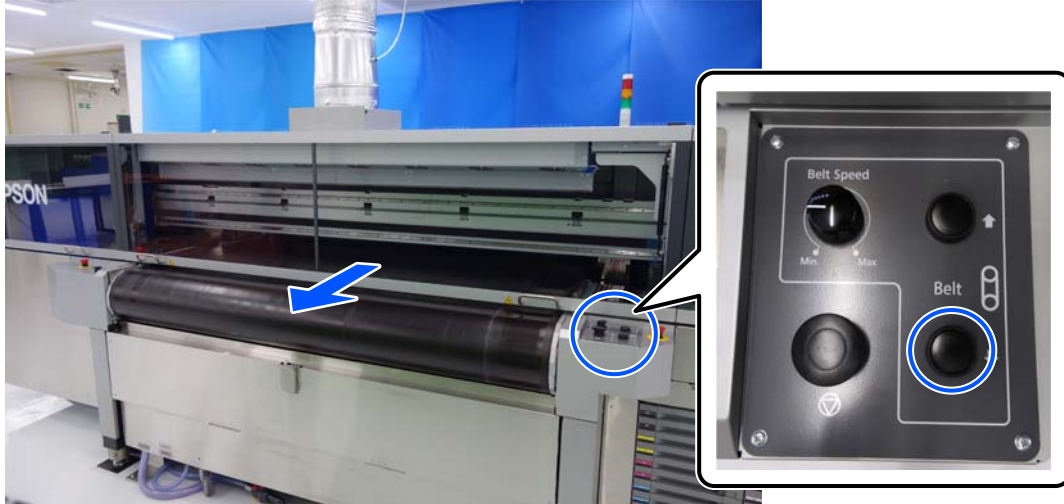
If errors occur frequently even after setting up, follow the instructions below to set up again.

 [“If errors occur frequently” on page 140](#)

Basic Operations

If errors occur frequently

- 1 Press the feed button to feed the belt until it reaches the position where the sensor reacts, and the printer comes to an emergency stop.

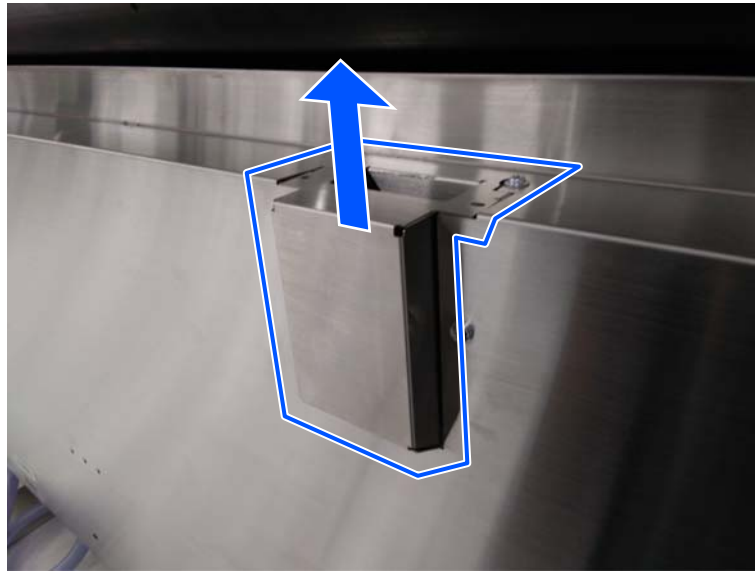


- 2 Loosen and remove the two screws on the top of the sensor cover by hand.

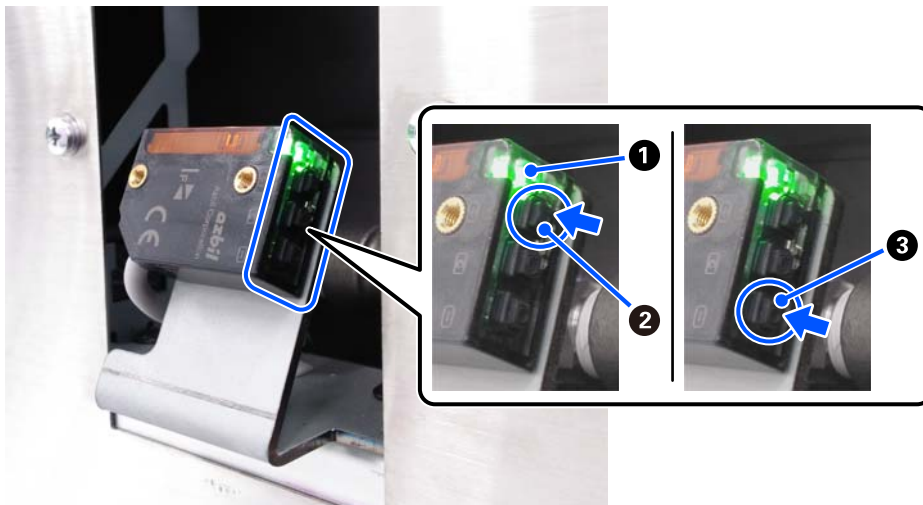


Basic Operations

- 3** Lift up the cover and remove it.



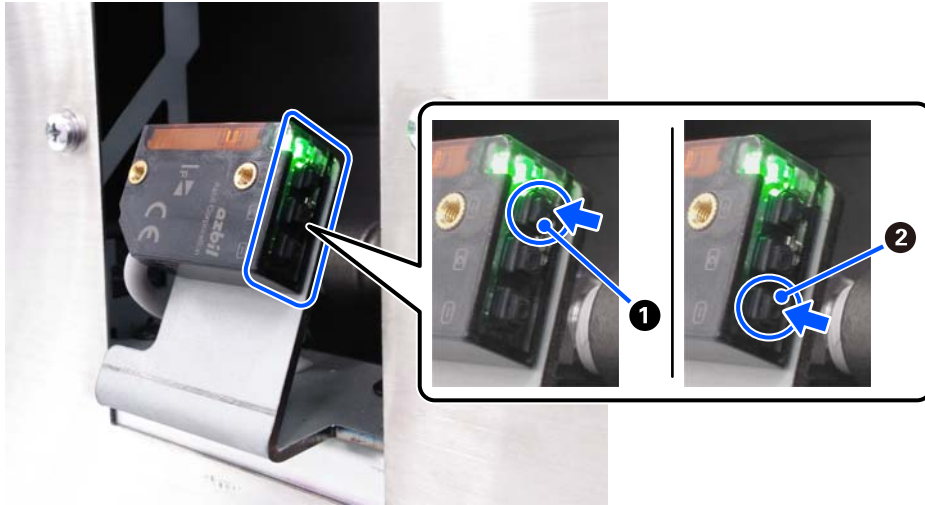
- 4** Press and hold the + or - button on the right of the sensor.
The green light flashes three times to release the lock.



- 1** Green lamp
- 2** + Button
- 3** - Button

Basic Operations

- 5 Press the + or - button once and check that the green lamp flashes.

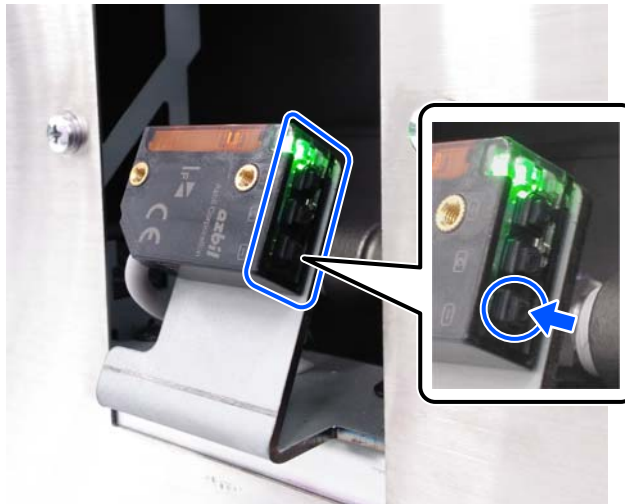


- 1 + Button
- 2 - Button

- 6 Press and release the - button several times until the sensor stops reacting.

When the orange lamp is lit, the sensor is reacting. Pressing the - button once moves the sensor's reaction position 0.5 to 1 mm away.

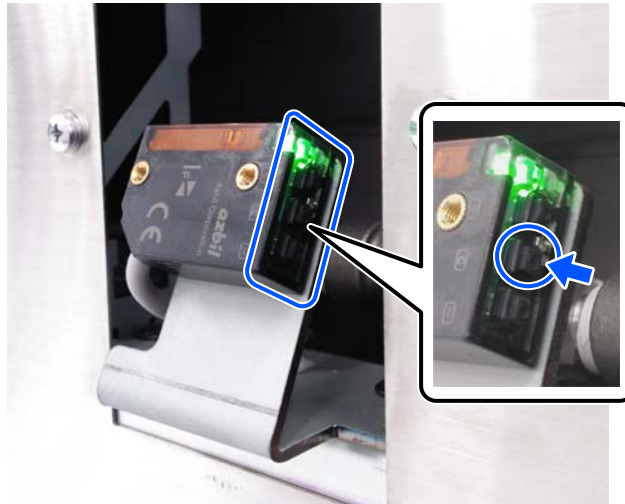
! **Important:**
If the sensor's reaction position is too far away, it may not detect tangled fabric.



Basic Operations

- 7** Press the C button.

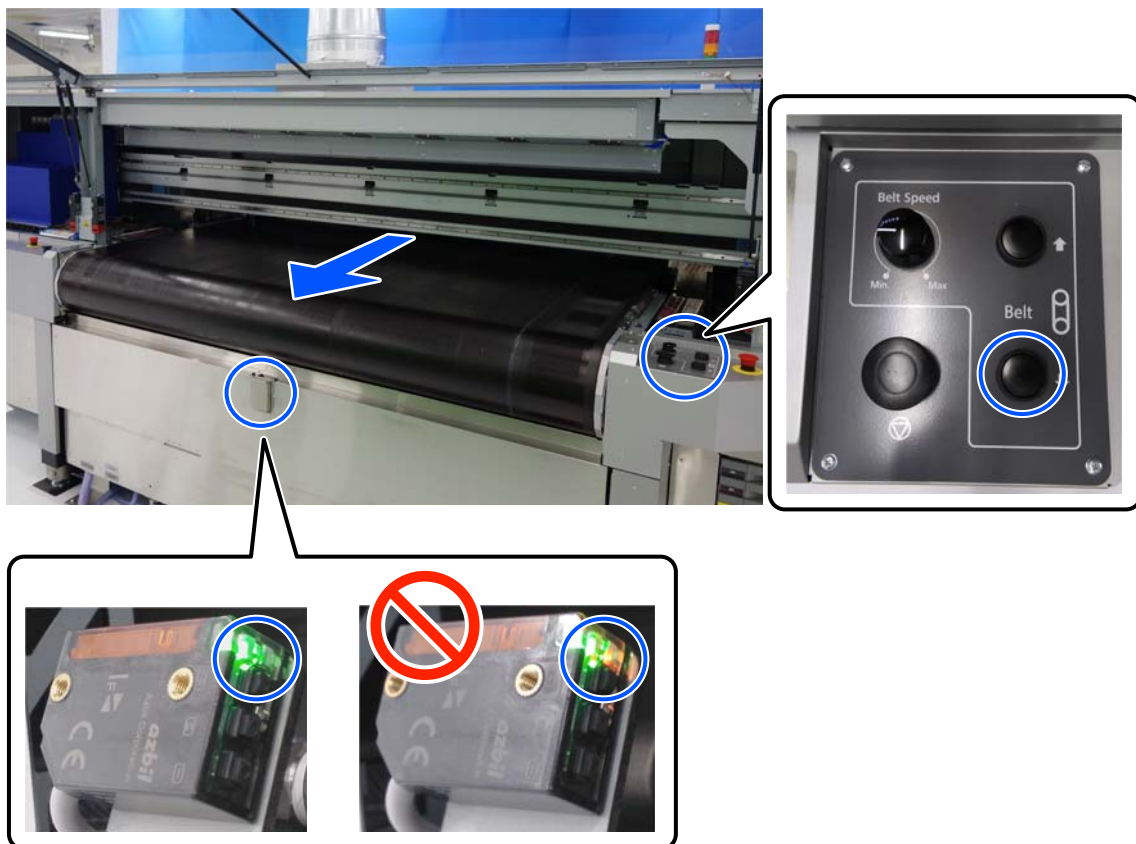
The green lamp lights up and the sensor reaction position is registered.



- 8** Press the feed button on the front panel to circle the belt once.

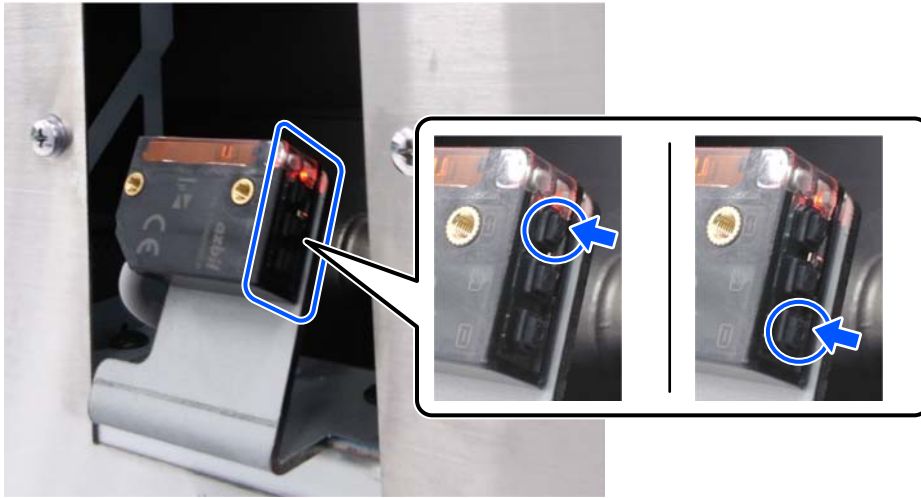
When the sensor reacts, the orange lamp will light up and the belt will stop.

When the sensor reacts, press and hold the + or - button and repeat the adjustment from Step 4.

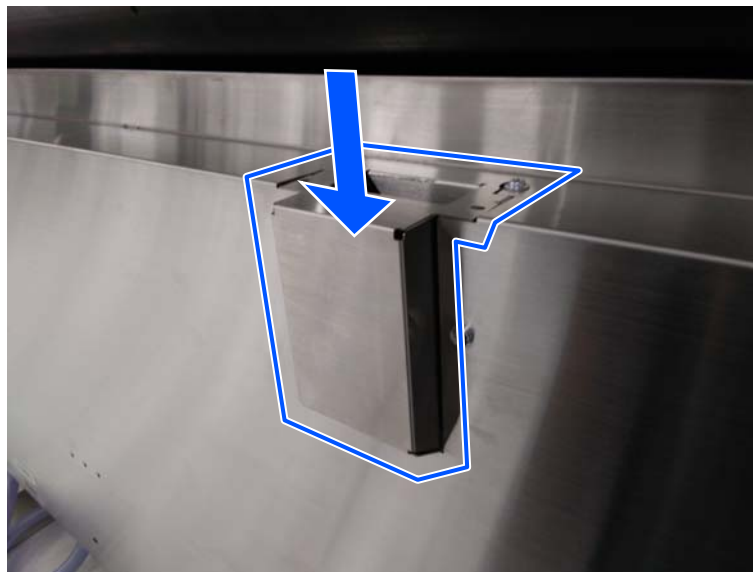


Basic Operations

- 9** Press and hold the + or - button to check the adjustment results.
The orange light flashes three times to complete sensor setup.



- 10** Install the sensor cover.



Basic Operations

- 11** Tighten the two cover screws by hand.



Using the Optional High Tension Feeding Unit

Basic Instructions

The high tension feeding unit allows you to print multiple items of narrow fabric, such as cloths, at the same time.

You can load fabric that meets the following conditions.

- Fabric length : 10 to 16 m
- Fabric width : 30 to 41 cm
- Fabric thickness : 1 mm or less
- Print surface : Can be wound print surface in or out
- Maximum number : 4
of fabric items

Even if each piece of fabric has a different length, width, thickness, print surface, and fabric type, you can load them as long as they meet the conditions. To maintain optimal print quality, we recommend that any differences in fabric thickness do not exceed 0.1 mm.

Workflow

1. Preparing the print data

 ["Preparing the print data" on page 147](#)



Basic Operations

2. Checking the status of the fabric

 ["Checking the Status of the Fabric" on page 147](#)



3. Loading the fabric

 ["Loading the Fabric" on page 147](#)



4. Setting the fabric floating sensor

 ["Setting the fabric floating sensor" on page 155](#)



5. Making print adjustments

 ["Print Adjustments" on page 155](#)



6. Setting fabric information

 ["Setting fabric information" on page 157](#)




7. Setting the print start position

 ["Setting the print start position" on page 157](#)



8. Printing

 ["Printing" on page 157](#)

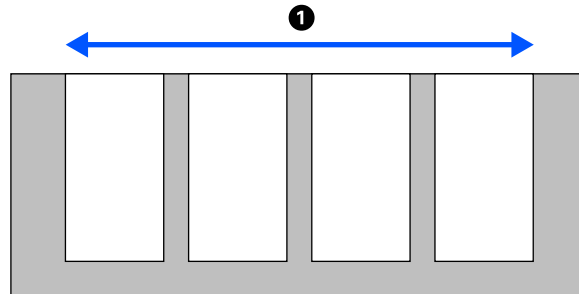
See the following for more information about each procedure.

Basic Operations

Preparing the print data

When printing multiple pieces of fabric at the same time, leave a space of about 50 mm between each piece.

The print data should be larger than the width of all pieces of fabric, including the spacing between each piece (①).



Note:

Use your RIP software to make adjustments if there are any printing misalignments or margins.

Checking the Status of the Fabric


See the following for more information.

[☞ “Checking the Status of the Fabric” on page 55](#)

Loading the Fabric

Required Items

Personal protective equipment (safety shoes), fabric roll, 50 mm wide rubber bands (max. 6)

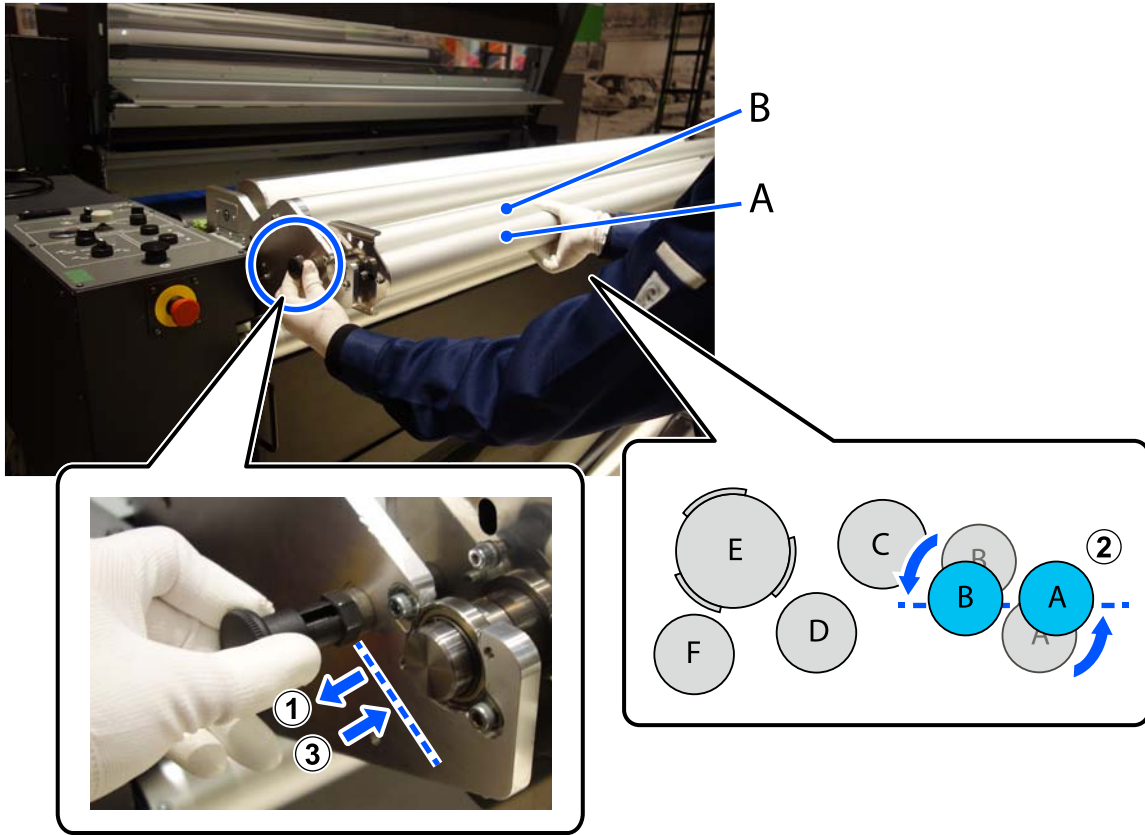
- 1 From the  (menu) button on the control panel, touch **General Settings - Printer Settings**, and then set **Feeding Unit** to **Off**.
- 2 Open the rear cover.



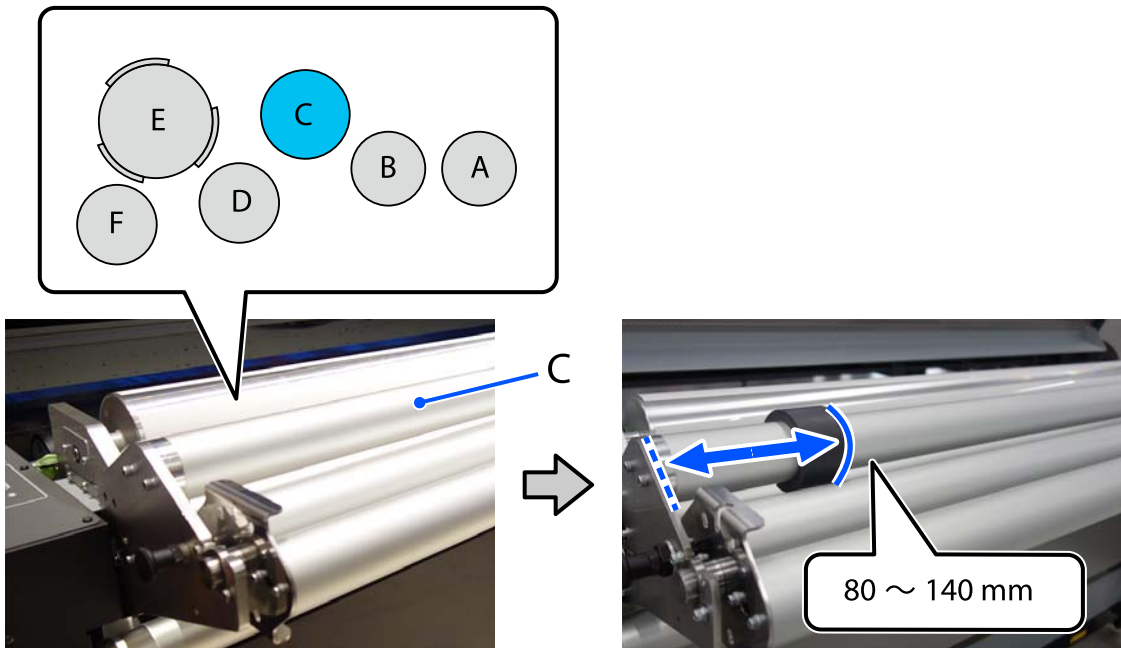
Basic Operations

- 3 While pulling the lock lever for the high tension feeding unit, make rollers A and B even. Return the lock lever to lock rollers A and B.

If rollers A and B do not lock, pull and turn the lock lever to lock them.

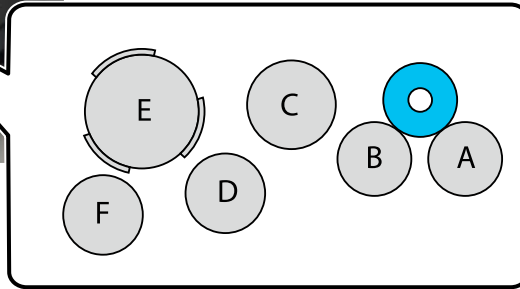
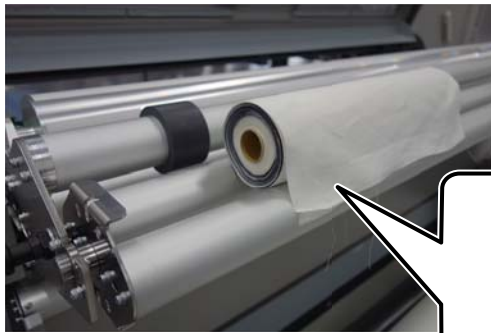


- 4 Attach a rubber band so that the right end of the rubber band is 80 to 140 mm from the left edge of roller C.

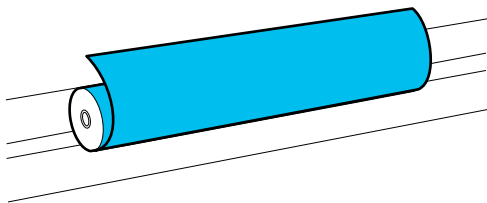


Basic Operations

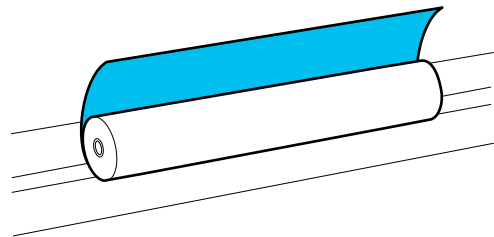
- 5** Place the fabric roll between rollers A and B. The method for loading the fabric roll varies depending on the print surface.



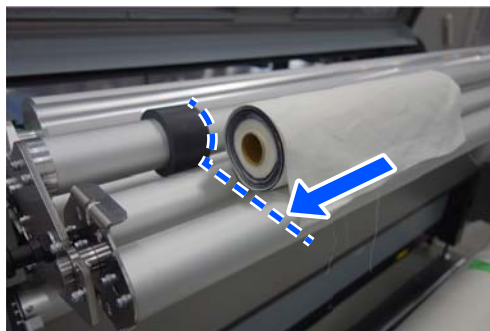
Print surface out



Printable area on the inside of the roll



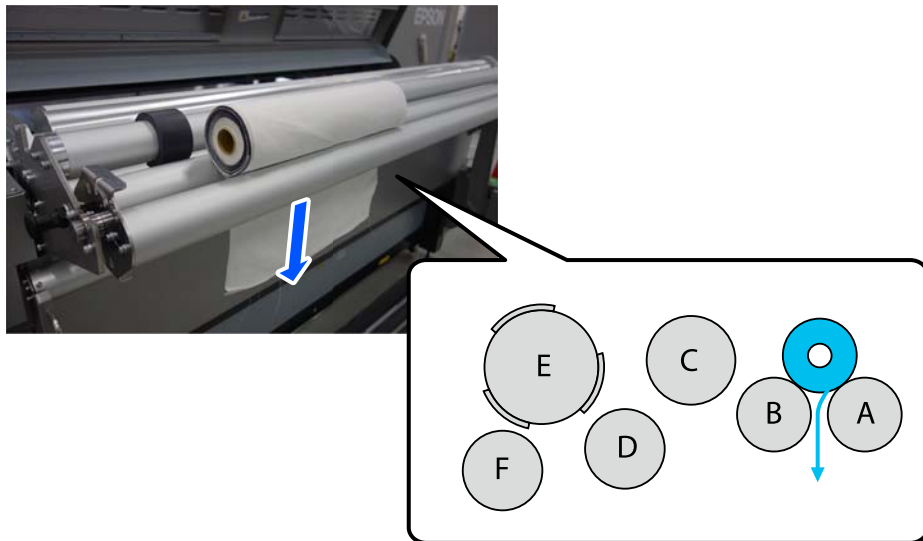
- 6** Align the left edge of the fabric roll with the right end of the rubber band.



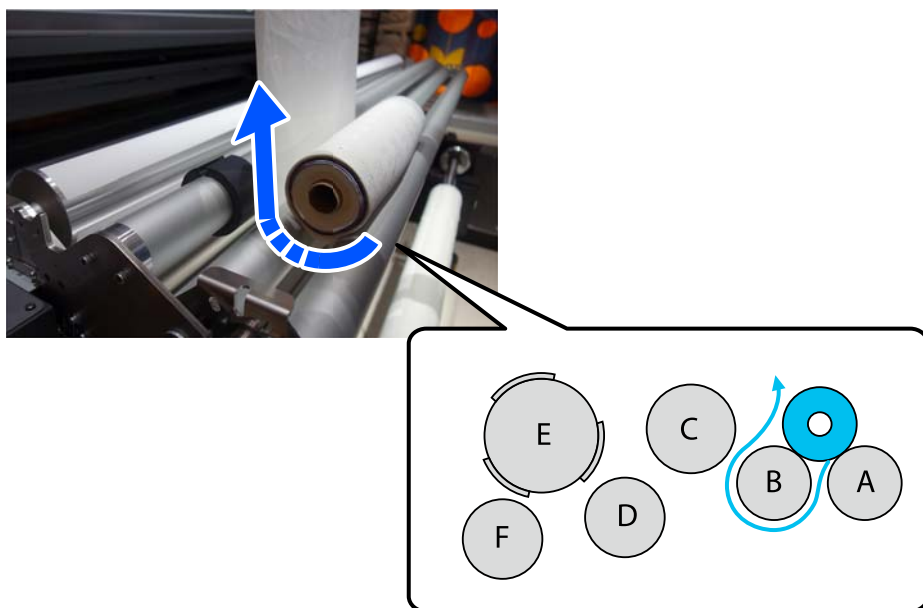
Basic Operations

7 Feed the fabric through the rollers.

- 1 Feed the fabric over the top between rollers A and B.

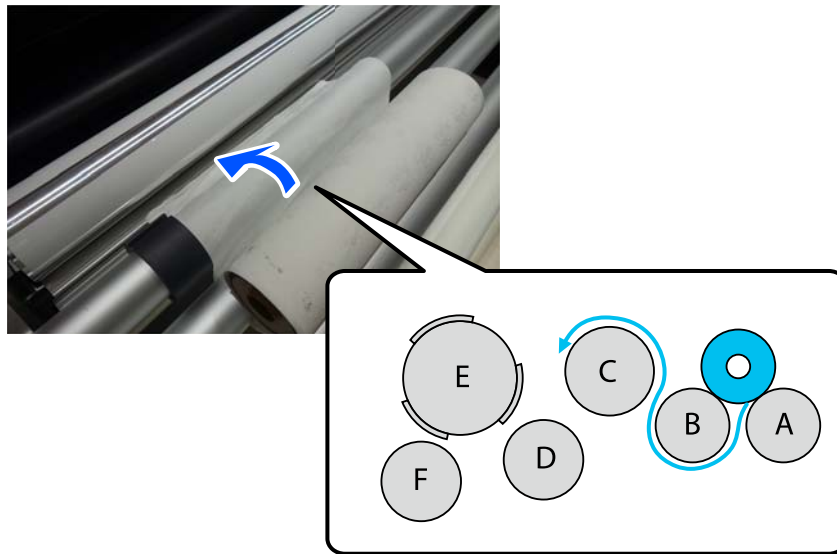


- 2 Feed the fabric between rollers B and C.

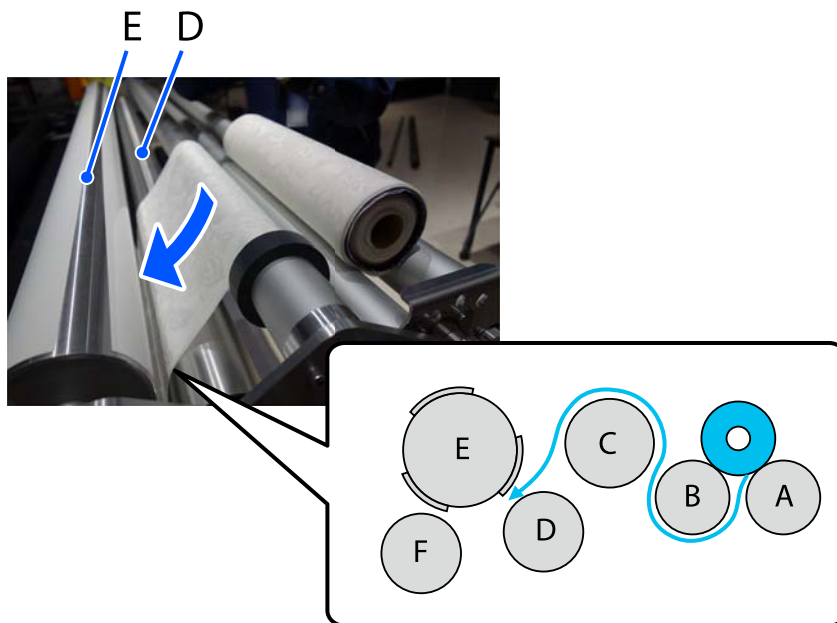


Basic Operations

- ③ Feed the fabric over roller C.

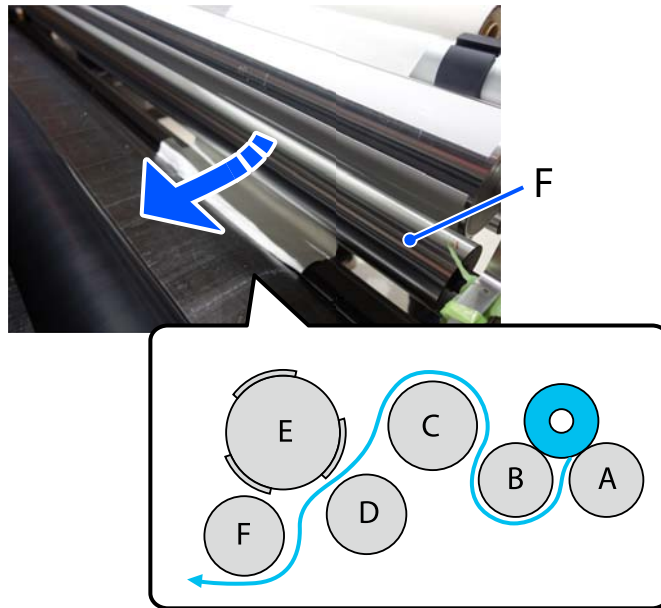


- ④ Feed the fabric between roller D and tension roller E.

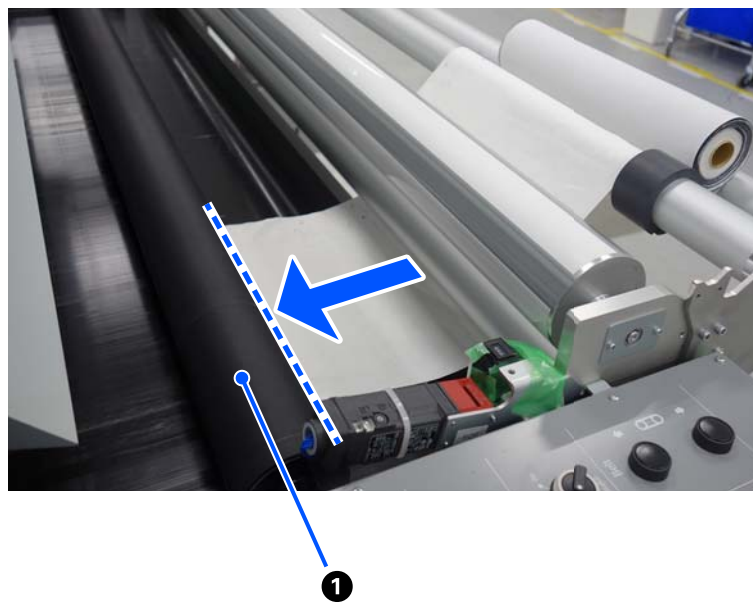


Basic Operations

- ⑤ Feed the fabric between roller F and the belt.



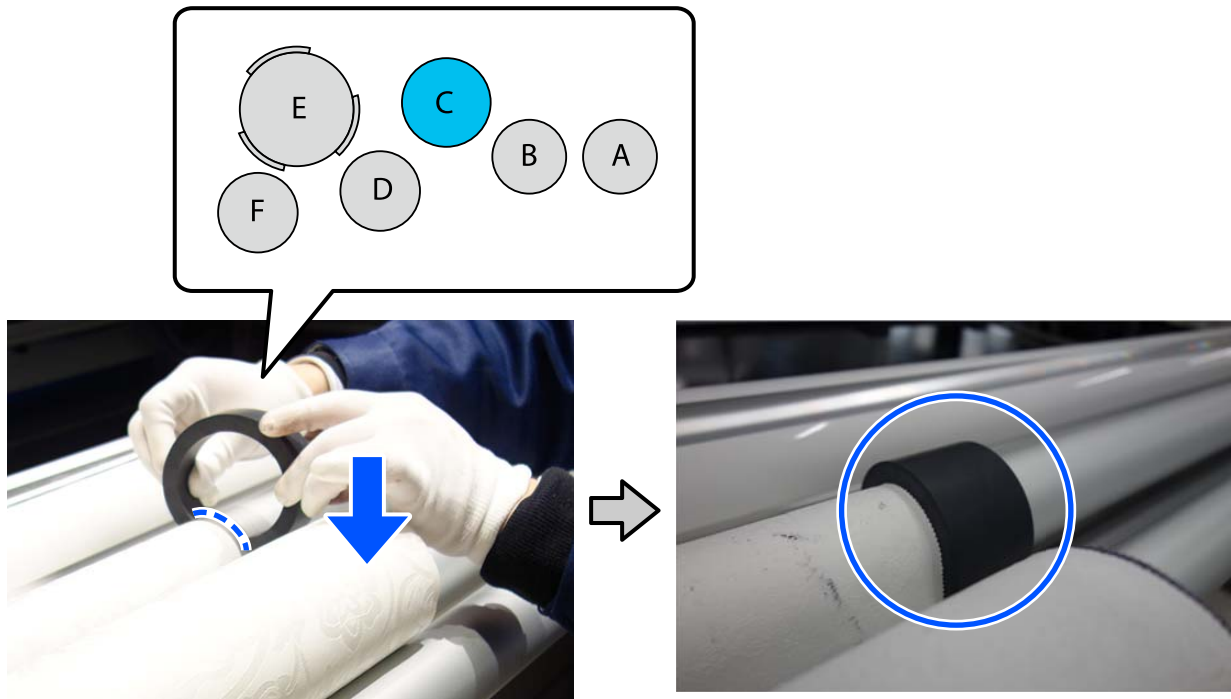
- 8 Pull the fabric out to the front of the heated pressure roller (①).



- 9 Smooth out any curls or wrinkles in the fabric.

Basic Operations

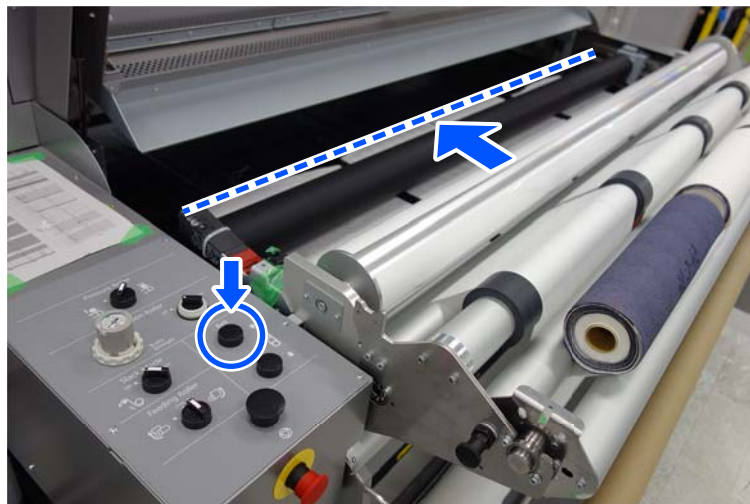
- 10** Attach a rubber band to roller C. Attach the rubber band to the right edge of the fabric so that there are no gaps, and the rubber band does not overlap the fabric.



- 11** See steps 6 to 10 when loading multiple pieces of fabric.
When all pieces of fabric are loaded, go to step 12.

- 12** Press and hold the feed button on the rear panel for several seconds to feed the fabric.
By continuing to feed the fabric, you can correct any skew of the fabric until it is straight.

If the fabric is still skewed after completely feeding the loose fabric, continue pressing the feed button until it is straight.



Basic Operations


- 13 Close the rear cover.



- 14 Turn the pressure roller switch on the rear panel.

The heated pressure roller lowers and moves back and forth, applying pressure to the fabric to attach it to the belt.



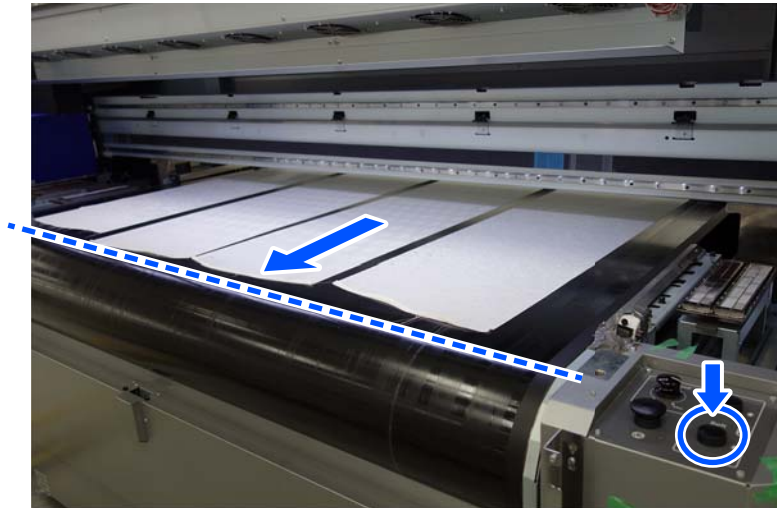
- 15 Press the feed button on the front panel ( in Belt) to feed the fabric to the front of the printer using the position shown in the photo as a guide.



Important:

To start printing without attaching the fabric to the drying unit or reel, feed the fabric to the printing position.

Basic Operations



- 16** Peel the tip of the fabric from the belt.
Make sure the fabric does not get caught in the belt cleaning tank.
- 17** While peeling the fabric from the belt, press the Feed button to feed the fabric.
Pull out the fabric until it is long enough to be loaded in the drying unit or reel.
- 18** Load the fabric in the drying unit or reel.
For instructions on using the drying unit or reel, see the manual supplied with the drying unit or reel.

Setting the fabric floating sensor

See the following for more information.

 [“Setting the Fabric Wrinkle Detection Sensor” on page 89](#)

Print Adjustments

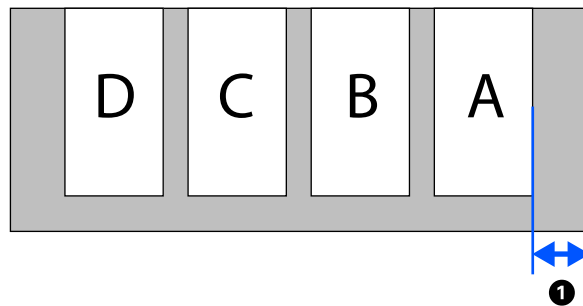
In the following situations, make print adjustments before printing.

- Using new fabric not registered to the printer
- When banding (horizontal band-shaped patterns, uneven shading, or stripes) or graininess is observed in the print result
- When the fabric type is the same but the width is different

The method for measuring the print width varies depending on the number of pieces of fabric loaded.

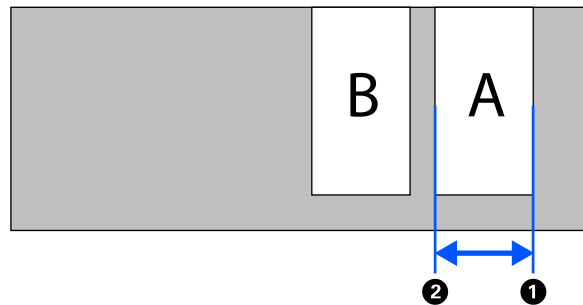
Basic Operations

- 1 When viewing from the front of the printer, use a tape measure or a ruler to measure the distance from the right edge of the belt to the right edge (A) of the fabric (①) at the far right.

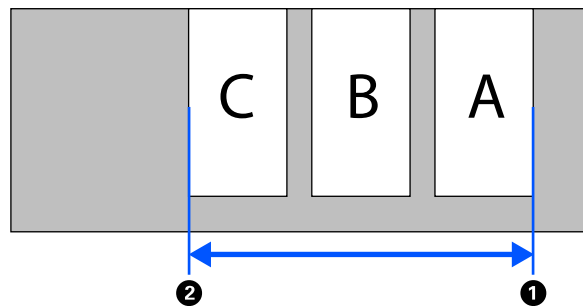


- 2 Measure the distance from the print start position (①) to (②) according to the method for measuring the print width for the number of pieces of fabric loaded.

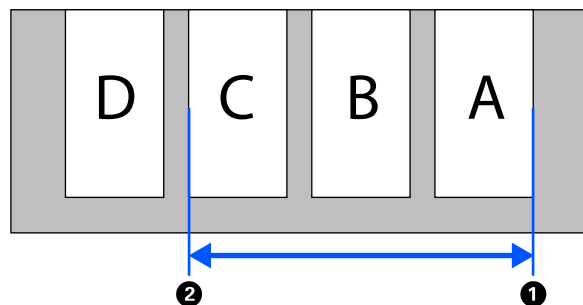
When loading two pieces of fabric




When loading three pieces of fabric



When loading four pieces of fabric



- 3 Set the values for the print start position (①) and print width (②) by touching **General Settings - Printer Settings** from the  (menu) button on the control panel and entering them in **Print Start Position** and **Print Width**.

Basic Operations

4 Make print adjustments.

See the following for each adjustment procedure for “Print Adjustments”.

 [“Automatic Adjustment” on page 112](#)

 [“Print Head Alignment \(Manual\)” on page 114](#)

 [“Fabric Feed Adjustment \(Manual\)” on page 116](#)

5 When you have finished making print adjustments, change the print width to the setting used when printing.

 [“General Settings Menu” on page 434](#)

Setting fabric information

When the thickness of the loaded fabric pieces differs, set the printer to the thickness of the thickest fabric.

See the following for more information.

 [“Setting Fabric Information” on page 88](#)


Setting the print start position

See the following for more information.

 [“Setting the Print Start Position” on page 90](#)

Printing

See the following for more information.

 [“Printing” on page 91](#)

Problems during basic use

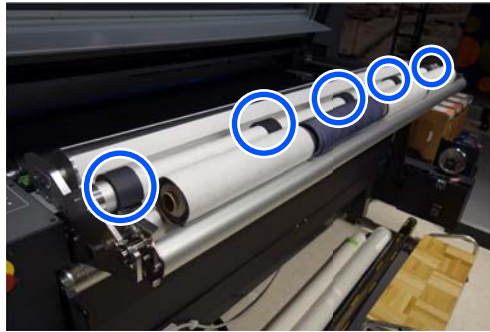
If the fabric shifts during printing

If the fabric shifts during printing, secure both ends of the fabric by attaching a 25 mm wide rubber band. Follow the steps below to attach the bands.

Required Items	25 mm wide rubber bands (max. 8), protective tape or cable ties (max. 8)
1 Press the Pause button on the control panel.	
Stops printing.	

Basic Operations

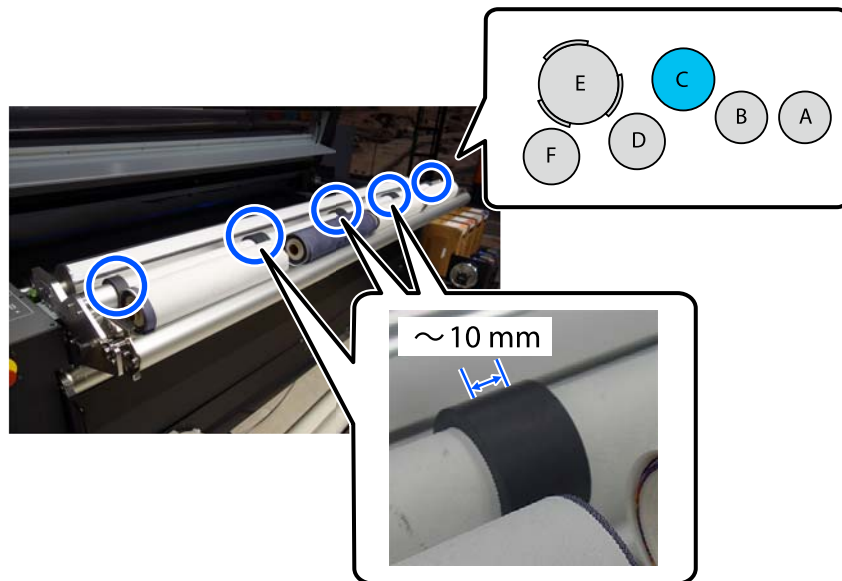
- 2 Remove all 50 mm wide rubber bands attached to the high tension feeding unit.



- 3 Adjust the position of each piece of fabric.

- 4 Attach one 25 mm wide rubber band to each end of the fabric on roller C so there are no gaps, and the rubber bands do not overlap the fabric.

To avoid exceeding the maximum print width, make sure the distance between the rubber bands attached between the pieces of fabric is 10 mm or less.



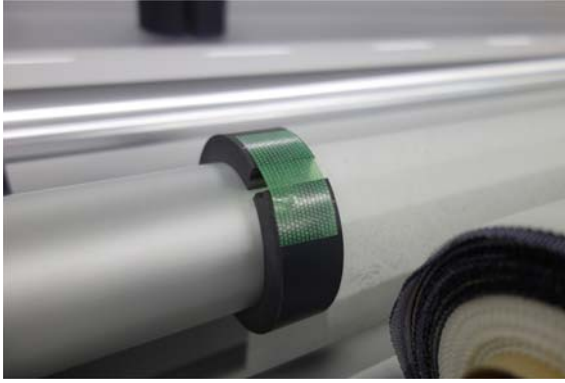
- 5 Secure the rubber bands to the roller.

Apply protective tape to any cracks in the rubber bands or use cable ties to secure them in place.

When using protective tape

When using cable ties

Basic Operations



Other Instructions

As well as printing multiple items of narrow fabric, such as cloths, at the same time, you can also use the high tension feeding unit for the following purposes.

- Print by smoothing out wrinkles and curls in the fabric

The high tension feeding unit reduces wrinkles and curls. See the following if the fabric wrinkles or curls up during normal printing.

 [“When you want to print by smoothing out wrinkles and curls in the fabric” on page 159](#)

- Easily load fabric and print

You can print easily by loading the fabric in the high tension feeding unit instead of the feeding unit. See the following to easily load fabric and print when using trial color combinations, and so on.



Important:

When loading fabric using this method, they may wrinkle, curl up, or skew. To maintain print quality, use the feeding unit to load the fabric.

 [“When you want to easily load fabric and print” on page 170](#)

When you want to print by smoothing out wrinkles and curls in the fabric

You can load fabric that meets the following conditions.

Fabric roll diameter	:	40 cm or less
Fabric roll weight	:	100 kg or less
Fabric width	:	30 to 185 cm
Fabric thickness	:	5 mm or less
Print surface	:	Can be wound print surface in or out

Basic Operations

Workflow

1. Checking the status of the fabric

 ["Checking the Status of the Fabric" on page 161](#)



2. Loading the fabric

 ["Loading the Fabric" on page 161](#)



3. Setting the fabric floating sensor

 ["Setting the fabric floating sensor" on page 170](#)



4. Making print adjustments

 ["Print Adjustments" on page 170](#)



5. Setting fabric information

 ["Setting fabric information" on page 170](#)




6. Setting the print start position

 ["Setting the print start position" on page 170](#)



7. Printing

 ["Printing" on page 170](#)

See the following for more information about each procedure.

Basic Operations


Checking the Status of the Fabric

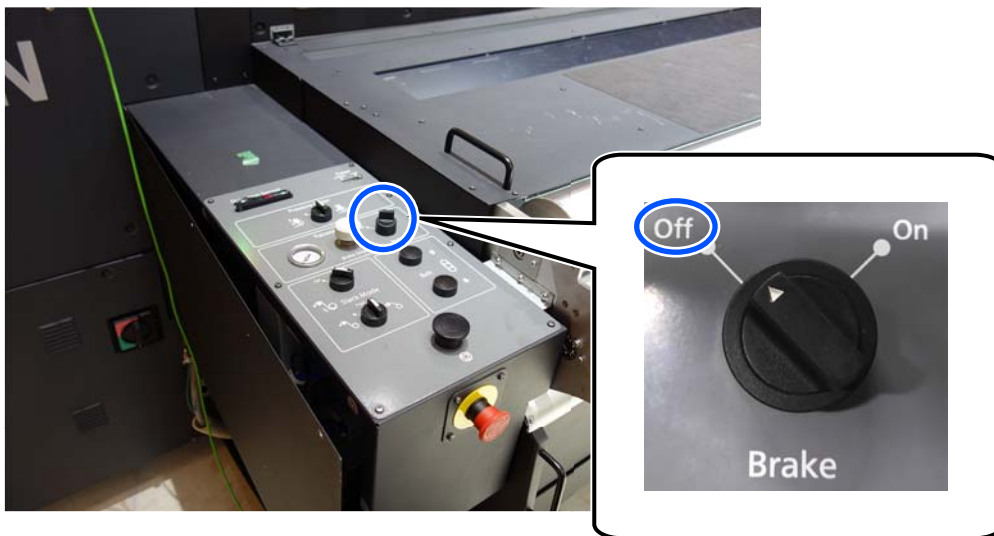
See the following for more information.

[☞ “Checking the Status of the Fabric” on page 55](#)

Loading the Fabric

Required Items	Fabric roll
----------------	-------------

- 1 From the  (menu) button on the control panel, touch **General Settings - Printer Settings**, and then set **Feeding Unit** to **On**.
- 2 Make sure that the tension switch (Brake) on the rear panel is set to Off.



- 3 Open the rear cover.



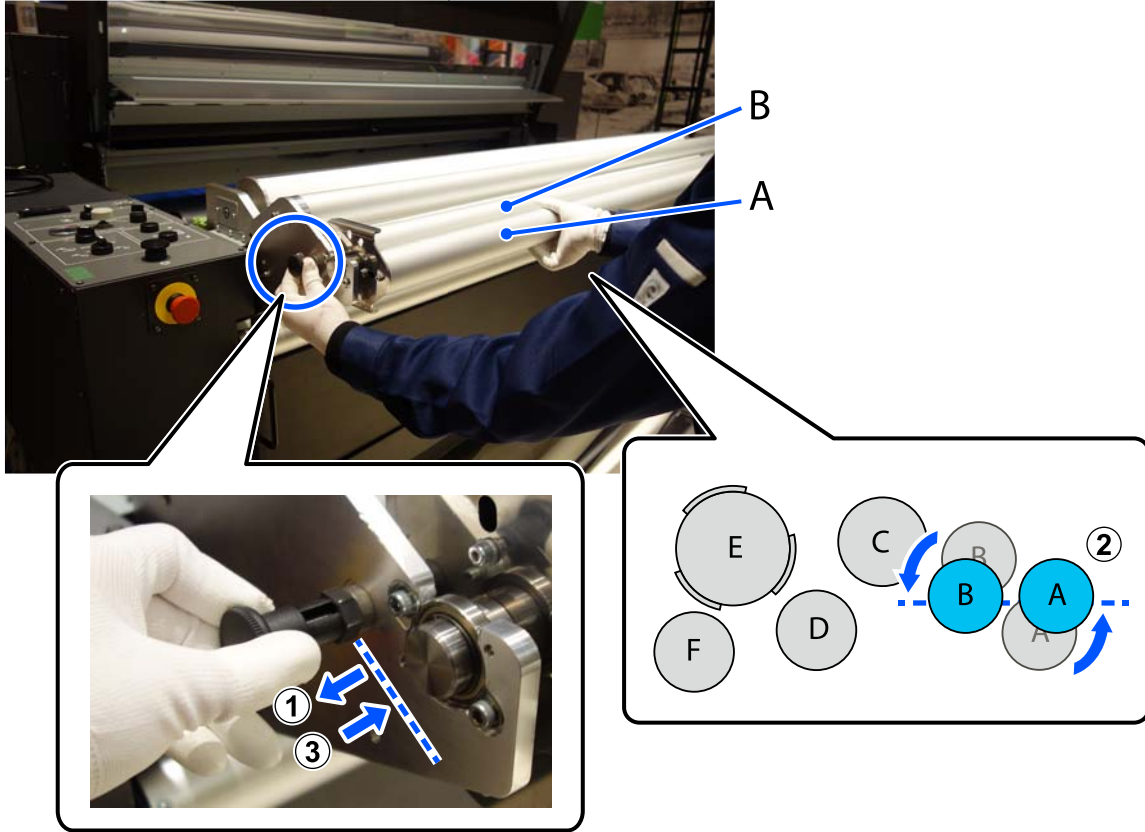
- 4 Attach the fabric roll to the feeding spindle.

[☞ “Installing the Fabric Roll” on page 56](#)

Basic Operations

- 5 While pulling the lock lever for the high tension feeding unit, make rollers A and B even. Return the lock lever to lock rollers A and B.

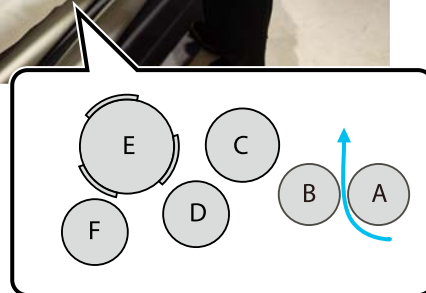
If rollers A and B do not lock, pull and turn the lock lever to lock them.



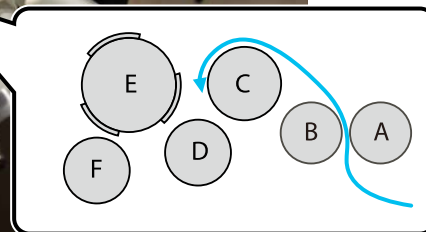
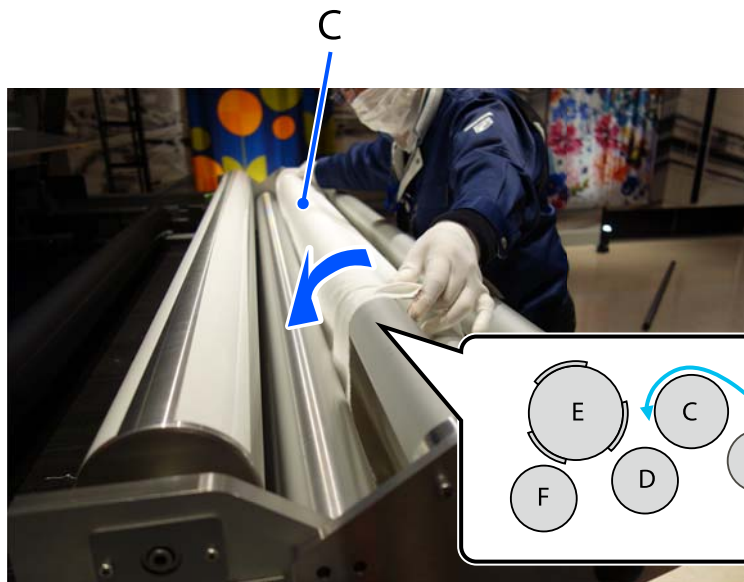
Basic Operations

6 Feed the fabric through the rollers.

① Feed the fabric between rollers A and B from below.

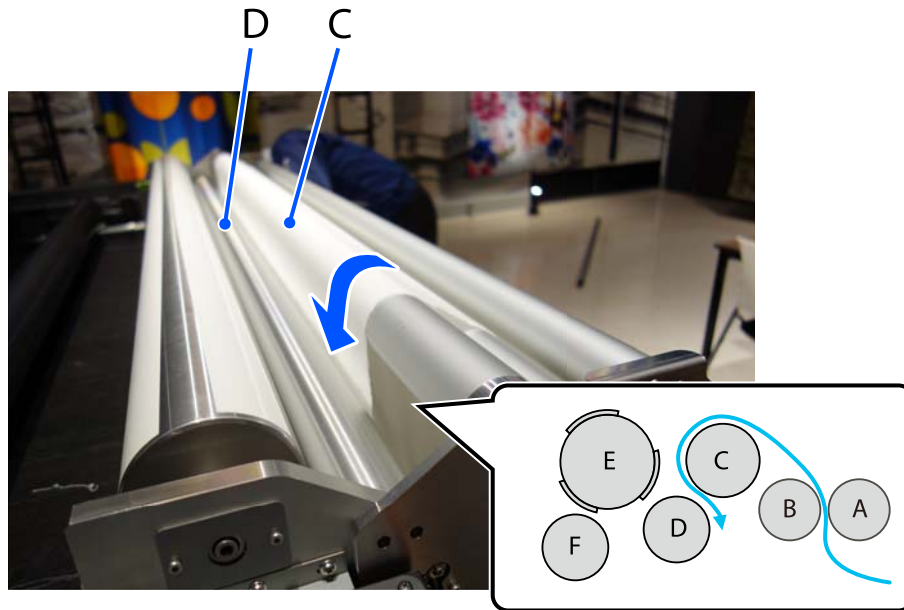


② Feed the fabric over roller C.

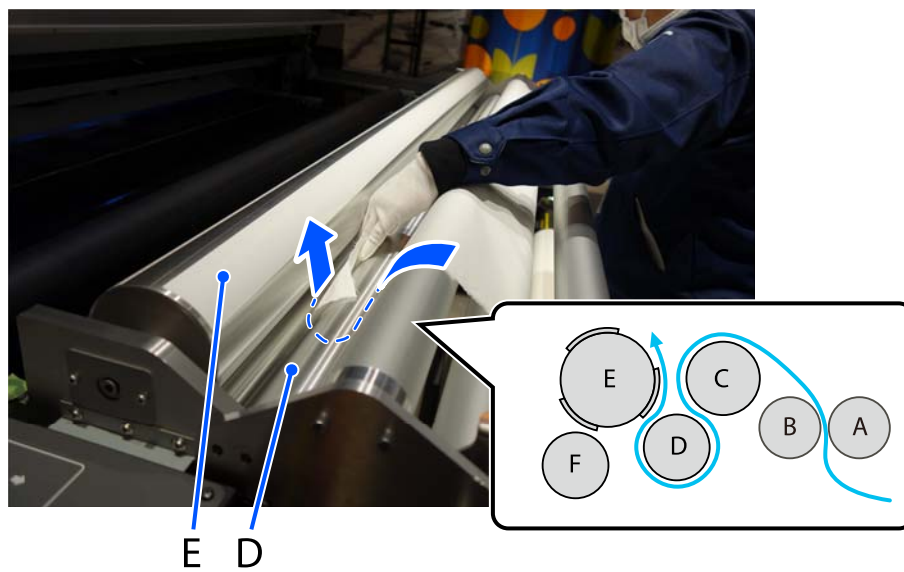


Basic Operations

- ③ Feed the fabric between C and D.



- ④ Feed the fabric between roller D and tension roller E from below.

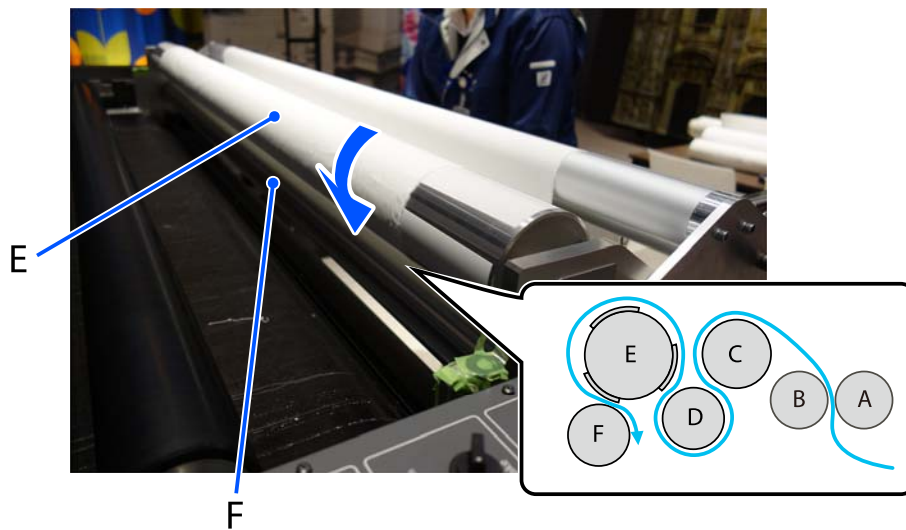


Basic Operations

- ⑤ Feed the fabric over tension roller E.

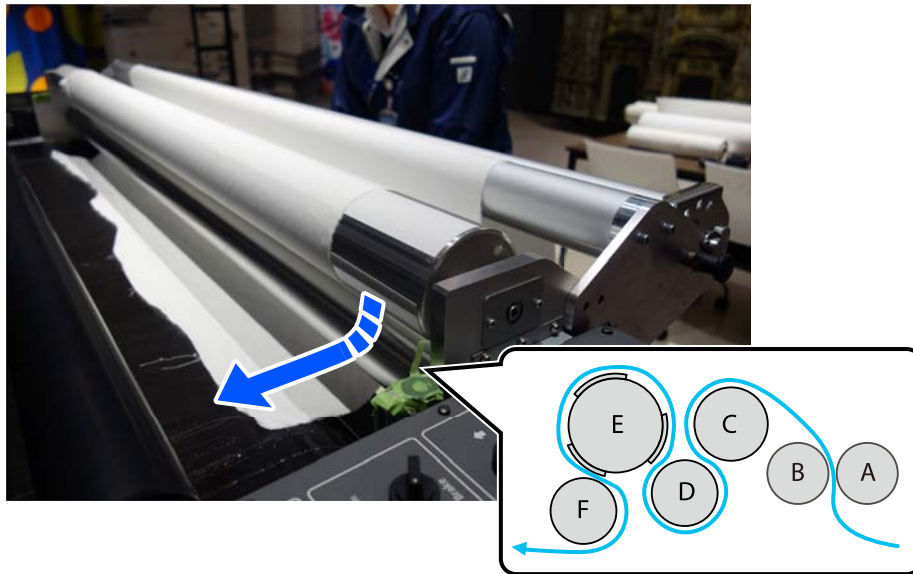


- ⑥ Feed the fabric between tension roller E and roller F.



Basic Operations

- ⑦ Feed the fabric between roller F and the belt.



- ⑧ Pull the fabric out to the front of the heated pressure roller (1).



Basic Operations

- 7 Attach the leading edge of the fabric to the belt by hand. Make sure the fabric does not lift or wrinkle when attaching it to the belt.



- 8 Rotate tension roller E once toward the front of the printer to loosen the fabric wrapped around the tension roller.



- 9 Set the tension switch on the rear panel to On.

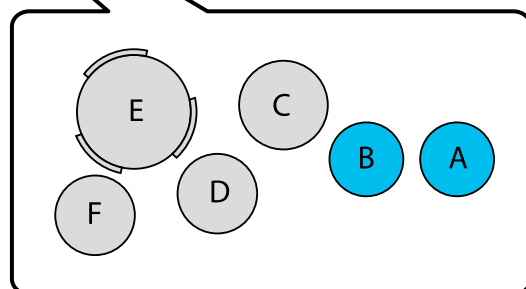
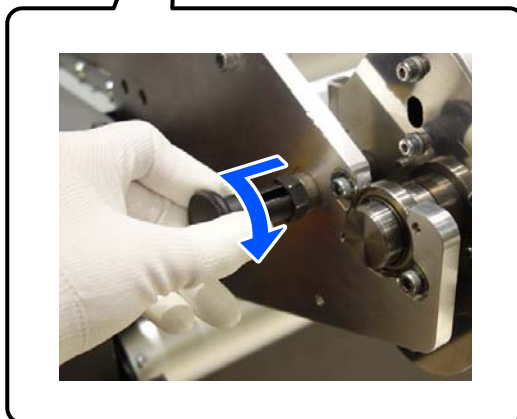
The tension roller is locked, making it hard for the fabric passing through the rollers to come off.

Basic Operations



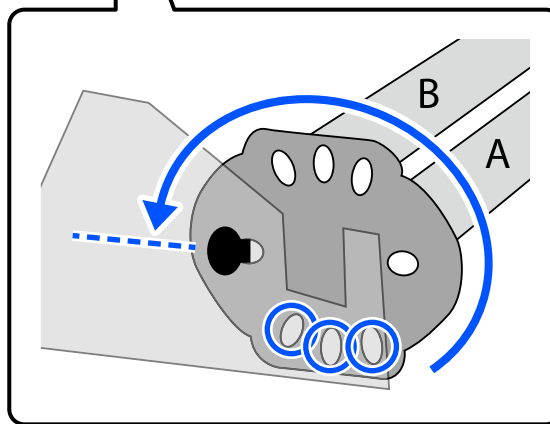
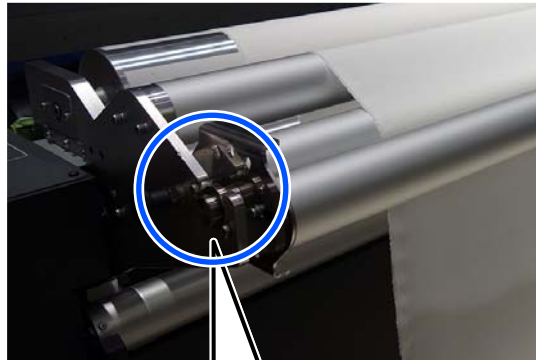
10 Adjust the tension applied to the fabric.

- ① Pull and turn the high tension feeding unit lock lever to unlock rollers A and B.

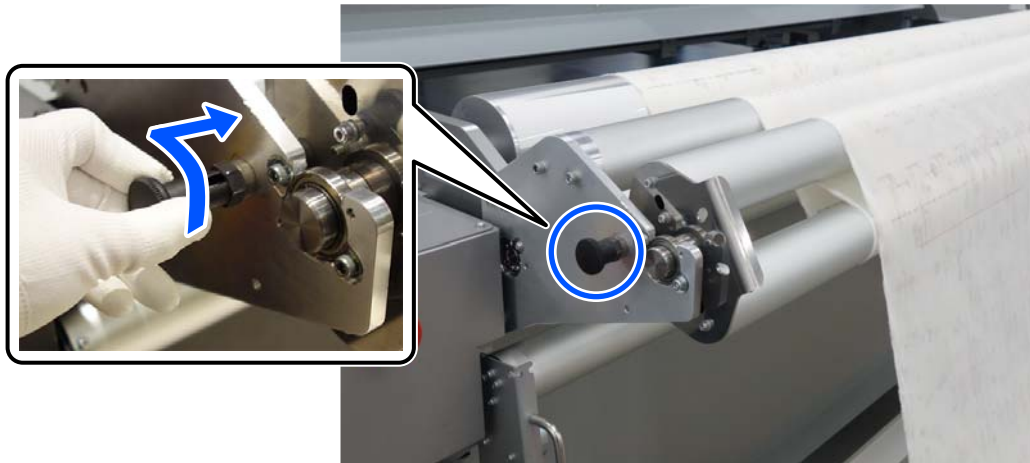


Basic Operations

- ② Turn rollers A and B in the direction of the arrows, align each of the three holes on the left end of the rollers with the position of the lock lever, and select the position that applies the appropriate tension.



- ③ Turn the lock lever to lock rollers A and B.



11

Smooth out any curls or wrinkles in the fabric.

Note:

When loading a large roll of fabric, the feeding spindle may rotate under the weight, causing the fabric to sag and making it difficult to correct tension, wrinkles, and curls in the fabric. In this situation, turn the feeding roller switch to the left or right to lock the feeding spindle. Once you have corrected any tension, wrinkles, and curls in the fabric, return the feeding roller switch to the center to unlock it.

Basic Operations

12 For the rest of the procedure, start from step 8 below.

 [“Apply tension to the fabric and load it” on page 63](#)

Setting the fabric floating sensor

See the following for more information.

 [“Setting the Fabric Wrinkle Detection Sensor” on page 89](#)

Print Adjustments

In the following situations, make print adjustments before printing.

- Using new fabric not registered to the printer
- When banding (horizontal band-shaped patterns, uneven shading, or stripes) or graininess is observed in the print result
- When the fabric type is the same but the width is different

See the following for more information.

 [“Print Adjustments” on page 111](#)

Setting fabric information

See the following for more information.

 [“Setting Fabric Information” on page 88](#)


Setting the print start position

See the following for more information.

 [“Setting the Print Start Position” on page 90](#)

Printing

See the following for more information.

 [“Printing” on page 91](#)

When you want to easily load fabric and print

You can load fabric that meets the following conditions.

Fabric roll diameter : 20 cm or less

Fabric roll weight : 30 kg or less

Fabric width : 30 to 185 cm

Fabric thickness : 5 mm or less

Basic Operations

Print surface : Can be wound print surface in or out

Note:

When loading fabric using this method, they may wrinkle, curl up, or skew. To maintain print quality, use the feeding unit to load the fabric.

Workflow

1. Checking the status of the fabric

 ["Checking the Status of the Fabric" on page 172](#)



2. Loading the fabric

 ["Loading the Fabric" on page 172](#)



3. Setting the fabric floating sensor

 ["Setting the fabric floating sensor" on page 180](#)



4. Making print adjustments

 ["Print Adjustments" on page 180](#)



5. Setting fabric information

 ["Setting fabric information" on page 180](#)



6. Setting the print start position

 ["Setting the print start position" on page 180](#)



Basic Operations

7. Printing

 "Printing" on page 180


See the following for more information about each procedure.

Checking the Status of the Fabric

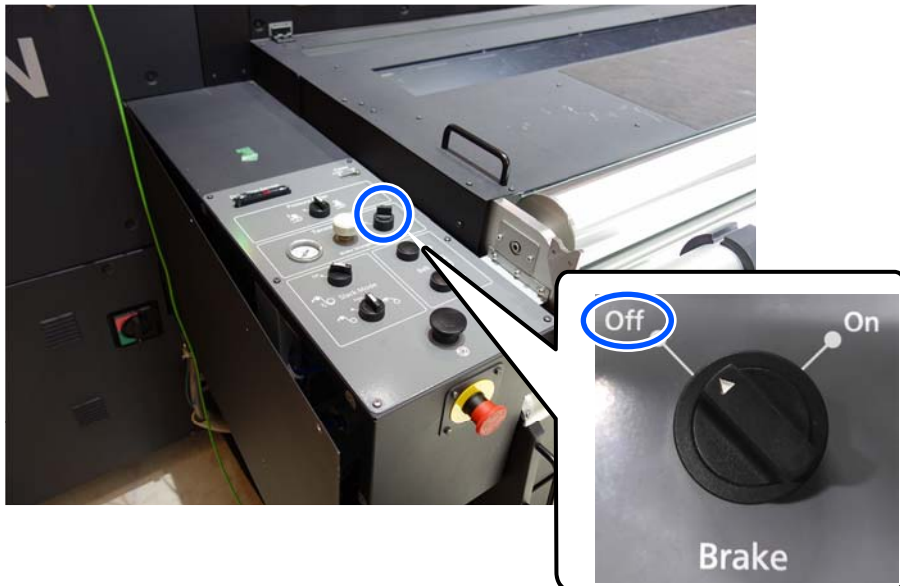
See the following for more information.

 "Checking the Status of the Fabric" on page 55

Loading the Fabric

1 From the  (menu) button on the control panel, touch **General Settings - Printer Settings**, and then set **Feeding Unit** to **Off**.

2 Make sure that the tension switch (Brake) on the rear panel is set to Off.



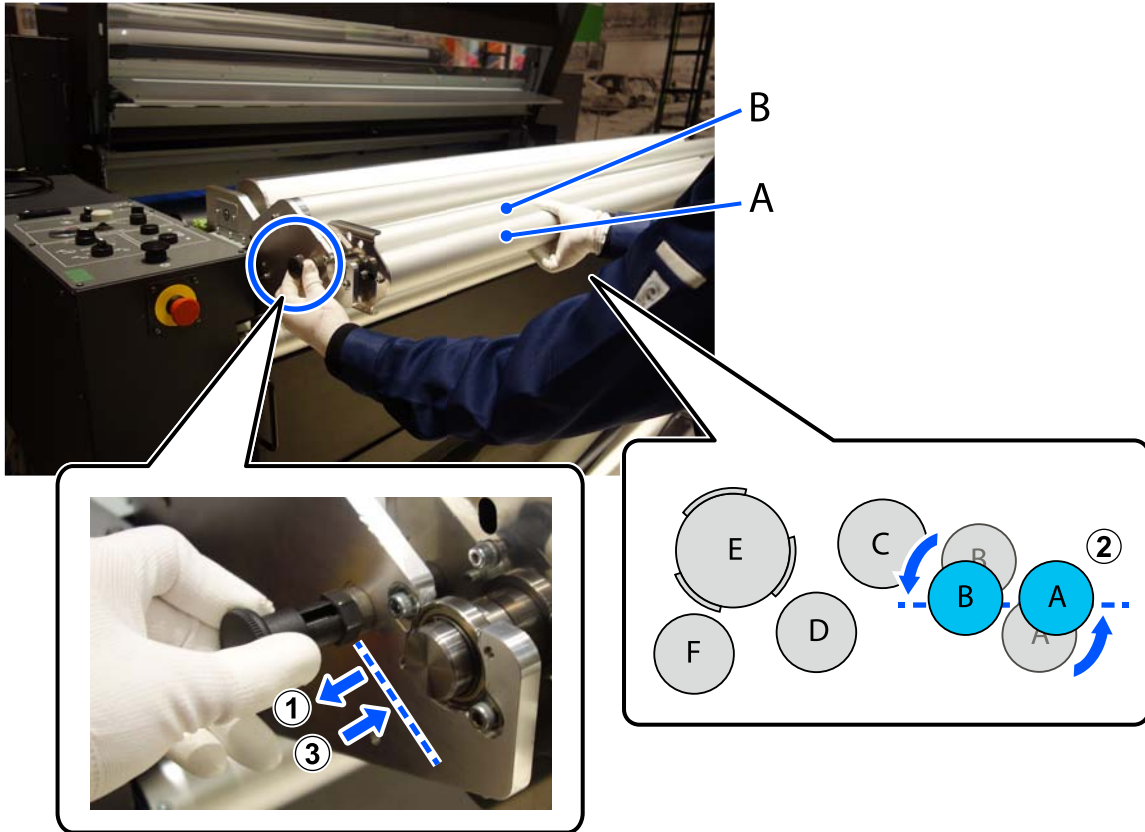
3 Open the rear cover.



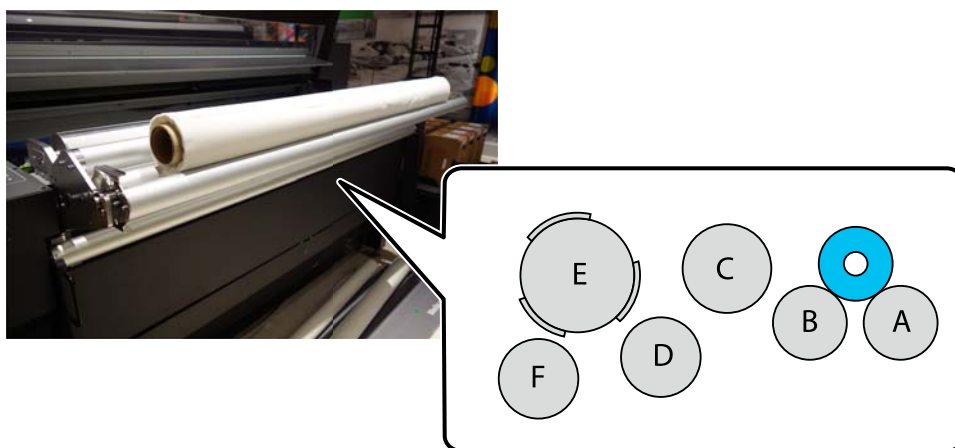
Basic Operations

- 4** While pulling the lock lever for the high tension feeding unit, make rollers A and B even. Return the lock lever to lock rollers A and B.

If rollers A and B do not lock, pull and turn the lock lever to lock them.



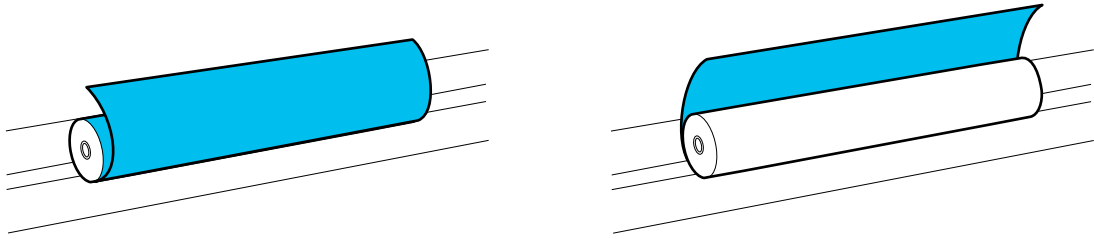
- 5** Place the fabric roll between rollers A and B. The method for loading the fabric roll varies depending on the print surface.



Print surface out

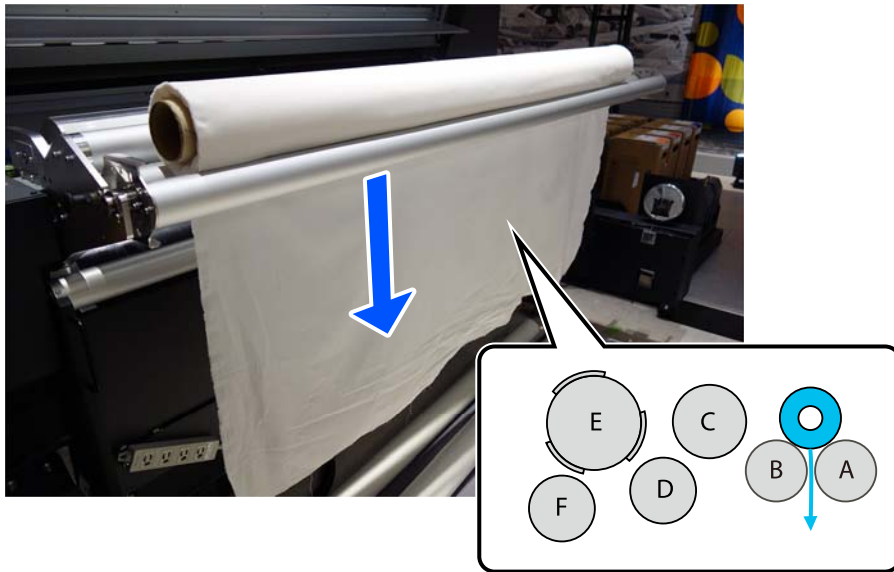
Printable area on the inside of the roll

Basic Operations



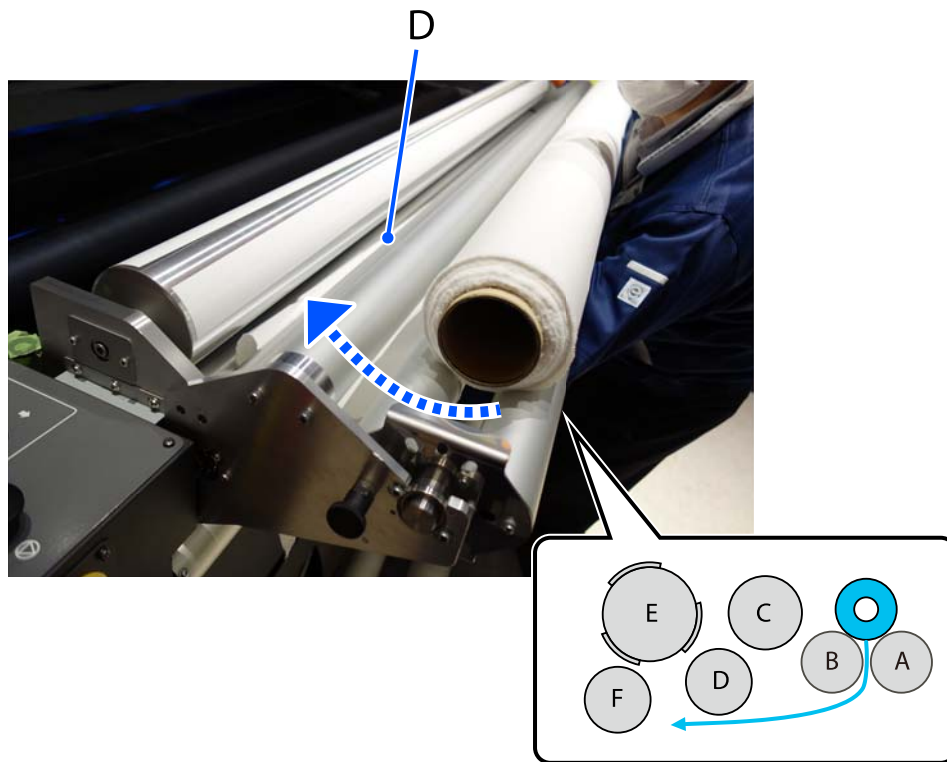
6 Feed the fabric through the rollers.

1 Feed the fabric over the top between rollers A and B.

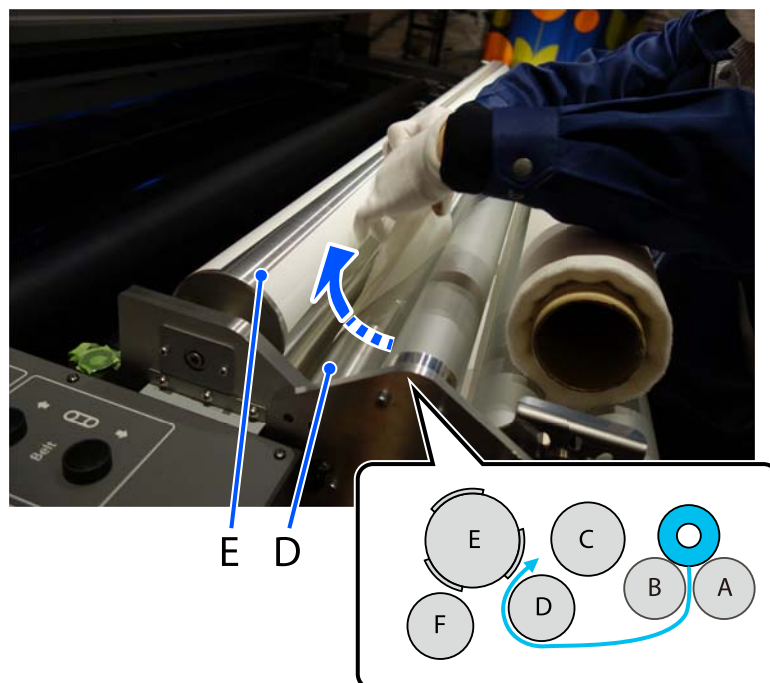


Basic Operations

- ② Feed the fabric under roller D.

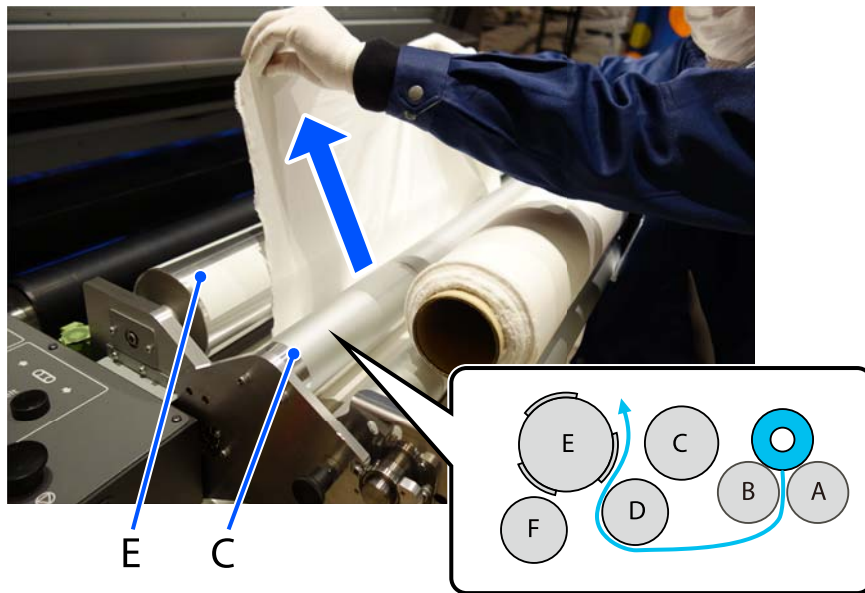


- ③ Feed the fabric between roller D and tension roller E.

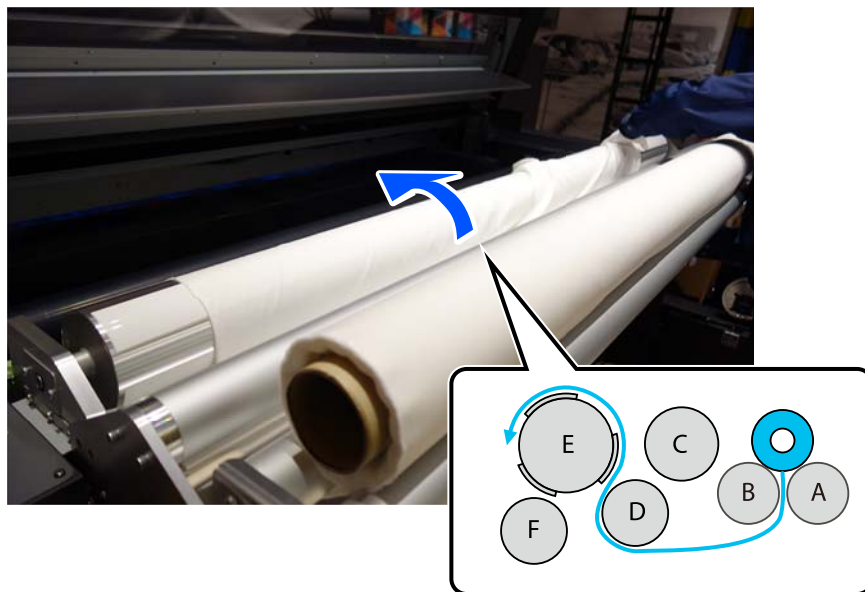


Basic Operations

- ④ Feed the fabric between roller C and tension roller E.

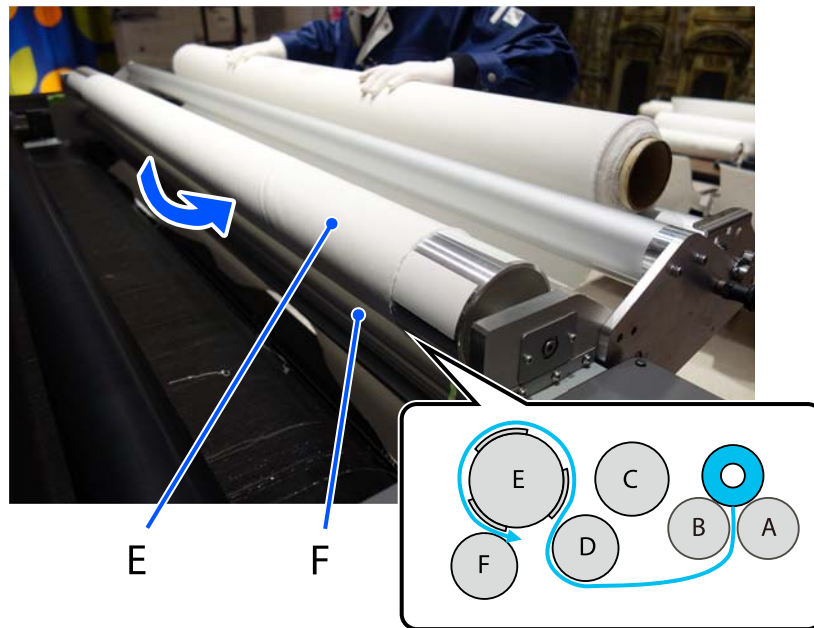


- ⑤ Feed the fabric over tension roller E.

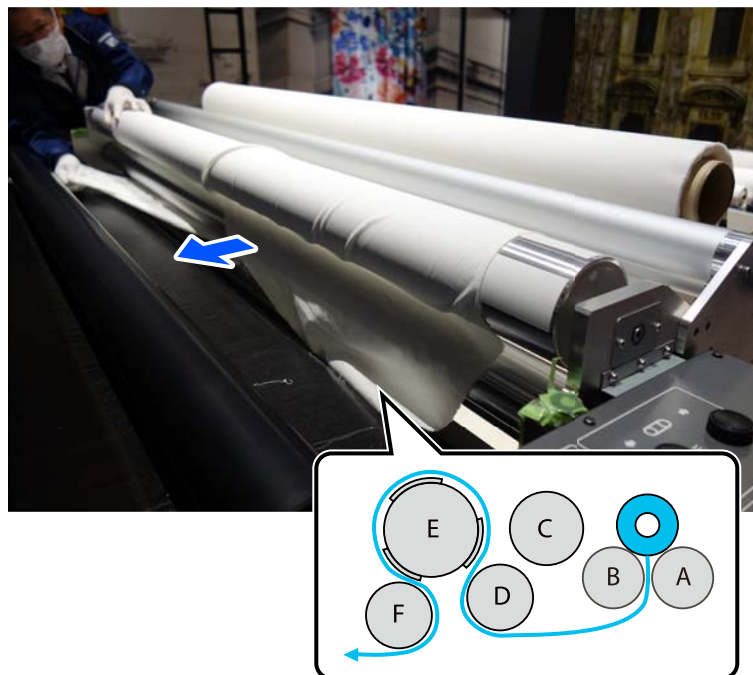


Basic Operations

- ⑥ Feed the fabric between tension roller E and roller F.

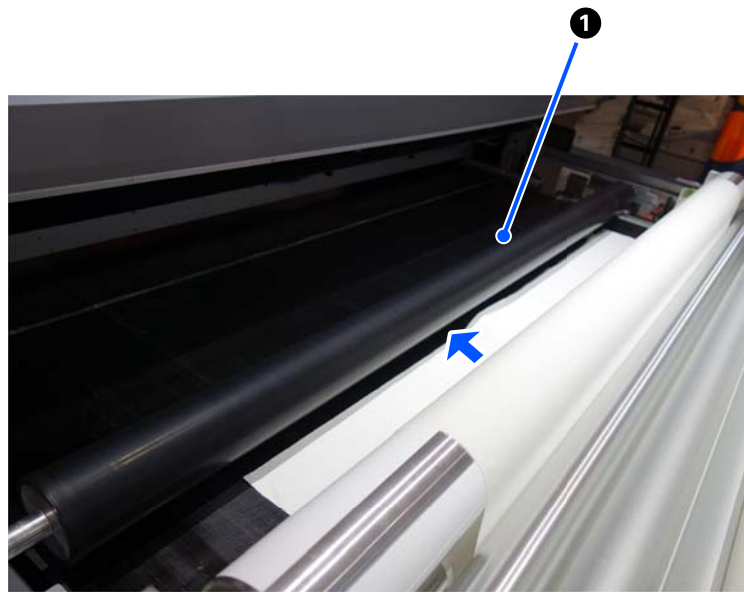


- ⑦ Feed the fabric between roller F and the belt.



Basic Operations

- ⑧ Pull the fabric out to the front of the heated pressure roller (①).

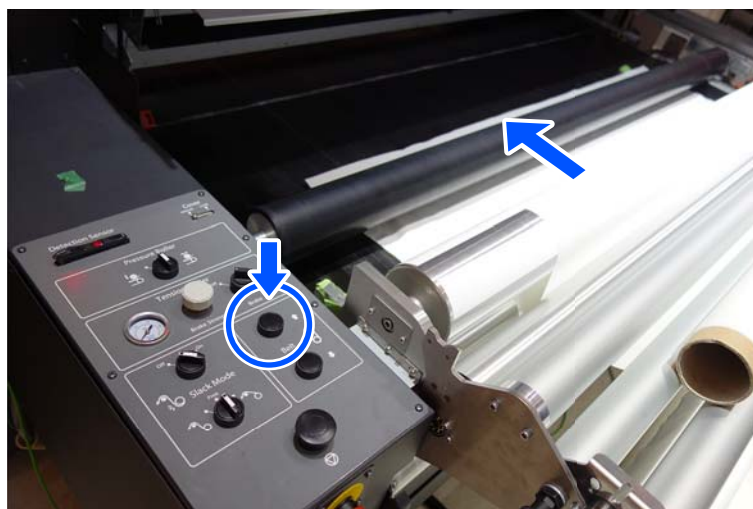


- 7 Smooth out any curls or wrinkles in the fabric.

- 8 Press and hold the feed button on the rear panel for several seconds to feed the fabric.

By continuing to feed the fabric with the tension roller locked, you can correct any skew of the fabric until it is straight.

If the fabric is still skewed after completely feeding the loose fabric, continue pressing the feed button until it is straight.



Basic Operations

- 9 Close the rear cover.



- 10 Turn the pressure roller switch on the rear panel.

The heated pressure roller lowers and moves back and forth, applying pressure to the fabric and affixing it to the belt.



Basic Operations

11

Press the feed button on the front panel (↓ in Belt) to feed the fabric to the print start position.



Setting the fabric floating sensor

See the following for more information.

[☞ “Setting the Fabric Wrinkle Detection Sensor” on page 89](#)

Print Adjustments

In the following situations, make print adjustments before printing.

- Using new fabric not registered to the printer
- When banding (horizontal band-shaped patterns, uneven shading, or stripes) or graininess is observed in the print result
- When the fabric type is the same but the width is different

See the following for more information.

[☞ “Print Adjustments” on page 111](#)

Setting fabric information

See the following for more information.

[☞ “Setting Fabric Information” on page 88](#)

Setting the print start position

See the following for more information.

[☞ “Setting the Print Start Position” on page 90](#)

Printing

See the following for more information.

[☞ “Printing” on page 91](#)

Maintenance

Maintenance

Cleaning and replacement of consumables must be performed to ensure the print quality of the printer. Failure to perform maintenance could result in reduced print quality.

This chapter explains the procedures for performing appropriate maintenance.

When to Perform Various Maintenance Operations


Inspection/Cleaning

Item	Frequency				Timing
	Everyday	Every week	Every month	Once every three months	
Inspecting Around the Operating Parts	✓				Before turning on the power
Cleaning the Area Around Operating Parts	✓				Before turning on the power
Cleaning the Lint Trap	✓				Before turning on the power
Inspecting/Adjusting the Air Pressure			✓		Before turning on the power
Inspecting/Attaching Tape to the Tension Roller			✓		Before turning on the power
Cleaning the Mist Filter			✓		Before turning on the power
Cleaning the Front Cover and Maintenance Cover			✓		<input type="checkbox"/> Before turning on the power <input type="checkbox"/> When the windows on each cover are dirty
Cleaning the Inside Light			✓		<input type="checkbox"/> Before turning on the power <input type="checkbox"/> When the inside is dark even when the inside light is on
Inspecting the Emergency Stop Device	✓				After turning on the power
Cleaning the Cleaning Pad Blades		✓			After turning on the power
Inspecting/Draining the Air Supply Regulator		✓			After turning on the power




Maintenance

Item	Frequency				Timing
	Everyday	Every week	Every month	Once every three months	
Cleaning the Suction Caps		✓			<input type="checkbox"/> After turning on the power <input type="checkbox"/> Before print head refresh
Inspecting/Cleaning the Sensors			✓		After turning on the power
Cleaning inside the Water Recycling Unit Tank				✓	After turning on the power
Inspecting/Cleaning the Cleaning Pad	✓				Before starting printing
Inspecting/Cleaning the Flushing Pad	✓				After printing ends
Inspecting/Cleaning Around the Print Head	✓				After printing ends
Drying the Sponge Roller	✓				After printing ends
Inspecting/Cleaning the Ink Path	✓		✓		After printing ends
	Inspecti on		Cleaning		
Cleaning the Belt Cleaning Unit		✓			<input type="checkbox"/> After printing ends <input type="checkbox"/> When the unit is clogged with lint or debris


Replacing Consumables

Item	Timing
Replacing the ink cartridges	When ink low warning is displayed on the control panel display
Replacing the Waste Ink Bottle	When a prepare and replacement message is displayed on the control panel screen
Replacing the Wiper Roll	When a prepare and replacement message is displayed on the control panel screen
Replacing the Washing Scraper	<input type="checkbox"/> When the washing scraper is worn out and water droplets remain on the belt after Belt Cleaning <input type="checkbox"/> When a prepare and replacement message is displayed on the control panel screen
Replacing the Flushing Pad	When the dirt does not come off even after cleaning the flushing pad  "Inspecting/Cleaning the Flushing Pad" on page 225

Maintenance


Item	Timing
Replacing the Cleaning Pad	When the dirt does not come off even after cleaning the cleaning pad  "Inspecting/Cleaning the Cleaning Pad" on page 221
Replacing the Sponge Roller	When water droplets remain on the belt even after drying the sponge roller  "Drying the Sponge Roller" on page 232
Replacing the Mist Filter	When dirt does not come off even after cleaning the mist filter  "Cleaning the Mist Filter" on page 201

Other Maintenance

Item	Timing
Cleaning the Mist Collection Fan	When a message is displayed on the control panel screen prompting you to clean the mist collection fan
Cleaning the Encoder Scale	<input type="checkbox"/> When a message is displayed on the control panel screen prompting you to clean the encoder scale <input type="checkbox"/> When you notice lint, debris, or dirt on the encoder scale
Checking for Clogged Nozzles	<input type="checkbox"/> When checking if nozzles are clogged <input type="checkbox"/> When checking which colors are clogged <input type="checkbox"/> Horizontal stripes or tint unevenness (banding) have appeared
Print Head Cleaning	When a clog is found after checking for clogged nozzles
Capping the Print Head	If capping is not performed for more than 20 minutes
Adding Grease to the Scan Spindle	Adding grease to the scan spindle: Every month Adding grease to the print head operating area: When a message prompting you to add grease is displayed on the control panel screen (once a year)
Removing glue (when using the glue removal tool)	<input type="checkbox"/> When the fabric attached to the belt rises slightly <input type="checkbox"/> When there is damage such as peeling of the glue
Removing glue (when using the glue bucket)	 "Timing for Reapplying the Glue" on page 309
Applying Glue	

Required Items

Prepare the following items before beginning cleaning and replacement.
The items you need to prepare for removing/applying glue are explained in each maintenance procedure.

 ["Removing Glue \(When Using the Glue Removal Tool\)" on page 314](#)

 ["Removing Glue \(When Using the Glue Bucket\)" on page 366](#)

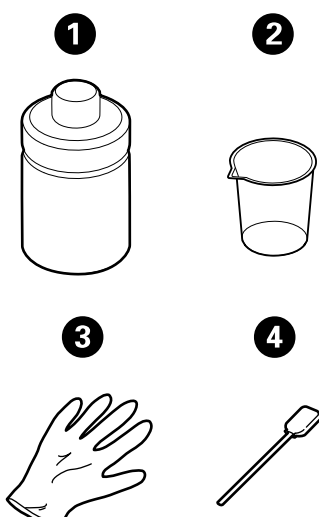
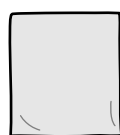
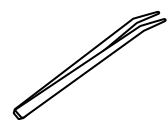
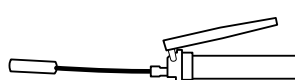
 ["Applying Glue" on page 402](#)

Maintenance

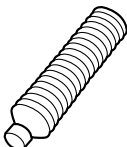
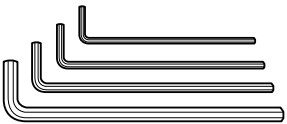
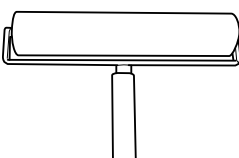
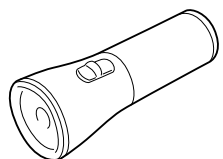
When the supplied parts have been completely used, purchase new consumables specifically made for this machine.

Use genuine parts when replacing ink cartridges or performing maintenance.

 [“Options and Consumable Products” on page 472](#)

Required Items	Details/Use	
<p>Cleaning kit</p>  <p>1 2 3 4</p>	Supplied	<p>Used to clean ink that has adhered to the machine. The following parts are included in the set.</p> <ul style="list-style-type: none"> 1 Cleaning liquid (x1) 2 Cup (x1) 3 Gloves (x16) 4 Cleaning stick (x50) <p>Do not dilute the cleaning liquid.</p>
<p>Cleaning cloth</p> 	Supplied or commercially available	Used to clean the inside of the machine. When using commercially available products, we recommend that you use products that do not produce lint and static electricity.
<p>Plastic tweezers</p> 	Commercially available	Use to remove lint and other debris adhering to caps when cleaning them.
<p>Grease pump</p> 	Supplied	Use to lubricate the moving parts of the print head with grease.
<p>Phillips screwdriver</p>	Commercially available No. 2 size with a shaft length of approximately 150 mm (6 inches)	Use to loosen and fasten screws on the work area of this machine. Do not use an electric screwdriver.
<p>Phillips screwdriver</p>	Commercially available No. 2 size with a shaft length of approximately 300 mm (12 inches)	Use the screwdriver to loosen or fasten screws when manually capping the print head.

Maintenance

Required Items	Details/Use	
Grease tube 	Commercially available Recommended: AFA grease (THK)	Use to lubricate the scan spindle, print head moving parts, and the belt cleaning unit with grease.
Metal or plastic (PP/PE) container	Commercially available	Use when cleaning removed consumables and when draining.
Metal or plastic (PP/PE) tray	Commercially available	Use this to place cleaning tools, removed consumables, and cleaning liquid transferred to the cup.
Flat-head screwdriver	Commercially available Blade width: 6 to 8 mm (0.23 to 0.31 inches) Blade thickness: 1.5 mm (0.05 inches)	Use to fasten or loosen screws on the machine. Do not use an electric screwdriver.
Hex key 	Commercially available 2.5 mm (0.1 inches) wide 5 mm (0.2 inches) wide	Use to fasten or loosen screws on the machine. The size of the hex wrench varies depending on each screw. Check each work procedure.
Scissors	Commercially available	Use to cut off the peeled part of the tension roller tape.
Photography paper	Commercially available	Use when printing check patterns. Prepare A3 or A2 size.
Rubber roller 	Commercially available	Use to attach photo paper to the belt. We recommend the following rubber rollers. <ul style="list-style-type: none"> <input type="checkbox"/> Roller spindle: Made of metal that supports both sides of the roller and does not deform even when force is applied (rust-resistant aluminum is recommended) <input type="checkbox"/> Roller part: Made of hard rubber, weighing 400 g or more
Flashlight 	Commercially available	Use to illuminate the area where you are working inside the machine, such as when cleaning the area around the heads. We recommend using free-standing lights, so that you can use both hands when working.
Mirror	Commercially available	Use to check if the encoder scale is properly installed in the scale holder.



Precautions Regarding Maintenance














Note the following points when cleaning and replacing parts.

- Remove the fabric from the printer before proceeding with cleaning.










Maintenance

- Never touch the belts, circuit boards, or any parts that do not require cleaning. Failure to observe this precaution could result in malfunction or reduced print quality.
- Always use fresh cleaning sticks. Re-using sticks can make stains even harder to remove.
- Do not touch the tips of the cleaning sticks. Oil from your hands could damage the print head.
- Do not use anything other than the specified cleaning liquid to clean the area around the print head and caps. Using anything else could result in malfunction or reduced print quality.
- Touch a metallic object before starting work to discharge any static electricity.

 WARNING	
	If using glue or glue remover that contains flammable gas, explosive gas, or the like, ensure sufficient ventilation and make sure that the ignition point and explosion limit are not reached. For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.



 CAUTION	
    	<p>During maintenance work, wear all of the protective equipment described in the maintenance procedures in the <i>User's Manual</i> (eye protection, protective gloves, respiratory protection, etc.).</p> <ul style="list-style-type: none"> <input type="checkbox"/> Use protective equipment compliant with the safety regulations. <input type="checkbox"/> Using additional protective equipment compliant with the safety regulations is recommended when necessary.
	Be sure to wear eye protection when performing maintenance work near the ink path, such as when cleaning the print head and caps. Failure to do so could cause ink to splash into the eyes.
	Be sure to wear protective gloves when performing the following tasks. <ul style="list-style-type: none"> <input type="checkbox"/> Tasks near the ink flow path, such as replacing the wiper unit <input type="checkbox"/> Cleaning or replacing parts inside the belt cleaning unit <input type="checkbox"/> Tasks involving the use of maintenance liquid
 	Be sure to wear eye protection, respiratory protection, and protective gloves when applying glue. For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.
	People with long hair should tie their hair and also wear a hair net. Otherwise, your hands and clothing could become stained with ink, and your fingers and hair could become caught in the machine, causing injury.
	If waste ink, maintenance liquid, or cleaning water gets on the floor, wipe it off with a cleaning cloth. Failure to do so could cause an injury due to slipping and falling.
	When opening the maintenance cover of the water recycling unit to perform maintenance tasks, always press the Pause/Restart button on the control panel of the water recycling unit to enter pause mode before starting the task. Also, be sure to wear eye protection. Failure to do so could cause cleaning water to splash into the eyes.

Maintenance




 CAUTION	
	<p>If cleaning water gets on your skin or enters your eyes or mouth, take the measures below.</p> <ul style="list-style-type: none"> <input type="checkbox"/> If it gets on your skin, rinse immediately with soap and water. <input type="checkbox"/> If it enters your eyes, rinse immediately with water. Failure to observe this precaution could result in bloodshot eyes or mild inflammation. If problems persist, consult with a physician. <input type="checkbox"/> If it enters your mouth, consult a physician immediately.
	<p>Perform maintenance tasks within the operating temperature and humidity range described in the "Specifications Table" in the <i>User's Manual</i>.</p>
	<p>When performing maintenance that requires you to move the print head (when the print head is moved away from the cap), make sure you perform the work within 20 minutes. Exceeding the maintenance time may cause the print head nozzles to clog, resulting in a decline in print quality. Exceeding the recommended working time, especially when using pigment inks, may cause a malfunction to occur. If you do exceed the working time guidelines when using pigment inks, contact your dealer or Epson Support.</p>
	<p>When maintenance work is completed, immediately return the protective equipment to its original location.</p>
	<p>Make sure that no tools or parts used in maintenance work or other foreign materials are left on the operating parts of the machine or inside the machine.</p>
	<p>During maintenance, do not use sharpening stones, abrasive/corrosive materials, or solvents (excluding glue). Doing so may erase numbers, codes, or characters indicated on the machine.</p>
	<p>Do not expose the electrical and electronic devices and motors to liquid.</p>
	<p>Follow the instructions in the "Safety Data Sheet (SDS)" for each product to ensure you use the product correctly. The Safety Data Sheet can be downloaded from the Epson website.</p>









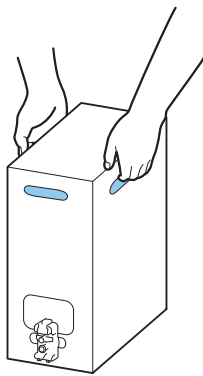
Precautions for Handling Ink, Maintenance Liquid, and Waste Ink

Read the Safety Data Sheet (SDS) before handling ink cartridges, maintenance liquid, and waste ink. The Safety Data Sheet can be downloaded from the Epson website.

 WARNING	
	<p>If ink gets on your skin or enters your eyes or mouth, take the measures below.</p> <ul style="list-style-type: none"> <input type="checkbox"/> If it gets on your skin, rinse immediately with soap and water. <input type="checkbox"/> If it enters your eyes, rinse immediately with water. Failure to observe this precaution could result in bloodshot eyes or mild inflammation. If problems persist, consult with a physician. <input type="checkbox"/> If it enters your mouth, consult a physician immediately.

Maintenance

 WARNING	
	Do not dismantle or remodel ink cartridges. Disassembling it can cause ink or cleaning liquid to get in your eyes or come in contact with your skin.
	Keep ink cartridges, maintenance liquid, grease, waste ink, and glue out of the reach of children.

 CAUTION	
	Do not touch the IC chip on any ink cartridges.
	Store ink cartridges within the indicated temperature range. Do not store them in high or freezing temperatures.
	Dispose of used ink cartridges according to local laws and regulations.
	Epson recommends the use of genuine Epson ink cartridges. Epson cannot guarantee the quality or reliability of nongenuine ink. The use of non-genuine ink may cause damage that is not covered by Epson's warranties, and under certain circumstances, may cause erratic printer behavior. For more information about the warranty for this machine, please refer to the Delivery Specifications or sales contract.
	This machine is designed to stop operating before the ink completely runs out in order to maintain the quality of the print head. Therefore, a small amount of ink will remain in used ink cartridges. The running cost will vary by usage environment and usage conditions.
 	When lifting an ink cartridge, wear safety shoes and lift it by placing your hands in the positions indicated in the following illustration. Lifting the ink cartridge by another part may cause it to fall or catch your fingers when putting it down, which could lead to injury. 

Precautions Regarding Glue and Glue Remover

Glue and glue remover may contain organic solvents harmful to the human body.

Before carrying out work handling glue or remover, obtain a Safety Data Sheet from the manufacturer of that glue or remover and thoroughly understand the contents thereof. Then, carry out work taking appropriate measures and strictly following the laws and regulations of your region.

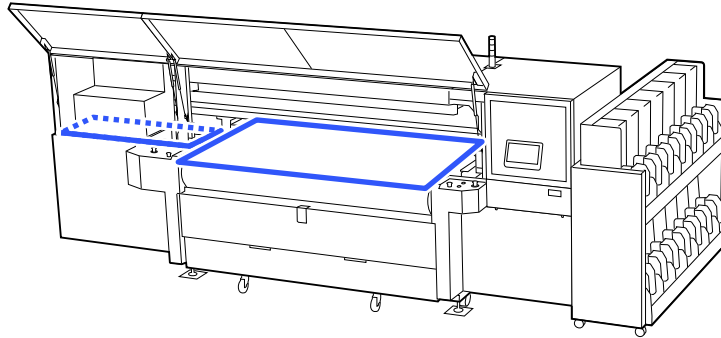
Seiko Epson Corporation will bear no responsibility whatsoever regarding the handling of glue or glue remover, as well as any effects on health therefrom.

Maintenance

Checks Before Maintenance

Check that there are no tools or hardware on the belt or around the heated pressure roller or print head. Otherwise, they may get caught in the print head, heated pressure roller, or belt resulting in damage to the printer. Before turning on the power, make sure that there are no objects on the belt, or on the moving parts of the heated pressure roller for the print head.

Front



Rear



Inspection/Cleaning Procedure

Inspecting Around the Operating Parts

Inspect the area around operating parts.

Maintenance

Inspection items

Check if there are any tools, hardware, or other items in the area.

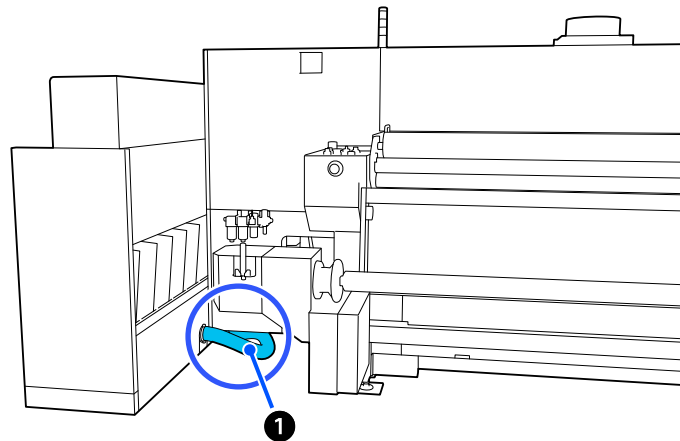
If you turn on the power when there are tools, hardware, and other such items placed on the belt, they may get caught in the belt or print head, resulting in damage to the printer. Before turning on the power, make sure that there are no objects on the belt, around the print head, or near any other moving parts.

Check for any debris or lint.

- If the operating parts are dirty, wipe them clean using a cleaning cloth dampened with water.
🔗 [“Inspecting Around the Operating Parts” on page 189](#)
- Clean the cleaning brushes and scraper if they are dirty.
🔗 [“Cleaning the Belt Cleaning Unit” on page 237](#)

Are there any signs of ink pooling or leaks around the printer?

- If there is an ink leak inside the printer, contact your dealer or Epson Support.
- If there is an ink leak around the ink supply units, check that the Ink cartridges are properly installed and that the ink supply tubes (❶) are not damaged. If there is any visible damage, contact your dealer or Epson Support.



- If waste ink is leaking from the waste ink bottle, replace the waste ink bottle.
🔗 [“Replacing the Waste Ink Bottle” on page 247](#)

Are there any water leaks around the printer?

- Check to see if there are leaks in the drain pipe joint located at the bottom of the belt cleaning unit or if it is loose. If it is leaking or loose, tighten it.
- Check to see if there are any water leaks coming from the water recycling unit.

If water is leaking, contact your dealer or Epson Support.

Inspection locations

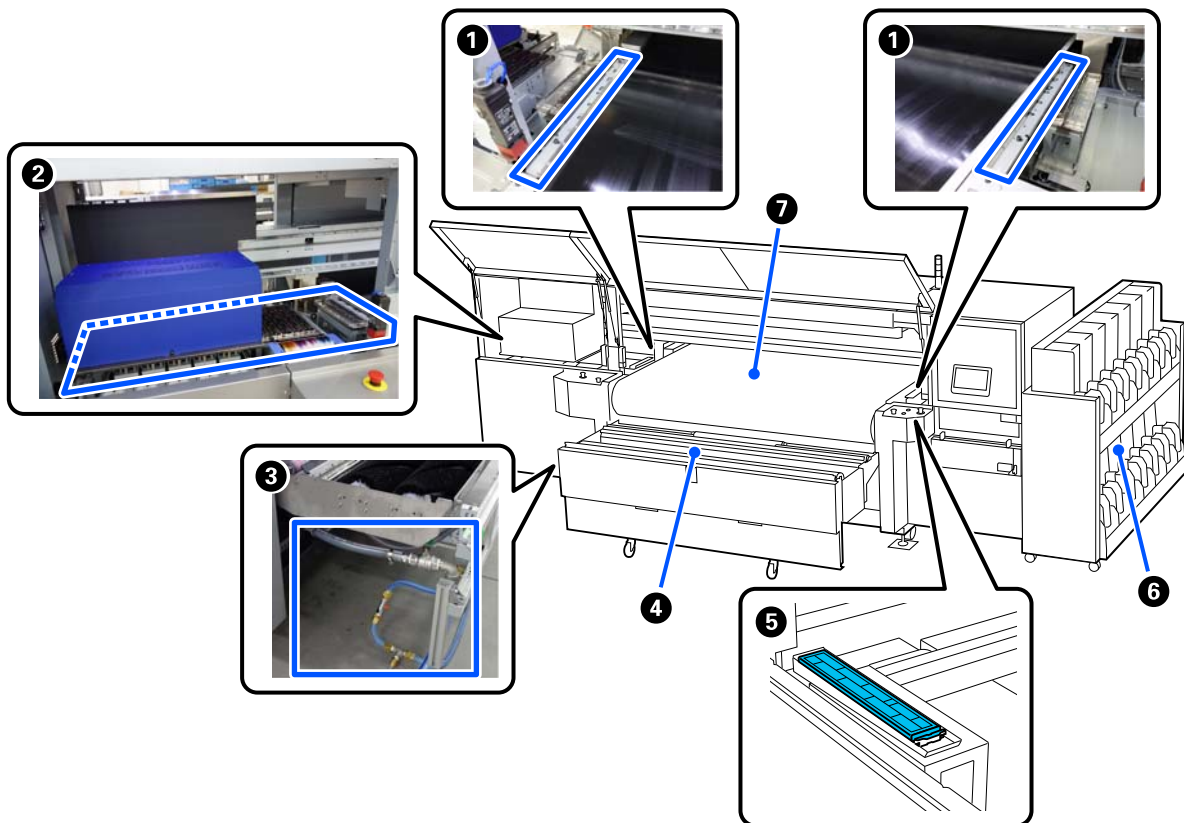
Perform a visual check.

- Belt/Guide beside the belt

Maintenance

- ❑ Inside/lower part of the belt cleaning unit
- ❑ Around the ink supply unit
- ❑ Around the print head
- ❑ Waste ink bottle surroundings
- ❑ Wiper roll, suction cap, flushing pad, cleaning pad area
- ❑ Tension roller
- ❑ Around the water recycling unit

Front

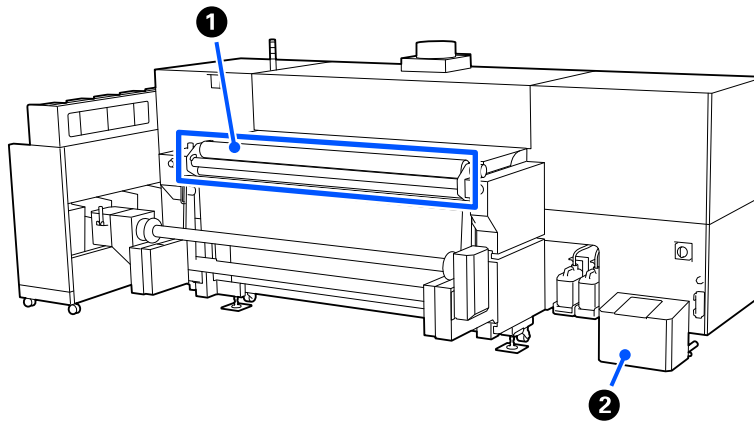


- ① Check for any debris or lint.
- ② Are there any signs of ink pooling or leaks around the printer?
- ③ Are there any signs of water leaks around the printer?
Is the drain pipe loose?
- ④ Check for any debris or lint.
Are there any signs of water leaks around the printer?
- ⑤ Are there any signs of ink pooling or leaks around the printer?

Maintenance

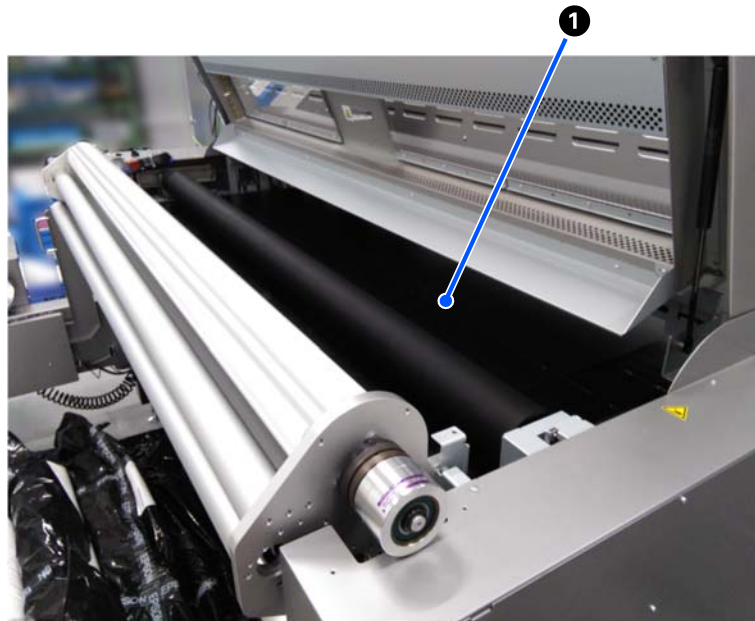
- ⑥ Are there any signs of ink pooling or leaks around the printer?
Are the ink supply tubes or cables damaged?
- ⑦ Check for any debris or lint.
Check if there are any tools, hardware, or other items in the area.

Rear



- ① Check for any debris or lint.
Is the tape peeling off?
- ② Are there any signs of water leaks around the printer?

Inside Rear




- ① Check for any debris or lint.
Check if there are any tools, hardware, or other items in the area.

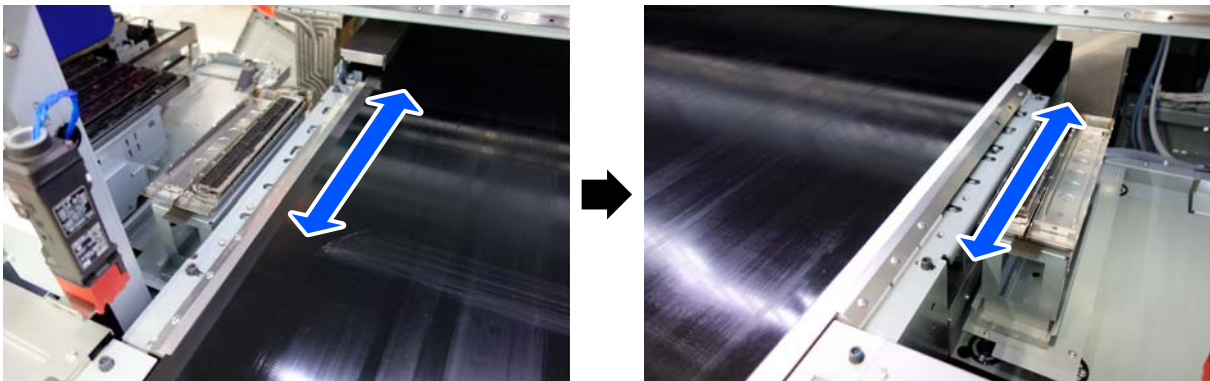
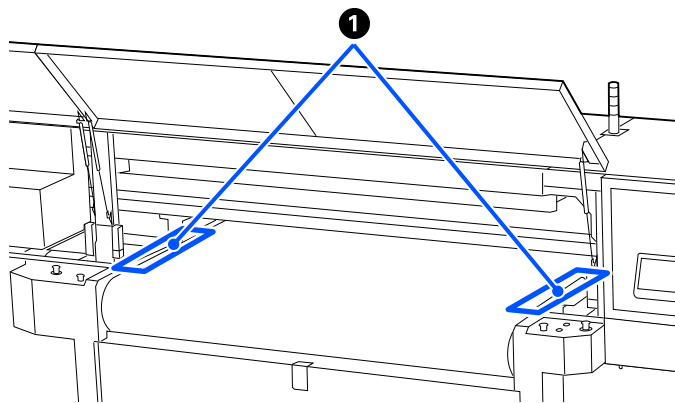
Maintenance

Cleaning the Area Around Operating Parts

Wipe away any debris or lint from the operating parts.

- 1 Check that the machine is off.
 [“Turning Off the Power” on page 110](#)

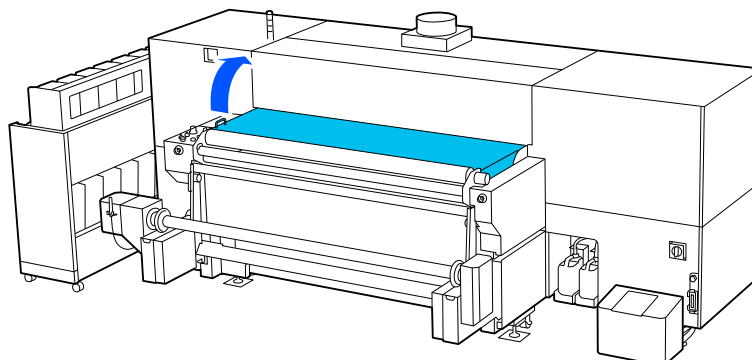
- 2 Open the front cover and wipe away any dirt on the belt surface or the belt side guides with a cleaning cloth dampened with water.



- 1 Guide beside the belt

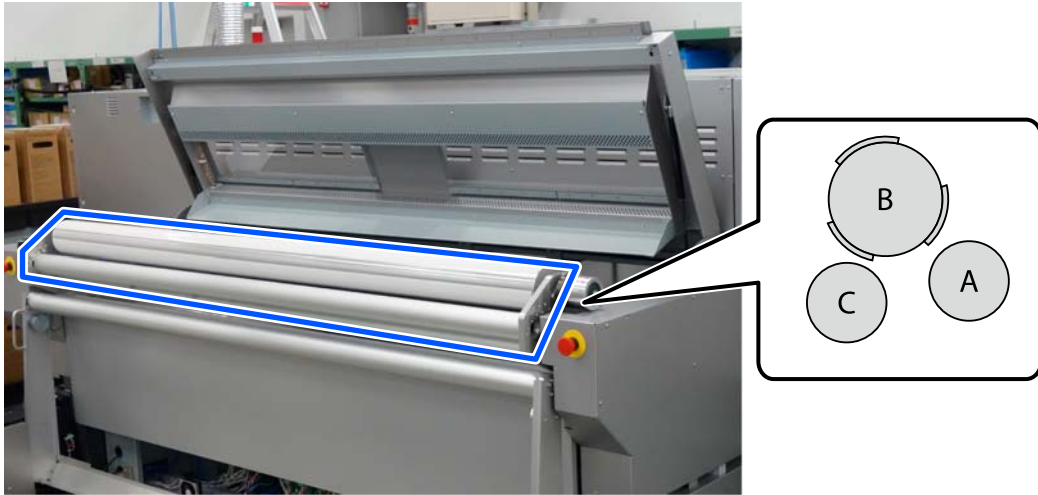
- 3 Close the front cover.

- 4 Move to the rear of the printer and open the rear cover.

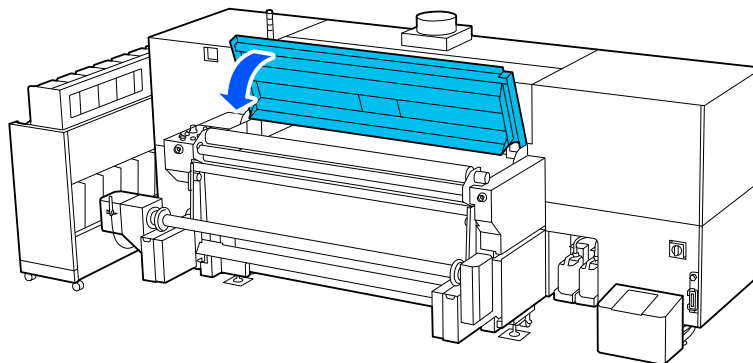


Maintenance

- 5** Wipe away any dirt from rollers A, B, and C with a cleaning cloth dampened with water.



- 6** Close the rear cover.



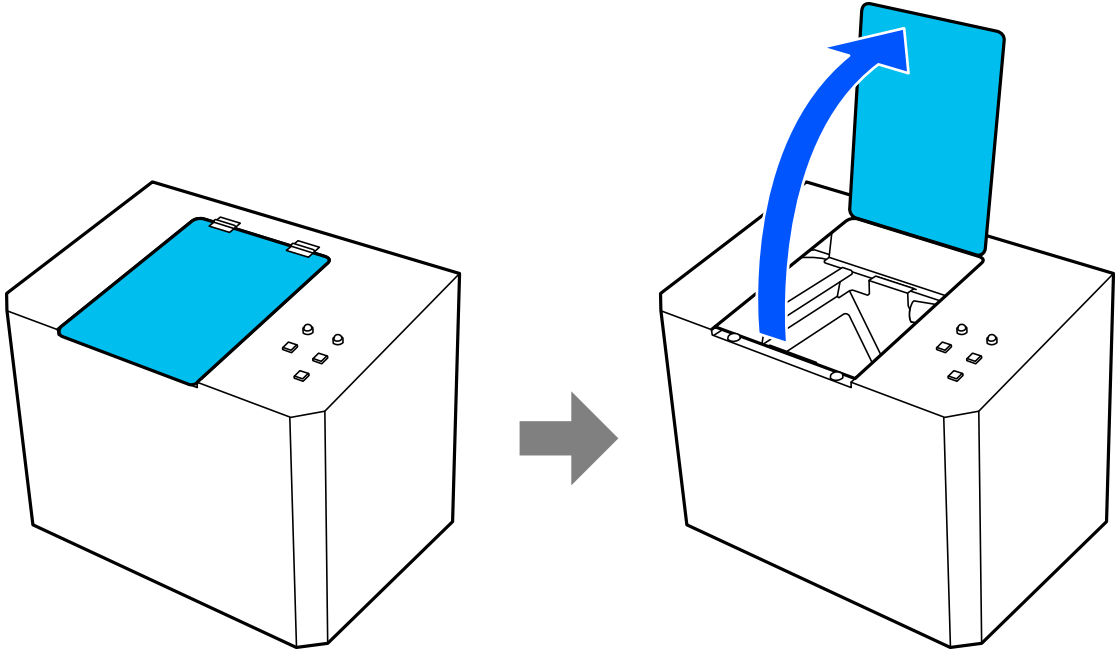
Cleaning the Lint Trap

Clean the lint trap.

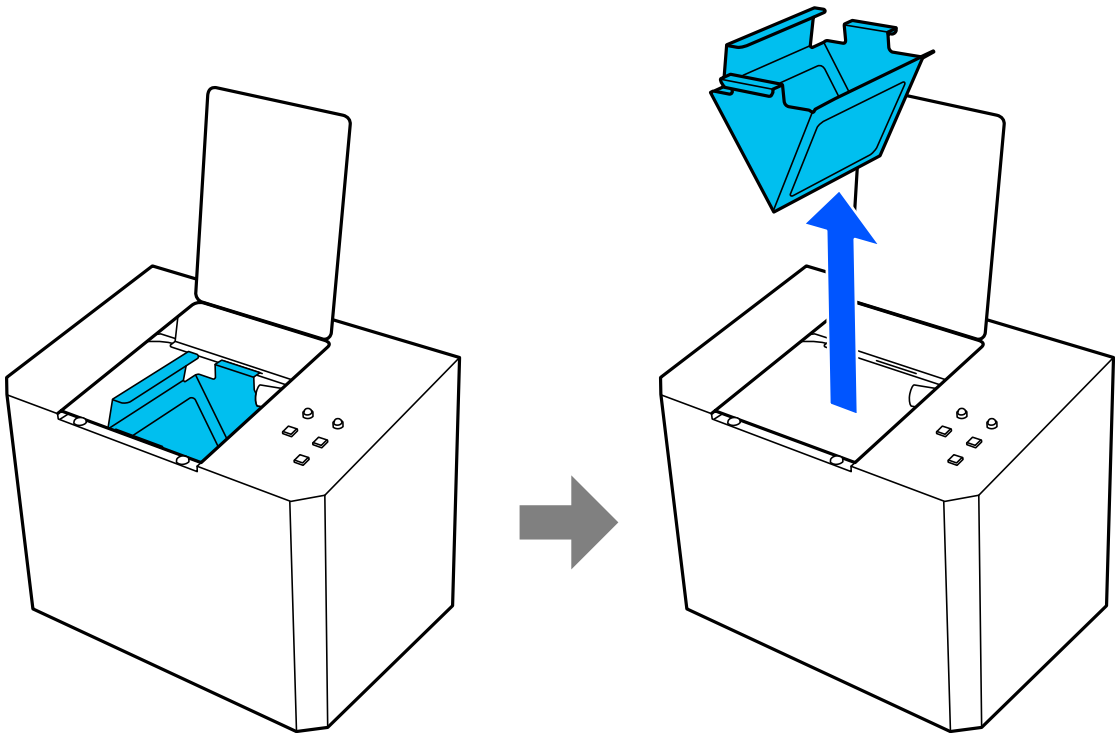
Required Items	Brush, wipe cloths, protective gloves, eye protection, protective clothing
----------------	--

Maintenance

- 1 Press the Pause/Restart button on the control panel of the water recycling unit.
Wait until the flow of cleaning water into the water recycling unit has slowed down.
- 2 Open the maintenance cover on the water recycling unit.



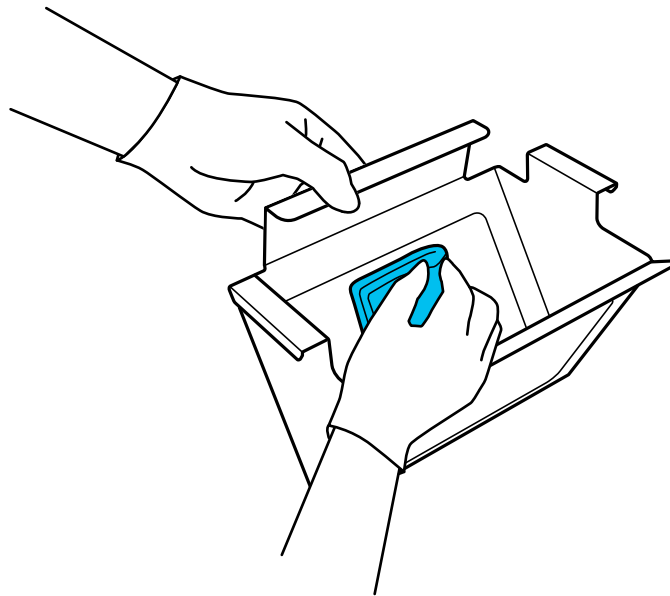
- 3 Remove the lint trap.



- 4 Use a brush, wipe cloth, or similar item to remove lint and other debris from the lint trap.
If it is very dirty, soak it in a container filled with tap water to remove the dirt.

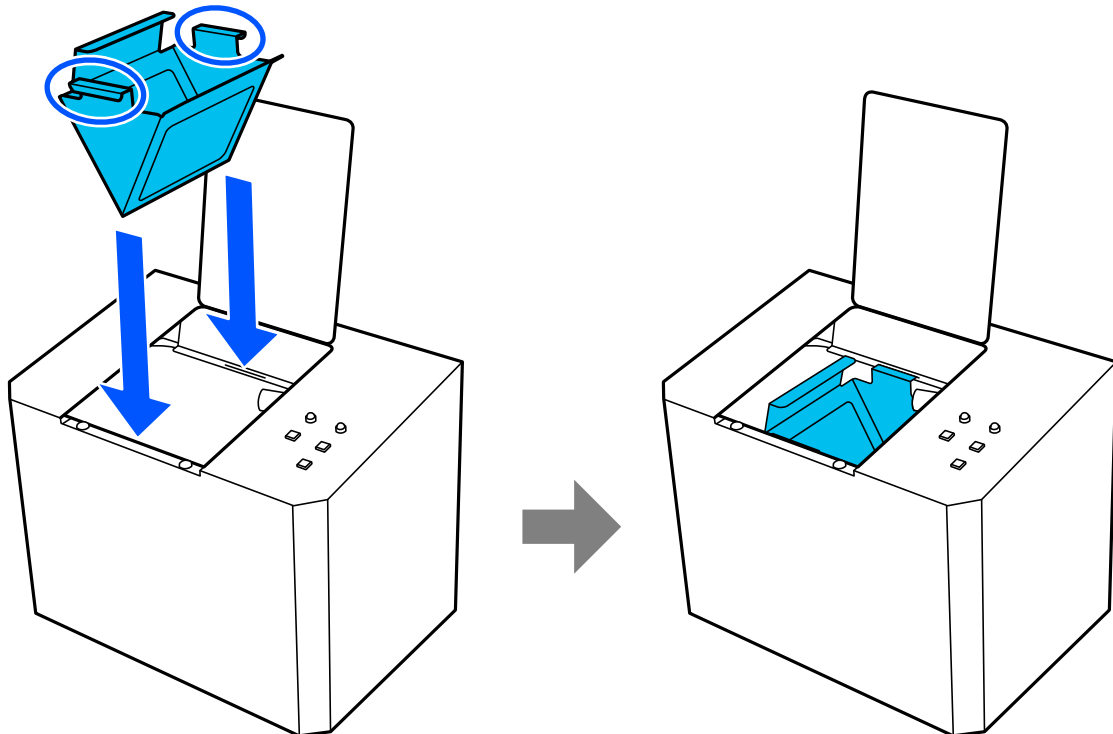
Maintenance

Used brushes, wipe cloths, and dirty water are considered industrial waste. Dispose of it in the proper manner.



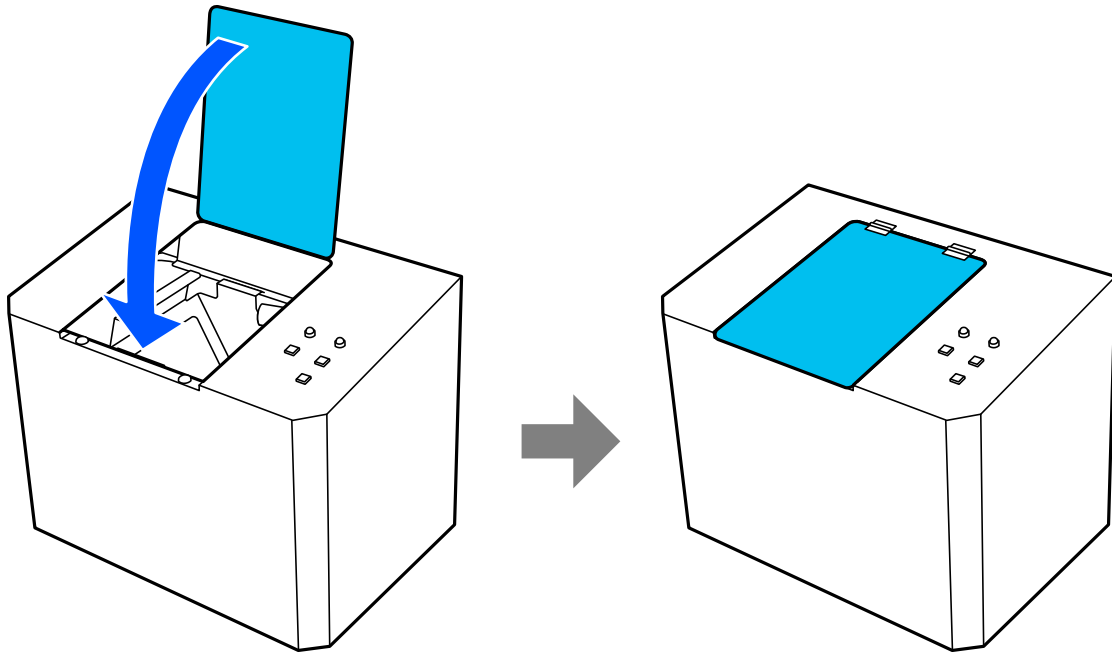
- 5 Return the lint trap to its original position.

Place the hooks of the lint trap over the notches of the water recycling unit, with the short side at the back of the water recycling unit and the long side at the front.



Maintenance

- 6** Close the maintenance cover on the water recycling unit.



- 7** Press the Pause/Restart button on the control panel of the water recycling unit.

The water recycling unit starts operating again, and the cleaning water flows into it.

Inspecting/Adjusting the Air Pressure

Compressed air must be supplied in order for the machine to operate. The machine will not operate if the specified air pressure is not supplied. Also, an air pressure that is higher than the specified air pressure could cause the machine to malfunction. Follow the steps below to inspect it, and if the values are not at the specified levels, adjust them to the specified values.

Maintenance

Inspection method

Confirm that the meter matches the specified value.
Specified value: 0.45 Mpa

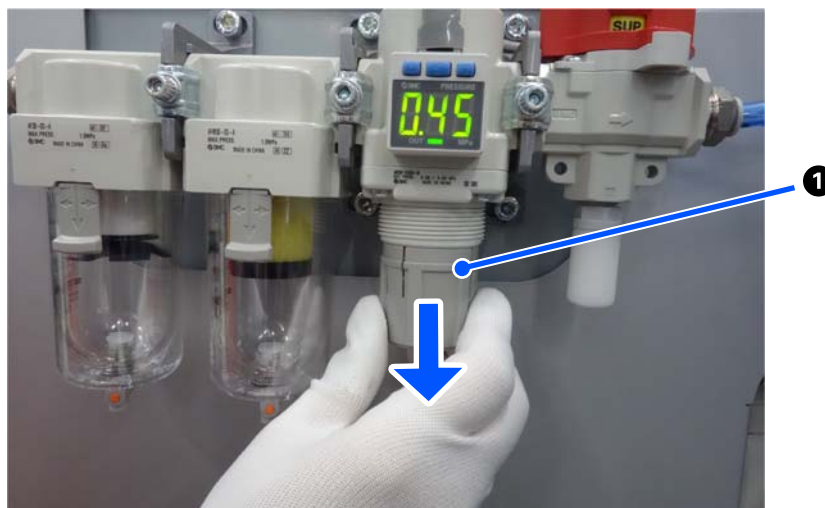


If it does not match the specified value, use the pressure adjustment handle to perform adjustment.

 [“Adjustment method” on page 198](#)

Adjustment method

- 1 Pull the pressure adjustment handle down until you hear a click.



- 1 Pressure adjustment handle

Maintenance

- 2** Adjust the pressure to 0.45 MPa (specified value). Turn to the right to raise the pressure. Turn to the left to lower the pressure.

Perform adjustments while checking the meter.



- 3** Push the pressure adjustment handle upward to lock it.

If it is not at the specified value after the above procedure, check the status of the compressed air equipment in the factory.

 [“Factory Facilities” on page 481](#)

Inspecting and Cutting the Tension Roller Tape

If you print while the tension roller tape is peeling or sticking up, the fabric may lift or wrinkles may occur. Inspect as explained below.

If the tension roller tape is peeling or sticking up, cut off that part. If the tape is peeling or sticking up by more than half the width of the tape, replace the tape. Contact your dealer or Epson Support.



Maintenance

① Tension roller tape

Inspection method

Move to the rear of the printer and check that the tension roller tape is not peeling off.

If the tension roller tape is peeling or sticking up, cut off that part with scissors.

 [“Cutting method” on page 200](#)



If the tape is peeling or sticking up by more than half the width of the tape, replace the tape. Contact your dealer or Epson Support.

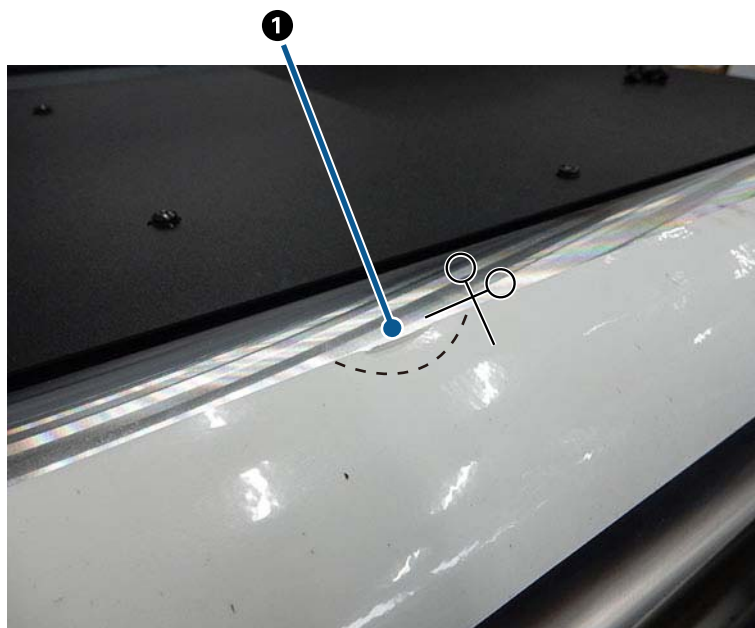


Cutting method

Required Items	Scissors, protective gloves, and protective clothing
----------------	--

Maintenance

- 1 Cut off any pieces of tape stuck to the tension roller that are peeling or sticking up using scissors or by hand.



- 1 Tape peeling or sticking up

- 2 Attach the tape to the tension roller so that nothing is sticking up.



Note:

If the tape continues to stick up or peel after re-attaching, the tape needs to be replaced.

Contact your dealer or Epson Support to request a replacement.

Cleaning the Mist Filter

If debris accumulates in the mist filter, the machine interior may get dirty due to the mist, which may stain the fabric or cause clogged nozzles. Follow the steps below to perform cleaning.

Maintenance

Note:

It takes time for the mist filter to dry after cleaning it. We recommend preparing another mist filter before you start cleaning.

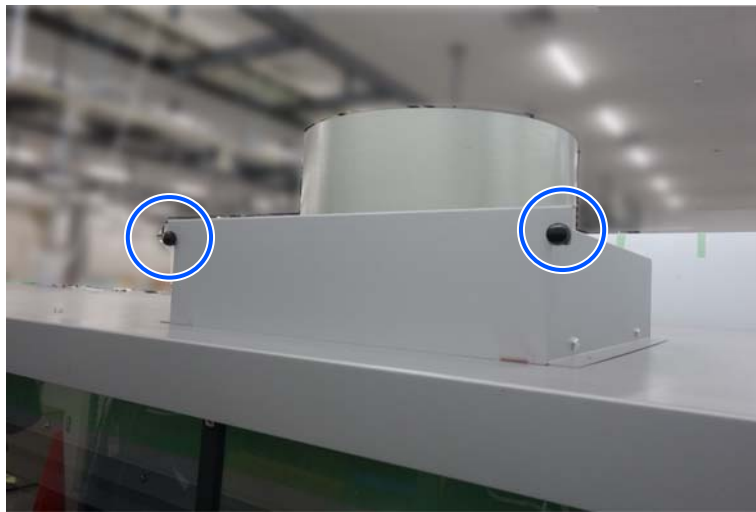
Required Items

Spare mist filter, protective gloves, and protective clothing

1 Check that the machine is off.

 [“Turning Off the Power” on page 110](#)

2 Loosen the two screws on the mist filter cover by hand.



3 Slide the cover upward and remove it.



Maintenance

- 4 Pull out the mist filter.



- 5 Clean the removed mist filter with water and thoroughly dry it.
Replace the mist filter with a new one if it is still dirty.

 [“Replacing the Mist Filter” on page 271](#)

- 6 Check the orientation of the arrow on the label of the spare or well-dried mist filter cover and put the filter back in its original position.




- 7 Attach the mist filter cover you removed.
- 8 Tighten the two screws on the mist filter cover.

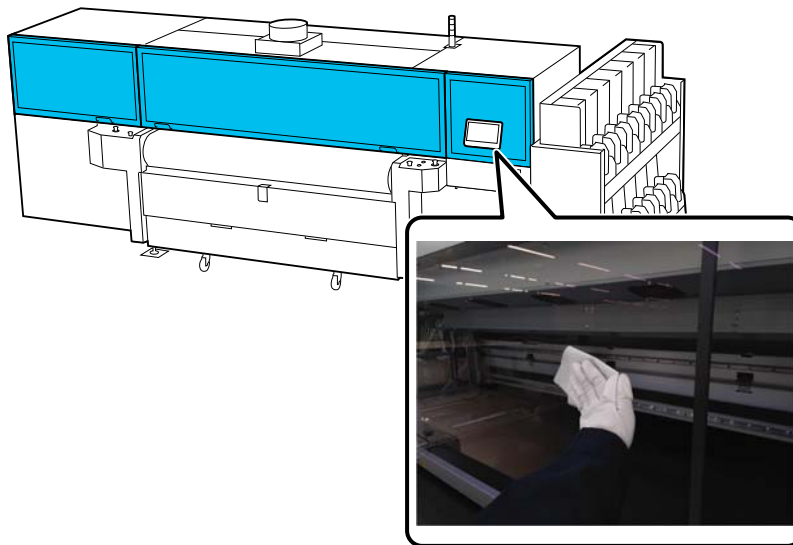
Cleaning the Front Cover and Maintenance Cover

If you continue to use the printer while the windows on the front cover and the left maintenance cover are dirty with dust or ink mist, it will become difficult to see inside the printer. Follow the steps below to perform cleaning.

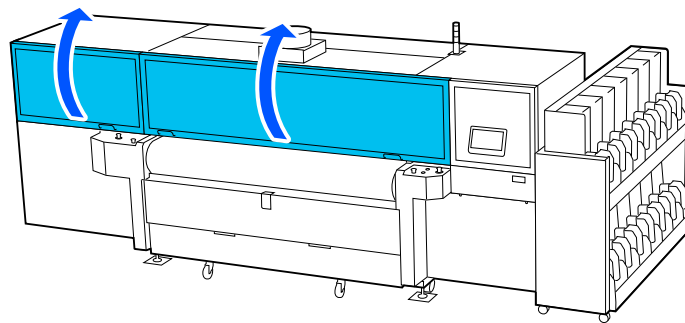
Maintenance

Required Items	Cleaning cloth, protective gloves, and protective clothing
----------------	--

- 1 Check that the machine is off.
 [“Turning Off the Power” on page 110](#)
- 2 Soak a cleaning cloth in water, wring it out thoroughly, and then wipe any dirt off the window on the cover.
For anything that cannot be removed with a damp cloth, dip a cloth in neutral detergent, squeeze it out, and then wipe the stubborn stain.



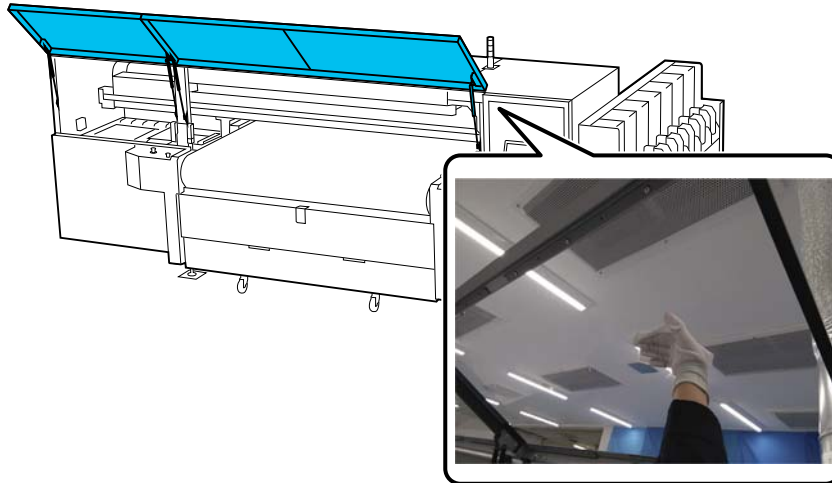
- 3 Open the front cover and the maintenance cover (left).



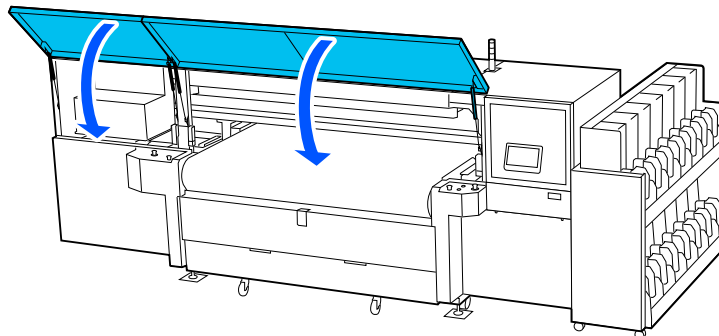
Maintenance

- 4** Soak a cleaning cloth in water, wring it out thoroughly, and then wipe away the dirt from the back of the window.

For anything that cannot be removed with a damp cloth, dip a cloth in neutral detergent, squeeze it out, and then wipe the stubborn stain.



- 5** Close the front cover and the maintenance cover (left).



Cleaning the Inside Light

If ink mist makes the surface of the inside light dirty, it becomes dim so checking becomes difficult. Follow the steps below to perform cleaning. If the inside of the printer remains dim due to ink mist buildup despite regular cleaning, clean it as needed each time.

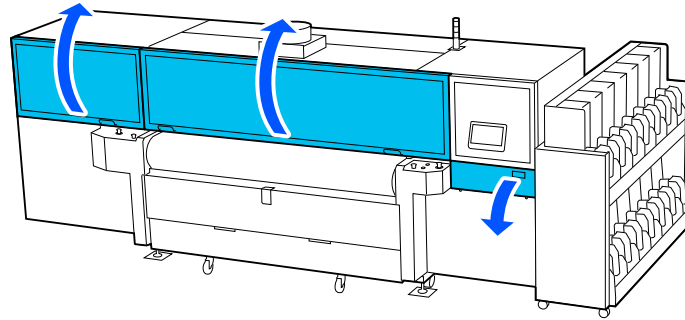
Required Items	Cleaning cloth, protective gloves, eye protection, and protective clothing
----------------	--

- 1** Check that the machine is off.

 [“Turning Off the Power” on page 110](#)

Maintenance

- 2 Open the front cover and the maintenance cover (Left and right).

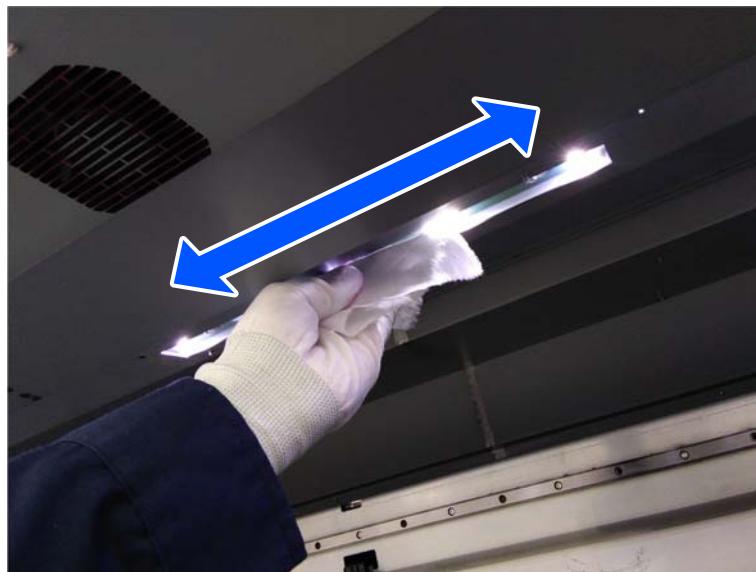
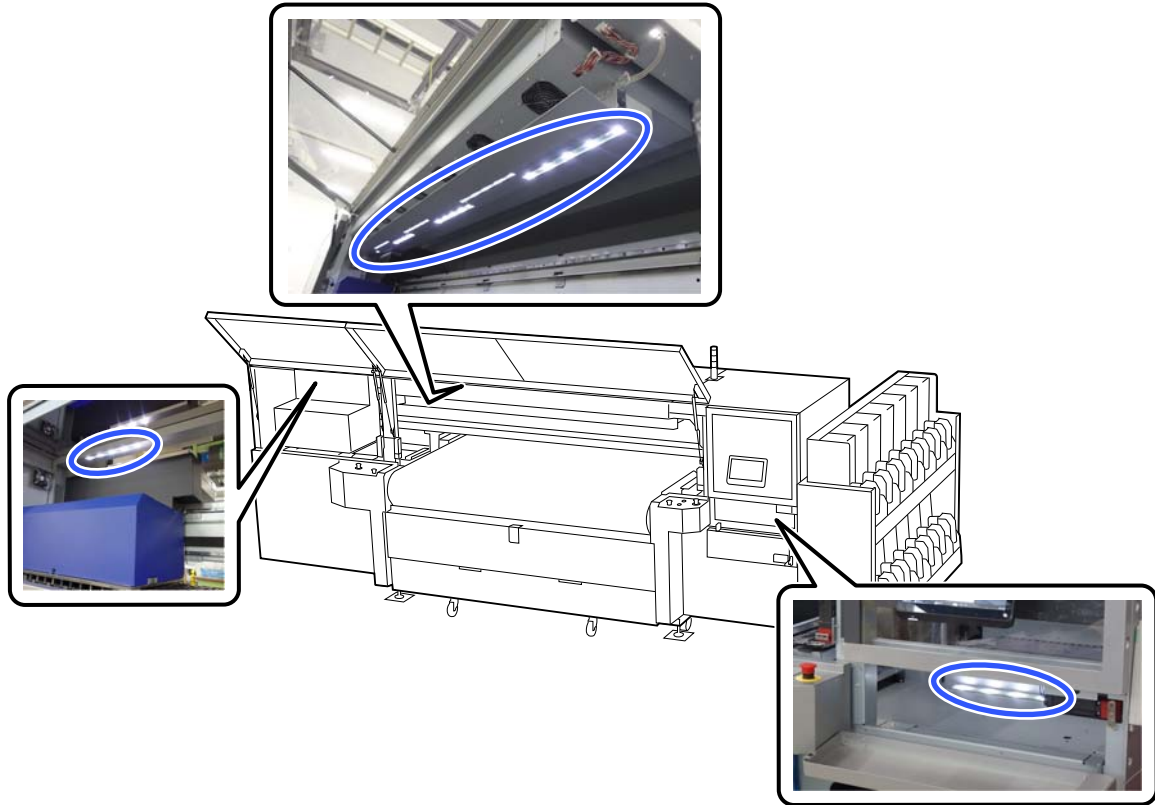


Maintenance

- 3 Soak a cleaning cloth in water, wring it out thoroughly, and then wipe away the dirt from the surface of the inside light (8 positions).

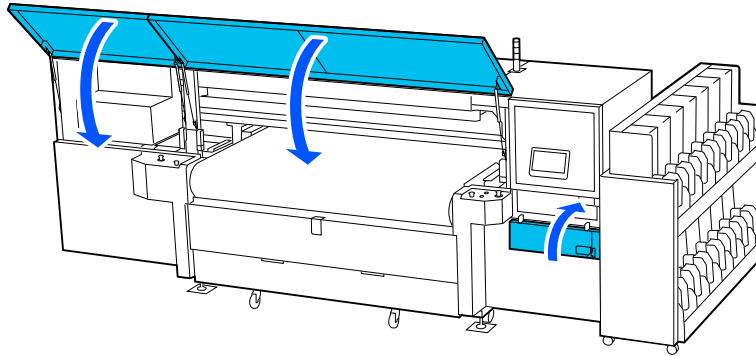
Wipe the dirt from all inside light surfaces.

For anything that cannot be removed with a damp cloth, dip a cloth in neutral detergent, squeeze it out, and then wipe the stubborn stain.



Maintenance

- 4 Close the front cover and the maintenance cover (Left and right).



Inspecting the Emergency Stop Device

Check that the machine stops correctly when an emergency stop button is pressed on the machine. Check any of the four emergency stop buttons.

- 1 Press the emergency stop button.



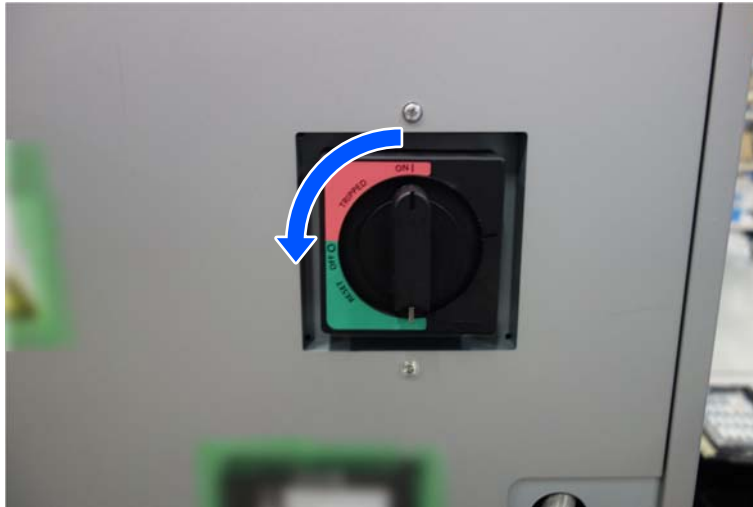
- 2 Confirm that the emergency stop message is displayed on the control panel, and that the signal lamp is red.

- 3 Turn the emergency stop button to the right.




Maintenance

- 4** Turn OFF the main power switch.



- 5** Turn on the printer.

 [“Turning On the Power” on page 51](#)

Cleaning the Cleaning Pad Blades

The cleaning pad blades are attached to the leftmost cleaning pad. Follow the steps below to perform cleaning. If ink deposits, lint, or dust accumulate even after regular cleaning, clean each time as needed.



1

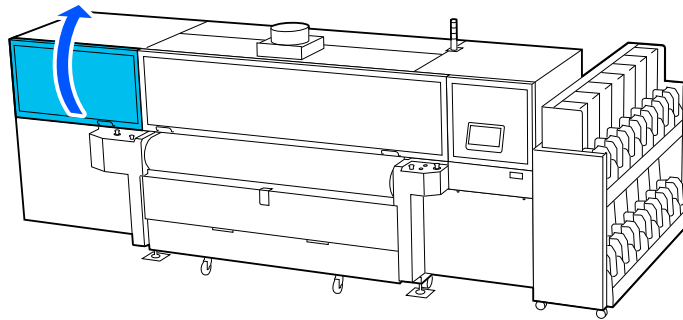
1 Blade

Required Items

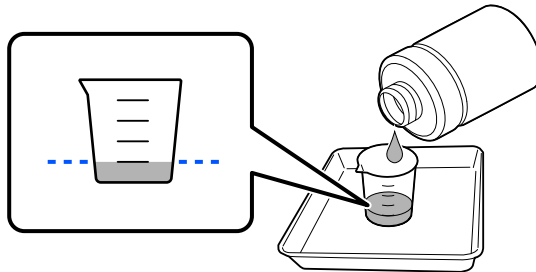
Cleaning kit, protective gloves, eye protection, protective clothing

Maintenance

- 1 Open the maintenance cover (left).

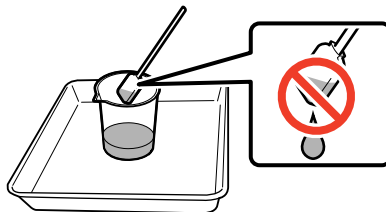


- 2 Place the container included in the cleaning kit on the tray and pour in approximately 10 ml (0.34 ounces) of cleaning liquid.



- 3 Dampen the cleaning stick with cleaning liquid.

When doing this, do not allow cleaning liquid to drip from the cleaning stick.



! **Important:**

Do not use cleaning liquid that you have used for cleaning to clean the next time. Using dirty cleaning liquid will make staining worse.

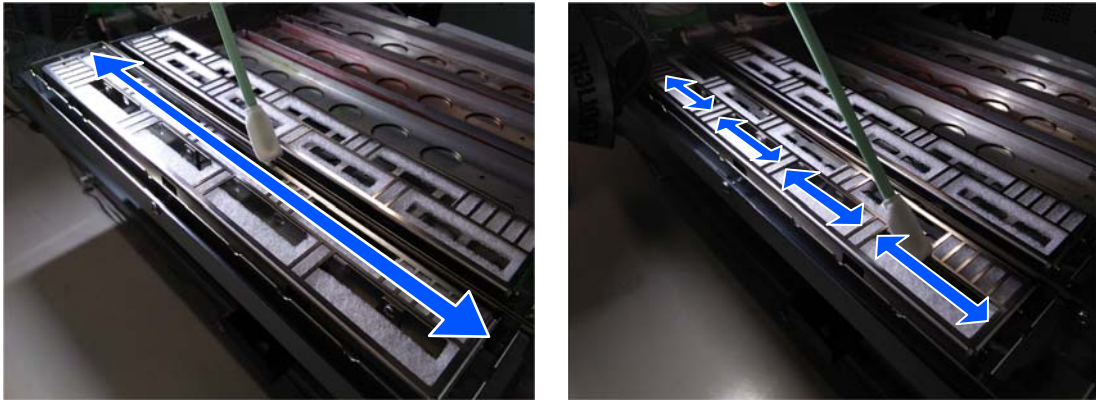
- Tightly close the lid of the cleaning liquid and store it at room temperature out of direct sunlight and away from high temperatures or humidity.*
- Used cleaning liquid and cleaning sticks are industrial waste. Dispose of them in the same way as for waste inks.*

- 4 Wipe off any ink, lint, or dust stuck to the tip of the cleaning pad blades using the cleaning stick.

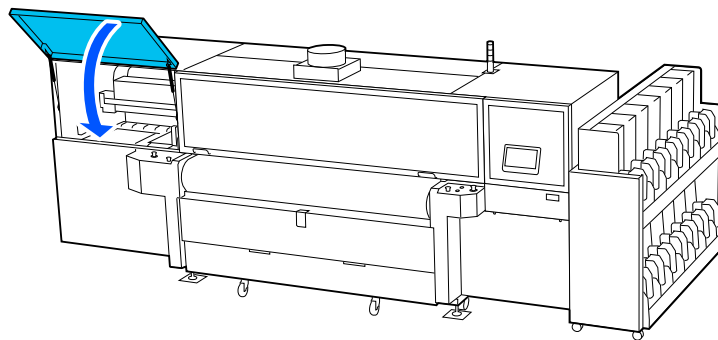
! **Important:**

- If the cleaning stick becomes dirty, rinse it with cleaning liquid as you wipe.*
- After removing a clot of ink with a cleaning stick, wipe the cleaning stick against the edge of the cup to remove the clot.*

Maintenance



5 Close the maintenance cover (left).



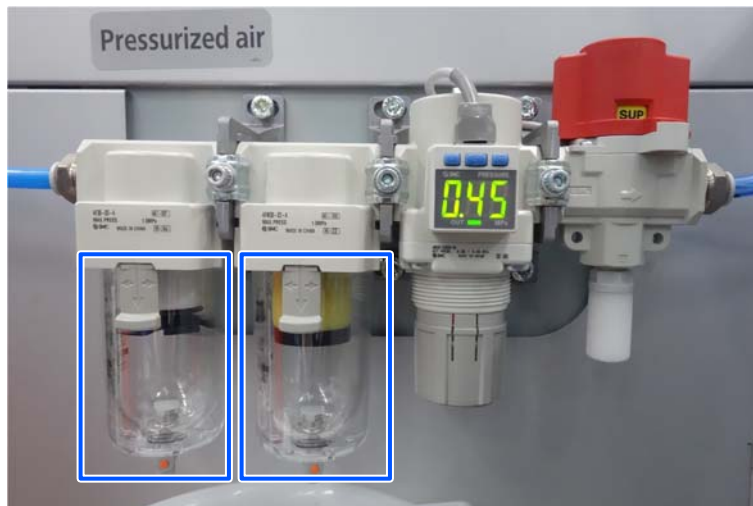
Inspecting/Draining the Air Supply Regulator

If drainage (liquid formed by the condensation of water vapor in compressed air) continues to accumulate in the filter case of the air supply regulator, it may cause the printer to malfunction.

Follow the steps below to inspect it. Drain any drainage that has accumulated in the filter case.

Inspection method

Check for water accumulation in the filter case for the air supply regulator.



Maintenance

Drain any water that has accumulated.

 [“Draining method” on page 212](#)

Draining method

Drain the drainage from the air supply regulator.


Required Items	Metal or plastic (PP/PE) container, protective gloves, eye protection, protective clothing
----------------	--

- 1 Stop the air pressure supply from the compressed air equipment to the printer and release the remaining pressure.

The location of the compressed air equipment and the method to stop the air pressure supply vary depending on your factory. For details, please check with the factory manager.

- 2 Check that the meter for the air supply regulator reads 0.00.

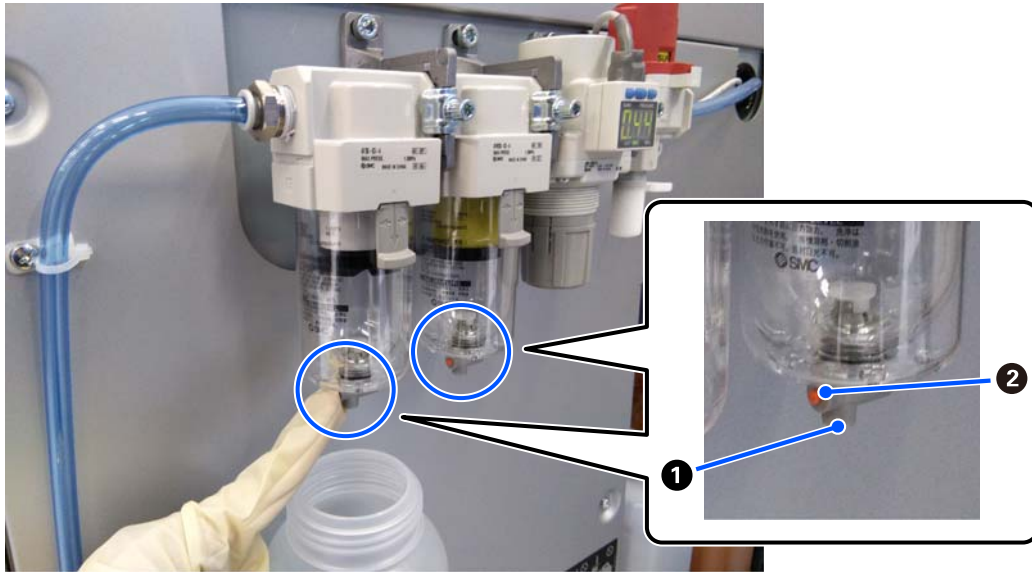
If the meter does not read 0.00, perform step 1 again.

 **Important:**
If you drain while the meter for the air supply regulator is not at 0.00, it may spray out with force.



Maintenance

- 3** Place the container under the drainage port (❶) on the air supply regulator, and then press the orange button (❷) to drain.



- 4** Supply air pressure to the printer from the compressed air equipment.

The location of the compressed air equipment and the method to supply air pressure vary depending on your factory. For details, please check with the factory manager.

- 5** Set the air pressure to the specified value.

 [“Adjustment method” on page 198](#)

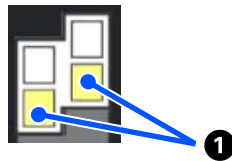
Cleaning the Suction Caps

If you do not clean the suction caps, doing Print Head Refresh is not fully effective. Follow the steps below to clean the suction caps every week after powering on the printer and before running Print Head Refresh.

Required Items	Cleaning kit, protective gloves, eye protection, protective clothing
----------------	--

- 1** From the Maintenance screen on the control panel, touch **Weekly - Clean the Suction Cap**, in that order.

The suction caps that require cleaning are indicated in yellow (❶) on the screen.

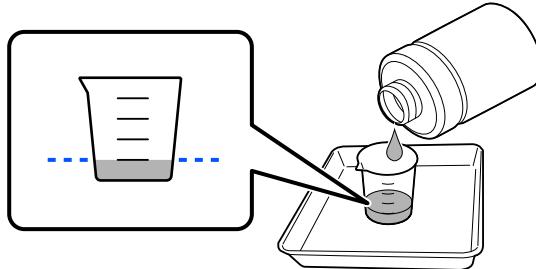


- 2** Check the on-screen message, and then touch **Start**.

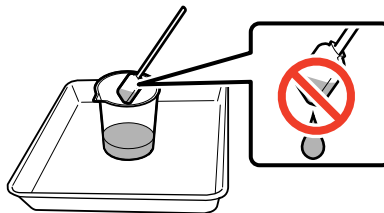
The print head moves to the right side of the front of the printer.

Maintenance

- 3 Open the maintenance cover (left).
- 4 Place the container included in the cleaning kit on the tray and pour in approximately 10 ml (0.34 ounces) of cleaning liquid.



- 5 Dampen the cleaning stick with cleaning liquid.
When doing this, do not allow cleaning liquid to drip from the cleaning stick.

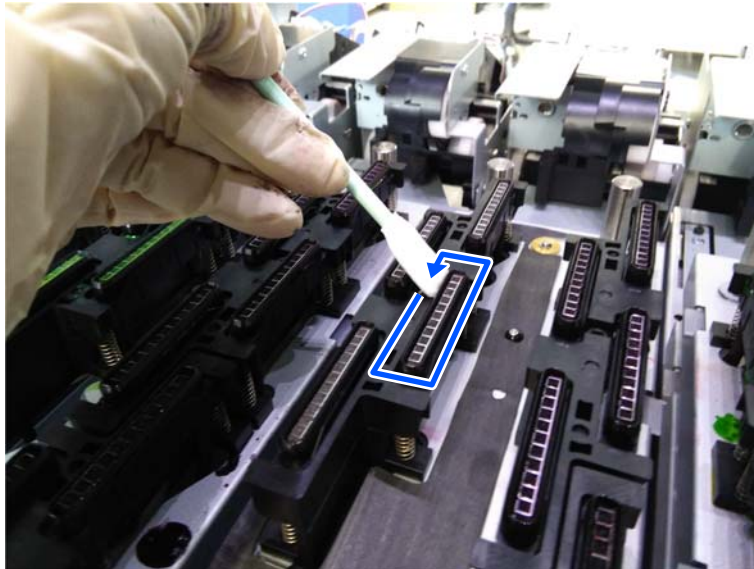
**Important:**

Do not use cleaning liquid that you have used for cleaning to clean the next time. Using dirty cleaning liquid will make staining worse.

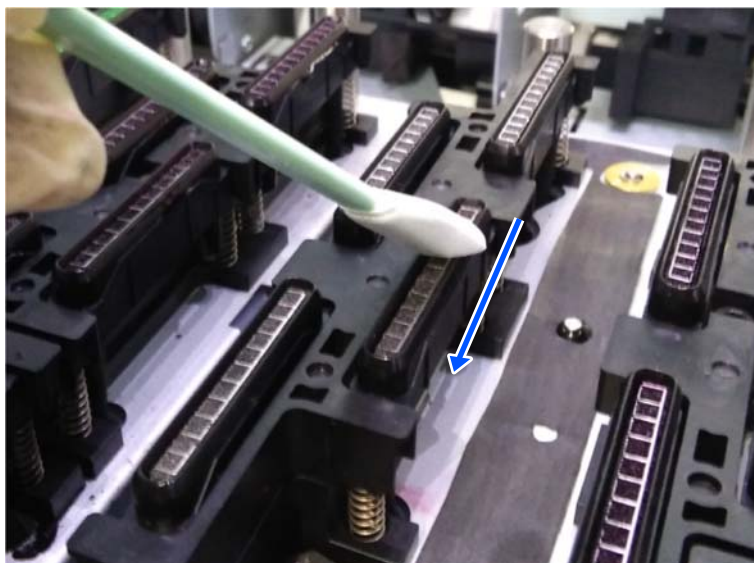
- ❑ *Tightly close the lid of the cleaning liquid and store it at room temperature out of direct sunlight and away from high temperatures or humidity.*
- ❑ *Used cleaning liquid and cleaning sticks are industrial waste. Dispose of them in the same way as for waste inks.*

Maintenance

- 6 Clean all suction caps indicated in yellow on the control panel's screen. Hold the cleaning stick vertically and wipe the outside of the cap.



- 7 Hold the cleaning stick flat and wipe all the edges.



- 8 Close the maintenance cover (left).

- 9 Touch the **Complete** button on the control panel.

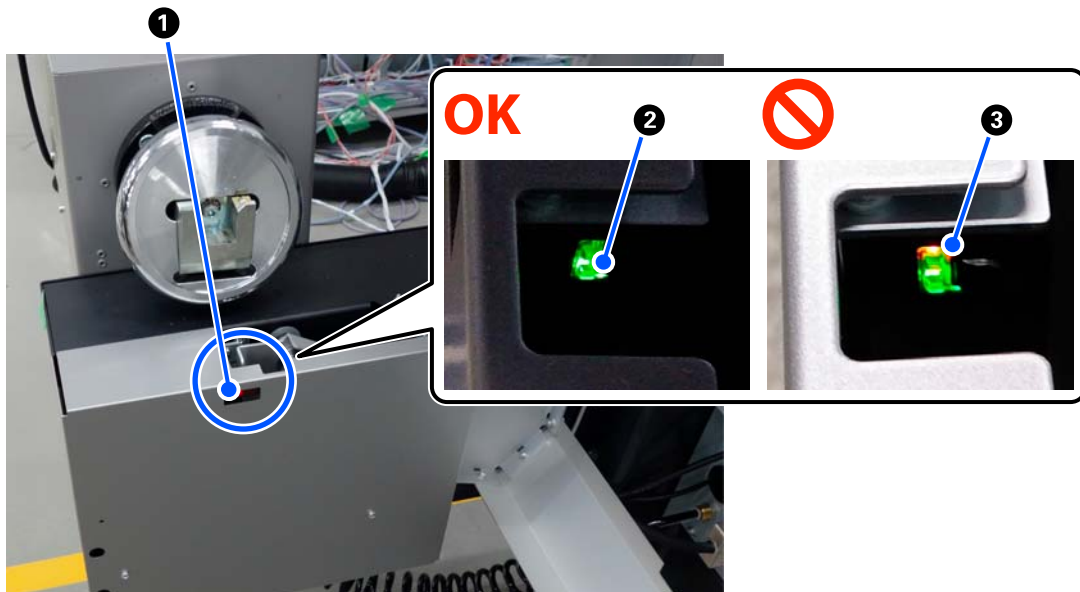
The print head moves to the left side of the front of the printer.

Inspecting/Cleaning the Sensors

Inspection method

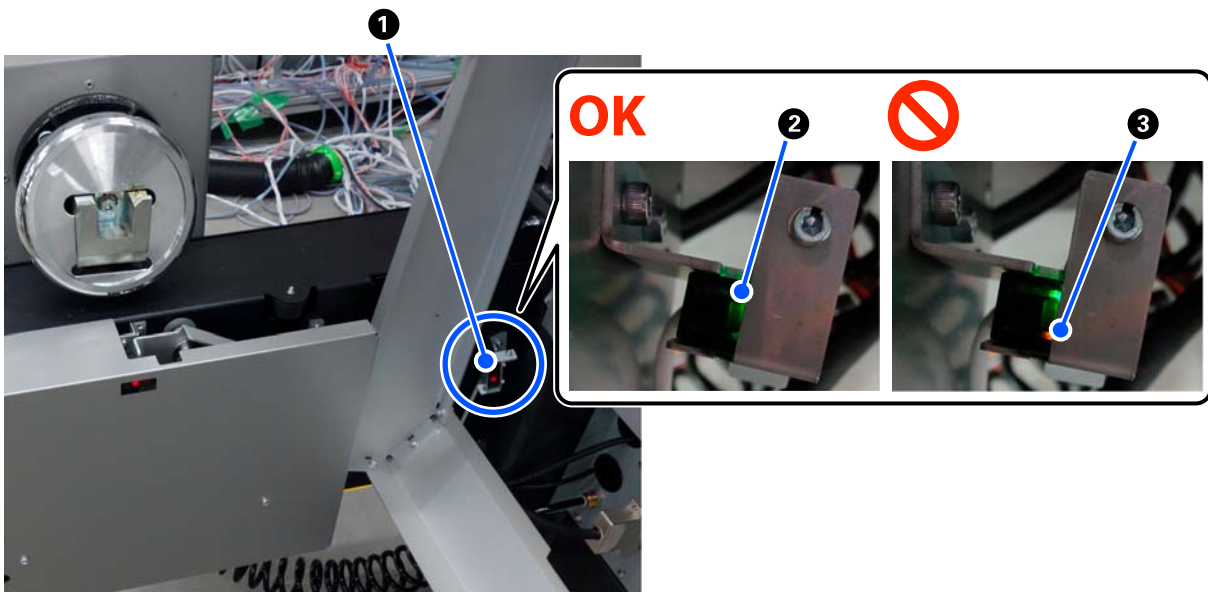
Check that the red lights on the sides of the roll diameter measurement sensor and the slack detection sensor at the back of the printer are on, and that the green lights on top of the sensors are on. If the orange light on top of the sensor is also lit, it means that an obstruction has been detected. Remove any obstructions from the sensor's optical axis.

Roll Diameter Measurement Sensor



- ① Red light
- ② Green light
- ③ Orange light

Slack Detection Sensor



Maintenance

- ① Red light
- ② Green light
- ③ Orange light

If the sensors are dirty, clean the sensors and the reflector plates opposite the sensors using cleaning cloths or the like.

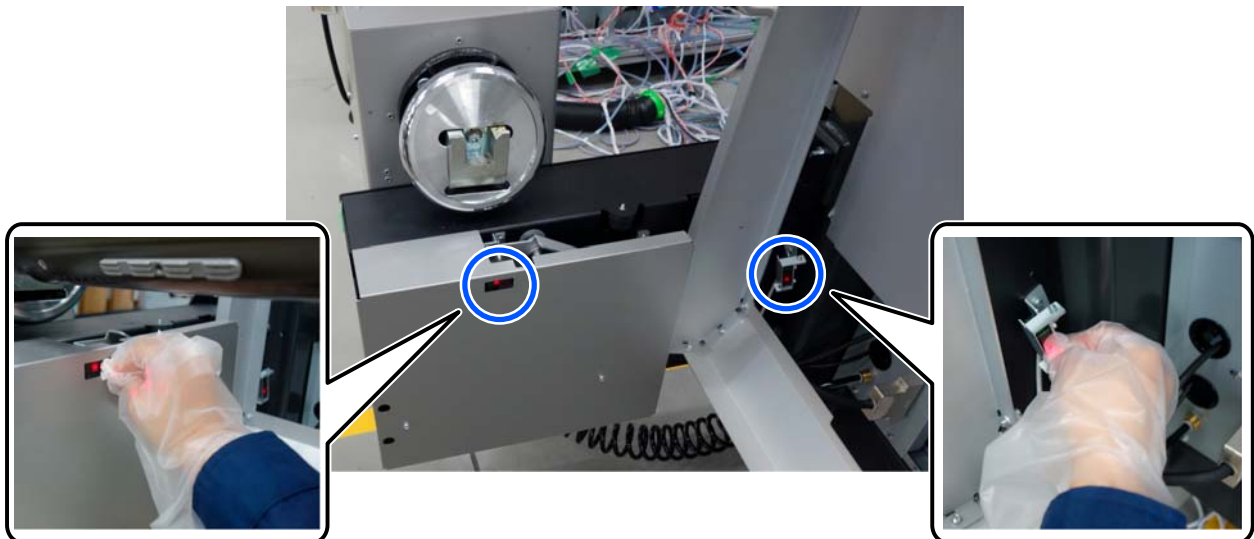
 [“Cleaning method” on page 217](#)

If the sensors do not respond well even after cleaning the sensors and the reflector plates, or if the light on top of the sensor remains orange even after removing any obstructions, reset each of the sensors.

 [“Slack Detection Sensor and Roll Diameter Measurement Sensor” on page 131](#)

Cleaning method

- 1 Use cleaning cloths or the like to wipe off any dust or debris attached to the roll diameter measurement sensor and the slack detection sensor at the back of the printer.



- 2 Use cleaning cloths or the like to wipe off any dust or debris attached to the reflector plates opposite the sensors.



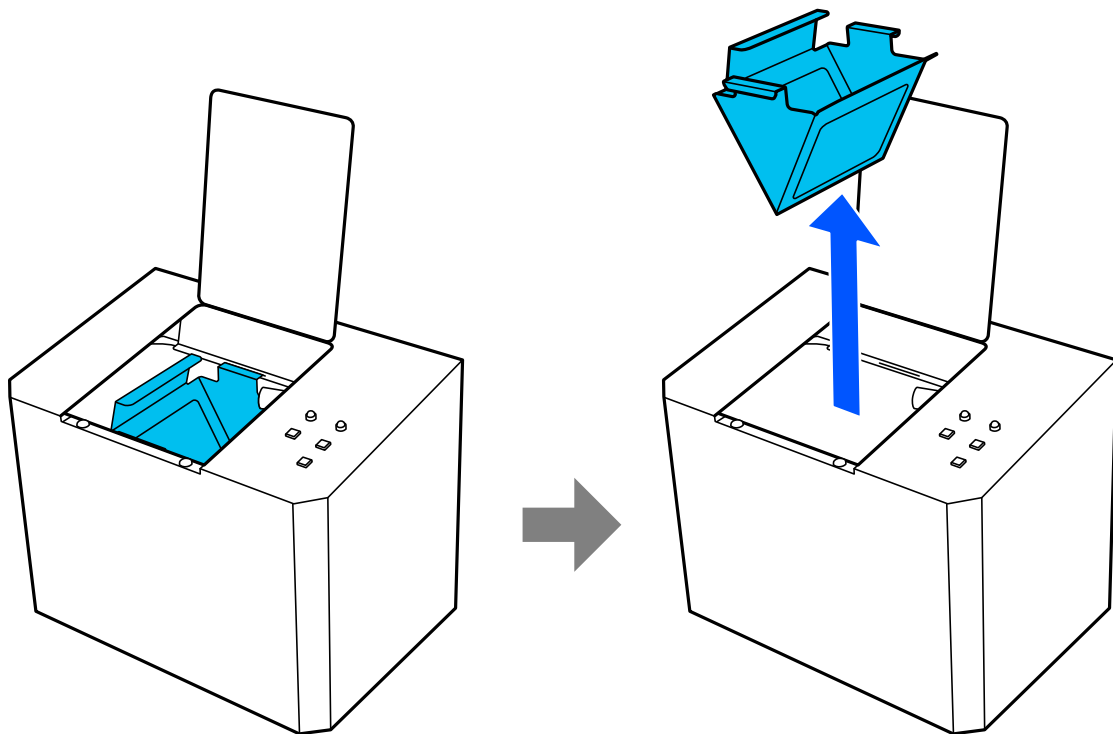
Maintenance

Cleaning Inside the Water Recycling Unit Tank

Required Items

Wipe cloths, brush, protective gloves, eye protection, protective clothing

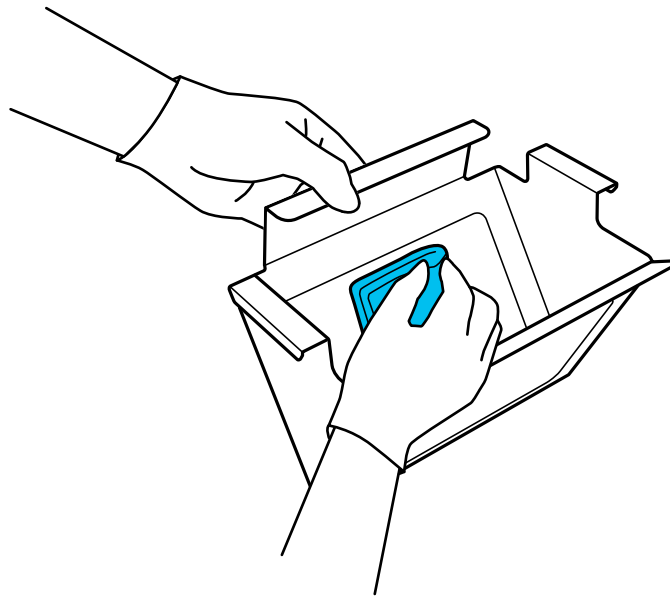
- 1 Open the drain valve on the printer.
- 2 Press the Drain button on the control panel of the water recycling unit.
The Power light flashes quickly, and the cleaning water drains from the tank. When draining is complete, the water recycling unit will pause.
- 3 Open the maintenance cover on the water recycling unit and make sure the water level in the tank has dropped to the min. water level sensor.
- 4 Turn off the printer.
[☞ “Turning Off the Power” on page 110](#)
- 5 Remove the lint trap.



- 6 Use a brush, wipe cloth, or similar item to remove lint and other debris from the lint trap.
If it is very dirty, soak it in a container filled with tap water to remove the dirt.

Maintenance

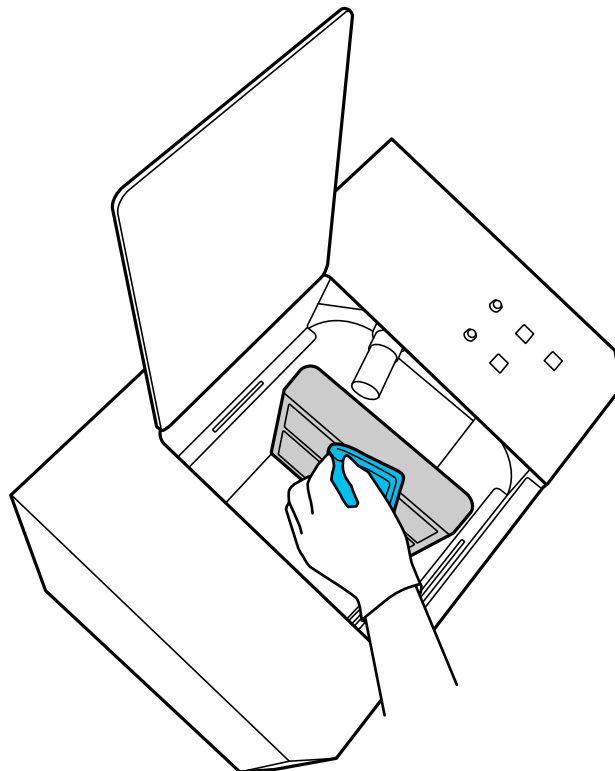
Used brushes, wipe cloths, and dirty water are considered industrial waste. Dispose of it in the proper manner.



- 7** Remove lint and other debris from the lint filter and from inside the tank.

Remove any dirt with a brush, wipe cloth, or similar item.

Used brushes and wipe cloths are considered industrial waste. Dispose of it in the proper manner.

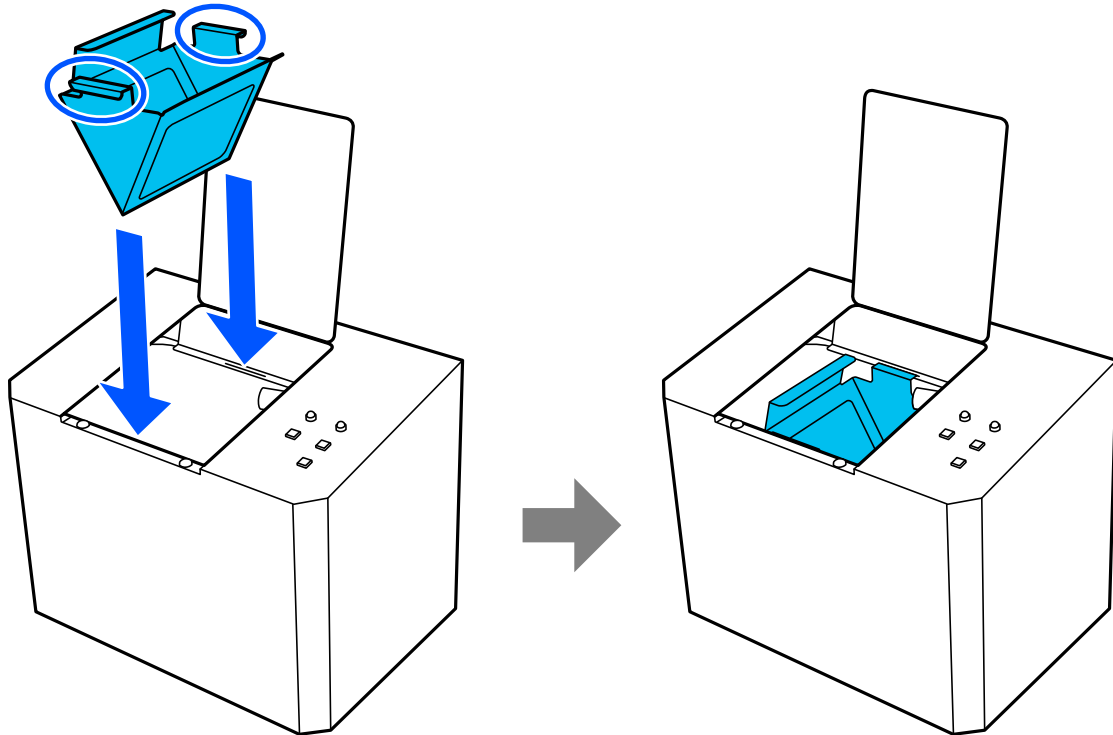


- 8** Remove any lint and other debris from the min. water level sensor and the max. water level sensor.

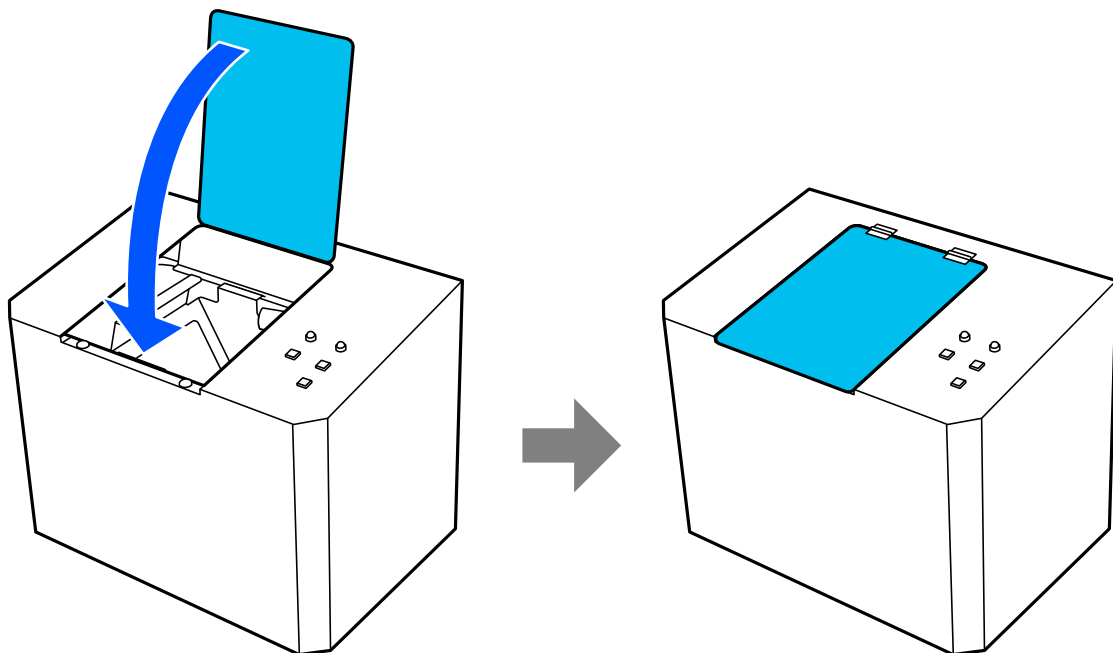
Maintenance

- 9** Return the lint trap to its original position.

Place the hooks of the lint trap over the notches of the water recycling unit, with the short side at the back of the water recycling unit and the long side at the front.

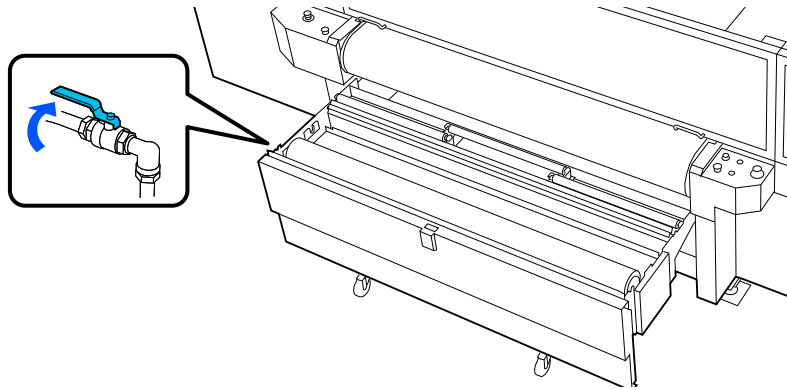


- 10** Close the maintenance cover on the water recycling unit.




Maintenance

- 11** Close the drain valve on the printer.



- 12** Turn on the printer.

 [“Turning On the Power” on page 51](#)

- 13** Make sure cleaning water flows into to the water recycling unit for at least five seconds.

Clean water is supplied if the water recycling unit starts operating with only a small amount of cleaning water in the tank.

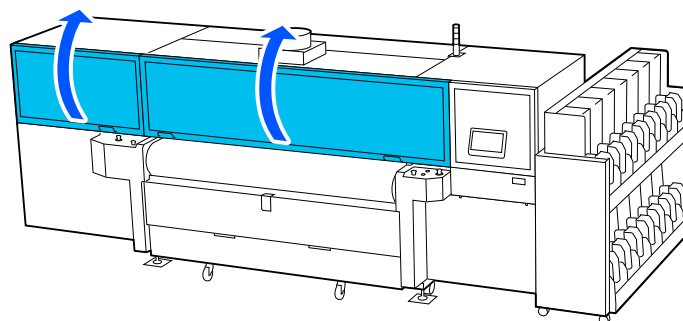
Inspecting/Cleaning the Cleaning Pad

This printer is equipped with five cleaning pads.

If there is any debris, lint, or ink deposits, it may come into contact with the print head and cause ink firing from the print head to fail. Follow the steps below to inspect it. Clean this if there is any debris, lint, or ink deposits.

Inspection method

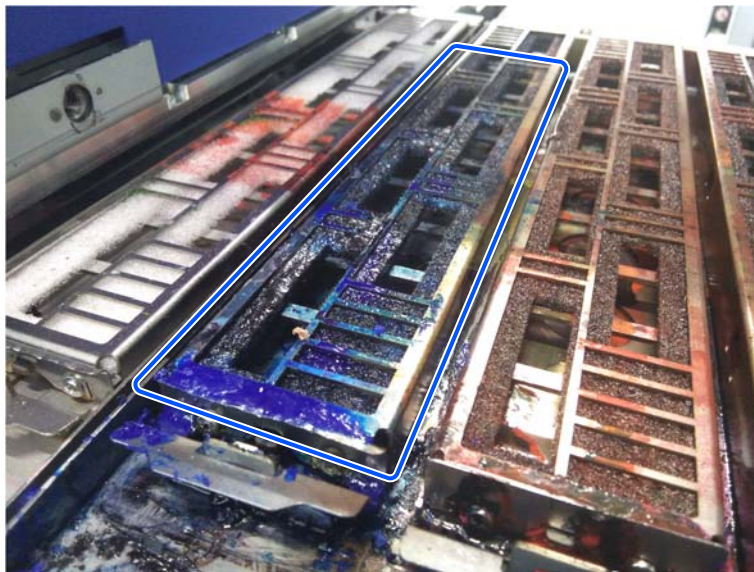
- 1** Open the front cover and the maintenance cover (left).



Maintenance

- 2 Check that there is no debris or lint on the cleaning pads, and that there are no ink deposits.

Dirty cleaning pad



If the cleaning pads have any debris, lint, or ink deposits, clean them after performing step 3.

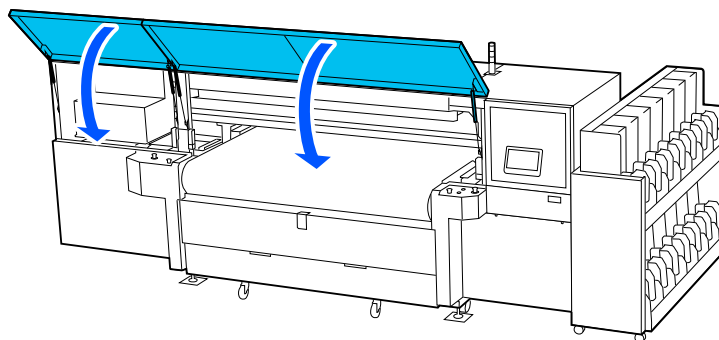
 [“Cleaning method” on page 222](#)

If cleaning does not remove the dirt from the cleaning pad, perform step 3, and then replace the inner porous pad of the cleaning pad.

 [“Replacing the Cleaning Pad” on page 256](#)

If the cleaning pad is deformed, contact your dealer or Epson Support.

- 3 Close the maintenance cover (left) and the front cover.



Cleaning method

Required Items	Container filled with tap water, tray, cleaning cloth, protective gloves, eye protection, and protective clothing
----------------	---

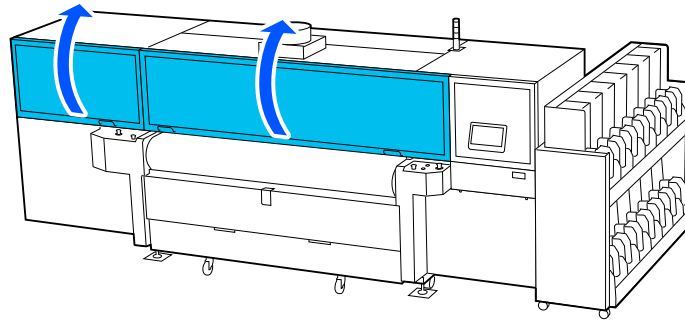
- 1 From the Maintenance screen on the control panel, touch **Daily - Cleaning Pad Cleaning**, in that order.

Maintenance

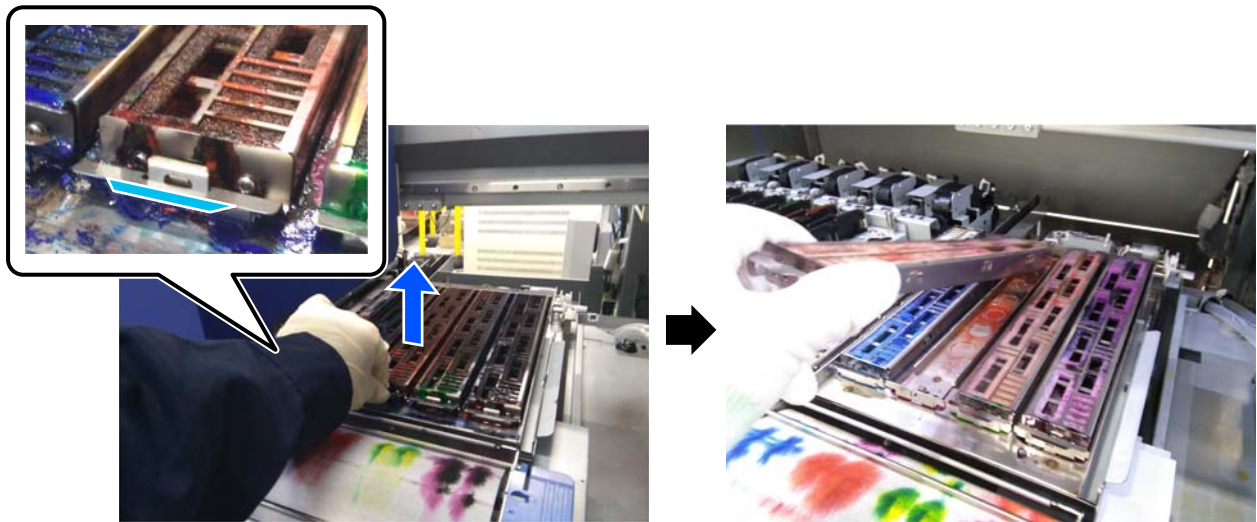
- 2 Check the message on the control panel and then touch **Start**.

The print head moves to the right when viewed from the front of the machine.

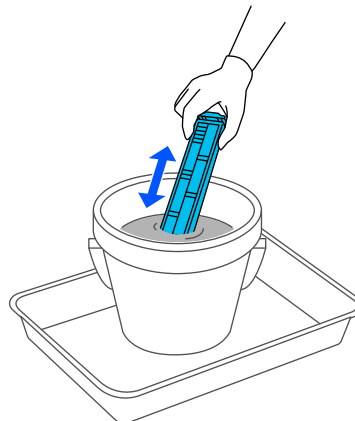
- 3 Open the front cover and the maintenance cover (left).



- 4 Lift the tab on the cleaning pad and remove the cleaning pad.

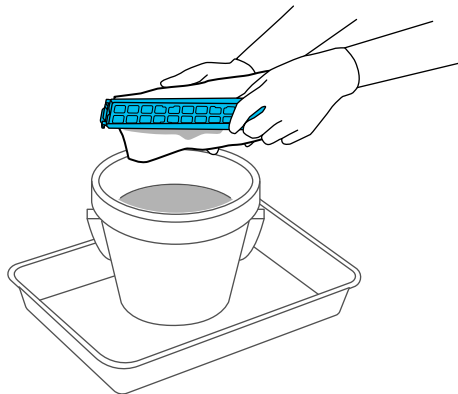


- 5 Place the cleaning pad in the container and remove the dirt.

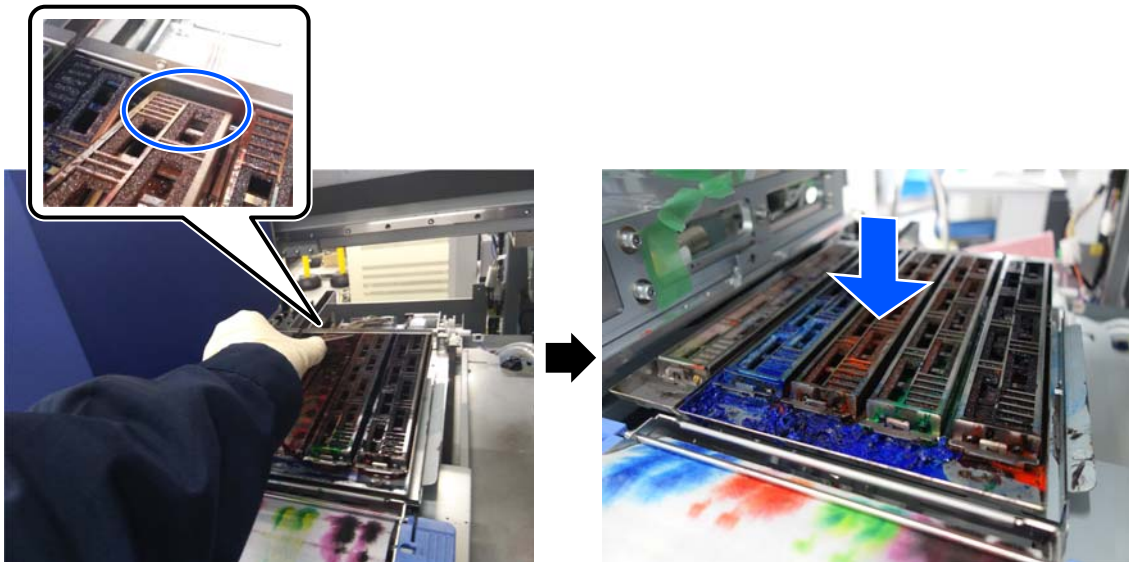


Maintenance

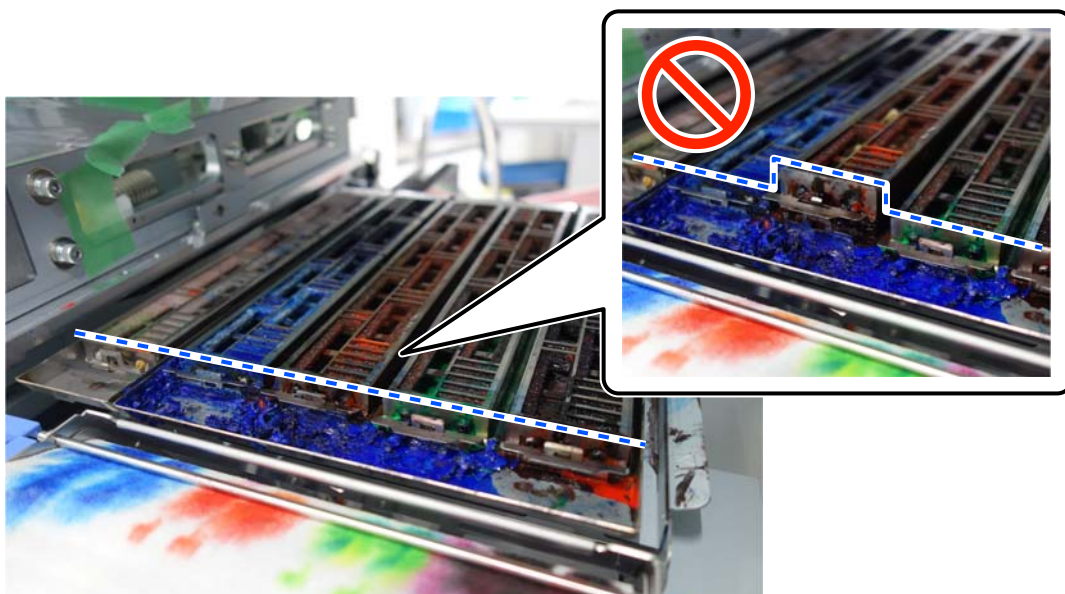
- 6 Press the cleaned cleaning pad against the cleaning cloth until no more water drips out. Perform this step while holding the pad over the container.



- 7 Insert the cleaning pad as shown in the illustration and place the cleaning pad in its original position.

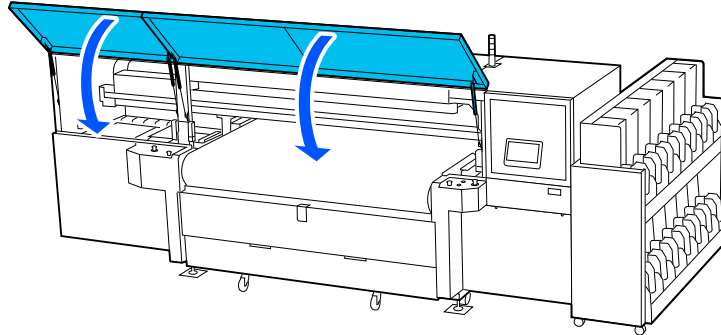


- 8 Check that the cleaning pad is not floating up. If the cleaning pad is floating up, place it again.



Maintenance

- 9 Use tap water to thoroughly wash the containers used to clean the cleaning pads.
- 10 Close the maintenance cover (left) and the front cover.



- 11 Touch the **Complete** button on the control panel.
The print head moves to the left when viewed from the front of the machine.

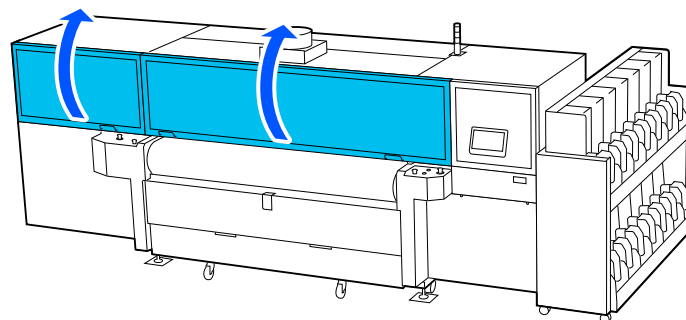
Inspecting/Cleaning the Flushing Pad

This machine is equipped with one flushing pad on the left and one on the right.

If there is any debris, lint, or ink deposits, it may come into contact with the print head and cause ink firing from the print head to fail. Follow the steps below to inspect it. Clean this if there is any debris, lint, or ink deposits.

Inspection method

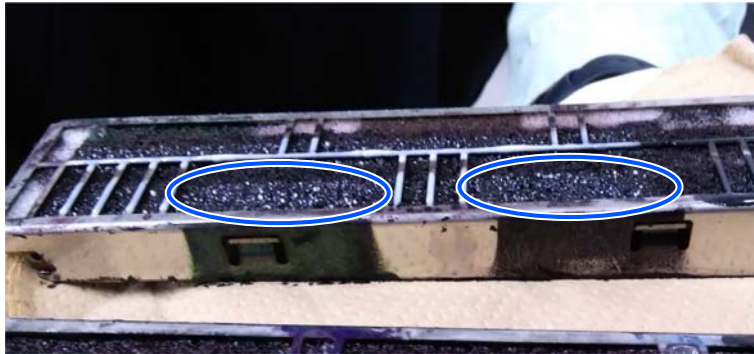
- 1 Open the front cover and the maintenance cover (left).




Maintenance

- 2 Check that there is no debris or lint on the flushing pads, and that there is no ink buildup.

Dirty flushing pad



If the flushing pads have any debris, lint, or ink deposits, clean them after performing step 3.

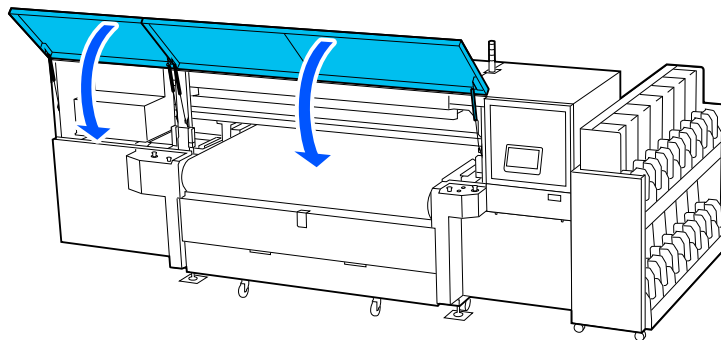
 [“Cleaning method” on page 226](#)

If cleaning does not remove the dirt, perform step 3, and then replace the inner pad of the flushing pad.

 [“Replacing the Flushing Pad” on page 252](#)

If the flushing pad is deformed, contact your dealer or Epson Support.

- 3 Close the front cover and the maintenance cover (left).



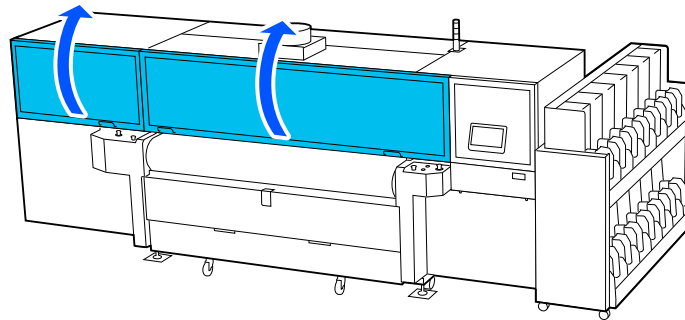
Cleaning method

Required Items	Container filled with tap water, tray, cleaning cloth, protective gloves, eye protection, and protective clothing
----------------	---

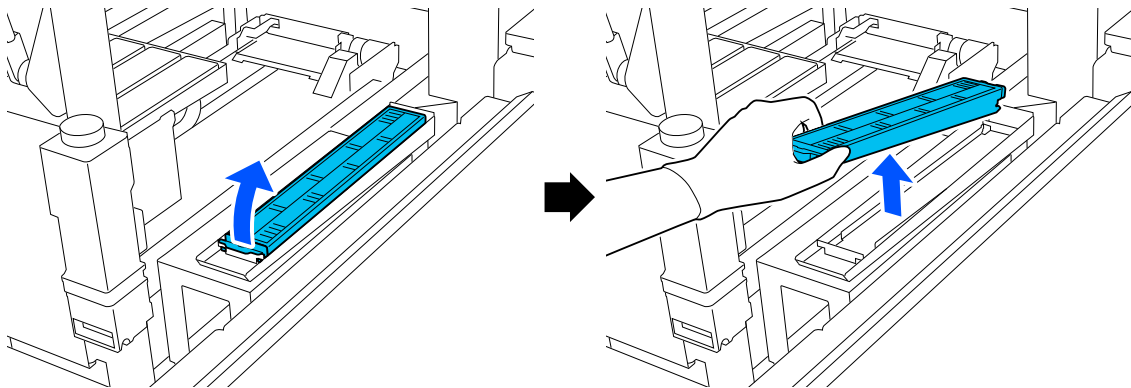
- 1 From the Maintenance screen on the control panel, touch **Daily - Flushing Pad Cleaning**, in that order.
- 2 Check the message on the control panel and then touch **Start**.

Maintenance

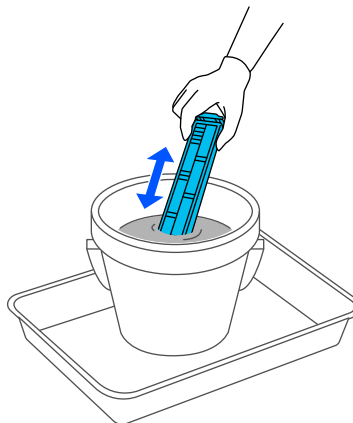
- 3** Open the front cover and the maintenance cover (left).



- 4** Lift the tab on the flushing pad and remove the flushing pad.

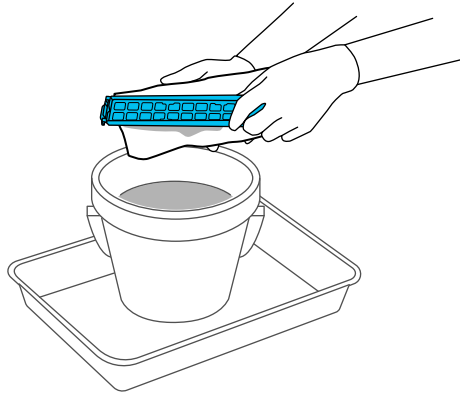


- 5** Put the flushing pad into a container and remove the staining.

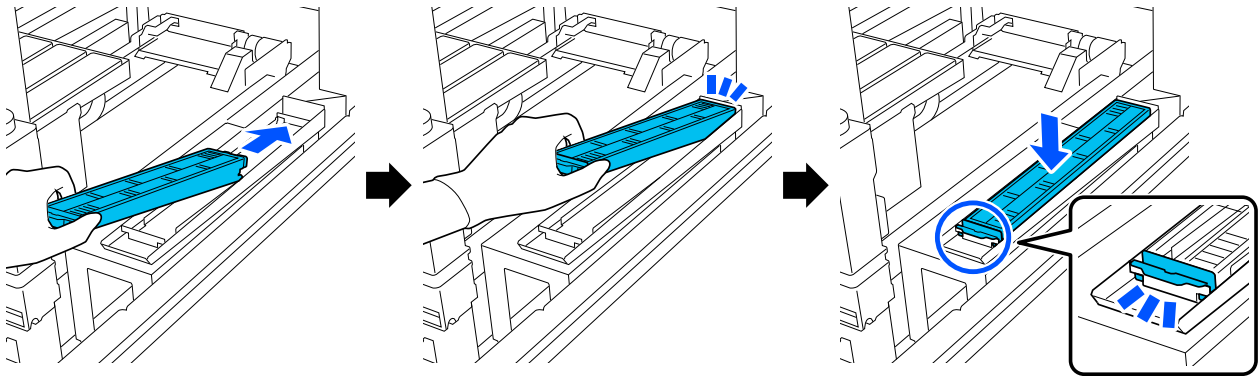


Maintenance

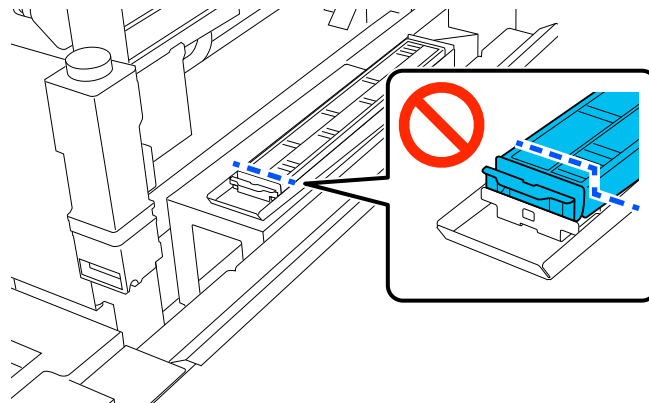
- 6** Press the cleaned flushing pad against the cleaning cloth until no more water drips out. Perform this step while holding the pad over the container.



- 7** Insert the flushing pad as shown in the illustration, and place it in its original position.



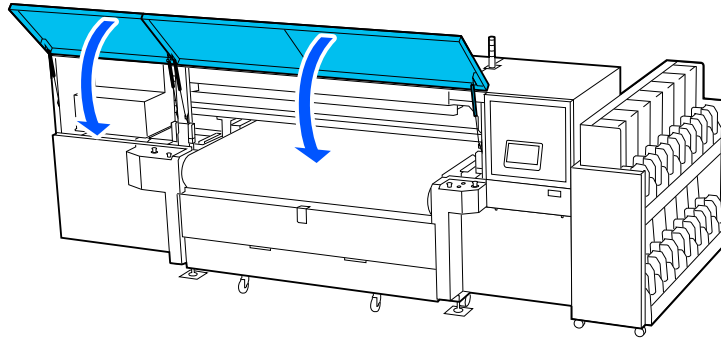
- 8** Check that the flushing pad is not floating up. If the flushing pad is floating up, place it again.



- 9** Use tap water to thoroughly wash the containers used to clean the flushing pads.

Maintenance

- 10** Close the maintenance cover (left) and the front cover.



- 11** Touch the **Complete** button on the control panel.

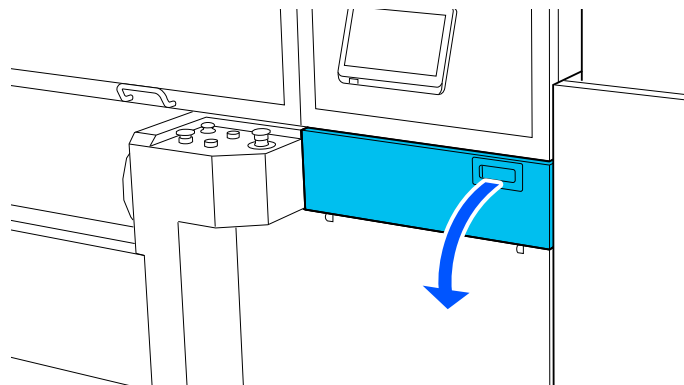
Inspecting/Cleaning Around the Print Head

If you print with ink deposits, lint, or dust around the print head, the print results may become dirty. Follow the steps below to inspect it. If any ink deposits, lint, or dust have accumulated, or if the following problems occur, clean the printer.


- The print head strikes the fabric
- Print results are dirty

Required Items	Cleaning kit, protective gloves, eye protection, protective clothing
----------------	--

- 1** From the Maintenance screen on the control panel, touch **Daily - Around the Head Cleaning**, in that order.
- 2** Check the on-screen message, and then touch **Start**.
The print head moves to the right when viewed from the front of the machine.
- 3** Open the maintenance cover (right).

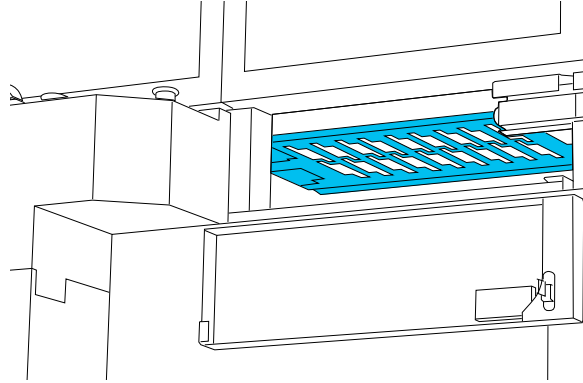


Maintenance

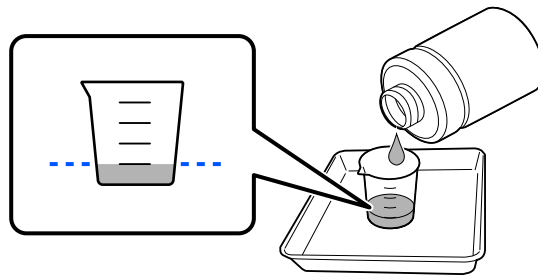
- 4** Check for dirt on the print head. Check that there is no ink, lint, or dust stuck to the  colored area shown in the illustration.

If it is dirty, then move on to the next procedure.

If it is not dirty, then move on to Step 8.

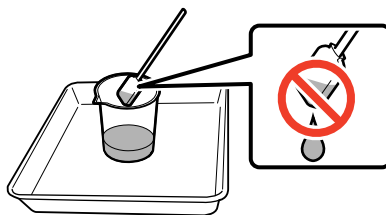


- 5** Place the container included in the cleaning kit on the tray and pour in approximately 10 ml (0.34 ounces) of cleaning liquid.



- 6** Dampen the cleaning stick with cleaning liquid.

When doing this, do not allow cleaning liquid to drip from the cleaning stick.



Important:

Do not use cleaning liquid that you have used for cleaning to clean the next time. Using dirty cleaning liquid will make staining worse.

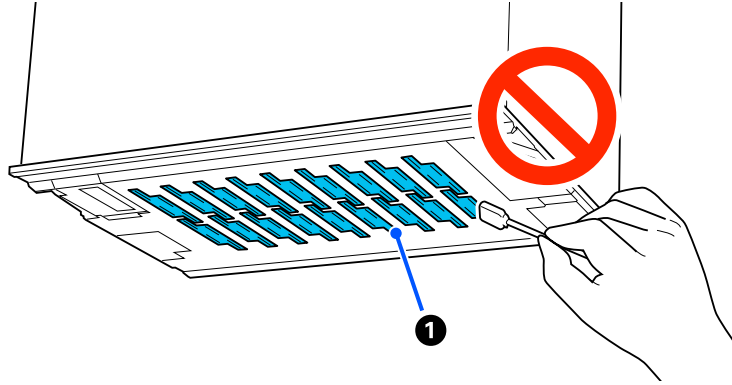
- Tightly close the lid of the cleaning liquid and store it at room temperature out of direct sunlight and away from high temperatures or humidity.*
- Used cleaning liquid and cleaning sticks are industrial waste. Dispose of them in the same way as for waste inks.*

Maintenance

7

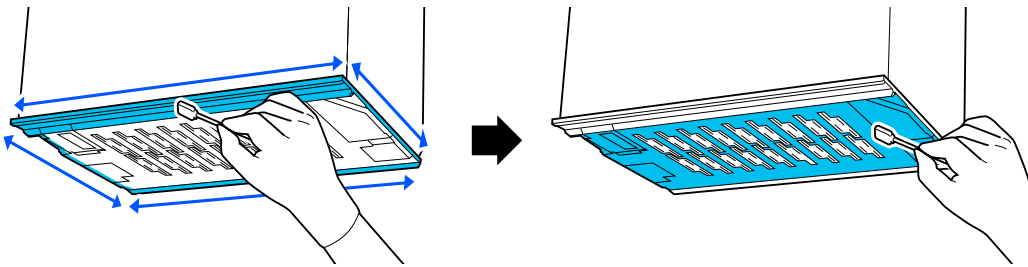
! *Important:*

Do not touch the nozzle surface of the print head or wipe it with a cleaning stick.



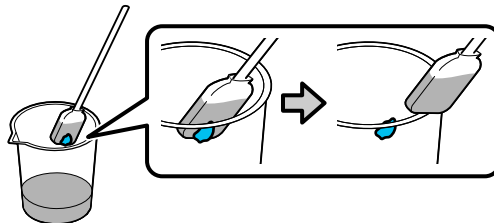
① *Print head nozzle surface*

Wipe off any ink, lint, or dust that is stuck to the colored area shown in the illustration. You do not need to wipe areas that are not dirty.



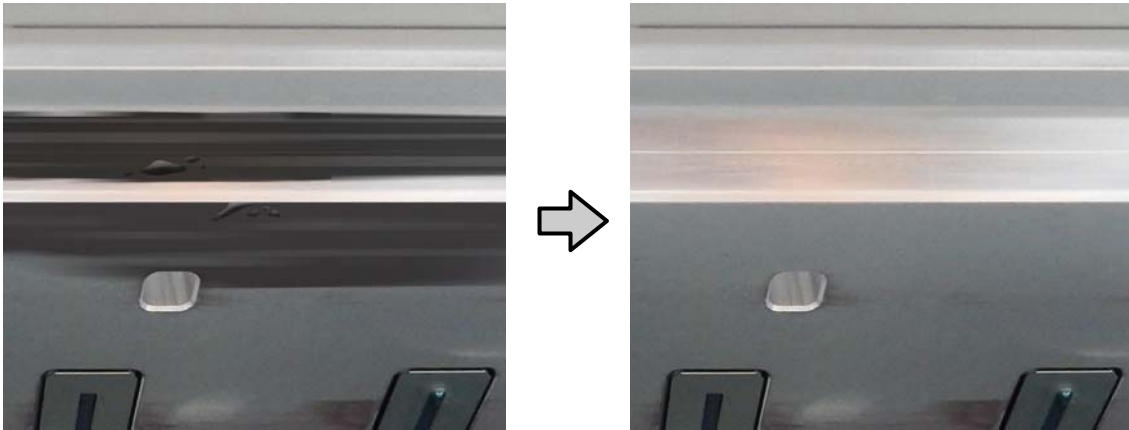
! *Important:*

- If the cleaning stick becomes dirty, rinse it with cleaning liquid as you wipe.*
- After removing a clot of ink with a cleaning stick, wipe the cleaning stick against the edge of the cup to remove the clot.*



Maintenance

Wipe off the ink stains until you can see the metal surface of the print head, as shown in the illustration.



8 Close the maintenance cover (right).

9 Touch the **Complete** button on the control panel.

The print head moves to the left when viewed from the front of the machine.

Drying the Sponge Roller

If you print while the sponge roller is wet, the print results may become uneven or blurred. Follow the steps below to dry it.



Caution:

The belt cleaning unit weighs over 110 kg, so make sure you bend your knees sufficiently and work in a natural position.

Pulling or pushing the unit with incorrect posture can lead to injury and back pain.

Required Items	Protective gloves and clothing, eye protection
----------------	--

1 Check that **Lift Up** is displayed in **Belt Cleaning Tank** on the Home screen on the control panel.

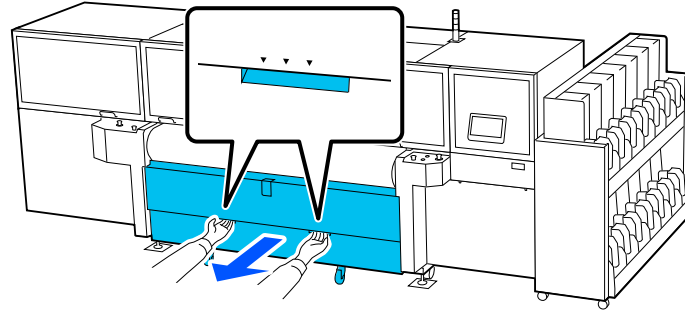
When **Lift Up** is displayed, you can pull out the belt cleaning tank.

When **Set Down** is displayed, touch the display area and lower the cleaning tank.

Maintenance

2 Make sure the machine has stopped, and then pull out the belt cleaning unit.

Hold the handles on the front of the belt cleaning unit to pull it out.



3 Squeeze the sponge roller to dry it out. Squeeze the entire length of the sponge roller until no more water drips out.

Do not squeeze the sponge roller by twisting it.



! **Important:**

In the following cases, the condition of the sponge roller, glue applied to the belt, or washing scraper may have deteriorated.

- When the sponge roller is absorbing more water than usual
- When water droplets form on the belt even after drying the sponge roller

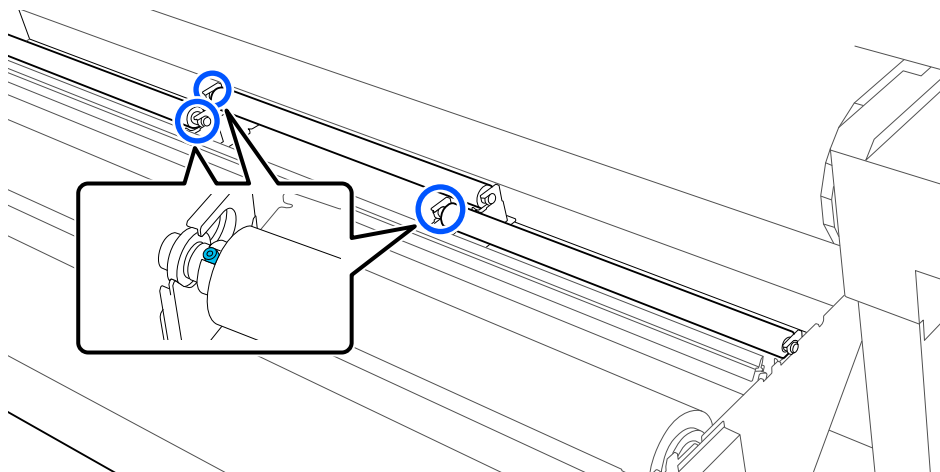
Maintenance

Note:

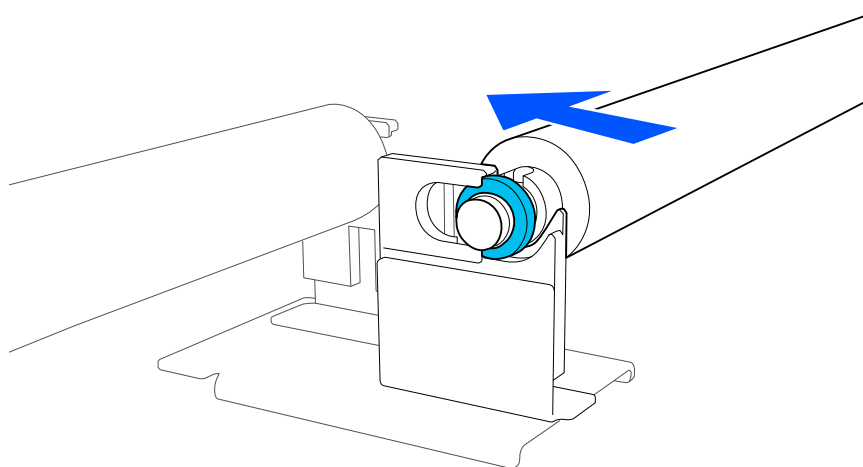
When squeezing the sponge roller, the sponge roller may come off the belt cleaning tank. Reattach the sponge roller if it comes off.

1. Check the mounting direction of the sponge roller.

The mounting direction depends on the position of the sponge roller. Install the stopper so that it fits in the position indicated in the illustration.



2. Set the sponge roller so that the left and right bearings fit into the grooves in the mounting section, and push the sponge roller all the way in until it clicks into place.



If you continue to use this function, the print result may become uneven or blurred.

See the following and take appropriate action.

 [“Water droplets remain on the belt after belt cleaning” on page 464](#)

4

Push the cleaning unit back to its original position.

Maintenance

Inspecting/Cleaning the Ink Path

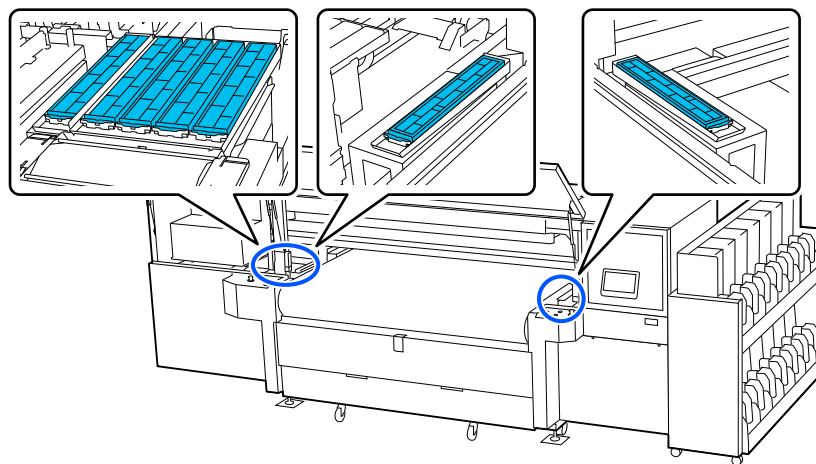
If the ink path is clogged, waste ink may leak from the flushing pads, the cleaning pads, or the surrounding areas.

Flushing water through the ink path can wash out the waste ink accumulated in the ink path. Perform an inspection and make sure there are no ink leaks before cleaning. When a message is displayed informing you that the waste ink bottle needs to be replaced, dispose of the waste ink before cleaning.

 [“Replacing the Waste Ink Bottle” on page 247](#)

Inspection method

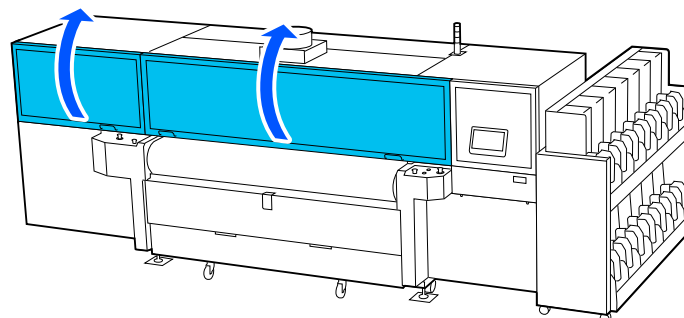
Check whether waste ink is leaking from the flushing pad, cleaning pad, or the surrounding area.



If ink is leaking, contact your dealer or Epson Support.

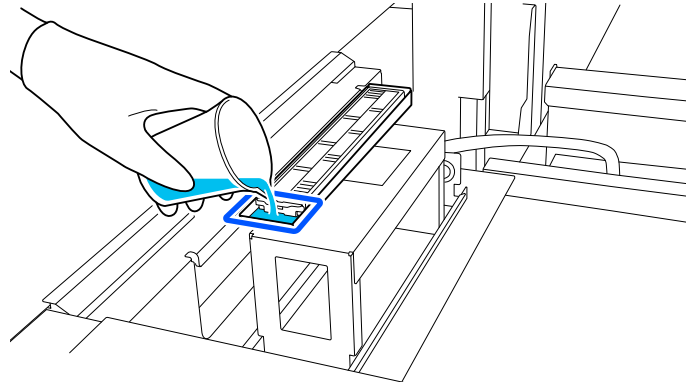
Cleaning method

- 1 From the Maintenance screen on the control panel, touch **Monthly - Ink Path Cleaning**, in that order.
- 2 Check the on-screen message, and then touch **Start**.
The print head moves to the right when viewed from the front of the machine.
- 3 Open the front cover and the maintenance cover (left).

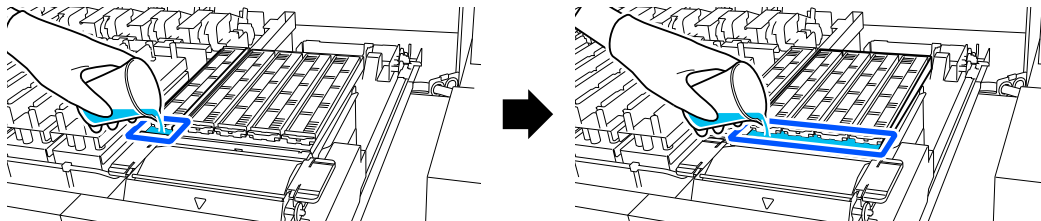


Maintenance

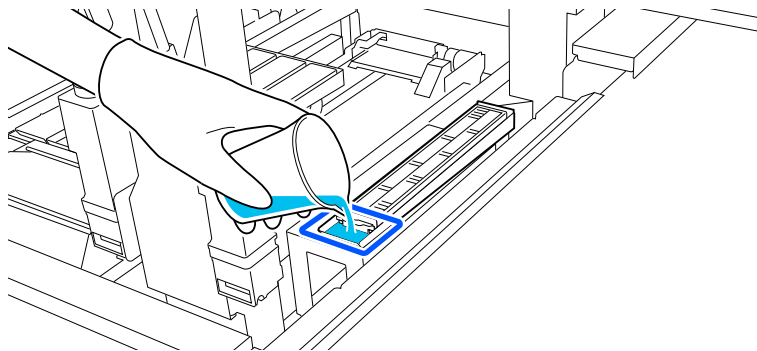
- 4** Pour approximately 100 ml (3.38 ounces) of tap water into the locations shown in the illustration of the right flushing pad.



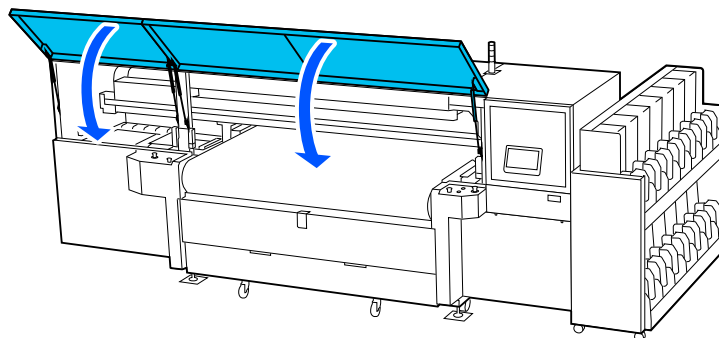
- 5** Pour approximately 200 ml (6.76 ounces) of tap water (400 ml total) into the locations shown in the illustration for the cleaning pad.



- 6** Pour approximately 100 ml (3.38 ounces) of tap water into the locations shown in the illustration of the left flushing pad.



- 7** Close the front cover and the maintenance cover (left).



Maintenance

- 8** Touch the **Complete** button on the control panel.

The print head moves to the left when viewed from the front of the machine.

Cleaning the Belt Cleaning Unit

After printing on fabric with significant amounts of lint, fibers or debris may get stuck on the cleaning brushes, washing scraper, or in the cleaning tank, reducing the cleaning effect. Follow the steps below to perform cleaning. Even if you clean regularly, clean the parts each time they are clogged with dust or debris.



Caution:

The belt cleaning unit weighs over 110 kg, so make sure you bend your knees sufficiently and work in a natural position.

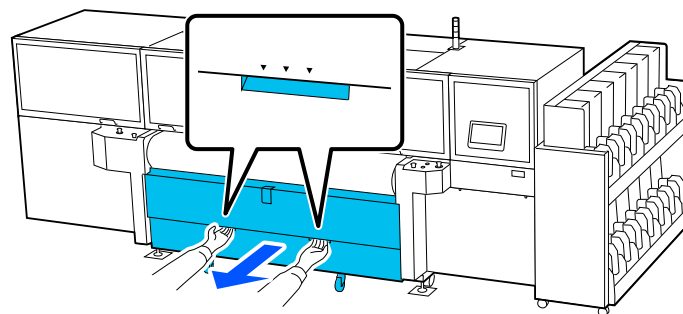
Pulling or pushing the unit with incorrect posture can lead to injury and back pain.

Item	Implementation procedure
Cleaning brushes	Steps 1-4, 13-14
Washing Scraper	Steps 1-3, 5, 13-14
Belt cleaning tank	Steps 1-3, 6-14

Note:

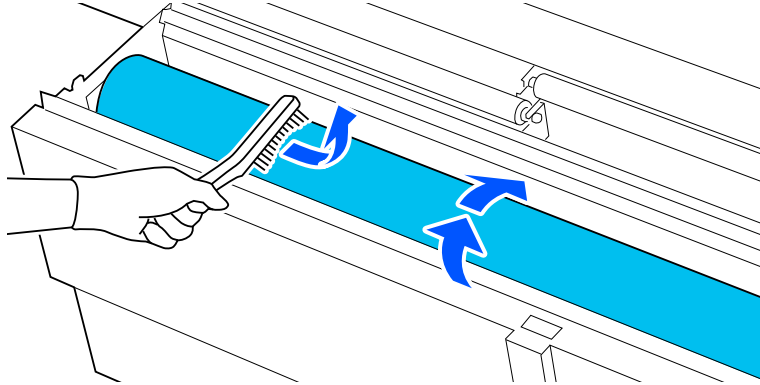
If lint or debris accumulates in the gutter connected to the belt cleaning unit, the gutter may overflow or wastewater may flow back into the cleaning tank. We also recommend that you inspect and clean the guttering on a regular basis.

- 1** Press the Pause/Restart button on the water recycling unit.
Wait until the Power light flashes and the water recycling unit pauses.
- 2** Check that the Home screen on the control panel shows **Lift Up** for the **Belt Cleaning Tank**.
When **Lift Up** is displayed, you can pull out the belt cleaning tank.
When **Set Down** is displayed, touch the display area and lower the belt cleaning tank.
- 3** Hold the handles on the front of the belt cleaning unit to pull it out.

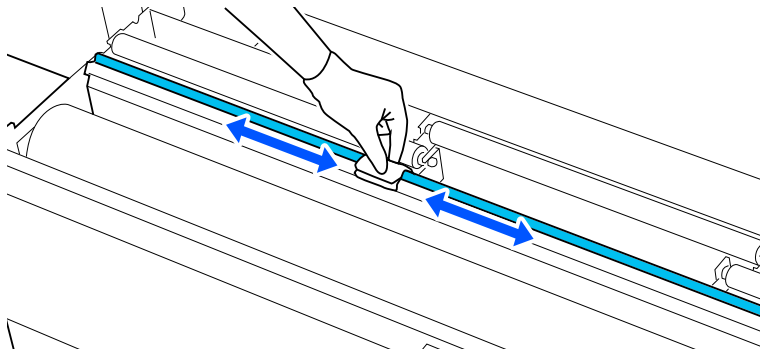


Maintenance

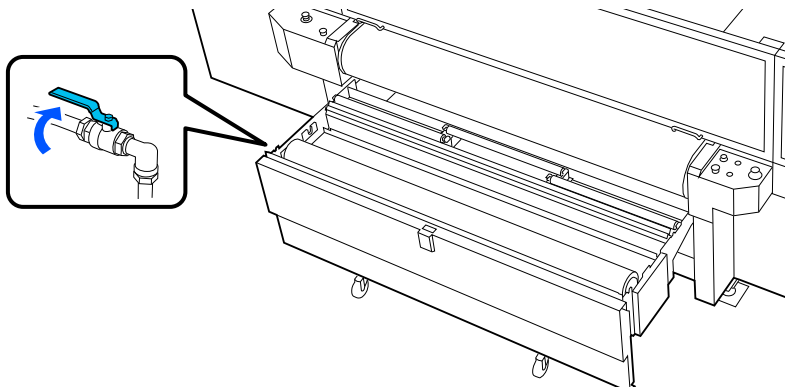
- 4** Remove all lint and debris attached to the cleaning brushes using a metal brush or similar tool.
Rotate the cleaning brush by hand to clean the entire surface of the brush.



- 5** Using a cleaning cloth or the like, remove all lint and debris from the washing scraper.

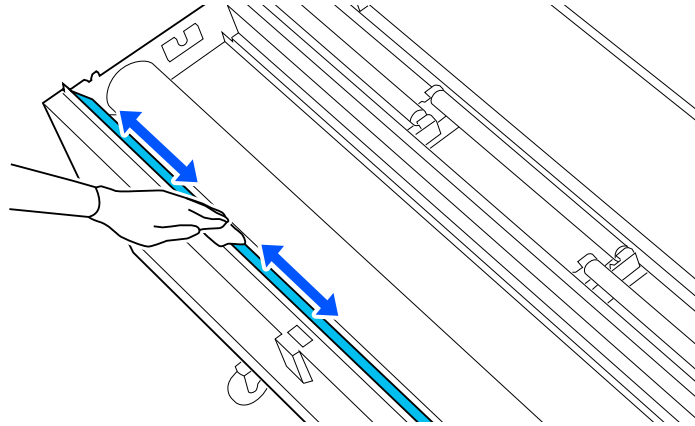


- 6** Open the drain valve and wait until the water level in the belt cleaning tank reaches the lowest level.

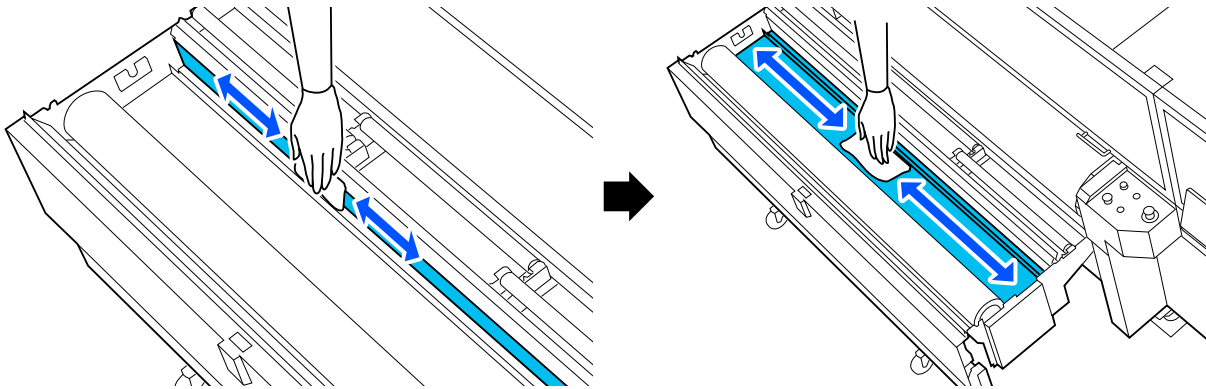


Maintenance

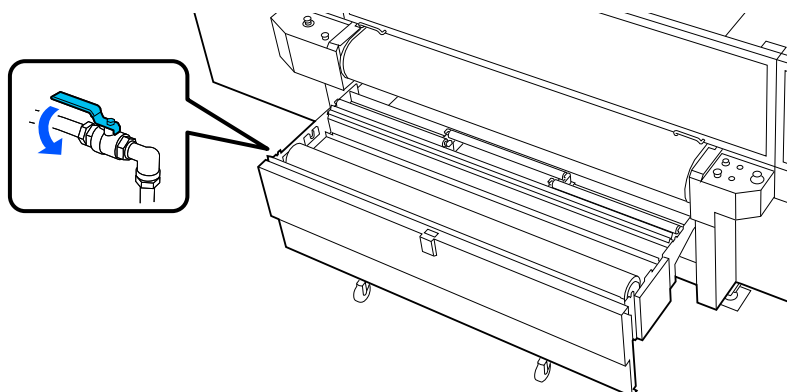
- 7 Wipe off all the lint and debris stuck to the area of the belt cleaning tank shown in the illustration with a cleaning cloth.



- 8 Wipe off all the lint and debris from the sides and bottom of the belt cleaning tank with a cleaning cloth.



- 9 Close the drain valve.



- 10 From the Maintenance screen on the control panel, touch **Maintenance - Belt Cleaning Unit Cleaning**, in that order.

- 11 Check the on-screen message, and then touch **Start**.

Supply of water to the cleaning tank begins.

Maintenance

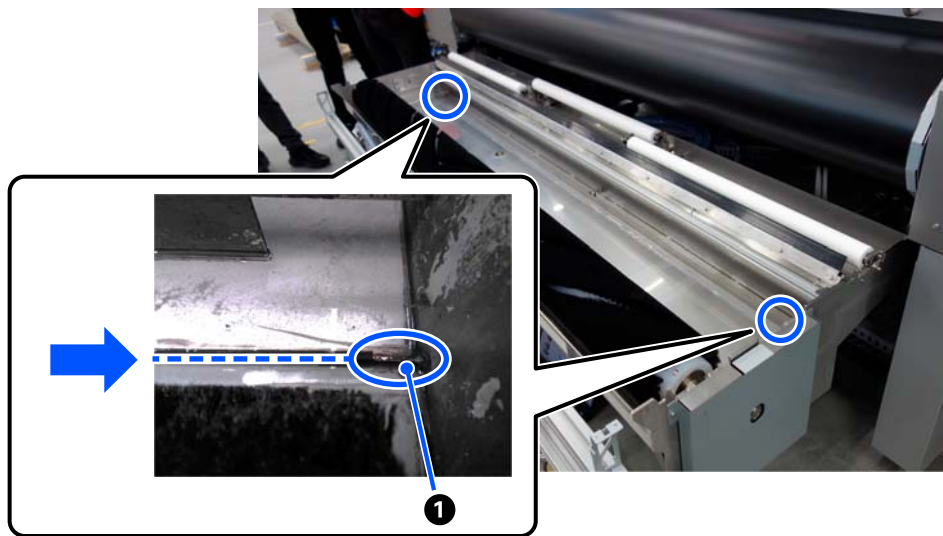
- 12** Once the water has been supplied to the level of the notches on either end of the belt cleaning tank, touch the **Suspended** button on the control panel.



Important:

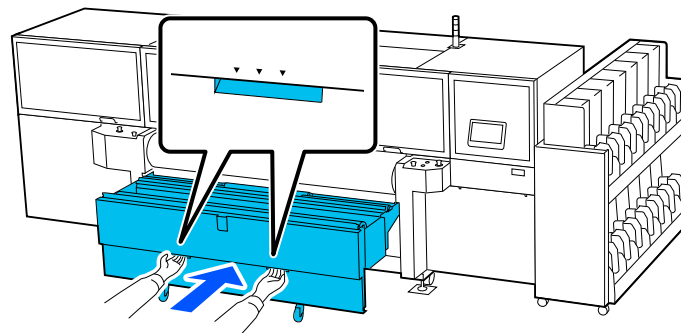
Do not stop the water supply below the level of the notch. The cleaning brush will rotate without water and the glue applied to the belt may peel off.

Even if the supplied water exceeds the height of the notch, there is no problem because the amount beyond the notch will drain away.



- 1** Notch

- 13** Push the belt cleaning unit back to its original position.



- 14** Press the Pause/Restart button on the water recycling unit.

The water recycling unit starts operating again, and the cleaning water flows into it.

Replacing Consumables

Replacing the Ink Cartridges

! Important:

- ❑ *Epson recommends the use of genuine Epson ink cartridges to ensure the best printer performance. The use of non-genuine products may cause the printer to become unable to function as intended, including negative effects on the print quality as well as the printer itself. Epson cannot guarantee the quality or reliability of non-genuine products. Repairs for printer damage or failures that occur due to the use of non-genuine products are subject to charges, even during the warranty period.*
- ❑ *Due to ink characteristics, the ink cartridges of this printer are prone to sedimentation (components settling to the bottom of the liquid). If ink settles, tint unevenness and nozzle clogs occur. Shake a new ink cartridge before installing it. After installing it in the printer, remove and shake it periodically.*

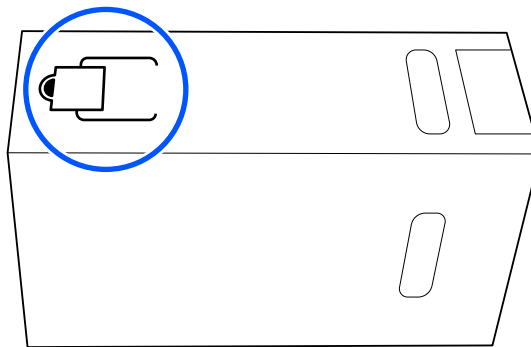
When the remaining amount of ink falls below the limit, the printer automatically switches the ink supply to the other ink cartridge of the same color. Printing will continue as it is, so replace the ink cartridge whose remaining quantity is below the limit and refill it with ink while the currently operating ink cartridge has sufficient ink. Ink cartridges that are not in operation can be replaced even during printing. You cannot print when the remaining amounts of both ink cartridges of the same color fall below the limit. Follow the procedure below to replace the ink cartridges. You can check the ink level on the Home screen.

 [“Home Screen” on page 30](#)

Required Items	New ink cartridge, protective gloves, and protective clothing
----------------	---

Opening and shaking

- 1** Place a new ink cartridge on a flat surface with the ink supply port slot facing up.

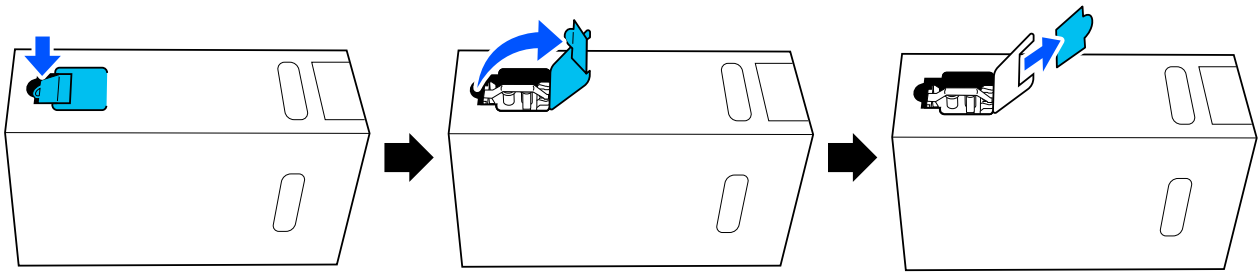


- 2** Use your hands to cut along the dashed lines of the slot to remove the top portion.

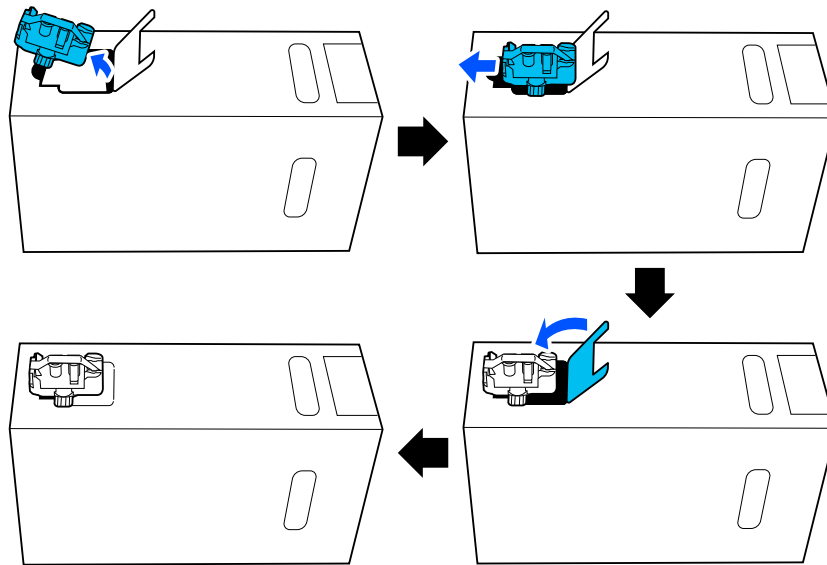
! Important:

Do not use a cutter to cut along the dashed lines. Failure to observe this precaution could damage the internal parts and cause ink to leak.

Maintenance

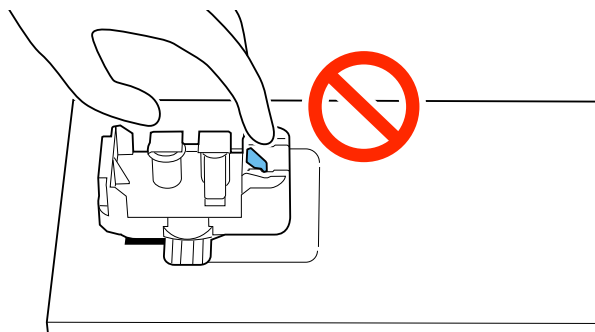


3 Take out the ink supply port and fix it as shown in the illustration.

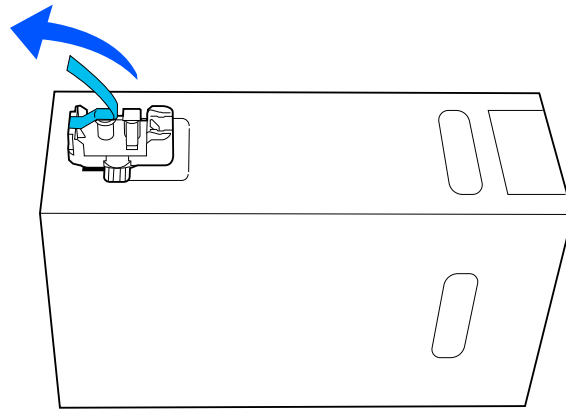


4 Peel the tape (yellow) from the surface of ink supply port.

! **Important:**
Do not touch the IC chip on the ink cartridge.

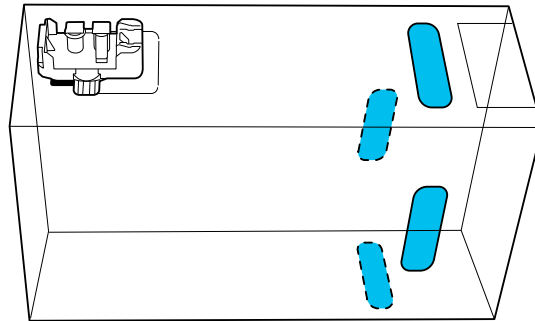


Maintenance



5

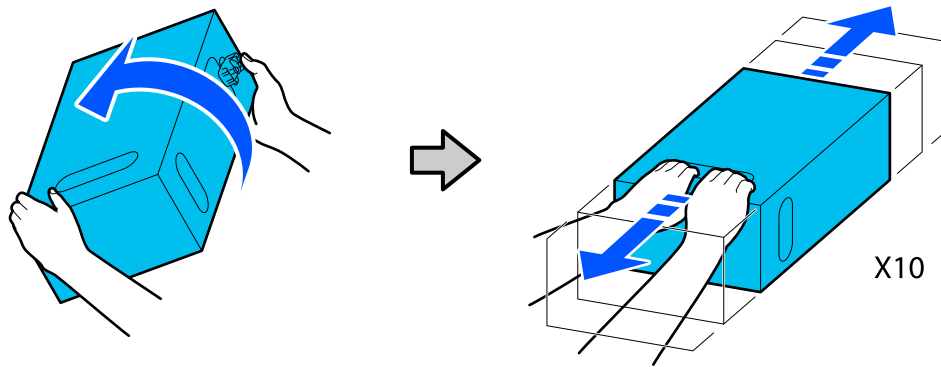
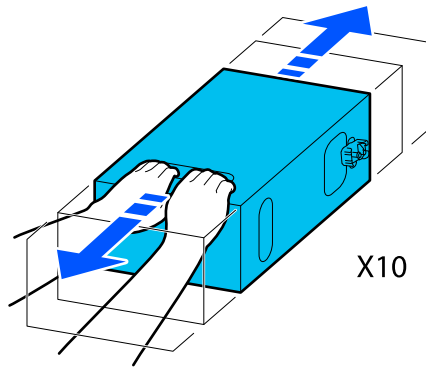
Cut along the dotted lines at the four parts shown in the illustration of the ink cartridge to create handles.



Maintenance

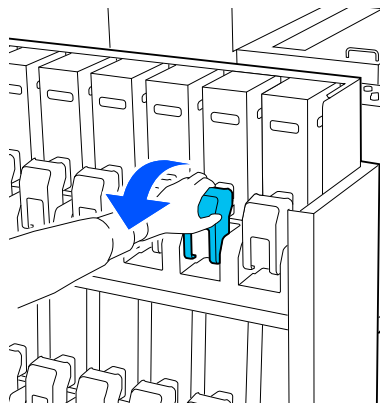
- 6 Place the ink cartridge on a flat surface so that the ink supply port is found on the side, and then move it back and forth along the length of its long side 10 times in 10 cm (3.93 inches) movements to the front and back.

Move it back and forth at a speed of one second per complete movement.



Replacement

- 1 Make sure the printer is on, and then lower the ink cartridge cover of the used ink cartridge toward you.

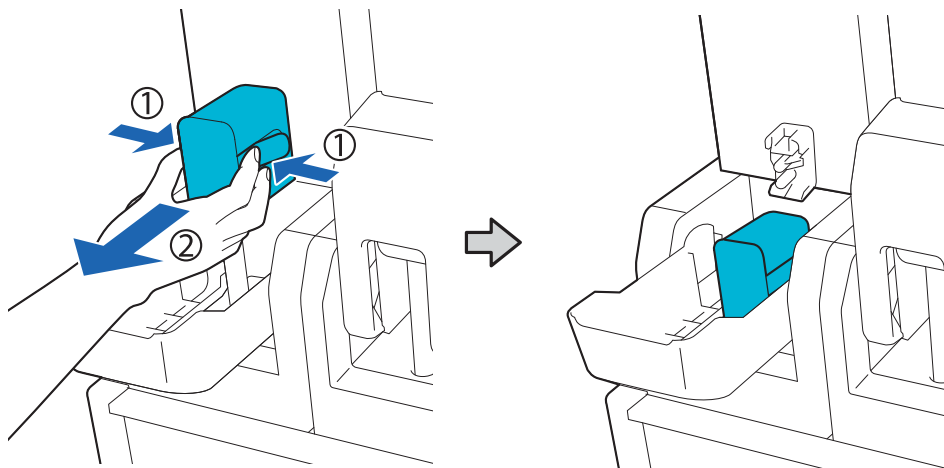


Maintenance

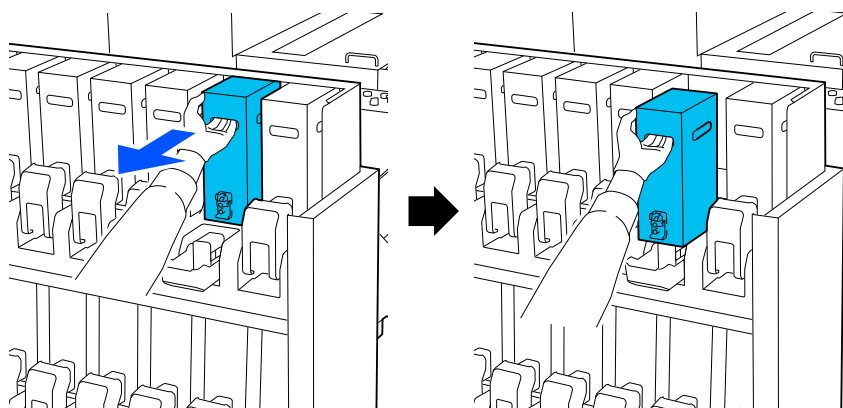
- 2** While pressing the levers on both sides of the connector, pull the connector toward you to remove it, and place the connector on the rear surface of the ink cartridge cover.

**Important:**

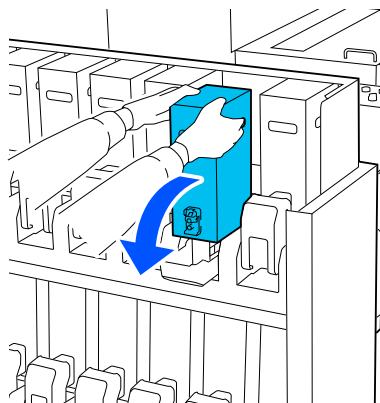
Do not leave the connector removed from the ink cartridge for more than 30 minutes. Otherwise, the ink will dry out and the printer may not function as expected.



- 3** Hold the handle on the front of the ink cartridge and pull the ink cartridge toward you.

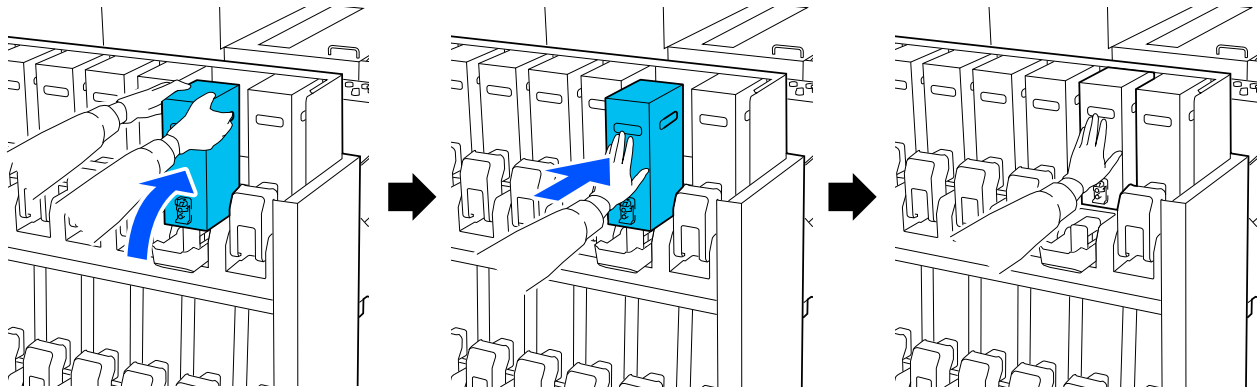


- 4** Hold the handles on the sides of the ink cartridge and remove the ink cartridge from the ink supply unit.

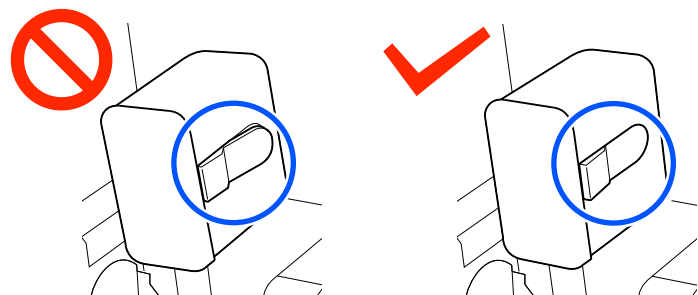
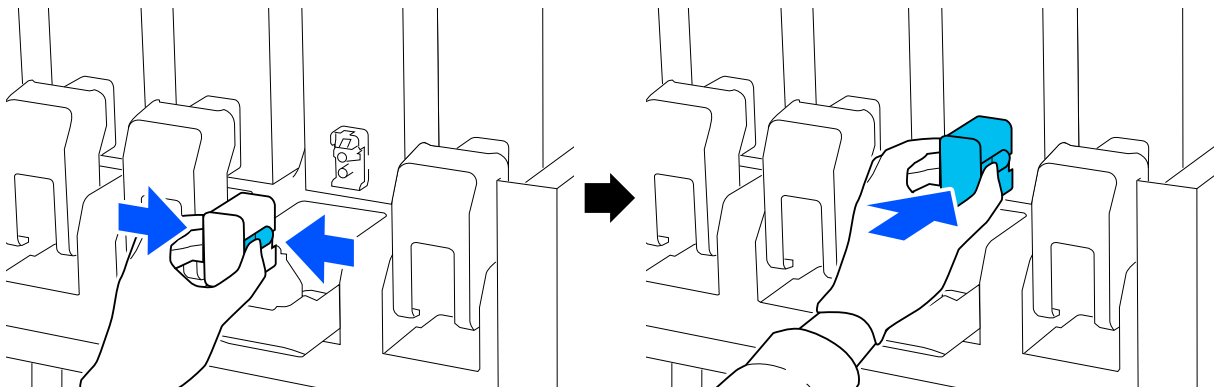


Maintenance

- 5** Hold the handles on the sides of the ink cartridge, place the stirred ink cartridge in the ink supply unit, and push it all the way in.



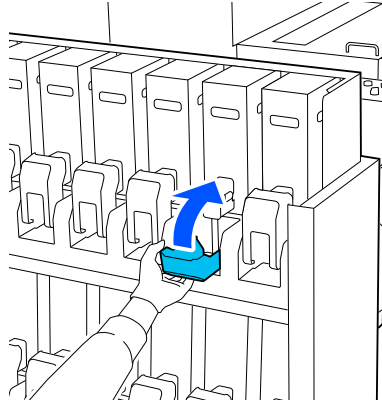
- 6** While squeezing the blue tabs on both sides of the connector, press the connector into the ink supply port until it clicks into place.



Maintenance

7

Close the ink cartridge cover.



Repeat the opening, shaking, and replacement procedures to replace other ink cartridges.

Replacing the Waste Ink Bottle

The printer uses the waste ink counter to track waste ink and displays a message when the counter reaches the warning level. If you replace the waste ink bottle when a message notifies you that it is time to do so, the counter is automatically reset. To replace the bottle before this message is displayed, perform **Replace Waste Ink Bottle** from the set up menu.

❑ When a message is displayed indicating the time to replace the waste ink bottle is approaching

Prepare a new waste ink bottle as soon as possible. When you want to replace the waste ink bottle at this stage, such as due to night operations, select **Replace Waste Ink Bottle** from the setup menu, and then replace the bottle. If you replace it without selecting **Replace Waste Ink Bottle**, the waste ink counter will not operate correctly.

❑ When a message is displayed indicating it is time to replace the waste ink bottle

Replace the waste ink bottle with a new bottle immediately.

Required Items	New waste ink bottle, protective gloves, and protective clothing
----------------	--

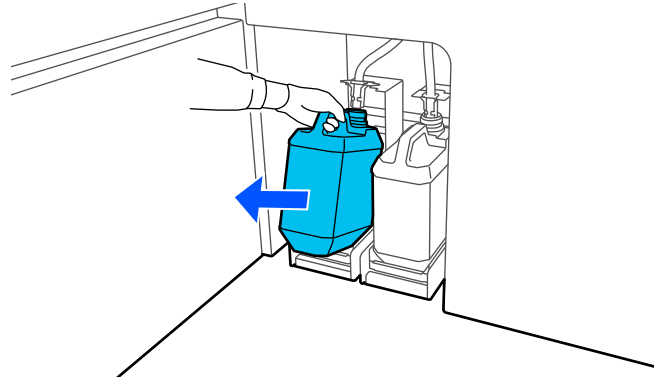


Important:

Never remove the waste ink bottle while printing or while the heads are being cleaned, unless there are on-screen instructions. Failure to observe this precaution could cause ink to leak.

Maintenance

- 1 Remove the waste ink bottle from the holder.

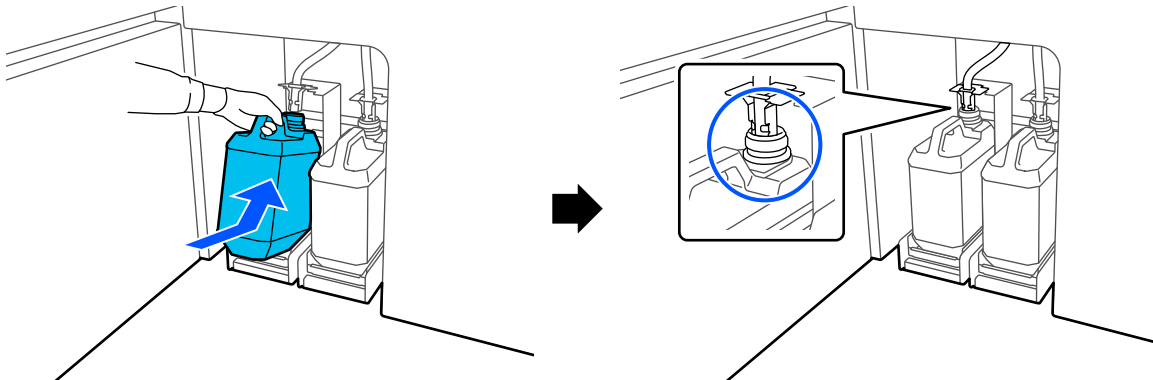


Securely close the cap on the waste ink bottle after use.

- 2 Insert the waste ink tube into the mouth of the new waste ink bottle and place it in the holder.

Make sure that the waste ink tube is inserted into the mouth of the bottle. Ink will spill onto the surrounding area if the waste ink tube is not inserted in the bottle.

You will need the lid for the new waste ink bottle when disposing of waste ink. Keep the lid in a safe place; do not throw it out.



- 3 Touch the **Complete** button on the control panel.
- 4 Confirm the message on the control panel and touch **OK**.

Replacing the Wiper Roll

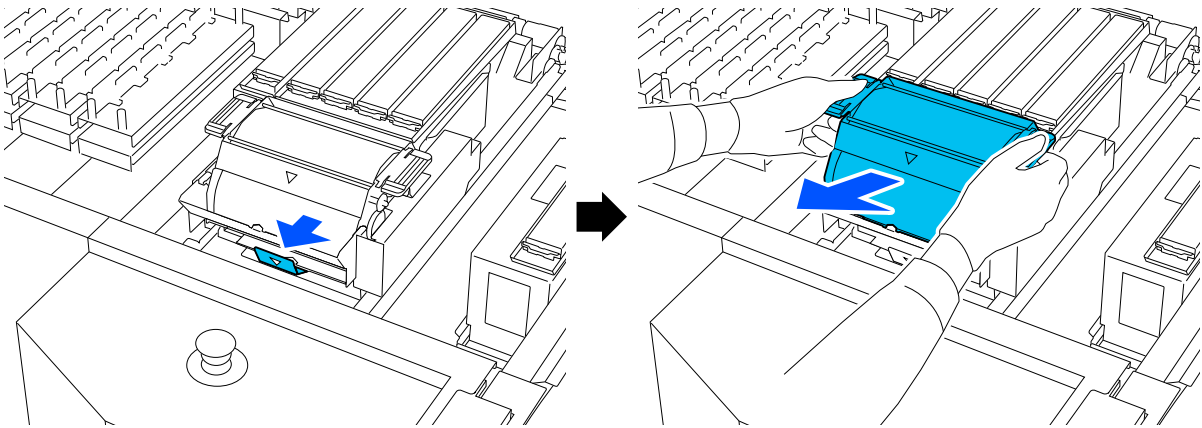
- When a message is displayed indicating the time to replace the wiper roll is approaching

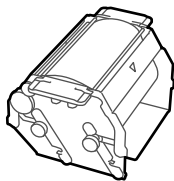
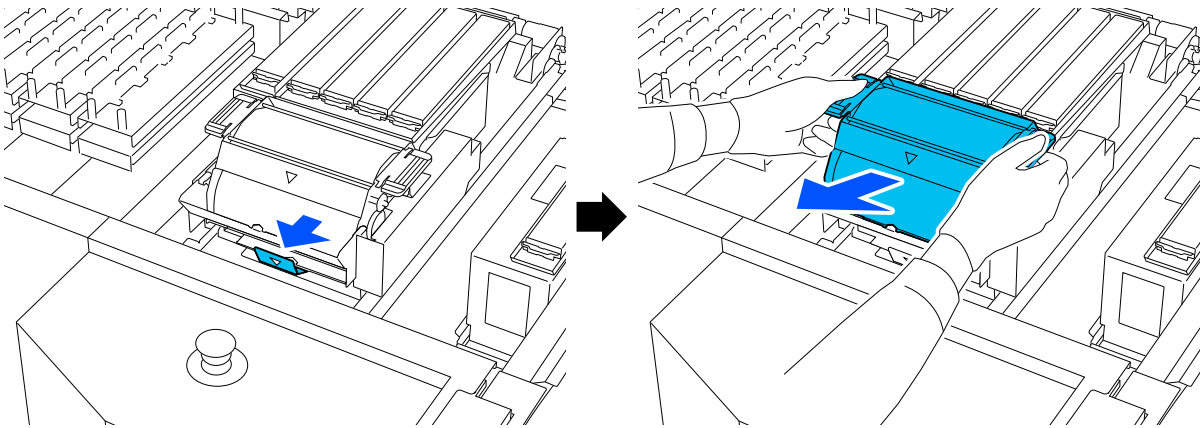
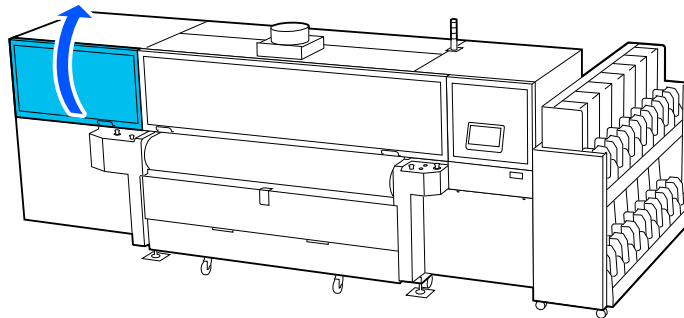
Prepare a new wiper roll as soon as possible. When you want to perform replacement at this stage, such as due to night operations, select **Maintenance - Replace Maintenance Parts - Replace Wiper Roll** from the Maintenance screen on the control panel, and then replace the part. If you replace it without selecting **Replace Wiper Roll**, the wiper roll counter will not operate correctly.

Maintenance

❑ When a message is displayed indicating it is time to replace the wiper roll

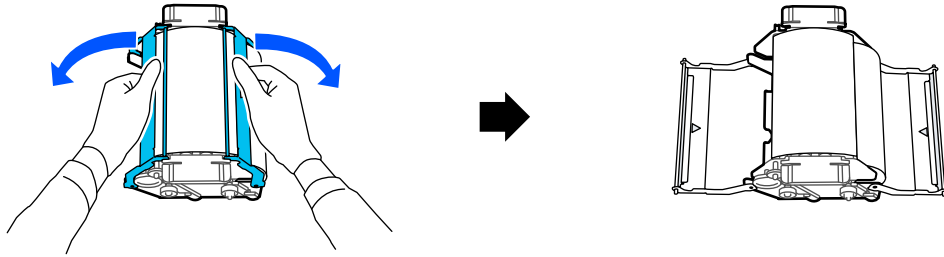
Replace the wiper roll with a new one immediately. Printing cannot be performed if the parts are not replaced. Make sure you use a replacement wiper roll for this printer.

Required Items	New wiper rolls, protective gloves, eye protection, protective clothing
<p>1 Check the on-screen message, and then touch Start.</p> <p>The print head moves to the right when viewed from the front of the machine.</p> <p>2 Open the maintenance cover (left).</p>  <p>3 Pull the lock lever and remove the wiper unit.</p>  <p>4 Place the wiper unit on a flat place oriented as shown in the illustration.</p> 	

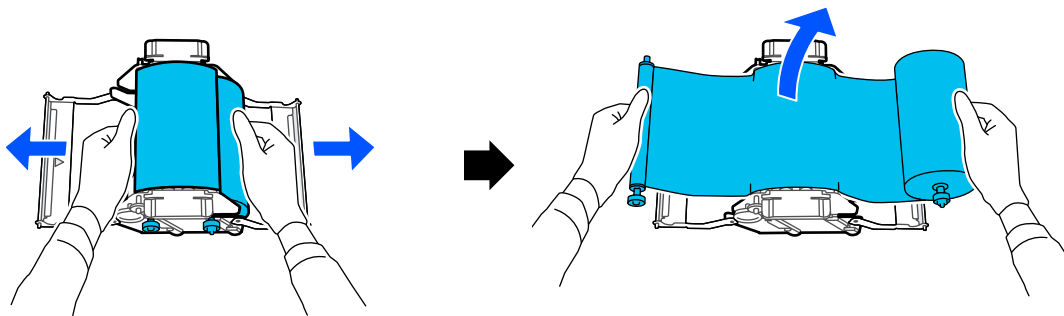


Maintenance

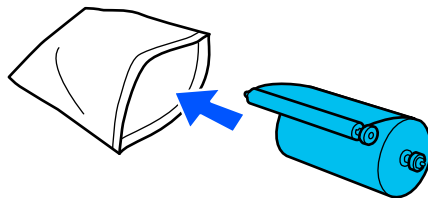
- 5 Open the left and right covers outwards.



- 6 Hold the spindle and roll and pull them out, and remove the wiper roll.



- 7 Place the used wiper roll in the bag of the new wiper roll.

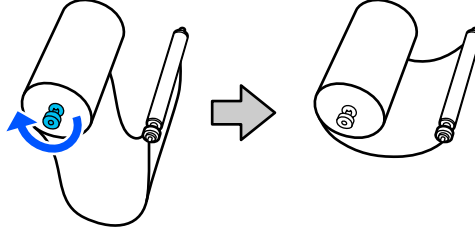


Maintenance

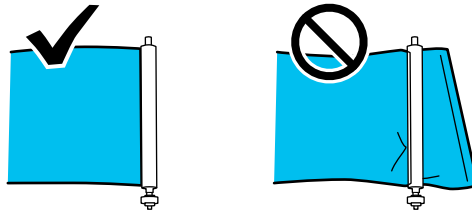
8 Install a new wiper roll.

! Important:

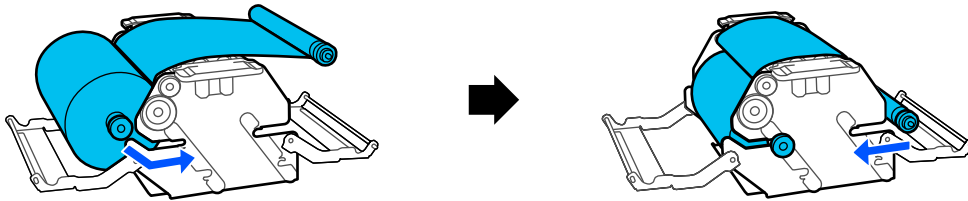
- ❑ Install the wiper roll so it does not sag. If it sags excessively, eliminate the sag.



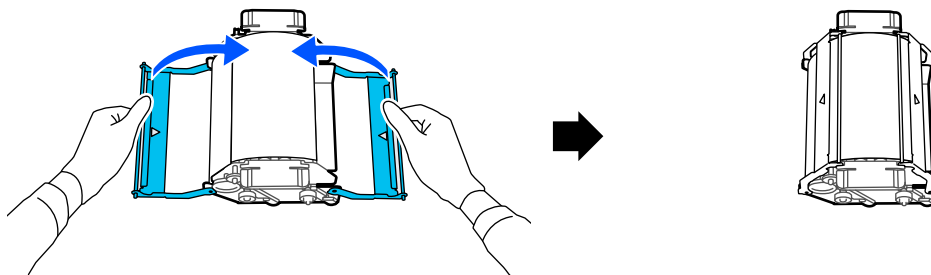
- ❑ Make sure that the fabric edge of the new wiper roll does not extend beyond the spindle. If the fabric goes beyond the spindle, the machine may not operate properly.



Insert the spindle into the groove on the wiper unit, and press inward until you hear a click.

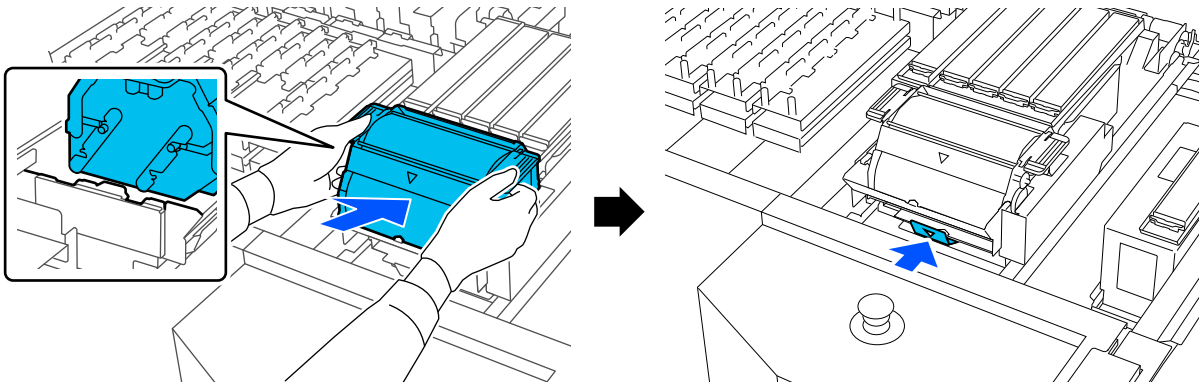


9 Close the left and right covers.

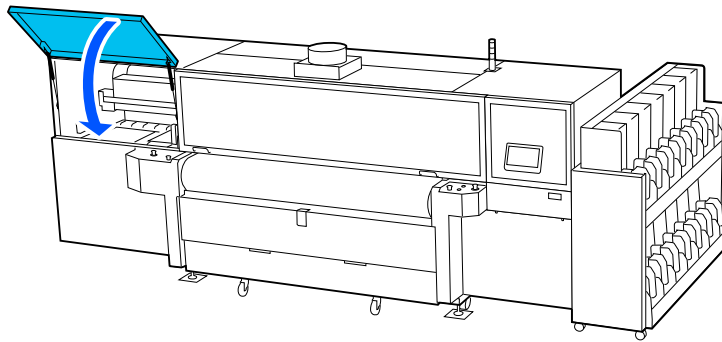


Maintenance

- 10** Install the wiper unit at an angle from above the printer, and then press the lock lever.



- 11** Close the maintenance cover (left).



- 12** Check the on-screen message, and then touch the **Yes** button.

The wiper roll counter is cleared.

- 13** Confirm the message on the control panel and touch **OK**.

Replacing the Flushing Pad

If cleaning does not remove the dirt from the flushing pad, replace it with a new inner pad.

If the flushing pad is deformed, contact your dealer or Epson Support.

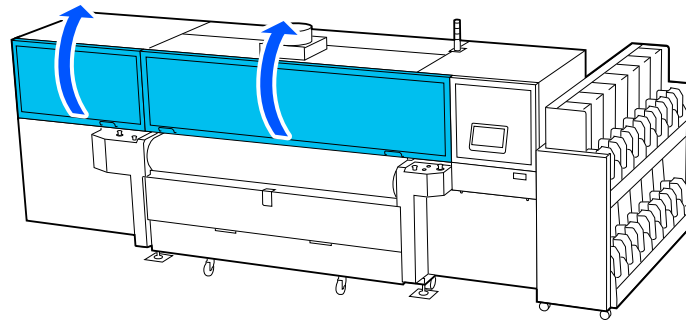
Required Items	New inner pad, trays, protective gloves, eye protection, and protective clothing
----------------	--

- 1** From the Maintenance screen on the control panel, touch **Maintenance - Replace Maintenance Parts - Replace Flushing Pad**, in that order.

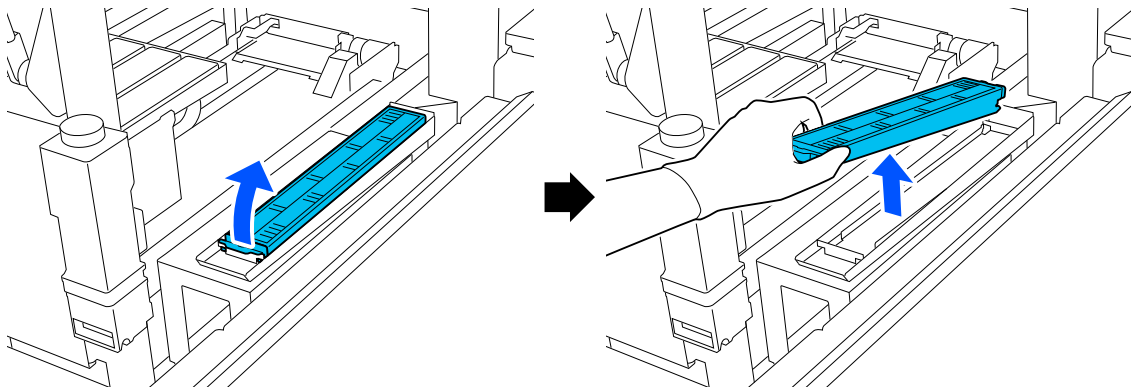
- 2** Check the message on the control panel and touch **Start**.

Maintenance

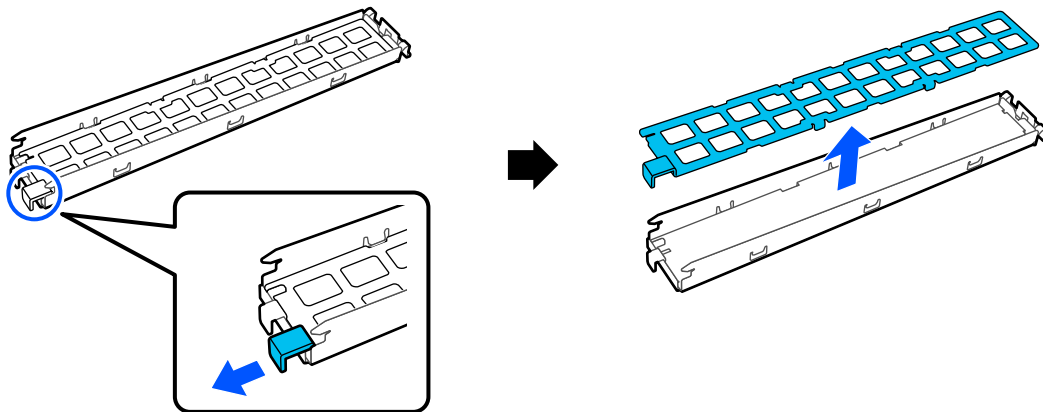
- 3** Open the front cover and the maintenance cover (left).



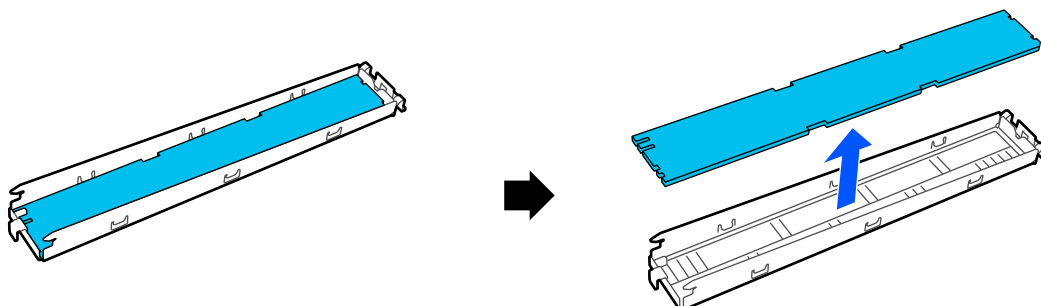
- 4** Lift the tab on the flushing pad and remove the flushing pad.



- 5** Turn the flushing pad over and place it on the tray. Slide the protruding part of the holding plate in the direction shown in the illustration to remove the holding plate.

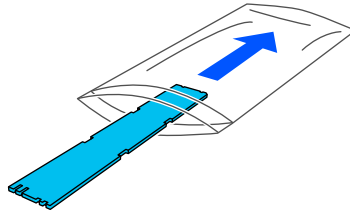


- 6** Remove the inner pad from the frame.

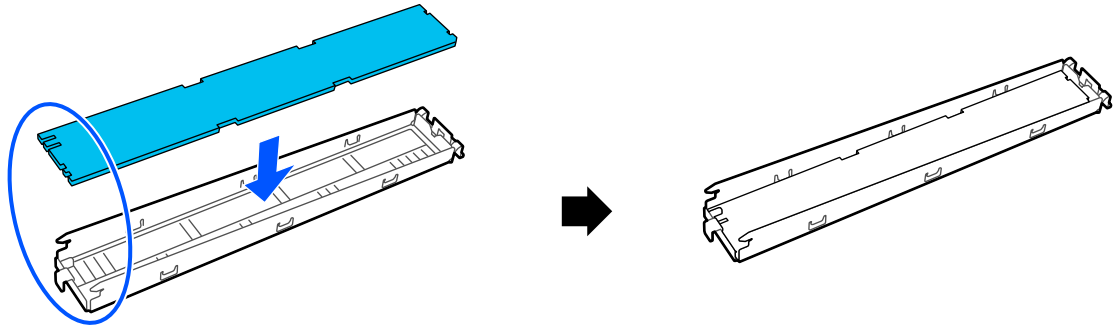


Maintenance

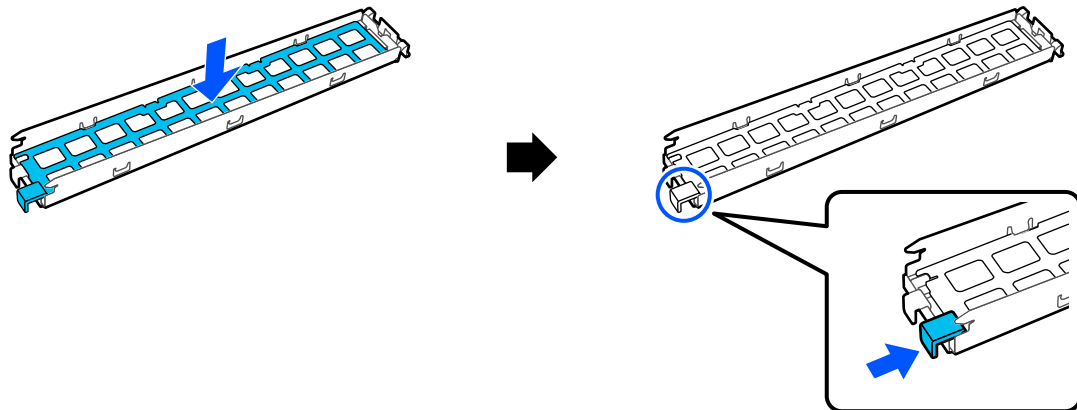
- 7** Put the used inner pad into the packaging.



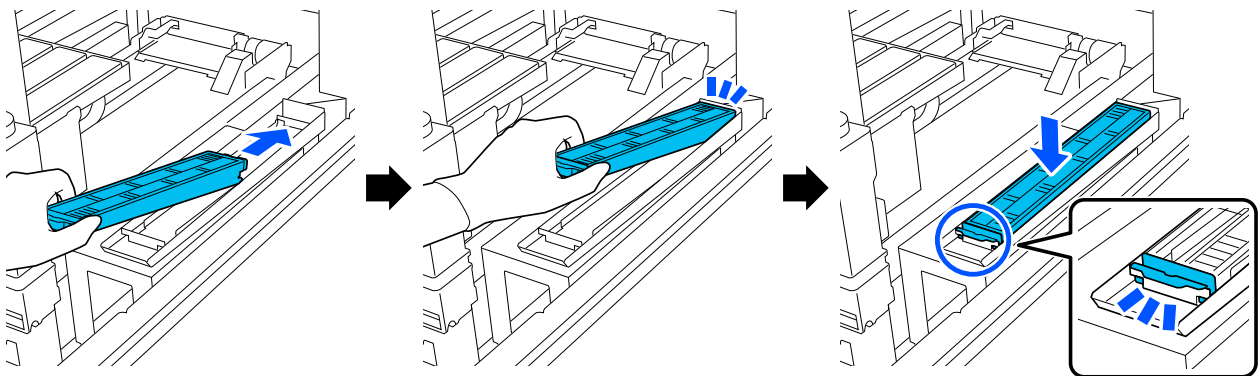
- 8** Check the orientation of the flushing pad, and then place the new inner pad into the frame.



- 9** While holding the protruding part of the holding plate, slide it in the direction of the arrow and secure the holding plate to the frame of the inner pad.

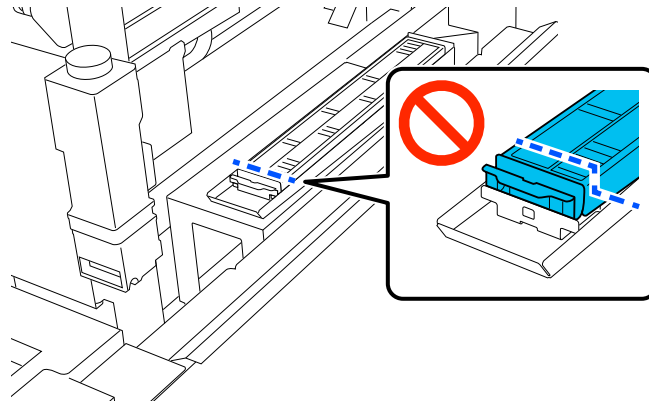


- 10** Insert the flushing pad as shown in the illustration, and place it in its original position while holding the tab.

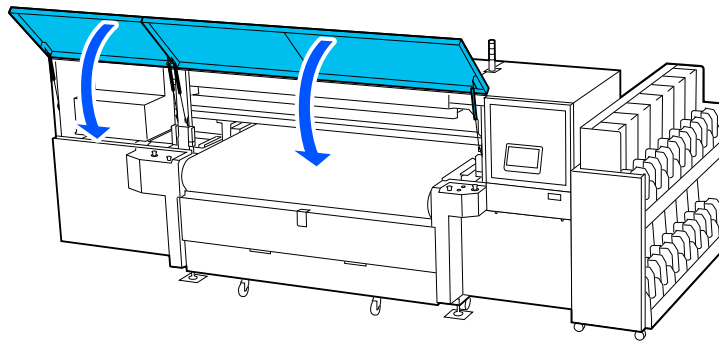


Maintenance

- 11 Check that the flushing pad is not floating up. If the flushing pad is floating up, place it again.



- 12 Close the maintenance cover (left) and the front cover.



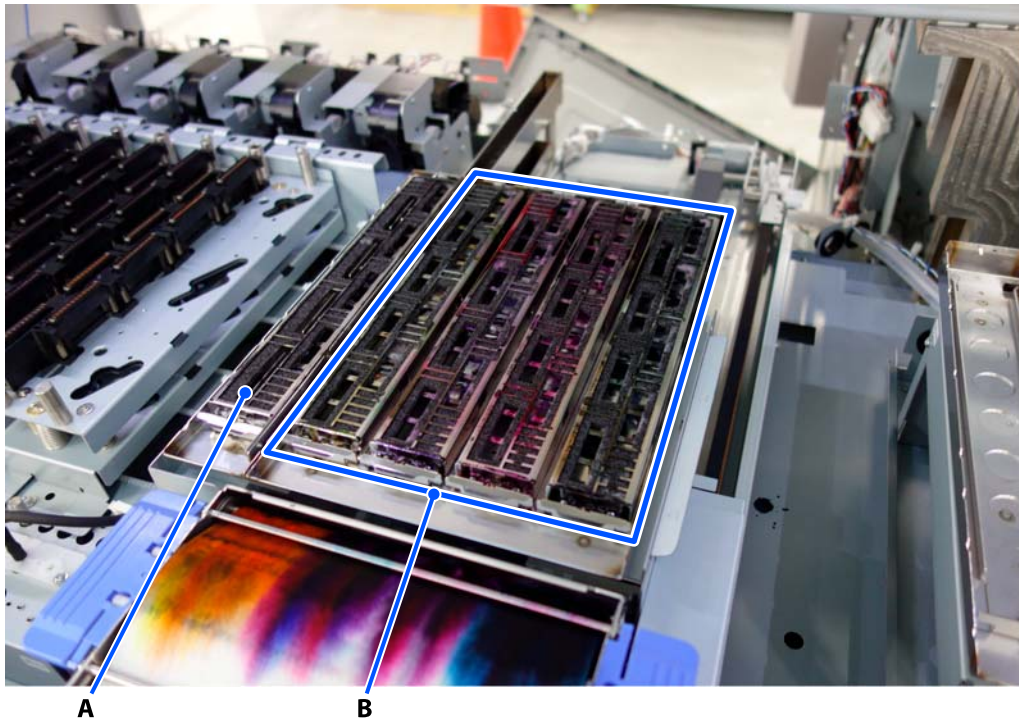
- 13 Touch the **Complete** button on the control panel.

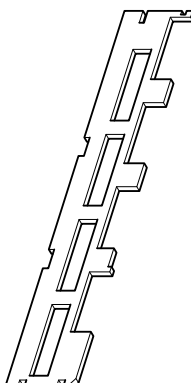
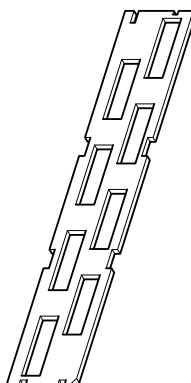
- 14 Confirm the message on the control panel and touch **OK**.

Maintenance

Replacing the Cleaning Pad

If cleaning does not remove the dirt from the cleaning pad, replace it with a new inner porous pad. Depending on the cleaning pad being replaced, the type of inner porous pad you need to prepare differs as follows.



Cleaning pad to be replaced	A	B
Inner porous pad to be prepared	Inner porous pad(1) 	Inner porous pad(2) 

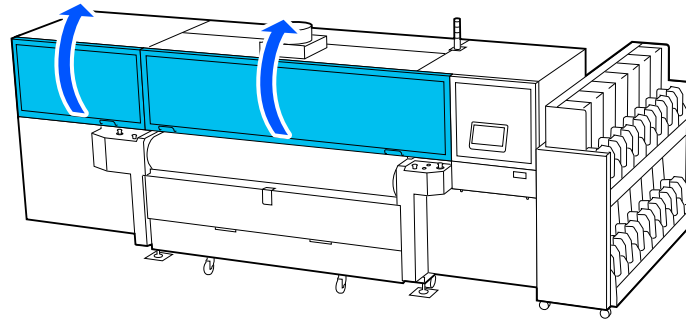
Prepare the inner porous pad for the cleaning pad to be replaced. The replacement method is the same for both types. Follow the steps below to replace it.

If the cleaning pad is deformed, contact your dealer or Epson Support.

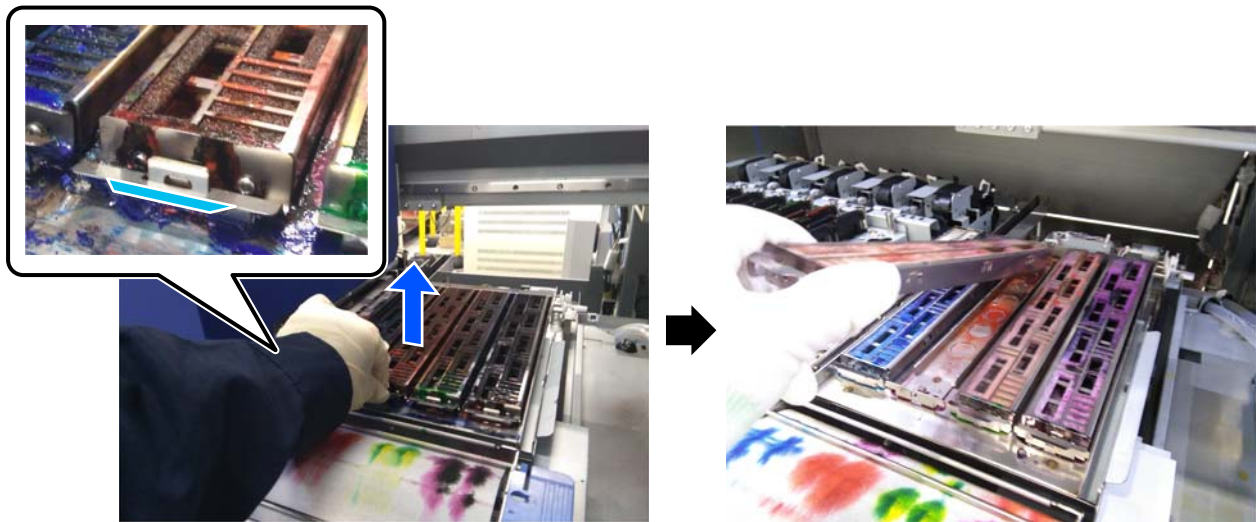
Required Items	New inner porous pad of the type to be replaced, tray, protective gloves, eye protection, and protective clothing
----------------	---

Maintenance

- 1 From the Maintenance screen on the control panel, touch **Maintenance - Replace Maintenance Parts - Replace Cleaning Pad**, in that order.
- 2 Check the message on the control panel and then touch **Start**.
The print head moves to the right when viewed from the front of the machine.
- 3 Open the front cover and the maintenance cover (left).

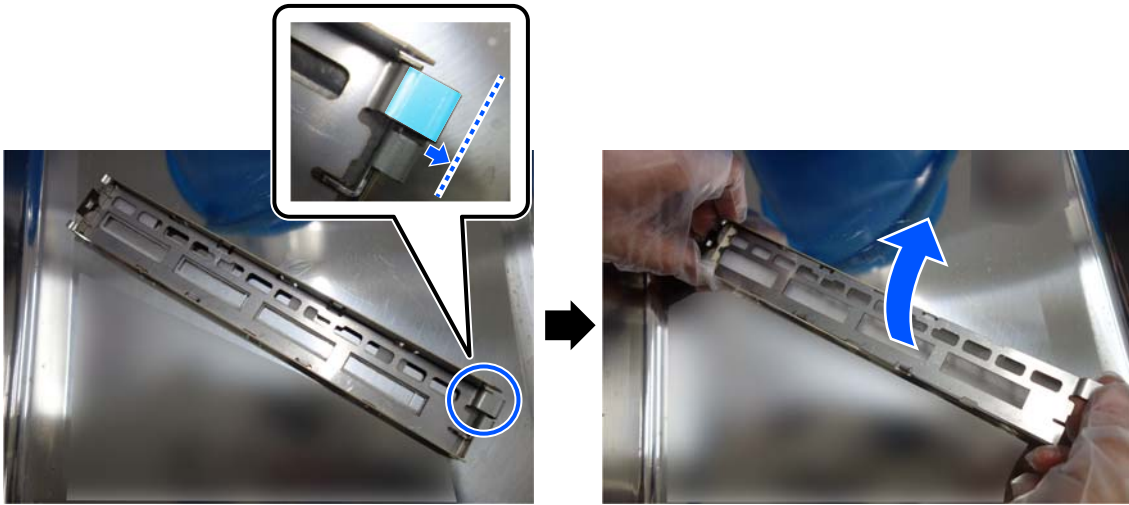


- 4 Lift the tab on the cleaning pad and remove the cleaning pad.

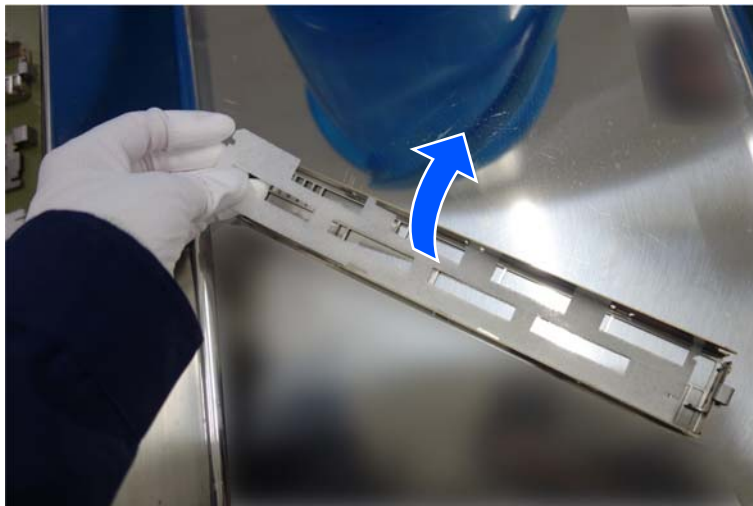


Maintenance

- 5 Turn the cleaning pad over and place it on the tray. Slide the protruding part of the holding plate in the direction shown in the illustration to remove the holding plate.



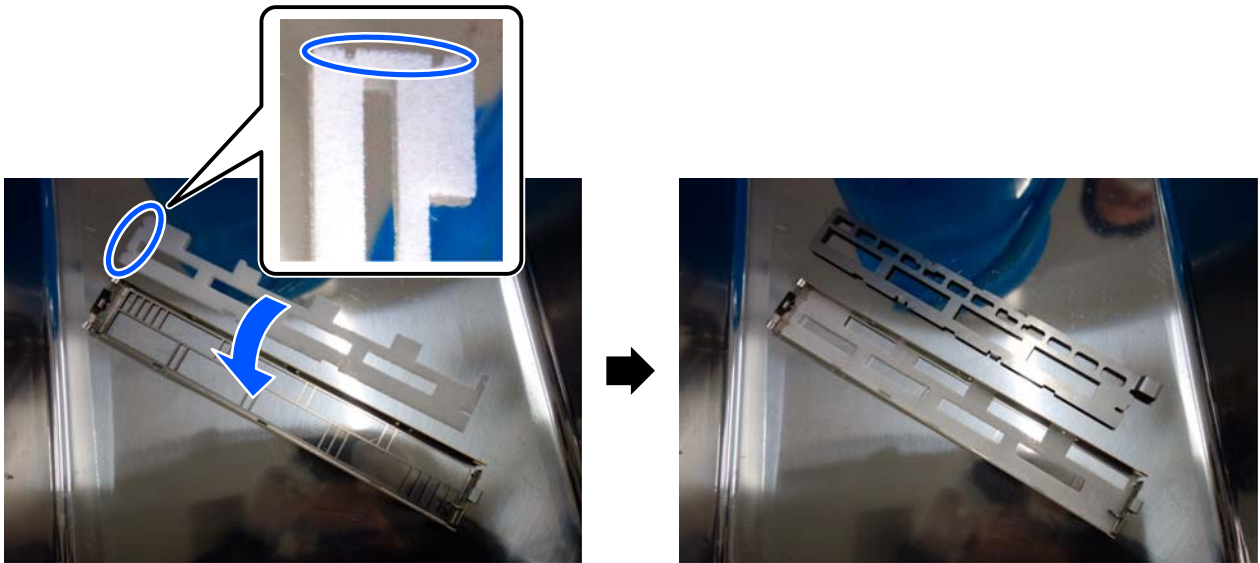
- 6 Remove the inner porous pad from the frame.



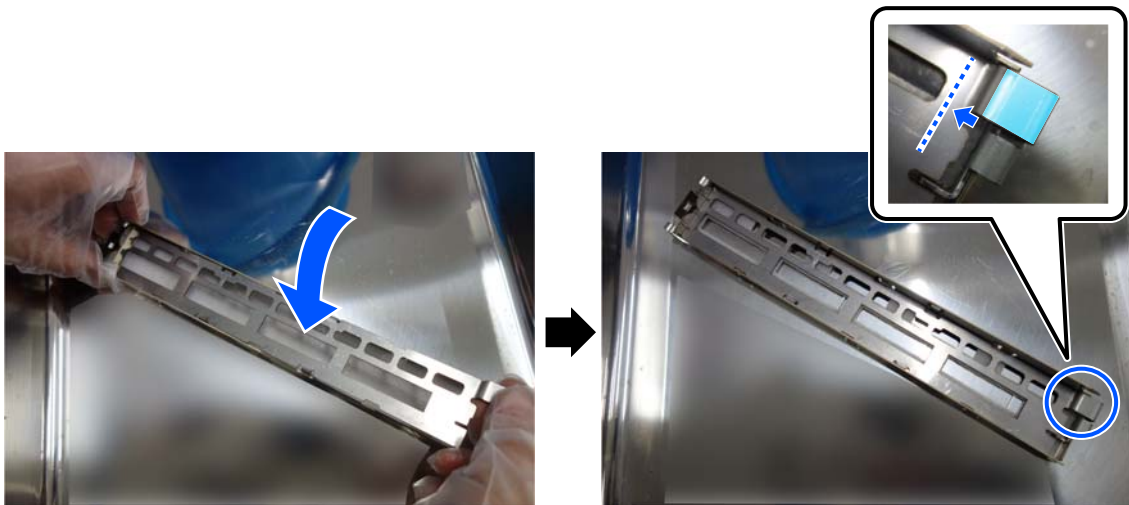
- 7 Put the used inner porous pad into the packaging.

Maintenance

- 8** Check the orientation of the inner porous pad, and then place the new inner porous pad into the cleaning pad frame.

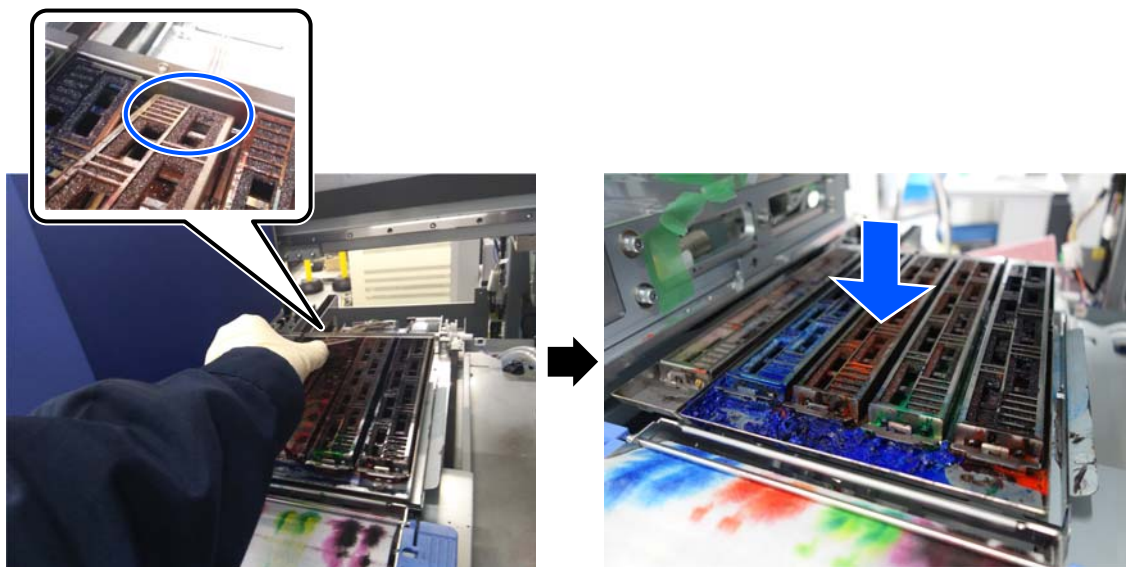


- 9** While holding the protruding part of the holding plate, slide it in the direction of the arrow and secure the holding plate to the frame of the cleaning pad.

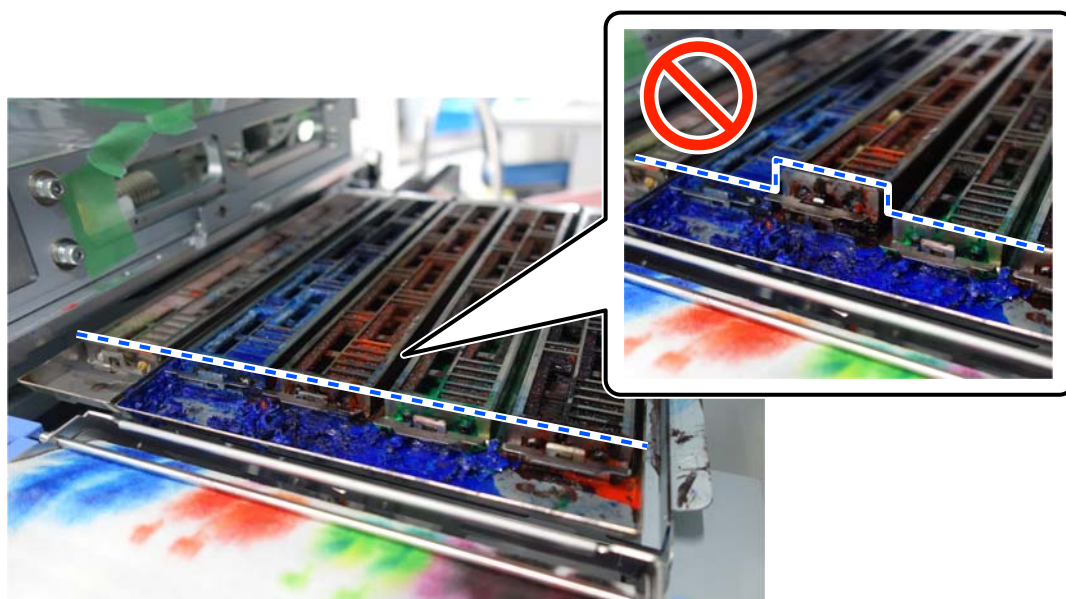


Maintenance

- 10 Insert the cleaning pad as shown in the illustration and place the cleaning pad in its original position while holding the tab.



- 11 Check that the cleaning pad is not floating up. If the cleaning pad is floating up, place it again.



- 12 Close the maintenance cover (left) and the front cover.

- 13 Touch the **Complete** button on the control panel.

The print head moves to the left when viewed from the front of the machine.

- 14 Confirm the message on the control panel and touch **OK**.

Replacing the Washing Scraper

Replace the washing scraper in the following situations.

When the washing scraper is worn out and water droplets remain on the belt after Belt Cleaning

Replace the washing scraper with a new one immediately.

Make sure you use a replacement washing scraper for this printer.

 [“Options and Consumable Products” on page 472](#)

When a message is displayed indicating the time to replace the washing scraper 2 is approaching

Prepare a new washing scraper as soon as possible. When you want to perform replacement at this stage, such as due to night operations, select **Maintenance - Replace Maintenance Parts - Replace Washing Scraper** from the Maintenance screen, and then replace the part. If you replace it without selecting **Replace Washing Scraper**, the washing scraper counter will not operate correctly.

When a message is displayed indicating it is time to replace the washing scraper 2

Replace the washing scraper with a new one immediately. Failure to perform replacement may result in water droplets remaining after belt cleaning.



Caution:

The belt cleaning unit weighs over 110 kg, so make sure you bend your knees sufficiently and work in a natural position.


Pulling or pushing the unit with incorrect posture can lead to injury and back pain.

The washing scraper can be used on both sides.

Turn it over and reattach it if the reverse side has not been used.

 [“Turning over and reattaching” on page 261](#)

If both sides have been used, or if water droplets remain even after turning it over, replace it with a new one.

 [“Replacing with a new one” on page 264](#)

Make sure you use a replacement washing scraper for this printer.

 [“Consumables” on page 472](#)

Turning over and reattaching

Required Items	Protective gloves, protective clothing, hex wrench (width: 2.5 mm (0.1 inches))
----------------	---

1

Check that **Lift Up** is displayed in **Belt Cleaning Tank** on the Home screen on the control panel.

When **Lift Up** is displayed, you can pull out the belt cleaning tank.

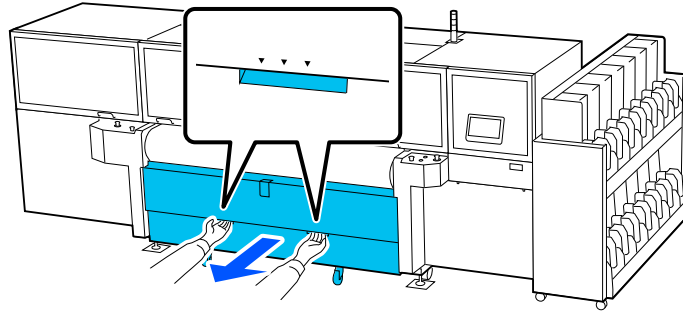
Maintenance

When **Set Down** is displayed, touch the display area and lower the cleaning tank.

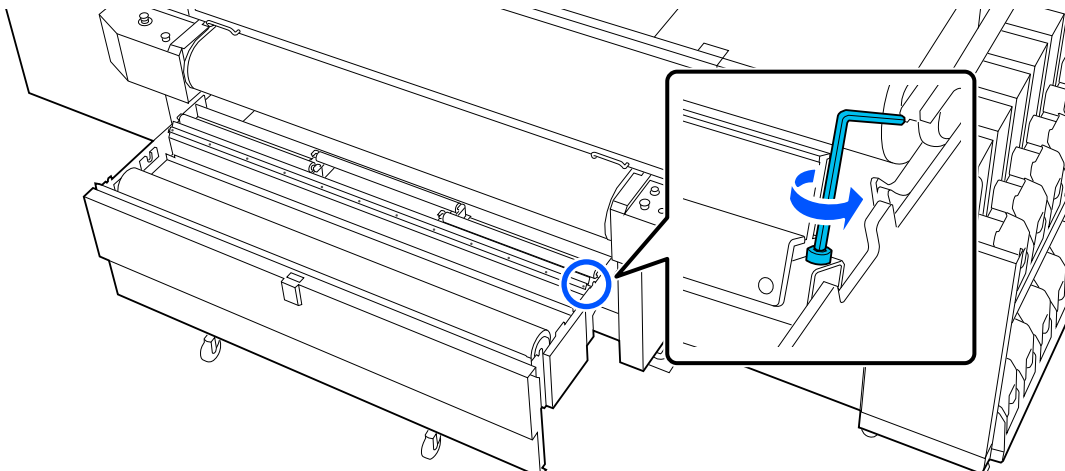
2 From the Maintenance screen on the control panel, touch **Maintenance - Replace Maintenance Parts - Replace Washing Scraper 2**, in that order.

3 Check the on-screen message, and then touch **Use the other side - Start**, in that order.

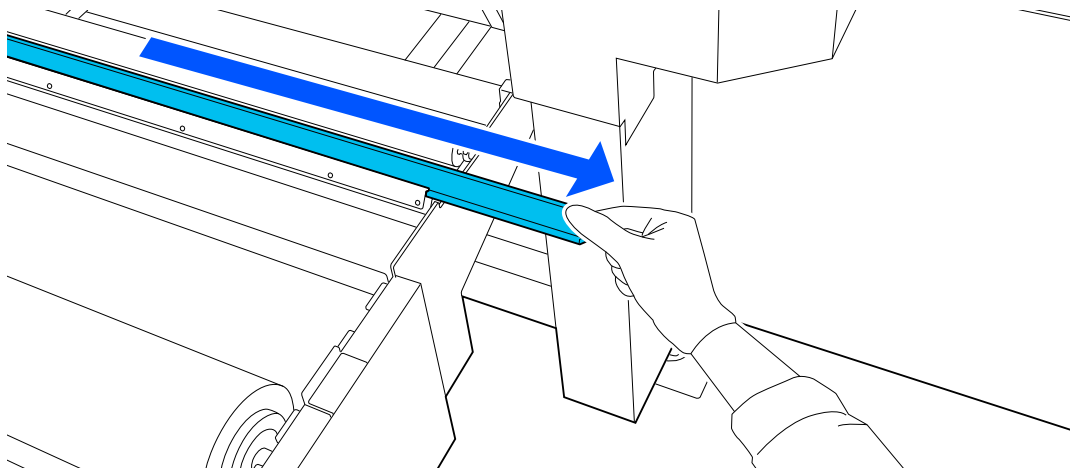
4 Hold the handles on the front of the belt cleaning unit to pull it out.



5 Loosen and remove the slide prevention screw on the right side of the scraper with a hex wrench.

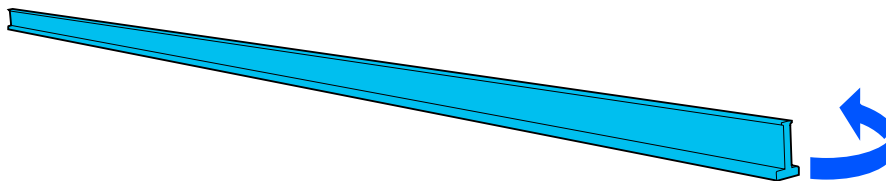


6 Pull out the scraper from the right side of the machine.

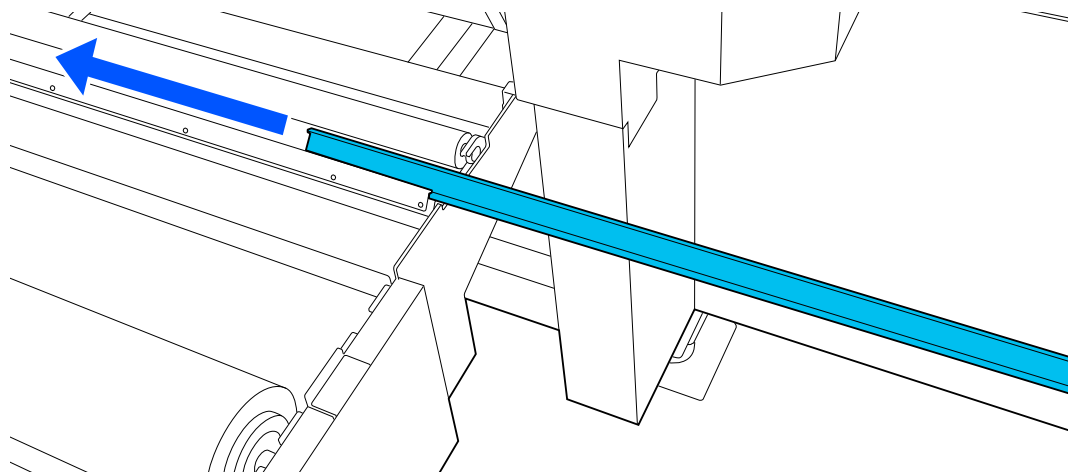


Maintenance

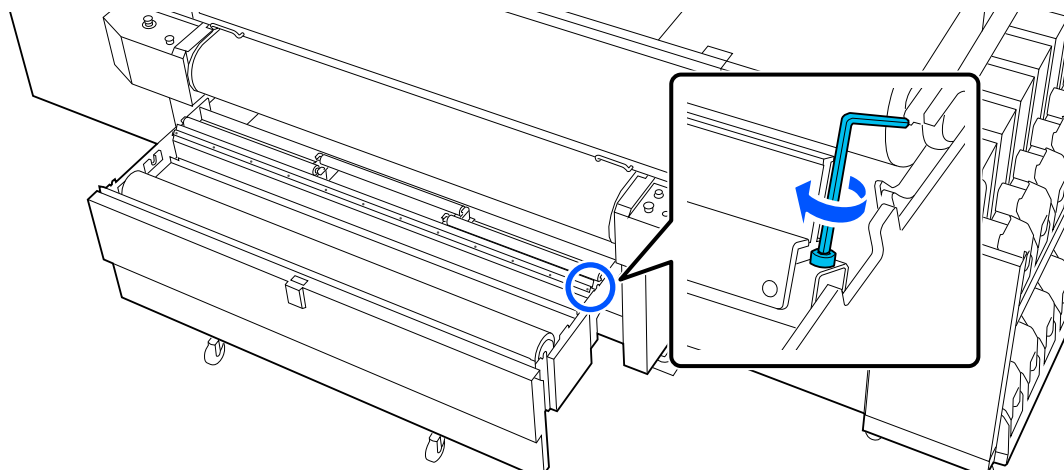
- 7 Turn over the removed washing scraper.



- 8 Insert the scraper from the right side of the belt cleaning tank.



- 9 Tighten the slide prevention screw on the right side of the scraper with a hex wrench.



- 10 Push the belt cleaning unit back to its original position.
- 11 Confirm the message on the control panel and touch the **Complete** button.
The Washing Scraper counter will be cleared.
- 12 Confirm the message on the control panel and touch **OK**.

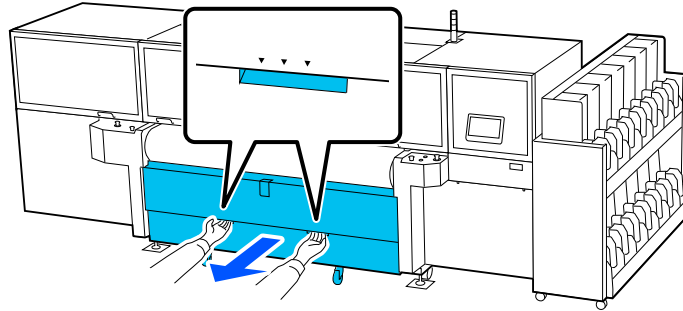
Maintenance

Replacing with a new one

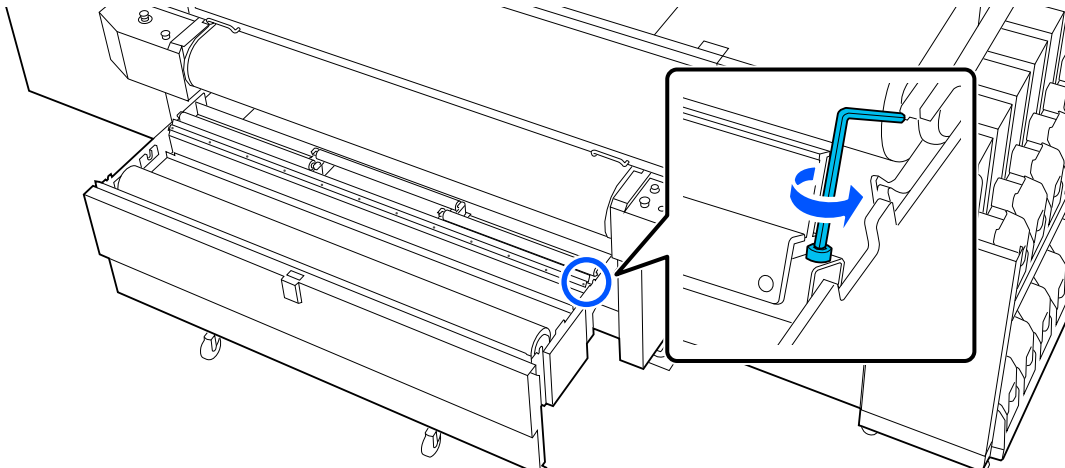
Required Items

Protective gloves, protective clothing, hex wrench (width: 2.5 mm (0.1 inches))

- 1 Check that **Lift Up** is displayed in **Belt Cleaning Tank** on the Home screen on the control panel.
When **Lift Up** is displayed, you can pull out the belt cleaning tank.
When **Set Down** is displayed, touch the display area and lower the cleaning tank.
- 2 From the Maintenance screen on the control panel, touch **Maintenance - Replace Maintenance Parts - Replace Washing Scraper 2**, in that order.
- 3 Check the on-screen message, and then touch **Replace it with a new one - Start**, in that order.
- 4 Hold the handles on the front of the belt cleaning unit to pull it out.

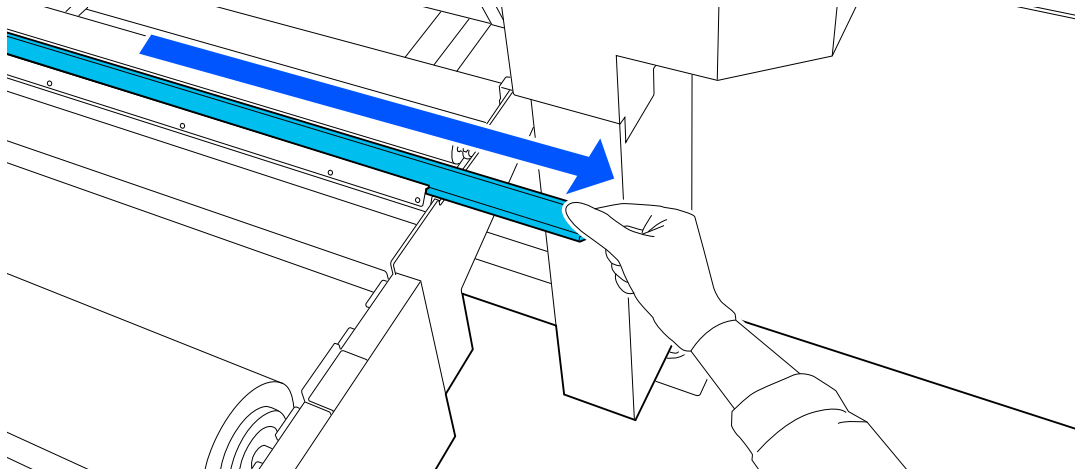


- 5 Loosen and remove the slide prevention screw on the right side of the scraper with a hex wrench.

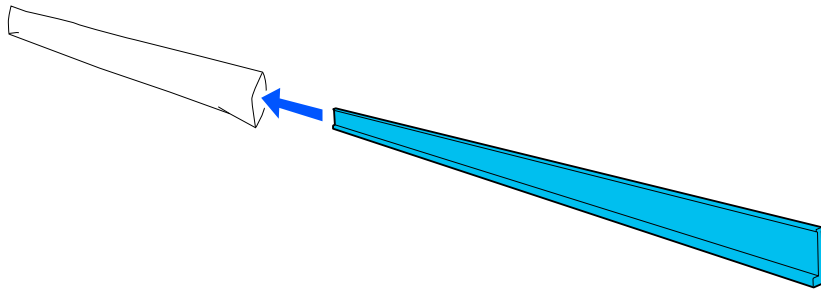


Maintenance

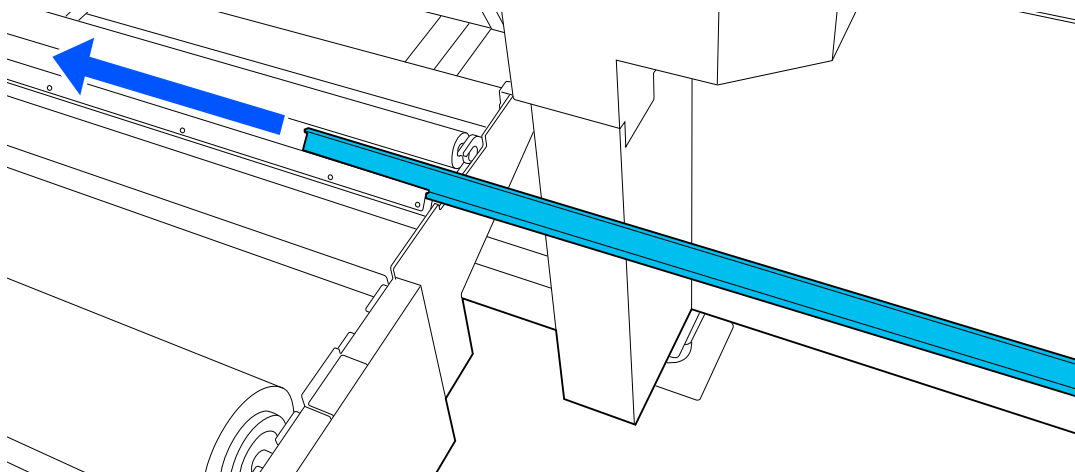
- 6** Pull out the scraper from the right side of the machine.



- 7** Place the used scraper in the bag of the new scraper.

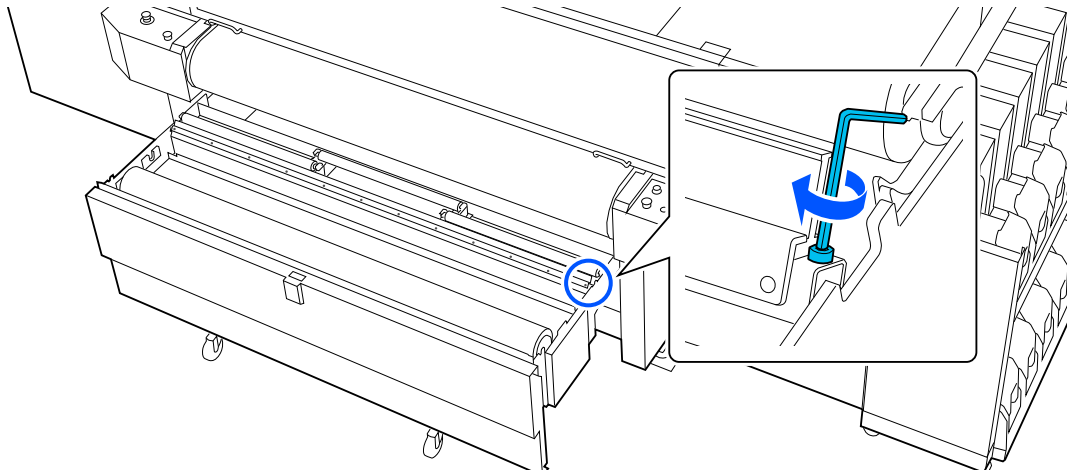


- 8** Insert the new scraper from the right side of the machine.



Maintenance

- 9** Tighten the slide prevention screw on the right side of the scraper with a hex wrench.



- 10** Push the belt cleaning unit back to its original position.
- 11** Confirm the message on the control panel and touch the **Complete** button.
The Washing Scraper counter will be cleared.
- 12** Confirm the message on the control panel and touch **OK**.

Replacing the Sponge Roller

If water droplets remain on the belt even after drying the sponge roller, replace the sponge roller with a new one.

Make sure you use a replacement sponge roller for this printer.

 [“Options and Consumable Products” on page 472](#)



Caution:

The belt cleaning unit weighs over 110 kg, so make sure you bend your knees sufficiently and work in a natural position.

Pulling or pushing the unit with incorrect posture can lead to injury and back pain.

Note:

Before replacing the roller, we recommend that you identify the factors causing water droplets to remain on the belt.

 [“Water droplets remain on the belt after belt cleaning” on page 464](#)

Required Items

New sponge roller, flat-head screwdriver, protective gloves, eye protection, and protective clothing

Maintenance

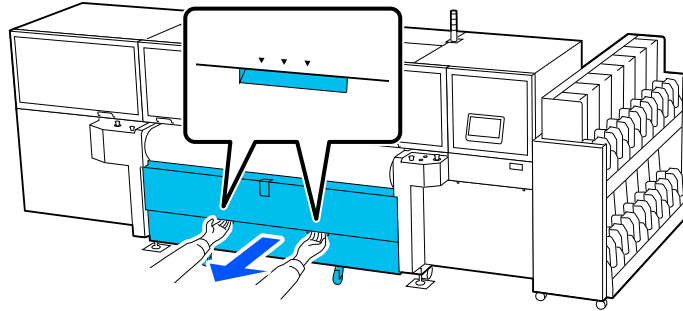
- 1 Check that **Lift Up** is displayed in **Belt Cleaning Tank** on the Home screen on the control panel.

When **Lift Up** is displayed, you can pull out the belt cleaning tank.

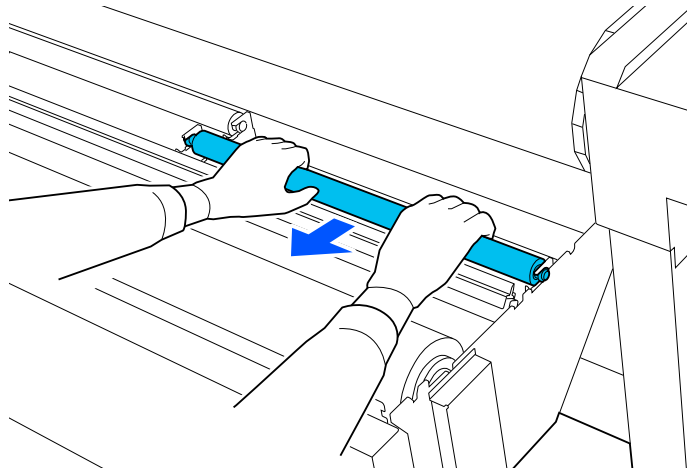
When **Set Down** is displayed, touch the display area and lower the cleaning tank.

- 2 From the Maintenance screen on the control panel, touch **Maintenance - Replace Maintenance Parts - Replace Sponge Roller**, in that order.

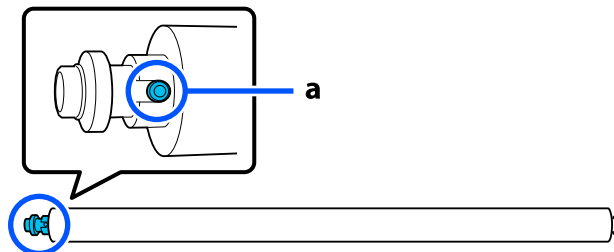
- 3 Hold the handles on the front of the belt cleaning unit to pull it out.



- 4 Pull the sponge roller toward you to remove it.



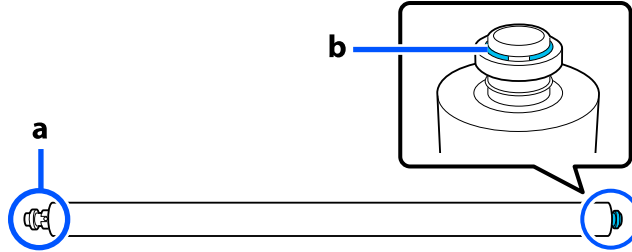
- 5 Check the position of stopper (a) on the sponge roller. Do not remove the retaining ring on the stopper side.



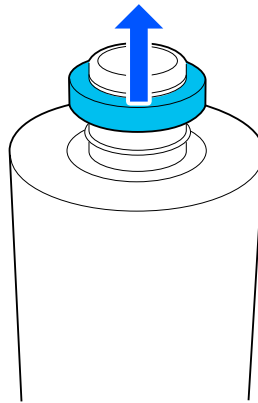
Maintenance

- 6** Remove the retaining ring attached to the opposite side (b) of the spindle from its stopper.

Insert a flat-head screwdriver from the slanted end of the notch in the retaining ring and remove it by pushing up along the circumference of the spindle.

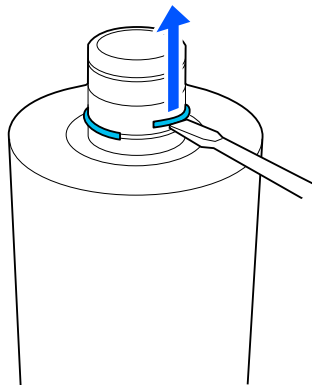


- 7** Remove the bearing.



- 8** Remove the remaining retaining rings.

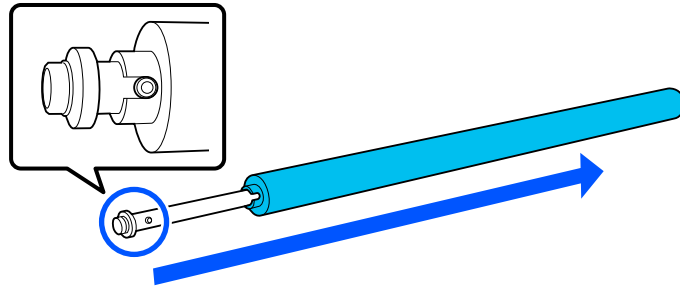
Insert a flat-head screwdriver from the slanted end of the notch in the retaining ring and remove it by pushing up along the circumference of the spindle.



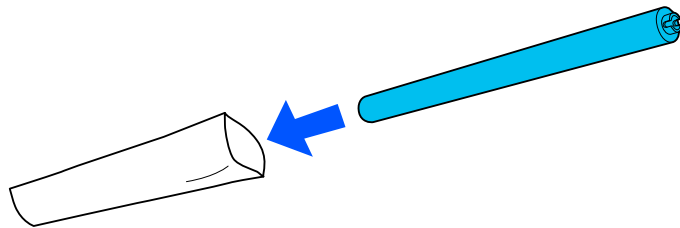
Keep the removed bearing, as it will be used when installing the new sponge roller.

Maintenance

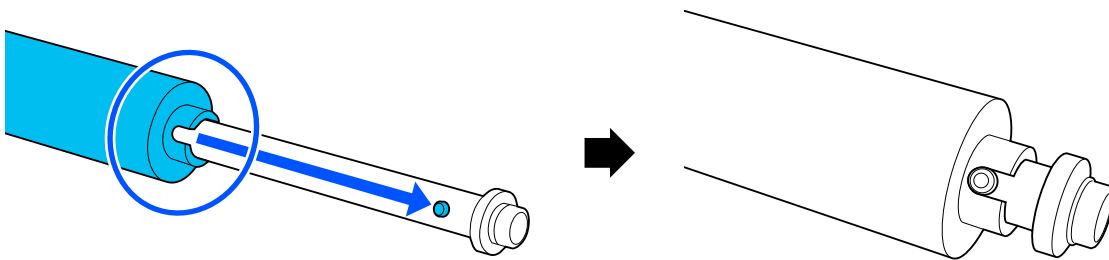
- 9** Remove the sponge roller from the shaft.



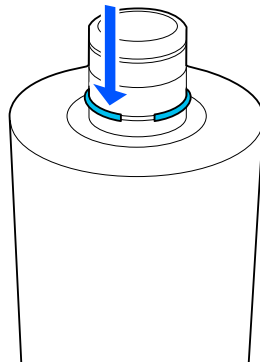
- 10** Place the used sponge roller in the bag of the new sponge roller.



- 11** Thread the new sponge roller through the shaft so that the stopper of the shaft fits into the notch in the sponge roller.



- 12** Attach the retaining ring included with the new sponge roller to the shaft at the position shown in the illustration (innermost groove).

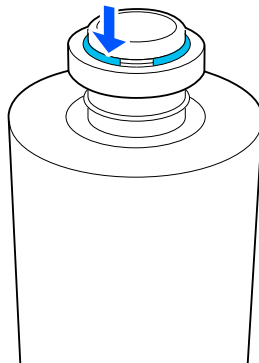


Maintenance

- 13** Install the bearing on the shaft.

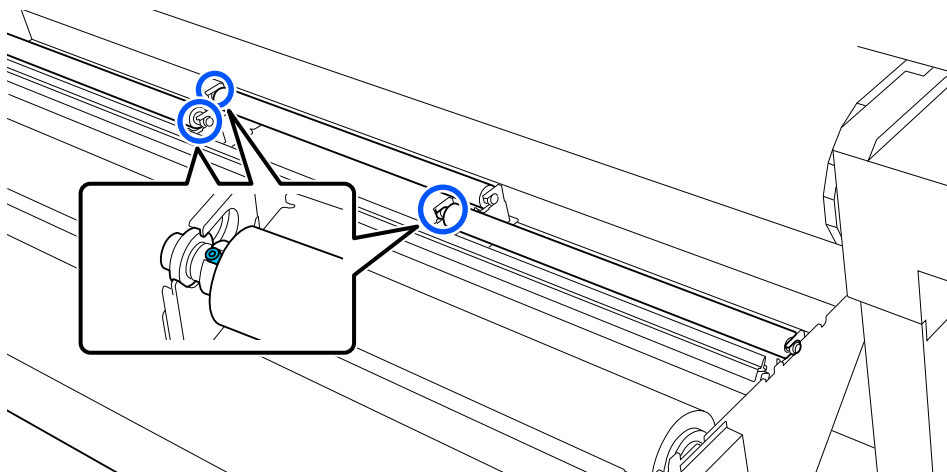


- 14** Overlap and install the remaining retaining rings provided with the new sponge roller such that there is no gap between the bearing and the remaining rings.



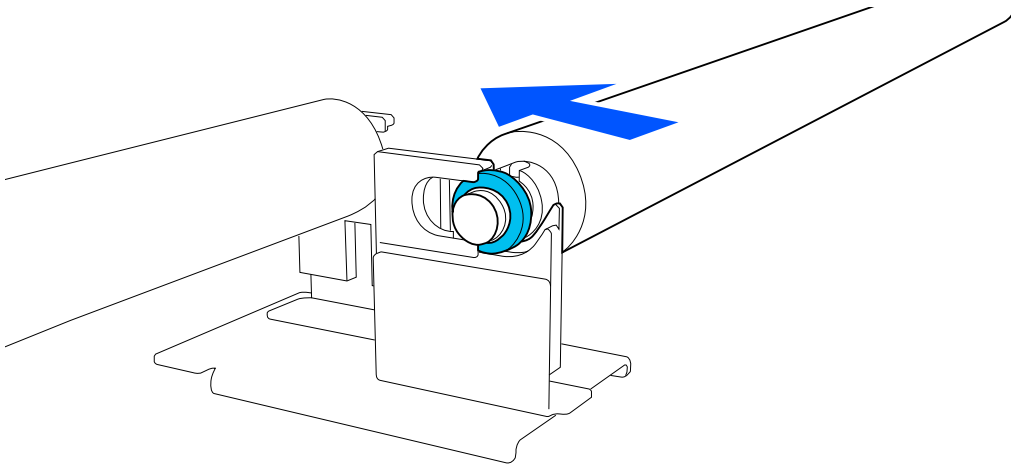
- 15** Check the mounting direction of the sponge roller.

The mounting direction depends on the position of the sponge roller. Install the stopper so that it fits in the position indicated in the illustration.



Maintenance

- 16** Install the sponge roller so that the left and right bearings fit into the grooves in the mounting section, and push the sponge roller all the way in until it clicks into place.



- 17** Push the belt cleaning unit back to its original position.
- 18** Confirm the message on the control panel and touch **Complete**.
The Sponge Roller counter will be cleared.
- 19** Confirm the message on the control panel and touch **OK**.

Replacing the Mist Filter

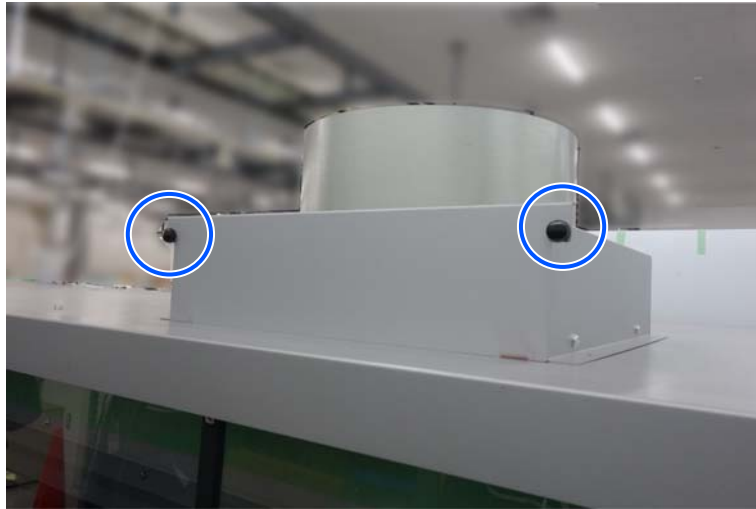
Replace the mist filter with a new one if it is still dirty after cleaning.

Required Items	New mist filter, protective gloves, and protective clothing
----------------	---

- 1** Check that the machine is off.

Maintenance

- 2 Loosen the two screws on the mist filter cover by hand and remove them.



- 3 Slide the cover upward and remove it.



- 4 Pull out the mist filter.



Maintenance

- 5 Place the removed mist filter into the packaging that contained the new mist filter.
- 6 Check the direction of the arrow on the label of the new mist filter cover and install the filter in its intended position.



- 7 Attach the mist filter cover you removed.
- 8 Tighten the two screws on the mist filter cover.

Other Maintenance

Cleaning the Mist Collection Fan

When lint or debris builds up on the mist collection fan, the fan stops and a message is displayed on the control panel screen prompting you to clean the fan.

If the fan stops working, the inside of the printer may get dirty due to the mist, which may stain the fabric or cause clogged nozzles. Follow the steps below to perform cleaning.

Required Items	Wipe cloth, cleaning stick, protective gloves, eye protection, and protective clothing
----------------	--

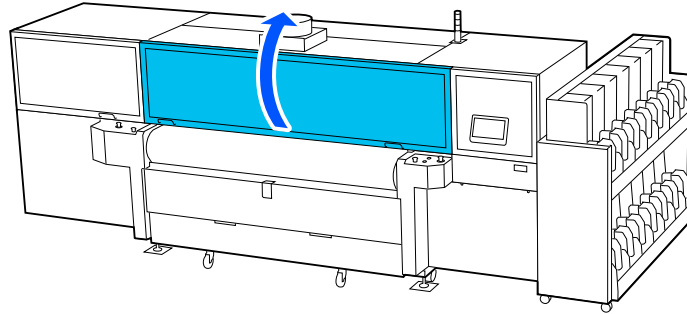
- 1 Remove the fabric loaded in the printer.
 - Roll the fabric to the back of the printer. If there is fabric below the mist collection fan, the fabric may become dirty with mist and lint that falls off during cleaning.
 - [“Removing the Fabric Roll” on page 102](#)
- 2 Turn off the printer.
 - [“Turning Off the Power” on page 110](#)

Maintenance

- 3 Stop operating the exhaust equipment connected to the printer.

The location and method of checking exhaust ducts will vary depending on the equipment that is used. For details, please check with the factory manager.

- 4 Open the front cover.



There are eight mist collection fans located at the top inside the printer.



- 1 Mist collection fans

Maintenance

- 5** Use a wipe cloth to remove any lint or mist stains from the wire protectors of the mist collection fans.
Clean all eight wire protectors.



1 Wire protector

- 6** Shine a headlight or flashlight inside the mist collection fans to check for lint or other debris stuck to the fans.

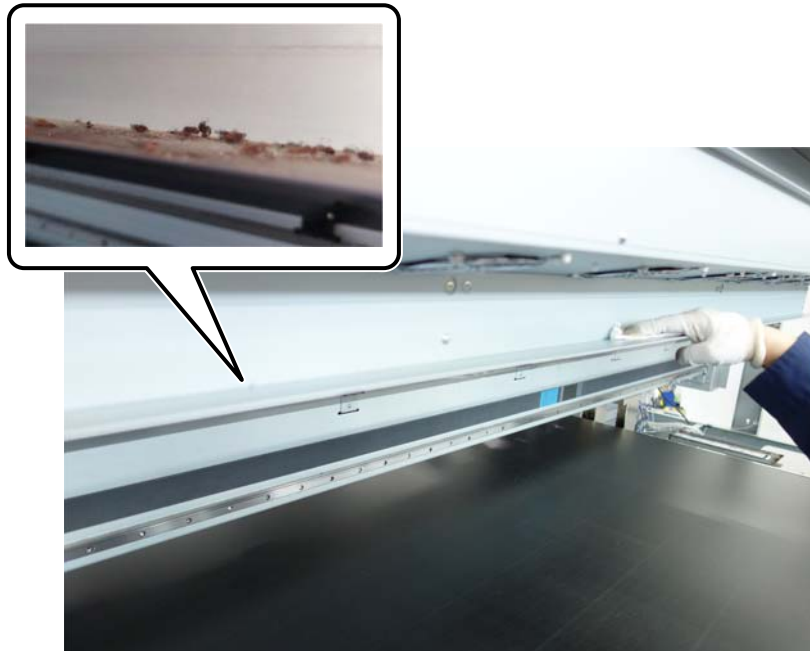
- 7** If lint or other debris is stuck to the fan, use a cleaning stick to remove the lint or mist stains from the fan.

Insert the cleaning stick to the back of the fan and move it around the fan toward the front to scrape out any lint and mist stains.

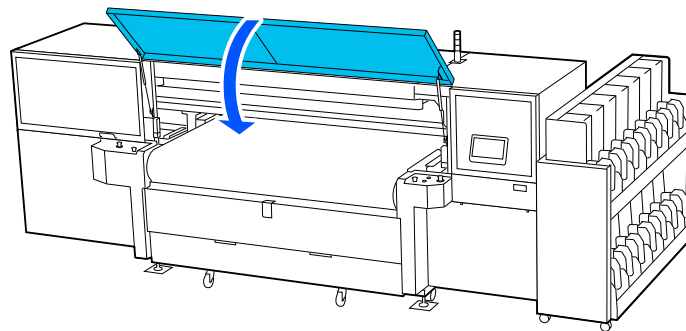


Maintenance

- 8 If there is any lint or debris on the metal plate of the mist collector under the fan, wipe it off with a wipe cloth.



- 9 Close the front cover.



- 10 Resume operating the exhaust equipment connected to the printer.

The location and method of checking exhaust ducts will vary depending on the equipment that is used. For details, please check with the factory manager.

- 11 Turn on the printer.

 [“Turning On the Power” on page 51](#)

Note:

If a message prompting you to clean the fan is displayed on the control panel screen when you resume printing, the mist collection fan may have malfunctioned.

Contact your dealer or Epson Support.

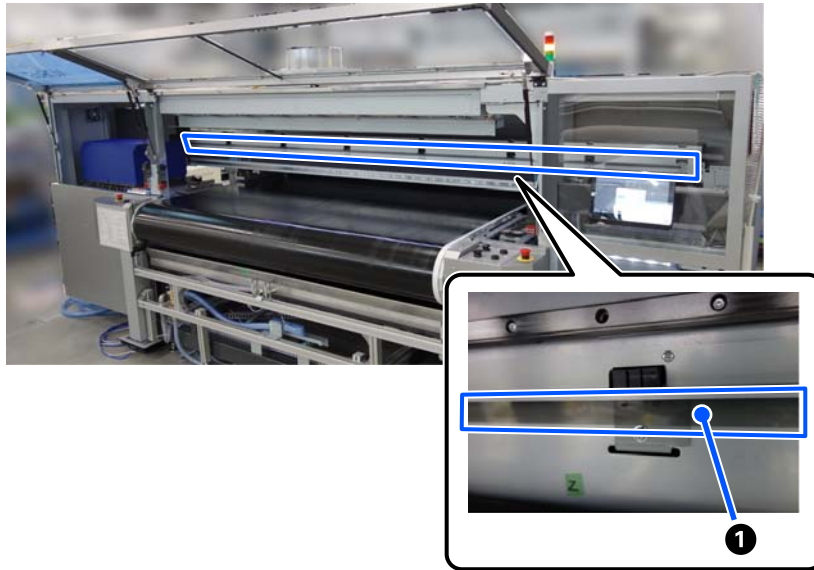
Maintenance

12 If any of the lint you scraped out falls on the belt, perform belt cleaning.

From the Maintenance screen on the control panel, touch **Belt Cleaning - Start**, in that order.

Cleaning the Encoder Scale

The encoder scale is a part used to read the position of the print head. It is installed in the print head operating section inside the printer.



Lint, debris, or dirt on the scale may prevent correct reading of the print head position, which could prevent normal printing operations.

Clean the encoder scale in case of following.

- When an error message appears on the control panel indicating that the print head position cannot be read
- When you notice lint, debris, or dirt on the encoder scale

Required Items	Cleaning cloth, ethanol, mirror, protective gloves, and protective clothing
----------------	---

Note:

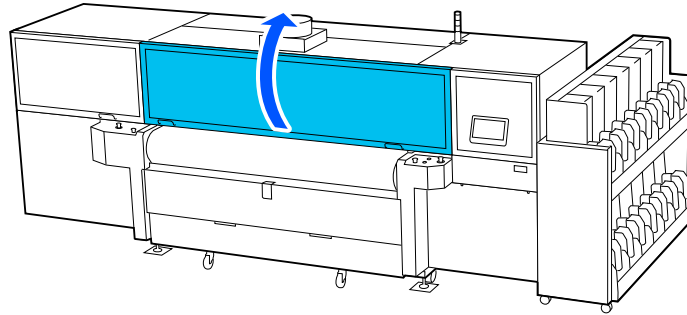
We recommend that the belt be covered with a fabric to protect it and prevent workers from getting dirty when working on the belt.

1 Check that the machine is off.

 [“Turning Off the Power” on page 110](#)

Maintenance

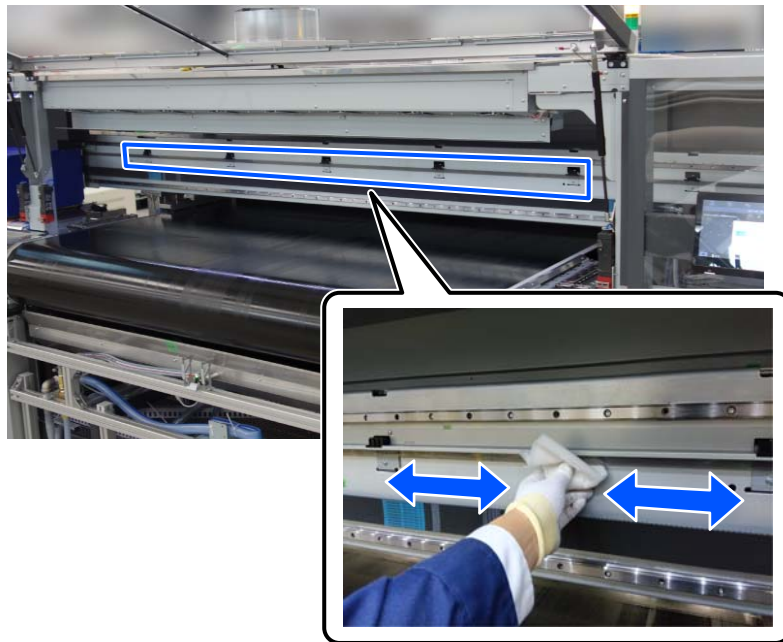
- 2 Open the front cover.



3

! **Important:**
*Do not touch the encoder scale directly with your hand.
Fingerprints and grease may cause print quality to decline. If it gets dirty, wipe it with a cleaning cloth.*

Wipe the encoder scale across the width of the belt with an ethanol-soaked cleaning cloth.

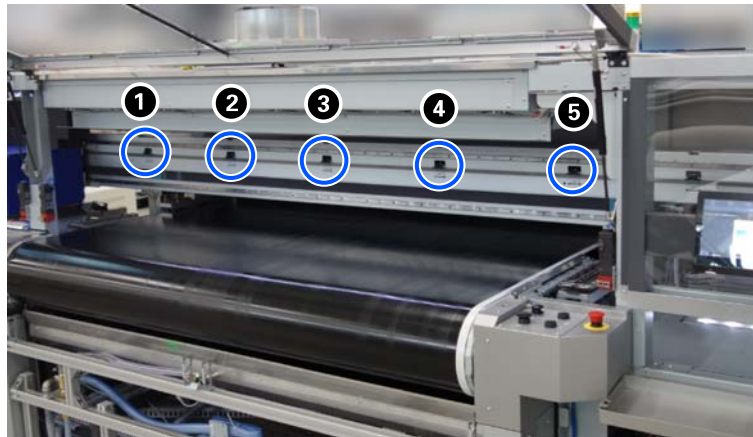


- 4 Pull down on the encoder scale near the 1st to 5th scale holders on the left side of the front of the printer, and check that the encoder scale does not detach from the scale holders.

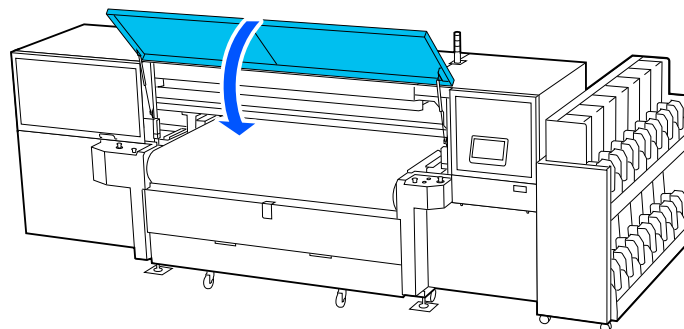
! **Important:**
If you continue to print while the encoder scale is detached from the scale holders, the encoder scale may rub against the print head and break.

Maintenance

 [“Installing the Encoder Scale” on page 280](#)



- 5** Close the front cover.



- 6** Turn on the printer.

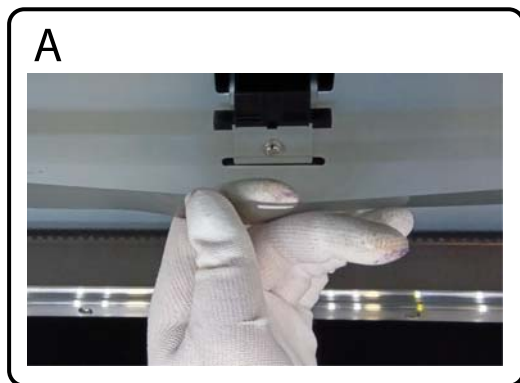
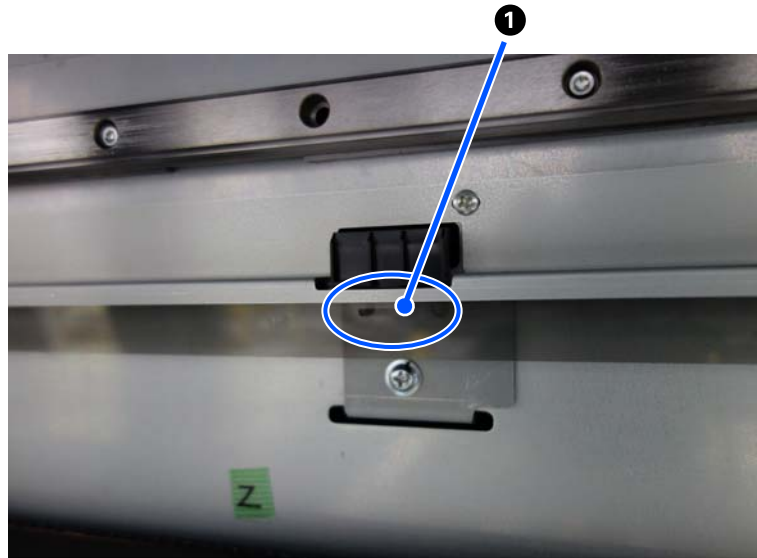
 [“Turning On the Power” on page 51](#)

- 7** From the Maintenance screen on the control panel, touch **Maintenance - Cleaning the Maintenance Parts - Encoder Scale - Complete**, in that order.

Maintenance

Installing the Encoder Scale

- 1 Attach the encoder scale by carefully bending the hole part (1) of the encoder scale with your fingers, as shown in A, and insert it from below the scale holder.



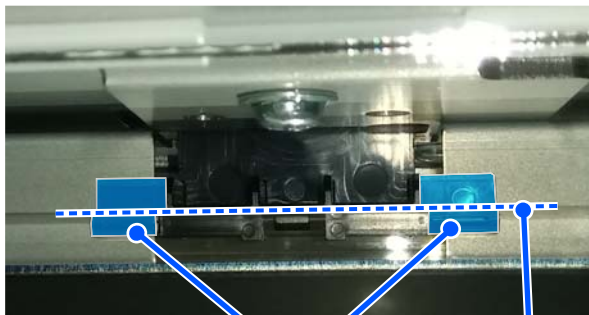
Maintenance

- 2** Use the mirror to check from below the scale holder to confirm that the encoder scale is properly installed in the scale holder.

If the protrusions (❶) at both ends of the scale holder extend toward the front beyond the encoder scale (❷), it is properly installed. If the protrusions at both ends of the scale holder are behind the encoder scale, return to step 1 and reinstall it.

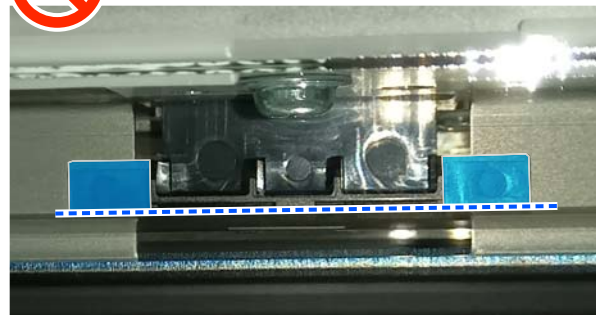


OK



❶

❷



Print Head Nozzle Check

We recommend that you check the nozzles for clogs each time you print to ensure quality results.

Types of check pattern printing

There are three ways to check for clogs.

Printing a check pattern when needed

When you want to check the condition of the nozzles before printing, or if there are stripes and unevenness in print results, you can print a check pattern to inspect the condition of the nozzles visually. See the following for details.

Maintenance

 [“Printing procedure for check patterns” on page 282](#)

Printing a check pattern for information printing

This prints a check pattern on the edges of the fabric during printing. You can check for clogged nozzles during printing, such as when printing jobs continuously or when printing a long job. See the following to change the settings.

 [“General Settings Menu” on page 434](#)

Nozzle Check between Jobs

Prints a check pattern for every set number of jobs. You can visually inspect the check pattern to determine whether there may be faint or missing colors in the preceding or following printout. See the following to change the settings.

 [“General Settings Menu” on page 434](#)


Printing procedure for check patterns

The following explains the procedure for printing a check pattern on photo paper.

You can print this pattern on fabric, but accurately determining clogging may not be possible.

Note:

Depending on the type of media used for printing and the nature of the operation, you need to change the settings for each switch and the settings for the printer.

 [“List of Printer Settings by Operation” on page 450](#)

Required Items	<input type="checkbox"/> Cleaning cloth <input type="checkbox"/> Rubber roller "When printing with Fabric Width Saving turned Off" <input type="checkbox"/> 1 sheet ^{*1} of A2 (594 × 420 mm [23.39 × 16.54 inches]) size photography paper "When printing with Fabric Width Saving turned On" <input type="checkbox"/> 1 sheet ^{*2} of A3 (420 × 297 mm [16.54 × 11.69 inches]) size photography paper
----------------	--

*1 A3 size (420 × 297 mm [16.54 × 11.69 inches]) can also be used instead. When using A3 size photography paper, prepare two sheets.

*2 You can use A4 size as a substitute. When using A4 size (297 × 210 mm [11.69 × 8.27 inches]) photography paper, prepare two sheets.

- 1** From the menu button on the control panel, touch **General Settings - Printer Settings**, in that order, and then set **Cut Sheet Mode** to **On**.
- 2** From the Maintenance screen on the control panel, touch **Maintenance - Print Head Nozzle Check**, in that order.
- 3** Select whether to turn **Fabric Width Saving** to **On** or **Off**.
Pattern print range

Maintenance

- ❑ Off: Approx. 493 × approx. 240 mm (19.57 × 9.45 inches)
- ❑ On: Approx. 246 × approx. 374 mm (9.69 × 14.72 inches)

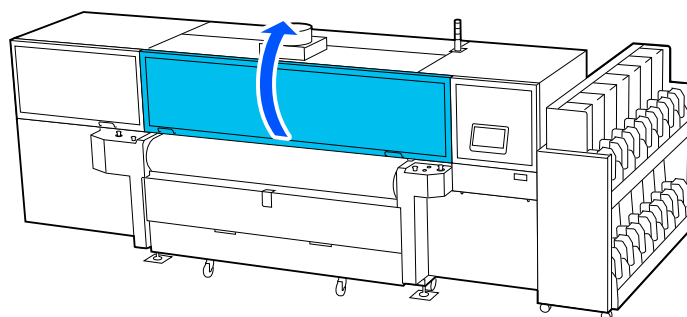
4 Specify the print start position from the right edge of the belt.

5 Touch **Carriage Speed** to set the same carriage speed as during printing. Check the Carriage Speed from your RIP software or printing application.

When using Epson Edge Print, see the Epson Edge Print help for details on the carriage speed.

When using the Epson Rob file print tool, see the Operation Guide for the Epson Rob file print tool for details on the carriage speed.

6 Open the front cover.



7 Soak a cleaning cloth in water, wring it out thoroughly, and then wipe the belt surface.

This prevents the photography paper from sticking to the belt. Wipe off any debris or lint on the belt surface.

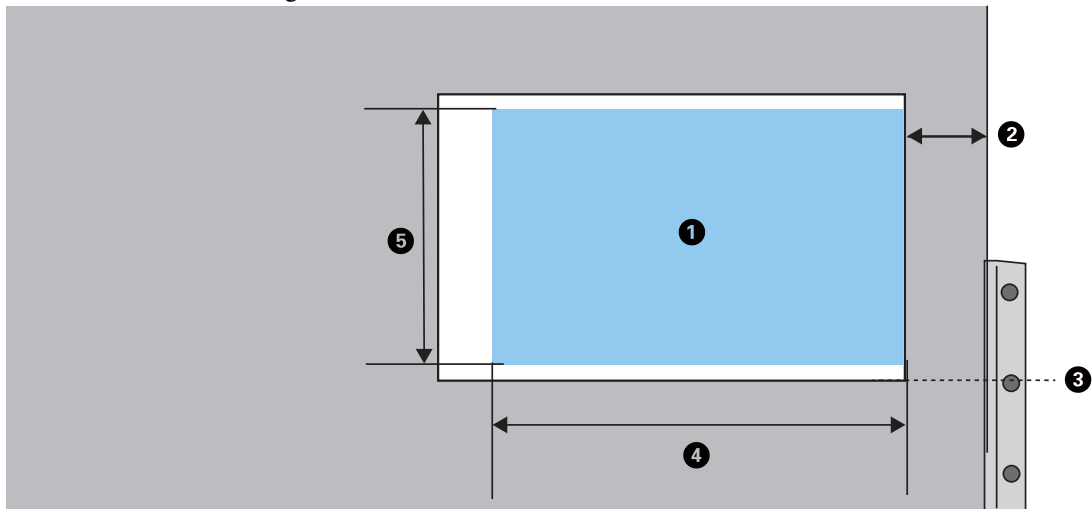


Maintenance

8

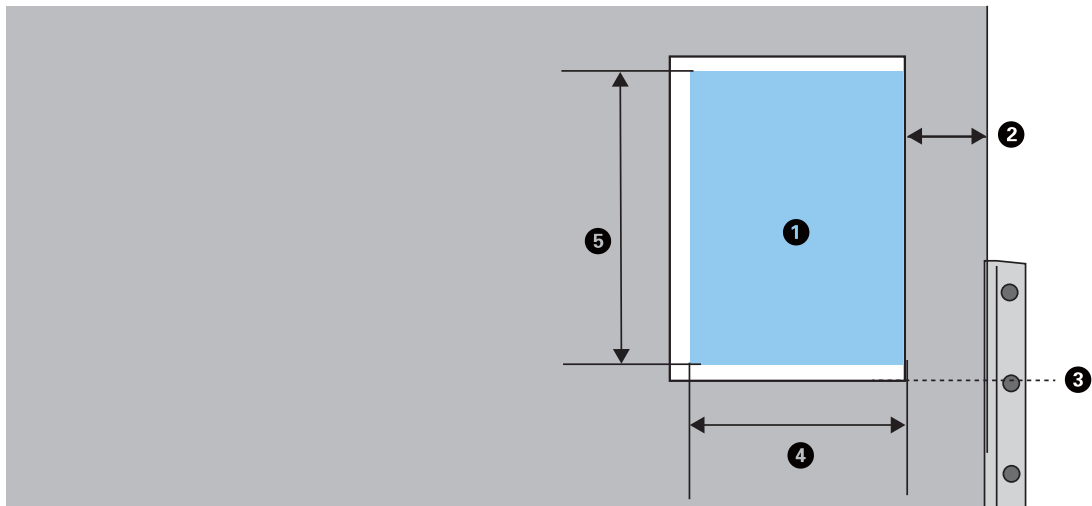
Place the photography paper on the belt by using the print area in the pattern as a reference.

When Fabric Width Saving is set to Off



- ① Check pattern
- ② Print start position (X direction): Arbitrary
- ③ Print start position (Y direction): The approximate start position is the second hole from the back of the guide, beside the belt
- ④ Pattern print width: Approximately 493 mm (19.41 in.)
- ⑤ Pattern print length: Approximately 240 mm (9.45 in.)

When Fabric Width Saving is set to On



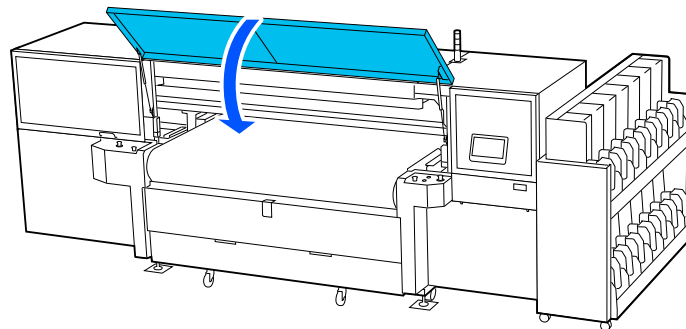
- ① Check pattern
- ② Print start position (X direction): Arbitrary
- ③ Print start position (Y direction): The approximate start position is the second hole from the back of the guide, beside the belt
- ④ Pattern print width: Approximately 246 mm (9.68 in.)
- ⑤ Pattern print length: Approximately 374 mm (14.72 in.)

Maintenance

- 9** Move the rubber roller to the rear side and stick the photography paper perfectly to the belt so that there are no wrinkles or creases.



- 10** Close the front cover.

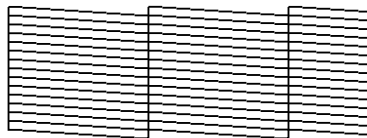


- 11** Check the on-screen message, and then touch **Start**.

A check pattern is printed.

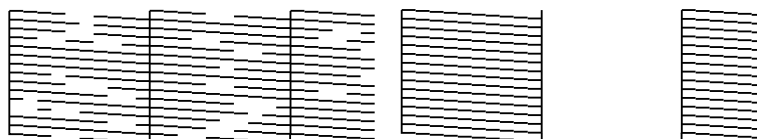
- 12** Open the front cover, remove the photography paper, and check the check pattern that was printed.

Example of clean nozzles



If no parts of the check pattern are missing, there is no clogging. Check the on-screen message, and then touch **OK**.

Example of clogged nozzles



If parts of the check pattern are missing or are not printed, there is clogging. Touch **NG** and then perform Print Head Cleaning.

Maintenance

 [“Print Head Cleaning” on page 286](#)

**Important:**

Always remove clogs from the nozzles of all colors before resuming use. If clogged nozzles (including clogged nozzles for colors that are not used) remain when printing after resuming use, the clogs can no longer be removed.

To finish checking for clogged nozzles and perform normal printing, from the menu button on the control panel, touch **General Settings - Printer Settings**, in that order, and then set **Cut Sheet Mode** to **Off**.

Print Head Cleaning

Perform print head cleaning to clear the clogged nozzles.

Types of cleaning

You can check the print head nozzles using any of the following three methods.

Cleaning the print head when needed

Perform print head cleaning if there are faint or missing parts of the check pattern that was printed.

There are three levels of cleaning available: **Cleaning**, **Power Cleaning**, **Print Head Refresh**.

The level of cleaning to be performed depends on the amount of missing parts in the check pattern.

Cleaning

Performs normal cleaning.

Power Cleaning

Performs a more powerful cleaning than normal Cleaning.

Print Head Refresh

Performs powerful cleaning combined with the ink suction function of the suction cap.

See the next section for cleaning procedures.

Periodic Cleaning

In Maintenance Setting, set Periodic Cleaning to On to perform periodic print head cleaning as a preventative measure before clogs actually occur in the nozzles. Set one of Print Duration, Print Jobs, or Print Length for the interval. See the following to change the settings.

 [“Maintenance Menu” on page 446](#)

Maintenance Cleaning

When Maintenance Cleaning is set to On in Maintenance Setting, print head cleaning is performed automatically after a certain period of time to keep the print head in optimum condition. See the following to change the settings.

 [“Maintenance Menu” on page 446](#)

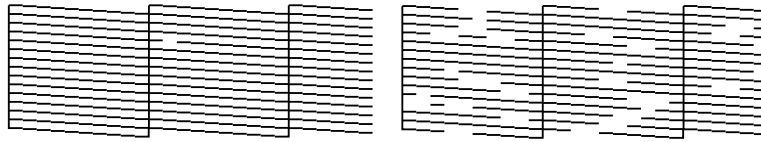
Maintenance

Checking the amount of clogging in the check pattern

When performing print head cleaning, check the amount of clogging shown in the printed check pattern.

When the check pattern is missing parts in one or several locations

Example

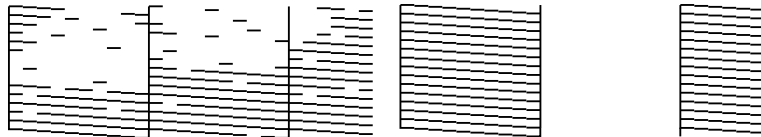


See the following to perform cleaning.

 ["Cleaning procedure when clogging has occurred in one or several locations" on page 287](#)

When some check patterns are missing or not printed at all

Example



See the following to perform cleaning.

 ["Cleaning procedure when some or all of the nozzles are clogged" on page 289](#)

Cleaning procedure when clogging has occurred in one or several locations

Follow the steps below to perform cleaning when the check pattern is missing parts in one or several locations.

Personal protective equipment

Protective gloves and clothing

- 1 From the Home screen of the control panel, touch **Maintenance - Print Head Cleaning**, and then select **Cleaning**.
- 2 Check the printed nozzle check pattern, then select the head number of the clogged nozzle along with the nozzle row that shows the same number.

Head numbers are printed at the bottom of each color pattern.

Maintenance

Example



OR
H11 B2
①

① Head number

3 Touch **Start**.

4 Print a check pattern to check for clogged nozzles.

[“Printing procedure for check patterns” on page 282](#)

When the nozzles are cleared, print head cleaning is complete. If the problem continues to occur, move on to the next procedure.

5 Select **Power Cleaning**.

A cleaning completion message is displayed when head cleaning is complete.

6 Select a row of nozzles for cleaning, and then touch **Start**.

Print head cleaning starts. When a cleaning completion message is displayed, touch **OK**.

7 Print a check pattern to check for clogged nozzles.

[“Printing procedure for check patterns” on page 282](#)

When the nozzles are cleared, print head cleaning is complete. If the problem continues to occur, move on to the next procedure.

8 Clean around the print head.

[“Inspecting/Cleaning Around the Print Head” on page 229](#)

9 Print a check pattern to check for clogged nozzles.

[“Printing procedure for check patterns” on page 282](#)

When the nozzles are cleared, print head cleaning is complete. If the problem continues to occur, move on to the next procedure.

Maintenance

- 10 Clean the suction caps.
[🔗 “Cleaning the Suction Caps” on page 213](#)
- 11 From the Home screen of the control panel, touch **Maintenance - Print Head Cleaning**, in that order, and then select **Print Head Refresh**.
- 12 Select a row of nozzles for cleaning, and then touch **Start**.
 Print head cleaning starts. When a cleaning completion message is displayed, touch **OK**.
- 13 Print a check pattern to check for clogged nozzles.
[🔗 “Printing procedure for check patterns” on page 282](#)
 When the nozzles are cleared, print head cleaning is complete. If the problem continues to occur, move on to the next procedure.
- 14 Select **Print Head Refresh**.
- 15 Select a row of nozzles for cleaning, and then touch **Start**.
 Print head cleaning starts. When a cleaning completion message is displayed, touch **OK**.
- 16 Print a check pattern to check for clogged nozzles.
[🔗 “Printing procedure for check patterns” on page 282](#)
 When the nozzles are cleared, print head cleaning is complete.
 If the problem continues to occur, you need to clean the nozzle surface or replace the head.
 For more details, contact your dealer or Epson Support.

Cleaning procedure when some or all of the nozzles are clogged

Follow the steps below to perform cleaning when some check patterns are missing or not printed at all.

Personal protective equipment	Protective gloves and clothing
-------------------------------	--------------------------------

- 1 Clean the suction caps.
[🔗 “Cleaning the Suction Caps” on page 213](#)
- 2 From the Home screen of the control panel, touch **Maintenance - Print Head Cleaning**, in that order, and then select **Print Head Refresh**.
- 3 Check the printed nozzle check pattern, then select the head number of the clogged nozzle along with the nozzle row that shows the same number.
 Head numbers are printed at the bottom of each color pattern.

Maintenance

Example



OR
H11 B2
①

① Head number

4 Touch **Start**.

5 Print a check pattern to check for clogged nozzles.

[“Printing procedure for check patterns” on page 282](#)

When the nozzles are cleared, print head cleaning is complete. If the problem continues to occur, move on to the next procedure.

6 Clean around the print head.

[“Inspecting/Cleaning Around the Print Head” on page 229](#)

7 Select **Print Head Refresh**.

8 Select a row of nozzles for cleaning, and then touch **Start**.

Print head cleaning starts. When a cleaning completion message is displayed, touch **OK**.

9 Print a check pattern to check for clogged nozzles.

[“Printing procedure for check patterns” on page 282](#)

When the nozzles are cleared, print head cleaning is complete.

If the problem continues to occur, you need to clean the nozzle surface or replace the head.

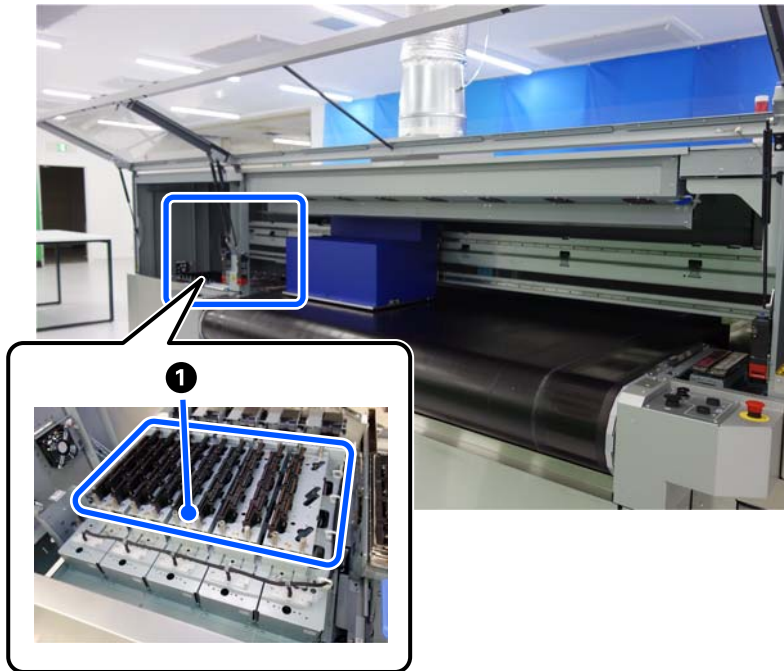
For more details, contact your dealer or Epson Support.

Capping the Print Head

The print head may not be capped if the printer is turned off due to an error, or if the power turns off suddenly.

Maintenance

If the machine remains suspended at a position other than the capping position for more than 20 minutes, the print head may become clogged and cause a malfunction.



1 Capping position

Perform the following actions within 20 minutes.

Auto capping

Make sure the belt is clear and turn the power on again.

[☞ “Turning On the Power” on page 51](#)

Wait a while until capping is performed automatically.

If the print head is left uncapped for more than 20 minutes, clean the print head.

[☞ “Print Head Cleaning” on page 286](#)

If the power does not turn on and capping does not continue for more than 20 minutes, perform the following manual capping procedure.

Manual capping

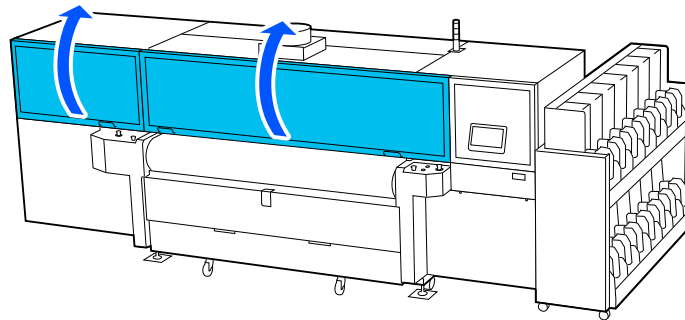
Required Items	Phillips screwdriver (shaft length of about 300 mm (12 inch), size No. 2), protective gloves, eye protection, and protective clothing
----------------	---

Maintenance

- 1 Check that the machine is off.

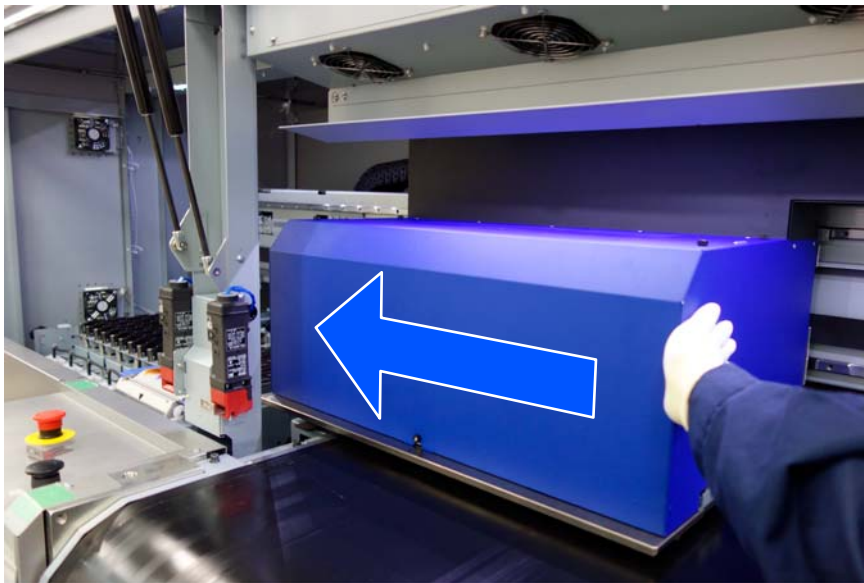
☞ “Turning Off the Power” on page 110

- 2 Open the front cover and the maintenance cover (left).



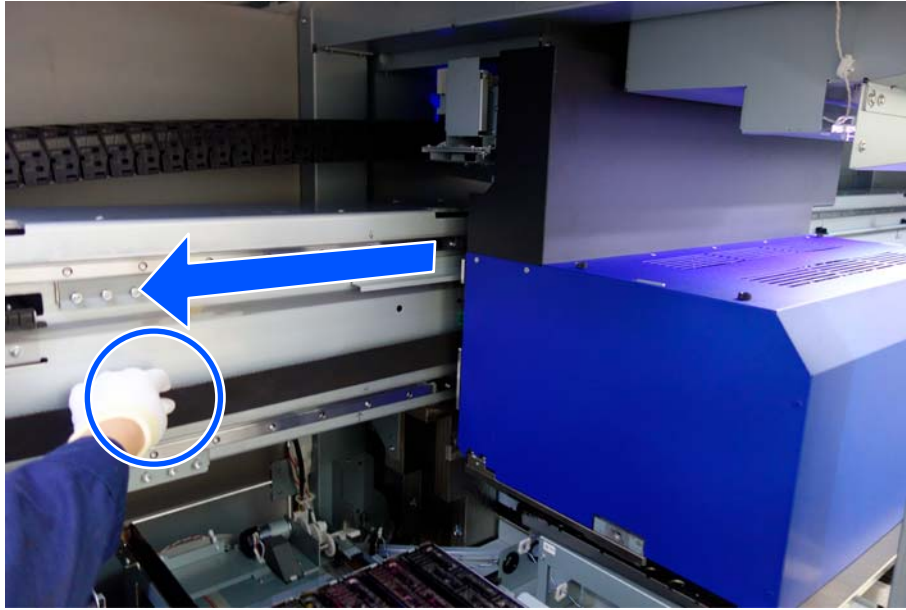
- 3 Push and move the print head to the front left edge.

If the print head is difficult to push, pull the print head belt to the left and move the print head to the left.

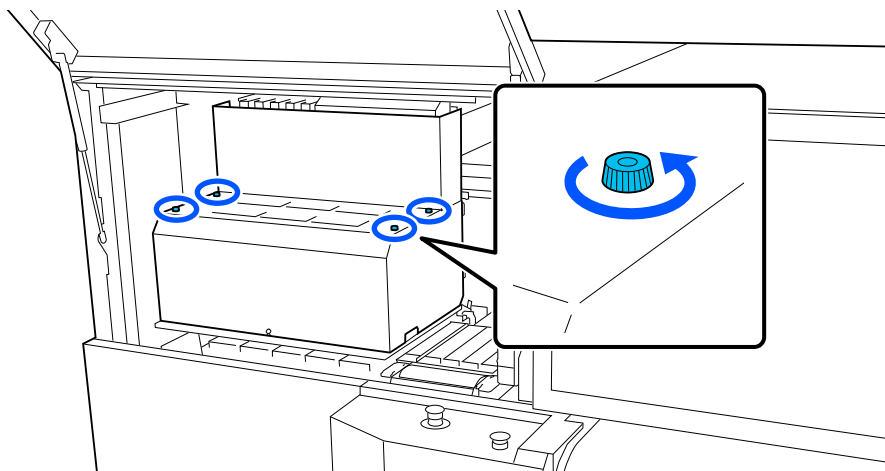


Maintenance

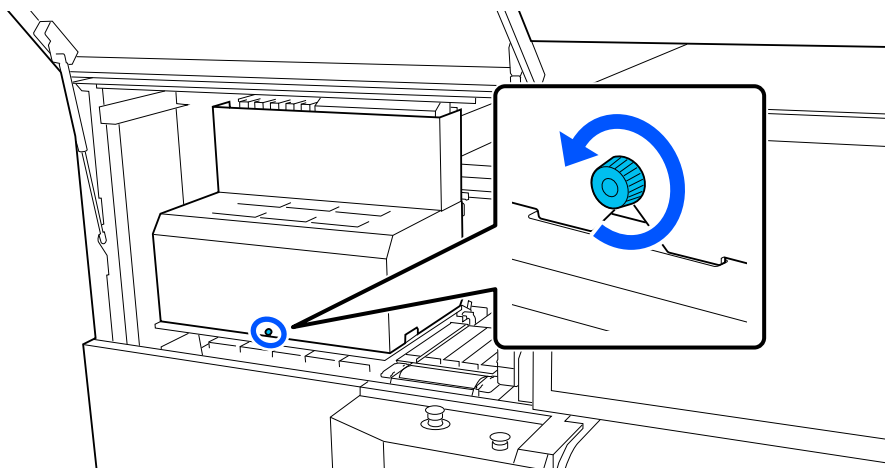
When it is difficult to push the print head to the left side



- 4 Remove the four screws at the top of the print head cover.

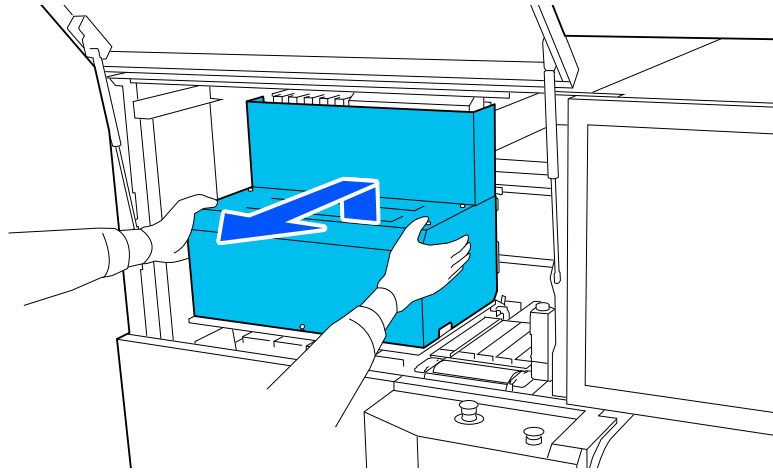


- 5 Loosen the screw on the front of the print head cover.

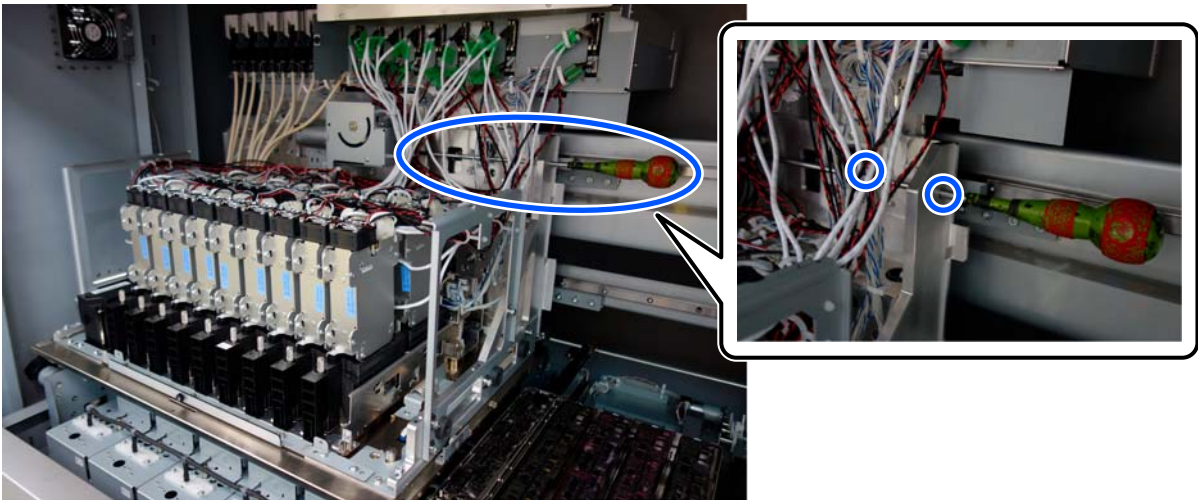


Maintenance

- 6 Remove the print head cover.



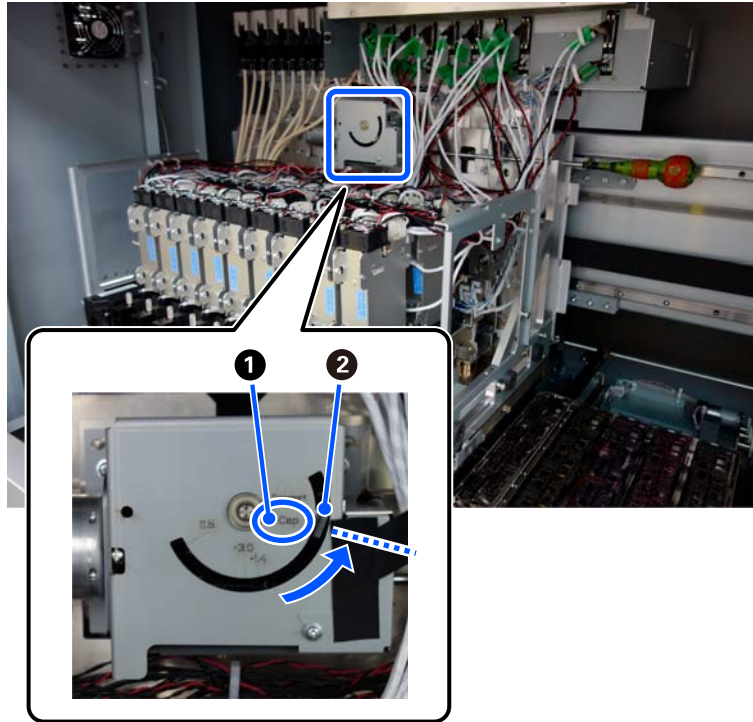
- 7 Insert the screwdriver straight into the guide on the right side of the print head.



Maintenance

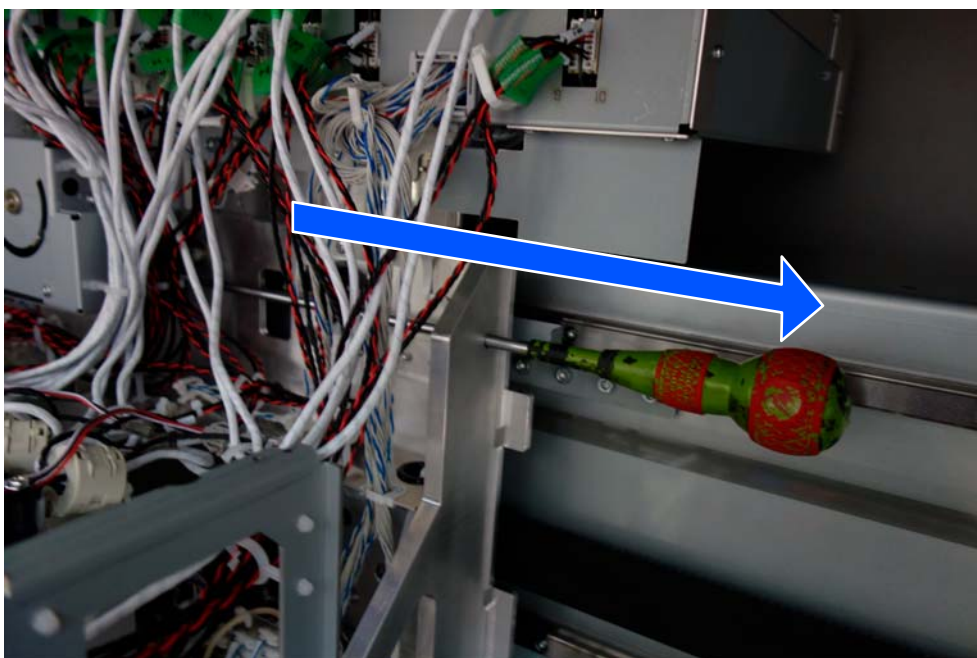
- 8** Turn the inserted screwdriver toward you until the needle on the scale at the top of the print head is at the “Cap” position.

The print head will be capped.



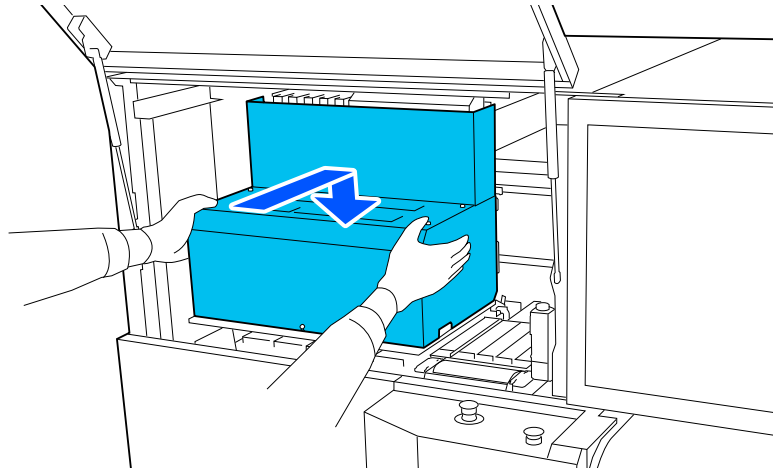
- 1 Scale
- 2 Needle

- 9** Pull out the screwdriver.

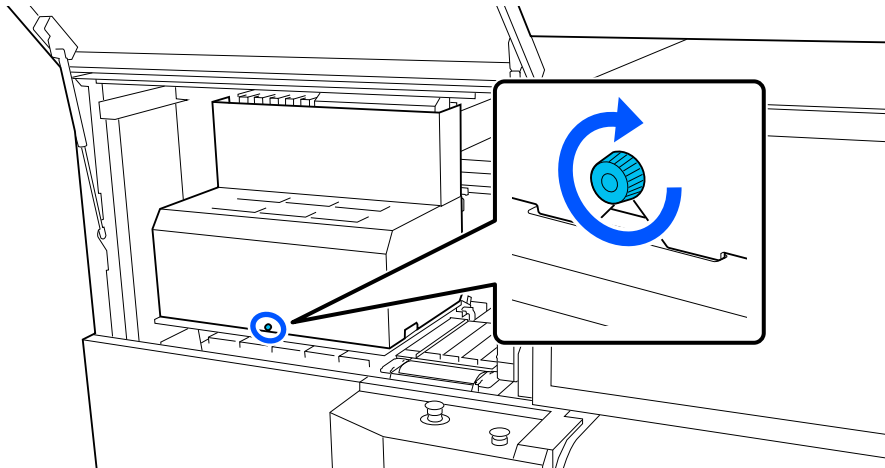


Maintenance

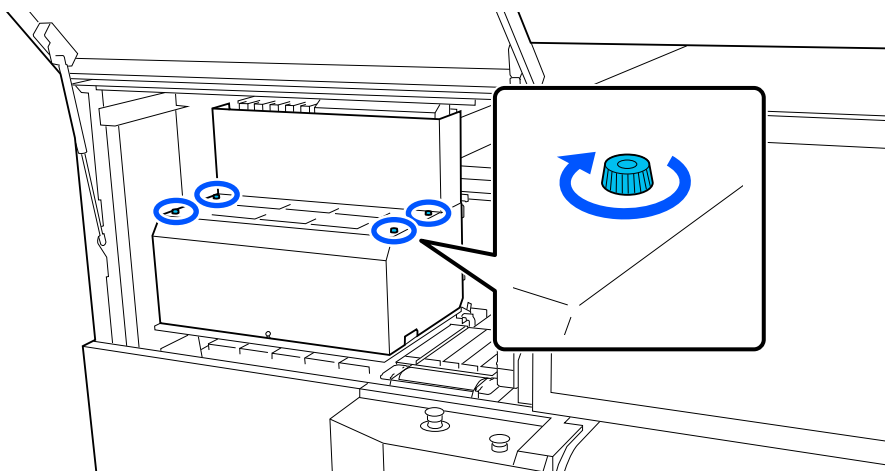
- 10** Attach the print head cover.



- 11** Tighten the screw on the front of the print head cover.

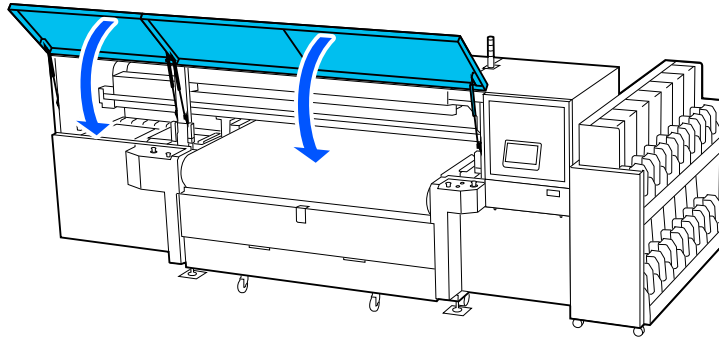


- 12** Tighten the four screws at the top of the print head cover.



Maintenance

- 13** Close the front cover and the maintenance cover (left).



Adding Grease to the Scan Spindle

If there is not enough grease on the operating part of the print head, the print head will not move smoothly and print quality may decline.

Follow the steps below to add grease once a month.

 [“Adding grease to the scan spindle \(once a month\)” on page 297](#)

When a message prompting you to add grease is displayed on the control panel screen (once a year), it is time to grease the operating parts of the print head.

 [“Adding grease to the operating parts of the print head \(once a year\)” on page 298](#)

Adding grease to the scan spindle (once a month)

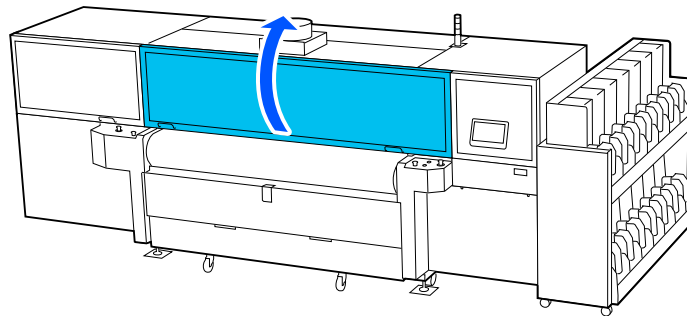
Required Items	Grease tube, protective gloves, and protective clothing
----------------	---

Note:

We recommend that the belt be covered with fabric to protect the belt when working on it.

- 1** Check that the machine is off.

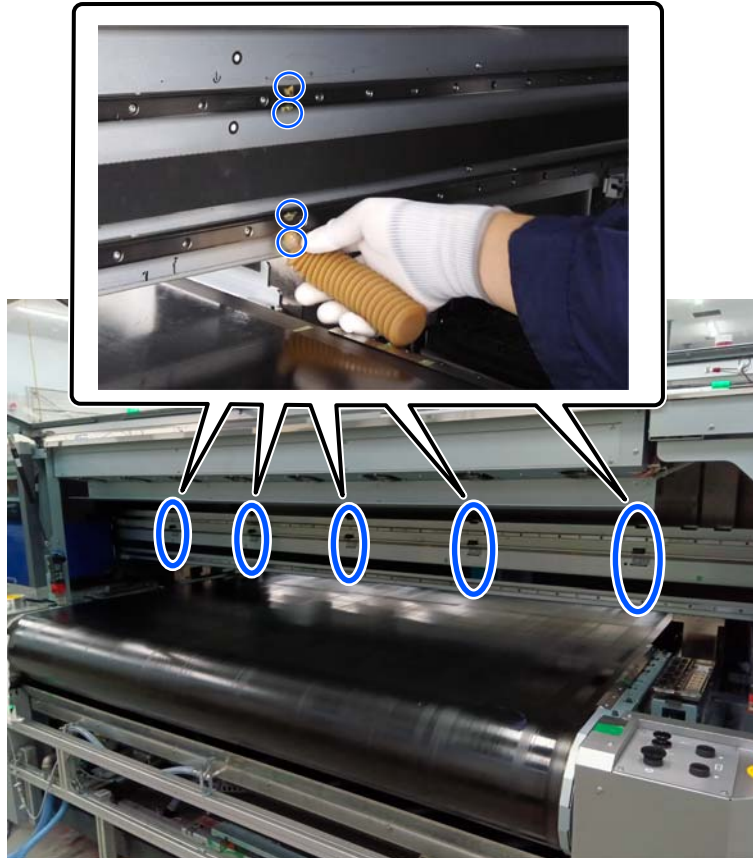
- 2** Open the front cover.



Maintenance

- 3 Add grease to a total of 20 locations: 5 locations in the direction of the girder on the scan spindle, and 4 locations on the edges of the upper and lower rails.

Use a little bit of grease (about the size of a grain of rice) from the grease tube and rub it on the edge.



- 4 Close the front cover.

Adding grease to the operating parts of the print head (once a year)

Required Items

Grease pump, grease tube, flat-head screwdriver, Phillips screwdriver (size No. 2 with a shaft length of approximately 150 mm (6 inches)), protective gloves, and protective clothing

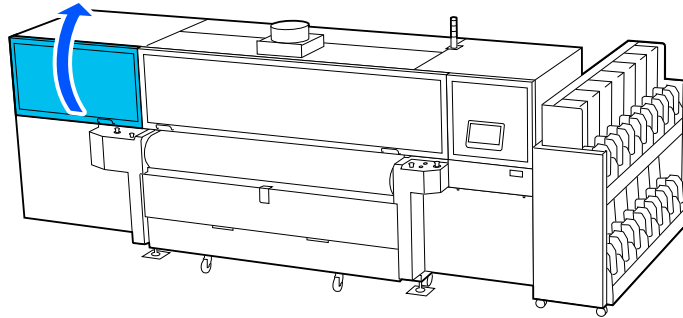
Note:

We recommend that the belt be covered with a fabric to protect the belt when working on it.

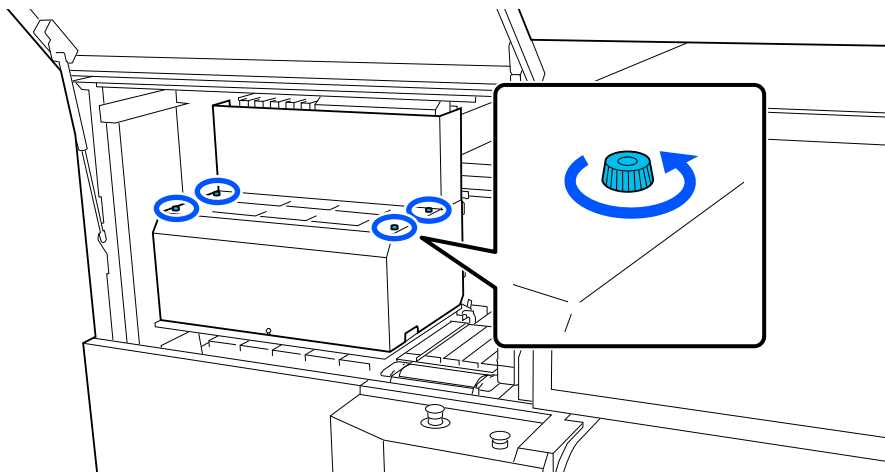
- 1 Check that the machine is off.
[🔗 “Turning Off the Power” on page 110](#)
- 2 Press the grease pump and make sure that the grease comes out of the grease pump nozzle.

Maintenance

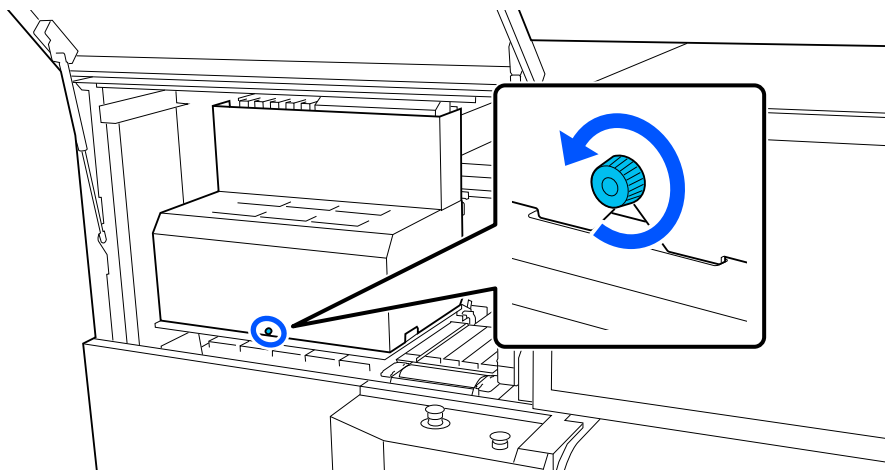
- 3** Open the maintenance cover (left).



- 4** Remove the four screws at the top of the print head cover by hand.

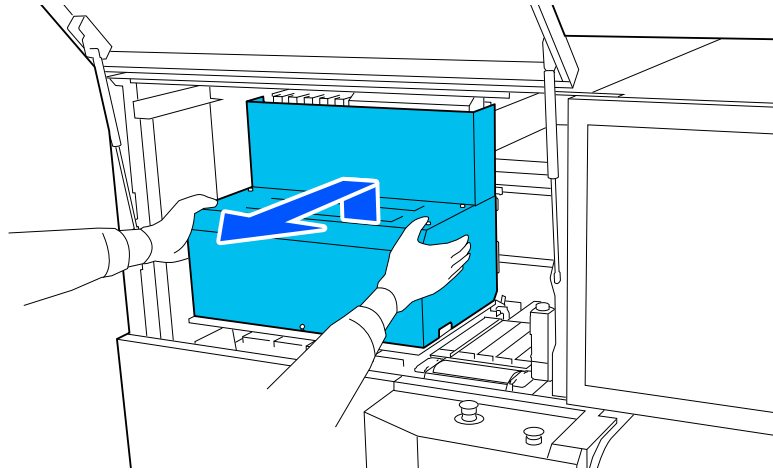


- 5** Loosen the screw on the front of the print head cover by hand.



Maintenance

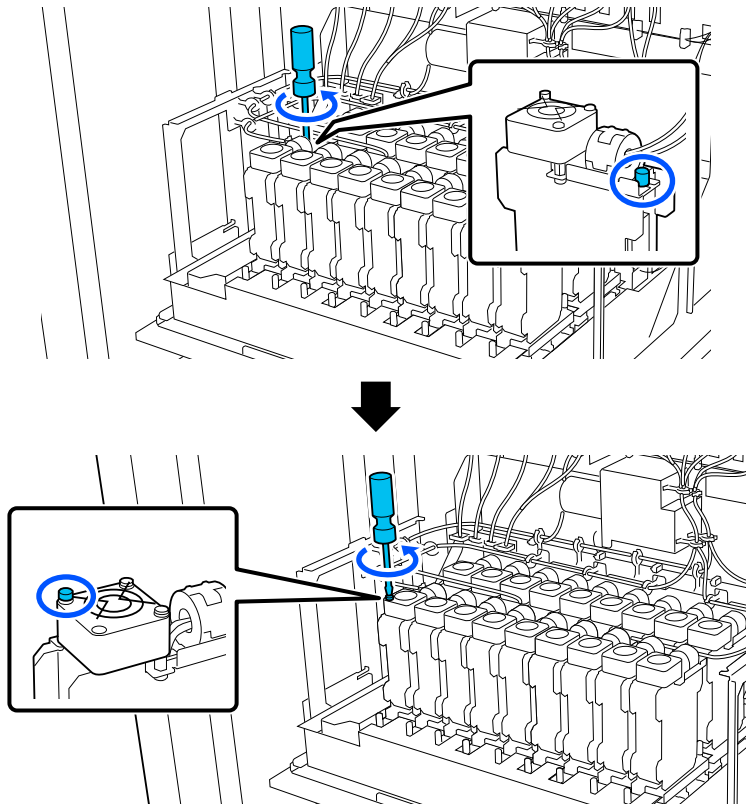
- 6** Remove the print head cover by lifting it slightly and then pulling it forward.



- 7** Check the position of print heads 1, 2, and 18.

The print head arrangement order is shown on the front of the print head.

- 8** Loosen the two screws of the fan unit on the top of the print head driver of print head 1 using a flat-head screwdriver.

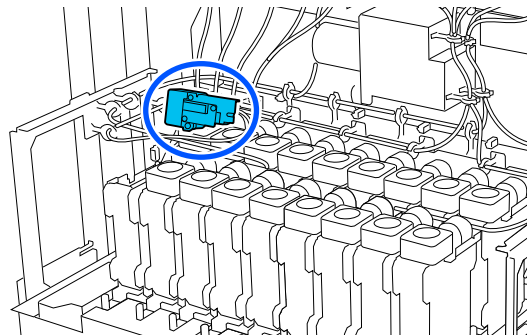
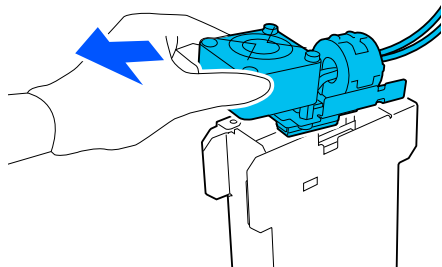
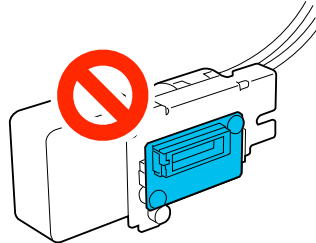


Maintenance

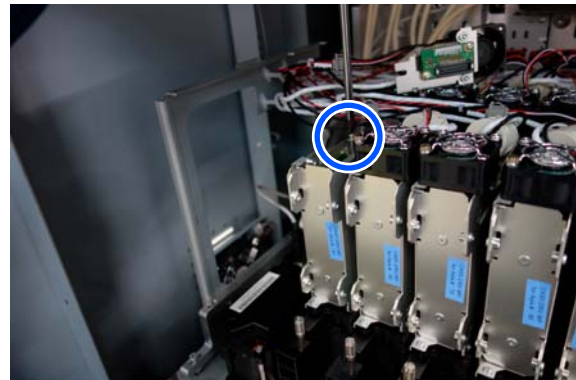
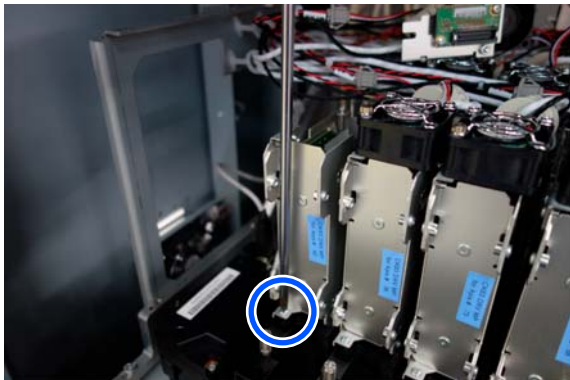
- 9 Remove the fan unit by sliding it diagonally up and forward, then place it behind the back row of print head drivers.

! **Important:**

Place the removed fan unit carefully so that your hands or other parts of the printer do not touch the circuit board of it.

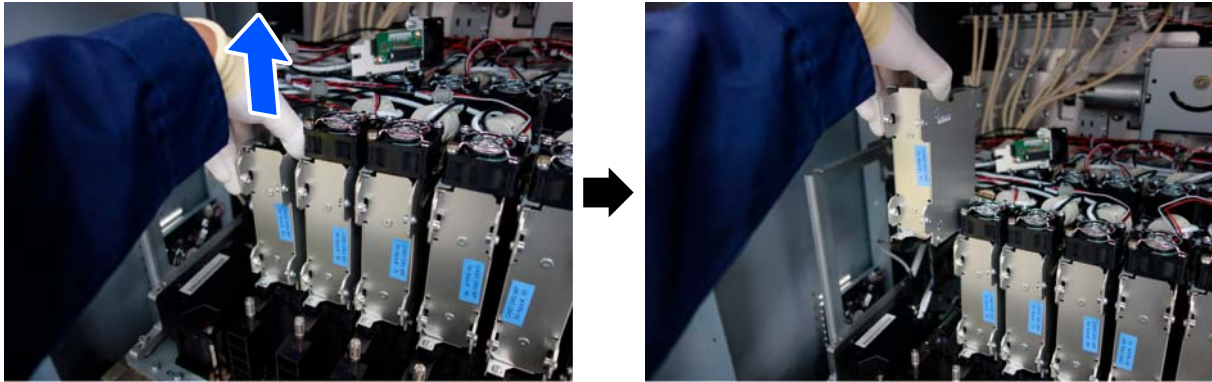


- 10 Loosen the two print head driver screws with a Phillips screwdriver.



Maintenance

- 11 Pull out the print head driver straight up.

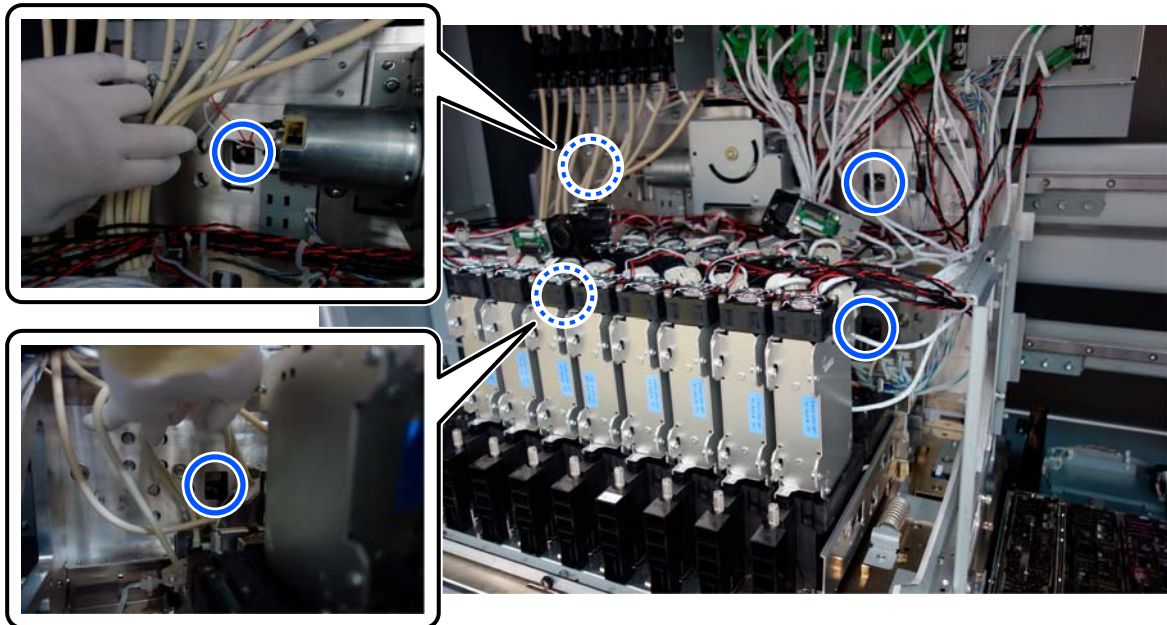


- 12 Repeat steps 8 to 11 to remove the print head drivers for print heads 2 and 18.

The installation location of the print head driver does not matter. There is no need to remember the installation location of the print head driver you have removed.

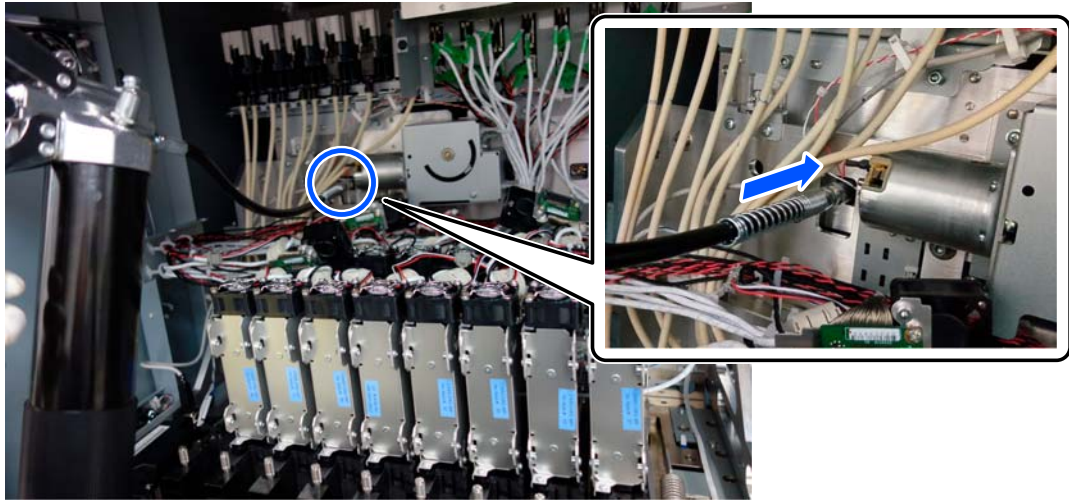
- 13 Pour grease in all four oil filler holes on the top and bottom.

! Important:
If there is excess grease or ink deposits in or around the oil filler holes, wipe them clean with a cleaning cloth before you start work.



Maintenance

- ① Insert the grease pump nozzle into the oil filler port until you hear a click.



- ② Lubricate with grease.



Important:

Do not push more than 4 times per oil filler hole. Doing so can result in excess grease dripping onto fabric, resulting in a printing error.

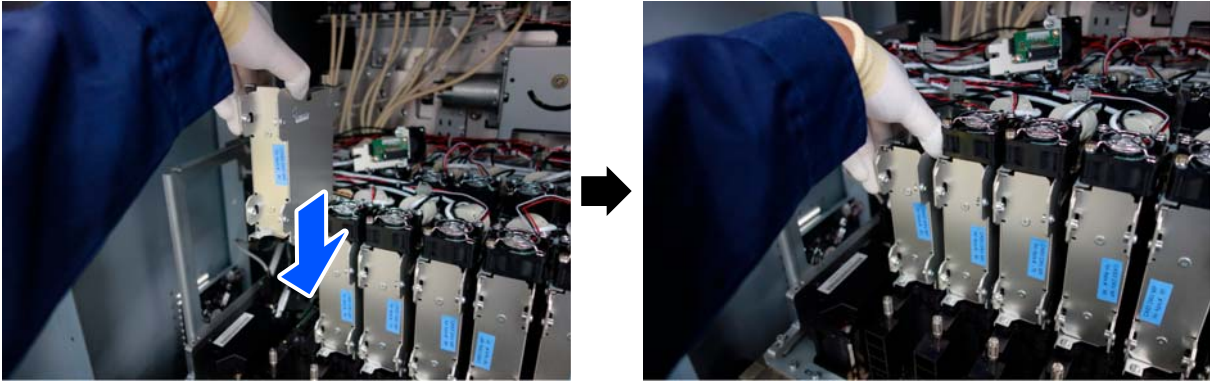
Push three times for one oil filler hole.



Maintenance

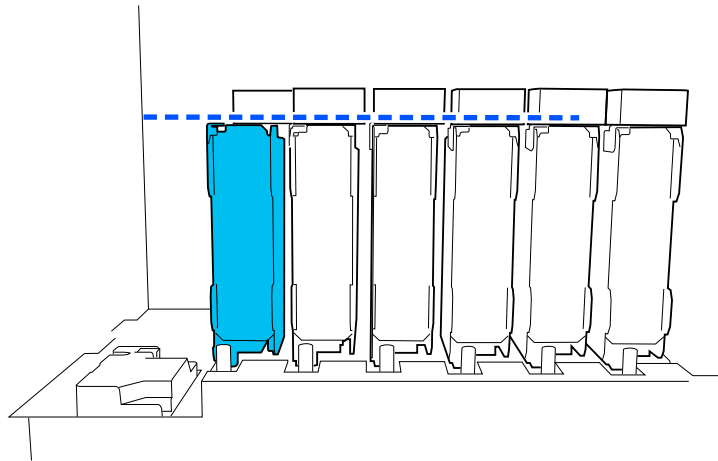
- 14** Insert the removed print head driver straight back into its original position.

It does not matter which print head driver you are installing and where you are installing it.

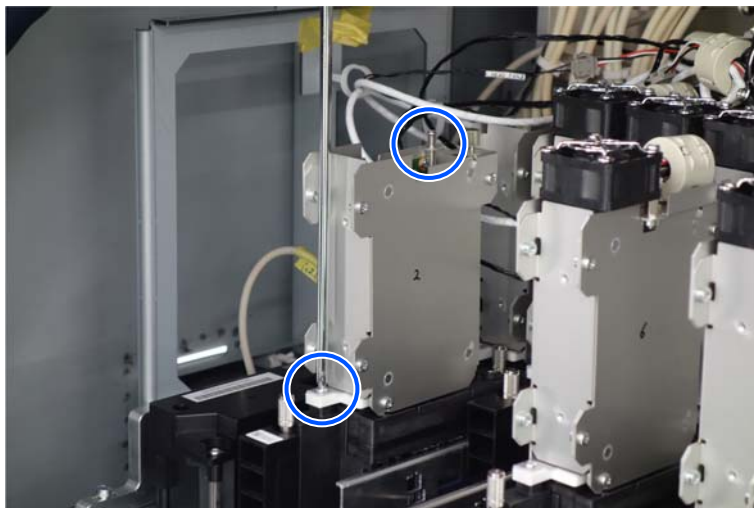


- 15** Make sure the height of the installed print head driver aligns with the adjacent print head drivers.

If the height does not align, press it firmly from above.



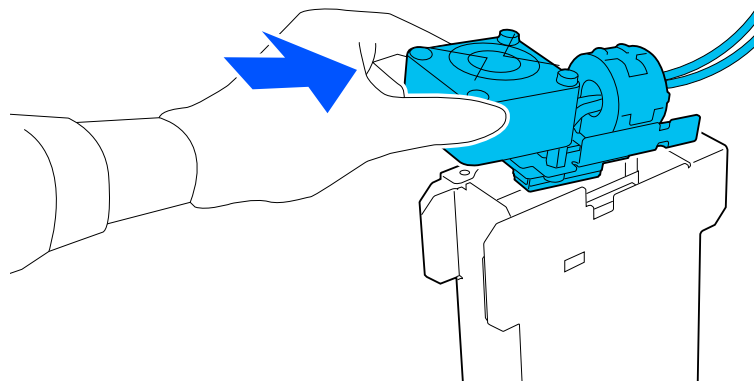
- 16** Tighten the two print head driver screws with a Phillips screwdriver.



Maintenance

17 Install the fan unit in the same position as before removal.

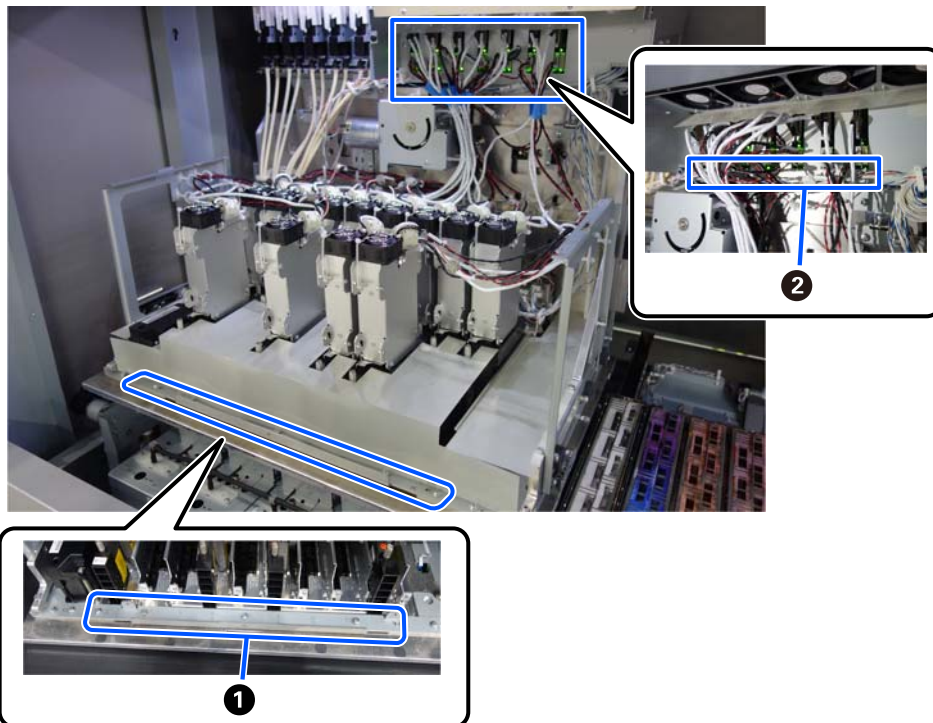
- ① Install by sliding it from the front to the rear.



Note:

If you are unsure of the mounting position of the fan unit, check the numbering on the print head and fan wiring connections.

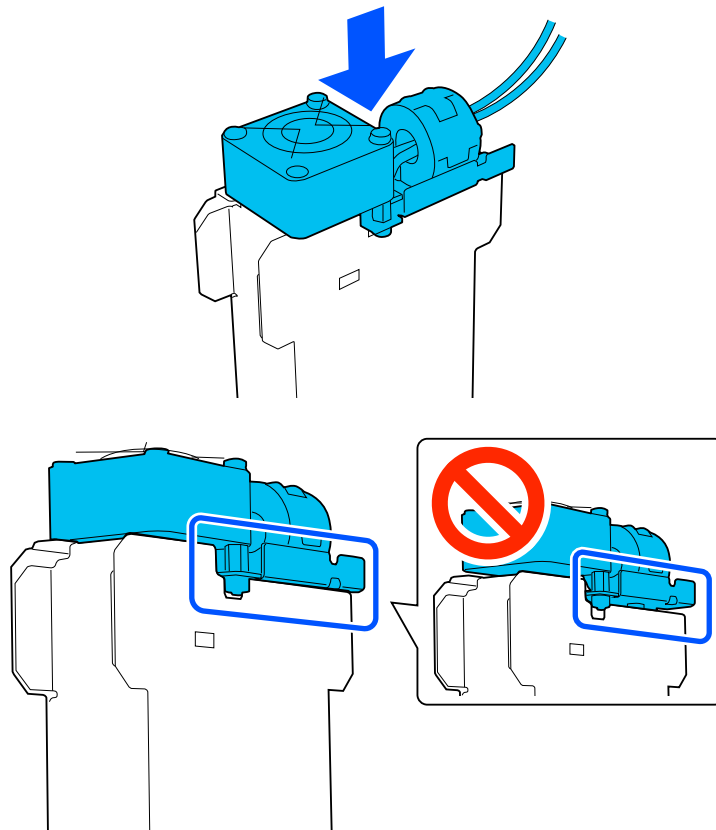
Install the fan unit in the print head driver at the location with the same print head number as the number of the wiring connection source.



- ① Print head numbering position
- ② Numbering position of the wiring connection source

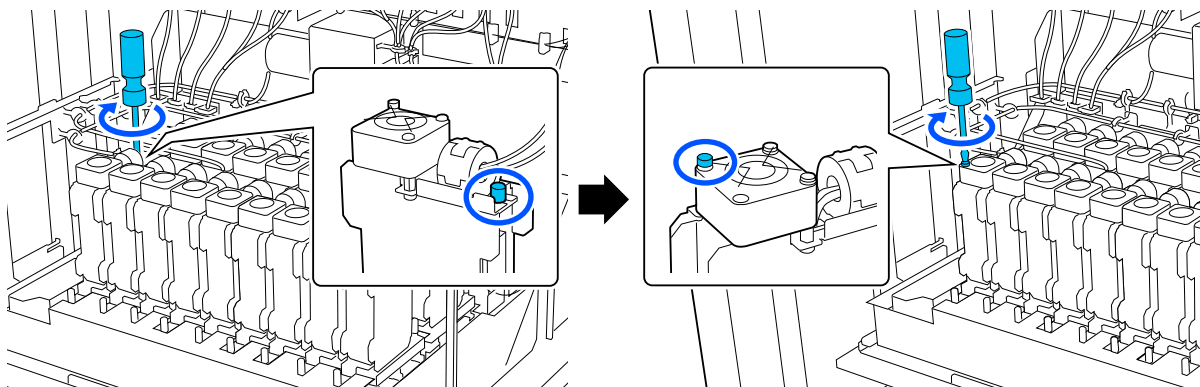
Maintenance

- ② To prevent any gap from forming between the fan unit and the print head driver, press between the fan and the core.



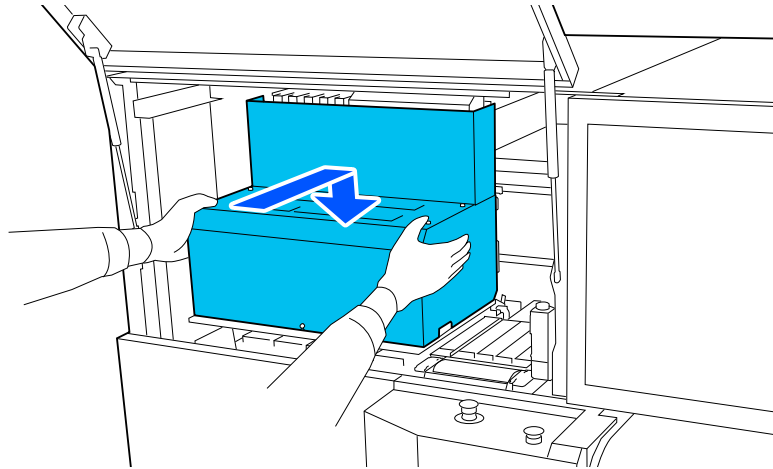
18

Tighten the two print head driver screws with a flat-head screwdriver.

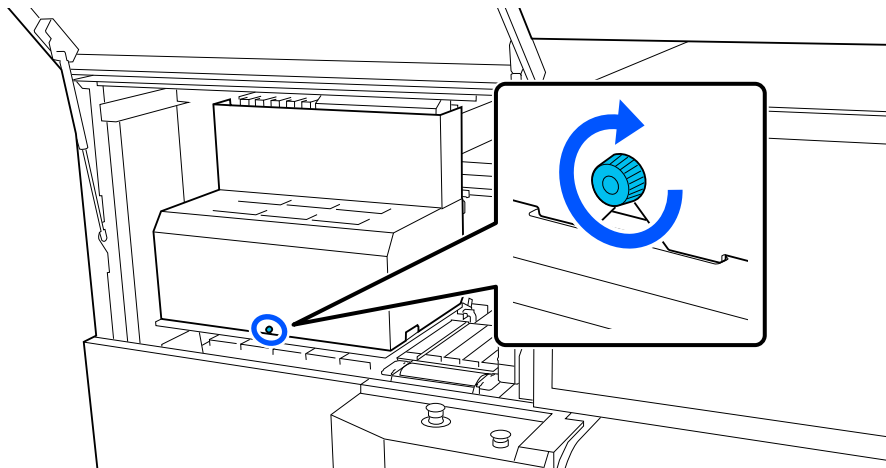


Maintenance

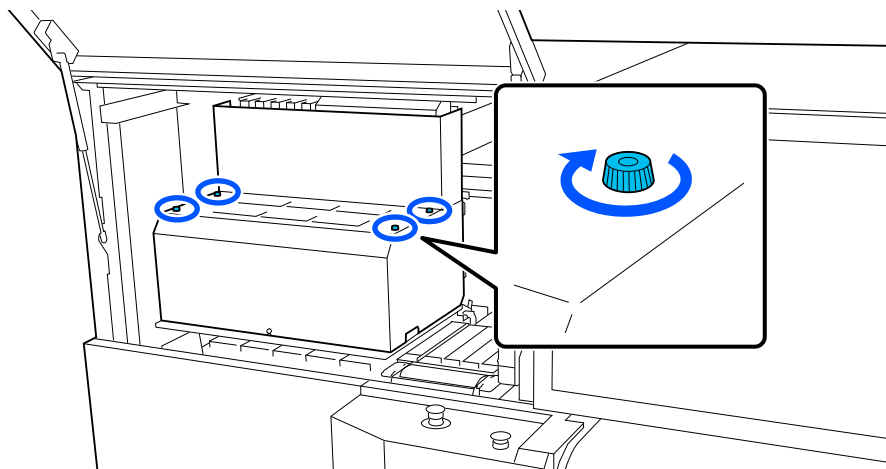
- 19** Install by slightly lifting the print head cover while pushing it all the way in so that the cover fits inside the front screws.



- 20** Tighten the screw on the front of the print head cover by hand.

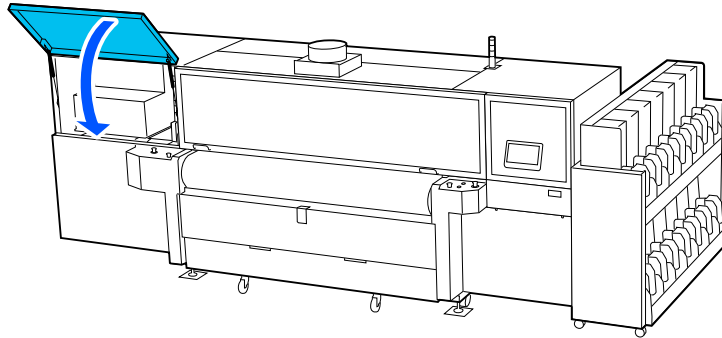


- 21** Tighten the four screws on the top of the print head cover by hand.



Maintenance

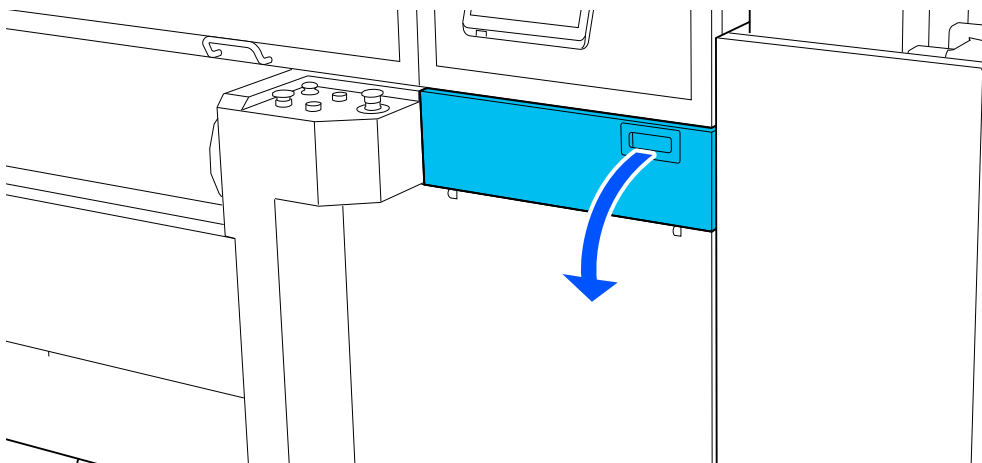
- 22 Close the maintenance cover (left).



- 23 Turn on the printer.

☞ [“Turning Off the Power” on page 110](#)

- 24 Open the maintenance cover (right).



- 25 Confirm that there is no grease dripping on the bottom surface inside the maintenance cover (right).
If grease is dripping, wipe it off with a cleaning cloth.



Maintenance


26

From the Maintenance screen on the control panel, touch **Maintenance - Adding Grease to the Scan Spindle - Done**, in that order.

The grease lubrication counter will be cleared.

Timing for Reapplying the Glue

Determine the time to reapply the glue (removal/application) based on the condition of the fabric and print quality or the results of measuring the adhesive strength of the glue applied to the belt. See the following when reapplying glue.

 [“Removing Glue \(When Using the Glue Removal Tool\)” on page 314](#)

 [“Removing Glue \(When Using the Glue Bucket\)” on page 366](#)

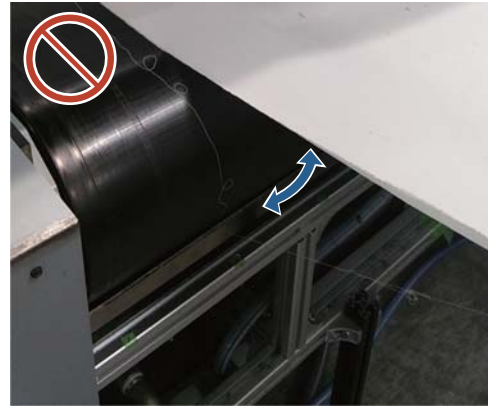
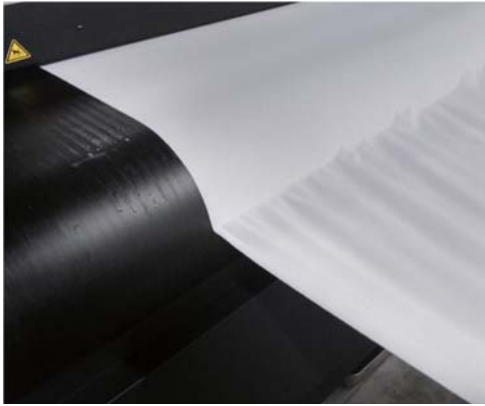
 [“Applying Glue” on page 402](#)

Is the fabric attached to the belt floating?

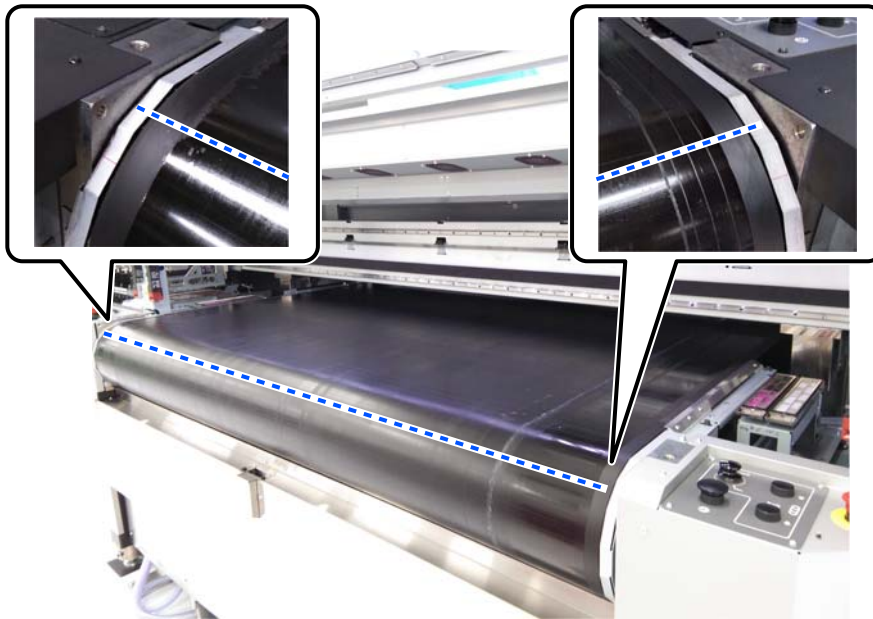
In the following conditions, the strength with which the belt is attached is weakened.

Maintenance

- ❑ The fabric easily peels off the belt when printing with a dryer or drying reel
If there is enough strength to the adhesive, the fabric sticks firmly even at the curved parts of the belt.
If there is not enough strength to the adhesive, the fabric peels off even at flat parts of the belt.

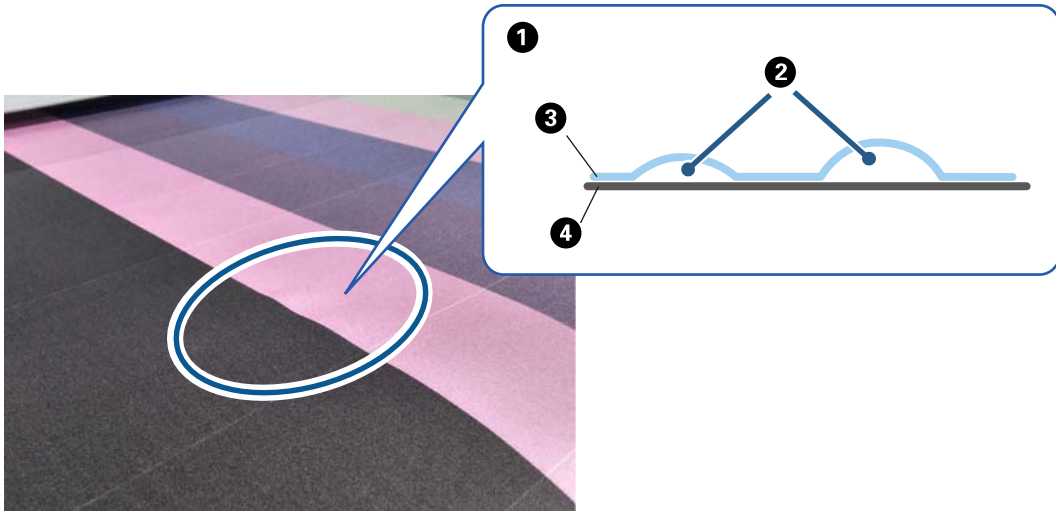


We recommend reapplying the glue if the fabric peels off at the position shown in the photos below (midway between the first block where the frame folds at both edges of the belt).



Maintenance

- Parts of the fabric rise slightly
The fabric and the belt do not stick to each other and the fabric rises slightly even when the heated pressure roller is applied.

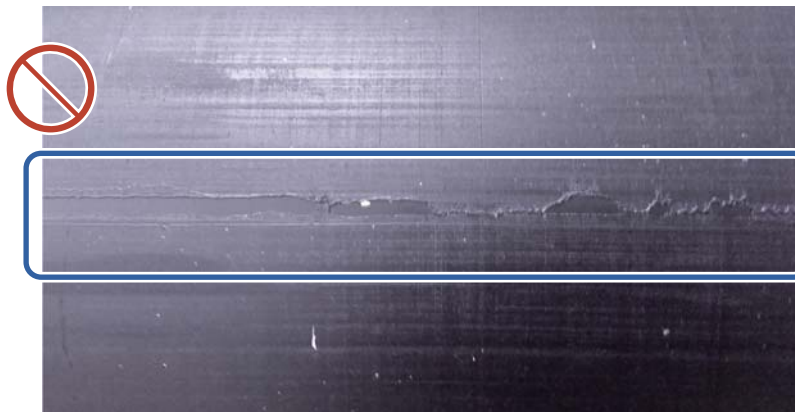


- ① Cross section
- ② Fabric rises slightly
- ③ Fabric
- ④ Belt

- When you touch the belt with your hand, you can see that the adhesive strength has almost gone


Check for water droplets on the belt

When water droplets remain on the belt, it may indicate that the glue has peeled off, as shown in the illustration below.



When water droplets remain on the belt, it may be due to causes other than the glue peeling off.

See below if water droplets remain on the belt even after reapplying the glue.

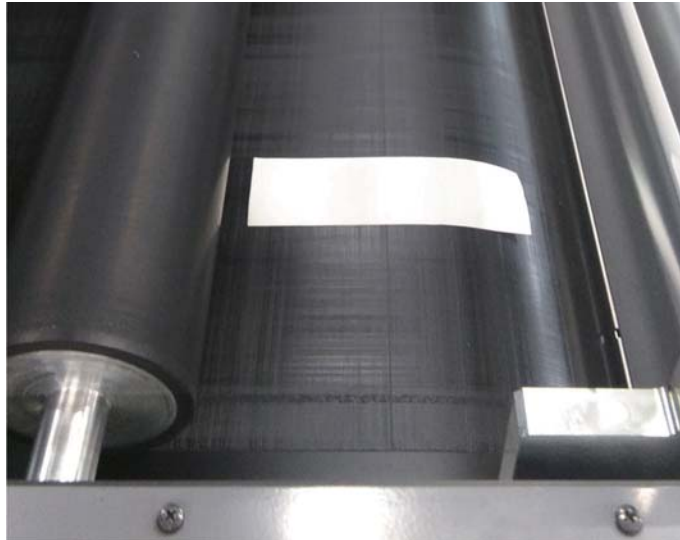
 [“Water droplets remain on the belt after belt cleaning” on page 464](#)

Maintenance

Is the adhesive strength of the glue lower than the standard value?

Below is an explanation on how to measure adhesive strength using a measuring device.

- 1 Cut the fabric into strips of 50 mm × 150 mm.
- 2 Attach the cut fabric strips to the belt so that they are smooth and unwrinkled at the rear of the heated pressure roller.



- 3 Close the rear cover.



Maintenance

- 4 Turn the pressure roller switch to the right.

The heated pressure roller moves forward/backward.



- 5 Go to the front of the machine and press the feed button on the front panel to feed the fabric to the front of the machine.



- 6 Peel off the edges of the fabric strips that were attached to the belt, and attach clips or similar fasteners.

- 7 Pull the clip with a device such as a push pull gauge to measure the adhesive strength.



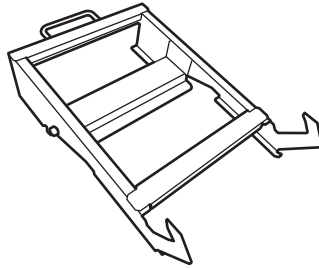
Maintenance

When the measured value is 0.05 to 0.1 N or less, we recommend reapplying the glue. However, this standard value may differ depending on the type of fabric being used, so make your determination based on your environment and fabric.

Removing Glue (When Using the Glue Removal Tool)

Remove the glue that has been applied to the belt.

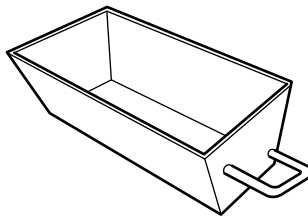
This section describes how to remove glue using the glue removal tool.



Note:

See the following when using the optional glue bucket.

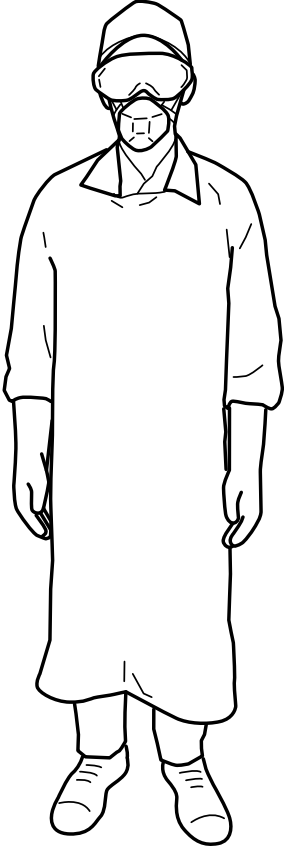
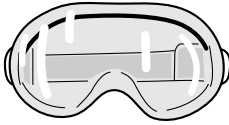
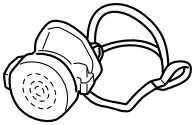

 [“Removing Glue \(When Using the Glue Bucket\)” on page 366](#)

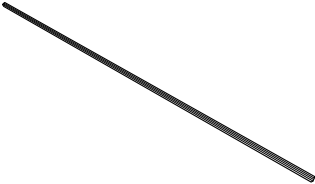
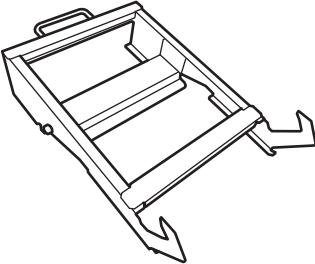


Required Items

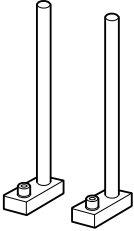
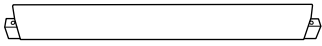
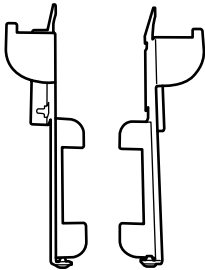
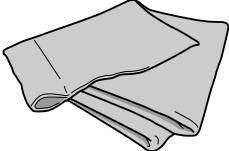
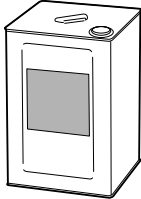

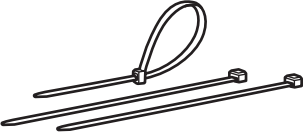
Required number of workers	Min. 2 persons
----------------------------	----------------

Maintenance



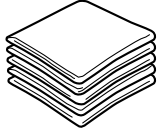

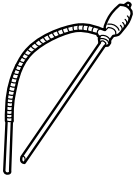

Personal protective equipment	The following is the protective equipment that must be worn when using the glue or glue remover recommended by Epson. For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.	
	Eye protection (For organic solvent use; Optimal is a goggle-type that seals against your face)	
		
	Gas mask (For organic solvent use)	
		
	Protective gloves (Butyl or polyurethane)	
		
Protective clothing (Long-sleeved)		
Hat or hair net (People with long hair must tie their hair and also wear a hair net.)		
Safety shoes		

Required Items	Quantity	Details/Use	
Felt rod 	1	Bundled item	Attach felt and install this in the machine interior for use.
Glue removal tool 	1	Bundled item	Press this against the belt and scrape off the glue.

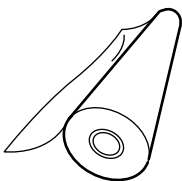
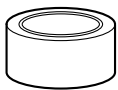
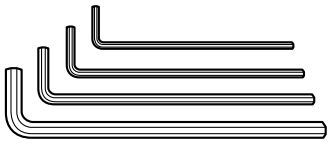
Maintenance

Required Items	Quantity	Details/Use	
Blade supports 	2	Supplied	These parts are used to secure to the belt the felt rod used when applying glue remover to the entire belt, or the blade used when applying glue on the belt. They are secured to both sides of the belt for use.
Blade 	1	Bundled item	Attach to the glue removal tool to remove the glue.
Felt mounting plate 	2	Supplied	Used to attach the felt rod to the printer.
Glue-removal felt 	1	Bundled item / Commercially available 190 cm (74.80 inches) (width) x 45 cm (17.72 inches) (length)	Soak this with glue remover for use.
Glue remover 	5 to 10 L	Recommended product <input type="checkbox"/> Cleanser TS (Murayama Chemical Laboratory) <input type="checkbox"/> ATR1222 (ATR) <input type="checkbox"/> ATR3222 (ATR)	Solvent used when peeling glue from the belt.
Scissors 	1	Commercially available	Used to cut slits in the felt to pass the cable ties through to secure the felt to the felt rod. These are not necessary when making a loop out of the bundled or commercially available felt and sewing it in place.
Cable ties 	5	Commercially available	Used to secure felt to the felt rod with cable ties. These are not necessary when making a loop out of the bundled or commercially available felt and sewing it in place.

Maintenance


Required Items	Quantity	Details/Use	
Ethanol 	0.25 L	Commercially available	Used when wiping stains off the belt surface or jigs.
Bottle (For ethanol) 	1	Commercially available	Container for holding ethanol.
Wipe cloths 	Proper amount	Commercially available	Used when cleaning the belt or equipment. Use cloths of soft non-fluffy material that will not damage the belt.
Bucket for glue remover 	1	Commercially available	Container used when pouring glue remover onto the felt.
Pump 	1	Commercially available	Used when pouring glue remover into the bucket. Use a material that does not dissolve when exposed to organic solvent.
Rubber spatula or plastic spatula 	1	Commercially available	Used when scraping the glue. Use a material that does not dissolve when exposed to organic solvent.
Phillips-head screwdriver	1	Commercially available Size: Ph2	Use to remove parts when cleaning the glue removal tool.
Bag	1	Commercially available Capacity: 15 L or more Size: <input type="checkbox"/> When using a large bag 350 [W] × 200 [D] mm (13.78 [W] × 7.9 [D] inches) or more <input type="checkbox"/> When using a small bag 550 [W] mm (21.65 [W] inches) or more	Use by attaching to the glue removal tool. Use a material that does not dissolve when exposed to organic solvent, such as polyethylene.

Maintenance

Required Items	Quantity	Details/Use	
Plastic sheet 	1	A: 2 m (78.74 inches) (width) x 3 m (118.1 inches) (length) Thickness: 0.15 mm (0.006 inches) or more	Used to protect the product bottom. You can also use plastic bags. Use a material that does not dissolve when exposed to organic solvent, such as polyethylene, and cut them to sizes A and B respectively.
	1	B: 2 m (78.74 inches) (width) x 45 cm (17.72 inches) (length) Thickness: 0.15 mm (0.006 inches) or more	
Protective tape 	Proper amount	Commercially available	Used to protect the product.
Hex key 	1	Commercially available 5 mm (0.2 inches) wide	Used when attaching or removing the felt mounting plate or the exterior panels of this printer.
	2	Commercially available 4 to 6 mm (0.15 to 0.23 inches) wide	Use this part when attaching the blade to the printer.



Warning:

Before starting this procedure, be sure to read the following.  [“Precautions Regarding Maintenance” on page 185](#)



Caution:

Be sure to wear eye protection, respiratory protection, and protective gloves when applying glue.

For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.

Work environment conditions

- Avoid work in high-temperature, high-humidity environments. The glue might not be applied evenly, resulting in water droplets remaining after belt cleaning.
- Work in an environment that is clean and dust-free (meaning dust does not accumulate for 5 to 10 minutes after cleaning).

Maintenance

Note:

The belt rotation speed can be adjusted using the belt speed dial on the front panel.

We recommend setting the belt rotation speed to a somewhat slower speed if this is your first time performing work.



Workflow

1. Enter glue maintenance removal mode

 ["Entering Adhesive Material Maintenance Removal Mode" on page 320](#)

**2. Protect the base of the product**

Cover the product so that glue remover or scraped off glue does not enter under the base of the product.

 ["Product curing" on page 321](#)

**3. Protect the glue removal tool**

 ["Preparing the glue removal tool" on page 333](#)

**4. Attach felt to the felt rod**

 ["Preparing the Felt" on page 336](#)

**5. Attach the felt rod and the blade to the product**

 ["Attaching the felt rod and the blade" on page 338](#)

**6. Ensuring safety**

Perform ventilation and wear protective equipment, referring to the instructions in the SDS for the glue and glue remover you are actually using, as well as the laws and regulations in your country.

Maintenance



7. Remove glue from the belt

 "Removing Glue" on page 344



8. Remove and clean the felt weight and felt rod

 "Belt surface cleaning" on page 354



9. Clean the surface of the belt

 "Belt surface cleaning" on page 354



10. Clean up the work area

Clean the tools used for glue removal and remove the protective tape from the base of the product. If you are going to apply glue after cleaning, do not remove the protective tape from the base of the product.

 "Clean-up" on page 356

You can watch a video of the procedure on YouTube.

https://support.epson.net/p_doc/a63/

Glue removal method

Entering Adhesive Material Maintenance Removal Mode

Switch the printer to maintenance mode.



Important:

Normally, you cannot operate the control panel when any cover is open or the belt cleaning unit is pulled out.

Therefore, if you return to the home screen during glue maintenance operations, you will not be able to return to maintenance mode until you close the front cover or the belt cleaning unit. Make sure you do not touch the panel until you are ready, as it may result in performing curing again, setting the jigs again, or failure of glue maintenance operations.

1

Press the Pause/Restart button on the water recycling unit.

Wait until the Power light flashes and the water recycling unit pauses.

2

From the Maintenance screen on the control panel, touch **Maintenance - Adhesive Material Maintenance**.

Maintenance

3 Enter the Administrator Password.



Important:

- ❑ *Change the default Administrator Password to a new password to ensure that only users who know the Administrator Password can switch to maintenance mode. See the following for details on making changes. The printer and the computer must be connected to the same network when making changes.*

[☞ “How to Set/Change the Administrator User Name/Administrator Password” on page 47](#)

- ❑ *Save the password you set in a safe location so that you do not forget it.*

See the following if you forget your password.

[☞ “If you have forgotten your administrator User Name or Administrator Password” on page 470](#)

4 Touch **Removal Mode - Start**.

When you touch **Forward** or **Reverse** once on the control panel, the belt will continue to rotate until you touch **Suspended**.

Touch **Done** to exit **Removal Mode** and return to the mode selection screen.

Product curing

Cover the product so that glue remover or scraped glue does not enter under the product and cause a malfunction.



Caution:

The belt cleaning unit weighs over 110 kg, so make sure you bend your knees sufficiently and work in a natural position.

Pulling or pushing the unit with incorrect posture can lead to injury and back pain.

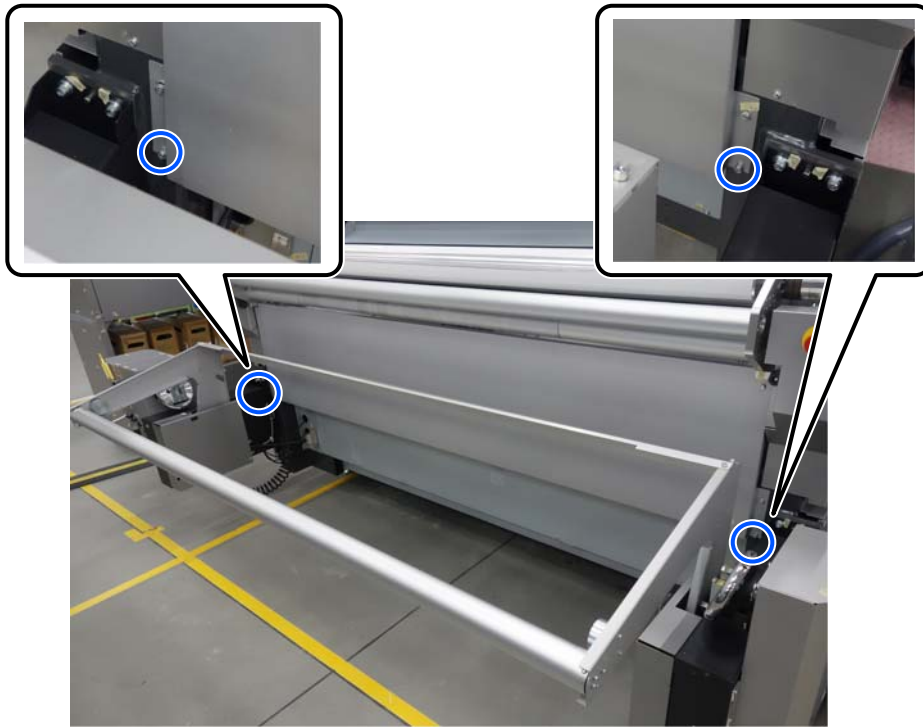
1 Protect the inside of the printer.

Move to the rear of the printer and lower the tension bar.



Maintenance

- 2 Loosen the two bolts at the bottom of the rear exterior panel of the machine using a hex wrench (5 mm in width).



! **Important:**
Steps 3 and 4 should be performed by at least two people.

- 3 While supporting the exterior panel to prevent it from falling, loosen and remove the four bolts at the top of the exterior panel using a hex wrench (5 mm in width).

Keep the removed bolts in a safe location to avoid losing them.



Maintenance

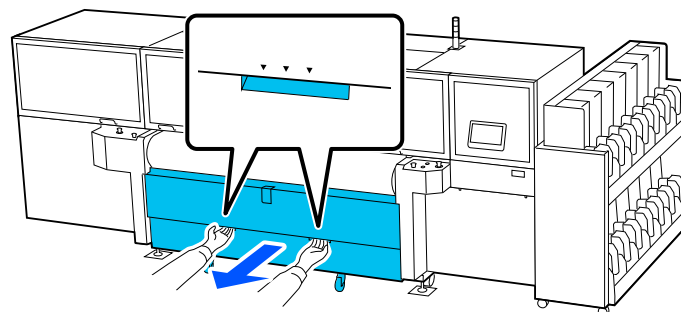
- 4 Lift up the exterior panel and remove it.



- 5 Lift up the tension bar.

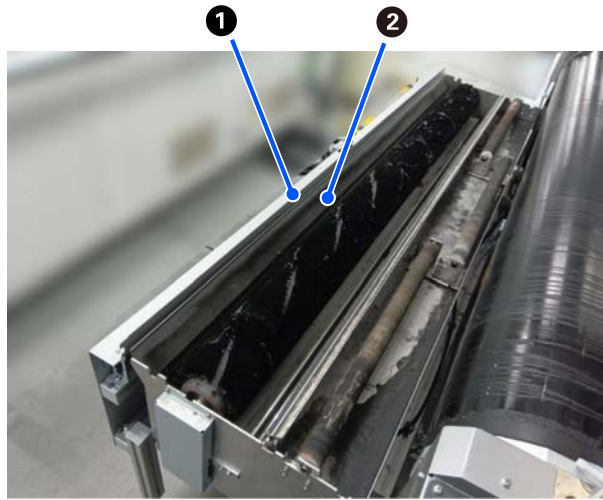


- 6 Move to the front of the machine, hold the handles at the front of the belt cleaning tank, and pull out the belt cleaning tank.



Maintenance

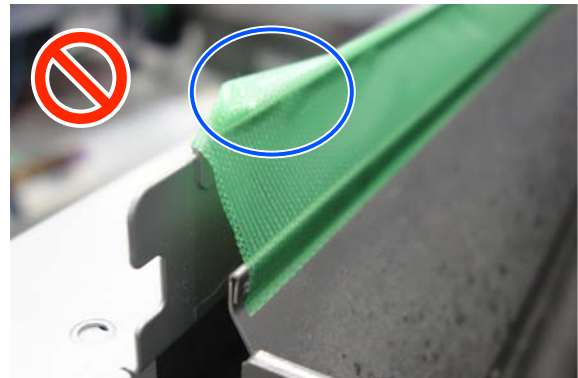
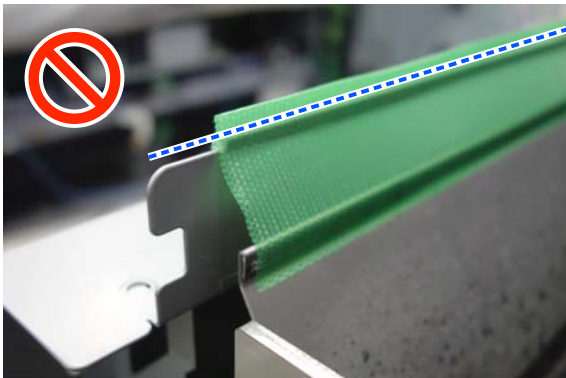
- 7** Wipe away any water droplets from the L-shaped section (①) of the belt cleaning unit cover and the edge (②) of the belt cleaning tank with a wipe cloth.



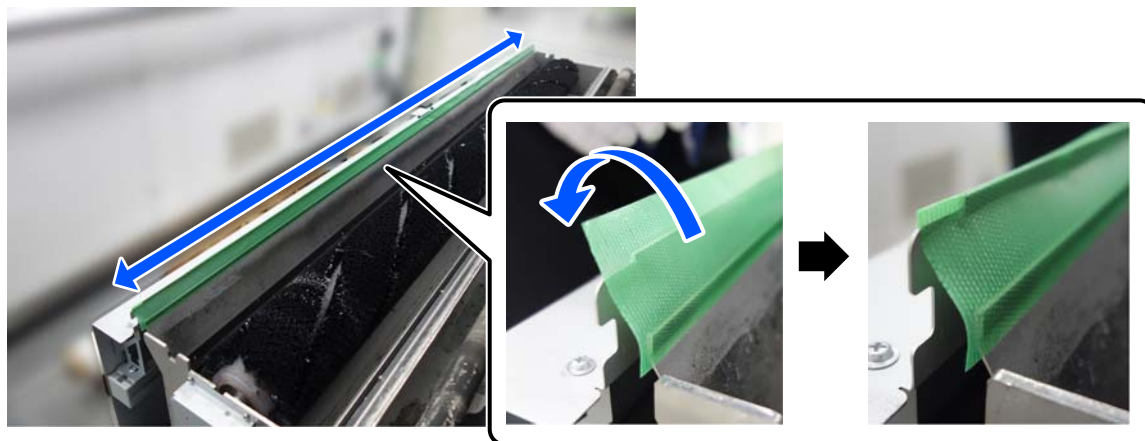
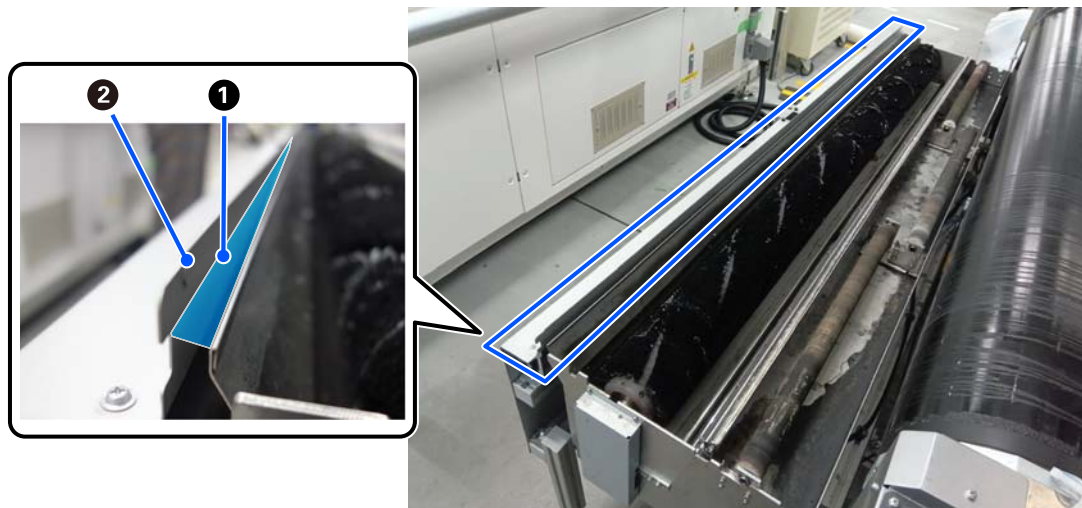
- 8** Attach protective tape from edge to edge on the front of the belt cleaning unit. Attach the tape so that it covers the gap (①) between the belt cleaning tank and the belt cleaning unit cover, as well as the raised part (②) at the front of the belt cleaning unit.

! **Important:**

When attaching the protective tape to the raised part, make sure the tape is firmly stuck down over the edge of the raised part. If the attached protective tape extends beyond the raised part or is not firmly stuck to the raised part, it may stick to or rub against the belt, requiring you to remove and reapply the glue.



Maintenance



- 9 Attach the plastic sheet A to the belt with protective tape in about three places.

! **Important:**
Attach the protective tape with the adhesive side facing up to the back of the plastic sheet and the belt. This makes the plastic sheet less likely to come off when feeding it to the rear.



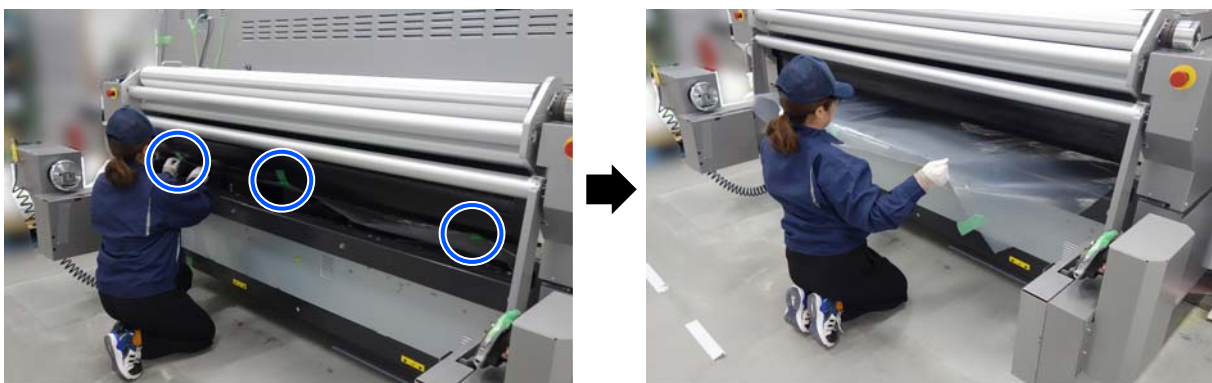
Maintenance



10 Press the backfeed button on the front panel to feed the plastic sheet attached to the belt to the rear.

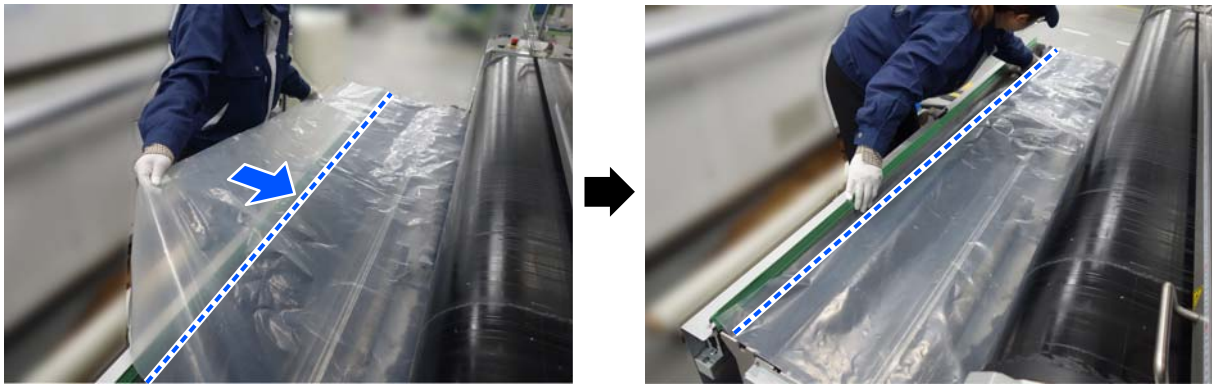
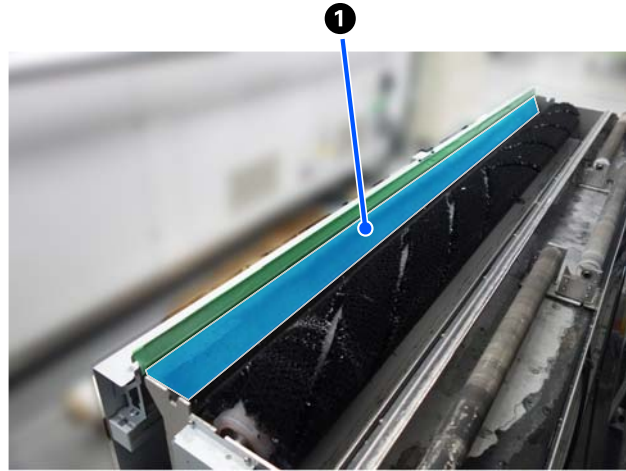


11 Move to the rear of the machine and remove the protective tape and plastic sheet attached to the belt.



Maintenance

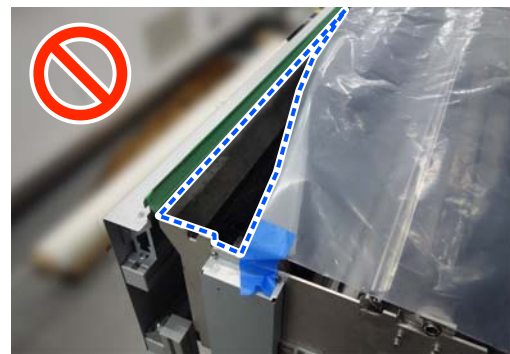
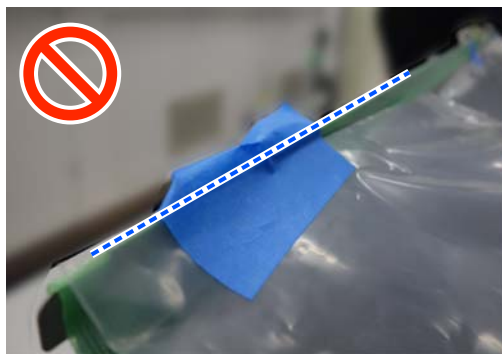
- 12 Align the front edge of the plastic sheet with the edge (1) of the belt cleaning tank.



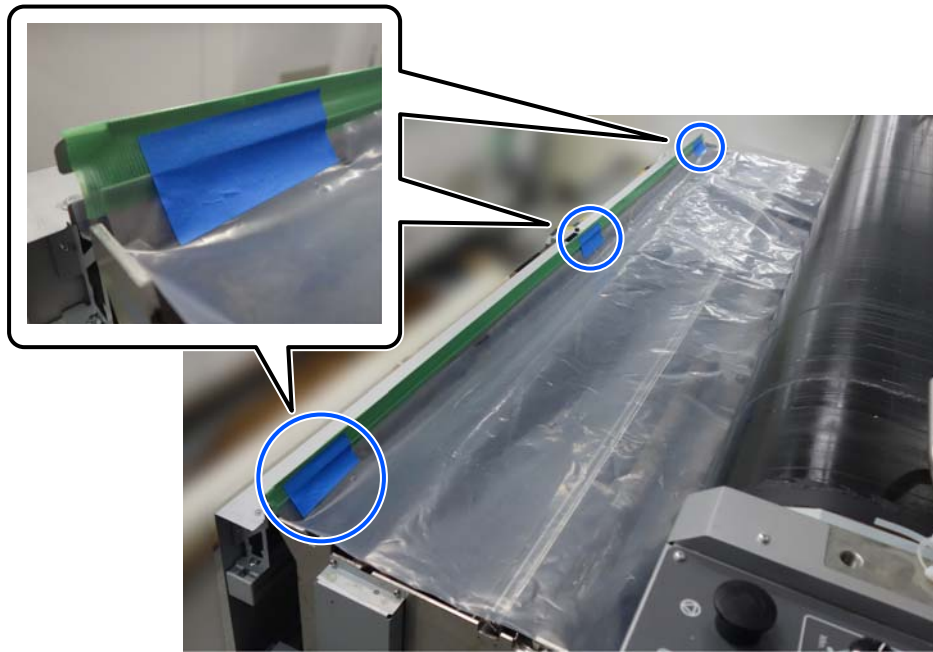
- 13 Smooth out any raised parts or wrinkles in the plastic sheet, and attach the edge of the plastic sheet to the edge of the belt cleaning tank with protective tape in about three places.

! Important:
When attaching the plastic sheet and protective tape, do not leave any gaps or extend beyond the raised parts of the belt cleaning unit.

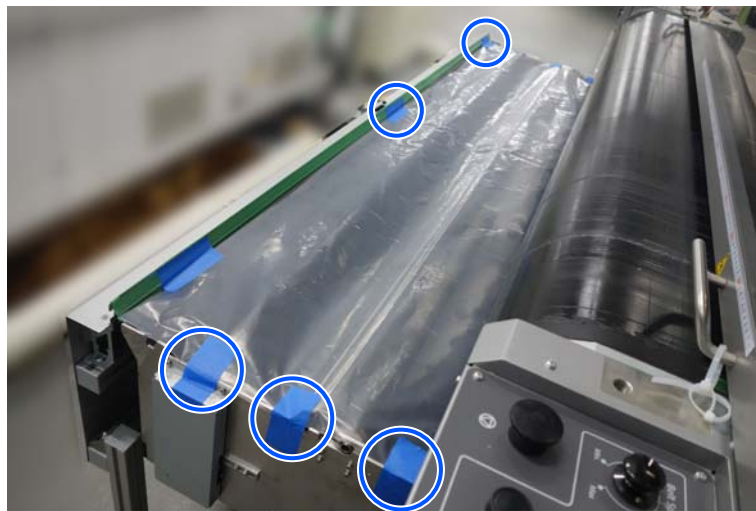
Glue remover or glue may stick to parts inside the belt cleaning unit, or the plastic sheet may stick to the belt, requiring you to remove and reapply the glue.



Maintenance



- 14** Attach both ends of the plastic sheet to the cleaning brushes section on the side of the belt cleaning tank, the washing scraper section, and the rear of the cleaning tank with protective tape.

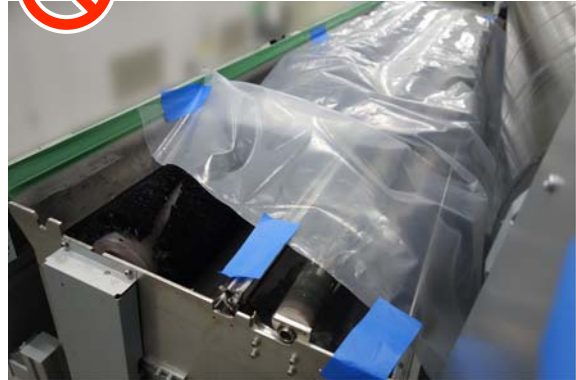
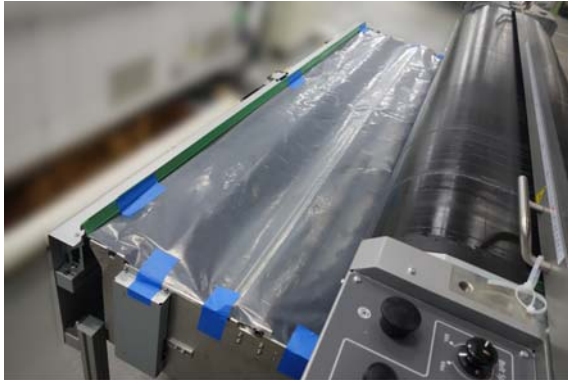


Maintenance

- 15** Check that there are no raised parts, wrinkles, or gaps in the plastic sheet covering the belt cleaning unit.

If there are any raised parts, wrinkles, or gaps in the plastic sheet, smooth out the wrinkles and raised parts and reapply the protective tape to ensure no gaps remain.

OK



- 16** Push the belt cleaning unit back to its original position.



Maintenance

- 17** Move to the rear of the machine and check that the plastic sheet is not stuck to the belt.
Peel off the plastic sheet if it is stuck to the belt.



- 18** Align the edge of the plastic sheet with the lower frame (1) of the machine. Place the excess parts of the plastic sheet inside the machine and allow the plastic sheet to sag.



Maintenance

- 19** Attach the edge of the plastic sheet to the lower frame of the machine with protective tape in about three places.



- 20** Attach both ends of the plastic sheet to the upper frame (1) of the machine with protective tape.



- 21** Protect the belt cleaning unit cover.

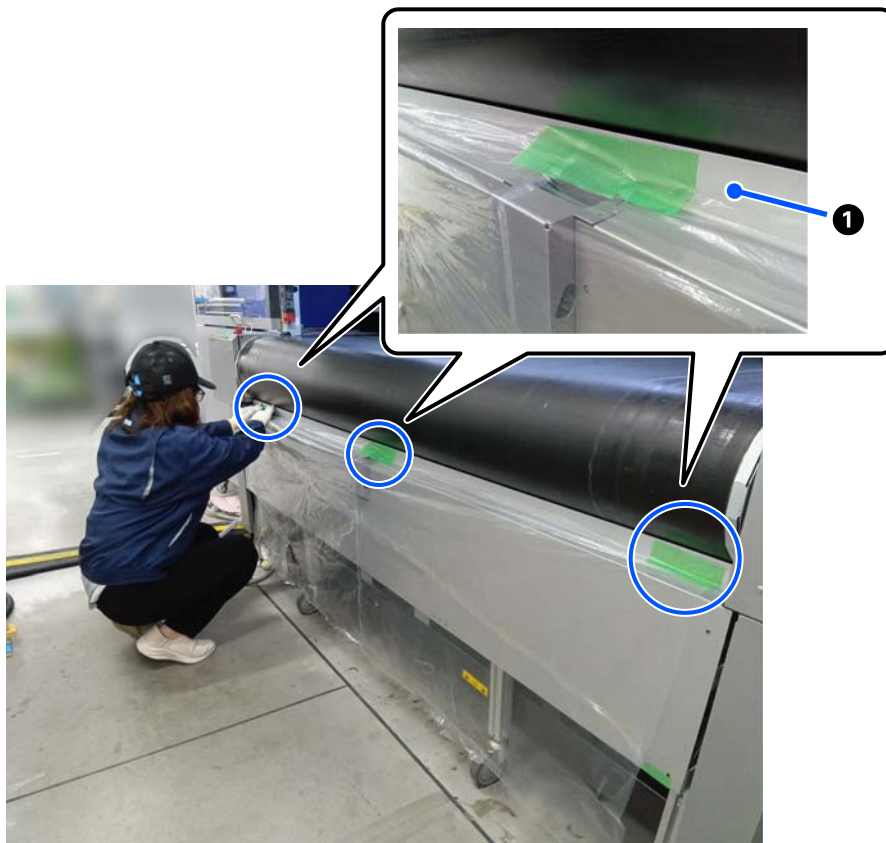
Move to the front of the machine and attach the edge of the plastic sheet B to the L-shaped corner (1) of the raised part of the belt cleaning unit cover with protective tape in about three places.

Maintenance



Important:

Attach the plastic sheet so that it covers the tangled fabric detection sensor (②), and the plastic sheet and protective tape do not extend beyond the raised part (③) of the belt cleaning unit cover. Otherwise, the sensor may malfunction, or the plastic sheet may stick to the belt, requiring you to remove and reapply the glue.



Maintenance

- 22 Attach the bottom edge of the plastic sheet to both ends of the lower part of the belt cleaning unit cover with protective tape.



Preparing the glue removal tool

- 1 Wipe both sides of the glue removal tool blade with an ethanol-soaked wipe cloth.
If the dirt cannot be removed, soak a wipe cloth in glue remover to wipe it off.
Dispose of the used wipe cloths in the proper manner for industrial waste.

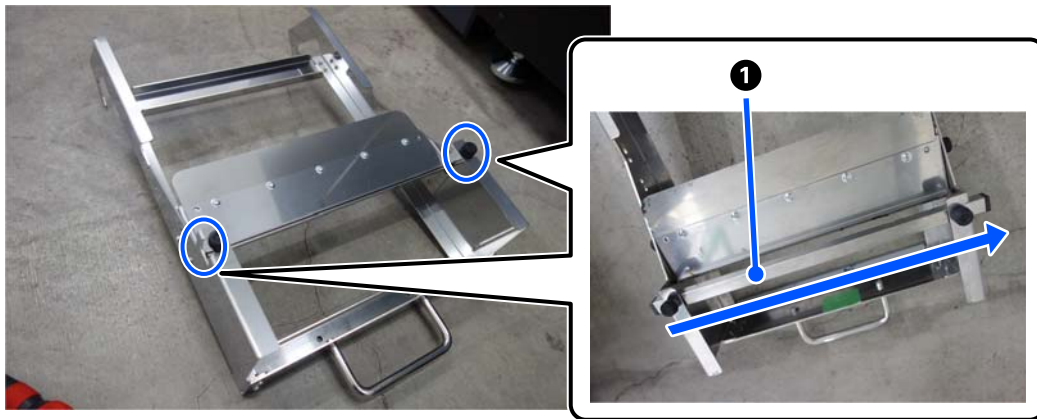


Maintenance

- 2** Loosely attach the two screws to the glue removal tool by hand.



- 3** Pass the bar through the holes in the glue removal tool.



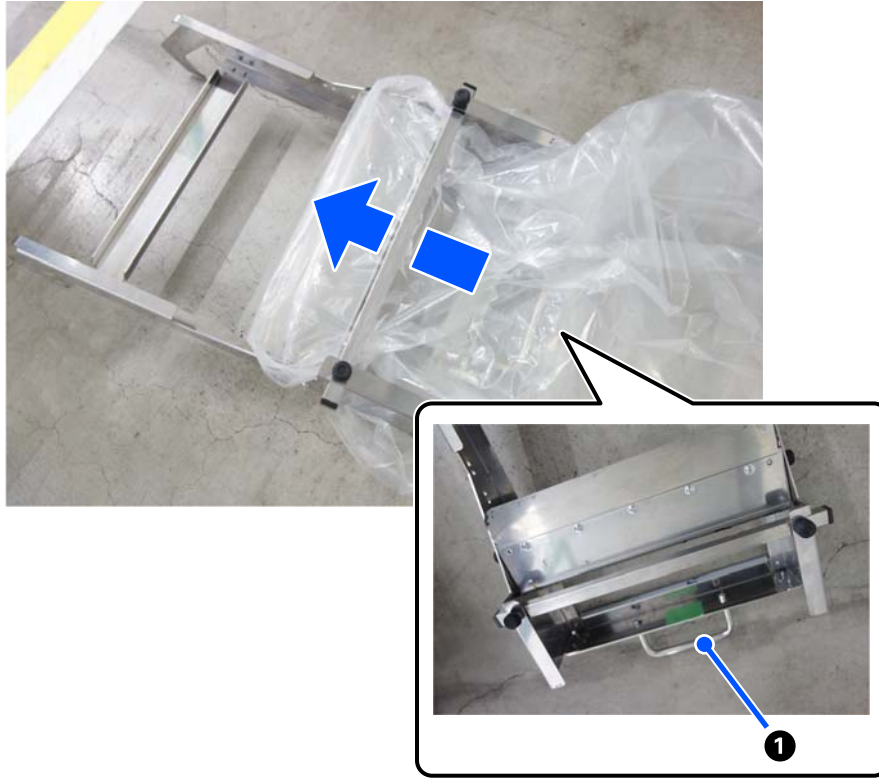
1 Bar

- 4** Tighten the two screws so that they are not loose.



Maintenance

- 5** Pull one side of the bag from the handle side of the glue removal tool and under the bar.
Pull out enough to cover the bar of the glue removal tool.



1 Handle

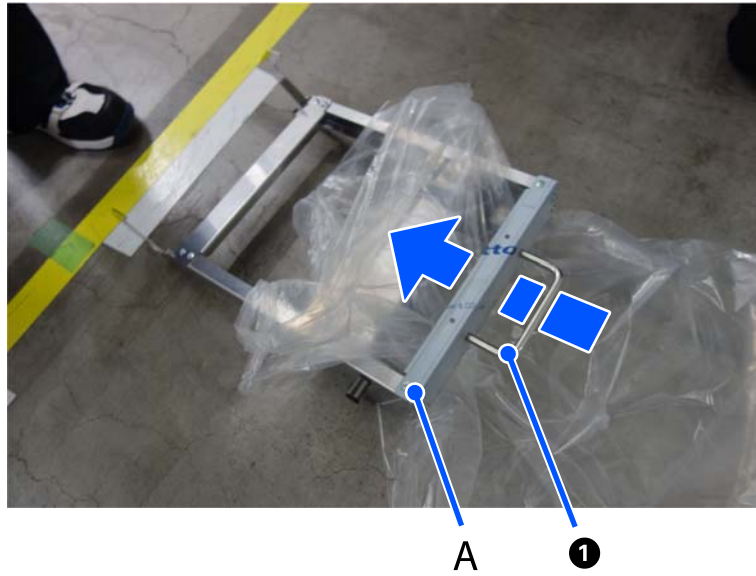
- 6** Cover the bar with the pulled-out bag and secure it to the glue removal tool in about three places with protective tape.



After attaching the tape, turn over the glue removal tool.

- 7** Pull the unsecured side of the bag from the handle side of the glue removal tool and under A.
Pull out enough to cover the handle and sides of the glue removal tool.

Maintenance

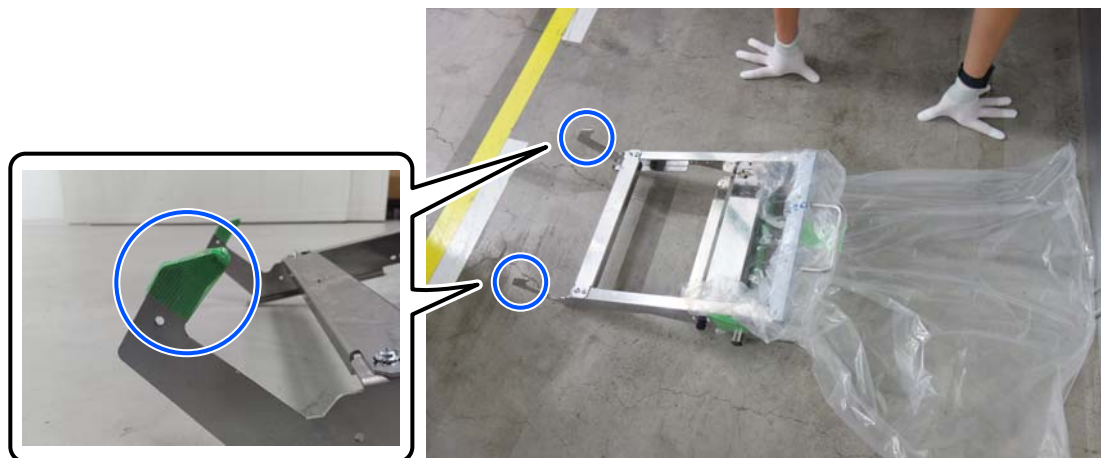


1 Handle

8 Cover the handle and sides of the glue removal tool with the pulled-out bag, and secure it to the glue removal tool in about three places with protective tape.



9 Cover the tips of the hooks of the glue removal tool with protective tape.



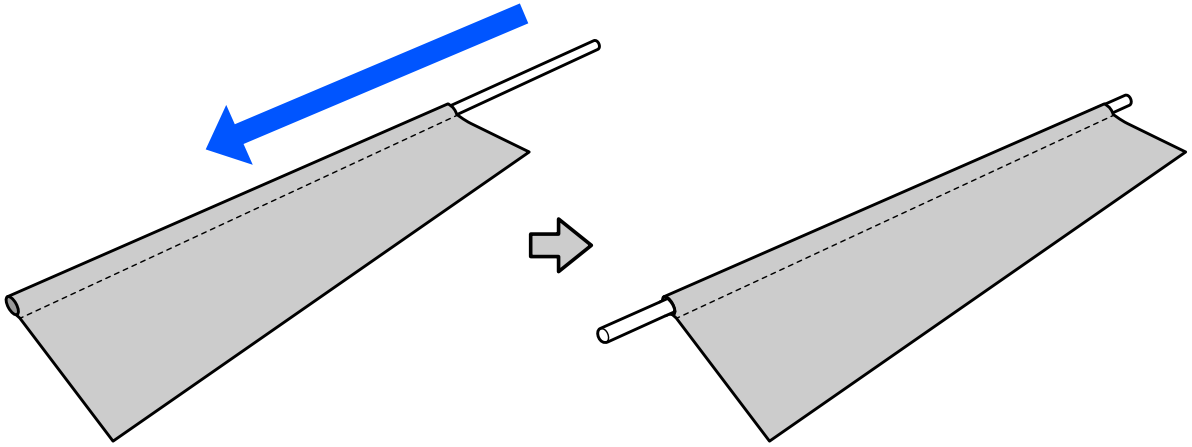
Preparing the Felt

Prepare some felt to soak up the glue remover.

Maintenance

When using the felt that comes with the machine

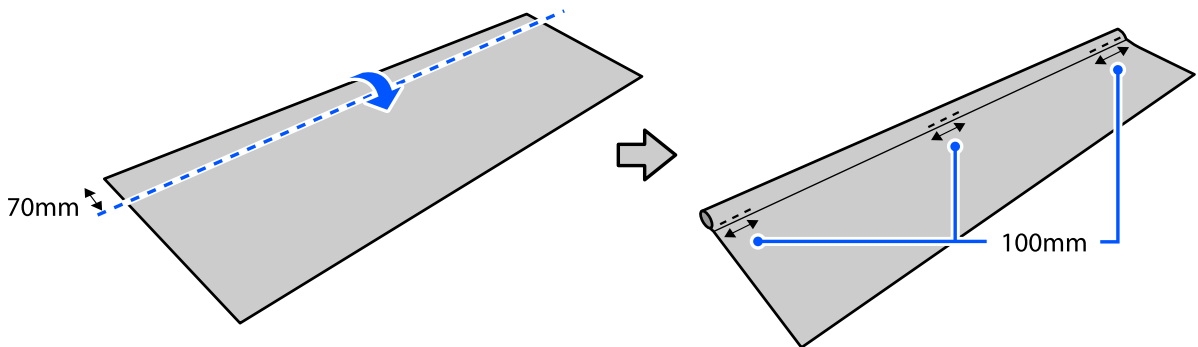
- 1** Put the felt rod through the glue-removal felt.



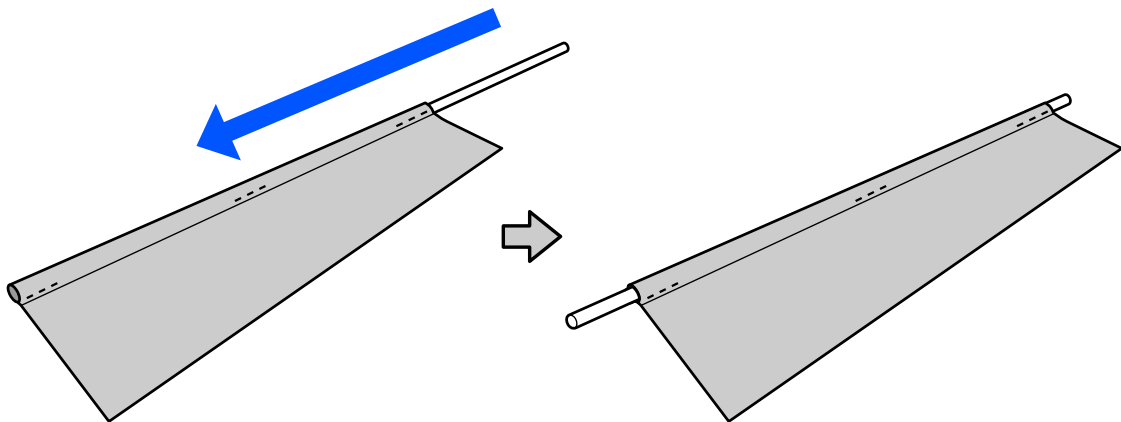
When using commercially available felt

Make a loop out of the felt and sew it in place

- 1** As shown in the figure, fold the felt so that it is approximately 70 mm wide, and then sew three points (the left, right, and center) of approximately 100 mm to form a loop.



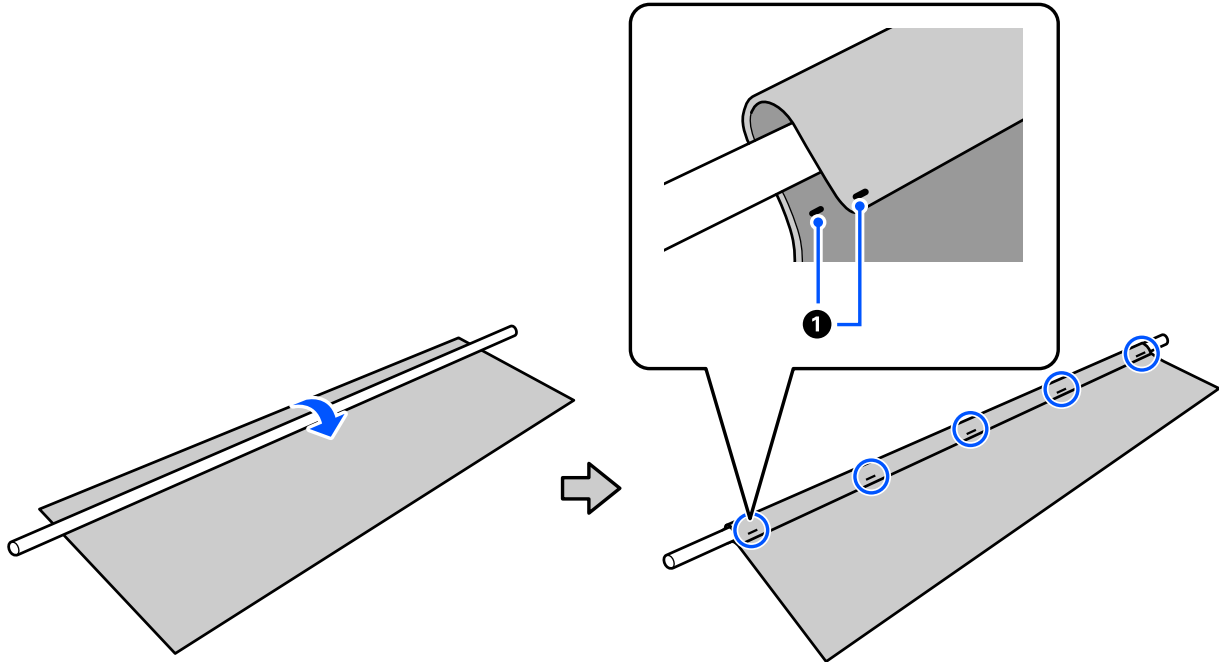
- 2** Put the felt rod through the felt.



Maintenance

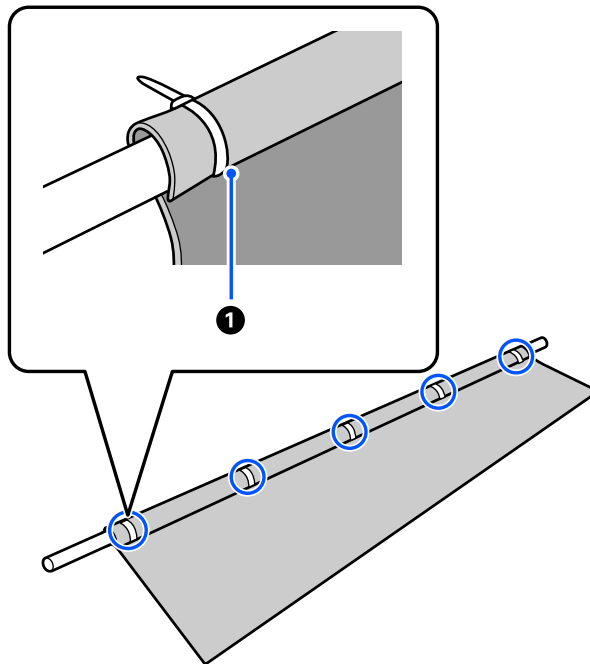
Use cable ties to secure it in place

- 1 Hang the felt over the felt rod, and then use scissors to cut five slits in the felt large enough to pass the cable ties through.



- 1 Slits

- 2 Attach the felt to the felt rod by passing five cable ties through the slits in the felt you made in step 1.



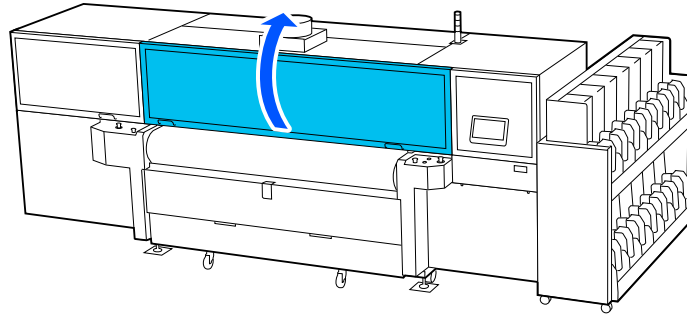
- 1 Cable ties

Attaching the felt rod and the blade

Attach the felt rod and the blade to the product.

Maintenance

- 1 Open the front cover.



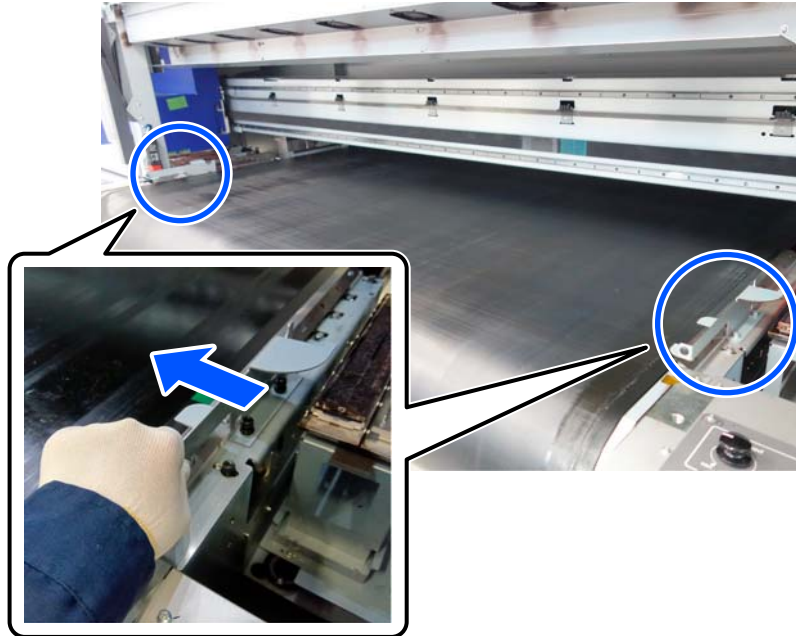
- 2 Loosely install the bolts in the bolt holes shown in the illustration with a hex wrench (5 mm width).
Loosen the bolts while they are still fixed in place.



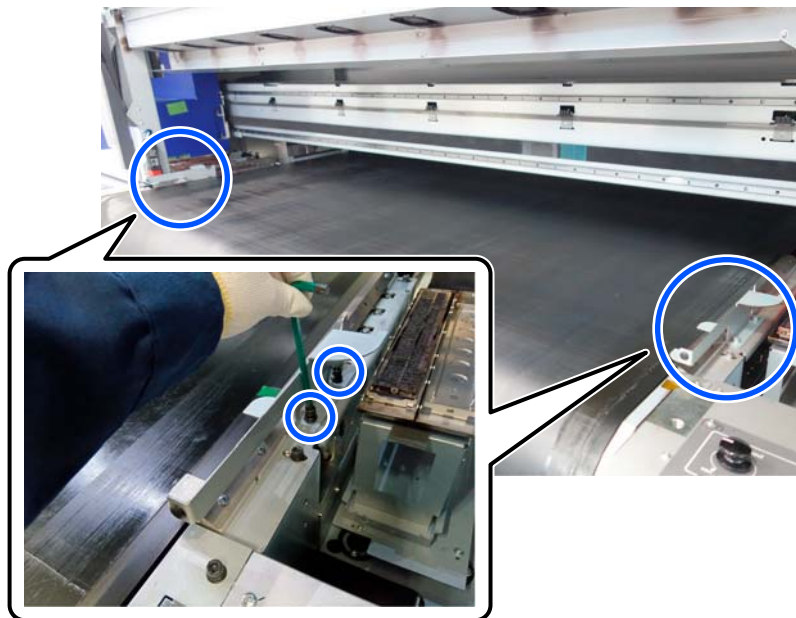
Maintenance

3 Install the felt mounting plate.

Insert the groove of the felt mounting plate into the gap between the bolts and the machine from the outside.



4 Tighten the bolts with a hex wrench (5 mm in width).



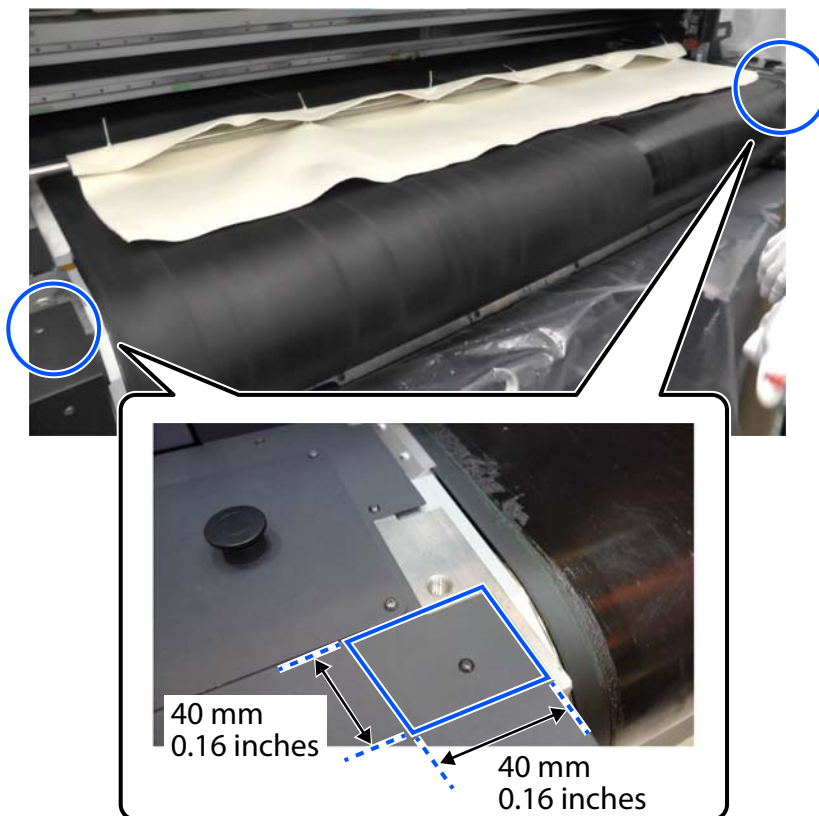
Maintenance

- 5** Set the felt mounting rod on the felt mounting plate and spread the felt to the front side of the product.



- 6** Attach protective tape cut into strips of approximately 40 × 40 mm to the area next to the belt as shown in the figure.

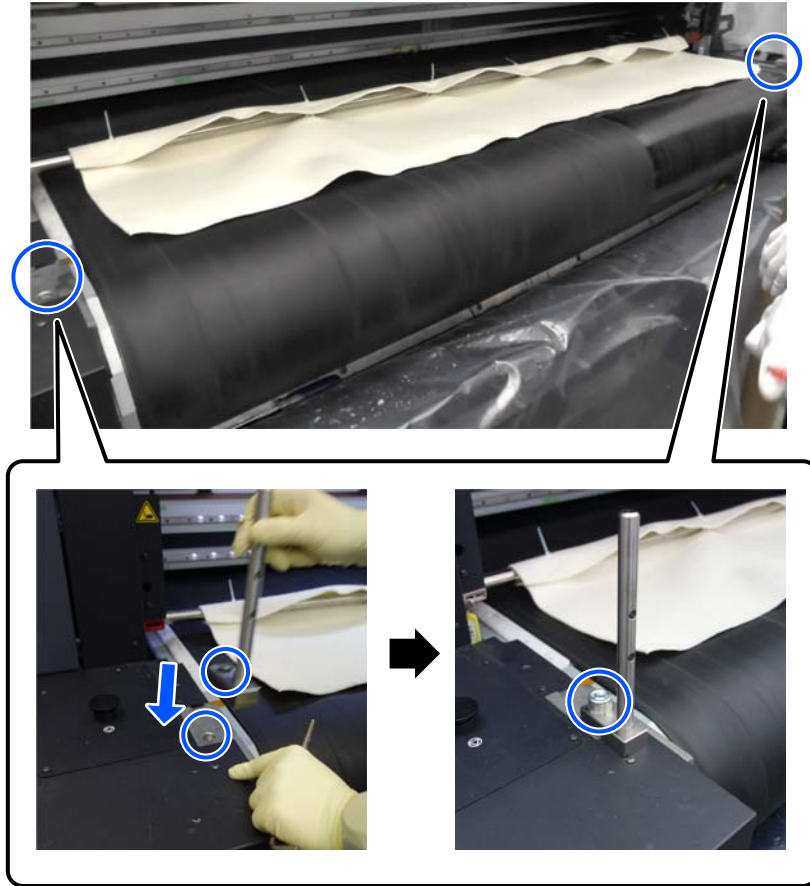
This prevents the product from being damaged when the blade supports are attached.



Maintenance

- 7 Align the screw holes on the blade support with the screw holes on the side of the belt so that the support is at the front and the screw holes are at the back. Loosely secure the blade supports with hexagonal screws.

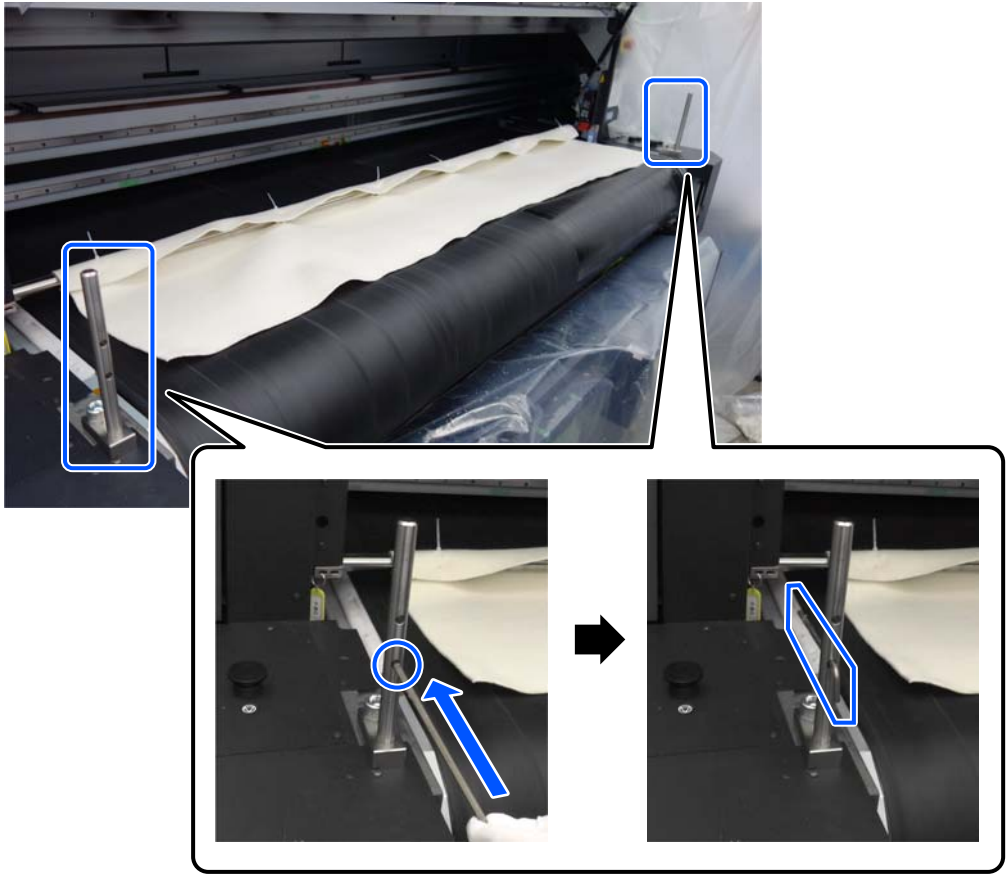
Attach the blade support on the opposite side of the belt as well, in the same way.



Maintenance

8

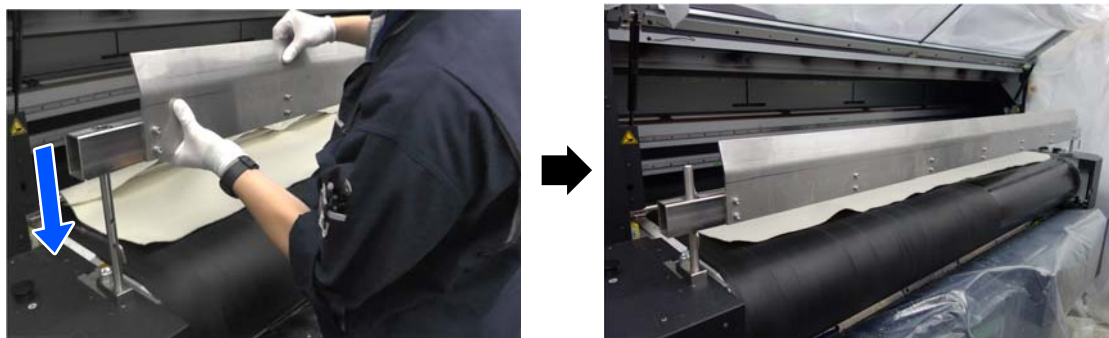
Insert a hex key of the same size through both of the bottom holes in the blade supports on either side.



9

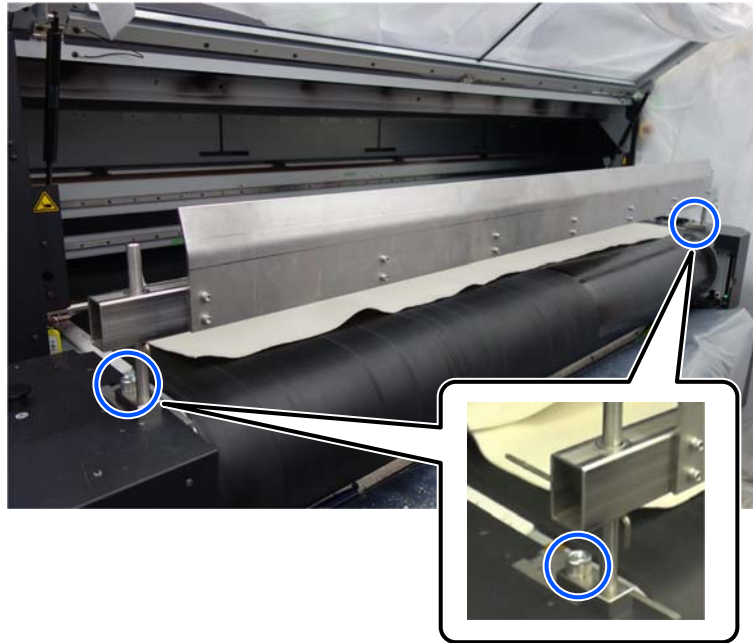
Have two people lift up the blade with the blade facing up, and pass the blade supports through the holes on either end of the blade.

Lower the blade slowly and evenly on both sides.



Maintenance

- 10** Firmly tighten the hexagonal screws of both blade supports by hand.



Ensuring safety

Perform ventilation and wear protective equipment, referring to the instructions of the SDS for the glue and glue remover you are actually using, as well as the laws and regulations in your country.

Removing Glue

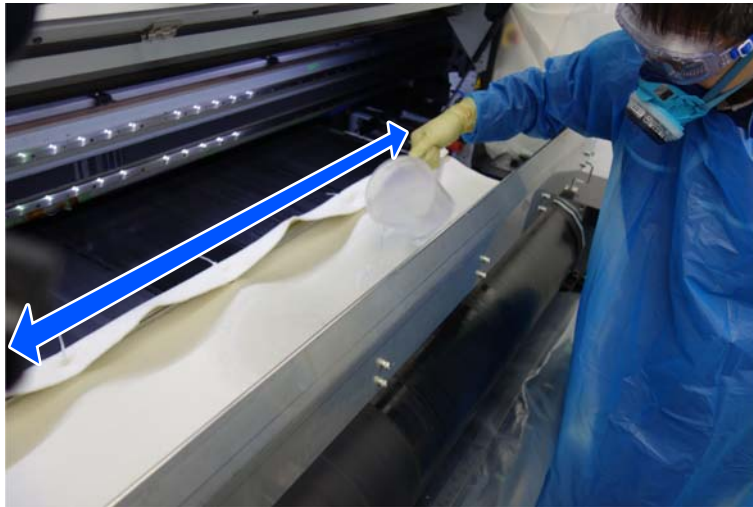
Use the glue remover and scrape the glue off the belt.

- 1** Touch the **Forward** button on the control panel.
The belt continues to move forward.
- 2** Place the glue remover bucket on the tray and put in approximately 2 L (67.63 ounces) of glue remover.
Use the pump to ensure the glue does not spill on the surroundings.

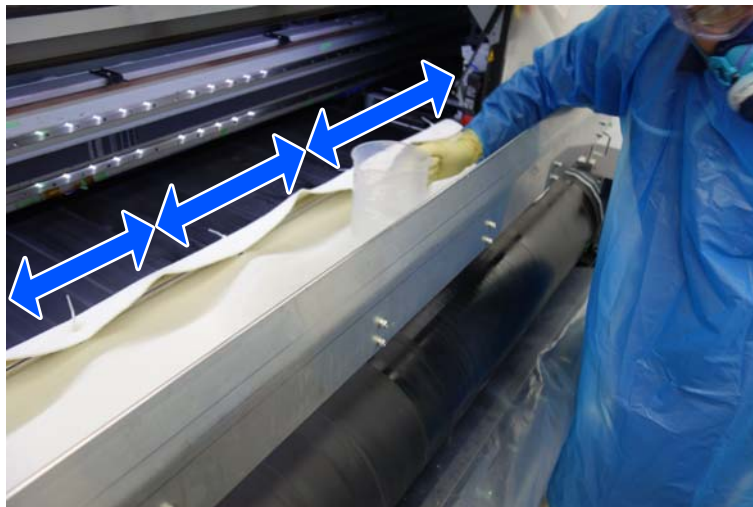


Maintenance

- 3 Soak the felt in glue remover.
Be careful that the glue remover does not leak from each side of the belt.

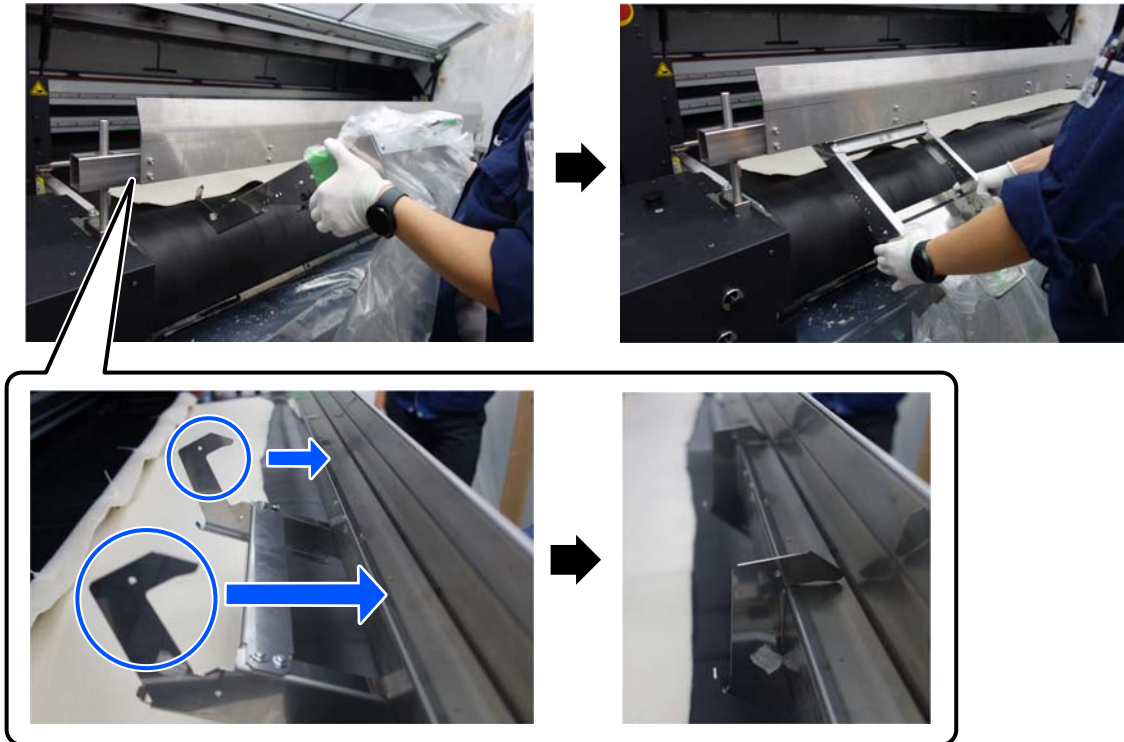


- 4 Ensure that the glue remover is uniformly spread throughout the felt.
After about 5 minutes, the glue on the belt surface begins to dissolve.
If the felt is floating up and is not in contact with the belt, put on a glove or use a similar tool to push down the felt.



Maintenance

- 5** Hold the glue removal tool with the tips of the hooks facing toward you, pass them under the blade and hook them over the back of the blade.

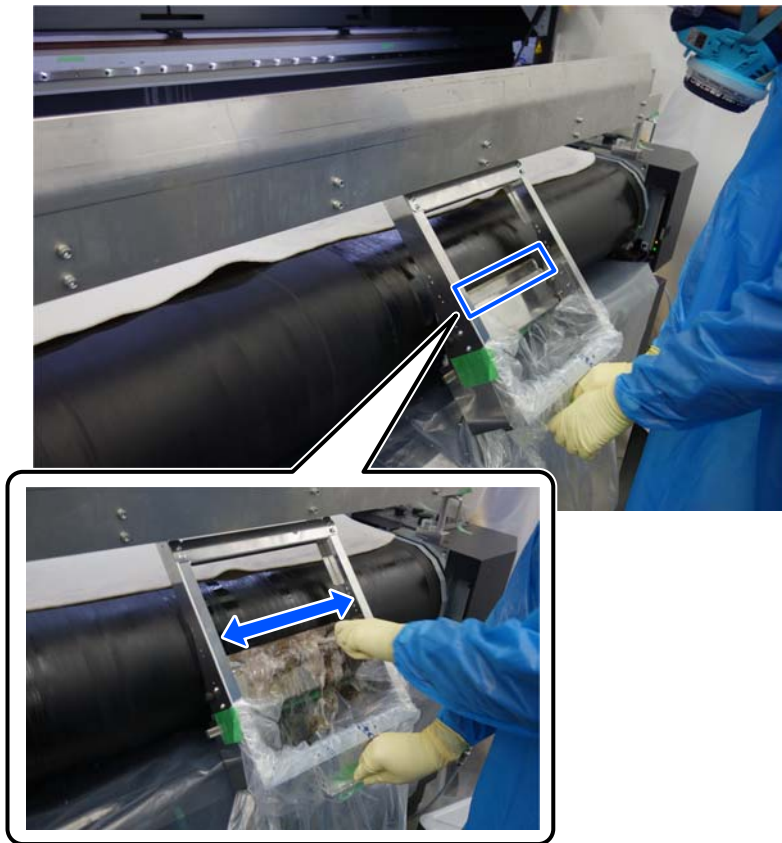


- 6** Worker 1: Hold the handle of the glue removal tool firmly with both hands, and then scrape off the glue by pressing the blade of the glue removal tool against the surface of the belt so that the blade deforms a little under the pressure. Use a scraper or similar tool to scrape off glue adhering to the blade of the glue removal tool into the vinyl bag attached to the glue removal tool.
 Worker 2: When the glue remover on the surface of the belt has dried, soak the entire surface of the felt with more glue remover.

**Important:**

Do not press the glue removal tool too hard against the belt. Doing so may damage the belt.

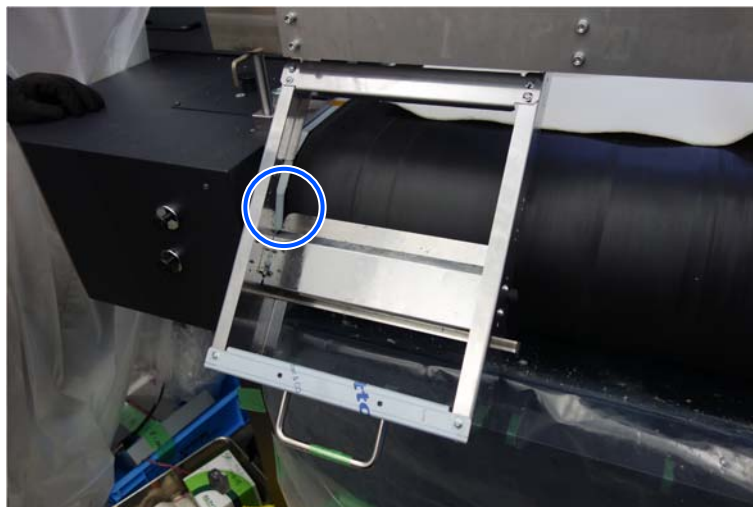
Maintenance



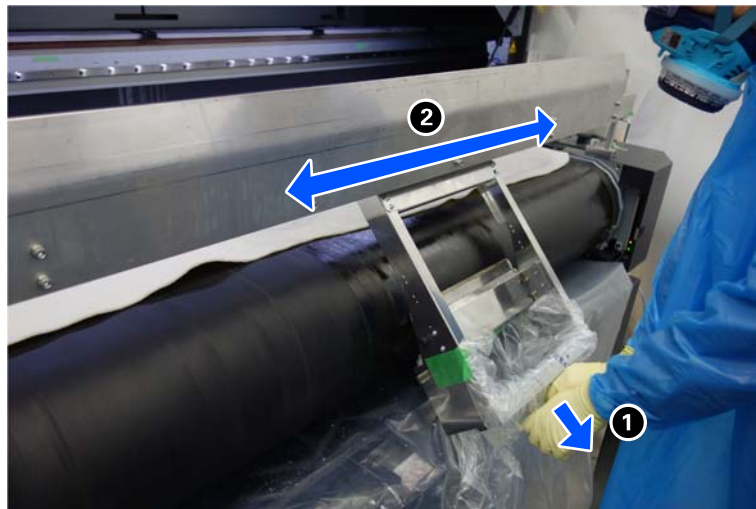
- 7** Worker 1: When the glue has been removed and cannot be scraped off any further, lift the glue removal tool while keeping the hooks hooked over the blade. Pull the glue removal tool toward you to move it to an area where the glue has not been scraped off, and then continue in this way to scrape off the glue from the rest of the belt. Worker 2: While checking the scraping conditions, continue pouring an appropriate amount of remover onto the felt.

! **Important:**

Glue tends to remain on the belt edges, so focus on peeling those areas.

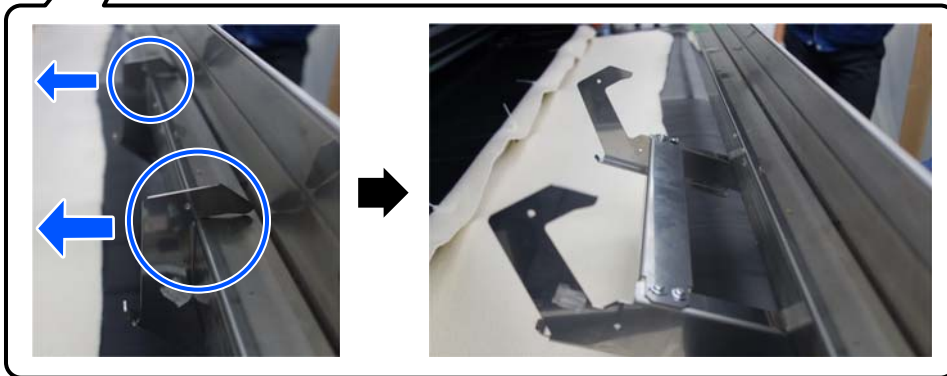
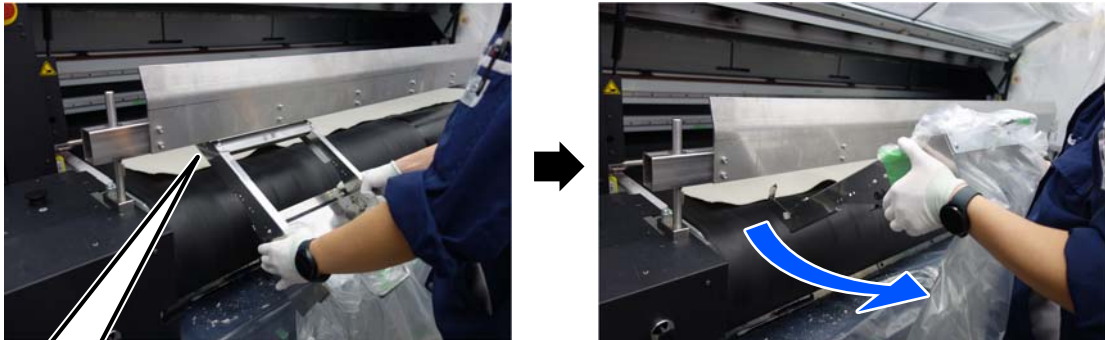


Maintenance



8

Once glue has been scraped off the entire belt, remove the glue removal tool from the blade.



9

Touch the **Suspended** button on the control panel.

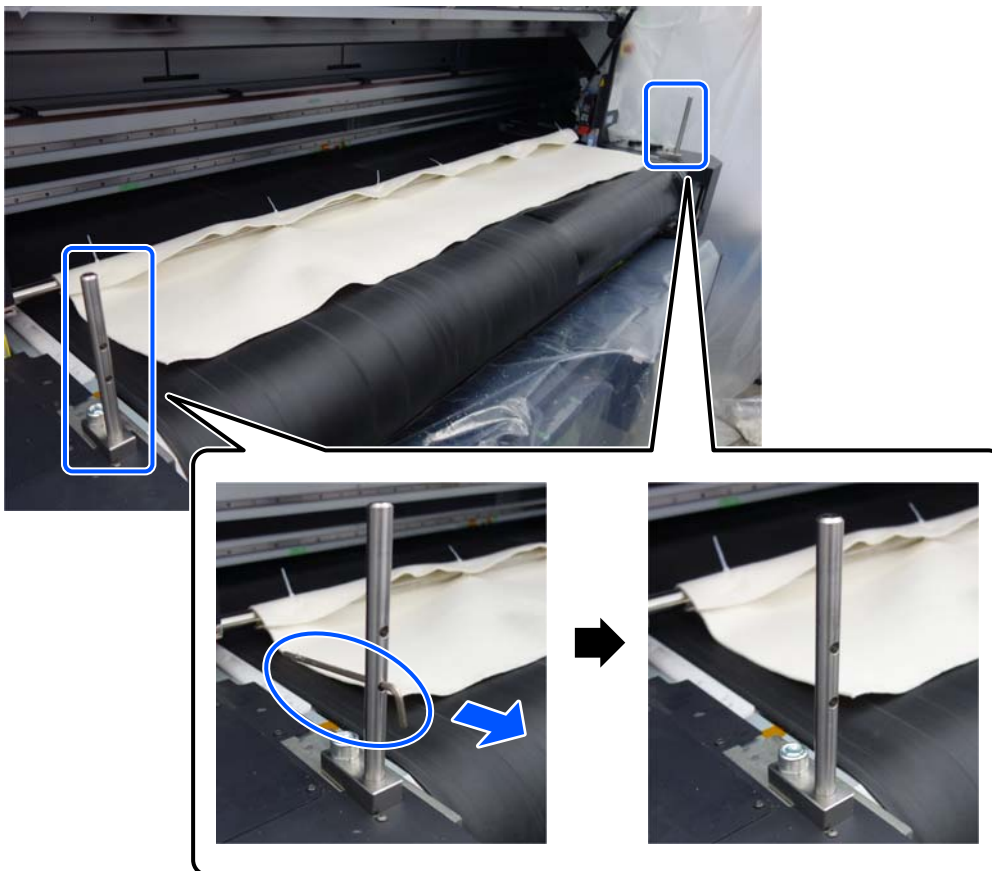
The belt will stop rotating.

Maintenance

- 10 Two people are required to lift the blade on both sides simultaneously and remove it.

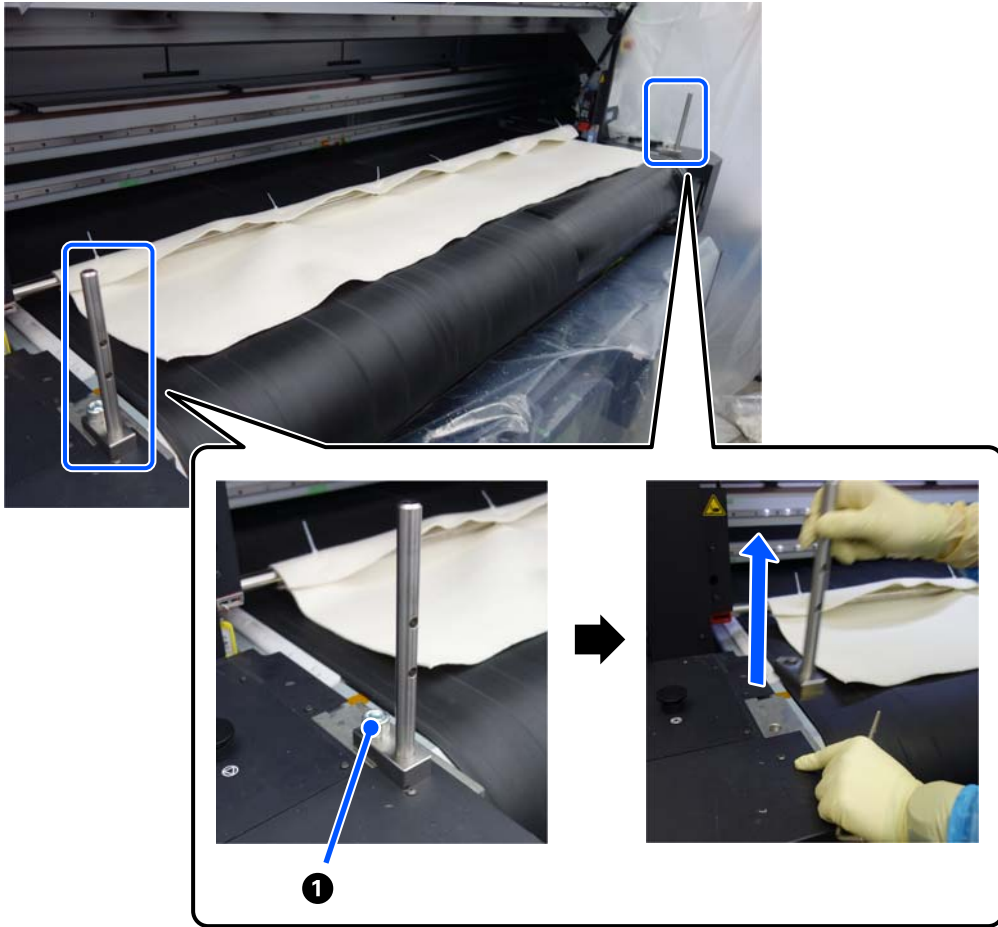


- 11 Remove the hex keys from the holes in the blade supports on either side.



Maintenance

- 12** Loosen the hexagonal screws on both blade supports and remove them from either side of the belt.



1 Hexagonal screws

Maintenance

- 13** Remove the felt rod.

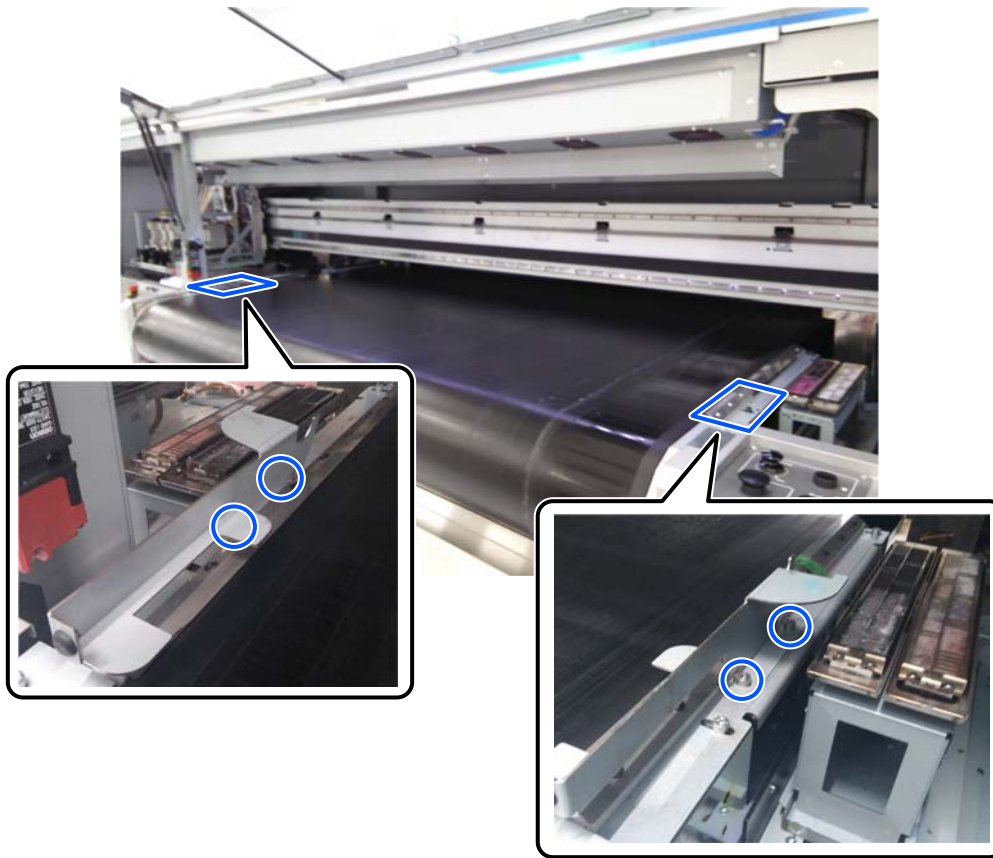


- 14** Remove the felt from the felt rod.
Dispose of the felt in the proper manner for industrial waste.

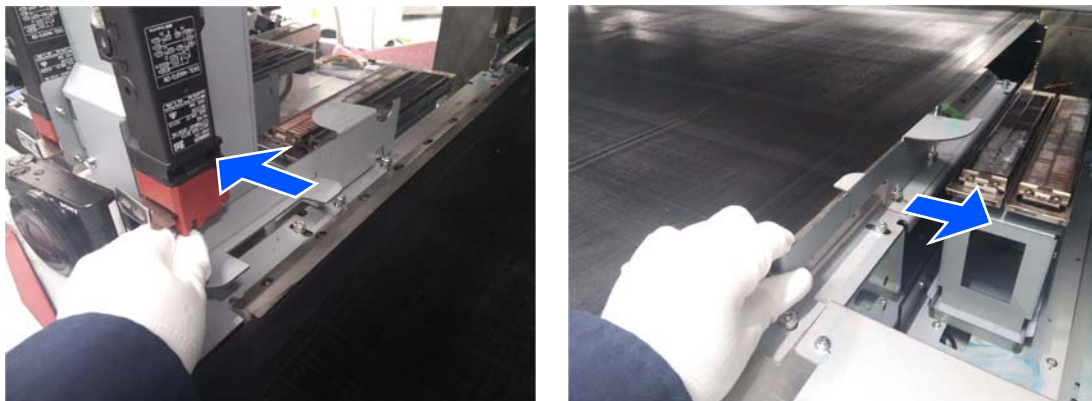


Maintenance

- 15 Loosen the bolts on the felt mounting plate with a hex wrench (5 mm in width).



- 16 Remove the felt mounting plate.

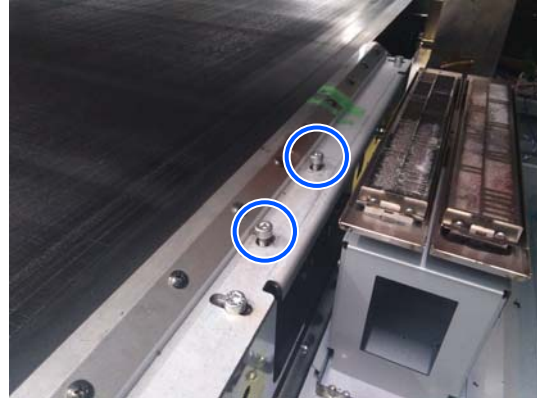


Important:

If printing is started with the felt mounting plate still attached, it may come into contact with the print head, which may cause the print head to malfunction. Be sure to remove the felt mounting plate.

Maintenance

- 17 Tighten the bolts with a hex wrench (5 mm in width).



- 18 If any glue remover got on the rod, wipe it clean using an ethanol-soaked wipe cloth. If the dirt cannot be removed, soak a wipe cloth in glue remover to wipe it off. Dispose of the used wipe cloths in the proper manner for industrial waste.

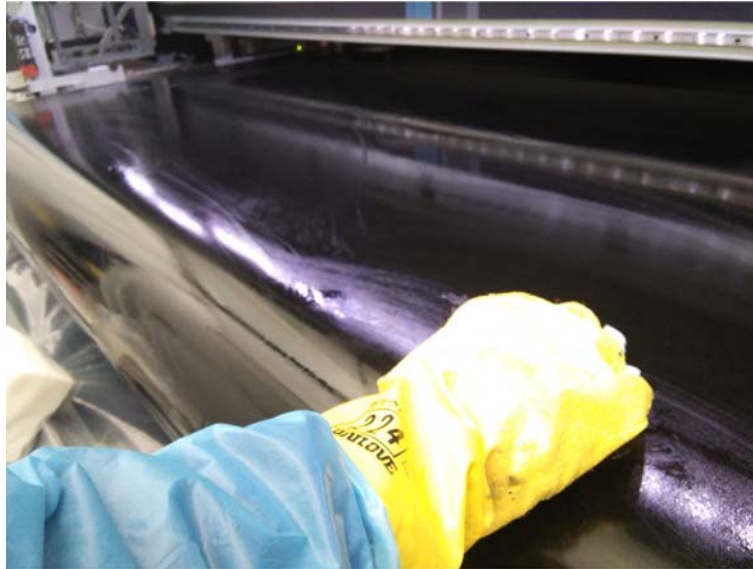


- 19 Touch **Forward** or **Reverse** on the control panel.
The belt continues to rotate.

Maintenance

- 20** Check the belt surface for any glue residue.

If glue remains, soak the felt with glue remover and wipe it off.



- 21** Touch the **Suspended - Done** buttons on the control panel in that order, and stop the rotation of the belt.

If you apply glue at this stage, do not return to the home screen, and leave the mode selection screen as it is. Step 22 is not required. Start by cleaning the belt surface.

- 22** Press the Pause/Restart button on the water recycling unit.

The water recycling unit starts operating again, and the cleaning water flows into it.

Belt surface cleaning

Clean the surface of the belt once.

- 1** Press the feed or backfeed button on the front panel to rotate the belt.

- 2** Wipe off the glue until the belt surface has a luster.

When the wipe cloth is dirty or glue chips occur, it means glue remains on the belt.

Dispose of used wipe cloths and glue chips according to the laws and regulations in your country.



Important:

Glue tends to remain on the belt edges, so focus on peeling those areas. If glue or other such material is stuck to the edge of the belt, it may not be possible to measure the normal belt feed rate.

Maintenance



Maintenance



Clean-up

Clean up the tools you used.

If you apply glue at this stage, you do not need to perform steps 17 and on to remove the curing.



Caution:

The belt cleaning unit weighs over 110 kg, so make sure you bend your knees sufficiently and work in a natural position.

Pulling or pushing the unit with incorrect posture can lead to injury and back pain.

1

Remove the bag and protective tape that was secured to the glue removal tool.

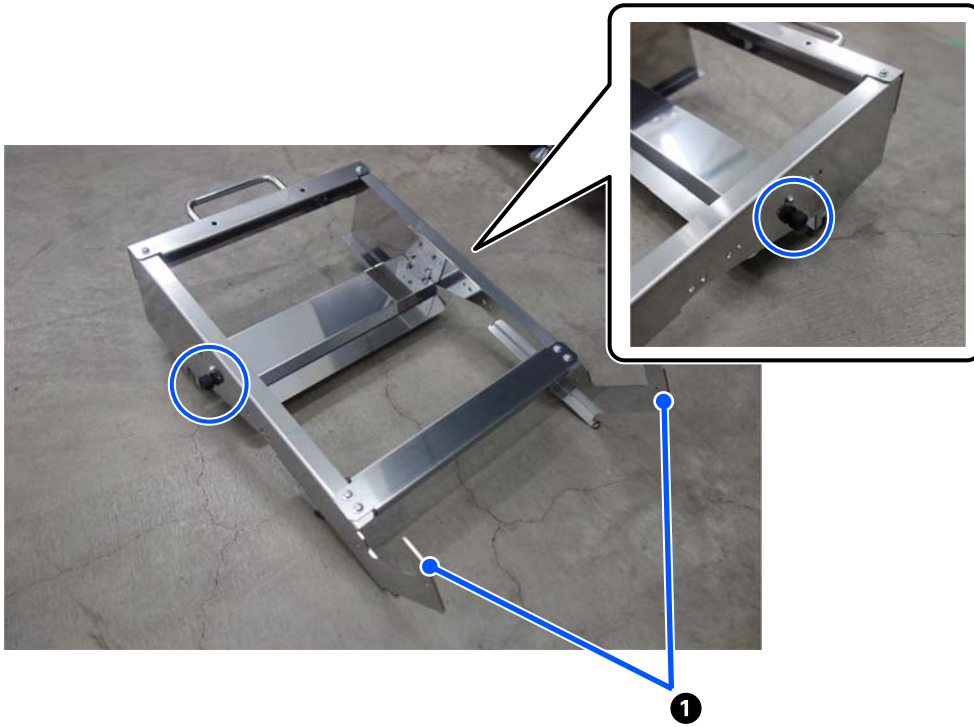
Dispose of the removed bag and protective tape in the proper manner for industrial waste.

2

Remove the protective tape that was attached to the tips of the hooks of the glue removal tool.

Maintenance

- 3 Place the glue removal tool so that the tips of the hooks are facing up, and then loosen and remove the two screws on both sides by hand.



① Hooks

- 4 Slide plate A toward the hooks and remove it.



- 5 Wipe off the glue remover from both sides of plate A with an ethanol-soaked wipe cloth.

If the dirt cannot be removed, soak a wipe cloth in glue remover to wipe it off.

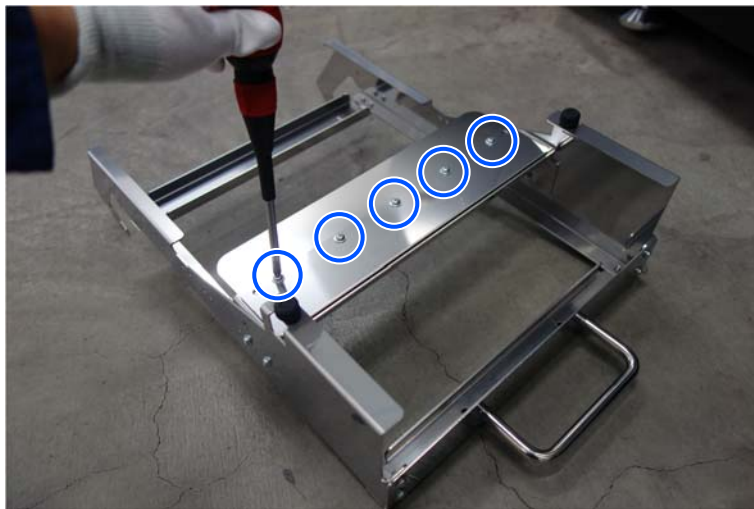
Dispose of the used wipe cloths in the proper manner for industrial waste.

Maintenance

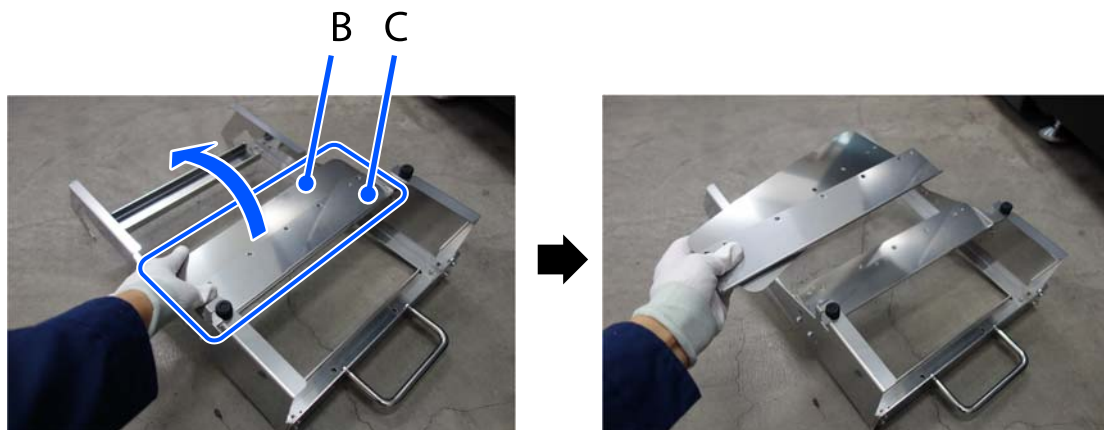


After wiping off the dirt, turn over the glue removal tool.

- 6** Loosen and remove the five screws with a Phillips-head screwdriver.



- 7** Remove plates B and C.

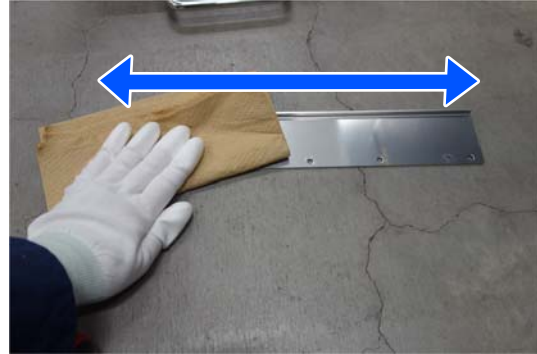
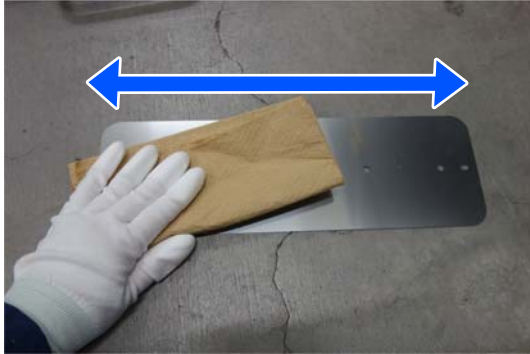


Maintenance

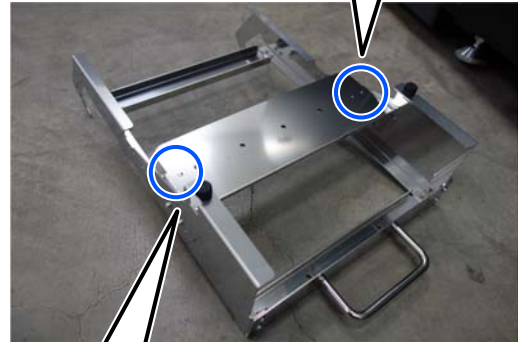
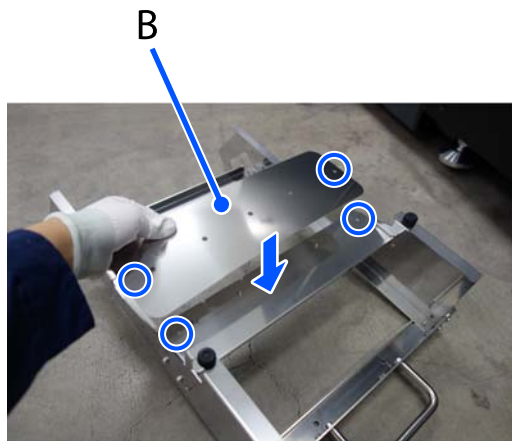
8 Wipe off the glue remover from both sides of plates B and C with an ethanol-soaked wipe cloth.

If the dirt cannot be removed, soak a wipe cloth in glue remover to wipe it off.

Dispose of the used wipe cloths in the proper manner for industrial waste.

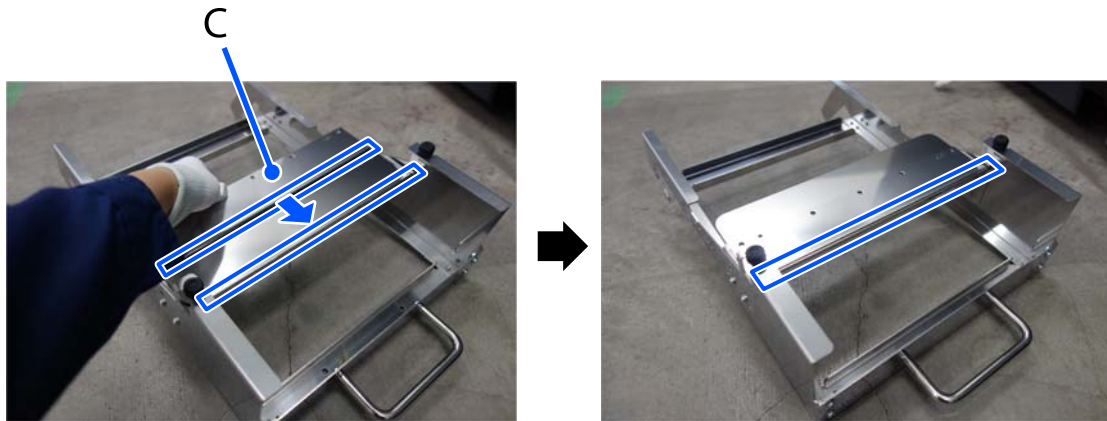


9 Align the holes on both ends of plate B with the protruding parts of the glue removal tool and attach the plate.

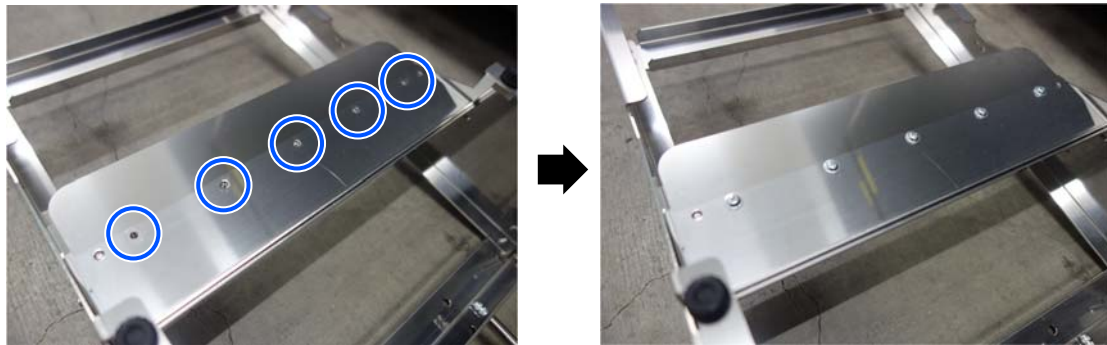


Maintenance

- 10** Align the L-shaped section of plate C with the corner of the glue removal tool and attach it.

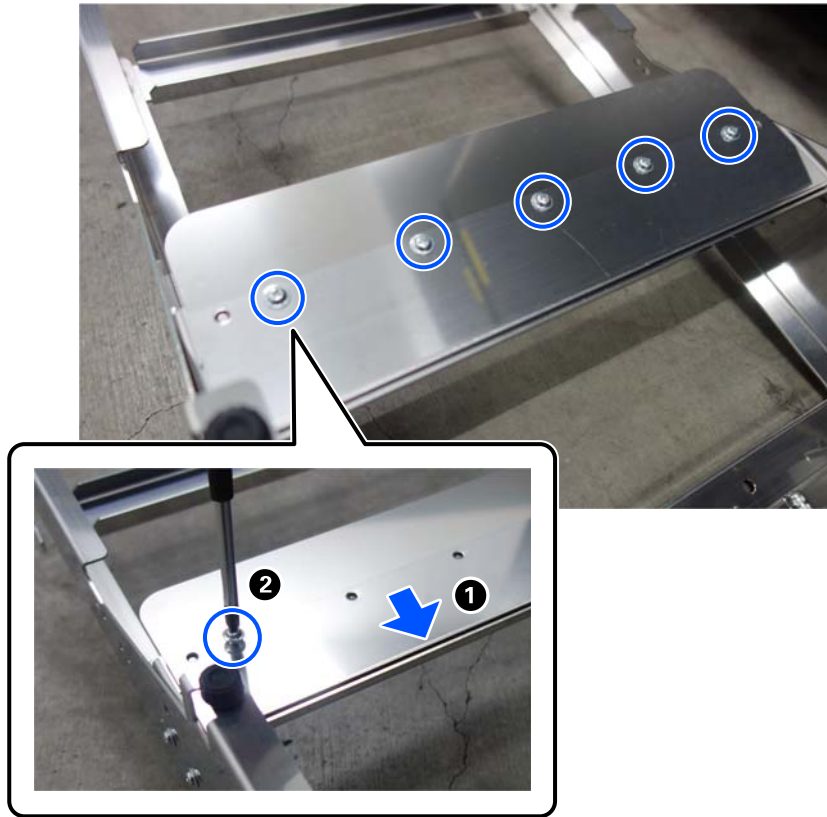


- 11** Loosely tighten the five screws with a Phillips-head screwdriver.



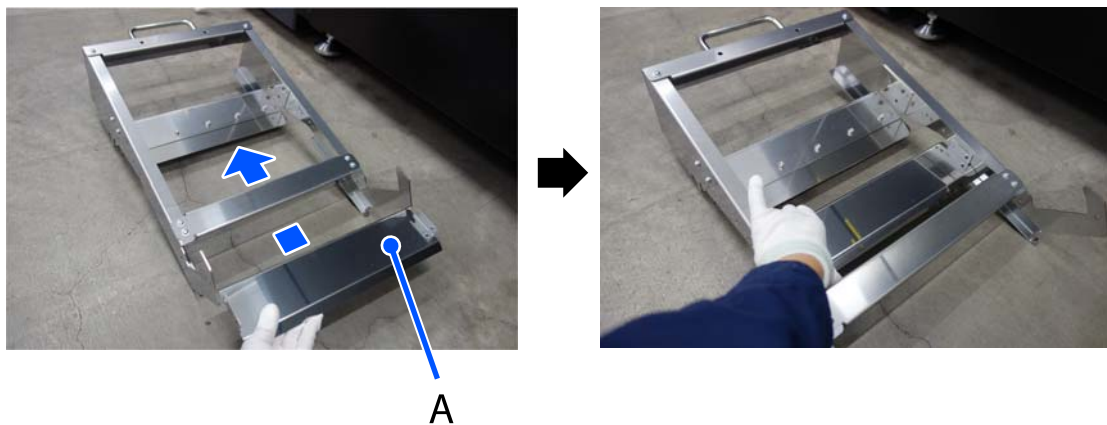
Maintenance

- 12** Keeping the L-shaped section of plate C aligned with the corner of the glue removal tool so that there are no gaps, tighten the five screws firmly with a Phillips-head screwdriver.



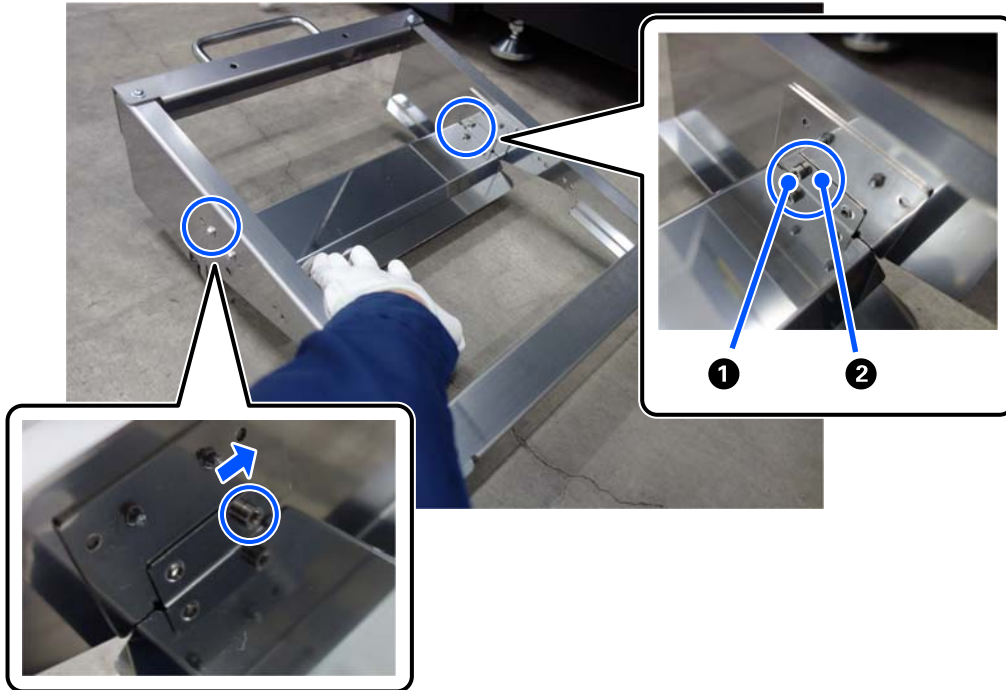
After tightening the screws, turn over the glue removal tool.

- 13** Insert plate A into the glue removal tool from the side with the hooks.



Maintenance

- 14** Fit the notch in plate A over the protruding parts on the inside of the glue removal tool.



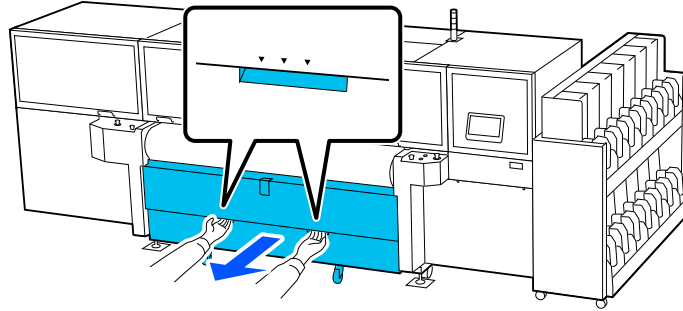
- 15** Tighten the two screws on the sides of the glue removal tool by hand.



- 16** Close the front cover.

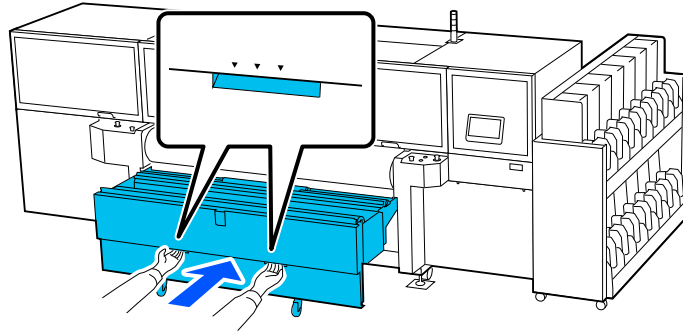
Maintenance

- 17 Hold the handles at the front of the belt cleaning tank, and pull out the belt cleaning tank.



- 18 Remove the protective tape and plastic sheet covering the lower part of the printer and the belt cleaning unit cover.

- 19 Push the belt cleaning unit back to its original position.



- 20 Move to the rear of the printer and lower the tension bar.



! **Important:**
Steps 21 to 23 should be performed by at least two people.

Maintenance

- 21** Attach the exterior panel to the rear of the printer.
Fit the grooves at the bottom of the exterior panel over the two bolts.

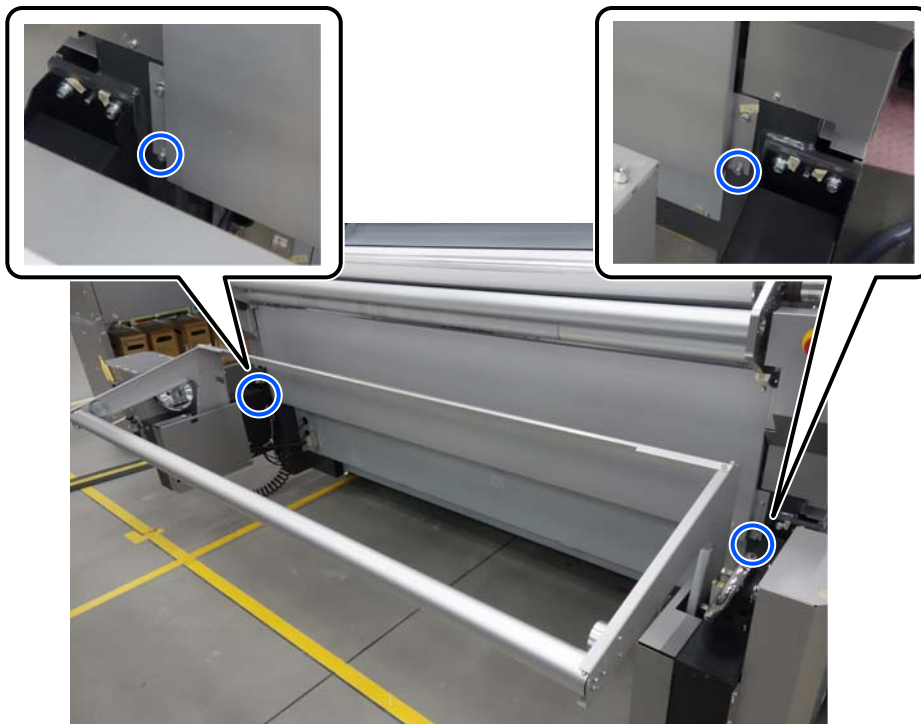


Maintenance

- 22** While supporting the exterior panel to prevent it from falling, tighten the four bolts at the top of the exterior panel using a hex wrench.



- 23** Tighten the two bolts at the bottom of the exterior panel using a hex wrench.



Maintenance

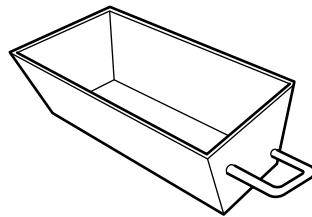
- 24** Lift up the tension bar.



Removing Glue (When Using the Glue Bucket)

Remove the glue that has been applied to the belt.

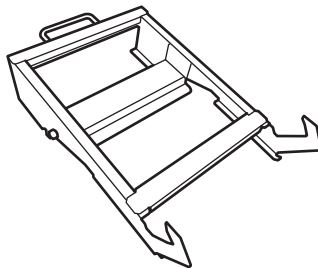
This section describes how to remove glue using the glue bucket.



Note:

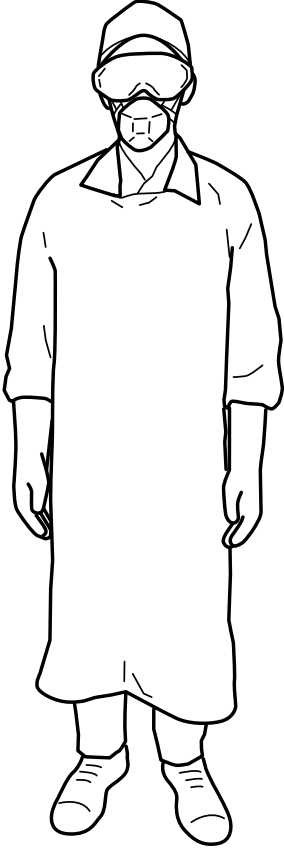
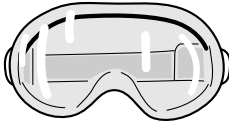
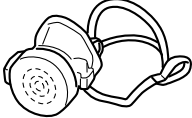

See the following when using the glue removal tool.

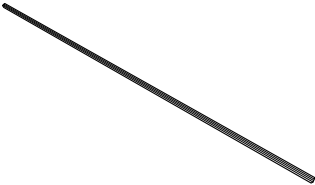
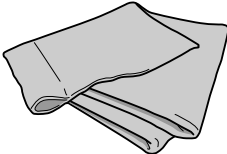
 [“Removing Glue \(When Using the Glue Removal Tool\)” on page 314](#)



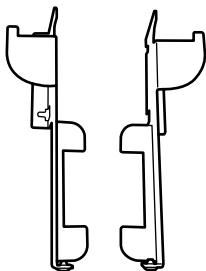
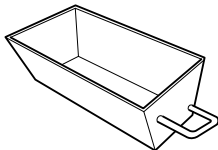
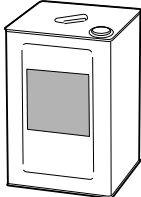

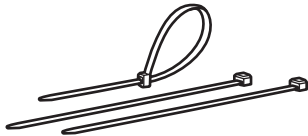


Required number of workers	Min. 2 persons
----------------------------	----------------

Maintenance

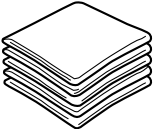

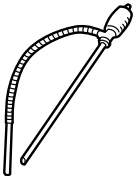

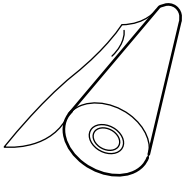
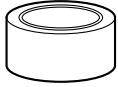
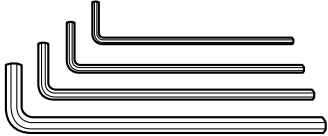
Personal protective equipment	The following is the protective equipment that must be worn when using the glue or glue remover recommended by Epson. For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.	
	Eye protection (For organic solvent use; Optimal is a goggle-type that seals against your face)	
		
	Gas mask (For organic solvent use)	
		
	Protective gloves (Butyl or polyurethane)	
		
Protective clothing (Long-sleeved)		
Hat or hair net (People with long hair must tie their hair and also wear a hair net.)		
Safety shoes		

Required Items	Quantity	Details/Use	
Felt rod 	1	Supplied	Attach felt and install this in the machine interior for use.
Glue-removal felt 	1	Supplied or commercially available 190 cm (7.48 inches) (width) x 45 cm (1.77 inches) (length)	Soak this with glue remover for use.


Maintenance

Required Items	Quantity	Details/Use	
Felt mounting plate 	2	Supplied	Used to attach the felt rod to the printer.
Glue collection bucket 	1	Optional	Push this against the belt and scrape off the glue.
Glue remover 	5 to 10 L	Recommended product <input type="checkbox"/> Cleanser TS (Murayama Chemical Laboratory) <input type="checkbox"/> ATR1222 (ATR) <input type="checkbox"/> ATR3222 (ATR)	Solvent used when peeling glue from the belt.
Scissors 	1	Commercially available	Used to cut slits in the felt to pass the cable ties through to secure the felt to the felt rod. These are not necessary when making a loop out of the felt that comes with the product or commercially available felt and sewing it in place.
Cable ties 	5	Commercially available	Used to secure felt to the felt rod with cable ties. These are not necessary when making a loop out of the felt that comes with the product or commercially available felt and sewing it in place.
Ethanol 	0.25 L	Commercially available	Used when wiping stains off the belt surface or jigs.
Bottle (For ethanol) 	1	Commercially available	Container for holding ethanol.

Maintenance

Required Items	Quantity	Details/Use	
Wipe cloths 	Proper amount	Commercially available	Used when cleaning the belt or equipment. Use cloths of soft non-fluffy material that will not damage the belt.
Bucket for glue remover 	1	Commercially available	Container used when pouring glue remover onto the felt.
Pump 	1	Commercially available	Used when pouring glue remover into the bucket. Use a material that does not dissolve when exposed to organic solvent.
Rubber spatula or plastic spatula 	1	Commercially available	Used when scraping the glue. Use a material that does not dissolve when exposed to organic solvent.
Plastic sheet 	1	A: 2 m (78.74 inches) (width) x 3 m (118.1 inches) (length) Thickness: 0.15 mm (0.006 inches) or more	Used to protect the product bottom. You can also use plastic bags. Use a material that does not dissolve when exposed to organic solvent, such as polyethylene, and cut them to sizes A and B respectively.
	1	B: 2 m (78.74 inches) (width) x 45 cm (17.72 inches) (length) Thickness: 0.15 mm (0.006 inches) or more	
Protective tape 	Proper amount	Commercially available	Used to protect the product bottom.
Hex key 	1	Commercially available 5 mm (0.2 inches) wide	Used when attaching or removing the felt mounting plate or the exterior panels of this printer.

**Warning:**

Before starting this procedure, be sure to read the following.  [“Precautions Regarding Maintenance” on page 185](#)

Maintenance



Caution:

Be sure to wear eye protection, respiratory protection, and protective gloves when applying glue.

For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.

Work environment conditions

- Avoid work in high-temperature, high-humidity environments. The glue might not be applied evenly, resulting in water droplets remaining after belt cleaning.
- Work in an environment that is clean and dust-free (meaning dust does not accumulate for 5 to 10 minutes after cleaning).

Note:

The belt rotation speed can be adjusted using the belt speed dial on the front panel.

We recommend setting the belt rotation speed to a somewhat slower speed if this is your first time performing work.



Workflow

1. Enter glue maintenance removal mode

 ["Entering Adhesive Material Maintenance Removal Mode" on page 371](#)



2. Protect the base of the product

Cover the product so that glue remover or scraped off glue does not enter under the base of the product.

 ["Product curing" on page 372](#)



3. Attach felt to the felt rod

 ["Preparing the Felt" on page 384](#)



4. Attach the felt rod to the product

 ["Setting the felt" on page 386](#)

Maintenance



5. Ensuring safety

Perform ventilation and wear protective equipment, referring to the instructions in the SDS for the glue and glue remover you are actually using, as well as the laws and regulations in your country.




6. Remove glue from the belt

 ["Removing Glue" on page 389](#)



7. Clean the surface of the belt

 ["Belt surface cleaning" on page 395](#)



8. Clean up the work area

Clean the tools used for glue removal and remove the protective tape from the base of the product.

If you are going to apply glue after cleaning, do not remove the protective tape from the base of the product.

 ["Clean-up" on page 397](#)

You can watch a video of the procedure on YouTube.

https://support.epson.net/p_doc/a63/

Glue removal method

Entering Adhesive Material Maintenance Removal Mode

Switch the printer to maintenance mode.



Important:

Normally, you cannot operate the control panel when any cover is open or the belt cleaning unit is pulled out.

Therefore, if you return to the home screen during glue maintenance operations, you will not be able to return to maintenance mode until you close the front cover or the belt cleaning unit. Make sure you do not touch the panel until you are ready, as it may result in performing curing again, setting the jigs again, or failure of glue maintenance operations.

1

Press the Pause/Restart button on the water recycling unit.

Wait until the Power light flashes and the water recycling unit pauses.

Maintenance

2 From the Maintenance screen on the control panel, touch **Maintenance - Adhesive Material Maintenance**.

3 Enter the Administrator Password.

! **Important:**

- ❑ Change the default Administrator Password to a new password to ensure that only users who know the Administrator Password can switch to maintenance mode. See the following for details on making changes. The printer and the computer must be connected to the same network when making changes.

[☞ “How to Set/Change the Administrator User Name/Administrator Password” on page 47](#)

- ❑ Save the password you set in a safe location so that you do not forget it.

See the following if you forget your password.

[☞ “If you have forgotten your administrator User Name or Administrator Password” on page 470](#)

4 Touch **Removal Mode - Start**.

When you touch **Forward** or **Reverse** once on the control panel, the belt will continue to rotate until you touch **Suspended**.

Touch **Done** to exit **Removal Mode** and return to the mode selection screen.

Product curing

Cover the product so that glue remover or scraped glue does not enter under the product and cause a malfunction.

! **Caution:**

The belt cleaning unit weighs over 110 kg, so make sure you bend your knees sufficiently and work in a natural position.

Pulling or pushing the unit with incorrect posture can lead to injury and back pain.

1 Protect the inside of the printer.

Move to the rear of the printer and lower the tension bar.



Maintenance

- 2 Loosen the two bolts at the bottom of the rear exterior panel of the machine using a hex wrench (5 mm in width).



! **Important:**
Steps 3 and 4 should be performed by at least two people.

- 3 While supporting the exterior panel to prevent it from falling, loosen and remove the four bolts at the top of the exterior panel using a hex wrench (5 mm in width).

Keep the removed bolts in a safe location to avoid losing them.



Maintenance

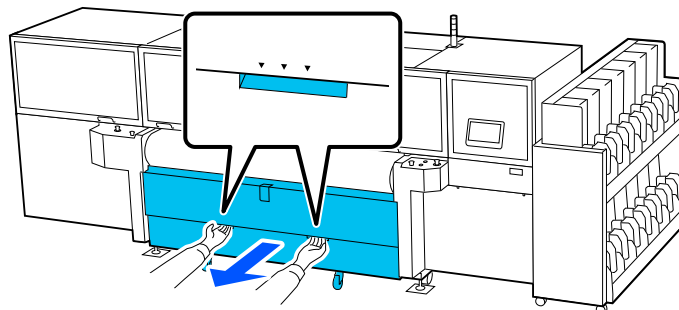
- 4 Lift up the exterior panel and remove it.



- 5 Lift up the tension bar.

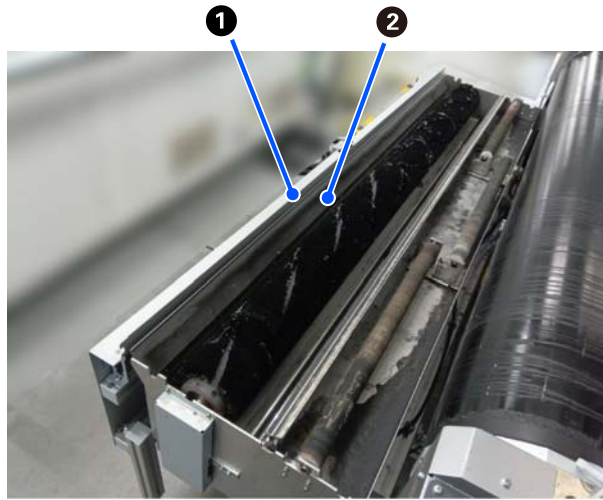


- 6 Move to the front of the machine, hold the handles at the front of the belt cleaning tank, and pull out the belt cleaning tank.



Maintenance

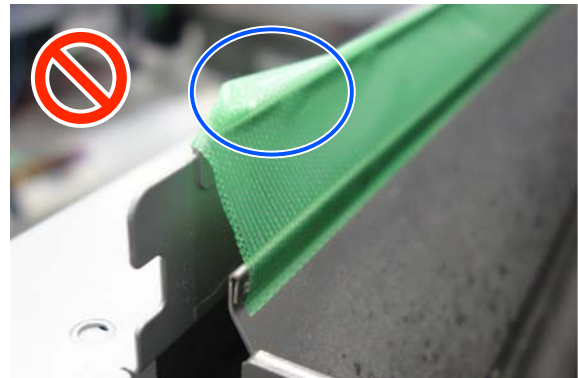
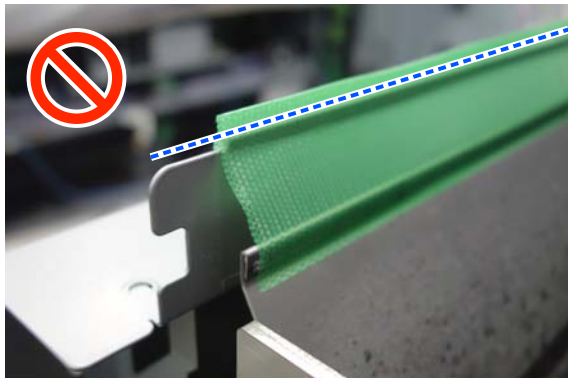
- 7 Wipe away any water droplets from the L-shaped section (1) of the belt cleaning unit cover and the edge (2) of the belt cleaning tank with a wipe cloth.



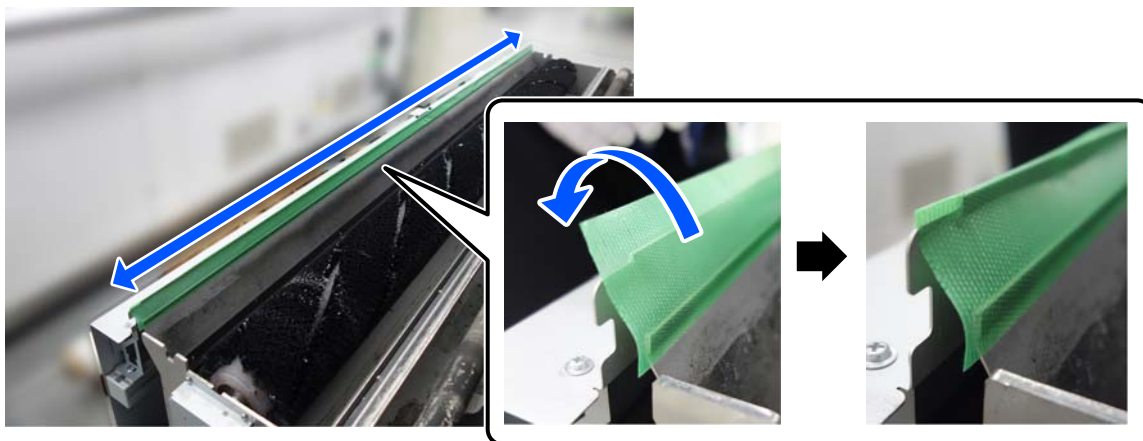
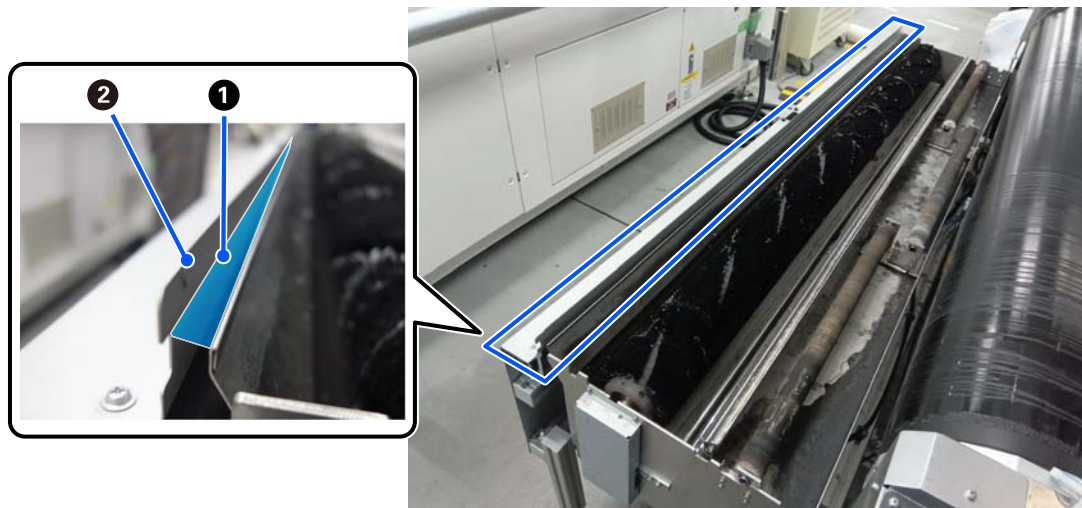
- 8 Attach protective tape from edge to edge on the front of the belt cleaning unit. Attach the tape so that it covers the gap (1) between the belt cleaning tank and the belt cleaning unit cover, as well as the raised part (2) at the front of the belt cleaning unit.

! **Important:**

When attaching the protective tape to the raised part, make sure the tape is firmly stuck down over the edge of the raised part. If the attached protective tape extends beyond the raised part or is not firmly stuck to the raised part, it may stick to or rub against the belt, requiring you to remove and reapply the glue.



Maintenance



9

Attach the plastic sheet A to the belt with protective tape in about three places.



Important:

Attach the protective tape with the adhesive side facing up to the back of the plastic sheet and the belt. This makes the plastic sheet less likely to come off when feeding it to the rear.



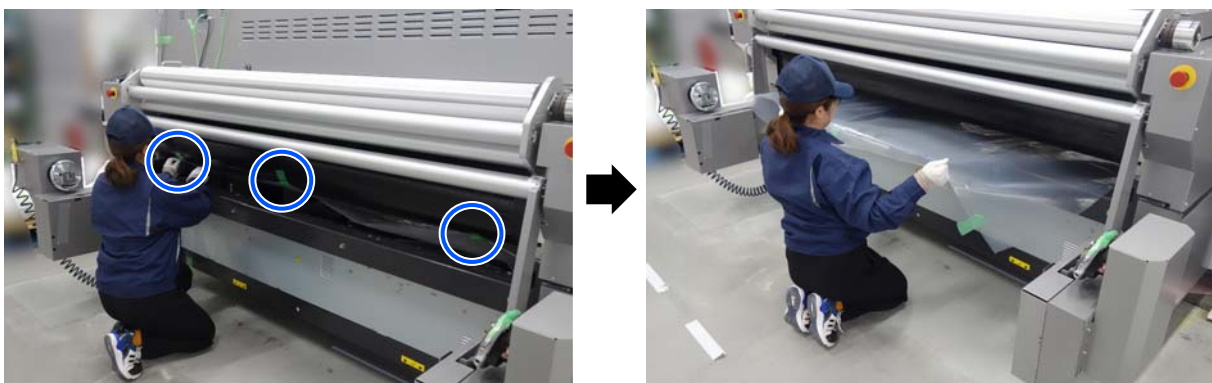
Maintenance



10 Press the backfeed button on the front panel to feed the plastic sheet attached to the belt to the rear.

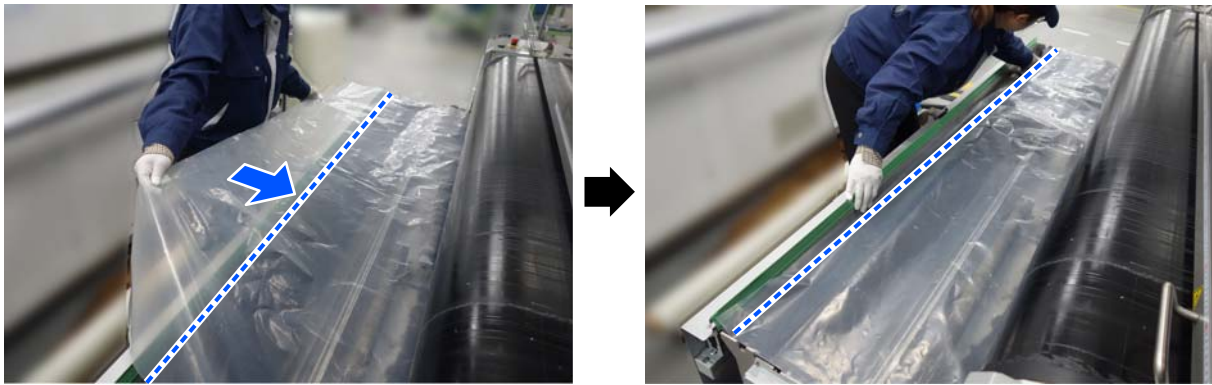
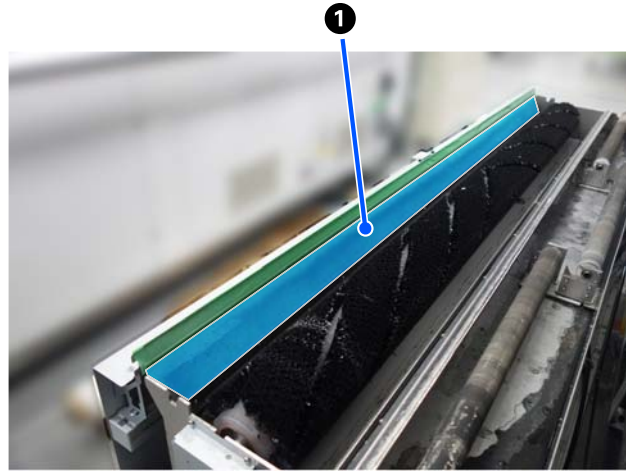


11 Move to the rear of the machine and remove the protective tape and plastic sheet attached to the belt.



Maintenance

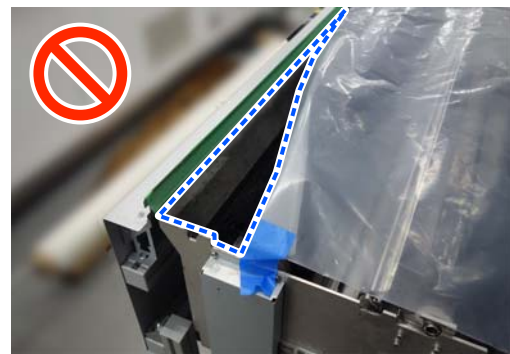
- 12 Align the front edge of the plastic sheet with the edge (1) of the belt cleaning tank.



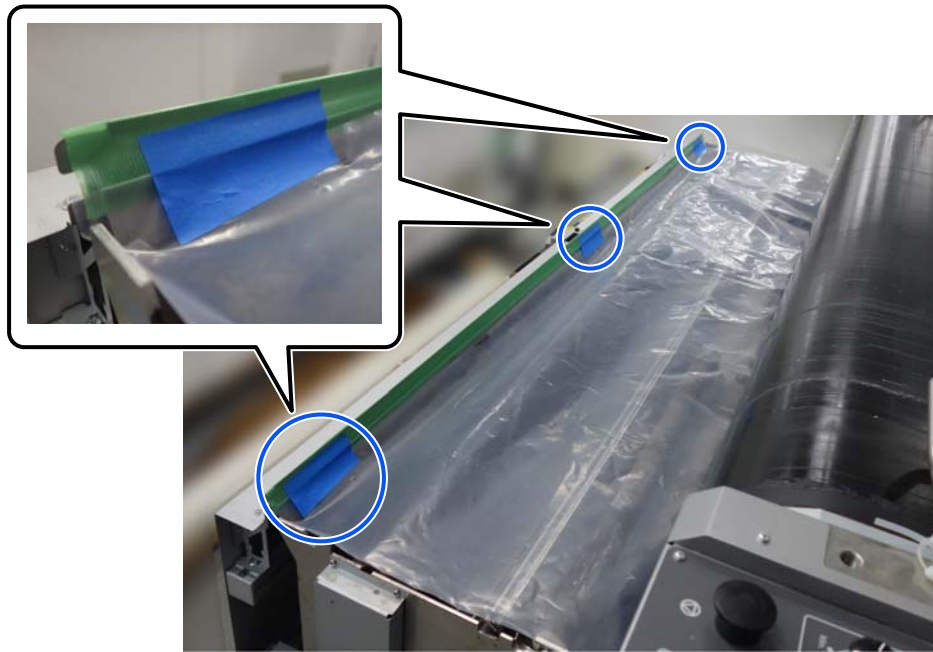
- 13 Smooth out any raised parts or wrinkles in the plastic sheet, and attach the edge of the plastic sheet to the edge of the belt cleaning tank with protective tape in about three places.

! **Important:**
When attaching the plastic sheet and protective tape, do not leave any gaps or extend beyond the raised parts of the belt cleaning unit.

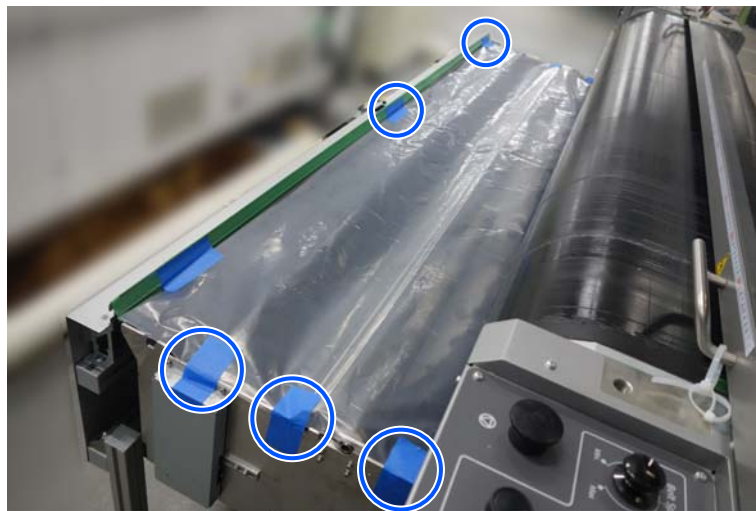
Glue remover or glue may stick to parts inside the belt cleaning unit, or the plastic sheet may stick to the belt, requiring you to remove and reapply the glue.



Maintenance



- 14** Attach both ends of the plastic sheet to the cleaning brushes section on the side of the belt cleaning tank, the washing scraper section, and the rear of the cleaning tank with protective tape.

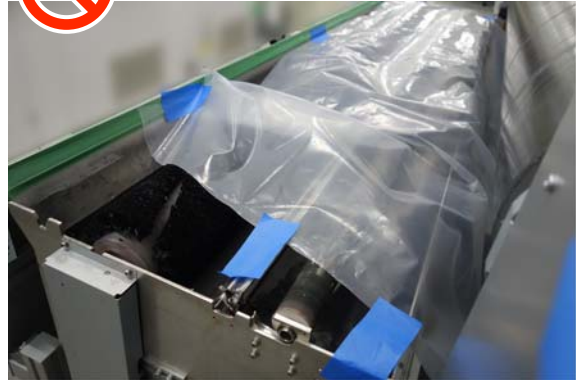
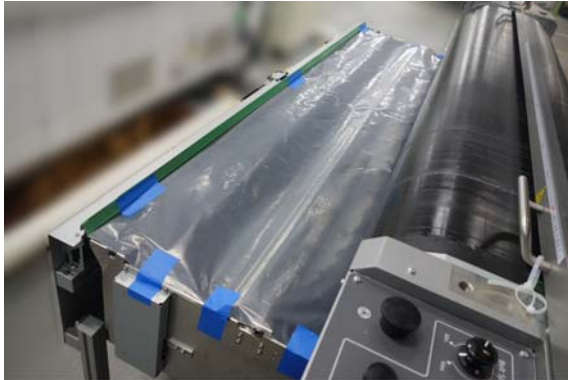


Maintenance

- 15** Check that there are no raised parts, wrinkles, or gaps in the plastic sheet covering the belt cleaning unit.

If there are any raised parts, wrinkles, or gaps in the plastic sheet, smooth out the wrinkles and raised parts and reapply the protective tape to ensure no gaps remain.

OK



- 16** Push the belt cleaning unit back to its original position.



Maintenance

- 17** Move to the rear of the machine and check that the plastic sheet is not stuck to the belt.
Peel off the plastic sheet if it is stuck to the belt.



- 18** Align the edge of the plastic sheet with the lower frame (1) of the machine. Place the excess parts of the plastic sheet inside the machine and allow the plastic sheet to sag.

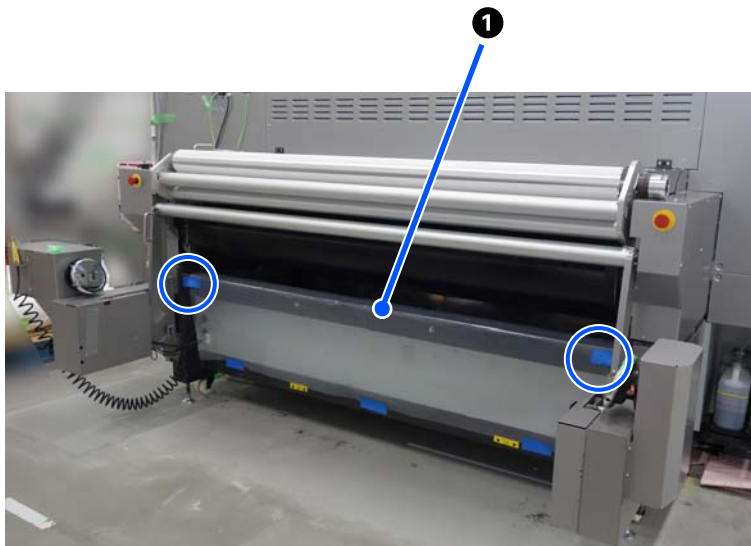


Maintenance

- 19** Attach the edge of the plastic sheet to the lower frame of the machine with protective tape in about three places.



- 20** Attach both ends of the plastic sheet to the upper frame (①) of the machine with protective tape.



- 21** Protect the belt cleaning unit cover.

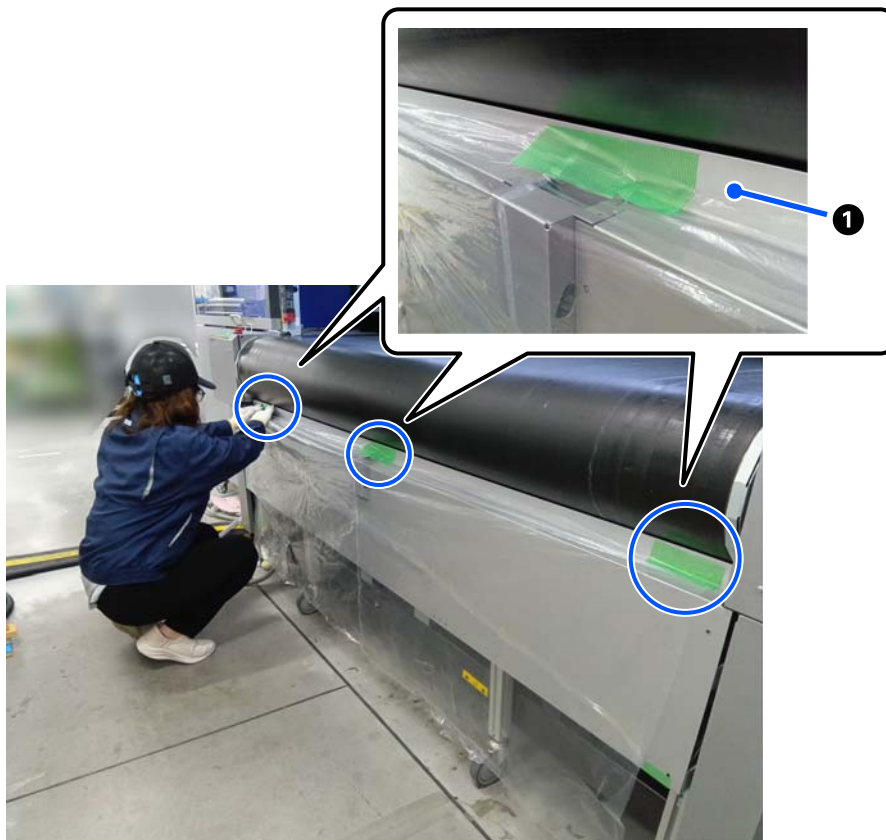
Move to the front of the machine and attach the edge of the plastic sheet B to the L-shaped corner (①) of the raised part of the belt cleaning unit cover with protective tape in about three places.

Maintenance



Important:

Attach the plastic sheet so that it covers the tangled fabric detection sensor (2), and the plastic sheet and protective tape do not extend beyond the raised part (3) of the belt cleaning unit cover. Otherwise, the sensor may malfunction, or the plastic sheet may stick to the belt, requiring you to remove and reapply the glue.



Maintenance

- 22 Attach the bottom edge of the plastic sheet to both ends of the lower part of the belt cleaning unit cover with protective tape.

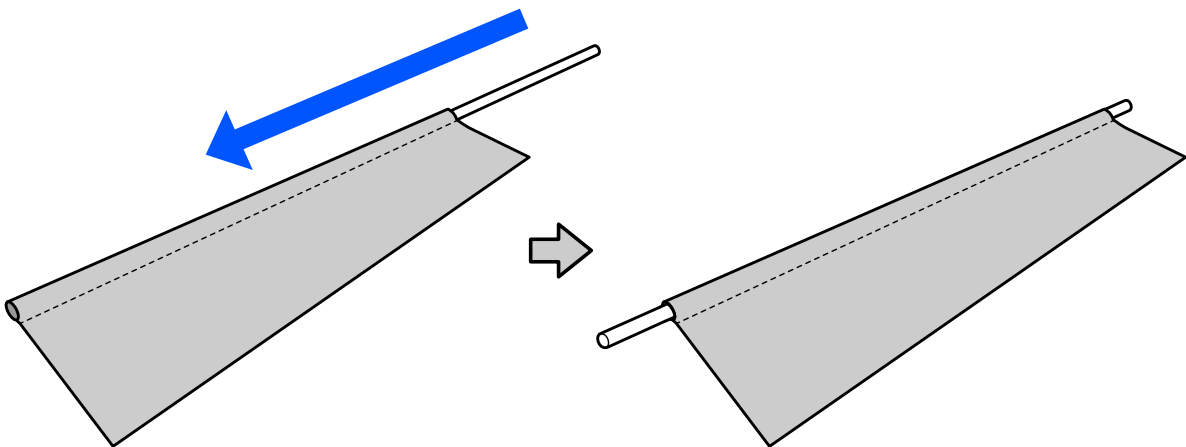


Preparing the Felt

Prepare some felt to soak up the glue remover.

When using the felt that comes with the machine

- 1 Put the felt rod through the glue-removal felt.

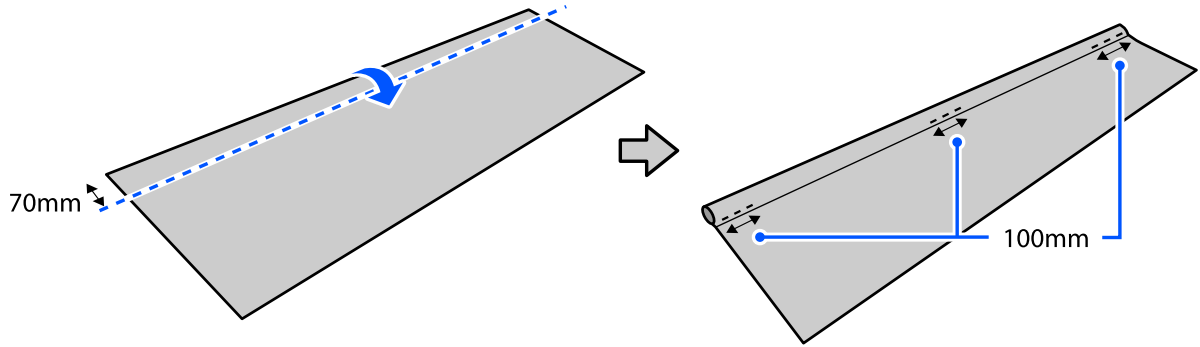


Maintenance

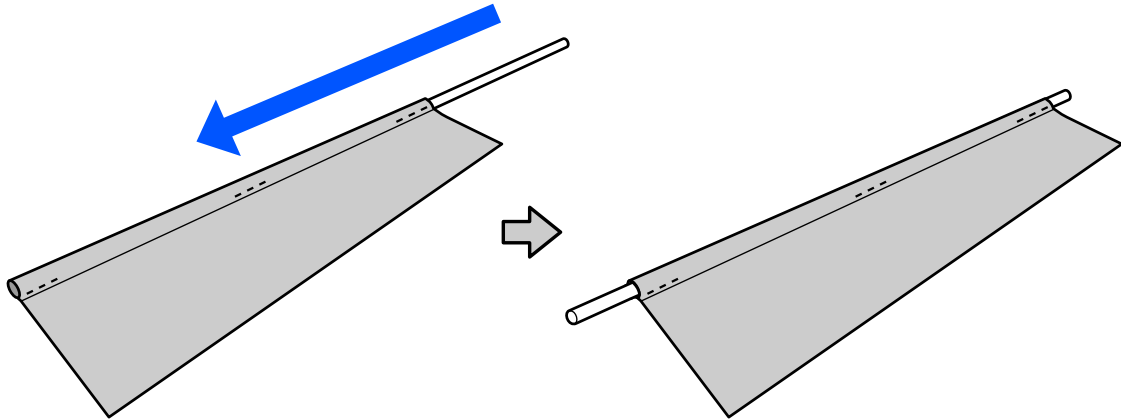
When using commercially available felt

Make a loop out of the felt and sew it in place

- 1** As shown in the figure, fold the felt so that it is approximately 70 mm wide, and then sew three points (the left, right, and center) of approximately 100 mm to form a loop.



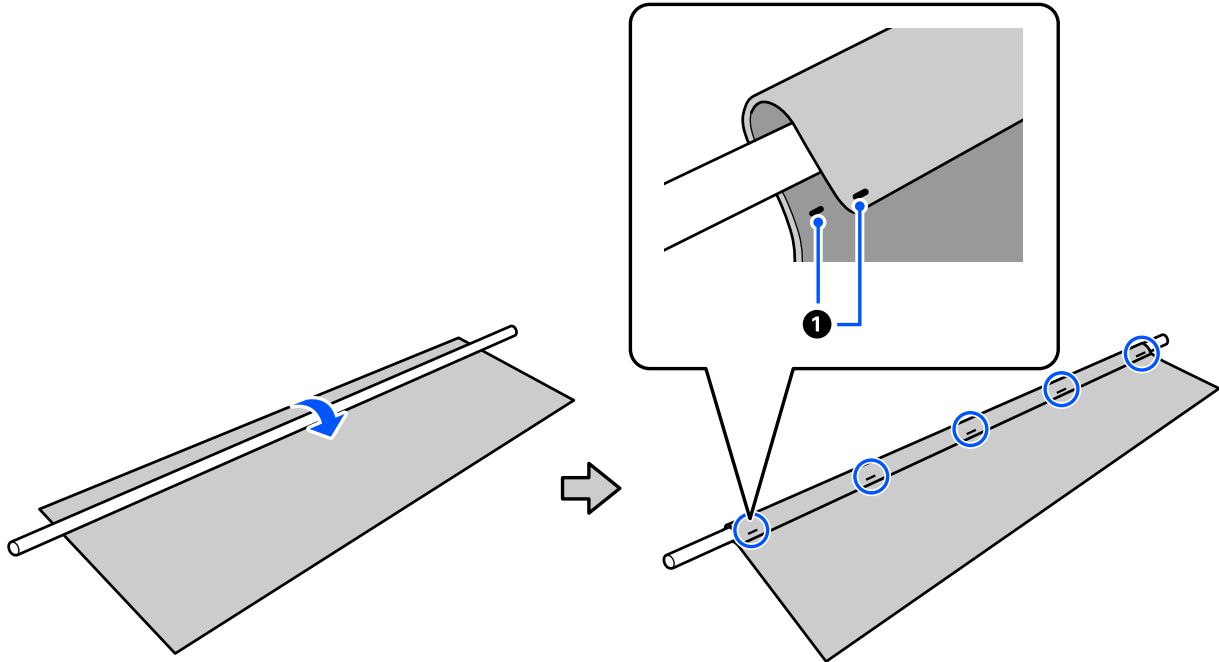
- 2** Put the felt rod through the felt.



Maintenance

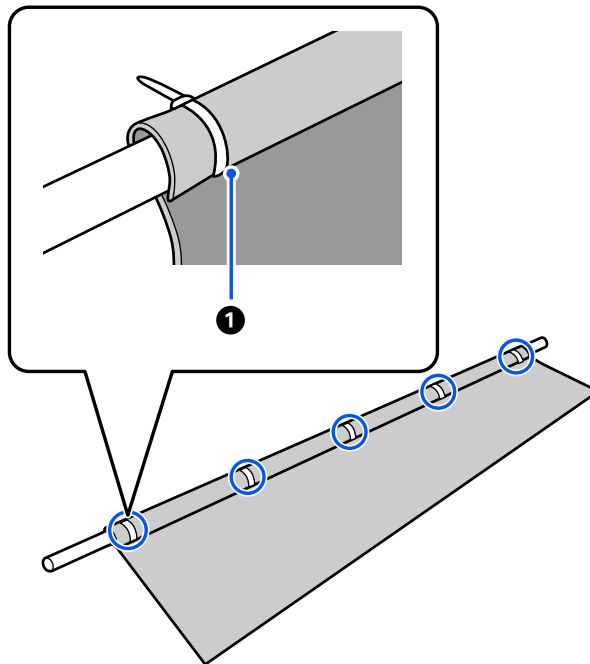
Use cable ties to secure it in place

- 1 Hang the felt over the felt rod, and then use scissors to cut five slits in the felt large enough to pass the cable ties through.



- 1 Slits

- 2 Attach the felt to the felt rod by passing five cable ties through the slits in the felt you made in step 1.



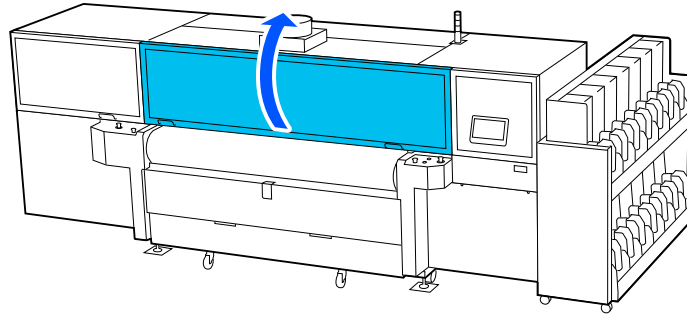
- 1 Cable ties

Setting the felt

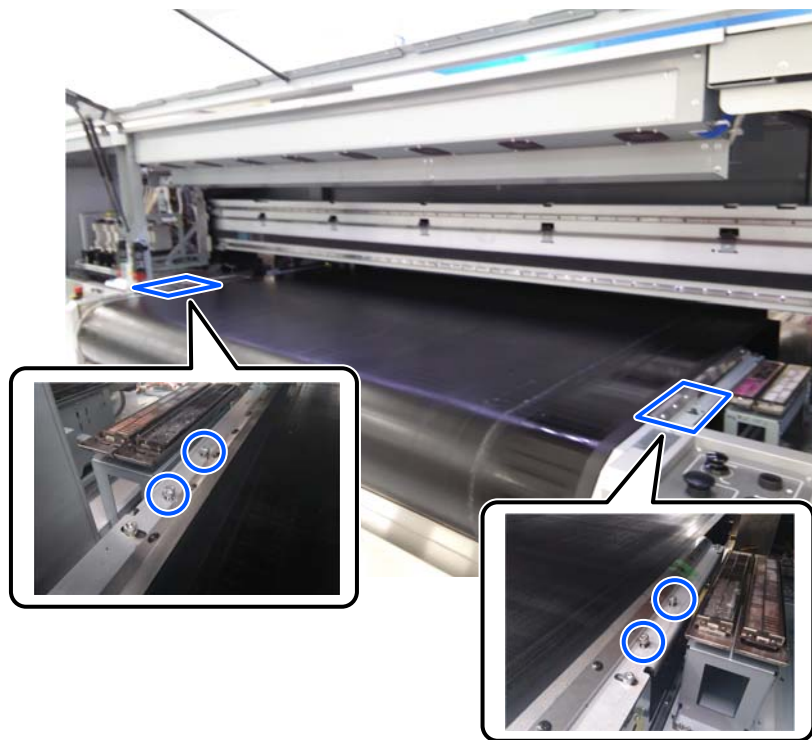
Set the felt in the printer.

Maintenance

- 1 Open the front cover.



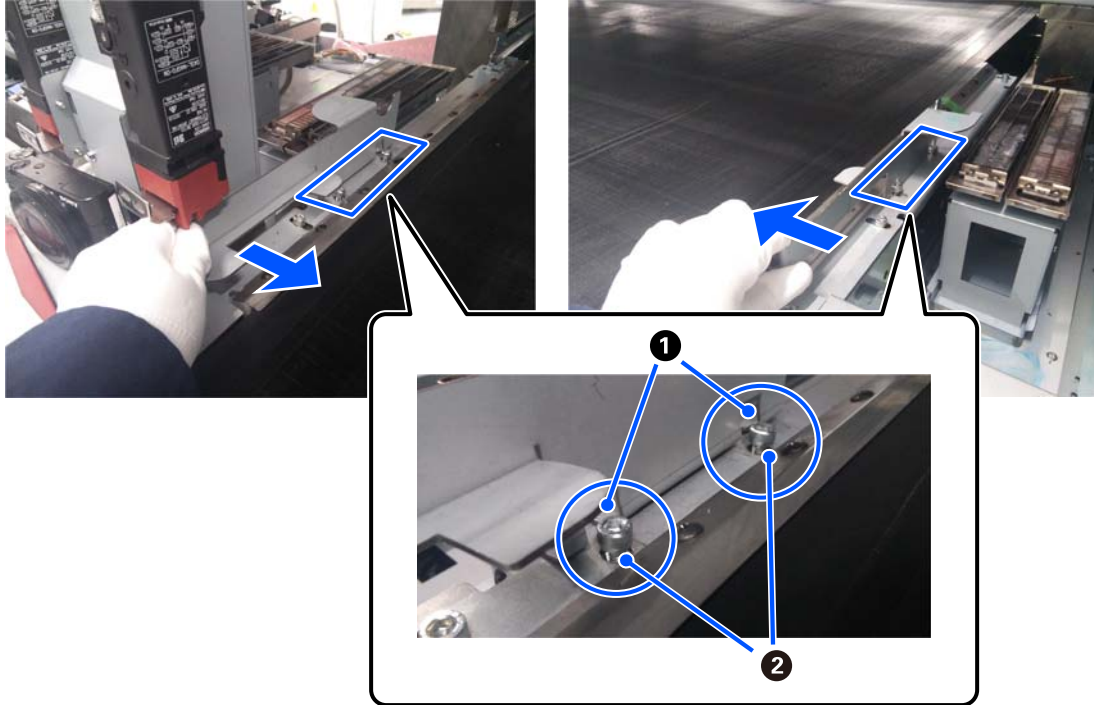
- 2 Loosely install the bolts in the bolt holes shown in the illustration with a hex wrench (5 mm width).
Loosen the bolts while they are still fixed in place.



Maintenance

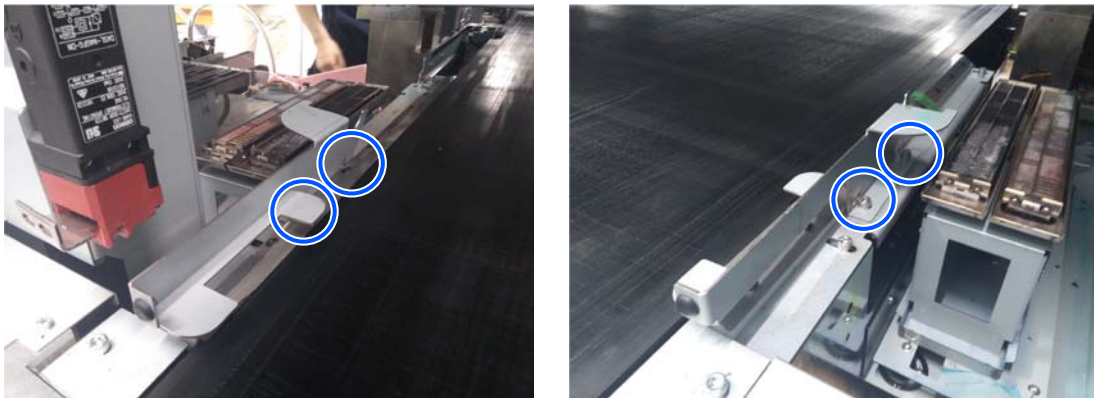
3 Install the felt mounting plate.

Insert the groove of the felt mounting plate into the gap between the bolts and the machine from the outside.



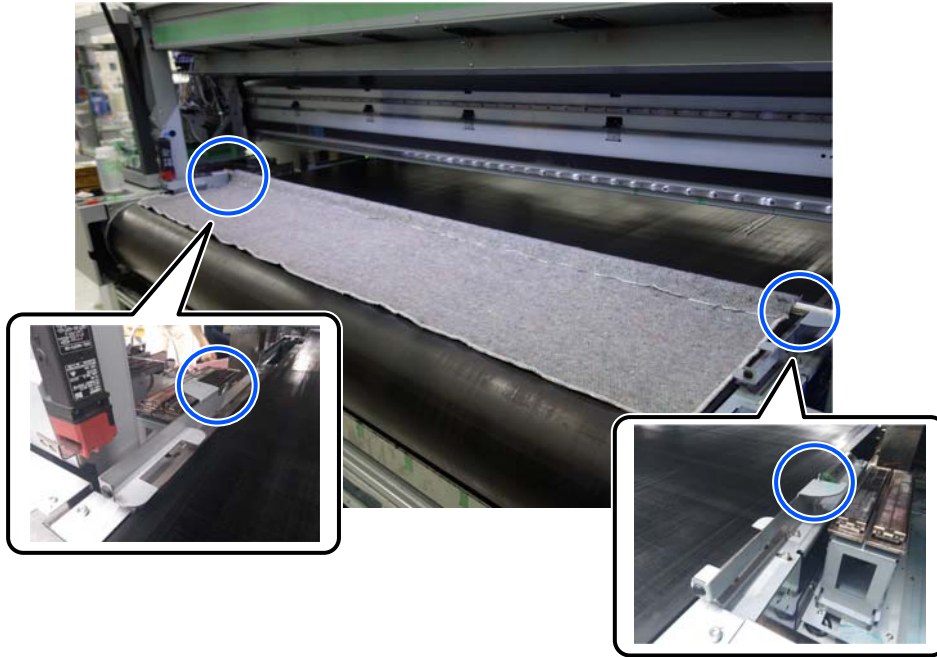
- 1 Notch
- 2 Bolts

4 Tighten the bolts with a hex wrench (5 mm [0.19 inches] in width).



Maintenance

- 5** Set the felt mounting rod on the felt mounting plate and spread the felt to the front side of the product.



Ensuring safety

Perform ventilation and wear protective equipment, referring to the instructions of the SDS for the glue and glue remover you are actually using, as well as the laws and regulations in your country.

Removing Glue

Use the glue remover and scrape the glue off the belt.

- 1** Touch the **Forward** button on the control panel.
The belt continues to move forward.
- 2** Place the glue remover bucket on the tray and put in approximately 2 L (67.63 ounces) of glue remover.
Use the pump to ensure the glue does not spill on the surroundings.

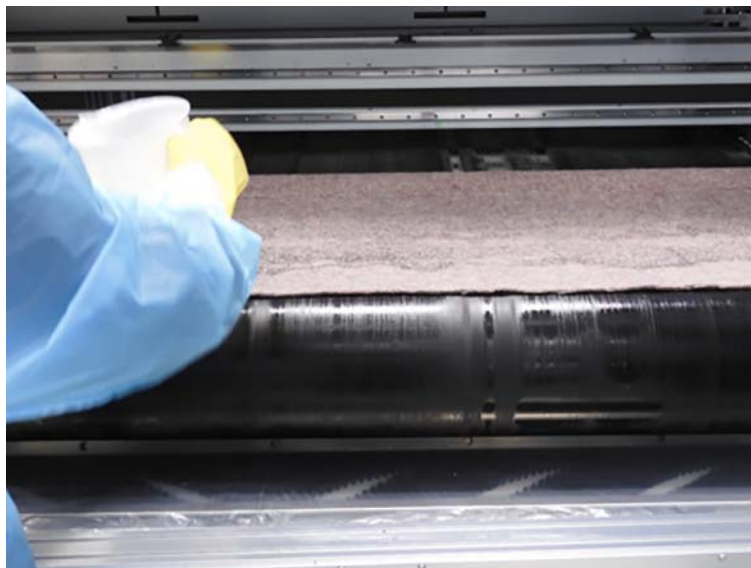


Maintenance

- 3** Soak the felt in glue remover.
Be careful that the glue remover does not leak from each side of the belt.



- 4** Ensure that the glue remover is uniformly spread throughout the felt.
After about 5 minutes, the glue on the belt surface begins to dissolve.
If the felt is floating up and is not in contact with the belt, put on a glove or use a similar tool to push down the felt.



- 5** Worker 1: Hold the handle of the glue collection bucket firmly with both hands and press it against the belt surface to scrape off the glue.
Worker 2: Use a scraper or the like to push glue on the bucket rim inside the bucket. To prevent the glue remover on the surface of the belt from drying, soak the entire surface of the felt with more glue remover.



Important:

Pressing too hard on the glue collection bucket may scratch the surface of the belt.

Maintenance

**6**

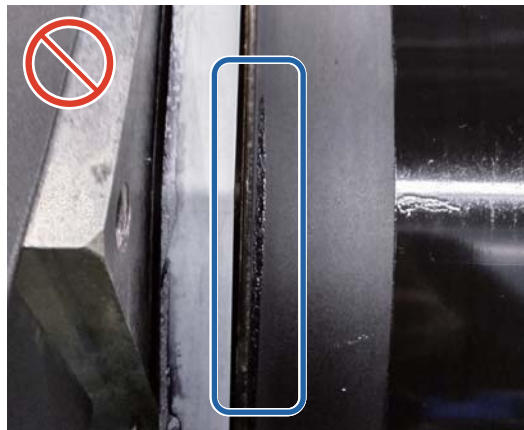
Worker 1: Once the glue has peeled and cannot be scraped away anymore, gradually move while scraping away glue from all areas of the belt.

Worker 2: While checking the scraping conditions, continue pouring an appropriate amount of remover onto the felt.

**Important:**

Glue tends to remain on the belt edges, so focus on peeling those areas.

If glue or other such material is stuck to the edge of the belt, it may not be possible to measure the normal belt feed rate.



Maintenance



- 7 Once glue has been scraped off the entire belt, touch the **Suspended** button on the control panel.
The belt will stop rotating.

- 8 Remove the felt rod.

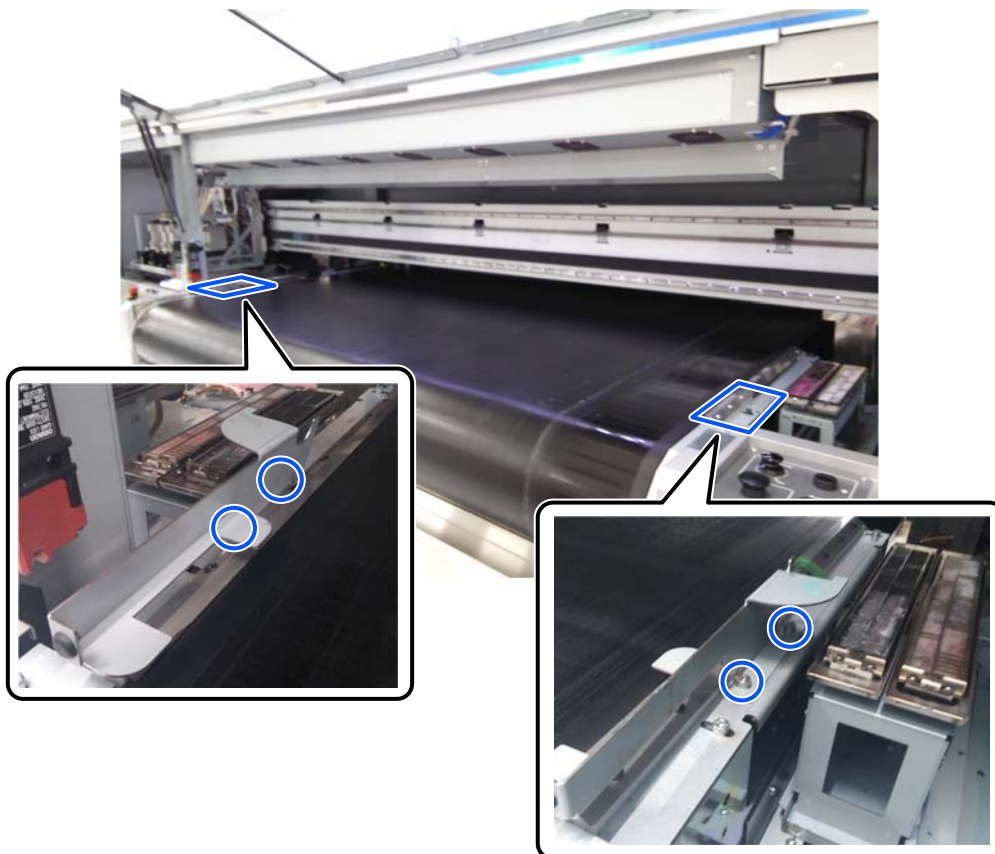


Maintenance

- 9 Remove the felt from the felt rod.
Dispose of the felt in the proper manner for industrial waste.

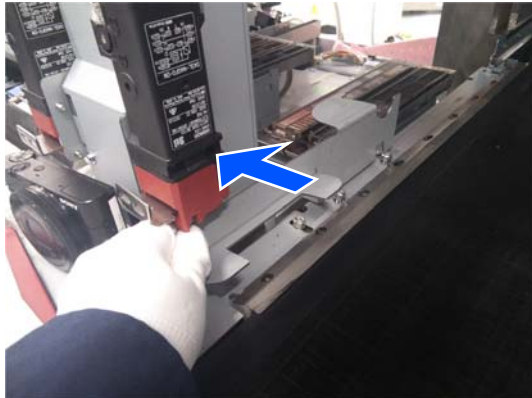


- 10 Loosen the bolts on the felt mounting plate with a hex wrench (5 mm in width).

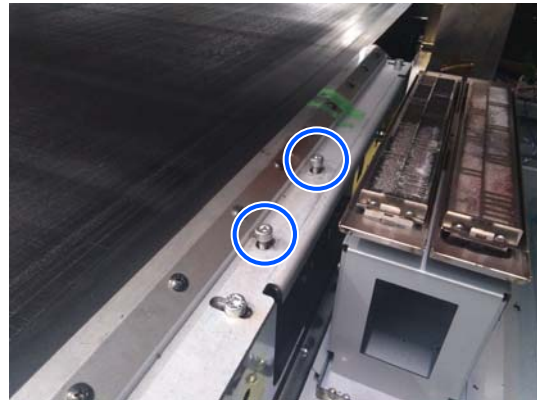
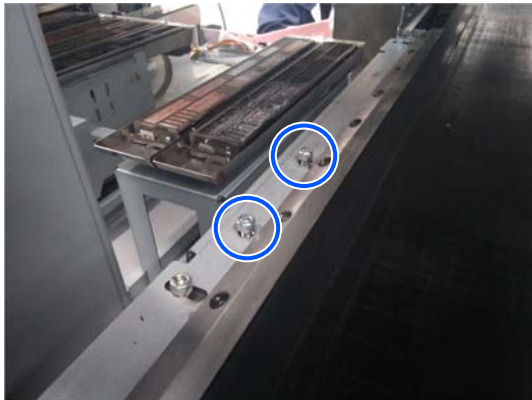


Maintenance

- 11** Remove the felt mounting plate.



- 12** Tighten the bolts with a hex wrench (5 mm in width).



- 13** If any glue remover got on the rod, wipe it clean using an ethanol-soaked wipe cloth. If the dirt cannot be removed, soak a wipe cloth in glue remover to wipe it off. Dispose of the used wipe cloths in the proper manner for industrial waste.



Maintenance

- 14** Touch **Forward** or **Reverse** on the control panel.

The belt continues to rotate.

- 15** Check the belt surface for any glue residue.

If glue remains, soak the felt with glue remover and wipe it off.



- 16** Touch the **Suspended** - **Done** buttons on the control panel in that order.

Check the message displayed on the control panel. Touch **Yes** to continue glue application, or **No** to discontinue glue application.

If you apply glue at this stage, do not return to the home screen, and leave the mode selection screen as it is. Step 17 is not required. Start by cleaning the belt surface.

- 17** Press the Pause/Restart button on the water recycling unit.

The water recycling unit starts operating again, and the cleaning water flows into it.

Belt surface cleaning

Clean the surface of the belt once.

- 1** Press the feed or backfeed button on the front panel to rotate the belt.

- 2** Wipe off the glue until the belt surface has a luster.

When the wipe cloth is dirty or glue chips occur, it means glue remains on the belt.

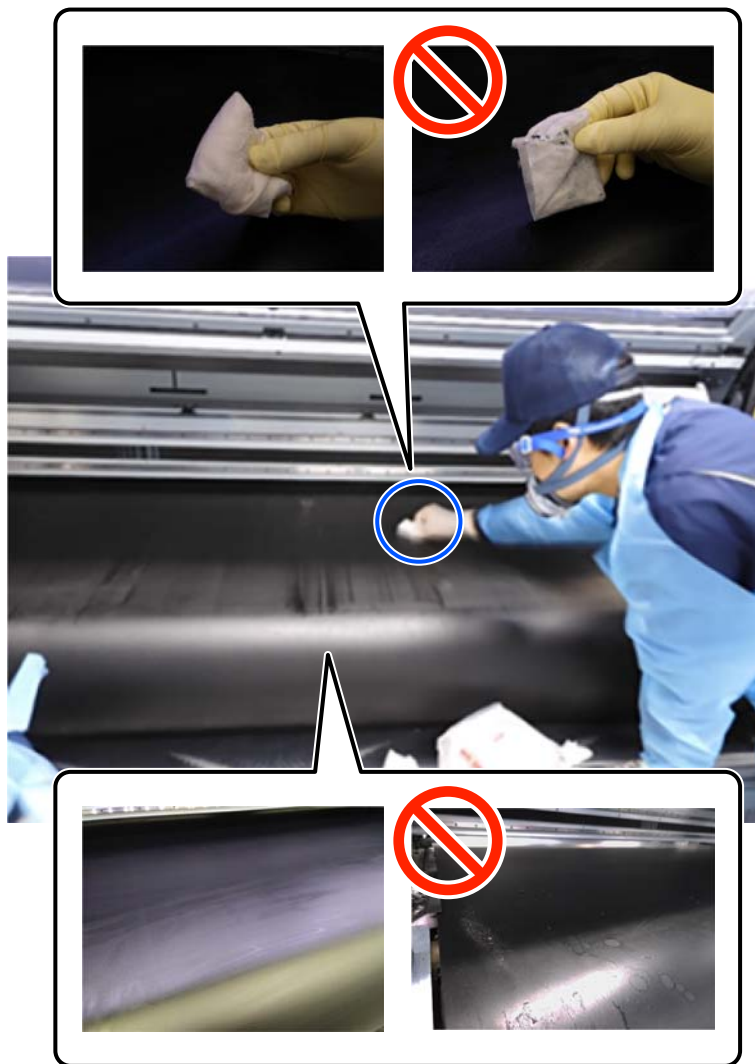
Dispose of used wipe cloths and glue chips according to the laws and regulations in your country.



Important:

Glue tends to remain on the belt edges, so focus on peeling those areas. If glue or other such material is stuck to the edge of the belt, it may not be possible to measure the normal belt feed rate.

Maintenance



Maintenance



Clean-up

Clean up the tools you used.

If you apply glue at this stage, you do not need to perform steps 4 and on to remove the curing.



Caution:

The belt cleaning unit weighs over 110 kg, so make sure you bend your knees sufficiently and work in a natural position.

Pulling or pushing the unit with incorrect posture can lead to injury and back pain.

1

Dispose of the glue in the glue collection bucket in the proper manner for industrial waste.



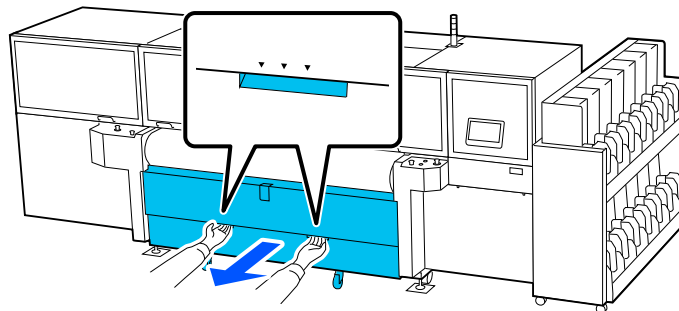
Maintenance

- 2 If any glue remover got on the glue collection bucket, wipe it clean using an ethanol-soaked wipe cloth. If the dirt cannot be removed, soak a wipe cloth in glue remover to wipe it off. Dispose of the used wipe cloths in the proper manner for industrial waste.



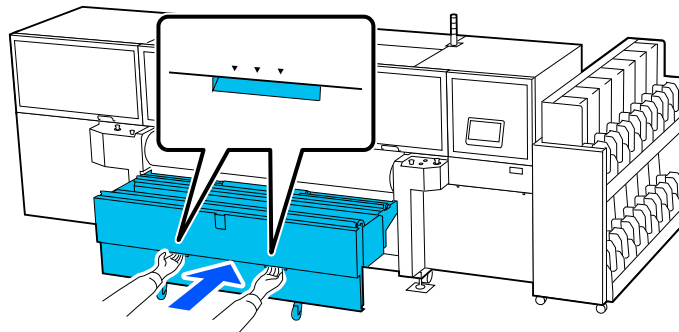
- 3 Close the front cover.

- 4 Hold the handles at the front of the belt cleaning tank, and pull out the belt cleaning tank.



- 5 Remove the protective tape and plastic sheet covering the lower part of the printer and the belt cleaning unit cover.

- 6 Push the belt cleaning unit back to its original position.



Maintenance

- 7 Move to the rear of the printer and lower the tension bar.



! **Important:**
Steps 8 to 10 should be performed by at least two people.

Maintenance

8

Attach the exterior panel to the rear of the printer.

Fit the grooves at the bottom of the exterior panel over the two bolts.

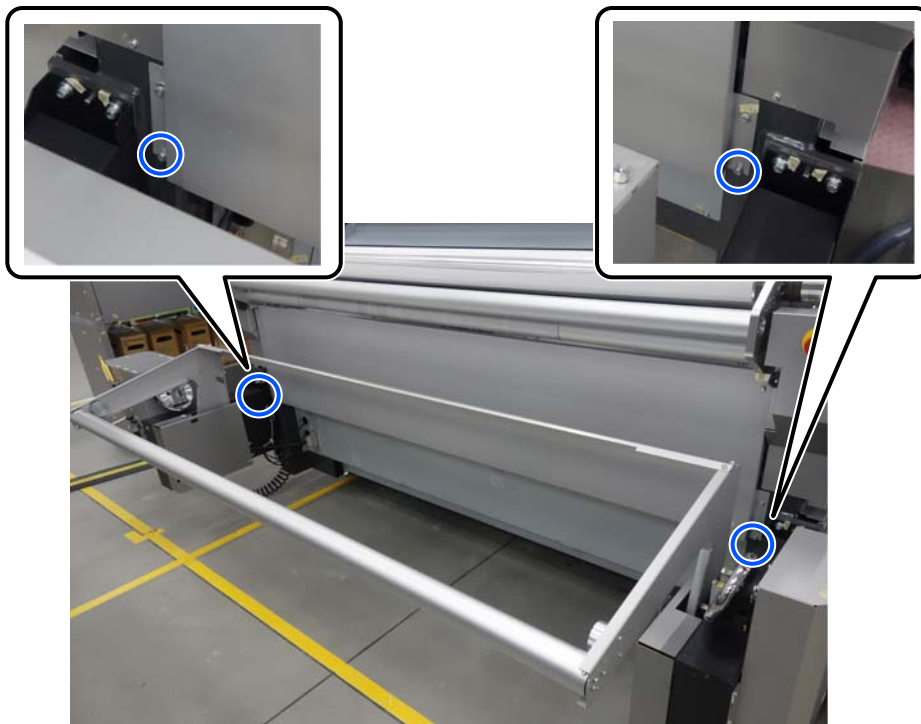


Maintenance

- 9** While supporting the exterior panel to prevent it from falling, tighten the four bolts at the top of the exterior panel using a hex wrench.

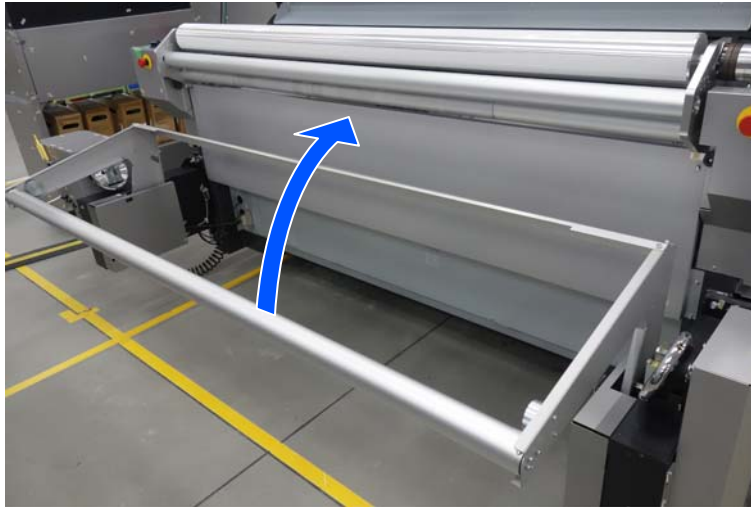


- 10** Tighten the two bolts at the bottom of the exterior panel using a hex wrench.



Maintenance

- 11 Lift up the tension bar.



Applying Glue

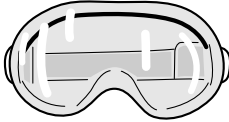
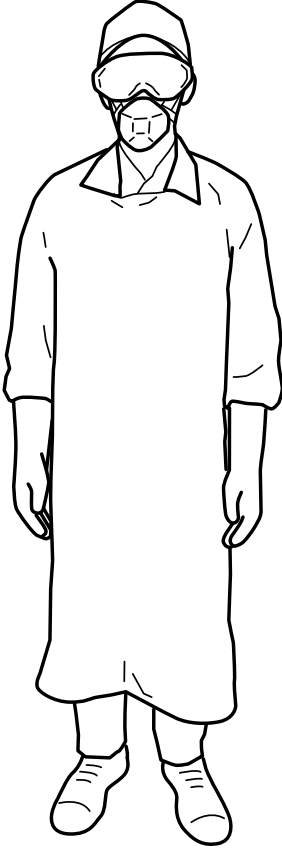
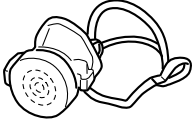

Pour the glue from the front of the machine and apply it to the entire belt.
This section describes the procedures for using the glue recommended by Epson.

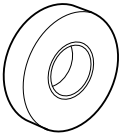
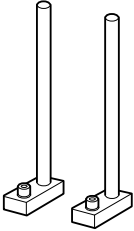


The illustrations shown here may differ from the model you are using.

Required Items


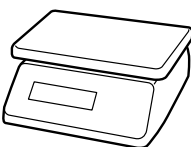

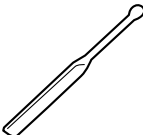
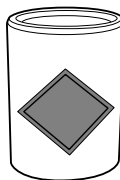

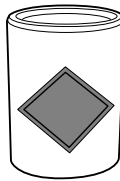

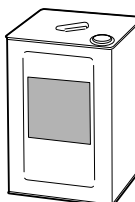
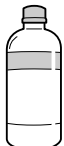
Required number of workers	Min. 2 persons
----------------------------	----------------

Maintenance




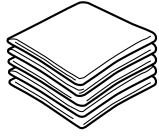
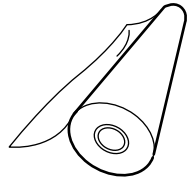

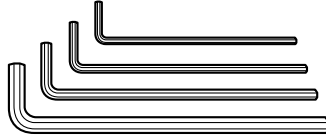
<p>Personal protective equipment</p>	<p>The following is the protective equipment that must be worn when using the glue or glue remover recommended by Epson. For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.</p>	
<p>Eye protection (For organic solvent use; Optimal is a goggle-type that seals against your face)</p>		
<p>Gas mask (For organic solvent use)</p>		
<p>Protective gloves (Butyl or polyurethane)</p>		
<p>Protective clothing (Long-sleeved)</p>	<p>Hat or hair net (People with long hair must tie their hair and also wear a hair net.)</p>	
<p>Hat or hair net (People with long hair must tie their hair and also wear a hair net.)</p>	<p>Safety shoes</p>	
<p>Safety shoes</p>		

Required Items	Quantity	Details/Use	
<p>Insulating tape</p> 	<p>1</p>	<p>Dedicated Consumables/ Commercially Available Items</p>	<p>Used when performing belt curing. 25 mm (0.98 inches) wide and 0.2 mm (0.008 inches) thick</p>
<p>Blade supports</p> 	<p>2</p>	<p>Supplied</p>	<p>These parts are used to secure to the belt the felt rod used when applying glue remover to the entire belt, or the blade used when applying glue on the belt. They are secured to both sides of the belt for use.</p>
<p>Blade</p> 	<p>1</p>	<p>Supplied</p>	<p>Used to apply glue uniformly to the belt.</p>
<p>Glue blocks</p> 	<p>2</p>	<p>Supplied</p>	<p>These parts are attached to both sides of the belt and used to prevent glue from leaking out of the belt sides.</p>

Maintenance

Required Items	Quantity	Details/Use	
Glue bucket 	1	Supplied	Container used when pouring glue onto the belt.
Scale 	1	Commercially available	Measures glue when preparing glue.
Scissors 	1	Commercially available	Used to cut insulating tape and so on.
Stirring rod for preparing glue 	1	Commercially available	Used when mixing 2 types of glue.
Glue A 	 "Amount of glue used" on page 405	Recommended product <input type="checkbox"/> ATR1719 <input type="checkbox"/> ATR1717	Solvent applied to the belt.
Glue B 	 "Amount of glue used" on page 405	Recommended product <input type="checkbox"/> ATR1655 <input type="checkbox"/> ATR1642	Solvent applied to the belt.
Glue remover 	Proper amount	Recommended product <input type="checkbox"/> Cleanser TS (Murayama Chemical Laboratory) <input type="checkbox"/> ATR1222 (ATR) <input type="checkbox"/> ATR3222 (ATR)	Used to clean the accessories.
Ethanol 	0.25 L (8.45 ounces)	Commercially available	Used when wiping stains off the belt surface or jigs.

Maintenance

Required Items	Quantity	Details/Use	
Bottle (For ethanol) 	1	Commercially available	Container for holding ethanol.
Soapy water 	Proper amount	Commercially available	Used when removing glue from the blade.
Cleaning bottle (For soapy water) 	1	Commercially available	Container for holding soapy water.
Wipe cloths 	Proper amount	Commercially available	Used when cleaning the belt or equipment. Use cloths of soft non-fluffy material that will not damage the belt.
Plastic sheet 	1	A: 2 m (78.74 inches) (width) x 3 m (118.1 inches) (length) Thickness: 0.15 mm (0.006 inches) or more	Used to protect the product bottom. This is not necessary if protective covering has already been applied. You can also use plastic bags. Use a material that does not dissolve when exposed to organic solvent, such as polyethylene, and cut them to sizes A and B respectively.
	1	B: 2 m (78.74 inches) (width) x 45 cm (17.72 inches) (length) Thickness: 0.15 mm (0.006 inches) or more	
Protective tape 	Proper amount	Commercially available	Used to protect the product bottom. This is not necessary if protective covering has already been applied.
Hex key 	1	Commercially available 5 mm (0.2 inches) wide	Used when attaching or removing the exterior panels of this printer.

Amount of glue used

As a general guideline, prepare the following amount of glue.

Maintenance

Amount of glue needed	
Glue A	Glue B
520 g (0.58 L)	1200 g (1.34 L)

Adjust the amount of glue used in the following situations.

When you want to prevent fabric from rising during printing

Applying the following amount of glue to the belt will prevent the fabric from rising during printing.



Important:

Fabric fibers and other lint may stick more easily to the belt, and glue may need to be removed and reapplied more frequently than usual.

Amount of glue needed	
Glue A	Glue B
866 g (0.96 L)	857 g (1.34 L)

When you want to reduce how often you need to remove and apply glue

When applying glue to the belt in the following amount, you can reduce how often you need to remove and apply glue.




Important:

The fabric may rise up more easily than normal.

Amount of glue needed	
Glue A	Glue B
1211 g (1.35 L)	513 g (0.57 L)



Warning:

Before starting this procedure, be sure to read the following.  [“Precautions Regarding Maintenance” on page 185](#)



Caution:

Be sure to wear eye protection, respiratory protection, and protective gloves when applying glue.

For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.

Maintenance

Work environment conditions

- ❑ Avoid work in high-temperature, high-humidity environments. The glue might not be applied evenly, resulting in water droplets remaining after belt cleaning.
- ❑ Work in an environment that is clean and dust-free (meaning dust does not accumulate for 5 to 10 minutes after cleaning).

Note:

- ❑ *The belt rotation speed can be adjusted using the belt speed dial on the front panel. We recommend setting the belt rotation speed to a somewhat slower speed if this is your first time performing work.*



- ❑ *You also need to perform product curing when applying glue. See the following for more details.*
[🔗 “Product curing” on page 372](#)

Workflow

1. Enter glue maintenance application mode

[🔗 “Entering Adhesive Material Maintenance Application Mode” on page 409](#)



2. Protect the base of the product

Cover the product so that glue remover, soapy water, and so on does not enter under the product and cause a malfunction.

This is not necessary if protective covering has already been applied.

The protection method is the same as for glue removal. See the following and take appropriate action.

[🔗 “Product curing” on page 321](#)



3. Check the belt surface for any glue residue

Press the feed button on the front panel and rotate the belt through one rotation to confirm. If any glue remains, see the following to clean it off.

[🔗 “Belt surface cleaning” on page 354](#)



Maintenance

4. Protect the belt

Protect both edges of the belt with insulating tape to prevent the glue from getting inside the printer.

 ["Protecting the belt" on page 409](#)



5. Install the blade

Install the blade so that the glue is applied evenly to the belt.

 ["Installing the blade" on page 413](#)



6. Ensure safety

Perform ventilation and wear protective equipment, referring to the instructions in the SDS for the glue and glue remover you are actually using and the laws and regulations in your country.



7. Mix the glue

 ["Mixing the glue" on page 420](#)



8. Apply the glue to the belt

 ["Applying Glue" on page 421](#)



9. Dry the glue applied to the belt

 ["Drying the glue" on page 426](#)



10. Check the condition of the glue applied to the belt

 ["Confirmation after glue application" on page 426](#)



11. Perform the work after applying glue

Remove the protective covering from both edges of the belt and the bottom of the cleaning tank, and then clean the belt.

 ["Work after glue application" on page 428](#)

Maintenance

You can watch a video of the procedure on YouTube.

https://support.epson.net/p_doc/a63/

Applying glue

Entering Adhesive Material Maintenance Application Mode

Switch the printer to maintenance mode.

If you want to continue from the glue removal process, see step 4 and on.

1 Press the Pause/Restart button on the water recycling unit.

Wait until the Power light flashes and the water recycling unit pauses.

2 From the Maintenance screen on the control panel, touch **Maintenance - Adhesive Material Maintenance**.

3 Enter the Administrator Password.



Important:

- ❑ *Change the default Administrator Password to a new password to ensure that only users who know the Administrator Password can switch to maintenance mode. See the following for details on making changes. The printer and the computer must be connected to the same network when making changes.*

[☞ "How to Set/Change the Administrator User Name/Administrator Password" on page 47](#)

- ❑ *Save the password you set in a safe location so that you do not forget it.*

See the following if you forget your password.

[☞ "If you have forgotten your administrator User Name or Administrator Password" on page 470](#)

4 Touch **Application Mode - Start**.

When you touch **Forward** or **Reverse** once on the control panel, the belt will continue to rotate until you touch **Suspended**.

Touch **Done** to exit **Application Mode** and return to the mode selection screen.



Important:

Normally, you cannot operate the control panel when any cover is open or the belt cleaning unit is pulled out.

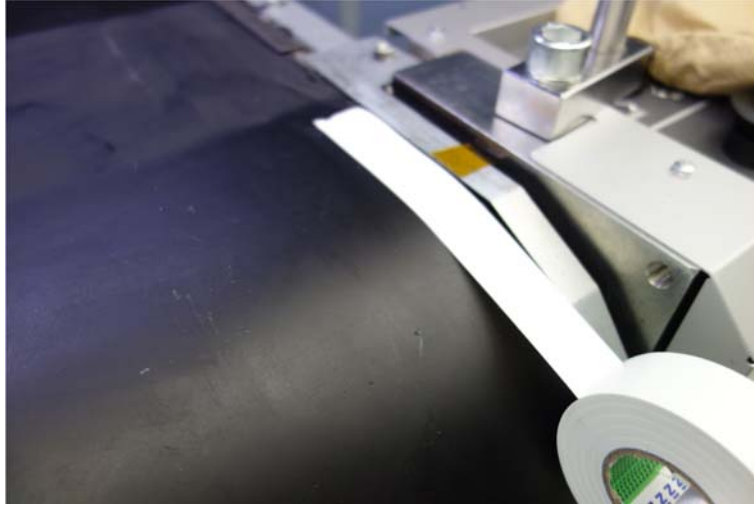
Therefore, if you return to the home screen during glue maintenance operations, you will not be able to return to maintenance mode until you close the front cover or the belt cleaning unit. Make sure you do not touch the panel until you are ready, as it may result in performing curing again, setting the jigs again, or failure of glue maintenance operations.

Protecting the belt

From the front of the printer, apply insulating tape (25 mm [0.98 inches] wide x 0.2 mm [0.008 inches] thick) to both edges of the belt. Affix insulating tape completely around the belt.

Maintenance

- 1 Worker 1: Align the edge of the insulating tape to the edge of the belt and apply.



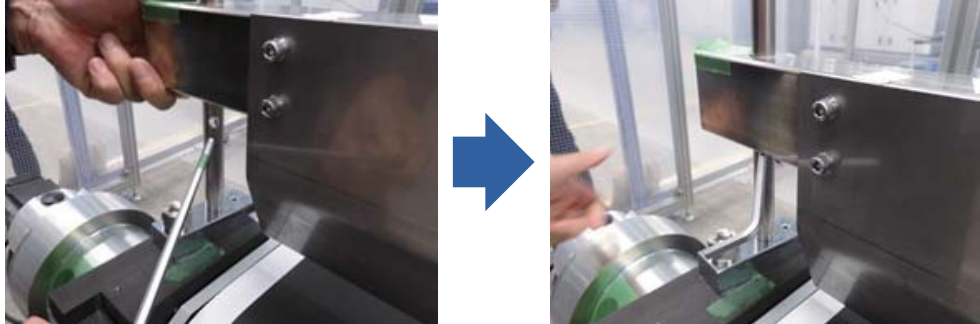
Maintenance

Note:

If you do not have 25 mm (0.98 inches) wide insulating tape, you can use 19 mm (0.75 inches) wide tape instead. Complete steps 1 through 3 of the blade installation procedure before applying the insulating tape.

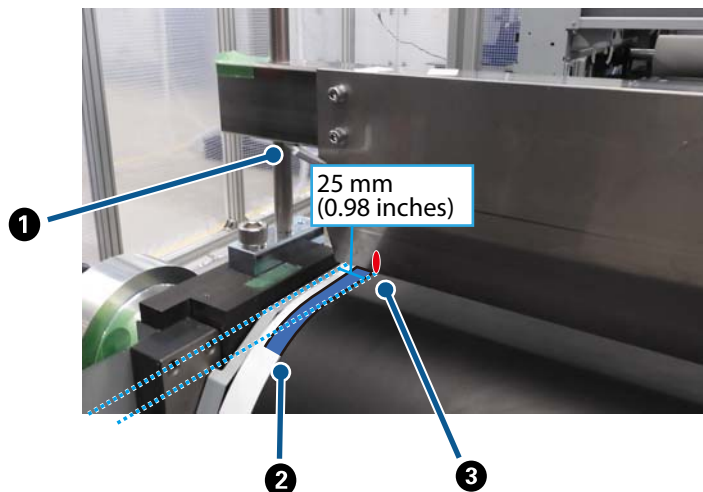
🔗 [“Installing the blade” on page 413](#)

1. Before applying the tape, insert a hex key or a similar tool into the hole in the blade support to raise the blade for installation.



2. Mark the blade 25 mm (0.98 inches) from the edge of the belt.

3: Align the edge of the tape with the mark on the blade and stick it in place.



- ① Hex key
- ② Tape
- ③ Mark

2

Worker 1: While gripping the insulating tape attached to the belt with your hand, pull the tape straight out along the edge of the belt.

Worker 2: Press and hold the backfeed button on the front panel to rotate the belt in the reverse direction.



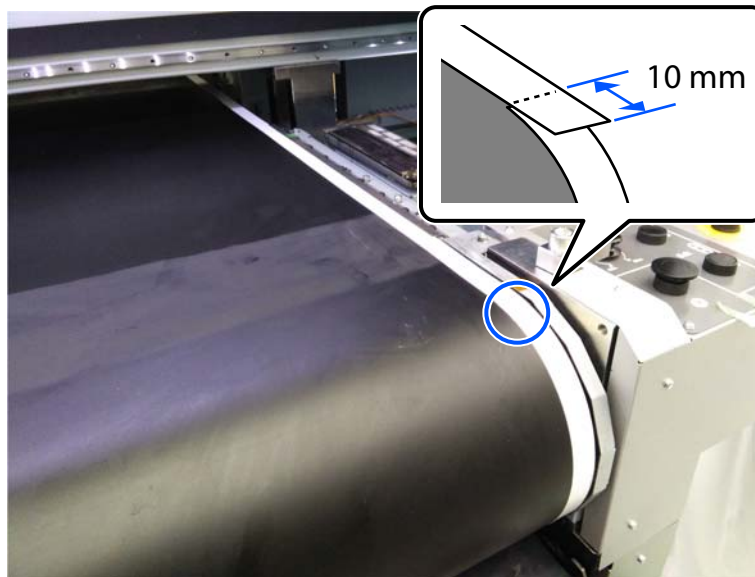
Important:

If air bubbles are formed or the tape swerves midway, peel off the tape and reapply new tape.

Maintenance

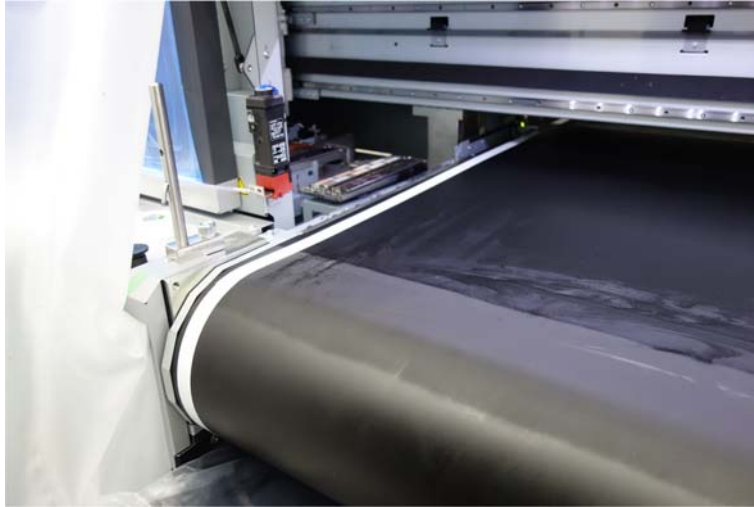


- 3** Worker 1: Cut and apply the tape so that the joins in the tape overlap by approximately 10 mm (0.39 inches).
Worker 2: When you have finished applying the tape to the belt all the way around, release the button to stop the belt.



Maintenance

- 4** Apply tape to the opposite side of the belt, in the same way as Steps 1 to 3.



- 5** Press and hold the backfeed button on the front panel to slowly rotate the belt as you check that the tape is not rising up and there is no foreign material on the belt. Press down any areas of tape that are floating up, and remove any foreign material using a wipe cloth or the like.



Important:

If the tape is floating up, friction with the blade could cause the tape to tear during glue application. If the tape tears, the glue cannot be applied uniformly; therefore, the tape must be reapplied.



Installing the blade

Prepare to apply the glue uniformly on the belt.

Maintenance

- 1 Use a wipe cloth soaked in ethanol (proper amount) to clean the sharp edge of the blade.

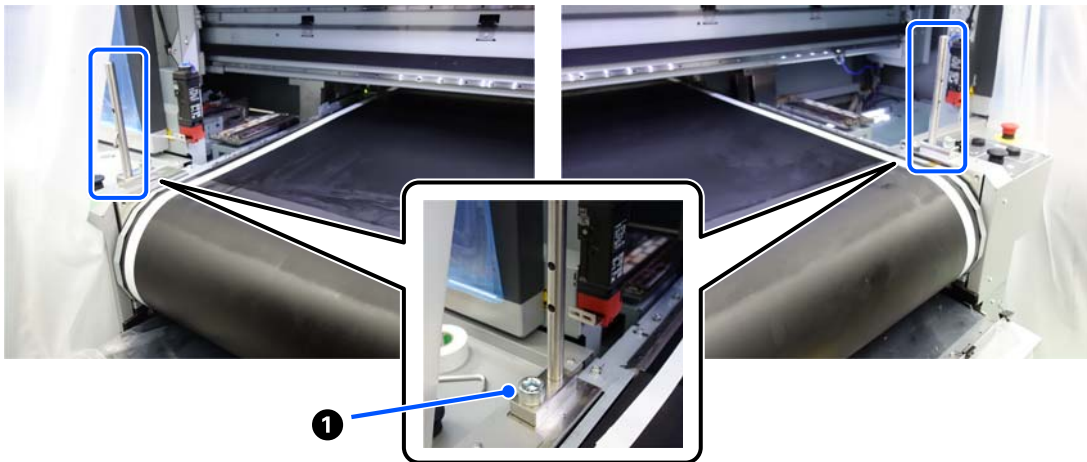


Important:

Do not place the blade on the floor with the sharp edge facing down, or bump it against other objects. Doing so may damage the blade and prevent the glue from being applied evenly.



- 2 Attach the blade supports to the machine.
Loosely tighten the bolt by hand.
Attach the blade support on the opposite side of the belt as well, in the same way.



- 1 Bolt

- 3 Have two or more people lift up the blade and pass the blade supports through the holes on both ends of the blade.

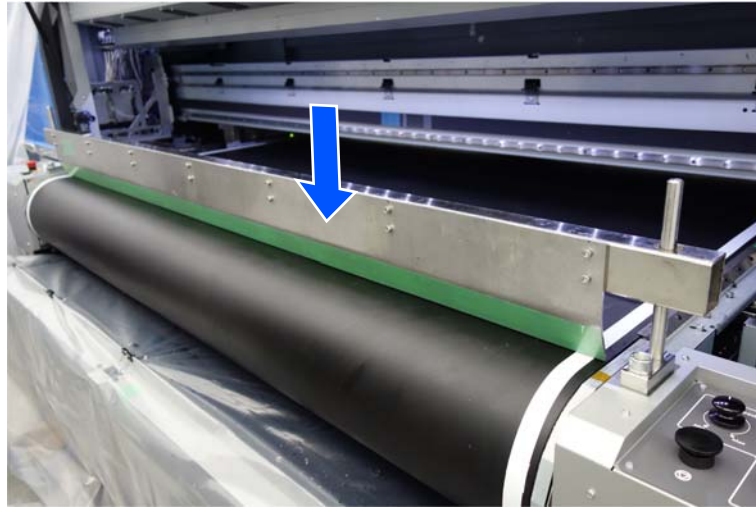
Lower the blade slowly and evenly on both sides to avoid damaging the belt.



Warning:

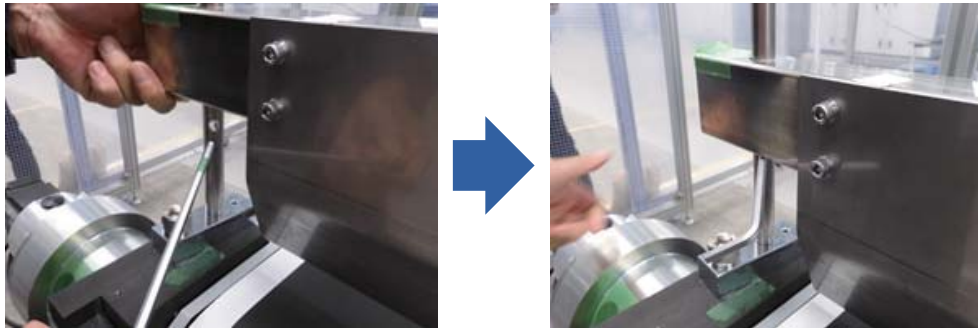
Be careful not to get your hands caught between the belt and the blade when lowering the blade.

Maintenance

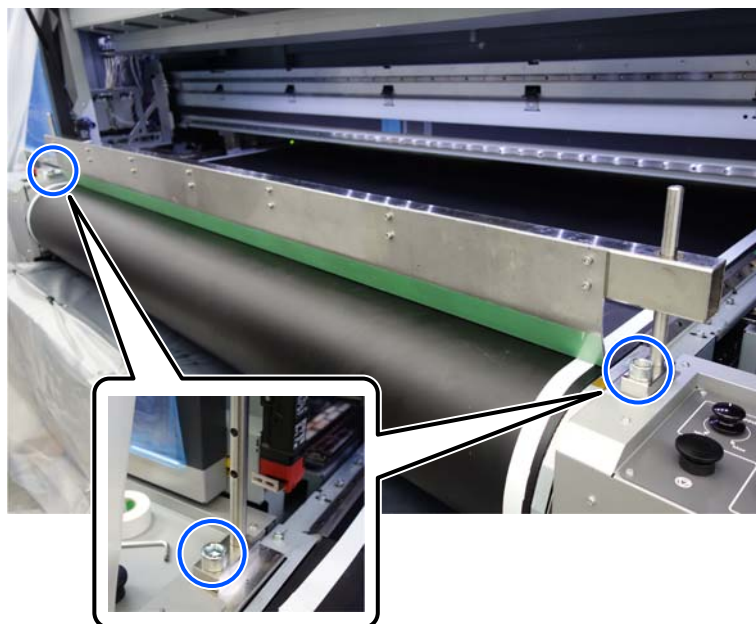


Note:

You can temporarily lift the blade from the belt by inserting a hex wrench or the like in the hole of the blade support.

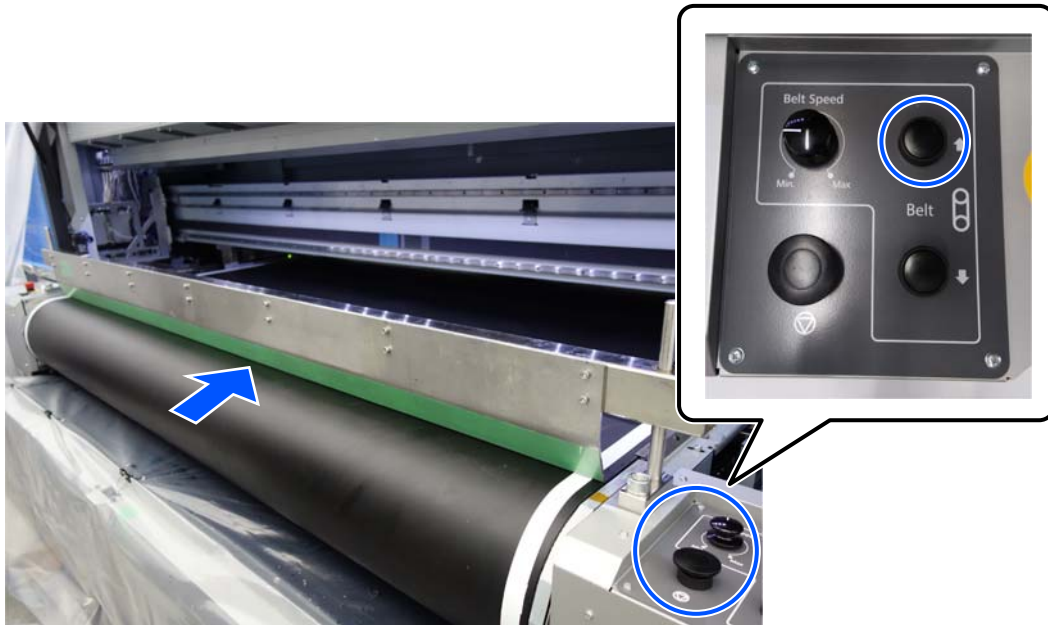


- 4 Firmly tighten the hexagonal screws of both blade supports.



Maintenance

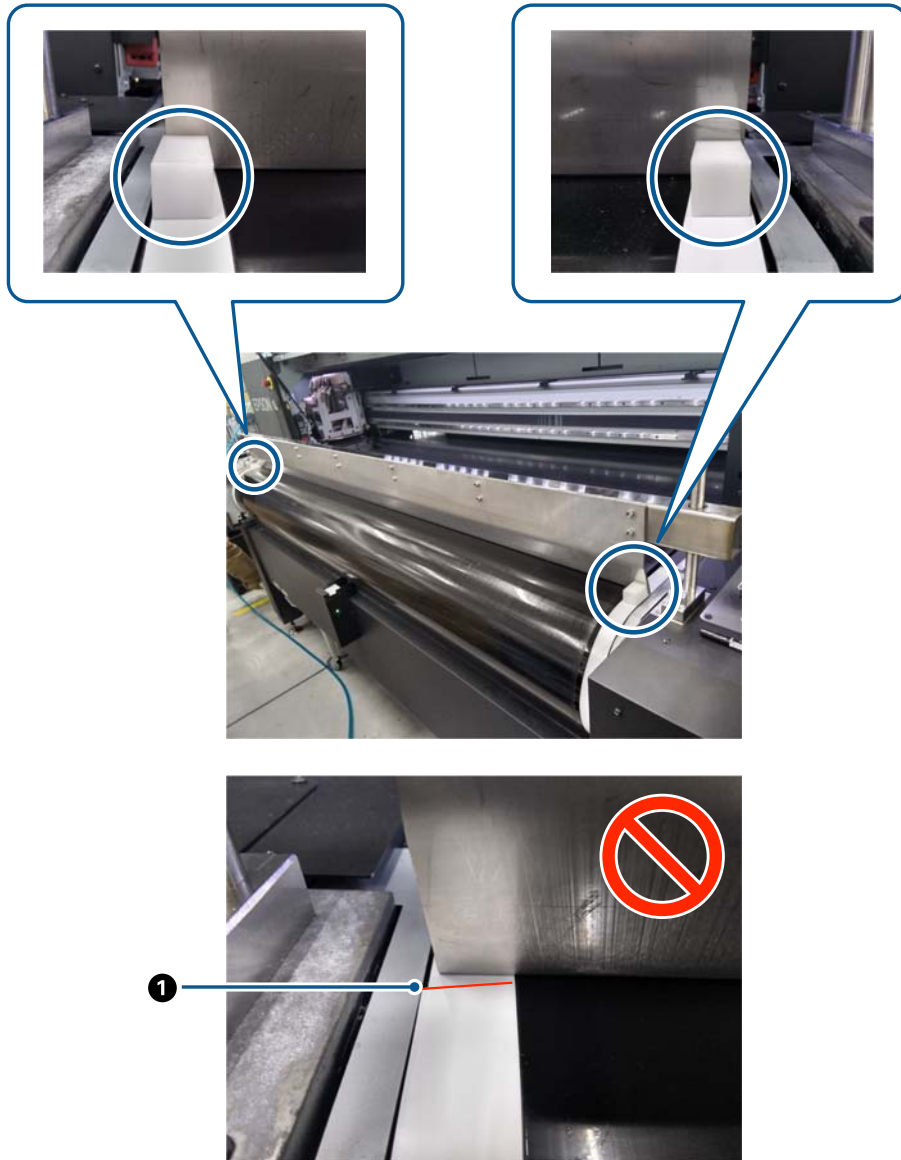
- 5 Press the backfeed button on the front panel to feed the belt in the reverse direction by approximately 10 cm (0.39 inches). This operation sets the blade at a slight angle against the belt. This completes the blade installation procedure.



Maintenance

- 6** Place one glue block on each end of the belt so that it is aligned with the edge of the blade.

When placing the blocks, do not place them at a point where the insulating tape overlaps where it is attached to both ends of the belt. When the tape overlaps at the position where you want to place the blocks, feed the belt to a point where the tape does not overlap.



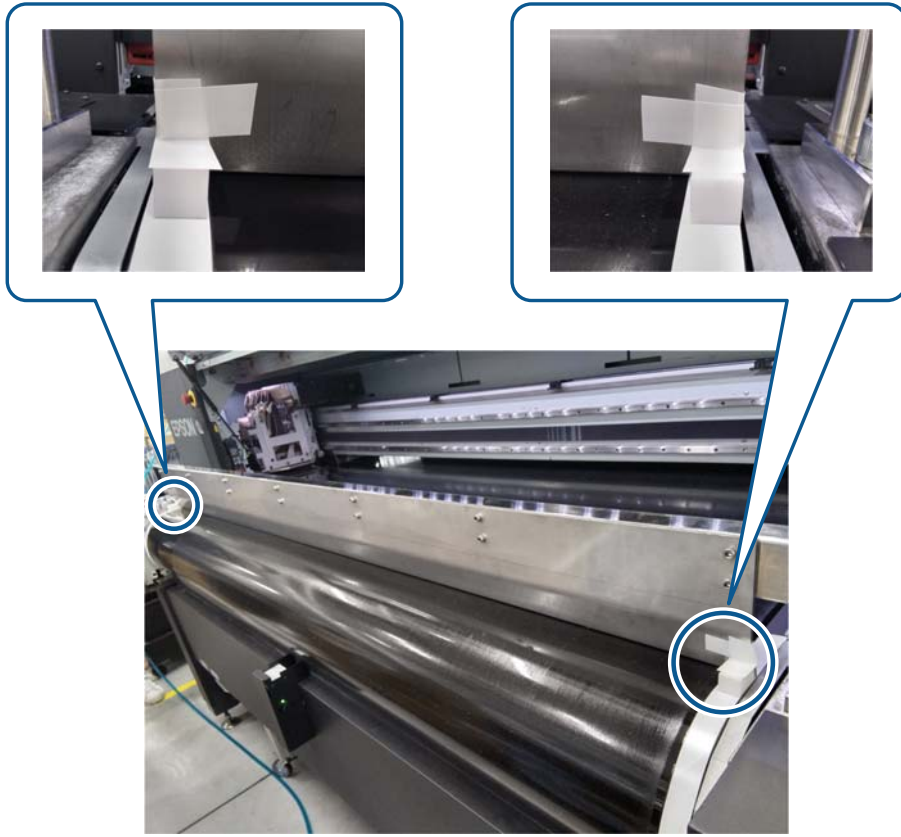
- 1** Overlapping insulating tape

- 7** Secure the glue blocks to both ends of the blade with insulating tape so that there are no gaps at the following points.

- Between the block and the belt

Maintenance

- ❑ Between the block and the blade



Maintenance



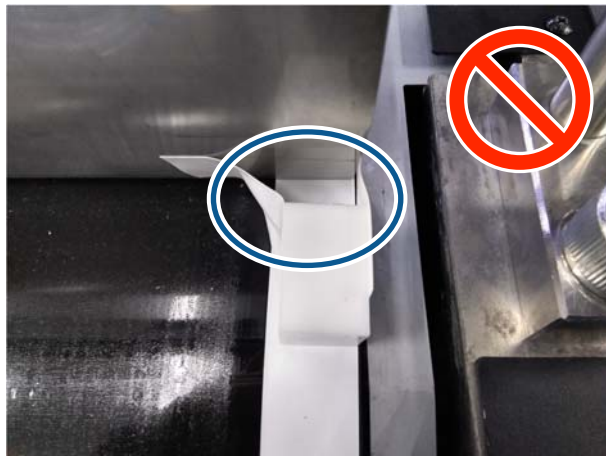
Caution:

Do not secure the block under the following conditions. Otherwise, the glue may not be applied evenly, or the glue may enter the printer from the edge of the belt causing the printer to malfunction.

- ❑ If there is a gap between the block and the belt



- ❑ If there is a gap between the block and the blade



- ❑ If the block is at an angle



Maintenance

Ensuring safety

Perform ventilation and wear protective equipment, referring to the instructions of the SDS for the glue and glue remover you are actually using, as well as the laws and regulations in your country.

Mixing the glue

Mix the glue to be used.

- 1 Set the glue bucket on the scale and pour in glue A.
Pour glue into the bucket slowly along the bucket side, to avoid the glue forming bubbles in the bucket.



- 2 Add glue B into the bucket containing glue A.
The weight of the bucket will be 1720 g (1.92 L).



Maintenance

- 3 Use the stirring rod for preparing glue to mix together glue A and glue B in the container. Mix slowly to avoid trapping air.



- 4 Preparation is complete when the colors of the 2 glues are blended.

Applying Glue

Apply the glue you prepared to the belt.

- 1 Touch the **Reverse** button on the control panel.

The belt continues to move in reverse.

- 2 Pour a proper amount of glue to right next to the blade. Pour uniformly from one end of the belt to the other.



It is not necessary to pour all of the glue at once.

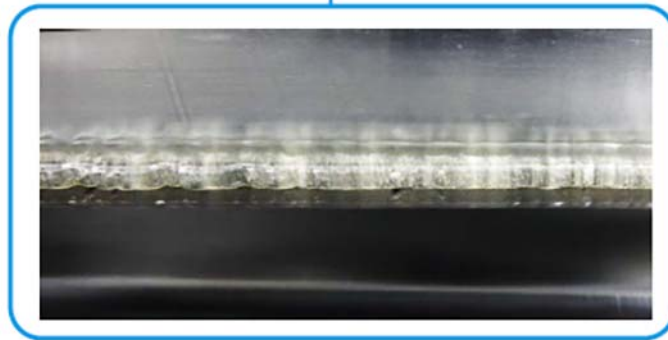
As the glue accumulates in front of the blade, rotate the belt to apply glue slowly to the belt surface through the gap between the blade and belt. As the glue decrease, pour in a proper amount of more glue.

Maintenance



Important:

If you pour too much glue or there is insufficient glue for too long, the belt may become uneven, requiring the glue to be reapplied.



3

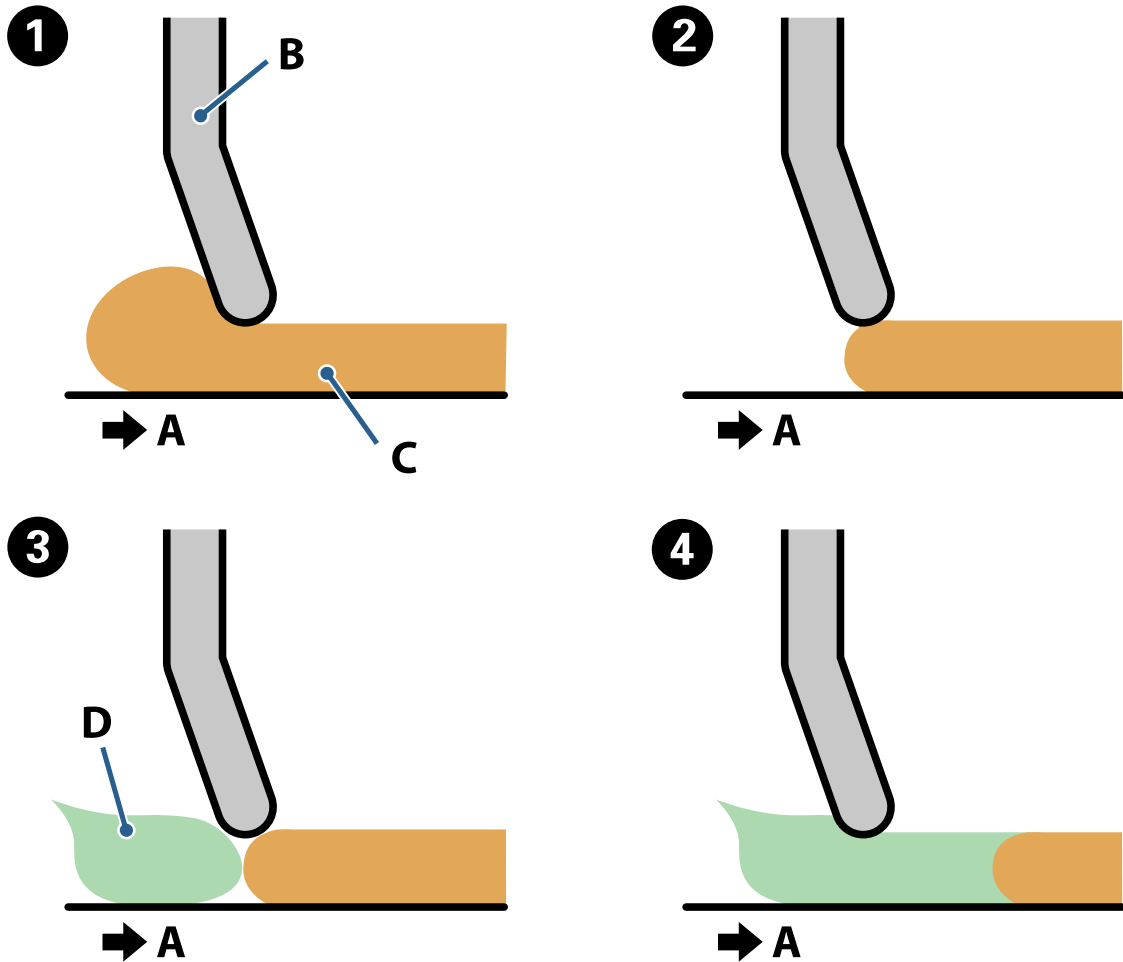
Once you have poured all the glue, wait until only a small amount of glue remains in front of the blade.

Maintenance

- 4** Immediately after the glue accumulated in front of the blade has been completely used, spray soapy water on the entire belt. If the glue usage is not evenly distributed, spray the local area with soapy water avoiding areas where the glue remains.

When to spray with soapy water

The illustration shows a side view of the gap between the blade and the belt. As soon as the glue starts to flow and is no longer visible from the front of the blade, spray it with soapy water (illustration ③).



A: Belt rotation direction

B: Blade

C: Glue

D: Soapy water

① : Glue has accumulated in front of the blade.

② : Glue in front of the blade is running low. Prepare soapy water.

③ : Glue is no longer visible from the front of the blade. Spray with soapy water at this time.

④ : Soapy water is flowing under the blade. Once you have sprayed the area with soapy water, always spread the soapy water out so that it does not dry out.

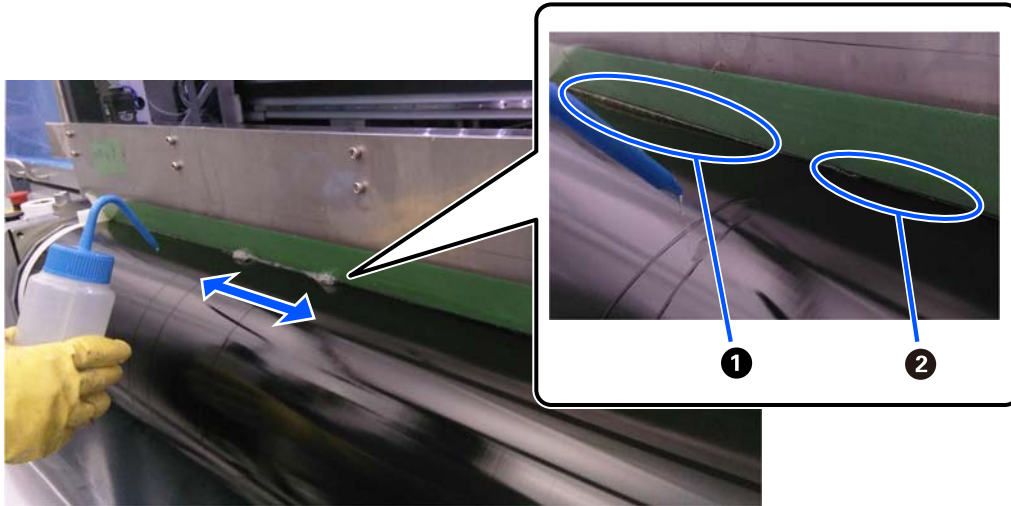
The soapy water acts as a lubricant so the blade slides smoothly on the belt.

Once you have sprayed the area with soapy water, always spread the soapy water out so that it does not dry out.

Maintenance

! **Important:**

Be sure to spray the entire belt with soapy water right after the glue runs out. If the soapy water is applied too late, the vibrations from the blade could cause unevenness in the belt surface. Unevenness may result in poor print quality.



- ① Part with accumulated glue
- ② Part without glue

5

Check that the glue accumulated in front of the blade has been completely used and soapy water is applied to the entire belt.

! **Important:**

Do not stop the belt, but ensure it continues rotating. Stopping the belt with the blade attached could cause unevenness in the belt surface.

Blade removal and cleaning

Remove the blade that was attached to the belt and clean the blade.

1

Two people are required to lift the blade simultaneously on both left and right sides and remove it.

! **Important:**

Lift the blade so that it does not come in contact with the belt. Any contact may cause unevenness on the belt surface, resulting in poor print quality.

Maintenance



2

If any glue got on the blade or blocks, wipe it clean using an ethanol-soaked wipe cloth. If the dirt cannot be removed, soak a wipe cloth in glue remover to wipe it off. Dispose of the used wipe cloths in the proper manner for industrial waste.



Important:

- ❑ Do not place the blade on the floor with the sharp edge facing down, or bump it against other objects. Doing so may damage the blade and prevent the glue from being applied evenly.
- ❑ If glue or dirt remains on the blade, it may not apply glue uniformly.

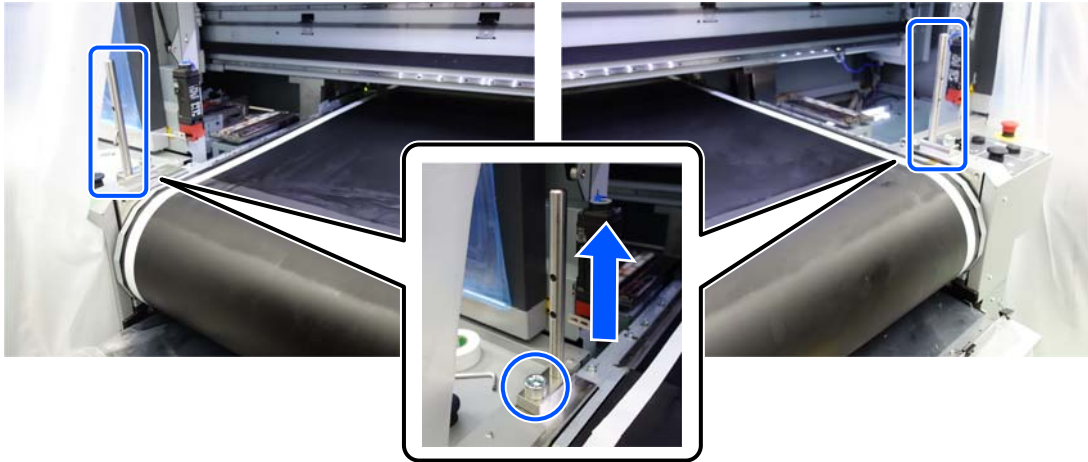


3

Use wipe cloths or the like to absorb any remaining solvents, and then dispose of them in the proper manner for industrial waste.

Maintenance

- 4 Loosen the hexagonal screws on both blade supports and remove them from either side of the belt.



- 5 Touch the **Suspended** button on the control panel.

Drying the glue

Dry the glue applied to the belt.

- 1 Reduce the belt speed.

The speed is indicated by the arrows shown in the illustration (belt speed dial: 0 to 30 degrees position).



- 2 Touch the **Forward** button on the control panel.
Rotate for two hours to allow the glue to dry.
- 3 Touch the **Suspended - Done** buttons on the control panel in that order.
- 4 Press the Pause/Restart button on the water recycling unit.
The water recycling unit starts operating again, and the cleaning water flows into it.
- 5 Close the front cover and leave it for at least 8 hours to allow the glue to dry.

Confirmation after glue application

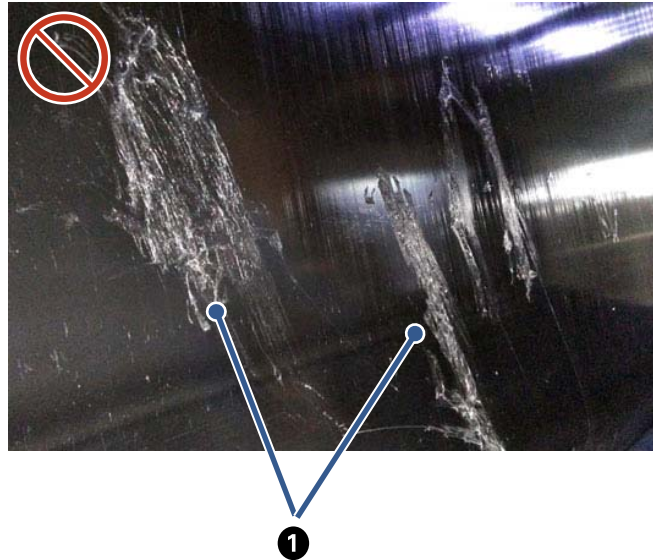
Check the condition of the glue applied to the belt.

Maintenance

❑ Entire belt

Rotate the belt once to check for any obvious unevenness on the belt surface.

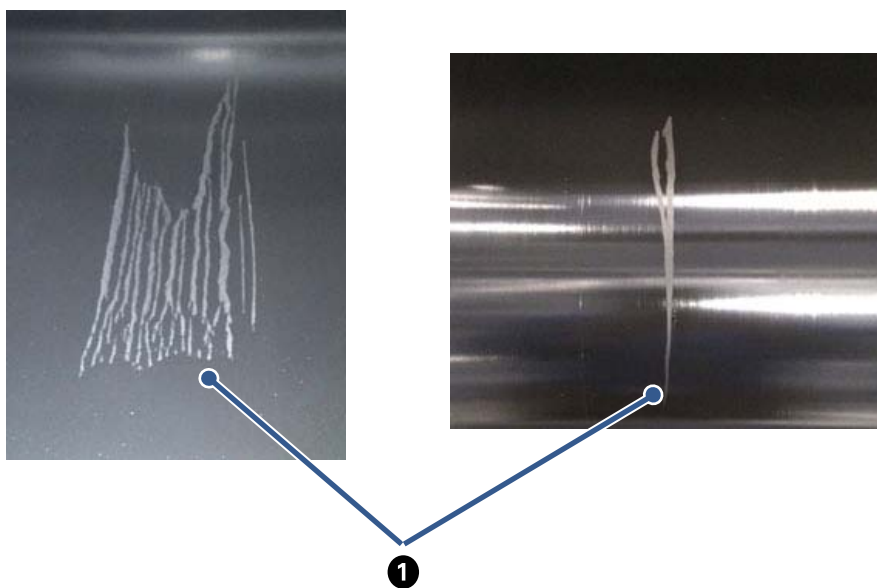
Unevenness as shown in the figure below may result in poor print quality.



❶ Unevenness on the belt surface

If there is any unevenness, remove and reapply the glue.

The condition shown below, where the glue applied to the belt is partially peeling off, occurs when the soapy water is applied too late or it dries up in the middle of the process. However, this does not affect the adhesion of the glue.

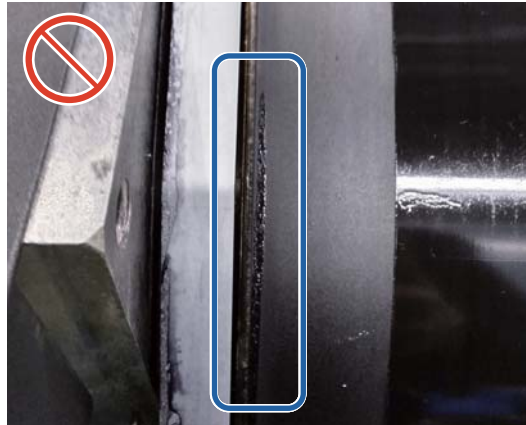


Maintenance

- ❑ Both ends of the belt

Make sure there is no glue or tape adhering to both ends of the belt.

Adhesion of the same may prevent the normal measurement of the belt feed rate. Remove the tape or wipe the glue clean with a cloth soaked in an appropriate amount of ethanol.



Work after glue application

Clean the belt and prepare for printing.



Caution:

The belt cleaning unit weighs over 110 kg, so make sure you bend your knees sufficiently and work in a natural position.

Pulling or pushing the unit with incorrect posture can lead to injury and back pain.

1

After leaving it for 10 hours or more, peel off the insulating tape.

Worker 1: Peel the end of the insulating tape and hold it as you peel the tape from the belt.

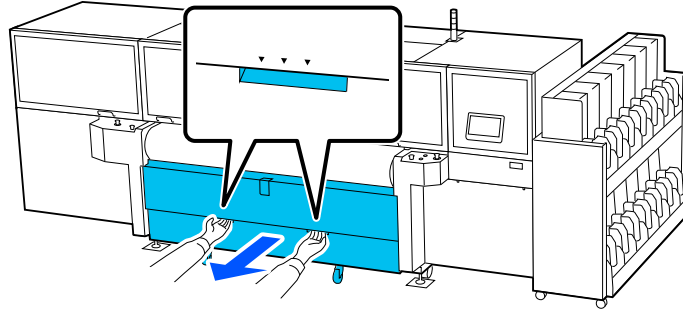
Worker 2: Press and hold the feed button on the front panel to slowly rotate the belt in the forward direction.

Peel the insulating tape on the opposite side in the same way.



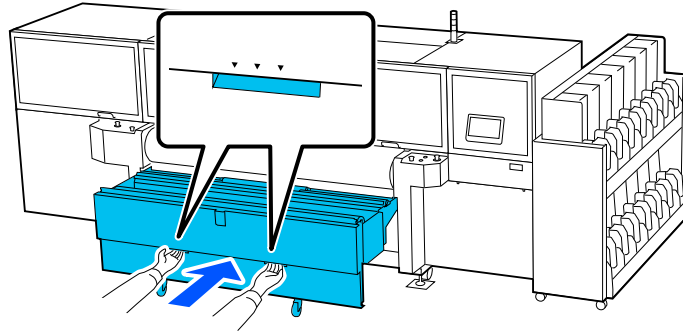
Maintenance

- 2 Hold the handles at the front of the belt cleaning tank, and pull out the belt cleaning tank.



- 3 Remove the protective tape and plastic sheet covering the lower part of the printer and the belt cleaning unit cover.

- 4 Push the belt cleaning unit back to its original position.



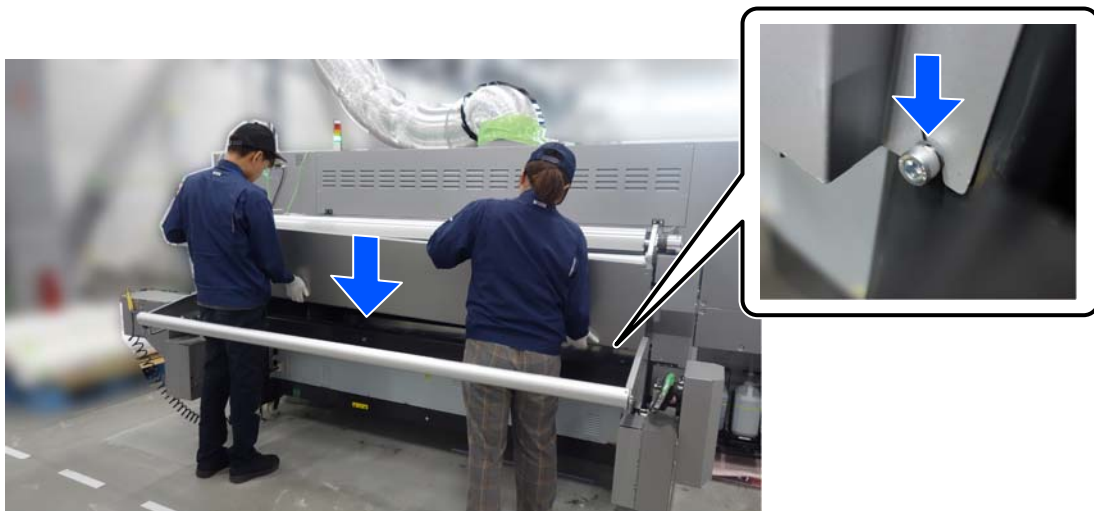
- 5 Move to the rear of the printer and lower the tension bar.



! **Important:**
Steps 6 to 8 should be performed by at least two people.

Maintenance

- 6 Attach the exterior panel to the rear of the printer.
Fit the grooves at the bottom of the exterior panel over the two bolts.

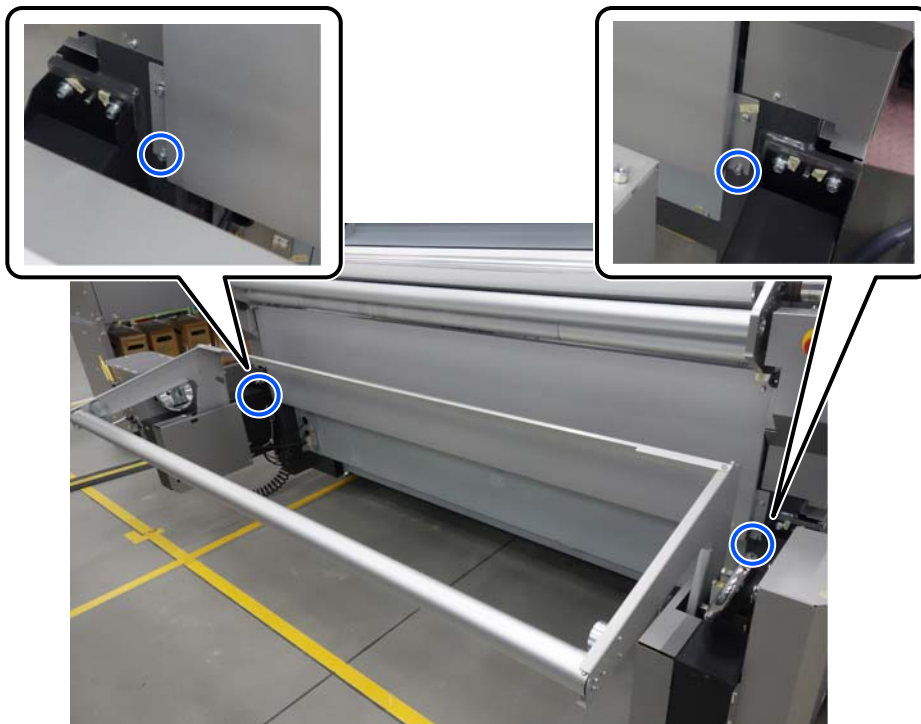


Maintenance

- 7** While supporting the exterior panel to prevent it from falling, tighten the four bolts at the top of the exterior panel using a hex wrench.

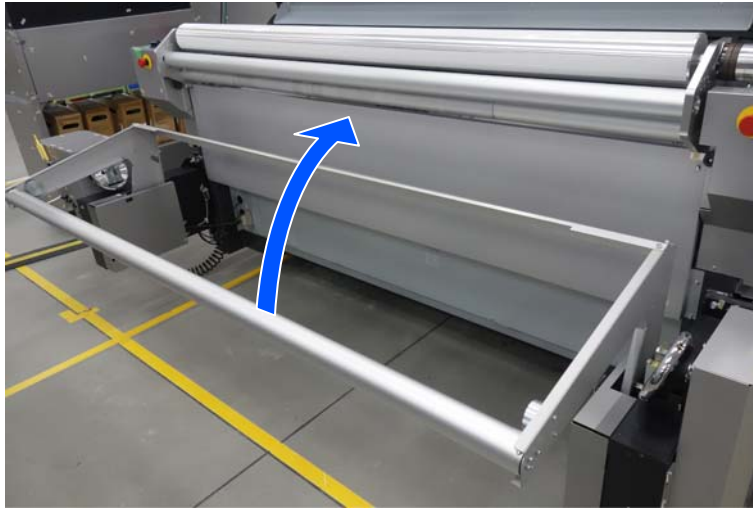


- 8** Tighten the two bolts at the bottom of the exterior panel using a hex wrench.



Maintenance

- 9 Lift up the tension bar.



- 10 From the Maintenance screen on the control panel, touch **Maintenance**, and then touch **Belt Cleaning**.
- 11 Set **Belt speed** to **Normal**, and then touch **OK** at the top-right of the screen.
Set the belt rotation speed to **Normal**.
- 12 Set **Number of cleaning cycles** to **1**, and then touch **OK** at the top-right of the screen.
The number of cleaning cycles for the belt is set to one.
- 13 Check the message on the **Belt Cleaning** screen, and then touch **Start**.
Belt cleaning begins.
- 14 Open the front cover.
- 15 Use wipe cloths to wipe off any water droplets on the belt surface.
- 16 Close the front cover.

Water droplets may remain on the belt even after applying glue to the belt.

See the following if water droplets remain on the belt.

 [“Water droplets remain on the belt after belt cleaning” on page 464](#)

Disposal of Used Consumables

The following used consumables with ink, glue, or glue remover on them are classed as industrial waste.

Maintenance

- Ink cartridges
- Cleaning stick
- Cleaning liquid or maintenance liquid
- Waste ink
- Waste ink bottle
- Wiper Roll
- Inner pad
- Inner porous pad
- Mist filter
- Washing Scraper
- Tools used in glue removal or application
- Fabric that has been printed on

Dispose of items according to local laws and regulations. For example, contract an industrial waste disposal company for disposal. In such cases, submit the "Safety data sheet" to the industrial waste disposal company. The Safety Data Sheet can be downloaded from the Epson website.

Control Panel Menu

Control Panel Menu

The following items and parameters can be set and executed in the Menu.

General Settings Menu

* indicates default settings.

Item	Parameter	Description
Basic Settings		
LCD Brightness	1 to 9 (9*)	Adjusts the brightness of the control panel display.
Sound		
Button Press	0 to 3 (1*)	Sets the volume of the sounds when the power button and control panel screen are operated.
Alert	0 to 3 (2*)	Sets the volume of the sounds when hardware, such as the covers and fabric loading lever, is operated.
Completion Notice	0 to 3 (3*)	Sets the volume of the sounds when print jobs or maintenance operations are finished.
Warning Notice		Sets the volume and the repetitions of sounds when it is time to replace consumables.
Volume	0 to 3 (2*)	
Repeat	Never* Until Stopped	
Error Tone		Sets the volume and the repetitions of sounds when an error occurs while printing and printing cannot continue.
Volume	0 to 3 (3*)	
Repeat	Never Until Stopped*	
Sound Type	Pattern1	Sets the type of sounds. Sounds that are easy to hear in the printer's operating environment can be set.
	Pattern2	
	Pattern3*	

Control Panel Menu

Item	Parameter	Description
Sleep Timer	1 to 240 (15*)	<p>The printer enters sleep mode after a specified time during which no print jobs are received, no errors are detected, and the heater is off. In sleep mode, the control panel screen turns off.</p> <p>The screen display recovers when you touch the control panel screen. Sleep mode is canceled and the printer returns to normal when a print job is received or an operation involving printer hardware is done, such as operating the fabric loading lever.</p>
Date/Time Settings		
Date/Time		Set the printer's built-in clock. The time set here is displayed on the Home screen.
Daylight Saving Time	Off*	When set to On , it displays the time one hour earlier than the set time.
	On	
Time Difference	-12:45 to +13:45	Set the time difference with coordinated universal time (UTC) in 15 minute increments. In network environments with a time difference, set this as necessary when administrating the printer.
Language	Japanese	Select the language used in the control panel display.
	English	
	French	
	Italian	
	German	
	Portuguese	
	Spanish	
	Dutch	
	Russian	
	Turkish	
	Korean	
	Simplified Chinese	
Traditional Chinese		

Control Panel Menu

Item	Parameter	Description
Screen Customization		Select the color scheme used in the control panel display. You can set a color scheme that is easy to see in the environment in which the printer is installed.
Background Color	Gray	
	Black*	
	White	
Display Information While Printing		Select the items you want to display on the control panel during printing.
Print Information	Printed Length	
	Remaining Print Length*	
Throughput	Print Length per Hour*	
	Print Area per Hour	
Pass Mode		
Keyboard	QWERTY*	Select the keyboard layout for the text input screen that appears, such as when inputting names to register for media settings.
	AZERTY	
	QWERTZ	
Unit Settings		
Length	m*	Choose the units of length used in the control panel display and when printing test patterns.
	ft/in	
Temperature	°C*	Choose the temperature units used in the control panel display.
	°F	
Screen Effect	On	Select On to enable animations when switching screens. Select Off to make screen transitions faster.
	Off*	
Printer Settings		

Control Panel Menu

Item	Parameter	Description
Margin between Jobs	0 to 999 mm (0 to 39.33 inches) (10 mm [0.39 inches] [*])	Set the margin between print jobs.
Print Start Position	27 to 1000 mm (1.06 to 39.37 inches) (55 mm [2.17 inches] [*])	Set the distance from the right edge of the belt (standard position) to the position where you want to start printing. 🔗 "Setting the Print Start Position" on page 90 🔗 "Setting the Print Area and Print Position" on page 118
Print Width	300 to 1850 mm (11.81 to 72.83 inches) (1100 mm [43.31 inches] [*])	You can set the Print Width on the printer and on the application. The narrowest Print Width setting will take priority. The Print Width on the printer is set when determining the flushing position on the belt and the Information Printing position. We recommend setting this to 1850 mm when not using flushing on the belt or Information Printing.
End Detection	On [*]	This function detects the end of the fabric and then stops printing.
	Off	When this is set to Off , you can print right to the end of the fabric, but we cannot guarantee the print quality or operation with externally connected devices. Additionally, ink may be wasted as printing continues even if the fabric runs out. Normally, set this to On before use.
Job Connection	On [*]	Starts printing the next job without feeding fabric, drying, or rewinding between continuous print jobs. There are no operations between jobs so printing time is that much shorter.
	Off	If there are six or more print jobs and the print length for six jobs is 120 mm or less, the sixth and subsequent jobs will not be connected. When Job Connection is set to On , make sure that all of the following items in the print jobs settings menu are set to the same settings. If the settings are different, you cannot perform Job Connection even if it is set to On . <input type="checkbox"/> Resolution <input type="checkbox"/> Passes <input type="checkbox"/> Bidirectional Printing <input type="checkbox"/> Advanced Quality <input type="checkbox"/> Carriage Speed When using Epson Edge Print, if you cannot connect the jobs even if all of the above items are set to the same settings, select Step and Repeat - Enable Setting in the Job Setting menu. For details, see the help for Epson Edge Print.


Control Panel Menu

Item	Parameter	Description
Information Printing		
	Off*	When this is turned to On , marks and the nozzle check pattern are printed on the edge of the fabric, so it is easier to check print quality.
	On	
	Margin Between Images	Margin Between Images: Set the interval between images and the marks and check patterns.
	Print Position	Print Position: Set Next to the Image to print in the position open between the margin between images using the edge of images as a reference. When Fabric End is set, printing is done in the position using the edge of the fabric as a reference.
	Event Marking	Event Marking: When this is turned to On , a mark is printed when an event that affects print quality occurs while printing. This makes it easier to find poor quality areas during and after printing. The following events cause a mark to be printed.
	Off	
	On*	<input type="checkbox"/> Change in nozzle clogging: When there is a change in nozzle clog conditions after printing starts <input type="checkbox"/> Head cleaning: When head cleaning is executed manually <input type="checkbox"/> Automatic head cleaning: When automatic head cleaning is executed <input type="checkbox"/> Head striking: When the striking of the fabric and print head is detected <input type="checkbox"/> Suspension: When printing is suspended <input type="checkbox"/> Start of nozzle compensation
	Print Position	
	Left*	
	Right	
	Left and Right	
	Nozzle Check Pattern	Set a position, in which marks are easy to check, in Print Position .
	Pattern Selection	
		Nozzle Check Pattern: When pattern selection is Normal or Fabric Width Saving , the nozzle check pattern prints continuously during printing. When printing a series of print jobs or a long job, you can immediately identify if the nozzles are clogged during printing. The width of the check pattern is narrower than Normal when Fabric Width Saving is set, so the image print area is wider. Set a position, in which check patterns are easy to check, in Print Position . When Print Head Nozzle Limitation is set to On , printing nozzle check patterns is disabled.
	Do Not Print	
	Normal*	
	Fabric Width Saving	
	Print Position	
	Left*	
	Right	
	Left and Right	

Control Panel Menu

Item	Parameter	Description
Actions after Media Scuffing	Stop Immediately*	Stops at the set time when the head strike sensor detects fabric friction.
	Stop when Continuously Detected	
	Ignore	
Cut Sheet Mode	On	When On is selected, the settings for the External Drying Reel, Feeding Unit, Belt Cleaning, and Heated Pressure Roller are disabled (forced to Off). It is useful to set this to On when using cut paper or pieces of fabric for test printing. When this mode is set to On , the settings for the items above cannot be changed. Additionally, a confirmation message is displayed asking if you want to continue printing in this mode before printing starts.
	Off*	
External Drying Reel	On	Set this to On if feeding the printed fabric to a rewinding dryer.
	Off*	
Feeding Unit	On*	While the fabric is being conveyed on the belt, the feeding spindle rotates to feed the fabric from the fabric roll.
	On(External Feeding Unit)	
	Off	
Belt Cleaning	On*	When you press the feed button or start printing, the belt cleaning tank rises, and belt cleaning is consistently performed during printing. The belt cleaning tank automatically lowers when you press the backfeed button or when you have not been printing for a certain period of time.
	Off	
Water Supply Amount	Low Amount	Select the amount of water to be supplied to the belt cleaning tank. You do not need to make this setting when using the water recycling unit. If the belt gets dirty even when set to Standard , set it to High Amount .
	Standard*	
	High Amount	
Heated Pressure Roller	Simultaneous Swing with Feed*	To seal the fabric to the belt, the heated pressure roller is lowered toward the belt and also moves back and forth horizontally during printing. Simultaneous Swing with Feed activates the heated pressure roller while the belt is fed in the forward/reverse direction. When printing using one pass, the operation remains the same as Periodic Swing to prevent the printer from malfunctioning, even when set to Simultaneous Swing with Feed . Periodic Swing activates the heated pressure roller at regular intervals regardless of the belt movement. If you select Off , the heated pressure roller remains away from the belt.
	Periodic Swing	
	Off	


Control Panel Menu

Item	Parameter	Description
Tangled Fabric Detection	On*	Detects when fabric gets tangled under the machine.
	Off	
Belt Feed Measurement Sensor	On*	Function for feeding the belt accurately. Do not set this to Off except when printing using one pass and when a malfunction occurs. When printing using one pass, this setting is disabled to prevent the machine from malfunctioning.
	Off	
Fabric Floating Sensor		<p>Detects curling and floating of the fabric. When detected, the machine stops operating.</p> <p>Sensor Sensitivity sets the height at which the fabric is detected to be curled or floating.</p> <p>We recommend that you leave this function turned On. If printing is executed with the fabric still curled, the fabric may come into contact with the print head, which may damage the print head.</p>
On*		
Sensor Sensitivity	-2.0 to 2.0 mm (-0.079 to 0.079 inches) (0.0 mm [0.000 inches]*)	
Off		
Nozzle Check between Jobs		<p>If you set Nozzle Check between Jobs to On, the nozzle check pattern is printed after job printing ends.</p> <p>When printing is complete, you can visually inspect the check pattern to determine whether there may be faint or missing colors in the preceding or following printout.</p>
Nozzle Check between Jobs	On	
	Off*	
Job(s)	1 to 9999 job(s)	
Inside Light	Auto*	<p>Select whether to turn on/off the light inside the front cover automatically (Auto) or whether to use the panel button as necessary (Manual).</p> <p>In Auto, the light turns on automatically when printing and so on, and turns off when the operation is complete.</p> <p>In Manual, you need to touch  on the control panel to turn the light on/off.</p>
	Manual	
Restore Default Settings	Network Settings	Executing Network Settings restores all the detailed settings in network settings to their default setting values.
	Clear All Data and Settings	Executing Clear All Data and Settings restores all menu settings to their default setting values.
Maintenance Setting		

Control Panel Menu

Item	Parameter	Description
Cleaning Setting		The machine constantly monitors the clogging status of the print head nozzles during printing.
Threshold of Clogged Nozzles	1 to 50 (15*)	<p>During printing, when a clogged nozzle is detected exceeding the value set in the Threshold of Clogged Nozzles, the item selected from Stop Printing, Show Alert, and Auto Cleaning in Actions Beyond the Threshold of Missing Nozzles will be executed. When Auto Cleaning is selected, Print Head Cleaning is performed.</p> <p>Here, set the Max Retry Cleaning Count and Maintenance Schedule when Auto Cleaning is selected under Actions Beyond the Threshold of Missing Nozzles.</p> <p>Max Retry Cleaning Count sets the maximum number of times Print Head Cleaning should be repeated if the nozzle is not unclogged after the Print Head Cleaning is performed.</p> <p>The Maintenance Schedule sets whether the Print Head Cleaning should be performed between the completion of printing a nozzle-clogged job and the start of printing the next job (Between Jobs) or immediately after the detection of a clogged nozzle (When Detected) and after printing is stopped. When set to When Detected, Print Head Cleaning is performed during the printing process, which may result in erratic printing and head rubbing.</p>
Max Retry Cleaning Count	0 to 2 (0*)	
Maintenance Schedule	Between Jobs*	
	When Detected	
Nozzle Compensation	On*	When set to On , the printer uses normal nozzles to compensate for the lack of ink that could not be dispensed due to clogged nozzles.
	Never	
Periodic Cleaning		When On is set, cleaning is performed at the interval set for one of Print Duration, Print Jobs, or Print Length .
On		
Print Duration	1 to 9999 minutes (120)	
Print Jobs	Every 1 to 9999 job(s) (1)	
Print Length	1 to 9999 m (3.28 to 32805.12 ft) (333 m [1092.52 ft]*)	
Off*		

Control Panel Menu

Item	Parameter	Description
Actions Beyond the Threshold of Missing Nozzles	Stop Printing	<p>Sets the action to be taken when the number of clogged nozzles exceeds the number set in the Threshold of Clogged Nozzles under the Cleaning Setting during printing.</p> <p>When Stop Printing is set, the message The Print head may require maintenance. It is recommended to perform a Print Head Nozzle Check before printing. is displayed on the control panel screen, printing stops, and the printer enters standby status. If you select Show Alert, the above message is displayed, but printing continues without stopping.</p> <p>When Auto Cleaning is selected, the print head is cleaned at the timing set in the Maintenance Schedule under the Cleaning Setting.</p>
	Show Alert*	
	Auto Cleaning	
Maintenance Cleaning		<p>When the printer is not used for a certain period of time, print head cleaning is automatically performed at intervals set in the Interval. This setting is not available for some ink types. This cleaning ejects sedimented ink in the ink tubes to prevent print quality from falling.</p>
On*		
Interval	1 to 2400 hours (720)	
Off		
Flush on Belt	On	<p>When On is set when the print width or fabric width is narrow, the print head does not move to the flushing boxes on the left and right of the printer, but performs flushing on the belt. As this reduces the travel distance of the print head, it improves productivity.</p> <p> "Setting the Print Area and Print Position" on page 118</p>
	Off*	
Network Settings		

Control Panel Menu


Item	Parameter	Description
Network Status	Wired LAN Status	You can check batches of a variety of information in network settings that are set in Advanced. When Print Status Sheet is selected, a list is printed.
	Print Status Sheet	
Advanced		Do a variety of network settings.
Device Name		
TCP/IP		
Proxy Server		
IPv6 Address	Enable*	
	Disable	
Link Speed & Duplex	Auto*	
	100BASE-TX Auto	
	10BASE-T Half Duplex	
	10BASE-T Full Duplex	
	100BASE-TX Half Duplex	
	100BASE-TX Full Duplex	
Redirect HTTP to HTTPS	Enable*	
	Disable	
Disable IPsec/IP Filtering		
Disable IEEE802.1X		

Fabric Settings Menu

* indicates default settings.

Item	Parameter	Description
Current Settings		

Control Panel Menu







Item	Parameter	Description
Fabric	01 XXXXXXXXXXXX to 50 XXXXXXXXXXXX	Choose the fabric settings to use. The registered name appears in XXXXXXXXXXXX.
Fabric Type		Choose the fabric type to use.
Fabric Thickness		Set the Fabric Thickness. If the fabric does not have a consistent height, such as for shaggy fabric, enter the average value.
Head Height		We recommend setting 0.7 mm (0.03 inches). A minimum height of 2 mm (0.08 inches) above the thickness of the fabric is secured.
Heater		Sets the heater for the heated pressure roller. If the fabric does not easily stick to the belt, turn On the heater.
Print Adjustments		Perform Print Adjustments in the following cases.
Automatic Adjustment		<input type="checkbox"/> Using new fabric not registered to the printer
Print Head Alignment		<input type="checkbox"/> When banding (horizontal band-shaped patterns, uneven shading, or stripes) or graininess is observed in the print result
Auto		<input type="checkbox"/> When using fabrics of different widths
Advanced	On	<input type="checkbox"/> When changing the fabric thickness or head height
	Off*	
Manual(Simple)		Automatic Adjustment automatically adjusts the Print Head Alignment and Fabric Feed Adjustment together. Print Head Alignment adjusts the misalignment of ink firing positions. Fabric Feed Adjustment adjusts the fabric feed amount.
Manual(Details)		You can adjust Print Head Alignment and Fabric Feed Adjustment automatically or manually. When performing automatic adjustment, Advanced adjustment is available. When performing manual adjustment, visually check the adjustment pattern and adjust accordingly.
Fabric Feed Adjustment		See the following for more information.
Auto		
Advanced	On	
	Off*	 "Print Adjustments" on page 111
Manual		
Fabric Management		

Control Panel Menu










Item	Parameter	Description
01 XXXXXXXXXXXX to 50 XXXXXXXXXXXX		Change the registered fabric settings. New registrations are normally done when loading fabric.
	Change Name	Change Name allows you to change the registered name.
Fabric Type	cotton	Under Fabric Type , select the fabric type to be used. Fabric Thickness sets thickness of the fabric. If the fabric does not have a consistent height, such as for shaggy fabric, enter the average value. Head Height sets the height of the head. 0.7 mm is the recommended value. A minimum height of 2 mm above the thickness of the fabric is secured. Heater configures the heater for the heated pressure roller. If the fabric does not easily stick to the belt, turn On the heater. Turning it On enables Temperature . Heater temperature is adjustable. Switching fabric type resets the previously set temperature and sets the recommended temperature for the selected fabric type.
	silk	
	wool	
	PET	
	PA	
	Stretch fabrics	
	PET/cotton	
	Others	
Fabric Thickness	0.0 to 5.0 mm (0.0 to 0.20 inches)	
Head Height	0.0 to 9.0 mm (0.0 to 0.35 inches)	
Heater		
Heater	Off	
	On	
Temperature	35 to 70°C (95 to 158°F)	
Print Length Management		
Auto Reset	Off*	Select either Off (do not automatically reset the value for Print Length) or Before Job Start (reset when starting to print the next job). When Off is selected, the value does not reset until you do Manual Reset. However, once the value reaches 9999, it automatically resets and returns to 0. When Before Job Start is selected, the value returns to 0 when printing starts for the next job so you can check the print length per job. You can also check how far along the print job is while printing.
	Before Job Start	
Manual Reset		When reset is done, the value for Print Length returns to 0.

Control Panel Menu

Maintenance Menu

Item	Parameter	Description
Print Head Nozzle Check		<p>Print a check pattern to check for clogged nozzles in the print head. Inspect the pattern visually and perform head cleaning if you detect faint or missing colors.</p> <p>Setting Fabric Width Saving to On shortens the printed length of the check pattern, which reduces the amount of fabric that is used.</p> <p>Set a position to print the check pattern in Print Position.</p> <p>Selects the speed of the print head during check pattern printing.</p> <p>Set the same carriage speed as during printing. Check the carriage speed during printing from your RIP software or printing application.</p>
Fabric Width Saving	On	
	Off*	
Print Position	27 to 1000 mm (1.06 to 39.37 inches)	
Carriage Speed		
Print Head Cleaning		<p>Execute Print Head Cleaning. Perform Cleaning first. If clogging is not cleared after cleaning, perform Power Cleaning until the clogging is cleared.</p> <p>Execute Print Head Refresh if there are multiple large clogs even after performing Power Cleaning. When you execute Print Head Refresh, the suction caps need to be cleaned, and because of this, the cleaning operation takes a long time, so execute it if you have the problem described above.</p> <p> "Print Head Cleaning" on page 286</p> <p>Touching Early Maintenance/Periodic Cleaning will clean the heads regardless of the timing set in Periodic Cleaning or Maintenance Cleaning. Once implemented, the counters for Periodic Cleaning or Maintenance Cleaning will be reset.</p>
Cleaning	Left	
	Right	
Power Cleaning	Left	
	Right	
Print Head Refresh	All Nozzles	
	Select Nozzles	
Early Maintenance/Periodic Cleaning		
Cleaning the Maintenance Parts	Flushing Pad	<p>Start cleaning the selected parts. Follow the on-screen instructions to clean them.</p> <p> "Inspecting/Cleaning the Flushing Pad" on page 225</p> <p> "Inspecting/Cleaning Around the Print Head" on page 229</p> <p> "Inspecting/Cleaning the Cleaning Pad" on page 221</p> <p> "Cleaning the Suction Caps" on page 213</p> <p> "Cleaning the Encoder Scale" on page 277</p>
	Around the Head	
	Cleaning Pad	
	Suction Cap	
	Encoder Scale	
Belt Cleaning		Starts belt cleaning.
Belt speed	Normal	<p>Sets the belt speed and number of cleaning cycles when performing belt cleaning.</p> <p>Select the belt rotation speed during belt cleaning in Belt speed.</p> <p>Normal rotates at the same speed as the belt speed during printing. Low rotates slower than Normal. Low (Interval) rotates slower than Low.</p> <p>Select Low or Low (Interval) when you want to thoroughly clean the belt.</p> <p>Set the number of times the belt is cleaned in Number of cleaning cycles.</p>
	Low	
	Low (Interval)	
Number of cleaning cycles	1 to 100	

Control Panel Menu

Item	Parameter	Description
Belt Cleaning Unit Cleaning		Touch the Start button when cleaning the belt cleaning brushes, washing scraper, or the cleaning tank. Supply of water to the cleaning tank begins.
Ink Path Cleaning		Starts cleaning the ink path. Follow the on-screen instructions to clean them.
Adhesive Material Maintenance	Application Mode	You need to enter the Administrator Password to start applying/removing glue. Follow the manual instructions to perform this.  "Removing Glue (When Using the Glue Removal Tool)" on page 314  "Removing Glue (When Using the Glue Bucket)" on page 366  "Applying Glue" on page 402
	Removal Mode	
Adding Grease to the Scan Spindle		Starts adding grease to the scan spindle. Follow the manual instructions to perform this.  "Adding Grease to the Scan Spindle" on page 297
Print Head Nozzle Limitation	On	Set the print heads to use for printing. For example, if there is a clogged nozzle in one print head and the clog cannot be cleared after repeated head cleaning, you can continue printing using the unclogged print head. Use this when you want to solve the problem without interrupting the printing work. <input type="checkbox"/> When maintenance that takes time, such as Print Head Refresh, needs to be done, do that maintenance after finishing work. <input type="checkbox"/> When the print head needs to be replaced, continue work until it is replaced. Confirm the check pattern printed by Print Head Nozzle Check, and then select the print head that is not clogged. Using the Print Head Nozzle Limitation function may increase the print time and cause print quality to decline. Also, printing a Fabric Edge Nozzle Check Pattern is disabled. We recommend using it only during the time until the clogged nozzles can be cleared.
	Off*	
Replace Waste Ink Bottle		If you are replacing the waste ink bottle before the message indicating that it is time to replace the waste ink bottle appears on the control panel's screen, do so from this menu.
Replace Maintenance Parts	Replace Wiper Roll	Start replacing the selected parts. Follow the on-screen instructions to replace them.  "Replacing the Wiper Roll" on page 248  "Replacing the Cleaning Pad" on page 256  "Replacing the Flushing Pad" on page 252  "Replacing the Washing Scraper" on page 261  "Replacing the Sponge Roller" on page 266
	Replace Cleaning Pad	
	Replace Flushing Pad	
	Replace Washing Scraper 2	
	Replace Sponge Roller	

Control Panel Menu**Supply Status Menu**

Item	Parameter	Description
Ink/Waste Ink Bottle		Shows the replacement timing, remaining amount and part number of the selected consumables.
Others	Wiper Roll	
	Washing Scraper 2	
	Sponge Roller	
	Adding Grease to the Scan Spindle	

Control Panel Menu

Replacement Part Information Menu

Item	Description
CR Cableveyor	Displays the replacement timing for the selected replacement part. Contact your dealer or Epson Support to request a replacement.
Side-to-side Motor	
Belt Wash Motor	
CR Motor	
Belt Feed Measurement Sensor	
Head Stroke Sensor	
Fabric Floating Sensor	
Slack Detection Sensor	
Roll Diameter Measurement Sensor	
Tangled Fabric Detection Sensor	
Fan (in)	
Fan (out)	
APG Motor Unit	
CR Belt	
Infrared Temperature Sensor	
Heated Pressure Roller Cableveyor	
Cleaning Pump Unit 1	
Cleaning Pump Unit 2	
Cleaning Pump Unit 3	
Cleaning Pump Unit 4	
Cleaning Pump Unit 5	
Cloth Wiper Drive Unit	
Ink Supply Pump(L)	
Ink Supply Pump(C)	
Ink Supply Pump(R)	


Control Panel Menu


Printer Status Menu

Item	Parameter	Description
Firmware Version		Shows and prints the selected information.
Printer Name		
Fatal Error Log		
Operation Report	Total Print Area	
	Total Fabric Feed Length	
	Total Carriage Pass	

List of Printer Settings by Operation











































Depending on the type of media used for printing and the nature of the operation, you need to change the settings for each switch and the settings for the printer.

 : If the setting is wrong, an error occurs and printing cannot be performed.

 : If the setting is wrong, print quality will be affected.

Control Panel Menu

Media Type: Fabric

Operation			Printing Images		Nozzle Check Pattern	Adjustment Pattern	
Detailed Conditions			Non-stretchable Fabric	Stretchable Fabric		Auto	Manual
Control panel	General Settings	External Drying Reel	 On if connected	 On if connected	 On if connected	 On if connected	 On if connected
		Feeding Unit	 On	 On	 On	 On	 On
		Belt Cleaning	 On	 On	 On	 On	 On
		Heated Pressure Roller	 Swing* ¹	 Swing* ¹	 Swing	 Swing	 Swing
		Belt Feed Measurement Sensor	 On* ¹	 On* ¹	 On	 On* ²	 On* ²
	Fabric Floating Sensor	 On	 On	 On	 On	 On	
Fabric Settings	Heater	 On	 On	_ * ³	_ * ³	_ * ³	
Rear panel	Tension switch		 On	 On	 On	 On	 On
	Slack detection switch		 Off	 Off	 Off	 Off	 Off

*1: When printing using one pass, the belt feed measurement sensor and heated pressure roller operate as follows to prevent the machine from malfunctioning.

Heated pressure roller: Even if it is set to simultaneous swing with feed, it activates at regular intervals without synchronizing with the belt.









Belt Feed Measurement Sensor: Even if it is set to On, the setting is disabled.

*2: When printing using one pass, turn Off the Belt Feed Measurement Sensor before making adjustments. If you adjust the print settings while the Belt Feed Measurement Sensor is On, banding may occur during printing.

*3: This setting is automatically turned off when printing nozzle check patterns and adjustment patterns.

Control Panel Menu

Media Type: Paper

Operation			Nozzle Check Pattern	Adjustment Pattern	
Detailed Conditions				Auto	Manual
Control panel	General Settings	External Drying Reel	Off	Off	Off
		Feeding Unit	 Off	 Off	 Off
		Belt Cleaning	 Off	 Off	 Off
		Heated Pressure Roller	Off	Off	Off
		Belt Feed Measurement Sensor	Either is acceptable	 On	 On
		Fabric Floating Sensor	Either is acceptable	Either is acceptable	Either is acceptable
Fabric Settings	Heater	_ *1	_ *1	_ *1	
Rear panel	Tension switch		_ *2	_ *2	_ *2
	Slack detection switch		_ *2	_ *2	_ *2

*1: This setting is automatically turned off when printing nozzle check patterns and adjustment patterns.

*2: This setting is unavailable when the **Feeding Unit** is set to **Off** on the machine.



Problem Solver

When a Message is Displayed

If one of the following messages is displayed, read and follow the instructions below.

Messages	What to do
The waste ink bottle is nearing the end of its service life. Prepare a new one. You can continue printing until replacement is required.	The Waste Ink Bottle is getting full. Ready a new Waste Ink Bottle. ☞ "Options and Consumable Products" on page 472
Ink cartridge is not recognized. Please replace the cartridge.	Remove and reinsert the ink cartridge. If the message persists, insert a new ink cartridge (do not reinsert the ink cartridge that caused the error).
Ink is low. You can continue printing until replacement is required.	Ink is low. Make sure a new ink cartridge is installed so that the printer can automatically switch ink cartridges when the remaining amount falls below the limit. ☞ "Options and Consumable Products" on page 472
The heater is warming up.	One or more heaters is still being warmed to the specified temperature. To start printing while the heater temperature is low, touch Start to display a confirmation screen, and then touch OK to start.
The print head is contacting the fabric. Check that the print results are not dirty. Printing can continue.	If you check the print results and they are dirty, stop printing and clean around the print head. ☞ "Inspecting/Cleaning Around the Print Head" on page 229
The XXXXX is nearing the end of its service life.	The replacement interval is approaching for the parts that are shown. Prepare new parts.
The inside of the printer is hot. Lower room temperature.	Lower the temperature of the room until it is within the temperature range described in the "Specifications Table". ☞ "Specifications" on page 478
Fabric is not loaded correctly. When setting the "Slack detection switch" to "On", raise the tension bar and allow the fabric to slacken so that it is detected by the slack detection sensor. When setting to "Off", lower the tension bar to prevent the fabric from slacking. Set the "Feeding Roller Switch" to match the roll winding direction.	The fabric was not correctly loaded when it was loaded. Refer to the following, and load the fabric correctly. ☞ "Installing the Fabric Roll" on page 56

Problem Solver

Messages	What to do
<p>Cannot perform auto adjustment due to problems with the fabric and print results. Refer to the user manual for further information. Perform manual adjustments if the problem is not resolved.</p> <p>The scanning device may be malfunctioning. Contact Epson Support. Manual adjustment is possible.</p>	<p>Touching OK cancels the error. When doing Auto execution of Print Adjustments, execution is not possible for the following fabric, settings, and environment.</p> <ul style="list-style-type: none"> <input type="checkbox"/> Fabric with an uneven surface <input type="checkbox"/> Fabric that bleeds-through easily <input type="checkbox"/> The printer is used in a place that is exposed to direct sunlight or interference from other ambient light sources. <p>In these cases, execute the manual menu.  "Print Adjustments" on page 111</p> <p>If the printer is exposed to interference from ambient light sources, shade the printer from these sources and perform the function again; it may succeed. When the function has failed after shading the printer, execute the manual menu.</p> <p>If the above items do not apply, and the same error occurs again, contact your dealer or Epson Support.</p>
<p>An error was detected at the belt feed measurement sensor. Check the belt feed measurement sensor and belt, and remove any foreign matter. If it occurs repeatedly, contact Epson Support.</p>	<p>Make sure there is no ink, glue, tape, or other material on the right or left edges of the belt (within 25 mm of the edge of the belt). If there is any ink, glue, tape, etc. stuck to the edges of the belt, wipe the edges clean with a cloth soaked in an appropriate amount of ethanol.</p> <p>If the same error occurs again after cleaning, contact your dealer or Epson Support.</p> <p>You can continue printing by turning off the Belt Control Unit function from Printer Settings on the control panel.  "General Settings Menu" on page 434</p>

When an Error Message is Displayed



Important:

If the printer enters an error status and the print head is not capped for more than 20 minutes, perform manual capping of the print head.

 ["Capping the Print Head" on page 290](#)

Messages	What to do
<p>Parts Service Life Ending XXXXXXXX One of the parts in the printer is nearing the end of its service life. Note the code and call for service.</p> <p>Replace Part Now XXXXXXXX Note the code and call for service.</p>	<p>This message notifies you that it is time to replace replacement parts on the printer. Immediately contact your dealer or Epson Support. When doing so, be sure to tell us the "XXXXXXX" (code number).</p>

Problem Solver











Messages	What to do
<p>Printer error. For details, see your documentation. XXXXXXXX</p> <p>Printer error. Turn the power off and on again. For details, see your documentation. XXXXXXXX</p>	<p>Error messages that are displayed for the following.</p> <ul style="list-style-type: none"> <input type="checkbox"/> The power cable is not connected securely <input type="checkbox"/> An error that cannot be cleared occurs <p>When a printer error occurs, the printer automatically stops printing.</p> <p>Turn the printer off and on again. When turning the printer back on, turn it on from the main power switch on the back of the printer.</p> <p>☞ "Turning On the Power" on page 51 ☞ "Turning Off the Power" on page 110</p> <p>If an error with the same code number occurs again, contact your dealer or Epson Support. When doing so, be sure to tell us the "XXXXXXXX" (code number).</p> <p>When error message "0014CD" is displayed If the error message "0014CD" is displayed immediately after turning on the machine, check that the air pressure is at the specified value. ☞ "Inspecting/Adjusting the Air Pressure" on page 197</p> <p>If it is not at the specified value, adjust it and turn the device off and back on again. ☞ "Turning On the Power" on page 51 ☞ "Turning Off the Power" on page 110</p> <p>When it has reached the specified value, contact your dealer or Epson Support.</p>
<p>The encoder scale is dirty, or the drive part is nearing the end of its life. If you continue to use the printer, print quality may decline, or the printer may stop working. If you continue to use the printer, print quality may decline, or the printer may stop working. When printing is complete, turn the printer off and then clean the encoder scale.</p> <p>When cleaning is complete, press "Complete" from "Cleaning the Maintenance Parts" - "Encoder Scale". If this message is still displayed after cleaning, contact Epson Support.</p>	<p>It is possible that the encoder scale is dirty or that it is time to replace a drive component. See the following to clean the encoder scale.</p> <p>☞ "Cleaning the Encoder Scale" on page 277</p> <p>If an error with the same code number occurs again, contact your dealer or Epson Support.</p>
<p>The water recycling unit has stopped. If you continue printing, the belt may become dirty and the fabric may be stained. For details, see your documentation.</p>	<p>Check the status lights on the water recycling unit and take the appropriate action.</p> <p>☞ "Understanding the Status Lights on the Water Recycling Unit" on page 456</p> <p>See the following if you want to continue using the printer without the water recycling unit.</p> <p>☞ "The water recycling unit stopped due to an error" on page 466</p>

Problem Solver








Messages	What to do
<p>The water recycling unit is not recognized. If you continue printing, the belt may become dirty and the fabric may be stained. For details, see your documentation.</p>	<p>Turn the printer off and on again. When turning the printer back on, turn it on from the main power switch on the back of the printer.</p> <p>☞ "Turning On the Power" on page 51 ☞ "Turning Off the Power" on page 110</p> <p>If the water recycling unit does not work even after turning the printer's power off and on, contact your dealer or Epson Support.</p> <p>See the following if you want to continue using the printer without the water recycling unit.</p> <p>☞ "The water recycling unit stopped due to an error" on page 466</p>

Understanding the Status Lights on the Water Recycling Unit






The lights turn on or flash in two colors to notify you of the status of the water recycling unit.

Error	Power	Description	Solution
 Off	 Off	The power is off.	Turn on the printer. ☞ "Turning On the Power" on page 51 If the water recycling unit does not start when you turn on the printer, contact your dealer or Epson Support.
 Off	 On	The system is starting up or operating.	-
 Off	 Flashing	The product is paused.	After performing any necessary procedures, press the Pause/Restart button on the water recycling unit.
 Off	 Flashing quickly twice, then off for one second	Clean water is being supplied to the tank because the cleaning water in the tank is low or has a high ink density.	-
 Off	 Flashing quickly	The cleaning water is being drained from the water recycling unit tank.	Wait until draining is complete. When draining is complete, the product will pause.

Problem Solver

Error	Power	Description	Solution
 <p>Flashing quickly three times, then off for one second</p>	 <p>On</p>	<p>The cleaning water in the water recycling unit tank has reached its maximum limit.</p>	<p>Check the water level in the water recycling unit tank. Depending on the water level, perform the following operations.</p> <ul style="list-style-type: none"> <input type="checkbox"/> When the water level has reached the max. water level sensor <ol style="list-style-type: none"> 1. Check if the drainage path is blocked by a kink in the drainage hose or any other obstruction. Once you have cleared the blockage and the tank's water level has dropped, press and hold the Reset button for at least three seconds. If the water level does not drop, use a commercially available pump or similar device to drain the water manually. 2. Clean inside the water recycling unit tank. <ul style="list-style-type: none">  "Cleaning Inside the Water Recycling Unit Tank" on page 218 <input type="checkbox"/> When the water level has not reached the max. water level sensor <p>There may be lint or other debris stuck to the sensor.</p> <ol style="list-style-type: none"> 1. Check if the drainage path is blocked by a kink in the drainage hose or any other obstruction, then press and hold the Reset button for at least three seconds. 2. Clean inside the water recycling unit tank. <ul style="list-style-type: none">  "Cleaning Inside the Water Recycling Unit Tank" on page 218 <p>If the problem continues to occur, contact your dealer or Epson Support.</p>
 <p>Flashing quickly four times, then off for one second</p>	 <p>On</p>	<p>Supplying water to the water recycling unit tank has not been completed.</p>	<p>Perform the following operations.</p> <ul style="list-style-type: none"> <input type="checkbox"/> Open the manual valve on the water recycling unit <ul style="list-style-type: none">  "Problems with the Water Recycling Unit" on page 466 <input type="checkbox"/> Close the drain valve on the printer <input type="checkbox"/> If water leaks from the printer's water pipes, tighten the joints. <p>After performing the operations above, press and hold the Reset button on the water recycling unit for at least three seconds.</p> <p>If the problem continues to occur, contact your dealer or Epson Support.</p>

Problem Solver

Error	Power	Description	Solution
 <p>Flashing quickly five times, then off for one second</p>	 <p>On</p>	Draining the water recycling unit tank has not been completed.	<p>Perform the following operations.</p> <ul style="list-style-type: none"> <input type="checkbox"/> Press and hold the Reset button on the water recycling unit for at least three seconds <input type="checkbox"/> Cleaning inside the water recycling unit tank <ul style="list-style-type: none">  "Cleaning Inside the Water Recycling Unit Tank" on page 218 <p>If the problem continues to occur, contact your dealer or Epson Support.</p>
 <p>Flashing</p>	 <p>Flashing</p>	A system error has occurred.	<p>Press and hold the Reset button on the water recycling unit for at least three seconds to restart the product.</p> <p>If restarting does not solve the issue, contact your dealer or Epson Support.</p>

Note:

See the following if you want to continue using the printer without the water recycling unit.

 ["The water recycling unit stopped due to an error" on page 466](#)

Troubleshooting

You Cannot Print (Because the Printer Does Not Work)

The printer does not turn on

■ **Is the power cable plugged into the electrical outlet or the printer?**

Make sure the power cable is securely plugged into the printer.

■ **Is there any problem with the electrical outlet?**

Make sure your outlet works by connecting the power cable for another electric product.

The printer is not communicating with the computer

■ **Is the cable plugged in properly?**

Make sure the printer's interface cable is securely plugged into the correct terminal of the computer and the printer. Also, make sure the cable is not broken nor bent. If you have a spare cable, try connecting with the spare cable.

■ **Does the interface cable specification match the specifications for the computer?**

Make sure the interface cable specifications match the specifications for the printer and the computer.

 ["Specifications" on page 478](#)

Problem Solver

■ **When using a USB hub, is it being used correctly?**

In the USB specification, daisy-chains of up to five USB hubs are possible. However, we recommend that you connect the printer to the first hub connected directly to the computer. Depending on the hub you are using, the operation of the printer may become unstable. If this should occur, plug the USB cable directly into your computer's USB port.

■ **Is the USB hub recognized correctly?**

Make sure the USB hub is recognized correctly on the computer. If it is recognized correctly, disconnect all USB hubs from the computer's USB port, then try connecting directly between the printer's USB port and the computer's USB port. Ask the USB hub manufacturer about USB hub operation.

You cannot print under the network environment

■ **Connect the printer directly to the computer using a USB cable, and then try to print.**

You may not be able to print under a network environment.

Connect the computer and this printer with SuperSpeed USB, and then try to print.

Printing does not start

■ **Are there any paused print jobs on your computer?**

If the printer is turned off or the network cable is disconnected during printing, print jobs may remain on your computer in a paused state preventing you from starting printing.

Delete any print jobs left in the print queue from the printer driver, or restart your computer.

When you resume printing, make sure that the printer is turned on and the network cable is firmly connected.

The printer has an error

■ **Confirm if errors have occurred in the printer by checking the lights and messages on the printer's control panel.**

 ["Control Panel" on page 17](#)

 ["When a Message is Displayed" on page 453](#)

The Printer is Working but Does Not Print

The Printer is Working but does not Print

■ **Confirm the printer operation.**

Print a test pattern. Test patterns can be printed without connecting the printer to a computer and hence can be used to check printer function and status.

 ["Print Head Nozzle Check" on page 281](#)

Refer to the following section for information on what to do if the pattern does not print correctly.

Test pattern does not print correctly

■ **Perform head cleaning.**

The nozzles may be clogged. Print a test pattern again after performing head cleaning.

 ["Print Head Cleaning" on page 286](#)

Problem Solver

■ **Has the printer been left unused for a long time?**

If the printer has not been used for a long time, the print head nozzles may have dried up and become clogged. Steps to take when the printer has not been used for a long time:

 ["Notes When Not Using the Printer" on page 41](#)

The Prints Are Not What You Expected

Print quality is poor, smudged or uneven, too light, too dark, obvious graininess, or the tone differs/print results are overlapping

■ **Are the print head nozzles clogged?**

If the print head nozzles are clogged, specific nozzles do not fire ink, and the print quality declines. Try printing a test pattern.

 ["Print Head Nozzle Check" on page 281](#)

■ **Perform print adjustments.**

There is a slight gap between the print head and the fabric, so the landing sites for the different colors of ink may be displaced by the following causes.

Difference in the direction the print head is moving (right to left or left to right)

- Temperature and humidity
- Inertial force of movement of the print head
- Displacement of the landing sites of the ink may cause the print results to show obvious graininess or to appear out-of-focus.

Also, large discrepancies in the feed amount cause banding (horizontal banding, tint unevenness, or stripes) in the printing results.

You can adjust discrepancies in ink landing sites and the amount of fabric that is fed by doing Print Adjustments. In **Fabric Settings**, do **Print Adjustments - Automatic Adjustment**, to do adjustments for the fabric you are using.

 ["Print Adjustments" on page 111](#)

■ **Use unidirectional printing.**

If ruled lines are misaligned or unevenness occurs, selecting one-directional printing may improve the symptoms.

■ **Are you using a genuine Epson ink cartridge?**

This printer is developed for use with Epson ink cartridges. Use of non-genuine products may result in faint prints or the inability to detect the amount of ink remaining properly, which may result in changes in color. Be sure to use the correct ink cartridge.

■ **Are you using an old ink cartridge?**

The print quality declines when an old ink cartridge is used. Replace the old ink cartridge with a new one. Use all the ink in the ink cartridge before the expiration date printed on the package or within six months of opening the ink cartridge packaging, whichever is sooner.

■ **Are fabric settings correct?**

Confirm that the fabric settings in the software RIP or on the printer match the fabric actually in use.

Problem Solver

■ **Is the fabric over stretched?**

Turn the tension adjustment dial to the left to reduce the tension of the fabric.

If you are using the high tension feeding unit, repeat step 6 below to adjust the tension as needed.

 ["When you want to print by smoothing out wrinkles and curls in the fabric" on page 159](#)

■ **Have you compared the printing result with the image on the display monitor?**

Since monitors and printers produce colors differently, printed colors will not always match on-screen colors perfectly.

■ **Did you press the pause button while printing?**

When printing is paused and then resumed, uneven shading is more likely to occur in the print results.

■ **Has an error occurred causing printing to stop?**

When an error occurs causing printing to stop and then printing resumes, print results may overlap or uneven shading may occur in the print results.

To prevent errors during printing, take measures such as smoothing out any wrinkles or lifting when loading the fabric or adjusting the fabric take-up speed.

■ **Is Ink is low. displayed on the control panel screen?**

The print quality may decline when the ink is low. We recommend replacing the ink cartridge with a new one. If there is a difference in color after replacing the ink cartridge, try performing head cleaning a few times.

■ **Is the USB connected to the machine?**

A poor connection between the USB and the machine may have resulted in interruption or delay in data transfer. Check that the USB terminal is inserted all the way into the USB port and that the USB is properly connected to the machine.

■ **Is there a problem with the connection between the printer and the computer?**

 ["The printer is not communicating with the computer" on page 458](#)

■ **Are there any water droplets left on the belt after belt cleaning?**

 ["Water droplets remain on the belt after belt cleaning" on page 464](#)

The print is not positioned properly on the fabric

■ **Is the fabric loaded correctly and are the margins correct?**

If the fabric is not loaded correctly, the results may be off-center or part of the data may not be printed. Also, check that the side margins and Print Start Position settings in the set up menu are appropriate.

 ["Installing the Fabric Roll" on page 56](#)

 ["General Settings Menu" on page 434](#)

■ **Is the fabric skewed?**

If the fabric is not loaded correctly, the fabric may skew and the print position may be displaced. Be careful of the following, and load the fabric correctly.

When pulling out the fabric, hold the center of the fabric in one hand, and pull it straight out.

 ["Installing the Fabric Roll" on page 56](#)

Problem Solver

■ Is the fabric floating up from the belt?

If the fabric is not attached to the belt properly, the fabric may lift up, shifting from the print position. Increase the heater temperature from the control panel.

👉 ["Control Panel Menu" on page 434](#)

However, note that raising the temperature too high can cause the fabric to shrink, wrinkle, or deteriorate. In addition, the heaters may require some time to reach the desired temperature if the ambient temperature is low. The heaters may also not have the desired effect after reaching the selected temperature if the fabric is too cold. Allow the fabric to warm to room temperature before use.

If the problem persists, reapply the glue.

👉 ["Removing Glue \(When Using the Glue Removal Tool\)" on page 314](#)

👉 ["Removing Glue \(When Using the Glue Bucket\)" on page 366](#)

👉 ["Applying Glue" on page 402](#)

Problems with the Fabric

Fabric jams

■ Is fabric curled, folded, wrinkled, or waved?

Cut and remove the curled, folded, wrinkled, or waved part.

👉 ["Removing jammed fabric" on page 462](#)

■ Is fabric loaded just before printing?

The heated pressure roller may crease fabric left in the printer, or the fabric may also become wavy or curled.

■ Is the fabric too thick or too thin?

Check the fabric specifications to determine whether it can be used in the printer.

👉 ["Supported Fabric" on page 474](#)

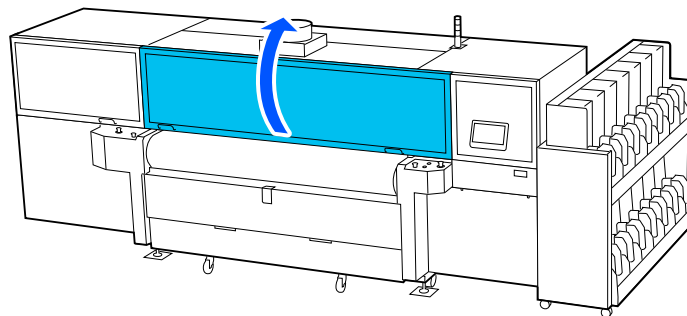
For information on how to configure print settings using the software RIP, contact the RIP manufacturer.

Removing jammed fabric

If an error message is displayed, follow the steps below to remove the jammed fabric. You can perform operation while the printer is on.

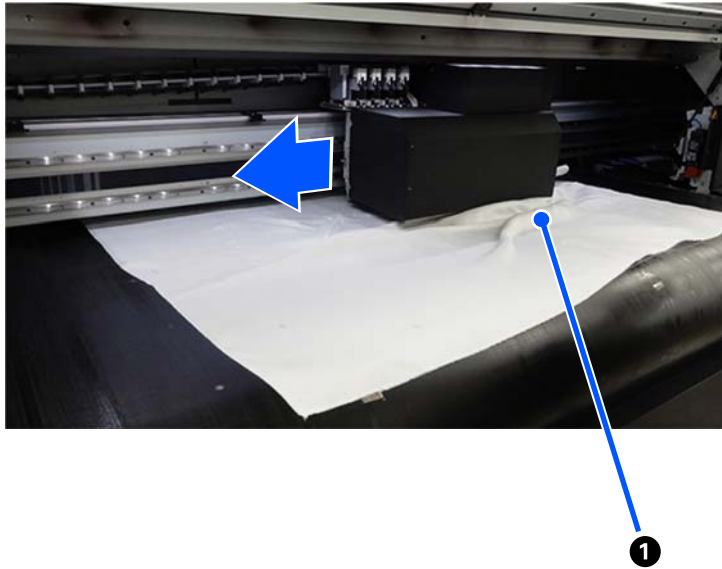
1

Open the front cover.



Problem Solver

- 2 To move the print head, push it away from the jammed fabric.



- 1 Jammed fabric

- 3 Stretch out any areas of the fabric that have floated up or are wrinkled, and stick it to the belt.



- 4 Close the front cover.

- 5 Check the message and press **OK**.

Resume printing.

 [“Installing the Fabric Roll” on page 56](#)

Problem Solver

If the same error continues to occur after re-starting printing, repeat the procedure and use scissors to cut and remove any floating or wrinkled areas of fabric in step 3.



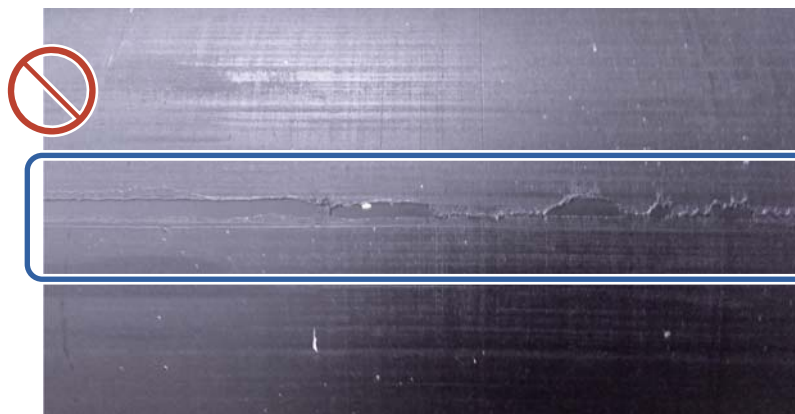
Problems with the Belt

Water droplets remain on the belt after belt cleaning

Depending on the condition of the glue applied to the belt and the condition of the washing scraper or sponge roller, water droplets may remain on the belt after belt cleaning. If water droplets remain on the belt, take the following steps to deal with the issue.

Checking procedure

- 1** Check if any of the following conditions apply to the belt.
 - ❶ Is there any lint or debris on the belt surface?
 - ❷ Are there any areas where the glue that was applied to the belt has peeled off?



Problem Solver

- ③ Has the adhesive strength of the glue that was applied to the belt declined?

If the fabric attached to the belt rises, there is not enough adhesive strength in the glue on the belt.

🔗 “Is the fabric attached to the belt floating?” on page 309

As well as judging from the condition of the fabric and the print quality, you can also use a measuring device to determine the adhesive strength of the glue.

🔗 “Is the adhesive strength of the glue lower than the standard value?” on page 312

If condition ① applies, remove any lint or debris from the belt surface.

If condition ② or ③ applies, remove and then reapply the glue.

🔗 “Removing Glue (When Using the Glue Removal Tool)” on page 314

🔗 “Removing Glue (When Using the Glue Bucket)” on page 366

🔗 “Applying Glue” on page 421

If none of the conditions in ① to ③ apply, follow the steps below.

2

Pull out the belt cleaning unit and check if the washing scraper is in the following condition.

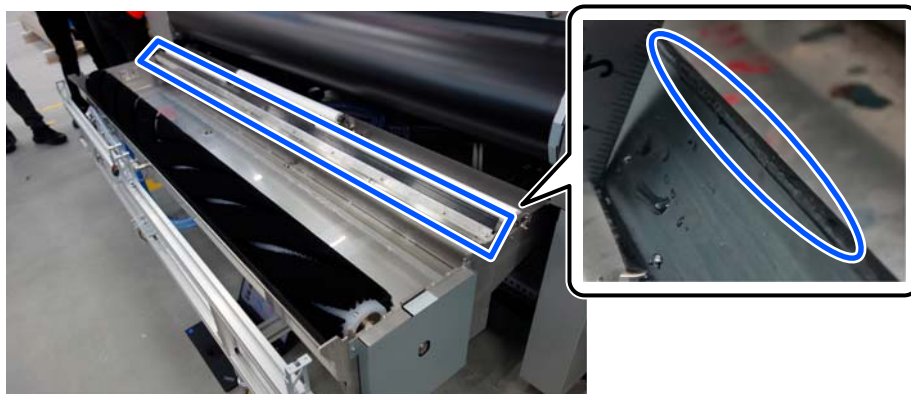


Caution:

The belt cleaning unit weighs over 110 kg, so make sure you bend your knees sufficiently and work in a natural position.

Pulling or pushing the unit with incorrect posture can lead to injury and back pain.

- ① Is there any lint or debris on the washing scraper?
- ② Is the edge of the washing scraper scratched or worn?



If condition ① applies, remove any lint or debris from the washing scraper.

Problem Solver

[↶](#) “Cleaning the Belt Cleaning Unit” on page 237

If condition ② applies, turn over the washing scraper and reinstall it, or replace it with a new one.

[↶](#) “Replacing the Washing Scraper” on page 261

If none of the conditions in ① or ② apply, follow the steps below.

3

Make sure that the sponge roller is not in the following state.

- ① Is the sponge roller soaked with water?
- ② Is the sponge roller detached from the belt cleaning unit?
- ③ After checking ① and ②, are there any water droplets left on the belt after belt cleaning?

If condition ① applies, dry the sponge roller.

[↶](#) “Drying the Sponge Roller” on page 232

If condition ② applies, correctly attach the sponge roller to the belt cleaning unit.

[↶](#) “Replacing the Sponge Roller” on page 266

If condition ③ applies, replace the sponge roller with a new one.

[↶](#) “Replacing the Sponge Roller” on page 266

If none of the conditions in ① to ③ apply, contact your dealer or Epson Support.

Problems with the Water Recycling Unit

The water recycling unit stopped due to an error

Check the error message and take the appropriate action.

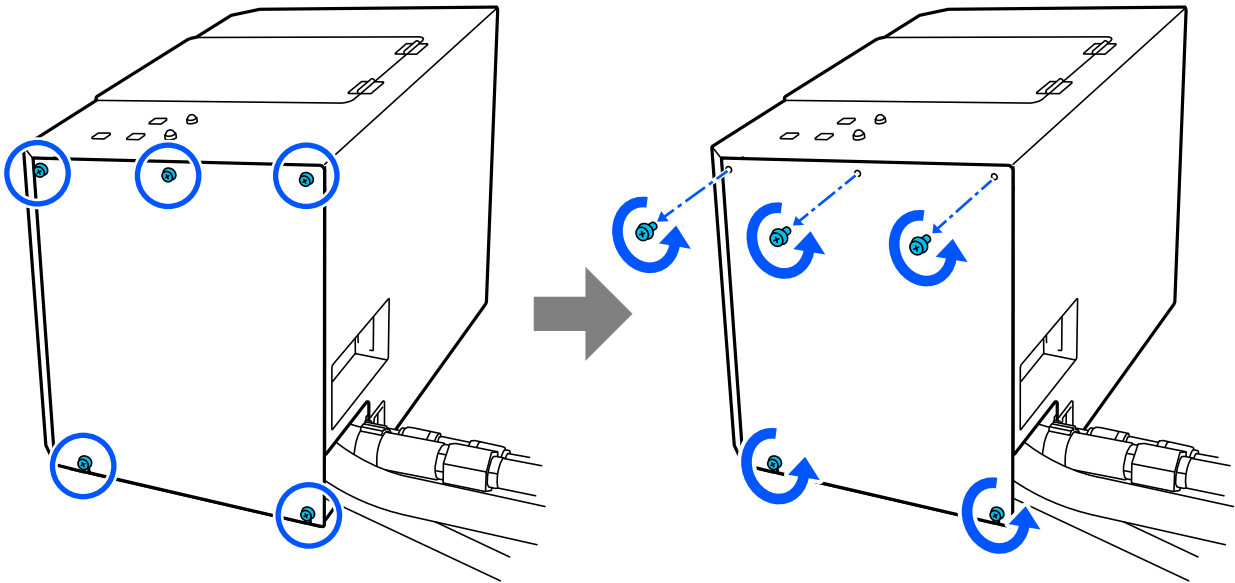
[↶](#) “When an Error Message is Displayed” on page 454

If the issue continues after trying the troubleshooting solutions, contact your dealer or Epson Support.

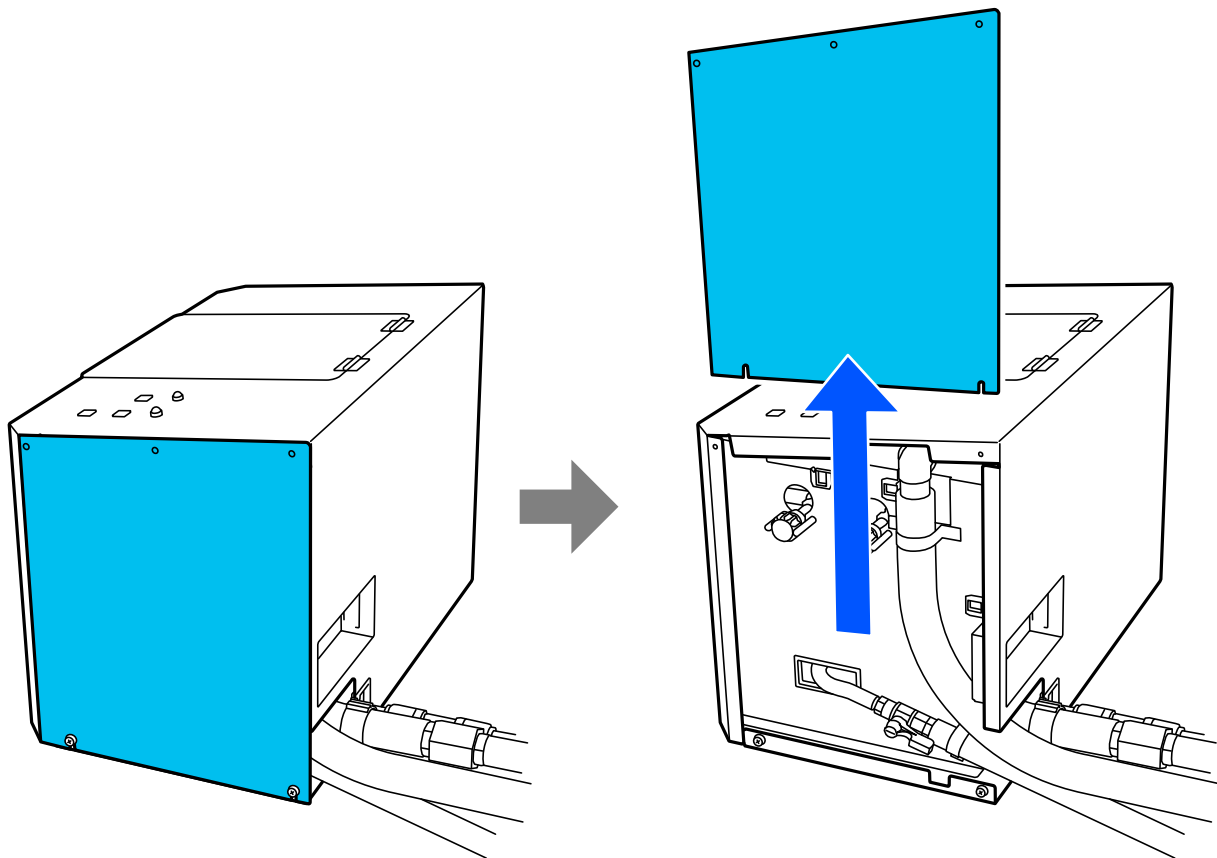
You can continue operating the printer without using the water recycling unit. Follow the steps below.

Problem Solver

- 1 Remove the top three screws on the right side of the water recycling unit, and loosen the bottom two screws thereof.

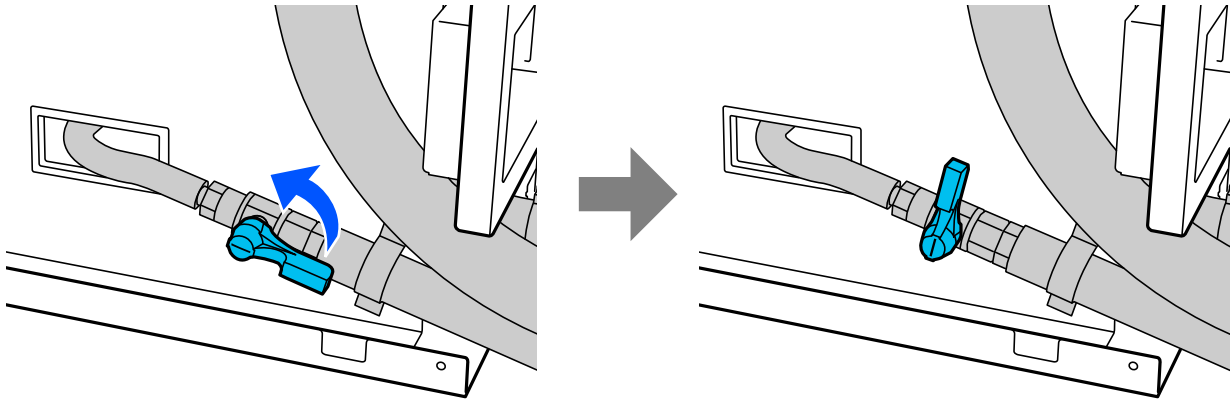


- 2 Slide the cover up to remove it.



Problem Solver

- 3** Close the manual valve.



- 4** From the Maintenance screen on the control panel, touch **Maintenance - Belt Cleaning Unit Cleaning**, in that order.

- 5** Check the on-screen message, and then touch **Start**.

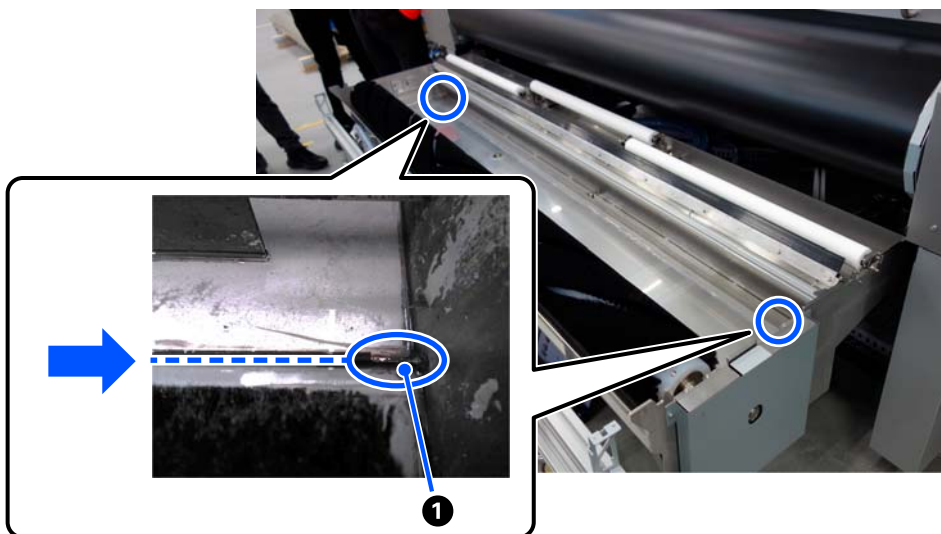
Supply of water to the cleaning tank begins.

- 6** Once the water has been supplied to the level of the notches on either end of the belt cleaning tank, touch the **Suspended** button on the control panel.

! **Important:**

Do not stop the water supply below the level of the notch. The cleaning brush will rotate without water and the glue applied to the belt may peel off.

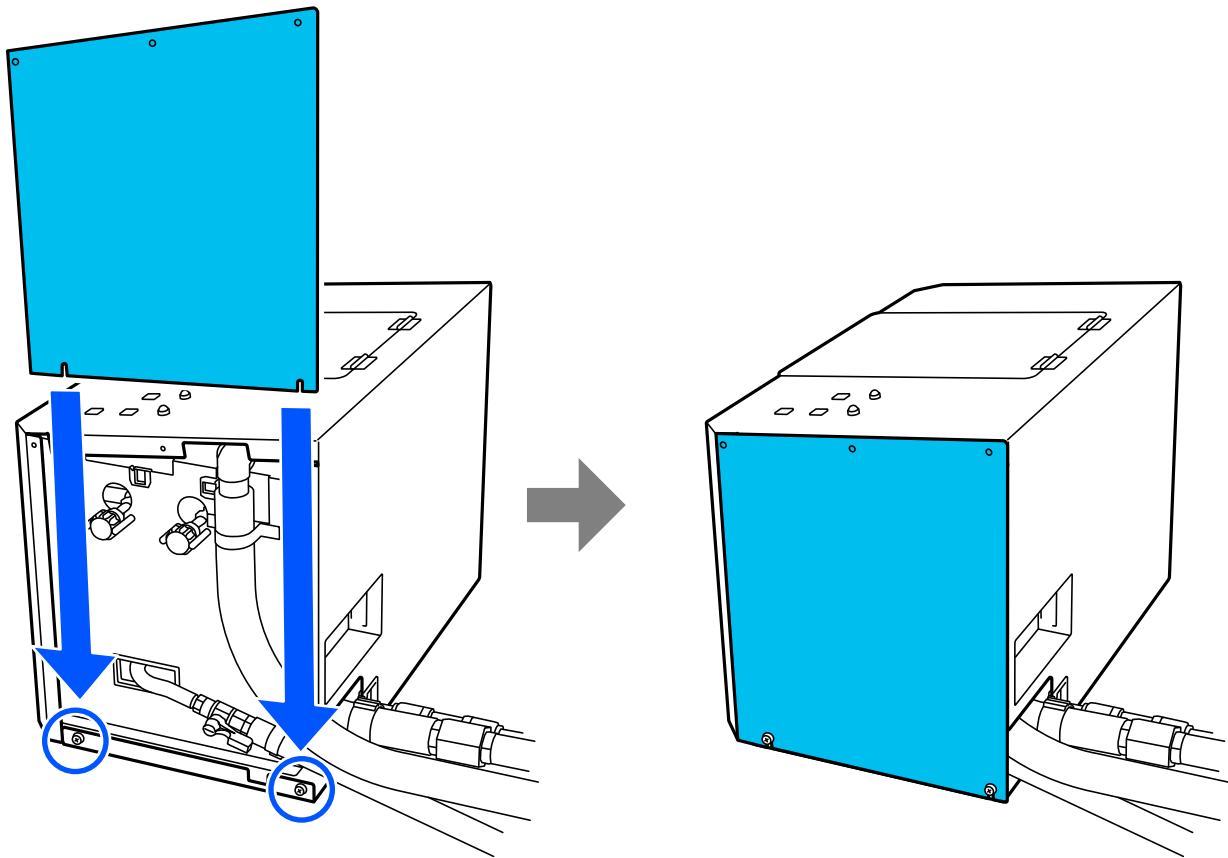
Even if the supplied water exceeds the height of the notch, there is no problem because the amount beyond the notch will drain away.



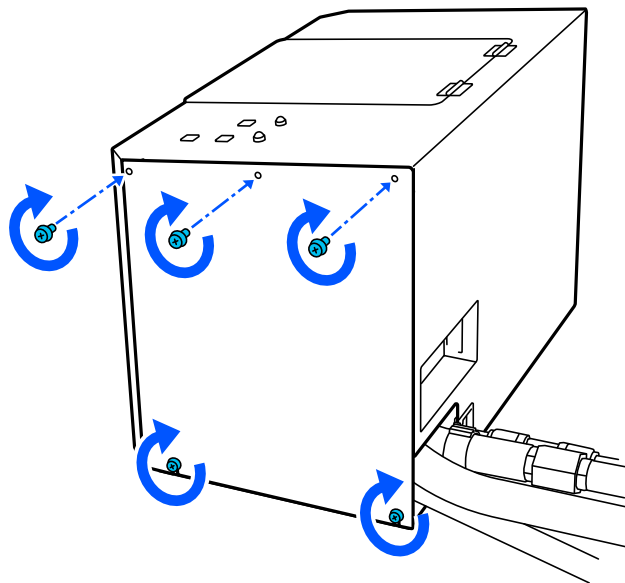
- 1** Notch

Problem Solver

- 7** Attach the cover by aligning the notches on the cover with the two screws at the bottom on the right side of the water recycling unit.



- 8** Tighten the top three screws, and then tighten the bottom two screws.



Problems when Printing Using One Pass

Banding (horizontal band-shaped patterns, uneven shading, or stripes) occurs even after print adjustment

If you adjust the print settings while the Belt Feed Measurement Sensor is On, banding may occur during printing. When printing using one pass, turn **Off** the **Belt Feed Measurement Sensor** on the control panel before making adjustments.

See the following if the problem continues to occur.

 [“The Prints Are Not What You Expected” on page 460](#)

Others

Heater automatically turns off

The heater turns off if no print job is received and no errors occur in the printer for a certain time.

The heater restarts when a print job is received or Preheat Start is touched.

The control panel display keeps turning off

■ Is the printer in sleep mode?

When no operations are performed on the printer for the time set in Sleep Timer in the setup menu, the printer enters sleep mode. The time before entering sleep mode can be changed in the General Settings menu.

 [“General Settings Menu” on page 434](#)

Sleep mode is canceled when a print job is received, the fabric loading lever is used, or another operation involving printer hardware is performed.

If you have forgotten your administrator User Name or Administrator Password

When the administrator User Name or Administrator Password has not been changed from the default value

Leave the administrator User Name blank. Enter the printer's serial number as the Administrator Password.

If you have forgotten your own administrator User Name or Administrator Password you set

You need to reset all of the printer's network settings. Touch **General Settings - Printer Settings - Restore Default Settings - Network Settings** on the control panel, in that order. All of the printer's network settings need to be reconfigured as necessary.

After resetting, enter the following administrator User Name and Administrator Password.

Administrator User Name: Blank (do not enter anything)

Problem Solver

Administrator Password: Enter the printer's serial number

Change the Administrator Password to a new password. Change to your own administrator User Name.

 [“How to Set/Change the Administrator User Name/Administrator Password” on page 47](#)

Appendix

Options and Consumable Products

The following list of consumables and optional items may not be up-to-date. When purchasing new consumables and optional items, check with your local dealer for more information on the latest products available.

Consumables

Ink cartridges

Epson recommends the use of genuine Epson ink cartridges to ensure the best printer performance. The use of non-genuine products may cause the printer to become unable to function as intended, including negative effects on the print quality as well as the printer itself. Epson cannot guarantee the quality or reliability of non-genuine products. Repairs for printer damage or failures that occur due to the use of non-genuine products are subject to charges, even during the warranty period.

Ink type	Color name	Color code
Reactive	Black	BK
	Cyan	C
	Magenta	M
	Yellow	Y
	Grey	GY
	Red	R
	Blue	BL
	Orange	OR
	Crimson	CR
	Grey	GY-G
	Cyan-P	C

Others

Product	Product No.	Notes
Wiper roll	C13S210128	Identical to the Wiper Roll supplied with the printer.
Washing scraper 2	C13S210167	Identical to the washing scraper supplied with the printer.
Insulating Tape	C13S400213	Use for applying glue.
Inner porous pad(1)	C13S400223	It is equivalent to the inner porous pad included with the cleaning pads on the far left.

Appendix

Product	Product No.	Notes
Inner porous pad(2)	C13S400224	It is equivalent to the inner porous pad included with the cleaning pads in the 2nd to 5th rows from the left.
Inner pad	C13S400225	Equivalent to the inner pad included with the flushing pads.
Sponge Roller	C13S400226	Identical to the sponge roller supplied with the printer.
Mist filter	C13S400227	Identical to the mist filter supplied with the printer.
Maintenance Liquid	C13T42X000	It is equivalent to the cleaning liquid included in the cleaning kit supplied with the printer. 20 L in volume. Used when cleaning the suction caps, around the print head, and so on.
Cleaning Stick	C13S090011	It is equivalent to the one included in the Cleaning kit that comes with the product. Used for cap cleaning.
Cleaning Cloth	C13S210050	It is a non-woven cloth for wiping off dirt and other contaminants from each component.
Cleaning kit	C13S210103 C13S210104	Identical to the Cleaning kit supplied with the product. The following consumable items are included in one maintenance set. It is used to clean the areas with ink residue. Cleaning liquid (x1) Cup (x1) Gloves (x16) Cleaning Stick (x50)
Waste ink bottle	C13S210071 C13S210072	Identical to the Waste ink bottle supplied with the printer.

Optional

Product	Product No.	Notes
2 inch Feeding Spindle	C12C938611	This is the feeding spindle used when loading the fabric. Identical to the feeding spindle supplied with the printer.
3 inch Feeding Spindle	C12C938621	
Grease Pump	C12C938631	Used for lubricating the moving parts of the print head and scan spindle with grease. Identical to the grease pump supplied with the printer.
Blade Supports	C12C938641	Used to secure felt rods or blades to the belt. Identical to the blade supports supplied with the printer.
Glue Blade	C12C938651	Used to apply glue uniformly to the belt. Identical to the blade supplied with the printer.
Glue Blocks	C12C938661	These parts are attached to both sides of the belt and used to prevent glue from leaking out of the belt sides. Identical to the glue blocks supplied with the printer.
Felt Rod	C12C938671	Attach felt and install this in the machine interior for use. Identical to the felt rod supplied with the printer.
Glue Bucket	C12C938681	Push this against the belt and scrape off the glue.

Appendix

Product	Product No.	Notes
High Tension Feeding Unit	C12C939761	Allows you to load and print multiple items of narrow fabric, such as cloths, at the same time.
Glue Removal Tool	C12C940131	Push this against the belt and scrape off the glue. Identical to the glue removal tool supplied with the printer.

Supported Fabric

The following fabric can be used with the printer.

Print quality is greatly affected by the type and quality of fabric used. Choose a fabric suited to the task at hand. For information on use, refer to the documentation supplied with the fabric or contact the manufacturer. Before buying fabric in large quantities, try printing on a smaller sample and check the results.

Roll core size	2 or 3 inches
Outer diameter of the fabric roll	2-inch/3-inch paper core size: 50.8 to 400 mm (2 to 15.75 inches)
Fabric width	300 to 1850 mm (11.81 to 72.83 inches)
Fabric thickness	5 mm (0.20 inches) or less
Roll weight	2-inch/3-inch paper core size: max. 100 kg (44.1 pounds)
Fabric type	Cotton, silk, wool, PET, PA, viscose, stretch fabrics, PET/cotton, others

Print Mode and Throughput

Prerequisites: Bidirectional printing, print width 1,500 mm (59.06 inches), **Flush on Belt** turned **On**, and carriage speed 100%

The throughput varies depending on the image, firmware, computer operating status, and print settings.

Print mode		Throughput [m ² /h]
Resolution [dpi]	Number of passes	
300 × 600	1	450
600 × 600	2	252
	3	168
	4	119
900 × 600	3	162
	4	123
	6	89








Appendix

Print mode		Throughput [m ² /h]
Resolution [dpi]	Number of passes	
1200 × 600	4	116
	6	89
	8	63
900 × 1200	6	80
	9	54
1200 × 1200	9	54






How to Read the Signal Lamps

The signal lamps indicate the status of the printer as shown in the following table. The lamps are, in order from the top, red, yellow, and green.

The following table is for standard settings. These settings may have been changed to suit your operating environment.

	Green	Yellow	Red	Status	Description
	Off	Off	Off	Power off	The power is off.
	On	Off	Off	Starting/Suspended	Doing start up operations after the power is turned on, or doing shut down operations after the power is turned off.
	On	Off	Off	Idling	Idling in a normal state. Ready to print.
	Flashing	Off	Off	Printing	Printing in a normal state.
	On	Off	Off	Consumable near end (idling)	Printing is possible, but printing will not be possible when the consumables need to be replaced.
	Flashing	Off	Off	Consumable near end (printing)	Printing can continue, but printing will stop and not be possible when the consumables need to be replaced.
	Off	On	Off	Printing cannot start	Printing not possible in current state for such reasons as a cover is open or a consumable is not loaded.

Appendix

	Green	Yellow	Red	Status	Description
	Off	On	Off	Error (recoverable)	An error has occurred so printing is not possible. Resolve the error and printing can be done.
	Off	Off	On	Fatal error (service call)	An error has occurred that cannot be resolved, so printing is not possible.
	On	Off	Off	Doing maintenance (jobs cannot be received)	A maintenance function is being executed. Print jobs cannot be received.
	On	Off	Off	Pause mode (printing stopped)	Printing is stopped.
	Flashing	Off	Off	Pause mode (waiting to stop printing)	Waiting to stop printing. Printing stops according to the specified operation.

System Requirements

Each software can be used in the following environments. (As of February, 2025)
The supported operating systems may change.

Depending on the software you are using, system requirements may vary.
For more information, see the user's manual for the software you are using.

Epson Edge Dashboard



Important:

Use a computer with Epson Edge Dashboard installed under the following conditions.

The printer cannot be monitored correctly if these conditions are not met.

- The hibernation function should not be enabled.
- Disable the sleep function to prevent the computer from entering sleep mode.

Windows

Operating system (OS)	Windows 11 Windows 10 x64
CPU	Multi-core processor (3.0 GHz or faster recommended)
Free memory	4 GB or more
Hard disk drive (free space during installation)	2 GB or more

Appendix

Display resolution	1280 x 1024 or better DPI Setting : Normal size
Communication interface	Hi-Speed USB Ethernet 1000Base-T
Browser	Microsoft Edge (recommended)

Mac

Operating system (OS)	Mac OS X 10.9.5 or later
CPU	Multi-core processor
Free memory	4 GB or more
Hard disk drive (free space during installation)	2 GB or more
Display resolution	1280 x 1024 or better DPI Setting : Normal size
Communication interface	Hi-Speed USB Ethernet 1000Base-T
Browser	Safari 6.0 or later (recommended)

Epson Edge Print

The following shows the recommended environment for using this software.

Operating system (OS)	Windows 11 Windows 10 x64
CPU	Intel® Core™ i7 -12700K 3.6 GHz or faster, 12 core/20 threads or more
Free memory	32 GB or more
Storage (free space during installation)	512 GB or more (M.2 SSD recommended)
Display resolution	1280 x 1024 or better
Communication interface	SuperSpeed USB (for performing print operations) Ethernet 1000Base-T (for print data communication between computers)

Epson Rob file print tool

Operating system (OS)	Windows 11 Windows 10 x64
CPU	Intel Core-i7 3.4 GHz or faster
Free memory	16 GB or more

Appendix

Storage (free space during installation)	SSD 50 GB or more (NVMe recommended)
Display resolution	1280 x 768 or higher
Communication interface	USB 3.0 (for performing print operations) Ethernet 100Base-TX/1000Base-T (for print data communication between computers)

Web Config

Windows

Browser	Microsoft Edge, Mozilla Firefox*, Google Chrome*
---------	--

Mac

Browser	Safari*, Mozilla Firefox*, Google Chrome*
---------	---

* Use the latest version

Moving and Transporting the Printer

Contact your dealer or Epson Support for assistance before moving or transporting the printer.

Specifications

Printer Specifications

Class 1 laser product based on the IEC 60825-1: 2014 standard.

Printer Specifications	
Printing method	On-demand ink jet
Nozzle configuration	400 nozzles × 2 rows × 4 chips × 18 colors
Resolution (maximum)	300 × 300 × 16 stack
Control code	ESC/P raster (undisclosed command)
Fabric feeding method	Adhesive belt
Temperature and humidity (without condensation)	

Appendix

Printer Specifications	
While operating	20 to 35°C (68 to 95°F), 40 to 70% Recommended: 22 to 28°C (71.6 to 82.4 °F), 40 to 60%
When the power is on (during maintenance)	10 to 35°C (50 to 95°F), 35 to 80%
Environment not supplied with power (After charging ink)	10 to 35°C (50 to 95°F), 10 to 85% (Storage period: within 1 month at 40°C [104°F])
Temperature and humidity range Gray area: While operating Cross-hatch line area: Recommended	<p>The figure consists of two graphs. The top graph shows temperature and humidity ranges in Celsius (°C). The y-axis represents humidity (%) from 20 to 90. The x-axis represents temperature (°C) from 10 to 40. A gray shaded area (operating range) is bounded by 20°C to 35°C on the x-axis and 40% to 70% on the y-axis. A cross-hatched area (recommended range) is bounded by 22°C to 28°C on the x-axis and 40% to 60% on the y-axis.</p> <p>The bottom graph shows temperature and humidity ranges in Fahrenheit (°F). The y-axis represents humidity (%) from 20 to 90. The x-axis represents temperature (°F) from 50 to 104. A gray shaded area (operating range) is bounded by 68°F to 95°F on the x-axis and 40% to 70% on the y-axis. A cross-hatched area (recommended range) is bounded by 71.6°F to 82.4°F on the x-axis and 40% to 60% on the y-axis.</p>
Noise	While printing: 70dB (A) or less

Appendix

Printer Specifications	
Dimension	Main printer unit (with ink supply units) When stored: 4,750 [W] × 2,660 [D] × 1,830 [H] mm (187.01 [W] × 104.72 [D] × 72.05 [H] inches) Maximum: 4,840 [W] × 3,310 [D] × 1,940 [H] mm (190.55 [W] × 130.31 [D] × 76.38 [H] inches)
	Main printer unit (without ink supply units) 4,200 [W] × 2,660 [D] × 1,830 [H] mm (165.35 [W] × 104.72 [D] × 72.05 [H] inches)
	Ink supply unit 550 [W] × 1,990 [D] × 1,450 mm [H] (21.65 [W] × 78.35 [D] × 57.09 [H] inches) or more
Work space	6,250 [W] × 4,660 [D] × 1,830 [H] mm (246.06 [W] × 183.46 [D] × 72.05 [H] inches) Desk for computer (for reference): 500 [W] × 500 [D] × 800 [H] mm (19.69 [W] × 19.69 [D] × 31.5 [H] inches)
Weight	Main printer unit (without ink supply units) 2190 kg (4828.12 pounds)
	Ink supply unit 160 kg (352.74 pounds)

Appendix

Factory Facilities

Factory facilities		
Electrical power	Rated voltage	3-phase Y-connection 380 - 415 V 50/60 Hz 3-phase (M5 terminal), Neutral (M5 terminal) and Earth (M5 terminal)
	Rated power	2.6 kW
	Rated apparent power	10.1 kVA
	Rated short circuit current	5 kA
	Leakage current	10 mA or less
	Rated current	14 A
Pressurized air	Tube	5 mm (0.20 inches) inner diameter, 8 mm (0.31 inches) outer diameter
	Pressure	0.45 to 1 MPa
Water	Tube	15 mm (0.59 inches) inner diameter, 22 mm (0.87 inches) outer diameter
	Flow rate	90 L/h or more
	Water temperature	20 to 25°C (68 to 77°F)
Wastewater	Tube	25 mm (0.98 inches) inner diameter, 33 mm (1.30 inches) outer diameter
Exhaust	Aluminum piping	Inner diameter 275 mm (10.83 inches)
	Aluminum tape	Bands
	Flow rate	900 m ³ /h or more
External drying unit connector	Dedicated connector	

Interface Specifications

Interface Specifications	
USB port for a computer	SuperSpeed USB We recommend using a USB cable with a ferrite core to avoid disturbance noise.
Wired LAN compliance standard	Ethernet 1000Base-T*1 Used to share printer information and so on with Epson Cloud Solution PORT. Use SuperSpeed USB when transferring print data between the computer and this printer.

Appendix

Interface Specifications	
Network printing protocols/ functions	EpsonNet Print (Windows)*2 Standard TCP/IP (Windows)*3 WSD (Windows)*3 Bonjour (Mac)*3 IPP (Windows)*3 IPP (Mac)*3 IPPS (Mac)*3 FTP*3
Security standards/protocols	IEEE802.1X (Ethernet)
	IPsec (v4/v6), IP filtering
	SSL/TLS: HTTPS Client (Epson Connect, Firmware Update using Web Config) SNI (HTTPS Client) HTTPS Server (Web Config) IPPS Server IPP -> IPPS (TLS Server Requested Upgrade) Root certificate (client) Root certificate version 2.03 Root certificate update (client) CA-signed certificate (server) CA certificate CSR generation (server) Self-signed certificate (server) EC key CSR/self-signed certificate generation (server) Certificate, secret key import
	OpenSSL version: 1.1.1k Supported TLS versions: 1.0/1.1/1.2/1.3 Default encryption strength: 128
	MIB access authentication, encryption: SNMPv3

*1 Use a shielded twisted pair cable (category 5e or better).

*2 IPv4 compliant.

*3 IPv4 and IPv6 compliant.

Ink Specifications

Ink Specifications	
Type	Special ink cartridges
Ink type	Reactive
Use by date	See the date printed on the ink cartridge (stored at normal temperature).
Print quality guarantee expiration	Six months (from date ink cartridge is opened)

Appendix

Ink Specifications	
Shaking	When installed <input type="checkbox"/> Stir count: 10 times
Storage temperature and humidity (when in its packaging or installed in the printer)	10 to 35°C (50 to 95°F), 35 to 85% (no condensation)
Ink cartridge capacity	10 L
Ink cartridge dimensions	150 [W] × 235 [D] × 412 mm [H] (5.90 [W] × 9.25 [D] × 16.22 [H] inches)

Precautions and Applicable Standard for This Product

Restriction of Use for This Product

When this product is used for applications requiring high reliability/safety, such as transportation devices related to aviation, rail, marine, automotive, etc.; disaster prevention devices; various safety devices, etc.; or functional/precision devices, etc.; you should use this product only after giving consideration to including fail-safes and redundancies into your design to maintain safety and total system reliability. Because this product was not intended for use in applications requiring extremely high reliability/safety, such as aerospace equipment, main communication equipment, nuclear power control equipment, or medical equipment related to direct medical care, etc., please make your own judgment on this product's suitability after a full evaluation.

Precautions When Using the Control Panel

The screen may contain pixels that do not light up, or pixels that always light up. Also, due to the properties of the liquid crystal, the brightness may be uneven. However, these are not malfunctions.

If it becomes dirty, wipe it with a dry, soft cloth. Do not use water or chemical cleaners.

If hit by a strong impact, the touch panel surface may break. If the touch panel surface is cracked or broken, request repair. Do not touch the broken section or fragments.

Touch the panel softly with your fingers. Do not apply force or operate the panel with your nails.

Do not operate the panel with pointed objects, such as ball pens or pointed pens.

If the interior of the control panel is exposed to condensation due to rapid changes in temperature or humidity, it could cause deterioration in operability.