

EPSON

ML-8000U / ML-8000

User's Manual

M00135014 EN
Rev. O

Original instructions

Cautions and Trademarks

Cautions and Trademarks

Cautions

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Cautions and Trademarks

Product Overview

The ML-8000U and ML-8000 are inkjet fabric printers. They can reach a print speed of 162 m²/h when the resolution is 600 x 600 dpi and two passes are performed. The ink supply unit can hold two ink cartridges of each of the eight colors to supply ink to the printer.
Before using this machine, make sure you receive safety and operation training from your dealer or Epson Support.

Images in This Manual

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



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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).

The latest manuals are available from qualified service personnel.

Safety Precautions	This manual explains the safety precautions. 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 QR code label at the bottom left of the control panel.

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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

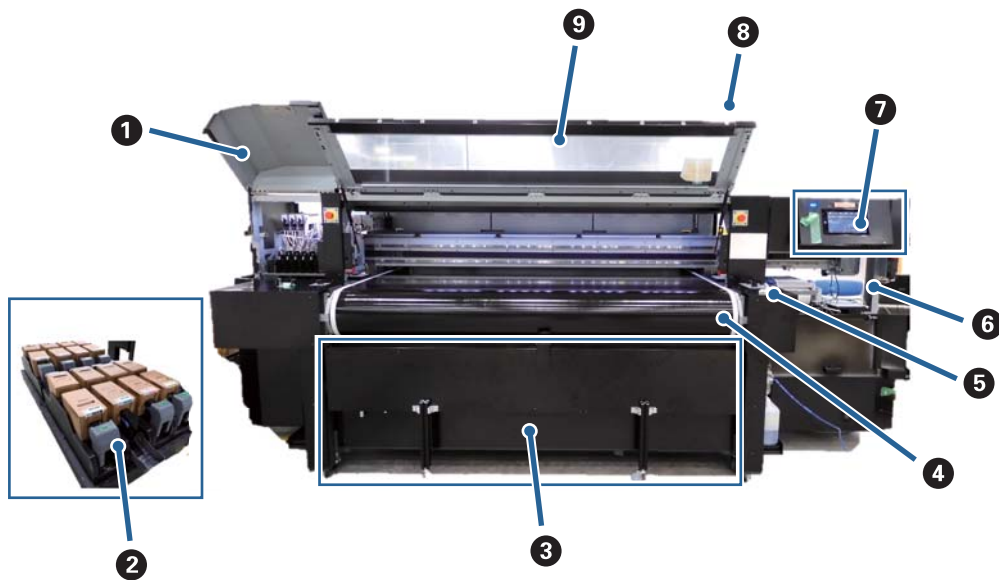
 Warning:	This symbol indicates content where mishandling the machine by ignoring this symbol can result in death or serious injuries.
 Caution:	This symbol indicates content where mishandling the machine by ignoring this symbol can result in injury or property damage.
	Indicates actions you must not 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



1 Maintenance cover (left)

Open this cover to clean the area around the caps. This is normally closed when using the printer.

2 Ink supply unit

Supplies the printer with ink from the ink cartridges. Two ink cartridges for each color can be inserted.

3 Belt cleaning unit

This unit cleans ink and other foreign material adhering to the belt. Open this cover to clean the cleaning brushes and washing scraper.

4 Belt

This attaches and fixes the fabric for smooth printing and fabric feeding.

5 Front panel

 ["Front panel" on page 18](#)

6 Maintenance cover (right)

Before Use

Open this cover to clean the area around the print head and the replacement for the wiper roll. This is normally closed when using the printer.

7 Control panel

 ["Control panel" on page 17](#)

8 Signal lamp

Lamps light or flash in 3 colors to notify you of the status of the printer. Basically, the meaning of the lamps' colors are as follows.

The color of the lamps, in order from top to bottom, are red, yellow, and green.



Red : Critical or dangerous status

Yellow : Error or imminent danger status

Green (on) : Ready status

Green (flashing) : The printer is operating normally

The printer notifies you about its status in detail with a combination of the lamps' colors and lighting/flashing. See the following for an explanation of the signal lamp.

 ["How to Read the Signal Lamps" on page 453](#)

9 Front cover

Open this cover when cleaning the inside of the printer or removing jammed fabric. This is normally closed when using the printer.

Front Section



Before Use

1 Cap

Except during printing, these caps cover the print head nozzles to prevent them drying out. Depending on the dirtiness, a message about cleaning appears on the control panel's screen. Clean according to the message.

 [“Cleaning the Caps” on page 209](#)

2 Inside light

Illuminates the inside of the printer to make it easy to check print results and areas for maintenance. If the surface becomes dirty due to ink mist, clean it.

 [“Cleaning the Inside Light” on page 233](#)

3 Flushing box

Collects ink discharged from the print head. Depending on the dirtiness, a message about cleaning appears on the control panel's screen. Clean according to the message.

 [“Inspecting/Cleaning the Flushing Pad” on page 194](#)

4 Suction cap

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

Clean the suction caps before doing Print Head Refresh.

Depending on the dirtiness, a message about cleaning appears on the control panel's screen. Clean according to the message.

 [“Inspecting/Cleaning the Suction Caps” on page 220](#)

5 Wiper unit

The wiper removes ink from the surface of the print head nozzles. The wiper roll that is loaded on the wiper unit is a consumable item. Replace when a message is displayed on the control panel prompting you to do so.

 [“Replacing the Wiper Roll” on page 242](#)

6 Print head

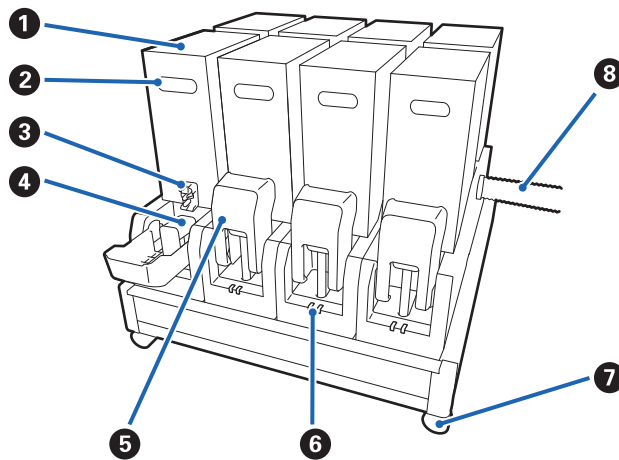
Prints by ejecting ink while moving left and right. When print results are dirty, check for dirt stuck to the print head and clean it, if necessary.

 [“Inspecting/Cleaning Around the Print Head” on page 201](#)

7 Head stroke sensor

Detects if the fabric has curled or been lifted up to prevent collisions with the print head.

Before Use

Ink supply unit
**1 Ink cartridges**

Two ink cartridges for each color are inserted. Normally, one ink cartridge continues to be used. Once the ink cartridge is expended, the printer automatically switches to the other ink cartridge. As a result, even if ink is expended during printing, the ink cartridge can be replaced without interrupting printing. You can also manually switch to the other ink cartridges of the same color if necessary. The switching operation is done from the Home screen.

 [“Home Screen” on page 23](#)

2 Handle

Grasp this with your hand to hold the ink cartridge. With new products, the holes are shut, so open the holes by pressing them with your hand. There are four handles on each ink cartridge, one on every side.

3 Ink supply port

Ink from the ink cartridge comes out of here. Take them out from the new ink cartridges and install them.

4 Connector

Attach this to the ink supply outlet, and then connect the ink supply unit and the ink cartridge.

5 Ink cartridge cover

Prevents accidental contact with the ink cartridge's connector. Normally, this is raised when using the printer.

6 Cartridge check lamp

Lights or flashes in 2 colors to notify you of the status of the ink cartridge that is inserted. The color of the lamp on the left side is blue and the color of the lamp on the right side is orange.

 [“How to read the cartridge check lamp” on page 13](#)

7 Casters


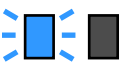



Attached to the four legs. Always lock these when using the printer.

Before Use

8 Ink supply tube

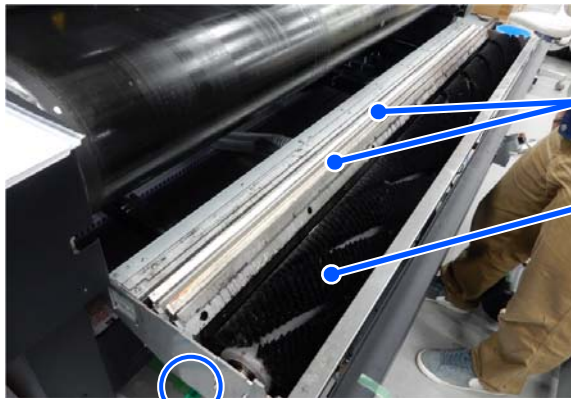
Supplies the printer with ink from the ink cartridges.

How to read the cartridge check lamp

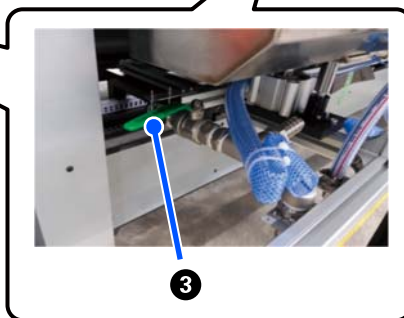
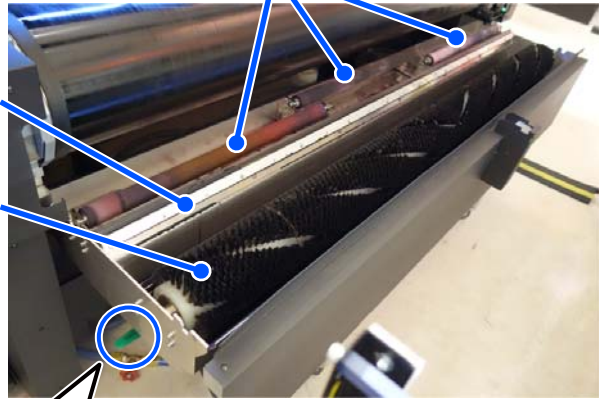
	Left side (blue) is lit	Ink is being supplied to the printer. Do not remove the ink cartridges.
	Left side (blue) is flashing	It is time to shake the ink cartridges. Remove the ink cartridges and shake them. ☞ "Periodically Shaking the Ink Cartridges" on page 267
	Right side (orange) is lit	An error or warning occurred. 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	No error. The ink cartridge can be removed, if necessary.

Belt cleaning unit

ML-8000



ML-8000U



1 Washing Scraper

Before Use

Wipes away water droplets after belt cleaning.

② Cleaning brushes

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

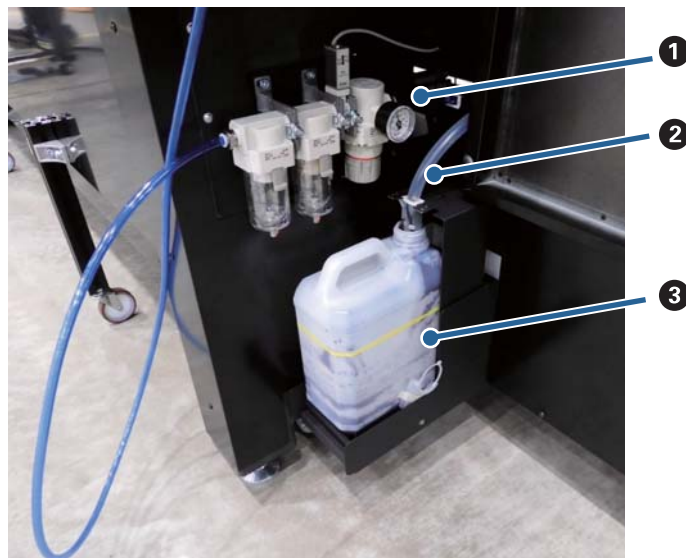
③ Drain valve

Open the valve to drain water that accumulated in the belt cleaning unit. This is normally closed when using the printer.

④ Sponge roller (ML-8000U only)

Wipes away water droplets after belt cleaning.

Waste Ink Tank



① Air supply regulator

Supplies compressed air in order to operate the machine. The machine will not operate if the specified air pressure is not supplied. An air pressure that is higher than the specified air pressure could cause the machine to malfunction. Please check the air pressure before operating the machine.

 [“Checking the Air Pressure” on page 70](#)

② Waste ink tube

Tubes for ejecting waste ink. Be sure the end of this tube is in the waste ink bottle while the printer is in use.

③ Waste ink bottle

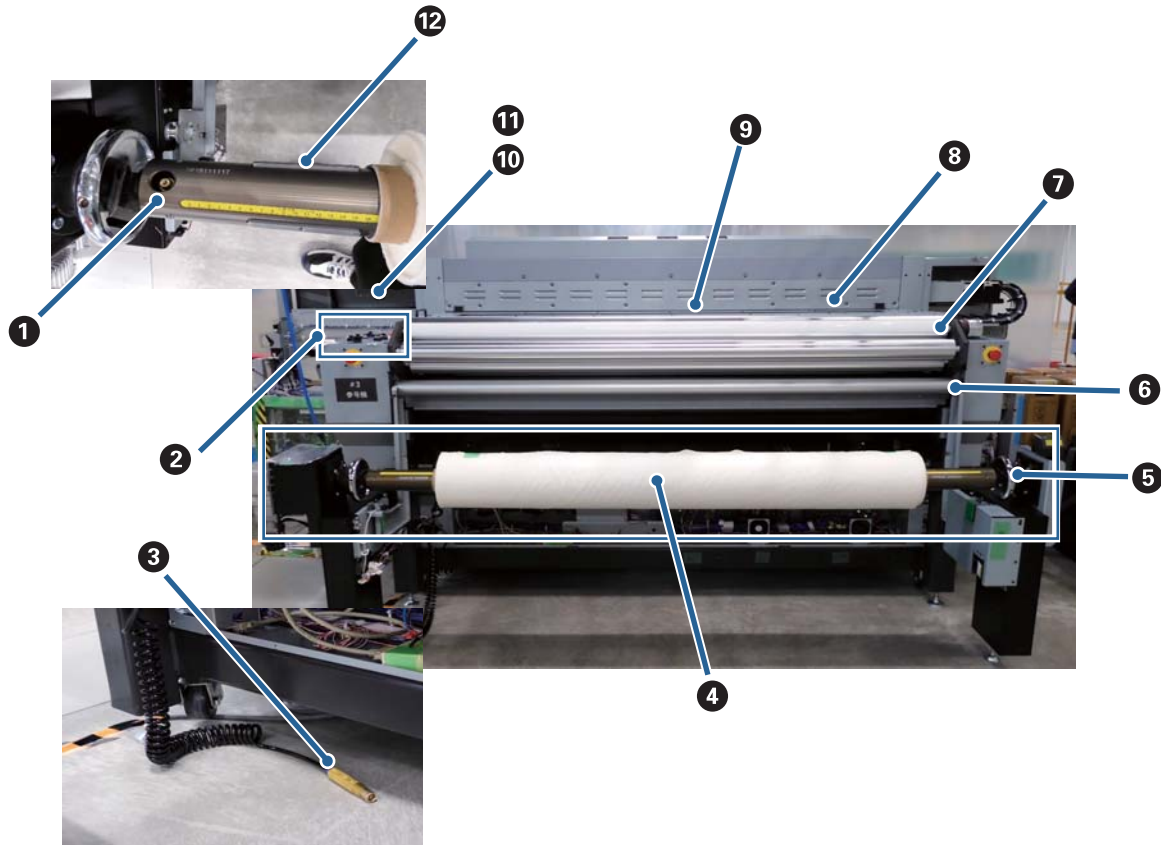
Before Use

Waste ink collects in this bottle.

Replace it with a new waste ink bottle when a message is displayed on the control panel prompting you to do so.

 [“Disposing of Waste Ink” on page 241](#)

Rear / Rear Section



1 Air inlet

Port for putting air into the feeding spindle. Use the air inflating tool to insert air.

2 Rear panel

 [“Rear panel” on page 19](#)

3 Air inflating tool

Tool for putting air into the feeding spindle. Insert this into the air inlet.

4 Feeding unit

Set the fabric to be used for printing.
See the following for supported fabric.

 [“Supported Fabric” on page 451](#)

Before Use

5 Locks

Use these when attaching or removing the feeding spindle.

6 Tension bar

After loading the fabric, push this toward the rear of the feeding unit to apply tension to the fabric.

7 Tension roller

Applies tension (braking) to the fabric during printing. The tension can be adjusted using the tension adjustment dial on the rear panel.

 [“Rear panel” on page 19](#)

8 Pressure roller

Presses down on the fabric during printing to attach it to the belt. The pressure can be adjusted using the pressure adjustment handle on the back of the product.

 [“The print is not positioned properly on the fabric” on page 439](#)

9 Rear cover

Open this cover when loading fabric. This is normally closed when using the printer.

10 LAN port

Connects the LAN cable. Use a shielded twisted pair cable (category 5e or higher).

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 (1000Base-T).

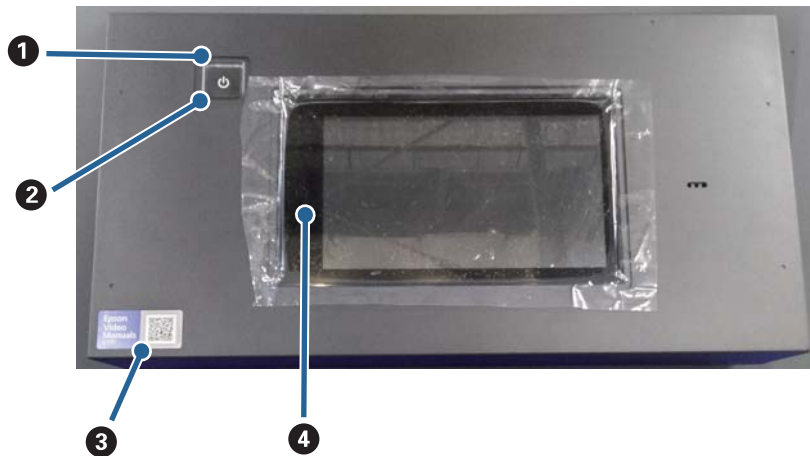
11 USB port

Connects the USB cable.

12 Stopper

When air is injected into the feeding spindle, the stopper inflates and fixes the fabric winding core.

Before Use

Control panel**1**  **light (Power light)**

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

On : The power is on.

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.

3 **QR code label**

You can watch a video of each maintenance procedure on YouTube.
Scan the QR code from your device to access the videos.

4  **button (Home button)**

Touch this while it is lit to return to the Home screen.

If the Home button cannot be used during operation, the lamp turns off.

Before Use

Front panel**1 Belt speed volume**

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 when the front cover is closed and when the rear cover is open.

2 Pause button

Use this button to pause printing and move the print head to the capping station. 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 panel

**1 Foreign material detection sensor controller**

Use this to set and display the detection threshold value of the foreign material detection sensor.

 [“Setting the Foreign Material Detection Sensor” on page 98](#)

2 Pressure roller switch

Use this switch to change the operation of the 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, manually return the switch to the standby position (center).

Left : Moves the pressure roller up/down. Turn to the left to move it up or down. However, the roller moves up automatically if it was down for a given amount of time when the belt is stopped.

Right : Moves the pressure roller forward/backward. Turn to the right to operate, and return it to the center to stop. The roller stops in the up position when stopped.

3 Tension meter

Before Use

Displays the tension on the fabric from the tension roller.

Specified value: 0.15 Mpa

If wrinkles still occur, raise this to 0.3 Mpa.

This displays 0 when the tension switch is off.

4 Slack detection switch

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

Off : Disabled

On : Enabled

5 Feeding roller switch

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 this machine.



(Right) : Prints on the outer side of the fabric roll.
The feeding spindle rotates toward the front of this machine.

6 Pause button

Use this button to pause printing and move the print head to the capping station.
Touch the **Resume** button on the control panel to resume printing.

7 Backfeed button

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

8 Feed button

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

9 Tension adjustment dial

Adjusts the tension applied to the fabric. Raise the tension if wrinkles still occur in the fabric.
Perform adjustments while watching the tension meter.

Turn to right : Raises the tension.

Turn to left : Lowers the tension.

10 Tension switch

Use this switch to enable/disable the tension.

Off : Disabled

Before Use

On : Enabled

11 Rear cover lock lever

When opening the rear cover, push this lever to Unlock (the left side).

When closing the rear cover, close the cover and then push this lever to Lock (the right side). This machine will not operate if the lock is not engaged.

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 428](#)

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 buttons on the machine front and two on the rear.

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



Front



Before Use

Rear



Releasing an emergency stop

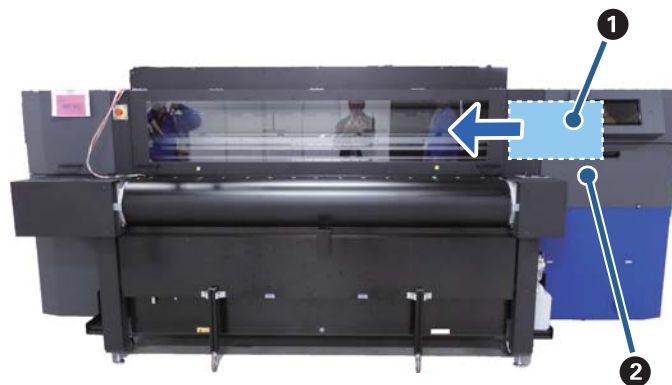
To release the emergency stop, turn the button to the right. Turn off the breaker (Main Power) on the back of the machine, and then turn it back on. Press the power button on the control panel to restart the machine.



⚠ Caution:

If the print head stops on the suction cap, move the print head manually over the belt before releasing the emergency stop. ➡ [“Manually Moving the Print Head” on page 434](#)

If you release the emergency stop without moving the print head, the print head and the suction cap may collide causing a malfunction to occur.



- ① Print head
- ② Suction cap

Understanding and Operating the Display

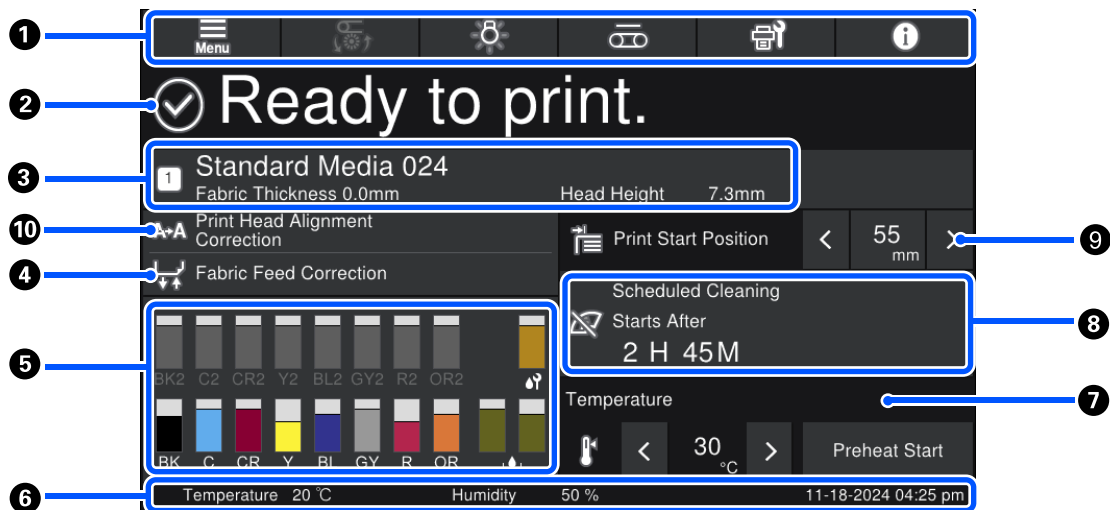
This chapter describes how to understand and operate the screen layout, using the Home screen, Menu screen, and the display for operating procedures screen as an example.

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.



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.



Switch between raised/lowered belt cleaning unit

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



: Lowered status



: Raised status

Before Use

- ❑ 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.



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 415](#)



Fabric Feeding Device Settings

You can switch between using an external feeding unit or drying reel, and turn the foreign material detection sensor On/Off.

Do not set Belt Position Control to Off except for when a malfunction occurs.

 [“General Settings Menu” on page 415](#)





Maintenance

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




Information

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.

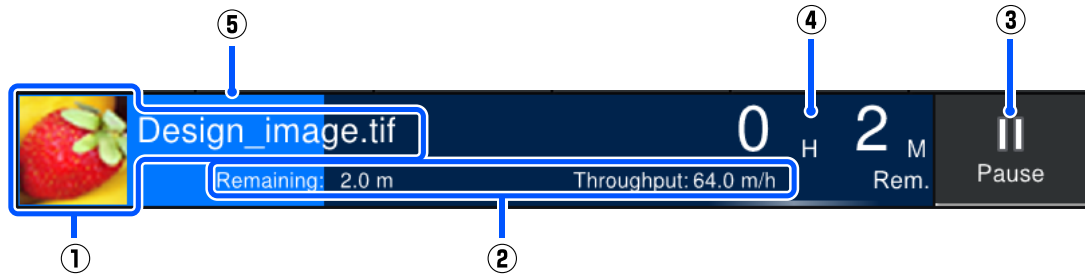
2 Messages

Before Use

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

 [“When a Message is Displayed” on page 430](#)

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 Length Remaining, Print Speed

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 423](#)

④ Fabric Feed Adjustment information during printing

If you perform Fabric Feed Adjustment while printing, the adjusted values appear here. Touching the display area shows the settings screen.

 [“Changing settings while printing” on page 28](#)

Before Use

5 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 448](#)

The bar at the bottom indicates the front ink cartridge, while the bar at the top indicates the back ink cartridge

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 has elapsed since the ink cartridge connector was disconnected. Immediately connect the connector, 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.



An ink cartridge's connector 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.



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.

6 Footer

Before Use

Displays the current date and time and the temperature and humidity around the printer. If the temperature and humidity are out of range for the printer's operating environment,  appears. For high-quality printing, use the printer within the range of the printer's operating environment. The footer also appears similarly on other screens.

7 Adhesive Belt Heater Information

Displays the Adhesive Belt Heater's Preheat Start button and the heater's temperature setting. When you touch the Preheat Start button, it preheats to the value set for the heater's temperature. Touch the Preheat Start button when you want to start preheating before receiving a print job. Touching the display area for temperature displays the settings screen. When you select 1 to 4 passes, the temperature may not rise above 35°C.

 ["Job Setting menu" on page 53](#)



Heating



Cooling

8 Notice on when to do maintenance or periodic cleaning

Displays a notice, in the following situations, about when to do Maintenance Cleaning (when the machine is not operating)* on the left and when to do Periodic Cleaning on the right. For Periodic Cleaning, either Print Duration, Print Job(s), or Print Length appears, according to the settings.

Maintenance cleaning	: 24 hours in advance
Periodic cleaning (Print Duration)	: 1 hour in advance
Periodic cleaning (Print Length)	: 20 m (65.6 feet) in advance
Periodic cleaning (Print Jobs)	: 20 jobs in advance

The frequency of the above cleanings can vary greatly depending on the ambient temperature of the print heads. Also, Maintenance Cleaning may be performed when the power is turned on again, regardless of the notifications displayed.



Touching the display area shows the screen for cleaning in advance. If you want to print when it is almost time to implement cleaning, implementing cleaning in advance is effective at preventing printing from being interrupted midway.

* Maintenance Cleaning consists of head cleaning that is performed automatically by the printer after a certain period of time to keep the print head in optimum condition. You can set Maintenance Cleaning from the Maintenance Setting menu.

 ["General Settings Menu" on page 415](#)

9 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.

Touching   allows you to change the values.

Before Use

10 Print Head Alignment during printing

If you perform Print Head Alignment while printing, the adjusted values appear here. Touching the display area shows the settings screen.

 [“Changing settings while printing” on page 28](#)











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 430](#)

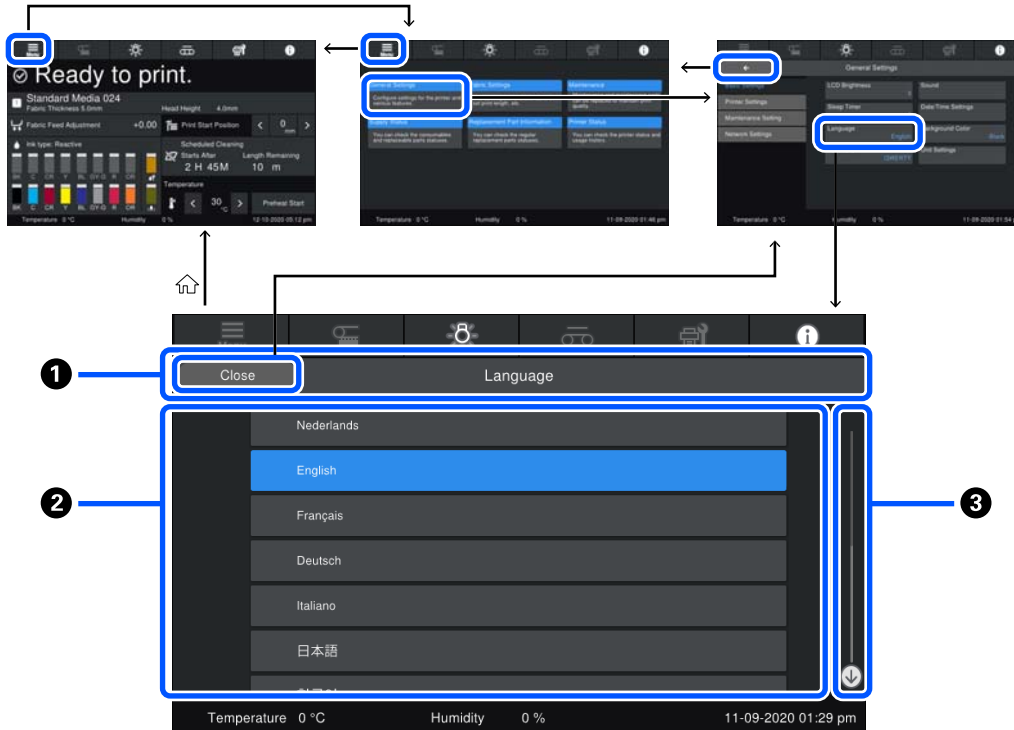
This section explains an example of how to change the Fabric Feed Adjustment and Print Head Alignment to compensate for banding.

- 1 Touch the Fabric Feed Adjustment information area.
The Settings screen is displayed.
- 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 adjustment.
If the problem is not resolved, touch  to proceed to the next step.
- 3 Touch the Print Head Alignment information area.
The Adjustment screen is displayed.
- 4 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 improve, the adjustment is complete. Touch  to finish the adjustment.
If there is no improvement, touch  to finish the adjustment and perform the **Manual(Simple) Print Head Alignment**.
 [“Print Head Alignment” on page 111](#)

Before Use

Menu Screen

Touch  on the Home screen to display the Menu screen.



1 Screen name display area



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

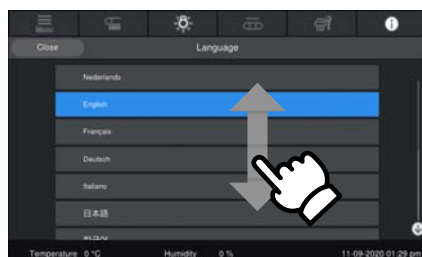
2 Operation area

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.



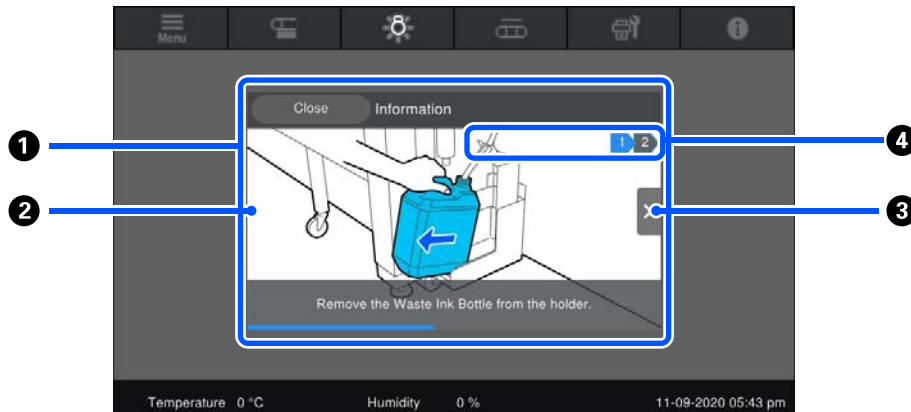
Before Use

Instructions Screen

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

How To...

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

Displays the previous step.

3 Next step button

Displays the next step.


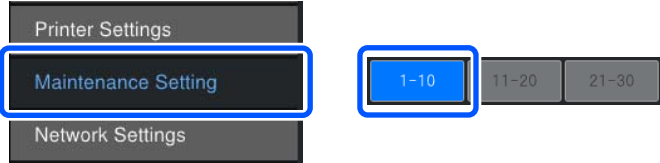
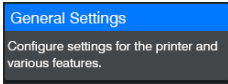


4 Step number

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.

Before Use

<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 456](#)

Interior Lighting

The printer should be installed and used in a location subject to an illuminance of 500 lux or more.

The following provides the recommended lighting environment for the EN 12464-1.


Before Use

Work Type	$\bar{E}_{m,r}$ [lx]	$\bar{E}_{m,u}$ [lx]	U_o	Ra	R _{UGL}	\bar{E}_z [lx]	$\bar{E}_{m, wall}$ [lx]	$\bar{E}_{m, ceiling}$ [lx]	T _{CP}
Automatic fabric printing	500	-	0.60	90	25	100	100	50	-
Color inspection; fabric control	1000	1500	0.70	90	19	150	150	100	4000K \leq T _{CP} \leq T6500K

$\bar{E}_{m,r}$	minimum maintained illuminance
$\bar{E}_{m,u}$	upper maintained illuminance
U_o	minimum illuminance uniformity
Ra	minimum color rendering indices
R _{UGL}	maximum Unified Glare Rating limit
\bar{E}_z	minimum cylindrical illuminance
$\bar{E}_{m, wall}$	minimum average illuminance on walls
$\bar{E}_{m, ceiling}$	minimum average illuminance on ceilings
T _{CP}	Correlated color temperature

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 456](#)
 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, 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 or ink supply tube. Doing so could cause ink to leak inside or around the printer or they could be disconnected from the printer.

Before Use

- ❑ 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 172](#)
 - ❑ 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.
[☞ “Manually Capping the Print Head” on page 283](#)
- * Capping is a function that automatically covers the print head to prevent it from drying out. When it is capped, the print head is positioned at the far left.
- ❑ When the power is on, do not remove the power plug or cut the power at the breaker. 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.

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 printer is not used for over 1 month. 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 washed using the cleaning fluid in the cleaning cartridge, to prepare 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 a long time, check the print heads for clogging before you start printing. Clean the heads if the print heads are clogged.
[☞ “Print Head Nozzle Check” on page 274](#)
- ❑ The pressure rollers may crease the fabric left in the printer. 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 an extended period of time without performing capping may cause print quality to decline.
If the printer is not capped, turn it off and on again.

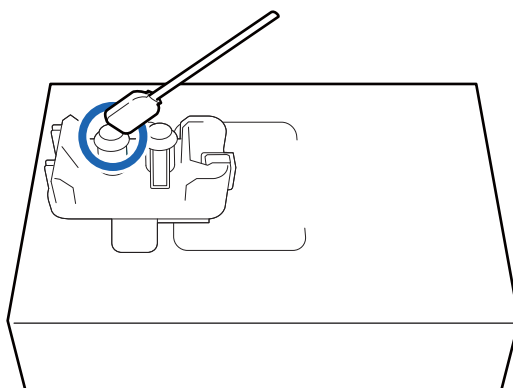
Before Use

- ❑ 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.
- ❑ 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 on the ink supply ports of 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 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.

Before Use

- ❑ 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.
- ❑ Depending on the type of ink, you may need to periodically remove and shake the ink cartridges installed in the machine.
 [“Periodically Shaking the Ink Cartridges” on page 267](#)

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.

Supplied Software

Name	Summary
Epson Edge Dashboard	<ul style="list-style-type: none"> ❑ You can easily acquire the following variety of information provided by Epson on the internet. <ul style="list-style-type: none"> ❑ Print settings (EMX) files ❑ Information from Epson ❑ With Epson Edge Dashboard installed, you can monitor the status of the printer connected to a computer over a network or USB connection. ❑ You can easily make and change fabric settings from a computer and write to the printer.
Epson communications drivers	(Windows only) 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)	This is a software RIP that can be effortlessly used with easy-to-understand operations. Epson Edge Print is only supported on the Windows OS.
Epson Rob file print tool	This is a tool for printing data in the Rob format.

Before Use

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	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.

How to Use Epson Edge Dashboard

Instructions for Starting

Epson Edge Dashboard is a web application.

- 1 Click the Epson Edge Dashboard, and select Show Epson Edge Dashboard.



- 2 The Epson Edge Dashboard starts.

For details, see the help for Epson Edge Dashboard.

Registering the Printer

The Epson Edge Dashboard can monitor, manage, and copy fabric settings to registered printers. On Windows computers, printers are registered automatically. This allows you to monitor and manage them immediately after starting the Epson Edge Dashboard. If your printer is not automatically registered, check that you are using it under the following conditions.

- A communication driver provided with the printer has been installed on a computer
- The computer and printer are connected
- The printer is on standby

Printers are not automatically registered to Mac machines. Register your printer manually from the Printer Registration screen. This screen is displayed upon starting up Epson Edge Dashboard for the first time. For details, see the help for Epson Edge Dashboard.

Checking and Managing the Printer's Status

Follow the next steps on the Printer Operation screen to check and manage the printer's status. The Printer Operation screen provides a view of the same status information as the printer's control panel screen. It also allows you to perform standard maintenance operations.

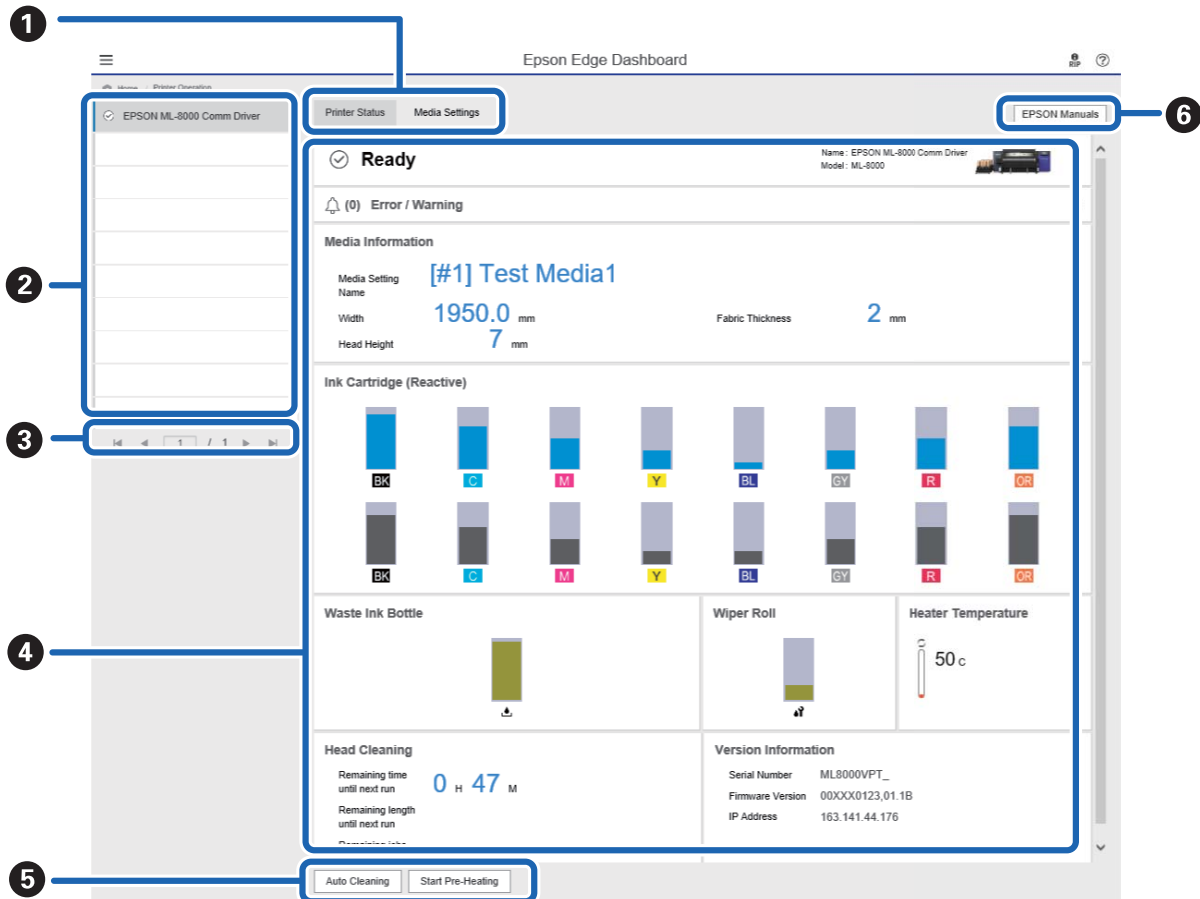
Before Use

- 1 Select Printer Operation from the menu. Alternatively, on the Home screen, click the area surrounding the text describing the status of the relevant printer.

The Printer Operation screen is displayed.

- 2 Make sure that the Printer Status tab is selected.

Screen Layout



1 Tabs for Switching Views

Allows you to switch between Printer Status and Fabric Settings views. Click tab to switch views. Upon initial screen display, the Printer Status view is shown.

[“Downloading and Copying Fabric Settings of EMX File” on page 38](#)

2 List of Registered Printers

Register the printer to view it on this list.

- When you select this printer, its status is displayed in the printer status display area (4).
- Click at the top-right corner of the list to collapse the list. Click to expand the list.

3 Page Controls

Before Use

If the list of registered printers covers multiple pages, you can specify a page number to go to, and go to the first page, previous page, next page, or last page by clicking the icons.

4 Printer Status Display Area

Select the printer to view the following information on the list of registered printers ②.

- Printer's current status
- Errors/Warnings
 - Notifies you of errors and warnings that are occurring with the printer. Click the item you want to check to display more details.
Click + to expand the display area. Click - to collapse the display area.
- Status
 - Displays the same status as that displayed on the printer's control panel screen.
- Version Information

5 Function buttons

Allow you to perform standard maintenance operations.

- Click the buttons to run the function according to the same procedure as when using the printer's control panel.
- If the printer is not available for maintenance operations, this button is grayed out. You can perform maintenance when the button is available.

6 EPSON Manuals Button

Click to view your printer's "Manual".

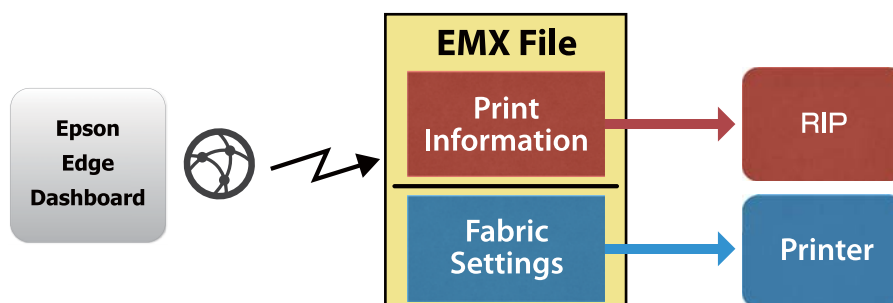
Downloading and Copying Fabric Settings of EMX File

Configuring optimum print settings for the fabric you use can require pain, time, and efforts.

You can use print setting file (EMX file) provided by Epson, which provides optimum print quality settings for the commercially available fabric being used. (The provided files differ according to the country and region in which you live.)

An EMX file is a single print settings file containing the following information necessary to print properly on commercially available fabric.

- Fabric Settings: Settings for each type of fabric used by the printer
- Print Information: Settings for ICC profiles that are used in RIP, the number of passes, the resolution, and so on



Before Use

Download an EMX file and copy the fabric setting values in the downloaded EMX file to the printer from the Fabric Settings screen of Printer Operation on the Epson Edge Dashboard.

Use the following procedure to view the Fabric Settings screen of Printer Operation.

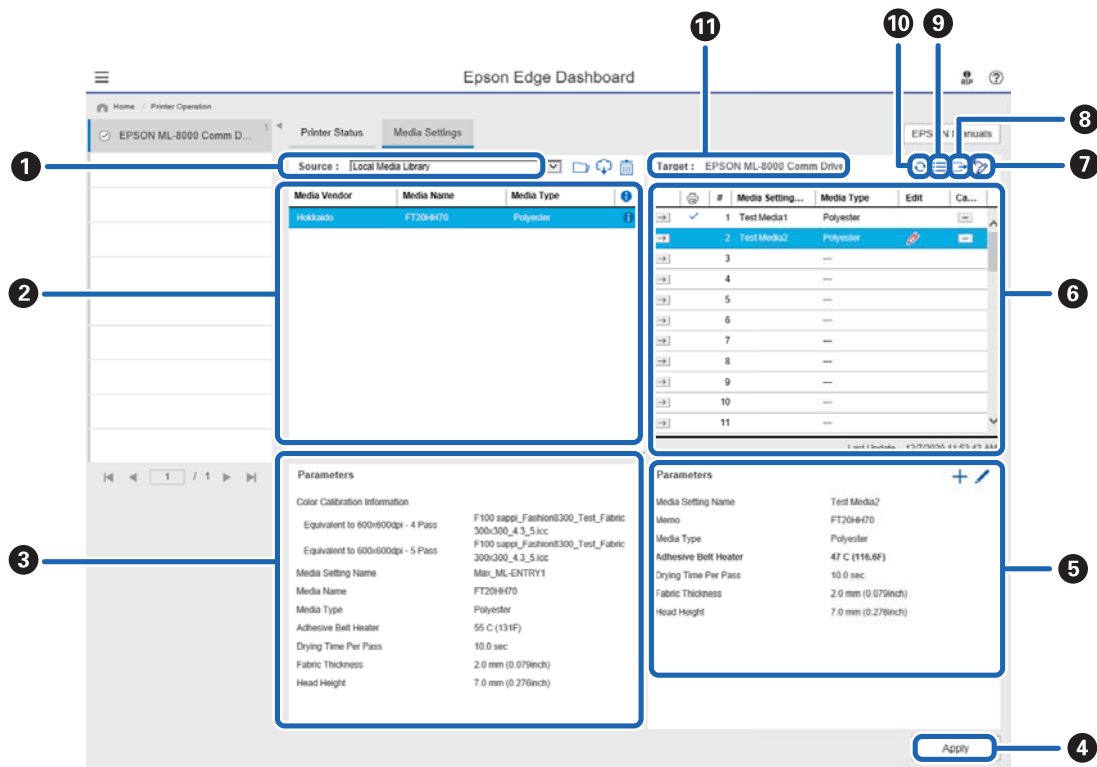
- 1 Select Printer Operation from the menu. Alternatively, on the Home screen, click the area surrounding the text describing the status of the relevant printer.

The Printer Operation screen is displayed.

- 2 Click the Fabric Settings tab.

The Fabric Settings screen of Printer Operation is displayed.

Screen Layout



- 1 **Source**
Select the source used to add or change the fabric settings for the printer selected in the list of registered printers.

- 2 **Source fabric settings list**
Displays a list of the fabric settings loaded in 1.

- 3 **Parameters list (Source)**
Displays the settings for the fabric settings clicked in 2.

- 4 **Apply button**

Before Use


Click to update fabric settings for the target printer using the content of the current **6** list.


5 Parameters list (Target)

Displays the settings for the fabric settings clicked in **6**.

6 Target fabric settings list

Displays the fabric settings registered to the printer selected in the list of registered printers. Calibration field indicates the status of color calibration of fabric settings with the following icons.

 : includes color calibration information.

 : does not include color calibration information.

No icon : Fabric settings you registered for the printer.

Click the icon to display the screen where you can see the list of color calibration history. You can click EMX File Export within the screen to save an EMX file that contains information required for color calibration.

7 Clear button

Click to return any changes you made to fabric settings selected from the list in **6** to their previous state. However, you cannot reset the changed items after you click the Apply button.

8 Write to file button*1

Click to collect the fabric settings displayed in the current list and save them to a single file on your computer. For details, see the help for Epson Edge Dashboard.

9 Check registered fabric settings button

Click to save the list of information for all the fabric settings currently registered to the printer selected in the list of registered printers. For details, see the help for Epson Edge Dashboard.

10 Target fabric settings list update button

Click to reflect the settings for the fabric currently registered to the printer in the target fabric settings list.

11 Target

Displays the name of the printer selected in the list of registered printers.

*1 This button is not displayed when accessing and using this software from another computer on the network. For details, see the help for Epson Edge Dashboard.

Before Use

Copy operation flow

To copy fabric settings to the printer, you can copy the fabric settings for another printer instead of copying the fabric settings contained in a downloaded EMX file.

You can copy the fabric settings for another printer to share the same settings between multiple printers. For how to copy the fabric settings of other printers, see the help for Epson Edge Dashboard.

The following explains the workflow for copying settings from a downloaded EMX file.

Download an EMX file

 ["Downloading an EMX file" on page 41](#)



Copy the fabric settings to the printer

 ["Copy the fabric settings to the printer" on page 43](#)



Do print adjustments on the printer

To optimize the fabric setting values for your printer's status, make sure to do print adjustments after copying the file.

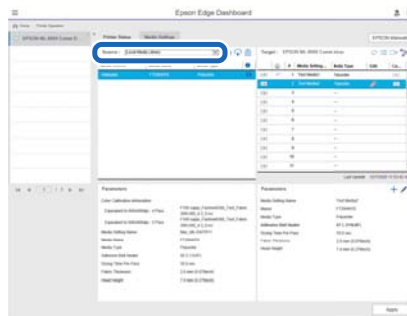
 ["Print Adjustments" on page 109](#)

Copying the fabric settings in the EMX file to the printer

Downloading an EMX file

You can download only the EMX files corresponding to the printers you registered on the Epson Edge Dashboard. In addition, regardless of the printers selected in the list of registered printers, you can download all the files corresponding to the registered printers.

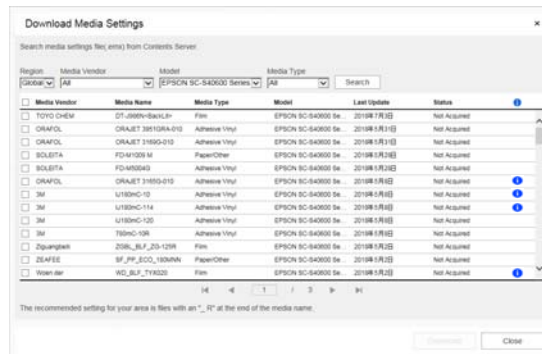
- 1 Click in the source, and select Local Media Library.



Before Use

2 Click .

A list of EMX files for each commercially available fabric is displayed in the following download screen.



At first, the EMX file corresponding to the printer selected in the list of registered printers is displayed. If you want to view the file corresponding to a different printer, select the desired printer in Model and click Search.



You can narrow the content of the list to only the necessary EMX files by selecting region, fabric vendor, fabric type, and then clicking Search.

3 Select the EMX files to download.

Select EMX files by checking the checkbox on the left of each file. Check the checkbox on the left of **Fabric Vendor** to select all EMX files displayed on the current page.

You cannot download EMX files with Acquisition Complete as their Status, for they have already been downloaded.

EMX files with Update Available as their Status have been updated since they were acquired. Downloading such EMX files will overwrite the Acquisition Complete files.

 is displayed for EMX files that contain information. Click  to display the contents.



Important:

If fabric setting values already registered to the printer are overwritten by an EMX file for the same fabric displayed with Update Available, the print adjustment setting values are initialized. If fabric settings are overwritten, click the Apply button to register the fabric settings to the printer, and then do print adjustments.

4 Click Download.

The EMX files are saved.

EMX files are downloaded one at a time.

When selecting multiple EMX files, wait until all files are of Acquisition Complete status.

Click Cancel to cancel EMX file download. EMX files that are of Acquisition Complete status at the time of cancellation are stored.

Note:

You cannot change where EMX files are stored. To copy downloaded EMX files to other computers, go to the Preferences screen and select Copy Folder Path to copy the path. For details, see the help for Epson Edge Dashboard.

Before Use

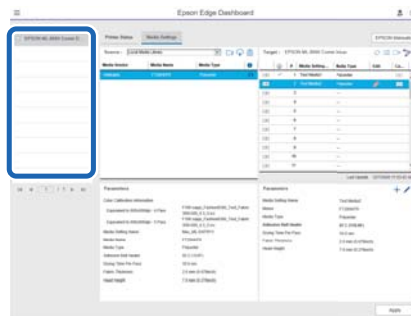
- 5 Click Close to close the Download screen.

Fabric settings in the EMX files are loaded and displayed to the source fabric settings list on the Fabric Settings screen.

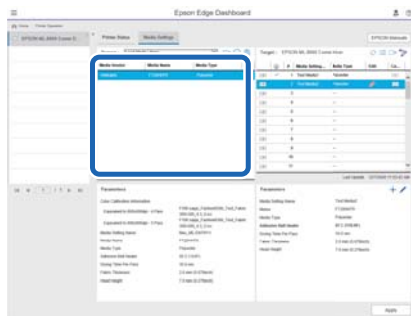
Only the fabric settings available to the model selected on the list of registered printers are displayed in the source fabric settings list. To view the loaded fabric settings, select the printer you selected in Step 2 on the list of registered printers.

Copy the fabric settings to the printer

- 1 Select the printer on the list of registered printers.



- 2 From the source fabric settings list, select the fabric settings that you want to add to or change on the printer.



If printers of multiple different models are registered to this software, only the fabric settings available to the printer you selected in Step 1 will be displayed. Fabric names are displayed in English. You can confirm the display name in the download screen by putting the mouse pointer over the English name.


You cannot select multiple sources simultaneously. Copy them one at a time.

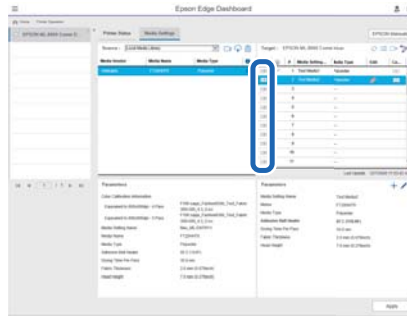
- 3 Check the target fabric settings list to see which fabric settings are registered to the printer.

You can see the name of the settings registered to the printer in **Fabric Setting Name** field.




- ✓ indicates the currently specified fabric settings for printing in the printer.

Before Use

- 4 Click the  of the target fabric setting number.





The fabric settings you selected in the source fabric settings list are copied.

 is displayed for fabric settings that were copied from the source fabric settings list or whose settings were changed on the Edit screen. If  is displayed,  is grayed out and cannot be updated until you click the Apply button.

You can check the Fabric Name on the download screen by referring to Fabric Name displayed in Memo of the parameters list (target).


- 5 Click the Apply button.

Fabric settings are copied to the printer.

Before clicking the Apply button, check the list of registered printers and make sure that  is displayed as the status icon. If the icon is anything except for , you cannot update the printer's fabric settings.

If the printer is connected via USB, make sure it is not printing before you click Apply.

Loading EMX files stored to another computer into the source fabric settings list



By clicking , you can load EMX files to your source fabric settings list, no matter where they have been copied. When you are using Epson Edge Dashboard on a computer that cannot download EMX files, you can load EMX files that were downloaded on a different computer.

Click the icon to display the file selection screen, select the EMX files of your choice, and load.

A maximum of 300 EMX files can be loaded at a time. The fabric settings of the files that are loaded are added to the source fabric settings list.

Once the files are loaded, going forward, you can simply select Local Media Library to see them listed.



Editing the source fabric settings list

Click  to delete the EMX files that have been downloaded. In the source fabric settings list, select the EMX files that you no longer use or that you downloaded by accident, and then click .

Editing Fabric Settings

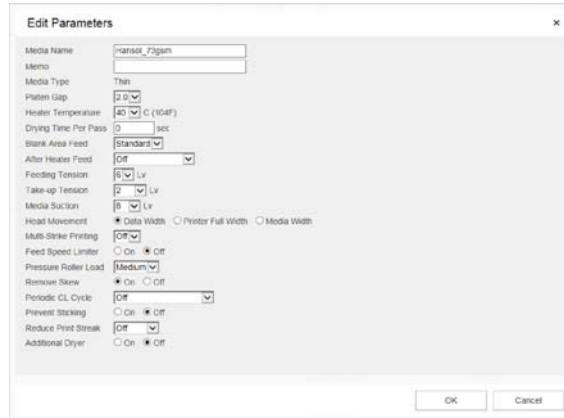
You can make changes to fabric settings selected on the target fabric settings list. You can also add new settings. The steps to do this are described below.

Before Use

- 1 On the target fabric settings list, select the fabric settings you want to edit. Click  (to change settings) or  (to create a new setting).

The Edit screen for Fabric Settings is displayed.

- 2 Change the settings.



The setting items vary according to the model being used.

You can enter a note in Memo to describe the content of the fabric settings. For fabric settings copied from EMX files, the fabric name is entered in the field.

You can only change the fabric type when creating a new fabric setting. When you newly create a fabric setting, it is populated with reference values for the fabric type you selected. These values are determined based on the standard specifications for this fabric type. Do edits as needed for the optimum setting values of your fabric.

- 3 When you have finished editing, click OK.

The changes are applied, and the previous screen is displayed.

To discard the changes and return to the previous page, click the Cancel button.

Exiting Procedure

Close the Web browser.

How to Use Epson Edge Print

About the Printer

Information on the ink types as well as the ink set information (combinations of ink colors) that you want to use is pre-registered in the printer. When changing the ink types or changing the combinations of ink sets, register it as a separate printer.

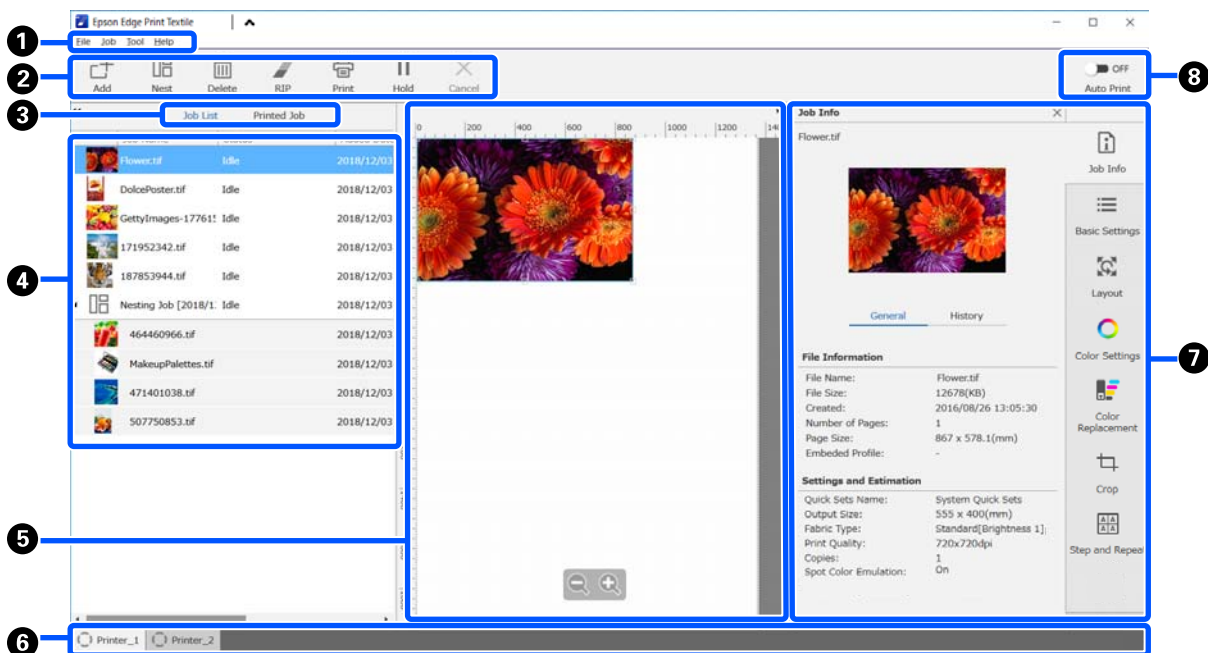
Before Use

About Printing

- ❑ When you register the printer, you can select to print using the connected printer or output a Rob file to print using an Epson digital fabric printer when you execute **Print** in this software.
- ❑ Any differences in operation between printing using the printer and outputting a Rob file are described separately in the text.
- ❑ This manual also uses the word "print" to refer to creating a Rob file.

Configuration of Main Screen

The main screen appears when you start Epson Edge Print.
The configuration and functions of the main screen are shown below.



- 1 Menu bar**
You can do settings and operations in the various menus.



By clicking **^** or **v** in the title line, you can show or hide the menu bar.



- 2 Job toolbar**


Before Use


You can perform the following operations for jobs that you select in the Job List/Printed Job lists **4**.


: Select and add print data to the Job List.


 / : Creates a single nest job from multiple selected jobs.




When you select a nest job,  changes to  and you can do UnNest.



: Deletes the selected job from the list.

: Performs RIP processing only for the selected job.

: Prints the selected job while performing RIP processing. When you select a job for which RIP is already complete, only printing is done.

: Cancels the RIP processing or printing in progress.

 / : Puts the selected job on hold. Held jobs are not printed when you set the Auto Print switching button **8** to  ON to perform auto printing.

When you select a job being held,  changes to  and you can cancel the hold. If you cancel a hold during automatic printing, the job becomes idle and is printed at the end of the queue.

3 List switching button

Switch the Job List/Printed Job Lists.

The name of the currently selected list is shown in a frame.



4 Job List/Printed Job Lists

In the Job List, a thumbnail, name of the source data, and the status are shown for jobs that are printing or waiting to be printed. Jobs that are finished printing are automatically moved to the Printed Job list.

You can do the following operations in both lists.


You can change the content by opening the right click menu on the list title.


You can perform the same operations as in the Job toolbar **2** by opening the right-click menu on the name of a job.


You can minimize or expand an area by clicking  or , which are to the top left of the list titles.

5 Preview area

Before Use



You can check a preview of a job that you select in the Job List .



Use this preview area to check your settings when making Layout and Crop settings in the Job Setting menu () , and when placing nest jobs.

The white area shows the fabric. The fabric width changes according to the  (Basic Settings) - Fabric Size setting in the Job Setting menu.

You can do the layout as you check the printing position with the scale. You can change the units (mm/inch) of the scale in Preferences in the Tool menu. For details, see the help for Epson Edge Print.

You can also drag the preview image to change the printing position.


By clicking  or  at the bottom of the preview area, you can reduce or enlarge the preview area display. To reduce or enlarge the printout, do the Layout settings in the Job Settings menu. For details, see the help for Epson Edge Print.

By clicking  or  on the left top of the area, you can minimize or expand the area.


6 Switch printer tab


Displays the statuses and names of printers that are registered to Epson Edge Print.


Click a tab to change the printer to operate. The white tab is the printer that is currently being operated. The meanings of the status icons is as follows.


: Ready to print (idling).



: Printing.

: A warning has occurred.


: An error has occurred.

: An operation other than printing, such as head cleaning or a panel operation, is in progress.


: The printer is off or disconnected.

By clicking the  on the bottom right of the screen, you can check the detailed status of the printer that is selected. Depending on the model you are using,  may be disabled.

7 Job Setting menu & Setting area

Perform settings, such as printing and layout, for idle jobs that are selected in the Job List .

The icon on the right is the Job Setting menu. The content of the setting area changes depending on the items that are selected. For details, see the help for Epson Edge Print.



Clicking the  in the top right of the setting area closes the setting area so the preview area is enlarged by that amount. To open the settings area, click on one of the Job Setting menus.

When the setting area is closed, you can minimize/maximize the menu area by dragging the menu's left edge to the left or right.



8 Auto Print switching button

Before Use

Each time this button is clicked, it turns on or off.

By setting it to  ON , the print jobs start printing in order just by adding print data to the Job List  . When there are idle jobs in the Job List, idle jobs are also printed in order.

By setting it to  OFF , the jobs are not printed until after the print data is added to the Job List, selected, and then printed.

When multiple jobs are put together and nesting or RIP is done before printing, set  OFF to do the nesting and RIP work, and then change it to  ON .

Printing Procedure

The following must be registered when printing with Epson Edge Print.

Print information

Register information such as the fabric ICC profile, number of passes, and resolution in this software.

Preparing the print data

Prepare print data in a data format that is supported by Epson Edge Print.


For details on supported data formats, see the help for Epson Edge Print.

If not using files output from ColorBlend, we recommend PDFs for the following reasons.

- There are no broken links to images or disrupted layouts.
- Text does not need to be outlined.
- The appearance does not change, even for different versions of image processing software.

Printing Procedure

This section describes the basic procedure for printing.

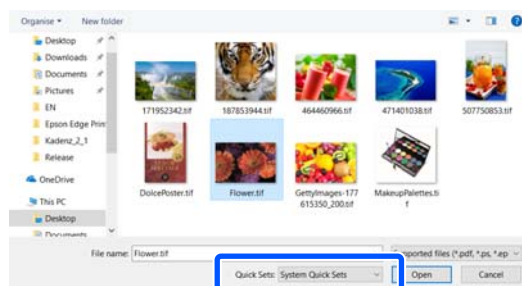
- 1** Click  (Add) in the Job toolbar and add the print data to the Job List.
Or, drag and drop the print data onto the Job List.

The name of the data and a thumbnail for the print data that was added appear in the Job List.

Before Use

Note:


When you click  (Add) and select the print data, you can also select Quick Sets at the same time.



Quick Sets are a saved batch of print job settings. Jobs are generated according to these settings. For details, see the help for Epson Edge Print.

- 2 Select a job to print from the Job List.

An image of the printout appears in the preview area.

- 3 Click  (Basic Settings) in the Job Setting menu.

The setting area changes to Basic Settings, and you can set the fabric size, fabric name, and print quality (e.g. resolution).

For details about basic settings, see the help for Epson Edge Print.

- 4 Click  (Print) in the Job toolbar to start printing.

During printing, Printing appears in the Status column in the Job List.

Jobs that are finished printing are automatically moved to the Printed Job list.

For details on how to use the Printed Job list, see the help for Epson Edge Print.


When there are multiple jobs in the Job List, you can decide on the order to print jobs and flexibly change the order of the print jobs in the Job List. For details, see the help for Epson Edge Print.

From the Job Setting menu, you can perform enlarged/reduced printing as well as print only a part of the image.

For details about the functions, see the help for Epson Edge Print.

Stopping Printing

Use the following procedure to stop printing while a job is printing.

- 1 Select the job to stop printing from the Job List, and click  (Cancel) in the Job toolbar. Or, open the right click menu on the name of the job to stop printing and select **Cancel**.

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

Before Use

How to Use the Rob File Printing Tool

Configuration of Main Screen

The main screen appears when you start the Rob file printing tool.

The configuration and functions of the main screen are shown below. For details, check the manual for the Rob file printing tool.



1 Status

Displays the operating status of the application.

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



① : Name of operation being executed

② : Progress bar

2 Connected printer name

Displays the name of the printer connected to the application.

You can select printers to connect to from the pull-down menu.

3 Control tab

Switches between the **Print** tab and **System** tab for operation.

 ["Print tab" on page 52](#)

4 Notification list

Before Use

Displays notification information from the connected printer.

Click a notification to display more details.

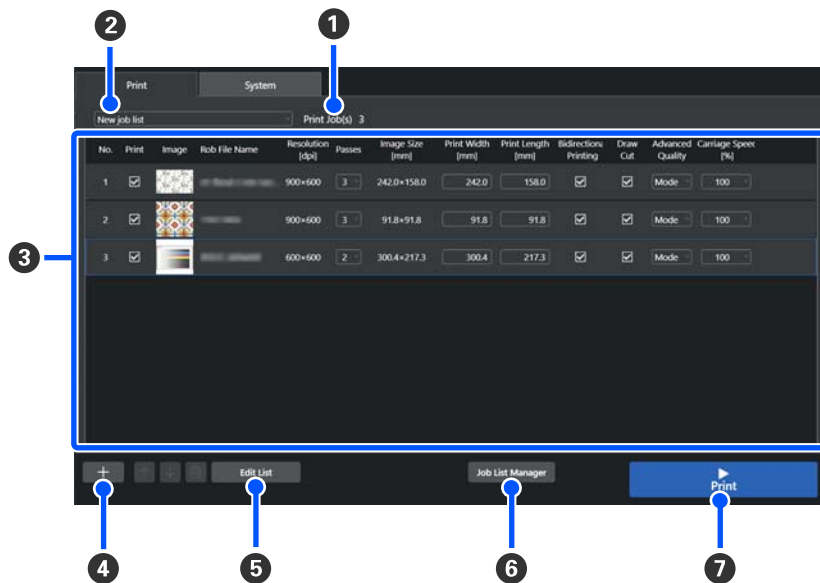
You cannot print if the printer has an error. Read the instructions and take the necessary measures.

5 Ink type

Displays the ink types installed in the printer when a printer is connected.

When the port for the communication driver is set to "FILE:" (for prn file output), the drop-down menu is enabled. Select an ink type.

Print tab



1 Print Job(s)

Displays the number of jobs planned for printing.

2 Selected job list name

Displays the name of the selected job list.

You can select a job list from the pull-down menu.

3 Job list

Displays a list of the jobs (Rob files) that are registered in the job list.

["Job Setting menu" on page 53](#)

4 Add job button

Adds a job (Rob file) to the job list. The Add job screen is displayed.

Added jobs inherit the settings of the last job on the selected job list. Items that are not to be inherited, such as when the resolution is different, use the default values.

5 Edit Job List button

Before Use

This enables the buttons for deleting jobs or changing the order of jobs, letting you edit the job list.

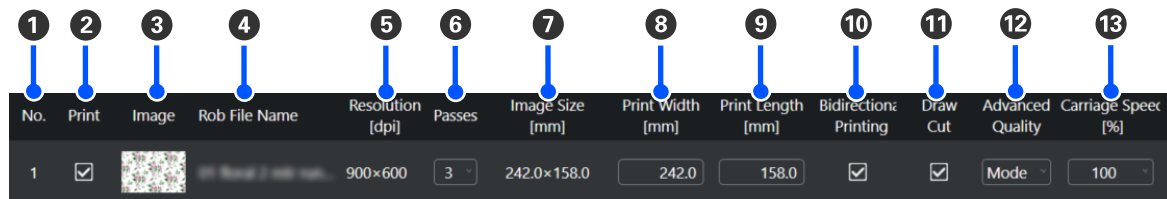
6 Job List Manager button

Creates, edits, and deletes job lists. The Job List Manager is displayed.

7 Print button

Starts printing jobs for which printing is enabled on the job list.

Job Setting menu



1 No.

Displays the job number in the job list. Printed in order following these numbers.

2 Print

Select a job to print. Click the check box to switch between enabled and disabled.

: Printing enabled

: Printing disabled

3 Image

Displays the thumbnail for the Rob file.
Click a thumbnail to display the detailed information for the job.

[🔗 “Job Info” on page 57](#)

4 Rob File Name

Displays the file name for the Rob file.
Click a file name to display the detailed information for the job.

[🔗 “Job Info” on page 57](#)

5 Resolution

Displays the resolution for the Rob file. W x H [Units: dpi]

6 Passes

Before Use

Select the number of passes for printing. The number of passes that can be selected depends on the print resolution.

The number of passes determines how many times the print head moves and prints on the fabric. In general, a larger number of passes improves print quality but reduces productivity. Consider the print quality and productivity when setting the number of passes.

7 Image Size

Displays the image width and image height for the Rob file. [Units: mm]

8 Print Width

Sets the width to be printed. [Units: mm]

Setting: 10.0 to 1850.0

You can set the print width on the printer and on the application. The narrowest print width setting will take priority.

9 Print Length

Sets the length to be printed. [Units: mm]

Setting: 10.0 to 4699000.0

10 Bidirectional Printing

If you unselect this check box, one-directional printing is selected, and printing is performed only when the print head moves in a certain direction. The print quality is improved, but print speed falls below normal. If ruled lines are misaligned or unevenness occurs, selecting one-directional printing may improve the symptoms. Click the check box to switch between enabled and disabled.



: Bidirectional Printing



: One-directional printing

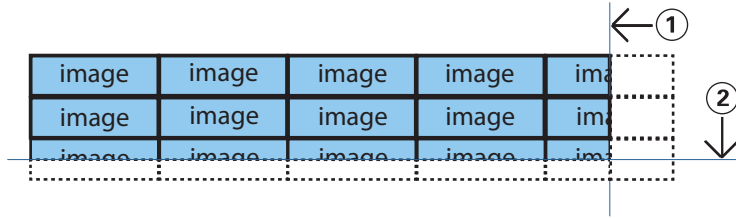
11 Draw Cut

Click the check box to switch between enabled and disabled.

Before Use

: Draw Cut enabled

Prints images up to the specified print width and print length as shown in the following illustration. Parts that extend beyond this area are not printed.



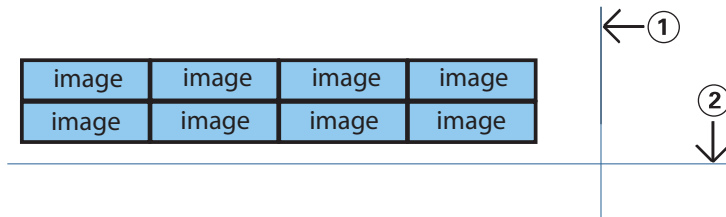
① Print width

② Print length

If you add the next job while Draw Cut is enabled, the print width and print length settings for the previous job are inherited.

: Draw Cut disabled

Printing is performed repeatedly until it fits within the print width and print length.



① Print width

② Print length

Before Use

Specifications for Disabling Draw Cut

- If you add the next job while Draw Cut is disabled, the print width and print length settings for the previous job are not inherited.
- At the time of calculation, the image size is calculated to two decimal places.
- If the print width and print length are the median of the image size, it will be rounded down. If you specify a value that is 2.5 times the image size, it will be rounded down to 2 times the size.
- If you specify a value that is smaller than the image size, it will be rounded up.
- When the image size is rounded up, the image is printed repeatedly until it fits within the maximum print width and print length.

<Example image size: 100.00 mm (3.94 inches) against a maximum print width of 1850 mm (72.83 inches)>

Print width: If you enter 151 mm (5.94 inches), it is rounded up to 200.00 mm (7.87 inches).

Print width: If you enter 150 mm (5.91 inches), it is rounded down to 100.00 mm (3.94 inches).

Print width: If you enter 90 mm (3.54 inches), it is rounded up to 100.00 mm (3.94 inches).

Maximum print width: If you enter 1850 mm (72.83 inches), it is rounded down to 1800 mm (70.87 inches).

When Draw Cut is changed from enabled to disabled, the print width and print length that were specified when it was enabled are reset to the print width and print length of the image size.

12 Advanced Quality

If there are streaks or unevenness in the print results that cannot be resolved even after implementing print adjustments, selecting the modes below may reduce the streaks and unevenness.

 ["Print Adjustments" on page 109](#)

- Mode 1: Default
- Mode 2: When the width of the streak is 5 mm (0.20 inches)
- Mode 3: When the width of the streak is 1 mm (0.04 inches)

13 Carriage Speed

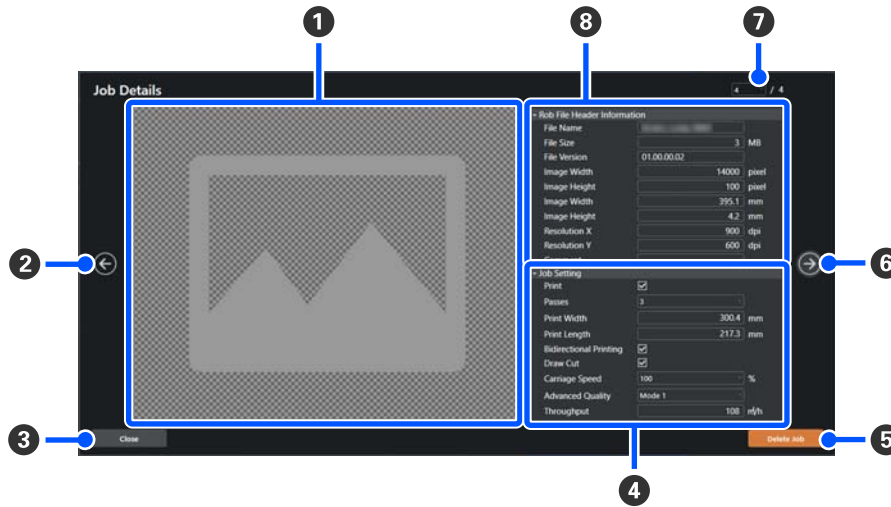
Selects the speed of the print head during printing. For geometric patterns or other cases where impact misalignments may cause streaks to occur, slow down the carriage speed.

This is not available for some ink types.

Before Use

Job Info

This can be viewed by clicking the thumbnail or file name in the Job Settings menu.



1 Image

Displays the thumbnail for the Rob file.

2 Switch job button (Prev)

Displays the Job Details information for the previous job in the job list.

3 Close button

Click to close the Job Details screen.

4 Job Setting menu

[🔗](#) “Job Setting menu” on page 53

Advanced Quality:

If there are streaks or unevenness in the print results that cannot be resolved even after implementing print adjustments, selecting the modes below may reduce the streaks and unevenness.

[🔗](#) “Print Adjustments” on page 109

Mode 1: Default

Mode 2: When the width of the streak is 5 mm (0.20 inches)

Mode 3: When the width of the streak is 1 mm (0.04 inches)

Throughput:

Displays an estimate for the printing throughput (m²/h), as determined by the job settings.

5 Delete Job

Deletes the displayed job.

6 Switch job button (Next)

Displays the Job Details information for the next job in the job list.

7 Select Job

Before Use

Specify a job number to display detailed information about that job.

8 Rob File Header Information

Displays the Rob file header information.

 “Job Setting menu” on page 53

Printing Procedure

Loading Rob files

Load the Rob files in the application. Once loaded, data is preserved even if the application is shut down.

The data formats for files that can be loaded are as follows. Rob files cannot be selected if they have a non-supported version or resolution, or if their header information is corrupted.

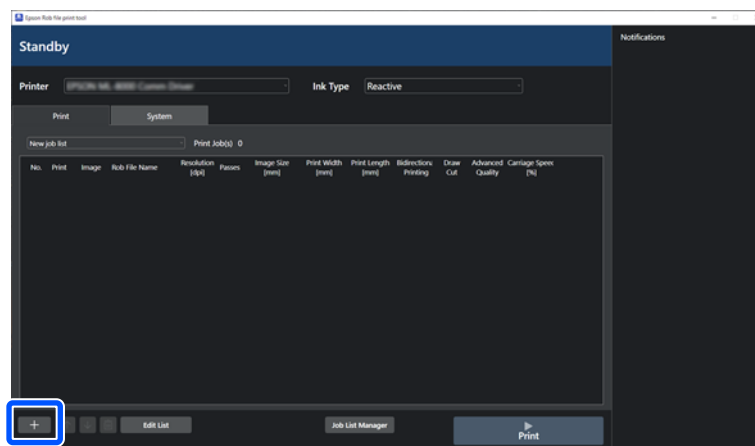
Data format: .rob/.robust/.robx

Resolution [dpi]: 300×600/600×600/900×600/600×1200/1200×600/900×1200/1200×1200

1

Click the + button on the **Print** tab.

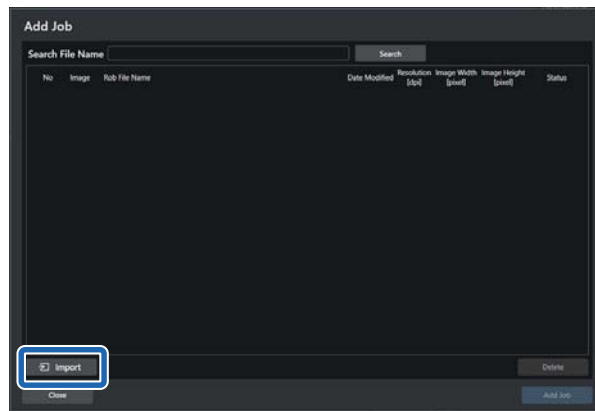
The Add job screen is displayed.



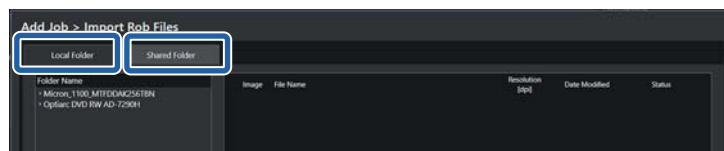
Before Use

- 2 Click the **Import** button.

The Import Rob Files screen is displayed.



- 3 Click the **Local Folder** tab to load a Rob file from the local folder, or click the **Shared Folder** tab to load a Rob file from the shared folder.



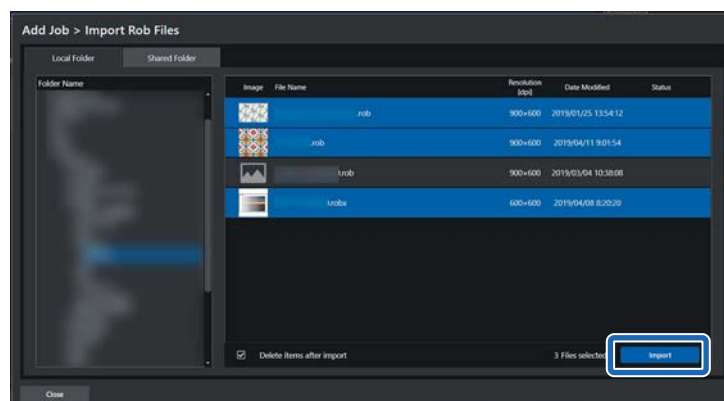
Note:

The "C:\ProgramData\EPSON\Epson Rob file print tool\Data\Shared" folder on the PC is open externally as "[PCname]\Rob Files". You can load Rob files via the network by copying Rob files to this folder.

- 4 Select the print data (Rob file) and then click the **Import** button.

The types of file status are as follows.

- Exists:** A Rob file with the same name has already been imported into the application.
- Used:** A Rob file with the same name has already been imported into the application and added to the job list.



Before Use

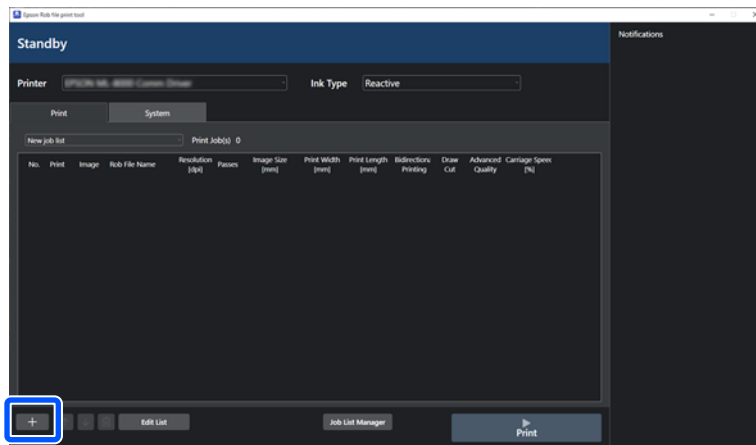
The data loading will begin. When the import is complete, you will be returned to the Add job screen. A list of imported Rob files is displayed on the Add job screen.

Adding a Rob file to the job list

Adds a Rob file to the selected job list.

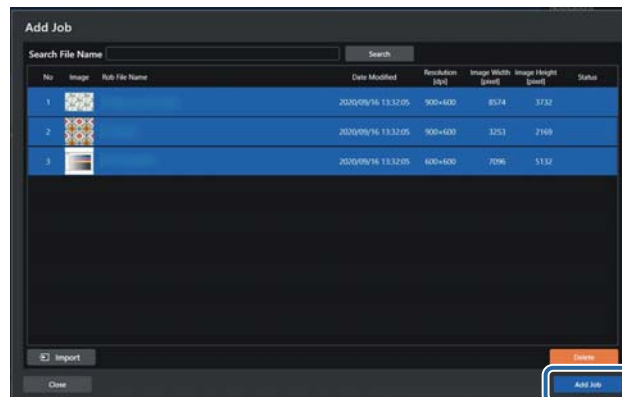
- 1 Click the + button on the **Print** tab.

The Add job screen is displayed.



- 2 Click the Rob files you want to add to the Job List to select them and then click the **Add Job** button.

The selected Rob file is added to the job list.

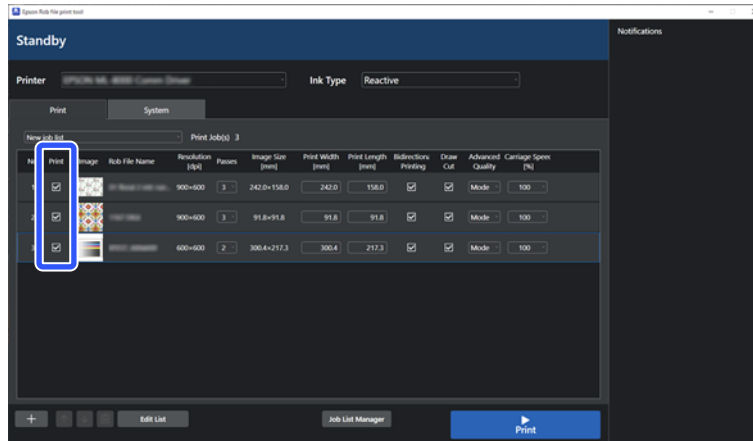


Before Use

Executing printing

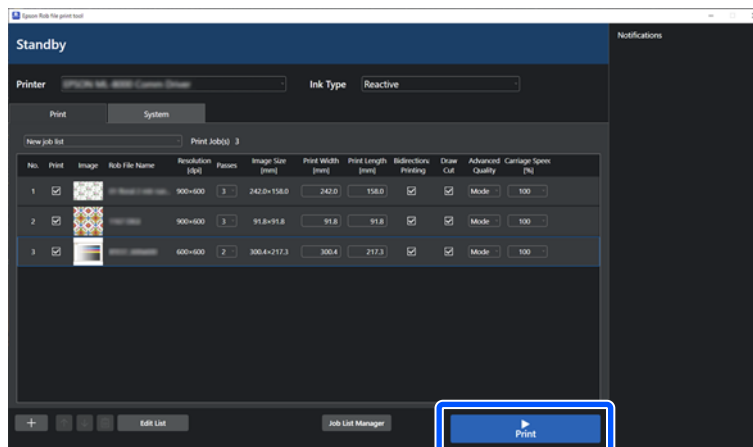
1 Place a check mark for the jobs to be printed.

They will be printed in the order of the job list.



2 Click the **Print** button.

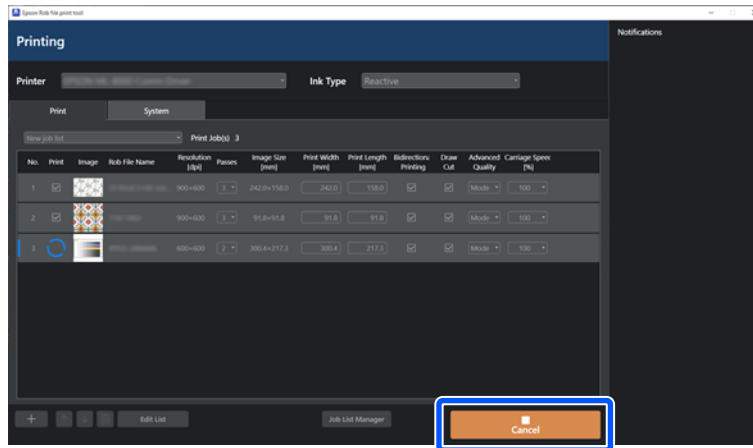
During printing, "Printing" is displayed in the Status column.



Before Use

Stopping Printing

Click the **Cancel** button on the **Print** tab.



How to Use Web Config

This section provides an overview of how to start the software and its functions.

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.
You can check the value set for the printer in **Network Settings - Network Status** on the control panel.
[🔗 “General Settings Menu” on page 415](#)
- 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.
Example: `https://192.168.192.168`
- 4 Click **Log in** at the top-right of the screen, and then enter the administrator User Name and Administrator Password. Enter the default 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 User Name and 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. [☞ “How to Set/Change the Administrator User Name and Administrator Password” on page 63](#)

[☞ “How to Set/Change the Administrator User Name and Administrator Password” on page 63](#)
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 the new settings. 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 63](#)

How to Set/Change the Administrator User Name and 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 these settings 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 your administrator User Name or Administrator Password, you will need to reset your Web Config and control panel settings.

[☞ “If you have forgotten your administrator password” on page 446](#)

[☞ “If you have forgotten your administrator User Name” on page 446](#)

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**.

2

Select the items to be exported.

3

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

Before Use

- 4 Press **Export**, 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 **Proceed**.
- 5 Select the items you want to import from the selected file, and then press **Proceed**.
- 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

Basic Operations

This chapter explains the workflow for optimal printing as well as how to splice the fabric.

Flow of Printing

Workflow before Beginning Work	1. "Checking the Area Around Operating Parts" on page 66
	2. "Checking the Exhaust Equipment" on page 68
	3. "Turning On the Power" on page 68
	4. "Checking the Air Pressure" on page 70
	5. "Checking the Sensors" on page 71
	6. "Checking the Operation of the Emergency Stop Equipment" on page 72
	7. "Checking the Belt Cleaning Tank Water Level" on page 74
	8. "Checking the Air Supply Regulator Water Level" on page 73
	9. "Inspecting the Cleaning Pad" on page 76



Print Workflow	1. "Checking the Status of the Fabric" on page 77
	2. "Loading the Fabric" on page 78
	3. "Setting the Foreign Material Detection Sensor" on page 98
	4. "Fabric Information Settings" on page 100
	5. "Setting the Print Start Position" on page 101
	6. "Executing Printing" on page 103



Workflow before Completing Work	1. "Daily Cleaning" on page 108
	2. "Turning Off the Power" on page 108

Workflow before Beginning Work

Checking the Area Around Operating Parts



Inspect the area around operating parts before turning on the power.

Inspection items


Check if there are any tools, hardware, or other items in the area.

- Remove any tools and foreign objects.
If you turn on the power when there are tools, hardware, and so on 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 dirt or dust.

- If the operating parts are dirty, wipe them clean using a wipe cloth dampened with water.
 [“Cleaning the Area Around Operating Parts” on page 181](#)
- Clean the cleaning brushes and scraper if they are dirty.
 [“Cleaning the Belt Cleaning Brushes and the Area Around Them” on page 213](#)


Is the tape peeling off?

- Is the tape on the tension roller peeling off?
If the tape on the tension roller is peeling or torn, cut off the area and re-attach it so that it does not stick up.
 [“Inspecting and Applying Tape to the Tension Roller” on page 231](#)

Are there any signs of ink pooling or leaks around the printer?

- If there is an ink leak inside the machine, contact your dealer or Epson Support.
- If there is an ink leak around the ink supply rack, check that the ink cartridges are installed correctly and that the ink supply tubes 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.
 [“Disposing of Waste Ink” on page 241](#)

Are there any water leaks around the printer?

- Tighten the joints for the water pipes inside the belt cleaning unit.
 [“Checking for Water Leaks in the Pipe Joints” on page 183](#)

Inspection locations

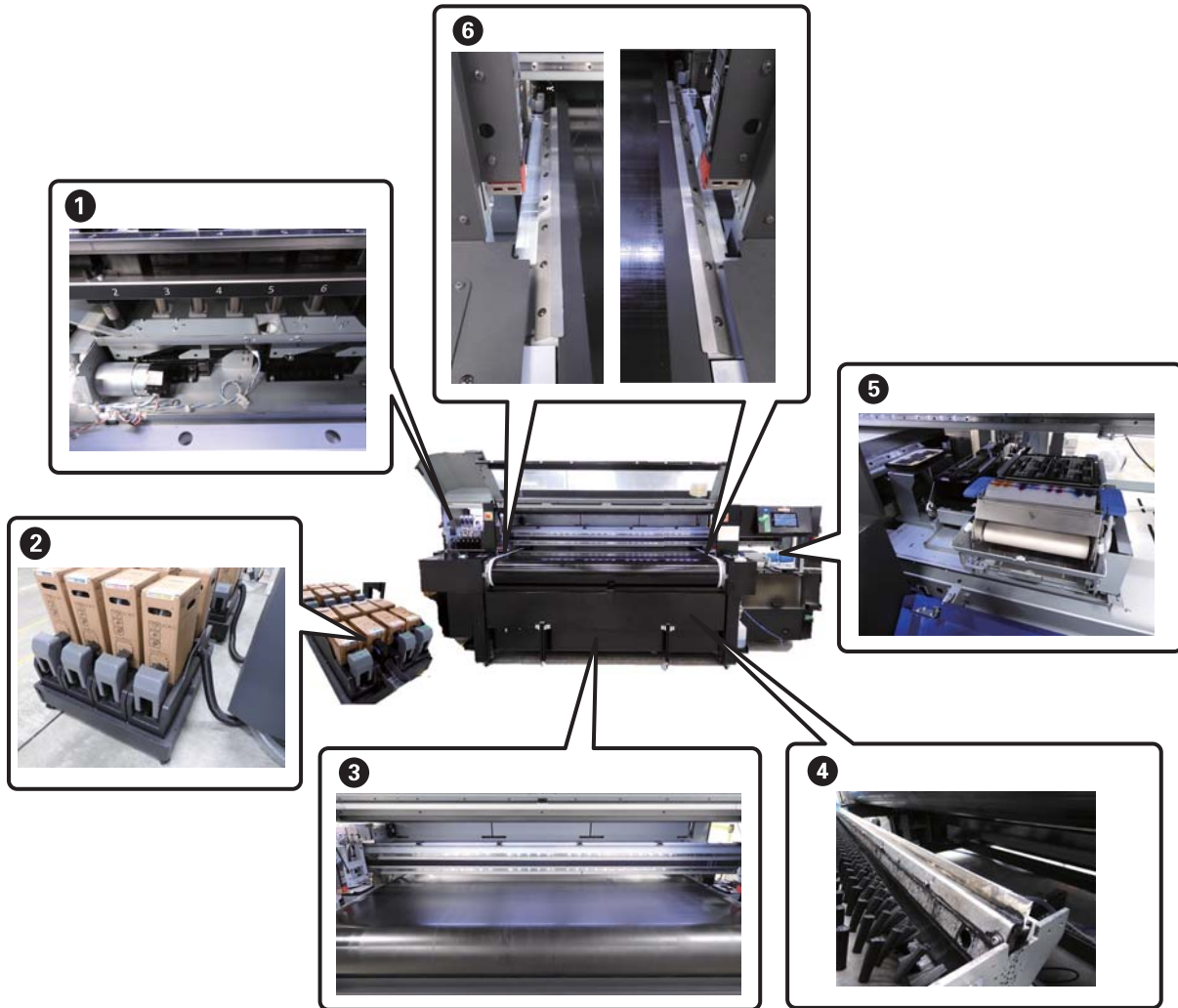
Perform a visual check.

- Belt / Guide beside the belt
- Inside the belt cleaning unit
- Ink supply unit bottom and surroundings, ink supply tube surroundings

Basic Operations

- Carriage surroundings, capping station surroundings
- Waste ink bottle surroundings
- Wiper roll, suction cap, flushing pad surroundings
- Tension roller

Front



- ① Are there any signs of ink pooling or leaks around the printer?
- ② Are there any signs of ink pooling or leaks around the printer?
Are the ink supply tubes or cables damaged?
- ③ Check for any dirt or dust.
Check if there are any tools, hardware, or other items in the area.
- ④ Check for any dirt or dust.
Check for any evidence of water leaking.
- ⑤ Are there any signs of ink pooling or leaks around the printer?
- ⑥ Check for any dirt or dust.

Basic Operations

Rear



- ① Check for any dirt or dust.
Is the tape peeling off?
- ② Check for any dirt or dust.
Check if there are any tools, hardware, or other items in the area.

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

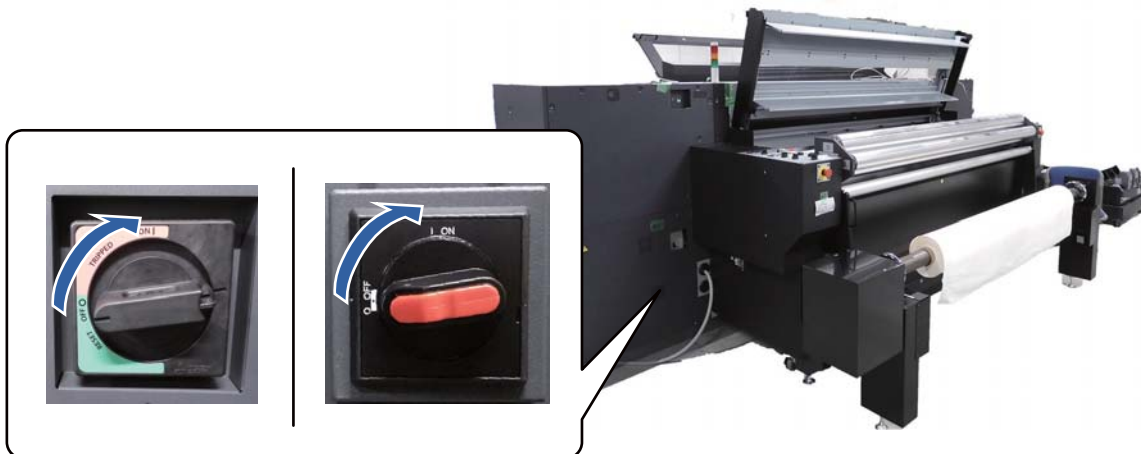
Turn on the printer.

Basic Operations

- 1 Make sure the rear cover is closed and the rear cover lock lever is in the Lock (right) position.



- 2 Turn on the breaker (Main Power) on the back of the machine.



- 3 Press the power button on the control panel on the machine front.

The signal lamp turns green, a return to origin is executed, and the screen for operating the machine is displayed.

Caution:

Do not open the rear cover while return to origin is being executed.

The printer stops when the rear cover lock lever is released. Close the rear cover and move the lock lever to the Lock (right) position to restart the printer

If the print head is on the suction cap when the printer is restarted, they may collide causing a malfunction to occur.

Make sure the print head is not on the suction cap before moving the lock lever to the Lock (right) position. If the print head is on the suction cap, see the following to retract the print head.

☞ "Manually Moving the Print Head" on page 434

Basic Operations

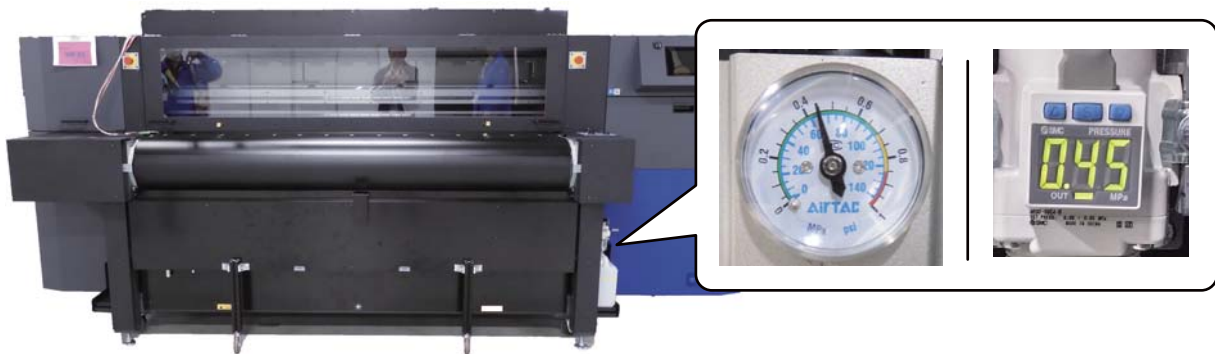


Checking the Air Pressure

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. An air pressure that is higher than the specified air pressure could cause the machine to malfunction.

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 adjustments.

☞ [“Checking the Air Pressure” on page 184](#)

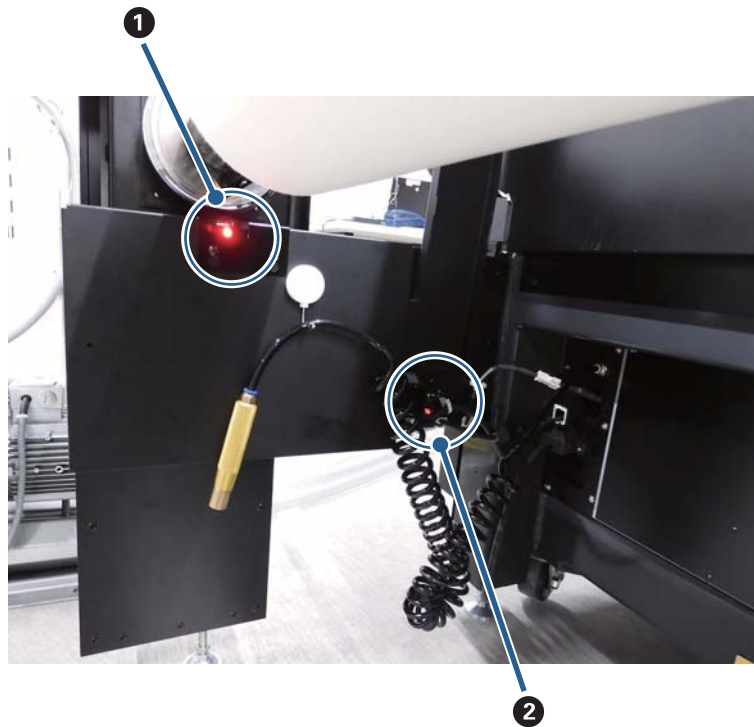
Note:

If the meter is in digital display and the value is flashing, the machine is in maintenance mode. Press the blue button at the top center of the meter once. Maintenance mode closes.

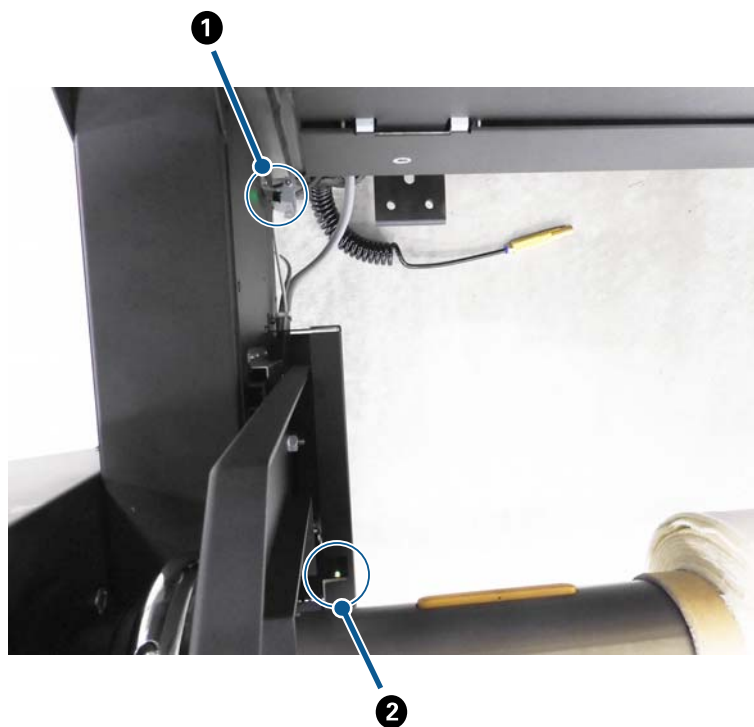
Basic Operations

Checking the Sensors

Confirm that the roll diameter measurement sensor and slack detection sensor on the rear of the machine are lit up red, and that the lamp on top of the sensor is lit up green. If the lamp is lit up in orange, an obstruction has been detected. Remove any obstructions from the sensor's optical axis.



- ① Roll diameter measurement sensor
- ② Slack detection sensor



Basic Operations

- 1 Green light for slack detection sensor
- 2 Green light for roll diameter measurement sensor

If the sensors are dirty, clean the sensors and the reflector plates opposite the sensors using wipe cloths or the like.

 [“Cleaning the Sensors” on page 187](#)

If the sensors do not respond well even after cleaning the sensors and the reflector plates, or if the lamp on top of the sensor is lit up in orange after removing an obstruction, reset each of the sensors.

 [“Slack detection sensor and roll diameter measurement sensor” on page 126](#)

Checking the Operation of the Emergency Stop Equipment

Check the operation of any one of the emergency stop buttons on the machine.

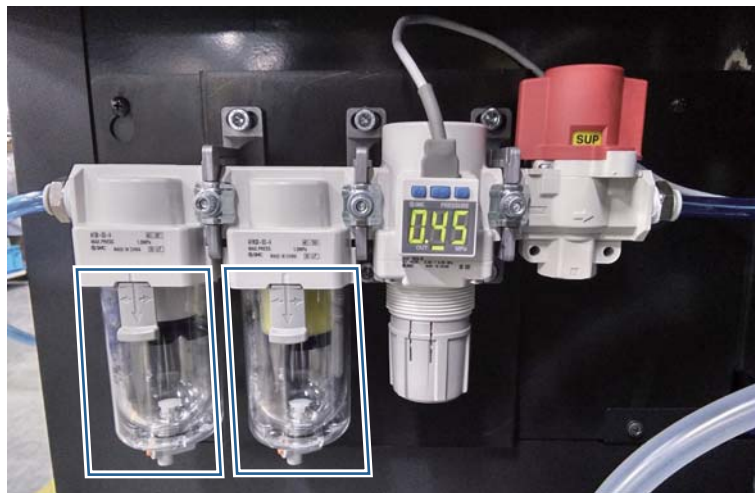
 [“Emergency Stop Button” on page 21](#)

- 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 and restart the machine.

Basic Operations

Checking the Air Supply Regulator Water Level

Check the water level in the air supply regulator.



If water has accumulated, turn the knob at the bottom of the regulator to the left, or press the orange button to drain the water.

[☞ "Checking the Air Supply Regulator Water Level" on page 188](#)

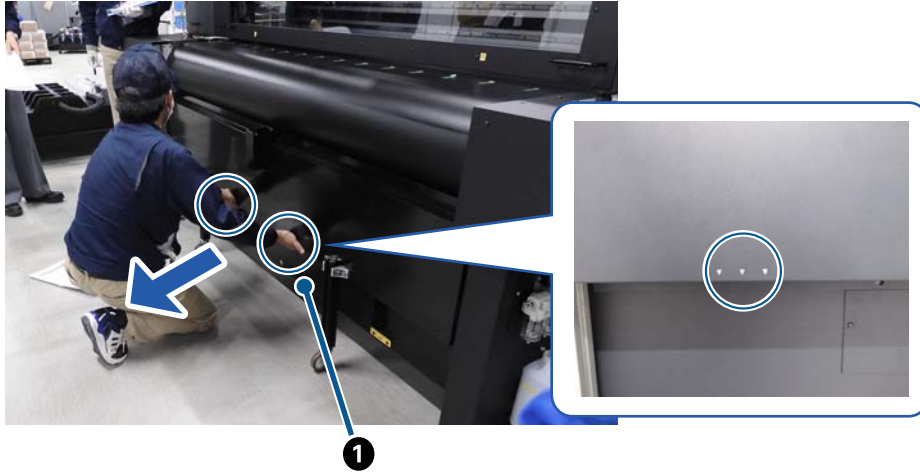
Basic Operations

Checking the Belt Cleaning Tank Water Level

Checking procedure

- 1 Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

Hold the handles on the front of the belt cleaning unit to pull it out.

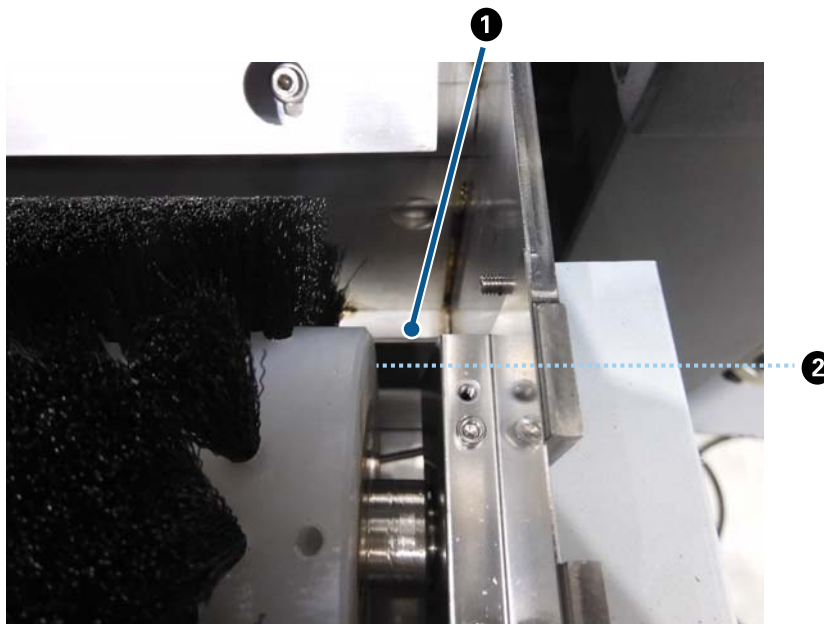


- 1 Handles

- 2 Check that the water in the belt cleaning tank is more than half full.

Supply more water if it is less than half full.

If the water is less than half full, the brush will rotate without water which may cause the glue applied to the belt to peel off.



Basic Operations

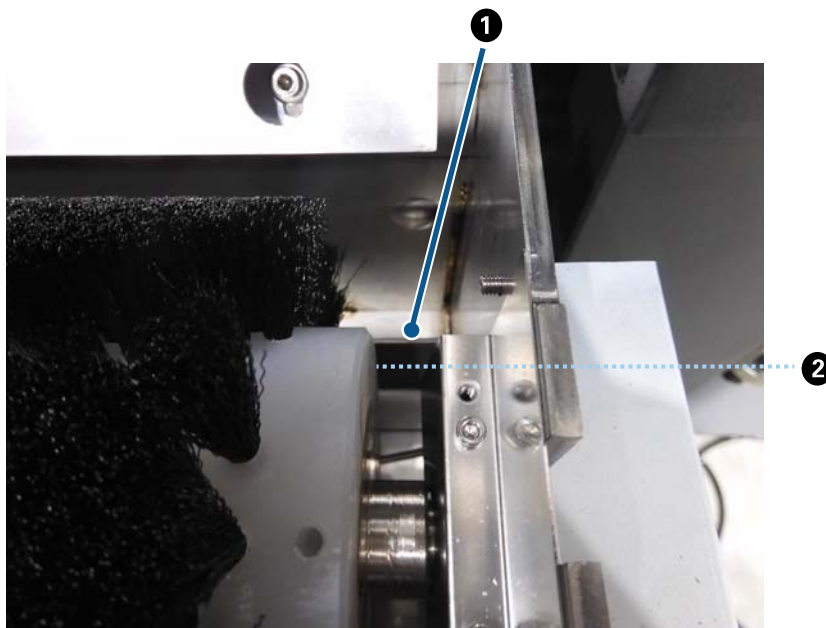
- ① Water storage maximum limit
- ② Estimated amount of water

Procedure for adding water to the cleaning tank

1 From the Maintenance screen on the control panel, touch **Maintenance - Cleaning the Cleaning Tank**, in that order.

2 Touch **Start**.

Supply of water to the cleaning tank begins. Supply water to the cleaning tank until it is more than half full.



- ① Water storage maximum limit
- ② Estimated amount of water

Basic Operations

Inspecting the Cleaning Pad

There are two cleaning pads inside the right-side maintenance cover.



Inspection Points

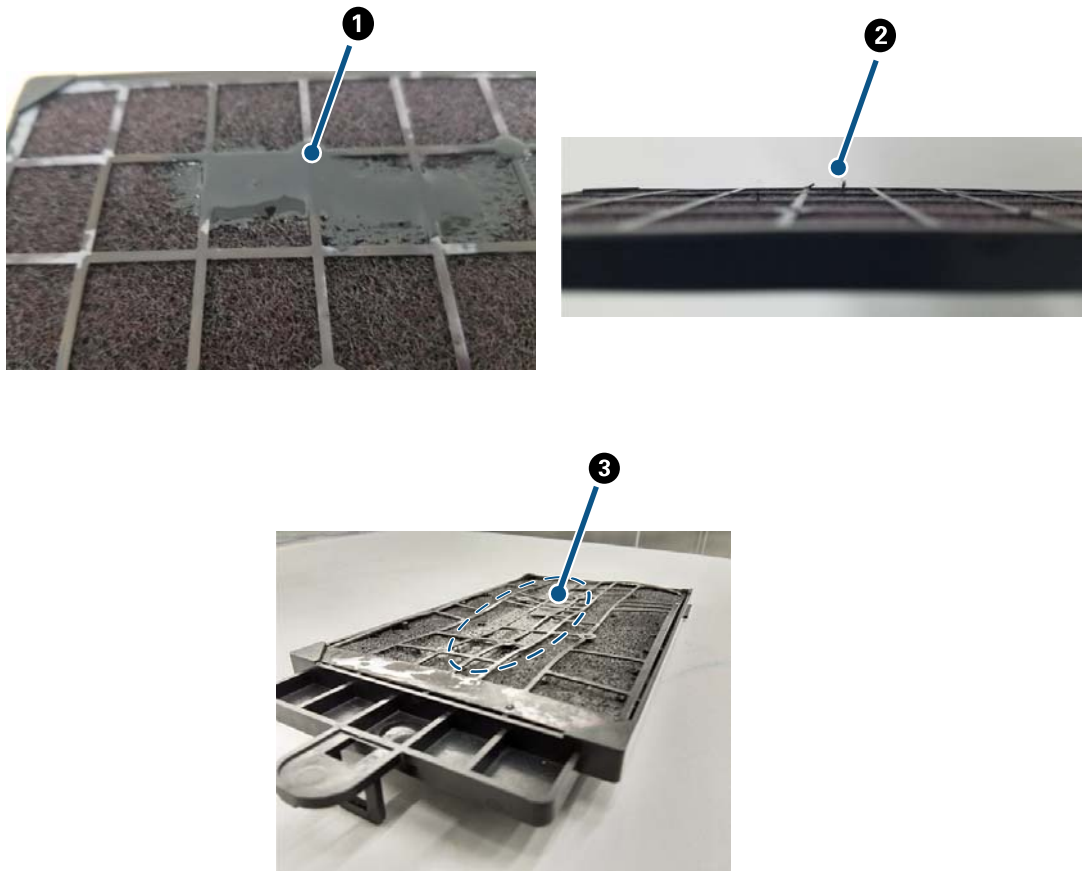
Check the cleaning pad by viewing it horizontally from the side. If ink, dust, lint, and so on has accumulated on the top surface of the cleaning pad, it needs to be cleaned.

[🔗 “Inspecting/Cleaning the Cleaning Pad” on page 190](#)

Basic Operations

If you cannot remove the built-up deposits after cleaning several times or if the cleaning pad is deformed, the cleaning pad needs to be replaced.

🔗 [“Replacing the Cleaning Pad” on page 250](#)



- ① Ink deposits
- ② Dust and lint
- ③ Deformed cleaning pad

Print Workflow

Checking the Status of the Fabric

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

- Fabric edge: There are no folds or protrusions and the fabric is not lifted up or frayed.
If the fabric is frayed, perform overcasting.
- Seams: There are no protrusions and the fabric is not frayed.






Important:

The fabric could rise up during printing and contact the print heads and damage them.

Basic Operations


Loading the Fabric

The fabric should be loaded by at least 2 people.

 WARNING	
 	<p>When attaching or removing fabric, be sure to wear safety shoes and make sure that the procedure is performed by two people. When lifting the fabric roll, make sure you bend your knees sufficiently and lift in a natural position.</p> <p>Fabric rolls weigh more than 30 kg (66.1 pounds) and may cause an injury if dropped. Lifting in an unnatural position could result in injury to the worker or cause back pain.</p>


Note:

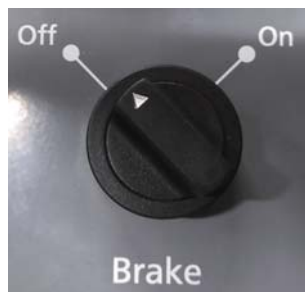
Depending on the type of media used for printing and the nature of the operation, you need to change the settings for each switch and the settings for the printer.

 ["List of Printer Settings by Operation" on page 428](#)

This section indicates the procedure when using the feeding unit.

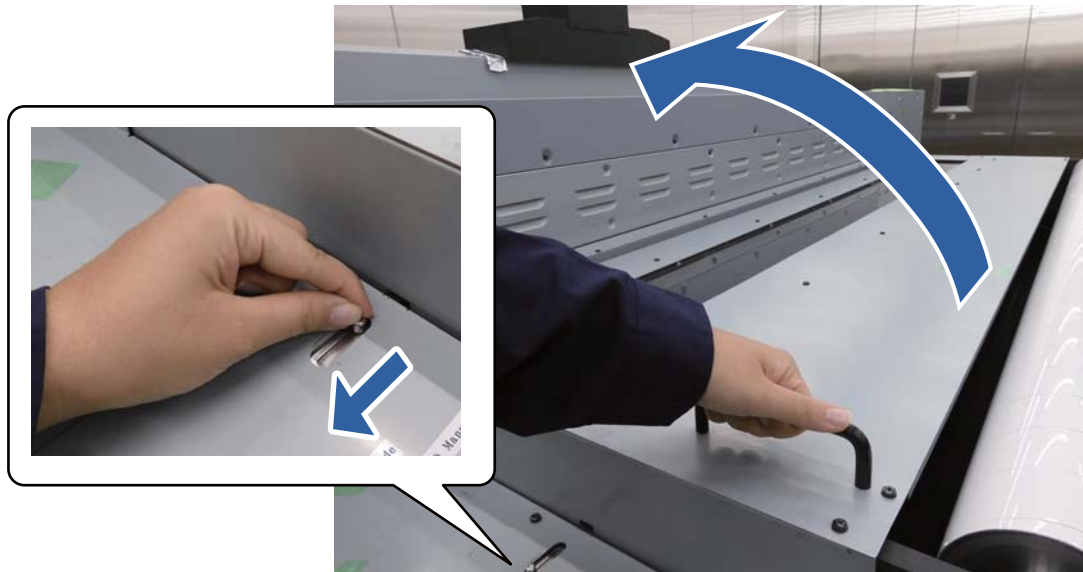
Preparing the printer

- 1 Touch the  (Fabric Feeding Device Settings) button on the control panel, and then check that the Feeding Unit is set to **On**.
- 2 Make sure that the tension switch on the rear panel is set to Off (left).



Basic Operations

- 3 Release the rear panel lock and then open the rear cover.



- 4 Hold the center of the pressure roller and move it to a position near the feeding unit.

! **Important:**
Do not move the pressure roller with too much force or by holding it at the edges. Doing so may cause the printer to malfunction.



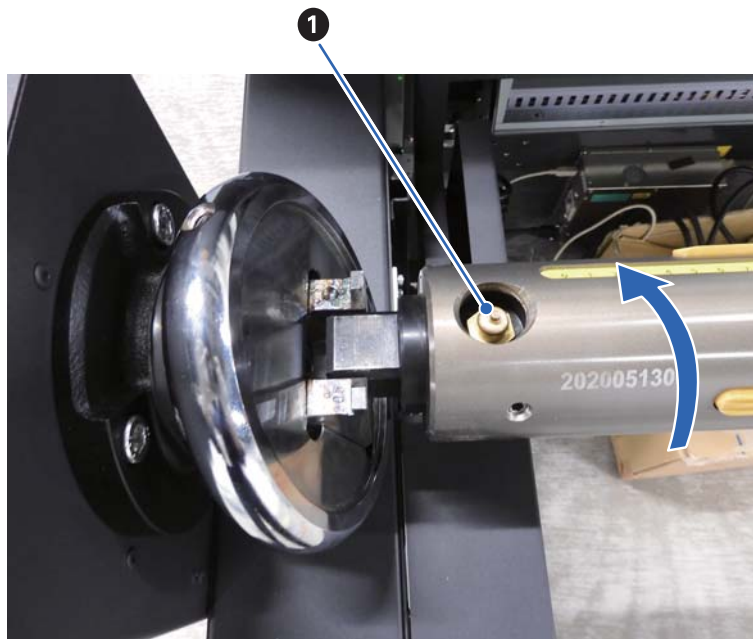
Basic Operations

Removing and attaching the feeding spindle

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



- 2 Rotate the feeding spindle and align it so that the air inlet is in the top position.

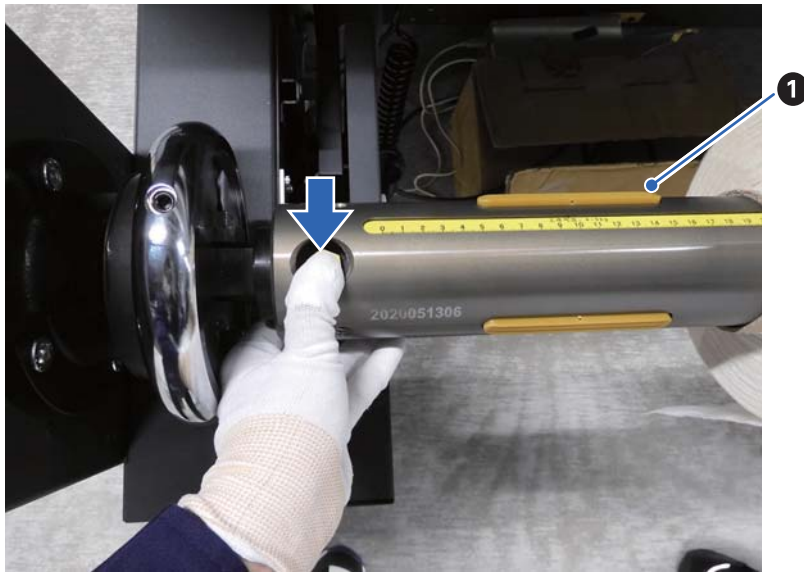


- 1 Air inlet

Basic Operations

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

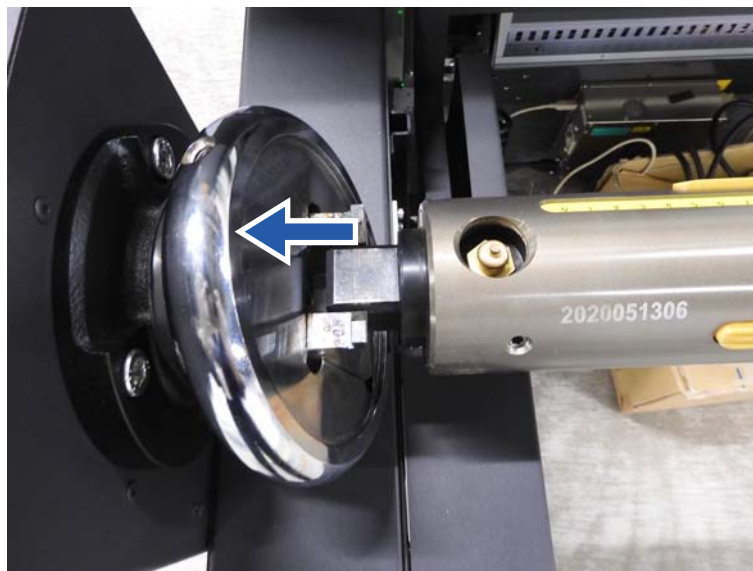
This loosens the stopper and creates a gap between the fabric roll core and the spindle.



1 Stopper

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

This releases the spindle fixing.



- 5** Remove the feeding spindle.



Caution:

The feeding spindle weighs approximately 15 kg (33.1 pounds). When removing or transporting it, use at least two people.

Basic Operations



6

Pass the feeding spindle through the new fabric.

Place the fabric on a base and insert the feeding spindle into the roll core.



7

Push the spindle onto the feeding unit.



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).

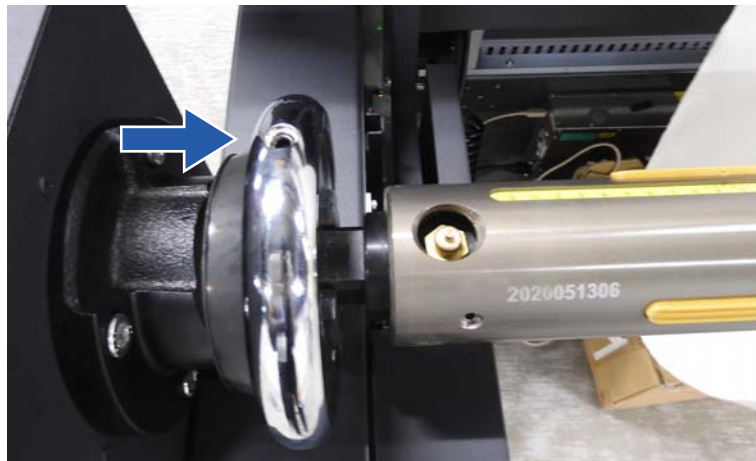
Basic Operations



8

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

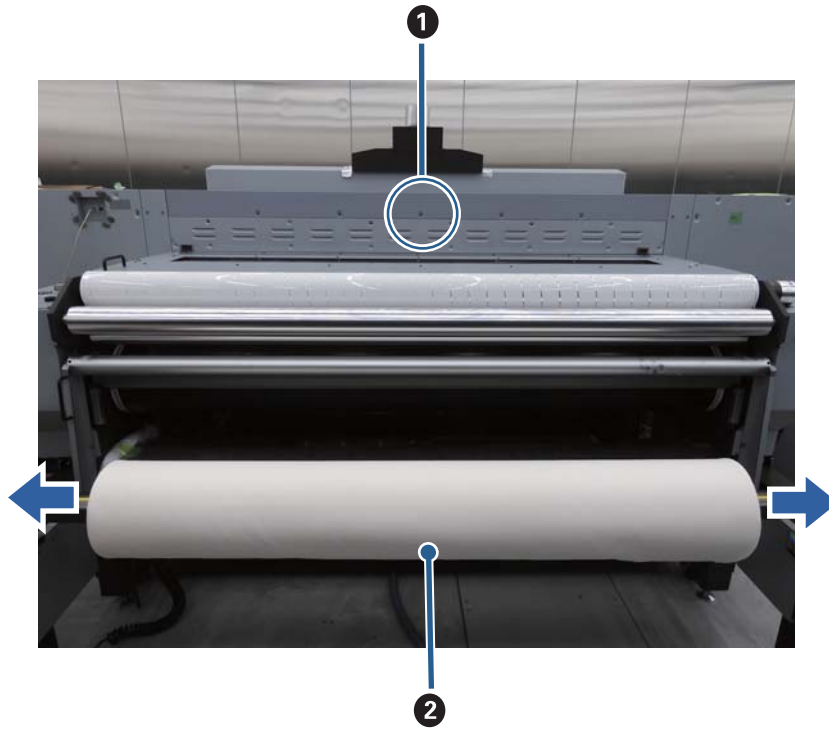
This fixes the spindle.



Basic Operations

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

The center screw on the rear cover is the machine center.



- ① Printer center
- ② Fabric center

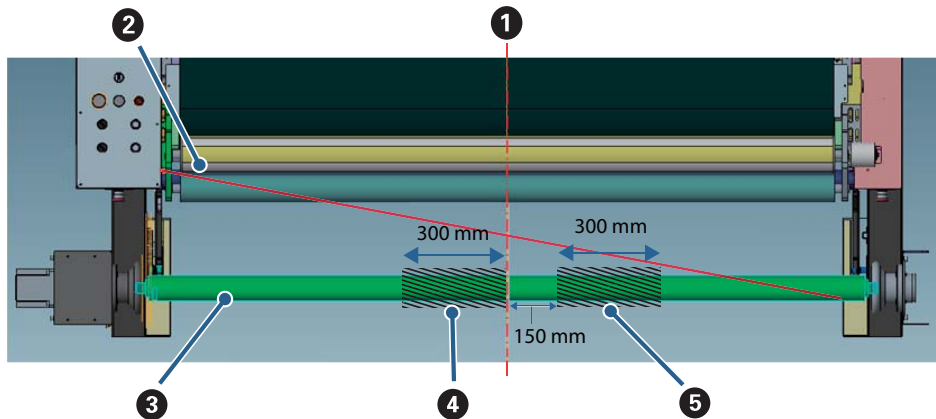
Basic Operations

Note:

When using fabric without tension (Slack Mode) and a roll with a short fabric width, place it so that the fabric roll covers the cross-hatch line area shown in the following illustration. If the fabric is placed outside of the cross-hatch line area, the sensors may not respond correctly.

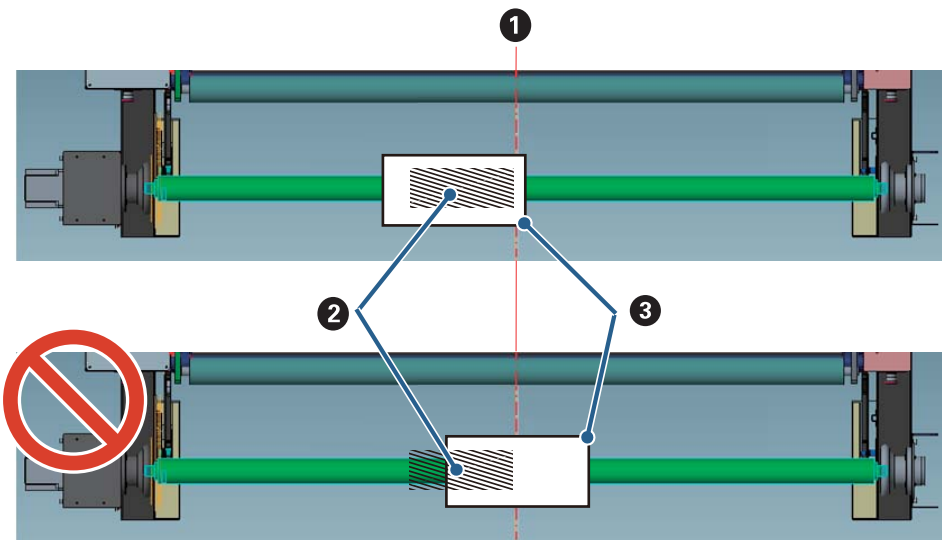
See the appendix for more details on the specifications of fabric rolls that can be used.

☞ "Supported Fabric" on page 451



- 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

<Placement example when using a fabric roll internally>

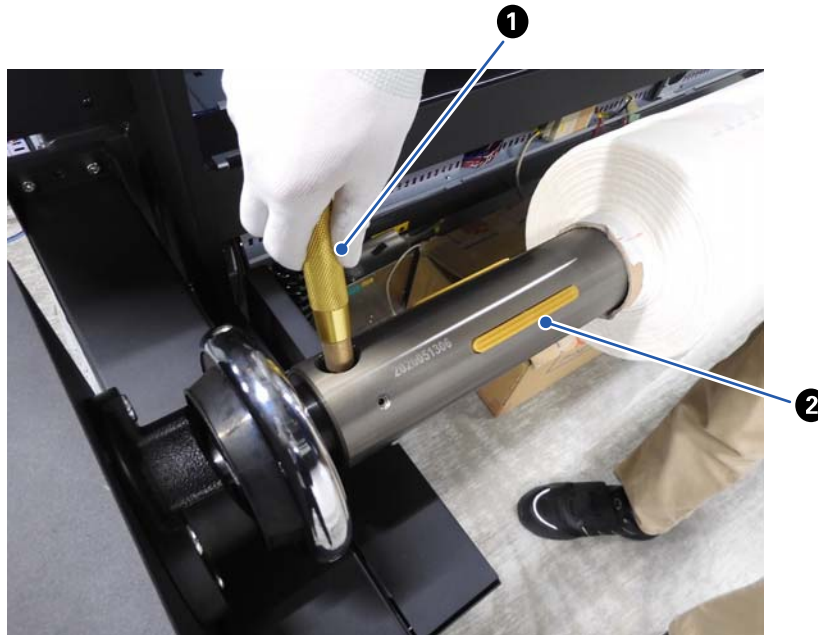


- ① Printer center
- ② Placement area
- ③ Fabric roll

Basic Operations

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

The stopper on the spindle swells to fix the fabric.



- ① Air inflating tool
- ② Stopper

Feed the fabric through the rollers

The method of loading the fabric differs depending on whether you are printing with tension applied to the fabric or printing without tension applied due to its elasticity. The loading method also differs depending on the thickness of the fabric.

☞ [“When applying tension to the fabric/When the fabric is less than 1 mm thick” on page 87](#)

☞ [“When not applying tension to the fabric/When the fabric is 1 mm thick or more” on page 92](#)

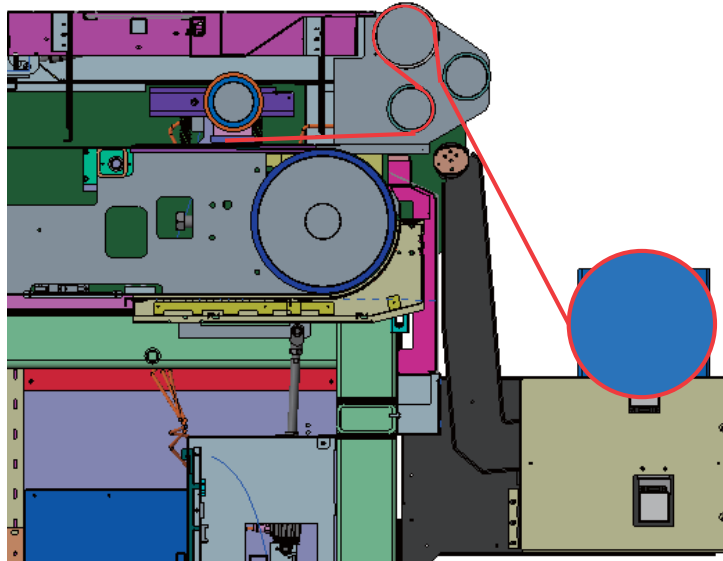
If the fabric is too thick and rigid to wrap around the rollers, or if it is a cut sheet, do not feed it through the rollers.

☞ [“When using thick and rigid fabric/When using cut sheets” on page 97](#)

Basic Operations

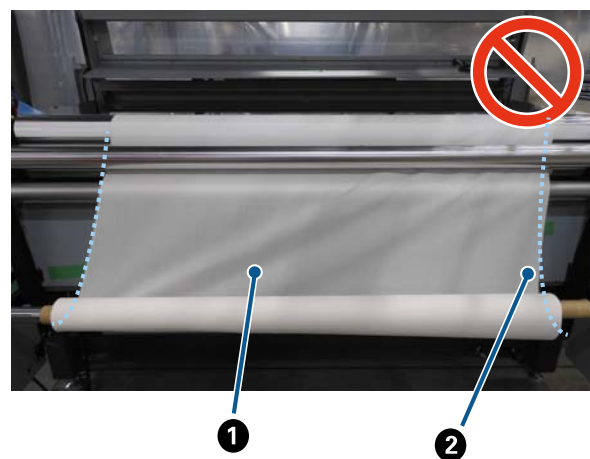
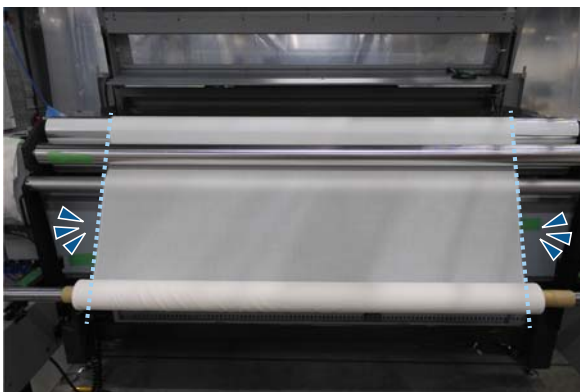
When applying tension to the fabric/When the fabric is less than 1 mm thick

- 1 Pull out the fabric on the feeding spindle and feed it through the rollers as shown in the figure.



Notes on Loading the Fabric

- Make sure the fabric is loaded straight in the feeding direction
- Even out the tension in the left and right sides of the fabric
- Temporarily lock the feeding roller if the fabric roll is off center



Basic Operations

- ① Wrinkles
- ② The tension in the left and right sides of the fabric differs

2 Press down on the fabric and spread out any wrinkles.

Make sure that the fabric is not folded or curled while feeding it.



Note:

If the fabric is drifting, temporarily set the tension switch to On (right) and set the feeding roller switch to either left or right, and then press the feed button to feed the belt. The fabric is pulled by the belt, allowing it to be loaded straight in the feed direction.

3 Turn the Pressure Roller switch to the left to lower the pressure roller.



Basic Operations

- 4** Pushing down on the tension roller with your hand to ensure the fabric does not gain any slack, push over the tension bar.



- 5** Set the feeding roller switch to match the print surface.
🔗 [“Rear panel” on page 19](#)



- ❶ Prints on the inner side of the roll
- ❷ Prints on the outer side of the roll

- 6** Turn the Tension Roller switch to On (right) to lock the spindle.
The spindle does not move even if the fabric is pulled.



Basic Operations

- 7 Close and lock the rear protective covers.



- 8 Turn the Pressure Roller switch to the right.
Move the pressure roller forward and back to affix the fabric to the belt.



- 9 Press the feed button (forward) on the rear panel to feed the fabric to the front of this machine.



Basic Operations

- 10** Move to the front of this machine. Peel the fabric from the belt and then press the feed button (forward) on the front panel to feed the fabric to the winder.



Important:

When starting printing without attaching the fabric to the winder, feed the fabric until the point where the fabric is being pressed by the pressure roller and is firmly stuck to the belt at the printing position. If printing is executed with the fabric still curled, the fabric may come into contact with the print head, damaging it.



- 11** Install the fabric on the external winder.

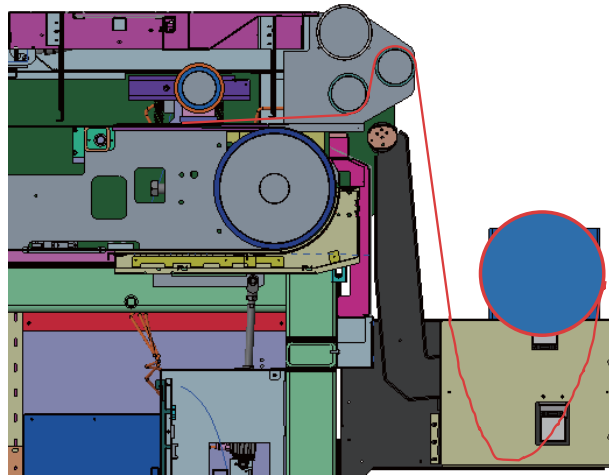
Note:

For details about handling the winder, see the manual supplied with the winder.

Basic Operations

When not applying tension to the fabric/When the fabric is 1 mm thick or more

- 1** Pull out the fabric on the feeding spindle and feed it through the rollers as shown in the figure.

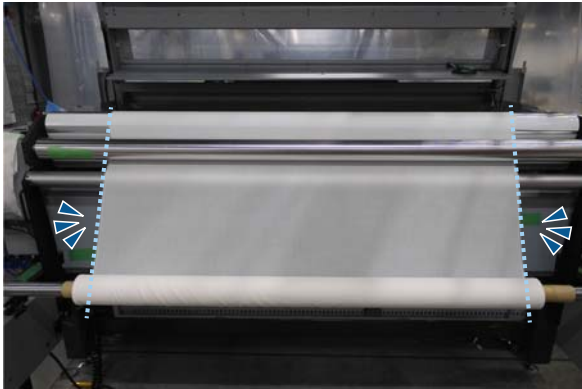


Notes on Loading the Fabric

- Make sure the fabric is loaded straight in the feeding direction
- Even out the tension in the left and right sides of the fabric

Basic Operations

- ❑ Temporarily lock the feeding roller if the fabric roll is off center



- ❶ Wrinkles
- ❷ The tension in the left and right sides of the fabric differs

2 Press down on the fabric and spread out any wrinkles.

Make sure that the fabric is not folded or curled while feeding it.



Note:

If the fabric is drifting, temporarily set the tension switch to On (right) and set the feeding roller switch to either left or right, and then press the feed button to feed the belt. The fabric is pulled by the belt, allowing it to be loaded straight in the feed direction.

Basic Operations

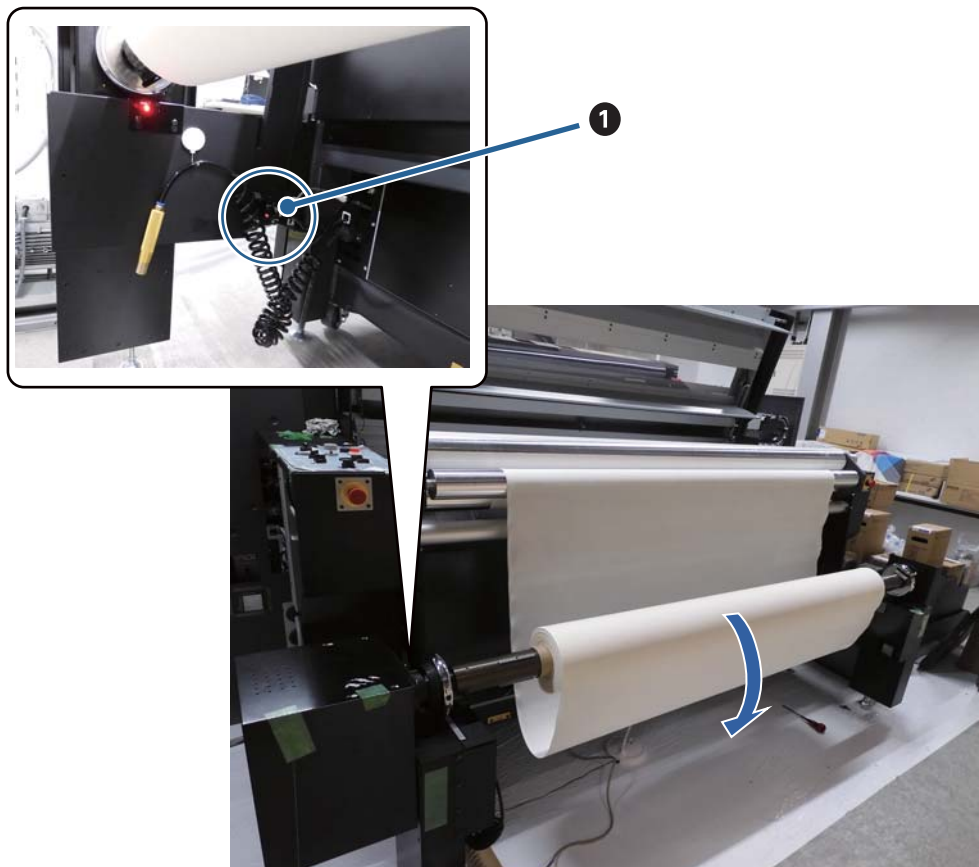
- 3** Turn the Pressure Roller switch to the left to lower the pressure roller.



- 4** Set the Slack detection switch to On.



- 5** Pull out the fabric until the slack detection sensor responds (the orange light turns on).



1 Slack detection sensor

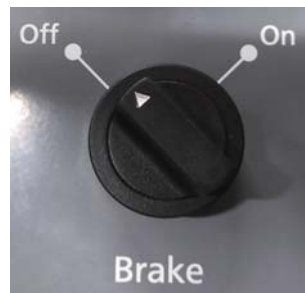
Basic Operations

- 6** Set the feeding roller switch to match the print surface.
👉 “Rear panel” on page 19



- ❶ Prints on the inner side of the roll
- ❷ Prints on the outer side of the roll

- 7** Make sure that the Tension Roller switch is set to Off (left).



- 8** Close and lock the rear protective covers.



Basic Operations

- 9 Turn the Pressure Roller switch to the right.
Move the pressure roller forward and back to affix the fabric to the belt.

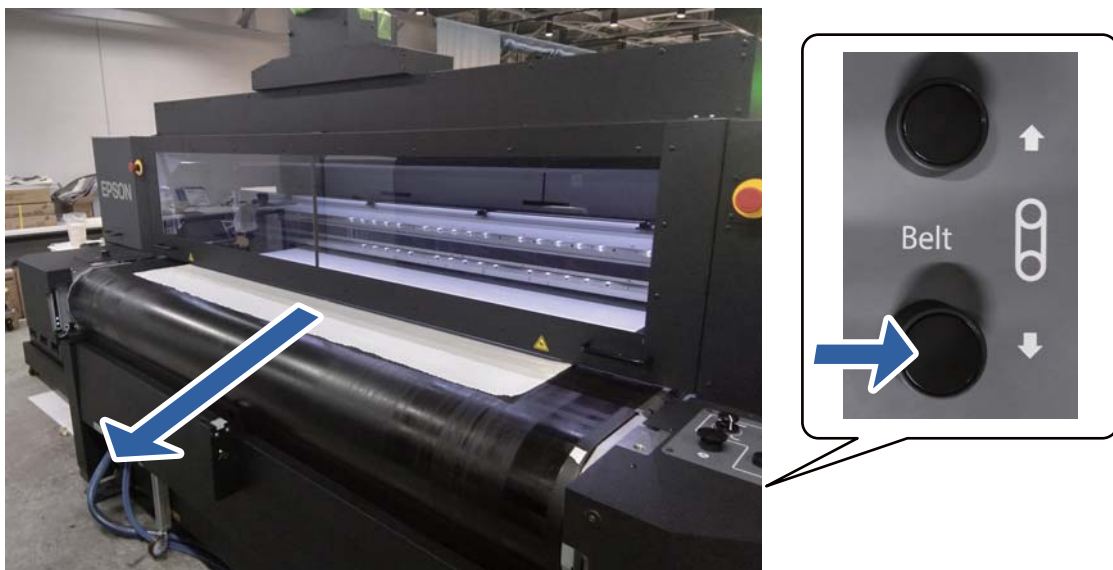


- 10 Press the feed button (forward) to feed the fabric to the front of this machine.



- 11 Move to the front of this machine. Peel the fabric from the belt and then press the feed button (forward) on the front panel to feed the fabric to the winder.

! Important:
When starting printing without attaching the fabric to the winder, feed the fabric until the point where the fabric is being pressed by the pressure roller and is firmly stuck to the belt at the printing position.
If printing is executed with the fabric still curled, the fabric may come into contact with the print head, damaging it.



Basic Operations

- 12** Install the fabric on the external winder.

Note:


For details about handling the winder, see the manual supplied with the winder.

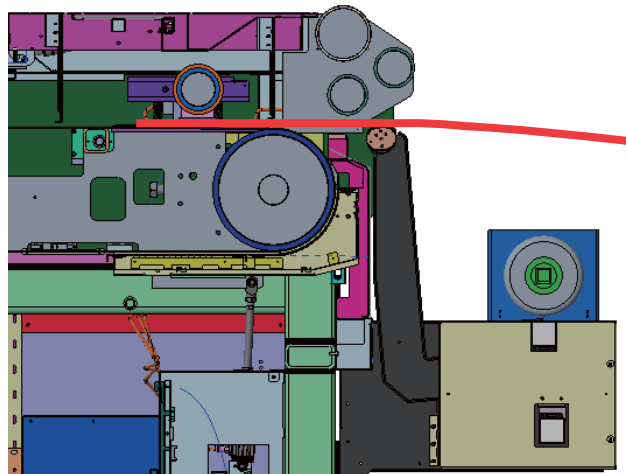
When using thick and rigid fabric/When using cut sheets

If the fabric is too thick and rigid to wrap around the rollers, or if it is a cut sheet, do not feed it through the rollers.

Note:

If you are using thick, rigid, rolled fabric, determine the fabric path according to your machine.

- 1** Touch the  (Fabric Feeding Device Settings) button on the control panel, and then check that the Feeding Unit is set to **Off**.
- 2** Feed the fabric through the rollers as shown in the figure.



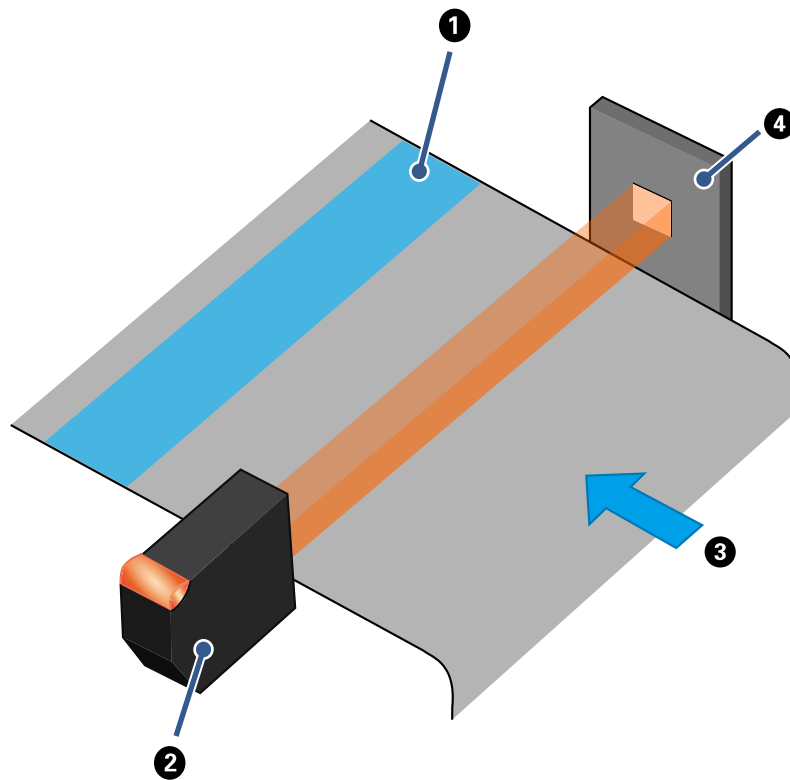
- 3** Press the feed button (forward) to feed the fabric to the front of this machine.



Basic Operations

Setting the Foreign Material Detection Sensor

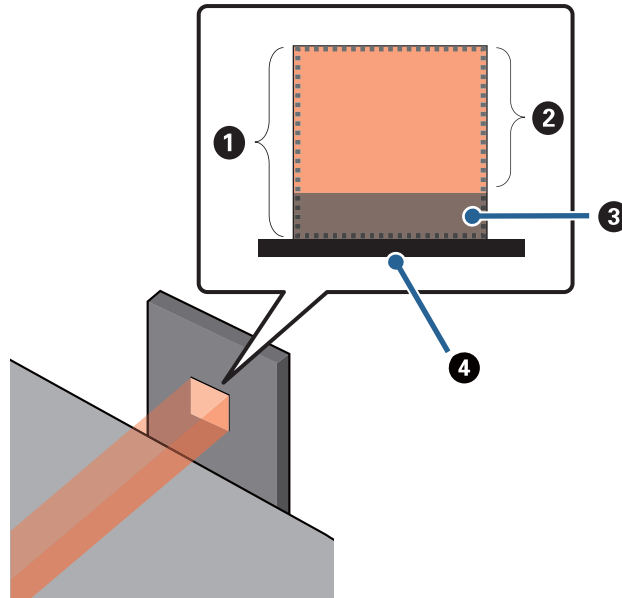
The foreign material detection sensors are located inside the rear cover and use a laser beam to detect gaps in the thickness of the fabric. If there is any foreign material on the fabric, or if the fabric does not stick to the belt and rises up or flips over, the print head stops to prevent it from colliding with the foreign material or the fabric.



- ① Printing position
- ② Foreign material detection sensor
- ③ Fabric feeding direction
- ④ Reflector plates

Basic Operations

This measures the amount of light emitted by the sensor when the laser light is reflected back from the reflectors. When the light is at 100% intensity, there is no foreign material or folded fabric blocking the laser light. The percentage of light intensity decreases if there is any foreign material or folded fabric blocking the light. If the percentage of light intensity is lower than the specified value (the threshold), the sensor will react. The default threshold is 85%. When loading the fabric for the first time or changing the fabric type or thickness, you need to set the sensor. If the fabric is more than 2 mm thick, you also need to set a threshold.



- ① Laser light intensity: 100%
- ② Threshold: 85% (default)
- ③ Fabric tolerance level
- ④ Belt

You can check and set the light intensity and threshold of the foreign material detection sensor on the rear panel.



- ① Indicates the threshold. The sensor reacts when the amount of light falls below the threshold (%) specified here.

If the fabric is more than 2 mm thick, we recommend lowering the threshold (making it less sensitive). If you leave it at the default threshold (85%), the sensor may overreact.

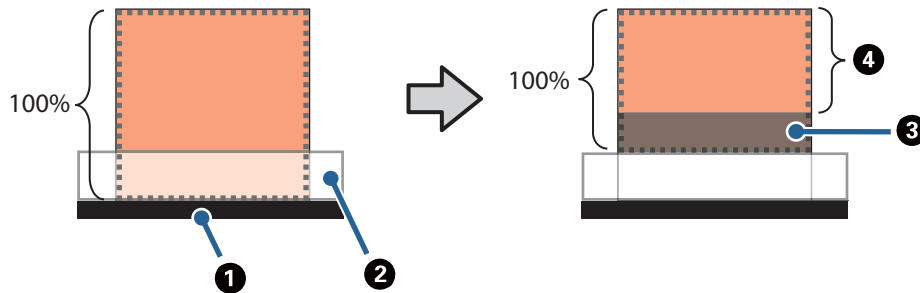
- ② Indicates the measured light intensity (%).
- ③ Press ◀ to decrease the threshold, and press ▶ to increase the threshold. The higher the threshold, the more sensitive the sensor becomes. The lower the threshold, the less sensitive it becomes.

Basic Operations

- ④ When you press this button, the amount of light measured when you press it is set as 100%.
When loading the fabric for the first time or changing the fabric type or thickness, press this button while fabric is loaded.

Press this button while fabric is loaded

Areas that do not contain the fabric reach 100% light intensity



- ① Belt
- ② Fabric
- ③ Fabric tolerance level
- ④ Threshold

Note:

To return the threshold to the default value, press the ④ **PRESET** button while no fabric is loaded.

Fabric Information Settings



Important:

Since the print head ejects ink while moving left and right, if the distance from the print head to the fabric is not set correctly, printing errors may occur or the print head may be damaged due to contact between the fabric and the print head.

1

Touch the Fabric information area of the control panel.

Displays the Fabric Settings menu.

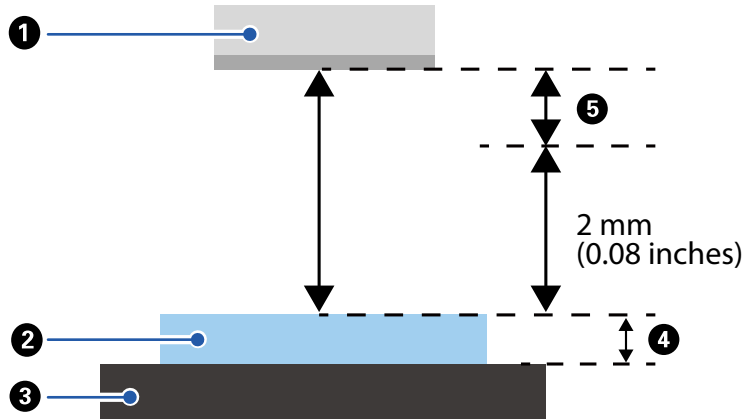
Basic Operations

- 2 Touch **Fabric Management** to select any control number, and then enter information for the fabric you are using.

[“Fabric Settings Menu” on page 423](#)

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

- 3 Return to the Fabric Settings menu, touch **Current Settings - Fabric**, and then select the control number to which you registered the fabric information.

- 4 Return to the Home screen, and then make sure that the fabric information you selected is displayed in the Fabric Information area.

Setting the Print Start Position

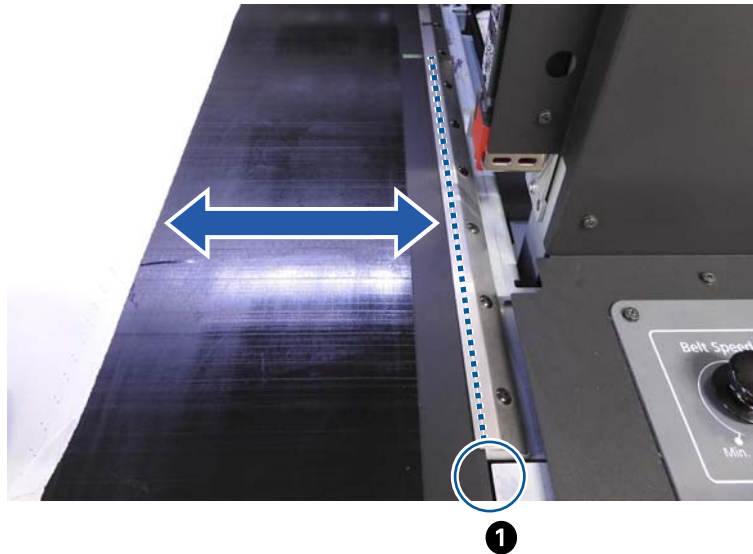
- 1 Use an item such as a tape measure or ruler to measure the distance from the right edge of the belt (standard position) to the position where you want to start printing.

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 120](#)

Basic Operations

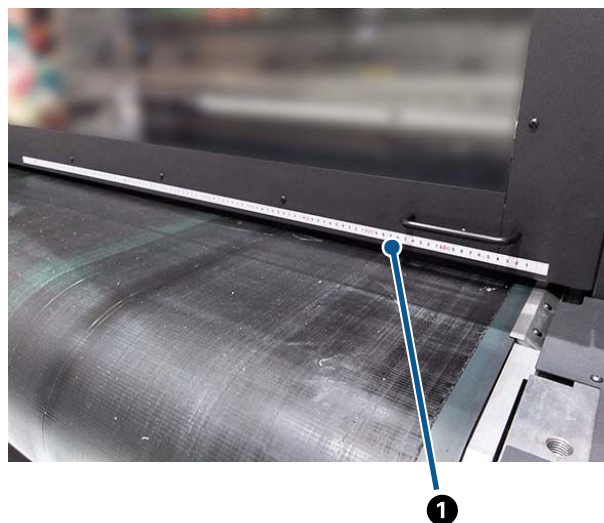


- 1 Edge of belt (standard position)

Note:

For printers with a tape measure attached, you can use this to measure the print start position.

If you want to add a tape measure to your printer, contact your dealer or Epson Support.



- 1 Tape measure

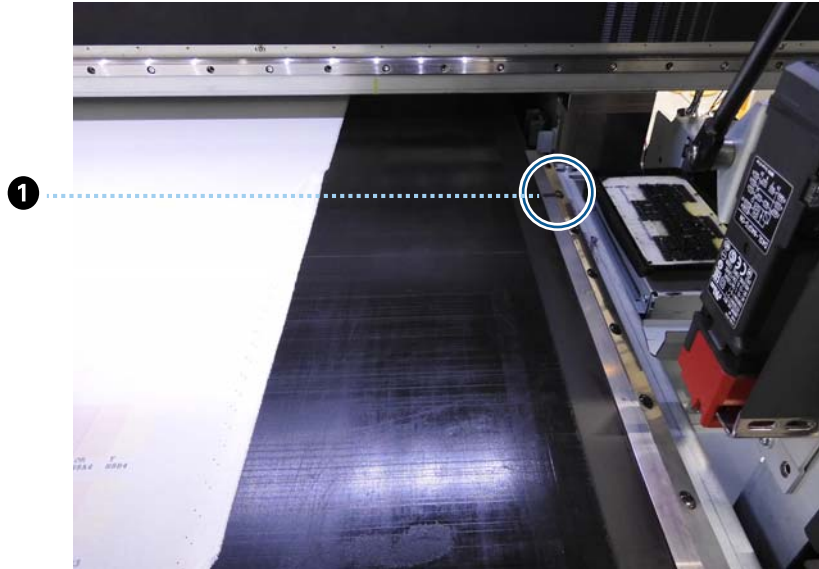
- 2 Set the **Print Start Position** on the Home screen on the control panel.

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

Basic Operations

Note:

- ❑ When performing the belt flushing, it is necessary to specify the print position for the belt flushing.
 🔗 [“General Settings Menu” on page 415](#)
- ❑ The approximate start position for printing in the Y direction is the position of the second screw or hole from the back of the guide beside the belt.
 You cannot specify the print start position in the Y direction.



① Print Start Position (Y direction)

Executing Printing

Use the print tool to perform printing.

🔗 [“How to Use Epson Edge Print” on page 45](#)

🔗 [“How to Use the Rob File Printing Tool” on page 51](#)

⚠ Caution:

Do not open the rear cover while printing is in progress.

The printer stops when the rear cover lock lever is released. Close the rear cover and move the lock lever to the Lock (right) position to restart the printer

If the print head is on the suction cap when the printer is restarted, they may collide causing a malfunction to occur.

Make sure the print head is not on the suction cap before moving the lock lever to the Lock (right) position. If the print head is on the suction cap, see the following to retract the print head.

🔗 [“Manually Moving the Print Head” on page 434](#)

⚠ Important:

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

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

Basic Operations

Note:

If you want to clean the print head while printing a job, you can do so by pausing the printing process. However, the color of the printed material may change when printing resumes.

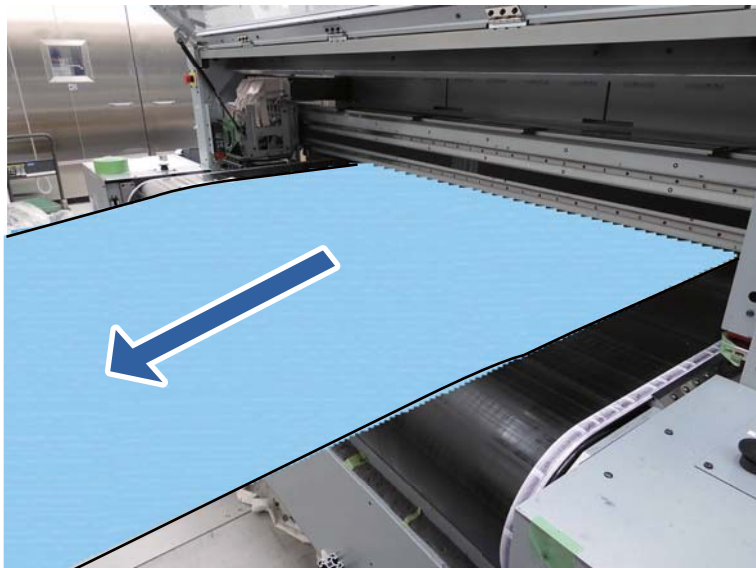
See the following for more information on cleaning the print head.

 [“Print Head Cleaning” on page 278](#)

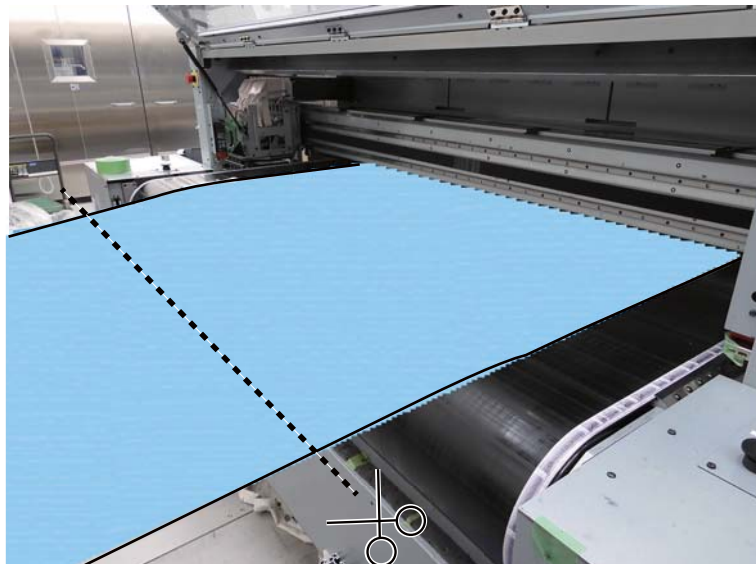
When Removing the Fabric

When removing fabric from this machine such as when replacing the fabric, use scissors or the like to cut between the machine front and the winder to remove the fabric.

- 1 Press the feed button (forward) on the front panel and feed the fabric to a desired position.



- 2 Use scissors or the like to cut between the machine front and the winder.



Basic Operations

- 3** Remove the fabric from the belt.



- 4** Move to the rear of the machine, and then remove the fabric inside the rear cover from the belt.



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



Basic Operations

- 6 Lift up the tension bar.



- 7 Set the tension switch to Off.



- 8 Manually turn the feeding spindle to take up the fabric.



Basic Operations

When Splicing the Fabric

When there is no more fabric left, use the sewing machine at the rear of the printer to sew together the fabric being printing on and the new fabric.

- 1 Use scissors or the like to cut between the feeding spindle and the tension roller.



- 2 Remove the feeding spindle and replace it with the new fabric roll.

[👉 “Removing and attaching the feeding spindle” on page 80](#)

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



Basic Operations

- 4 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.

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

Workflow before Completing Work

Daily Cleaning

Cleaning and replacement of consumables must be performed to ensure the print quality. Failure to perform appropriate maintenance could result in reduced print quality.

 [“When to Perform Various Maintenance Operations” on page 172](#)

Turning Off the Power

- 1 Press and hold the power button on the control panel for 2 seconds or more.



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

Basic Operations

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

When the breaker turns off, the breaker turns off to prevent the tension bar from lowering causing the feeding spindle to rotate, and to prevent excess fabric from being pulled out.



- 4** Make sure that all of the signal lamps have gone off and then turn off the breaker (Main Power) on the rear of the machine.



Print Adjustments

Use this menu in the following cases.

- Using new fabric not registered to the printer
Perform **Automatic Adjustment** after loading fabric to the printer.
- If you can still see banding or graininess in the print results even after performing Fabric Feed Adjustment while printing. [↗ “Changing settings while printing” on page 28](#)
If the problem continues to occur, perform **Manual(Simple)** from **Print Head Alignment**.
- When the fabric width is different
- When the fabric thickness or head height is changed

Basic Operations

Note:

- ❑ If the print results do not improve by performing *Print Adjustments* or *Fabric Feed Adjustment* 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.

- ❑ If you have configured **Margin between Jobs**, then margins are applied during print adjustments as well.

Automatic Adjustment

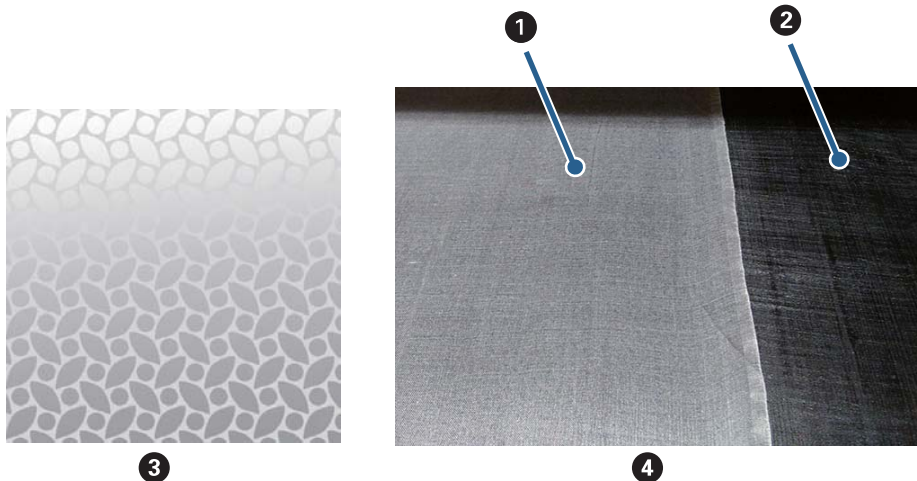
Landing site displacement and fabric feeding are adjusted while printing the pattern.

Depending on the fabric, reading the pattern may fail. When using the following types of fabric, perform **Manual** from **Print Head Alignment** and **Manual** from **Fabric Feed Adjustment**.

🔗 Print Head Alignment: [“Manual” on page 111](#)

🔗 Fabric Feed Adjustment: [“Manual” on page 113](#)

- ❑ Fabric with a weave density of 25 strands/inch or less
- ❑ Colored fabric
- ❑ Fabric with a sheen or patterns
- ❑ Transparent fabric



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

1 Check that the printer is ready, and load the fabric according to the actual usage conditions.

🔗 [“Removing and attaching the feeding spindle” on page 80](#)

Basic Operations


- 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.
- 4 Touch **Start**.
Auto adjust starts, and an adjustment pattern is printed. Wait until adjustment is complete.


If an Error Occurs During Automatic Adjustment

See the following for more details.

- 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. 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 1.

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

 Print Head Alignment: ["Manual" on page 111](#)

 Fabric Feed Adjustment: ["Manual" on page 113](#)

Print Head Alignment

Auto

The same adjustment as Print Head Alignment of Automatic Adjustment is performed.

- 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 - Print Head Alignment - Auto**, in that order.
- 4 Touch **Start**.
Auto adjust starts, and an adjustment pattern is printed. Wait until adjustment is complete.

Manual

You can select Manual(Simple) or Manual(Details) to make adjustments.

Basic Operations

Manual(Simple)

Select this when you cannot perform automatic adjustments, or when you want to perform quick and simple adjustments by visually inspecting the pattern.

Manual(Details)

Select this when you want to perform adjustment equivalent to Auto adjustment by visually inspecting the pattern.

Adjustment Procedure

- 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 - Print Head Alignment**, in that order.
- 4 Select **Manual(Simple)** or **Manual(Details)**, and then touch **Start**.
An adjustment pattern is printed. Wait until printing is complete.
- 5 Open the front cover to check the printed adjustment pattern.

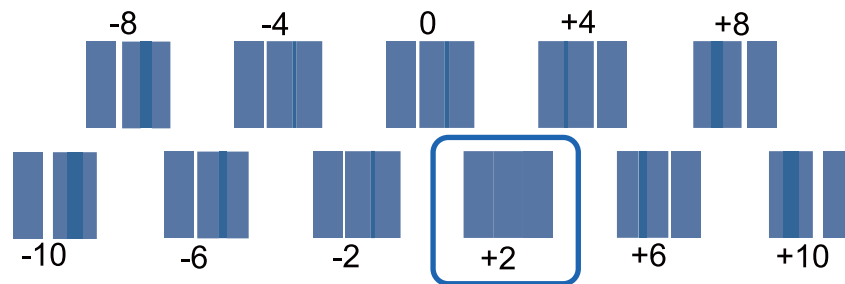
Adjustment pattern blocks are printed as shown below according to the type of manual adjustments.

Manual (Simple): 8 blocks, A to H

Manual (Details): 64 blocks, A to Z, a to z, and 1 to 12

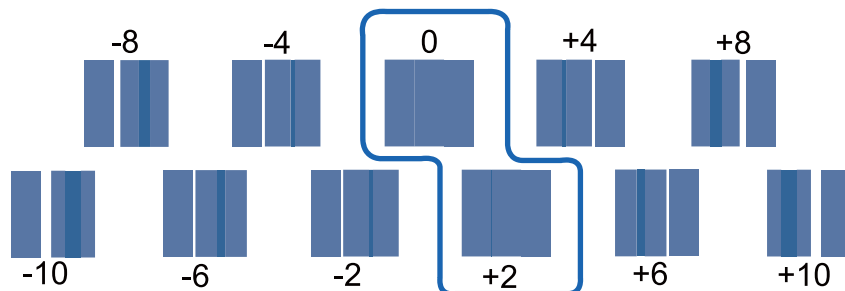
Select the pattern with the least tint unevenness for each block.

Select "+2" in the example shown below.



If there are patterns where unevenness is the same, enter the middle value in Step 6.

Set "+1" in the example shown below.



- 6 Close the front cover.

The screen for entering confirmation results for the adjustment pattern is displayed.

Basic Operations

- 7** On the entry screen of each block, set the number confirmed in Step 4 by touching **-**/**+**, and then touch **OK**.
The Fabric Settings menu is displayed when you finish the adjustments.

Fabric Feed Adjustment

This menu is used when banding (horizontal banding, tint unevenness, or stripes) is detected in printing results. You can select Auto or Manual to make adjustments.

Auto

Select this when you want to perform quick and simple adjustment, such as for readjustment before the roll is used up.

The same adjustment as Fabric Feed Adjustment of Automatic Adjustment is performed.

- 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 - Auto**, in that order.
- 4** Touch **Start**.
Auto adjust starts, and an adjustment pattern is printed. Wait until adjustment is complete.

Manual

Make a selection in the following cases.

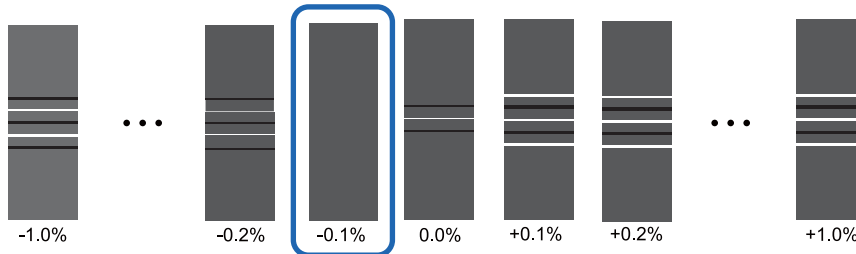
- When Auto adjustment has failed
- When you want to perform quick and simple adjustment by visually inspecting the pattern

- 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 - Fabric Feed Adjustment - Manual**, in that order.
- 4** Touch **Start**.
An adjustment pattern is printed. Wait until adjustment is complete.

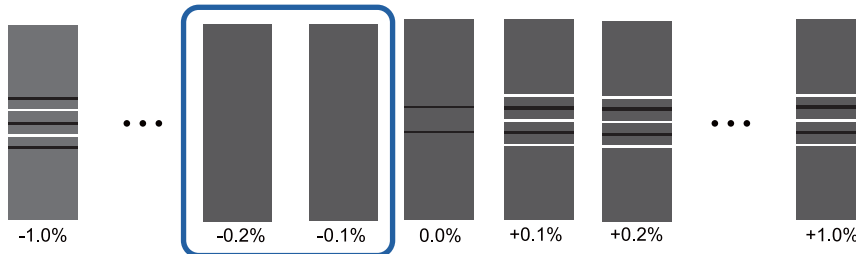
Basic Operations

5 Open the front cover to check the printed adjustment pattern.

Select the pattern with the least amount of overlapping or gaps. Select “-0.1%” in the example shown below.



If there are patterns where the overlapping or gaps are the same, enter the middle value in Step 6. Enter “-0.15%” 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.

Setting the Print Area and Print Position

The following functions are available for improving printing efficiency.

[☞ “Menu List” on page 408](#)

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

Belt flushing

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.

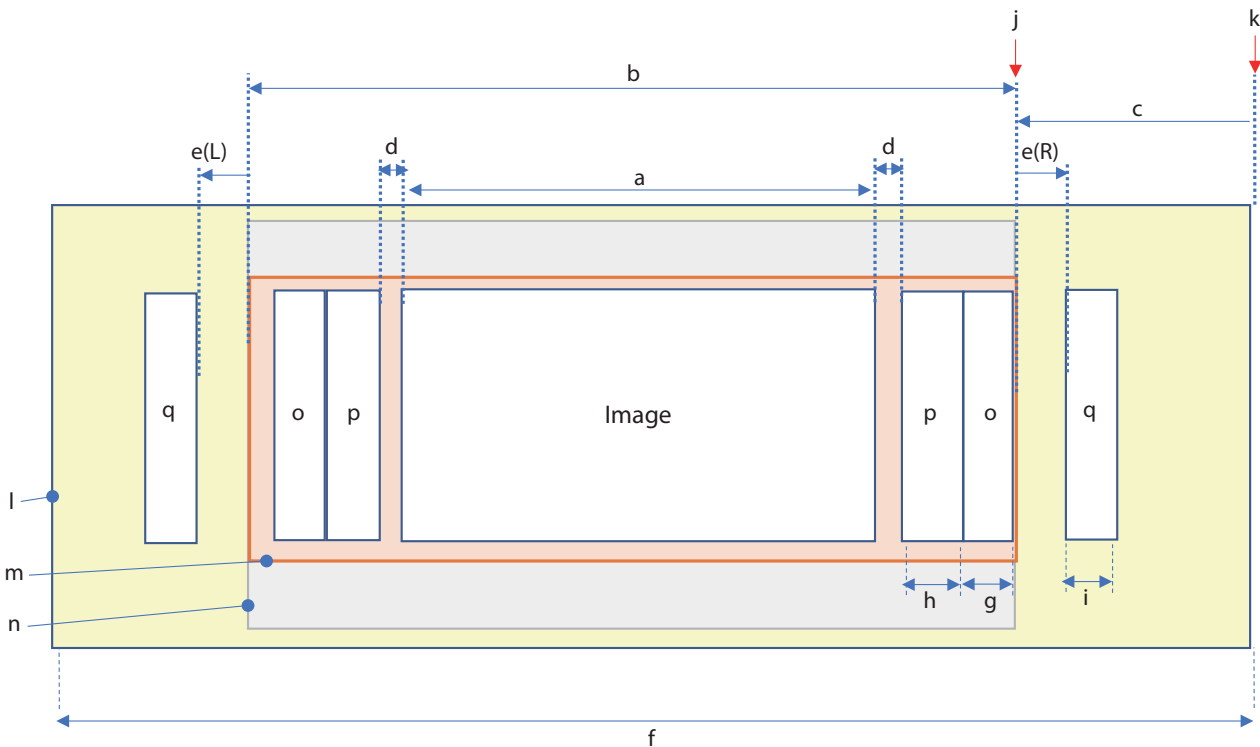
The belt flushing position is determined by the print width and the print start position.

[☞ “Belt Flushing Position” on page 116](#)

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	Image width	300 to 1850 mm (11.81 to 72.83 inches)	RIP software
b	Print Area	300 to 1850 mm (11.81 to 72.83 inches) Default value: 1100 mm (43.31 inches)	Control panel
c	Print Start Position	27 to 1000 mm (1.06 to 39.37 inches)	Control panel
d	Distance from image to fabric edge information	5 to 999 mm (0.20 to 39.33 inches) Default value: 5 mm (0.20 inches)	Control panel
e (R)/(L)	Distance from print area to belt flushing	This depends on the print width and the print start position. 📖 "Belt Flushing Position" on page 116	-

Basic Operations

Symbol	Item	Value / Range	Setting method
f	Printable area	1912 mm (75.28inches)	-
g	Fabric edge nozzle check width	4 mm or 16 mm (0.16 inches or 0.63 inches)	-
h	Event marking width	20 mm (0.79inches)	-
i	FL on belt	-	-
j	Image edge	-	-
k	Belt edge (Standard position)	-	-
l	Belt	-	-
m	Print Area	-	-
n	Fabric	-	-
o	Fabric Edge Nozzle Check	-	-
p	Event Marking	-	-
q	Belt flushing	-	-

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.

Belt Flushing Position

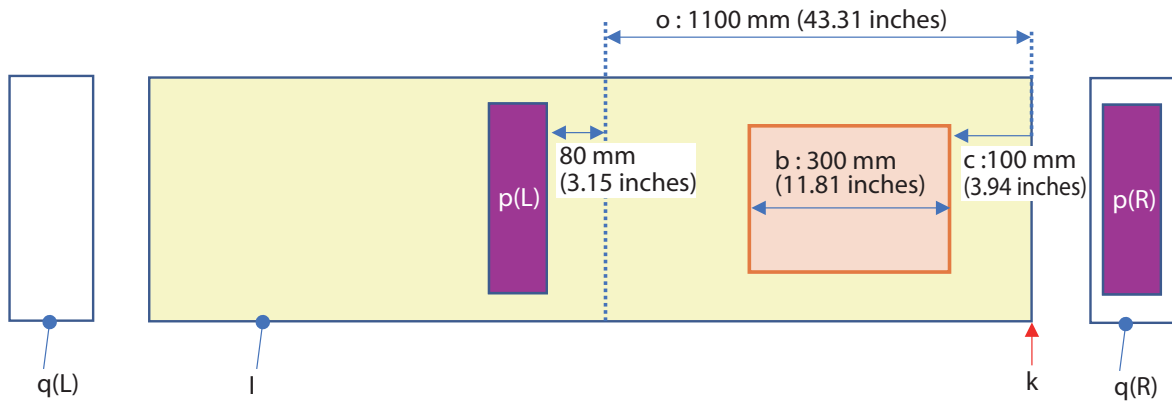
The belt flushing position is determined by the total length of the print width (b) and the print start position (c), and the length of the print width (b) and the print start position (c).

By adjusting the start print 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	Print Start Position	p (R)/(L)	Flushing box
k	Edge of belt (standard position)	q (R)/(L)	Belt flushing
l	Belt		

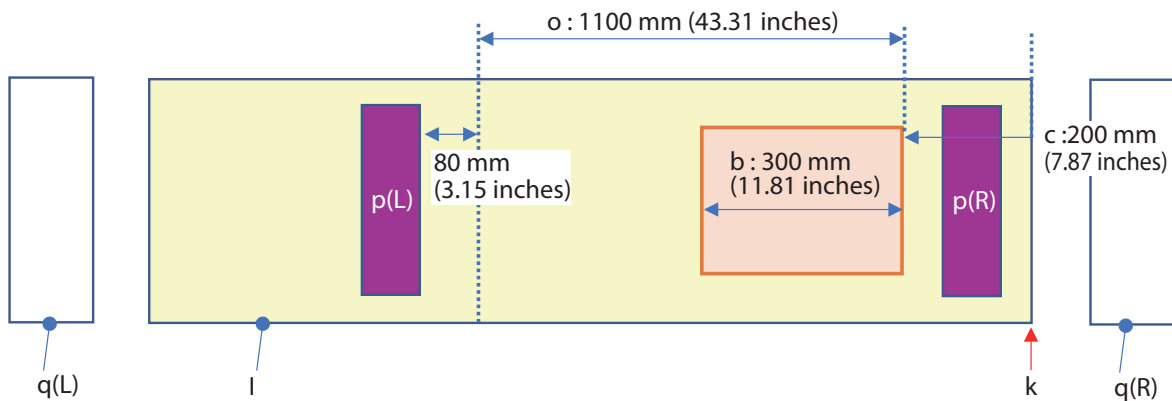
Basic Operations

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



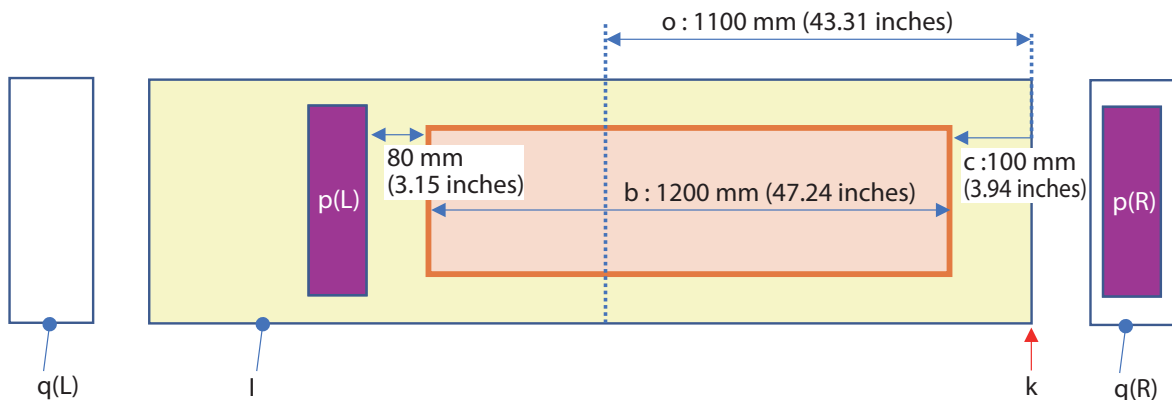
- Belt flushing (right) position: On the Flushing box (right)
- Belt flushing (left) position: 1100 mm (43.31 inches) + 80 mm (3.15 inches)

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)

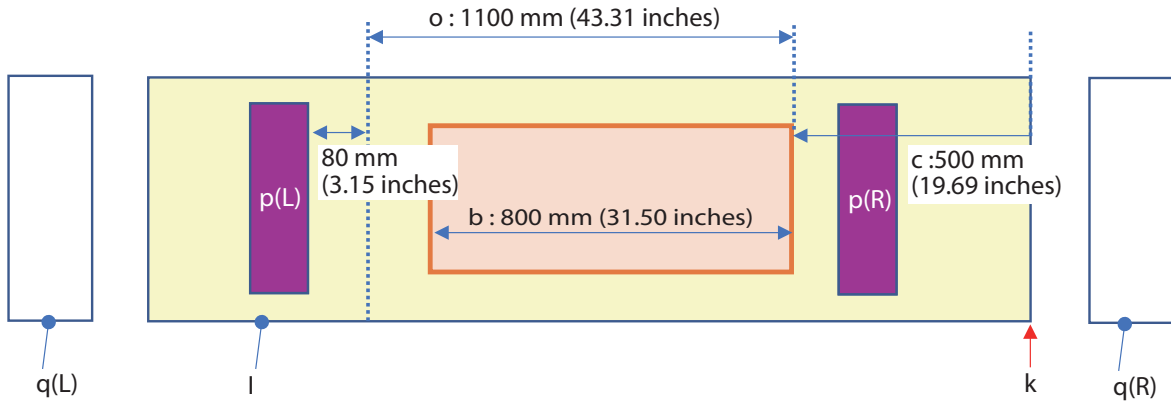
3 When 1776 mm (69.92 inches) $\geq b + c > 1100$ mm (43.31 inches) and $c \leq 155$ mm (6.10 inches)



Basic Operations

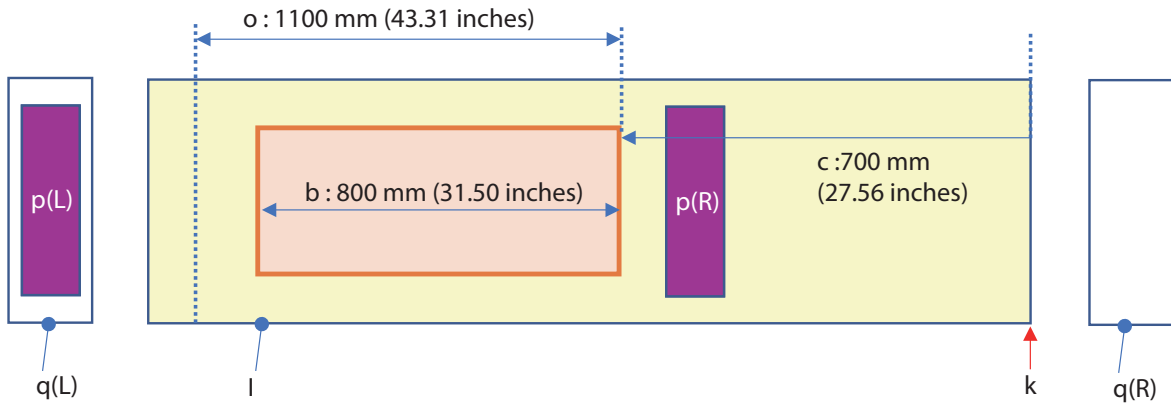
- ❑ Belt flushing (right) position: On the Flushing box (right)
- ❑ Belt flushing (left) position: $b + c + 80$ mm (3.15 inches)

4 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 $b \leq 1100$ mm (43.31 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)

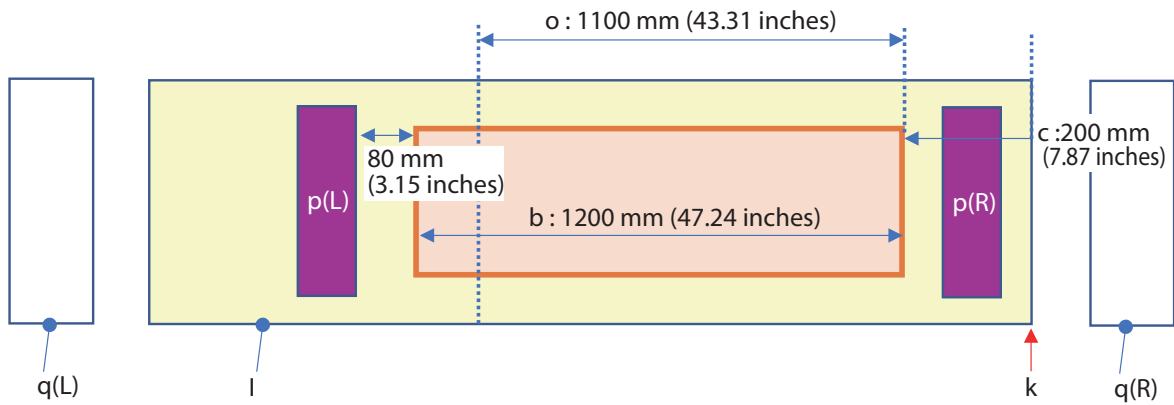
5 When 1776 mm (69.92 inches) $\geq b + c > 1100$ mm (43.31 inches) and 850 mm (33.46 inches) $\geq c > 676$ mm (26.61 inches) and $b \leq 1100$ mm (43.31 inches)



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

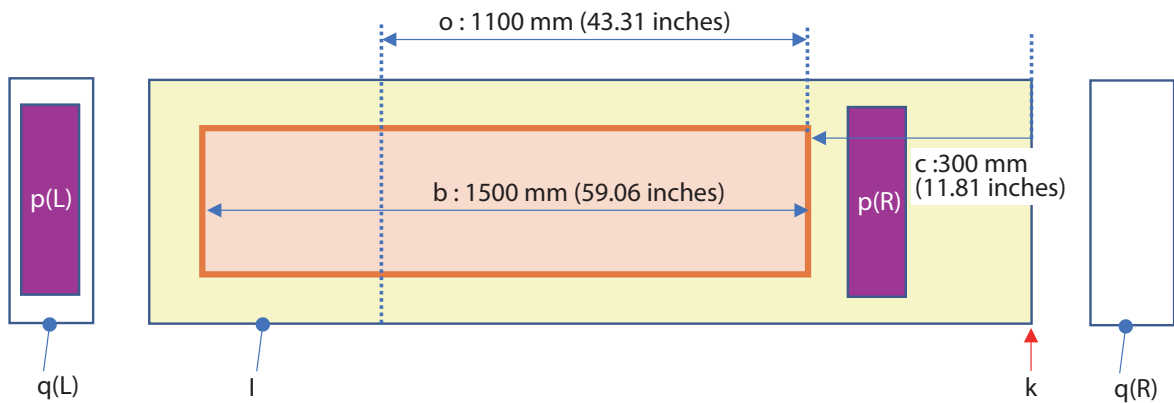
Basic Operations

- 6** 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 $b > 1100 \text{ mm (43.31 inches)}$



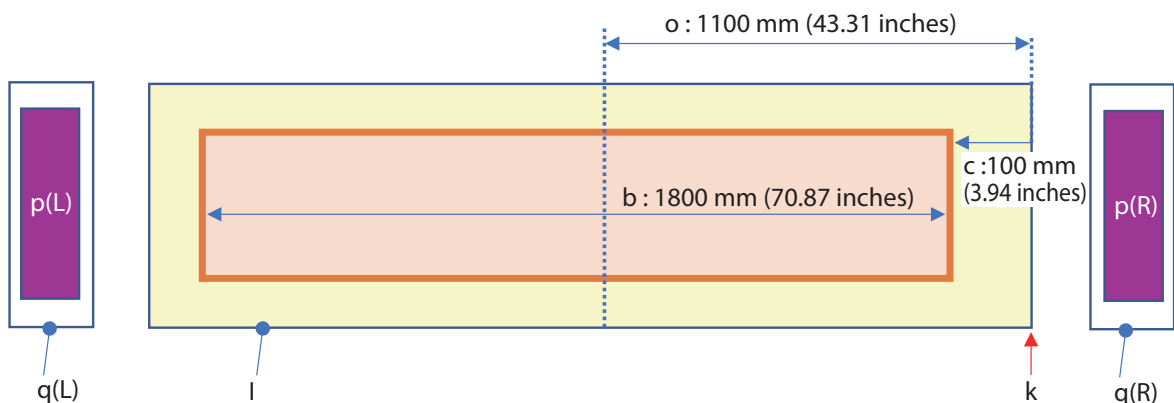
- Belt flushing (right) position: $c - 80 \text{ mm (3.15 inches)}$
- Belt flushing (left) position: $b + c + 80 \text{ mm (3.15 inches)}$

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



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

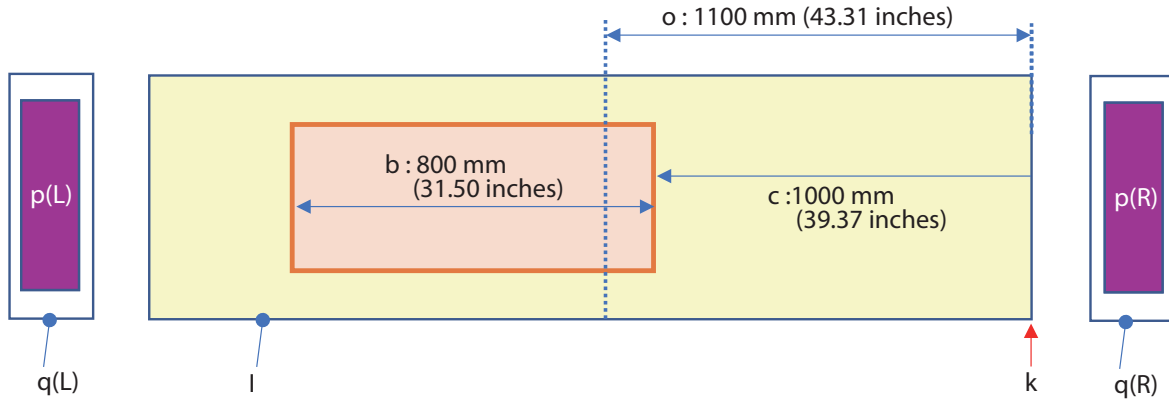
- 8** When $b + c > 1776 \text{ mm (69.92 inches)}$ and $c \leq 155 \text{ mm (6.10 inches)}$



Basic Operations

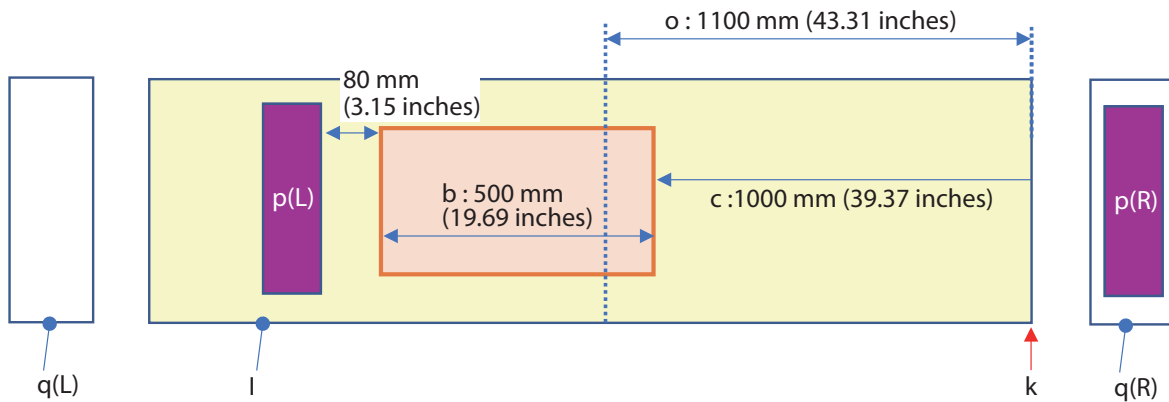
- Belt flushing (right) position: On the Flushing box (right)
- Belt flushing (left) position: On the Flushing box (left)

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



- Belt flushing (right) position: On the Flushing box (right)
- Belt flushing (left) position: On the Flushing box (left)

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



- Belt flushing (right) position: On the Flushing box (right)
- 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
Belt flushing	OFF	OFF	ON	ON
Fabric edge nozzle check pattern	OFF	ON	OFF	ON
Event Marking	OFF	ON	OFF	ON

Basic Operations

Pattern A

Belt flushing	OFF
Fabric edge nozzle check pattern	OFF
Event Marking	OFF



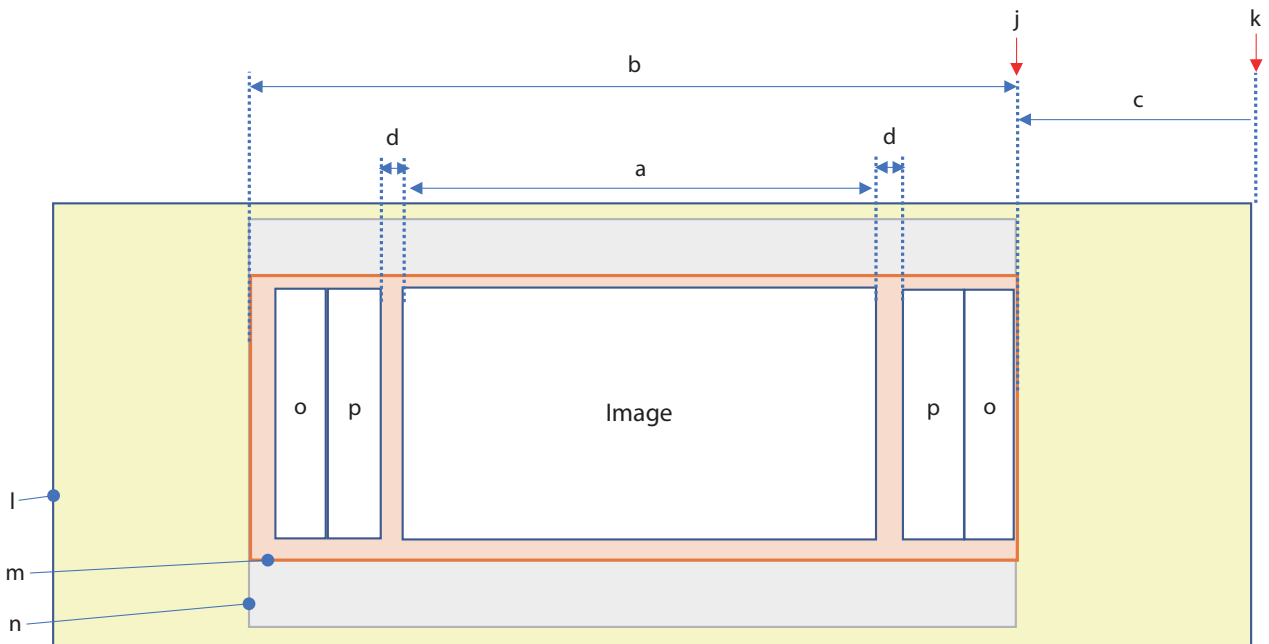
Symbol	Item	Setting method
a	Image width	Specify using the RIP software. To print without exceeding the edges of the fabric, prepare print data equal to or smaller than the fabric size. To print without leaving a margin at the edges of the fabric, prepare print data larger than the fabric size.
b	Print Area	Specify this on the control panel or in your application. 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	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 position where you want to start printing and set this as the distance. 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. "Setting the Print Start Position" on page 101
j	Image edge	-
k	Belt edge (Standard position)	-
l	Belt	-
m	Print Area	-
n	Fabric	-

Pattern B

Belt flushing	OFF
Fabric edge nozzle check pattern	ON
Event Marking	ON



Basic Operations

Symbol	Item	Setting method
a	Image 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.
b	Print Area	Specify this on the control panel. Specify the same value as the fabric width.
c	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 101
d	Distance from image to fabric edge information	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	Image edge	-
k	Belt edge (Standard position)	-
l	Belt	-
m	Print Area	-
n	Fabric	-
o	Fabric Edge Nozzle Check	-
p	Event Marking	-

Pattern C

Belt flushing	ON
Fabric edge nozzle check pattern	OFF
Event Marking	OFF

Basic Operations



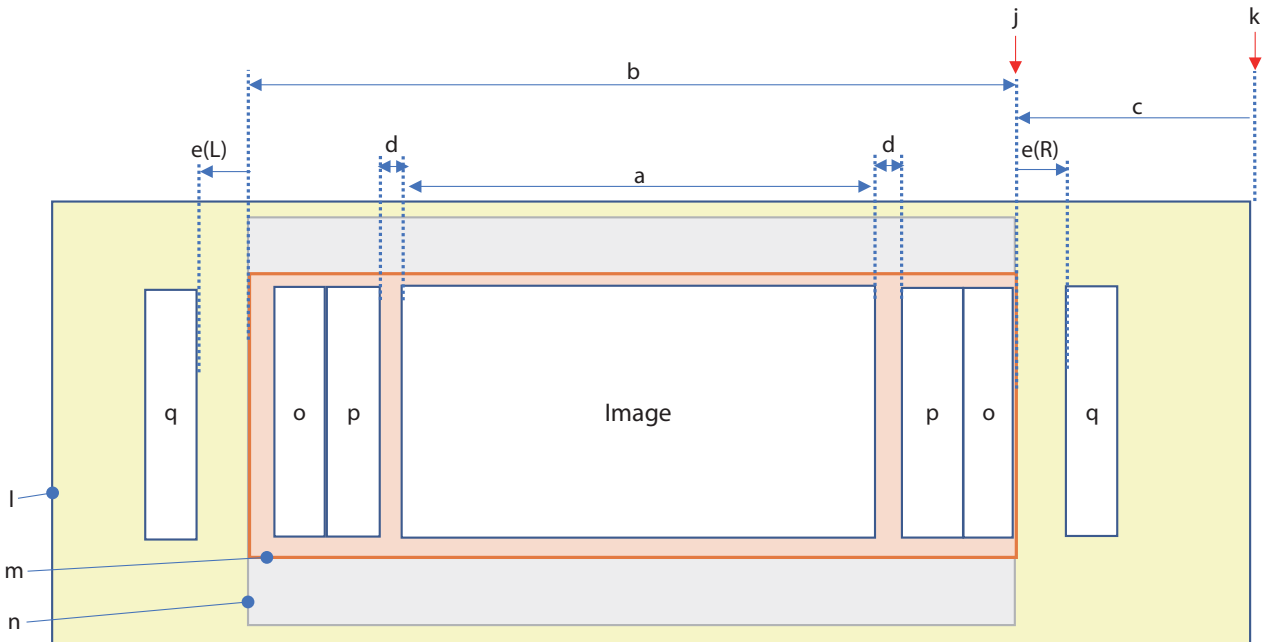
Symbol	Item	Setting method
a	Image width	Specify using the RIP software. To print without exceeding the edges of the fabric, prepare print data equal to or smaller than the fabric size. To print without leaving a margin at the edges of the fabric, prepare print data larger than the fabric size.
b	Print Area	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.
c	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 position where you want to start printing and set this as the distance. 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. 🔗 "Setting the Print Start Position" on page 101
e (R)/(L)	Distance from print area to belt flushing	This depends on the print width and the print start position. 🔗 "Belt Flushing Position" on page 116
j	Image edge	-
k	Belt edge (Standard position)	-
l	Belt	-

Basic Operations

Symbol	Item	Setting method
m	Print Area	-
n	Fabric	-
q	FL on belt	-


Pattern D

Belt flushing	ON
Fabric edge nozzle check pattern	ON
Event Marking	ON



Symbol	Item	Setting method
a	Image 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.
b	Print Area	Specify this on the control panel. Specify the same value as the fabric width.
c	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 101

Basic Operations

Symbol	Item	Setting method
d	Distance from image to fabric edge information	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)	Distance from print area to belt flushing	This depends on the print width and the print start position.  "Belt Flushing Position" on page 116
j	Image edge	-
k	Belt edge (Standard position)	-
l	Belt	-
m	Print Area	-
n	Fabric	-
o	Fabric Edge Nozzle Check	-
p	Event Marking	-
q	FL on belt	-

Sensor Settings

This printer is equipped with a variety of sensors. Follow the steps below to adjust or reset the sensitivity of the sensor.

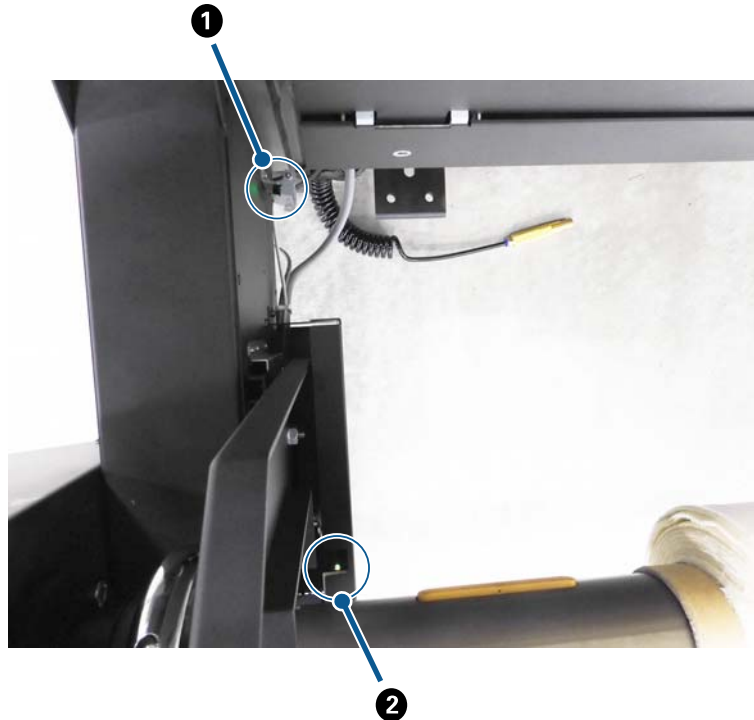
Slack detection sensor and roll diameter measurement sensor

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

Basic Operations

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

If the lamp is lit up in orange, an obstruction has been detected. Remove any obstructions from the sensor's optical axis.



- ① Slack detection sensor Green light
- ② Green light for roll diameter measurement sensor

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

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

If the light flashes orange, 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.

Foreign material detection sensor

 [“Setting the Foreign Material Detection Sensor” on page 98](#)

Tangled Fabric Detection Sensor

The center of the belt cleaning unit is equipped with a sensor to prevent printed fabric from getting caught in the belt cleaning unit. If the sensor detects that the fabric has become tangled, the printer comes to an emergency stop.

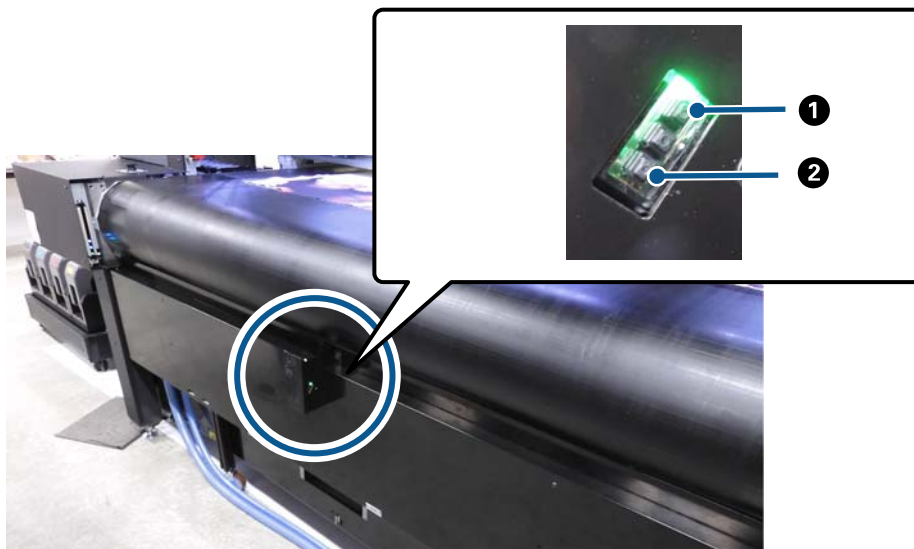
Basic Operations

Note that the sensor also reacts to water droplets and dust, so make sure you remove any that adhere to the belt.



After opening and closing the belt cleaning unit, the sensitivity of the sensor may change, so make adjustments if errors occur frequently. Follow the steps below to adjust the sensitivity of the sensor.

- 1 Press and hold the + or - key on the right of the sensor.
The green light flashes three times and the key is unlocked.



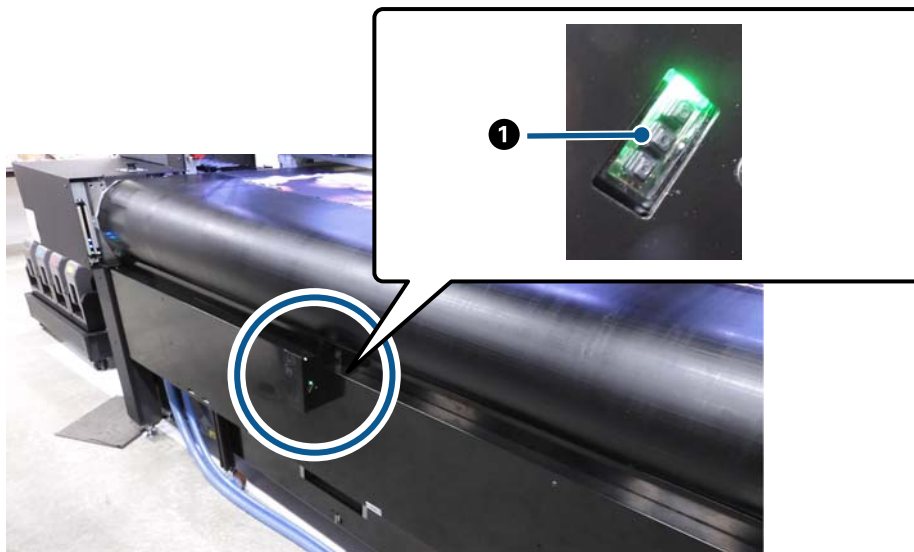
- 1 + key
- 2 - key

Basic Operations

- 2 Attach a piece of fabric or other material to the position where the sensor reacts.



- 3 Press and hold the C key in the middle of the sensor.
The sensor's light turns orange and flashes quickly.



1 C key

Basic Operations

- 4 Check if a red laser beam is being emitted by the sensor and shining on to the piece of fabric attached to the belt.

If the laser beam is not shining on to the fabric, re-load the fabric.

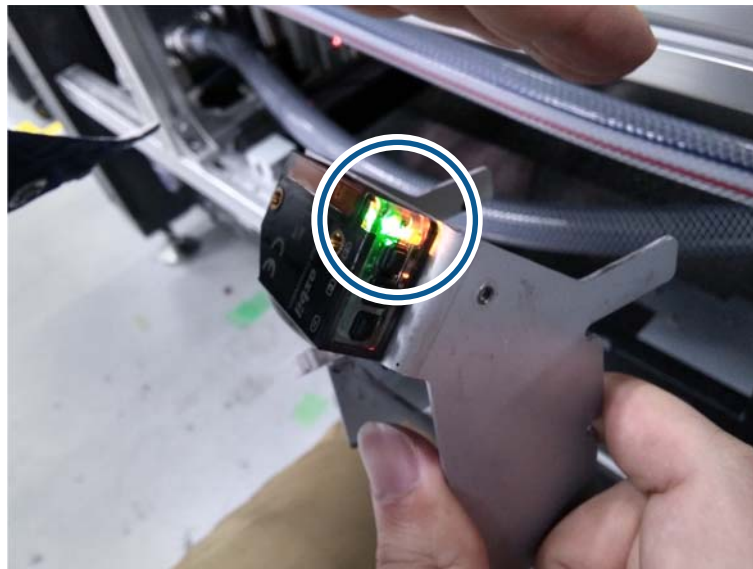


- 5 Press the C key in the middle of the sensor.

The sensor is now set to the reaction position.

- 6 Check the sensor adjustment results for any problems.

Press the feed button on the front panel to rotate the belt. When the sensor reacts, the part shown in the figure turns orange and the belt stops.



When the sensor reacts, see the following.

[👉 “When the sensor reacts” on page 132](#)

Basic Operations

7 Press and hold the + or - key to check the adjustment results.

The light flashes orange three times and the key is locked.

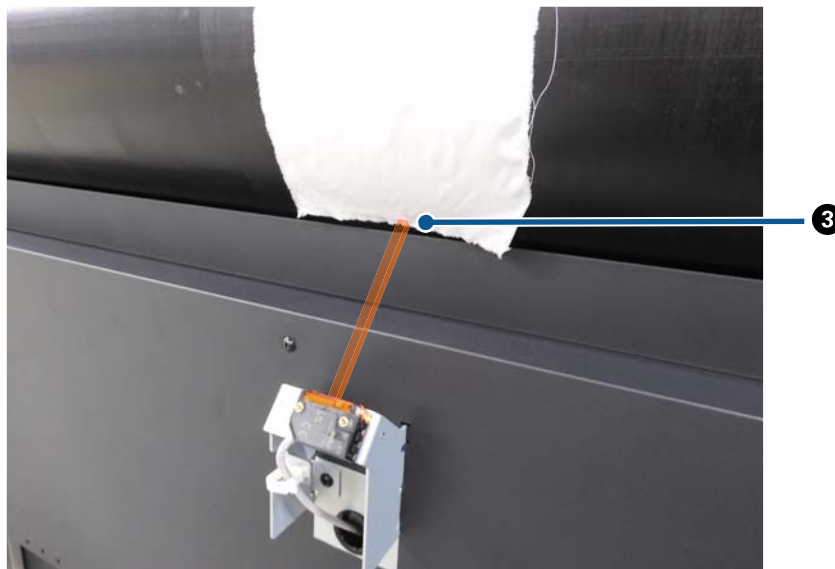
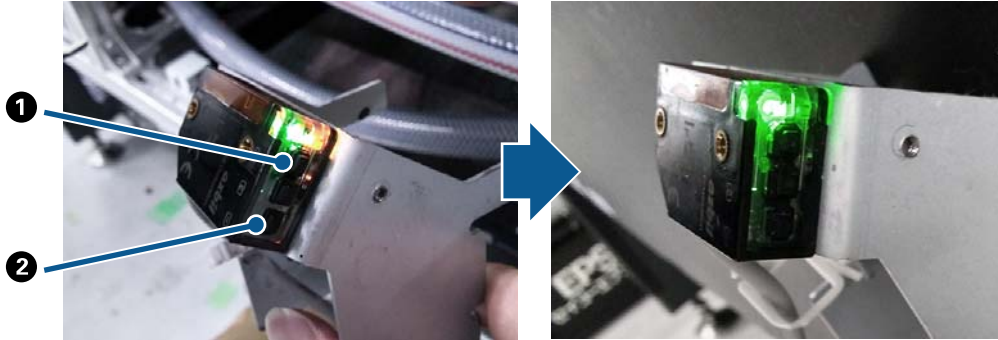


- ① + key
- ② - key

Basic Operations

When the sensor reacts

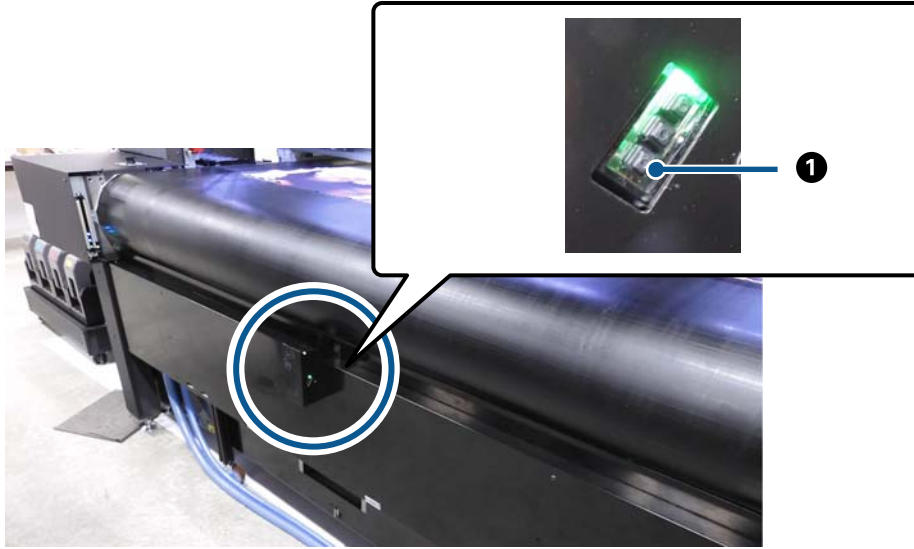
- 1 Press the + key until the sensor reacts and the light turns orange, and then press the - key to move the sensor away from the belt. If the sensor is too far away, press the + key to move it closer.



- 1 + key
- 2 - key
- 3 Sensor reaction position

Basic Operations

- 2** Press the - key three times.



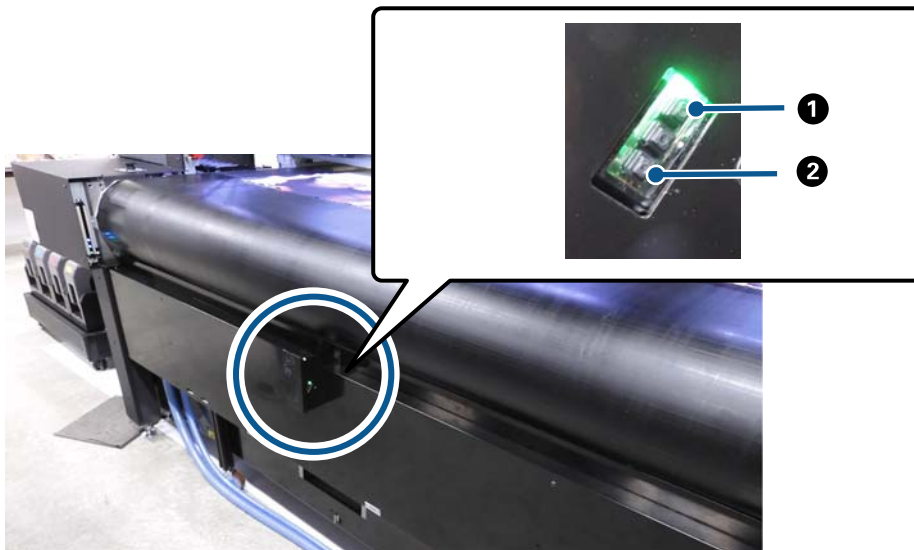
1 - key

- 3** Check the sensor adjustment results for any problems.

Press the feed button on the front panel to rotate the belt.
When the sensor reacts, the sensor light turns orange and the belt stops.
When the sensor reacts, repeat steps 1 to 3 to make adjustments.

- 4** Press and hold the + or - key to check the adjustment results.

The light flashes orange three times and the key is locked.



1 + key

2 - key

Basic Operations

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 135](#)

**2. Checking the status of the fabric**

 ["Checking the Status of the Fabric" on page 136](#)

**3. Loading the fabric**

 ["Loading the Fabric" on page 136](#)

**4. Setting the foreign material detection sensor**

 ["Setting the foreign material detection sensor" on page 144](#)

Basic Operations



5. Making print adjustments

["Print Adjustments" on page 144](#)



6. Making fabric information settings

["Fabric Information Settings" on page 146](#)



7. Setting the print start position

["Setting the Print Start Position" on page 146](#)



8. Executing printing

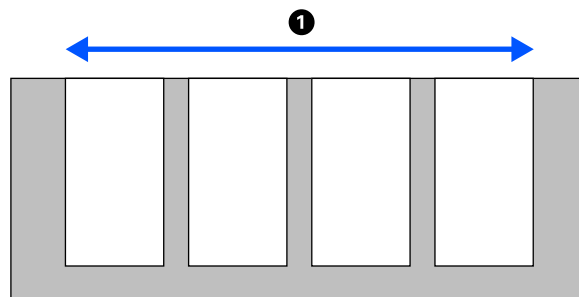
["Executing Printing" on page 146](#)

See the following for more information about each procedure.

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.

Basic Operations


Checking the Status of the Fabric

See the following for more information.

 [“Checking the Status of the Fabric” on page 77](#)

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.



- 3 Hold the center of the pressure roller and move it to a position near the feeding unit.



Important:

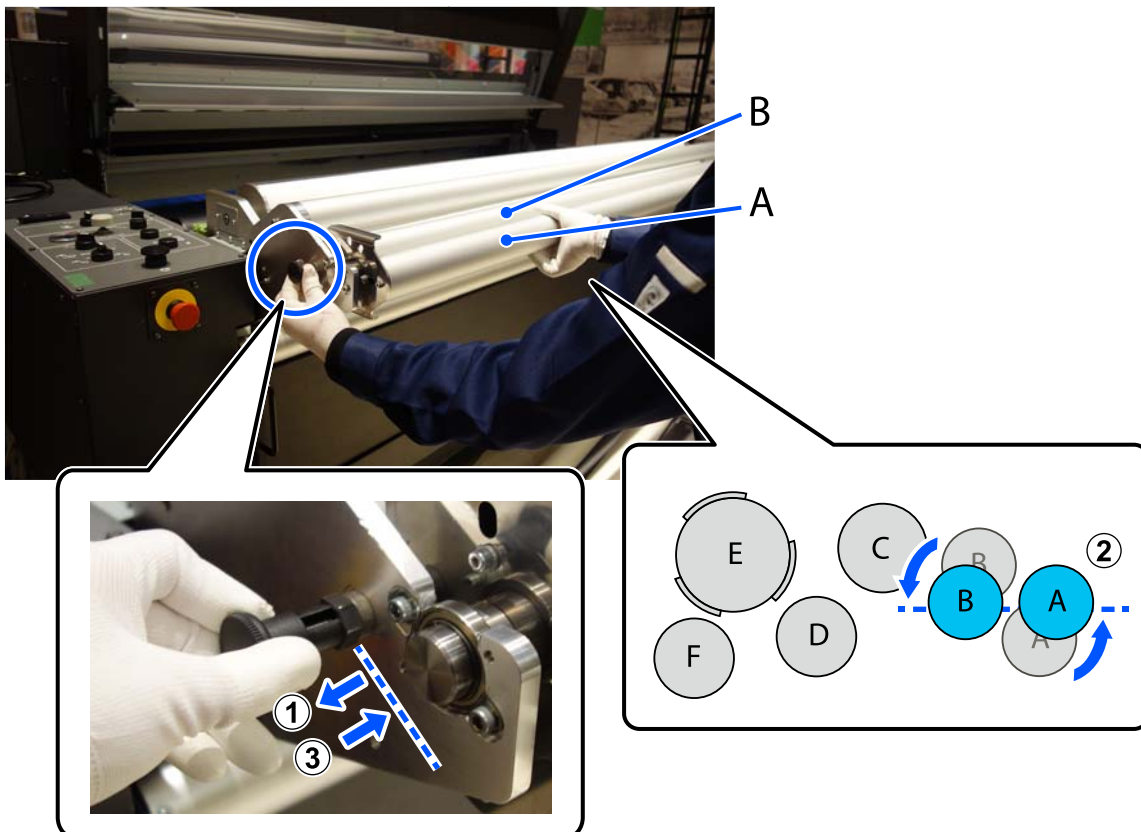
Do not move the pressure roller with too much force or by holding it at the edges. Doing so may cause the printer to malfunction.

Basic Operations



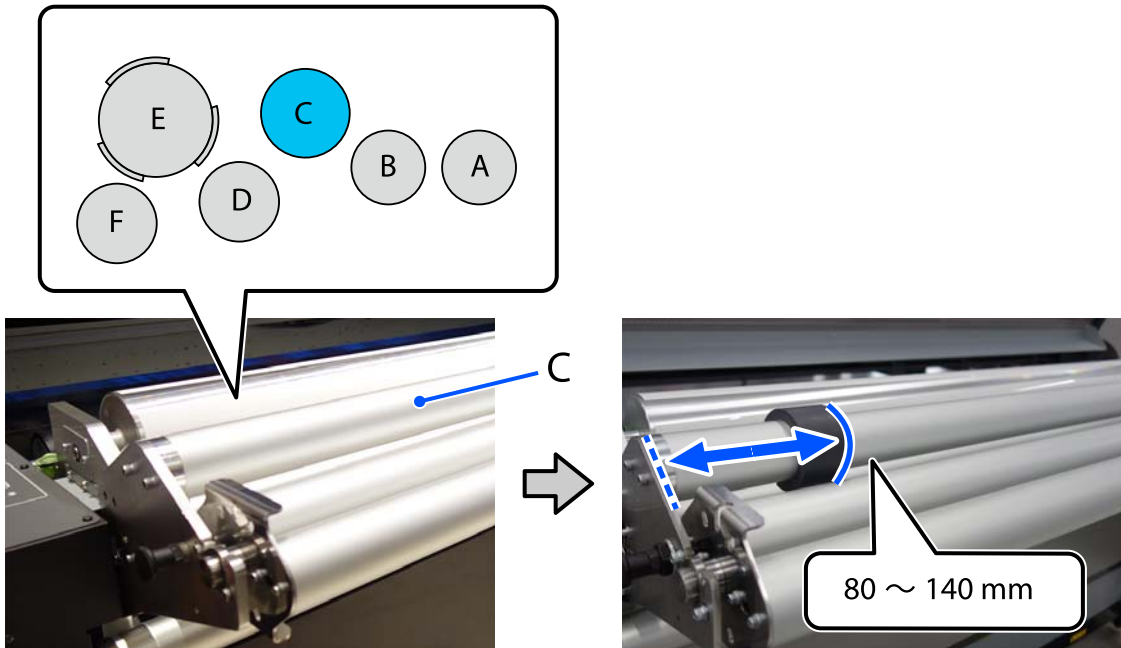
- 4 While pulling the lock lever for the high tension feeding unit, make rollers A and B even. Return the lock lever to lock rollers A and B.

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

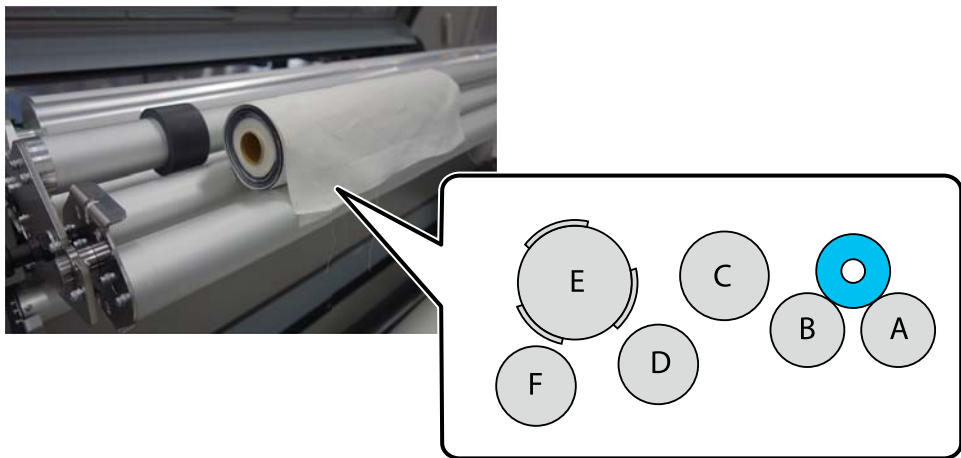


Basic Operations

- 5** 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.

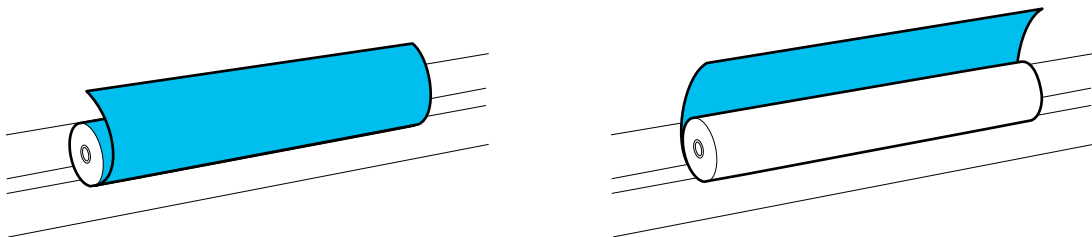


- 6** Place the fabric roll between rollers A and B. The method for loading the fabric roll varies depending on the print surface.



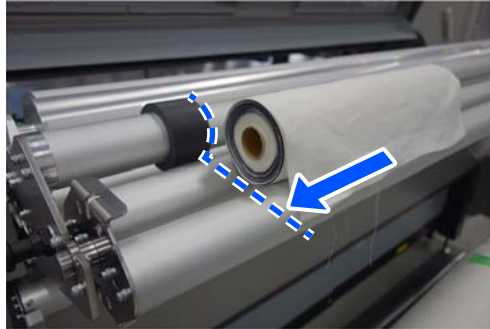
Print surface out

Print surface in



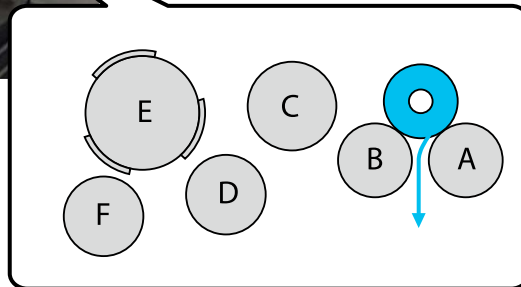
Basic Operations

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

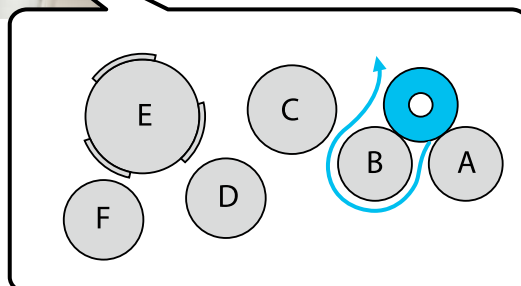


- 8** Feed the fabric through the rollers.

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

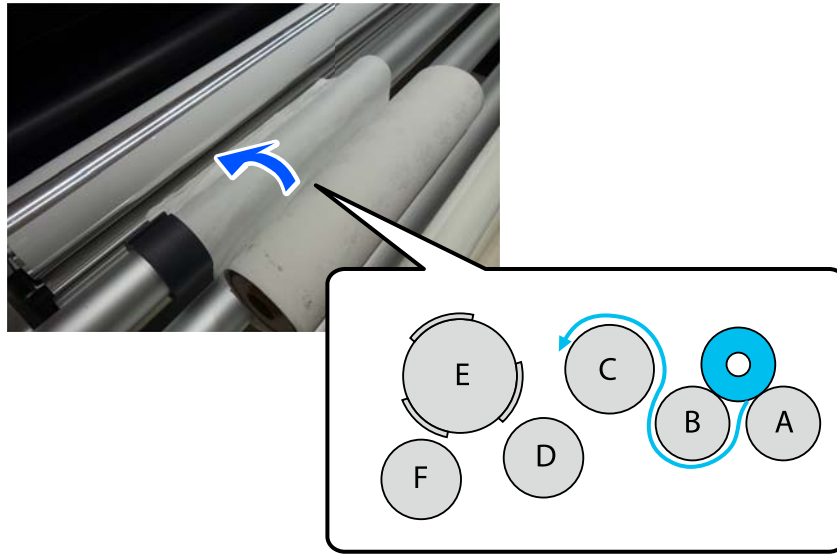


- ② Feed the fabric between rollers B and C.

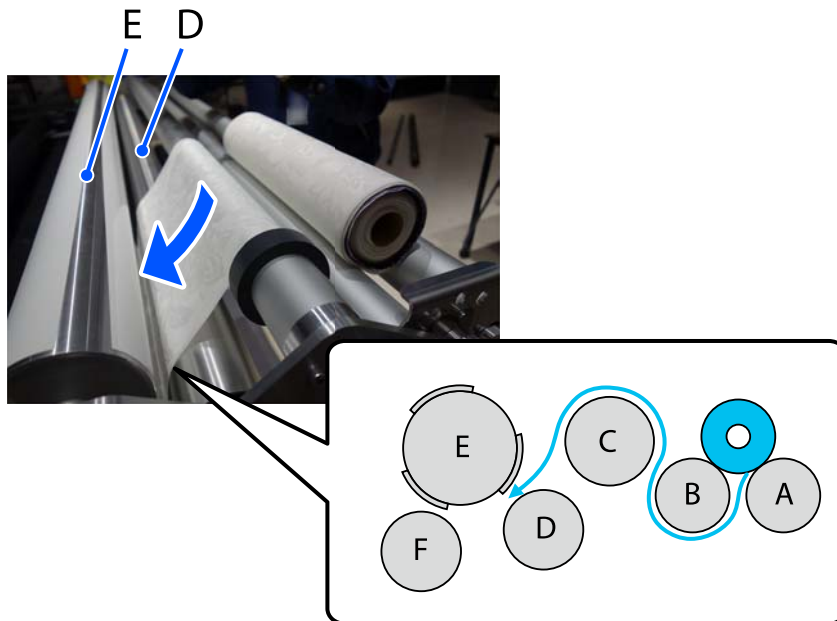


Basic Operations

- ③ Feed the fabric over roller C.

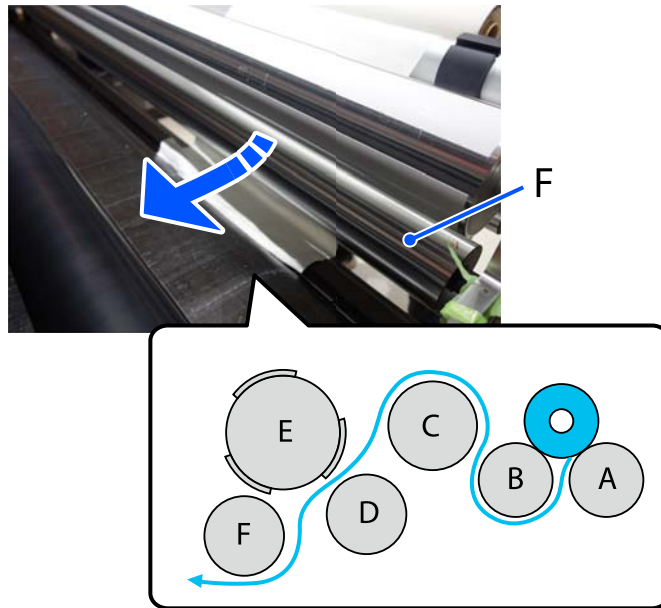


- ④ Feed the fabric between roller D and tension roller E.

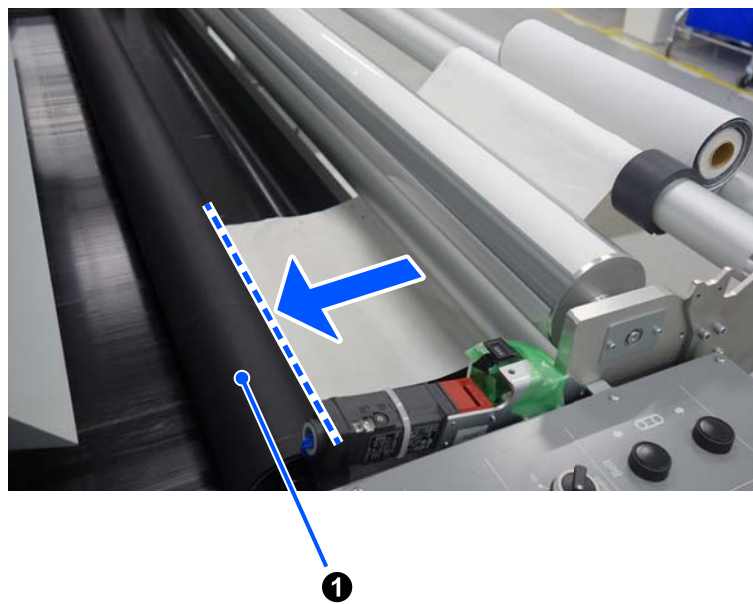


Basic Operations

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



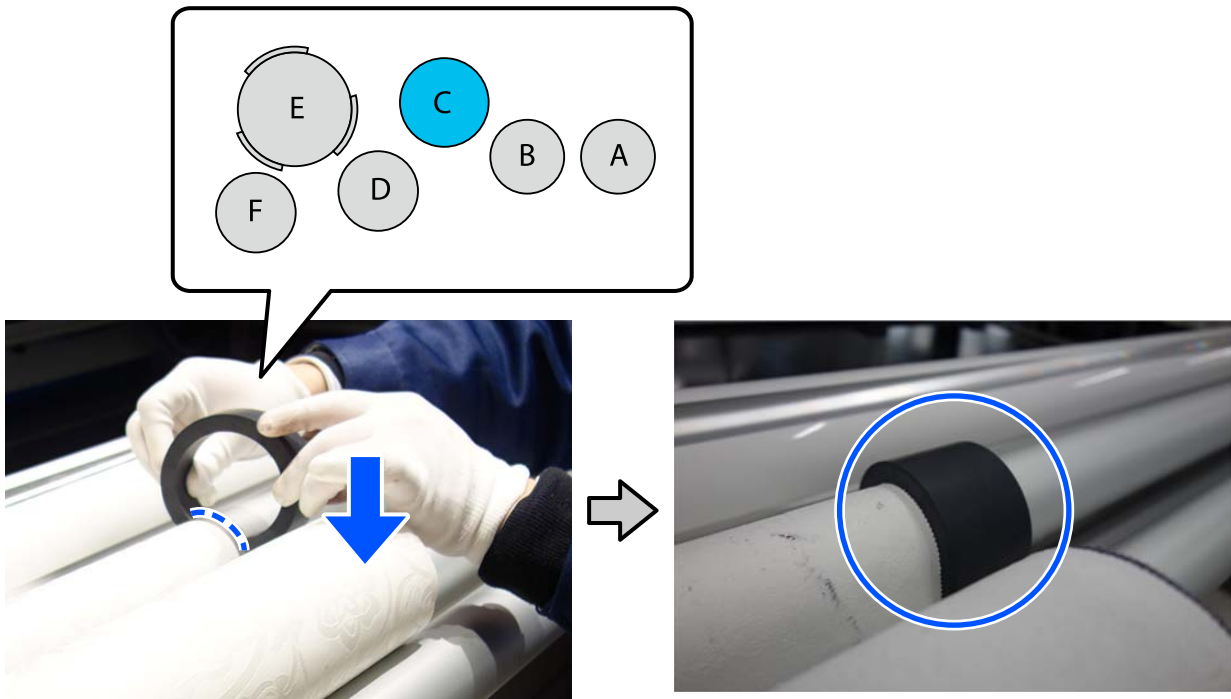
- 9 Pull the fabric out to the front of the pressure roller (①).




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

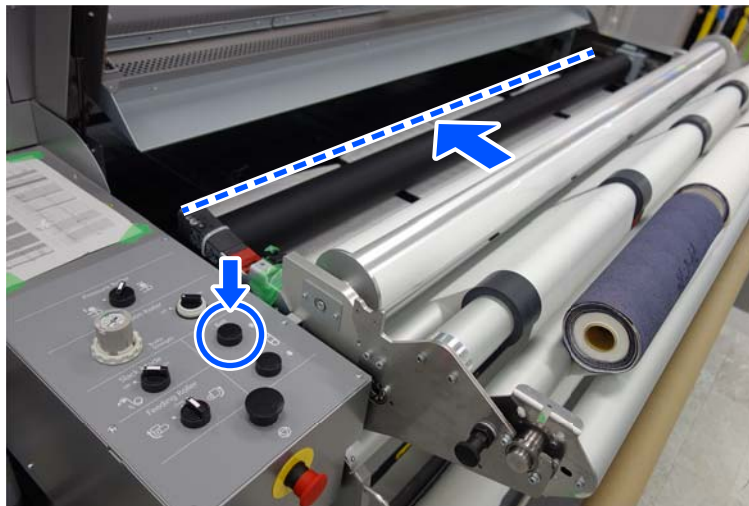
Basic Operations

- 11** 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.



- 12** See steps 7 to 11 when loading multiple pieces of fabric.
When all pieces of fabric are loaded, go to step 12.

- 13** Press the feed button on the rear panel ( in Belt) to feed the fabric to the position shown in the photo.



Basic Operations

- 14 Close the rear cover.



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

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



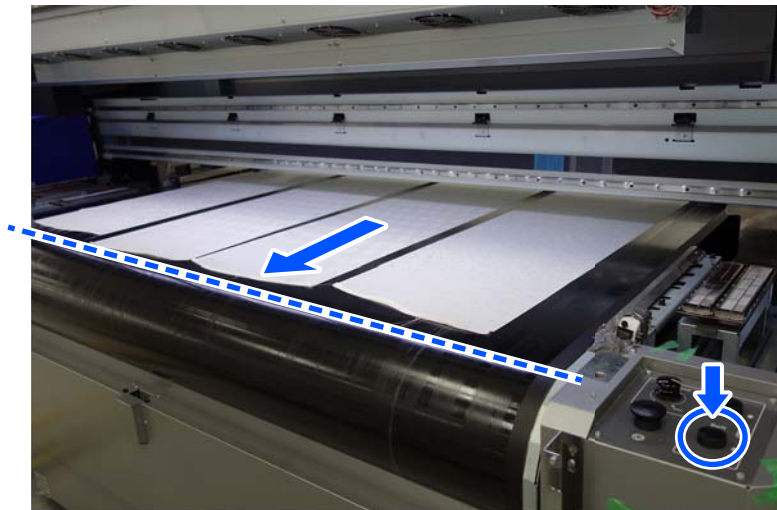
- 16 Press the feed button on the front panel (↓ in Belt) to feed the fabric to the front of the printer using the position shown in the photo as a guide.



Important:

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

Basic Operations



- 17 Peel the tip of the fabric from the belt.
Make sure the fabric does not get caught in the belt cleaning tank.
- 18 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.
- 19 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 foreign material detection sensor

See the following for more information.

 [“Setting the Foreign Material Detection Sensor” on page 98](#)

Print Adjustments

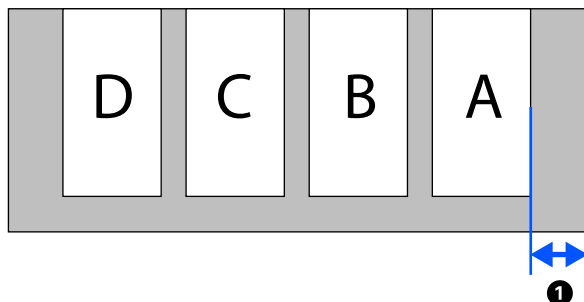
In the following situations, make print adjustments before printing.

- Using new fabric not registered to the printer
- When banding (horizontal banding, tint unevenness, or stripes) or graininess is detected in print results
- When the fabric width is different
- When the fabric thickness or head height is changed

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

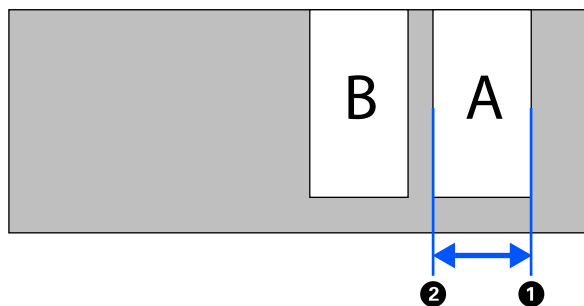
Basic Operations

- 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.

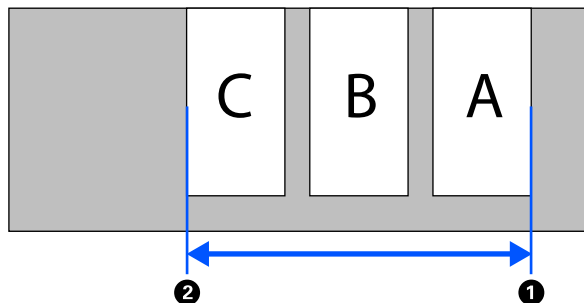


- 2 Measure the distance from the print start position (①) to (②) according to the method for measuring the print width for the number of pieces of fabric loaded.

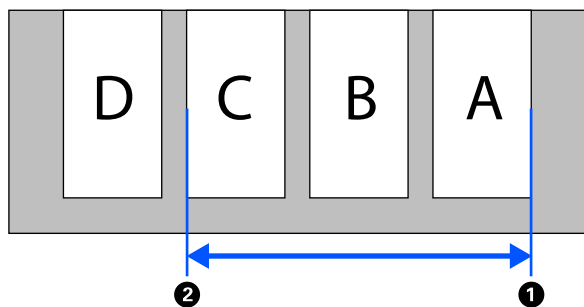
When loading two pieces of fabric




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 110](#)

 [Print Head Alignment: “Manual” on page 111](#)

 [Fabric Feed Adjustment: “Manual” on page 113](#)

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

 [“General Settings Menu” on page 415](#)

Fabric Information Settings

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.

 [“Fabric Information Settings” on page 100](#)

Setting the Print Start Position

See the following for more information.

 [“Setting the Print Start Position” on page 101](#)

Executing Printing

See the following for more information.

 [“Executing Printing” on page 103](#)

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.

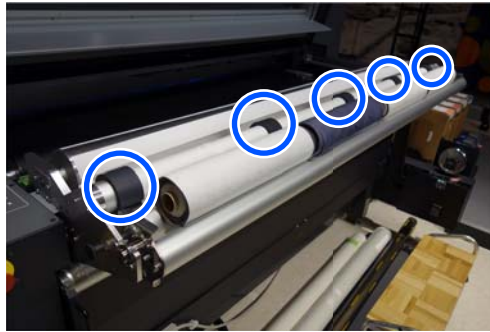
Required Items	25 mm wide rubber bands (max. 8), curing tape or cable ties (max. 8)
----------------	----------------------------------------------------------------------

1 Press the **Pause** button on the control panel.

Stops printing.

Basic Operations

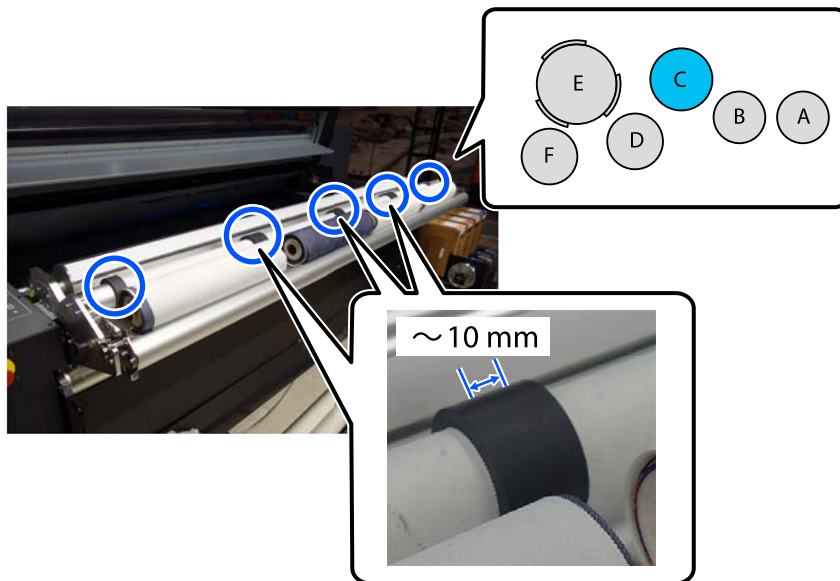
- 2 Remove all 50 mm wide rubber bands attached to the high tension feeding unit.



- 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.



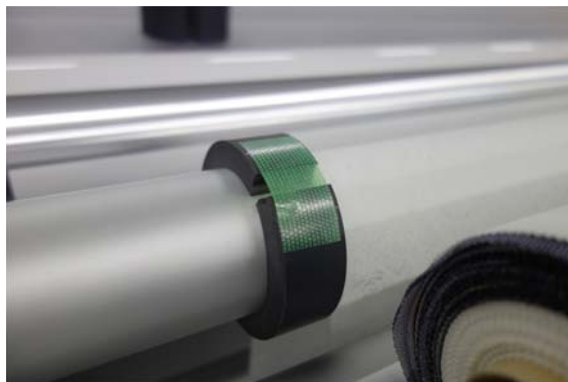
- 5 Secure the rubber bands to the roller.

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

When using curing 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 148](#)

- ❑ 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 160](#)

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 150](#)



2. Loading the fabric

 ["Loading the Fabric" on page 150](#)



3. Setting the foreign material detection sensor

 ["Setting the Foreign Material Detection Sensor" on page 159](#)



4. Making print adjustments

 ["Print Adjustments" on page 159](#)



5. Making fabric information settings

 ["Fabric Information Settings" on page 159](#)



6. Setting the print start position

 ["Setting the Print Start Position" on page 159](#)



7. Executing printing

 ["Executing Printing" on page 159](#)

See the following for more information about each procedure.

Basic Operations


Checking the Status of the Fabric

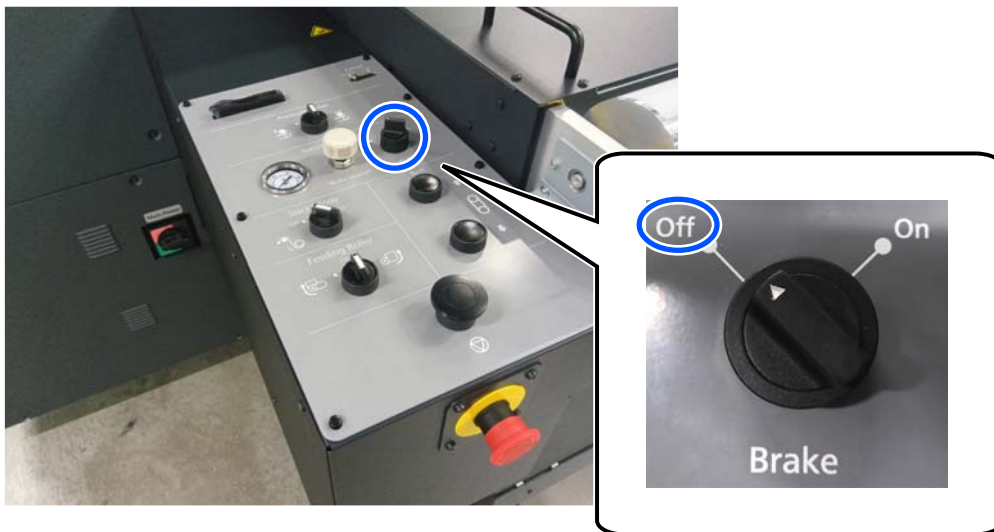
See the following for more information.

 [“Checking the Status of the Fabric” on page 77](#)

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.



Basic Operations

- 4 Hold the center of the pressure roller and move it to a position near the feeding unit.




Important:

Do not move the pressure roller with too much force or by holding it at the edges. Doing so may cause the printer to malfunction.



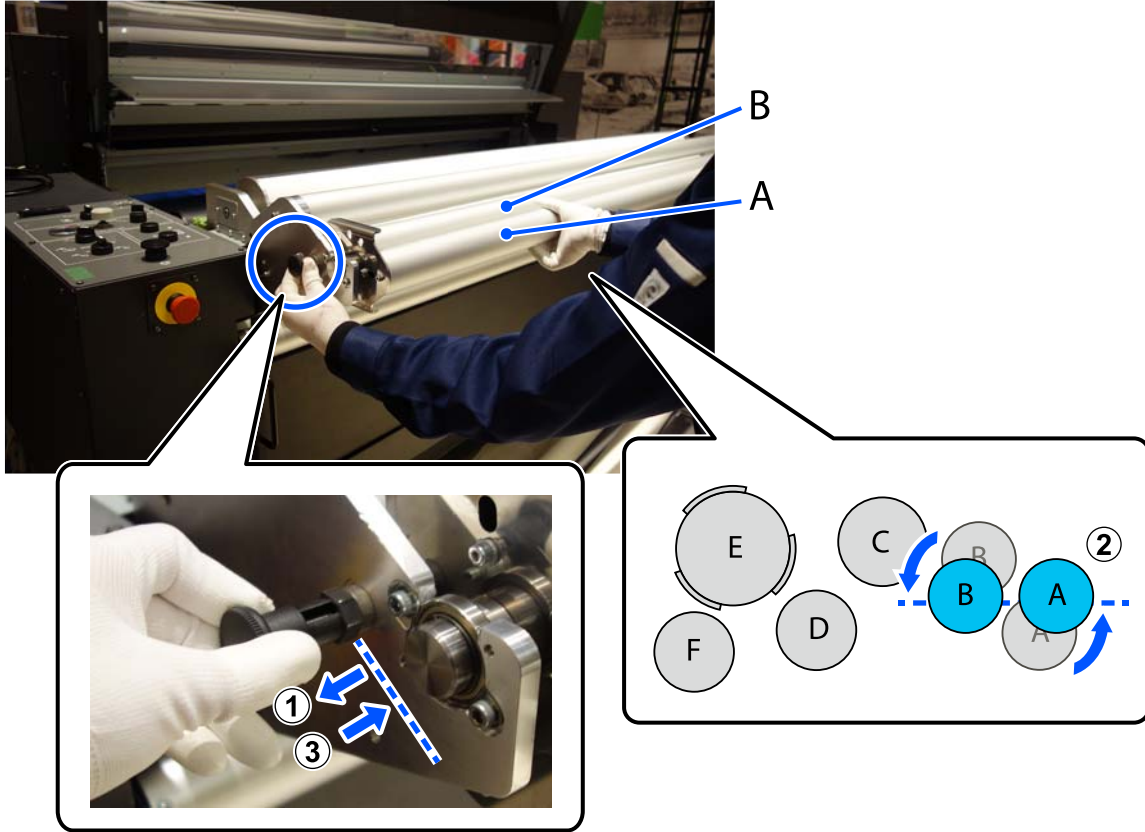
- 5 Attach the fabric roll to the feeding spindle.

 [“Removing and attaching the feeding spindle” on page 80](#)

Basic Operations

- 6** 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.

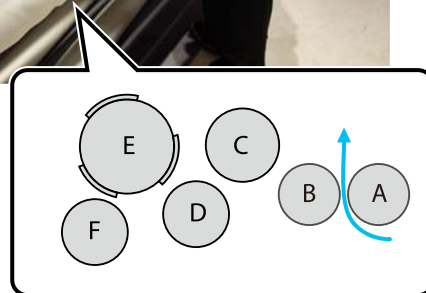
If rollers A and B do not lock, pull and turn the lock lever to lock them.



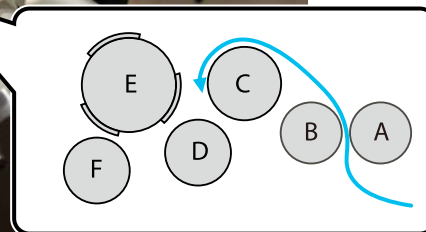
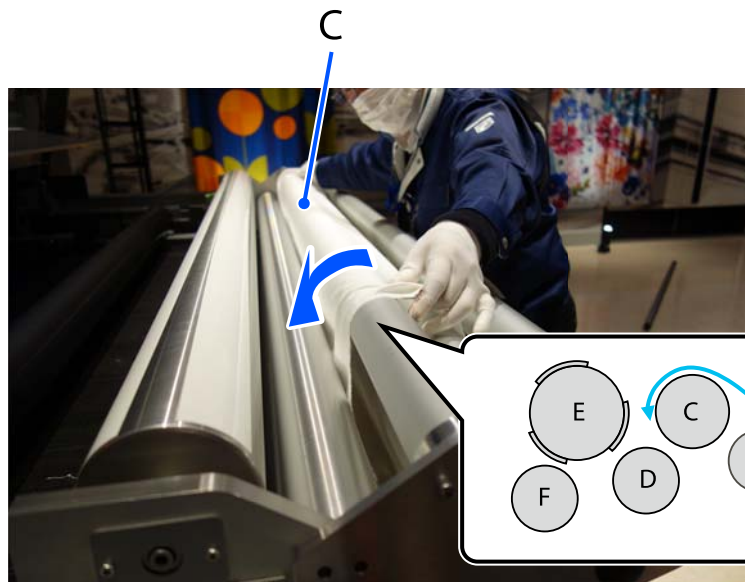
Basic Operations

7 Feed the fabric through the rollers.

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

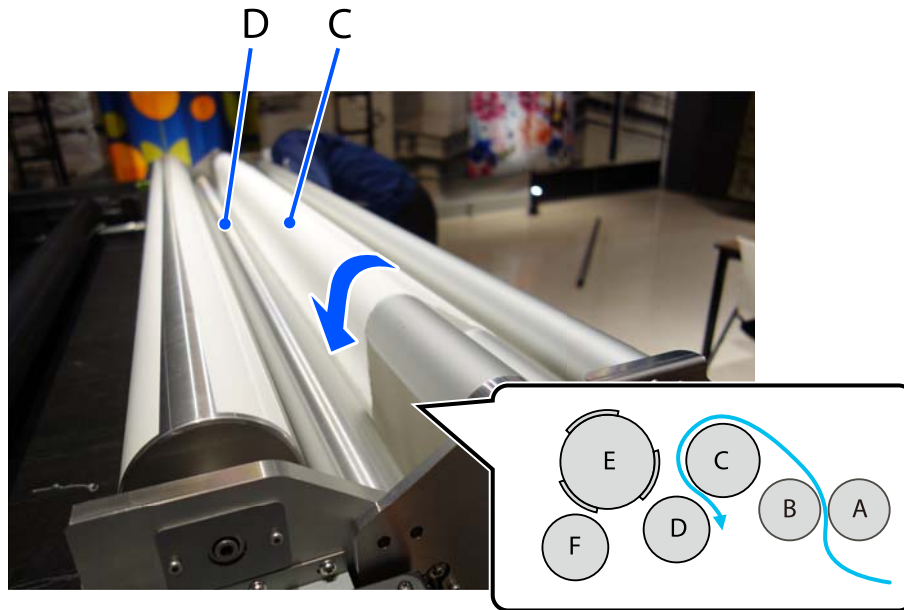


② Feed the fabric over roller C.

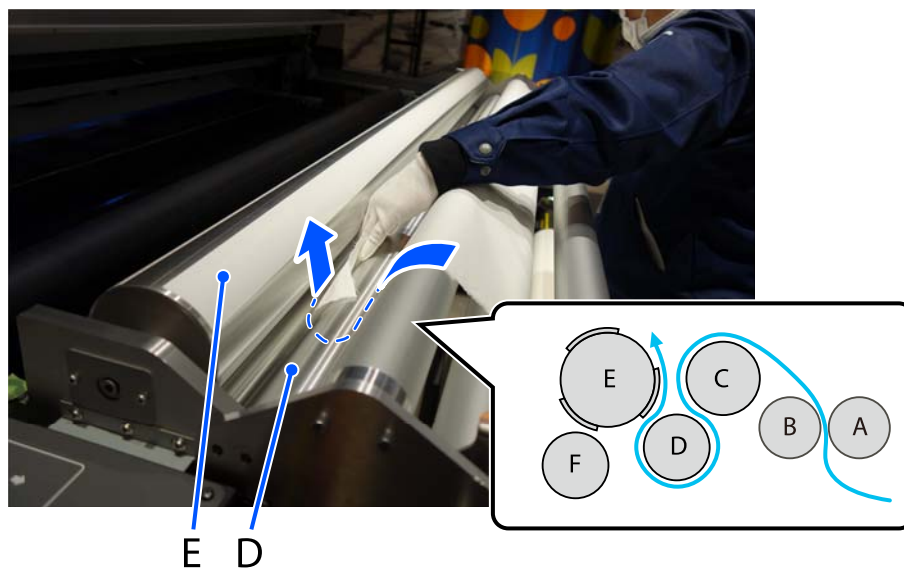


Basic Operations

- ③ Feed the fabric between C and D.

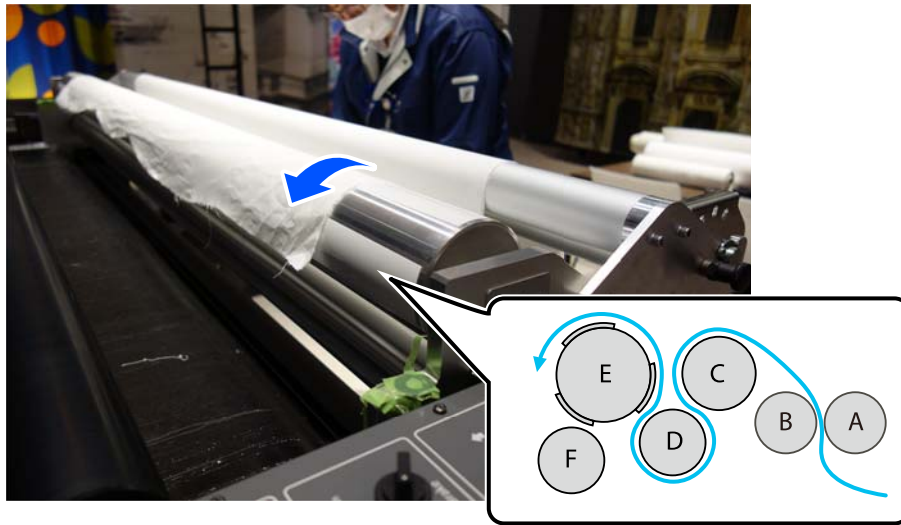


- ④ Feed the fabric between roller D and tension roller E from below.

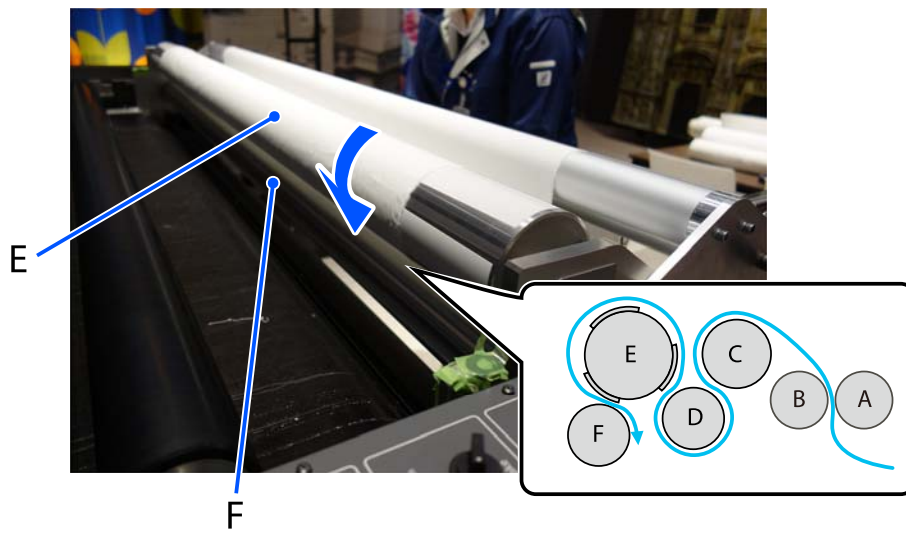


Basic Operations

- ⑤ Feed the fabric over tension roller E.

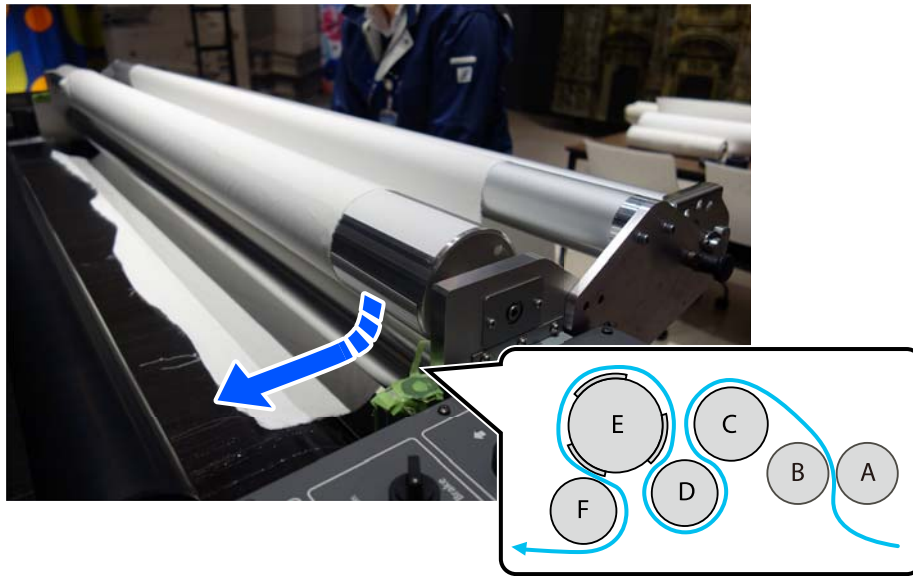


- ⑥ Feed the fabric between tension roller E and roller F.



Basic Operations

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



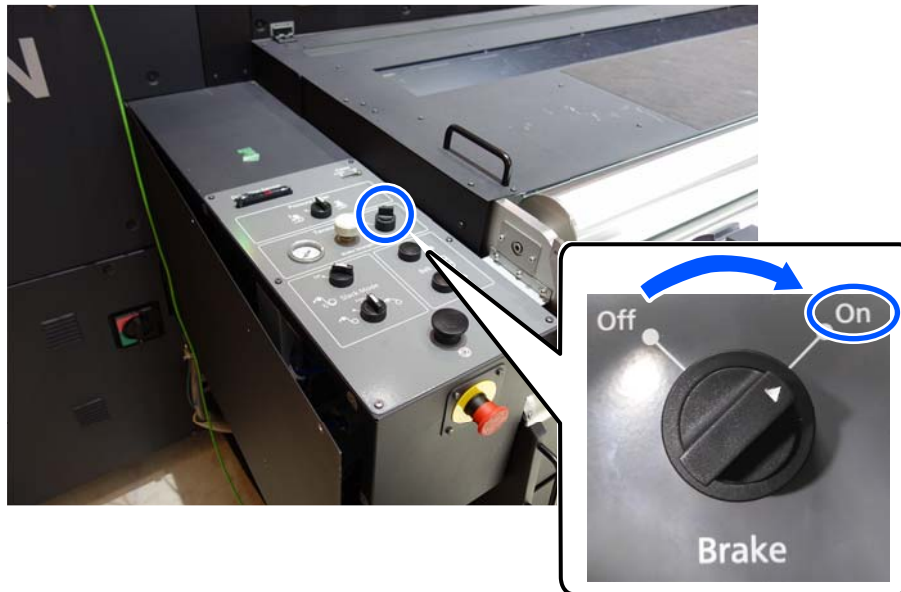
- ⑧ Pull the fabric out to the front of the pressure roller (①).



Basic Operations

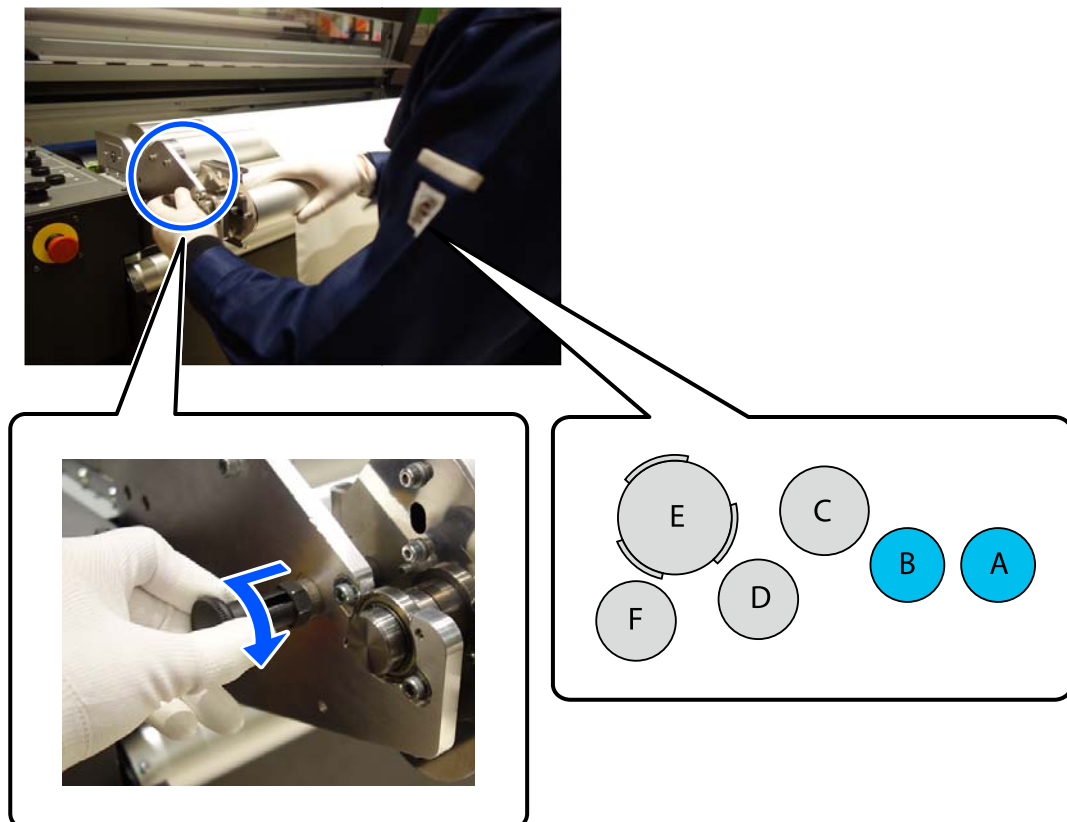
- ⑨ Set the tension switch on the rear panel to On (right).

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



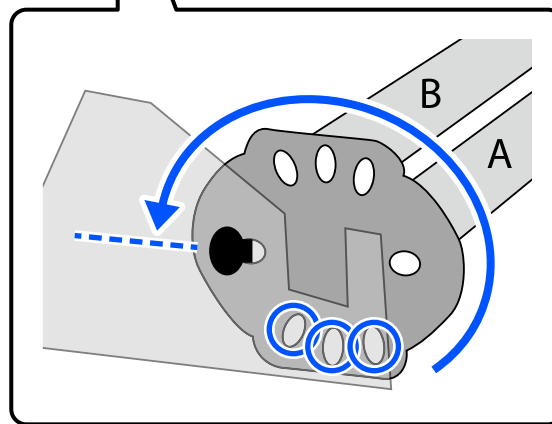
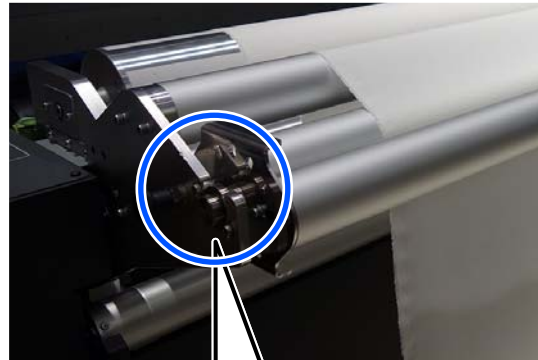
- 8 Adjust the tension applied to the fabric.

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

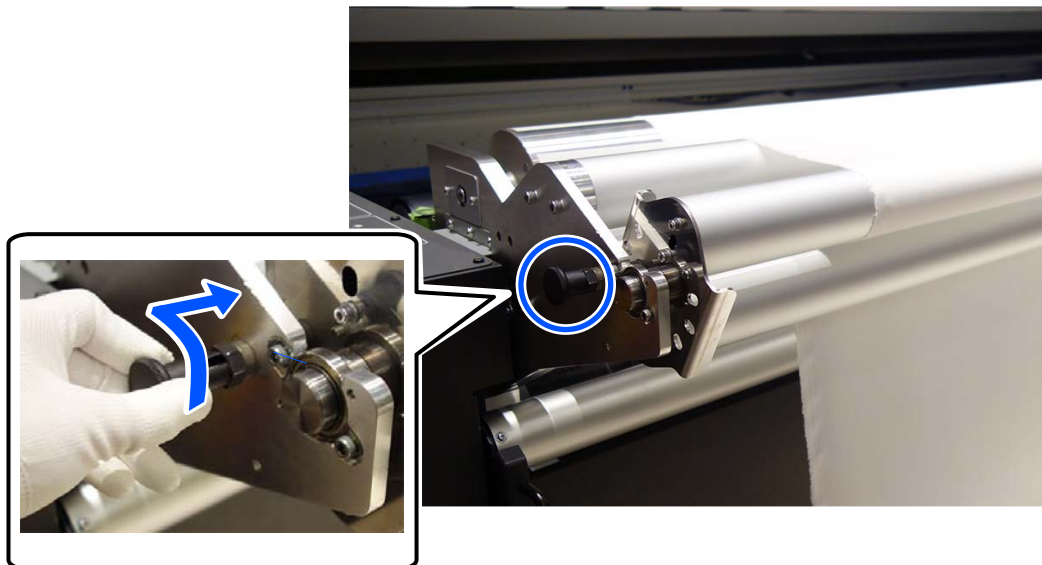


Basic Operations

- 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.



Basic Operations

- 9** 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 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 switch to the center to unlock it.

- 10** For the rest of the procedure, start from step 3 below.

 [“When applying tension to the fabric/When the fabric is less than 1 mm thick” on page 87](#)

Setting the Foreign Material Detection Sensor

See the following for more information.

 [“Setting the Foreign Material Detection Sensor” on page 98](#)

Print Adjustments

In the following situations, make print adjustments before printing.

- Using new fabric not registered to the printer
- When banding (horizontal banding, tint unevenness, or stripes) or graininess is detected in print results
- When the fabric width is different
- When the fabric thickness or head height is changed

See the following for more information.

 [“Print Adjustments” on page 109](#)

Fabric Information Settings

See the following for more information.

 [“Fabric Information Settings” on page 100](#)

Setting the Print Start Position

See the following for more information.

 [“Setting the Print Start Position” on page 101](#)

Executing Printing

See the following for more information.

 [“Executing Printing” on page 103](#)

Basic Operations

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
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 161](#)



2. Loading the fabric

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



3. Setting the foreign material detection sensor

 ["Setting the foreign material detection sensor" on page 170](#)



4. Making print adjustments

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



5. Making fabric information settings

 ["Fabric Information Settings" on page 170](#)

Basic Operations



6. Setting the print start position

["Setting the Print Start Position" on page 170](#)



7. Executing printing

["Executing Printing" on page 170](#)

See the following for more information about each procedure.

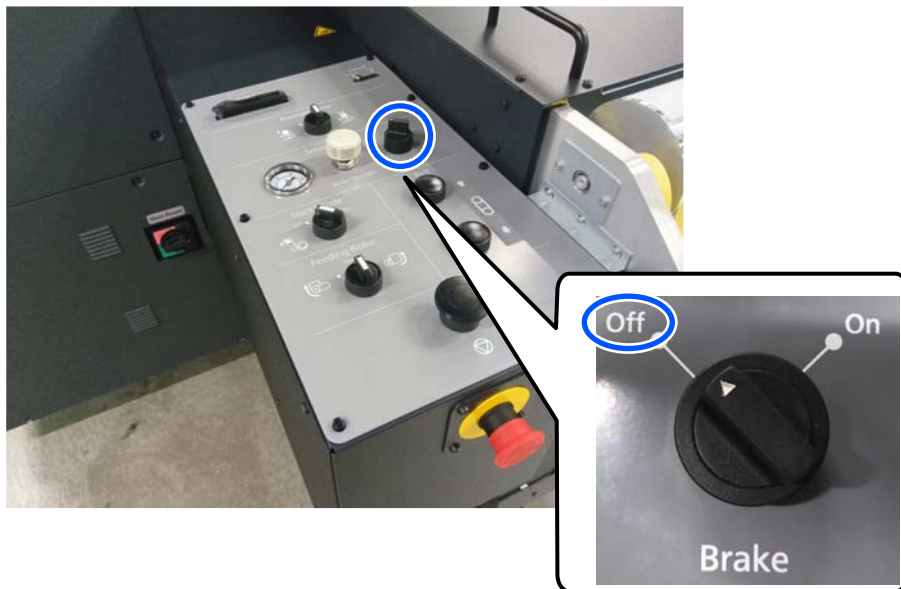
Checking the Status of the Fabric

See the following for more information.

["Checking the Status of the Fabric" on page 77](#)

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.



Basic Operations

- 3 Open the rear cover.



- 4 Hold the center of the pressure roller and move it to a position near the feeding unit.

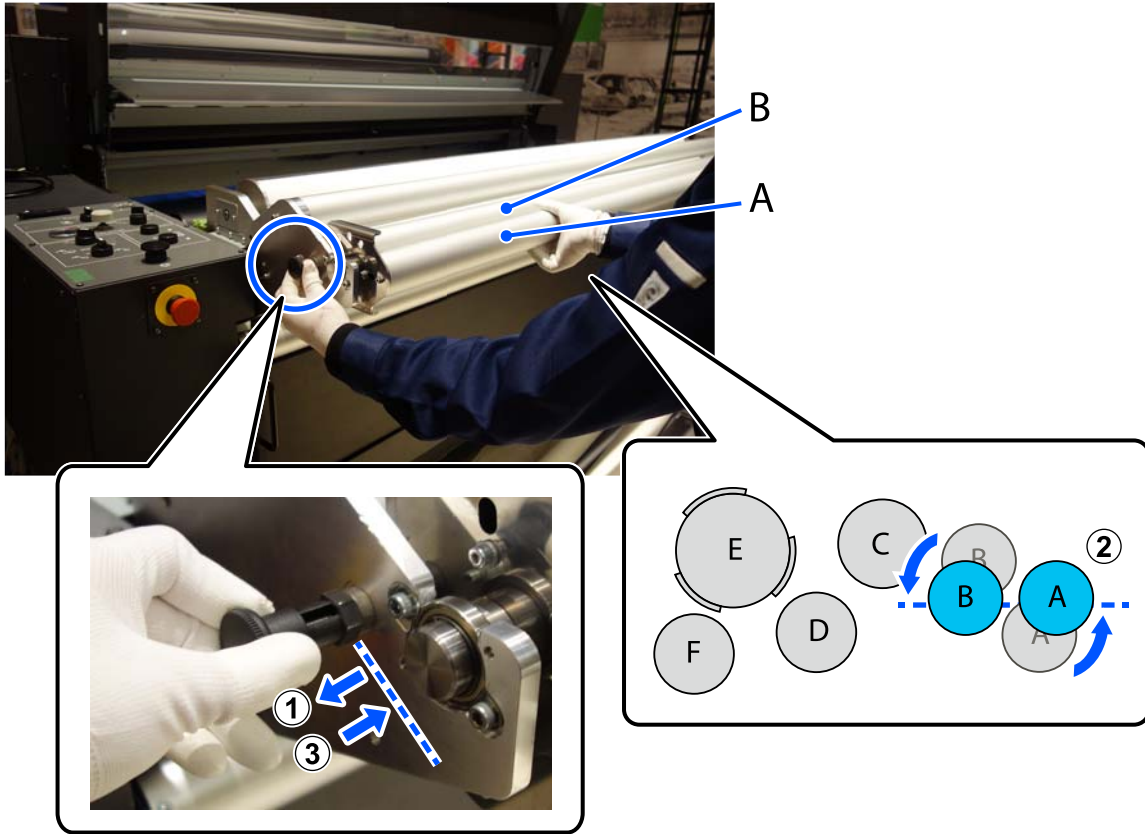
! **Important:**
Do not move the pressure roller with too much force or by holding it at the edges. Doing so may cause the printer to malfunction.



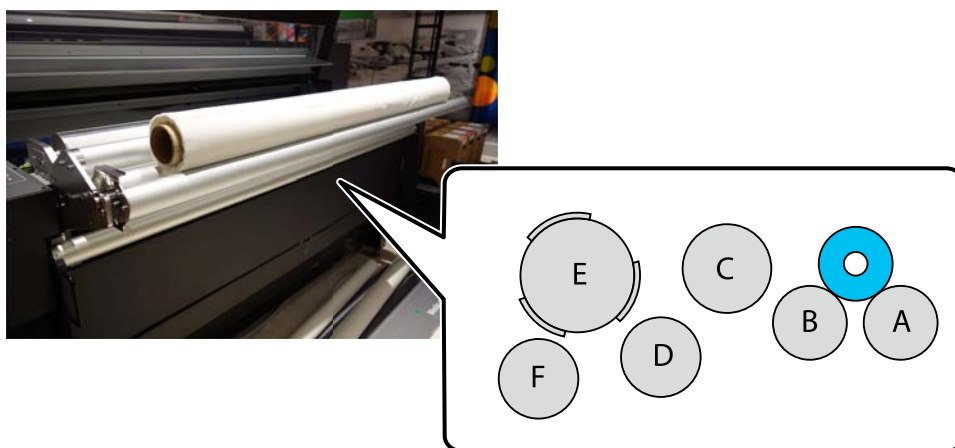
Basic Operations

- 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.



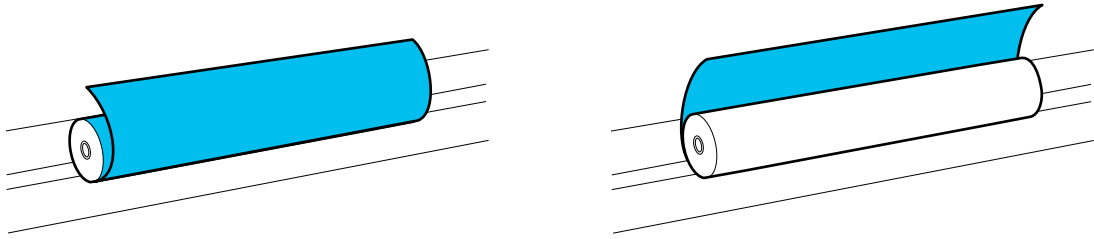
- 6** Place the fabric roll between rollers A and B. The method for loading the fabric roll varies depending on the print surface.



Print surface out

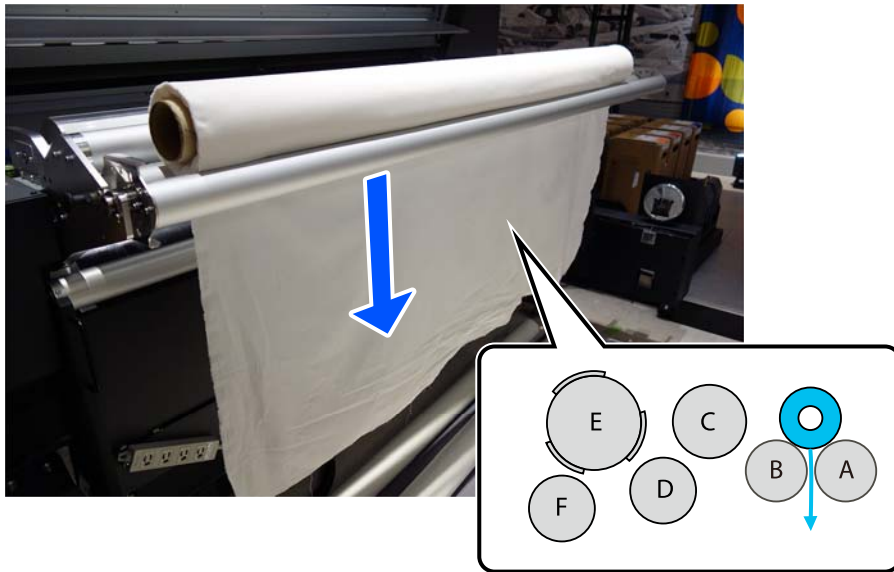
Print surface in

Basic Operations



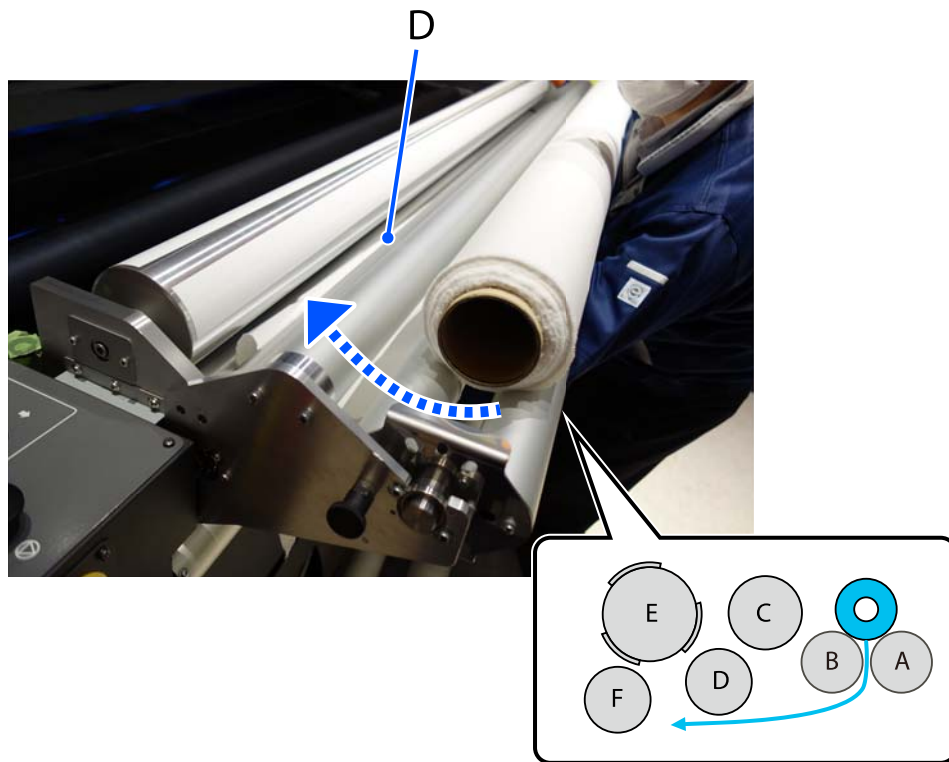
7 Feed the fabric through the rollers.

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

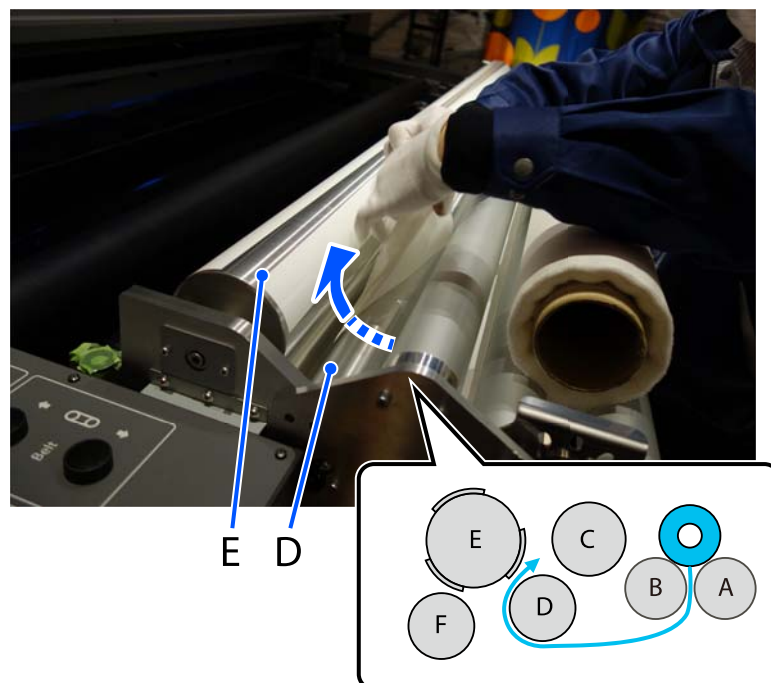


Basic Operations

- ② Feed the fabric under roller D.

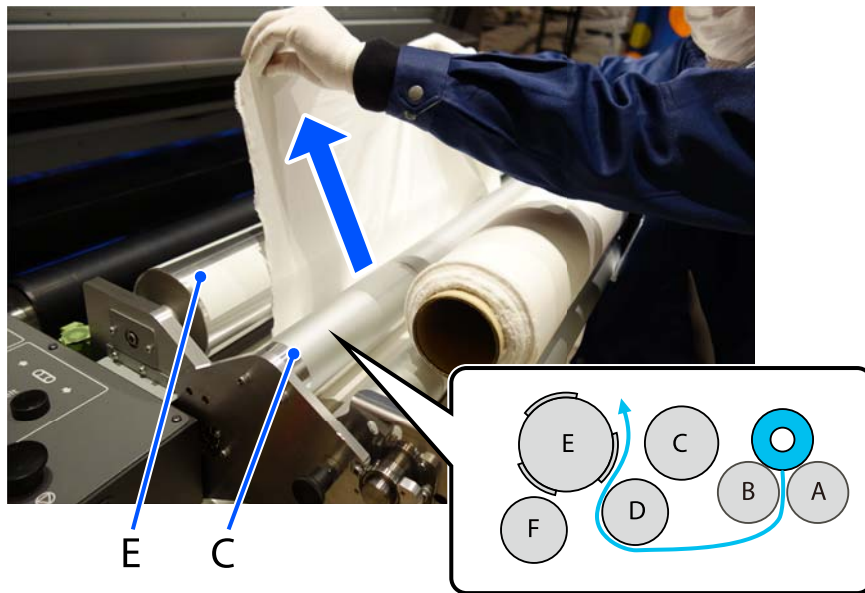


- ③ Feed the fabric between roller D and tension roller E.

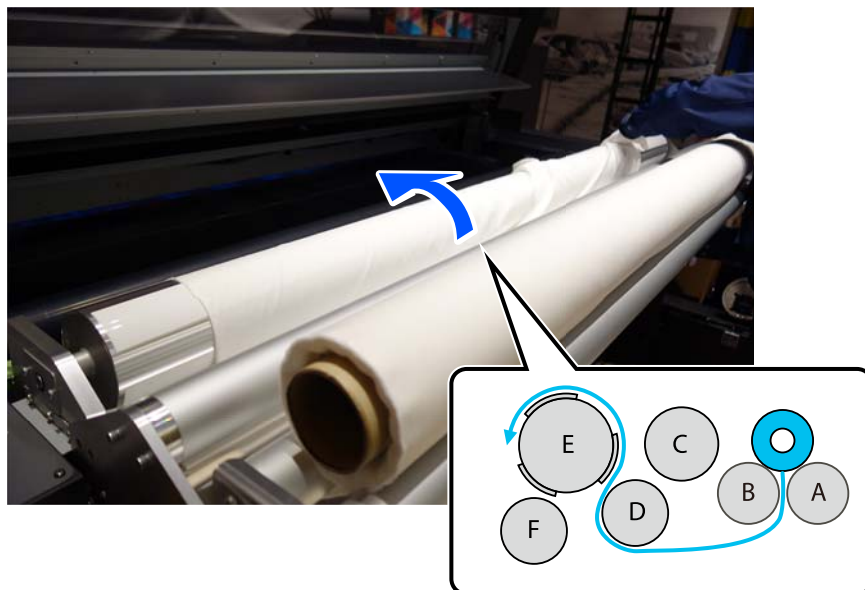


Basic Operations

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

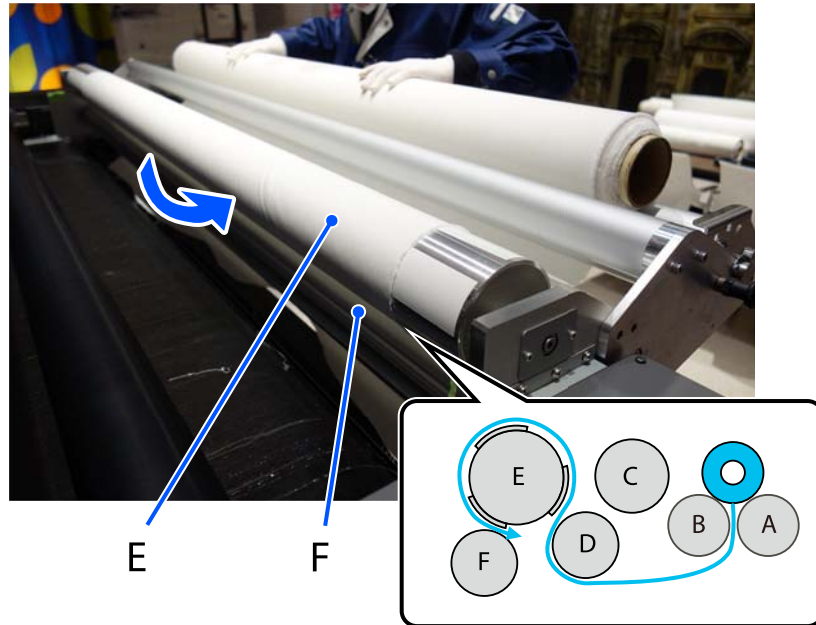


- ⑤ Feed the fabric over tension roller E.

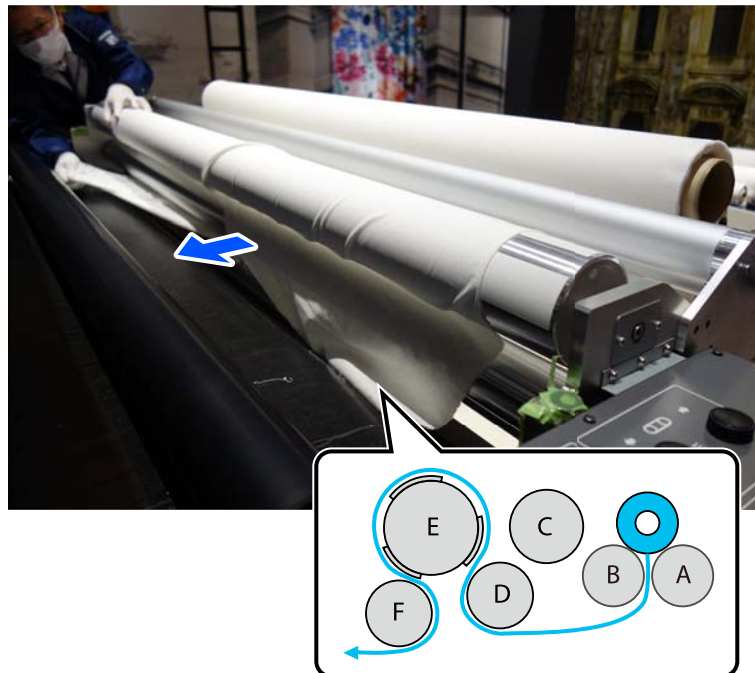


Basic Operations

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



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



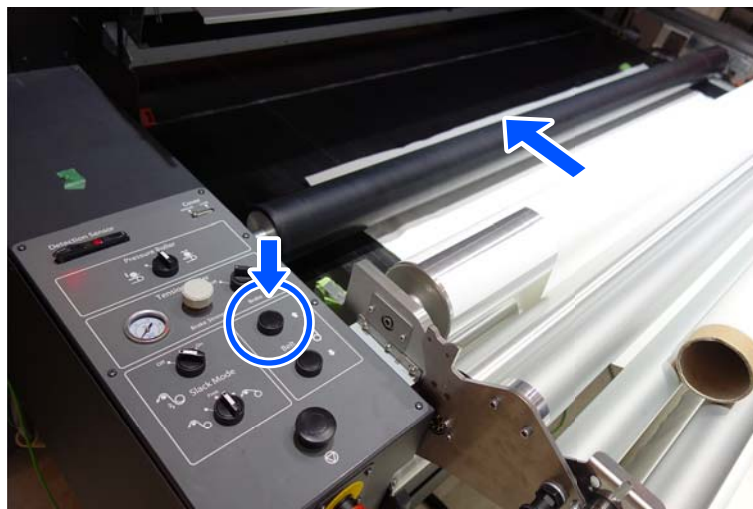
Basic Operations

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



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

- 9 Press the feed button on the rear panel (↑ in Belt) to feed the fabric to the position shown in the photo.



Basic Operations

- 10 Close the rear cover.



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

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



Basic Operations

12

Press the feed button on the front panel (↓ in Belt) to feed the fabric to the print start position.



Setting the foreign material detection sensor

See the following for more information.

[☞ “Setting the Foreign Material Detection Sensor” on page 98](#)

Print Adjustments

In the following situations, make print adjustments before printing.

- Using new fabric not registered to the printer
- When banding (horizontal banding, tint unevenness, or stripes) or graininess is detected in print results
- When the fabric width is different
- When the fabric thickness or head height is changed

See the following for more information.

[☞ “Print Adjustments” on page 109](#)

Fabric Information Settings

See the following for more information.

[☞ “Fabric Information Settings” on page 100](#)

Setting the Print Start Position

See the following for more information.

[☞ “Setting the Print Start Position” on page 101](#)

Executing Printing

See the following for more information.

Basic Operations

 [“Executing Printing” on page 103](#)

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	Ink type				Frequency			Timing
	Pigment	Reactive	Acid	Dispersion	Everyday	Every week	Every month	
Checking the Area Around Operating Parts	✓	✓	✓	✓	✓			Before turning on the power
Cleaning the Area Around Operating Parts	✓	✓	✓	✓	✓			Before turning on the power
Checking for Water Leaks in the Pipe Joints	✓	✓	✓	✓	✓			Before turning on the power
Checking the Air Pressure	✓	✓	✓	✓	✓			Before turning on the power
Cleaning the Sensors	✓	✓	✓	✓	✓			After turning on the power
Checking the Operation of the Emergency Stop Equipment	✓	✓	✓	✓	✓			After turning on the power
Checking the Air Supply Regulator Water Level	✓	✓	✓	✓	✓			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

Maintenance

Item	Ink type				Frequency			Timing
	Pigment	Reactive	Acid	Dispersion	Everyday	Every week	Every month	
Inspecting the Washing Scraper (Washing Scraper 2 only)	✓	✓	✓	✓	✓			After printing ends
Sponge roller for drying (ML-8000U only)	✓	✓	✓	✓	✓			After printing ends
Inspecting/ Cleaning the Ink Path	✓				✓		✓ Cleaning	After printing ends Cleaning frequency: Once a month
Cleaning the Caps	✓	✓	✓	✓		✓		Before starting printing
Cleaning the Belt Cleaning Brushes and the Area Around Them	✓	✓	✓	✓		✓*		After printing ends
Inspecting/ Cleaning the Suction Caps	✓	✓	✓	✓			✓	Before head cleaning
Cleaning and Replacing the Mist Filter	✓	✓	✓	✓		✓		Before turning on the power Replacement frequency: Once every 3.5 years
Cleaning and replacing the Blower filter (ML-8000 only)	✓	✓	✓	✓		✓		Before turning on the power Replacement frequency: Once every 2.5 years
Cleaning the Front Cover	✓	✓	✓	✓			✓	Before turning on the power
Cleaning the Inside Light	✓	✓	✓	✓			✓	Before turning on the power

Maintenance

Item	Ink type				Frequency			Timing
	Pigment	Reactive	Acid	Dispersion	Everyday	Every week	Every month	
Inspecting and Applying Tape to the Tension Roller	✓	✓	✓	✓	✓			Before turning on the power

*: Clean once a week or whenever the items on the printer become clogged or covered with lint or debris.


Replacing Consumables

Item	Timing
Replacing the Ink Cartridges	When ink low warning is displayed on the control panel display
Disposing of Waste Ink	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 Flushing Pad	When replacing the wiper roll /When extremely dirty
Replacing the Cleaning Pad	When replacing the wiper roll /When extremely dirty
Replacing the Washing Scraper	<input type="checkbox"/> When the washing scraper is worn down <input type="checkbox"/> When a prepare and replacement message is displayed on the control panel screen
Replacing the Sponge roller (ML-8000U only)	When water droplets remain on the belt even after drying the sponge roller

Other Maintenance

Item	Timing
Periodically Shaking the Ink Cartridges	When a shake message is displayed on the control panel screen
Cleaning the Mist Collection Fan	When a message is displayed on the control panel screen prompting you to clean the mist collection fan
Checking for Clogged Nozzles	When checking if nozzles are clogged When checking which colors are clogged Horizontal stripes or tint unevenness (banding) have appeared
Print Head Cleaning	When a clog is found after checking for clogged nozzles
Manually Capping the Print Head	If capping is not performed for more than 20 minutes
Belt Cleaning Tank Flow Rate Adjustment	When the belt dirt cannot be cleaned and stains the fabric When drainage is insufficient and water overflows
Adding Grease to the Scan Spindle	Adding grease to the scan spindle: Once a month Adding grease to the carriage operating area: When a message prompting you to add grease is displayed on the control panel screen (once a year)


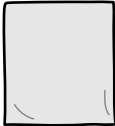
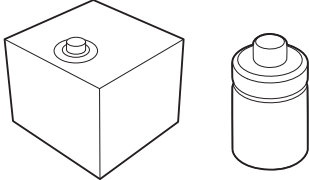
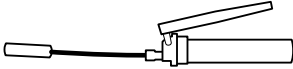
Maintenance

Item	Timing
Adding Grease to the Belt Cleaning Unit	When it is hard to pull out the belt cleaning unit
Applying anti-foaming agent to the belt cleaning unit (only when using acid ink)	Once a week: Before turning on the power
Removing Ink Film (Pigment Inks Only)	When ink sticks to the belt and the adhesive strength decreases about one week after applying the glue
Removing Glue (when using the glue removal tool)	When the fabric attached to the belt rises slightly When there is damage such as peeling of the glue
Removing Glue (when using the glue bucket)	 "Timing for Reapplying the Glue" on page 401
Applying Glue	

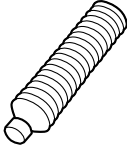
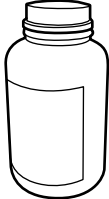



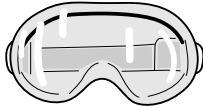
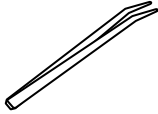
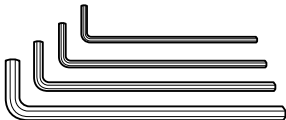
Required Items

Prepare the following items before beginning cleaning and replacement.
When the supplied parts have been completely used, purchase new consumables.
Use genuine parts when replacing ink cartridges or performing maintenance.

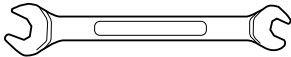
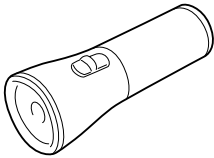

 ["Options and Consumable Products" on page 448](#)

Required Items	Details/Use	
Cleaning stick 	Dedicated consumables/ commercially available items	Use for cleaning caps, suction caps, and the mist collection fan.
Cleaning cloth 	Dedicated consumables/ commercially available items	Use for head cleaning and cleaning inside the front cover. Use material that is not likely to generate lint or static electricity.
Maintenance liquid or cleaning liquid 	Dedicated consumables	This is a dedicated cleaning liquid for removing ink that has adhered to the machine. Do not dilute the liquid.
Grease pump 	Bundled item	Use for adding grease to the scan spindle and the carriage operating area.

Maintenance

Required Items	Details/Use	
Grease (AFA Grease THK) 	Commercially available	Grease added to the scan spindle, the carriage operating area, and the belt cleaning unit operating area.
Anti-foaming agent 	Commercially available	Anti-foaming agent for applying to the belt cleaning unit. This is only necessary when using acid ink.
Brush 	Commercially available	Use when applying anti-foaming agent to the belt cleaning unit. This is only necessary when using acid ink.
Plastic Cup 	Commercially available	Use to contain the maintenance liquid and anti-foaming agent for use during maintenance.
Rubber gloves 	Commercially available	Use during cleaning.
Eye protection 	Commercially available	Use during all types of cleaning. We recommend using eye protection that protects against chemical splashes.
Plastic tweezers 	Commercially available	Use to remove fluffy material and other debris when cleaning caps. We recommend using plastic tweezers.
Hex key 	Commercially available 2.5 mm (0.1 inches) wide	Use to fasten or loosen screws on the machine.

Maintenance

Required Items	Details/Use	
Spanner 	Commercially available Double open end with aperture width of 30 mm (1.18 inches)	Use to fasten or loosen screws on the machine.
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.
Photo paper	Commercially available	Use to print a check pattern after performing a nozzle check or print head cleaning. Use A3 size (297 x 420 mm [11.69 x 16.54 inches]). Prepare a sufficient number of sheets of paper. To save the amount of paper used, set Fabric Width Saving to On and print a check pattern.
Waste ink bottle 	Dedicated consumables	Use when replacing the waste ink bottle.

Precautions Regarding Maintenance

Note the following points when cleaning and replacing parts.





















- Remove the fabric from the printer before proceeding with cleaning.
- 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.





Maintenance





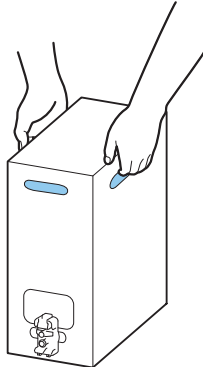




 CAUTION	
    	<p>During maintenance work, wear all of the protective equipment described in the maintenance procedures in the <i>User's Manual</i> (eye protection, protective gloves, respiratory protection, etc.).</p> <ul style="list-style-type: none"> <input type="checkbox"/> Use protective equipment compliant with the safety regulations. <input type="checkbox"/> Using additional protective equipment compliant with the safety regulations is recommended when necessary.
	<p>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.</p>
	<p>Be sure to wear protective gloves when using maintenance liquid.</p>
 	<p>Be sure to wear eye protection and respiratory protection when applying glue. For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.</p>
	<p>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.</p>
	<p>Do not climb on the machine while working on it. Note that the machine is not designed to support the weight and can be easily damaged.</p>
	<p>If waste ink or maintenance liquid gets on the floor, wipe it up with a wipe cloth. Failure to do so could cause an injury due to slipping and falling.</p>
	<p>Make sure that all maintenance work is performed at room temperature.</p>
	<p>When performing maintenance that requires you to move the carriage (when the print head is moved away from the caps), 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.</p> <p>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.</p>

Maintenance




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.
	<p>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.</p>
	<p>Keep ink cartridges, maintenance liquid, carriage spindle grease, waste ink, and glue out of the reach of children.</p>

 CAUTION	
 	<p>When lifting up an ink cartridge, wear safety shoes and place your hands in the positions indicated in the figure below. Lifting with placing the hands on other positions could cause the ink cartridge to fall or pinch your fingers when you lower it, resulting in injury.</p> <p> "Ink supply unit" on page 12</p> <div style="text-align: center;">  </div>
	<p>Do not touch the IC chip on the cartridge.</p>
	<p>Store ink cartridges within the indicated temperature range. Do not store them in high or freezing temperatures.</p>
	<p>Do not use reactive ink, acid ink, dispersion ink, and pigment ink at the same time (including ink penetration liquid).</p>
	<p>Dispose of used cartridge according to local laws and regulations.</p>

Maintenance

 CAUTION	
	Epson recommends the use of genuine Epson ink cartridge. 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.

Precautions for Glue, Glue Remover, and Ink Film Remover

Glue, glue remover, and ink film 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, glue remover, and ink film remover as well as any effects on health therefrom.

Checks Before Maintenance

Check that there are no tools or hardware on the belt or around the pressure roller or print head. Otherwise, they may get caught in the print head, 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, around the print head, or near any other moving parts.

Front



Maintenance

Rear



Inspection/Cleaning Procedure

Checking the Area Around Operating Parts

- 1 Check that the machine is off.
- 2 Check that there are no problems around the moving parts.
 - Check that there are no tools or the like left around the belt or pressure roller.
 - Check for any dirt or dust or the like.
 - Are there any signs of ink pooling or leaks around the printer?
 - Are there any water leaks around the printer?

 [“Checking the Area Around Operating Parts” on page 66](#)

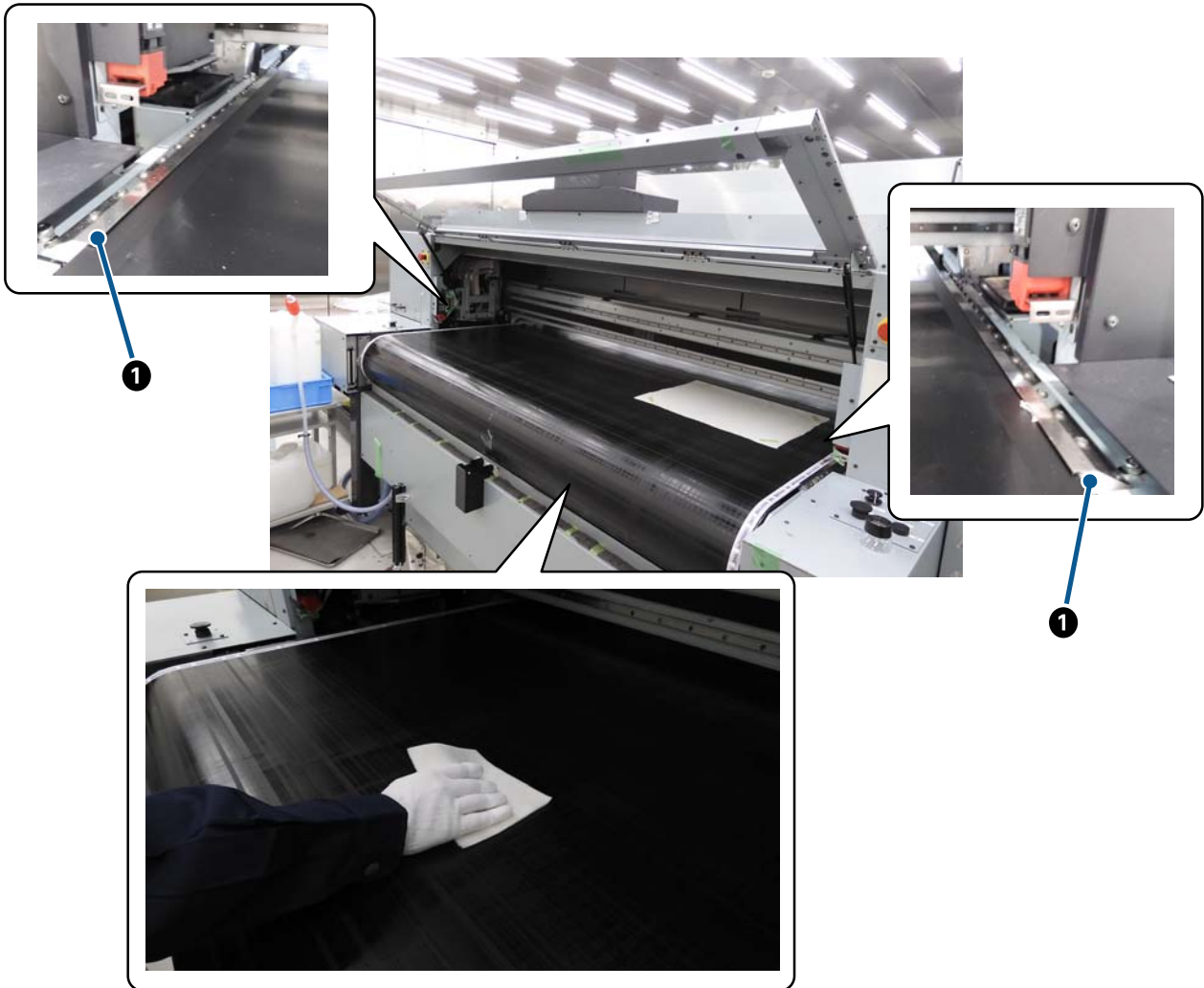
Cleaning the Area Around Operating Parts

Wipe away any debris or lint from the operating parts.

- 1 Check that the machine is off.

Maintenance

- 2 Open the front cover and wipe away any dirt on the belt surface or the belt side guides with a cloth dampened with water.



- 1 Guide beside the belt

Maintenance

- 3 Open the rear cover and wipe away any dirt from each of the rollers in the feeding unit with a wipe cloth dampened with water.

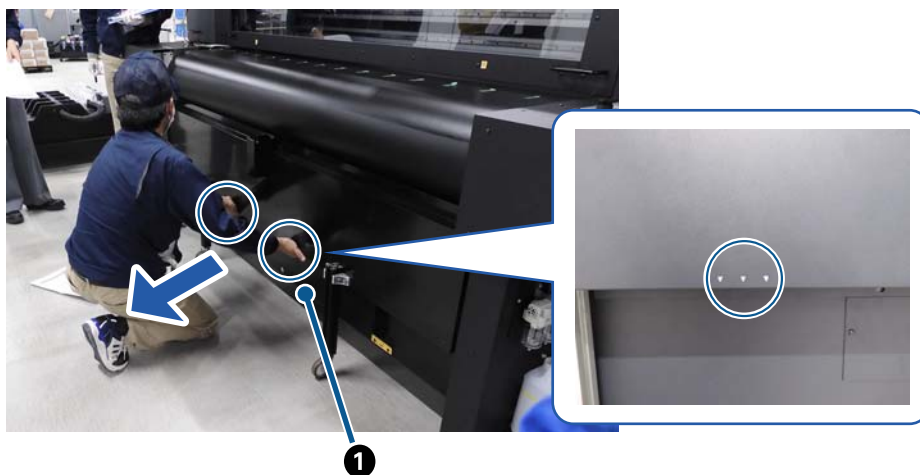


- 4 Close the rear cover and the front cover.

Checking for Water Leaks in the Pipe Joints

- 1 Check that the machine is off.
- 2 Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

Hold the handles on the front of the belt cleaning unit to pull it out.



- 1 Handles

Maintenance

- 3** Check that the joints for the cleaning tank of the cleaning unit are not loosened and are free from water leaks.

If there are any leaks, tighten the joints. If the problem continues to occur, check the status of the equipment in the factory.

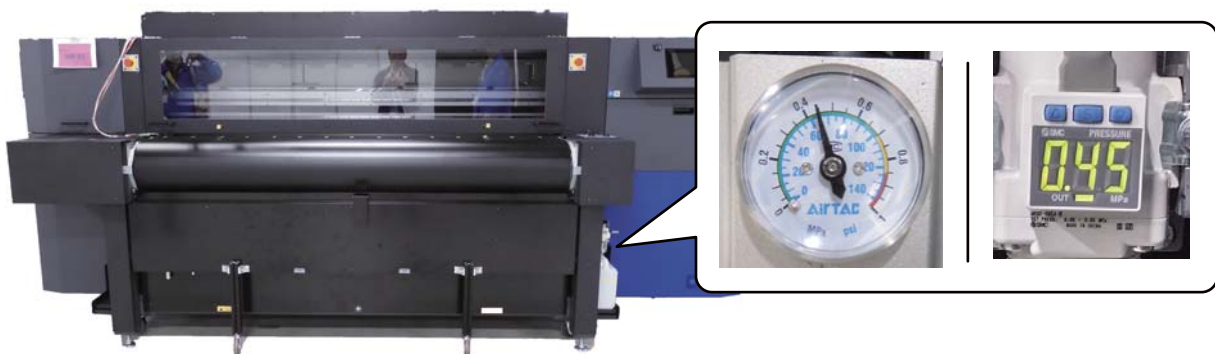
☞ [“Factory facilities” on page 458](#)



Checking 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. An air pressure that is higher than the specified air pressure could cause the machine to malfunction.

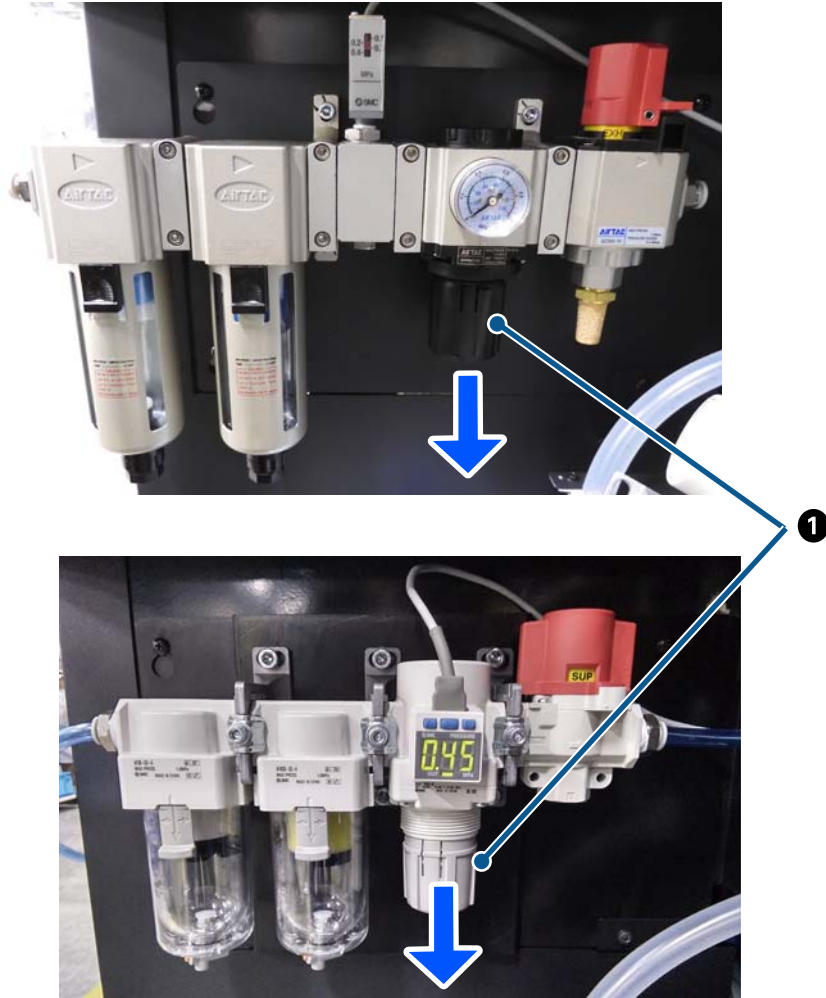
Confirm that the meter matches the specified value.
Specified value: 0.45 Mpa



If it does not match the specified value, use the pressure adjustment handle to perform adjustment.

Maintenance

- 1 Pull the pressure adjustment handle down until you hear a click.



- 1 Pressure adjustment handle

Maintenance

- 2** Turn to the right to raise the pressure. Turn to the left to lower the pressure.

Perform adjustments while checking the meter.



- 3** Once you have adjusted the pressure to the necessary amount, press the pressure adjustment handle up and lock it.

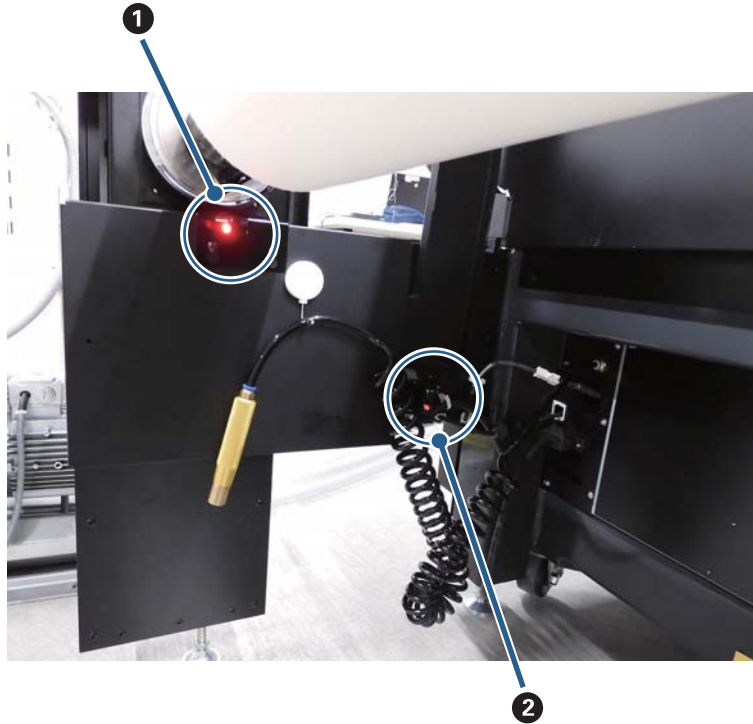
If it is not at the specified value after the above procedure, check the status of the compressed air equipment in the factory.

🔗 [“Factory facilities” on page 458](#)

Maintenance

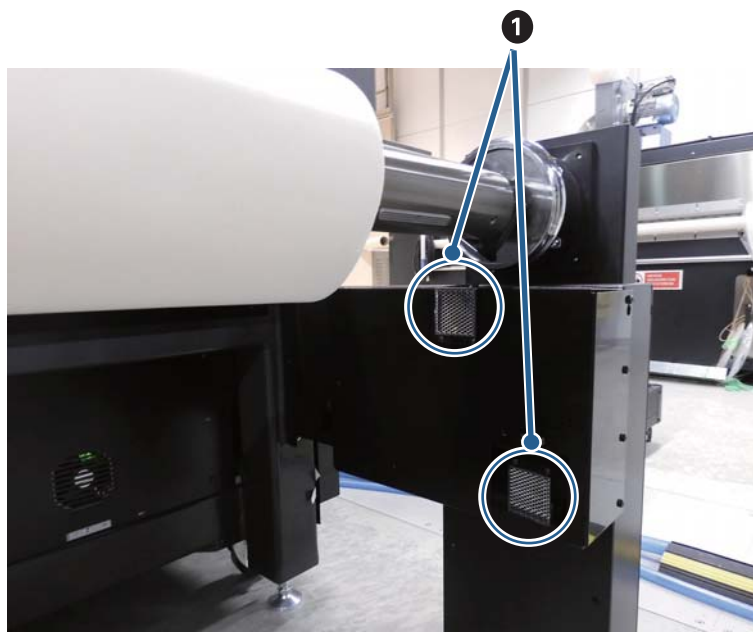
Cleaning the Sensors

- 1 Use wipe cloths or the like to wipe off any dust or debris attached to the roll diameter measurement sensor and slack detection sensor on the machine rear.



- 1 Roll diameter measurement sensor
- 2 Slack detection sensor

- 2 Use wipe cloths or the like to wipe off any dust or debris attached to the reflector plates opposite the sensors.



- 1 Reflector plates

Maintenance

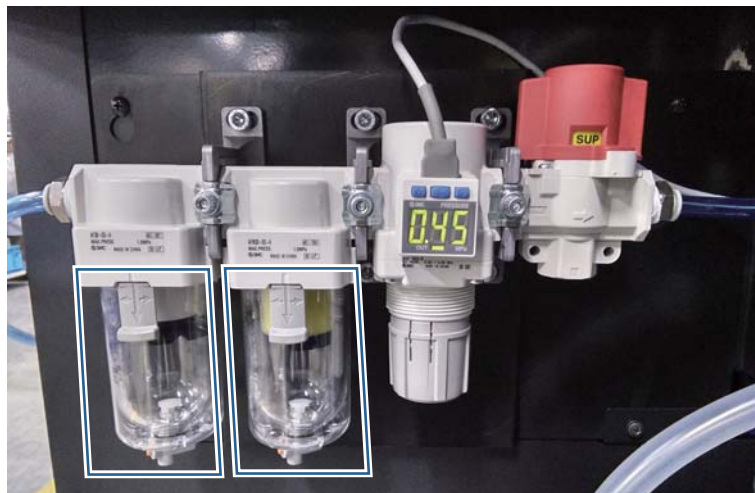
Checking the Operation of the Emergency Stop Equipment

Check the operation of any one of the emergency stop buttons on the machine.

 [“Checking the Operation of the Emergency Stop Equipment” on page 72](#)

Checking the Air Supply Regulator Water Level

- 1 Check that the machine is off.
- 2 Check the water level in the air supply regulator.



Maintenance

- 3 If water has accumulated, turn the knob at the bottom of the regulator to the left, or press the orange button to drain the water.



Maintenance

Inspecting/Cleaning the Cleaning Pad


There are two cleaning pads inside the right-side maintenance cover.



If waste ink, debris, or lint has accumulated on the cleaning pad, follow the steps below to perform cleaning.

Inspection Points

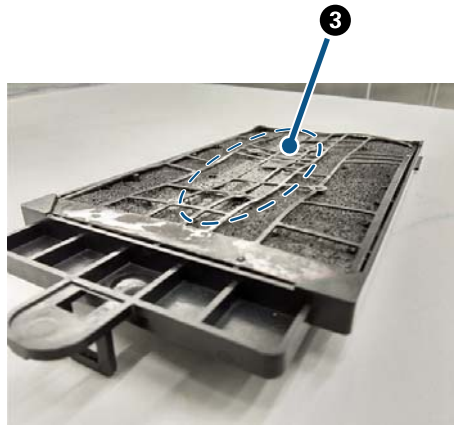
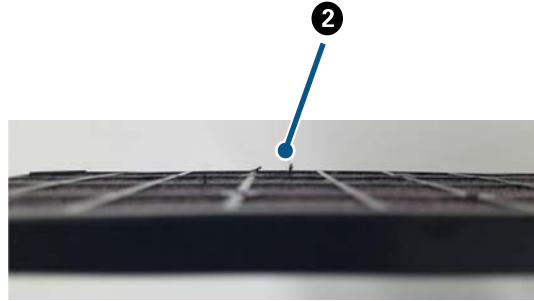
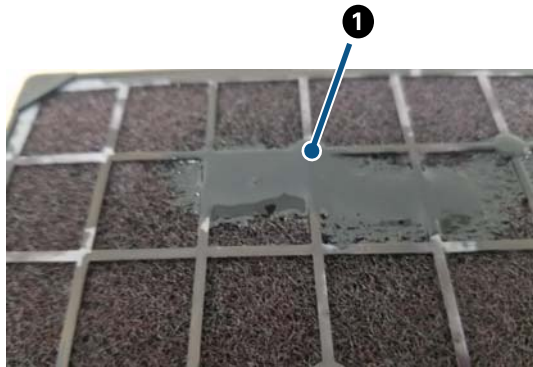
Check the cleaning pad by viewing it horizontally from the side. If ink, dust, lint, and so on has accumulated on the top surface of the cleaning pad, it needs to be cleaned.

 [“Cleaning” on page 191](#)

Maintenance

If you cannot remove the built-up deposits after cleaning several times or if the cleaning pad is deformed, the cleaning pad needs to be replaced.

🔗 [“Replacing the Cleaning Pad” on page 250](#)



- ① Ink deposits
- ② Dust and lint
- ③ Deformed cleaning pad

Cleaning

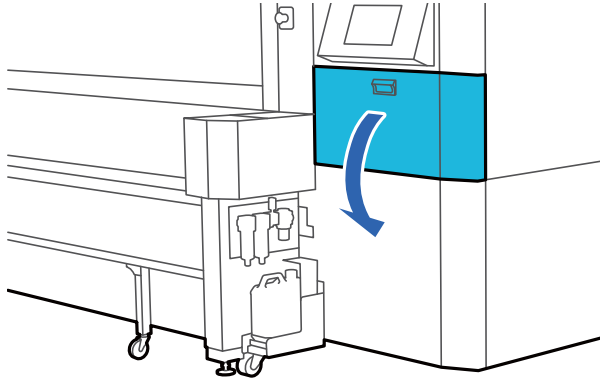
Personal protective equipment	Protective gloves and clothing, eye protection
-------------------------------	------------------------------------------------

1

From the Maintenance screen on the control panel, touch **Daily - Cleaning Pad Cleaning**, in that order.

Maintenance

- 2 Open the right-side maintenance cover.



- 3 Lift the tab on the rear of the cleaning pad on the top of the wiper roll unit towards you and remove it.



Maintenance

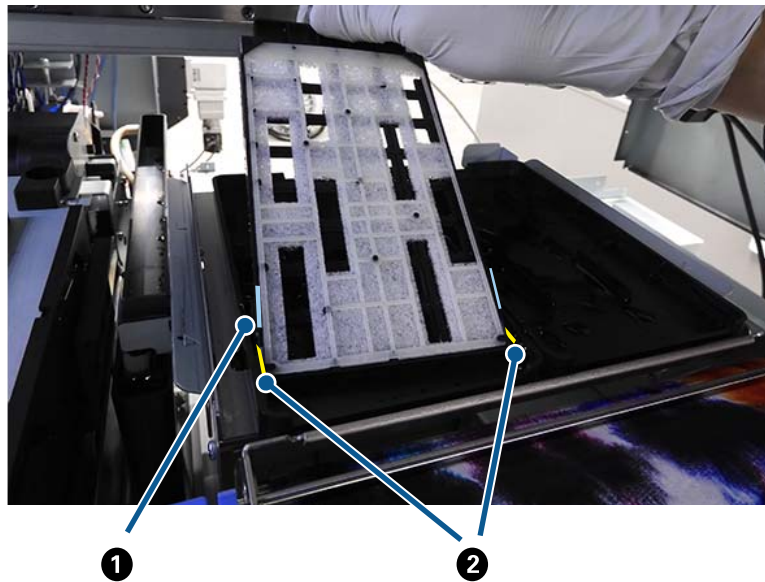
4 Put the cleaning pad into a container filled with tap water and remove the staining.

Dirty water is industrial waste. Dispose of it in the proper manner.



5 Dry the cleaning pad and put it back in its original position.

Align the protrusions of the cleaning pad with the guides on the top of the wiper roll unit.



1 Protrusions

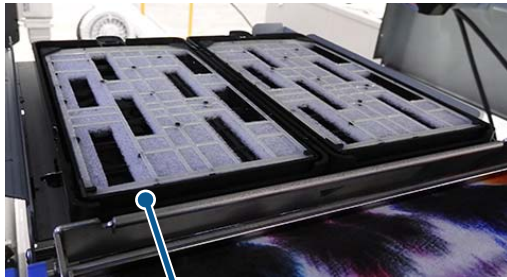
2 Guides

Maintenance



Important:

Make sure that the cleaning pad is not floating up diagonally. Printing with it still floating up can cause it to collide with the print head and cause a failure.



1



2

1 Not floating

2 Floating

6

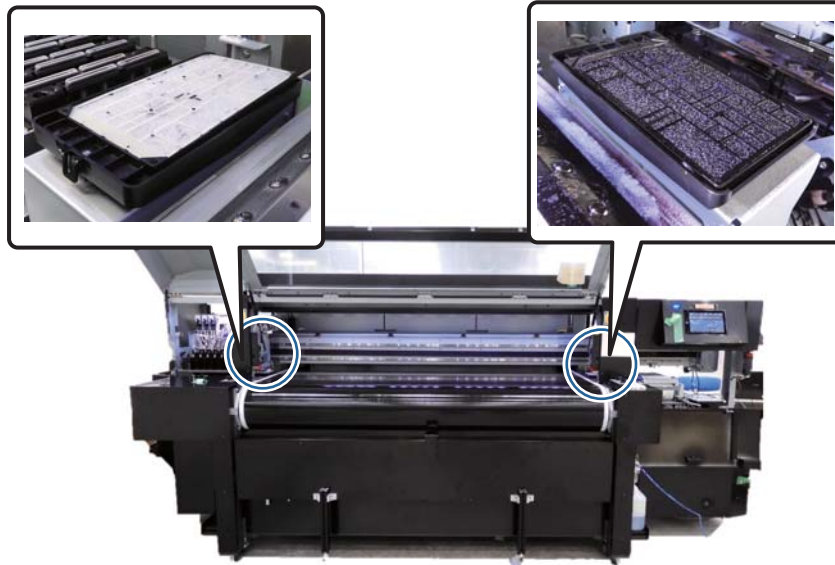
Clean the other cleaning pad in the same way.

7

Close the maintenance cover.

Inspecting/Cleaning the Flushing Pad

There is one flushing pad inside the left and right maintenance covers.




If waste ink, debris, or lint has accumulated on the flushing pad, follow the steps below to perform cleaning.

Maintenance

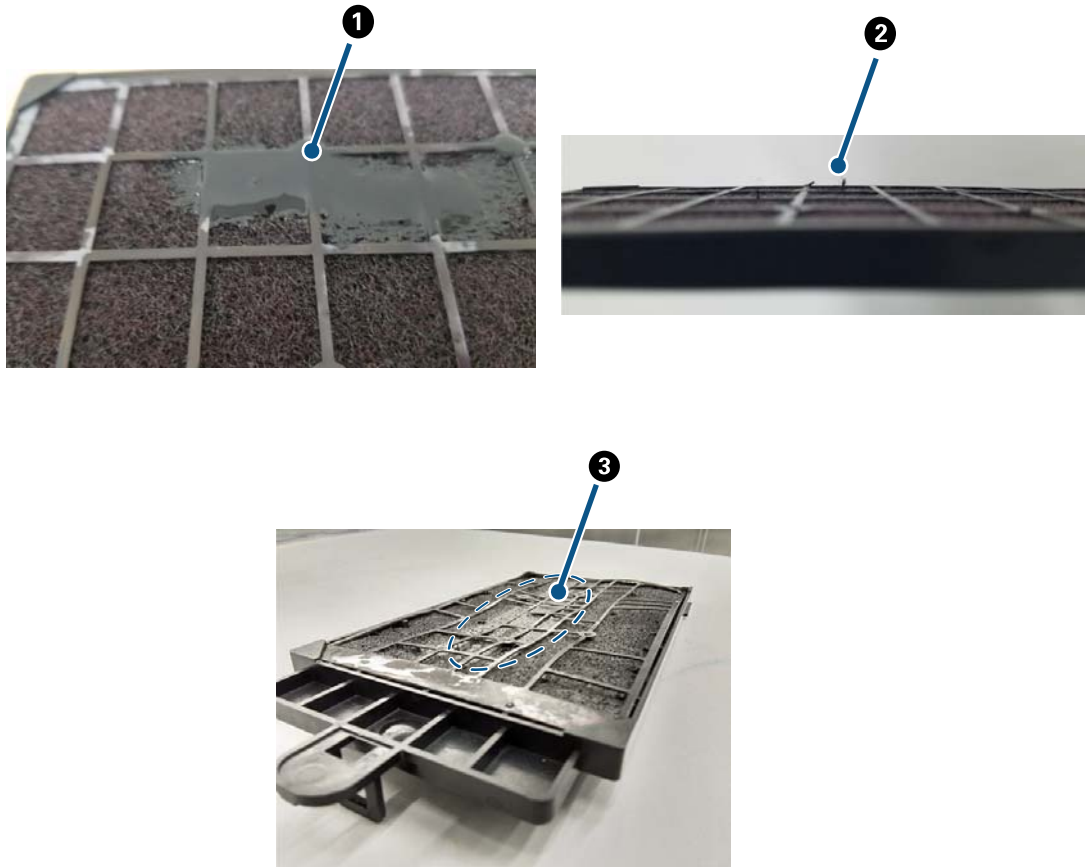
Inspection Points

Check the flushing pad by viewing it horizontally from the side. If ink, dust, lint, and so on has accumulated on the top surface of the flushing pad, it needs to be cleaned.

 [“Cleaning” on page 195](#)

If you cannot remove the built-up deposits after cleaning several times or if the flushing pad is deformed, the flushing pad needs to be replaced.

 [“Replacing the Flushing Pad” on page 245](#)



- ① Ink deposits
- ② Dust and lint
- ③ Deformed flushing pad

Cleaning

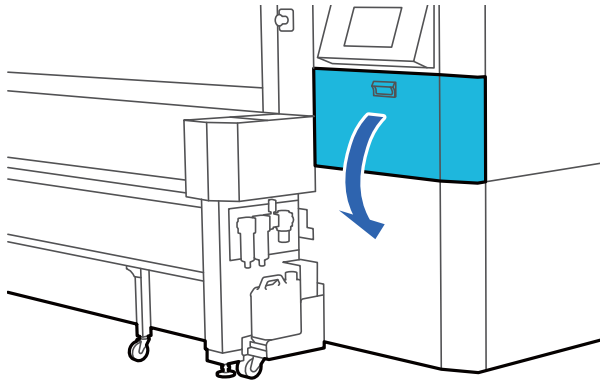
Personal protective equipment	Protective gloves and clothing, eye protection
-------------------------------	------------------------------------------------

1

From the Maintenance screen on the control panel, touch **Daily - Flushing Pad Cleaning**, in that order.

Maintenance

- 2 Open the right-side maintenance cover.



- 3 Lift the tab on the rear of the flushing pad towards you and remove it.



Maintenance

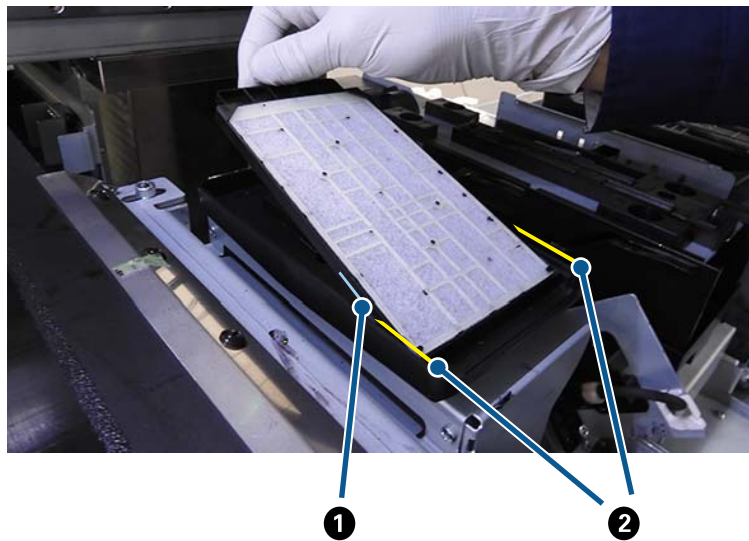
- 4** Put the flushing pad into a container filled with tap water and remove the staining.

Dirty water is industrial waste. Dispose of it in the proper manner.



- 5** Dry the flushing pad and put it back in its original position.

Align the protrusions of the flushing pad with the guides on the flushing box.

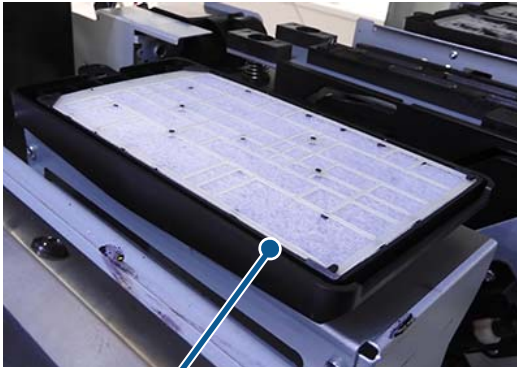


- ① Protrusions
- ② Guides

Maintenance

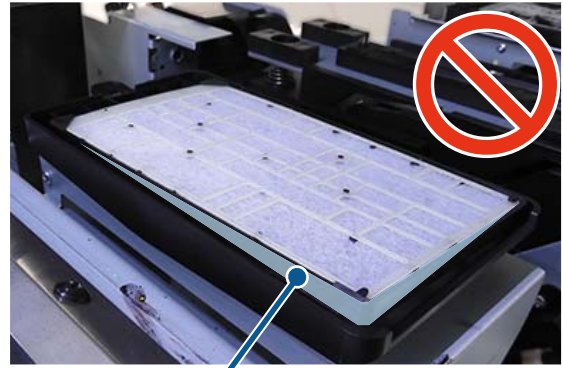
**Important:**

Make sure that the flushing pad is not floating up diagonally. Printing with it still floating up can cause it to collide with the print head and cause a failure.



1

1 Not floating



2

2 Floating

6

Close the maintenance cover.

7

From the Maintenance screen on the control panel, touch **Daily - Around the Head Cleaning**, in that order.

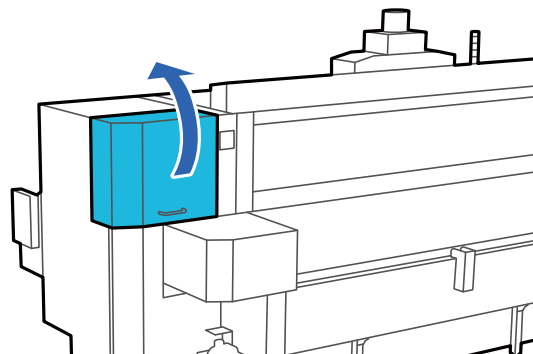
Move the print head to clean the flushing pad on the left.

8

Check the on-screen message, and then touch **Start**.

9

Confirm that the print head has moved to the right side, and then open the left-side maintenance cover.



Maintenance

- 10** Lift the tab on the front of the flushing pad towards you and remove it.



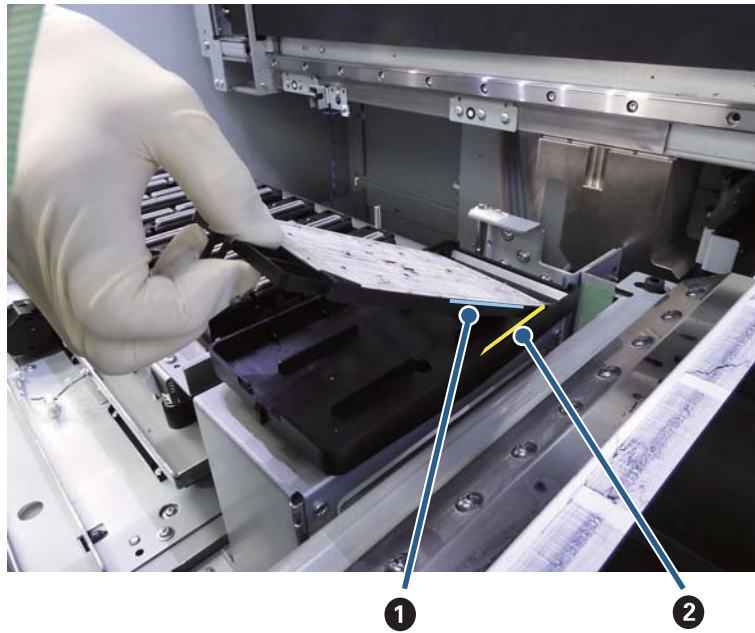
- 11** Put the flushing pad into a container filled with tap water and remove the staining.
Dirty water is industrial waste. Dispose of it in the proper manner.



Maintenance

12 Dry the flushing pad and put it back in its original position.

Align the protrusions of the flushing pad with the guides on the flushing box.



- 1 Protrusions
- 2 Guides

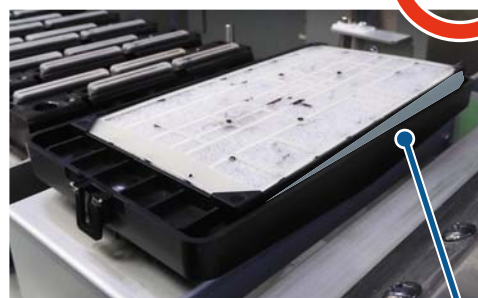


Important:

Make sure that the flushing pad is not floating up diagonally. Printing with it still floating up can cause it to collide with the print head and cause a failure.



1



2

- 1 Not floating
- 2 Floating

13 Close the maintenance cover, and then touch the **Done** button on the control panel.

Maintenance

Inspecting/Cleaning Around the Print Head

If any of the following problems occur, check the print head and clean it if there are any ink clots, lint, or dust.

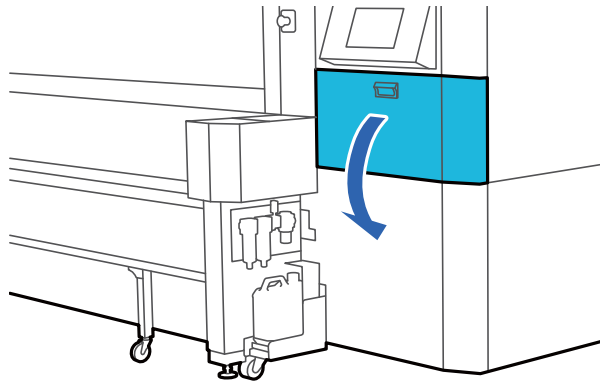
- Print head striking
- Print results are dirty

You can watch a video of the procedure on YouTube.


https://support.epson.net/p_doc/80d/

Personal protective equipment	Protective gloves and clothing, eye protection
-------------------------------	------------------------------------------------

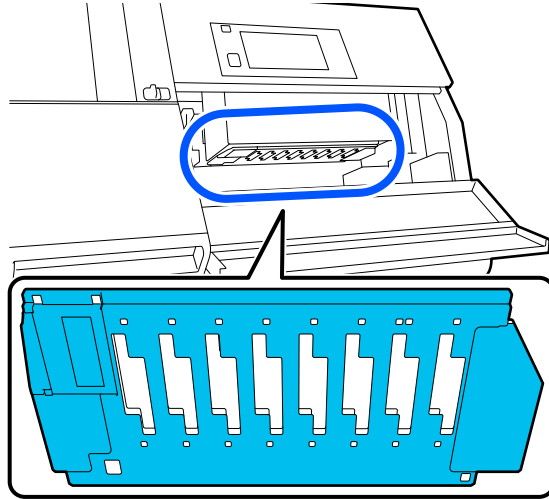
- 1** From the Maintenance screen on the control panel, touch **Daily - Around the Head Cleaning**, in that order.
- 2** Check the on-screen message, and then touch **Start**.
- 3** Confirm that the print head has moved to the right side, and then open the right-side maintenance cover.



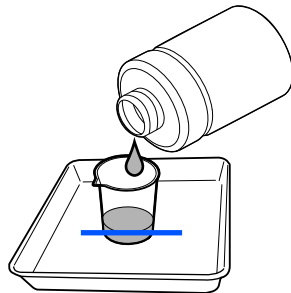
Maintenance

- 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.

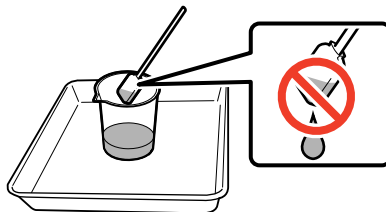


- 5** Place the container included in the cleaning kit on the tray and pour in approximately 10 ml (0.34 ounces) of cleaning liquid.



- 6** Dampen the cleaning stick with cleaning liquid.

When doing this, do not allow cleaning liquid to drip from the cleaning stick.



Maintenance



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.

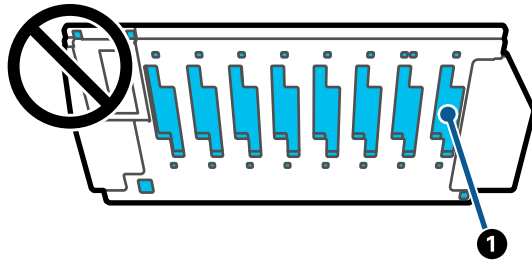
- ❑ Tightly close the lid of the cleaning liquid and store it at room temperature out of direct sunlight and away from high temperatures or humidity.
- ❑ Used cleaning liquid and cleaning sticks are industrial waste. Dispose of them in the same way as for waste inks.

7



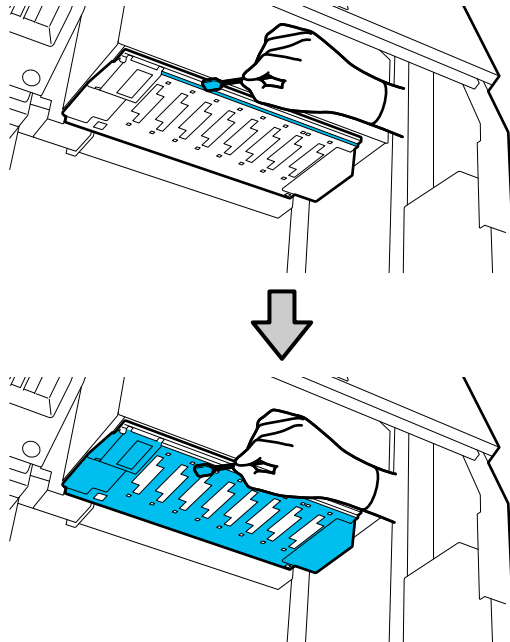
Important:

Do not touch the nozzle surface of the print head or wipe it with a cleaning stick.



① Print Head Nozzle Surface

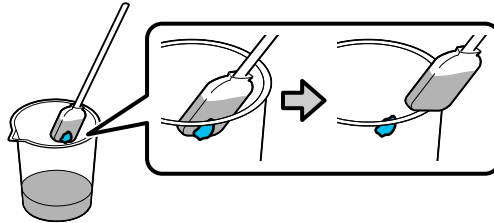
Wipe off any ink, lint, or dust that is stuck to the colored area shown in the illustration. It is not necessary to wipe off any areas that are not dirty.



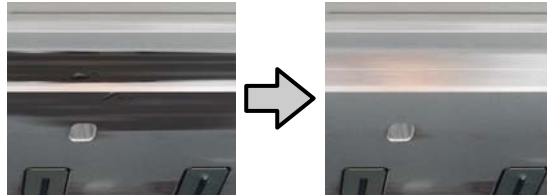
Maintenance

! 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.



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, and then touch the **Complete** button on the control panel.

Inspecting the Washing Scraper (Washing Scraper 2 only)

When using washing scraper 2 (C13S210167), check to make sure that the washing scraper is not worn down.

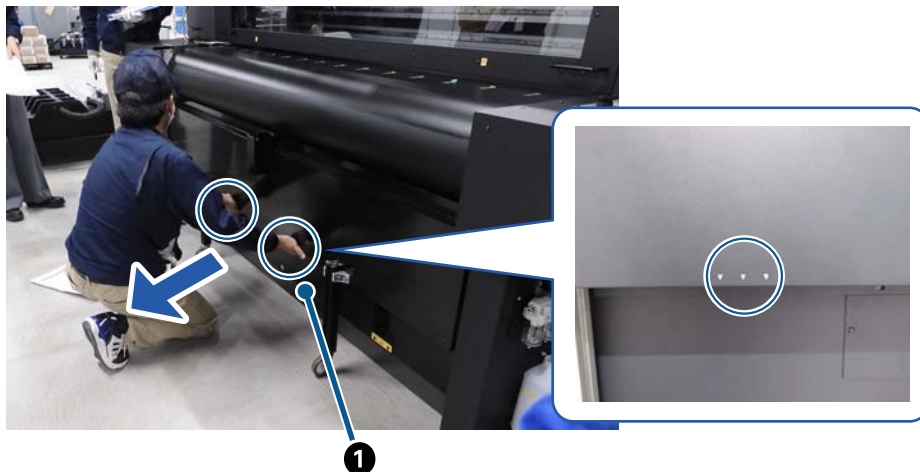
Personal protective equipment

Protective gloves and clothing

1

Check that the belt cleaning unit is in the lowered status and then pull out the belt cleaning unit from the machine front.

Hold the handles on the front of the belt cleaning unit to pull it out.



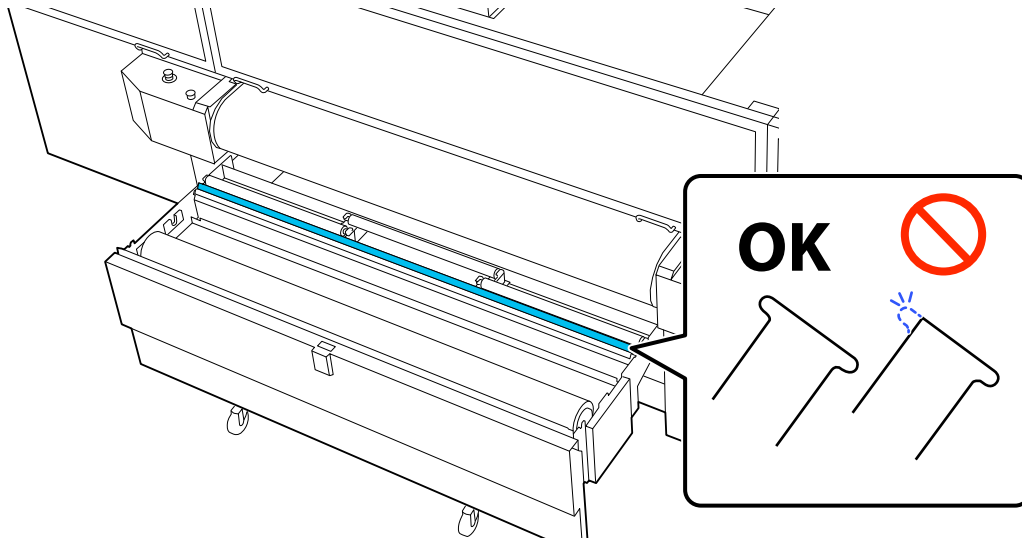
① Handles

Maintenance

- 2** Check that the protruding part on the front of the washing scraper is not worn down.

If it is worn down so much that the protruding part is gone, even partially, then turn over the washing scraper and reattach it, or replace it.

 [“When Using the Washing Scraper 2 \(C13S210167\)” on page 256](#)



- 3** Push the belt cleaning unit back to its original position.

Drying Sponge Roller (ML-8000U Only)

Water droplets may remain on the belt if the sponge roller is wet. Follow the steps below to dry it.

When water droplets remain on the belt even after drying, replace the sponge roller.

 [“Replacing the Sponge Roller \(ML-8000U Only\)” on page 261](#)

Note:

Do not continue printing while the sponge roller is wet. If the sponge roller cannot absorb water and printing is performed with water droplets remaining on the belt, the print results will be smeared, or the quality of the sponge roller will deteriorate.

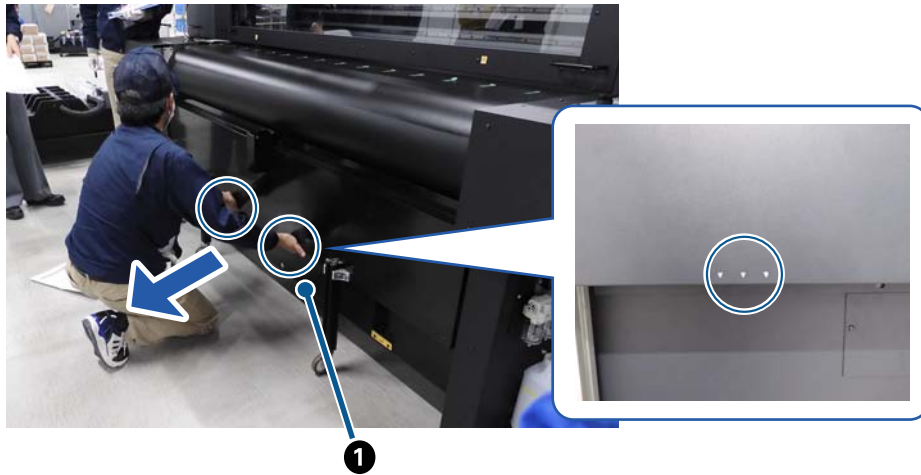
Personal protective equipment

Protective gloves and clothing, eye protection

Maintenance

- 1 Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

Hold the handles on the front of the belt cleaning unit to pull it out.



- 1 Handles

- 2 Dry the sponge roller by hand.

Thoroughly squeeze the entire sponge roller until no water drips out.



Maintenance


Important:

Do not squeeze the sponge roller by twisting it. Doing so may tear the sponge and reduce its absorbency.


3

Push the belt cleaning unit back to its original position.

Inspecting/Cleaning the Ink Path

If the ink path becomes clogged, waste ink could leak inside the machine. Flushing water through the ink path can wash out the waste ink accumulated in the ink path. The flushed water is stored in the waste ink bottle. If waste ink has filled up the yellow line in the waste ink bottle, it may overflow during ink path cleaning. Dispose of the waste ink in advance.

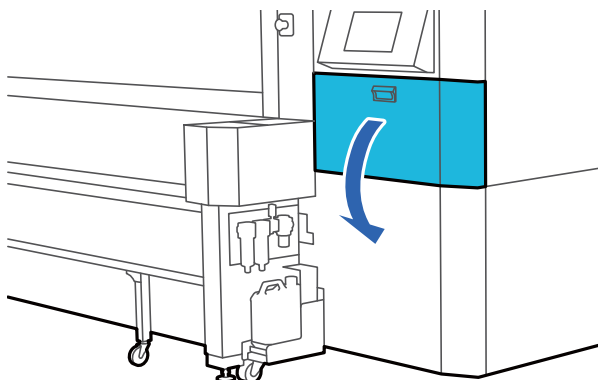
 [“Disposing of Waste Ink” on page 241](#)

Follow the steps below to perform cleaning. If ink is already leaking, contact your dealer or Epson Support.

Personal protective equipment	Protective gloves and clothing, eye protection
-------------------------------	------------------------------------------------

1

Open the right-side maintenance cover.

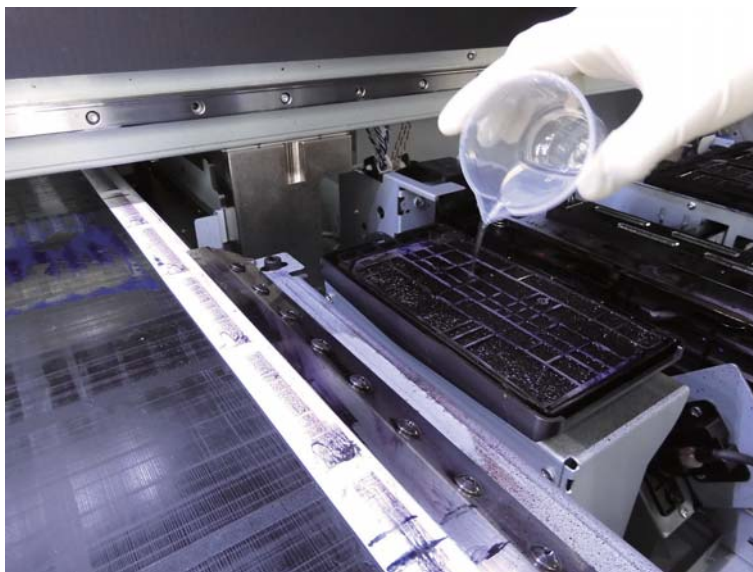


Maintenance

- 2 Pour approximately 200 ml (6.76 ounces) of tap water down the right side of the cleaning pad.



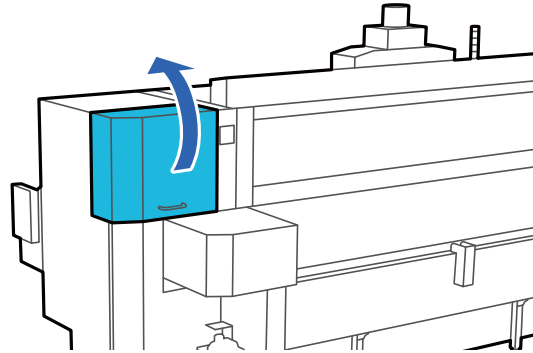
- 3 Pour approximately 200 ml (6.76 ounces) of tap water over the flushing pad.



- 4 Close the maintenance cover.
- 5 Check the waste ink bottle on the right side, and if the waste ink has filled up to the yellow line, dispose of the waste ink.
[🔗 “Disposing of Waste Ink” on page 241](#)
- 6 From the Maintenance screen on the control panel, touch **Daily - Around the Head Cleaning**, in that order.
Move the print head to flush the flushing pad on the left.
- 7 Check the on-screen message, and then touch **Start**.

Maintenance

- 8 Confirm that the print head has moved to the right side, and then open the left-side maintenance cover.



- 9 Pour approximately 200 ml (6.76 ounces) of tap water over the flushing pad.



- 10 Close the maintenance cover, and then touch the **Done** button on the control panel.

- 11 Check the waste ink bottle on the left side, and if the waste ink has filled up to the yellow line, dispose of the waste ink.

 [“Disposing of Waste Ink” on page 241](#)

Cleaning the Caps

When the caps need to be cleaned, the message **Clean the Cap.** is displayed on the screen, indicating which caps need to be cleaned.

When the message is displayed, follow the steps below to clean only the indicated caps.

You can watch a video of the procedure on YouTube.

https://support.epson.net/p_doc/80d/

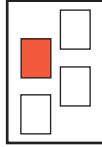
Maintenance

Personal protective equipment

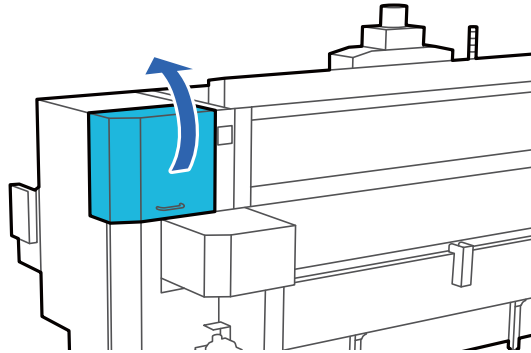
Protective gloves and clothing, eye protection

- 1 When the message **Clean the Cap.** Is displayed on the screen, check which caps you need to clean.

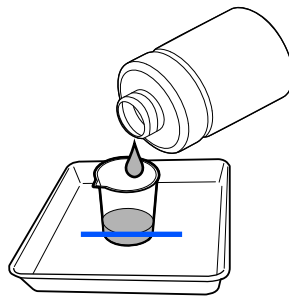
As shown in the figure, the caps that need to be cleaned are filled in.



- 2 Open the left-side maintenance cover.

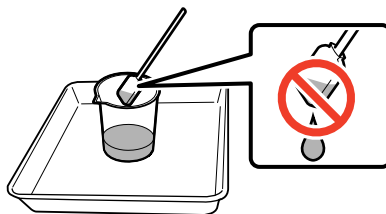


- 3 Place the container included in the cleaning kit on the tray and pour in approximately 10 ml (0.34 ounces) of cleaning liquid.



- 4 Dampen the cleaning stick with cleaning liquid.

When doing this, do not allow cleaning liquid to drip from the cleaning stick.



Maintenance



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.

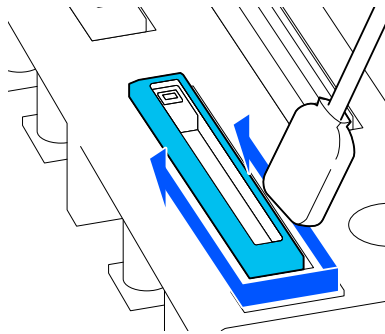
- ❑ Tightly close the lid of the cleaning liquid and store it at room temperature out of direct sunlight and away from high temperatures or humidity.
- ❑ Used cleaning liquid and cleaning sticks are industrial waste. Dispose of them in the same way as for waste inks.

5

Hold the cleaning stick vertically and wipe the outer edges of the cap.

Avoid wiping around the hole in the cap.

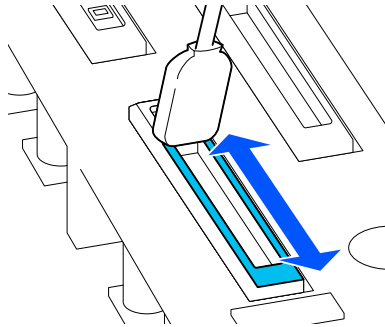
If there is lint or dust on the cap, remove it with the tip of the cleaning stick.



6

Hold the cleaning stick flat and wipe the edges of the cap.

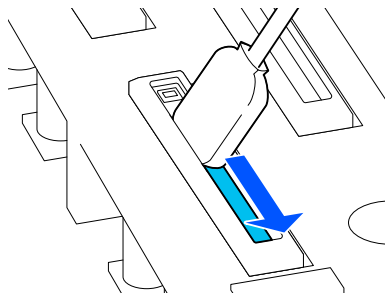
Avoid wiping around the hole in the cap.



7

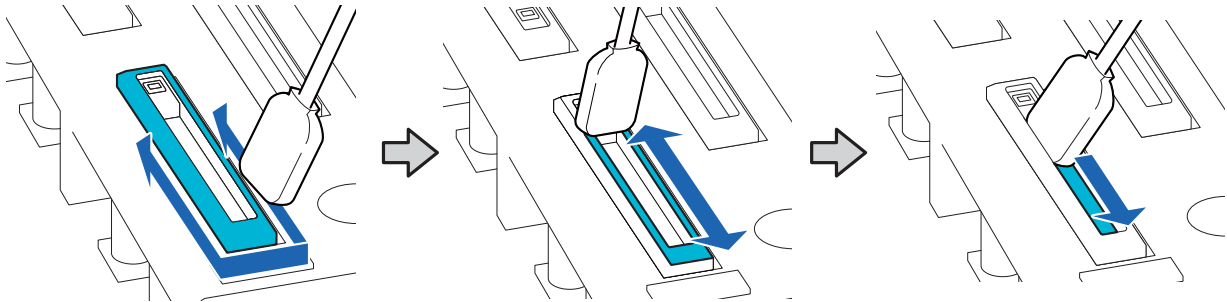
Hold the cleaning stick vertically and wipe the inside edges of the cap.

Avoid the area around the hole in the cap, and wipe by moving the cleaning stick only in the direction away from the hole to the opposite side.



Maintenance

- 8** With a new, dry cleaning stick, wipe off all ink and cleaning liquid from the outer edges, the rim, and the inside of the cap.



Wipe up all the ink and cleaning liquid, leaving no residue, as shown in the illustration below. If any ink or cleaning liquid remains, it may cause the nozzles to clog.



- 9** Close the maintenance cover, and then touch the **Complete** button on the control panel.
The print head returns to its normal position.

Maintenance

Cleaning the Belt Cleaning Brushes and the Area Around Them

After printing on fabric with significant amounts of lint, fibers or debris may get stuck on the cleaning brushes, scraper, blower motor, or in the cleaning tank, reducing the cleaning effect of the belt, and water droplets may remain on the belt causing blurring in the print results. Once a week, follow the steps below to perform cleaning. Clean once a week, or whenever the printer items become clogged or covered with lint or debris.



❶ Clogged with lint and debris

Note:

If lint or debris accumulates in the guttering connected to the belt cleaning unit, the guttering may overflow or waste water may wash back into the cleaning tank. We also recommend that you inspect and clean the guttering on a regular basis.

Cleaning the cleaning brushes

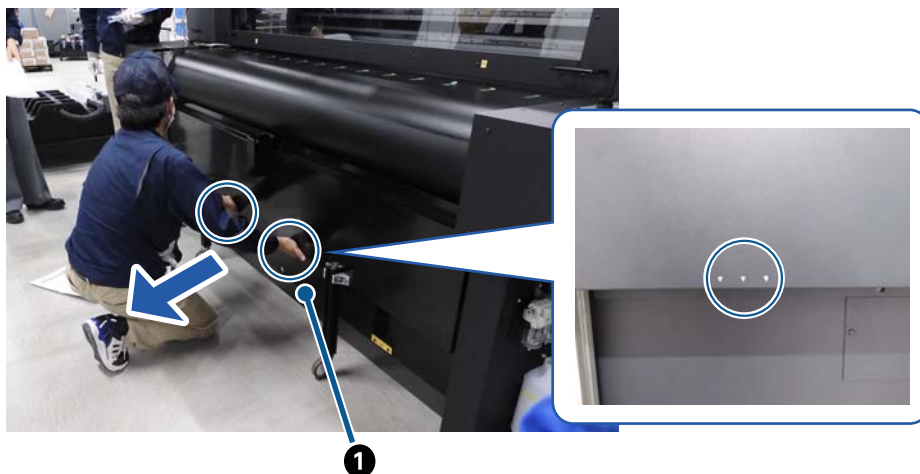
Personal protective equipment

Protective gloves and clothing, eye protection

Maintenance

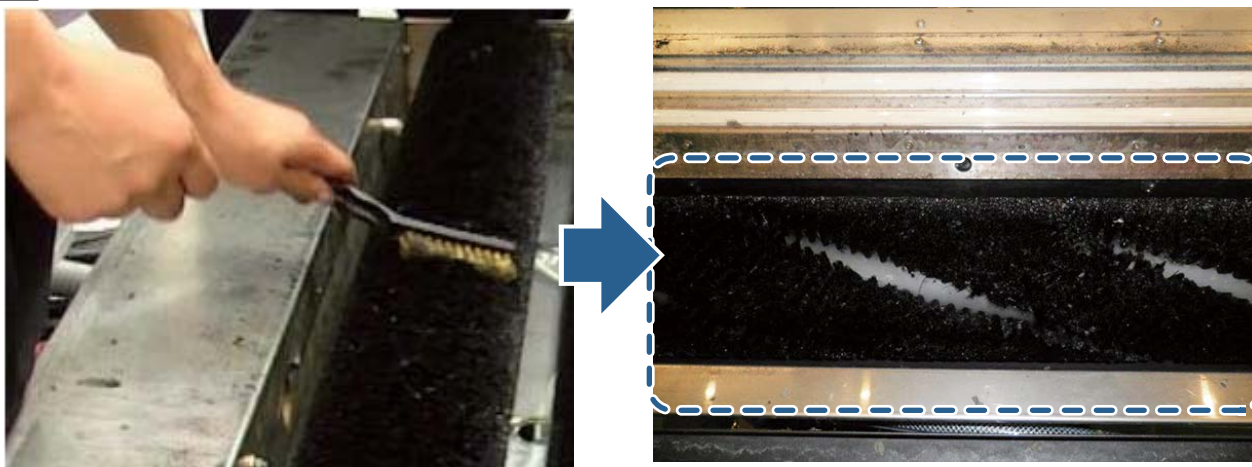
- 1 Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

Hold the handles on the front of the belt cleaning unit to pull it out.



- 1 Handles

- 2 Using a metal brush and so on, remove all lint and debris attached to the cleaning brushes.



- 3 Push the belt cleaning unit back to its original position.

Cleaning the washing scraper

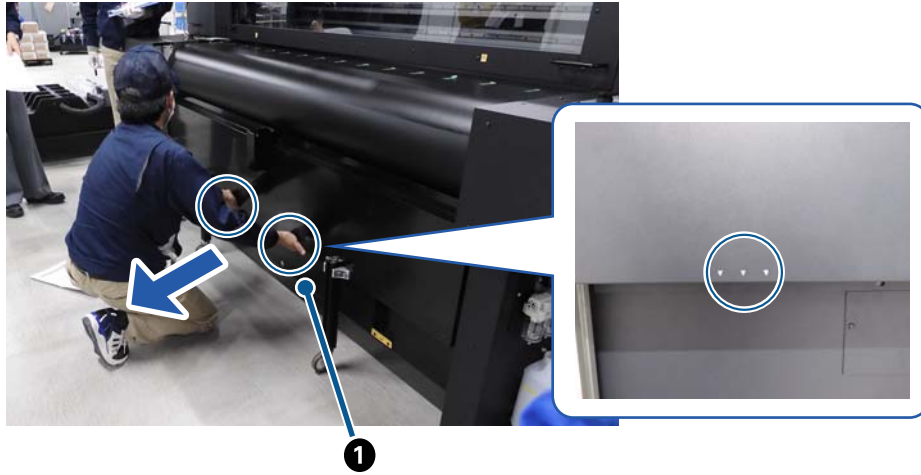
Personal protective equipment

Protective gloves and clothing, eye protection

Maintenance

- 1 Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

Hold the handles on the front of the belt cleaning unit to pull it out.



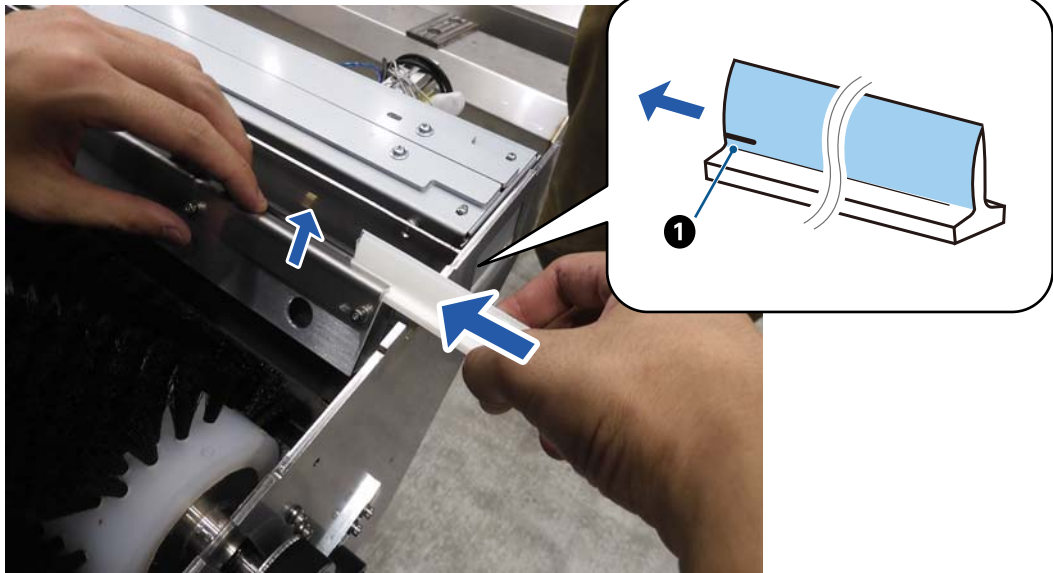
- 1 Handles

Maintenance

- 2** Using a soft cloth such as a wipe cloth, remove all lint and debris attached to the washing scraper.

! **Important:**

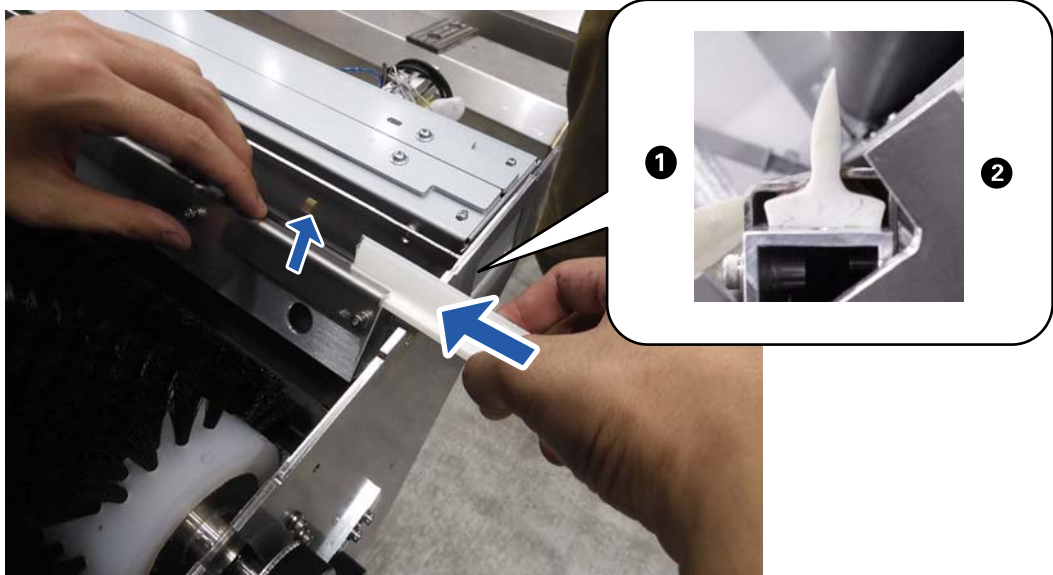
When removing and reinserting the scraper, insert it with the side that has a mark facing forward while lifting the metal plate up. Inserting it with the marked side facing the back may cause an abnormal noise or leave water droplets on the belt.



1 Markings

If the mark is difficult to see

If the mark is difficult to see, insert the scraper with the bulge in the scraper's cross section facing the front.



1 Front

2 Back

Maintenance



- 3 Push the belt cleaning unit back to its original position.

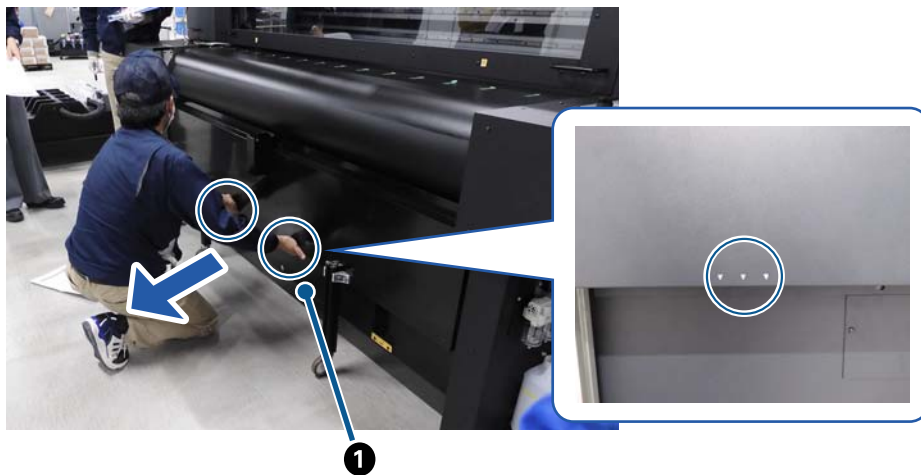
Cleaning the blower motor (ML-8000 only)

Personal protective equipment

Protective gloves and clothing, eye protection

- 1 Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

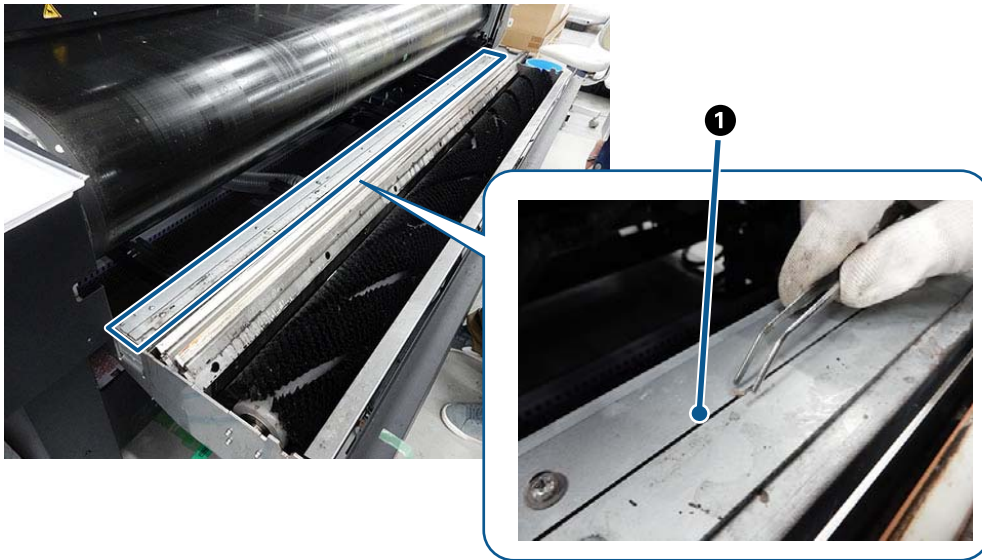
Hold the handles on the front of the belt cleaning unit to pull it out.



- 1 Handles

Maintenance

- 2 Use tweezers to remove any dust or lint from the exhaust port for the blower motor.



1 Exhaust port

- 3 Push the belt cleaning unit back to its original position.

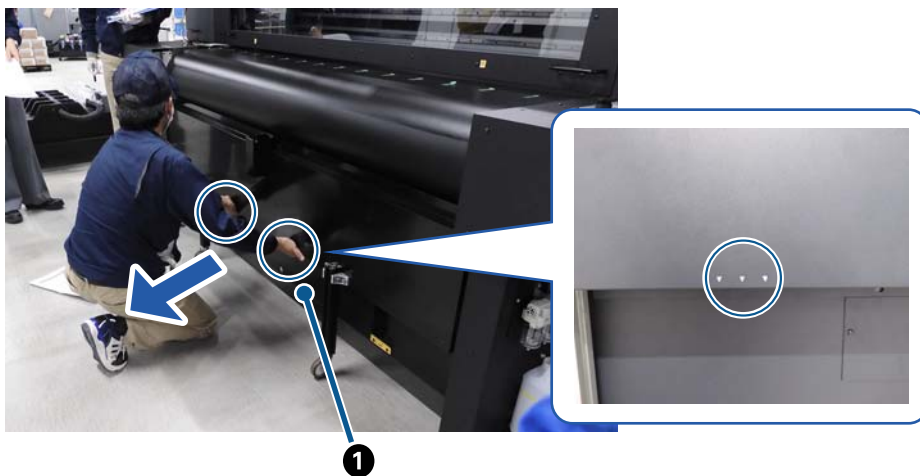
Cleaning the Belt Cleaning Tank

Personal protective equipment

Protective gloves and clothing, eye protection

- 1 Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

Hold the handles on the front of the belt cleaning unit to pull it out.



1 Handles

Maintenance

- 2 Open the drain valve on the bottom left side of the belt cleaning unit.

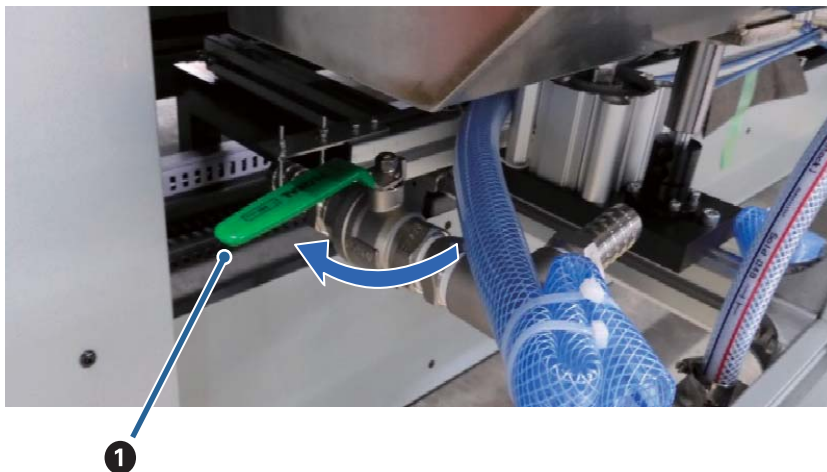
Drain the water in the cleaning tank.



- 1 Drain valve

- 3 Using a metal brush or the like, remove all lint and debris attached to the cleaning tank.

- 4 Close the drain valve.



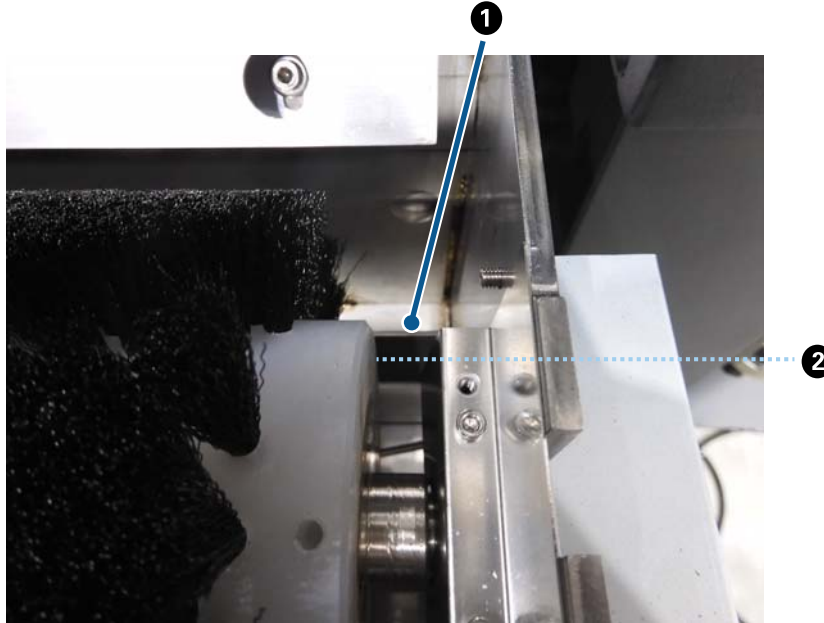
- 1 Drain valve

- 5 From the Maintenance screen on the control panel, touch **Maintenance - Cleaning the Cleaning Tank**, in that order.

Maintenance

6 Touch Start.

Supply of water to the cleaning tank begins. Supply water to the cleaning tank until it is more than half full. If the water is less than half full, the brush will rotate without water which may cause the glue applied to the belt to peel off.



- ① Water storage maximum limit
- ② Estimated amount of water

7 Once water accumulates in the cleaning tank, touch the **Suspend** button on the control panel.

8 Push the belt cleaning unit back to its original position.

Inspecting/Cleaning the Suction Caps

Inspect/clean the suction caps before performing Print Head Refresh.

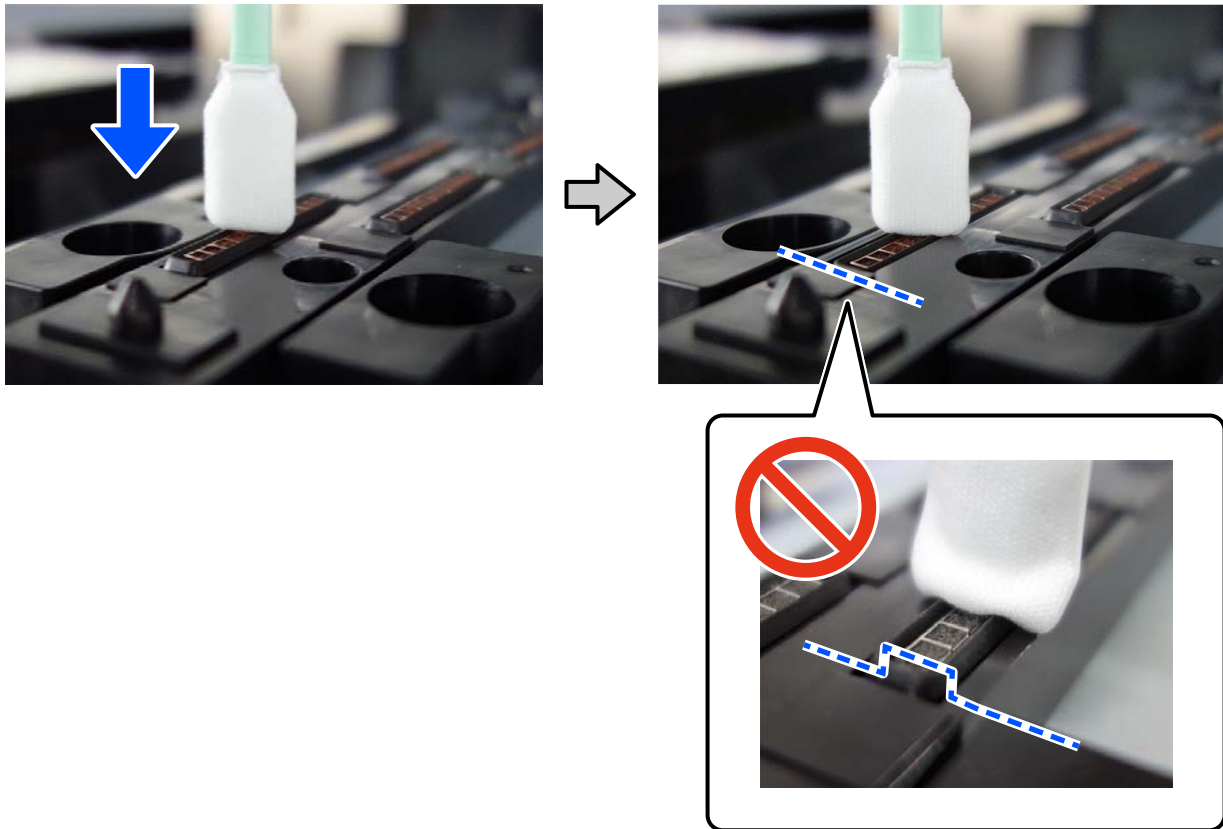
Personal protective equipment	Protective gloves and clothing, eye protection
-------------------------------	------------------------------------------------

Inspection Procedure

Check for any ink buildup inside the suction cap.

Maintenance

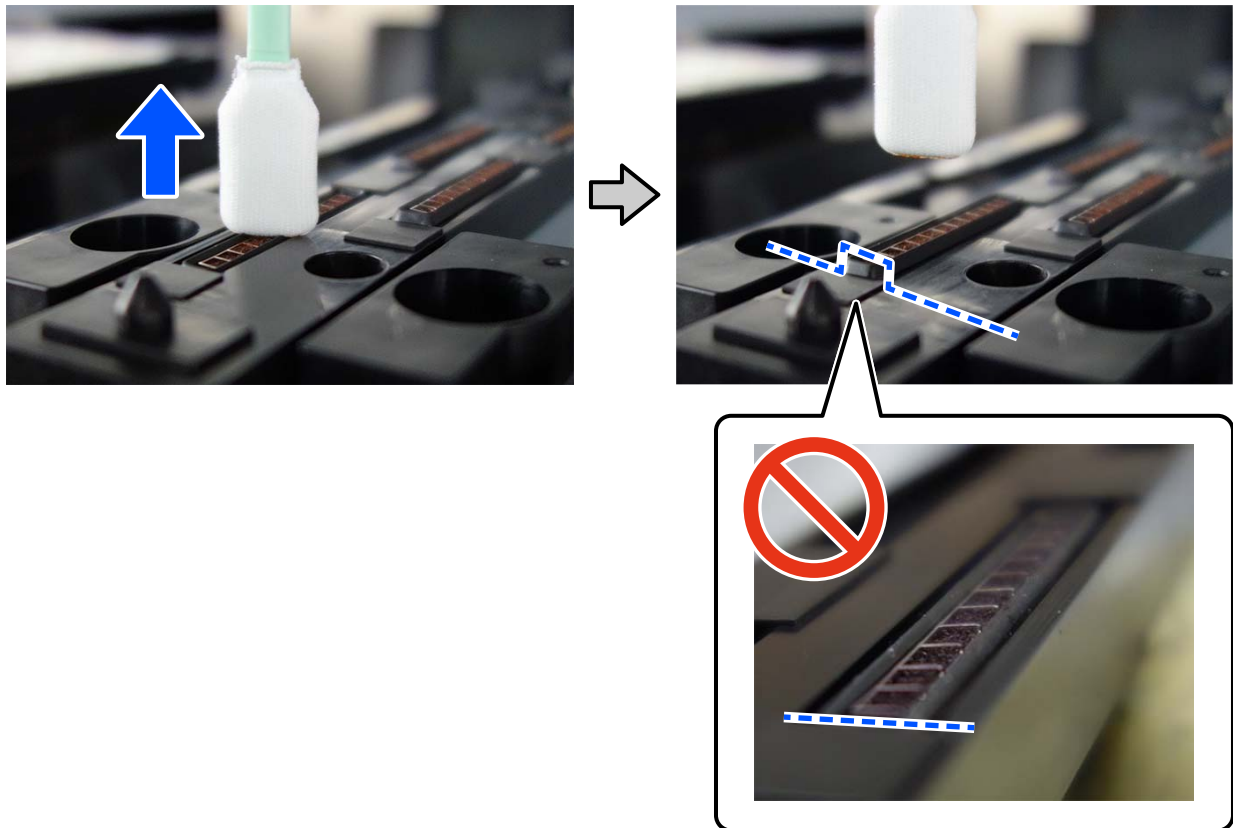
- 1 Hold the cleaning stick in the direction shown in the photo and use it to press the center of the suction cap to check if it can be lowered completely.



! **Important:**
*If the suction cap does lower completely, ink may have built up inside the suction cap.
If ink builds up, it may cause the printer to malfunction, so contact your dealer or Epson Support.*

Maintenance

- 2 Remove the cleaning stick from the suction cap and check that it returns to its original height.



! **Important:**
 If the suction cap does not return to its original height, ink may have built up inside the suction cap.
 If ink builds up, it may cause the printer to malfunction, so contact your dealer or Epson Support.

Cleaning

If you do not clean the suction caps, doing Print Head Refresh is not fully effective. You can view the procedure on YouTube.

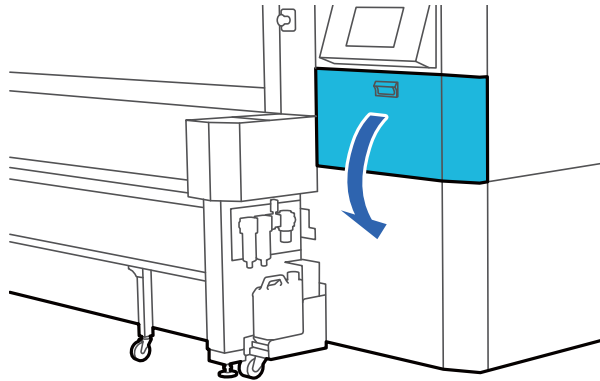
You can watch a video of the procedure on YouTube.

https://support.epson.net/p_doc/80d/

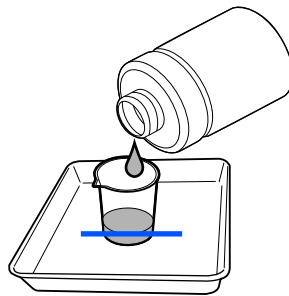
- 1 From the Maintenance screen on the control panel, touch **Maintenance - Cleaning the Maintenance Parts - Suction Cap**, in that order.
- 2 Check the on-screen message, and then touch **Start**.

Maintenance

- 3** Open the right-side maintenance cover.

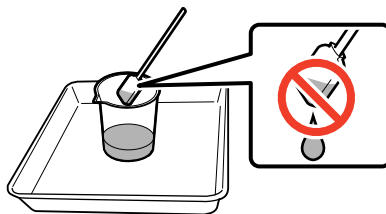


- 4** Place the container included in the cleaning kit on the tray and pour in approximately 10 ml (0.34 ounces) of cleaning liquid.



- 5** Dampen the cleaning stick with cleaning liquid.

When doing this, do not allow cleaning liquid to drip from the cleaning stick.



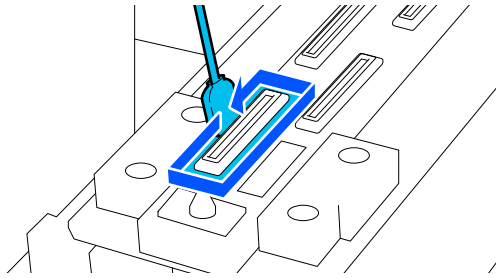
Important:

Do not use cleaning liquid that you have used for cleaning to clean the next time. Using dirty cleaning liquid will make staining worse.

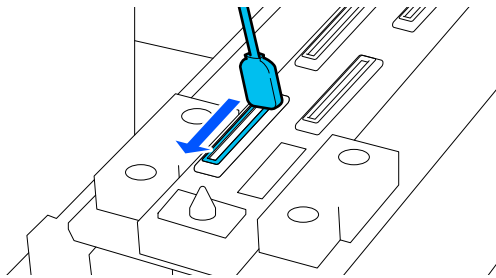
- Tightly close the lid of the cleaning liquid and store it at room temperature out of direct sunlight and away from high temperatures or humidity.*
- Used cleaning liquid and cleaning sticks are industrial waste. Dispose of them in the same way as for waste inks.*

Maintenance

- 6** Hold the cleaning stick vertically and wipe the entire outer edge of the cap.



- 7** Hold the cleaning stick flat and wipe all the edges.



- 8** Make sure that there are no ink stains, lint debris, or dust on the outer edge or rim of the cap.

If any dirt remains, repeat Steps 6 and 7.

- 9** Close the maintenance cover, and then touch the **Done** button on the control panel.

Cleaning and Replacing the Mist Filter

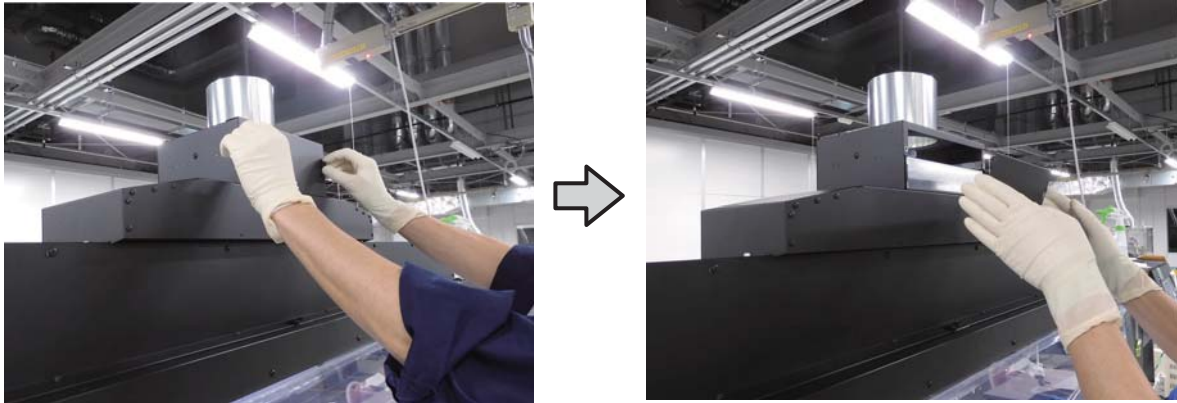
If debris accumulates in the mist filter, the machine interior may become dirty due to the mist, staining the fabric and causing clogged nozzles. Follow the steps below to perform cleaning. Replace the filter with a new one if it is still dirty after cleaning.

Personal protective equipment	Protective gloves and clothing
-------------------------------	--------------------------------

- 1** Check that the machine is off.

Maintenance

- 2** Remove the two screws from the mist filter cover and remove the cover.



- 3** Pull out the mist filter.



- 4** Clean the removed mist filter with water and thoroughly dry it.
If the filter is very dirty, replace it with a new one.

Note:

Since it takes time for the mist filter to dry, we recommend buying a spare.

- 5** Check the mist filter orientation (Top side: Blue, Bottom side: White) and return it to its original position.

- 6** Attach the mist filter cover you removed.

Cleaning and Replacing the Blower Filter (ML-8000 Only)

If debris accumulates in the blower filter, less air is sent to the belt, which may result in water droplets remaining after belt cleaning. Follow the steps below to perform cleaning.
Replace the filter with a new one if it is still dirty after cleaning.

Personal protective equipment

Protective gloves and clothing

Maintenance

Cleaning

- 1 Check that the machine is off.
- 2 Turn the screw on the top of the blower filter and remove the cover.



Maintenance

- 3 Use a vacuum cleaner to clean the dust, dirt, and so on from the blower filter.

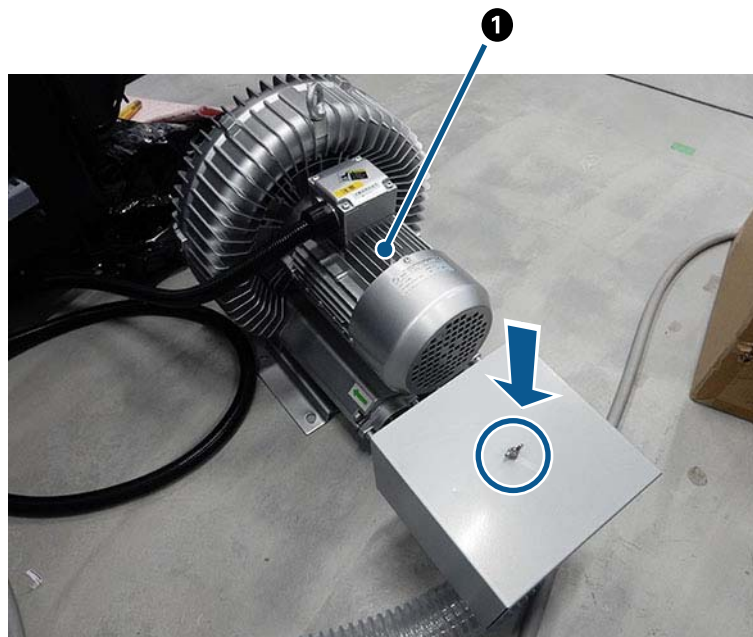
If the filter is very dirty, replace it with a new one.

[☞ “Replacing” on page 228](#)



- 1 Blower filter

- 4 Install the filter cover you removed so that it is parallel to the blower, and then tighten the screw.

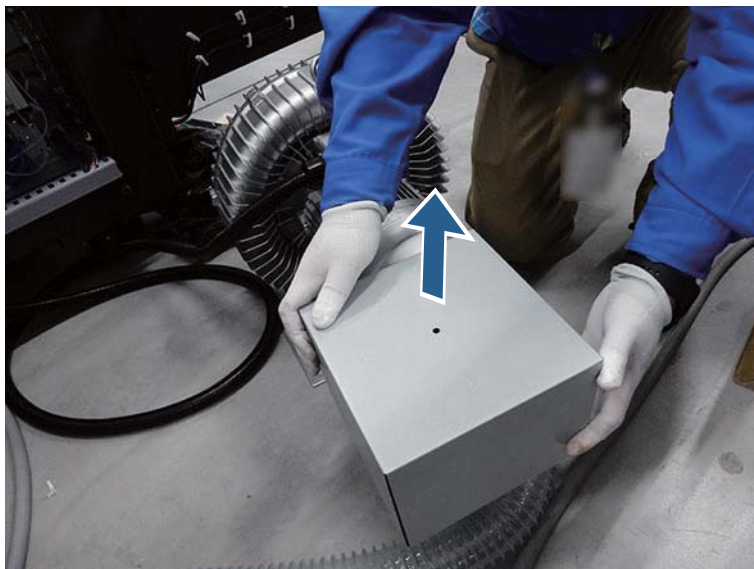


- 1 Blower

Maintenance

Replacing

- 1 Check that the machine is off.
- 2 Turn the screw on the top of the blower filter and remove the cover.

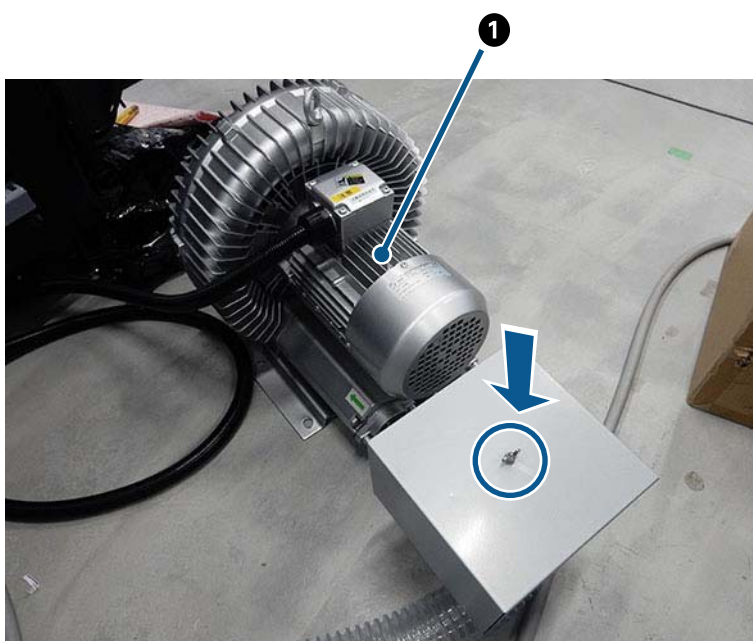


Maintenance

- 3 Remove the blower filter and replace it with a new filter.



- 4 Install the filter cover you removed so that it is parallel to the blower, and then tighten the screw.



1 Blower

Cleaning the Front Cover

The front cover becomes dirty from dust and ink mist, etc., if you continue to use the printer in this condition, the inside of the printer becomes difficult to see. If it is dirty, follow the steps below to clean.

Personal protective equipment	Protective gloves and clothing
-------------------------------	--------------------------------

Maintenance

- 1 Check that the machine is off.
- 2 Soak a soft cloth in water, wring it out thoroughly, and then wipe any dirt off of the window on the front 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.



Maintenance

- 4** Wipe the inner side 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.

Inspecting and Applying Tape to the Tension Roller

If the tape attached to the tension roller is peeling or sticking up, the fabric cannot be fed correctly, or the fabric may jam and deform the rear cover. If this occurs, cut off the affected area and re-attach so that it does not stick up. 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 to request a replacement.



- 1** Tension roller tape

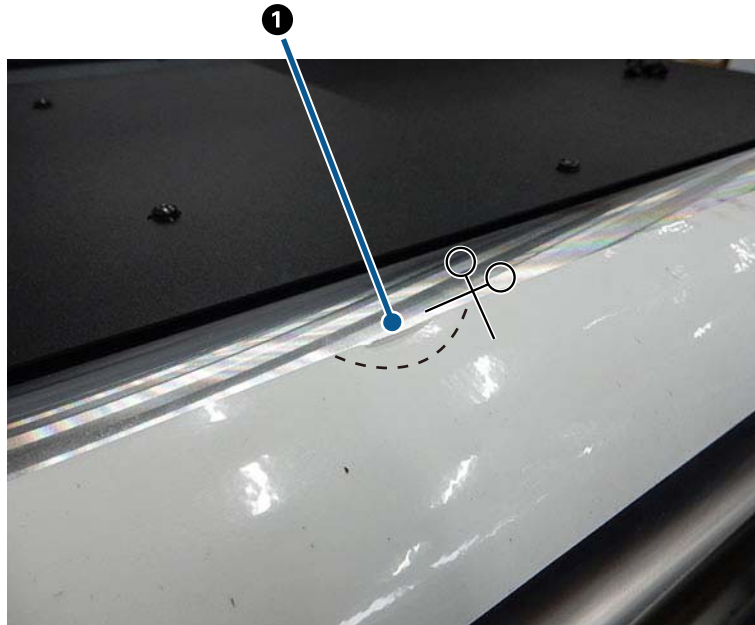
Maintenance

Personal protective equipment

Protective gloves and clothing

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

Re-attach so that there is nothing sticking up.



Note:

If the tape continues to peel or stick up after re-attaching, the tape needs to be replaced.

Contact your dealer or Epson Support to request a replacement.

Maintenance

Cleaning the Inside Light

The printer has an inside light inside the front cover and maintenance covers to make it easy to check print results and areas for maintenance. If ink mist makes the surface of the inside light dirty, it becomes dim so checking becomes difficult. If it seems dim, follow the steps below to clean it.

Personal protective equipment	Protective gloves and clothing, eye protection
-------------------------------	------------------------------------------------

1 Check that the machine is off.

2 Open the front cover.



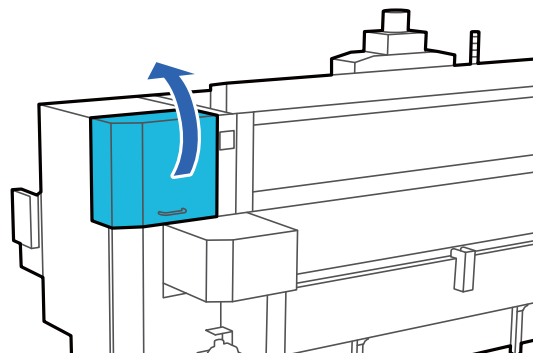
Maintenance

- 3 Soak a soft cloth in water, wring it out thoroughly, and then wipe any dirt off of the inside light surfaces shown in the illustration.

There are a total of 4 inside lights inside the front cover. Wipe the dirt from all these 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.



- 4 Close the front cover.
- 5 Open the left-side maintenance cover.



Maintenance

- 6** Soak a soft cloth in water, wring it out thoroughly, and then wipe any dirt off of the inside light surfaces shown in the illustration.

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.



- 7** Close the maintenance cover.

Replacing Consumables

Replacing the Ink Cartridges

If ink is expended, replace the ink cartridge immediately with a new one. You can check the ink level on the Home screen.

 [“Home Screen” on page 23](#)

Two ink cartridges for each color can be inserted into the printer, so a cartridge not in use can be replaced during printing.

Personal protective equipment

Protective gloves and clothing

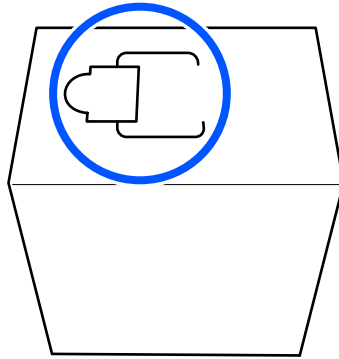
Important:

- ❑ *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.*

Maintenance

Opening and shaking

- 1 Place a new ink cartridge on a flat surface with the ink supply port slot facing up.

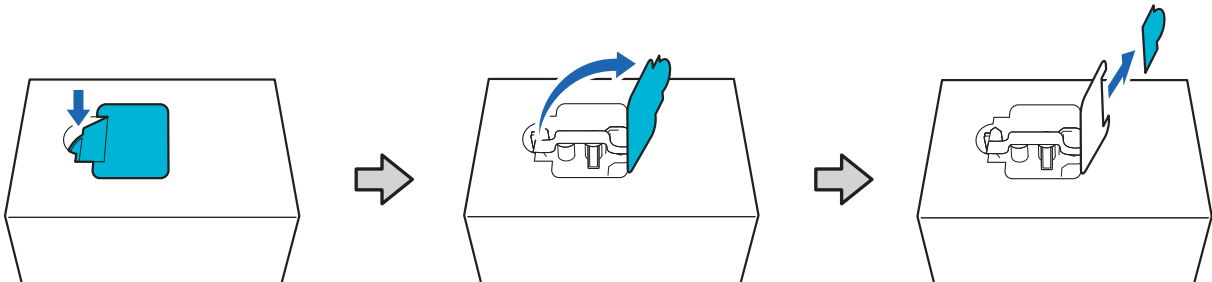


- 2 Use your hands to cut along the dashed lines of the slot to remove the top portion.

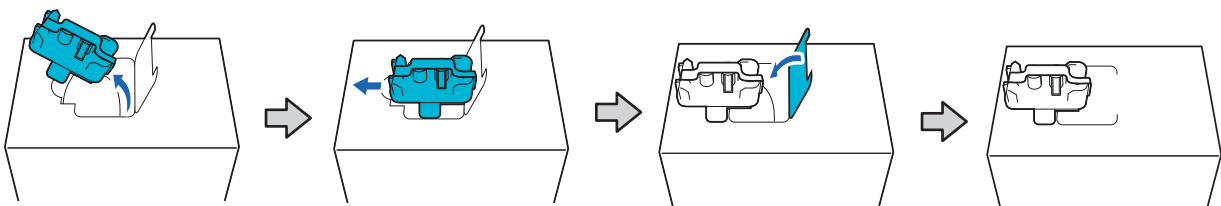


Important:

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.



- 3 Take out the ink supply port and fix it as shown in the illustration.



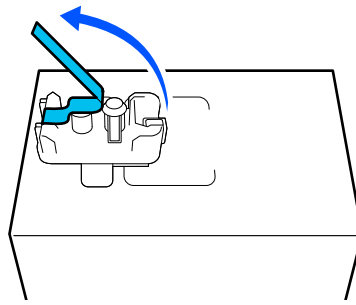
- 4 Peel the tape (yellow) from the surface of ink supply port.



Important:

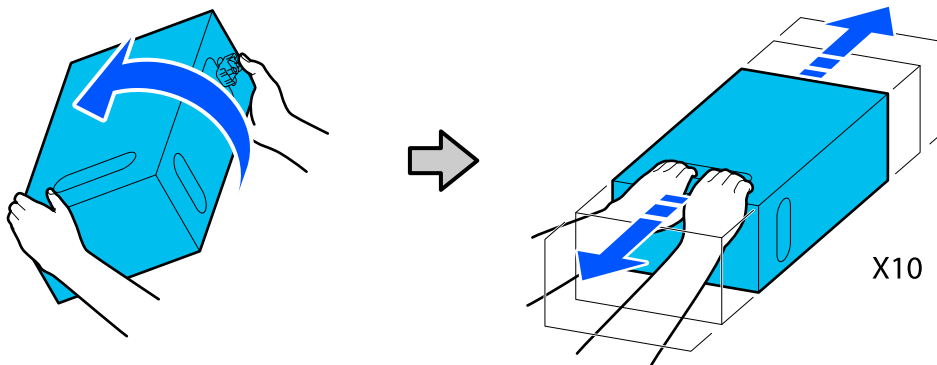
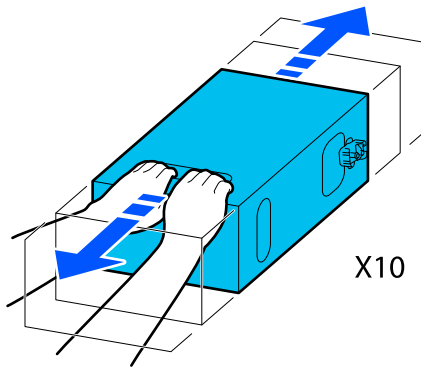
Do not touch the IC chip on the ink cartridge.

Maintenance



- 5** Place the ink cartridge on the floor so that the ink supply port is on its 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.

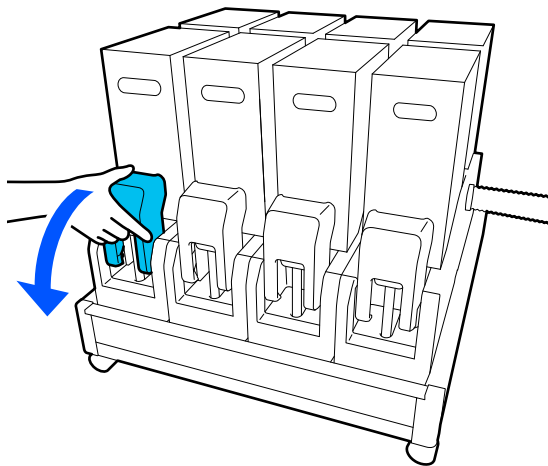
Move it back and forth at a speed of one second per complete movement.



Maintenance

Replacement

- 1 Make sure the printer is on, and then lower the ink cartridge cover of the used ink cartridge toward you.

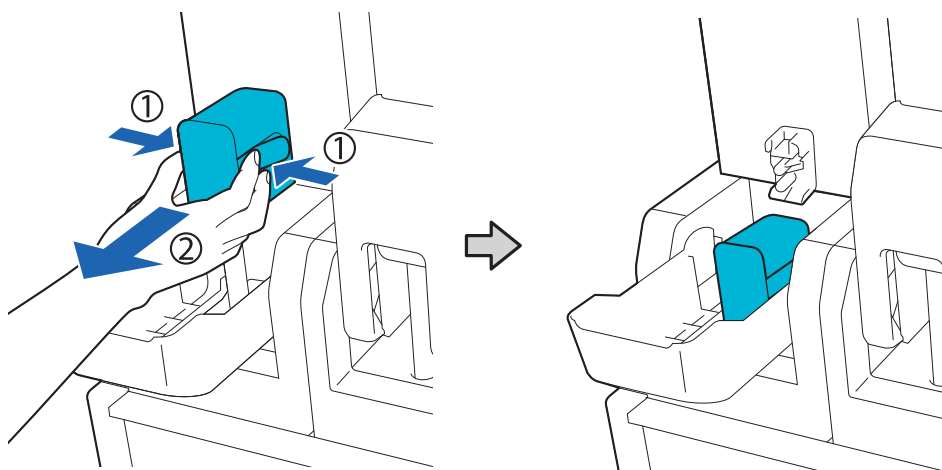


- 2 While pressing the levers on both sides of the connector, pull the connector toward you to remove it, and place the connector on the rear surface of the ink cartridge cover.



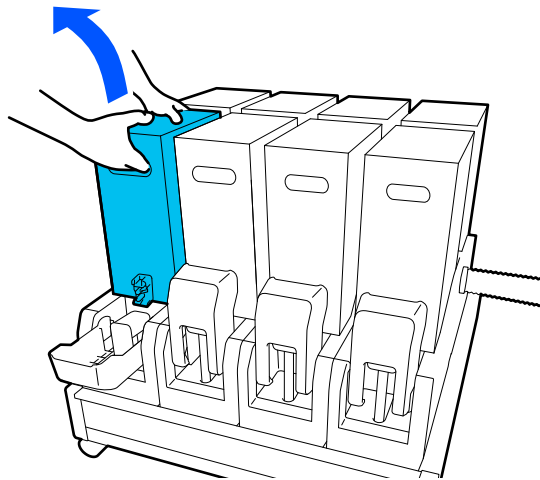
Important:

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.

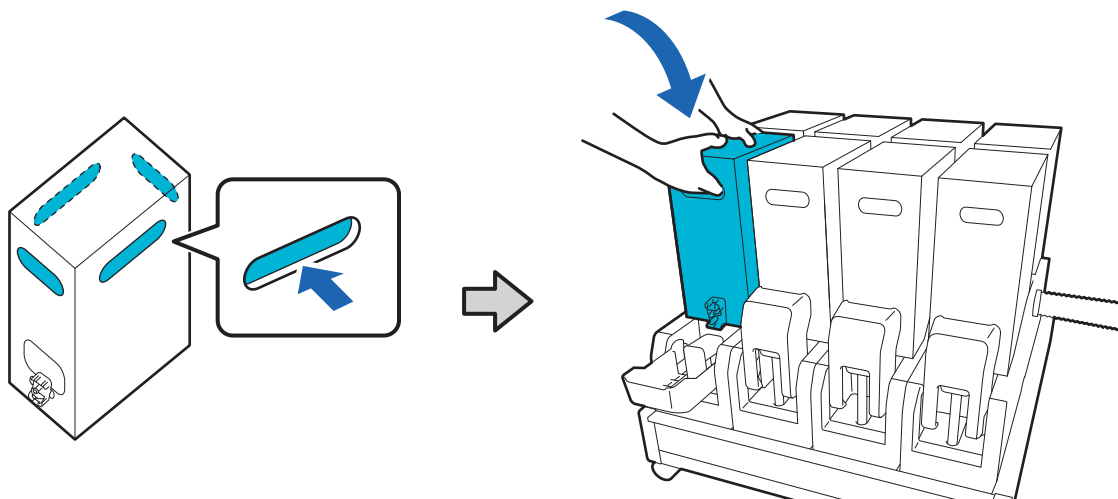


Maintenance

- 3** Remove the used ink cartridge from the ink supply unit.



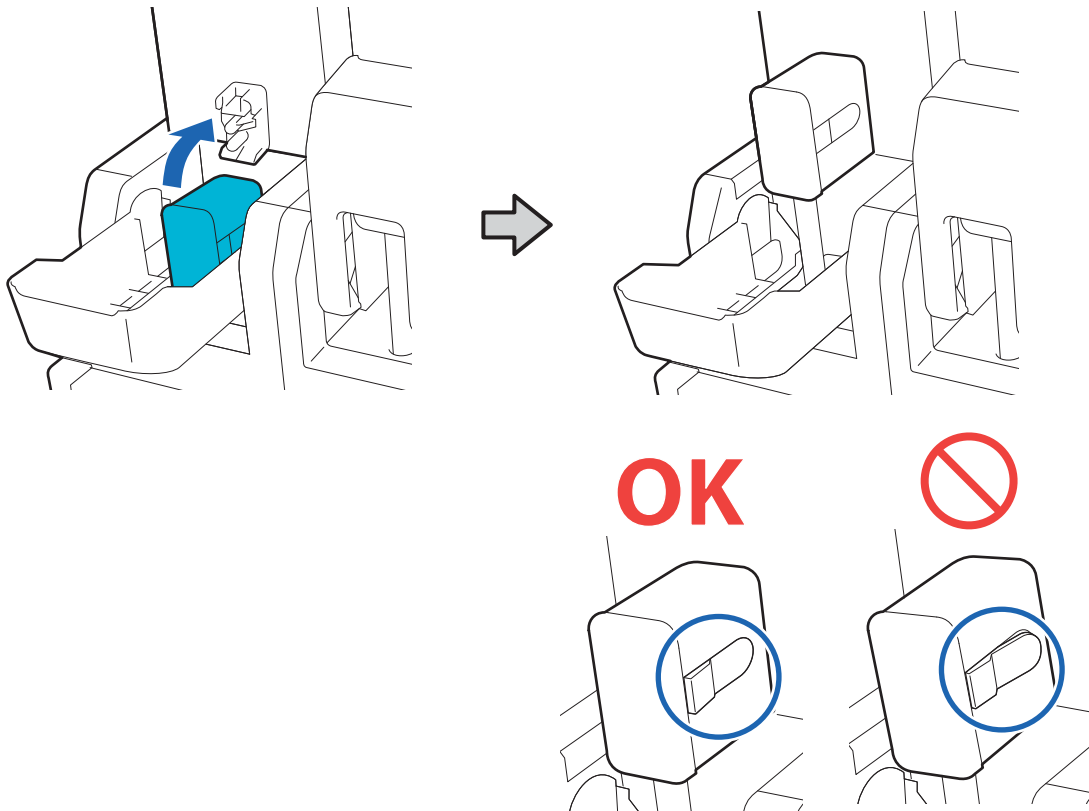
- 4** Hold the already shaken ink cartridge by opening hand holes, and then place it with the ink supply port facing the connector.



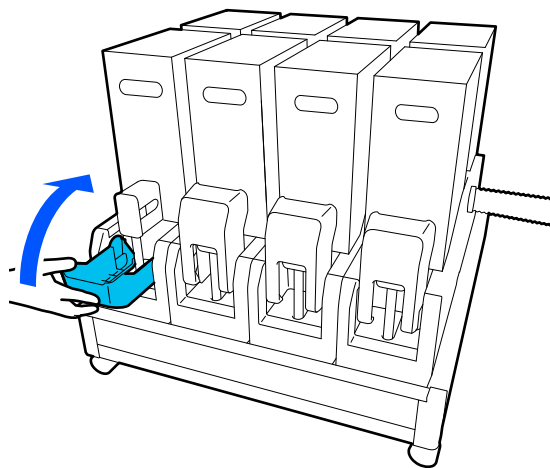
Maintenance

- 5** Install the connector to the ink supply port.

Insert the connector until you hear a click.



- 6** Raise the ink cartridge cover.



Repeat the opening, shaking, and replacement procedures to replace other ink cartridges.

Maintenance

Disposing of Waste Ink

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.

Personal protective equipment	Protective gloves and clothing
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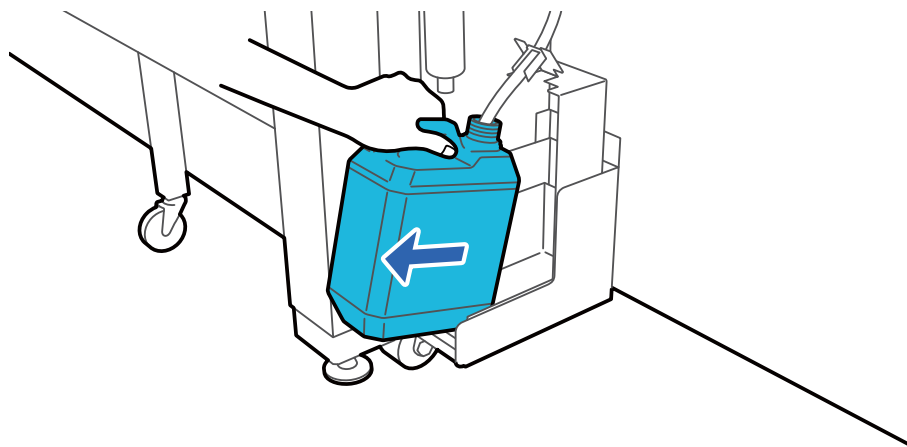


Important:

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.

1

Remove the waste ink bottle from the holder.



2

Tightly close the lid of the removed waste ink bottle.

Do not transfer the waste ink to another container; dispose of it together with the waste ink bottle following the determined method.

3

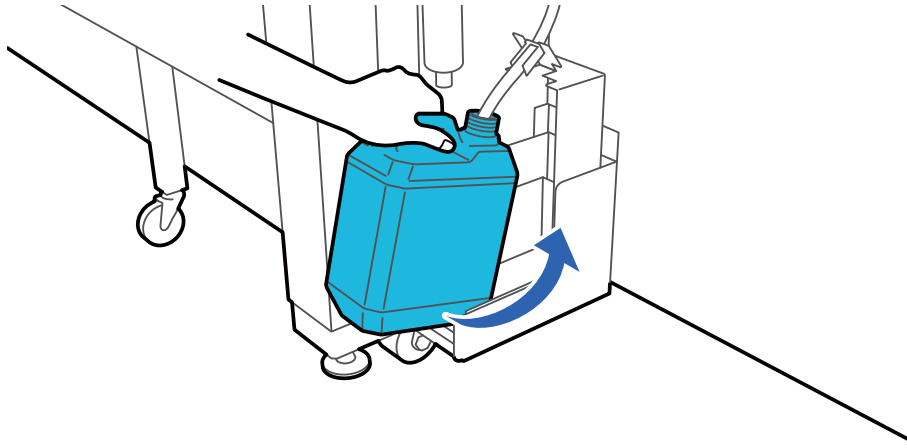
Remove the lid of the new waste ink bottle.

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.

Maintenance

- 4** 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 tube is not inserted in the bottle.



- 5** Touch the **Done** button on the control panel.

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 in the order of **Maintenance - Replace Maintenance Parts - Replace Wiper Roll** from the Maintenance screen on the control panel, and then do the replacement work. If you replace it without selecting **Replace Wiper Roll**, the wiper roll counter will not operate correctly.

- 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.

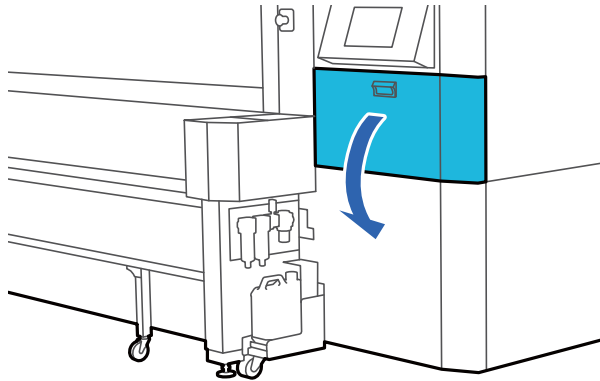
Personal protective equipment	Protective gloves and clothing, eye protection
-------------------------------	------------------------------------------------

- 1** From the Maintenance screen on the control panel, touch **Maintenance - Replace Maintenance Parts - Replace Wiper Roll**, in that order.

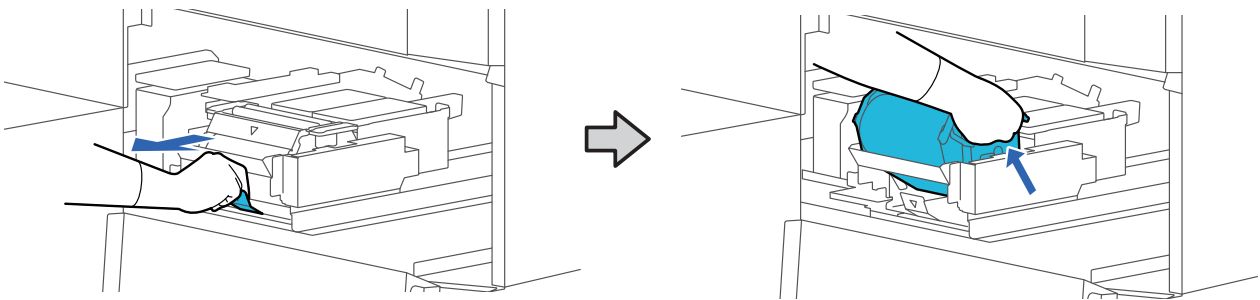
- 2** Check the on-screen message, and then touch **Start**.

Maintenance

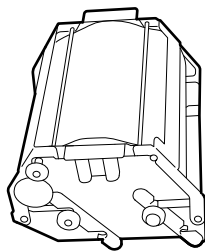
- 3** Open the right-side maintenance cover.



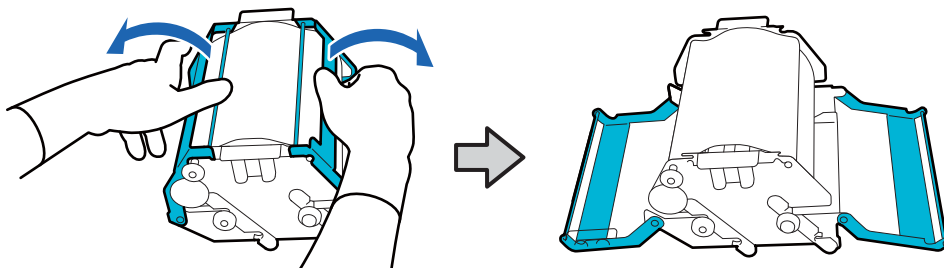
- 4** Pull the lock lever, and then pull the wiper unit out at an upward angle.



- 5** Place the wiper unit on a flat place oriented as shown in the illustration.

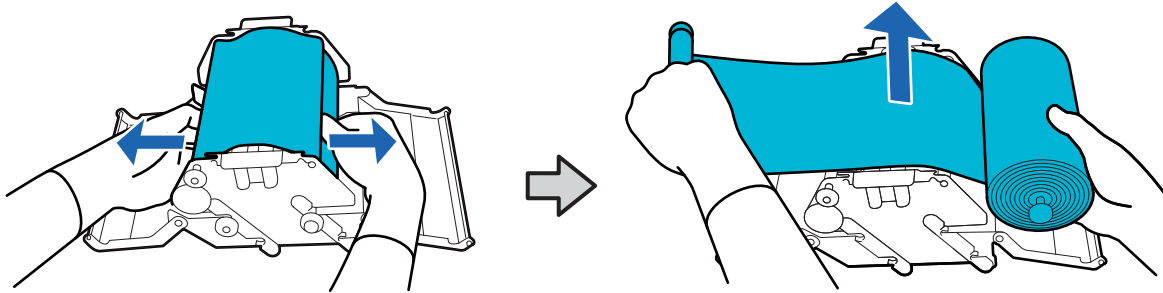


- 6** Open the left and right covers outwards.



Maintenance

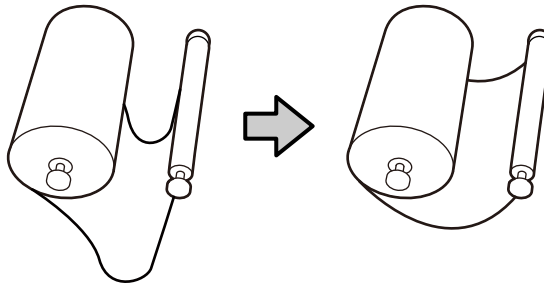
7 Hold the spindle and roll and pull them out, and remove the wiper roll.



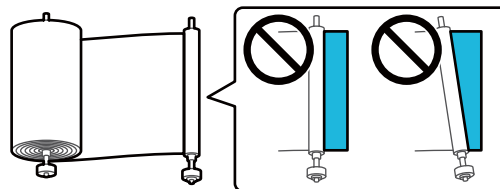
8 Install a new wiper roll.

! **Important:**

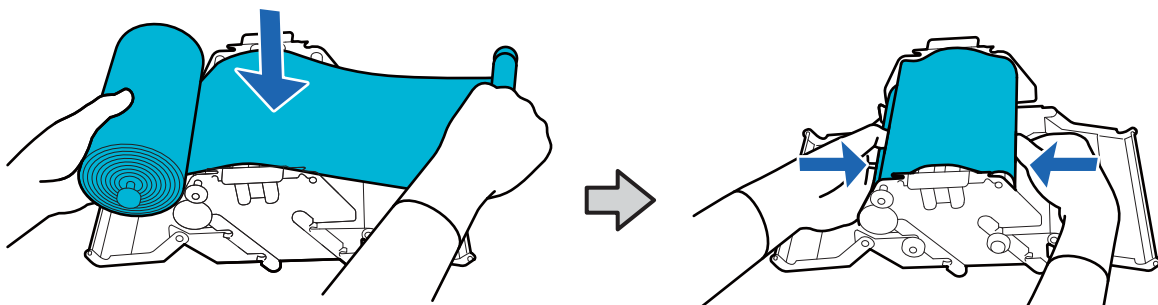
- ❑ Install the wiper roll so it does not sag. If it sags excessively, eliminate the sag.



- ❑ Check that the wiper roll spindle is at the start end of the fabric. If the spindle is not at the start end of the fabric or is diagonally installed, the printer may not be able to function properly.

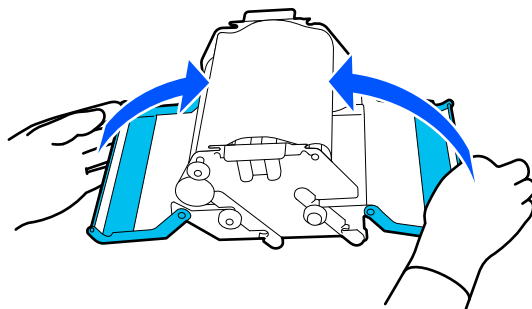


Insert the spindle into the groove on the wiper unit, and press inward until you hear a click.

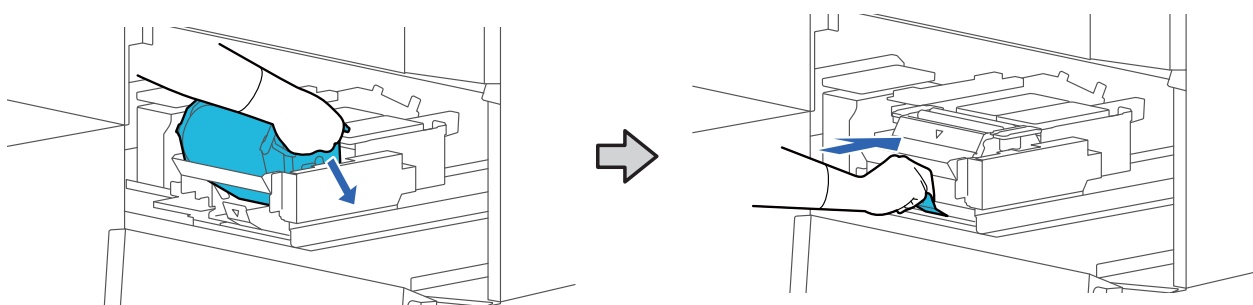


Maintenance

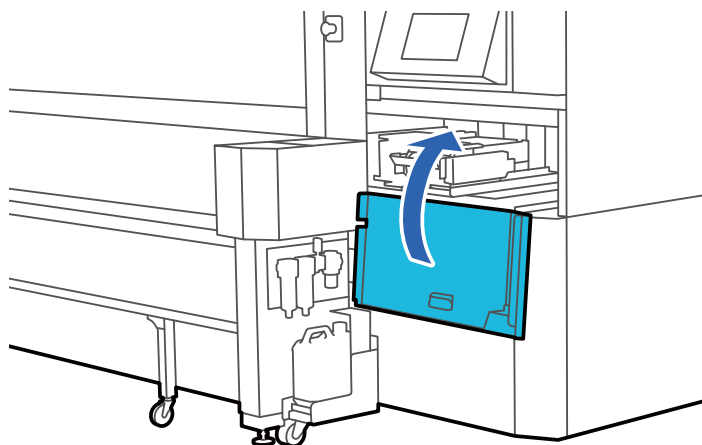
- 9 Close the left and right covers.



- 10 Install the wiper unit at an angle from above the printer, and then press the lock lever.



- 11 Close the maintenance cover.



- 12 Check the on-screen message, and then touch the **Yes** button.

Replacing the Flushing Pad

If the flushing pad is extremely dirty or if it is deformed, follow the steps below to replace it with a new flushing pad.

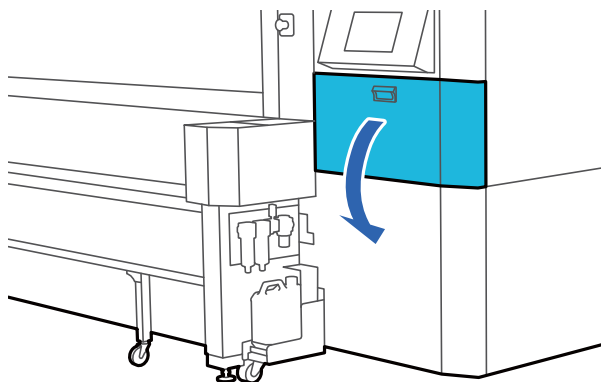
Maintenance

There is one flushing pad inside the left and right maintenance covers. When replacing them, replace them both at the same time.

Personal protective equipment

Protective gloves and clothing, eye protection

- 1 From the Maintenance screen on the control panel, touch **Maintenance - Replace Maintenance Parts - Replace Flushing Pad**, in that order.
- 2 Open the right-side maintenance cover.



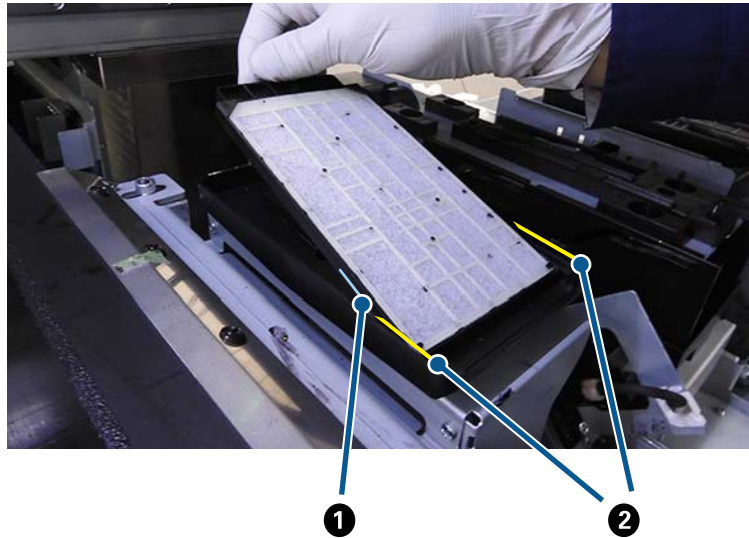
- 3 Lift the tab on the rear of the flushing pad towards you and remove it.
Dispose of the flushing pad in the proper manner.



Maintenance

4 Attach the new flushing pad.

Align the protrusions of the flushing pad with the guides on the flushing box.

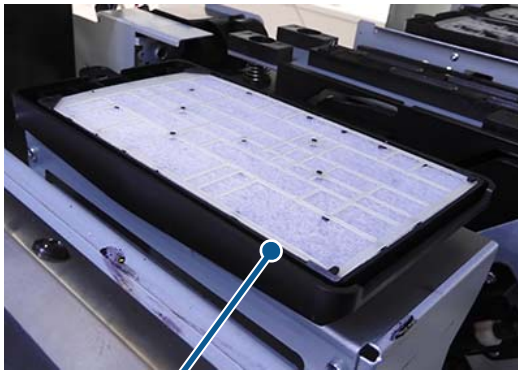


- ① Protrusions
- ② Guides



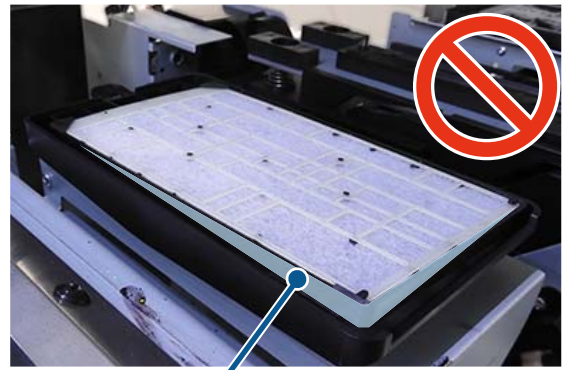
Important:

Make sure that the flushing pad is not floating up diagonally. Printing with it still floating up can cause it to collide with the print head and cause a failure.



①

- ① Not floating
- ② Floating



②

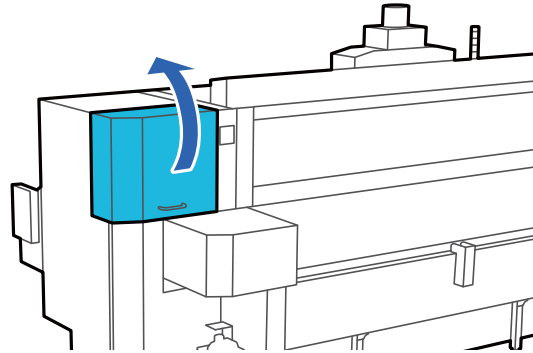
5 Close the maintenance cover.

6 From the Maintenance screen on the control panel, touch **Daily - Around the Head Cleaning**, in that order.

Move the print head to replace the flushing pad on the left.

Maintenance

- 7 Check the on-screen message, and then touch **Start**.
- 8 Confirm that the print head has moved to the right side, and then open the left-side maintenance cover.



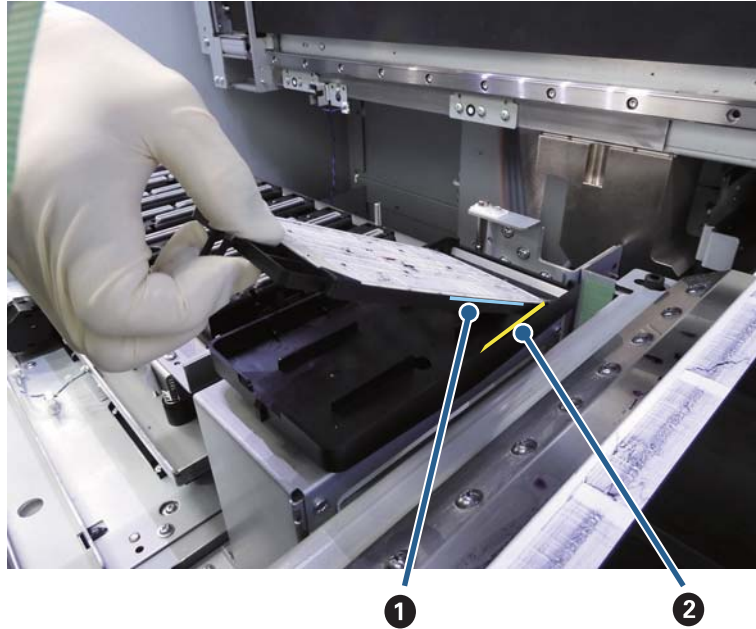
- 9 Lift the tab on the front of the flushing pad towards you and remove it.
Dispose of the flushing pad in the proper manner.



Maintenance

10 Attach the new flushing pad.

Align the protrusions of the flushing pad with the guides on the flushing box.



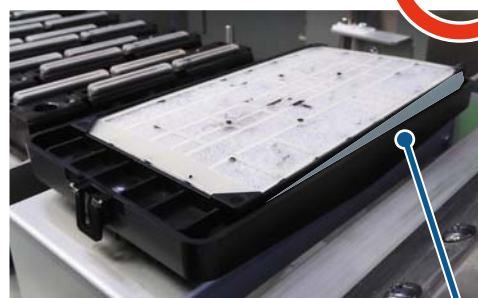
- ① Protrusions
- ② Guides

! **Important:**

Make sure that the flushing pad is not floating up diagonally. Printing with it still floating up can cause it to collide with the print head and cause a failure.



①



②

- ① Not floating
- ② Floating

11 Close the maintenance cover, and then touch the **Complete** button on the control panel.

Maintenance

Replacing the Cleaning Pad

If the cleaning pad is extremely dirty or if it is deformed, follow the steps below to replace it with a new cleaning pad.

There are two cleaning pads inside the right-side maintenance cover. When replacing them, replace them both at the same time.

Personal protective equipment	Protective gloves and clothing, eye protection
-------------------------------	------------------------------------------------

1 From the Maintenance screen on the control panel, touch **Maintenance - Replace Maintenance Parts - Replace Cleaning Pad**, in that order.

2 Lift the tab on the rear of the cleaning pad on the top of the wiper roll unit towards you and remove it.

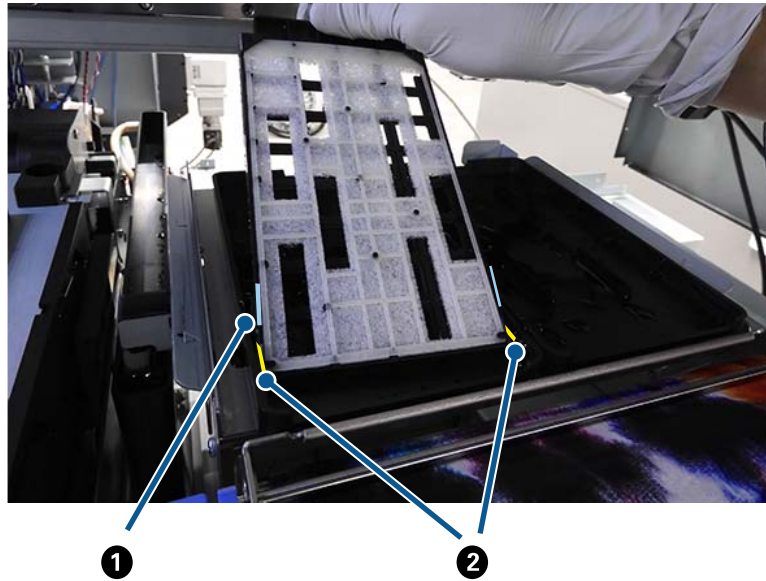
Dispose of the cleaning pad in the proper manner.



Maintenance

3 Attach a new cleaning pad.

Align the protrusions of the cleaning pad with the guides on the top of the wiper roll unit.

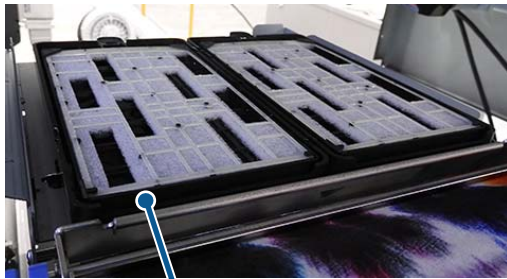


- ❶ Protrusions
- ❷ Guides



Important:

Make sure that the cleaning pad is not floating up diagonally. Printing with it still floating up can cause it to collide with the print head and cause a failure.



❶



❷

- ❶ *Not floating*
- ❷ *Floating*

4 Replace the other cleaning pad in the same way.

5 Close the maintenance cover.

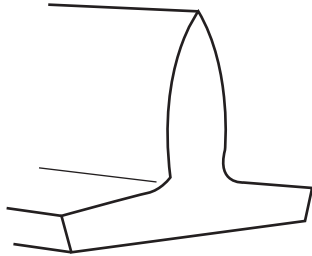
Replacing the Washing Scraper

Depending on the washing scraper in use, the timing and method for replacement vary.

Maintenance

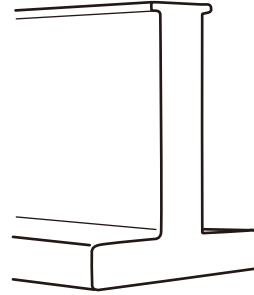
If you are using the ML-8000 or if you are using the ML-8000U with the washing scraper (C13S210132), see the following.

 ["When Using the Washing Scraper \(C13S210132\)" on page 252](#)



If you are using the ML-8000U with the washing scraper 2 (C13S210167), see the following.

 ["When Using the Washing Scraper 2 \(C13S210167\)" on page 256](#)



When Using the Washing Scraper (C13S210132)

When the washing scraper is worn down

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 448](#)

When a message is displayed indicating the time to replace the washing scraper 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 in the order of **Maintenance - Replace Maintenance Parts - Replace Washing Scraper** from the Maintenance screen on the control panel, and then do the replacement work. 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

Replace the washing scraper with a new one immediately. Failure to perform replacement may result in water droplets remaining after belt cleaning. Make sure you use a replacement washing scraper for this printer.

Replacement Procedure

Required items	Protective gloves, protective clothing, a new washing scraper (C13S210132), hex wrench (width: 2.5 mm (0.1 inches))
----------------	---------------------------------------------------------------------------------------------------------------------

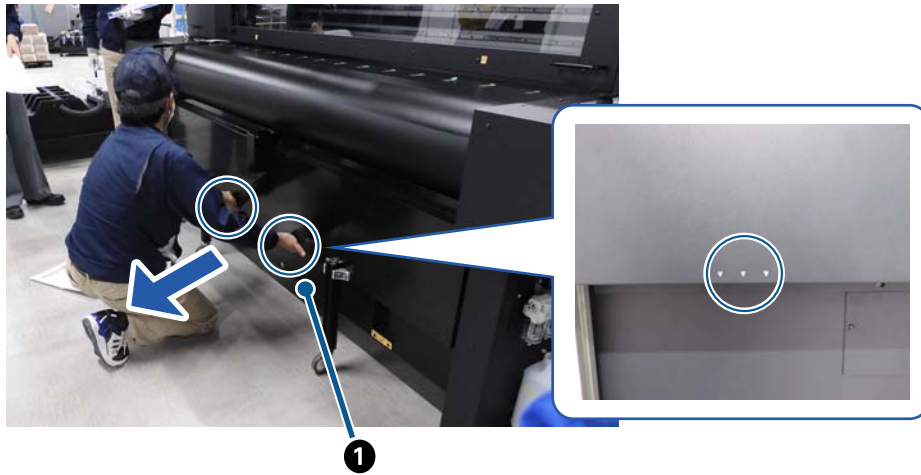
1

From the Maintenance screen on the control panel, touch **Maintenance - Replace Maintenance Parts - Replace Washing Scraper**, in that order.

Maintenance

- 2 Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

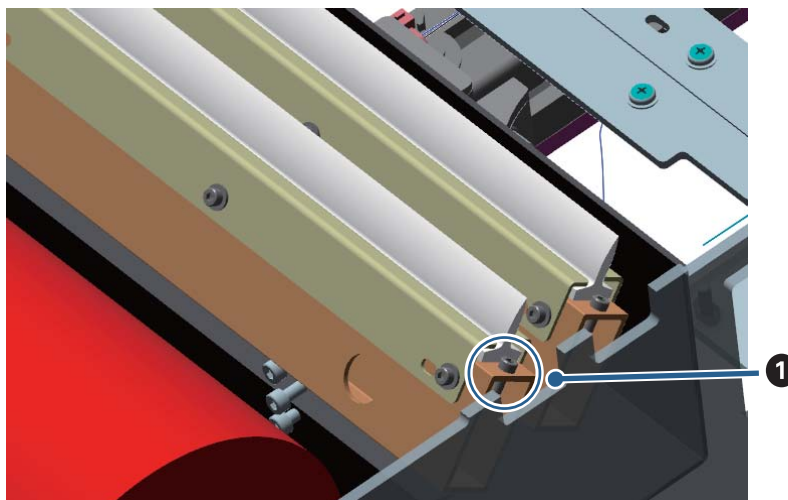
Hold the handles on the front of the belt cleaning unit to pull it out.



- 1 Handles

- 3 Remove the slide prevention screw on the right side of the washing scraper.

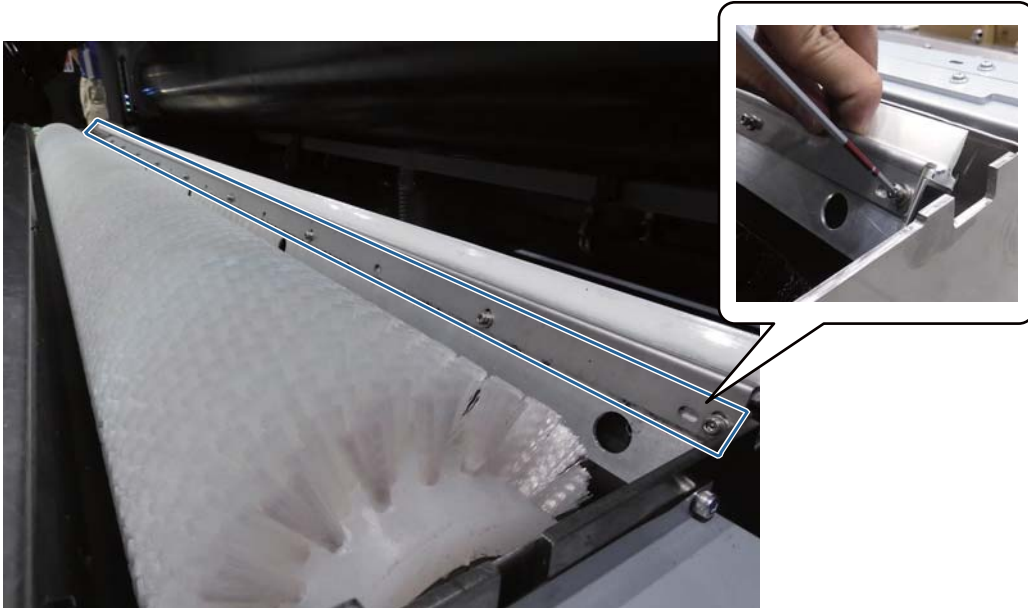
When using the ML-8000, remove the slide prevention screw on the front of the washing scraper.



- 1 Slide prevention screw

Maintenance

- 4 Using the hex key (width: 2.5 mm), loosen the 12 screws that secure the whole scraper.



- 5 Lifting the metal plate upwards, pull out the scraper from the right side of the machine.
If lint has become fused making it difficult to pull out, first remove the lint.



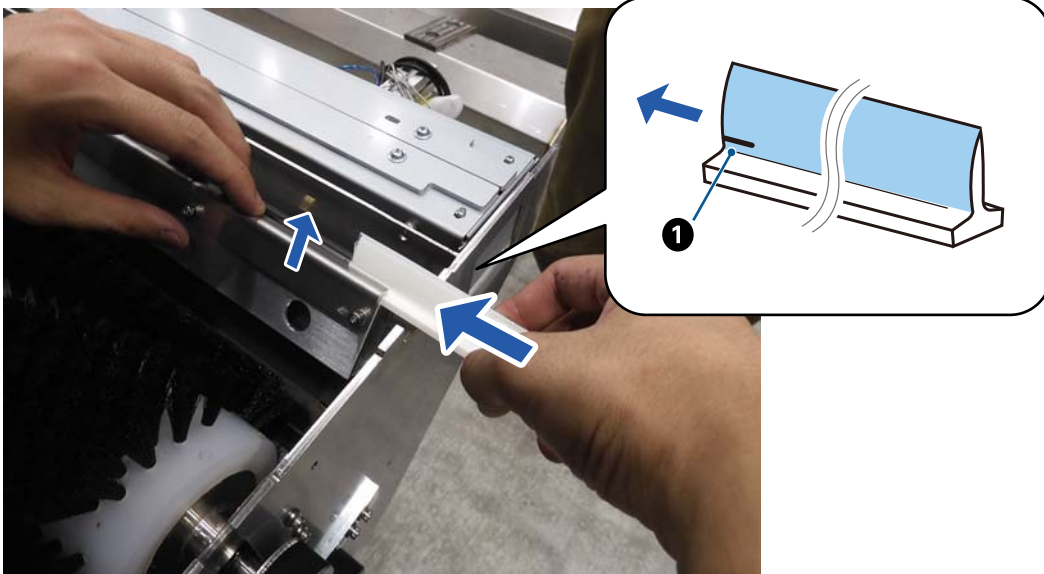
When using the ML-8000U, go to step 7.

- 6 Remove the rear scraper in the same way. (ML-8000 only)

- 7 Insert the new scraper with the mark facing forward while lifting the metal plate up.

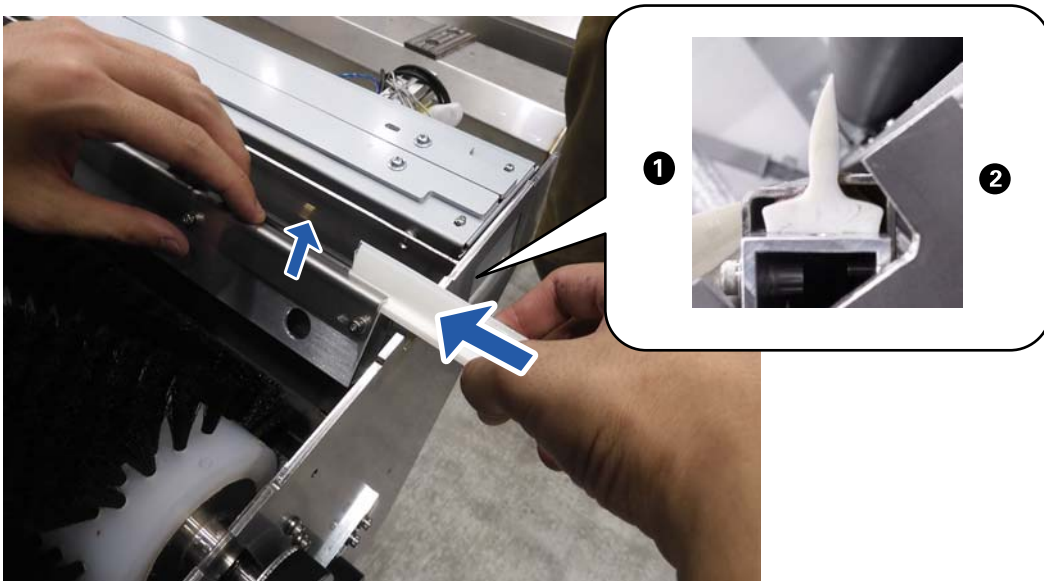
! **Important:**
Inserting it with the marked side facing the back may cause an abnormal noise or leave water droplets on the belt.

Maintenance



① Markings

If the mark is difficult to see, insert the scraper with the bulge in the scraper's cross section facing the front.



① Front

② Back

8 Using the hex key (width: 2.5 mm), tighten the 12 screws that secure the scraper.
Push down on the metal plate as you tighten the screws.

9 Tighten the slide prevention screw on the right side of the scraper.

10 In the same way, replace the front scraper with a new scraper. (ML-8000 only)

Maintenance

11 Push the belt cleaning unit back to its original position.

12 Touch **Complete** on the control panel.

The washing scraper counter will be cleared.

When Using the Washing Scraper 2 (C13S210167)

The washing scraper 2 can be used on both sides.

During replacement, if the reverse side of the washing scraper has not been used, then turn it over and reattach it. If both sides have been used, or if water droplets remain even after turning it over, replace it with a new one.


When a message is displayed indicating the time to replace the washing scraper is approaching, and you have used both sides of the washing scraper, prepare a new washing scraper as soon as possible.

If the washing scraper is worn down, turn over the washing scraper and reattach it, or replace it. When a message is displayed indicating it is time to replace the washing scraper, replace the washing scraper even if the reverse side has not been used.

When turning the washing scraper over and reattaching it, refer to the following.

 [“Turning over and reattaching” on page 256](#)

When replacing the washing scraper with a new one, refer to the following. Make sure you use a replacement washing scraper for this printer.

 [“Replacing with a new one” on page 258](#)

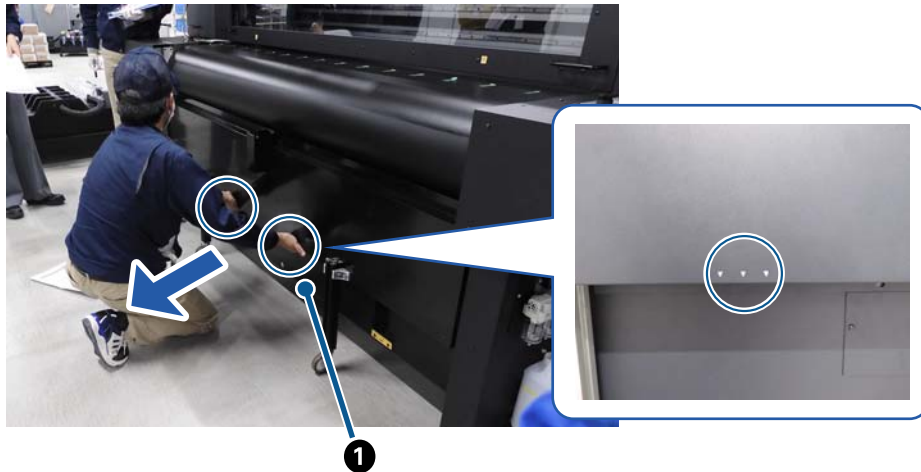
Turning over and reattaching

Required Items	Protective gloves, protective clothing, hex wrench (width: 2.5 mm (0.1 inches))
<p>1 From the Maintenance screen on the control panel, touch Maintenance - Replace Maintenance Parts - Replace Washing Scraper, in that order.</p>	

Maintenance

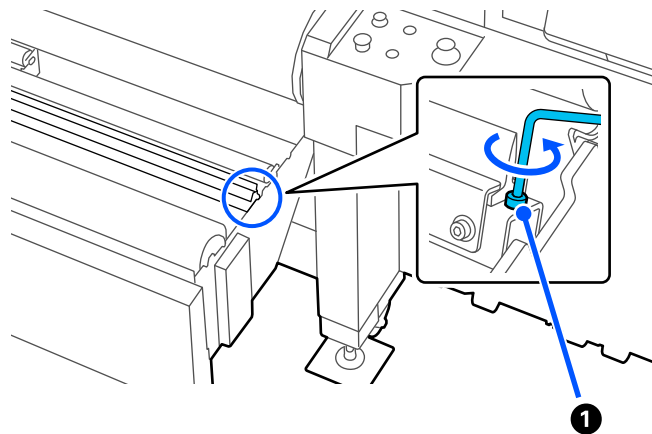
- 2** Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

Hold the handles on the front of the belt cleaning unit to pull it out.



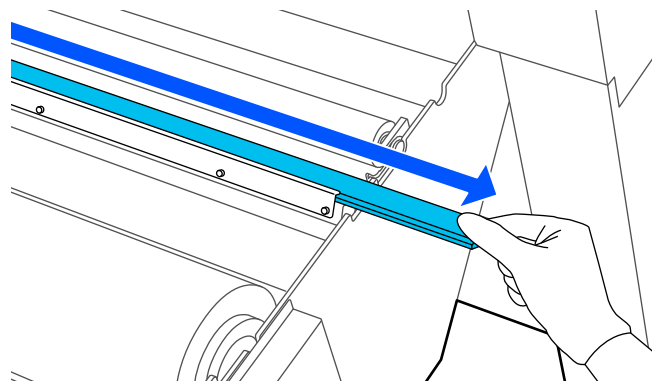
- 1** Handles

- 3** Loosen and remove the slide prevention screw on the right side of the washing scraper with a hex wrench.



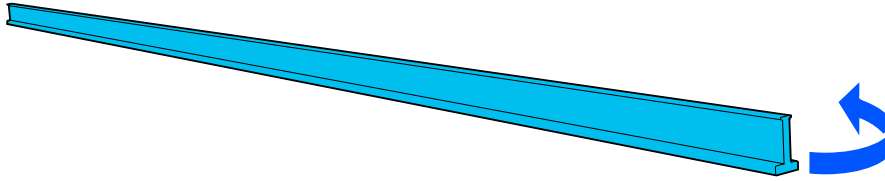
- 1** Slide prevention screw

- 4** Pull out the washing scraper from the right side of the machine.

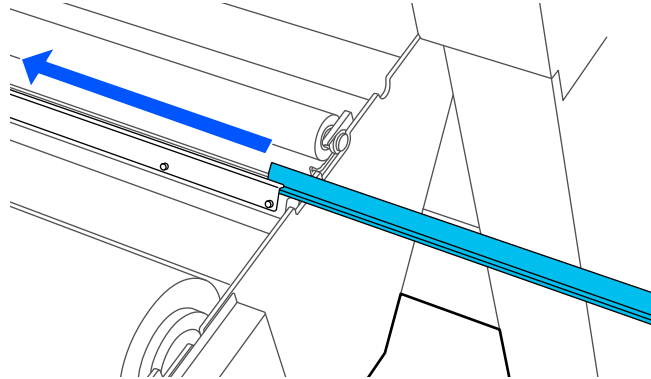


Maintenance

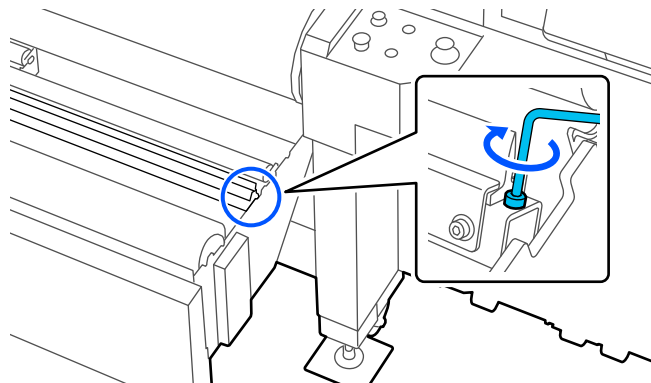
- 5 Turn over the removed washing scraper.



- 6 Insert the washing scraper from the right side of the belt cleaning tank.



- 7 Tighten the slide prevention screw on the right side of the washing scraper with a hex wrench.



- 8 Push the belt cleaning unit back to its original position.

- 9 Confirm the message on the control panel and touch the **Complete** button.

The Washing Scraper counter will be cleared.

Replacing with a new one

Required Items

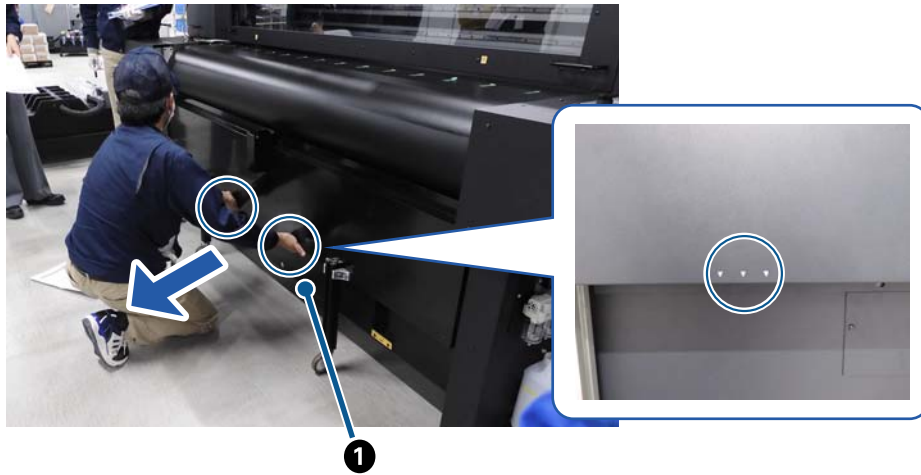
Protective gloves, protective clothing, a new washing scraper 2 (C13S210167), hex wrench (width: 2.5 mm (0.1 inches))

- 1 From the Maintenance screen on the control panel, touch **Maintenance - Replace Maintenance Parts - Replace Washing Scraper**, in that order.

Maintenance

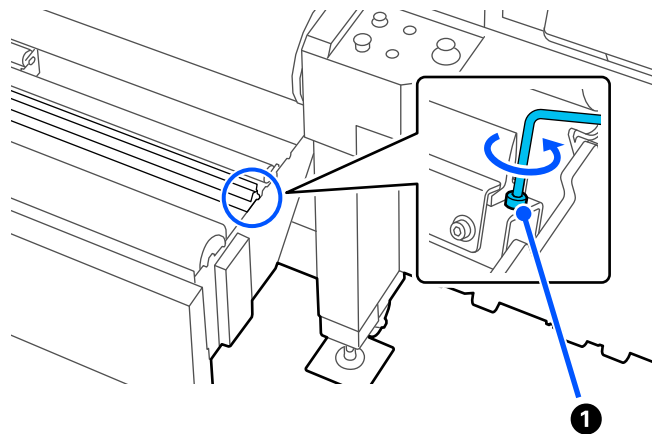
- 2** Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

Hold the handles on the front of the belt cleaning unit to pull it out.



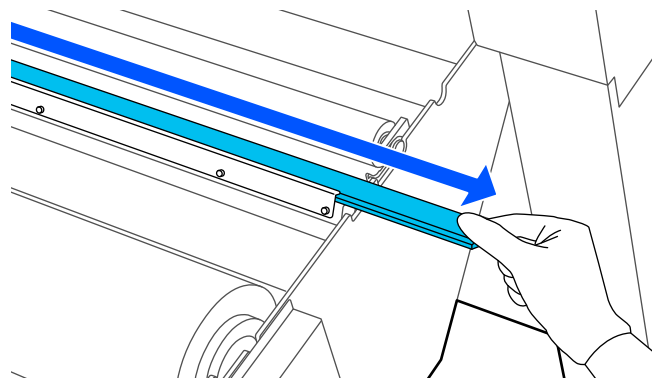
- 1** Handles

- 3** Loosen and remove the slide prevention screw on the right side of the washing scraper with a hex wrench.



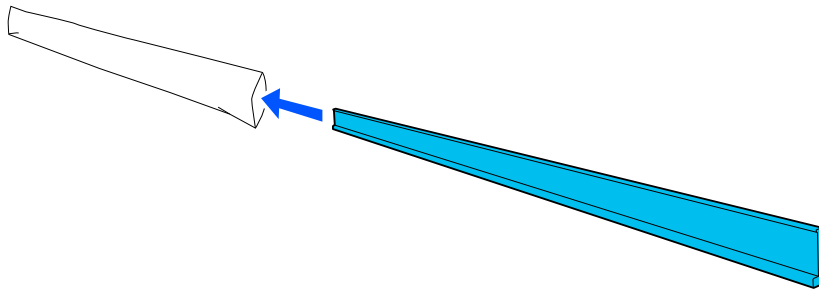
- 1** Slide prevention screw

- 4** Pull out the washing scraper from the right side of the machine.

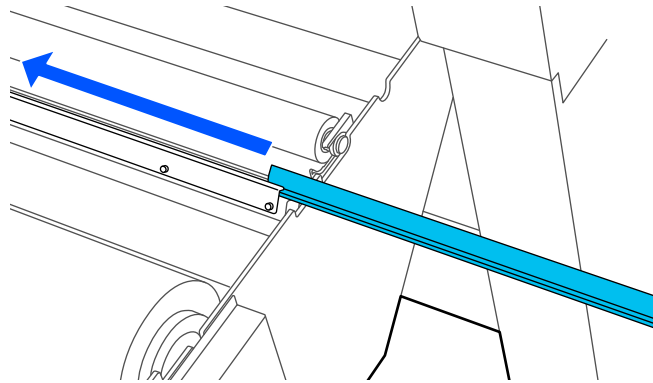


Maintenance

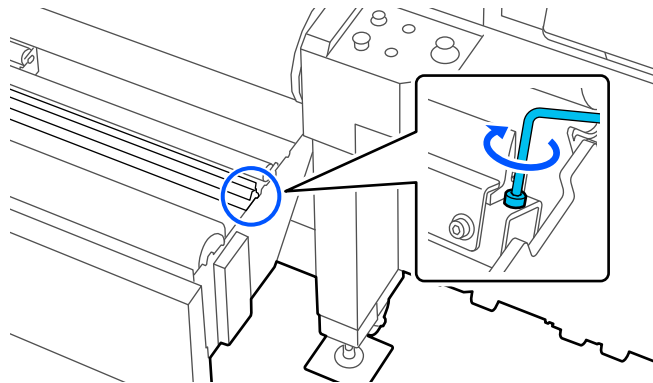
- 5 Place the used washing scraper in the bag of the new washing scraper.



- 6 Insert the washing scraper from the right side of the belt cleaning tank.



- 7 Tighten the slide prevention screw on the right side of the washing scraper with a hex wrench.



- 8 Push the belt cleaning unit back to its original position.

- 9 Confirm the message on the control panel and touch the **Complete** button.

The Washing Scraper counter will be cleared.

Maintenance

Replacing the Sponge Roller (ML-8000U Only)

- ❑ **When water droplets remain on the belt even after performing sponge roller drying**

Replace the sponge roller with a new one immediately.

Make sure you use a replacement sponge roller for this printer.

 [“Options and Consumable Products” on page 448](#)

- ❑ **When a message is displayed indicating the time to replace the sponge roller is approaching**

Prepare a new sponge roller 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 Sponge Roller** from the setup menu, and then replace the part. If you replace it without selecting **Replace Sponge Roller**, the sponge roller counter will not operate correctly.

- ❑ **When a message is displayed indicating it is time to replace the sponge roller**

Replace the sponge roller with a new one immediately. Failure to perform replacement may result in water droplets remaining after belt cleaning. Make sure you use a replacement sponge roller for this printer.

Note:

We recommend identifying the cause of water droplets remaining on the belt before making replacements.

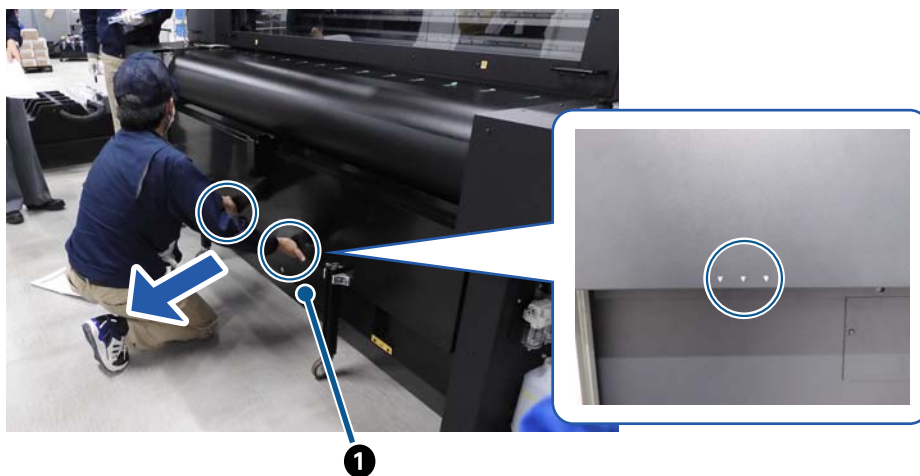
 [“Water droplets remain on the belt after belt cleaning” on page 442](#)

Personal protective equipment

Protective gloves and clothing, eye protection

- 1 Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

Hold the handles on the front of the belt cleaning unit to pull it out.



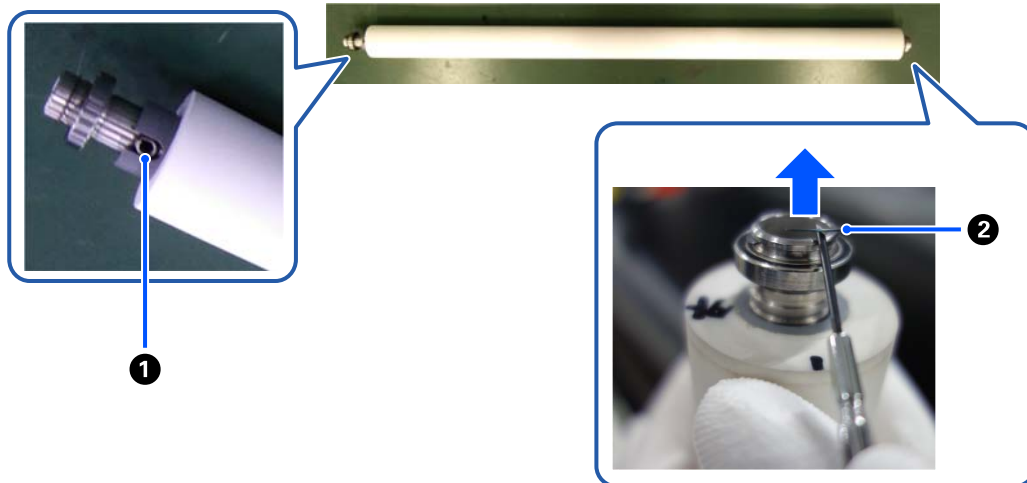
① Handles

Maintenance

- 2** Pull the sponge roller toward you to remove it.



- 3** Remove the stop ring attached to the opposite side of the shaft stopper.
Insert a screwdriver or similar tool into the slit in the stop ring and push up to remove it.



- ① Stopper
- ② Stop ring

Maintenance

- 4** Remove the bearing.



- 1** Bearing

- 5** Remove the remaining stop ring.

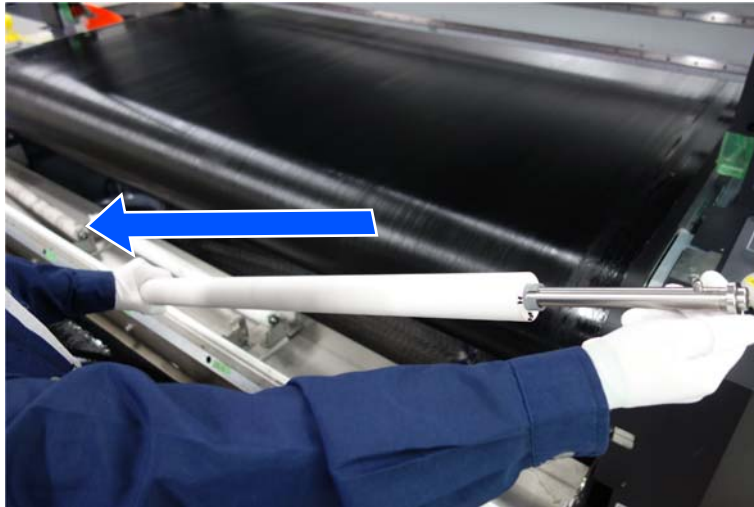
Insert a screwdriver or similar tool into the slit in the stop ring and push up to remove it.



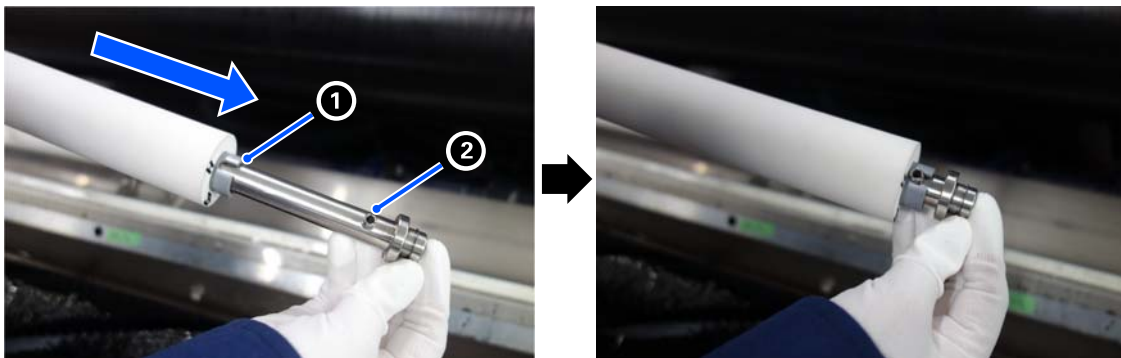
- 1** Stop ring

Maintenance

- 6** Remove the sponge roller from the shaft.



- 7** Insert the shaft into the new sponge roller until the shaft stopper fits into the notch in the sponge roller.



- ① Notch
- ② Stopper

- 8** Attach the stop ring provided with the new sponge roller at the position on the shaft shown in the photo (innermost groove).



Maintenance

- 9** Install the bearing onto the shaft.



- 10** Install the remaining stop ring supplied with the new sponge roller so that it overlaps with the bearing and there are no gaps between them.



Maintenance

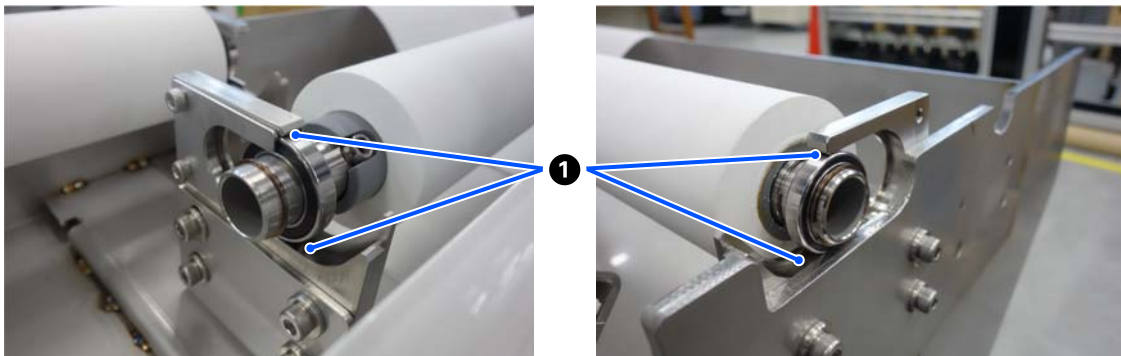
1 Stop ring



1 Stopper

11

Place the sponge roller so that the left and right bearings fit into the grooves in the installation area.



1 Grooves

12

Push the sponge roller back until it clicks into place.



Maintenance

- 13** Push the belt cleaning unit back to its original position.

Other Maintenance

Periodically Shaking the Ink Cartridges

After installing an ink cartridge in the printer, a shake message is displayed on the control panel screen at the following intervals.

- Pigment ink (Red): Once every three weeks
- Pigment ink (except for Red) and dispersal ink: Once a month
- Reactive ink and acid ink: Shaking is not required

If the message appears, remove the ink cartridge immediately and shake it.

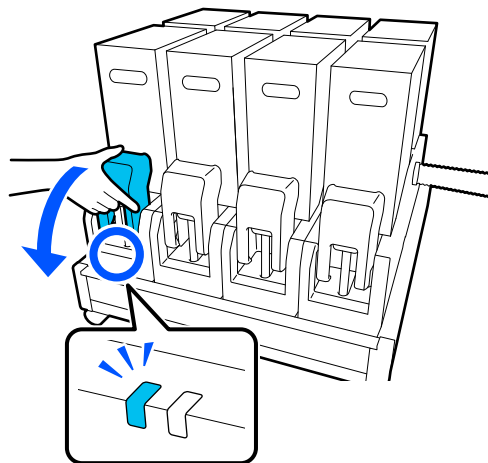
The shaking method after installation differs from when shaking the ink before installing. Follow the steps below for shaking.

Personal protective equipment

Protective gloves and clothing

- 1** Make sure the printer is on, and then lower the ink cartridge cover of the ink cartridge you need to shake.

The ink cartridge with a flashing left (blue) lamp is the one that needs to be shaken.



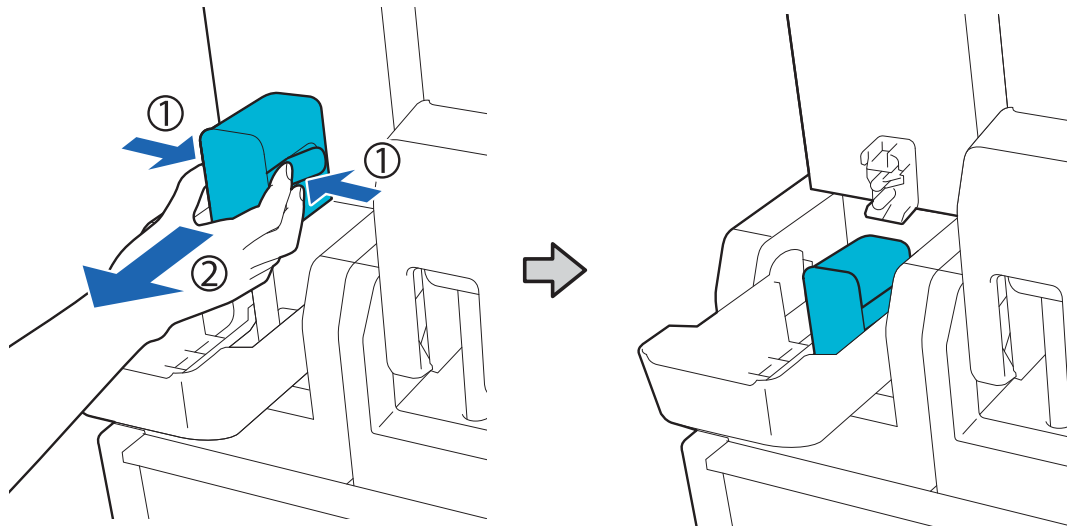
- 2** While pressing the levers on both sides of the connector, pull the connector toward you to remove it, and place the connector on the rear surface of the ink cartridge cover.



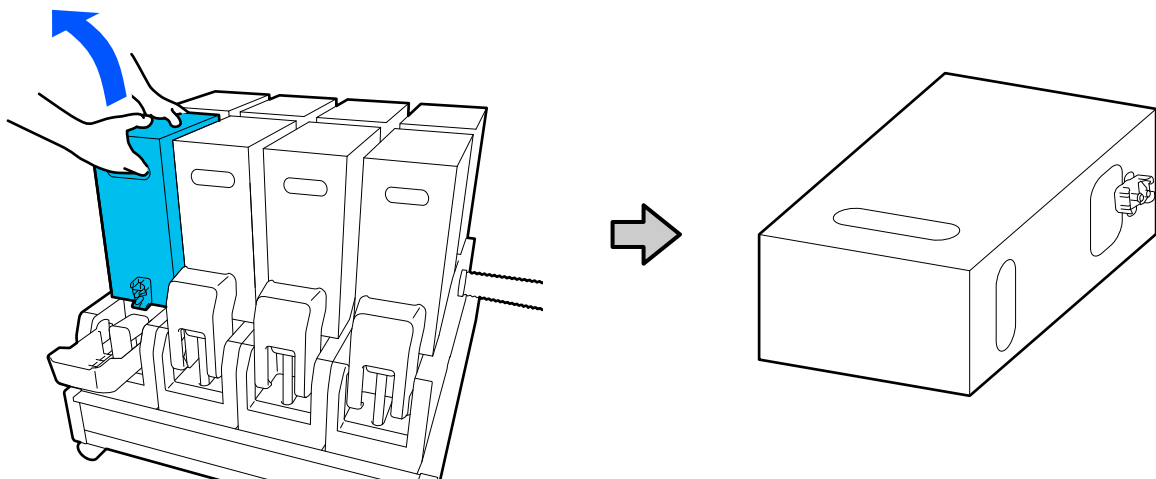
Important:

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.

Maintenance



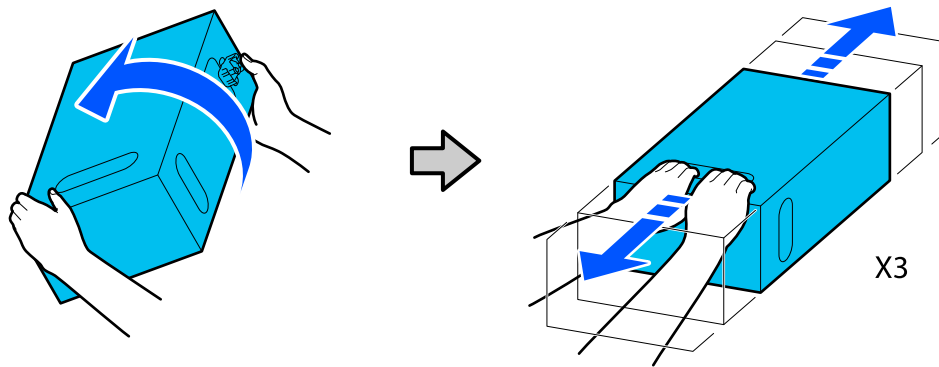
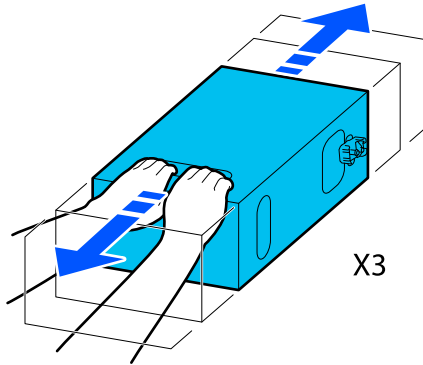
- 3** Remove the ink cartridge from the ink supply unit, and place it on a flat surface with the ink supply port facing the side.



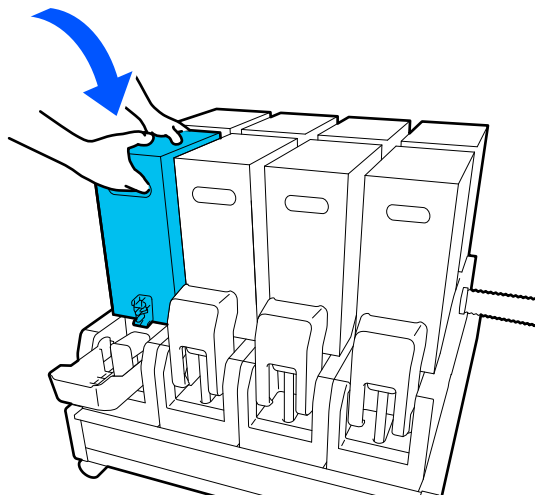
Maintenance

- 4 Move it back and forth along the length of its long side three 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.



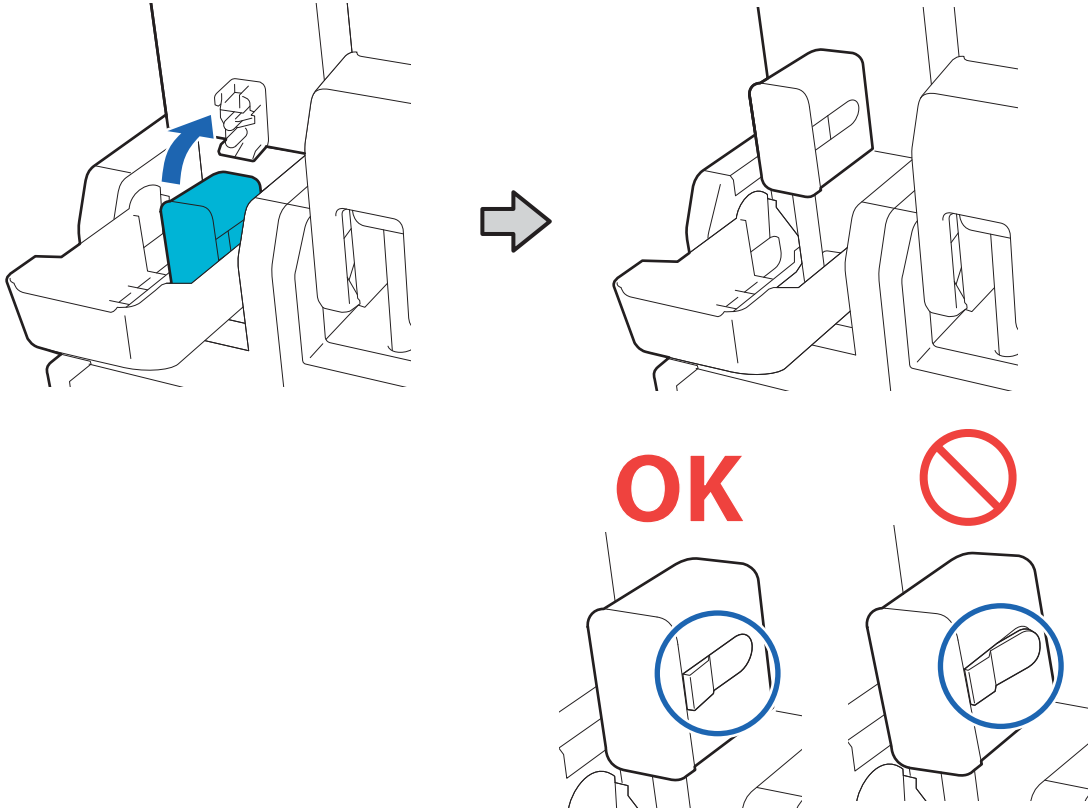
- 5 Place the shaken ink cartridge such that the ink supply port faces the connector.



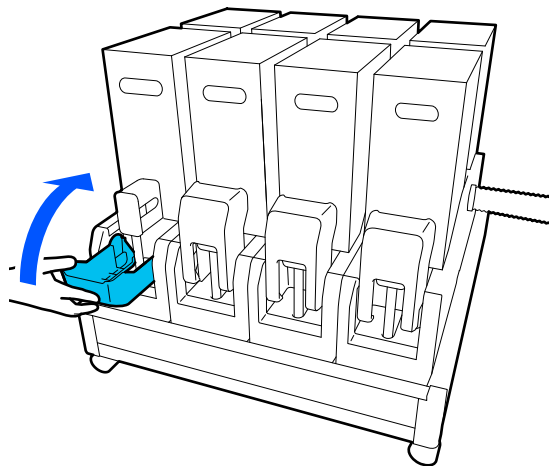
Maintenance

- 6** Install the connector to the ink supply port.

Insert the connector until you hear a click.



- 7** Raise the ink cartridge cover.



Repeat the same procedure to shake other ink cartridges.

Cleaning the Mist Collection Fan

If lint or dirt builds up on the mist collection fan, the fan will stop, and a message prompting you to clean the fan is displayed on the control panel screen.


Maintenance

If the fan stops, the interior or the printer may get dirty due to the mist, leading to fabric stains and clogged nozzles. Follow the steps below to perform cleaning.

Personal protective equipment	Protective gloves and clothing, eye protection
-------------------------------	------------------------------------------------

1 Remove the fabric loaded in the printer.

Roll the fabric to the back of the printer. If there is fabric under the mist collection fan, the fabric may become dirty if lint that has been soiled by mist falls off during cleaning.

 [“When Removing the Fabric” on page 104](#)

2 Turn off the printer.

Press and hold the power button on the control panel for at least two seconds, and when the confirmation screen is displayed, touch **Yes**.

3 Stop operating the exhaust equipment connected to the printer.

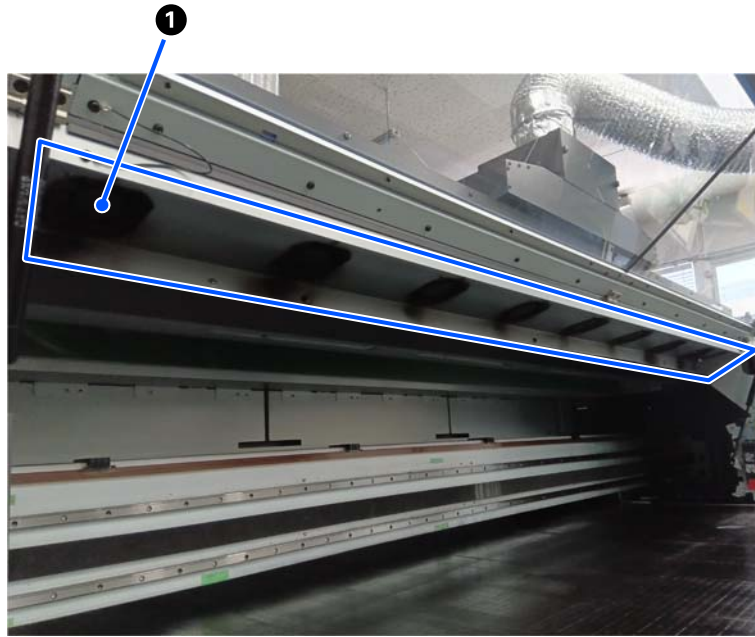
The location and method of checking exhaust ducts will vary depending on the equipment that is used. For details, please check with the factory manager.

4 Open the front cover.



Maintenance

There are eight mist collection fans located at the top inside the printer.



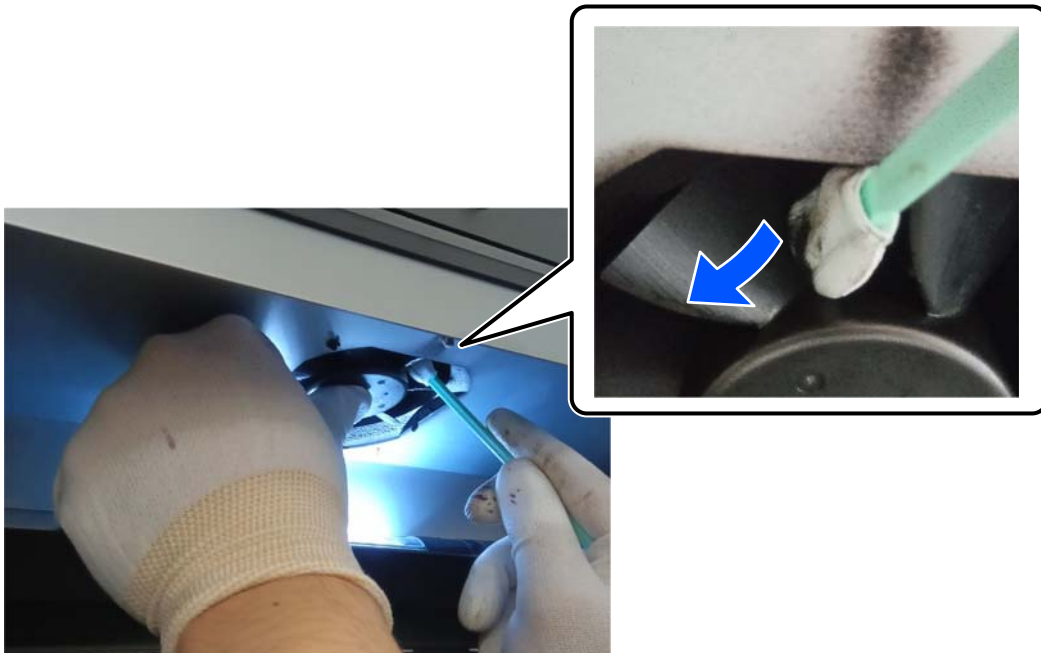
① Mist collection fans

5

While holding down the fan to stop it from rotating, use a cleaning stick to remove any lint or mist stains from the fan.

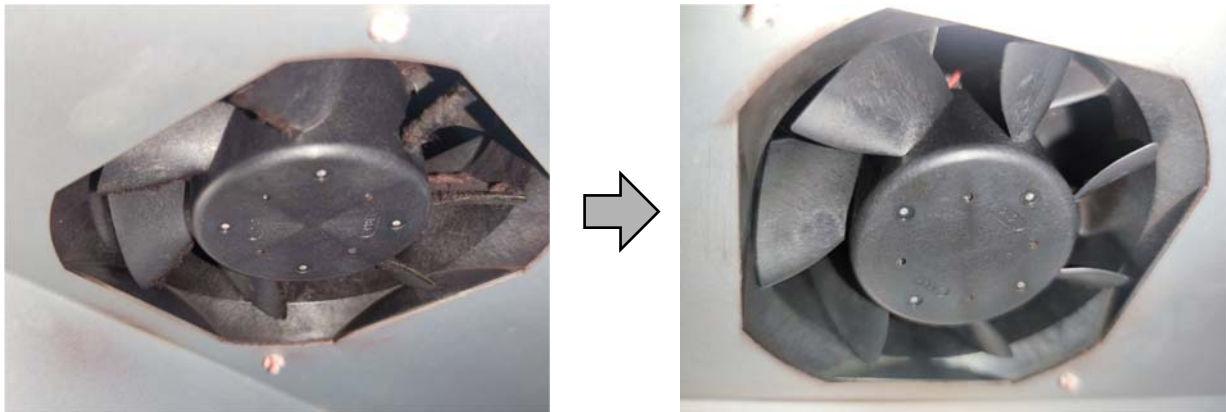
Insert the cleaning stick to the back of the fan and move it around the fan toward the front to scrape out any lint and debris.

We recommend using a headlamp or flashlight to light up the fans.



Maintenance

As shown in the photos below, clean the fan thoroughly to ensure no lint or ink stains remain. Clean all of the fans.



- 6** If there is any lint or debris on the metal of the mist collector at the bottom of the fan, wipe it off with a wipe cloth.



- 7** If any of the debris you scraped out falls on the belt, perform belt cleaning.

From the Maintenance screen on the control panel, touch **Maintenance - Belt Cleaning**. Set **Belt speed** and **Number of cleaning cycles**, and then touch **Start**.

- 8** Close the front cover.

- 9** 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.

- 10** Turn on the printer.

Press the power button on the control panel.

Maintenance

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.

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

You can check the print head nozzles using any of the following three methods.

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.

 [“Printing procedure for check patterns” on page 274](#)

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 415](#)

Nozzle Check between Jobs

This prints a check pattern before printing 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 415](#)


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 428](#)

Personal protective equipment

Protective gloves and clothing

Maintenance

- 1 From the menu button on the control panel, touch **General Settings - Printer Settings**, 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
 - Off: 691 × 121 mm [27.20 × 4.76 inches] (two sheets of A3 size photo paper)
 - On: 271 × 199 mm [10.67 × 7.83 inches] (one sheet of A3 size photo paper)
- 4 Open the front cover.



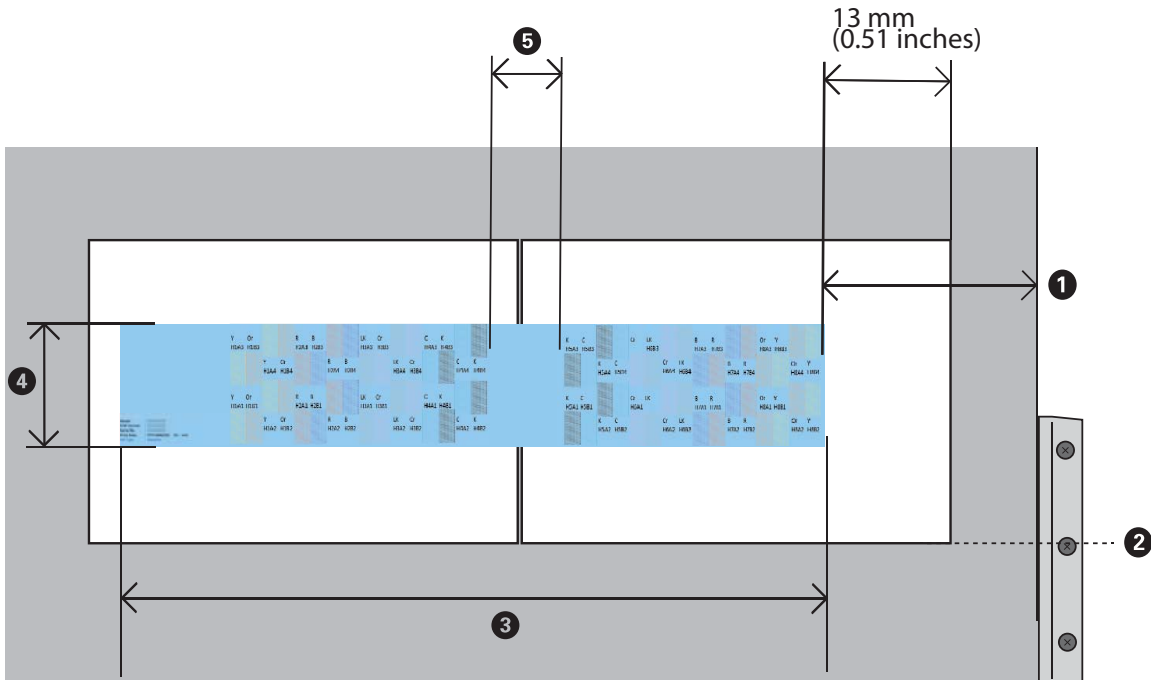
- 5 Wipe the surface of the belt with a soft cloth that has been soaked in water and thoroughly wrung out.
This prevents the photography paper from sticking to the belt. Wipe off any dust or lint on the surface of the belt.



Maintenance

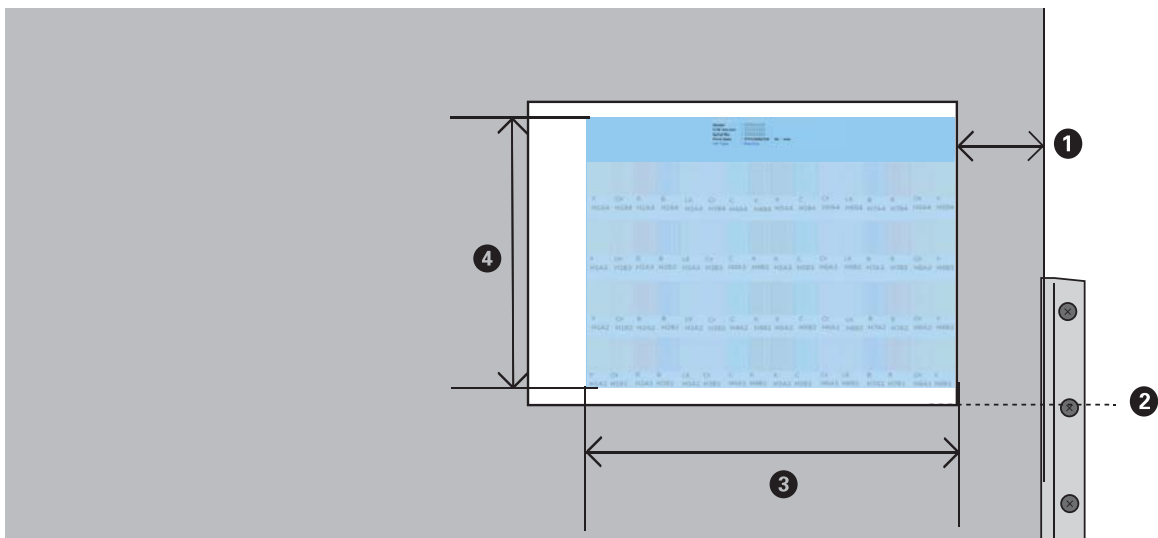
6 Place the photography paper on the belt by using the print area in the pattern as a reference.

If **Fabric Width Saving** is set to **Off**



- ❶ Print start position (X direction): arbitrary
- ❷ Print start position (Y direction): the approximate start position is the second screw or hole from the back of the guide beside the belt
- ❸ Pattern print width: approximately 691 mm (27.2 inches)
- ❹ Pattern print length: approximately 121 mm (4.76 inches)
- ❺ Distance between pattern blocks: approximately 33.9 mm (1.33 inches)

If **Fabric Width Saving** is set to **On**



Maintenance

- ① Print start position: arbitrary
- ② Print start position (Y direction): the approximate start position is the second screw or hole from the back of the guide beside the belt
- ③ Pattern print width: approximately 271 mm (10.6 inches)
- ④ Pattern print length: approximately 199 mm (7.83 inches)

Note:

- The layout of the nozzle check pattern depends on the ink set being used.*
- When printing a check pattern on fabric, depending on the width of the loaded fabric, you can save fabric by printing additional test patterns in the space beside an existing pattern.*

7 Touch **Print Start Position**, and then specify the print start position from the right edge of the belt.

8 Close the front cover.

9 Check the on-screen message, and then touch **Start**.

A check pattern is printed.



Caution:

Do not open the rear cover while printing is in progress.

The printer stops when the rear cover lock lever is released. Close the rear cover and move the lock lever to the Lock (right) position to restart the printer

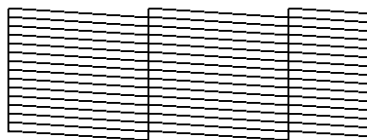
If the print head is on the suction cap when the printer is restarted, they may collide causing a malfunction to occur.

Make sure the print head is not on the suction cap before moving the lock lever to the Lock (right) position. If the print head is on the suction cap, see the following to retract the print head.

[☞ "Manually Moving the Print Head" on page 434](#)

10 Open the front cover, remove the photography paper, and check the check pattern that was printed.

Example of clean nozzles

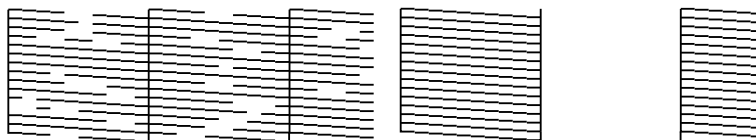


If no parts of the check pattern are missing, there is no clogging. Check the on-screen message, and then touch **OK**.

From the menu button on the control panel, touch **General Settings - Printer Settings**, and then set **Cut Sheet Mode** to Off to complete the procedure.

Maintenance

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.

[“Print Head Cleaning” on page 278](#)



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.

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 Job, or Print Length for the interval. See the following to change the settings.

[“Maintenance Menu” on page 425](#)

Maintenance

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.

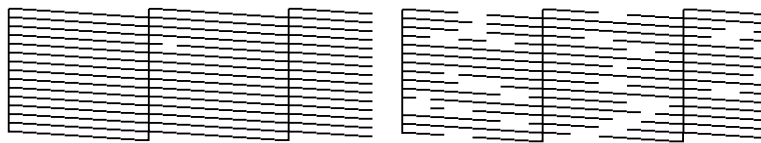
[☞ “Maintenance Menu” on page 425](#)

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

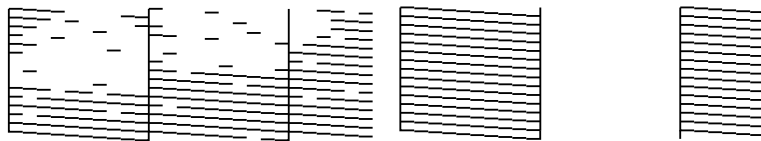


See the following to perform cleaning.

[☞ “Cleaning procedure when clogging has occurred in one or several locations” on page 279](#)

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 281](#)

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 Maintenance screen on the control panel, touch **Maintenance - Print Head Cleaning - Cleaning**, in that order.
- 2 Select a row of nozzles for cleaning, and then touch **Start**.
Print head cleaning starts. When a cleaning completion message is displayed, touch **OK**.
- 3 Print a check pattern to check for clogged nozzles.

[☞ “Printing procedure for check patterns” on page 274](#)

When the nozzles are cleared, print head cleaning is complete. If the problem continues to occur, move on to the next procedure.

Maintenance

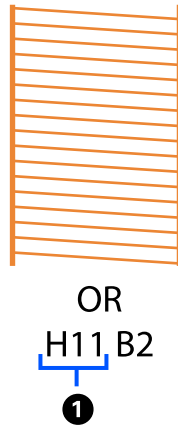
4 Select **Power Cleaning**.

A cleaning completion message is displayed when head cleaning is complete.

5 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.

Example



① Head number

6 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 274](#)

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 and the caps.

[“Inspecting/Cleaning Around the Print Head” on page 201](#)

[“Cleaning the Caps” on page 209](#)

9 Print a check pattern to check for clogged nozzles.

[“Printing procedure for check patterns” on page 274](#)

When the nozzles are cleared, print head cleaning is complete. If the problem continues to occur, move on to the next procedure.

10 Clean the suction caps.

[“Inspecting/Cleaning the Suction Caps” on page 220](#)

Maintenance

11 From the Maintenance screen on the control panel, touch **Maintenance - Print Head Cleaning - Print Head Refresh**, in that order.

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 274](#)

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 274](#)

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.

 [“Inspecting/Cleaning the Suction Caps” on page 220](#)

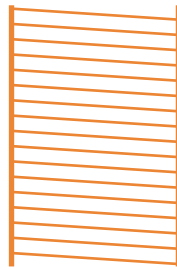
2 From the Maintenance screen on the control panel, touch **Maintenance - Print Head Cleaning - Print Head Refresh**, in that order.

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**.

Print head cleaning starts. When a cleaning completion message is displayed, touch **OK**.

5 Print a check pattern to check for clogged nozzles.

[☞ “Printing procedure for check patterns” on page 274](#)

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 and the caps.

[☞ “Inspecting/Cleaning Around the Print Head” on page 201](#)

[☞ “Cleaning the Caps” on page 209](#)

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 274](#)

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.

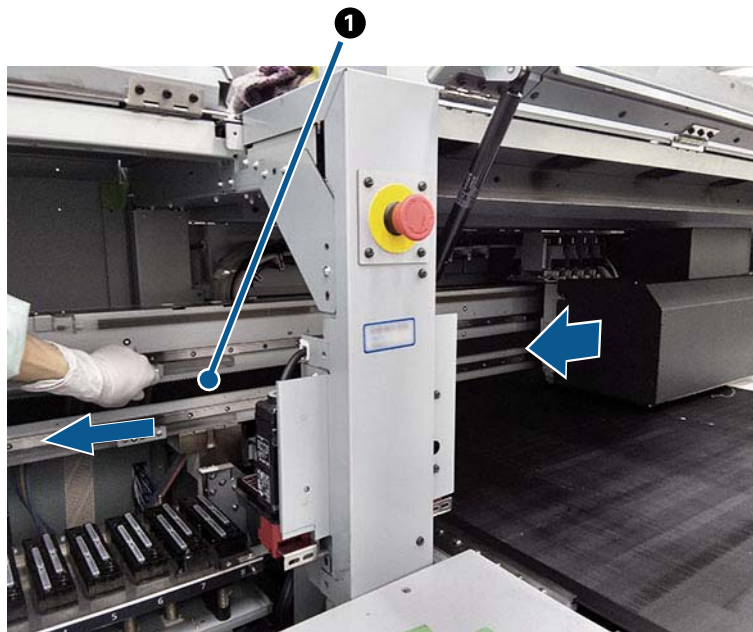
Maintenance

Manually Capping the Print Head

The print head may not be capped if the printer is turned off when the fabric is jammed or an error has occurred, or if the power turns off suddenly. If this occurs, turn on the power and wait a while until capping is performed automatically. If capping is not performed for more than 20 minutes, perform manual capping.

Personal protective equipment	Protective gloves and clothing, eye protection
-------------------------------	------------------------------------------------

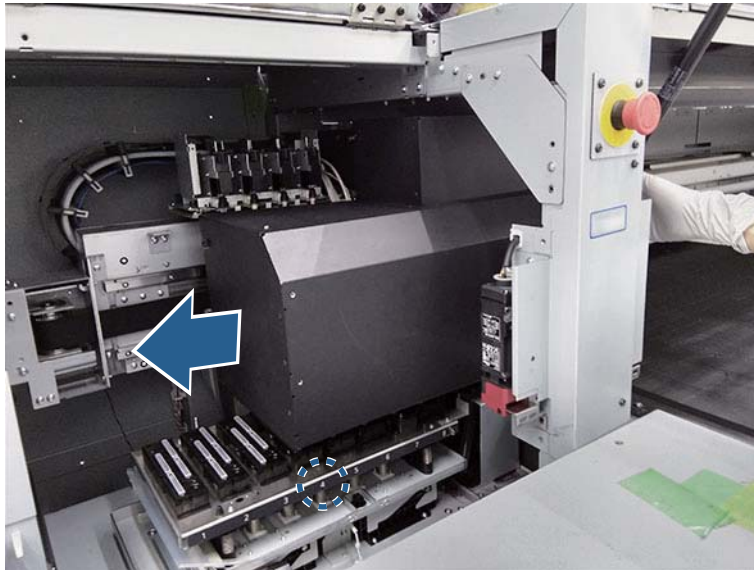
- 1 Open the front cover and the left-side maintenance cover.
- 2 Pull the carriage belt to the left by hand to move the carriage to the left.



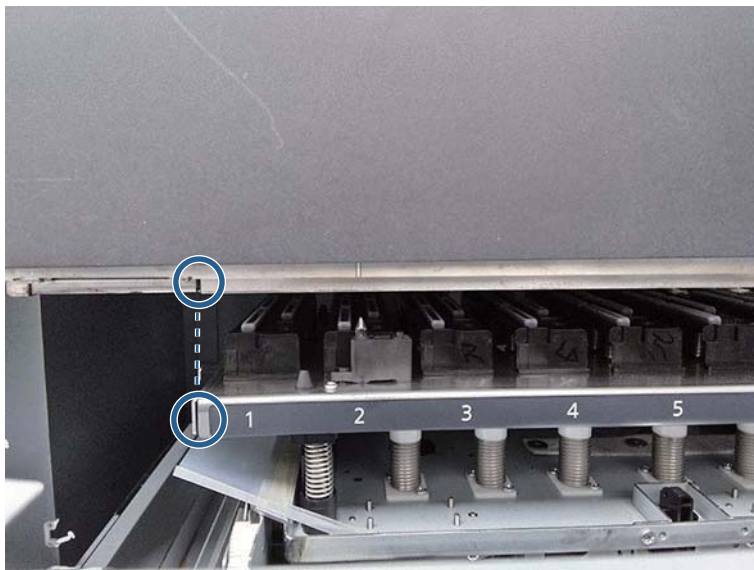
- ① Carriage belt

Maintenance

- 3** When the left edge of the carriage reaches the fourth cap from the left, push the carriage to the left by hand to move it over the cap.

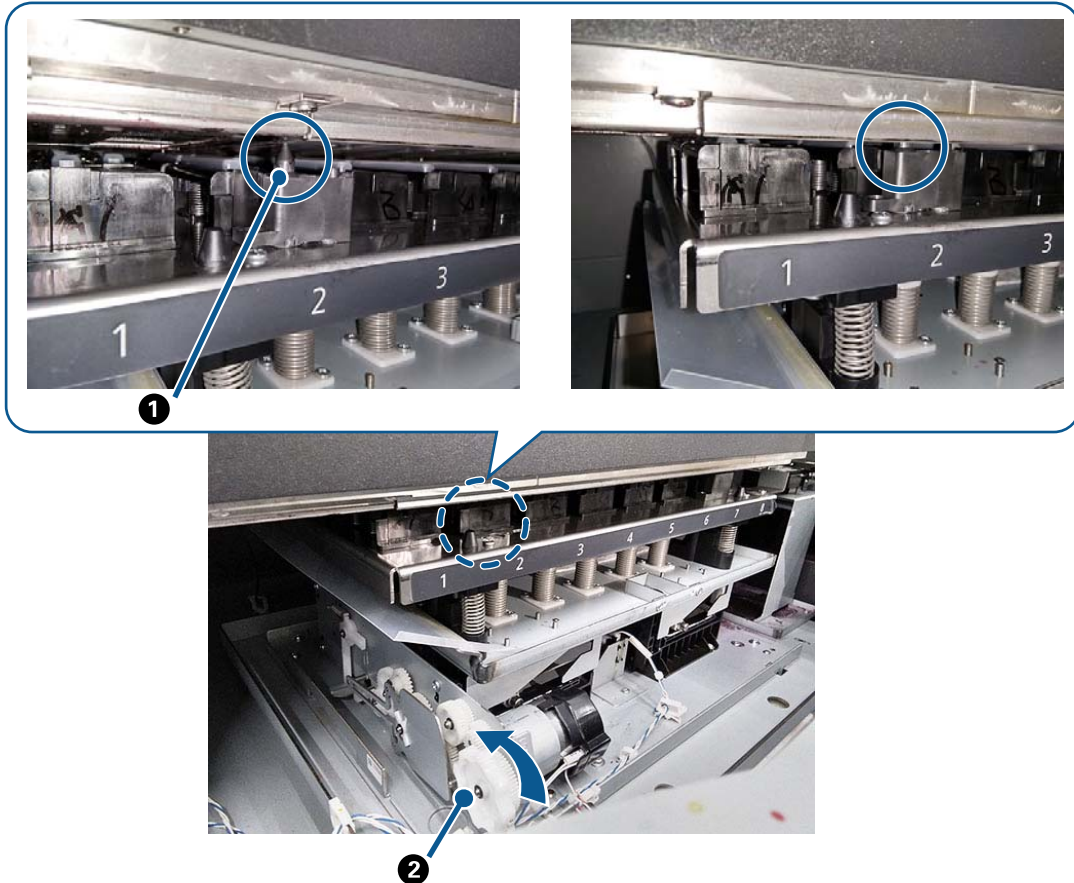


- 4** Adjust the position of the left edge of the caps so that it aligns with the position shown in the photo.



Maintenance

- 5** Turn the gear on the bottom-left of the print head in the direction shown until the cap no longer lifts up.
Check that the pin of the cap that is second from the left is inserted into the hole in the print head.



- ① Pin
- ② Gear

- 6** Close the front cover and the left-side maintenance cover.

Belt Cleaning Tank Flow Rate Adjustment

If the flow rate to the belt cleaning tank is not adjusted properly, the belt may not be cleaned properly resulting in fabric stains, or drainage may be insufficient resulting in water overflows.

If you are using the included valve and hose, follow the steps below to adjust the flow rate.

If you are not using the valve and hose, check the factory equipment.

Personal protective equipment

Protective gloves and clothing, eye protection

- 1** From the Maintenance screen on the control panel, touch **Maintenance - Cleaning the Cleaning Tank**, in that order.

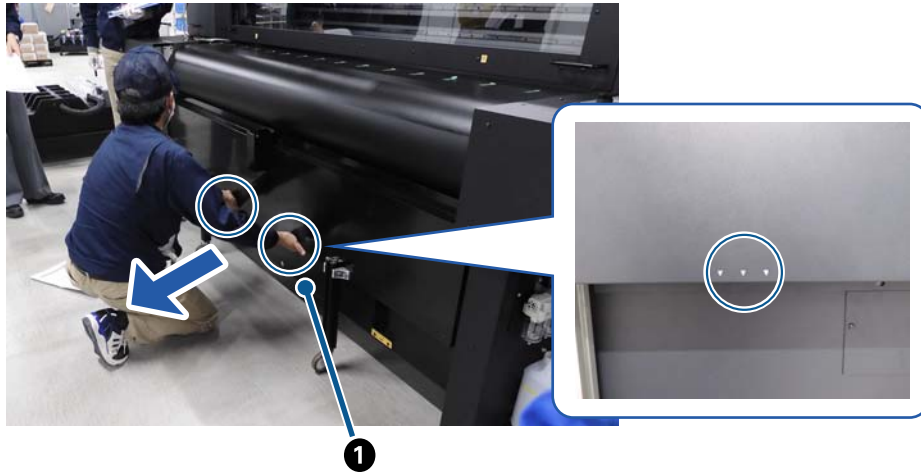
Maintenance

2 Touch Start.

Supply of water to the cleaning tank begins, and the pressure on the supply valve is released.

3 Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

Hold the handles on the front of the belt cleaning unit to pull it out.



① Handles

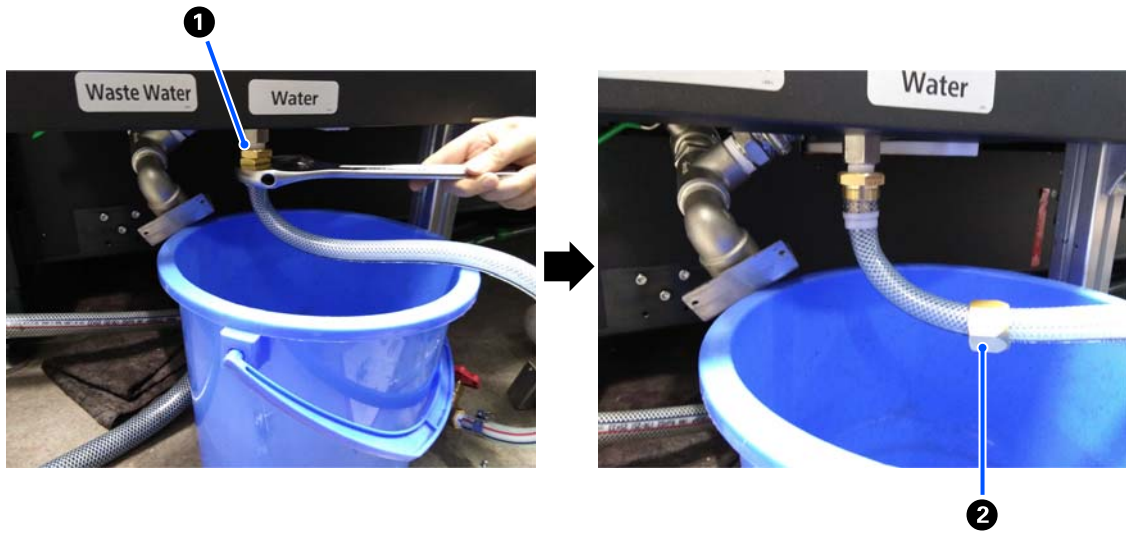
4 Close the adjustment valve near the supply joint on the belt cleaning unit and stop the flow of water.



① Adjustment valve

Maintenance

- 5** Use a spanner to loosen the nut on the blade lock (water inlet) securing the hose, and then loosen it by hand and pass it through the hose.



- 1 Blade lock
- 2 Nut

- 6** Pull the hose out of the blade lock.

Place a bucket or other container below as water may come out of the hose.



Maintenance

7 Adjust the flow rate.

ML-8000: 50 to 150 L/h (standard water supply rate 50 L/h)

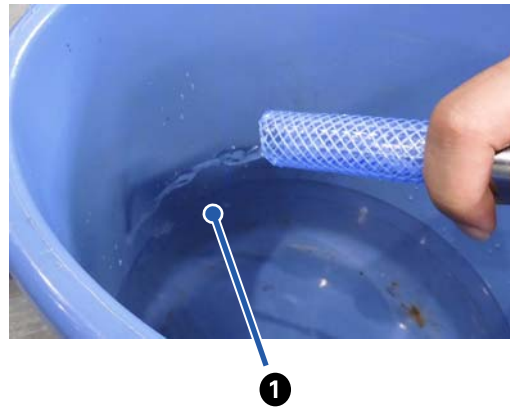
ML-8000U: 10 to 150 L/h (standard water supply rate 10 L/h)

If you do not have a flow meter or the like, you can adjust the flow rate by measuring the time it takes for the water to fill the container.

The approximate times for a 0.5 L container are shown below.

ML-8000: 36 seconds (50 L/h) to 12 seconds (150 L/h)

ML-8000U: 180 seconds (10 L/h) to 12 seconds (150 L/h)



1 Estimate flow rate

Note:

It is helpful to place a mark on the valve once you have determined the flow rate.



Maintenance

- 8** Once you have determined the flow rate, stop the water supply by folding the hose on the supply side.



- 9** Insert the hose into the blade lock while the water supply is turned off.



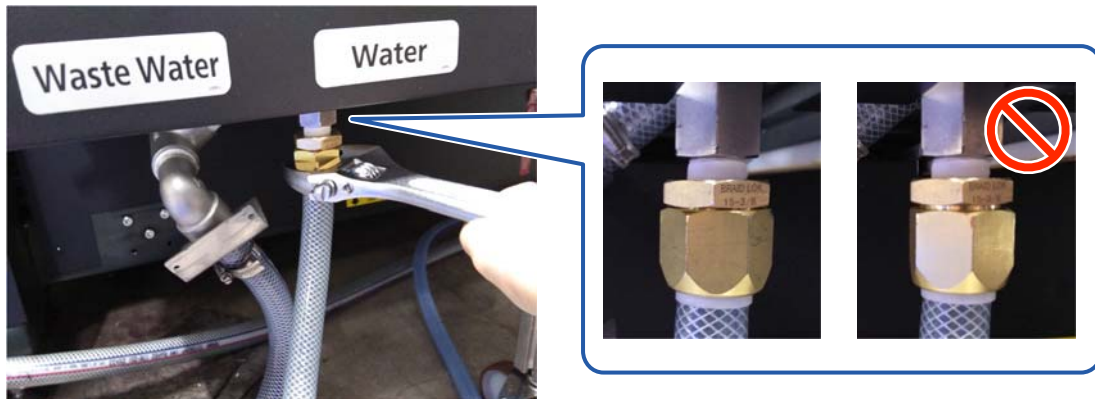
Maintenance

- 10 Return the nut to the blade lock and tighten it by hand.



- 11 Use a spanner to tighten the nut further.

Tighten until there is no gap between the blade lock and the nut.



- 12 Unfold the hose you folded and check that water is flowing into the cleaning tank.

- 13 Push the belt cleaning unit back to its original position, and then touch the **Done** button on the control panel.

Adding Grease to the Scan Spindle

If there is not enough grease in the carriage operating area, the carriage 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 291](#)

When a message prompting you to add grease is displayed on the control panel screen (once a year), it is time to grease the carriage operating area.

[☞ “Adding grease to the carriage operating area \(once a year\)” on page 291](#)

Maintenance

Adding grease to the scan spindle (once a month)

Personal protective equipment	Protective gloves and clothing
-------------------------------	--------------------------------

Note:

When performing maintenance, we recommended placing cloth over the belt to cover it.

- 1 Check that the machine is off.
- 2 Open the front cover.
- 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 carriage operating area (once a year)

Personal protective equipment	Protective gloves and clothing
-------------------------------	--------------------------------

Note:

When performing maintenance, we recommended placing cloth over the belt to cover it.

- 1 Check that the machine is off.

Maintenance

- 2 Press the grease pump and make sure that the grease comes out of the pump.

Note:

If there is a lot of air in the grease tube, the grease may not come out even if you press the pump. If this occurs, squeeze the tube to push out the air, and then attach it to the pump.

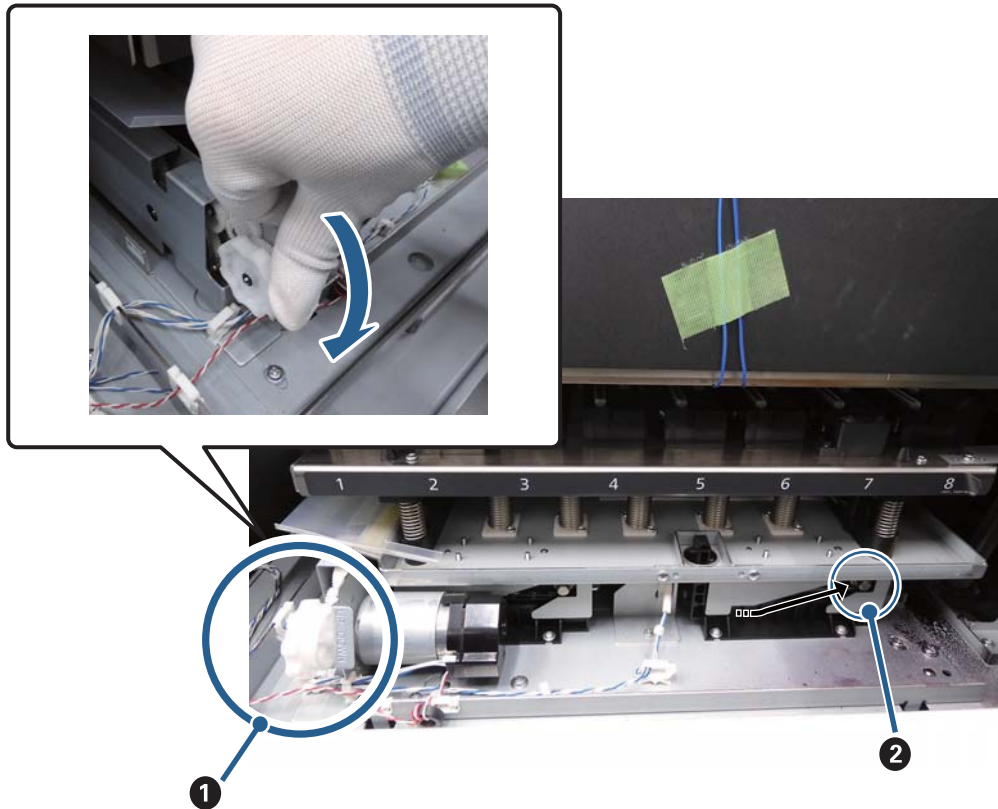


- 3 Open the front cover and the left-side maintenance cover.

Maintenance

- 4** Turn the knob inside the left-side maintenance cover towards you.

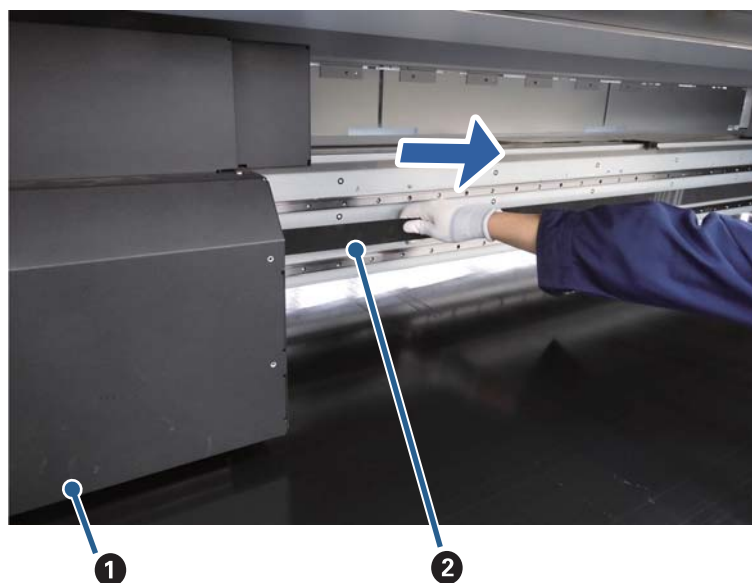
The spindle moves to the right. Turn the knob until the spindle stops moving at the right edge.



- 1 Knob
- 2 Spindle

- 5** Manually move the carriage to the center of the machine.

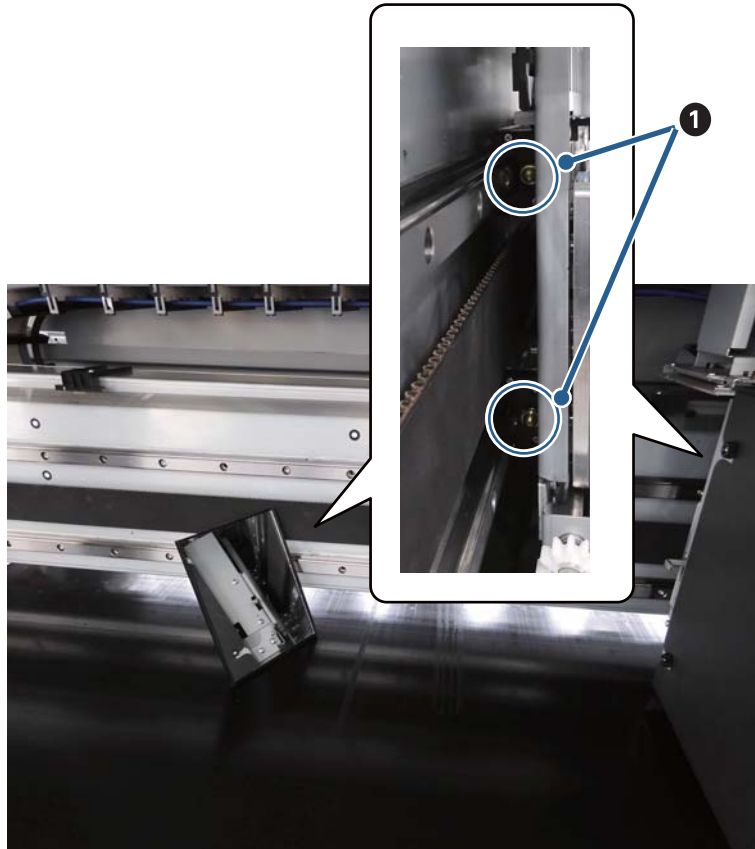
Pull on the belt section or push the carriage frame.



Maintenance

- ① Carriage
- ② Scan spindle belt

- 6** Place a mirror on the left side of the carriage in a position where you can see the oil filler holes (upper and lower).



- ① Oil filler holes

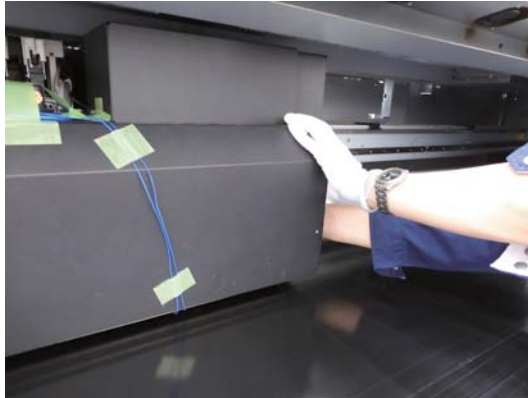
- 7** Press the grease pump against the oil filler holes (upper and lower) and add grease.

The proper grease amount is 1 to 3 g for each oil filler hole. A single push is approximately the amount of grease to add.

Maintenance

! **Important:**

- ❑ *Have a co-worker hold the carriage from the other side to prevent it from moving.*



- ❑ *Do not touch the scale. Fingerprints and grease may cause print quality to decline. If it gets dirty, wipe it with a wipe cloth.*

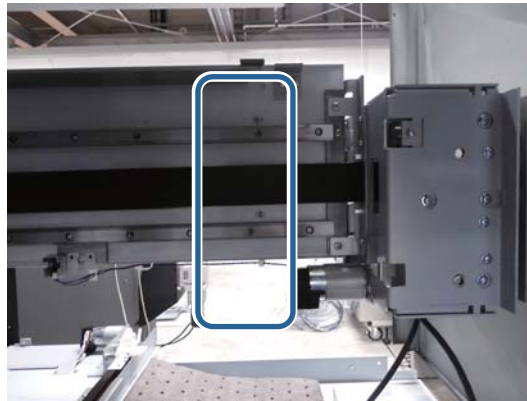


- ❑ *If there is excess grease or ink deposits in or around the oil filler holes, wipe them clean with a wipe cloth before you start work.*
- ❑ *Do not add too much grease. Doing so can result in excess grease dripping onto fabric, resulting in a printing error.*



Maintenance

- 8 Use the same method to add grease to the oil filler holes (upper and lower) on the right side of the carriage.
- 9 Remove any mirrors, tools, and so on that were on the belt, make sure nothing has been left on the belt, and then close the front cover and the left-side maintenance cover.
- 10 Turn on the printer.
The carriage returns to its original position.
- 11 Open the right-side maintenance cover, and then check the scan spindle.
If there is grease on the rail edge, grease has been successfully added. Use a wipe cloth to wipe off the grease from the rail edge.
If there is no grease, grease has not been applied to the oil filler holes, or there may not be enough grease. Implement this procedure again.



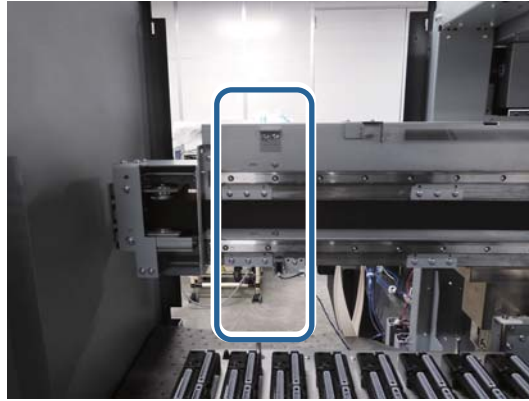
- 12 Close the right-side maintenance cover.
- 13 From the Maintenance screen on the control panel, touch **Daily - Around the Head Cleaning**, in that order.
Move the print head to check the scan spindle on the left.
- 14 Check the on-screen message, and then touch **Start**.
- 15 Confirm that the print head has moved to the right side, and then open the left-side maintenance cover.

Maintenance

- 16** Open the left-side maintenance cover and check the scan spindle in the same way as the right side.

If there is grease on the rail edge, grease has been successfully added. Use a wipe cloth to wipe off the grease from the rail edge.

If there is no grease, grease has not been applied to the oil filler holes, or there may not be enough grease. Implement this procedure again.



- 17** Close the left-side maintenance cover.

Adding Grease to the Belt Cleaning Unit

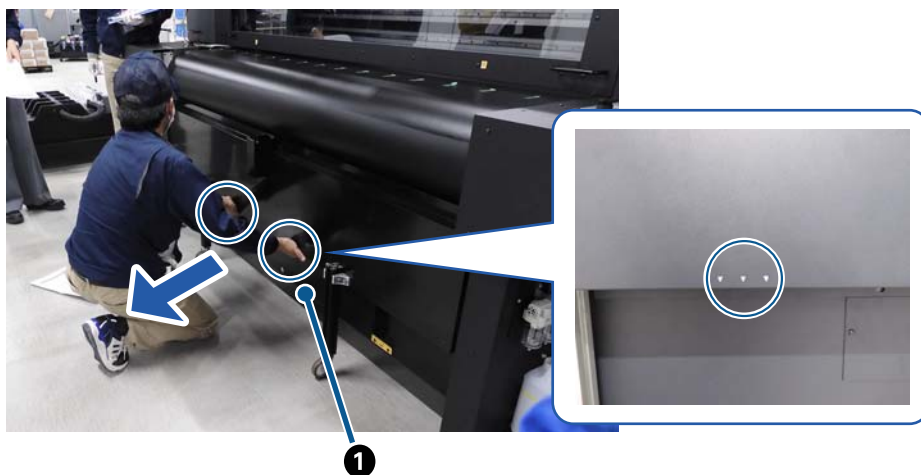
If the grease on the moving parts of the belt cleaning unit is running low, it will be harder to pull out the unit. If the unit becomes hard to pull out, follow the steps below to add grease as trying to pull it out by force may cause an injury or malfunction to occur.

Personal protective equipment

Protective gloves and clothing

- 1** Check that the machine is off.
- 2** Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

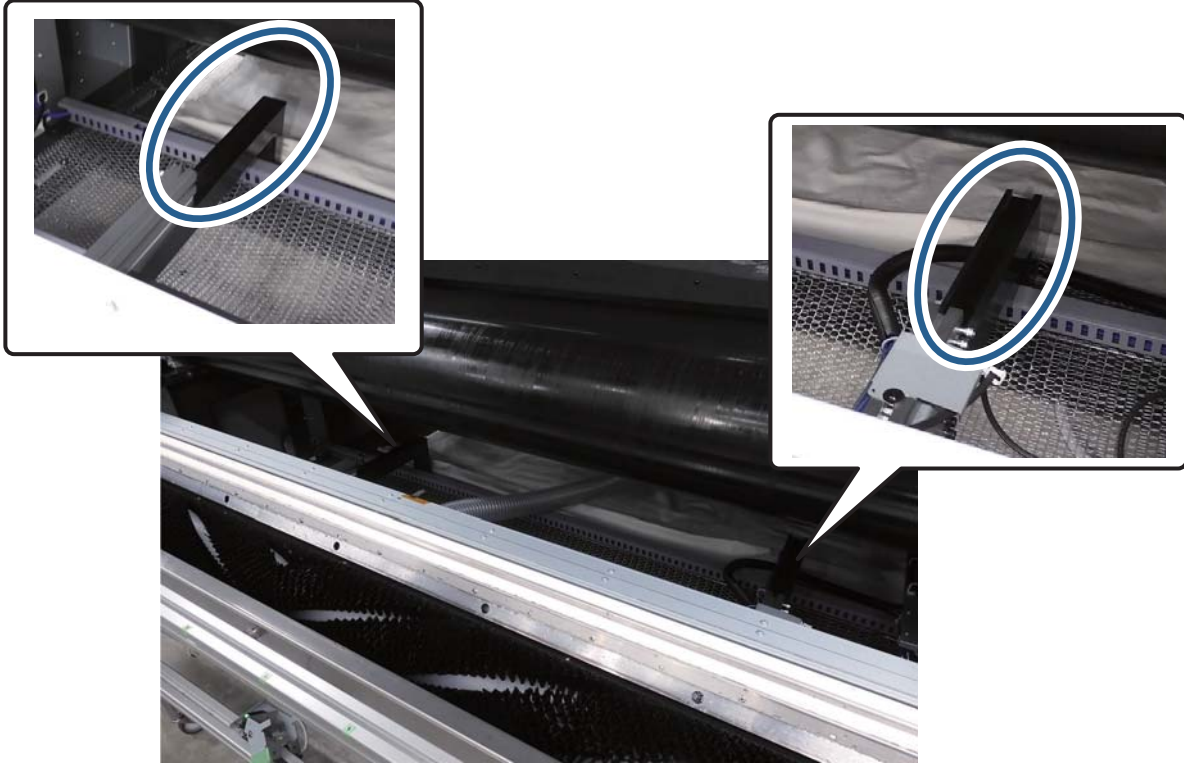
Hold the handles on the front of the belt cleaning unit to pull it out.



Maintenance

① Handles

③ Add grease to the moving parts of the belt cleaning unit.



④ Push the belt cleaning unit back to its original position.

Applying anti-foaming agent to the belt cleaning unit (only when using acid ink)

If you use acid ink, foam may be generated in the belt cleaning unit and the cleaning tank may overflow. Once a week before turning on the power, follow the steps below to apply anti-foaming agent to the belt cleaning unit.



Important:

When using the water recycling unit, the method for using an anti-foaming agent is different. Do not perform this procedure.

When using the water recycling unit, check the procedure in the User's Manual for the water recycling unit.

You can acquire the User's Manual for the water recycling unit from epson.sn (website). Enter epson.sn into your Internet browser, select your printer model, and then download the "User's Manual" for the water recycling unit (C12C939921).

Personal protective equipment

Protective gloves and clothing, eye protection

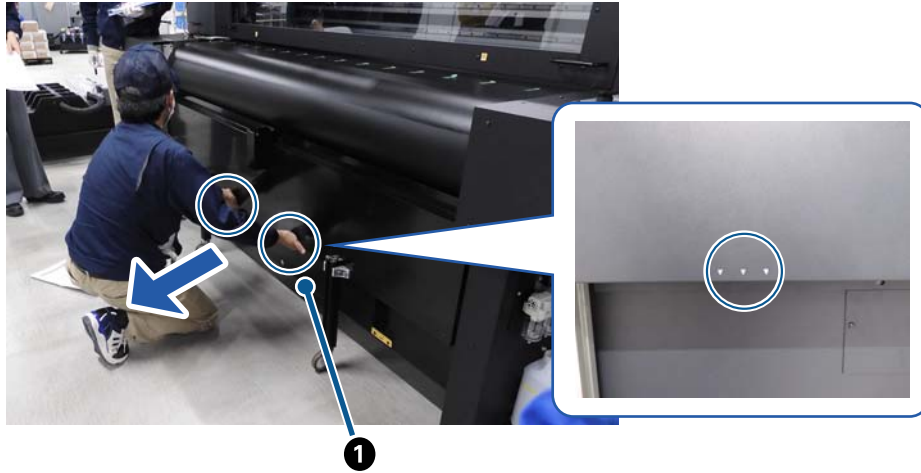
①

Check that the machine is off.

Maintenance

- 2 Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit from the front of the machine.

Hold the handles on the front of the belt cleaning unit to pull it out.



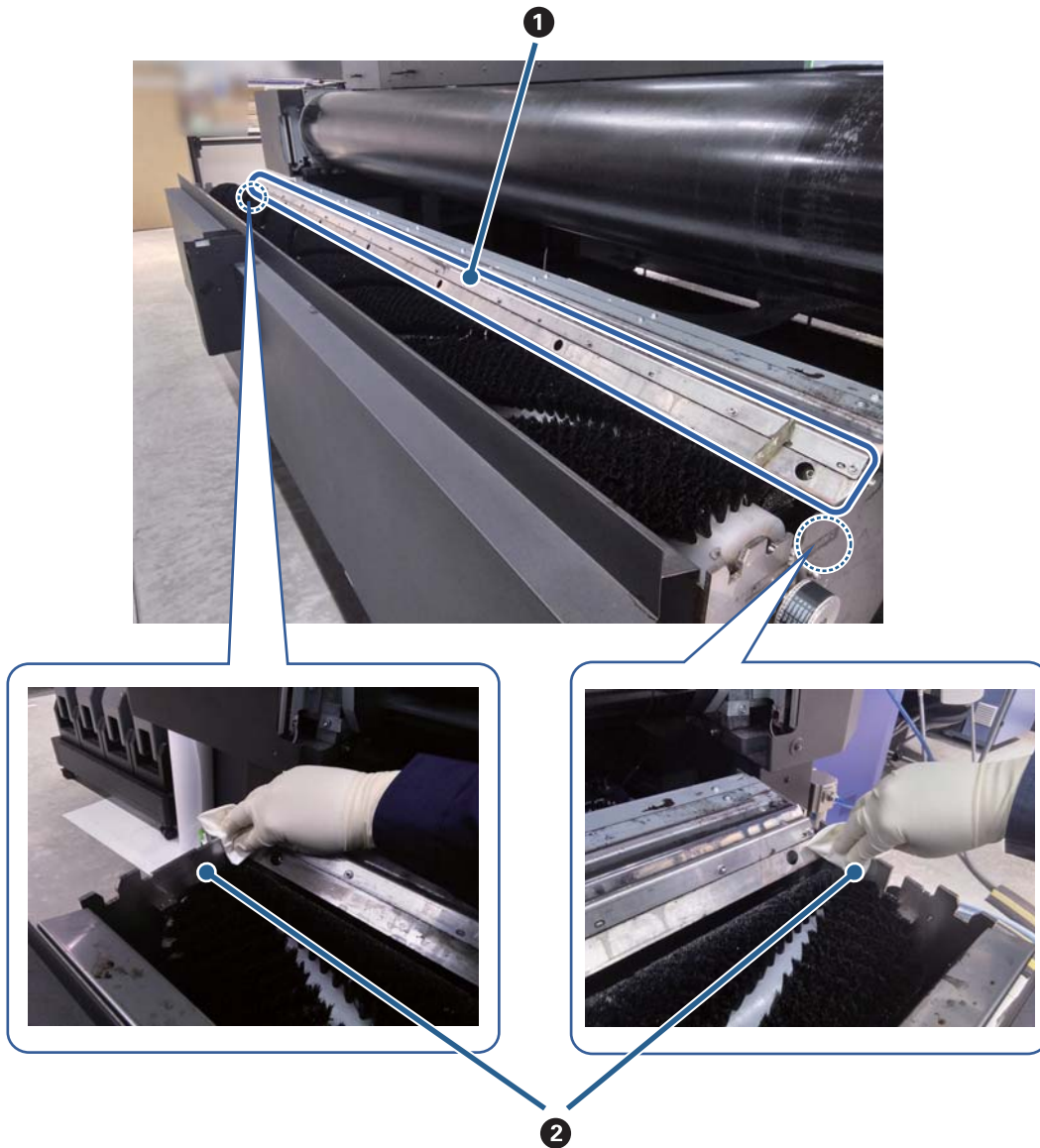
- 1 Handles

- 3 Use wipe cloths to wipe off any water droplets at the two locations shown in the photo.

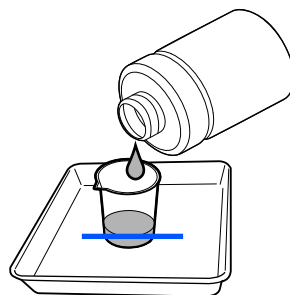
- 1 Metal part that holds the scraper in place

Maintenance

- ② Metal parts on both sides inside the belt cleaning tank



- ④ Pour approximately 20 g of anti-foaming agent into a plastic cup.



- ⑤ Use a brush to apply anti-foaming agent to the two locations shown in the photo. Be sure to use the entire amount poured into the plastic cup.

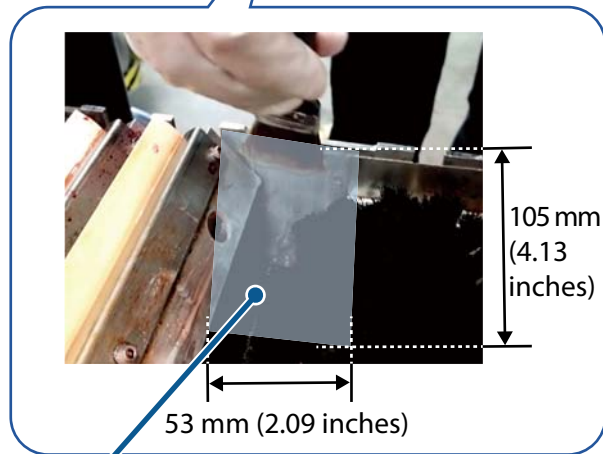
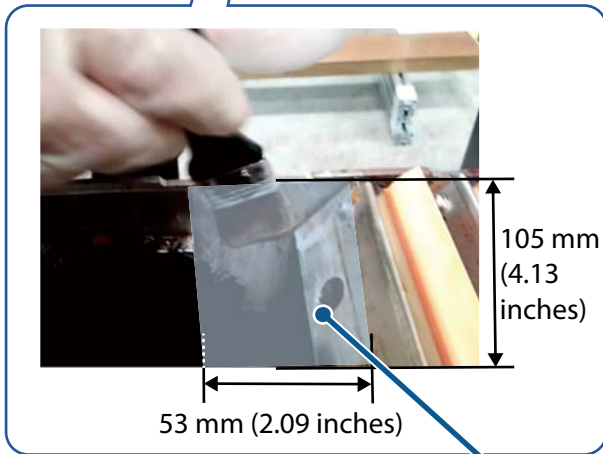
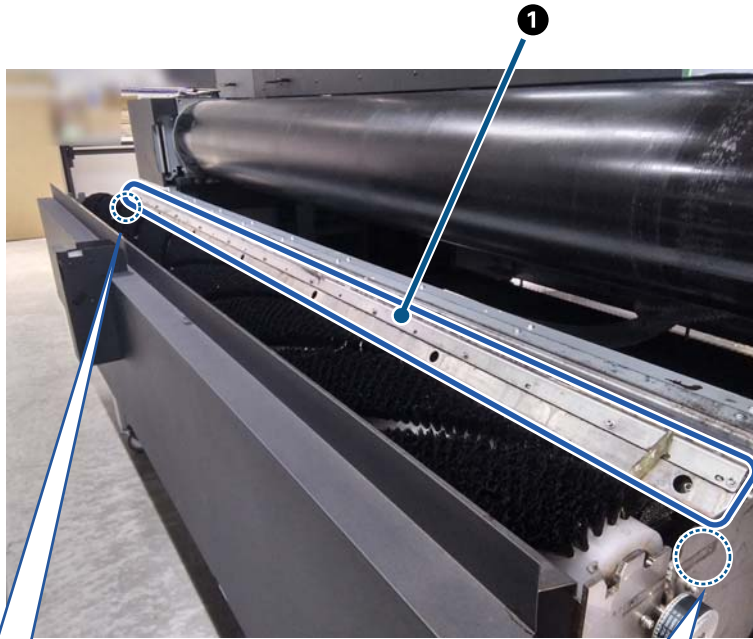
- ① Metal part that holds the scraper in place
- ② Metal parts on both sides inside the belt cleaning tank

Maintenance



Important:

Apply the anti-foaming agent so that it does not adhere to the brush or the cleaning scraper. If any adheres to these items, wipe it off with a wipe cloth moistened with alcohol.



2


Ink Film Remover (Pigment Inks Only)

When printing with pigment inks, a film of ink may form on the belt. When a film of ink forms, the adhesive strength of the glue decreases. When ink sticks to the belt and the adhesive strength decreases about one week after applying the glue, remove the ink film.

This section describes the procedures for using the ink film remover recommended by Epson. Allow at least 8 hours for the belt to dry after performing this operation.

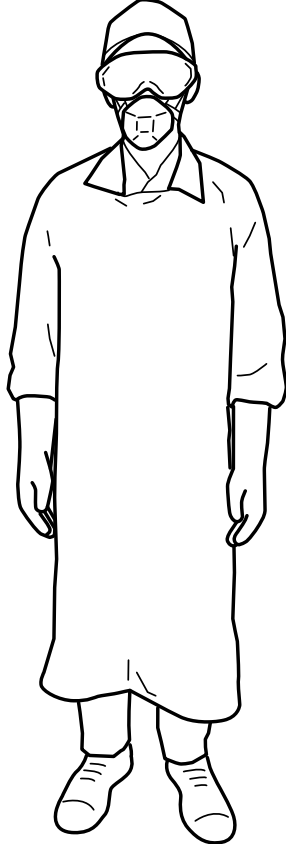
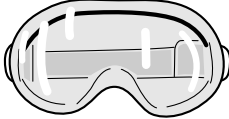


Maintenance



Even if you perform the following procedure, the glue applied to the belt may dissolve. If the glue dissolves, perform the glue removal and application procedure.

 [“Removing Glue \(When Using the Glue Removal Tool\)” on page 316](#)

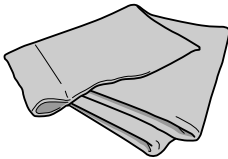
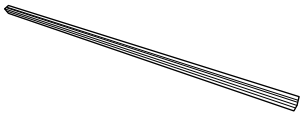


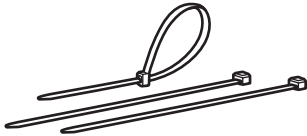


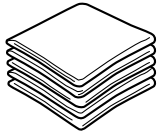
 [“Removing Glue \(When Using the Glue Bucket\)” on page 354](#)

 [“Applying Glue” on page 376](#)

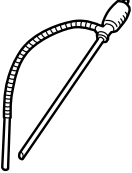
Required number of workers	Min. 2 persons	
Personal protective equipment	The following is the protective equipment that must be worn when using the glue or glue remover recommended by Epson. For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.	
	Eye 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 bucket 	1	Bundled item	Container used when pouring ink film remover onto the felt.

Maintenance

Required Items	Quantity	Details/Use	
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.
Felt weight 	1	Optional item	Used to keep the felt soaked in ink film remover pressed onto the belt.
Ink film remover 	2	Recommended product FORCLEAN(ATR) If you are using a glue other than the one we recommend, check with your local dealer for their recommended remover.	Solvent used to remove ink film 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.
Ethanol 	0.25 L	Commercially available	Used when wiping off dirt from the felt rod and felt weight after removing ink film.
Bottle (For ethanol) 	1	Commercially available	Container for holding ethanol.
Wipe cloths 	Proper amount	Commercially available	Used when cleaning the belt, felt rod, and felt weight. Use cloths of soft non-fluffy material that will not damage the belt.

Maintenance

Required Items	Quantity	Details/Use	
Pump 	1	Commercially available	Used when pouring ink film remover into the bucket. Use a material that does not dissolve when exposed to organic solvent.

Workflow

Removing ink film	1. "Entering Adhesive Material Maintenance Removal Mode" on page 304
	2. "Preparing the Felt" on page 305
	3. "Setting the felt" on page 308
	4. "Ensuring safety" on page 309
	5. "Removing ink film" on page 309
	6. "Removing and cleaning the felt weight and felt rod" on page 313
	7. "After removing the ink film" on page 315

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 setting the jigs again or failure of glue maintenance operations.

1

From the Maintenance screen on the control panel, touch **Maintenance - Adhesive Material Maintenance**, in that order.

2

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 and Administrator Password" on page 63](#)

- ❑ Save the Administrator Password you set in a safe location so that you do not forget it.

See the following if you forget your Administrator Password.

[🔗 "If you have forgotten your administrator password" on page 446](#)

Maintenance

3 Touch Removal Mode - Start.

When you touch **Forward** or **Reverse** once on the control panel, the belt will continue to rotate until you touch **Stop**.

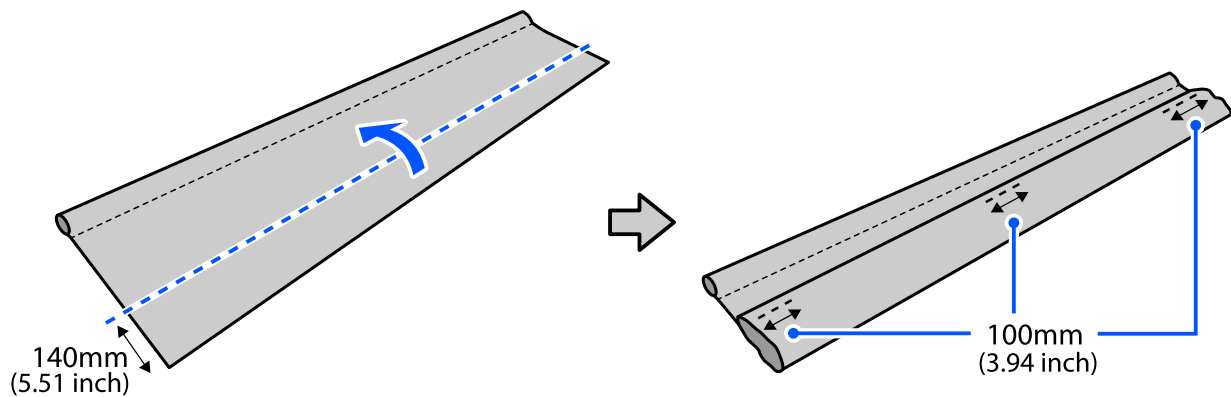
Touch **Done** to exit **Removal Mode** and return to the mode selection screen.

Preparing the Felt

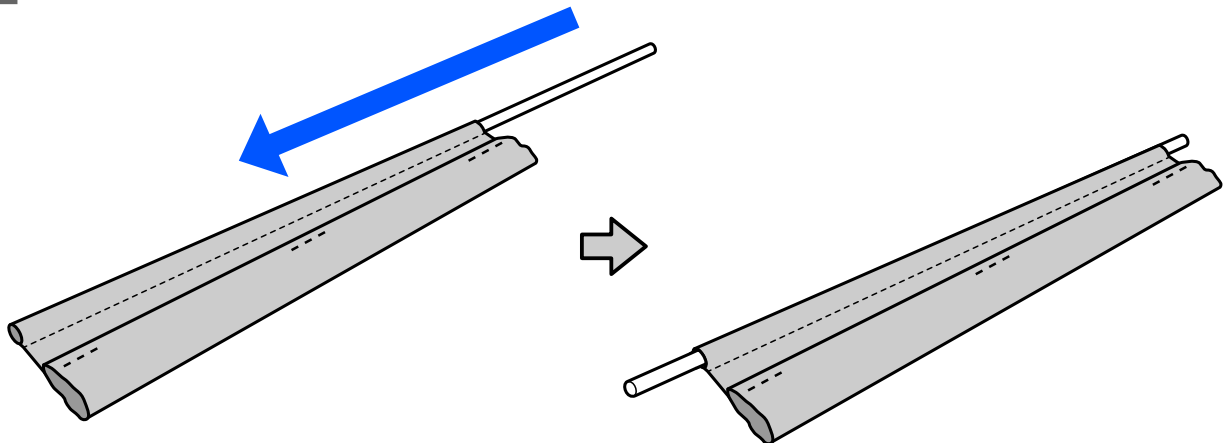
Prepare some felt to soak up the ink film remover.

When using the bundled felt

- 1 Fold the felt at the point shown in the figure so that it is approximately 140 mm (5.51 inches) wide, and then sew approximately 100 mm (3.94 inches) along the long side at three points; the left, right, and center.



- 2 Pass the felt rod through the felt loop on the opposite side.



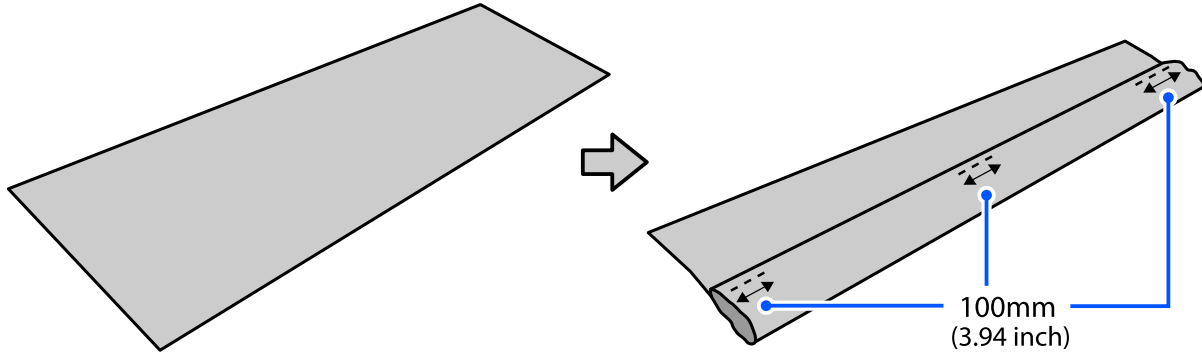
Maintenance

When using commercially available felt

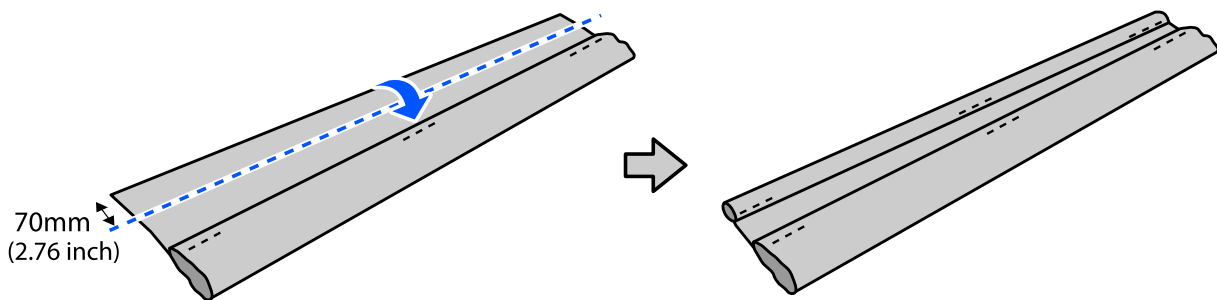
Use one of the following methods to attach the felt rod to the felt.

When attaching the felt rod to sewn felt

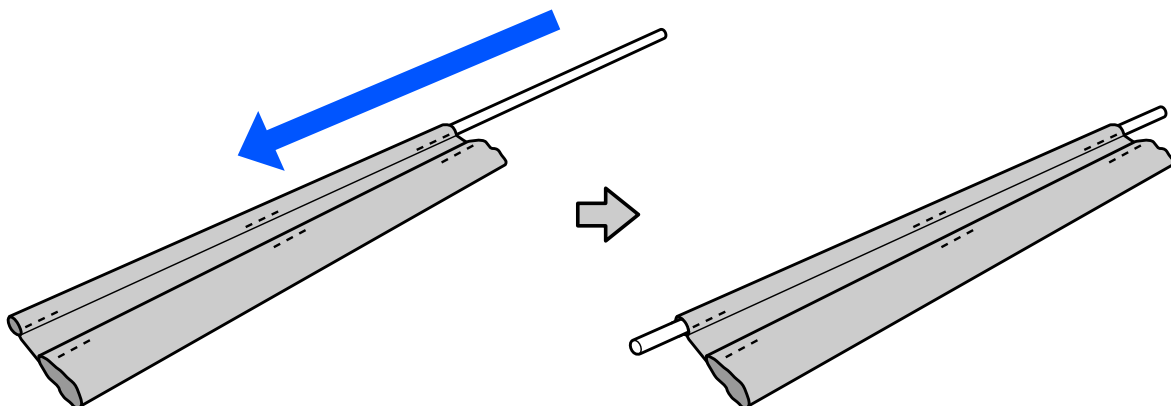
- 1 Fold the long side of the felt so that it is approximately 140 mm (5.51 inches) wide, and then sew approximately 100 mm in three places (the left, right, and center) (3.94 inches) to form a loop.



- 2 Fold the other side of the felt loop that you made in step 1 so that it is approximately 70 mm (2.76 inches) wide, and then sew approximately 100 mm (3.94 inches) in three places (the left, right, and center) to form a loop.



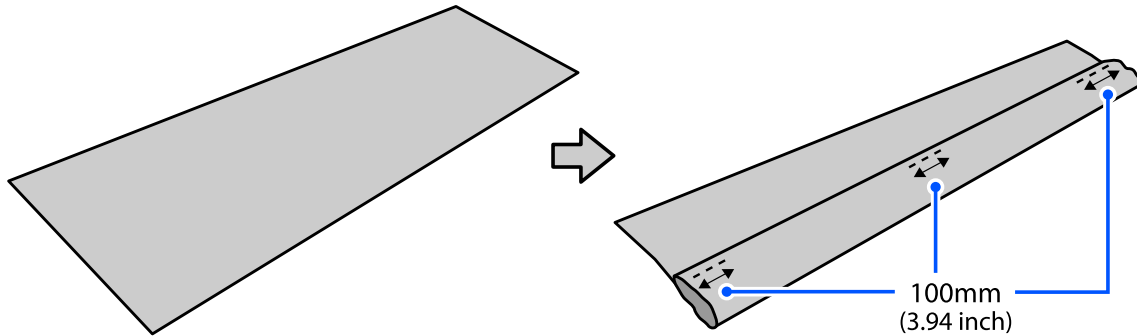
- 3 Pass the felt rod through the loop you made in step 2.



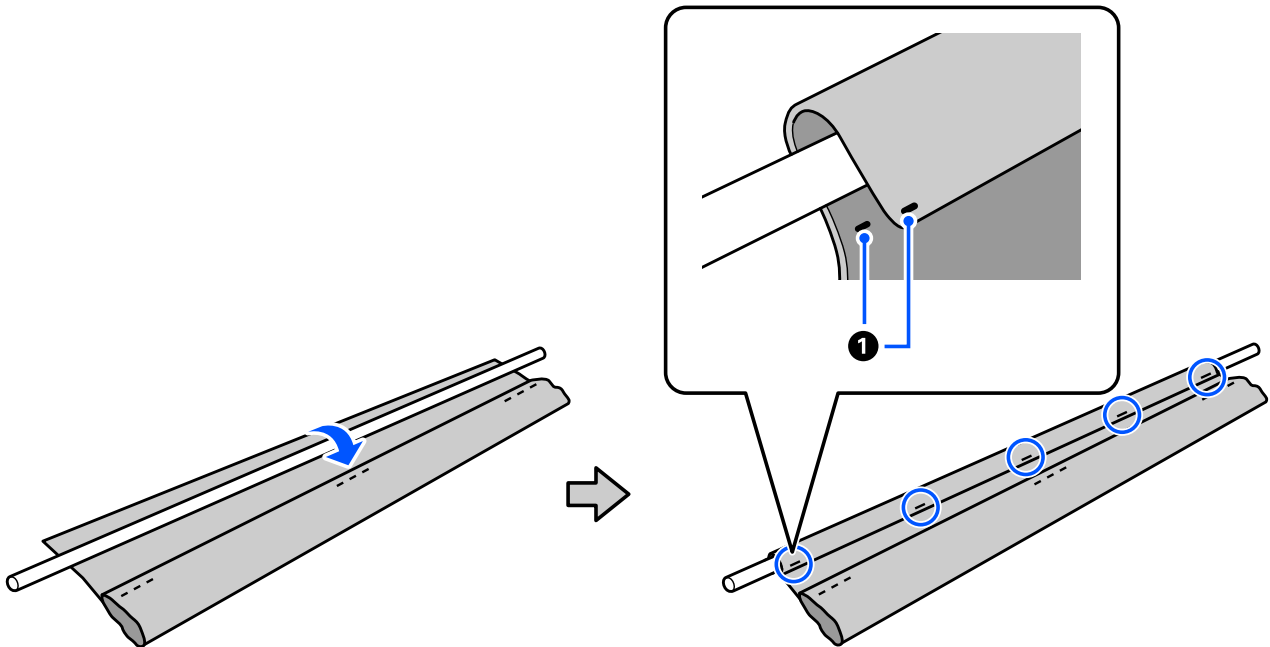
Maintenance

When attaching cable ties to secure the felt to the felt rod

- 1 Fold the long side of the felt so that it is approximately 140 mm wide, and then sew approximately 100 mm in three places (the left, right, and center) to form a loop.

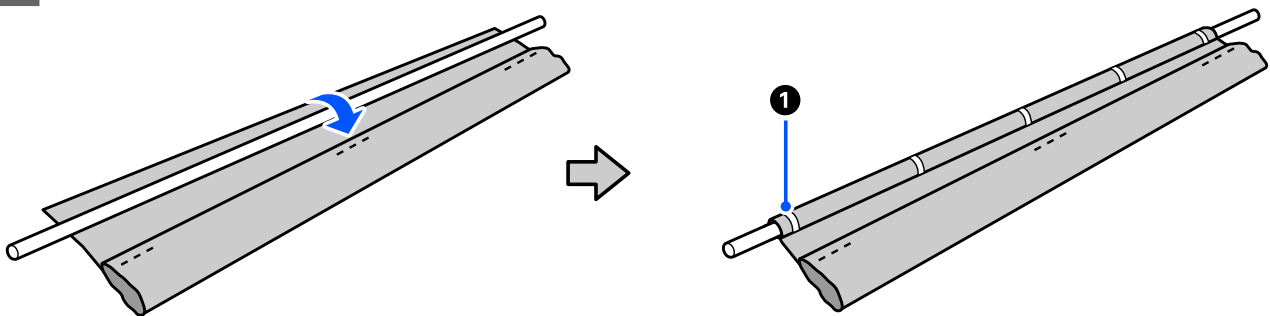


- 2 Hang the side of the felt without a loop over the felt rod, and then use scissors to cut five slits in the felt large enough to pass the cable ties through.



1 Slits

- 3 Attach the felt to the felt rod by passing five cable ties through the slits in the felt you made in step 2.



1 Cable ties

Maintenance

Setting the felt

Set the felt in the printer.

- 1 Open the front cover.



- 2 Once the felt is set on the rod, install the rod on the L-shaped hooks inside the product.



Maintenance

- 3 Spread the felt out towards the product front.



Ensuring safety

Perform ventilation and wear protective equipment, referring to the instructions of the SDS for the ink film remover you are actually using, as well as the laws and regulations in your country.

Removing ink film

Remove the ink film using an ink film remover.

- 1 Place the glue remover bucket on the tray, and pour in 2 L of ink film remover.
Use the pump to ensure the remover does not spill on the surroundings.



- 2 Soak about 1 liter of the ink film remover from the bucket into the area where the felt has stuck to the belt.



Important:

Be careful that the remover does not leak from either edge of the belt. If any of the remover sticks to the edges of the belt, the belt control unit may not function as expected. If any leaks do occur, use a wipe cloth to wipe them off.

Maintenance



- 3 Once the ink film remover has soaked in, pass the felt weight through the felt loop so that it is parallel to the felt rod.



Maintenance

- 4 Adjust the belt speed volume to the position indicated in the photo (the 60° position).



- 5 Touch the **Forward** button on the control panel.

The belt rotates.

- 6 Check the surface of the belt from under the felt, and if you notice any areas where the remover has dried as shown in the photo, soak the remaining remover into the felt.

The process takes approximately 20 minutes.



Important:

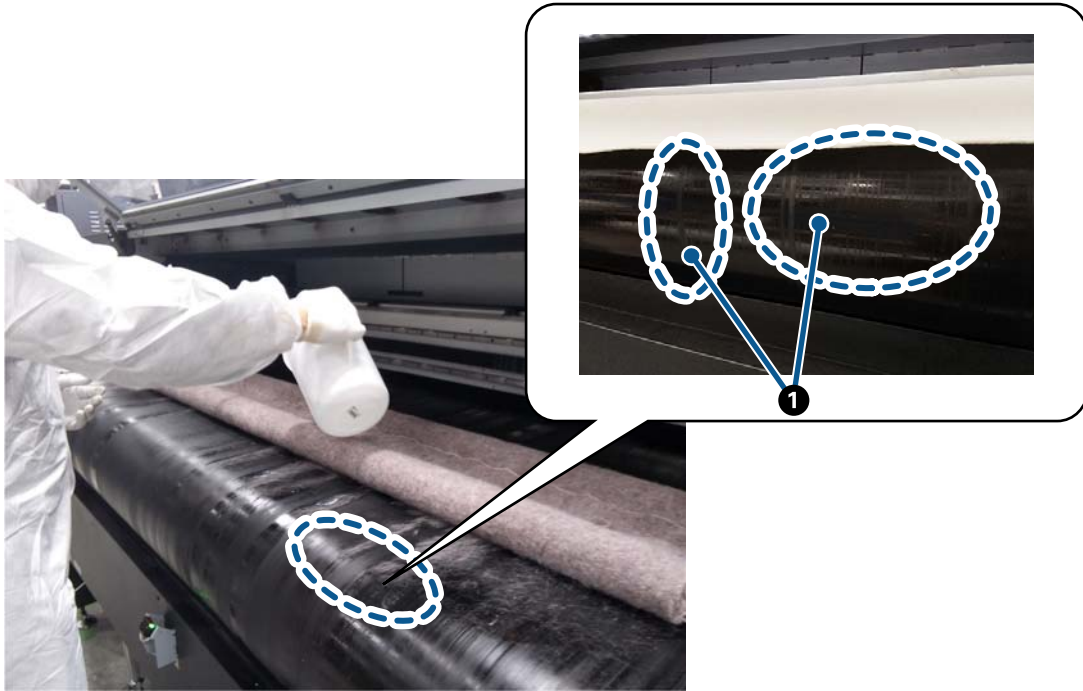
Do not soak the remover into the felt for more than 30 minutes. Otherwise, the glue on the belt may dissolve and peel off.

If the glue applied the last time has dissolved, perform the procedure for approximately 15 minutes. If the glue still dissolves after 15 minutes of work, reduce the work time by another 5 minutes, or reduce the ink film remover by 0.5 L and add 0.5 L of water. Do not perform this procedure in less than 10 minutes, or reduce the remover by more than 1 L or add more than 1 L of water.

If any ink remains on the belt, repeat the procedure for approximately 5 minutes.

If any ink still remains on the belt after this additional 5 minutes, continue working for another 5 minutes. Do not allow the total amount of time in which the felt is soaked with remover to exceed 30 minutes.

Maintenance



① Areas where the remover has dried

7 Touch the **Suspended** button on the control panel.

The belt stops.

8 Touch **Done** on the control panel.

Adhesive Material Maintenance Application mode closes.

Maintenance

Removing and cleaning the felt weight and felt rod

- 1** Remove the felt weight from the felt.



- 2** Remove the felt rod.

**Important:**

When the felt rod is removed, ink may remain on the belt or the glue that had been applied may dissolve.

If any ink remains on the belt, repeat step 6 in "Ensuring safety" for approximately 5 minutes. If the glue dissolves, perform the glue removal and application procedure.

☞ "Ensuring safety" on page 309

☞ "Removing Glue (When Using the Glue Removal Tool)" on page 316

☞ "Removing Glue (When Using the Glue Bucket)" on page 354

☞ "Applying Glue" on page 376

Maintenance



3 Remove the felt from the felt rod.

Dispose of the felt in the proper manner for industrial waste.



Maintenance

- 4** Wipe off the ink film remover on the rod and the felt weight using an ethanol-soaked wipe cloth.
Dispose of the used wipe cloths in the proper manner for industrial waste.



After removing the ink film

- 1** Check if there is water in the cleaning tank.
- 2** From the Maintenance screen on the control panel, touch **Maintenance - Cleaning the Cleaning Tank - Start**, in that order.
Supply of water to the cleaning tank begins, and the pressure on the supply valve is released.
- 3** Close the front cover.
- 4** From the Maintenance screen on the control panel, touch **Maintenance - Belt Cleaning**, in that order.
- 5** Touch **Belt speed** on the **Belt Cleaning** screen, and then touch **Normal**.
Set the belt rotation speed to **Normal**.
- 6** Touch **Number of cleaning cycles**, and then touch + or - to set the number of cleaning cycles to **3**.
- 7** Touch **OK** at the top-right of the **Number of cleaning cycles** screen.
The number of cleaning cycles is set to three.
- 8** Touch **Start**.
Belt cleaning begins.

Maintenance

- 9 When belt cleaning is complete, use water soaked wipe cloths to wipe off any water droplets or remaining remover on the belt surface.

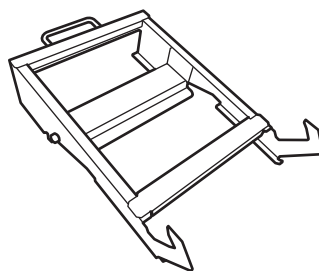


- 10 Check the on-screen message, and then touch **OK**.
- 11 Allow the glue on the belt to dry for at least eight hours.

Removing Glue (When Using the Glue Removal Tool)

Remove the glue that has been applied to the belt.

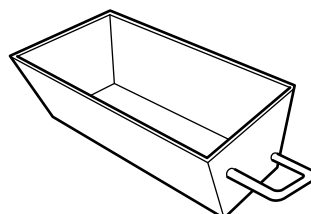
This section describes how to remove glue using the glue removal tool.



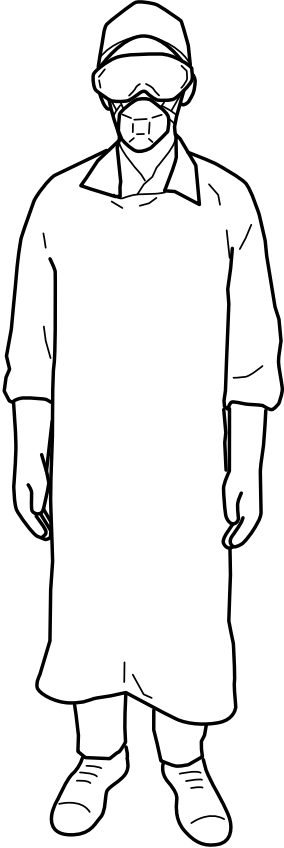
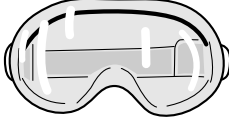
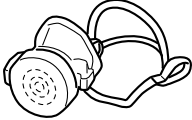

Note:


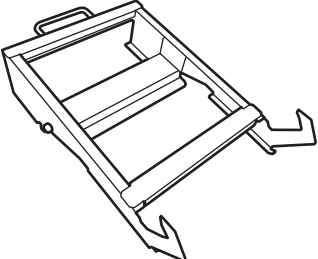
See the following when using the glue bucket.

 [“Removing Glue \(When Using the Glue Bucket\)” on page 354](#)

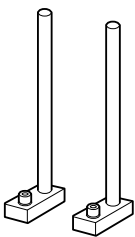

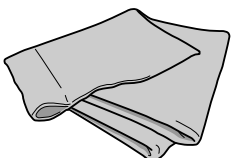
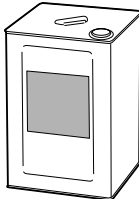

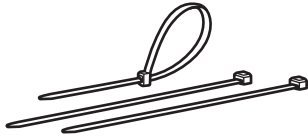
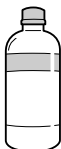



Maintenance

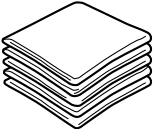

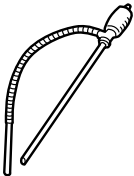


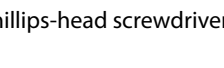

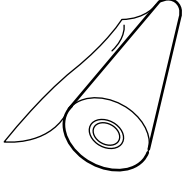
Required number of workers	Min. 2 persons	
Personal protective equipment	The following is the protective equipment that must be worn when using the glue or glue remover recommended by Epson. For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.	
	Eye 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.

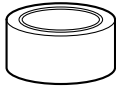
Maintenance

Required Items	Quantity	Details/Use	
Blade supports 	2	Bundled item	Use this part to secure the blade to 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.
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. The amount of glue remover necessary is a reference value applicable when applying glue using the type of glue and applied amount described in this manual.
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.
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.
Hex key 	2	Commercially available 4 to 6 mm (0.16 to 0.24 inches) [W]	Use this part when attaching the blade to the printer.
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] x 200 [D] mm (13.78 [W] x 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.
bags or plastic sheets 	Proper amount	Commercially available 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. Use a material that does not dissolve when exposed to organic solvent, such as polyethylene.

Maintenance

Required Items	Quantity	Details/Use	
Curing tape 	Proper amount	Commercially available	Used to protect the product.



Warning:

Before starting this procedure, be sure to read the following.  [“Precautions Regarding Maintenance” on page 177](#)

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 volume 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 321](#)



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 322](#)



3. Attach the bag to the glue removal tool

 [“Preparing the glue removal tool” on page 326](#)



Maintenance

4. Attach felt to the felt rod

 "Preparing the Felt" on page 330



5. Attach the felt rod and the blade to the product

 "Attaching the felt rod and the blade" on page 332



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.



7. Remove glue from the belt

 "Removing Glue" on page 337



8. Clean the surface of the belt

 "Belt surface cleaning" on page 346



9. 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 347

You can watch a video of the procedure on YouTube.

https://support.epson.net/p_doc/80d/

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.

Maintenance

1 From the Maintenance screen on the control panel, touch **Maintenance - Adhesive Material Maintenance**, in that order.

2 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 and Administrator Password" on page 63](#)

- ❑ *Save the Administrator Password you set in a safe location so that you do not forget it.*

See the following if you forget your Administrator Password.

[☞ "If you have forgotten your administrator password" on page 446](#)

3 Touch **Removal Mode - Start**.

When you touch **Forward** or **Reverse** once on the control panel, the belt will continue to rotate until you touch **Stop**.

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. This section describes the procedures recommended by Epson.

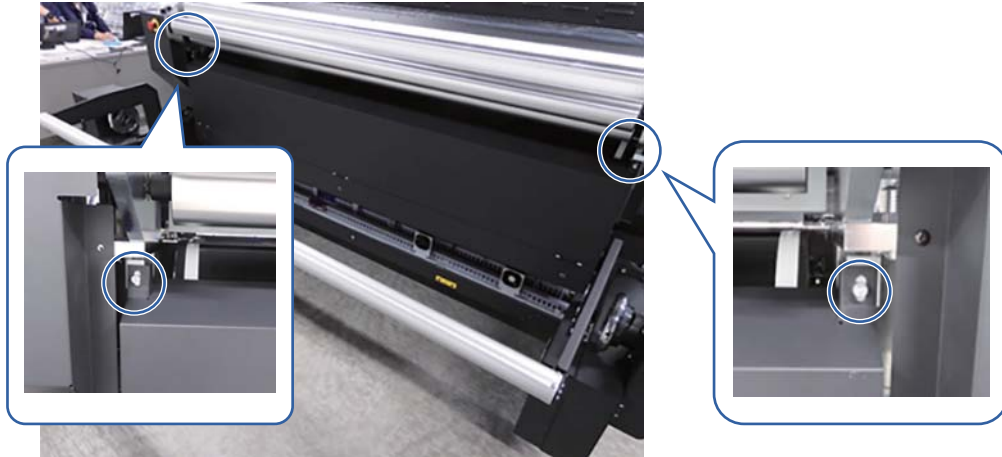
1 Push down the tension bar on the machine rear.



1 Tension bar

Maintenance

- 2** Remove the 2 screws that secure the machine rear cover and pull down the cover.

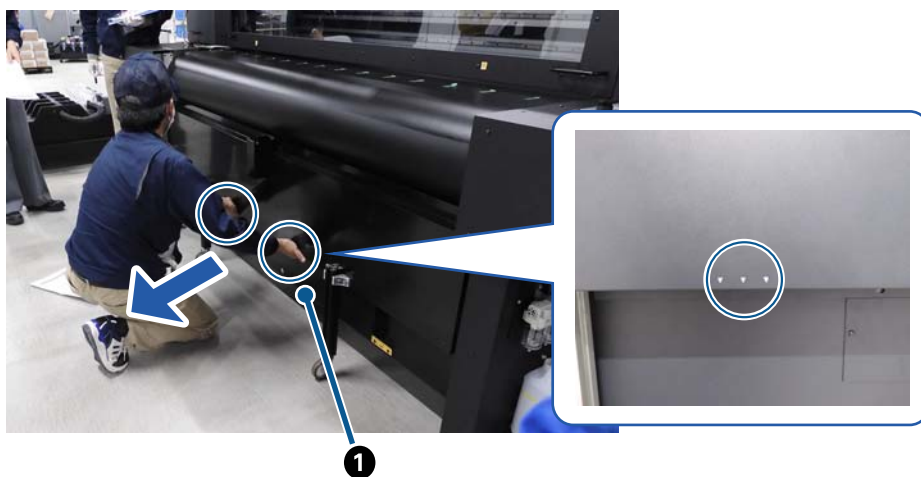


- 3** Lift up the tension bar.



1 Tension bar

- 4** Move to the front of this machine, make sure the belt cleaning unit is in the lowered position, and then grip the handle and pull out the belt cleaning unit.



Maintenance

① Handles

- 5** Use the curing tape to stick the edge of the plastic sheet to the belt. If you tape to apply the rear side of the plastic sheet to the belt, the tape will be less likely to peel when the belt is fed.



- 6** Press the feed button on the front panel and feed the plastic sheet to the rear.



- 7** Move to the product rear, and peel the plastic sheet off the belt.

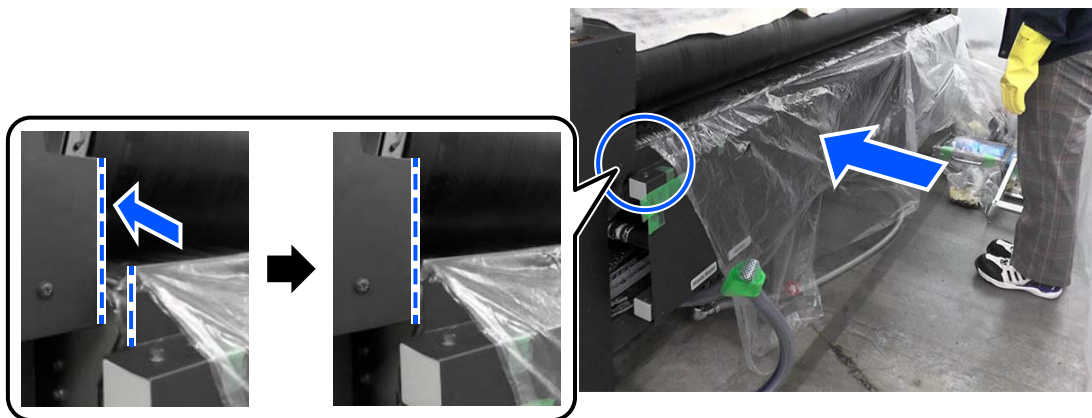


Maintenance

- 8 Cover the belt cleaning tank in the plastic sheet, spread out the wrinkles in the plastic, and then tape it down in 3 locations.



- 9 Push in the belt cleaning unit until the protruding part on the front of the belt cleaning unit is aligned with the position of the metal plate on the left side of the machine.



- 10 Go to the back of the printer and check the gap between the belt and the cleaning tank, and if the vinyl is touching or sticking to the belt, remove it.



Maintenance

- 11 Spread out the wrinkles in the plastic sheet, and then tape it down on the rear surface of the rear cover in 3 locations.



- 12 Use clips or the like to pinch the covering plastic sheet on the protrusion in front of the belt cleaning unit. Secure the plastic sheet so that it does not wrinkle, such as by floating up in the wind.

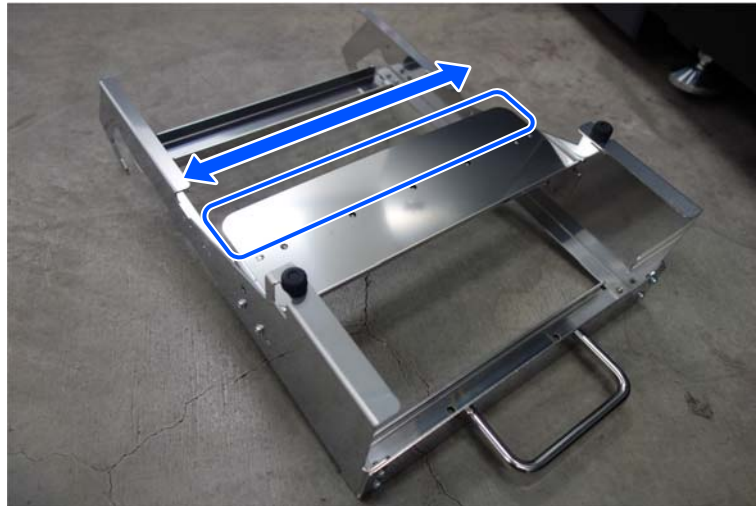


- 13 Make sure the vinyl is not touching or sticking to the belt. If the plastic sheet is attached, peel it off, then secure it using tape and take measures so that it does not rise up in the wind by placing a weight or the like on it.

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.

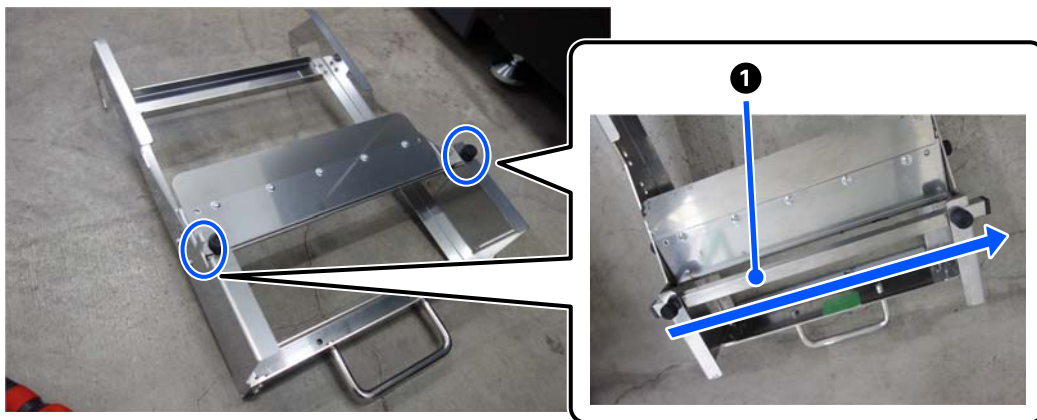
Maintenance



- 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.



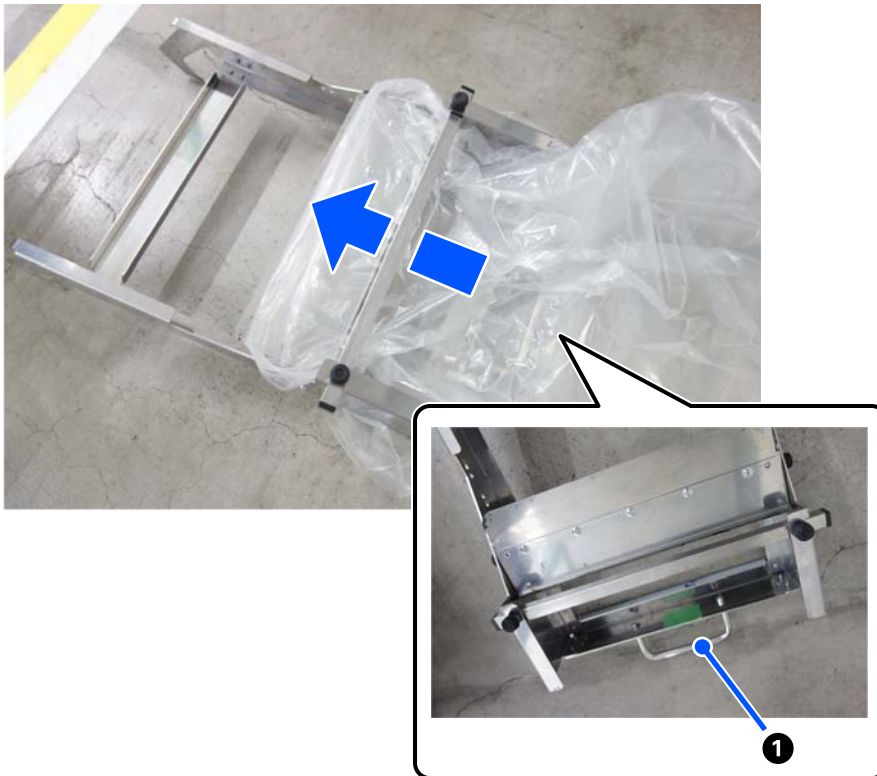
- 1** Bar

Maintenance

- 4** Tighten the two screws so that they are not loose.



- 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

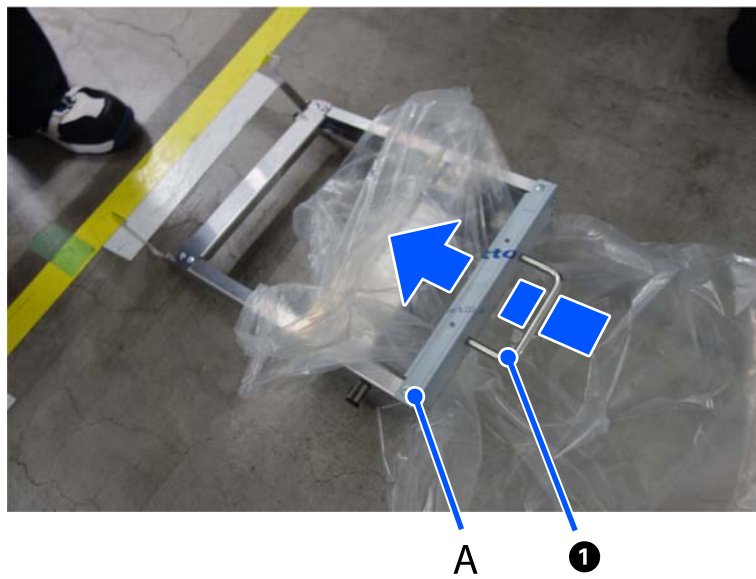
Maintenance

- 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 applying 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.



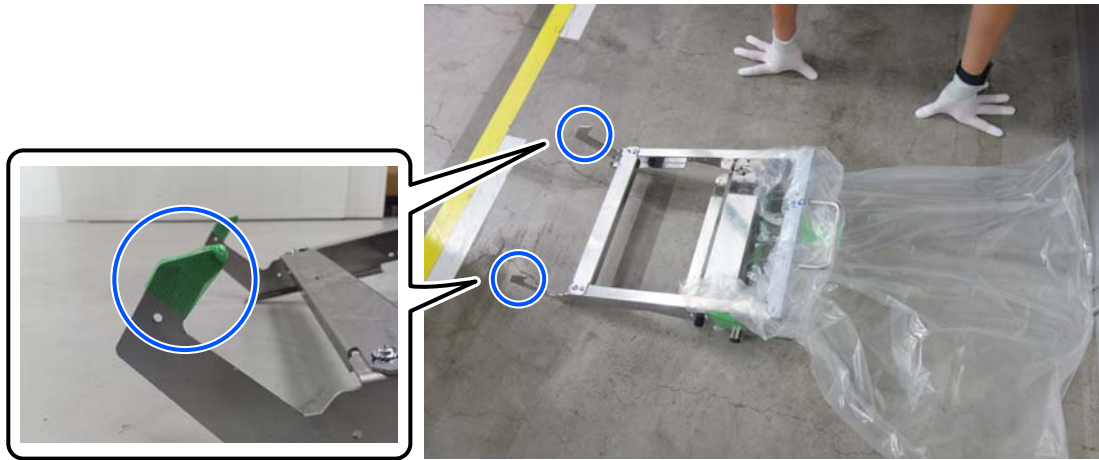
1 Handle

- 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.



Maintenance

- 9 Cover the tips of the hooks of the glue removal tool with protective tape.

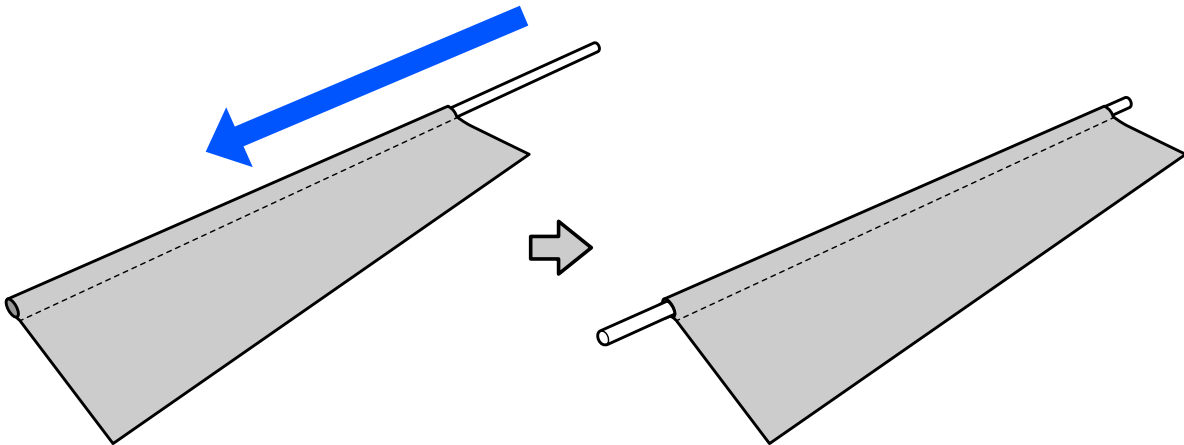


Preparing the Felt

Prepare some felt to soak up the glue remover.

When using the bundled felt

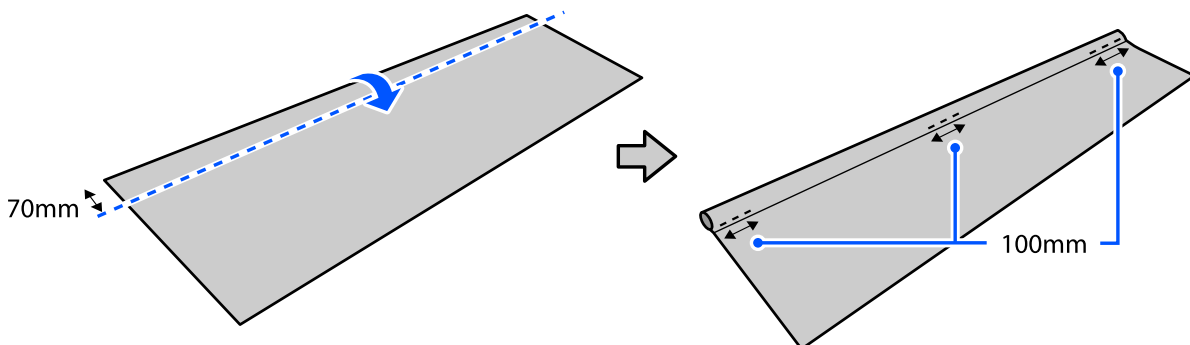
- 1 Put the felt rod through the glue-removal felt.



When using commercially available felt

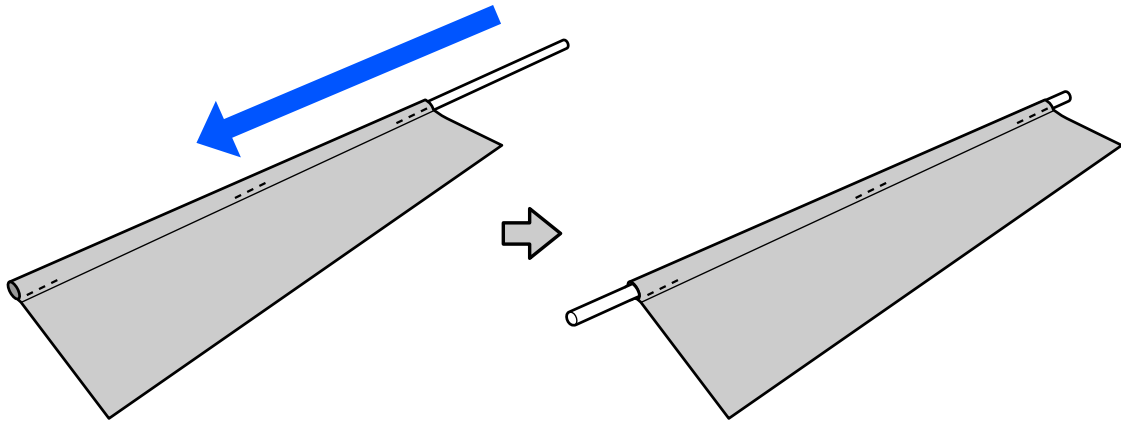
Make a loop out of the felt and sew it in place

- 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.



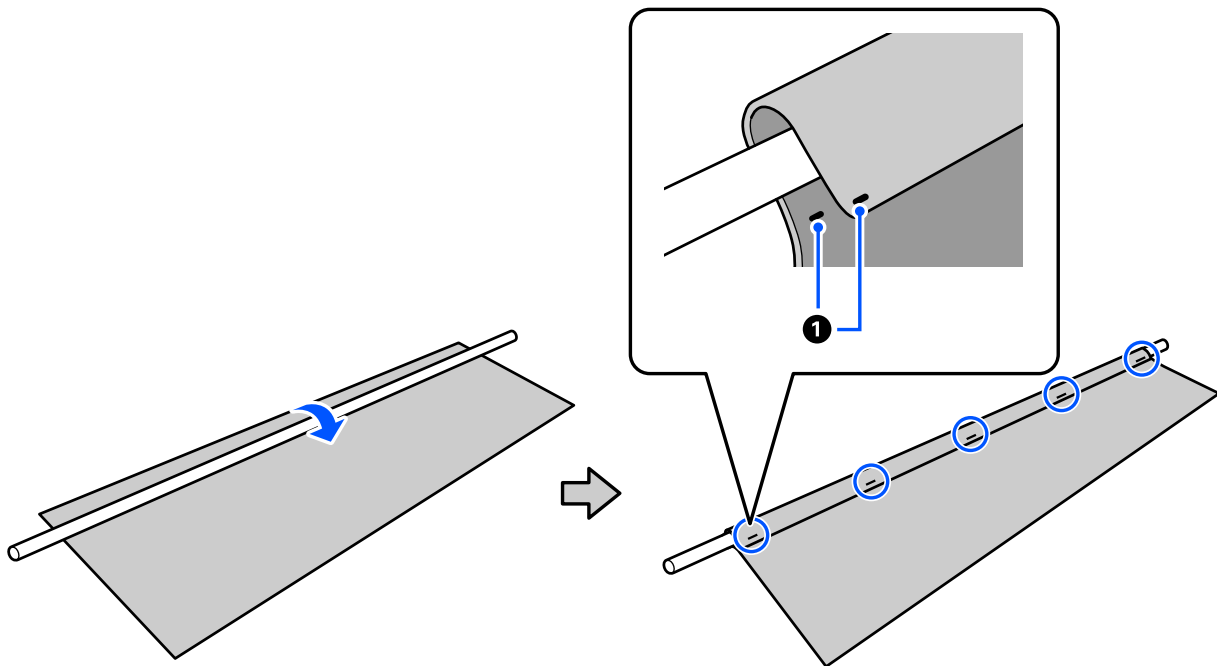
Maintenance

- 2** Put the felt rod through the felt.



Use cable ties to secure it in place

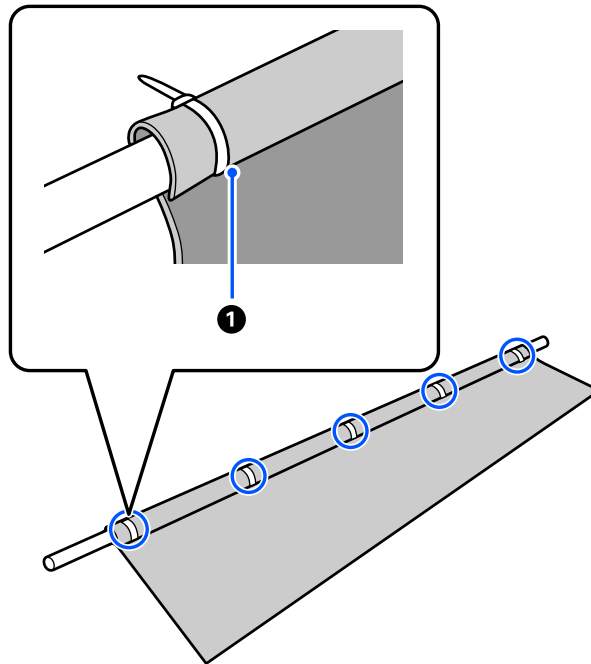
- 1** Hang the felt over the felt rod, and then use scissors to cut five slits in the felt large enough to pass the cable ties through.



1 Slits

Maintenance

- 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

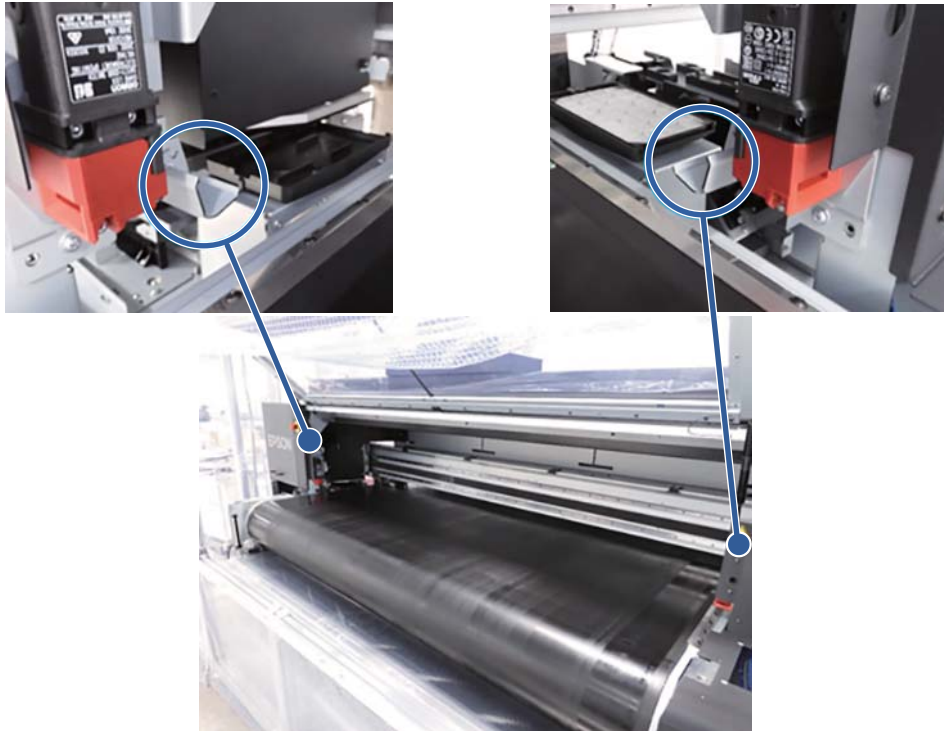
Attach the felt rod and the blade to the product.

- 1** Open the front cover.



Maintenance

- 2** Once the felt is set on the rod, install the rod on the L-shaped hooks inside the product.



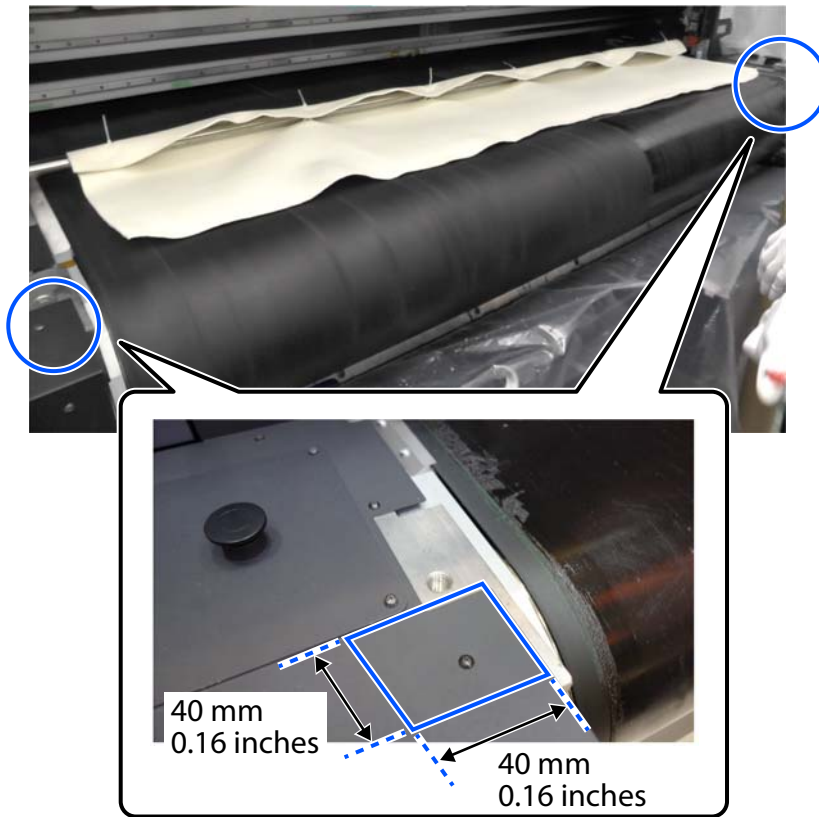
- 3** Spread the felt out towards the product front.



- 4** Attach protective tape cut into strips of approximately 40 x 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

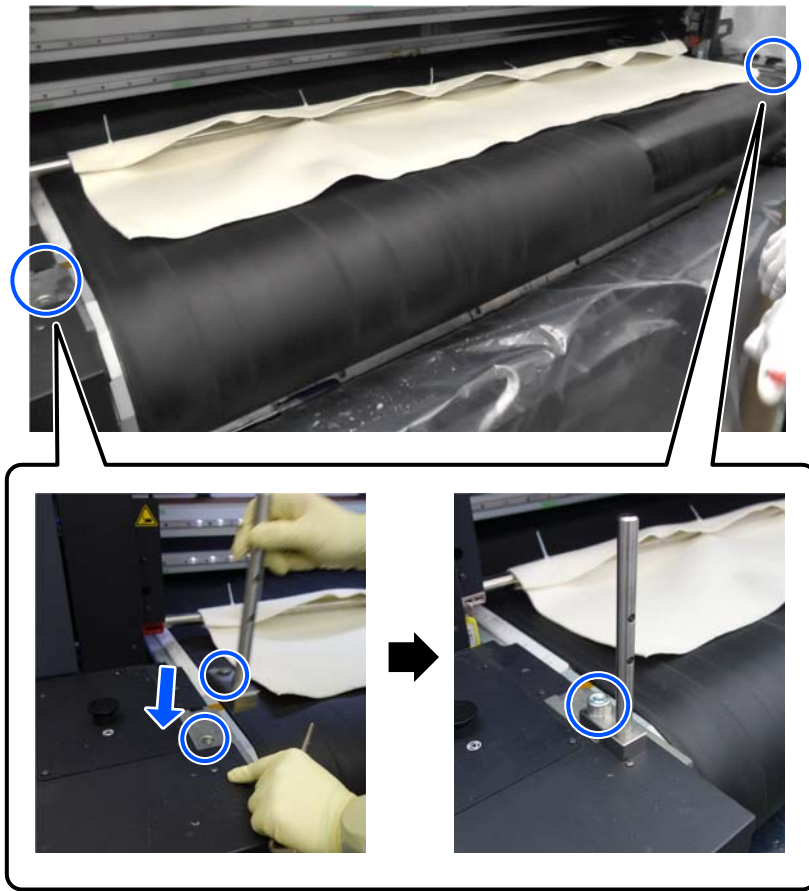


5

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.

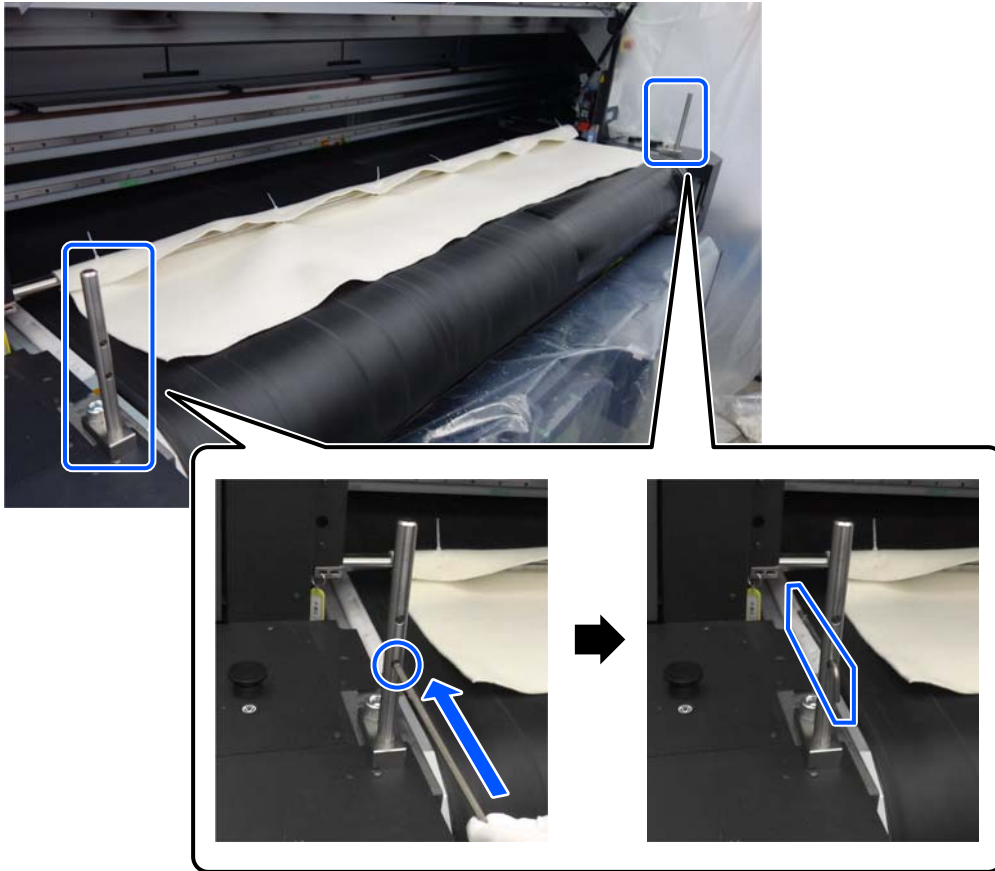
Attach the blade support on the opposite side of the belt as well, in the same way.

Maintenance



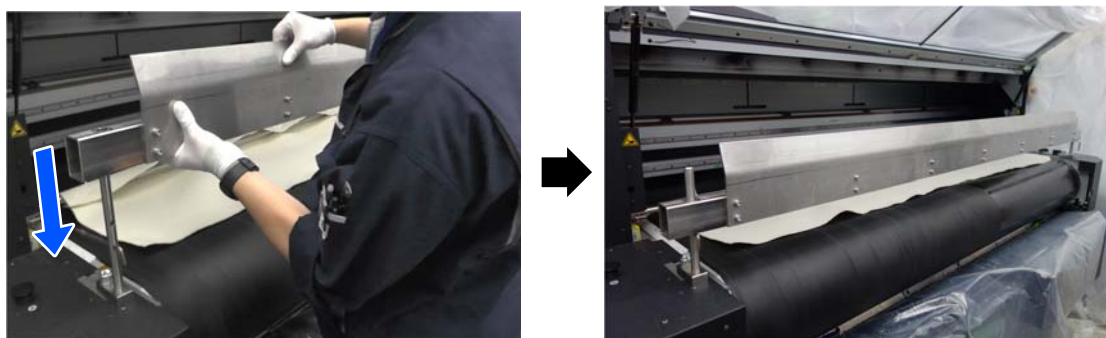
Maintenance

- 6** Insert a hex key of the same size through both of the bottom holes in the blade supports on either side.



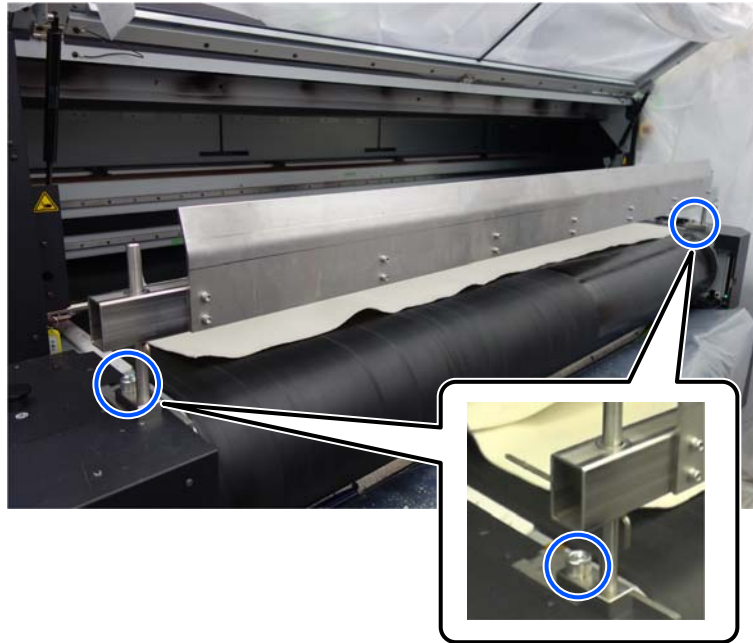
- 7** Have two people lift up the blade with the blade facing up, and pass the blade supports through the holes on either end of the blade.

Lower the blade slowly and evenly on both sides.



Maintenance

- 8** 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.

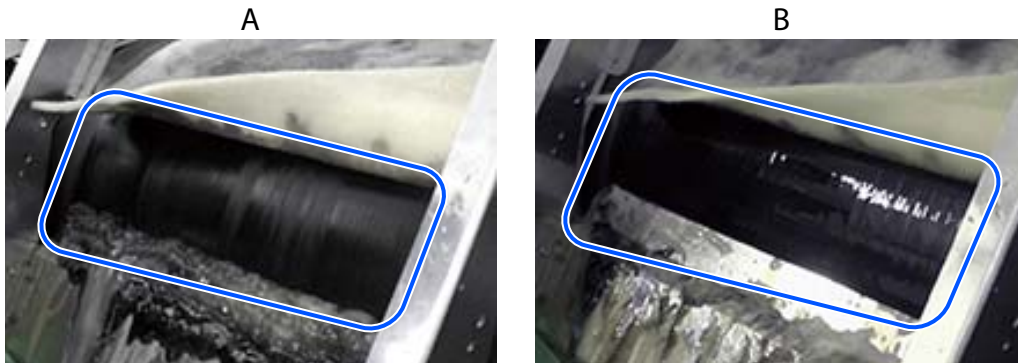


- 4 Ensure that the glue remover is uniformly spread throughout the felt.

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.

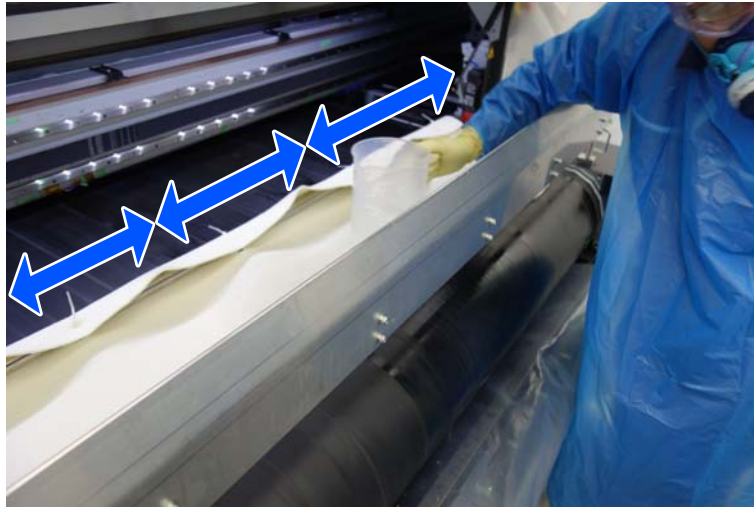
If the location where you will scrape off the glue on the belt dries before 5 minutes have passed, soak the felt with more glue remover.



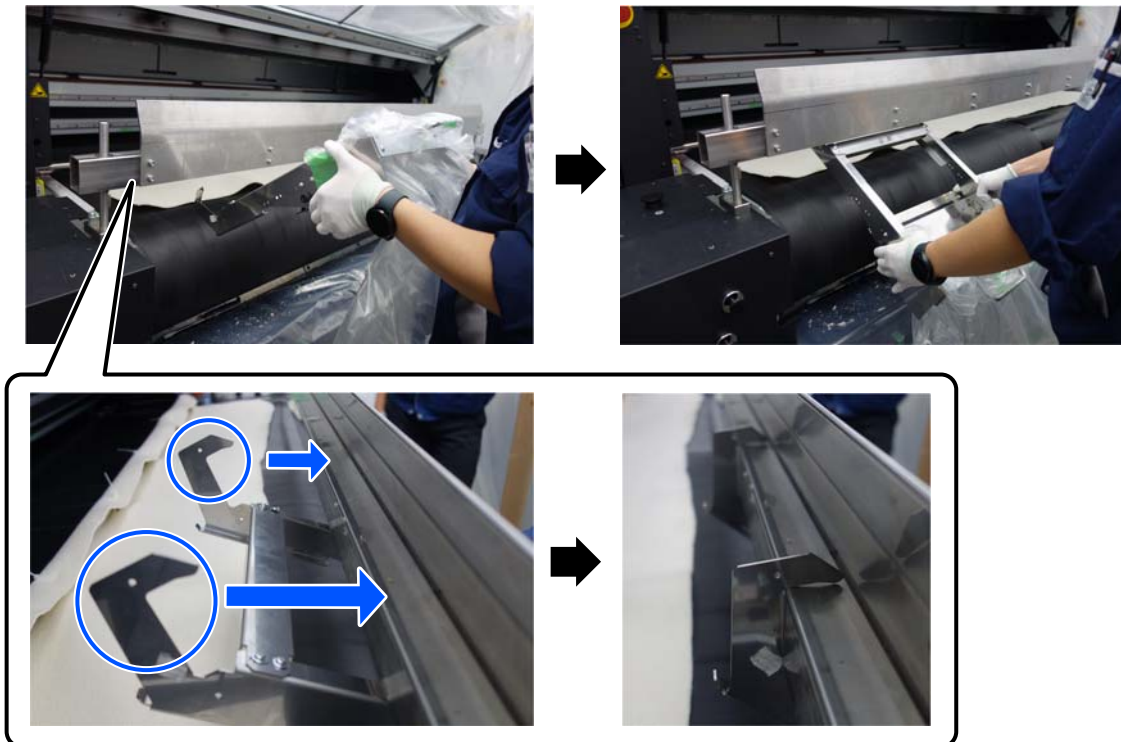
A: Glue remover has dried

Maintenance

B: Glue remover has not dried



- 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.



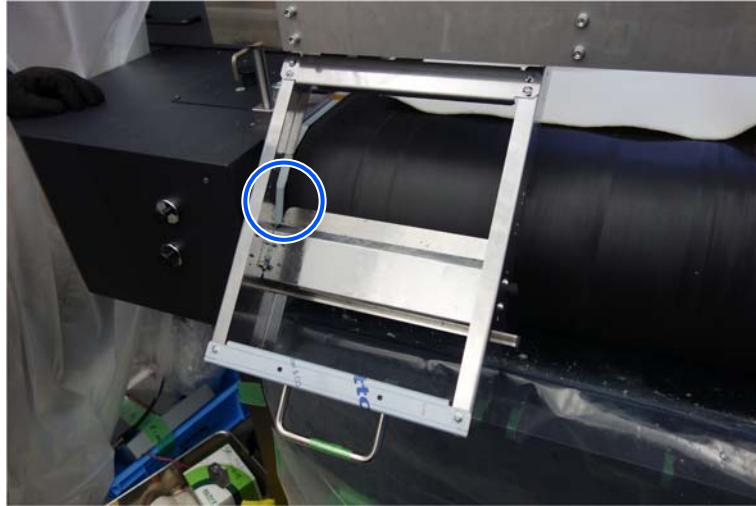
- 6** Hold the handle of the glue removal tool with both hands, and then scrape off the glue by pressing the blade of the glue removal tool against the surface of the belt so that the blade deforms a little under the pressure.

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.

Maintenance

! **Important:**

- ❑ Do not press the glue removal tool too hard against the belt. Doing so may cause the blade of the glue removal tool to come out of contact with the belt preventing you from scraping off the glue, or may damage the belt.
- ❑ Glue tends to remain on the belt edges, so focus on peeling those areas.



Maintenance

- 7** When the glue remover of the location where you have scraped glue off the belt becomes dry, lift the glue removal tool while keeping its hooks hooked over the blade.



- 8** Soak the area where you have scraped off the felt glue with more glue remover and then put on a glove or use a similar tool to push down the felt.

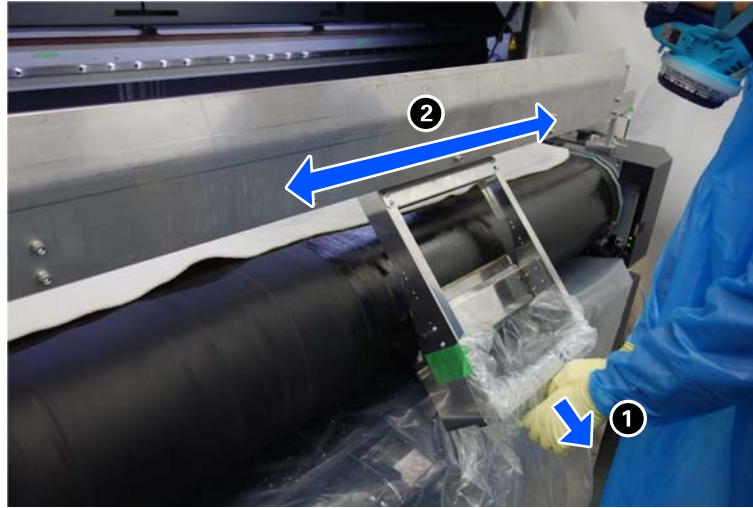
After about 5 minutes, the glue on the belt surface begins to dissolve. If the location where you have scraped off the glue on the belt dries before 5 minutes have passed, soak the felt with more glue remover.



- 9** Perform step 6 again and remove the glue.
Repeat steps 6 to 8 until you cannot scrape off the glue any further.

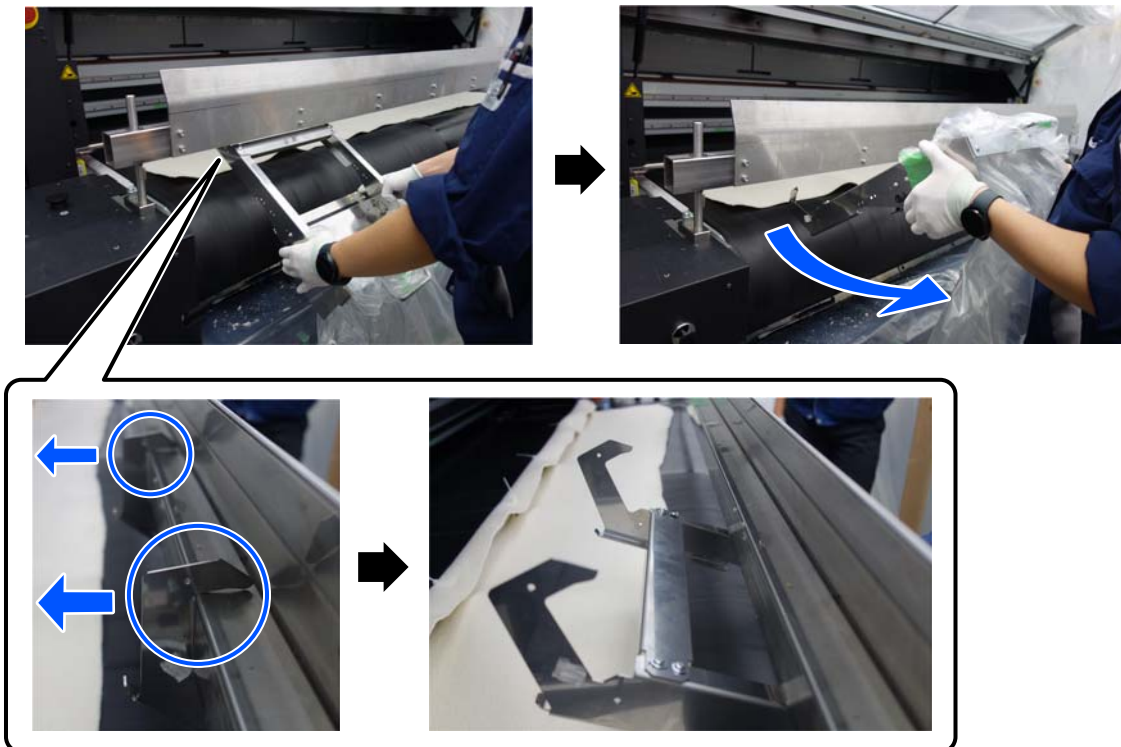
Maintenance

- 10 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.



- 11 Repeat steps 6 to 10 and scrape the glue off the entire belt.

- 12 When glue has been removed from the entire belt, remove the glue removal tool from the blade.

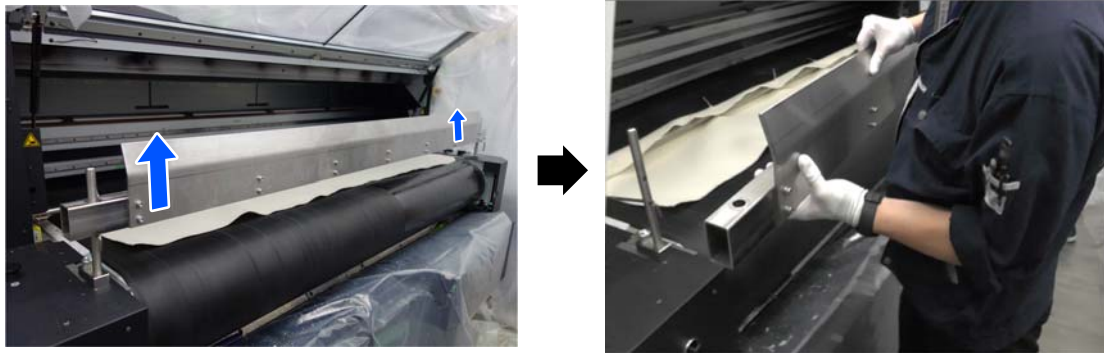


- 13 Touch the **Suspended** button on the control panel.

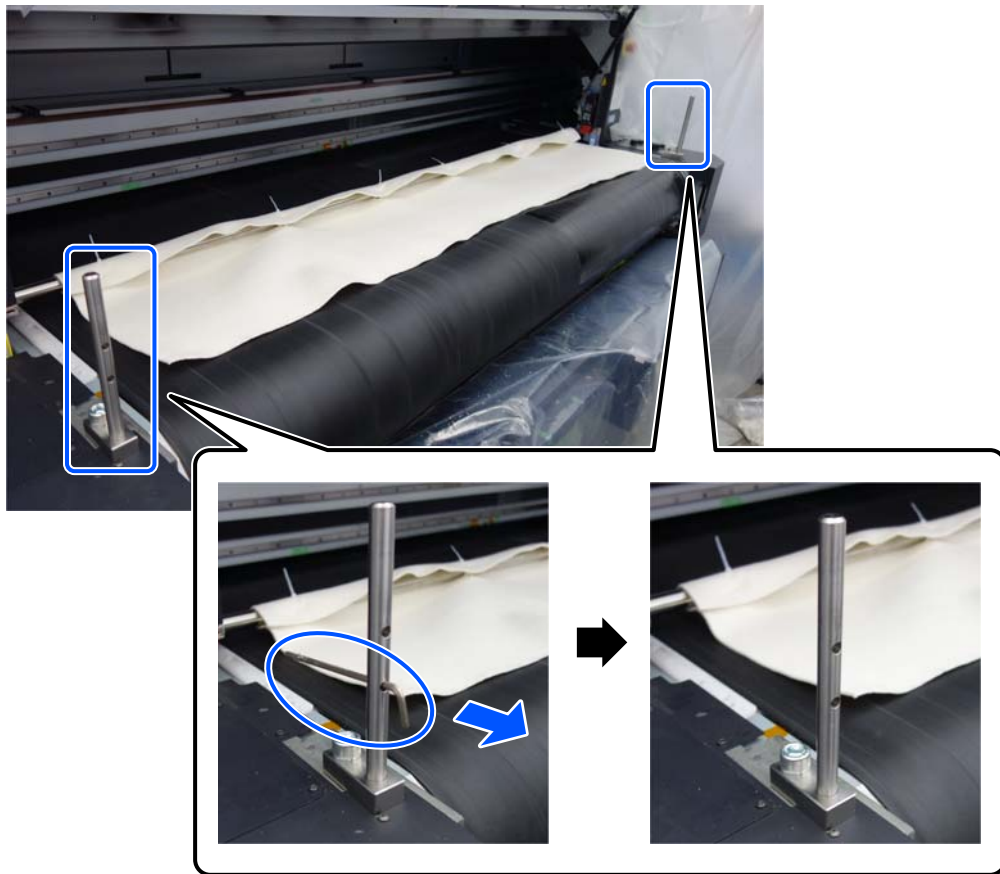
The belt will stop rotating.

Maintenance

- 14** Two people are required to lift the blade simultaneously on both right and left sides and remove it.

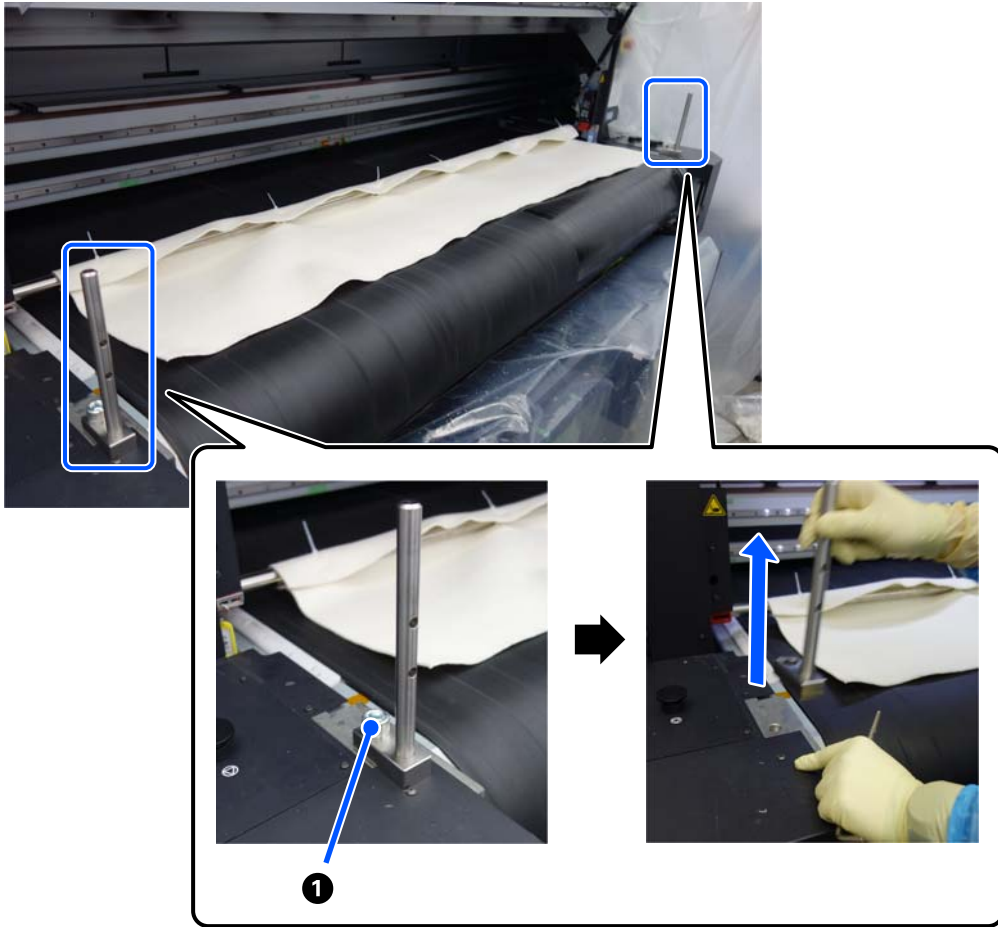


- 15** Remove the hex keys from the holes in the blade supports on either side.



Maintenance

- 16** Loosen the hexagonal screws on both blade supports and remove them from either side of the belt.



- ① Hexagonal screws

- 17** When glue has been removed from the entire belt, remove the felt rod.



Maintenance

- 18** Remove the felt from the felt rod.
Dispose of the felt in the proper manner for industrial waste.



- 19** 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.



- 20** Touch **Forward** or **Reverse** on the control panel.
The belt continues to rotate.

Maintenance

21 Check the belt surface for any glue residue.

If glue remains, soak the felt with glue remover and wipe it off.



22 Touch the **Stop - 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.

Belt surface cleaning

Use a wipe cloth soaked in ethanol (proper amount) to wipe the belt surface for 1 rotation.

- Press the Feed or Backfeed button on the front panel to rotate the belt.
- Wipe off the glue until the belt surface has a luster. Be especially careful to remove the glue from both edges of the belt.
- If the wipe cloth is dirty or glue chips occur, it means glue remains on the belt.

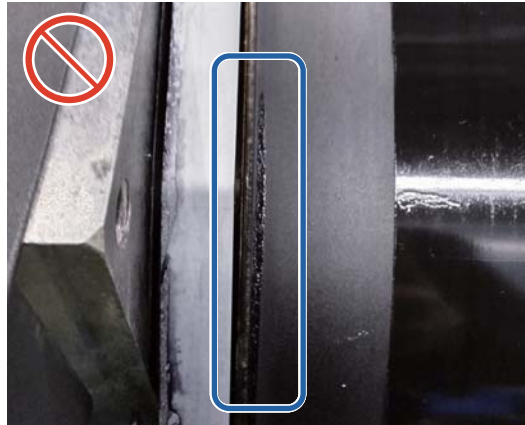
Maintenance

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 any glue or tape is stuck to the edges of the belt, the belt control unit may not operate correctly.



Clean-up

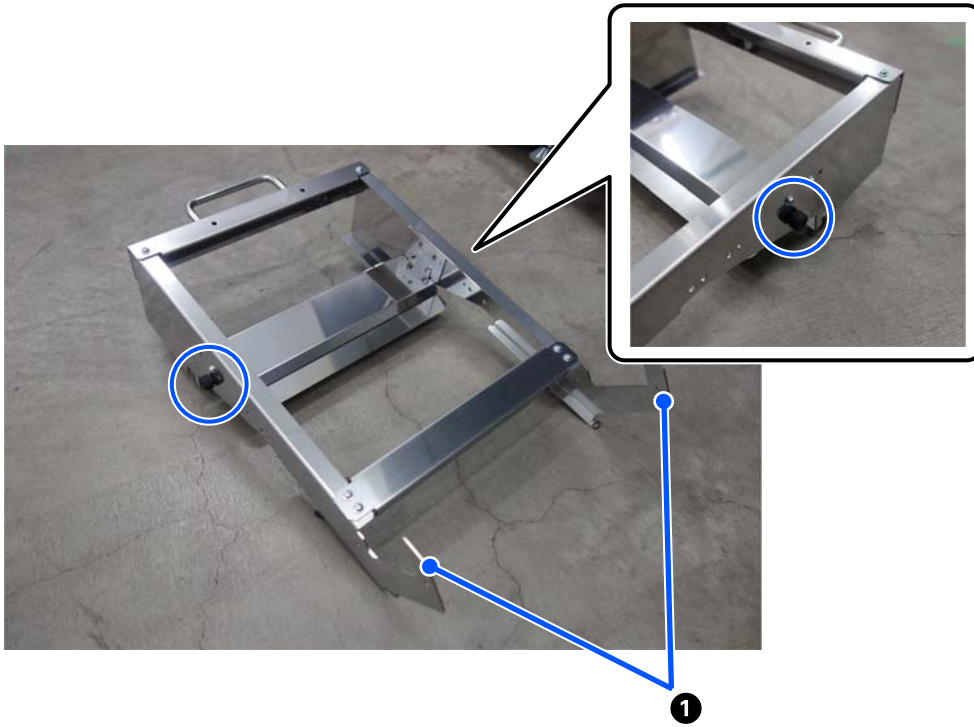
Clean up the tools you used.

If you apply glue at this stage, you do not need to perform steps 15 and on to remove the curing.

- 1 Remove the bag and protective tape that was secured to the glue removal tool.
- 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.



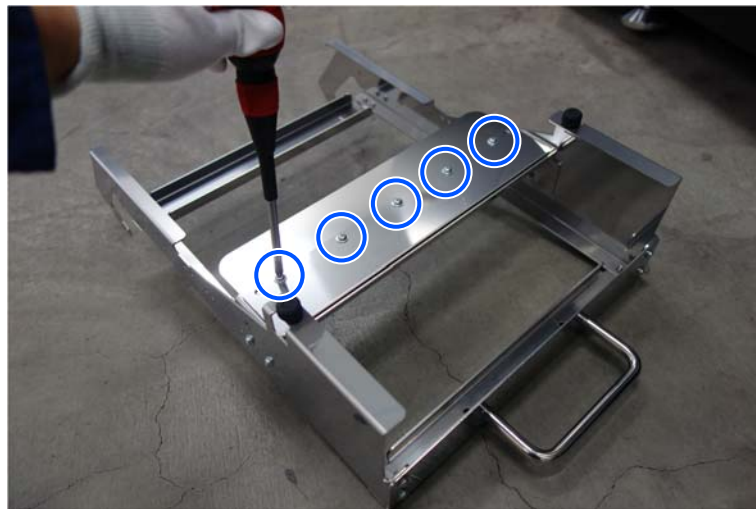
- 5 Wipe off the glue remover from both sides of plate A with an ethanol-soaked wipe cloth.
If the dirt cannot be removed, soak a wipe cloth in glue remover to wipe it off.
Dispose of the used wipe cloths in the proper manner for industrial waste.

Maintenance

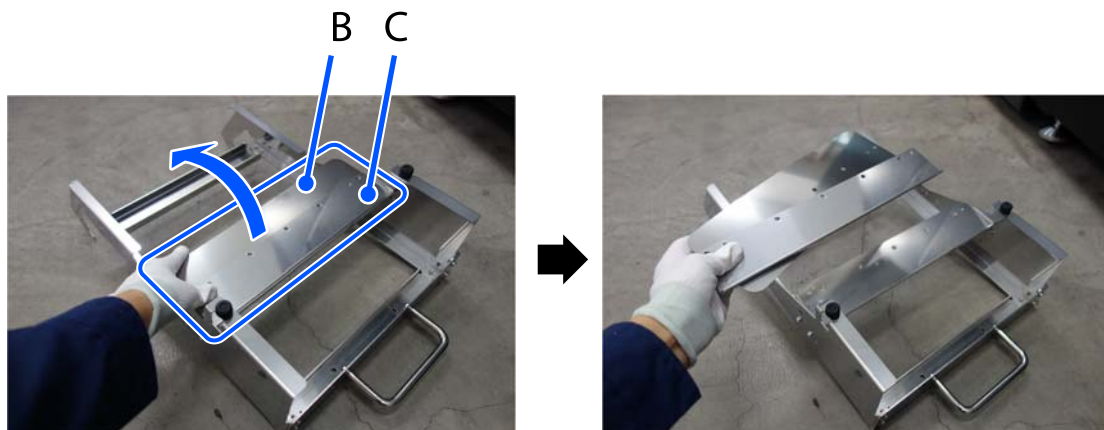


After wiping off the dirt, turn over the glue removal tool.

- 6** Loosen and remove the five screws with a Phillips-head screwdriver.



- 7** Remove plates B and C.

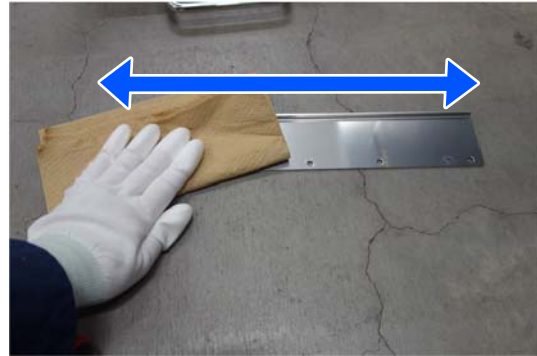
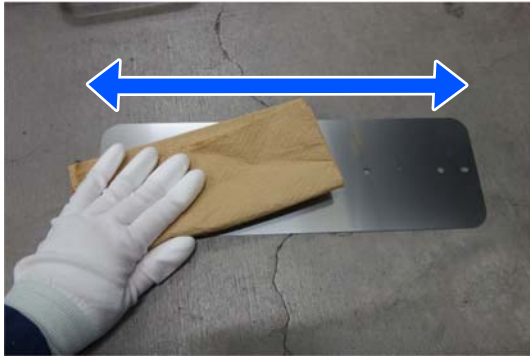


Maintenance

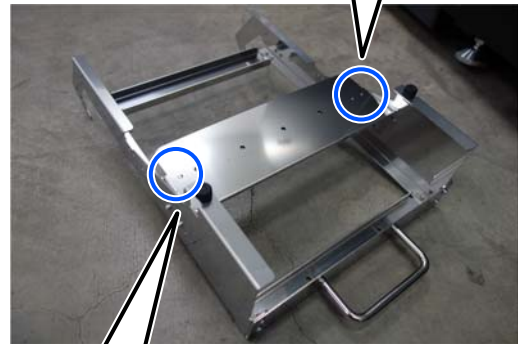
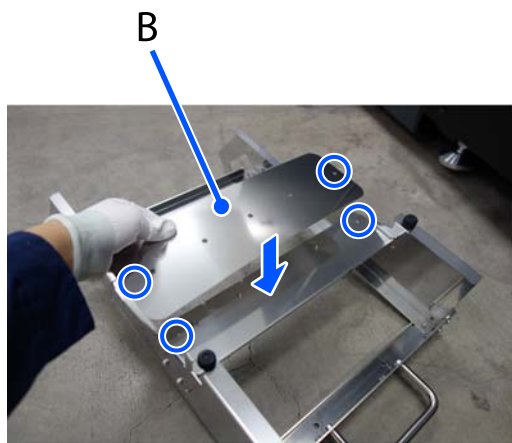
8 Wipe off the glue remover from both sides of plates B and C with an ethanol-soaked wipe cloth.

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.

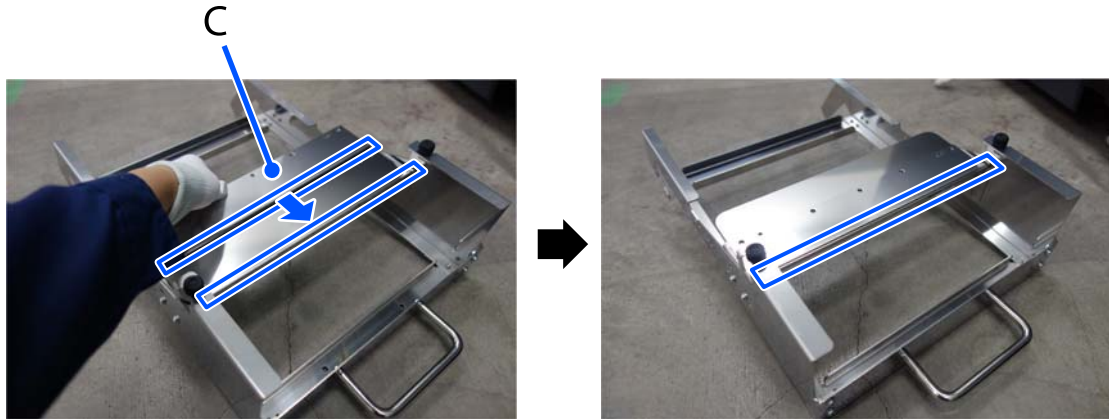


9 Align the holes on both ends of plate B with the protruding parts of the glue removal tool and attach the plate.

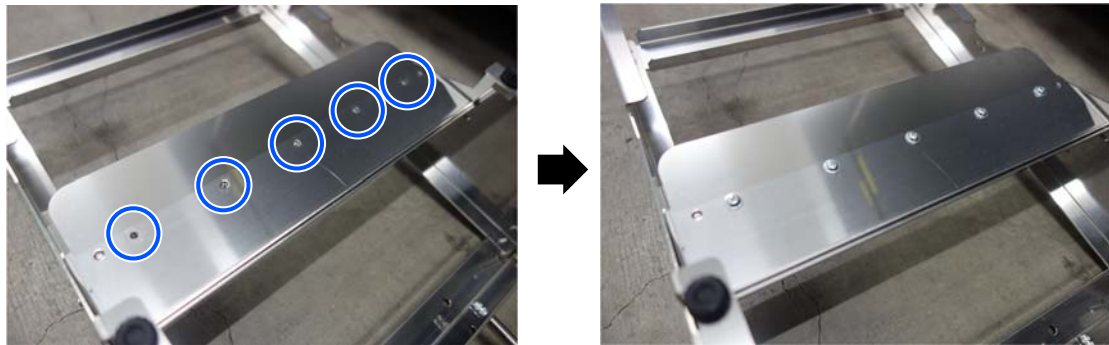


Maintenance

- 10** Align the L-shaped section of plate C with the corner of the glue removal tool and attach it.

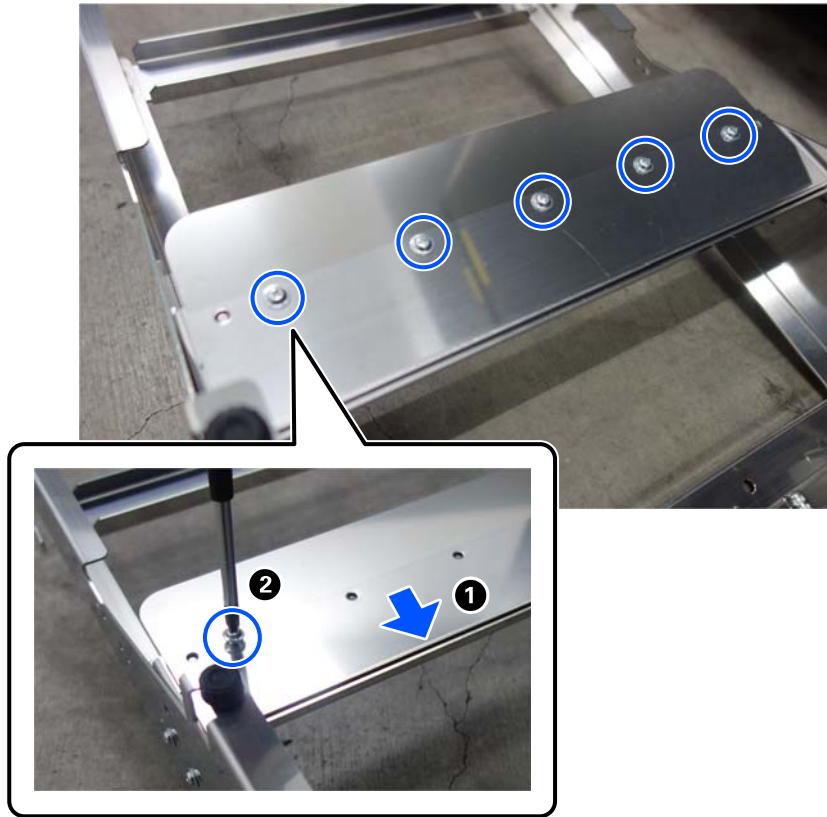


- 11** Loosely tighten the five screws with a Phillips-head screwdriver.



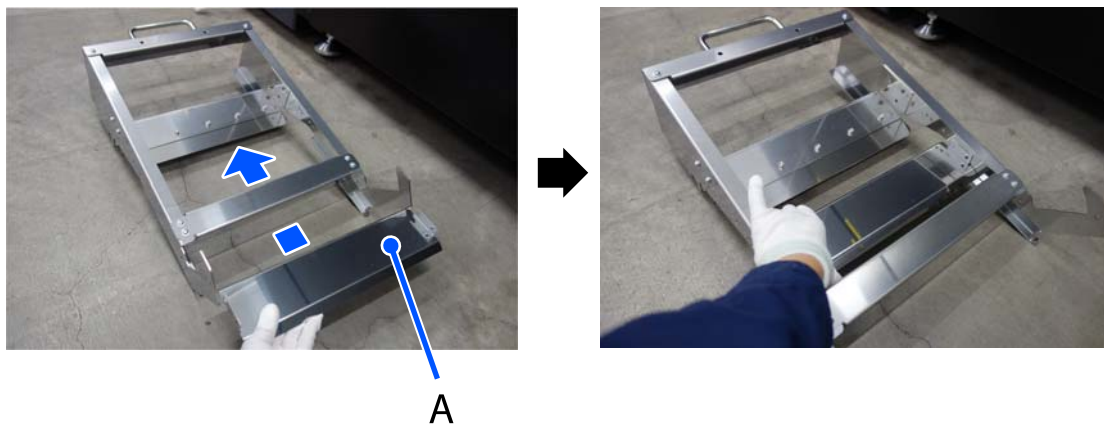
Maintenance

- 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.



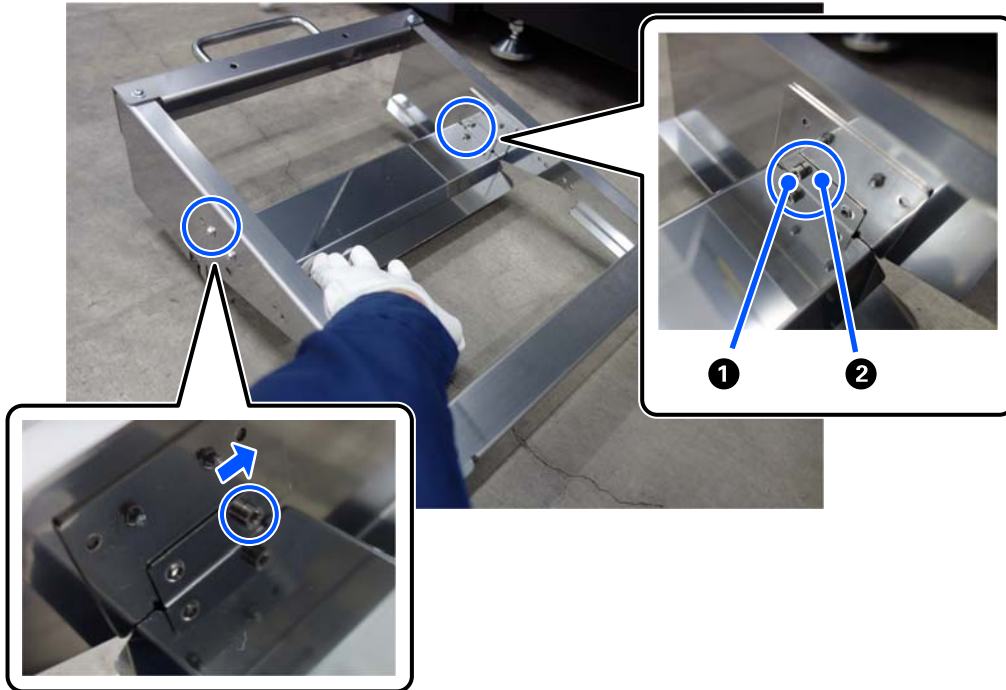
After tightening the screws, turn over the glue removal tool.

- 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.



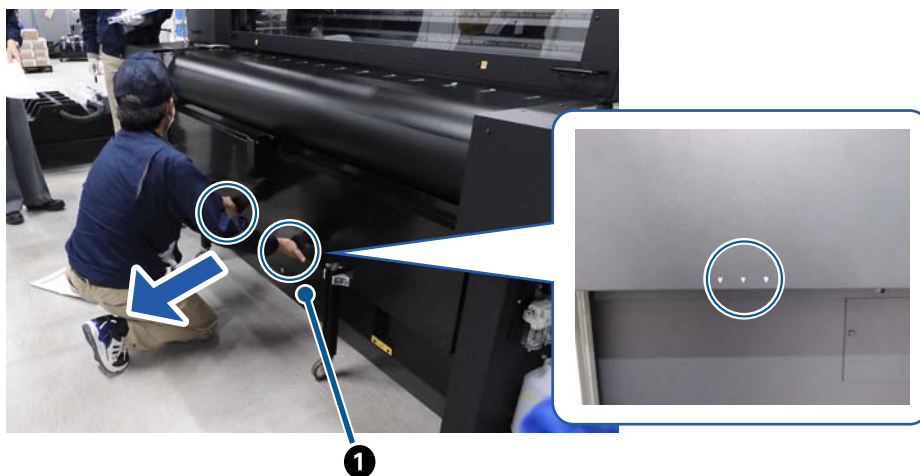
- 16** Close the front cover.

If you apply glue now, you do not need to perform the following steps.

Maintenance

- 17** Pull out the belt cleaning unit.

Hold the handles on the front of the belt cleaning unit to pull it out.



- 1** Handles

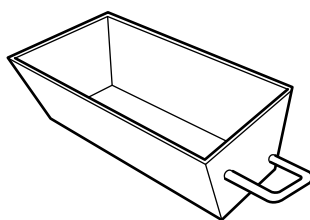
- 18** Peel off the tape securing the curing plastic sheet and pull the plastic sheet out from the belt cleaning tank side.

- 19** Push the belt cleaning unit back to its original position.

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.

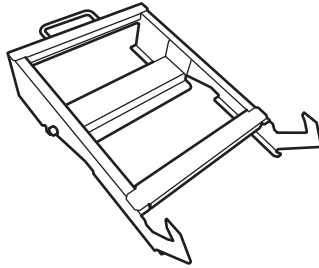


Maintenance

Note:

See the following when using the glue removal tool.

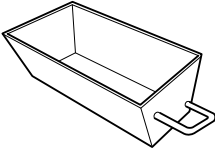
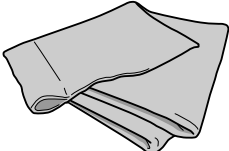
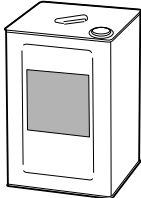

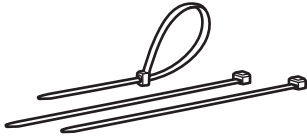
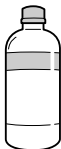

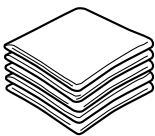
 [“Removing Glue \(When Using the Glue Removal Tool\)” on page 316](#)




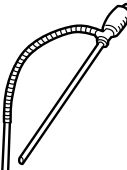

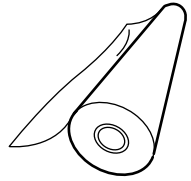
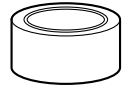
Required number of workers	Min. 2 persons	
Personal protective equipment	The following is the protective equipment that must be worn when using the glue or glue remover recommended by Epson. For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.	
	Eye 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.

Maintenance


Required Items	Quantity	Details/Use	
Glue collection bucket 	1	Bundled item	Push this against the belt and scrape off the glue.
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. The amount of glue remover necessary is a reference value applicable when applying glue using the type of glue and applied amount described in this manual.
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.
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.

Maintenance

Required Items	Quantity	Details/Use	
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.
bags or plastic sheets 	Proper amount	Commercially available 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. Use a material that does not dissolve when exposed to organic solvent, such as polyethylene.
Protective tape 	Proper amount	Commercially available	Used to protect the product bottom.



Warning:

Before starting this procedure, be sure to read the following.  [“Precautions Regarding Maintenance” on page 177](#)

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 volume 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 321](#)

**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 360](#)

**3. Attach felt to the felt rod**

 ["Preparing the Felt" on page 364](#)

**4. Attach the felt rod to the product**

 ["Setting the felt" on page 366](#)

**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 368](#)

Maintenance



7. Clean the surface of the belt

["Belt surface cleaning" on page 373](#)



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 374](#)

You can watch a video of the procedure on YouTube.

https://support.epson.net/p_doc/80d/

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

From the Maintenance screen on the control panel, touch **Maintenance - Adhesive Material Maintenance**, in that order.

2

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 and Administrator Password" on page 63](#)

- Save the Administrator Password you set in a safe location so that you do not forget it.*

See the following if you forget your Administrator Password.

["If you have forgotten your administrator password" on page 446](#)

3

Touch **Removal Mode - Start**.

When you touch **Forward** or **Reverse** once on the control panel, the belt will continue to rotate until you touch **Stop**.

Touch **Done** to exit **Removal Mode** and return to the mode selection screen.

Maintenance

Product curing

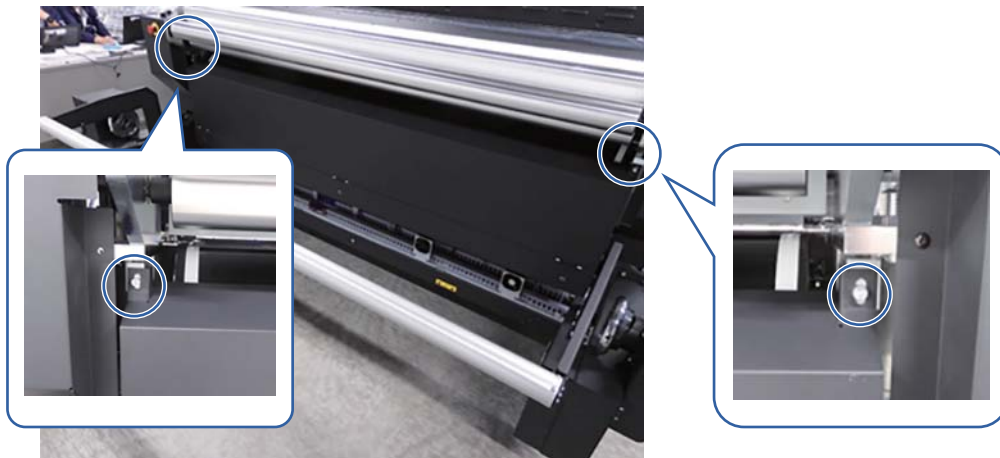
Cover the product so that glue remover or scraped glue does not enter under the product and cause a malfunction. This section describes the procedures recommended by Epson.

- 1 Push down the tension bar on the machine rear.



- 1 Tension bar

- 2 Remove the 2 screws that secure the machine rear cover and pull down the cover.



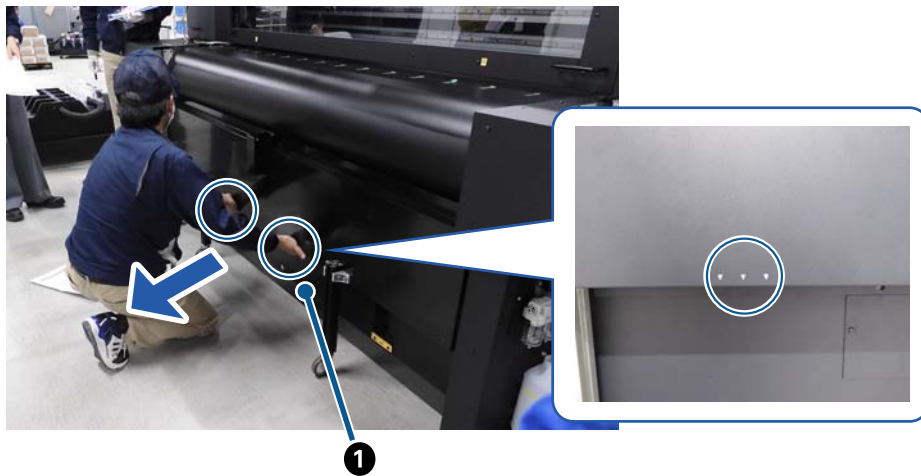
Maintenance

- 3** Lift up the tension bar.



- 1** Tension bar

- 4** Move to the front of this machine, make sure the belt cleaning unit is in the lowered position, and then grip the handle and pull out the belt cleaning unit.



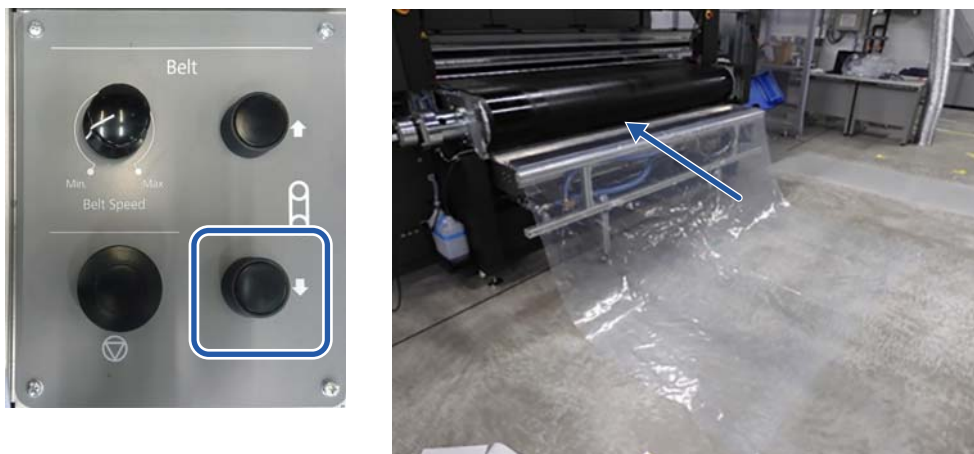
- 1** Handles

Maintenance

- 5 Use the curing tape to stick the edge of the plastic sheet to the belt. If you tape to apply the rear side of the plastic sheet to the belt, the tape will be less likely to peel when the belt is fed.



- 6 Press the feed button on the front panel and feed the plastic sheet to the rear.



- 7 Move to the product rear, and peel the plastic sheet off the belt.

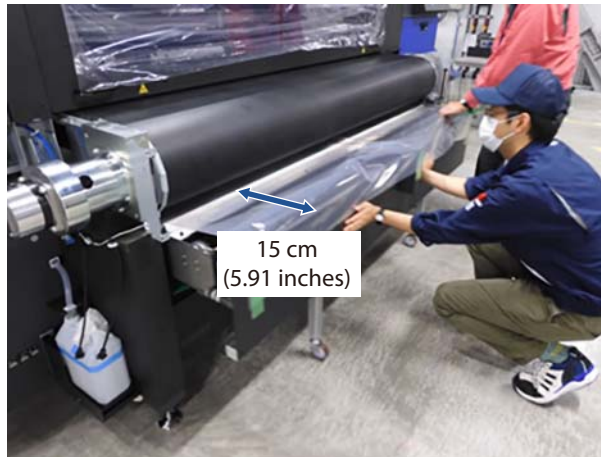


Maintenance

- 8** Cover the belt cleaning tank in the plastic sheet, spread out the wrinkles in the plastic, and then tape it down in 3 locations.



- 9** Push the belt cleaning unit partially back. Place the glue collection bucket on top of the cleaning tank in a position where the bucket can be pressed against the belt (about 15 cm [5.91 inches] between the belt and the cleaning unit).



- 10** Go to the back of the printer and check the gap between the belt and the cleaning tank, and if the vinyl is touching or sticking to the belt, remove it.



Maintenance

- 11** Spread out the wrinkles in the plastic sheet, and then tape it down on the rear surface of the rear cover in 3 locations.



- 12** Use clips or the like to pinch the covering plastic sheet on the protrusion in front of the belt cleaning unit. Secure the plastic sheet so that it does not wrinkle, such as by floating up in the wind.



- 13** Make sure the vinyl is not touching or sticking to the belt. If the plastic sheet is attached, peel it off, then secure it using tape and take measures so that it does not rise up in the wind by placing a weight or the like on it.

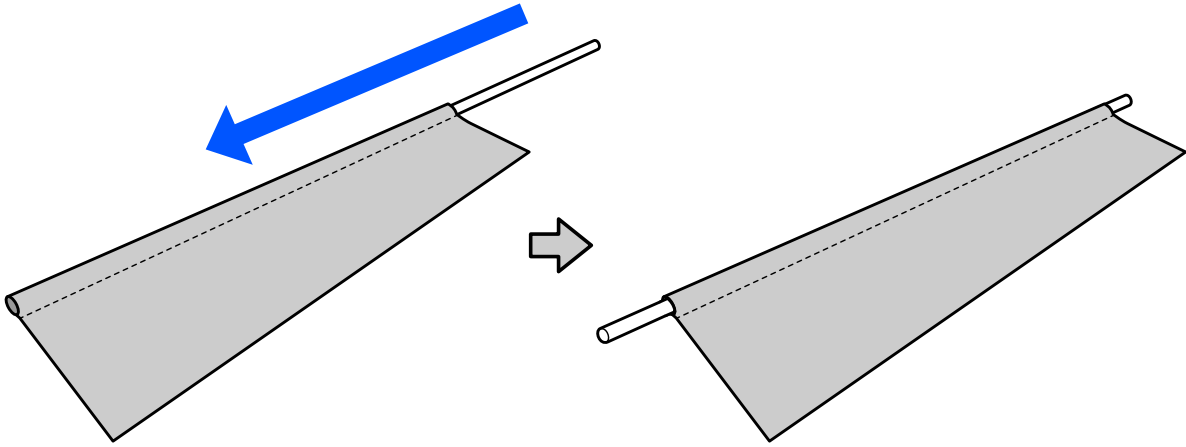
Preparing the Felt

Prepare some felt to soak up the glue remover.

Maintenance

When using the bundled felt

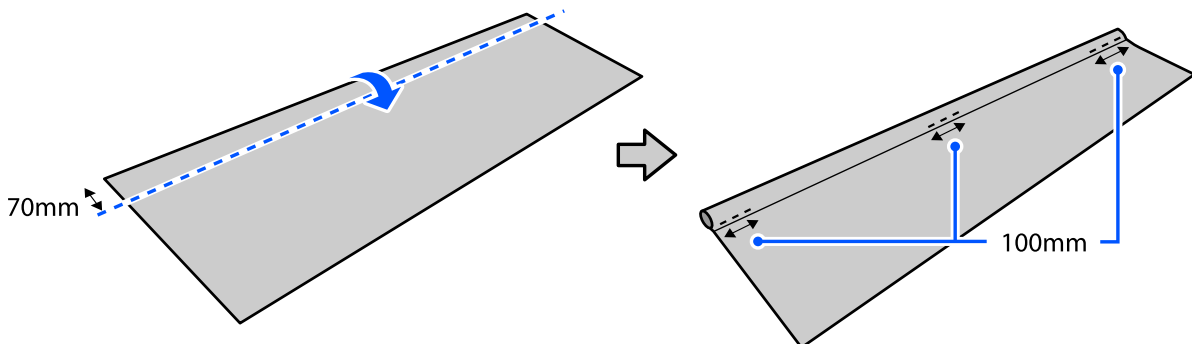
- 1 Put the felt rod through the glue-removal felt.



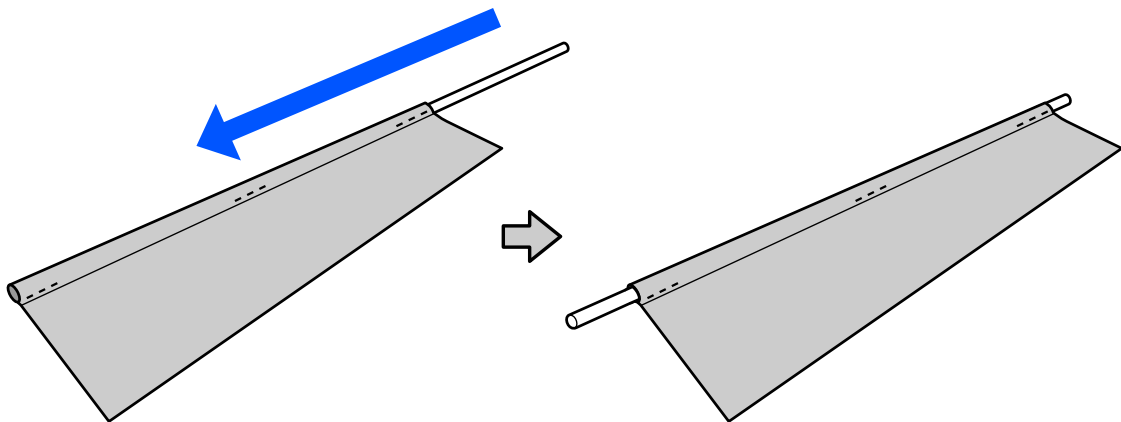
When using commercially available felt

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.



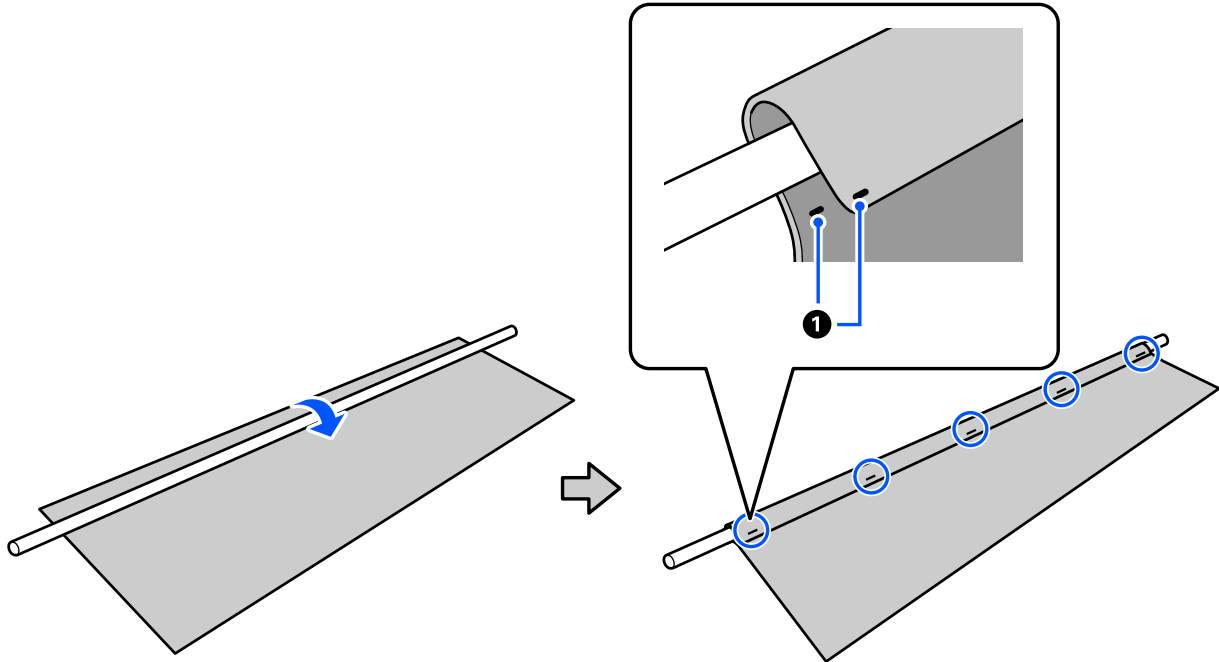
- 2 Put the felt rod through the felt.



Maintenance

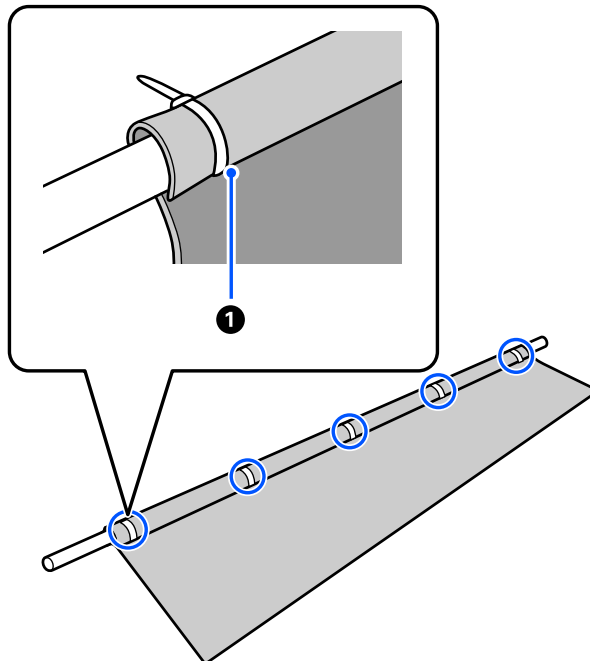
Use cable ties to secure it in place

- 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

Setting the felt

Set the felt in the printer.

Maintenance

- 1 Open the front cover.



- 2 Once the felt is set on the rod, install the rod on the L-shaped hooks inside the product.



Maintenance

- 3 Spread the felt out towards the product front.



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.

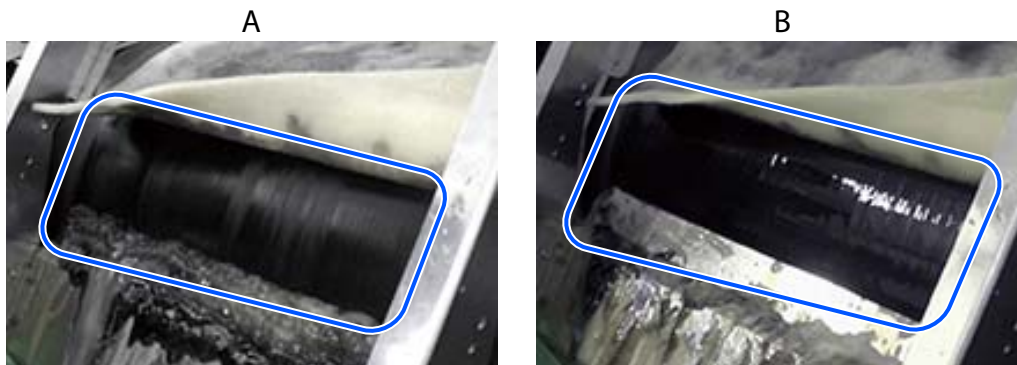


- 4** Ensure that the glue remover is uniformly spread throughout the felt.

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.

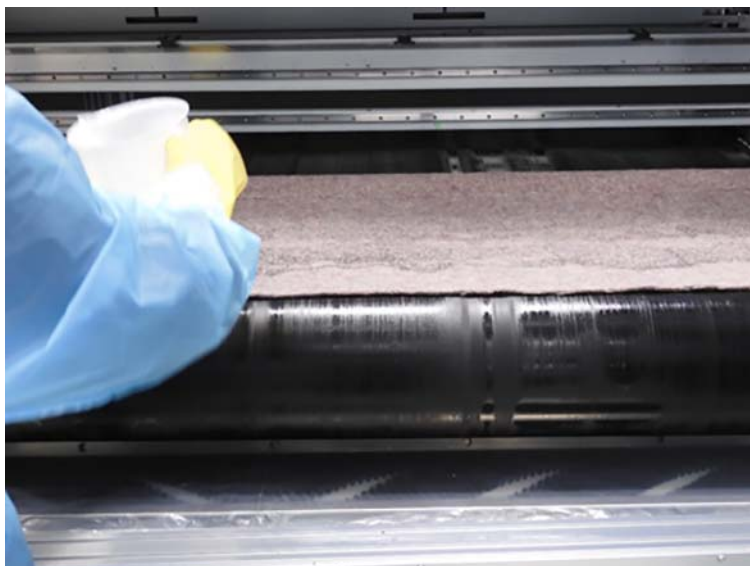
If the location where you will scrape off the glue on the belt dries before 5 minutes have passed, soak the felt with more glue remover.



A: Glue remover has dried

Maintenance

B: Glue remover has not dried



- 5** Hold the handle of the glue collection bucket with both hands and press it against the belt surface to scrape off the glue.

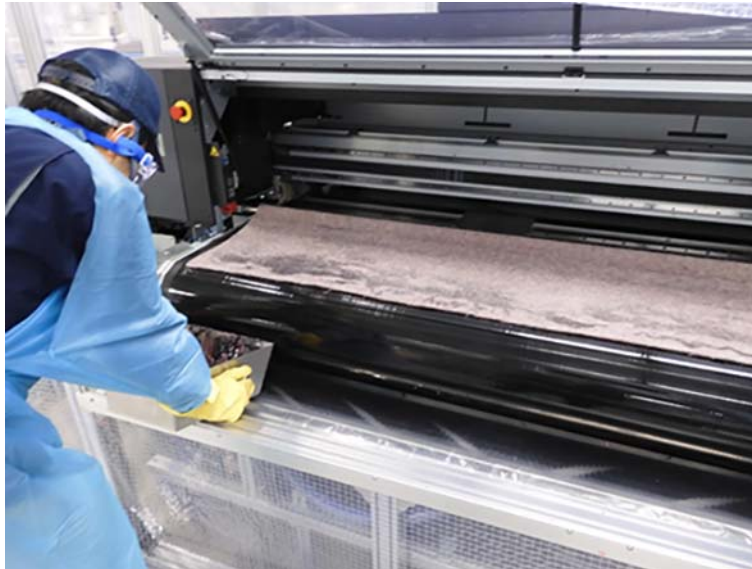
Use a scraper or the like to push glue on the bucket rim inside the bucket.

! **Important:**

- Pressing too hard on the glue collection bucket may scratch the surface of the belt.
- Glue tends to remain on the belt edges, so focus on peeling those areas.
By inserting the handle of the glue collection bucket into the notch on the exterior cover of the printer, the bucket can be placed firmly against the belt edges.



Maintenance



6 When the glue remover of the location where you have scraped glue off the belt becomes dry, remove the glue collection bucket from the belt.

7 Soak the area where you have scraped off the felt glue with more glue remover and then put on a glove or use a similar tool to push down the felt.

After about 5 minutes, the glue on the belt surface begins to dissolve. If the location where you have scraped off the glue on the belt dries before 5 minutes have passed, soak the felt with more glue remover.

8 Perform step 5 again and remove the glue.
Repeat steps 5 to 7 until you cannot scrape off the glue any further.

9 When the glue has been removed and cannot be scraped off any further, move to an area where the glue has not been scraped off.



10 Repeat steps 5 to 9 and scrape the glue off the entire belt.

Maintenance

- 11 Once all the glue is removed from the belt, touch the **Suspended** button on the control panel.
The belt will stop rotating.

- 12 Remove the felt rod.



- 13 Remove the felt from the felt rod.
Dispose of the felt in the proper manner for industrial waste.



Maintenance

- 14** 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.



- 15** Touch **Forward** or **Reverse** on the control panel.

The belt continues to rotate.

- 16** Check the belt surface for any glue residue.

If glue remains, soak the felt with glue remover and wipe it off.



- 17** Touch the **Stop - 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.

Belt surface cleaning

Use a wipe cloth soaked in ethanol (proper amount) to wipe the belt surface for 1 rotation.

Maintenance

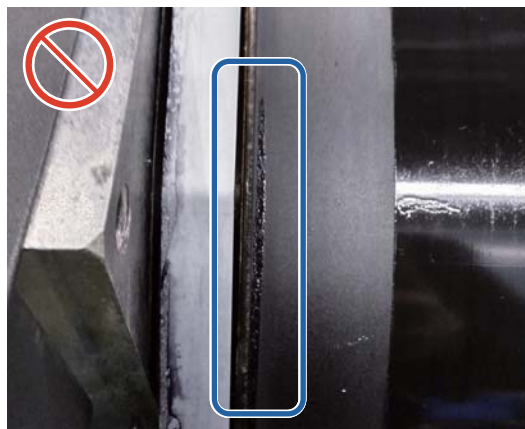
- ❑ Press the Feed or Backfeed button on the front panel to rotate the belt.
- ❑ Wipe off the glue until the belt surface has a luster. Be especially careful to remove the glue from both edges of the belt.
- ❑ If the wipe cloth is dirty or glue chips occur, it means glue remains on the belt.

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 any glue or tape is stuck to the edges of the belt, the belt control unit may not operate correctly.



Clean-up

Clean up the tools you used.

If you apply glue at this stage, you do not need to perform steps 3 and on to remove the curing.

Maintenance

- 1 Dispose of the glue in the glue collection bucket in the proper manner for industrial waste.



- 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.

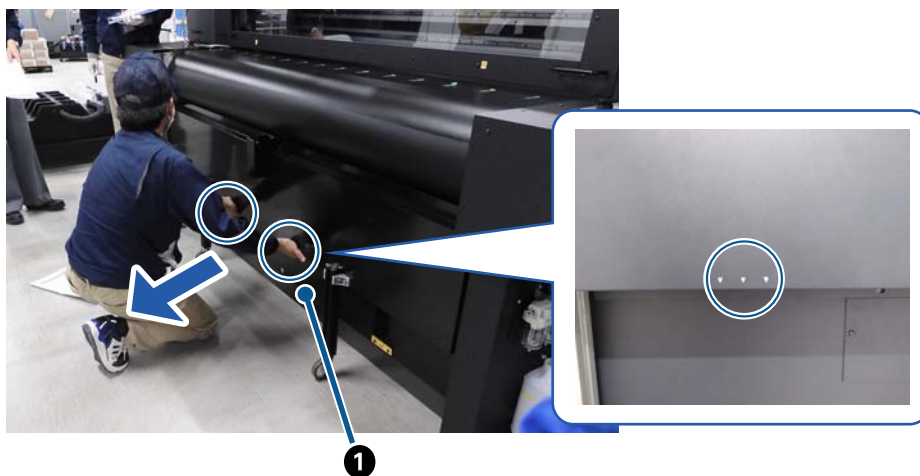


- 3 Close the front cover.

Maintenance

- 4** Pull out the belt cleaning unit.

Hold the handles on the front of the belt cleaning unit to pull it out.



- 1** Handles

- 5** Peel off the tape securing the curing plastic sheet and pull the plastic sheet out from the belt cleaning tank side.

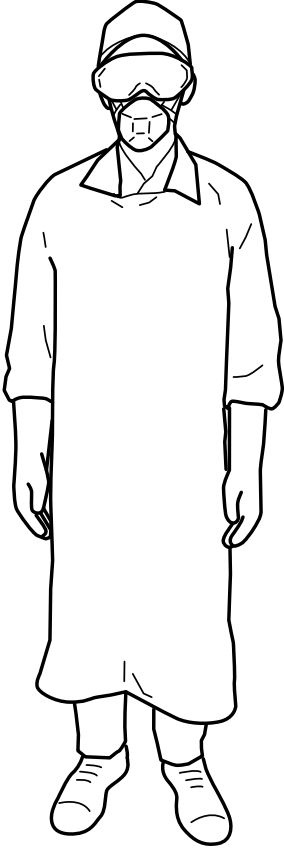
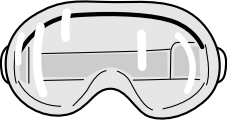

- 6** Push the belt cleaning unit back to its original position.

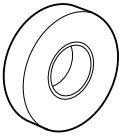
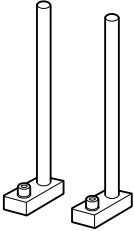

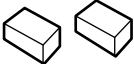
Applying Glue

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.


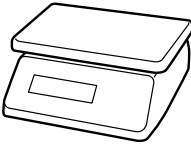

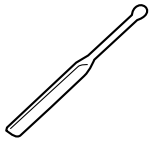
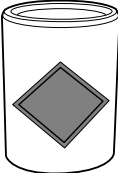
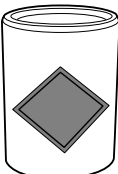
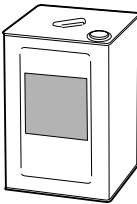
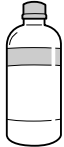
Required number of workers	Min. 2 persons
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Maintenance



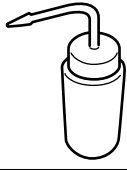
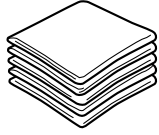
<p>Personal protective equipment</p>	<p>The following is the protective equipment that must be worn when using the glue or glue remover recommended by Epson. For details, refer to the instructions of the SDS for the glue and glue remover you are actually using.</p>	
<p>Eye protection (For organic solvent 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>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>Bundled item</p>	<p>Use this part to secure the blade to the belt. They are secured to both sides of the belt for use.</p>
<p>Blade</p> 	<p>1</p>	<p>Bundled item</p>	<p>Used to apply glue uniformly to the belt.</p>
<p>Glue blocks</p> 	<p>2</p>	<p>Bundled item</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	Bundled item	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 the like.
Stirring rod for preparing glue 	1	Commercially available	Used when mixing 2 types of glue.
Glue A 	520 g (0.58 L)	Recommended product <input type="checkbox"/> ATR1717 (ATR) <input type="checkbox"/> ATR1719 (ATR)	Solvent applied to the belt.
Glue B 	1200 g (1.34 L)	Recommended product <input type="checkbox"/> ATR1642 (ATR) <input type="checkbox"/> ATR1655 (ATR)	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.



Warning:

Before starting this procedure, be sure to read the following.  [“Precautions Regarding Maintenance” on page 177](#)

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 volume 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 360](#)

Workflow

1. Enter glue maintenance application mode

[🔗 "Entering Adhesive Material Maintenance Application Mode" on page 381](#)



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 382](#)

If curing has already been performed, no work is required.



3. Clean the surface of the belt

Use a wipe cloth soaked in the appropriate amount of ethanol to wipe the belt surface for 1 rotation.

[🔗 "Belt surface cleaning" on page 382](#)



4. Protect the belt

Apply insulating tape completely around the belt on both ends.

[🔗 "Belt curing" on page 383](#)



5. Install the blade

Attach the blade supports to both ends of the belt and install the blade.

[🔗 "Installing the blade" on page 386](#)

Maintenance



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.



7. Prepare the glue

Mix two types of glue.

 ["Glue preparation" on page 392](#)



8. Apply glue to the belt

 ["Applying Glue" on page 393](#)



9. Remove and clean the blade

 ["Blade removal and cleaning" on page 397](#)



10. Dry the glue applied to the belt

 ["Drying the glue" on page 398](#)



11. Work after applying glue

Remove the protective tape from the base of the product and the belt, and then clean the belt.

 ["Work after glue application" on page 398](#)

You can watch a video of the procedure on YouTube.

https://support.epson.net/p_doc/80d/

Entering Adhesive Material Maintenance Application Mode

Switch the printer to maintenance mode.

If you want to continue from the glue removal process, see step 3 and on.

1

From the Maintenance screen on the control panel, touch **Maintenance - Adhesive Material Maintenance**, in that order.

Maintenance

2 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 and Administrator Password” on page 63*
- ❑ *Save the Administrator Password you set in a safe location so that you do not forget it.*
 See the following if you forget your Administrator Password.
 🔗 *“If you have forgotten your administrator password” on page 446*

3 Touch Application Mode - Start.

When you touch **Forward** or **Reverse** once on the control panel, the belt will continue to rotate until you touch **Stop**.

Touch **Done** to exit **Removal 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.

Product curing

Cover the product so that glue remover, soapy water, and so on does not enter under the product and cause a malfunction.

This uses the same curing method as for glue removal (step 4 and on).

🔗 [“Product curing” on page 360](#)

If curing has already been performed, no work is required.

Belt surface cleaning

Use a wipe cloth soaked in ethanol (proper amount) to wipe the belt surface for 1 rotation.

- ❑ Press the Feed or Backfeed button on the front panel to rotate the belt.
- ❑ Wipe off the glue until the belt surface has a luster. Be especially careful to remove the glue from both edges of the belt.
- ❑ If the wipe cloth is dirty or glue chips occur, it means glue remains on the belt.

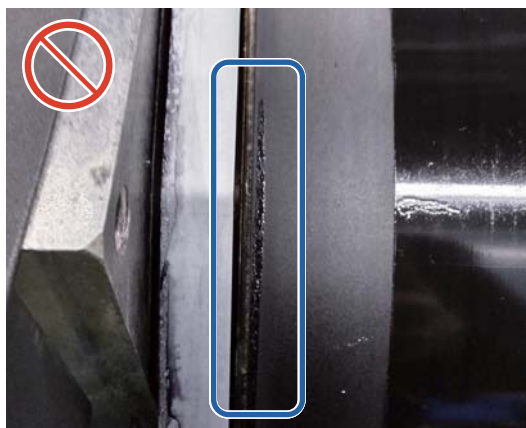
Maintenance

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 any glue or tape is stuck to the edges of the belt, the belt control unit may not operate correctly.



Belt curing

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.

1

Worker 1: Align the edge of the insulating tape to the edge of the belt and apply.

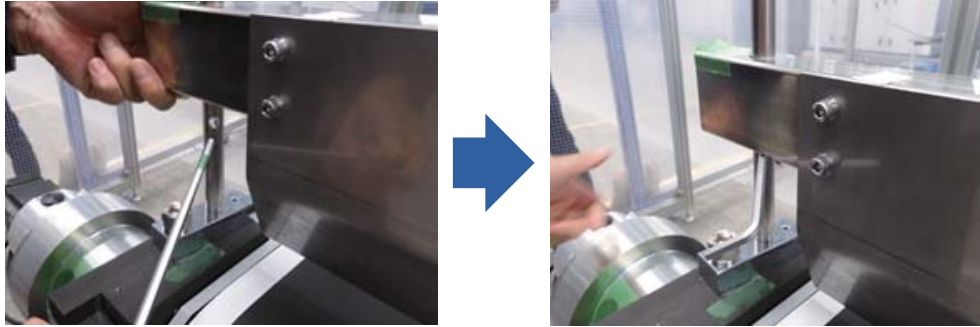


Maintenance

Note:

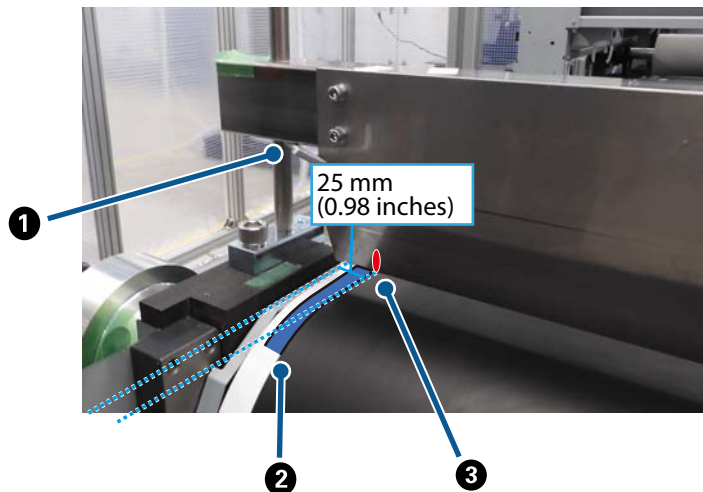
If you do not have 25 mm (0.98 inches) wide insulating tape, you can use 19 mm (0.75 inches) wide tape instead. Make sure the tape is applied 25 mm (0.98 inches) from the edge of the belt.

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.



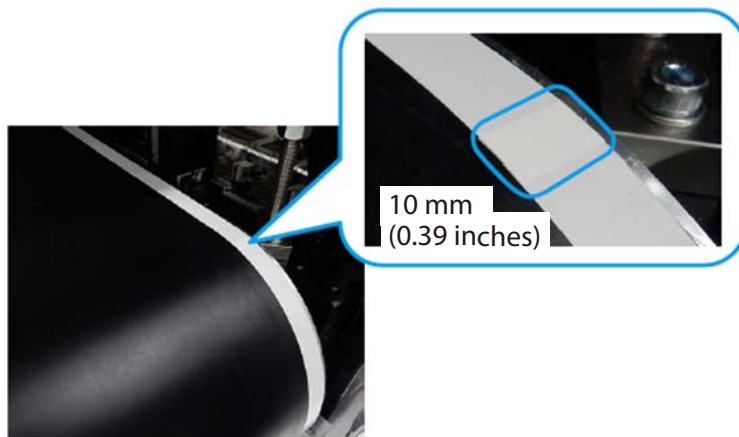
Important:

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.



- 4** Apply tape to the opposite side of the belt, in the same way as Steps 1 to 3.



Maintenance

- 5 Press and hold the Backfeed button on the front panel to slowly rotate the belt as you check that the tape is not floating 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.

- 1 Use a wipe cloth soaked in ethanol (proper amount) to clean the sharp edge of the blade.



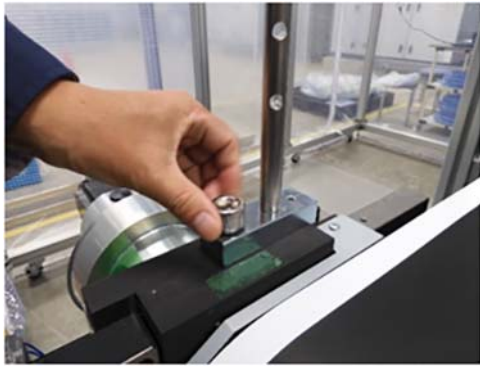
Important:

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 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 back and the screw holes are at the front. 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.

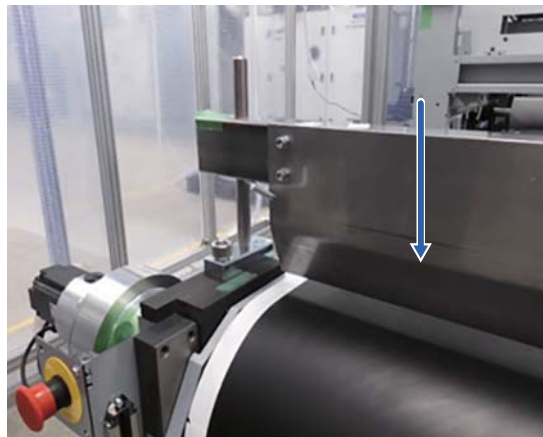
Maintenance



- 3** Have two 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.

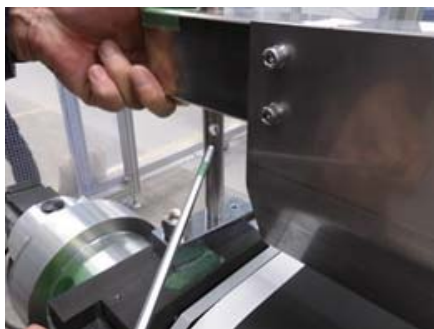
Warning:

Be careful not to get your hands caught between the belt and the blade when lowering the blade.



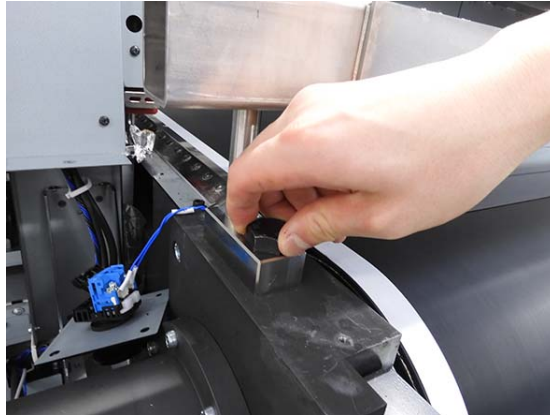
Note:

You can temporarily lift the blade from the belt by inserting a hex wrench or the like in the hole of the blade support.



Maintenance

- 4** Firmly tighten the hexagonal screws of both blade supports.



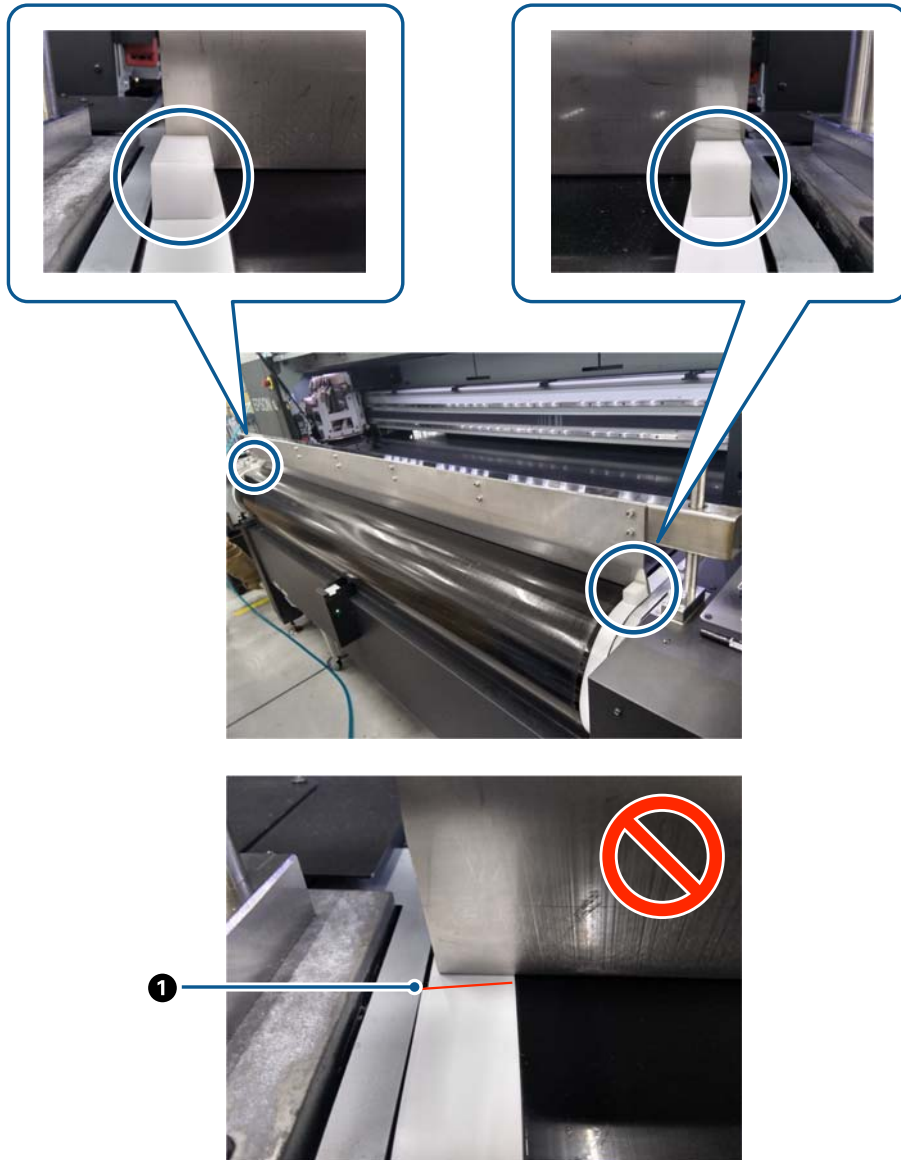
- 5** Press the Backfeed button on the front panel to feed the belt in the reverse direction by approximately 10 cm (3.94 inches). This operation sets the blade at a slight angle against the belt. This completes the blade installation procedure.



Maintenance

- 6** Place one glue block on each end of the belt so that they are 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.



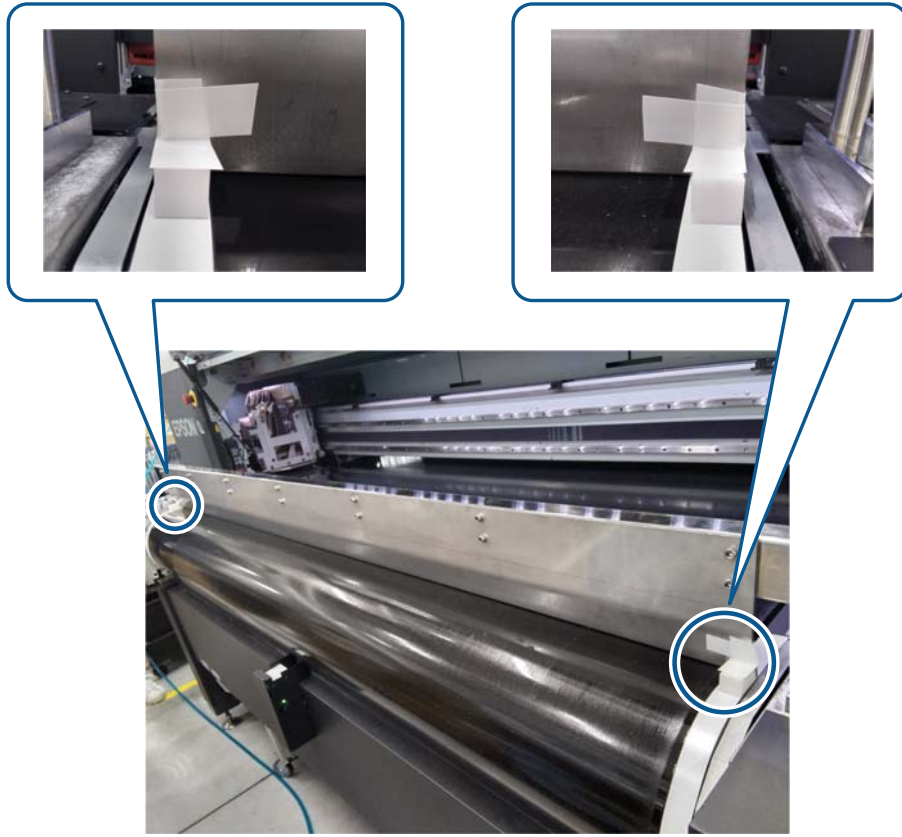
- 1** Overlapping insulating tape

- 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



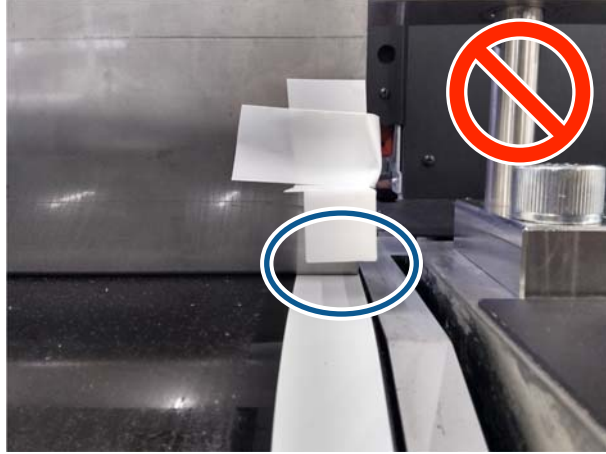
Maintenance



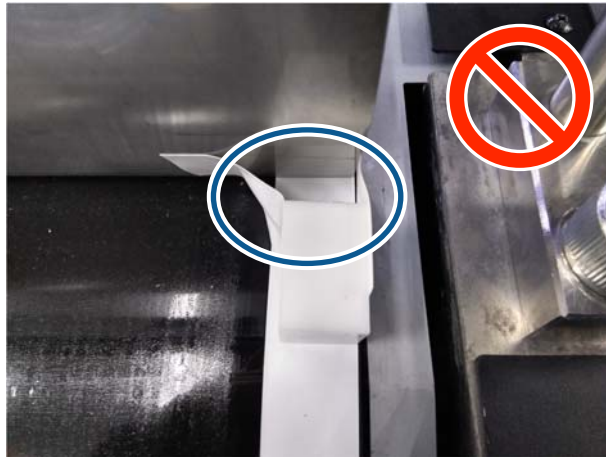
Caution:

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.

Glue preparation

Mix the glue to be used.

- 1 Set the glue bucket on the scale and pour in 520 g (0.58 L) of glue A.
Pour glue into the bucket slowly along the bucket side, to avoid the glue forming bubbles in the bucket.



- 2 Add 1200 g (1.34 L) of 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.

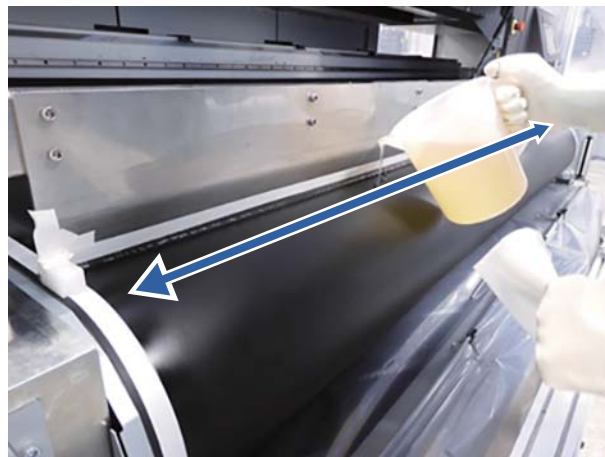
Applying Glue

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.

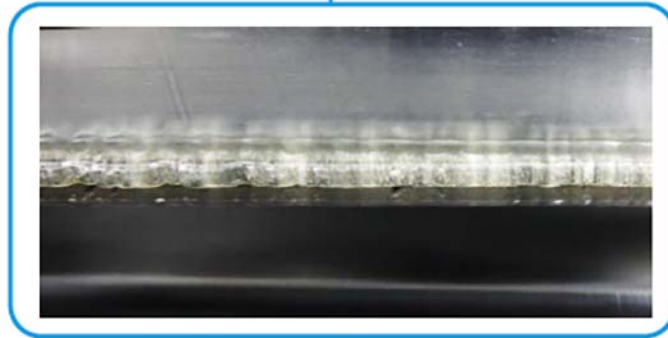
As the glue accumulates in front of the blade, rotate the belt to apply glue slowly to the belt surface through the gap between the blade and belt. As the glue decrease, pour in a proper amount of more glue.

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 of glue remains in front of the blade.

4

Just after the glue accumulated in front of the blade has been completely used, spray soapy water on the entire belt.

If the glue is not uniformly distributed, spray the local area with soapy water avoiding areas where the glue remains.

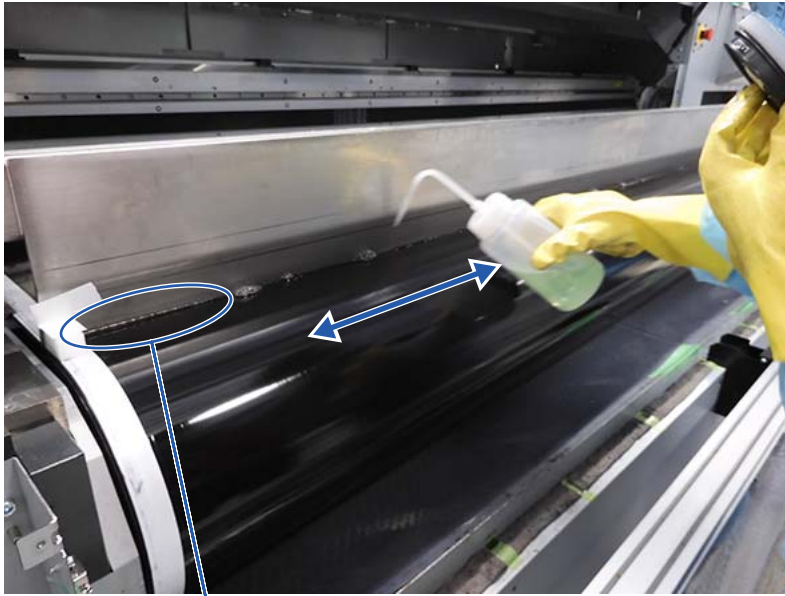
Once you have sprayed the area with soapy water, always spread the soapy water out so that it does not dry out.



Important:

The soapy water acts as a lubricant so the blade slides smoothly on the belt. If the soapy water is applied too late, the vibrations from the blade could cause unevenness in the belt surface.

Maintenance



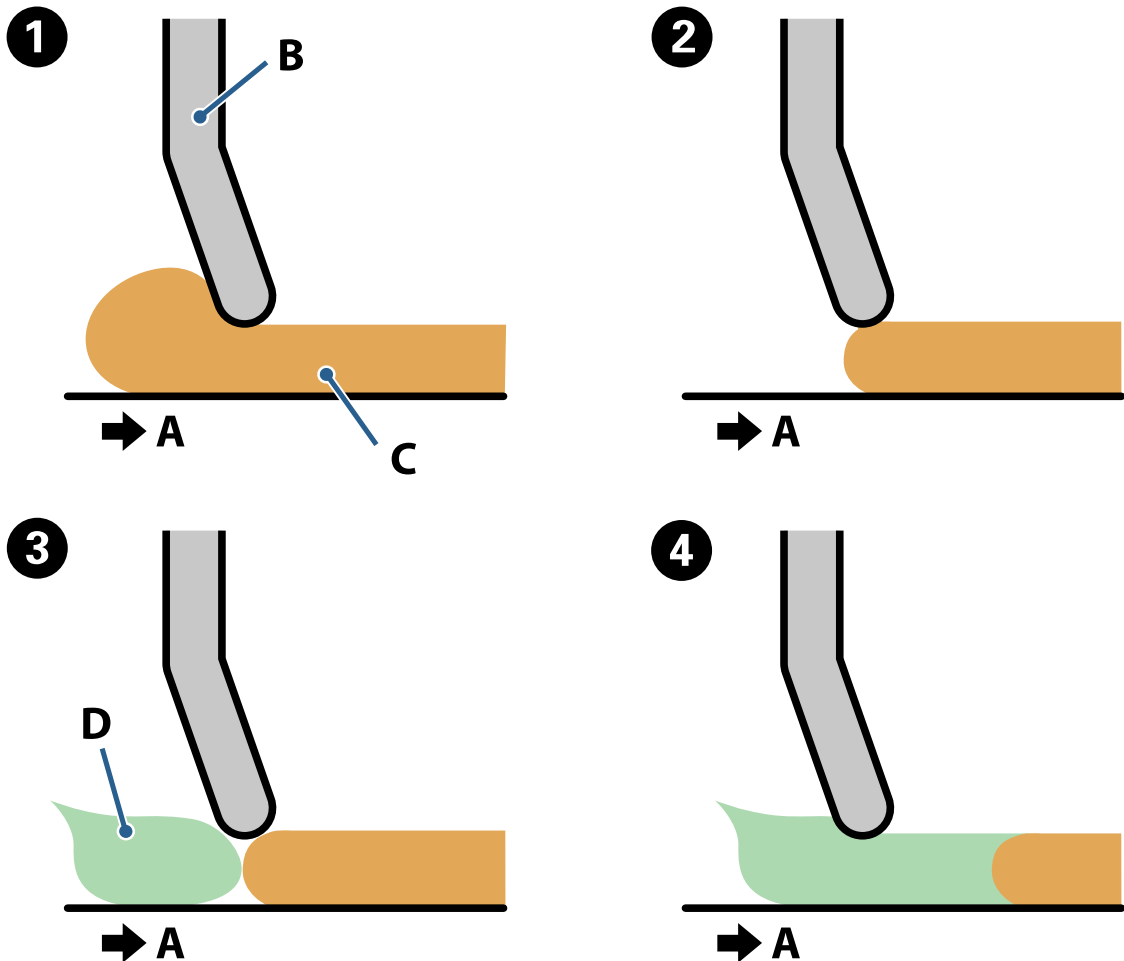
1

- 1 Avoid areas where glue remains and accumulates

Maintenance

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.

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.

Maintenance

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 right and left sides and remove it.



- 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:

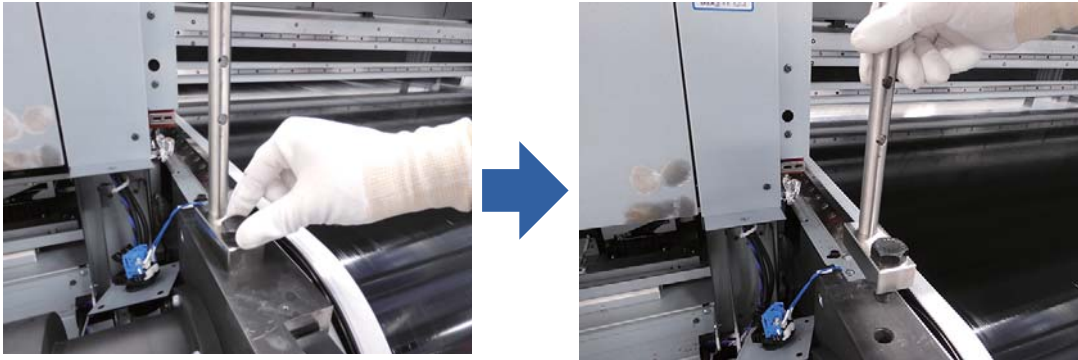
- ❑ Do not place the blade on the floor with the sharp edge facing down, or bump it against other objects. Doing so may damage the blade and prevent the glue from being applied evenly.
- ❑ If glue or dirt remains on the blade, it may not apply glue uniformly.



- 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.



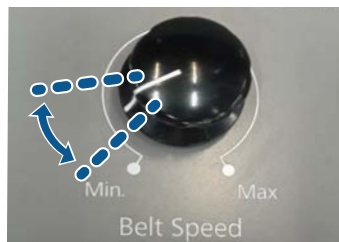
- 5 Touch the **Pause** button on the control panel.

Drying the glue

Dry the glue applied to the belt.

- 1 Decrease the belt speed.

The speed is indicated by the arrows shown in the figure (belt speed volume: 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 **Stop - Done** buttons on the control panel in that order.

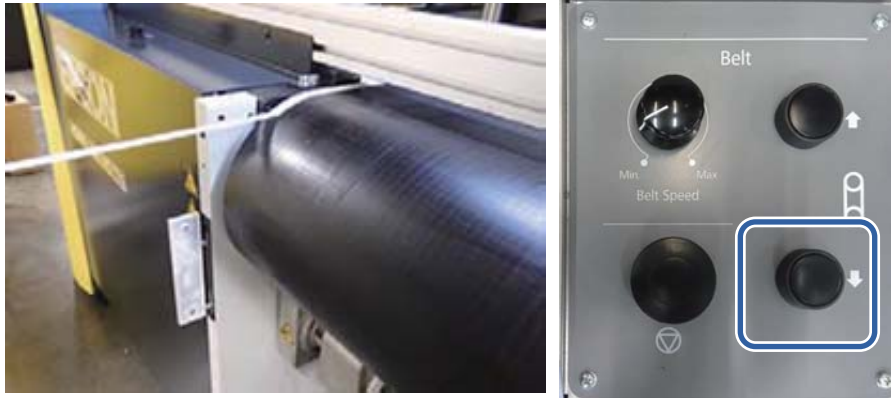
- 4 Close the front cover and leave it for at least 8 hours to allow the glue to dry.

Work after glue application

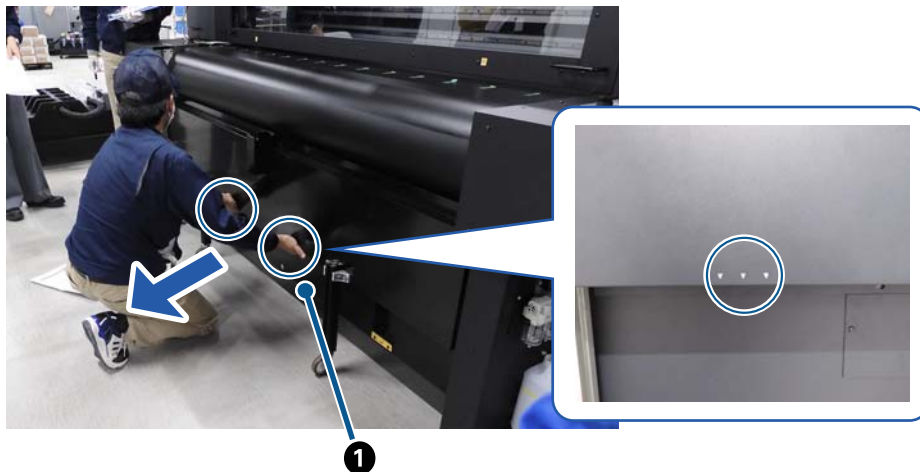
Clean the belt and prepare for printing.

Maintenance

- 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.



- 2 Make sure the belt cleaning unit is in the lowered position, and then pull out the belt cleaning unit.
 Hold the handles on the front of the belt cleaning unit to pull it out.

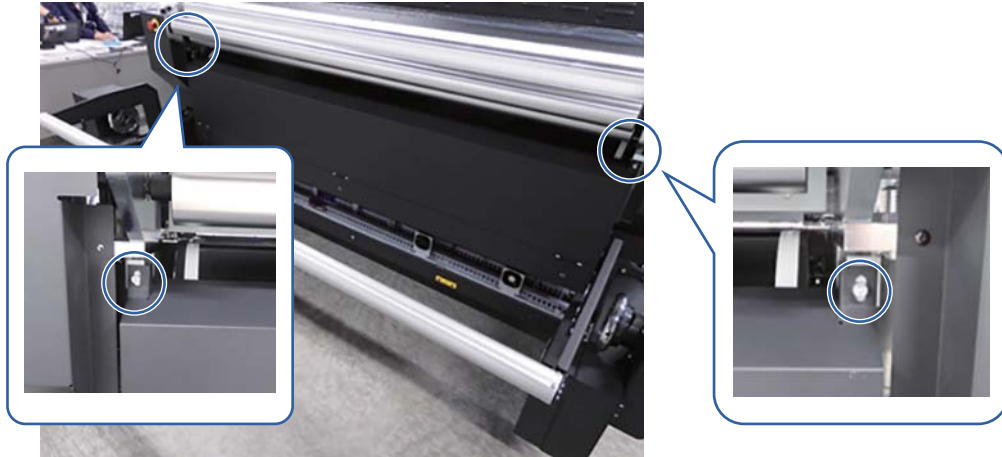


① Handles

- 3 Peel off the tape securing the curing plastic sheet and pull the plastic sheet out from the belt cleaning tank side.
- 4 Push the belt cleaning unit back to its original position.
- 5 Push down the tension bar on the machine rear.

Maintenance

- 6** Raise the cover on the back of the printer and screw it in place in two places.



- 7** Lift up the tension bar.
- 8** Check if there is water in the cleaning tank.
If there is no water in the cleaning tank, then select in the order of **Maintenance - Cleaning the Cleaning Tank - Start** from the Maintenance screen on the control panel and supply water.
- 9** From the Maintenance screen on the control panel, touch **Maintenance - Belt Cleaning**, in that order.
- 10** Touch **Belt speed** on the **Belt Cleaning** screen, and then touch **Normal**.
Set the belt rotation speed to **Normal**.
- 11** Touch **Number of cleaning cycles**, and then check if the number of cycles is set to **1**.
If **Number of cleaning cycles** is not set to **1**, touch **-** to set the number of cleaning cycles to **1**.
- 12** Touch **OK** at the top-right of the **Number of cleaning cycles** screen.
The number of cleaning cycles is set to one.
- 13** 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.

Maintenance

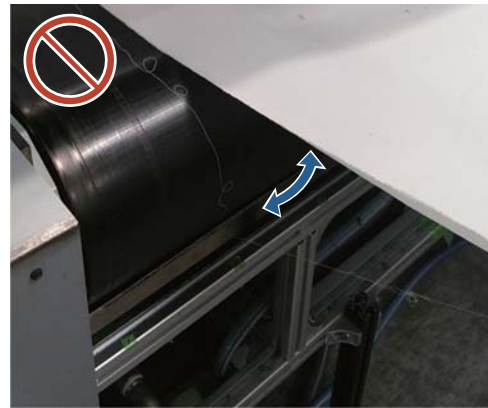
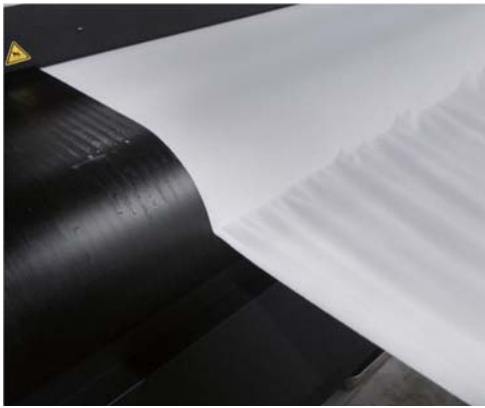
Timing for Reapplying the Glue

When the fabric attached to the belt rises slightly or if water droplets remain where the glue has been removed, the glue must be reapplied otherwise the print quality may decline.

The fabric attached to the belt rises slightly

In the following conditions, the strength with which the belt is attached is weakened.

- ❑ The fabric easily peels off the belt when printing with an external fabric drying winder. 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.

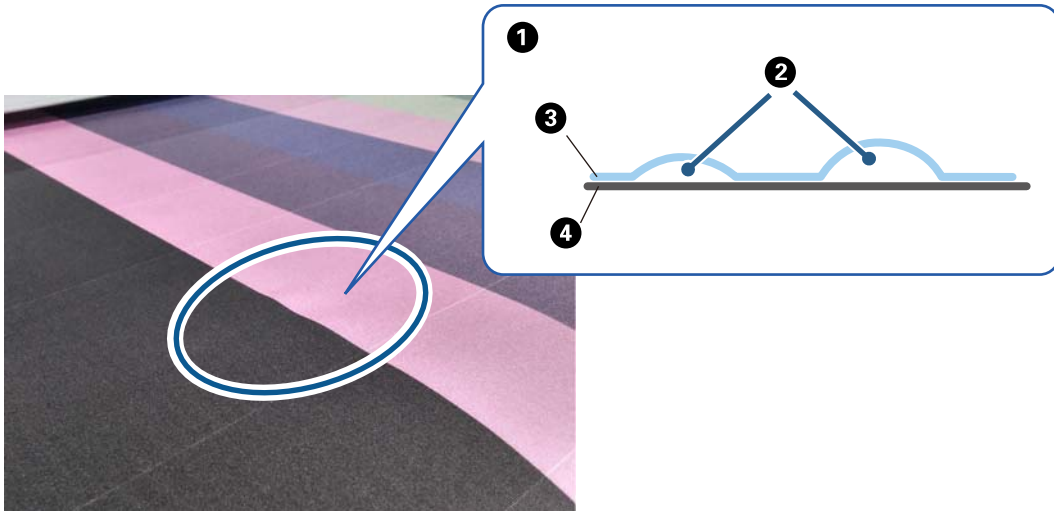


We recommend reapplying the glue if the fabric peels off at the position shown in the photos below (midway between the first block where the frame folds at both edges of the belt).



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 pressure roller is applied.

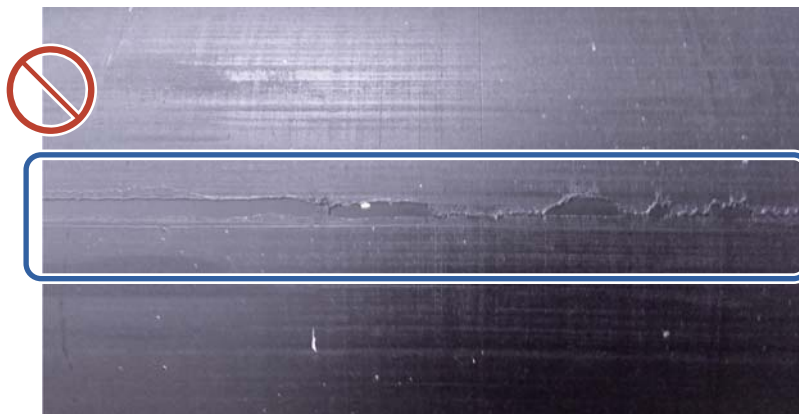


- 1 Cross section
- 2 Fabric rises slightly
- 3 Fabric
- 4 Belt

- When you touch the belt with your hand, you can see that the adhesive strength has almost gone.

Water droplets remain on the belt

If there is a part of the belt where the glue has peeled off, water droplets will remain there and soak into the fabric resulting in a decline in print quality.



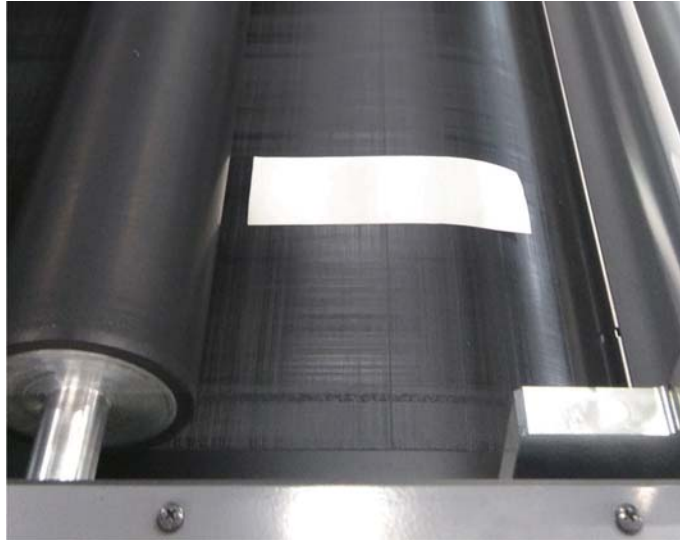
Measuring the adhesive strength of the glue

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.

Maintenance

1 Cut the fabric into strips of 50 mm x 150 mm.

2 Attach the cut fabric to the belt with the wrinkles smoothed out at the rear of the pressure roller.



3 On the rear panel, turn the Pressure Roller switch to the left to lower the pressure roller.



4 Turn the Pressure Roller switch to the right.

The pressure roller moves forward/backward.



Maintenance

- 5 Press the feed button (forward) on the rear panel to feed the fabric to the front of this machine.



- 6 Move to the front of this machine.
- 7 Peel off the edges of the cut fabric and attach a clip or something similar.
- 8 Pull the clip with a device such as a push pull gauge to measure the adhesive strength.

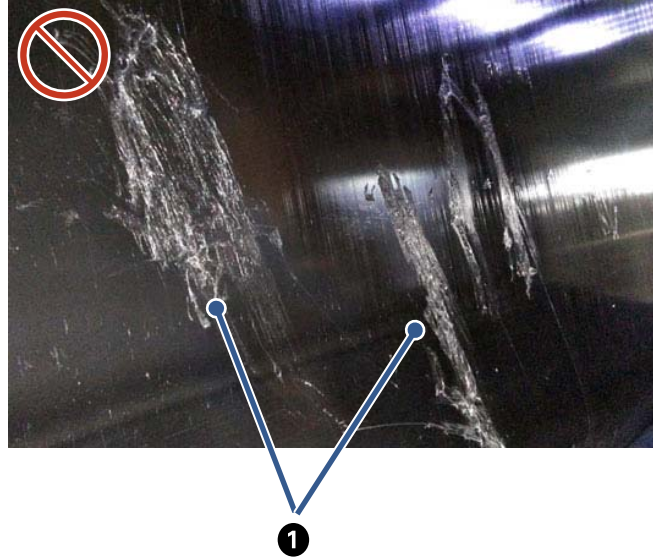


If the measured value is 0.05 to 0.1 N or less, we recommend reapplying the glue. However, this standard value may differ depending on the type of fabric being used, so make your determination based on your environment and fabric.

Maintenance

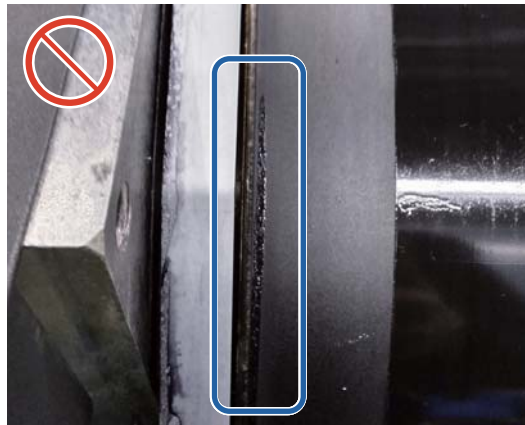
Evaluation Standard for Glue Application

Check the condition of the glue, and if the belt surface is clearly uneven, you need to reapply the glue.



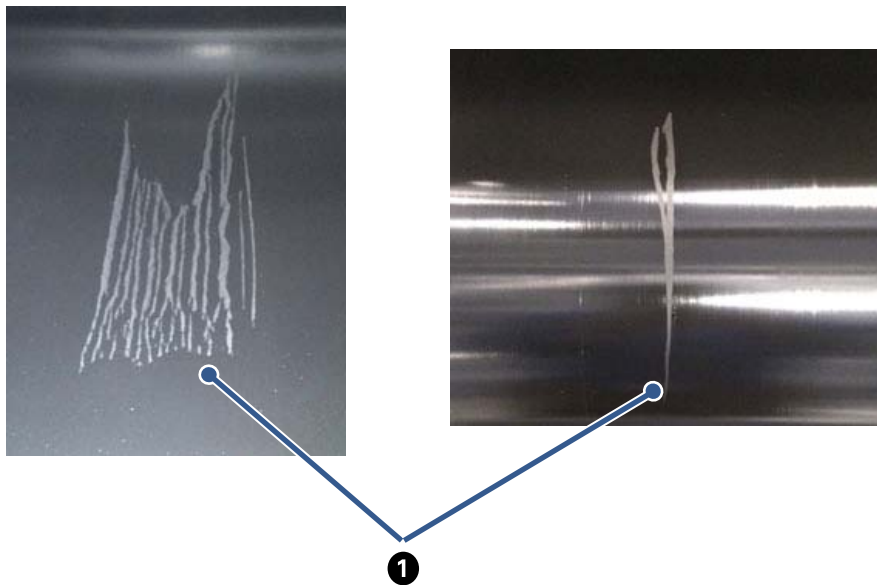
① During the glue application process, pieces of glue are falling off and sticking to the belt.

If there is glue or tape stuck to the edges of the belt, wipe the edges clean with a cloth soaked in an appropriate amount of ethanol. Otherwise, the belt control unit may not function as expected.



Maintenance

The following conditions will occur when the soapy water is applied too late or the soapy water dries up during the process. However, this does not affect the adhesion of the glue.



① Blade vibrations

Disposal of Used Consumables

The following used consumables with ink, glue, glue remover, or ink film remover on them are classed as industrial waste.

- Ink cartridges
- Cleaning stick
- Cleaning liquid
- Waste ink
- Waste ink bottle
- Wiper roll
- Cap
- Flushing pad
- Cleaning pad
- Mist filter
- Blower filter (ML-8000 only)
- Washing scraper

Maintenance

- Sponge roller (ML-8000U only)
- Tools used in glue removal or application, or ink film removal
- 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

Menu List

The following items and parameters can be set and executed in the Menu. See the reference pages for more details on each item.

General Settings

For more information on these items, see [☞ “General Settings Menu” on page 415](#)

Item	Parameter
Basic Settings	
LCD Brightness	1 to 9
Sounds	
Button Press	0 to 3
Alert	0 to 3
Completion Notice	0 to 3
Warning Notice	
Volume	0 to 3
Repeat	Never, Until Stopped
Error Tone	
Volume	0 to 3
Repeat	Never, Until Stopped
Sound Type	Pattern1, Pattern2
Sleep Timer	1 to 240 minutes
Date/Time Settings	
Date/Time	
Time Difference	-12:45 to +13:45 (15 minute increments)
Language	Japanese, English, French, Italian, German, Portuguese, Spanish, Dutch, Russian, Turkish, Korean, Simplified Chinese, Traditional Chinese
Background Color	Gray, Black, White
Keyboard	QWERTY, AZERTY, QWERTZ

Control Panel Menu

Item	Parameter
Unit Settings	
Length	m, ft/in
Temperature	°C, °F
Printer Settings	
Margin between Jobs	0 to 999 mm (0 to 39.33 inches)
Print Start Position	27 to 1000 mm (1.06 to 39.37 inches)
Print Width	300 to 1850 mm (11.81 to 72.83 inches)
End Detection	On, Off
Job Connection	On, Off
Information Printing	
Off	
On	
Margin Between Images	5 to 999 mm (0.20 to 39.33 inches)
Print Position	Next to the Image, Fabric End
Event Marking	
Off	
On	
Print Position	Left, Right, Left and Right
Nozzle Check Pattern	
Pattern Selection	Do Not Print, Normal, Fabric Width Saving
Print Position	Left, Right, Left and Right
Actions after Fabric Scuffing	Stop Immediately, Stop when Continuously Detected, Ignore
Cut Sheet Mode	On, Off
External Drying Reel	On, Off
Feeding Unit	On, On (External Feeding Unit), Off
Belt Cleaning	On, Off
Pressure Roller	Swing, Press, Off
Fluff Removal Fan	On, Off
Belt Position Control	On, Off
Foreign Material Detection	On, Off

Control Panel Menu

Item	Parameter
Nozzle Check between Jobs	
Nozzle Check between Jobs	On, Off
Job(s)	1 to 9999
Heater Off Timer	10 to 60 minutes
Automatic Wind-back	On, Off
Inside light	Auto, Manual
Restore Default Settings	Network Settings, Clear All Data and Settings
Maintenance Setting	
Cleaning Setting	
Threshold Of Clogged Nozzles	1 to 50
Max Retry Cleaning Count	0, 1, 2
Maintenance Schedule	Between Jobs, When Detected
Nozzle Compensation	On, Off
Periodic Cleaning	
On	
Print Duration	1 to 9999 minutes
Print Jobs	Every 1 to 9999 job(s)
Print Length	1 to 9999 mm (0.04 to 393.66 inches)
Off	
Actions Beyond the Threshold of Missing Nozzles	
Stop Printing	
Show Alert	
Auto Cleaning	
Maintenance Schedule	Between Jobs, When Detected
Maintenance Cleaning	On, Off
Belt flushing	
Off	
On	
Network Settings	

Control Panel Menu

Item	Parameter
Network Status	Wired LAN Status, Print Status Sheet
Advanced	
Device Name	
TCP/IP	
Proxy Server	
Email Server	Server Settings, Connection Check
IPv6 Address	Enable, Disable
Link Speed & Duplex	Auto, 10BASE-T Half Duplex, 10BASE-T Full Duplex, 100BASE-TX Half Duplex, 100BASE-TX Full Duplex, 1000BASE-T Full Duplex
Redirect HTTP to HTTPS	Enable, Disable
Disable IPsec/IP Filtering	
Disable IEEE802.1X	

Fabric Settings

For more information on these items, see [🔗 “Fabric Settings Menu” on page 423](#)

Item	Parameter
Current Settings	
Fabric	01 XXXXXXXXXXXX to 50 XXXXXXXXXXXX
Fabric Type	
Fabric Thickness	
Head Height	
Adhesive Belt Heater	
Drying Time Per Pass	
Print Adjustments	
Automatic Adjustment	
Print Head Alignment	Auto, Manual(Simple), Manual(Details)
Fabric Feed Adjustment	Auto, Manual
Fabric Management	

Control Panel Menu

Item	Parameter
01 XXXXXXXXXXXX to 50 XXXXXXXXXXXX	
Change Name	
Fabric Type	Cotton, silk, wool, PET, PA, viscose, PA/EL, PET/cotton, others
Fabric Thickness	0.0 to 5.0 mm (0 to 0.20 inches)
Head Height	0.0 to 4.0 mm (0 to 0.16 inches)
Adhesive Belt Heater	
Adhesive Belt Heater	Off, On
Temperature	30 to 45°C (80 to 113°F)
Drying Time Per Pass	0.0 to 10.0 seconds (0.1 second intervals)
Print Length Management	
Auto Reset	Off, After Last Page
Manual Reset	

Maintenance

For more information on these items, see [☞ “Maintenance Menu” on page 425](#)

Item	Parameter
Print Head Nozzle Check	
Fabric Width Saving	On, Off
Print Start Position	27 to 1000mm (1.06 to 39.37 inches)
Print Head Cleaning	Cleaning, Power Cleaning, Print Head Refresh
Cleaning the Maintenance Parts	
Cap	
Flushing Pad	
Around the Head	
Cleaning Pad	
Suction Cap	
Belt Cleaning	
Belt speed	Normal, Low
Number of cleaning cycles	For Normal: 1 to 30 For Low: 1 to 99
Cleaning the Cleaning Tank	

Control Panel Menu

Item	Parameter
Adhesive Material Maintenance	Application Mode, Removal Mode
Adding Grease to the Scan Spindle	
Print Head Nozzle Limitation	On, Off
Replace Waste Ink Bottle	
Replace Maintenance Parts	Replace Wiper Roll, Replace Cleaning Pad, Replace Flushing Pad, Replace Washing Scraper

Supply Status

For more information on the menu, see [☞ “Supply Status Menu” on page 426](#)

Item	Parameter
Ink/Waste Ink Bottle/Wiper Roll	
Others	Wiper roll/Washing scraper/Adding Grease to the Scan Spindle

Replacement Part Information


For more information on the menu, see [☞ “Replacement Part Information Menu” on page 427](#)

Item	Parameter
Side-to-side motor	
Belt Wash motor	
Feeder motor	
CR motor	
Belt control unit	
Head stroke sensor	
Foreign material detection sensor	
Slack detection sensor	
Roll diameter measurement sensor	
Fan (in)	
Blower (ML-8000 only)	
Ink flow path pump unit 1	
Ink flow path pump unit 2	
Ink flow path pump unit 3	

Control Panel Menu

Item	Parameter
Ink flow path pump unit 4	
Capping station drive unit	
Cleaning pump unit	
Cloth wiper drive unit	
Suction pump unit	
Ink tube	

Printer Status/Printing

For more information on the menu, see  [“Printer Status Menu” on page 427](#)

Item	Parameter
Firmware Version	
Printer Name	
Fatal Error Log	
Operation Report	Total Print Area, Total Fabric Feed Length, Total Carriage Pass

Control Panel Menu

Details of 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.
Sounds		
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	Off* 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	Off Until Stopped*	
Sound Type	Pattern1* Pattern2	Sets the type of sounds. Sounds that are easy to hear in the printer's operating environment can be set.




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 and date set here are displayed on the Home screen. It is also used for the printer's status as shown in job logs.
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		
Background Color	Gray	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.
	Black*	
	White	
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	

Control Panel Menu

Item	Parameter	Description
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	
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] [*])	Half of the set value is applied as margins to before and after every print job.
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 101  "Setting the Print Area and Print Position" on page 114
Print Width	300 to 1850 mm (11.81 to 72.83 inches) (1100 mm [43.30 inches] [*])	You can set the Print Width on the printer and on the application. In the following situations, set the print width on the printer. <input type="checkbox"/> When determining the position of the flushing on the belt <input type="checkbox"/> When determining the position for information printing <input type="checkbox"/> When making print adjustments When making settings in the application, we recommend setting the print width on the printer to 1850 mm.
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. If there are eight or more print jobs and the print length for eight jobs is 120 mm or less, the ninth 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  "Job Setting menu" on page 53 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.
	Off	


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	5 to 999 mm (0.20 to 39.33 inches) (5 mm [0.20 inches]*)	Margin Between Images: Set the interval between images and the marks and check patterns.
Print Position	Next to the Image*	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.
	Fabric Edge	
Event Marking		
	Off	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.
	On	
Print Position	Left*	<input type="checkbox"/> Change in state of clogged nozzles: When there is a change in nozzle clog conditions after printing starts
	Right	<input type="checkbox"/> Head cleaning: When head cleaning is executed manually
	Left and Right	<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
Nozzle Check Pattern		
Pattern Selection	Do Not Print	<input type="checkbox"/> Suspension: When printing is suspended
	Normal*	<input type="checkbox"/> Start of nozzle compensation
	Fabric Width Saving	Set a position, in which marks are easy to check, in Print Position .
Print Position	Left*	Nozzle Check Pattern: When pattern selection is Normal or Fabric Width Saving , the nozzle check pattern prints continuously during printing. When printing print jobs continuously or when printing a long job, you can immediately understand if nozzles clog while 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.
	Right	
	Left and Right	


Control Panel Menu

Item	Parameter	Description
Actions after Fabric Scuffing	Stop Immediately*	<p>The printer constantly monitors for striking of the fabric and print head while printing, so set the operation for when striking occurs.</p> <p>When Stop Immediately is set, printing stops immediately when striking is detected.</p> <p>When Stop when Continuously Detected is set, printing stops when continuous striking is detected.</p> <p>When Ignore is set, printing does not stop even if striking is detected. When striking is detected, the stopped fabric wrinkles, so take measures, such as adjusting the temperature of the heater, and clean the area around the print head if needed before restarting printing.</p>
	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 Pressure Roller are disabled (forced to Off).
	Off*	<p>It is useful to set this to On when using cut paper or pieces of fabric for test printing.</p> <p>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.</p>
External Drying Reel	On	Set this to On if feeding the printed fabric to a rewinding dryer.
	Off*	
Feeding Unit	On*	<p>Set the fabric feeding method.</p> <p>On: Fabric is fed using the feeding unit of this machine.</p> <p>On (External Feeding Unit): Fabric is fed using an external feeding unit.</p>
	On (External Feeding Unit)	
	Off	
Belt Cleaning	On*	Performs belt cleaning constantly while printing.
	Off	
Pressure Roller	Swing*	<p>In order to seal the fabric to the belt, the pressure roller is lowered toward the belt and also moves back and forth horizontally during printing.</p> <p>If you select Press, the pressure roller is lowered toward the belt, but it does not move horizontally during printing.</p> <p>If you select Off, the pressure roller remains away from the belt.</p>
	Press	
	Off	
Fluff Removal Fan	On*	A fan operates, blowing away fluff on the fabric or belt during printing and while the belt is being fed.
	Off	
Belt Position Control	On*	Function for feeding the belt accurately. Do not set this to Off except for when there is a failure.
	Off	
Foreign Material Detection	On*	<p>Detects curls in the fabric.</p> <p>If printing is executed with the fabric still curled, the fabric may come into contact with the print head, damaging it.</p>
	Off	

Control Panel Menu

Item	Parameter	Description
Nozzle Check between Jobs	Nozzle Check between Jobs	<p>If you set Nozzle Check between Jobs to On, the check pattern is printed before printing for every number of jobs set for Job(s). If you set Job Connection to on, the check pattern is printed before printing for the connected job.</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>
	Off*	
	Job(s)	1 to 9999 job(s)
Heater Off Timer	10 to 60 minutes (10*)	The heater turns off a specified time after printing during which no print jobs are received. It turns back on if a print job is received or if you touch Preheat Start in the Home screen.
Automatic Wind-back	On	When printing is finished, paused, or canceled, or when an error occurs, the belt stops and then reverses by 20 mm (0.79 inches).
	Off	<p>The default setting is Off for ML-8000U and On for ML-8000. If you are using the ML-8000U and this is set to Restore Default Settings - Clear All Data and Settings, return the setting to Off.</p> <p>Make sure this is set to On if you want to use our recommended externally connected device. Set this to Off if you are unable to perform operations with the printer using other externally connected devices.</p>
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	<p>Executing Clear All Data and Settings restores all menu settings to their default setting values.</p> <p>If you performed Clear All Data and Settings when using the ML-8000U, set Automatic Wind-back to Off.</p>
Maintenance Setting		

Control Panel Menu

Item	Parameter	Description
Cleaning Setting		<p>The printer constantly monitors the condition of the print head nozzles while printing, so set the operation for when clogged nozzles (missing nozzles) are detected during monitoring.</p> <p>When the number of clogged nozzles that are detected exceeds the number set in Threshold Of Clogged Nozzles, Print Head Cleaning is executed as part of maintenance.</p> <p>Max Retry Cleaning Count sets the number of times maintenance can be retried if the clogged nozzles are not cleared after maintenance is done.</p> <p>When Maintenance Schedule is set to Between Jobs, then maintenance is done after completing the job during which clogged nozzles were detected, but before the next print job starts. With When Detected, printing is stopped when a clogged nozzle is detected, and then maintenance is done. Because cleaning is done while printing, printing may be disturbed or head striking may occur.</p>
Threshold Of Clogged Nozzles	1 to 50 (9*)	
Max Retry Cleaning Count	0*	
	1	
	2	
Maintenance Schedule	Between Jobs*	
	When Detected	
Nozzle Compensation	On*	<p>Printing is performed using standard nozzles to compensate for the lack of ink that could not be ejected due to clogged nozzles.</p>
	Off	
Periodic Cleaning		<p>When On is set, cleaning is performed at the interval set for one of Print Duration, Print Jobs, or Print Length. Change the setting according to the ink type. If you do not change the setting, a malfunction may occur.</p> <ul style="list-style-type: none"> <input type="checkbox"/> Reactive, Acidic, Dispersal Ink <ul style="list-style-type: none"> Print Duration: 120 mins. Print Jobs: Every 200 jobs Print Length: 200 meters <input type="checkbox"/> Pigment Ink <ul style="list-style-type: none"> Print Duration: 360 mins. Print Jobs: Every 630 jobs Print Length: 630 meters
On		
Print Duration	1 to 9999 minutes (120*)	
Print Jobs	Every 1 to 9999 job(s) (200*)	
Print Length	1 to 9999 mm (0.04 to 393.66 inches) (200 mm [7.87 inches]*)	
Off*		
Actions Beyond the Threshold of Missing Nozzles	Stop Printing	<p>Set the action when the number of clogged nozzles that are detected exceeds the number set in Threshold Of Clogged Nozzles.</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.</p> <p>When Show Alert is set, printing continues without stopping while the message remains displayed.</p> <p>When Auto Cleaning is set, the print head is cleaned at the timing set in Nozzle Check Schedule.</p>
	Show Alert*	
	Auto Cleaning	
Maintenance Cleaning	On*	<p>When On is set, the print head is cleaned automatically when the printer is not used for a specified period. This cleaning ejects sedimented ink in the ink tubes to prevent print quality from falling.</p>
	Off	
Belt flushing	Off*	<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 114</p>
	On	
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		
Email Server	Server Settings	
	Connection Check	
IPv6 Address	Enable*	
	Disabled	
Link Speed & Duplex	Auto*	
	10BASE-T Half Duplex	
	10BASE-T Full Duplex	
	100BASE-TX Half Duplex	
	100BASE-TX Full Duplex	
	1000BASE-T Full Duplex	
Redirect HTTP to HTTPS	Enable*	
	Disabled	
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 0.7mm (0.03 inches). A minimum height of 2 mm (0.08 inches) above the thickness of the fabric is secured.
Adhesive Belt Heater		Select On if using heat-sensitive glue, or Off if using pressure-sensitive glue.
Drying Time Per Pass		Set the time from when printing on the first pass ends to when printing on the next pass begins. The time needed for the ink to dry varies with ink density and the fabric used. If, in the print results, the ink blurs or runs on the fabric, set a longer Drying Time. Increasing the drying time increases the time needed to print.
Print Adjustments		Set these in the following cases.
Automatic Adjustment		<input type="checkbox"/> Using new fabric not registered to the printer
Print Head Alignment	Auto	<input type="checkbox"/> When banding or graininess is found in the print results even after Automatic Adjustment is performed
	Manual(Simple)	<input type="checkbox"/> When the fabric width is different
	Manual(Details)	<input type="checkbox"/> When the fabric thickness or head height is changed
Fabric Feed Adjustment	Auto	Normally, Automatic Adjustment should be performed, and if banding or graininess is still visible in the print results even after automatic adjustment, perform Print Head Alignment and Fabric Feed Adjustment manually.
	Manual	
Fabric Management		
	01 XXXXXXXXXXXX to 50 XXXXXXXXXXXX	Change the registered fabric settings. New registrations are normally done when loading fabric.
Print Length Management		
Auto Reset	Off*	Select either Off (do not automatically reset the value for print length) or After Last Page (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.
	After Last Page	When After Last Page 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.
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. "Printing procedure for check patterns" on page 274</p>
Fabric Width Saving	On	
	Off	
Print Start Position	27 to 1000 mm (1.06 to 39.37 inches)	
Print Head Cleaning	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 278</p>
	Power Cleaning	
	Print Head Refresh	
Cleaning the Maintenance Parts	Cap	<p>Start cleaning the selected parts. Follow the on-screen instructions to clean them.</p> <p> "Cleaning the Caps" on page 209</p> <p> "Inspecting/Cleaning the Flushing Pad" on page 194</p> <p> "Inspecting/Cleaning Around the Print Head" on page 201</p> <p> "Inspecting/Cleaning the Cleaning Pad" on page 190</p> <p> "Cleaning the Belt Cleaning Brushes and the Area Around Them" on page 213</p> <p> "Inspecting/Cleaning the Suction Caps" on page 220</p>
	Flushing Pad	
	Around the Head	
	Cleaning Pad	
	Suction Cap	
Belt Cleaning		Starts belt cleaning.
Belt speed	Normal*	<p>Select the belt rotation speed in Belt speed. Set the number of times the belt is cleaned in Number of cleaning cycles.</p> <p>The maximum number of cleaning cycles depends on the speed selected in Belt speed.</p>
	Low	
Number of cleaning cycles	For Normal: 1 to 30 (1*)	
	For Low: 1 to 99 (1*)	
Cleaning the Cleaning Tank		<p>Touch the Start button when cleaning the belt cleaning brushes, the washing scraper, or the cleaning tank, or when performing flow rate adjustment for the belt cleaning tank. Supply of water to the cleaning tank begins.</p> <p> "Cleaning the Belt Cleaning Brushes and the Area Around Them" on page 213</p> <p> "Belt Cleaning Tank Flow Rate Adjustment" on page 285</p>

Control Panel Menu

Item	Parameter	Description
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 316 ☞ "Removing Glue (When Using the Glue Bucket)" on page 354 ☞ "Applying Glue" on page 376
	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 290
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. <ul style="list-style-type: none"> <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 242 ☞ "Replacing the Cleaning Pad" on page 250 ☞ "Replacing the Flushing Pad" on page 245 ☞ "Replacing the Washing Scraper" on page 251
	Replace Cleaning Pad	
	Replace Flushing Pad	
	Replace Washing Scraper	

Supply Status Menu

Item	Parameter	Description
Ink/Waste Ink Bottle/Wiper Roll		Shows the replacement timing, remaining amount and part number of the selected consumables.
Others		

Control Panel Menu

Replacement Part Information Menu

Item	Parameter	Description
Side-to-side motor		<p>Displays the replacement timing for the selected replacement part.</p> <p>Contact your dealer or Epson Support to request a replacement.</p>
Belt wash motor		
Feeder motor		
CR motor		
Belt control unit		
Head stroke sensor		
Foreign material detection sensor		
Slack detection sensor		
Roll diameter measurement sensor		
Fan (in)		
Blower (ML-8000 only)		
Ink flow path pump unit 1		
Ink flow path pump unit 2		
Ink flow path pump unit 3		
Ink flow path pump unit 4		
Capping station drive unit		
Cleaning pump unit		
Cloth wiper drive unit		
Suction pump unit		
Ink tube		


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	

Control Panel Menu
















































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.









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 (External Feeding Unit)	 On/ On (External Feeding Unit)	 On/ On (External Feeding Unit)	 On/ On (External Feeding Unit)	 On/ On (External Feeding Unit)
		Belt Cleaning	 On	 On	 On	 On	 On
		Pressure Roller	 Swing	 Swing	 Swing	 Swing	 Swing
		Fluff Removal Fan	 On	 On	 On	 On	 On
		Belt Position Control	 On	 On	 On	 On	 On
	Foreign Material Detection	 On	 On	 On	 On	 On	
Fabric Settings	Adhesive Belt Heater	 On	 On	_*1	_*1	_*1	
Rear panel	Tension switch		 On	 On	 On	 On	 On
	Slack detection switch		 Off	 Off	 Off	 Off	 Off

*1: 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
		Pressure Roller	Off	Off	Off
		Fluff Removal Fan	Either is acceptable	Either is acceptable	Either is acceptable
		Accurate Belt Position Control	Either is acceptable	 On	 On
	Foreign Material Detection	Either is acceptable	Either is acceptable	Either is acceptable	
Fabric Settings	Adhesive Belt 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 448
The ink cartridge cannot be 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. Ready a new ink cartridge. 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 448
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 201
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 456
Fabric is not loaded correctly. Remove the fabric and then reload it.	The fabric was not correctly loaded when it was loaded. Refer to the following, and load the fabric correctly.  "Loading the Fabric" on page 78

Problem Solver


Messages	What to do
<p>There is a problem with the fabric or the print results; auto adjust cannot be done. 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 109</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>Clean the Cap.</p>	<p>The caps are dirty and need to be cleaned. Follow the instructions on the control panel screen to identify the caps to be cleaned and then clean them.</p> <p> "Cleaning the Caps" on page 209</p>
<p>An error has been detected in the Belt Control Unit (XX). Check the Belt Control Unit and the belt, and remove any foreign material. If the error repeatedly occurs, contact Epson Support.</p>	<p>Make sure there is no ink, glue, tape, etc. 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.</p> <p> "General Settings Menu" on page 415</p>

When an Error Message is Displayed

The print head may stop on the suction cap when an error message is displayed and the printer turns off. If the print head stops on the suction cap, move the print head manually until it is over the belt and then turn the printer back on.




 ["Manually Moving the Print Head" on page 434](#)

If the print head is not capped for more than 20 minutes, perform manual capping of the print head.

 ["Manually Capping the Print Head" on page 283](#)

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.</p> <p>Immediately contact your dealer or Epson Support.</p> <p>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 the manual. XXXXXXXX</p> <p>Printer error. Turn the power off and on again. For details, see the manual. 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 <input type="checkbox"/> When the print head has stopped on the suction cap <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 breaker (Main Power) on the back of the printer.</p> <p> "Turning On the Power" on page 68</p> <p> "Turning Off the Power" on page 108</p> <p>If the code number "00141A" or "0014BB" is displayed, the print head may have stopped on the suction cap.</p> <p>Follow the steps below to move the print head and then turn the printer back on.</p> <p> "Manually Moving the Print Head" on page 434</p> <p>If an error with the same number occurs again, contact your dealer or Epson Support.</p> <p>When doing so, be sure to tell us the "XXXXXXX" (code number).</p>

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 456](#)

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 has, disconnect the USB hub from the computer and connect the computer directly to the printer. Ask the USB hub manufacturer about USB hub operation.

You cannot print under the network environment

■ **Are the network settings correct?**

Ask your network administrator for the network settings.

■ **Connect the printer directly to the computer using a USB cable, and then try to print.**

If you can print via USB, there are some problems on the network environment. Ask your system administrator, or refer to the manual for your network system. If you cannot print via USB, see the appropriate section in this User's Guide.

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 430](#)

■ **Did you open the rear cover while executing return to origin or while printing?**

The printer stops when the rear cover lock lever is unlocked while executing return to origin or while printing.

If the print head is on the suction cap when the printer is restarted after the rear cover has been closed and locked, the print head may collide with the suction cap causing a malfunction to occur.

In this situation, make sure that the print head is not on the suction cap before closing the rear cover. If the print head is on the suction cap, follow the steps below to move the print head.

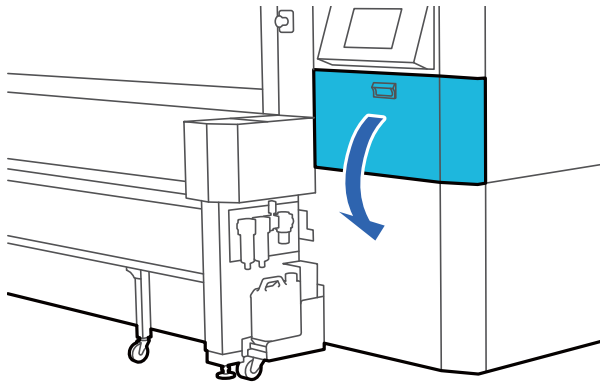
Problem Solver

Manually Moving the Print Head

- 1 Open the front cover.



- 2 Open the maintenance cover (right).

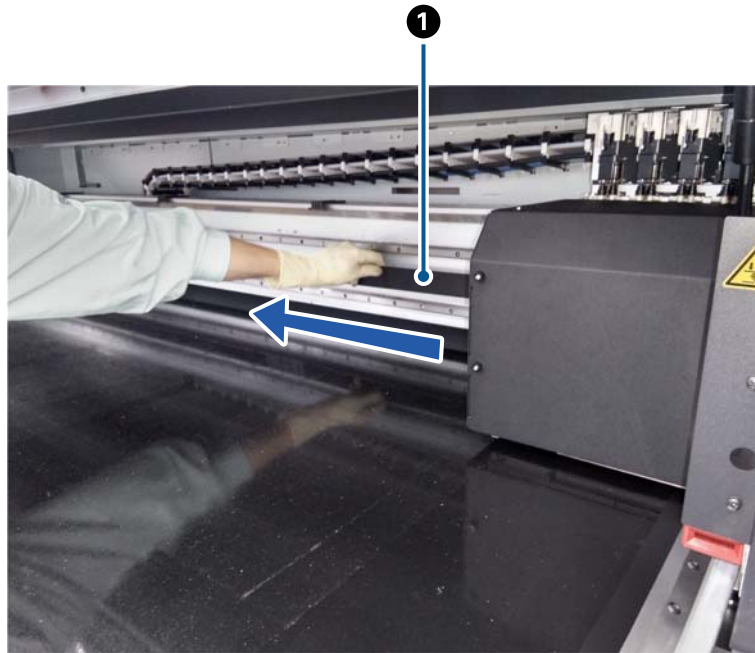


Problem Solver

3

Pull the carriage belt to the left by hand to move the print head onto the belt.

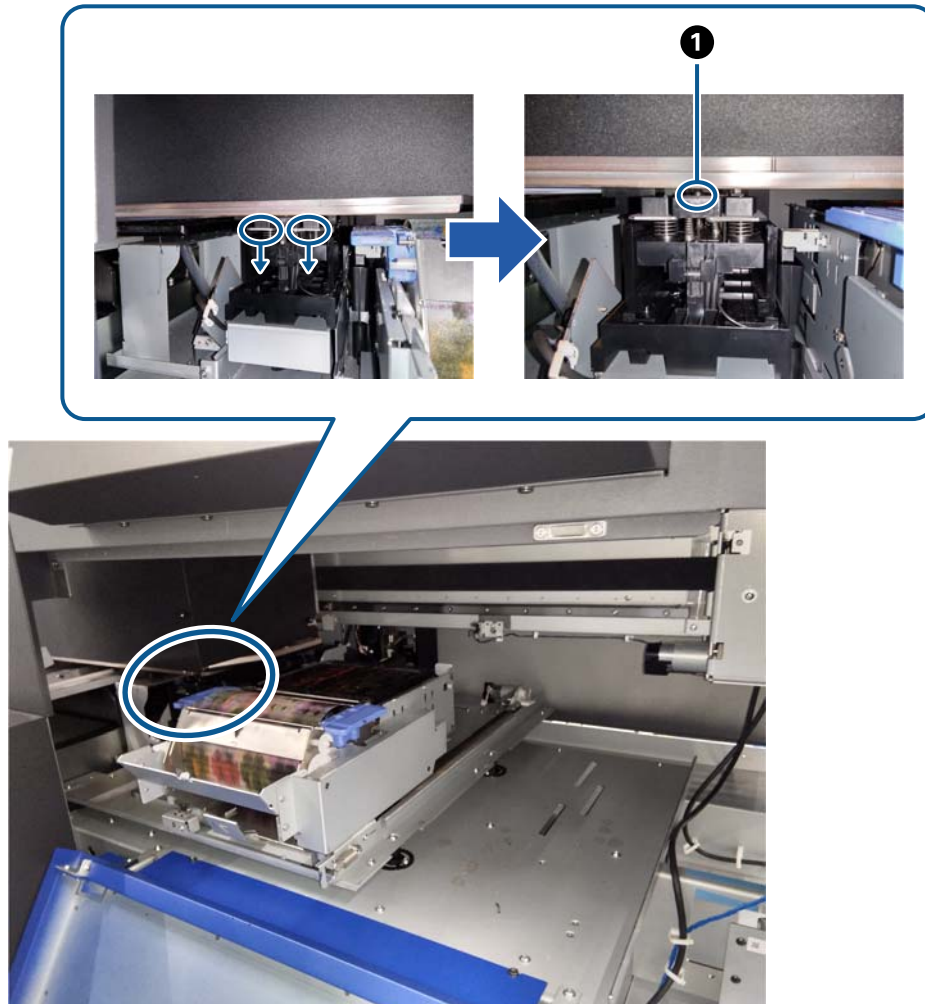
Move the print head until the entire print head is positioned on the belt.



1 Carriage belt

Problem Solver

If you cannot move the print head, the suction cap pin may have been inserted into the print head. Carefully press the metal plate for the suction cap on the maintenance cover (right) and remove the pin from the print head.



① Pin

4 Close the maintenance cover (right).

5 Close the front cover.

Problem Solver

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 274](#)

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 278](#)

- **Has the printer been left unused for a long time?**

If the printer has not been used for a long time, the nozzles may have dried up and have been clogged. Steps to take when the printer has not been used for a long time:

 ["Notes When Not Using the Printer" on page 33](#)

The Prints Are Not What You Expected

Print quality is poor, smeared or uneven, too light, too dark, obvious graininess, or the tone differs

- **Are the print head nozzles clogged?**

If the 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 274](#)

- **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 109](#)

Problem Solver

■ 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 cartridge before the date printed on the package or within six months of opening it, whichever is sooner.

■ Are the heaters at the correct temperature?

Raise the temperature if the print results are blurred or smudged or the ink clots. Note, however, 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.

Turning off the heaters may improve the issue.

■ Are fabric settings correct?

Confirm that the fabric settings in the software RIP or on the printer match the fabric actually in use.

■ 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 8 below to adjust the tension as needed.

 ["When you want to print by smoothing out wrinkles and curls in the fabric" on page 148](#)

■ 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.

■ Was a printer cover opened during printing?

Opening covers during printing causes the print head to stop abruptly, resulting in uneven colors. Do not open the covers while printing is in progress.

■ Is Ink 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.

■ Shake the ink cartridges.

The ink may have sedimented (components settling to the bottom of the liquid). Remove the ink cartridges and shake them.

 ["Periodically Shaking the Ink Cartridges" on page 267](#)

■ Are there any water droplets on the belt after belt cleaning?

 ["Water droplets remain on the belt after belt cleaning" on page 442](#)

Problem Solver

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.

 ["Loading the Fabric" on page 78](#)

 ["General Settings Menu" on page 415](#)

■ 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.

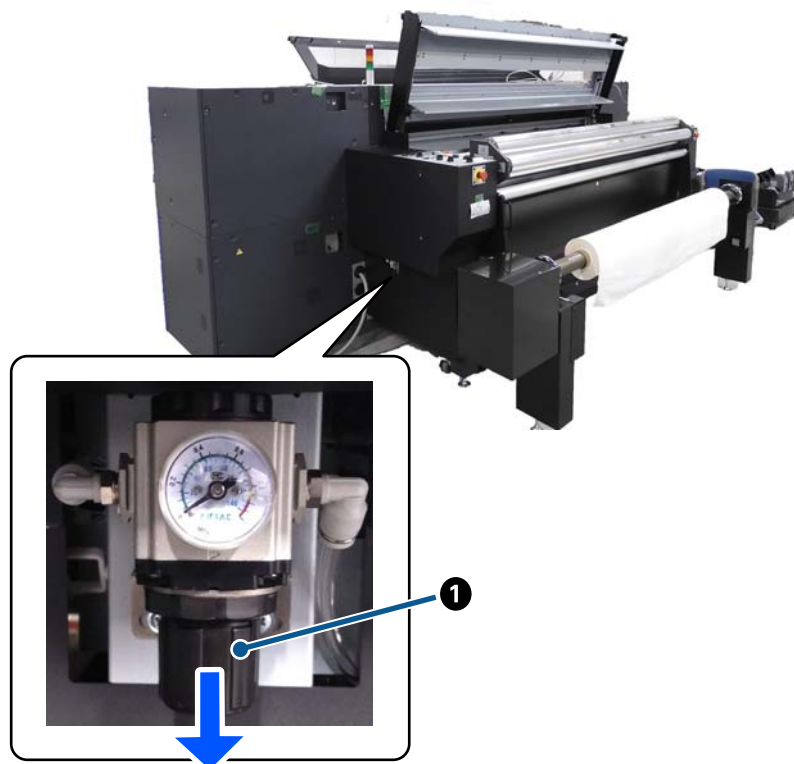
 ["Loading the Fabric" on page 78](#)

■ Is the fabric floating up from the belt?

If the application to the belt is too weak, the fabric may float up, shifting from the print position. Adjust the pressure for the pressure rollers using the pressure regulator at the bottom of the rear of product.

1 Pull the pressure adjustment handle down.

You will see an orange line.



1 Pressure adjustment handle

Problem Solver

- 2** Turn to the right to raise the pressure. Turn to the left to lower the pressure.

Perform adjustments while checking the meter.
Specified value: 0.3 Mpa



- 3** Once you have adjusted the pressure to the necessary amount, press the pressure adjustment handle up and lock it.

If the situation still does not improve, you must raise the pressure to 0.5 Mpa or reapply the glue.

[👉 “Removing Glue” on page 368](#)

[👉 “Applying Glue” on page 376](#)

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 440](#)

■ **Is fabric loaded just before printing?**

The pressure rollers 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 451](#)

For information on how to configure print settings using the software RIP, contact the RIP manufacturer.

Removing jammed fabric

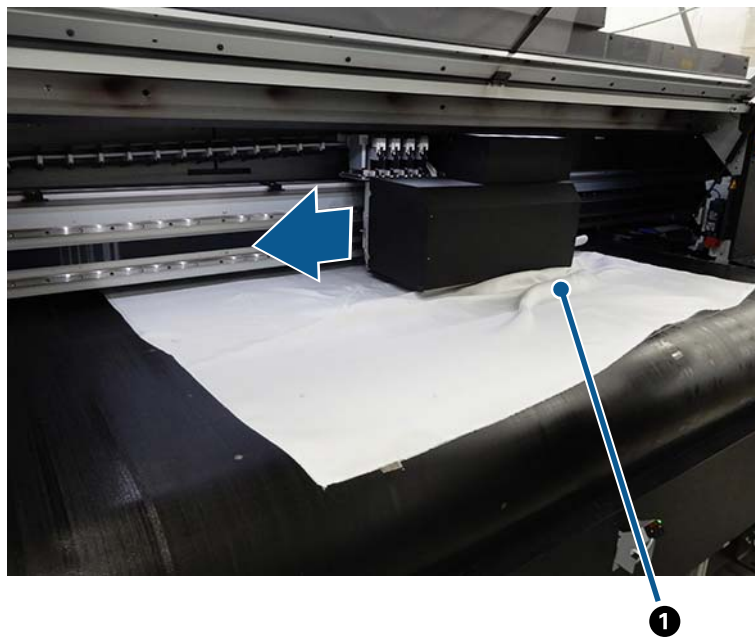
If an error message is displayed, follow the steps below to remove the jammed fabric.

Problem Solver

- 1 Open the front cover.



- 2 To move the print head, push it away from the jammed fabric.



- 1 Jammed fabric

Problem Solver

- 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.

 [“Loading the Fabric” on page 78](#)

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

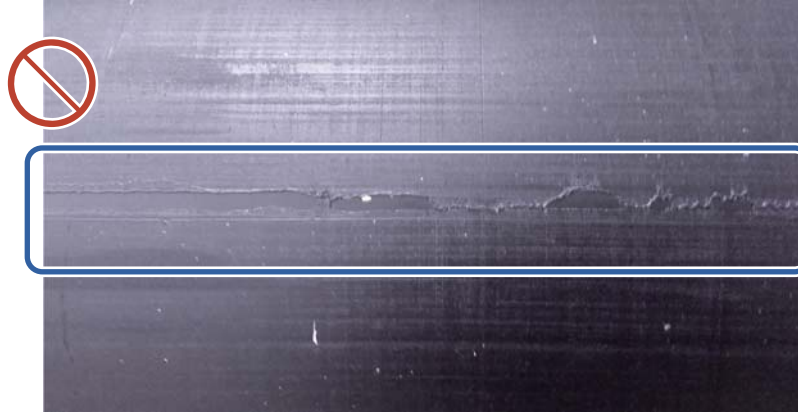
Depending on the condition of the glue applied to the belt and the condition of the washing scraper and sponge roller, water droplets may remain on the belt after belt cleaning. If water droplets remain on the belt, take the following steps to deal with the issue.

Problem Solver

Checking procedure

1 Check if any of the following conditions apply to the belt.

- ① Is there any lint or debris on the belt surface?
- ② Are there any areas where the glue that was applied to the belt has peeled off?



- 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 strength to the adhesive.

[☞ “The fabric attached to the belt rises slightly” on page 401](#)

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.

[☞ “Measuring the adhesive strength of the glue” on page 402](#)

If condition ① applies, remove any lint or debris from the belt surface.

If condition ② or ③ applies, reapply the glue.

[☞ “Removing Glue” on page 368](#)

[☞ “Applying Glue” on page 393](#)

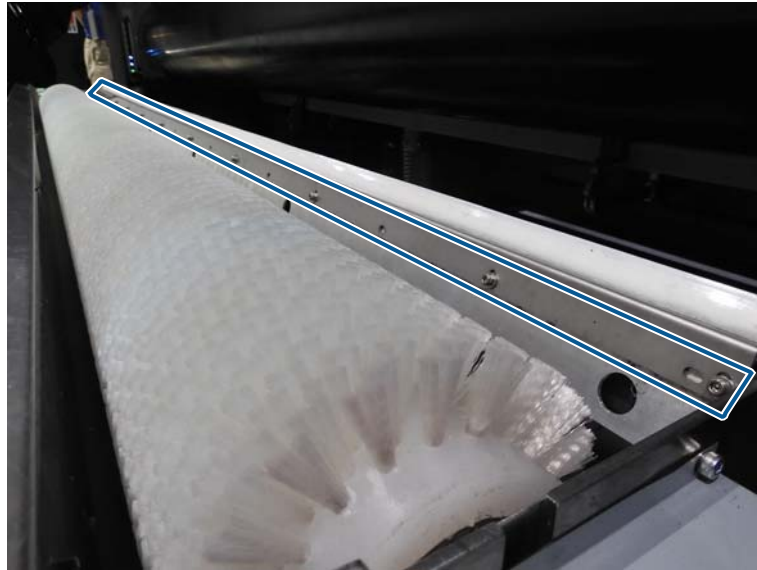
If none of the conditions in ① to ③ apply, follow the steps below.

2 Check if any of the following conditions apply to the washing scraper.

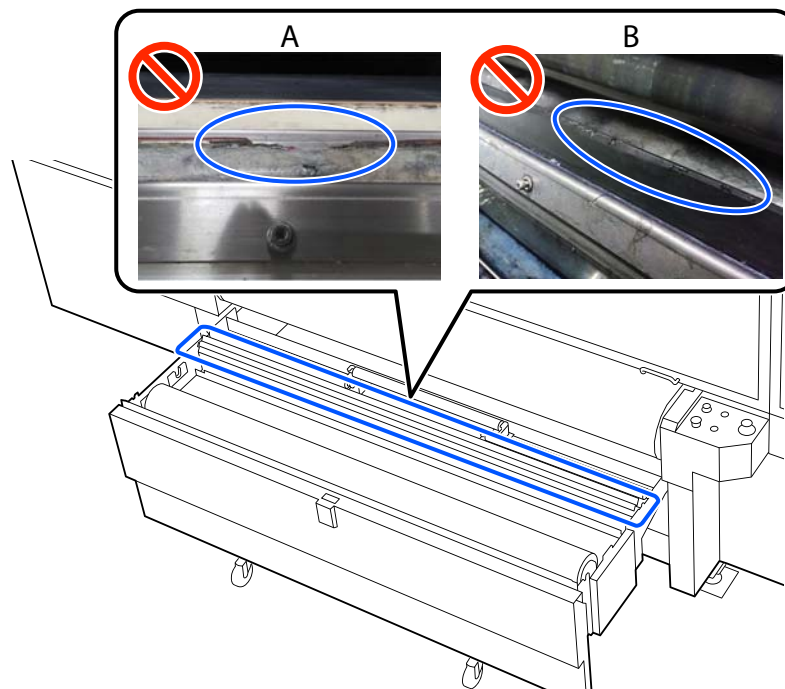
- ① Is there any lint or debris on the washing scraper?

Problem Solver

- 2 Have the screws (x12) that hold the washing scraper in place come loose?



- 3 Is the edge of the washing scraper scratched or worn?



A: Washing scraper (C13S210132)

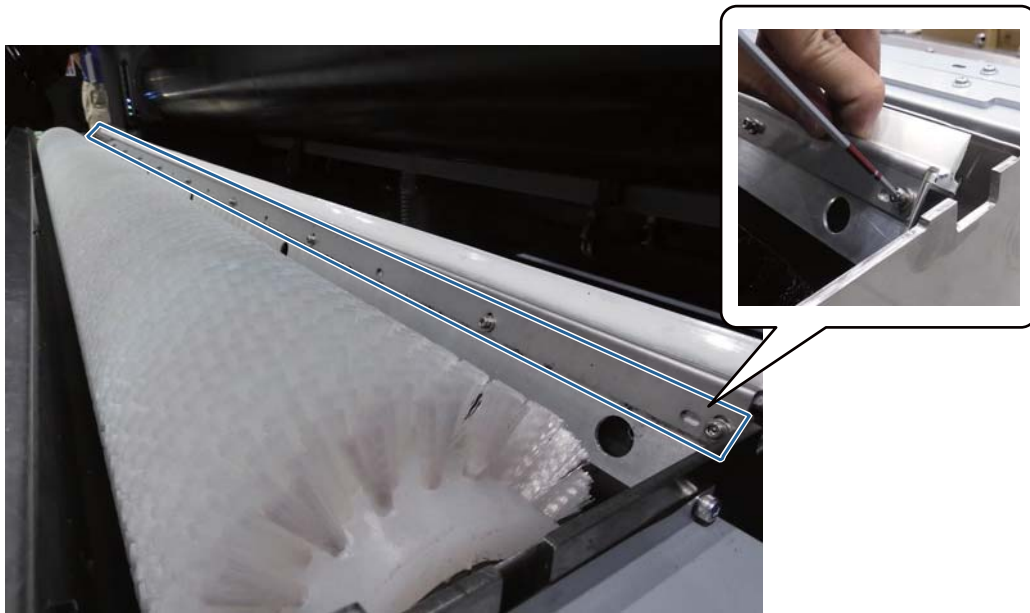
B: Washing scraper 2 (C13S210167)

If condition 1 applies, clean any lint or debris from the washing scraper.

 [“Cleaning the washing scraper” on page 214](#)

Problem Solver

If condition ② applies, tighten the screws (x12) with a hex key (2.5 mm wide).



If condition ③ applies, refer to the following and turn over the washing scraper and reattach it, or replace it with a new one.

[☞ “Replacing the Washing Scraper” on page 251](#)

If none of the conditions in ① to ③ 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, there are still water droplets left on the belt after belt cleaning.

If condition ① applies, dry the sponge roller.

[☞ “Drying Sponge Roller \(ML-8000U Only\)” on page 205](#)

If condition ② applies, correctly attach the sponge roller to the belt cleaning unit.

[☞ “Replacing the Sponge Roller \(ML-8000U Only\)” on page 261](#)

If condition ③ applies, replace the sponge roller with a new one.

[☞ “Replacing the Sponge Roller \(ML-8000U Only\)” on page 261](#)

If none of the conditions in ① to ③ apply, contact your dealer or Epson Support.

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 time until the heaters automatically switch to Off can be changed in Heater Off Timer in the setup menu.

 ["General Settings Menu" on page 415](#)

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 415](#)

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 password

When the Administrator Password has not been changed from the default value

Enter the printer's serial number.

If you have forgotten the Administrator Password you set

All network settings for the printer must be initialized. Touch [General Settings] - [Printer Settings] - [Restore Default Settings] - [Network Settings] on the control panel. Reconfigure the network settings of the printer as necessary.

After initializing, enter the printer's serial number as the Administrator Password.

Change the Administrator Password to a new one.

 ["How to Set/Change the Administrator User Name and Administrator Password" on page 63](#)

If you have forgotten your administrator User Name

When the administrator User Name has not been changed from the default value

Leave the administrator User Name blank.

If you have forgotten the administrator User Name you set

All settings of the printer, including Fabric Settings and Network Settings, must be initialized. Touch **General Settings - Printer Settings - Restore Default Settings - Clear All Data and Settings** on the control panel. The administrator User Name and Administrator Password are returned to their default values.

After initialization, enter the following administrator User Name and Administrator Password.

Problem Solver

Administrator User Name: Leave the User Name blank.

Administrator Password: Enter the printer's serial number.

Change the Administrator Password to a new one. Set your own administrator User Name.

 [“How to Set/Change the Administrator User Name and Administrator Password” on page 63](#)

The red light is on inside the printer

This is not a failure.

The red light is a light inside the printer.

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.

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.

Supported ink

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 (GOTS)*	GY-G

Appendix

Ink type	Color name	Color code
Pigment	Black	BK
	Cyan	C
	Magenta	M
	Yellow	Y
	Yellow-C	Y
	Grey	GY
	Red	R
	Green	GR
	Orange	OR
Acid	Black	BK
	Cyan	C
	Magenta	M
	Yellow	Y
	Grey	GY
	Red	R
	Blue	BL
	Cobalt	CO
	Orange-F	OR-F
	Rubine	RB
	Fluorescent Pink	FP
	Fluorescent Flavine	FL
	Dispersion	Black
Cyan		C
Magenta		M
Yellow		Y
Grey		GY
Red		R
Blue		BL
Orange		OR

Appendix

Ink type	Color name	Color code
Others	Ink Penetration Liquid AC/RE	AC
	Ink Penetration Liquid DS	AC
	Cleaning Liquid	CL

* GOTS: Global Organic Textile Standard

Others

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	
High tension feeding Unit	C12C939761	Allows you to load and print multiple items of narrow fabric, such as cloths, at the same time.
Water recycling unit	C12C939921	This is the water recycling system. It circulates cleaning water used by the belt cleaning unit to remove lint.
Belt Cleaning Unit for ML-8000U	C12C939691	This is the ML-8000U belt cleaning unit. You can install it on the ML-8000 to achieve results that are equivalent to the ML-8000U.
Grease pump	C12C938631	Use for adding grease to the scan spindle and the carriage operating area. 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.
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 removal tool	C12C940131	Push this against the belt and scrape off the glue. Hook it to the blade and use.
Glue collection bucket	C12C938681	Push this against the belt and scrape off the glue.
Felt weight	C12C938851	Used to keep the felt soaked in ink film remover pressed onto the belt.
Cleaning stick	C13S090011	Used for cap cleaning.
Cleaning cloth	C13S210050	Nonwoven fabric for head cleaning.
Insulating tape	C13S400213	Use for applying glue.

Appendix

Product	Product No.	Notes
Maintenance liquid	C13T42X000	Cleaning liquid for maintenance, 20 L Use when cleaning the caps, suction caps, carriage surfaces other than the nozzle surface, head cover, and belt side guides.
Cleaning kit	C13S210103	The following consumable items are included in one maintenance set. Use when cleaning the caps, suction caps, carriage surfaces other than the nozzle surface, head cover, and belt side guides. Cleaning liquid (x1) Cup (x1) Gloves (x16) Cleaning stick (x50)
Waste ink bottle	C13S210071	Identical to the Waste Ink Bottle supplied with the printer.
Wiper roll	C13S210128	Identical to the Wiper Roll supplied with the printer.
Cleaning pad (x2)	C13S210129	Identical to the cleaning pad supplied with the printer.
Flushing pad (x2)	C13S210130	Identical to the flushing pad supplied with the printer.
Washing scraper (x2)	C13S210132	Scrapes off water droplets stuck on the belt.
Washing Scraper 2	C13S210167	Scrapes off water droplets stuck on the belt. Can only be used with the ML-8000U.
Mist filter	C13S210133	Identical to the mist filter supplied with the printer.
Blower filter	C13S210134	ML-8000 only Identical to the blower filter supplied with the printer.
Sponge Roller	C13S400226	Identical to the sponge roller 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
Roll outer diameter	50.8 to 400 mm (2.00 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	Max. 100 kg (220.5 pounds)
Fabric type	Cotton, silk, wool, PET, PA, viscose, PA/EL, PET/cotton

Appendix

Print Mode and Throughput

Reactive Ink and Pigment Ink

Prerequisites: Bidirectional printing and 1,500 mm (59.06 inches) printing width

The throughput varies depending on the image, firmware, PC operating status, and print settings.

Print mode			Throughput [m ² /h]
Resolution [dpi]	Number of passes	Carriage Speed [%]	
300 × 600	1	100	312
		90	279
600 × 600	2	100	162
		90	144
	3	100	111
		90	99
	4	100	80
		90	71
900 × 600	3	100	108
		90	96
	4	100	84
		90	75
	6	100	56
		90	50
1200 × 600	4	100	78
		90	69
	6	100	56
		90	50
	8	100	42
		90	37
900 × 1200	6	100	54
		90	48
	9	100	37
		90	33

Appendix

Print mode			Throughput [m ² /h]
Resolution [dpi]	Number of passes	Carriage Speed [%]	
1200 × 1200	9	100	37
		90	33

Acid Ink and Dispersion Ink

Prerequisites: Bidirectional printing and 1,500 mm (59.06 inches) printing width


The throughput varies depending on the image, firmware, PC operating status, and print settings.

Print mode		Throughput [m ² /h]
Resolution [dpi]	Number of passes	
300 × 600	1	279
600 × 600	2	144
	3	99
	4	71
900 × 600	3	96
	4	75
	6	50
1200 × 600	4	69
	6	50
	8	37
900 × 1200	6	48
	9	33
1200 × 1200	9	33












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.

Appendix

	Green	Yellow	Red	Status	Description
	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.
	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 May, 2025)
The supported operating systems may change.

Appendix

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 Print

Minimum Operating Environment

Operating system (OS)	Windows 11 Windows 10 x64
CPU	Intel® Core™ i3 3.0 GHz or faster (released after April 2014)
Free memory	8 GB or more
Hard disk drive (free space during installation)	50 GB or more
Display resolution	1280 x 1024 or better
Communication interface	Hi-Speed USB Ethernet 100Base-TX/1000Base-T

We recommend installing this software on a computer with high specifications since the software will be used in combination with software applications such as Adobe Illustrator.

Also, this software normally handles data that is several GB in size, and in some cases may be tens of GB in size particularly when performing high quality banner printing jobs.

We therefore recommend using a computer with sufficient storage space.

The recommended environment for using this software is shown below.

Recommended Environment

Operating system (OS)	Windows 11 Windows 10 x64
CPU	Intel® Core™ i7-14700 processor or better
Free memory	32 GB or more
Storage (free space during installation)	SSD 1 TB or more
Display resolution	1280 x 1024 or better
Communication interface	Hi-Speed USB Gigabit Ethernet

Epson Rob file print tool

Operating system (OS)	Windows 10 x64
CPU	Intel® Core™ i7 3.4 GHz or faster
Physical memory	16 GB or more

Appendix

SSD free space	50GB or more
Display resolution	1280 x 768 or higher
Communication interface	USB3.0 / Ethernet 1000Base-T

Web Config

Windows

Browser	Internet Explorer 11, Microsoft Edge, Mozilla Firefox*, Google Chrome*
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* Use the latest version

Mac

Browser	Safari*, Mozilla Firefox*, Google Chrome*
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* 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

The degrees of protection for this machine are IP22 (IEC 60529).

This machine is a Class 1 laser product based on the IEC 60825-1: 2014 standard.

Printer Specifications	
Printing method	On-demand ink jet
Nozzle configuration	400 nozzles x 2 rows x 4 chips x 8
Resolution (maximum)	300 x 300 dpi x 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 30°C (68 to 86°F), 40 to 60%
While printing	22 to 28°C (71.6 to 82.4°F), 40 to 60%
Environment supplied with power	10 to 35°C (50 to 95°F), 20 to 80%
Environment not supplied with power (After charging ink)	10 to 35°C (50 to 95°F) (1 month)
Transport environment	-20 to 60°C (-4 to 140°F), 5 to 85%
Temperature and humidity range Gray area: While operating Cross-hatch line area: Recommended	
Noise	While printing: 80 dB (A) or less Average value: 75.5 dB(A)... Complies with the Machinery Directive 2006/42/EC, Section 1.7.4.2
Dimension	<p>Printer When stored: 3700 [W] x 2500 [D] x 1826 [H] mm (145.67 [W] x 98.43 [D] x 71.89 [H] inches) Maximum: 3710 [W] x 2683 [D] x 1950 [H] mm (146 [W] x 105.63 [D] x 76.77 [H] inches)</p> <p>Ink supply unit 880 [W] x 960 [D] x 541 [H] mm (34.65 [W] x 37.80 [D] x 21.30 [H] inches) (ink supply unit only) 880 [W] x 960 [D] x 790 [H] mm (34.65 [W] x 37.80 [D] x 31.10 [H] inches) (when ink cartridges are installed)</p>
Work space	6280 [W] x 4350 to 4500 [D] x 1950 [H] mm (247.24 [W] x 171.26 to 177.17 [D] x 76.77 [H] inches) Between ink rack and printer: 0 to 200 mm (0 to 7.87 inches) Desk for PC (for reference): 500 [W] x 500 [D] x 800 [H] mm (19.68 [W] x 19.68 [D] x 31.49 [H] inches)

Appendix

Printer Specifications			
Weight	Gross weight of printer (not including ink supply unit):	ML-8000U	Approx. 2110 kg (4651.75 pounds)
		ML-8000	Approx. 2150 kg (4739.9 pounds)
	Ink supply unit (x2, not including ink cartridges):	Approx. 110 kg (242.5 pounds)	

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 (M6 terminal)	
	Rated power	ML-8000U	1.6 kW
		ML-8000	5.5 kW
	Rated apparent power	14.4 kVA	
	Rated short circuit current	1.5 kA	
	Leakage current	10 mA or less	
Rated current	20 A		

Appendix

Factory facilities		
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	150 L/H or more Range of flow rate adjustment by model ML-8000: 50 to 150 L/h ML-8000U: 10 to 150 L/h
	Water pressure	0.8 MPa or less
Wastewater	Tube	25 mm (0.98 inches) inner diameter, 33 mm (1.30 inches) outer diameter
Exhaust	Aluminum piping	125 mm (4.92 inches) inner diameter
	Flow rate	900 m ³ /h
Network	A communication speed of 100BASE-TX or more is recommended.	
External feeding unit connector	Dsub25 pin (Male), Machine side: Female	
External drying unit connector	Dsub37 pin (Male), Machine side: Female	

Interface Specifications

Interface Specifications	
USB port for a computer	USB 3.0 We recommend using a USB cable with a ferrite core to avoid disturbance noise.
Wired LAN compliance standard	1000Base-T* ¹ To ensure stable printing, when transferring print data between a PC and the printer by Ethernet, do not connect any other devices to the Ethernet hub connected to the PC, to the printer, or to the Epson Cloud Solution PORT router.
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 FTP* ³

Appendix


Interface Specifications	
Security standards/protocols	IEEE802.1X (Ethernet)
	IPsec (v4/v6), IP filtering
	SSL/TLS: HTTPS Server (Web Config) IPPS Server SMTPS Client (Email send) STARTTLS (SMTPS) Root certificate (client) Root certificate version 2.01 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: 1.0.2j Supported TLS versions: 1.0/1.1/1.2
	Authentication for email sending: POP before SMTP APOP SMTP authentication (Kerberos/NTLMv1/CRAM-MD5/PLAIN/LOGIN)
	Authentication for IPP printing: HTTP Basic authentication
	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	 "Ink cartridges" on page 448
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	<p>When installed</p> <ul style="list-style-type: none"> <input type="checkbox"/> Ink type: Reactive, Acid, Disperse, Pigment <input type="checkbox"/> Number of shakes: 10 times on front and 10 times on back <p>Periodic shaking</p> <ul style="list-style-type: none"> <input type="checkbox"/> Pigment ink (Red): Once every three weeks <input type="checkbox"/> Pigment ink (except for Red) and dispersal ink: Once a month <input type="checkbox"/> Reactive ink and acid ink: Shaking is not required <input type="checkbox"/> Number of shakes: 3 times
Storage temperature	10 to 35°C (50 to 95°F), 35 to 85% (no condensation)
Ink cartridge capacity	10000 ml, 3000 ml
Ink cartridge dimensions	10000 ml: 150 [W] x 235 [D] x 412 [H] mm (5.91 [W] x 9.25 [D] x 16.22 [H] inches) 3000 ml: 158 [W] x 260 [D] x 168 [H] mm (6.22 [W] x 10.24 [D] x 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.