



India's largest manufacturer of digital inkjet printers

# SubliXpress<sup>PLUS</sup>

USER MANUAL



## Foreword

This user manual is briefly describing the operational aspects of the **SubliXpress Plus** machine. In this document, the step-wise instructions for handling various aspects of the machine with visual screens are provided for easy and better understanding. It also describes the error messages encountered while working with the machine with appropriate remedial actions required to be taken by the user.

This manual serves as the reference tool which guides their customers how to use or operate the **SubliXpress Plus** machine without anyone else assistance. The information provided in this document ensures its uniqueness and language quality. For safe and proper use of the product, please read this manual carefully and follow all the instructions.

### Disclaimer

The information and instructions provided in this user manual have been checked for accuracy, uniqueness, and reliability. ColorJet group reserves all the rights to modify and revise this manual as per the company requirements without any prior notice.

**“No part of this document shall be reproduced or used by externals without prior permission of the ColorJet group”.**

The reference table is shown in the below table:

| Doc Type    | Doc Code | Version | Machine Name     | Date of Issue |
|-------------|----------|---------|------------------|---------------|
| User Manual |          | 1       | SubliXpress Plus | 2021          |

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## 1. About Document

### Purpose

The purpose of this document is to guide and educate the targeted audience about the Printer and its Printer Manager software so that they can easily and effectively handle as well as use it as per their requirements. Additionally, this document also provides step-wise instructions for handling various aspects of the printer and its related software with the help of graphical screens for easy and better understanding. Moreover, the document also describes commonly encountered problems while working with the printer and Printer Manager software with appropriate remedial actions.

### Audience

This document is meant for all the users who want to use the Printer for their printing business. Sometimes, the targeted audience has little knowledge about the printer but in most of the cases, targeted audience is much familiar with the terminologies of printer and printing business. Thus, this document is designed to facilitate both types of users.

## 2. Machine Specifications

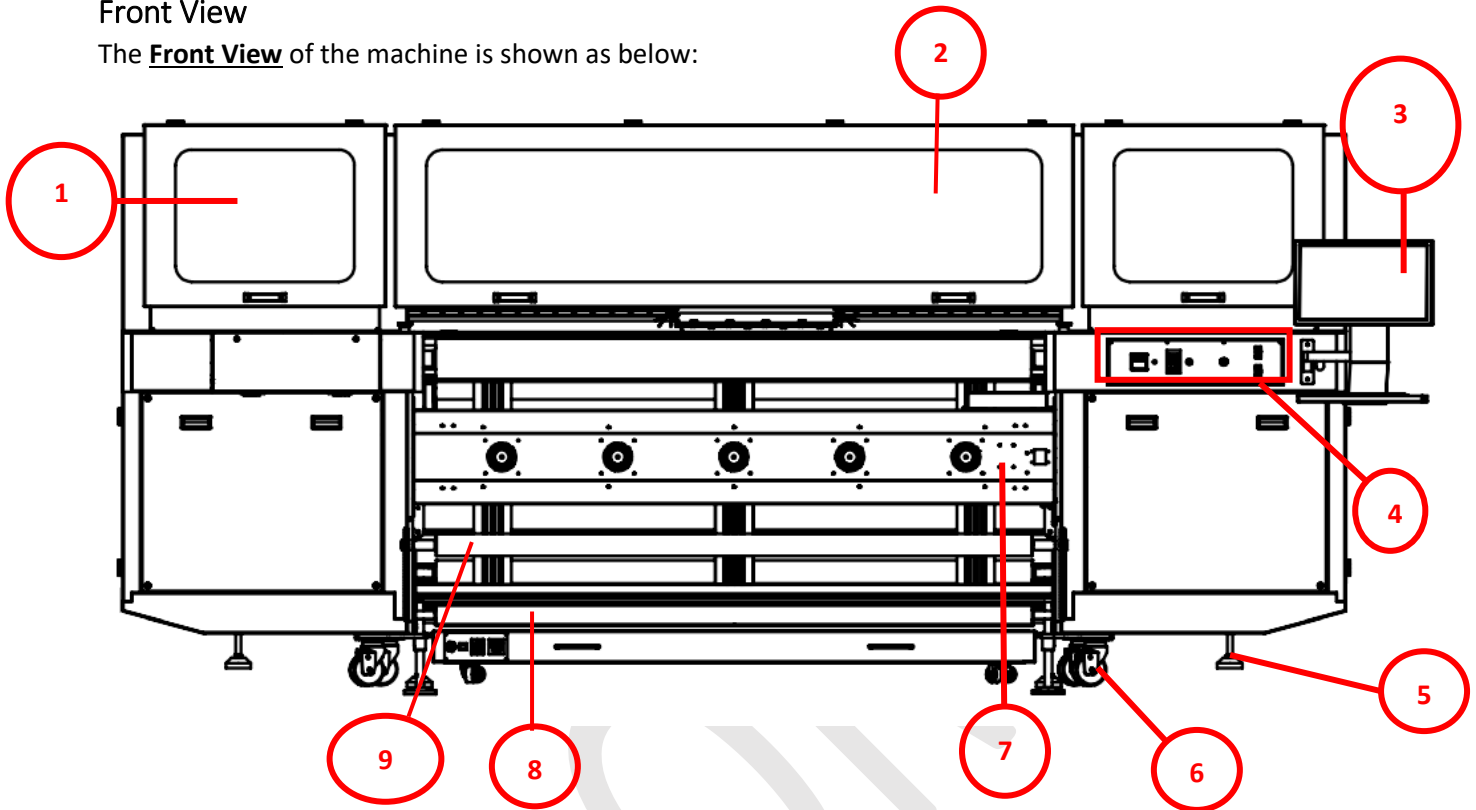
**Machine Specifications** are shown in the table below:

| SubliXpress Plus          |                        |                                                                                                 |       |
|---------------------------|------------------------|-------------------------------------------------------------------------------------------------|-------|
| Configuration             |                        | X4403                                                                                           | X4806 |
| Printing Technology       |                        | Drop on demand, Piezo Electric Inkjet                                                           |       |
| No. of Print Heads        |                        | 4                                                                                               | 8     |
| Print Heads               | Type                   | Industrial Grade Jetting Assemblies                                                             |       |
|                           | Resolution             | Upto 2400 dpi                                                                                   |       |
|                           | Height Adjustment      | Upto 20mm                                                                                       |       |
|                           | Cleaning Method        | Pressure Purge and Wiping                                                                       |       |
|                           | Wetting Control        | Piezoelectric Actuators                                                                         |       |
| Ink                       | Type                   | Dye Sublimation Aqueous Based Ink                                                               |       |
|                           | Colors                 | 4                                                                                               | 4     |
|                           | Supply (Tank Capacity) | 10 Litre Refillable Tank                                                                        |       |
| Media                     | Max. Thickness         | Upto 20mm                                                                                       |       |
|                           | Max/Printing Width     | Upto 1800mm                                                                                     |       |
|                           | Feed Roll Diameter     | Upto 900mm                                                                                      |       |
| Distance Accuracy         |                        | Error of less than $\pm 0.1\%$ of distance travelled or $\pm 0.1\text{mm}$ whichever is greater |       |
| Media Drying System       |                        | Infrared Heaters                                                                                |       |
| Printing Interface        |                        | USB 3.1                                                                                         |       |
| RIP Software              |                        | Onyx(ColorJet Edition) and NeoStampa(ColorJet Edition)                                          |       |
| Power Requirements        |                        | AC 220 V, 36 A, 50/60 Hz                                                                        |       |
| Dimensions (Printer Only) |                        | 3926 x 1235 x 1824 mm (LxWxH)                                                                   |       |
| Dimensions (Feeder Only)  |                        | 2415 x 1118 x 1050 mm (LxWxH)                                                                   |       |
| Packing Dimensions        |                        | 4200 x 2260 x 2050 mm (LxWxH)                                                                   |       |
| Machine Weight            |                        | N.W. 1600kg, G.W. 2300kg, Feeder N.W. 300kg                                                     |       |
| Operating Condition       |                        | Temperature: $24^{\circ}\text{C} \pm 4$ and Humidity: RH of 55% $\pm 10\%$                      |       |

### 3. Machine Overview

#### Front View

The **Front View** of the machine is shown as below:



*Fig 1: Displaying the Front View*

- |                                       |                       |
|---------------------------------------|-----------------------|
| 1. Left Door (Carriage Home Position) | 2. Front Middle Door  |
| 3. Console (TFT Screen)               | 4. Control Panel Unit |
| 5. Leveller                           | 6. Wheel              |
| 7. Dryer Fan Unit                     | 8. Dancing Roller     |
| 9. Guiding Roller                     |                       |

## Back View

The **Back View** of the machine is shown as below:

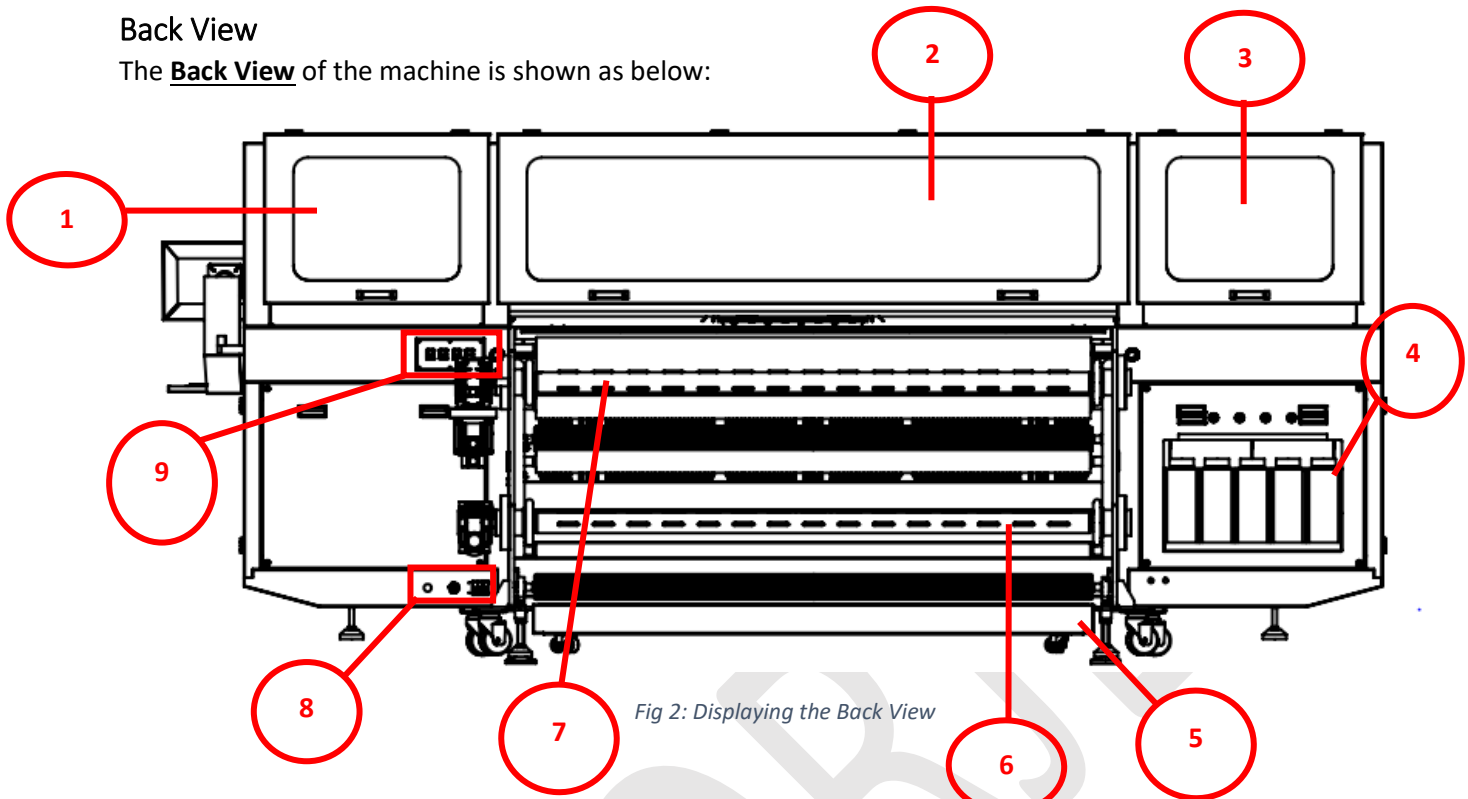
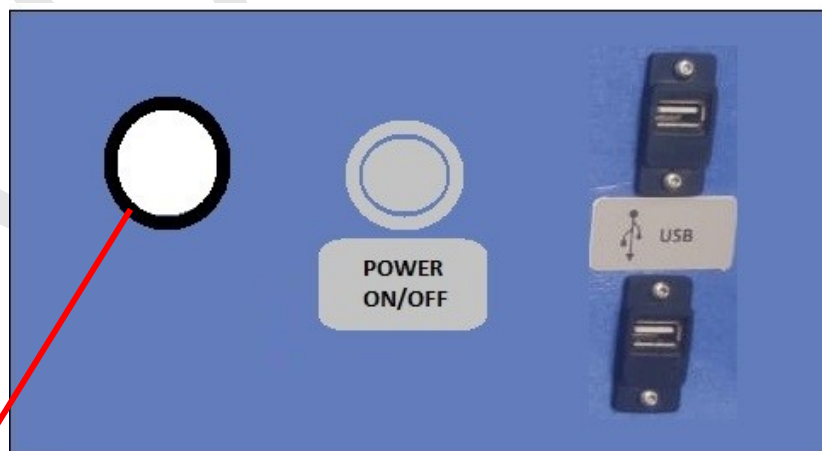


Fig 2: Displaying the Back View

- |                                       |                                                |
|---------------------------------------|------------------------------------------------|
| 1. Left Door                          | 2. Back Middle Door                            |
| 3. Right Door                         | 4. Main Ink Tanks                              |
| 5. Print Dryer                        | 6. Take-up Roller                              |
| 7. Supply Roller                      | 8. Power Inlet (Machine MCB and Heater Switch) |
| 9. Take-Up and Supply Control Buttons |                                                |

## Control Panel Details


The **Control Panel Screen** is shown as below:



**Bed Vacuum Control Regulator**

Fig 3: Displaying the Control Panel

**Different options of the Control Panel**

|                                                                                                                  |                                     |
|------------------------------------------------------------------------------------------------------------------|-------------------------------------|
| <b>Bed Vacuum Regulator</b><br> | Control the bed vacuum.             |
| <b>POWER ON/OFF</b><br>         | Turn ON/OFF the printer power.      |
| <b>USB Port</b><br>            | Insert USB cable into the USB port. |

The Take-Up and Supply controls are shown in the image below:



*Fig 4: Displaying the Take-Up and Supply Controls*

## 4. Getting Familiar with Printer Manager Interface

The **User Interface** of the Printer Manager software is shown as below:

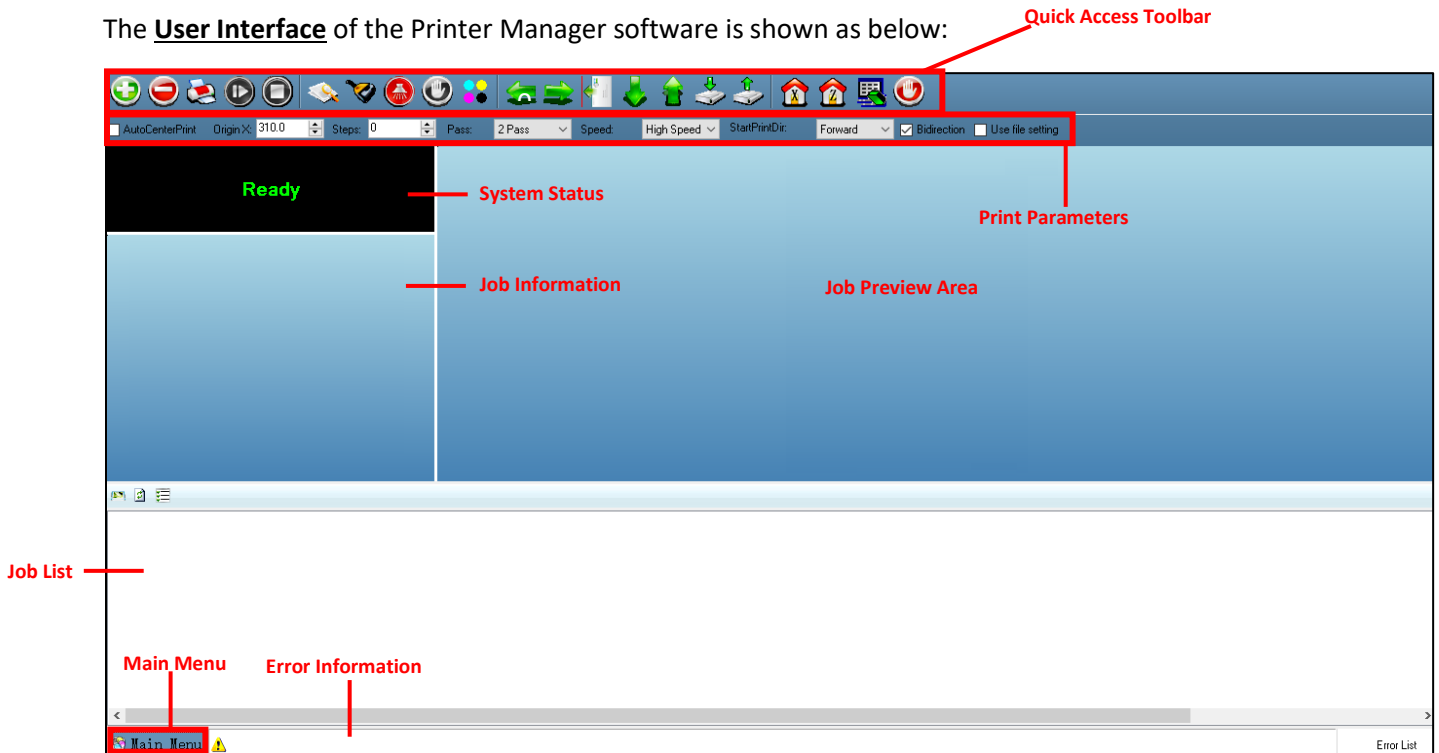


Fig 5: Displaying the User Manual of Printer Manager

The description of the Printer Manager window is given as below:

- A. Main Menu:** Consist of several sub menu options viz. Settings, Tools, and also provide variety of functions in well-organized manner.
- B. Quick Access Toolbar:** Display frequently performed actions like Add Job, Delete Job, Print Job, Pause or resume, Abort job, check nozzle, Auto clean, Move left, Move right, Set print origin, Move forward, Move backward, Move carriage to origin, and Edit job are available as buttons on the Quick access toolbar.
- C. Job Information:** Display the properties of the selected job like file name and path, Status, Print Size, Print Area, DPI, Pass, and more.
- D. Job Preview:** Show the job preview as well as print progress in this area.
- E. Job List:** Displays the thumbnail preview of added jobs.
- F. Error message:** Displays the system generated error messages.

## 5. Main Menu Options

The **Main Menu** options are shown in the image below:

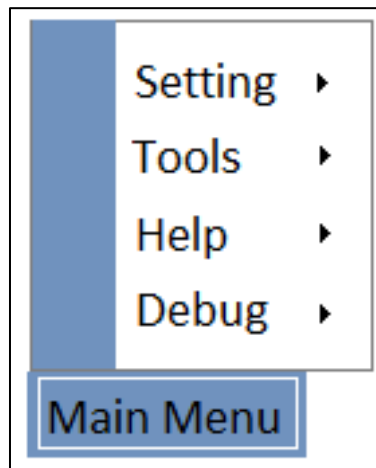


Fig 6: The Main Menu Options

### Setting Menu

The **Setting** menu options are shown in the image below:

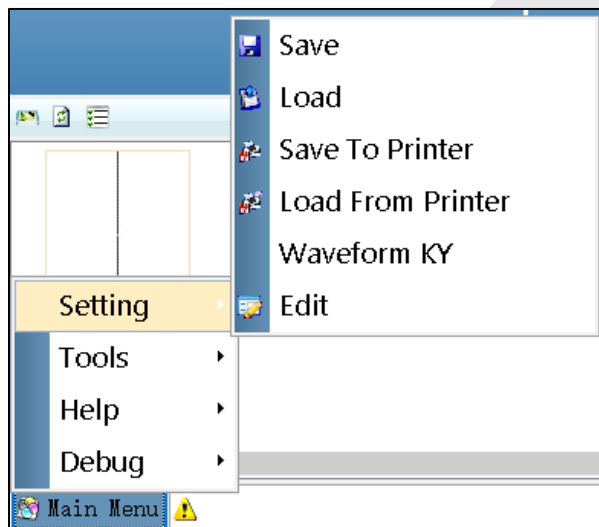


Fig 7: Displaying the Setting Menu and Its Related Options

**Save:** Using this option, you can save the default settings of the machine. When you save the settings, an xml file will be created for further references.

**Load:** Using this option, you can load the previously saved machine's settings.

**Save To Printer:** When you click on this option, all the current settings get saved in the Main Board of the machine.

**Load From Printer:** When you click on this option, the printer settings get saved from Main Board to Printer Manager software.

**Edit:** Using this option, you can edit the previously made settings of Printer. On clicking the Edit option, the Setting window with Printer, Move, Preference, and Calibration tabs appears on the screen.

The **Setting** window with the **Printer** tab is shown in the below image:

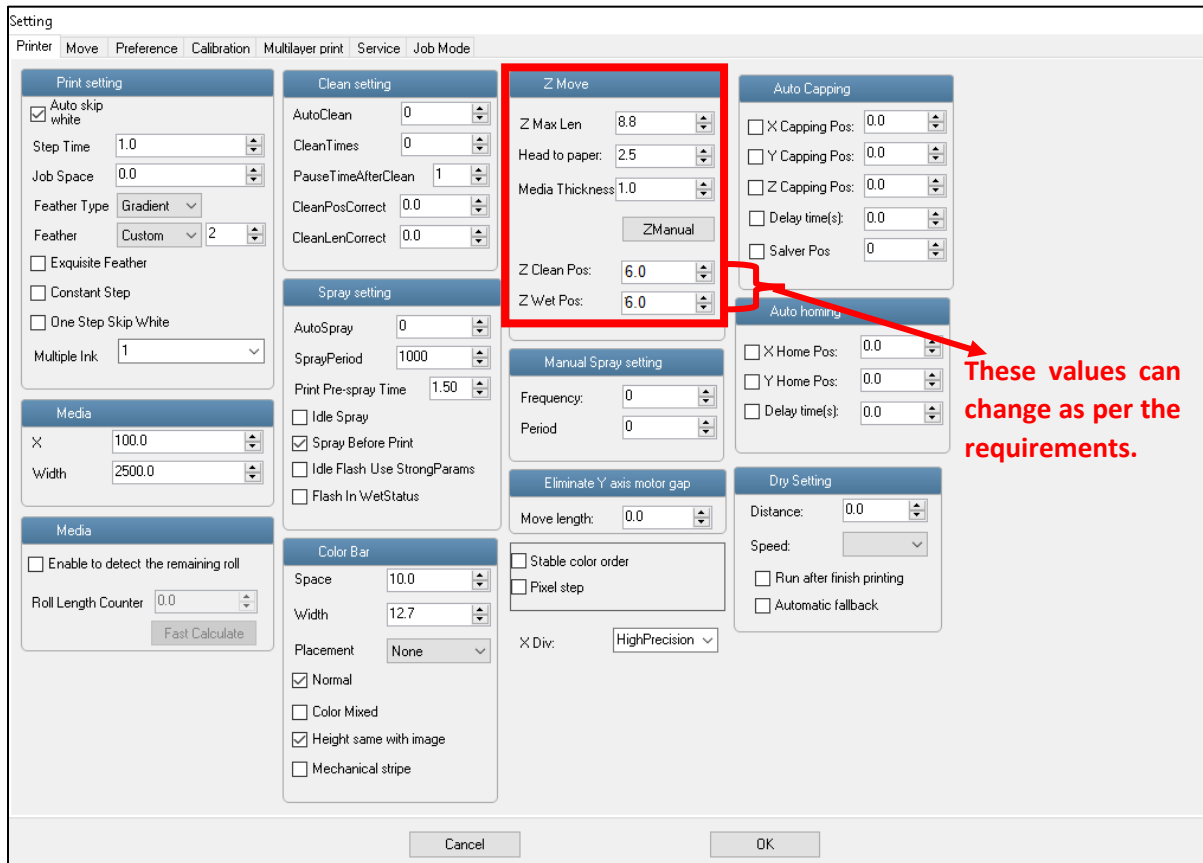


Fig 8: Displaying the Setting Window

Describing the different sections of the Setting window, as given below:

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <p><b>Print setting</b></p> <p><b>Auto skip white:</b> Enable to auto skip the white space in the image during printing.</p> <p><b>Step Time:</b> Set time interval of the feed motor during printing.</p> <p><b>Job Space:</b> Set space between multiple jobs.</p> <p><b>Feather:</b> Feather type should be “Gradient” only and intensity percentage of the feather should be 5-100 as per the media type.</p> <p><b>Multiple Ink:</b> Enable to select the color depth of an image according to the passes. The available options are Default, Double, and More.</p> | <p><b>Color Bar</b></p> <p><b>Space:</b> Specify the distance of the color bar from the image.</p> <p><b>Width:</b> Set width of the color bar.</p> <p><b>Placement:</b> Enable or disable the color bar and its placement viz. left, right, or both.</p> <p><b>Height same with image:</b> If enabled, the height of the color bar is same as the image height.</p> | <p><b>Spray setting</b></p> <p><b>Auto Spray:</b> Set the duration (number of passes) for auto spraying.</p> <p><b>Spray Period:</b> Define the duration for spraying. If the duration increased, spray frequency gets decreased.</p> <p><b>Print Pre-spray Time:</b> This option works when the <b>Spray Before Print</b> option is enabled and used for defining the duration, if spray before issuing the Print command.</p> <p><b>Idle Spray:</b> Spray during carriage at home position. This option must be enabled.</p> <p><b>Spray Before Print:</b> This option enables spray before start of print.</p> |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

The **Move** tab are shown in the image below:

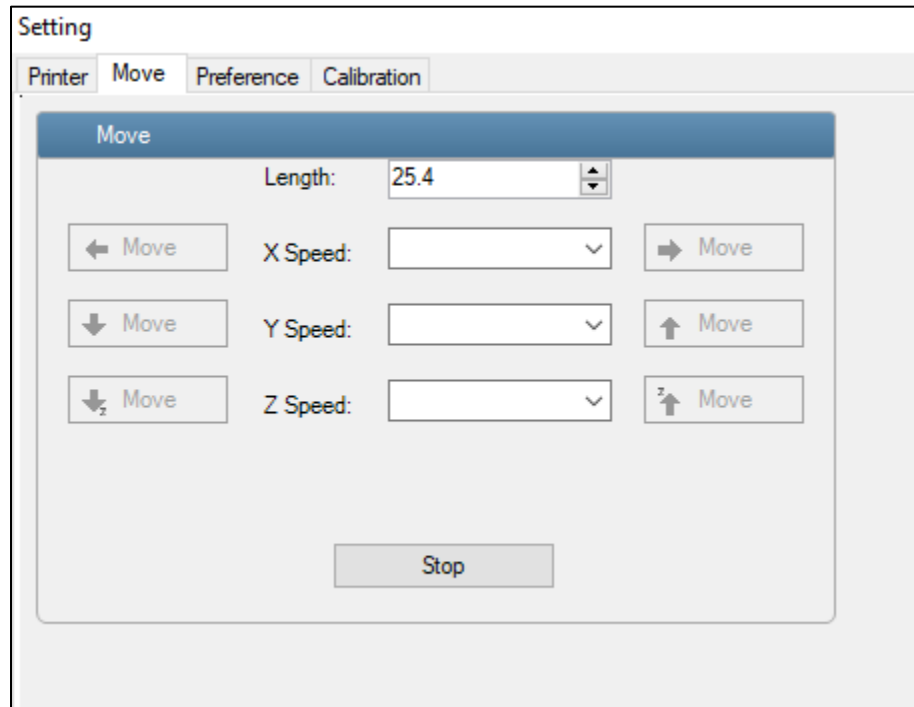


Fig 9: Displaying the Move Tab

**Note:** X and Y manual moving speed can be selected using the Move tab.

The **Preference** tabs are shown in the image below:

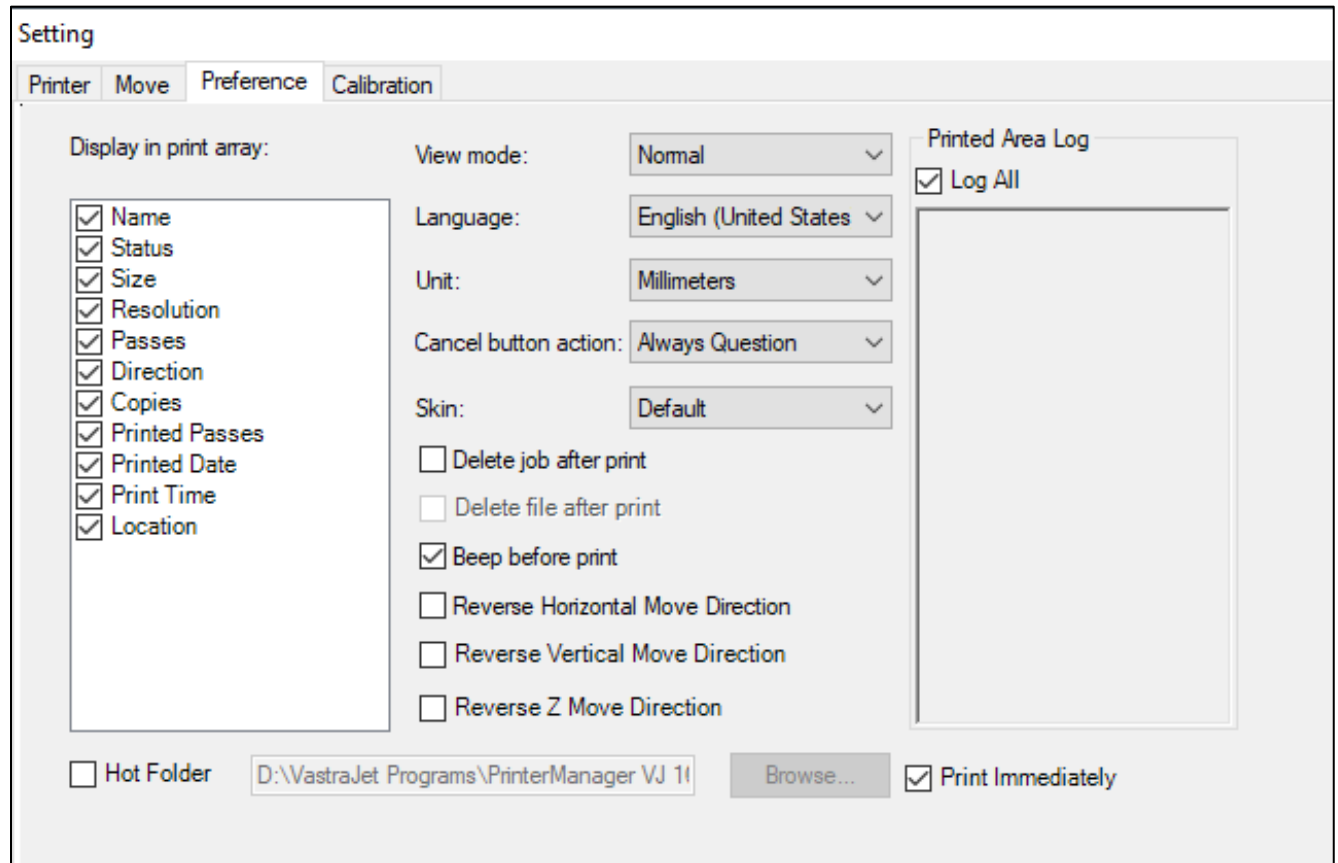


Fig 10: Displaying the Preference Tab

#### **Different options by the Preference tab:**

- **View Mode:** Enable to set the Printer Manager screen view.
- **Language:** Enable to change the language of the Printer Manager.
- **Unit:** Enable to set the measuring unit like Millimeter.

The **Calibration** and **Multilayer Print** tabs are shown in the image below:

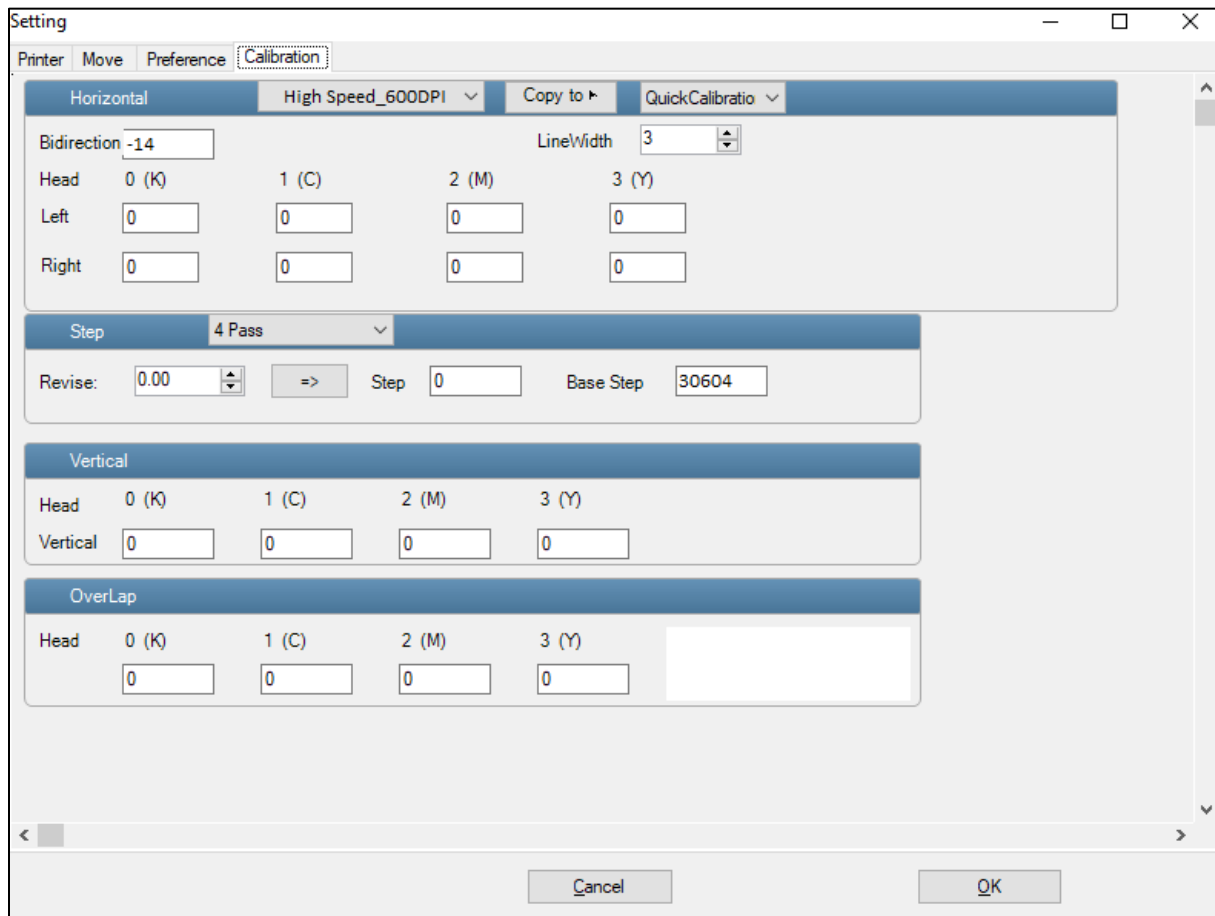


Fig 11: Displaying the Calibration and Multilayer Print Tabs

## Tools Menu

The **Tools** menu options are shown in the image below:

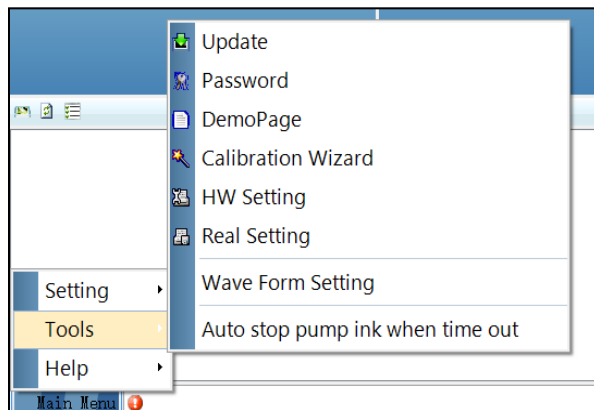


Fig 12: The Tools Menu Option

**Password:** This option enables to feed the time and language passwords of the printer.

**Calibration Wizard:** Using this option, you can perform different types of calibration viz. Angle Check, Vertical Check, Nozzle Check, and more. For more details, please read the “**Calibration Wizard**” section carefully.

**Auto stop pump ink when time out:** Enable or disable the pump automatically when time out occurs.

## Help Menu

The **Help** menu option is shown in the image below:

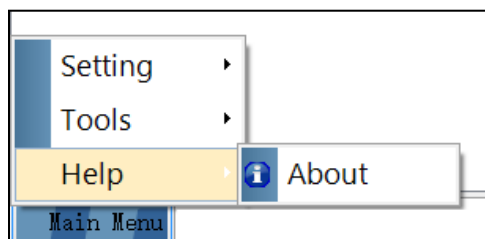


Fig 13: The Help Menu Option

**About:** Enable to view the details about Printer Manager software viz. software version and copyrights.

## 6. Getting Ready for Printing

### Switch ON Procedure

**Note:** Don't switch OFF the machine input power from the main power board and machine's MCB.

Follow these steps to switch ON the printer:

**Step 1:** Check Waste Bottle.

**Step 2:** Check Ink Level.

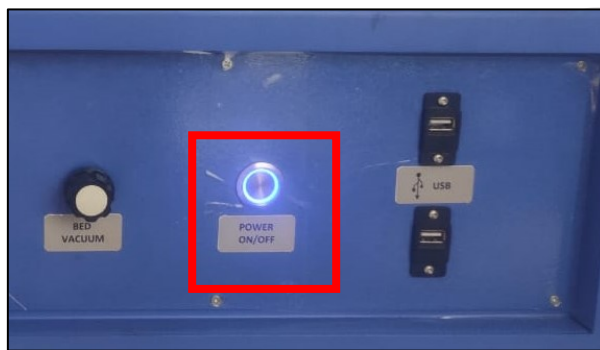
**Step 3:** Maintain the room temperature.

**Step 4:** Move the carriage manually away from the Home position.

**Step 5:** Turn ON the Power ON/OFF button to on the printer from the Control Panel.



*Fig 14: Displaying the MCB*



*Fig 15: Displaying the Power ON/OFF Button*

**Step 6:** Load the media.

**Step 7:** Turn on the computer system and open the printer manager software.

**Step 8:** Check the print head nozzles status by issuing the Nozzle Test command. If nozzle test result is not OK or nozzles are blocked, clean the Print Head by performing the steps given in the **Head Cleaning** section.

**Step 9:** Rip the image file using the Ripping software provided with the machine.

**Step 10:** Set the print origin to specify the printing starting position.

Now, the printer is ready for printing.

### Loading Media

Follow these steps to load media:

**Step 1:** Unwind the media roll and insert into the supply roller.

**Step 2:** Pass the media through dancing roller and guiding rollers (Refer to Fig 16).

**Step 3:** Pull out enough media from the supply roller to the print bed (Roller no 5 in Fig 16).

**Step 4:** After this, pass the media through guiding rollers and dancing. Finally, paste it on the take up roller, as shown in the image below:

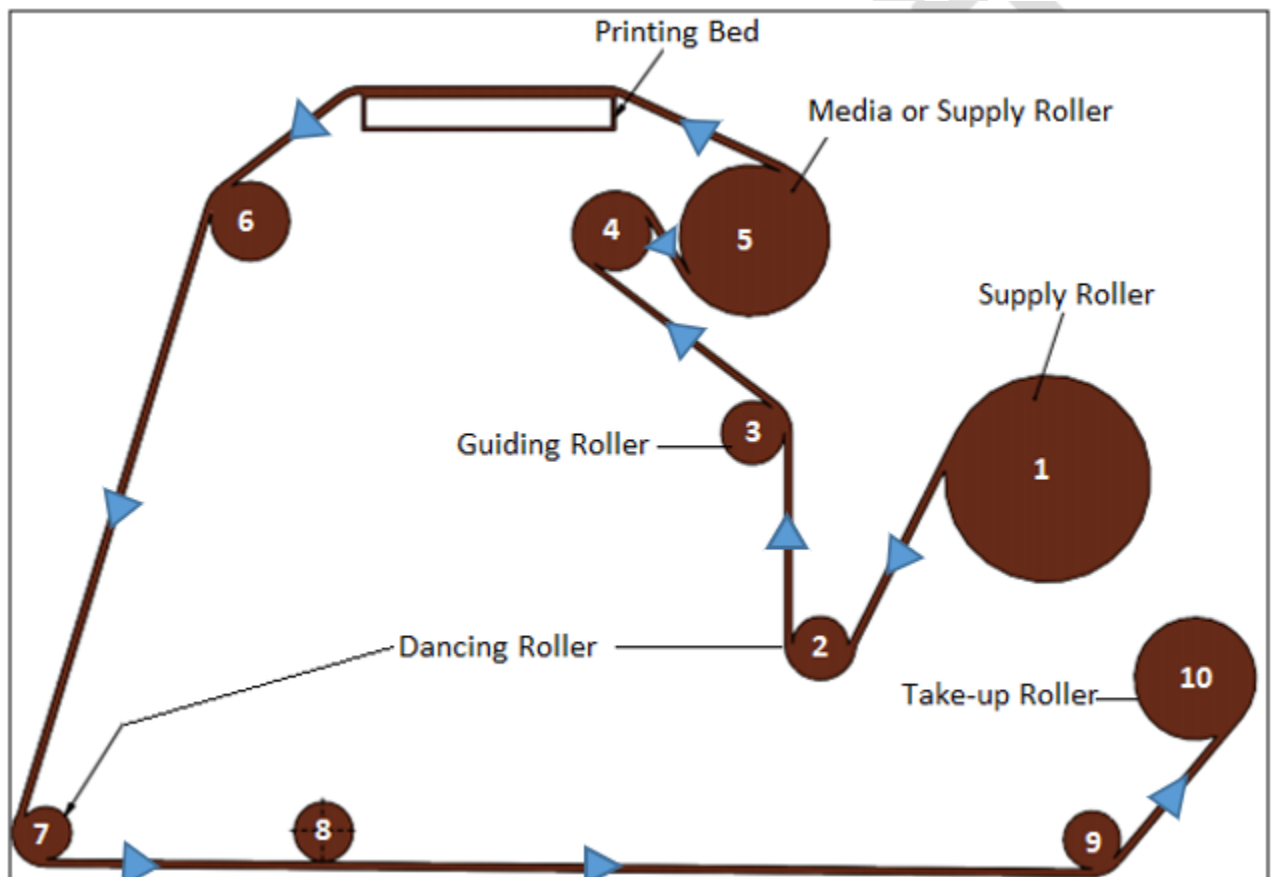


Fig 16: Showing the Media Path

**Note:** Media on the take-up must be perfectly aligned according to the supply roller's media.

## Ink Refilling

Please use the recommended ink in the printer for high printing quality as well as long life of print and print heads. To refill ink, open the left door of the printer and replace ink bottles, if empty. Ink gets filled in the Sub tanks.



Fig 17: Displaying the Main Tanks

## Feeding Password

The Password option enables operator to feed or update password of the printer. On clicking **Password** option under the **Tools** menu, the **Password** window appears with two options viz. Time Password and Language Password.

Follow these steps to change the passwords of the printer:

**Step 1:** Click on the **Main Menu**→**Tools**→**Password** path. The **Password** window appears on the screen.

**Step 2:** Feed Password in the **Time Password** field (Refer to Fig 19).

**Note:** The length of the password field must be of 16 digits.

**Step 3:** After feeding the passwords, click on the **Set** button (Refer to Fig 19).

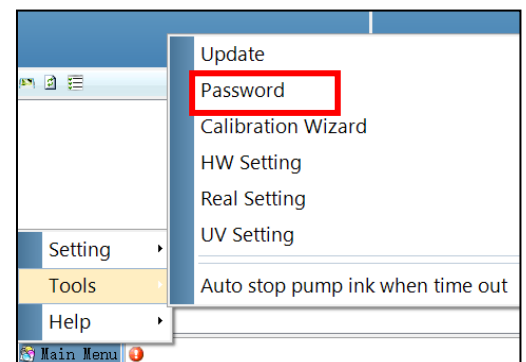
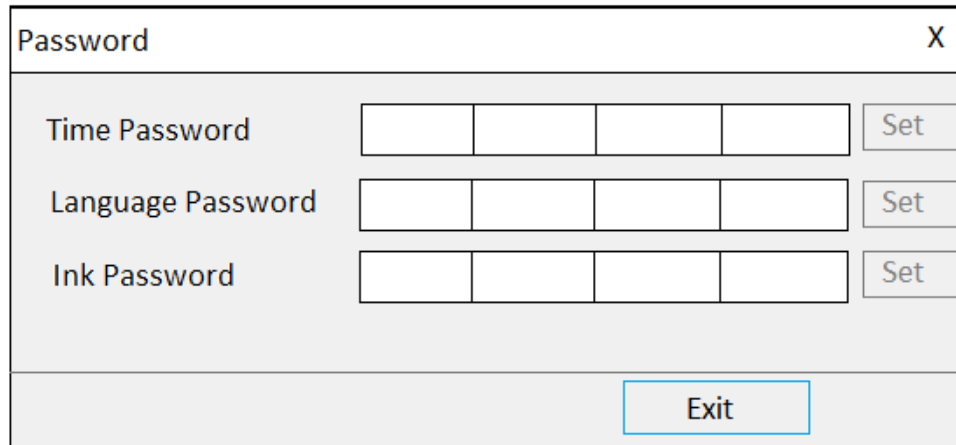


Fig 18: Selecting the Password Option

**Step 4:** Click on the **Exit** button to close the **Password** window, as shown below:



The screenshot shows a window titled "Password" with a close button (X) in the top right corner. Inside the window, there are three rows of input fields, each with a "Set" button to its right:

- Time Password: [ ][ ][ ][ ] Set
- Language Password: [ ][ ][ ][ ] Set
- Ink Password: [ ][ ][ ][ ] Set

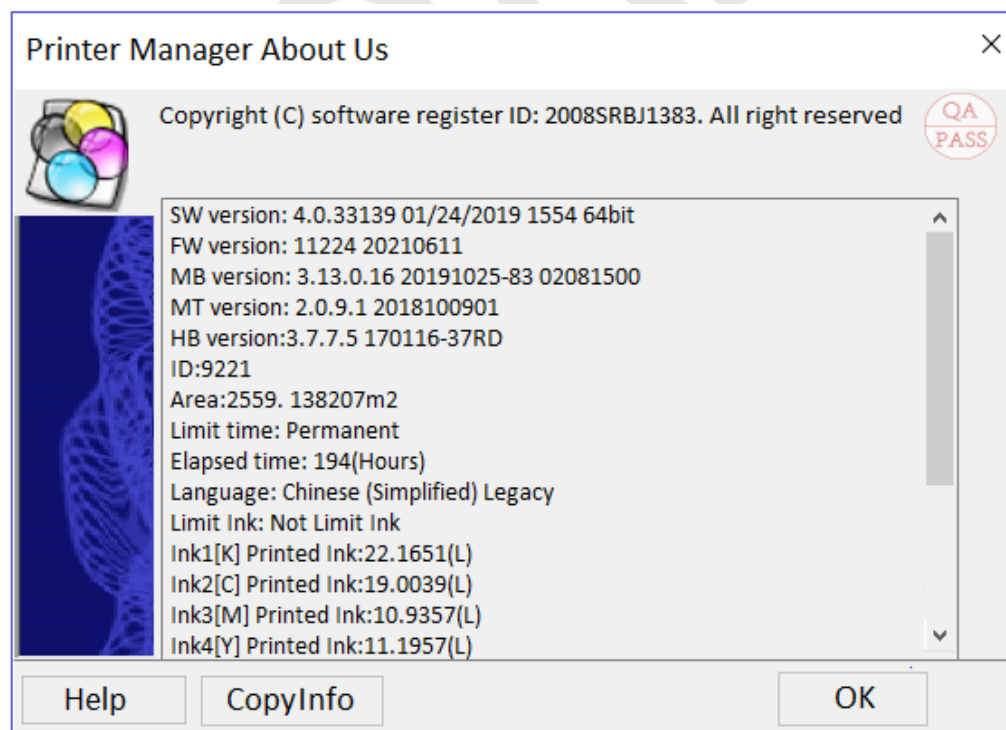
At the bottom center of the window is a large "Exit" button.

Fig 19: Displaying the Password Window

**Step 5:** After performing the above steps, restart the printer.

**Note:** When “**First Warning**” appears, kindly contact Head Office with the following screen:

- Password Screen (Refer to Fig 19)
- About Screen



The screenshot shows a window titled "Printer Manager About Us" with a close button (X) in the top right corner. The window contains the following information:

- Copyright (C) software register ID: 2008SRBJ1383. All right reserved
- SW version: 4.0.33139 01/24/2019 1554 64bit
- FW version: 11224 20210611
- MB version: 3.13.0.16 20191025-83 02081500
- MT version: 2.0.9.1 2018100901
- HB version: 3.7.7.5 170116-37RD
- ID: 9221
- Area: 2559. 138207m2
- Limit time: Permanent
- Elapsed time: 194(Hours)
- Language: Chinese (Simplified) Legacy
- Limit Ink: Not Limit Ink
- Ink1[K] Printed Ink: 22.1651(L)
- Ink2[C] Printed Ink: 19.0039(L)
- Ink3[M] Printed Ink: 10.9357(L)
- Ink4[Y] Printed Ink: 11.1957(L)

At the bottom of the window are three buttons: "Help", "CopyInfo", and "OK".

Fig 20: Displaying the About Us Screen

## 7. Printing

### Nozzle Testing

Before starting with calibration tests, the Print Heads should be checked for blockage. Each Print Head has multiple tiny nozzles through which ink drops emerge and get deposited onto the print medium. Any nozzle blockage can compromise the print quality by forming discolored horizontal streaks or bands.



Fig 21: Displaying the Good and Bad Nozzle Test

To check the nozzle, click on the **Check Nozzle** icon available on the **Quick Access Toolbar**, as shown below:



Fig 22: Clicking the Check Nozzle Icon

In case of blockages, refer to the **Head Cleaning** section to perform head cleaning before proceeding to other calibration steps.

### Print Head Calibration

The Print Head calibration is categorized into the following types:

- **Mechanical Check:** Includes Vertical Check and Angle Check
- **Software Calibration:** Includes Bi-direction, Horizontal Calibration and Step Calibration

**Note:** Mechanical checks are only performed by the Service Engineer.

### Calibration Wizard

Print Heads should be calibrated to ensure good printing quality. To open the Calibration Wizard, click on the **Main Menu→Tools→Calibration Wizard** path.

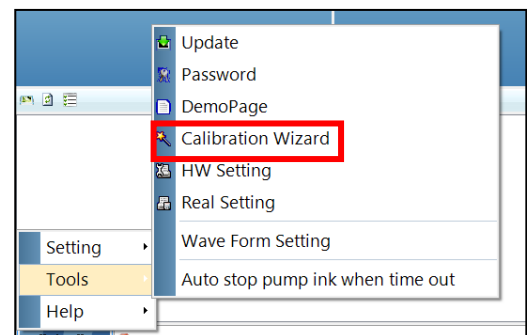


Fig 23: Selecting the Calibration Wizard Option

This should bring up the calibration wizard which is shown below:

**Mechanical Check**  
Adjust head with tools

Angle Check

Vertical Check

Nozzle Check

Cross Check

Fig 24: Displaying the Calibration Wizard

Click on the **Next** button to redirect to the software calibration screen, as shown in the below images:

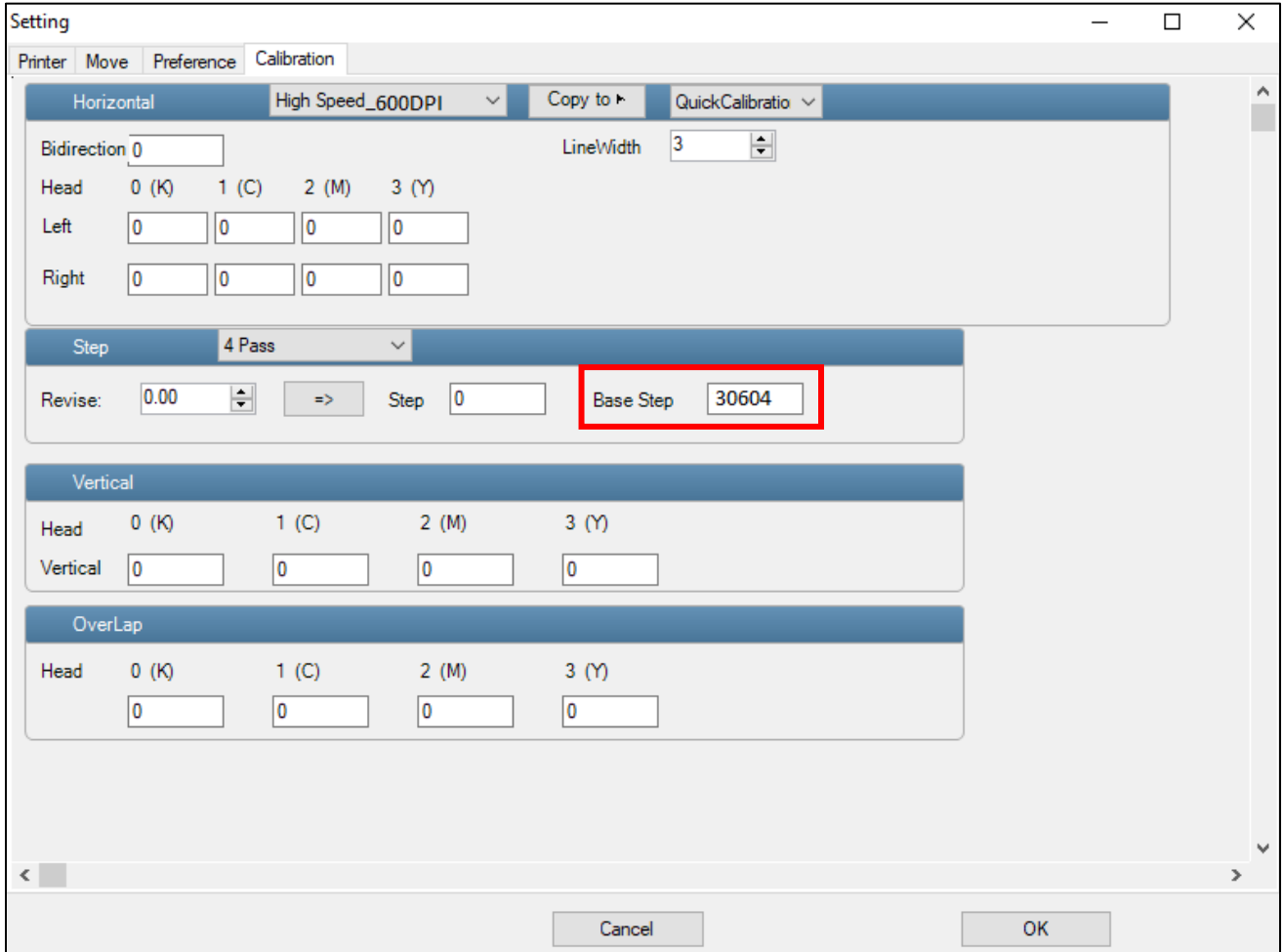


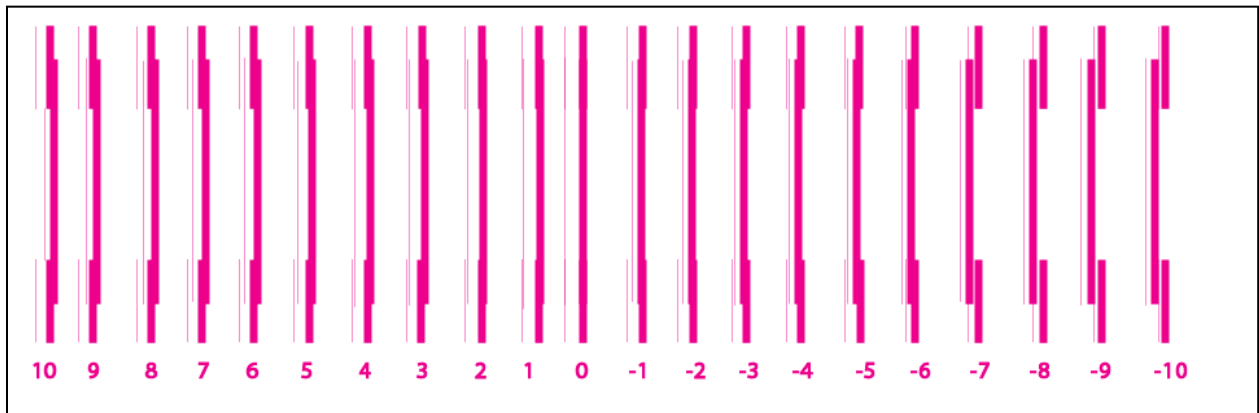
Fig 25: Displaying the Printer Calibration Options

**Note:** Base Step value should be **30583**.

### Bi-direction Calibration

Bi-directional calibration is performed to achieve dot placement accuracy between the “Left to Right” and “Right to Left” print sweeps. If the bi-direction offset value is correct, the Left to Right test print would align accurately with the Right to Left test print at “0” position. In case of error in the Bi-Direction offset, the Left to Right and Right to Left print would align at some other point on the scale.

The **Bi-direction Calibration Result** is shown in the image below:



*Fig 26: The Bi-Direction Calibration Output*

Based on the above figure, you can notice that the Bi-direction calibration is good at “0” position. The correction value is “0” which means you need not to correct the bi-direction value. Sometimes, the correction value can either positive or negative. If the correction value is positive, then you need to add it in the current bi-direction adjust value or subtract the same if negative.

### Horizontal Calibration

Horizontal Calibration checks left and right alignment and corrects it by adding or subtracting the correction value from the default set value. It has to be performed for each print mode, whichever is required.

### Left to Right and Right to Left Calibrations

Left to Right Calibration is performed to achieve dot placement accuracy of all colors (Black, Cyan, and Yellow) with respect to Magenta during the carriage’s left to right print sweep. Similarly, Right to Left calibration is used to achieve dot placement accuracy during the carriage’s right to left sweep.

When the position of the test head is correct, then it would align perfectly with the reference color at “0” position, indicating that the error position is “0”. If the test Print Head’s position saved in the system is inaccurate then it would not align at “0” position, but at some other point on the calibration scale. The position at which the test head aligns perfectly with the reference head, indicates the error in position.

The **Left Calibration** result is shown in the image below:

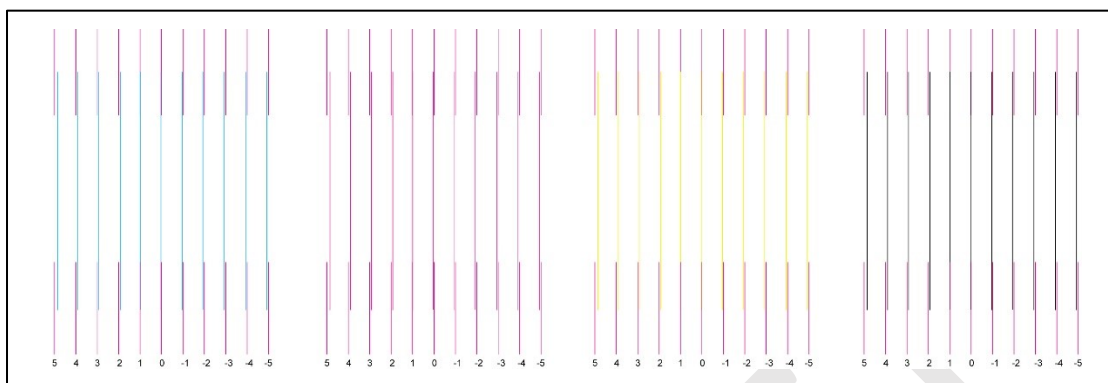


Fig 27: Displaying the Left Calibration

The **Right Calibration** result is shown in the image below:

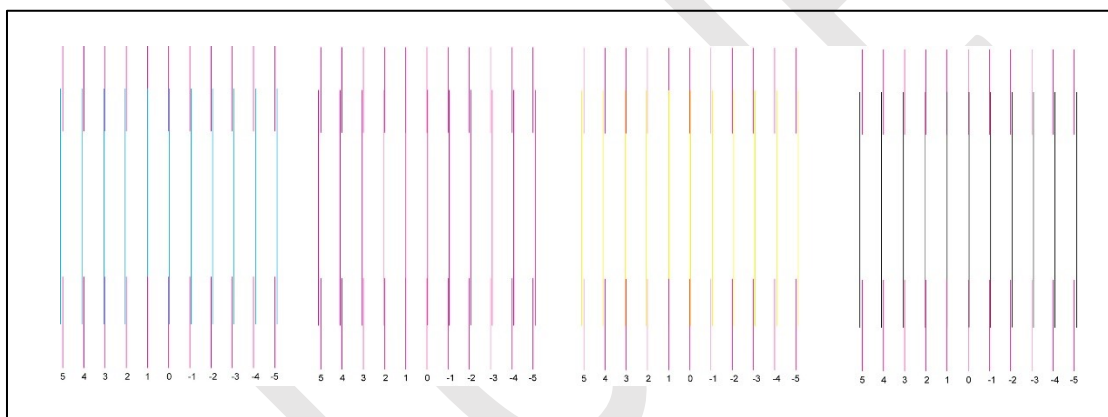


Fig 28: Displaying the Right Calibration

### Step Calibration

The printer step calibration is performed to verify and correct media feeding. The printer prints a complete image pass by pass. A pass is the horizontal carriage sweep perpendicular to the media movement. After each pass the printer moves the media forward for the next pass. This movement of media is called a step. The distance by which the media is moved is called the step size and it has to be accurate. Step size errors cause horizontal white or dark bands to appear in the print output.

Step size needs to be adjusted for multiple factors like thickness and roughness of the print media etc. Step calibration should be used to fine adjust the step size and has to be done for each desired pass. On the fly, Step value can be adjusted using the Steps field, as shown below:

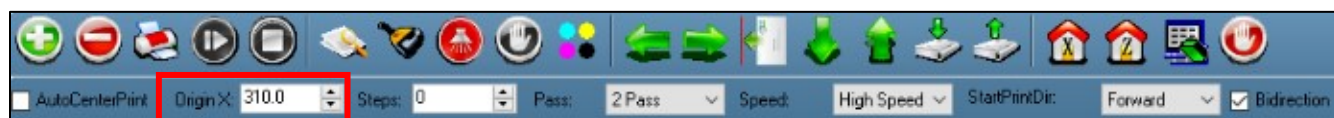


Fig 29: Selecting the Print Origin Option

The **Step Calibration Result** image is shown as below:

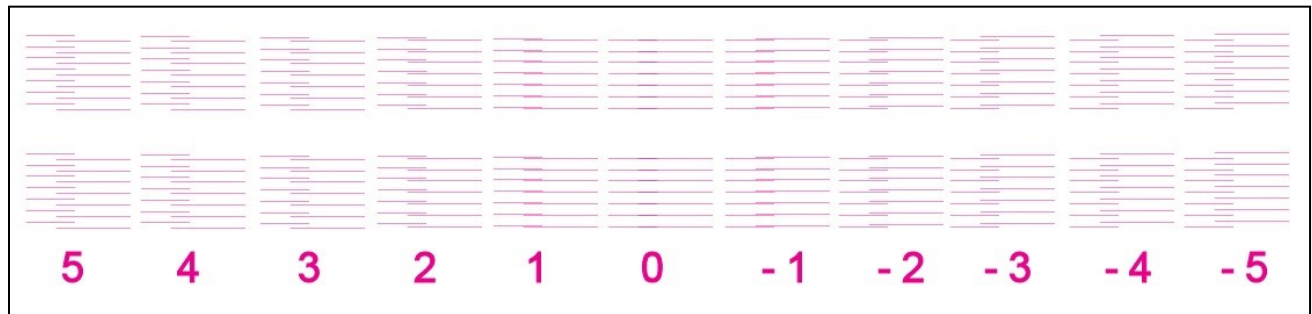
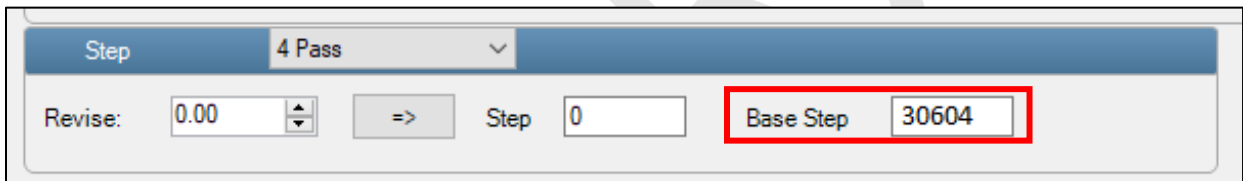


Fig 30: Displaying the Output of the Step Calibration

From the above figure, you get the accurate step adjust correction value. The correction value is either positive or negative. If the value is positive, then add it in the current step adjust value for the Print Head calibration. On the other hand, if the value is negative, then subtract the value from the current step adjust value. From the above, you can conclude that the pattern is corrected at "0" position.

The **Step Calibration** and its parameters are shown in the image below:



The image shows the Step Calibration Parameters window. It includes a dropdown menu for "Step" set to "4 Pass". Below this, there is a "Revise" field with a value of "0.00", an "=>" button, a "Step" field with a value of "0", and a "Base Step" field with a value of "30604". The "Base Step" field is highlighted with a red box.

Fig 31: The Step Calibration Parameters

Follow these steps to perform step calibration:

**Step 1:** Select the desired pass from the list and click on the **Print** button (Refer to Fig 31).

**Step 2:** Feed the correction value in the **Revise** field (the correction value up to two decimal places) (Refer to Fig 31).

**Step 3:** Click on the => icon (Refer to Fig 31) on the Step Calibration window. The correction value result will be reflected in the **Step** field (Refer to Fig 31). The same step value will also be displayed in the **Steps** field on the **Quick Access Toolbar**.

## Setting Print Origin

Print origin sets the print starting point with right most print head position as the reference point. It can be set by two ways; moving and positioning the carriage and typing the offset value directly in the given field.

Follow these steps to change the print origin:

**Step 1:** Move the carriage at the position from where you want to start the printing by *clicking* on the left and right buttons on the **Quick Access Toolbar**, as shown below:

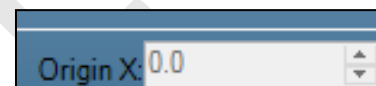


Fig 32: Adjusting the Carriage Position

**Step 2:** After positioning the carriage, *click* on the **Set print origin** icon on the **Quick Access Toolbar** (Refer to Fig 32).



On clicking the **Set print origin** icon, the current position of the carriage gets updated in the **Origin X** text box.



Now, the printing origin gets set. Additionally, you can also enter the print origin value manually in the Origin X field under the Print Parameter section.

## Setting Print Parameters

Using the Printer Manager, you can manually change print preferences as per the printing requirements such as print origin, printing speed, no of steps, and more as shown below:



Fig 33: Setting Printing Parameters

The description of printing parameters is given as follows:

- **Origin X:** Directly enter the print origin value.
- **Steps:** Remove step size errors in the current print job by specifying number of steps.
- **Pass:** Choose the number of passes with which the print job should be printed. Passes selected should be compatible with the Y DPI of the image selected. Increasing the number of passes improves the print quality but at the cost of printing time.
- **Speed:** Choose the printing speed like High Speed, Medium, and Low.
- **Medium Speed:** Set the Y printing speed viz. Standard Speed and Low.

## Adding Jobs

There are two ways to add jobs in the Job List area viz. the Add Job button and right click on the Job List area.

Follow these steps to add jobs in the Job List area:

**Step 1:** Click on the **Add Job** button  on the **Quick Access Toolbar**. The **Open** window appears on the screen.

**Step 2:** Navigate to the location where the image file with extension “.prt” and “.prn” is stored (Refer to Fig 34 ).

**Step 3:** Click on the **Open** button to add the file into the **Job List** area, as shown below:

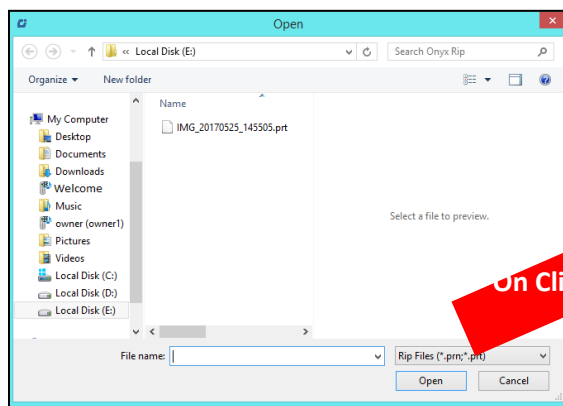
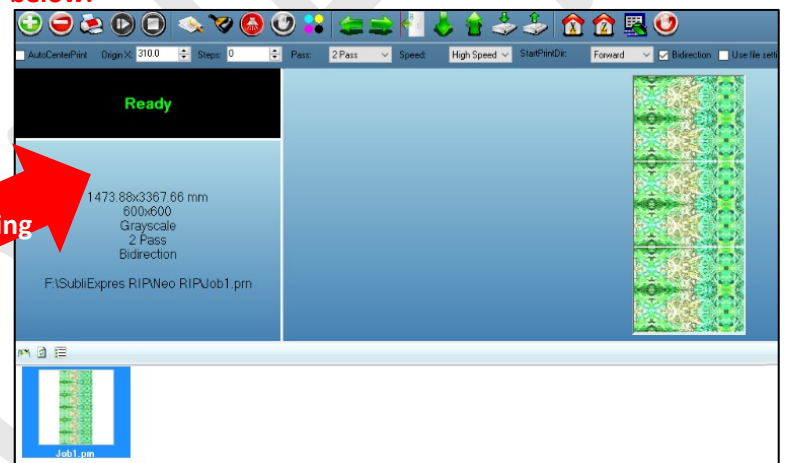


Fig 34: Adding the Job

The selected image appears in the Job List area, as shown below:



Once a file has been added its information such as file path, size, resolution, and number of passes can be viewed in the Job Information area. User can also add a job simply by right clicking on the Job List area and selecting the **Add Job** option from the context menu, as shown below:

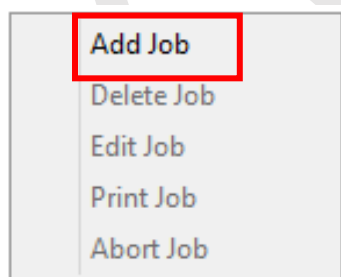


Fig 35: Adding Job

On selecting the **Add Job** option, the **Open** window appears and follow the above-mentioned steps to add more jobs.

**Note:** To delete the selected job, click on the **Delete job** icon on the **Quick Access Toolbar**.

## Editing Job

Follow these steps to edit the selected job:

**Step 1:** Select the job for which details you want to edit from the **Job List** area and right click.

**Step 2:** Select on the **Edit** option from the context menu.

**Step 3:** Select the desired checkbox in front of the Clip, Reverse Print, and Tile options. Clicking on any option will enable its related parameters on the right pane and you can edit them as per the requirements. In our case, we have selected the **Clip** checkbox. The job editing options are shown in the image below:

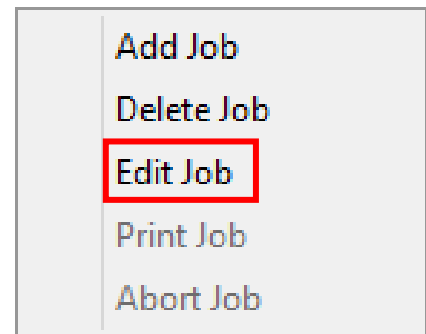


Fig 36: Selecting the Edit Job Option

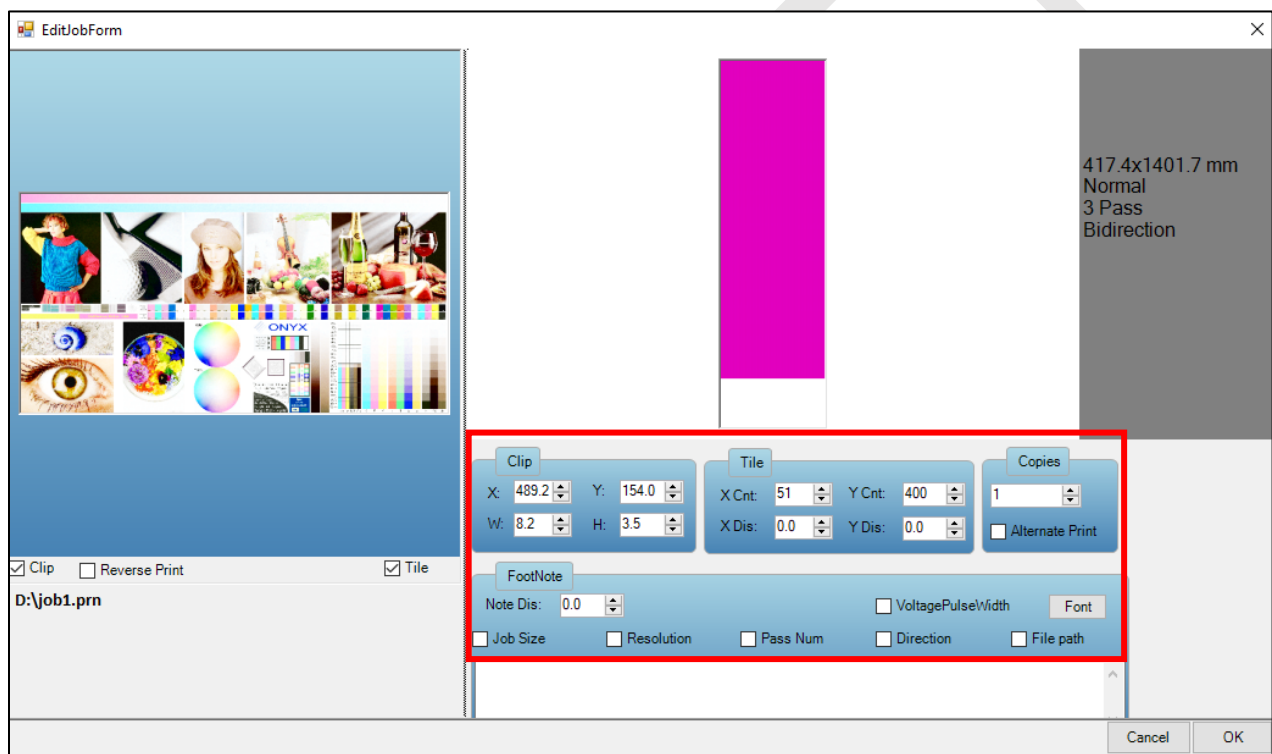


Fig 37: Displaying the Edit Job Options

**Clip:** By enabling this, a portion of the image can be selected by dragging the image preview. And its height and width can be adjusted. Also, the crop margins can be adjusted in x and y direction.

**Tile:** By enabling this, desired number of counts in x and y directions can be printed. Also, the distance between each count can be adjusted.

**Copies:** Feeding any number of copies will repeat the prints in Y direction. Careful, the Print will stop and restart after each copy.

**Foot note:** You can add footnote printing with each printed image. Parameters required can be selected.

**Step 5:** After making the desired changes, click on the **OK** button to apply the settings (Refer to Fig 37).

## Ripping and Printing

Ripping is an independent process which converts a raw image file into the machine-readable format and get the file ready for printing. The Rip software supports the pdf, tiff, jpeg, eps, psd, bmp file formats. After ripping the image file, the output file will be in “.prt” or “.prn” file format. Thus, you should first rip the image file before printing and then issue the Print command. While ripping, the color profiles are used to automatically perform the color corrections in the image. Now, you can print an image on the selected media simply by clicking on the **Print Job** button available on the **Quick Access Toolbar**.



Fig 38: Issuing the Print Job Command

After issuing the Print command, the printing gets started and its progress details displays in the Job Information area, as shown below:

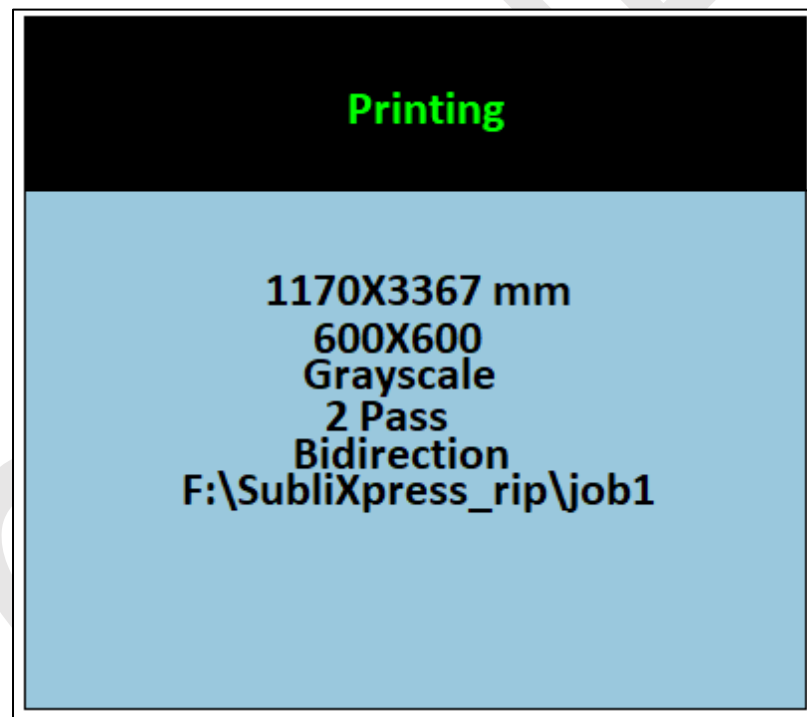


Fig 39: Displaying the Printing Details

## DPI and Print Mode

The DPI and passes are given as below:

| Print Mode | DPI      | Passes |
|------------|----------|--------|
| Mode 1     | 488X300  | 1      |
| Mode 2     | 488X600  | 2      |
| Mode 3     | 488X900  | 3      |
| Mode 4     | 488X1200 | 4      |

### Pausing and Canceling Printing

If you find any defect during the printing process, you can immediately pause or cancel the current printing job using the Pause or resume and Abort Job buttons available on the **Quick Access Toolbar** as shown below:



*Fig 40: Issuing the Pause or resume Command*

Similarly, you can abort the process by right clicking on the selected Job in the Job List area and select the **Abort Job** option from the context menu.

**Note:** Keyboard shortcut for pausing and resuming is **Ctrl+TAB**.

## 8. Head Cleaning

Print Head is a delicate part which needs to be cleaned as per the recommended methods to have long life and to ensure consistent print quality. Below sections give recommended steps to clean the Print Heads.

### Head Blotting

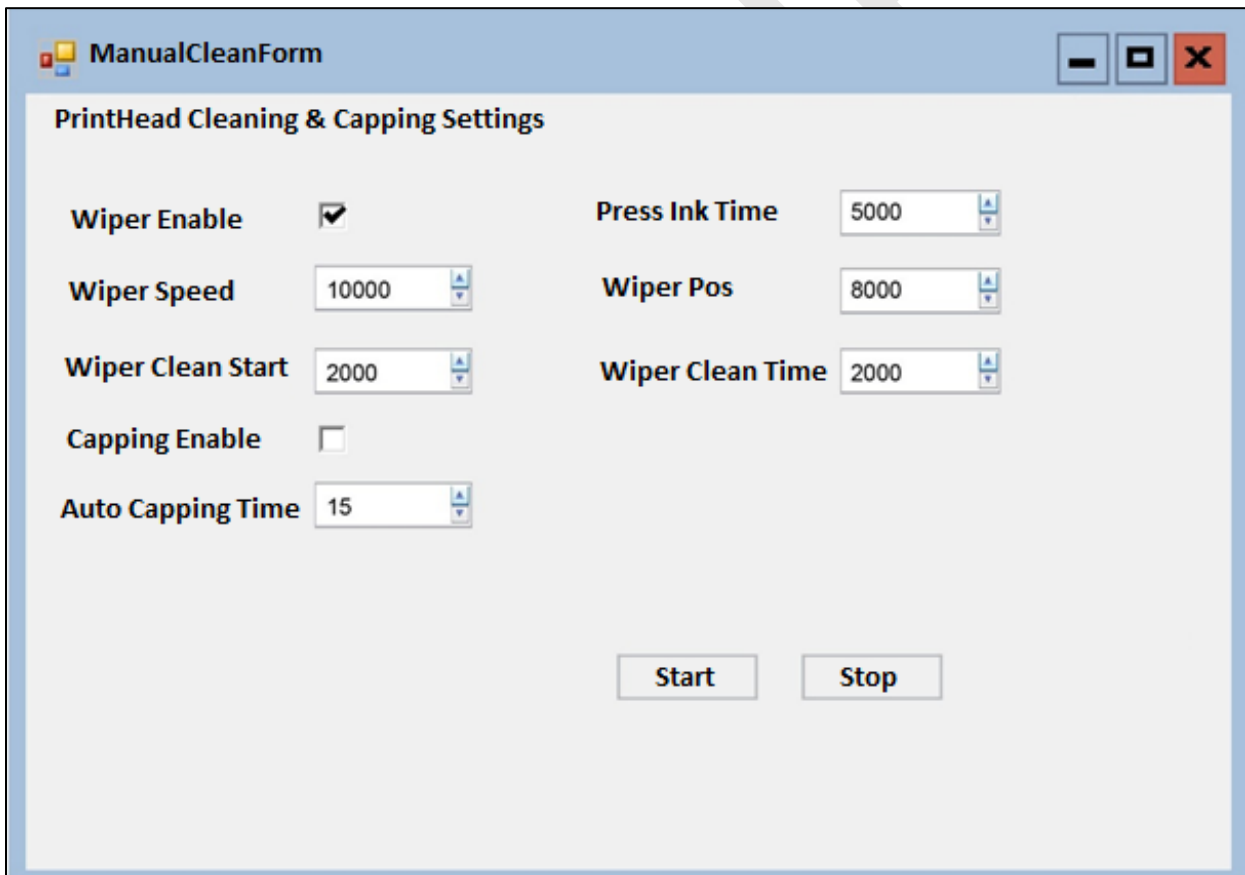
Head blotting refers to the process in which the head surface area is cleaned for better printing result and quality. In SubliXpress Plus, auto wiping option is available to clean the head surface area.

The Auto Wiping icon is shown in the image below:



Fig 41: Selecting the /auto Wiping Option

On clicking the **Auto Wiping** icon, the Manual Clean Form window appears on the screen, as shown below:



**ManualCleanForm**

**PrintHead Cleaning & Capping Settings**

|                          |                                     |                         |      |
|--------------------------|-------------------------------------|-------------------------|------|
| <b>Wiper Enable</b>      | <input checked="" type="checkbox"/> | <b>Press Ink Time</b>   | 5000 |
| <b>Wiper Speed</b>       | 10000                               | <b>Wiper Pos</b>        | 8000 |
| <b>Wiper Clean Start</b> | 2000                                | <b>Wiper Clean Time</b> | 2000 |
| <b>Capping Enable</b>    | <input type="checkbox"/>            |                         |      |
| <b>Auto Capping Time</b> | 15                                  |                         |      |

Fig 42: Displaying Auto Wiping and Auto Capping Settings

The list of Auto Wiping and Auto Capping options is defined as follow:

- **Wiper Enable:** Enable the auto wiper functionality.
- **Wiper Speed:** Help in defining the wiper speed.
- **Wiper Clean Start:** Define the wiper cleaning position.
- **Wiper Pos:** Define the wiper position.
- **Capping Enable:** Enable the auto capping functionality.
- **Auto Capping Time:** Define the auto capping time. When the printer is ideal for the define time then auto capping process gets started and capped the capping station with the head plate.

### Setting Wiping and Capping Height

Using the Setting window, user can set the wiping and capping height by updating values in the Z Clean Pos and Z Wet Pos list boxes, as shown below:

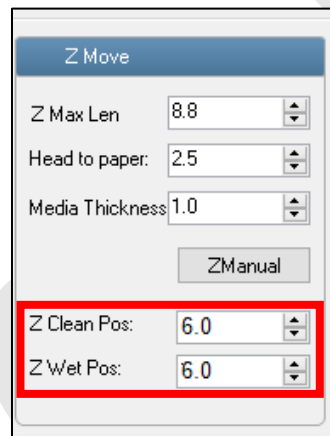
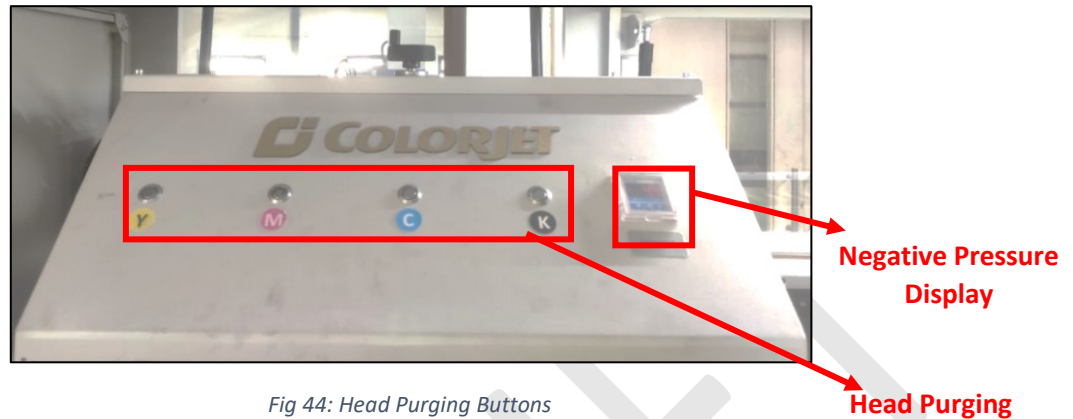


Fig 43: Setting Wiping and Capping Height

### Head Purging

Head purging refers to the method in which heads are cleaned by forcing pressurized ink through the nozzles. In the printer, The **Head Purging** button for each color is available on the carriage, as shown in the below figure:



**Note:** Negative pressure should be in the -4.3 - -5.0 range.

### Head Spraying

Head spraying clears the mixing of colors during blotting, may also clear few dry nozzles. When heads are sprayed, all the nozzles are actuated at a high rate which helps in opening up few dry nozzles of the printer. To perform head spraying, *click* on the **Spray** button available under the **Quick Access Toolbar**, as shown below:



## 9. Switch OFF Procedure

**Note:** Don't switch OFF the machine input power from main power board and machine's MCB.

Follow these steps to switch off the machine:

**Step 1:** Perform the Nozzle Test to check Print Head nozzles status.

**Step 2:** Clean the Print Heads, if required.

**Step 3:** Remove the media from the machine.

**Step 4:** Clean the Capping Station area and check the water in the Capping tray.

**Step 5:** Click on the **Auto Capping** icon to engage capping station with the head plate using the Printer Manager, as shown below:



*Fig 46: Displaying the Auto Capping Option*

**Note:** Never move the carriage manually over elevated capping station.

**Step 6:** Close the Printer Manager software.

Now, the printer is switch off.

## 10. Maintenance

### Environmental Maintenance

- Room temperature should be maintained in 18-28 Degree Celsius range with humidity 35-80%RH
- Closed dirt-free room exclusive for Printer
- Proper cool with white lightings

### Print Head Maintenance

Print Head is an important and delicate part of the printer. Thus, it must be handled with care to ensure the long life of the Print Heads. For Print Head maintenance, the following instructions should be taken care:

- Perform the nozzle test daily 2-3 times before printing to monitor the blockage in the head nozzles
- Avoid head damage due to media and Print Head confliction
- Color Bar should be ON
- Avoid ink spilling on the Print Head and head cables
- Don't use expiry ink and store the ink at favourable environment
- Clean heads using head cleaning techniques viz. head wiping, purging, and spraying

### Head Plate Maintenance

- Check the Waste Tray regularly and it must be cleaned before start working on the machine

### Waste Bottle Maintenance

- Check the Waste Bottle regularly and empty it, if full

### Print Bed Maintenance

- Clean dust particles and ink stains, if any

### Ink Filter Maintenance

- Replace the Ink Filter after six months

## 11. Troubleshooting

### Printer Not Initializing

- Encoder scale is having ink stains
- Encoder sensor is not cleaned

### Printer Manager Not Showing "READY"

- USB cable is not connected to the computer or loose
- USB cable is faulty
- Printer is OFF

### Print Stops in Between Printing

- USB cable is loose or faulty
- Open heavy file that can slow down the data transfer
- Ground wire is disconnected
- Encoder scale is having ink stains
- Pulley or belt is slipping
- Ripped file is having error
- Media is finished

### Print Margin is Shifting or Junk Printing

- Encoder scale is having ink stains
- Encoder sensor is not clean
- Pulley or belt is slipping
- Data cable is faulty

### Print is Blur (Not Sharp)

- Improper printer calibration - bidirectional and step
- Improper head mounting and calibration
- Selection of incorrect resolution
- Wrong speed selection instead of high precision

### Lines in Print

- Head nozzles are blocked
- Incorrect feed steps

### Heaters Not Working

- Check if inlet power cord and supply power are connected
- Check the set temperature in the controller

### Head Not Firing

- Perform nozzle test and clean heads, if required
- Check if any air lock or no ink in the head pipes
- Check the ink and air pipe for any cuts or loose connection

### Ink Not Supply

- Ink path have disclosure
- No ink in the main or sub ink tanks

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