8. When you have finished making the setting, press [ENTER].

9. Press [◄].

The screen shown below appears again.

```
NETWORK        ◄◆
IP ADDRESS        ▶
```

2. Set the subnet mask.

1. On the screen of step 9 of "1. Set the IP address." (P. 33), press [▼].

The screen shown below appears.

```
NETWORK        ◄◆
SUBNET MASK       ▶
```

2. Press [►] twice.

The screen shown below appears.

```
SUBNET MASK   ◄◆►
000.000.000.000↵
```

3. Press [▲] or [▼] to select the address number.

4. Press [►].

5. Repeat steps 3 and 4 to set the subnet mask (255.255.255.0).

For the subnet mask, make the setting the same value as the one used by the computer. Here, "255.255.255.000" is entered by way of example.

```
SUBNET MASK   ◄◆►
255.255.255.000↵
```

6. When you have finished making the setting, press [ENTER].

7. Press [◄].

The screen shown below appears again.

```
NETWORK        ◄◆
SUBNET MASK       ▶
```

If you connect the computer and the machine on a one-to-one basis, this completes the settings to make on the printer. Proceed to "Make the Port Settings for the RIP & PRINT MANAGEMENT SOFTWARE" (P. 35).

If you need to set the gateway address, proceed to the following procedure, "3. Set the gateway address." (P. 35).

3. Set the gateway address.

1. **On the screen of step 7 of "2. Set the subnet mask." (P. 34), press [▼].**

The screen shown below appears.

```
NETWORK          ◄╪
GATEWAY ADDR.      ►
```

2. **Press [►] twice.**

The screen shown below appears.

```
GATEWAY ADDR.◄╪►
000.000.000.000↵
```

3. **Press [▲] or [▼] to select the address number.**

4. **Press [►].**

5. **Repeat steps 3 and 4 to set the gateway address (255.255.255.255).**

For the value to enter for the gateway address, consult your network administrator. Here, "255.255.255.255" is entered by way of example.

```
GATEWAY ADDR.◄╪►
255.255.255.255↵
```

6. **When you have finished making the setting, press [ENTER].**

7. **Press [◄].**

The screen shown below appears again.

```
NETWORK          ◄╪
GATEWAY ADDR.      ►
```

Make the Port Settings for the RIP & PRINT MANAGEMENT SOFTWARE

- Install the RIP & PRINT MANAGEMENT SOFTWARE and set it up. For the print destination, use the IP address set on the printer. For information about how to make the settings, refer to the documentation for the RIP & PRINT MANAGEMENT SOFTWARE.

- You can check whether the connection to the network has been made by using the printing-test feature of the RIP & PRINT MANAGEMENT SOFTWARE. For information about how to carry out a printing test, refer to the documentation for the RIP & PRINT MANAGEMENT SOFTWARE.

First Time Printing

Basic Operation Flow

When Starting Daily Operations

1. "STEP 1:Turning the Power On" (P. 38)

⬇

2. "STEP 2:Loading Media and Setting the Height" (P. 39)

⬇

3. "STEP 3: Printing Tests and Normal Cleaning" (P. 41)

Actual Printing

⬇

4. Repeat steps 2 and 3.

⬇

5. "STEP 4: Performing Actual Printing" (P. 43)

After Daily Operations

⬇

6. "STEP 5: Printing Tests and Normal Cleaning after Daily Operations" (P. 48)

⬇

7. "STEP 6: Turning the Power Off" (P. 48)

Conditions for Usable Media

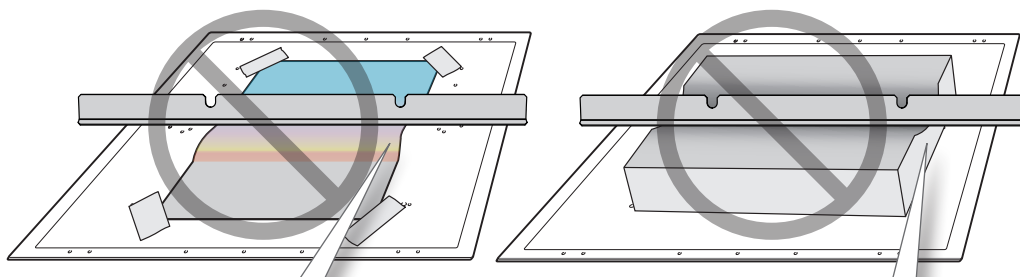In this manual, the printing material used for output is called "media."

Media		Condition
Maximum size	**Width**	538 mm (21.2 in.)
	Length	360 mm (14.2 in.)
	Thickness	100 mm (3.94 in.)
Maximum weight		5 kg (11 lb.)

NOTE

- Do not use media that is charged with static electricity.

- This printer cannot print on all materials. When selecting media, be sure to carry out testing in advance to make sure that satisfactory print quality can be obtained.

- There is a limit to the variation in the unevenness on the print surface.

☞ "Height Settings When the Print Surface is Uneven" (Master Guide)

- Depending on the type of media and the installation method, the height may not be set correctly. The machine may malfunction if printing is performed under these conditions. Do not use the following types of media.

Media that easily becomes loose

If the media becomes loose, the head gap sensor cannot detect the height correctly. Be sure to secure the media without looseness. If the media becomes loose, you can use a substance such as commercially available adhesive tape to hold the media in place.
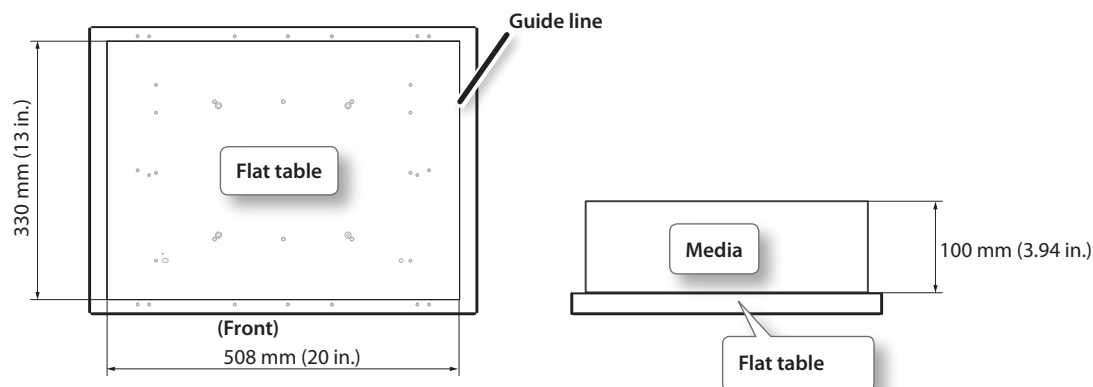
Media made from soft material

If the media is made from soft material, the pressure applied against the head gap sensor is too weak. This prevents it from detecting the height correctly.
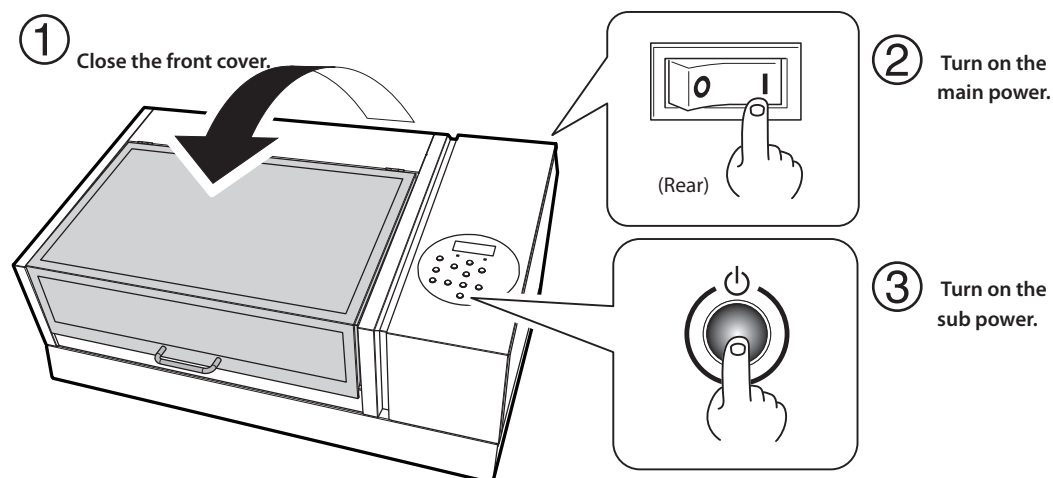
Printable Area

Maximum Printable Area: Width 508 × length 330 × thickness 100 mm (20 × 13 × 3.94 in.)

* The maximum printable area is inside the guide lines on the flat table.

* The maximum size of the media and the maximum printable area are different.

STEP 1:Turning the Power On

NOTE

Leave the main power switched on at all times.

Never switch off the main power. Leaving the main power on enables the automatic maintenance to be carried out periodically. If the automatic maintenance is not carried out, the printer may malfunction. For example, the print heads may be damaged.

Be sure to hold the handle of the front cover and keep holding it until the cover is completely opened or closed.

If you do not open and close the front cover gently, it may break or you may be injured.

STEP 2:Loading Media and Setting the Height

1. Loading Media (Media Setup)

NOTE

Be sure to hold the handle of the front cover and open and close it gently.

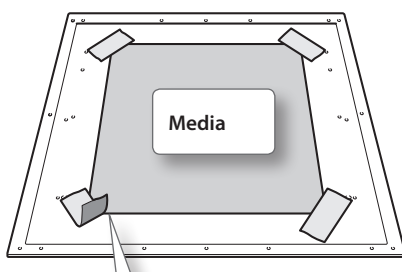**1.** **Check that the following screen is displayed.**

```
SETUP MEDIA
```

MEMO

When this screen is not displayed, you cannot perform setup. To perform setup, make sure that there is nothing placed on the flat table, and then press [SETUP] for one second or longer. The flat table will come forward into a position in which you can set up the media.

2. **Open the front cover.**

3. **Secure the media in place.**

Printing tests are used to check that no dot drop-out occurs. For printing tests, use media for testing (width 80 × height 70 mm, width 3.1 × height 2.8 in. or bigger), not the media you will actually use.

Media

Secure the media with tape.

Secure the media in place using a substance such as commercially available tape affixed directly to the flat table. This method can be used for thin paper media or those that can be secured with tape only.

The media can be set anywhere as long as it does not protrude from the flat table.

Be aware that when there are folds or kinks in the media, they might hit the interior of the printer and cause damage.

4. **Close the front cover.**

2. Setting the Height of the Media Automatically

The height of the media is automatically detected, and the print heads are adjusted to the appropriate height for printing.

MEMO

- If the print surface is uneven, there is a limit to the area of unevenness.

☞ "Height Settings When the Print Surface is Uneven" (Master Guide)

- You can manually set the height of the media. The automatic height setting is not suitable if you do not want to make the head gap sensor come into contact with the media. In this case, you should set the height manually.

☞ "Setting the Height of the Media Manually" (Master Guide)

NOTE

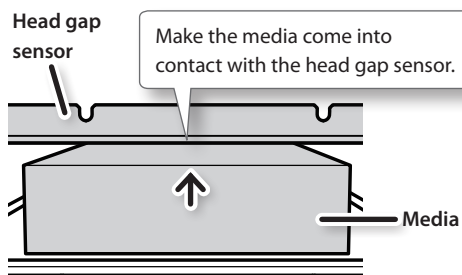Be sure to hold the handle of the front cover and open and close it gently.

1. Press [SETUP].

[SETUP] starts to flash.

2. Press [▲], [▼], [UP], or [DOWN] to move the flat table.

Bring the highest position of the media (print surface) into contact with the head gap sensor. When the head gap sensor reacts, a buzzer goes off.

```
HEIGHT:000.0mm  ▸
                ↵
```


Head gap sensor

Make the media come into contact with the head gap sensor.

Media

MEMO

This step can be performed with the front cover open.

3. Press [▶].

The screen shown below appears.

```
AUTO DETECTION  ◂
                ↵
```

4. If the front cover is open, close it.

The following step moves the flat table rearward. If the media hits the head gap sensor, the media may be damaged or the head gap sensor may malfunction.

To readjust the height of the media, press [◀] and perform the procedure again starting from step 2 in "2. Setting the Height of the Media Automatically" (P. 40).

5. Press [ENTER].

The flat table moves, and media height detection starts. The flat table rises while moving backward and forward until the media reaches a position where it comes in contact with the head gap sensor.

When the flat table stops moving and one short beep is heard, the setup is complete.

The media's height will be set automatically to a position about 1 mm (0.04 in.) away from the ink emission surface of the print heads.

MEMO

You can change the distance between the ink emission surface of the print heads and the media. For more information, see "Expanding the Distance between the Media and the Print Heads" (Master Guide).
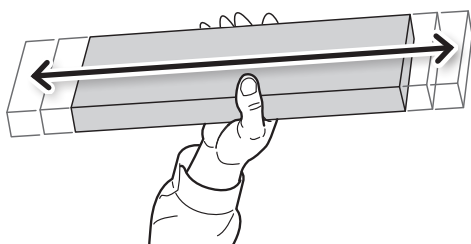
STEP 3: Printing Tests and Normal Cleaning

Check for dot drop-out by performing printing tests before and after daily operations. If dot drop-out occurs, perform cleaning of the print heads (normal cleaning). Leaving the dot drop-out untreated may damage the print heads, so be sure to check for this condition each day after operation.

* Dot drop-out is a condition where dust or other foreign matter adheres to the print heads and interferes with normal ink emission.

1. Perform a Printing Test on Media for Testing

1. **Remove just the white ink cartridge, shake it 50 times (about 15 seconds), and then reinsert this cartridge.**
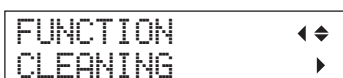

NOTE

The components in the white ink have a tendency to precipitate. If ink components precipitate, it will not be possible to print with correct colors. So that the ink mixes well, shake the ink cartridge horizontally with a stroke length of around 5 cm (2 in.) from each end of the ink cartridge.

The deposits may harden and cause problems including printer malfunctions if left alone for an extended period of time.

2. **Press [FUNCTION].**
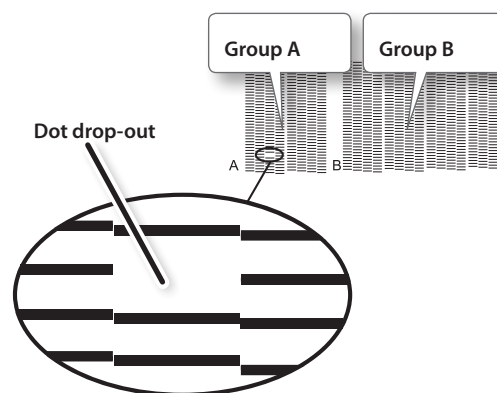
The screen shown below appears.

```
FUNCTION      ◀◆
CLEANING       ▶
```

3. Press [►].

The screen shown below appears.

```
CLEANING      ◀◆
TEST PRINT     ↵
```

4. **Press [ENTER].**

A test pattern is printed.

If dot drop-out is present, proceed to "2. Perform Normal Cleaning" (P. 42).

If there is no dot drop-out, proceed to "STEP 4: Performing Actual Printing" (P. 43).

If the printing-test results are difficult to interpret

Examine the results from different angles in a well-lit location. Take advantage of reflected light to enable visual checking.

2. Perform Normal Cleaning

1. Press [FUNCTION].

2. Press [►], then [▼].

The screen shown below appears.

```
FUNCTION        ◄◆
CLEANING          ►
```

3. Press [►].

The screen shown below appears.

```
CLEANING        ◄◆
NORMAL CL.        ►
```

4. Press [◄] or [►] to select the group of print heads that is not to be cleaned (P. 41).

```
NORMAL CL.     ◄◆►
     AB          ↵
```

Group

5. Press [▲] or [▼] to clear the group of print heads that is not to be cleaned from the display.

```
NORMAL CL.     ◄◆►
     AB          ↵
```

6. Press [ENTER].

Normal cleaning starts. It takes about two to three minutes.

```
CLEANING...
>>>>
```

When finished, the screen shown below appears again.

```
NORMAL CL.     ◄◆►
     AB          ↵
```

7. Press [FUNCTION].

The display returns to the original screen.

```
W:508mm L:330mm
H:100.0mm
```

8. Perform a printing test (P. 41) again to make sure the dot drop-out has been corrected.

If the problem persists, try performing cleaning again.

If the printer has been used for a long period, the problem may not be fixed even after performing cleaning two or three times. If this is the case, perform medium or powerful cleaning.

☞ "Medium and Powerful Cleaning" (Master Guide)

NOTE

UV ink will harden. It may adhere to the print head and solidify. If left alone, ink may clog the print heads and cause problems including printer malfunctions.

Clean the head manually when printing frequently with the print head at a distance from the print surface. This is called manual cleaning. To prevent clogging of the print heads, you may have to perform manual cleaning each time you print in some cases.

For more information, see "Manual Cleaning" (Master Guide).

STEP 4: Performing Actual Printing

This section explains how to print from this machine, using the included VersaWorks Dual (RIP & PRINT MANAGEMENT SOFTWARE). It assumes that you have already completed the following tasks.

- Installation of VersaWorks Dual
- Connecting VersaWorks Dual and this machine
- Learning the basic operation of VersaWorks Dual
- ☞ "Roland VersaWorks Dual Installation Guide"
- Preparing print data

In this section, a file saved as a PDF file is used.

1. Perform "STEP 2:Loading Media and Setting the Height" (P. 39)

Load the media that you actually want to print on and set the print area.

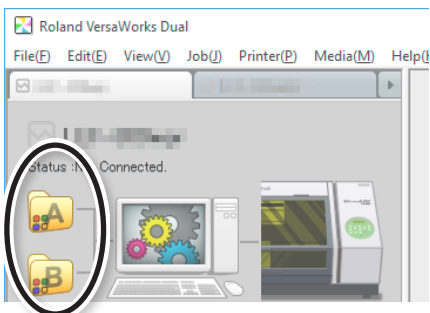## 2. Load the Print Area Set on This Machine into VersaWorks Dual

1. **Start VersaWorks Dual.**

Check that:

- VersaWorks Dual connects to the machine.
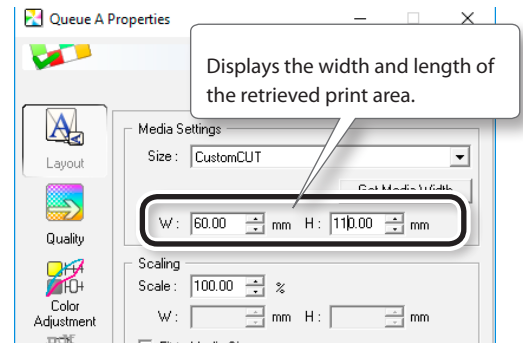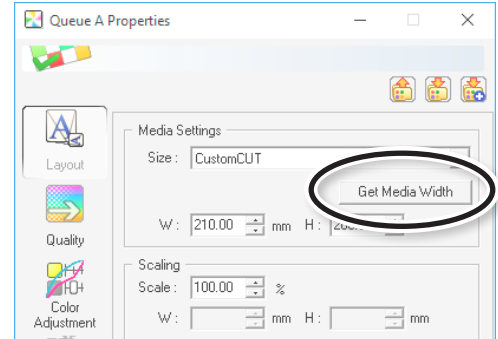- The machine's status is "Ready to Start Printing."

2. **Double-click (or).**

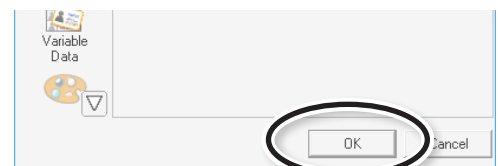The "Queue A Properties" dialog box appears. (Display the properties for the input setting to use.)

3. **Click [Get Media Width].**

Load the print area set on this machine into VersaWorks Dual.

Displays the width and length of the retrieved print area.

* To configure other settings, see the "VersaWorks Dual Installation Guide," the Help, or the "Special Color Inks & Primer Guide" (included).
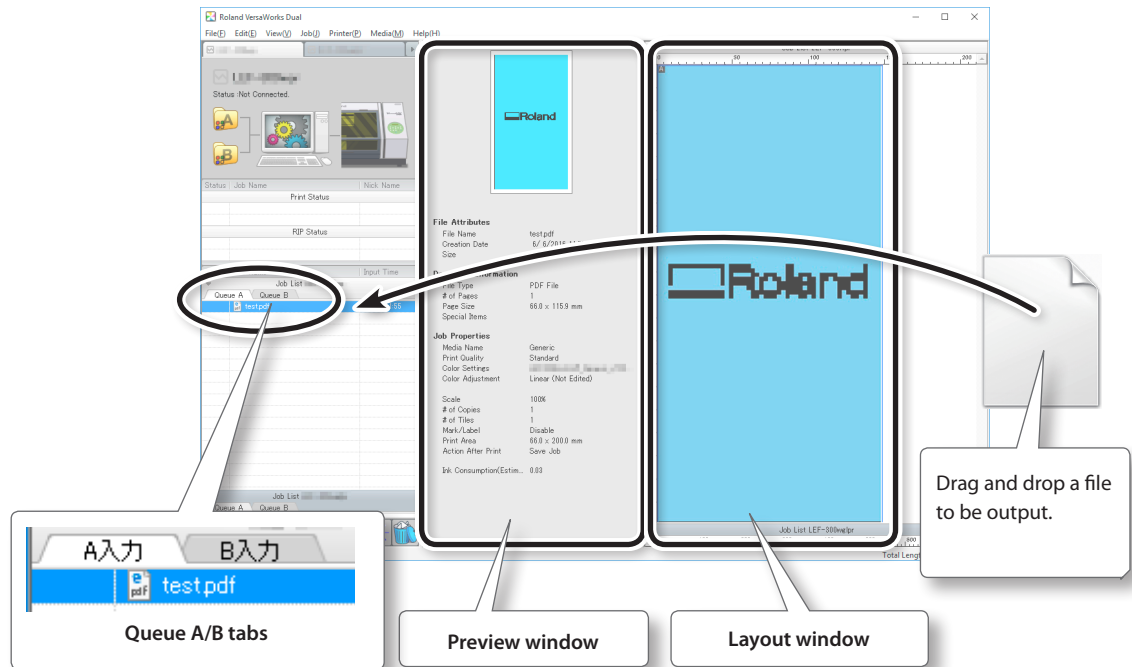
4. **Click [OK].**
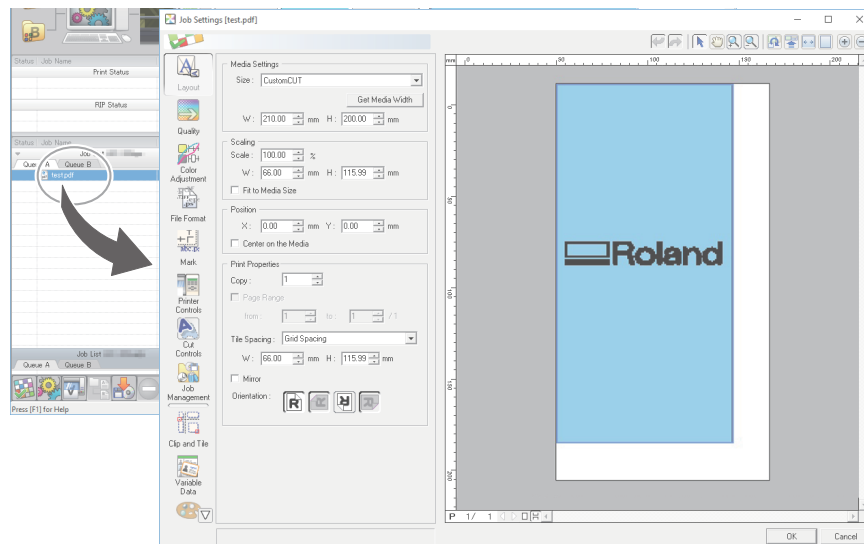
3. Output Print Data Using VersaWorks Dual

1. **Click the [Queue A] tab in the [Job List], and then drag the print data to the Queue A job list (to the Queue B job list when the print setting is done on Queue B).**

The contents of the data are displayed in the preview window, and the layout on the media is displayed in the layout window.
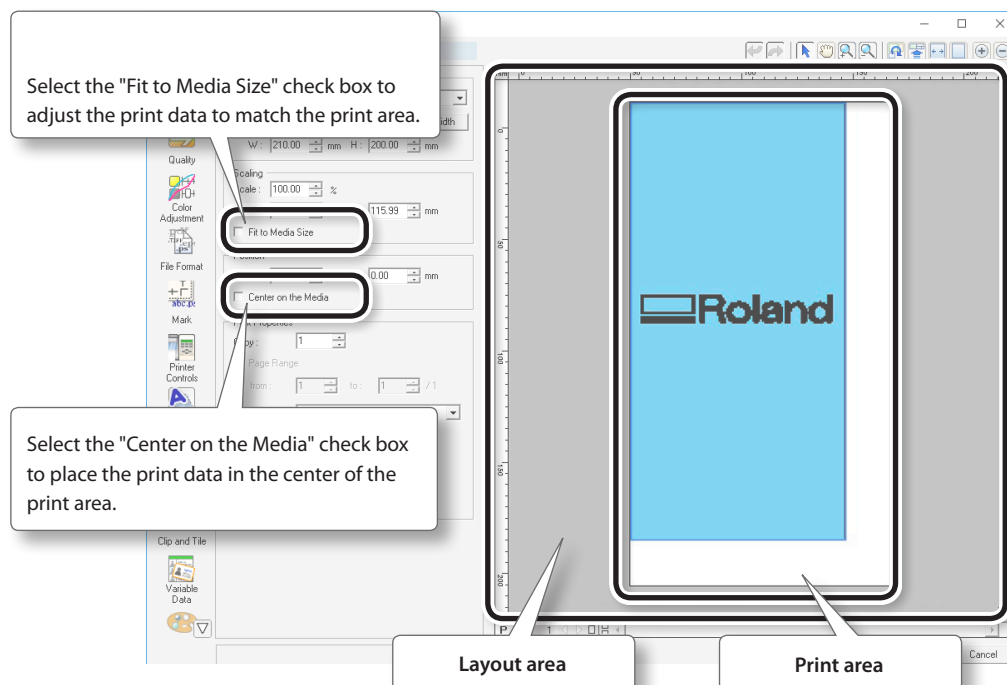

Drag and drop a file to be output.

Queue A/B tabs

Preview window

Layout window

2. **Double-click a print job in the job list.**

The "Job Settings" window appears.

3. **Use this screen to fit the print data in the print area and adjust the position of the print data.**

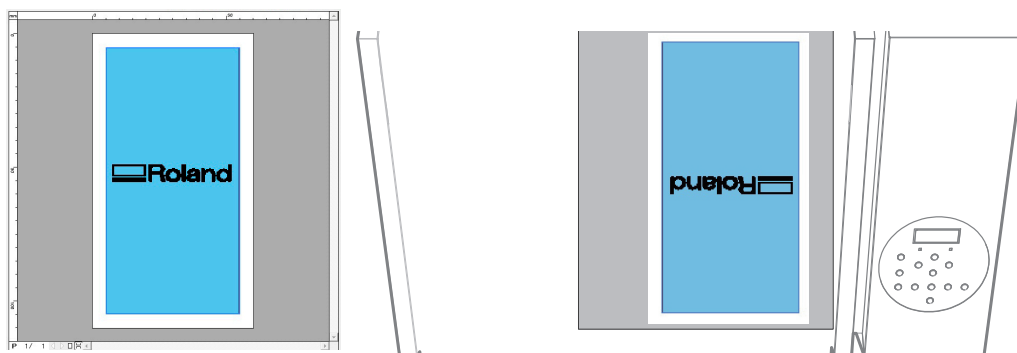The white part in the layout area is the print area that was loaded in step 1. Print data that is not in the print area will not be printed.

Select the "Fit to Media Size" check box to adjust the print data to match the print area.

Select the "Center on the Media" check box to place the print data in the center of the print area.

Layout area

Print area

* This is an example of the display when "Center on the Media" is selected.
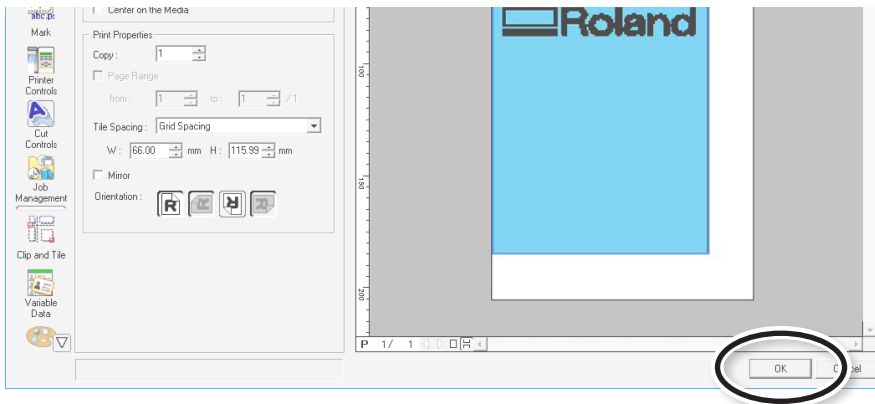
MEMO

The orientation in the VersaWorks Dual screen display is the opposite of the actual print orientation.
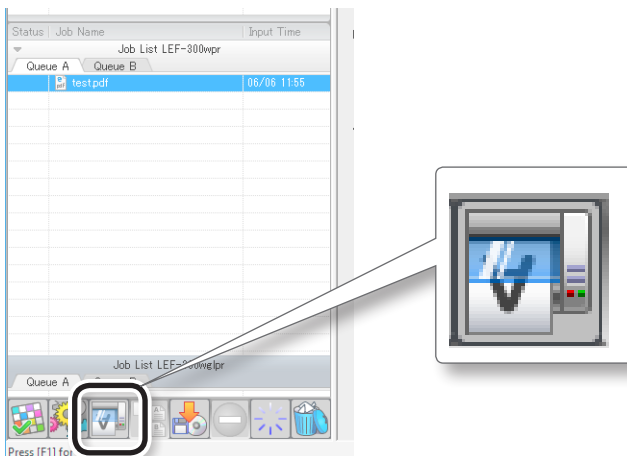
Make sure the media orientation is correct.

Orientation on the VersaWorks Dual screen

Actual print orientation

4. **After you have adjusted the printing position, click [OK].**

5. **Click** .

Printing will be started.

When the printing ends, the screen shown below appears on the display screen of the printer.

```
FINISHED PRINT
                        ↵
```

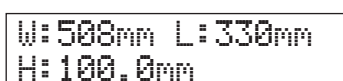Data from the computer is not accepted while this screen is displayed.

MEMO

If [PRT CONTINUE] is set to [ENABLE], the screen shown in the figure does not appear.

For more information, see "Continuously Outputting Print Data" (Master Guide).

6. **Press [ENTER].**

The screen shown below appears again.

```
W:508mm  L:330mm
H:100.0mm
```

Data from the computer can be accepted again.

Pausing or Canceling Printing

You can pause and cancel printing before it finishes. However, we do not recommend resuming printing because colors may be uneven in the place where output stopped.

Procedure

1. **Press [PAUSE] before printing finishes.**

The printing operation is paused.

The screen shown below appears.

```
TO CANCEL, HOLD
  DOWN SETUP KEY
```

2. **Press [PAUSE] again to resume printing.**

Printing resumes. To cancel printing, go the next step without pressing [PAUSE].

3. **Hold down [SETUP] to cancel printing.**

The printing operation is canceled.

4. **When printing is canceled, the computer stops sending data.**

STEP 5: Printing Tests and Normal Cleaning after Daily Operations

Make sure to check for dot drop-out by performing printing tests after daily operations. If dot drop-out is present, perform normal cleaning.

☞ "STEP 3: Printing Tests and Normal Cleaning" (P. 41)

If problems such as dot drop-out persist even after you have performed normal cleaning several times, perform medium or powerful cleaning.
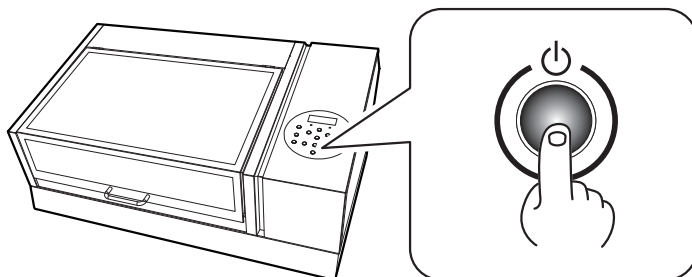
☞ "Periodic Cleaning Maintenance" (Master Guide)

NOTE

Frequently clean the inside of the machine using a vacuum cleaner or by wiping with a cloth moistened with water then wrung dry. If dust and dirt accumulate in the machine, they are likely to affix to printed materials.

☞ "About Care and Maintenance of the Inside of the Machine" (Master Guide)

STEP 6: Turning the Power Off

Hold down the sub power button for one second or longer.

The sub power turns off. Turn off the sub power after printing is complete.

NOTE

- Never switch off the main power. Leaving the main power on enables the automatic maintenance to be carried out periodically. If the automatic maintenance is not carried out, the printer may malfunction. For example, the print heads may be damaged.

- Never switch off the main power or unplug the power cord suddenly while operation is in progress. Doing so may damage the print heads. Be sure to first switch off the sub power. If the main power is accidentally switched off, immediately turn the main power and sub power back on.

For China

产品中有毒有害物质或元素的名称及含量

部件名称	有毒有害物质或元素					
	铅(Pb)	汞(Hg)	镉(Cd)	六价铬 (Cr(VI))	多溴联苯 (PBB)	多溴二苯醚 (PBDE)
印刷电路板	×	○	×	○	○	○
头部	×	○	○	○	○	○
壳体、底架	×	○	○	○	○	○
电源	×	○	×	○	○	○
其他（电缆、附件等）	×	○	○	○	○	○

○：表示该有毒有害物质在该部件所有均质材料中的含量均在 GB/T26572-2011 标准规定的限量要求以下。

×：表示该有毒有害物质至少在该部件的某一均质材料中的含量超出 GB/T26572-2011 标准规定的限量要求。

环保使用期限

此标志适用于在中国国内销售的电子信息产品，表示环保使用期限的年数。
所谓环保使用期限是指在自制造日起的规定期限内，产品中所含的有害物质
不致引起环境污染，不会对人身、财产造成严重的不良影响。
环保使用期限仅在遵照产品使用说明书，正确使用产品的条件下才有效。
不当的使用，将会导致有害物质泄漏的危险。

For EU countries

This product must be disposed of separately at your local waste recycling center. Do not dispose of in household waste bin.

Lever dit product in bij een lokaal afvalverzamelpunt. NIET met normaal huishoudelijk afval afvoeren.

Bitte führen Sie dieses Produkt separat Ihrer örtlichen Entsorgungsstelle zu. Bitte nicht mit dem normalen Hausmüll entsorgen.

Dette Produkt skal smides særskilt væk på den lokale affalds- og genbrugsstation. Må ikke smides ud sammen med almindeligt husholdningsaffald.

Ne jetez pas le produit avec vos ordures ménagères. Portez-le dans un centre recyclage des déchets.

Tätä tuotetta ei saa hävittää normaalien talousjätteiden mukana, vaan se on toimitettava ongelmajätteiden keräilypisteeseen hävitettäväksi.

Questo prodotto deve essere smaltito negli appositi contenitori per la raccolta differenziata, non buttare nel cestino dei rifiuti casalinghi.

Produkten måste kasseras separat på din lokala återvinningscentral. Släng inte produkten tillsammans med hushållssoporna.

Este producto debe devolverse al centro de reciclaje más cercano a su domicilio para su correcta eliminación. No lo tire a la basura.

Μην πετάξετε το αντικείμενο αυτό στο καλάθι των απορριμμάτων. Αφαιρέστε τις μπαταρίες και προσκομίστε το στο τοπικό κέντρο ανακύκλωσης.

Deite fora separadamente este produto no seu centro de reciclagem local. Não o deite fora no seu caixote do lixo.

Roland