

Operation Instructions & Maintenance Manual

Operation Instructions

1. Before powering on, confirm that there are no foreign objects on the platen to avoid scratching the printhead.
2. After powering on the machine, open the software:
 - RIN
 - PrintExp
 - Nodprinvision
3. After the machine completes homing successfully, perform one printhead cleaning using the PrintExp control software.
After cleaning, print a nozzle status test.
Only when there is no ink dropout may production begin.
4. Before placing the substrate, ensure the platen surface is clean and has sufficient tackiness.
After placement, ensure the substrate is completely flat with no edge lifting.
5. Measure the thickness of the substrate and manually input the corresponding value into the Z-axis Media Positioning field in PrintExp. Click Save, then exit.
6. According to the specific substrate, adjust the required amount of W pretreatment liquid (Ink Limitation Control in PrintExp print parameter settings).
 - Flat embroidery: 15
 - Chenille / towel embroidery: 30
7. Positioning & Printing Notes
 - (1) Embroidery Deformation Prevention
 - Loosen the bottom thread to reduce deformation.
 - Arrange panels naturally according to fabric grain.
 - Use 2 layers of backing fabric; recommended 1080 or 0.12 mm hot-melt adhesive.
 - Fix inner areas first, then outer areas.
 - Strengthen inspection during embroidery.
 - Avoid dyed edge binding threads.
 - Large graphics may be split into multiple templates.
 - (2) Photoshop Image Cutout
 - High contrast: Magic Wand Tool.

- Same-color background: Lasso + Levels.
- Use black for the first sample.
- Expand selection by several pixels.
- Remove shadows.

(3) Template Creation

- Ensure stable lighting and clear edges.
- Feature area must match printing area.
- Retain edge features, remove center features.
- Matching threshold: 0.3–0.5.
- Template, substrate and print heights must match.

(4) Printing

- Do not remove the backing before printing.
- Place substrate near the platen center.

8. Printhead Status Check

Power off machine, close software and computer.

The confirmed carriage is parked at the capping position and the printhead is sealed.

Maintenance & Care

1. Clean and lubricate guide rails and bearings every 3 months.

2. Keep the wiper blade clean. Replace every 6 months.

3. Keep the capping station clean and replace the ink pad regularly.

4. Clean dust from components monthly.

5. Printhead Moisturizing Maintenance

- Shutdown ≤ 10 days: Clean capping station. Add half purified water. Perform moisturizing.
- Shutdown 10–30 days:
 - Seal dampers, flush printhead. Inject moisturizing fluid. Seal ink tubes, then fill the cap with purified water. Perform moisturizing.
- Shutdown > 30 days:
 - Remove the printhead and store with moisturizing fluid. Clean ink tubes and fill with moisturizing fluid.