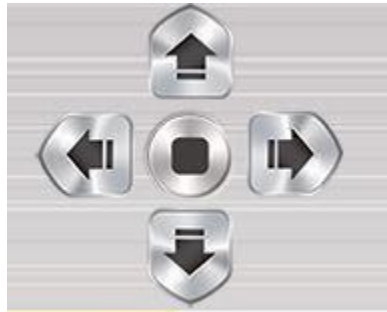


- **Safety**

- Always make sure that a print job is completed in the RIP software before putting any body part in the path of the carriage.
- The emergency stops either do not work at all or they only work conditionally
 - When detecting the media thickness the emergency stop button doesn't work (on ours at least).
 - If the printer needs to be stopped hit the power button.
 - Be careful to do this when it is at a slowed down part of its pass because when the rail shuts off the carriage keeps its momentum and will just slam into the stopper at full speed.
- The crash bars are haphazard.
 - They will stop the printer carriage if they hit something, but on more than one occasion I have had them stop the printer and then within thirty seconds had the printer start up again.
 - It is best when the crash bars hit to raise the carriage, cancel the process, and then immediately cancel the print.
 - Raise the carriage to prevent more head strikes.
 - Cancel the process so that it does not rise too far.
 - Cancel the print so that the UV lamps are not on and firing while the printer is higher above the material.
 - This can cause damage to the printheads.
 - Because of the larger tolerance between the material and the print carriage, material can sometimes hit the bottom of the carriage without striking the crash bars and stopping the machine.
 - Make sure to listen for repetitive knocking sounds as this is an indication of that happening.

• Movement

- The printer moves in the X, Y, and Z direction (forward and backwards, left, and right, and up and down)
- You can move the carriage around by holding the “Ctrl” button while using the directional keys to navigate.
- Sometimes this doesn’t work so you will either have to restart the printer and the computer, or use the directional tool located at the top of the software window. See below.



- - This tool moves the printer carriage automatically in the corresponding XY directions.
 - The left and right are a bit finicky, and you have to press the stop button in the middle for them to stop moving the carriage or it will just move all the way to the end of the rail.



○

Calibration		Motion		Voltage		Carriage Lifter		System Information	
Setting & State									
Printhead To Media Height(d):	1.8	mm	Maximum height:	310	mm				
Length from zero to platform(A)	308.5	mm	Z-axis speed:	9	mm/s				
Media thickness(T)	0.326	mm	Lifter motion factor:	4166.66	Pls/mm				
Height Detector Offset:	7	mm	Carriage height position:	-44730.1	mm				
External Encoder Factor:	28.3436	Pls/mm	<input type="checkbox"/> Use an external encoder			<input type="checkbox"/> Media Detector Down			
Detector X Offset	400	mm	<input checked="" type="checkbox"/> Reverse direction			<input type="checkbox"/> Lift Carriage before print			
Detector Y Offset	200	mm	<input type="checkbox"/> Reverse Negative Limit						
	Positive limit	Detector Move Out		Detect Media Thickness		Apply			
	Zero	Carriage Back To Zero		Move Carriage to specified height					
	Negative limit								

- When using the settings in this tab do not touch any of the settings on top

Setting & State

Printhead To Media Height(d):	1.8	mm	Maximum height:	310	mm
Length from zero to platform(A)	308.5	mm	Z-axis speed:	9	mm/s
Media thickness(T)	0.326	mm	Lifter motion factor:	4166.66	Pls/mm
Height Detector Offset:	7	mm	Carriage height position:	-44730.1	mm
External Encoder Factor:	28.3436	Pls/mm	<input type="checkbox"/> Use an external encoder	<input type="checkbox"/> Media Detector Down	
Detector X Offset	400	mm	<input checked="" type="checkbox"/> Reverse direction	<input type="checkbox"/> Lift Carriage before print	
Detector Y Offset	200	mm	<input type="checkbox"/> Reverse Negative Limit		

- To send the carriage to the topmost position press “Carriage Back to Zero”

Setting & State

Printhead To Media Height(d):	1.8	mm	Maximum height:	310	mm
Length from zero to platform(A)	308.5	mm	Z-axis speed:	9	mm/s
Media thickness(T)	0.326	mm	Lifter motion factor:	4166.66	Pls/mm
Height Detector Offset:	7	mm	Carriage height position:	-44730.1	mm
External Encoder Factor:	28.3436	Pls/mm	<input type="checkbox"/> Use an external encoder	<input type="checkbox"/> Media Detector Down	
Detector X Offset	400	mm	<input checked="" type="checkbox"/> Reverse direction	<input type="checkbox"/> Lift Carriage before print	
Detector Y Offset	200	mm	<input type="checkbox"/> Reverse Negative Limit		

- To move the carriage up manually click the arrow buttons

Setting & State

Printhead To Media Height(d):	1.8	mm	Maximum height:	310	mm
Length from zero to platform(A)	308.5	mm	Z-axis speed:	9	mm/s
Media thickness(T)	0.326	mm	Lifter motion factor:	4166.66	Pls/mm
Height Detector Offset:	7	mm	Carriage height position:	-44730.1	mm
External Encoder Factor:	28.3436	Pls/mm	<input type="checkbox"/> Use an external encoder	<input type="checkbox"/> Media Detector Down	
Detector X Offset	400	mm	<input checked="" type="checkbox"/> Reverse direction	<input type="checkbox"/> Lift Carriage before print	
Detector Y Offset	200	mm	<input type="checkbox"/> Reverse Negative Limit		

- I have yet to see the downward arrow work to move the carriage down, but I would not suggest doing such a thing anyway.
- To measure the material thickness, first move the carriage up higher than the material
 - This can be a significant amount
 - It is good practice to send it back to zero before measuring height to zero the carriage's position before printing and give you a chance to clean the printer before printing.

- Next make sure that the sensor pin is positioned squarely over the material you are measuring
 - The sensor pin is a round cylinder on the bottom of the print carriage.
 - The sensor pops out and pops back in when it detects material it is measuring.
- Click “Detect Media Thickness”

The screenshot shows a 'Setting & State' window with the following settings:

Printhead To Media Height(d):	1.8 mm	Maximum height:	310 mm
Length from zero to platform(A)	308.5 mm	Z-axis speed:	9 mm/s
Media thickness(T)	0.326 mm	Lifter motion factor:	4166.66 Pls/mm
Height Detector Offset:	7 mm	Carriage height position:	-44730.1 mm
External Encoder Factor:	28.3436 Pls/mm	<input type="checkbox"/> Use an external encoder	<input type="checkbox"/> Media Detector Down
Detector X Offset	400 mm	<input checked="" type="checkbox"/> Reverse direction	<input type="checkbox"/> Lift Carriage before print
Detector Y Offset	200 mm	<input type="checkbox"/> Reverse Negative Limit	

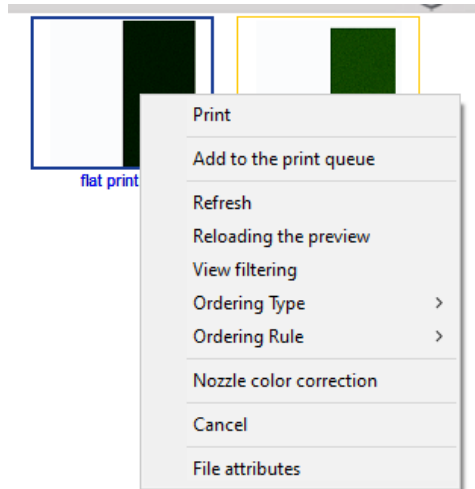
Below the settings table, there are several buttons and indicators:

- Up arrow button (green background, labeled 'Positive limit')
- Down arrow button (red background, labeled 'Negative limit')
- 'Zero' button (red background)
- 'Detector Move Out' button
- 'Detect Media Thickness' button (highlighted with a blue circle)
- 'Carriage Back To Zero' button
- 'Move Carriage to specified height' button
- 'Apply' button

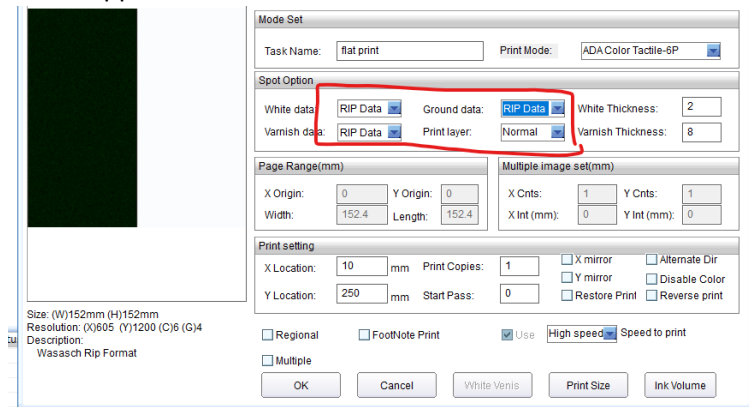
- This will begin the process of measuring the material
- ALWAYS be sure that there is nothing higher on the table than the material you are printing
- ALWAYS be sure that you position the print carriage over your material
 - When “Detect Media Thickness” is selected while the print carriage is over its home position then it will continue to lower past its limit and could be damaged.
- After measuring the thickness, position the printer carriage back over the drip tray.

• Sending for Print

- Files are sent to the control software directly from the RIP software and will appear in whatever folder you saved them in in the RIP
- Navigate to which file you saved it in on the lefthand tree
- Once you see your file in the right window, right click it and press “Print”



- This menu will appear



- Make sure that the highlighted settings are set like the image
- Next check the "Print Mode"

Print Mode: ADA Color Tactile Test-12

- Used for tactile

Print Mode: Default Bi-D-48P

- Used for flat prints

- Next Check the thicknesses of the varnish and white

White Thickness: 5

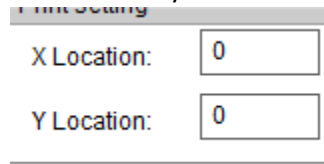
Varnish Thickness: 8

- For any raised Tactile

White Thickness: 3

Varnish Thickness: 0

- For any flat prints
- Next check the x and y location



The image shows a 'Print Settings' dialog box. It has a title bar that says 'Print Settings'. Inside, there are two labels: 'X Location:' and 'Y Location:'. Each label is followed by a text input field. Both input fields contain the number '0'. To the right of each input field is a small red vertical line. Below the input fields is a horizontal line.

- - They should be set to 0,0
- Once all these settings are checked and set then the print will be ready to send.
 - Be sure you have measured the height of the material before you send anything to print and have checked that there is nothing higher than the material on the bed
 - Before clicking print make sure to prime and clean the material of any dust before printing
- Click “OK” and your file will begin printing