

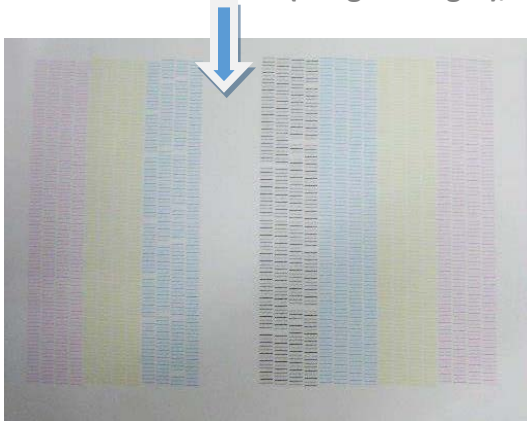
## Service Bulletin

### DX7 (Gold Print Head) Damper Seal

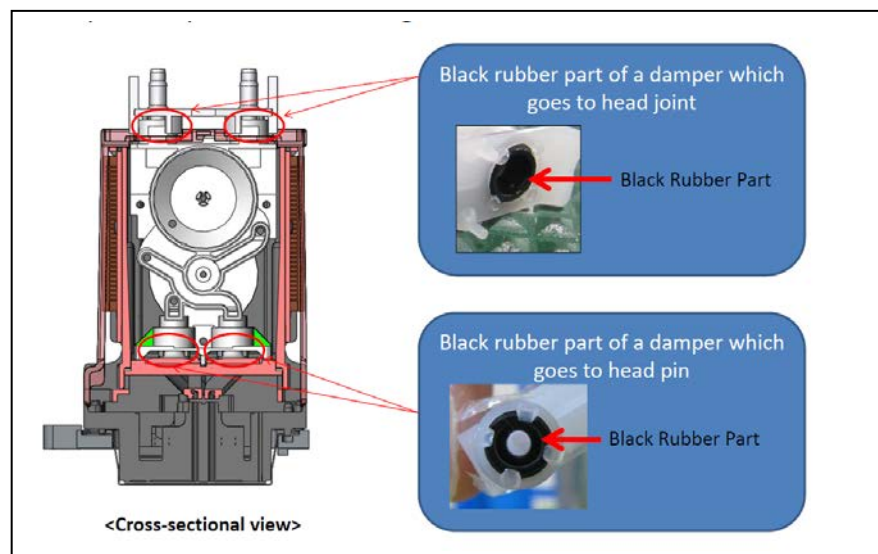
Roland Printers: XR-640, XF-640, VS & VSi Series, RF-640, RT-640 & RE-640

This service bulletin is designed to provide you with excellent hints on how to ensure a good damper seal in and around the gold print head. This serves as an important reminder of key connection points throughout the printers ink delivery system. Never assume this is a defective print head. Add this to your list of things to check before you ever consider replacing a print head.

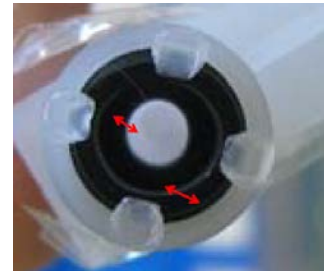
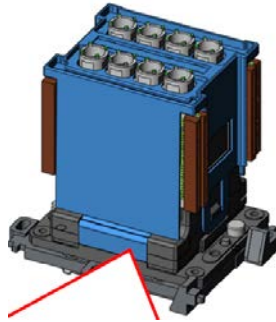
Example of a nozzle test print showing a poor damper seal. This could even happen after replacing a damper. Even after running several medium cleanings. We have seen cases where the cleaning did restore the test print (image on right), however cyan dropped out again after the service call.



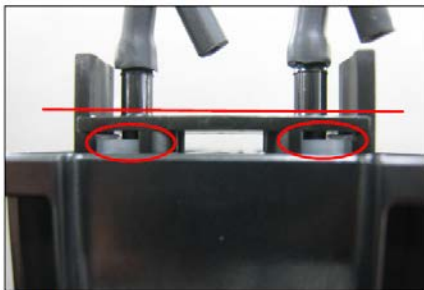
#### Important damper connections



Notice the position of the upper damper o-ring. The o-ring seal is difficult to inspect since the upper manifold adapter (called head joint) and head cover hides the connection.



The illustration below gives you a better view on the importance of a good connection. Apply cleaning fluid to the o-rings before you install the new damper. A dry o-ring could cause a poor connection to the head joint.



When you squeeze head joints into a damper



When you attach head joints to a damper after applying cleaning liquid to the black rubber part

Proper damper installation using cleaning fluid. Steps 1 – 3.



1) Moisten the cleaning stick with the cleaning liquid.



2) Apply cleaning liquid the black rubber part connected to the head joint

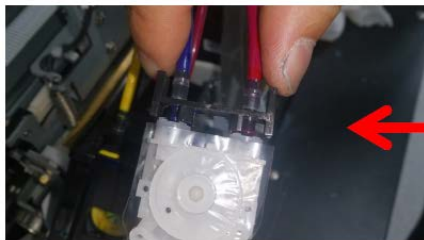


3) Apply cleaning liquid the black rubber part connected to the head pin

## Installing the damper steps 4 - 9



4) Insert and remove the damper from the head several times



5) Insert and remove the damper from the head joint several times



6) Attach the damper to the head joint firmly



7) Attach the damper to the head together with the head cover



NOT OK!!  
Damper is not attached to the  
Head Joint

8) Check that the damper is attached to the head joints correctly



9) Check that the height of all head joints are same

The final step 10: perform a cleaning test print to make sure all the nozzles are firing.