

TROUBLE SHOOTING REFERENCE GUIDE

Model	Information Disclosure	Date of issued	Date of update
UCJV330 UCJV300 series	Only for Distributors & Dealers	1/8/2025	
Title			Rev
UCJV330 UCJV300 series Glossy clear print guide			Ver1.0

1. Description of this procedure

Clear glossy printing may not print properly depending on printing conditions and environment.

-Clear is not fully cured.

-The surface of clear becomes cloudy white after a while after printing.

The following describes how to set printing conditions and how to deal with poor image quality when it occurs.

2. Recommended settings

1. Quality Setting

To obtain a better effect of clear ink, print clear ink with the following conditions.

UJV300 Glossy print			
Resolution	Pass	Print direction	Hi Speed print
600 × 1200 VD	32/44 pass	Bi-direction	Hi
1200 × 1200 VD	32/44 pass	Bi-direction	Hi

UJV330 Glossy print			
Resolution	Pass	Print direction	Hi Speed print
1200 × 1200 VD	16 pass	Bi-direction	Hi
1200 × 1800 VD	24 pass	Bi-direction	Hi

2. Clear Density

The recommended concentration of clear is 40% to 70%, and it is recommended that the lowest possible concentration be used.

If the density of clear is too high, the clear ink may not cure completely or the clear may cloud over some time after printing.

If the glossy clear surface is not smooth, test by increasing the density of the clear by 5%.

Special Color

Ink

Clear

Clear

50

%

Clear

50

%

Execution

Create

3. UV lamp Density

The light intensity of the UV lamp can be adjusted in the machine settings.

If there are problems with curing, it is recommended to change the setting to +50%

UCJV300 ; Local → Menu → Settings → UV AdjVal

UCJV330 ; Local → Menu → Media Settings → UV AdjVal

Menu	Setting	Detail
UV AdjVal	-50% to +50%	<p>The preset UV-LED lamp brightness can be altered. Check the performance (e.g. stickiness and odor) after printing.</p> <ul style="list-style-type: none">• Minus direction: Reduces hardness.• Plus direction: Increases hardness.

3. Troubleshooting

1. Clear ink uncured, sticky surface

The surface may be sticky or have fingerprints on it after printing is complete.

Countermeasure

-Reduce the density of clear ink as much as possible.

By reducing the density of the clear ink, the thickness of the clear ink can be reduced, resulting in less uncured ink in the layer.

-Increase UV lamp density

Increasing the illumination intensity of the UV lamp accelerates the curing of the ink.

-Use High pass (e.g. 32pass -> 44pass)

Increasing the PASS increases the number of UV irradiations and thus reduces the percentage of uncured ink.

Even with these measures, clear glossy prints will not cure completely.

They may require several days to fully cure, and it is recommended not to touch them during this period.

2. Clear surface becomes cloudy after a while after printing

Even after printing is complete, the ink inside the glossy clear is not fully cured.

When the internal uncured ink reacts with moisture in the air, crystals may form on the surface of the clear print, causing them to appear cloudy.

Countermeasure

-Reduce the density of clear ink as much as possible.

By reducing the density of the clear ink, the thickness of the clear ink can be reduced, resulting in less uncured ink in the layer.

-Increase UV lamp density

Increasing the illumination intensity of the UV lamp accelerates the curing of the ink.

-Reduce humidity in the environmental location (less than 40%)

Lowering the humidity inhibits the reaction of uncured ink with moisture in the air.

Crystals generated by the ink reacting with moisture in the air can be removed with alcohol.

Try wiping with a cloth moistened with IPA (more than 99%).

