



STX/Mutoh 628D Printer Guidelines

Best Environmental Conditions

No direct sunlight.

Dust free with minimal static.

Temperatures between 20 and 24 degrees Celsius/68-75F 24hrs a day 7 days a week Humidity <35% - 45%.

Daily Maintenance

1. Remove and rotate the 2 white ink cartridges to a flat position and shake them from side to side for 2 minutes each day. If using the 1L bags, also remove the bag from the high-capacity adaptor to massage while shaking to ensure complete agitation.

- If you have the external white circulation units, just start the circulation/filtration units.

2. Using a lint free cloth, remove any free ink from the end of the cartridges. Be sure to perform this operation BEFORE and AFTER your print workflow is started and completed each day.

End of the Day

At the end of the day wet cap your printer:

1. Fill the capping station with cleaning solution;
2. Park the head on the capping station;
3. Turn off the printer and wet cap overnight.

Before Printing

1. Remove and rotate the 2 white ink cartridges to a flat position and shake them from side to side for 2 minutes each day. If using the 1L bags, also remove the bag from the high-capacity adaptor to massage while shaking to ensure complete agitation.
 - If you have the external white circulation units, just start the circulation/filtration units.
2. Perform a nozzle check before printing and check nozzle quality, followed by a head cleaning if needed (Little Charge) and repeat the process until the nozzle pattern is drop-out free.

Best Practice Habits

1. Always print with the front cover in the down position.
2. Protect the printer from electrical disruptions and power outages with a 500VA UPS surge protector. Do not use inks that are expired.

Do not lift or touch the media when the printer is in operation! **WARNING**

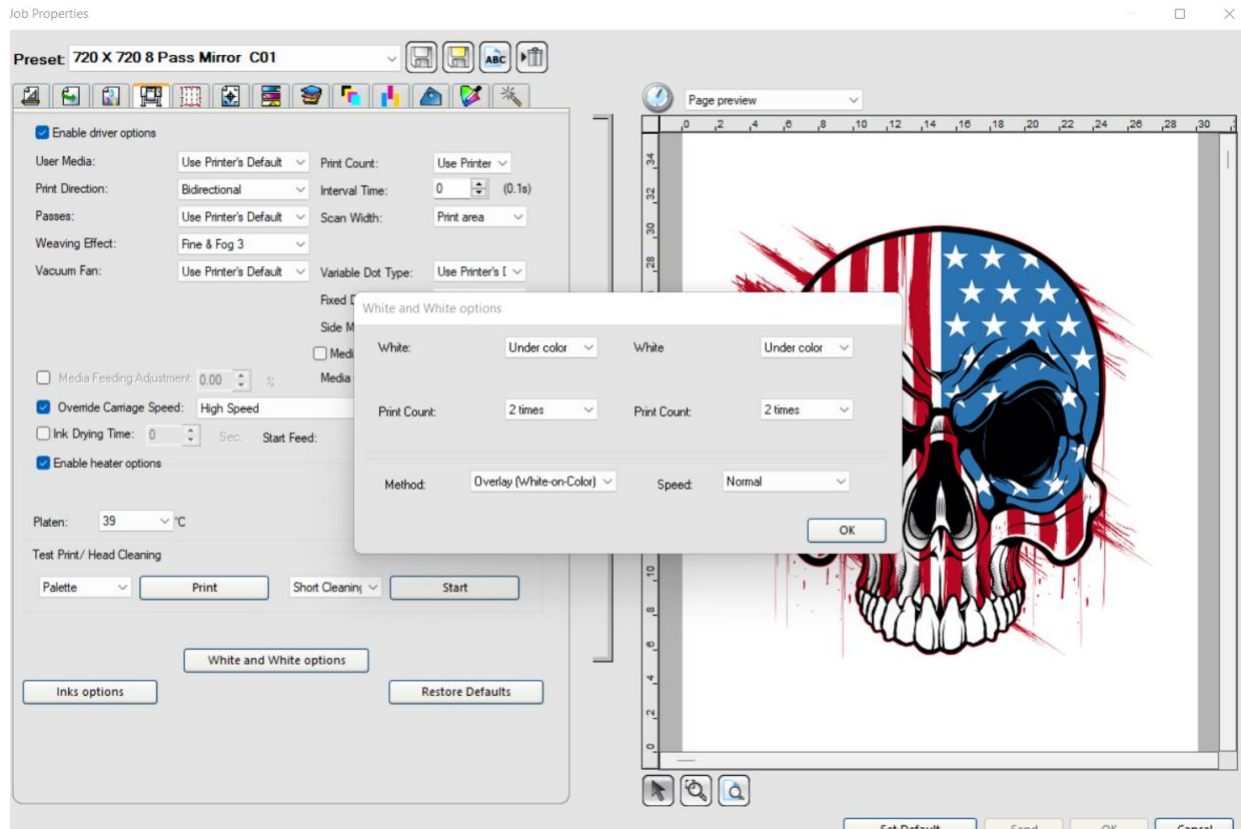
STS Inks will not warranty any head damage due to operator error – Please follow best practice guidelines at all times

What to do if the print head strikes the PET film

1. Immediately stop printing and start the head cleaning process from your MSM (Mutoh Status Monitor) Perform a nozzle check before printing and check nozzle quality, followed by head cleaning if needed and repeat the process until the nozzle pattern is drop-out free
2. If the Nozzle Pattern is still poor after performing 4 or 5 head cleanings; (1) fill the capping station with cleaning solution; (2) park the head on the capping station; (3) turn off the printer and wet cap overnight.

Note: This is a good practice to perform each day after finishing your workflow to ensure clean nozzles. The next day shake the white bags or cartridges as usual, then perform a nozzle check the following day. Also, never park the head directly on the PET film.

NOTE Sustained head cleanings can put too much pressure on the print head and may cause the print head to delaminate and fail prematurely. In the event the nozzle does not recover, print in high quality (720x1440) or 2x white as the Flexi setup shows below.



The PET Film used for DTF printing is covered with a layer of a specialized emulsion that sets the inks to a gel-like state when the ink lands on the film. Therefore, if the print head touches the PET film any ink that is on the surface of the print head, including across any nozzles, will be set to a gel-like state and can cause blocked nozzles and ultimately premature head failure

Do not lift the media or touch the media during printing operations **WARNING**

Maintenance Best Practices

- Clean wiper blade and the wiper drain path at end of production and every second day.
- Clean the capping station seal at end of production and every second day if inactive.
- Clean the print head guards and the black plastic rams at either end of the print head after production and every second day if inactive.
- Fill the capping station with cleaning solution after cleaning maintenance, and then cap the print head and turn off the printer.

Periodic Maintenance

Monthly

1. Lubricate the carriage guide rails and the bearings on the carriage.
2. Lightly clean the encoder strip with Isopropyl alcohol using a lint free cloth once every two or three weeks, and more often after heavy production.

Three Months

1. Lightly clean the feed and pressure rollers by wiping with a lint free cloth that has had isopropyl alcohol sprayed on it to remove any build up.
2. Using a dry toothbrush gently clean the feed rollers to remove any build up present.
3. To maintain the ink delivery system, every three to four months flush the printer using Long Store option in your MSM remote panel.
4. When not printing for long periods (more than 5 days); Flush all ink lines with STS Cleaning Solution using Long Store on your MSM dashboard and wet cap as usual.

Please do not open the printer cover for any reason as this will void your warranty!

STS Technical Support