

**MANUAL**  
**PG SERIES**

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Dear customers:

Please read this manual thoroughly before using Lyric PG series ink-jet printers.

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## Chap 1 Safety instructions

Please read the following directions thoroughly before you start to use this machine:

1. You should place the printer in a room what is,
  - ◆ clean and breezy with flat ground;
  - ◆ anti-electromagnetic, quakeproof and without heavy dirty;keep the ambient conditions always be at temperature: 20~25 °C and humidity: 40%~70%RH.
2. Connect the printer and PC to a reliable outlet well grounded, and a one-meter-long pontil planted in the salted soil is also suggested for ground connection.
3. Do not pull or plug the print cable between the printer and PC with power, and do wait 10 seconds before you need to turn on the power again.
4. Adoption of high quality solvent inks is necessary for the printer; If you need to change the ink of different brand please do contact with the local dealer.
5. When using the machine, pay attention to that,
  - ◆ Do not press the machine cover by hand or other heavy things;
  - ◆ Do remember to turn on / off by power switch;
  - ◆ Printing directly on the printer plate without PVC banner is prohibited!
6. If you encounter the following troubles, please cut off the power at once and contact with the local dealer,

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7. If you encounter the following troubles, please cut off the power at once and contact with the local dealer,

- ◆ Power switch is out of control or damaged;
- ◆ Cannot operate it normally or some obvious changes of machine preferences occur.

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## Chap 2 Installation and Troubleshooting

### 1. Packing box

(1.1) one host machine;

(1.2) one set of machine stand as follows,

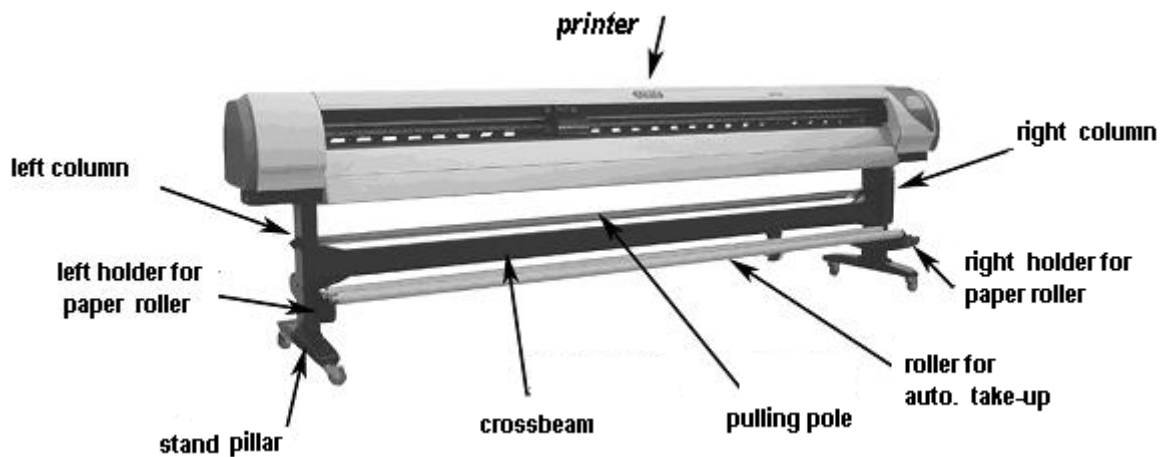
NO.	Items	QTY.
1	Left and right column	Per 1
2	Crossbeam	1
3	Roller for feeding	2
4	Roller for take up	2
5	Left and right holder for paper roller	Per 1
6	Stand pillar	2
7	Sub power switch	1
8	Pulling system	1
9	Tighten kits	1 bag
10	Left and right holder for pulling system and connection board	Per 1
11	Fixed peg for crossbeam	2
12	Ink Collection Plate	1
13	Connection board for column	4

(1.3) one set of accessories see as follows,

NO.	Items	QTY.
1	Power cable	2

2	Print cable	1
3	Cleaner cloth and nylon tube	1 bag & 2
4	Main and sub tank	per 1
5	User manual	1
6	Inner hexagon spanner (S=2)	1
7	Inner hexagon spanner (S=3)	1
8	Inner hexagon spanner (S=5)	1
9	Inner hexagon spanner (S=6)	1
10	“O” ring	8
11	RIP software	1
12	PCI card	1

## 2. Installation (referring to the fig.1)



### (2.1) Stand installation,

Referring to the above figure, install the stand in following steps,

- ① Draw out the plug and wire from the crossbeam first, through the right column then take them out from the side hole in it, now you can

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connect the crossbeam with left/right column by fixed peg kits;

- ② Connect the left/right pillars to the columns, and adjust the 4 wheels on pillar to be stable;
- ③ Connect the left/right holder for paper roller with the columns, then install the sub power switch to the right column.
- ④ Place the host machine on the stand and well tightened to be stable with tighten kits;

### (2.1) Installation of the PCI card and driver

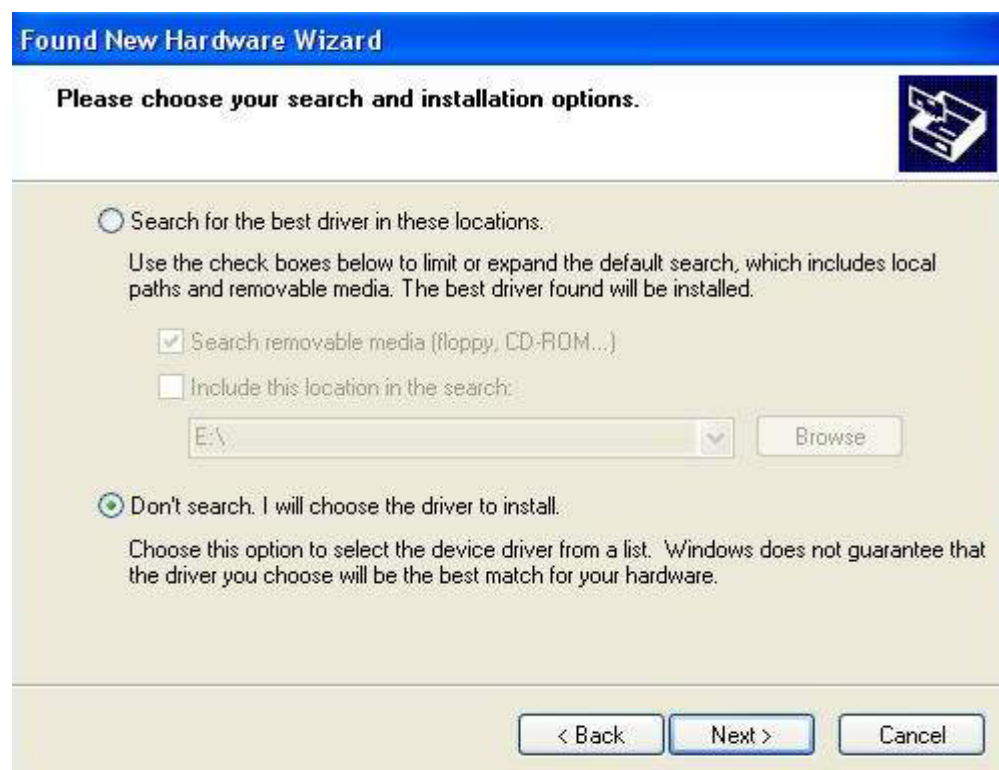
First, please make sure the computer is powered off, open the PC case and insert the PCI card into the PCI slot of the mainboard. If you are not familiar with this kind of operation, please let the professionals do it for you to avoid the hardware damage. If the manufacturer of your computer do not allow you open the PC case, please contact their service department and let them do it for you to avoid unexpectable troubles.

After successful installation of the PCI card, please connect the PCI card and the printer with the print cable which is in the accessories. Then turn on the power for computer, the operation system will find the new PCI card and require the corresponding driver, please install the driver as follows

(Windows XP as an example):



First is the ‘Found New Hardware Wizard’ , please put the accessory cd into the cd-rom and click ‘next’ ;

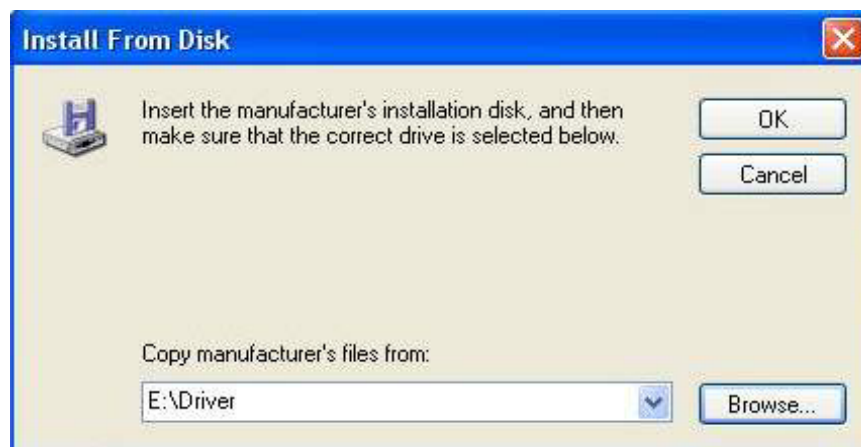


select ‘Don’t search. I will choose the driver to install’ , click ‘next’ ;

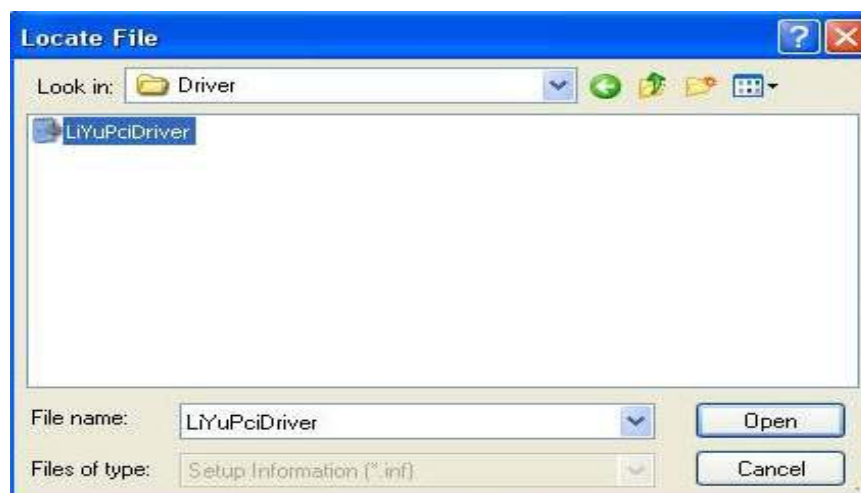




Click “Have Disk”, to show “Install From Disk” interface, Click “Browse” to Select LiYuPciDriver.inf document under driver directory in CD,



click ‘OK’,





select 'LYRIC JetPlot Card', then click 'next', the windows will start the installation automatically. After that, restart the computer, then the Installation is complete.

## (2.2) Electric installation

- ① Connect the 3-pin plug-in of the media motor and the 3-pin socket on the sub power switch.
- ② Connect the 4-pin plug-in of the media sensor and the 4-pin socket on the sub power switch.
- ③ Connect the out-put power socket on the sub power switch with the power socket on the right bottom of the printer by the accessory power cable. (or Find the accessory power cable, one end connect to the out-put power socket on the sub power switch, the other end connect to the power socket on the right bottom of the printer) Test whether the panel is heated or not by push the

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beside power switch and adjust the heat temperature by the temperature tuner.

④ Connect the plug-in of the vacuum cleaner into the power socket on the left side of the printer. Connect the power socket of the printer with the power supply socket by the accessory power cable.

⑤ Connect the PCI card with the printer by the accessory print cable. Connect the printer with the power supply by the accessory power cable; connect the sub power switch with the power supply by the accessory power cable.

### 3.Troubleshooting

(3.1) Lift up the pinch roller handle, load the banner from behind to front and keep the banner side aligned with the printer slot in the front plate, then put down the handle;

(3.2) If 110V power standard is adopted, do remember to switch the power voltage at 110V by knob in the power box on the downside of the host machine, the default voltage is 220V(see the knob panel).

(3.3) By the switch of the DC motor you can change the rotate direction of the paper roller;

(3.4) Paste the 2 Steel slices on the platen with glue in order to fix the two sides of the banner;

(3.5) Connect the power cable and the print cable then power on;

(3.6) Referring to Chap. 4 (***Operation Guide***), now you can test all

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the functions and be ready to work.

## Chap 3 Appearance and Components

Please referring to the following figures carefully,

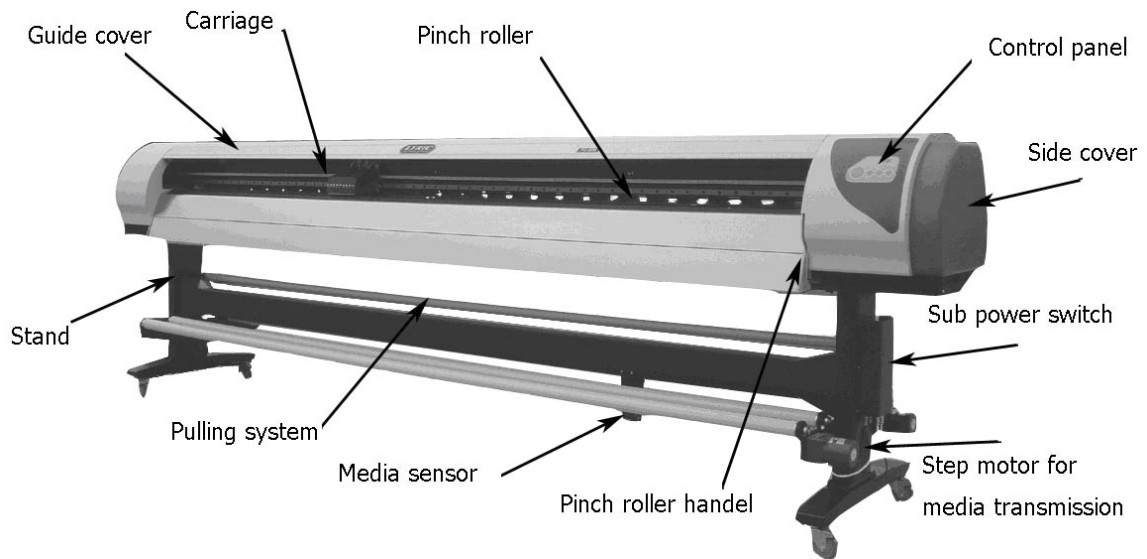


Fig. 3.1 outside view

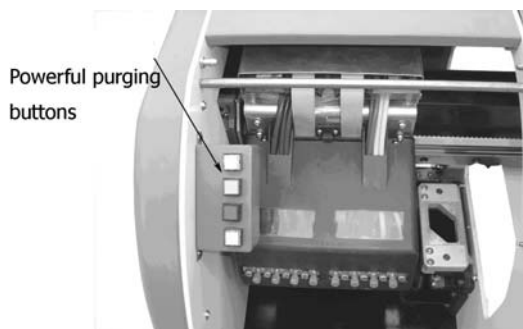


Fig. 3.2 left view

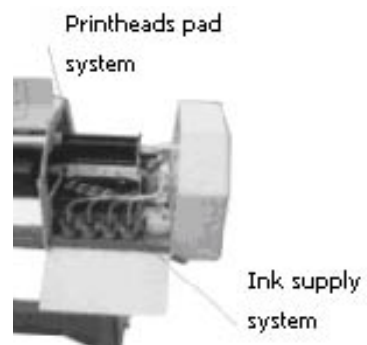


Fig. 3.3 right view

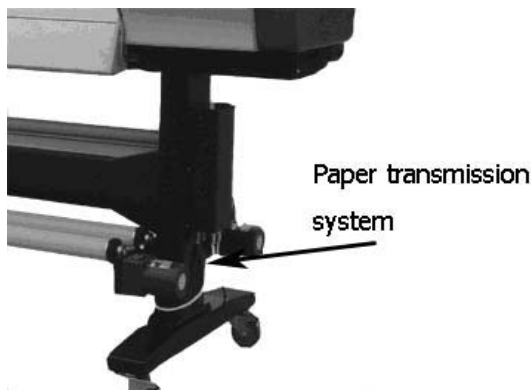


Fig. 3.4 right front view



Fig. 3.5 pulling system

1. guide cover: cover and protect carriage

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2. pinch roller: work together with metal roller to push the media and make it move smoothly
  3. head carriage: 8 Xaar piezo print heads inside
  4. control panel: setting functions and printing mode
  5. pinch roller handle: control the pinch roller to load the media
  6. machine stand: support the host machine
  7. auto. purging system: set particular time to have auto. purging operation; powerful purging on single printhead also can be set when any printhead is clogged
  8. unique cleaning system: can clean the printhead without pulling the ink tube
  9. head protection plate system: head protection pad will cover the printhead automatic when the printhead back to original location. There is a tube in the ink collection box under the head protection system. It will guide the waste ink out of the lower plate and need an extra box to contain the waste ink.
  10. ink supply system: consist of main tank, ink pump, ink filter, ink tube and sub tank, when the lack of ink in the sub tank is detected, ink pump will pump the ink from main tank to sub tank automatically.
  11. side cover: left side cover and right side cover; control board inside the right side cover; power switch, power socket and print interface under the right side cove.
  12. waste-ink collection box: contain the waste ink

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13. auto. feeding and take-up system: when media roll is adapted, media sensor will control the feeding operation; when printing long images, auto. take-up as long as printing
  14. pulling system: automatic split up the roll media to cooperate with media feeding system to make the more smoothly and accurate media transmission.
  15. heating system: shorten the dry time and increase the image quality.
  16. sub power switch: supply power for heating system and auto. feeding and take-up system

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## Chap 4 Operation Instructions

### 1. control panel

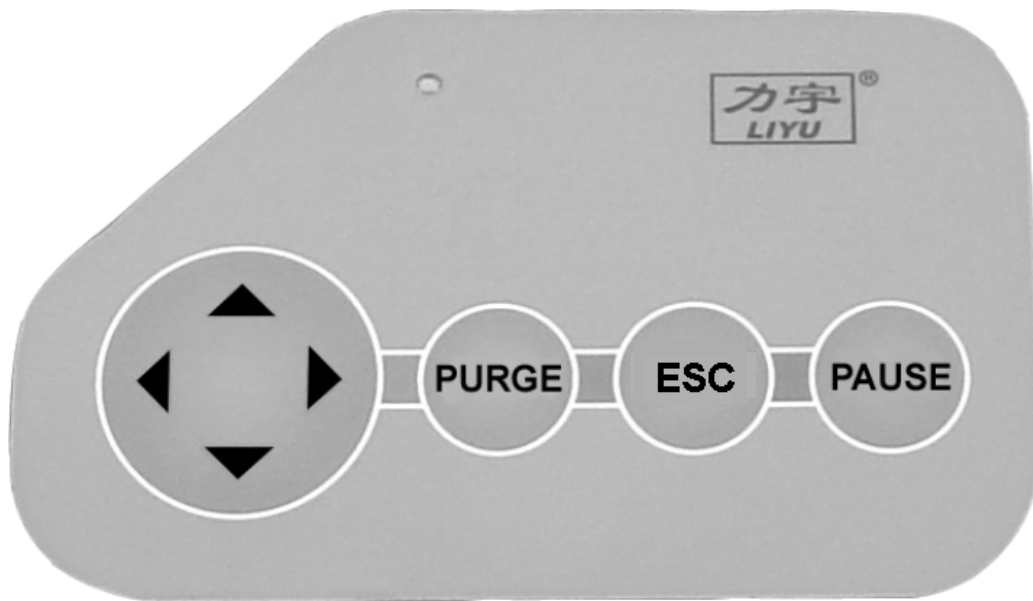


Fig 4.1 control panel

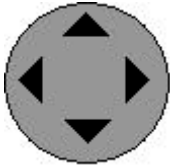
### 2. Keyboard description

(2.1) PURGE: the carriage will move to the left side and waiting for purging after this button is pressed, then you can use four powerful purging button to purge the print head. The four buttons correspond to print head of four colors, that is, white button correspond to black color print head, others are buttons correspond to the same color print head. Press the button, powerful purging will start on the correspond print head; release the button, it stops. When all the print heads are purged up, press ESC and the carriage will be back to the original location. If printing images before purging, then it will continue the printing work after purging.

(2.5) ESC: quit to the last menu under any menu.

(2.4) PAUSE: pause printing randomly as you need.

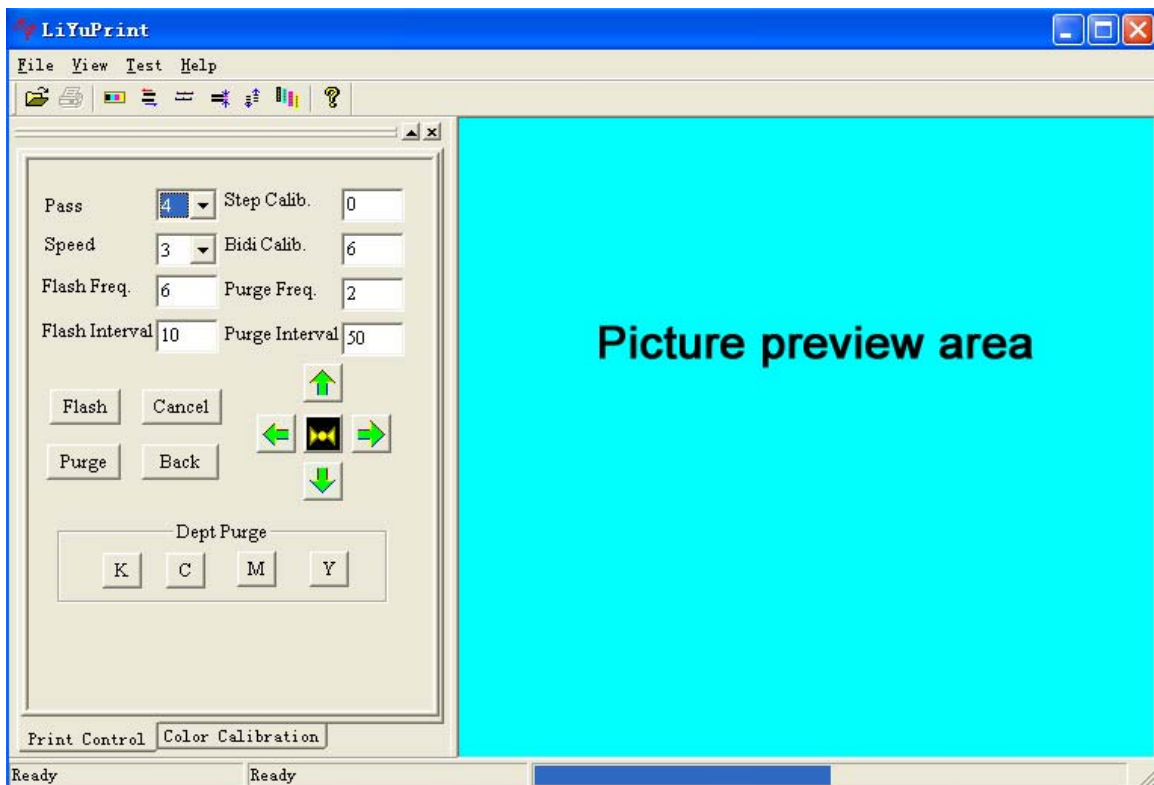




(2.9) : select the menu and move manually as you need; also you can set the value by left and right keys.

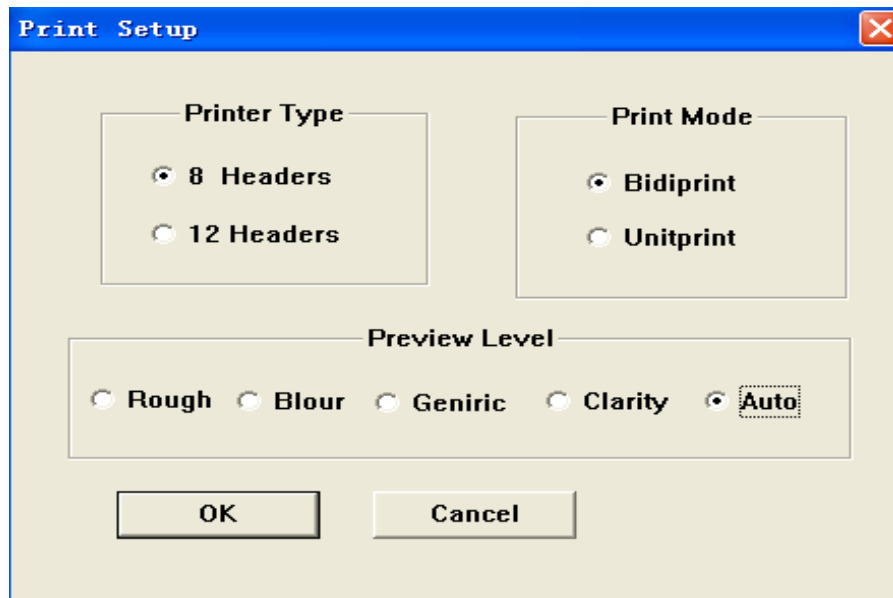
## 5.2 LiYuPrint Operation Guide

Double-click the icon of LiYuPrint on the desktop to launch the program, main interface as follows:



### 5.2.1 Setup Print

Please choose the right number of printhead that your printer has before printing by LiYuPrint software. You can set it up by system setting on the file menu.



**Note:** You must select right printer type. Otherwise the printer will not print picture correctly. Furthermore, you can select the bi-direction or the single direction of print mode and setup the solution of the preview on printing image in setup print.

### 5.2.2 Glossary of Print Control Interface


- **Pass:** Setup number of demand print pass.
- **Speed:** Select print speed. LiYu PG series printer offers seven levels of speeds. The bigger number you select, the more quickly of the printing.
- **Step Calibration:** Fill in number of step adjustment.
- **Bi-direction Calibration:** Fill in number of bi-direction adjustment.
- **Flash-jet Frequency:** Set the times of the print head jets every second.
- **Flash-jet Interval:** During printing, the printhead carriage will move to the right of the printer, flash-jet position, to flash-jet every certain times that printing back and forth. The number of times is flash interval. It can prevent nozzle clogging effectively if you setup flash interval

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appropriately.

- **Purge Frequency:** When purging automatically, after the carriage entering the left cover of the printer, purging area, the printer will start vacuum cleaner automatically that was joined on the printer. The carriage proceeds to purge several times back and forth above the inhalant. The times is named purge frequency.
- **Purge Interval:** Every certain times that printing back and forth, the carriage will be purged automatically, then continues after that. The number of times is purge interval. It can also prevent nozzle clogging effectively if you set purge interval appropriately.

### 5.2.3 Glossary of Key on Print Control Interface

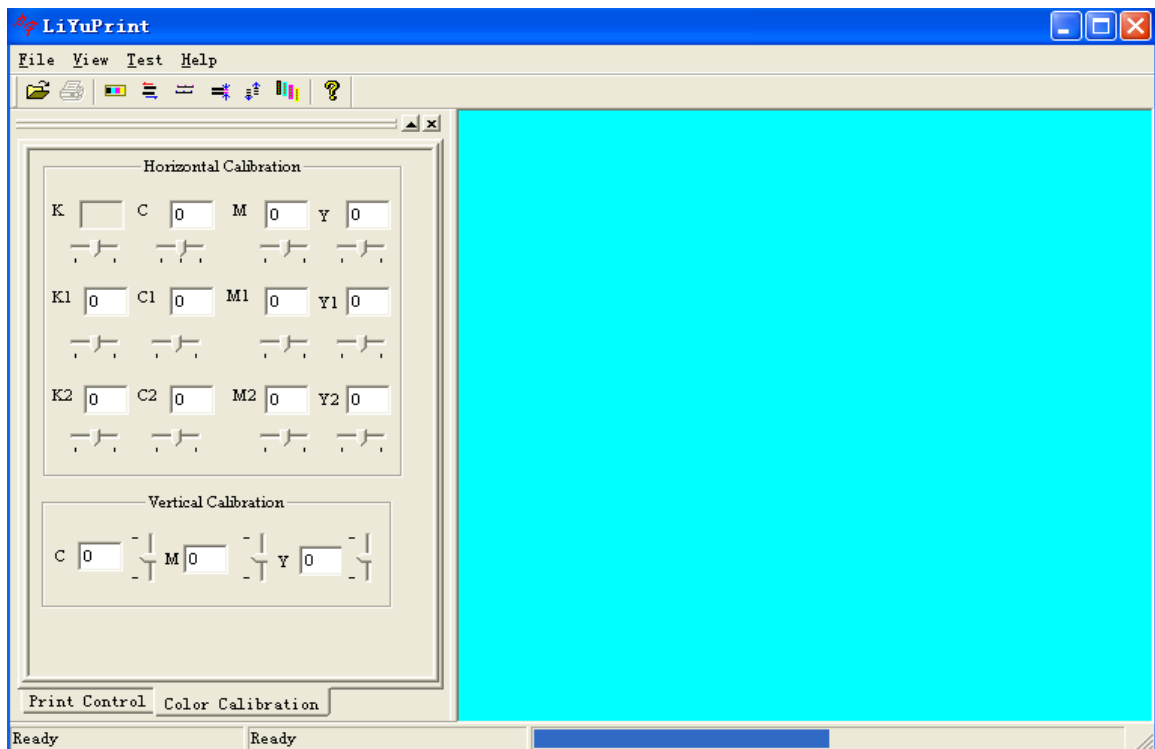
- **Direction Key:** The left and right keys control the carriage to move horizontally. The up and down keys control the step motor to roll over media.
- : Reset key, make the printer return to the original position or receive new data while printing.
- **Flash-jet:** The printhead make the flash-jet operation at the flash-jet position for anti-clogging when this button clicked. It will make a pause while printing, click “Back” key to continue.
- **Purge:** After clicking this button, the carriage will enter the left cover of the machine to purge the printheads automatically.
- **Cancel:** During printing, this key will stop operation of printing.
- **Back:** The printer will exit from flash-jet or manual purging operation

by clicking it.

- **Depth Purge:** There are four keys with different colors, when you press one of them, the carriage will move to purging area, purging the printheads with corresponding color (2~3printheads/color). At the same time, you can also click other keys to purge other printheads. Click “Back”, to keep the carriage back after that.

### 5.3 The interface of Printhead Calibration

You must run each test of “printing test” in menu item before you adjust the



- **Horizontal Calibration:** To run horizontal test of “printing test” in the menu item, the printer will print diagram of horizontal calibration test. The calibration value is number of the aligning place in each test diagram. And fill the value in corresponding item. (If you choose ‘8 Headers’ printer type in system settings, K2, C2, M2 and Y2 items will not appear.)



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- **Vertical Calibration:** It's same as horizontal calibration.

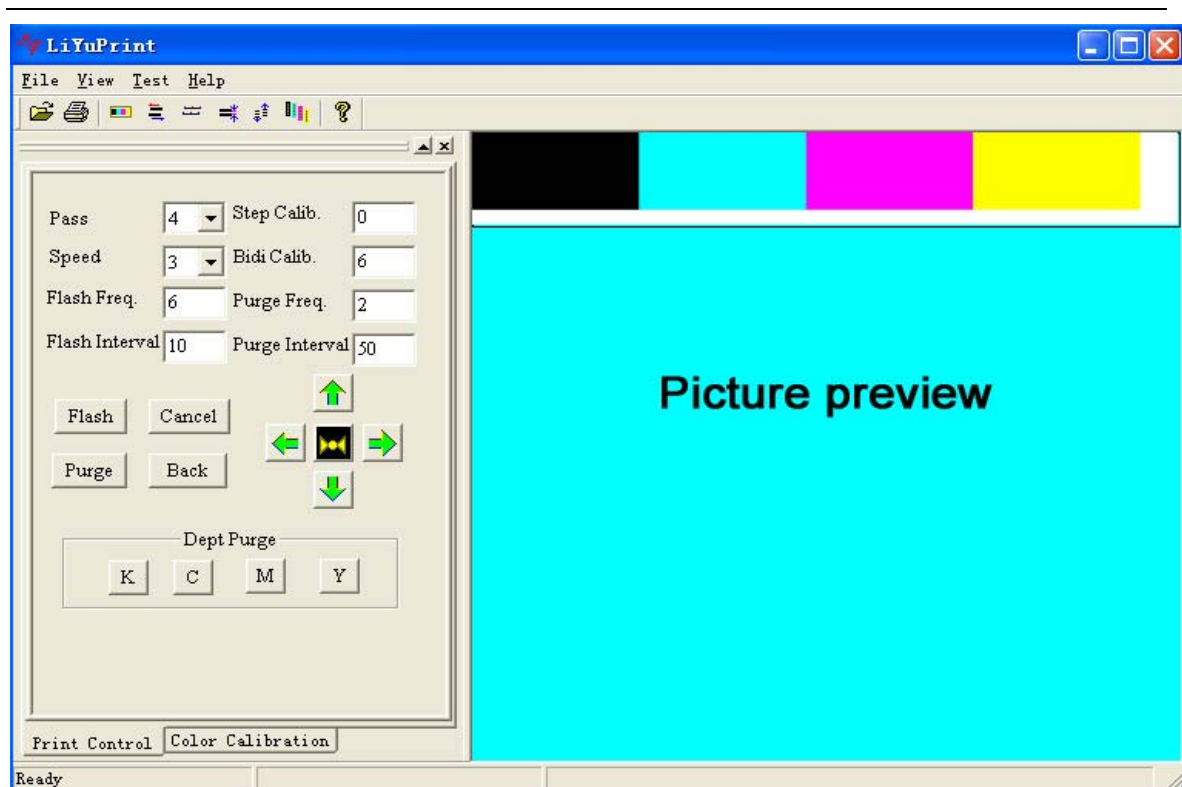
The “printing test” includes also bi-direction test, step test, nozzle status and test line. Among the rest, you can set the bi-direction test and step test as the same way as the horizontal calibration. And fill in the calibration value into the bi-direction test and step test items. Nozzle status tests if printhead is clogged. Once the printhead is clogged, it will be represented by the nozzle status testing image.

Test line is to test general status after calibration, such as horizontal, vertical, step and bi-direction calibration etc. If any one of them is not set properly, test lines will show it.

All these calibration data is saved in **Liyu.dat**. You can backup it for safety.

#### 5.4 Print images

Click file → open or  icon on the toolbar, then choose a \*.prt or \*.prn file to open. Then the preview of the file will appear in preview area on the right side of the main interface. If it's really the image you want, please click file → print or  icon on the toolbar, the printer starts to print.

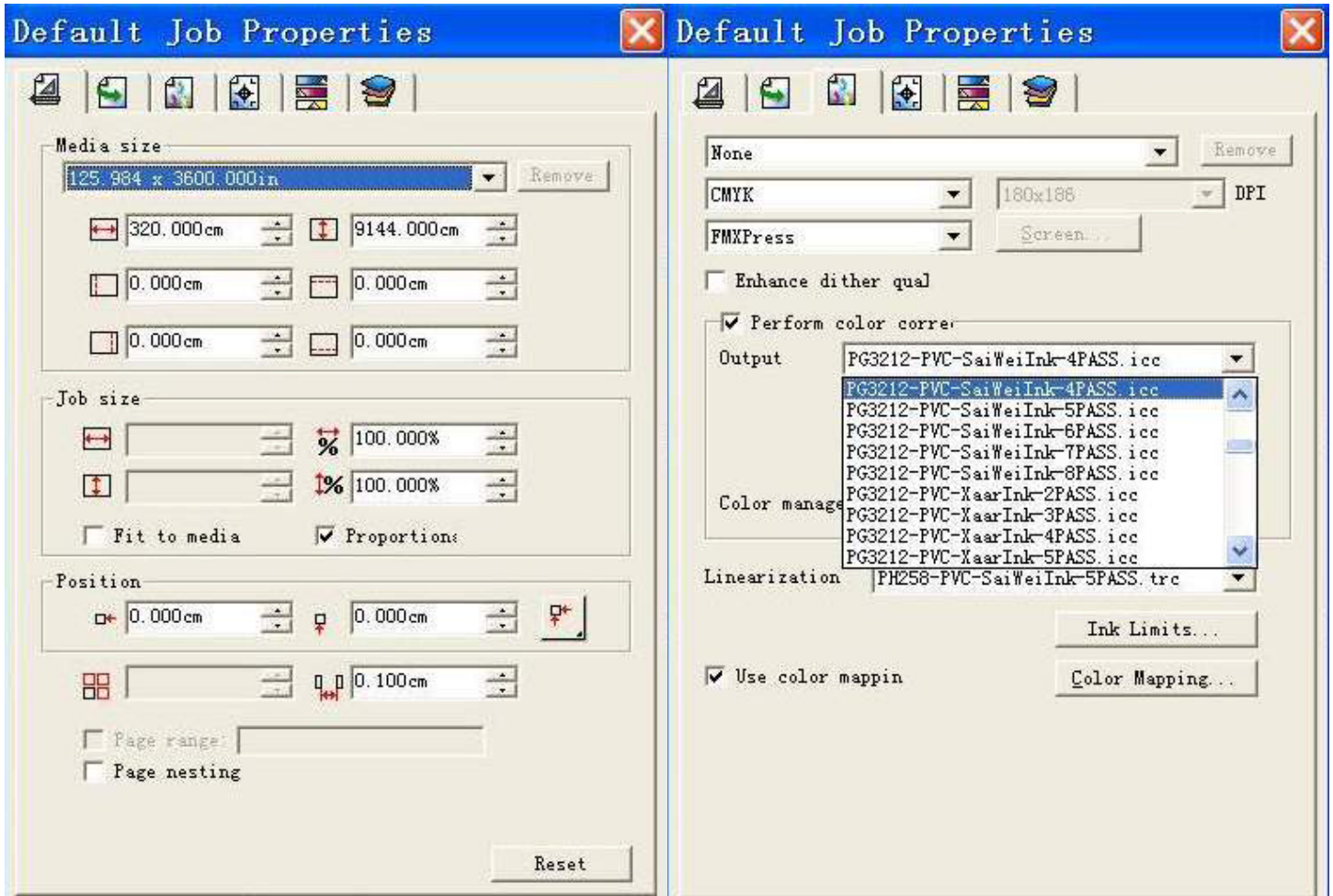


During printing, a broken line across the image preview area shows process of the printing, the part up the broken line is printed already, the below is the part ready to print.

### 5.5 PhotoPRINT Setup


PhotoPRINT is sent along with the printer which is the professional RIP software. The \*.prn and \*.prt files that LiYuPrint prints are all made by PhotoPRINT. In order to get optimal image for printing you need to add icc profiles of PG series printer to PhotoPrint. If you have the latest version PhotoPrint, you will find the PG series ICC profiles in the 'output' item which is in the third page of the 'Default Job Properties'(as Fig 4.7). If the ICC profiles do not appear, please add them as follows:

① Insert LiYuPrint CD sent along with the printer into your CD-ROM, copy 'Iccprofile', 'OutputDriver' and 'Density' three folders in the root directory of LiYuPrint CD to the folder in which PhotoPRINT installed, replace the folders existed. For example, your PhotoPRINT is installed in the



folder C:\Program files\PhotoPRINT, then you should copy 'Iccprofile', 'OutputDriver' and 'Density' three folders from LiYuPrint CD to C:\Program files\PhotoPRINT, replace the folders existed.

② Run PhtoPRINT, select icc profiles corresponding PG series printer in 'Default Job Properties' interface.

Select the third icon  in the 'Default Job Properties interface'. Select the icc profile according to the printer type, brand of ink and the number of

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PASS in the list on the right of the label 'Output'. For example, if your printer type is PG 3212, ink brand is SaiWei, and PASS number is 4, please select PG3212–PVC–SaiWeiInk-4PASS.icc in Output list.

In the same way select .trc file with same filename in Linearization list of the 'Default Job Properties' interface, viz. PG3212–PVC–SaiWei-4PASS.trc.

Please click "OK" to save and exit. Then, \*.prt document made by

PhotoPRINT will fit the PG series printer exactly. Then you can print perfect images by LiYuPrint.

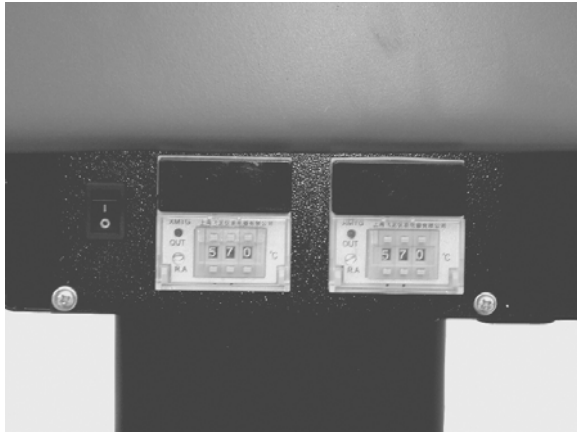
### 3. other functions

(3.1) ink supply warning

(3.2) auto. feeding and tak-up: can be shut down by the switch. When using this system, please balance the media rollers and make them in line. Please separate the sub power switch power supply from the power supply for computer and printer.

(3.3) Pre-heating and dry: electric heating parts are stuck under the front and back stainless plate. There is a temperature management system on the left side of the down plate to adjust the temperature. You can decide weather use pre-hearting and dry system based on the surrounding temperature and the media type.





**Fig 4.10**

Operation: the temperature changes one degree on each press of the temperature setting button. Please press this button repeatedly until get the temperature you want. The column tuner on the down-left is to adjust the movement range of the temperature, the default range is  $\pm 1^{\circ}\text{C}$ .

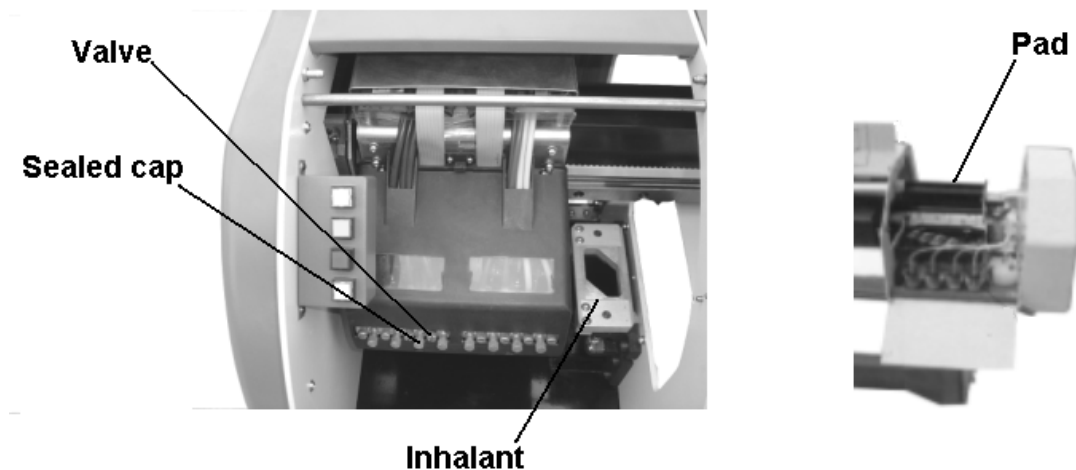
Note: Please pay attention to the connection column on the left side of the plate when disassembling the back plate. Please power off first, take apart the wires, then the plate.

## Chap 5 Technical Specifications

Model	PG1808/1812	PG2508/2512	PG3208/3212
Printhead	8/12 XJ-128/200dpi		
Print resolution	180X185dpi/180X370dpi		
Printhead clearance	3mm ~ 5mm off media		
Image size	1.83m/6.00ft.	2.50m/8.20ft.	3.20m/10.49ft.
Media size	1.88m/6.16ft.	2.55m/8.36ft.	3.25m/10.66ft.
Printing speed	PG1808/2508/3208:(36,24,18) m <sup>2</sup> /h (2p, 3p, 4p) PG1812/2512/3212:(50,33,25) m <sup>2</sup> /h (2p, 3p, 4p)		
Print mode	Uni/bi-direction		
Ink type	Solvent ink: C、M、Y、K		
Media type	Normal PVC banner, vinyl, coating film and ect.		
Media transmission	Roll to Roll		
Interface	PCI high speed card		
External dimensions	2.72X0.55X1.21m (8.92X1.80X3.97ft.)	4.39X0.55X1.21m (11.12X1.80X3.97ft.)	4.09X0.55X1.21m (13.42X1.80X3.97ft.)
Weight	235kg/518lbs	283kg/624lbs	334kg/736lbs
Power requirement	220V ± 10%, >10A, 50/60Hz		
Environment	Temperature: 20~28℃, Humidity: 40%~70%RH		
Other features	Auto. purging and cleaning system; Auto ink supply system; Auto. Feeding and take-up system; Heating system; Auto. pulling system		

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## Chap 6 Maintenance Items



### 1. Purging (see as Fig.6)

(1.1) During printing, if nozzle clogged happen, you should purge the head by pressing “**PURGE**” key, and the carriage will move to the purge zero at the left end of the machine.

(1.2) Press the four color button to purge the head, you can prolong the pumping time if head heavy clogged.

(1.3) After pumping finished, press “**ESC**” to continue the work.

(1.4) You also can cover the cleaner cloth soaked with flushing solution under the nozzle plate for several minutes to get rid of nozzle clogged.

(1.5) If heavy clogged and pumping invalid, you need head cleaning-up, now tighten the valve and cut off the ink flowing, then screw off the sealed cap, finally with one syringe full of flushing solution flush up the nozzle via the tie-in (inside the sealed cap).

(1.6) After purging finished, fasten all 4 sealed caps clockwise and loosen

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the valves (about 3~5 circles anti-clockwise) to return ink supplying.

(1.7) Repeat step (1.2), (1.3) and clean up the remained flushing solution in head till the solvent ink jet out, now return printing.

(1.8) If head very terrible clogged, you must stop printing and power off.

Take down the head along with bracket and soak the nozzle plate into the flush solution for several hours then re-install it.

(1.9) If above measures are all invalid, please contact with the local dealer at once.

## 2. Maintenance

(2.1) After power off, move the carriage to the left end then do purging followed as above step (1.5).

(2.2) Screw on 4 sealed caps but not tightened, and put the nozzle-pad plate into the right cover.

(2.3) Move the carriage to the right end just above the nozzle-pad and make them well sealed, thus good head protection can be realized.

**(Note:** Be take out the pad plate when printing in case of the picture quality affected.)

## 3. Please keep the guide clean

Please in time infuse the lube into the slipper nozzle to keep the guide smooth, the frequency decided by your working volume.

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## Chap 7 Guarantee Items

1. As for PH series inkjet printer purchased from our authorized dealer, we guarantee one year from the purchasing date verified by Guarantee Card.
2. In one year guarantee, the dealer will provide free of charge service for the troubles happened under normal using state.
3. The following is excluding of warranty,
  - Without valid Guarantee Card.
  - Damaged by unwarrantable operation or abnormal using.
  - Damaged by taking apart the printer not allowed.
  - Because of FORCE MAJEURE or natural damage.
  - Consumptive parts have no warranty such as print head, pinch roller, ink filter and so on.
4. The dealer should undertake the charged service out of guarantee time.
5. The manufacturer just bear the obligation based on machine itself, excluding any other loss induced from troubled machine.

### Appendix

1. PC requirement:
  - (1.1) CPU: at least PIII 1G;
  - (1.2) RAM: >256MB;
  - (1.3) Hard disk: >40GB, and C disk partition at least 8GB~10GB;
  - (1.4) Main board: credible brand suggested;
2. Location conditions and necessary tools:

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- (2.1) one 1000W dry and wet cleaner;
  - (2.2) two 50ml glass syringe;
  - (2.3) several cleaner cloth with good quality;
  - (2.3) In the workroom, you'd better install one big-power exhaust fan, and one psychro-meter, one humidifier also necessary in dry area.

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外观无明显划痕及硬伤，无锈蚀，镀锌件表面光整，无暗斑，涂漆(喷塑)件表面饱满，无结渣，无脱漆。

Machine's appearance does not have any obvious scratch, hard wound and corrosion, Zinc-plated pieces does not have dark spot

Painting surface should be plump, without dregs and not taken of paint.

未经技术部门同意，不允许增装垫圈，调整垫片。

Without Technology Department's consent , do not allow to increase washer or adjust spacer. 各连接处螺钉紧固，安装正确、可靠。

Every screw be fastened, correct and reliable to install.

墨管联结正确可靠一一对应，且表层无硬伤，防止渗出墨水漏出墨水。

Ink-tube connection should be correct one-to-one correspondently, should not have hard wound in its surface in order to preventing ink leak.

墨车活动自如，导轮与导轨面紧密接触均匀一致。

Carriage can move freely, guide roller and guide pulley should keep in touch closely with each other

线路部分连接可靠正确，布线整齐规范，防止机械装配时压伤损坏电线。

Connection of Circuit Part is reliable and correct, Circuit overall arrangement should be trim and orderly in order to prevent electric wire from damaging while machinery assembling.

打印头底板与机体上平面间隙两端为 $3.5+0.5\text{mm}$ ，中间较两端大 $0.4\text{mm}$ (PM32)， $0.2\text{mm}$ (PM25)， $0$ (PM18)；打印头底板与机体上平面平行，平行度 $\leq 0.2\text{mm}$ 。

Interval between Carriage Baseplate and Machine Body in both ends is  $3.5+0.5\text{mm}$  , Middle Interval:  $0.4\text{mm}$  (PM32),  $0.2\text{mm}$ (PM25), $0$ (PM18);

Carriage Baseplate is parallel to the level of Machine Body, parallel degree  $\leq 0.2\text{mm}$

同步带松紧适度符合要求。

Elasticity of Cylincal Synchromesh Bell should fulfil requirements

墨垫位置位于打印头底板方孔中心，墨垫盒上下自如。

Nozzle Pad lie in the center of Carriage Baseplate's square hole ,Head plate can move up and down freely.

吸头板上下活动灵活，与打印头底板间隙符合要求，不倾斜。

Vacuum Board is flexible to up and down ,fulfilling requirements with Carriage baseplate interval ,not slope.

拾轮手柄动作正常，压轮抬起时与滚筒间隙大于 $2.5\text{mm}$ ，压下时拾辊凸轮处于自由状态。

Pinch roller handle can be moved normally, Pinch roller should keep a space more than  $2.5\text{mm}$  with Wheel when lifted up, uplift-roller can move freely when lifted down.

检查完毕，对合格机器卸下打印头底板，在流程卡上签字；对不合格机器挂上返修单，通知相关工序返修。

For the qualified machine, it should unload Carriage baseplate and sign on Procedure Card; For unqualified ones, it should hang up with "REPROCESSING CARD" and inform relevant person to reprocess after finish checking.

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## 8

将手柄臂销和复位顶杆销安装在右端板上。

**Install Pinch roller handle at right-end plate.**

将连杆，复位顶杆和手柄臂组合连接起来，用开口挡圈固定。

**Connect its three pieces and use Block Ring to fix.**

**Connect**

将手柄安装在手柄臂组合上

**Install the handle on Arm-Peg Assembly.**

**Requirements: Pinch roller should keep a space more than 2.5mm with Wheel when lifted up, uplift-roller can move freely when lifted down.**

要求：连接坚固可靠，拾轮系统活动灵活，无阻碍，压轮抬起时与滚筒面间隙>2.5mm，压下时凸轮处于自由状态

## 10

在小车板、PCI卡、I/O板、伺服电机和步进电机驱动器上贴保修凭证，并签上当日日期。在固定位置安装伺服驱动板、I/O板、小车板和步进电机驱动器。

**Get Guarantee Card on Carriage board, PCI Card, I/O board, Servo motor and Driver for Step motor respectively and sign Date on Guarantee Card.**

**Carriage board, PCI Card, I/O board, Servo motor and Driver for Step motor install on regular position.**

用相应线束及导线将开关电源、I/O板、伺服驱动板、步进电机驱动器及步进电机连接起来扎线(捆线时注意分开交直流电源线，以及传感器信号线)。

要求：各连线正确可靠，接地线接地

**Connect Power switch, I/O board, Drive board for Servo motor, Driver for Step motor and Step motor with corresponding thread bunch and wire.**

**Bind wire (pay attention to separating AC POWER LINE, DC POWER LINE and Sensor Signal Line).**

**Require: Every line is connected reliably and correctly, well grounded also required.**

## 11

插好小车板上的柔性导带以及右顶盖的按键面膜排线。

**Insert Data Cable on Carriage board and Cables on Control Panel.**

要求：排线、电源线的接插紧固到位。

**Require: Cables and Power line connect fastenly and in correct place.**

**检查电控系统装配接线是否正确可靠。**

**Check if assembling wire in Electric Controlled System can work correctly**

通电检查驱动器、按键功能是否正常；各电压输出是否达到设计要求；主辊和小车的运动方向是否正确；自动抽吸功能是否正常。

**Checked whether Driver, Button function are normal; Each output of voltage reaches the designing requirement; Whether movement direction of Main Roller and Carriage are correct; Whether Auto-purging function can work normally.**



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短接小车板上的墨泵传感器，检测墨泵、蜂鸣器是否正常工作。

Connect pump sensor on Carriage board in short circuit, check if Pump and Buzzer can work normally. 进行8小时老化机器。

要求：I/O板的传感器插头做好标识，左限位（L）、右限位（R）、原点（O）、抽吸（P）、吸尘器（C）。蜂鸣器在墨泵泵墨约一分钟后正常报警。

Mature machine for 8 hours

Require: Get I/O board sensor plug with identification or mark: left limit sensor(L), right limit sensor(R), origin (O), Purge (P), Vacuum(C)

Buzzer would give an alarm after ink-supplying about 1 minute.

## 12

将前后面板接线座安装在机体上，前后面板表面不得有划伤及凹痕。Install Front and Back panel's Electrical Outlet on Machine Body

Note: the surface of Front and Back panel must not have scuff mark or dint.

通电检查升温，达到热平衡时，温度应较环境温度高35℃~40℃，检查完后将温控仪设定温度调到50℃。

When power on, check temperature heating-up, the temperature should be 35-40 degrees Centigrade higher than environmental temperature while reaching thermal balance, transfer Temperature Controller to be 50 degrees Centigrade after finishing checking

## 13

### 14.

装配所有覆盖件，粘贴铭牌、外饰件。

要求：1>外观表面清洁，无损伤、划痕、凹陷等损伤、以及影响整体外观的缺陷；所有金属件不得有锈蚀和保护层损伤。

2>紧固件的联结到位、牢固。

清洗外观表面。

左右各面板主墨罐盒盖，左右罩壳不允许因零件不合格或变形造成翘曲、不合缝等缺陷。

机罩、导轨罩接缝处等高，允差2.5mm，允许通过局部校正达到要求。

Assemble all coverings, paste name plate, other gadget.

Require: 1>The machine appearance should be clean, no damaging, scratch or dint etc., All metal piece must not have corrosion and antiabrasion layer damage.

2>The connection of tighten kits is putting in place firmly and clean its surface.

Main tank Cap and Right & Left Cover should not allow to be warp and mismatch due to accessory's disfection

The gap between machine cover and guide cover permit a difference 2.5mm, it can be adjusted in correct place in partly.

### 15.

按《电脑喷绘机出厂检验规程》检验

Inspect according to "Leaving Factory Inspection Regulations For Ink-jet printer"

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16.

检验合格的产品挂上产品合格证。

Qualified Machines are hung up with "Q.C."

将整机及配件用塑料膜包装，并固定在木箱底板上。

Enwrap Machine Body and accessory with plastic membrane, and fix them on wooden case baseplate.

将包装箱各块板间用M10螺栓连接，并用螺母固定。

Fix wooden case with M10 bolt and fasten with the nut

在包装箱上标明产品型号、出厂编号等标志。

Indicate Machine Model, Serial number., etc signs on the packing box.

要求：附件按照装箱清单所列打包，无错装漏装，整机及配件包装前擦去表面灰尘及污垢，在箱内固定可靠，配件间无碰撞，包装箱各块板间螺栓连接紧固可靠。

Require: Accessory packing should according to LIST, machine and accessory should wipe out surface dust and dirt before packing and fix in the wooden case affirmly for preventing collide among the accessory.

Every board of packing box should joint fastently