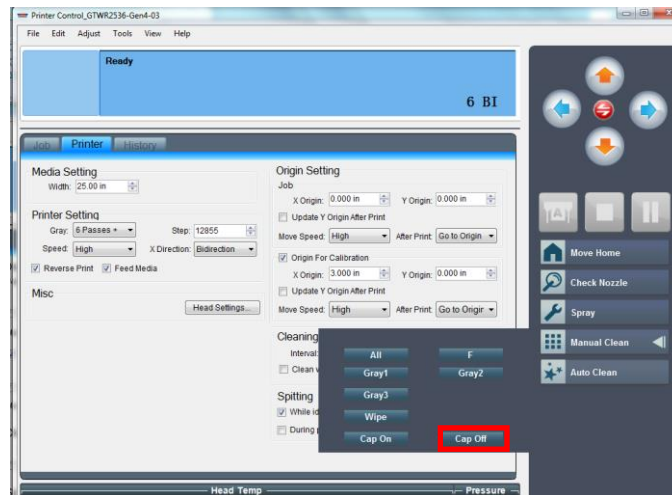


## Printhead Purging Procedure

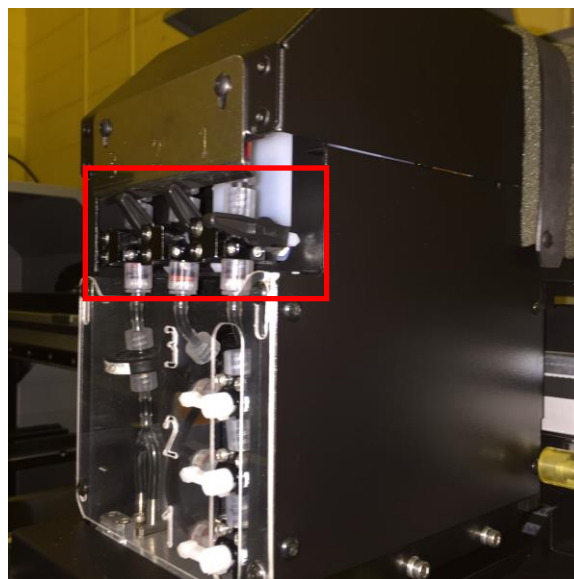
### Procedure:

1. Open up PCS software and uncap printed head through 'Cap Off' button in the Manual Clean tab on the vertical menu.

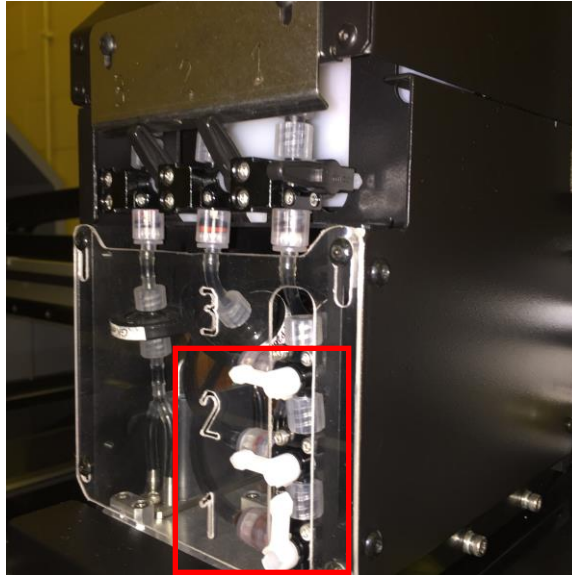
*Note: Skip this step if printhead is already uncapped.*



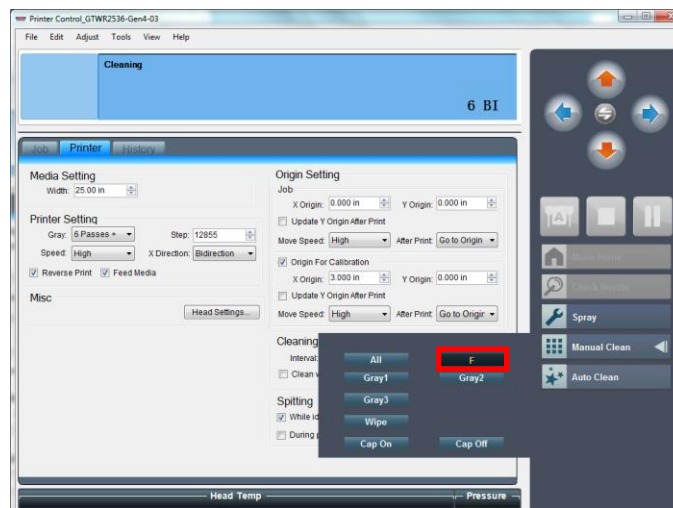
2. Once printhead is uncapped and in 'Ready' mode; the top valve levers for printhead 2 & 3 should be turned up to the off position then place printhead 1s' top valve lever in the mid-way position. See photo for details.



3. Lower valve levers 2 & 3 stay in the same position (lever pointing left), and the lower valve lever 1 should point directly up.

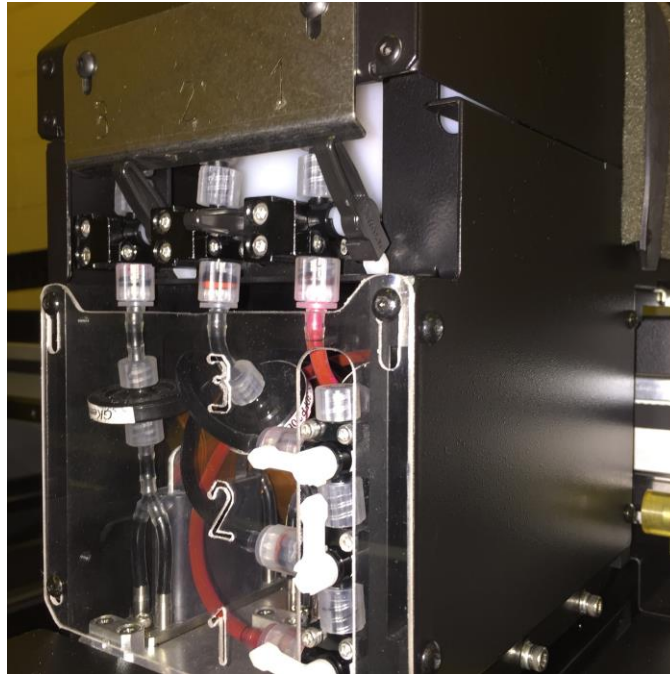


4. Verify that the all valve levers are in correct position to purge printhead 1. Then in the PCS software, locate the 'F' button in the manual clean tab.

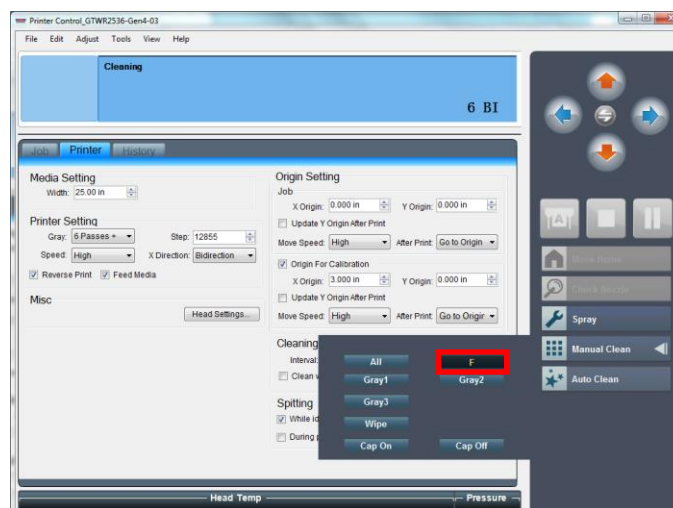


5. Hold 'F' button until all connected tubing to/from printhead is full of the pink flushing solution.
6. Once printhead 1 is full of flushing solution, return lower valve lever to left position and top valve lever to off position.
7. Next, the top valve levers for printhead 1 & 3 should be turned up to the off position and then place printhead 2s' top valve in the mid-way position.

8. The lower valves levers for printhead 1 & 3 stay in the same position (lever pointing left), and the lower valve lever for printhead 2 should point directly up. See photo for details.



9. Once valve lever positions are verified, hold 'F' button until all connected tubing to printhead is full of the pink cleaning solution.

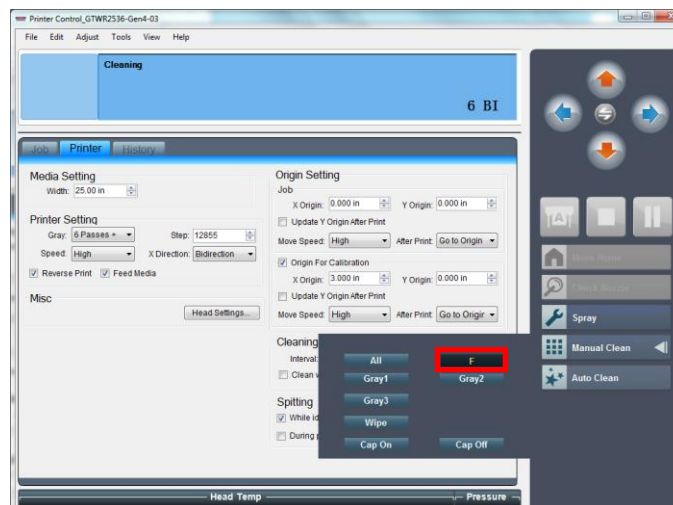


10. Once printhead 2 is full of flushing solution, return lower valve lever to left position and top valve lever to off position.

11. Next, the top valve lever for printhead 1 & 2 should be turned up to the off position then place printhead 3s' top valve lever in the mid-way position.
12. The lower valve levers for printhead 1 & 2 stay in the same position (lever pointing left), and the lower valve lever for printhead 3 should point directly up. See photo for details.

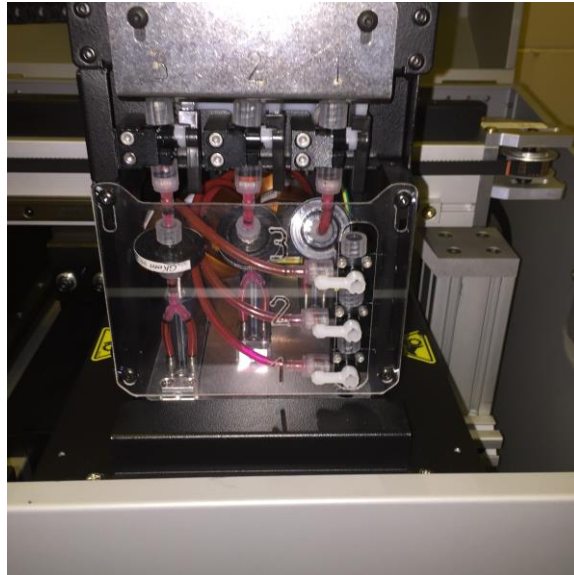


13. Once valve positions are verified, hold 'F' button until all connected tubing to printhead is full of the pink flushing solution.



14. Once printhead 3 is full of flushing solution, return lower valve lever to left position and top valve lever to off position.

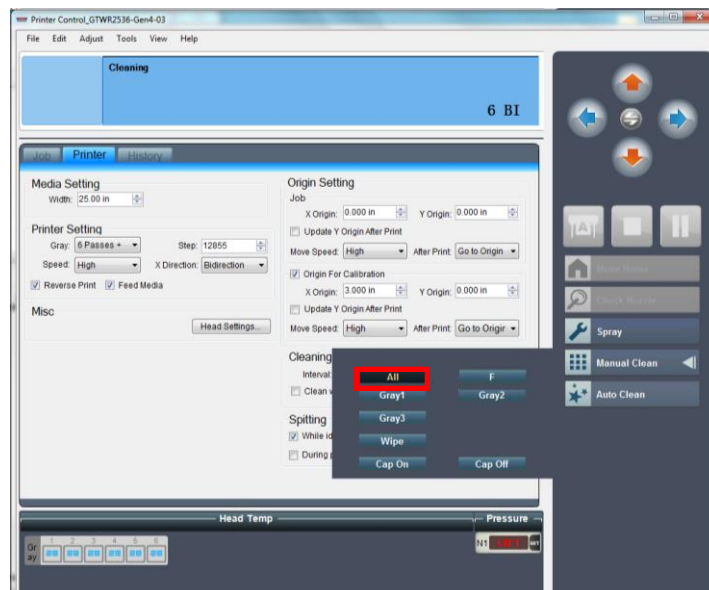
15. When finished, the printhead should look like the photo below.



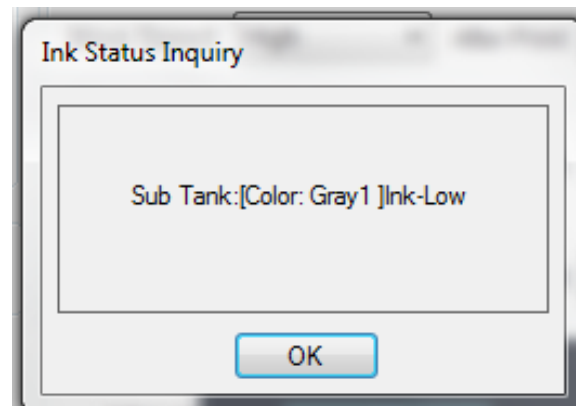
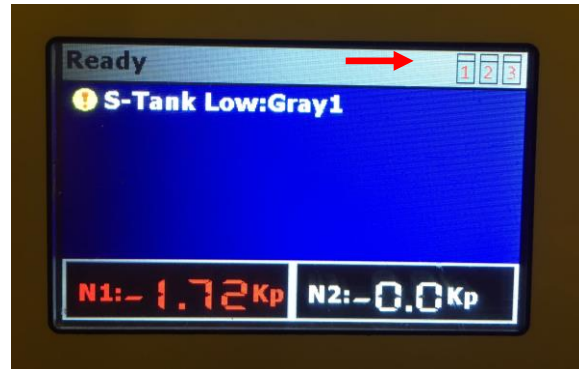
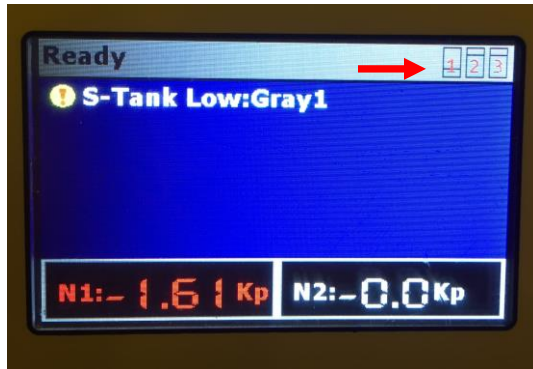
16. To start the ink filling process, all top valve levers need to point down and lower valve levers need to point left.

17. Starting with Printhead 1, click and hold 'All' button in manual clean tab for 5 seconds. As soon as the button is pressed the lower valve lever corresponding to printhead 1 should point up. Furthermore, before the 'All' button is released, return lower valve lever to original position (pointing left).

Note: Lower valve lever must be adjusted within the 5 second purge time, to maintain proper pressure. A second person may be necessary for this step.



18. If warning message “Sub-Tank:[Color: Gray1 ]Ink-Low” appears, do not press ‘Ok’. Locate the sub tank icon on LCD screen and confirm that horizontal bar is moving up and down. Once this animation is complete, the sub tank is full and the warning message will disappear.

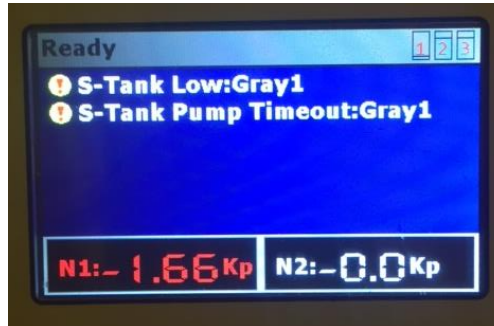


19. Repeat the procedure in step 15 for printhead 2 & 3, until all heads are filled with black ink.
20. Before checking nozzle, run 'Auto Clean' so that there is not excess ink built up underneath printhead.
21. If nozzle check still needs improvement, redo steps 1 through 18.



## Troubleshooting:

If the LCD screen displays alarm “S-Tank Pump Timeout:Gray1”. Follow the steps detailed below.

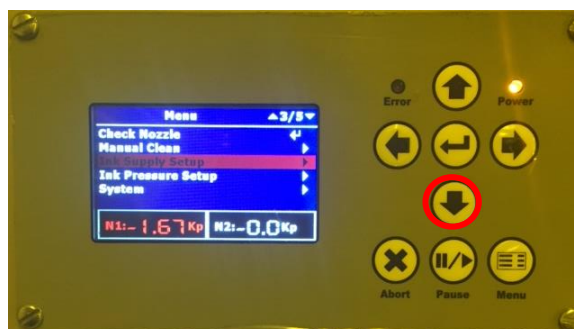


## Procedure:

1. Press menu button.



2. Press down arrow until 'Ink Supply Setup' option is highlighted, then press right arrow to advance.



3. In new window, make sure “Supply Mode=Auto” is highlighted then press right arrow to advance.

4. Highlight "Manual" and then press enter to make selection.



5. Now press "Menu" button, to get back to original screen to verify that alarm is dismissed. Once verified redo steps 1 and 2, to enter "Ink Supply Setup" page.
6. In new window, make sure "Supply Mode=Manual" is highlighted then press right arrow to advance.
7. Highlight 'Auto' and then press enter button.



8. Next, Highlight "Pump Time Limit: 30 Sec" and then hit right arrow.





9. Change time limit from 30 sec to off, then press the enter button.



10. Ink Supply Setup menu show look like photo below.



11. Re-enter Pump Time Limit setting menu, and change time limit back to 30 seconds.

12. Once verified, press menu button to go back to home screen and run a Auto-clean to verify the pump is no longer timed out.