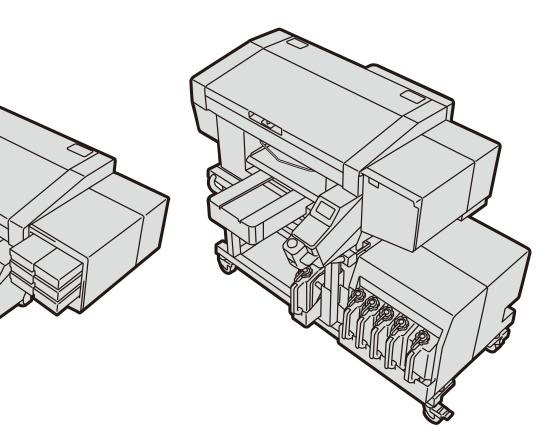
brother

GTX pro/ GTX pro Bulk

GARMENT PRINTER

Instruction Manual



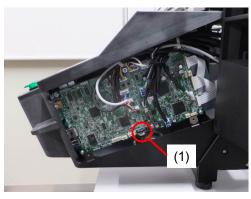
Please be sure to read this manual before using this product. Keep this manual in a safe place for future use.

Required Tools

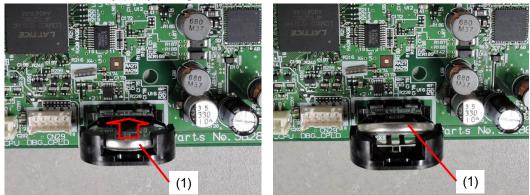
Phillips screwdriver: M3 to M5

Disassembling

(1) Remove the Cover PANEL SIDE.



(2) Remove the Lithium Battery (1) by pulling out the holder in the direction of the arrow.



(3) Pickup the Lithium Battery (1) to the direction of the arrow.



Note based on California law (USA) on the use and handling of Perchlorate

This product contains a CR Coin Lithium Battery which contains Perchlorate Material – special handling may apply.

See http://www.dtsc.ca/gov/hazardouswaste.perchlorate.

Thank you very much for buying a BROTHER printer.

Before using your new printer, please read the "SAFETY INSTRUCTIONS" and handling instructions carefully.

1. Safety indications and their meanings

This instruction manual and the indications and symbols that are used on the printer itself are provided in order to ensure safe operation of this printer and to prevent accidents and injury to yourself or other people. The meanings of these indications and symbols are given below.

Indications

	The instructions which follow this term indicate situations where failure to follow the instructions will result in death or serious injury.
	The instructions which follow this term indicate situations where failure to follow the instructions could result in death or serious injury.
	The instructions which follow this term indicate situations where failure to follow the instructions may result in minor or moderate injury.
((!))IMPORTANT	The instructions which follow this term indicate situations where failure to follow the instructions may result in damage to property.
((!))NOTE	The instructions which follow this term indicate precautions and restrictions for use.

Symbols

<u>.</u>	This symbol (\triangle) indicates something that you should be careful of. The picture inside the triangle indicates the nature of the caution that must be taken. (For example, the symbol at left means "beware of injury".)
\bigotimes	This symbol (\bigotimes) indicates something that you must not do.
.	This symbol () indicates something that you must do. The picture inside the circle indicates the nature of the thing that must be done. (For example, the symbol at left means "you must make a ground connection".)

2. Notes on safety

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Contact with high voltage sections may lead to a serious injury. Turn off the power, and remove the cover 5 minutes later.

Basic precautions

To prevent accidents and problems, do not modify the machine yourself. Brother will not be held responsible for any accidents or problems resulting from modifications made to the machine.

Do not handle the power cord with wet hands. Otherwise, it may cause electric shocks.

 \triangle

Installation

Do not set up the printer in a dusty environment. If dust collects inside the printer, it may cause fire or electric shocks or problems with correct operation.

Be sure to connect the ground. If the ground connection is not secure, you run a high risk of receiving a serious electric shock, and problems with correct operation may also occur.

Do not bend the cords excessively or fasten them too hard with staples or anything similar to secure cords. Otherwise it may cause fire or electric shocks.

Printing

If a foreign object gets inside the printer, immediately turn off the power, disconnect the power cord, and contact the place of purchase or a qualified technician. If you continue to use the printer while there is a foreign object inside, it may result in fire or electric shocks or problems with correct operation.

Do not allow the printer to come into contact with liquids. Otherwise it may cause fire or electric shocks or problems with correct operation.

If any liquid gets inside the printer, immediately turn off the power, disconnect the power cord, and contact the place of purchase or a qualified technician.

Do not use the printer when smoke or a bad odor is coming from the printer. Otherwise it may cause fire or electric shocks or problems with correct operation. Immediately turn off the power, disconnect the power cord, and contact the place of purchase or a qualified technician.

Keep your finger or any body part away from the rotating fan. Otherwise it will be caught up, which results in injuries.

Turn off the power when you approach the fan.

Environmental requirements

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Use the printer in a place which is adequately ventilated. A slight odor is generated when the printed articles are being fixed by heat.

Installation

\bigcirc	Setting up and moving of the printer should only be carried out by a qualified technician.
	The printer machine weighs 120 kg (265 lb). Transporting and setting up of the printer should be held in the proper way. Otherwise it may fall down and cause injury.
<i>▲</i>	When the printer falls down, disconnect the power cord and contact the place of purchase or a qualified technician. If you continue to use it, it may result in fire or electric shocks or poor printing quality.
	Do not place the printer on a shaky table or high shelf or other unstable location. Otherwise it may tip over or fall down and cause injury. Furthermore, the table that supports the printer should be at least 35.4 in. (90 cm) in width and 23.6 in. (60 cm) in depth, and should be able to bear a weight of 150 kg (330 lb) or more.
	Do not set up the printer in a place where it will be affected by vibration. Otherwise the printing quality may be degraded or the printer may fall down, which causes injury or results in failure of the printer.
	Do not connect the power cord until installation is complete. The printer may operate if the power is turned on by mistake, which could result in injury.
	Do not climb onto the printer or place heavy objects on top of it. Otherwise it may become unbalanced and tip over or fall down and cause injury.
\bigcirc	Be careful not to touch the claws of the mounting portion on the upper side of the rear cover. Otherwise you may be injured.
	Printing
\bigcirc	This printer should only be used by operators who are appropriately trained in its safe operation.
	Ensure there is adequate space left in front of the printer and avoid placing any objects. Otherwise your hand may get caught between the platen and an object, which may result in injury.
	Do not handle the platen while printing. If your hand gets caught between the platen or the T-shirt tray and the covers, it may be injured.
	Do not put your hands inside the covers while the printer's power is turned on. Otherwise your hands may touch against moving parts and this may result in injury.
0	When the pretreatment is applied to printed objects (like a T-shirt) with a spray or pretreatment applicator, sprayed mist is generated. So wear a pair of plastic gloves, a mask and protective glasses (or goggles) designed to shield against liquid splash, and fully take care of the air ventilation when you are working with it.
0	When a problem occurs with the operation of the printer, contact the place of purchase or a qualified technician.

Maintenance

Be careful not to get your fingers caught when closing the front cover, otherwise it may result in injury to your fingers.

When you mount or replace the head, be careful not to get your hands or fingers caught. Otherwise you may be injured.

Do not disassemble the ink pouch. If the ink gets into your eyes or onto your skin, it may cause inflammation. In case of contact with eyes, do not rub but immediately rinse the eyes with water.

Do not drink liquids such as the ink, maintenance solution, cleaning solution, pretreatment, or waste. They may cause diarrhea or vomiting.

Avoid causing your eyes or skin to make contact with the ink, maintenance solution, cleaning solution, pretreatment or waste. It may cause inflammation. In case of contact with eyes, do not rub but immediately rinse the eyes with water.

Keep the liquids out of the reach of children.

Be sure to wear protective goggles and gloves when handling the grease, so that it does not get into your eyes or onto your skin.

It can cause inflammation. Do not drink or eat the grease. It may cause diarrhea or vomiting. Keep the liquids out of the reach of children.

When replacing parts and installing optional accessories, be sure to use only genuine Brother parts. Brother will not be held responsible for any accidents or problems resulting from the use of non-genuine parts.

When replacing parts or installing optional accessories, be sure to follow the procedures described in the Instruction Manual. Incorrect procedures could cause injuries or problems.

«!»IMPORTANT

Printing

Do not move the p

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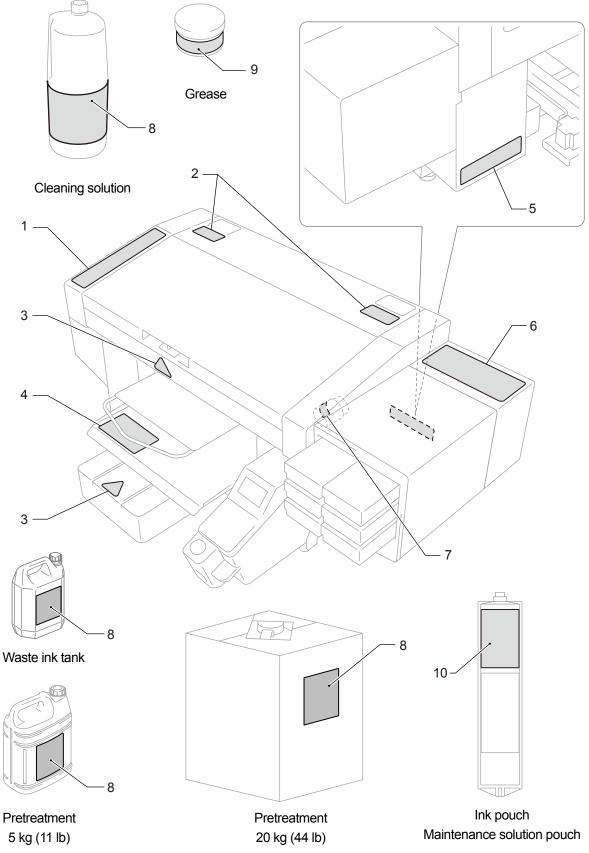
Do not move the platen by hand. Otherwise the printer may be mechanically and electrically damaged.

Ensure there is adequate space left in front of the printer and avoid placing any objects. The platen may be hit and damaged.

Use the printer in an area which is free from sources of strong electrical noise such as electrical line noise or static electric noise. Sources of strong electrical noise may cause problems with correct operation. Any fluctuations in the power supply voltage should be within ±10% of the rated voltage for the printer. Voltage fluctuations which are greater than this may cause problems with correct operation. The power supply capacity should be greater than the requirements for the printer's power consumption. Insufficient power supply capacity may cause problems with correct operation. In the event of an electrical storm, turn off the power and disconnect the power cord from the wall outlet. Lightning may cause problems with correct operation.

3. Warning labels

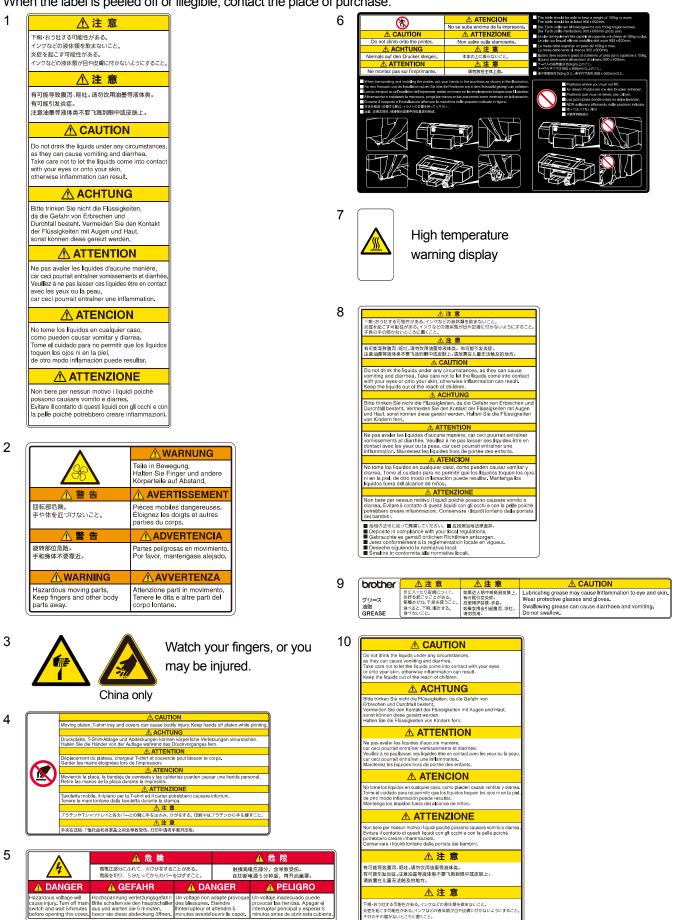
For GTX pro:



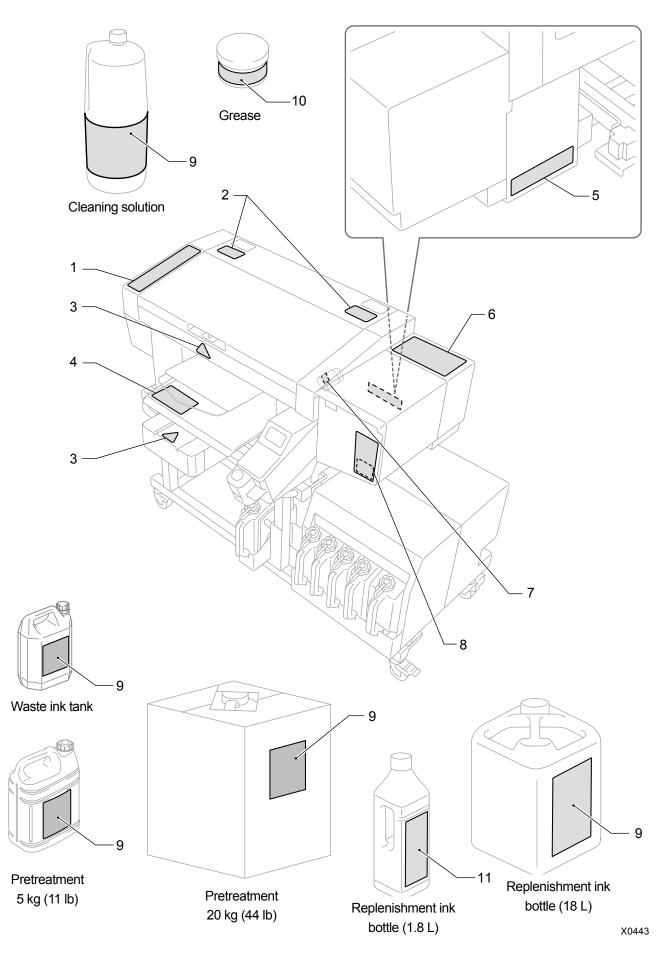
This printer has the following warning labels displayed on it.

Follow the precautions given on each warning label for your work.

When the label is peeled off or illegible, contact the place of purchase.



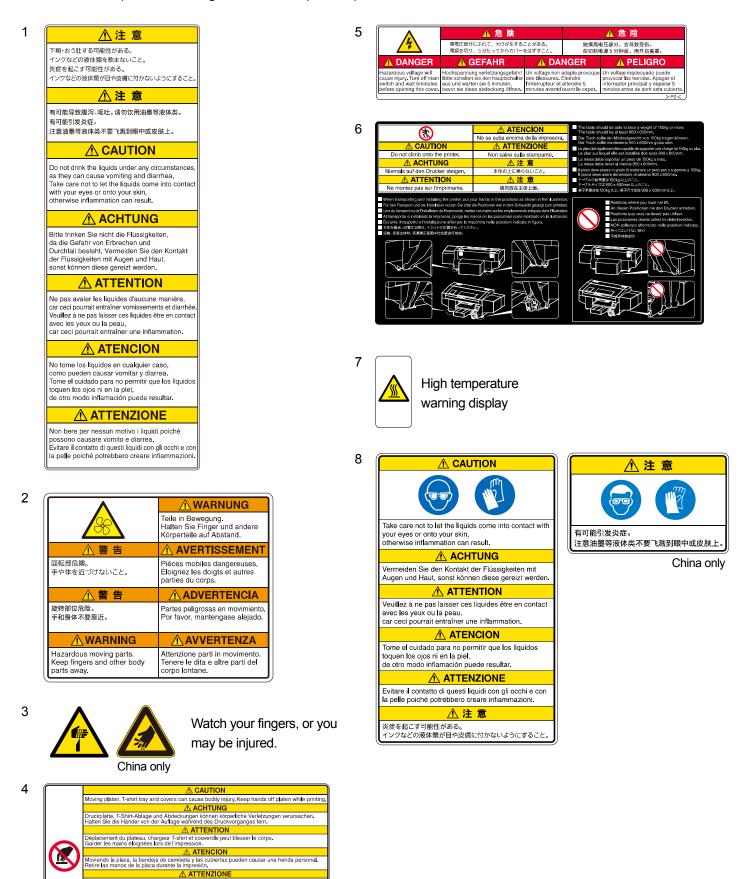
For GTX pro Bulk:



This printer has the following warning labels displayed on it.

Follow the precautions given on each warning label for your work.

When the label is peeled off or illegible, contact the place of purchase.



on rtas pueden causar una herida personal

bbero causare infortuni.

nobile, il ripiano per la T-shirt ed il carter potrebi nani lontane dalla tavoletta durante la stampa

⚠注意 △ム左 夢 ブラテンやTシャツトレイと各カバーとの間に手をはまか、付がをする。印刷中はブラテンから手を描すこと ▲ 注 意 手央在正核、T他托盘和各源盖之间会导致受伤、打印中请将手属并压纸。



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10	brother	▲注意	⚠注意	
	グリース 油脂 GREASE	目に入ったり皮膚につくと、 炎症を起こすことがある。 保護めがね、手袋を使うこと。 食べると、下痢、嘔吐する。 食べないこと。	有可能引发炎症。	Lubricating grease may cause Inflammation to eye and skin. Wear protective glasses and gloves. Swallowing grease can cause diarrhoea and vomiting. Do not swallow.

Do not drink the liquids under any circumstances, as they can cause vomiting and diarrhea. Take care not to let the liquids come into contact with your eyes or onto your skin, otherwise inflammation can result. Keep the liquids out of the reach of children.
Bitte trinken Sie nicht die Flüssigkeiten, da die Gefahr von Erbrechen und Durchfall besteht, Vermeiden Sie den Kontakt der Flüssigkeiten mit Augen und Haut, sonst können diese gereizt werden. Halten Sie die Flüssigkeiten von Kindern fern.
Ne pas avaler les liquides d'aucune manière, car ceci pourrait entraîner vomissements et diarrhée. Veuillez à ne pas laisser ces liquides être en contact avec les yeux ou la peau, car ceci pourrait entraîner une inflammation. Maintenez les liquides hors de portée des enfants.
No tome los líquidos en cualquier caso, como pueden causar vomitar y diarrea. Tome el cuidado para no permitir que los líquidos toquen los ojos ni en la piel, de otro modo inflamación puede resultar. Mantenga los líquidos fuera del alcance de niños.
Non bere per nessun motivo i liquidi poiché possono causare vomito e diatrea. Evitare il contatto di questi liquidi con gli occhi e con la pelle poiché potrebbero creare infiammazioni. Conservare i liquidi lottano dalla portata dei bambini.
注 意
下痢・おう吐する可能性がある。 インクなどの液体類を飲まないこと。 炎症を起こす可能性がある。 インクなどの液体類が目や皮膚に付かないようにすること。 子供の手の屈かないところに置くこと。
注 意
有可能导致腹泻、呕吐。请勿饮用油墨等液体类。 有可能引发炎症。注意油墨等液体类不要飞溅到眼中或皮肤上。 请放置在儿童无法触及的地方。
Deposite in compliance with your local regulations. Gebrauchte es gemäß ortlichen Richtlinien entsorgen. Jetez conformément a la reglementation locale en vigueu Deseche siguiendo la normativa local. Smaltre in conformita âlle normative locali. 地域の法合になって原知してください。■ 应按照当地法律废弃。

型号			有害	 「物质		
BGTX423H5000032 BGTX424H5000032	铅	镉	六价铬	汞	多溴联苯	多溴二苯醚
部件名称	Pb	Cd	Cr(VI)	Hg	PBB	PBDE
框架机制	0	0	0	0	0	0
盖板机制	0	0	0	0	0	0
台板机制	Х	0	0	0	0	0
导轴机制	Х	0	0	0	0	0
维护机制	×	0	0	0	0	0
供墨机制	Х	0	0	0	0	0
打印头机制	Х	0	0	0	0	0
电气部品	Х	0	0	0	0	0
操作面板机制	Х	0	0	0	0	0
配件	0	0	0	0	0	0
使用手册/其他零件	0	0	0	0	0	0
包装	Х	0	0	0	0	0
框架机制	0	0	0	0	0	0

<产品中有害物质的名称及含量>

本表格依据 SJ/T 11364 的规定编制。

O: 表示该有害物质在该部件所有均质材料中的含量均在 GB/T 26572 规定的限量要求以下。

.....

×: 表示该有害物质至少在该部件的某一均质材料中的含量超出 GB/T 26572 规定的限量要求。

(由于技术的原因暂时无法实现替代或减量化)

China only

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1-1. Be sure to read the following notes before using the printer

Keep in mind the following points before using the printer:

Precautions for proper use

- Keep the printer powered on the printer for 24 hours a day.
 Even when the printer is placed in standby mode, it performs such maintenance as white ink circulation inside the main unit automatically to prevent sedimentation of the white ink.
- Use the printer within the scope covered by its warranty for the best print result (temperature: 18 to 30°C (64.4 to 86°F) and humidity: 35 to 85%).
 Otherwise, the print heads may be clogged with ink and ink may splash.
- Adjust the height of the platen according to the print medium before using it. Adjust the height so that it is lowered by one step from the limit height detected by the obstacle sensor, and check that the platen is not detected by the obstacle sensor.
- Do not excessively lower the platen.

Otherwise, ink mist will be scattered inside the printer, which may result in staining of the printing surface, blurring of the printed image, and malfunction of the sensor and the main unit. ""6-4-2. Platen height adjustment >>P.151"

- Never power off the printer or open the cover while the printer is in operation. Otherwise, the printer may break down or a print job may end up in failure.
- Until the ink is firmly fixed on the surface of a T-shirt, do not touch the T-shirt. If a T-shirt is soiled with such ink that has not been firmly fixed on its surface, such ink stain cannot be removed even by washing.

About ink cartridge (for GTX pro only)

- Insert each of the cartridges into the hole of the same color as the printer seal.
- Shake the white ink well once a day immediately before use. (Shake each cartridge approximately 100 times.)

Otherwise the white ink may precipitate.

- Never pull out any cartridges while the printer is operating. Otherwise, the print quality may deteriorate or the printer may break down.
- Store consumable goods in a place where they are not exposed to direct sunlight.
- Use up the ink pouch, pretreatment and maintenance solution before their shelf life. Also, use up each color ink within six months after opening their sealed packages.
- Do not replenish into or disassemble the ink pouch.
 In order to use the printer for a long period and to take full advantage of its capabilities, we recommend to use the ink pouches that are specified by us. Use of a non-genuine ink pouch may make you liable for the cost of repairs even during the guarantee period.

• Do not remove the ink cartridge.

If the ink cartridge insertion slot is left empty, the inner needle may clog because ink dries up, or the printer may be damaged.

• Take care to prevent the ink pouch from being bent, snagged by sharp objects, or dropped. Otherwise, it could be damaged.

About ink cartridge (for GTX pro Bulk only)

- Replenish ink into the ink bottle of the same color as the ink tank seal.
- Shake the white ink well before replenishment. Otherwise the white ink may precipitate.
- Store consumable goods in a place where they are not exposed to direct sunlight.
- Use up the ink and pretreatment before their shelf life.
 Also, use up each ink bottle soon after opening their sealed packages.
- In order to take full advantage of the printer capabilities, we recommend to use the ink specified by us. Use of a non-genuine ink may make you liable for the cost of repairs even during the guarantee period.
- Be sure to close the ink tank lid once you have replenished the ink.
- Handle the ink bottle with care.
- Handle the IC stick with care.
- Use up the ink bottle every time you open it.

About pretreatment

- Avoid application of the pretreatment when no white ink is used.
 If a T-shirt to which the pretreatment is applied is coated with only color inks, its stains may be wiped off by washing.
- After a T-shirt is coated with the pretreatment, store pretreatment in a place where it is not exposed to direct sunlight, and wash it with clean water at an early stage after ink is applied to it. When a white or light-colored T-shirt is coated with the pretreatment, the coated surface color may change, and cannot be restored to the original color even if the T-shirt is washed.
- When performing printing for the first time, try pretreatment in an unnoticeable area. Some T-shirts may be discolored by the pretreatment and cannot be restored to the original color even if they are washed.
- Wash away any imprint of the pretreatment with water.
- When a color transfer occurs, wipe the color-transferred area clean of dirt with a soft and clean cloth or a toothbrush that is moistened with a small amount of mild detergent for home use or alcohol. If a printed material is rubbed with vinyl-chloride-based white or light-colored synthetic leather, color transfer may occur. Also, when a color-printed surface is rubbed strongly against a printed surface with only white ink, color transfer may occur in the same fashion.

About maintenance

In order to keep good printing quality, perform maintenance on a regular basis.
 For GTX pros "7. Precautions to keep good printing quality/use printer over the long term (For GTX pro) >>P.182"

For GTX pro Bulk "8. Precautions to keep good printing quality/use printer over the long term (For GTX pro Bulk) >>P.241"

• We recommend to use the genuine cleaning solution that is specified by us when cleaning the head section, cap or wiper.

This allows you to take full advantage of the printer's intrinsic capabilities and use it for a long period. Using commercially available alcohol or cleaning solution could cause damage to the print heads.

• Never remove the print heads except when they are replaced with new ones. Because they are precision components, the print head may fail.

What to do when not using printer

When the printer will not be used for a prolonged period of time, take appropriate procedures before storing the printer depending on storage period or condition.
 For GTX prose "7-5. When Not Using for a Long Period of Time >>P.239"
 For GTX pro Bulker "8-4. When Not Using for a Long Period of Time >>P.294"

About waste handling

• Dispose of the residual wastes and waste ink properly as water-based waste fluid in accordance with applicable laws and ordinances.

Others

- In the event that the printer is relocated elsewhere for layout change, etc., place a level gauge on the top surface of the cover and the top surface of the platen to make such an adjustment that the printer will be placed horizontally level.
- U: Standby symbol
- You cannot connect this product directly to the communications lines, including the public wireless LANs, of telecommunication carriers like mobile communications companies, fixed communications companies, or internet providers. Ensure that the product is connected through a router, if it is to be used over the internet.

<NOTE> Only for the use in the United States

This device complies with Part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) this device may not
cause harmful interference, and (2) this device must accept any interference received, including interference that may cause
undesired operation.

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Downloadable from: http://www.brother.com

About software

• •

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To use this printer, you are required to agree with the End-User License Agreement for Brother Software as mentioned below.

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This EULA will become effective upon your acceptance and continue in effect unless you cease to use the SOFTWARE. However, Brother may terminate this EULA without notice.

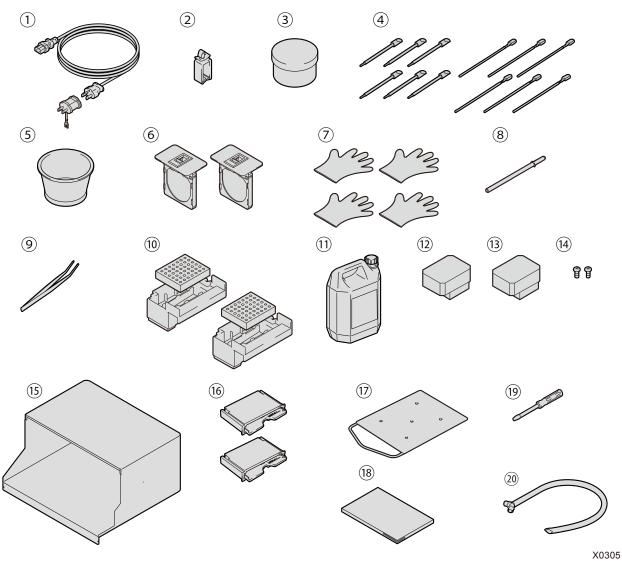
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1-2. Components included with printer

The components included with the printer are shown below. However, in the event that there is any missing component(s), please contact your dealer.

For GTX pro:

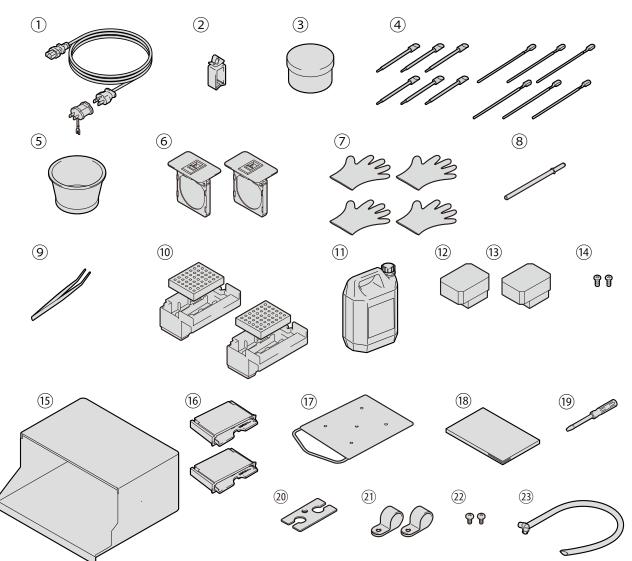


No.	Name	Quantity	No.	Name	Quantity
1	AC power cord	1	10	Flushing receiver	2
2	Cable clamp	1	10	Flushing foam	2
3	Grease	1	11	Waste ink tank	1
1	Clean stick R	6	12	Print head (for color printing)	1
4	Clean stick T	6	13	Print head (for white)	1
5	Cleaning cup	1	14	Rear cover installation screws ^{*1}	2
6	Filter cover and Fan filter	2	15	Rear cover	1
	Gloves (for changing the wiper		16	Wiper cleaner	2
7	cleaner / for cleaning the	4	17	Adult platen	1
	maintenance unit)		18	Setup Manual	1
8	Carriage fixing pin	1	19	Driver	1
	Tweezers	1	20	Waste ink tube	1

^{*1}: Screws are already fixed with the machine.

For GTX pro Bulk:

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X0434

No.	Name	Quantity	No.	Name	Quantity
1	AC power cord	1	11	Waste ink tank	1
2	Cable clamp	1	12	Print head (for color printing)	1
3	Grease	1	13	Print head (for white)	1
4	Clean stick R	6	14	Rear cover installation screws ^{*1}	2
4	Clean stick T	6	15	Rear cover	1
5	Cleaning cup	1	16	Wiper cleaner	2
6	Filter cover and Fan filter	2	17	Adult platen	1
	Gloves (for changing the wiper		18	Setup Manual	1
7	cleaner / for cleaning the maintenance unit)	4	19	Driver	1
8	Carriage fixing pin	1	20	Connector cover	1
9	Tweezers	1	21	Cord holder	2
10	Flushing receiver	2	22	Cord holder installation screw	2
10	Flushing foam	2	23	Waste ink tube	1

^{*1}: Screws are already fixed with the machine.

1-3. Other items you must make available for use

What you buy from our distributors

- Ink pouch (for GTX pro only)
- Maintenance solution pouch (for GTX pro only) *Only if white ink is not used
- Replenishment ink bottle: 1.8 L or 18 L (for GTX pro Bulk only)
- Cleaning solution
- Pretreatment

Others

USB 2.0-compliant device cable (A/B)

<NOTE>

- Using other cables than the specified one may cause the printer to be rendered inoperative. Do not use any extension cable.
- LAN cable (10BASE-T/100BASE-TX)
- USB flash memory

Please use a FAT32-formatted USB flash memory of which storage capacity is 2 GB to 32 GB in total. You cannot use a USB memory with security functions such as password lock function or beyond 32 GB.

Pure water

It refers to such water as distilled water and purified water, which is used to dilute the pretreatment with it.

<NOTE>

- Avoid using such water as tap water in which impurities are contained.
- Heat press

It must deliver the performance through which the print range of the size of a platen to be used can be covered and 180°C (356°F) can be kept for 35 seconds or more. At a fixing stage of the pretreatment, be sure to use the heat press, but not an oven, to smoothen the surface.

Peel-off sheet

Always use this sheet to flatten the fixed surface and enhance the peel property when fixating the pretreatment and ink by means of the heat press. Immediate "6-3-1. Provisions for pretreatment >>P.135".

- Silicone foam (of open-cell structure)
 It is the foamed mattress which resists heat. Use this at a fixing stage through the use of the heat press.
- Adhesive roller

Use these to remove lint from a T-shirt or debris from its surface.

- T-shirt (printing medium)
 - 100% cotton
 - Polyester blended yarn fabric

<TIPS>

- Although it is advisable to use a 100% cotton T-shirt, some textiles cannot necessarily guarantee good printing quality even if they are made of 100% cotton or blended yarn. In particular, for a T-shirt made of new material, perform a printing test on it beforehand.
- Some textiles may leave noticeable imprints of the pretreatment after it is fixated. In that case, wash them away with water.
- Perform a printing test beforehand. Then, the following phenomena may occur:
 - The textiles may be discolored by the pretreatment and cannot be restored to the original color even if they are washed.

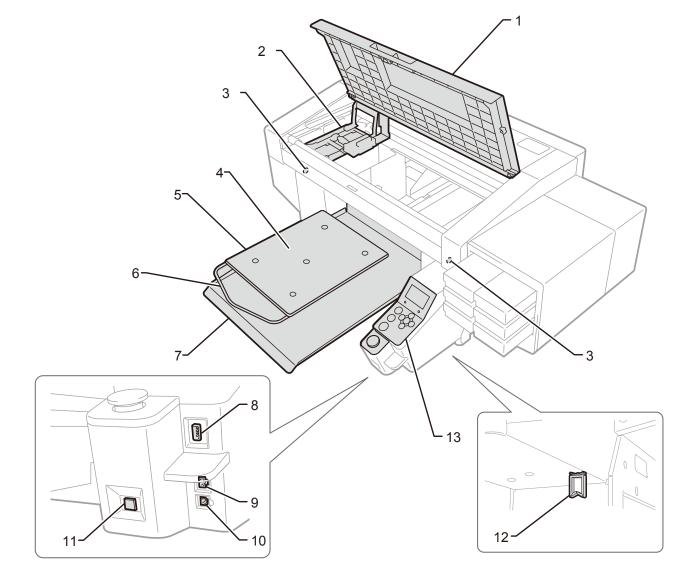
- A deep-colored polyester blended yarn fabric dissolves dye, which may cause the white ink to change to a slightly different color.

- Fabric material may turn yellow after the pretreatment is fixed.

Name and function of each component

2-1. Front part

2



X0306

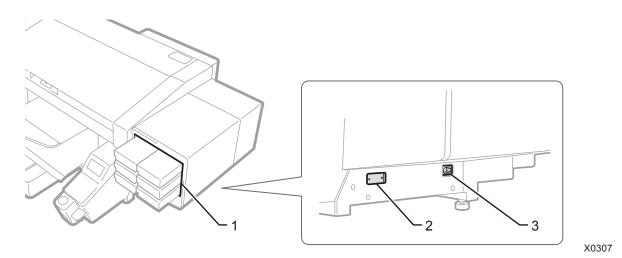
*The GTX pro is assumed.

No.	Name	Function		
1	Front cover	Open this cover when cleaning the internal area of the printer.		
2	Carriage	Holds the print head.		
	Obstacle sensor	Checks the presence of any obstacles by their height (such as wrinkled T-shirt)		
3	Obstacle sensor	that are within range to collide with the print head.		
	Platen too low sensor	Make sure that the clearance between the head and platen is not too large.		
4	Platen sheet	It helps to keep the T-shirt from moving/shifting during printing so that an image		
4	Flaten Sheet	can be clearly printed.		
5	Platen	Set the T-shirt to be printed.		
6	Shoulder bar	Align the position of a T-shirt with this bar.		
7	T-shirt tray	This T-shirt tray holds such portions of T-shirt that droop down on it and feeds		
1	1-Shift uay	the entire T-shirt into the printer.		
8	USB flash insertion slot	Insert a USB flash memory into this slot.		
9	LAN port	Into this port, insert the LAN cable which is to be connected with a PC.		
10	USB port	Into this port, insert the USB cable which is to be connected with a PC.		

No.	Name	Function
		Use this button to turn the power on/off to the printer.
11	Power button	The power-off operation should be performed after completing any required
11		operation.
		The standby power cannot be turned off.
12	Cable clamp	With this clamp, the LAN and USB cables can be securely fixed to the lower
		part of the main unit of printer.
13	Operation panel	Operate the printer using this panel.

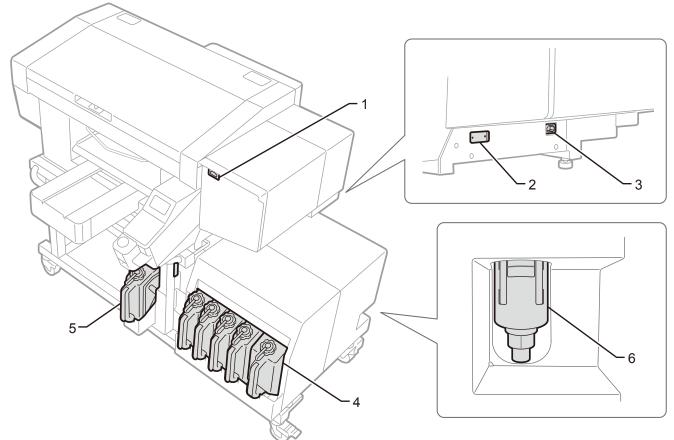
2-2. Right side view

For GTX pro:



No.	Name	Function
1	Ink cartridge slot	Ink cartridges placed here are, from the left in the top row, black (K) and yellow (Y), from the left in the middle row, cyan (C) and magenta (M), and from the left in the bottom row, white (W12) and white (W34). Be sure to put each of the ink cartridges in their correct places.
2	Model plate	On this plate, a product serial number is inscribed.
3	Power cord insertion port	Insert the power cord into this port.

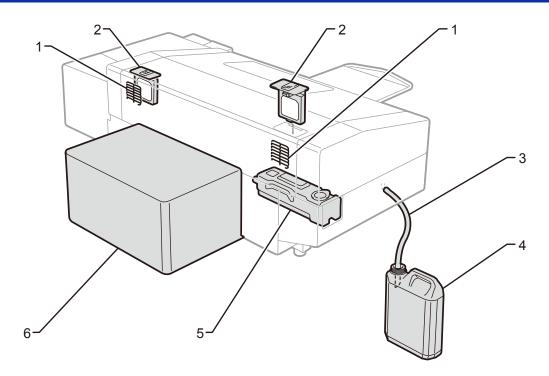
For GTX pro Bulk:



X0383

No.	Name	Function
1	IC stick insertion slot	This slot accommodates the IC stick that contains the color information for use when replenishing the ink.
2	Model plate	On this plate, a product serial number is inscribed.
3	Power cord insertion port	Insert the power cord into this port.
4	Ink tank	In the left-to-right order, the remaining ink volume in the black (K), yellow (Y), cyan (C), magenta (M) and white (W) ink cartridges are shown here.
5	Cleaning liquid tank	It is the tank that reserves the cleaning solution used for maintenance.
6	Drain separator	Temporarily stores ink generated from inside when the main unit is faulty to prevent ink overflow.

2-3. Left side view/Rear side view



X0308

*The GTX pro is assumed.

No.	Name	Function
1	Exhaust opening	This is the exhaust outlet for fan exhaust air. For proper use, keep this opening
		apart from the nearest wall by 7.9 in. (20 cm) or more.
2	Fan filter	It absorbs ink mist which is generated inside the printer on its surface.
3	Waste ink tube	This tube is used to direct the flow of waste ink down into the waste ink tank.
4	Waste ink tank	This tank collects waste ink.
5	Cleaning liquid tank	It is the tank that reserves the cleaning solution used for maintenance.
	(for GTX pro only)	
6	Rear cover	It protects the platen's working range.

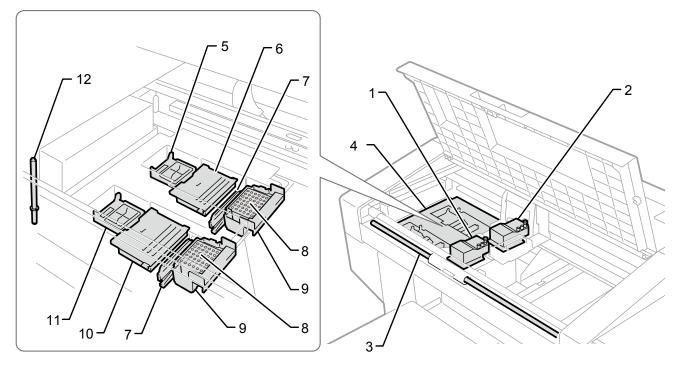
2-4. Inner-side view of front cover

Before opening the front cover, be sure to stop all operations, then house the platen in place, and finally turn off the power.

To open the front cover, raise it while holding the center grip and open it until it is oriented almost vertically.

<IMPORTANT>

• Be sure to press the power button to turn off the power before opening the front cover. If you open the front cover while the power is on, no cleaning will be performed at the end of the print job, which is intended to keep the print heads in good condition.

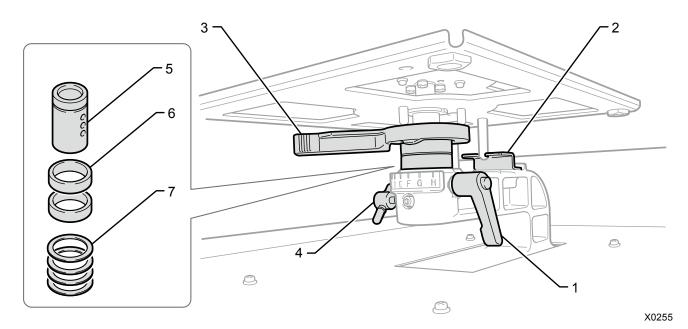


X0309

No.	Name	Function
1	Print head (front: on the color side)	It ejects the color ink.
2	Print head (rear: on the white side)	It ejects the white ink.
3	Carriage guide shaft	This shaft supports the carriage.
	Maintenance unit	In order to keep good printing quality, this unit performs maintenance
4		functions to the print heads on a regular basis. (Example: Auto-Cleaning
		Function)
5	Cap (rear: on the white side)	It protects the surface of heads on the white side, and sucks ink during
5		head cleaning.
6	Wiper cleaner (rear: on the white side)	It removes waste ink attached to the wiper surface.
7	Wiper (for CMYK and white)	It wipes away ink from the head surface.
8	Flushing foam	To keep good printing quality the foam absorbs the ink-jet droplets ejected
0		from the print head.
9	Flushing receiver	Set the flushing foam.
10	Wiper cleaner (front: on the color side)	It removes waste ink attached to the wiper surface.
11	Cap (front: on the color side)	It protects the surface of heads on the color side, and sucks ink during
		head cleaning.
12	Carriage fixing pin	To prevent drying of print heads in an emergency such as a blackout, it
12		fixes the carriage to the cap position of the maintenance unit.

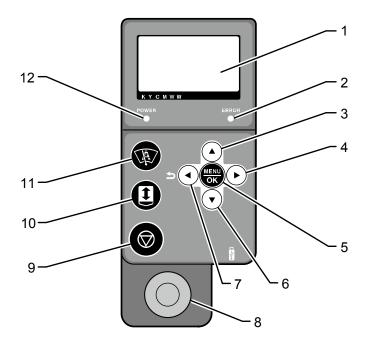
2-5. Bottom view of platen

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No.	Name	Function
1	Platen fixing lever	Use this lever to secure the platen in place.
		Tighten or loosen it to adjust the height of the platen when attaching/removing
		the platen. Keep it tightened when printing.
2	Platen positioning plate	This is used to secure the platen at the fixed direction and hold it in place.
3	Platen height adjustment lever	This lever should be used to adjust the platen's height.
4	Knob	Use this knob to secure the platen bearing in place. This lever should be used
4		to change the platen's height. Keep it tightened when printing.
5	Platen bearing	This is used to secure and hold the platen in place.
6	Collars	Used to change the platen's height by changing the number.
7	Spacer	Platen height of each machine is finely adjusted by the number of the spacer.
		Never tamper with or remove these spacers even if adjusting the collars or it
		will affect print output.

2-6. Operation panel



X0036

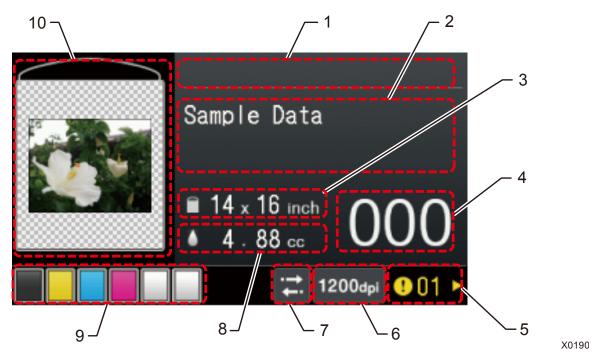
No.	Name	Function
1	Liquid crystal panel	It indicates the job name or file name of print data, the active status of the
		printer, and the menu for various settings.
2	Error LED	When it remains off: No error has occurred.
		When it remains on: One or more errors have been detected.
3		While the menu screen is being displayed, use this button to select your
	Up-arrow button	desired menu item.
		In the numeric value setting menu, use this button to increase the target value.
	Right-arrow button	While the menu screen is being displayed, use this button to select your
4		desired lower-level (right) menu item.
4		While the standby mode screen is being displayed, use this button to display a
		warning when any warning message appears.
5	MENU/OK button	If this button is pressed when the printer is placed in the standby state, the
		menu screen will appear.
5		While the menu screen or the error screen is being displayed, use this button to
		finalize and accept the currently displayed content.
	Down-arrow button	While the menu screen is being displayed, use this button to select your
6		desired menu item.
		In the numeric value setting menu, use this button to decrease the target value.
	Back button /	While the menu screen is being displayed, use this button to return to only one
7	Left-arrow button	upper-level (left) menu screen.
8		There is no print data when this button remains off. This button blinks during
	Print button	reception of print data, and it illuminates when such reception is completed.
		Printing will begin if you press this button when it is illuminated.

No.	Name	Function	
9	Stop button	 With this button, such actions as printing and platen movement can be canceled. Printer will come to a stop after necessary actions for keeping the printer's good quality, such as retracting operation of print heads and capping operation, are completed. While the menu screen is being displayed, the screen will exit and return to the standby mode screen. 	
10	Platen button	It is used to move the platen toward the rear or front of the printer. Use this button to ascertain whether the platen is set to a proper height after the platen's height is adjusted.	
11	Shortcut button	Performs the action assigned to the shortcut function.	
12	Power LED	When it remains off:The power of the printer is turned off.When it remains on:The printer remains turned on (powered on).	

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2-6-1. Liquid crystal panel

The picture shown below indicates a state under which the printer has received print data. On this screen, the printer's current state and necessary information for printing are displayed.



No.	Indications	Function
1	Progress bar display area	It displays a state of progress during the process of printing and/or print-data reception.
2	Text string display area on basic display screen	In this area, the print job name or file name, auto cleaning, receiving state, standby state, etc. are shown.
3	Platen Size	Platen size that is specified by the print driver during file creation is indicated here.
4	Number of printed sheets The total number of printed sheets of which printing operation is completed response to the received print data is displayed here. (0 to 999)	
5	5 Warning mark Warning mark 5 Warning mark 5 Warning mark 5 Warning mark • Cause • C	
6	Resolution icon	The printing resolution of received print data is displayed here.
7	Print direction icon The print direction is displayed here in the form of either bi-directional or uni-directional icon.	
8	Ink volume to be used	The required ink volume (cc) for printing out one sheet of the received print data is displayed here. (CMYK + White)

Name and function of each component

No.	Indications	Function	
9	Remaining ink volume indication area	 In this area, current remaining ink volume of each cartridge is displayed. In the left-to-right order, the remaining ink volume in the black (K), yellow (Y), cyan (C), magenta (M) and two white (W12 and W34) ink cartridges are shown here. The GTX pro Bulk has one remaining volume indicator for white ink. In the remaining ink volume is running low. Make ink available for use in the next printing session. *1 In the remaining ink has been depleted. 	
10	Preview image	The preview display screen of received print data is shown in this window. The preview display screen shown here is indicated upside down as opposed to the page orientation (the upper side of the preview image is oriented toward the front of the printer main unit). Furthermore, it is possible to change the direction of the preview display screen as well.	

<IMPORTANT>

*1: If you perform printing that requires a large volume of ink when the remaining ink level is low, the ink may be depleted during the printing process. As a rough indication, replace the ink pouch (for GTX pro) or replenish ink (for GXT pro Bulk) before you perform printing that requires 20 cc or more ink.

On-screen menu manipulation

Pressing (in the wait state causes the current screen to move to the menu selection screen.
By means of $\mathbf{A} \neq \mathbf{V}$, change a menu item to another menu item to be displayed.
Pressing causes the current menu to change to another menu item which is one level lower in the menu layer.
Pressing causes the currently displayed menu to be acknowledged.
Pressing Ⴢ causes the current menu to change to another menu item which is
one level higher in the menu layer.
 If you press when a menu in the uppermost menu layer remains displayed, the menu will exit and the system will return to the standby state. If you press when an optional menu remains displayed, the menu will exit and the system will return to standby state.
P OI P

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Menu list (for GTX pro)

1st layer	2nd layer	3rd layer	Description
			In the event that no ink-jet droplets are ejected,
		[All Colors]	this menu item enables you to perform cleaning
			of all the nozzles of the color heads.
			In the event that no ink-jet droplets are ejected,
	[Normal Cleaning]	[All Whites]	this menu item enables you to perform cleaning
			of all the nozzles of the white heads.
			In the event that no ink-jet droplets are ejected,
		[All Print Heads]	this menu item enables you to perform cleaning
			of the nozzles of all the print heads.
		[All Colors]	Perform one of the powerful cleaning operations
	[Powerful Cleaning]	[All Whites]	when poor ejection of ink-jet droplets is not
		[All Print Heads]	improved by means of the normal cleaning.
[Head Cleaning]		[All Colors]	Perform one of the super cleaning operations
	[Super Cleaning]	[All Whites]	when poor ejection of ink-jet droplets is not
		[All Print Heads]	improved by means of the powerful cleaning.
		[White-1]	
		[White-2]	
		[White-3]	
		[White-4]	
	[Elooh Eiring]	[Black]	Perform one of the flushing operations when the
	[Flash Firing]	[Yellow]	ink-jet droplets are not ejected stably.
		[Cyan]	
		[Magenta]]
		[All Whites]]
		[All Colors]	

1st layer	2nd layer	Description	
	[Nozzle Check CMYK]	This is the test pattern to check to see if ink-jet droplets are	
[Test Print]		ejected from the color heads properly or not.	
	[Nozzle Check White]	This is the test pattern to check to see if ink-jet droplets are	
		ejected from the white head(s) properly or not.	
[Print Data Load]		With this menu item, any print data stored in a USB flash	
		memory (ARXP or ARX4 file) is loaded into the system.	
		By selecting this menu item, you can display any print data	
[Receiving History]		received in the order in which they are sorted from the	
[newest to the oldest ones, and you can select any one of	
		them.	
	[White Ink Circulation]		
	[White Ink Refilling]		
	[Maintenance Part Clean/Replace]		
	[White Head Cleaning]		
	[Install White Ink After Cleaning]		
[Maintenance]	[Head Replacement]	Use when performing printer maintenance.	
	[Install Ink after Replacing Head]		
	[Initial Ink Installation]		
	[White Ink Pause Mode]		
	[Exchange Filter]	-	
	[Printer transport preparation]		
	[Log copy to USB]		
	[Print Direction]		
	[Back Light]		
	[Auto Screen Erase Time]		
	[Menu TimeOut Setting]		
	[Speaker Volume]		
	[Temperature]		
	[Preview display settings]		
	[File name display setting]		
	[Obstcl sensr settng during print]		
	[Platen too low sensor]		
[Printer Setting]	[Low Temperature Mode]	Use when configuring the printer.	
[[Auto Cleaning Setting]		
	[Auto Cleaning Start Timing]		
	[Flushing Interval Setting]		
	[Flushing Volume Setting]		
	[Wiping frequency]		
	[Auto Job Delete]		
	[IP Address Set]		
	[Network filtering]		
	[Shortcut button]		
	[Cartridge Attach/Remove Check]		
	[CR Speed Adjustment]		

Menu list

1st layer	2nd layer	Description
[Total Print]		
[CTG Attach/Remov	e History]	
[Check circulation sc	hedule]	
[Temperature/Humid	lity Info]	
	[IP Address]	
[Confirm network	[Subnet Mask]	
setting]	[Default Gateway]	
setting	[Host name]	
	[MAC address]	
	[English]	
	[Español]	
	[Français]	Use when needed.
	[Deutsch]	
	[Italiano]	
[Language]	[日本語]	
	[中文]	
	[Türkçe]	
	[Русский]	
	[한국어]	
	[Firm Version]	
[Version]	[Data Info]	
	[Serial No.]	
	[Head information]	

Menu list (for GTX pro Bulk)

1st layer	2nd layer	3rd layer	Description
			In the event that no ink-jet droplets are ejected,
		[All Colors]	this menu item enables you to perform cleaning
			of all the nozzles of the color heads.
			In the event that no ink-jet droplets are ejected,
	[Normal Cleaning]	[All Whites]	this menu item enables you to perform cleaning
			of all the nozzles of the white heads.
			In the event that no ink-jet droplets are ejected,
		[All Print Heads]	this menu item enables you to perform cleaning
			of the nozzles of all the print heads.
		[All Colors]	Perform one of the powerful cleaning operations
	[Powerful Cleaning]	[All Whites]	when poor ejection of ink-jet droplets is not
		[All Print Heads]	improved by means of the normal cleaning.
[Head Cleaning]		[All Colors]	Perform one of the super cleaning operations
	[Super Cleaning]	[All Whites]	when poor ejection of ink-jet droplets is not
		[All Print Heads]	improved by means of the powerful cleaning.
		[White-1]	
		[White-2]	
		[White-3]	
		[White-4]	
	[Elooh Eiring]	[Black]	Perform one of the flushing operations when the
	[Flash Firing]	[Yellow]	ink-jet droplets are not ejected stably.
		[Cyan]	
		[Magenta]	
		[All Whites]	
		[All Colors]	

1st layer	2nd layer	Description	
		This is the test pattern to check to see if ink-jet droplets are	
[Toot Print]	[Nozzle Check CMYK]	ejected from the color heads properly or not.	
[Test Print]	[Nozzla Chack W/bita]	This is the test pattern to check to see if ink-jet droplets are	
	[Nozzle Check White]	ejected from the white head(s) properly or not.	
[Print Data Load]		With this menu item, any print data stored in a USB flash	
[Print Data Load]		memory (ARXP or ARX4 file) is loaded into the system.	
		By selecting this menu item, you can display any print data	
[Receiving History]		received in the order in which they are sorted from the	
		newest to the oldest ones, and you can select any one of	
		them.	
[Ink refill]		Use when replenishing the ink.	
[Add cleaning solution]		Use when replenishing the cleaning solution.	
-	[Maintenance Part Clean/Replace]		
	[White Ink Circulation]		
	[White Ink Refilling]		
	[White Head Cleaning]		
	[Install White Ink After Cleaning]		
	[Correct tank volume sensor]		
[Maintenance]	[Head Replacement]	Use when performing printer maintenance.	
	[Install Ink after Replacing Head]		
	[Initial Ink Installation]		
	[White tank agitation]		
	[Exchange Filter]		
	[Printer transport preparation]		
	[Log copy to USB]		
	[Print Direction]		
	[Back Light]		
	[Auto Screen Erase Time]		
	[Menu TimeOut Setting]		
	[Speaker Volume]		
	[Temperature]		
	[Preview display settings]		
	[File name display setting]		
	[Obstcl sensr settng during print]		
	[Platen too low sensor]	1	
[Printer Setting]	[Low Temperature Mode]	Use when configuring the printer.	
	[Auto Cleaning Setting]		
	[Auto Cleaning Start Timing]		
	[Flushing Interval Setting]		
	[Flushing Volume Setting]		
	[Wiping frequency]		
	[Auto Job Delete]		
	[IP Address Set]		
l F	[Network filtering]		
, L			
[[Shortcut button]		

Menu list

1st layer	2nd layer	Description
[Total Print]		
[Check circulation so	chedule]	
[Temperature/Humic	lity Info]	
	[IP Address]	
[Confirm network	[Subnet Mask]	
setting]	[Default Gateway]	
Setting	[Host name]	
	[MAC address]	
	[English]	
	[Español]	
	[Français]	Use when needed.
	[Deutsch]	
	[Italiano]	
[Language]	[日本語]	
	[中文]	
	[Türkçe]	
	[Русский]	
	[한국어]	
	[Firm Version]	
[Vorsion]	[Data Info]	
[Version]	[Serial No.]	
	[Head information]	

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Be sure to use the printer after making correct setting in accordance with the instructions described in this chapter.

Do not set up the printer in a dusty environment. If dust collects inside the printer, it may cause fire or electric shocks or problems with correct operation. 9 Be sure to connect the ground. If the ground connection is not secure, you run a high risk of receiving a serious electric shock, and problems with correct operation may also occur. Do not bend the cords excessively or fasten them too hard with staples or anything similar to secure cords. Otherwise it may cause fire or electric shocks. Setting up and moving of the printer should only be carried out by a qualified technician. The printer machine weighs 120 kg (264 lb) for the GTX pro or 160 kg (352.7 lb) (main body 120 kg (264 lb) + tank unit 40 kg (88.1 lb)) for the GTX pro Bulk. Transporting and setting up of the printer should be held in the proper way. The machine may fall down and cause injury. When the printer falls down, disconnect the power cord and contact the place of purchase or a qualified technician. If you continue to use it, it may result in fire or electric shocks or poor printing quality. ଛ Do not place the printer on a shaky table or high shelf or other unstable location. Otherwise it may tip over or fall down and cause injury. Furthermore, for the GTX pro, the table that supports the printer should be at least 35.4 in. (90 cm) in width and 23.6 in. (60 cm) in depth, and should be able to bear a weight of 150 kg (330 lb) or more. For more information on the GTX pro Bulk, contact the dealer. Do not set up the printer in a place where it will be affected by vibration. Otherwise the printing quality may be degraded or the printer may fall down, which causes injury or results in failure of the printer. Do not connect the power cord until installation is complete. The printer may operate if the power switch is turned on by mistake, which could result in injury. Do not climb onto the printer or place heavy objects on top of it. Otherwise it may become unbalanced and tip over or fall down and cause injury. Be careful not to touch the claws of the mounting portion on the upper side of the rear cover. Otherwise you may be injured.

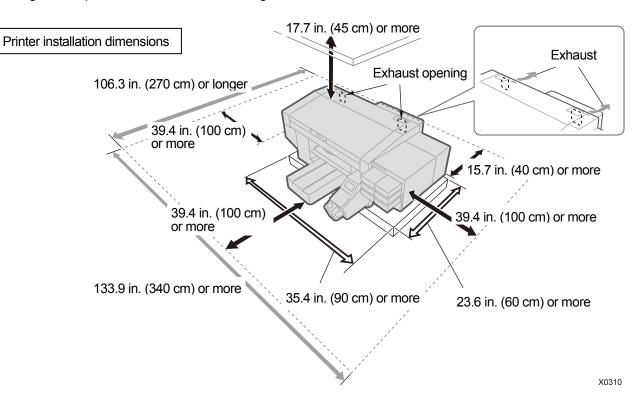
4-1. Installation of printer

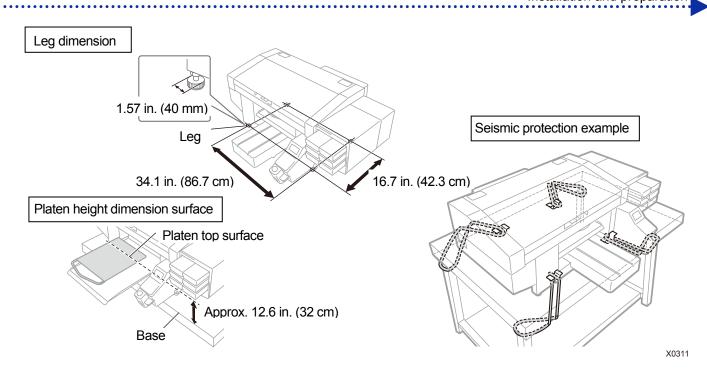
For GTX pro

Please refer to the Setup Manual included with the printer, for details of unpacking procedures and installation procedures of accessories.

For an installation site of the printer, please bear the following points in mind:

- When installing the printer, avoid any place that presents direct sunlight or a large amount of dust.
- The body size is 55.1 in. (width) x 51.2 in. (depth) x 21.7 in. (height) (140 cm (width) x 130 cm (depth) x 55 cm (height)). The main unit weighs 120 kg (264 lb).
- The right-and-left width of the legs is 34.1 in. (86.7 cm) while the front-to-rear width is 16.7 in. (42.3 cm). The diameter of the legs is 1.57 in. (40 mm).
- The height from the table to the top surface of the platen is approx. 12.6 in. (32 cm).
- Do not use any extension cable.
- As workspace in front of and on both sides of the printer, always keep 39.4 in. (100 cm) or wider space around it from obstruction. Also, as a space to install the rear cover, keep 15.7 in. (40 cm) or wider clearance at the back of the printer. Keep 17.7 in. (45 cm) or wider space free above the unit as well. As the air is exhausted toward the rear side, keep 7.9 in. (20 cm) or more space open behind the exhaust opening. If this space is not secured, you will have to move peripherals or the printer when making a repair.
- Be sure to use a table that supports the printer should be at least 35.4 in. (90 cm) in width and 23.6 in. (60 cm) in depth, and its top plate should be level and should be able to bear a weight of 150 kg (330 lb) or more without rattling the printer when in operation.
- When installing the printer, place a level gauge on the top surface of the cover and the top surface of the platen to make adjustments so that the main unit is set horizontally level.
- In preparation for a major earthquake or other natural disasters, fix the table and the main unit with a tool like a fixing band to prevent the main unit from falling from the table.



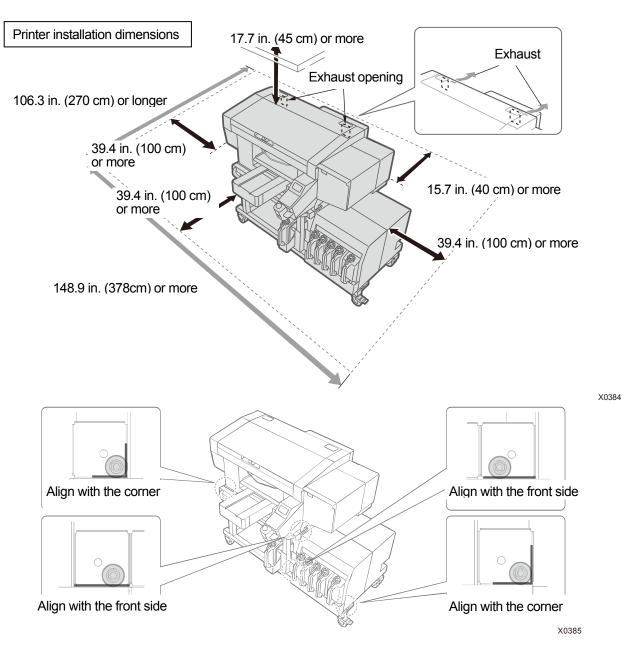


For GTX pro Bulk

Please refer to the Setup Manual included with the printer, for details of unpacking procedures and installation procedures of accessories.

For an installation site of the printer, please bear the following points in mind:

- When installing the printer, avoid any place that presents direct sunlight or a large amount of dust.
- The size is 70 in. (width) x 51.1 in. (depth) x 47.6 in. (height) (178 cm (width) x 130 cm (depth) x 121 cm (height)). The main unit weighs 160 kg (352 lb).
- Do not use any extension cable.
- As workspace in front of and on both sides of the printer, always keep 39.4 in. (100 cm) or wider space around it from obstruction. Also, as a space to install the rear cover, keep 15.7 in. (40 cm) or wider clearance at the back of the printer. Keep 17.7 in. (45 cm) or wider space free above the unit as well. As the air is exhausted toward the rear side, keep 7.9 in. (20 cm) or more space open behind the exhaust opening. If this space is not secured, you will have to move peripherals or the printer when making a repair.
- When installing the printer, place a level gauge on the top surface of the cover and the top surface of the platen to make adjustments so that the main unit is set horizontally level.
- Align the main body and tank unit front legs with the frame corner.
- For information on the table that supports the printer, contact the dealer.



4-1-1. Installation of waste ink tank

Insert the waste ink tube into the main body. Fasten the waste ink tank to the table leg or the like by using two pieces of string, etc. Insert the waste ink tube into the waste ink tank.

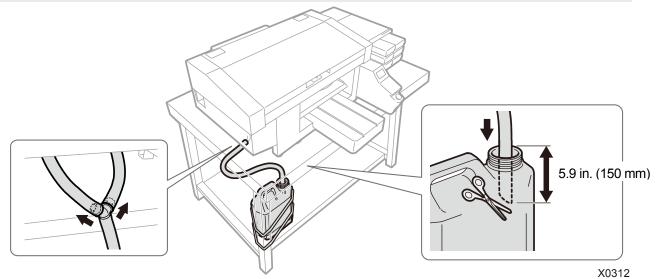
<IMPORTANT>

- If the tip of the waste ink tube is immersed in the liquid, it will prevent the smooth flow of the waste ink, to disable the ink suction operation of the head cleaning function. After the waste ink tank is fastened, the waste ink tube should be cut so that the length from the tube connection is 5.9 in. (150 mm).
- Avoid placing the waste ink tube horizontally as much as possible, and be sure not to let it bend. Otherwise the waste ink
 may have difficulty flowing through the tube.

For GTX pro:

<TIPS>

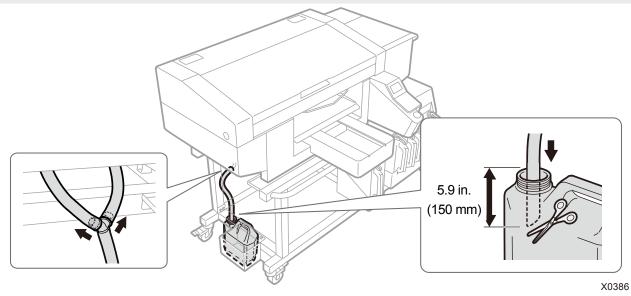
Install the waste ink tank in the front, because it must be emptied when the waste ink is full.



For GTX pro Bulk:

<TIPS>

• The table provides a place where to install the waste ink tank. Install the waste ink tank there.



4-2. Power supply of printer

Even when the printer is placed in standby mode, such maintenance as white ink circulation is performed automatically. **PLEASE LEAVE THE PRINTER POWERED ON 24 HOURS A DAY.**

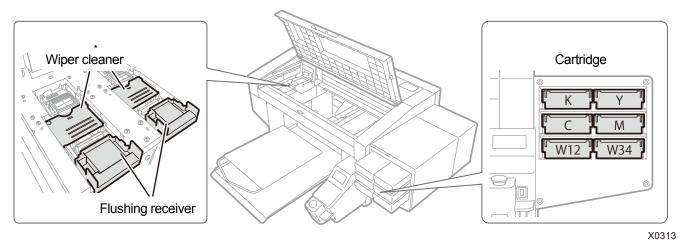
<TIPS>

Every time this printer is powered on or off, maintenance operations are performed to keep its print heads in good condition. Turning on and off the power frequently causes more ink to be consumed because of the maintenance operations. In order to reduce the ink consumption, it is advisable to keep the power turned on for proper use of the printer.

4-2-1. Turning on the power

Please refer to the Setup Manual, after the unpacking procedures and installation procedures are completed. Please check the following points, before connecting the power cord to the printer:

- Check whether or not the cartridge is correctly installed. (For GTX pro only)
- Check whether or not the wiper cleaner and flushing receiver are correctly installed.
- Ascertain whether the ink tube is connected to the print head correctly.



- Ascertain whether the waste ink tube is inserted into the waste ink tank which has been made available.
- Ascertain whether the rear cover is put in position.
- Ascertain whether there is enough cleaning solvent in the cleaning liquid tank and the tank is mounted correctly in place.
- Ascertain whether the required space (at least approx. 11.8 in. (30 cm)) for the platen to be moved forward is kept and the min. clearance (7.9 in. (20 cm)) is maintained at the back side of the printer for exhausting air from the exhaust opening.

<IMPORTANT>

- For the GTX pro Bulk, turn on the power before you replenish the ink.
- (1) Connect the power cord included with the printer to the power cord insertion port.
- (2) Insert the power plug into an electric outlet.
- (3) Make sure that the printer's earth terminal is properly grounded.
- (4) With the main unit's cover being closed, turn on the power to the printer.

<IMPORTANT>

- Never power off the printer while it is in operation. Otherwise, the printer may be damaged.
- Do not activate the printer with the ink tube not connected to the print head. Otherwise, the printer may be damaged.
- Make sure that no flushing foam extends off the outboard end portions of the flushing receiver. If it sticks out of the end
 portions, it may interfere with any nozzles and may result in non-ejection of ink-jet droplets.
- Do not turn off the power because if you do so, the machine mail fail because necessary maintenance operations are not performed.

<TIPS>

- If the printer is activated after having been off for a long time
 - For the GTX pro, the maintenance operation including white ink circulation will be performed for up to 40 minutes.
 - For the GTX pro Bulk, the maintenance operation including white ink agitation will be performed for up to four hours depending on the length of the time for which the printer is powered off.

4-2-2. Turning off the power

When you need to turn off the power

Turn off the power in the following cases.

- When the front cover needs to be opened for maintenance of the printer, etc.
- When moving the printer elsewhere.
- In the event that the power supply interruption is anticipated in advance, including the case where a planned power outage is scheduled.

<IMPORTANT>

• When you want to move the printer, perform [Printer transport preparation] before doing so. Otherwise, the print head may fail to eject ink-jet droplets due to the vibration during transport. F 4-5. Moving the printer >>P.61

How to turn off the power

(1) Press the power button for a short time (Release your finger when a beep sounds).

If the printer is operating, wait for it to finish.

(2) Cleaning will start at the end of the print job. Then the power will be turned off.

<IMPORTANT>

 No cleaning will be performed at the end of the print job to keep the print heads in good condition, if you open the front cover before turning the power off or disconnect the AC power cable. In these cases, the print heads may fail to eject ink-jet droplets. For this reason, be sure to activate the printer once again and perform the head cleaning after activation.

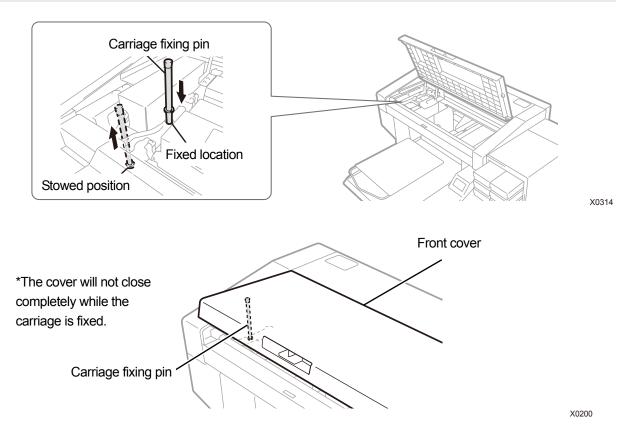
Installation and preparation

4-2-3. When there is no prospect of electric power recovery for a while due to power outage

(1) Open the front cover and move the carriage to the left, and stop it at the position where the left side of the carriage

reaches the end. The position of the print head and the cap should match. Returning the print heads to the cap position prevents them from drying up.

- (2) Insert the carriage fixing pin into its specified hole, and fix the carriage to the cap position. <TIPS>
 - Note that the carriage fixing pin is housed in the area on the left side of maintenance unit.
 - The front cover will not close completely if the carriage is fixed with the carriage fixing pin.

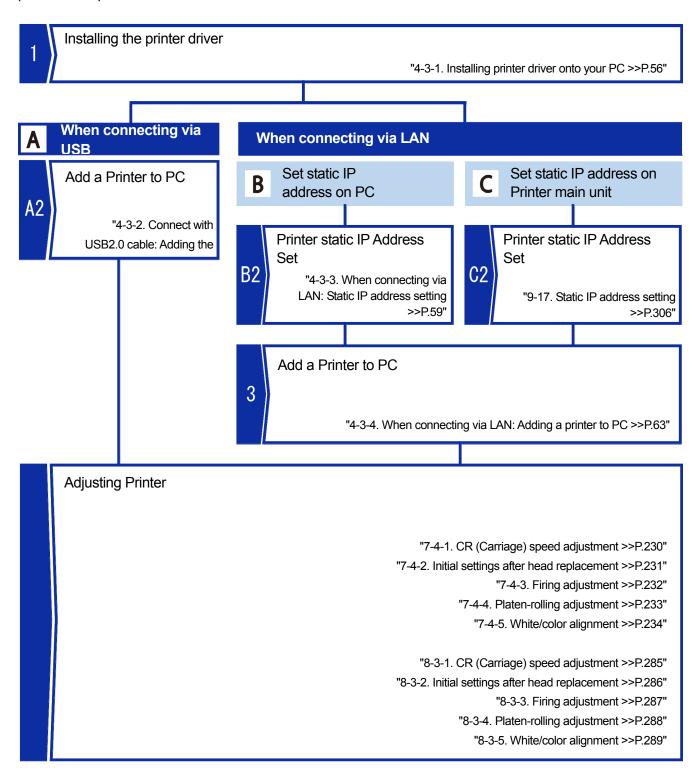


- (3) When the current state is brought to an available condition to turn on the power, pull out the carriage fixing pin, return it to its stowed position and reactivate the printer. <IMPORTANT>
 - For this reason, be sure to activate the printer once again and perform the head cleaning after activation.

4-3. Connection between Printer and PC (for Windows)

This chapter provides information about the procedures to install the GTX pro printer driver onto your PC and connection method of the printer to PC.

For Windows 8.1 and 10, different dialog boxes may be displayed. Proceed with the next step while checking each procedural step.



4-3-1. Installing printer driver onto your PC

To begin with, on your PC, install the printer driver for file output, "Brother GTX pro FileOutput". At this stage, do not connect the printer to your PC yet. <TIPS>

- You must log into your PC with administrator privileges.
- (1) Activate the PC.
- (2) Complete all of the current sessions.
- (3) Double-click on the "setup.exe" to execute the installer.
- (4) Then, the installation procedures will begin. Follow the on-screen instructions to complete the installation.
- (5) When the dialog box shown below appears, click [Install].

E Windows Security		×
Would you like to install this device software?		
Name: Brother Printers Publisher: Brother Industries, Ltd.		
Ltd.".	<u>I</u> nstall	Do <u>n</u> 't Install
You should only install driver software from publishers y device software is safe to install?	ou trust. How o	can I decide which

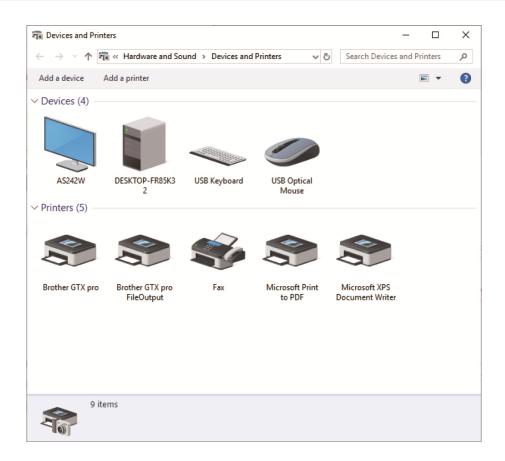
(6) After the installation is completed, reactivate the PC.

4-3-2. Connect with USB2.0 cable: Adding the printer to the PC

(1) Once you have installed the printer driver, with the printer powered on, make a connection with a USB 2.0 cable between the printer and your PC.

<TIPS>

- For this connection of the USB cable, secure it in place by means of the cable clamp as required.
- (2) Follow the on-screen instructions to complete the installation.
- (3) After the installation is completed, open [Devices] > [Devices and Printers] from [Settings].
 <TIPS>
 - In the case of Windows 8.1, select the [View devices and printers] from [Control Panel].



- (4) Right-click the "Brother GTX pro" icon or the "Brother GTX pro FileOutput" icon for file output, and select the [Set as default printer].
- (5) If LAN connection is required, perform static IP address setting on the printer and add the printer to the PC. If connecting only via USB and LAN connection is not required, configuration task on the PC is now completed.

(6) Adjust the carriage speed. Then adjust the printer using "GTX pro Maintenance".

	Menu name	Things to prepare	See the operating procedure with GTX pro Maintenance
1	[CR Speed Adjustment]	_	For GTX pro 7-4-1. CR (Carriage) speed adjustment >>P.230" For GTX pro Bulk 78-3-1. CR (Carriage) speed adjustment >>P.285"
2	[Initial settings after head replacement]	_	For GTX pro 18-3-1. CR (Carriage) speed adjustment >>P.285" For GTX pro Bulk 18-3-2. Initial settings after head replacement >>P.286"
3	[Firing Adjustment]	Black paper or transparent sheet (such as OHP sheet) White paper	For GTX pro☞"8-3-1. CR (Carriage) speed adjustment >>P.285" For GTX pro Bulk☞"8-3-3. Firing adjustment >>P.287"
4	[Platen-Rolling Adjustment]	White paper	For GTX pro☞"8-3-1. CR (Carriage) speed adjustment >>P.285" For GTX pro Bulk☞"8-3-4. Platen-rolling adjustment >>P.288"
5	[White/Color Alignment]	Black paper or pretreated black or dark color T-shirt	For GTX pro☞"8-3-1. CR (Carriage) speed adjustment >>P.285" For GTX pro Bulk☞"8-3-5. White/color alignment >>P.289"

What to do in the White Ink Pause Mode (for GTX pro only)

For the White ink pause mode, perform the following steps using the maintenance tool.

	Menu name	When in White Ink Pause Mode
1	[CR Speed Adjustment]	Performed
		Performed for color head only
		Upon completion of color head
2	[Initial actions offer board replacement]	setting, click [Cancel] to close the
2	[Initial settings after head replacement]	maintenance tool once and then start
		it. Then proceed to the following
		steps.
		Performed for color head only
	[Firing Adjustment]	Upon completion of color head
3		setting, click [Cancel] to close the
5		maintenance tool once and then start
		it. Then proceed to the following
		steps.
4	[Platen-rolling adjustment]	Performed
5	[White/Color Alignment]	Not required
6	[Setting of the time displayed on the nozzle check pattern]	Performed

4-3-3. When connecting via LAN: Static IP address setting

When connecting via LAN, Printer static IP address needs to be obtained beforehand. There are two ways to set a static IP address for the printer: from the PC and from the printer. For information on the setting from the printer, see Chapter 8. ""9-17. Static IP address setting >>P.306"

<TIPS>

- If the PC cannot recognize the Printer, a correct static IP address might not be assigned. "4-3-4. When connecting via LAN: Adding a printer to PC >>P.63" Consult your administrator.
- With the printer powered on, make a connection with a USB 2.0 cable between the printer and your PC.
 <TIPS>
 - For this connection of the USB cable, secure it in place by means of the cable clamp as required.
- (2) From [All Programs] in the Start menu, select the "GTX pro Maintenance" from "Brother GTX pro Tools".
- (3) After the window shown below appears, select the [IP Address Set] and click [Next].

	Brother GTX pro 🗸 Search
Sele	ect an item from the menu below and click "Next".
	Perform this setting when replacing the head or when setting up the printer only.
	O Firing Adjustment Adjust this setting when the edges of the print look vague, solid areas are not even, or after a Print Head is replaced.
	 Platen-rolling adjustment Make adjustments when horizontal stripes (banding) occur in the printed image. Use this adjustment as a troubleshooting method when other items such as proper temperature and humidity have already been verified. White/Color Alignment Adjust when white print does not align with color print.
	Set an IP Adrress Assign a static IP address to the printer.
	O Log Data Retrieval Execute if there was a request after troubleshooting service.
	Setting of the time displayed on the nozzle check pattern This is not necessary if you have configured the scheduled time for white ink circulation.
	O Set the scheduled time for white ink circulation

(4) Select the desired IP address setting method and click [Next].

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P Brother GTX pro Maintenance	×
Step 1:	
Select the method of setting the IP address.	
Manually enter the IP address	
O Automatically acquire the IP address	
< Back Ne	ext > Cancel

If you selected "Manually enter the IP address"

(5) Enter each of the pre-determined values of the printer for [IP Address], [Subnet Mask] and [Default Gateway], and click [Next]. (One instance of each value is cited as shown in the window below.)

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Brother GTX pro Mainte	nance	×
Step 2: Input IP address.		
Input IP address, Subnet M	ask and the default Gateway to the printer.	
IP Address	192 . 168 . 0 . 2	
Subnet Mask	255 . 255 . 255 . 0	
Default Gateway	0.0.0	

If you selected "Automatically acquire the IP address"

- (5) Enter the host name to be set for the printer and click [Next].
 <TIPS>
 - The host name can contain up to 31 characters.

	enance	
Step 2:		
Enter the host name.		
Enter the host name to b	associated with the printer.	
Host name :	GTXpro	
Host name :	Graphi	
Press "Next" to automatic	lly acquire the IP address.	
	< Back	Next > Cancel

(6) When [IP address was successfully assigned to Printer.] is displayed, the process is complete. If there is any error in each of the values you have entered for the static IP Address, Subnet Mask and Default Gateway, an error message to inform you thereof accordingly will appear. In this case, correct the error and attempt the process again.

Step 3:		
IP address was assigned.		
IP address was successfully assigned to the Pri	inter.	

4-3-4. When connecting via LAN: Adding a printer to PC

(1) Connect your PC with the printer by means of the LAN cable to make a network connection, and power on the printer.

<TIPS>

- For this connection of the LAN cable, secure it in place by means of the cable clamp as required.
- (2) Select [Settings] > [Devices] > [Devices and Printers].

<TIPS>

• In the case of Windows 8.1, select the [View devices and printers] from [Control Panel].

(3) Click the [Add a printer].

Devices and Print	ters			_		×
← → · ↑ ₹	🕯 « Hardware and So	und > Devices and	Printers 🗸 Č	Search Devices and	Printers	Q
Add a device	Add a printer				-	0
∨ Devices (4)						
		\checkmark				
AS242W	DESKTOP-FR85K3 2	USB Keyboard	USB Optical Mouse			
∨ Printers (5)						
		Ś				
Brother GTX pro	Brother GTX pro FileOutput	Fax	Microsoft Print to PDF	Microsoft XPS Document Writer		
	, neodpa					
9 ite	ems					

- (4) Select [The printer that I want isn't listed].<TIPS>
 - In the case of Windows 8.1, select [The printer that I want isn't listed] -> [Add a local printer or network printer with manual settings], then click [Next].

	-		×
Add a device			
Choose a device or printer to add to this PC No devices found			
]
The printer that I want isn't listed			
	Next	Can	cel

~

(5) Select [Add a local printer or network printer with manual settings], then click [Next].

.....

👼 Add Printer	^
Find a printer by other options	
O My printer is a little older. Help me find it.	
○ Select a shared printer by name	
Browse	
Example: \\computername\printername or http://computername/printers/printername/.printer	
○ Add a printer using a TCP/IP address or hostname	
O Add a Bluetooth, wireless or network discoverable printer	
Add a local printer or network printer with manual settings	
Next Cancel	
	Find a printer by other options My printer is a little older. Help me find it. Select a shared printer by name Example: \\computername\printername or http://computername\printers/printername/.printer Add a printer using a TCP/IP address or hostname Add a Bluetooth, wireless or network discoverable printer Add a local printer or network printer with manual settings

(6) Select the [Create a new port], then select [Standard TCP/IP Port] for [Type of port], and finally click [Next].

			×
←	🖶 Add Printer		
	Choose a printer port A printer port is a type of connect	ion that allows your computer to exchange information with a printer.	
	O Use an existing port:	LPT1: (Printer Port)	1
	Create a new port:		
	Type of port:	Standard TCP/IP Port	1
		Next Cancel	

(7) In the [Hostname or IP address] field, enter the already-setup static IP address of the printer, uncheck the [Query the printer and automatically select the driver to use], and click [Next]. (One instance of each value is cited as shown in the window below.)

🖶 Add Printer	
Type a printer hostnam	ne or IP address
Device type:	TCP/IP Device
Hostname or IP address:	192.168.0.2
Port name:	192.168.0.2
Query the printer and auto	matically select the driver to use

<TIPS>

(

If you set the printer's IP address by automatic acquisition, you must check the IP address of the printer in advance. You can confirm the IP address by selecting [Confirm network setting] -> [IP Address] from the menu. Image: "9-25. Confirm network setting >> P.311".

Cancel

×

Next

- If you are using a DNS server, you can use a host name and domain name instead of the IP address. Enter the host name of your choice. " "4-3-3. When connecting via LAN: Static IP address setting >>P.59" As for the domain name, check with your network administrator.
- (8) Then, the detection window of TCP/IP port appears, and the current window will automatically go to the additional port information window after the detection is completed.
- (9) After the window shown below appears, select the [Custom] in the [Device Type], and click [Settings].

	🖶 Add Printer				
Additional port information required					
	 The device is t The network is The device is p The address or If you think the address 	connected. roperly configured. In the previous page is Idress is not correct, cl rm another search on			
	Device Type				
	◯ Standard	Generic Network Car	rd		\sim
	Oustom	Settings			
				Next	Cancel

(10) In the [Protocol], select the [LPR], enter "BINARY_P1" in [Queue Name] of the [LPR Settings], and click [OK].

When the current screen goes back to the previous screen, click [Next].

.

onfigure Standard TCP/IP Port	Monitor
ort Settings	
Port Name:	192.168.0.2
Printer Name or IP <u>A</u> ddress:	192.168.0.2
Protocol	
⊂ <u>R</u> aw	€ LPR
- Raw Settings	
Port <u>N</u> umber:	9100
LPR Settings	
Queue Name:	BINARYP1
LPR Byte Counting Enab	led
<u>SNMP Status Enabled</u>	
<u>C</u> ommunity Name:	public
SNMP <u>D</u> evice Index:	1
	OK Cancel

(11) After the window shown below appears, click the [Have Disk].

÷	🖶 Add Printer	~
	Install the printer driver	
	Choose your printer from the list. Click Windows Update to see more models.	
	To install the driver from an installation CD, click Have Disk.	
	Manufacturer E C Microsoft This driver has an Authenticode(tm) signature. Windows Update Have Disk	
	Tell me why driver signing is important	
	Next Can	cel

(12) Click the [Browse], select the "64bit_OS" folder in the installer according to the PC's OS (64 bit version).

.....

After the file path appears, click [OK].

.



(13) Make sure that a list of printer drivers is shown for the selected folder.

After that, click [Next].		
		\times
÷	Add Printer	
	Install the printer driver	
	Choose your printer from the list. Click Windows Update to see more models.	
	To install the driver from an installation CD, click Have Disk.	
	Printers	1
	Brother GTX pro	J
	This driver has an Authenticode(tm) signature. Windows Update Have Disk <u>Tell me why driver signing is important</u>	
	Next Cancel	

(14) After the window shown below appears, select the [Replace the current driver], and click [Next].

		×
÷	H Add Printer	
	Which version of the driver do you want to use?	
	Windows detected that a driver is already installed for this printer.	
	O Use the driver that is currently installed (recommended)	
	Replace the current driver	
	Next Cancel	I

Cancel

Next

(15) Enter [Printer name], and click [Next].

.

←	🖶 Add Printer		×
	Type a printer na	ame	
	Printer name:	Brother GTX pro (LAN)	
	This printer will be ins	talled with the Brother GTX pro driver.	

(16) Then, the specified printer will be added to the system, following which the window shown below appears, select the [Do not share this printer], and click [Next].

type a new	haring to share this one. The shar						the suggeste	ed name or
type a new							the suggeste	ed name or
	one. The shar		e visible c	o other net	WOIK USEI	2.		
		and the second se						
Do not s	hare this print	er						
Share th	is printer so th	at others on	your netw	/ork can fir	nd and use	it		
Shar	e name:							
Loca	tion:							
<u>C</u> om	ment:							
							Next	Cancel

(17) Click [Finish]. This exits the setting for the PC.

<TIPS>

٠

• •

If the PC cannot recognize the Printer, a correct static IP address might not be assigned. Consult your administrator.

.

		×
÷	Hand Add Printer	
	You've successfully added Brother GTX pro (LAN)	
	To check if your printer is working properly, or to see troubleshooting information for the printer, print a test page. Print a test page	

Finish

Cancel

(18) Adjust the carriage speed. Then adjust the printer using "GTX pro Maintenance".

.....

	Menu name	Things to prepare	See the operating procedure with	
			GTX pro Maintenance	
1	[CR Speed Adjustment]	_	For GTX proser 7-4-1. CR (Carriage) speed adjustment >>P.230" For GTX pro Bulkser 8-3-1. CR (Carriage) speed adjustment >>P.285"	
2	[Initial settings after head replacement]	_	For GTX prose"8-3-1. CR (Carriage) speed adjustment >>P.285" For GTX pro Bulkse"8-3-2. Initial settings after head replacement >>P.286"	
3	[Firing Adjustment]	Black paper or transparent sheet (such as OHP sheet) White paper	For GTX pro "8-3-1. CR (Carriage) speed adjustment >>P.285" For GTX pro Bulk "8-3-3. Firing adjustment >>P.287"	
4	[Platen-Rolling Adjustment]	White paper	For GTX proser"8-3-1. CR (Carriage) speed adjustment >>P.285" For GTX pro Bulkser"8-3-4. Platen-rolling adjustment >>P.288"	
5	[White/Color Alignment]	Black paper or pretreated black or dark color T-shirt	For GTX pros "8-3-1. CR (Carriage) speed adjustment >>P.285" For GTX pro Bulk "8-3-5. White/color alignment >>P.289"	
6	[Setting of the time displayed on the nozzle check pattern]	_	For GTX pro "8-3-1. CR (Carriage) speed adjustment >>P.285" For GTX pro Bulk "8-3-6. Setting of the time displayed on the nozzle check pattern >>P.290"	

What to do in the White Ink Pause Mode (for GTX pro only)

For the White ink pause mode, perform the following steps using "GTX pro Maintenance".

	Menu name	When in White Ink Pause Mode
1	[CR Speed Adjustment]	Performed
		Performed for color head only
		Upon completion of color head
2	[Initial settings after head replacement]	setting, click [Cancel] to close the
2		maintenance tool once and then start
		it. Then proceed to the following
		steps.
		Performed for color head only
		Upon completion of color head
3	[Firing Adjustment]	setting, click [Cancel] to close the
5		maintenance tool once and then start
		it. Then proceed to the following
		steps.
4	[Platen-rolling adjustment]	Performed
5	[White/Color Alignment]	Not required
6	[Setting of the time displayed on the nozzle check pattern]	Performed

4-4. Connection between Printer and PC (for Macintosh)

This chapter provides information about the procedures to install the GTX pro printer driver and connection method of the printer to the PC. You can connect the printer to your PC using either a USB cable or a LAN cable.

-Using a LAN cable -> P.75"

4-4-1. Installing printer driver onto your PC

To begin with, onto your PC, install the printer driver for file output, Brother GTX pro FileOutput. At this stage, do not connect the printer to your PC yet.

<TIPS>

- You must log into your PC with administrator privileges.
- (1) Activate the PC.
- (2) Complete all of the current sessions.
- (3) Double-click on the "BrotherGTX pro_ver***.pkg" to execute installer.
- (4) Then, the installation procedures will begin. Follow the on-screen instructions to complete the installation.
- (5) After the installation is completed, reactivate the PC.

4-4-2. Connecting the printer to your PC via a USB 2.0 cable

- (1) With the printer powered on, make a connection of USB 2.0 cable between the printer and your PC.
- (2) From the Apple menu, open the [System Preferences] and click on the [Printers & Scanners].
 - ••• < > == System Preferences Sign in to your Apple ID Set up iCloud, the App Store, and more. Sign In 20) . Ner 00.00 Ø :: 0 (X 2 69 9 ۲ ٠ Energy Saver
- (3) After that, click the + button in the lower-left corner.
 - Image: Constraint of the sector o
- (4) Select the [Brother GTX pro xx] first, then click on the [Select Software...] of [Use].

	0.0
s 🧐 💳	Q, Search
ault IP Windows	Search
Name	× Kind
Brother GTX pro	USB
Name: Brother GT	TX pro 3
Name: Brother GT	TX pro 3
	TY are
Location:	TV CTX pro
Location: Use: VBrother	TV CTX pro

(5) Select the [Brother GTX pro] and click on the [OK].



.

(6) Then, click [Add].



(7) In the [Default printer], select either [Brother GTX pro xx] or [Brother GTX pro FileOutput]. This exits the setting for the USB connection.



4-4-3. Connecting the printer to your PC via a LAN cable

When you connect your Macintosh to the printer via a LAN cable, configure the IP address settings for the printer, referring to the Instruction Manual.

Subsequently, perform the procedures below to add the printer to your PC.

- (1) Connect your PC with the printer by means of the LAN cable to make a network connection, and power on the printer.
 - <TIPS>
 - For this connection of the LAN cable, secure it in place by means of the cable clamp as required.
- (2) From the Apple menu, open the [System Preferences] and click on the [Printers & Scanners].



(3) After that, click the + button in the lower-left corner.

Printers Brother GT-3 FileOutput Ide Brother GT-3 USB • Offline Brother GTX pro • Offline, Default		Brother GTX pro F Open Print Quer Options & Suppl	JØ
Control of the off off off off off off off off off of	Location: Kind: Status:	Brother GTX pro Idle	
+	☑ Share this print	er on the network Printer sharing is turne	Sharing Preferences
-	Default printer:	Brother GTX pro	0
	Default paper size:	A4	0
Click the lock to make change	s.		?

(4) Select [IP].

	-	Q Search		
aul IP /	Vindows		Search	
Address:				
	Enter host name or	r IP address.		
Protocol:	Line Printer Da	emon - LPD		۵
Queue:				
100000000000000000000000000000000000000				
	Leave blank for de	fault queue.		
	Leave blank for de	fault queue.		
	Leave blank for de	fault queue.		
	Leave blank for de	fault queue.		
	Leave blank for de	fault queue.		
Name:	Leave blank for de	fault queue.		•
Name: Location:	Leave blank for det	fault queue.		•
Name: Location:	Leave blank for det	fault queue.		© Add

(5) In the [Address], enter the IP address of the printer you have just set up.

Select the [Line Printer Daemon - LPD] of [Protocol].

In the [Queue], type in the word "BINARY_P1".

Enter the name of the printer in the [Name].

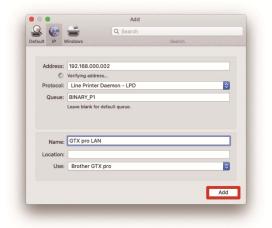
Click on the [Select Software...] of [Use].



(6) Select the [Brother GTX pro] and click on the [OK].

000	Prir	nter Software		
		Q gtx p		0
Brother GTX pro				
				-1
		C	ancel	K

(7) Then, click [Add].



(8) Then, the current window goes back to the [Printers & Scanners] window into which the GTX pro printer (LAN) is added.

In the [Default printer], select your desired GTX pro printer, as required.

This exits the setting for the LAN connection.



4-5. Moving the printer

<IMPORTANT>

When you want to move the printer, perform [Printer transport preparation] before doing so. Otherwise, the print head may fail to eject ink-jet droplets due to the vibration during transport.

For GTX pro:

- (1) While the printer is in standby mode, press the (MENU) on the operation panel to bring the menu screen into the view.
- (2) From the menu, select [Maintenance] > [Printer transport preparation], and press
- (3) Check the remaining ink in the ink pouch and press

- (4) Once the transport preparation is complete, turn off the power.
- (5) Remove the power plug from the outlet and move the printer.

For GTX pro Bulk:

For help, please contact your dealer.

• Performing the procedure for GTX pro to transport the printer may cause it to fail.

5-1. Types of applications

You can create print data by either "using Brother products" or "using other applications". Select applications to use depending on your needs. You are recommended to use Brother product applications as far as possible. If you want to use other applications, however, you are recommended to use one of the three recommended applications to achieve high-quality print results. This chapter describes the procedures for using other applications.

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Using Brother product

Applications to use	Reference
Graphics Lab	Graphics Lab Instruction Manual

When using other applications

Applications to use	Reference
CorelDRAW(2018/2019)	"5-3-1. When using CorelDRAW >>P.82"
Adobe Photoshop(CC2020/CC2019)	"5-3-2. When using Adobe Photoshop >>P.90"
Adobe Illustrator(CC2020/CC2019)	"5-3-3. When using Adobe Illustrator>>P.95"

<TIPS>

Make proper settings, such as color settings and printing conditions, of each application, in accordance with the setting contents
of the application.

 In this chapter, the value RGB=(254,254,254) is described as "RGB=254", and the value RGB=(255,255,255) is described as "RGB=255".

About color mode (color space)

The GTX pro printer is a printer of RGB type.

Be sure to create image data in RGB mode, and always set the color space (input) you use for such data to sRGB (sRGB IEC61966-2.1).

<TIPS>

- When such application as Adobe and Corel is used, there are instances in which an image in CMYK mode cannot reproduce the color that is intended.
- Even for an image in RGB mode, a similar color reproduction failure occurs when other color space than the specified one, such as Adobe RGB, is used.

About print layout

Specify the platen size that uses the paper size specified in the Print menu, and confirm the print layout. Moreover, use the "Brother GTX pro FileOutput" printer driver for file output, then display and check the print preview. <TIPS>

• In order for a print image to be oriented properly at all times, it is advisable to set the GTX pro printer to the [Set as default printer].

How to create white data

When creating print data with [Color + White Ink] or [White Ink Only], RGB=(255) is treated as "Transparent color", ejecting no ink. For such an image that you wish to print out in pure white color with white ink, make such a setting as RGB=254.

<TIPS>

• The treatment of RGB=255 varies depending on the applications. Configure the settings appropriately.

About ARXP file

Use the "Brother GTX pro FileOutput" printer driver for file output in order to save your print data in the ARXP format. When your print data is saved in the ARXP format, its information and the amount of used ink will be able to be reviewed. <TIPS>

- When performing file output, be sure to use the printer driver, "Brother GTX pro FileOutput". If file output is performed using [Print to file] command that is supplied with each application, there may be some cases where the file extension cannot be saved as .arxp, or the file destination cannot be specified.
- ARX4 files created with the GTX can be printed with the GTX pro.
- The GTX pro printer cannot print out the print data that has been created for the GT-541/GT-782/ GT-3 series.
- If you make a printer driver setting from the Control Panel of your PC, such setting sometimes will not take effect in each application. For this reason, verify that your printer driver has been set up properly before you begin printing.

5-2. Sending print data using Brother GTX pro FileOutput (for Macintosh only)

Saving print data to a file

When using the "Brother GTX pro FileOutput" printer to save print data to a file, be sure to perform the save operation with the "GTX pro FileViewer" being activated.

If you try to output and save the data to a file without activating the "GTX pro FileViewer", an error shown below will occur and the file cannot be saved to the system.

<TIPS>

• Not all applications display an error message. If that is the case, start the "GTX pro FileViewer" and try again.



<TIPS>

• The procedures to output a file from the "Brother GTX pro FileOutput" are the same as those for Windows PC.

Transmission of print data

Send such print data that has been saved using the "Brother GTX pro FileOutput" printer to the printer by performing the procedures mentioned below.

- The procedures to send the print data are the same as those for Windows PC.
- (1) Double-click on a file with the extension ".arxp" assigned to its filename which has been saved by means of the "Brother GTX pro FileOutput" printer.
- (2) Subsequently, the "GTX pro FileViewer" starts working, then, under that condition, click on the [Send to Printer], which results in the file transmission.

5-3. Using other applications

5-3-1. When using CorelDRAW

First of all, perform the following procedures:

- Color setting
- Print size

As required, perform the following procedures:

- Create print data (ARXP file)
- Use the color palette in Useful Tools.
- Convert data to bitmap image data
- Replace RGB=255 in bitmap image data with RGB=254

<TIPS>

For this printer, it is recommendable to use CorelDRAW 2018/2019. The display screen is described assuming CorelDRAW 2019.

Color management settings

- (1) In the menu bar, select [Tools] > [Color Management].
- (2) Establish the settings of [Color Management Settings] as follows:
 - [RGB profile]: [sRGB IEC61966-2.1]
 - [Primary color mode]: [RGB]
 - [Rendering intent]: [Relative colorimetric]

	agement Settings				
Default					
					^
	Preset:	Custom		П	
	RGB profile:	(Default) sRGB IEC61966-2.1		-	
	CMYK profile:	(Default) U.S. Web Coated (SWOP)	/2	-	
	Grayscale profile:	(Default) Dot Gain 20%		-	
	Primary color mode:	RGB		*	
	Rendering intent:	Relative colorimetric		*	
	Color conversion —				
	Color engine:	Microsoft ICM CMM		*	
		Preserve pure black			
		 Map gray to CMYK black 			~
			OK	Can	cel

Print size

- (1) In the menu bar, select [File] > [Print].
- (2) Set the [Printer] to either "Brother GTX pro" or "Brother GTX pro FileOutput", click on [Apply], and close the [Print] dialog box.

<TIPS>

If [Printer] is set to "Brother GTX pro", the print data at the time of printing will be sent to the printer.
 If [Printer] is set to "Brother GTX pro FileOutput", the print data at the time of printing will be saved as an ARXP file.

.

ieneral	Color	Composite	Layout	Prepress	PostScript	No Issues
Destination	1					
Printer:	Brot	her GTX pro			¢.	
Orientation	: Mat	ch orientation (L	etter, Portra	it) "	Use PPD	
Status:						
Location:					Print to fi	e
Comment:					Single File	-
Print range	<u>.</u>			Copies		
• Current				Number of a	copies:	1 🗘
O Current	page	O <u>S</u> election	on			
O Pages:		1		11 22	33	Collate
		Even & Odd	÷			
				Print as bit	map: 300	🗘 dpi
						- upi
						- upi
Print style:	Corel	IDRAW Defaults			• 000	Sa <u>v</u> e As
Print style:	Corel	DRAW Defaults				

(3) In the menu bar, select [Layout] > [Page Layout].

- (4) Make the following settings in the [Page Size] window:
 - [Size]: [Custom]
 - [Width]: 14.0 in. (355.6 mm)
 - [Height]: 16.0 in. (406.4 mm)
 - Page orientation: Portrait
 - <TIPS>
 - Set the width and height to the size of platen to be used. ST5-4-1. Select the platen size >>P.103". The above size is the standard 14X16 platen size.

ocument Options)
General Page Size Layout Background	Page size Label presets Size and orientation Size Custom	
Guidelines Grid Rulers Save	Width 355.6 ↓ millimeters ↓ Height 406.4 ↓ □ □ Apply size to current page only ✓ Show page border	
	Rendering resolution: Bleed: 4.0 Show bleed area	
? Save as Default	ОК	Cancel

Create print data (ARXP file)

Save the image data and print settings as a set of print data in ARXP file format.

The following will be made available if the print data is converted into an ARXP file:

- Image data and print settings can be put together and stored.
- Without connection to a PC, the printing can be performed directly from a USB flash memory unit.

- Image editing is unavailable for any ARXP file. As such, save your image data for an editing purpose in advance.
- For file output, there are some cases where neither file output destination nor extension cannot be specified by the [Print to file] command. Be sure to use the printer driver "Brother GTX pro FileOutput".
- For details of directly sending data to the Printer from an application ""6-6-2. Sending print data from applications >> P.169".

- (1) In the menu bar, select [File] > [Print].
- (2) Open the [Color] tab, and make the following settings:
 - Place a checkmark in the [Document color] checkbox.
 - [Color conversions]: "Brother GTX pro" or "Brother GTX pro FileOutput"
 - [Color profile]: [sRGB IEC61966-2.1]
 - [Rendering intent]: [Relative colorimetric]

s color f pro FileOutput colors to RGB 56-2.1 GB numbers	
color f pro FileOutput r ot colors to RGB 56-2.1	
f pro FileOutput ot colors to RGB	
pro FileOutput v r ot colors to RGB 56-2.1 v	
ot colors to RGB	
ot colors to RGB	
56-2.1	
GB numbers	
one traitine sta	
ure <u>b</u> lack	
rimetric	
s dialog box are set for the Windows e General tab.	
r	imetric vialog box are set for the Windows

- On [General] tab, select [Printer] and select "Brother GTX pro FileOutput" for file output.
 <TIPS>
 - If the specified [Printer] is set to "Brother GTX pro ", the print data will be sent to the printer.
 If the specified [Printer] is set to "Brother GTX pro FileOutput", the print data will be saved as an ARXP file.
- (4) On [Preferences], create your settings of printer driver. "5-4. Set up the printer driver >> P.101".

When you press [OK] in the [Print] dialog box, the dialog box shown below will be displayed. After that, click [Save]. <TIPS>

• There may be cases where this saving process takes several minutes.

Brother GTX pro File Output I	Preview window	- 0
Job Name : Date :	IMG_1404 20/01/2020 19:28	-7.0 0 7.0
Platen Size :	14x16	
Select Ink :	Color+White Ink	
Highlight :	5	
Mask :	3	
Print Time :	x 10	
Whiteness :	400 %	- In the second s
Use background black color :	Off	
Color Multiple Pass Printing :	Off	
Details		
Color Ink :	0.06 cc	8.0 -
White Ink :	0.20 cc	100%
Print :	1 piece	
		Present Layer 1 W+CMYK 💌 🗆 White Data
Save Close		Background Color Change

(5) Specify the [Save In] and [File name] first, then click [Save] to save the ARXP file to your PC.

What to do when using the color palette in Useful Tools

- (1) Save the color pallet files for CoreIDRAW, "GT_Colors.xml" and "GT_Tshirts.xml", on your PC, following the instructions on screen.
- (2) In the menu bar, select [Window] > [Color Palettes] > [Open Palette].
- (3) Select the files having such filename as "GT_Colors.xml" and "GT_Tshirts.xml", respectively.

<TIPS>

• Do not use any color from the color sample palette, such as HKS and Pantone. Otherwise, an on-screen color may differ from the resulting print color.

Convert data to bitmap image data

- (1) In the menu bar, select [Bitmaps] > [Convert To Bitmap].
- (2) Set the [Color mode] to [RGB Color].
 - <TIPS>
 - When the white ink is used for performing the printing, unmark the [Anti-aliasing] checkbox.

Convert To Bitmap	0	X
Resolution: 300	💌 dpi	
Color mode: R	GB Color (24-bit)	*
Dithered	rint <u>b</u> lack	
Options <u>Anti-aliasing</u> <u>Transparent b</u> 	ackground	
Uncompressed file	tana a sa sa sa sa	
7	OK	Cancel

<TIPS>

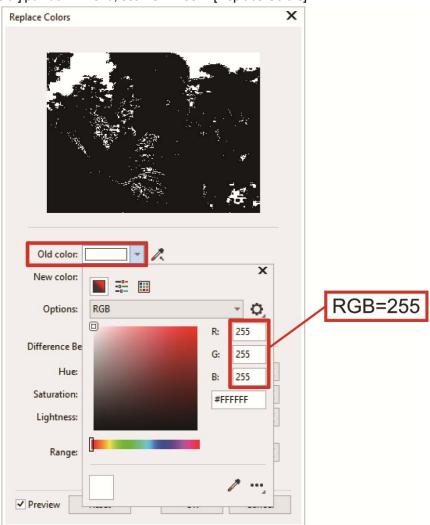
• Even when the platen size to be used has been selected from the printer driver, the current setting in [Page Layout] may change to [Settings from printer].

In the [Page Layout], be sure to change the width and the height according to the size of the platen.

Replace RGB=255 in bitmap image data with RGB=254

RGB=255 is identified as a transparent color. In a portion where RGB=255 is contained, no ink will be ejected. In order for the white ink to be printed, select an area for RGB=255, and replace it with RGB=254. To make such replacement, use the method mentioned below.

- (1) In the menu bar, select [Effects] > [Adjust] > [Replace Colors].
- (2) From the [Old color] pull-down menu, set RGB=255 in [Replace Colors].



- (3) In the same manner, set [New color] to RGB=254.
- (4) Set [Range] to "1", and click on the [OK] button.

Replace Colors	х
Old color:	
Options: Ignore grayscale Single <u>d</u> estination color	
Difference Between Colors	
<u>H</u> ue: +++++++ +++++++ 0	
Saturation:	
Lightness:	
<u>R</u> ange: ++++++ ++++++++++++++++++++++++++++]
Preview Reset OK Cancel	

<TIPS>

• For the vector data, change the fill color to RGB=254.

5-3-2. When using Adobe Photoshop

In Photoshop, configure the settings mentioned below:

Color setting

As required, perform the following procedures:

- Create print data (ARXP file)
- Use the color palette in Useful Tools.
- Replace RGB=255 with RGB=254

<TIPS>

- For an image created in the CMYK color mode, select [Image] > [Mode] in the menu bar, and change the color to the RGB color (sRGB). In order to edit an image, select [Image] > [Adjustments] in the menu bar and edit it, or edit it by means of the image quality improvement of the printer driver (\$75.4-9. Set up the image quality >>P.115").
- For this printer, it is recommended to use Photoshop CC2020/CC2019. The display screen is described assuming Photoshop CC2020.

Color setting

- (1) In the menu bar, select [Edit] > [Color Settings].
- (2) Establish the settings of [Color Settings] as follows: [Working Spaces]
 - [RGB]: [sRGB IEC61966-2.1]

[Conversion Options]

- [Engine]: [Adobe(ACE)]
- [Intent]: [Relative Colorimetric]
- [Color Management Policies]
 - [RGB]: [Convert to Working RGB]
 - [CMYK]: [Convert to Working CMYK]
 - [Gray]: [Convert to Working Gray]
 - [Profile Mismatches]: Mark the [Ask When Opening] and [Ask When Pasting] checkboxes.
 - [Missing profiles]: Mark the [Ask When Opening] checkbox.

Color Settings				>
Settings: Custom ~				
Working Spaces	Conversion O	Options		ОК
RGB: sRGB IEC61966-2.1	 Engine: Ad 	dobe (ACE) 🗸 🗸		Reset
CMYK: Japan Color 2011 Coated	 Intent: Rel 	elative Colorimetric 🗸		Load
Gray: Dot Gain 15%	v V	Use Black Point Compensatio		Save
Spot: Dot Gain 15%		Use Dither (8-bit/channel ima	ges)	5446
Color Management Policies		Compensate for Scene-referre	d Profiles	Preview
Convert to Working RGB CMYK: Convert to Working GMYK Gray: Convert to Working Gray Frofile Mismatches: Ask When Opening Ask When Past Missing Profiles: Ask When Opening	□ Blend RGB (ing ☑ Blend Text	ontrols 2 Monitor Colors By: Colors Using Gamma: t Colors Using Gamma: ironized: Your Creative Cloud a synchronized for consistent col		
Description	Ţ			

Create print data (ARXP file)

Save the image data and print settings as a set of print data in ARXP file format. The following will be made available if the print data is converted into an ARXP file:

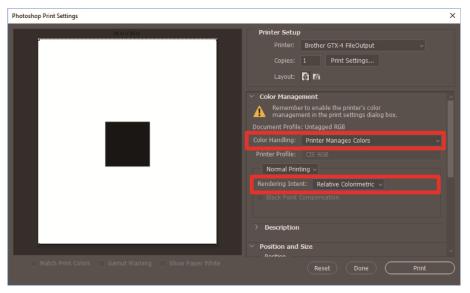
- Image data and print settings can be put together and stored.
- Without connecting to a PC, the printing can be performed directly from a USB flash memory.

<TIPS>

- Image editing is unavailable for any ARXP file. As such, save your image data for an editing purpose in advance.
- For file output, there are some cases where neither file output destination nor extension cannot be specified by the [Print to file] command. Be sure to use the printer driver "Brother GTX pro FileOutput".
- For details of directly sending data to the Printer from an application "6-6-2. Sending print data from applications >> P.169".
- (1) In the menu bar, select [File] > [Print]. If the PC's default printer is either "Brother GTX pro" or "Brother GTX pro

FileOutput", the layout is set to the platen size.

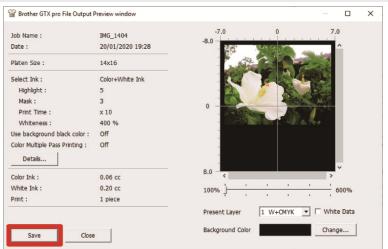
- (2) Make the settings as follows:
 - [Color Handling]: [Printer Manages Colors]
 - [Rendering Intent]: [Relative Colorimetric]



- (3) From [Printer], select "Brother GTX pro FileOutput" for file output. <TIPS>
 - If [Printer] is set to "Brother GTX pro", the print data will be sent to the printer.
 - If [Printer] is set to "Brother GTX pro FileOutput", the print data will be saved as an ARXP file.
- (4) On [Print Settings], make your settings for the printer driver. "5-4. Set up the printer driver >>P.101".

- (5) When you press [Print], the dialog box shown below will be displayed on the screen. After that, click [Save].
 - There may be cases where this saving process takes several minutes.

.



(6) Specify the [Save In] and [File name] first, then click [Save] to save the ARXP file to your PC.

What to do when using the color palette in Useful Tools

- (1) Save the color pallet file for Photoshop, "GT_Colors_T.ase", on your PC, following the instructions on screen.
- (2) In the menu bar, select [Window] > [Swatches].
- (3) Click on the to open the submenu.



(4) From [Replace Swatches], select [Swatch Exchange (*.ASE)] for the type of file and then select the file name [GT_Colors_T.ase].



<TIPS>

• Do not use any color from the color sample palette, such as HKS and Pantone. Otherwise, an on-screen color may differ from the resulting print color.

What to do when replacing RGB=255 with RGB=254

RGB=255 is identified as a transparent color. To a portion where RGB=255 is contained, no ink will be ejected. In order for the white ink to be printed, select an area for RGB=255, and replace it with RGB=254. To make such replacement, use the method mentioned below.

- (1) On the menu bar, select [Layer] > [New Adjustment Layer] > [Selective Color], and create a new layer.
- (2) Set the opacity to 20%, and click [OK].

New Layer		×
Name:	Selective Color 1	ОК
	Use Previous Layer to Create Clipping Mask	Cancel
Color:	🗙 None 🗸 🗸	
Mode:	Normal ~ Opacity: 20 ~ %	

- (3) From the [Selective Color], make the following settings:
 - [Colors]: [Whites]
 - [Black]: 1%
 - Mark the [Absolute] option

Properties		
Selective Color		
Preset: Custom		~
Colors: Whites		
Cyan:	0	
Magenta:	0	
▲ Yellow:	0	
Black:	1	96
 Relative Absolute 		
x ∎ �} <u>+</u>	<u>n</u> o	〕

- The method to replace RGB=255 with RGB=254 as shown above can be used only when the [Color mode] is set to [8 bit] of [RGB Color].
- For Photoshop, the action file "SolidWhite.atn" is made available in Useful Tools, which changes RGB=255 to RGB=254 (
 "5-5-2. Replace RGB=255 with RGB=254 (for Photoshop only) >>P.118"). For how to use it, refer to the Help feature that Photoshop is provided with.

5-5-3. When using Adobe Illustrator

In Illustrator, perform the required procedures mentioned below:

- Color setting
- Open a new file

As required, perform the following procedures:

- Create print data (ARXP file)
- Use the color palette

- Take one of the actions mentioned below, in order to avoid such troubles that no image data is inserted into the print range or part
 of image data is cut off.
 - Before start-up, specify the PC's default printer as the "Brother GTX pro" or the "Brother GTX pro FileOutput".
 - Use the "Brother GTX pro FileOutput" printer driver to output a file, then display and check the print preview.
- For an image created in CMYK color mode, load the image into Photoshop, select [Image] > [Mode] in the menu bar, and change the color to the RGB color (sRGB). In order to edit an image, load the image into the Photoshop, edit it in the form of bitmap data, or edit it by means of the image quality improvement of printer driver (37"5-4-9. Set up the image quality >>P.115").
- For this printer, it is recommended to use Illustrator CC2020/CC2019. The display screen is described assuming Illustrator CC2020.

Color setting

- (1) In the menu bar, select [Edit] > [Color Settings].
- (2) Click on the [More Options].
- (3) Ensure selection of the settings as mentioned below, and click [OK].
 - [Settings]: [Custom]

[Working Spaces]

• [RGB]: [sRGB IEC61966-2.1]

[Color Management Policies]

- [RGB]: [Convert to Working Space]
- [CMYK]: [Convert to Working Space]
- [Profile Mismatches]: Mark the [Ask When Opening] and [Ask When Pasting] checkboxes.

.

• [Missing profiles]: Mark the [Ask When Opening] checkbox.

[Conversion Options]

- [Engine]: [Adobe(ACE)]
- [Intent]: [Relative Colorimetric]

8)		
Color Settings	5	
	nchronized: Your Creative Cloud applications are not synchronized for co pronize, select Color Settings in Bridge.	onsistent color. To
	Settings: Custom v Load	. Save
Working S	paces	
	RGB: sRGB IEC61966-2.1	~
	CMYK: U.S. Web Coated (SWOP) v2	
Color Mana	agement Policies	
	RGB: Convert to Working Space	~
	CMYK: Convert to Working Space	
Profile Mis	matches: 🗹 Ask When Opening 🛛 Ask When Pasting	
Missing	Profiles: 🗹 Ask When Opening	
Conversion	1 Options	
	Engine: Adobe (ACE)	~
	Intent: Relative Colorimetric	~
	Use Black Point Compensation	
(i) Hold the c	ursor over a setting for additional information.	
Less Opti	ons OK	Cancel

Open a new file

- (1) Set up a new document as follows:
 - [Width]: 14.0 in. (355.6 mm)
 - [Height]: 16.0 in. (406.4 mm)
 - [Orientation]: Portrait
 - [Color Mode]: [RGB]

<TIPS>

• Set the width and height to the size of platen to be used. (3-5-4-1. For other applications: Selection of platen size >>P.127) The above size is the standard 14X16 platen size.

More Settings	
Nar	me: Untitled-1
Prof	file: [Custom] ~
Number of Artboar	ds: 1 $2 + 24 + 1$ \rightarrow
Si	ize: [Custom] ~
Wid	ith: 355.6 mm Units: Millimeters ~
Heig	pht: 406.4 mm Orientation: 🎦 🗈
	Top Bottom Left Right ed: 0 mm 0 mm 0 mm 0 mm 0
✓ Advanced	
	de: RGB V
	cts: High (300 ppi) ~
Preview Mo	de: Default ~
Templates	Create Document Cancel

Create print data (ARXP file)

Save the image data and print settings as a set of print data in ARXP file format. The following will be made available if the print data is converted into an ARXP file:

- Image data and print settings can be put together and stored.
- Without connecting to a PC, the printing can be performed directly from a USB flash memory.

- Image editing is unavailable for any ARXP file. As such, save your image data for an editing purpose in advance.
- For file output, there are some cases where neither file output destination nor extension cannot be specified by the [Print to file] command. Be sure to use the printer driver "Brother GTX pro FileOutput".
- For details of directly sending data to the Printer from an application "6-6-2. Sending print data from applications >> P.169".
- (1) In the menu bar, select [File] > [Print] > [Color Management].
- (2) Make the settings as follows:
 - [Document Profile]: [sRGB IEC61966-2.1]
 - [Color Handling]: [Let Illustrator determine colors]
 - [Printer Profile]: [sRGB IEC61966-2.1]
 - [Rendering Intent]: [Relative Colorimetric]

Print				
	Print Preset: C Printer: B PPD:	ustom rother GTX pro FileOutput	> >	4
General ^ Marks and Bleed Output	Color Management Print Method			
Graphics Color Management	Color Handling	e: sRGB IEC61966-2.1 : Let Illustrator determine colors : sRGB IEC61966-2.1		î
		Relative Colorimetric		
	Description			
I 4 1 of 1 I I I I I I I I I I I I I I I I I I				
Setup		Done Print	G	ncel

- (3) From [Printer], select "Brother GTX pro FileOutput" for file output. <TIPS>
 - If [Printer] is set to "Brother GTX pro ", the print data will be sent to the printer.
 If [Printer] is set to "Brother GTX pro FileOutput", the print data will be saved as an ARXP file.
- (4) On the [Advanced], make your settings for the printer driver. "5-4. Set up the printer driver >>P.101".
 <CAUTION>
 - For Adobe Illustrator, set the platen size for the paper size in the Print dialog box in the application. The size or placement of the image may not be set correctly if you make settings in the Print Settings dialog.
- (5) When you press [Print], the dialog box shown below will be displayed on the screen. After that, click [Save].
 - There may be cases where this saving process takes several minutes.

🗃 Brother GTX pro File Output I	Preview window	– 🗆 X
Job Name : Date :	IMG_1404 20/01/2020 19:28	-7.0 0 7.0
Platen Size : Select Ink :	14x16 Color+White Ink	
Highlight : Mask :	5	
Print Time :	x 10	
Whiteness : Use background black color :	400 % Off	
Color Multiple Pass Printing : Details	Off	
Color Ink :	0.06 cc	8.0 <
White Ink :	0.20 cc	100% 600%
Print :	1 piece	
		Present Layer 1 W+CMYK 💌 🗆 White Data
Save Close)	Background Color Change

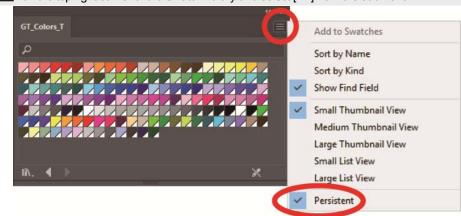
(6) Specify the [Save In] and [File name] first, then click [Save] to save the ARXP file to your PC.

Using Useful Tools

- (1) Save the color pallet file for Illustrator, "GT_Colors_T.ase", on your PC, following the instructions on screen.
- (2) In the menu bar, select [Window] > [Swatches].
- (3) Click on the == , and select [Open Swatch Library] from the submenu.
- (4) Select [Other Library].



- (5) On the [Open] screen, select the file having such filename as "GT_Colors_T.ase".
 <TIPS>
 - Unlike the Photoshop or CoreIDRAW, this Swatch needs to be selected each time a file is opened.
 However, you can fix the Swatch library in the following method to display the screen automatically whenever you start the application if you are using Illustrator CC.



Click e on the top right corner of the Swatch library and select [Fix] from the submenu.

5-4. Set up the printer driver

- The GTX pro printer driver treats RGB=(255) as "Transparent color" and does not eject the ink. For such an image that you wish to print out in pure white color with white ink, make such a setting as RGB=(254).
- For the color replacement method, refer to a relevant page or help menu of each application software .
 "5-3. Using other applications >>P.82".
- (1) By following the printing procedures of each application software, open the print setup dialog box of the printer driver.

or+White Iormal 3	e Ink			~			
2			OB	co-Mode	i i		_
3	5	7	9	11	13		-
					_	5	
	2	3		4	5	3	
Time :	x 1	Wh	iteness	: 400 9	6		
10	20	30	40	50	60		
						20	
10	20	30	40	50	60		
					_	20	
r (for bla	ick T-shir	ts only)					
					De	fault	
	10 10	Time: x 1 10 20 10 20	Time: x1 Wh	Time : x 1 Whiteness 10 20 30 40 10 20 30 40	Time : x 1 Whiteness : 400 5 10 20 30 40 50 10 20 30 40 50	Time : x 1 Whiteness : 400 ½ 10 20 30 40 50 60 10 20 30 40 50 60 10 20 30 40 50 60 10 20 30 40 50 60 for black T-shirts only)	2 3 4 5 3 4 5 3 Time : x 1 Whiteness : 400 % 10 20 30 40 50 60 10 20 30 40 50 60 10 20 30 40 50 60 20 20 30 40 50 60

(2) In the dialog box for setting the printer driver, configure required settings. If you click on the [Advanced], [White Ink Settings], [Color Processing], [Color Balance] and [Uni-Directional Printing] can be configured.

- Depending on the settings you have made in the [Select Ink:] option or the like, setup items that appear on the screen vary.
- The rollover help is displayed in the square portion at the bottom of dialog box. Place the mouse pointer over it to browse the help feature.
- For the detailed description of setup items, refer to each chapter mentioned below.

Vhite Ink Settings									
Transparent Color :		green	(0,19	9,0)				~	Custom
	0	10	20)	30	40		50	
Tolerance :					÷			-	30
Minimum Whiteness :		Normal				0) Spe	cial	
	1							2	1
			-					-	-
Choke Width :	0	1 2	3 4	5	0	78	9	10	2
Color Processing								_	
-	0	10)	20		30		40	
Saturation :								- !	5
Brightness :								-	5
Contrast :		-						-	5
Color Balance	-	-4 -3						-	
Cyan :	-5	-4 -3	-2 -1		1	2 3	4	5	0
				н					
Magenta :								-	0
Yellow :								- !	0
Black :								-	0
Uni-Directional Printing									
stom :									
put RGB values for transpa	rent col	or. Only	one C	Custo	m Col	or is av	ailabl	e.	

- (3) After your settings are completed, click [OK].
 <TIPS>
 - You can refer to each value you have set up here by opening an ARXP file from the "GTX pro File Viewer".

5-4-1. Select the platen size

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From the pull-down menu of [Platen Size:], select a platen size for print area. <TIPS>

• The platen size is equivalent to the paper size.

Setup item	Platen to be used	Size
[16X21]	16X21 platen	16.0 in. x 21.0 in. (406.4 mm x 533.4 mm)
[16X18]	16X18 platen	16.0 in. x 18.0 in. (406.4 mm x 457.2 mm)
[14X16]	14X16 platen	14.0 in. x 16.0 in. (355.6 mm x 406.4 mm)
[10X12]	10X12 platen	10.0 in. x 12.0 in. (254.0 mm x 304.8 mm)
[7X8]	7X8 platen	7.0 in. x 8.0 in. (177.8 mm x 203.2 mm)

Printing Preferences									>
Paper/Quality Main Settin	g								
Platen Size :	14x1 16x2	21				~	Adv	vanced	
Select Ink :	16x1 14x1 10x1 7 x 8	6 2							_
Mode :		omai			UB	co-wode			
White Ink Settings :	1	3	5	7	9	11	13		
Highlight :	_						_	5	
Mask :	1		2	3		4	5	3	
	Print	Time :	x 1	Wh	iteness	400	%		
Fast White Print Mode									
2 Layer White	0	10	20	30	40	50	60	20	
Interval (sec.) :								20	
White/Color Pause Interval (sec.) :	0	10	20	30	40	50	60	20	
Use background black		(for blac	ck T-shi	rts only)		_			_
Color Multiple Pass Pri	nting						D	efault	
Platen Size : Select the size of the plat 16x21 (406.4x533.4mm) 16x18 (406.4x457.2mm)			nt.						
14x16 (355.6x406.4mm) * 10x12 (254.0x304.8mm) 7x8 (177.8x203.2mm)	standa	ard							
								OK	Cancel

5-4-2. Select the ink type

.

.

Setup item	Description
[Color+White Ink]	This option enables a color image to be printed out on the mask layer of white ink.
[White Ink Only]	This option enables the white ink only to be used for printing out a monochrome image.
[Color Ink Only]	This option enables a color image to be printed out on a white background or lighter and
	pale color background.
[Black Ink Only]	This option enables the black ink only to be used for printing out monochrome image.

.....

From the [Select Ink:] option, select a combination of inks to be used.

Printing Preferences									×
aper/Quality Main Settin	g								
Platen Size :	14x	16				~	Adv	vanced	
Select Ink :	_	or+White				~			-
Mode :	Whi Colo	r+White te Ink O r Ink On k Ink On	nly ly			ode			-
White Ink Settings :	1	3	5	7	9	11	13		
Highlight :	-						_	5	
Mask :	1		2	3		4	5	3	
	Print	Time :	x 1	Wh	iteness	: 400 %			
Fast White Print Mode									
2 Layer White	0	10	20	30	40	50	60	20	
Interval (sec.) :								20	
White/Color Pause	0	10	20	30	40	50	60	20	
Use background black	colo	r (for bla	ck T-shi	rts only)					
Color Multiple Pass Pri				its only /			D	efault	
Select Ink : Selects ink combination. Color+White Ink : Prints c White Ink Only : Prints mo Color Ink Only : Prints mo Black Ink Only : Prints mo	noch colo	rome ima r images	ages with on whit	h only wh e or light	ite ink. color m	aterials.			-
Black Ink Only : Prints mo	nochr	ome ima	iges with	n only bla	ick ink.				

5-4-3. Select the mode

If you set [Mode:] to [Eco-Mode], the white ink volume serving as the background is automatically adjusted to reduce the overall ink consumption.

<TIPS>

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• The luminance on the finished print may be slightly reduced depending on the color.

Platen Size :	14x	16				~	Adv	/anced	
Select Ink :	Colo	or+White	e Ink			~			
Mode :	ON	lormal			● E	co-Mode			
White Ink Settings : Highlight :	1	3	5	7	9	11	13	5	
Mask :	1		2	3		4	5	3	
	Print	Time :	x 1	Wh	iteness	: 400 %			
Fast White Print Mode		10	20		40	50			
2 Layer White Interval (sec.) :	0	10	20	30	40	50	60	20	
White/Color Pause	0	10	20	30	40	50	60	20	
Use background black	k color	for blac	ck T-shir	ts only)					
Color Multiple Pass Pri	nting						D	efault	
Mode : Adjust the amount of the overall. However, the level of brig the color.									

5-4-4. Set up the white ink

If you have selected [Color+White Ink] or [White Ink Only] in the [Select Ink:], the setup items for [White Ink Settings:] will appear.

Adjust the white ink volume separately in the [Highlight:] (visible white ink volume) and in the [Mask:] (white ink volume to cover the background color).

Also, set the white ink time in the [Fast White Print Mode], [2 Layer White], and [White/Color Pause].

aper/Quality Main Sett	ing								
Platen Size :	14x	16				~	Adv	vanced	
Select Ink :	Colo	or+White	e Ink			\sim			_
Mode :	O N	lomal			OB	co-Mode			-
White Ink Settings :	1	3	5	7	9	11	13		1
Highlight :	_							5	
Mask :	1		2	3		4	5	3	L
	Print	Time :	x 1	W	iteness	400 1	6		L
Fast White Print Mod	e								
2 Layer White	0	10	20	30	40	50	60		
Interval (sec.) :								20	
White/Color Pause		10	20	30	40	50	60		
Interval (sec.) :	_							20	
Use background blac		r (for bla	ck T-shi	ts only)					
Color Multiple Pass P	rinting						D	efault	
White Ink Settings : You can set "Highlight"	and "M	lask" wł	nen "Col	or+White	e Ink" or	"White	Ink On	v" is	
selected.									

Highlight

This enables you to select whiteness (thickness) of RGB=254 in such nine levels as [1] to [13]. When you increase this value, the White ink volume will increase. You can specify [10] to [13] only if [2 Layer White] is enabled.

Highlight setpoints	Ink volume
[1]	White ink volume 200%
[2]	White ink volume 250%
[3]	White ink volume 300%
[4]	White ink volume 350%
[5]	White ink volume 400%
[6]	White ink volume 450%
[7]	White ink volume 500%
[8]	White ink volume 550%
[9]	White ink volume 600%
[10]	White ink volume 650%
[11]	White ink volume 700%
[12]	White ink volume 750%
[13]	White ink volume 800%

<TIPS>

- Appropriate highlight setting value depends on color or material of the T-shirt. It is recommended to consider and decide on an
 appropriate highlight setting value before creating print data. Perform a highlight check pattern print and select an appropriate
 setting value.
 5-5-6. Print out of highlight check pattern/mask check pattern >>P.122".
- Depending on the settings of [Highlight:] and [Color Multiple Pass Printing], the [Print Time:] and [Whiteness:] will change accordingly.
- [Print Time:] will be set to [X1] if the setup value of [Highlight:] is [5] and [Color Multiple Pass Printing] is turned OFF. With this [X1] serving as a reference value, how many times relates to how long the print time will take when printing.
- Actual ink consumption depends on the actual colors used in the original image. As such, use this number as a reference for ink consumption.

Mask

This enables you to select the volume of white ink which is used as background color for color inks in such five levels as [1] to [5].

Setup value	Description
[1] or [2]	These setup values are suitable for such lighter and pale background colors as pale pink,
	ash and cream.
[3]	This is the default value.
	This value will reproduce the most smooth white-gray-black gradation.
[4]	This value is suitable for vivid background color, e.g. red, purple, green, etc. It also covers
	the strong background colors.
[5]	This value enables the printing with the largest amount of white ink under all colors except
	darker color areas.

<TIPS>

Perform a mask check pattern print and select an appropriate setting value. "5-5-6. Print out of highlight check pattern/mask check pattern >> P.122"

Fast White Print Mode

This option allows high speed printing in the white ink use mode. This does not change the ink amount or concentration. Turn it off if remarkable horizontal stripes are seen.

<TIPS>

- This setting menu will be enabled only if you have selected [Color+White Ink] in the [Select Ink:] settings.
- Selecting [White Ink Only] from [Select Ink:] forcibly switches the printer to the high speed mode.

2 Layer White

You can make highlight settings at a level of [1] to [13] when 2 Layer White is enabled.

Set the time from the start of printing the first white ink layer to the start of printing the second white ink layer. If you set a time shorter than the time it takes to print the first layer, the additional waiting time will be set to 0 seconds.

- <TIPS>
- This setting menu will be enabled only if you have selected [Color+White Ink] or [White Ink Only] in the [Select Ink:] settings.

White / Color Pause

Set the time from the start of printing the previous white ink layer to the start of printing the color ink layer.

If you set a time shorter than the time it takes to print the previous white ink layer, the additional waiting time will be set to 0 seconds.

- This setting menu will be enabled only if you have selected [Color+White Ink] in the [Select Ink:] settings.
- Check this checkbox to activate it when you print a tiny image.
- Tiny images may become black when printed. When that occurs, print a white layer first and wait for a while (waiting time), to print the color layers.

5-4-5. Specify whether or not to use the background black color

If you have selected [Color+White Ink] in the [Select Ink:], the setup items of [Use background black color (for black T-shirts only)] will appear.

In the event that you wish to print a black T-shirt making use of the T-shirt's background black color, mark the [Use background black color (for black T-shirts only)] checkbox.

						_			
Select Ink :	Cold	or+White	Ink			~			
Mode :	0	lomal			● E	co-Mode			
White Ink Settings :	1	3	5	7	9	11	13		
Highlight :	-						_	5	
Mark	1		2	3		4	5	3	
Mask :								3	
	Print	Time :	x 1	Wh	iteness	400 1	6		
Fast White Print Mode									
2 Layer White	0	10	20	30	40	50	60	20	
Interval (sec.) :								20	
White/Color Pause	0	10	20	30	40	50	60	20	
Use background black	c colo	r (for blac	ok T-shir	ts only)	1				
Color Multiple Pass Pri				to only /			D	efault	
Use background black c	olor :					_			
Turn ON this item when p Black (RGB = 0) is autom	rinting			ick mate	rial with	its black	color u	ised.	
Turn OFF this item when				arent co	olor in ad	lvanced	menu.		

5-4-6. Specify whether or not to perform Multiple Pass Printing

If you have selected one of the [Color+White Ink], [Color Ink Only] or [Black Ink Only] in the [Select Ink:], the setup items for [Color Multiple Pass Printing] will appear.

In cases where small and horizontal stripes are highly noticeable in the print result, mark the [Color Multiple Pass Printing] checkbox.

- Even if the [Color Multiple Pass Printing] checkbox is marked, the amount of inks to be consumed will remain unchanged.
- When the [Color Multiple Pass Printing] checkbox is marked, it takes a longer time for the print time to be completed. For typical
 print time, refer to [Print Time:].

per/Quality Main Settin	9								
laten Size :	14x1	6				~	Adv	vanced	
Select Ink :	Color	r+White	e Ink			~			-
Node :		ormal			۰E	co-Mode			
White Ink Settings : Highlight :	1	3	5	7	9	11	13	5	
Mask :	1		2	3		4	5	3	
	Print	Time :	x 2	Wh	iteness	: 400 %	6		
Fast White Print Mode									
2 Layer White	0	10	20	30	40	50	60		
Interval (sec.) :								20	
White/Color Pause	0	10	20	30	40	50	60	20	
Use background black	color	(for bla	ck T-shi	rts only)					
Color Multiple Pass Pri	nting						D	efault	
Color Multiple Pass Printin Color Multiple Pass printin produce finer ink dots. It t	g, for c	color pri onger to	nt data,) print bu	increase It enable	s the nu s better	imber of color pri	platen li nting.	ne feeds to	

5-4-7. Set up the color ink

If you have selected [Color Ink Only] or [Black Ink Only] in the [Select Ink:], the setup items of [Color Ink Settings:] will appear.

In the [Color Ink Settings:] window, you can make your setting from the [Ink Volume:] or [Double Printing:] option.

.

aper/Quality Main Setting Platen Size : 14x16 Select Ink : Color Ink Only Mode : Image: Color Ink Only Mode : Image: Color Ink Settings : 1 2 1 2 1 2 1 2 1 2 1 1 1 2 1 1 1 2 1 1 1 2 1 1 <	Printing Preferences								
Select Ink : Color Ink Only Mode : ONOrmal Coor Ink Only Mode : ONOrmal Coor Ink Settings : 1 2 3 4 5 6 7 8 9 10 10 Ink Volume : 0 1 2 3 1 10 Double Printing : 0 1 1 2 3 1 10 Color Ink Settings : 1 2 3 4 5 6 7 8 9 10 10 Default Color Multiple Pass Printing Default Color Ink Settings : Enables you to set "Ink Volume" and "Double Printing" when "Color Ink Only" or "Black Ink	per/Quality Main Settin	ng							
Mode : Normal Eco-Mode Color Ink Settings : 1 2	Platen Size :	14x16				~	Ad	lvanced	
Color Ink Settings : 1 2 3 4 5 6 7 8 9 10 Ink Volume : 0 1 2 3 1 10 10 Double Printing : 1 2 3 1 1 10 10 Color Multiple Pass Printing 1 0 1 2 3 1 Color Ink Settings : Enables you to set "Ink Volume" and "Double Printing" when "Color Ink Only" or "Black Ink	Select Ink :	Color Ink C	Only			~			_
Ink Volume : 1 1 1 Double Printing : 1 1 1 Color Multiple Pass Printing Default Default Color Ink Settings : Enables you to set "Ink Volume" and "Double Printing" when "Color Ink Only" or "Black Ink	Mode :	Normal			O	Eco-Mo	de		
Double Printing : 1 Color Multiple Pass Printing Default Color Ink Settings : Enables you to set "Ink Volume" and "Double Printing" when "Color Ink Only" or "Black Ink		1 2	34	5	67	8	9 10	10	1
Color Ink Settings : Enables you to set "Ink Volume" and "Double Printing" when "Color Ink Only" or "Black Ink	Double Printing :	0	1		2		3	1	
Color Ink Settings : Enables you to set "Ink Volume" and "Double Printing" when "Color Ink Only" or "Black Ink									
			_						J

Ink volume

This enables you to select the ink volume in such ten levels as [1] to [10].

Setup value	Description
[10]	This is the default value.
	This value corresponds to 100%-cotton fabrics as well as for blended yarn fabrics (hemp
	50%/polyester 50% or cotton 50%/polyester 50%).
[9] to [7]	These values correspond to a thinner T-shirt, thick towel, and cotton products woven with
	twill fabrics.
[6] to [4]	These values correspond to thin and plain fabrics as well as for blended yarn fabrics that
	consist of cotton, polyester and polyurethane.
[3] to [1]	These values correspond to polyester jerseys and synthetic fabrics that have no water
	absorbency.

<TIPS>

• When you print other clothes than a thick T-shirt, check on the actual blurring first, then adjust a value in the [Ink Volume:] option.

Double Printing

Performing the print cycle two times separately will make the printed color stand out more.

Setup value	Description
[0]	No separate processes
[1]	Separate processes (wait time between the 1st and 2nd print cycle)
[2]	Separate processes (longer wait time than the case with setting [1] between the 1st and
	2nd print cycle)
[3]	Separate processes (longer wait time than the case with setting [2] between the 1st and
	2nd print cycle)

<TIPS>

- For the options [1] to [3], the platen will reciprocate two times.
- The higher the setpoint is, the longer the print time will be.

5-4-8. Set up the white ink

If you have selected [Color+White Ink] or [White Ink Only] in the [Select Ink:], this setting menu will be enabled. When you click on the [Advanced] in the [Printing Preferences] dialog box, the setup items of [White Ink Settings] appear.

In the [White Ink Settings], you can make settings for [Transparent Color:], [Tolerance:], [Minimum Whiteness :],and [Choke Width:].

Transparent Color :			. (0. 10						Custom
Inansparent Color :	-	greer	1 (0, 19	9,0)					Custom
	0	10	20)	30	40	Ę	50	
Tolerance :					÷				30
Minimum Whiteness :		Normal				0) Spe	cial	
	1							2	
									1
	0	1 2	3 4	5	6	78	9	10	
Choke Width :									2
Color Processing									
-	0	1(D	20		30		40	
Saturation :		•							5
Brightness :									5
Contrast :		а.							5
Conduct									
Color Balance		-4 -3						_	
	-5	-4 -3	-2 -1		1	2 3	4	5	0
Cyan :									
Magenta :									0
Yellow :				-					0
Black :									0
Uni-Directional Printing									
ansparent Color : lecting a color to make it tra I allows you to select anoth									
ues for custom transparen									

Transparent color

With this option, specify a color which is treated as a transparent color without using any color during the printing process. If you want to specify other colors excluding the RGB=255 as "Transparent color", perform the following procedures to make your setting.

<TIPS>

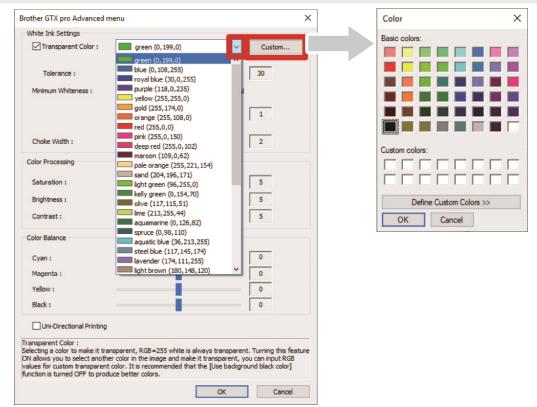
- The RGB=255 is treated as a "Transparent color" (non-printing color).
- You would be better off making [Use background black color (for black T-shirts only)] OFF to produce better colors.
- (1) Click the [Transparent Color:] checkbox.

Then, the pull-down menu for color selection becomes active.

(2) In the pull-down menu, select a color which serves as a background color of T-shirt, or click on the [Custom...] to specify a RGB value.

<TIPS>

 This custom color you have specified is valid only for one color which is specified immediately before. This color cannot be saved in the list.



Tolerance

Specify the gradation range (RGB values) to smoothly connect the zone between "Unprinted color" and "Printed color" to be gradually changed in tone.

- If this value is increased, the gradation range in which the mask white is generated from a state in which no mask white exists will increase.
- The gradation's image quality depends on image data. For this reason, it is advisable to perform a test printing beforehand.

Creating print data

Minimum white ink volume

When printing with [Color+White Ink], the volume of background white color ink for dark or black color ink can be controlled.

When printing with [Color+White Ink], you can increase the amount of the white ink volume used as the base in a dark area by specifying a larger value.

Selecting [Special] allows you to select a value of [3] or higher.

<TIPS>

Larger the value, the more likely that blurring occurs.

White Ink Choke Width

This enables you to select the white ink choke width in such ten levels as [1] to [10]. When you increase this value, the choke width increases. By decreasing the print range of white ink, the white ink will be prevented from extending off from under the color inks.

- Check the original image if white lines and/or dots are seen around the image, this may be caused by "Anti-alias" bitmap.
- There are instances in which fine lines (characters or photographs) will disappear if this level is increased. For this reason, it is
 advisable to perform a test printing beforehand.

5-4-9. Set up the image quality

When you click on the [Advanced] in the [Printing Preferences] dialog box, the setup items of [Color Processing] appear. In the [Color Processing] option, you can make settings for [Saturation:], [Brightness:] and [Contrast:]. Make adjustments to increase vividness, brightness and clarity of an image without using any functions of application software.

Setup item	Description
[Saturation:]	The more vivid the color is, the higher its value.
[Brightness:]	The brighter the color is, the higher its value.
[Contrast:]	Contrast makes the image lighter for lighter colors and darker for darker colors if its value
	increases.

- If a value of [Contrast:] is increased, there may be some cases in which fine lines will disappear.
- For this reason, it is advisable to perform a test printing beforehand when you specify a higher value.

/hite Ink Settings		
Transparent Color :	green (0, 199,0)	~ Custom
	0 10 20 30 40	50
Tolerance :		30
Minimum Whiteness :	Normal Os	pecial
	1	2
	-	1
Choke Width :	0 1 2 3 4 5 6 7 8 9	10
Choke width :		2
olor Processing		
Saturation :	0 10 20 30	40
Brightness :	-	5
Contrast :		5
olor Balance		
	-5 -4 -3 -2 -1 0 1 2 3 4	
Cyan :		0
Magenta :		0
Yellow :		0
Black :		0
	_	
Uni-Directional Printing		
turation : turation increases the color IYK color mode, scanned da	brightness. Use for grayish and colorless ita, etc.	images, artwork create

5-4-10. Set up the color balance

When you click on the [Advanced] in the [Printing Preferences] dialog box, the setup items of [Color Balance] appear. In the [Color Balance], you can make settings for [Cyan:], [Magenta:], [Yellow:], and [Black:]. You can adjust the color in 11 gradations, -5 to +5.

<TIPS>

• If you select [Black Ink Only] for ink selection, you can adjust [Black:] only.

Setup item	Description
[Cyan:]	Adjust the cyan ink volume.
	If you increase its value, the color becomes light bluish overall. If you decrease its value,
	the color becomes reddish overall.
[Magenta:]	Adjust the magenta ink volume.
	If you increase its value, the color becomes reddish-purple overall. If you decrease its
	value, the color becomes greenish overall.
[Yellow:]	Adjust the yellow ink volume.
	If you increase its value, the color becomes yellowish overall. If you decrease its value,
	the color becomes bluish overall.
[Black:]	Adjust the black ink volume.
	If you increase its value, the color becomes blackish overall. If you decrease its value, the
	color becomes whitish overall.

Vhite Ink Settings			
Transparent Color :	green (0, 199,0)	~ Custom	
	0 10 20 30 40	50	
Tolerance :		30	
Minimum Whiteness :	Normal	Special	
	1	2	
		1	
Choke Width :	0 1 2 3 4 5 6 7 8 9	9 10 2	
Color Processing	0 10 20 20	40	
Saturation :	0 10 20 30	40 5	
Brightness :	_	5	
Contrast :		5	
Color Balance	-5-4-3-2-10123	4 5	
Cyan :		0	
Magenta :		0	
Yellow :		0	
Black :		0	
Uni-Directional Printing			
	color becomes light bluish overall. color becomes reddish overall.		

5-4-11. Specify the print direction

When you click on the [Advanced] in the [Printing Preferences] dialog box, you can make the settings for [Uni-Directional Printing].

- What you have specified on the printer's operation panel are prioritized, and this option becomes active only when the print
 direction specified on the printer side is set to [Auto].
- Print time will be doubled.

Vhite Ink Settings		
Transparent Color :	green (0, 199,0) V	Custom
Tolerance :	0 10 20 30 40 50	30
rulerance ;		30
Minimum Whiteness :	Normal O Special	
	1 2	1
	-	1.
Choke Width :	0 1 2 3 4 5 6 7 8 9 10	2
Color Processing		
Saturation :	0 10 20 30 40	5
Brightness :	+	5
Contrast :	-	5
Color Balance	-5-4-3-2-1012345	
Cyan :		0
Magenta :		0
Yellow :		0
Black :		0
Uni-Directional Printing		
i-Directional Printing : kes the print uni-directiona e value of Print Direction se Print Direction through the	t by the Panel has priority. This is available only	y if [Auto] is selecte

5-5. Using Useful Tools

Useful tools and print data are provided for adjusting colors or searching for an appropriate print setting. The "Useful Tools" will be installed onto the subdirectory under the "Brother GTX pro Tools" of your PC. For the details of each tool, please refer to the chapters described later.

5-5-1. Use the color palette

The different color palettes are available for each software application as follows:

- Adobe Photoshop/Illustrator: "GT_Colors_T.ase"
- CorelDRAW: "GT_Colors.xml" and "GT_Tshirts.xml"

For more information, refer to a relevant page or help menu of each application software (13-3. Using other applications >>P.82").

<TIPS>

• When using the printer driver by default, use one of them as a color sample to check color reproduction and create/edit the image data. (Because CoreIDRAW cannot contain identical color in the same palette, the color palette is divided into two files.)

5-5-2. Replace RGB=255 with RGB=254 (for Photoshop only)

For Photoshop, use this to change RGB=255 to RGB=254.

- (1) From the "Useful Tools", click "SolidWhite.atn", and follow the on-screen instructions to save the file on your PC.
- (2) In the menu bar of Photoshop, select [Window] > [Action file].
- (3) Click on the <u>to open the submenu</u>.
- (4) From the [Load Actions], select "SolidWhite.atn" saved on your PC.<TIPS>
 - For information on using action files, refer to the Help feature that Photoshop is provided with.
 - "SolidWhite.atn" can be used only when the [Color mode] is set to [8 bit] of [RGB Color].

5-5-3. Check the color sample

Use when checking the color sample.

Please use this color chart as a color sample like the one that is commonly provided by an ink maker, for the print data (ARXP file) you created using your desired printer driver setting.

<TIPS>

• Make use of this color chart when you perform the printing after changing the settings of the printer driver.

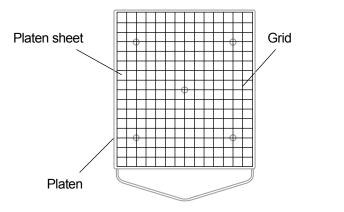


- (1) From the "Useful Tools", click a required file name to download the data. The following files are provided as color samples.
 - GT_Blues.pdf
 - GT_Greens.pdf
 - GT_Oranges.pdf
 - GT_Reds.pdf
 - GT_ColorChart.pdf
- (2) Configure the printer driver and create print data.

- For details of the printer driver's setting procedures, refer to "5-4. Set up the printer driver >>P.101".
- For information on creating print data, refer to "5-3. Using other applications >>P.82".
- (3) Send the created print data to the printer and perform printing.
 "6. Basic printing procedures >>P.125".
 <TIPS>
 - Check the print result and adjust the printer driver's settings.

5-5-4. Print a grid pattern on the platen sheet

You can print a grid pattern onto a new platen sheet.



- (1) From the "Useful Tools", open such an ARXP file (for example, Grid14x16.arxp) that has a grid size suitable to the platen size.
- (2) Send the print data of grid pattern to the printer.
- Without putting a T-shirt in place, print the grid pattern directly onto the platen sheet.
 <TIPS>
 - After the printing is completed, press down the printed surface lightly with a dry cloth or a sheet of paper to dry the ink.

5-5-5. Adjust the ink volume

Set an optimum setting for [Ink Volume:] of the printer driver.

Download the data from "Useful Tools" and perform printing to check the blurring beforehand (""6. Basic printing procedures >>P.125").

- Appropriate ink volume setting value depends on color or material of the T-shirt. It is recommended to consider and decide on an
 appropriate ink volume setting value before creating print data.
- There are four types of ink volume printing data. Select the ink volume print data to match the [Double Printing:] setting for the printer driver.
- (1) Select the desired file from "Ink Volume SinglePrint.arxp", "Ink Volume DoublePrint1.arxp", "Ink Volume DoublePrint2.arxp", and "Ink Volume DoublePrint3.arxp" from the "Useful Tools" to download data.
- (2) Send the data to the printer and perform printing.
- (3) Check the print result and adjust the value for [Ink Volume:] of the printer driver.

ob Name : Nate :	Ink Volume SinglePrint 20/12/2017 17:25	
laten Size :	14x16	Brutter Germant Printer Ink Values Tot Future 1200Apt Brutter
elect Ink :	Color Ink Only	
Color Ink Volume :	10	0
Double Printing :	1	-
Color Multiple Pass Printing :	Off	
Details		-
Color Ink :	0.41 cc	8.0 - <
rint :	1 piece	100%
Send to Printer		

5-5-6. Print out of highlight check pattern/mask check pattern

This is one of the print data files for selecting the ideal setting for [Highlight:] of the printer driver.

Download the data from "Useful Tools" and print the highlight check pattern for checking whiteness, background hiding level, and blurring beforehand.

<TIPS>

- Please print on a pretreated T-shirt. Image "6. Basic printing procedures >>P.125".
- Appropriate highlight setting value depends on color or material of the T-shirt. It is recommended to consider and decide on an
 appropriate highlight setting value before creating print data.
- (1) From the "Useful Tools", click "Highlight-Mask Check at MW1.zip" or "Highlight-Mask Check at MW2.zip" to

download data.

- The file you should select differs depending on whether "Minimum Whiteness:" is set to [1] or [2].
- Check the number at the end of the file name before downloading the file.
- (2) Unzip the file and the following print data will be displayed.
 - "HighlightCheckPattern"
 - "MaskCheckPattern" at each highlight
- (3) Print "HighlightCheckPattern" and select the optimum highlight setting.
- (4) Print "MaskCheckPattern" for the optimum highlight setting and select the optimum mask setting.
- (5) Check the print result and adjust the values for [Highlight:] and [Mask:] of the printer driver.

G:\GTX pro\HighlightCheck	attern MW1.arxp	- 0	×
Job Name : Date : Platen Size : Select Ink : Highlight : Mask : Print Time : Whiteness : Use background black color : Color Multiple Pass Printing : Details Color Ink : White Ink : Print : Send to Printer Browse Close	Highlight Check MW1 09/04/2018 01:05 14x16 Color+White Ink 1 3 x 1 200 % Off Off 0.64 cc 10.66 cc 1 piece	0 7.0	

5-5-7. Check the ejection timing

Check whether or not the ejection timing is correct.

(1) From the "Useful Tools", click "FIRING CHK COLOR.arxp" or "FIRING CHK WHITE.arxp" to download data.

- (2) Send the data to the printer and perform printing.
- (3) Check the print result to make sure the firing timing has been set correctly.

ob Name :	FIRING CHK COLOR	-7.0 0	7.0
Date :	17/09/2015 00:05		^
Platen Size :	14x16	-	
Select Ink :	Color Ink Only	-	
Color Ink Volume :	10	0	
Double Printing :	1	-	
Color Multiple Pass Printing :	Off	-	
Details		-	
Color Ink :	0.08 cc	8.0 «	>
rint:	1 piece	100%	600%

5-5-8. Check the platen feed setting

Check whether or not the platen feed adjustment is appropriate.

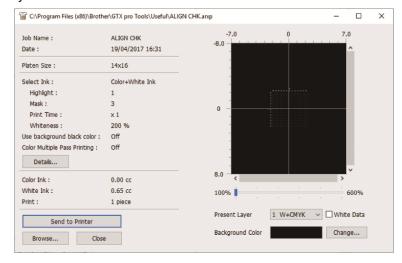
- (1) From the "Useful Tools", click "FEEDING PATTERN(1).arxp" to download data.
- (2) Send the data to the printer and perform printing.
- (3) Check the print result to make sure the platen-rolling adjustment has been set correctly.

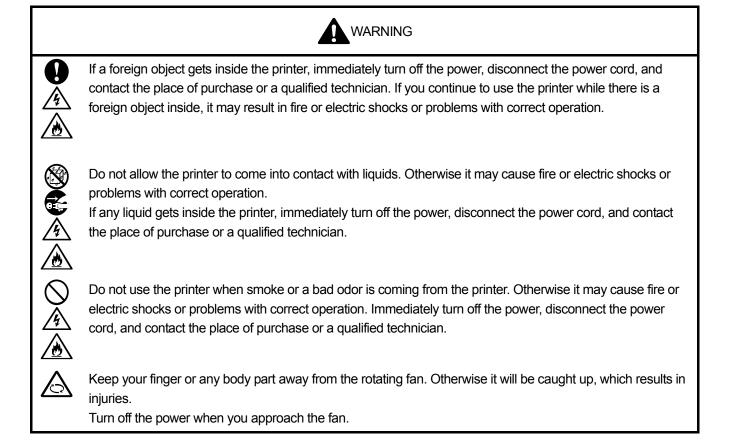
C:\Program Files (x86)\Broth	er\GTX pro Tools\Useful\FEEDING			-		×
Job Name :	FEEDING PATTERN(1)	-7.0	0	7.	.0	
Date :	13/12/2015 18:52	-	CTX Carriage Adjusting Pattern Fild		î	
Platen Size :	14x16	-	875			
Select Ink :	Color Ink Only	-				
Color Ink Volume :	10	0				
Double Printing :	1	-				
Color Multiple Pass Printing :	Off	-				
Details		-				
Color Ink :	0.09 cc	8.0 - <		>	*	
Print :	1 piece	100%			600%	
Send to Printer						
Browse Close	•					

5-5-9. Check the print position

Check the alignment of the print position on the white side with the print position on the color side.

- (1) From the "Useful Tools", click "ALIGN CHK.arxp" to download data.
- (2) Send the data to the printer and perform printing.
- (3) Check the print result to make sure the print position on the white side has been aligned with the print position on the color side correctly.



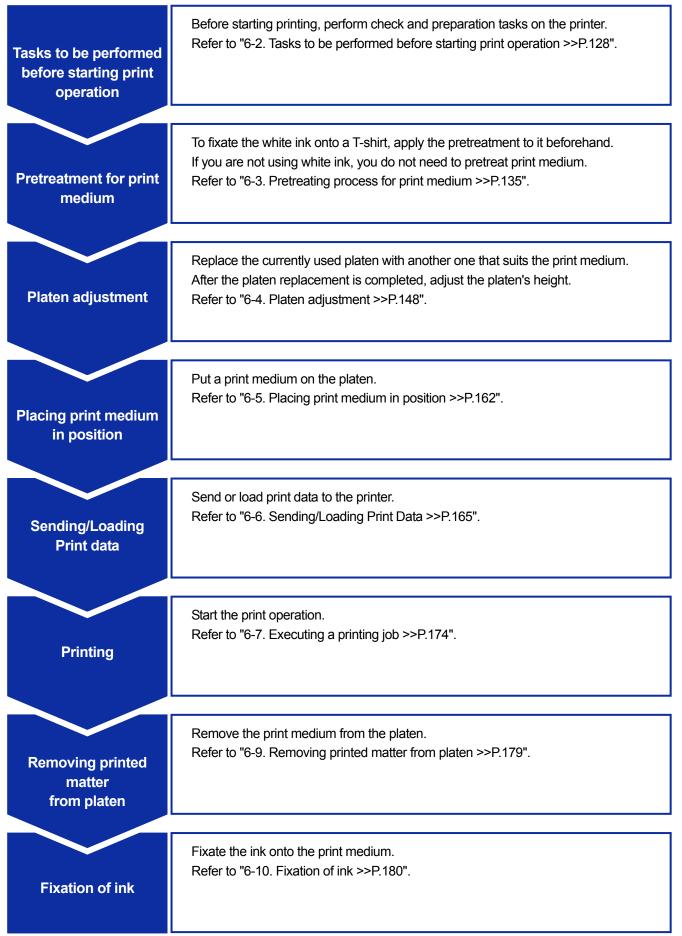


	CAUTION		
\bigcirc	This printer should only be used by operators who are appropriately trained in its safe operation.		
	Ensure there is adequate space left in front of the printer and avoid placing any objects. Otherwise your hand may get caught between the platen and an object, which may result in injury.		
(Do not handle the platen while printing. If your hand gets caught between the platen or the T-shirt tray and the covers, it may be injured.		
	Do not put your hands inside the covers while the printer's power is turned on. Otherwise your hands may touch against moving parts and this may result in injury.		
\bigcirc	Do not disassemble the ink pouch. If the ink gets into your eyes or onto your skin, it may cause inflammation. In case of contact with eyes, do not rub but immediately rinse the eyes with water.		
\bigcirc	Do not disassemble the ink cartridge.		
\bigotimes	Do not drink liquids such as the ink, maintenance solution, cleaning solution, pretreatment, or waste. They may cause diarrhea or vomiting. Avoid causing your eyes or skin to make contact with the ink, maintenance solution, cleaning solution, pretreatment or waste. It may cause inflammation. In case of contact with eyes, do not rub but immediately rinse the eyes with water. Keep the liquids out of the reach of children.		
0	When the pretreatment is applied to printed objects (like a T-shirt) with a spray or pretreatment applicator, sprayed mist is generated. So wear a pair of plastic gloves, a mask and protective glasses (or goggles) designed to shield against liquid splash, and fully take care of the air ventilation when you are working with it.		
0	When a problem occurs with the operation of the printer, contact the place of purchase or a qualified technician.		
0	Do not move the platen by hand. Otherwise the printer may be mechanically and electrically damaged.		

Ensure there is adequate space left in front of the printer and avoid placing any objects. The platen may be hit and damaged.

6-1. Basic printing process flow

What are described below are the basic work flows before the start and after the completion of print process.



6-2. Tasks to be performed before starting print operation

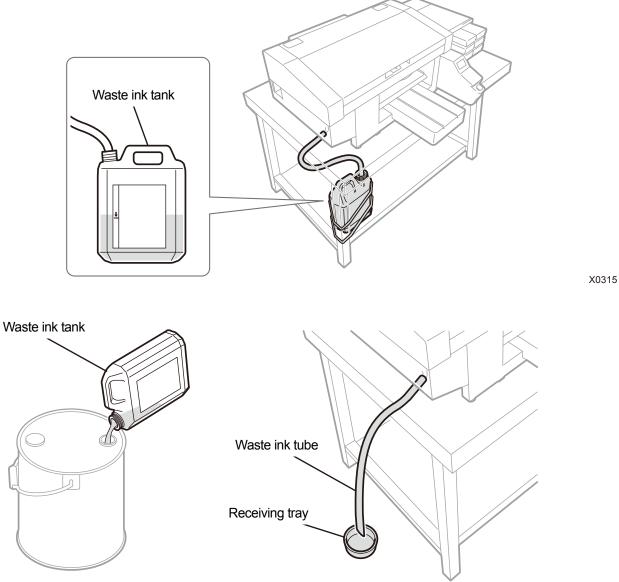
6-2-1. Confirmation and disposal of waste ink

Check the amount of waste ink in the waste ink tank, and if the tank is filled with the waste ink up to its one-half or higher level, discard the ink.

(1) Check on the waste ink tank, and discard the waste ink.

In an area under the other end of the waste ink tube (when removed) from the waste ink tank, place a receiving tray or the like so that the waste ink spilled from the tube will not be discharged onto the floor, etc. <NOTE>

• Dispose of the waste ink properly as water-based waste fluid in accordance with applicable laws and ordinances.



X0316

(2) Return the waste ink tank to its original state, and insert the waste ink tube into the tank. <IMPORTANT>

- The waste ink tube should be cut diagonally. If the tip of the waste ink tube is immersed in the liquid, it will prevent the smooth flow of the waste ink, to disable the ink suction operation of the head cleaning function. Otherwise, waste fluid may flow reversely, causing the waste ink to spill contaminating the floor.
- Avoid placing the waste ink tube horizontally as much as possible, and be sure not to let it bend.
 Otherwise the waste ink may have difficulty flowing through the tube.

X0044

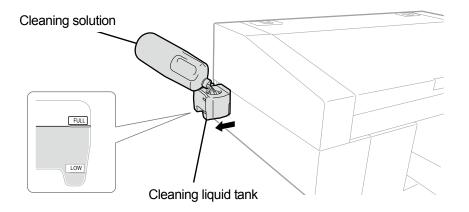
6-2-2. Confirmation and replenishment of cleaning solution

Check to see if the amount of cleaning solution is kept at a proper liquid level in the cleaning liquid tank, and refill the tank with the solution when its amount is below the proper level. <TIPS>

 Also, refill the tank with the solution when a warning message appears on the operation panel screen or in the warning message window when the cleaning liquid tank is not pulled out.

For GTX pro:

- (1) Pull out the cleaning liquid tank from the side of the printer.
- (2) Open its lid and refill it with the cleaning solution up to the "FULL" line. <IMPORTANT>
 - Be sure not to put the cleaning solution into the tank above the "FULL" line.

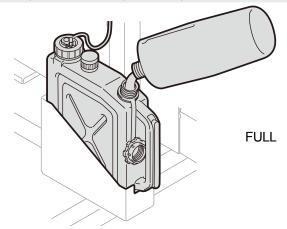


(3) Close the lid and slowly place the cleaning liquid tank into the printer.

X0387

For GTX pro Bulk:

- Open the cleaning liquid tank lid and fill the tank with the cleaning liquid.
 <IMPORTANT>
 - Take care to prevent the cleaning liquid from leaking when filling it.



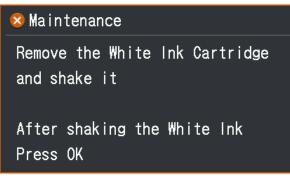
- (2) Close the cleaning liquid tank lid.
- (3) From the menu, select [Replenishment of cleaning solution], and press

<IMPORTANT>

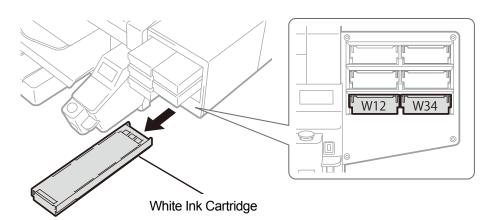
- After filling the cleaning liquid, be sure to close the cleaning liquid tank lid.
- Once an error occurs with the cleaning solution tank empty, you cannot clear the error unless you perform [Replenishment of cleaning solution] from the menu.

6-2-3. Daily agitation of the white ink (For GTX pro only)

Perform the procedures shown below if a white ink cartridge stirring message is displayed before starting operation.

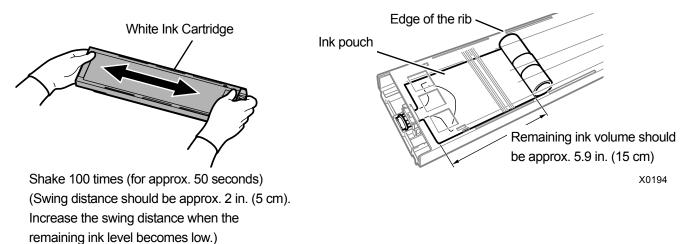


- (1) Take out the white ink cartridge from the printer. <CAUTION>
 - The bottom of the cartridge may be soiled with ink. Clean the printer on a regular basis.



X0317

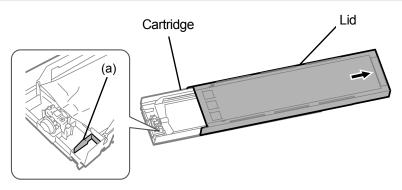
- (2) Shake the cartridge 100 times side by side to stir the white ink. <IMPORTANT>
 - The white ink cartridge should be held horizontally when shaking it.
 - Holding the white ink cartridge upside down or shaking it too roughly could break the ink pouch.
 - <NOTE>
 - Wear the provided gloves when performing this task.
 - When the remaining ink level becomes approximately 5.9 in. (15 cm), shake the cartridge with its cover open and with the edge of the ink pouch slightly winded, to make the ink easier to stir.



131

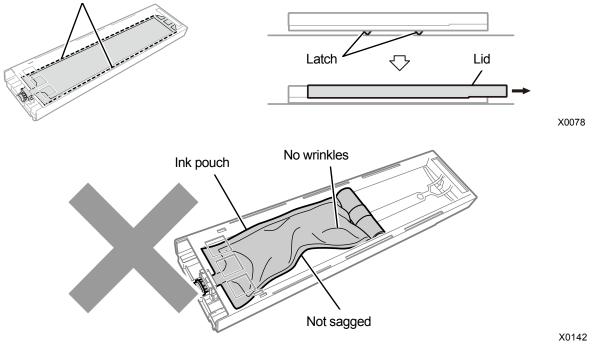
(3) Open the lid of the cartridge and place the ink pouch in its correct position.
 <IMPORTANT>

- Always open the cartridge lid and properly rewind the ink pouch. If the pouch is placed without opening the lid, ink can flow into the wound section of the pouch when stirred, which can cause improper winding of the pouch.
- When opening the lid, place the entire cartridge on a flat surface, push the latches on the bottom surface of the cartridge downward and open the lid.
- When setting the ink pouch, avoid unevenness or wrinkles on the pouch.
- When opening the lid, be sure not to touch the portion (a). Otherwise, it could be damaged.
- <NOTE>
- If the remaining ink level is low, hold the sagged part of the ink pouch and close the lid.



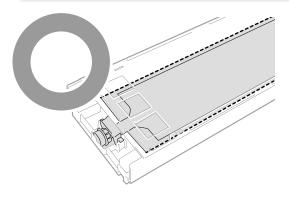
X0182

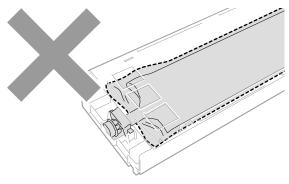
Place the pouch in a straight alignment with the cartridge



(4) Close the lid, and put the white ink cartridge in position inside the printer. <IMPORTANT>

- W12 and W34 cartridges should correctly be placed at their original locations. Wrongly placed cartridges could cause the printer malfunction.
- When setting the cartridge, do not shake the cartridge with the ink pouch facing down with the aim of facilitating the winding of the pouch. Doing so will cause wrinkles, and the proper winding of the ink pouch will not be possible.





X0283

- (5) Repeat the same process to shake the other white ink cartridge to stir up the ink.
- (6) On the operation panel, press

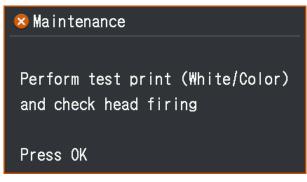
Then, the white ink refilling will be performed automatically. The following screen will be displayed without white ink refilling in the case of insufficient agitation.

After performing steps (1) to (5), press (MENU again.

😣 Maintenance
Remove the White Ink Cartridge and shake it
(over 60 seconds) After shaking the White Ink
Press OK

(7) When you are finished replacing the white ink, press in the operation panel to print the nozzle check pattern. For GTX pros⁻¹⁷-2-1. Print out of the nozzle check pattern (checking on the print heads) >>P.213".

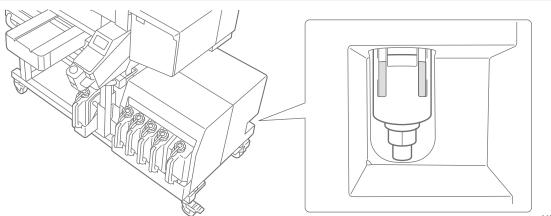
For GTX pro Bulk ""8-2-1. Print out of the nozzle check pattern (checking on the print heads) >> P.275".



6-2-4. Checking the drain separator (for GTX pro Bulk only)

Before starting the work, check that no ink is collected in the drain separator. <IMPORTANT>

• If ink is collected, immediately stop using the printer and contact your dealer.



X0435

6-2-5. Checking the ejection from the head (for GTX pro Bulk only)

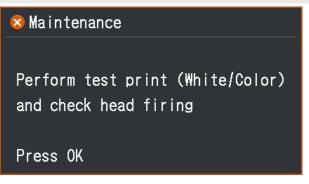
If a message prompting you to check the ejection from the head is displayed before work, print out a nozzle check pattern.

For GTX pros "7-2-1. Print out of the nozzle check pattern (checking on the print heads) >>P.213".

For GTX pro Bulk "8-2-1. Print out of the nozzle check pattern (checking on the print heads) >> P.275".

<TIPS>

• The GTX pro Bulk does not require you to manually agitate the white ink tank but it requires you to periodically check the ejection from the head.



6-3. Pretreating process for print medium

To fixate the white ink onto the surface of fabric of a T-shirt, apply the pretreatment to it beforehand. If you are not using white ink, you do not need to pretreat print medium.

Workflow of pretreating process

Step	Item	Detailed description
1	Dilution of pretreatment	Put the pretreatment into a polypropylene container or the like, and dilute it with pure water.
2	Application of diluted pretreatment	By means of a spray or roller, apply the diluted pretreatment onto the print medium.
3	Fixation of pretreatment	Fixate the pretreatment by using the heat press to apply heat and pressure onto the print medium.

6-3-1. Provisions for pretreatment

Items to be prepared

Two types of application means are available for the pretreatment—roller and spray. With reference to the table below, make what you need available in advance. ○: What you need
△: Useful items, if any
–: Not required

Items to be prepared	For roller coating	For spray coating
Pretreatment	0	0
Pure water	0	0
Pretreatment roller	0	_
Handle (handgrip of roller)	0	_
Тгау	0	_
Agent-coating table	Δ	_
Weighing instrument	0	0
Spray	_	0
Heat press	0	0
Peel-off sheet	Δ	Δ
Silicone foam (of open-cell structure)	Δ	Δ
Adhesive roller	Δ	Δ

Pretreatment

It is the white liquid that is needed for pretreating process for printing with white ink. If a print medium is not coated with this agent, no color development of white ink takes place, and the whiteness becomes insufficient. Also, no color will be produced from the color inks that are applied onto the white ink. In order to apply the pretreatment onto a T-shirt, use a spray or roller, and use the heat press to fixate it.

<CAUTION>

- Be sure to wear a pair of plastic gloves, a mask and protective glasses during the work operation.
- For information on handling of the pretreatment, see the Material Safety Data Sheet issued by us.
 http://sds.brother.co.jp/sdsapp/index.html

Pure water

It refers to distilled water, purified water, etc. which is used to dilute the pretreatment with it.

Pretreatment roller (option)
 This is used to apply the pretreatment onto a T-shirt. It is advisable to use such a handgrip for the roller that is resistant to rust formation.

<NOTE>

- Separately provide a tray (container for dilution), handle (handgrip for roller), agent-coating table and weighing instrument for amount of coating.
- Spray (commercially available item)

This is used to apply the pretreatment onto a T-shirt. Use a spray (preferably of an electrically-operated type) that can emit fine spray. As compared with a roller, a spray allows for easy and even coating and reduces non-uniform coating, while it requires a special space for using it.

In addition to a spray, a pretreatment application device (commercial product) is available that can apply the pretreatment onto a T-shirt automatically. As required, make them available for use separately.

<CAUTION>

- Fully take care of the air ventilation when you work on operation that generates mist such as spray application.
- Be sure to wear a pair of plastic gloves, a mask and protective glasses (or goggles) designed to shield against liquid splash during the work operation.
- For information on handling of the pretreatment, see the Material Safety Data Sheet issued by us.
 <u>http://sds.brother.co.jp/sdsapp/index.html</u>

<IMPORTANT>

- If you are using an electric spray to apply the pretreatment, perform the work at a place as far as possible from the printer. Otherwise, it may cause failure of print heads.
- Heat press

It must deliver the performance through which the print range of the platen can to be covered and 180°C (356°F) can be kept for 35 seconds or more. At a fixing stage of the pretreatment, be sure to use the heat press, but not an oven, to smoothen the surface.

Peel-off sheet

When using the heat press, place this sheet on a T-shirt so that neither inks nor pretreatment can be attached to the press surface of the heat press. As a peel-off sheet, use a silicone-coated paper or a fluororesin sheet. There is a tendency to bring the print result to an almost matte finish if a silicone-coated paper is used at the ink fixation stage. There is a tendency to bring the print result to an almost bright finish if a fluororesin sheet is used at the ink fixation stage.

- Silicone foam (of open-cell structure)
 It is the foamed mattress which is made of silicone that resists heat. When fixating the inks or pretreatment by means of the heat press, use this foam to ventilate steam with ease.
- Adhesive roller
 Use these to remove lint from a T-shirt or debris from its surface.

• T-shirt (printing medium)

100%-cotton fabric or polyester blended yarn fabric (cotton 50% or more) <TIPS>

- Although it is advisable to use a 100% cotton T-shirt, some textiles cannot necessarily guarantee good printing quality even if they are made of 100% cotton or blended yarn. In particular, for a T-shirt made of new material, perform a printing test on it beforehand.
- Some textiles may leave noticeable imprints of the pretreatment after it is fixated. In that case, wash them away with water.
- Perform a printing test beforehand. Then, the following phenomena may occur:
 - The textiles may be discolored by the pretreatment and cannot be restored to the original color even if they are washed.
 A deep-colored polyester blended yarn fabric dissolves dye, which may cause the white ink to change to a slightly different color.

- It is likely that a textile may become yellowish in color after the pretreatment is fixated.

6-3-2. Dilution of pretreatment

Be sure to use the pretreatment after diluting it with pure water. <CAUTION>

- Be sure to wear a pair of plastic gloves and protective glasses during the work operation.
- For information on handling of the pretreatment, see the Material Safety Data Sheet issued by us. <u>http://sds.brother.co.jp/sdsapp/index.html</u>

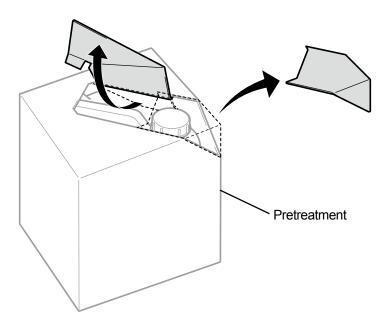
Dilution ratio

Use within the ratio range of x3 (Pretreatment:Pure water=1:2) (Volume ratio).

Dilution method

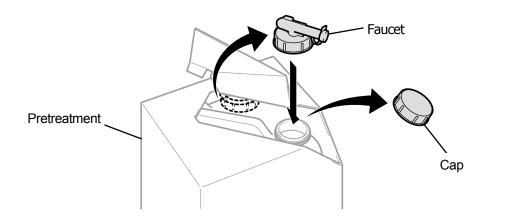
<TIPS>

- The figure below is based on the pretreatment (20 kg (44 lb)). When using the pretreatment (5 kg (11 lb)), remove the cap and pour the agent into the container, and dilute it with pure water, referring to step (4) and the subsequent steps. Dilution ratio is the same.
- Unpack the pretreatment container from the shipping carton by cutting off the perforated paper along the perforated tear-off line to open the carton.

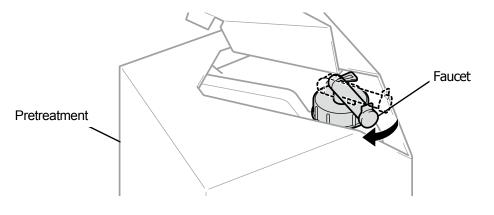


X0079

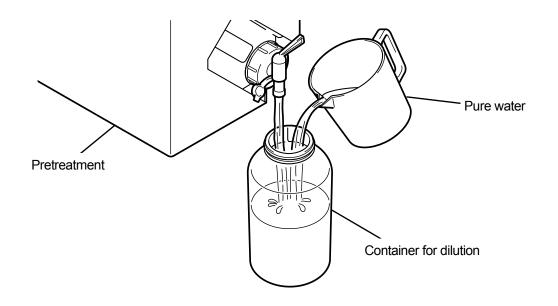
(2) Remove the cap, and place the cap in position.



(3) Orient the pour spout of faucet in the position as shown in the figure below.



- (4) Lean the entire shipping carton of pretreatment toward a container for dilution to pour the agent into the container, and dilute it with pure water.
 - <IMPORTANT>
 - Use with the dilution rate of x3 (Pretreatment:Pure water=1:2) (Volume ratio).
 - Close the cap of the container for dilution, and shake it sufficiently to provide equal concentration.



X0082

X0081

(5) To provide safekeeping for the pretreatment, close the faucet, place the pretreatment with the faucet part facing upward, and store the entire carton in a safe place.

6-3-3. Application of pretreatment

In order for the pretreated portions to be printed with inks, apply the pretreatment evenly to a wider area than the print range.

<CAUTION>

- Fully take care of the air ventilation when you work on operation that generates mist such as spray application.
- Be sure to wear a pair of plastic gloves, a mask and protective glasses (or goggles) designed to shield against liquid splash during the work operation.
- For information on handling of the pretreatment, see the Material Safety Data Sheet issued by us. http://sds.brother.co.jp/sdsapp/index.html

<IMPORTANT>

 Some T-shirts may leave distinct imprints of the pretreatment after it is fixated. Wash away any imprint of the pretreatment with water, if any.

Also, some T-shirts may be discolored by the pretreatment and cannot be restored to the original color even if they are washed. When performing the printing for the first time, do that after applying the agent to an unnoticeable area on trial.

If you are using an electric spray to apply the pretreatment, perform the work at a place as far as possible from the printer.
 Otherwise, it may cause failure of print heads.

Reference guide for amount of coating of pretreatment

Determine a coating area and amount of coating according to a platen size. When your coating area differs from what are shown in the table below, calculate the amount of coating based on the area ratio. <IMPORTANT>

- Depending on the type of fabric, the print quality cannot be guaranteed with the amount of coating of pretreatment shown below. It is therefore necessary to conduct sufficient print tests and adjust the amount of coating.
- If the amount of coating of pretreatment is too small, imprints of the pretreatment may become less noticeable after it is fixated, whereas color reproduction of the white ink and color inks on the white ink will deteriorate.
- Meanwhile, if the amount of coating of pretreatment is too large, imprints of the pretreatment may become noticeable, the printed surface may be cracked or discoloring may occur after washing.

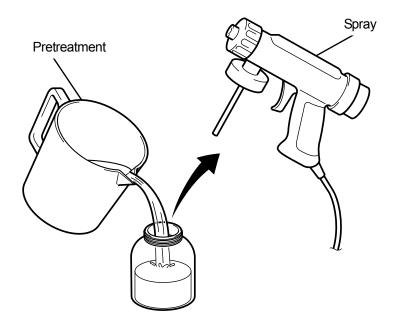
Platen Size	Amount of coating of pretreatment
16 x 21	45 g (1.6 oz)
16 x 18	39 g (1.4 oz)
14 x 16	30 g (1.1 oz)
10 x 12	16 g (0.6 oz)
7 x 8	8 g (0.3 oz)
Letter size/A4-size	15 g (0.5 oz)
Pocket size	3 g (0.1 oz)
(3.9 in. x 3.9 in. (10 cm x 10 cm))	- 3 ()

For coating with a spray (commercial product: preferably of an electrically-operated type)

(1) Fill a spray with the diluted pretreatment.

<TIPS>

Please use a spray (preferably of an electrically-operated type) that can emit fine spray.



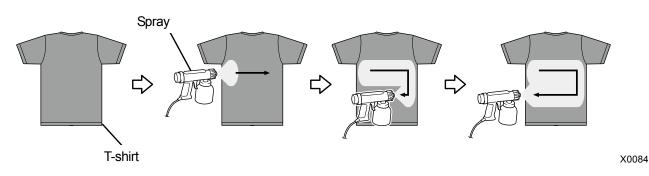
X0083

- (2) Put a T-shirt flatly on a flat surface or lean it back against wall, and apply the pretreatment evenly onto it. <CAUTION>
 - Fully take care of the air ventilation when you work on operation that generates mist such as spray application.
 - Be sure to wear a pair of plastic gloves, a mask and protective glasses (or goggles) designed to shield against liquid splash during the work operation.
 - For information on handling of the pretreatment, see the Material Safety Data Sheet issued by us.
 <u>http://sds.brother.co.jp/sdsapp/index.html</u>

<IMPORTANT>

If you are using an electric spray to apply the pretreatment, perform the work at a place as far as possible from the printer.
 Otherwise, it may cause failure of print heads.

- Note that pretreatment will not soak into the back (reverse) side of a T-shirt if you put an intermediate plate in the T-shirt. Remove the intermediate plate from the T-shirt before the pressing stage.
- When you are still unaccustomed to the spray coating, perform it while measuring the amount of coating by means of a weighing instrument.

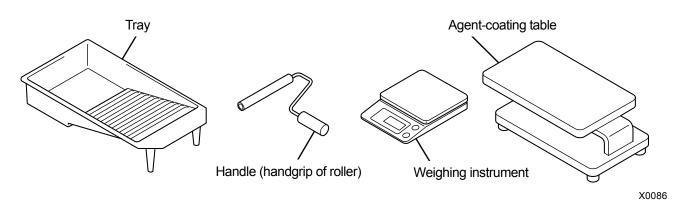


For coating with a pretreatment roller (option)

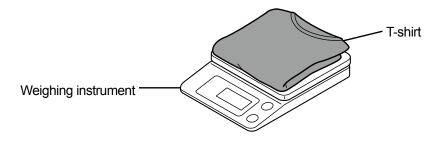
(1) Make a polypropylene tray or the like, handle (handgrip for roller), weighing instrument to measure the amount of

coating and agent-coating table ready for use. <TIPS>

• It is convenient for you to use an agent-coating table that can cover the print area, because it prevents the pretreatment from soaking into the underside of the area.

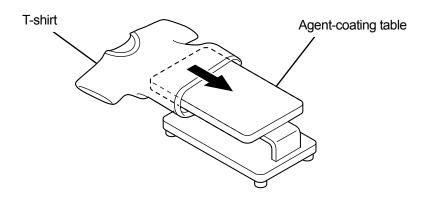


(2) Weigh a T-shirt before applying the pretreatment to it, so that you will be able to know how much of the agent you have applied to it later.

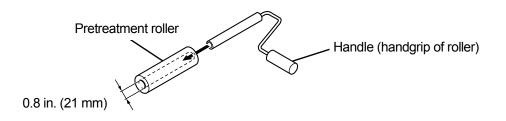


X0087

- (3) Slide a T-shirt onto the agent-coating table, with its printing side facing upward.
 <TIPS>
 - Note that pretreatment agent will not soak into the back (reverse) side of a T-shirt if you put an intermediate plate inside the T-shirt when there is not an agent-coating table.

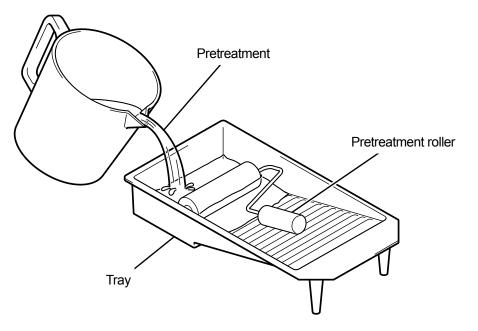


- (4) Attach the pretreatment roller to the handle (handgrip of roller).<TIPS>
 - Use a commercially available handle provided with a roller that fits the pretreatment roller's inside diameter of 0.8 in. (21 mm).

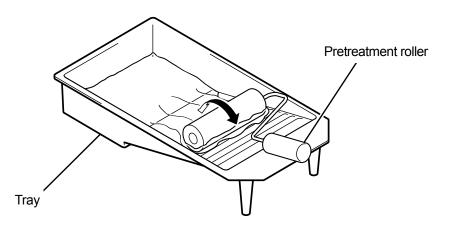


X0089

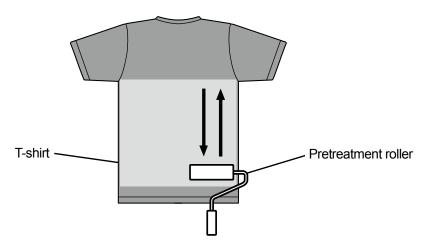
(5) Pour the diluted pretreatment into the tray, and dip the pretreatment roller in the agent so that it will be dampened with the agent.



(6) Rub the pretreatment roller well against the scrub board of the tray and squeeze a redundant agent out of it.

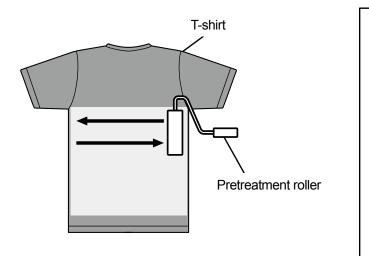


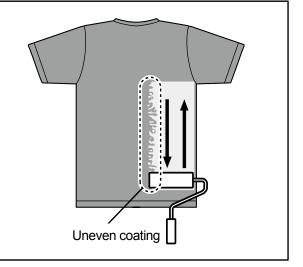
(7) Move the pretreatment roller on the T-shirt in a longitudinal direction, and apply the agent evenly onto the print range.



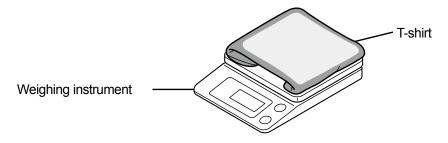
X0092

- (8) Move the pretreatment roller on the T-shirt in a lateral direction, and apply the agent evenly onto the print range. <TIPS>
 - Depending on a difference in the force applied by you to the pretreatment roller, the pretreatment may not be applied evenly to a T-shirt. Move the pretreatment roller repeatedly on each area to apply the agent evenly onto such area.
 - When there is any area (gap) that fails to be coated with the pretreatment or any other area that is found to be unevenly coated, dip the pretreatment roller in the agent again, and apply the agent evenly there.





- (9) Weigh the T-shirt to check to see if the required amount of pretreatment has been applied to it.
 <TIPS>
 - For the amount of coating of pretreatment read and re
 - If the amount of coating is small, color reproduction of the white ink and color inks on the white ink will deteriorate.
 - Meanwhile, if the amount of coating is too large, it is likely that a T-shirt may harden, imprints of the pretreatment may become noticeable or washing fastness may get worse and so on after the pretreatment is fixated.



Basic printing procedures

Maintenance of pretreatment roller

If you continue using the pretreatment roller under a state in which any fuzziness, yarn waste, dust, etc. remain attached to its surface, you may not provide a uniform coating.

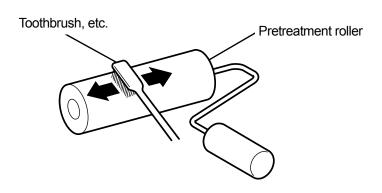
In such case, use a toothbrush or the like to brush off such fuzziness to remove it from the surface. <CAUTION>

- Be sure to wear a pair of plastic gloves and protective glasses during the work operation.
- For information on handling of the pretreatment, see the Material Safety Data Sheet issued by us. http://sds.brother.co.jp/sdsapp/index.html

<NOTE>

• After the pretreatment roller is used, put it in a plastic bag or the like hermetically to prevent it from drying up, and keep it in a flat place in an upright position.

Also, when it remains unused for two weeks or longer, wash it well with running water, and let it dry in a shaded area before using it again.



6-3-4. Fixation of pretreatment

<CAUTION>

- As the operation will generate mist, fully take care of the air ventilation.
- Be sure to wear a pair of plastic gloves, a mask and protective glasses (or goggles) designed to shield against liquid splash during the work operation.
- For information on handling of the pretreatment, see the Material Safety Data Sheet issued by us. <u>http://sds.brother.co.jp/sdsapp/index.html</u>

<TIPS>

- Because the pretreatment will not work best if it is dried through oven-based drying or air drying, be sure to use the heat press. As the oven does not bind fuzziness, the agent may be applied unevenly on white print.
- When you put a T-shirt on the heat press, set it so as to flatten the T-shirt's surface, place a peel-off sheet on the entire press area, and apply pressure.
- Note that any area in which the pretreatment is fixated may cause its effect to deteriorate or could cause the agent to be coated there unevenly if such area gets wet once.
- Do not touch the treated area with your hand after the pretreatment is fixated.
- After the pretreatment is fixated, do not touch or place the T-shirts on top of each other.
- Avoid leaving the pretreatment as it is in any highly humid areas.
- If the agent is left unchecked for a long time, use the heat press to apply pressure to a T-shirt immediately before the printing in
 order to dry it well.

Guidelines on fixation conditions of pretreatment

The undermentioned fixation temperature/time serve as guidelines only, and optimum conditions vary with your heat press. Be sure to perform the fixation after checking on the temperature and fixation results beforehand. <TIPS>

- Prior to and during a fixation process, check the heat press's temperature. If the fixation is performed continuously, the heat
 press's temperature will decrease, resulting in improper fixation of the pretreatment. In this case, the whiteness cannot be
 reproduced because the white ink soaks into the fabric of a T-shirt.
- Such a pressure is required that is adequate enough to flatten the surface. As the fixation conditions differ by heat press, check the ink fixation result in advance and adjust the pressure.
- If it is not dry enough after pressing for 35 seconds, extend the time while checking the dried condition of the pretreatment.
- The following values should be regarded as guidelines only, for the optimum fixation conditions depend on the amount of coating of pretreatment.

Temperature	Time
180°C (356°F)	35 seconds

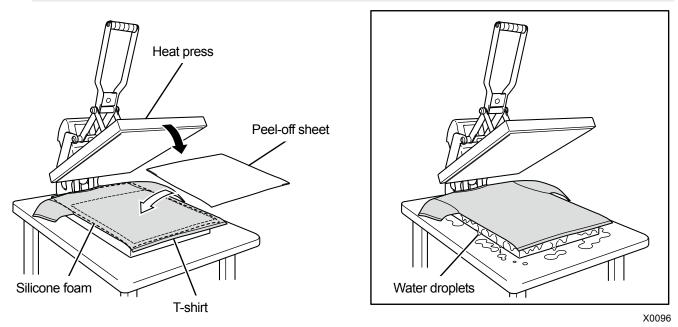
X0097

(1) Place the silicone foam, T-shirt and peel-off sheet in position under the heat press first, and fixate the pretreatment

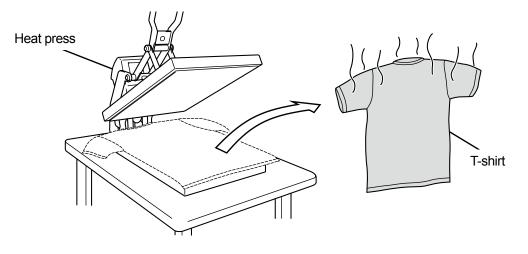
properly.

<TIPS>

- Water droplets are generated around the heat press to evaporate water content of the pretreatment by the heat of heat press. Keep your working space clean so that the surface to be coated with the agent will not get wet.
- A peel-off sheet should be used if needed, depending on the heat press you use.



(2) Remove the T-shirt from the heat press so that the steamy heat will escape from it.



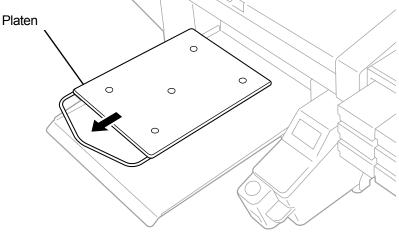
6-4. Platen adjustment

Replace the currently used platen with another one that suits the medium to be printed. <TIPS>

- In cases where such an optionally sized platen as 10X12 platen is used, ascertain that a proper "Platen size" has been selected in the printer driver's setting menu. Image: 5-4-1. Select the platen size >>P.103".
- When using the 16X21 platen: Image: Market States and States and

6-4-1. Replacing the currently used platen with another one

(1) On the operation panel, press (), and move the platen toward the front of the printer.

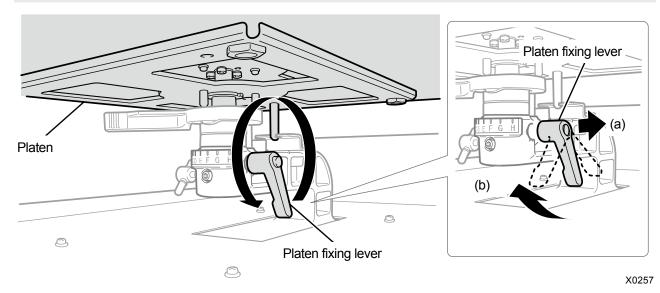


X0164

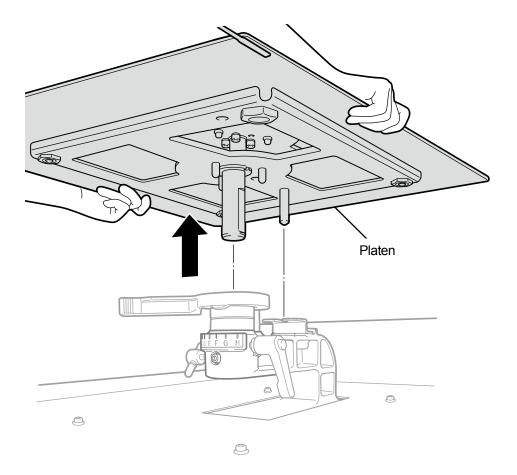
(2) Loosen the platen fixing lever by rotating it one to two turns.

<TIPS>

Depending on the height of the platen, the platen fixing lever may strike against the platen, and prevent rotation. In that case, move the platen fixing lever in the direction (a), draw the edge of the platen fixing lever forward as shown in (b), then loosen it again.

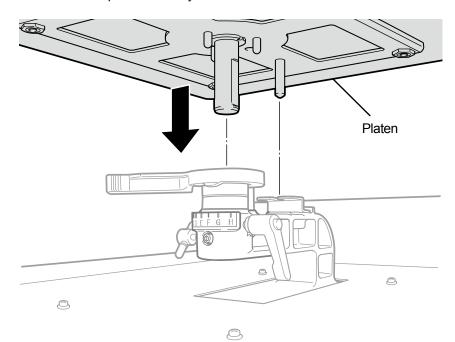


(3) Remove the platen moving it straight upwards by holding both ends of it.

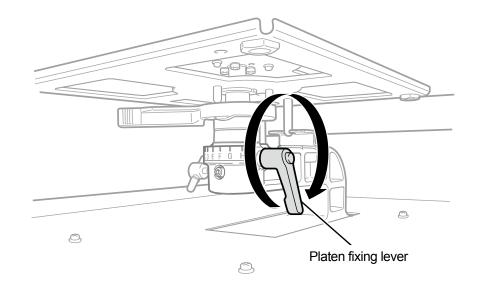


X0258

(4) Put another platen to be used in position directly from above.



(5) Tighten the platen fixing lever.



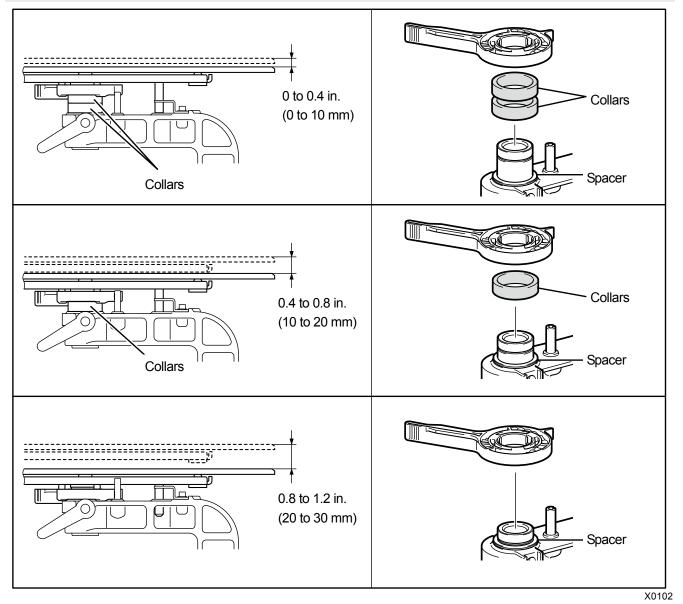
.

6-4-2. Platen height adjustment

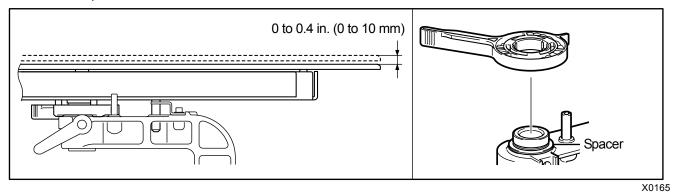
When constantly printing on thick material, the platen height can be lowered by up to 1.2 in. (30 mm) by adjusting the platen bearing and collars.

<TIPS>

- Please refer to the table below for the platen's height adjustment range (height A, measured from the platen height adjustment lever; with the standard parts installed).
- Spacers are installed on your printer so that the height can be the reference value. Do not change the number of spacers.
- When using the 16X21 platen, it can be used only at the lowest position. Remove all the collars before mounting the platen. Also note that the height adjustment range of the 16X21 platen is 0.4 in. (10 mm) at maximum.
- When adjusting the height, put the latch of the platen height adjustment lever into the groove of the platen bearing.



Case of 16X21 platen



As an example, the cases where the platen's height is set to the lowest position from the standard position and to the middle position from the lowest position are described below.

From the standard to the lowest position

- (1) Detach the platen.
- (2) Remove the platen fixing lever, platen height adjustment lever, and collars.

The number of collars and the height adjustment range are as follows:

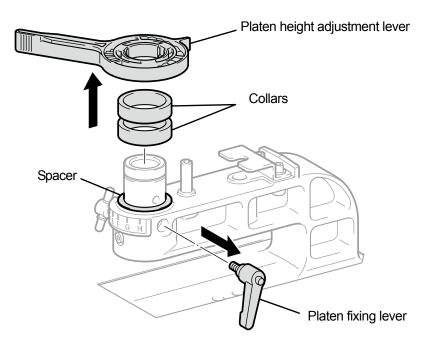
Position	Height	No. of collars	
Highest position (standard)	0 to 10 mm	2	
Middle position	10 to 20 mm	1	
Lowest position	20 to 30 mm	None	

Case of 16×21 platen

		No. of collars
Lowest position	0 to 10 mm	None

<TIPS>

• Spacers are installed on your printer so that the height can be the reference value. Do not change the number of spacers.

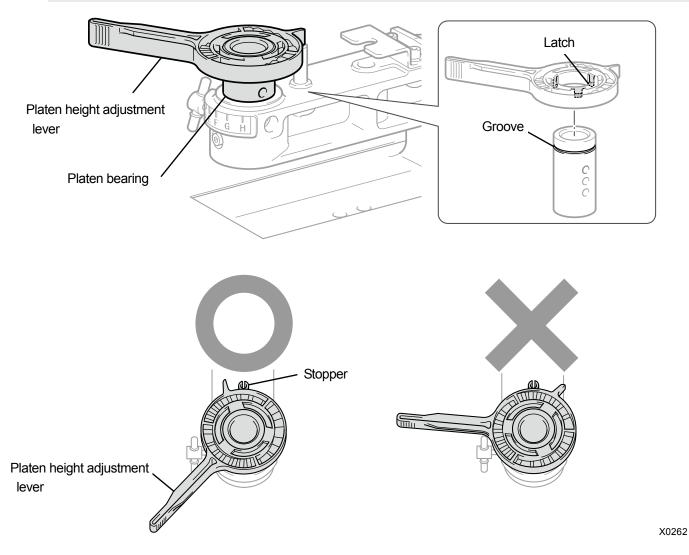


(3) Attach the platen height adjustment lever to the platen bearing.
 <CAUTION>

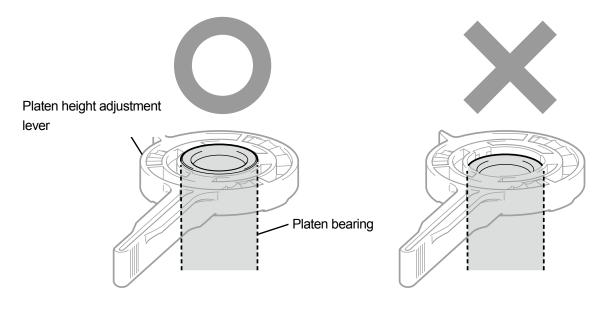
• Attach the platen height adjustment lever to the position as illustrated in the figure below. The lever installed in the wrong position will interfere with the stopper when the platen is attached.

<TIPS>

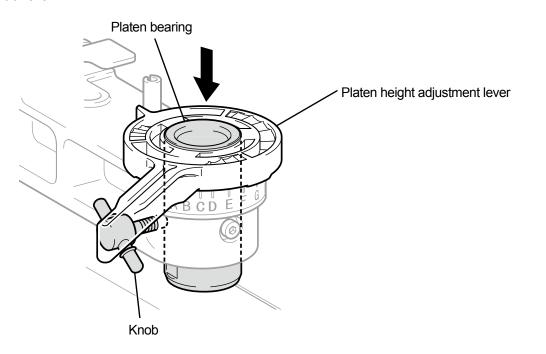
• When adjusting the height, put the latch of the platen height adjustment lever into the groove of the platen bearing.



(4) Check that the end position of the platen height adjustment lever is aligned with that of the platen bearing.



(5) Loosen the knob while holding the platen height adjustment lever and lower the platen bearing and the height control lever.



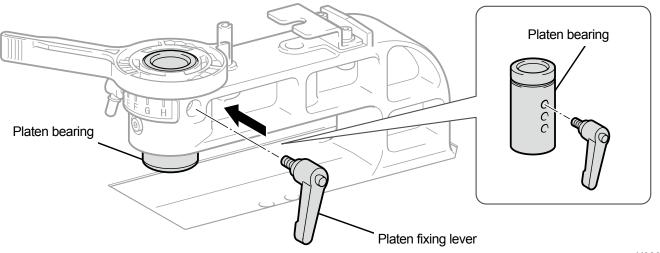
X0263

(6) Use the platen fixing lever to secure the platen temporarily.

The number of collars and the position of screw hole for the platen bearing differ by the height of the platen adjusted.

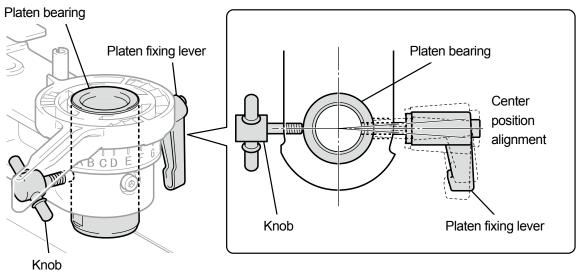
<TIPS>

- If you are setting the platen's height to the lowest position, remove all the collars and fix the platen bearing at its highest screw hole temporarily.
- If you are setting the platen's height to the middle position, attach one collar and fix the platen bearing at its middle screw hole temporarily.
- If you are setting the platen's height to the highest position, attach two collars and fix the platen bearing at its lowest screw hole temporarily.



X0264

- (7) Tighten the knob to secure the platen bearing in place.<TIPS>
 - Align the center of platen fixing lever with the position as illustrated in the figure below, and secure the platen bearing in place.



X0265

(8) Insert the platen to be used and tighten the platen fixing lever.

From the lowest position to the middle position

- (1) Detach the platen.
- (2) Remove the platen fixing lever, platen height adjustment lever.

The number of collars and the height adjustment range are as follows:

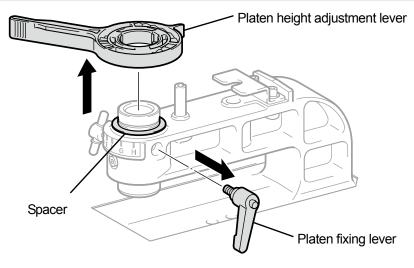
Position	Height	No. of collars
Highest position (standard)	0 to 10 mm	2
Middle position	10 to 20 mm	1
Lowest position	20 to 30 mm	None

Case of 16×21 platen

Position	Height	No. of collars
Lowest position	0 to 10 mm	None

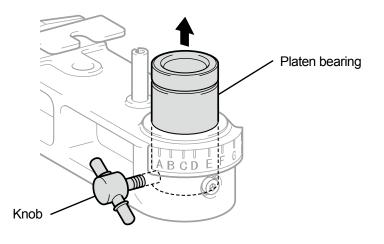
<TIPS>

• Spacers are installed on your printer so that the height can be the reference value. Do not change the number of spacers.

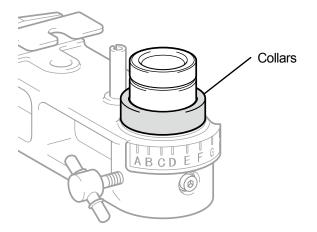


X0266

(3) Loosen the knob while holding the platen bearing and lift the platen bearing to the top to tighten the knob again.



(4) Attach the collar.

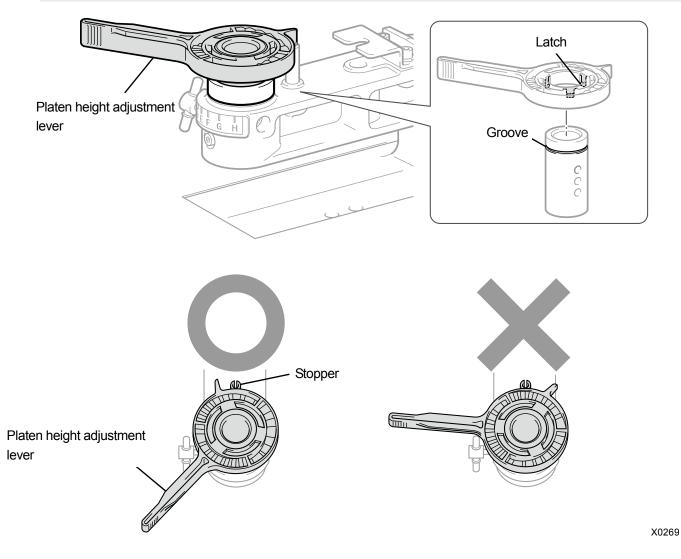


X0268

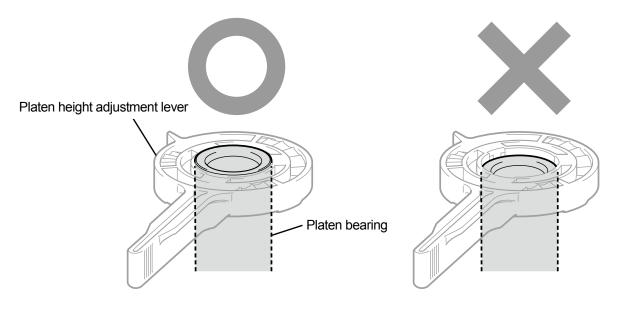
- (5) Attach the platen height adjustment lever to the platen bearing.
 <CAUTION>
 - Attach the platen height adjustment lever to the position shown below. The lever installed in the wrong position will interfere with the stopper when the platen is attached.

<TIPS>

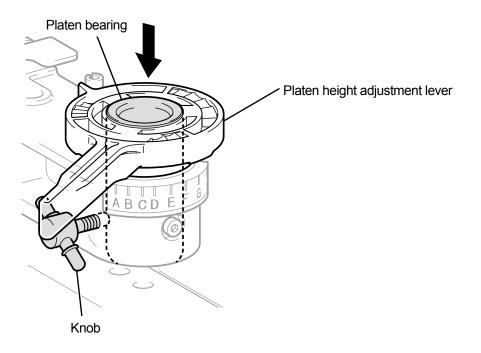
When adjusting the height, put the latch of the platen height adjustment lever into the groove of the platen bearing.



(6) Check that the end position of the platen height adjustment lever is aligned with that of the platen bearing.



(7) Loosen the knob while holding the platen height adjustment lever and lower the platen bearing and the height control lever.



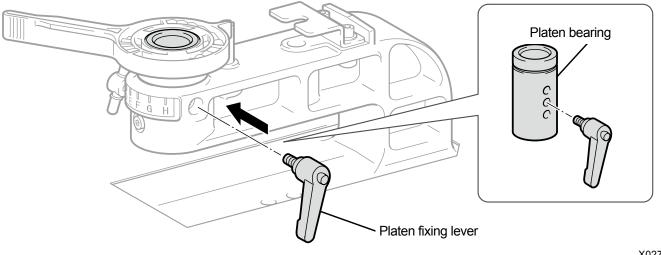
X0270

(8) Use the platen fixing lever to secure the platen temporarily.

The number of collars and the position of screw hole for the platen bearing differ by the height of the platen adjusted.

<TIPS>

- If you are setting the platen's height to the lowest position, remove all the collars and fix the platen bearing at its highest screw hole temporarily.
- If you are setting the platen's height to the middle position, attach one collar and fix the platen bearing at its middle screw hole temporarily.
- If you are setting the platen's height to the highest position, attach two collars and fix the platen bearing at its lowest screw hole temporarily.

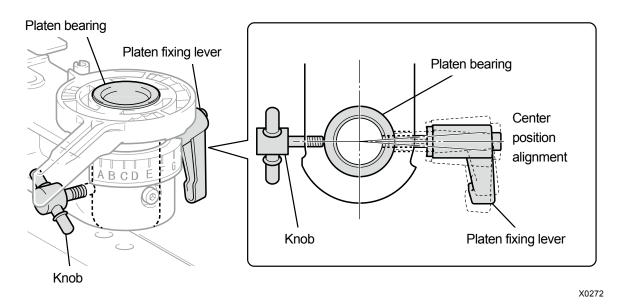


X0271

(9) Tighten the knob to secure the platen bearing in place.<TIPS>

(10) Insert the platen to be used and tighten the platen fixing lever.

 Align the center of platen fixing lever with the position as illustrated in the figure below, and secure the platen bearing in place.

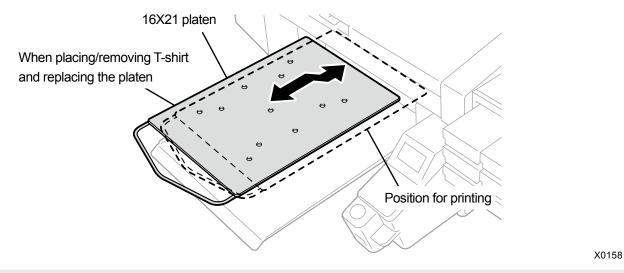


6-4-3. Using the 16X21 platen

<CAUTION>

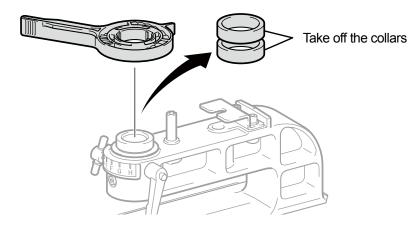
- When using the 16X21 platen, handle it with care because it is heavy. Be sure not to touch the moving parts of the platen. Otherwise you may be injured.
- When you slide the 16X21 platen manually, move it slowly.

When you place or remove a T-shirt, and when you replace the platen, manually slide the platen forward and draw it out of the main unit completely to perform such operation. At this time, slide the platen while lifting it a little. When you perform printing, slide the platen backward and return it to the printing position before starting the print process.

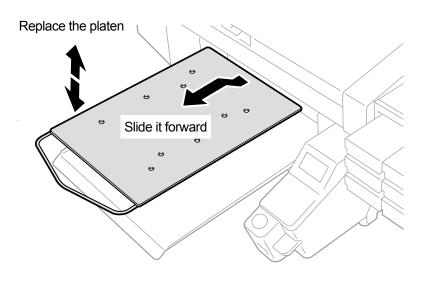


<TIPS>

When using the 16X21 platen, remove all the collars for height adjustment before using it. For information on platen height
adjustment, refer to "6-4-2. Platen height adjustment >>P.151".



- (1) On the operation panel, press [1], and move the 16x21 platen toward the front of the printer.
- (2) Slide the 16X21 platen while lifting it a little to draw it forward.
- Perform the work for placing or removing a T-shirt and replacing the platen in this condition.
 <TIPS>
 - For information on replacing the platen, refer to "6-5. Placing print medium in position >>P.162".
 - For information on placing or removing a T-shirt, refer to "6-5. Placing print medium in position >>P.162".



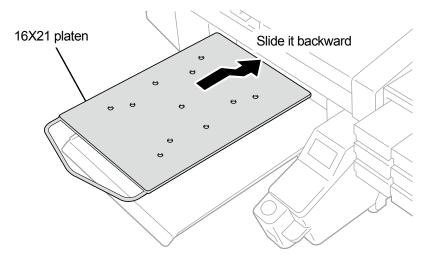
X0166

(4) When you finish placing or removing a T-shirt, and replacing the platen, slide the platen backward and return it to its printing position.

<IMPORTANT>

 As the platen is positioned higher when it is slid forward, it is detected by the obstacle sensor, which prevents printing from being performed. However, if the platen's height is set at the lowest position, the platen is not detected by the obstacle sensor, and printing may be performed outside the print range of the platen.

Make sure to start printing after sliding the platen to the printing position.



6-5. Placing print medium in position

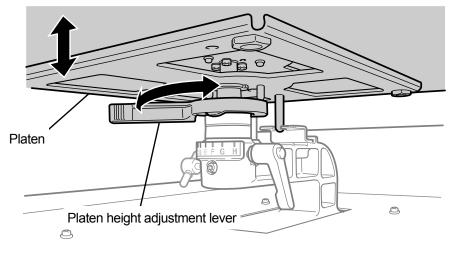
In order to provide an optimum printing image quality when a print medium is placed in position, you need to adjust the platen's height in accordance with the thickness of the T-shirt or other print medium. <CAUTION>

- Ensure there is adequate space left in front of the printer and avoid placing any objects that may hinder your movement or the complete movement of the platen. The platen moves forward while operating and it can strike/damage anything set in its path of movement.
- Do not handle the platen while printing. If your hand gets caught between the platen or the T-shirt tray and the covers, it may be injured.

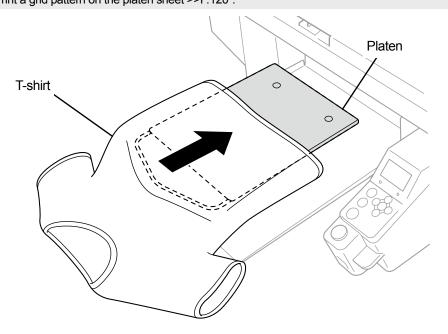
<IMPORTANT>

• Do not move the platen by hand. Otherwise the printer may be mechanically and electrically damaged.

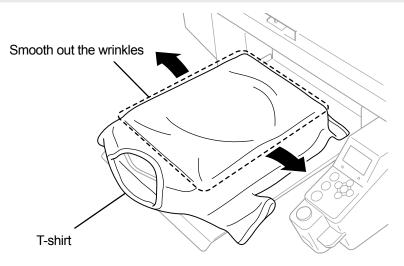
- <TIPS>
- Adjust the height of the platen corresponding to the print medium before using it. You can use the platen height adjustment lever to adjust the height of the platen. As a rough indication, adjust the height so that it is lowered by one step from the limit height detected by the obstacle sensor, and check that the platen is not detected by the sensor.
 In the event that the platen's height is lowered excessively, ink mist will be scattered inside the printer, which may result in staining of the printing surface, blurring of the printed image, and malfunction of the sensor and the main unit.
- Use Uni-Directional Printing in the case where the platen's height needs to be lowered to avoid a hemmed (edge) and seam. "9-1. Setting the print direction >>P.297".
- You can specify the Uni-Directional Printing for each print data from the printer driver as well. \$\conv="5-4-11. Specify the print direction >>P.117".
- When you print a thick printing material, you can always lower the platen's height by adjusting the platen bearing, collars. \$\color"6-4-2. Platen height adjustment >>P.151".
- (1) If the platen has not been moved forward, press **1** on the operation panel.
- (2) Use the platen height adjustment lever to adjust the height of platen. <TIPS>
 - Set the platen height adjustment lever to the position around "A" for a T-shirt, or to the position "C" for such thick material as a sweatshirt.
 - If the platen's height is lowered too much, the printing quality may deteriorate, the main unit may be soiled with ink mist and so on.



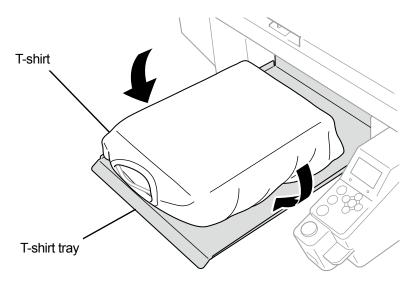
- Put a T-shirt onto the platen, with its printing side facing upward.
 <IMPORTANT>
 - If the 16X21 platen is mounted, slide it forward and place a T-shirt on it.
 <TIPS>
 - For the position alignment of white or pale-colored T-shirts, a grid to be printed out on the platen sheet is available from [All Programs] in the Start menu, by selecting "Brother GTX pro Tools" > "Useful Tools".
 "5-5-4. Print a grid pattern on the platen sheet >>P.120".



- (4) Smooth down the creases in the T-shirt and remove lint and dust from it.
 <TIPS>
 - Seams on a hemmed (edge), neck portion, armhole, tucks and sleeves or the like are easily detected by the obstacle sensor.
 - In particular, both ends of the T-shirt tend to be raised easily during the printing operation if not flattened properly and detected by the obstacle sensor.
 - Touching on the fixated pretreated surface should be avoided during the work.
 - Do not pull the T-shirt with the pretreatment applied. Instead, flatten it in such a way that it will fit onto the platen surface well.
 - When the surface of the T-shirt does not remain flattened properly, the obstacle sensor detects it.
 - In the event that any T-shirt is placed on the platen by pulling it outward forcibly, there are instances in which ejection areas
 of the white and color inks are misaligned and the white ink extends off its specified printing area. In particular, be careful
 not to stretch a thin T-shirt outward on the platen.



(5) The T-shirt should be placed on the T-shirt tray, trying not to draw the excessive parts like sleeves and hems into the printer.



X0112

(6) On the operation panel, press U, and move the platen toward the rear of the printer.

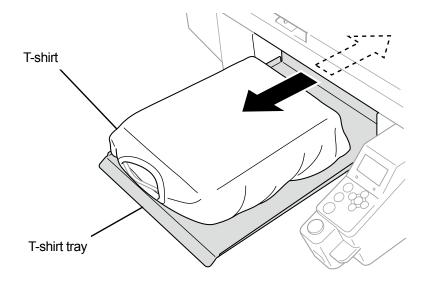
Try moving the platen, and check on the gap between the T-shirt surface and the obstacle sensor over the entire print area. <TIPS>

- If this gap is too wide, adjust it by rotating the platen height adjustment lever.
- Adjust the height so that it is lowered by one step from the limit height detected by the obstacle sensor, and check that the
 platen is not detected by the sensor.
- If the platen's height is too high, a print medium will strike against the print head during the printing process, which in turn
 results in ink stains or malfunction.
- If the 16X21 platen is mounted, manually slide it backward until it returns to the original position, then move the platen toward the rear of the printer.
- (7) On the operation panel, press

and move the platen toward the front of the printer.

<TIPS>

- Repeat the height adjustment until the platen will be positioned at a proper height.
- After your desired height is determined, start the printing operation. ""6-7. Executing a printing job >> P.174".



6-6. Sending/Loading Print Data

Print data can be loaded into the printer in the following ways:

- Receive the print data from the PC connected with the USB or LAN cable.
- Load the print data from the USB flash.

For details, please refer to the chapters described later.

6-6-1. Sending print data from ARXP file preview

(1) Open an ARXP file.

<TIPS>

- Double click on the ARXP file, or select [All Programs] > "Brother GTX pro Tools" > "GTX pro File Viewer", to select and open the ARXP file.
- (2) The file's printing conditions and preview window will be displayed.

<TIPS>

- If you have selected [Color+White Ink] or [White Ink Only] in the Select Ink operation, the preview window will be displayed against a "Black" background or a "Transparent color" background which has been specified in the Advanced settings.
- If you have selected [Color Ink Only] in the Select Ink operation, the preview window will be displayed against a "White" background.
- When you press the Details button, those items that have been specified in the Advanced setting window of the printer driver appear.
 - When [Color+White Ink] or [White Ink Only] is selected

C:\GTX pro\IMG_1404.arxp		- 🗆 X
Job Name : Date :	IMG_1404 13/02/2020 15:06	-7.0 0 7.0
Platen Size :	14x16	
Select Ink :	Color+White Ink	
Highlight :	5	
Mask :	3	
Print Time :	x 1	
Whiteness :	400 %	- CRAMER CALLER AND CALL
Use background black color :	Off	
Color Multiple Pass Printing :	Off	
Details		
Color Ink :	0.97 cc	8.0 - <
White Ink :	8.65 cc	100%
Print :	1 piece	
Send to Printer		Present Layer 1 W+CMYK \checkmark White Data
Browse Close	9	Background Color Change

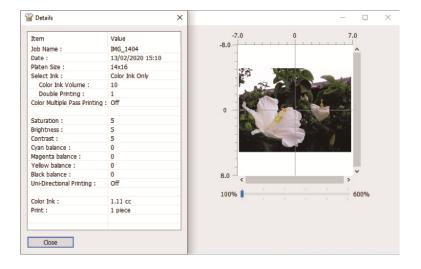
• When [Color Ink Only] is selected

C:\GTX pro\IMG_1404.arxp			_		×
Job Name : Date :	IMG_1404 13/02/2020 15:10	-8.0	7	 ^	
Platen Size :	14x16		1		
Select Ink :	Color Ink Only	-			
Color Ink Volume :	10	0 —		-	
Double Printing :	1	-			
Color Multiple Pass Printing :	Off	-			
Details		-			
Color Ink :	1.11 cc	8.0 - <	>		
Print :	1 piece	100%		600%	
Send to Printer					
Browse Close	•				

.

• [Details]

.



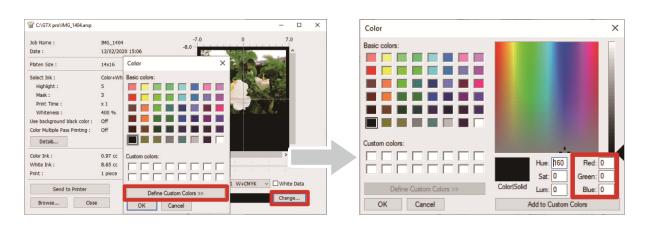
(3) If you have selected [Color+White Ink] or [White Ink Only] in the Select Ink operation, you can change the

background color of the preview window and preview the print image. Select [Change...] > [Define Custom Colors],

and enter RGB value.

<TIPS>

• When the [White Data] checkbox is marked, the preview window for white ink only will be displayed.



"Example: Preview window for printing an image on a brown (R=128, G=64, B=64) T-shirt"

lob Name :	IMG_1404	-7.0 0 7.0
Date :	13/02/2020 15:06	
Platen Size :	14x16	
Select Ink :	Color+White Ink	
Highlight :	5	
Mask :	3	
Print Time :	x 1	
Whiteness :	400 %	
Jse background black color :	Off	
Color Multiple Pass Printing :	Off	
Details		
Color Ink :	0.97 cc	8.0 - < >
White Ink :	8.65 cc	100%
Print :	1 piece	
Send to Printer		Present Layer 1 W+CMYK \checkmark White Data

(4) For the print data that requires multiple cycles of platen reciprocate movement, print data of each layer can be

verified separately by selecting the desired layer to be displayed. From the [Present Layer], select a layer that you

want to bring into the view.

<TIPS>

- In the layer that is shown as [Total], the preview window of the final print result is displayed.
- When the [White Data] checkbox is marked, the preview window for white ink only will be displayed.

lob Name :	IMG_1404	-7.0 0	7.0
Date :	13/02/2020 15:06	-8.0	^
Platen Size :	14x16		
Select Ink :	Color+White Ink		1.025
Highlight :	5		
Mask :	3		1 × × /
Print Time :	x 1		No. of the second s
Whiteness :	400 %		Watter C
Jse background black color :	Off		
Color Multiple Pass Printing :	Off		
Details		-	
Color Ink :	0.97 cc	8.0 - <	>
White Ink :	8.65 cc	100%	600%
Print :	1 piece		
		Present Layer Total	White Data

(5) Check the printing conditions and preview window, and click on [Send to Printer]. Then, the ARXP file is sent to the printer.

<TIPS>

- Make sure that a connection of USB 2.0 cable or LAN cable is made between your PC and the printer.
- In the event that two or more GTX pro printer drivers have been installed on your PC, select one of them and click [OK].

C:\GTX pro\IMG_1404.arxp		- 0
Job Name : Date :	IMG_1404 13/02/2020 15:06	-7.0 0 7.0
Platen Size :	14x16	
Select Ink :	Color+White Ink	
Highlight :	5	
Mask :	3	
Print Time :	x 1	
Whiteness :	400 %	
Use background black color :	Off	
Color Multiple Pass Printing :	Off	
Details		
Color Ink :	0.97 cc	8.0 <
White Ink :	8.65 cc	100%
Print :	1 piece	
Send to Printer		Present Layer 1 W+CMYK v White Data
Browse Close	2	Background Color Change

6-6-2. Sending print data from applications

CorelDRAW

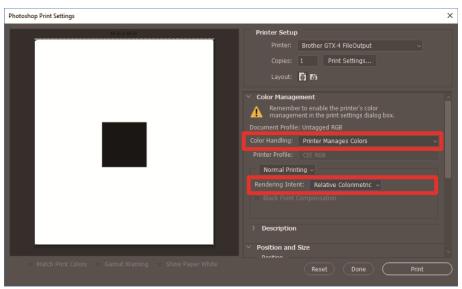
- (1) In the menu bar, select [File] > [Print].
- (2) Open the [Color] tab, and make the following settings:
 - Place a checkmark in the [Document color] checkbox.
 - [Color conversions]: "Brother GTX pro" or "Brother GTX pro FileOutput"
 - [Color profile]: [sRGB IEC61966-2.1]
 - [Rendering intent]: [Relative colorimetric]

eneral Color Composite	Layout Prepress 1 Issue
Color:	● <u>C</u> omposite ○ <u>S</u> eparations
Settings:	Document color Color proof
Color conversions:	Brother GTX pro FileOutput 👻
Output colors:	RGB 🔫
	✓ Convert spot colors to RGB
Color profile:	sRGB IEC61966-2.1 💌
	☑ Preserve RGB numbers
	Preserve pure <u>b</u> lack
Rendering intent:	Relative colorimetric 🔹
The color settings and preview Graphic device printer that you	available in this dialog box are set for the Windows selected on the General tab.

- (3) Open [General] tab and select "Brother GTX pro" from [Printer].
 <TIPS>
 - If the specified [Printer] is set to "Brother GTX pro", the print data will be sent to the printer.
 If the specified [Printer] is set to "Brother GTX pro FileOutput", the print data will be saved as an ARXP file.
- (4) On [Preferences], set up the printer driver and send the print data by clicking [OK] in the [Print] dialog box.
 <TIPS>
 - Setting the printer driver \$\$"5-4. Set up the printer driver \$\$P.101"
 - Clicking on [OK] will not start the print operation of the printer itself. The print button of the printer should be pressed to start the printing operation.

Adobe Photoshop

- In the menu bar, select [File] > [Print]. If the PC's default printer is either "Brother GTX pro" or "Brother GTX pro FileOutput", the layout is set to the platen size.
- (2) Make the settings as follows:
 - [Color Handling]: [Printer Manages Colors]
 - [Rendering Intent]: [Relative Colorimetric]



- (3) From [Printer], select "Brother GTX pro". <TIPS>
 - If [Printer] is set to "Brother GTX pro ", the print data will be sent to the printer.
 If [Printer] is set to "Brother GTX pro FileOutput", the print data will be saved as an ARXP file.
- In the [Print Settings], set up the printer driver, and send the print data by clicking [Print].
 <TIPS>
 - Setting the printer driver \$\$"5-4. Set up the printer driver >>P.101"
 - Clicking on [Print] will not start the print operation of the printer itself. The print button of the printer should be pressed to start the printing operation.

Adobe Illustrator

- (1) In the menu bar, select [File] > [Print] > [Color Management].
- (2) Make the settings as follows:
 - [Document Profile]: [sRGB IEC61966-2.1]
 - [Color Handling]: [Let Illustrator determine colors]
 - [Printer Profile]: [sRGB IEC61966-2.1]
 - [Rendering Intent]: [Relative Colorimetric]

Print		
	Print Preset: Custom	× 🛃
	Printer: Brother GTX pro FileOutput	
General Arrow Arr	Color Management Print Method	
Output Graphics	Document Profile: sRGB IEC61966-2.1	
Color Management	Color Handling: Let Illustrator determine colors Printer Profile: sRGB IEC61966-2.1	~ (i) ~
	Rendering Intent: Relative Colorimetric	
	Description	
I4 4 1 of 1 ► M Document: 355.6 mm x 406.4 mm		
Media: 355.6 mm x 406.4 mm	Done Print	Cancel

- (3) From [Printer], select "Brother GTX pro".
 - <TIPS>
 - If [Printer] is set to "Brother GTX pro", the print data will be sent to the printer.
 If [Printer] is set to "Brother GTX pro FileOutput", the print data will be saved as an ARXP file.
- In the [Advanced], set up the printer driver, and send the print data by clicking [Print].
 <TIPS>
 - Setting the printer driver \$\$"5-4. Set up the printer driver >>P.101"
 - Clicking on [Print] will not start the print operation of the printer itself. The print button of the printer should be pressed to start the printing operation.

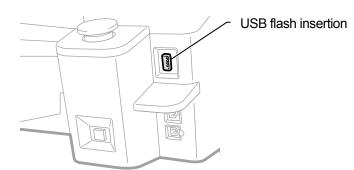
X0038

6-6-3. Loading print data (ARXP file) from USB flash memory

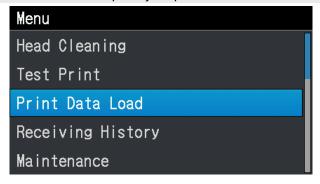
Insert a USB flash memory into the insertion slot near the operation panel of the printer.
 <IMPORTANT>

Do not apply undue force to the USB flash memory when you insert it into the slot. Otherwise, it could be damaged.
 <TIPS>

- Please use a FAT32-formatted USB flash memory of which storage capacity is 2 GB to 32 GB in total. You cannot use a
 USB memory with security functions such as password lock function or beyond 32 GB.
- Note that the data which can be loaded from the USB flash memory is only the data in the ARXP or ARX4 format.



- (2) From the menu, select [Print Data Load], and press <TIPS>
 - The information on file is shown on the liquid crystal panel.



(3) Select a filename to be printed out, and press

<TIPS>

- Selecting i will display the file stored in
- Folders in the USB flash memory are shown down to the 3rd layer. Folders created in the 4th layer or below are not displayed.

• Select data file	•<
🗀 Sample Folder1	Sample Folder1
🔁 🗅 Sample Folder2	Sample Folder2
2 Sample Data1.arx4	Sample Data1.arx4
Sample Data2.arxp	2 Sample Data2.arxp
Sample Data3.arxp	Sample Data3.arxp

(4) Check the print image displayed in the preview window, and press

<IMPORTANT>

• Never touch the USB flash memory when the print button is blinking. Otherwise, any already-saved data may be corrupted. <TIPS>

- Depending on data size, it may take several minutes before the loading process is completed.
- When any files of USB flash memory cannot be read out For GTX prose "10-1. Troubleshooting instructions >>P.316" For GTX pro Bulk "11-1. Troubleshooting instructions >>P.380"
- If a folder contains more than one print data, you can use $\blacktriangle \nearrow \blacksquare$ buttons to switch the preview display screen.
- It is possible to change the direction of the preview display screen as well. \$\$"9-7. Preview display settings >>P.300".



The print data loading will be completed when the print button stops blinking and remains lit, while the electric chime sounds.

6-7. Executing a printing job

6-7-1. Executing a print job once for a single print medium

(1) Receiving a print data file.

The print button blinks during reception of data. When the data reception is completed, an audible alarm is activated and the print button illuminates.

As there are two types of audible alarms, make sure the mounted platen matches the platen size of the print data. <TIPS>

- When data of the same platen size as the previous one was received: A notice sound of "ping-pong" is output.
- When data of a different platen size from the previous one was received: A notice sound of "ping-pong pan-pong" is output.
- (2) Make sure that the print data you want to print out is displayed on the liquid crystal panel, and press the print button

to start the printing.

When the printing is completed, the platen moves to the forward-most position and the sound of "pong" is heard. <TIPS>

- If the print button is pressed when the platen has not moved toward the front, the platen will move toward the front of the printer, but no print job will be started. In this case, press the print button once again.
- Pressing (causes the printing to be canceled.
- The printer may shift to low temperature operation mode, when the room temperature is less than 18°C (64.4°F) and white ink is used.

During low temperature mode, it may take a longer time for print operation and maintenance before starting the print. Change the low temperature operation setting as needed. " "9-11. Print Operation Settings Under Low Temperature >>P.302".

High-temperature and low-humidity environment may prolong the maintenance time after completion of printing. If any
warning message about temperature and humidity is displayed, be sure to control the temperature and humidity promptly
so as to conform with the print warranty scope. "13-1. Apparatus >>P.473"

6-7-2. Executing a print job several times for multiple print media

You can keep the identical print data and execute a print job several times for multiple print media. <TIPS>

- When the power is turned off, the retained print data is erased.
- In the event that [ON] is selected from the [Auto Job Delete] in the [Printer Setting] window, the print data will be erased after the
 printing of the specified number of print media is completed. To change the setting, refer to "9-16. Automatic deletion of print data
 >>P.305".
- (1) Make sure that the print data you want to print out is displayed on the liquid crystal panel, and press the print button

to start printing.

When the printing is completed, the platen moves to the forward-most position and the sound of "pong" is heard. <TIPS>

- If the print button is pressed when the platen has not moved toward the front, the platen will move toward the front of the printer, but no print job will be started. In this case, press the print button once again.
- Pressing (causes the printing to be canceled.
- The number of print media of which printing is completed is shown on the liquid crystal panel.
- The printer may shift to low temperature operation mode, when the room temperature is less than 18°C (64.4°F) and white ink is used.

During low temperature mode, it may take a longer time for print operation and maintenance before starting the print. Change the low temperature operation setting as needed. "9-11. Print Operation Settings Under Low Temperature >>P.302".

- High-temperature and low-humidity environment may prolong the maintenance time after completion of printing. If any
 warning message about temperature and humidity is displayed, be sure to control the temperature and humidity promptly
 so as to conform with the print warranty scope. "13-1. Apparatus >>P.473"
- (2) Replace the platen's printed medium (T-shirt) with the next one and repeat the procedure until the desired number of print jobs are completed.

6-7-3. Performing the printing from receiving history

You can print out such print data that you have received before. <TIPS>

- The print data that can be retained are max. 100 pieces of them and 800 MB in total capacity, wherein each print data will be erased in the order from the oldest to the latest.
- When the power is turned off, the retained print data is erased.
- In the event that [ON] is selected from the [Auto Job Delete] in the [Printer Setting] window, the print function in the [Receiving History] is disabled. Change the settings as needed. "9-16. Automatic deletion of print data >>P.305"
- From the menu, select a print data you want to print out in the [Receiving History].
 <TIPS>
 - Each of the pieces of print data is displayed in the order in which they are received from the newest to the oldest ones.
- (2) Make sure that the print data you want to print out is displayed on the liquid crystal panel, and press the print button

to start the printing.

When the printing is completed, the platen moves to the forward-most position and the sound of "pong" is heard. <TIPS>

- If the print button is pressed when the platen has not moved toward the front, the platen will move toward the front of the printer, but no print job will be started. In this case, press the print button once again.
- Pressing (causes the printing to be canceled.
- The printer may shift to low temperature operation mode, when the room temperature is less than 18°C (64.4°F) and white ink is used.

During low temperature mode, it may take a longer time for print operation and maintenance before starting the print. Change the low temperature operation setting as needed. ""9-11. Print Operation Settings Under Low Temperature >>P.302".

High-temperature and low-humidity environment may prolong the maintenance time after completion of printing. If any
warning message about temperature and humidity is displayed, be sure to control the temperature and humidity promptly
so as to conform with the print warranty scope. #"13-1. Apparatus >>P.473".

6-8. Scheduling a print

When the printer is not in the standby state, you can schedule a print by pressing the Print button so that the printer will perform a print as soon as it returns to the standby state.

6-8-1. When you can schedule printing

You can schedule printing by pressing the Print button in advance while the print data is being received, during the post-print processing, and during the circulation of white ink.

This is useful if the printer performs the post processing for the previous print job after you remove the printed T-shirt and set a new T-shirt to the platen.

<TIPS>

- Be sure to remove the printed T-shirt from the platen and set the next T-shirt to the platen before you press the Print button.
- You cannot press the Print button in advance if the printer is being operated from the menu or an error has occurred.

When you can schedule printing	Description
The printer is receiving print data	While the printer is receiving print data sent via the USB or LAN cable
The printer is post-processing after	When a print job finishes and the platen is unloaded and while the printer is wiping,
a print	capping, cleaning the wiper, or performing an auto purge after a print job
During the white ink airculation	While the white ink is being circulated inside the printer at specified intervals or at a
During the white ink circulation	scheduled time for circulation

6-8-2. When a scheduled print begins

A scheduled print begins when each of the following conditions is true:

When you schedule printing	When the print begins
The printer is receiving print data	When the printer has completely received print data
The printer is post-processing	When the printer has finished all the processes such as wiping, capping, cleaning
after a print	the wiper, or an auto purge after a print job
During the white ink circulation	When the white ink circulation is completed

Even if the condition for the print to begin is met, the print does not begin and the schedule is cancelled in the following cases:

Probable Cause	What occurs when you press the Print button
An error occurs when the print should begin	"Ink has been depleted", "Cleaning solution has been depleted", "Part
	cleaning/replacement time", "Temperature where operation is not
	guaranteed"
The required print data is missing when the	The data that was being printed when you scheduled the print was
print should begin	deleted by the [Auto Job Delete] function

<TIPS>

• The Print button flashes fast during the period between when you schedule printing and when the printing begins.

6-8-3. When printing does not begin

A scheduled printing does not begin when each of the following conditions is true:

- If an error occurs when printing should begin. (For example, this is true if the ink is depleted in the previous print job.)
- If the data to print is missing from the printer when printing should begin. (For example, this is true if the data being printed when you schedule printing is deleted by the [Auto Job Delete] function. ³⁹-16. Cancelling scheduled printing)

6-8-4. Cancelling scheduled printing

You can cancel scheduled printing by pressing the Cancel button during the period between when you schedule printing and when printing begins.

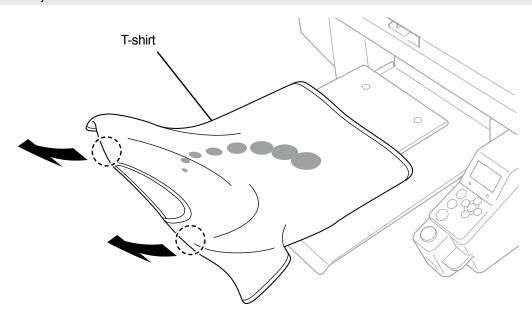
If you schedule a print during the white ink circulation and press the Cancel button, both the white ink circulation and the scheduled print are cancelled.

6-9. Removing printed matter from platen

- Hold the shoulder portions of print medium with your hand, and pull it out slowly in the forward direction indicated.
 <IMPORTANT>
 - Because the printed surface is still wet with ink, avoid touching it.
 - If any ink is attached to your hands, wash your hands with soap and water.
 - Those inks that are attached to fabrics cannot be cleaned up, please handle the inks with utmost care.

<TIPS>

 The printed ink is not fixated at this point - therefore, handle the T-shirt with care to avoid the printed surface touching with other objects.



6-10. Fixation of ink

For fixation of ink, use the heat press or oven.

Heat press

It is useful because you can control its temperature and operating time with ease.

Oven

If the number of articles to be printed is high, it will improve the operational efficiency.

<CAUTION>

• Please use the heat press and oven in a well-ventilated area. If your working area is not well ventilated, wear a protective mask. <TIPS>

- If the inks are fixated insufficiently, discoloring may occur due to washing and friction.
- Keep the fixation surface of heat press and peel-off sheet clean.
 Otherwise, the printing surface may be soiled with stains from the peel-off sheet.
- If a printed material is rubbed with vinyl-chloride-based white or light-colored synthetic leather, color transfer may occur.
 When a color-printed surface is rubbed strongly against a printed surface with only white ink, color transfer may occur in the same fashion.

When a color transfer takes place, wipe the color-transferred area and clean off dirt with a soft and clean cloth or a toothbrush that is moistened with a small amount of mild detergent for home use and/or alcohol.

Component of pretreatment remains on the T-shirt on which the ink was fixated after applying pretreatment. For this reason, it is
advisable to wash such T-shirts with water before wearing them.

Guidelines on fixation conditions of ink

The undermentioned fixation temperature/time serve as guidelines only, and optimum conditions vary with your heat press or oven. Be sure to perform the fixation after checking on the temperature and fixation results beforehand. <TIPS>

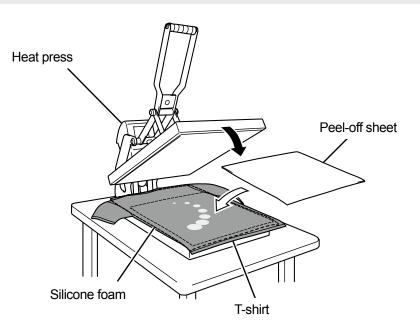
- Because optimum conditions vary depending on the type of your heat press or oven, use the fixation conditions as a reference guide. Be sure to adjust the conditions while checking on the temperature and ink fixation results beforehand.
- Because some print media easily get scorched, please carefully check and see how the surface actually looks like. In particular, the print media onto which the pretreatment has been applied will easily get scorched.
- When using the heat press, adjust the pressure while checking the ink fixation result.
- If it is not dry enough after processing for the period of the guideline, extend the time while checking the dried condition of the ink.

Device	Temperature	Time
Heat press	180°C (356°F)	35 seconds
Oven	Surface temperature: 160°C (320°F)*1	3 min. and 30 sec. to 5 min.

*¹: Because a T-shirt may be discolored if this temperature increases too high, great care should be taken to exercise temperature control.

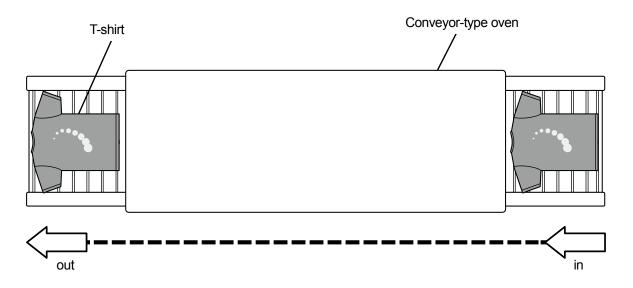
Ink fixation by means of heat press

- Place the silicone foam, T-shirt and peel-off sheet in position under the heat press first, and fixate the ink properly.
 <TIPS>
 - For the guidelines on fixation conditions of ink #6-10. Fixation of ink >>P.180".
 - For details, refer to the instruction manual of your heat press.
 - There is a tendency to bring the print result to an almost matte finish if a silicone-coated paper is used as a peel-off sheet or to an almost bright finish if a fluororesin sheet is used as the same at the ink fixation stage. Selectively use either of them according to your desired finish.



Ink fixation by means of conveyor-type oven

- (1) Fixate inks onto a T-shirt by means of the conveyor-type oven.
 <TIPS>
 - For the guidelines on fixation conditions of ink³"6-10. Fixation of ink >>P.180".
 - For the conveyor-type oven, identify the oven's internal temperature, and check up on actual ink fixation result.
 - For details, refer to the instruction manual of your conveyor-type oven.



	DANGER
Ŕ	Contact with high voltage sections may lead to a serious injury. Turn off the power, and remove the cover 5 minutes later.
	Be careful not to get your fingers caught when closing the front cover, otherwise it may result in injury to your fingers.
S	Do not disassemble the ink pouch. If the ink gets into your eyes or onto your skin, it may cause inflammation. In case of contact with eyes, do not rub but immediately rinse the eyes with water.
\mathcal{S}	Do not disassemble the ink cartridge.
S	Do not drink liquids such as the ink, maintenance solution, cleaning solution, pretreatment, or waste. They may cause diarrhea or vomiting. Avoid causing your eyes or skin to make contact with the ink, maintenance solution, cleaning solution, pretreatment or waste. It may cause inflammation. In case of contact with eyes, do not rub but immediately rinse the eyes with water. Keep the liquids out of the reach of children.
9	Be sure to wear protective goggles and gloves when handling the grease, so that it does not get into your eyes or onto your skin. It can cause inflammation. Do not drink or eat the grease. It may cause diarrhea or vomiting. Keep the liquids out of the reach of children.
9	When replacing parts and installing optional accessories, be sure to use only genuine Brother parts. Brother will not be held responsible for any accidents or problems resulting from the use of non-genuine parts.
0	When replacing parts or installing optional accessories, be sure to follow the procedures described in the Instruction Manual. Incorrect procedures could cause injuries or problems.

((!))IMPORTANT

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Do not move the platen by hand. Otherwise the printer may be mechanically and electrically damaged.

Ensure there is adequate space left in front of the printer and avoid placing any objects. The platen may be hit and damaged.

7-1. Tasks to be performed regularly

7-1-1. Replacement of ink pouch with a new one

If the 🚺 is displayed in the remaining ink volume indication window on the operation panel screen, replace the ink

pouch which is marked with X with a new one. <IMPORTANT>

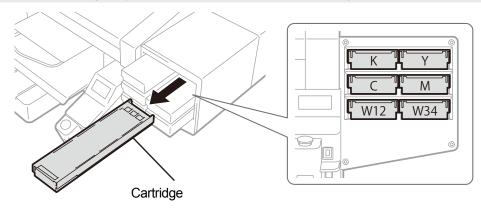
- No cartridges can be refilled with any ink. Do not disassemble the ink pouch. In order to use the printer for a long period and to take full advantage of its capabilities, we recommend to use the ink pouches that are specified by us.
- During the printing process or head cleaning operation, avoid replacing any ink pouch with a new one. Otherwise, the printer may break down.

<TIPS>

- If you replace an ink pouch that still has much amount of remaining ink in the way of use, the remaining ink volume indication window may not display the correct remaining volume.
- Any ink pouch has been designed to leave a small amount of ink in it when reading the end of its service life. This is required to protect the printer and keep its good printing quality. Please keep this matter in mind.

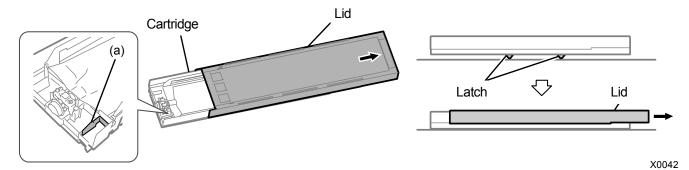


- (1) Take out the ink cartridge displayed on the screen from the printer. <CAUTION>
 - The bottom of the cartridge may be soiled with ink. Clean the printer on a regular basis.

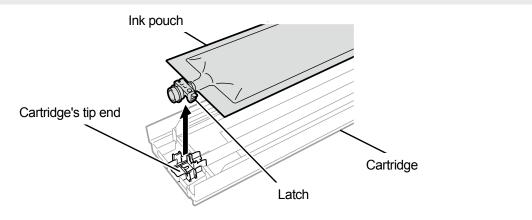


(2) Open the cartridge's lid.

- <IMPORTANT>
- When opening the lid, be sure not to touch the portion (a). Otherwise, it could be damaged.
- Place the entire cartridge on a flat surface, push the latches on the bottom surface of the cartridge downward and open the lid.



- (3) Pinch the latch at the front end of ink pouch, and draw out the depleted ink pouch from the cartridge. <CAUTION>
 - Remove the accumulated ink at the tip of the cartridge with a waste cloth (non-fuzzy cloth). Clean the printer on a regular basis.

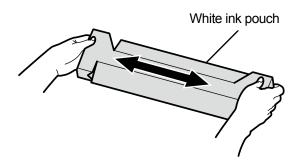


(4) Unpack a new ink pouch from its shipping carton.

For the white ink pouch, shake it 100 times each in the side to side direction with its obverse side and reverse side facing upward separately, as shown below.

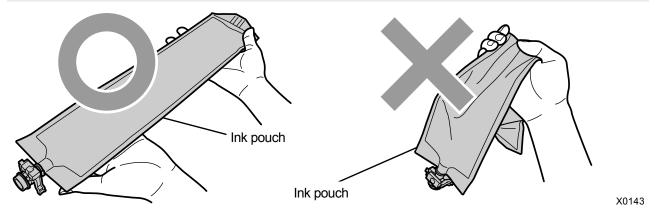
<NOTE>

Shake the pouch under the condition it remains contained in the inner box.



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- (5) Unpack a new ink pouch from its inner box.<IMPORTANT>
 - Do not place the ink pouch near the sharp edges. It could break the pouch and leak the contained ink.
 - Handle the ink pouch with care. It could be damaged when bent, snagged by sharp objects, or dropped.



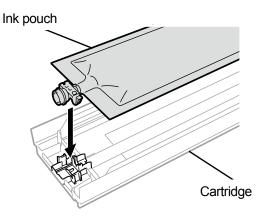
(6) Put a new ink pouch in the cartridge.

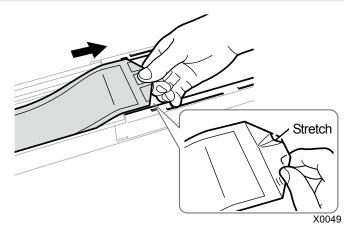
Push the tip end of the ink pouch into the cartridge until it clicks into place.

Straighten the ink pouch in such a manner that it will be aligned with the gutter of lid of cartridge, and mount in position by pulling it with your hand.

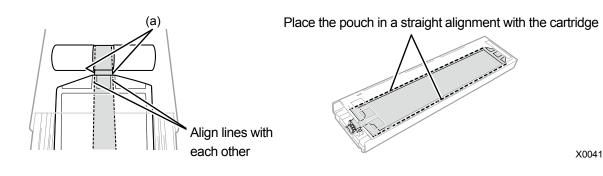
<NOTE>

• If the edge of the ink pouch is bent or undulating significantly, make it straight with your hand.





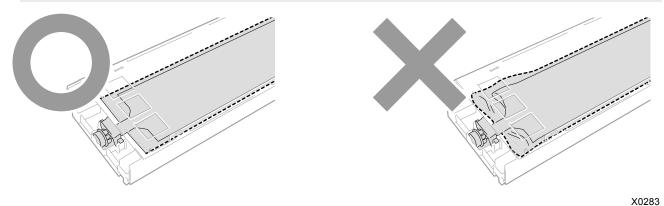
- (7) Put the ink pouch in its correct position.<CAUTION>
 - Avoid touching the portion (a) of cartridge. Otherwise, you may cut your hand.



(8) Close the lid, and put the ink cartridge in position inside the printer.

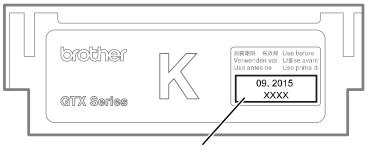
- <IMPORTANT>
 - Be sure to put a cartridge in its correct position. If a different ink cartridge is put by mistake, the applicable print head may be adversely affected. If a cartridge of different color is placed, please set it into the right position. If colors are mixed on the print result or within the ink pouch, please contact your dealer.
 - When setting the cartridge, do not shake the cartridge with the ink pouch facing down with the aim of facilitating the winding
 of the pouch.

Doing so will cause wrinkles, and the proper winding of the ink pouch will not be possible.



<NOTE>

- Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.
- (9) Attach a shelf life seal included with ink pouch onto the front surface of the cartridge.

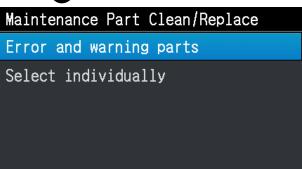


Shelf life label

7-1-2. Cleaning and replacement of maintenance parts

Clean or replace individually selected maintenance parts.

- (1) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press
- (2) Select [Select individually] and press



(3) Select the maintenance part you want to clean or replace following the message and press

<TIPS>

• The nozzle guard, wiper, exhaust cap, and suction cap should be cleaned at the same time.

(4) Clean and replace.

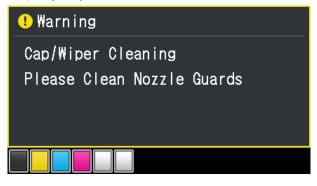
<TIPS>

- For the way to perform cleaning and replacement, refer to the respective maintenance parts.
 - ☞"7-1-3. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.188"
 - ☞"7-1-4. Replacing the wiper cleaner >>P.200"
 - ☞"7-1-5. Replacing the flushing foam >>P.203"
 - ☞"7-1-7. Replacing the fan filter >>P.211"

7-1-3. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap

When a warning message appears in the warning message window, perform the cleaning.

In the event that maintenance has been performed inadequately, a printed material may be soiled with waste ink during a print session or a printed surface quality may deteriorate.



- (1) Make the clean stick R, clean stick T, cleaning cup, gloves and cleaning solution, which come standard with the printer, available for use.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press
- (3) Select [Part with Error/Warning] and press

<IMPORTANT>

• If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

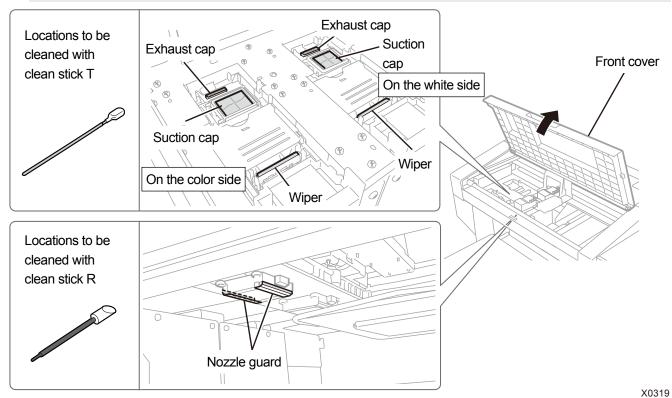
- Pressing causes the platen to start moving. Do not put anything around the platen.
- (4) Follow the on-screen message and turn off the power.

<IMPORTANT>

- Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
- If the task takes more than 15 minutes to complete, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.

(5) Open the front cover, and clean each of the nozzle guards, wipers, exhaust caps, and suction caps.

Two types of clean sticks are provided. Use either the clean stick T or R depending on what you want to clean. <TIPS>



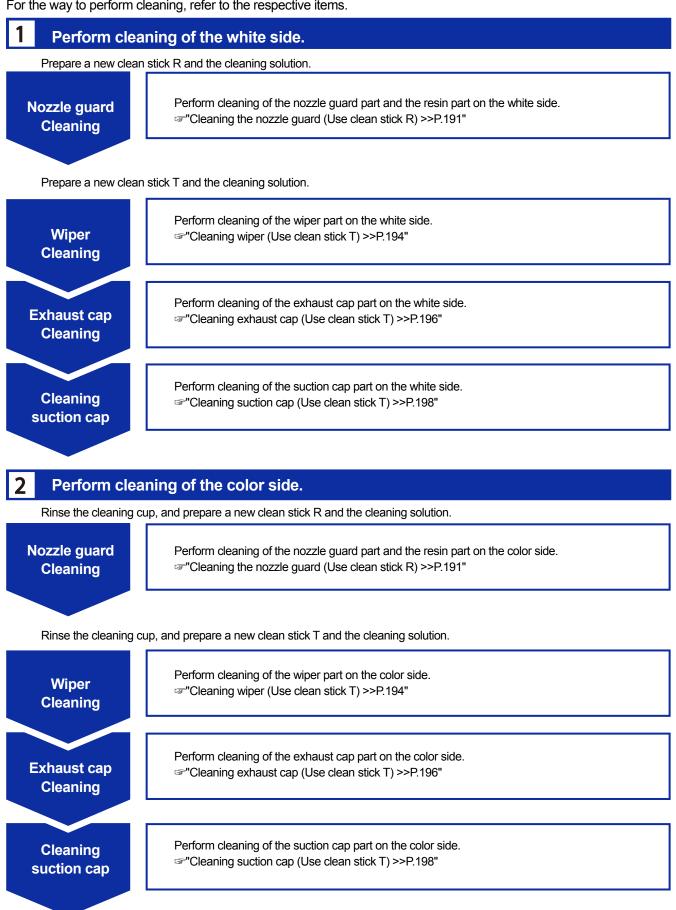
• For the cleaning method, refer to the description mentioned below.

- (6) After the cleaning is completed, close the front cover.
- (7) Turn on the power.

<NOTE>

- Dispose of any waste resulting from the cleaning in accordance with applicable laws and ordinances.
 <TIPS>
- Then, a head cleaning will be performed to prevent any ink from drying up.
- Because the cleaning cup will be reused, rinse it in clean cleaning solution and store it in a safe place.

Cleaning of the nozzle guard, wiper and exhaust cap should be performed separately for the white side and color side. For the way to perform cleaning, refer to the respective items.

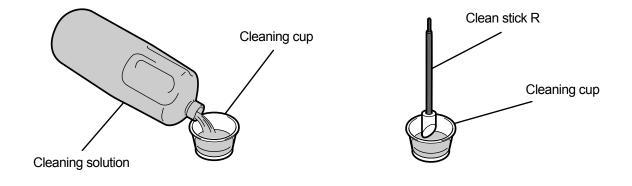


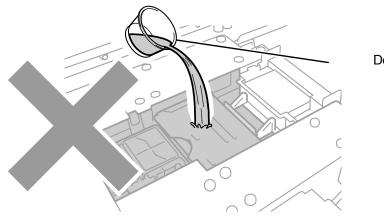
Cleaning the nozzle guard (Use clean stick R)

- (1) Put a proper amount of cleaning solution into the cleaning cup.
- (2) Moisten a new clean stick R with the cleaning solution. <IMPORTANT>
 - Use a new clean stick R when you start cleaning.
 - Never touch the tip end of clean stick R with your hand. If any sebaceous matter is attached to the wiper, it may result in a
 printer malfunction.
 - Do not use other fluids (water, etc.), because they may damage the print heads.
 - Do not return the cleaning solution which has been put in the cleaning cup to the cleaning solution bottle.
 - Do not shed cleaning solution in the maintenance unit.

<NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.



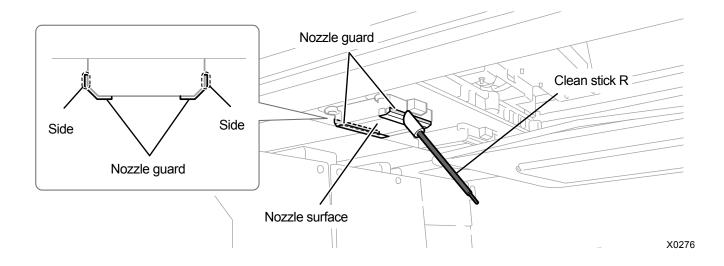


Do not drain waste ink.

- (3) Wipe clean the sides of the nozzle guard with the clean stick R. </br><IMPORTANT>
 - Be sure not to touch the nozzle surface as well as the level surface and sidling surface of the nozzle guard.
 - <tips>

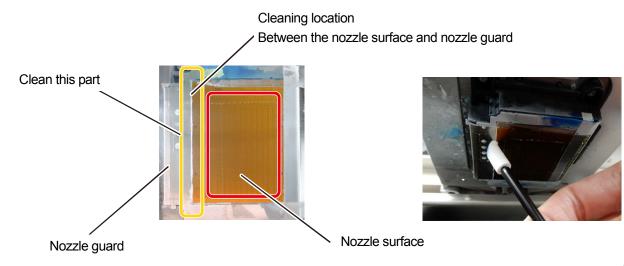
.

• Manually move the carriage to such a position that you can perform the cleaning with ease.





- (4) Wipe the resin part between the print head's nozzle surface and nozzle guard.
 <IMPORTANT>
 - Be sure not to touch the red-frame zone of the nozzle surface.
 - For cleaning, be sure not to use any tool other than clean stick R.



X0237

Cleaning conditions

Pre-cleaning state	Post-cleaning state	
Cleaning location Between the nozzle surface and nozzle guard	Cleaning location K0238 Between the nozzle surface and nozzle guard	

<IMPORTANT>

Be sure to use the clean stick R separately for white ink and color ink.

<TIPS>

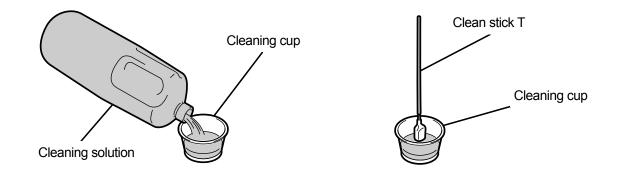
• There may remain white ink in the black resin part, but it doesn't matter if the severity is small as shown in the photo. Wipe away the white ink spreading out of the nozzle guard and nozzle surface.

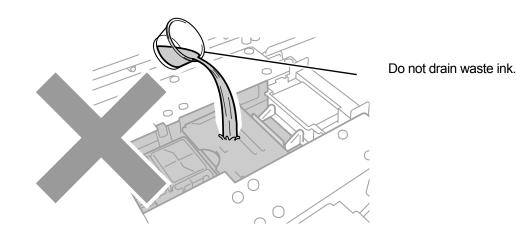
Cleaning wiper (Use clean stick T)

- (1) Put a proper amount of cleaning solution into the cleaning cup.
- (2) Moisten a new clean stick T with the cleaning solution. <IMPORTANT>
 - Use a new clean stick T when you start cleaning.
 - Never touch the tip end of clean stick T with your hand. If any sebaceous matter is attached to the wiper, it may result in a
 printer malfunction.
 - Do not use other fluids (water, etc.), because they may damage the print heads.
 - Do not return the cleaning solution which has been put in the cleaning cup to the cleaning solution bottle.
 - Do not shed cleaning solution in the maintenance unit.

<NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.

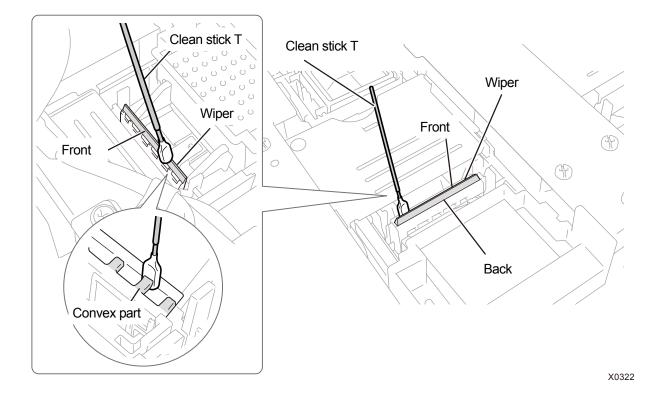




- Use clean stick T to wipe clean the surface of the wiper as well as the gap between the convex part and the wiper.
 <IMPORTANT>
 - Never touch the tip end of clean stick T with your hand. If any sebaceous matter is attached to the wiper, it may result in a
 printer malfunction.
 - Be sure to use the clean stick T separately for color ink and white ink.
 - If ink clot floats on surface, remove it using the clean stick T. Do not use tweezers or other sharp objects. Using sharp
 objects could damage the wiper, possibly resulting in failure to eject ink-jet droplets.

(4) Use the clean side of clean stick T to wipe clean the back of the wiper.

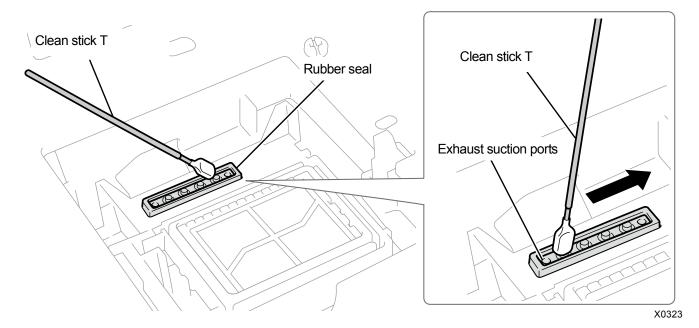
.



- (5) Rinse the clean stick T in the cleaning cup to use it for cleaning of the exhaust cap to be performed next.
 <IMPORTANT>
 - Be sure to use the clean stick T separately for white ink and color ink.

Cleaning exhaust cap (Use clean stick T)

- Wipe clean the rubber seal of exhaust cap with the clean stick T.
 <IMPORTANT>
 - Never touch the tip end of clean stick T with your hand. If any sebaceous matter is attached to the wiper, it may result in a
 printer malfunction.
 - The clean stick T used for cleaning the wiper should be rinsed in the cleaning cup before the next use. Be sure to use the clean stick T separately for color ink and white ink.
 - If ink clot floats on surface, remove it using the clean stick T. Do not use tweezers or other sharp objects. Using sharp
 objects could damage the exhaust cap and deteriorate its air tightness, possibly resulting in failure to eject ink-jet droplets.
- (2) Use the clean stick T to soak up the ink accumulated in the exhaust cap, and remove it. <IMPORTANT>
 - If there is any ink clot in the exhaust cap, move the clean stick T in the direction as illustrated below. If the stick is moved toward yourself, any of the exhaust suction ports may be clogged with ink clot.



(3) Rinse the clean stick T in the cleaning cup to use it for cleaning of the suction cap to be performed next. <IMPORTANT>

• Be sure to use the clean stick T separately for white ink and color ink. <TIPS>

• Some cleaning solution may remain in the exhaust cap, but it will not cause any functional problem.

Precautions to keep good printing quality/use printer over the long term (For GTX pro)

Cleaning conditions

	Pre-cleaning state	Post-cleaning state
On the white side	Exhaust cap rubber part	Exhaust cap rubber part
On the color side	Exhaust cap rubber part	Exhaust cap rubber part

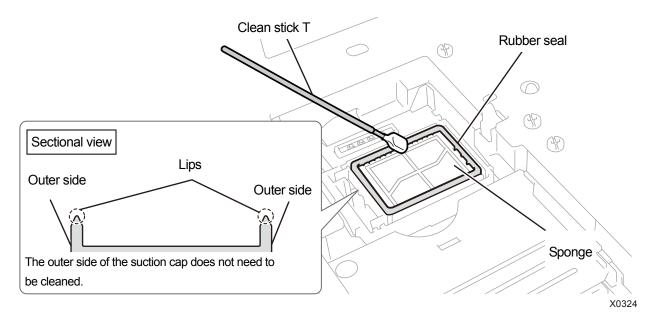
Cleaning suction cap (Use clean stick T)

(1) Wipe the rubber seal and lip of the suction cap with one side of the tip portion of clean stick T in parallel with the

seal.

<IMPORTANT>

- Clean the lip of the suction cap with clean stick T. The print head dries and causes an ejection failure if solidified ink remains.
- Do not touch the sponge of the suction cap. The sponge may come off.
- Never touch the tip end of clean stick T with your hand. If any sebaceous matter is attached to the wiper, it may result in a printer malfunction.
- The clean stick T used for cleaning the wiper and exhaust cap should be rinsed in the cleaning cup before the next use. Be sure to use the clean stick T separately for color ink and white ink.
- If ink clot floats on surface, remove it using the clean stick T. Do not use tweezers or other sharp objects. Using sharp objects could damage the suction cap and deteriorate its air tightness, possibly resulting in failure to eject ink-jet droplets.
- Be sure not to pinch the rubber seal. If it is damaged, its sealing property will be degraded, which in turn may lead to non-ejection of ink-jet droplets from the print heads.



- (2) Replace clean stick T with clean stick R, rinse the cleaning cup, and clean the nozzle guard on the color side head. <IMPORTANT>
 - Be sure to use the clean stick T separately for white ink and color ink.
 - The used clean stick T should be disposed of, and should not be reused.
 - After cleaning the nozzle guard of the color side head, rinse the cleaning cup with pure water, let it dry sufficiently, and store it so that dust does not get inside.

Precautions to keep good printing quality/use printer over the long term (For GTX pro)

Cleaning conditions

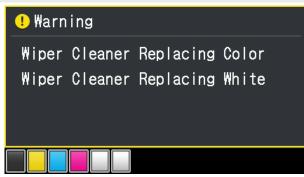
Pre-cleaning state	Post-cleaning state	
	X0390	

7-1-4. Replacing the wiper cleaner

When a warning message appears on the operation panel screen or in the warning message window, replace the specified wiper cleaner with a new one.

<TIPS>

• When you replace the wiper cleaner, check the staining state inside the printer. If parts inside the printer (carriage guide shaft, roller guide, and carriage roller) are stained, perform cleaning. *7-1-6. Cleaning the internal area of printer >>P.205"



- (1) Have the supplied gloves and wiper cleaner ready.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press



(3) Select [Part with Error/Warning] and press (I) .

<IMPORTANT>

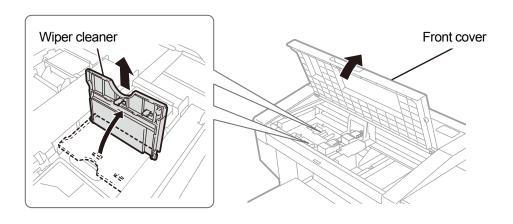
 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing (KENU) causes the platen to start moving. Do not put anything around the platen.
- (4) Follow the on-screen message and turn off the power.<IMPORTANT>
 - Please complete the task within 15 minutes, in order prevent the print heads from drying up.
 - If the task takes more than 15 minutes to complete, after attaching the wiper cleaner, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (5) Open the front cover.

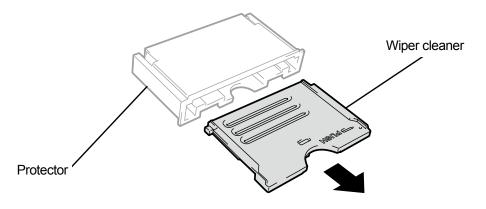
- (6) Raise the wiper cleaner and move it to its upright position, and remove it by moving it upward. <NOTE>
 - For a proper work operation, be sure to wear the printer-provided gloves.

.



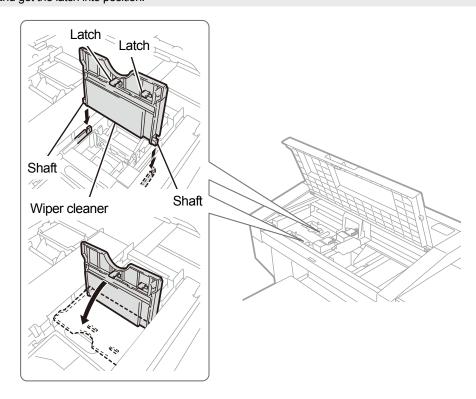
X0325

- (7) Take out the wiper cleaner from its packing bag, and remove it from its protector.
 <IMPORTANT>
 - As soon as it is unpacked, do not leave it as it is and put it in position.



X0326

- (8) Insert a new wiper cleaner into the printer from above, tip it leftward and put it in place. <TIPS>
 - First, insert the shaft from above. Then fold it to the left, press the area with the PUSH indication until a clicking sound is heard, and get the latch into position.



- (9) Close the front cover.
- (10) Turn on the power.

<NOTE>

- Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.
- <TIPS>
- A head cleaning will be performed to prevent ink from drying up.

7-1-5. Replacing the flushing foam

When a warning message appears on the operation panel screen or in the warning message window, replace the specified flushing foam with a new one.

<TIPS>

• When you replace the flushing foam, check the staining state inside the printer. If parts inside the printer (carriage guide shaft, roller guide, and carriage roller) are stained, perform cleaning. *7-1-6. Cleaning the internal area of printer >>P.205"



(1) Make the clean stick R, gloves and flushing foam, which come standard with the printer, available for use.

<TIPS>

- For this cleaning, you can use an already-used dirty clean stick R.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press
- (3) Select [Part with Error/Warning] and press

<IMPORTANT>

 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing Causes the platen to start moving. Do not put anything around the platen.
- (4) Follow the on-screen message and turn off the power.

<IMPORTANT>

- Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
- If the task takes more than 15 minutes to complete, after attaching the flushing receiver, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (5) Open the front cover.

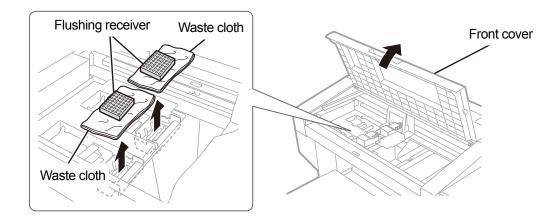
(6) Remove the flushing foam from the maintenance unit.

<IMPORTANT>

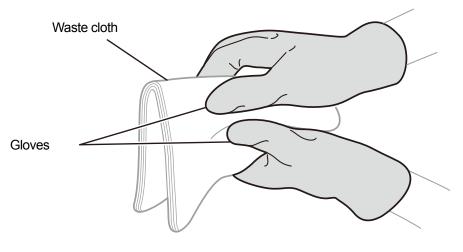
• Remove the flushing foam without removing the flushing receiver from the maintenance unit.

Ink droplets will drop off from the hole in flushing foam. After removal, apply a waste cloth to the bottom face.
 <NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.



(7) Wipe the gloves with a waste cloth.



X0436

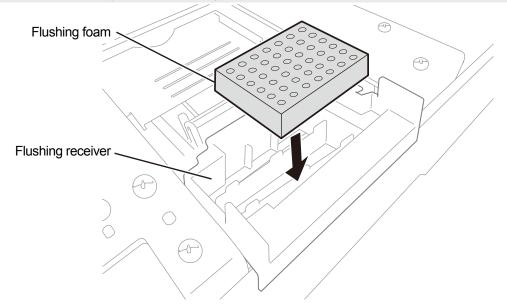
(8) Assemble a new flushing foam to the flushing receiver.

<IMPORTANT>

 After this assembly process is completed, make sure that no flushing foam extends off the outboard end portions of flushing receiver. If it sticks out of the end portions, it may interfere with any nozzles and may result in non-ejection of ink-jet droplets.

<TIPS>

• It is not necessary to clean the flushing receiver.



X0330

- (9) Close the front cover.
- (10) Turn on the power.

<NOTE>

- Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.
 <TIPS>
- The head cleaning will be performed to prevent ink from drying up.

7-1-6. Cleaning the internal area of printer

When you replace the wiper cleaner and the flushing foam, check the staining state inside the printer. If parts inside the printer (carriage guide shaft, roller guide, and carriage roller) are stained, perform cleaning.

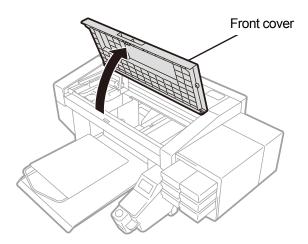
- Prepare a clean stick R, cleaning cup, gloves, cleaning solution, and grease which come standard with the printer.
 <IMPORTANT>
 - Never touch the tip end of clean stick R with your hand. If any sebaceous matter is attached to the head nozzle, it may
 result in a printer malfunction.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press

<IMPORTANT>

If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing causes the platen to start moving. Do not put anything around the platen.
- (3) Follow the on-screen message and turn off the power. <IMPORTANT>
 - Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
 - If the task takes more than 15 minutes to complete, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (4) Open the front cover.

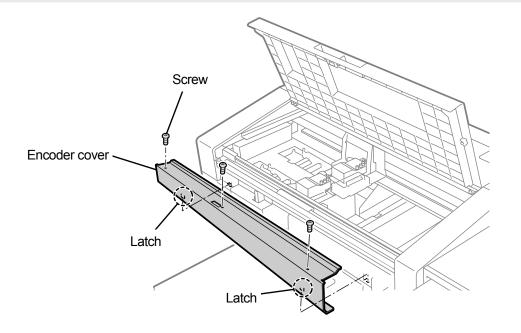


X0148

(5) Remove three screws to remove the encoder cover.

<CAUTION>

- Do not touch the latch under the encoder cover. Otherwise, the operator may get injured.
- <IMPORTANT>
- Do not touch the encoder on the main unit.

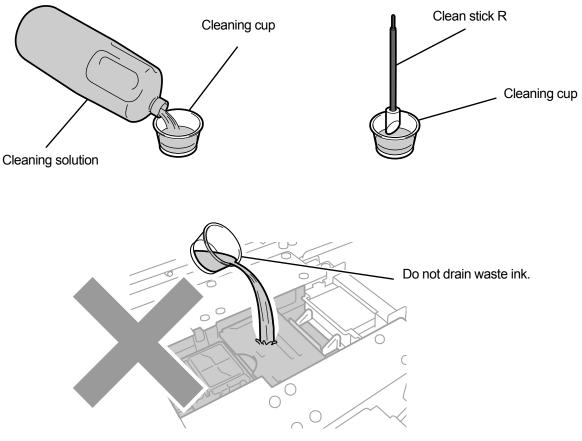


(6) Put a proper amount of cleaning solution into the cleaning cup.

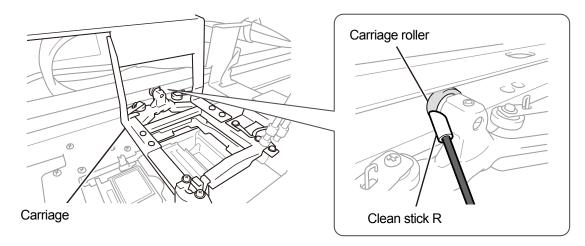
- (7) Moisten a clean stick R with the cleaning solution.
 - <IMPORTANT>
 - Do not return the cleaning solution which has been put in the cleaning cup to the cleaning solution bottle.
 - Do not shed cleaning solution in the maintenance unit.
 - <NOTE>

.

• For a proper work operation, be sure to wear the printer-provided gloves.



- (8) With the clean stick R, wipe away the ink mist on the carriage roller part.
- (9) Move the carriage from side to side to rotate the roller part, and wipe all around the carriage roller.



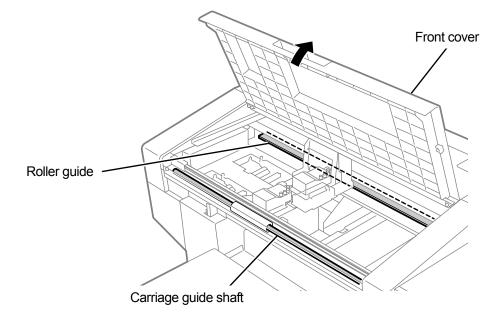
X0448

(10) Clean the carriage guide shaft and the three sides (upper, front, and lower sides across which the roller rolls) of

roller guide.

<TIPS>

- Moisten a waste cloth (non-fuzzy cloth) with a small amount of alcohol, and use such cloth to wipe clean the internal surface.
- Do not use alcohol on parts other than the carriage guide shaft and the roller guide.
- (11) Apply a proper amount of the grease (which is included with the printer) onto the carriage guide shaft.
 <CAUTION>
 - When handling the grease, perform the work operation in such a manner that it will not get into your eyes or onto your skin.



- (12) Insert the two latches under the encoder cover and fix the cover with three screws.
- (13) Close the front cover.
- (14) Turn on the power.

<NOTE>

Dispose of any waste resulting from the cleaning in accordance with applicable laws and ordinances.
 <TIPS>

- Then, a head cleaning will be performed to prevent any ink from drying up.
- Because the cleaning cup will be reused, rinse it in clean cleaning solution and store it in a safe place.
- (15) Adjust the carriage speed. 7-4-1. CR (Carriage) speed adjustment >>P.230".
- (16) Print out a nozzle check pattern. 7-2-1. Print out of the nozzle check pattern (checking on the print heads)

>>P.213".

7-1-7. Replacing the fan filter

When a warning message appears in the warning message window, replace the fan filter with a new one.

! Wa	rning			
Fan	Filter	To Be	Replaced	

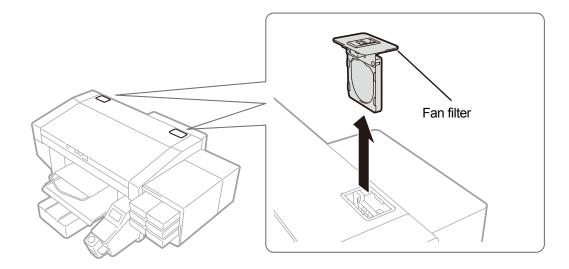
- (1) Make the gloves which come standard with the printer, as well as a new fan filter, available for use.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press
- (3) Select [Part with Error/Warning] and press (INCOMPANIE).

<IMPORTANT>

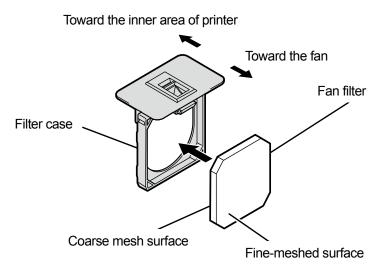
 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing (Causes the platen to start moving. Do not put anything around the platen.
 - Pressing (Kenner) will not move the platen or head if the error and warning displayed are [Fan Filter To Be Replaced] only.
- (4) Follow the on-screen message and turn off the power.
- (5) Remove the fan filter from the main unit of printer.<NOTE>
 - For a proper work operation, be sure to wear the printer-provided gloves.



- (6) Mount a new fan filter to the frame of filter case.<IMPORTANT>
 - Mount the fan filter properly in correct position in such a way that its coarse mesh surface faces toward the inner area of printer.



X0062

(7) Mount the assembled fan filter in the main unit of printer.

(8) Turn on the power.

<NOTE>

Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.
 <TIPS>

• Then, a head cleaning will be performed to prevent any ink from drying up.

7-2. Tasks to be performed when needed

7-2-1. Print out of the nozzle check pattern (checking on the print heads)

By printing out a nozzle check pattern, you can check on the printing quality.

It is recommended to always perform this procedure to verify the output.

<TIPS>

The serial number, firmware version, and print date (day/month/year) and time are printed at the bottom of the nozzle check pattern.

The date and time will be printed in Coordinated Universal Time with "(UTC)" printed at the end if time adjustment as a maintenance tool has not been made. You can print the date and time according to your environment by making time adjustment. #7-4-6. Setting of the time displayed on the nozzle check pattern >>P.235"

(1) Put the platen 14X16 in place, and position its level at "A".

☞ "6-4-1. Replacing the currently used platen with another one >>P.148" and "6-4-2. Platen height adjustment >>P.151".

(2) As illustrated below, put the A4-size or letter-size white paper on the platen in alignment with the right-hand corner

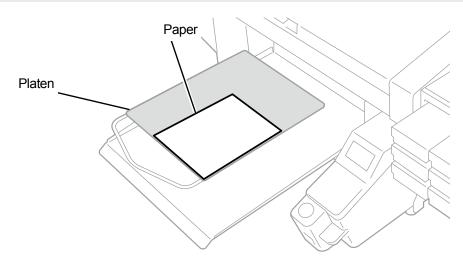
of the platen at its front edge.

When the paper is loosely fitted, fix its edge with a tape or the like.

A T-shirt can also be used instead.

<TIPS>

 When printing out a nozzle check pattern on the white side, print it on a pretreated black or dark color textile or black paper, or a transparent sheet (such as OHP sheet).



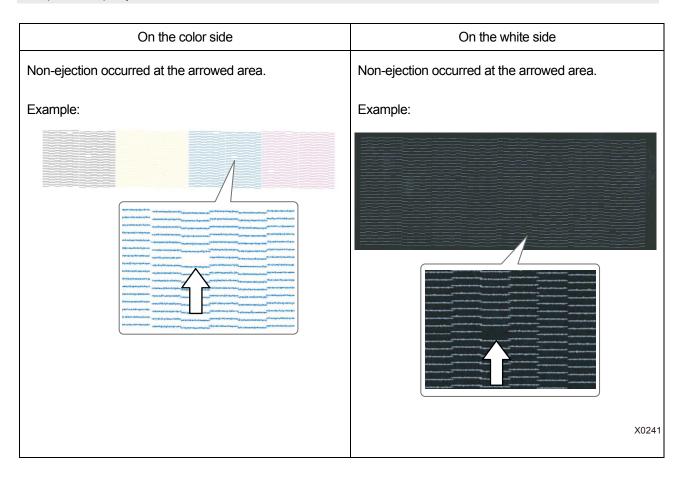
- (3) From the menu, select [Test Print] > [Nozzle Check CMYK], and press
- (4) After printing on the color side is completed, remove the printed paper and replace it with a paper for printing on the white side.
- (5) From the menu, select [Test Print] > [Nozzle Check White], and press
 Then, printing will begin.

(6) Check to see if the printed result of both sides are acceptable, and if no ink-jet droplets have been ejected, perform

a head cleaning for print heads. T-2-2. Head cleaning >>P.215"

<IMPORTANT>

- If the print result shows an intermittent line, non-ejection has occurred. A head cleaning should be performed on the print head that has a poor nozzle check result.
- Even if the lines of the white-side printed result are light, since white ink is fired from more than one nozzle on the same place, the quality is not affected.



7-2-2. Head cleaning

This printer has been designed to perform the Auto Cleaning every time 24 print jobs are printed after the previous Auto Cleaning, or before starting the printing using the white ink when one hour or more elapses after the previous printing that used the white ink.

<TIPS>

• The frequency and start timing of Auto Cleaning can be changed. ""9-12. Auto Cleaning Setting >> P.303"

In the event that there is any faintly printed or missing portion on a printed material, head cleaning sometimes provides a solution.

Selecting a type of head cleaning from the menu to perform the head cleaning

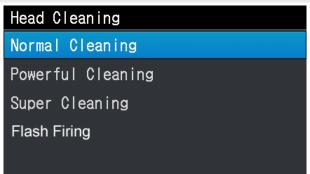
- (1) While the printer is in standby mode press (in the operation panel to bring the menu screen into the view.
- (2) From the menu, select [Head Cleaning], and press

Menu
Head Cleaning
Test Print
Print Data Load
Receiving History
Maintenance

(3) By pressing ▲ / ▼, select one of the options: [Normal Cleaning], [Powerful Cleaning], [Super Cleaning] or [Flash Firing], and press

<TIPS>

• For selecting a desired cleaning option, follow the instructions in the respective steps. ""10-2-1. Recovery action to be taken for such a nozzle that is unable to eject ink-jet droplets >>P.325".



(4) By pressing ▲ / ▼, select the [All Colors], [All Whites], or [All Print Heads], and press



<TIPS>

• Under the condition that the nozzle which has been confirmed not ejecting ink-jet droplets, determine the color for which the head cleaning should be performed. "7-2-1. Print out of the nozzle check pattern (checking on the print heads) >>P.213"

Normal Cleaning
All Colors
All Whites
All Print Heads

- (5) Then, the head cleaning will be performed for the specified print heads.
 <TIPS>
 - The cleaning operation cannot be canceled halfway.
 - After the procedures are completed, the current screen will go back to the standby mode screen.

7-2-3. White ink circulation

When whiteness is not enough, it may be solved by performing white ink circulation.

(1) While the printer is in standby mode, press

on the operation panel to bring the menu screen into view.

(2) From the menu, select [Maintenance] > [White Ink Circulation], and press

<IMPORTANT>

 Do not turn off the power because if you do so, the machine mail fail because necessary maintenance operations are not performed.

<TIPS>

- Time required for completing the white ink circulation varies depending on the ambient temperature. It normally takes 7 and a half minutes although it can take up to 15 minutes. White ink is circulated automatically every six hours and white ink three times as much as normal is circulated every 24 hours.
- If you are activating the printer after having had its power off for a long period, it will take up to 40 minutes.

White Ink Circulation
All Whites
[1]min[30]sec
Please Wait

7-2-4. Cleaning the CR (carriage) plate

Clean the carriage plate when it is contaminated with ink.

<TIPS>

- You can use an already-used clean stick R.
- (1) Make the clean stick R, cleaning cup, gloves and cleaning solution, which come standard with the printer, available

for use.

<IMPORTANT>

- Never touch the tip end of clean stick R with your hand. If any sebaceous matter is attached to the head nozzle, it may
 result in a printer malfunction.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press

<IMPORTANT>

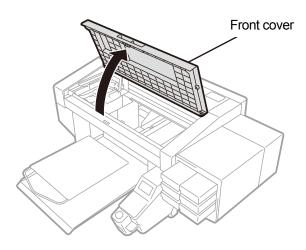
 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing (Causes the platen to start moving. Do not put anything around the platen.
- (3) Follow the on-screen message and turn off the power.

<IMPORTANT>

- Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
- If the task takes more than 15 minutes to complete, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (4) Open the front cover.



X0331

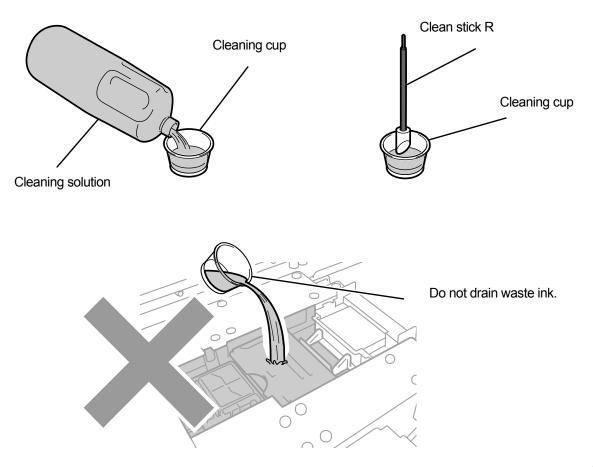
(5) Put a proper amount of cleaning solution into the cleaning cup.

(6) Moisten a clean stick R with the cleaning solution.

- <IMPORTANT>
- If you use an already-used clean stick R, do not use it for other purposes than cleaning the carriage plate.
- Do not use other fluids (water, etc.), because they may damage the print heads.
- Do not return the cleaning solution which has been put in the cleaning cup to the cleaning solution bottle.
- Do not shed cleaning solution in the maintenance unit.
- <NOTE>

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• For a proper work operation, be sure to wear the printer-provided gloves.

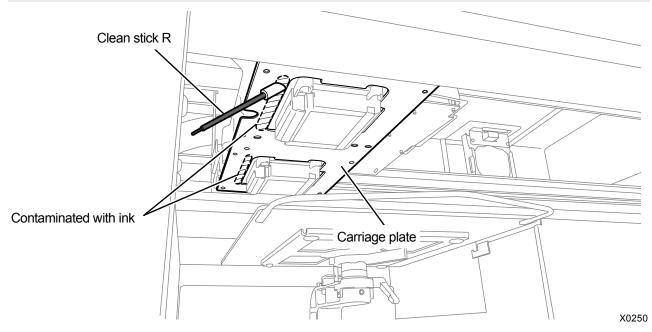


X0320

- (7) With the clean stick R, wipe away the accumulated ink on the carriage plate of the left-side of the print head. </br><IMPORTANT>
 - Be sure not to touch the nozzle surface.

<TIPS>

• Manually move the carriage to such a position that you can perform the cleaning with ease.



- (8) Clean the carriage plate on the left side of the other print head in the same manner.
 <IMPORTANT>
 - The used clean stick R should be disposed of, and should not be reused.
- (9) Close the front cover.
- (10) Turn on the power.

<NOTE>

Dispose of any waste resulting from the cleaning in accordance with applicable laws and ordinances.

<TIPS>

- Then, a head cleaning will be performed to prevent any ink from drying up.
- Because the cleaning cup will be reused, rinse it in clean cleaning solution and store it in a safe place.

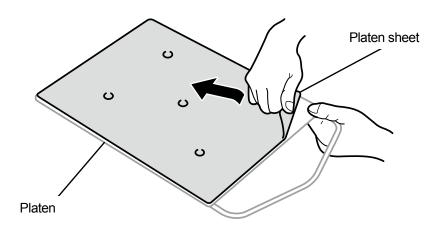
7-2-5. Replacing the platen sheet

When the platen sheet gets soiled, replace it with a new one.

- (1) Remove the platen from the main unit of the printer.
 - ☞ "6-4-1. Replacing the currently used platen with another one >>P.148"
- (2) Peel the platen sheet off the platen.

<TIPS>

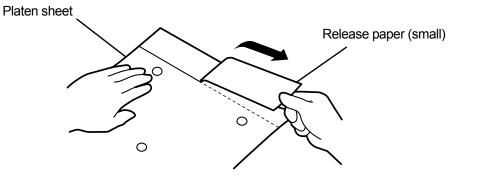
• When it is hard to peel the platen sheet off, warm it using a hair dryer or the like and peel it off.



- (3) Wipe the surface of the platen with a clean cloth moistened with a mild detergent which is diluted with water, then wipe the platen clean with a dry and soft clean cloth.
- (4) Mount the platen in the main unit of the printer.

"6-4-1. Replacing the currently used platen with another one >>P.148"

(5) Peel the release paper (small in size) off a new platen sheet.



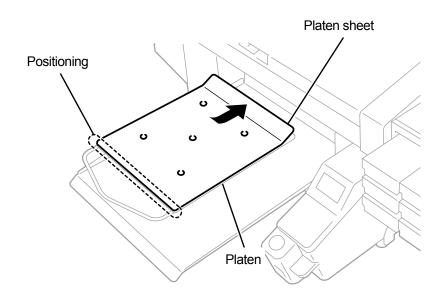
X0157

X0064

(6) Position the platen sheet to match the platen surface, and onto the platen, stick the portion of the platen sheet

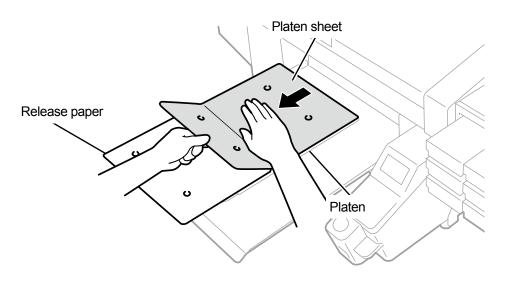
where the release paper (small) was removed.

- <TIPS>
- If the 16X21 platen is used, slide it forward before working on it.



X0065

- Peel off the rest of the release paper, and paste the whole platen sheet onto the entire platen.
 <TIPS>
 - Straighten the platen sheet, and stick it properly while pressing it with hands outward from the center to avoid making wrinkles.



X0066

(8) As required, print a grid pattern onto the new platen sheet.

"5-5-4. Print a grid pattern on the platen sheet >>P.120"

• After the printing is completed, press down the printed surface lightly with a dry cloth or a sheet of paper to dry the ink.

7-3. White Ink Pause Mode

7-3-1. Disabling white ink

If you do not plan to use the white ink for 1 month or longer, it is recommended to set the printer to white ink pause mode. This eliminates the necessity to maintain the white ink, and saves its consumption.

<TIPS>

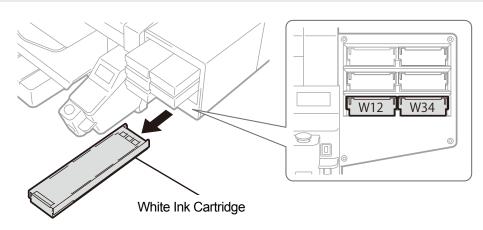
- Although the white ink pause mode can be activated even when the remaining volume of maintenance solution in the maintenance solution pouch is running short, there may be a case where the pouch needs to be replaced with a new one in the middle of the process depending on such remaining volume. If the remaining volume is 500 g (17.6 oz) or less, prepare a new maintenance solution pouch, follow the instructions on the screen to replace the pouch, and activate the mode again.
- (1) From the menu, select [Maintenance] > [White Ink Pause Mode] > [Enable].
- (2) Check the waste ink tank for its availability and take a necessary measure for it, if any, then press



(3) Remove the white ink cartridge from the printer.

<CAUTION>

• The bottom of the cartridge may be soiled with ink. Clean the printer on a regular basis.

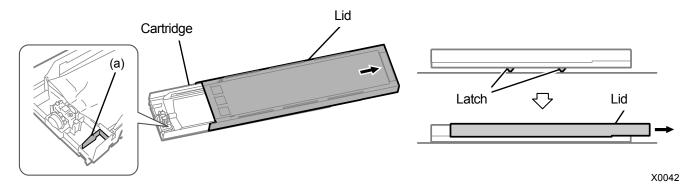


X0333

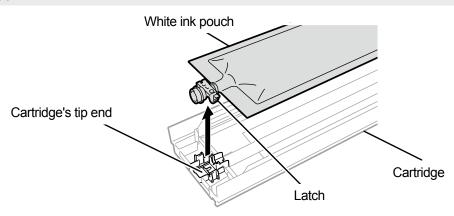
(4) Open the cartridge's lid.

<IMPORTANT>

- When opening the lid, be sure not to touch portion (a). Otherwise, it could be damaged.
- Place the entire cartridge on a flat surface, push the latches on the bottom surface of the cartridge downward and open the lid.



- (5) Pinch the latch at the front end of the ink pouch, and draw out the white ink pouch from the cartridge.
 - <CAUTION>
 - Remove the accumulated ink at the tip of the cartridge with a waste cloth (non-fuzzy cloth). Clean the printer on a regular basis.



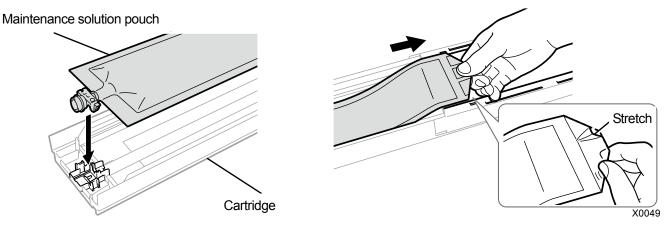
X0119

(6) Put the maintenance solution pouch in the cartridge.

Push the tip end of the maintenance solution pouch into the cartridge until it clicks into place. Straighten the maintenance solution pouch in such a manner that it will be aligned with the gutter of lid of cartridge, and mount into position by pulling it with your hand.

<NOTE>

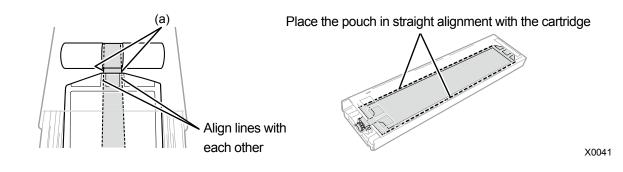
• If the edge of the ink pouch is bent or undulating significantly, make it straight with your hand.



(7) Put the maintenance solution pouch in its correct position.

<CAUTION>

• Avoid touching portion (a) of the cartridge. Otherwise, you may cut your hand.



- (8) Close the lid, and put the maintenance solution cartridge in position inside the printer.
- (9) Repeat the same process to replace the other white ink cartridge with the maintenance solution pouch.
- (10) On the operation panel, press

Then, the white ink will be replaced with the maintenance solution.

<TIPS>

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- After the procedures are completed, the current screen will go back to the standby mode screen.
- Always keep the maintenance solution cartridge placed in its position.
- As required, restart printing with the white ink. #"7-3-2. Reusing White Ink >>P.226"
- If the maintenance solution pouch runs out, replace the maintenance solution pouch with a new one.

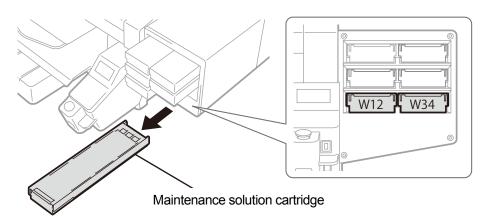
Reusing White Ink 7-3-2.

Perform the following operations when you restart printing with the white ink after activating the white ink pause mode.

- (1) From the menu, select [Maintenance] > [White Ink Pause Mode] > [Disable].
- (2) Check the waste ink tank level and take a necessary measure for it, if any, then press
- (3) Remove the maintenance solution cartridge from the printer.

<CAUTION>

The bottom of the cartridge may be soiled with ink. Clean the printer on a regular basis.

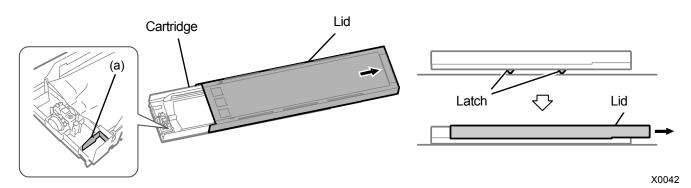


X0333

(4) Open the cartridge's lid.

<IMPORTANT>

- When opening the lid, be sure not to touch portion (a). Otherwise, it could be damaged.
- Place the entire cartridge on a flat surface, push the latches on the bottom surface of the cartridge downward and open the lid.



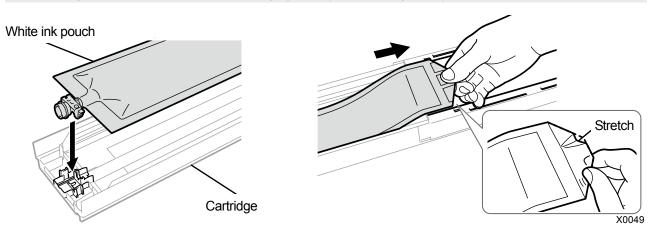
(5) Remove the maintenance solution pouch from the cartridge, and put the white ink pouch in place.

Push the tip end of the ink pouch into the cartridge until it clicks into place.

Straighten the ink pouch in such a manner that it will be aligned with the gutter of the lid of cartridge, and mount in position by pulling it with your hand.

<NOTE>

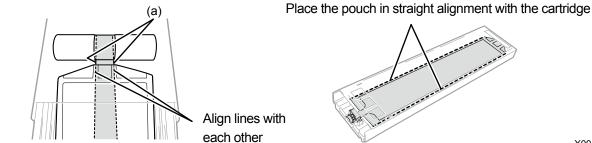
If the edge of the ink pouch is bent or undulating significantly, make it straight with your hand.

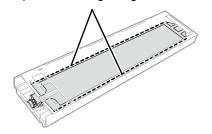


(6) Make sure that the white ink pouch is set in its correct position, to close the lid.

<CAUTION>

Avoid touching portion (a) of cartridge. Otherwise, you may cut your hand.





X0041

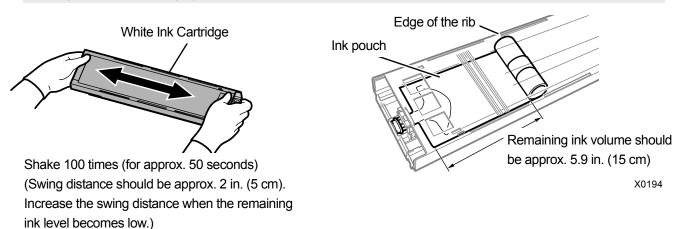
(7) Shake the cartridge 100 times side to side to stir the ink.

<IMPORTANT>

- The white ink cartridge should be held horizontally when shaking it.
- Holding the white ink cartridge upside down or shaking it too roughly could break the ink pouch.

<NOTE>

- Wear the provided gloves when performing this task.
- When the remaining ink level becomes approximately 5.9 in. (15 cm), shake the cartridge with its cover open and with the edge of the ink pouch slightly winded, to make the ink easier to stir.



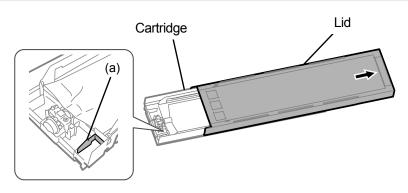
(8) Open the lid of the cartridge and place the ink pouch in its correct position.

<IMPORTANT>

- Always open the cartridge lid and properly rewind the ink pouch. If the pouch is placed without opening the lid, ink can flow
 into the wound section of the pouch when stirred, causing improper winding of the pouch.
- When opening the lid, place the entire cartridge on a flat surface, push the latches on the bottom surface of the cartridge downward and open the lid.
- When setting the ink pouch, avoid unevenness or wrinkles on the pouch.
- When opening the lid, be sure not to touch the portion (a). Otherwise, it could be damaged.

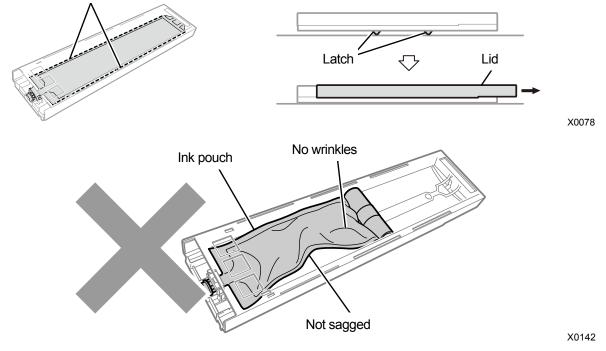
<NOTE>

• If the remaining ink level is low, hold the sagged part of the ink pouch and close the lid.



X0182

Place the pouch in straight alignment with the cartridge



(9) Close the lid, and put the white ink cartridge in position inside the printer.

<IMPORTANT>

- W12 and W34 cartridges should correctly be placed at their original locations. Wrongly placed cartridges could cause printer malfunction.
- (10) Repeat the same process to replace the other maintenance solution cartridge with the white ink pouch.

(11) On the operation panel, press

Then, the white ink will be installed. <TIPS>

- When the white ink pouch runs low on its remaining volume of white ink, the Install Ink function can no longer get started.
 Furthermore, there may be cases where the pouch needs to be replaced with a new one during the installation process of white ink. If the remaining volume is 400 g (14.1 oz) or less, prepare a new white ink pouch, follow the instructions on the screen to replace the pouch, and activate the mode again.
- After the procedures are completed, the current screen will go back to the standby mode screen.

7-4. Adjustment/setup

7-4-1. CR (Carriage) speed adjustment

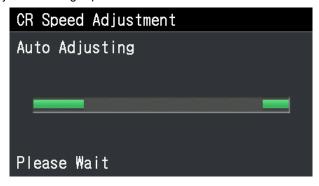
Carriage speed should be adjusted when the error message [Adjust CR] is displayed on the operation panel. Adjustment should always be performed when carriage shaft cleaning or print head replacement tasks are carried out, or after completing the setup procedures.

(1) While the printer is in standby mode, press

on the operation panel to bring the menu screen into view.

- (2) From the menu, select [Printer Setting] > [CR Speed Adjustment], and press
- (3) Select [Start] or [Start (after cleaning/setup)] and press
 - [Start]: If you cannot clean the internal area of the printer such as carriage shaft immediately after the head replacement or when the error message is displayed.
 - [Start (after cleaning/setup)]: After cleaning the carriage shaft.

Wait until the carriage stops moving and the sound of pong is heard. It takes about 3 minutes to adjust the carriage speed.



7-4-2. Initial settings after head replacement

Set V-rating after replacing the print head or completing the setup procedure.

- (1) Make sure that a connection of USB 2.0 cable or LAN cable is made between the printer and your PC.
- (2) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" from "Brother GTX pro Tools".
- (3) After the window shown below appears, select [Initial settings after head replacement] and click [Next].

P Brother GTX pro Maintenance	×
Confirm the printer is turned ON and connected to your PC. Select the printer.	
Brother GTX pro \checkmark Search	
Select an item from the menu below and click "Next"	
Initial settings after head replacement Perform this setting when replacing the head or when setting up the printer only.	
Firing Adjustment Adjust this setting when the edges of the print look vague, solid areas are not even, or after a Print Head is replaced	ł.
Platen-rolling adjustment Make adjustments when horizontal stripes (banding) occur in the printed image. Use this adjustment as a troubleshooting method when other items such as proper temperature and humidity have already been verified.	
Adjust when white print does not align with color print.	
O Set an IP Adrress Assign a static IP address to the printer.	
O Log Data Retrieval Execute if there was a request after troubleshooting service.	
O Setting of the time displayed on the nozzle check pattern This is not necessary if you have configured the scheduled time for white ink circulation.	
O Set the scheduled time for white ink circulation Configure this setting to set or cancel the scheduled time for white ink circulation.	
< Back Next > Close	

(4) Perform the required operation by following the on-screen instructions in the dialog box. After the adjustment is completed, the currently displayed screen will go back to the window mentioned above.

7-4-3. Firing adjustment

Because the ejection timing varies depending on the platen's height and properties of each print head, this function is provided to adjust the ejection timing for each print head when any print head is replaced with a new one or after the completion of the setup procedure, for instance. If you want to make adjustments after replacing the print head, configure the initial settings after print head replacement before you do so.

- (1) Make several sheets of A4-size or letter-size paper (black paper or transparent sheet such as OHP sheet, and white paper) available for use.
- (2) Make sure that a connection of USB 2.0 cable or LAN cable is made between the printer and your PC.
- (3) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" from "Brother GTX pro Tools".
- (4) After the window shown below appears, select [Firing Adjustment] and click [Next].

Confirm the printer is turned ON and connected to your PC. Select the printer.	
Brother GTX pro	✓ Search
Select an item from the menu below and click "Nex Initial settings after head replacement Perform this setting when replacing the head or when	
Firing Adjustment Adjust this setting when the edges of the print look va	ague, solid areas are not even, or after a Print Head is replaced.
 Platen-rolling adjustment Make adjustments when horizontal stripes (banding) o troubleshooting method when other items such as pro White/Color Alignment Adjust when white print does not align with color prin 	oper temperature and humidity have already been verified.
O Set an IP Adrress Assign a static IP address to the printer.	
O Log Data Retrieval Execute if there was a request after troubleshooting se	ervice.
O Setting of the time displayed on the nozzle check pa This is not necessary if you have configured the sched	
O Set the scheduled time for white ink circulation Configure this setting to set or cancel the scheduled time	ine for white ink circulation.

(5) Perform the required operation by following the on-screen instructions in the dialog box.

After the adjustment is completed, the currently displayed screen will go back to the window mentioned above.

7-4-4. Platen-rolling adjustment

Platen feed adjustment should be performed after replacing the print head or completing the set up procedure. If you want to make adjustments after replacing the print head, configure the initial settings after print head replacement and adjust the firing timing before you do so.

- (1) Make several sheets of A4-size or letter-size white paper available for use.
- (2) Make sure that a connection of USB 2.0 cable or LAN cable is made between the printer and your PC.
- (3) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" from "Brother GTX pro Tools".
- (4) When the window shown below is displayed, select [Platen-rolling adjustment] and click [Next].

Brother GTX pro			~	Search	
 Initial settings af Perform this setting Firing Adjustment 	t	t head or when setting u			
Platen-rolling adj Make adjustment troubleshooting	ustment s when horizontal strip	e print look vague, solik es (banding) occur in ti ms such as proper temp with color print	ne printed image. Use	this adjustment as a	
O Set an IP Adrres					
O Log Data Retriev Execute if there v	al vas a request after trou	bleshooting service.			
	ne displayed on the n ary if you have config	ozzle check pattern ured the scheduled time	for white ink circulati	on.	
0	d time for white ink d	irculation e scheduled time for wh	ite ink circulation.		

(5) Perform the required operation by following the on-screen instructions in the dialog box. After the adjustment is completed, the currently displayed screen will go back to the window mentioned above.

7-4-5. White/color alignment

This is the adjustment function to align the print position on the white side with the print position on the color side. Adjust white/color alignment after replacing a print head or completing the setup procedure.

If you want to make adjustments after replacing the print head, configure the initial settings after print head replacement and adjust the firing timing and platen feed before you do so.

- (1) Prepare a sheet of black paper or a pretreated black or dark color T-shirt.
- (2) Make sure that a connection of USB 2.0 cable or LAN cable is made between the printer and your PC.
- (3) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" from "Brother GTX pro Tools".
- (4) After the window shown below appears, select the [White/Color Alignment] and click [Next].

P Brother GTX pro Maintenance	×
Confirm the printer is turned ON and connected to your PC. Select the printer.	
Brother GTX pro Y Search	
Select an item from the menu below and click "Next".	
 Initial settings after head replacement Perform this setting when replacing the head or when setting up the printer only. 	
O Firing Adjustment Adjust this setting when the edges of the print look vague, solid areas are not even, or after a Print Head is replaced.	
OPlaten-rolling adjustment Make adjustments when horizontal stripes (banding) occur in the printed image. Use this adjustment as a memograture and humidity have already been verified.	
White/Color Alignment Adjust when white print does not align with color print.	
O Set an IP Adrress Assign a static IP address to the printer.	
O Log Data Retrieval Execute if there was a request after troubleshooting service.	
O Setting of the time displayed on the nozzle check pattern This is not necessary if you have configured the scheduled time for white ink circulation.	
O Set the scheduled time for white ink circulation Configure this setting to set or cancel the scheduled time for white ink circulation.	
< Back Next > Close	

(5) Perform the required operation by following the on-screen instructions in the dialog box. After the adjustment is completed, the currently displayed screen will go back to the window mentioned above.

7-4-6. Setting of the time displayed on the nozzle check pattern

Set the time displayed on the nozzle check pattern.

- (1) Make sure that a connection of USB 2.0 cable or LAN cable is made between the printer and your PC.
- (2) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" of "Brother GTX pro Tools".
- (3) After the window shown below appears, select [Setting of the time displayed on the nozzle check pattern] and click [Next].

	Brother GTX pro Search
Sel	ect an item from the menu below and click "Next".
	 Initial settings after head replacement Perform this setting when replacing the head or when setting up the printer only.
	Adjust this setting when the edges of the print look vague, solid areas are not even, or after a Print Head is replace
	O Platen-rolling adjustment Make adjustments when horizontal stripes (banding) occur in the printed image. Use this adjustment as a troubleshooting method when other items such as proper temperature and humidity have already been verified.
	O White/Color Alignment Adjust when white print does not align with color print.
	O Set an IP Adrress Assign a static IP address to the printer.
	O Log Data Retrieval Execute if there was a request after troubleshooting service.
	Setting of the time displayed on the nozzle check pattern This is not necessary if you have configured the scheduled time for white ink circulation.
1	O Set the scheduled time for white ink circulation Configure this setting to set or cancel the scheduled time for white ink circulation.

- (4) Perform the required operation by following the on-screen instructions in the dialog box.
 <CAUTION>
 - Confirm that the date and time of your PC are set correctly, and continue.

.

	aintenance		
Step 1:			
Set the time displayed	on the nozzle check pattern.		
Current time	14:47		
Confirm that continue.	t the date and time of your P	PC is set for 2018 or later and	
- Set to the above	mentioned time.		

(5) After the setting is completed, the currently displayed screen will go back to the Main screen.



7-4-7. Set the scheduled time for white ink circulation

White ink circulation can be performed at a specified time. If not set, white ink circulation will be performed automatically every six hours.

- (1) Make sure that a connection of USB 2.0 cable or LAN cable is made between the printer and your PC.
- (2) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" of "Brother GTX pro Tools".
- (3) After the window shown below appears, select [Set the scheduled time for white ink circulation] and click [Next].

brould	er GTX pro			~	Search	
Select an i	item from the me	nu below and c	lick "Next".			
🔾 Initi	al settings after hea	d replacement				
Per	form this setting when	replacing the head	l or when setting up t	he printer only.		
OFirin	g Adjustment					
Adj	ust this setting when t	he edges of the pri	nt look vague, solid a	reas are not even, or	after a Print Head	is replaced
	en-rolling adjustmen	t				
Mak	ke adjustments when h	norizontal stripes (b				
_	ubleshooting method v	when other items su	uch as proper tempera	ature and humidity ha	ave already been v	erified.
-	te/Color Alignment ust when white print o	loss not alian with	color print			
, Auj	ust when white print t	Joes not align with	color prints			
0	an IP Adrress					
Ass	ign a static IP address	to the printer.				
	Data Retrieval					
Exe	cute if there was a req	uest after troubles	nooting service.			
OSett	ting of the time displa	aved on the nozzle	e check pattern			
	s is not necessary if yo			r white ink circulation	n.	
Orat	the scheduled time f	or white ink circult	tion			
- Set	the scheduled time in		neduled time for white			

(4) After the window shown below appears, select [Set the scheduled time for white ink circulation.] and click [Next].

P Brother GTX pro Maintenance	×
Step 1: Set or cancel the scheduled time for white ink circulation.	
Set the scheduled time for white ink circulation. Cancel the scheduled time for white ink circulation.	
 If the scheduled time of white ink circulation is not set, the white ink circulation is automatically turned ON ever six hours. 	у
 You cannot set the scheduled time in such a manner that the length of the intervals of white ink circulation is longer than six hours. 	
< Back Next > Car	ncel

(5) Set the scheduled time for white ink circulation and click [Next].

<CAUTION>

.

- Confirm that the date and time of your PC are set correctly, and continue.
- Enter four or more start time settings.
- You cannot set the scheduled time in such a manner that the length of the intervals of white ink circulation is longer than six hours.
- Input a time range of "0:00" to 23:59".

<TIPS>

• You can check on the main unit the scheduled time you set. ""9-23. Check circulation schedule >> P.309".

P Brother GTX pro Mainte	nance	×
Step 2: Set the scheduled time for	white ink circulation.	
Current time	14:43	
Start time for white ink circ	lation	
[1]	[2] [3]	[4]
[5]	[6] [7]	[8]
Confirm that the continue.	e date and time of your PC is	set for 2018 or later and
- Enter the start time for	white ink circulation.	
- Input a time range of " For example, when setti	:00" to 23:59". g the time "8:00," either "800" or "8:00" can b	e input.
- Enter four or more star	time settings.	
- You cannot set the sch longer than six hours.	duled time in such a manner that the length o	f the intervals of white ink circulation is
	[< Back Next > Cancel

7-5. When Not Using for a Long Period of Time

When the printer will not be used for a prolonged period of time, take appropriate procedures before storing the printer depending on storage period or condition.

<IMPORTANT>

- Do not turn the printer off. Otherwise, the printer may be damaged.
- If the power source to the printer cannot be sustained, please contact your dealer in advance.

<NOTE>

- If any error message is displayed on the screen, follow the instructions.
- When storing the printer for more than two weeks, cleaning of the nozzle guard, wiper and exhaust cap should be performed. \$\[\sigma"7-1-3. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.188"\]

7-5-1. When Not Using for a Long Period of Time: within 2 weeks

The printer can be used through normal procedure after the storage period, by performing the following maintenance tasks.

- (1) Check the amount of waste ink in the waste ink tank, and if the tank is filled with waste ink up to its one-half or higher level, discard the ink. I Confirmation and disposal of waste ink >>P.128"
- (2) Check the amount of cleaning solution in the cleaning liquid tank, and refill the tank when its amount is below the proper level. F "6-2-2. Confirmation and replenishment of cleaning solution >>P.129"
- (3) Stir the white ink if a white ink cartridge stirring message is displayed on the operation panel screen. ☞ "6-2-3. Daily agitation of the white ink (For GTX pro only) >>P.131"
- (4) As required, print out a nozzle check pattern. 77-2-1. Print out of the nozzle check pattern (checking on the print heads) >> P.213"

7-5-2. When Not Using for a Long Period of Time: more than 2 weeks

Perform the following maintenance every two weeks.

- (1) Check the amount of waste ink in the waste ink tank, and if the tank is filled with the waste ink up to its one-half or higher level, discard the ink. (**) "6-2-1. Confirmation and disposal of waste ink >>P.128".
- (2) Check the amount of cleaning solution in the cleaning liquid tank, and refill the tank when its amount is below the proper level. "6-2-2. Confirmation and replenishment of cleaning solution >>P.129".
- (3) Stir the white ink if a white ink cartridge stirring message is displayed on the operation panel screen. "6-2-3. Daily agitation of the white ink (For GTX pro only) >> P.131"
- (4) Print out a nozzle check pattern and verify the result. 7-2-1. Print out of the nozzle check pattern (checking on the print heads) >> P.213"
- (5) If a non-firing nozzle is found, perform head cleaning and run the nozzle check pattern print, and verify the result again. ☞ "7-2-2. Head cleaning >>P.215".

7-5-3. When Not Using for a Long Period of Time: within 2 weeks with white ink pause mode

The printer can be used through normal procedure after the storage period, by performing the following maintenance tasks.

- (1) Check the amount of waste ink in the waste ink tank, and if the tank is filled with the waste ink up to its one-half or higher level, discard the ink. "6-2-1. Confirmation and disposal of waste ink >>P.128"
- (2) Check the amount of cleaning solution in the cleaning liquid tank, and refill the tank when its amount is below the proper level. ☞ "6-2-2. Confirmation and replenishment of cleaning solution >>P.129"
- (3) As required, print out a nozzle check pattern for the color side. 7-2-1. Print out of the nozzle check pattern
 (checking on the print heads) >>P.213"
 <TIPS>
 - For the White ink pause mode, print the nozzle check patterns for the head only on the color side.

7-5-4. When Not Using for a Long Period of Time: more than 2 weeks with white ink pause mode

Perform the following maintenance every two weeks.

- (1) Check the amount of waste ink in the waste ink tank, and if the tank is filled with the waste ink up to its one-half or higher level, discard the ink. "6-2-1. Confirmation and disposal of waste ink >>P.128"
- (2) Check the amount of cleaning solution in the cleaning liquid tank, and refill the tank when its amount is below the proper level. ☞ "6-2-2. Confirmation and replenishment of cleaning solution >>P.129"
- (3) Print out a nozzle check pattern on the color side and verify the result. 7-2-1. Print out of the nozzle check

pattern (checking on the print heads) >>P.213" <TIPS>

- For the White ink pause mode, print the nozzle check patterns for the head only on the color side.
- (4) If a non-firing nozzle is found, perform head cleaning and run the nozzle check pattern print, and verify the result again. 7-2-2. Head cleaning >>P.215"
- (5) Perform the normal white head cleaning. 7-2-2. Head cleaning >>P.215"

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Contact with high voltage sections may lead to a serious injury. Turn off the power, and remove the cover 5 minutes later.

	Be careful not to get your fingers caught when closing the front cover, otherwise it may result in injury to your fingers.
\bigcirc	Do not disassemble the ink pouch. If the ink gets into your eyes or onto your skin, it may cause inflammation. In case of contact with eyes, do not rub but immediately rinse the eyes with water.
\bigcirc	Do not disassemble the ink cartridge.
\oslash	Do not drink liquids such as the ink, maintenance solution, cleaning solution, pretreatment, or waste. They may cause diarrhea or vomiting. Avoid causing your eyes or skin to make contact with the ink, maintenance solution, cleaning solution, pretreatment or waste. It may cause inflammation. In case of contact with eyes, do not rub but immediately rinse the eyes with water. Keep the liquids out of the reach of children.
	Be sure to wear protective goggles and gloves when handling the grease, so that it does not get into your eyes or onto your skin. It can cause inflammation. Do not drink or eat the grease. It may cause diarrhea or vomiting. Keep the liquids out of the reach of children.
•	When replacing parts and installing optional accessories, be sure to use only genuine Brother parts. Brother will not be held responsible for any accidents or problems resulting from the use of non-genuine parts.
0	When replacing parts or installing optional accessories, be sure to follow the procedures described in the Instruction Manual. Incorrect procedures could cause injuries or problems.
	((!))IMPORTANT

Do not move the platen by hand. Otherwise the printer may be mechanically and electrically damaged.

Ensure there is adequate space left in front of the printer and avoid placing any objects. The platen may be hit and damaged.

8-1. Tasks to be performed regularly

8-1-1. Replenishing color ink

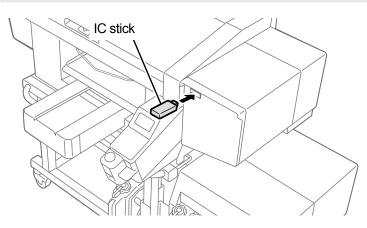
If the is displayed in the remaining ink volume indication window on the operation panel screen, replenish the ink.

<CAUTION>

- Be sure to wear a pair of plastic gloves and protective glasses during the work operation.
- Take care not to lose the IC stick that comes standard with the replenishment ink bottle.
- Once you have replenished ink, you cannot print until you insert the IC stick.

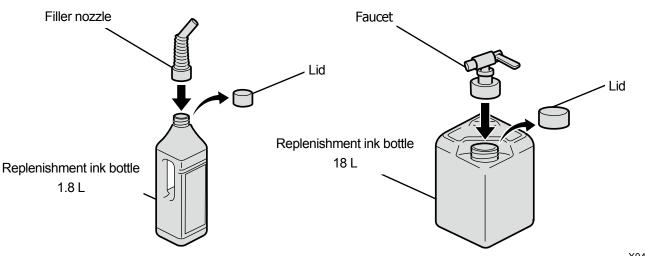


- (1) From the menu, select [Replenish Ink] and press
- (2) From [Black], [Yellow], [Cyan], and [Magenta] select the color with no ink and press
- (3) Insert the IC stick of the same color as the replenished ink and press <TIPS>
 - An error appears if you insert an IC stick of a different color from the depleted ink.



X0391

- (4) Open the replenishment ink bottle and attach the supplied filler nozzle or faucet.
 <IMPORTANT>
 - The used filler nozzle should be disposed of, and should not be reused.
 - To store a faucet after use, wipe off ink with a waste cloth and seal it in a plastic bag.
 - Do not use a non-standard funnel except the supplied filler nozzle. Otherwise, ink may be contaminated or deteriorated, possibly damaging the printer.
 - Use up the 1.8 L replenishment ink bottle every time you open it.



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X0444
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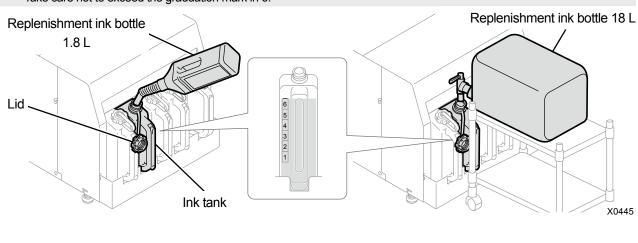
(5) Open the ink tank lid and replenish ink up to the graduation mark in 6.

In addition, if you are using an 18 L bottle of replenishment ink, put the bottle on a table with casters when

replenishing the ink.

<IMPORTANT>

• Take care not to exceed the graduation mark in 6.



- (6) Press (FRU on the operation panel. Close the ink tank lid and press (FRU again. <IMPORTANT>
 - Be sure to close the ink tank lid once you have replenished the ink.
- (7) Remove the IC stick following the instructions on screen and press
 <NOTE>
 - Store the IC stick by attaching it to the handle of the replenishment ink bottle.
 - Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.

8-1-2. Replenishing white ink

is displayed in the remaining ink volume indication window on the operation panel screen, replenish the ink.

Agitate the white ink sufficiently to remove sediments before replenishing it. Agitate the ink beforehand because it takes time.

<IMPORTANT>

If the

- Do not use ink not agitated sufficiently because doing so may deteriorate the durability of the printed matter or cause the head not to eject ink-jet droplets. In cases where the printer malfunctions due to the use of ink not agitated sufficiently, you may be liable for the cost of repairs even during the guarantee period.
- Agitate ink by shaking the replenishment ink bottle.
- Do not insert a bar or propeller into the replenishment ink bottle when agitating the ink because doing so causes foreign mater inclusion, possibly resulting in printer failure.

<CAUTION>

- Be sure to wear a pair of plastic gloves and protective glasses during the work operation.
- Take care not to lose the IC stick that comes standard with the replenishment ink bottle.
- Once you have replenished ink, you cannot print until you insert the IC stick.

Agitating white ink with an agitator

<TIPS>

- Be sure to install an agitator.
 To choose from many types of agitators available, consult your dealer.
- Set the replenishment ink bottle to the agitator.
 <IMPORTANT>
 - Securely fasten the replenishment ink bottle by means of a jig to prevent it from falling during agitation.
- Perform agitation with reference to the manual of your agitator.
 <TIPS>
 - The recommended agitation time differs depending on the ink stationary period and agitator performance.

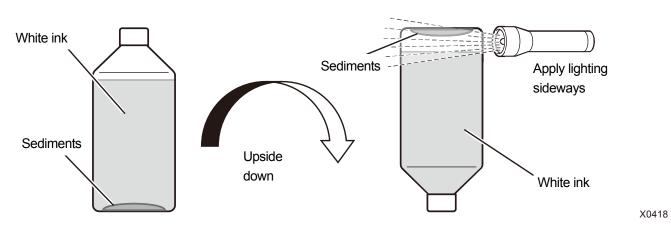
(3) Hold the replenishment ink bottle upside down and apply lighting to its side face to visually check for sediments.

A dark shadow is seen on the bottom if sediments are remaining, so repeat steps (1) and (2) until such a dark

shadow disappears.

<<IMPORTANT>>

- Similarly, hold the 18 L replenishment ink bottle upside down and apply lighting to its side face to visually check for sediments.
- <TIPS>
- Use bright lighting and darken the surrounding area to make the sediments more visible.



Agitated state

With sediments	Without sediments
Sediments	Bubbles
	X0425

<TIPS>

The shadows of bubbles may be confusing with sediments after the white ink agitation, so leave the bottle until bubbles disappear before checking for sediments.
 To distinguish between bubbles and sediments, lightly shake the replenishment ink bottle. The shadows of bubbles move lightly shake the replenishment ink bottle.

To distinguish between bubbles and sediments, lightly shake the replenishment ink bottle. The shadows of bubbles move but the shadows of sediments do not move.

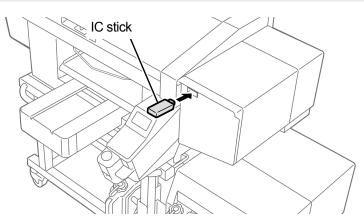
How to replenish white ink



- (1) From the menu, select [Replenish Ink] and press
- (2) Select [White] and press
- (3) Insert the white IC stick and press

<TIPS>

• An error appears if you insert an IC stick of a different color from the depleted ink.

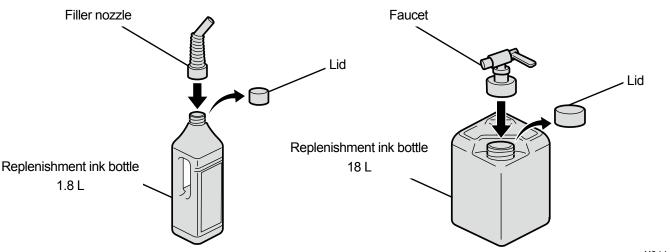


X0391

(4) Open the replenishment ink bottle and attach the supplied filler nozzle or faucet.

<IMPORTANT>

- The used filler nozzle should be disposed of, and should not be reused.
- To store a faucet after use, wipe off ink with a waste cloth and seal it in a plastic bag.
- Do not use a non-standard funnel except the supplied filler nozzle. Otherwise, ink may be contaminated or deteriorated, possibly damaging the printer.
- Use up the 1.8 L replenishment ink bottle every time you open it.



X0444

(5) Open the ink tank lid and replenish ink up to the graduation mark in 6.

In addition, if you are using an 18 L bottle of replenishment ink, put the bottle on a table with casters when

replenishing the ink.

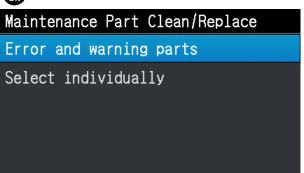
<IMPORTANT>

- Take care not to exceed the graduation mark in 6.
 Replenishment ink botte
 1.8 L
 Lid
 Lid
 Lid
 Lid
 Ink tank
 Ink tank
 Ink tank lid and press
 Image: again.
- (7) Remove the IC stick following the instructions on screen and press
 <NOTE>
 - Store the IC stick by attaching it to the handle of the replenishment ink bottle.
 - Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.

8-1-3. Cleaning and replacement of maintenance parts

Clean or replace individually selected maintenance parts.

- (1) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press
- (2) Select [Individual] and press



(3) Select the maintenance part you want to clean or replace following the message and press

<TIPS>

• The nozzle guard, wiper, exhaust cap, and suction cap should be cleaned at the same time.

(4) Clean and replace.

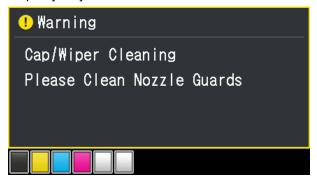
<TIPS>

- For the way to perform cleaning and replacement, refer to the respective maintenance parts.
 - ☞"8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249"
 - ☞"8-1-5. Replacing the wiper cleaner >>P.261"
 - ☞"8-1-6. Replacing the flushing foam >>P.264"
 - ☞"8-1-8. Replacing the fan filter >>P.272"

8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap

When a warning message appears in the warning message window, perform the cleaning.

In the event that maintenance has been performed inadequately, a printed material may be soiled with waste ink during a print session or a printed surface quality may deteriorate.



- (1) Make the clean stick R, clean stick T, cleaning cup, gloves and cleaning solution, which come standard with the printer, available for use.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press
- (3) Select [Part with Error/Warning] and press

<IMPORTANT>

 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

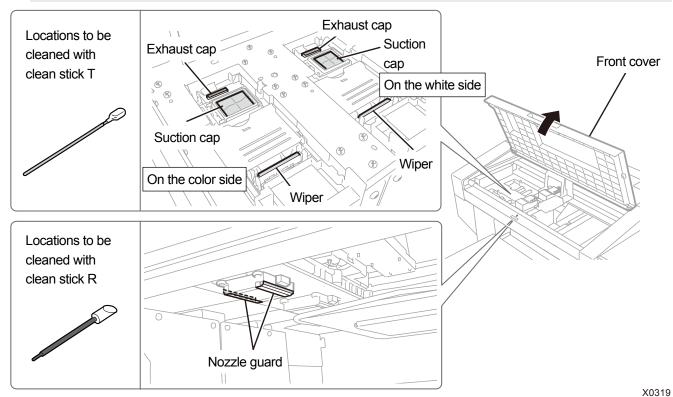
- Pressing (CAL) causes the platen to start moving. Do not put anything around the platen.
- (4) Follow the on-screen message and turn off the power.

<IMPORTANT>

- Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
- If the task takes more than 15 minutes to complete, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.

(5) Open the front cover, and clean each of the nozzle guards, wipers, exhaust caps, and suction caps.

Two types of clean sticks are provided. Use either the clean stick T or R depending on what you want to clean. <TIPS>



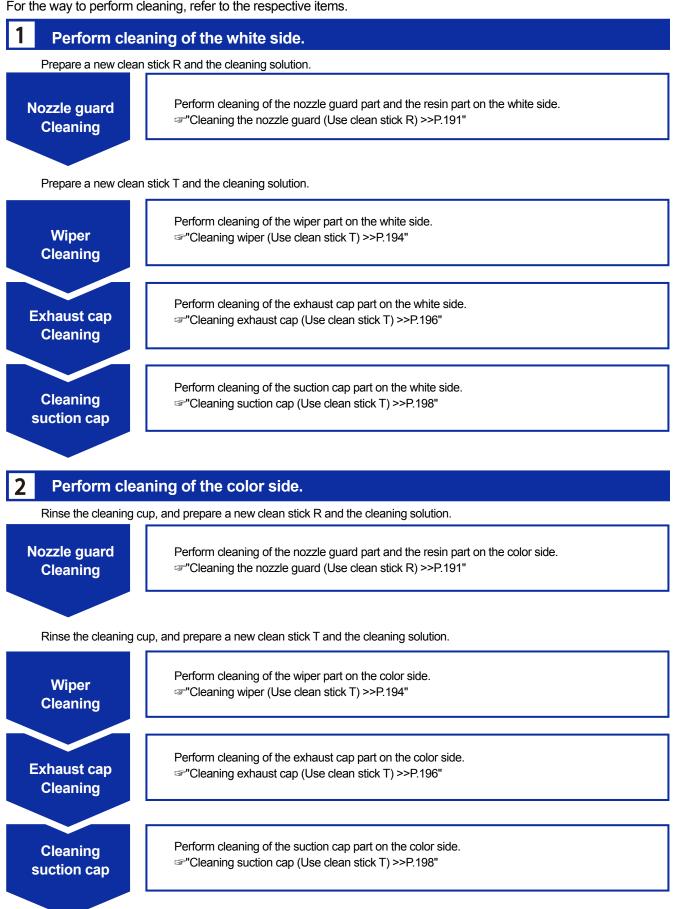
• For the cleaning method, refer to the description mentioned below.

- (6) After the cleaning is completed, close the front cover.
- (7) Turn on the power.

<NOTE>

- Dispose of any waste resulting from the cleaning in accordance with applicable laws and ordinances.
 <TIPS>
- Then, a head cleaning will be performed to prevent any ink from drying up.
- Because the cleaning cup will be reused, rinse it in clean cleaning solution and store it in a safe place.

Cleaning of the nozzle guard, wiper and exhaust cap should be performed separately for the white side and color side. For the way to perform cleaning, refer to the respective items.

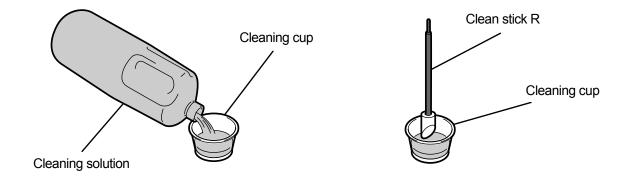


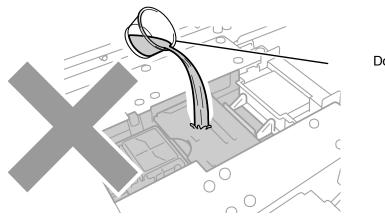
Cleaning the nozzle guard (Use clean stick R)

- (1) Put a proper amount of cleaning solution into the cleaning cup.
- (2) Moisten a new clean stick R with the cleaning solution. <IMPORTANT>
 - Use a new clean stick R when you start cleaning.
 - Never touch the tip end of clean stick R with your hand. If any sebaceous matter is attached to the wiper, it may result in a
 printer malfunction.
 - Do not use other fluids (water, etc.), because they may damage the print heads.
 - Do not return the cleaning solution which has been put in the cleaning cup to the cleaning solution bottle.
 - Do not shed cleaning solution in the maintenance unit.

<NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.





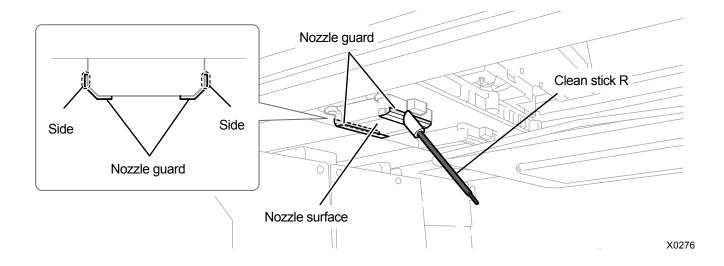
Do not drain waste ink.

X0320

- (3) Wipe clean the sides of the nozzle guard with the clean stick R. </br><IMPORTANT>
 - Be sure not to touch the nozzle surface as well as the level surface and sidling surface of the nozzle guard.
 - <tips>

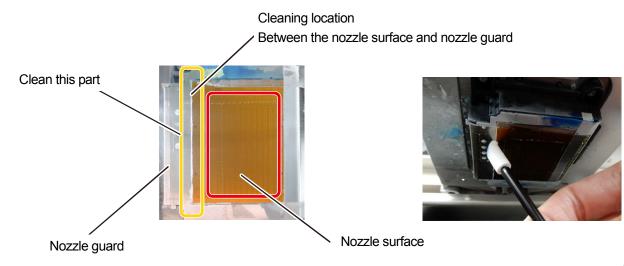
.....

• Manually move the carriage to such a position that you can perform the cleaning with ease.





- (4) Wipe the resin part between the print head's nozzle surface and nozzle guard.
 <IMPORTANT>
 - Be sure not to touch the red-frame zone of the nozzle surface.
 - For cleaning, be sure not to use any tool other than clean stick R.



X0237

Cleaning conditions

Pre-cleaning state	Post-cleaning state	
Cleaning location Between the nozzle surface and nozzle guard	Cleaning location Cleaning location > Cleaning location > Cleaning location www.com"/www.com Cleaning location <a a="" href="https://www.com" www.com"="" wwww.com<=""> Cleaning location 	

<IMPORTANT>

Be sure to use the clean stick R separately for white ink and color ink.

<TIPS>

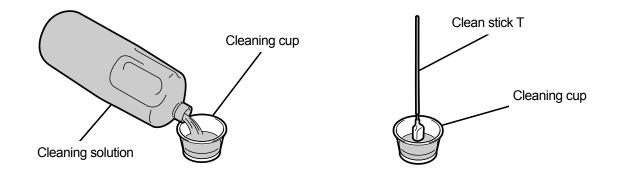
• There may remain white ink in the black resin part, but it doesn't matter if the severity is small as shown in the photo. Wipe away the white ink spreading out of the nozzle guard and nozzle surface.

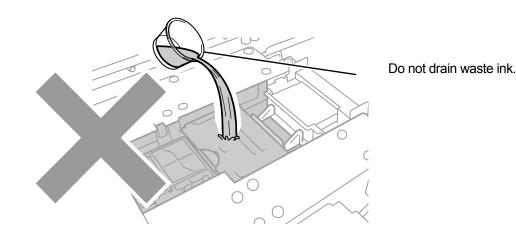
Cleaning wiper (Use clean stick T)

- (1) Put a proper amount of cleaning solution into the cleaning cup.
- (2) Moisten a new clean stick T with the cleaning solution. <IMPORTANT>
 - Use a new clean stick T when you start cleaning.
 - Never touch the tip end of clean stick T with your hand. If any sebaceous matter is attached to the wiper, it may result in a
 printer malfunction.
 - Do not use other fluids (water, etc.), because they may damage the print heads.
 - Do not return the cleaning solution which has been put in the cleaning cup to the cleaning solution bottle.
 - Do not shed cleaning solution in the maintenance unit.

<NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.

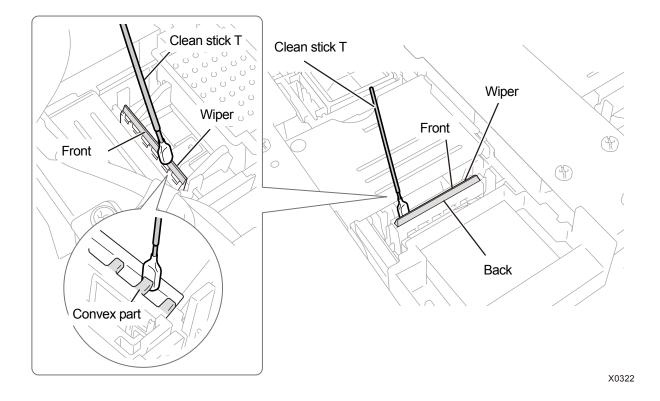




- Use clean stick T to wipe clean the surface of the wiper as well as the gap between the convex part and the wiper.
 <IMPORTANT>
 - Never touch the tip end of clean stick T with your hand. If any sebaceous matter is attached to the wiper, it may result in a
 printer malfunction.
 - Be sure to use the clean stick T separately for color ink and white ink.
 - If ink clot floats on surface, remove it using the clean stick T. Do not use tweezers or other sharp objects. Using sharp
 objects could damage the wiper, possibly resulting in failure to eject ink-jet droplets.

(4) Use the clean side of clean stick T to wipe clean the back of the wiper.

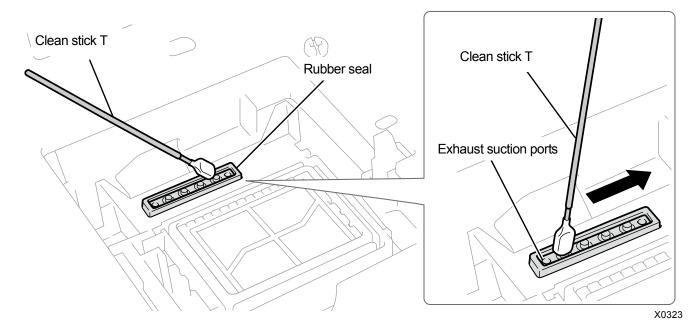
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- (5) Rinse the clean stick T in the cleaning cup to use it for cleaning of the exhaust cap to be performed next.
 <IMPORTANT>
 - Be sure to use the clean stick T separately for white ink and color ink.

Cleaning exhaust cap (Use clean stick T)

- Wipe clean the rubber seal of exhaust cap with the clean stick T.
 <IMPORTANT>
 - Never touch the tip end of clean stick T with your hand. If any sebaceous matter is attached to the wiper, it may result in a
 printer malfunction.
 - The clean stick T used for cleaning the wiper should be rinsed in the cleaning cup before the next use. Be sure to use the clean stick T separately for color ink and white ink.
 - If ink clot floats on surface, remove it using the clean stick T. Do not use tweezers or other sharp objects. Using sharp
 objects could damage the exhaust cap and deteriorate its air tightness, possibly resulting in failure to eject ink-jet droplets.
- (2) Use the clean stick T to soak up the ink accumulated in the exhaust cap, and remove it. <IMPORTANT>
 - If there is any ink clot in the exhaust cap, move the clean stick T in the direction as illustrated below. If the stick is moved toward yourself, any of the exhaust suction ports may be clogged with ink clot.



(3) Rinse the clean stick T in the cleaning cup to use it for cleaning of the suction cap to be performed next. </br><IMPORTANT>

Be sure to use the clean stick T separately for white ink and color ink.
 <TIPS>

• Some cleaning solution may remain in the exhaust cap, but it will not cause any functional problem.

Precautions to keep good printing quality/use printer over the long term (For GTX pro Bulk)

Cleaning conditions

	Pre-cleaning state	Post-cleaning state	
On the white side	Exhaust cap rubber part	Exhaust cap rubber part	
On the color side	Exhaust cap rubber part	Exhaust cap rubber part	

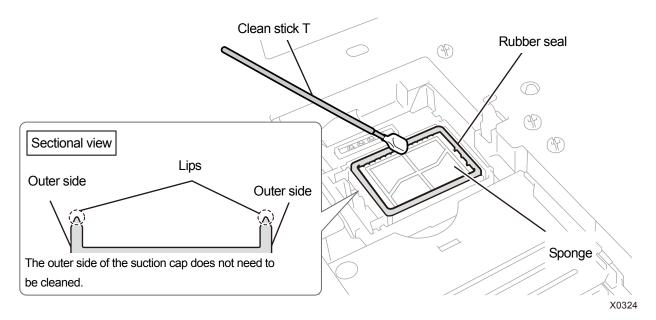
Cleaning suction cap (Use clean stick T)

(1) Wipe the rubber seal and lip of the suction cap with one side of the tip portion of clean stick T in parallel with the

seal.

<IMPORTANT>

- Clean the lip of the suction cap with clean stick T. The print head dries and causes an ejection failure if solidified ink remains.
- Do not touch the sponge of the suction cap. The sponge may come off.
- Never touch the tip end of clean stick T with your hand. If any sebaceous matter is attached to the wiper, it may result in a printer malfunction.
- The clean stick T used for cleaning the wiper and exhaust cap should be rinsed in the cleaning cup before the next use. Be sure to use the clean stick T separately for color ink and white ink.
- If ink clot floats on surface, remove it using the clean stick T. Do not use tweezers or other sharp objects. Using sharp objects could damage the suction cap and deteriorate its air tightness, possibly resulting in failure to eject ink-jet droplets.
- Be sure not to pinch the rubber seal. If it is damaged, its sealing property will be degraded, which in turn may lead to non-ejection of ink-jet droplets from the print heads.



- (2) Replace clean stick T with clean stick R, rinse the cleaning cup, and clean the nozzle guard on the color side head. <IMPORTANT>
 - Be sure to use the clean stick T separately for white ink and color ink.
 - The used clean stick T should be disposed of, and should not be reused.
 - After cleaning the nozzle guard of the color side head, rinse the cleaning cup with pure water, let it dry sufficiently, and store it so that dust does not get inside.

Cleaning conditions

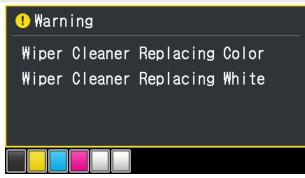
Pre-cleaning state	Post-cleaning state
	X0390

8-1-5. Replacing the wiper cleaner

When a warning message appears on the operation panel screen or in the warning message window, replace the specified wiper cleaner with a new one.

<TIPS>

• When you replace the wiper cleaner, check the staining state inside the printer. If parts inside the printer (carriage guide shaft, roller guide, and carriage roller) are stained, perform cleaning. *** 8-1-7. Cleaning the internal area of printer >> P.267**



- (1) Have the supplied gloves and wiper cleaner ready.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press



(3) Select [Part with Error/Warning] and press (****)

<IMPORTANT>

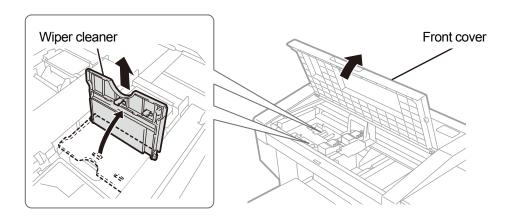
 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing (K) causes the platen to start moving. Do not put anything around the platen.
- (4) Follow the on-screen message and turn off the power.<IMPORTANT>
 - Please complete the task within 15 minutes, in order prevent the print heads from drying up.
 - If the task takes more than 15 minutes to complete, after attaching the wiper cleaner, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (5) Open the front cover.

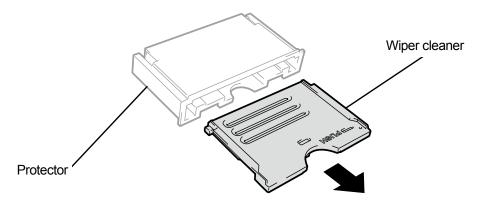
- (6) Raise the wiper cleaner and move it to its upright position, and remove it by moving it upward. <NOTE>
 - For a proper work operation, be sure to wear the printer-provided gloves.

.



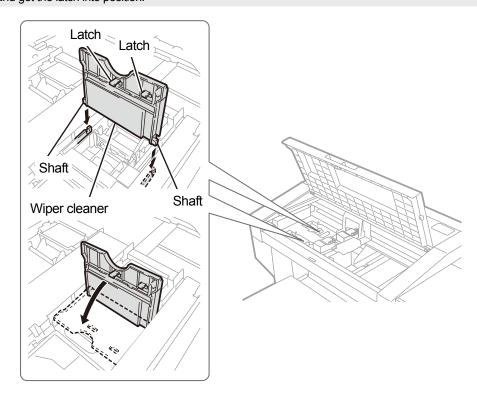
X0325

- (7) Take out the wiper cleaner from its packing bag, and remove it from its protector.
 <IMPORTANT>
 - As soon as it is unpacked, do not leave it as it is and put it in position.



X0326

- (8) Insert a new wiper cleaner into the printer from above, tip it leftward and put it in place. <TIPS>
 - First, insert the shaft from above. Then fold it to the left, press the area with the PUSH indication until a clicking sound is heard, and get the latch into position.



- (9) Close the front cover.
- (10) Turn on the power.

<NOTE>

- Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.
- <TIPS>
- A head cleaning will be performed to prevent ink from drying up.

8-1-6. Replacing the flushing foam

When a warning message appears on the operation panel screen or in the warning message window, replace the specified flushing foam with a new one.

<TIPS>

• When you replace the flushing foam, check the staining state inside the printer. If parts inside the printer (carriage guide shaft, roller guide, and carriage roller) are stained, perform cleaning. ***8-1-7. Cleaning the internal area of printer >>P.267**

. Warning			
Flushing	Foam	Replacing	Color
Flushing	Foam	Replacing	White

(1) Make the clean stick R, gloves and flushing foam, which come standard with the printer, available for use.

<TIPS>

- For this cleaning, you can use an already-used dirty clean stick R.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press
- (3) Select [Part with Error/Warning] and press

<IMPORTANT>

 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing causes the platen to start moving. Do not put anything around the platen.
- (4) Follow the on-screen message and turn off the power.

<IMPORTANT>

- Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
- If the task takes more than 15 minutes to complete, after attaching the flushing receiver, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (5) Open the front cover.

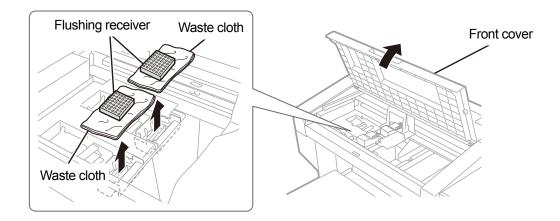
(6) Remove the flushing foam from the maintenance unit.

<IMPORTANT>

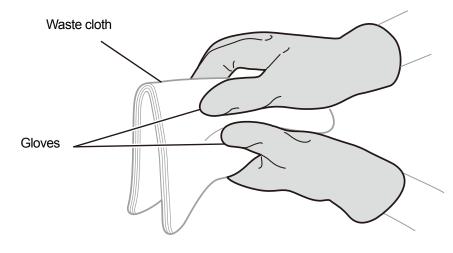
Remove the flushing foam without removing the flushing receiver from the maintenance unit.

• Ink droplets will drop off from the hole in flushing foam. After removal, apply a waste cloth to the bottom face. <NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.



(7) Wipe the gloves with a waste cloth.



X0436

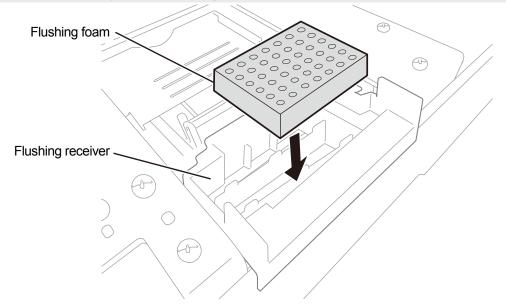
(8) Assemble a new flushing foam to the flushing receiver.

<IMPORTANT>

 After this assembly process is completed, make sure that no flushing foam extends off the outboard end portions of flushing receiver. If it sticks out of the end portions, it may interfere with any nozzles and may result in non-ejection of ink-jet droplets.

<TIPS>

• It is not necessary to clean the flushing receiver.



X0330

- (9) Close the front cover.
- (10) Turn on the power.

<NOTE>

- Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.
 <TIPS>
- The head cleaning will be performed to prevent ink from drying up.

8-1-7. Cleaning the internal area of printer

When you replace the wiper cleaner and the flushing foam, check the staining state inside the printer. If parts inside the printer (carriage guide shaft, roller guide, and carriage roller) are stained, perform cleaning.

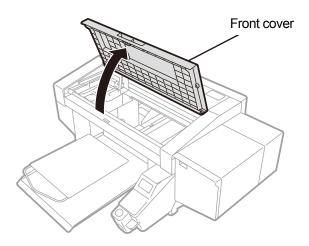
- Prepare a clean stick R, cleaning cup, gloves, cleaning solution, and grease which come standard with the printer.
 <IMPORTANT>
 - Never touch the tip end of clean stick R with your hand. If any sebaceous matter is attached to the head nozzle, it may
 result in a printer malfunction.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press

<IMPORTANT>

If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

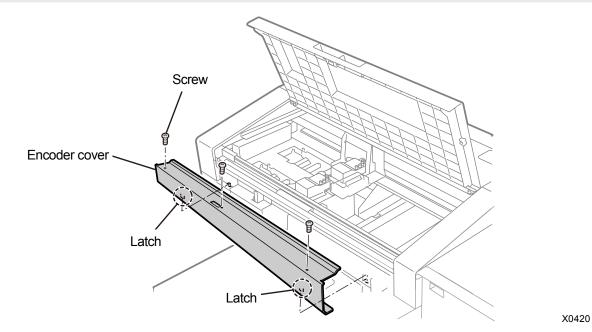
- Pressing (Causes the platen to start moving. Do not put anything around the platen.
- (3) Follow the on-screen message and turn off the power. <IMPORTANT>
 - Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
 - If the task takes more than 15 minutes to complete, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (4) Open the front cover.



(5) Remove three screws to remove the encoder cover.

<CAUTION>

- Do not touch the latch under the encoder cover. Otherwise, the operator may get injured.
- <IMPORTANT>
- Do not touch the encoder on the main unit.

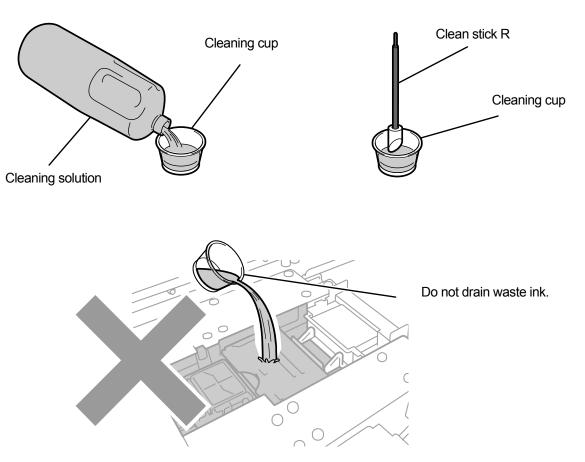


(6) Put a proper amount of cleaning solution into the cleaning cup.

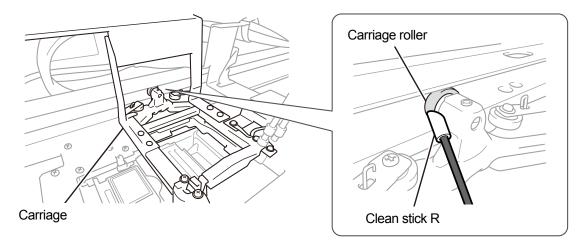
- (7) Moisten a clean stick R with the cleaning solution.
 - <IMPORTANT>
 - Do not return the cleaning solution which has been put in the cleaning cup to the cleaning solution bottle.
 - Do not shed cleaning solution in the maintenance unit.
 - <NOTE>

.

• For a proper work operation, be sure to wear the printer-provided gloves.



- (8) With the clean stick R, wipe away the ink mist on the carriage roller part.
- (9) Move the carriage from side to side to rotate the roller part, and wipe all around the carriage roller.



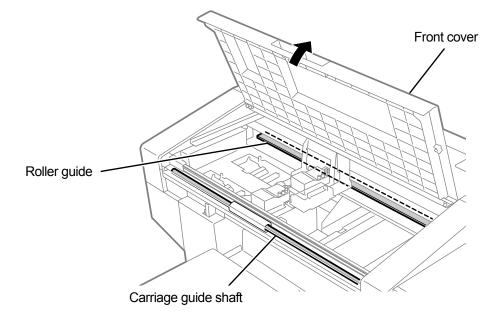
X0448

(10) Clean the carriage guide shaft and the three sides (upper, front, and lower sides across which the roller rolls) of

roller guide.

<TIPS>

- Moisten a waste cloth (non-fuzzy cloth) with a small amount of alcohol, and use such cloth to wipe clean the internal surface.
- Do not use alcohol on parts other than the carriage guide shaft and the roller guide.
- (11) Apply a proper amount of the grease (which is included with the printer) onto the carriage guide shaft. <CAUTION>
 - When handling the grease, perform the work operation in such a manner that it will not get into your eyes or onto your skin.



- (12) Insert the two latches under the encoder cover and fix the cover with three screws.
- (13) Close the front cover.
- (14) Turn on the power.

<NOTE>

Dispose of any waste resulting from the cleaning in accordance with applicable laws and ordinances.
 <TIPS>

- Then, a head cleaning will be performed to prevent any ink from drying up.
- Because the cleaning cup will be reused, rinse it in clean cleaning solution and store it in a safe place.
- (15) Adjust the carriage speed. ref. "8-3-1. CR (Carriage) speed adjustment >>P.285".
- (16) Print out a nozzle check pattern. rev "8-2-1. Print out of the nozzle check pattern (checking on the print heads)

>>P.275".

8-1-8. Replacing the fan filter

When a warning message appears in the warning message window, replace the fan filter with a new one.

! Wa	rning			
Fan	Filter	To Be	Replaced	

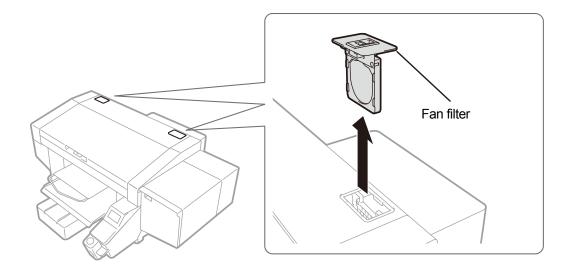
- (1) Make the gloves which come standard with the printer, as well as a new fan filter, available for use.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press
- (3) Select [Part with Error/Warning] and press

<IMPORTANT>

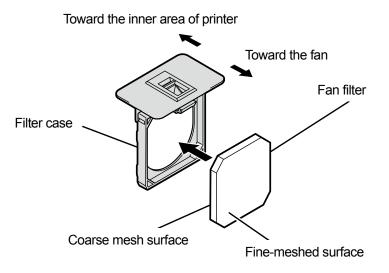
 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing (REND) causes the platen to start moving. Do not put anything around the platen.
 - Pressing will not move the platen or head if the error and warning displayed are [Fan Filter To Be Replaced] only.
- (4) Follow the on-screen message and turn off the power.
- (5) Remove the fan filter from the main unit of printer.<NOTE>
 - For a proper work operation, be sure to wear the printer-provided gloves.



- (6) Mount a new fan filter to the frame of filter case.<IMPORTANT>
 - Mount the fan filter properly in correct position in such a way that its coarse mesh surface faces toward the inner area of printer.



X0062

(7) Mount the assembled fan filter in the main unit of printer.

(8) Turn on the power.

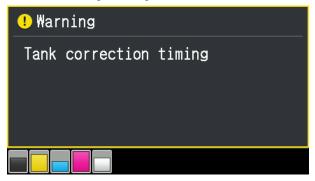
<NOTE>

Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.
 <TIPS>

• Then, a head cleaning will be performed to prevent any ink from drying up.

8-1-9. Correcting the remaining ink level

When a warning message appears in the warning message window, correct the remaining ink level.



- (1) From the menu, select [Maintenance] > [Tank remaining volume sensor correction], and press
- (2) Press \blacktriangle \nearrow . Enter the scale for the ink level and press $\prod_{\alpha \in \mathcal{A}} A^{\alpha}$.

-
Correct tank volume sensor
□Black
4
Enter the liquid level
Then press OK

<TIPS>

- Check and correct the scale for [Black], [Yellow], [Cyan], [Magenta], and [White] in order.
- If the level is between the scales, make a correction based on the lower value.

<CAUTION>

• If you enter an incorrect value, the remaining level may not be correctly recognized and the printer may be damaged.

8-2. Tasks to be performed when needed

8-2-1. Print out of the nozzle check pattern (checking on the print heads)

By printing out a nozzle check pattern, you can check on the printing quality.

It is recommended to always perform this procedure to verify the output.

<TIPS>

The serial number, firmware version, and print date (day/month/year) and time are printed at the bottom of the nozzle check pattern.

The date and time will be printed in Coordinated Universal Time with "(UTC)" printed at the end if time adjustment as a maintenance tool has not been made. You can print the date and time according to your environment by making time adjustment. Image: "8-3-6. Setting of the time displayed on the nozzle check pattern >>P.290"

(1) Put the platen 14X16 in place, and position its level at "A".

☞ "6-4-1. Replacing the currently used platen with another one >>P.148" and "6-4-2. Platen height adjustment >>P.151".

(2) As illustrated below, put the A4-size or letter-size white paper on the platen in alignment with the right-hand corner

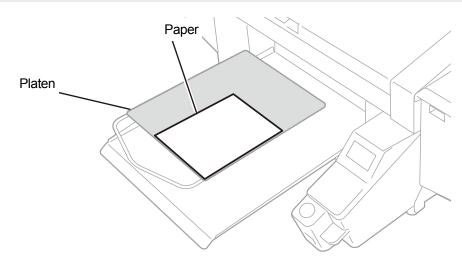
of the platen at its front edge.

When the paper is loosely fitted, fix its edge with a tape or the like.

A T-shirt can also be used instead.

<TIPS>

 When printing out a nozzle check pattern on the white side, print it on a pretreated black or dark color textile or black paper, or a transparent sheet (such as OHP sheet).



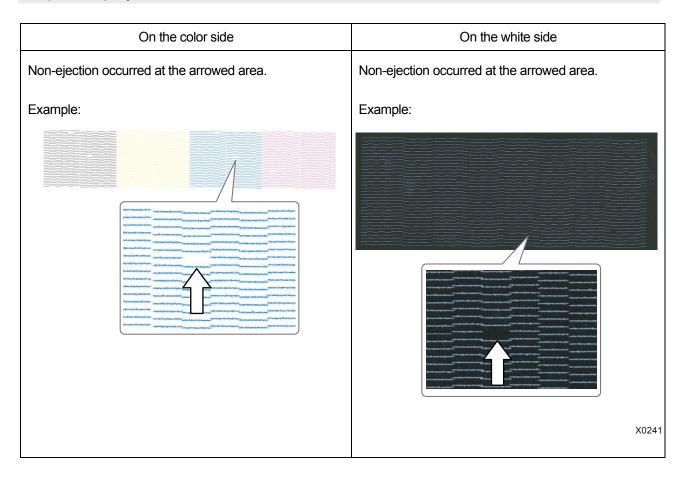
- (3) From the menu, select [Test Print] > [Nozzle Check CMYK], and press Then, printing will begin.
- (4) After printing on the color side is completed, remove the printed paper and replace it with a paper for printing on the white side.
- (5) From the menu, select [Test Print] > [Nozzle Check White], and press
 Then, printing will begin.

(6) Check to see if the printed result of both sides are acceptable, and if no ink-jet droplets have been ejected, perform

a head cleaning for print heads. I "8-2-2. Head cleaning >> P.277"

<IMPORTANT>

- If the print result shows an intermittent line, non-ejection has occurred. A head cleaning should be performed on the print head that has a poor nozzle check result.
- Even if the lines of the white-side printed result are light, since white ink is fired from more than one nozzle on the same place, the quality is not affected.



8-2-2. Head cleaning

This printer has been designed to perform the Auto Cleaning every time 24 print jobs are printed after the previous Auto Cleaning, or before starting the printing using the white ink when one hour or more elapses after the previous printing that used the white ink.

<TIPS>

• The frequency and start timing of Auto Cleaning can be changed. ""9-12. Auto Cleaning Setting >> P.303"

In the event that there is any faintly printed or missing portion on a printed material, head cleaning sometimes provides a solution.

Selecting a type of head cleaning from the menu to perform the head cleaning

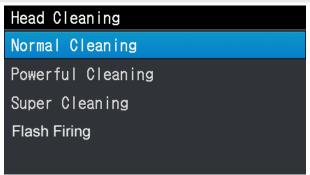
- (1) While the printer is in standby mode press (in the operation panel to bring the menu screen into the view.
- (2) From the menu, select [Head Cleaning], and press

Menu
Head Cleaning
Test Print
Print Data Load
Receiving History
Maintenance

(3) By pressing ▲ / ▼, select one of the options: [Normal Cleaning], [Powerful Cleaning], [Super Cleaning] or [Flash Firing], and press

<TIPS>

• For selecting a desired cleaning option, follow the instructions in the respective steps. "11-2-1. Recovery action to be taken for such a nozzle that is unable to eject ink-jet droplets >>P.389".



(4) By pressing ▲ / ▼, select the [All Colors], [All Whites], or [All Print Heads], and press



<TIPS>

 Under the condition that the nozzle which has been confirmed not ejecting ink-jet droplets, determine the color for which the head cleaning should be performed.
 "8-2-1. Print out of the nozzle check pattern (checking on the print heads) >>P.275"

Normal Cleaning
All Colors
All Whites
All Print Heads

- (5) Then, the head cleaning will be performed for the specified print heads.
 <TIPS>
 - The cleaning operation cannot be canceled halfway.
 - After the procedures are completed, the current screen will go back to the standby mode screen.

8-2-3. White ink circulation

When whiteness is not enough, it may be solved by performing white ink circulation.

(1) While the printer is in standby mode, press

on the operation panel to bring the menu screen into view.

(2) From the menu, select [Maintenance] > [White Ink Circulation], and press

<IMPORTANT>

 Do not turn off the power because if you do so, the machine mail fail because necessary maintenance operations are not performed.

<TIPS>

- Time required for completing the white ink circulation varies depending on the ambient temperature. It normally takes 7 and a half minutes although it can take up to 15 minutes. White ink is circulated automatically every six hours and white ink three times as much as normal is circulated every 24 hours.
- If you are activating the printer after having had its power off for a long period, it will take up to 4 hours depending on how long the power was off.

White Ink Circulation		
All Whites		
[1]min[30]sec		
Please Wait		

8-2-4. Cleaning the CR (carriage) plate

Clean the carriage plate when it is contaminated with ink.

<TIPS>

- You can use an already-used clean stick R.
- (1) Make the clean stick R, cleaning cup, gloves and cleaning solution, which come standard with the printer, available

for use.

<IMPORTANT>

- Never touch the tip end of clean stick R with your hand. If any sebaceous matter is attached to the head nozzle, it may
 result in a printer malfunction.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press

<IMPORTANT>

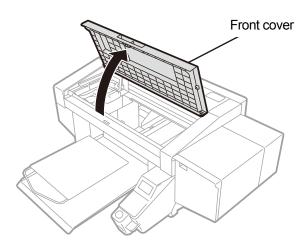
 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing (Causes the platen to start moving. Do not put anything around the platen.
- (3) Follow the on-screen message and turn off the power.

<IMPORTANT>

- Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
- If the task takes more than 15 minutes to complete, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (4) Open the front cover.



X0419

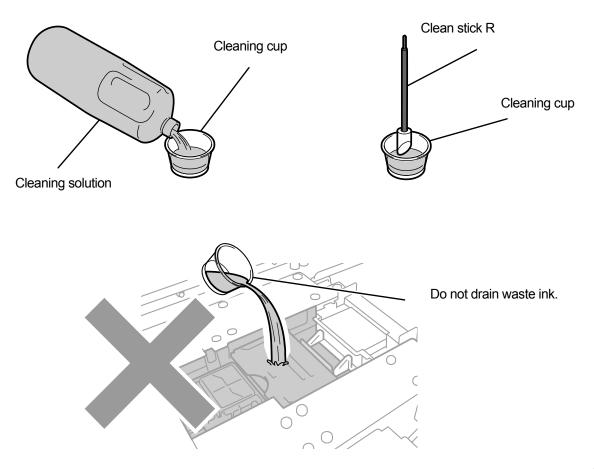
(5) Put a proper amount of cleaning solution into the cleaning cup.

(6) Moisten a clean stick R with the cleaning solution.

- <IMPORTANT>
- If you use an already-used clean stick R, do not use it for other purposes than cleaning the carriage plate.
- Do not use other fluids (water, etc.), because they may damage the print heads.
- Do not return the cleaning solution which has been put in the cleaning cup to the cleaning solution bottle.
- Do not shed cleaning solution in the maintenance unit.
- <NOTE>

.

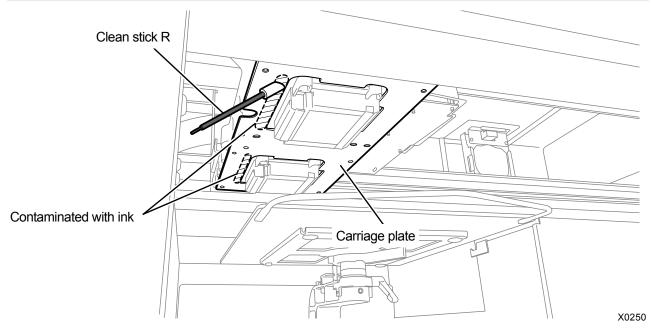
• For a proper work operation, be sure to wear the printer-provided gloves.



- (7) With the clean stick R, wipe away the accumulated ink on the carriage plate of the left-side of the print head. </br><IMPORTANT>
 - Be sure not to touch the nozzle surface.

<TIPS>

• Manually move the carriage to such a position that you can perform the cleaning with ease.



- (8) Clean the carriage plate on the left side of the other print head in the same manner.
 <IMPORTANT>
 - The used clean stick R should be disposed of, and should not be reused.
- (9) Close the front cover.
- (10) Turn on the power.

<NOTE>

Dispose of any waste resulting from the cleaning in accordance with applicable laws and ordinances.

<TIPS>

- Then, a head cleaning will be performed to prevent any ink from drying up.
- Because the cleaning cup will be reused, rinse it in clean cleaning solution and store it in a safe place.

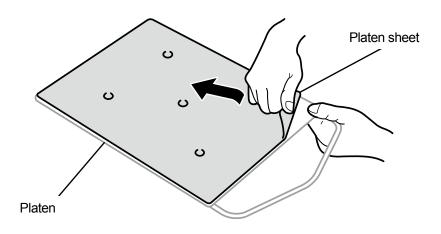
8-2-5. Replacing the platen sheet

When the platen sheet gets soiled, replace it with a new one.

- (1) Remove the platen from the main unit of the printer.
 - ☞ "6-4-1. Replacing the currently used platen with another one >>P.148"
- (2) Peel the platen sheet off the platen.

<TIPS>

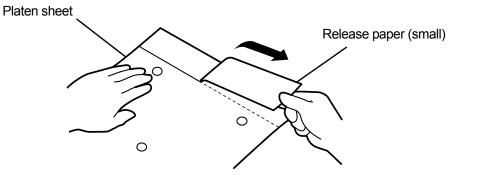
• When it is hard to peel the platen sheet off, warm it using a hair dryer or the like and peel it off.



- (3) Wipe the surface of the platen with a clean cloth moistened with a mild detergent which is diluted with water, then wipe the platen clean with a dry and soft clean cloth.
- (4) Mount the platen in the main unit of the printer.

"6-4-1. Replacing the currently used platen with another one >>P.148"

(5) Peel the release paper (small in size) off a new platen sheet.

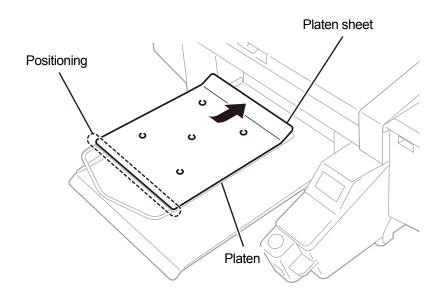


X0157

(6) Position the platen sheet to match the platen surface, and onto the platen, stick the portion of the platen sheet

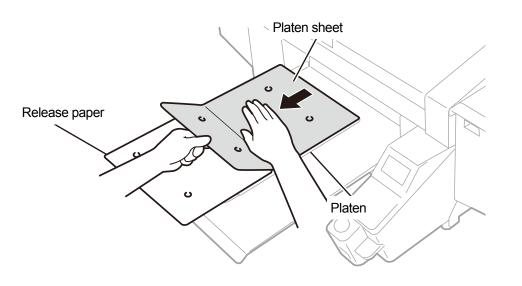
where the release paper (small) was removed.

- <TIPS>
- If the 16X21 platen is used, slide it forward before working on it.



X0423

- Peel off the rest of the release paper, and paste the whole platen sheet onto the entire platen.
 <TIPS>
 - Straighten the platen sheet, and stick it properly while pressing it with hands outward from the center to avoid making wrinkles.



X0424

(8) As required, print a grid pattern onto the new platen sheet.

"5-5-4. Print a grid pattern on the platen sheet >>P.120"

• After the printing is completed, press down the printed surface lightly with a dry cloth or a sheet of paper to dry the ink.

8-3. Adjustment/setup

8-3-1. CR (Carriage) speed adjustment

Carriage speed should be adjusted when the error message [Adjust CR] is displayed on the operation panel. Adjustment should always be performed when carriage shaft cleaning or print head replacement tasks are carried out, or after completing the setup procedures.

(1) While the printer is in standby mode, press

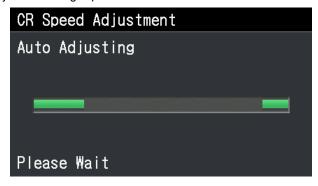
on the operation panel to bring the menu screen into view.

(2) From the menu, select [Printer Setting] > [CR Speed Adjustment], and press

OK

- (3) Select [Start] or [Start (after cleaning/setup)] and press
 - [Start]: If you cannot clean the internal area of the printer such as carriage shaft immediately after the head replacement or when the error message is displayed.
 - [Start (after cleaning/setup)]: After cleaning the carriage shaft.

Wait until the carriage stops moving and the sound of pong is heard. It takes about 3 minutes to adjust the carriage speed.



8-3-2. Initial settings after head replacement

Set V-rating after replacing the print head or completing the setup procedure.

- (1) Make sure that a connection of USB 2.0 cable or LAN cable is made between the printer and your PC.
- (2) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" from "Brother GTX pro Tools".
- (3) After the window shown below appears, select [Initial settings after head replacement] and click [Next].

🖗 Brother GTX pro Maintenance	×
Confirm the printer is turned ON and connected to your PC. Select the printer.	
Brother GTX pro Search	
Select an item from the menu below and click "Next"	
Initial settings after head replacement Perform this setting when replacing the head or when setting up the printer only.	
O Firing Adjustment Adjust this setting when the edges of the print look vague, solid areas are not even, or after a Print Head is replaced.	
 Platen-rolling adjustment Make adjustments when horizontal stripes (banding) occur in the printed image. Use this adjustment as a troubleshooting method when other items such as proper temperature and humidity have already been verified. White/Color Alignment Adjust when white print does not align with color print. 	
O Set an IP Adrress Assign a static IP address to the printer.	
O Log Data Retrieval Execute if there was a request after troubleshooting service.	
O Setting of the time displayed on the nozzle check pattern This is not necessary if you have configured the scheduled time for white ink circulation.	
O Set the scheduled time for white ink circulation Configure this setting to set or cancel the scheduled time for white ink circulation.	
< Back Next > Close	

(4) Perform the required operation by following the on-screen instructions in the dialog box. After the adjustment is completed, the currently displayed screen will go back to the window mentioned above.

8-3-3. Firing adjustment

Because the ejection timing varies depending on the platen's height and properties of each print head, this function is provided to adjust the ejection timing for each print head when any print head is replaced with a new one or after the completion of the setup procedure, for instance. If you want to make adjustments after replacing the print head, configure the initial settings after print head replacement before you do so.

- (1) Make several sheets of A4-size or letter-size paper (black paper or transparent sheet such as OHP sheet, and white paper) available for use.
- (2) Make sure that a connection of USB 2.0 cable or LAN cable is made between the printer and your PC.
- (3) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" from "Brother GTX pro Tools".
- (4) After the window shown below appears, select [Firing Adjustment] and click [Next].

P Brother GTX pro Maintenance	×
Confirm the printer is turned ON and connected to your PC. Select the printer. Brother GTX pro Search Select an item from the menu below and click "Next". O Initial settings after head replacement	
Perform this setting when replacing the head or when setting up the printer only. Ifring Adjustment Adjust this setting when the edges of the print look vague, solid areas are not even, or after a Print Head is replaced.	1
 Platen-rolling adjustment Make adjustments when horizontal stripes (banding) occur in the printed image. Use this adjustment as a troubleshooting method when other items such as proper temperature and humidity have already been verified. White/Color Alignment Adjust when white print does not align with color print. 	-
O Set an IP Adrress Assign a static IP address to the printer.	
O Log Data Retrieval Execute if there was a request after troubleshooting service.	
 Setting of the time displayed on the nozzle check pattern This is not necessary if you have configured the scheduled time for white ink circulation. 	
 Set the scheduled time for white ink circulation Configure this setting to set or cancel the scheduled time for white ink circulation. 	
< Back Next > Close	

(5) Perform the required operation by following the on-screen instructions in the dialog box.

After the adjustment is completed, the currently displayed screen will go back to the window mentioned above.

8-3-4. Platen-rolling adjustment

Platen feed adjustment should be performed after replacing the print head or completing the set up procedure. If you want to make adjustments after replacing the print head, configure the initial settings after print head replacement and adjust the firing timing before you do so.

- (1) Make several sheets of A4-size or letter-size white paper available for use.
- (2) Make sure that a connection of USB 2.0 cable or LAN cable is made between the printer and your PC.
- (3) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" from "Brother GTX pro Tools".
- (4) When the window shown below is displayed, select [Platen-rolling adjustment] and click [Next].

P Brother GTX pro Maintenance	×
Confirm the printer is turned ON and connected to your PC. Select the printer.	
Brother GTX pro V Search	
Select an item from the menu below and click "Next". Dinitial settings after head replacement Perform this setting when replacing the head or when setting up the printer only. Firing Adjustment Adjust this setting when the edges of the print look vague, solid areas are not even, or after a Print Head is replaced.	
Platen rolling adjustment Make adjustments when horizontal stripes (banding) occur in the printed image. Use this adjustment as a troubleshooting method when other items such as proper temperature and humidity have already been verified.	
Adjust when white print does not align with color print. O Set an IP Adrress Assign a static IP address to the printer.	
O Log Data Retrieval Execute if there was a request after troubleshooting service.	
O Setting of the time displayed on the nozzle check pattern This is not necessary if you have configured the scheduled time for white ink circulation.	
O Set the scheduled time for white ink circulation Configure this setting to set or cancel the scheduled time for white ink circulation.	
< Back Next > Close	

(5) Perform the required operation by following the on-screen instructions in the dialog box. After the adjustment is completed, the currently displayed screen will go back to the window mentioned above.

8-3-5. White/color alignment

This is the adjustment function to align the print position on the white side with the print position on the color side. Adjust white/color alignment after replacing a print head or completing the setup procedure.

If you want to make adjustments after replacing the print head, configure the initial settings after print head replacement and adjust the firing timing and platen feed before you do so.

- (1) Prepare a sheet of black paper or a pretreated black or dark color T-shirt.
- (2) Make sure that a connection of USB 2.0 cable or LAN cable is made between the printer and your PC.
- (3) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" from "Brother GTX pro Tools".
- (4) After the window shown below appears, select the [White/Color Alignment] and click [Next].

Prother GTX pro Maintenance	×
Confirm the printer is turned ON and connected to your PC. Select the printer.	
Brother GTX pro V Search	
Select an item from the menu below and click "Next".	
 Initial settings after head replacement Perform this setting when replacing the head or when setting up the printer only. 	
O Firing Adjustment Adjust this setting when the edges of the print look vague, solid areas are not even, or after a Print Head is replaced.	
O Platen-rolling adjustment Make adjustments when horizontal stripes (banding) occur in the printed image. Use this adjustment as a memperature and humidity have already been verified.	
White/Color Alignment Adjust when white print does not align with color print.	
O Set an IP Adrress Assign a static IP address to the printer.	
 Log Data Retrieval Execute if there was a request after troubleshooting service. 	
O Setting of the time displayed on the nozzle check pattern This is not necessary if you have configured the scheduled time for white ink circulation.	
O Set the scheduled time for white ink circulation Configure this setting to set or cancel the scheduled time for white ink circulation.	
< Back Next > Close	

(5) Perform the required operation by following the on-screen instructions in the dialog box. After the adjustment is completed, the currently displayed screen will go back to the window mentioned above.

8-3-6. Setting of the time displayed on the nozzle check pattern

Set the time displayed on the nozzle check pattern.

- (1) Make sure that a connection of USB 2.0 cable or LAN cable is made between the printer and your PC.
- (2) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" of "Brother GTX pro Tools".
- (3) After the window shown below appears, select [Setting of the time displayed on the nozzle check pattern] and click [Next].

	Brother GTX pro V Search
iele	ect an item from the menu below and click "Next".
	O Initial settings after head replacement Perform this setting when replacing the head or when setting up the printer only.
	O Firing Adjustment
	Adjust this setting when the edges of the print look vague, solid areas are not even, or after a Print Head is replac
	OPlaten-rolling adjustment Make adjustments when horizontal stripes (banding) occur in the printed image. Use this adjustment as a troubleshooting method when other items such as proper temperature and humidity have already been verified.
	O White/Color Alignment Adjust when white print does not align with color print.
	O Set an IP Adrress Assign a static IP address to the printer.
	O Log Data Retrieval Execute if there was a request after troubleshooting service.
ſ	Setting of the time displayed on the nozzle check pattern This is not necessary if you have configured the scheduled time for white ink circulation.
	O Set the scheduled time for white ink circulation

- (4) Perform the required operation by following the on-screen instructions in the dialog box.
 <CAUTION>
 - Confirm that the date and time of your PC are set correctly, and continue.

.

Brother GTX pro N	laintenance	
Step 1:		
Set the time displaye	d on the nozzle check pattern.	
Current time	14:47	
Confirm that continue.	It the date and time of your PC is set for 20	18 or later and
- Set to the above	mentioned time.	

(5) After the setting is completed, the currently displayed screen will go back to the Main screen.



8-3-7. Set the scheduled time for white ink circulation

White ink circulation can be performed at a specified time. If not set, white ink circulation will be performed automatically every six hours.

- (1) Make sure that a connection of USB 2.0 cable or LAN cable is made between the printer and your PC.
- (2) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" of "Brother GTX pro Tools".
- (3) After the window shown below appears, select [Set the scheduled time for white ink circulation] and click [Next].

Brot	her GTX pro			~	Search	
elect ar	n item from the men	u below and click	"Next".			
~ ~ ~	itial settings after head					
P	erform this setting when r	replacing the head or w	hen setting up the print	er only.		
OF	ring Adjustment					
A	djust this setting when the	e edges of the print loc	k vague, solid areas are	not even, or a	fter a Print Head is re	plac
OP	aten-rolling adjustment					
M	ake adjustments when he					
	oubleshooting method wi	hen other items such as	s proper temperature an	d humidity hav	ve already been verifie	ed.
-	hite/Color Alignment djust when white print do	ses not align with color	ncint			
-		bes not alight what color	printe			
·	et an IP Adrress					
A	ssign a static IP address to	o the printer.				
OL	g Data Retrieval					
E	xecute if there was a requ	iest after troubleshootir	ig service.			
OSe	tting of the time display	ed on the nozzle che	ck pattern			
	his is not necessary if you			ink circulation		
00	t the scheduled time fo	r white ink circulation				
			ed time for white ink circ			

(4) After the window shown below appears, select [Set the scheduled time for white ink circulation.] and click [Next].

₩ Brother GTX pro Maintenance	×
Step 1: Set or cancel the scheduled time for white ink circulation.	
 Set the scheduled time for white ink circulation. Cancel the scheduled time for white ink circulation. 	
 If the scheduled time of white ink circulation is not set, the white ink circulation is a six hours. 	utomatically turned ON every
 You cannot set the scheduled time in such a manner that the length of the interval longer than six hours. 	s of white ink circulation is
< Back	Next > Cancel

(5) Set the scheduled time for white ink circulation and click [Next].

<CAUTION>

.

- Confirm that the date and time of your PC are set correctly, and continue.
- Enter four or more start time settings.
- You cannot set the scheduled time in such a manner that the length of the intervals of white ink circulation is longer than six hours.
- Input a time range of "0:00" to 23:59".

<TIPS>

• You can check on the main unit the scheduled time you set. ""9-23. Check circulation schedule >> P.309".

Step 2:				
Set the scheduled tir	ne for white ink circulation.			
Current time	14:43			
tart time for white in	k circulation			
[1]	[2]	[3]	[4]	
[5]	[6]	[7]	[8]	
Confirm that continue.	t the date and tin	ne of your PC is	set for 2018 or later	and
- Enter the start tir	ne for white ink circulation.			
	e of "0:00" to 23:59". setting the time "8:00," eit	her "800" or "8:00" can be	e input.	
	e start time settings.			
- Enter four or mor			the intervale of white ink circula	tion is
	e scheduled time in such a r rs.	manner that the length of	the intervals of write ink circula	
- You cannot set th		nanner that the length of		

8-4. When Not Using for a Long Period of Time

When the printer will not be used for a prolonged period of time, take appropriate procedures before storing the printer depending on storage period or condition.

<IMPORTANT>

- Do not turn the printer off. Otherwise, the printer may be damaged.
- If the power source to the printer cannot be sustained, please contact your dealer in advance.

<NOTE>

- If any error message is displayed on the screen, follow the instructions.
- When storing the printer for more than two weeks, cleaning of the nozzle guard, wiper and exhaust cap should be performed. "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249"

8-4-1. When Not Using for a Long Period of Time: within 2 weeks

The printer can be used through normal procedure after the storage period, by performing the following maintenance tasks.

- (1) Check the amount of waste ink in the waste ink tank, and if the tank is filled with waste ink up to its one-half or higher level, discard the ink. I '6-2-1. Confirmation and disposal of waste ink >>P.128"
- (2) Check the amount of cleaning solution in the cleaning liquid tank, and refill the tank when its amount is below the proper level. ☞ "6-2-2. Confirmation and replenishment of cleaning solution >>P.129"
- (3) Stir the white ink if a white ink cartridge stirring message is displayed on the operation panel screen. I "6-2-3. Daily agitation of the white ink (For GTX pro only) >> P.131"
- (4) As required, print out a nozzle check pattern. ☞ "8-2-1. Print out of the nozzle check pattern (checking on the print heads) >>P.275"

8-4-2. When Not Using for a Long Period of Time: more than 2 weeks

Perform the following maintenance every two weeks.

- (1) Check the amount of waste ink in the waste ink tank, and if the tank is filled with the waste ink up to its one-half or higher level, discard the ink. (**) "6-2-1. Confirmation and disposal of waste ink >>P.128".
- (2) Check the amount of cleaning solution in the cleaning liquid tank, and refill the tank when its amount is below the proper level. "6-2-2. Confirmation and replenishment of cleaning solution >>P.129".
- (3) Stir the white ink if a white ink cartridge stirring message is displayed on the operation panel screen. I Compare 10-2-3. Daily agitation of the white ink (For GTX pro only) >> P.131"
- (4) Print out a nozzle check pattern and verify the result. "8-2-1. Print out of the nozzle check pattern (checking on the print heads) >>P.275"
- (5) If a non-firing nozzle is found, perform head cleaning and run the nozzle check pattern print, and verify the result again. ☞ "8-2-2. Head cleaning >>P.277".

As required, make settings and adjustments as mentioned below.

About menu layer on the setting screen

Menu	Setting screen	Description
		[Auto]
	[Print Direction]	[Always Bi-Directional]
		[Always Uni-Directional]
		[Light High]
	[Back Light]	[Light Medium]
		[Light Low]
		[No Auto Screen Erase]
		[5 min]
	[Auto Screen Erase Time]	[10 min]
		[15 min]
		[30 min]
		[1min]
	[Menu TimeOut Setting]	[3min]
		[5min]
	[Speaker Volume]	0 to 7
		[Fahrenheit]
	[Temperature]	[Centigrade]
		[display it upward]
	[Preview display settings]	[display it downward]
	[File name display setting]	[Priority to file name display]
		[Priority to job name display]
	[Obstcl sensr settng during print]	[Check when platen is loading]
[Printer Setting]		[Check during printing as well]
	[Platen too low sensor]	[Enable]
		[Disable]
	I our Tomporatura Madal	[Enable(Normal)]
	[Low Temperature Mode]	[Disable]
	[Auto Cleaning Setting]	1 to 24
	[Auto Cleaning Start Timing]	[Conduct before Printing]
		[Conduct after Printing]
		[every 40 lines]
	[Flushing Interval Setting]	[normal 22 lines]
		[every 10 lines]
		[every 6 lines]
		[More]
	[Flushing Volume Setting]	[Standard]
		[Less]
		[Standard]
	[Wiping frequency]	[Medium-high]
		[High]
	[Auto Job Delete]	[OFF]
		[ON]
	[IP Address Set]	[Manual setting]
		[Automatic acquisition]

.

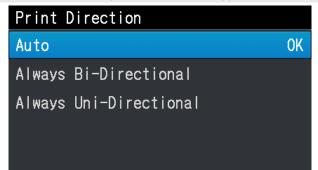
Menu	Setting screen	Description	
	[Nicture]	[Enable]	
	[Network filtering]	[Disable]	
		[Normal cleaning]	
		[Auto cleaning]	
[Drinton Cotting]	[Shortcut button setting]	[Print data Load]	
[Printer Setting]		[White Ink Circulation]	
	[Cartridge Attach/Remove Check]	[Check]	
	(for GTX pro only)	[No check]	
		[Start]	
	[CR Speed Adjustment]	[Start (after cleaning/setup)]	
[Total Print]			
[CTG Attach/Remove History]			
(For GTX pro only)			
[Check circulation schedule]			
[Temperature/Humidity Info]			
	[IP Address]		
	[Subnet Mask]		
[Confirm network setting]	[Default Gateway]		
	[Host name]		
	[MAC address]		
	[English]		
	[Español]		
	[Français]		
	[Deutsch]		
	[Italiano]		
[Language]			
	[中文]		
	[Türkçe]		
	[Русский]		
	[한국어]		
	[Firm Version]		
	[Data Info]		
[Version]	[Serial No.]		
	[Head information]		

9-1. Setting the print direction

- (1) From the menu, select [Printer Setting] > [Print Direction], and press
- (2) Select your desired print direction of the print heads, and press

<TIPS>

- The print direction is displayed here in the form of either bi-directional or the uni-directional icon
- Note that the setting of the print direction gives priority to the printer's setting over the setting of the printer driver.
- The setting content will be kept intact until it is changed for the next printing job.



9-2. Screen back light adjustment

- (1) From the menu, select [Printer Setting] > [Back Light], and press
- (2) Select your desired brightness of Liquid crystal panel, and press



<TIPS>

• During this menu selection process, the screen is displayed with the selected brightness.

Back Light	
Light High	0K
Light Medium	
Light Low	

9-3. Setup of Auto Screen Erase Time

(1) From the menu, select [Printer Setting] > [Auto Screen Erase Time], and press

(2) Select your desired time until the liquid crystal panel and print button become unlit, and press



<TIPS>

• During this menu selection process, the currently selected set value is displayed.

Auto Screen Erase Time	
No Auto Screen Erase	0K
5 min	
10 min	
15 min	
30 min	

9-4. Setting the menu timeout period

- (1) From the menu, select [Printer Setting] > [Menu TimeOut Setting], and press
- (2) Select the time before the display screen returns to the standby mode screen, and press

<TIPS>

• During this menu selection process, the currently selected set value is displayed.

Menu	TimeOut	Setting	
1min			OK
3min			
5min			

OK

9-5. Speaker volume adjustment

- (1) From the menu, select [Printer Setting] > [Speaker Volume], and press
- (2) Adjust the speaker volume in eight-step scale from 0 to 7, and press

<TIPS>

• You can adjust the volume while checking it.



OK

9-6. Setup of temperature indication

- (1) From the menu, select [Printer Setting] > [Temperature], and press (KENU).
- (2) Select your desired unit of ambient temperature to be shown on the liquid crystal panel, and press

Temperature	
Fahrenheit	OK
Centigrade	

9-7. Preview display settings

Set the display direction of the preview image.

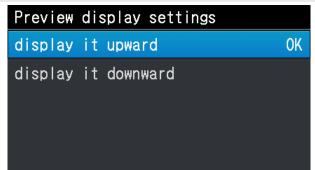
(1) From the menu, select [Printer Setting] > [Preview display settings], and press



(2) Select the display direction and press (NENU OK

<TIPS>

During this menu selection process, the currently selected set value is displayed.



9-8. File name display setting

Make file name display settings of print data.

The display name you set is reflected in the selection screen of standby mode or receiving history or the USB memory loading screen.

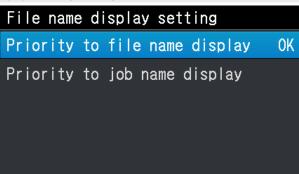
(1) From the menu, select [Printer Setting] > [File name display setting], and press



(2) Select the display method and press

<TIPS>

• The job name is set automatically by the image editing application.



9-9. Configuring the obstacle sensor to work during the printing process

Specify the detection mode of the obstacle sensor by selecting either [Check when platen is loading] or [Check during printing as well].

(1) From the menu, select [Printer Setting] > [Obstcl sensr setting during print], and press



Select the obstacle sensor setting and press (2)

<TIPS>

- During this menu selection process, the currently selected set value is displayed.
- The obstacle sensor is intended to detect wrinkles of the print media or foreign object on it to prevent the print head from contacting wrinkles or foreign matter or minimize the time during which the contact continues.
- If the print head comes into contact with wrinkles or foreign object, a failure to eject ink-jet droplets or a mechanical failure may occur.
- If the obstacle sensor detects a foreign object, the printing process and the platen operation are immediately stopped.
- If you select [Check when platen is loading], the obstacle sensor works only while the platen is moving from the front to the rear.
- If you select [Check during printing as well], the obstacle sensor works during the period from when you press the print button to when the printing process completes.

Obstcl sensr settng during print Check when platen is loading Check during printing as well

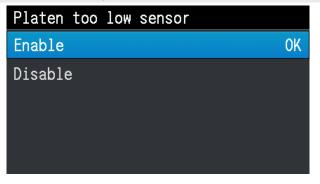
9-10. Platen too low sensor

The sensor is activated if it detects that the print medium is far because the platen is too low. Enable or disable this function when using the printer.

- (1) From the menu, select [Printer Setting] > [Platen too low sensor], and press
- Select the Platen too low sensor function and press (2)

<TIPS>

- The platen too low sensor checks if the platen is too low when it is completely inserted.
- If the platen too low sensor is activated, the printing process and the platen operation are immediately stopped.



9-11. Print Operation Settings Under Low Temperature

Configure the printer with automatic switching to low temperature operation mode for ensuring print quality when [Temp Low] is displayed on the liquid crystal panel. It is set to [Enable(Normal)], by default.

If the low temperature operation mode is enabled, the printer will automatically be switched to the low temperature operation. Although it can assure print quality, it may take longer time for printing.

If the low temperature operation mode is disabled, print speed will not slow down; however, poor ejection may occur.

- (1) From the menu, select [Printer Setting] > [Low Temperature Mode], and press
- (2) Select the print mode under low temperature and press

<TIPS>

• When [Disable] is selected, white ink injection may become unstable when trying to print a wide area.

Low Temperature Mode	
Enable(Nomal)	OK
Disable	

9-12. Auto Cleaning Setting

Setting the Number of Printed Sheets for Auto Cleaning

Specify the number of printed sheets as the frequency of Auto Cleaning; where head cleaning is automatically performed every time a predetermined number of sheets are printed in order to protect the printer and provide stable printing quality. If the printing quality deteriorates in continuous printing, decrease the number of printed sheets for Auto Cleaning. The default value is 24.

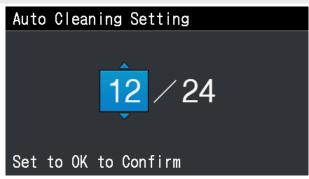
(1) From the menu, select [Printer Setting] > [Auto Cleaning Setting], and press



(2) Press \blacktriangle \checkmark \checkmark to set up the number of sheets to be printed in the range between 1 and 24, and press

<TIPS>

- The printing quality tends to deteriorate if the humidity is low.
- If the auto cleaning is performed more frequently, the Wiper cleaner and flushing foam will need to be replaced with a new one earlier.



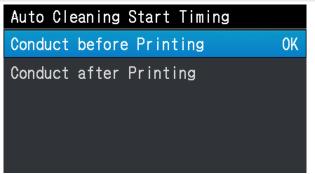
Auto Cleaning Start Timing

Specify your desired auto cleaning start timing.

- (1) From the menu, select [Printer Setting] > [Auto Cleaning Start Timing], and press
- (2) Select your desired auto cleaning start timing, and press

<TIPS>

• Even when [Conduct after Printing] is selected, Auto Cleaning may be performed before printing, depending on the state of use.



9-13. Flushing Interval Setting

Perform this if the printing quality deteriorates during printing operations.

- (1) From the menu, select [Printer Setting] > [Flushing Interval Setting], and press
- (2) Select the desired number of scanning operations until the flushing starts, and press



<TIPS>

- The printing quality tends to deteriorate during the printing operation if the humidity is low.
- Setting shorter flushing intervals improves the printing quality, however, increases the ink consumption and increases the time required for printing.

Flushing Interval	Setting
every 40 lines	
normal 22 lines	OK
every 10 lines	
every 6 lines	

9-14. Flushing Volume Setting

Perform this if the printing quality deteriorates at the startup of the printing operation.

- (1) From the menu, select [Printer Setting] > [Flushing Volume Setting], and press
- (2) Select your desired volume of ink to be ejected from the print heads during the flushing operation before the

printing operation starts, and press

<TIPS>

- The printing quality tends to deteriorate at the startup of the printing operation if the humidity is low.
- Setting larger flushing volume improves the printing quality, however, increases the ink consumption.

Flushing	Volume	Setting		
More				
Standard	alaralaratarataratar Dubbi Dubbi Dubbi D		Oł	(
Less				

9-15. Wiping frequency settings

Perform this if the white printing quality deteriorates while printing.

(1) From the menu, select [Printer Setting] > [Wiping frequency], and press (IIII).



OK

(2) Select the target [Wiping frequency] while printing, and press

<TIPS>

- The printing quality tends to deteriorate while printing if the temperature is low.
- Frequent wipes will improve the printing quality, which, however, will take more time to print.



9-16. Automatic deletion of print data

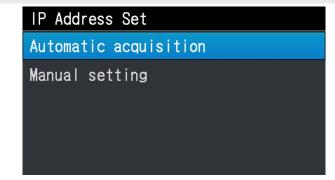
- (1) From the menu, select [Printer Setting] > [Auto Job Delete], and press
- (2) Select the desired function of Auto Job Delete, and press

Auto	Job	Delete			
0FF		alaratarataratarat Na Na Na Na Na Na Na Na	abaratra sa paratra Ulululululululul	alaa ahaa ahaa ahaa WWWWWWWWWW	OK
ON					

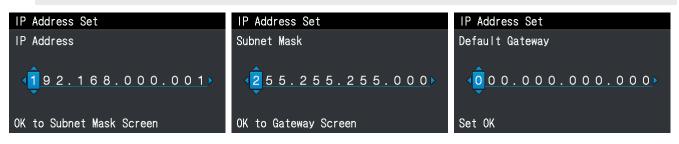
9-17. Static IP address setting

In the [IP Address Set] window, select the manual setting or automatic acquisition, and set up the [IP Address], [Subnet Mask] and [Default Gateway] when you select the manual setting.

- (1) From the menu, select [Printer Setting] > [IP Address Set], and press
- (2) Select either [Manual setting] or [Automatic acquisition] and press <TIPS>
 - If you select [Automatic acquisition], the screen will go back to the standby mode screen after the settings are automatically acquired.



- (3) To make manual settings, press \checkmark \checkmark to move to and select your desired position.
- (4) To make manual settings, press $\blacktriangle \nearrow \blacksquare$ to specify your desired numeric value.
- (5) When the vertex button is pressed, the selected value is accepted, and the display screen goes to the [IP Address], [Subnet Mask] and [Default Gateway] in an orderly manner.
 <TIPS>
 - The display screen shown here has been taken as an example.



9-18. Network filtering settings

This function will enhance LAN security. Enable or disable this function when using the printer. Setting this function to [Enable] will allow access only from subnet mask to which LAN-connected GTX belongs. It is set to [Disable], by default.

- (1) From the menu, select [Printer Setting] > [Network filtering], and press
- (2) Select [Enable] or [Disable] and press

Network	filtering			
Enable	tanat kapat ka Kapat kapat kap	et ant a alle strand and Digiti Digiti Digiti Digiti	()K
Disable				

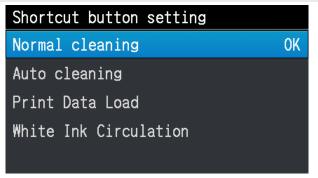
9-19. Shortcut button setting

You can set the operation that takes place when the shortcut button on the operation panel is pressed.

- (1) From the menu, select [Printer Setting] > [Shortcut button setting], and press ((1)).
- (2) Select the function and press (NERU).

<TIPS>

- During this menu selection process, the currently selected set value is displayed.
- If you select [Normal Cleaning], you will be presented with the Normal Cleaning Head Selection menu.
- If you select [Auto Cleaning], Auto-Cleaning begins.
- If you select [Print Data Load], you will be presented with the screen to select the print data to load.
- If you select [White Ink Circulation], the white ink circulation begins.



9-20. Cartridge Attach/Remove Check (for GTX pro only)

This check function prevents the agitation omission and insufficient agitation of the white ink cartridge. Enable or disable this function when using the printer.

Agitate the white ink cartridge if the white ink cartridge stirring message is displayed. "6-2-3. Daily agitation of the white ink (For GTX pro only) >>P.131"

<TIPS>

- It takes about 60 to 120 seconds to agitate the W12 or W34 cartridge.
- If the period in which each cartridge is removed is less than 60 seconds, you cannot move to the next screen by pressing

while the white ink cartridge stirring message is displayed.

- (1) From the menu, select [Printer Setting] > [Cartridge Attach/Remove Check], and press
- (2) Select either [Check] or [Uncheck] and press

Cartridge Attach/Remove Check	
Check	OK
No check	

9-21. Display of total printed sheets

On this display screen, the total number of printed sheets is shown.

- (1) From the menu, select [Total Print], and press
- (2) Then, the total number of printed sheets is displayed.
 <TIPS>
 - Only the number of printed sheets of which printing has succeeded is counted, in which the canceled number of sheets is not included.
 - All the printed sheets involved in printing operation, including test print, are counted.
 - The display screen shown here has been taken as an example.
 - The count of total number of printed sheets cannot be reset.



9-22. Cartridge Attach/Remove Check History (for GTX pro only)

This function makes it possible to display records on the state of the white ink cartridge removed for 60 seconds or more. You can use this function to check whether the agitation of the white ink cartridge is performed regularly.

- (1) From the menu, select [Cartridge Attach/Remove Check History], and press
- (2) The cartridge attach/remove check history is displayed, and you can use the ▲/▼ keys to see the records on cartridge attachment and removal.

CTG Atta	ch/Remove	Histo	ry	
30/09	08:19	[₩12]	199	Sec
30/09	08:19	[W34]	204	Sec
27/09	08:35	[\12]	105	Sec
27/09	08:35	[W34]	90	Sec
26/09	08:25	[₩12]	237	Sec

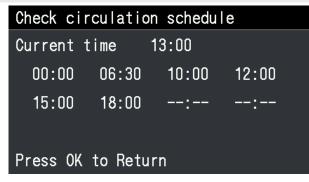
9-23. Check circulation schedule

White ink circulation can be performed at a specified time.

- (1) From the menu, select [Check circulation schedule], and press
- (2) Display the circulation schedule.



- <TIPS>
- If the scheduled time of white ink circulation is not set with the maintenance tool, the circulation schedule will not be displayed.



9-24. Display of Temperature/Humidity Info

On this display screen, the ambient temperature and humidity are shown.

(1) From the menu, select [Temperature/Humidity Info], and press



(2) Then, the ambient temperature and humidity are displayed.

<TIPS>

- Make the setting of temperature indication unit in the Temperature window.
- The display screen shown here has been taken as an example.

Temperature/Humidity	Info
Temperature	[25°C]
Humidity	[78 %]
Press OK to Return	

9-25. Confirm network setting

In the [Confirm network setting] window, display the [IP Address], [Subnet Mask], [Default Gateway], [Host name], and [MAC address].

(1) From the menu, select [Confirm network setting], and press



(2) Select one out of the [IP Address], [Subnet Mask], [Default Gateway], [Host name], and [MAC address], and press



Confirm network setting
IP Address
Subnet Mask
Default Gateway
Host name
MAC address

(3) Display [IP Address], [Subnet Mask], [Default Gateway], [Host name], or [MAC address].

<TIPS>

• The display screen shown here has been taken as an example.

IP Address	Subnet Mask
192.168.000.001	255.255.255.000
Press OK to Return	Press OK to Return
Default Gateway	Host name
<u>000.000.000.000</u> GTX4-XXXXXX	
Press OK to Return	Press OK to Return
MAC address 00:1B:A9:FD	
Press OK to Retur	n

9-26. Language setting

Select your desired language to be shown on the liquid crystal panel.

- (1) From the menu, select [Language], and press
- (2) Select your desired language in the [Language] window, and finalize your setting by pressing



(3) Follow the on-screen message, and turn off the power and on again.

Language	
English	OK
Español	
Français	
Deutsch	
ltaliano	

9-27. Display of version

On this display screen, the firmware's version information, [Firm Version], as well as [Data Info] and [Serial No.], are shown.

(1) From the menu, select [Version], and press



(2) In the window shown below, select one of the [Firm Version], [Data Info] and [Serial No.], and press



Versi	on
Firm	Version
Data	Info
Seria	1 No.
Head	information

(3) Then, one of the [Firm Version], [Data Info] and [Serial No.] will appear.

<TIPS>

- The display screen shown here has been taken as an example.

Firm Version	Data Info
Main 0.65.0000	Message 0.19.0000
MNT 0.64.0000/ 0.64.0000	Font 1.00.0000
LCD 0.57.0000	Test Print 0.00.0007
Head 0.64.0000/ 0.64.0000	
BTL 0.57.0000	
Serial No.	Head information
Serial No.	Head information White
Serial No. Serial No. ABCDEFG1	
	₩hite
	White Head No:XAAOO26 V.Rating:10

9-27-1. Updating of firmware

When a new firmware is released, please update the firmware. <TIPS>

• To check any release information of a new firmware, please visit the website of Brother Industries, Ltd.

- (1) Download the firmware's updated data from the website of Brother Industries, Ltd.
- (2) On the PC, from [All Programs] in the Start menu, select the "GTX pro Firmware Update" from "Brother GTX pro Tools".
- (3) Specify the firmware's updated data (.bwf).

🐨 GTX pro Firmware Update	\times
Select the Firmware Update Data (*.bwf).	
Browse	
< Back Next > Cancel	

(4) Make a connection of the USB 2.0 cable or LAN cable between your PC and the printer, and update your firmware by performing the on-screen procedures.

	Ensure there is adequate space left in front of the printer and avoid placing any objects. Otherwise your hand may get caught between the platen and an object, which may result in injury.
\otimes	Do not handle the platen while printing. If your hand gets caught between the platen or the T-shirt tray and the covers, it may be injured.
	Do not put your hands inside the covers while the printer's power is turned on. Otherwise your hands may touch against moving parts and this may result in injury.
	Be careful not to get your fingers caught when closing the front cover, otherwise it may result in injury to your fingers.
\bigcirc	When you mount or replace the head, be careful not to get your hands or fingers caught. Otherwise you may be injured.
\bigotimes	Do not drink liquids such as the ink, maintenance solution, cleaning solution, pretreatment, or waste. They may cause diarrhea or vomiting. Avoid causing your eyes or skin to make contact with the ink, maintenance solution, cleaning solution, pretreatment or waste. It may cause inflammation. In case of contact with eyes, do not rub but immediately rinse the eyes with water. Keep the liquids out of the reach of children.
0	Be sure to wear protective goggles and gloves when handling the grease, so that it does not get into your eyes or onto your skin. It can cause inflammation. Do not drink or eat the grease. It may cause diarrhea or vomiting. Keep the liquids out of the reach of children.
	When replacing parts and installing optional accessories, be sure to use only genuine Brother parts. Brother will not be held responsible for any accidents or problems resulting from the use of non-genuine parts.
9	When replacing parts or installing optional accessories, be sure to follow the procedures described in the Instruction Manual. Incorrect procedures could cause injuries or problems.

((!))IMPORTANT

Do not move the platen by hand. Otherwise the printer may be mechanically and electrically damaged.

10-1. Troubleshooting instructions

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With reference to the descriptions below, troubleshoot your problem.

No print data can be sent from PC

Probable Cause	Remedy	Reference
Have you selected an incorrect	From the menu for printing, check your printer name.	
printer or not?		-
Has a USB or LAN cable been	Ascertain that connection of the USB 2.0 cable or the	
connected properly?	LAN cable has been made correctly.	-
Are you using such PC or OS that	Check your PC's operating environment.	"13-2. Software >>P.475"
is outside the specification?		
Are you using such a USB 2.0	Use a 2.0 cable that is compliant with the	"1-3. Other items you
cable that is outside the	specification.	must make available for
specification?		use >>P.28"
Has any noise been produced	Remove the USB 2.0 cable/LAN cable first, then	
between the printer and your PC?	make a connection of it once again in five seconds. If	
	the problem continues, power off the printer first, then	
	reactivate it in five seconds.	
Does your PC function properly?	Restart the PC.	-
Has any other USB device been	Remove the other USB device, restart the PC, and	
connected to your PC?	check to see if the printer functions properly.	_
Has the USB cable/LAN cable	Use a different USB or LAN cable.	_
been damaged?		

No printing job gets started even after pressing the print button

Probable Cause	Remedy	Reference
Is the print scheduled (is the button	The print begins as soon as the printer becomes	
flashing fast)?	available. Wait for a while.	-
Is any error message displayed?	Eliminate the cause of the error, and perform printing	"12. Error message
	once more	>>P.423"
Does the menu screen still appear	Please exit the menu. Alternatively, please wait until	
on the screen, or are you	the maintenance operation will come to an end.	
performing the maintenance		-
operation from the menu?		
Is the automatic head cleaning	Please wait until the ongoing head cleaning	
operation underway?	operation is completed.	-
Is the printer in the white ink	Please wait until the ongoing white ink circulation is	
circulation stage?	completed.	-
Is the room temperature suited to	Check for your PC's operating environment and	"13-1. Apparatus >>P.473"
the usage conditions?	adjust the room temperature.	
Does the printer receive no print	Send the print data to the printer. Alternatively, please	
data, or is it in the state to receive	wait until the reception of print data is completed.	
such data (the print button is not		-
illuminating)?		
Do you find that the temperature of	There may be the possibility that the flat cables of	
print heads is	print heads have not been put in place and the	
becoming high, and [Color Head	temperature of print heads has become high.	-
Getting Warm] or [W Head Temp	Turn off the power, make sure that the flat cable is in	
Rising] message appears?	place, and wait until the temperature decreases.	

The power cannot be turned on

Probable Cause	Remedy	Reference
Is the power cord connected to the printer?	Make sure that the power cord is connected to the printer.	-
Is the front cover closed firmly?	Close the front cover properly.	-

An error occurs immediately after activating the printer

Probable Cause	Remedy	Reference
Is any error message displayed?	Check the content of the error, and restart the printer.	"12. Error message
	If the error is still not eliminated, please contact your	>>P.423"
	dealer or Brother.	

No print data can be loaded from USB flash memory

Probable Cause	Remedy	Reference
Has the USB flash memory been	Insert the USB flash memory into the insertion slot	
inserted into its insertion slot	firmly.	-
properly?		
Is the applicable file ARP or AR3	This printer cannot print out the print data of	
file?	GT-541/GT-782/GT-3. Recreate the print data.	-
Is your USB flash memory suited	Please use a FAT32-formatted USB flash memory of	
to required conditions?	which storage capacity ranges from 2 GB to 32 GB.	
	You cannot use a USB memory with security functions	-
	such as password lock or beyond 32 GB.	
Has your USB flash memory	Check to see if it functions properly using your PC or	
been broken?	the like.	-

Neither uni-directional printing nor bi-directional printing can be performed

Probable Cause	Remedy	Reference
Do the settings of printer driver	Note that the setting of the printer's setting has priority	"9-1. Setting the print
and printer agree with each	over the setting of printer driver. The printer driver's	direction >>P.297"
other?	setup value takes effect only if the printer's setting is	
	[Auto].	

The depletion of ink in an ink pouch cannot be detected

Probable Cause	Remedy	Reference
Is an ink pouch in its correct	If the ink pouch is in contact with the side of the ink	"7-1-1. Replacement of
position?	cartridge case, detection may not be performed	ink pouch with a new one
	correctly.	>>P.183"
	Put a proper ink pouch in its correct position.	
After stirring the white ink, is the	Open the lid of the white ink cartridge and	"6-2-3. Daily agitation of
lid of the ink cartridge opened	appropriately rewind the ink pouch. Ink might have	the white ink (For GTX pro
and the pouch placed in the	entered into the wound section of the pouch when	only) >>P.131"
correct position?	stirred, which could have caused improper winding of	
	the pouch.	

"x" is displayed for the remaining ink level after replacing the ink pouch

Probable Cause	Remedy	Reference
Is a wrong color of an ink pouch	Put an ink pouch in its correct position. If colors are	
installed?	mixed on the print result or within the ink pouch,	-
	please contact your dealer.	

Remaining volume indication of the ink pouch does not reflect the actual status

Probable Cause	Remedy	Reference
Didn't you replace an ink pouch in	If you take out an ink pouch that still has much amount	
the way of use?	of remaining ink in the way of use, then set a different	
	ink pouch or the original used ink pouch back to the	
	printer, it can indicate a different volume from the	-
	actual remaining volume. If you keep on using it and	
	the volume is reduced to some extent, the correct	
	remaining volume will be displayed again.	

10-2. Solutions to print quality problems

With reference to the descriptions below, troubleshoot your problem.

Print is too light

Probable Cause	Remedy	Reference
Is the setting of an image editing software application made improperly, or is an image placed in CMYK mode?	Edit the image.	"5-3. Using other applications >>P.82"
Have the printing conditions been applied improperly, or does your image data have insufficient color saturation?	Using [Color Processing], adjust saturation or contrast as appropriate.	"5-4-9. Set up the image quality >>P.115"
Is a sufficient amount of ink left in a cartridge?	Replace the old ink pouch with a new one.	"7-1-1. Replacement of ink pouch with a new one >>P.183"
Is there any nozzle that does not eject ink-jet droplets?	Perform [Head Cleaning] from the menu. If no improvement is attained, follow the referenced instructions.	"10-2-1. Recovery action to be taken for such a nozzle that is unable to eject ink-jet droplets >>P.325"
Is initial settings after head replacement configured?	With reference to, configure the initial settings after head replacement.	"7-4-2. Initial settings after head replacement >>P.231"
Isn't the [Low Temperature Mode] set to [Disable]?	Change the setting to [Enable (Normal)].	"9-11. Print Operation Settings Under Low Temperature >>P.302"

Horizontal stripe (banding) is found on printed material

Probable Cause	Remedy	Reference
Is there any nozzle that does not eject ink-jet droplets?	Perform [Head Cleaning] from the menu. If no improvement is attained, follow the referenced instructions.	"10-2-1. Recovery action to be taken for such a nozzle that is unable to eject ink-jet droplets >>P.325"
Do you print ink dots on a highly water-absorbing print medium?	Set the print head's print direction to [Always Uni-Directional]. Also, combine the color multiple pass printing with the printing.	"9-1. Setting the print direction >>P.297" "5-4-6. Specify whether or not to perform Multiple Pass Printing >>P.110"
Is the platen positioned at too low level?	Adjust the height of the platen corresponding to the print medium before using it. You can use the platen height adjustment lever to adjust the height of platen. As a rough indication, adjust the height so that it is lowered by one step from the limit height detected by the obstacle sensor, and check that the platen is not detected by the sensor.	"6-5. Placing print medium in position >>P.162"

Troubleshooting (For GTX pro)

Probable Cause	Remedy	Reference
Is the firing timing well-timed?	Adjust the ejection timing again. It is likely that the	"7-4-3. Firing adjustment
	setup value is incorrectly set after replacing a print	>>P.232"
	head or the platen with a new one, or after adjusting	
	the platen height.	
Is platen feed adjusted?	Perform the platen feed adjustment. It is likely that	"7-4-4. Platen-rolling
	the setup value is incorrectly set after replacing a	adjustment >>P.233"
	print head or the platen with a new one.	
Is the [White High Speed Print]	Turn off the [White High Speed Print] check box to	"5-4-4. Set up the white
check box of the print data turned	create the print data.	ink >>P.106"
on?		
Isn't the temperature low?	Change the wiping frequency setting.	"9-15. Wiping frequency
		settings >>P.305"
Isn't the [Low Temperature Mode]	Change the setting to [Enable (Normal)].	"9-11. Print Operation
set to [Disable]?		Settings Under Low
		Temperature >>P.302"

Blurring is observed (when printed with [Color Ink Only])

Probable Cause	Remedy	Reference
Isn't the amount of ink excessive	Print the ink volume and check the blurring, and select	"5-5-5. Adjust the ink
against the print media?	appropriate set value for [Ink Volume:].	volume >>P.121"
		"5-4-7. Set up the color ink
		>>P.111"

Blurring is observed (when printed with [Color+White Ink])

Probable Cause	Remedy	Reference	
Is the [Highlight:] of [White Ink	Print the highlight check pattern to check the blurring,	"5-5-6. Print out o	ſ
Settings:] too high?	and select appropriate set value for [Highlight:].	highlight check	ĸ
		pattern/mask check	ĸ
		pattern >>P.122"	
		"5-4-4. Set up the white	Э
		ink >>P.106"	
	By turning ON the [White/Color Pause] or [Color	"5-4-8. Set up the white	Э
	Multiple Pass Printing] checkbox, extend time before	ink >>P.112"	
	the color ink settles onto the white ink, to prevent	"5-4-6. Specify whether o	r
	blurring. Try this method to eliminate blurring without	not to perform Multiple	Э
	weakening the highlight.	Pass Printing >>P.110"	

"7-1-5. Replacing the flushing foam >>P.203"

"7-2-5. Replacing the

platen sheet >>P.221"

"7-2-4. Cleaning the CR

(carriage) plate >>P.218"

Probable Cause Remedy Reference Is the area around the print heads Clean the head section and suction cap. "7-1-3. Cleaning the soiled with waste ink spilled from Furthermore, replace the wiper cleaner with a new nozzle guard, wiper, the wiper cleaner or head cap? exhaust cap, and suction one. cap >>P.188" "7-1-4. Replacing the wiper cleaner >>P.200" Is any lint attached to the nozzle Clean the nozzle guard. "7-1-3. Cleaning the surface? nozzle guard, wiper, exhaust cap, and suction cap >>P.188" Is the carriage plate contaminated? Clean the carriage plate. "7-2-4. Cleaning the CR (carriage) plate >>P.218" Do the print heads rub against a Flatten the surface of T-shirt, and adjust the platen's "6-5. Placing print medium T-shirt? height as required. in position >>P.162"

Replace the flushing foam with a new one.

Replace the platen sheet with a new one.

Perform the cleaning of the carriage plate and

Ink sticks to such an area where no print data exists (ink stain, horizontal stripe, etc.)

The edges of the image are blurred, characters and straight lines are doubly printed and printed

remove the accumulated ink.

result appears too granular

Has the flushing foam become

Has the platen sheet become

Has any ink attached to the

carriage that secures the print

heads in place or is it dripping off?

dirty?

dirty?

Probable Cause	Remedy	Reference
Is the platen positioned at a level	Adjust the height of the platen corresponding to the	"6-5. Placing print medium
that is too low?	print medium before using it. You can use the platen	in position >>P.162"
	height adjustment lever to adjust the height of platen.	
	As a rough indication, adjust the height so that it is	
	lowered by one step from the limit height detected by	
	the obstacle sensor, and check that the platen is not	
	detected by the sensor.	
Is the firing timing correct?	Adjust the ejection timing again. It is likely that the	"7-4-3. Firing adjustment
	setup value is incorrectly set after replacing a print	>>P.232"
	head or the platen with a new one, or after adjusting	
	the platen height.	
Is the image enlarged on the	When a low resolution image is enlarged on the	
printer setting screen?	printer setting screen, it may blur or angle the image.	
	Pattern data should be enlarged on an image editing	-
	application, and its roughness should be checked.	

Thin color cannot be printed out well gradually

Probable Cause	Remedy	Reference
Is the ambient atmosphere at a	Perform the flushing more frequently. In addition,	"9-13. Flushing Interval
high temperature and very dry,	increase the flushing volume.	Setting >>P.304"
which in turn tends to cause the		"9-14. Flushing Volume
nozzle surface to dry up?		Setting >>P.304"

White ink is not printed out evenly

Probable Cause	Remedy	Reference
Has the pretreatment been	Apply the recommended amount of pretreatment	"6-3-3. Application of
applied unevenly?	evenly to the target area.	pretreatment >>P.140"
Has the pretreatment caused any	After the pretreatment roller is used, put it in a plastic	
change in hardness or	bag or the like hermetically to prevent it from drying	
deformation of the pretreatment	up, and keep it in a flat place in an upright position.	
roller? (This applies to the case	Also, when it remains unused for two weeks or	-
where the pretreatment roller is	longer, wash it well with running water, and let it dry in	
used.)	a shaded area.	
Is any water content attached to	Prevent water content from being attached to the	"6-3-4. Fixation of
the pretreatment roller after the	roller after the pretreatment is fixated.	pretreatment >>P.146"
pretreatment is fixated?		
Is there any lint, yarn waste, dust,	Clean the surface of the pretreatment roller.	"6-3-3. Application of
etc. that are attached to the		pretreatment >>P.140"
surface of pretreatment roller?		
(This applies to the case where		
the pretreatment roller is used.)		
Did you shake the pretreatment	Shake the pretreatment sufficiently.	"6-3-2. Dilution of
after its dilution?		pretreatment >>P.138"
Is the [Low Temperature Mode]	Change the setting to [Enable (Normal)].	"9-11. Print Operation
set to [Disable]?		Settings Under Low
		Temperature >>P.302"
Has the pretreatment been fixated	Check on an actual temperature of the heat press	"6-3-4. Fixation of
insufficiently?	and its pressure during the fixation stage.	pretreatment >>P.146"
	Always keeping the lower iron (where media is	
	placed) of the heat press at heated temperature with	
	a heating source may solve this problem.	

Whiteness of print result is insufficient

Probable Cause	Remedy	Reference
Has the pretreatment been	Apply a proper amount of pretreatment.	"6-3-3. Application of
applied insufficiently?		pretreatment >>P.140"
Has the pretreatment been fixated	Check on an actual temperature of the heat press	"6-3-4. Fixation of
insufficiently?	and its pressure during the fixation stage.	pretreatment >>P.146"
Is there any nozzle that does not eject ink-jet droplets?	Perform [Head Cleaning] from the menu. If no improvement is attained, follow the referenced instructions.	"10-2-1. Recovery action to be taken for such a nozzle that is unable to eject ink-jet droplets >>P.296"

Probable Cause	Remedy	Reference
Is the white ink circulated	From the menu, select [Maintenance] > [White Ink	
insufficiently?	Circulation] to circulate the white ink properly.	-
Is the white ink stirred	In the event that the white ink remains accumulated in	
insufficiently?	the bottom of the ink pouch, shake the pouch 100	
	times and additionally shake it until the ink is stirred	
	well.	
	Also, when the remaining ink level becomes	-
	approximately 5.9 in. (15 cm), shake the cartridge	
	with its cover open and with the edge of the ink pouch	
	slightly winded.	
Is the [Low Temperature Mode]	Change the setting to [Enable (Normal)].	"9-11. Print Operation
set to [Disable]?		Settings Under Low
		Temperature >>P.302"
Is the dilution rate of the	Dilute the pretreatment appropriately.	"6-3-2. Dilution of
pretreatment correct?		pretreatment >>P.138"
Is the [Highlight:] of [White Ink	Print the highlight check pattern to check the blurring,	"5-5-6. Print out of
Settings:] too low?	and select appropriate set value for [Highlight:].	highlight check
		pattern/mask check
		pattern >>P.122"
		"5-4-4. Set up the white
		ink >>P.106"

Too much luster

Probable Cause	Remedy	Reference
Are you using Teflon-treated	Use a silicon coated peel off sheet when curing the	
peel-off sheet for fixation?	ink to reduce the gloss.	-

Too fuzzy

Probable Cause	Remedy	Reference
Did you touch the print media	Excessively touching the media (T-shirt) on the	
(T-shirt) just before printing?	platen by trying to flatten the media before printing	
	could cause fuzziness. Make sure not to touch the	-
	media surface too much after the pretreatment is	
	fixated.	
Does it take a long time before	Leaving the print media (T-shirt) after fixing the	
printing, after the pretreatment	pretreatment may cause fuzziness, because the	
fixation?	media would absorb water. Print the pretreatment	-
	fixated media as soon as possible.	
Is the upper iron on the heat press	If the upper iron is contaminated, it could roughen the	
contaminated during the	print media (T-shirt) surface by a heat press process,	
pretreatment fixation process?	to cause fuzziness. Clean the upper iron of the heat	
	press with a cloth.	-
	If the condition persists, try using a peel-off sheet	
	during the pretreatment fixation process, to probably	
	improve the condition.	
Unevenly dried during the fixation	It may be solved by inserting a silicone foam	
process?	between the heat press lower iron and a print media	-
	(T-shirt) during ink fixation.	

Background white ink spreads out when printed with [Color+White Ink]

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Probable Cause	Remedy	Reference
[White/Color Alignment]	Misalignment of white and color inks can occur when	"7-4-5. White/color
misaligned?	the media thickness or the platen height is changed.	alignment >>P.234"
	Adjust the platen height first for the actual media to be	
	printed, and align the white and color inks positions.	
Is the media easy to stretch when	Print misalignment may occur between white and	"5-4-8. Set up the white
wet?	color inks when the media stretches when wet with	ink >>P.112".
	white ink. Increasing [Choke Width:] can prohibit	
	spreading of the background white ink.	

Printed surface cracks after fixation

Probable Cause	Remedy	Reference
Isn't the print surface folded before	Try not to touch the print surface until the fixation	
fixation is completed?	process is completed.	-

The lower left side area of the printer's main unit is soiled with ink

Probable Cause	Remedy	Reference
Is the waste ink tube dismounted	For help, please contact your dealer.	
from the maintenance unit?		-
Is the waste ink tube clogged	Straighten the waste ink tube to remove the clog.	
causing the waste ink to flow		-
reversely?		

The cleaning solution is leaked from the cleaning liquid tank

Probable Cause	Remedy	Reference
Is the main body of printer put	Place the printer horizontally.	"4-1. Installation of printer
aslant?	If the problem is still not remedied, please contact your	>>P.48"
	dealer.	

Takes longer print time than before

Probable Cause	Remedy	Reference
Is the ambient temperature under	Adjust the room temperature to 18°C (64.4°F) or	"9-11. Print Operation
18°C (64.4°F)?	more.	Settings Under Low
	If it is difficult to adjust the room temperature, set the	Temperature >>P.302"
	operational configuration under low temperature to	
	[Disable].	
Is your printing under	Lower your room temperature below 30°C (86°F).	
high-temperature and low humidity	Raise your room humidity over 35%.	-
environment?		
Is the wiping frequency set to	Change the wiping frequency to [Standard].	
[Medium-high] or [High]?		-

10-2-1. Recovery action to be taken for such a nozzle that is unable to eject ink-jet droplets

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Items to be checked	Description	Remedy	Document
Is the cap contaminated?	When the cap is contaminated, it cannot fully contact the head, which would lead to suction failure.	Clean the cap	Refer to "7-1-3. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.188".
Is there any deposit of ink around the nozzle surface?	When the surrounding area of nozzle surface is contaminated, it could lead to ejection failure since the wiper cannot clean the nozzle surface properly. Or, it could reduce the adhesion between the nozzle and cap, thereby causing ink suction failure.	Cleaning the surrounding area of nozzle surface	Refer to "10-2-4. Cleaning the surrounding area of nozzle surface >>P.339"
Is the wiper contaminated?	When the wiper tip is contaminated, it could lead to ejection failure since the wiper cannot clean the nozzle surface properly.	Clean the wiper	Refer to "7-1-3. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.188".
Is there any indication of scar or deformation on the wiper?	When the wiper has any scar or deformation, it could lead to ejection failure since the wiper cannot clean the nozzle surface.	Replace the wiper	Refer to "10-2-7. Replacing the Wiper >>P.371".
Is the wiper cleaner contaminated?	If the wiper cleaner is contaminated, residual dirt on the wiper may prohibit the wipers cleaning function.	Replacing the wiper cleaner	Refer to "7-1-4. Replacing the wiper cleaner >>P.200".
Is the wiper cleaner dried?	If the wiper cleaner is dry, it may prohibit the wiper's proper function to wipe clean.	Replacing the wiper cleaner	Refer to "7-1-4. Replacing the wiper cleaner >>P.200".
Is the flushing foam floated?	If the flushing foam is not placed appropriately, it may touch the nozzle surface to stop ejection from the nozzle.	Replace the flushing foam	Refer to "7-1-5. Replacing the flushing foam >>P.203".
Is the ink accumulated on the flushing foam?	If an ink accumulates on the flushing foam, the ink may touch the nozzle surface to prevent ink from ejecting.	Replace the flushing foam	Refer to "7-1-5. Replacing the flushing foam >>P.203".
Is the tube correctly connected to the head?	If they are loosely mated, it may allow air to enter into the head section during the head cleaning operation, to cause non-ejection condition of the nozzle.	Verify connection between the head and the tube	Refer to "10-2-6. Replacement of print head >>P.345".
Is the ink pouch properly attached to the cartridge?	If the ink pouch is not properly installed, the cartridge cannot fully wind it, and fails to supply enough ink to the head.	Install an ink pouch	Refer to "7-1-1. Replacement of ink pouch with a new one >>P.183".
Is the tube filled with ink?	If a large amount of air exists in the tube, that air will go into the head to cause non-ejection condition of the nozzle.	Re-install the ink	Refer to "10-2-8. Re-install the ink >>P.376".

Please verify the followings when any nozzle is not ejecting ink droplets.

After carrying out appropriate remedial measures listed above, make sure the non-firing nozzle has been recovered. If it has not, perform the steps 1 to 5 to recover the non-firing nozzle.

Step 1: Print out a nozzle check pattern

(1) Print out a nozzle check pattern (1st time).

<TIPS>

- For details of the printing method of nozzle check pattern, refer to "7-2-1. Print out of the nozzle check pattern (checking on the print heads) >> P.213".
- (2) Check the result of the printed nozzle check pattern (1st time), and carry out the following procedures. 7-2-1.

Print out of the nozzle check pattern (checking on the print heads) >>P.213" <TIPS>

Even if the white print result is weak, since the white ink is ejected on one same spot through multiple nozzles, a relatively large amount of ink volume will be used, and the firing problem of a single nozzle will not affect the print quality so much. Even in a condition with weak lines, the print is performed without a problem.

Existence or nonexistence of a nozzle that does not eject any ink-jet droplets	Recovery action
Such a nozzle does not exist that does not eject any ink-jet droplets	If a number of non-firing of white head is observed in printing although such non-firing problems do not occur in nozzle check pattern printing, please contact your dealer. If a number of non-firing of white head is observed in printing although such non-firing problems do not occur in nozzle check pattern printing, replace the filter. In 10-2-5. Replacing the color filter >>P.342" If non-firing cannot be resolved after replacing the filter, please contact your dealer.
Such a nozzle exists that does not eject any ink-jet droplets	Proceed to Step 2.

Step 2: Perform the head cleaning

- (1) Perform a normal cleaning. 7-2-2. Head cleaning >>P.215"
- (2) Print out a nozzle check pattern (2nd time).
- (3) Check the result of the printed nozzle check pattern (2nd time), and carry out the following procedures.

Existence or nonexistence of a nozzle that does not eject any ink-jet droplets	Recovery action
Such a nozzle does not exist that	Exit
does not eject any ink-jet droplets	
Ten-or-less nozzles exist that do	Perform the normal cleaning once again. Subsequently, proceed to (4).
not eject any ink-jet droplets	
Ten-or-more nozzles exist that do	Perform the powerful cleaning. Subsequently, proceed to (4).
not eject any ink-jet droplets	
More than half of the nozzles of	Re-install the ink. Is "10-2-8. Re-install the ink >>P.376"
the color heads have a problem	Subsequently, proceed to (4).
concerning firing of the print	
heads.	
More than half of the nozzles of	Clean the white heads. I 10-2-8. Re-install the ink >>P.376"
the white heads have a problem	Subsequently, proceed to (4).
concerning firing of the print	
heads.	

<TIPS>

- For the ink re-installing method, please refer to.
- For details of cleaning method of white heads, refer to "10-2-2. White head cleaning >>P.302".
- (4) Print out a nozzle check pattern (3rd time).
- (5) Check the result of the printed nozzle check pattern (3rd time), and carry out the following procedures.

Existence or nonexistence of a	
nozzle that does not eject any	Recovery action
ink-jet droplets	
Such a nozzle does not exist that	Exit
does not eject any ink-jet droplets	
Such a nozzle exists that does not	Proceed to Step 3.
eject any ink-jet droplets	

Step 3: Check that no ink-jet droplets are ejected from the applicable nozzle

(1) Check locations of the non-ejecting nozzles on the result of the printed nozzle check pattern (1st to 3rd time), and

carry out the following procedures.

Comparison of non-ejection nozzle positions	Recovery action
The same nozzle always does not	Perform the super cleaning -> print out of nozzle check pattern for the third
eject ink-jet droplets	time in a row.
A different nozzle does not eject	Leave the printer as it is for about 30 minutes, and perform the normal
ink-jet droplets	cleaning -> print out of nozzle check pattern for the third time in a row.

(2) Check a result of the resultant nozzle check patterns, and carry out the following procedures.

Existence or nonexistence of a	
nozzle that does not eject any	Recovery action
ink-jet droplets	
Such a nozzle does not exist that	Exit
does not eject any ink-jet droplets	
Such a nozzle exists that does not	Proceed to Step 4.
eject any ink-jet droplets	

Step 4: Clean the nozzle surface

- (1) Clean the nozzle surface of the print heads. "10-2-3. Cleaning of head nozzle >>P.336"
- (2) Print out a nozzle check pattern.
- (3) Check a result of the resultant nozzle check patterns, and carry out the following procedures.

Existence or nonexistence of a	
nozzle that does not eject any	Recovery action
ink-jet droplets	
Such a nozzle does not exist that	Exit
does not eject any ink-jet droplets	
Such a nozzle exists that does not	Proceed to Step 5.
eject any ink-jet droplets	

<IMPORTANT>

• Even if the nozzles on the white side have a bit of problem concerning firing, since the white ink is ejected on one same spot through multiple nozzles, relatively large amount of ink volume will be used, and firing problem of a single nozzle will not affect the print quality so much. Even in a condition with a problem concerning firing as shown in (a), print is performed without a problem as shown in (b).

Step 5: Head Replacement

• •

(1) Replace the print head with a new one. ☞ "10-2-6. Replacement of print head >>P.345"

10-2-2. White head cleaning

If a problem concerning firing of the white head side is not cleared even after performing the head cleaning, perform the white head cleaning.

After the white head cleaning is completed, conduct the Install White Ink After Cleaning. <TIPS>

- Although the white head cleaning can begin even when the remaining volume of maintenance solution in the maintenance solution pouch is running short, there may be cases where the pouch needs to be replaced with a new one during the cleaning depending on such remaining volume. If the remaining volume is 500 g (17.6 oz) or less, prepare a new maintenance solution pouch.
- When the white ink pouch runs low on its remaining volume of white ink, the Install White Ink After Cleaning function can no longer get started. Furthermore, there may be cases where the pouch needs to be replaced with a new one during the installation process of white ink. If the remaining volume is 400 g (14.1 oz) or less, prepare a new white ink pouch.

White Head Cleaning

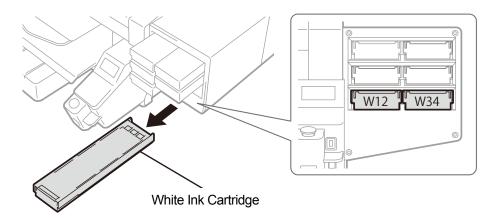
(1) From the menu, select [Maintenance] > [White Head Cleaning], and press

<TIPS>

- Perform the work operation by following the on-screen instructions.
- (2) After making sure that the waste ink tank is filled one-half or less full with waste ink, and press

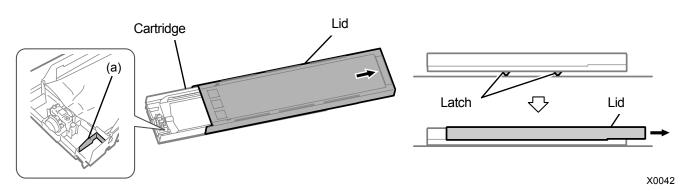


- (3) Take out the white ink cartridge from the printer. <CAUTION>
 - The bottom of the cartridge may be soiled with ink. Clean the printer on a regular basis.

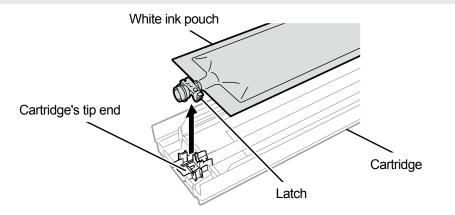


(4) Open the cartridge's lid.

- <IMPORTANT>
- When opening the lid, be sure not to touch the portion (a). Otherwise, it could be damaged.
- Place the entire cartridge on a flat surface, push the latches on the bottom surface of the cartridge downward and open the lid.



- (5) Pinch the latch at the front end of ink pouch, and draw out the white ink pouch from the cartridge. <CAUTION>
 - Remove the accumulated ink at the tip of the cartridge with a waste cloth (non-fuzzy cloth). Clean the printer on a regular basis.



X0119

Stretch

X0049

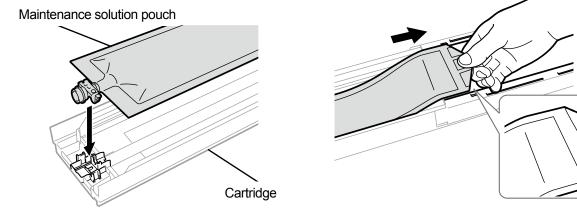
(6) Put the maintenance solution pouch in the cartridge.

Push the tip end of the maintenance solution pouch into the cartridge until it clicks into place.

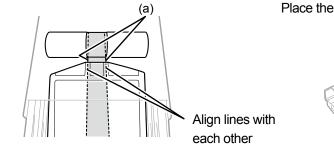
Straighten the maintenance solution pouch in such a manner that it will be aligned with the gutter of the lid of the cartridge, and mount in position by pulling it with your hand.

<NOTE>

• If the edge of the ink pouch is bent or undulating significantly, make it straight with your hand.



- (7) Put the maintenance solution pouch in its correct position.<CAUTION>
 - Avoid touching the portion (a) of cartridge. Otherwise, you may cut your hand.



Place the pouch in a straight alignment with the cartridge



- (8) Close the lid, and put the maintenance solution cartridge in position inside the printer.
- (9) Repeat the same process to replace the other white ink cartridge with the maintenance solution pouch.
- (10) On the operation panel, press

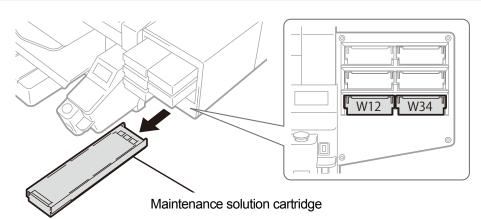
Then, the white head cleaning will be performed.

<TIPS>

 White head cleaning will take approximately 25 minutes. Perform the "Install White Ink After Cleaning" operation by following the on-screen instructions.

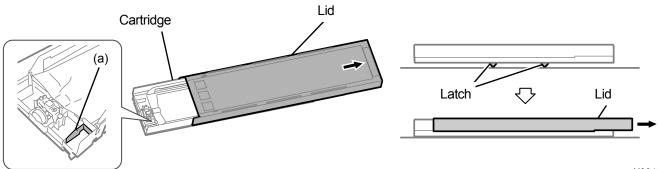
Install White Ink After Cleaning

- Make sure the message [Install White Ink After Cleaning] is displayed on the liquid crystal panel.
 <TIPS>
 - Perform the work operation by following the on-screen instructions.
- (2) Take out the maintenance solution cartridge from the printer.
 - <CAUTION>
 - The bottom of the cartridge may be soiled with ink. Clean the printer on a regular basis.



X0333

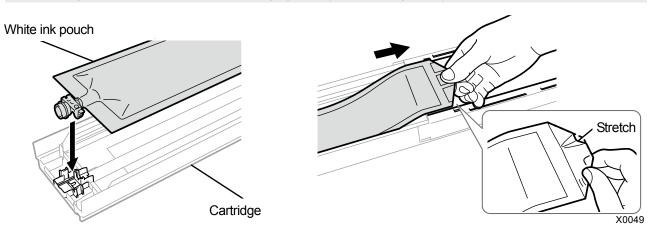
- (3) Open the cartridge's lid. <IMPORTANT>
 - When opening the lid, be sure not to touch the portion (a). Otherwise, it could be damaged.
 - Place the entire cartridge on a flat surface, push the latches on the bottom surface of the cartridge downward and open the lid.



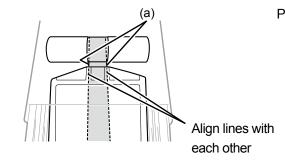
(4) Take out the maintenance solution pouch from the cartridge, and put the white ink pouch in place. Push the tip end of ink pouch into the cartridge until it clicks into place. Straighten the ink pouch in such a manner that it will be aligned with the gutter of the lid of the cartridge, and mount in position by pulling it with your hand.

<NOTE>

If the edge of the ink pouch is bent or undulating significantly, make it straight with your hand.



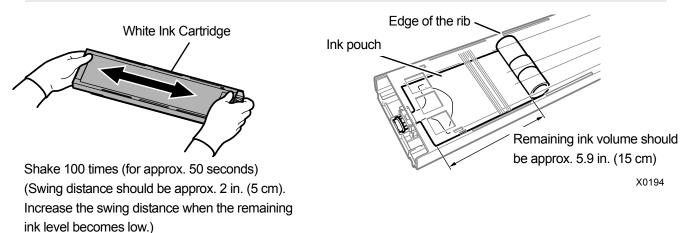
- (5) Put the white ink pouch in its correct position. <CAUTION>
 - Avoid touching the portion (a) of cartridge. Otherwise, you may cut your hand.



Place the pouch in a straight alignment with the cartridge

X0041

- (6) Shake the cartridge 100 times side to side to stir the ink. <IMPORTANT>
 - The white ink cartridge should be held horizontally when shaking it.
 - Holding the white ink cartridge upside down or shaking it too roughly could break the ink pouch.
 - <NOTE>
 - Wear the provided gloves when performing this task.
 - When the remaining ink level becomes approximately 5.9 in. (15 cm), shake the cartridge with its cover open and with the edge of the ink pouch slightly winded, to make the ink easier to stir.



334

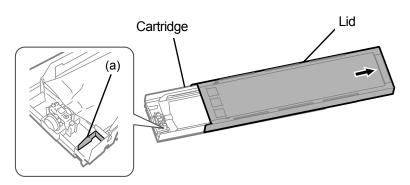
X0182

(7) Open the lid of the cartridge and place the ink pouch in its correct position. <IMPORTANT>

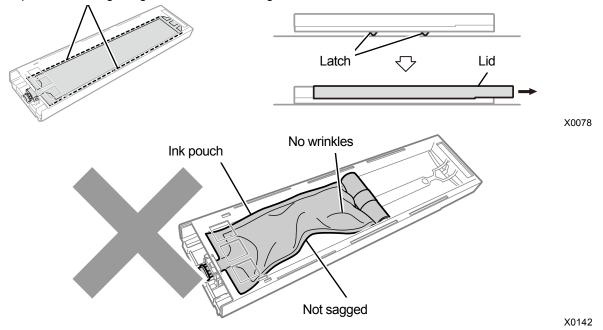
- Always open the cartridge lid and properly rewind the ink pouch. If the pouch is placed without opening the lid, ink can flow into the wound section of the pouch when stirred, which can cause improper winding of the pouch.
- When opening the lid, place the entire cartridge on a flat surface, push the latches on the bottom surface of the cartridge downward and open the lid.
- When setting the ink pouch, avoid unevenness or wrinkles on the pouch.
- When opening the lid, be sure not to touch the portion (a). Otherwise, it could be damaged.

<NOTE>

• If the remaining ink level is low, hold the sagged part of the ink pouch and close the lid.



Place the pouch in a straight alignment with the cartridge



(8) Close the lid, and put the white ink cartridge in position inside the printer.

<IMPORTANT>

- W12 and W34 cartridges should correctly be placed in their original locations. Wrongly placed cartridges could cause a
 printer malfunction.
- (9) Repeat the same process to replace the other maintenance solution cartridge with the white ink pouch.
- (10) Check the waste ink tank level and take any necessary measure for it, if any, then press on the operation panel.
 After the cleaning is completed, the Install White Ink After Cleaning function will get started.
 <TIPS>
 - The "Install White Ink After Cleaning" operation will take approximately 15 minutes. After the procedures are completed, the current screen will go back to the standby mode screen.

10-2-3. Cleaning of head nozzle

If a problem of non-ejection of ink-jet droplets is not cleared even after performing the head cleaning, perform the head nozzle cleaning. 7-1-3. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.188"

- Clean the nozzle guard first, then clean the head nozzle.
- (1) Make the clean stick R, cleaning cup, gloves and cleaning solution, which come standard with the printer, available

for use.

<IMPORTANT>

- Use a new clean stick R when you start cleaning.
- Never touch the tip end of clean stick R with your hand. If any sebaceous matter is attached to the head nozzle, it may
 result in the printer malfunction.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press

<IMPORTANT>

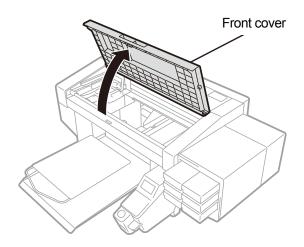
 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing (CAL) causes the platen to start moving. Do not put anything around the platen.
- (3) Follow the on-screen message and turn off the power.

<IMPORTANT>

- Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
- If the task takes more than 15 minutes to complete, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (4) Open the front cover.



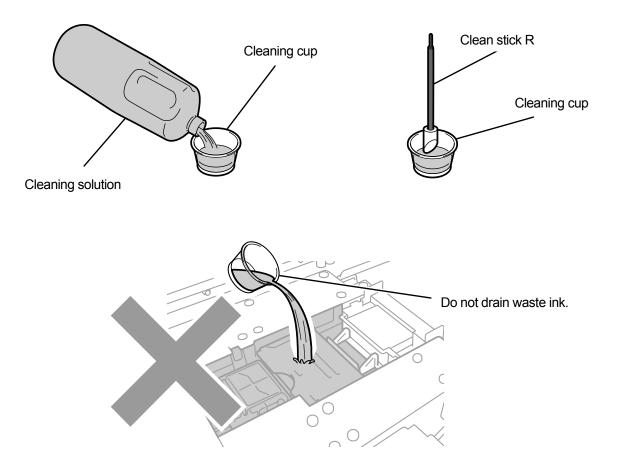
- (5) Put a proper amount of cleaning solution into the cleaning cup.
- (6) Moisten a clean stick R with the cleaning solution.

<IMPORTANT>

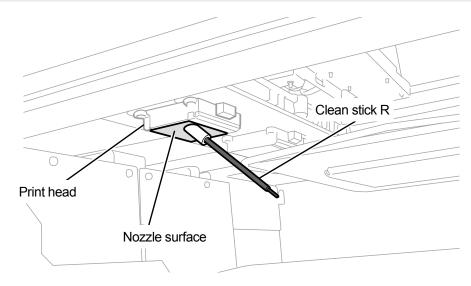
- Be sure to use a different clean stick R separately for the color head and the white head. Use a new clean stick R when you start cleaning.
- Do not use other fluids (water, etc.), because they may damage the print heads.
- Do not return the cleaning solution which has been put in the cleaning cup to the cleaning solution bottle.
- Do not shed cleaning solution in the maintenance unit.

<NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.



- (7) With a clean stick R, clean the nozzle surface of print head.
 Manually move the carriage to such a position that you can perform the cleaning with ease.
 <IMPORTANT>
 - Be sure not to bring corner edges of the clean stick R into contact with the nozzle surface.
 - Avoid roughly rubbing the nozzle surface.
 - The used clean stick R should be disposed of, and should not be reused.



X0251

- (8) Close the front cover, turn on the power.
- (9) From the menu, select [Head Cleaning] > [Powerful Cleaning] > [All Print Heads], and press
 <NOTE>



Dispose of any waste resulting from the cleaning in accordance with applicable laws and ordinances.
 <TIPS>

- Then, the head cleaning will be performed to prevent any ink from drying up.
- Because the cleaning cup will be reused, rinse it in clean cleaning solution and store it in a safe place.

10-2-4. Cleaning the surrounding area of nozzle surface

(1) Make the clean stick R, cleaning cup, gloves and cleaning solution, which come standard with the printer, available

for use.

<IMPORTANT>

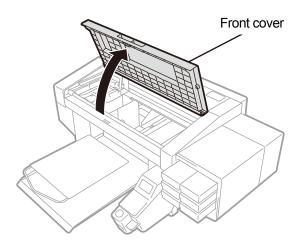
- Use a new clean stick R when you start cleaning.
- Never touch the tip end of clean stick R with your hand. If any sebaceous matter is attached to the head nozzle, it may
 result in the printer malfunction.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press

<IMPORTANT>

 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing (K) causes the platen to start moving. Do not put anything around the platen.
- (3) Follow the on-screen message and turn off the power. <IMPORTANT>
 - Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
 - If the task takes more than 15 minutes to complete, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (4) Open the front cover.



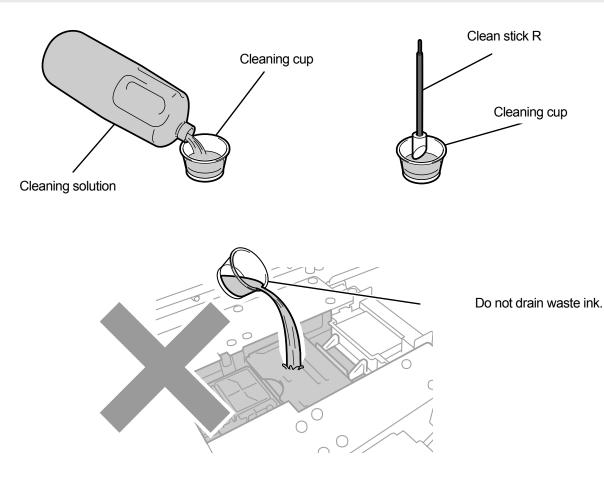
- (5) Put a proper amount of cleaning solution into the cleaning cup.
- (6) Moisten a clean stick R with the cleaning solution.

<IMPORTANT>

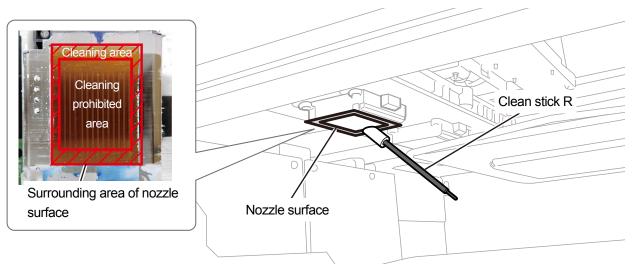
- Be sure to use a different clean stick R separately for the color head and the white head. Use a new clean stick R when you start cleaning.
- Do not use other fluids (water, etc.), because they may damage the print heads.
- Do not return the cleaning solution which has been put in the cleaning cup to the cleaning solution bottle.
- Do not shed cleaning solution in the maintenance unit.

<NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.



- With a clean stick R, clean the surrounding area of nozzle surface of print head. Manually move the carriage to such a position that you can perform the cleaning with ease.
 <IMPORTANT>
 - Be sure not to bring the clean stick R into contact with the nozzle surface.
 - The used clean stick R should be disposed of, and should not be reused.



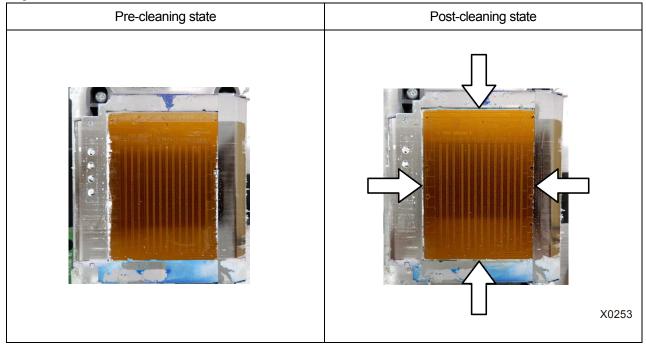
X0293

- (8) Close the front cover, turn on the power.
- (9) From the menu, select [Head Cleaning] > [Powerful Cleaning] > [All Print Heads], and press (NOTE>

Dispose of any waste resulting from the cleaning in accordance with applicable laws and ordinances.
 <TIPS>

- Then, the head cleaning will be performed to prevent any ink from drying up.
- Because the cleaning cup will be reused, rinse it in clean cleaning solution and store it in a safe place.

Cleaning conditions



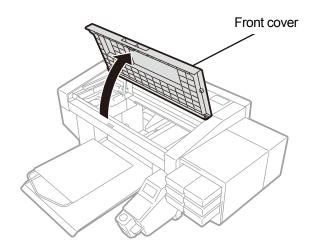
10-2-5. Replacing the color filter

If a number of non-firing color head nozzles is observed after printing, the filter should be replaced. <IMPORTANT>

• When replacing multiple filters, filters for individual colors should be replaced one by one. Replace the filter for the first color and install ink, then replace the next filter. Removing multiple filters at the same time might damage the print head.

<TIPS>

- Ink installation should be performed after replacing the filters. If the ink level is low, make a new ink pouch available for use.
- (1) Prepare the supplied gloves and optional filter.
- (2) From the menu, select [Maintenance] > [Exchange Filter], and press
- (3) From [Black], [Yellow], [Cyan], and [Magenta] select non-firing color and press <TIPS>
 - Pressing (CALC) causes the platen to start moving. Do not put anything around the platen.
- (4) Follow the on-screen message and turn off the power.
- (5) Open the front cover.

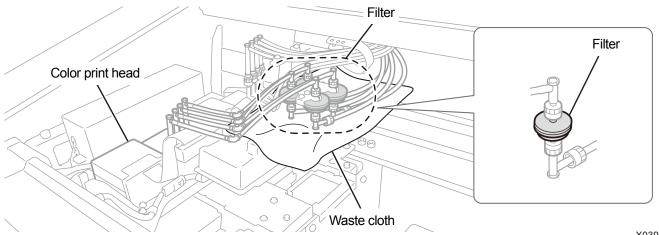


X0331

(6) Lay a waste cloth under the filter to be replaced.

<TIPS>

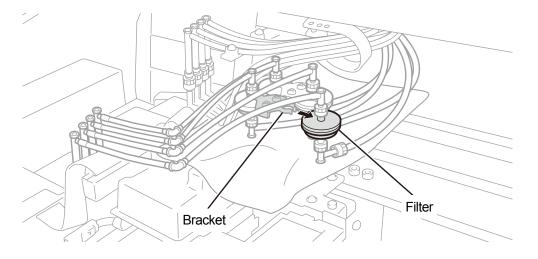
Non-fuzzy, clean cloth should be used.



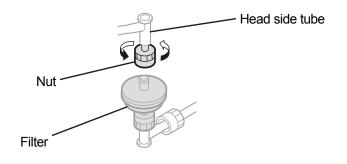
X0397

X0437

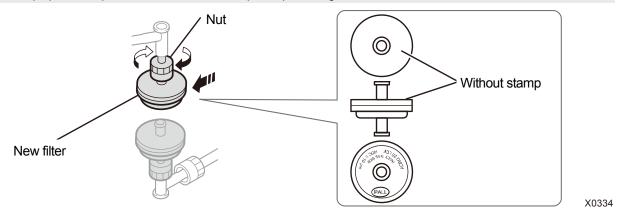
(7) Remove the filter from the bracket.



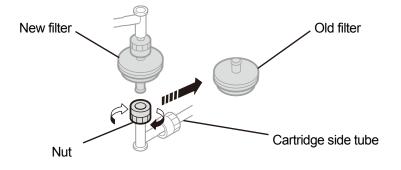
(8) Rotate the nut of the tube on the head side and remove the filter.



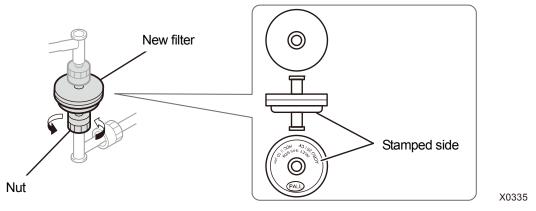
- (9) Place a new filter on the head side tube and fasten the nut. <IMPORTANT>
 - Install the filter with no stamp facing the tube. Pay attention to this installation orientation.
 - <NOTE>
 - For a proper work operation, be sure to wear the printer-provided gloves.



(10) Rotate the nut of the tube on the cartridge side to remove the old filter.



- (11) Attach the cartridge side tube to a new filter and fasten the nut.<IMPORTANT>
 - Make sure to install the filter with the stamped side facing the cartridge side tube.



- (12) Remove the waste cloth from under the filter.
- (13) Close the front cover, turn on the power. <NOTE>
 - Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.
- (14) Perform the [Filter exchange after ink Load] operation by following the on-screen instructions.
 - When replacing multiple filters, go back to the beginning of the procedure to start replacing the next filter.
 - After the procedures are completed, the current screen will go back to the standby mode screen.

10-2-6. Replacement of print head

If a problem of non-ejection of ink-jet droplets is not cleared even after cleaning the head nozzle, replace a print head with a new one.

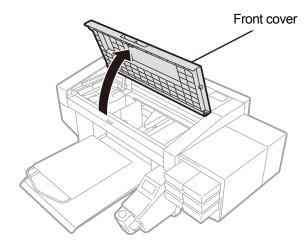
The replacement procedures vary from the color heads to the white heads. According to each of the replacement procedures, replace each print head with a new one separately.

<TIPS>

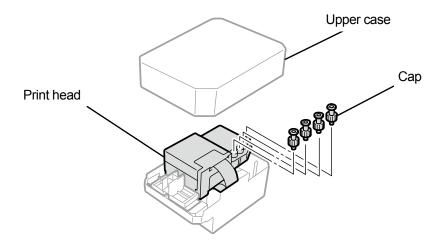
- Do not confuse the color side print head with the white side print head.
 Check the case color (red for the color side, white for the white side) and replace the case.
- Ink needs to be re-installed after replacing the print head. If the ink level is low, make a new ink pouch available for use.

Replacement procedures for print head on the color side

- From the menu, select [Maintenance] > [Head Replacement] > [Color], and press
 <TIPS>
 - Pressing (CAL) causes the platen to start moving. Do not put anything around the platen.
- (2) Follow the on-screen message and turn off the power. <IMPORTANT>
 - Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
- (3) Open the front cover.



- (4) Remove the upper case of a new print head.
- (5) Remove four caps from the new print head.



Troubleshooting (For GTX pro)

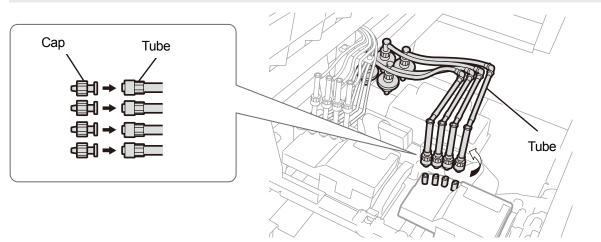
(6) Remove each tube from the print head to be replaced with a new one, then attach each of the new caps which are

removed from a new print head to each tube, while exercising care to prevent any ink from being spilled. </br><IMPORTANT>

- Care is needed in preventing any ink from being spilled from each tube. If the ink is dripping, wipe off the dripping ink.
- Be careful not to confuse it with the tube for the print head on the white side.
- When you replace the print head, be sure to move the carriage manually to the position of platen at the center of the printer before starting the replacement. If you perform the mounting of the head when the carriage is directly above the maintenance unit, it may damage the maintenance unit or the heads.

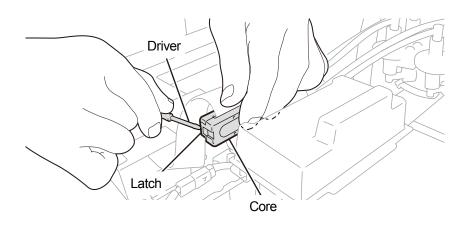
<NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.



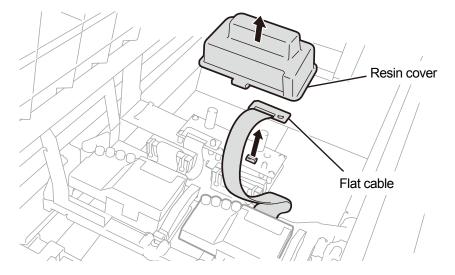
X0398

- (7) Remove the core claw using the supplied screwdriver.<IMPORTANT>
 - Hold the core center by hand to make it easy to insert the screwdriver into the claw.



(8) Remove the resin cover which is placed on the top of the carriage board and remove the flat cable.

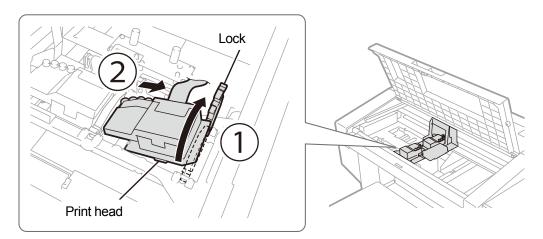
...........



X0400

(9) Unlock the print head, and remove the print head. <IMPORTANT>

 When removing the print head in position, be careful not to drip the ink on the carriage plate. If the ink is dripping, wipe off the dripping ink.

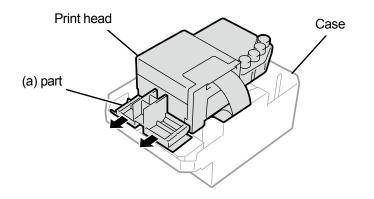


X0401

- (10) Release the lock by pulling (a) part toward yourself, and take out the new print head from its case.
 <IMPORTANT>
 - When removing the print head, be careful not to touch the nozzle surface at the bottom of the head. Otherwise it may cause poor printing.

<TIPS>

• Sometimes, you may find it hard to remove the print head when you try to open the lock of (a) part. If it is hard, use both hands to remove it.



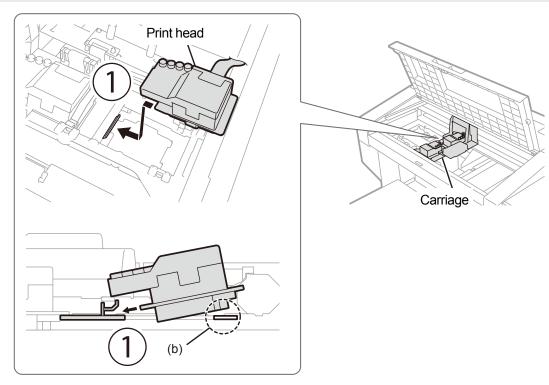
(11) By following the procedures mentioned below, mount a new print head on the carriage.

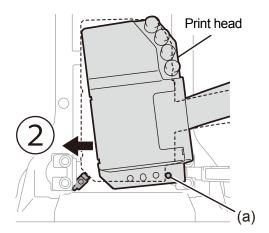
① Insert the rearward end of the print head into the carriage.

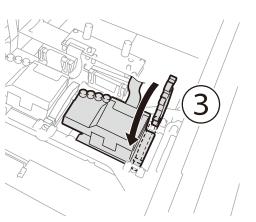
② Push with force in direction ② so that the illustrated part (a) makes contact with the side of the metal plate of the print head.③ Lock the print head in place.

<IMPORTANT>

- Make sure the illustrated (a) part is in contact with the side of the metal plate.
- When placing the print head in position, be careful not to move the carriage as much as possible. Your hand may be caught in the carriage and injured. In addition, the tubes may be rolled together possibly damaging them.
- When you mount ③, push it down from the top. Otherwise, you may get your finger caught in it and get injured.
- <TIPS>
- If the print head is not inserted sufficiently, the part as illustrated in (b) could come into contact with its bottom surface, which in turn may result in poor printing. Please insert the print head as far as it can go.



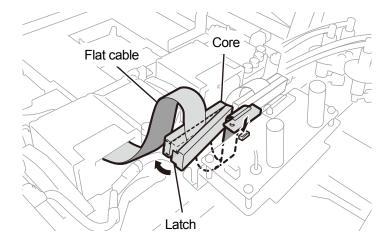




X0403

- (12) Insert the flat cable into the core and connect it to the carriage board.
- (13) Fit the claw by pushing the core until it clicks into place.

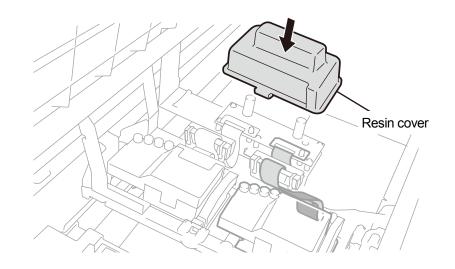
Leave a slack to avoid interference between the flat cable and the resin cover.



X0404

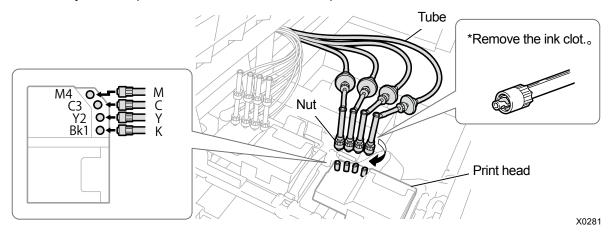
(14) Place the resin cover back onto the carriage board, and engage the two latches properly.

Tuck the extra flat cable as shown in the illustration.



- (15) Remove the cap you connected in step (6) from the tube, and connect the tubes to the print head. <IMPORTANT>
 - To prevent the tubes from being entangled with each other, connect the innermost tube to the print head first, and make a connection of the rest of the tubes.
 - Be sure to connect each tube with its correct position.

(16) Tighten the nut firmly until it stops so that each tube is fixed to the print head.



- (17) Close the front cover, turn on the power.
- (18) From the menu, select [Maintenance] > [Install Ink after Replacing Head] > [Color], and press
 Perform the work operation by following the on-screen instructions.
 <TIPS>
 - After the procedures are completed, the current screen will go back to the standby mode screen.
- (19) Adjust the carriage speed. 7-4-1. CR (Carriage) speed adjustment >>P.230"
- (20) Print the nozzle check patterns. I 17-4-1. CR (Carriage) speed adjustment >>P.230"
- (21) Perform the initial settings after head replacement configuration. ☞ "7-4-2. Initial settings after head replacement >>P.231".
- (22) Adjust the ejection timing of print head. T-4-3. Firing adjustment >> P.232".
- (23) Perform the platen feed adjustment. 7-4-4. Platen-rolling adjustment >>P.233"
- (24) Make the position adjustment between the white head and the color head. (7-4-5. White/color alignment >>P.261

Replacement procedures for print head on the white side (if you use a capping pouch)

<IMPORTANT>

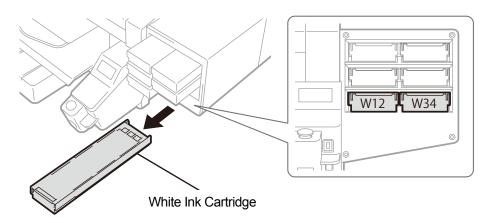
- When you replace a print head on the white side, you can minimize ink consumption by installing a capping pouch (optionally available) in addition to a print head. Instead of the capping pouch, a white ink pouch at its ink depletion level before its expiry date can also be used.
- (1) From the menu, select [Maintenance] > [Head Replacement] > [White], and press



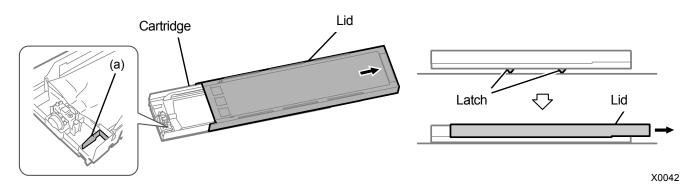
- (2) Make available a capping pouch and select [Yes] in response to the instructions on screen. <IMPORTANT>
 - Instead of the capping pouch, a white ink pouch at its ink depletion level before its expiry date can also be used.
 <TIPS>
 - Perform the work operation by following the on-screen instructions.
 - Pressing (K) causes the platen to start moving. Do not put anything around the platen.
- (3) Remove the white ink cartridge from the printer.

<CAUTION>

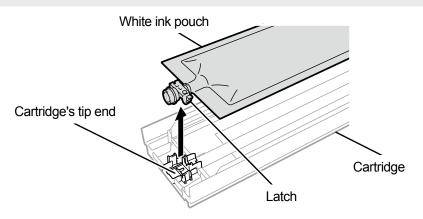
• The bottom of the cartridge may be soiled with ink. Clean the printer on a regular basis.



- (4) Open the cartridge's lid. <IMPORTANT>
 - When opening the lid, be sure not to touch the portion (a). Otherwise, it could be damaged.
 - Place the entire cartridge on a flat surface, push the latches on the bottom surface of the cartridge downward and open the lid.



- (5) Pinch the latch at the front end of ink pouch, and draw out the white ink pouch from the cartridge. <CAUTION>
 - Remove the accumulated ink at the tip of the cartridge with a waste cloth (non-fuzzy cloth). Clean the printer on a regular basis.

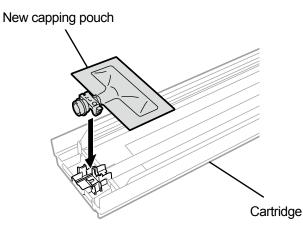


(6) Put the capping pouch in the cartridge.

<TIPS>

- You can use a capping pouch of either the old or new shape.
- < New capping pouch>

Push the tip end of capping pouch into the cartridge until it clicks into place.



X0294

X0119

< Old capping pouch>

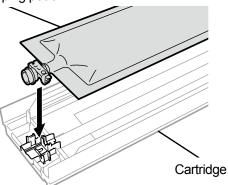
Push the tip end of capping pouch into the cartridge until it clicks into place.

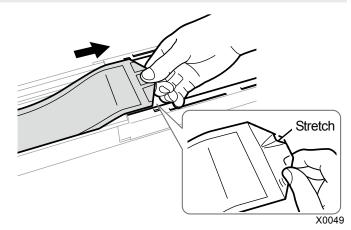
Straighten the capping pouch in such a manner that it will be aligned with the gutter of lid of cartridge, and mount in position by pulling it with your hand.

<NOTE>

If the edge of the ink pouch is bent or undulating significantly, make it straight with your hand.

Old capping pouch





(7) Put the capping pouch in its correct position.

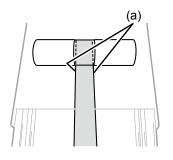
< New capping pouch>

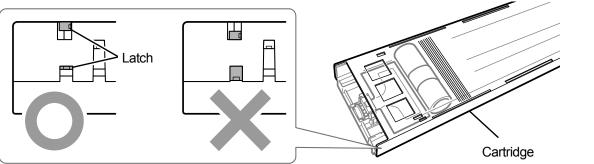
<CAUTION>

• Avoid touching the portion (a) of cartridge. Otherwise, you may cut your hand.

<NOTE>

• After closing the lid, the winding is complete when the latch of the cartridge side is raised.





X0296

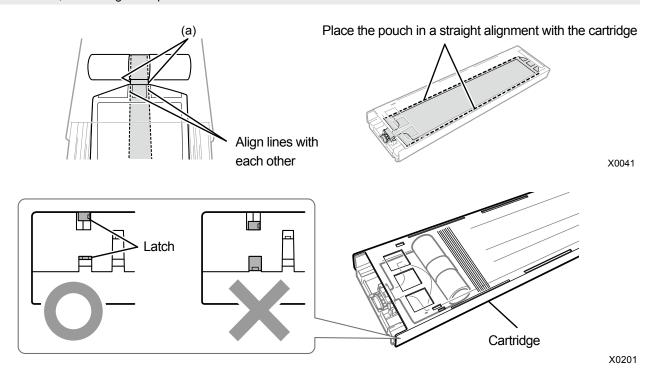
< Old capping pouch>

<CAUTION>

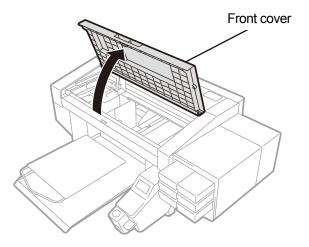
• Avoid touching the portion (a) of cartridge. Otherwise, you may cut your hand.

<NOTE>

- Close the lid while holding the slack of the capping pouch by hand.
- After closing the lid, confirm that the capping pouch has been taken up to the end. When the latch of the cartridge side is raised, the winding is complete.

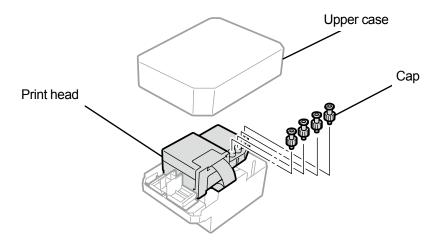


- (8) Close the lid, and put the capping cartridge in position inside the printer.
- (9) Repeat the same process to replace the other white ink cartridge with the capping pouch.
- (10) Follow the on-screen message and turn off the power.<IMPORTANT>
 - Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
- (11) Open the front cover.



(12) Remove the upper case of a new print head.

(13) Remove four caps from the new print head.

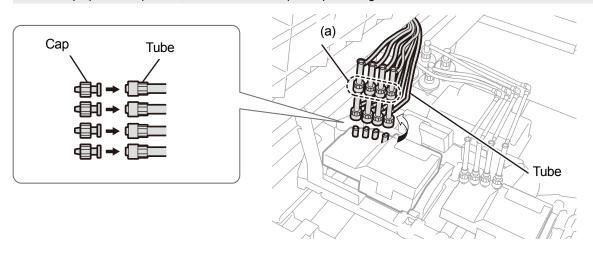


X0068

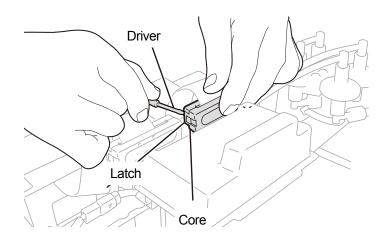
(14) Remove each tube from the print head to be replaced with a new one, then attach each of the new caps which are

removed from a new print head to each tube, while exercising care to prevent any ink from being spilled. </br><IMPORTANT>

- Care is needed in preventing any ink from being spilled from each tube. If the ink is dripping, wipe off the dripping ink.
- Be careful not to confuse it with the tube for the print head on the color side.
- Be sure not to tighten the nut for part (a) by mistake. It could remove the tube and leak the contained ink.
- When you replace the print head, be sure to move the carriage manually to the position of the platen at the center of the printer before starting the replacement. If you perform the mounting of the head when the carriage is directly above the maintenance unit, it may damage the maintenance unit or the heads.
 <NOTE>
- For a proper work operation, be sure to wear the printer-provided gloves.

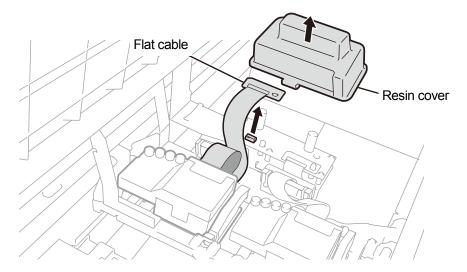


- (15) Remove the core claw using the supplied screwdriver.
 - <TIPS>
 - Hold the core center by hand to make it easy to insert the screwdriver into the claw.



X0408

(16) Remove the resin cover which is placed on the top of the carriage board and remove the flat cable.

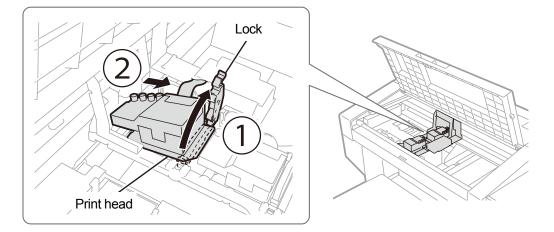


X0409

(17) Unlock the print head, and remove the print head.

<IMPORTANT>

• When removing the print head, be careful not to drip the ink on the carriage plate. If the ink is dripping, wipe off the dripping ink.

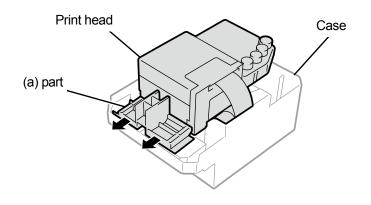


(18) Release the lock by pulling (a) part toward yourself, and take out the new print head from its case.
 <IMPORTANT>

• When removing the print head, be careful not to touch the nozzle surface at the bottom of the head. Otherwise it may cause poor printing.

<TIPS>

• Sometimes, you may find it hard to remove the print head when you try to open the lock of (a) part. If it is hard, use both hands to remove it.



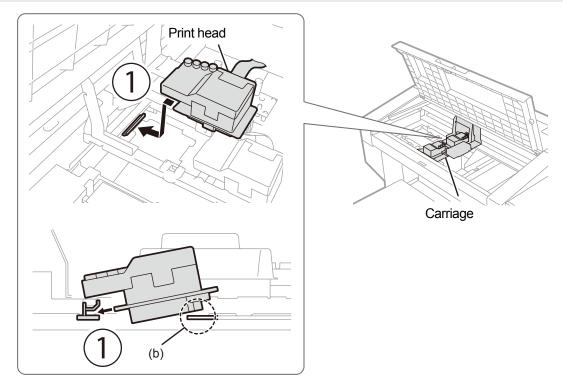
(19) By following the procedures mentioned below, mount a new print head on the carriage.

① Insert the rearward end of print head into the carriage.

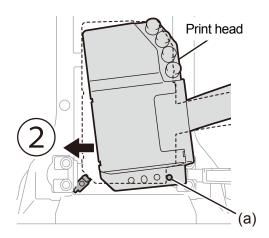
② Push with force in direction ② so that the illustrated part (a) makes contact with the side of the metal plate of the print head.③ Lock the print head in place.

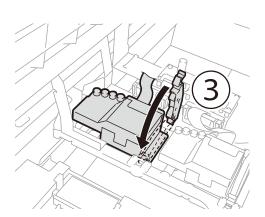
<IMPORTANT>

- Make sure the illustrated (a) part is in contact with the side of the metal plate.
- When placing the print head in position, be careful not to move the carriage as much as possible. Your hand may be caught in the carriage and injured. In addition, the tubes may be rolled together possibly damaging them.
- When you mount ③, push it down from the top. Otherwise, you may get your finger caught in it and get injured.
- <TIPS>
- If the print head is not inserted sufficiently, the part as illustrated in (b) could come into contact with its bottom surface, which in turn may result in poor printing. Please insert the print head as far as it can go.



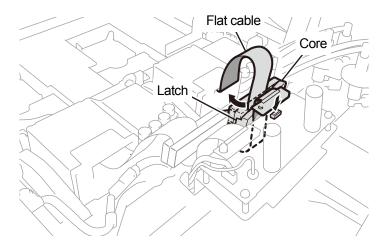






- (20) Insert the flat cable into the core and connect it to the carriage board.
- (21) Fit the claw by pushing the core until it clicks into place.

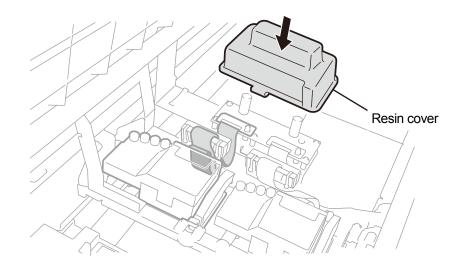
Leave a slack to avoid interference between the flat cable and the resin cover.



X0413

(22) Place the resin cover back onto the carriage board, and engage the two latches properly.

Tuck the extra flat cable as shown in the illustration.

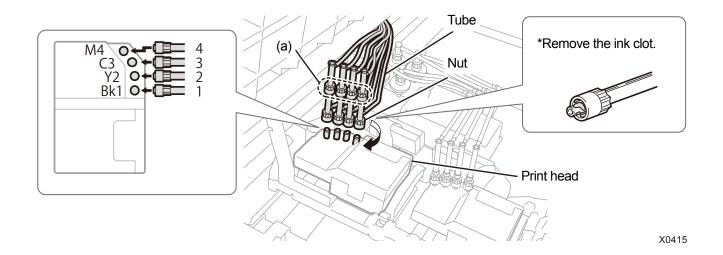


(23) Remove every cap from each tube, and connect the tubes to the print head.

- <IMPORTANT>
- To prevent the tubes from being entangled with each other, connect the innermost tube to the print head first, and make the connection of the rest of the tubes.
- Check the stamp on the print head and connect them taking care not to confuse their positions. Incorrectly connecting them may cause the ink to leak during the circulation.
- (24) Tighten the nut firmly until it stops so that each tube is fixed to the print head.

<IMPORTANT>

• Be sure not to tighten the nut for part (a) by mistake.

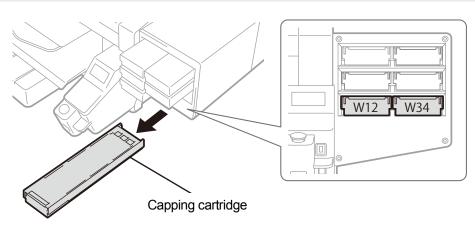


- (25) Close the front cover, turn on the power.
- (26) From the menu, select [Maintenance] > [Install Ink after Replacing Head] > [White], and press

Perform the work operation by following the on-screen instructions.

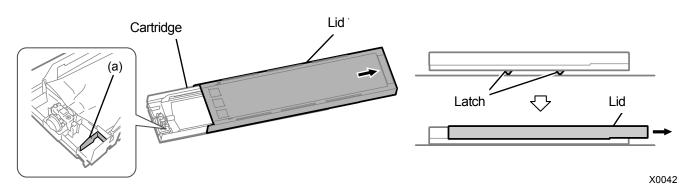
<TIPS>

- When the white ink pouch runs low on its remaining volume of white ink, the Install Ink after Replacing Head function can no longer get started. Furthermore, there may be cases where the pouch needs to be replaced with a new one during the installation process of white ink. If the remaining volume is 400 g (14.1 oz) or less, prepare a new white ink pouch, follow the instructions on the screen to replace the pouch, and activate the mode again.
- (27) Take out the capping cartridge from the printer.
 - <CAUTION>
 - The bottom of the cartridge may be soiled with ink. Clean the printer on a regular basis.



(28) Open the cartridge's lid.

- <IMPORTANT>
- When opening the lid, be sure not to touch portion (a). Otherwise, it could be damaged.
- Place the entire cartridge on a flat surface, push the latches on the bottom surface of the cartridge downward and open the lid.



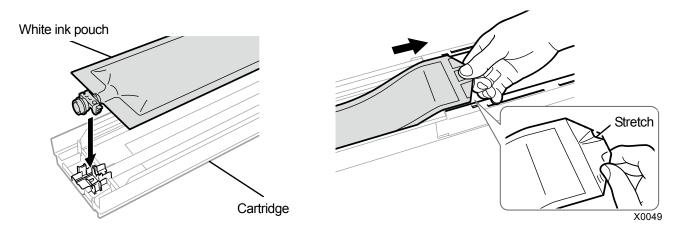
(29) Take out the capping pouch from the cartridge, and put the white ink pouch in place.

Push the tip end of the ink pouch into the cartridge until it clicks into place.

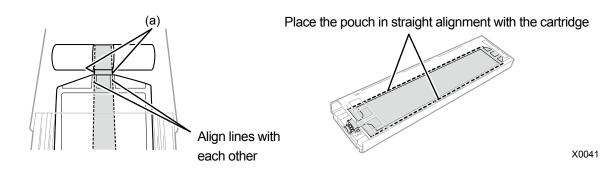
Straighten the ink pouch in such a manner that it will be aligned with the gutter of the lid of cartridge, and mount in position by pulling it with your hand.

<NOTE>

• If the edge of the ink pouch is bent or undulating significantly, make it straight with your hand.



- (30) Put the white ink pouch in its correct position and close the lid. <CAUTION>
 - Avoid touching portion (a) of the cartridge. Otherwise, you may cut your hand.



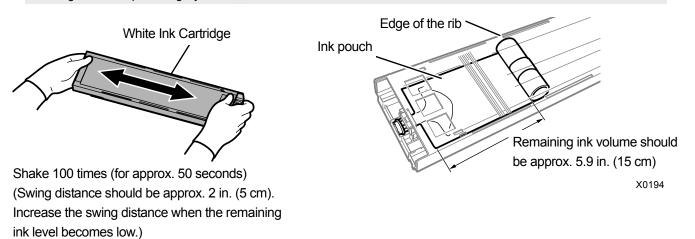
(31) Shake the cartridge 100 times side to side to stir the ink.

<IMPORTANT>

- The white ink cartridge should be held horizontally when shaking it.
- Holding the white ink cartridge upside down or shaking it too roughly could break the ink pouch.

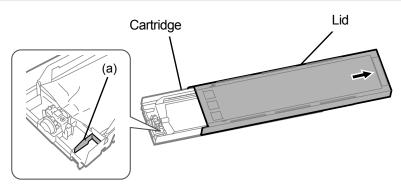
<NOTE>

- Wear the provided gloves when performing this task.
- When the remaining ink level becomes approximately 5.9 in. (15 cm), shake the cartridge with its cover open and with the edge of the ink pouch slightly winded, to make the ink easier to stir.



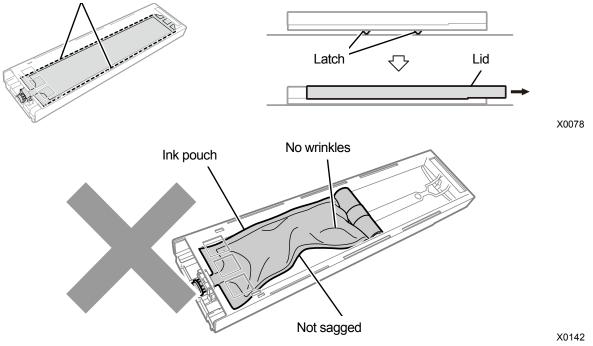
(32) Open the lid of the cartridge and place the ink pouch in its correct position.

- <IMPORTANT>
- Always open the cartridge lid and properly rewind the ink pouch. If the pouch is placed without opening the lid, ink can flow into the wound section of the pouch when stirred, and cause improper winding of the pouch.
- When opening the lid, place the entire cartridge on a flat surface, push the latches on the bottom surface of the cartridge downward and open the lid.
- When setting the ink pouch, avoid unevenness or wrinkles on the pouch.
- When opening the lid, be sure not to touch the portion (a). Otherwise, it could be damaged.
- <NOTE>
- If the remaining ink level is low, hold the sagged part of the ink pouch and close the lid.



X0182

Place the pouch in straight alignment with the cartridge



(33) Close the lid, and put the white ink cartridge in position inside the printer.

<IMPORTANT>

- W12 and W34 cartridges should correctly be placed at their original locations. Wrongly placed cartridges could cause a
 printer malfunction.
- (34) Repeat the same process to replace the other capping cartridge with the white ink pouch.
- (35) On the operation panel, press

Then, the white ink will be installed after the head is replaced with a new one.

<TIPS>

- After the procedures are completed, the current screen will go back to the standby mode screen.
- (36) Adjust the carriage speed. 7-4-1. CR (Carriage) speed adjustment >>P.230"
- (37) Print the nozzle check patterns. I 17-4-1. CR (Carriage) speed adjustment >>P.230"
- (38) Perform the initial settings after head replacement configuration. ☞ "7-4-2. Initial settings after head replacement >>P.231"
- (39) Adjust the ejection timing of the print head. T-4-3. Firing adjustment >>P.232".
- (40) Perform the platen feed adjustment. 7-4-4. Platen-rolling adjustment >> P.233".
- (41) Make the position adjustment between the white head and the color head. (7-4-5. White/color alignment >>P.234"

Replacement procedures for print head on the white side (if you do not use a capping pouch)

<IMPORTANT>

- When you replace a print head on the white side, you can minimize ink consumption by installing a capping pouch (optionally available) in addition to a print head. Instead of the capping pouch, a white ink pouch at its ink depletion level before its expiry date can also be used.
- (1) From the menu, select [Maintenance] > [Head Replacement] > [White], and press



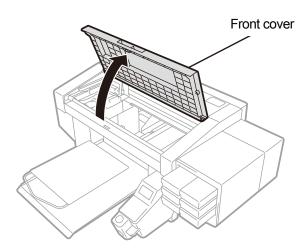
(2) Select [No] in response to the instructions on screen.

<TIPS>

- Perform the work operation by following the on-screen instructions.
- Pressing Causes the platen to start moving. Do not put anything around the platen.
- (3) Follow the on-screen message and turn off the power.

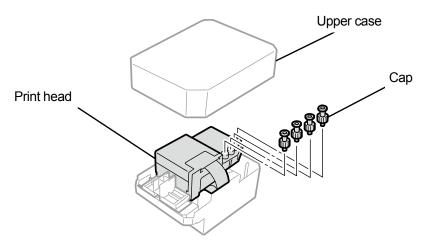
<IMPORTANT>

- Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
- (4) Open the front cover.



X0331

- (5) Remove the upper case of a new print head.
- (6) Remove four caps from the new print head.



Troubleshooting (For GTX pro)

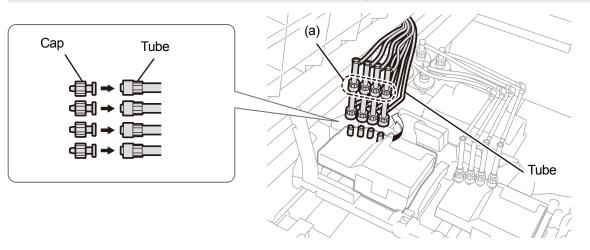
(7) Remove each tube from the print head to be replaced with a new one, then attach each of the new caps which are

removed from a new print head to each tube, while exercising care to prevent any ink from being spilled. </br><IMPORTANT>

- Care is needed in preventing any ink from being spilled from each tube. If the ink is dripping, wipe off the dripping ink.
- Be careful not to confuse it with the tube for the print head on the color side.
- Be sure not to tighten the nut for part (a) by mistake. It could remove the tube and leak the contained ink.
- When you replace the print head, be sure to move the carriage manually to the position of the platen at the center of the printer before starting the replacement. If you perform the mounting of the head when the carriage is directly above the maintenance unit, it may damage the maintenance unit or the heads.

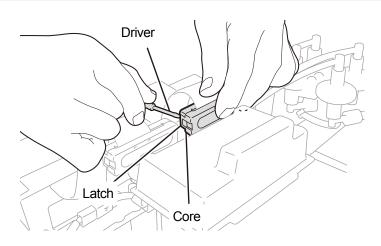
<NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.

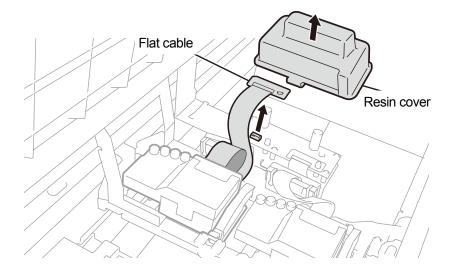


X0407

- (8) Remove the core claw using the supplied screwdriver.
 <TIPS>
 - Hold the core center by hand to make it easy to insert the screwdriver into the claw.



(9) Remove the resin cover which is placed on the top of the carriage board and remove the flat cable.

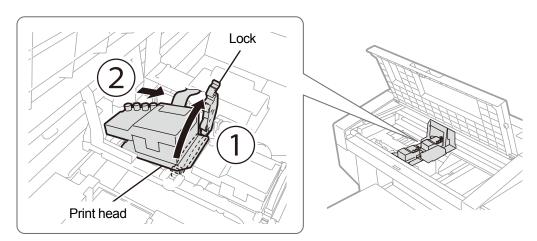


X0409

(10) Unlock the print head, and remove the print head.

<IMPORTANT>

When removing the print head, be careful not to drip the ink on the carriage plate. If the ink is dripping, wipe off the dripping ink.

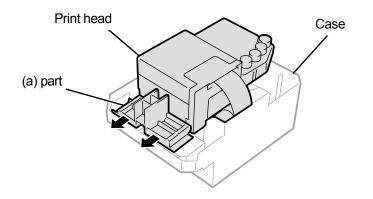


X0410

- (11) Release the lock by pulling (a) part toward yourself, and take out the new print head from its case.
 <IMPORTANT>
 - When removing the print head, be careful not to touch the nozzle surface at the bottom of the head. Otherwise it may cause poor printing.

<TIPS>

• Sometimes, you may find it hard to remove the print head when you try to open the lock of (a) part. If it is hard, use both hands to remove it.



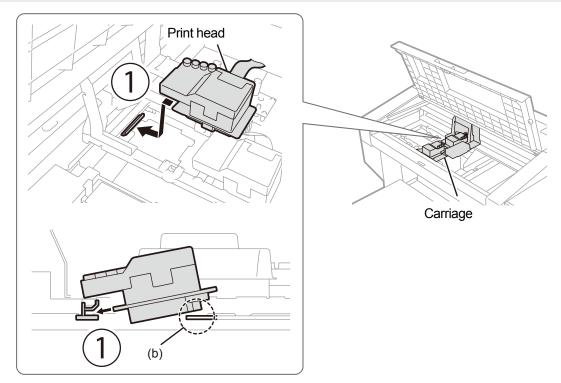
(12) By following the procedures mentioned below, mount a new print head on the carriage.

① Insert the rearward end of print head into the carriage.

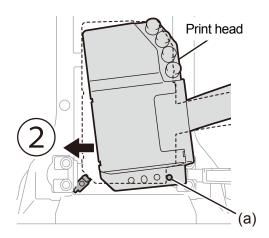
② Push with force in direction ② so that the illustrated part (a) makes contact with the side of the metal plate of the print head.③ Lock the print head in place.

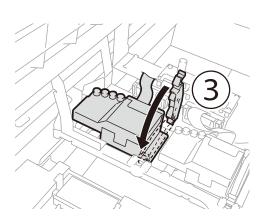
<IMPORTANT>

- Make sure the illustrated (a) part is in contact with the side of the metal plate.
- When placing the print head in position, be careful not to move the carriage as much as possible. Your hand may be caught in the carriage and injured. In addition, the tubes may be rolled together possibly damaging them.
- When you mount ③, push it down from the top. Otherwise, you may get your finger caught in it and get injured.
- <TIPS>
- If the print head is not inserted sufficiently, the part as illustrated in (b) could come into contact with its bottom surface, which in turn may result in poor printing. Please insert the print head as far as it can go.



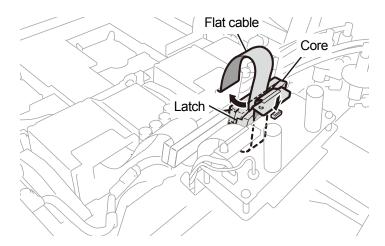






- (13) Insert the flat cable into the core and connect it to the carriage board.
- (14) Fit the claw by pushing the core until it clicks into place.

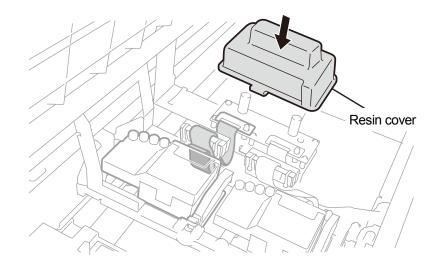
Leave a slack to avoid interference between the flat cable and the resin cover.



X0413

(15) Place the resin cover back onto the carriage board, and engage the two latches properly.

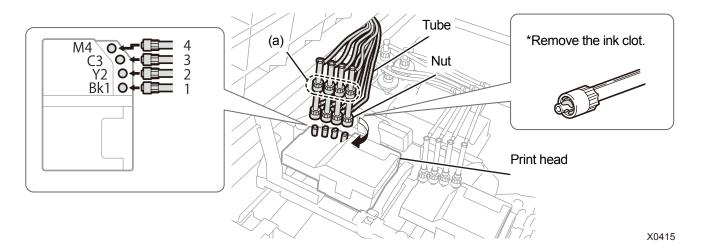
Tuck the extra flat cable as shown in the illustration.



- (16) Remove every cap from each tube, and connect the tubes to the print head.<IMPORTANT>
 - To prevent the tubes from being entangled with each other, connect the innermost tube to the print head first, and make the connection of the rest of the tubes.
 - Check the stamp on the print head and connect them taking care not to confuse their positions. Incorrectly connecting them
 may cause the ink to leak during the circulation.

(17) Tighten the nut firmly until it stops so that each tube is fixed to the print head.

- <IMPORTANT>
- Be sure not to tighten the nut for part (a) by mistake.



- (18) Close the front cover, turn on the power.
- (19) From the menu, select [Maintenance] > [Install Ink after Replacing Head] > [White], and press



- When the white ink pouch runs low on its remaining volume of white ink, the Install Ink after Replacing Head function can no longer get started. Furthermore, there may be cases where the pouch needs to be replaced with a new one during the installation process of white ink. If the remaining volume is 400 g (14.1 oz) or less, prepare a new white ink pouch, follow the instructions on the screen to replace the pouch, and activate the mode again.
- (20) On the operation panel, press

Then, the white ink will be installed after the head is replaced with a new one.

<TIPS>

<TIPS>

- After the procedures are completed, the current screen will go back to the standby mode screen.
- (21) Adjust the carriage speed. "7-4-1. CR (Carriage) speed adjustment >>P.230"
- (22) Print the nozzle check patterns. I 17-4-1. CR (Carriage) speed adjustment >>P.230"
- (23) Perform the initial settings after head replacement configuration. ☞ "7-4-2. Initial settings after head replacement >>P.231"
- (24) Adjust the ejection timing of the print head. "7-4-3. Firing adjustment >>P.232"
- (25) Perform the platen feed adjustment. 7-4-4. Platen-rolling adjustment >>P.233"
- (26) Make the position adjustment between the white head and the color head. "7-4-5. White/color alignment >>P.234"

10-2-7. Replacing the Wiper

Replace the wiper with a new one if it is damaged or deformed.

- (1) Have the supplied gloves and wiper ready.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press

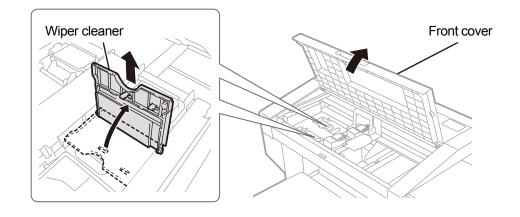


<IMPORTANT>

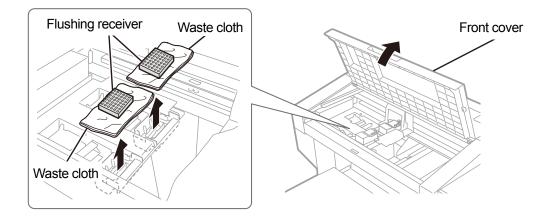
 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing causes the platen to start moving. Do not put anything around the platen.
- (3) Follow the on-screen message and turn off the power. <IMPORTANT>
 - Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
 - If the task takes more than 15 minutes to complete, after attaching the flushing receiver, wiper cleaner, and wiper, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (4) Open the front cover.
- (5) Raise the wiper cleaner and move it to its upright position, and remove it by moving it upward.
 <IMPORTANT>
 - Removed wiper cleaner should be placed with the cleaner side facing up.
 <NOTE>
 - For a proper work operation, be sure to wear the printer-provided gloves.

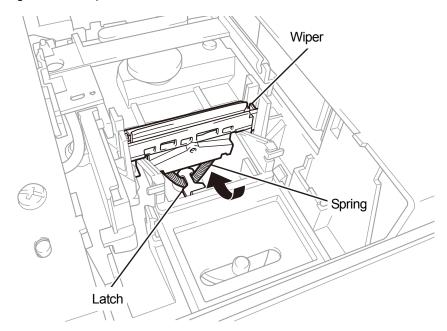


- (6) Remove the flushing receiver from the maintenance unit. <IMPORTANT>
 - Ink droplets will drop off from the hole on the bottom of flushing receiver. Press a waste cloth against the bottom surface, and lift the flushing receiver vertically to remove it.

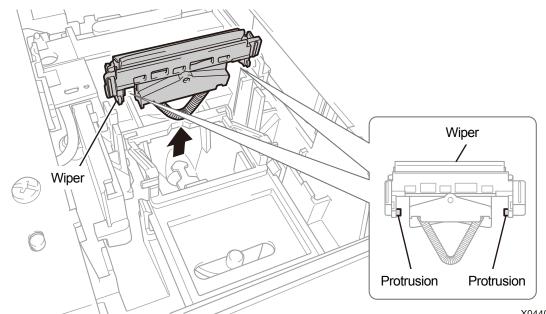


X0327

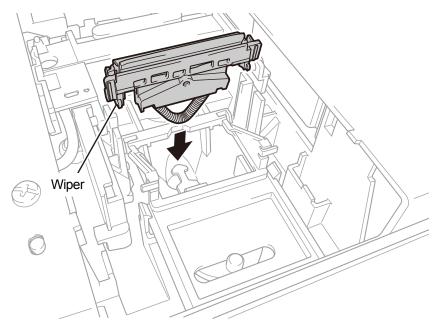
(7) Remove the spring under the wiper from the maintenance unit latch.



- (8) Remove the wiper from the maintenance unit.<IMPORTANT>
 - There are two protruded parts underneath. Thoroughly remove the wiper not to damage these parts.

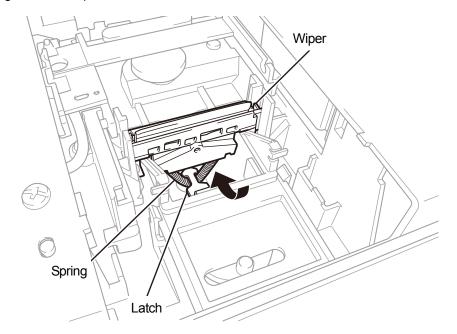


(9) Insert a new wiper into the printer from above.



X0440

(10) Place the spring under the wiper on the maintenance unit latch.

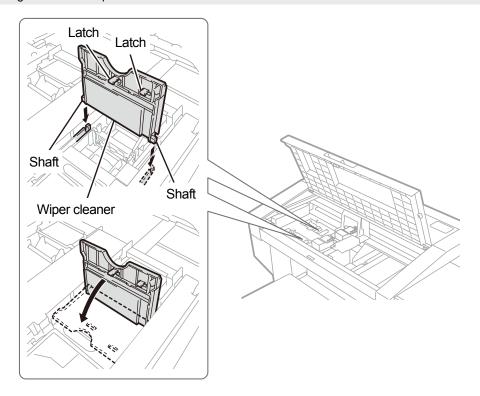


X0442

(11) Insert a wiper cleaner into the printer from above, tip it leftward and put it in place.

<TIPS>

- During this process, it is recommended to also replace the wiper cleaner with a new one.
- First, insert the shaft from above. Then fold it to the left, press the area with the PUSH indication until a clicking sound is heard, and get the latch into position.



(12) Mount the flushing receiver back to its original place in the maintenance unit.

- <TIPS>
- Direct its orientation with a hole on the bottom to the front.

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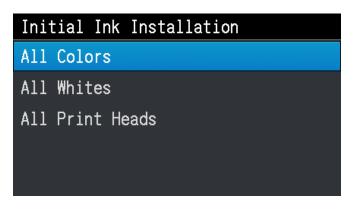
- (13) Close the front cover.
- (14) Turn on the power.
 - <NOTE>
 - Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.
 - <TIPS>
 - Then, the head cleaning will be performed to prevent any ink from drying up.

Re-install the ink 10-2-8.

Ink should be re-installed when an entrance of air into the print head or tube prevents proper ink-jet operation and remedial measure cannot improve the condition.

(1) While the printer is in standby mode, press (Menu) on the operation panel to bring the menu screen into view.

- (2) Press \blacktriangle / \bigtriangledown , select [Maintenance] > [Initial Ink Installation], and press (
- (3) Press ▲ / ▼ to select one of the options; [All Colors], [All Whites], or [All Print Heads], and press OK



- (4) According to the message displayed on the operation panel, press Initial ink installation will be operated. <TIPS>
 - Estimated time to finish is 30 minutes for [All Whites] and 15 minutes for [All Colors], which, however, may fluctuate depending on the temperature environment and printer status. After the procedures are completed, the current screen will go back to the standby mode screen.

10-3. Acquisition of log file

In cases where the printer malfunctions, you may be required by our service personnel to obtain your printer's log file. For this reason, please save your printer's log file to a file. <TIPS>

• To the resultant file, such filename (.log) that automatically identifies your printer will be given.

Fetch a log file from USB flash memory

- (1) Insert a USB flash memory into the insertion slot of the printer.
- (2) Press (C) on the operation panel located on the left side of printer to go to the menu.
- (3) Press \blacktriangle / \bigtriangledown , select [Maintenance] > [Log copy to USB], and press



(4) Then, the print button stops blinking, and the log file writing operation will be completed when you hear the sound of pong.

<IMPORTANT>

- Never remove the USB flash memory from the printer when the print button is blinking. Otherwise, the USB flash memory
 may be damaged, rendering its internal data to be unreadable.
- (5) Obtain the log file saved to the USB flash memory, and send such file to our service personnel.

Fetch a log file via USB/LAN connection

(1) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" from "Brother GTX pro Tools".

(2) After the window shown below appears, select the [Log Data Retrieval] and click [Next].

W Brother GTX pro Maintenance	×
Confirm the printer is turned ON and connected to your PC. Select the printer.	
Brother GTX pro V Search	
Select an item from the menu below and click "Next".	
 Initial settings after head replacement Perform this setting when replacing the head or when setting up the printer only. 	
Firing Adjustment Adjust this setting when the edges of the print look vague, solid areas are not even, or after a Print Head is replaced.	,
 Platen-rolling adjustment Make adjustments when horizontal stripes (banding) occur in the printed image. Use this adjustment as a troubleshooting method when other items such as proper temperature and humidity have already been verified. White/Color Alignment Adjust when white print does not align with color print. 	
O Set an IP Adrress Assign a static IP address to the printer.	
Dog Data Retrieval Execute if there was a request after troubleshooting service.	
Setting of the time displayed on the nozzle check pattern This is not necessary if you have configured the scheduled time for white ink circulation.	
 Set the scheduled time for white ink circulation Configure this setting to set or cancel the scheduled time for white ink circulation. 	
< Back Next > Close	

(3) Perform the required operation by following the on-screen instructions in the dialog box.

	Ensure there is adequate space left in front of the printer and avoid placing any objects. Otherwise your hand may get caught between the platen and an object, which may result in injury.
\otimes	Do not handle the platen while printing. If your hand gets caught between the platen or the T-shirt tray and the covers, it may be injured.
	Do not put your hands inside the covers while the printer's power is turned on. Otherwise your hands may touch against moving parts and this may result in injury.
	Be careful not to get your fingers caught when closing the front cover, otherwise it may result in injury to your fingers.
\bigcirc	When you mount or replace the head, be careful not to get your hands or fingers caught. Otherwise you may be injured.
\bigotimes	Do not drink liquids such as the ink, maintenance solution, cleaning solution, pretreatment, or waste. They may cause diarrhea or vomiting. Avoid causing your eyes or skin to make contact with the ink, maintenance solution, cleaning solution, pretreatment or waste. It may cause inflammation. In case of contact with eyes, do not rub but immediately rinse the eyes with water. Keep the liquids out of the reach of children.
0	Be sure to wear protective goggles and gloves when handling the grease, so that it does not get into your eyes or onto your skin. It can cause inflammation. Do not drink or eat the grease. It may cause diarrhea or vomiting. Keep the liquids out of the reach of children.
0	When replacing parts and installing optional accessories, be sure to use only genuine Brother parts. Brother will not be held responsible for any accidents or problems resulting from the use of non-genuine parts.
9	When replacing parts or installing optional accessories, be sure to follow the procedures described in the Instruction Manual. Incorrect procedures could cause injuries or problems.

((!))IMPORTANT

Do not move the platen by hand. Otherwise the printer may be mechanically and electrically damaged.

11-1. Troubleshooting instructions

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With reference to the descriptions below, troubleshoot your problem.

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No print data can be sent from PC

Probable Cause	Remedy	Reference
Have you selected an incorrect	From the menu for printing, check your printer name.	
printer or not?		-
Has a USB or LAN cable been	Ascertain that connection of the USB 2.0 cable or the	
connected properly?	LAN cable has been made correctly.	-
Are you using such PC or OS that	Check your PC's operating environment.	"13-2. Software >>P.475"
is outside the specification?		
Are you using such a USB 2.0	Use a 2.0 cable that is compliant with the	"1-3. Other items you
cable that is outside the	specification.	must make available for
specification?		use >>P.28"
Has any noise been produced	Remove the USB 2.0 cable/LAN cable first, then	
between the printer and your PC?	make a connection of it once again in five seconds. If	
	the problem continues, power off the printer first, then	
	reactivate it in five seconds.	
Does your PC function properly?	Restart the PC.	-
Has any other USB device been	Remove the other USB device, restart the PC, and	
connected to your PC?	check to see if the printer functions properly.	_
Has the USB cable/LAN cable	Use a different USB or LAN cable.	_
been damaged?		

No printing job gets started even after pressing the print button

Probable Cause	Remedy	Reference
Is the print scheduled (is the button	The print begins as soon as the printer becomes	
flashing fast)?	available. Wait for a while.	-
Is any error message displayed?	Eliminate the cause of the error, and perform printing	"12. Error message
	once more	>>P.423"
Does the menu screen still appear	Please exit the menu. Alternatively, please wait until	
on the screen, or are you	the maintenance operation will come to an end.	
performing the maintenance		-
operation from the menu?		
Is the automatic head cleaning	Please wait until the ongoing head cleaning	
operation underway?	operation is completed.	-
Is the printer in the white ink	Please wait until the ongoing white ink circulation is	
circulation stage?	completed.	-
Is the room temperature suited to	Check for your PC's operating environment and	"13-1. Apparatus >>P.473"
the usage conditions?	adjust the room temperature.	
Does the printer receive no print	Send the print data to the printer. Alternatively, please	
data, or is it in the state to receive	wait until the reception of print data is completed.	
such data (the print button is not		-
illuminating)?		
Do you find that the temperature of	There may be the possibility that the flat cables of	
print heads is	print heads have not been put in place and the	
becoming high, and [Color Head	temperature of print heads has become high.	-
Getting Warm] or [W Head Temp	Turn off the power, make sure that the flat cable is in	
Rising] message appears?	place, and wait until the temperature decreases.	

The power cannot be turned on

Probable Cause	Remedy	Reference
Is the power cord connected to the printer?	Make sure that the power cord is connected to the printer.	-
Is the front cover closed firmly?	Close the front cover properly.	-

An error occurs immediately after activating the printer

Probable Cause	Remedy	Reference
Is any error message displayed?	Check the content of the error, and restart the printer.	"12. Error message
	If the error is still not eliminated, please contact your	>>P.423"
	dealer or Brother.	

No print data can be loaded from USB flash memory

Probable Cause	Remedy	Reference
Has the USB flash memory been	Insert the USB flash memory into the insertion slot	
inserted into its insertion slot	firmly.	-
properly?		
Is the applicable file ARP or AR3	This printer cannot print out the print data of	
file?	GT-541/GT-782/GT-3. Recreate the print data.	-
Is your USB flash memory suited	Please use a FAT32-formatted USB flash memory of	
to required conditions?	which storage capacity ranges from 2 GB to 32 GB.	
	You cannot use a USB memory with security functions	-
	such as password lock or beyond 32 GB.	
Has your USB flash memory	Check to see if it functions properly using your PC or	
been broken?	the like.	-

Neither uni-directional printing nor bi-directional printing can be performed

Probable Cause	Remedy	Reference
Do the settings of printer driver	Note that the setting of the printer's setting has priority	"9-1. Setting the print
and printer agree with each	over the setting of printer driver. The printer driver's	direction >>P.297"
other?	setup value takes effect only if the printer's setting is	
	[Auto].	

The depletion of ink in an ink tank cannot be detected

Probable Cause	Remedy	Reference
Check if the remaining ink level	Perform the remaining ink level correction again.	"8-1-9. Correcting the
correction was skipped or an		remaining ink level
incorrect value was entered for		>>P.274"
the correction.		

"x" is displayed for the remaining ink level after replenishing ink.

Probable Cause	Remedy	Reference
Is ink of a wrong color	Replenish the right ink. If ink colors are mixed in the	
replenished?	ink tank as the result of replenishing ink of a wrong	-
	color, contact your dealer.	

Remaining volume indication of the ink tank does not reflect the actual status

Probable Cause	Remedy	Reference
Check if the remaining ink level correction was skipped or an incorrect value was entered for the correction.	Perform the remaining ink level correction again.	"8-1-9. Correcting the remaining ink level >>P.274"

You have replenished cleaning solution but it is still reported as empty.

Probable Cause	Remedy	Reference
After replenishing cleaning	Perform [Replenishment of cleaning solution] from the	
solution, did you select	menu.	
[Replenishment of cleaning		-
solution] from the menu?		

11-2. Solutions to print quality problems

With reference to the descriptions below, troubleshoot your problem.

Print is too light

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Probable Cause	Remedy	Reference
Is the setting of an image editing	Edit the image.	"5-3. Using other
software application made		applications >>P.82"
improperly, or is an image placed		
in CMYK mode?		
Have the printing conditions been applied improperly, or does your image data have insufficient color saturation?	Using [Color Processing], adjust saturation or contrast as appropriate.	"5-4-9. Set up the image quality >>P.115"
Is there any nozzle that does not eject ink-jet droplets?	Perform [Head Cleaning] from the menu. If no improvement is attained, follow the referenced instructions.	"11-2-1. Recovery action to be taken for such a nozzle that is unable to eject ink-jet droplets >>P.389"
Is initial settings after head replacement configured?	With reference to, configure the initial settings after head replacement.	"8-3-2. Initial settings after head replacement >>P.286"
Isn't the [Low Temperature Mode] set to [Disable]?	Change the setting to [Enable (Normal)].	"9-11. Print Operation Settings Under Low Temperature >>P.302"

Horizontal stripe (banding) is found on printed material

Probable Cause	Remedy	Reference
Is there any nozzle that does not	Perform [Head Cleaning] from the menu.	"11-2-1. Recovery action
eject ink-jet droplets?	If no improvement is attained, follow the referenced	to be taken for such a
	instructions.	nozzle that is unable to
		eject ink-jet droplets
		>>P.389"
Do you print ink dots on a highly	Set the print head's print direction to [Always	"9-1. Setting the print
water-absorbing print medium?	Uni-Directional].	direction >>P.297"
	Also, combine the color multiple pass printing with	"5-4-6. Specify whether or
	the printing.	not to perform Multiple
		Pass Printing >>P.110"
Is the platen positioned at too low	Adjust the height of the platen corresponding to the	"6-5. Placing print medium
level?	print medium before using it. You can use the platen	in position >>P.162"
	height adjustment lever to adjust the height of platen.	
	As a rough indication, adjust the height so that it is	
	lowered by one step from the limit height detected by	
	the obstacle sensor, and check that the platen is not	
	detected by the sensor.	
Is the firing timing well-timed?	Adjust the ejection timing again. It is likely that the	"8-3-3. Firing adjustment
	setup value is incorrectly set after replacing a print	>>P.287"
	head or the platen with a new one, or after adjusting	
	the platen height.	

Probable Cause	Remedy	Reference
Is platen feed adjusted?	Perform the platen feed adjustment. It is likely that	"8-3-4. Platen-rolling
	the setup value is incorrectly set after replacing a	adjustment >>P.288"
	print head or the platen with a new one.	
Is the [White High Speed Print]	Turn off the [White High Speed Print] check box to	"5-4-4. Set up the white
check box of the print data turned	create the print data.	ink >>P.106"
on?		
Isn't the temperature low?	Change the wiping frequency setting.	"9-15. Wiping frequency
		settings >>P.305"
Isn't the [Low Temperature Mode]	Change the setting to [Enable (Normal)].	"9-11. Print Operation
set to [Disable]?		Settings Under Low
		Temperature >>P.302"

Blurring is observed (when printed with [Color Ink Only])

Probable Cause	Remedy	Reference
Isn't the amount of ink excessive	Print the ink volume and check the blurring, and select	"5-5-5. Adjust the ink
against the print media?	appropriate set value for [Ink Volume:].	volume >>P.121"
		"5-4-7. Set up the color ink
		>>P.111"

Blurring is observed (when printed with [Color+White Ink])

Probable Cause	Remedy	Referenc	e
Is the [Highlight:] of [White Ink	Print the highlight check pattern to check the blurring,	"5-5-6. Print	out of
Settings:] too high?	and select appropriate set value for [Highlight:].	highlight	check
		pattern/mask	check
		pattern >>P.122"	
		"5-4-4. Set up 1	the white
		ink >>P.106"	
	By turning ON the [White/Color Pause] or [Color	"5-4-8. Set up 1	the white
	Multiple Pass Printing] checkbox, extend time before	ink >>P.112"	
	the color ink settles onto the white ink, to prevent	"5-4-6. Specify w	hether or
	blurring. Try this method to eliminate blurring without	not to perform	Multiple
	weakening the highlight.	Pass Printing >>I	P.110"

Probable Cause	Remedy	Reference
Is the area around the print heads	Clean the head section and suction cap.	"8-1-4. Cleaning the
soiled with waste ink spilled from	Furthermore, replace the wiper cleaner with a new	nozzle guard, wiper,
the wiper cleaner or head cap?	one.	exhaust cap, and suction
		cap >>P.249"
		"8-1-5. Replacing the
		wiper cleaner >>P.261"
Is any lint attached to the nozzle	Clean the nozzle guard.	"8-1-4. Cleaning the
surface?		nozzle guard, wiper,
		exhaust cap, and suction
		cap >>P.249"
Is the carriage plate contaminated?	Clean the carriage plate.	"8-2-4. Cleaning the CR
		(carriage) plate >>P.280"
Do the print heads rub against a	Flatten the surface of T-shirt, and adjust the platen's	"6-5. Placing print medium
T-shirt?	height as required.	in position >>P.162"
Has the flushing foam become	Replace the flushing foam with a new one.	"8-1-6. Replacing the
dirty?		flushing foam >>P.264"
Has the platen sheet become	Replace the platen sheet with a new one.	"8-2-5. Replacing the
dirty?		platen sheet >>P.283"
Has any ink attached to the	Perform the cleaning of the carriage plate and	"8-2-4. Cleaning the CR
carriage that secures the print	remove the accumulated ink.	(carriage) plate >>P.280"
heads in place or is it dripping off?		

Ink sticks to such an area where no print data exists (ink stain, horizontal stripe, etc.)

The edges of the image are blurred, characters and straight lines are doubly printed and printed

result appears too granular

Probable Cause	Remedy	Reference
Is the platen positioned at a level	Adjust the height of the platen corresponding to the	"6-5. Placing print medium
that is too low?	print medium before using it. You can use the platen	in position >>P.162"
	height adjustment lever to adjust the height of platen.	
	As a rough indication, adjust the height so that it is	
	lowered by one step from the limit height detected by	
	the obstacle sensor, and check that the platen is not	
	detected by the sensor.	
Is the firing timing correct?	Adjust the ejection timing again. It is likely that the	"8-3-3. Firing adjustment
	setup value is incorrectly set after replacing a print	>>P.287"
	head or the platen with a new one, or after adjusting	
	the platen height.	
Is the image enlarged on the	When a low resolution image is enlarged on the	
printer setting screen?	printer setting screen, it may blur or angle the image.	
	Pattern data should be enlarged on an image editing	-
	application, and its roughness should be checked.	

Thin color cannot be printed out well gradually

Probable Cause	Remedy	Reference
Is the ambient atmosphere at a	Perform the flushing more frequently. In addition,	"9-13. Flushing Interval
high temperature and very dry,	increase the flushing volume.	Setting >>P.304"
which in turn tends to cause the		"9-14. Flushing Volume
nozzle surface to dry up?		Setting >>P.304"

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White ink is not printed out evenly

Probable Cause	Remedy	Reference
Has the pretreatment been	Apply the recommended amount of pretreatment	"6-3-3. Application of
applied unevenly?	evenly to the target area.	pretreatment >>P.140"
Has the pretreatment caused any	After the pretreatment roller is used, put it in a plastic	
change in hardness or	bag or the like hermetically to prevent it from drying	
deformation of the pretreatment	up, and keep it in a flat place in an upright position.	
roller? (This applies to the case	Also, when it remains unused for two weeks or	-
where the pretreatment roller is	longer, wash it well with running water, and let it dry in	
used.)	a shaded area.	
Is any water content attached to	Prevent water content from being attached to the	"6-3-4. Fixation of
the pretreatment roller after the	roller after the pretreatment is fixated.	pretreatment >>P.146"
pretreatment is fixated?		
Is there any lint, yarn waste, dust,	Clean the surface of the pretreatment roller.	"6-3-3. Application of
etc. that are attached to the		pretreatment >>P.140"
surface of pretreatment roller?		
(This applies to the case where		
the pretreatment roller is used.)		
Did you shake the pretreatment	Shake the pretreatment sufficiently.	"6-3-2. Dilution of
after its dilution?		pretreatment >>P.138"
Is the [Low Temperature Mode]	Change the setting to [Enable (Normal)].	"9-11. Print Operation
set to [Disable]?		Settings Under Low
		Temperature >>P.302"
Has the pretreatment been fixated	Check on an actual temperature of the heat press	"6-3-4. Fixation of
insufficiently?	and its pressure during the fixation stage.	pretreatment >>P.146"
	Always keeping the lower iron (where media is	
	placed) of the heat press at heated temperature with	
	a heating source may solve this problem.	

Whiteness of print result is insufficient

Probable Cause	Remedy	Reference
Has the pretreatment been	Apply a proper amount of pretreatment.	"6-3-3. Application of
applied insufficiently?		pretreatment >>P.140"
Has the pretreatment been fixated	Check on an actual temperature of the heat press	"6-3-4. Fixation of
insufficiently?	and its pressure during the fixation stage.	pretreatment >>P.146"
Is there any nozzle that does not eject ink-jet droplets?	Perform [Head Cleaning] from the menu. If no improvement is attained, follow the referenced instructions.	"11-2-1. Recovery action to be taken for such a nozzle that is unable to eject ink-jet droplets >>P.389"

Probable Cause	Remedy	Reference
Is the white ink circulated insufficiently?	From the menu, select [Maintenance] > [White Ink Circulation] to circulate the white ink properly.	-
Is the [Low Temperature Mode] set to [Disable]?	Change the setting to [Enable (Normal)].	"9-11. Print Operation Settings Under Low Temperature >>P.302"
Is the dilution rate of the pretreatment correct?	Dilute the pretreatment appropriately.	"6-3-2. Dilution of pretreatment >>P.138"
Is the [Highlight:] of [White Ink Settings:] too low?	Print the highlight check pattern to check the blurring, and select appropriate set value for [Highlight:].	"5-5-6. Print out of highlight check pattern/mask check pattern >>P.122" "5-4-4. Set up the white ink >>P.106"

Too much luster

Probable Cause	Remedy	Reference
Are you using Teflon-treated	Use a silicon coated peel off sheet when curing the	
peel-off sheet for fixation?	ink to reduce the gloss.	-

Too fuzzy

Probable Cause	Remedy	Reference
Did you touch the print media	Excessively touching the media (T-shirt) on the	
(T-shirt) just before printing?	platen by trying to flatten the media before printing	
	could cause fuzziness. Make sure not to touch the	-
	media surface too much after the pretreatment is	
	fixated.	
Does it take a long time before	Leaving the print media (T-shirt) after fixing the	
printing, after the pretreatment	pretreatment may cause fuzziness, because the	
fixation?	media would absorb water. Print the pretreatment	-
	fixated media as soon as possible.	
Is the upper iron on the heat press	If the upper iron is contaminated, it could roughen the	
contaminated during the	print media (T-shirt) surface by a heat press process,	
pretreatment fixation process?	to cause fuzziness. Clean the upper iron of the heat	
	press with a cloth.	-
	If the condition persists, try using a peel-off sheet	
	during the pretreatment fixation process, to probably	
	improve the condition.	
Unevenly dried during the fixation	It may be solved by inserting a silicone foam	
process?	between the heat press lower iron and a print media	-
	(T-shirt) during ink fixation.	

Background white ink spreads out when printed with [Color+White Ink]

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Probable Cause	Remedy	Reference
[White/Color Alignment]	Misalignment of white and color inks can occur when	"8-3-5. White/color
misaligned?	the media thickness or the platen height is changed.	alignment >>P.289"
	Adjust the platen height first for the actual media to be	
	printed, and align the white and color inks positions.	
Is the media easy to stretch when	Print misalignment may occur between white and	"5-4-8. Set up the white
wet?	color inks when the media stretches when wet with	ink >>P.112".
	white ink. Increasing [Choke Width:] can prohibit	
	spreading of the background white ink.	

Printed surface cracks after fixation

Probable Cause	Remedy	Reference
Isn't the print surface folded before	Try not to touch the print surface until the fixation	
fixation is completed?	process is completed.	-

The lower left side area of the printer's main unit is soiled with ink

Probable Cause	Remedy	Reference
Is the waste ink tube dismounted	For help, please contact your dealer.	
from the maintenance unit?		-
Is the waste ink tube clogged	Straighten the waste ink tube to remove the clog.	
causing the waste ink to flow		-
reversely?		

The cleaning solution is leaked from the cleaning liquid tank

Probable Cause	Remedy	Reference
Is the main body of printer put	Place the printer horizontally.	"4-1. Installation of printer
aslant?	If the problem is still not remedied, please contact your	>>P.48"
	dealer.	

Takes longer print time than before

Probable Cause	Remedy	Reference
Is the ambient temperature under	Adjust the room temperature to 18°C (64.4°F) or	"9-11. Print Operation
18°C (64.4°F)?	more.	Settings Under Low
	If it is difficult to adjust the room temperature, set the	Temperature >>P.302"
	operational configuration under low temperature to	
	[Disable].	
Is your printing under	Lower your room temperature below 30°C (86°F).	
high-temperature and low humidity	Raise your room humidity over 35%.	-
environment?		
Is the wiping frequency set to	Change the wiping frequency to [Standard].	
[Medium-high] or [High]?		-

11-2-1. Recovery action to be taken for such a nozzle that is unable to eject ink-jet droplets

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Items to be checked	Description	Remedy	Document
Is the cap contaminated?	When the cap is contaminated, it cannot fully contact the head, which would lead to suction failure.	Clean the cap	Refer to "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249".
Is there any deposit of ink around the nozzle surface?	When the surrounding area of nozzle surface is contaminated, it could lead to ejection failure since the wiper cannot clean the nozzle surface properly. Or, it could reduce the adhesion between the nozzle and cap, thereby causing ink suction failure.	Cleaning the surrounding area of nozzle surface	Refer to "11-2-3. Cleaning the surrounding area of nozzle surface >>P.397"
Is the wiper contaminated?	When the wiper tip is contaminated, it could lead to ejection failure since the wiper cannot clean the nozzle surface properly.	Clean the wiper	Refer to "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249".
Is there any indication of scar or deformation on the wiper?	When the wiper has any scar or deformation, it could lead to ejection failure since the wiper cannot clean the nozzle surface.	Replace the wiper	Refer to "11-2-6. Replacing the Wiper >>P.415".
Is the wiper cleaner contaminated?	If the wiper cleaner is contaminated, residual dirt on the wiper may prohibit the wipers cleaning function.	Replacing the wiper cleaner	Refer to "8-1-5. Replacing the wiper cleaner >>P.261".
Is the wiper cleaner dried?	If the wiper cleaner is dry, it may prohibit the wiper's proper function to wipe clean.	Replacing the wiper cleaner	Refer to "8-1-5. Replacing the wiper cleaner >>P.261".
Is the flushing foam floated?	If the flushing foam is not placed appropriately, it may touch the nozzle surface to stop ejection from the nozzle.	Replace the flushing foam	Refer to "8-1-6. Replacing the flushing foam >>P.264".
Is the ink accumulated on the flushing foam?	If an ink accumulates on the flushing foam, the ink may touch the nozzle surface to prevent ink from ejecting.	Replace the flushing foam	Refer to "8-1-6. Replacing the flushing foam >>P.264".
Is the tube correctly connected to the head?	If they are loosely mated, it may allow air to enter into the head section during the head cleaning operation, to cause non-ejection condition of the nozzle.	Verify connection between the head and the tube	Refer to "11-2-5. Replacement of print head >>P.403".
Is the ink pouch properly attached to the cartridge?	If the ink pouch is not properly installed, the cartridge cannot fully wind it, and fails to supply enough ink to the head.	Install an ink pouch	Refer to "11-2-7. Re-install the ink >>P.420".
Is the tube filled with ink?	If a large amount of air exists in the tube, that air will go into the head to cause non-ejection condition of the nozzle.	Re-install the ink	Refer to "10-2-8. Re-install the ink >>P.348".

Please verify the followings when any nozzle is not ejecting ink droplets.

After carrying out appropriate remedial measures listed above, make sure the non-firing nozzle has been recovered. If it has not, perform the steps 1 to 5 to recover the non-firing nozzle.

Step 1: Print out a nozzle check pattern

(1) Print out a nozzle check pattern (1st time).

<TIPS>

- For details of the printing method of nozzle check pattern, refer to "8-2-1. Print out of the nozzle check pattern (checking on the print heads) >> P.275".
- (2) Check the result of the printed nozzle check pattern (1st time), and carry out the following procedures. ** "8-2-1.

Print out of the nozzle check pattern (checking on the print heads) >>P.275"

<TIPS>

Even if the white print result is weak, since the white ink is ejected on one same spot through multiple nozzles, a relatively large amount of ink volume will be used, and the firing problem of a single nozzle will not affect the print quality so much.
 Even in a condition with weak lines, the print is performed without a problem.

Existence or nonexistence of a nozzle that does not eject any ink-jet droplets	Recovery action
Such a nozzle does not exist that	If a number of non-firing of white head is observed in printing although such
does not eject any ink-jet droplets	non-firing problems do not occur in nozzle check pattern printing, please contact your dealer.
	If a number of non-firing of white head is observed in printing although such non-firing problems do not occur in nozzle check pattern printing, replace the filter. #"11-2-4. Replacing the color filter >>P.400" If non-firing cannot
	be resolved after replacing the filter, please contact your dealer.
Such a nozzle exists that does not	Proceed to Step 2.
eject any ink-jet droplets	

Step 2: Perform the head cleaning

- (1) Perform a normal cleaning. * "8-2-2. Head cleaning >> P.239"
- (2) Print out a nozzle check pattern (2nd time).
- (3) Check the result of the printed nozzle check pattern (2nd time), and carry out the following procedures.

Existence or nonexistence of a	
nozzle that does not eject any	Recovery action
ink-jet droplets	
Such a nozzle does not exist that	Exit
does not eject any ink-jet droplets	
Ten-or-less nozzles exist that do	Perform the normal cleaning once again. Subsequently, proceed to (4).
not eject any ink-jet droplets	
Ten-or-more nozzles exist that do	Perform the powerful cleaning. Subsequently, proceed to (4).
not eject any ink-jet droplets	
More than half of the nozzles of	Re-install the ink. Is "11-2-7. Re-install the ink >>P.420"
the color heads have a problem	Subsequently, proceed to (4).
concerning firing of the print	
heads.	

- (4) Print out a nozzle check pattern (3rd time).
- (5) Check the result of the printed nozzle check pattern (3rd time), and carry out the following procedures.

Existence or nonexistence of a	
nozzle that does not eject any	Recovery action
ink-jet droplets	
Such a nozzle does not exist that	Exit
does not eject any ink-jet droplets	
Such a nozzle exists that does not	Proceed to Step 3.
eject any ink-jet droplets	

Step 3: Check that no ink-jet droplets are ejected from the applicable nozzle

(1) Check locations of the non-ejecting nozzles on the result of the printed nozzle check pattern (1st to 3rd time), and

carry out the following procedures.

Comparison of non-ejection nozzle positions	Recovery action
The same nozzle always does not	Perform the super cleaning -> print out of nozzle check pattern for the third
eject ink-jet droplets	time in a row.
A different nozzle does not eject	Leave the printer as it is for about 30 minutes, and perform the normal
ink-jet droplets	cleaning -> print out of nozzle check pattern for the third time in a row.

(2) Check a result of the resultant nozzle check patterns, and carry out the following procedures.

Existence or nonexistence of a	
nozzle that does not eject any	Recovery action
ink-jet droplets	
Such a nozzle does not exist that	Exit
does not eject any ink-jet droplets	
Such a nozzle exists that does not	Proceed to Step 4.
eject any ink-jet droplets	

Step 4: Clean the nozzle surface

- (1) Clean the nozzle surface of the print heads. "11-2-2. Cleaning of head nozzle >>P.394"
- (2) Print out a nozzle check pattern.
- (3) Check a result of the resultant nozzle check patterns, and carry out the following procedures.

Existence or nonexistence of a	
nozzle that does not eject any	Recovery action
ink-jet droplets	
Such a nozzle does not exist that	Exit
does not eject any ink-jet droplets	
Such a nozzle exists that does not	Proceed to Step 5.
eject any ink-jet droplets	

<IMPORTANT>

• Even if the nozzles on the white side have a bit of problem concerning firing, since the white ink is ejected on one same spot through multiple nozzles, relatively large amount of ink volume will be used, and firing problem of a single nozzle will not affect the print quality so much. Even in a condition with a problem concerning firing as shown in (a), print is performed without a problem as shown in (b).

(a)	(b)

Step 5: Head Replacement

(1) Replace the print head with a new one. T11-2-5. Replacement of print head >>P.403"

11-2-2. Cleaning of head nozzle

If a problem of non-ejection of ink-jet droplets is not cleared even after performing the head cleaning, perform the head nozzle cleaning. ** "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249"

<IMPORTANT>

- Clean the nozzle guard first, then clean the head nozzle.
- (1) Make the clean stick R, cleaning cup, gloves and cleaning solution, which come standard with the printer, available

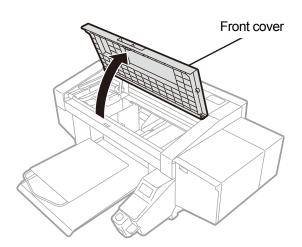
for use.

<IMPORTANT>

- Use a new clean stick R when you start cleaning.
- Never touch the tip end of clean stick R with your hand. If any sebaceous matter is attached to the head nozzle, it may result in the printer malfunction.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press
 <IMPORTANT>
 - If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing Causes the platen to start moving. Do not put anything around the platen.
- (3) Follow the on-screen message and turn off the power. <IMPORTANT>
 - Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
 - If the task takes more than 15 minutes to complete, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (4) Open the front cover.



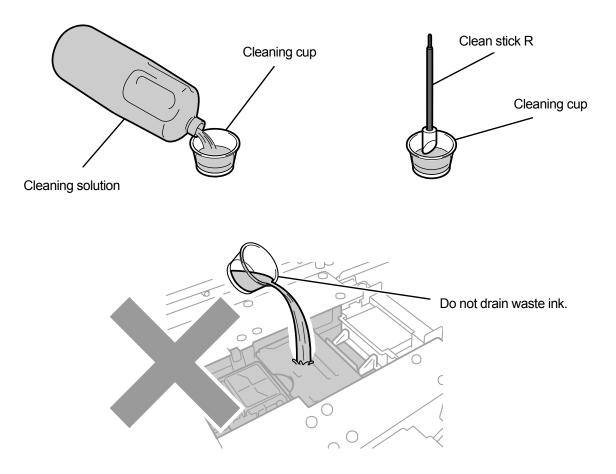
- (5) Put a proper amount of cleaning solution into the cleaning cup.
- (6) Moisten a clean stick R with the cleaning solution.

<IMPORTANT>

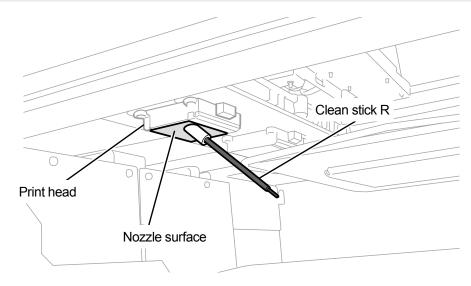
- Be sure to use a different clean stick R separately for the color head and the white head. Use a new clean stick R when you start cleaning.
- Do not use other fluids (water, etc.), because they may damage the print heads.
- Do not return the cleaning solution which has been put in the cleaning cup to the cleaning solution bottle.
- Do not shed cleaning solution in the maintenance unit.

<NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.



- (7) With a clean stick R, clean the nozzle surface of print head.
 Manually move the carriage to such a position that you can perform the cleaning with ease.
 <IMPORTANT>
 - Be sure not to bring corner edges of the clean stick R into contact with the nozzle surface.
 - Avoid roughly rubbing the nozzle surface.
 - The used clean stick R should be disposed of, and should not be reused.



X0251

- (8) Close the front cover, turn on the power.
- (9) From the menu, select [Head Cleaning] > [Powerful Cleaning] > [All Print Heads], and press
 <NOTE>



Dispose of any waste resulting from the cleaning in accordance with applicable laws and ordinances.
 <TIPS>

- Then, the head cleaning will be performed to prevent any ink from drying up.
- Because the cleaning cup will be reused, rinse it in clean cleaning solution and store it in a safe place.

11-2-3. Cleaning the surrounding area of nozzle surface

(1) Make the clean stick R, cleaning cup, gloves and cleaning solution, which come standard with the printer, available

for use.

<IMPORTANT>

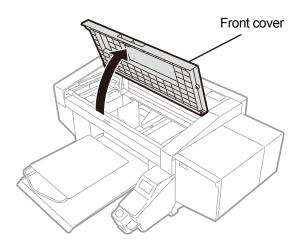
- Use a new clean stick R when you start cleaning.
- Never touch the tip end of clean stick R with your hand. If any sebaceous matter is attached to the head nozzle, it may
 result in the printer malfunction.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press

<IMPORTANT>

 If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

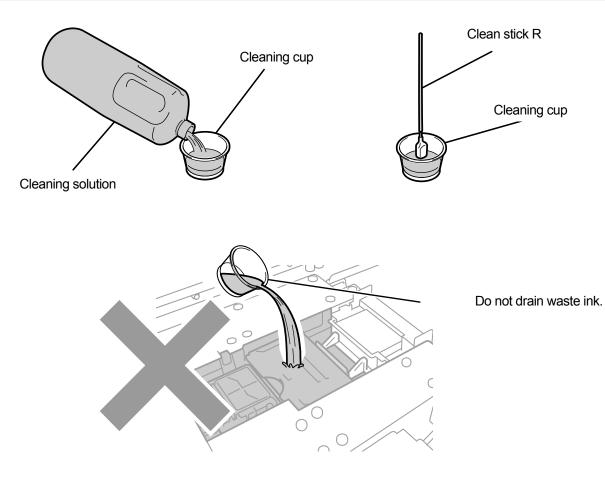
- Pressing (K) causes the platen to start moving. Do not put anything around the platen.
- (3) Follow the on-screen message and turn off the power. <IMPORTANT>
 - Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
 - If the task takes more than 15 minutes to complete, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (4) Open the front cover.



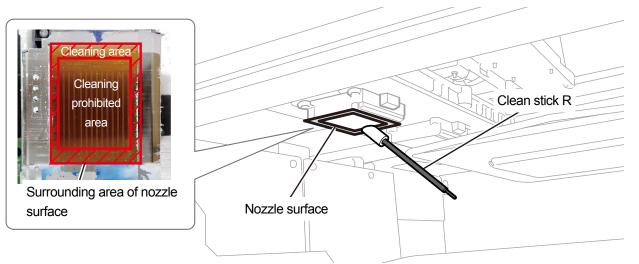
- (5) Put a proper amount of cleaning solution into the cleaning cup.
- (6) Moisten a clean stick R with the cleaning solution.

<IMPORTANT>

- Be sure to use a different clean stick R separately for the color head and the white head. Use a new clean stick R when you start cleaning.
- Do not use other fluids (water, etc.), because they may damage the print heads.
- Do not return the cleaning solution which has been put in the cleaning cup to the cleaning solution bottle.
- Do not shed cleaning solution in the maintenance unit.
- <NOTE>
- For a proper work operation, be sure to wear the printer-provided gloves.



- With a clean stick R, clean the surrounding area of nozzle surface of print head. Manually move the carriage to such a position that you can perform the cleaning with ease.
 <IMPORTANT>
 - Be sure not to bring the clean stick R into contact with the nozzle surface.
 - The used clean stick R should be disposed of, and should not be reused.



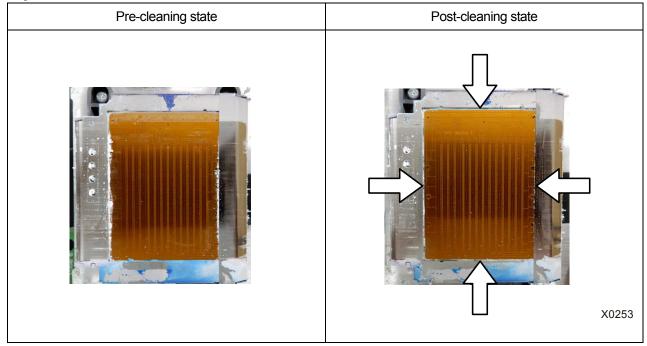
X0293

- (8) Close the front cover, turn on the power.
- (9) From the menu, select [Head Cleaning] > [Powerful Cleaning] > [All Print Heads], and press (NOTE>

Dispose of any waste resulting from the cleaning in accordance with applicable laws and ordinances.
 <TIPS>

- Then, the head cleaning will be performed to prevent any ink from drying up.
- Because the cleaning cup will be reused, rinse it in clean cleaning solution and store it in a safe place.

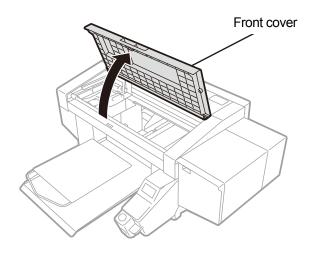
Cleaning conditions



11-2-4. Replacing the color filter

If a number of non-firing color head nozzles is observed after printing, the filter should be replaced. <IMPORTANT>

- When replacing multiple filters, filters for individual colors should be replaced one by one. Replace the filter for the first color and install ink, then replace the next filter. Removing multiple filters at the same time might damage the print head.
 <TIPS>
- Ink installation should be performed after replacing the filters. If the ink level is low, make a new ink pouch available for use.
- (1) Prepare the supplied gloves and optional filter.
- (2) From the menu, select [Maintenance] > [Exchange Filter], and press
- (3) From [Black], [Yellow], [Cyan], and [Magenta] select non-firing color and press <TIPS>
 - Pressing (CALC) causes the platen to start moving. Do not put anything around the platen.
- (4) Follow the on-screen message and turn off the power.
- (5) Open the front cover.

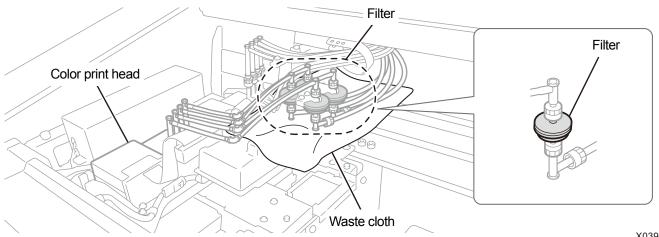


X0419

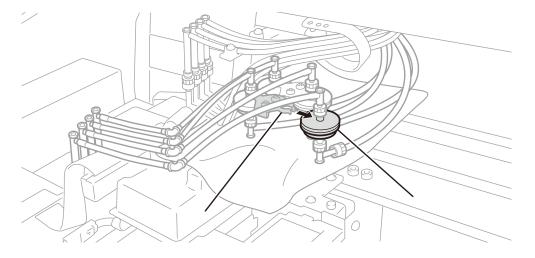
(6) Lay a waste cloth under the filter to be replaced.

<TIPS>

Non-fuzzy, clean cloth should be used.



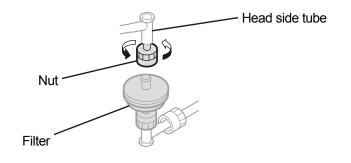
(7) Remove the filter from the bracket.



X0397

X0437

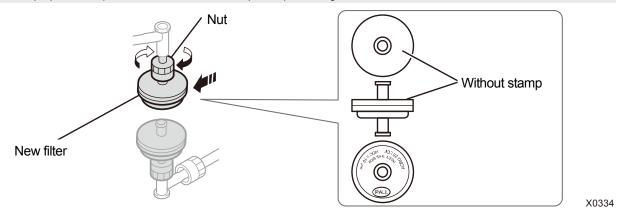
(8) Rotate the nut of the tube on the head side and remove the filter.



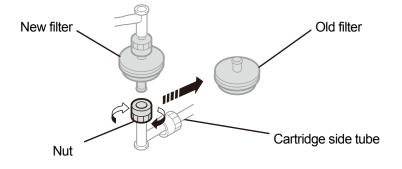
(9) Place a new filter on the head side tube and fasten the nut. <IMPORTANT>

• Install the filter with no stamp facing the tube. Pay attention to this installation orientation.

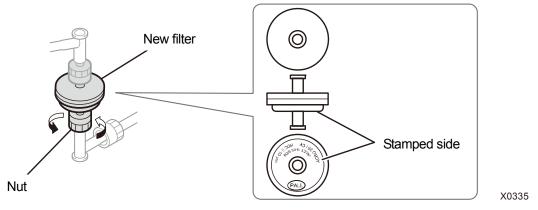
- <NOTE>
- For a proper work operation, be sure to wear the printer-provided gloves.



(10) Rotate the nut of the tube on the cartridge side to remove the old filter.



- (11) Attach the cartridge side tube to a new filter and fasten the nut.<IMPORTANT>
 - Make sure to install the filter with the stamped side facing the cartridge side tube.



- (12) Remove the waste cloth from under the filter.
- (13) Close the front cover, turn on the power. <NOTE>
 - Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.
- (14) Perform the [Filter exchange after ink Load] operation by following the on-screen instructions. <TIPS>
 - When replacing multiple filters, go back to the beginning of the procedure to start replacing the next filter.
 - After the procedures are completed, the current screen will go back to the standby mode screen.

11-2-5. Replacement of print head

If a problem of non-ejection of ink-jet droplets is not cleared even after cleaning the head nozzle, replace a print head with a new one.

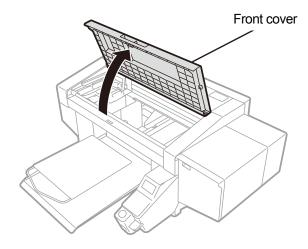
The replacement procedures vary from the color heads to the white heads. According to each of the replacement procedures, replace each print head with a new one separately.

<TIPS>

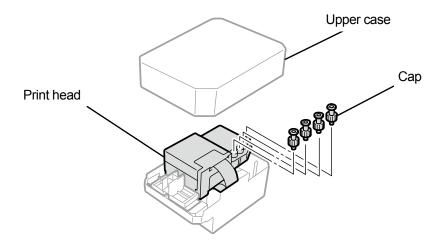
- Do not confuse the color side print head with the white side print head.
 Check the case color (red for the color side, white for the white side) and replace the case.
- Ink needs to be re-installed after replacing the print head. If the ink level is low, make a new ink pouch available for use.

Replacement procedures for print head on the color side

- From the menu, select [Maintenance] > [Head Replacement] > [Color], and press
 <TIPS>
 - Pressing Causes the platen to start moving. Do not put anything around the platen.
- (2) Follow the on-screen message and turn off the power. <IMPORTANT>
 - Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
- (3) Open the front cover.



- (4) Remove the upper case of a new print head.
- (5) Remove four caps from the new print head.



Troubleshooting (For GTX pro Bulk)

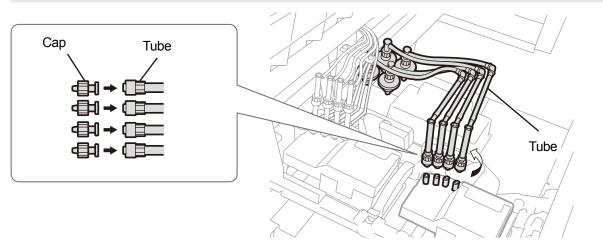
(6) Remove each tube from the print head to be replaced with a new one, then attach each of the new caps which are

removed from a new print head to each tube, while exercising care to prevent any ink from being spilled. </br><IMPORTANT>

- Care is needed in preventing any ink from being spilled from each tube. If the ink is dripping, wipe off the dripping ink.
- Be careful not to confuse it with the tube for the print head on the white side.
- When you replace the print head, be sure to move the carriage manually to the position of platen at the center of the printer before starting the replacement. If you perform the mounting of the head when the carriage is directly above the maintenance unit, it may damage the maintenance unit or the heads.

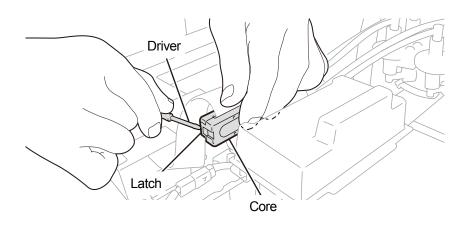
<NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.

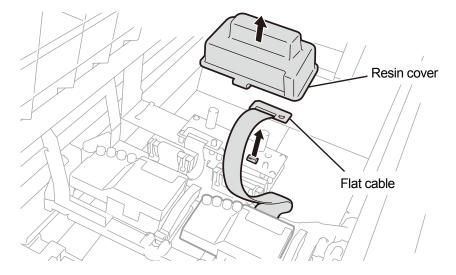


X0398

- (7) Remove the core claw using the supplied screwdriver.<IMPORTANT>
 - Hold the core center by hand to make it easy to insert the screwdriver into the claw.

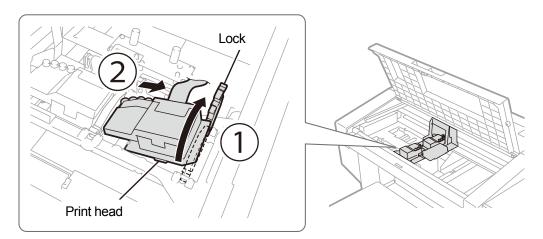


(8) Remove the resin cover which is placed on the top of the carriage board and remove the flat cable.



X0400

- (9) Unlock the print head, and remove the print head. <IMPORTANT>
 - When removing the print head in position, be careful not to drip the ink on the carriage plate. If the ink is dripping, wipe off the dripping ink.

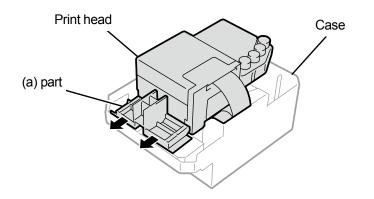


X0401

- (10) Release the lock by pulling (a) part toward yourself, and take out the new print head from its case.
 <IMPORTANT>
 - When removing the print head, be careful not to touch the nozzle surface at the bottom of the head. Otherwise it may cause poor printing.

<TIPS>

• Sometimes, you may find it hard to remove the print head when you try to open the lock of (a) part. If it is hard, use both hands to remove it.



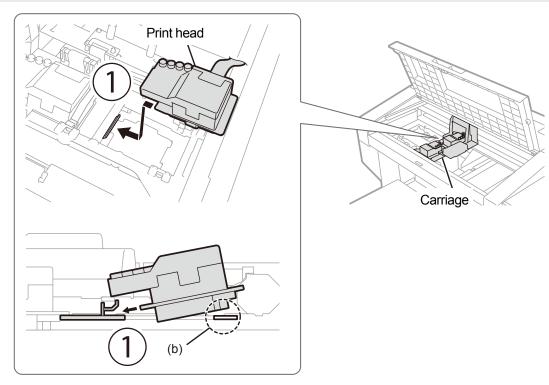
(11) By following the procedures mentioned below, mount a new print head on the carriage.

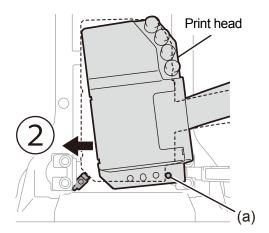
① Insert the rearward end of the print head into the carriage.

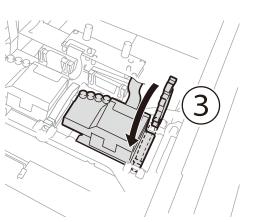
② Push with force in direction ② so that the illustrated part (a) makes contact with the side of the metal plate of the print head.③ Lock the print head in place.

<IMPORTANT>

- Make sure the illustrated (a) part is in contact with the side of the metal plate.
- When placing the print head in position, be careful not to move the carriage as much as possible. Your hand may be caught in the carriage and injured. In addition, the tubes may be rolled together possibly damaging them.
- When you mount ③, push it down from the top. Otherwise, you may get your finger caught in it and get injured.
- <TIPS>
- If the print head is not inserted sufficiently, the part as illustrated in (b) could come into contact with its bottom surface, which in turn may result in poor printing. Please insert the print head as far as it can go.



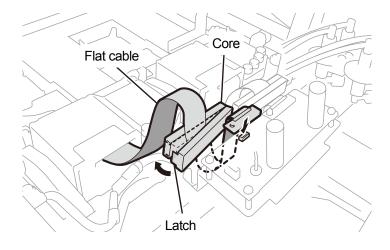




X0403

- (12) Insert the flat cable into the core and connect it to the carriage board.
- (13) Fit the claw by pushing the core until it clicks into place.

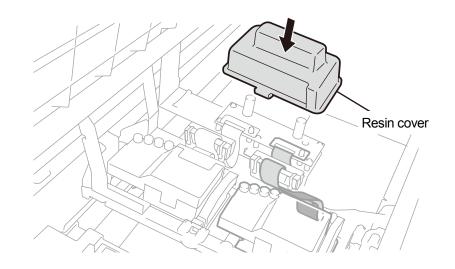
Leave a slack to avoid interference between the flat cable and the resin cover.



X0404

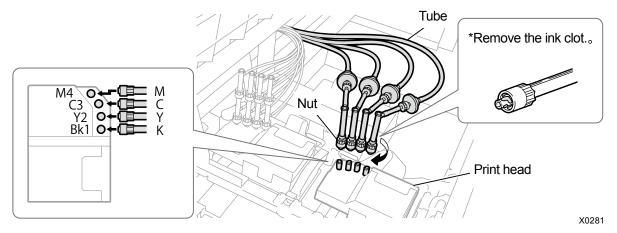
(14) Place the resin cover back onto the carriage board, and engage the two latches properly.

Tuck the extra flat cable as shown in the illustration.



- (15) Remove the cap you connected in step (6) from the tube, and connect the tubes to the print head. <IMPORTANT>
 - To prevent the tubes from being entangled with each other, connect the innermost tube to the print head first, and make a connection of the rest of the tubes.
 - Be sure to connect each tube with its correct position.

(16) Tighten the nut firmly until it stops so that each tube is fixed to the print head.



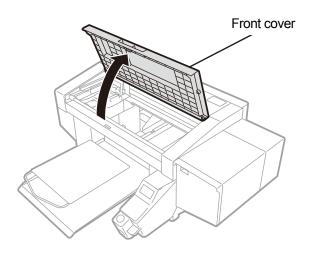
- (17) Close the front cover, turn on the power.
- (18) From the menu, select [Maintenance] > [Install Ink after Replacing Head] > [Color], and press
 Perform the work operation by following the on-screen instructions.
 <TIPS>
 - After the procedures are completed, the current screen will go back to the standby mode screen.
- (19) Adjust the carriage speed. * "8-3-1. CR (Carriage) speed adjustment >>P.285"
- (20) Print the nozzle check patterns. I "8-3-1. CR (Carriage) speed adjustment >>P.285"
- (21) Perform the initial settings after head replacement configuration. ☞ "8-3-2. Initial settings after head replacement >>P.286".
- (22) Adjust the ejection timing of print head. r "8-3-3. Firing adjustment >>P.287".
- (23) Perform the platen feed adjustment. * "8-3-4. Platen-rolling adjustment >>P.288"
- (24) Make the position adjustment between the white head and the color head. ☞ "8-3-5. White/color alignment >>P.261

Replacement procedures for print head on the white side

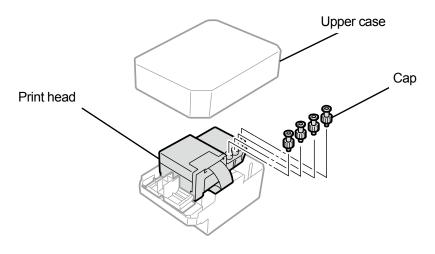
- (1) From the menu, select [Maintenance] > [Head Replacement] > [White], and press
- (2) Select [No] in response to the instructions on screen.

<TIPS>

- Perform the work operation by following the on-screen instructions.
- Pressing (causes the platen to start moving. Do not put anything around the platen.
- (3) Follow the on-screen message and turn off the power.
 <IMPORTANT>
 - Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
- (4) Open the front cover.



- (5) Remove the upper case of a new print head.
- (6) Remove four caps from the new print head.



Troubleshooting (For GTX pro Bulk)

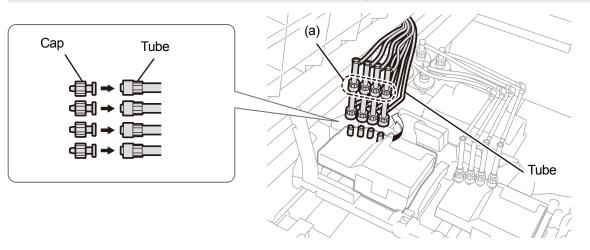
(7) Remove each tube from the print head to be replaced with a new one, then attach each of the new caps which are

removed from a new print head to each tube, while exercising care to prevent any ink from being spilled. </br><IMPORTANT>

- Care is needed in preventing any ink from being spilled from each tube. If the ink is dripping, wipe off the dripping ink.
- Be careful not to confuse it with the tube for the print head on the color side.
- Be sure not to tighten the nut for part (a) by mistake. It could remove the tube and leak the contained ink.
- When you replace the print head, be sure to move the carriage manually to the position of the platen at the center of the printer before starting the replacement. If you perform the mounting of the head when the carriage is directly above the maintenance unit, it may damage the maintenance unit or the heads.

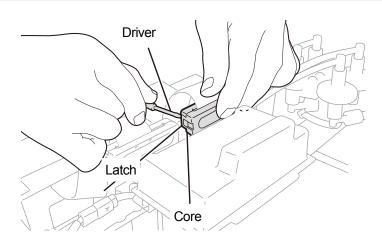
<NOTE>

• For a proper work operation, be sure to wear the printer-provided gloves.

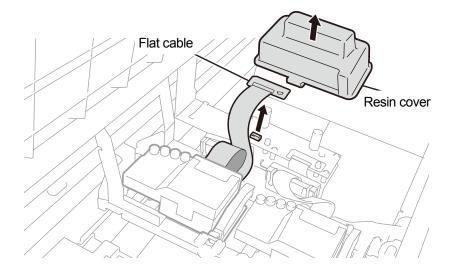


X0407

- (8) Remove the core claw using the supplied screwdriver.
 <TIPS>
 - Hold the core center by hand to make it easy to insert the screwdriver into the claw.



(9) Remove the resin cover which is placed on the top of the carriage board and remove the flat cable.

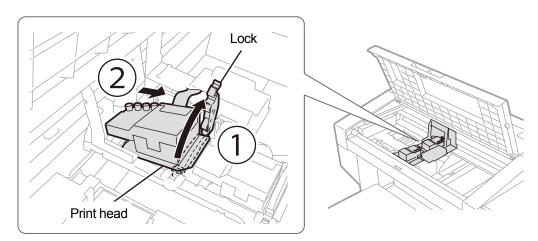


X0409

(10) Unlock the print head, and remove the print head.

<IMPORTANT>

When removing the print head, be careful not to drip the ink on the carriage plate. If the ink is dripping, wipe off the dripping ink.

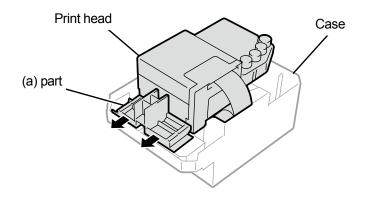


X0410

- (11) Release the lock by pulling (a) part toward yourself, and take out the new print head from its case.
 <IMPORTANT>
 - When removing the print head, be careful not to touch the nozzle surface at the bottom of the head. Otherwise it may cause poor printing.

<TIPS>

• Sometimes, you may find it hard to remove the print head when you try to open the lock of (a) part. If it is hard, use both hands to remove it.



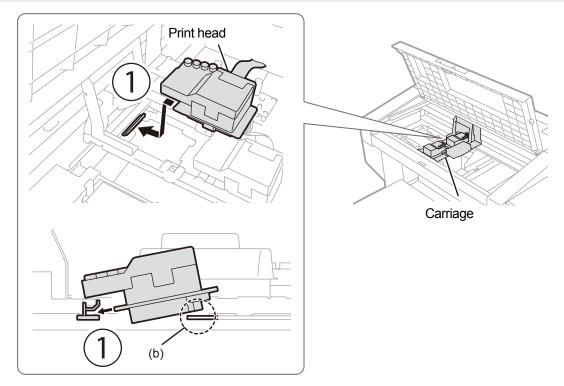
(12) By following the procedures mentioned below, mount a new print head on the carriage.

(1) Insert the rearward end of print head into the carriage.

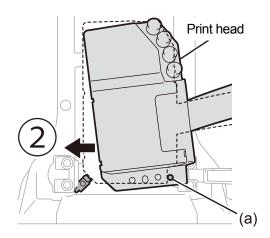
② Push with force in direction ② so that the illustrated part (a) makes contact with the side of the metal plate of the print head.③ Lock the print head in place.

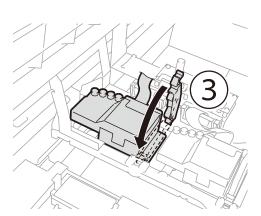
<IMPORTANT>

- Make sure the illustrated (a) part is in contact with the side of the metal plate.
- When placing the print head in position, be careful not to move the carriage as much as possible. Your hand may be caught in the carriage and injured. In addition, the tubes may be rolled together possibly damaging them.
- When you mount ③, push it down from the top. Otherwise, you may get your finger caught in it and get injured.
- <TIPS>
- If the print head is not inserted sufficiently, the part as illustrated in (b) could come into contact with its bottom surface, which in turn may result in poor printing. Please insert the print head as far as it can go.



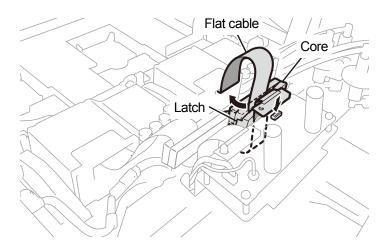






- (13) Insert the flat cable into the core and connect it to the carriage board.
- (14) Fit the claw by pushing the core until it clicks into place.

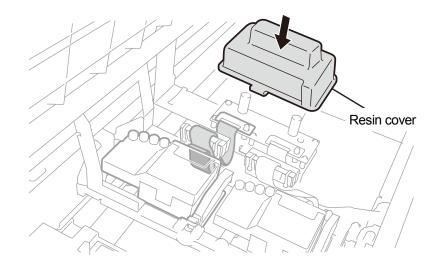
Leave a slack to avoid interference between the flat cable and the resin cover.



X0413

(15) Place the resin cover back onto the carriage board, and engage the two latches properly.

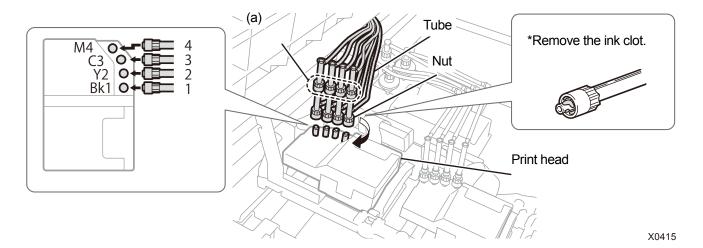
Tuck the extra flat cable as shown in the illustration.



- (16) Remove every cap from each tube, and connect the tubes to the print head.<IMPORTANT>
 - To prevent the tubes from being entangled with each other, connect the innermost tube to the print head first, and make the connection of the rest of the tubes.
 - Check the stamp on the print head and connect them taking care not to confuse their positions. Incorrectly connecting them
 may cause the ink to leak during the circulation.

(17) Tighten the nut firmly until it stops so that each tube is fixed to the print head.

- <IMPORTANT>
- Be sure not to tighten the nut for part (a) by mistake.



- (18) Close the front cover, turn on the power.
- (19) From the menu, select [Maintenance] > [Install Ink after Replacing Head] > [White], and press



- When the white ink pouch runs low on its remaining volume of white ink, the Install Ink after Replacing Head function can no longer get started. Furthermore, there may be cases where the pouch needs to be replaced with a new one during the installation process of white ink. If the remaining volume is 400 g (14.1 oz) or less, prepare a new white ink pouch, follow the instructions on the screen to replace the pouch, and activate the mode again.
- (20) On the operation panel, press

Then, the white ink will be installed after the head is replaced with a new one.

<TIPS>

<TIPS>

- After the procedures are completed, the current screen will go back to the standby mode screen.
- (21) Adjust the carriage speed. ""8-3-1. CR (Carriage) speed adjustment >>P.285"
- (22) Print the nozzle check patterns. Solutions (Carriage) speed adjustment >>P.285"
- (23) Perform the initial settings after head replacement configuration. ☞ "8-3-2. Initial settings after head replacement >>P.286"
- (24) Adjust the ejection timing of the print head. * "8-3-3. Firing adjustment >>P.287"
- (25) Perform the platen feed adjustment. * "8-3-4. Platen-rolling adjustment >>P.288"
- (26) Make the position adjustment between the white head and the color head. "8-3-5. White/color alignment >>P.289"

11-2-6. Replacing the Wiper

Replace the wiper with a new one if it is damaged or deformed.

- (1) Have the supplied gloves and wiper ready.
- (2) From the menu, select [Maintenance] > [Maintenance Part Clean/Replace], and press

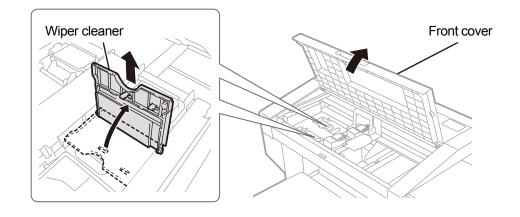


<IMPORTANT>

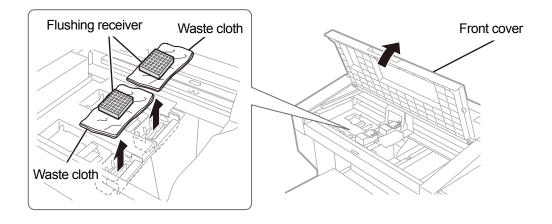
• If any other error or message is displayed on the operation panel or warning message window, follow the message to solve the problem, then perform the cleaning.

<TIPS>

- Pressing causes the platen to start moving. Do not put anything around the platen.
- (3) Follow the on-screen message and turn off the power. <IMPORTANT>
 - Please complete the task within 15 minutes, in order to prevent the print heads from drying up.
 - If the task takes more than 15 minutes to complete, after attaching the flushing receiver, wiper cleaner, and wiper, close the front cover and turn on the power, and then select [Maintenance Part Clean/Replace] again to restart the task. Then, the head cleaning will be performed to prevent any ink from drying up.
- (4) Open the front cover.
- (5) Raise the wiper cleaner and move it to its upright position, and remove it by moving it upward.
 <IMPORTANT>
 - Removed wiper cleaner should be placed with the cleaner side facing up.
 <NOTE>
 - For a proper work operation, be sure to wear the printer-provided gloves.

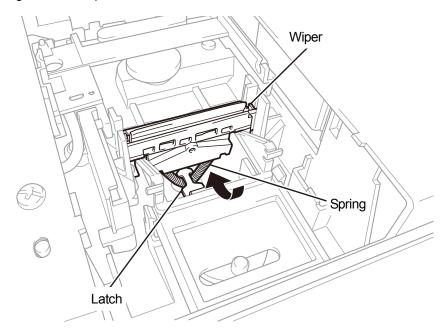


- (6) Remove the flushing receiver from the maintenance unit.
 <IMPORTANT>
 - Ink droplets will drop off from the hole on the bottom of flushing receiver. Press a waste cloth against the bottom surface, and lift the flushing receiver vertically to remove it.

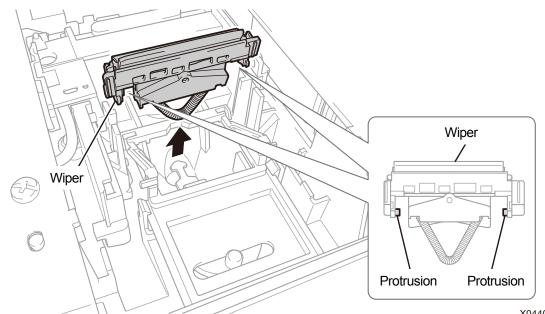


X0327

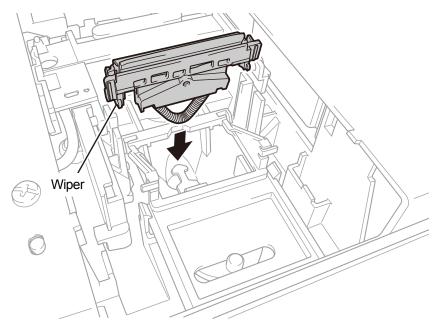
(7) Remove the spring under the wiper from the maintenance unit latch.



- (8) Remove the wiper from the maintenance unit.<IMPORTANT>
 - There are two protruded parts underneath. Thoroughly remove the wiper not to damage these parts.

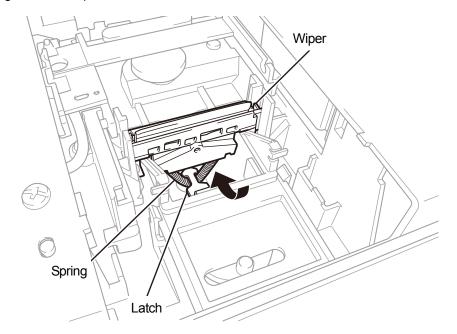


(9) Insert a new wiper into the printer from above.



X0440

(10) Place the spring under the wiper on the maintenance unit latch.

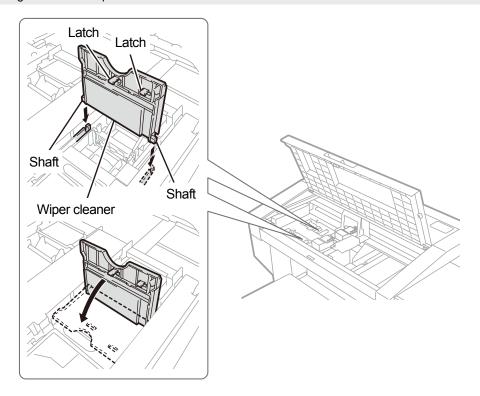


X0442

(11) Insert a wiper cleaner into the printer from above, tip it leftward and put it in place.

<TIPS>

- During this process, it is recommended to also replace the wiper cleaner with a new one.
- First, insert the shaft from above. Then fold it to the left, press the area with the PUSH indication until a clicking sound is heard, and get the latch into position.



(12) Mount the flushing receiver back to its original place in the maintenance unit.

<TIPS>

- Direct its orientation with a hole on the bottom to the front.
- (13) Close the front cover.
- (14) Turn on the power.
 - <NOTE>
 - Dispose of any waste resulting from the replacement in accordance with applicable laws and ordinances.

<TIPS>

• Then, the head cleaning will be performed to prevent any ink from drying up.

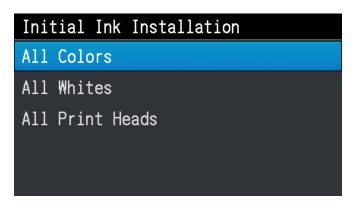
11-2-7. Re-install the ink

Ink should be re-installed when an entrance of air into the print head or tube prevents proper ink-jet operation and remedial measure cannot improve the condition.

(1) While the printer is in standby mode, press

on the operation panel to bring the menu screen into view.

- (2) Press \blacktriangle / \bigtriangledown , select [Maintenance] > [Initial Ink Installation], and press (
- (3) Press \blacktriangle \checkmark \checkmark to select one of the options; [All Colors], [All Whites], or [All Print Heads], and press



- (4) According to the message displayed on the operation panel, press Initial ink installation will be operated.
 <TIPS>
 - Estimated time to finish is 58 minutes (30 more minutes below 18°C) for [All Whites] and 45 minutes for [All Colors] (10 more minutes below 18°C), which, however, may fluctuate depending on the temperature environment and printer status. After the procedures are completed, the current screen will go back to the standby mode screen.

11-3. Acquisition of log file

In cases where the printer malfunctions, you may be required by our service personnel to obtain your printer's log file. For this reason, please save your printer's log file to a file. <TIPS>

• To the resultant file, such filename (.log) that automatically identifies your printer will be given.

Fetch a log file from USB flash memory

- (1) Insert a USB flash memory into the insertion slot of the printer.
- (2) Press (CAR) on the operation panel located on the left side of printer to go to the menu.
- (3) Press \blacktriangle \nearrow , select [Maintenance] > [Log copy to USB], and press



(4) Then, the print button stops blinking, and the log file writing operation will be completed when you hear the sound of pong.

<IMPORTANT>

- Never remove the USB flash memory from the printer when the print button is blinking. Otherwise, the USB flash memory
 may be damaged, rendering its internal data to be unreadable.
- (5) Obtain the log file saved to the USB flash memory, and send such file to our service personnel.

Fetch a log file via USB/LAN connection

(1) On the PC, from [All Programs] in the Start menu, select the "GTX pro Maintenance" from "Brother GTX pro Tools".

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(2) After the window shown below appears, select the [Log Data Retrieval] and click [Next].

W Brother GTX pro Maintenance	х
Confirm the printer is turned ON and connected to your PC. Select the printer.	
Brother GTX pro V Search	
Select an item from the menu below and click "Next".	
 Initial settings after head replacement Perform this setting when replacing the head or when setting up the printer only. 	
Firing Adjustment Adjust this setting when the edges of the print look vague, solid areas are not even, or after a Print Head is replaced.	
 Platen-rolling adjustment Make adjustments when horizontal stripes (banding) occur in the printed image. Use this adjustment as a troubleshooting method when other items such as proper temperature and humidity have already been verified. White/Color Alignment Adjust when white print does not align with color print. 	
O Set an IP Adrress Assign a static IP address to the printer.	
Dog Data Retrieval Execute if there was a request after troubleshooting service.	
Setting of the time displayed on the nozzle check pattern This is not necessary if you have configured the scheduled time for white ink circulation.	
 Set the scheduled time for white ink circulation Configure this setting to set or cancel the scheduled time for white ink circulation. 	
< Back Next > Close	

(3) Perform the required operation by following the on-screen instructions in the dialog box.

Error message

Error message

What is shown below is the error message list of the GTX pro printer. Any error message is displayed on the liquid crystal panel.

Please try to solve any error according to the resolution strategy.

Error code	Error message	Description	Remedy	Reference
_	[Temperature & Humidity Warning]	The printer is currently under high-temperature and low-humidity environment, thereby prolonging the time required for automatic maintenance operation after completion of printing.	Adjust the surrounding temperature and humidity of the printer so that both of the temperature and humidity may be within the print warranty coverage with room left for the coverage.	"13-1. Apparatus >>P.473"
0001	[ERROR: 0001 I failed in initialization. Turn off and on]	The panel board cannot communicate with the main board at all (Displayed in English regardless of the selected language.)	If the problem still persists even after restarting the printer, please contact your dealer.	-
1000	[Cleaning Solution Low - Add More]	The remaining cleaning solution is running low.	Replenish cleaning solution.	"6-2-2. Confirmation and replenishment of cleaning solution >>P.129"
1001	[Cleaning Solution Out - Add More]	The cleaning solution has been depleted.	Replenish cleaning solution.	"6-2-2. Confirmation and replenishment of cleaning solution >>P.129"
1010	[Tank Correction Time]	When the tank remaining volume sensor needs to be manually corrected	Select [Tank remaining volume sensor correction] to correct the ink tank remaining volume sensor.	-
1011	[Tank correction is needed. Perform the correction]	When the tank remaining volume sensor needs to be manually corrected	Correct the ink tank remaining volume sensor following the instructions on screen.	-
1030	[Color Head Getting Warm]	It is the warning about temperature increase in the color heads.	Please wait until the temperature decreases. If the problem still persists, please contact your dealer.	-
1031	[W Head Temp Rising]	It is the warning about temperature increase in the white heads.	Please wait until the temperature decreases. If the problem still persists, please contact your dealer.	-

Error code	Error message	Description	Remedy	Reference
1060	[Temp Low]	The ambient temperature decreases below the scope covered by its warranty for the best print result.	Raise your room temperature.	"13-1. Apparatus >>P.473"
1061	[Temp High]	The ambient temperature rises above the scope covered by its warranty for the best print result.	Lower your room temperature.	"13-1. Apparatus >>P.473"
1064	[Humidity too Low]	The humidity decreases below the scope covered by its warranty for the best print result.	Raise your room humidity.	"13-1. Apparatus >>P.473"
1065	[Humidity too High]	The humidity level is higher than the scope covered by its warranty for the best print result.	Lower your room humidity.	"13-1. Apparatus >>P.473"
1070	[Battery To Be Replaced]	Battery needs to be replaced.	Make note of their error code and error message, and please notify it to your dealer.	-
1080	[RTC Not Adjusted]	The built-in clock has not been set up.	Make note of their error code and error message, and please notify it to your dealer.	-
1085	[RTC Not Adjusted]	The built-in clock has not been set up.	Make note of their error code and error message, and please notify it to your dealer.	-
1090	[Cap/Wiper Cleaning]	Cap and wiper need to be cleaned.	Clean the cap and wiper.	For GTX pro "7-1-3. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.188" For GTX pro Bulk "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249"

Error message

Error code	Error message	Description	Remedy	Reference
1091	[Cap/Wiper Cleaning]	Cap and wiper need to be cleaned.	Clean the cap and wiper.	For GTX pro "7-1-3. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.188" For GTX pro Bulk "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249"
1092	[Wiper Cleaner Replacing White]	The wiper cleaner on the white side needs to be replaced with a new one.	Replace the wiper cleaner with a new one.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-5. Replacing the wiper cleaner >>P.261"
1093	[Wiper Cleaner Replacing White]	The wiper cleaner on the white side needs to be replaced with a new one.	Replace the wiper cleaner with a new one.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-5. Replacing the wiper cleaner >>P.261"
1095	[Wiper Cleaner Replacing Color]	The wiper cleaner on the color side needs to be replaced with a new one.	Replace the wiper cleaner with a new one.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-5. Replacing the wiper cleaner >>P.261"
1096	[Wiper Cleaner Replacing Color]	The wiper cleaner on the color side needs to be replaced with a new one.	Replace the wiper cleaner with a new one.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-5. Replacing the wiper cleaner >>P.261"
1100	[Pump Tube To Be Replaced]	Pump tube needs to be replaced.	Make note of the error code and error message, and please notify it to your dealer.	-

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Error code	Error message	Description	Remedy	Reference
1125	[Install White Ink After Cleaning]	Because the white head cleaning is performed, the Install White Ink After Cleaning function needs to be put into execution.	Install white ink after cleaning.	"10-2-2. White head cleaning >>P.330"
1202	[Remove the White Ink Cartridge and shake it]	The white ink needs to be stirred.	Pressing () after the stirring causes the White Ink Refilling function to be put into execution.	"6-2-3. Daily agitation of the white ink (For GTX pro only) >>P.131"
1210	[Exhaust Fan Stop]	The exhaust fan is not working.	Make note of the error code and error message, and please notify it to your dealer.	-
1501	[Fan Filter To Be Replaced]	The fan filter needs to be replaced with a new one.	Replace the fan filter with a new one.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-8. Replacing the fan filter >>P.272"
1601	[Flushing Foam Replacing White]	The flushing foam on the white side needs to be replaced with a new one.	Replace the flushing foam with a new one.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-6. Replacing the flushing foam >>P.264"
1602	[Flushing Foam Replacing White]	The flushing foam on the white side needs to be replaced with a new one.	Replace the flushing foam with a new one.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-6. Replacing the flushing foam >>P.264"

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Error message

Error code	Error message	Description	Remedy	Reference
1605	[Flushing Foam Replacing Color]	The flushing foam on the color side needs to be replaced with a new one.	Replace the flushing foam with a new one.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-6. Replacing the flushing foam >>P.264"
1606	[Flushing Foam Replacing Color]	The flushing foam on the color side needs to be replaced with a new one.	Replace the flushing foam with a new one.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-6. Replacing the flushing foam >>P.264"
1700	[Nozzle Guard Cleaning Timing]	The nozzle guard needs to be cleaned.	Clean the nozzle guard.	For GTX pro "7-1-3. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.188" For GTX pro Bulk "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249"
1701	[Nozzle Guard Cleaning Timing]	The nozzle guard needs to be cleaned.	Clean the nozzle guard.	For GTX pro "7-1-3. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.188" For GTX pro Bulk "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249"
1801	[None after head change (W)]	Because the white head replacement is made, the Install Ink after Replacing Head function needs to be put into execution.	Conduct the Install Ink after Replacing Head for the white head.	For GTX pro "10-2-6. Replacement of print head >>P.345" For GTX pro Bulk "11-2-5. Replacement of print head >>P.403"

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Error code	Error message	Description	Remedy	Reference
1802	[None after head change (KYCM)]	Because the color head replacement is made, the Install Ink after Replacing Head function needs to be put into execution.	Conduct the Install Ink after Replacing Head for the color head.	For GTX pro "10-2-6. Replacement of print head >>P.345" For GTX pro Bulk "11-2-5. Replacement of print head >>P.403"
1901	[Perform Initial Ink Installation]	The ink installation has not been performed yet.	Perform initial ink installation.	For GTX pro "10-2-8. Re-install the ink >>P.376" For GTX pro Bulk "11-2-7. Re-install the ink >>P.420"
1905	[Exit Disable White Ink]	An operation to temporarily stop the use of white ink is stopped in the middle.	Completely perform one of the referenced procedures.	"7-3-1. Disabling white ink >>P.223" "7-3-2. Reusing White Ink >>P.226"
2000	[Cartridge Not Set Black]	No black ink cartridge exists.	Place the black ink cartridge in position.	-
2001	[Cartridge Not Set Magenta]	No magenta ink cartridge exists.	Place the magenta ink cartridge in position.	-
2002	[Cartridge Not Set Cyan]	No cyan ink cartridge exists.	Place the cyan ink cartridge in position.	-
2003	[Cartridge Not Set Yellow]	No yellow ink cartridge exists.	Place the yellow ink cartridge in position.	-
2004	[Cartridge Not Set White-12]	No white 12 ink cartridge exists.	Place the white ink cartridge in position.	-
2005	[Cartridge Not Set White-34]	No white 34 ink cartridge exists.	Place the white ink cartridge in position.	-
2020	[No Ink Black]	The black ink pouch is empty.	Replace the old black ink pouch with a new one.	-
2021	[No Ink Magenta]	The magenta ink pouch is empty.	Replace the old magenta ink pouch with a new one.	-
2022	[No Ink Cyan]	The cyan ink pouch is empty.	Replace the old cyan ink pouch with a new one.	-
2023	[No Ink Yellow]	The yellow ink pouch is empty.	Replace the old yellow ink pouch with a new one.	-
2024	[No Ink White-12]	The white 12 ink pouch is empty.	Replace the old white ink pouch with a new one.	-
2025	[No Ink White-34]	The white 34 ink pouch is empty.	Replace the old white ink pouch with a new one.	-

Error code	Error message	Description	Remedy	Reference
2030	[Ink Pouch Error Black]	The black ink pouch cannot be identified properly.	Put a proper ink pouch in its correct position. Put an identifiable ink pouch in position inside the printer. If the problem still persists, please contact your dealer.	-
2031	[Ink Pouch Error Magenta]	The magenta ink pouch cannot be identified properly.	Put a proper ink pouch in its correct position. Put an identifiable ink pouch in position inside the printer. If the problem still persists, please contact your dealer.	-
2032	[Ink Pouch Error Cyan]	The cyan ink pouch cannot be identified properly.	Put a proper ink pouch in its correct position. Put an identifiable ink pouch in position inside the printer. If the problem still persists, please contact your dealer.	-
2033	[Ink Pouch Error Yellow]	The yellow ink pouch cannot be identified properly.	Put a proper ink pouch in its correct position. Put an identifiable ink pouch in position inside the printer. If the problem still persists, please contact your dealer.	-
2034	[Ink Pouch Error White 12]	The white 12 ink pouch cannot be identified properly.	Put a proper ink pouch in its correct position. Put an identifiable ink pouch in position inside the printer. If the problem still persists, please contact your dealer.	-
2035	[Ink Pouch Error White 34]	The white 34 ink pouch cannot be identified properly.	Put a proper ink pouch in its correct position. Put an identifiable ink pouch in position inside the printer. If the problem still persists, please contact your dealer.	-
2036	[Machine Error]	It is the read-out trouble of an ink pouch on the color side.	Make note of their error code and error message, and please notify it to your dealer.	-
2037	[Machine Error]	It is the read-out trouble of an ink pouch on the white side.	Make note of their error code and error message, and please notify it to your dealer.	-

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Error code	Error message	Description	Remedy	Reference
2041	[No Wiper Cleaner (CMYK)]	There is no wiper cleaner on the color side.	Place a wiper cleaner in position on the color side.	-
2042	[No Wiper Cleaner (White)]	There is no wiper cleaner on the white side.	Place a wiper cleaner in position on the white side.	-
2050	[Temp Low]	The ambient temperature decreases below the operation assurance range for the best print result.	Raise your room temperature.	"13-1. Apparatus >>P.473"
2051	[Temp High]	The ambient temperature rises above the operation assurance range for the best print result.	Lower your room temperature.	"13-1. Apparatus >>P.473"
2070	[Obstacle on the Platen]	The obstacle sensor has detected some obstacle on the platen or print medium.	Remove such obstacle from the platen, flatten its surface, and press for to clear the error.	-
2071	[Obstacle detected during printing]	Obstacle detected on the Platen during printing	Perform test printing and check the ejection from the head for any abnormalities. If the ejection is abnormal, immediately perform head cleaning to rectify the abnormality.	-
2072	[Platen is too low. Adjust it]	The platen was detected to be too low when attempting to start printing.	The gap between the medium's print surface and the print head is too large. Make adjustments by raising the platen.	-
2084	[White 12 Check The Cartridge]	The white 12 ink pouch may not be winded properly.	Take out the white 12 cartridge, open the cover, and have the ink pouch winded properly. Close the cover, set the ink pouch back to the printer, and press () to clear the error.	-

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Error code	Error message	Description	Remedy	Reference
2085	[White 34 Check The Cartridge]	The white 34 ink pouch may not be winded properly.	Take out the white 34 cartridge, open the cover, and have the ink pouch winded properly. Close the cover, set the ink pouch back to the printer, and press to clear the error.	-
2090	[Ink Pouch Error Black]	An error has been detected in the black ink pouch.	In that case, replace with a new ink pouch set.	-
2091	[Ink Pouch Error Magenta]	An error has been detected in the magenta ink pouch.	In that case, replace with a new ink pouch set.	-
2092	[Ink Pouch Error Cyan]	An error has been detected in the cyan ink pouch.	In that case, replace with a new ink pouch set.	-
2093	[Ink Pouch Error Yellow]	An error has been detected in the yellow ink pouch.	In that case, replace with a new ink pouch set.	-
2094	[Ink Pouch Error White 12]	An error has been detected in the white 12 ink pouch.	In that case, replace with a new ink pouch set.	-
2095	[Ink Pouch Error White 34]	An error has been detected in the white 34 ink pouch.	In that case, replace with a new ink pouch set.	-
2100	[USB flash drive Not Ready]	No USB flash memory been inserted into its insertion slot.	Insert a USB flash memory into the slot, wait for a couple of seconds, and perform the operation. Insert a USB flash memory into the slot again. If the problem still persists, check on the format and type of the USB flash memory.	For GTX pro "10-1. Troubleshooting instructions >>P.316" For GTX pro Bulk "11-1. Troubleshooting instructions >>P.380"
2101	[Not Enough Area]	At the writing stage to the USB flash memory there is not enough free space to store the data.	Use your PC to check free space on the USB flash memory. Insert the USB flash memory that has enough free space into the insertion slot.	-

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Error code	Error message	Description	Remedy	Reference
2105	[No Files]	No valid file exists in a USB flash memory.	Connect the USB flash memory to your PC for checking the information stored in it. If an ARXP or ARX4 file has been saved to it, check its content by means of the file viewer.	For GTX pro "10-1. Troubleshooting instructions >>P.316" For GTX pro Bulk "11-1. Troubleshooting instructions >>P.380"
2110	[Receiving History W/O Error1]	After the power is turned on, it is found that there is no print data received.	Press or to clear the error.	-
2120	[Print Data Auto Delete Enable]	Because the Print Data Auto Delete Enable function remains active, no receiving history is available.	Press for to clear the error. When you use the receiving history, disable the Auto Job Delete option.	-
2130	[White Ink Pause Mode… Non-performable]	Because the White Ink Pause Mode remains active, no white ink can be installed.	Press to clear the error. When you use the white ink, do not make the White Ink Pause Mode active.	-
2200	[Maintenance Pouch Set Black]	Although an ink pouch is needed, a maintenance solution pouch is set to the black cartridge.	Set an ink pouch to the black cartridge.	-
2201	[Maintenance Pouch Set Magenta]	Although an ink pouch is needed, a maintenance solution pouch is set to the magenta cartridge.	Set an ink pouch to the magenta cartridge.	-
2202	[Maintenance Pouch Set Cyan]	Although an ink pouch is needed, a maintenance solution pouch is set to the cyan cartridge.	Set an ink pouch to the cyan cartridge.	-
2203	[Maintenance Pouch Set Yellow]	Although an ink pouch is needed, a maintenance solution pouch is set to the yellow cartridge.	Set an ink pouch to the yellow cartridge.	-

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Error code	Error message	Description	Remedy	Reference
2204	[Maintenance Pouch Set White12]	Although an ink pouch is needed, a maintenance solution pouch is set to the white 12 cartridge.	Set the ink pouch to the white 12 cartridge.	-
2205	[Maintenance Pouch Set White34]	Although an ink pouch is needed, a maintenance solution pouch is set to the white 34 cartridge.	Set the ink pouch to the white 34 cartridge.	-
2214	[Ink Pouch Set White12]	Although a maintenance solution pouch is needed, an ink pouch is set to the white 12 cartridge.	Set the maintenance solution pouch to the white 12 cartridge.	-
2215	[Ink Pouch Set White34]	Although a maintenance solution pouch is needed, an ink pouch is set to the white 34 cartridge.	Set the maintenance solution pouch to the white 34 cartridge.	-
2230	[Replenishment to ink tank detected]	Ink was replenished to the ink tank (K) in an incorrect way.	Replenish the ink following the instructions on screen. To replenish the ink, be sure to select the [Replenish Ink] menu.	-
2231	[Replenishment to ink tank detected]	Ink was replenished to the ink tank (M) in an incorrect way.	Replenish the ink following the instructions on screen. To replenish the ink, be sure to select the [Replenish Ink] menu.	-
2232	[Replenishment to ink tank detected]	Ink was replenished to the ink tank (C) in an incorrect way.	Replenish the ink following the instructions on screen. To replenish the ink, be sure to select the [Replenish Ink] menu.	-
2233	[Replenishment to ink tank detected]	Ink was replenished to the ink tank (Y) in an incorrect way.	Replenish the ink following the instructions on screen. To replenish the ink, be sure to select the [Replenish Ink] menu.	-
2234	[Replenishment to ink tank detected]	Ink was replenished to the ink tank (W) in an incorrect way.	Replenish the ink following the instructions on screen. To replenish the ink, be sure to select the [Replenish Ink] menu.	-
2300	[Special operation mode]	Under the operation by the service man	If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
2310	[Perform test printing and check the ejection from the head]	Since the parts have been replaced, you have to perform test printing and check the ejection from the head.	Perform test printing following the on-screen instructions.	-
2320	[Perform test printing and check the ejection from the head]	Since 18 or more hours have passed, you have to perform test printing and check the ejection from the head.	Perform test printing following the on-screen instructions.	-
3000	[PC Communication Error]	Data reception from PC has suspended.	Make sure that your PC is connected to the printer, and resend the print data. If you have trouble in sending the data, restart your PC and the printer. This error will also occur "when the cable is removed during data reception" or "when the ongoing operation is canceled on the PC during data reception".	-
3001	[PC Communication Error]	Data transmission to PC has suspended.	Make sure that your PC is connected to the printer, and start operating the PC tool over from the beginning. If you have trouble in sending the data, restart your PC and the printer. This error may also occur "when the cable is removed during data transmission" or "when the PC tool is caused to stop running on the PC during data transmission".	_
3002	[PC Data Error]	The GT has received an unsupported data.	Make sure that your PC is connected to the printer, and resend the print data. If you have trouble in sending the data, restart your PC and the printer.	-
3003	[PC Data Error]	The version of printer driver disagrees with the firmware's version.	Update the firmware of the PC's printer driver as well as firmware of the printer to the latest version.	-

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Error code	Error message	Description	Remedy	Reference
3004	[PC Data Error]	It is the communication error between your PC and the printer.	Ascertain whether the updated data of firmware you try to send is correct or not. Make sure that your PC is connected to the printer, and start communication between your PC and the printer once again. If the problem is still not remedied, restart your PC and the printer. If the problem still persists, please contact your dealer.	-
3005	[PC Data Error]	It is the communication error between your PC and the printer.	Make sure that your PC is connected to the printer, and start communication between your PC and the printer once again. If the problem is still not remedied, restart your PC and the printer. If the problem still persists, please contact your dealer.	-
3010	[PC Data Error]	It is the communication error between your PC and the printer.	Make sure that your PC is connected to the printer, and start communication between your PC and the printer once again. If the problem is still not remedied, restart your PC and the printer. If the problem still persists, please contact your dealer.	-
3013	[PC Data Error]	It is the communication error between your PC and the printer.	Make sure that your PC is connected to the printer, and start communication between your PC and the printer once again. If the problem is still not remedied, restart your PC and the printer. If the problem still persists, please contact your dealer.	-
3014	[PC Data Error]	It is the communication error between your PC and the printer.	Make sure that your PC is connected to the printer, and start communication between your PC and the printer once again. If the problem is still not remedied, restart your PC and the printer. If the problem still persists, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
3015	[Can no longer receive data]	Too many print data has been sent from the PC during the print operation.	Number of the print data should be up to 99 during any print operation.	-
3100	[PC Data Error (with White)]	Such print data that uses the white ink was sent to the printer which is placed in the white ink pause mode.	On the setting screen of printer driver, verify that the ink selection is set to [Color Ink Only]. While the white ink pause mode remains active, any print data in which the white ink is included cannot be received.	_
3400	[PC Data Error]	In the print data, some command in incorrect command length is included.	Check on the ARXP file by means of "GTX pro File Viewer" Create the print data once again. If the problem still persists, please contact your dealer.	-
3401	[PC Data Error]	In the print data, some undefined command is included.	Check on the ARXP file by means of "GTX pro File Viewer" Create the print data once again. If the problem still persists, please contact your dealer.	-
3402	[PC Data Error]	It is the sequence error in the print data.	Check on the ARXP file by means of "GTX pro File Viewer" Create the print data once again. If the problem still persists, please contact your dealer.	-
3407	[Blank Data]	• •	Check on the ARXP file by means of "GTX pro File Viewer" For example, please confirm the print range and paper size for your software application through the Print Preview function, etc. of Photoshop.	

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Error code	Error message	Description	Remedy	Reference
3408	[PC Data Error (too large)]	The print data capacity is too large.	Make note of their error code and error message, and please notify it to your dealer.	-
3410	[PC Data Error]	It is the communication error between your PC and the printer.	Check on the ARXP file by means of "GTX pro File Viewer" Make sure that your PC is connected to the printer, and start communication between your PC and the printer once again. Restart your PC and the printer. If the problem still persists, please contact your dealer.	-
3411	[PC Data Error]	It is the communication error between your PC and the printer.	Check on the ARXP file by means of "GTX pro File Viewer" Make sure that your PC is connected to the printer, and start communication between your PC and the printer once again. Restart your PC and the printer. If the problem still persists, please contact your dealer.	-
3412	[PC Data Error]	It is the communication error between your PC and the printer.	Check on the ARXP file by means of "GTX pro File Viewer" Make sure that your PC is connected to the printer, and start communication between your PC and the printer once again. Restart your PC and the printer. If the problem still persists, please contact your dealer.	-
4100	[USB flash drive Access Error]	No file can be opened.	Check on the content of USB flash memory. Insert a USB flash memory into the slot again, and perform the required operation once more. If the problem is still not remedied, restart the printer and try to operate it once again.	For GTX pro "10-1. Troubleshooting instructions >>P.316" For GTX pro Bulk "11-1. Troubleshooting instructions >>P.380"

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Error code	Error message	Description	Remedy	Reference
4101	[USB flash drive Access Error]	No file can be created.	Check on the content of USB flash memory. Insert a USB flash memory into the slot again, and perform the required operation once more. If the problem is still not remedied, restart the printer and try to operate it once again.	For GTX pro "10-1. Troubleshooting instructions >>P.316" For GTX pro Bulk "11-1. Troubleshooting instructions >>P.380"
4103	[USB flash drive Access Error]	File search has ended up in failure.	Check on the content of USB flash memory. Insert a USB flash memory into the slot again, and perform the required operation once more. If the problem is still not remedied, restart the printer and try to operate it once again.	For GTX pro "10-1. Troubleshooting instructions >>P.316" For GTX pro Bulk "11-1. Troubleshooting instructions >>P.380"
4104	[USB flash drive Access Error]	The system has failed to read the file.	Check on the content of USB flash memory. Insert a USB flash memory into the slot again, and perform the required operation once more. If the problem is still not remedied, restart the printer and try to operate it once again.	For GTX pro "10-1. Troubleshooting instructions >>P.316" For GTX pro Bulk "11-1. Troubleshooting instructions >>P.380"
4105	[USB flash drive Access Error]	The system has failed to write the file.	Check on the content of USB flash memory. Insert a USB flash memory into the slot again, and perform the required operation once more. If the problem is still not remedied, restart the printer and try to operate it once again.	For GTX pro "10-1. Troubleshooting instructions >>P.316" For GTX pro Bulk "11-1. Troubleshooting instructions >>P.380"
4106	[Illegal Format]	There is something wrong with the file's data.	Check on the content of USB flash memory. Insert a USB flash memory into the slot again, and perform the required operation once more. If the problem is still not remedied, restart the printer and try to operate it once again.	For GTX pro "10-1. Troubleshooting instructions >>P.316" For GTX pro Bulk "11-1. Troubleshooting instructions >>P.380"

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Error code	Error message	Description	Remedy	Reference
4108	[USB flash drive Access Error]	The system has failed to obtain the file size.	Check on the content of USB flash memory. Insert a USB flash memory into the slot again, and perform the required operation once more. If the problem is still not remedied, restart the printer and try to operate it once again.	For GTX pro "10-1. Troubleshooting instructions >>P.316" For GTX pro Bulk "11-1. Troubleshooting instructions >>P.380"
4200	[Machine Error]	Abnormal indication is found in the language data on the LCD screen.	In the event that this error is displayed after suspending the updating of firmware, please start the updating operation over from the beginning. If the problem still persists, please contact your dealer.	-
4201	[Machine Error]	Abnormal indication is found in the language data on the LCD screen.	In the event that this error is displayed after suspending the updating of firmware, please start the updating operation over from the beginning. If the problem still persists, please contact your dealer.	-
4202	[Machine Error]	Abnormal indication is found in the language data on the LCD screen.	In the event that this error is displayed after suspending the updating of firmware, please start the updating operation over from the beginning. If the problem still persists, please contact your dealer.	-
4400	[Test print data Error]	An error is detected in the print data for test print menu.	In the event that this error is displayed after suspending the updating of firmware, please start the updating operation over from the beginning. If the problem still persists, please contact your dealer.	-
4401	[Test print data Error]	An error is detected in the print data for test print menu.	In the event that this error is displayed after suspending the updating of firmware, please start the updating operation over from the beginning. If the problem still persists, please contact your dealer.	-

Error code	Error message	Description	Remedy	Reference
4402	[Test print data Error]	An error is detected in the print data for test print menu.	In the event that this error is displayed after suspending the updating of firmware, please start the updating operation over from the beginning. If the problem still persists, please contact your dealer.	-
4500	[Network error]	The network interface was unable to be activated.	Press to clear the error. Contact your network setup manager and network administrator. If the problem still persists, please contact your dealer.	-
4501	[Network error]	An error has been detected in the static IP address setting and subnet mask value.	Press (IFW) to clear the error. Use the maintenance tool to set up a correct static IP address and subnet mask value once again.	-
4502	[Network error]	The network interface setting has ended up in failure.	Press to clear the error. Contact your network setup manager and network administrator. If the problem still persists, please contact your dealer.	-
4503	[Network error]	An error was found in the static IP address of the default gateway.	Press (KERU) to clear the error. Use the maintenance tool to set up a correct static IP address of default gateway once again.	-
4504	[Network error]	It is the error of static IP address setup value.	Press (Content of the error) to clear the error. Use the maintenance tool to set up a correct static IP address and subnet mask value once again.	-
4506	[No Enable Restore Data]	No data can be restored because its backup copy was not made.	Make note of the error code and error message, and please notify it to your dealer.	-

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Error message

Error code	Error message	Description	Remedy	Reference
4510	[Network error]	Error in configuring the network for the printer	Press very to clear the error. Check the network settings. Contact your network setup manager if you have a question.	-
5001	[Machine Error]	A timeout has occurred at the time of initialization.	Make note of the error code and error message, and please notify it to your dealer.	-
5010	[PC Data Error]	An error is detected in the current print data being run.	Press to clear the error. Create the print data again on the PC to load it to the printer, and try the print operation again.	-
5020	[Machine Error]	The carriage movement was not completed.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5021	[Machine Error]	Head operation is incomplete.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5022	[Machine Error]	Head operation is incomplete.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5080	[Machine Error]	Maintenance unit operation is incomplete.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5081	[Machine Error]	Maintenance unit operation is incomplete.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5094	[Machine Error]	The platen cannot be moved toward the rear of the printer.	Make note of the error code and error message, and please notify it to your dealer.	-
5095	[Machine Error]	The platen cannot be moved toward the front of the printer.	Make note of the error code and error message, and please notify it to your dealer.	-
5096	[Machine Error]	The platen cannot be rolled.	Make note of the error code and error message, and please notify it to your dealer.	-

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Error code	Error message	Description	Remedy	Reference
5200	[Machine Error]	It is the communication error between the main board and the maintenance unit.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5201	[Machine Error]	It is the communication error between the main board and the maintenance unit.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5230	[Machine Error]	It is the communication error between the main board and the maintenance unit.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5231	[Machine Error]	It is the communication error between the main board and the maintenance unit.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5232	[Machine Error]	It is the communication error between the main board and the maintenance unit.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5233	[Machine Error]	It is the communication error between the main board and the maintenance unit.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5240	[Machine Error]	It is the communication error between the main board and the maintenance unit.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
5241	[Machine Error]	It is the communication error between the main board and the maintenance unit.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5250	[Machine Error]	The program data of the firmware of maintenance unit, which you try to update, has been found to be defective.	As it is likely that the firmware's file is corrupted, obtain a proper file of the firmware which is not corrupted. If the problem still persists even after restarting the printer and your PC, please contact your dealer.	-
5260	[Machine Error]	A version of the firmware of maintenance unit is incompatible.	In the event that this error is displayed after suspending the updating of firmware, please start the updating operation over from the beginning. If the problem still persists, please contact your dealer.	-
5261	[Machine Error]	The printer is connected to a maintenance board for a different model.	Restart the printer and update the firmware again. Check if the firmware update file is for the model of your printer. If the problem still persists, please contact your dealer.	-
5301	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5302	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5303	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

Error code	Error message	Description	Remedy	Reference
5304	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5305	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5306	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5307	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5311	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5312	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5313	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

Error code	Error message	Description	Remedy	Reference
5314	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5320	[Machine Error]	The cam of the maintenance unit (on the color side) malfunctions.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5321	[Machine Error]	The cam of the maintenance unit (on the color side) malfunctions.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5322	[Machine Error]	The cam of the maintenance unit (on the color side) malfunctions.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5323	[Machine Error]	The cam of the maintenance unit (on the color side) malfunctions.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5330	[Machine Error]	The wiper of the maintenance unit (on the color side) malfunctions.	Check to see if the wiper is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5331	[Machine Error]	The wiper of the maintenance unit (on the color side) malfunctions.	Check to see if the wiper is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5332	[Machine Error]	The wiper of the maintenance unit (on the color side) malfunctions.	Check to see if the wiper is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
5333	[Machine Error]	The wiper of the maintenance unit (on the color side) malfunctions.	Check to see if the wiper is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5340	[Machine Error]	The wiper of the maintenance unit (on the color side) malfunctions.	Check to see if the wiper is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5341	[Machine Error]	The wiper of the maintenance unit (on the color side) malfunctions.	Check to see if the wiper is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5342	[Machine Error]	The wiper of the maintenance unit (on the color side) malfunctions.	Check to see if the wiper is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5343	[Machine Error]	The wiper of the maintenance unit (on the color side) malfunctions.	Check to see if the wiper is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5350	[Machine Error]	It is an internal error of the maintenance unit (on the color side), which is associated with updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
5351	[Machine Error]	It is an internal error of the maintenance unit (on the color side), which is associated with updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5352	[Machine Error]	It is an internal error of the maintenance unit (on the color side), which is associated with updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5353	[Machine Error]	It is an internal error of the maintenance unit (on the color side), which is associated with updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5354	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side), which is associated with the updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5355	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side), which is associated with the updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5356	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side), which is associated with the updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-

Error code	Error message	Description	Remedy	Reference
5357	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the color side), which is associated with the updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5358	[Machine Error]	It is an internal error of the maintenance unit (on the color side), which is associated with updating of firmware.	Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5359	[Machine Error]	It is an internal error of the maintenance unit (on the color side), which is associated with updating of firmware.	Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5361	[Machine Error]	When the solenoid is in operation, there is a mismatch between the main board and the maintenance unit (on the color side).	Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5391	[Machine Error]	It is the internal error of the maintenance unit (on the color side).	Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5401	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5402	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
5403	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5404	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5405	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5406	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5407	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5411	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5412	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
5413	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5414	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5420	[Machine Error]	The cam of the maintenance unit (on the white side) malfunctions.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5421	[Machine Error]	The cam of the maintenance unit (on the white side) malfunctions.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5422	[Machine Error]	The cam of the maintenance unit (on the white side) malfunctions.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5423	[Machine Error]	The cam of the maintenance unit (on the white side) malfunctions.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5430	[Machine Error]	The wiper cleaner of the maintenance unit (on the white side) malfunctions.	Check to see if the wiper cleaner is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5431	[Machine Error]	The wiper cleaner of the maintenance unit (on the white side) malfunctions.	Check to see if the wiper cleaner is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
5432	[Machine Error]	The wiper cleaner of the maintenance unit (on the white side) malfunctions.	Check to see if the wiper cleaner is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5433	[Machine Error]	The wiper cleaner of the maintenance unit (on the white side) malfunctions.	Check to see if the wiper cleaner is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5440	[Machine Error]	The wiper of the maintenance unit (on the white side) malfunctions.	Check to see if the wiper is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5441	[Machine Error]	The wiper of the maintenance unit (on the white side) malfunctions.	Check to see if the wiper is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5442	[Machine Error]	The wiper of the maintenance unit (on the white side) malfunctions.	Check to see if the wiper is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-
5443	[Machine Error]	The wiper of the maintenance unit (on the white side) malfunctions.	Check to see if the wiper is properly installed and there is no obstacle around the wiper or wiper cleaner. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
5450	[Machine Error]	It is an internal error of the maintenance unit (on the white side), which is associated with updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5451	[Machine Error]	It is an internal error of the maintenance unit (on the white side), which is associated with updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5452	[Machine Error]	It is an internal error of the maintenance unit (on the white side), which is associated with updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5453	[Machine Error]	It is an internal error of the maintenance unit (on the white side), which is associated with updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5454	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side), which is associated with the updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5455	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side), which is associated with the updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
5456	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side), which is associated with the updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5457	[Machine Error]	It is the communication error between the main board and the maintenance unit (on the white side), which is associated with the updating of firmware.	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5458	[Machine Error]	It is an internal error of the maintenance unit (on the white side), which is associated with updating of firmware.	Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5459	[Machine Error]	It is an internal error of the maintenance unit (on the white side), which is associated with updating of firmware.	Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5461	[Machine Error]	When the solenoid is in operation, there is a mismatch between the state of the main board and that of the maintenance unit (on the white side).	Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
5471	[Machine Error]	It is the communication error between the maintenance unit (on the white side) and the cartridge sensor.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
5472	[Machine Error]	It is the communication error between the maintenance unit (on the white side) and the cartridge sensor.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5473	[Machine Error]	It is the communication error between the maintenance unit (on the white side) and the cartridge sensor.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5474	[Machine Error]	It is the communication error between the maintenance unit (on the white side) and the cartridge sensor.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5475	[Machine Error]	It is the communication error between the maintenance unit (on the white side) and the cartridge sensor.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5476	[Machine Error]	It is the communication error between the maintenance unit (on the white side) and the cartridge sensor.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5477	[Machine Error]	It is the communication error between the maintenance unit (on the white side) and the cartridge sensor.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5478	[Machine Error]	It is the communication error between the maintenance unit (on the white side) and the cartridge sensor.	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
5491	[Machine Error]	It is the internal error of the maintenance unit (on the white side).	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
5501	[Machine Error]	The sub tank of black ink is not filled with black ink.	Check the ink pouch (black) for any abnormalities.	-
5502	[Machine Error]	The sub tank of magenta ink is not filled with magenta ink.	Check the ink pouch (magenta) for any abnormalities.	-
5503	[Machine Error]	The sub tank of cyan ink is not filled with cyan ink.	Check the ink pouch (cyan) for any abnormalities.	-
5504	[Machine Error]	The sub tank of yellow ink is not filled with yellow ink.	Check the ink pouch (yellow) for any abnormalities.	-
5520	[Machine Error]	Failed to calibrate the winding sensor	Remove the ink cartridge, check winding, and then install the cartridge correctly. If the problem still persists even after restarting the printer, please contact your dealer.	-
5600	[Machine Error]	Ink pouch was identified with abnormal timing at the time of initialization.	If the problem still persists even after restarting the printer, please contact your dealer.	-
5601	[Machine Error]	An abnormality was detected when tried to check the ink pouch.	Check if the ink pouch is seated on the ink cartridge correctly. Ensure that the ink cartridge is correctly placed on the printer. If the problem still persists even after restarting the printer, please contact your dealer.	-
5602	[Machine Error]	An abnormality was detected when tried to check the ink pouch.	Check if the ink pouch is seated on the ink cartridge correctly. Ensure that the ink cartridge is correctly placed on the printer. If the problem still persists even after restarting the printer, please contact your dealer.	-

Error code	Error message	Description	Remedy	Reference
5603	[Machine Error]	An abnormality was detected when tried to check the ink pouch.	Check if the ink pouch is seated on the ink cartridge correctly. Ensure that the ink cartridge is correctly placed on the printer. If the problem still persists even after restarting the printer, please contact your dealer.	-
5801	[Machine Error]	It is the communication error between the main board and the panel board or the head board.	Check to see if there is any source near the printer that produces a loud noise. If a USB flash memory is inserted into the printer, remove the memory first, and then restart the printer. If the problem still persists even after restarting the printer, please contact your dealer.	-
5802	[Machine Error]	It is the communication error between the main board and the panel board or the head board.	Check to see if there is any source near the printer that produces a loud noise. If a USB flash memory is inserted into the printer, remove the memory first, and then restart the printer. If the problem still persists even after restarting the printer, please contact your dealer.	-
5803	[Machine Error]	It is the communication error between the main board and the panel board or the head board.	Check to see if there is any source near the printer that produces a loud noise. If a USB flash memory is inserted into the printer, remove the memory first, and then restart the printer. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error message

Error code	Error message	Description	Remedy	Reference
5804	[Machine Error]	It is the communication error between the main board and the panel board or the head board.	Check to see if there is any source near the printer that produces a loud noise. If a USB flash memory is inserted into the printer, remove the memory first, and then restart the printer. If the problem still persists even after restarting the printer, please contact your dealer.	-
6004	[Obstacle on the Platen]	It indicates some error in the obstacle sensor.	Check to see if the obstacle sensor is covered with something. If the problem still persists even after restarting the printer, please contact your dealer.	-
6010	[PC Data Error]	The system failed to write the EEPROM of the main board.	Make note of their error code and error message, and please notify it to your dealer.	-
6011	[Machine Error]	The system failed to erase the FLASH ROM of the main board.	Make note of the error code and error message, and please notify it to your dealer.	-
6012	[Machine Error]	The system failed to write the FLASH ROM of the main board.	Make note of the error code and error message, and please notify it to your dealer.	-
6021	[No Battery]	The battery of the real-time clock is fully exhausted.	Make note of the error code and error message, and please notify it to your dealer.	-
6031	[Machine Error]	Platen button is out of working order.	Ascertain whether or not something is placed on the operation panel. For help, please contact your dealer.	-
6032	[Machine Error]	Print button is out of working order.	Ascertain whether or not something is placed on the operation panel. For help, please contact your dealer.	-
6033	[Machine Error]	Stop button is out of working order.	Ascertain whether or not something is placed on the operation panel. For help, please contact your dealer.	-

Error code	Error message	Description	Remedy	Reference
6034	[Machine Error]	Back button is out of working order.	Ascertain whether or not something is placed on the operation panel. For help, please contact your dealer.	-
6035	[Machine Error]	Right button is out of working order.	Ascertain whether or not something is placed on the operation panel. For help, please contact your dealer.	-
6036	[Machine Error]	Down button is out of working order.	Ascertain whether or not something is placed on the operation panel. For help, please contact your dealer.	-
6037	[Machine Error]	Up button is out of working order.	Ascertain whether or not something is placed on the operation panel. For help, please contact your dealer.	-
6038	[Machine Error]	Head cleaning button is out of working order.	Ascertain whether or not something is placed on the operation panel. For help, please contact your dealer.	-
6039	[Machine Error]	MENU/OK button is out of working order.	Ascertain whether or not something is placed on the operation panel. For help, please contact your dealer.	-
6045	[Machine Error]	The printer is connected to a maintenance board for a different model.	Restart the printer and update the firmware again. Check if the firmware update file is for the model of your printer. If the problem still persists, please contact your dealer.	-
6046	[Machine Error]	The LCD panel firmware version is not compatible with the main firmware version.	Restart the printer and update the firmware again. Check if the firmware update file is for the model of your printer. If the problem still persists, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
6050	[Machine Error]	The winding sensor was detected to be faulty	Remove the ink cartridge, check winding, and then install the cartridge correctly. If the problem still persists even after restarting the printer, please contact your dealer.	-
6060	[Machine Error]	An Ethernet related hardware error was detected during startup	If the problem still persists even after restarting the printer, please contact your dealer.	-
6090	[Machine Error]	The main board was not initialized sufficiently	If the problem still persists even after restarting the printer, please contact your dealer.	-
6101	[Machine Error]	It indicates the carriage's malfunction.	If the problem still persists even after reactivating the printer, please contact your dealer.	-
6102	[Machine Error]	The carriage stops at an incorrect position.	Check to see if something gets caught in the carriage or any foreign object exists inside the printer. If the problem still persists, please contact your dealer.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"
6103	[Machine Error]	No cap can be locked in place.	Check to see if something gets caught in the carriage or any foreign object exists inside the printer. If the problem still persists, please contact your dealer.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"
6104	[Machine Error]	Carriage does not move.	Check to see if something gets caught in the carriage or any foreign object exists inside the printer. If the problem still persists, please contact your dealer.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"

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Error message

Error code	Error message	Description	Remedy	Reference
6105	[Machine Error]	The carriage's home position return initialization has ended up in failure.	Check to see if something gets caught in the carriage or any foreign object exists inside the printer. If the problem still persists, please contact your dealer.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"
6106	[Machine Error]	The carriage has bumped against the frame.	Check to see if something gets caught in the carriage or any foreign object exists inside the printer. If the problem still persists, please contact your dealer.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"
6107	[Machine Error]	The carriage's reverse rotation has been detected.	Check to see if something gets caught in the carriage or any foreign object exists inside the printer. If the problem still persists, please contact your dealer.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"
6108	[Machine Error]	Abnormal decrease in the speed of carriage has been detected.	Check to see if something gets caught in the carriage or any foreign object exists inside the printer. If the problem still persists, please contact your dealer.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"
6109	[Machine Error]	The carriage has stopped abnormally within the print range.	Check to see if something gets caught in the carriage or any foreign object exists inside the printer. If the problem still persists, please contact your dealer.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"

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Error message

Error code	Error message	Description	Remedy	Reference
6110	[Machine Error]	The carriage cannot move out of its locked position.	Check to see if something gets caught in the carriage or any foreign object exists inside the printer. If the problem still persists, please contact your dealer.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"
6111	[Machine Error]	Carriage cannot perform capping.	Check to see if something gets caught in the carriage or any foreign object exists inside the printer. If the problem still persists, please contact your dealer.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"
6119	[Machine Error]	The carriage movement does not come to a full stop.	If the problem still persists even after restarting the printer, please contact your dealer.	-
6130	[Machine Error Adjust CR]	It indicates an abnormal decrease in the speed of carriage.	Clean the carriage. Then, adjust the carriage speed.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"
6131	[Machine Error Adjust CR]	It indicates an excessive increase in the speed of carriage.	Clean the carriage. Then, adjust the carriage speed.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267" For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-3-1. CR (Carriage) speed adjustment >>P.285"

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Error message

Error code	Error message	Description	Remedy	Reference
6132	[Machine Error Adjust CR]	The carriage stops at an incorrect position.	Clean the carriage. Then, adjust the carriage speed.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267" For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-3-1. CR (Carriage) speed adjustment >>P.285"
6133	[Machine Error]	It indicates an error in the carriage speed adjustment (reverse motion).	Clean the carriage. Then, adjust the carriage speed.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"
6134	[Machine Error]	It indicates an error in the carriage speed adjustment (forward motion).	Clean the carriage. Then, adjust the carriage speed.	For GTX pro "8-1-4. Cleaning the nozzle guard, wiper, exhaust cap, and suction cap >>P.249" For GTX pro Bulk "8-1-7. Cleaning the internal area of printer >>P.267"
6220	[Machine Error]	The color heads' temperature level is abnormal.	Ascertain whether or not the cable for the heads is disconnected. If the problem still persists even after restarting the printer, please contact your dealer.	-
6221	[Machine Error]	The white heads' temperature level is abnormal.	Ascertain whether or not the cable for the heads is disconnected. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
6230	[Machine Error]	It refers to abnormal voltage in the color heads.	Ascertain whether or not the cable for the heads is disconnected. If the problem still persists, please contact your dealer.	-
6231	[Machine Error]	It refers to abnormal voltage in the white heads.	Ascertain whether or not the cable for the heads is disconnected. If the problem still persists, please contact your dealer.	-
6240	[Machine Error]	It refers to FFC failure in the color heads.	Ascertain whether or not the cable for the heads is disconnected. If the problem still persists even after restarting the printer, please contact your dealer.	-
6241	[Machine Error]	It refers to FFC failure in the white heads.	Ascertain whether or not the cable for the heads is disconnected. If the problem still persists even after reactivating the printer, please contact your dealer.	-
7000	[Machine Error]	It is the system call error.	Make note of the error code and error message, and please notify it to your dealer.	-
7012	[Machine Error]	Firmware internal error occurred.	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	_
7013	[Machine Error]	It is the general program error.	Make note of the error code and error message, and please notify it to your dealer.	-
7015	[Machine Error]	Because the ongoing print operation remains unfinished, the next print data cannot be printed out.	Send any print data to the printer while the printer is not performing the printing operation.	-
7020	[Machine Error]	Internal error related to white ink circulation	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-

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Error code	Error message	Description	Remedy	Reference
7021	[Machine Error]	Internal error related to white ink agitation	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	_
8000	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8001	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8002	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8003	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	_
8004	[Machine Error]	The firmware on the bottle board is faulty	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	_
8010	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

Error code	Error message	Description	Remedy	Reference
8011	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	_
8012	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	_
8013	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	_
8020	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8021	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	_
8030	[Machine Error]	Failed to fill the sub tank with ink (K)	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8031	[Machine Error]	Failed to fill the sub tank with ink (Y)	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
8032	[Machine Error]	Failed to fill the sub tank with ink (C)	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8033	[Machine Error]	Failed to fill the sub tank with ink (M)	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8034	[Machine Error]	Failed to fill the sub tank with ink (W)	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8035	[Machine Error]	Communication error between the main board and the bottle board during the circulation through the sub tank	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8036	[Machine Error]	Communication error between the main board and the bottle board during the circulation thorough the tank	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8037	[Machine Error]	Communication error between the main board and the bottle board during the tank agitation	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8039	[Machine Error]	Communication error between the main board and the bottle board during the filling of cleaning solution	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
8040	[Machine Error]	Sub tank remaining volume sensor was detected to be faulty (K)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8041	[Machine Error]	Sub tank remaining volume sensor was detected to be faulty (Y)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8042	[Machine Error]	Sub tank remaining volume sensor was detected to be faulty (C)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8043	[Machine Error]	Sub tank remaining volume sensor was detected to be faulty (M)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8044	[Machine Error]	Sub tank remaining volume sensor was detected to be faulty (W)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8050	[Machine Error]	Failed to discharge air from sub pouch (K)	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8051	[Machine Error]	Failed to discharge air from sub pouch (Y)	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8052	[Machine Error]	Failed to discharge air from sub pouch (C)	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
8053	[Machine Error]	Failed to discharge air from sub pouch (M)	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
8054	[Machine Error]	Failed to discharge air from sub pouch (W)	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8060	[Machine Error]	Failed to fill the sub tank with ink (K)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8061	[Machine Error]	Failed to fill the sub tank with ink (Y)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8062	[Machine Error]	Failed to fill the sub tank with ink (C)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8063	[Machine Error]	Failed to fill the sub tank with ink (M)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8064	[Machine Error]	Failed to fill the sub tank with ink (W)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8065	[Machine Error]	Failed to fill the cleaning solution sub tank with cleaning solution	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8070	[Machine Error]	Failed to discharge ink from the sub tank (K)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-

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Error code	Error message	Description	Remedy	Reference
8071	[Machine Error]	Failed to discharge ink from the sub tank (Y)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8072	[Machine Error]	Failed to discharge ink from the sub tank (C)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8073	[Machine Error]	Failed to discharge ink from the sub tank (M)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8074	[Machine Error]	Failed to discharge ink from the sub tank (W)	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8090	[Machine Error]	The firmware update data for the bottle board is faulty	Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
8101	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
8102	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8103	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
8111	[Machine Error]	Communication error between the bottle board and the bottle support board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8112	[Machine Error]	Communication error between the bottle board and the bottle support board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8113	[Machine Error]	Communication error between the bottle board and the bottle support board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8114	[Machine Error]	Communication error between the bottle board and the bottle support board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8121	[Machine Error]	An error occurred in the motor control from the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8122	[Machine Error]	An error occurred in the motor control from the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8123	[Machine Error]	The white ink tank agitation motor does not rotate	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

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Error code	Error message	Description	Remedy	Reference
8181	[Machine Error]	The bottle firmware update data was faulty	Restart the printer and update the firmware again. If the problem still persists, please contact your dealer.	-
8182	[Machine Error]	Version mismatch between the bottle board and the main board	If the problem still persists even after restarting the printer, please contact your dealer after noting the error code and message displayed.	-
8191	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8192	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8193	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8194	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-
8199	[Machine Error]	Communication error between the main board and the bottle board	Check to see if there is any source near the printer that produces a loud noise. If the problem still persists even after restarting the printer, please contact your dealer.	-

In the event that other error codes than those that are mentioned above are displayed or that any of the above-mentioned errors cannot be remedied even by following the troubleshooting procedures, please contact your dealer for help.

13-1. Apparatus

GTX pro

Printing method			Direct cloth printing by a	color ink jet printing
Head	1	antity	2-piece set	
Resolution		kimum	1200dpi×1200dpi	
Туре		ype	Water-based ink	
Ink		r of colors	5 colors of CMYKW	
Material supply	method		Platen transportation m	ethod
Supported		Size	14 in. (355.6 mm) x 16	in. (406.4 mm) (standard platen)
media	Thio	kness	Up to 1.1 in. (30 mm)	
(size/thickness)				
Printable area	Max	kimum	16 in. (406.4 mm) x 21	in. (533.4 mm)
Interface			USB 2.0, LAN (10BASE	E-T, 100BASE-TX, 1000BASE-T), USB memory
External dimens	ions		55.1 in. (width) x 51.1 ir	n. (depth) x 21.6 in. (height) (1400 mm (width) x 1300
			mm (depth) x 550 mm ((height))
Weight			120 kg (264 lb) (includir	ng platen)
	P	ower	Single phase, 100 V-24	0 V, 50/60 Hz
	P	ower	When active: 80 W max	х.
	Consu	umptions		
		Recomm	Temperature: 18 to	
		ended	30°C (64.4 to 86°F)	Printing-guaranteed range
		Print	Humidity: 35 to 85%	Humidity (%) Operating your printer Keeping your printer
		environ	(No condensation	85 - 80 -
Installation	Tempe	ment	should occur.)	
conditions	rature		Temperature: 10 to	70 -
Working	and	Working	35°C (50 to 95°F)	60 -
environment	humidit	environ	Humidity: 20 to 85%	50 -
	у	ment	(No condensation	
	Enviro		should occur.)	40 - 37 - 35 -
	nment		Temperature: 0 to	30 -
		Storage	40°C (32 to 104°F)	20 - Temperature
		environ	Humidity: 20 to 85%	
		ment	(No condensation	10 15 18 20 25 2930 35 40
			should occur.)	(50 59 68 77 86 95 104 (°F)) _{X0394}
Print direction			Bidirectional, unidirection	onal
			Conveyor oven (recom	mended): $160^{\circ}C$ ($320^{\circ}F$) for 3.5 minutes, or heat press:
Fixation conditions		180°C (356°F) for 35 seconds		
			* The time taken for fixa	ation differs depending on the fixation device.
			Pretreatment is required	d when you print using white ink.
Pretreatment			Apply pretreatment with	n a roller or pretreatment device and dry it up with a heat
			press.	
	-			

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GTX pro Bulk

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Drinting mothe	.d		Direct cloth printing by	color ink interinting	
Printing method Head Quantity		Direct cloth printing by			
	-		2-piece set		
Resolution Maximum		1200dpi×1200dpi			
Ink		уре	Water-based ink		
		er of colors	5 colors of CMYKW		
Material supply			Platen transportation m		
Supported		Size	14 in. (355.6 mm) x 16	in. (406.4 mm) (standard	d platen)
media	Thio	ckness	Up to 1.1 in. (30 mm)		
(size/thickness	s)				
Printable area	Max	ximum	16 in. (406.4 mm) x 21	in. (533.4 mm)	
Interface			USB 2.0, LAN (10BAS	E-T, 100BASE-TX, 1000	BASE-T), USB memory
External dimer	nsions		70 in. (width) x 51.1 in.	(depth) x 47.6 in. (height	t) (1780 mm (width) x 1300 mm
			(depth) x 1210 mm (he	ight))	
			* When equipped with t	the recommended table	
Weight			160 kg (352 lb) (includi	ng platen)	
			* Main body 120 kg (26	4 lb) and tank unit 40 kg	(88 lb)
	Po	wer	Single phase, 100 V-24	0 V, 50/60 Hz	
	Po	wer	When active: 160 W m	ax.	
	Consu	mptions			
		Recomm	Temperature: 18 to		
		ended	30°C (64.4 to 86°F)		Printing-guaranteed range
		print	Humidity: 35 to 85%	Humidity (%)	 Operating your printer Keeping your printer
		environ	(No condensation	85 -	
Installation		ment	should occur.)	80 -	
conditions	Tempera		Temperature: 10 to	70 -	
working	ture and	Working	35°C (50 to 95°F)	60 -	
environment	humidity	environ	Humidity: 20 to 85%	50 –	
	environ	ment	(No condensation		
	ment		should occur.)	40 - 37 - 35 -	
			Temperature: 0 to	35 30 -	
		Storage	40°C (32 to 104°F)	20 -	
		environ	Humidity: 20 to 85%		Temperature
		ment	(No condensation	10 15 18 20	25 2930 35 40 (°C)
			should occur.)	(50 59 68	77 86 95 104 (°F)) _{X0394}
Print direction	1	L	Bidirectional, unidirection	onal	
) for 3.5 minutes, or heat press:
Fixation condit	Fixation conditions		180°C (356°F) for 35 s		,, p. ••••
			ation differs depending o	n the fixation device.	
				d when you print using v	
Pretreatment				• • •	device and dry it up with a heat
ricucaunent					active and dry it up with a field
			press.		

13-2. Software

OS	macOS 10.14 Mojave、macOS 10.15 Catalina、
03	Windows 8.1 (64bit) 、Windows 10 (64bit)
Min energting on vironment	CPU with 2 GHz or above
Min. operating environment	RAM with 4 GB or above
Display resolution	XGA (1024 x 768) or higher
Output	Printer driver, GTX Graphics Lab
Recommended application software	Adobe [®] Photoshop CC2020/CC2019、Adobe [®] Illustrator CC2020/CC2019、
for high-level image editing	CoreIDRAW [®] 2018/2019 (for Windows)

13-3. Ink, maintenance solution, cleaning solution, pretreatment

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13-3-1. Ink

GTX pro

Name		Black / Magenta / Cyan / Yellow ink pouch	
Use expiration date		Expiration date on the pouch pack (supposing storage at normal temperature)	
Storage temperat	ure	0 to 40°C (32 to 104°F)	
		- Store them in a place where they are not exposed to direct sunlight.	
Cautions for stora	ige	- Keep them out of the reach of children.	
		- Store them away from fire, heat and oxidized substance.	
Content		350 ml, 500 ml, 700 ml	
External	1 piece est	20.3 in. (width) x 5.2 in. (depth) x 1.8 in. (height) (518 mm (width) x 133 mm	
dimensions in		(depth) x 48 mm (height)) (common to 350 ml, 500 ml and 700 ml)	
transport	12 piece est	21.1 in. (width) x 11.4 in. (depth) x 14.8 in. (height) (538 mm (width) x 290 mm	
condition 12-piece set		(depth) x 378 mm (height)) (common to 350 ml, 500 ml and 700 ml)	

Name		White ink pouch	
Use expiration date		Expiration date on the pouch pack (supposing storage at normal temperature)	
Storage temperate	ure	0 to 40°C (32 to 104°F)	
		- Store them in a place where they are not exposed to direct sunlight.	
Cautions for stora	ge	- Keep them out of the reach of children.	
		- Store them away from fire, heat and oxidized substance.	
Content		500 ml, 700 ml	
External	2 piece est	20.3 in. (width) x 5.2 in. (depth) x 3.4 in. (height) (518 mm (width) x 133 mm	
dimensions in		(depth) x 87 mm (height))	
transport	12 piece est	21.1 in. (width) x 11.4 in. (depth) x 11.6 in. (height) (538 mm (width) x 290 mm	
condition 12-piece set		(depth) x295 mm (height))	

GTX pro Bulk

Name			Black / Magenta / Cyan / Yellow ink pouch
Use expiration date			Expiration date printed on the bottle (supposing storage at normal temperature)
Storage temper			0 to 40°C (32 to 104°F)
Olorage temper	ature		- Store them in a place where they are not exposed to direct sunlight.
Cautions for sto	rane		- Keep them out of the reach of children.
	lage		- Store them away from fire, heat and oxidized substance.
			- Take care not to lose the IC stick.
Content			1.8 L / 18 L
		1-piece set	4.5 in. (width) x 4.5 in. (depth) x 15.4 in. (height) (115 mm (width) x 115 mm
External	External		(depth) x 393 mm (height))
dimensions in	1.8 L	6-pieces	14.5 in. (width) x 10.0 in. (depth) x 17.1 in. (height) (370 mm (width) x 255 mm
transport		set	(depth) x 435 mm (height))
condition	101	1-piece set	11.6 in. (width) x 10.0 in. (depth) x 19.9 in. (height) (294 mm (width) x 294 mm
	18 L	-	(depth) x 507 mm (height))

13-3-2. Maintenance solution (for GTX pro only)

Name		Maintenance solution pouch	
Use expiration date		Expiration date on the pouch pack (supposing storage at normal temperature)	
Storage temperat	ure	0 to 40°C (32 to 104°F)	
		- Store them in a place where they are not exposed to direct sunlight.	
Cautions for stora	ige	- Keep them out of the reach of children.	
		- Store them away from fire, heat and oxidized substance.	
Content		700 ml	
External	1 piece set	20.3 in. (width) x 5.2 in. (depth) x 1.8 in. (height) (518 mm (width) x 133 mm	
dimensions in	1-piece set	(depth) x 48 mm (height))	
transport	12-piece set	21.1 in. (width) x 11.4 in. (depth) x 14.8 in. (height) (538 mm (width) x 290 mm	
condition		(depth) x 378 mm (height))	

13-3-3. Cleaning solution

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Name		Cleaning solution
Use expiration dat	e	Expiration date on the container (supposing storage at normal temperature)
Storage temperatu	ure	0 to 40°C (32 to 104°F)
Cautions for storage		 Store them in a place where they are not exposed to direct sunlight. Keep them out of the reach of children. Store them away from fire, heat and oxidized substance. Cap the container tightly, and keep it in a cool, dark place with good ventilation.
Content		1.9 kg (4.2 lb)
External dimensions in transport condition	6-piece set	18.9 in. (width) x 13.3 in. (depth) x 13.5 in. (height) (480 mm (width) x 340 mm (depth) x 345 mm (height))

13-3-4. Pretreatment

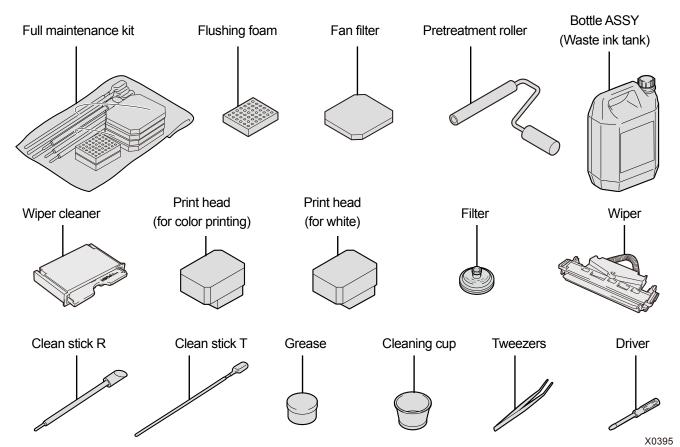
Name		Pretreatment		
Use expiration da	te	Expiration date on the outer case (supposing storage at normal temperature)		
Storage temperature		0 to 40°C (32 to 104°F)		
Cautions for storage		- Store them in a place where they are not exposed to direct sunlight.		
		- Keep them out of the reach of children.		
		- Store them away from fire, heat and oxidized substance.		
		- Cap the container tightly, and keep it in a cool, dark place with good ventilation.		
Content		20 kg (44 lb), 5 kg (11 lb)		
External	1 minor ant	10.4 in. (width) x 14.3 in. (depth) x 15.7 in. (height) (265 mm (width) x 365 mm		
dimensions in	1-piece set	(depth) x 400 mm (height)), (20 kg (44 lb))		
transport	4 piece est	17.9 in. (width) x 12.6 in. (depth) x 12.5 in. (height) (456 mm (width) x 320 mm		
condition	4-piece set	(depth) x 318 mm (height)), (5 kg (11 lb))		

13-4. About consumable supplies, optional items and replacement parts

About consumable supplies, optional items and replacement parts

- Consumable supplies: Components required for the printing operation
- Optional items: Available items through purchase order according to customers' usage status
- Replacement parts: Components for which periodic maintenance needs to be performed for you to optimize the printer's operation

Consumable supplies			Code No	Optional items	Code No.
GTX pro	Black ink pouch	350 ml	GCX-4K35-1	Over size platen X	
	·	500 ml	GCX-4K50-1	(16"x21" / 406 x 533mm)	SB6992
		700 ml	GCX-4K70-1	Platen sheet 16X21	SB7242
	Magenta ink pouch	350 ml	GCX-4M35-1	Large platen X	SB6994
		500 ml	GCX-4M50-1	(16"x18" / 406 x 457mm)	
		700 ml	GCX-4M70-1	Platen sheet 16X18	SB6995
	Cyan ink pouch	350 ml	GCX-4C35-1	Adult platen X	SB6996
		500 ml	GCX-4C50-1	(14"x16" / 356 x 406mm)	
		700 ml	GCX-4C70-1	Platen sheet 14X16	SB6667
	Yellow ink pouch	350 ml	GCX-4Y35-1	Youth platen X	SB6998
		500 ml	GCX-4Y50-1	(10"x12" / 254 x 305mm)	
		700 ml	GCX-4Y70-1	Platen sheet 10X12	SB6999
	White ink pouch	500 ml	GCX-4W50	Baby platen X	SD7001
		700 ml	GCX-4W70	(7"x8" / 178 x 203mm)	SB7001
	Black ink bottle	1.8 L	GCX-4K02-1	Platen sheet 7X8	007000
		18 L	GCX-4K20K-1		SB7002
	Magenta ink bottle	1.8 L	GCX-4M02-1	Pretreatment roller SI	SP1200
		18 L	GCX-4M20K-1		SB1290
GTX pro Bulk	Cyan ink bottle	1.8 L	GCX-4C02-1	Bottle ASSY (waste ink tank)	SB2582
		18 L	GCX-4C20K-1		
	Yellow ink bottle	1.8 L	GCX-4Y02-1	Capping pouch	SB5696
		18 L	GCX-4Y20K-1		300090
	White ink bottle	1.8 L	GCX-4W02	Replacement parts	Code No.
		18 L	GCX-4W20K		
Cleaning solution		1.9 kg	GCX-4E02	Print head (for color printing)	SC0764
Pretreatment		5 kg(11 lb)	GCX-4P05	Print head (for white)	SB8571
		20 kg (44 lb)	GCX-4P20	Driver	SC1681
Maintenance solution pouch (for		700 ml	GCX-4S70	Filter	SB7093
GTX pro only)			00/-40/0		
Full maintenance kit				Wiper	SB7870
<printer-supplied items=""></printer-supplied>				Grease	SB3229
Clean stick R		16 pcs. 16 pcs.	SC0934	Cartridge (for white ink)	SB5495
Clean stick T	Clean stick T			Cartridge C (for colored ink)	SB6875
Flushing foam		2 pcs.		Cleaning cup	SB6925
Fan filter		4 pcs.		Tweezers	117466100
Wiper cleaner2-piece set			SB6673		
5		2-piece set	SC0935		
Fan filter2-piece set			SB7007		
Clean stick R		50-piece set	SB7008		
Clean stick T		50-piece set	SC0032		





*Please note that the contents of this manual may differ slightly from the actual product purchased as a result of product improvements.

BROTHER INDUSTRIES, LTD. http://www.brother.com/ 1-5, Kitajizoyama, Noda-cho, Kariya 448-0803, Japan.

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