

## Please read this manual before use

Thank you for purchasing a MUTOH product.

This manual explains the steps for unpacking, installation and basic setup before using the MUTOH Full-color inkjet printer XPJ-1341SR-P.

This manual is intended for owners, installer personnel, and users of this product.

Please read this manual carefully and understand the contents and instructions in this manual before installing this product.

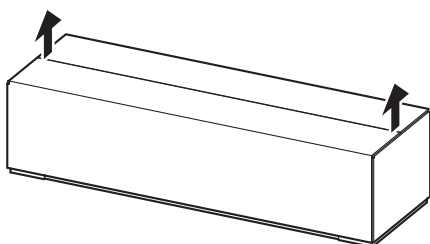
## Installation flow chart

Here are basic installation steps.

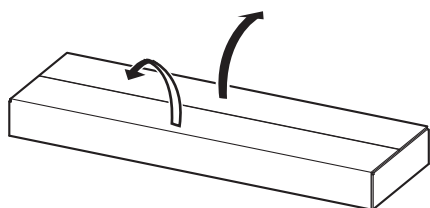
For details of each procedure, see the next page onward.

### 1 Unpacking boxes

#### 1.1 Unpacking the printer box



#### 1.2 Unpacking the stand box



### 2 Confirming supplied items

#### 2.1 Items in the printer box

#### 2.2 Items in the accessory bag

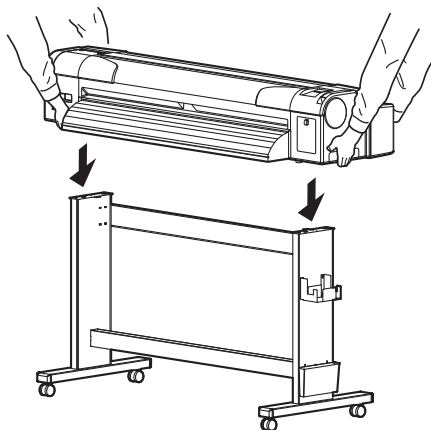
#### 2.3 Items in the waste fluid tank box

#### 2.4 Items in the stand box

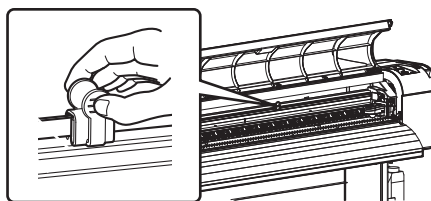
### 3 Assembling

#### 3.1 The stand assembling procedure

#### 3.2 Assembling the stand



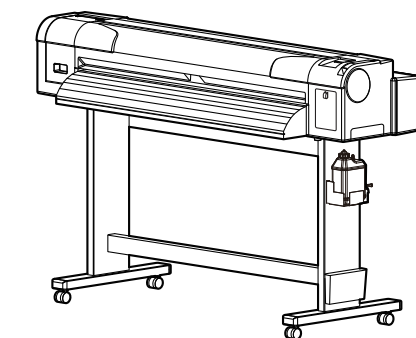
#### 3.3 Removing protective materials



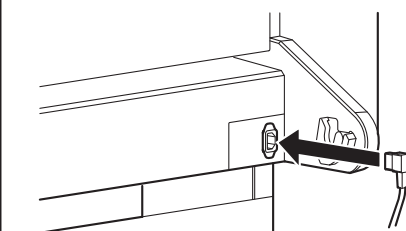
### 4 Installation

#### 4.1 Installation site requirements

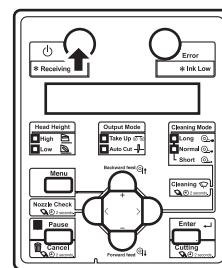
#### 4.2 Installation procedure



### 5 Connecting the power cord



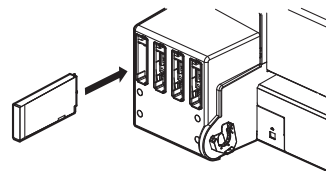
### 6 Turning the power ON/OFF



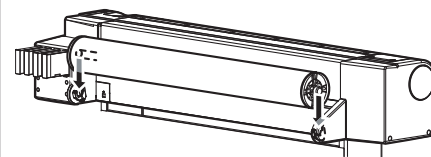
### 7 Product activation

### 8 Setting the display language and units

### 9 Installing the ink cartridge



### 10 Loading roll media



### 11 Checking the printing condition

### 12 Manual composition

## 1 Unpacking boxes

This section explains the unpacking procedure.

This product is packaged in two separate boxes; the printer box and the stand box.

### CAUTION

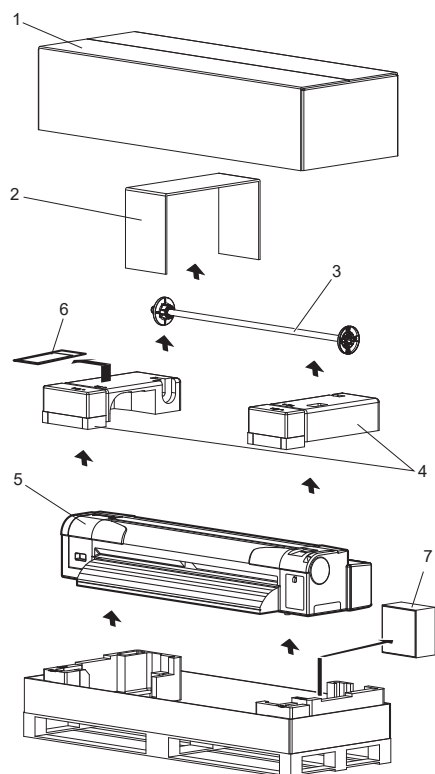
● This task requires at least three people.

● When taking out the printer from the box, make sure to remove the vinyl sheet and hold the handles on the printer. If the printer is lifted with the vinyl sheet attached, the printer might slip from your hands and be damaged.

### 1.1 Unpacking printer box

Follow these steps to unpack the printer box.

1. Carry the box to where you will unpack it.
2. Remove the strapping bands.
3. Open the box and take out the following items.
  - Accessory bag
  - Waste fluid tank box
  - Scroller



No.	Name	No.	Name
1	Printer box	5	Printer main body
2	Reinforcement packaging	6	Accessory bag
3	Scroller	7	Waste fluid tank box
4	Packing material		

### 1.2 Unpacking stand box

Follow these steps to unpack the stand box.

1. Carry the box to where you will unpack it.
2. Open the box and take out all the items in the box.

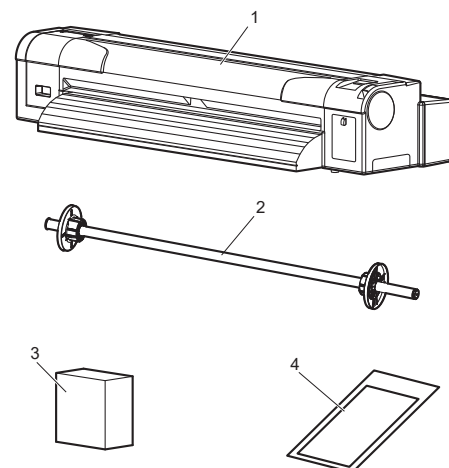
## 2 Confirming supplied items

After unpacking, check that the product has no damage and all supplied items are included.

### NOTE

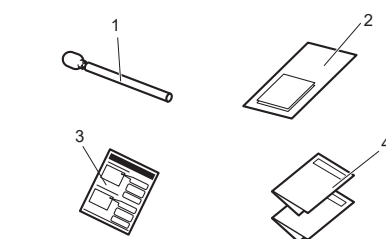
- If any items are damaged or missing, contact your local MUTOH dealer.

### 2.1 Items in the printer box



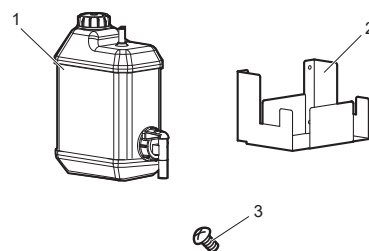
No.	Name	Q'ty
1	Printer main body	1 set
2	A0 Scroller 3 inch	1
3	Waste fluid tank box	1
4	Accessory bag	1

### 2.2 Items in the accessory bag



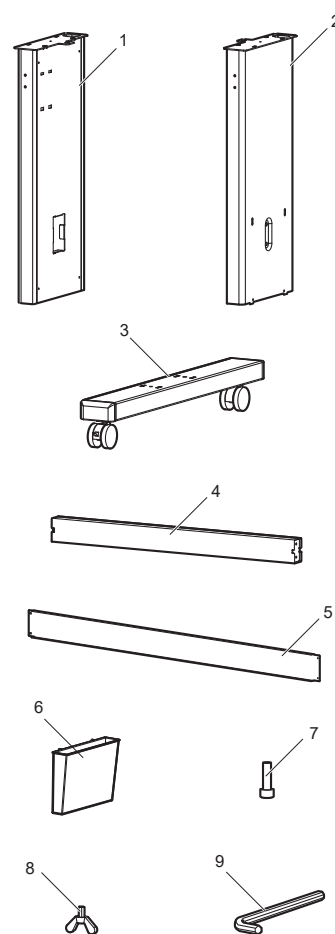
No.	Name	Q'ty
1	Clean stick	10
2	Paper towel	5
3	Request for User Registration & Download (English/ Japanese)	1
4	Installation Manual (This manual, English/ Japanese)	1 each

### 2.3 Items in the waste fluid tank box



No.	Name	Q'ty
1	Waste fluid tank	1
2	Waste fluid tank holder	1
3	Waste fluid tank holder stabilizing screws	4

### 2.4 Items in the stand box



No.	Name	Q'ty
1	Left support	1
2	Right support	1
3	Caster section (left, right)	2
4	Central beam	1
5	Stabilizer	1
6	Book holder	1
7	Hexagon socket head cap screw	12
8	Butterfly bolt	2
9	Hexagonal wrench	1

## 3 Assembling

This section explains how to assemble the stand to the printer unit.

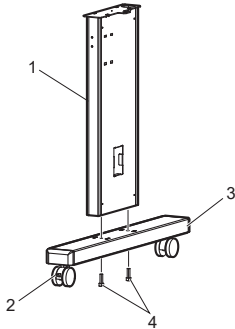
### CAUTION

- This task requires at least three people.

### 3.1 The stand assembling procedure

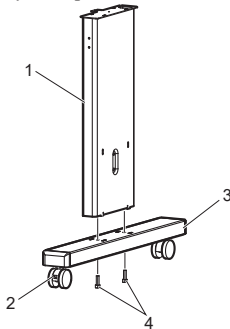
If you will use the stand, assemble it in accordance with the following steps.

- Follow these steps to assemble the left side of the stand leg.
  - Attach the left support to the caster section.
  - Tighten two hexagon socket head cap screws with the supplied hexagonal wrench.



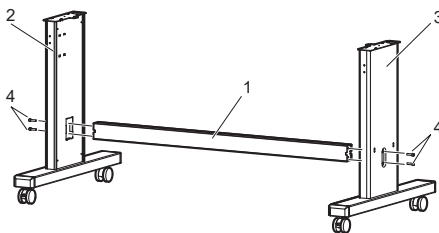
No.	Name	No.	Name
1	Left support	4	Hexagon socket head cap screws
2	Caster lock		
3	Caster section		

- Assemble the right side of the stand leg in a similar way to step 1.



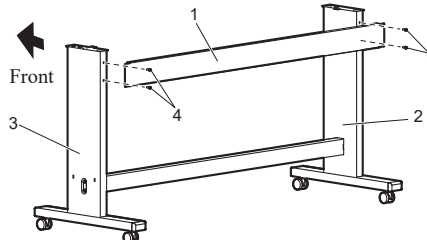
No.	Name	No.	Name
1	Right support	4	Hexagon socket head cap screws
2	Caster lock		
3	Caster section		

- Follow these steps to attach the central beam to the stand legs (left, right).
  - Attach the central beam and four hexagon socket head cap screws to the stand (the left, the right).
  - Tighten the hexagon socket head cap screws with the supplied hexagonal wrench to fasten the central beam.



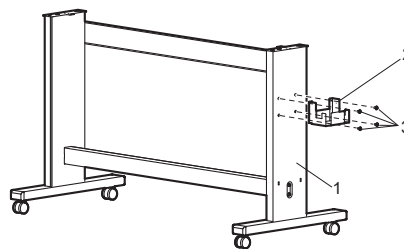
No.	Name	No.	Name
1	Central beam	4	Hexagon socket head cap screws
2	Leg (left)		
3	Leg (right)		

- Follow these steps to attach the stabilizer to the stand.
  - Use 4 hexagon socket head cap screws to attach the stabilizer to the right and left sides of the stand (2 each side).
  - Tighten the hexagon socket head cap screws using the hexagonal wrench.



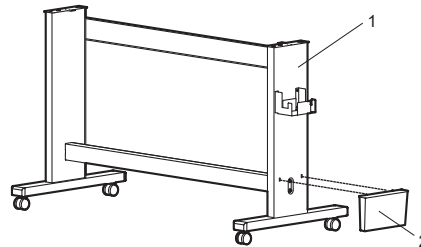
No.	Name	No.	Name
1	Stabilizer	4	Hexagon socket head cap screws
2	Stand (left)		
3	Stand (right)		

- Attach the waste fluid tank holder to the right side of the stand using four screws.



No.	Name	No.	Name
1	Stand (right)	3	Waste fluid tank holder stabilizing screws
2	Waste fluid tank holder		

- Attach the book holder to the right side of the stand. The book holder can be attached to the left side of the stand as well.



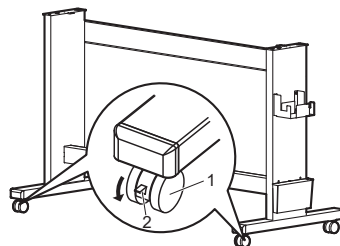
No.	Name	No.	Name
1	Leg (right)	2	Book holder

- Confirm that each component is fastened firmly by gently shaking the stand.

### 3.2 Assembling the stand

Attach the stand to the printer in accordance with the following steps.

- Lock two casters on the front side.

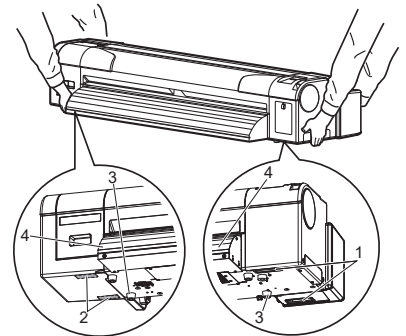


No.	Name	No.	Name
1	Castors	2	Caster locks

- Hold the following positions when lifting the product.  
 Panel side : two grab handles under the product  
 Opposed side : two grab area under the product

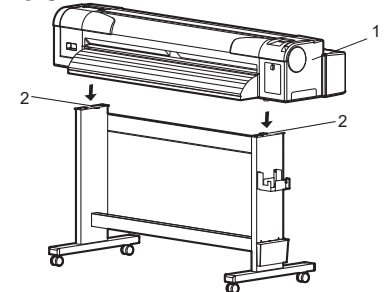
### NOTE

- Make sure to hold the designated positions when lifting the printer. This prevents the product from being damaged by accidental fall.
- Do not hold the media guide. This may affect the accuracy of the product, leading to improper operation.



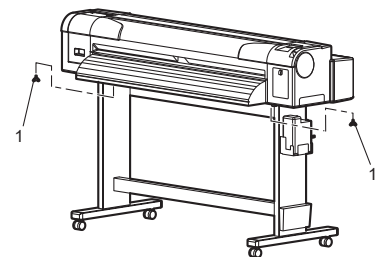
No.	Name	No.	Name
1	Grab handles	3	Rubber leg tips
2	Grab area	4	Media guide

- Place the printer on the stand so that the rear rubber leg tips fit into the holes on the stand.



No.	Name	No.	Name
1	Printer main body	2	Holes on the stand

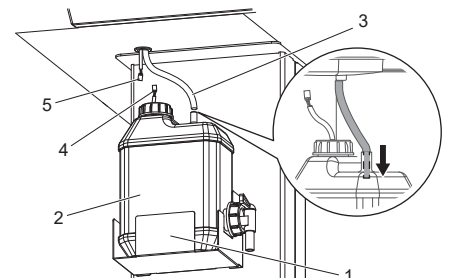
- Use two butterfly bolts to secure the printer to the stand.



No.	Name	No.	Name
1	Butterfly bolts		

- Follow these steps to connect the Waste fluid tank.

- Put the Waste fluid tank on the Waste fluid tank holder.
- Attach the Waste fluid tube to the Waste fluid tank.
- Connect the Waste fluid sensor cable to the Waste fluid sensor connector.



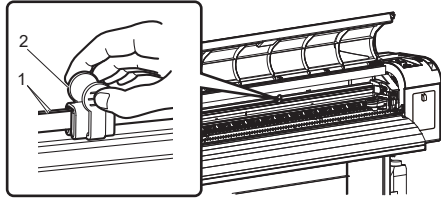
No.	Name	No.	Name
1	Waste fluid tank holder	4	Waste fluid sensor cable
2	Waste fluid tank	5	Waste fluid sensor connector
3	Waste fluid tube		

### 3.3 Removing protective materials

This product has protective materials in the place shown below.

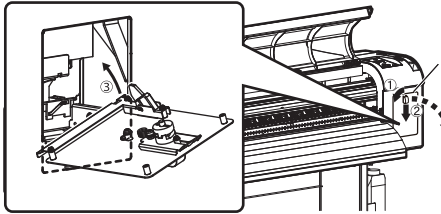
Follow these steps to remove all protective materials.

1. Remove all tapes from each cover.
2. Open the front cover and remove the CR belt clip from the CR belt.



No.	Name	No.	Name
1	CR belt	2	CR belt clip

3. Remove protective materials of the maintenance cover R.
  - Turn the knob to left until it clicks.
  - Open the maintenance cover R while sliding the knob down.
  - Remove the maintenance cover R and protective materials.



4. Close the maintenance cover R.

## 4 Installation

This section provides the procedures and minimum requirements for installation site.

### 4.1 Installation site requirements

Install this product to the appropriate place with reference to the following.

#### ⚠ WARNING

- When installing this product, avoid the following location:
  - on a shaky stand
  - non-level floor
  - places where the product get vibration from the neighboring devices
 It can lead to injury from a fall or printer fallen down.
- Do not step on this printer or place heavy things on top of it. It may cause an injury if the printer falls down.
- Do not block the vent on the product with cloth or other material. This may cause excessive heat inside the product, leading to fire.
- Do not install the printer in a location that has high humidity or dust. It could lead to electric shock and fire.

#### 4.1.1 Installation environmental condition

Choose the location which satisfies the requirements below.

Floor strength of installation place	More than 2940 Pa (300 kg/m <sup>2</sup> )
Power Specification	
Rated Voltage	AC100V - 120V/200V - 240V
Frequency Range	50/60Hz ± 1Hz
Power capacity	More than 10 A
Environmental conditions	
Operating condition	Temperature: 20 °C to 32 °C Humidity: 40 % to 60 %, No Condensation
Recommended printing condition	Temperature: 22 °C to 30 °C Humidity: 40 % to 60 %
Change rate	Temperature: within 2 °C per hour Humidity: within 5 % per hour

#### NOTE

- For temperature and humidity, avoid locations such as the following. There is a possibility that the print quality will be affected.
  - Places where temperature or humidity may rapidly change, even though within the required conditions.
  - Places that receive direct sunlight, increased illumination or direct air, for example from an air conditioner.
- To keep the temperature and humidity constant, install this product in a location where the air condition is adjustable.

#### 4.1.2 Installation space

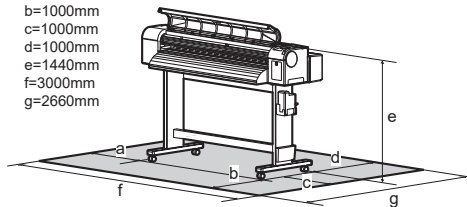
Install on a level floor which meets the following condition.

- It has enough strength to support the weight of the printer and the stand.

#### NOTE

- For the weight of the printer and the stand, refer to the Operation Manual.

a=500mm  
b=1000mm  
c=1000mm  
d=1000mm  
e=1440mm  
f=3000mm  
g=2660mm



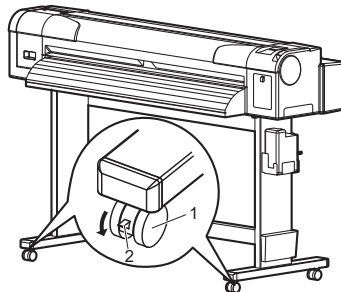
### 4.2 Installation procedure

Install this product to the installation place in accordance with the list shown below.

#### NOTE

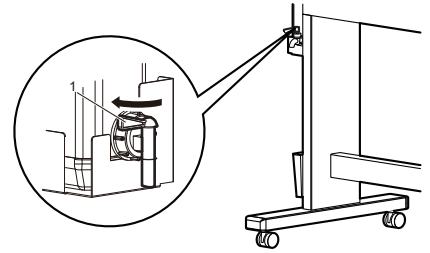
- Please check that the butterfly bolts are not loose before/after moving this product.
- When transporting or moving the product outside, remove the printer from the stand.

1. Check that the two butterfly bolts attaching the stand and the printer are not loose.
2. Move the printer to the installation place.
3. Lock two casters on the front side.



No.	Name	No.	Name
1	Castors	2	Caster locks

4. Check that the two butterfly bolts attaching the stand and the printer are not loose.
5. Check that the waste fluid valve is closed.



No.	Name	No.	Name
1	Waste fluid valve		

## 5 Connecting the power cord

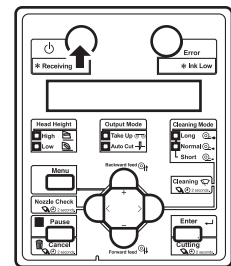
This section explains how to connect the power cord.

#### ⚠ WARNING

- Be sure to use the specified power cable (separately sold). Using power cables other than the specified can cause an electric shock or fire.
- Use a power cord set which is compatible with the safety standards, power supply voltage, and plug shape used in the country where this printer is used.
- Use a power cord set which is equipped with a protective earth, and securely connect it to the outlet.
- Do not use a damaged power cord. It may cause an electric shock or fire.

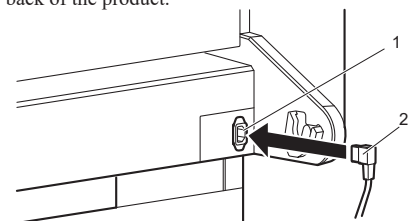
Follow the steps below to connect the power cable.

1. Confirm that the product is turned OFF.



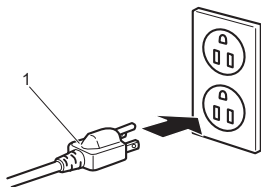
#### NOTE

- If the [Power] key is pressed, the product is turned ON. Press the key again to turn OFF the power.
2. Connect the power cable to the AC inlet on the back of the product.



No.	Name	No.	Name
1	AC inlet	2	Power Cable

- Correctly insert the power cable plug into the power socket.



No.	Name		
1	Power cable		

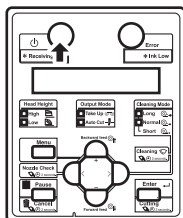
## 6 Turning the power ON/OFF

This section explains how to turn ON/OFF the printer.

### 6.1 Turning the power ON

Follow the procedure below to turn ON the printer.

- Press the [Power] key on the operation panel to turn ON the printer.
- The Power lamp on the operation panel lights up in blue.



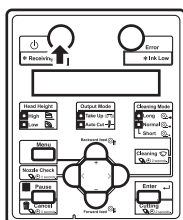
- The printer starts initial operation.
- When the initial operation is complete, the printer enters normal status.

### 6.2 Turning the power OFF

Follow the procedure below to turn OFF the printer.

- Regarding the operating condition of the printer, confirm the following.

- Printing or other operations are not in progress.
- The operation panel is in normal status.

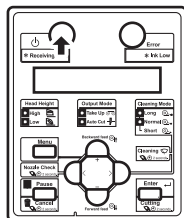


- Press the [Power] key on the operation panel to turn OFF the printer.
- The Power lamp on the operation panel turns OFF.

#### NOTE

- If the operation panel is in the following status, the power is ON.
  - The [Power] key is pressed in.
  - The Power lamp lights up in blue.

Press the key once again and turn OFF the power.



- The printer starts operating to turn the power OFF.
- The operation panel displays "Power Off".
- All the lamps on the operation panel and the LCD monitor are turned OFF.
- The printer automatically turns the power OFF.

## 7 Product activation

This printer requires activation when the power is turned ON for the first time.

When "Activation required" is displayed on the Operation panel, refer to "Printer activation guide"\* to perform activation.

\*Please download the "Product Activation Guide" from the MUTOH Club below.

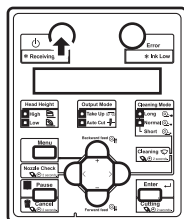
<https://club.mutoh.co.jp/mutoh/guser>

## 8 Setting the display language, unit and etc

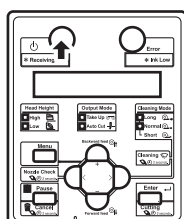
Once activation has been completed, the printer requires setting of the language, temperature unit, length unit, IP address, subnet mask and gateway at the time of restart.

Follow the procedure below to setup.

- Once activation has been completed, "Reboot a printer" is displayed on the Operation panel. Press the [Power] key on the Operation panel and turn the power OFF.



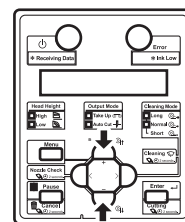
- Press the [Power] key on the Operation panel and turn the power ON.



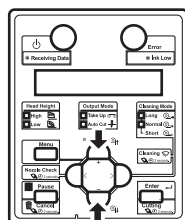
- "Language: English" is displayed on the Operation panel.

- Press [+] or [-] key on the Operation panel to select the set value, and press the [Enter] key.

- To set the language to Japanese, select "Language: Japanese".



- "Temp: Celsius[C]" is displayed on the Operation panel.
- Press [+] or [-] key on the Operation panel to select the set value, and press the [Enter] key.
- To set the temperature unit to Celsius, select "Temp: Celsius [C]".



- "Length: mm" is displayed on the Operation panel.

- Press [+] or [-] key on the Operation panel to select the set value, and press the [Enter] key.

- To set the length unit to mm, select "Length: mm".

- "IP: 192.168.1.253" is displayed on the Operation panel.

- Press [+] or [-] key on the Operation panel to select the set value, and press the [Enter] key.

- "MASK: 255.255.255.0" is displayed on the Operation panel.

- Press [+] or [-] key on the Operation panel to select the set value, and press the [Enter] key.

- "GW: 192.168.1.254" is displayed on the Operation panel.

- Press [+] or [-] key on the Operation panel to select the set value, and press the [Enter] key.

- This completes the setting the display language, units, IP address, subnet mask and gateway.

#### NOTE

- If "Smart/C End" is displayed on the Operation panel, follow "Printer activation guide" (separate volume) and perform "Renew Smart/C".

Printer activation guide

"A-8 Renewing Smart/C"

"B-3 Renewing Smart/C"

- The printer starts initial operation.
- When the initial operation is complete, the printer enters normal status.



## 9 Installing the ink cartridge

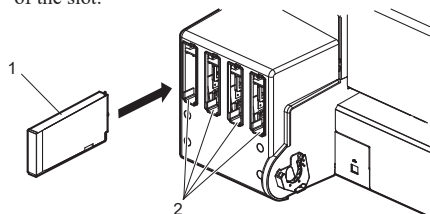
This section explains how to install ink cartridges.

Follow the these steps to install ink cartridges.

### CAUTION

- **Wear protective equipment (gloves, goggles or eye protection, protective mask, protective clothing) when handling ink.**  
**Be cautious that ink does not get into your eye or make a contact with your skin.**
- **When ink gets into your eye or make a contact with your skin, wash with water immediately.**
- **If left as it is, it may cause red eye or light inflammation. If it is necessary, please see your doctor immediately.**

1. Turn the printer ON.
  - The printer starts the initializing operation.
  - After the initial operation is complete, "Start Ink Charge ? > E" is displayed on the operation panel.
2. Press the [Enter] key on the operation panel.
  - If "Remove Cartridges" is displayed on the operation panel, remove all the ink cartridges.
  - "Insert Cleaning cart." is displayed on the operation panel.
  - "Busy-Washing" is displayed on the operation panel and the printer starts head cleaning.
3. Remove the new cleaning cartridges (4 pieces) from the package.
4. Insert the cleaning cartridge into the ink cartridge slot.
  - Keep ▲ mark of the cleaning cartridge facing up and insert in the printer.
  - Insert the cleaning cartridge all the way to the end of the slot.



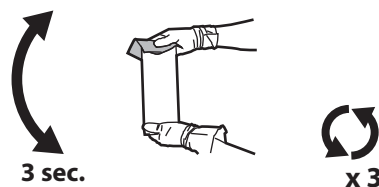
No.	Name	No.	Name
1	Cleaning cartridge	2	Ink cartridge slots

- When all cleaning cartridges are installed, "Busy-Washing" is displayed on the operation panel, and the printer starts charging the cleaning fluid.
  - When the cleaning fluid has been charged, "Remove Cartridges" is displayed on the operation panel.
5. Remove all the cleaning cartridges.
    - "Busy-Washing" is displayed on the operation panel and the printer starts head cleaning.
  6. After the head cleaning is complete, "Insert CleaningCart." is displayed on the operation panel.
  7. Repeat steps 4 and 5.
    - When head cleaning is complete, "Wash retry? No" is displayed on the operation panel.
  8. Press the [Enter] key on the operation panel.
    - "Insert InkCartridges" is displayed on the operation panel.

## 9.1 Installing 220ml ink cartridges

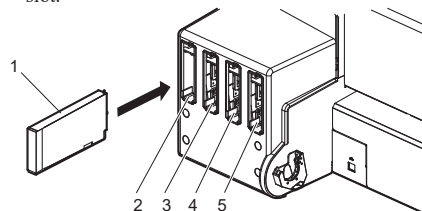
1. Remove the new ink cartridges from the package.
2. Agitate the ink cartridges.
  - Hold the ink cartridge facing the ink plug up and wait for 3 seconds.
  - Next invert the cartridge and wait for 3 seconds.
  - Repeat that 3 times.

3 sec.



3. Insert the ink cartridges into Ink cartridge slots.

- Make sure that the ink cartridges are inserted into the correct slots.  
Match the color of the ink with the color of the label attached to each slot.
- Keep ▲ mark of the ink cartridge facing up and insert in the printer.
- Insert the ink cartridge all the way to the end of the slot.



No.	Name	No.	Name
1	Ink cartridge	4	Ink cartridge slot M
2	Ink cartridge slot K	5	Ink cartridge slot Y
3	Ink cartridge slot C		

- When an ink cartridge is installed, "Ink Refill \*\*%" is displayed on the operation panel and ink charging starts.
- Initial charging takes about four minutes.  
Ink charging operation and pause operation are repeated during the ink charging.
- When "100%" is displayed, the ink charging is complete.

### NOTE

- Do not perform the following operations during ink charging. If charging is interrupted, ink will be lost when charging is resumed.
  - Do not turn OFF the power of the printer.
  - Do not unplug the power cable of the printer.
  - Do not open the front cover.
  - Do not push the media loading lever towards the back.

4. After the ink charging is complete, "Media End" is displayed on the operation panel.

### NOTE

- If you perform a nozzle check printing immediately after initial ink charging is complete, the following results may occur.
  - Printed lines become blurred.
  - The data is partially not printed.

In such cases, follow "6.2.3 Head cleaning" to perform "Little Charge" and then print an image again to check the print result.

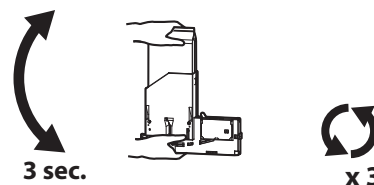
If there is no improvement in the print result even after performing "Little Charge", leave the printer unused for an hour or more. Then, perform "Little Charge" again and check the print result.

If the problem still persists, contact your local MUTOH dealer.

## 9.2 Installing high capacity pack adapters (option)

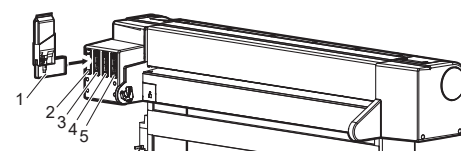
1. Remove the new ink bags from the package.
2. Install the ink bag and smart chip card to high capacity pack adapter.
3. Agitate the ink bags.
  - To prevent the ink bag and the High capacity ink pack adapter from separating, hold one hand against the top of the ink bag. Rotate the plug of the ink bag vertically and hold for 3 seconds.
  - Next, turn the ink plug downward and wait for 3 seconds.
  - Repeat that 3 times.

3 sec.



4. Insert the High capacity ink pack adapters into Ink cartridge slots.

- Make sure that the high capacity pack adapter are inserted into the correct slots.  
Match the color of the ink with the color of the label attached to each slot.
- Insert the high capacity pack adapter all the way to the end of the slot.



No.	Name	No.	Name
1	High capacity pack adapter	4	Ink cartridge slot M
2	Ink cartridge slot K	5	Ink cartridge slot Y
3	Ink cartridge slot C		

- When a high capacity pack adapter is installed, "Ink Refill \*\*%" is displayed on the operation panel and ink charging starts.
- Initial charging takes about four minutes.  
Ink charging operation and pause operation are repeated during the ink charging.
- When "100%" is displayed, the ink charging is complete.

### NOTE

- Do not perform the following operations during ink charging. If charging is interrupted, ink will be lost when charging is resumed.
  - Do not turn OFF the power of the printer.
  - Do not unplug the power cable of the printer.
  - Do not open the front cover.
  - Do not push the media loading lever towards the back.

5. After the ink charging is complete, "Media End" is displayed on the operation panel.

### NOTE

- If you perform a nozzle check printing immediately after initial ink charging is complete, the following results may occur.
  - Printed lines become blurred.
  - The data is partially not printed.

In such cases, follow "6.2.3 Head cleaning" to perform "Little Charge" and then print an image again to check the print result.

If there is no improvement in the print result even after performing "Little Charge", leave the printer unused for an hour or more. Then, perform "Little Charge" again and check the print result.

If the problem still persists, contact your local MUTOH dealer.

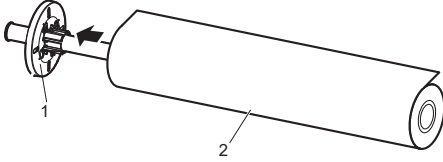
## 10 Loading roll media

This section explains how to load roll media.

Follow the steps below to load roll media.

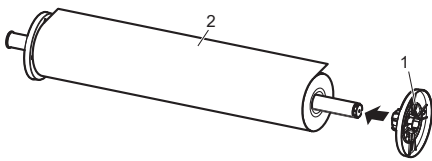
1. Set roll media in the scroller so that the roll media gets wound up in the direction of anti-clockwise when viewed from the fixed flange side.

2. Push the roll media until its core hits the right edge of the fixed flange.



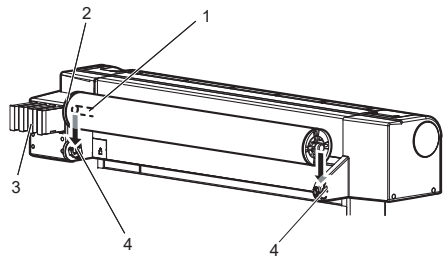
No.	Name	No.	Name
1	Fixed flange	2	Roll media

3. Attach the movable flange so that it is firmly attached to the roll media core.



No.	Name	No.	Name
1	Movable flange	2	Roll media

4. Set the scroller onto the scroll receiver with the fixed flange side facing the ink cartridge slots.



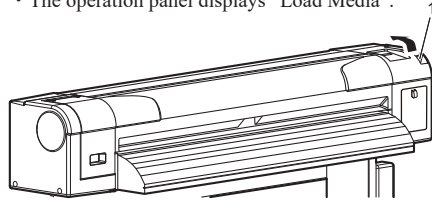
No.	Name	No.	Name
1	Scroller	3	Ink cartridge slot
2	Fixed flange	4	Scroller receiver

5. Turn ON the product.
6. The product starts the initial operation.

- The operation panel displays “Media End”.

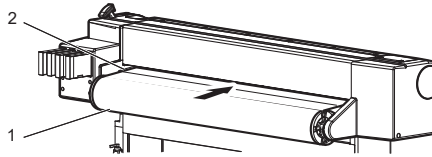
7. Push the media loading lever backward.

- The operation panel displays “Load Media”.



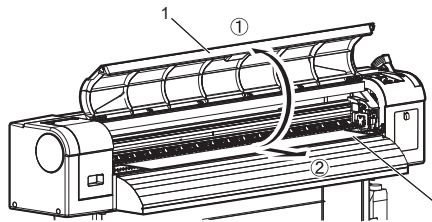
No.	Name	No.	Name
1	Media loading lever		

8. Feed the roll media into the media feed slot.



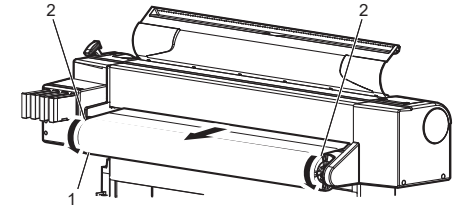
No.	Name	No.	Name
1	Roll media	2	Media feed slot

9. Open the front cover, and pull out the roll media.



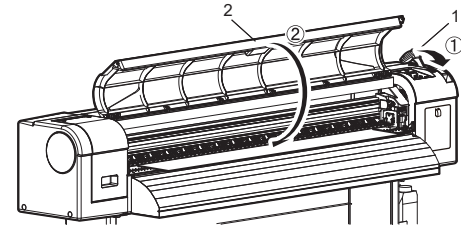
No.	Name	No.	Name
1	Front cover	2	Roll media

10. Wind back the roll media with the scroller to remove a media bend or slant.



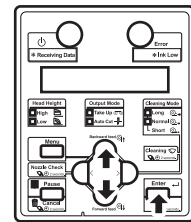
No.	Name	No.	Name
1	Roll media	2	Scroller

11. Return the media loading lever to the front and close the front cover.



No.	Name	No.	Name
1	Media loading lever	2	Front cover

12. Press the [ + ] key or [ - ] key on the operation panel to select the type of the loaded media and press the [Enter] key.

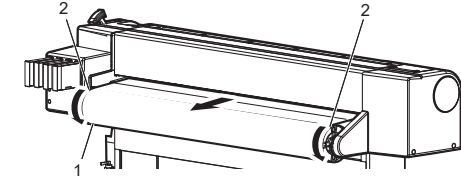


This confirms the media type.

The operation panel displays “Media Initial”, and media initial operation starts.

After the media initial operation is completed, the operation panel displays “Ready to Print”, and the display enters normal status.

13. Wind back the roll media with the scroller to remove a media bend.



No.	Name	No.	Name
1	Roll media	2	Scroller

The media loading is complete.

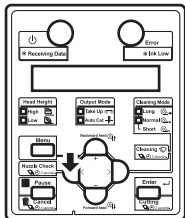
## 11 Checking printing conditions

Check the condition of the print head after the ink charging.

1. Turn ON the printer and load a roll media.

 “10. Loading roll media”

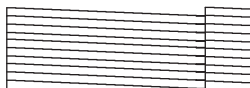
2. Confirm that the printer functions normally.
3. Press the [ < ] key on the operation panel for more than two seconds.



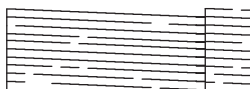
Nozzle check printing starts.

4. Check the nozzle check print for blurred or missing parts.

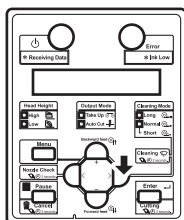
No nozzle clog



Nozzle clogged



5. If the nozzle check result indicates that there is a problem such as mentioned above in the check pattern, clean the head.  
Press and hold the [Cleaning] key on the operation panel for two seconds or more.



The operation panel displays “Cleaning \*\*%”.  
Head cleaning starts.

6. Perform nozzle check again and check the condition of the print head.

### NOTE

- If one time of head cleaning was not enough to remove blurred or missing parts in the check pattern, perform “Long” cleaning.
- If those problems above were not improved after a few times of head cleaning, refer to the Operation Manual “7 Troubleshooting” and perform required procedures.

7. Perform nozzle check again and check the condition of the print head.

## 12 Manual composition

This product includes the following three manuals.

- **Installation Manual (this manual)**

This manual explains the procedures of unpacking, installing, and the basic set up.

- **Product Activation Guide\***

This manual explains the procedures when the printer starts up first time.

- **Operation Manual\***

The Operation Manual explains the basic installation, daily use and available functions.

\*Please download from the MUTOH Club:

<https://club.mutoh.co.jp/mutoh/guser>

### TIP

- Operation Manual of this product is created with PDF format.
- Adobe Acrobat Reader 6.0 or above is required to view PDF format.  
Adobe Reader is available for free download from the Adobe website.