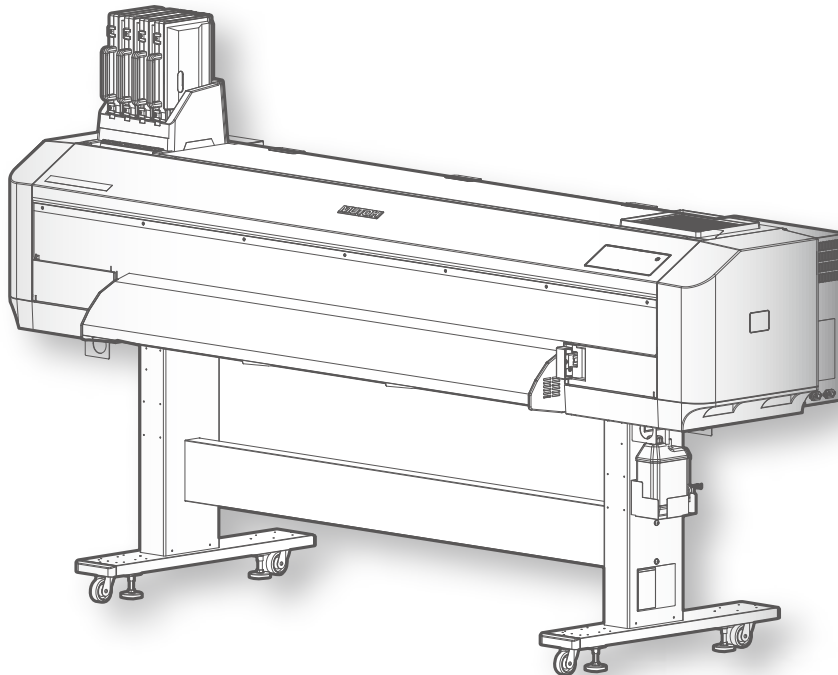


XPJ-1641SR-P II

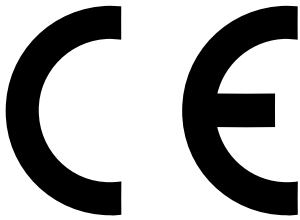
Startup Guide

Unpacking and Assembling Instructions



Important Notice

For Users in Europe



The CE marking is a mandatory European marking for certain product groups to indicate conformity with the essential health and safety requirements set out in European Directives.

By affixing the CE marking, the manufacturer, his authorized representative, or the person placing the product on the market or putting it into service ensures that the item meets all the essential requirements of all applicable EU directives and that the applicable conformity assessment procedures have been applied.

For Users in the United States

This equipment has been tested and found to comply with the limits for a Class A digital device, pursuant to Part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications.

Operation of this equipment in a residential area is likely to cause harmful interference in which case the user will be required to correct the interference at his own expense.

CAUTION

Use of controls or adjustments or performance of procedures other than those specified herein may result in radiation exposure.

Microsoft® and Windows® are either registered trademarks or trademarks of Microsoft Corporation in the United States and/or other countries.

VerteLith™ is trademark of MUTOH INDUSTRIES LTD.

Company names and product names that appear in this Guide are registered trademarks or trademarks of the respective companies.

- Unauthorized copying or duplication of the whole or part of the contents of this Guide is prohibited.
- Every care has been taken in writing the contents of this Guide, but please contact MUTOH or the dealer you purchased the product from if you find any unclear, erroneous or otherwise unsatisfactory content in the Guide.
- Please be aware that MUTOH will not be liable in any way for failures or accidents that result from handling or operating the printer according to any procedures other than those set forth in this Guide.
- To return to original place after clicking link in the table of contents or reference, tap **Alt** + **←** keys.

Table of Contents

Safety Precautions

5

Symbols	5
Usage Precautions	6
Warning labels.....	12
Instruction Labels	15

Check before installation

16

Installation Location Requirements.....	16
Minimum Space Requirements	16
Power specifications	17
Environmental Requirements	18

Unpacking

19

Preparations	19
Unpacking the printer	20
Package Contents.....	21

Assembling

23

Assembling the stand	23
Attaching the printer	26
Attaching the waste ink tank	28
Removing protective materials	29

Connecting the cables

32

Connecting the power cord to the printer	32
Connecting the Ethernet cable	34

Setup

35

Initial Setup Flow	35
How to use the printer control panel	36
Step1 Initial settings	36
Step2 Activation	39
Step3 Initial Cleaning - Initial Ink Charging	41

Installing MSM

50

Installing procedure	50
----------------------------	----



Safety Precautions

Symbols



In this document, information that must be followed is marked with following symbols to avoid risk of harm to human health or damage to the property.

Please read and understand the meaning of each symbol and ensure to use the product properly.




■ The following signs are used to classify and explain the degree of harm or damage that may result from neglect of instructions or incorrect handling.

 Warning	Failure to follow the instructions could result in serious injury or death.
 Caution	Failure to follow the instructions could result in minor injury or damage to the whole or part of the product.

■ The following symbols are used to classify and explain the types of instructions that must be observed.

	Indicates an action that you must avoid.
	Indicates an important instruction that you must do.

■ Other symbols

 Important!	Provides information that require special attention or should be followed.
 Note	Provides supplemental or reference information.
	Indicates the link to the reference section.






Note

For the name of each part marked with safety symbols, see “Printer main components / Functions” in the operation manual.

Usage Precautions







In the event of abnormal conditions

Warning





	<p>If something abnormal occurs such as smoke or unusual odor, turn off the power button and unplug the power cord from the outlet.</p> <p>Keeping using the product may result in electric shock or fire. Once you have confirmed that smoke is no longer being emitted, please contact your local dealer. Never attempt to repair the machine yourself as it is dangerous.</p>
	<p>If a foreign object, water, or other liquid gets inside the product, immediately turn off the power button and unplug the power plug from the outlet.</p> <p>Keeping using the product may result in electric shock or fire. Once you have confirmed there are no abnormalities in the product, please contact your local dealer. Never attempt to repair the machine yourself as it is dangerous.</p>
	<p>If ink, maintenance solution, or waste fluid gets on skin, immediately wipe off with a cloth. Then wash with soap and plenty of water.</p> <p>If skin irritation or inflammation occurs, seek medical attention.</p>
	<p>If ink, maintenance solution, or waste fluid gets in eyes, immediately flush with plenty of water for 15 minutes. If eye pain or irritation is present, seek medical attention immediately.</p> <p>If left untreated, it may cause red eyes or mild irritation in the eyes.</p>
	<p>If ink, maintenance liquid, or waste fluid is swallowed, do not induce vomiting. Gargle immediately and seek medical attention.</p> <p>Attempting to induce vomiting may cause vomit to enter the trachea.</p>

Handling



Warning

	<p>Do not touch the product when lightning starts.</p> <p>This could result in electric shock.</p>
	<p>Do not insert or drop metal or flammable objects into the printer through openings such as vent.</p> <p>This could result in fire or electric shock.</p>
	<p>Do not cover the product with a cloth or other material to block vent.</p> <p>If covered, the inside the product gets hot, resulting in fire.</p>
	<p>Do not touch the moving parts.</p> <p>This could cause injury or damage to the product.</p>
	<p>Do not sit or place heavy objects on the product.</p> <p>This could result in injury from a fall.</p>
	<p>Do not touch the media guide while printing or when the heater is in operation.</p> <p>The media guide gets hot, causing burn injury.</p>

Handling







	Never modify the product or open any covers secured with screws. This could result in an electrical shock or damage to the printer. Also, modifying or disassembling the product will void the warranty.
	Do not pour flammable liquid on the media guide. This could result in fire.
	Ensure that no moisture enters the product. This could result in an electrical short circuit.
	Immediately after printing, the media guide gets hot. Allow the media guide to cool down and then do a task.

Caution











	Do not tilt or give any impact to the product. Doing so may cause the ink inside the printer to leak. MUTOH cannot guarantee that the printer can run properly.
	Use the following safety precautions when handling the front cover or maintenance cover: <ul style="list-style-type: none"> • Avoid strong airflow from fan or air conditioner to covers when installing the product. It may accidentally close covers. • Check your surroundings when opening cover. Cover may hit someone or something.

Power cords


Warning

	Do not damage or modify power cord or power plug. Also, do not place heavy objects on it, heat it, or forcibly bend or pull it. This could damage the power cord, resulting in fire or electric shock.
	Do not use a power cord that is damaged, broken or core wire exposed. This could result in fire or electric shock.
	Do not plug the ground terminal into a power outlet. This could result in fire or electric shock.
	Do not allow metal or other objects to touch the blade of the power plug. This could result in fire or electric shock.
	Do not use power strips. This could result in fire or electric shock.
	Do not connect an earth wire to the following places: <ul style="list-style-type: none"> • Gas pipe: It has potential risks of fire or explosion. • Earth wire of telephone cables or lightning rods: Large lightning current may flow when lightning strikes. • Water pipe or faucet: It may not work properly if a plastic pipe is connected to the pipe.

Power cords





	<p>Do not connect or disconnect power plug with wet hands.</p> <p>This could result in an electrical shock.</p>
	<p>Be sure to use the designated power cords.</p> <p>The use of non-designated power cord could result in an electric shock or fire. For the designated power cord, please contact your local MUTOH dealer.</p> <p>Use a power cord with protective ground terminal and make sure to plug in securely.</p> <p>Use a power cord which meets the safety standard, voltage and plug shape of the country to use the product.</p>
	<p>Use the product within the designated power specification range.</p>
	<p>Plug the power cord into a power outlet near the product.</p> <p>Install the product near the power outlet so that you can unplug the power cord in case of emergency.</p>
	<p>Use the cord clamp to secure the power cord.</p>
	<p>Insert the power plug blade securely.</p> <p>Incomplete insertion may cause fire or electric shock.</p>
	<p>When unplugging the power cord, be sure to hold the plug and pull it out.</p> <p>Pulling on the power cord may damage the cord, resulting in fire or electric shock.</p>
	<p>Clean the power plug regularly with a dry cloth.</p> <p>Moisture adhering to accumulated dust may cause a short circuit. This could result in fire or electric shock.</p>
	<p>Unplug the power plug from the outlet when not using the product for an extended period of time.</p> <p>Dust buildup on the power plug may cause fire or electric shock.</p>
	<p>Plug the power cord into the wall outlet that has the earth connection and be sure to connect the earth wire.</p> <p>Failure to connect the earth wire may cause an electric shock or fire.</p> <p>Make sure to connect an earth wire to the earth connection that meets the following requirements:</p> <ul style="list-style-type: none"> • Earth terminal of power socket • An earth wire with a copper plate which is buried more than 650 mm deep into the ground

Caution




	<p>Use a power outlet and breaker which satisfies the power requirement of the printer.</p> <p>The breaker may shut down if it does not meet the power requirements.</p>
---	---

Printer installation and moving

Warning





	<p>Choose the location which satisfies the requirements below:</p> <ol style="list-style-type: none"> 1. The floor must be level. 2. Avoid vibration from the neighboring devices. 3. Low humidity and free from dust. 4. Less chance of temperature and humidity changes. 5. Avoid direct sunlight. 6. Avoid water. 7. Avoid direct air (including air conditioning) onto the printer. 8. Low levels of electromagnetic waves.
	<p>Install in a place that can be ventilated and ensure that the work area is well ventilated.</p> <p>Odor of ink may adversely impact on health. If you experience headache or feel dizzy or dull, stop your work and get to fresh air. If nausea persists, seek medical attention.</p>
	<p>Before taking out the printer from the packaging box, remove the plastic sheet wrapped around the printer first.</p> <p>Failure to do so may cause slip or damage to the printer.</p>
	<p>Do not install the product in a location where children are likely to be present.</p>

Caution

	<p>At least four people are required for unpacking and moving the product. When moving, keep the product level.</p>
	<p>Empty the waste ink tank even when moving for a short distance.</p> <p>Failure to do so may result in damage to the printer.</p>
	<p>Wearing safety shoes is recommended when moving the product.</p>

Maintenance

Caution

   	<p>When cleaning, make sure to wear protective equipment (gloves, goggles or eye protection, protective clothing, mask).</p>
--	---

Maintenance

	<p>Follow these precautions when cleaning:</p> <ul style="list-style-type: none"> • Do not touch the tip of cleaning stick with finger. Finger oil may cause print head malfunction. • Never put water on the tip of cleaning stick. This will cause the print head damage. • Use a new cleaning stick. The reuse of used cleaning sticks may cause print head malfunction. • Allow the media guide to cool down and then do a maintenance task. Immediately after printing, the media guide is hot. Rest it at least 10 minutes after printing and do a maintenance task.
	<p>Never touch the print head nozzles when cleaning the parts around the print head. This could damage the print head.</p>
	<p>Do not touch the cleaning wiper and the print head capping station with bare hands when cleaning the wiper. If finger oil gets on this, head cleaning cannot be performed properly.</p>
	<p>Do not use volatile chemicals such as thinner, benzine or alcohol for cleaning. This may cause damage to the paint or plastic cover.</p>
	<p>Avoid the following actions when ink charging is being performed.</p> <ul style="list-style-type: none"> • Turn off the printer or unplug the power cord. • Open the front cover or maintenance cover. • Raise the pressure rollers. • Move the printer.











Ink and waste fluid

Warning

	<p>The safety concerns involved with using and handling of ink and waste fluid are detailed in the Safety Data Sheet (SDS). Make sure to read the SDSs when handling these liquid. Download the latest version of SDSs from our website (https://www.mutoh.co.jp/).</p>
	<p>Waste fluid collected from the product is classified as waste oil of industrial waste. You are obligated to properly dispose of waste fluid from the printer in compliance with Wastes Disposal and Public Cleansing Act and local ordinances. Delegate disposal to an industrial waste disposal contractor.</p>
	<p>Do not bring fire to the work area. There is a risk of fire from ink or waste fluid.</p>
	<p>Keep the ink, cleaning solution and waste fluid away from fire and heat and store in a cool, dark place.</p>

Ink and waste fluid

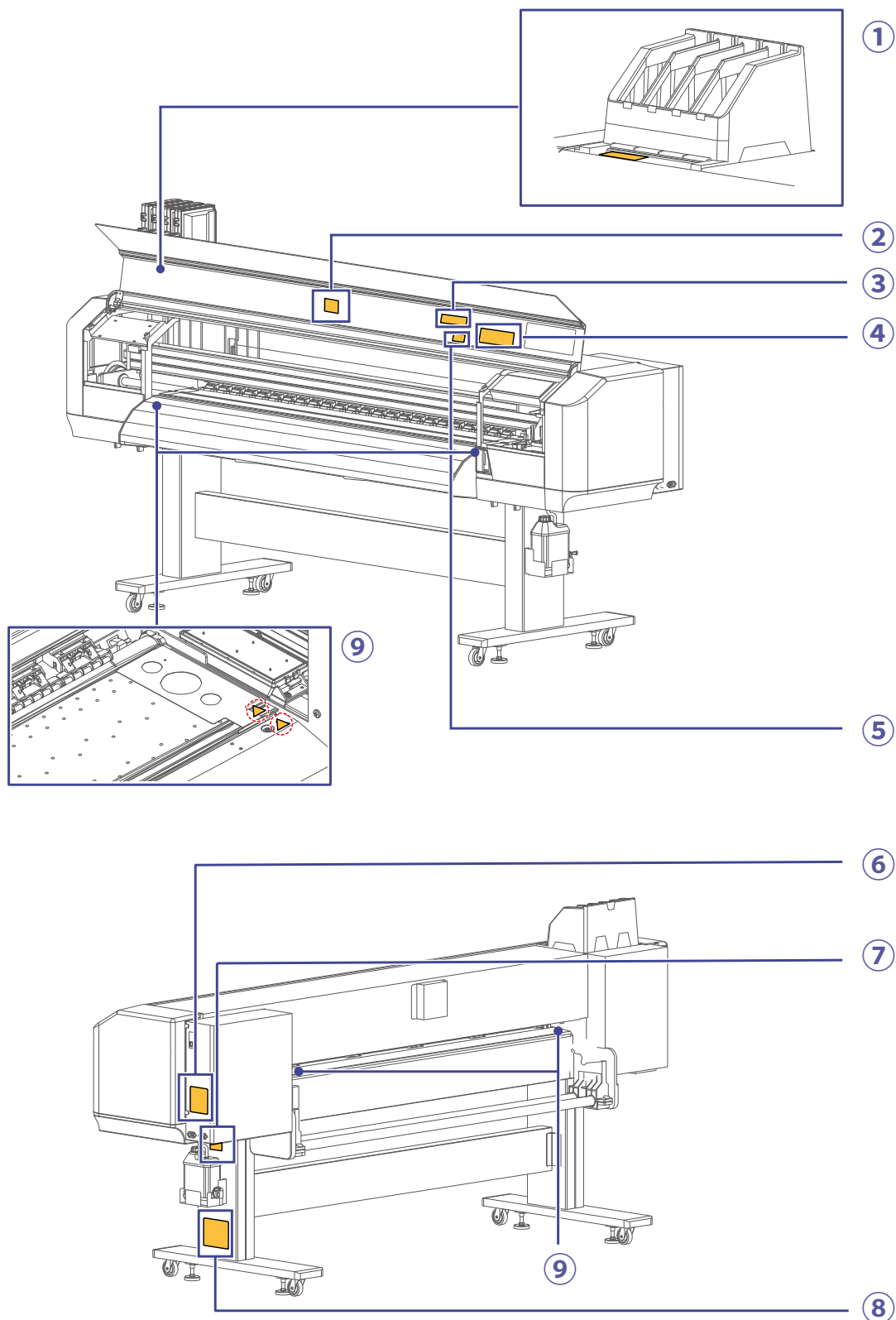
Caution

	When handling ink or doing a task that you may come into contact with ink (such as cleaning print head, capping station, wiper), make sure to wear protective equipment (gloves, goggles or eye protection, protective clothing, mask).
	
	Be careful ink does not get into eyes or skin when you handle ink bag. If ink gets in eyes or on skin, immediately flush with water.
	If left untreated, it may cause red eyes or mild irritation in the eyes. If there are some problems, immediately seek medical attention.
	Use MUTOH genuine ink. This product is designed to deliver best performance by using MUTOH genuine ink. The use of non-genuine ink may affect the product as well as print quality. The warranty does not cover the use of non genuine ink.
	Use inks within its shelf life. <ul style="list-style-type: none"> • The use of expired ink can lead to jetting failure or cause damage to the product. • When expired, replace with a new one even if ink remains in the ink bag. • Dispose of expired ink as industrial waste. Put the emptied ink bag in a plastic bag and dispose of it according to the local regulations.
	When expired, replace with a new one even if ink remains in the ink bag. Dispose of expired ink as industrial waste. Put the emptied ink bag in a plastic bag and dispose of it according to the local regulations.
	Do not allow waste fluid collected from this printer to reach sewage or natural water systems.
	Do not mix waste ink with any other chemical substances not even in small amounts. Mixing with other chemicals (such as oxidant) will cause heating.
	Do not disassemble or give strong impact to the ink bag. Doing so may cause ink leakage.

Warning labels

Warning labels are affixed to the hazardous area of the product. Read and follow the instructions on the labels.

If the label came off or got dirty, please contact your local MUTOH dealer for replacement.



Type of labels

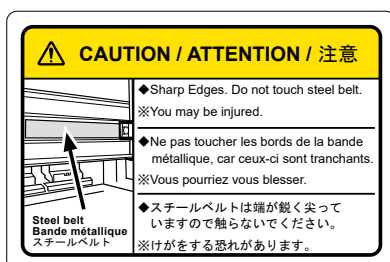
Name / Meaning

①



Personal Protective Equipment Label
Wear protective equipment when handling ink.

②



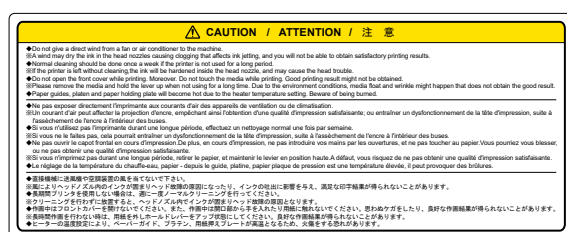
Steel Belt Caution
Do not touch this part. Risk of injury.

③



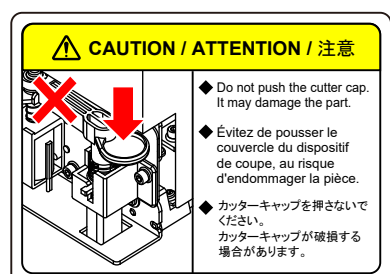
Cutter Caution
Do not place fingers near the cutter. Risk of injury from blade contact.

④



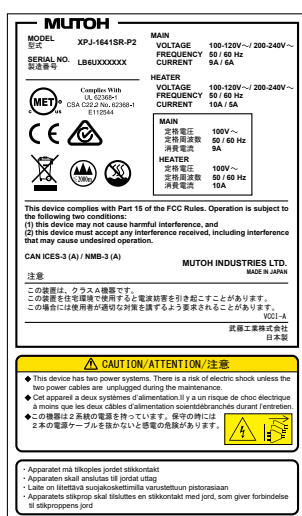
Front Cover Caution
Follow the instructions on the label.

⑤



Cutter Cap Caution
Do not push the cutter cap. This could damage the cap.

⑥



Rating Plate
Provides model, serial number, electrical ratings, certification and notification information.

⑦



Waste Fluid Drain Tube Caution Label

⑧

CAUTION / ATTENTION / 注意

Waste ink has following negative effects on human health. Wear protective mask, glasses, gloves, and clothing when handling.

- Before using this product, be sure to read the Safety Data Sheet, (SDS)
- Harmful if inhaled or gets on skin.
- Cause serious eye damage if gets in eyes.
- Cause blood or systemic toxicity, or damage to central nerve system.
- May cause allergic skin reaction or respiratory irritation, or may damage fertility, or the unborn child.
- May cause damage to blood or kidney through prolonged or repeated exposure.
- The container should be kept from open flame and well ventilated.
- Handle the ink with care to avoid the ink splash to your skin, eyes and clothing. Be to avoid accidental ingestion, be careful not to inhale the vapor.
- Contaminated clothing should be thoroughly cleaned.
- Wash your hands and goggles well after using.

Les résidus d'encre ont les effets négatifs suivants sur la santé humaine. Porter un masque, des lunettes, des gants et des vêtements de protection lors de la manipulation.

- Avant utilisation de ce produit, lisez sa fiche de données de sécurité, (SDS)
- Nocif en cas d'inhalation ou de pénétration cutanée.
- Cause des lésions oculaires graves en cas de pénétration dans les yeux.
- Provoque une toxicité sanguine ou systémique, ou des dommages au système nerveux central.
- Peut provoquer une réaction allergique de la peau ou une irritation des voies respiratoires, ou peut nuire à la fertilité ou au fœtus.
- Peut provoquer des lésions sanguines ou rénales à la suite d'expositions répétées ou d'une exposition prolongée.
- Manipuler l'encre dans un lieu bien ventilé et sans flamme ouverte.
- Manipuler l'encre avec précaution, afin qu'il n'entre pas en contact avec la peau, les yeux ou les vêtements, et d'éviter toute ingestion accidentelle.
- Manipuler également l'encre à ne pas inhaler les vapeurs d'encre.
- Les habits de travail tachés par l'encre doivent être bien nettoyés.
- Après manipulation, bien vous laver les mains et vous rincer la bouche avec soin.

Emergency Measures

- If on skin, wash well with plenty of soapy water. Consult your doctor if your skin feels irritated or is discolored.
- In eyes, wash well with plenty of tap water and seek medical attention as soon as possible.
- If accidentally swallowed, do not vomit. Consult your doctor as soon as possible.
- If inhaled vapor, move to fresh air. Consult your doctor if you experience dizziness or nausea.
- If breathing has stopped, apply artificial respiration immediately, and call emergency medical assistance.
- If spilled from the container, remove all sources of heat, ignition and flame, then wipe up with cloth. The contaminated cloth should be soaked in water until disposed.

Mesures d'urgence

- En cas de contact avec la peau, bien laver et rincer abondamment avec de l'eau savonneuse. Consulter un médecin si la peau est irritée ou si vous constatez une modification de son aspect.
- En cas de contact avec les yeux, rincer abondamment avec de l'eau du robinet, et consulter un médecin le plus rapidement possible.
- Ne pas régurgiter si vous avez ingéré de l'encre par inadvertance. Ne pas respirer si vous avez inhalé de l'encre par inadvertance.
- En cas d'inhalation de vapeurs, déplacez-vous dans un endroit où l'air est propre, consultez un médecin si vous êtes pris de vertiges ou de nausées.
- En cas d'arrêt de la respiration, pratiquer immédiatement une ventilation artificielle, et contactez les urgences.
- Si l'encre a coulé du réservoir, éliminer d'abord des sources de chaleur, des étincelles ou des flammes, puis essuyer avec un morceau de tissu. Toujours laisser tremper les tissus tachés avec de l'encre dans l'eau jusqu'à leur élimination.

応急処置

- 皮膚に付着した場合は多量の石鹸水で洗い流し、皮膚に刺激を感じたり変化があらわれる場合は医師の診察を受けてください。
- 目に入った場合は多量の水道水で洗い流し、出来るだけ早く医師の診察を受けてください。
- 吸って飲み込んだ場合は吐き出さないでください。その場でできるだけ早く医師の診察を受けてください。
- 吸気を感じた場合は空気の清浄な場所に移動し、のどや吐き気を感じる場合は医師の診察を受けてください。
- 呼吸が止まった場合はすぐに人工呼吸を行い、緊急医療を受けてください。
- 容器からこぼれた場合は火気、熱源、火花、火から遠ざかり、布等で拭き取ってください。インクが付着した布等は廃棄するまで必ず水につけておいてください。

Waste Fluid Caution Label

Waste ink is harmful to human body. Wear protective mask, goggles, protective gloves and clothing when handling.

⑨

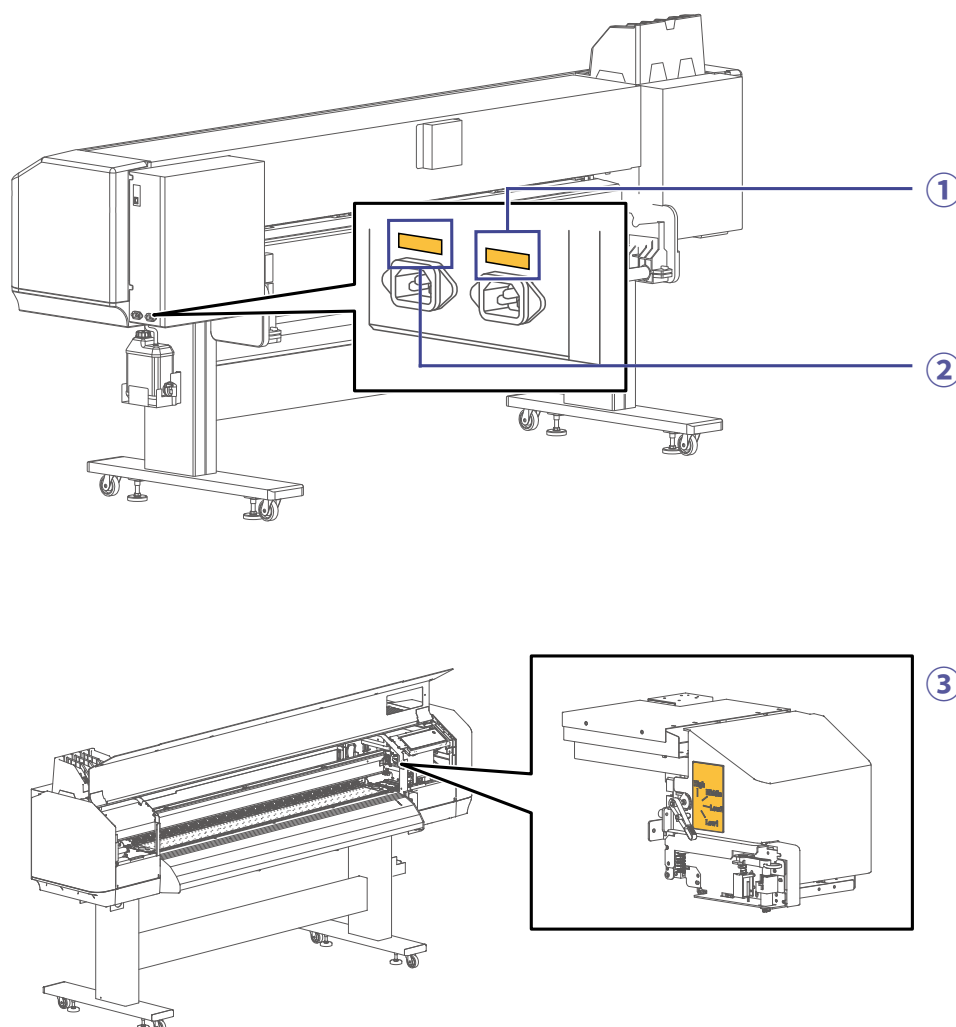




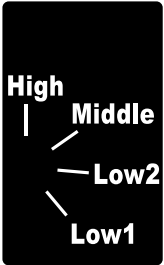
Hot Surface Hazard Label

Risk of burns. Do not touch this surface for at least 30 minutes after printing.

Instruction Labels

Instruction labels are affixed where special attention for operating this product is required. The contents of each label are shown here.



	Type of labels	Name / Meaning
①		AC Inlet Label (MAIN)
②		AC Inlet Label (HEATER)
③		PG Label <ul style="list-style-type: none"> Indicates the height of print head.

Check before installation

Installation Location Requirements

Choose the location which satisfies the requirements below.

- The floor must be level
- Avoid vibration from the neighboring devices
- Low humidity and free from dust
- Less chance of temperature and humidity changes
- Avoid direct sunlight
- Avoid water
- Avoid direct air onto the product (including air from air conditioner)
- Low levels of electromagnetic waves



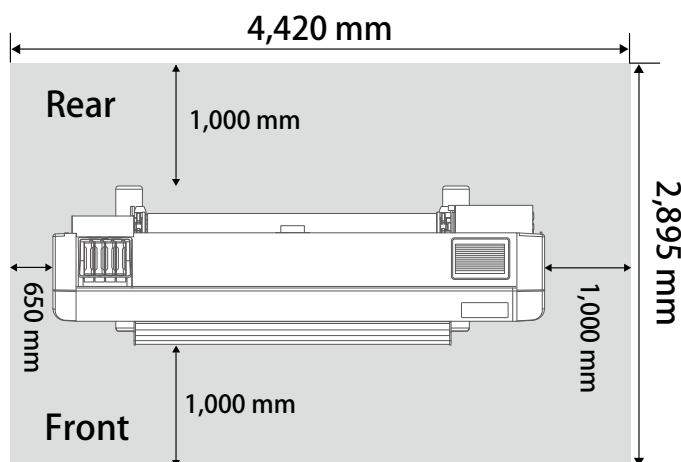
Caution

- The floor where the product is installed must be able to support this product. The weight of the product is 210 kg (295 kg including optional heavy-duty take-up unit). Installing in an unsuitable location could cause injury from a fall.
- This product is not suitable for use in a location where children are likely to be present.
- Keep the work area well-ventilated.

Odor of ink could have adversely impact on health. If you experience headache or feel dizzy or dull, stop your work and get to fresh air. If nausea persists, seek medical attention.

Minimum Space Requirements

The following space is required for installation of the product.



Printer size

W i d t h x 2,770 mm x 895 mm
Depth:

Height: 1,611 mm *1

*1 With ink bag case (1,000 ml) installed
The height of the installation space must be at least 1,760 mm.

Power specifications

The installation site must meet the following power specification:

Printer main unit:

- Input voltage:
 - AC 100V to 120V \pm 10%
 - AC 200V to 240V \pm 10%
- Input frequency:
 - 50/60 Hz \pm 1Hz
- Input load current:
 - AC 100V to 120V: 9.0 A or less
 - AC 200V to 240V: 6.0 A or less

Heater

- Input voltage:
 - AC 100V to 120V \pm 10%
 - AC 200V to 240V \pm 10%
- Input frequency:
 - 50/60 Hz \pm 1Hz
- Input load current:
 - AC 100V to 120V: 10.0 A or less
 - AC 200V to 240V: 5.0 A or less

Environmental Requirements

The installation site must meet the following environmental requirements:

Printer Operating Condition:

- Temperature: 20° C to 32° C
- Humidity: 40% to 60%, non condensing

Recommended Printing Environment:

- Temperature: 22° C to 30° C
- Humidity: 40% to 60%, non condensing

Fluctuation:

- Temperature: within 2° C per hour
- Humidity: within 5% per hour

Printer Storage Condition:

- Without ink filled : within 6 months
 - Temperature: -20° C to 60° C
 - Humidity: 20% to 80%, non condensing
- With ink filled : within 1 week
 - Temperature: -10° C to 40° C
 - Humidity: 20% to 80%, non condensing
- When stored between 32° C to 40° C: within 4 days

Ink Storage Condition:


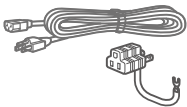


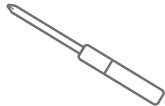
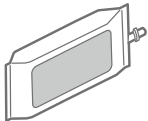
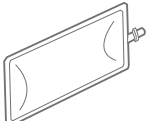
- Black, Cyan, Magenta, Yellow (1,000 ml each)
 - Temperature: -20° C to 40° C
 - Humidity: 5% to 85%, non condensing
- When stored at 40° C: within 1 month
- Keep away from heat and flammable materials. Store in a cool, dark and well-ventilated place.
- Cleaning bag (300 ml)
 - Temperature: -5° C to 40° C
 - Humidity: less than 80%, non condensing
- When stored between -5 °C to 5 °C or 30 °C to 40 °C : within 6 months

Unpacking

Preparations

Please check the points below before unpacking.

- At least four people are required for unpacking, assembling and installing this product.
- In addition to the supplied accessories, you will need the following items for installation and initial setup.

				
Computer: 1	Power cord: 2*	Gigabit Ethernet cable: 1	Media: 1*	Phillips-head screwdriver: 1
				
Ink bag (1000 ml): 4*	Cleaning bag (300 ml): 4*			

* Optional accessories or consumable supplies

Usable size of media

- 2-inch or 3-inch paper core
- Media outer diameter: up to 200 mm
- Media width: 500 mm to 1,625 mm
- Weight: up to 30 kg



Warning

Be sure to use the designated power cords. The use of non-designated cord could result in an electrical shock or fire.

Important!

Make sure your computer meets the following requirements:

- OS: Windows 11, Windows 10
- CPU: Intel (R) Core (TM) i5 or more
- Memory: 8GB minimum
- Network: Use a network port that supports Gigabit Ethernet, and an Ethernet cable that supports Category 6 Gigabit Ethernet or later.

Note

- The OS support period of software supplied from MUTOH conforms to the Microsoft support lifecycle policies.
- When using RIP software, please also check the system requirements of your RIP software.

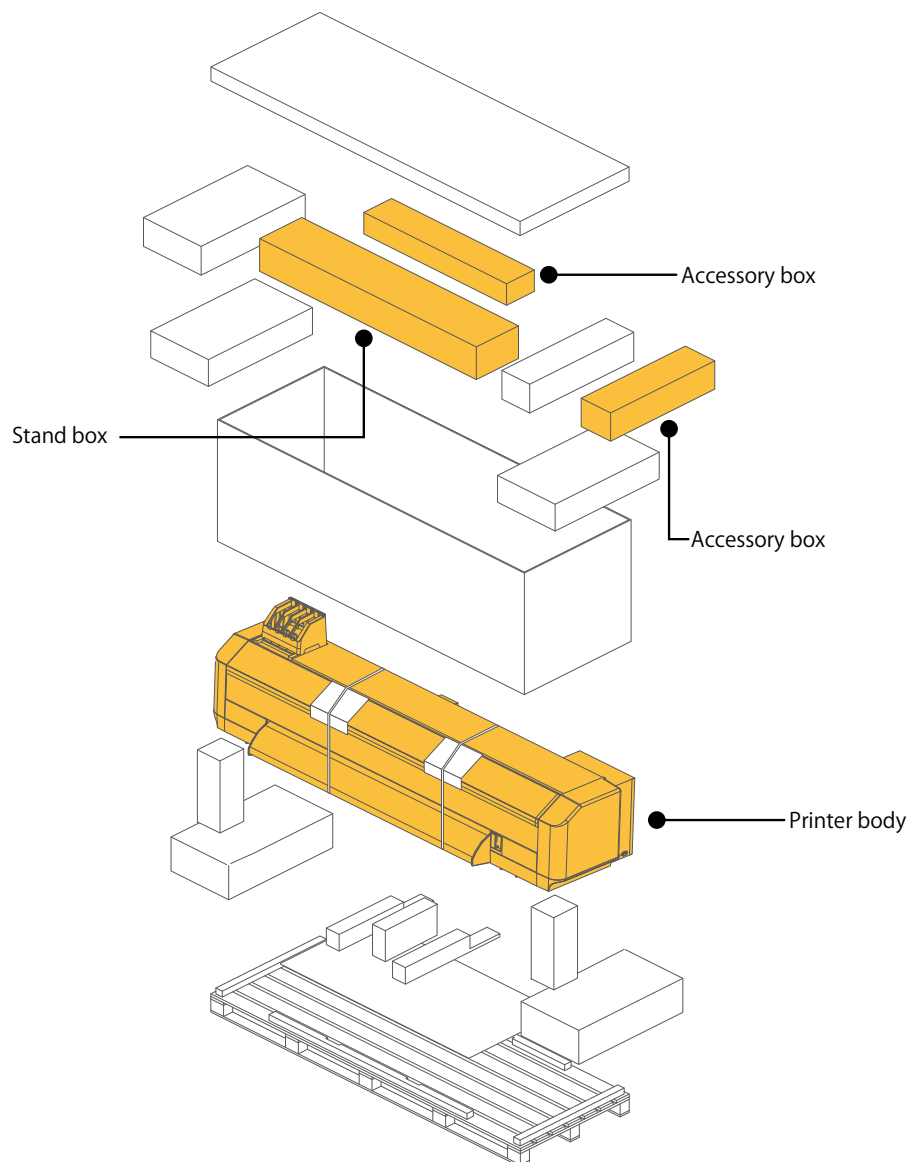
Unpacking the printer

Check that the following items are included in the box.

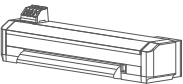
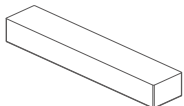
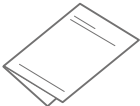


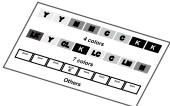


Caution



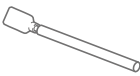

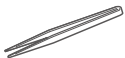
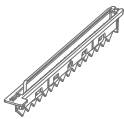

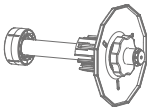

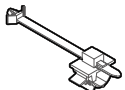
- At least four people are required for unpacking and moving the printer.
- Before taking out the printer from the packaging box, remove the plastic sheet wrapped around the printer first. Failure to do so could cause slip or damage to the product.
- Keep the printer level while moving.



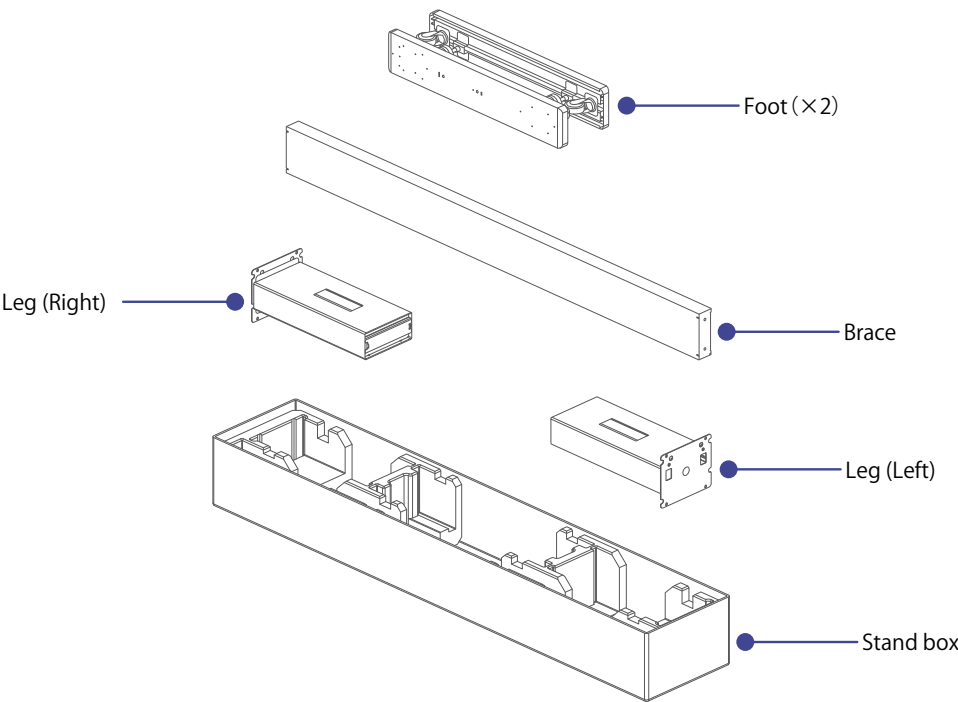
Package Contents

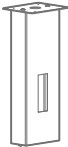
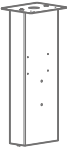

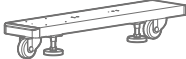


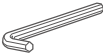




				
Printer: 1	Stand box: 1	Startup Guide: 1	Request for Registration & Download: English/Japanese 1 each	Ink Bag Case Operation Manual: English/Japanese 1 each
				
Ink color label: 1				

Contents of Accessories Box

				
Cable tie: 1	Waste ink tank: 1	Cleaning stick: 50	Paper towel: 5	Tweezers: 1
				
Cleaning wiper (Gray, for head height High): 1	Flushing box pad: 5	Media flange: 2	Ink bag case (1,000 ml): 4	Cord clamp: 2

Contents of Stand Box



 Leg (Left): 1	 Leg (Right): 1	 Brace: 1	 Foot: 2	 Hex head bolt: 8
 Spring washer: 8	 Hex wrench: 1	 Screw: 12	 Fixing bracket: 2	 Wing bolt: 8
 Waste ink tank holder: 1				

Assembling

Assembling the stand

Follow these steps to assemble the stand.



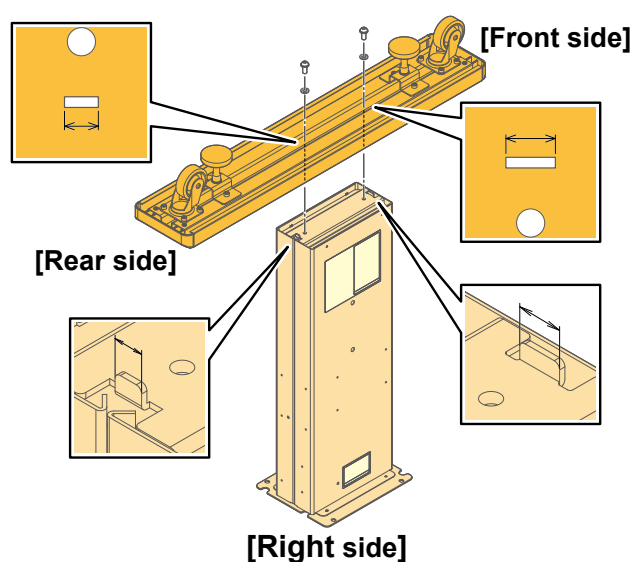
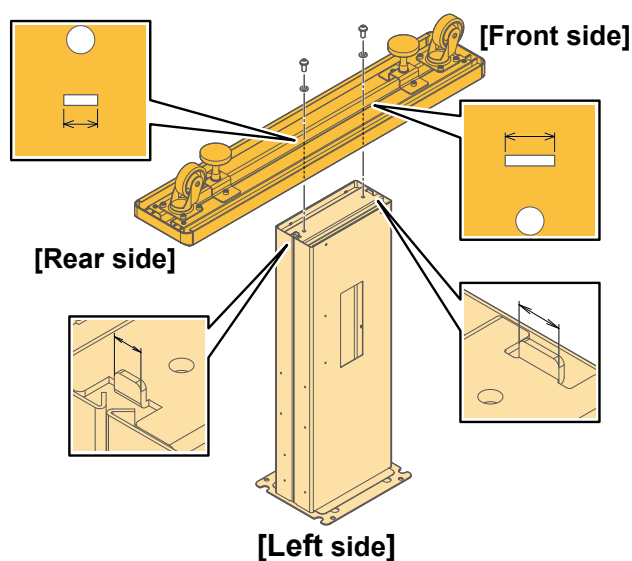
Caution

At least two people are required for this task.

Procedure

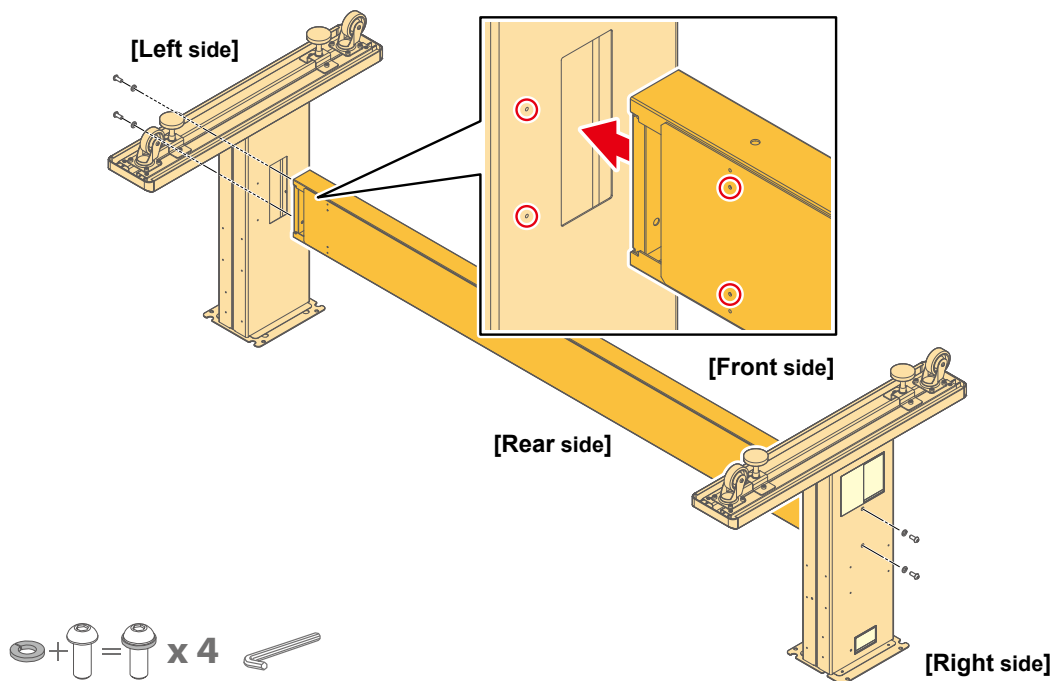
1 Attach the foot to the leg.

- Align the notch on the foot with the protrusion on the leg. The side with large notch and protrusion is on the front side.
- Secure with the hex head bolt with spring washer attached (x2 each).

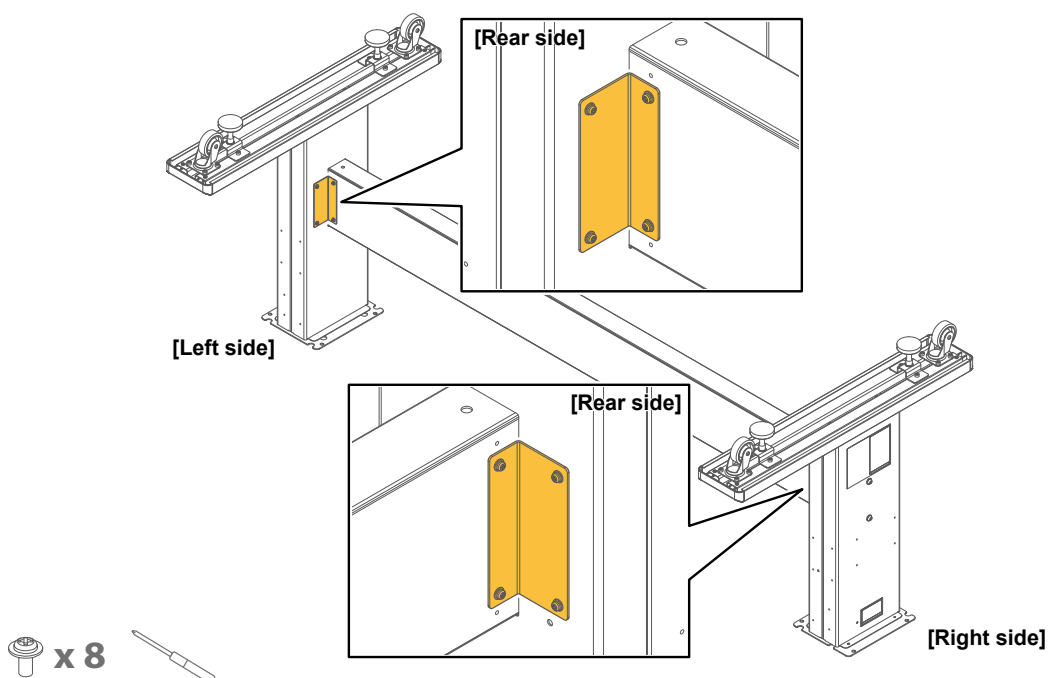


2 Attach the brace to the legs.

- The side with screw holes (marked with red circle) on the leg and brace is on the rear side. The leg with the warning label attached is on the right side.
- Secure with the hex head bolt with spring washer attached (x2 each).

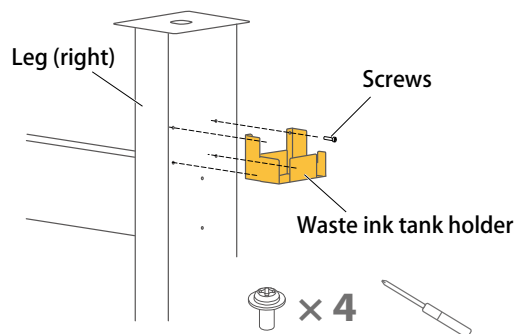


3 Secure the fixing brackets (x2) with screws (x4 each).



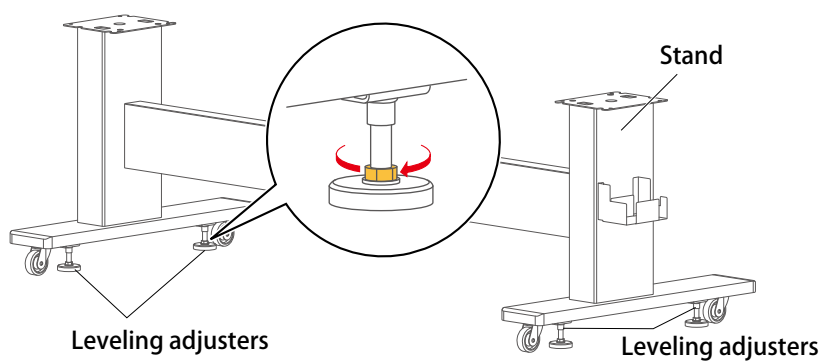
4 Flip the stand over to its upright position.

- 5** Use the screws (x4) to secure the waste ink tank holder to the leg (right).



- 6** Shake the stand to make sure that each part is firmly attached.

- 7** Turn the leveling adjusters (x4) to the direction shown in the illustration until the stand does not move.



Attaching the printer

Follow these steps to attach the printer to the stand.

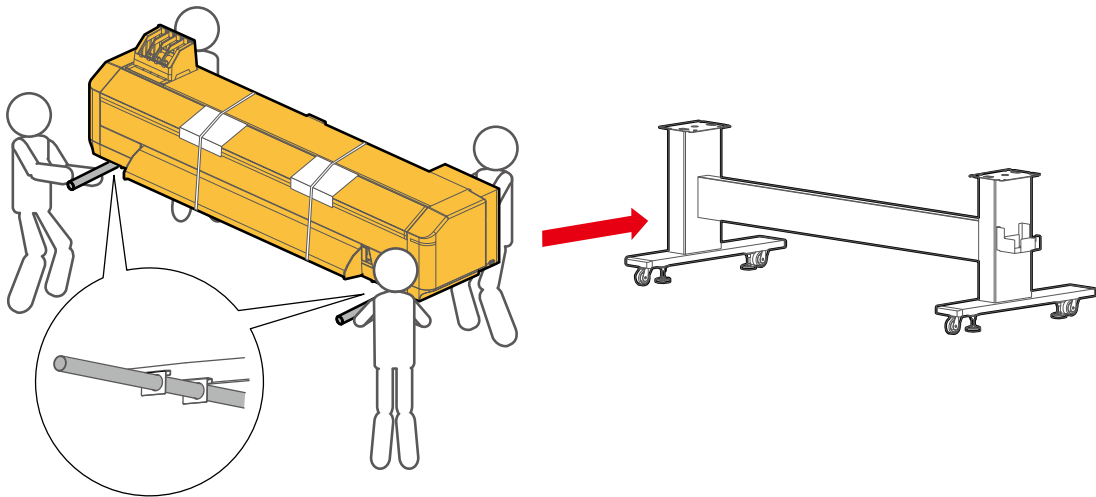
Caution

- At least four people are required for unpacking and moving the printer.
- Before taking out the printer from the packaging box, remove the plastic sheet wrapped around the printer first. Failure to do so could cause slip or damage to the product.
- Keep the printer level while moving.

Procedure

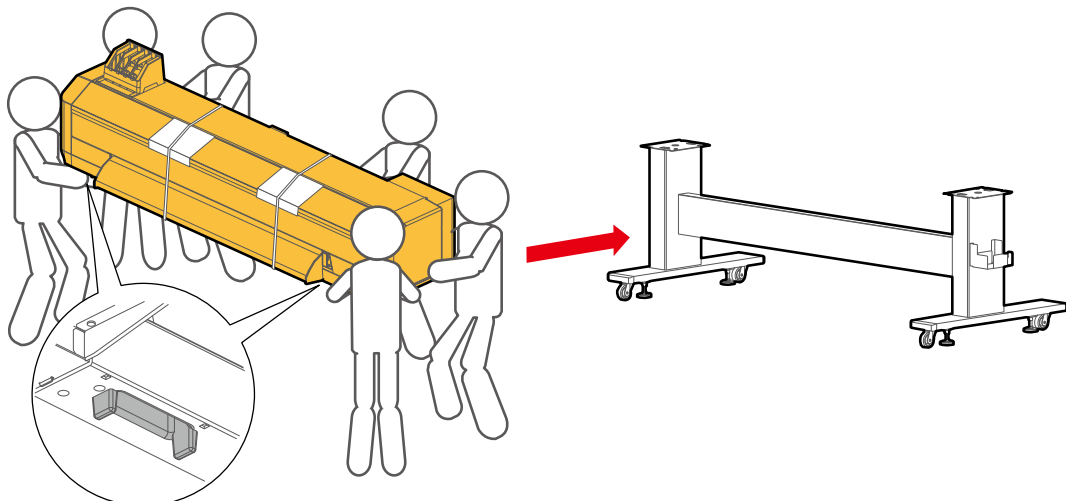
1 Lift the printer with at least four people and mount it on the stand.

Insert two lifting bars into the guide holes at the bottom left and right of the printer and lift the printer.

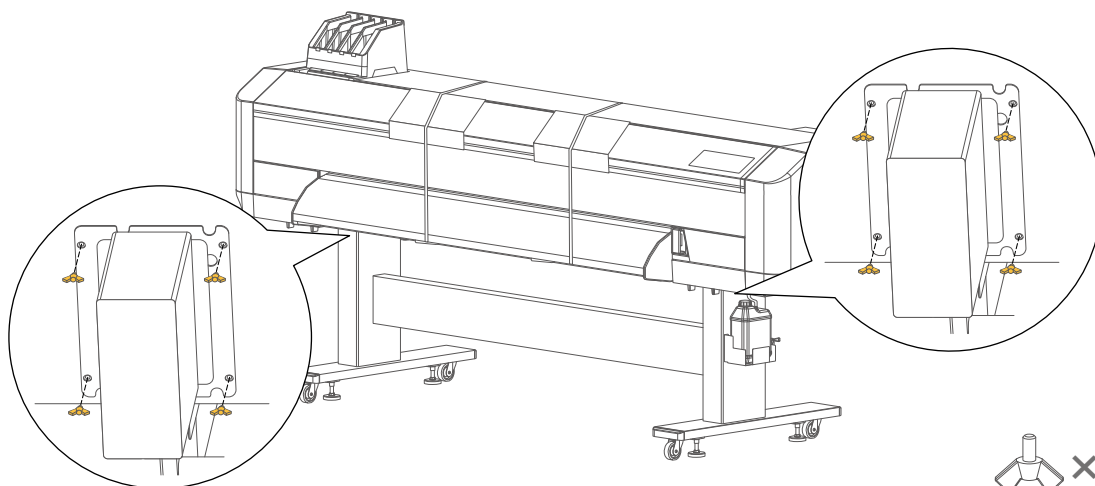


■ (If you do not have lifting bars)

- Lift the printer with at least six people and mount it on the stand.
- When holding the front side of the printer, use the handholds at the front bottom of the printer.



- 2** Use the wing bolts (x8) to fix the stand to the printer.



Attaching the waste ink tank

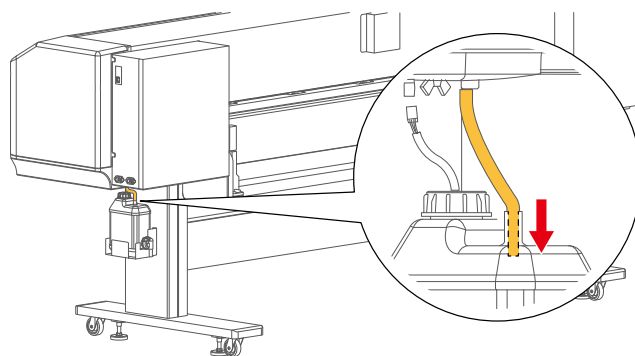
Follow these steps to attach the waste ink tank.

Procedure

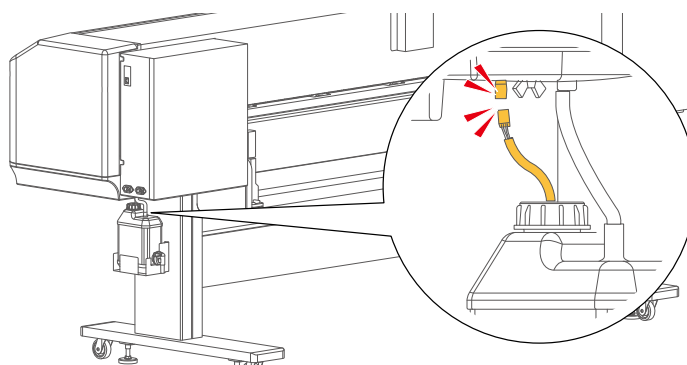
1 Place the waste ink tank on the waste ink tank holder.

2 Attach the waste ink tube to the waste ink tank.

Insert the waste ink tube into the mouth of the waste ink tank.



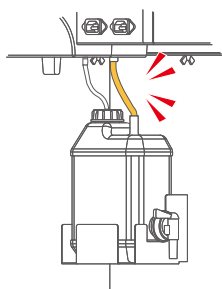
3 Connect the waste ink sensor cable to the waste ink sensor connector.



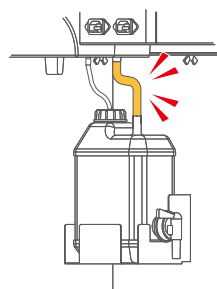
Important!

- Check that the tube is firmly inserted in the mouth of the tank. Failure to insert it firmly may cause ink to leak.
- Once the tube has been attached to the waste ink tank, check that there is no fold or bend in the tube. This will cause ink leakage.

Good



Not Good

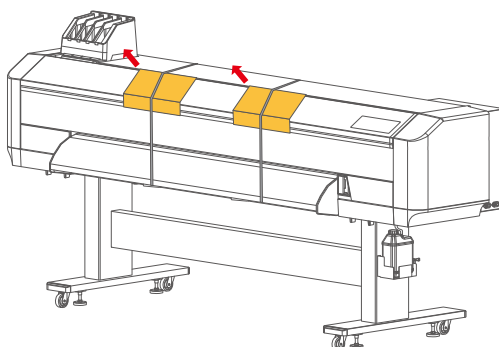


Removing protective materials

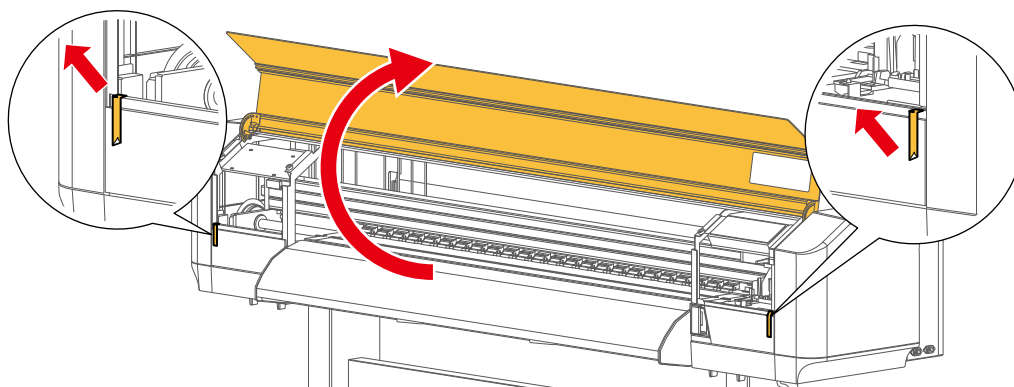
Follow these steps to remove protective materials from the printer.

Procedure

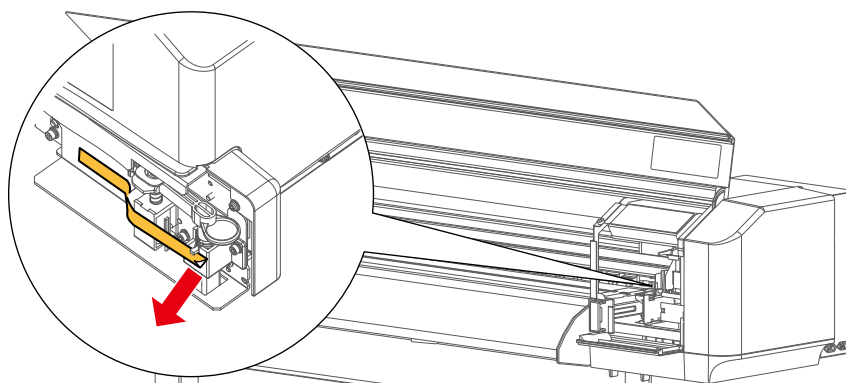
- 1 Remove the protective materials from the front cover.



- 2 Open the front cover and remove the tape from the maintenance cover.

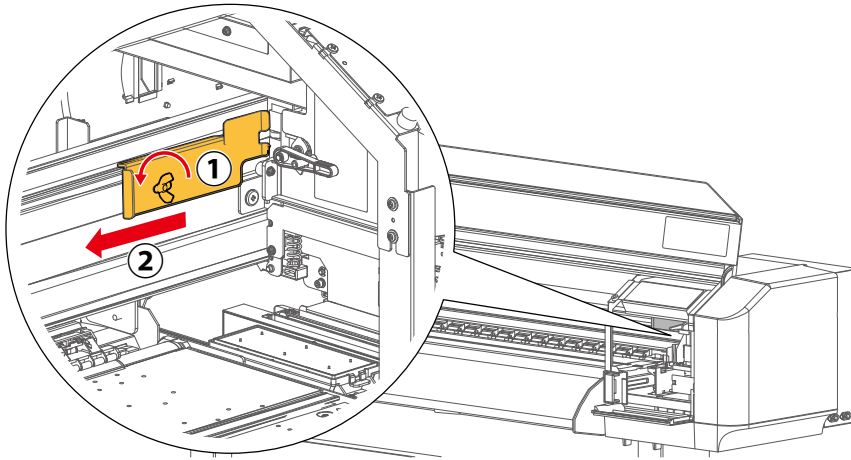


- 3 Remove the tape from the cutter cap.



4 Remove the shipping bracket from the carriage.

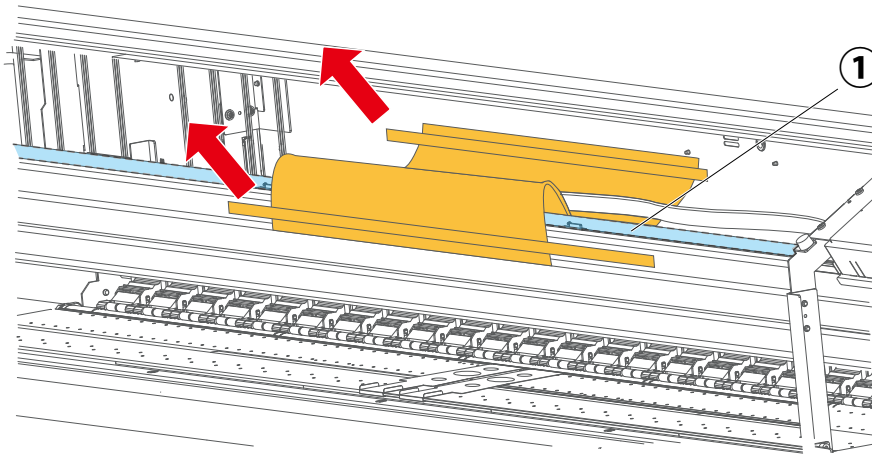
- a. Loosen the wing bolt (①).
- b. Remove the shipping bracket together with the wing bolt from the carriage (②).



Important!

You will need the shipping bracket and the wing bolt removed from the carriage for transporting. Keep them for reuse.

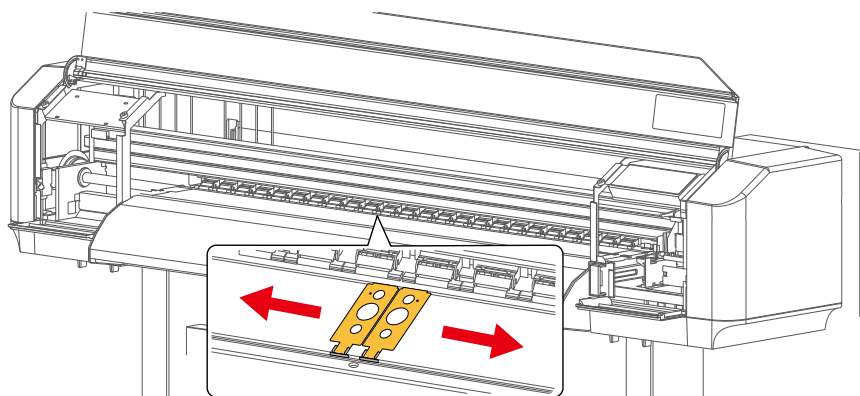
5 Remove the tapes to remove the protective materials attached inside the front cover.



Important!

Never touch the T fence (① : clear parts) when removing the protective material. Deformation of T fence will affect print quality.

- 6** Remove the tapes and move the edge holders to the left and right end of the printer.



- 7** Remove all the tapes attached to the printer.

Connecting the cables

Connecting the power cord to the printer

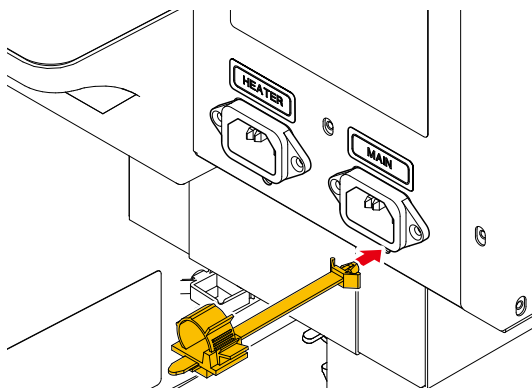


Warning

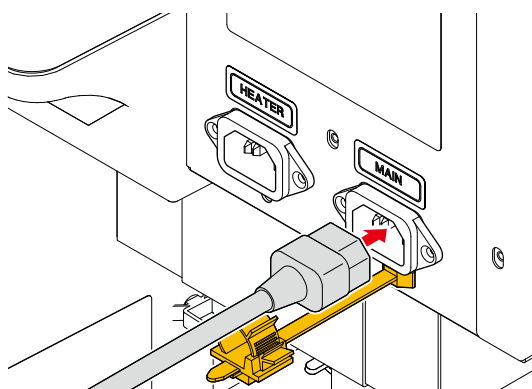
Make sure to plug all the power cords into the wall outlets with the same voltage. Failure to do so may cause damage to the electrical circuit.

Procedure

- 1 Check the front cover is closed.
- 2 Attach the cord clamp to the printer.

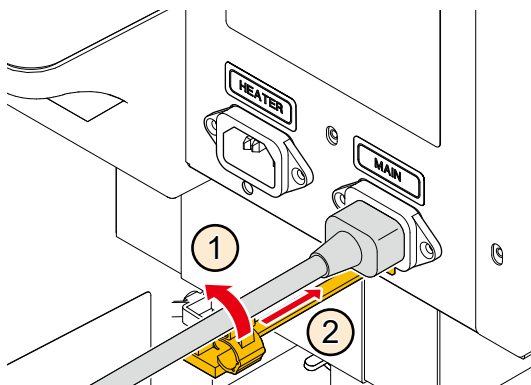


- 3 Connect the power cord to the printer inlet.



4 Secure the power cord to the cord clamp.

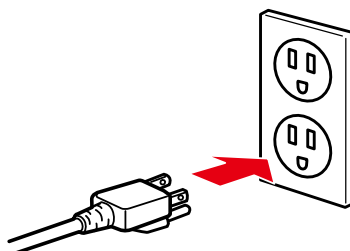
- a. Pass the power cord through the clamp and push until it clicks into place.
- b. Slide the clamp toward the inlet.



Important!

Connect the power cord for the heater in the same way.

5 Attach the cord clamp to the printer.



Warning

Do not use power strips.



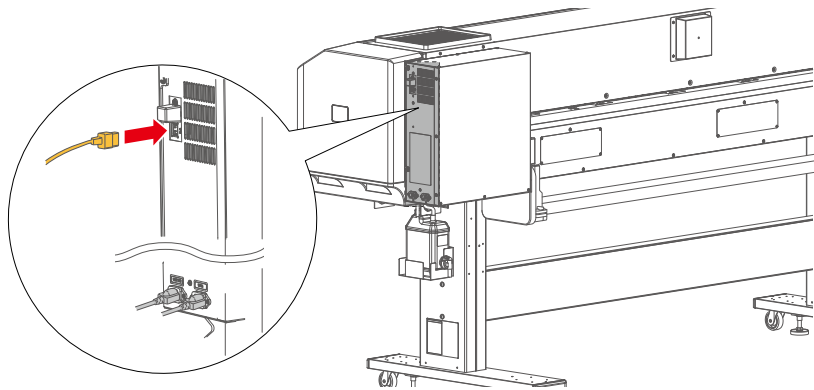
Warning

This printer uses multiple power cords. To unplug from the wall outlet, make sure to unplug all of them. There is a risk of electric shock.

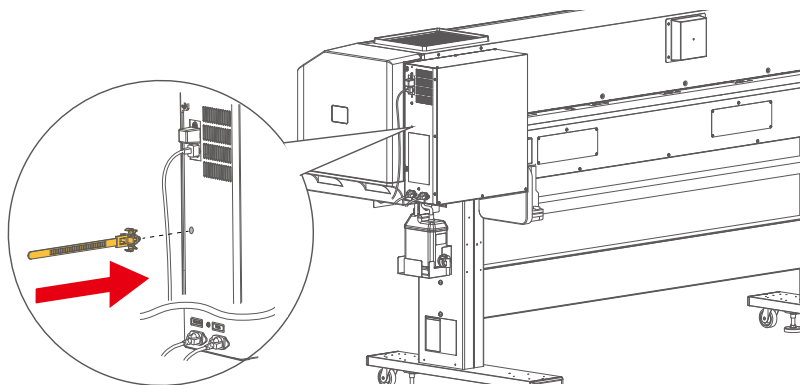
Connecting the Ethernet cable

Procedure

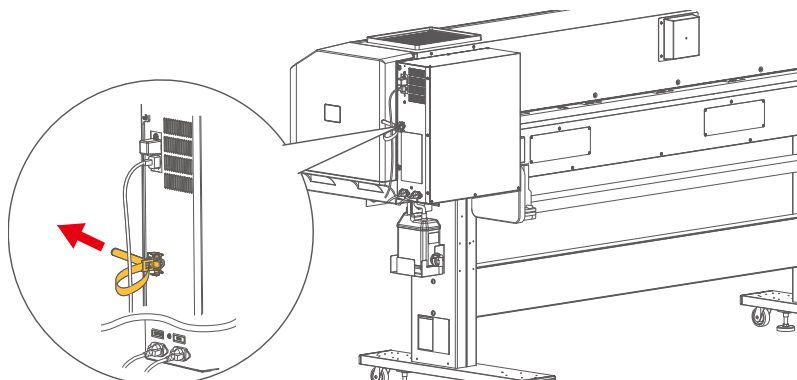
- 1 Connect the Ethernet cable to the printer.



- 2 Attach the cable tie to the printer.



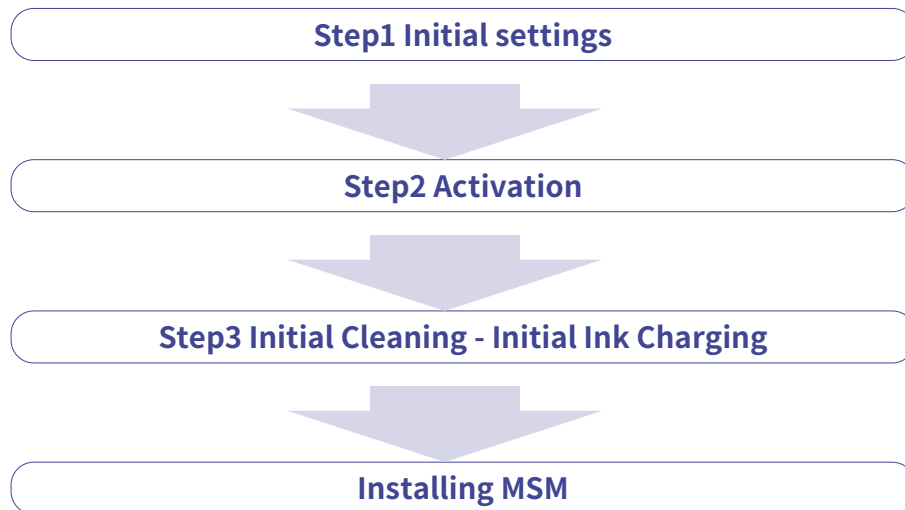
- 3 Secure the Ethernet cable with the cable tie.



Setup

Initial Setup Flow

Here is how to get started with your printer.



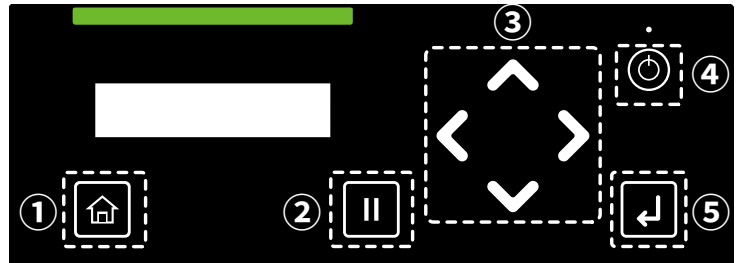
How to use the printer control panel

The printer control panel is the touch panel and the active keys are lit up on the panel for guidance.

- Tap: Lightly touch the key and immediately release it.
- Long-touch: Keep touching the key.

key names

- ① : [Home] key
- ② : [Cancel] key
- ③ : [▲]/[▼]/[<]/[>] (arrow) keys
- ④ : Power button
- ⑤ : [Enter] key



Step1 Initial settings

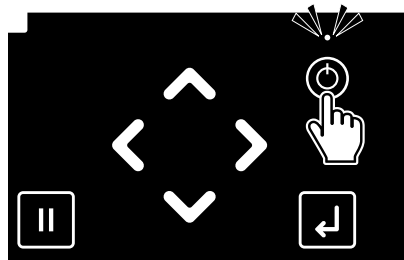
Turn on the printer and configure the initial settings on the control panel.

Procedure

1 Check that the front cover is closed.

2 Turn on the printer.

- Press the power button on the printer control panel for more than two seconds.
- The power LED above the power button and keys light up.



Note

Once the power LED lights up, release the power button.

3 Select the language to be displayed on the control panel.

Use [▲]/[▼] keys to select the language and tap [Enter] key.

Language: English

Note

[Language: English] will appear for the first time.

4 Select the unit of temperature.

Use [**▲**] / [**▼**] keys to select the unit and tap [**Enter**] key.

Temperature: Celsius[° C]

5 Select the unit of length.

Use [**▲**] / [**▼**] keys to select the unit and tap [**Enter**] key.

Length: mm

6 Assign the IP address of the printer.

- [**▲**] / [**▼**] key : increase or decrease numbers.
- [**<**] / [**>**] key : move the cursor to the previous or next digit number.
- Tap Enter key after entering all digits.

IP Address: 192. 168. 1. 253

7 Assign the subnet mask of the printer.

- [**▲**] / [**▼**] key : increase or decrease numbers.
- [**<**] / [**>**] key : move the cursor to the previous or next digit number.
- Enter all the digits. Tap [**Enter**] key after entering all digits.

Subnet Mask: 255. 255. 255. 0

8 Assign the gateway of the printer.

- [**▲**] / [**▼**] key : increase or decrease numbers.
- [**<**] / [**>**] key : move the cursor to the previous or next digit number.
- Enter all the digits. Tap Enter key after entering all digits.

Gateway: 192. 168. 1. 254

9 Select how the alert buzzer beeps when an error occurs.

Use [**▲**] / [**▼**] keys to select an option and tap [**Enter**] key.

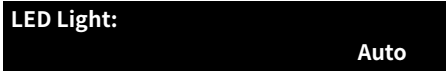
- [**On**] : Tapping any key on the printer control panel will stop the buzzer sound. This is the default setting.
- [**Off**] : The buzzer beeps several times and then stops automatically.

Alert Buzzer: On

10 Select how to turn on internal lights.

Use [**▲**] / [**▼**] keys to select an option and tap [**Enter**] key.

- **[Auto]** : Internal lights automatically turn on. It turns on while printing, cover open, detecting media, cutting media, feeding media or setting origin. This is the default setting.
- **[On]** : Internal lights always turn on. However, it turns off during sleep mode or when the printer is turned off.
- **[Off]** : Internal lights always turn off.



LED Light: **Auto**

11 Printer initialization begins.



Initializing

Step2 Activation

When the message "Activation required" appears, activate your printer.

There are two methods for activation. Choose the method you prefer.

→ "Activation from the printer control panel" P.39

→ "Activation through Internet" P.40

Note

While [**Activation required**] is displayed, you can redo the initial settings (e.g. IP Address etc.) by tapping [**Home**] key.

Activation from the printer control panel

Follow the instructions on the printer control panel to perform activation.

Procedure

1 When [**Activation required**] appears, tap [**Enter**] key.

2 Enter the 16-digit activation code.

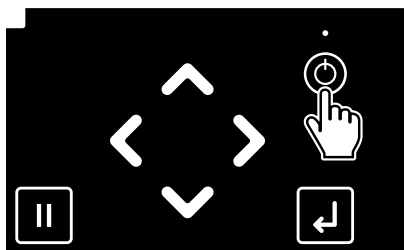
- [**▲**] / [**▼**] key : increase or decrease numbers.
- [**<**] / [**>**] key: move the cursor to the previous or next digit number.
- After entering all digits, tap [**Enter**] key.

0 0 0 0 - 0 0 0 0 - 0 0 0 0 - 0 0 0 0

Note

For activation code, please contact your local MUTOH dealer to obtain it by email, etc.

3 When [**Activation Succeeded/ Reboot Printer**] appears, press the power button for more than two seconds to turn off the printer.



- When [**Power Off**] appears, release the power button.
- Wait for a few seconds and then press the power button for more than two seconds to reboot the printer.

Note

If the activation code is wrong, the display will show [**Activation Failed/ Reboot Printer**]. Reboot the printer and then do the activation again.

Activation through Internet

Follow the instructions on the Printer Activation Guide to activate the printer.

Note

Printer Activation Guide and the activation code can be obtained from MUTOH Club.

Access to MUTOH Club from the following URL and click "Register" to complete the user registration.

<https://mutoh-club.com/mutoh/guser/>

Step3 Initial Cleaning - Initial Ink Charging

Follow these steps to perform initial cleaning and initial ink charging.

What you need

- Cleaning bag : x4
- Ink bag : x4 (Black, Cyan, Magenta, Yellow)
- Ink bag case : x4

Important!

- Use new cleaning and ink bags.
- When performing initial cleaning and initial ink charging, make sure that the print head height is set to "Low1" (factory default).



Make sure to read the following sections before this task.

- "Handling" P.6
- "Ink and waste fluid" P.10

1. Performing initial cleaning

Procedure

- 1 When [**Ink Charge Start** -> **Enter**] appears, tap [**Enter**] key.

Note

While [**Activation required**] is displayed, you can redo the initial settings (e.g. IP Address etc.) by tapping [**Home**] key.

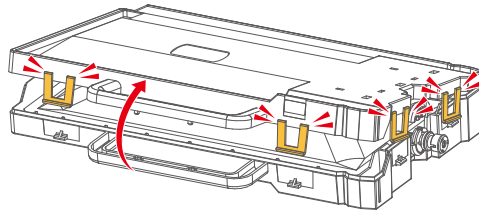
- a. When [**Remove Bags**] appears, remove all the ink bags and smartchip cards.
- b. Flushing begins.

Washing Head

- c. When discharging is completed, the display will show [**Insert Cleaning Bags**].

2 Place the cleaning bag in the ink bag case.

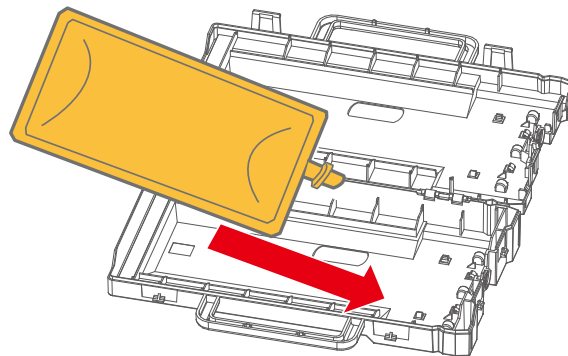
- a. Unlock four latches and open the ink bag case.



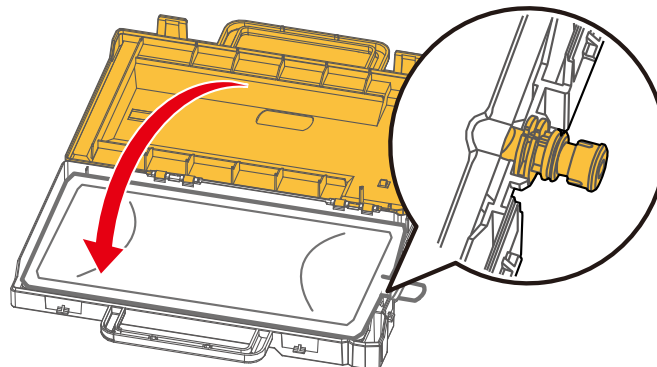
Important!

Do not apply excessive force when unlocking the latch. This will cause damage to the latch.

- b. Place the cleaning bag in the ink bag case.



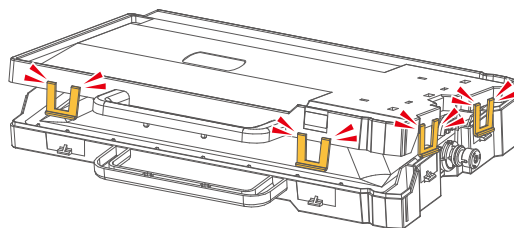
- c. Close the ink bag case.



Important!

Make sure that the spout of the ink bag is properly fitted into the groove in the case. If not fitted, the printer cannot correctly detect the ink bag.

- d. Close the latches (x4) of the case properly.

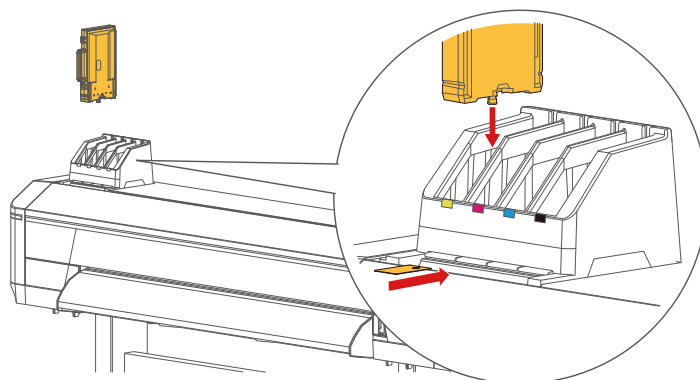


Important!

Check that all the latches (x4) are closed. If not, it may cause ink to leak.

3 Insert the ink bag case and smartchip card into their respective slots.

- a. Face the latch side towards you and insert the case into the slot. Make sure that they are fully inserted.



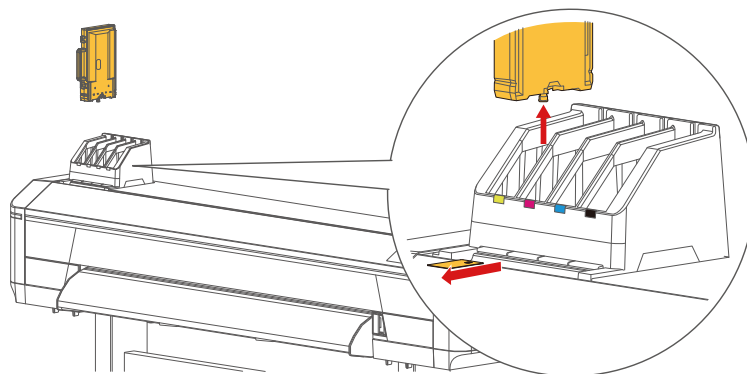
- b. Cleaning solution filling begins.

Washing Head

- c. Once the printer is filled with the cleaning solution, the display will show "Remove Bags".

4 Remove the ink bag cases and smartchip cards from the slots.

- a. Remove all ink bag cases and smartchip cards. Store the cleaning bag together with the corresponding smartchip card.



- b. Once removed, it begins flushing cleaning solution out of the printer.

Washing Head

- c. When flushing is completed, the display will show **[Insert Cleaning Bags]**.

5 Repeat steps 4 and 5.

6 When the following message appears during flushing, empty the waste ink tank.

Empty Waste Ink Tank
then Tap Enter

→ "2.Emptying waste ink tank" P.44

2.Emptying waste ink tank



Make sure to read the following sections before this task.

- "Handling" P.6
- "Ink and waste fluid" P.10

Procedure

1 Prepare a container to collect waste fluid.

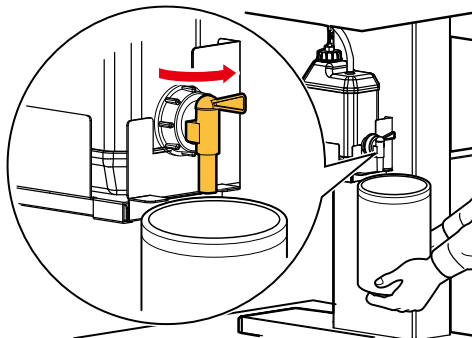
Important!

The capacity of the waste ink tank is 2,000 ml. Make sure to prepare a container that has enough capacity to collect waste fluid.

2 Cover the floor under the waste ink tank with waste paper or cloth.

3 Wear protective equipment.

4 Open the drain tube valve to drain waste fluid to the empty container.

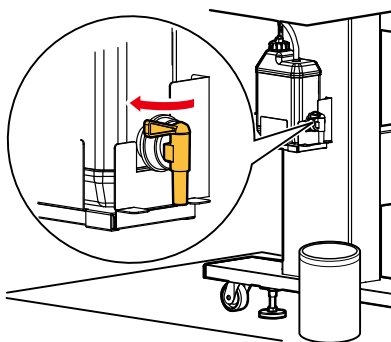


Important!

Waste fluid may splash while draining from the waste ink tank. Make sure to put the tip of the drain tube valve in the empty container and start draining.

5 Once you finish emptying the tank, close the drain tube valve firmly.

Use a dry cloth to clean the tip of the valve.

**6** Dispose of the waste fluids as industrial waste.**7** Once emptying the tank, tap **[Enter]** key.

Empty Waste Ink Tank
then Tap Enter

**Warning**

Waste fluid collected from the product is classified as waste oil of industrial waste.

You are obligated to properly dispose of waste fluid from the printer in compliance with Wastes Disposal and Public Cleansing Act and local ordinances. Delegate disposal to an industrial waste disposal contractor.

Initial Ink Charging



Caution



Do not attempt the following actions during ink charging:

- Turn off the printer.
- Unplug the power cord of the printer.
- Open the front cover.
- Open the maintenance cover.
- Raise the pressure rollers.

Procedure

- 1 When **[Wash Retry? No]** appears, tap **[Enter]** key.

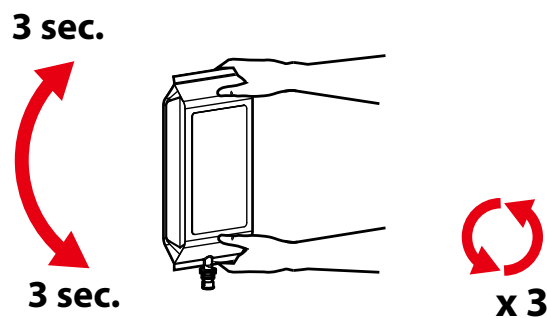
Note

To perform a cleaning again, use **[V]** key to select **[Wash Retry? Yes]** and tap **[Enter]** key. Then follow the instructions on the printer control panel.

When flushing is completed, the display will show **[Insert Ink Bags]**. Move to the next step.

[Insert Ink Bags] will be displayed.

- 2 Agitate the ink in a new ink bag.
 - a. Hold the ink bag with the ink outlet facing up and wait for three seconds.
 - b. Invert it with the ink outlet facing down and wait for three seconds.
 - c. Repeat this 3 times.

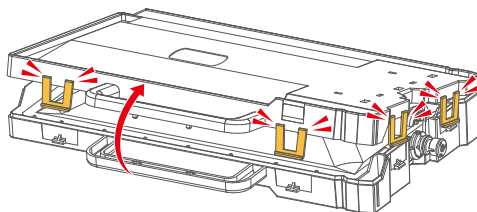


Important!

Be sure to use a new ink bag. If an ink bag does not have enough ink, it will run out of ink during initial ink charging and will consume more ink.

3 Place the ink bag in the ink bag case.

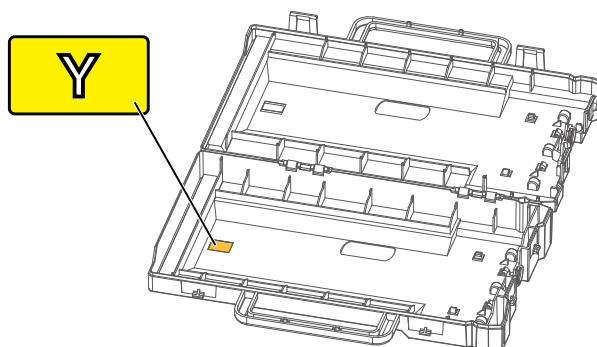
- a. Unlock four latches and open the ink bag case.



Important!

Do not apply excessive force when unlocking the latch. This will cause damage to the latch.

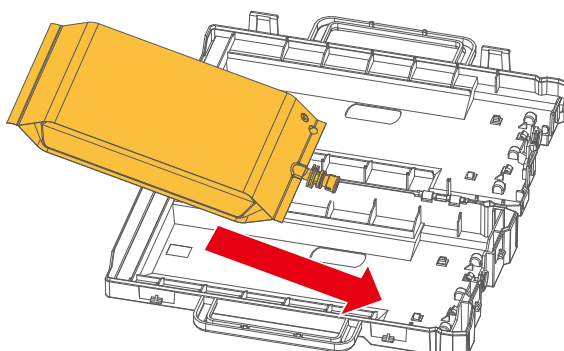
- b. Apply an ink color label to the inside of the case.
- Label placement position: within the recess as shown in the illustration



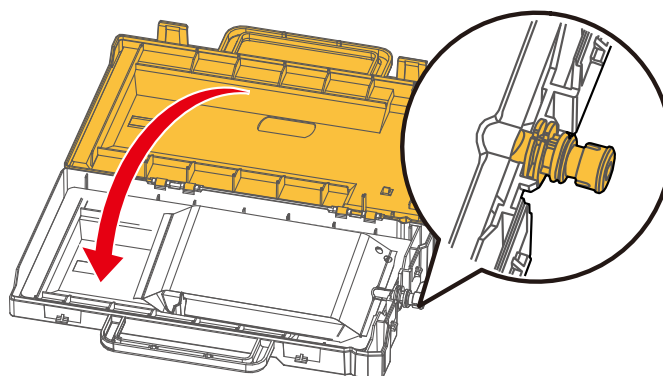
Note

The ink color label is included in the accessories box.

- c. Place the ink bag in the ink bag case.



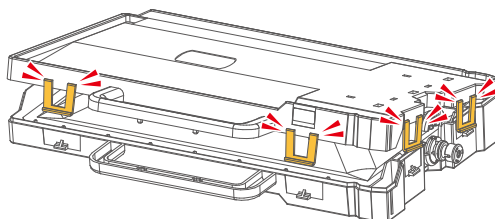
- d. Close the ink bag case.



Important!

Make sure that the spout of the ink bag is properly fitted into the groove in the case. If not fitted, the printer cannot correctly detect the ink bag.

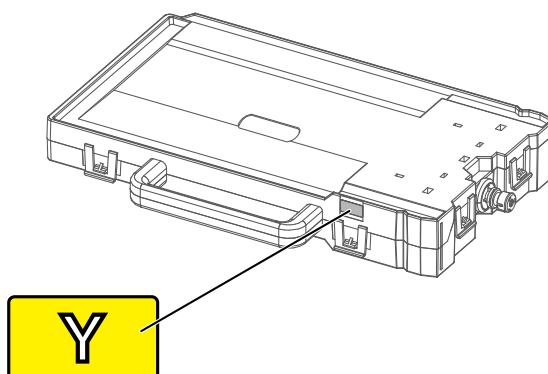
- e. Close the latches (x4) of the case properly.



Important!

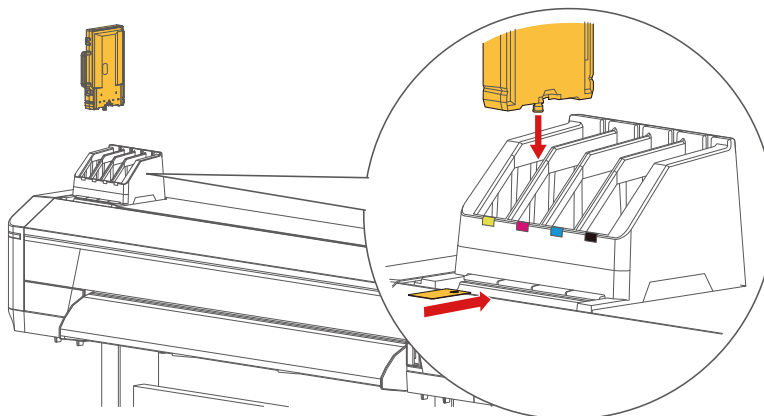
Check that all the latches (x4) are closed. If not, it may cause ink to leak.

- f. Apply an ink color label on the outside of the case. Make sure to match the color of the label with the one applied on the inside of the case.
- Label placement position: within the recess as shown in the illustration



4 Insert the ink bag case and smartchip card into their respective slots.

- a. Make sure to match the color of the ink bag label with the color of the label attached to the ink slot.
 - Face the latch side towards you and insert the case into the slot.
 - Make sure that they are fully inserted.



- b. Once loaded, ink charging begins.

Ink Refill **0%

5 When ink charging is completed, the display will show **[Media End]**.

Media End
PG : Low1

Installing MSM

Install the MUTOH Status Monitor (MSM) in the computer that will connect to the printer.

MSM must be installed on your computer before printing. Once installed, follow the instructions on the MSM operation manual to complete initial set up and printer registration.

➔ **MUTOH Status Monitor Operation manual "Initial Setting"**

Various software and manuals can be downloaded from MUTOH Club. The downloadable software and manuals are as follows:

MUTOH Status Monitor (MSM)	Allows you to view printer status, change printer settings and run a test print.
Manuals (Printer and software)	<div>The following manuals are available in PDF format.</div> <ul style="list-style-type: none">• XPJ-1641SR-P II Operation Manual “Operation and Maintenance Methods”• XPJ-1641SR-P II Startup Guide (this document)• MUTOH Status Monitor Operation Manual

🔊 Important!

Make sure to use MSM downloaded from MUTOH Club.

Installing procedure

Procedure

- 1 Follow the instructions on the "Request for User Registration & Download" sheet supplied with the printer to complete user registration and download.
- 2 Unzip the file downloaded to any location.
- 3 Open the folder and double click the setup.exe.

MUTOH