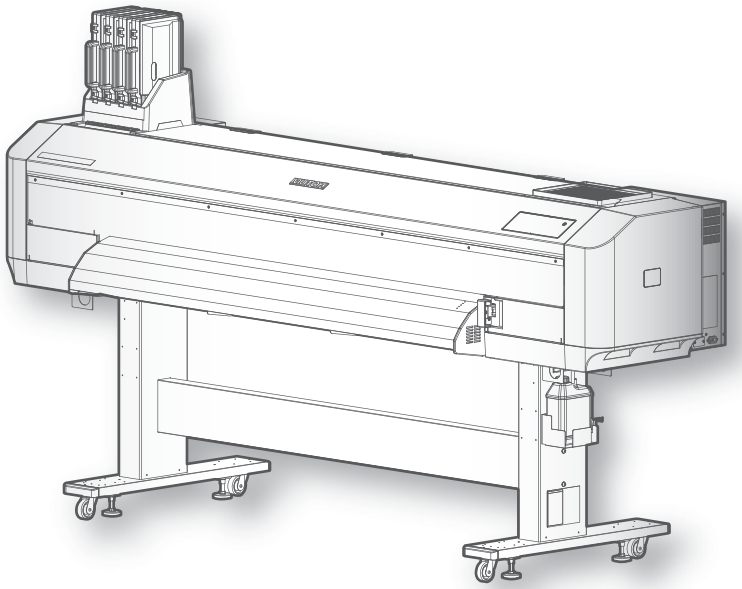
MUTOH

XPJ-1642WR

Startup Guide

Unpacking and Initial Setup



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- 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.
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Site Preparation

Choose the location which satisfies the requirements below.

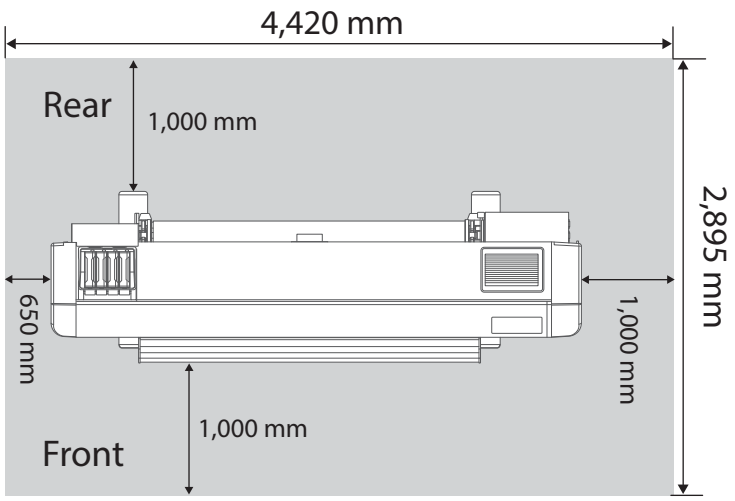
Installation Location Requirements

- 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 printer.
- Low levels of electromagnetic waves.

⚠ CAUTION	• Choose the floor that can safely support the weight of this product. **The total weight of printer and stand is 250 kg.** **If the floor does not have sufficient load capacity, it can lead to injury from a fall.** • This equipment is not suitable for use in locations where children are likely to be present. • Keep the work area well ventilated while operating. **Ink odor may cause health problem such as headache, dizziness, or dull. If you experience these symptoms, stop printer operation and move to fresh air. Seek medical attention if vomit persists.**

The following space is required for installation.

Minimum Space Requirements



Printer Size	
Width x Depth:	2,770 mm x 895 mm
Height	:1,611 mm *1
	:1,712 mm *2

***1 When installing 1,000 ml ink bag cases. The room height should be at least 1,760 mm.**

***2 When installing 2,200 ml ink bag cases. The room height should be at least 1,861 mm.**

The installation site must meet the power specification and environmental requirements below.

Power Specification

- Input voltage:
  AC 100V to 120V±10%
  AC 200V to 240V±10%
- Input frequency:
  50 / 60Hz ±1Hz
- Input load current:
  11.5 A (AC 100V to 120V)
  6.0 A (AC 200V to 240V)

Environmental Requirements

- Operating condition:
  Temperature: 20°C to 32°C
  Humidity: 40% to 60%, non condensing
- Printing Condition:
  Temperature: 22°C to 30°C
  Humidity: 40% to 60%, non condensing
- Change rate
  Temperature: No more than 2 °C per 1 hour
  Humidity: No more than 5% per 1 hour
- Printer Storage Condition
  Without ink filled: Up to 6 months
  Temperature: -20°C to 60°C
  Humidity: 20% to 80%, non condensing

  With ink filled:
  Temperature: -5°C to 35°C
  Humidity: 20% to 80%, non condensing
- Ink Storage Condition
  Black / Cyan / Magenta / Yellow (1,000 ml each, or 2,200 ml each)
  Temperature: -5°C to 40°C, Avoid direct sunlight, When unopened
  Humidity: 5% to 85%, non condensing

  Cleaning bag (600 ml)
  Temperature: 10°C to 40°C
  Humidity: 80% or less non condensing

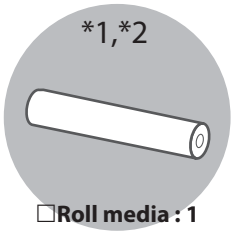
Unpacking

Before unpacking, read the instructions below and prepare the necessary items.

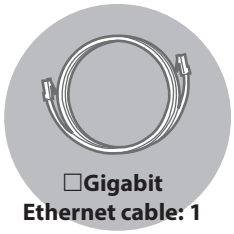
Unpacking Preparation

- Minimum 4 people are required for unpacking, assembling and installation.
- The items listed below are required for installation and initial setup.

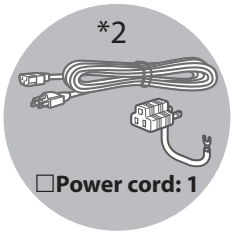
☐**Computer : 1**



☐**Roll media : 1**

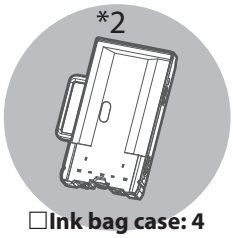


☐**Gigabit Ethernet cable: 1**



☐**Power cord: 1**

☐**Phillips-head screwdriver: 1**



☐**Ink bag case: 4**
(1,000ml or 2,200ml)

☐**Ink bag: 4**
(1,000ml or 2,200ml)

*1 Usable size for Roll media

- Media core diameter: 2 inches or 3 inches
- Outer diameter: Φ200 mm or less
- Width: 500 mm to 1,625 mm
- Weight: 30 kg or less

*2 Optional accessories or supplies.

WARNING	**Use the designated power cords.** Failure to do so may result in electric shock or fire.

Important!

Your computer must meet the following minimum 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 port, Gigabit Ethernet cable (Category 6 or later)

Note

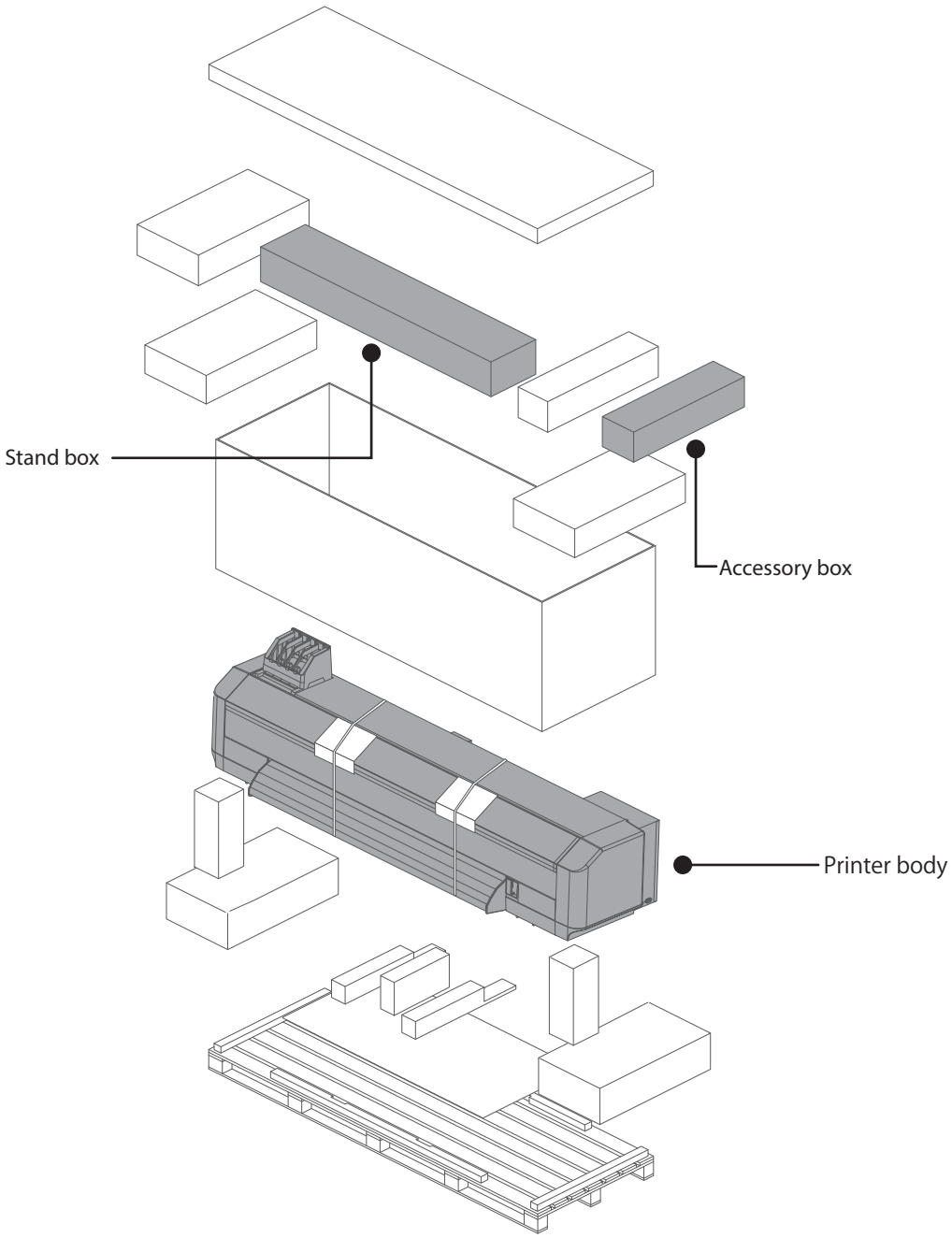
- The OS support period of MUTOH software follows the Microsoft support lifecycle policies.
- When using RIP software, please also see the system requirements of your RIP software.

Unpack the product.

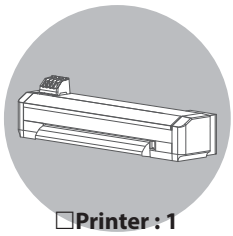
Unpacking the printer

⚠ CAUTION	• **Minimum four people are required for unpacking and moving this product.** • **When taking out the product from the packing box, remove the plastic sheet wrapped around the product, then take out the product. Failure to do so may cause slip and damage to the product.** • **Keep the product level while moving it.**

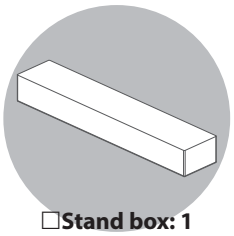
[1] Open the packing box and take out the items listed below.



[2] Check that the following items are included.



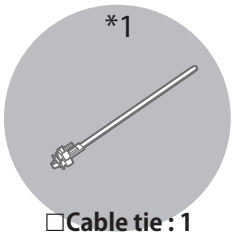
☐Printer : 1



☐Stand box: 1

☐Startup Guide : Japanese/English (each)

☐Request for User Registration & Download : Japanese/English (each)



*1

☐Cable tie : 1

*1

☐Waste ink tank : 1

*1

☐Cleaning wiper for head height High (grey): 1

*1

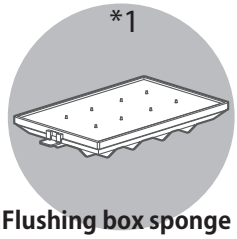
☐Cleaning stick : 10

*1

☐Paper towel : 5

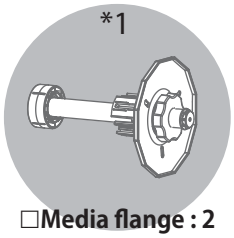
*1

☐Tweezers : 1



*1

☐Flushing box sponge : 5



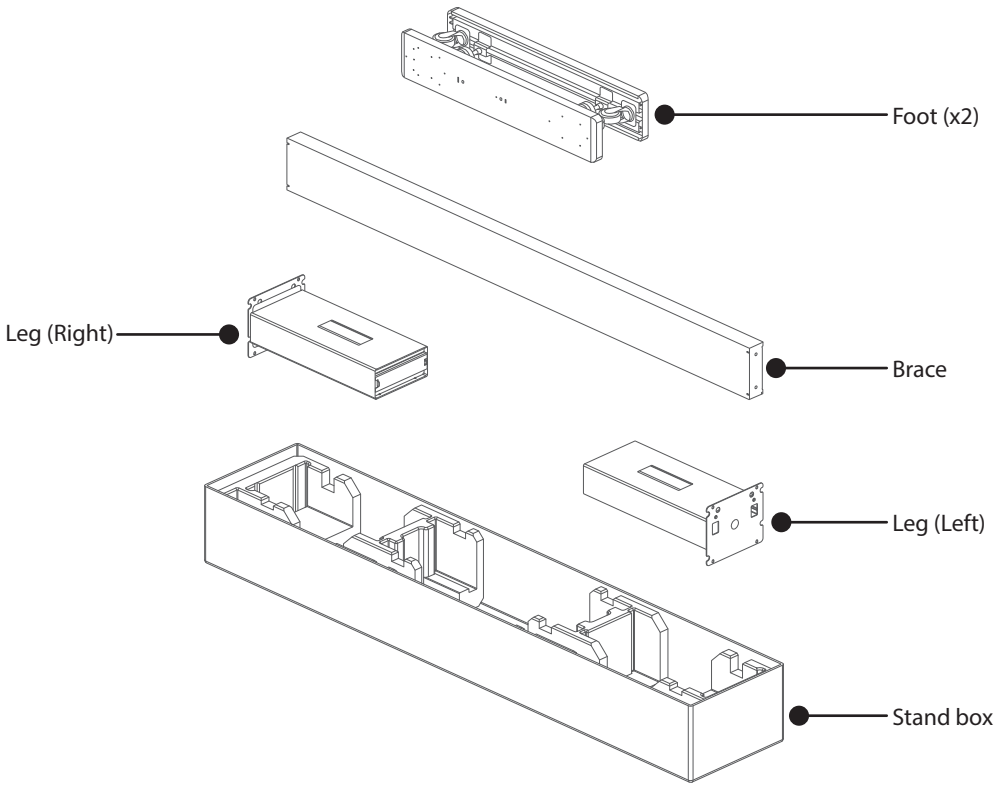
*1

☐Media flange : 2

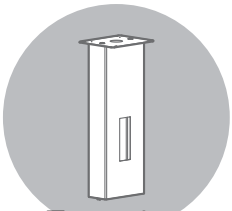
*1 Included in the accessory box.

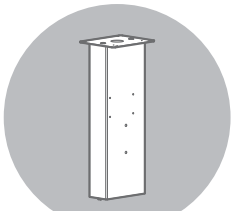
Unpacking Stand

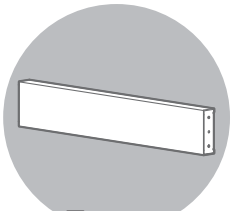
[1] Open the packing box and take out the items listed below.

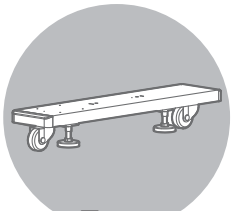


[2] Check that the following items are included.


☐Leg (Left) : 1

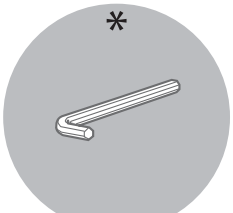

☐Leg (Right): 1


☐Brace : 1

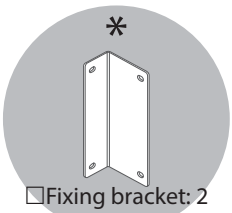

☐Foot: 2

☐Hex head bolt : 8 *

☐Spring washer: 8 *


☐Hex wrench: 1 *

☐Round head screw: 12 *


☐Fixing bracket: 2 *

☐Wing bolt: 8 *

☐Waste ink tank holder: 1 *

Note

Items marked with an asterisk (*) above are in the accessory box.

Assembling

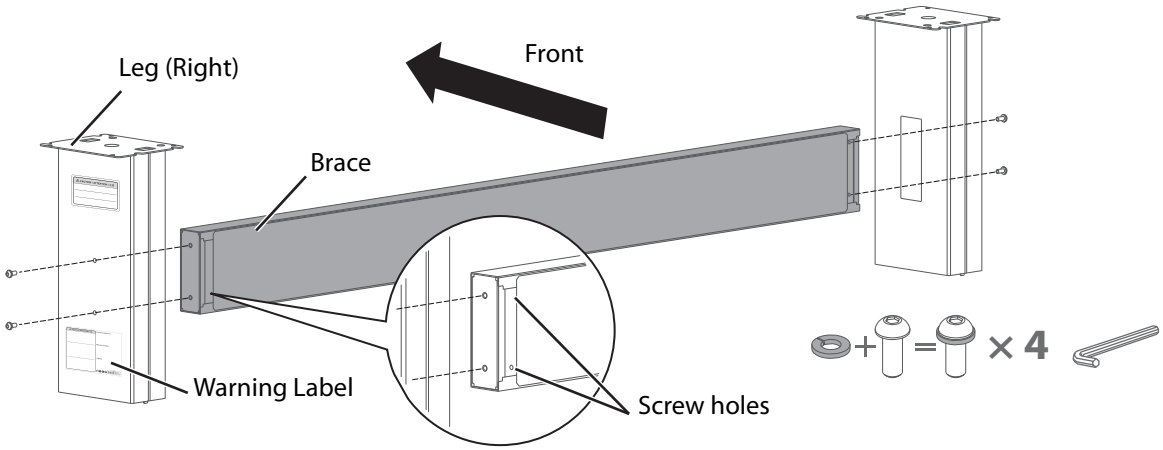
Follow the steps below to assemble the stand.

Assembling Stand

CAUTION	**Minimum two people are required for assembling the stand.**

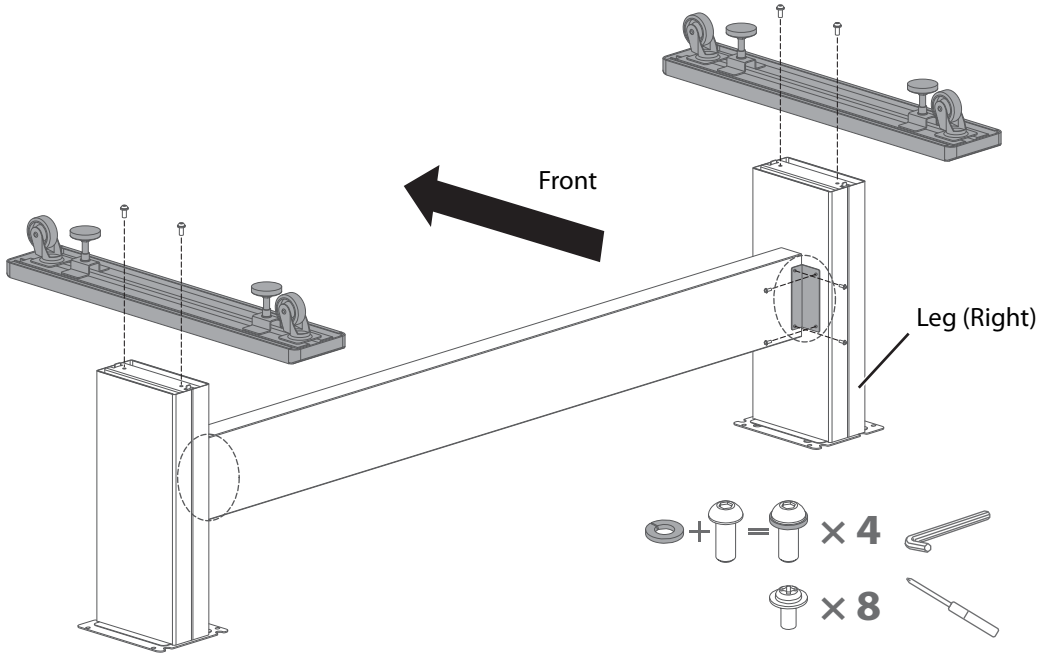
[1] Attach the left leg and right leg to the brace.

- Face the screw hole face (face with notch) on the brace toward the rear side of the printer and attach it to both legs.
- The leg with two warning labels attached is the right leg.
- Put the spring washers on the hex head screws (4 each), then tighten the screws.

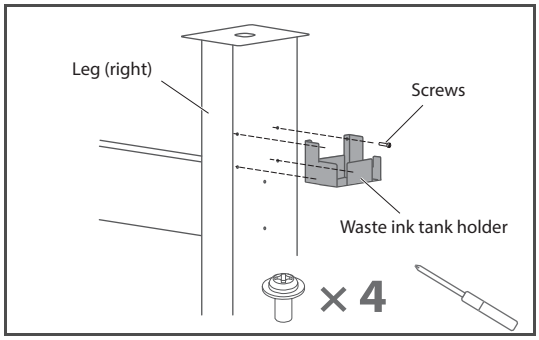


[2] Attach the foot to the leg.

- Face the screw holes on the foot toward the front side of the printer and attach it to the leg.
- Put the spring washers on the hex head screws (4 each), then tighten the screws.
- Use the round head screws (×8) to fix the fixing brackets (×2) on the brace and both legs.



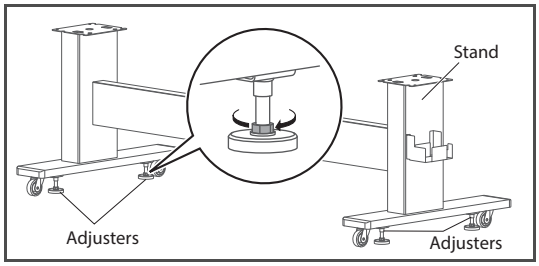
[3]



Use the round head screws (×4) to attach the waste ink tank holder to the right leg.

[4] Shake the stand to make sure that each part is firmly attached.

[5]



Turn the leveling adjusters (×4) as shown on the left until the stand does not move.

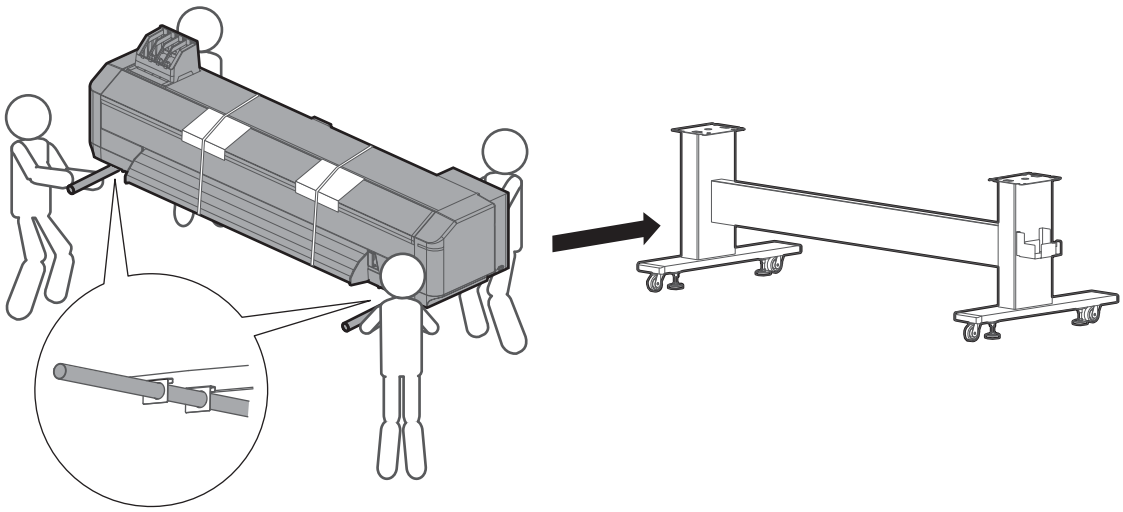
Follow the steps below to attach the printer to the stand.

Attaching Printer

⚠ CAUTION	• **Minimum four people are required for this process.** • **When taking out the product from the packing box, remove the plastic sheet wrapped around the product, then take out the product. Failure to do so may cause slip and damage to the product.** • **Keep the product level while attaching.**

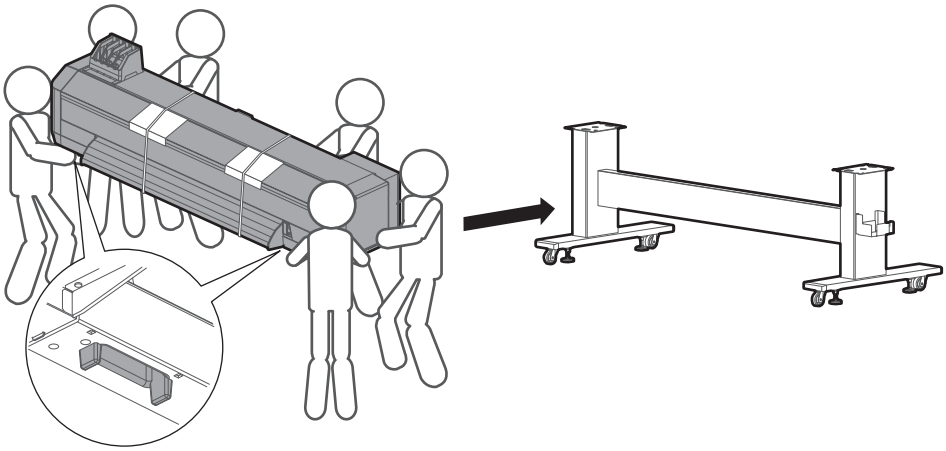
[1] Lift the printer with at least four people and mount it on the stand.

- Use two lifting bars to insert into the guide holes at the bottom left and right of the printer, and lift up on the stand.

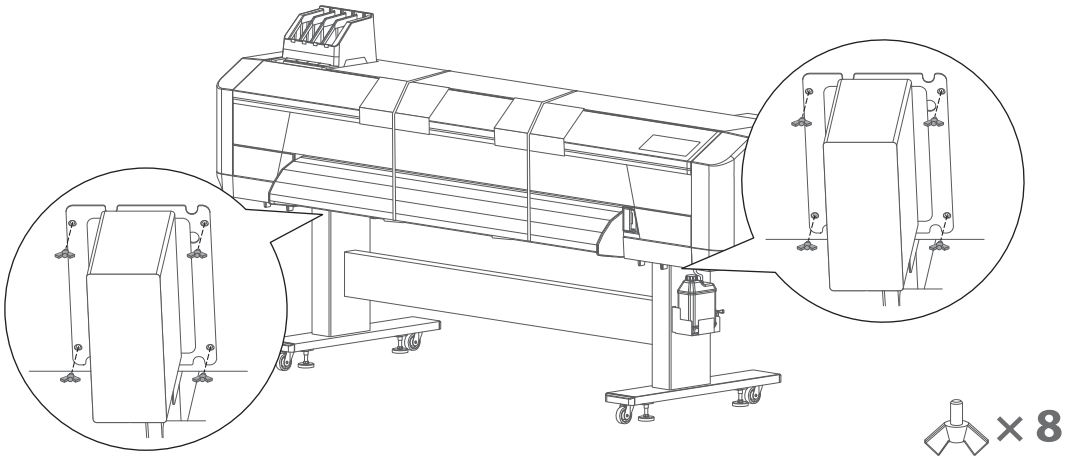


(If you do not have lifting bars) Lift the printer with at least four people and mount it on the stand.

- Use the handholds at the front bottom of the printer.



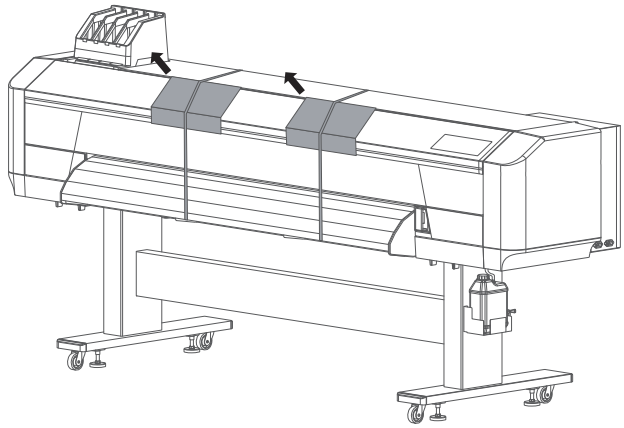
[2] Use the wing bolts (×8) and attach the printer to the stand.



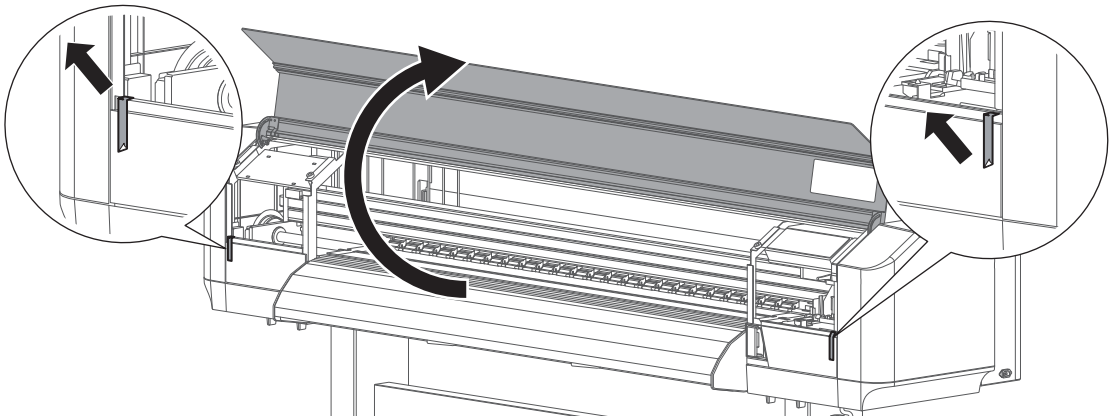
Remove packing materials from the product.

Removing Packing Materials

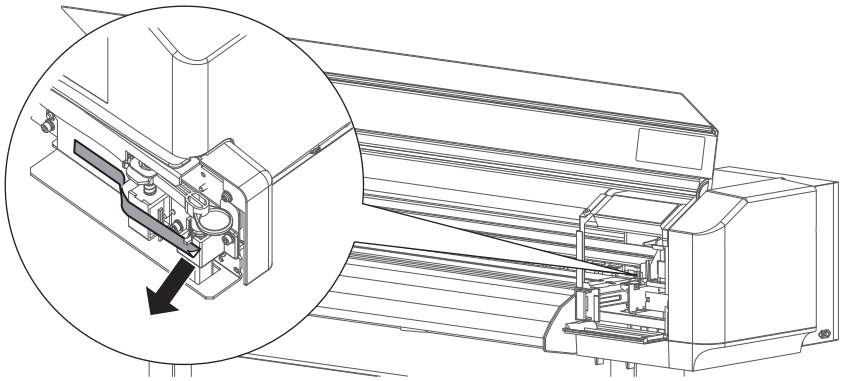
[1] Remove the protective material at the front cover.



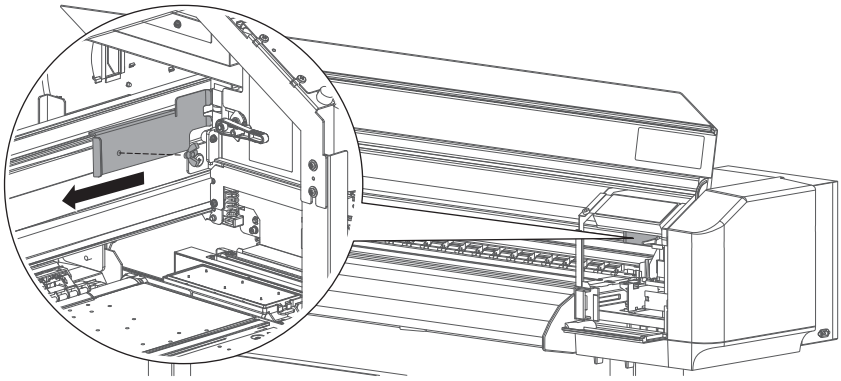
[2] Open the front cover and remove the protective tape from the maintenance cover.



[3] Remove the protective tape from the cap on the cutter.



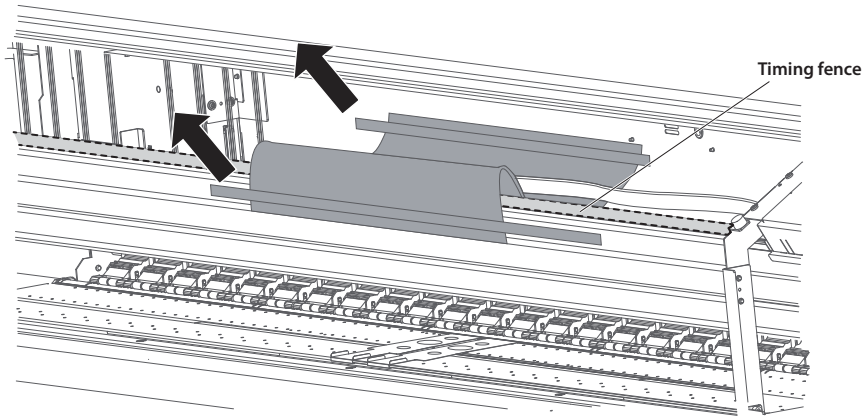
[4] Remove the wing bolt to remove the shipping bracket from the carriage.



Important!

Keep the shipping bracket and screws for next use.

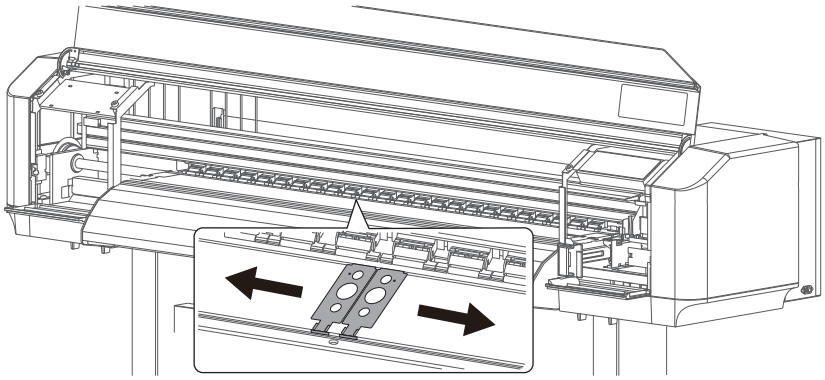
[5] Remove the protective tape, then remove the protective material at the back inside of the printer.



Important!

When removing protective materials, do not touch the timing fence (clear part). If it deforms, it will affect print quality.

[6] Remove the tape, and move the edge holders to the left and the right edge.



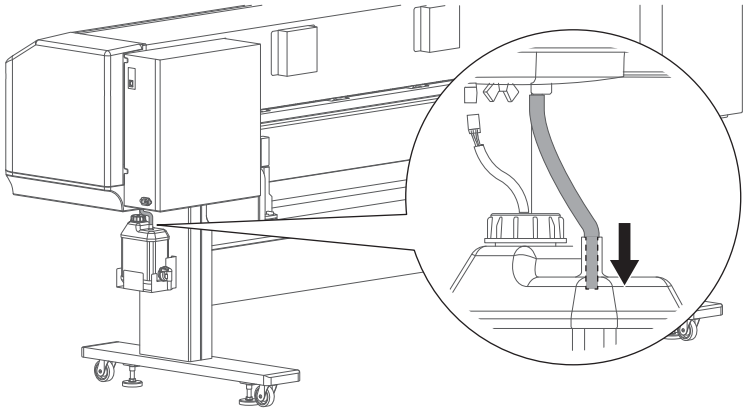
[7] Remove rest of all the protective tapes.

Attach the waste ink tank to the printer.

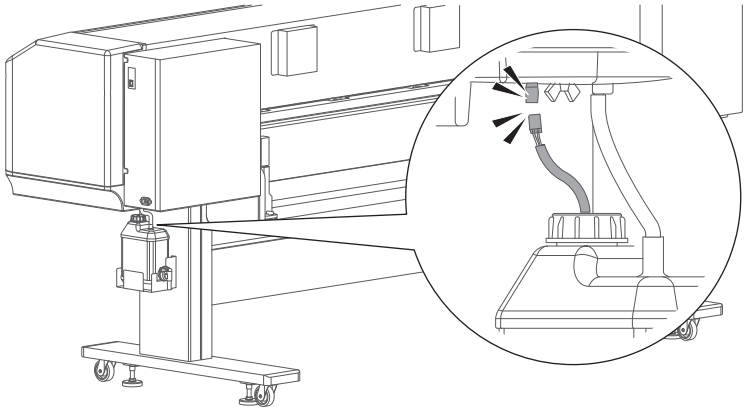
Attaching Waste Ink Tank

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

[2] Put the waste ink tube in the mouth of the waste ink tank.



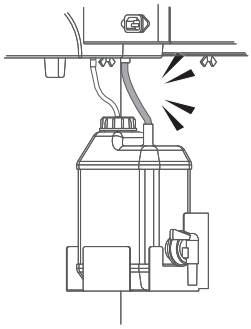
[3] Connect the waste ink sensor cable to the waste ink sensor connector.



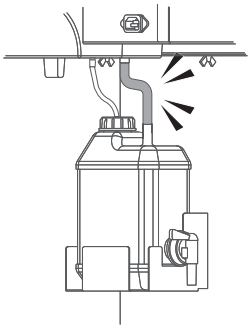
Important!

- **Ensure that the waste ink tube is firmly inserted. Failure to do so may cause ink spillage.**
- **After connecting the tube to the tank, check that the tube is not bended. Any bending will cause ink spillage.**

Good



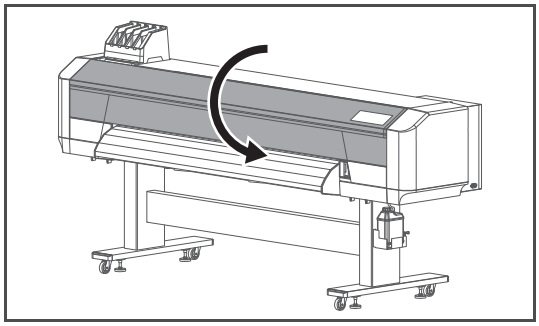
No good



Connecting Power and Network

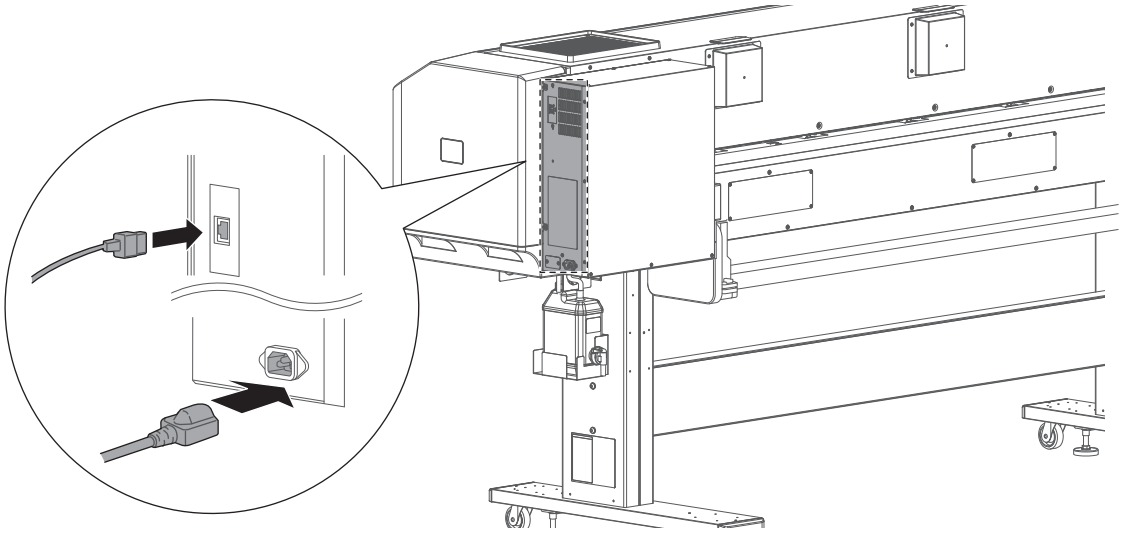
Follow the steps below to connect the power cord and Ethernet cable.

Connect Power Cord and Ethernet Cable

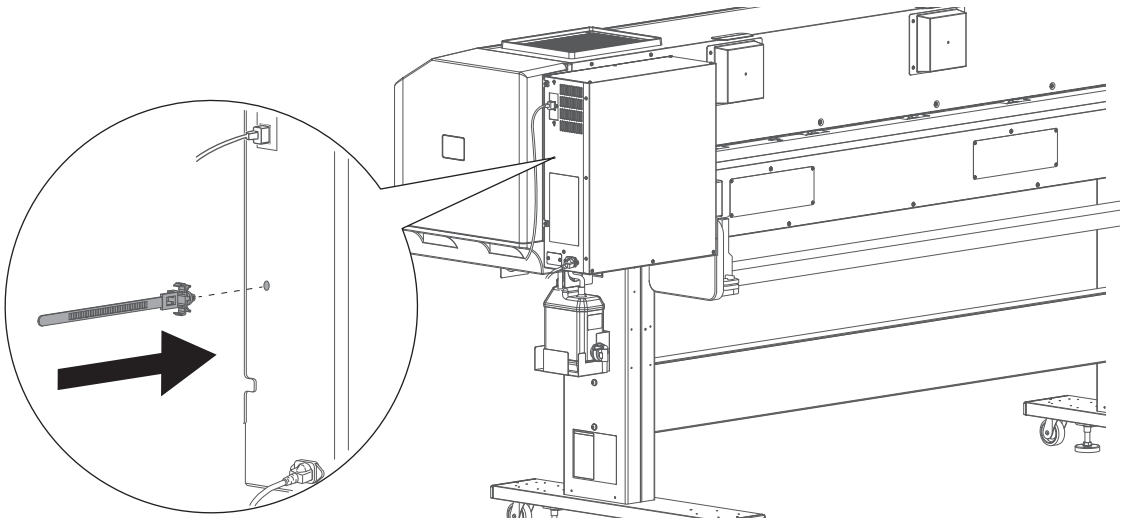
[1] 

Check that the front cover is closed.

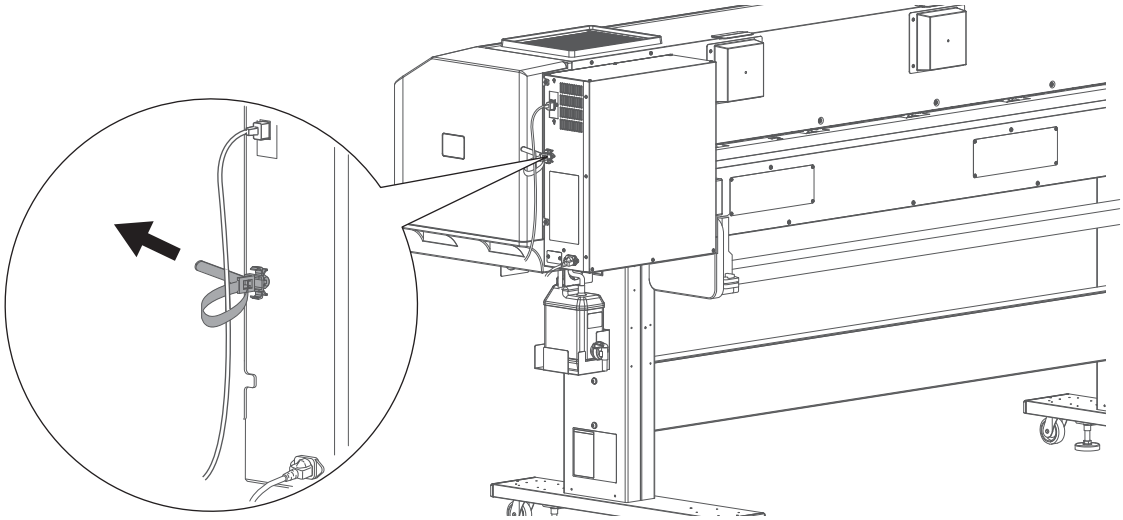
[2] Connect the power cord and a Ethernet cable to the printer.

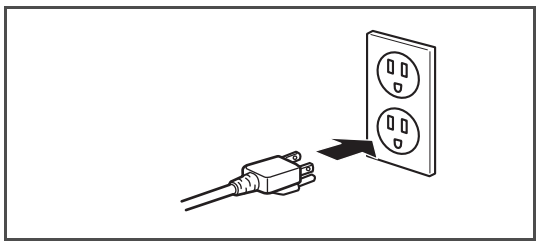


[3] Insert the tip of the cable tie into the hole on the printer to attach it.



[4] Use the cable tie to secure the Ethernet cable to the printer.



[5] 

Plug the power cord into the wall outlets respectively.

Printer Initial Setup

Here is how to get started with your printer.

Initial Setup Flow

Configure the initial settings

Choose and configure the language, unit of length, temperature, and network setting from the front panel.

Activate the printer

Enter the activation code from the front panel.

Perform initial ink charging

Install ink bags into the printer and perform ink charging.

Load a roll media for test printing.

Load a roll media for the nozzle check printing.

Run a nozzle check and perform cleaning

Run a nozzle check print and perform cleaning until all nozzles are clear.

Connect the printer to your computer

Enter the IP address from the touch panel.
Install MUTOH Status Monitor (MSM) and configure the initial setup on MSM.

Initial setup is now complete!

Front panel

The printer has a touch-screen panel located on the front right of the printer. The active keys are lit up on the panel for guidance.

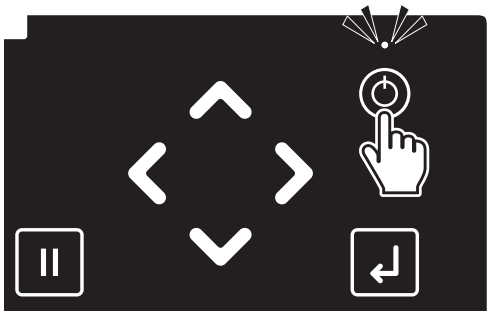
- Tap: Lightly touch the key with your finger, then immediately release.
- Long-touch: Keep touching the key.

Power on the printer and configure the initial settings on the front panel.

Step 1 Powering on - Initial settings on the front panel

[1] Check that the front cover is closed.

[2]



Long press the Power button on the front panel.

- The Power LED (above the Power button) lights up.

Note

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

[3]

Use ▼ to select the language.

Tap ↵ (Enter).

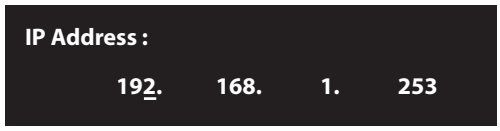
[4]

Tap ↵ (Enter).

[5]

Tap ↵ (Enter).

[6]

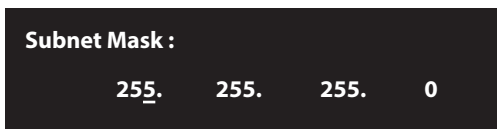


Sets the IP address of the printer.

- ▲ key: Increase the number.
- ▼ key: Decrease the number.
- ◀ key: Move the cursor to the previous digit.
- ▶ key: Move the cursor to the next digit.

Tap ↵ (Enter) after entering each digit.

[7]

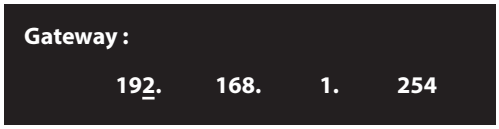


Sets the subnet mask of the printer.

- ▲ key: Increase the number.
- ▼ key: Decrease the number.
- ◀ key: Move the cursor to the previous digit.
- ▶ key: Move the cursor to the next digit.

Tap ↵ (Enter) after entering each digit.

[8]



Sets the gateway.

- key: Increase the number.
- key: Decrease the number.
- key: Move the cursor to the previous digit.
- key: Move the cursor to the next digit.

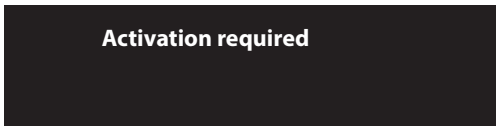
Tap (Enter) after entering each digit.

[9]

The printer will start mechanical initialization.

Follow the steps below to perform activation.

Step 2 Activation



When the message on the left appears, use one of the following methods to activate the printer.

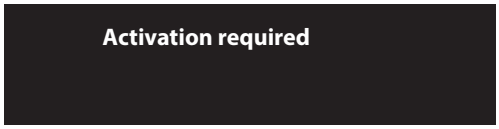
☞ **"Activation through the front panel"** P. 19
☞ **"Activation through Internet"** P. 19

Note

While "Activation required" is displayed, you can return the initial setting flow (e.g. IP Address etc.) by tapping .

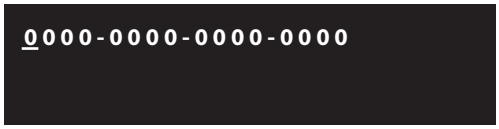
Activation through the front panel

[1]



When the message on the left appears, tap (Enter).

[2]



Enter the 16-digit activation code.

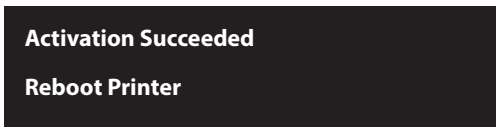
- key: Increase the number.
- key: Decrease the number.
- key: Move the cursor to the previous digit.
- key: Move the cursor to the next digit.

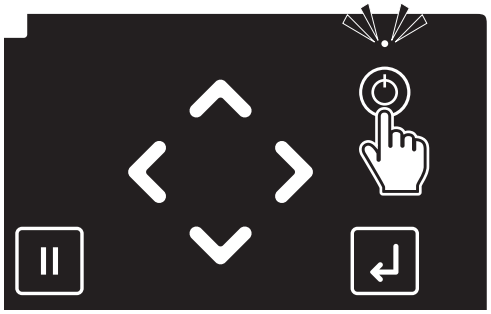
Tap (Enter) after entering each digit.

Note

To obtain the activation code, please contact your local MUTOH dealer to send it by email.

[3]



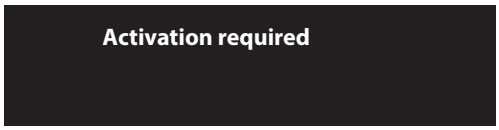


When the message on the left appears, long press the Power button to power off the printer.

- When the message “Power Off” appears on the panel, release the Power button.

Wait for a few seconds and long press the Power button to reboot the printer.

Activation through Internet



When the message on the left appears on the front panel, follow the instructions on the Printer Activation Guide to activate the printer.

Note

To obtain the activation code and the Printer Activation Guide, access to MUTOH Club from the following URL and click “Register” to complete the user registration.
https://mutoh-club.com/mutoh/guser/

Follow the steps below to perform initial ink charging.

Step 3 Initial Ink Charging

Items Required:

- Ink bag: ×4
  Black, Cyan, Magenta, Yellow
- Ink bag case: ×4

Important!

When performing initial ink charging, make sure that the head height is set to "Low1" (factory default).

1. Perform initial ink charging

[1]

When the message on the left appears, tap (Enter).

Note

While "Ink Charge Start -> Enter" is displayed, you can return the initial setting flow (e.g. IP Address etc.) by tapping .

[2]

Tap (Enter).

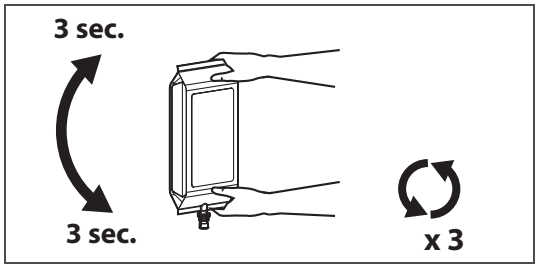
Note

To perform cleaning, use or to choose "Wash Retry? Yes".

The message on the left will appear.

When installing 1,000 ml ink bag cases.

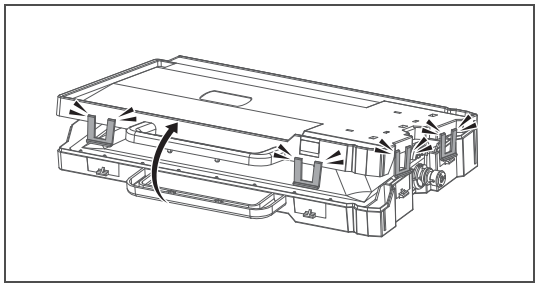
[1]



Prepare the new ink bag and follow the instructions below to invert it to mix the ink.

- Face the ink spout side upwards for 3 seconds.
- Invert it and count for 3 seconds.
- Repeat 3 times.

[2]

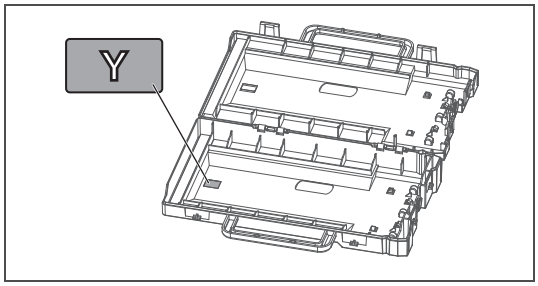


Unlock four latches and open the ink bag case.

Important!

Try not to apply excessive force to unlock them. This will cause damage to the latch.

[3]

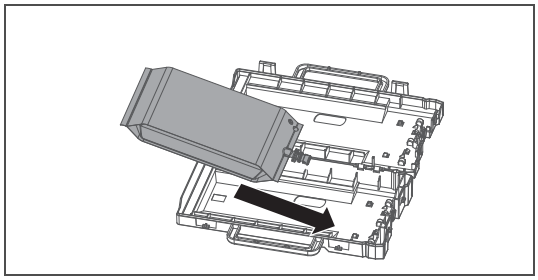


Open an ink case and apply an ink color label onto the inside of the case.

Note

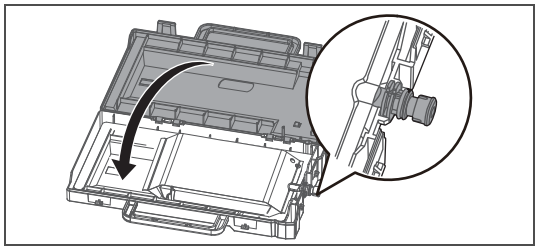
- The ink color label is supplied with the ink case.
- The label should be applied in the label application area (within the recess on the inside of the case) as shown in the illustration left.

[4]



Put the ink bag into the case.

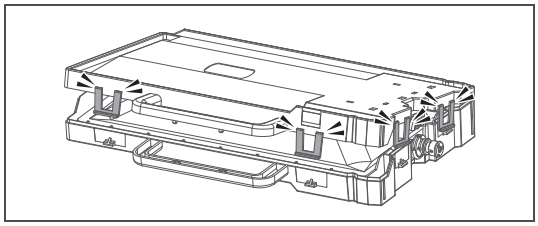
[5]



Close the case.

Important!

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

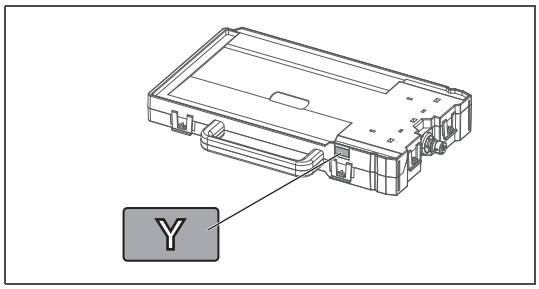


Close the latches (×4) of the case properly.

Important!

Check that all the latches (×4) are closed.
If not, it may cause ink spillage.

[6]



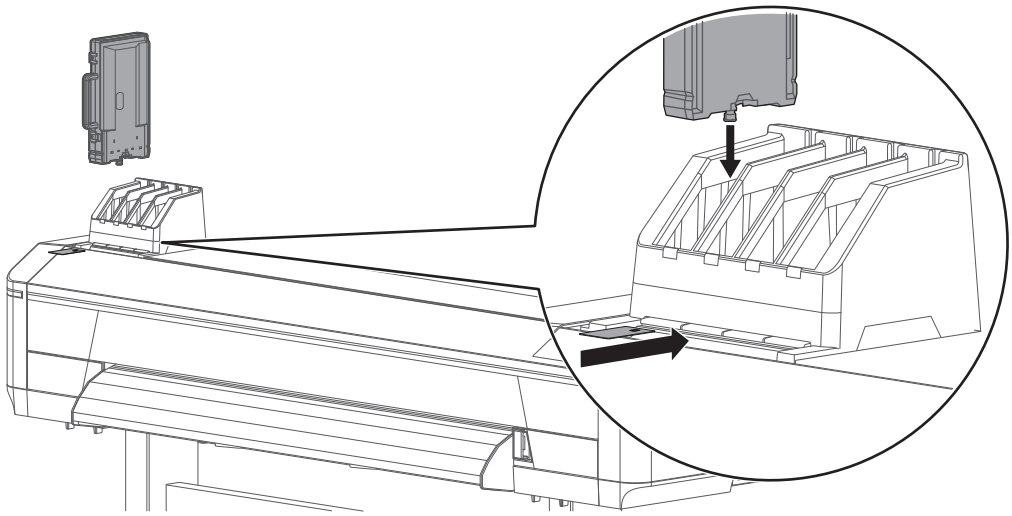
Apply an ink color label onto the outside of the case.

Note

- The label should be applied in the label application area (within the recess on the outside of the case) as shown in the illustration left.
- Make sure to match the color of the label with the one applied onto the inside of the case.

[7] Insert the ink bag cases and S/C cards into each slot.

- Make sure to match the colored label on the ink slot and the colored label on the ink bag.
- Face the latch side towards you and insert the case into the slot.
- Make sure that they are fully inserted.



Ink Refill ** %

The message on the left appears.

- The printer starts the initial ink charging.

CAUTION

DO NOT attempt the following actions during ink charging:

- **Power off the printer.**
- **Disconnect the power cord.**
- **Open the front cover.**
- **Open the maintenance cover.**
- **Release the pressure rollers.**

[8]

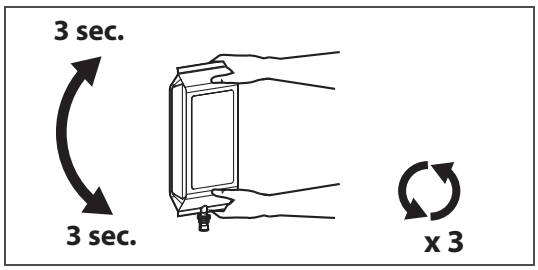
Media End
PG: Low1

Once the ink has been filled, the message on the left will appear on the panel.

- The ink charging is complete.

When installing 2,200 ml ink bag cases.

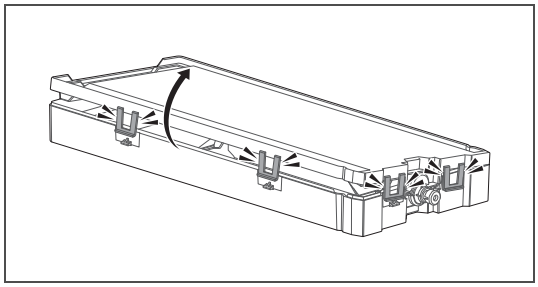
[1]



Prepare the new ink bag and follow the instructions below to invert it to mix the ink.

- Face the ink spout side upwards for 3 seconds.
- Invert it and count for 3 seconds.
- Repeat 3 times.

[2]

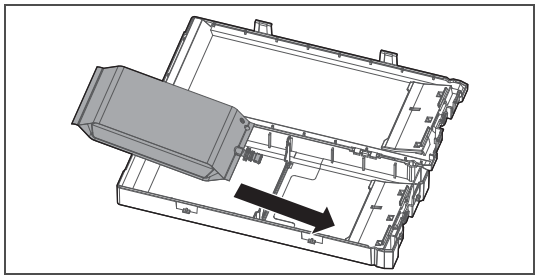


Unlock four latches and open the ink bag case.

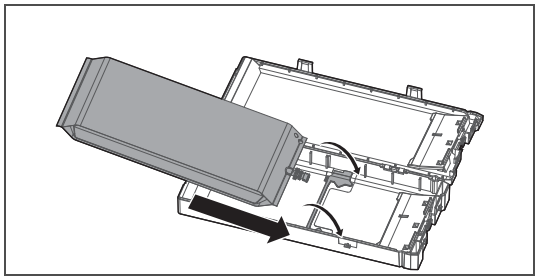
Important!

Try not to apply excessive force to unlock them. This will cause damage to the latch.

[3]



Put the ink bag into the case.

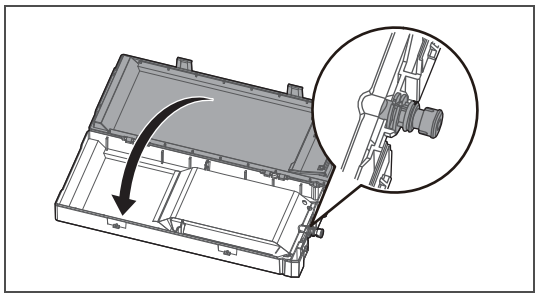


Important!

When installing 2,200 ml ink bag cases:

- **If you are using 2L ink bag, release the lock of divider plate in the case,and then put the ink bag into the case.**
- **If you are using 1L ink bag, always lock the divider plate.**

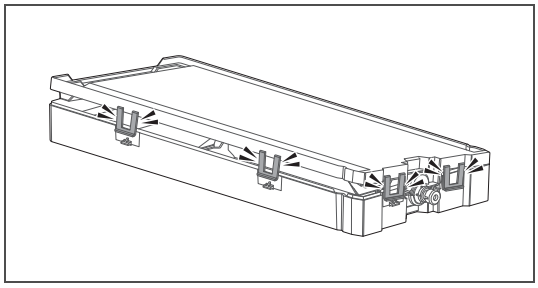
[4]



Close the case.

Important!

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



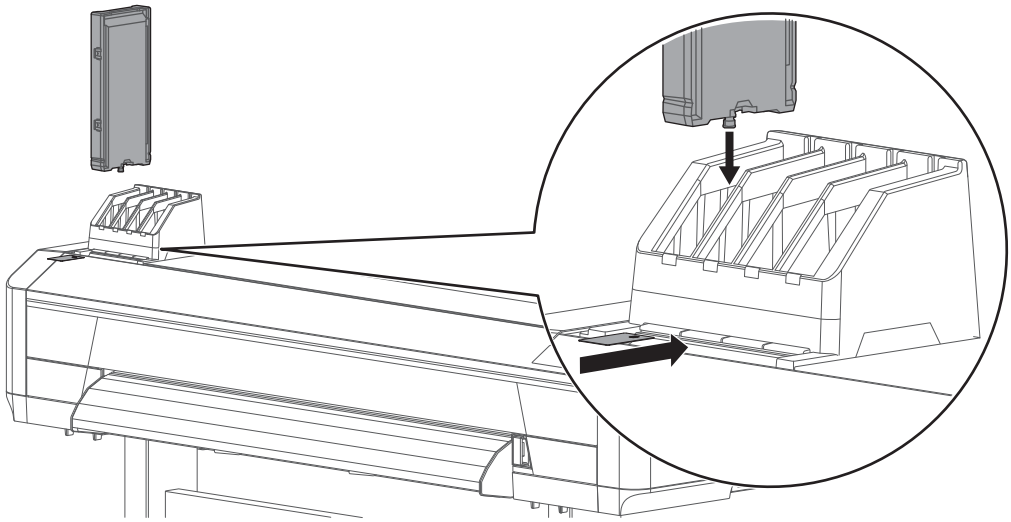
Close the latches (×4) of the case properly.

Important!

Check that all the latches (×4) are closed.
If not, it may cause ink spillage.

[5] Insert the ink bag cases and S/C cards into each slot.

- Make sure to match the colored label on the ink slot and the colored label on the ink bag.
- Face the latch side towards you and insert the case into the slot.
- Make sure that they are fully inserted.



Ink Refill	** %

The message on the left appears.

- The printer starts the initial ink charging.

⚠ CAUTION

DO NOT attempt the following actions during ink charging:

- **Power off the printer.**
- **Disconnect the power cord.**
- **Open the front cover.**
- **Open the maintenance cover.**
- **Release the pressure rollers.**

[6]

Media End
PG: Low1

Once the ink has been filled, the message on the left will appear on the panel.

- The ink charging is complete.

Test printing

Follow the steps below to load a media into the printer.

Important!

Depending on the size of media, two or more people are required.

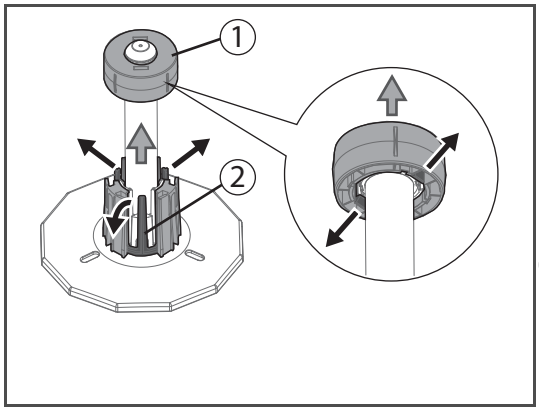
Load a roll media into the printer

1. Attach flanges to the media

Items Required:

- Roll media
- Media flange: ×2

[1]



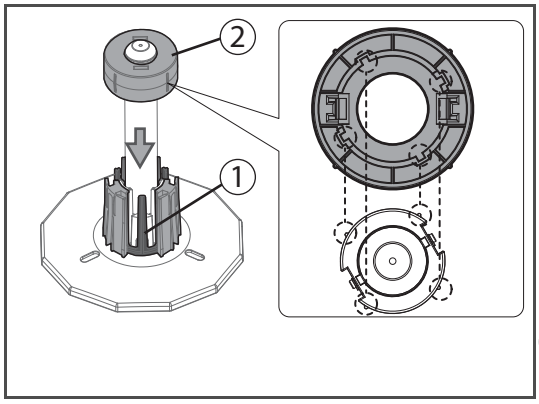
(If you are using 2-inch core roll media), remove the 3-inch adapter from the media flange.

①: Pull two tabs on the adapter outward, then remove it from the flange.

②: Pull three tabs on the adapter outward, then remove it from the flange.

Note

- If ② adaptor cannot be removed, turn the handle on the flange anti-clockwise to loose (see Step 2), then remove it.
- If you are using 3-inch core roll media, skip this step.



(When replacing 2-inch core roll media with 3-inch core roll media)
Attach the 3-inch adapters to the media flange.

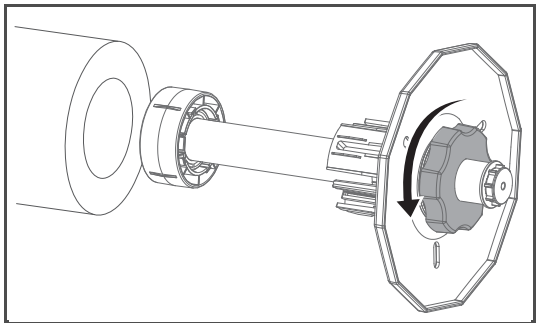
①: Align the tabs (x3) on the adapter with the dents on the base of flange to click into place.

②: Align the notches (x4) on the inside of adapter with the protrusions (x4) on the leading edge of media flange as shown to the left to attach it to the edge of the media flange.

Note

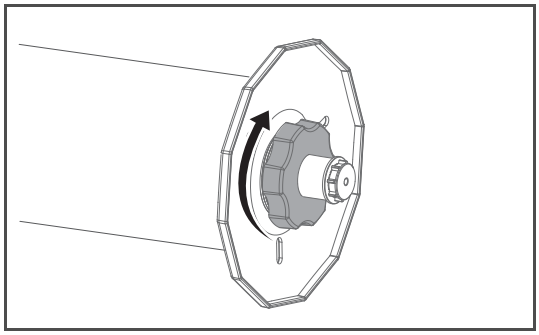
- If ② adapter is misaligned, it will not be properly fixed to the media flange.

[2]



Push the media flange (×2) into the both ends of the media core.

- Before inserting, twist the handle on the flange anticlockwise to unlock it.

[3] 

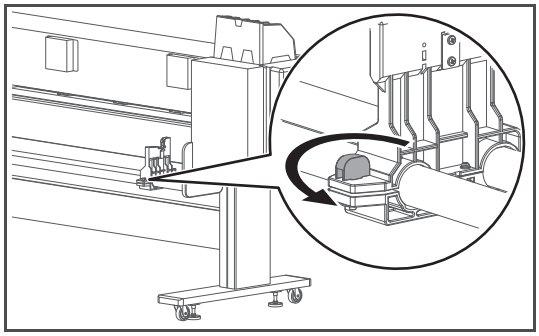
Twist the handle clockwise to lock the flange.

Important!

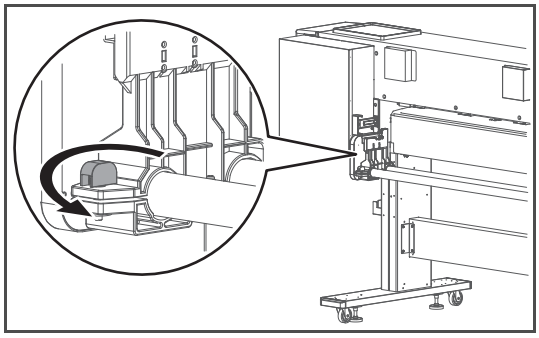
Check that the flange is firmly locked.
If not, the media can be removed from the flanges, affecting the print quality.

2. Enable torque on media holders

If you want to apply torque to the media holders, follow the steps below.

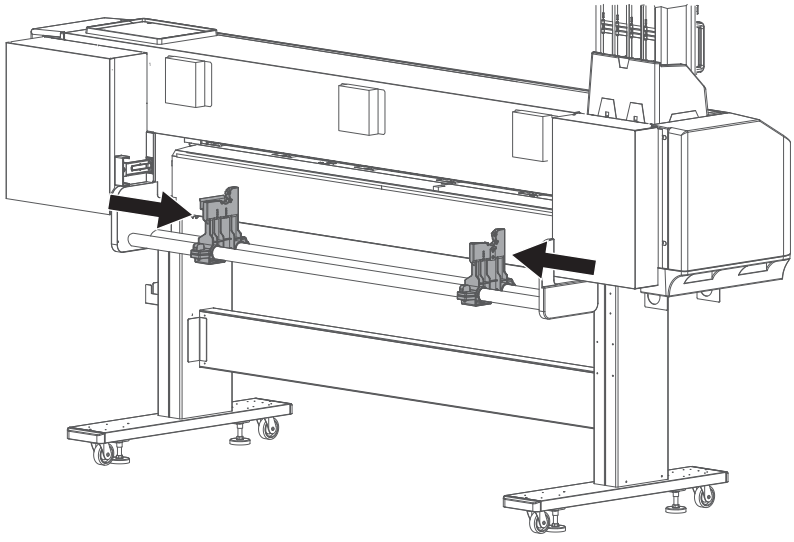
[1] 

Twist the knob bolt on the right side of the media holder anticlockwise to loosen.

[2] 

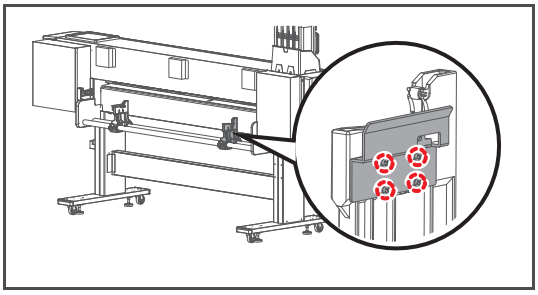
Twist the knob bolt on the left side of the media holder anticlockwise to loosen.

[3] Slide both left and right media holders about 30 cm towards the center of the slider for easy access.



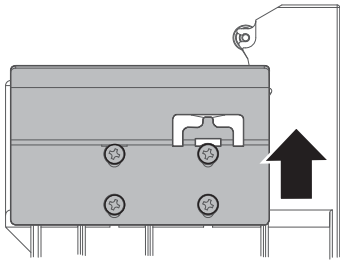
[4] Tighten the knob bolts on both media holders.

[5]



(When looking from the rear side of the printer) Use the screwdriver to loosen four screws securing the roller shaft guide plate to the right media holder.

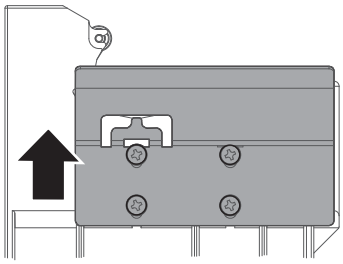
[6]



Roller shaft guide plate (right)

Slide up the roller shaft guide plate as far as it will go and tighten the screws.

[7]



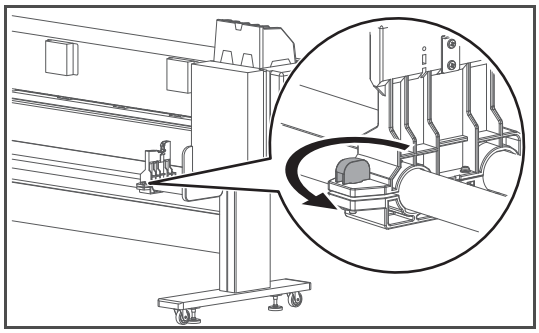
Roller shaft guide plate (left)

Do the same for the left media holder to slide up the roller shaft guide plate as far as it will go and tighten the screws.

[8] Loosen the knob bolts and slide back both media holders to the original position.

[9] Tighten the knob bolts.

3. Place the media onto the media holder

[1] 

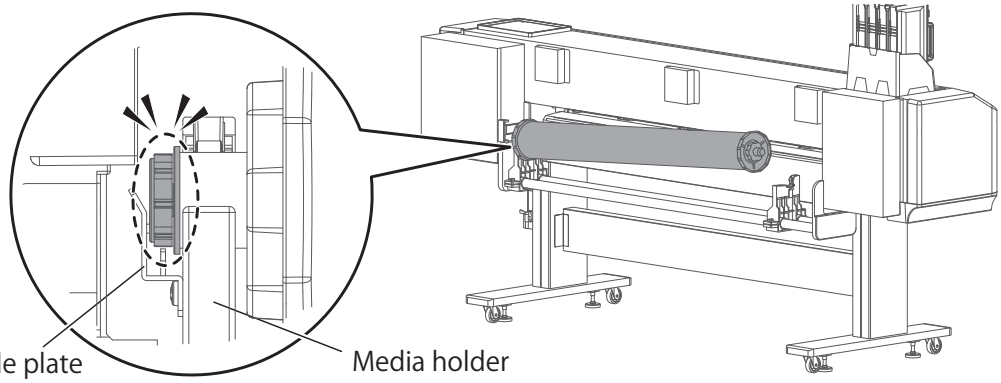
Twist the knob bolt on the right side of the media holder anticlockwise to loosen.

[2] Place the roll media onto the left media holder. Carefully and gently place it on the holder.

- Place the flange between the roller shaft guide plate and the media holder as shown in the illustration.

Important!

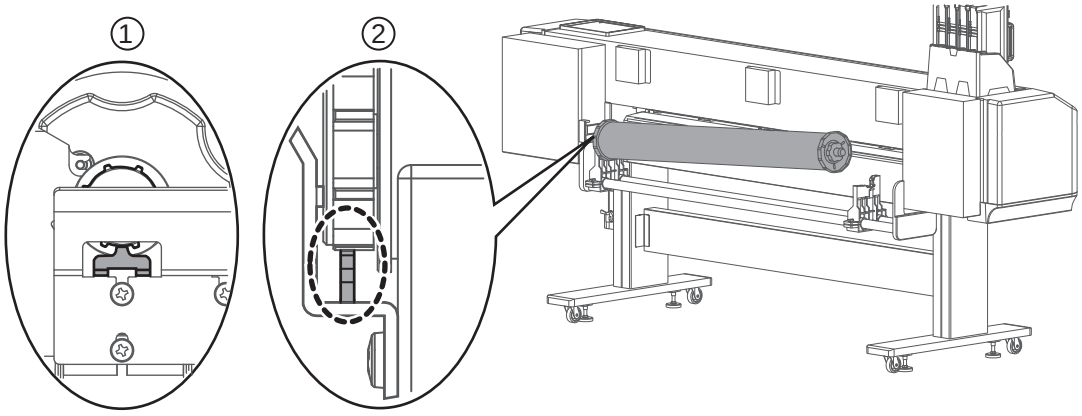
Do not drop or apply excessive impact while placing the media. This will cause damage to the part.



If you set the torque, continue to check the following.

①: When looking from the left side, check that the protrusion on the roller shaft guide plate is fitted into between two protrusions on the flange end cap.

②: When looking from the rear side of the printer, check that the flange end cap is properly placed on the protrusion on the roller shaft guide plate.



Important!

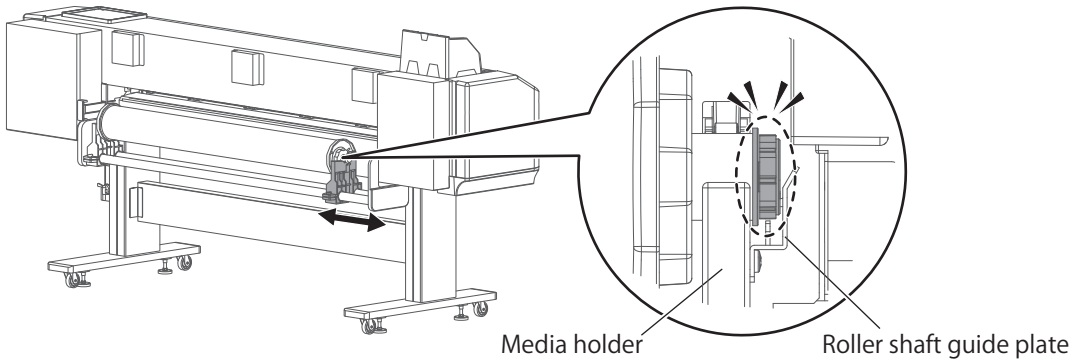
When you adjust the position of the media holder (left), do not move it more than 450 mm away from the left-hand end. The printer will not be able to detect media.

[3] Place the roll media onto the right media holder. Carefully and gently place it on the holder.

- Slide the right side of the media holder to place the right side of the flange onto the holder.
- Place the flange between the roller shaft guide plate and the media holder as shown in the illustration.

Important!

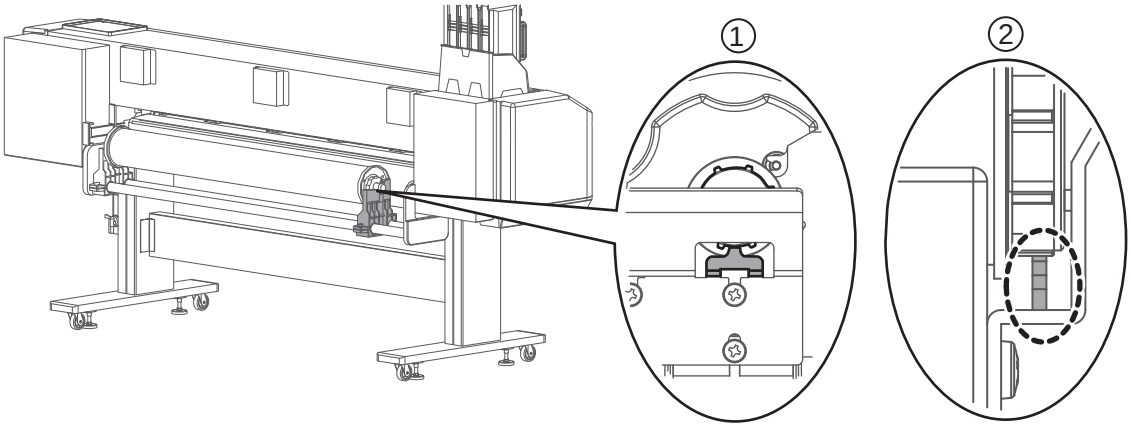
- **Do not drop or apply excessive impact while placing the media. This will cause damage to the part.**

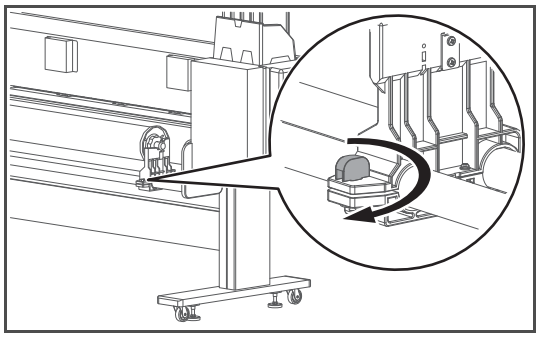


If you set the torque, continue to check the following.

①: When looking from the right side, check that the protrusion on the roller shaft guide plate is fitted into between two protrusions on the flange end cap.

②: When looking from the rear side of the printer, check that the flange end cap is properly placed on the protrusion on the roller shaft guide plate.



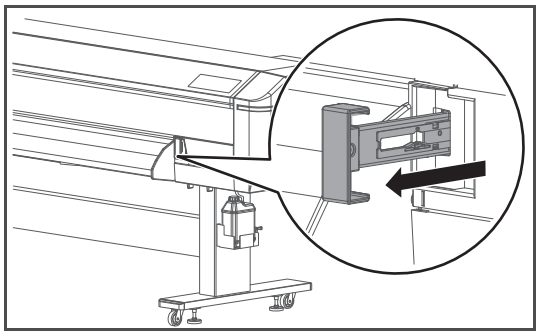
[4] 

Twist the knob bolt on the right side of the media holder clockwise to tighten.

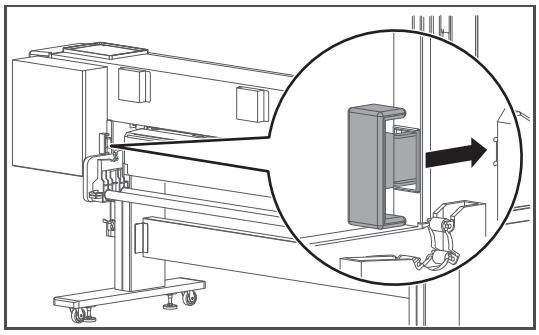
4. Load the media into the printer

[1] Check that the printer is powered on.

[2]



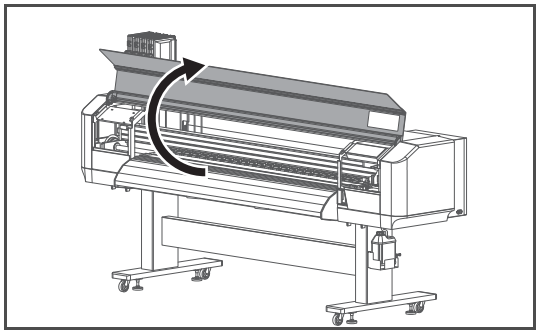
From the front side of the printer, fully pull the media feed lever towards you to release the pressure rollers.



You can access to the media feed lever from the rear side of the printer.

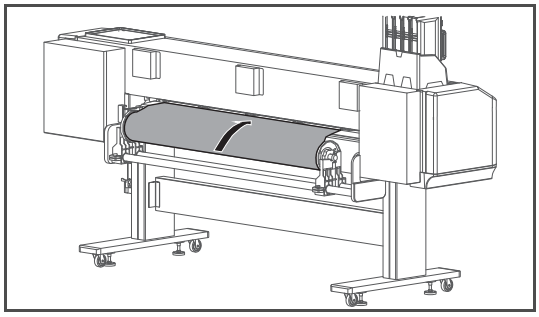
- To release the pressure rollers, push the lever as far as it goes.

[3]



Open the front cover.

[4]

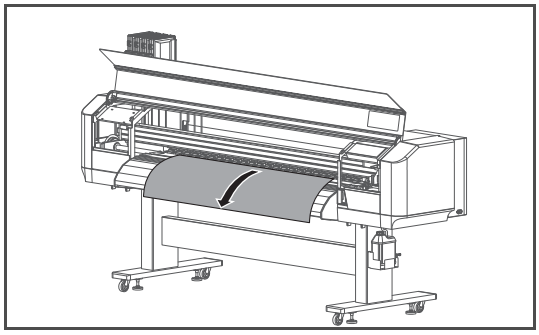


From the rear side of the printer, insert the front edge of the media into the media slot.

Note

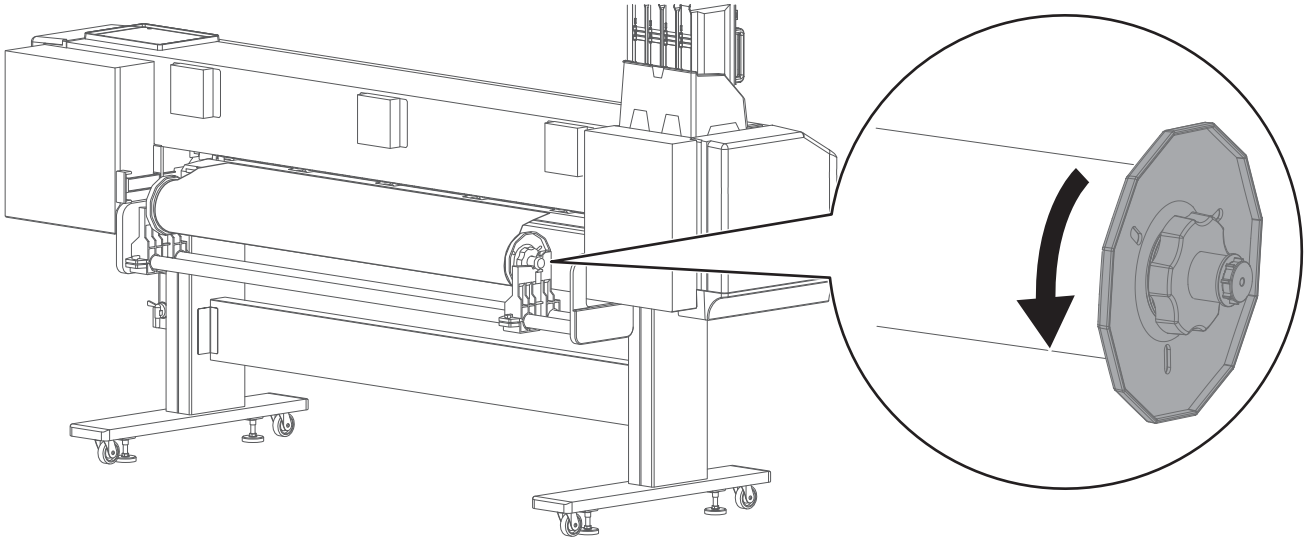
Before inserting, rewind the media properly.

[5]



From the front side of the printer, pull the media for approximately 1 m.

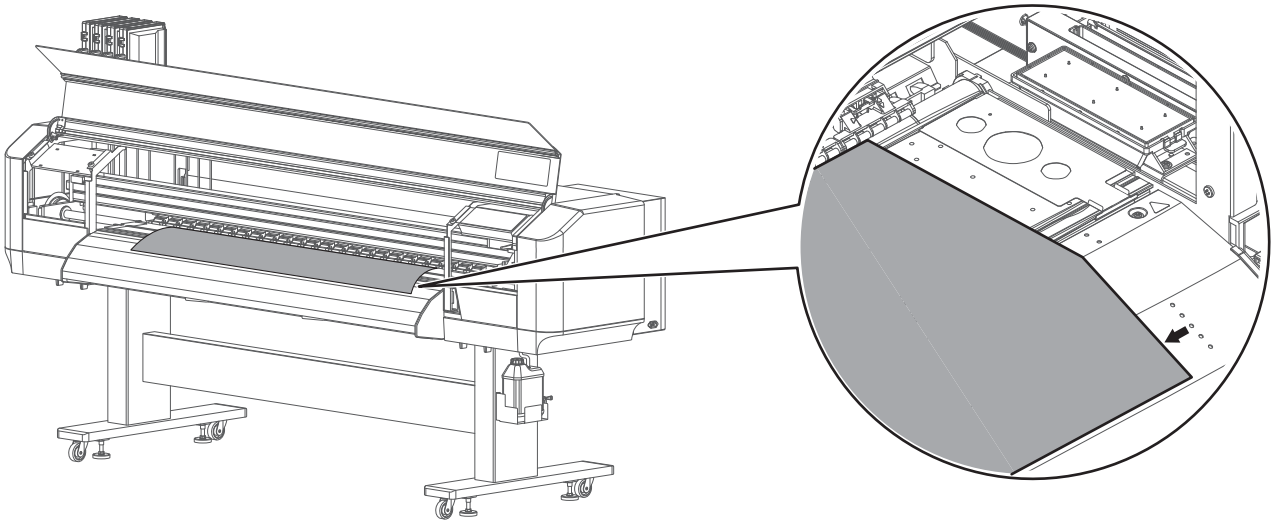
[6] While one person holds the front edge of the media, the other person turns the flange to slightly rewind the media onto the roll to remove warp or skew.



Note

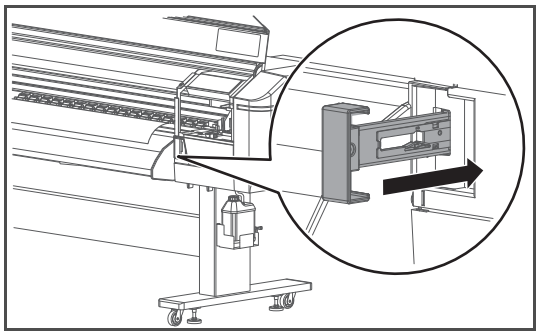
If you remove your hands from the front edge of the media while rewinding, the media can be removed from the media slot.

[7] Check that the right-hand edge of the media is located at the left side of the media guide line.
If not, print quality can be affected.



[8] If needed, use a slide lock lever on the pressure rollers to individually cancel or reduce the pressure.
☞Operation Manual "Canceling or reducing pressure rollers individually"

[1]



From the front side of the printer, push the media feed lever to hold the media flat with pressure rollers.

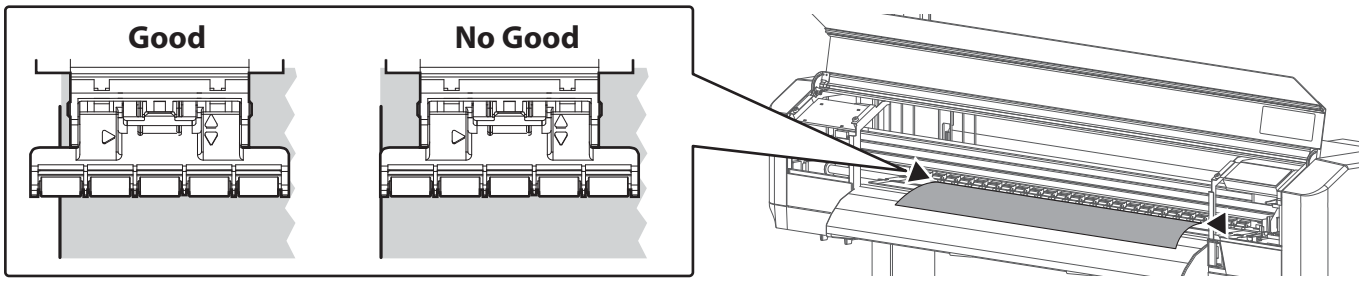
Note

Using this lever, the holddown pressure can be changed between High and Normal. Normally push the lever until it clicks to apply normal pressure.

☞Operation Manual "Changing holddown pressure using media feed lever"

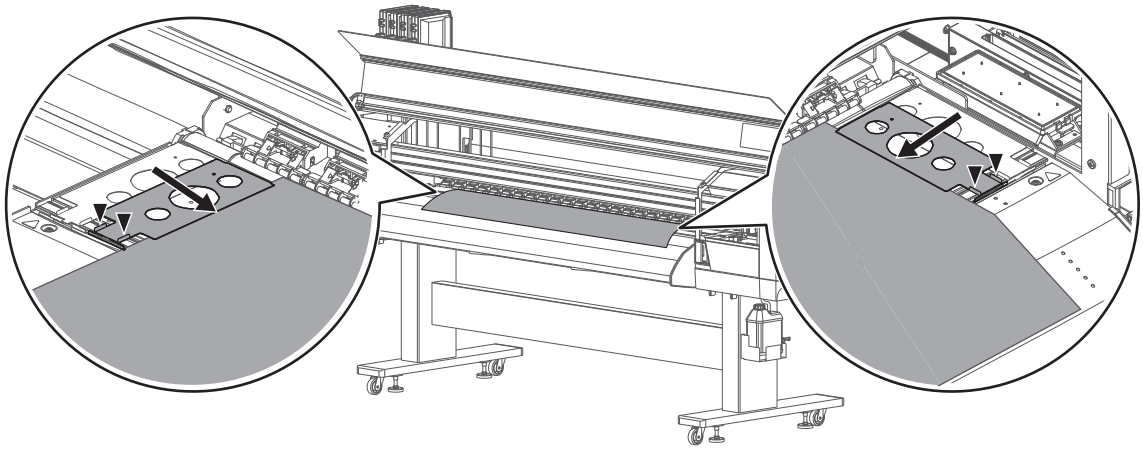
[2] Check that the pressure rollers hold down the both edges of the media properly.

- If it holds as a "No Good" example, pull the media feed lever towards you as much as possible, then adjust the position of the left or right side of the media holder until the both edges of the media are held down properly (see **"Place the media onto the media holder" P. 28** for more details).



[3] Place the edge holders on both edges of the media.

- Lift up the tab on the front of edge holder so that the center of edge holder is lifted.
  Move and place it on the edge of the media while the center of the edge holder is lifted.



Note

The way to attach edge holders varies depending on type of roll media to be loaded.

☞Operation Manual "Swapping left and right edge holders depending on the media type"

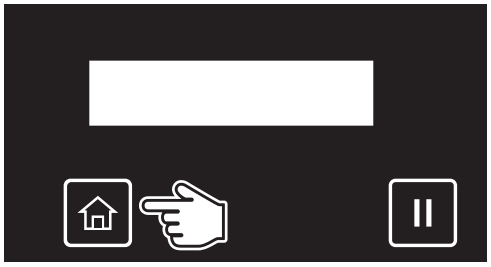
- Normally attach them as shown in the figure below so that the hole on the edge holder is located on the outside of the holder. This will hold down roll media lightly.

- To print on thin or soft media, swap left and right edge holders and attach them as shown in the figure below so that the hole on the edge holder is located on the inside of the holder. This will hold down wider area on roll media.

Important!

In the default setting, the printer starts printing with 5 mm margin on the sides.
DO NOT hold down the edge of the media more than 5 mm with the edge holder.

[4]



Tap (Home).

[5]

Tap .

[6]

Tap until the menu on the left appears.

- Tap .

[7]

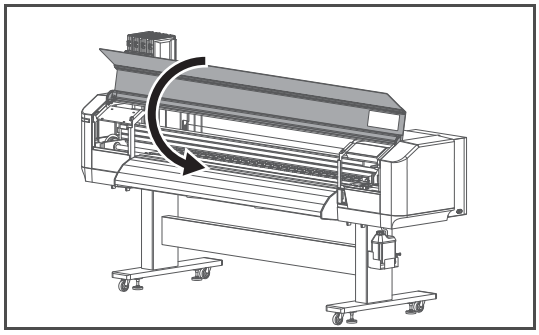
Enter the side margin. At least 10 mm margin is required.

- Use ▲ or ▼ to choose the alignment method.
- Tap ↵ (Enter).

Note

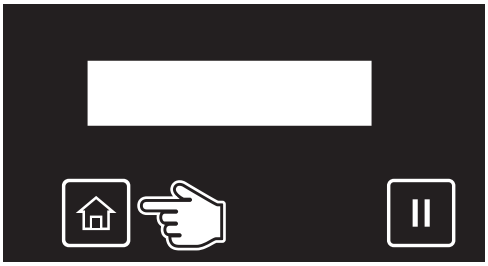
The side margin can be set between 5 mm and 25 mm.

[8]



Close the front cover.

[9]



Tap ⌂ (Home).

[10]

"User: Type** OK?" appears on the front panel.

- Use ▲ or ▼ to choose the correct user type and tap ↵ (Enter) to start media initialization.
  End the media loading.

Nozzle Check and Cleaning

Run a nozzle check print. If nozzle missing is found, perform cleaning.

This printer offers the following 3 kinds of nozzle checks:

- Nozzle Check: Print a nozzle check pattern selected from "Setup 29: Select Nozzle.
- Nozzle Check F: Print a nozzle check pattern using all of the nozzles on the print head.
- Auto Nozzle Check: Run an automatic nozzle clogging detection using the built-in drop sensor.

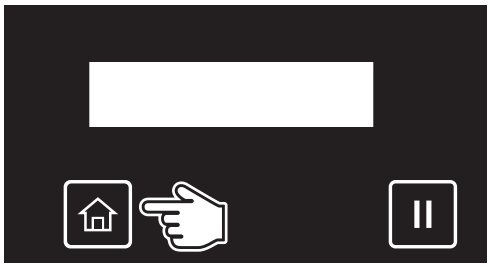
In this test print, select the pattern Nozzle Check F which is printed using all of the nozzles.

1. Run a nozzle check F print

[1] Load a roll media for Nozzle check.

☞ "Test printing" P. 25

[2]



Tap (Home).

[3]

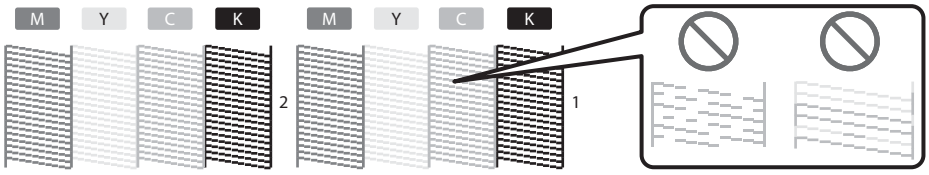
- Use to choose the menu shown left.
- Tap .

[4]

- Use to choose the menu shown left.
- Tap (Enter).

[5] Look at the print.

- If you find missing or thin lines on the print, go to "Perform cleaning" P. 36.
- If all lines are clearly printed, you can start printing.



Note

- Printer information (Data and time printed, serial number, firmware version) is printed next to the pattern.

Important!

If you run a nozzle check print immediately after the initial ink charging, the following symptoms may occur:

- lines are faded.
- patterns are partially missing.

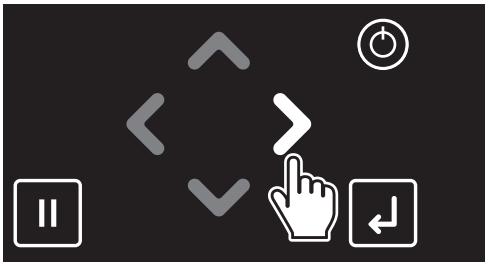
In such cases, follow the instructions on the operation manual "Menu 3: Cleaning" to perform "Little Charge".

If it does not help to solve the problem, leave the printer for one hour or more, then perform cleaning or "Little Charge" again.

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

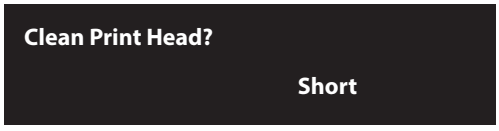
2. Perform cleaning

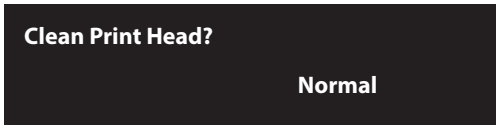
[1]

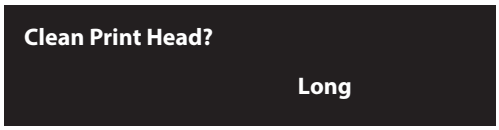


Tap ›.

[2]







Use ^ or v to choose the cleaning mode.

Tap ↵ (Enter).

- The printer will start cleaning.

[3] Run a nozzle check print again.

☞ "Run a nozzle check F print" P. 35

- If the problem persists, repeat normal cleaning until all nozzles are clear.
  To perform "Short", "Long", "Little Charge", and "Initial Charge", see the operation manual "Head Cleaning".

Note

- Before you start printing an image, connect your computer and configure the IP address, subnet mask, and default gateway.
  ☞ Operation manual "Setup 20: IP Address", "Setup 21: Subnet Mask", "Setup 22: Gateway"
- If "Long" or "Little Charge" cleaning does not help to recover the nozzles, go to "Setup 29: Select Nozzle" to select the nozzles that fire properly.
  ☞ Operation manual "Setup 29: Select Nozzle"

Important!

You must perform media feed adjustment before printing an image.

☞ Operation manual "Media feed adjustment"

Installing MUTOH Status Monitor

Before you start printing an image, MUTOH Status Monitor (MSM) must be installed on your computer.
After installing MSM, follow the instructions on the MSM operation manual to configure MSM initial setup, printer registration.
☞ MUTOH Status Monitor Operation manual “Initial Setting”

The following software and operation manual can be downloaded from MUTOH Club:

MUTOH Status Monitor (MSM)	Allows you to view printer status, change printer’s settings and run a test printing.
Manuals (for printer and software)	The following documents are available in the PDF format. • XPJ-1642WR Operation manual “Operations and Maintenance Methods” • XPJ-1642WR Startup Guide (This manual) • MUTOH Status Monitor Operation manual

Important!

Make sure to install MSM downloaded from MUTOH Club.

[1] Follow the instructions on the "Request for User Registration & Download" sheet supplied with the product to complete user registration and download the Startup Assistant package for your printer.

[2] Unzip the file downloaded and double click on setup.exe.

Safety Precautions

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.

Safety Notices

Signification of WARNING and CAUTION

WARNING	Failure to follow the instruction may result in serious injury or death.
CAUTION	Failure to follow the instruction may result in minor injury or damage to the product.

Meaning of symbols

Warning symbol	Meaning
	Indicates an action that must be avoided.
	Indicates an important instruction that must be followed.

Note

Refer to "Main components of your printer" of operation manual for names of each component in the main body.

Electrical Shock, Short, and Fire Hazard

WARNING

DO NOT install this product in a location with high humidity and dust.
This could result in an electrical shock or fire.

DO NOT use a damaged power cord.
This could result in an electrical shock or fire.

DO NOT connect or disconnect the power plug with wet hands.
This could result in an electrical shock.

DO NOT connect an earth wire to the following places:
- **Gas pipe**
  It has potential risks of fire and explosion.
- **Earth wire of telephone cables or lighting rods**
  Large current may flow when the lightning strikes.
- **Water pipe or faucet**
  It may not work properly if a plastic pipe is connected to the pipe.

DO NOT insert or drop metal or flammable objects into the printer through openings such as vent.
This could result in an electrical shock or fire.

If foreign objects or liquid accidentally entered the inside the product, do not use the printer.
It could result in an electrical shock or fire.
Immediately power off the printer and disconnect the power plug from the outlet. Then contact the MUTOH customer support.

DO NOT block the vent on the product with cloth or other materials.
If covered, the inside the product gets hot, resulting in fire.

Follow the precautions below when handling the power cord.
- **Do not modify power cords.**
- **Do not place heavy objects on power cords.**
- **Do not bend, twist, or pull on power cords.**
- **Do not route power cords near heating equipment.**

Follow the precautions below when handling the power plug.
- **Do not allow dust or foreign objects to accumulate around the power plug.**
- **Firmly insert the power plug into the wall outlet.**

DO NOT use flammable liquid on the media guide.
This could result in fire.

Use the designated power cord only.
Failure to do so could result in an electrical shock or fire.

Plug the power cord into the wall outlet.
DO NOT use power strips. This could result in fire.

Plug the power cords into the wall outlet that has the earth connection and make sure to connect the earth.
If the earth is not connected, an electrical shock or fire may occur.

Plug two power cords into the wall outlet with the same voltage.
Failure to do so may damage the electrical circuit.

Make sure to connect an earth wire to the earth connection that meets the following requirements:
- Earth terminal of power socket
- An earth wire with a copper plate which is buried at 650 mm or more in the ground.

Be sure to use the designated power cords.
- Failure to do so could result in an electrical shock or fire. For the designated power cord, please contact your local MUTOH dealer.
- The power cord should have the protective ground terminal and make sure to plug in securely.
- Use the power cords which meet the safety standard, voltage and plug shape of the country to use this product.

Make sure to follow the instruction on this manual to plug the power cord into the wall outlet.
Failure to do so could result in fire.

Never open the covers securing with screws.
This could result in an electrical shock or damage to the printer.

If you are not using the product for a long period of time, disconnect the power plug from the wall outlet.

Ensure that no moisture enters the product.
This could result in an electrical short circuit.

Installation Precautions

WARNING

When installing this product, avoid the location where
- **the floor is not flat and level.**
- **the product gets vibration from the neighboring devices.**

Failure to do so may result in injury from a fall.

CAUTION

DO NOT tilt or turn the product upside down.
The ink inside the printer may spill.
MUTOH cannot guarantee that the printer can run properly.

Keep this product level when moving.

Minimum four people are required for unpacking or moving this product.

Before taking out the printer from the packing box, remove the plastic sheet wrapped around the printer first.
Failure to do so may cause slip or damage to the product.

This equipment is not suitable for use in locations where children are likely to be present.

Product Handling

WARNING

DO NOT sit on or place heavy objects on the product.
Failure to do so may result in injury from a fall.

CAUTION

Follow the precautions below when cleaning the cleaning wiper or around the print head:
- **DO NOT reuse the cleaning stick.**
  Dust on the stick may damage the print head.

Follow the precautions below when cleaning the cleaning wiper.
- **DO NOT touch the cleaning wiper and head cap unit with your bare hands.**
  The skin oil from your finger can result in improper cleaning.
- **Use a dry cleaning stick to clean the wiper. DO NOT moisten the stick with water.**
  This may cause the nozzle clogs.

Follow the precautions below when cleaning around the print head:
- **DO NOT touch the surface of the print head.**
  This may damage the print head.
- **DO NOT touch the cleaning stick with your finger.**
  The oil from your finger may damage the print head.
- **DO NOT use water when cleaning with cleaning sticks.**
  This may damage the print head.

Product Handling (continued)

DO NOT touch the media guide while printing or the heater is on.
The media guide can be very hot, causing burn injuries.

The media guide can be very hot immediately after printing.
Wait until it cools down.

DO NOT attempt the following actions during ink charging:

- **Power off the printer.**
- **Disconnect the power cord.**
- **Open the front cover.**
- **Open the maintenance cover.**
- **Release the pressure rollers.**

DO NOT use volatile chemicals such as thinner, benzine or alcohol for cleaning.
This will damage the paint on the printer.

Ink Handling

WARNING

Waste ink collected from this product is classified as industrial waste. Dispose of waste ink according to the local waste disposal regulations.

CAUTION

Do not disassemble Ink bags.
If disassembled, ink may come into contact with your eyes or skin, causing irritation or allergic reaction.

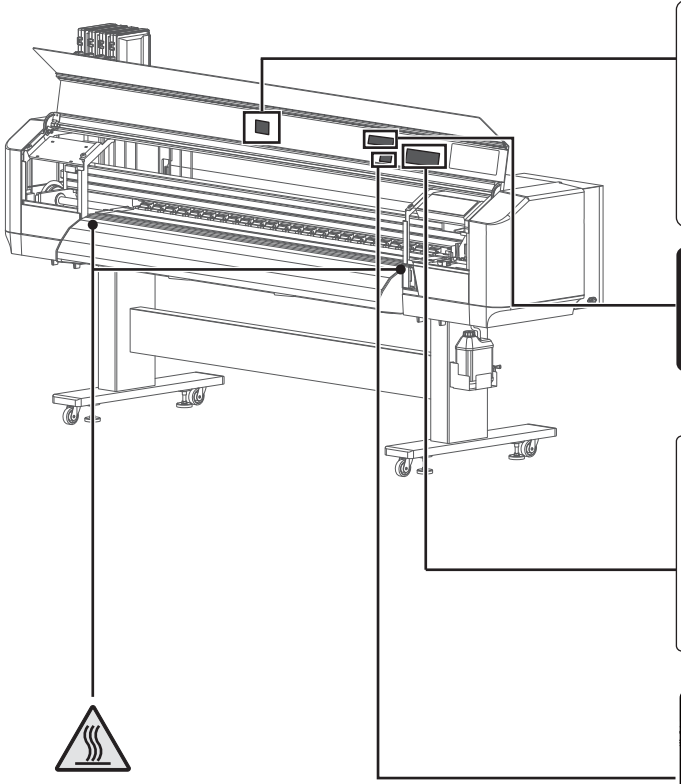
Before using the ink bag on the printer, make sure to read the Safety Data Sheet (SDS).

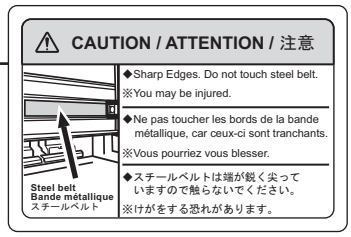
DO NOT drop or hit an ink bag.
Ink may leak from the bag.

Wear the protective gloves and avoid contact with your eyes or skin.
Eye or skin contact may cause slight irritation or bloodshot eyes. If in eyes or on skin, immediately flush with water. If irritation is present, seek medical advice/ attention immediately.

Warning Labels

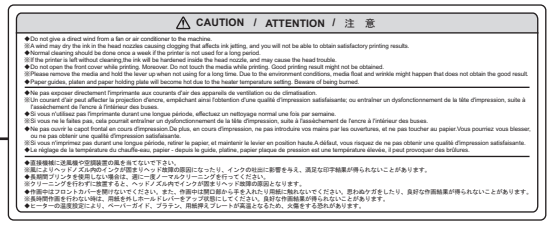
Warning labels are applied onto the product where special attention is required. Read the messages on the labels and always follows the instructions. If the labels are peeled off or become dirty, contact your local MUTOH dealer to get new one.



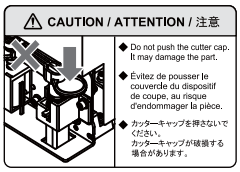


Cut Hazard Label for Steel Belt

Cut Hazard Label for Cutter



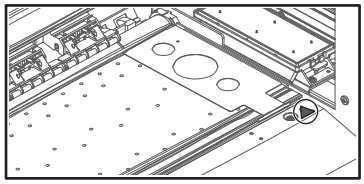
Printer Safe Handling Label



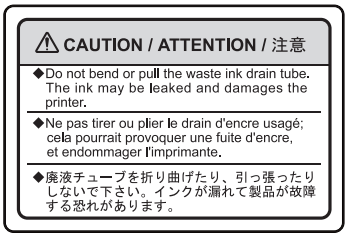
Cutter Cap Caution Label

When replacing a cutter blade, do not push the cutter cap.

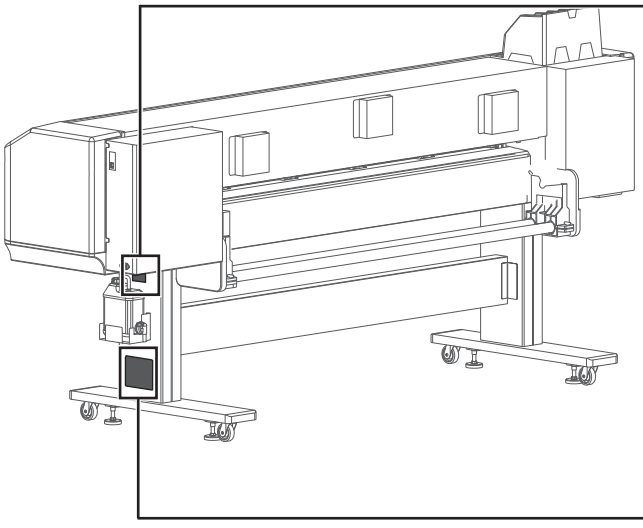
Hot Surface Caution Label



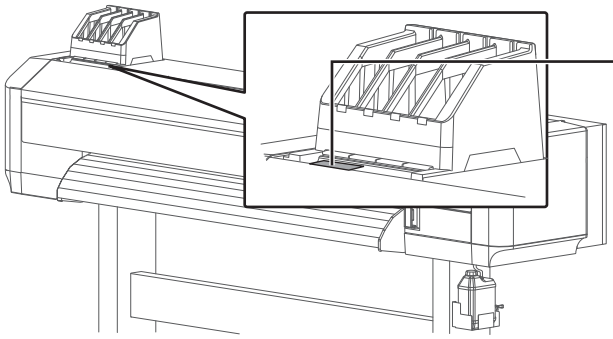
The surface may get hot and may cause burn injury.
Do not touch with your hand for at least 30 minutes after turning off the printer.



Caution Label for Waste Ink Drain Tube Handling

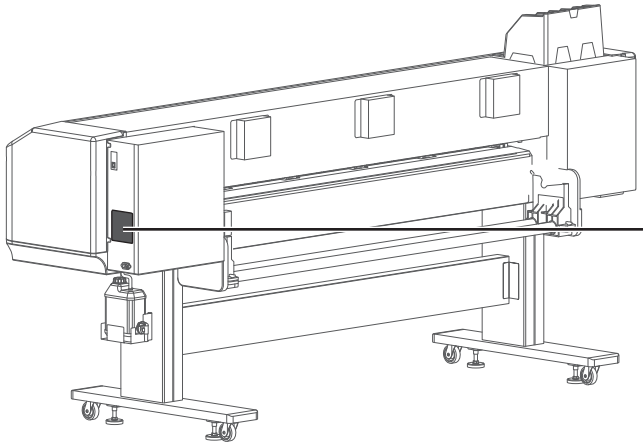


Waste Fluid Caution Label

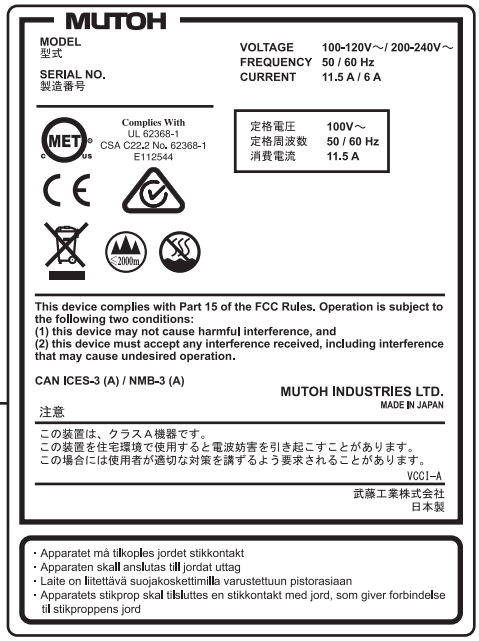


Protective equipment label
(Mask • Glasses • Gloves • Protective clothing)

Wear protective equipment when handling ink.



Rating plate



"~" on the rating plate represents AC voltage.

Note

The following marks are for China's safety standards.

汉文	仅适用于海拔2000m以下地区安全使用。
藏文	《2000m ཡར་ཨངུགས་ཀྱིས་ཉམས་ལག་ཚད་ཀྱི་ ཀུན་སྤྱོད་ཐུབ་ཡོད།》
蒙古文	“ᠭᠤᠯᠠᠭᠤᠳᠤᠷ ᠳᠡᠭᠡᠭᠰᠢ ᠠᠯᠢᠪᠠ ᠵᠠᠰᠠᠭ ᠨᠢ2000ᠮᠠᠲ᠋ ᠬᠦᠷᠲᠡᠯ ᠶᠡᠬᠡ ᠪᠠᠢᠳᠠᠯ ᠳᠤᠷ ᠬᠡᠷᠡᠭᠯᠡᠭᠳᠡᠵᠦ ᠪᠣᠯᠣᠭᠳᠠᠭᠠ᠃”
壮文	Dan hab yungh youq gij digih haijbaz 2000m doxroengz haenx ancienz sawjyungh.
维文	دېڭىز يۈزىدىن 2000 مېتر تۆۋەن رايونلاردىلا بىخەتەر ئىشلەتكىلى بولىدۇ

汉文	“仅适用于非热带气候条件下安全使用。”
藏文	《ཉམས་ལྡན་ ཨེབས་ཀ ཨེབས་ སྐྱེས་ སོར་སྐྱོང་ ལ་ རྟགས་ཀྱི་ ཀུན་སྤྱོད་ཐུབ་ཡོད།》
蒙古文	“ᠬᠣᠳᠠᠳ᠎ᠠ ᠭᠤᠯᠠᠭᠤᠳᠤᠷ ᠭᠠᠵᠠᠷ ᠤᠨ ᠭᠠᠷᠭᠠᠯᠭ᠎ᠠ ᠳᠤᠳᠠ ᠭᠡᠵᠢ ᠪᠠᠢᠭᠤᠯᠤᠭᠰᠠᠨ ᠳᠤ ᠳᠡᠭᠡᠭᠰᠢ ᠠᠯᠢᠪᠠ ᠵᠠᠰᠠᠭ ᠨᠢ ᠬᠦᠷᠲᠡᠯ ᠶᠡᠬᠡ ᠪᠠᠢᠳᠠᠯ ᠳᠤᠷ ᠬᠡᠷᠡᠭᠯᠡᠭᠳᠡᠵᠦ ᠪᠣᠯᠣᠭᠳᠠᠭᠠ᠃”
壮文	Dan hab yungh youq gij dienheiq diuzgen mbouj dwg diegndat haenx ancienz sawjyungh.
维文	غەيرى ئىسسىق بەلباغ ھاۋا كىلىماتى شارائىتىدىلا بىخەتەر ئىشلەتكىلى بولىدۇ

MUTOH