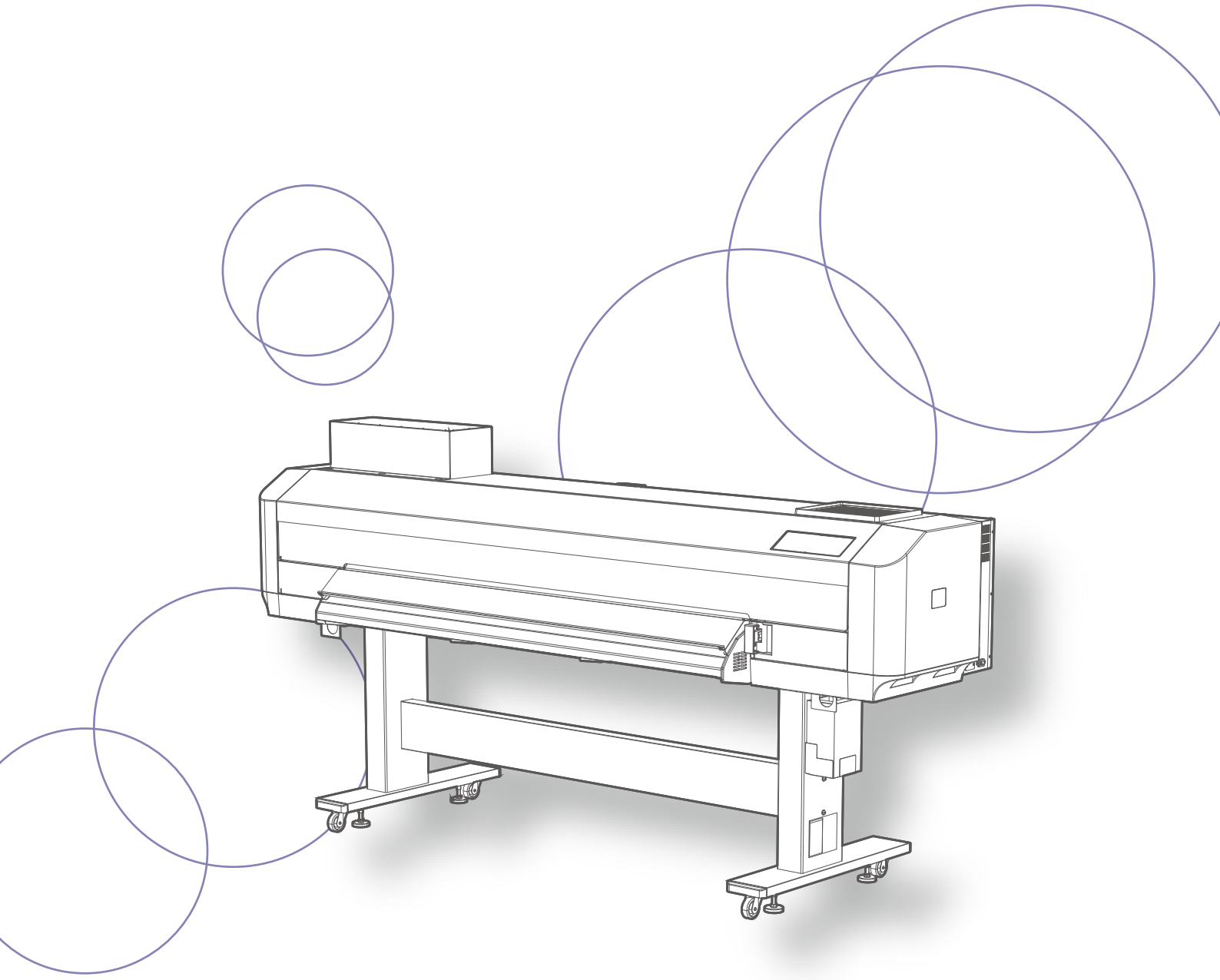
MUTOH

XPJ-1682UR

Startup Guide

Unpacking and Assembling Instructions



XPJ1682URE-Q-01

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.

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- 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.

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Safety Symbols

Symbols

In this document, the following symbols are used for the instructions that must be followed to avoid risk of harm to human health or damage to the property.

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.

Actions that must be avoided or Instructions that must be followed.

	Indicates an action that must be avoided.
	Indicates an important instruction that must be followed.

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 warning or caution symbols, see “Before Use” on the XPJ-1682UR operation manual.

Electrical shock hazard / 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.	**Make sure to use a designated power soket.**
Do not use a damaged power cord. This 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.
Do not connect or disconnect the power plug with wet hands. This could result in an electrical shock.	**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.
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.	**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.
	Keep ink away from fire or heat source and store in a cool, dark place in order to avoid risk of fire.
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.**	
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.	**Do not block the vent on the product with cloth or other materials.** If covered, the inside the product gets hot, resulting in fire.
Never open the covers securing with screws. This could result in an electrical shock or damage to the printer.	**Make sure to follow the instructions on this guide to connect the power cord or cables.** Failure to do so could result in fire.
Ensure that no moisture enters the product. This could result in an electrical short circuit.	**If foreign objects or liquid accidentally entered the inside the product, do not use the printer.** This 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.

	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.

Installation

⚠ Warning

	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 printer. • Low levels of electromagnetic waves.		**Keep the work area well-ventilated.** Odor of UV ink could have adversely impact on health. If you experience headache, fatigue or dizziness, stop your work and immediately get to fresh air. If nausea persists, seek medical advice.
			This equipment is not suitable for use in locations where children are likely to be present.
	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.		

⚠ Caution

	Next to the UV-LED lamp in the printer, there may be other sources of UV light present in the working environment: sunlight or any form of artificial light. To avoid printer damage (nozzle clogs, operation faults to the maintenance station, print head damage.) caused by unintentional curing by UV light sources present in the working area, please follow these guidelines: • Do not install the product in direct sunlight. Make sure to keep the front cover closed unless necessary to open it. • Do not remove the cover. Do not modify this product. The warranty does not cover if the product has been modified or disassembled.		
	Minimum three people are required for moving this product.When moving, keep this product level.		**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.

Handling

Warning

Do not sit on or place heavy objects on the product. Failure to do so may result in injury from a fall.	**Do not touch the moving parts.** This may cause injury or damage to the product.
In case you need to move the printer after ink was filled, move it slowly to avoid impact and risk of ink leakage.	

Caution

Ultraviolet light (bluish white light) emitted from the UV inkjet printer is minimized to safe levels; however, be aware of the following points when handling the printer. • Do not stare directly into the gap under the cover, or stare at the ultraviolet light at close range for long periods of time. This may cause eye damage. • Do not expose your skin to ultraviolet light at close range for long periods of time. This may cause skin inflammation.	
When cleaning, follow these precautions: • Make sure to wear protective equipment (gloves, goggles or eye protection, protective clothing, mask). • Always follow the steps to perform maintenance. • Always use a new cleaning stick and dampen it with designated maintenance cleaner. Do not use other type of maintenance cleaner. It may cause nozzle clogging. • Do not touch the tip of a cleaning stick with fingers. If finger oil gets on the stick, it will damage the print head. • Do not reuse a cleaning stick. Dust sticking to the stick will cause damage to the print head.	
Never touch the print head nozzles when cleaning around the print head. This could damage the print head.	**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.
Before moving this printer, always empty the waste ink tank even moving short distance. Failure to do so may result in damage to the product.	**Do not use volatile chemicals such as thinner, benzine or alcohol for cleaning.** This will damage the paint on the printer.
When handling the front cover or the maintenance cover, always use the following safety precautions: • Avoid strong airflow from a fan or an air conditioner to install this printer. If not, it may accidentally close the cover. • When opening the cover, make sure the cover does not hit anyone or anything.	
Make sure the print is completely cured before touching. If you are not sure, wear gloves to avoid skin or clothing contact with ink.	**Do not attempt the following actions during ink charging:** • Power off the printer. • Disconnect the power cord. • Open the front cover or the maintenance cover. • Move the printer.

Ink and waste fluid

Warning

The safety concerns involved with using and handling of UV curable ink and waste fluid are detailed in the Safety Data Sheets (SDS). Please carefully read these sheets before handling these liquids.

Store ink bags and waste fluids in a cool, dark place and avoid direct sunlight.

Keep away from

- children's reach
- fire and heat

Wear protective equipment (gloves, goggles or eye protection, protective mask, protective clothing) when handling ink.

- Do not touch uncured UV ink with bare hands.
  UV ink curing time varies depending on surface characteristics of media. Especially a print with low ink coverage needs to rest for a while (approximately one hour). When checking that it is cured, make sure to wear protective gloves.
- Especially during operations where ink might contact you (e.g. handling ink or waste fluid, cleaning of print head/cap/wiper), always wear protective equipment (such as solvent-resistant gloves and goggles) to avoid contact with skin or eyes.
- Two types of gloves are supplied with the printer. To avoid ink penetration, please wear rubber gloves (white) over polyethylene gloves (pink). If these gloves are not available, butyl rubber gloves are recommended.
- If glove becomes contaminated with ink, replace with new ones.
- If ink gets on skin, immediately wash with soap and plenty of water for 15minutes. Seek medical advice/ attention if irritation or inflammation are present.
- If ink gets in eyes, flush eyes with plenty of water for 15minutes and seek medical advice/attention immediately.
- If swallowed, rinse mouth immediately and do not induce vomiting. Seek medical advice/attention.

- When disposing of ink, waste fluid collected from the printer, or containers and paper towels with ink adhered, be sure to follow industrial waste disposal contractors, related laws, and local regulations to dispose of them.
- Waste fluid from this printer is harmful. Do not allow it to reach sewage or natural water systems.
- Use a HDPE container with light blocking properties to store waste liquid.
- **When storing waste fluid for a long time, slightly loosen the cap on the container to allow air. Do not tightly close it.**
- Do not mix waste ink with any other chemical substances, not even in small amounts.
  When mixed with other chemicals (e.g. oxidants), heating may occur.

Caution

Follow these precautions when handling ink bag:

- Do not disassemble
- Do not drop or hit

This could lead to ink leakage.

Use of non-designated ink could cause printer failure. Mutoh does not cover the cost of repair caused by such use.

Use inks within its shelf life.

- Using an expired ink could result in damage to the printer.
- 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.

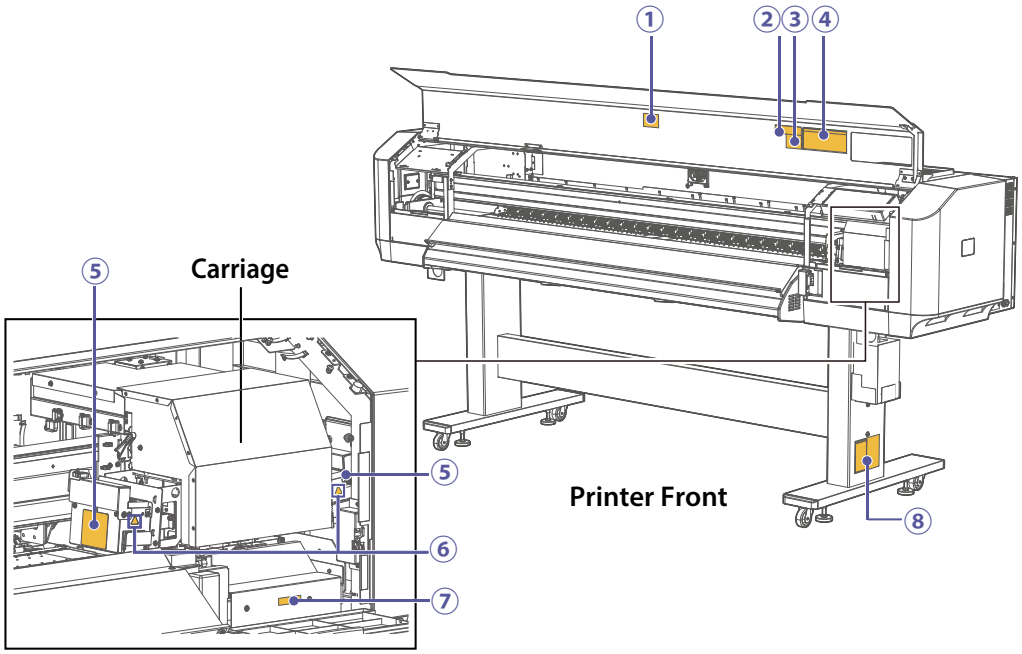
Use MUTOH genuine ink.

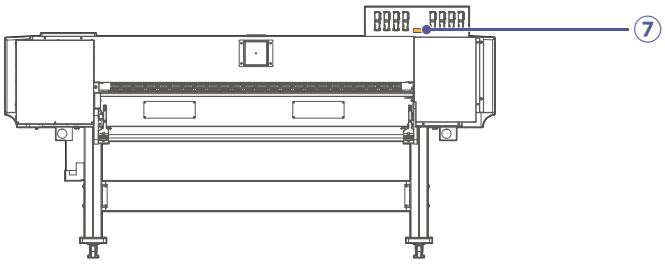
This printer is designed to deliver best performance by using MUTOH genuine ink. The use of non-genuine ink may affect the printer as well as print quality. This is not covered by the warranty.

Warning labels

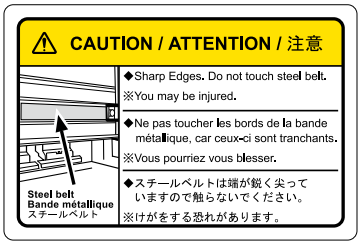
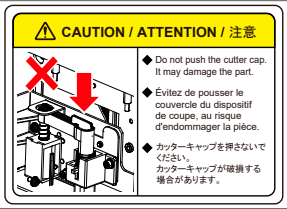
Warning labels are affixed to the hazardous area of the printer. Read and follow the instructions on the labels.

In case the warning labels came off or get dirty, please contact your local MUTOH dealer for replacement.

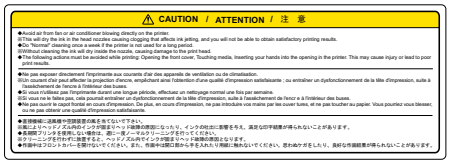




Printer Rear

	Type of labels	Name / Meaning
①		**Steel Belt Caution** • Do not touch this part to avoid injury.
②		**Cut Hazard Label for Cutter** • Do not insert your fingers around the cutter. The cutting blade may injure your fingers.
③		**Cutter Cap Caution** • Do not push the cutter cap. This could damage the part.

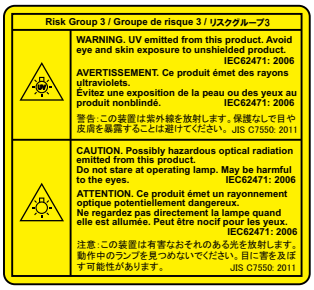
④



Front Cover Caution

- Follow the instructions on this label.

⑤



UV Safety Label

- UV light hazard: Avoid direct skin or eye exposure to light.

⑥

Hot Surface Hazard Label

- Risk of burns. Do not touch this surface for 10 minutes after printing.

⑦

Personal Protective Equipment Label

- Wear necessary protective equipment when handling ink.

⑧

Waste Fluid Caution Label

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

Note

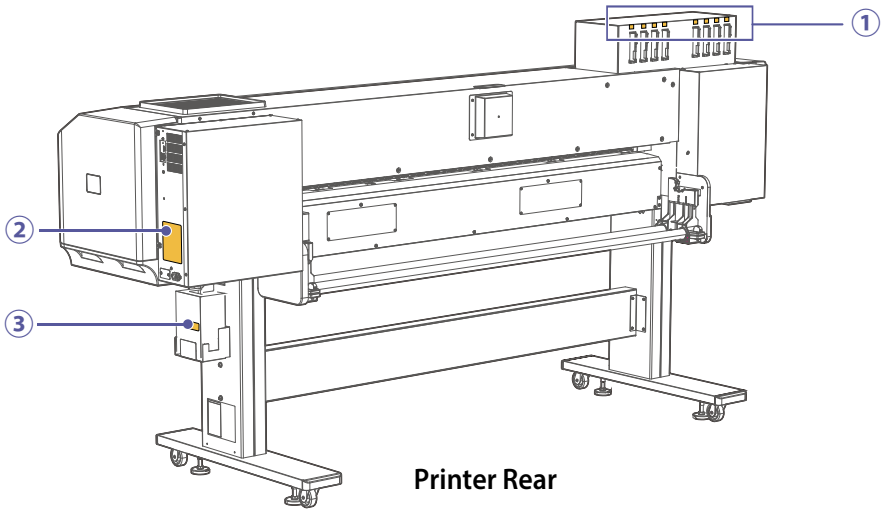
The following labels correspond with the Chinese safety standards.

汉文	仅适用于海拔2000m以下地区安全使用。
藏文	《2000m ར་ས་ལས་ལྟོག་ཐུབ་ལས་ཡོད་ཚད་ཀྱི་ས་གནས་ཁོངས་ནང་ཁོ་ནས་སྤྱོད་དགོས།》
蒙古文	“ᠭᠤᠯᠠᠭᠠᠨᠢ ᠳᠡᠭᠡᠷ ᠠᠯᠠᠪᠠ ᠪᠠᠢᠷᠢᠯᠠᠭᠤᠯᠵᠤ ᠪᠤᠢ 2000ᠮᠧᠲᠷ ᠳᠤᠤᠷᠠᠬᠢ ᠭᠠᠵᠠᠷ ᠳᠡᠭᠡᠷ ᠵᠥᠪᠬᠡᠨ ᠠᠵᠢᠯᠯᠠᠬᠤ᠂”
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

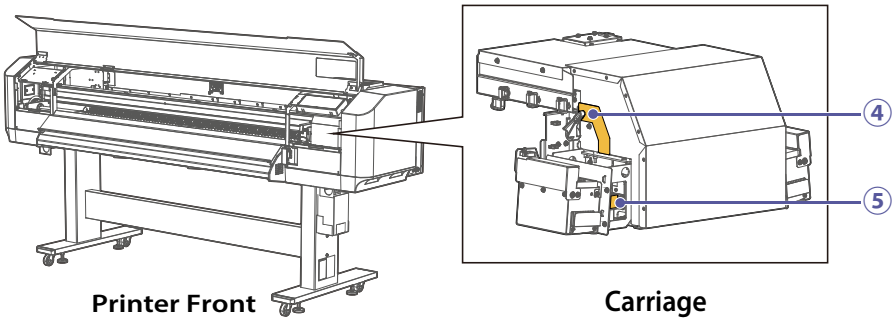
汉文	“仅适用于非热带气候条件下安全使用。”
藏文	《ཁྱིམ་ཚང་ཨ་ཆིས་ཀྱི་ཉིན་གཞིས་ཀ་ཡིན་པའི་ས་གནས་ཁོངས་ནང་ཁོ་ནས་སྤྱོད་དགོས།》
蒙古文	“ᠬᠡᠪᠢᠳᠡᠢ ᠠᠯᠠᠪᠠ ᠭᠠᠵᠠᠷ ᠤᠨ ᠭᠠᠷᠭᠠᠯ ᠲᠤᠷᠰᠢᠯᠲᠠ ᠪᠤᠰᠤ ᠭᠠᠵᠠᠷ ᠳᠤ ᠵᠥᠪᠬᠡᠨ ᠠᠵᠢᠯᠯᠠᠬᠤ᠂”
壮文	Dan hab yungh youq gij dienheiq diuzgen mbouj dwg diegndat haenx ancienz sawjyungh.
维文	غەيرى ئىسسىق بەلباغ ھاۋا كىلىماتى شارائىتىدىلا بىخەتەر ئىشلەتكىلى بولىدۇ

Instruction Labels

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

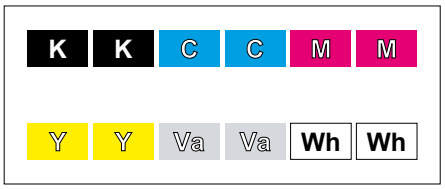
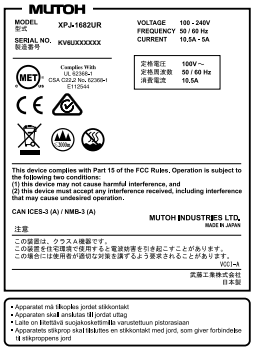


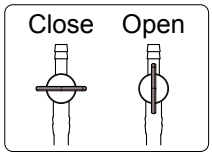
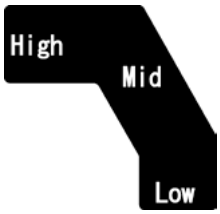
Printer Rear



Printer Front

Carriage

	Type of labels	Name / Meaning
①		**Ink Color Label** • Before using this product, apply an ink color label to the area above the ink slot depending on the ink color configuration of your printer. ☞"Applying the ink color labels" P.30 • Make sure to match the color of the ink to the color on this label and insert the correct ink cartridge (ink bag).
②		**Rating Plate** • Rating Plate provides the model number and serial number of the printer.

③		**Drain Tube Valve Caution** • The label indicates the open/close position of the drain tube valve.
④		**PG Label** • Adjust the print head height by referring to the label.
⑤		**ORIGIN Label** • The label indicates the origin position of the printer.

Check before installation

Installation Location Requirements

Choose the location which satisfies the requirements below.

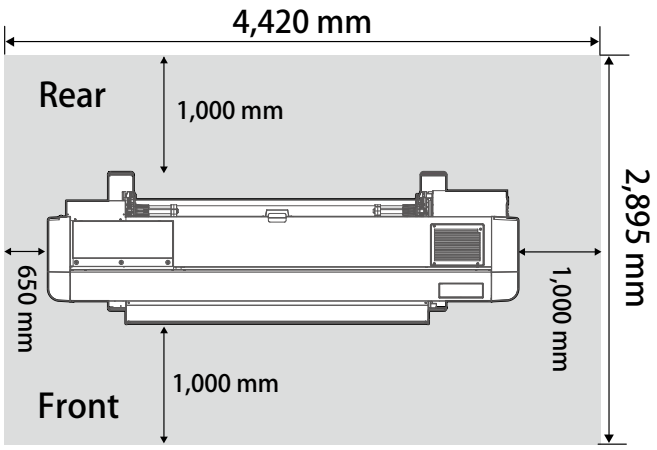
- The floor must be level.
- Avoid vibration from the neighboring devices.
- Low humidity and free from dust.
- Less chance of temperature and humidity changes.
- Avoid direct sunlight.
- Avoid water.
- Avoid direct air onto the printer (including air from air conditioner).
- Low levels of electromagnetic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

Caution

- **The floor where the product is installed must be able to support this product.**
  The weight of this product will be 181 kg including the stand and take-up unit. Installing in an unsuitable location could cause injury from the fall.
- **This product is not suitable for use in location where children are likely to be present.**
- **Keep the work area well-ventilated. Odor of ink may adversely impact on health.**
  If you experience headache or feel dizzy or dull, immediately get to fresh air. Seek medical attention if vomiting persists.

Minimum Space Requirements

The following space is required for installation.



Printer Size	
Width x Depth	: 2,770 mm x 895 mm
Height	: 1,527 mm *1

*1 When front cover opened. The height of the installation space mustbe at lease 1,760 mm.

Power Specification

The installation site must meet the following power specification:

Printer main unit

- **Input voltage:**

  AC 100V to 240V±10%

- **Input frequency:**

  50 / 60Hz ±1Hz

- **Input load current:**

  10.5 A or less (AC 100V to 120V)
  5.0 A or less A (AC 200V to 240V)

Warning

Do not use power strips.

Environmental Requirements

The installation site must meet the following 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

- Fluctuation:

  Temperature: No more than 2 °C per hour

  Humidity: No more than 5% per hour

- Printer Storage Condition:

  Without ink filled: Within 6 months :

  Temperature: -20°C to 60°C

  Humidity: 20% to 80%, non condensing

  Storage with ink filled: Up to 1 month*1

  Temperature 5 to 30 °C

  Humidity 20 to 80%, No condensation

  *1 Printer must be put into sleep mode. Make sure to check ink level and perform ink agitation once a week.

- Ink Storage Condition:

  - US61 ink:

    Black , Cyan, Magenta , Yellow , Varnish , White

    Temperature: 5°C to 30°C (Store in a cool, dark place.)

  - Cleaning cartridge

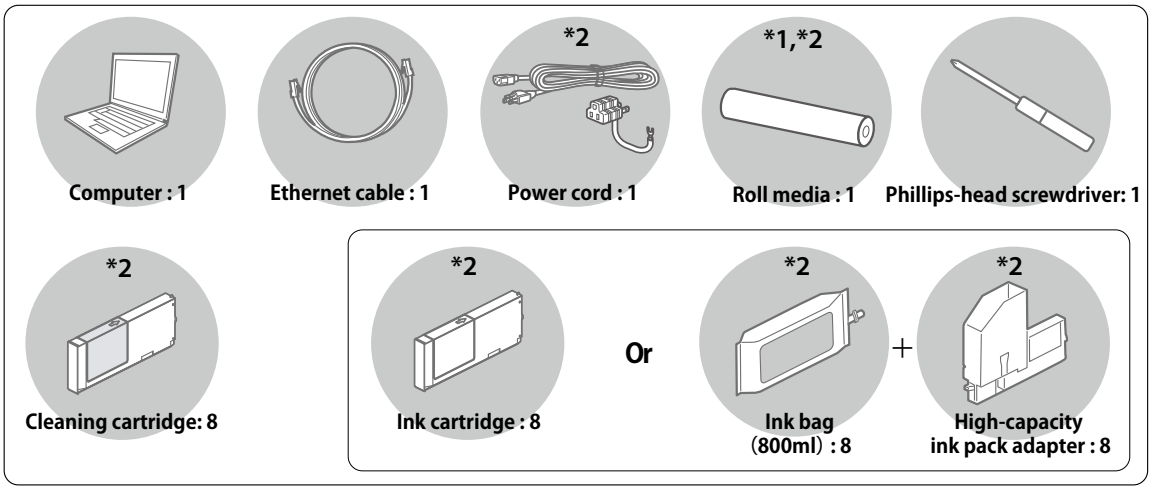
    Temperature: -20 °C to 40°C (At 40°C: within 1 month. Keep away from heat and flammable materials. Store in a cool, dark and well-ventilated place.)

Unpacking

Preparations

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

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



*1 Usable size for roll media

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

*2 Optional accessories or consumable supplies

Warning

Make sure to use the designated power cord.
Failure to do so could cause electric 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.
- Please also check the system requirements of your RIP software if you are using.
- To install the ink pack to the high-capacity ink pack adapter, refer to the operation manual included with the high-capacity ink pack adapter.

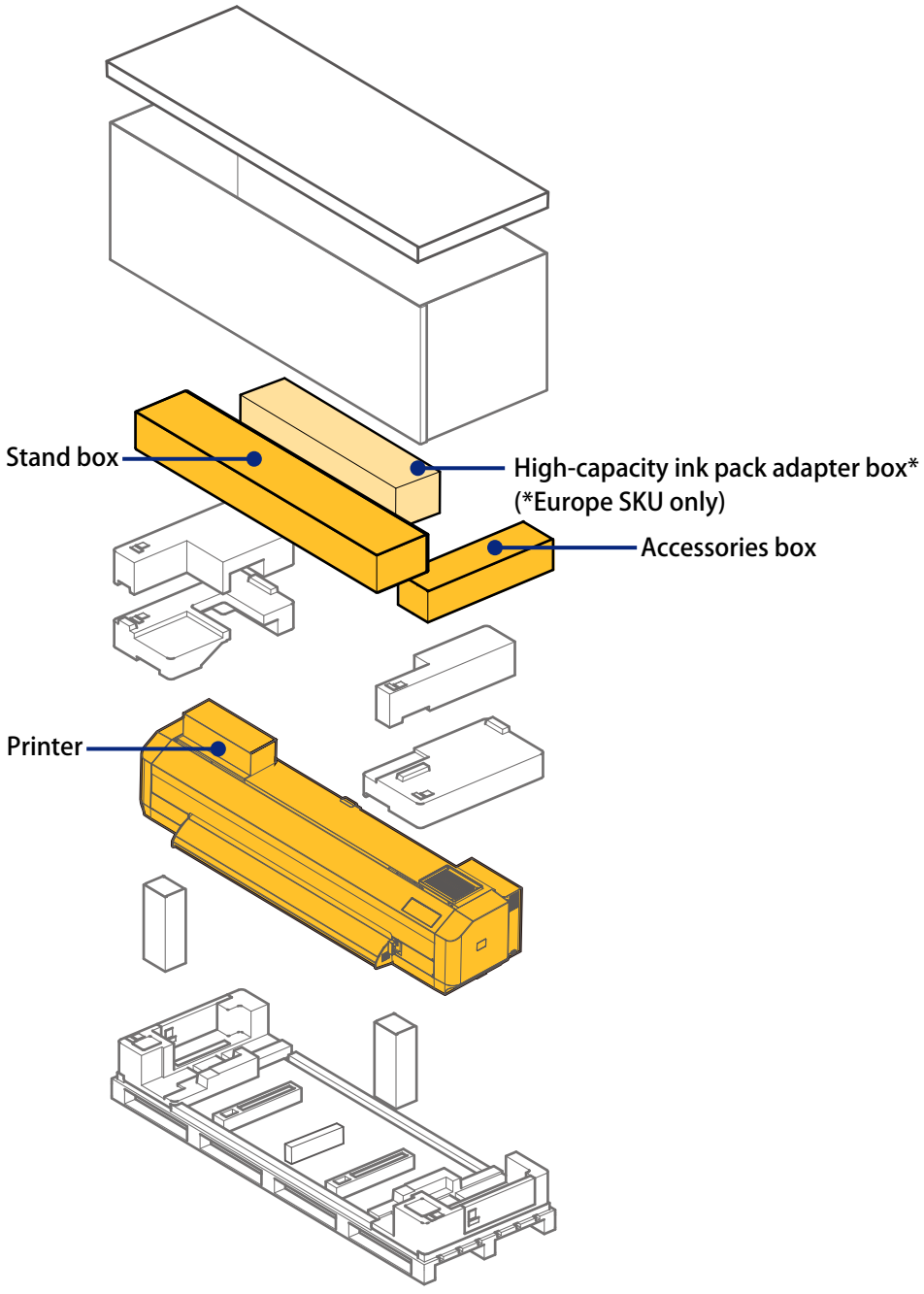
Unpacking the printer

Caution

- **At least four people are required for unpacking and moving the printer.**
- **When taking out the printer from the packaging box, remove the plastic sheet wrapped around the printer, then take it out. Failure to do so may cause slip and damage to the printer.**
- **Keep the printer level while moving.**

Follow these steps.

1 Remove the following items:.



2 Open the accessories box and check that the following items are included.

☐Startup Guide : English/Japanese (this document)

☐Request for Registration & Download : English/Japanese

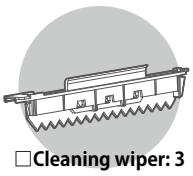
☐Daily maintenance sheet : English/Japanese

☐Notes for using dedicated ink :English/Japanese

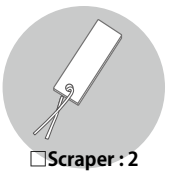
☐How to handle UV inkjet printer / its supplies : English/Japanese

☐Paper towel : 5

☐Cleaning stick : 50

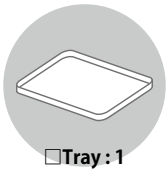


☐Cleaning wiper: 3

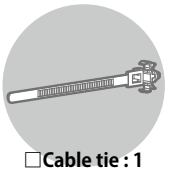


☐Scraper : 2

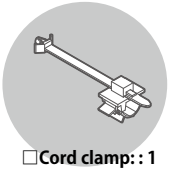
☐Dropper (5 ml) : 2



☐Tray : 1



☐Cable tie : 1



☐Cord clamp: : 1

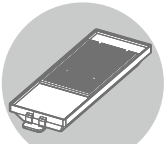
☐Rubber gloves : 100

☐Polyethylene gloves : 100

☐Goggles: 1

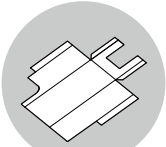
☐Plastic cup (100 ml) : 1

☐Ink color label : 1



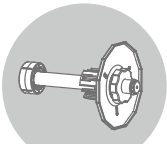
☐Flushing box pad : 3

☐Waste ink tank : 1



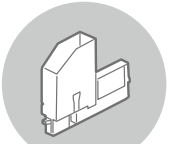
☐Waste ink tank cover: 1

☐Waste ink valve case : 1

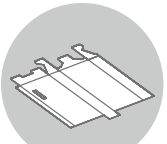


☐Media flange : 2

High-capacity ink pack adapter box (Europe SKU only)



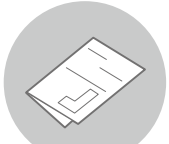
☐High-capacity ink pack adapter : 8



☐Ink light-blocking case : 8

☐Adapter sealing jig: 1

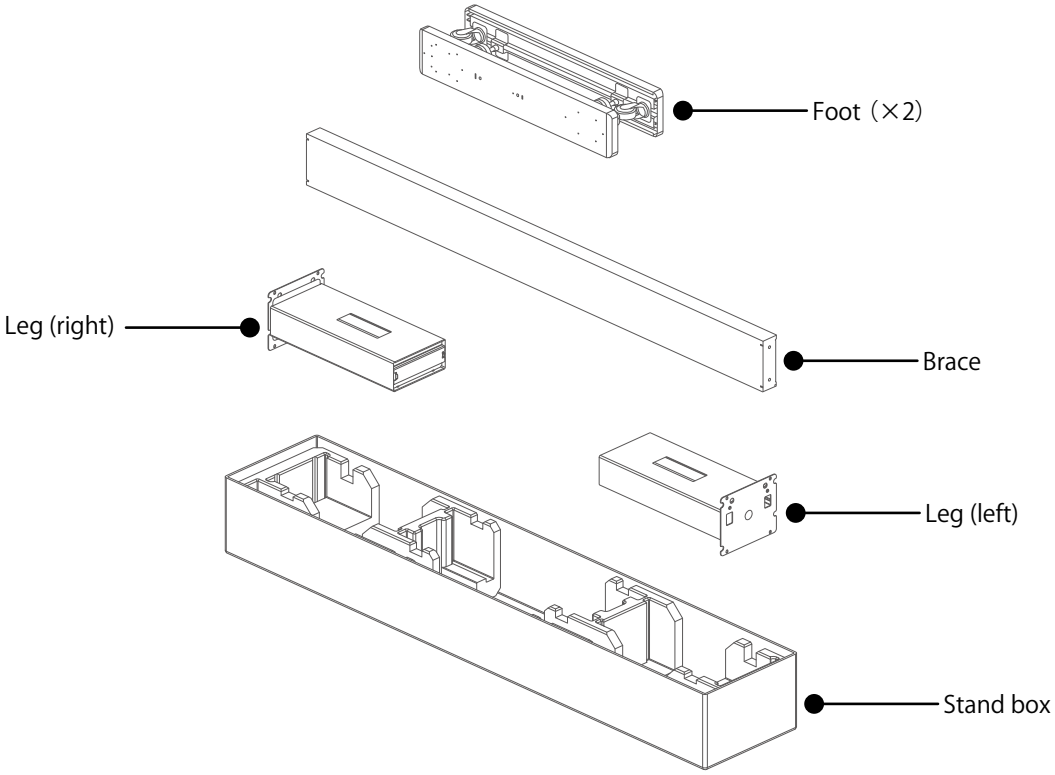
☐Rubber connector: 20



☐High-Capacity Ink Pack Adapter Operation Manual : English/Japanese

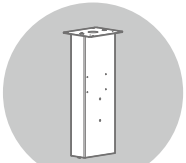
Unpaking the stand

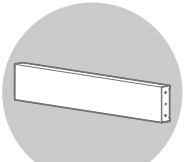
1 Open the packing box and take out each part.

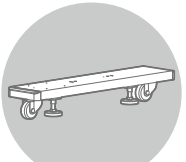


2 Check that the following items are included.

☐Leg (Left) : 1

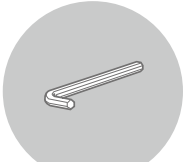

☐Leg (Right): 1


☐Brace : 1

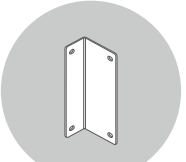

☐Foot: 2

☐Hex head bolt : 8

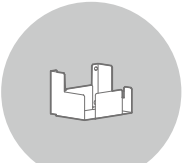
☐Spring washer: 8


☐Hex wrench: 1

☐Round head screw: 12


☐Fixing bracket: 2

☐Wing bolt: 8


☐Waste ink tank holder: 1

Assembling

Assembling the stand

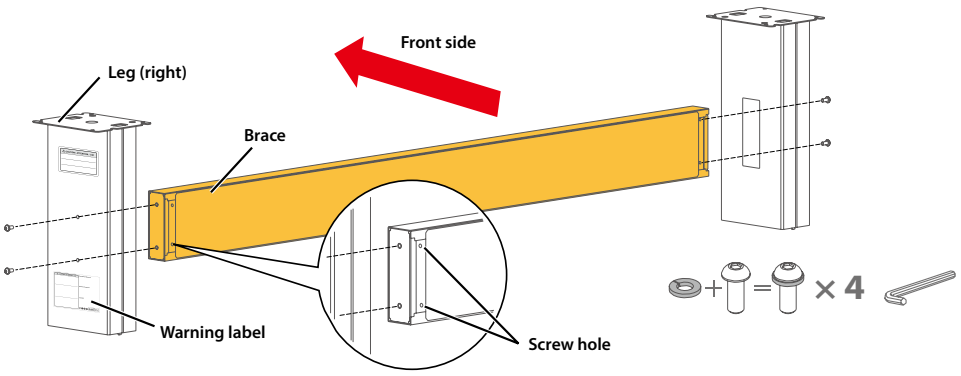
CAUTION

At least two people are required for this task.

Follow these steps to assemble the stand.

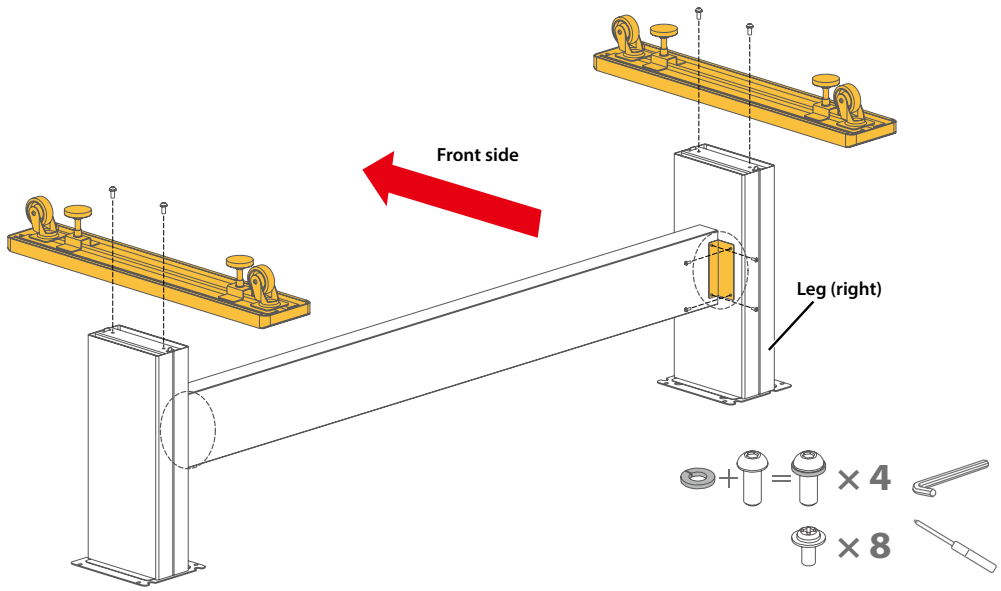
1 Attach the brace to the legs.

- Face the side with the hole of the brace towards the back of the printer and attach it to each leg.
- The leg with the warning label attached is the right leg.
- Use four hex head bolts with spring washers to secure them.

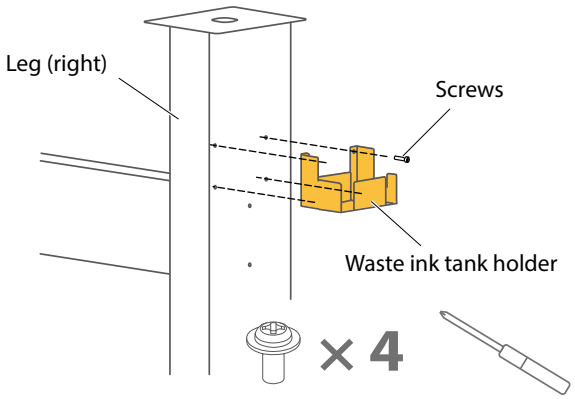


2 Attach the foot to the leg.

- Attach the foot so that the screw holes (x4) on the top surface of the foot are on the front side.Put the spring washers on the hex head screws (4 each), then tighten the screws.
- Use four hex head bolts with spring washers to secure them.
- Use the screws (x8) to secure the fixing brackets (x2).

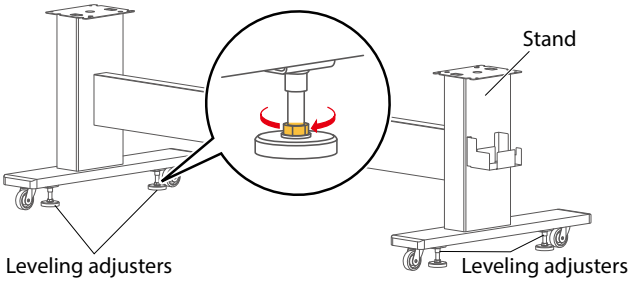


3 Use the screws (x4) to secure the waste ink tank holder to the leg (right).



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

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



Attaching the printer

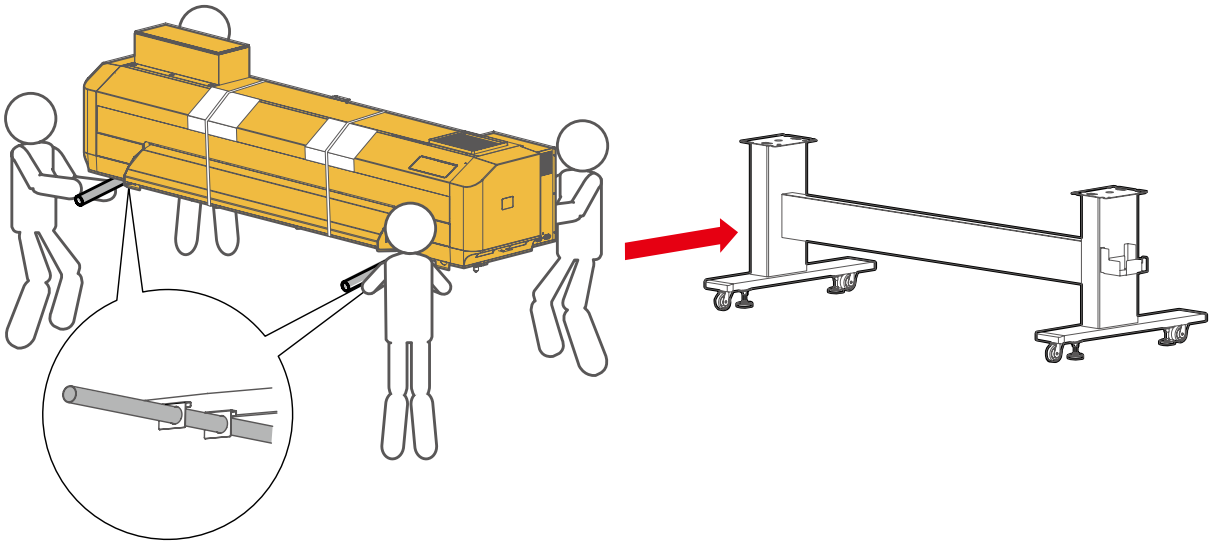
Caution

- **At least four people are required for unpacking and moving the printer.**
- **When taking out the printer from the packaging box, remove the plastic sheet wrapped around the printer, then take it out. Failure to do so may cause slip and damage to the printer.**
- **Keep the printer level while moving.**

Follow these steps to attach the printer to the stand.

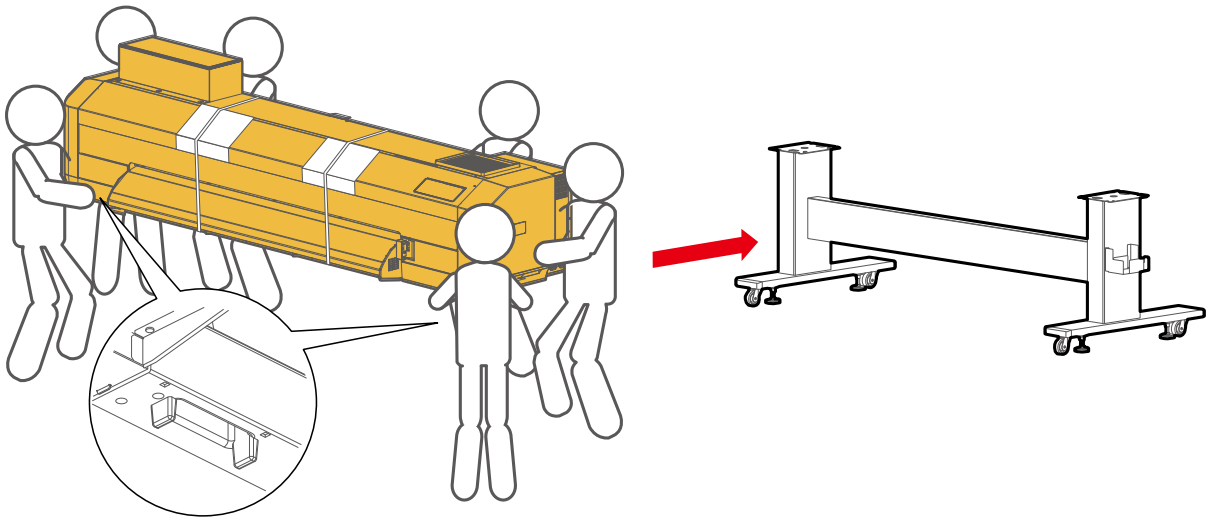
1 **Lift the printer with at least four people and mount it on the stand.**

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

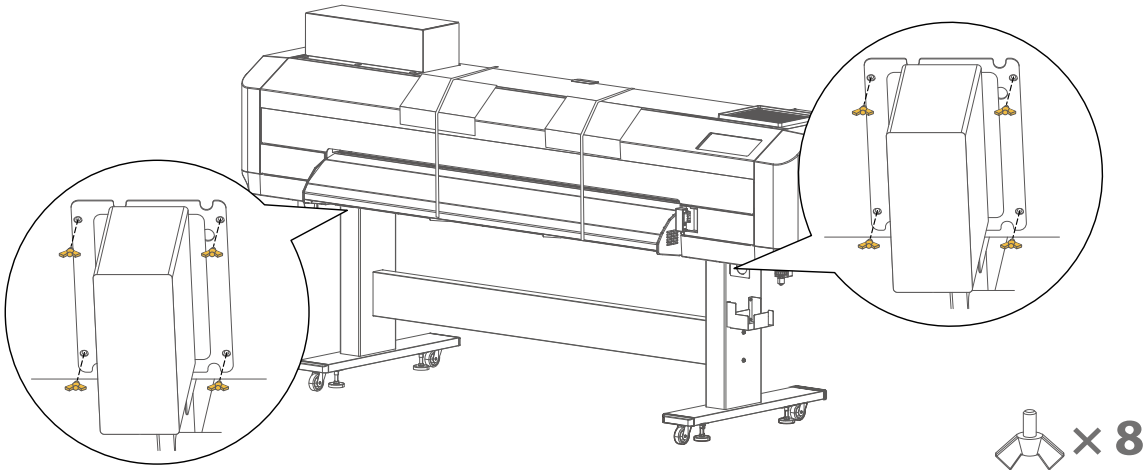


(If you do not have lifting bars) Lift the printer with at least six people and mount it on the stand.

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

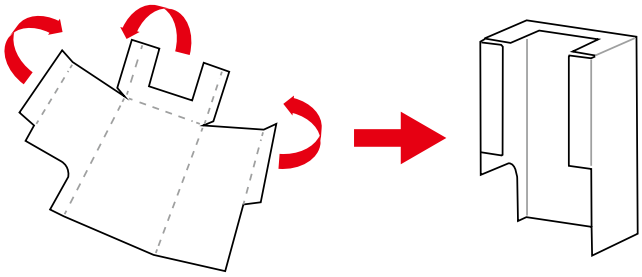


2 Use the wing bolts (x8) to fix the stand to the printer.



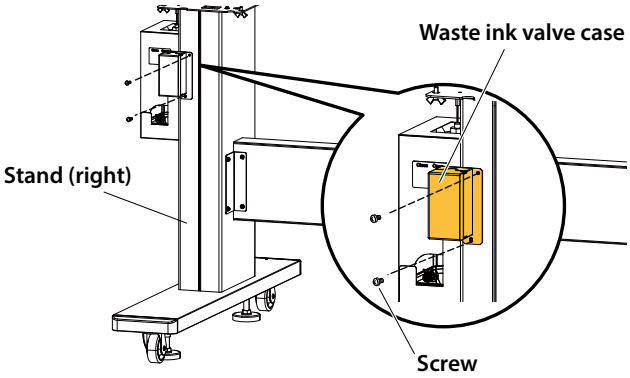
Attaching the waste ink tank

1 Assemble the waste ink tank cover.



2 Attach the waste ink valve case to the stand.

- Use the supplied screws (x2) to fix the plate of the waste ink valve case to the stand.



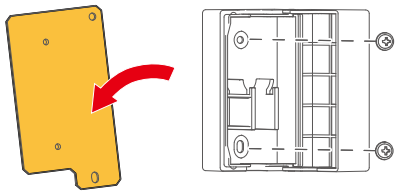
When using the optional heavy-duty take-up unit. (The illustration is different model)

- ① Remove the plate from the waste ink valve case.
- ② Use the supplied screws (x2) to secure the waste ink valve case to the position shown in the illustration.

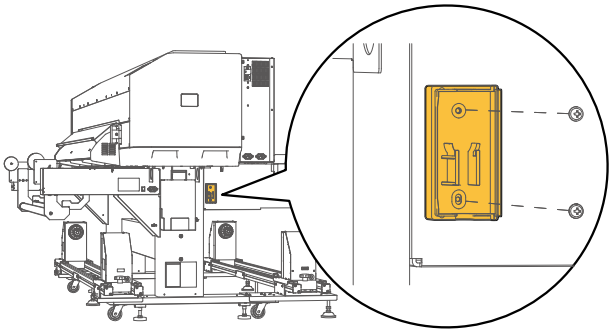
Note

Keep the plate and the screws removed from the waste ink valve case for next use.

①



②



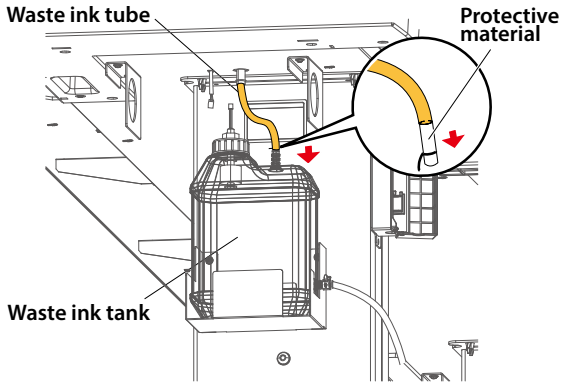
3 Place the waste ink tank on the waste ink tank holder.

4 **Insert the waste ink tube into the waste ink tank.**

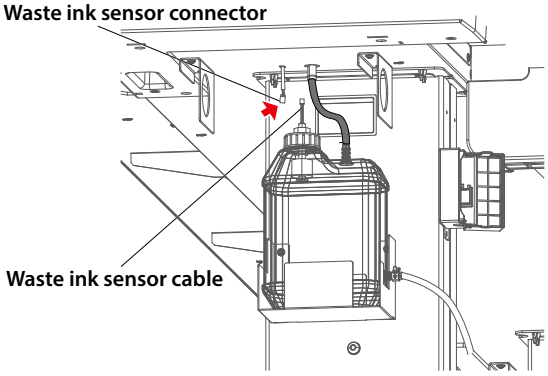
- Pull to remove the protective material and insert the tube into the mouth of the waste ink tank.

Important!

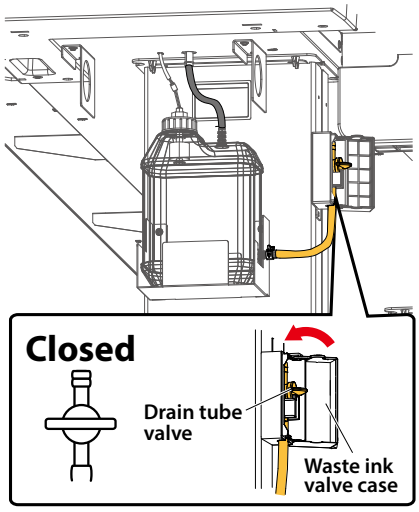
Check that the tube is firmly inserted in the mouth of the tank. Failure to do so could cause ink leakage.



5 **Connect the waste ink sensor cable to the waste ink sensor connector.**

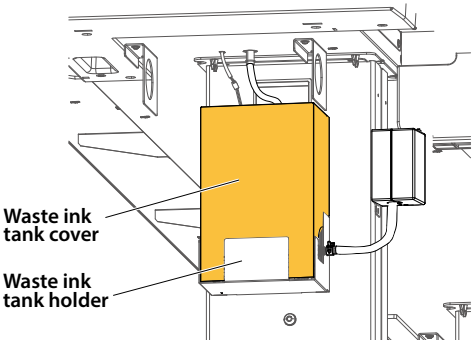


6 **Check that the drain tube valve is in closed position, store it in the waste ink valve case and close the case cover.**



7 **Attach the waste ink tank cover to the waste ink tank.**

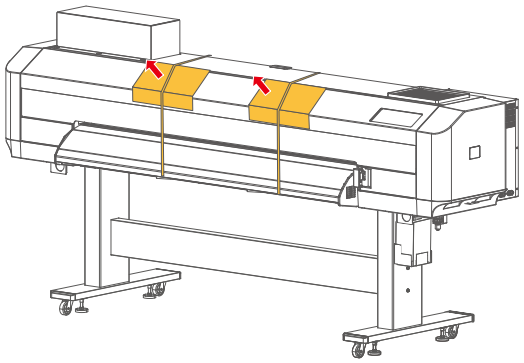
- Insert the waste ink tank cover inside the waste ink tank holder.



Removing protective materials

Follow these steps to remove protective materials from the printer.

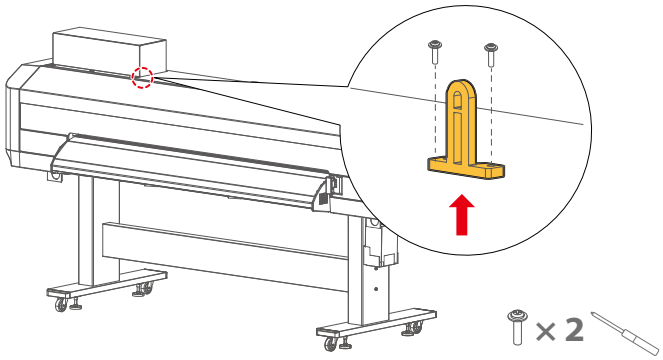
1 Remove the protective materials from the front cover.



2 Remove the two screws and remove the front cover lock from the front cover.

Important!

Make sure to remove the front cover lock before opening the front cover. Failure to do so could cause damage to the cover.

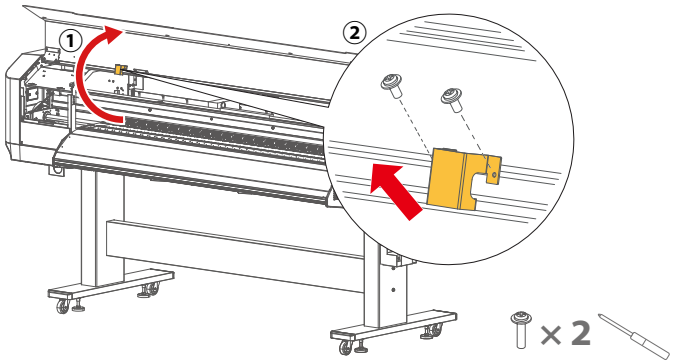


3

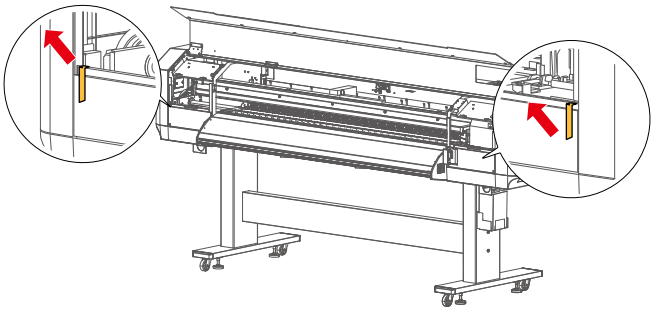
- Open the front cover (①).
- Remove two screws and remove the shipping bracket from the front cover (②).

Important!

Keep these removed screws, front cover lock and shipping brackets for reuse. You will need them when moving or transporting the printer.

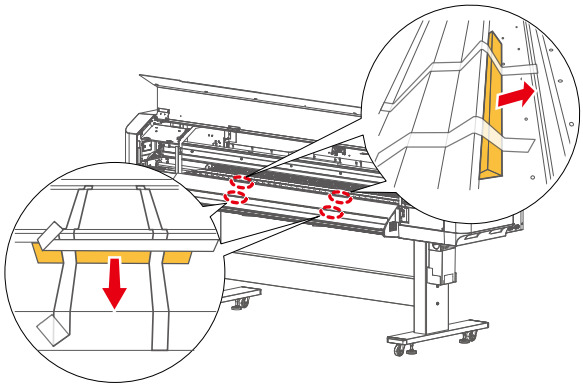


4 Remove the tape from the maintenance cover.

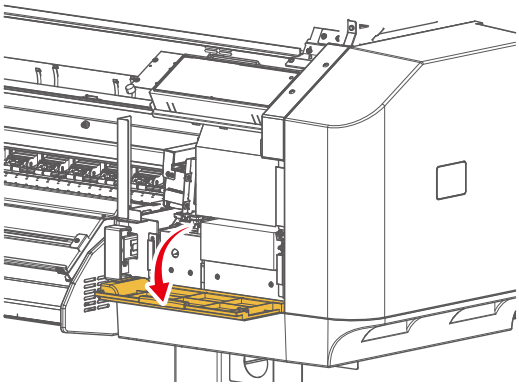


5 Remove the protective materials under the UV-LED light protective cover.

1. Remove the tape and pull out the protective material.
2. Four protective materials are attached; two on the upper side of the cover, two on the lower side of the cover.



6 Open the right maintenance cover.

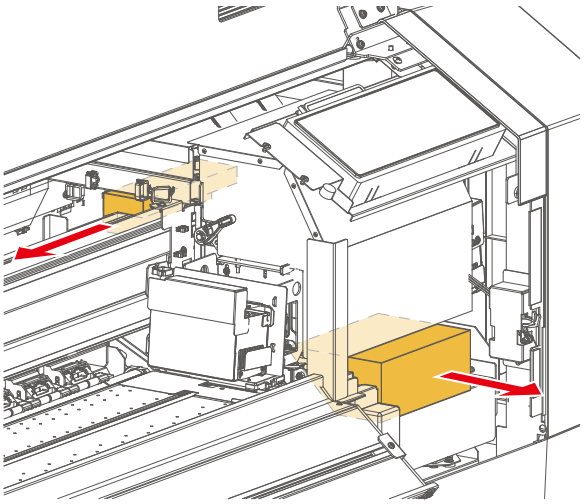


7 Remove the protective materials around the carriage.

- There are two protective materials to remove; one under the carriage and one at the back side of the carriage.

Important!

- **Keep these removed protective materials for reuse. You will need them when moving or transporting the printer.**
- **When moving the printer, install the protective material on the underside of the carriage.**

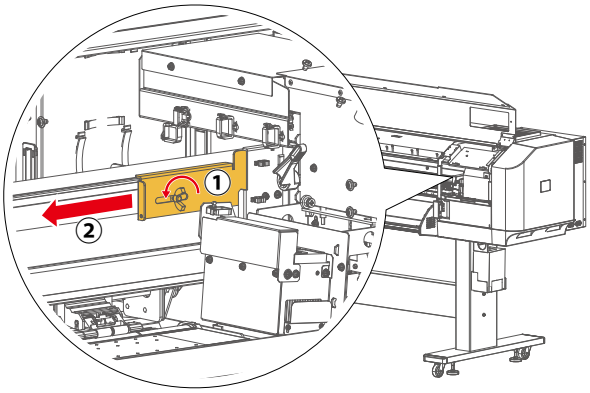


8 Remove the shipping bracket.

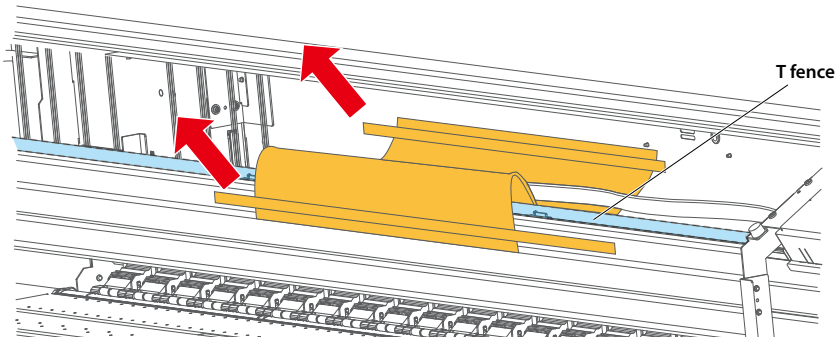
- Loosen the wing bolt (①).
- Remove the shipping bracket (the part that the red vinyl tie is attached) together with the wing bolt from the carriage (②).

Important!

Keep the removed shipping bracket and the wing bolts for reuse. You will need it when moving or transporting the printer.



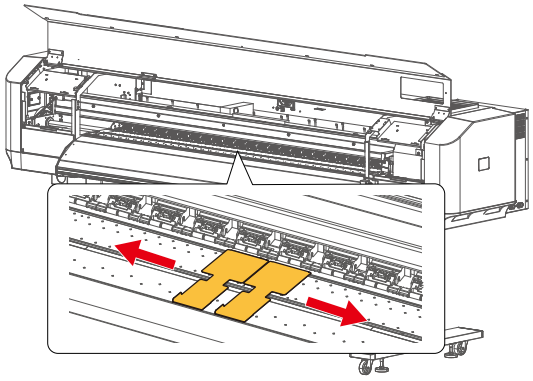
9 Remove the tapes to remove the protective materials attached inside the front cover.



Important !

Do not touch the T fence (clear parts) when removing the protective material. Deformation of T fence will affect print quality.

10 Remove the tapes and move the edge holders to the left and right end of the printer.



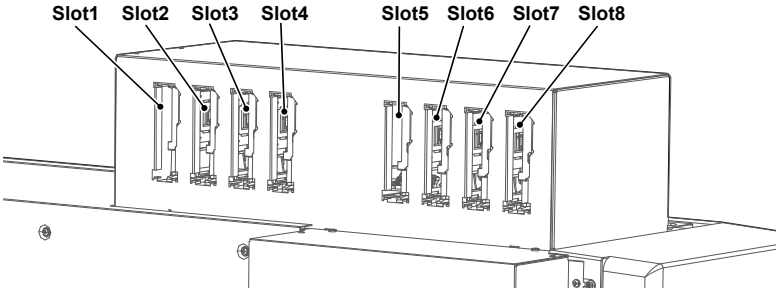
11 Remove all the tapes attached to the printer.

Applying the ink color labels

Depending on the ink color configuration on your printer, stick an ink color label supplied with the printer to the area above the ink slot.

When looking from the rear of the printer, the slot number and the ink color assignment are shown below.

	Slot1	Slot2	Slot3	Slot4	Slot5	Slot6	Slot7	Slot8
6 colors	K	M	C	Y	Va	Va	Wh	Wh
4 colors	M	M	C	C	K	K	Y	Y

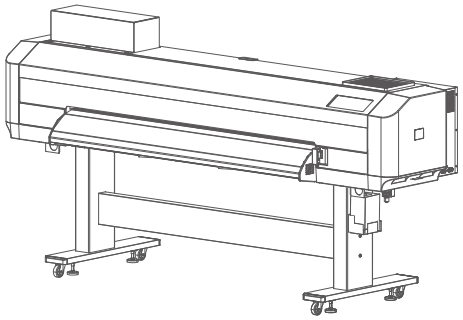


Connecting the cables

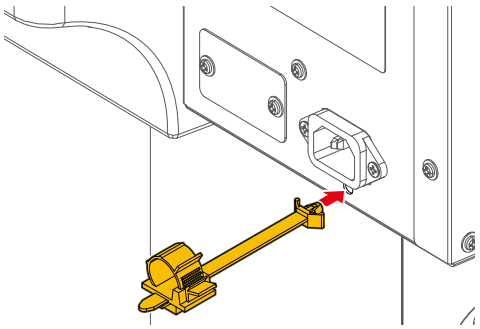
Connecting power cord and Ethernet cable

Follow these steps to connect a power cord and an Ethernet cable.

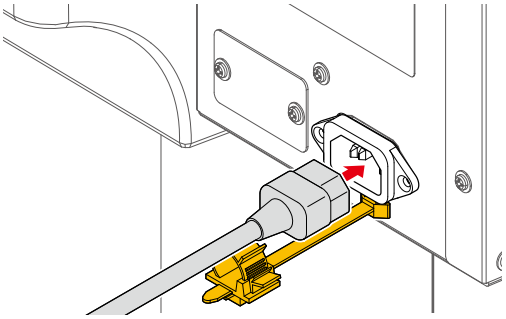
1 Check that the front cover is closed.



2 Attach the cord clamp to the printer.

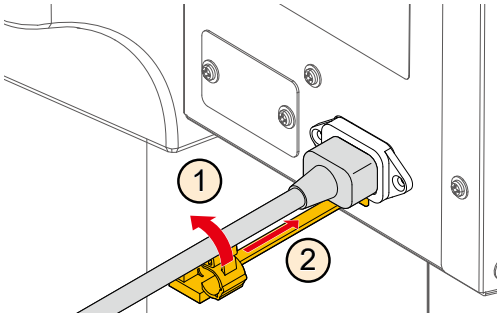


3 Connect the power cord to the printer inlet.



4 Secure the power cord to the cord clamp.

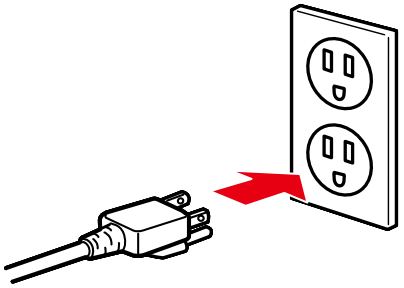
1. Pass the power cord through the clamp and clamp until it clicks into place.
2. Slide the clamp toward the inlet.



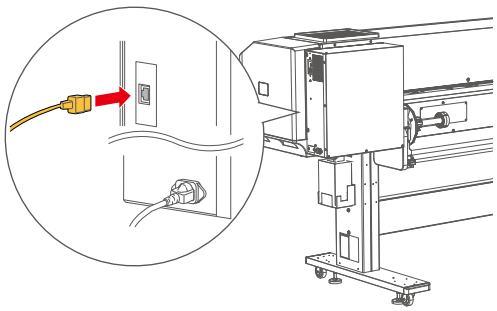
5 Plug the power cord into a wall outlet.

Warning

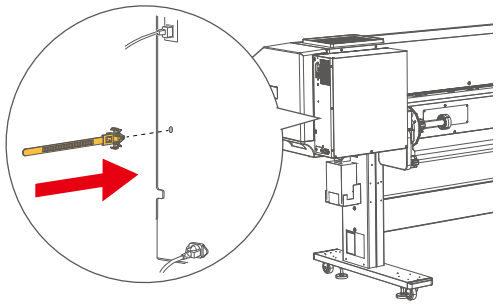
Do not use power strips.



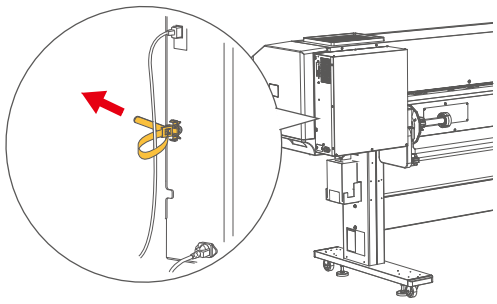
6 Connect the Ethernet cable to the printer.



7 Attach the cable tie to the printer.



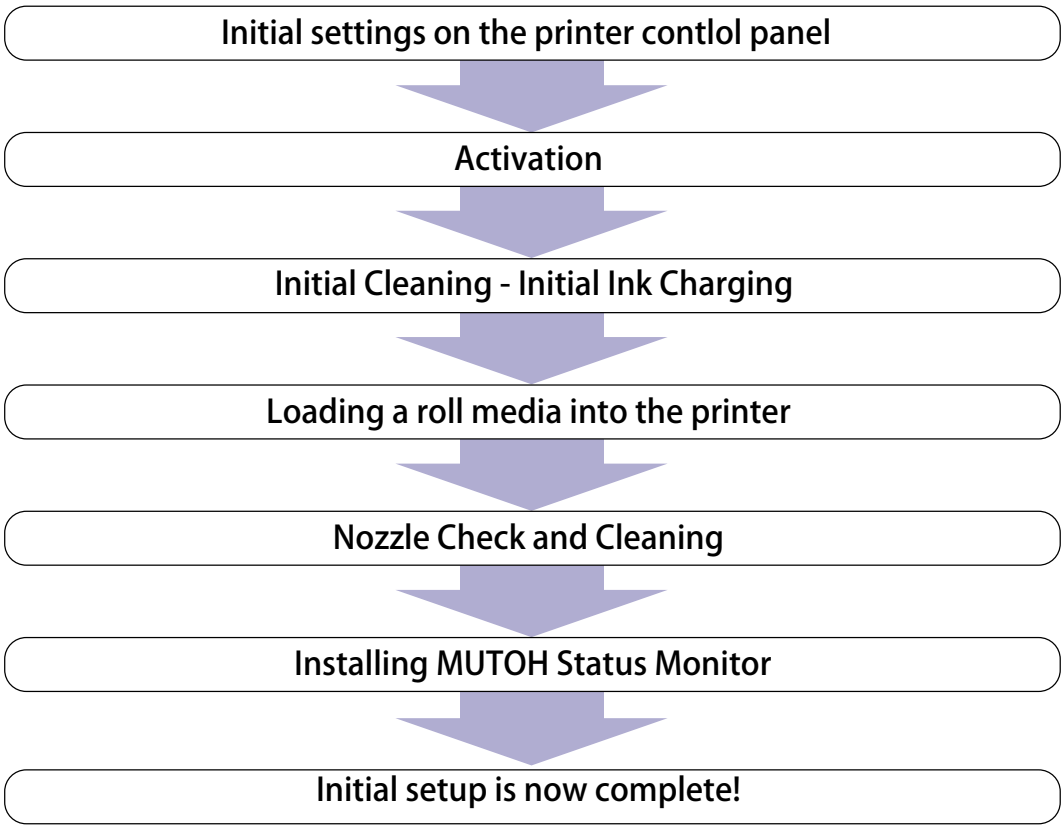
8 Secure the Ethernet cable and the Take-up unit cable to the printer with a cable tie.



Setup

Initial Setup Flow

Follow this flow to complete the initial setup of your printer.



How to operate printer control 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.**

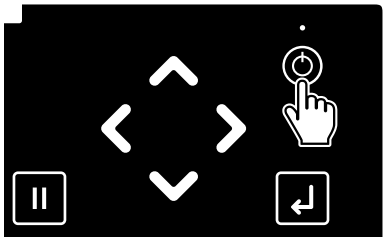
Initial settings on the printer contlol panel

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

1 **Check that the front cover is closed.**

2 **Long press the Power button on the control panel**

- Each key lights up.



3 **Select the language of your printer.**

- Use ▲ / ▼ key to select the language and tap ↵ Enter key.

4 **Select the unit of length.**

- Use ▲ / ▼ key to select the unit of length and tap ↵ Enter key.

5 **Select whether to display the ink level indicator.**

- [Remain Ink：Off] appears.
- Use ▲ / ▼ key to select between [On] and [Off] and tap ↵ Enter key.

6 **Assign an IP address of your printer.**

- ▲ / ▼ key : increase or decrease numbers.
- ◀ key : move the cursor to the previous digit number.
- ▶ key : move the cursor to the next digit number.

Once entered, tap ↵ Enter key.

7 **Assign a subnet mask of your printer.**

- ▲ / ▼ key : increase or decrease numbers.
- ◀ key : move the cursor to the previous digit number.
- ▶ key : move the cursor to the next digit number.

Enter all the digits. Once entered, tap ↵ Enter key.

8 Assign a gateway of your printer.

- ▲ / ▼ key : increase or decrease numbers.
- ◀ key : move the cursor to the previous digit number.
- ▶ key : move the cursor to the next digit number.

Enter all the digits. Once entered, tap ↵ Enter key.

9 Select whether to enable beep sound for errors.

- [AlertBuzzer：On] appears.
- Use ▲ / ▼ key to select between [On] and [Off] and tap ↵ Enter key.

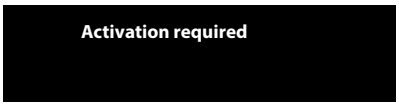
10 The message [Initializing] appears.
Printer initialization begins.

Activation

Follow these steps below to perform activation.

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

☞"Activation from the printer control panel" P.35
☞"Activation through Internet" P.36



Note

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

Activation from the printer control panel

1 When the message [Activation required] appears, tap ↵ Enter key.

- [0000-0000-0000-0000] appears.

2 Enter the 16-digit activation code.

- ▲ / ▼ key : increase or decrease numbers.
- ◀ key : move the cursor to the previous digit number.
- ▶ key : move the cursor to the next digit number.

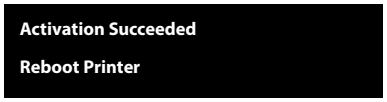
Once entered, tap ↵ Enter key .

Note

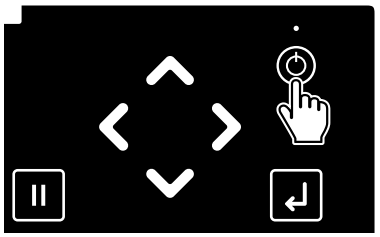
To obtain the activation code, please contact your local MUTOH dealer to send it by email.

3 When the message on the right appears, long press the Power button for more than two seconds to power off the printer.

- When the message [Power Off]appears on the panel, release the Power button.

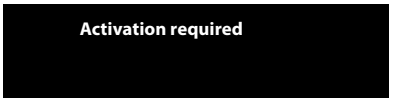


Wait for a few seconds and long press the Power button for more than two seconds to reboot the printer.



Activation through Internet

When the message on the right appears, 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/

Initial Cleaning - Initial Ink Charging

Items Required:

- **Cleaning cartridge : x 8**
- **Ink cartridge (or ink bag): x 8**

4-color configuration	6-color configuration
Black (K) : 2 Cyan (C) : 2 Magenta (M) : 2 Yellow (Y) : 2	Black (K) : 1 Cyan (C) : 1 Magenta (M) : 1 Yellow (Y) : 1 Varnish (Va) : 2 White(Wh) : 2

Important !

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

Note

- **To use ink bags, the high-capacity ink pack adapters are required.**
- **For handling the high-capacity ink pack adapters, see the operation manual of high-capacity ink pack adapter.**

1. Performing initial cleaning

1 Perform an initial cleaning.
When the message [Ink Charge Start -> Enter] appears, tap Enter key.

- [Color: 4Color] appears.

Note

While the above message is displayed, you can redo the initial settings (e.g. IP Address etc.) by tapping Home key.

2 Select the ink configuration of the printer you want to use.

Use / key to select from [4 color] or [6 color] and tap Enter key.

- [*Color OK ? No] will appear.

Note

The ink configuration selection menu appears at the first startup only.

3 To save the ink configuration, use / key to select [Yes], and then tap Enter key.

- To redo this setting,[No] and tap Enter key.

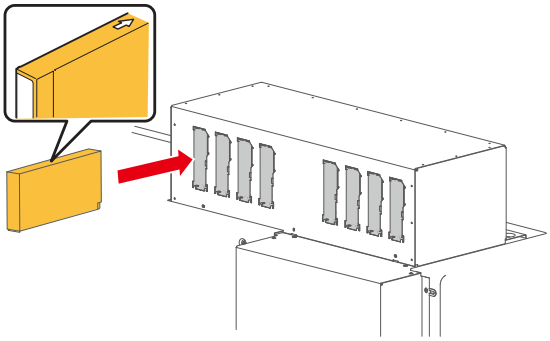
4 **The message [Empty Waste Ink Tank then Tap Enter] appears.**

- Tap ↵ Enter key.

5 **[Insert Cleaning Cart.] appears.**

6 **Insert cleaning cartridges into all the ink slots.**

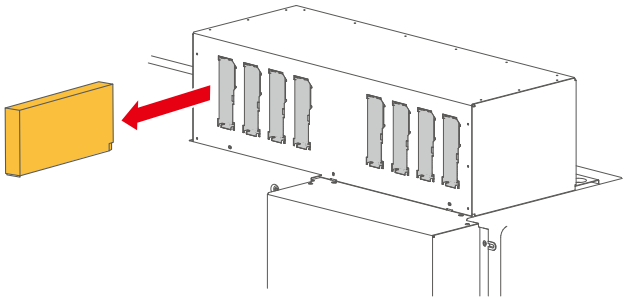
- Insert the cartridge with the arrow mark facing up.
- Insert it all the way in.
- Once inserted, [Washing Head] appears. The printer begins filling the ink lines with cleaner.



7 **Once the cleaner filling has finished, the message [Remove Cartridges] appears.**

8 **Remove the cleaning cartridges from all the ink slots.**

- When the message [Washing Head **%] appears, it begins flushing cleaner out of the printer.



9 **Once the cleaner has flushed, this message will appear.**

- Empty the waste ink tank.

☞"2. Emptying waste ink tank" P.39

```
Empty Waste Ink Tank
then Tap Enter
```

2. Emptying waste ink tank

Warning

- **Store waste fluids in a cool, dark place and avoid direct sunlight.**
- **Keep away from fire and heat.**
- **Do not mix waste ink with any other chemical substances, not even in small amounts.**

- **Use a HDPE container with light blocking properties to store waste fluid.**
- **When storing waste fluid for a long time, slightly loosen the cap on the container to allow air. Do not tightly close it.**

Caution

Skin or eye contact with UV curable ink may cause skin inflammation or allergic reaction. For this operation, be sure to wear the supplied gloves (or solvent resistant gloves) and goggles to prevent ink from contacting with your eyes or skin.

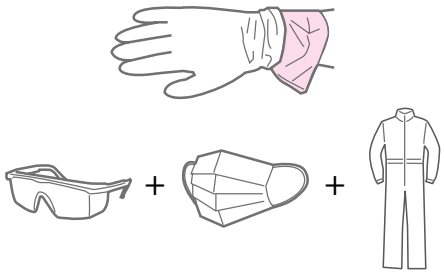
1 Prepare a container to collect waste fluid.

Important!

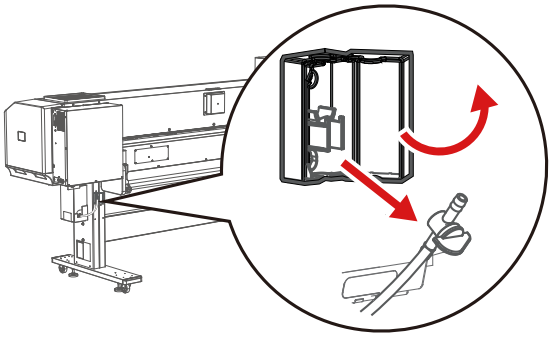
The capacity of waste ink tank is 2,000 ml. Make sure to prepare a container with at least 2,000 ml capacity.

2 Cover the floor under the waste ink tank using waste paper.

3
- Wear the rubber gloves over the polyethylene gloves.
- Wear protective equipment such as goggle, protective mask, protective clothing.



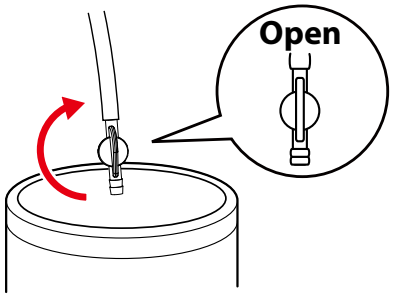
4 Open the cover of the waste ink valve case, and then take the drain tube valve out from the case.



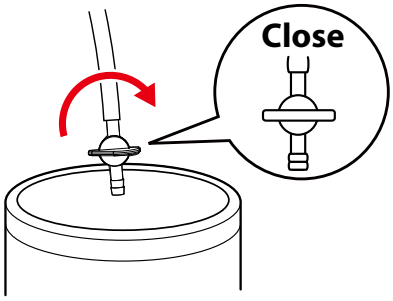
5 Put the tip of the drain tube valve in the empty container and open the valve to drain waste fluid from the waste ink tank.

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.

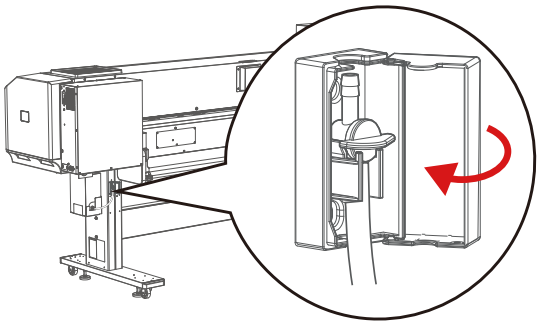


6 Once you finish emptying the tank, close the drain tube valve firmly.



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

8 Hook the drain tube valve on the clamp of the waste ink valve case, then close the cover.



9 Dispose of the waste fluid as industrial waste.

Warning

- **Waste ink collected from this product is classified as 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.**
- **Waste fluid from this printer is harmful to aquatic organisms. Do not allow it to reach sewage or natural water systems.**

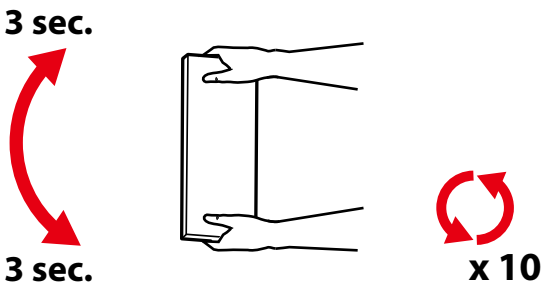
10 Once finished, tap ↵ Enter key.

3. Performing initial ink charging

1 [Insert Ink Cartridges] appears.

2 Prepare a new ink cartridge and follow these steps to agitate ink in the cartridge.

- Hold the ink with the ink outlet facing up and wait for three seconds.
- Invert it with the ink outlet facing down and wait for three seconds.
- Repeat this ten times (white ink : twenty times)



Important !

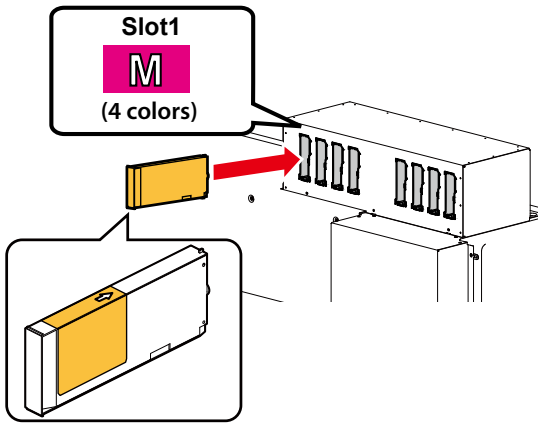
Make sure to use new ink cartridges.

Note

There is no need to agitate varnish ink.

3 Insert the new ink cartridge into the ink slot.

- Make sure to match the color of the ink cartridge with the color of the label attached to each ink slot. (This illustration is an example of 4-color configuration)
- Hold the cartridge with the arrow mark facing up.
- Insert it all the way in.



4 [Ink Refill **%] will appear.

- Ink charging begins.

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.**

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

- The ink charging is complete.

Test printing

Loading a roll media into the printer

Caution

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

Follow these steps to load a media into the printer.

1. Attaching flanges to the media

Items Required:

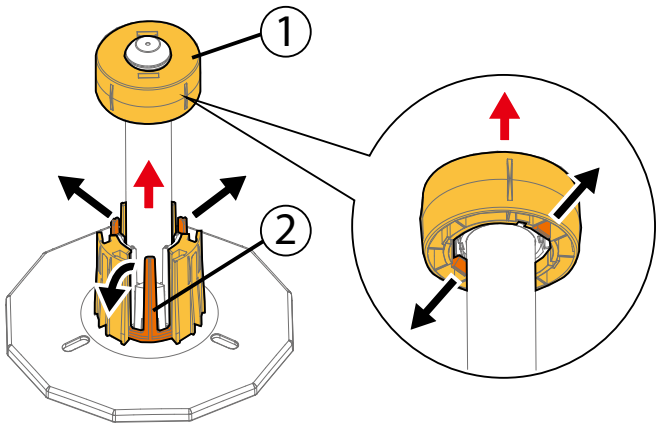
- **Roll media**
- **Media flange: ×2**

1 Replace the flange adapter depending on the size of paper core of roll media.

■ 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.



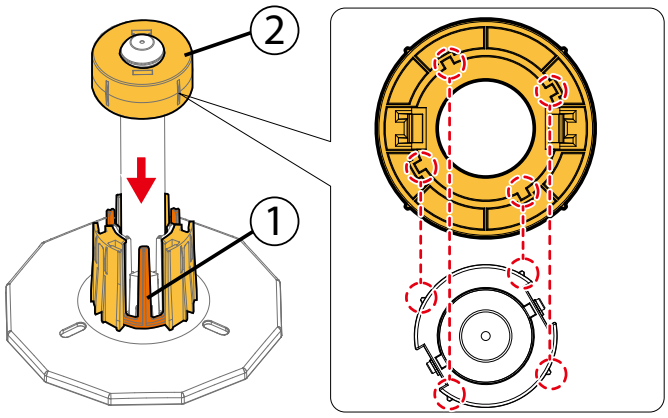
Note

- **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 right to attach it to the edge of the media flange.

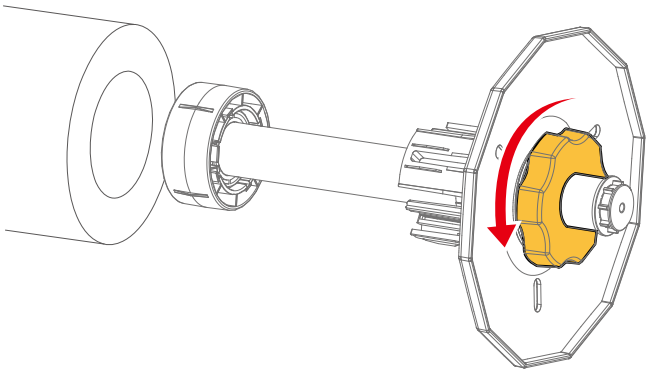


Note

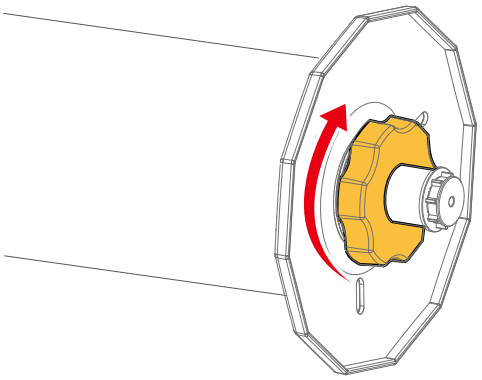
If ② adapter is misaligned, it will not be properly fixed to the media flange.

2 Push the media flange (x 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.



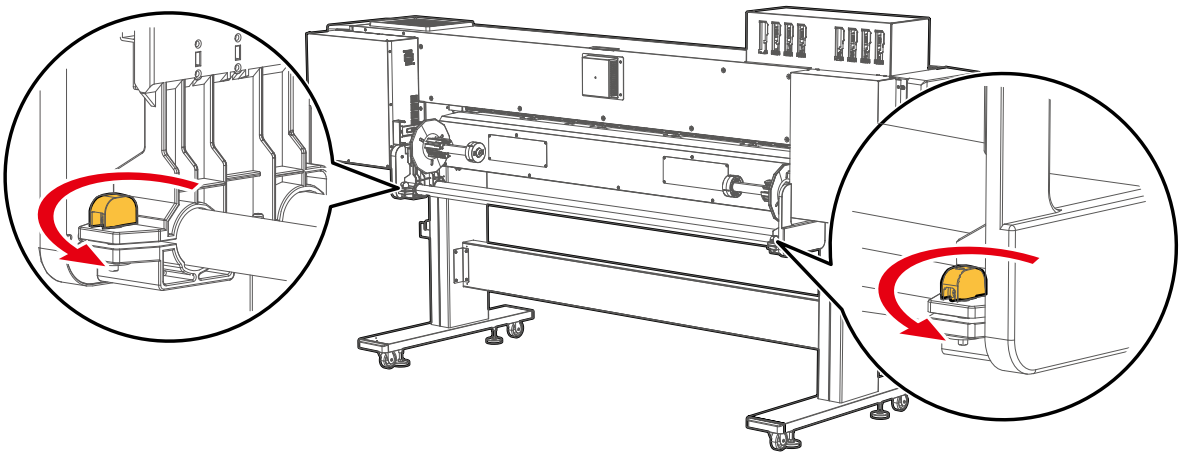
Important !

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

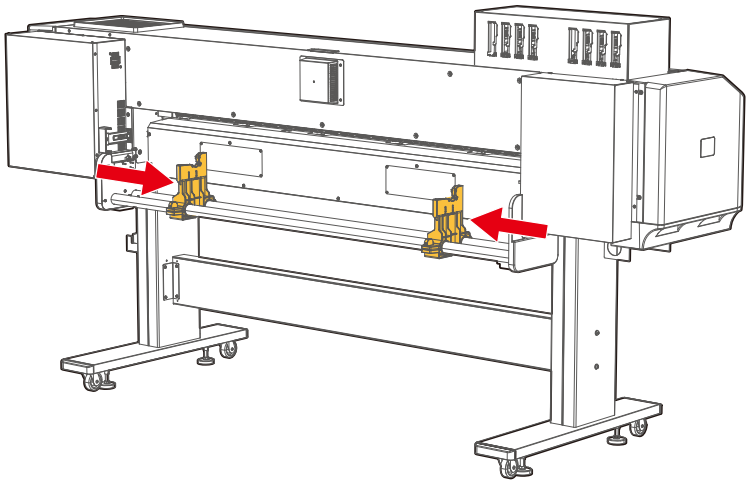
2. Enabling torque on media holders

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

1 Twist the knob bolt on the left and right media holders anticlockwise to loosen.

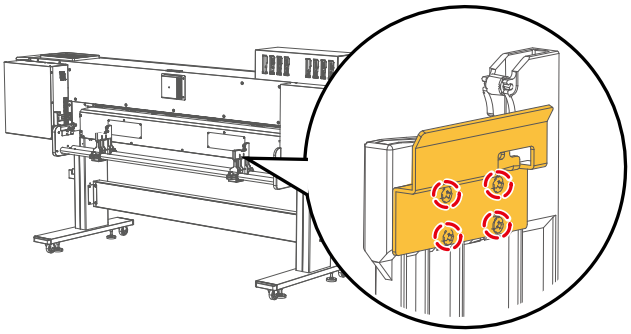


2 Slide both left and right media holders about 30 cm towards the center of the slider for easy access.

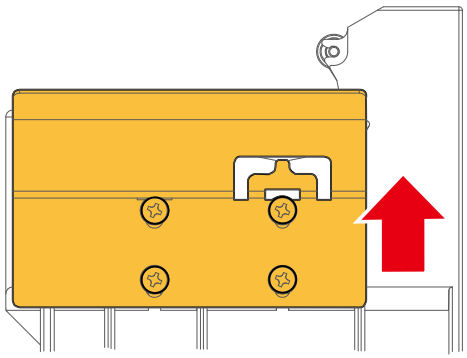


3 Tighten the knob bolts on both media holders.

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

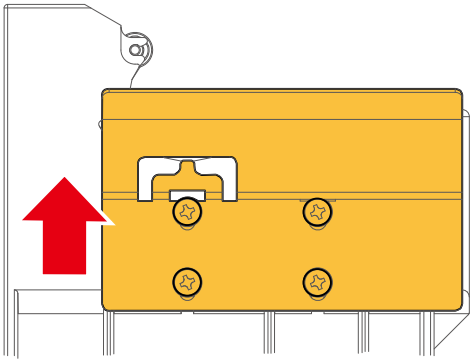


5 Slide up the roller shaft guide plate as far as it will go and tighten the screws.



Roller shaft guide plate (right)

6 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.



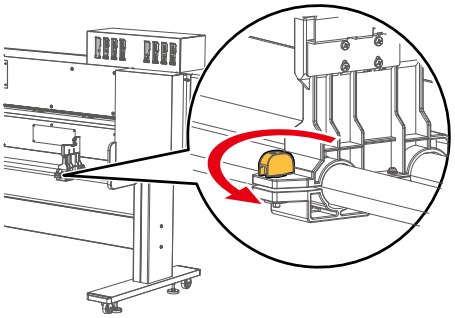
Roller shaft guide plate (left)

7 Loosen the knob bolts and slide back both media holders to the original position.

8 Tighten the knob bolts on both media holders.

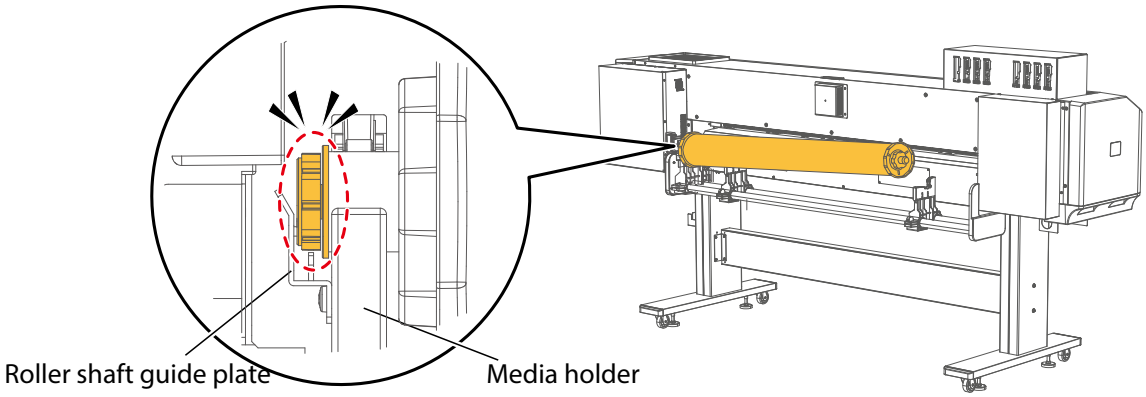
3. Placing the media onto the media holder

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



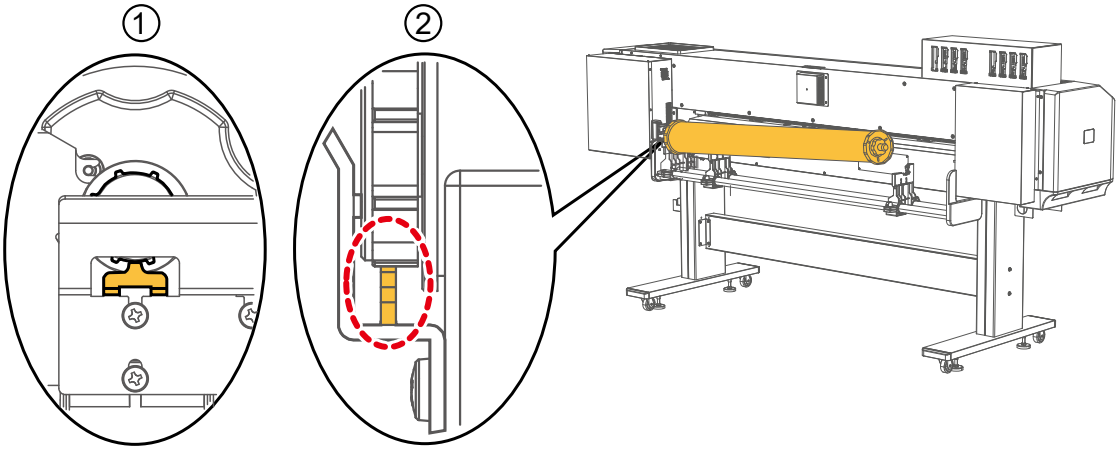
2 **Place the roll media onto the left media holder. Carefully and gently place it on the holder.**

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



If you have enabled torque, 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.

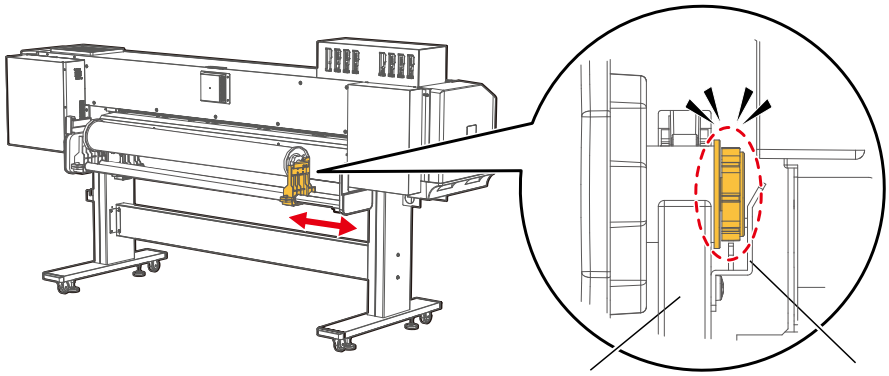


Important !

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

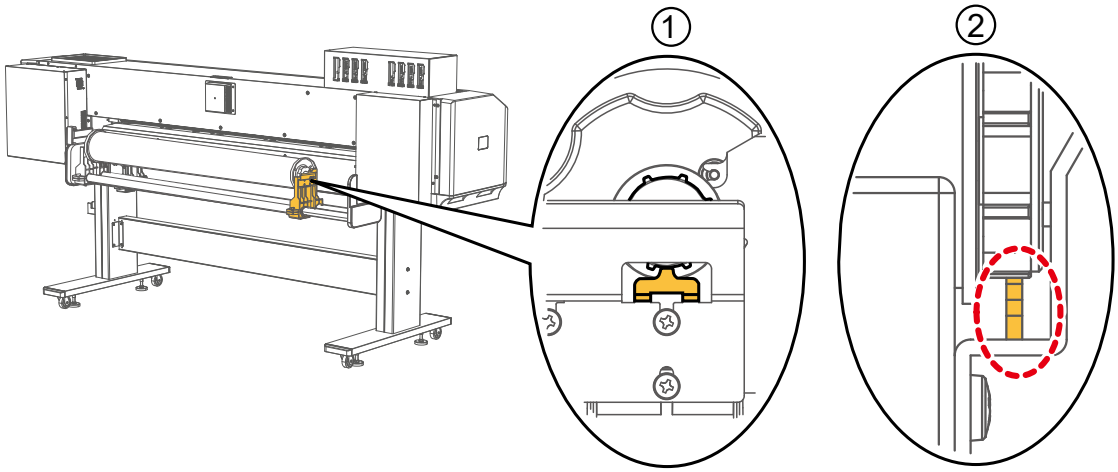
3 **Place the roll media onto the right media holder. Carefully and gently place it on the holder.**

- 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.

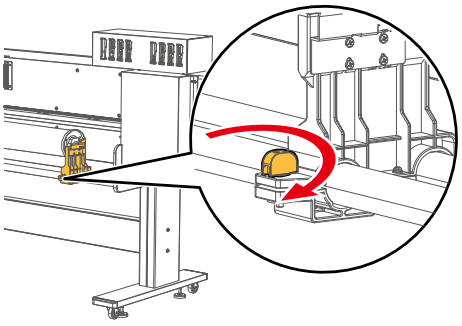


If you have enabled torque, check the following.

- 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.



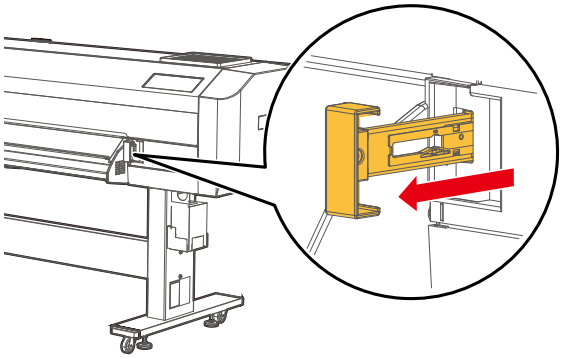
4 **Twist the knob bolt on the right the media holder clockwise to tighten.**



4. Loading the media into the printer

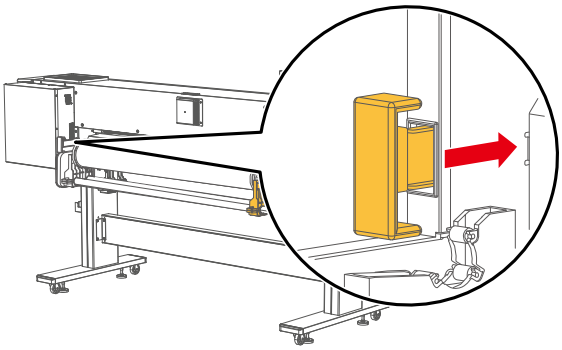
1 Check that the printer is powered on.

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

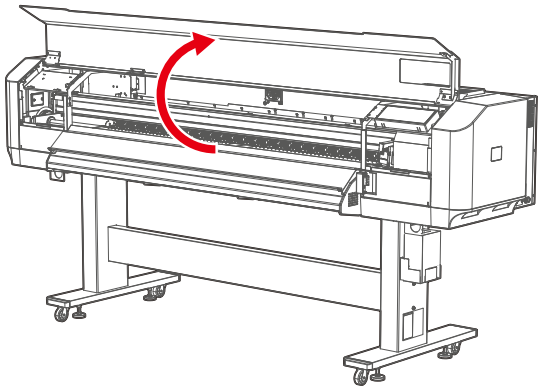


You can access to the media feed lever from the rear side of the printer.

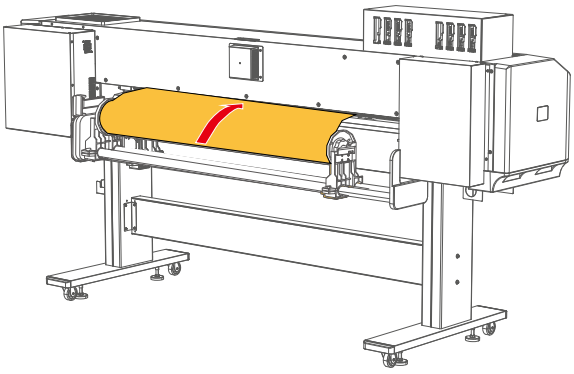
- To release the pressure rollers, push the lever as far as it goes.



3 Open the front cover.

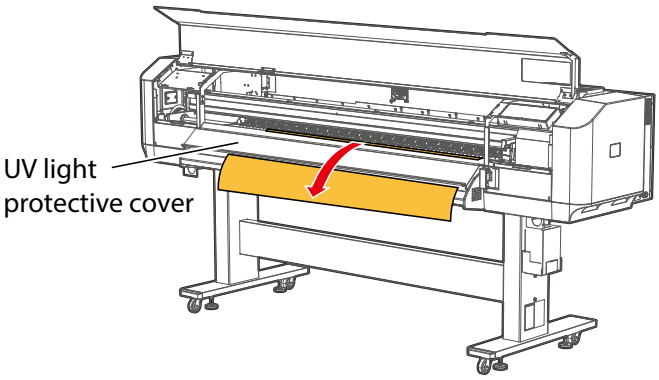


4 From the rear side of the printer, insert the leading edge of the media into the media slot.

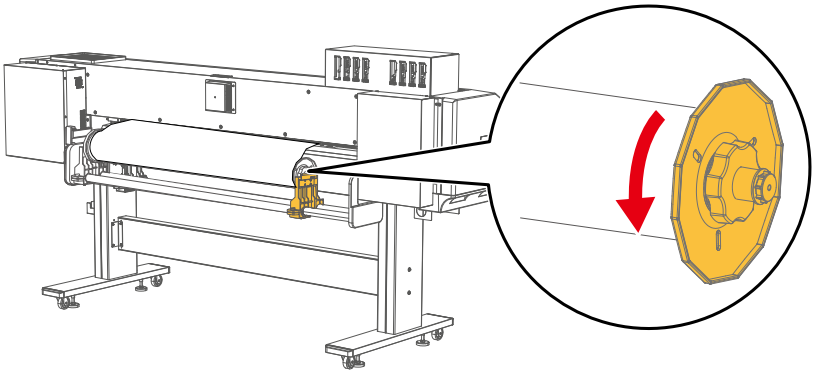


5 From the front side of the printer, pull the media for approximately 1 m.

- Pass the media between the UV light protective cover and the media guide and pull it.



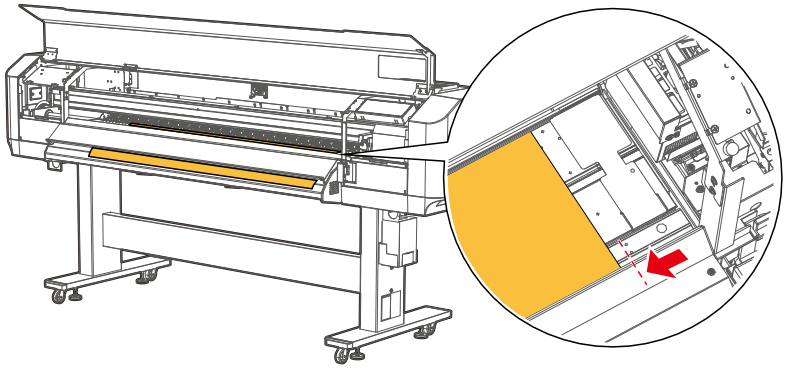
6 While one person holds the leading edge of the media, the other person turns the flange to slightly rewind the media onto the roll to remove warp or skew.



Note

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

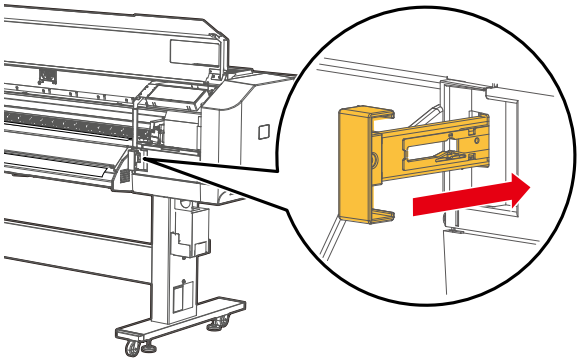
7 Check that the right-hand edge of the media is located at the left side of the media guide line.
If not, print quality can be affected.



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"**

5. After loading the media...

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



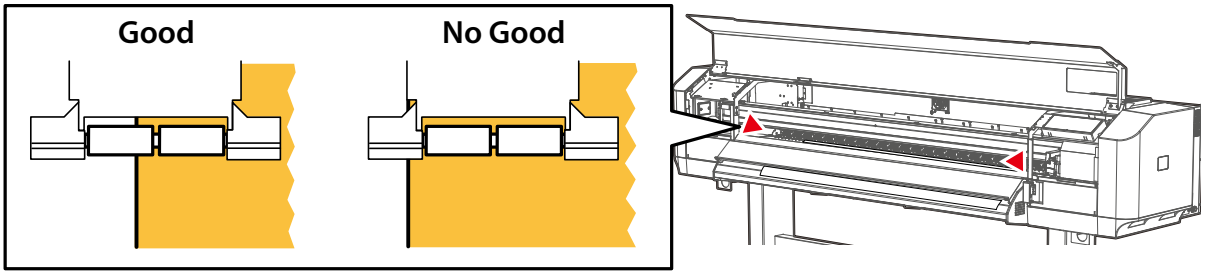
Note

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"

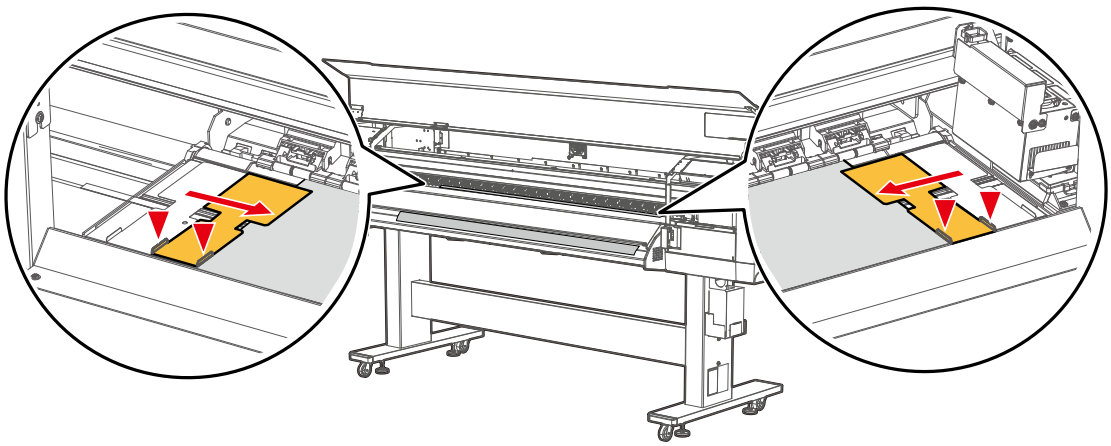
2 Check that both edges of the media are held down properly by the pressure rollers.

- If it is held like "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 "3. Placing the media onto the media holder" P.47).

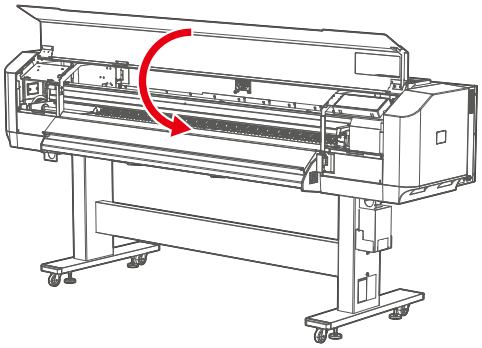


3 Place the edge holders on both edges of the media.

- Lift up the tabs 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.



4 Close the front cover.



5 "User: Type** OK?" appears on the printer control panel.

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

Nozzle Check and Cleaning

Run a nozzle check print. If nozzles are clogged, perform cleaning.

This printer offers the following nozzle check menus:

- **Nozzle Check: Print a nozzle check pattern using the print head and nozzles selected from "Head Select" and "Select Nozzle" menus.**
- **Nozzle Check F: Print a nozzle check pattern using all of nozzles.**
- **Nozzle Check B: Some colors of nozzle check patterns are printed with the background colors.**

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

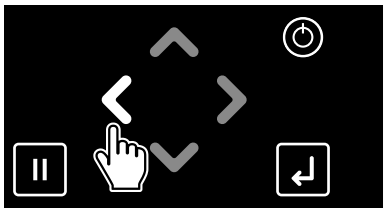
Running a nozzle check F print

1 Load a roll media to print nozzle check pattern.

☞ **"Loading a roll media into the printer" P.43**

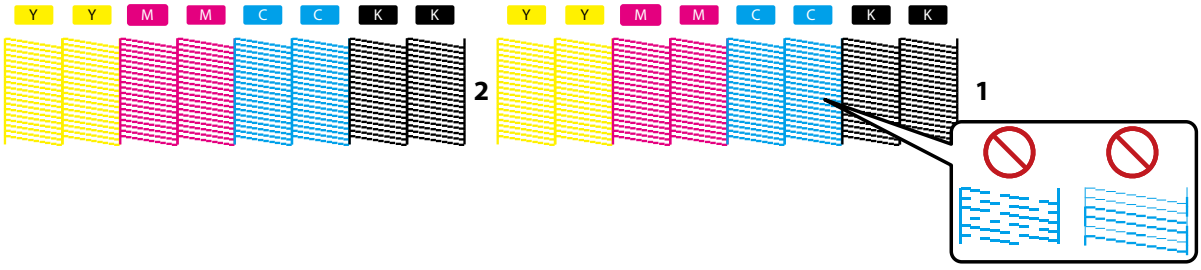
2 Tap ◀ key.

- When [Start Printing?/ Nozzle Check] appears, use ▲ / ▼ key to select [Nozzle Check F].
- Tap ↵ key so that the printer begins printing a nozzle check F pattern.



3 Check the nozzle check print to see all nozzles are clear.

- If you find missing or thin lines on the print, go to **"Performing cleaning" P.54**
- If all lines are clearly printed, you can start printing.



Note

- **The above pattern is an example of 4-color configuration.**
- **Printer information (date and time printed, serial number, firmware version) is printed next to the pattern.**

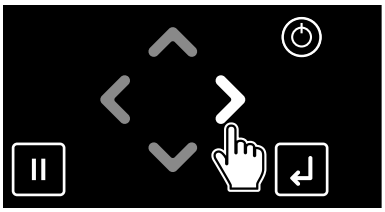
Important!

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" cleaning.
If it does not help to solve the problem, leave the printer for one hour or more, then perform cleaning or "Little Charge" cleaning again.
If the problem still persists, contact your local MUTOH dealer.

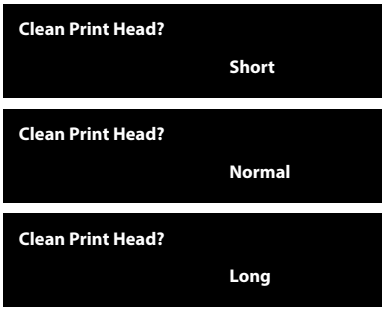
Performing cleaning

1 Tap ❯ key.



2 Use ^ or v to choose the cleaning mode, then tap ↵ Enter key.

- The cleaning cycle begins.



3 Run a nozzle check print again.
☞ "Running a nozzle check F print" P.53

- If nozzle clogging persists, repeat normal cleaning until all nozzles are clear.
- To perform "Short", "Long", "Little Charge", or "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.**
  ☞ **"Initial settings on the printer contlol panel" P.34**
- **If "Long" or "Little Charge" cleaning does not help to recover the nozzles, go to "Advaiced Settings : Select Nozzle" to select the nozzles that fire properly.**
  ☞ **Operation manual "Select Nozzle"**

Important!

You must perform media feed adjustment before printing an image.
☞**Operation manual "Media feed adjustment"**

Installing MUTOH Status Monitor

Before printing, MUTOH Status Monitor (MSM) must be installed on your computer.

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"**

The following software and operation manuals are available for download from MUTOH Club.

MUTOH Status Monitor (MSM)	Allows you to view printer status, change printer's settings and run a test printing.
VerteLith	MUTOH genuine RIP software that gets optimal performance out of MUTOH printer and improves the work efficiency (a license must be purchased).
Manuals (for printer and software)	The following operation manuals are available in PDF format. • XPJ-1682UR Operation Manual "Operation and Maintenance" • XPJ-1682UR Startup Guide (this document) • MUTOH Status Monitor Operation manual • VerteLith User Manual

Important!

Make sure to install MSM downloaded from MUTOH Club.

Installing procedure

1. Follow the instructions on the "Request for User Registration & Download" sheet supplied with this product to complete user registration and download.

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

Sleep Mode

When you are not using the printer, always leave the power on and put the printer into the sleep mode. Failure to do so may result in ink settling, causing print defects or printer failure.

Before putting the printer into sleep mode, follow the instructions on the printer control panel to perform a daily maintenance.

While in sleep mode, the printer performs following maintenance automatically.

- **scheduled automatic head cleaning**
- **ink circulation**
- **"Little Charge" cleaning**

Important !

If you are going to put the printer in sleep mode for more than 7 days, perform followings once a week:

- **Check the ink level in the ink cartridges (ink bags). When the message [Ink Low] appears on the control panel, replace with a new one.**
  ☞Operation Manual "Checking ink level and replacing ink"
- **Agitate the ink in the ink cartridges (ink bags).**
  ☞Operation Manual "Agitating ink"

1 Check that

- the front cover and the maintenance covers are closed.
- media is removed from the printer.
- ink cartridges (ink bags) have sufficient ink.
- the waste ink tank has enough space.

Important !

If you are going to leave the printer in sleep mode for a long period of time, empty the waste ink tank.
☞Operation Manual "Empty the waste ink tank"

2 Prepare the items required for daily maintenance.

☞ Included item " XPJ-1682UR Daily maintenance sheet " or
☞ Operation Manual " Daily maintenance atthe end of work "

3 Go to the "Sleep Mode" menu.

- Tap Home key ➡ [Menu1 Setup] appears.
- Use / key to scroll the menus and select [Menu8 Sleep Mode].
- Tap key twice ➡ [Sleep Mode Star t -> Enter] appears.

4 Tap Enter key.

- [Daily maintenance Start -> Enter] appears.

5 Tap Enter key.

- [Please Wait] will appear.
- The carriage will move to the maintenance position (left side of the printer).

6 When [Daily Maintenance Next -> Enter] appears, you can start a daily maintenance.

Important!

For maintenance procedure, see the following documents:
☞ Included item " XPJ-1682UR Daily maintenance sheet " or
☞ Operation Manual " Daily maintenance atthe end of work "

7 Finish the daily maintenance.

- Check that [Check UV Lamp R End -> Enter] appears on the control panel.
- Once all the maintenance has finished, tap Enter key.

8 [Please Wait] appears.

- [Cleaning **%] appears and the automatic "Short" cleaning begins.

9 [Sleep Mode End -> Enter] appears.

- The printer is put into sleep mode.

10 To wake up from sleep mode, tap Enter key.

Note

- **While in sleep mode, the LED above the Power button blinks every five seconds.**
- **For the types and the timer of cleaning to be performed during sleep mode, refer to the following section.**
  ☞Operation manual"Auto Cleaning".
- **When the printer wakes up from sleep mode, an appropriate automatic cleaning (automatic head cleaning or "Little Charge" cleaning) will be performed by the timer for automatic maintenance depending on the elapsed time.**

MUTOH