



Revel DTF-2402 Operating Manual



THINK BEYOND

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Please carefully read the following instructions before using DTF printer series, and please follow the warnings and instructions marked on the printer.

1.1 Important safety instructions

- Do not block the opening on printer enclosure.
- Do not insert any item into the slot of the printer, and pay attention not to splash liquid into the printer.
- The power supply type indicated on the printer label is allowed only. 110V or 220V AC power supply may be selected in different countries or regions.
- Be sure to connect all devices to a suitable grounded socket, so that the socket used will not be in the same circuit as a copier or air conditioning system that regularly switches between on and off.
- Be sure not to use the socket controlled by wall switches or auto-timers.
- Be sure to keep your computer system away from potential electromagnetic interference sources, such as loudspeakers or cordless phone stands.
- Do not use damaged or worn power cords.
- If an additional power cord is used, mind that the total amperage of the device into which the additional power cord is inserted shall not exceed the rated amperage of the power supply. In addition, mind that the total amperage of all devices inserted into the wall shall not exceed the rated amperage of the wall socket.
- Do not attempt to repair the printer by yourself.
- In any of the following cases, please cut off the power supply and ask an experienced professional for maintenance help:
 - When the power cord or plug is damaged;
 - When liquid is splashed into the printer;
 - When the printer falls or the enclosure is damaged;
 - When the printer is unable to run normally or has significant changes in performance.

1.2 Precautions when using the printer:

- Do not move the printer head by hand, This may damage the printer.

- Always turn off the printer by pressing the power switch. When pressing the power switch, the power supply will be cut off. Before cutting off the power supply, please do not unplug the printer or USB cable.
- Prior to moving the printer, please make sure that the printer head is in the initial position and secure it.

1.3 Precautions when using the cartridge:

- Keep the cartridges out of the reach of children.
- In case of contact with the skin, please wash with soap and water. In case of contact with eyes, please rinse with clean water immediately.
- Do not shake the cartridges, this may lead to ink leakage.
- After each cartridge has been used for a period of time (usually three months), remove it immediately for thorough cleaning and air drying. Note that the new cartridge shall be kept clean for high printing quality.

1.4 Printer installation requirements

- Site preparation
Users are liable for observing all installation requirements and implementing these requirements during operation.
If not, the printer may not run smoothly.
- Work area
Work area refers to the area close to the DTF printer (hereinafter referred to as the Device), as shown in the figure below. It should be pointed out that users shall guarantee the safety of operators within the area, and the printer dimensions are 1336mm*658mm*1400mm (L*W*H).

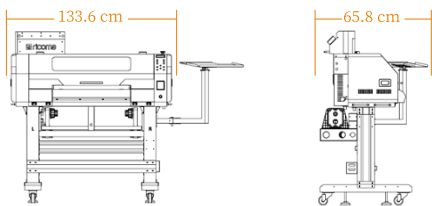


Figure 1: Schematic Diagram for Work Area Around DTF Printer (Unit: cm)

- Environmental requirements
The Device shall be kept away from jointing equipment (fabric feederliner) or other RF sources. The floor shall be easy to clean without dust or static electricity. In order to help the operator and user determine accurate colors, neutral grey decoration and pure white (daylight lamp) lighting shall be used as much as possible. The Device shall be installed in a clean, dust-free atmosphere with relative humidity controlled within the following range: altitude: below 1000m, temperature: 18-28°C; relative humidity: 40-60%.
- Space reserve requirements
Space shall be reserved by 2.0m in the front, 1.0m in the back, and 1.0m each on the left and on the right for the Device. In addition, the reserved space shall also include 3m above the ground. Moreover, space in the front and back of the Device shall also be reserved to facilitate the loading and unloading of consumables and finished images.
- Safety requirements
 - 1)、Fire prevention
Inks and solvents must be stored in a special storage cabinet for non-flammable liquids or a separate storeroom, and must be clearly identified to meet the requirements of professional safety regulations.
Inks shall be stored strictly in accordance with relevant local fire prevention regulations on the use and storage of combustible items. Carbon dioxide and powder fire extinguishers shall be placed in a visible, accessible place of all channels. They shall be placed near the Device and the storage cabinet (storeroom) of non-flammable liquids or in accordance with the local fire prevention regulations.
 - 2)、Ventilation
In order to prevent the accumulation of volatile gases from causing risks, there must be adequate ventilation to ensure that the air in the work area is changed about 6 to 8 times per hour, and the vents shall be low enough that volatile gases cannot accumulate near the floor. When fabric passes through the dryer, an

exhaust gas system is required to remove solvents evaporating from the inks. Note: Solvent gases will accumulate near the floor if the specific gravity is greater than the air.

The electrical equipment installed near the work area must meet the GB/T standard and the provisions of the national electrical regulations on Class I and Class II venues, and shall be installed by professional electrical contractors with corresponding qualifications. Also, the handling of hazardous wastes shall be in line with the special storage and handling requirements stipulated by relevant departments.

- Electrical requirements (UPS and power regulator are highly recommended) As a DTF printer uses a single-phase power supply, the printer must be well grounded. (The voltage of ground wire and zero wire shall not be greater than 0.3V, and the grounding resistance shall be lower than 3Ω.) The supply voltage shall be 220V(±10) AC 50Hz or 60Hz. In addition, users must have professional electrical engineers or contractors install the power output. The rated values of the circuit breaker are as follows:

Power supply\voltage	AC 220V	AC 110V
Single-phase	10A/phase	20A/phase

The maximum power consumption shall be lower than 2kW, and the average power consumption shall be 1kW. UPS may be 2KVA and can be connected to the power for purposes other than heating.

The distance of the main power socket from the power inlet of the Device shall not be greater than 2m.

- DTF printer power: About 1000W, so that regulated power supply is recommended. Installation of ground wire: Install the ground wire to the common ground plate within the Device, then dial the multimeter to the range of AC 200V, connect one meter hand to the ground wire and another hand to the zero wire of AC input. In addition, make sure that all the measured values are smaller than 1.

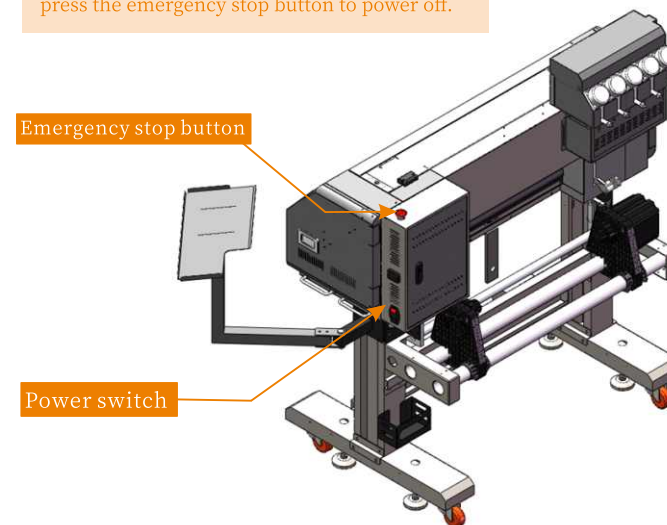
1.5 Important safety notice

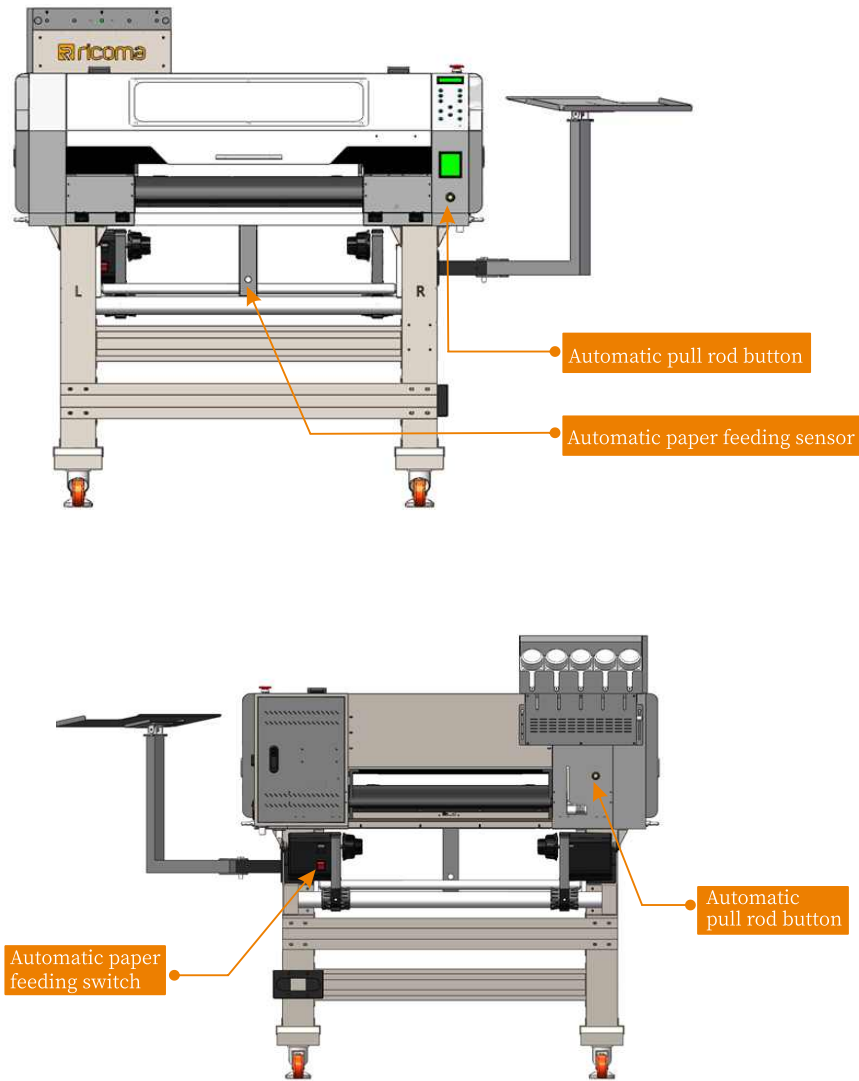
- **Warning:** These instructions must be strictly observed to avoid bodily harm.
- **Caution:** These instructions must be strictly observed to avoid equipment damage.
- **Notice:** This manual contains important information and useful tips for printer operation.

2.0 Introduction to machine function

- Automatic pull rod
Attention: Automatic lifting rods must be used as manual pulling rods will cause functional damage.
- Automatic paper feeding
Switch on printer before feeding paper. Automatic paper feeding stabilizes the materials to prevent any dislocation.
- 24-hour white ink cycle
Keep machine running at all times to prevent white ink from drying out. In case of emergency, press the emergency stop button to power off.
- The following diagram shows how the machine its parts function:

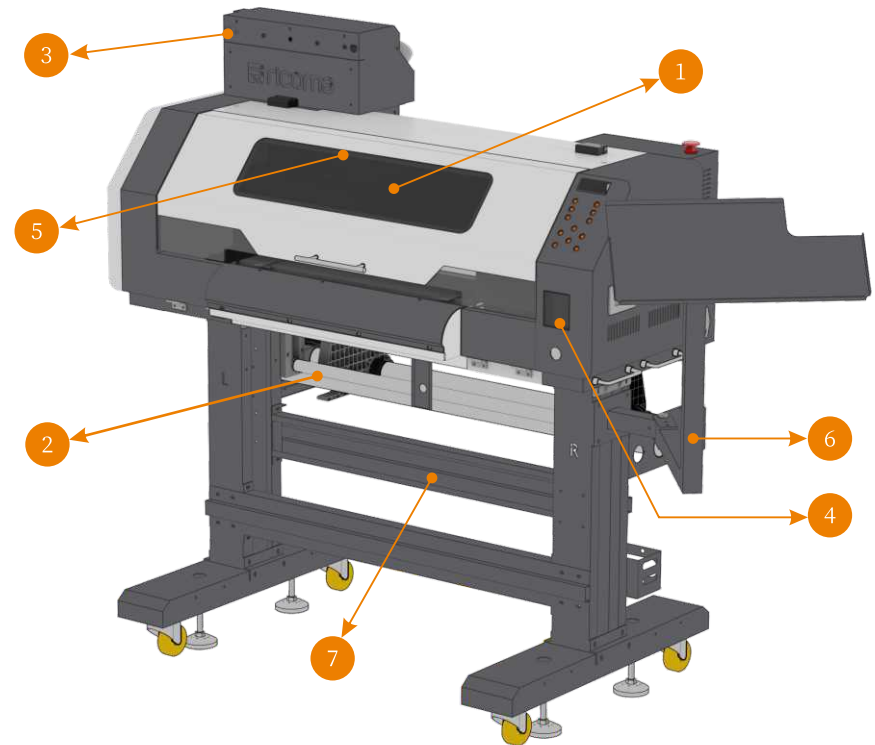
Keep machine running at all times to prevent white ink from drying out. In case of emergency, press the emergency stop button to power off.





2.1 Machine Structure

Unbox and take out the accessories in it and assemble according to the following instructions:

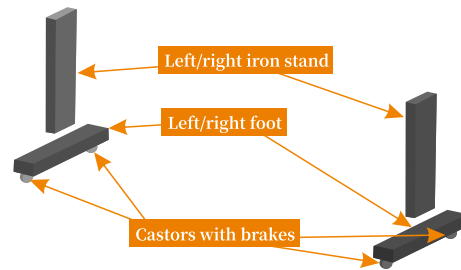


Names of parts:

- (1) Main body ; (2) Paper tension control system ; (3) Ink shortage alarm;
- (4) Three-way constant temperature system ; (5) LED lamp ;
- (6) Computer stand ; (7) Support stand ; (8) Waste film alarm

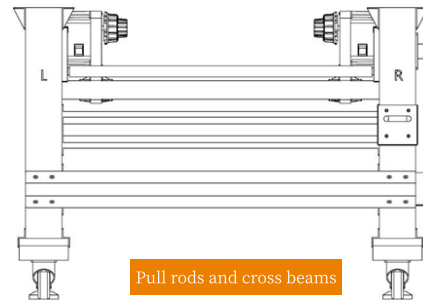
Stand installation:

1. Install the left foot and the right one under bottom of the left iron stand and the right one and fix with hexagon socket screws. Install the castors with brakes onto the left foot and the right one and fix them with hexagon socket screws.

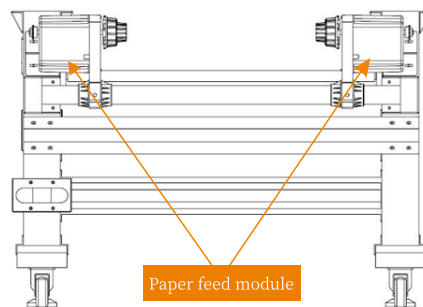


Note: Lock along the arrow directions as in the figure below.

2. Have the pull rods and the cross beams installed between them and fixed with hexagon socket screws as shown in the figure below.

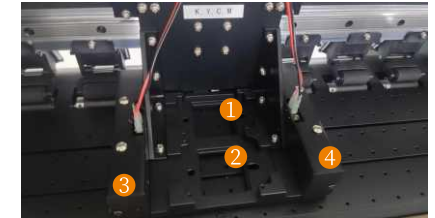


3. Use hexagon socket screws to fix the support retaining plate with the left iron stand, the right iron stand, the left foot and the right foot, and then fix its left and right ends. Put the assembled paper feed module onto the aluminum pipe and then mount them onto the left support and the right support. Refer to the figure below.



2.2 Structural drawing of printer head view

1. Color ink-jet head ;
2. White ink-jet head
3. Left bumper ;
4. Right bumper



2.3 Left view of printer box

- 1.X-axis ;
- 2.Y-axis;
3. Automatic pull rod motor ;
- 4.Y-axis-motor;
- 5.Encoder



2.4 Right view of printer box

1. Ink pump ;
2. X-axis motor ;
3. Motor of temperature-controlled console ;
4. Motor of automatic pull rod button



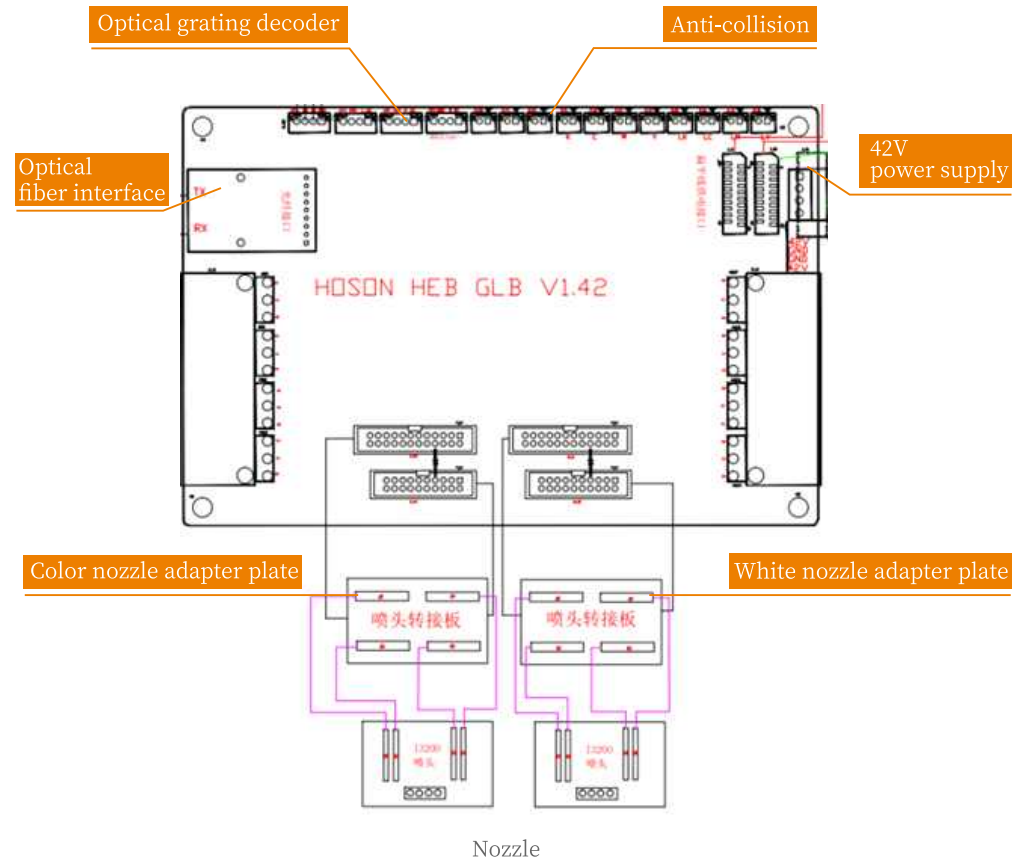
3.1 Basic parameters

Model	DTF-2402T
Nozzle type	I3200
Nozzle quantity	2
Print width	≤600mm
Print configuration	Color+white (KYCM+WWWW)
Applicable medium	4Pass 720 x 1200 15m ² /H ; 6Pass 720 x 1800 9.5m ² /H
Print speed and resolution	Print speed and resolution
Ink type	Coating ink
RIP software	SAI Flexi (PP)
Color control	ICC or density curve
Operating system	Win7, Win10
Heating and drying function	Printer arc plate heating and plate heating
Anti-collision function	Anti-collision alarm emergency stop touch devices are installed on both ends of the printer head
Automatic feeding function	Automatic feeder is equipped with a probe sensor for automatic tension feeding.
Paper out alarm function	The printer will automatically stop printing in case of paper out alarm during printing.
Waste ink alarm function	The printer will automatically give an alarm in case of full waste ink bottle.
Cycle stirring function	White ink uses a separate power supply, so that it can achieve timed infinite cycle stirring in off state.
Low ink alarm function	The printer will automatically give an alarm in case of low ink.
Lighting function of printing platform	LED lighting for printing platform
Paper pressing function of automatic pull rod	One-key automatic lifting pull rod for platform feeding
PC assembly function	Self-equipped computer stand, which saves space.
Platform suction	The suction capacity is adjustable.
Print interface	Gigabit network interface
Temperature & Humidity	15 - 30°C ; 35-65%
Material collection function	Automatic sensor for material collection
Rated power	800W
Power input	50HZ/220V 15A
Net weight	154KG
Gross weight	Machine+wooden case: 205KG
Machine dimensions	1336mm x 658mm x 1400mm (L*W*H)
Package dimensions	1480mm x 1020mm x 731mm (L*W*H)

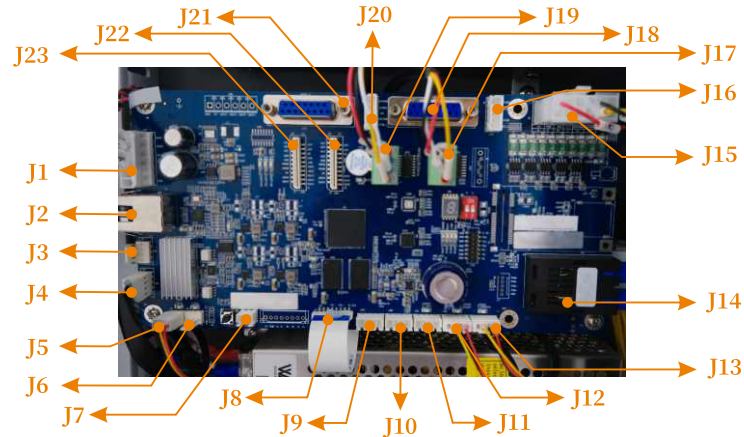
4.1 Print system introduction

DTF print control system consists of three parts, separately are main board, nozzle control panel and control software, which use USB 2.0 ports and PC connections.

4.2 The nozzle control panel and nozzle arrangement are shown in below figure:



4.3 Main board interface is shown in below figure:



4.4 Main board interfaces and definitions:

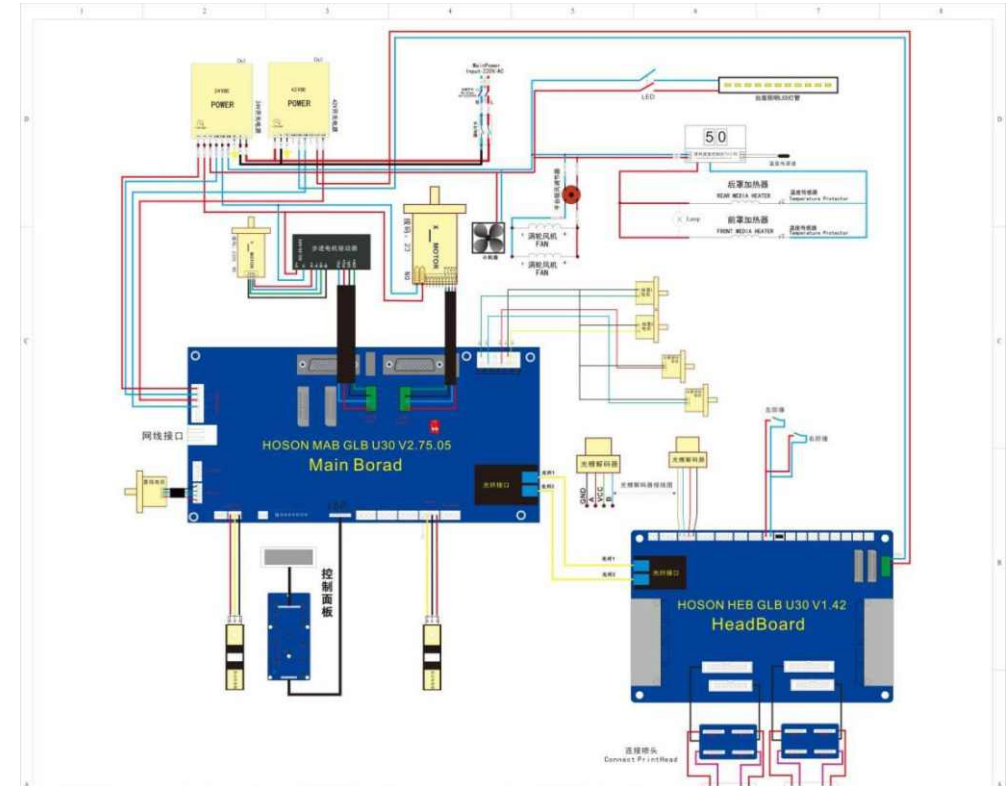
Main board interfaces: Power interface, high-speed communication interface, low-speed communication interface, control interface

No.	Interface definition	No.	Interface definition
J1	Power (24V/42V) input interface	J13	Paper out signal detection interface
J2	Gigabit Ethernet interface	J14	Optical fiber interface
J3	Ink stack lifting motor interface	J15	24V control signal output interface
J4	Ink stack scraper motor interface	J16	Y-axis motor limit interface
J5	Ink stack scraper motor limit interface	J17	Y-axis motor single-end signal output interface
J6	Ink stack lifting motor limit interface	J18	Y-axis motor differential signal output interface
J7	Ink supply reset interface	J19	X-axis motor single-end signal output interface
J8	Control panel interface	J20	X-axis motor limit interface
J9	Rs485 expansion interface	J21	X-axis motor differential signal output interface
J10	Optical grating signal input interface	J22	24V flat cable power supply interface
J11	Left limit interface	J23	24V flat cable power supply interface
J12	Right limit interface		

Note: Main board design requires two lines of 24V power supply, so as to ensure stability in main board during operation. Meanwhile, it is required to fix set screws to printer enclosure.

4.5 The installation and wiring diagrams of printer plate card are shown in below figure:

The printer control system consists of three parts: main board, head board and control software, which are connected to computer by cable ports.



5.1 Software installation

Print Exp_X64 software is a kind of printer management software, which is mainly used to set various printer parameters, calibrate and adjust printer nozzles, maintenance, nozzle cleaning and printing operation, etc.

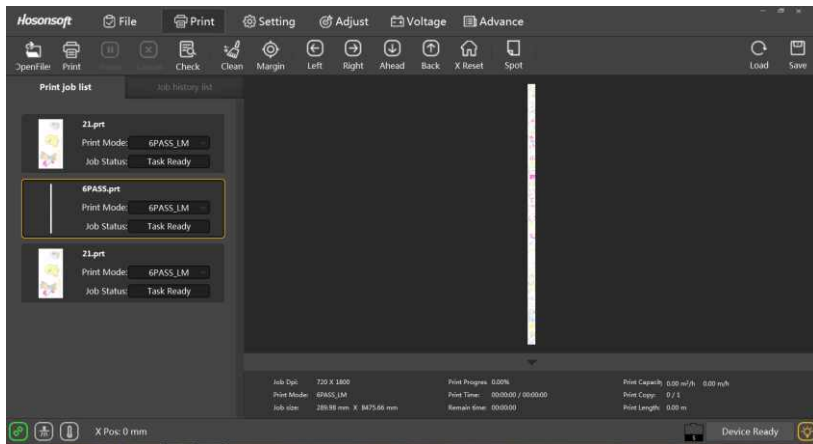
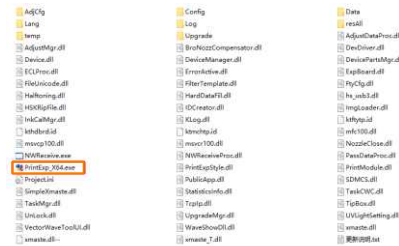
The printing management software shall be installed according to the following steps:



As the existing computer systems include Win7, Win10, etc., the installation steps are as follows: First, unpack the software package.

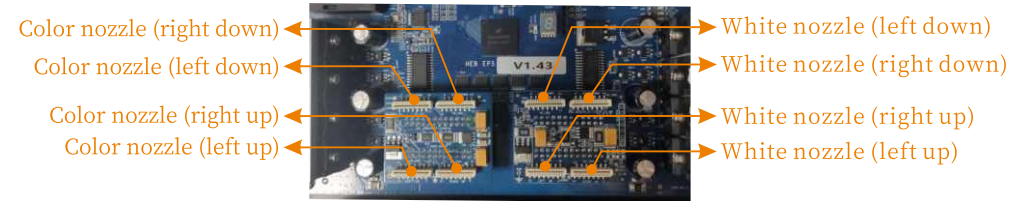


Open the unpacked folder, double click Print Exp_X64.e x e to enter the main interface of the software, as shown in below figure:

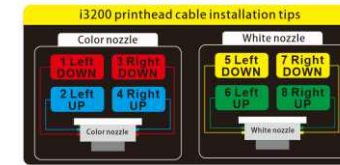


6.1 The arrangement of plate nozzles

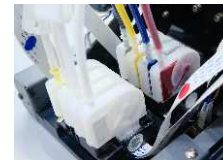
The arrangement of plate nozzles is shown in below figure:



6.2 Nozzle USB cable connection is shown in below figure:



Note: Regardless of the installation method of the nozzle plate, the connection is unique. In case of a wrong connection, it may probably burn the nozzles or head board.



Arrangement of nozzle ink inlet KYCMWWW



Nozzle USB cable interface



EPSON i3200 nozzle appearance



Arrangement of cartridges MYCKW



Nozzle plate USB cable interface



Gigabit network cable

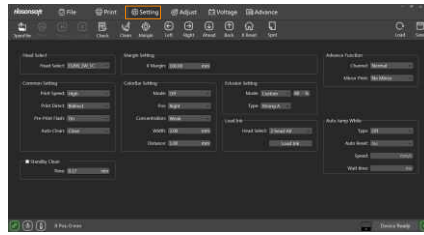
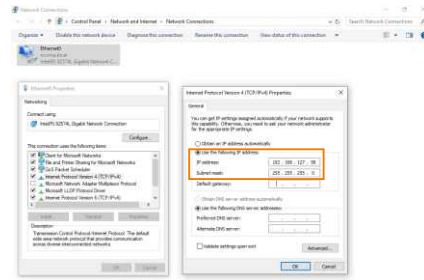


①. Ink sac (one nozzle requires 4 ink sacs)

②. USB cable: 14-core flat cable of nozzle and head board (one nozzle requires 4 cables)

7.1 Set an IP address for the computer network.

- Put the cursor on the “Network Neighborhood” icon, right click the mouse, choose “Local Connection” and right click the mouse while the cursor is on the “Attribute” option.
- On the computer, do networking setting with user-defined IP address 192.168.127.58 and default subnet mask 255.255.255.0.



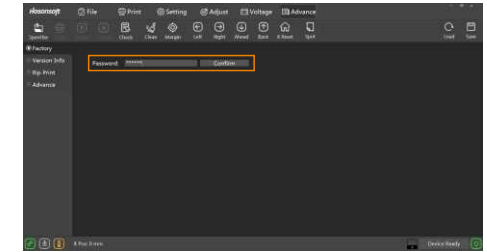
7.2 功能参数设置

a, Click “Setting” to enter the interface with conventional printing settings.

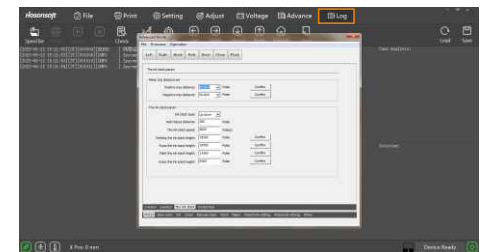
S.N.	Name	Functional description	
1	Nozzle selection	Nozzle selection settings are available only for specific models.	
2	White edge settings	X-axis white edge	Set the initial position for printing
		Y-axis white edge	Set the initial position for printing
3	Conventional settings	Print speed	Set print speed to low, medium and high speed
		Print direction	Set print direction to left, right and two-way print
		Flash injection before printing	Set whether flash injection or not before printing
		Automatic cleaning	Set ON or OFF before printing
		Paper feeding direction	Select paper feeding direction
4	Color stripe settings	Color stripe position	Separately set color stripe position to left stripe, right stripe, left and right stripe and stripe off.
		Color stripe pattern	Select stripe pattern during printing
		Color stripe concentration	Select stripe concentration during printing, i.e. low, medium and high
		Color stripe width	Select stripe width during printing
		Color stripe spacing	Select stripe spacing during printing
5	Feather settings	Feather pattern	Select feather pattern

S.N.	Name	Functional description	
5	Feather settings	Feather type	Select feather type
6	Advanced functions	Channel control	Control nozzle data
		Mirror print	Control whether the pictures are horizontally flip printed
7	Light		Ink drying and curing
8	Automatic white skipping	White skipping mode	Select white skipping mode, i.e. white skipping off, stepping white skipping and continuous white skipping
		Automatic reset	Select whether to automatically reset

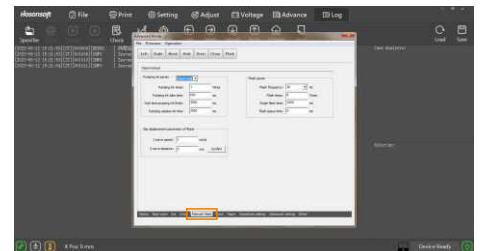
b, Click “Advanced” and “Factory Settings” in sequence and enter password “111111” to enter the internal function setting.



c, For the main ink station position, the ink station height and the scraper height can be set.

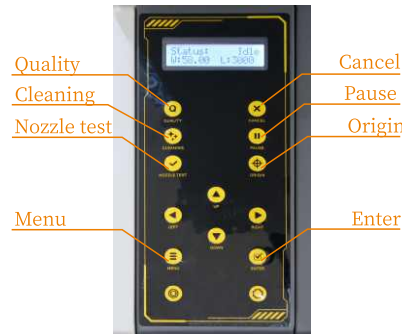


d, In the “Manual cleaning parameters” zone, the cleaning parameters can be adjusted. For other functions, choose their defaults.



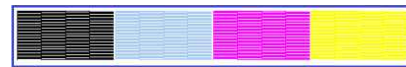
7.3 Control panel

1. Left/right moving button: For moving the printer head leftward or rightward in the standby status, or browsing in the menu status
2. Paper feed/unwinding direction button: For feeding and discharging the printing carrier in the standby status, or decreasing or increasing the item quantity in the menu status
3. Exit button: For backing to the previous menu in the menu status
4. Enter button: for entering the main menu page



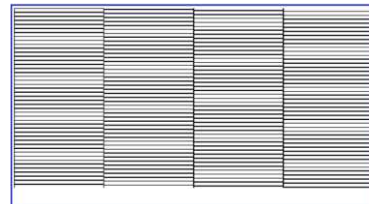
8.1 Nozzle test function introduction

Click “Nozzle test” to print nozzle pattern. The sample pattern is shown below:



Nozzle Calibration Pattern

Locally enlarge the black state pattern in normal and abnormal cases, as shown below:



Nozzle State Pattern in Normal Case

The below state pattern shows there may be blockage, which requires cleaning until nozzle ink injection reaches the best effect.



Nozzle State Pattern in Abnormal Case

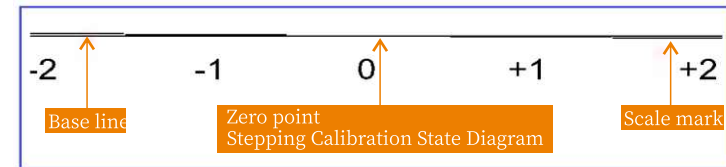
8.2 Stepping calibration function

Click “Stepping calibration” for printing.



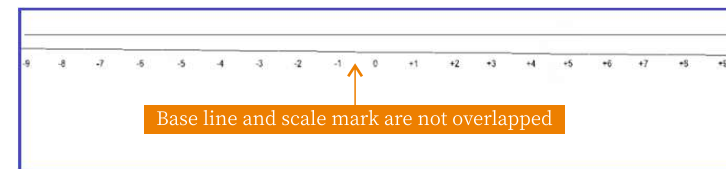
Figure 10

If stepping adjustment is normal, base line and scale mark will be completely overlapped at zero point, as shown in Stepping Adjustment State Diagram 1.



Stepping Adjustment State Diagram 1

If stepping adjustment is abnormal, base line and scale mark will not be overlapped, as shown in Stepping Adjustment State Diagram 2.



Stepping Adjustment State Diagram 2

8.3 Calibration of horizontal spacing between nozzles

Click “Nozzle spacing” for printing.

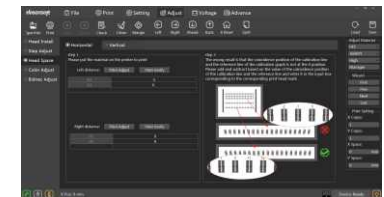
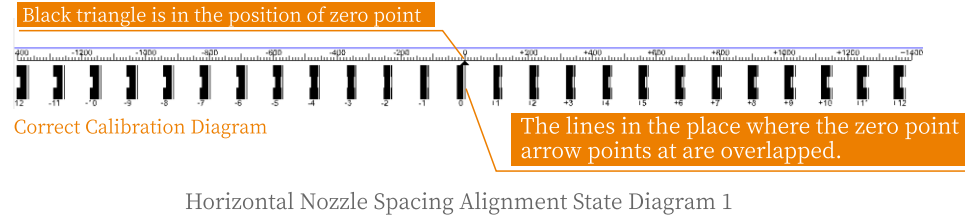
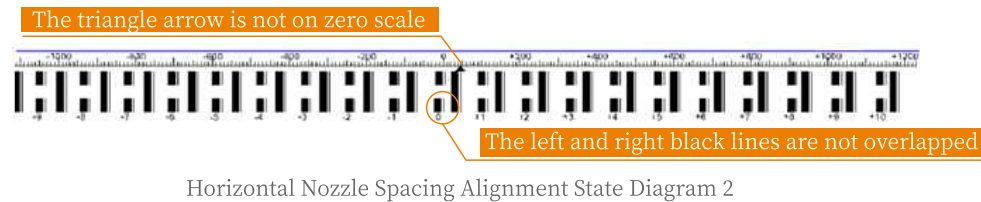


Figure 11

If the print head spacing is aligned normally, the print pattern will be shown as follows.



If the print head spacing is aligned abnormally, the print pattern will be shown as follows.



In this case, alignment is required. First, enter adjustment value in H2, click to calculate and re-print the print pattern until the zero point on the scale is on zero scale.

8.4 Calibration of vertical spacing between nozzles

Click “Nozzle calibration” for printing.

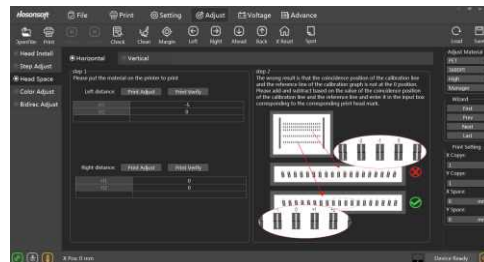
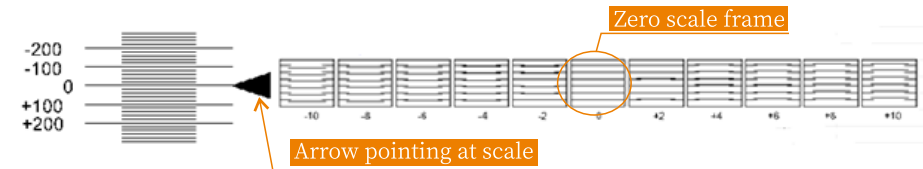
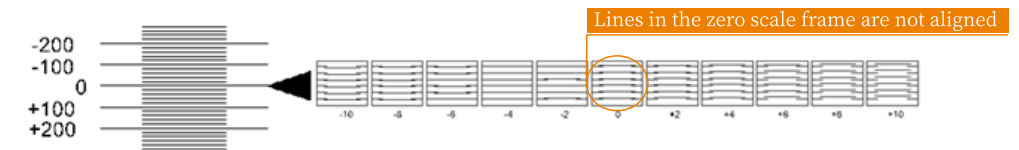


Figure 12

If the alignment of vertical spacing between nozzles is normal, all lines in the zero scale frame are parallel, and the left arrow points at zero position, as shown in Vertical Nozzle Spacing Alignment State Diagram 1.



If the adjustment of vertical nozzle spacing is abnormal, all lines in the zero scale frame are parallel to -4 position, indicating the alignment state of vertical nozzle spacing.



In this case, it is required to make adjustments based on the original reference adjustment until all lines in the zero scale frame are parallel at zero point, i.e. left arrow points at zero position.

8.5 Bidirectional calibration

Click “Print calibration diagram” in bidirectional calibration for printing.

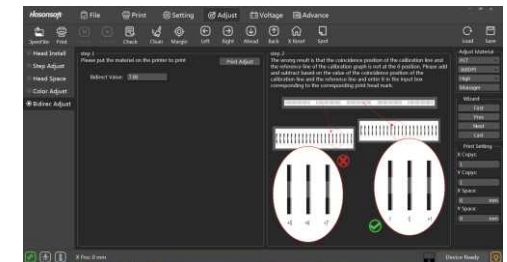
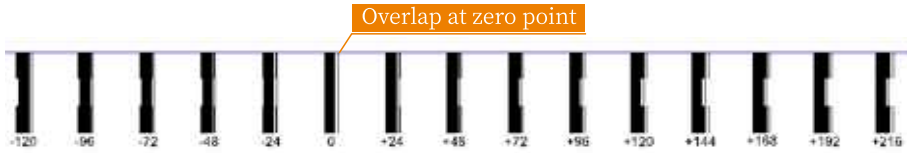


Figure 13

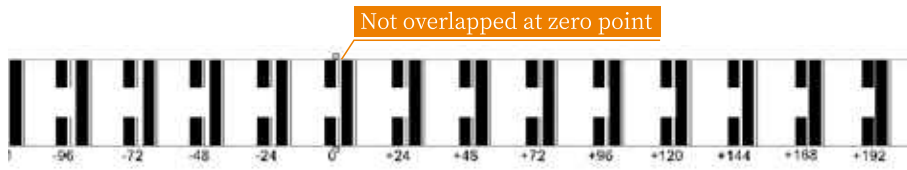
If bidirectional calibration is normal, the lines will be overlapped at zero position, as shown below.



Correct Calibration Diagram

Bidirectional Calibration State Diagram 1

If bidirectional calibration is abnormal, the lines will not be overlapped at zero position, as shown below.



Bidirectional Calibration State Diagram 2

In this case, it is required to enter adjustment value for re-adjustment.

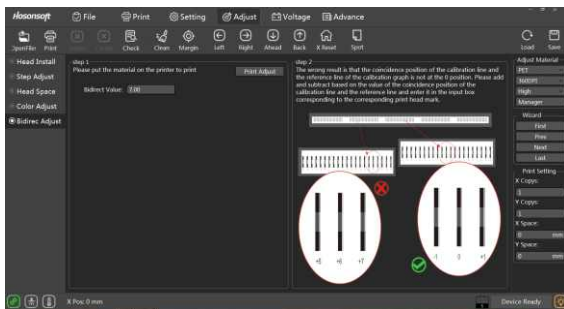
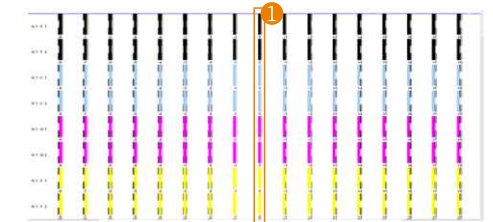


Figure 14

8.6 Polychrome calibration

Click “Print left/right calibration diagram” under polychrome calibration interface to print calibration diagram.



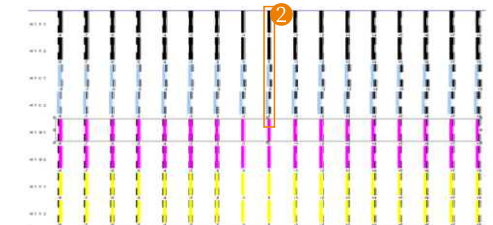
Polychrome Calibration Diagram 1

If color adjustment is normal, the lines will be overlapped at the zero position, as shown below.

①: The pattern of the channel color and the black pattern are completely overlapped at zero point.

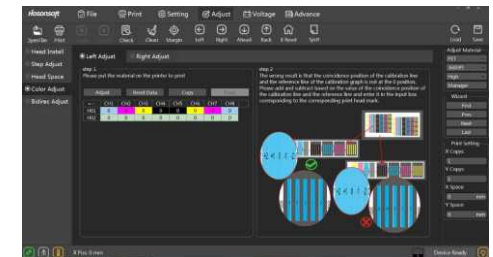
If color adjustment is abnormal, the lines will not be overlapped at zero position, as shown below.

②: The pattern of the channel color and the black pattern are overlapped at zero point.

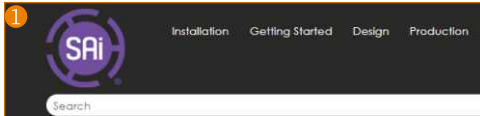


Polychrome Calibration Diagram 2

In this case, it is required to enter adjustment value for re-adjustment, as shown in below figure.



1



You are here: Installation

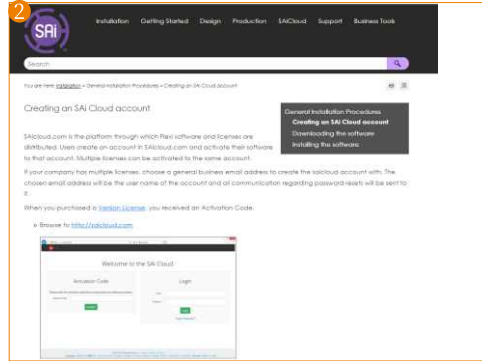
Installation

This chapter covers everything related to the installation and setup of your software.

General installation procedures

- » [Creating an SAI Cloud account](#)
- » [Downloading the software](#)
- » [Installing the software](#)

2



Creating an SAI Cloud account

SAIcloud.com is the platform through which PAKI software and licenses are distributed. Users create an account in SAIcloud.com and activate their software to that account. Multiple licenses can be activated to the same account.

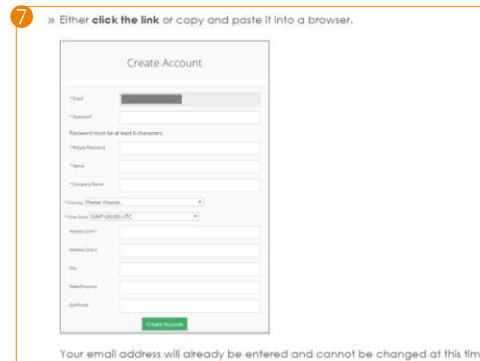
If your company has multiple licenses, choose a general business email address to create the SAIcloud account with. The chosen email address will be the user name of the account and all communication regarding password resets will be sent to it.

When you purchased a [Standard License](#), you received an Activation Code:

» Browse to <http://saicloud.com>

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» Either **click the link** or copy and paste it into a browser.

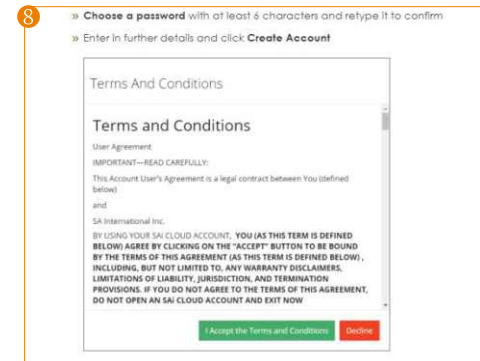


Your email address will already be entered and cannot be changed at this time.

8

» **Choose a password** with at least 6 characters and retype it to confirm

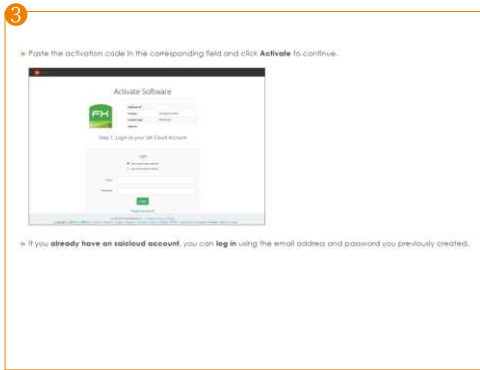
» Enter in further details and click **Create Account**



Accept the Terms and Conditions

3

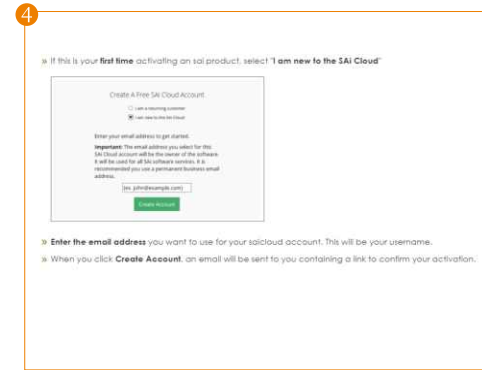
» Paste the activation code in the corresponding field and click **Activate** to continue.



» If you **already have an saicloud account**, you can **log in** using the email address and password you previously created.

4

» If this is your **first time** activating an SAI product, select **"I am new to the SAI Cloud"**

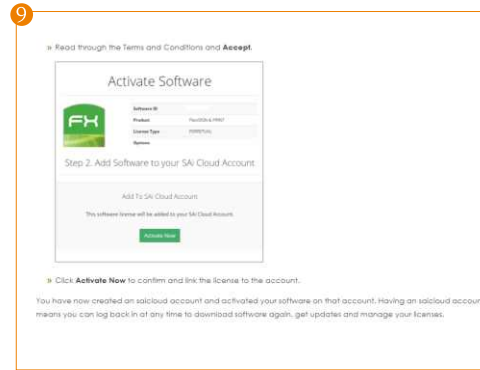


» **Enter the email address** you want to use for your saicloud account. This will be your username.

» When you click **Create Account**, an email will be sent to you containing a link to confirm your activation.

9

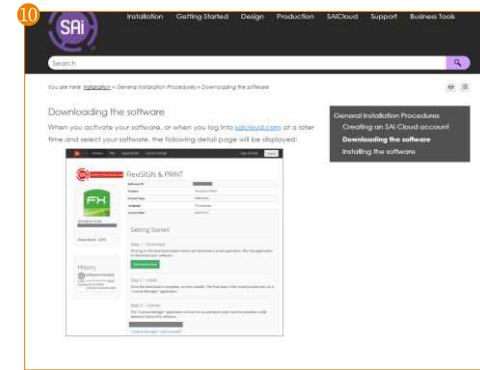
» Read through the Terms and Conditions and **Accept**.



» Click **Activate Now** to confirm and link the license to the account.

You have now created an saicloud account and activated your software on that account. Having an saicloud account means you can log back in at any time to download software again, get updates and manage your licenses.

10

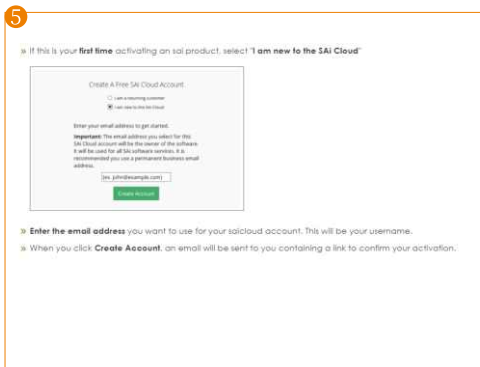


Downloading the software

When you activate your software, or when you log into saicloud.com at a later time and select your software, the following detail pages will be displayed:

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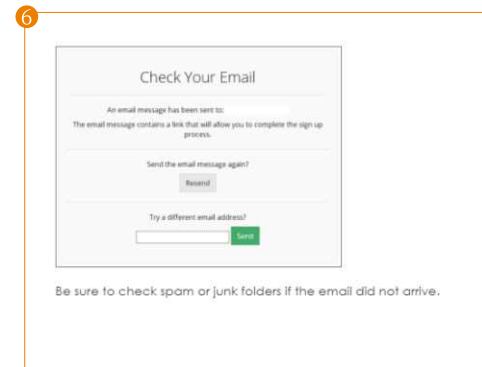
» If this is your **first time** activating an SAI product, select **"I am new to the SAI Cloud"**



» **Enter the email address** you want to use for your saicloud account. This will be your username.

» When you click **Create Account**, an email will be sent to you containing a link to confirm your activation.

6



Be sure to check spam or junk folders if the email did not arrive.

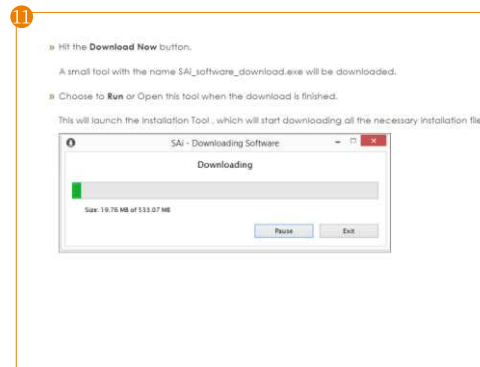
11

» Hit the **Download Now** button.

A small tool with the name `SAI_software_download.exe` will be downloaded.

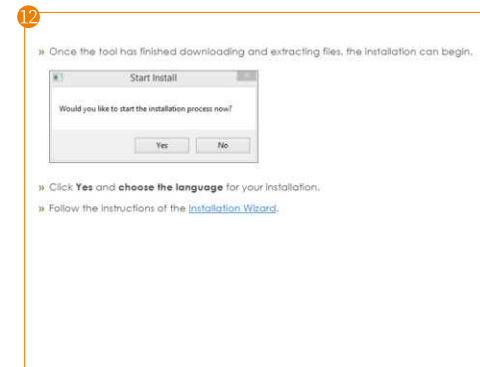
» Choose to **Run** or **Open** this tool when the download is finished.

This will launch the installation tool, which will start downloading all the necessary installation files.



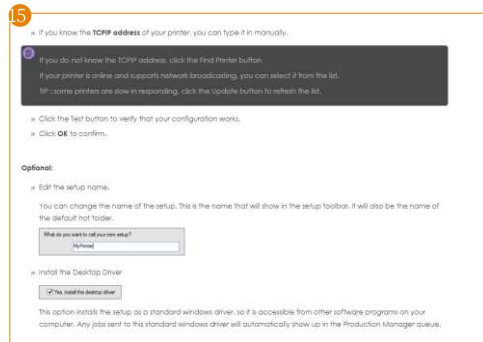
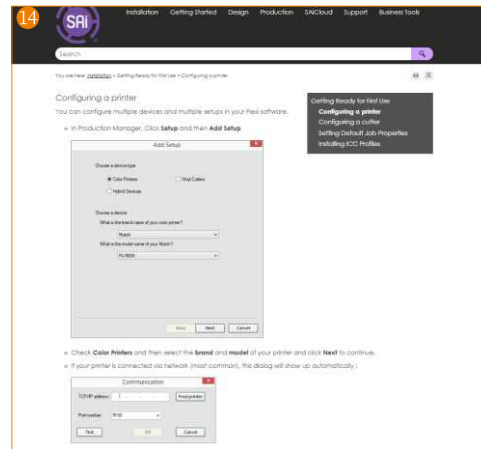
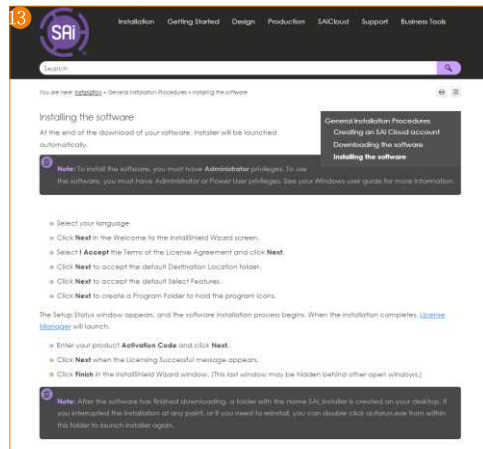
12

» Once the tool has finished downloading and extracting files, the installation can begin.



» Click **Yes** and **choose the language** for your installation.

» Follow the instructions of the [Installation Wizard](#).



10.1 Maintenance Instructions

1. Before powering on the product each day, check whether the nozzles are blocked and clean them if ink discontinuity is detected.
2. The operating temperature is 20°C-30°C; the operating relative humidity is 45% to 65%.
3. Before powering off the product each day, check the nozzles and clean them if ink discontinuity is detected.
4. Before powering off the product each day, make sure the nozzles and the ink

station are aligned and contact each other.

5. Do not use color bars in printing to avoid nozzle blockage due to long-time discharge failure of the ink of certain color.
6. In printing, keep the printing film from scrapping the nozzles.
7. Make sure the gratings are not dusty. Wipe them with dust-free cloth every one to two weeks.
8. Wipe the guide rail with sewing machine oil every two to three weeks.
9. Wipe the scraper with dust-free cloth at regular intervals.
10. Clean up the ink on paper in time to avoid nozzle scrapping by it after accumulation.
11. Clean up the ink on the printer head baseplate at regular intervals.
12. Clean the ink close to the ink stack cap at regular intervals to keep the ink stack cap clean.
13. If the product is not going to be used for a long time, pour distilled water or special coating ink cleaning solution onto the ink stack cap till the nozzles are immersed and clamp the ink pipes and the ink suction pump.
14. When the printing film is not used, wrap it with fresh-keeping film to keep it from moisture.
15. When the hot melt adhesive powder is not used, seal it with a bag to keep it from moisture.