

For customer

**HITACHI**  
Inspire the Next



**INK JET PRINTER FOR INDUSTRIAL MARKING**

# HITACHI Printer

## Handling Guidance and Precautions for Ink



- ◆ Please read SDS(Safety Data Sheet) of purchased ink and makeup.
- ◆ Before using IJ printer, please read following precautions for stable operation.
- ◆ Please refer "Basic Operation Manual", "Instruction Manual" and "Technical Manual" also.

 <b>WARNING</b>	WARNING is used to indicate the presence of a hazard which may cause severe personal injury or death if the warning against performing an incorrect handling procedure is ignored.
 <b>CAUTION</b>	CAUTION is used to indicate the presence of a hazard which may cause personal injury or property damage if the warning against performing an incorrect handling procedure is ignored.

Version; W5.04

## Basic Precautions

[ i ]

### Precautions of Storage

- (1) Please read SDS(Safety Data Sheet) of purchased ink and makeup.
- (2) Store inks and makeups in the cold dark place (0 to 20°C ).(Please store them in the same way regardless before and after opening cartridge/bottle.)
- (3) There is an opening deadline for inks and makeups. Please fill them into the IJ printer before the "Expiration date" described on the cartridge/bottle. ("Expiration date" means "Opening deadline".)
- (4) Once the cartridge/bottle is opened, even if it is stored in a cold dark place, the ink begins to deteriorate in the same manner as the ink in the printer. If "Ink Replacement Cycle" base on guideline have passed, dispose the ink.

[Note] Regarding to (3) and (4), please see detail on following "[v] Guideline for the "Ink Replacement Cycle" and applicable makeup" .



#### WARNING

Do not drain the ink or makeup waste solution into public sewer systems or elsewhere. Waste disposal must comply with all appropriate regulations. Have the used wiping papers and the empty container disposed by an industrial waste processor. Consult the appropriate regulatory agency for further information.

[ ii ]

### Consideration of "Air purge" Install

Depend on usage environment, air purge is necessary. Below is the conditions under which air purge is required.(\*1).

- (1) When the printer is used in a high-humidity environment, such as a beverage can or beer can line (Perform air purge when using it in the 85 % RH or higher humidity environment.)
- (2) When a water drainage blow sequence is performed before printing.
- (3) When you use the printer in an environment with a lot of paper powder or dust.
- (4) When the end of the print head becomes dirty because the distance between the print head and the target is too close and ink splashing occurs.
- (5) When you use the ink for which the need for air purge is described in the handling guidance of each ink.

[Note] Depending on the ink, "Air purge" is required regardless of the usage environment.  
On the contrary, there is case installing is not available. Please see "Precautions for each ink".

(\*1) UX2/UX/RX2 : [Technical Manual] 3.1 Print head air purge

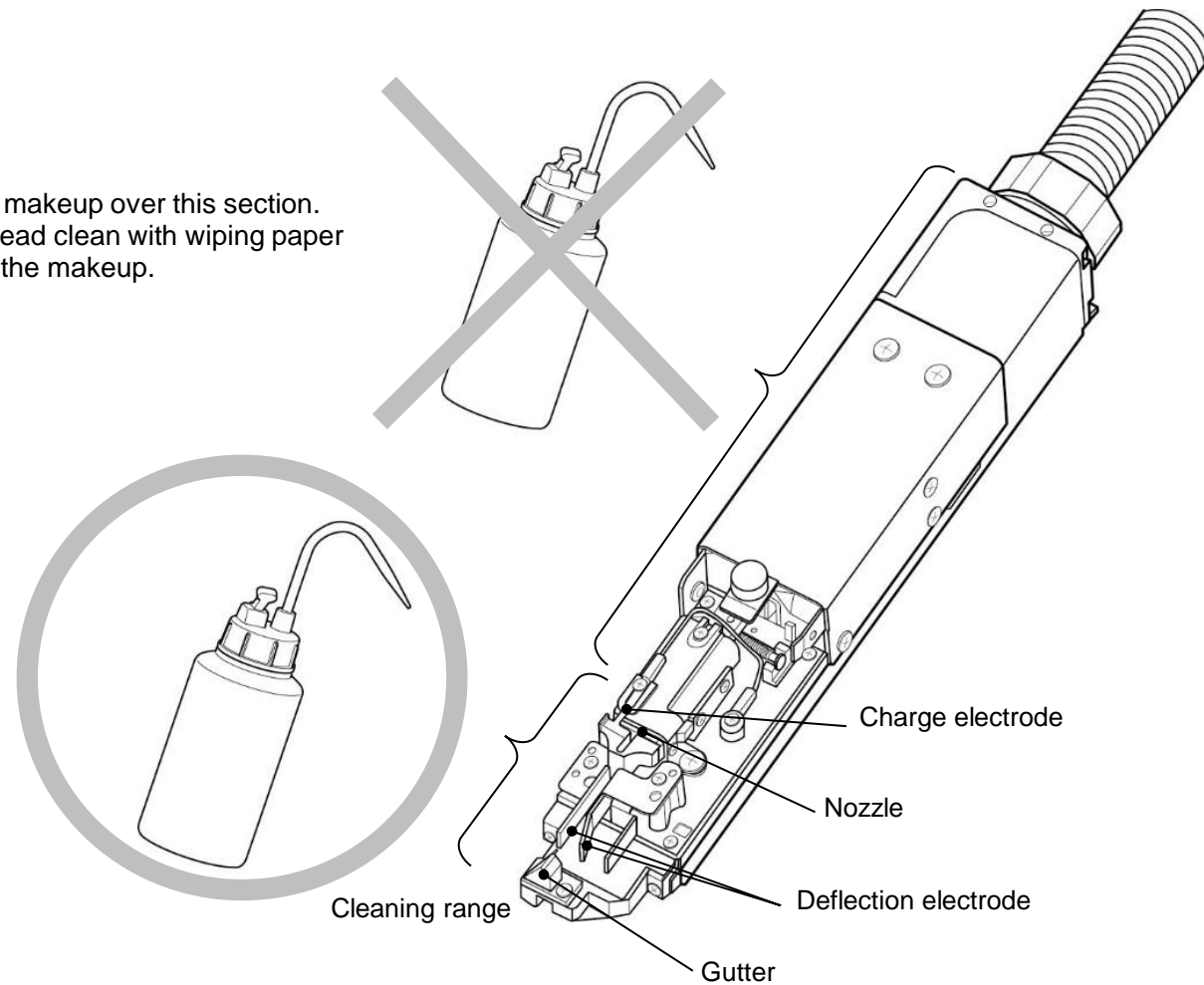
[ iii ]

## Print Head Cleaning

Take the following precautions when cleaning ink from around the nozzle.

- (1) Face the end of the print head downward and pour makeup onto the dirty part and clean while catching the makeup in a beaker.

Do not pour the makeup over this section.  
Wipe the print head clean with wiping paper dampened with the makeup.



\*This figure is an image of UX2 series. There are some difference between UX2 and UX/RX2, but basic structure is same.

- (2) After cleaning, thoroughly wipe the print head with wiping paper and allow it to dry.
  - Thoroughly dry the nozzle orifice, charge electrode, deflection electrode, and mounting base and fringe of the gutter. Make sure that the parts are sufficiently dry before starting the next operation. If operated while wet, the printer will not start normally.
  - While the print head is wet, do not orient its end upward.
- (3) Do not immerse the print head in the makeup.
- (4) When printing is frequently performed or the distance between the print material and the print head is short, ink splashes may stain the end of the print head and the print head cover. If this condition is left unresolved, the staining will be worse, resulting in a print error or emergency stop. If a print error or emergency stop frequently occurs due to staining caused by ink splashes, stop the operation in progress and clean the end of the print head (around the nozzle, charge electrode, deflection electrode, mounting base and gutter) and the print head cover. Perform this operation in addition to the cleaning at the end of each day's work.

Air purging of the print head is effective against staining due to ink splashing. See the "Print head air purge(\*1)".

(\*1) UX2/UX/RX2 : [Technical Manual] 3.1 Print head air purge

[ iv ]

## Gutter Cleaning

This unit collects ink from the gutter. At the same time, it sucks in atmospheric gas, dust, and other matter from the air. If these substances are mixed with the ink in the gutter, undissolved components in the ink or makeup may stick to the gutter. If the unit runs for a long time without the gutter being cleaned, these components will gradually accumulate in the gutter. This, together with the ink coming into contact with it, may cause an error stemming from a dirty head.

If this fault occurs, perform the following actions (1) and (2):

- (1) Clean the gutter and its perimeters with makeup periodically.
- (2) See the procedures described in the Technical Manual "Cleaning the Gutter(\*1)" to clean the gutter and the ink recovery route.

If the above actions (1) and (2) do not solve the issue, contact your nearest distributor.

(\*1) UX2 : [Technical manual] 5.6 Cleaning Gutter

UX/RX2: [Technical manual] 6.6 Cleaning the Gutter

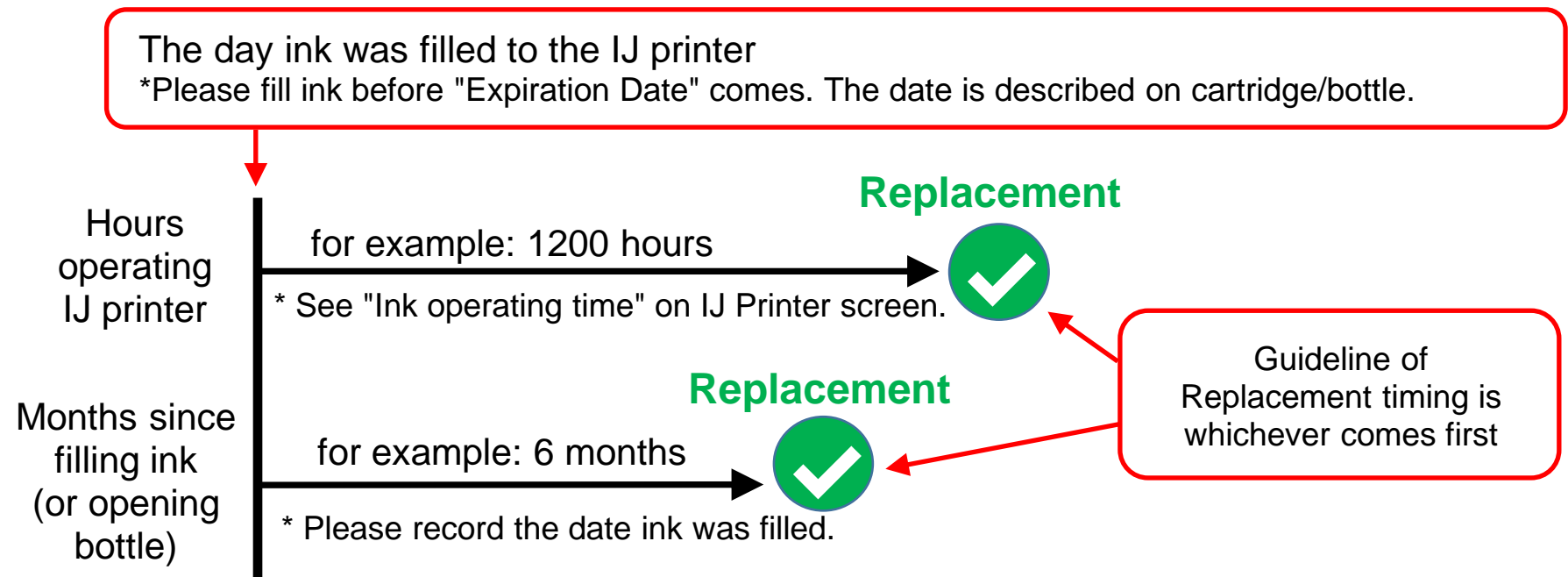
**[ v ] Guideline for the "Ink Replacement Cycle"**

While the IJ printer ink circulates for operations, it reacts with atmospheric air elements and deteriorates with time. Therefore, it needs periodic replacement. Each ink has several guideline for the ink replacement cycle. Also, since the proper replacement intervals vary with the printer operating environmental conditions (temperature, humidity, dust, etc.). Please determine the best replacement cycle in accordance with the obtained printing results, and replace all ink in the printer with new ink.

[Note] The makeup must be filled to the printer within one year after opening the cartridge.  
 Note that basically the makeup filled to the printer needs no replacement.

(\*1) UX2 : [Technical Manual] 5.3 Replacing the ink  
 UX/RX2: [Technical Manual] 6.3 Replacing the ink

**[Guideline for ink replacement timing]**



**[Remark] "Hours operating on IJ printer" and "Months since filling ink" are depend on Ink model. Please refer to the attached document for each ink.**

**[ vi ] Stoppable Period and Long-term Shutdown**

If the IJ printer is not operated on regular basis, ink may stick in circulation system. If it sticks, error such as ink not ejecting and ink can not be recovered are occur. To prevent these issues, refer to "IJ printer Stoppable period (\*1)", and operate IJ printer (eject ink from the nozzle) on a regular basis. The period that can be stopped depends on the storage temperature. Also, please note that the period may be shorter dramatically depending on the usage environment(\*2).

In case of long period shut down more than the term shown in "Stoppable period and Long-term shutdown", to operate "Long-term shutdown" is necessary. This long-term shutdown prevents sticking by draining the ink in the IJ printer and filling makeup (solvent) instead. Dedicated operation is required even when restarting. Please refer to the [Technical Manual (\* 3)] for details of the operation.

(\*1) Maximum period possible to be continuously shut down without operation. it is necessary to operate it at least once during this period.

(\*2) Please note that the ink may harden within a week if it is stored at 45 ° C or higher.

- (\*3) UX2 : [Technical manual] 6.16 Long-term shutdown
- UX/RX2 : [Technical manual] 6.16 Long-term shutdown
- UX(Twin nozzle) : [Technical manual] 6.15 Long-term shutdown
- UX-P : [Technical manual] 6.15 Long-term shutdown
- RX2 : [Technical manual] 6.14 Long-term shutdown

#NAME?

 **CAUTION**

Since "Perform long-term shutdown storage work" requires special work, it is recommended to contact your local distributor and ask for the work.

**[Remark] "Days printer can be stopped" depend on Ink model. Please refer to the attached document for each ink.**

[ vii ]

## Required Operating Minimum Hours to Prevent Ink Viscosity Decrease

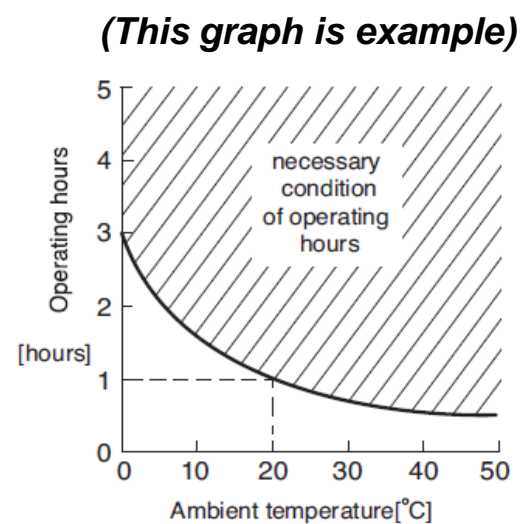
Following is precautions when repeating operation start and stop.

The IJ printer automatically cleans the circulation system with makeup (solvent) when stopped to prevent ink from sticking. At this time, the amount of solvent in the ink tank increases and the ink viscosity decreases. On the other hand, when the IJ printer is operated, the ink viscosity is automatically adjusted for stable operation. However, if the main tank is filled with a large amount of solvent by repeating "shutdown (automatic cleaning) in a short time", the ink viscosity may not be controlled normally. To prevent this, operate for a certain period of time (eject ink from nozzle) after starting operation. The required operating time depends on the ambient temperature and ink model.

[Note] For stable operation, limit the number of times "Shutdown" to be performed to two at a time.

### [ For example ]

The table on the right showing the minimum required operating time is an example. In this case, if IJ printer is running under 20 °C ambient temperature, the required operating minimum hours is around 1 hour, after starting operation.



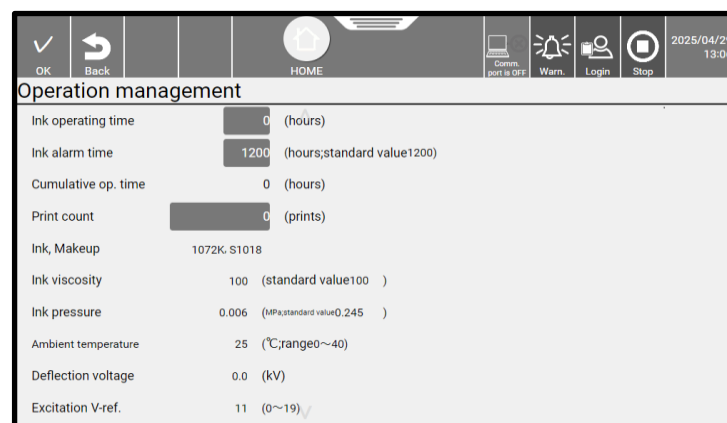
**[Remark] "Required operating minimum hours" depend on Ink model. Please refer to the attached document for each ink.**

## Supplementary Information

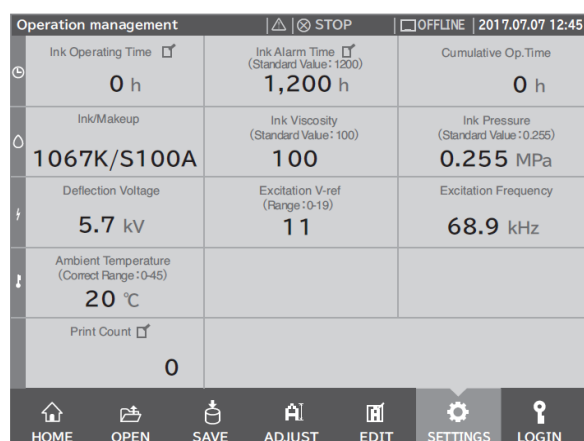
In case of using "Rotary encoder" in order to match production speed and printing speed, "Excitation frequency" information is necessary(\*1). This value depends on ink model, nozzle size and setting. Please see "Operating management" screen, and confirm the value of excitation frequency. In addition, applicable makeup and other information are shown also on the screen.

(\*1) UX2 [Technical Manual] 4.3.2 Speed Matching Function Using Rotary Encoder

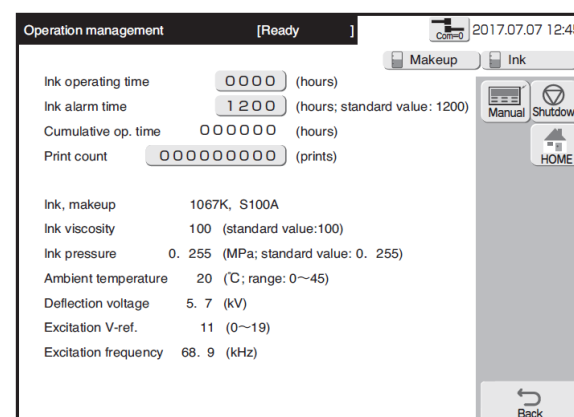
UX/RX2 [Technical Manual] 4.3.2-3 Method of calculating the conditions which allow product speed matching



UX2 style screen



UX/RX2 style screen



Classic style screen

### Precautions (Basic precautions)

Note

For customer

## Attachment for Basic Precautions

Detailed values for the following notes described in the main document depend on ink. Please refer to the contents described in the table of this document and use IJ printer and ink. Applicable makeup for each ink is described also.

- [ v ] Guideline for the "Ink replacement cycle"
- [ vi ] Stoppable period and Long-term shutdown
- [ vii ] Required operating minimum hours to prevent ink viscosity decrease

※ Depending on the ink, there may be special precautions. In this case, please see "Precaution for each ink" also.

### Value of "Basic precautions [v], [vi] and [vii]" for each ink

#### 1118Y / JP-Y118

Applicable Makeup	S1084 / TH-84	Base solvent	MEK
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[ v ]	Guideline for the "Ink replacement cycle"	
Guideline of replacement timing to new ink is the earlier of the following.		
	Hours operating on IJ printer	Months since filling ink (or opening bottle)
	600 - 1200 hours	6 months

[ vi ]	Stoppable period and Long-term shutdown			
Guidelines for stoppable period (Days printer can be stopped)				
	Storage temperature	0-35°C	35-40°C	40-45°C
	Days printer can be stopped	14 days	7 days	5 days

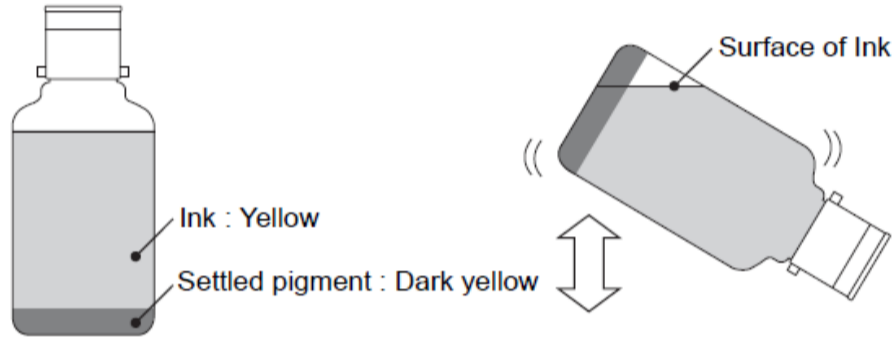
[ vii ]	Required operating minimum hours to prevent ink viscosity decrease	
Please operate IJ printer for at least following hours per start-up of IJ printer.		
	For single nozzle	For Twin nozzle ((UX-D860J/W))
Estimated operating hours		

For customer

**Precautions for each ink**

Following items are precautions for each ink. In order to prevent errors, please be sure to check following matters before installing. In addition, please see "Basic Precautions" also.

<b>Precaution Number</b>	<b>Precautions for ink <a href="#">1118Y / JP-Y118</a></b>
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<b>B02</b>	<b>Stirring before using ink &lt;for yellow inks&gt;</b>	
	Detail	<p>This ink contains organic pigment as color material. Organic pigment settle on bottom of cartridge/bottle. Before using ink(Filling, replenishment and ink replacement), please invert the ink cartridge/bottle up and down 20 times or more to stir, in order to re-disperse settled organic-pigment. If the liquid level is shaken so that it is in contact with the precipitate, it will be easier to re-disperse. To check the re-dispersion of the settled organic pigment, turn the bottle upside down and leave it for tens of seconds to see the deposition. Please continue stirring until the settlings disappears. If stirring is not enough, color density would be light.</p> <div style="text-align: center;">  </div> <p>※ Compare with carbon inks, pigment for yellow inks deposit on bottom easy. Therefore, sufficient stirring is required.</p>

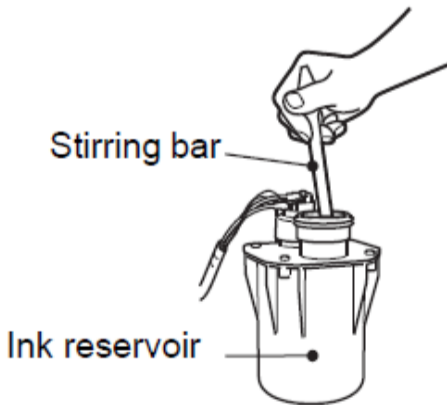
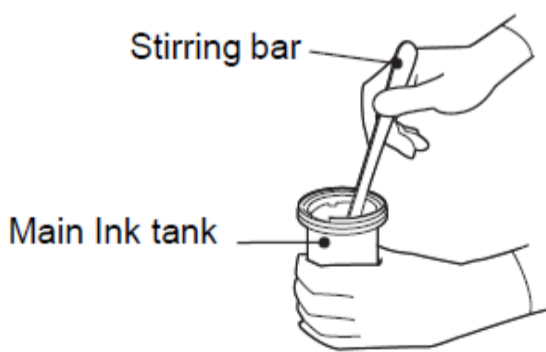
<b>D01</b>	<b>Cleaning of print head (per 24 hours)</b>	
	Detail	The inside of the print head tends to get dirty with ink. To prevent the missing dots which are caused by the ink stains, open the head cover every 24 hours and check it the deflection electrodes and the gutter are clean. If they are stained, stop IJ printer and clean the deflection electrodes and the gutter.
	Manual	UX2 : [Basic Operation Manual] 3.3 Print head cleaning. UX/RX2 : [Basic Operation Manual] 2.3 Print head cleaning.

<b>D04</b>	<b>Regularly gutter cleaning every 24 hours &lt;for yellow inks&gt;</b>	
	Detail	<p>If IJ printer is operated 24 hours continuous without shutdown(automatically cleaning) or cleaning, ink may dry and deposit inside of gutter, and the inner diameter of gutter decrease. Due to this phenomenon, ink overflow from the gutter, deposits on outside of gutter, and charging error may occur. To prevent this issue, please perform shutdown(automatically cleaning) or cleaning. In case of above issues occur, please clean gutter with following procedure.</p> <p style="margin-left: 40px;">(1) Wipe off the dirt on the gutter with wipe paper wipe dampened with makeup.                  (2) Perform the function "Cleaning the gutter" and, pour the make up approximately one minute.                  (3) If dirt is remained inside of gutter, please perform "Cleaning the gutter" again.</p> <p>[Note] If "Cleaning the gutter" was performed several times at once, the ink viscosity becomes low. Do not perform this function more than two times at once.</p>
	Manual	UX2 : [Technical manual] 6.3.3 Gutter cleaning UX/RX2 : [Technical manual] 6.6 Cleaning the Gutter UX-P : [Technical manual] 6.5 Cleaning the Gutter



<b>D06</b>	<b>Regularly print head cleaning in case of printing frequency is high &lt;for pigment inks&gt;</b>													
	Detail	<p>Compare with dye ink, it tends to get ink deposits on the gutter. Ink deposits on gutter may lead to problems of stoppage and printing errors. Especially, It may occur when printing frequency is high. In order to do stable operation, please check deposits around gutters and print-head regularly, then clean them if there are deposited.</p> <p>[Note] The following message is displayed when a certain number of prints are made. The display timing differs depending on the print characters, print settings, and print frequency. If this message is displayed, please check the gutter and electrodes, and if they are dirty, clean them immediately. *Please contact service station for details of software specifications.</p> <div style="border: 1px solid black; padding: 5px; margin: 10px auto; width: fit-content;"> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="text-align: center;">=====</td> <td style="text-align: center;">Gutter and Electrode Check of Dirt</td> <td style="text-align: center;">=====</td> </tr> <tr> <td colspan="3" style="text-align: center;">Check the gutter and electrode dirt.</td> </tr> <tr> <td colspan="3">Solution Clean if the gutter, charge electrode, deflection electrode, and nearby components is dirty.</td> </tr> <tr> <td style="text-align: center;">OK</td> <td></td> <td></td> </tr> </table> </div>		=====	Gutter and Electrode Check of Dirt	=====	Check the gutter and electrode dirt.			Solution Clean if the gutter, charge electrode, deflection electrode, and nearby components is dirty.			OK	
=====	Gutter and Electrode Check of Dirt	=====												
Check the gutter and electrode dirt.														
Solution Clean if the gutter, charge electrode, deflection electrode, and nearby components is dirty.														
OK														
Manual	UX2	: [Basic Operation Manual]	3.3 Print head cleaning.											
	UX/RX2	: [Basic Operation Manual]	2.3 Print head cleaning.											

<b>D07</b>	<b>Nozzle cleaning method &lt;for yellow inks and white inks&gt;</b>		
	Detail	<p>If ink dries and sticks to the nozzle or gutter and cannot be repaired by cleaning with makeup, please clean them with following method.</p> <p>(1) Remove orifice nozzle or gutter, and soak them in about 0.5% household dish detergent. (2) Clean them with ultrasonic washer for approximately 10 minutes.</p>	
Manual	UX2	: [Technical manual]	5.4.2. Disassembly and Cleaning of Nozzle Orifice
	UX/RX2	: [Technical manual]	6.4.2 Nozzle orifice disassembly and cleaning
	UX-P	: [Technical manual]	6.3.2 Nozzle orifice disassembly and cleaning

<b>D10</b>	<b>Ink stirring after 1 week stopping and automatic stirring function &lt;for white and yellow inks&gt;</b>		
	Target inks and machine models	Ink	Note
		White inks	-
		Yellow inks	In case of using yellow inks with "Pigment machine" or "UX-H(48μm)"
Detail	<p>Pigment as color material may accumulate on the bottom of ink tanks due to that of high heavy specific gravity. If stoppage period exceeds one week(168 hours), stirrer for ink stirring may not rotate. Before starting IJ printer, please stir ink inside of ink reservoir and main ink tank with using stirring bar.</p> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;">  <p style="margin: 0;">Stirring bar</p> <p style="margin: 0;">Ink reservoir</p> </div> <div style="text-align: center;">  <p style="margin: 0;">Stirring bar</p> <p style="margin: 0;">Main Ink tank</p> </div> </div> <p>IJ printer for this ink has the function "Automatic stirring" while stopping. This function circulates part of circulation system paths and rotates the stirrer once every 24 hours during IJ printer stopping. To use this function, power must be supplied even while IJ printer stopping.</p> <p>[Note] This function does not do circulation for all circulation system paths. Please refer to "Note for long-term shutdown" and operate IJ printer regularly.</p>		
Manual	UX-P/H	: [Technical Manual]	6.16 Automatic stirring during shutdown

D11	Regular stirring of ink tanks <for yellow inks> *for pouring type IJ printers			
	Target models	Series	Nozzle diameter	Note
		UX	48µm, 65µm(Pigment machine)	Pouring type IJ printers *Information for cartridge type is on "Remark"
	RX2	65µm		
Detail	<p>Pigment with a higher specific gravity than dyes are used for color material, and it tends to settle on the bottom of ink tanks. Please perform following regular maintenance, and remove settle on the bottom of ink tanks. (Compare with pigment for white inks, pigment for yellow inks has light specific gravity) [Noe] Performing this procedure at the time of ink replacement or every 6 months is recommended.</p> <p>① Perform "Ink drainage(*1)". Ink in main ink tank and circulation system is drained. ② Take out ink reservoir, and dispose ink in it. ③ Check settle on ink reservoir. If settle is exist, remove it and clean tank with makeup and wipe paper.</p> <p>[Note] Main ink tank of pigment-machine and UX-H(48µm) can be taken out. If settle is on the bottom, please remove and clean tank also.</p> <p>[Note] If settle is significant, settle may exist on circulation system also. Perform "Process prior to long-term shutdown(*2)", and fill makeup in the IJ printer to wash. Especially, in case of RX2, taking out main ink tank and wash it is difficult, so this procedure may needed. If draining ink by drain tube on main ink tank is not fine, large amount of settle should be exist, and performing "Process prior to long-term shutdown(*2)" is needed.</p> <p>④ Refill new ink to reservoir tank, and perform "Ink refill(*1)". In case of "Process prior to long-term shutdown(*2)" was performed on process ③, perform "Process after long-term shutdown".</p>			
Remark	In case of using yellow ink with cartridge type IJ printer(UX-B/D and etc.), other maintenance and parts replacement is required. Please refer to precaution number [E2].			
Manual	UX2	: [Technical Manual]	(*1) 5.1. Operation and details on circulation (*2) 5.15. Long-term Shutdown	
	UX/RX2	: [Technical Manual]	(*1) 6.1 Circulation control screen operation and contents (*2) 6.16 Long-term Shutdown	

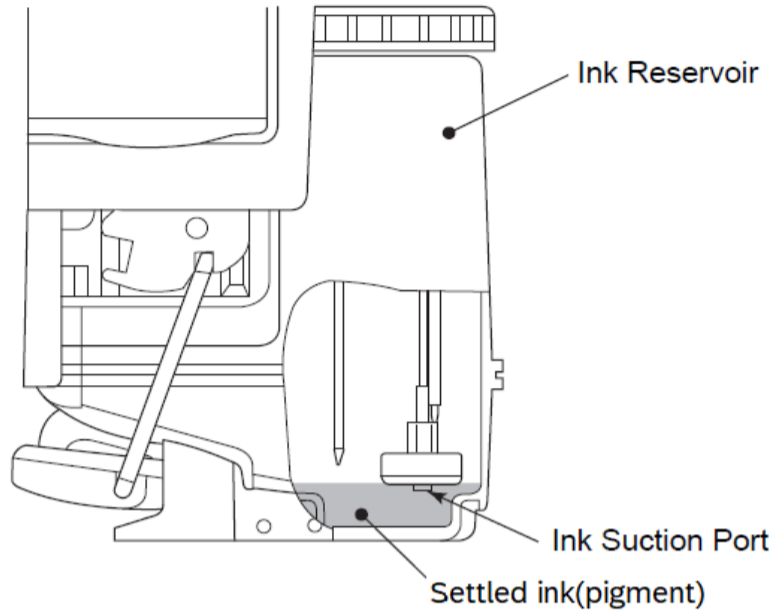
D13	Pigment accumulation in the print head cable <for white and yellow inks>			
	Detail	<p>Pigment as color material may accumulate in print head cable due to that of high heavy specific gravity. To prevent that accumulation of pigment, please perform "Ink circulation" once every month. ※Perform "Ink circulation" to end without interruption. Printing is not available while "Ink circulation" is being performed.</p>		
Manual	UX2	: [Technical Manual]	5.1. Operation and details on circulation	
	UX/RX2	: [Technical Manual]	6.1 Circulation control screen operation and contents	

**E02**

**Regular replacement of ink reservoir tank <for yellow inks> ※for using cartridge type IJP**

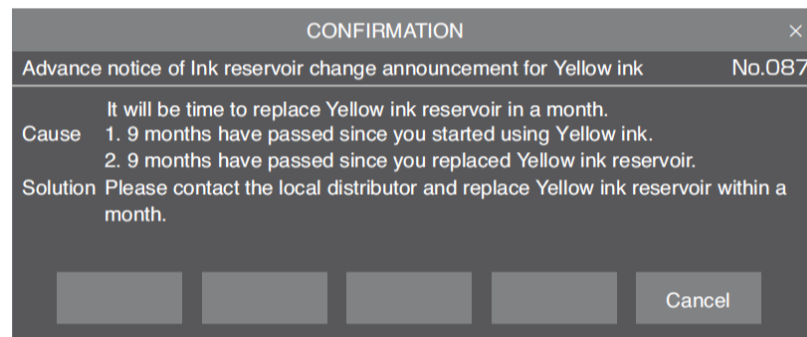
Target machine	Series	Nozzle diameter	Remark
	UX2	65µm	Cartridge type IJP
	UX	40µm, 55µm, 65µm(Dye machine), 100µm	

Detail(1) Ink suction port may clogged due to settled ink(pigment) on the ink reservoir bottom. In case of cartridge type IJ printer(not pouring type IJP), ink tanks cannot be cleaned, so regular replacement of ink tanks every 10 months is required. The following regular announcement will be displayed on the IJ printer screen to inform the replacement timing.



Message displayed

(1) Message displayed from starting to use ink or "9 months" after regular ink reservoir tank replacement



(2) Message displayed from starting to use ink or "10 months" after regular ink reservoir tank replacement



"Ink low fault" will shown on display 30 minutes after the "Ink low warning" is shown.  
 ([Ref] In case of other than yellow inks, "Ink low fault" will shown on display 60 minutes after the "Ink low warning" is shown.)

E02

Detail(2)

Caution

Settling speed depends on use environment, and if it is fast, ink suction port may clogged before regular ink reservoir tank replacement cycle 10 months. In this case, error message will be shown on screen. Please contact our service station in that of situation.

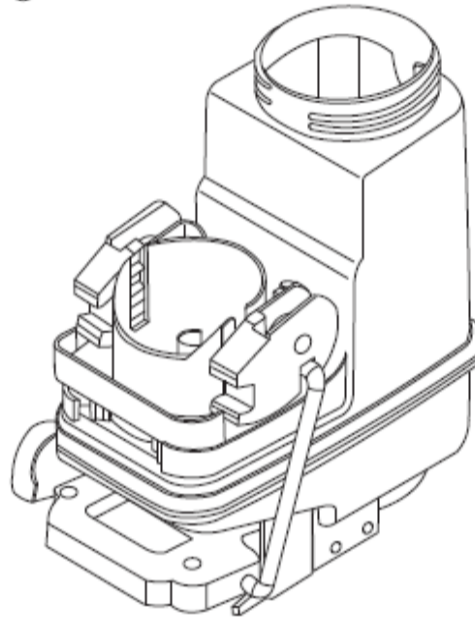
Regular replacement parts

Please replace one of the following parts.

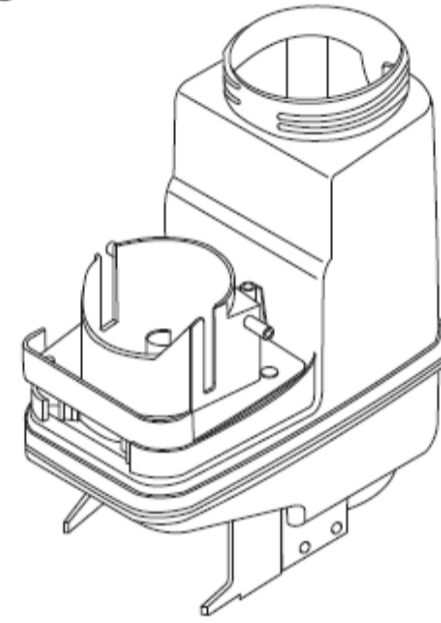
No.	Parts	Order name	Periodical replacement term	Part No.	DWG No.	Replacement Procedure
1	Ink Reservoir	Ink Reservoir UX Parts	10 months after starting use	452002	2N4ZL5219-B	Please contact service station
2	Ink Reservoir	Ink Reservoir Tank (*1)		-	2N4ZL5064-B	

(\*1) This parts does not equip lever and etc. Remove it from the ink tank currently in use and replace it with the new ink tank.

① Ink Reservoir UX Parts purchase form



② Ink Reservoir Tank purchase form



Remark

Considering that using pigment machine(example; UX-P) is recommended. Some yellow inks can also be used with pigment machines. When using with pigment machine, regular replacement of the ink tank (parts) as described above is not required. In addition, since the pigment machine has an automatic stirring function using stirrer, it can be used relatively stably compare with dye machine.

*\*Please see "Available Ink list" to check if the selected yellow ink can be used with pigment machine.*