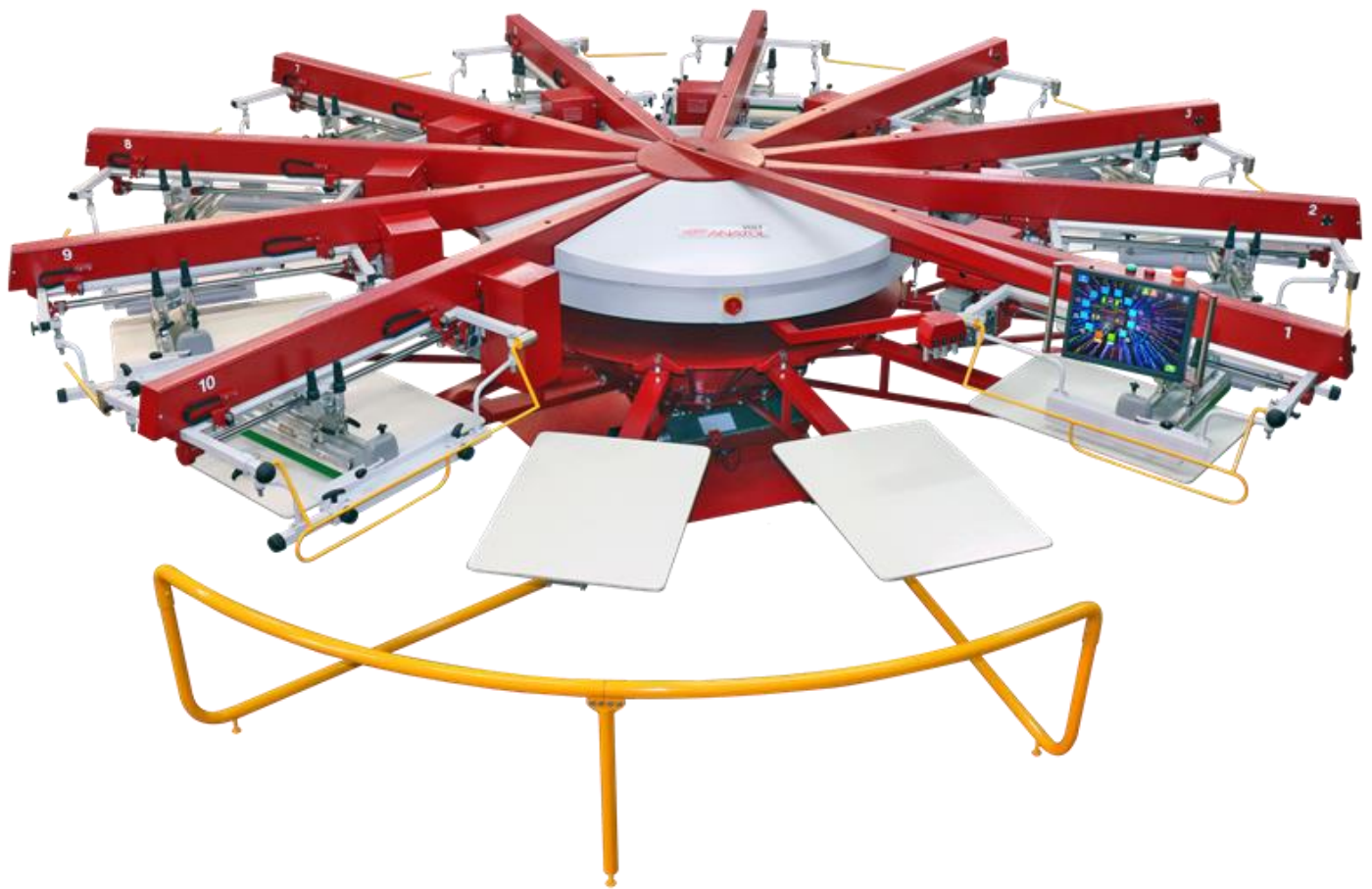# OPERATOR'S MANUAL
VOLT
ARIES OPERATING SYSTEM

ANATOL EQUIPMENT MANUFACTURING CO.
919 SHERWOOD DR.
LAKE BLUFF, IL 60044 USA
PHONE: 847-582-1825
FAX: 847-582-1854

ANATOL EQUIPMENT MANUFACTURING CO.
"Print Smarter…Not Harder"

Thank you for your purchase of the VOLT, a fully automatic screen printing press. The VOLT is controlled from an operator-friendly touchscreen control panel powered by our Aries operating system, allowing the user quick and easy access to all machine parameters.

We at Anatol welcome you to our family and look forward to a long relationship, allowing us to serve your needs now and in the future.

Should you have any questions or equipment service needs, contact our **service department at 847-582-1825** (USA) or +48 85 731-93-00 (Poland) between the hours of 8:00am – 5:00pm CST or fax your inquiry during normal business hours to 847-582-1854 (USA) or +48 85 730-17-79 (Poland). When you call, please have your machine serial number information available so we may assist you quickly.

You may also reach our service department by email at service@anatol.com

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Go to **anatol.com** to view other Anatol equipment and to register your warranty.

Table of Contents

VOLT

Aries Operating System

The main window is divided into several areas:

1. **Lower menu (Page 6)** – a set of buttons for controlling the machine's basic movements

2. **Right menu (Page 8)** – a set of buttons that provides additional machine functionality

3. **Virtual carousel (Page 26)** – illustrates the current condition of pallets and print heads, as well as displays the current machine status and counters

4. **Upper taskbar (Page 37)** – shows the current user, time, job name (if saved) and wireless internet connectivity

More information for each section can be found in the following subsections of this manual.

1. Lower Menu

The lower menu contains all the buttons you need to control the press's basic movements. This menu is closely correlated with the message interface and icon lights located in the center of the Virtual Carousel (see Page 26). Before you begin printing, you will have to perform the following:

Reset
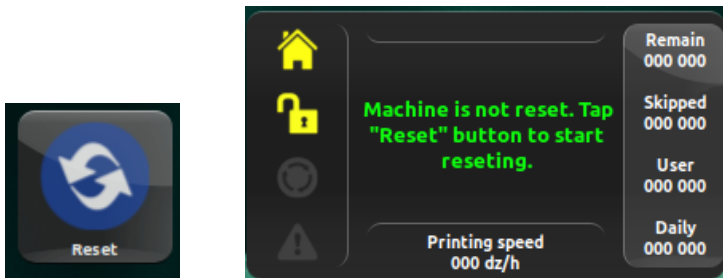
Resetting the machine is necessary after every error message and after starting the machine or receiving an open safety bar warning. Press the Reset button to reset the machine.

Home
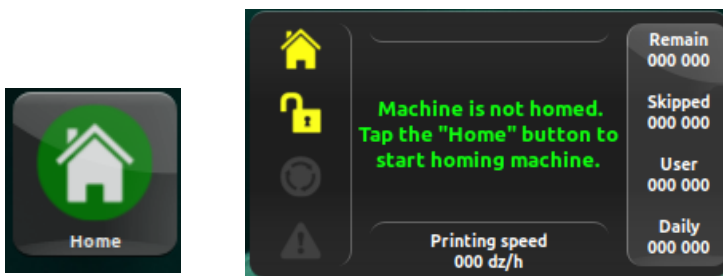
The press will need to be homed every time the press is started and whenever any malfunction or emergency occurs. Press the Home button to move all servos to the home position.

Lock

Bearing   Fork

Unlocked   Locked
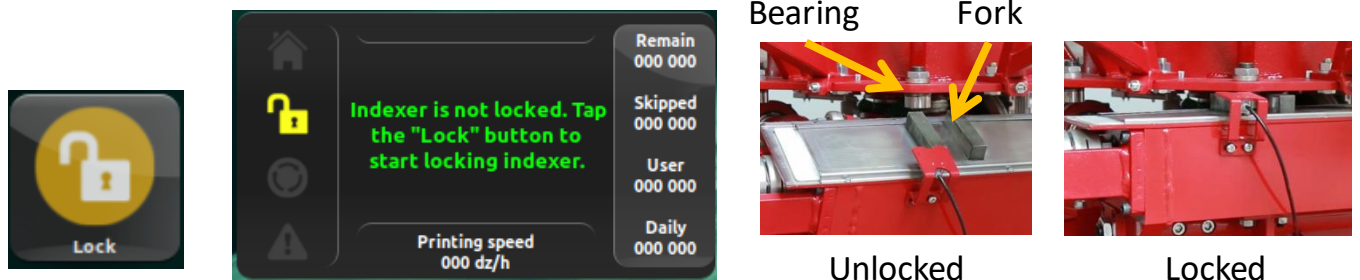
Pressing the Lock button closes, or locks, the indexer. Be sure to set the bearing on the carousel in the right position so it will fit into the fork on the indexer when the indexer moves into the upright, locked position.

When the press is reset, homed and locked, the press is ready for printing and the full lower menu will display, containing the buttons below:

A.   **Clean** – pressing this button will half index the pallets between the print heads, allowing you to clean the underside of the screens when necessary. Pressing the button again will return the pallets to their original positions.

B.   **Index Left** – pressing this button will execute either a full or half index left, depending on the setting of the Full/Half Index switch. (See item 3 below)

C.   **Full/Half Index** – toggle between executing full indexes (moving the pallets from one station to the next) or half indexes (moving the pallets halfway between stations).

D.   **Index Right** – pressing this button will execute either a full or half index right, depending on the setting of the Full/Half Index switch. (See item 3 above)

E.   **Table Up/Table Down** – pressing this button will raise or lower the table for setup purposes.

F.   **Manual/Auto** – switch the machine mode between Manual and Automatic printing. In Manual mode, you need to hit the Print button for every shirt. In Automatic mode, the machine will execute continuous printing until you hit Stop or the Remaining Shirts counter hits zero (if activated - see Page 27).

G.   **Lock/Unlock** – pressing this button will unlock, or open, the indexer. All buttons will disappear from the lower menu and the Lock button will appear. When the indexer is unlocked, or open, Free Wheel mode is enabled, allowing you to rotate the pallet carousel by hand. This is often used for test printing.

H.   **Start/Stop Printing** – pressing this button will begin the printing process. If Manual print is selected, you will have to press the button to begin printing each individual shirt. If Automatic printing is selected, the machine will execute continuous printing until the Stop button is pressed or the Remaining Shirts counter hits zero (if activated – see Page 27).

2. Right Menu
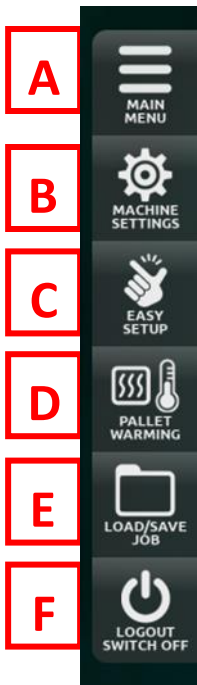
A. **Main Menu (Page 9)** – View the press's maintenance schedule, change language and appearance, change the user PIN code, access advanced settings, enable/disable additional machine functions and modes, and check for/download firmware updates.

B. **Machine Settings (Page 19)** – Adjust the duration of the audible warning beep, change the units that measure the production speed, change the indexing direction, set the lift/lower delay time, enable Cycle and Step Back modes, and adjust the indexer speed.

C. **Easy Setup (Page 20)** – Reduces the off-contact distance to zero and enables the Index Here function to facilitate registration during job setup.

D. **Pallet Warming (Page 23)** – Warm the pallets to a preset temperature for a preset time, or for a preset number of cycles to prepare the pallets for printing.

E. **Load/Save Job (Page 21)** – Save and recall job parameters to help speed up setup times.

F. **Logout/Switch Off (Page 24)** – Change users, enter Presentation Mode, or turn the machine off.

2.1 Main Menu

In the Main Menu, you have the ability to view the press's maintenance schedule (**A**), change the menu language and appearance (**B**), change the user PIN code (**C**), access advanced settings (**D**), enable/disable additional functions and print modes (**E**), and check for/download firmware updates if the machine is connected to Wi-Fi (**F**).

See the following subsections for additional information on each function of the Main Menu.

- Maintenance – **Page 10**
- Language and Appearance – **Page 10**
- Change User PIN Code – **Page 11**
- Advanced Settings – **Page 11, Pages 13-18**
- Access to Functions – **Page 12**
- Firmware Updates – **Page 12**

2.1.1 Maintenance

In the Maintenance window, you will see the press's maintenance schedule. For each maintenance item, you will see after how many cycles you should perform the maintenance, as well as a counter of how many cycles are remaining until the next required maintenance. When you perform the maintenance item, press the **Done** icon to reset the counter.
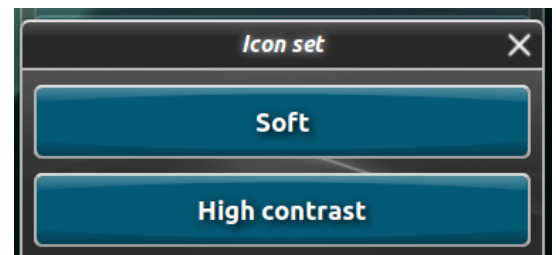

2.1.2 Language and Appearance

In the Language and Appearance window, you have the ability to toggle between Soft and High Contrast icon sets. You can also set the menu language, background color, wallpaper and screen brightness.
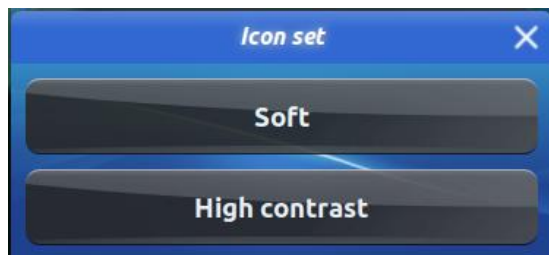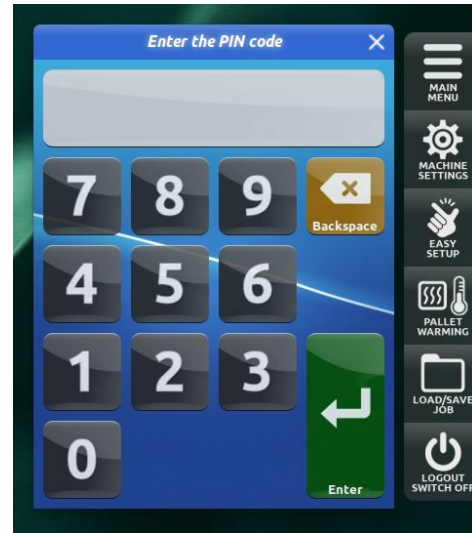

Soft icons

High Contrast icons

2.1.3 Change User PIN Code

In the Change User PIN Code window, you can change the PIN code the current user uses to log in to the machine. **This function is only available to users with Manager or Admin roles (see User Management – Page 16)**.

2.1.4 Advanced Settings

In the Advanced Settings window, you can access advanced Indexer, Lift and Print Head settings. You can also manage the press users, set up automatic email notifications, set the machine to automatically stop after the last t-shirt, toggle temperature units between °F/°C, manage your press's Wi-Fi connection, adjust the current date and time, manage the RS-232 port settings, or exit to the desktop.

The Advanced Settings window is only available to Managers and Administrators (see User Management – Page 16).

For more on the Advanced Settings window, see pages 13-18
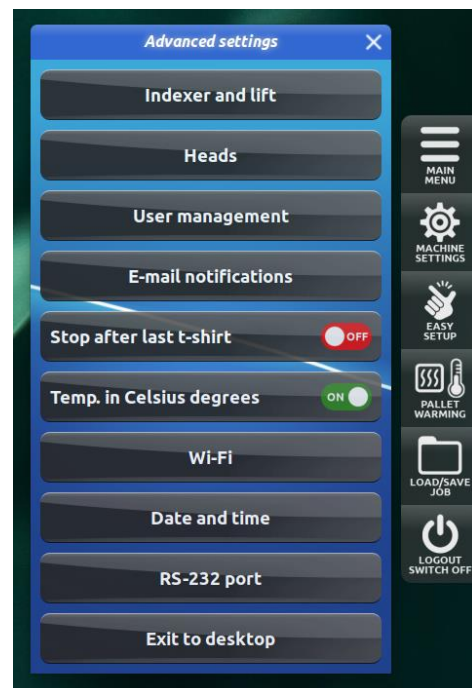
2.1.5 Access to Functions

In the Access to Functions window, you can enable/disable the following functions:

- Step Back Mode (See Page 34)
- Cycle Mode (See Page 35)
- Load/Save Jobs (See Pages 21-22)
- Pallet Warming (See Page 23)
- Flash Warming (See Page 31)
- Setting Ink Colors on the Print Heads (See Page 33)
- Multiprint Table Move (See Page 29)

Only Managers and Administrators have access to the Access to Functions window. See User Management on Page 16.

2.1.6 Firmware Updates

In the Firmware Updates window, you can view the current firmware version, as well as reload the Master PCB and Print Head PCBs, and also toggle automatic firmware updates on/off and check for/download available firmware updates.

If the press is connected to Wi-Fi, you can check for any available updates with the "Check for updates" button. If an update is available and you wish to proceed with the update, you will be prompted to power off your machine and power it back on to install the update. **Allow at least one minute between switching the machine off and on again to give the system time to load the update.**

**Only Managers and Administrators have access to Firmware Updates. See User Management on Page 16.**

2.2 Advanced Settings

In the Advanced Settings window, you can access advanced Indexer, Lift and Print Head settings. You can also manage the press users, set up automatic email notifications, set the machine to automatically stop after the last t-shirt, toggle temperature units between °F/°C, manage your press's Wi-Fi connection, adjust the current date and time, manage the RS-232 port settings, or exit to the desktop.

Each section of the Advanced Settings window is described in more detail in the following pages 14-18

The Advanced Settings window is only accessible to Managers and Administrators. See User Management – Page 16.

2.2.1 Indexer and Lift Settings

Please contact the Anatol Service Department at 847-582-1825 or service@anatol.com before making any changes to the advanced Indexer and Lift Settings. **Making unauthorized changes without the assistance of Anatol Service can cause permanent damage to your press.**

In the Indexer and Lift Settings window, you have the ability to make advanced adjustments to the indexer and lift home and distance offset positions, as well as speed. **Do not adjust these settings without the assistance of the Anatol Service Department. It is also a good idea to take a photo of the factory settings for your own records.**

2.2.2 Number of Heads Setting

Please contact the Anatol Service Department at 847-582-1825 or service@anatol.com before making any changes to the Number of Heads setting. **Making unauthorized changes without the assistance of Anatol Service can cause permanent damage to your press.**

2.2.3 User Management

The User Management menu is where you can add and delete new users for the machine. **This screen is only available to users with Manager or Admin roles – see below.**

A. Toggle on/off the ability to sign the selected user in automatically on machine start-up
B. Displays the name of the current user
C. Opens a keypad to change the current user name
D. Displays the current user role
E. Change the current user's role
F. Displays the current user's PIN code used to log in to the machine
G. Change the current user's PIN code
H. Delete the user
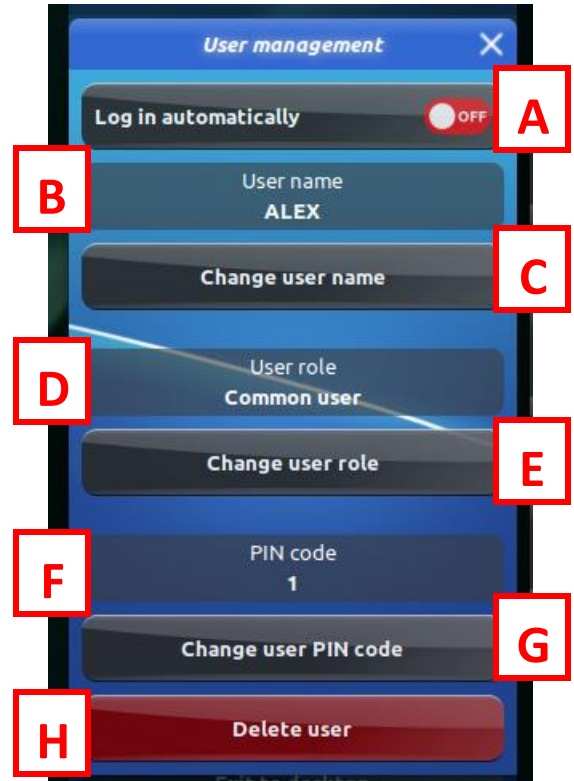
User Roles

Functions not listed in this table are available to all three types of user

| Function	Common User	Manager	Administrator
Change user PIN codes	X	✓	✓
Indexer speed adjustment	X	✓	✓
Advanced settings access	X	✓	✓
User management	X	✓	✓
Email notification setup	X	X	✓
Date and time setup	X	X	✓
Exit to desktop	X	X	✓
Access to functions	X	✓	✓
Firmware updates	X	✓	✓

2.2.4 Email Notifications

In the Email Notifications menu, you have the ability to enter up to three different email addresses to which productivity reports will be automatically delivered whenever the press is powered off, if the press is connected to Wi-Fi. **Only users with Admin permissions can set email notifications – see User Management on Page 16.**

2.2.5 Stop After Last T-Shirt

If you are using the Remaining Shirts counter (see Page 27) to count down the shirts remaining in the print run, you can set the machine to stop printing at the last shirt and display a message informing the operator that it is time to print the final shirt. Do this by toggling "Stop after last t-shirt" to On.
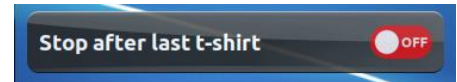
2.2.6 Wi-Fi Connection

In the Wi-Fi connection menu, you can connect the press to your shop's wireless internet network. Locate your shop's Wi-Fi network on the list and enter any required credentials to connect your press to the network.
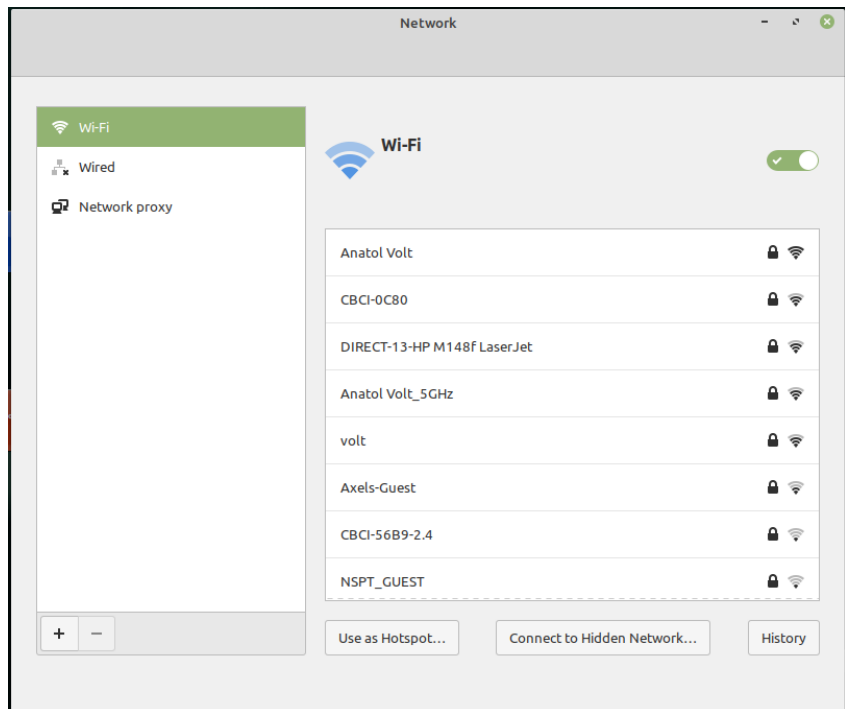
2.2.7 Date and Time

In the Date and Time window, you can set the current date and time displayed on the touchscreen. **Only Administrators have access to the Date and Time screen – see User Management on Page 16. In order to change the Date and Time settings, please contact the Anatol Service Department at 847-582-1825 or service@anatol.com**
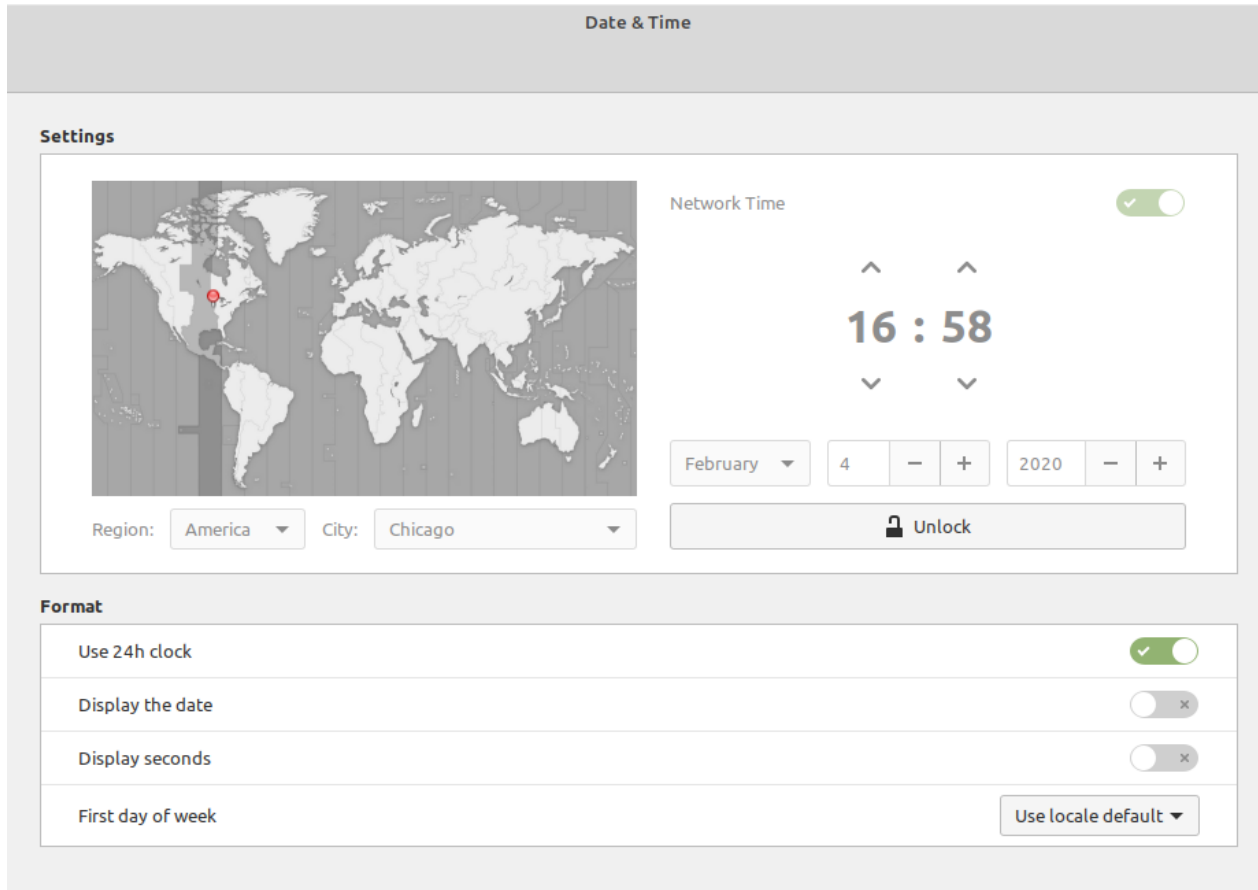
2.2.8 RS-232 Ports

To adjust the RS-232 port settings, please contact the Anatol Service Department at 847-582-1825 or service@anatol.com

2.2.9 Exit to Desktop

Press the Exit to Desktop icon to exit the Aries operating system and go back to the desktop. **Only Administrators have the ability to Exit to Desktop – see User Management on Page 16. Contact Anatol Service at 847-582-1825 or service@anatol.com before exiting to the desktop.**

2.3 Machine Settings

In the Machine Settings window, you have the ability to adjust the duration of the audible warning beep (**A**), change the units used to measure production speed (**B**), change the indexer direction (**C**), adjust the lift (**D**)/lower (**E**) delay time, toggle between Cycle mode, Step Back mode and Regular printing (**F**), and adjust the indexer speed (**G**).

A. Adjust the duration of the audible warning beep from 0-3 seconds
B. Change the units used to measure production speed of the press. View production speed in dozens per hour (dz/h) or pieces per hour (pcs/h).
C. Change the indexing direction from clockwise to counter-clockwise.
D. Set the delay time before the pallets will raise to the Table Up position.
E. Set the delay time before the pallets will lower to the Table Down position.
F. Enable/disable Cycle mode, Step Back mode, or Regular Printing mode. **Only one mode can be active at a time.**
G. Set an indexer speed of slow, regular or fast (**only available for Managers and Administrators – see User Management on Page 16**)

2.4 Easy Setup

Easy Setup mode is used to help you easily prepare your press for a print run. Easy Setup will reduce the off-contact setting to zero and enable the Index Here function to help facilitate registration during setup. The button is located in the right menu. By default, this feature is disabled.

1. To activate the function, press the Easy Setup button. A window will display information about Easy Setup mode. Press "OK" to continue.
2. All counters will be deactivated. The machine is still ready for printing.
3. In Easy Setup mode, the table will raise to a zero off-contact position so the screens can be easily aligned with the artwork on a film positive placed on a pallet underneath, to facilitate registration. When Easy Setup is turned off, the off-contact distance returns to the preset level.
4. When Easy Setup is active, the Index Here button will appear in the Head Settings window.
5. When the machine is operating in any of the print modes (Manual, Automatic or Test mode), the off-contact distance returns to the preset level displayed in the main window.

2.5 Load/Save Job

In the Load/Save Job window, you can save and recall job parameters to help speed up setup times.

In the Save Job window, you can enter the following settings:

- **Job name** – choose a name for the job
- **Customer** – enter the customer's name or company name
- **Quantity** – enter the number of t-shirts to be printed
- **End date** – select the due date for the order
- **T-shirt size** – set the size of the shirts you are printing
- **T-shirt color** – set the color of the shirts you are printing
- **Comments** – leave any additional information that will be helpful to you

If the press is connected to Wi-Fi, you can upload the artwork to the press from your desktop computer. For more information on connecting your computer and uploading artwork, contact Anatol Service at 847-582-1825 or service@anatol.com

In the Load Job window, you can load saved job profiles, rename saved jobs or delete saved jobs.

2.6 Pallet Warming

The Pallet Warming function allows you to preheat your pallets to prepare them for printing. During the warming process, all flashes connected to the machine will operate regardless of their previous settings. This way you do not have to change the machine and flash parameters specifically for preheating.

To activate the Pallet Warming function, press the Pallet Warming button in the right menu.

Temperature Control mode: If at least one flash with a temperature sensor is connected to the press, you can set the exact temperature to which you want to preheat the pallets.
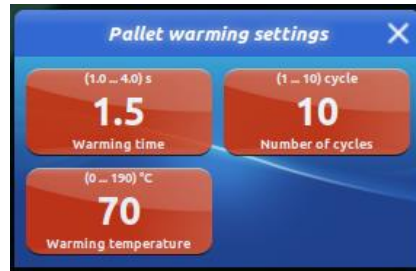
Cycle Control mode: If no flash with a temperature sensor is connected to the press, the pallets will warm for the preset number of cycles.

Whether you are warming the pallets based on temperature or the number of cycles, the common parameter shared between both modes is the time that the pallet is heated. When the Warm Pallets window is open, the machine switches to the "Ready to Warm Pallets" mode. The print head settings buttons become inactive. The prints heads remain disabled and the flash enabled, to ensure that when warming pallets, there is no work done on any print head.

To start the Pallet Warming function, press the Start Warming button. Then the machine will start to rotate. All connected flashes will heat up the pallets for the time set in the Warming Time parameter. The function will recognize the pallet as warm when:
- In **Temperature Control** mode, all pallets reach the preset temperature. If flashes with temperature sensors are connected to the machine, the machine takes into account the sensor readings on the head of the nearest flash station.
- In **Cycle Control** mode, the machine will execute the set number of rotations. One full rotation means that the machine heated each pallet once.
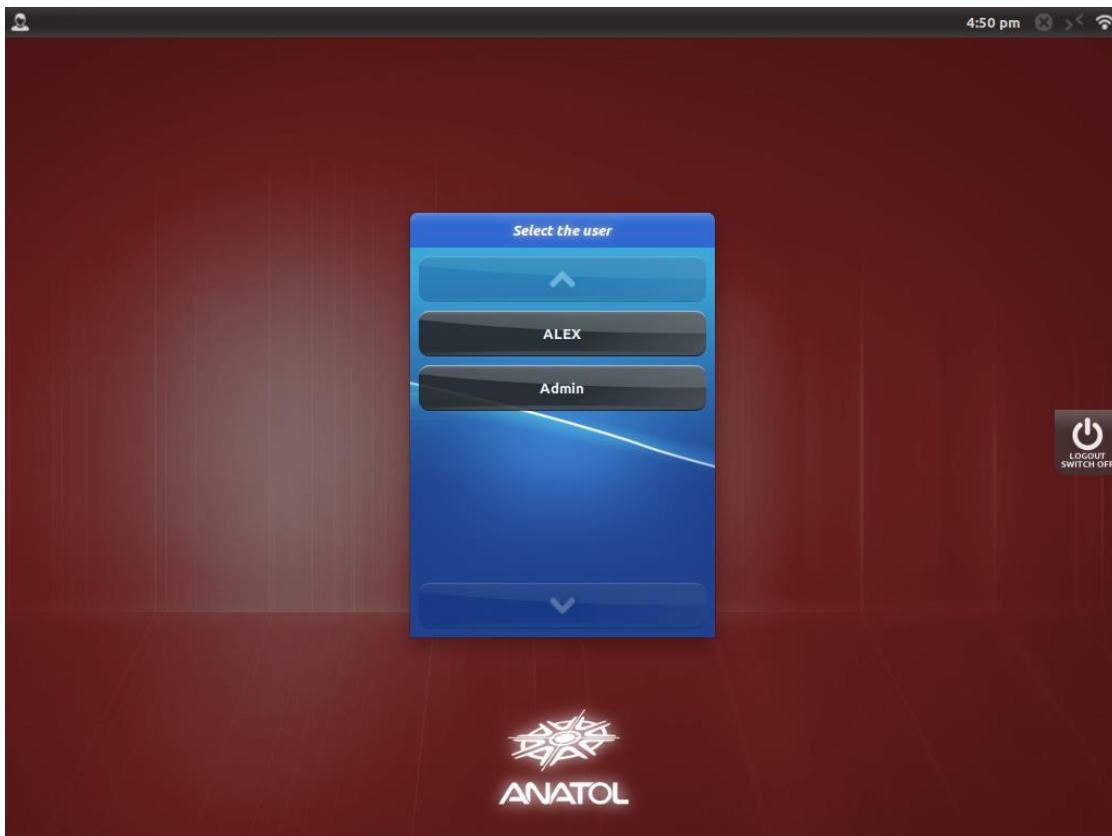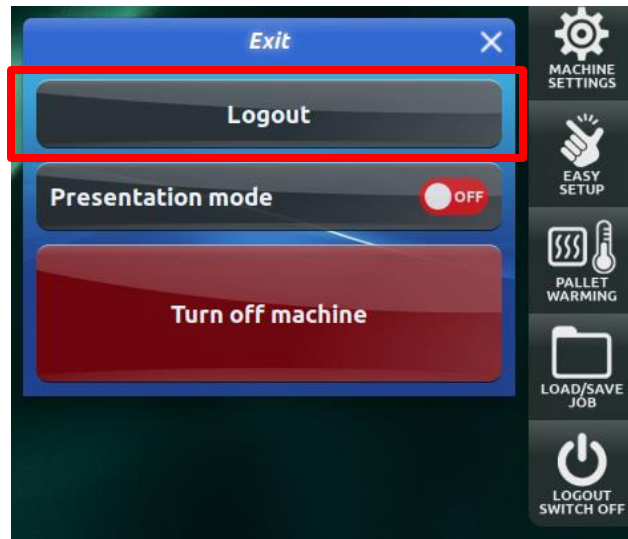
2.7 Logout/Switch Off

In the Logout/Switch Off window, you can sign out of the current user account and switch users. You can enable Presentation Mode to connect your machine to the Anatol Service Department for remote diagnosis and troubleshooting (if the press is connected to Wi-Fi). From the Logout/Switch Off window, you can also turn the machine off.

2.7.1 Logout

Select Logout to change users. Select the new user from the list. If a PIN code is set for the new user's account, you will be prompted to enter the PIN code before logging in.

If you cannot remember your PIN code, please contact the Anatol Service Department at 847-582-1825 or service@anatol.com

2.7.2 Presentation Mode

Entering Presentation Mode allows you to connect your machine to the Anatol Service Department for remote diagnosis and troubleshooting of press issues, as well as help accessing settings and functions of the machine.

When you have an issue with your machine, call the Anatol Service Department at 847-582-1825. To help diagnose the issue with your press, you can toggle Presentation Mode on and you will be provided with an ID code. Giving this ID code to the Anatol Service Department allows the service technician to access the touchscreen control panel of your press to help identify error messages and assist with troubleshooting.

When the Anatol Service Department is accessing your machine, you will see a TeamViewer icon displayed on the touchscreen. You can disconnect from the screen share at any time.
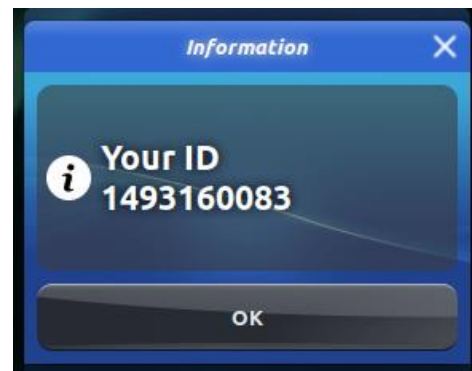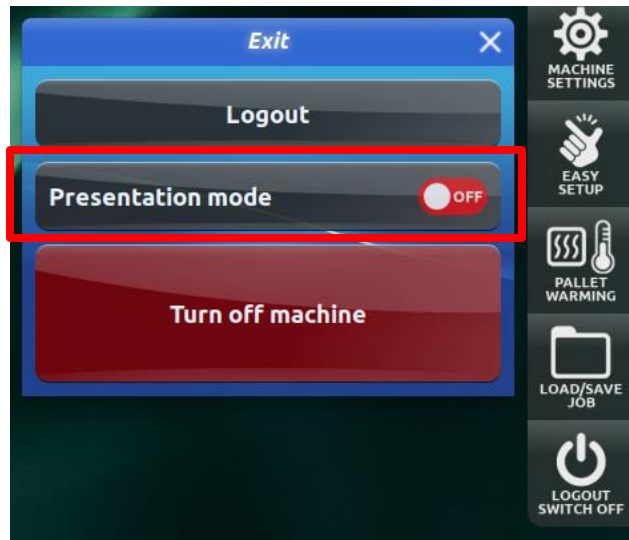
To contact the Anatol Service Department:

USA
847-582-1825
service@anatol.com

International
+48 85 731-93-00
speservice@spe.home.pl
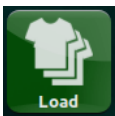
3. Virtual Carousel

The Virtual Carousel is a visual representation of the press, including the current state of the pallets and print heads.
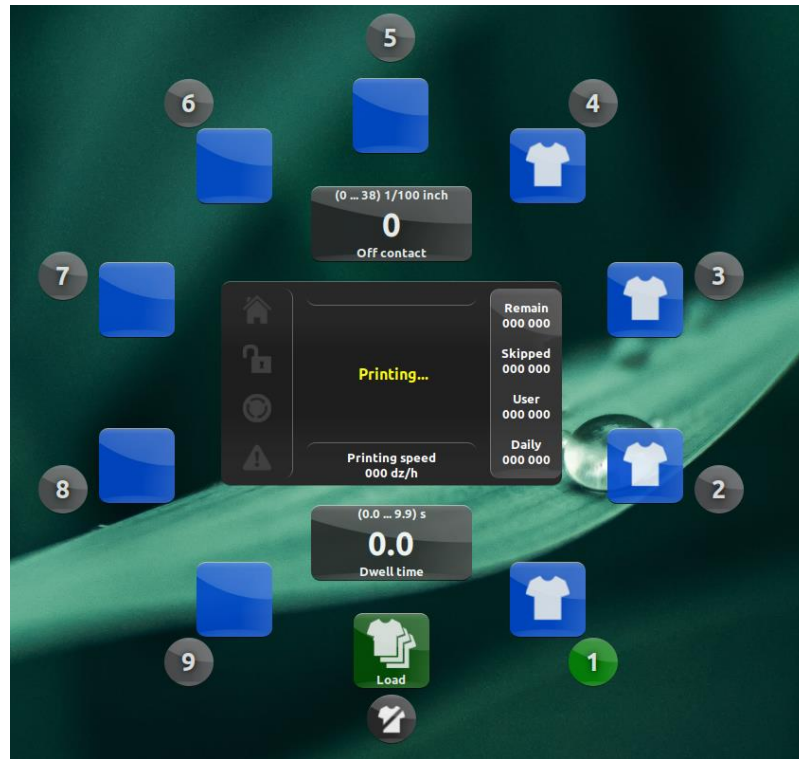
1. **Clear Info** – Clear the shirt info from the pallet icons

2. **Load/Unload** – For machines with a single load/unload station, this station will be represented by a green icon. For machines with separate loading and unloading stations, the load station will be represented by a green icon and the unload station will be represented by a red icon.

3. **Head Settings** – Pressing the Head Settings button will open the Head Settings window where you can set the parameters for that print head.


4. **Station (Pallet) Icon** – Represents a station (pallet) on the machine. Blue icons indicate pallets at print stations, orange icons indicate pallets at flash stations, and purple icons indicate pallets at cooling stations.


5. **Dwell Time** – Set the dwell time, or the delay between indexes, from 0 seconds to 9.9 seconds. Increasing the dwell time will give the operator more time to load and unload shirts.
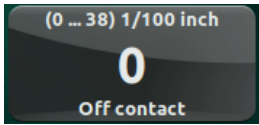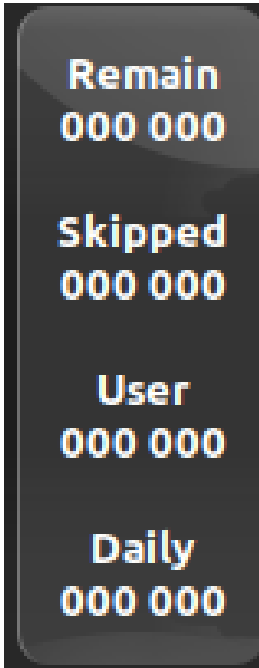
6. **Off-Contact** – Adjust the off-contact distance, or the distance between the pallet and the underside of the screen. Anatol automatic presses are equipped with **central off-contact**, which means you can set one off-contact distance across all print heads.
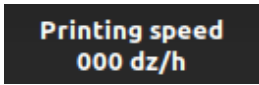
7. **Printing Speed** – Displays the production speed in your choice of units: dozens per hour (dz/h) or pieces per hour (pcs/h).

8. **Remaining Shirts** – Displays a countdown of the remaining apparel to be printed. Pressing in the Counters window allows you to set the remaining shirt counter.

9. **Skipped Shirts** – Displays the number of shirts skipped (Skip Shirt button is pressed). This counter will reset when the machine is powered off and on again, or when the counter is cleared manually.

10. **User Counter** – Displays the number of shirts printed while the current user is signed in. The counter will reset when the machine is powered off and on again, when the current user is signed out, or when the counter is cleared manually.

11. **Daily Counter** – Displays a running total of shirts printed until the Daily Counter is reset manually.
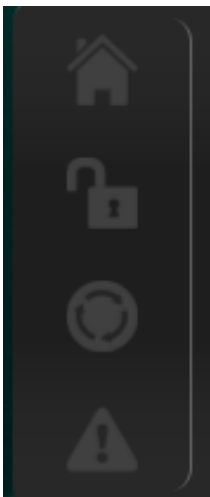
12. **Icon Lights** – Lights indicating the homing status of the machine, the indexer lock/unlock status, the status of the E-Stop button, and the status of the safety bars.
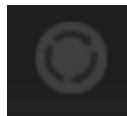
Homing
Yellow: Machine must be homed
Flashing: Machine is homing
Grey: Machine is homed

Indexer Locking
Yellow: Indexer is unlocked
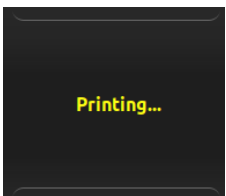Flashing: Indexer is locking
Grey: Indexer is locked

Emergency Stop
Red: E-Stop is pressed
Grey: E-Stop is released

Safety Bars
Red: A safety bar is open
Grey: Safety bars are closed

13. **Message Window** – This window displays messages informing the operator of the current state of the machine, including commands to execute and error messages.

3.1 Station (Pallet) Icons

The stations, or pallets, on the press are represented in the Virtual Carousel by square shaped icons in different colors representing the different types of stations.

Load Station

The Load station is depicted by a green pallet icon. On machines with a single station for loading and unloading (an 8 station/7 color machine, for example), this icon represents the single station used for both loading and unloading shirts. By default, the icon is **blank**, indicating no shirts are being loaded. An icon with a **single shirt** indicates you will be printing a single shirt (test printing or printing the final shirt of a print run, for example). An icon with **multiple shirts** indicates you will be loading shirts on the press continuously.

Unload Station

The Unload station (if present) is depicted by a red pallet icon. The red icon will only display on machines with two separate stations, one for loading and one for unloading (an 8 station/6 color machine, for example).

Print Station

The Print stations are represented by blue icons, representing the pallets under the print heads on the machine.

If the option to set the ink color on the print head is enabled, you will see a circle containing that color in the upper right corner of the Print Station icon. (**Left** – an icon indicating black ink is being printed at this station)

Flash Station

Stations used for flash curing are represented by orange icons. The type of flash (Quartz = **QZ**, Infrared = **IR**) will display in the lower right corner. For flashes with temperature sensors, the current temperature will display in the center of the icon. **SB** indicates Step Back mode is active. **PH** indicates Preheating is enabled. **T1/T2** in the lower left indicates whether Drying Time 1 or Drying Time 2 is selected.

Cooling Station

Stations used for cooling are represented by purple icons. You may choose to use a station for cooling after flashing a layer of ink.

3.2 Head Settings

In the Head Settings window, you can activate/deactivate the heads on the machine, as well as indicate whether they are print heads, flash heads or cooling stations. Assign the type of head by pressing the Head Type icon.

3.2.1 Print Head Settings

When you assign the head type as a Print Head, the Print Head Settings window will display. In the Print Head Settings window, you can set the parameters for a print head.
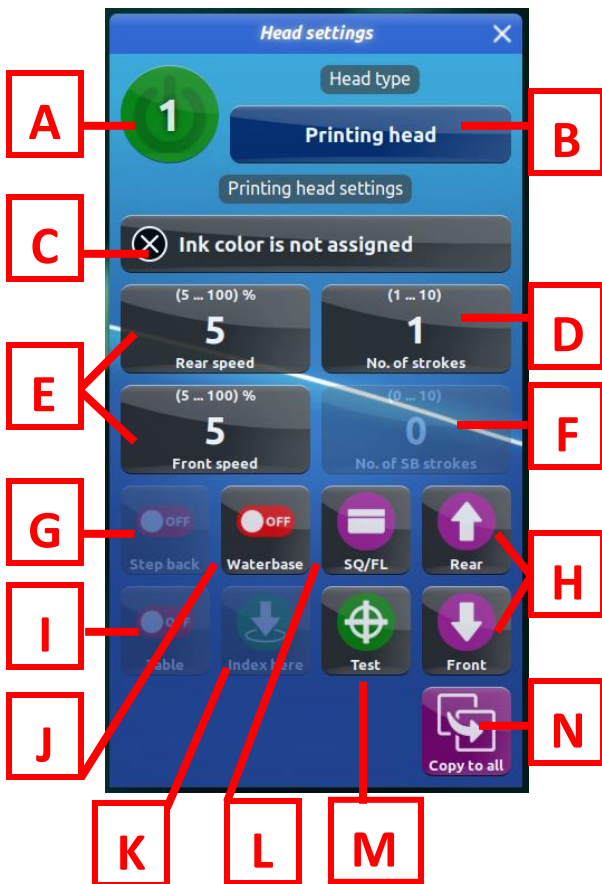
A. Activate/deactivate the head (green icon means active)

B. Select the type of head: Printing, Flashing or Cooling

C. Assign the ink color to be printed on the head (must be enabled in Access to Functions menu – see Page 12)

D. Select the number of strokes (1-10)

E. Set the front and rear stroke speed (5-100%)

F. Set the number of strokes after step back during Step Back mode (if active)

G. Toggle Step Back mode on/off (must also be enabled in Access to Functions menu)

H. Move the carriage to the front or rear position

I. Multiprint Table Move. When enabled via the Access to Functions menu and toggled on, the pallets will table down during the flood stroke between print strokes when multiple strokes are selected.

J. Select water-based or plastisol ink. Selecting water-based will have the machine perform an extra flood stroke after the print stroke.

K. Index Here moves the shirt to the selected print head (only available when Easy Setup mode is active)

L. Raise or lower the squeegee and flood bar

M. Perform a test print

N. Copy the settings to all print heads

3.2.2 Flash Head Settings

When you assign the head type as any Flash Head (**Quartz Flash without Temperature Sensor, Quartz Flash with Temperature Sensor or Infrared Shuttle Flash**) , the Flash Settings window will display. In the Flash Settings window, you can set the parameters for a flash head.
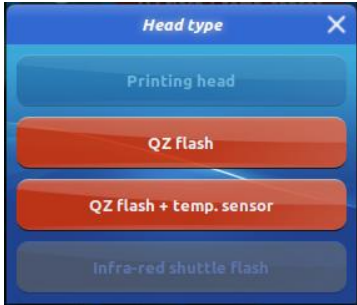
The flash sockets on a Volt press are located on the print heads. Insert the plug into the socket and tighten it. Be sure to protect the cables so they do not come into contact with any moving parts of the press. This could damage the machine. Quartz flashes are automatically detected by the machine when they are plugged in to the print head.

Remember to set the flash height correctly to avoid damaging the unit or the items being flashed. After connecting and securing the power cables, start up the device. Rapid Wave quartz flash cures have a Plug and Heat function. This means that they are automatically detected when attached to a Volt press. On the press control panel, the head to which the flash is attached will automatically change to Quartz. To open the flash settings window, press the settings button associated with the head to set the parameters for that flash cure unit.

A. Quartz Flash without Temperature Sensor

A. Activate/deactivate the head (green icon means active)

B. Select the type of head: Printing, Flashing or Cooling. You can choose between Infrared and Quartz flashes (with or without temperature sensor).

C. Set Drying Time 1 (0-30 seconds)

D. Set Drying Time 2 (0-30 seconds)

E. Set the Step Back Drying Time (if Step Back mode is active) (0-30 seconds)

F. Set the Drying Power (0-100%)

G. Toggle between Drying Time 1 and Drying Time 2

H. Test the flash

I. Index Here (when Easy Setup mode is active)

J. Set the flash warming time (if enabled)

K. Toggle Step Back mode on/off

L. Enable/disable flash warming (see next page)

M. Toggle flash preheating on/off

N. Copy these settings to all heads
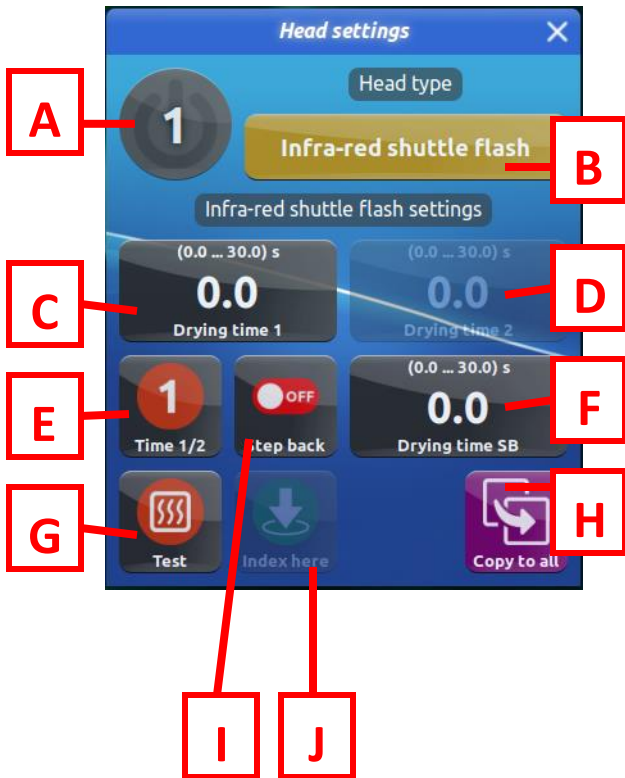
B. Quartz Flash with Temperature Sensor
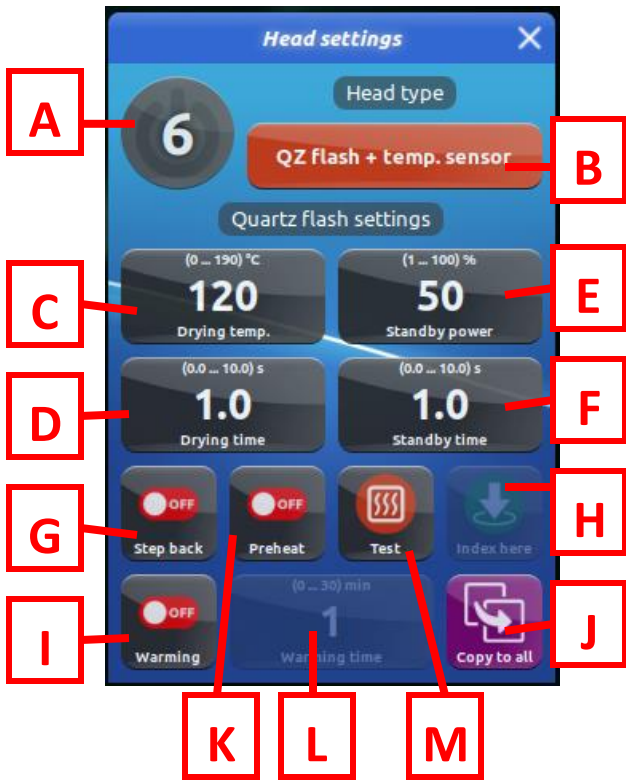
A. Activate/deactivate the head (green icon means active)
B. Select the type of head: Printing, Flashing or Cooling. You can choose between Infrared and Quartz flashes (with or without temperature sensor).
C. Set the temperature of the flash
D. Set the time for which the flash should maintain the set temperature
E. Set power level for additional standby flashing, in addition to the set time and temperature in the Drying temp/Drying time parameter
F. Set the duration of the additional standby flashing, in addition to the set time in the Drying time parameter
G. Toggle Step Back mode on/off
H. Index Here (if Easy Setup mode is enabled)
I. Toggle flash warming on/off
J. Copy these settings to all heads
K. Toggle preheating on/off (flash will activate when machine begins index, instead of when pallet is under the flash)
L. Set the flash warming time (if warming is active)
M. Test the flash

Flash Warming

When you pause a print run, you may want to keep the flashes warm to ensure a thorough cure when you resume the job. Enabling flash warming allows you to set a warming time of 0-30 minutes to keep quartz flashes warm while the press is stopped.

Keep in mind when adjusting Drying Power parameters in the Flash Head Settings window - **the flash intensity is also controlled by the knob on the flash unit itself.** So if the knob on the flash is set to 50% power and the Drying Power parameter on the touchscreen is set to 50% power, the flash is operating at 25% power. If the knob is set to 100% power and the Drying Power parameter on the touchscreen is set to 50% power, the flash is operating at 50% power, etc.

C. Infrared Shuttle Flash

A. Activate/deactivate the head (green icon means active)

B. Select the type of head: Printing, Flashing or Cooling. You can choose between Infrared and Quartz flashes (with or without temperature sensor).

C. Set Drying Time 1 (0-30 seconds)

D. Set Drying Time 2 (0-30 seconds)

E. Toggle between Drying Time 1 and Drying Time 2

F. Set the Step Back drying time (if Step Back mode is enabled)

G. Test the flash

H. Copy the settings to all heads

I. Toggle Step Back mode on/off

J. Index Here (if Easy Setup mode is enabled)

3.2.3 Setting the Ink Color on the Print Head
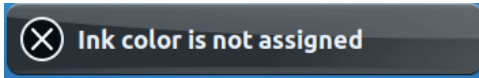
1. Open the Print Head settings window by clicking on the circular icon in the Virtual Carousel representing a print head.
2. Press the "Ink Color is Not Assigned" icon. If you cannot find this button, make sure "Ink Colors" is toggled on in the Access to Functions section of the Main Menu (see Page 12).
3. The Ink Color Space window appears. Here you have the ability to set the ink color in RGB, CMYK or Pantone formats. You can also unassign a previously assigned ink color from the selected print head.

A. RGB/CMYK
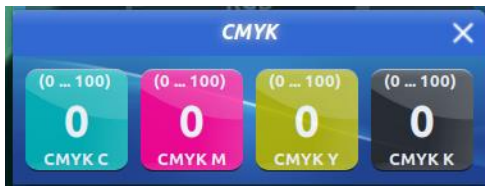
1. To select the color of the ink in each component field, enter the appropriate values to get the desired color.
2. To enter a value, click on the selected field. A numeric keypad will appear on the screen. Input the desired value and press Enter.
3. Follow the same procedure for each RGB or CMYK field.
4. The Color Selection window will close by clicking anywhere outside the menu area.

B. Pantone

1. To select a color, choose a name from the list of available colors. The list contains over 1000 colors available in the Pantone pallet.
2. Select the desired color in the list by clicking on the corresponding icon.
3. Confirm your choice with the OK button. The list window will close and the selected ink color will display in the Select Ink Color dialog box.
4. The Color Selection window will close by clicking anywhere outside the menu area.
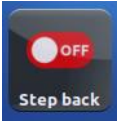
4. Step Back Mode

After activating Step Back mode in the Access to Functions window (see Page 12) and toggling the function on in the desired Flash Head and/or Print Head Settings windows, it is possible to program the machine so that the pallet indexes back to the previous head. This enables you to cure multiple colors or multiple layers of the same color with one flash.

There are two variations of Step Back mode:

- **Step Back** – allows you to print on Head 1 > flash on Head 2 > return to Head 1 to print > flash again on Head 2 > move on to Head 3 and continue

- **Multi Step Back** – combines multiple steps back: print on Head 1 > flash on Head 2 > return to Head 1 to print > flash again on Head 2 > print on Head 3 > step back to Head 2 to flash > move on to Head 3, Head 4, etc.

You can only step back one station. For example, you could not step back from printing on Head 4 to flashing on Head 2.
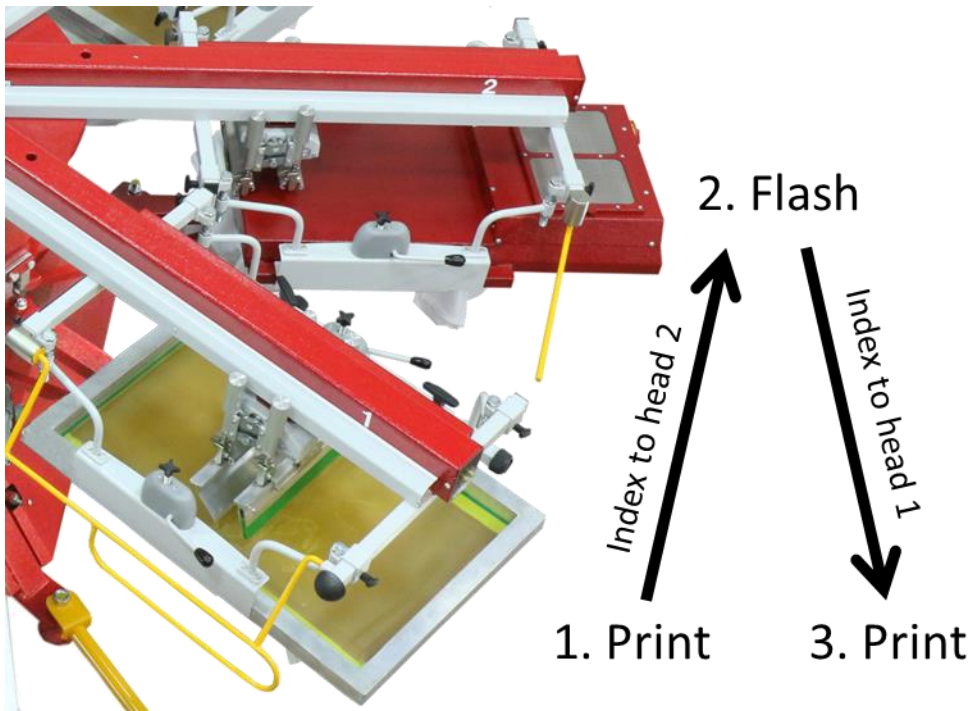
5. Cycle Mode
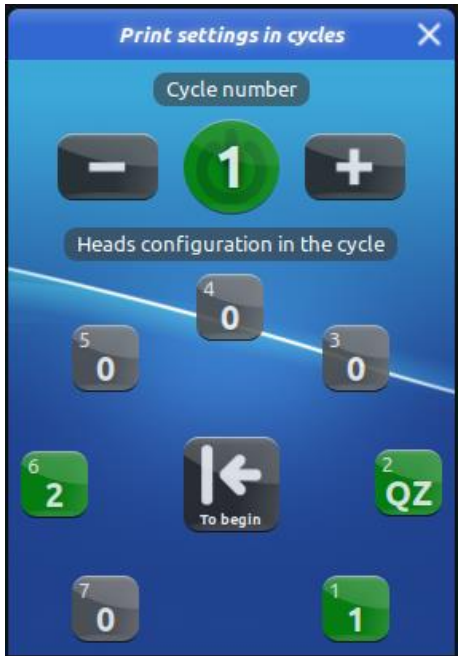
When Cycle mode is selected in the Access to Functions window (see Page 12), a Cycles button is displayed in the right menu. When this button is pressed, a window opens where you can program up to 8 different work sequences.

The cycle number (1-8) is displayed in the top center of the window inside the ON/OFF button. Press the ON/OFF button to turn on individual cycles (green=on, grey=off). Use the + and – keys to toggle between cycles.

Similar to the Virtual Carousel display, there are icons representing each print head on the machine. In the middle of the head icons, there is a button labeled "To begin" that you can use to accept the current cycle settings, before moving on to the setup of the next cycle.

In each cycle you can select the heads you want activated during that cycle.

- Select the flash heads by pressing the button corresponding to the number of the head on which the flash is mounted. If the icon is grey, it means the head is not activated in this cycle. A green icon with QZ or IR indicates the flash head is active.
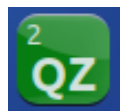
 Head 2 is a Quartz flash

 Head 5 is an Infrared flash

- Select the print heads by pressing the buttons corresponding to the number of the heads. You need to set the number of print strokes that you want each print head to perform – this number is displayed inside the head icon. Press the head icon to open a window where you can set the number of strokes you want the selected head to perform. If the number is greater than 0, the icon will switch from grey to green, indicating that head is active during this cycle. If you want the print head to remain inactive, leave the number of strokes at 0.
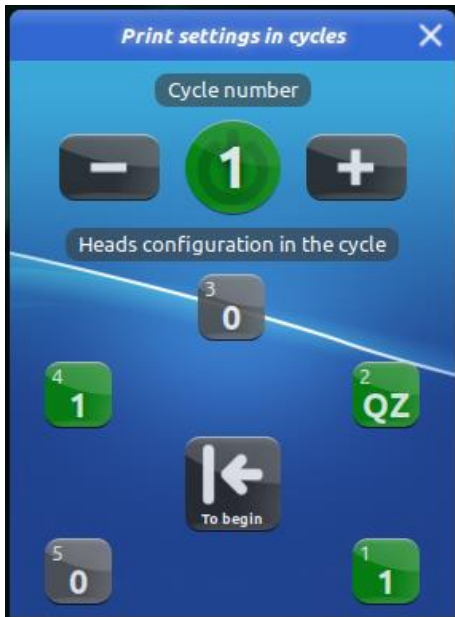
 Head 1 will print one stroke

 Head 3 is inactive and will print zero strokes

 Head 6 will print two strokes

One cycle is one full rotation of the carousel, where the shirts are printed according to the operator's choice of heads and flashes. The cycle will be repeated for as many shirts as the number of pallets on the machine. You can program the machine to perform up to 8 different cycles.

When the first shirt completes all the active cycles, the machine will stop and beep. Unload the finished shirt and press the Start button again to finish printing the remaining shirts.

In the example to the left we have two cycles set up:

- In **Cycle 1**, Head 1 will print one stroke, Head 2 will quartz flash, then Head 4 will print 1 stroke. Heads 3 and 5 are inactive.

- In **Cycle 2**, Head 2 will quartz flash, then Head 5 will print one stroke. Heads 1, 3 and 4 are inactive.
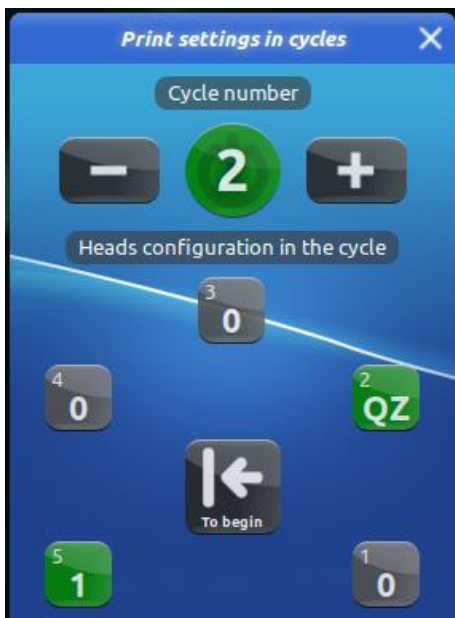
Just like in regular printing mode, you will tell the machine whether you will load a single shirt (for test printing, for example) or you will be loading shirts continuously. Indicate this by pressing the Load station icon in the Virtual Carousel (see Page 26)
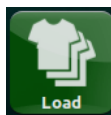

In this example, we will be loading shirts continuously. We can use the Dwell Time button to set a delay time from 0-9.9 seconds between indexes, to allow the operator more time to load and unload shirts.

When the first shirt has completed all active cycles - in this example Cycle 1 and Cycle 2 - the machine will stop and beep to let you know the first shirt is finished. Unload the completed shirt, load a new shirt on the now empty pallet and hit Start. The new shirt will enter Cycle 1 while the shirts remaining on the machine finish Cycle 2. As you take the rest of the finished shirts from the first load off the press and load new shirts in their place, the new shirts will begin Cycle 1. When the first shirt of the second load finishes both cycles, the machine will stop and beep again to let you know the first shirt of the second load is finished. Continue the process for as many shirts as you need to print. Press Stop when you are finished printing all the shirts.

6. Upper Taskbar

Admin   Sample Job 1   5:02 pm
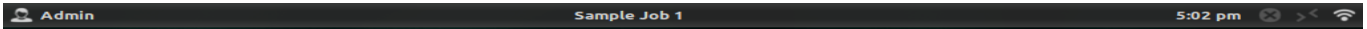
In the Upper Taskbar at the top of screen, you can see the following information:

- The current user signed in to the machine
- The name of the current job (if saved)
- The current time
- The Wi-Fi connection status
- If Demo Mode is active, the X icon will display here. If your press starts in Demo Mode, contact the Anatol Service Department at 847-582-1825 or service@anatol.com