

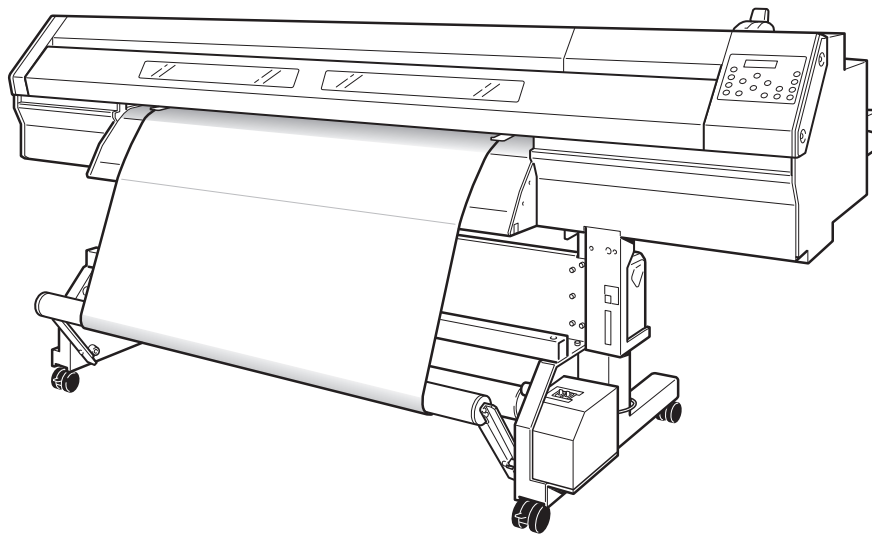
# ***XC-540MT***

## **SPECIAL COLOR INK GUIDE**

### **(Metallic Silver & White)**

**When using metallic silver ink and white ink, be sure to read this first.**

This document describes the characteristics of special color inks (white ink and metallic silver ink) used with XC-540MT, important notes, maintenance, and printing method using these inks. For other matters, refer to the XC-540/XC-540MT Setup Guide and the XC-540/XC-540MT User's Manual.



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# **Chapter 1**

## **Getting Started**

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# 1-1 What This Document Assumes and Related Manuals

## What This Document Assumes

Before performing any operations described in this guide, make sure that all the following preparations are complete.

- Assembling and installing the XC-540MT unit
- Installing VersaWorks on your computer, and connecting the computer to the XC-540MT via a network

## Related Manuals

Read the following documentation for information about setting up the XC-540MT unit and VersaWorks.

### (1) Setup Guide

This manual covers details about how to use the XC-540MT, including how to set up the printer and where to locate the printer, etc. Be sure to read this manual.

### (2) User's Manual

This manual describes operation methods in detail. After you've read the XC-540MT Setup Guide, be sure to read this manual.

### (3) VersaWorks Quick Start Guide

This manual explains basic operations of VersaWorks, including how to set up the program. Be sure to read Chapter 1 of this manual and make necessary setups on your computer. It is also recommended to read Chapter 2 of this manual and become familiar with how to use this program.

## VersaWorks Online

This document describes the important notes for using the metallic silver ink and white ink as well as the basic printing method. You can get the latest information about Roland VersaWorks and the information on printing methods requiring more complex settings by viewing VersaWorks Online.

If you want to learn more about the features of Roland VersaWorks, or if you want to use metallic silver ink and white ink more effectively, be sure to visit VersaWorks Online.

**URL:** <http://dg4.roland.co.jp/en/RVW2forWeb/index.html>

# 1-2 Before Starting Operations

## Important: Characteristics of Inks and Important Notes

The usage and handling of white ink and metallic silver ink involve some important considerations that do not apply to ink of other colors.

Be sure to familiarize yourself with the characteristics of inks before you use it.

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### White ink and Metallic Silver ink settle and separate.

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- If it is allowed to stand, the precipitated material may solidify and cause clogging of the print heads or other malfunction. Be sure to observe the cautions in this manual.

---

### Maintenance must be performed.

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- Always keep the main power switched on. If the main power is switched off, the automatic maintenance function stops working, and may result in malfunction.
- We recommend operating the printer at least once a week.
- If the printer is left unused for a long period of time, ink precipitation may occur, resulting in an incorrect ink discharge such as occurrence of dot drop-out. In such cases, the precipitated and solidified ink needs to be discharged. This work requires two SOL INK cleaning cartridges. For how to perform the work, refer to the description below.

☞ P. 64, "When Dot Drop-out etc. Cannot be Corrected"

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### Drying inks

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- After output, allow the ink to dry sufficiently. Note that white ink and metallic silver ink in particular require printing at a high density, and so are more difficult to dry than CMYK inks.
- Use an auxiliary drying unit (DU-540).

---

### We strongly recommend performing lamination.

---

- Depending on conditions, the weatherability of metallic silver ink and white ink may be inferior to that of CMYK inks. Therefore, laminating is strongly recommended.
- Maintenance requires two SOL INK cleaning cartridges, so be sure to have these on hand.

## Before Starting the Day's Work

- **Remove just the white and metallic silver ink cartridges, shake them gently, then reinsert them.**
- **The cyan, magenta, yellow, and black ink cartridges do not need to be shaken every day, but new cartridges for these colors should be shaken when you install them.**

The ingredients in white and metallic silver ink tend to settle. Each day, before starting the day's operations, be sure to carry out the above steps. Allowing the ink to stand without carrying out these steps can cause the settled material to harden, resulting in malfunction or other problems.

# 1-3 Important Notes on Printing

## When Performing Pullback Printing

### What is Pullback Printing?

Pullback printing refers to a printing method in which the white-ink (or metallic silver ink) undercoat is printed first, and then CMYK color is printed on top of white ink (or vice versa); in the process, the already printed media is pulled back to the original position once, and then overprinting is performed.

### Allow the ink to dry thoroughly.

- Dry the ink sufficiently before you perform pullback printing with the next color. Performing pullback printing before the ink has dried enough may make attractive printing impossible or cause problems such as reduced weatherability.
- Drying time differs according to various conditions, but as a general guide you should use an auxiliary drying unit (DU-540) and also allow the media to stand for an additional 15 minutes.
- In particular, when you're pullback printing a white or metallic silver undercoat with CMYK inks, allow the undercoat to dry thoroughly before you overprint it. If the undercoat is not dry enough, differences in dryness may cause variations in the overprinted CMYK colors.

### Using the middle pinch rollers

- The middle pinch rollers may smudge the printed surface when the media is pulled back. When you perform pullback printing, we recommend securing the media in place using only two pinch rollers (one on the left and one on the right).

### Never use the media take-up system


- Performing pullback printing requires pulling the media back, and so the take-up unit cannot be used.

## When Using Transparent Media

### Loading transparent media

- Set the [EDGE DETECTION] menu item to "DISABLE". Transparent media cannot be loaded unless this setting is made.
- Ensure a margin of at least 75 mm from the leading edge of the media to the printing- or cutting-start location.

Important notes on the amount of media remaining

- When you use transparent media, the presence of media cannot be detected. In such cases, printing operation does not stop when the media runs out, and there is a chance that the platen or the like may become soiled by ink or that ink may get inside and damage the machine.
- If media runs out while printing is in progress, immediately press  to quit printing.



---

### **Using the middle pinch rollers**

---

- The middle pinch rollers damage media slightly, and on transparent media this damage can be very noticeable. If such damage is a concern, we recommend securing the media in place using only two pinch rollers (one on the left and one on the right).

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### **Automatic crop-mark detection**

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- Automatic crop-mark detection may not be possible for some media, such as transparent media. In such cases, perform alignment manually.



# Chapter 2

## Getting Ready

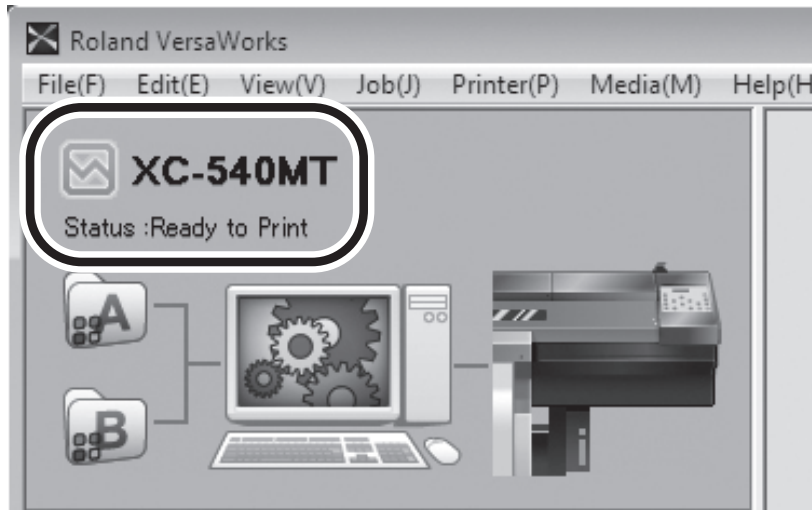
---

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# 2-1 Preparing VersaWorks

## Starting VersaWorks

On the computer you're using, start VersaWorks. For information on how to start the program, see the Roland VersaWorks Quick Start Guide. After starting the program, go to the upper left of the main screen and check to make sure that "Model (or Nickname) of Your Printer" is displayed, and that "Status" is set to "Ready to Print."

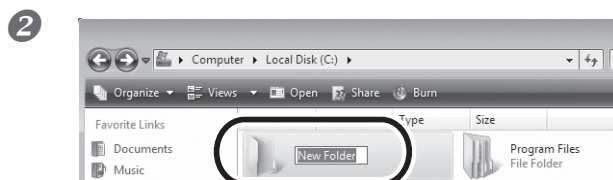


## Creating a Folder for Saving PS Files

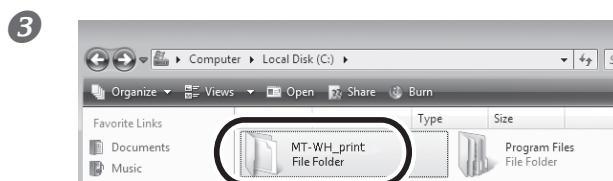
Before you actually print an image you draw using application software such as Adobe Illustrator, it is necessary to save the image as a PS file (s). And then, you can print the image by loading the PS file (s) on VersaWorks. Because of this, you should create a folder for saving PS files in advance. It is recommended to locate the folder in the root directory on your computer's local disk.

### Procedure

**1** Open [Computer] (or [My Computer]), and then open [Local Disk (C:)].



On the [Organize] menu, click [New Folder]. (Or on the [File] menu, click [New], and then click [Folder].)



Enter the name for the folder, and then press the Enter key.  
Here you name "MT-WH\_print", for example.

## 2-2 Printer Preparations

### Making the Printer Settings and Loading Media

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#### When Using Transparent Media

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When you're using transparent media, make the necessary printing settings on the printer and load the media accordingly.

#### Procedure

---

- 1 Press  and make the following settings.  
[EDGE DETECTION] to "DISABLE."
- 2 Load transparent media into the printer.
  - When the media warps or partially floats, ensure a margin of about 200 mm from the leading edge of the media to the printing- or cutting-start location.
  - Be sure to use the media clamps when you load media.

---

#### When Using Media Other Than Transparent Media

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Load the media using the method described in the XC-540/XC-540MT User's Manual.

## 2-3 Creating Printing Data

### Basic Approach for Creating Printing Data

#### When Using Metallic Silver Ink

When you print using metallic silver ink, you can create the printing data according to the two methods below.

- **Specify the spot color so as to use only the metallic silver ink.**  
Apply the spot color named "RDG\_MetallicSilver" to the areas you want to print using the metallic silver ink.
- **Use the exclusive metallic color special colors library.**  
From the exclusive metallic color special colors library, select the metallic color to be used which is the combination color of CMYK ink and metallic silver ink.

#### When Using White Ink

Apply the spot color named "RDG\_WHITE" to the areas you want to print using the white ink.

### Creating Data for Printing

Create the data for printing using the metallic silver ink and white ink.

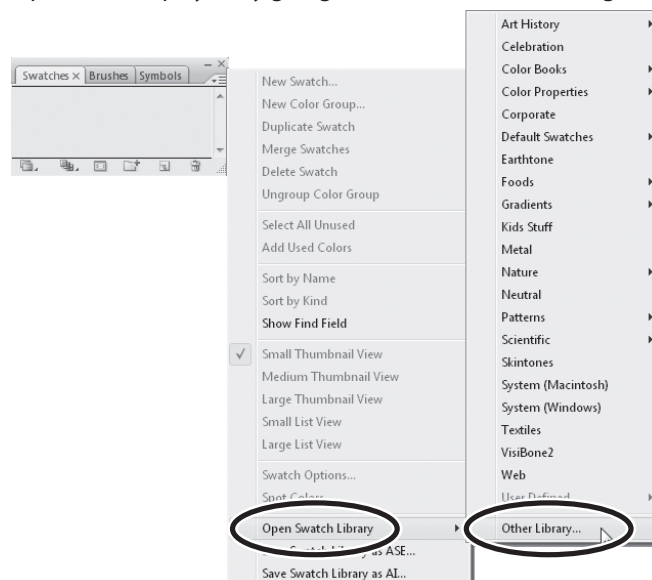
The program used to create the printing data is Adobe Illustrator CS3. For detailed information on drawing methods and how to work with palettes, refer to the documentation or online help for Adobe Illustrator CS3. If you're using another version of Adobe Illustrator, operations may be somewhat different from those explained here.

#### 1. Open the exclusive swatch library.

- ➊ **At the swatch palette menu, select [Open Swatch Library], then [Other Libraries].**

The "Select Library" window appears.

NOTE: The swatch palette is displayed by going to the menu and selecting [Window], then [Swatch].

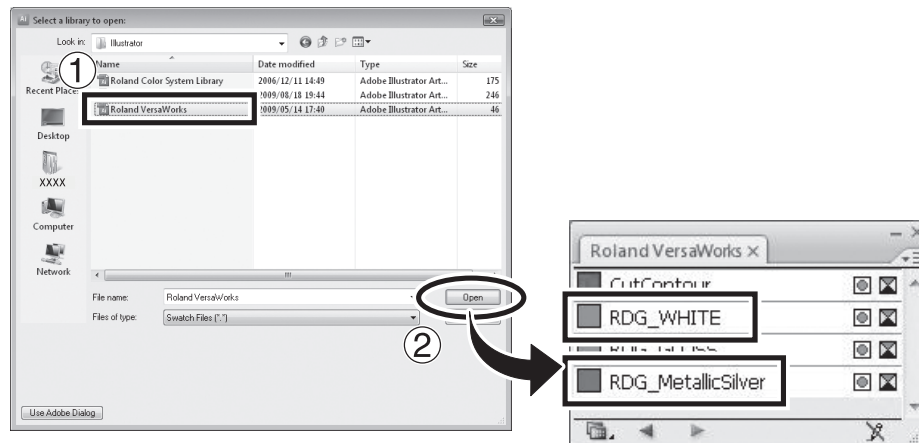


- 2** ① **Open folder in the order of [Computer] (or [My Computer]) → [Local Disk (C:)] → [Program Files] → [Roland VersaWorks] → [Swatch] → [Illustrator], then select "Roland VersaWorks.ai."**

Depending on the settings of your computer, the extension ".ai" might not be shown.

- ② **Click [Open].**

The swatch library containing "RDG\_MetallicSilver" and "RDG\_WHITE" is displayed.

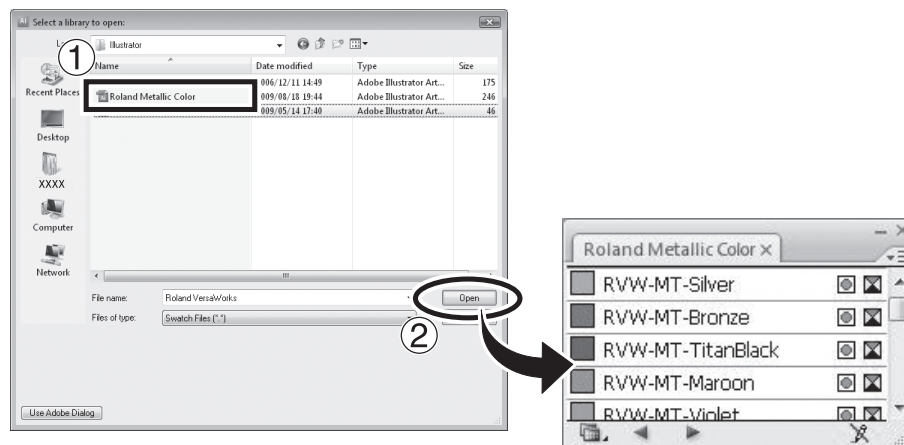


- 3** ① **Open the same folders as in step 2, then select "Roland Metallic Color.ai."**

Depending on the settings of your computer, the extension ".ai" might not be shown

- ② **Click [Open].**

The swatch library is displayed which is containing the "metallic color" created by mixing the metallic silver ink and CMYK ink.



### Tips!

By saving the ".ai" file selected in steps 2 and 3 into the folder below, you can register each swatch library to the Adobe Illustrator's library.

C:\Program Files\Adobe\Adobe Illustrator CS3\Preset\Swatch  
("C" is the name of your computer's local disk.)

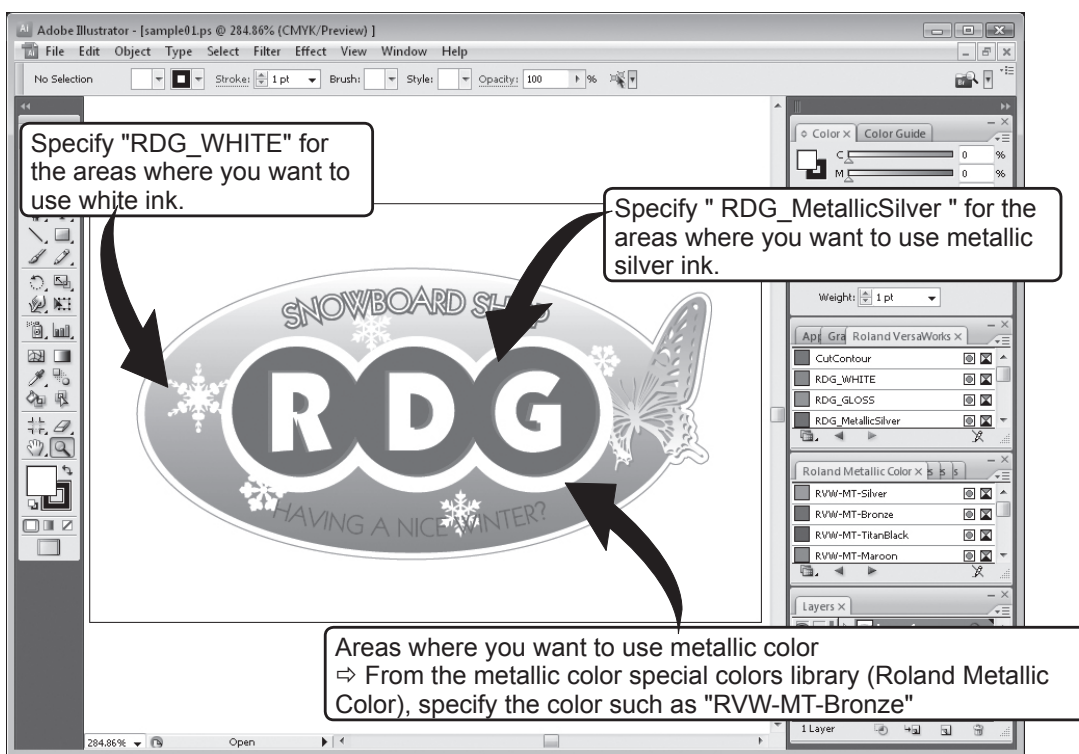
Once the registration is performed, you can open the library directly from the swatch palette menu, eliminating the need to search the file every time you start Adobe Illustrator.

## 2. Create the illustration, and specify the spot color that matches the color you want to print.

**1 Create the illustration.**  
Be sure to draw the illustration in the CMYK mode.

**2 Specify each spot color that matches the color you want to print.**

Desired ink or color	Spot color name
<b>Metallic silver ink</b>	<b>RDG_MetallicSilver</b>
<b>White ink</b>	<b>RDG_WHITE</b>
<b>Metallic color (Metallic silver/CMYK combination color)</b>	<b>RVW-MT-Silver, RVW-MT-Bronze, RVW-MT-TitanBlack, etc.</b>



### POINT!

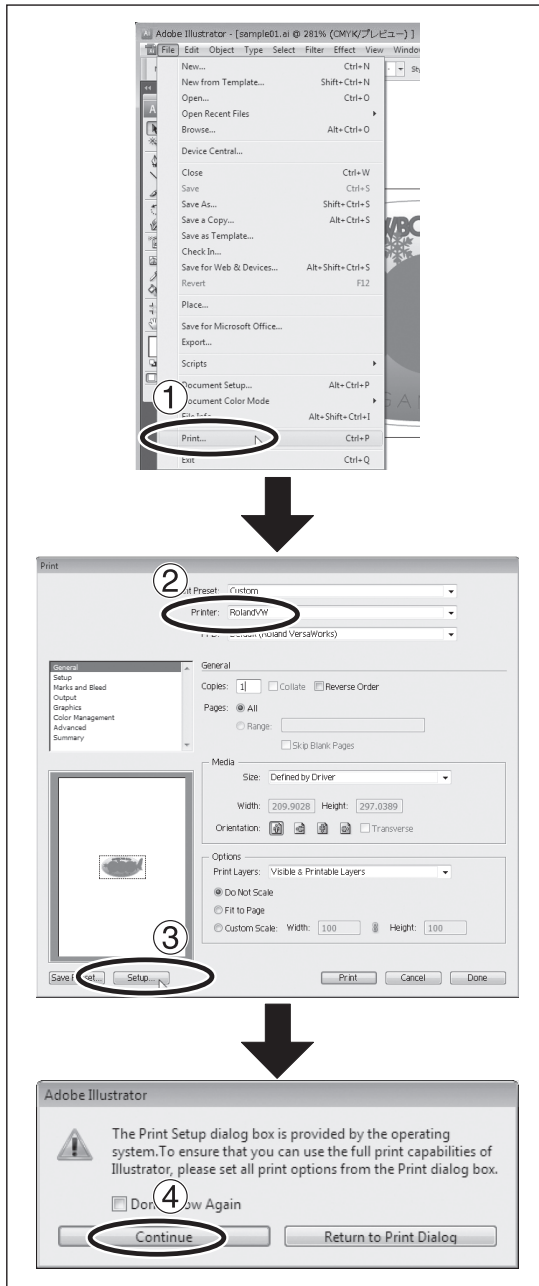
Using the metallic silver ink, you can perform the blend print and the layered print by combining the ink with the CMYK ink.

☞ P. 18, "Blend Print and Layered Print (Metallic Silver and CMYK)"



### 3. Create the PS (PostScript) file.

1



① Select [Print] from the [File] menu.

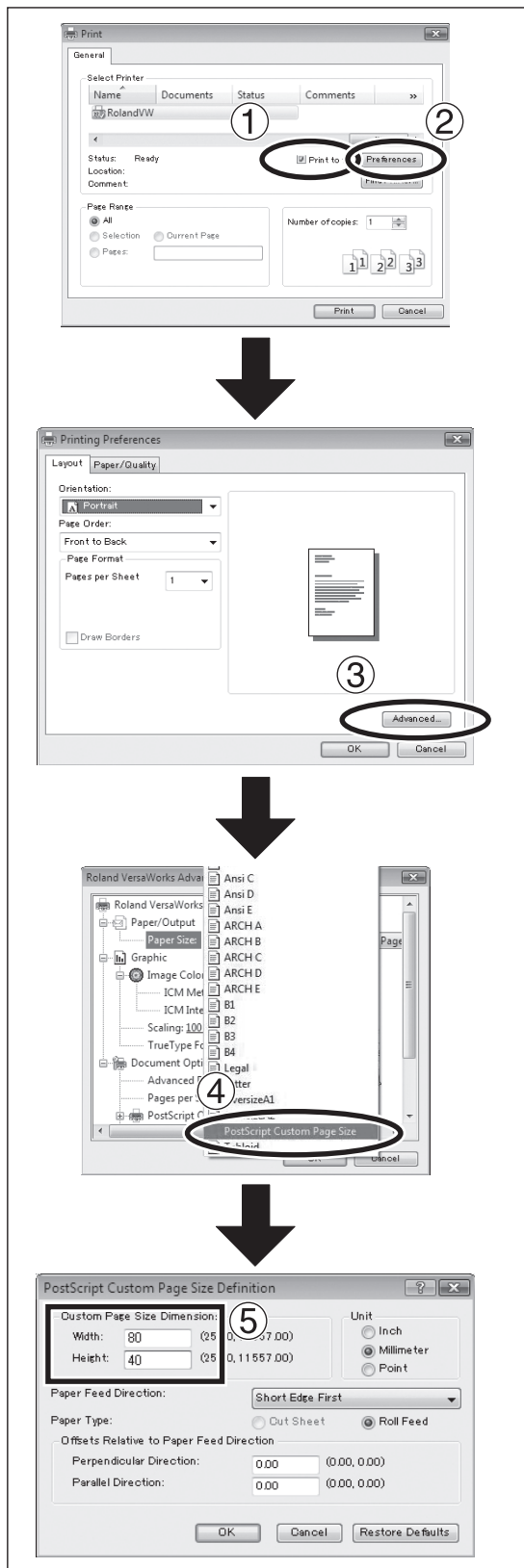
② Select [Roland VW].

When a nickname is set, or when more than one printer is connected, select "Roland VW\_(the nickname of the printer used for output)."

③ Click [Setup].

④ Click [Continue].

2



① Turn on the [Print to file] option.

② Click [Preferences].

③ Click [Advanced] in the [Layout] tab. For Windows 2000: In the "Print" dialog box (the window at the very top of this page), go to the "Layout" tab and click [Advanced].

④ Click the down arrow to the right of the [Paper Size] box, and then click [PostScript Custom Page Size] from the list that appears.

⑤ For "Custom Page Size Definition," enter the values in the "Width" and "Height" fields.

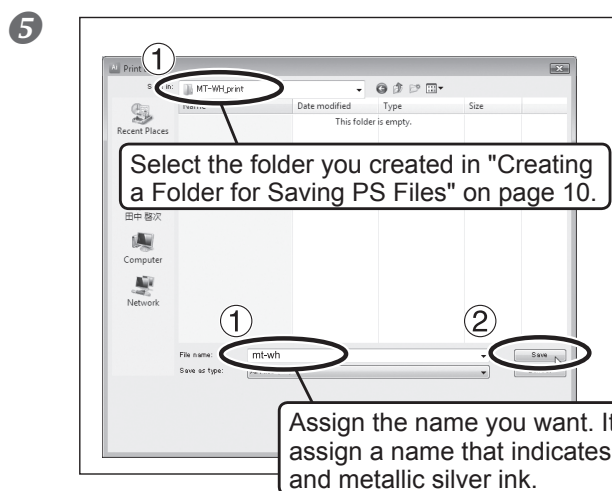
Enter values for the same size as the illustration you created in step 2.

- 3 Click [OK] three times to close the "PostScript Custom Page Size Definition," "Roland VersaWorks Advanced Options," and "Printing Preferences" dialog boxes. The "Print" dialog box returns.



1 Click [Print].

2 Click [Print].



1 Specify the destination and file name for saving, then save the file.

Example: "C:\MT-WH\_print" for the folder to save to, and "mt-wh.ps" as the file name

2 Click [Save].

The CMYK layer of the image is saved as a PS file.

- 6 Open the folder you saved to and make sure the file has been created.

## Blend Print and Layered Print (Metallic Silver and CMYK)

Using the metallic silver ink, you can perform the blend print and the layered print by combining the ink with the CMYK ink. By this means, you can realize the metallic expressions that cannot be made only with the CMYK ink. The printing methods are different between the blend print and the layered print, and so are the metallic impressions of the CMYK colors. Select and use the types of printing to suit your taste.

☞ P. 24, "Blend Print (Metallic Silver + CMYK)," p. 26, "Layered Print (Metallic Silver ⇒ CMYK)," p. 28, "Layered Print (CMYK ⇒ Metallic Silver)"

\* When you perform "Printing with White, Metallic Silver, and CMYK Ink" (page 32), the printing method is limited to the blend print.

**POINT!**

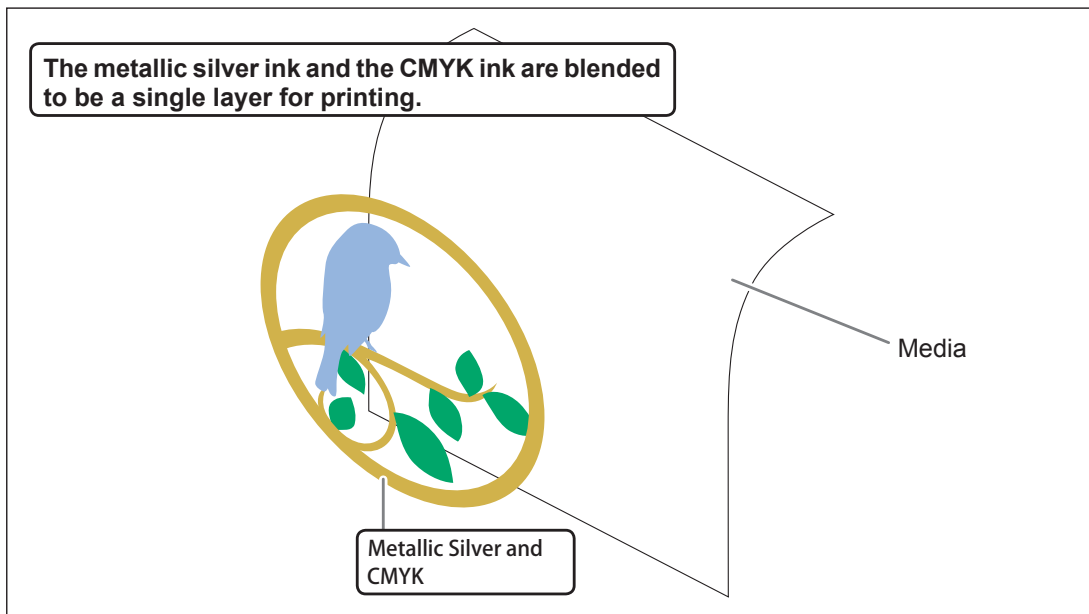
In performing the blend print or the layered print, you can specify the colors from the metallic color special colors library. However, if you specify the metallic colors with the same names for the blend print and the layered print, the tones of the colors are different between them. We recommend that you check the tones of the colors by performing the test printing or printing out the Metallic Color Chart.

Seeing the metallic color chart for the layered print, you may feel a slight inconsistency between the names and the tones of the colors. This is because the colors listed in the Metallic Color Chart are named based on those for the blend print.

☞ P. 38, "Printing the Metallic Color Chart"

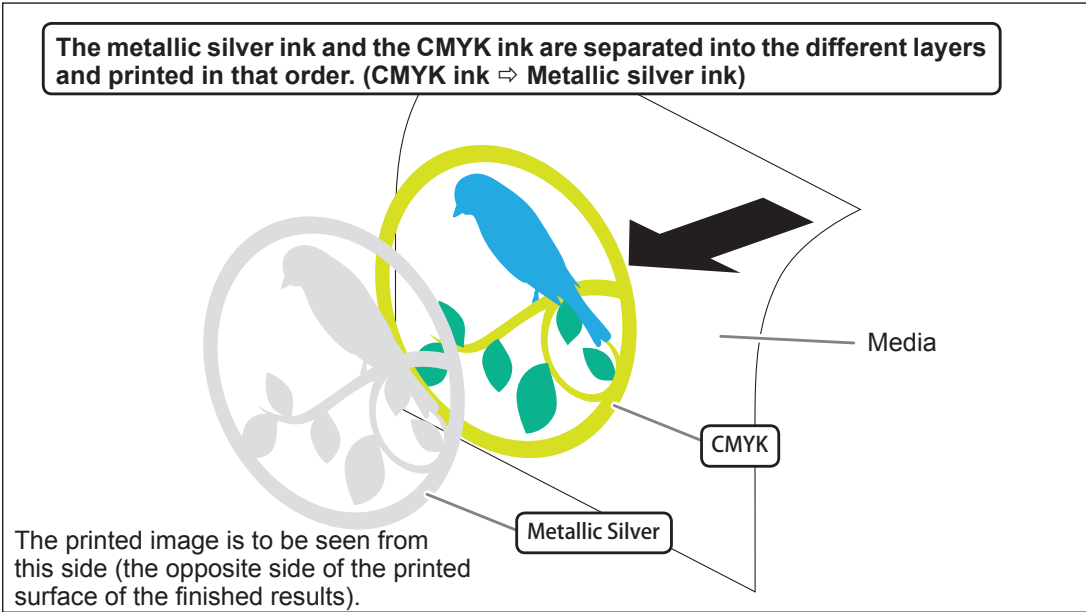
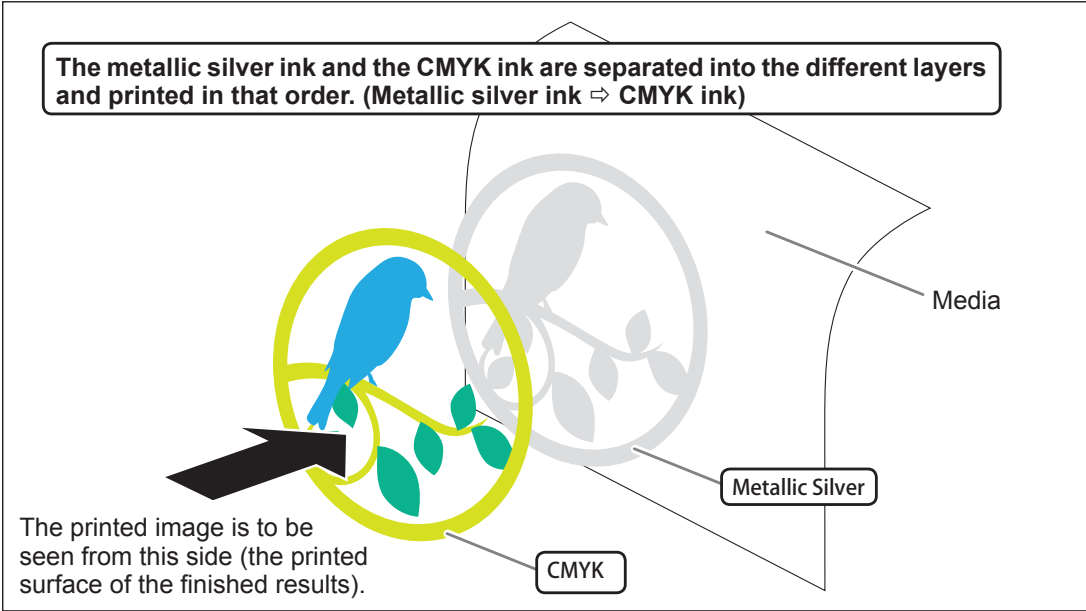
### Blend Print

(Image of printing method)



**Layered Print**

(Image of printing method)





# Chapter 3

## Printing

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# 3-1 Print Job Setting

## Printing Only with Metallic Silver Ink

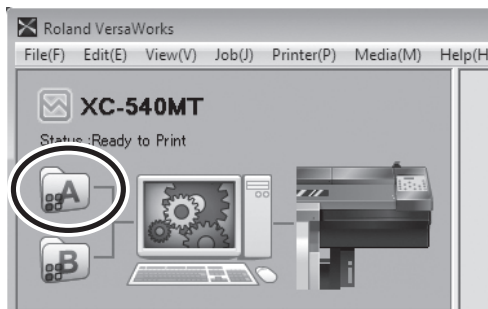
This section describes how to perform printing only with the metallic silver ink. To use the metallic silver ink in printing, you need to use the printing data where the use of the metallic silver ink is designated. If the printing data have the portion designating the use of other colors, with the settings described in this section, you can print with the metallic silver ink only the area of the image which has been designated to print with the metallic silver ink.

☞ P. 12, "2-3 Creating Printing Data"

### Procedure

**1** Make sure that you have finished making the preparations for VersaWorks, getting the printer ready, and creating the printing data (☞ page 9, "Chapter 2 -- Getting Ready").

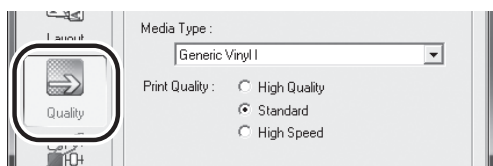
**2**



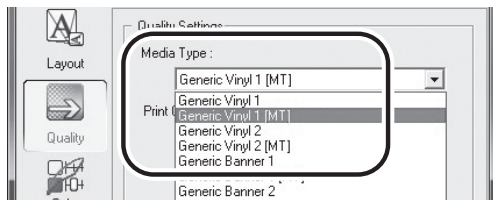
Double-click .

Queue A Properties" window appears.

**3**

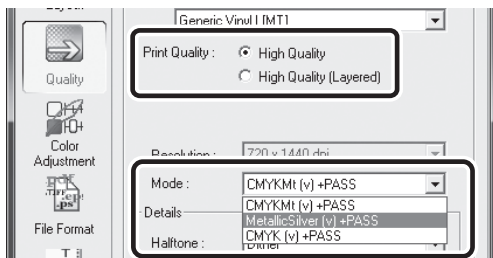


Click .



For [Media Type], select names with [MT] attached such as "Generic Vinyl 1 [MT]".

Make the selection that matches the media to be used. Selecting an item attached with [MT] enables you to choose the print mode that can use the metallic silver ink.



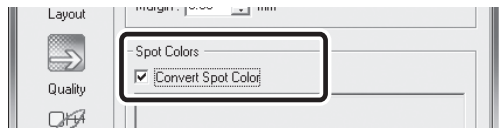
For [Print Quality], select [High Quality]

For [Mode], select [MetallicSilver (v)].

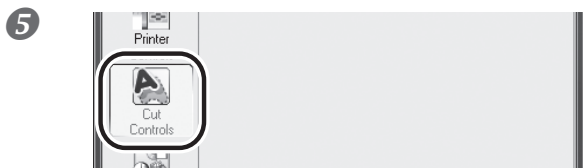




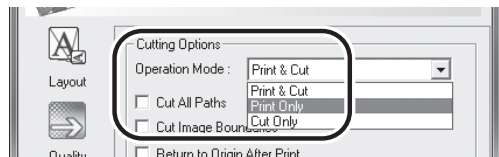
Click  .



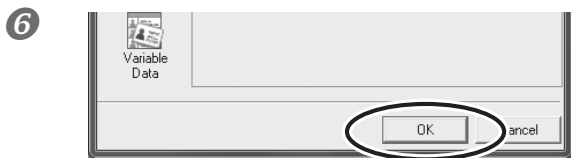
Turn on the [Convert Spot Color] option.



Click  .



In [Operation Mode], select the operation of the printer.



Click [OK] to close the "Queue A Properties" window.

This is the end of the print job setting. To start printing, go on to page 37 "Starting the Print Operation."

Only the settings necessary for the use of the metallic silver ink are described in this section. For other settings, refer to the online help provided for VersaWorks.

\* If you select [CMYK (v)] for [Mode] in the procedure **3**, only the area of the image where CMYK is specified in the printing data is to be printed.

## Blend Print (Metallic Silver + CMYK)

This section describes how to perform the blend print with the metallic silver ink and CMYK ink.

☞ P. 18, "Blend Print and Layered Print (Metallic Silver and CMYK)"

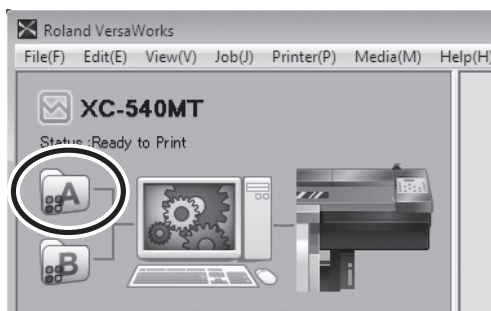
To perform the blend print, you need to use the printing data where the use of the metallic silver ink and the CMYK ink is designated.

☞ P. 12, "2-3 Creating Printing Data"

### Procedure

- 1 **Make sure that you have finished making the preparations for VersaWorks, getting the printer ready, and creating the printing data (☞ page 9, "Chapter 2 -- Getting Ready").**

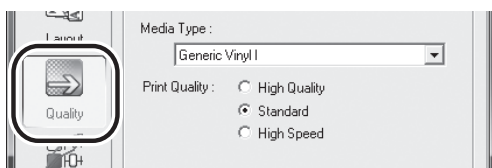
2



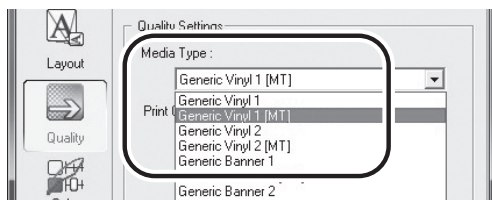
Double-click .

"Queue A Properties" window appears.

3

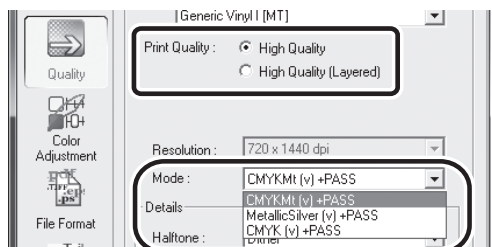


Click .



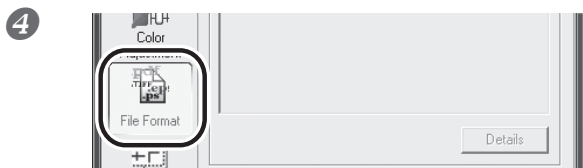
For [Media Type], select names with [MT] attached such as "Generic Vinyl 1 [MT]".

Make the selection that matches the media to be used. Selecting an item attached with [MT] enables you to choose the print mode that can use the metallic silver ink.

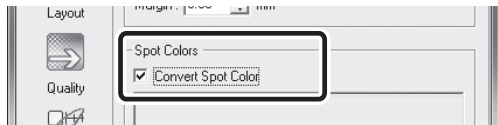


For [Print Quality], select [High Quality].

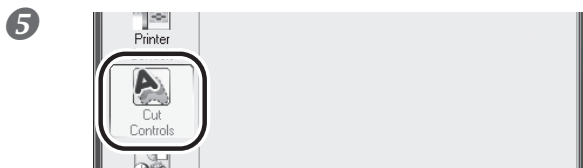
For [Mode], select [CMYKMT (v)].



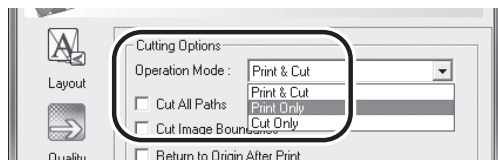
Click  .



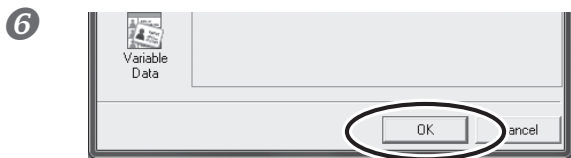
Turn on the [Convert Spot Color] option.



Click  .



In [Operation Mode], select the operation of the printer.



Click [OK] to close the "Queue A Properties" window.

This is the end of the print job setting. To start printing, go on to page 37 "Starting the Print Operation."

Only the settings necessary for the use of the metallic silver ink are described in this section. For other settings, refer to the online help provided for VersaWorks.

## Layered Print (Metallic Silver → CMYK)

This section describes how to perform the layered print with the metallic silver ink and CMYK ink using the metallic silver ink as background.

☞ P. 18, "Blend Print and Layered Print (Metallic Silver and CMYK)"

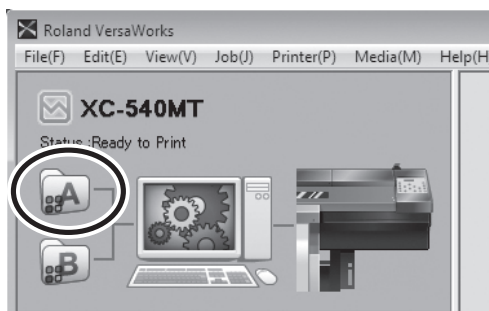
To perform the layered print, you need to use the printing data where the use of the metallic silver ink and the CMYK ink is designated.

☞ P. 12, "2-3 Creating Printing Data"

### Procedure

- 1 **Make sure that you have finished making the preparations for VersaWorks, getting the printer ready, and creating the printing data (☞ page 9, "Chapter 2 -- Getting Ready").**

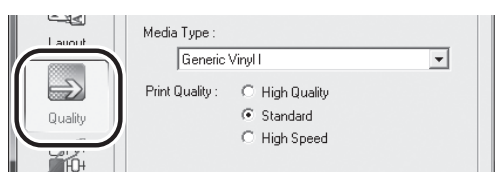
- 2



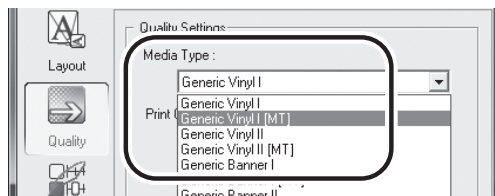
Double-click .

Queue A Properties" window appears.

- 3

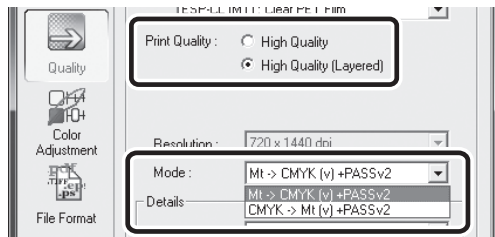


Click .



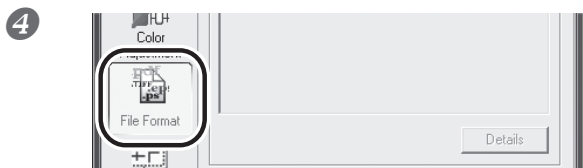
For [Media Type], select names with [MT] attached such as "Generic Vinyl 1 [MT]".

Make the selection that matches the media to be used. Selecting an item attached with [MT] enables you to choose the print mode that can use the metallic silver ink.

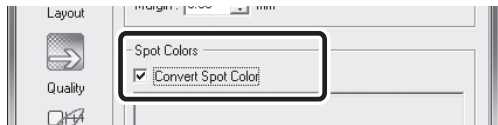


For [Print Quality], select [High Quality (Layered)].

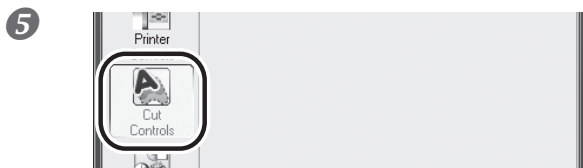
If [Mode] is selectable, select [Mt -> CMYK (v)].



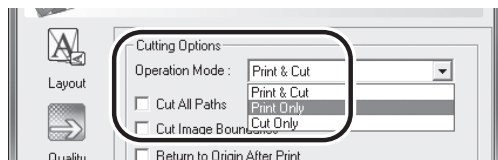
Click  .



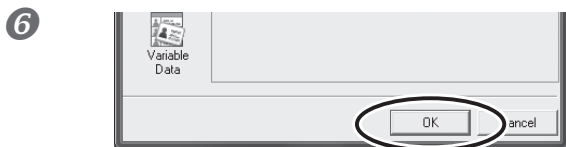
Turn on the [Convert Spot Color] option.



Click  .



In [Operation Mode], select the operation of the printer.



Click [OK] to close the "Queue A Properties" window.

This is the end of the print job setting. To start printing, go on to page 37 "Starting the Print Operation."

Only the settings necessary for the use of the metallic silver ink are described in this section. For other settings, refer to the online help provided for VersaWorks.

## Layered Print (CMYK ⇨ Metallic Silver )

This section describes how to perform the layered print with the metallic silver ink.

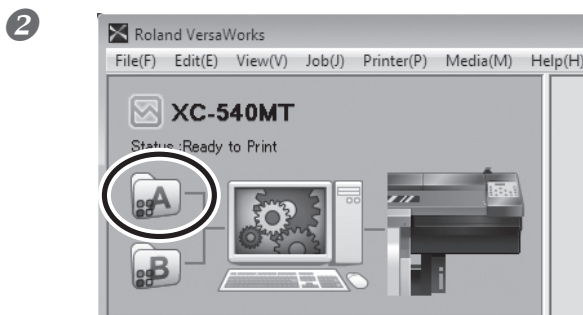
☞ P. 18, "Blend Print and Layered Print (Metallic Silver and CMYK)"

To perform the layered print, you need to use the printing data where the use of the metallic silver ink and the CMYK ink is designated.

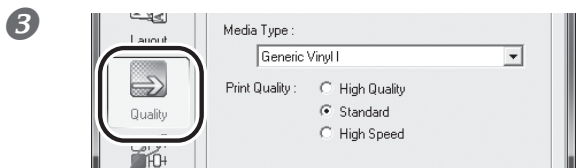
☞ P. 12, "2-3 Creating Printing Data"

### Procedure

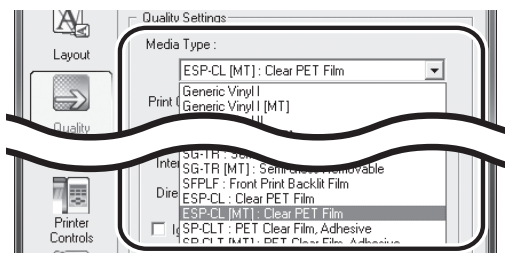
**1** Make sure that you have finished making the preparations for VersaWorks, getting the printer ready, and creating the printing data (☞ page 9, "Chapter 2 -- Getting Ready").



Double-click .  
"Queue A Properties" window appears.

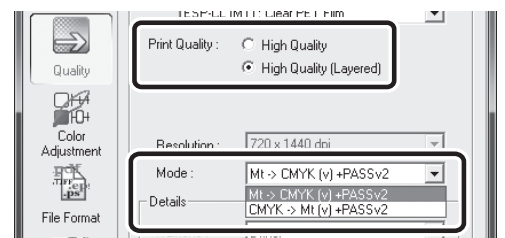


Click .



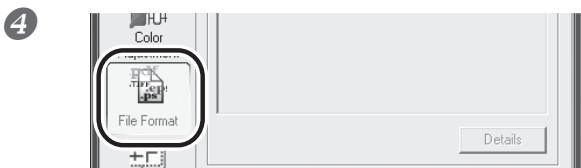
For [Media Type], select "xxx[MT]: Clear PET Film" or "xxx[MT]: PET Clear Film, Adhesive" (or xxx: Clear PET Film, "xxx: PET Clear Film, Adhesive).

\* "xxx" indicates "ESP-CL" and others.

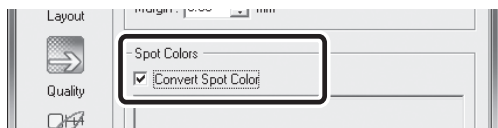


For [Print Quality], select [High Quality (Layered)].

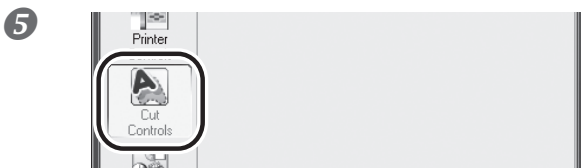
For [Mode], select [CMYK -> Mt (v)].



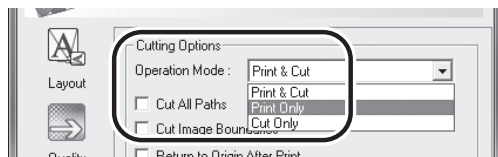
Click  .



Turn on the [Convert Spot Color] option.

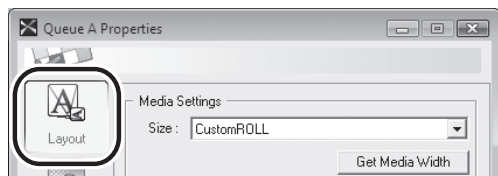


Click  .



In [Operation Mode], select the operation of the printer.

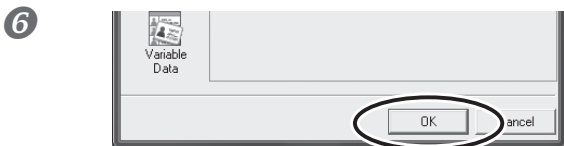
**When You Want to Display the Side Opposite the Printed Surface by Using Clear Film.**



Click  .



Turn on the [Mirror] option.  
When the printing data with mirror image is prepared beforehand, you do not need to turn on this option.



Click [OK] to close the "Queue A Properties" window.

This is the end of the print job setting. To start printing, go on to page 37 "Starting the Print Operation."

Only the settings necessary for the use of the metallic silver ink are described in this section. For other settings, refer to the online help provided for VersaWorks.

## Printing Only with White Ink

This section describes how to perform printing only with the white ink. To use the white ink in printing, you need to use the printing data where the use of the white ink is designated. If the printing data have the portion designating the use of other colors, with the setting described in this section, you can print with the white ink only the area of the image which has been designated to print with the white ink.

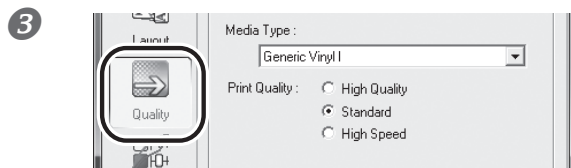
☞ P. 12, "2-3 Creating Printing Data"

### Procedure

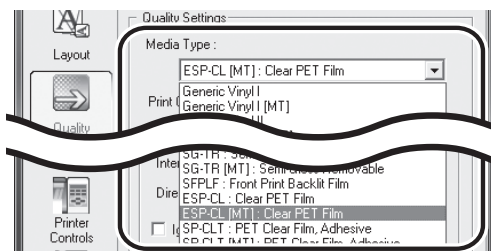
- 1 **Make sure that you have finished making the preparations for VersaWorks, getting the printer ready, and creating the printing data (☞ page 9, "Chapter 2 -- Getting Ready").**



**Double-click** .  
"Queue A Properties" window appears.

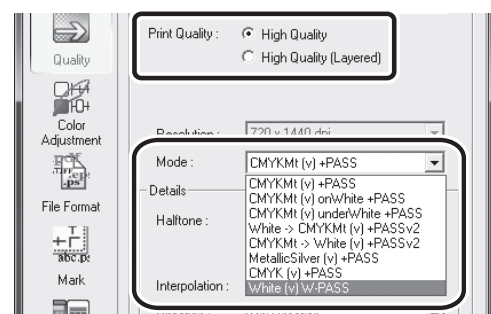


Click .



For [Media Type], select "xxx[MT]: Clear PET Film" or "xxx[MT]: PET Clear Film, Adhesive" (or xxx: Clear PET Film," "xxx: PET Clear Film, Adhesive).

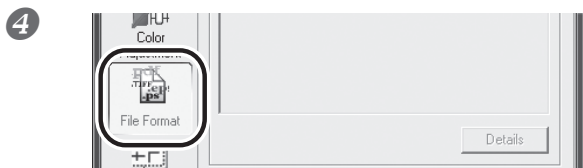
\* "xxx" indicates "ESP-CL" and others.



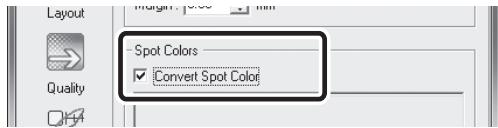
**For [Print Quality], select [High Quality].**  
When "xxx: Clear PET Film" or "xxx: PET Clear Film, Adhesive" is selected for [Media Type], [Print Quality] need not be selected (because the option is only [High Quality]).

**For [Mode], select [White (v)].**

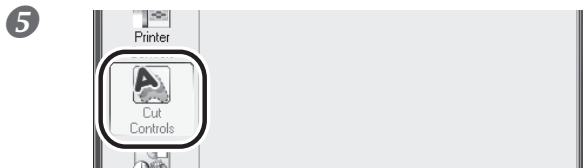




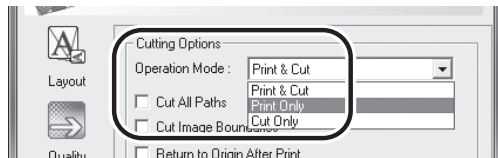
Click  .



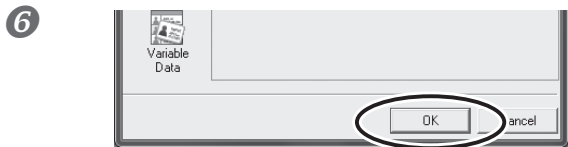
Turn on the [Convert Spot Color] option.



Click  .



In [Operation Mode], select the operation of the printer.



Click [OK] to close the "Queue A Properties" window.

This is the end of the print job setting. To start printing, go on to page 37 "Starting the Print Operation."

Only the settings necessary for the use of the metallic silver ink are described in this section. For other settings, refer to the online help provided for VersaWorks.

\* If you select [CMYK (v)] for [Mode] in the procedure **3**, only the area of the image where CMYK is specified in the printing data is to be printed.

## Printing with White, Metallic Silver, and CMYK Ink

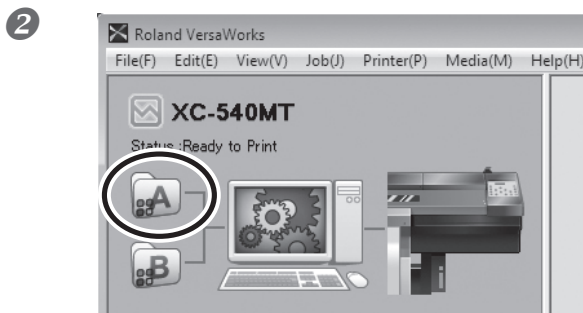
This section describes how to perform printing with the metallic silver ink, the white ink, and the CMYK ink. Deciding which ink between the white and the others (the metallic silver and CMYK) you want to use for the base is an important point in determining the print job setting here.

To use the metallic silver ink and the white ink, you need to use the printing data where the use of the respective inks is designated. For the area of the image to be printed with the metallic silver ink and the CMYK ink combined, the setting is fixed to the blend print.

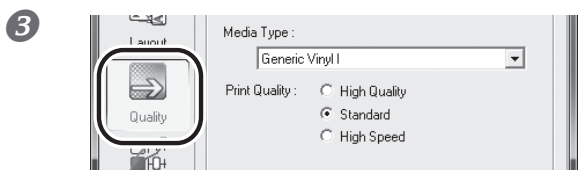
☞ P. 12, "2-3 Creating Printing Data"

### Procedure

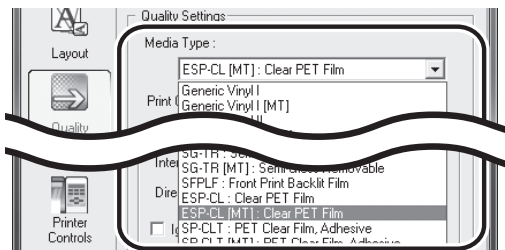
**1** Make sure that you have finished making the preparations for VersaWorks, getting the printer ready, and creating the printing data (☞ page 9, "Chapter 2 -- Getting Ready").



Double-click . Queue "A Properties" window appears.

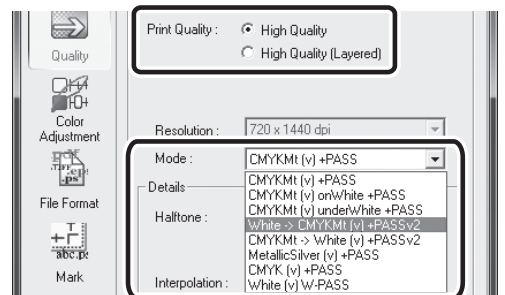


Click .



For [Media Type], select "xxx[MT]: Clear PET Film" or "xxx[MT]: PET Clear Film, Adhesive."

\* "xxx" indicates "ESP-CL" and others.



For [Print Quality], select [High Quality]. With [Mode], select the print mode.

**White -> CMYKmt (v)**

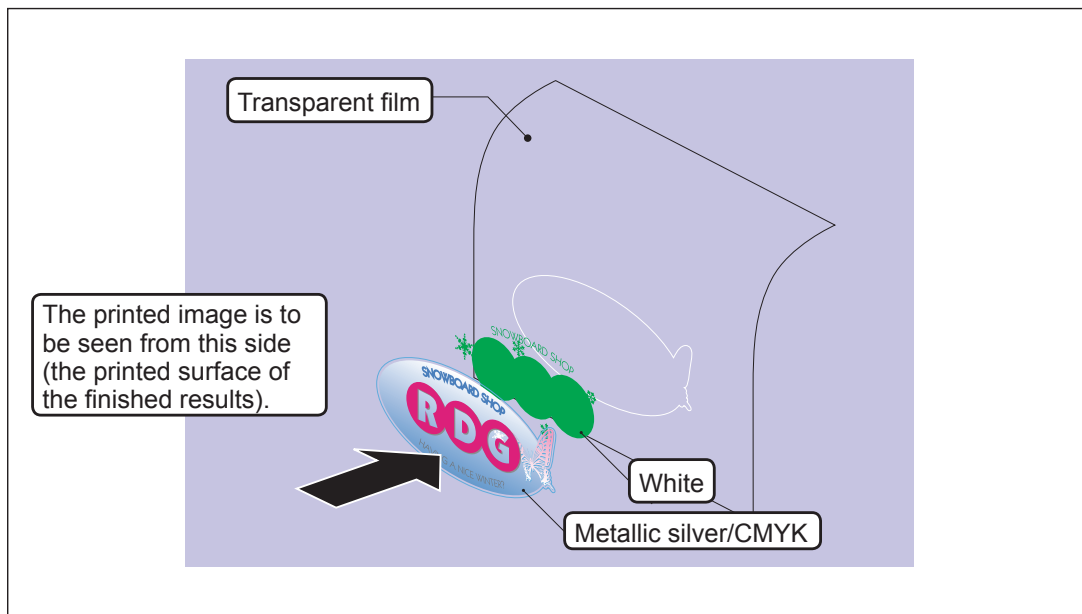
Inks are overprinted in the sequence of white and then metallic silver/CMYK Color.

**CMYKmt -> White (v)**

Inks are overprinted in the sequence of white and then metallic silver/CMYK Color.

**Image of overprinting in the sequence of white and then metallic silver/CMYK Color**

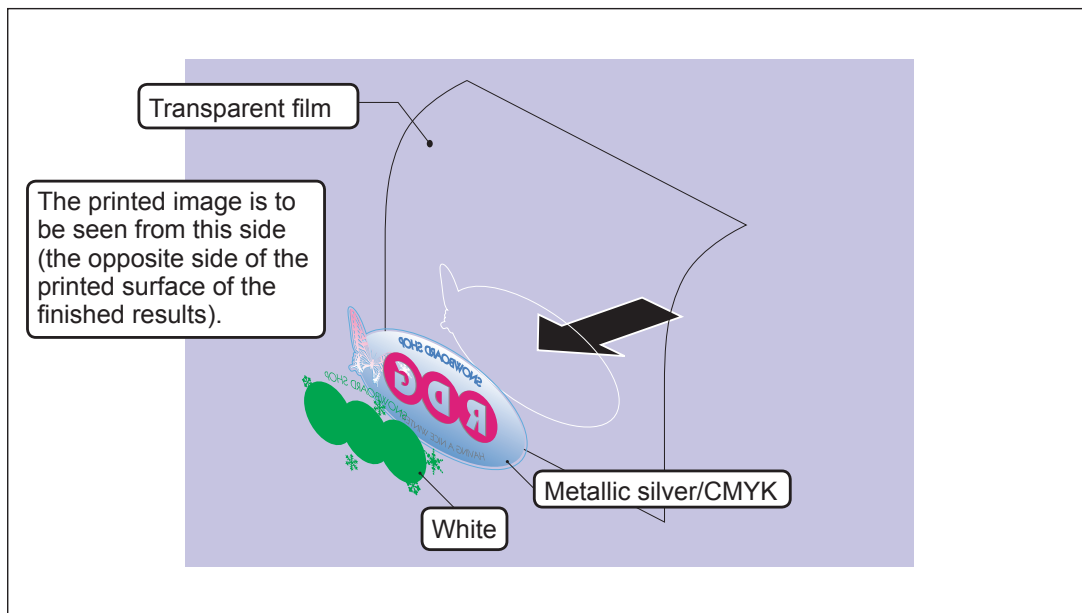
(Print Mode "White -> CMYKt (v) ")



\* The white data and the metallic silver/CMYK color data are actually printed simultaneously, but they are shown here as separate layers in order to indicate the printing sequence.

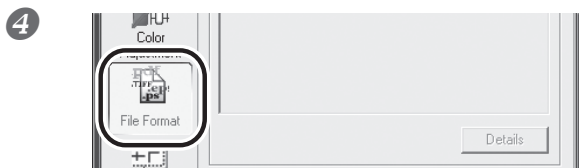
**Image of overprinting in the sequence of metallic silver/CMYK Color and then white**

(Print Mode "CMYKt -> White (v) ")

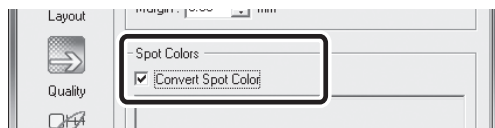


\* The white data and the metallic silver/CMYK color data are actually printed simultaneously, but they are shown here as separate layers in order to indicate the printing sequence.

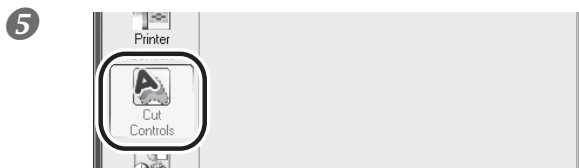
### 3-1 Print Job Setting



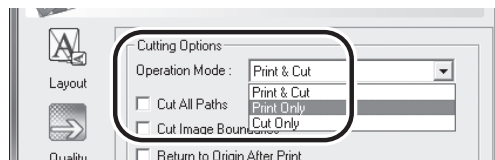
Click  .



Turn on the [Convert Spot Color] option.

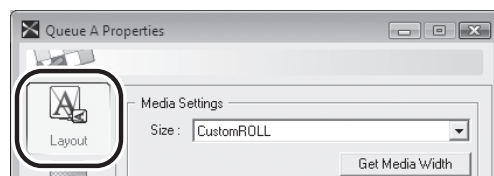


Click  .

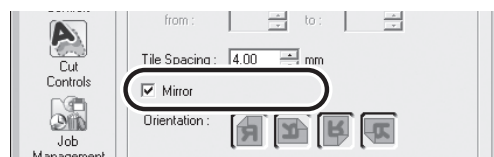


In [Operation Mode], select the operation of the printer.

#### When You Want to Display the Side Opposite the Printed Surface by Using Clear Film.

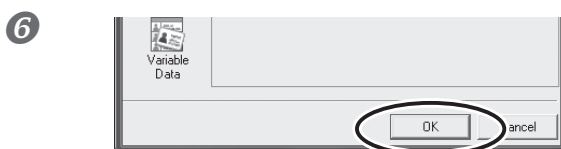


Click  .



Turn on the [Mirror] option.

When the printing data with mirror image is prepared beforehand, you do not need to turn on this option.



Click [OK] to close the “Queue A Properties” window.

This is the end of the print job setting. To start printing, go on to page 37 “Starting the Print Operation.” Only the settings necessary for the use of the metallic silver ink and white ink are described in this section. For other settings, refer to the online help provided for VersaWorks.

## Printing with White and CMYK Ink

This section describes how to perform printing with the white ink and the CMYK ink. Deciding which ink between the white and the CMYK you want to use for the base is an important point in determining the print job setting here. To use the white ink for printing, you need to use the printing data where the use of the white ink is designated.

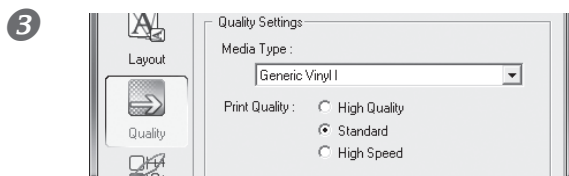
☞ P. 12, "2-3 Creating Printing Data"

### Procedure

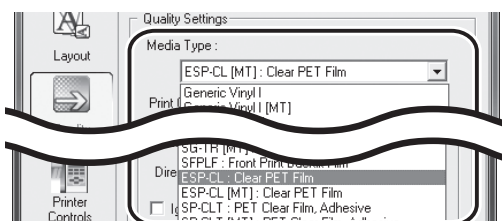
- 1 **Make sure that you have finished making the preparations for VersaWorks, getting the printer ready, and creating the printing data (☞ page 9, "Chapter 2 -- Getting Ready").**



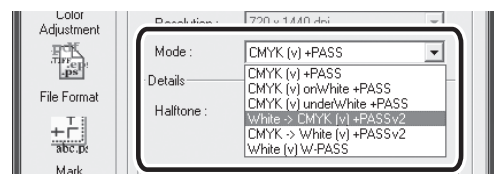
Double-click .  
Queue A Properties" window appears.



Click .



For [Media Type], select "xxx: Clear PET Film" or "xxx: PET Clear Film, Adhesive."  
"xxx" indicates "ESP-CL" and others.



With [Mode], select the print mode.

**White -> CMYK (v)**

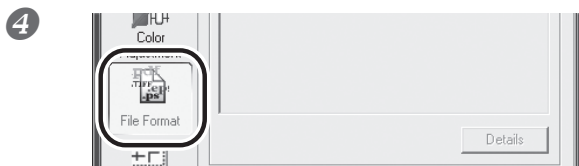
Inks are overprinted in the sequence of white and then CMYK Color.

**CMYK -> White (v)**

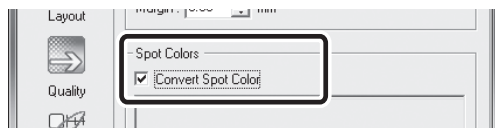
Inks are overprinted in the sequence of CMYK and then white Color.

- \* The image of overprinting in the sequence of white and CMYK is the same as that of overprinting in the sequence of white and metallic silver/CMYK on page 33. (The description of "metallic silver/CMYK" is to be replaced with "CMYK" only.)

### 3-1 Print Job Setting



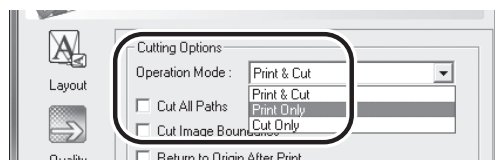
Click  .



Turn on the [Convert Spot Color] option.



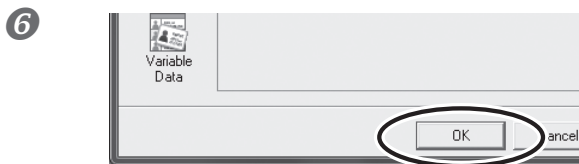
Click  .



In [Operation Mode], select the operation of the printer.

**When You Want to Display the Side Opposite the Printed Surface by Using Clear Film.**

☞ P. 29



Click [OK] to close the “Queue A Properties” window.

This is the end of the print job setting. To start printing, go on to page 37 “Starting the Print Operation.” Only the settings necessary for the use of the white ink are described in this section. For other settings, refer to the online help provided for VersaWorks.

# 3-2 Starting the Print Operation

## Starting the Print Operation

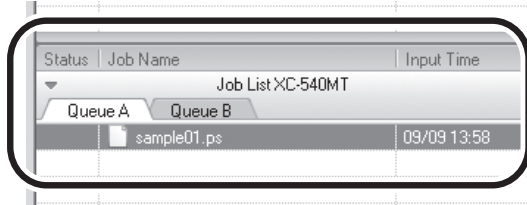
Following the print job setting, you can start the print operation.

### Procedure

**1** Make settings for the print job.

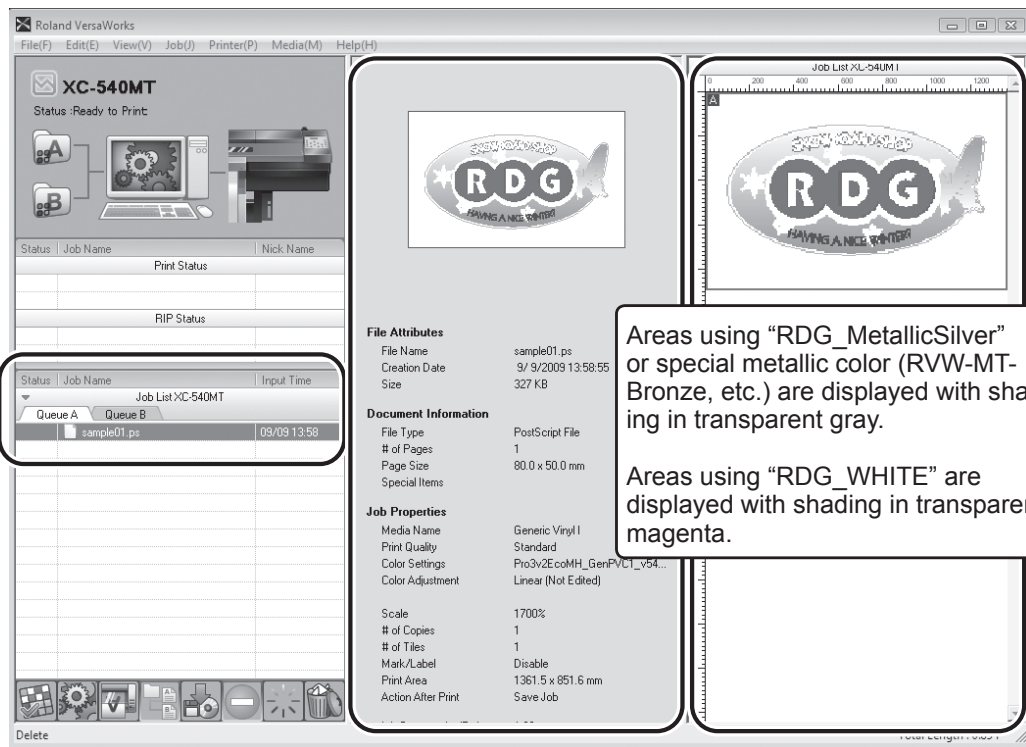
☞ P. 22, “3-1 Print Job Setting”

**2**



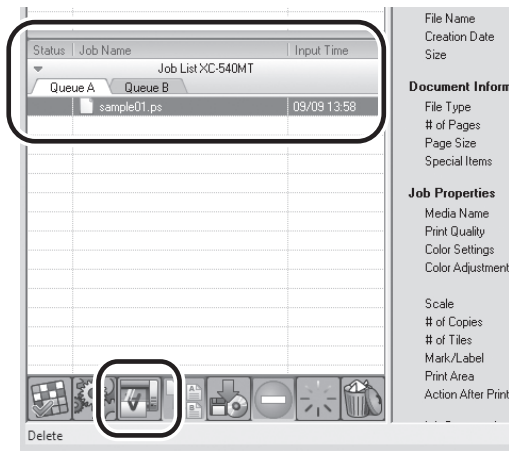
Go to “Job List,” click the “Queue A” tab, and drag the printing data to the queue A job list (If the print job setting has been made in [Queue B], drag and drop the printing data on the job list of [Queue B].).

The contents of the data are displayed in the preview window, and the layout on the media is displayed in the layout window.



### 3-2 Starting the Print Operation

3



Select the print job in the job list, and then click .

Printing will be started.

#### Tips!

After printing, allow the ink to dry sufficiently. We strongly recommend performing lamination.

#### Tips!

To continue printing similar data, repeat steps 2 and 3. Also, if you want to modify detailed settings for each job, it will be convenient to perform modifications in the "Job Setting" window (which you can display by double-clicking the print job in the job list).

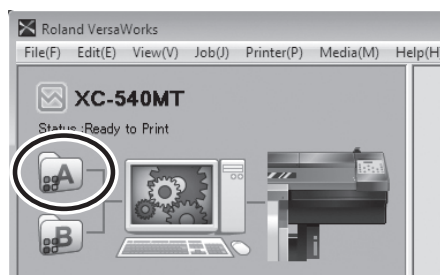
## Printing a Metallic Color Chart

The Metallic Color Chart is the printing sample of the special metallic color. By printing the Metallic Color Chart, you can confirm the "complete metallic color chart" representing the special metallic color itself that can be printed with "Your Printer" and "Your Media" (slight pattern differences is possible to occur depending on the conditions of the printer and media.) By selecting colors from this color chart and creating illustrations with these colors, you can accurately reproduce the desired colors..

### Procedure

1 Make sure that you have finished making the preparations for VersaWorks, and getting the printer ready (⇒ page 9, "Chapter 2 -- Getting Ready").

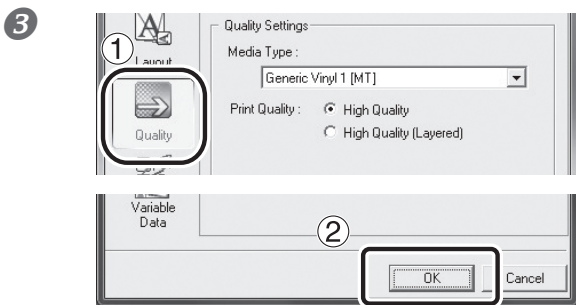
2



Double-click .

"Queue A Properties" window appears.





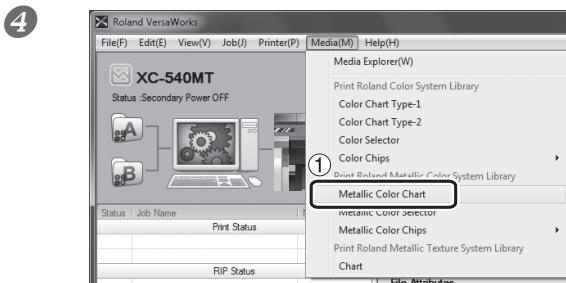
Click , configure the settings in [Quality-Settings] and [Color Management].

⇨ P. 22, “3-1 Print Job Setting”

Click [OK].

**POINT!**

When printing a Metallic Color Chart, the [Quality] settings from the [Queue Properties] window are always applied. Since you cannot change the quality settings for the job using the [Job Settings] window after it has been added, be sure to configure the settings in the [Queue Properties] window before performing the following operations.



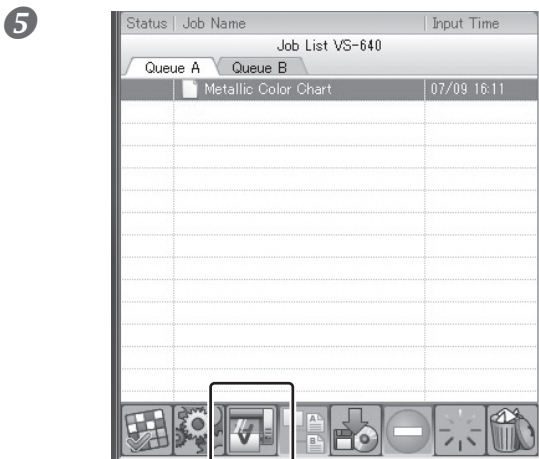
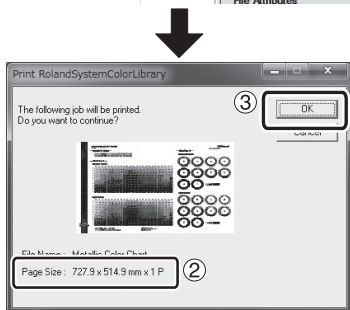
① Click [Media] and then [Metallic Color Chart].

② Check the page size.

If the size of the media loaded on the printer is not adequate for the page size, change it to another media of sufficient size.

③ Click [OK].

The print job of the Metallic Color Chart is added to the job list.



Click .

Printing will be started.



# Chapter 4

## Advanced

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# 4-1 Pullback printing

## Pullback printing (White ⇨ Metallic silver/CMYK)

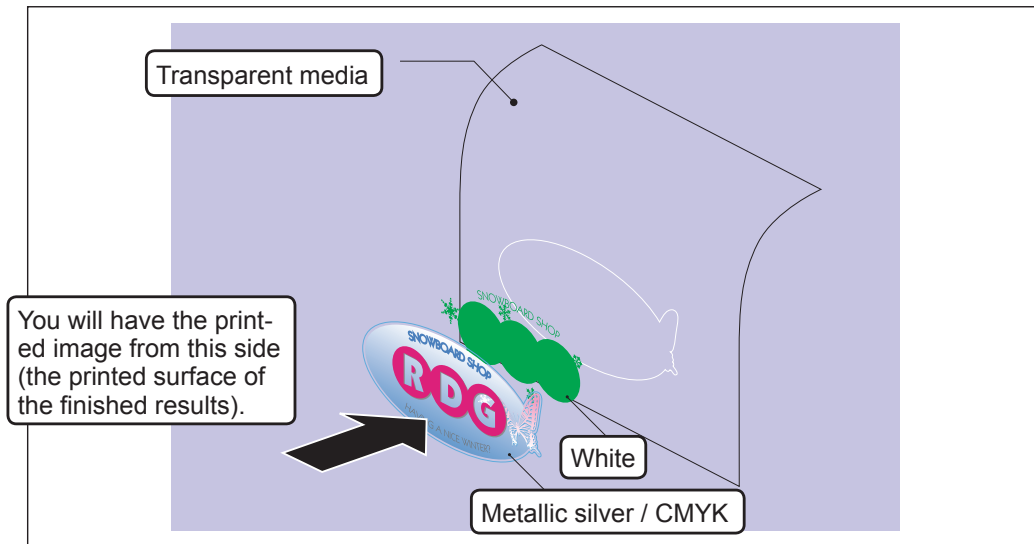
This section describes how to perform printing in the sequence of white and then metallic silver/CMYK color. After performing printing using white ink and allowing the ink to dry for a predetermined period, the media is pulled back once, and then the fill overprinting is performed using metallic silver and CMYK ink. The printing data containing metallic colors such as "RDG\_MetallicSilver" and "RVW-MT-Bronze" must be used in order to use the metallic silver ink, and the printing data containing "RDG\_WHITE" must be used in order to use the white ink.

⇨ P. 12, "Creating Printing Data"

### IMPORTANT!

This printing method involves some important notes for avoiding contamination on the printed surface. Be sure to refer to page 6, "When Performing Pullback Printing".

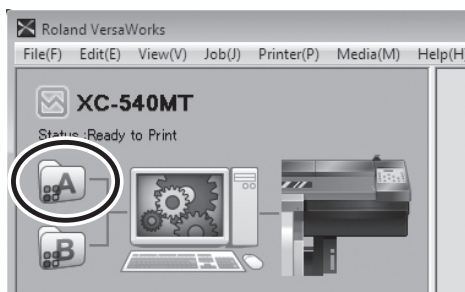
### Image of overprinting in the sequence of white and then metallic silver/CMYK



## 1. Printing With White Ink Only

1 Make sure that you have finished making the preparations for VersaWorks, creating the printing data, and getting the printer ready (⇨ p. 9, "Chapter 2 Getting Ready").

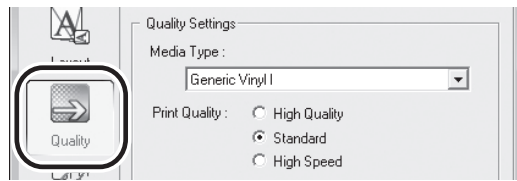
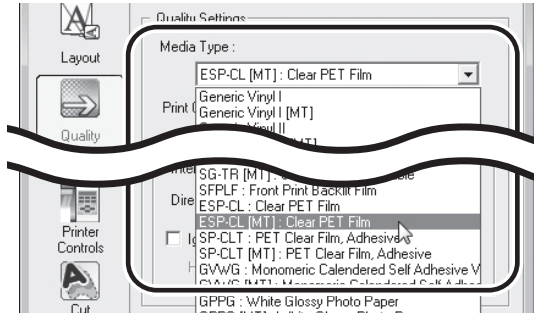
2



Double-click .

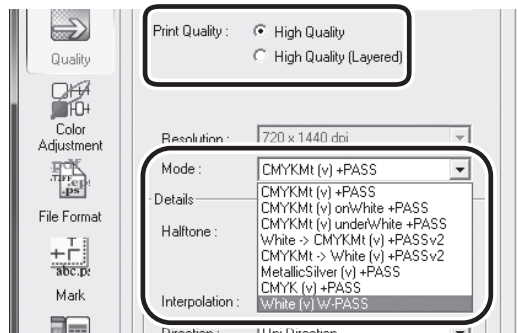
"Queue A Properties" window appears.

3

Click .

For [Media Type], select "xxx[MT]: Clear Film" or "xxx[MT]: Clear Film, Adhesive."

\*"xxx" indicates "ESP-CL" and others.

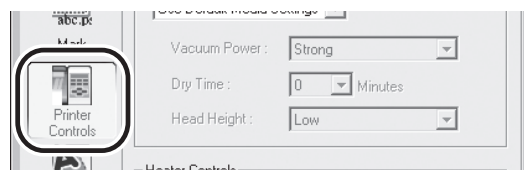
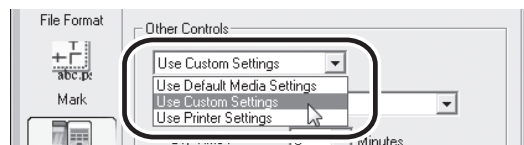


For [Print Quality], select [High Quality].

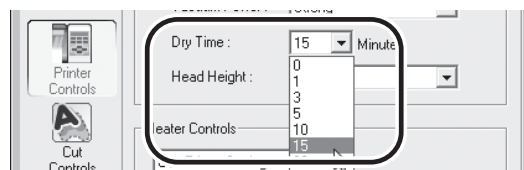
With [Mode], select the print mode "White (v) ."

This prints with RDG\_WHITE only.

4

Click .

With [Other Controls], select "User Custom Settings."

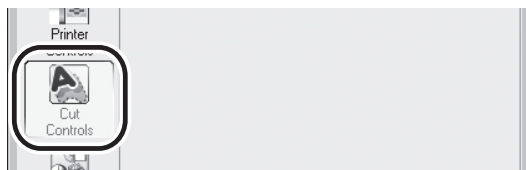


For [Dry Time], select "15 minutes."

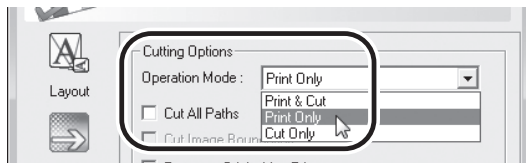
This is a suggested setting for when using an auxiliary drying unit (the DU-540).

## 4-1 Pullback printing

5



Click .

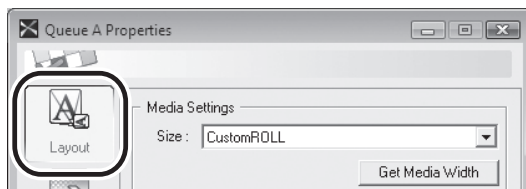


In [Operation Mode], select "Print Only."



Turn on the [Return to Origin After Print] option.

When You Want to Display the Side Opposite the Printed Surface



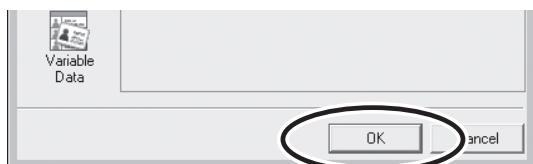
Click .



Turn on the [Mirror] option. When the printing data with mirror image is prepared beforehand, you do not need to turn on this option.

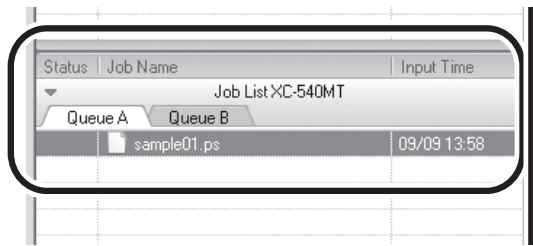
NOTE: This section only described the settings that are necessary for the use of the white ink. For other settings, refer to the online help provided for VersaWorks.

6



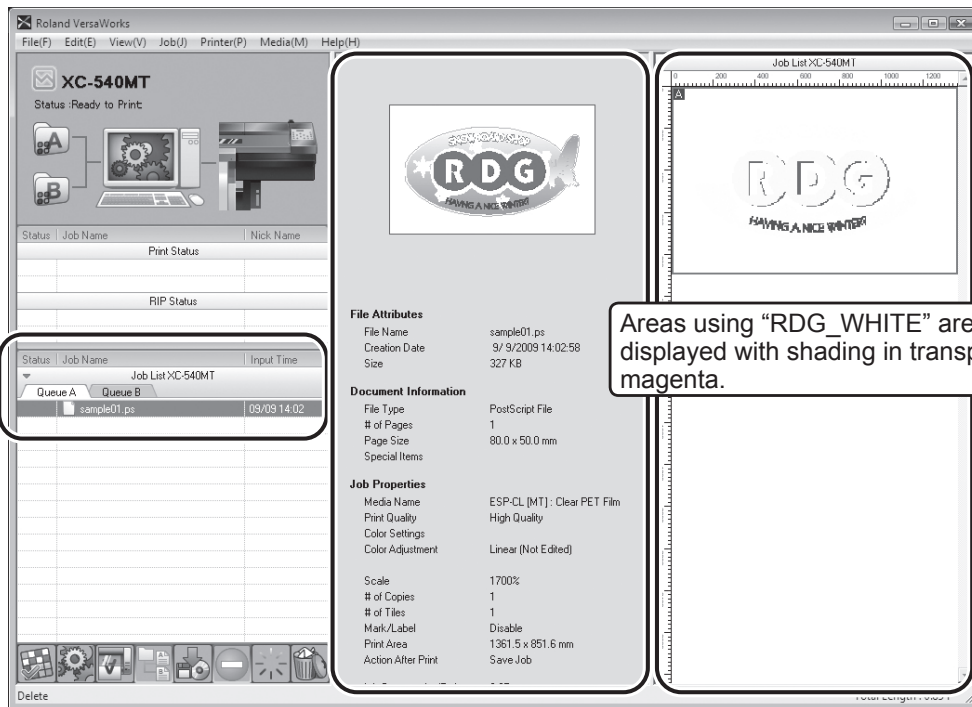
Click [OK] to close the "Queue A Properties" window.

7

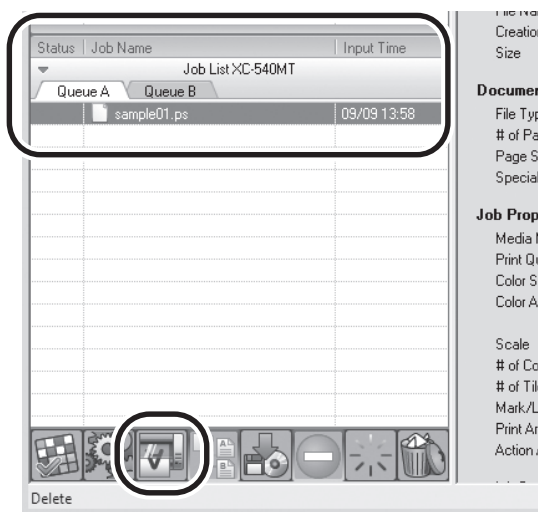



Go to “Job List” and click the “Queue A” tab, and drag the printing data to the queue A job list.

The contents of the data are displayed in the preview window, and the layout on the media is displayed in the layout window.



8



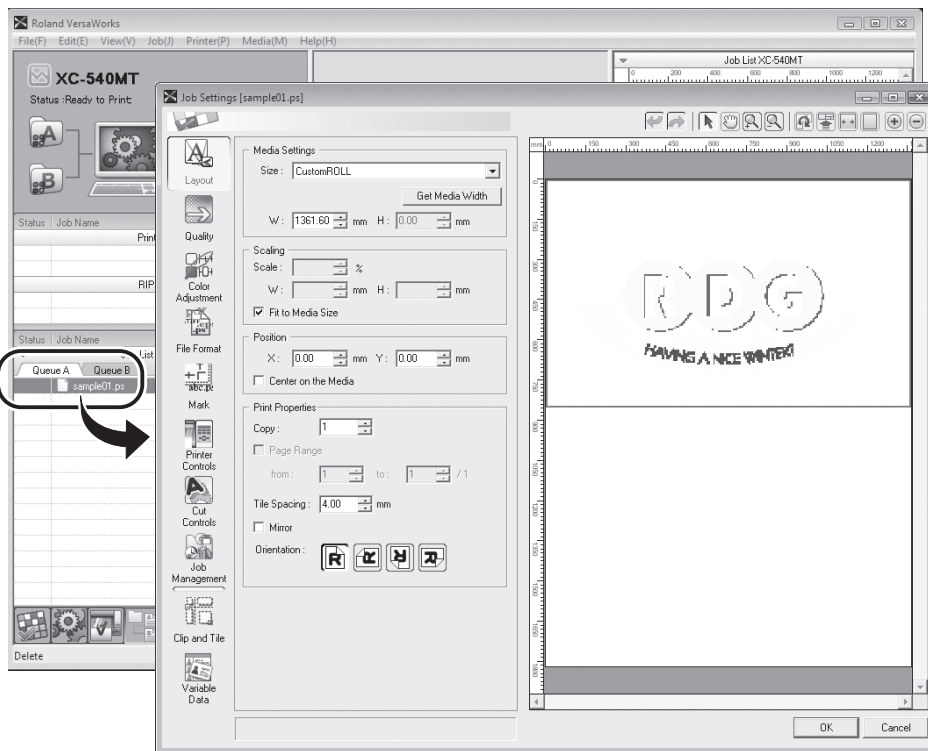
Select the print job in the job list, then click .

Printing will be started.

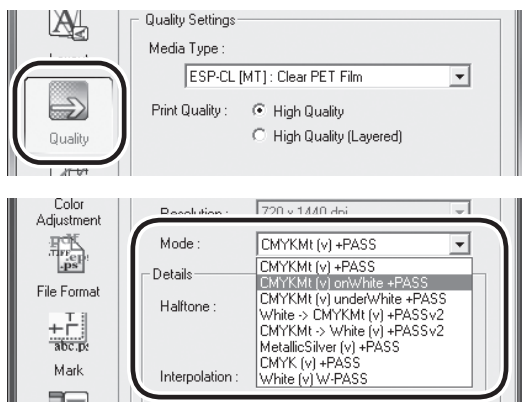
After printing and dry time, the media is pulled back. Continue printing of areas using metallic silver and CMYK colors.


## 2. Printing With Metallic Silver/CMYK Color

- 1 Double-click the print job that was used in the step 1. The "Job Setting" window appears.



- 2 < When performing blend print with metallic silver / CMYK >

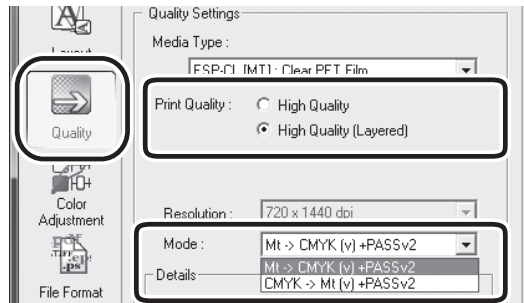


Click  . For [Print Quality], select [High Quality].

With [Mode], select the print mode " **CMYK Mt (v) onWhite .** " This prints the areas where metallic color, such as RDG\_MetallicSilver and RVW-MT-Bronze, and CMYK colors are specified.



## &lt; When performing layered print with metallic silver / CMYK &gt;

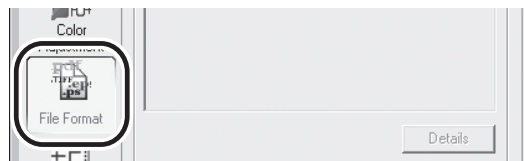
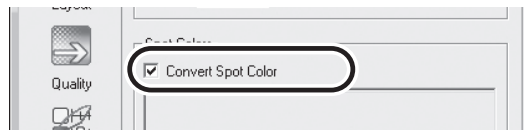
Click .

For [Print Quality], select [High Quality (Layered)].

With [Mode], select the print mode "Mt -&gt; CMYK(v)."

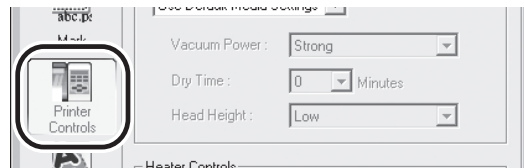
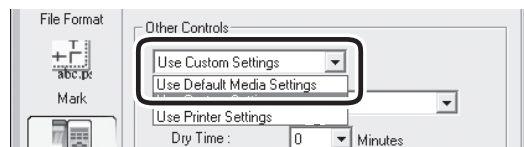
This prints the areas where metallic color, such as RDG\_MetallicSilver and RVW-MT-Bronze, and CMYK colors are specified.

3

Click .

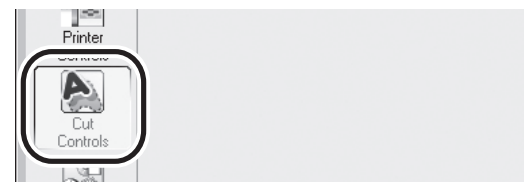
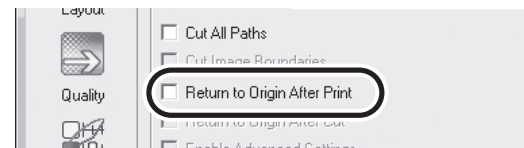
Turn on the [Convert Spot Color] option.

4

Click .

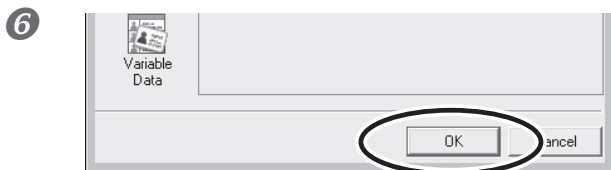
With [Other Controls], select "Use Default Media Settings."

5

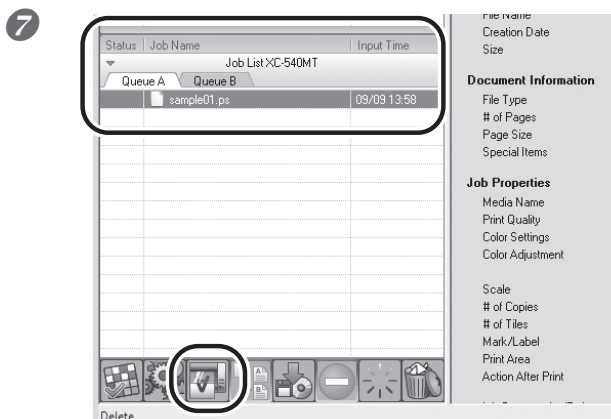
Click .


Turn off the [Return to Origin After Print] option.

## 4-1 Pullback printing



Click [OK] to close the “Job Setting” window.



Select the print job in the job list, then click . Printing will be started.

### Tips!

After printing, allow the ink to dry sufficiently. We strongly recommend performing lamination.

### Tips!

When continuing printing using another data that uses metallic silver, white, and CMYK colors, repeat steps on and after 1.-7. Also, if you want to modify detailed settings for each job, it will be convenient to perform modifications in the “Job Setting” window (displayed by double-clicking the print job in the job

## Pullback printing (Metallic silver/CMYK ⇨ White)

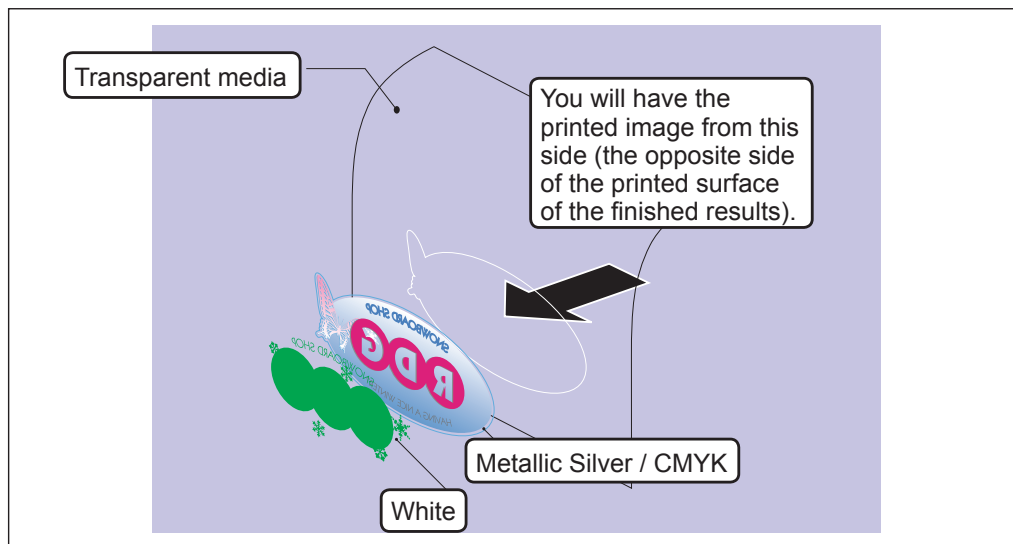
This section describes how to perform printing in the sequence of metallic silver/CMYK Color and then white. After performing printing using metallic silver and CMYK ink and allowing the ink to dry for predetermined period, the media is pulled back once, and then the fill overprinting is performed using white ink. The printing data containing metallic colors such as "RDG\_MetallicSilver" and "RVW-MT-Bronze" must be used in order to use the metallic silver ink, and the printing data containing "RDG\_WHITE" must be used in order to use the white ink.

☞ P. 12, "Creating Printing Data"

### IMPORTANT!

This printing method involves some important notes for avoiding contamination on the printed surface. Be sure to refer to page 6, "When Performing Pullback Printing".

Image of overprinting in the sequence of metallic silver/CMYK and then white.



## 1. Printing With Metallic Silver/CMYK Color

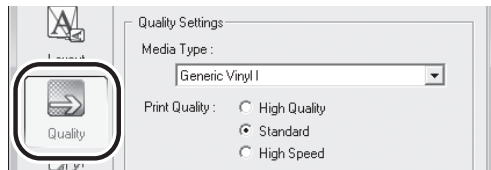
- 1 Make sure that you have finished making the preparations for VersaWorks, creating the printing data, and getting the printer ready (☞ p. 9, "Chapter 2 Getting Ready").



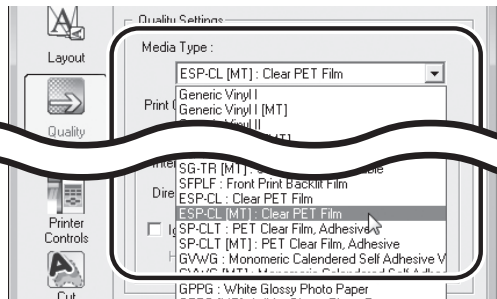
Double-click .

"Queue A Properties" window appears.

**3 < When performing blend print with metallic silver / CMYK >**

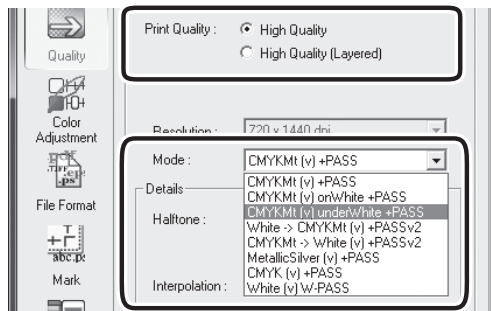


Click .



For [Media Type], select "xxx[MT]: Clear Film" or "xxx[MT]: Clear Film, Adhesive."

\*"xxx" indicates "ESP-CL" and others.

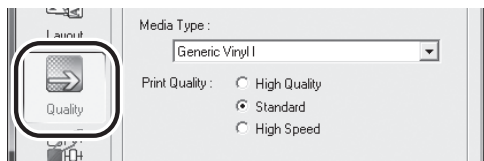


For [Print Quality], select [High Quality].

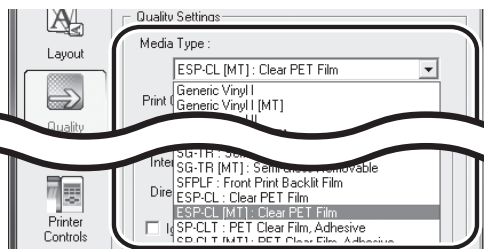
With [Mode], select the print mode "CMYK Mt (v) underWhite."

This prints the areas where metallic color, such as RDG\_MetallicSilver and RVW-MT-Bronze, and CMYK colors are specified.

**< When performing layered print with metallic silver / CMYK >**

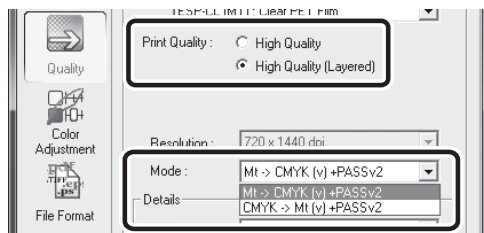


Click .



For [Media Type], select "xxx[MT]: Clear PET Film" or "xxx[MT]: PET Clear Film, Adhesive" (or xxx: Clear PET Film, "xxx: PET Clear Film, Adhesive).

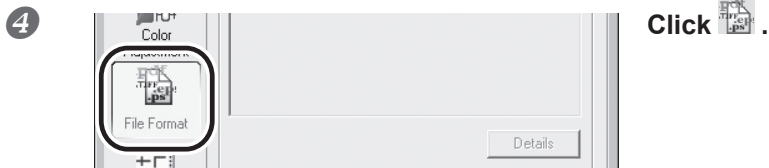
\*"xxx" indicates "ESP-CL" and others.



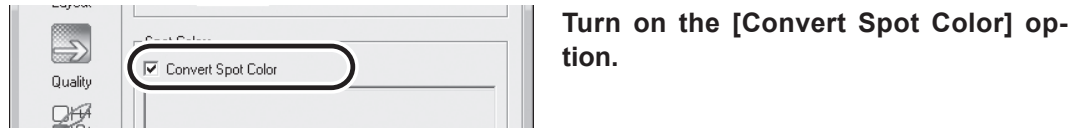
For [Print Quality], select [High Quality (Layered)].

For [Mode], select [CMYK -> Mt(v)].

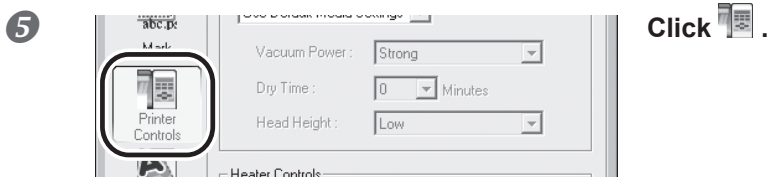
This prints the areas where metallic color, such as RDG\_MetallicSilver and RVW-MT-Bronze, and CMYK colors are specified.



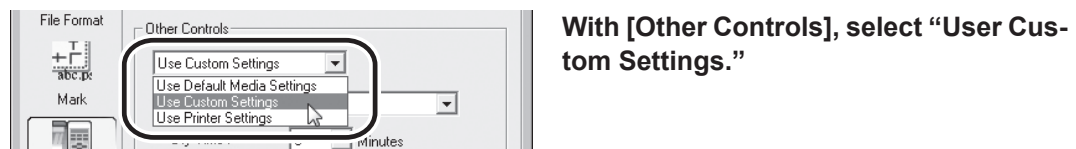
Click  .



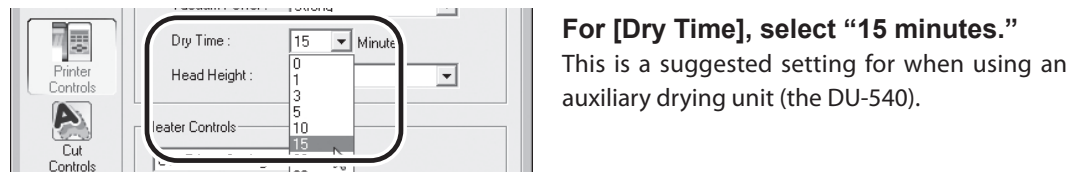
Turn on the [Convert Spot Color] option.



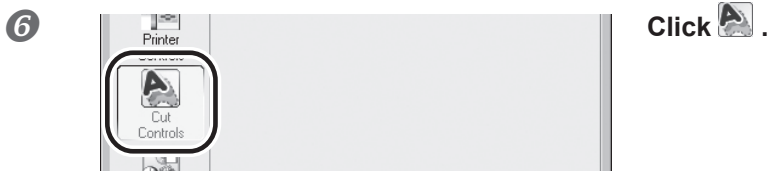
Click  .



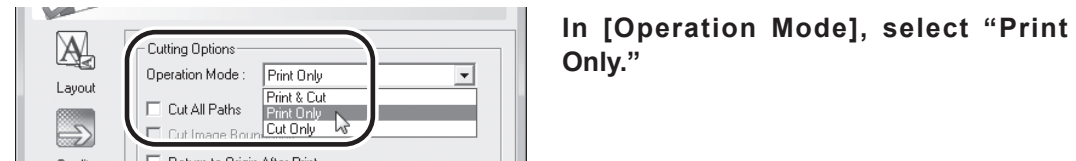
With [Other Controls], select “User Custom Settings.”



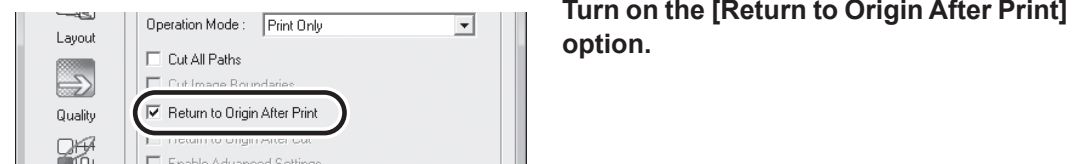
For [Dry Time], select “15 minutes.”  
This is a suggested setting for when using an auxiliary drying unit (the DU-540).



Click  .



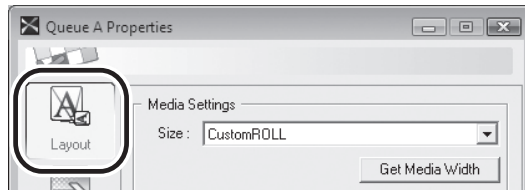
In [Operation Mode], select “Print Only.”



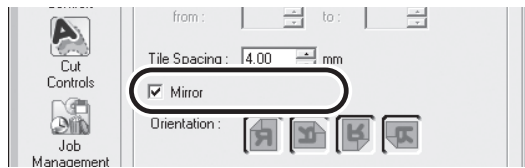
Turn on the [Return to Origin After Print] option.

## 4-1 Pullback printing

When You Want to Display the Side Opposite the Printed Surface

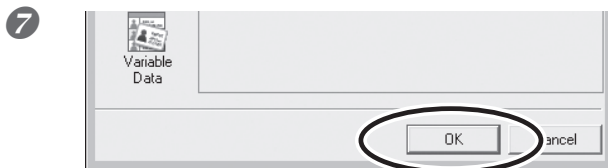


Click .

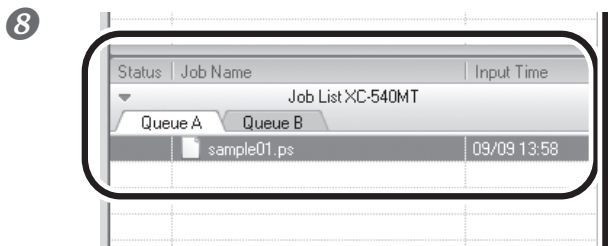


Turn on the [Mirror] option.  
When the printing data with mirror image is prepared beforehand, you do not need to turn on this option.

NOTE: This section only described the settings that are necessary for the use of the metallic silver ink. For other settings, refer to the online help provided for VersaWorks.

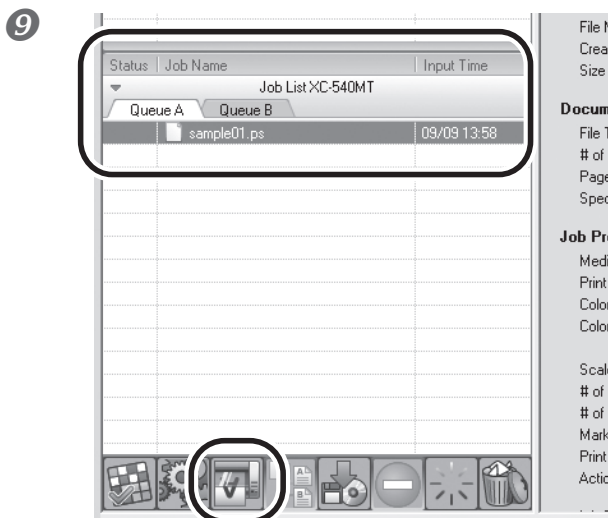


Click [OK] to close the “Queue A Properties” window.



Go to “Job List” and click the “Queue A” tab, and drag the printing data to the queue A job list.

The contents of the data are displayed in the preview window, and the layout on the media is displayed in the layout window.



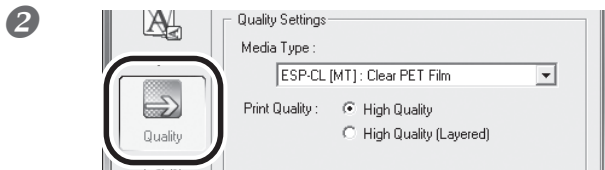
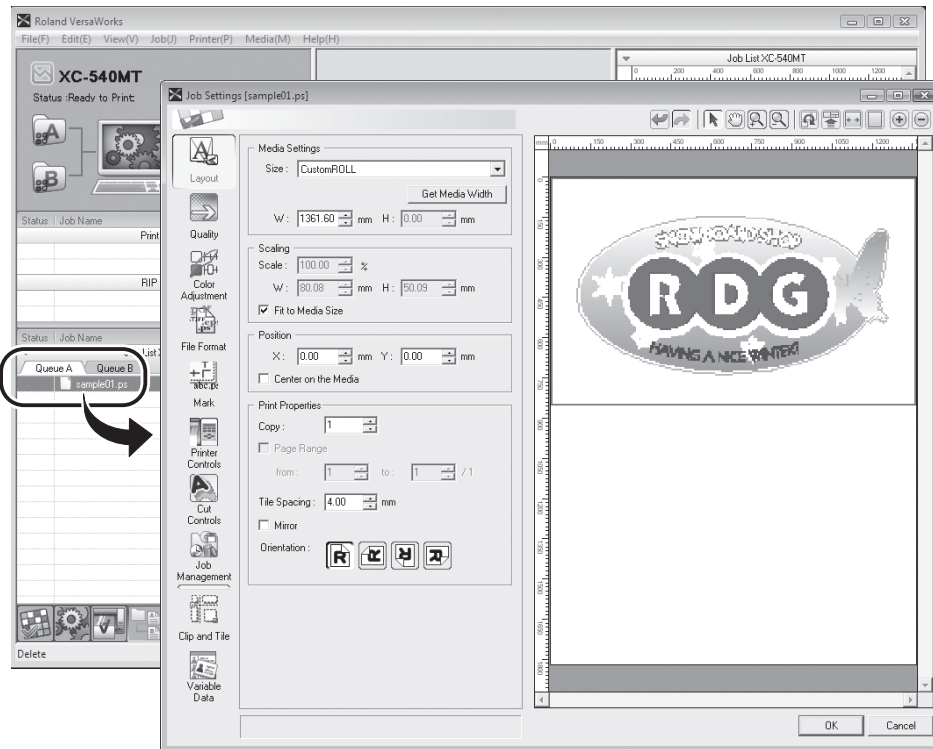
Select the print job in the job list, then click .

Printing will be started.

After printing and dry time, the media is pulled back. Then, print the white areas.

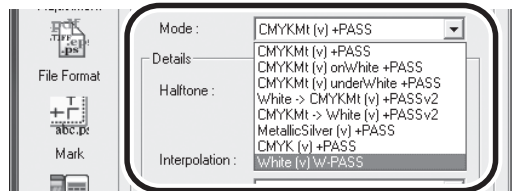
## 2. Printing With White Ink Only

- 1 Double-click the print job that was used in the step 1.  
The "Job Setting" window appears.



Click .

For [Print Quality], select [High Quality].



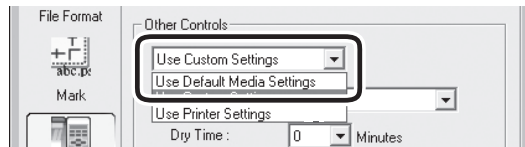
With [Mode], select the print mode "White (v) ."

This prints with RDG\_WHITE only.

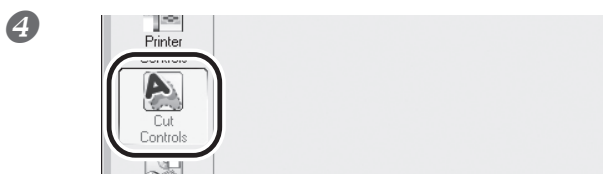
## 4-1 Pullback printing



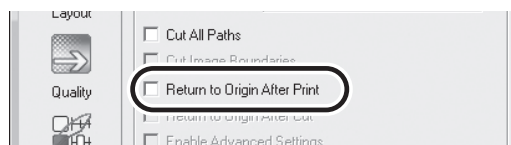
Click .



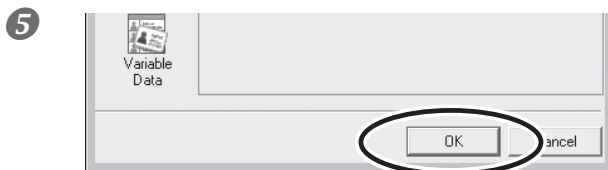
With [Other Controls], select "Use Default Media Settings."



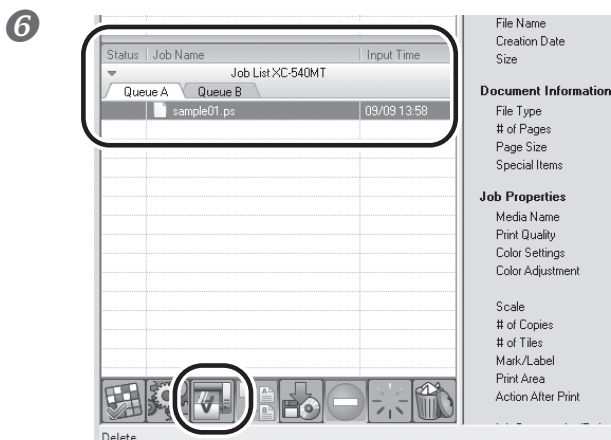
Click .




Turn off the [Return to Origin After Print] option.



Click [OK] to close the "Job Setting" window.



Select the print job in the job list, then click . Printing will be started.

### Tips!

After printing, allow the ink to dry sufficiently. We strongly recommend performing lamination.

### Tips!

When continuing printing using another data that uses metallic silver, white, and CMYK colors, repeat steps on and after 1.-8. Also, if you want to modify detailed settings for each job, it will be convenient to perform modifications in the "Job Setting" window (displayed by double-clicking the print job in the job list).



## 4-2 Performing Texture Printing

### What is Texture Printing?

Texture printing is a printing method to produce texture patterns. This uses the texture patterns of the exclusive library to create and output the printing data. This document describes the texture printing using metallic silver ink.

- \* Create the printing data using the Adobe Illustrator version of CS or later if using Adobe Illustrator. If you use the earlier version before Adobe Illustrator 10 to create the printing data, the texture patterns may result in poor condition.

### Create The Texture Printing Data

To create the data for the texture printing, please follow the instructions below.

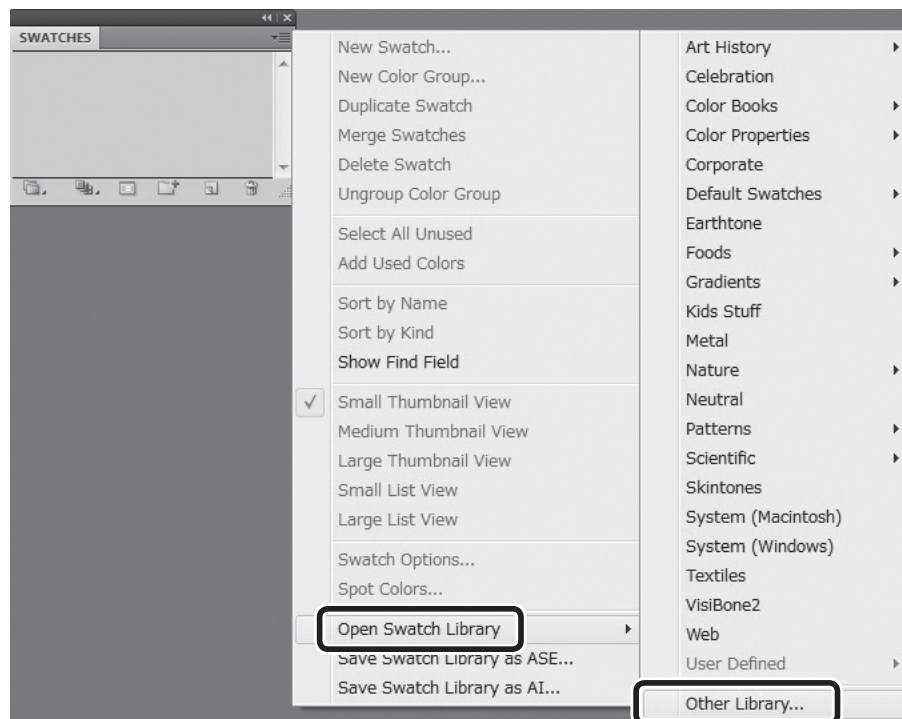
The program used to create the printing data is Adobe Illustrator CS4. For detailed information on drawing methods and how to work with palettes, refer to the documentation or online help for Adobe Illustrator CS4. If you're using another version of Adobe Illustrator, operations may be somewhat different from those explained here.

#### 1. Open the exclusive library.

- 1 **At the swatch palette menu, select [Open Swatch Library], then [Other Libraries].**

The "Select Library" window appears.

\* The swatch palette is displayed by going to the menu and selecting [Window], then [Swatch].



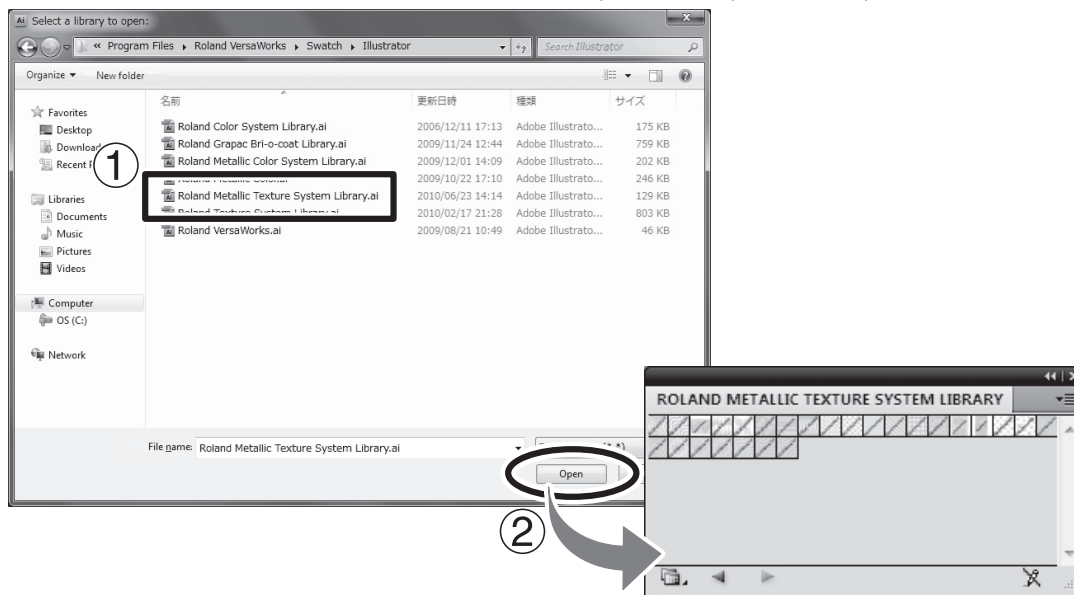
## 4-2 Performing Texture Printing

- ② ① Open folder in the order of [Computer] (or [My Computer]) → [Local Disk (C:)] → [Program Files] → [Roland VersaWorks] → [Swatch] → [Illustrator], and then select "Roland Metallic Texture System Library.ai."

Depending on the settings of your computer, the extension ".ai" might not be shown.

- ② Click [Open].

The exclusive swatch libraries "Roland Metallic Texture System Library.ai" is displayed.



### Tips!

By saving the ".ai" file selected in step ② into the folder below, you can register the exclusive library to the Adobe Illustrator's library.

C:\Program Files\Adobe\Adobe Illustrator CS4\Preset\Swatch  
(“C” is the name of your computer's local disk.)

Once the registration is performed, you can open the library directly from the swatch palette menu, eliminating the need to search the file every time you start Adobe Illustrator.

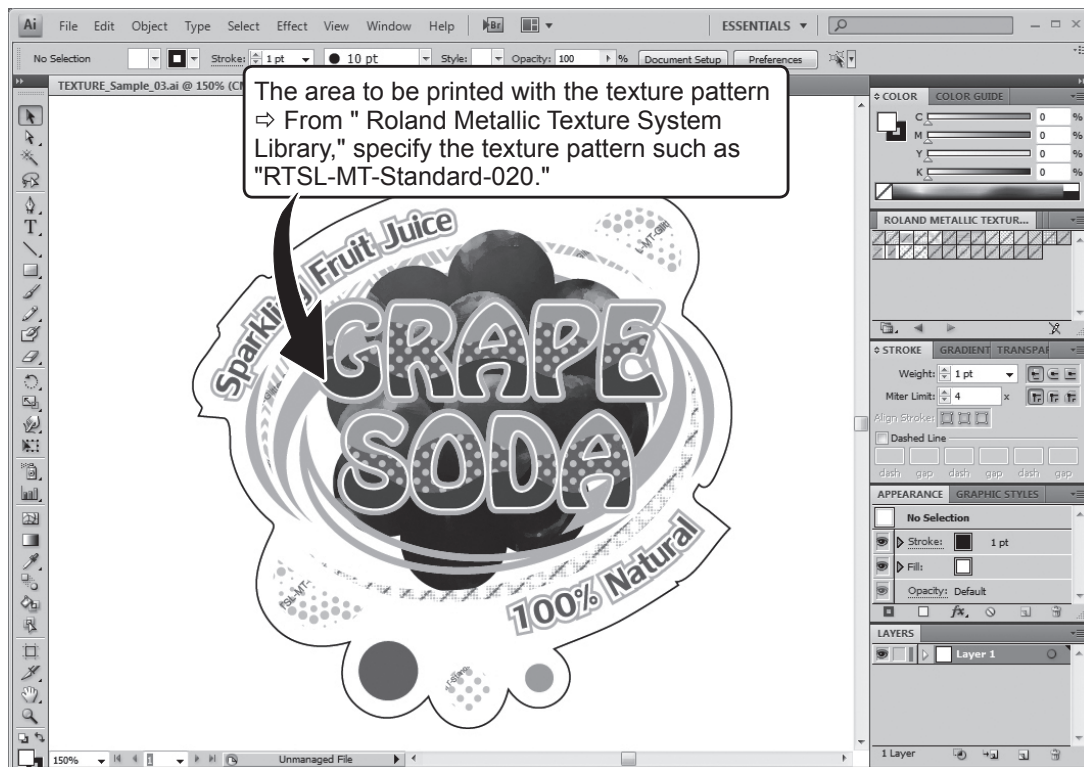
## 2. Create Illustrations and Specify Texture Patterns You Wish to Use

### 1 Create the illustration.

Be sure to draw the illustration in the CMYK mode.

### 2 Assign the desired texture patterns to the areas for the texture printing.

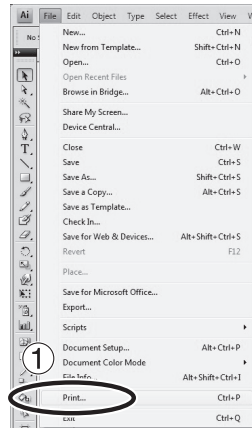
The areas where the texture patterns are assigned shall be printed with metallic silver ink. When the metallic silver ink is to be used for the printings other than the texture printing, other special spot colors shall be used. For the detailed usage, please refer to "Chapter 2 Getting Ready".



- \* The name of the texture pattern is displayed on the data of Illustrator. The texture of the displayed image appears rougher than that of the actual print.

### 3. Create the PS (PostScript) file.

1

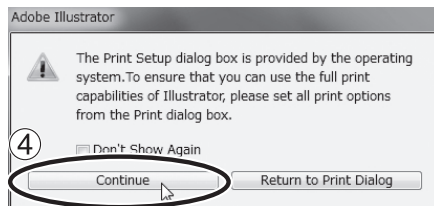
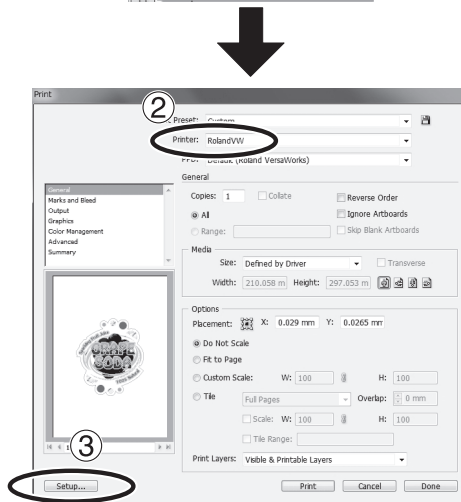


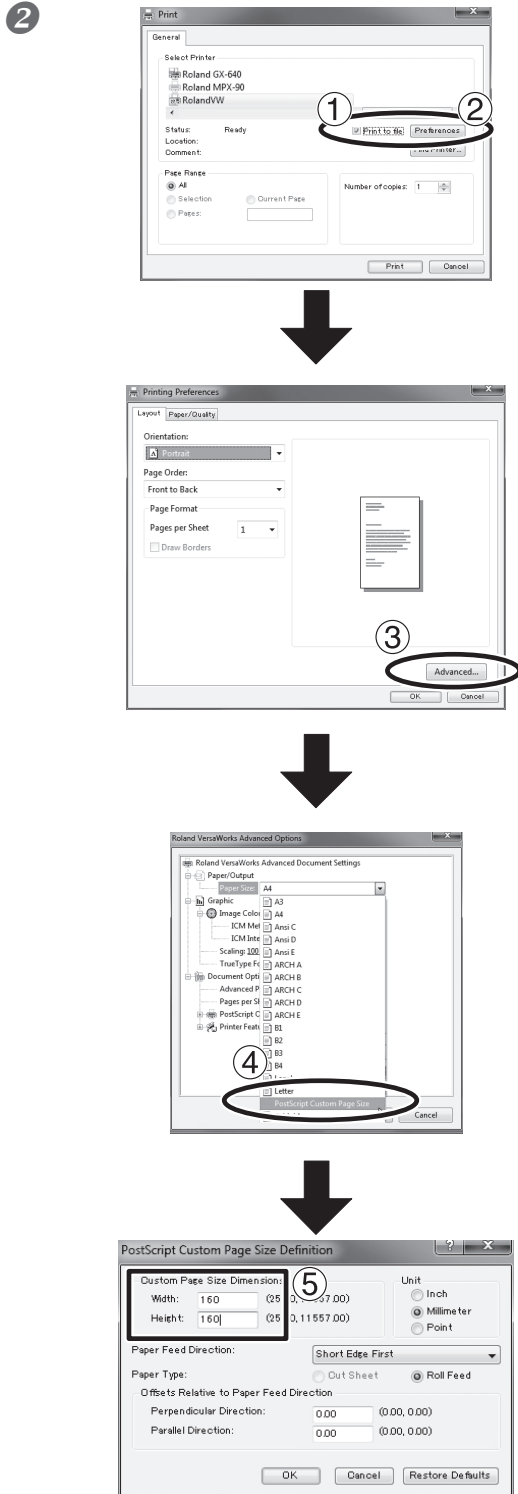
1 Click [Print] from the [File] menu.

2 Select [Roland VW].

3 Click [Setup].

4 Click [Continue].





① Turn on the [Print to file] option.

② Click [Preferences].

③ Click [Advanced] in the [Layout] tab. For Windows 2000: In the "Print" dialog box (the window at the very top of this page), go to the "Layout" tab and click [Advanced].

④ Click the down arrow to the right of the [Paper Size] box, and then click [PostScript Custom Page Size] from the list that appears.

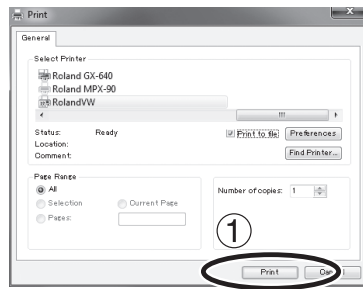
⑤ For "Custom Page Size Definition," enter the values in the "Width" and "Height" fields.

Enter values for the same size as the illustration you created in step 2..

③ Click [OK] three times to close the "PostScript Custom Page Size Definition," "Roland VersaWorks Advanced Options," and "Printing Preferences" dialog boxes. The "Print" dialog box returns.

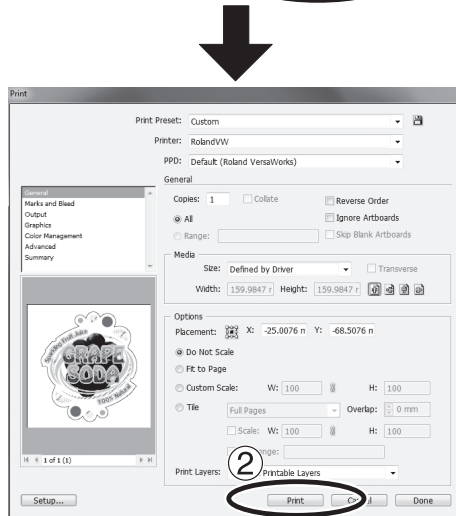
## 4-2 Performing Texture Printing

4

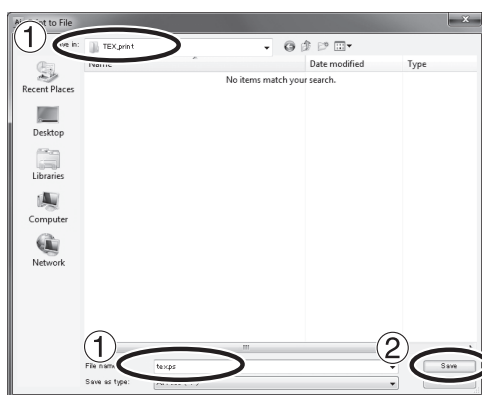


① Click [Print].

② Click [Print].



5



① Specify the destination and file name for saving, then save the file.

Example: "TEX\_print" for the folder to save to, and "tex.ps" as the file name

② Click [Save].

The CMYK layer of the image is saved as a PS file.

⑥ Open the folder you saved to and make sure the file has been created.

## Performing Texture Printing

### Procedure

- 1 Prepare the printing data having been created in the previous process which is described in "Create The Texture Printing Data" on page 55.
- 2 Make the setting to output metallic silver ink with the VersaWorks, and execute the printing.

To use metallic silver ink, you need to select "CMYKMt", etc. in the print mode of the VersaWorks. For the detailed method of setting, please refer to "Chapter 3 Printing".

## Printing a Texture Chart

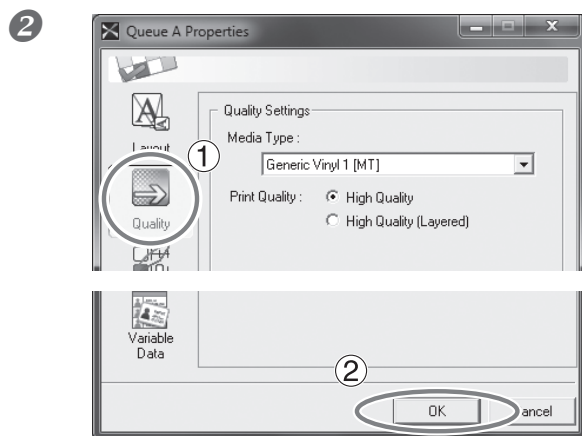
The texture chart is the printing sample of the texture pattern. By printing the texture chart, you can confirm the "complete texture chart" representing the texture itself that can be printed with "Your Printer" and "Your Media" (slight pattern differences is possible to occur depending on the conditions of the printer and media.) By selecting a pattern from this texture chart and creating the printing data using that selected pattern, you can print your intended pattern almost perfectly.

### procedure



Double-click .

The [Queue A Properties] window appears.

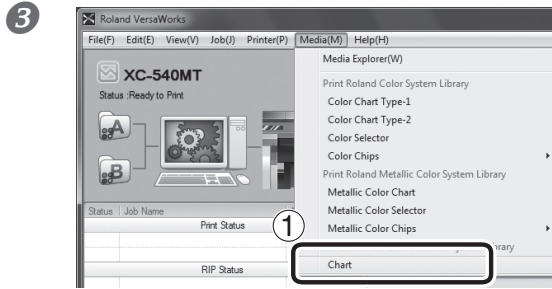


1 Click , configure the settings in [Quality Settings] and [Color Management].

2 Click [OK].

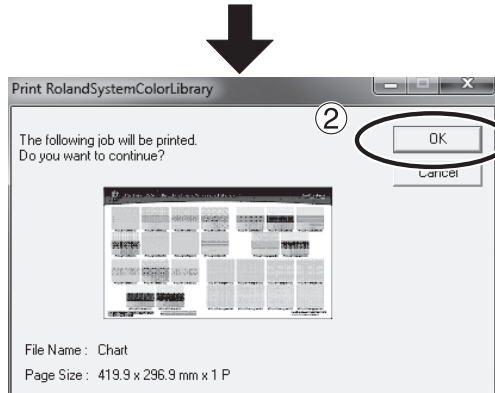
Note: When printing a texture chart, the [Quality] settings from the [Queue Properties] window are always applied. Since you cannot change the quality settings for the job using the [Job Settings] window after it has been added, be sure to configure the settings in the [Queue Properties] window before performing the following operations.

## 4-2 Performing Texture Printing



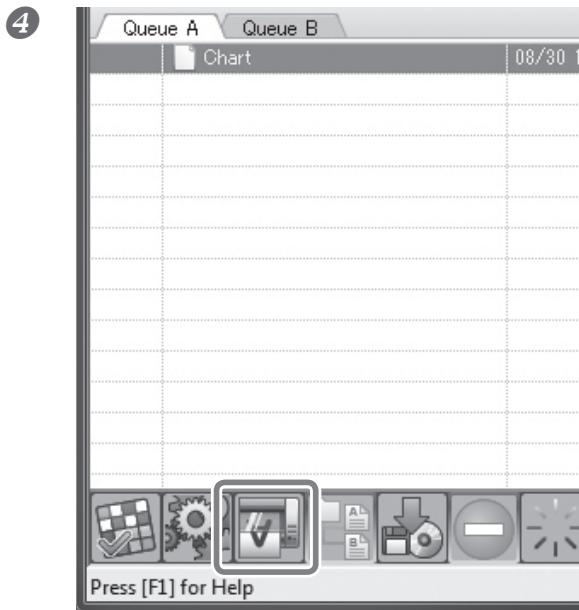
① Click [Chart] under [Print Roland Texture System Library] from the [Media] menu.

This message appears: The following job will be printed. Do you want to continue? Check that the media in the printer is large enough for the displayed page size.



② Click [OK].

The texture chart is added to the job list.



Click .

Rip'ing and printing the texture chart are performed.

\* In the texture chart, color is added to part of the background of the texture. This makes the design of the texture clear.



# ***Chapter 5***

## ***Maintenance***

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# 5-1 Maintenance

## Message for Ink Circulation

With this machine, white ink and metallic silver ink are circulated periodically to prevent the ink precipitation. When the following message appears, please wait until the display changes.

**[CIRCULATING INK]**

In order to allow the automatic maintenance such as above to be performed, please observe the items below.

- Leave the main power on at all times.
- Never leave the front cover open for long periods.
- After finishing making the settings for the various menu items, go back to the top screen.










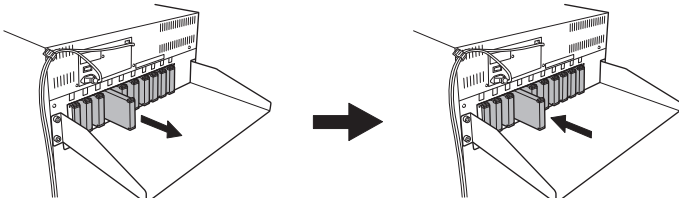
## When Dot Drop-out Etc. Cannot be Corrected

When using metallic silver ink and white ink, incorrect ink discharge, such as generation of dot drop-out, may occur even after cleaning is performed using the cleaning function or cleaning kit. This is due to the properties of metallic silver ink and white ink that ingredients tend to settle and separate, causing the precipitated ingredients to solidify after the machine is left unattended for a long period. In such cases, perform the operation described below. This operation requires two cleaning cartridges.

### IMPORTANT!

A large amount of ink will be discharged during this operation. Perform this operation only when dot drop-out and other issues cannot be corrected even after performing cleaning using the cleaning function (Normal, Medium, Powerful) or cleaning kit. For how to perform cleaning using the cleaning function or cleaning kit, refer to the XC-540/XC-540MT User's Manual.

### Procedure

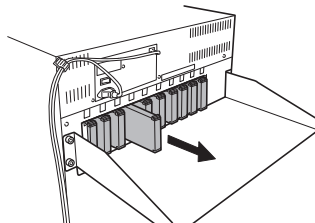
-  Press  .  
Press  several times.
  -  Press  .  
Discard the discharged fluid and attach the emptied bottle.
  -   
↓ Number 4 and 5 flashes.  
  
↓ Number 4 and 5 flashes.  
 Press  .  
① Remove the ink cartridges from slots 4 and 5.  
② Insert SOL INK cleaning cartridges into slots 4 and 5.
- 

④ REMOVE CL-LIQUID  
1 2 3 4 5 6 7 8 9 10

↓ Number 4  
and 5 flashes.

RENEWING INK . . .  
>>>>>>>>>>>>>>>>

Remove the SOL INK cleaning cartridges from slots 4 and 5. Carry out steps ③ and ④ as many times as indicated by the on-screen messages.

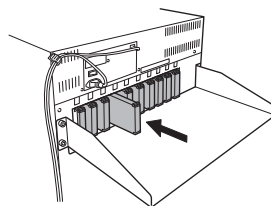


⑤ SET CARTRIDGE  
1 2 3 4 5 6 7 8 9 10

↓ Number 4 and  
5 flashes.

RENEWING INK . . .  
>>>>>>>>>>>>>>>>

Insert the ink cartridges into slots 4 and 5.



⑥ W 736mm

SETUP SHEET  
◀▶ ROLL

Press .  
Press to go back to the original screen.











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