

UniNet[®]

iColor[®]

PRINTING SOLUTIONS

iColor[®] 540 Digital Color + White Transfer Media Printer User Manual



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Important note about USB Drives shipped with your system: Do not lose your RIP dongle! This is your license key and if lost, a cost for replacement will be incurred. Associated USB dongles for software such as drivers, RIP programs, SmartCUT and more have a 3 month warranty on the physical drive. UniNet suggests that you limit the physical handling of RIP dongles and use external USB hubs (as an example). If damaged (past the 3 month warranty period), a cost for replacement will be incurred.

December 2019 Edition – A newer version of this manual may be available at www.icolorprint.com/support

iColor® 540 Digital Color + White Transfer Media Printer

The iColor® 540 printer has been developed to produce high-quality, conventional color prints with the out-of-the-box functionality of printing in white.

Please follow the enclosed quick setup guide, as well as this manual, to get started. The iColor® 540 comes complete with 4 toner cartridges for full color and black printing (CMYK), as well as our exclusive fluorescent white cartridge. Quickly swap the black for white when you want to add white as a spot color, or to print a white underprint or overprint in concert with the iColor® ProRIP software. Black can then be produced using composite black (made from CMY), or if true black and white is needed at the same time, just pass the print through the printer a second time. Our registration system will ensure the prints are lined up perfectly.

You will also have the option to add the fluorescent toner or dye sublimation toner upgrade kits, as well as the exclusive iColor® security and clear toner options, at any time.

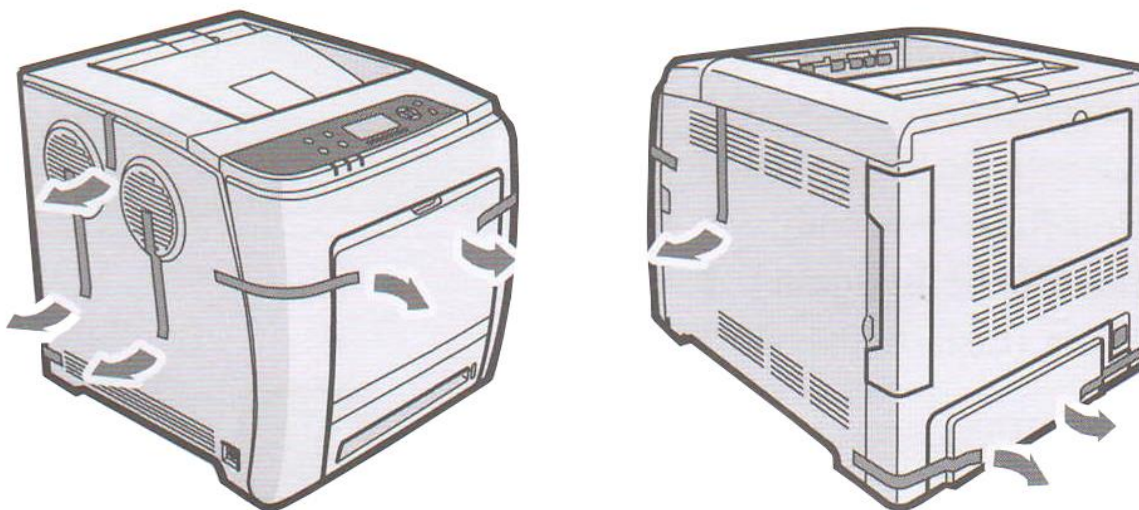
Please note that vector and line art images, including text, are likely to produce the best results. For exciting design ideas and suggestions for using the iColor® 540 for maximum effect, please visit our website at www.icolorprint.com.

iColor® Premium Transfer media has been optimized to provide quality results when used with the printer, enabling the user to produce eye-catching designs which may be applied to a variety of textiles and surfaces.

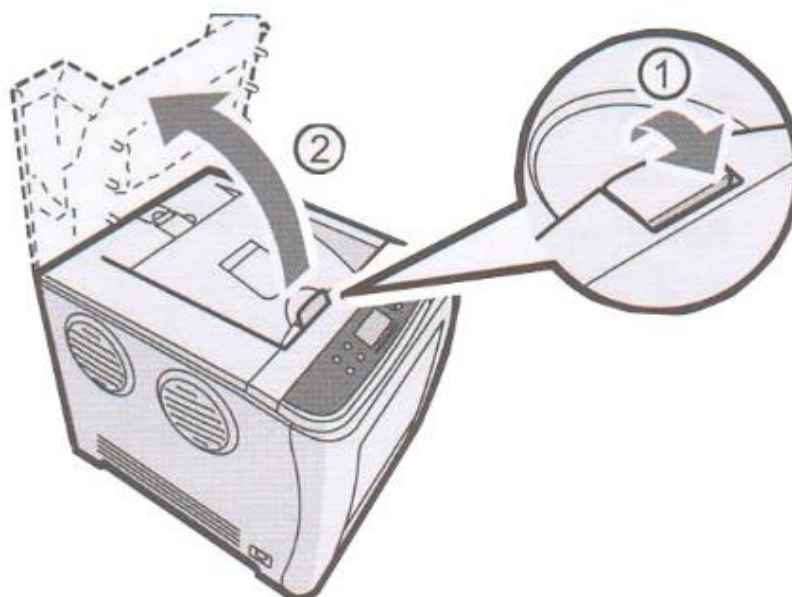
What's so unique about the iColor® 540 Digital Color + White Transfer Media Printer?

- The ability to print white as an underprint AND an overprint in the same machine, in one pass, using the iColor® ProRIP software.
- The white opacity of UniNet's unique blend of toner is double that of any other brand, giving you the brightest whites and solid backgrounds to bring out the vibrancy of your colors.
- The true black cartridge is included with the printer, allowing you to switch to CMYK mode to print items such as brochures and menus when white is not needed.
- Optional dye sublimation, fluorescent, security and clear toner cartridge options.
- Lowest cost and most flexible machine available.
- No maintenance typical with ink based machine is necessary. The iColor® 540 is a toner based system.
- Large array of media available for virtually any project.
- Global sales, support and service direct from UniNet or its dealer network.

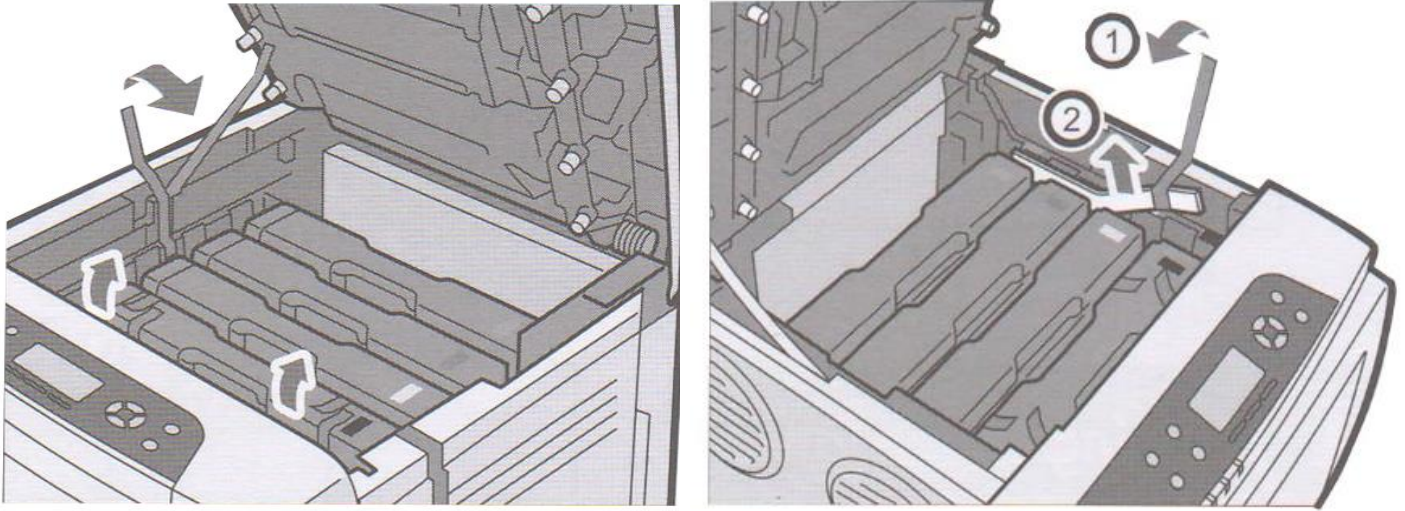
Unpacking and installing consumables



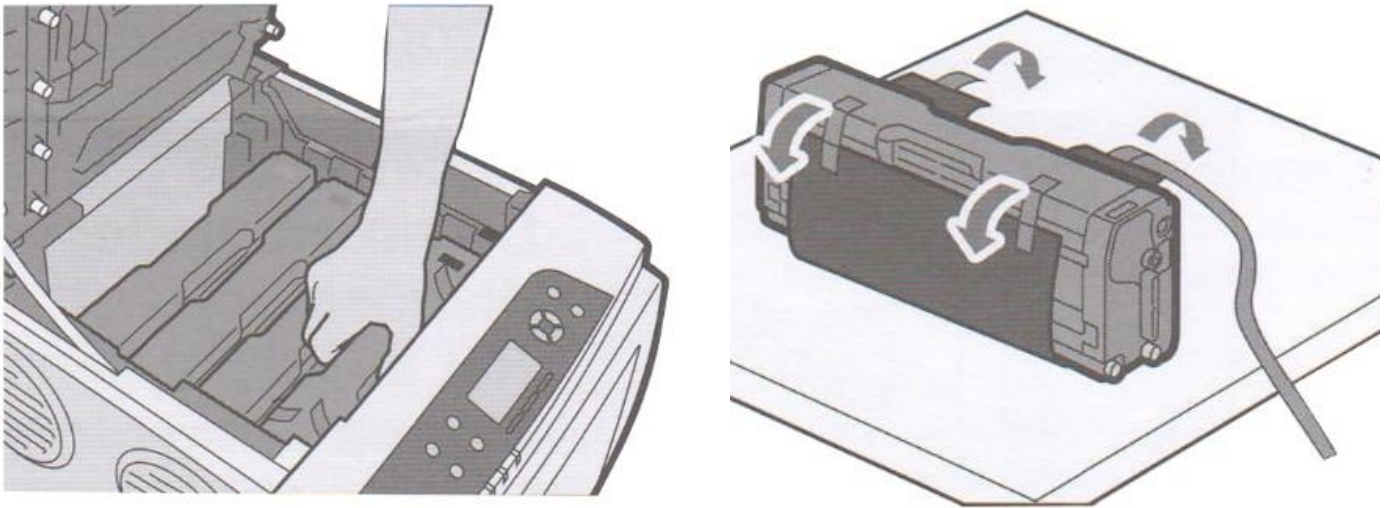
Remove orange security tape and packing material from around the printer.



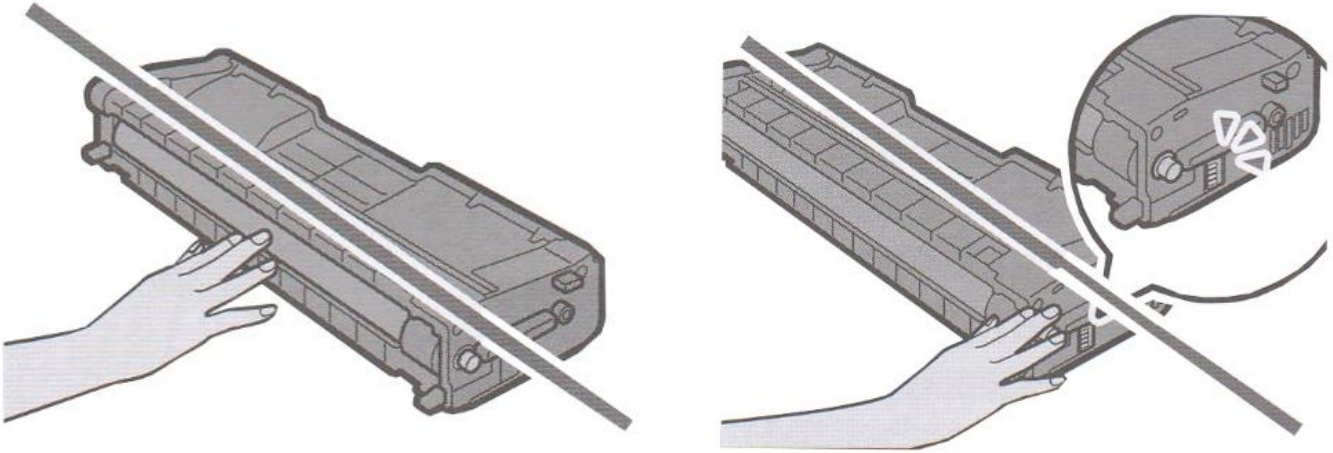
Open top lid.



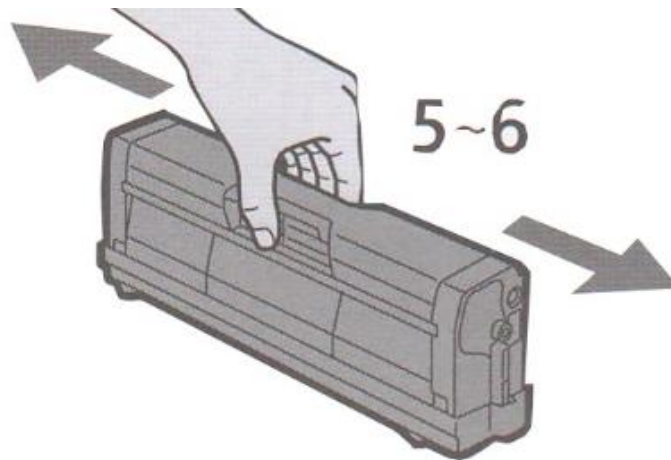
Remove orange security tape and packing material from inside the printer.



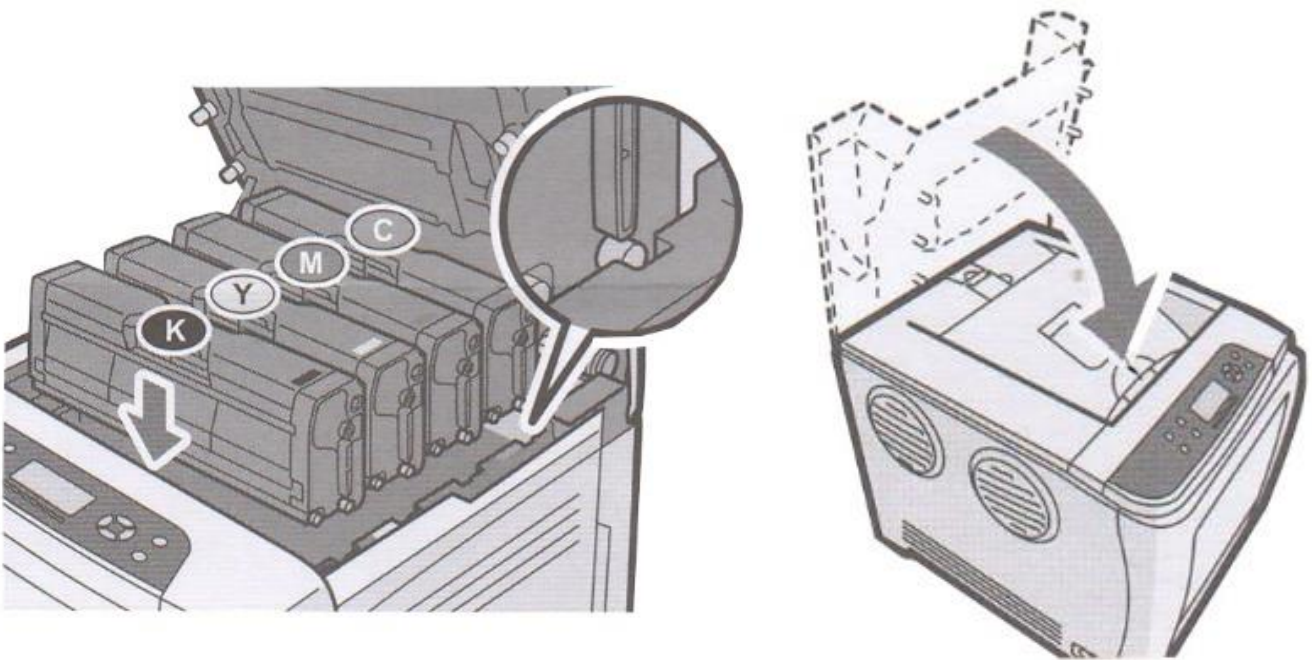
Remove the white toner cartridge from the front of the machine. Place it on a flat, solid surface and carefully remove the black security paper.



Be careful not to touch the drum or the contacts on the side of the cartridge.

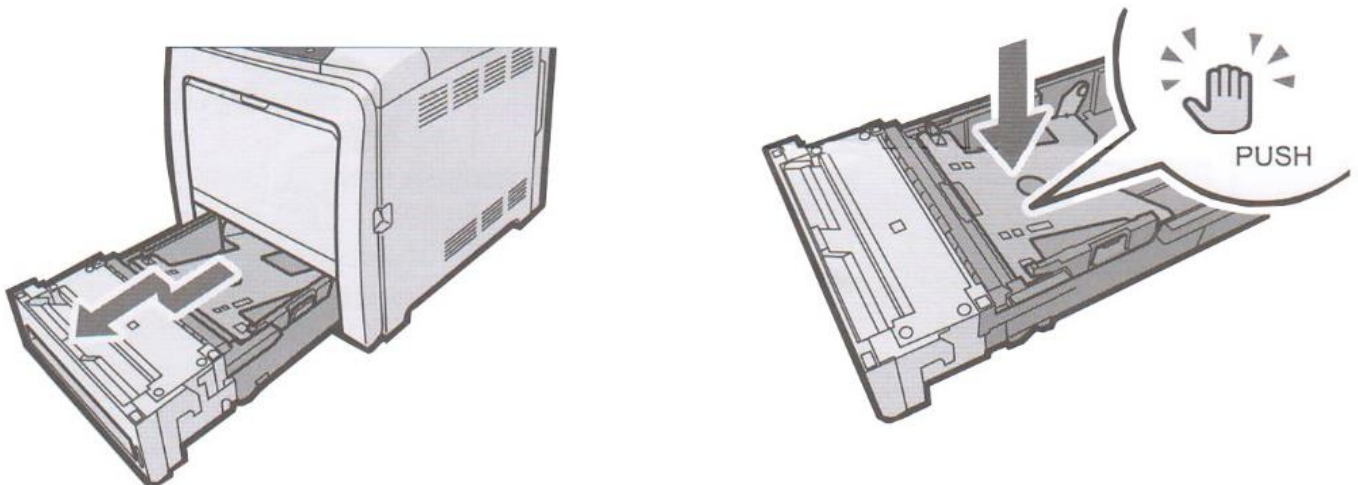


Remove each cartridge and gently shake back and forth 5 or 6 times to loosen the toner that may be settled in the cartridge due to shipping.

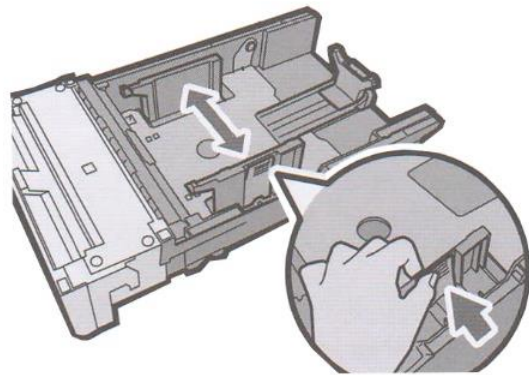
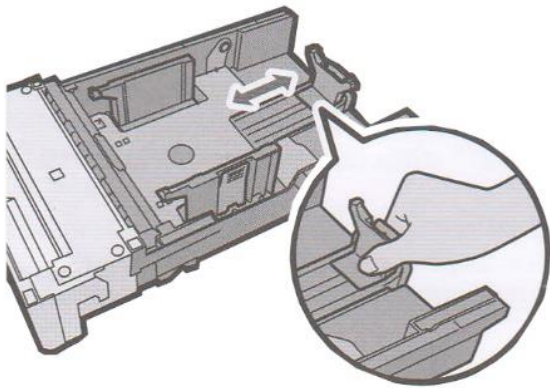


Reinstall the cartridges in the desired configuration (in the above representation, white or black can go into the first slot) and close the lid. Use white for transfer printing and black for normal CMYK printing.

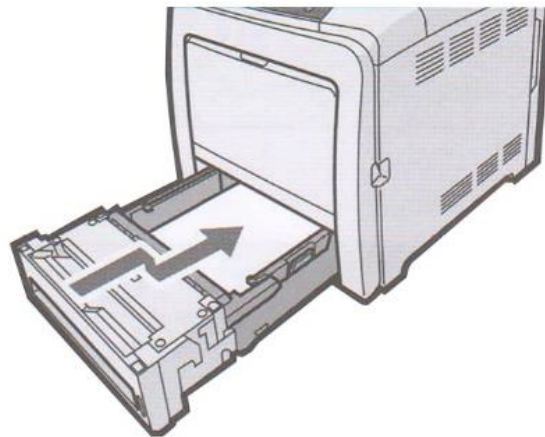
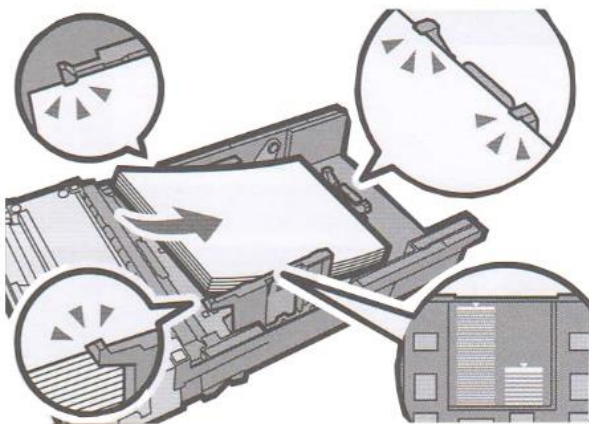
Loading Paper



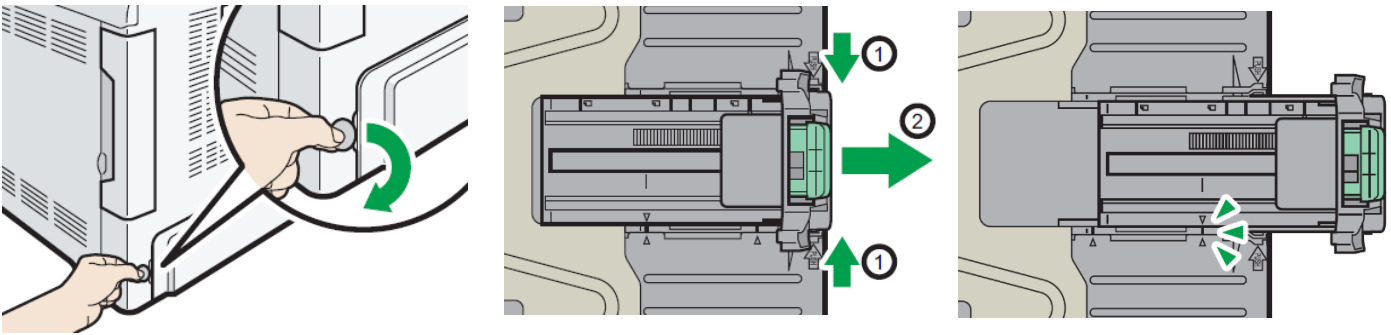
Pull out the paper cassette and push down the metal base.



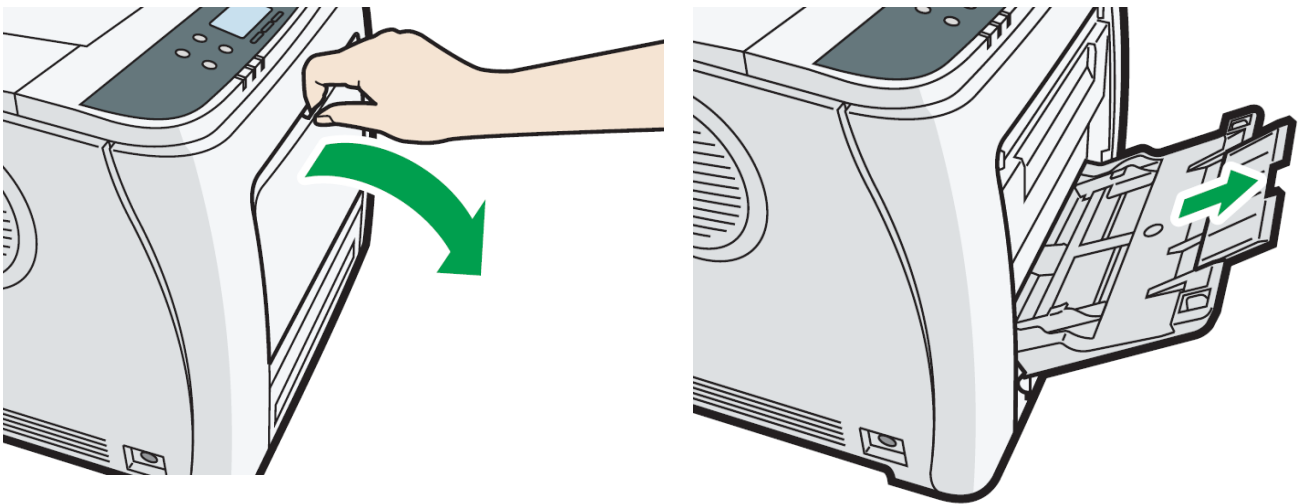
Squeeze the clips on the paper guides and slide them to match paper size. Do not move the paper guides forcefully. Doing so may damage the tray.



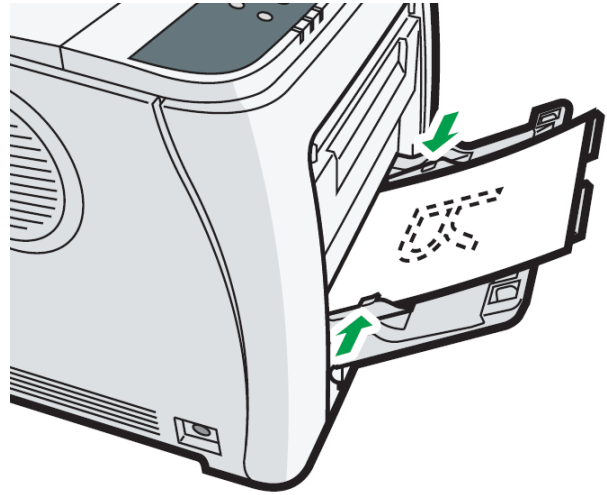
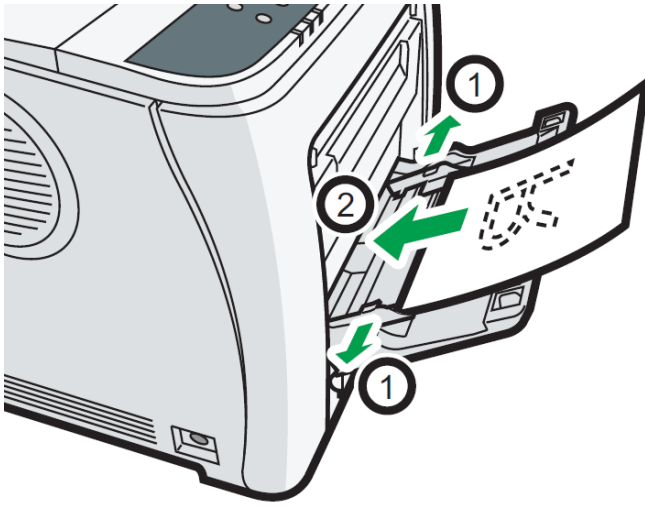
Load media with the print side face up and ensure it locks in underneath the guides before closing the cassette. Ensure the paper stack does not exceed the upper limit mark inside the paper tray. Excess stacking can cause paper jams.



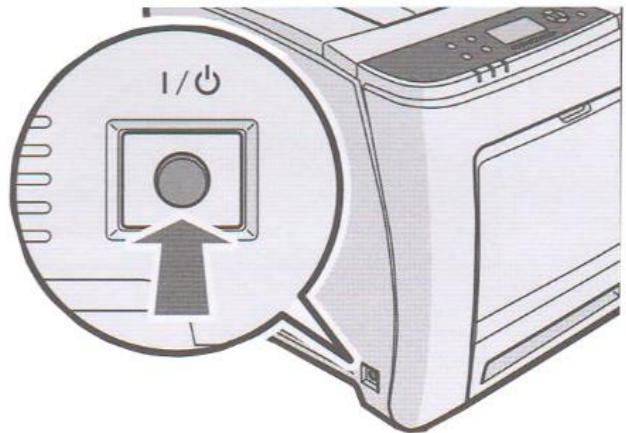
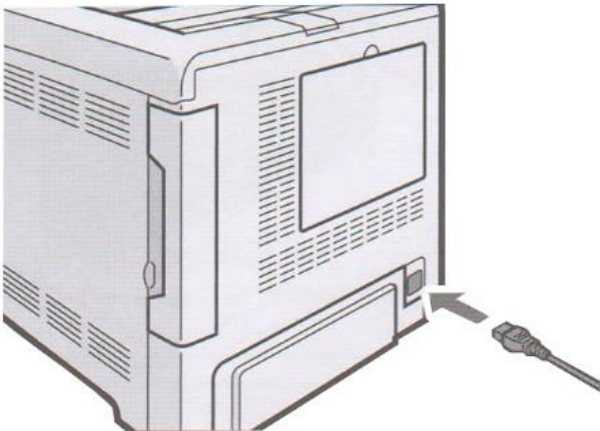
When loading paper longer than 11" into tray 1, remove the lower rear cover using a coin. Squeeze the rear extender and push outward to accommodate lengths up to 14" long. Do not extend this tray when loading A4 or letter size paper. Otherwise, a paper jam may occur.



To access the MPT tray, press and hold the lever at the top and pull out and down. Pull out the extender when loading paper larger than A4 or letter size.



Load the paper print side face down and adjust the guides as necessary.



Insert power cord and power on the unit as per the driver installation instructions.
If connecting via USB, do not plug in the USB cable until instructed to do so by the software.

Installing iColor® 540 printer on a PC

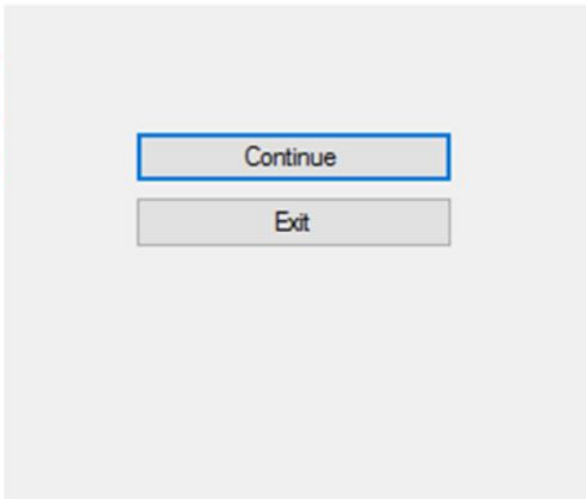
Choose the appropriate driver that shipped on the USB drive with your printer (Windows 32 or 64 bit). Only install this driver if you wish to print items outside of the RIP software, when white toner is not needed.

UniNet recommends setting up your printer via Network only if installing the driver.

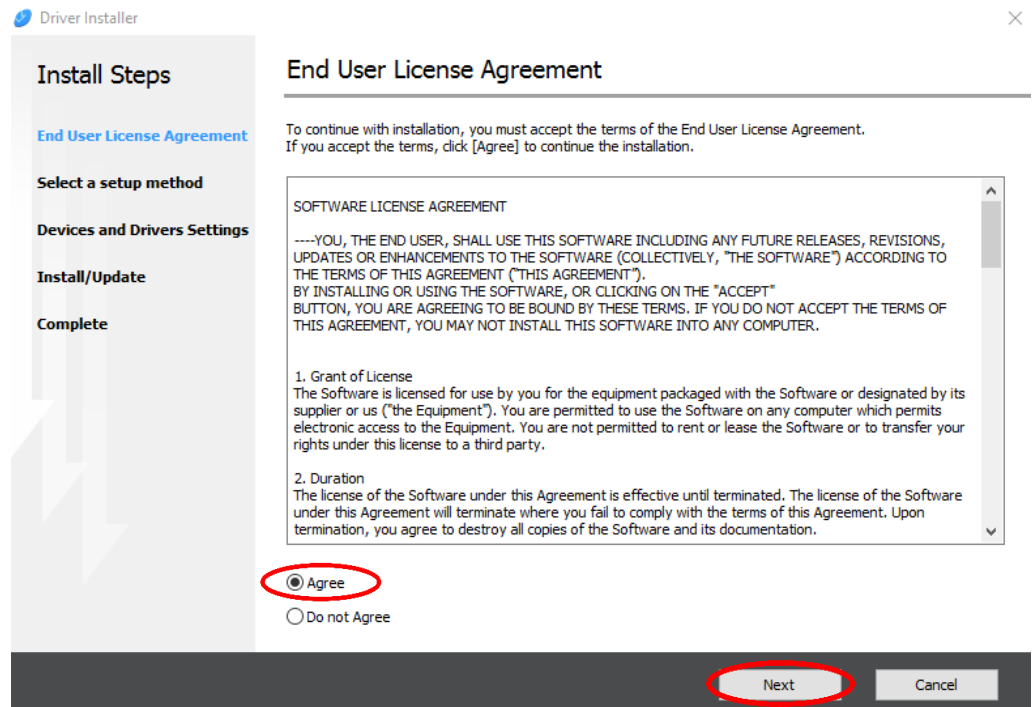
You must have Administrator privileges on the computer to proceed.

Network Setup:

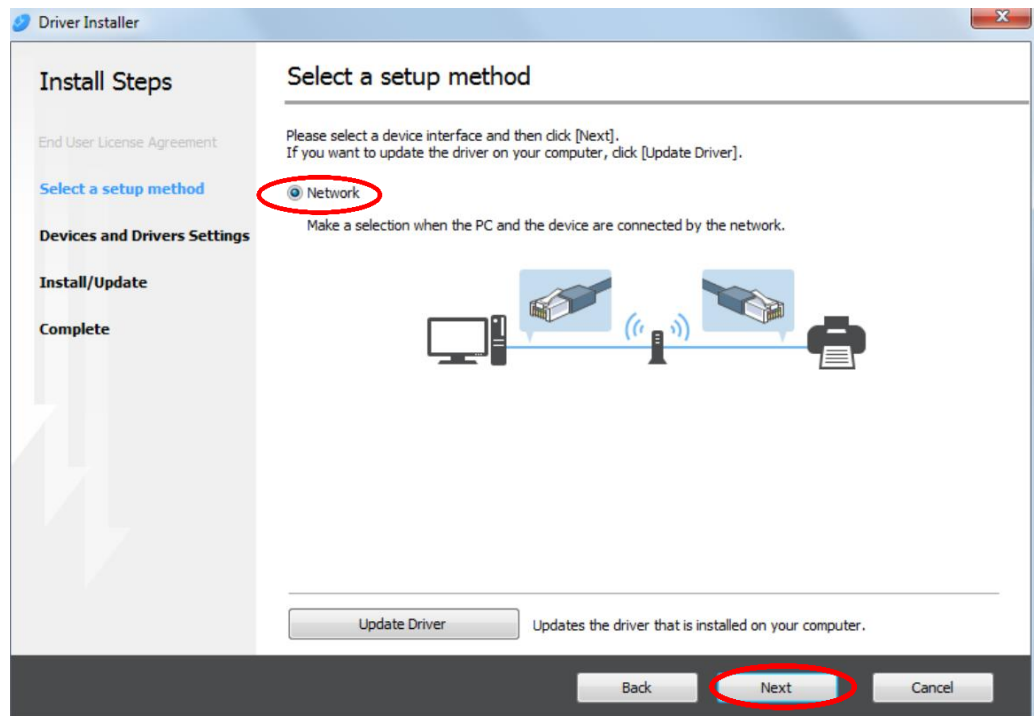
1. Connect the printer to your network via CAT 5 cable and power on the printer. Your network will automatically assign an IP address to the printer, but it is suggested that you program a static IP address to the printer to avoid possible reassignment of the IP address should the machine be powered off.
2. Locate the installation file on the USB drive that was shipped with your printer and double click to launch the setup program.
3. Click 'continue' to install the iColor® 540 driver.



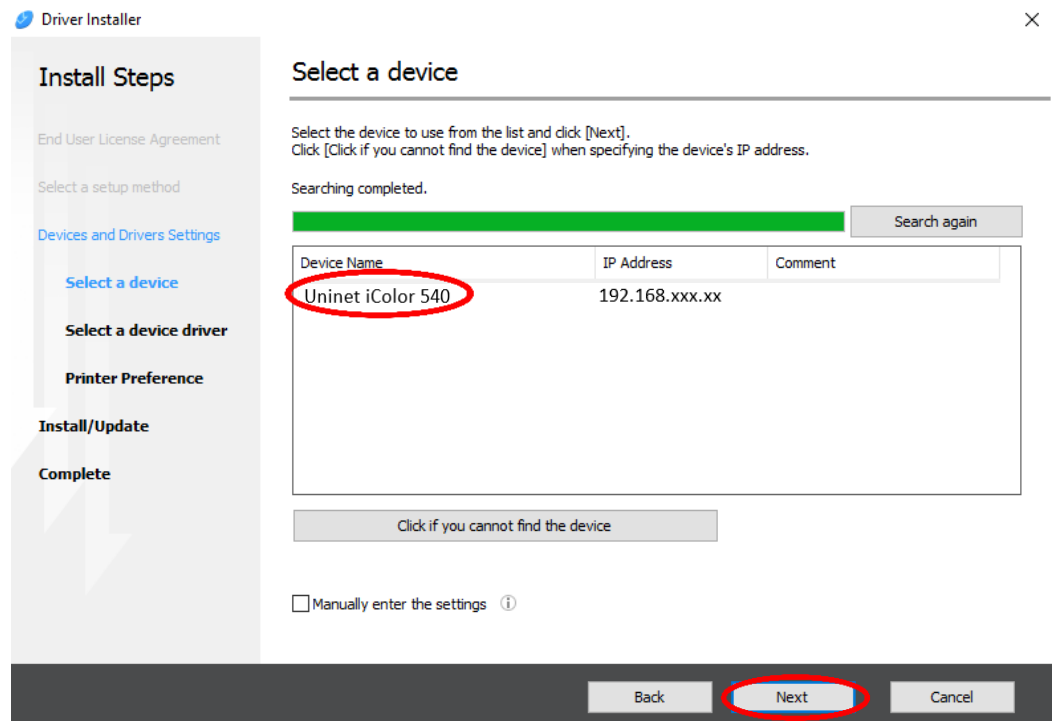
4. Agree to the End User License agreement and click 'Next'



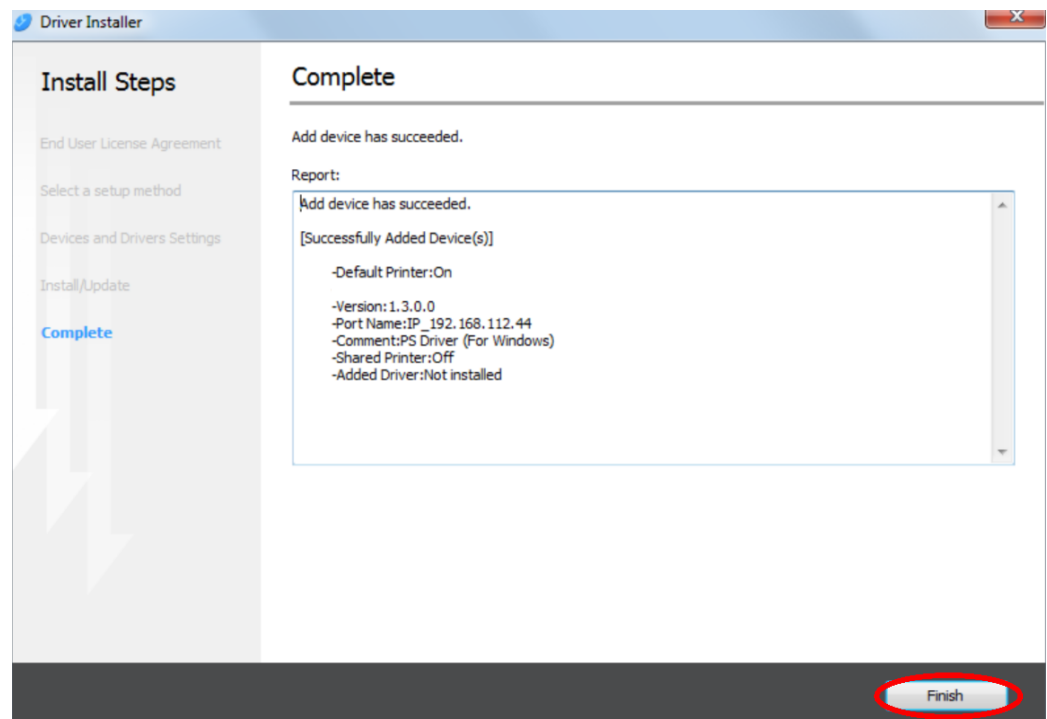
5. Select 'Network' and click 'Next'



6. The software will detect the printer on your network. Click on the printer and click 'Next'. The driver will now install.



7. Click 'Finish' to complete the install



8. Your printer will now be listed along with your other printers and devices.



Uninet iColor 540

9. You are now ready to install the iColor® ProRIP software. Installation software is on the USB drive that came with your printer.

NOTE – if the driver installation quits prematurely, it may be due to a conflict with some versions of Adobe Acrobat. UniNet recommends that you uninstall Adobe Acrobat and try the installation again. Once the driver is installed correctly, you can safely reinstall Adobe Acrobat.



Why use the iColor® ProRIP?

Use the iColor® ProRIP software to print white as an underprint or overprint in one pass. This professional version is designed for higher volume printing with an all new interface. Design files can be printed directly from your favorite graphics program, as well as imported directly into iColor® ProRIP.

The iColor® ProRIP software allows the user to control the spot white channel feature. Three cartridge configurations are available: Spot color overprinting, where white is needed as a top color for textiles; Spot color underprinting for printing on dark or transparent media where white is needed as a background color and standard CMYK printing where a spot color is not needed. No need to create additional graphics with different color configurations – the software does it all – and in one pass! Enhance the brilliance of any graphic with white behind color!

Print and Transfer onto:

Natural and synthetic fabrics
Dark and light fabrics
Beer, wine and juice bottles
White, colored or clear labels
Leather
Dark and light paper stock
Mugs and ceramics
Banners
Wood
Metal
Acrylic
And much more!

Create unique items - The possibilities are endless!

T-shirts and sweatshirts
Aprons
Dark restaurant menus with fluorescent white print
Corporate logo shirts
Mouse pads
Sports apparel
Jackets
Tote bags
Signs with colored, white or fluorescent toner
Labels
Tattoos

The most important point of the iColor® ProRIP software is that it allows colors to be put down in layers. Regular printer drivers only concern themselves with what the eye sees on the top layer, the RIP allows you to separately control each layer, thus giving you the ability to control not only what you see, but what is behind that top layer (typically the white layer). The iColor® ProRIP gives you the unique ability to use one machine to print images with white as an underprint or an overprint. You can now print vibrant colors on clear or dark media regardless of the background to which it is applied, where the white is put down first and the colors afterwards.

The iColor® ProRIP 'Color Mapping' feature also allows for reverse printing when printing and transferring to garments where white is put down last. This is the only way to achieve white underprint and overprint in one pass, and you will not find another software/printer package on the market today that can do all of this. The software also allows for color manipulation and removal, rasterization, professional layout tools and direct printing from your favorite graphics program. It ships standard with the iColor® 540 and as an upgrade for the iColor® 500 and 600.

To accomplish these two features, UniNet has created three configurations referred to as 'Print Queues' to suit any printing project:

Standard CMYK Printing



Spot Color Overprinting



Spot Color Underprinting



The **CMYK Queue** is for standard print jobs that do not require a spot color. This queue assumes that the media being printed on is white. Use this Queue for printing on banner media, window cling, Presto! Media and for Dye Sublimation prints. Note that for Dye Sublimation, there is an ICC Profile that is automatically loaded when this is selected.

The **Overprint Queue** is for printing white as an overprint in one pass for reverse printing (typically used for transfer printing). For this configuration, the white cartridge is placed in the first slot of the iColor® 540 printer and the cyan cartridge is placed in the last slot of the printer. This configuration is for textile and hard surface transfer printing, where white is needed as an overprint, applied on top of all the other colors. When the image is pressed to the garment, the transfer sheet is flipped over and the white becomes the underprint. This

is especially important where images have half tones and 100% transfer of the image can be problematic, or when there is white in the image that needs to show through on dark colored garments.

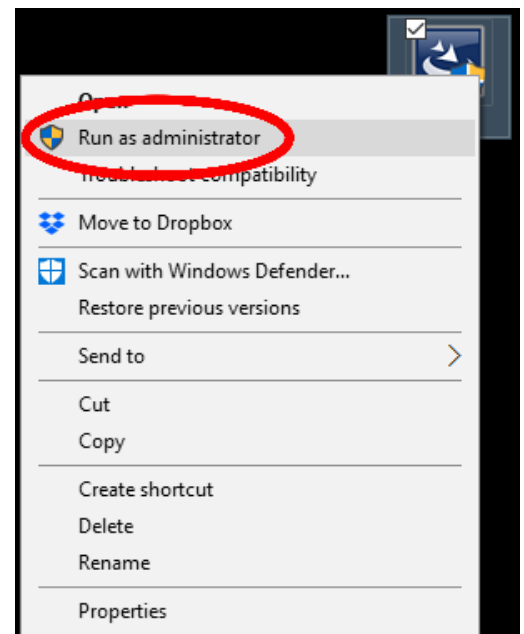
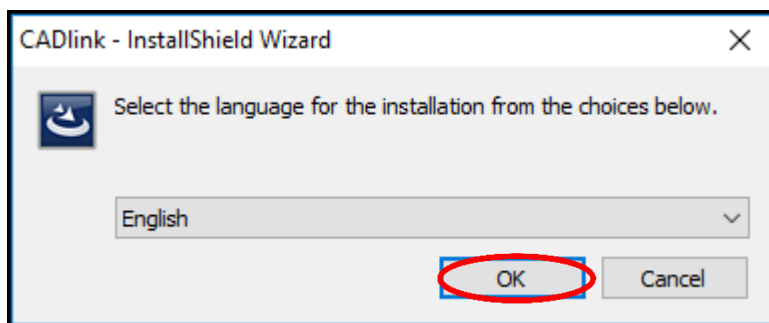
The **Underprint Queue** is for right side printing and allows for printing white as an underprint in one pass (typically used for transparencies, clear labels, dark media or UniNet Aqua Clear paper). When the white is installed in the last slot of the iColor® 540 printer, this is configured for 'Right Side Printing' where the white is printed first, as an underprint, all in one pass. In this situation, the RIP converts pure K colors to CMY composite black, and puts in white, not only as a background color, but also in the image where white or page white is specified.

For the Overprint and Underprint configurations, the exclusive Color Mapping feature of the RIP overrides the basic driver of the printer and automatically sends the proper color to the proper channel.

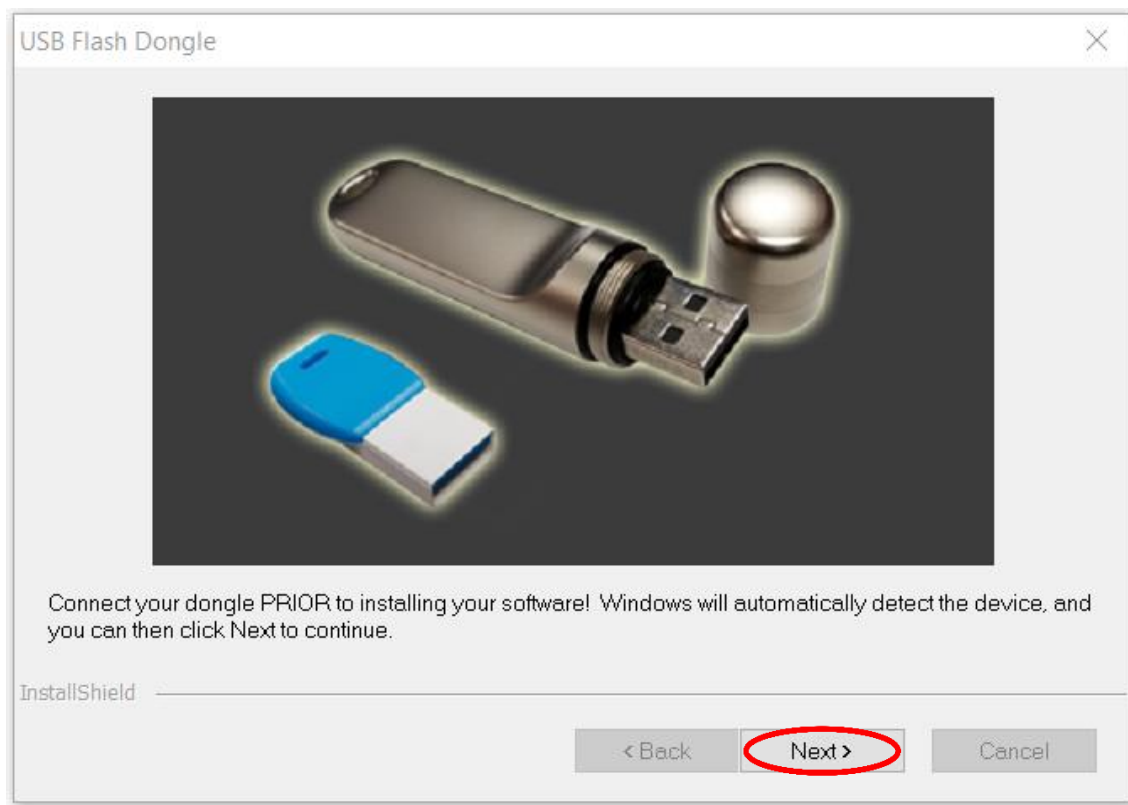
Software Installation

- Make sure all other programs are closed and virus software is disabled.
- Plug in the included dongle into a free USB port on your PC. This dongle contains all of the software, manuals and documents for your printer and software and also serves as your license key.
- Navigate to the RIP setup folder on the dongle and right click the setup file and select 'Run as Administrator'.
- Run the Installation and follow the steps pictured below.
- NOTE: It is suggested to copy all of the installation files located on the USB drive to a folder on your computer for safe keeping and ease of installation.
- The iColor® ProRIP dongle must be inserted at all times when installing or running the program.

- 1) Navigate to the RIP setup folder on the ProRIP dongle or on your PC if you've copied these files. Right click on the setup application file and 'Run as administrator'.
- 2) Select the language for installation and click 'OK'.

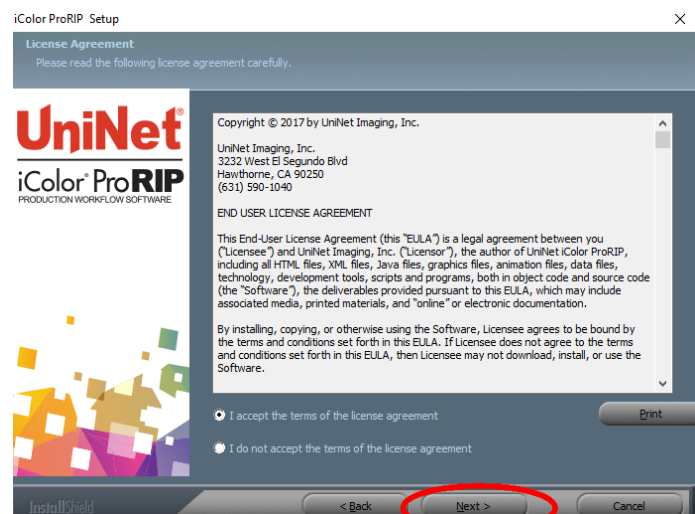


- 3) You will be prompted to insert the USB dongle before proceeding with the installation. If already inserted, click 'Next'. (There is only one dongle shipped with your system, and can look like either of the types represented below).

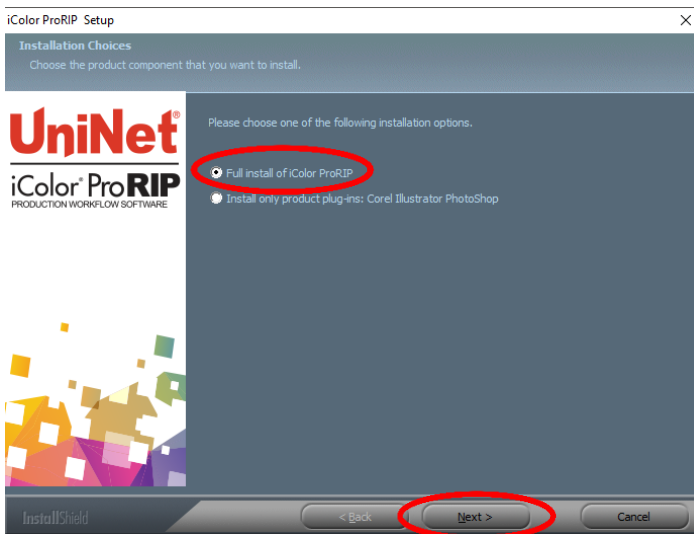


IMPORTANT: This USB dongle is your license key. Ensure that it is not lost or broken, as UniNet cannot replace it without a charge. You cannot use the software without it installed in your PC.

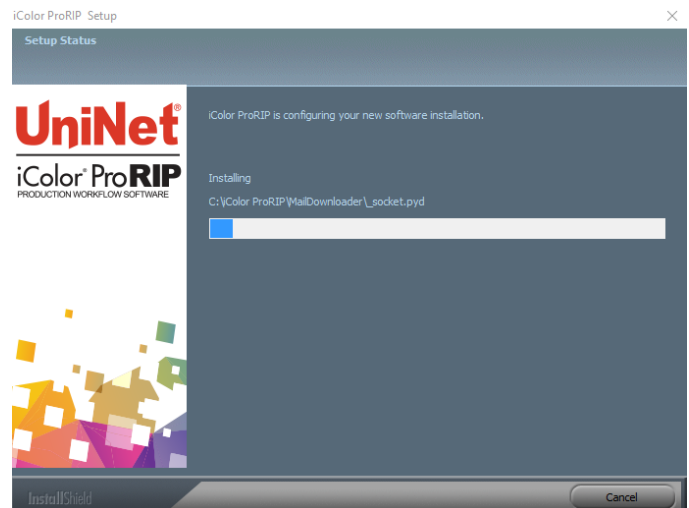
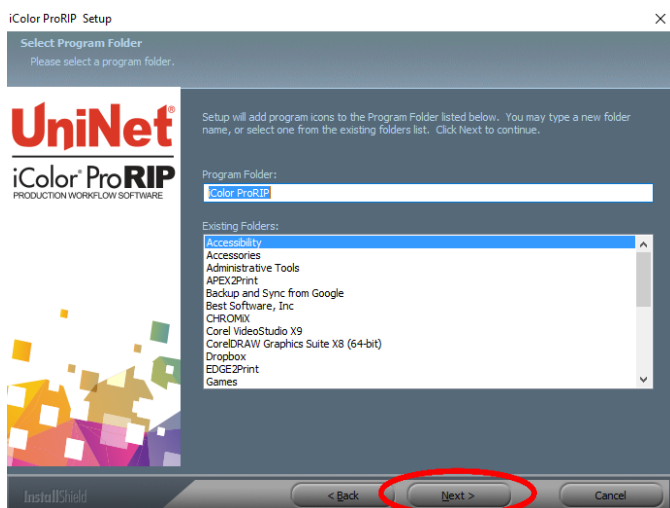
- 4) Select either the 32 or 64 bit application (dependent upon your version of windows). Accept the terms of the license agreement and click 'Next'.



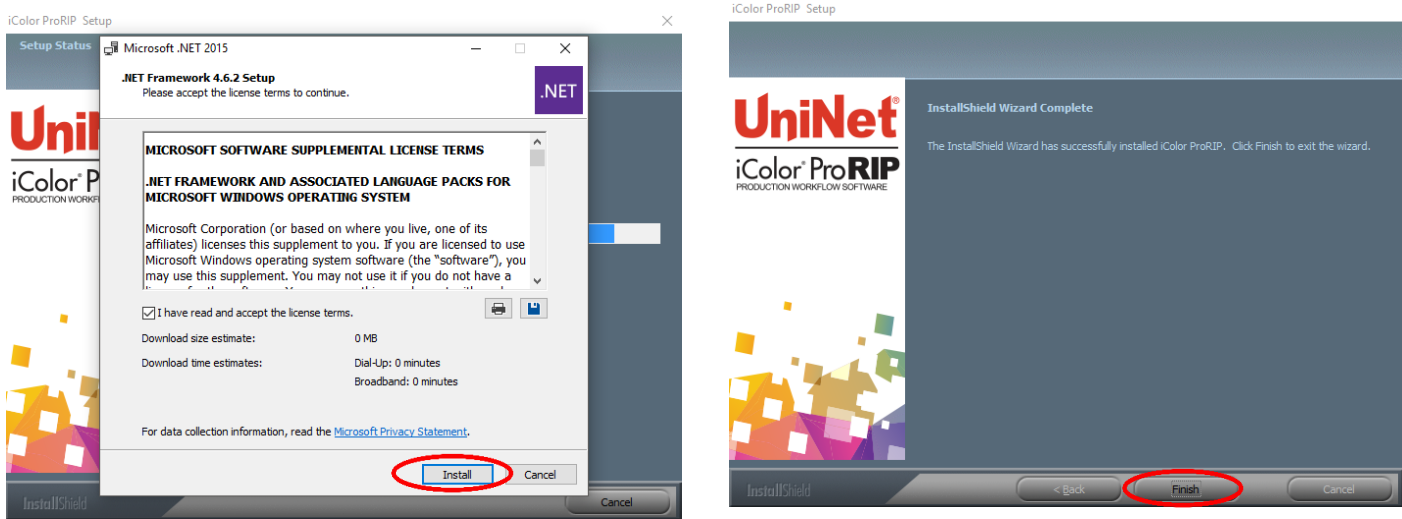
5) Choose 'Full install of iColor® ProRIP' and click 'Next'. Click 'Next' again to accept the installation folder.



6) Click 'Next' to allow the creating of the iColor® ProRIP Program Folder and the installation will begin.

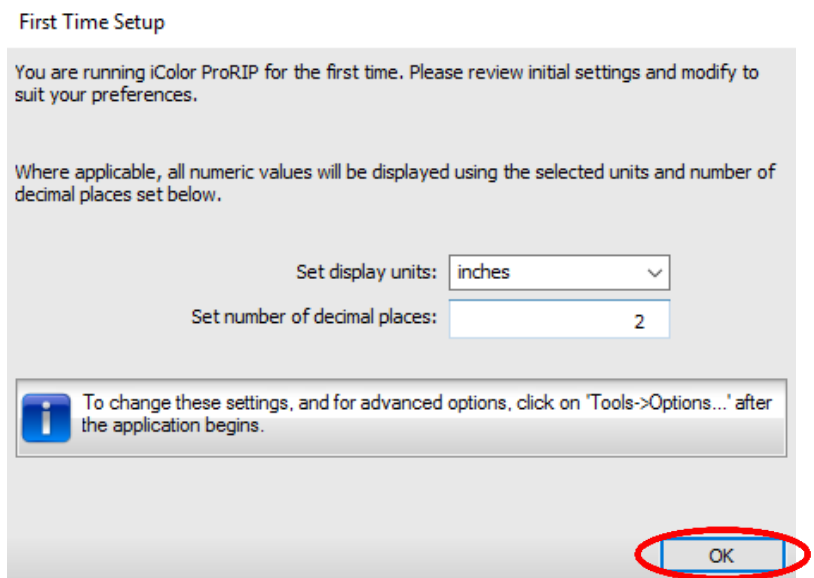
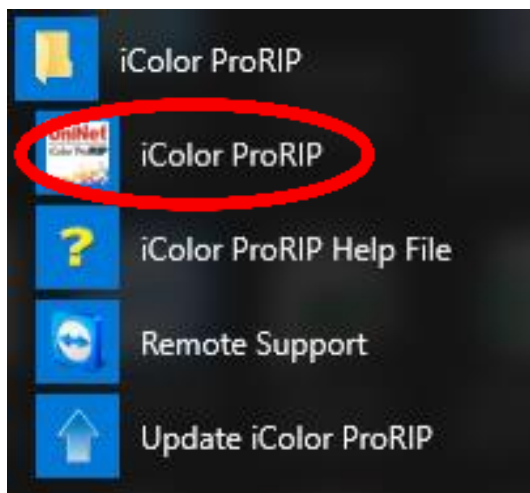


- 7) If not already installed, you will be prompted to install .NET Framework, which is a necessary component to the ProRIP software. Accept the license terms and click 'Install'. Once the InstallShield Wizard is complete, click 'Finish'. This installation normally takes several minutes to complete.

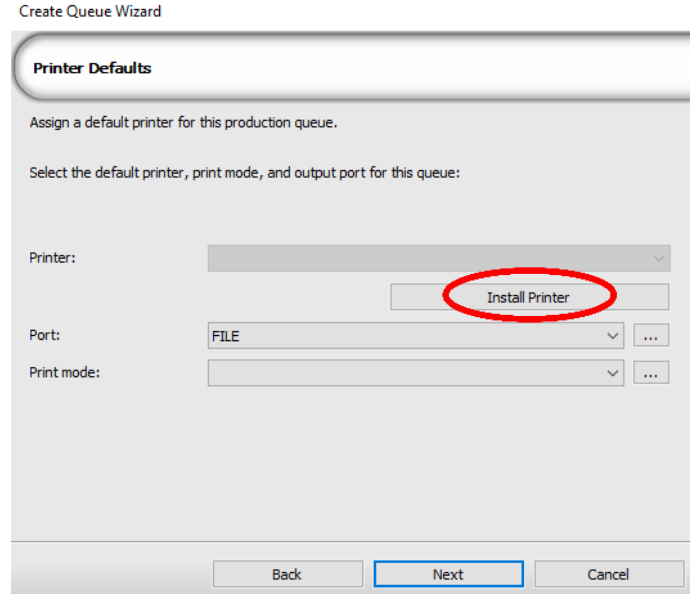
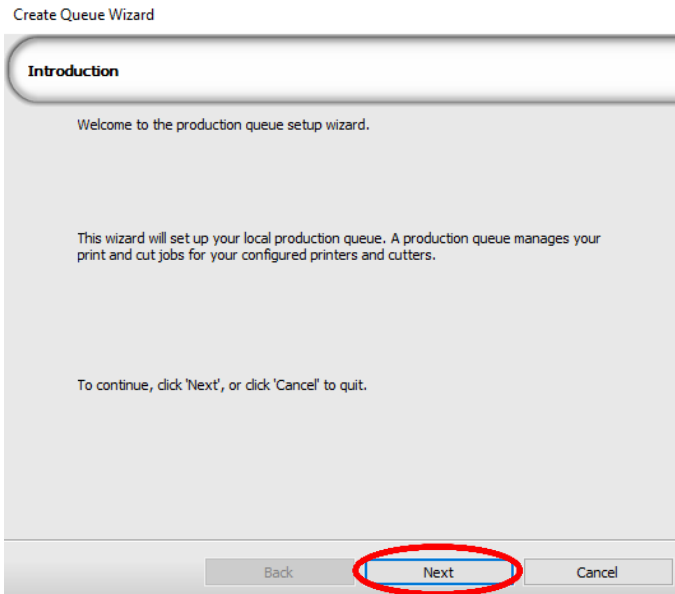


ProRIP First Time Setup

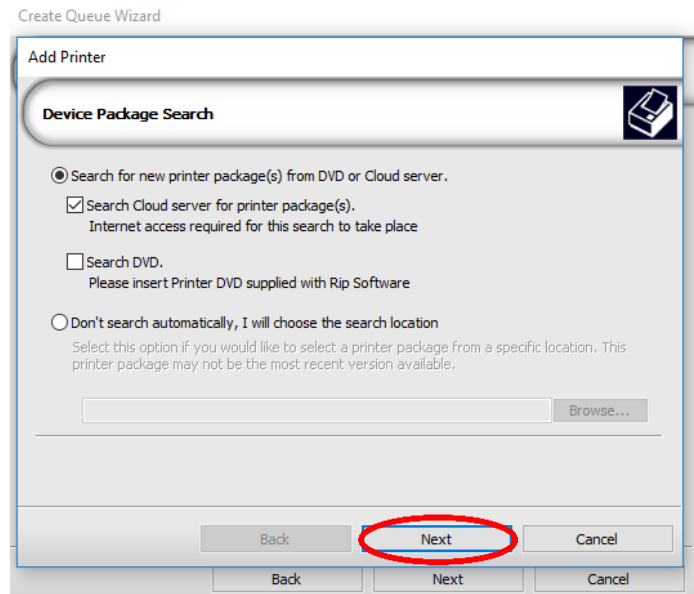
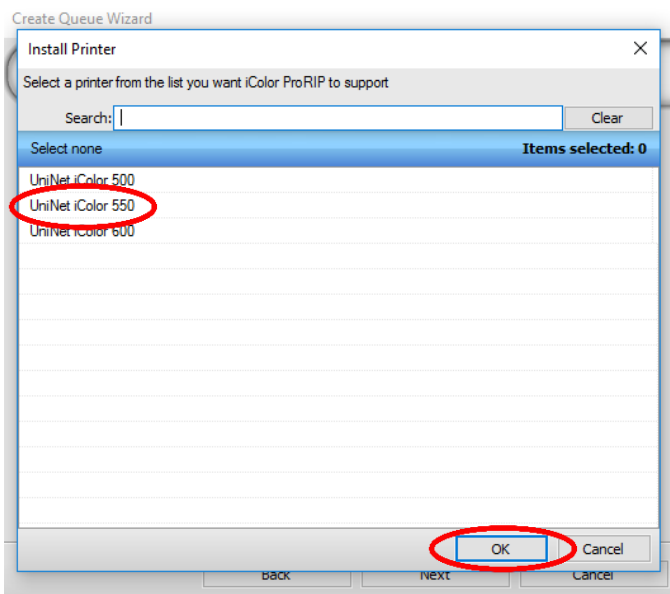
- 1) Be sure the iColor® ProRIP dongle is installed and you are connected to the internet. From the Windows Start menu, choose **All Programs >> iColor® ProRIP** or double click on the desktop icon that was created upon installation. Launch the program. Create a shortcut if desired for quicker access later. Confirm first time setup by setting your preferred unit of measure and decimal places. This can be changed later under **Tools >> Options**.



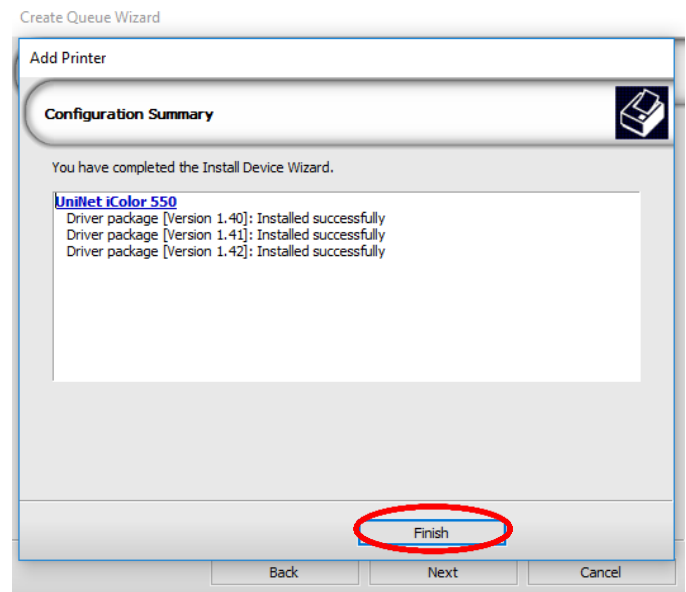
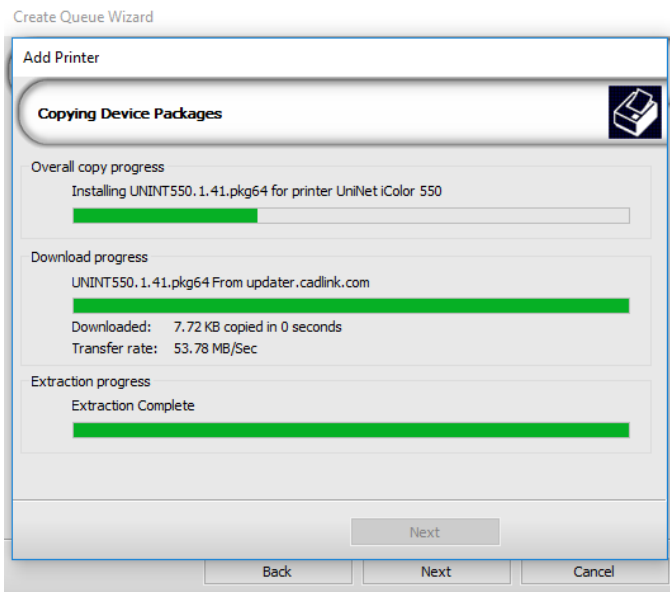
- 2) Once the ProRIP opens, the Queue Wizard will begin the installation of the support files for your iColor® printer. Click 'Next' and then 'Install Printer'.



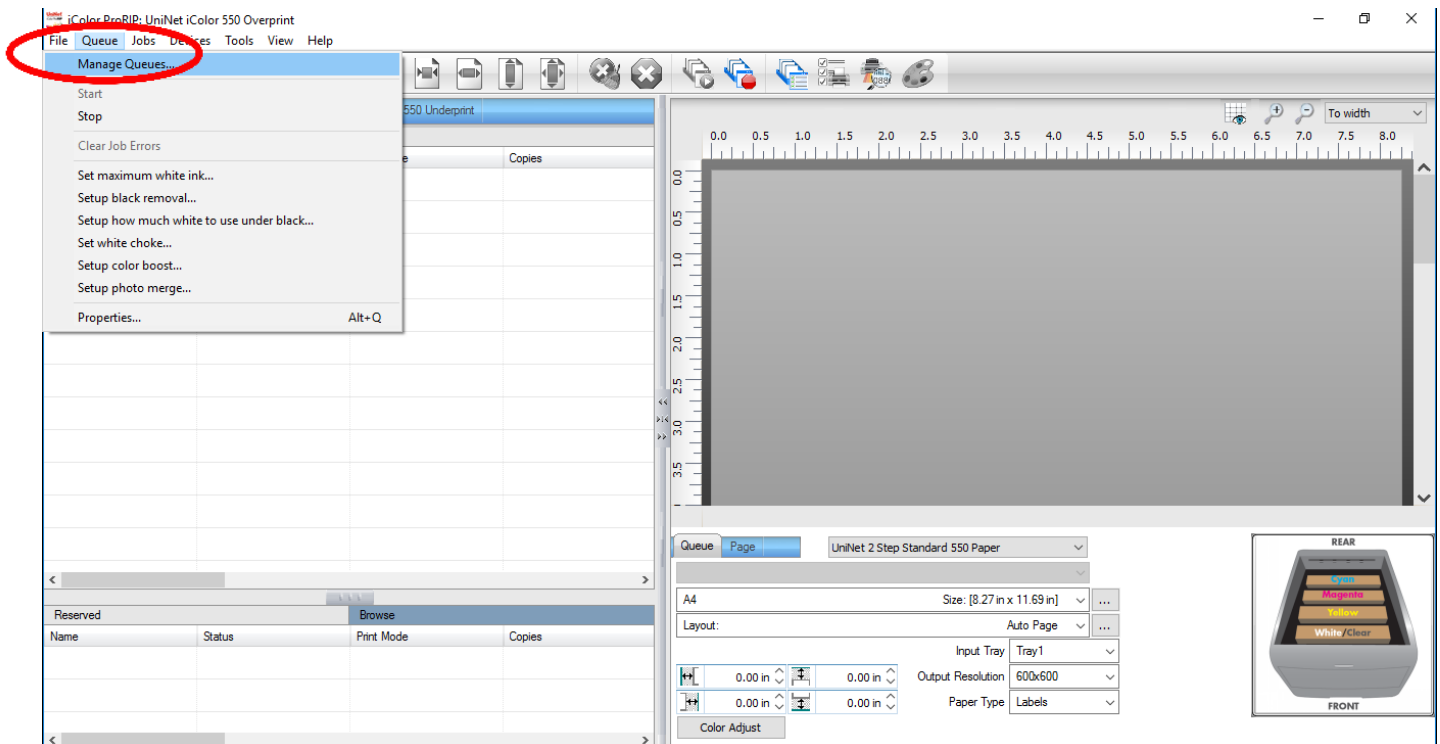
- 3) Select the appropriate printer from the support menu (in this case, we will choose the iColor® 550). Click 'OK'. Then click 'Next' to continue the installation. Note that you may have already installed the printer driver in windows. This installation is for RIP functionality only.



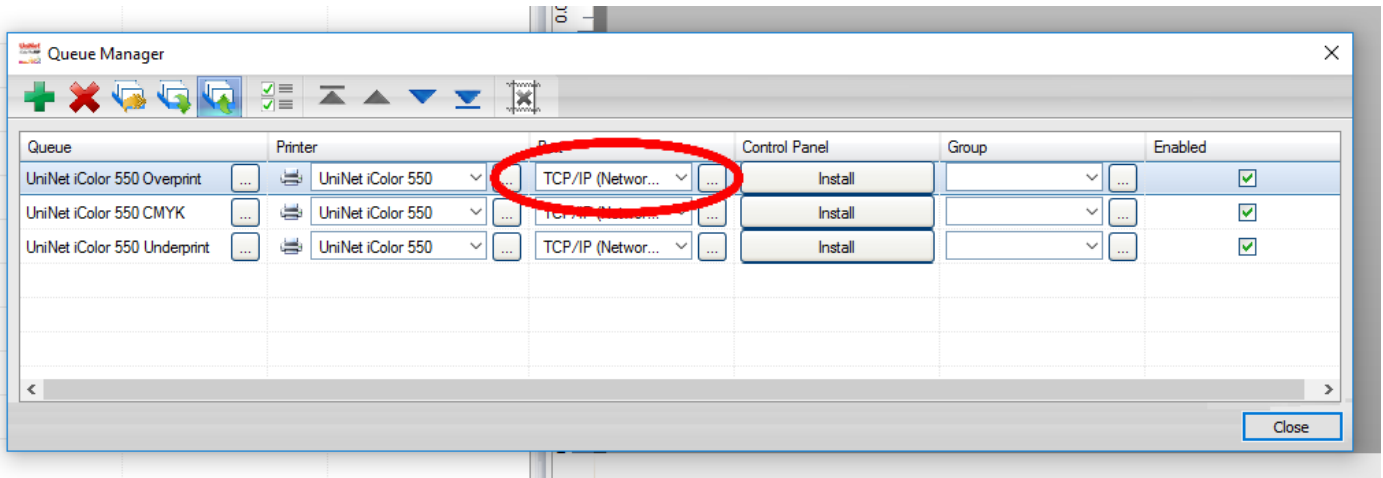
- 4) Click 'Finish' to complete the installation and continue to step 5 or you will not be able to print.



- 5) Click **Queue >> Manage Queues** to set up your printer for each of the preset queues.



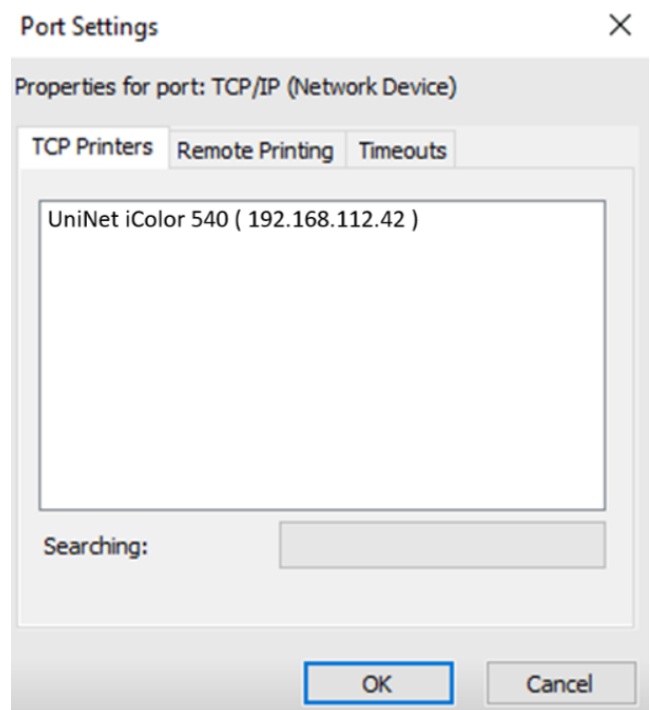
- 6) In the 'Port' drop down menu, chose the proper port. If connected via network (recommended), choose TCP/IP. If connected by USB, choose the printer as identified in the drop down. All other ports will update automatically, it is only necessary to do this for one queue.



- 7) If connected via network, once TCP/IP is selected, the software will poll your network for available printers. Select the proper iColor® printer. Note that the IP address of the printer is displayed. Be sure to set a static IP address for your printer so that the IP address does not change later. If this happens, you will have to repeat this step.

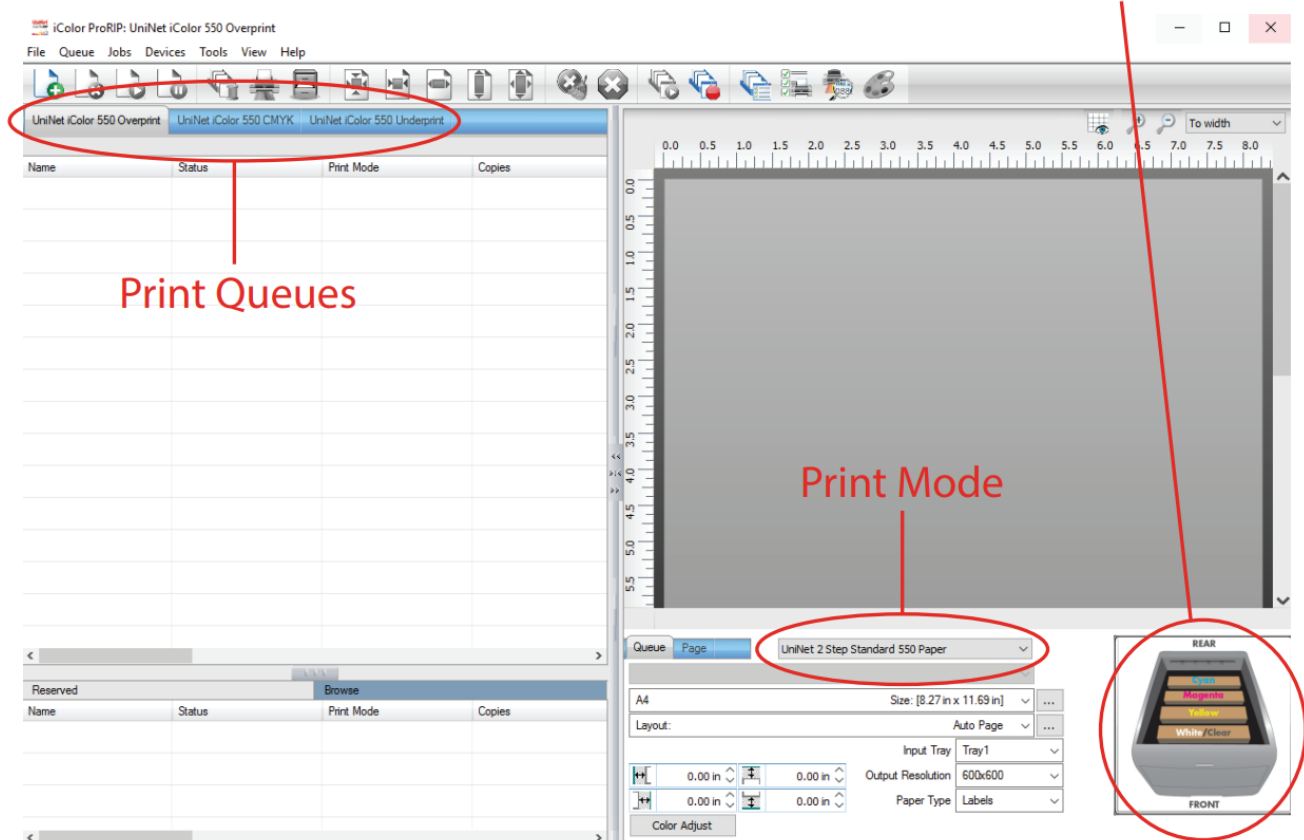
Setting a static IP on the iColor 540:

Press the **Menu** button to the left of the LED screen. Using the 4 arrow keys to the right of the LED screen, select **Network>>Host Interface>>IPv4 Address>>Specify**. Use the left button beneath the LED labeled **IP add** to set the IP address. Use the middle button **Subnet M** to set the subnet mask and the right button labeled **Gateway** to set the default gateway.

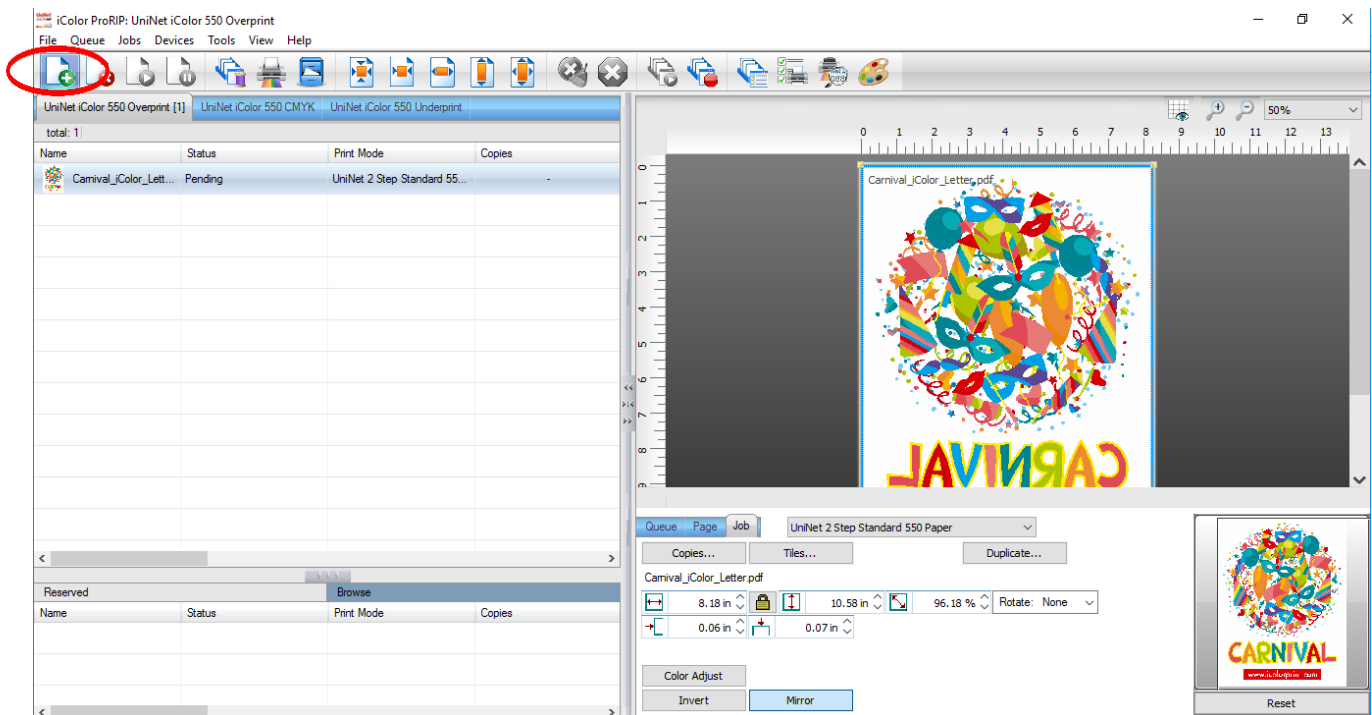


- 8) Select the proper Print Queue for your project. Then, select the Print Mode (otherwise known as media type) and verify the size of that media before importing your graphic.

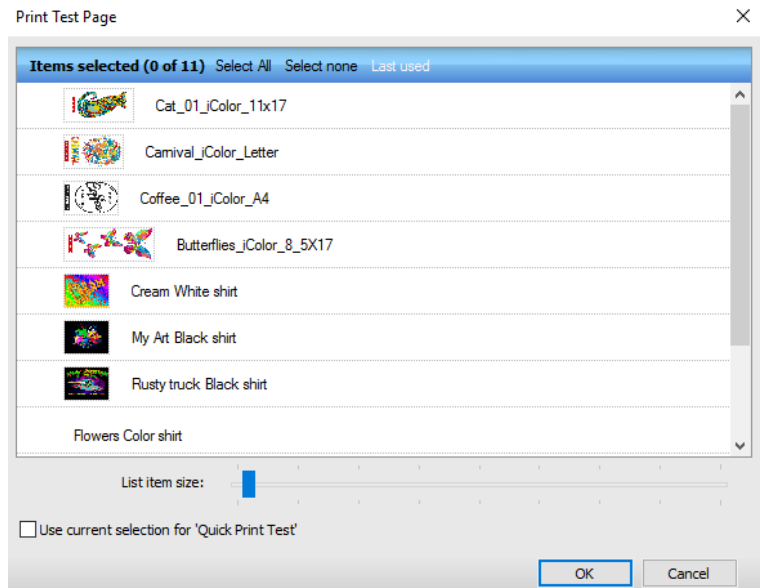
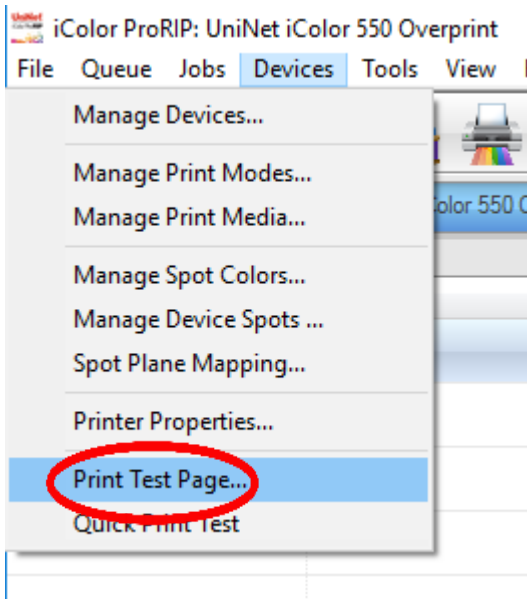
Please note, the preview icon of the printer should match the physical configuration of the printer.



- 9) Import the desired graphic by clicking the 'green plus' icon and navigating to the proper folder. You can also import by clicking **File > Import File**, or simply dragging and dropping your file into the queue.

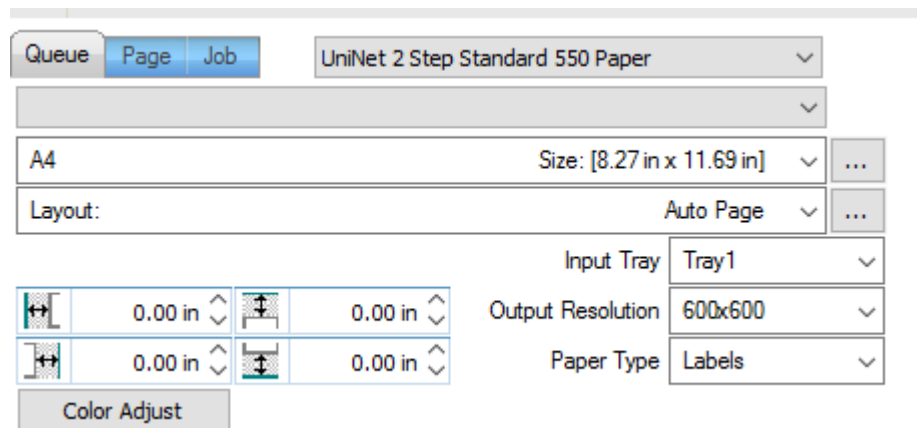


- 10) There are preloaded images that can be used to print a test page. Click **Devices >> Print Test Page** to see the choices. It is suggested that you print a test page upon completion of the setup to confirm the printer has been properly installed. Use [Shift] and [Ctrl] to click multiple pages, and then click OK. More about the uses of each page can be found in the Help Topics file within the ProRIP program.

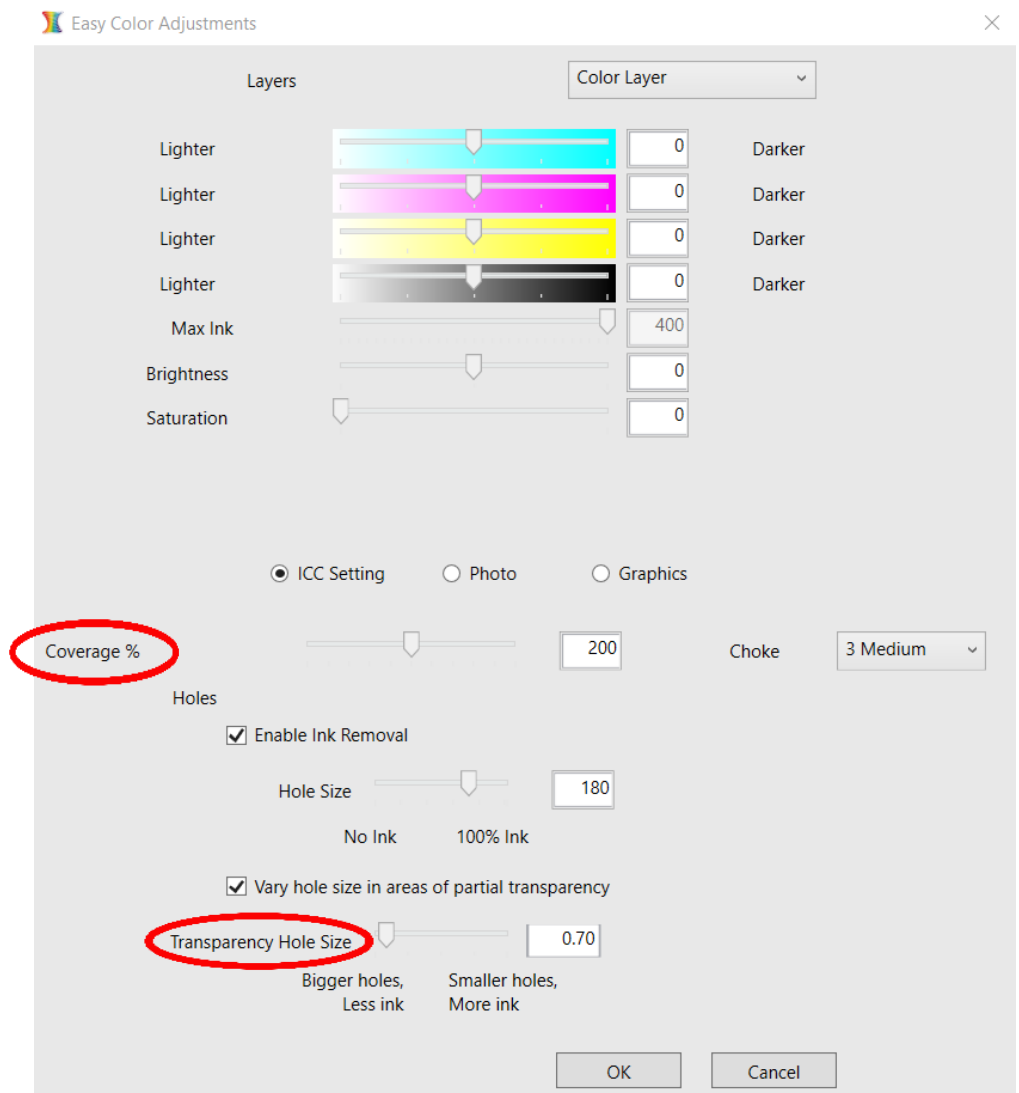


Using the ProRIP Software (Summary)

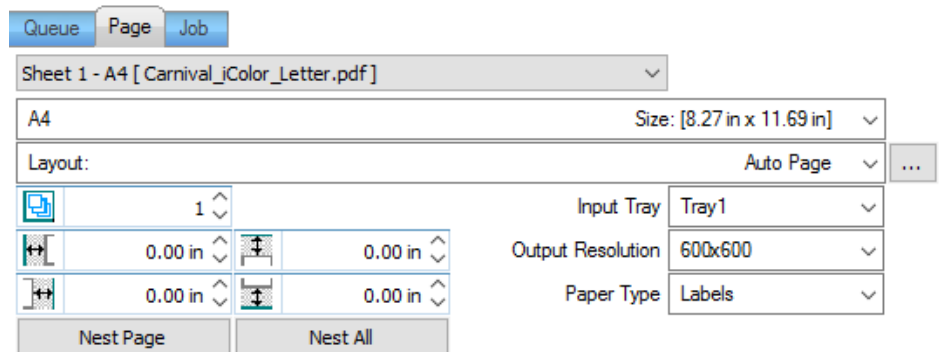
Once your image is loaded, take note of the preconfigured settings based relating to the media being used in the printer. The 'Queue' tab shows the size of the media that will be used, where to load the media into the printer and the paper type setting recommended. Each media type will contain this preconfigured data to make your printing experience as easy as possible. Overriding these settings could result in undesirable results.



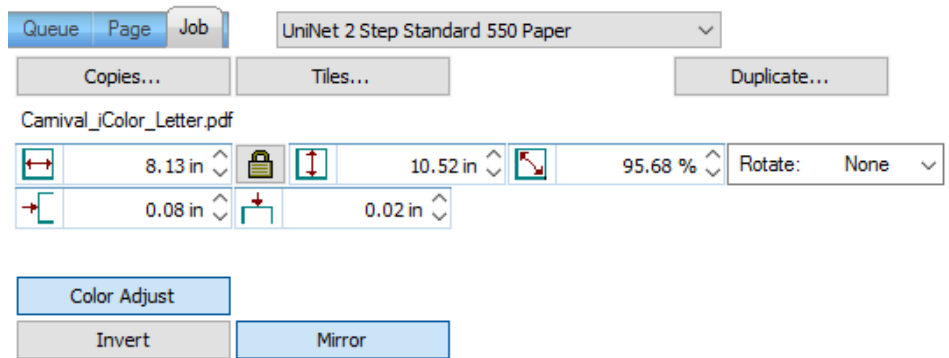
To alter the color settings, click on 'Color Adjust' and adjust as needed. 'Coverage %' represents the amount of white/clear toner overprint or underprint (depending on which queue is being used). The 'Use graphics transparency for dot size' option allows for rasterization of colors that fade into nothing and to retain partial transparency. It is suggested that this option is left on, as it will only apply itself where it's



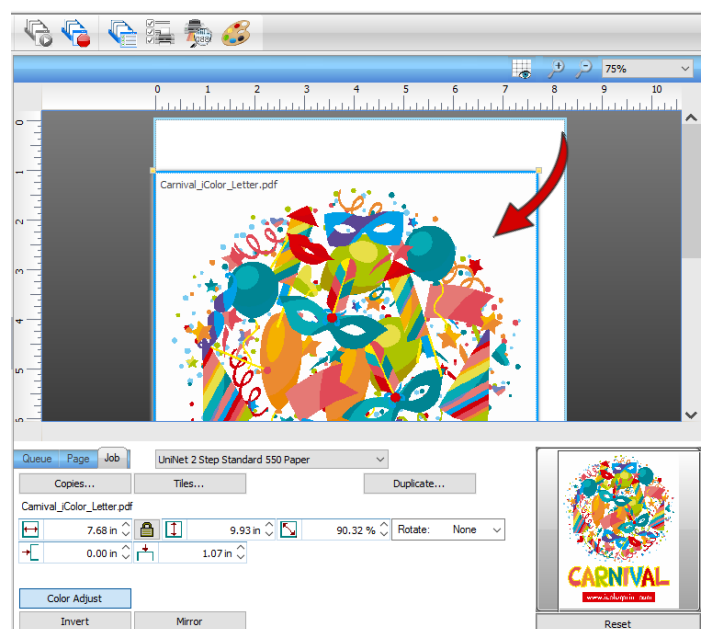
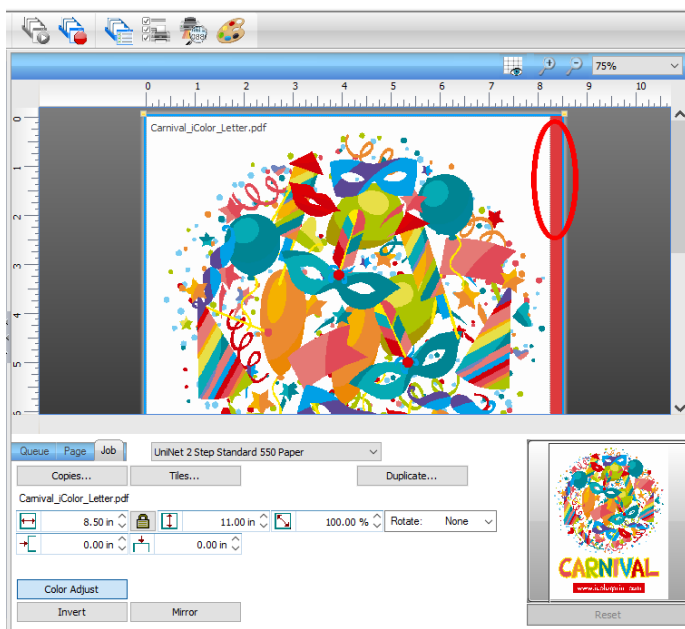
The 'Page' tab offers the ability to print multiple copies and nest images. You can also adjust the size of the image to fit your media here (and in the Queue tab).



The 'Job' tab allows you to lock the proportions of your image to maintain the aspect ratio. Here you can also mirror, rotate and invert the image. You can also adjust the margins of the print if necessary. Note that the mirror function is automatically on for any image loaded into the overprint queue.



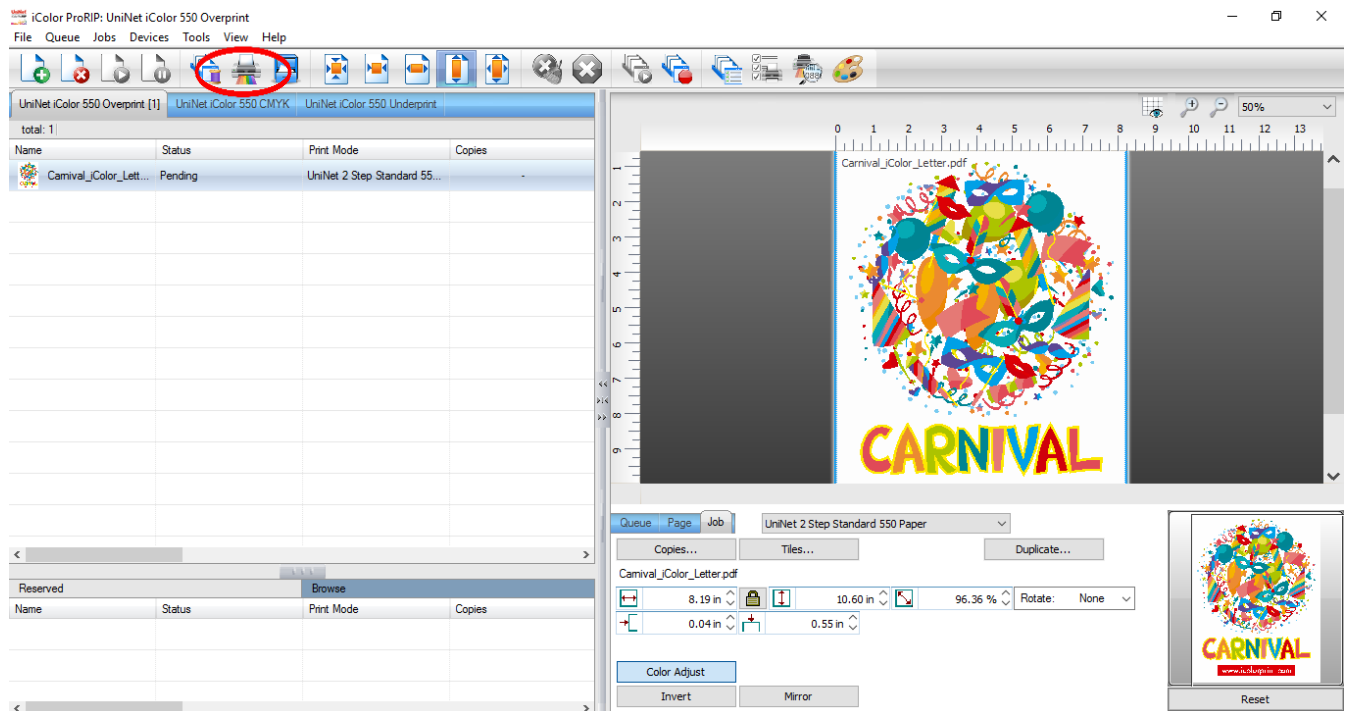
You can also adjust the size of any image by dragging and dropping the corner of the image in the preview pane. In this example, where we have a letter sized image placed on an A4 artboard, the red bar to the right of the image represents the portion of image that is outside the print margins. Be sure to resize to eliminate this bar before printing.



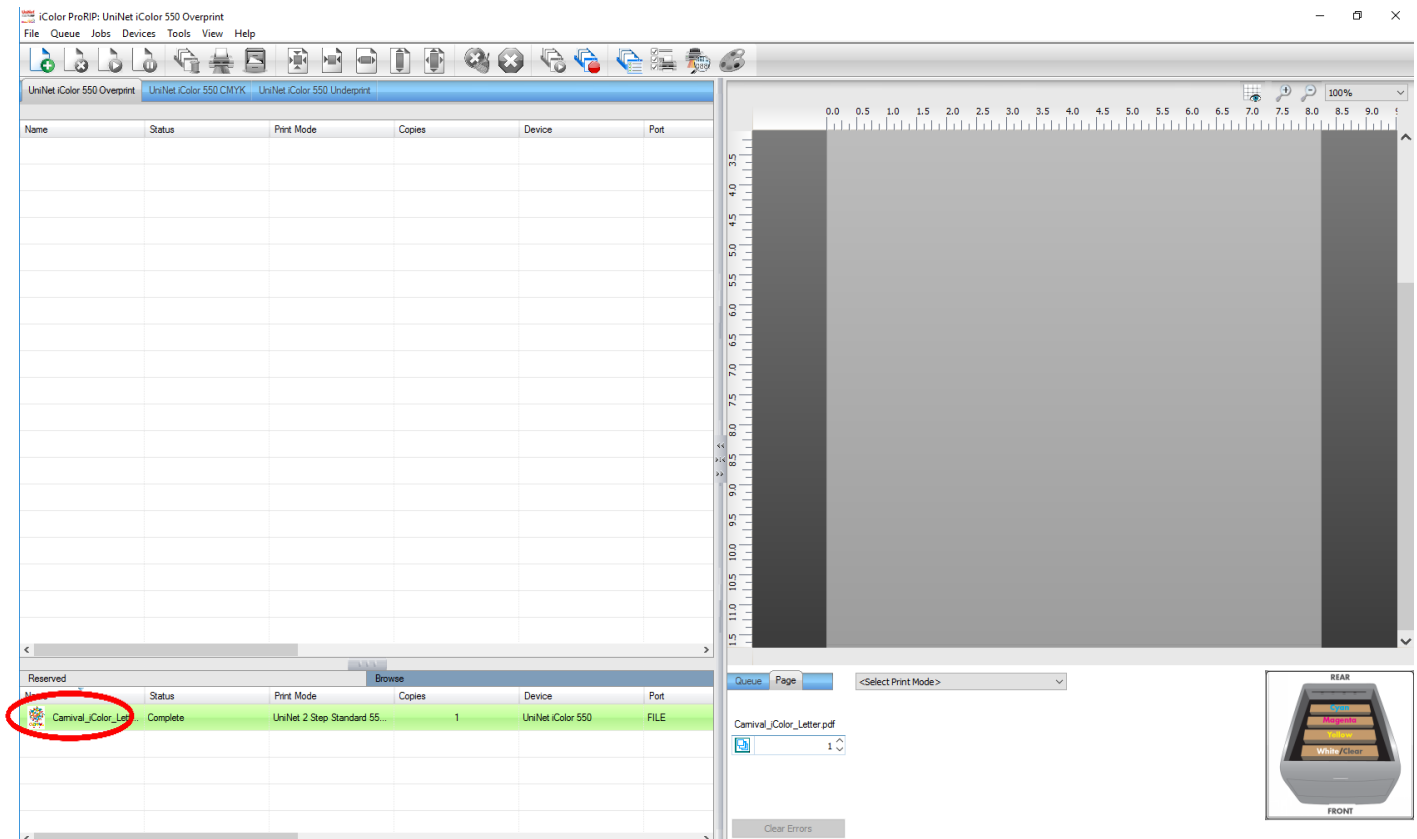
Adjustments can also be made by using these icons at the top of the screen.



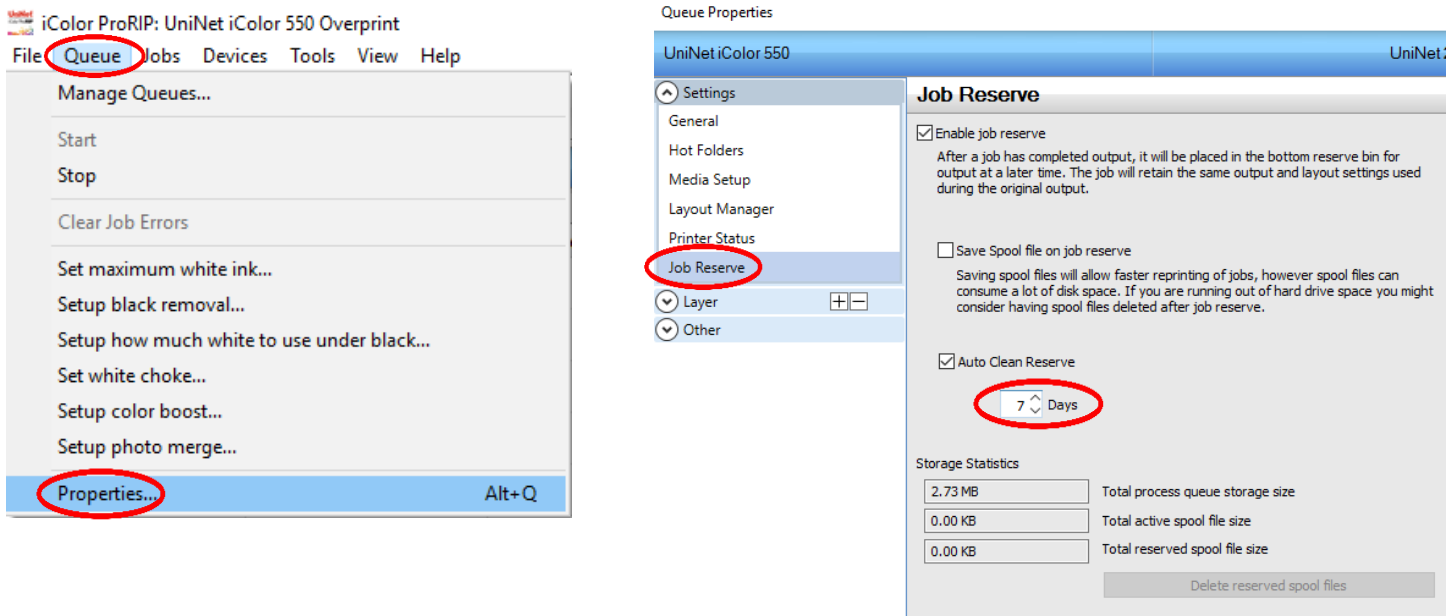
When ready, click the 'Print' icon to print your graphic.



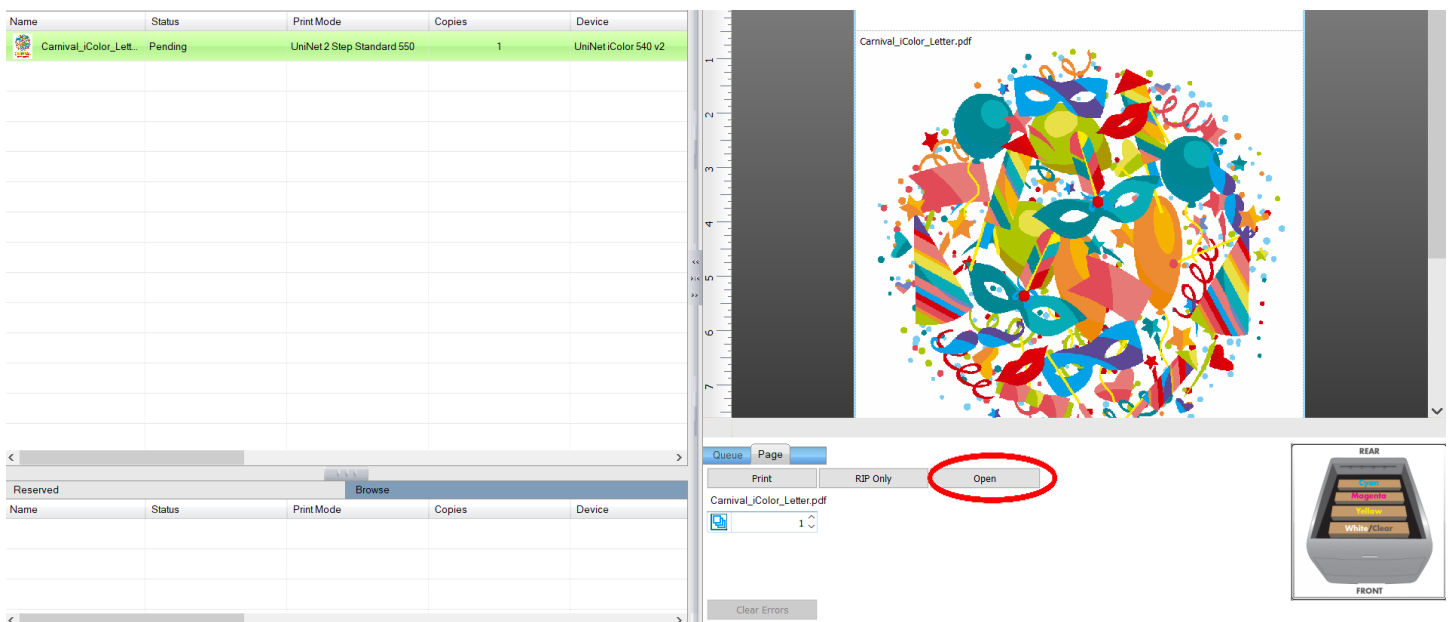
Once the print has completed, the job will be archived in the reserved area for 7 days. If you wish to reprint that job, drag and drop the job from the reserved section into the proper queue.



To lengthen the amount of time a job stays in reserve, click **Queue>>Properties**. Then click 'Job Reserve' and set the 'Auto Clean Reserve' time frame. Unclick to keep jobs in reserve forever.



After a particular job has printed, it will be 'closed'. This means that it was rendered by the software so that the next time you print, the processing time will be minimal. If you need to make any changes to the print job before printing, you must 'open' the job. Otherwise, just reprint as needed (processing time is faster when already rendered).



For more detailed instructions for the iColor® ProRIP software, please consult the iColor® ProRIP User Manual.

Visit www.icolorprint.com/support for the most updated written and video instructions on the iColor® ProRIP software.

Replacing toner cartridges

Because the iColor® 540 features cartridge remapping to achieve a white underprint or overprint, it is important that you follow these rules when determining the cartridge order inside the machine:

OVERPRINTING Supplies Replacement Guide

This is for white/clear overprinting when the proper cartridge is installed

Typically used for reverse print applications such as garment decoration

| Printer Display Reads: | Replace with: |
|-------------------------------|---|
| Cyan low/out/empty | Cyan (Back of Printer) |
| Magenta low/out/empty | Magenta |
| Yellow low/out/empty | Yellow |
| Black low/out/empty | White/Clear (check which cartridge is installed) (Front of Printer) |

UNDERPRINTING Supplies Replacement Guide

This is for white/clear underprint when the proper cartridge is installed

Typically used for right side reading application such as printing on dark or clear media

| Printer Display Reads: | Replace with: |
|-------------------------------|--|
| Cyan low/out/empty | White/Clear (check which cartridge is installed) (Back of Printer) |
| Magenta low/out/empty | Magenta |
| Yellow low/out/empty | Yellow |
| Black low/out/empty | Cyan (Front of Printer) |

It is recommended that you power down your printer before moving cartridges to prevent electrostatic damage.

The black, white or clear cartridges can never be installed at the same time. Only one of these 3 cartridges can be installed at any one time.

Printing with Fluorescent Colors

Instantly transform your iColor® printer into a fluorescent printer where the printed images produced will glow brightly under UV light. The upgrade kit consists of 3 toner cartridges (CMY) and are shipped in 3 separate boxes. Simply remove and store the standard CMY toner cartridges and swap with the fluorescent kit to instantly print with UV sensitive toner while using the standard black cartridge in place. The white cartridge that shipped with your iColor® 540 printer can also be used if a white overprint is required.

Operating on the same application principles as standard toner that ships with your machine, you can print and/or press onto virtually any surface using the appropriate transfer media – or print directly onto paper, transparencies and label stock. Be sure to design your graphics with bright colors – avoid dark or black colors (unless specifically wanted), as those will not fluoresce well and may not look desirable as a final product. Most fluorescent images will be placed on a black or dark colored garment, so black would not be suggested in these cases anyway.

Specific installation instructions can be found at www.icolorprint.com/support

Printing with Dye Sublimation Toner

Instantly transform your iColor® printer into a dye sublimation printer. The upgrade kit consists of 4 toner cartridges (CMYK) and are shipped in 4 separate boxes. Simply remove and store the standard cartridges and swap with the dye sublimation kit to instantly print and sublimate on coated materials.

Operating on the same application principles as standard ink sublimation systems, you must press onto white 100% polyester or sublimation coated materials for best results. 50/50 cotton poly blends may also be used for a lighter, vintage look. There is no white overprint option with dye sublimation, only CMYK prints are possible.

The iColor® Dye Sublimation Upgrade Kit has several unique advantages suited for a production environment:

- 1) Vastly faster print speeds: 26 pages per **minute** vs 34 pages per **hour** for ink (photo mode)
- 2) No clogged heads resulting from non-use. Toner based systems do not have this maintenance issue.
- 3) Longer expiration period
- 4) Much higher page yield: 3,000 pages standard toner vs 350 pages for starter ink

Specific installation instructions can be found at www.icolorprint.com/support

Ask your dealer about upgrading to security and clear toner options as well!



Why use iColor® SmartCUT?

Easily print oversized images with UniNet's optional iColor® SmartCut software. This ground breaking application turns your letter sized printer into a tabloid 'plus' capable machine, allowing for the splitting and splicing of one graphic across two or more printed transfer sheets.

Pick virtually any oversized graphic, and the software will split it in half along the most logical path. You can choose to have it split along dark or light areas, depending on the color garment you will be pressing onto. With this software, you can make 3XL shirts that are not possible with even the most expensive of printing systems because you can gang up as many transfer sheets as you want.

SmartCUT was designed from the ground up with ease of use as a paramount consideration. Most functions are automated to allow you to focus on finding the best starting point to split each job. SmartCUT supports most common image formats, with a preference for PNG files with transparent backgrounds.

The program works as an integral part of a decorating system where the split pages are printed onto iColor® Standard transparent transfer media. The sheets are then lined up visually on the substrate through the transparent sheet.

SmartCUT opens the door for the iColor® 540 to print these common design sizes such as 15" square, as well as plus size garments such as 2X, 3X, 4X. The ability to print designs that properly fill out these large sizes create the opportunity for high value garments that can fetch a premium price.

SmartCUT enables users who cannot make the jump to tabloid sized printers to effectively print larger images than user with the larger printers.

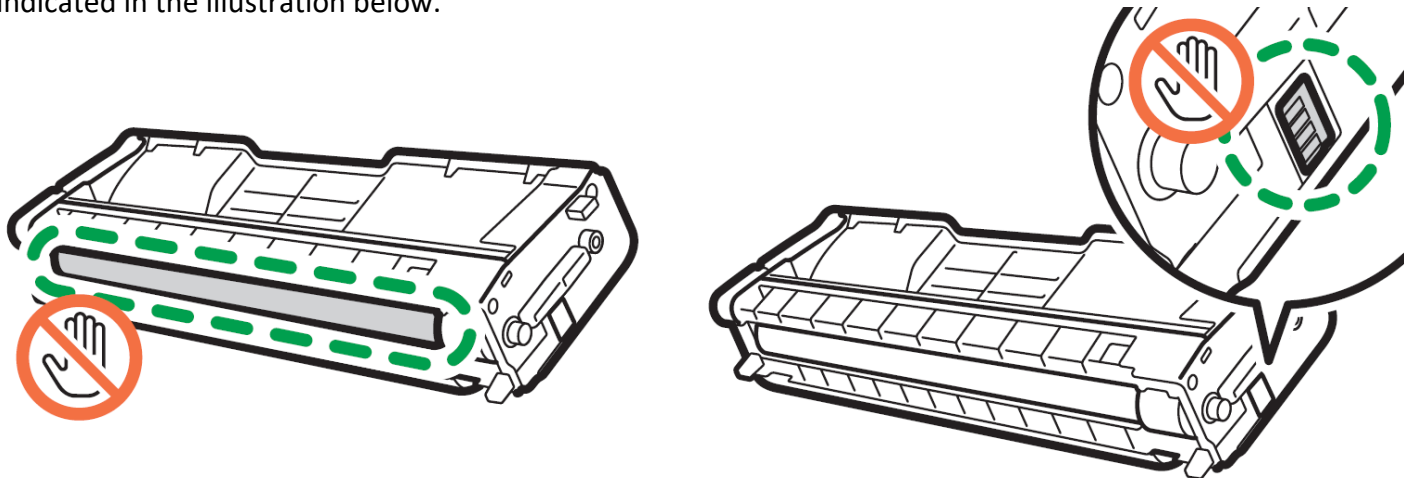
SmartCUT WORKS!!! A tremendous amount of research and testing has proven the concept that using the method implemented in this application will produce results for a very high percentage of designs that are virtually imperceptible by even those who know that a seam exists.

If not purchased, your iColor® printer shipped with a demo version of the software, to purchase the full version, contact your representative.

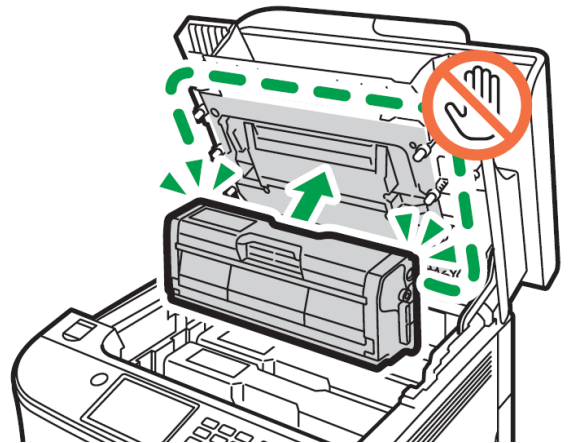
Maintaining your Printer

Replacing the Print Cartridges:

- Store print cartridge in a cool dark place.
- Actual yield varies depending on image volume and density, number of pages printed, paper type and size, and environmental conditions such as temperature and humidity.
- The manufacturer shall not be responsible for any damage or expense that might result from the use of parts other than genuine parts from the manufacturer with your office products.
- When the toner runs out, pressing the [Stop/Start] key allows you to print a few more pages, but the print quality of those pages may be lower.
- Do not allow paper clips, staples, or other small objects to fall inside the machine.
- Do not expose the print cartridge without its cover to direct sunlight for a long time.
- Do not touch the print cartridge's photo conductor unit or the ID chip on the side of the print cartridge as indicated in the illustration below.



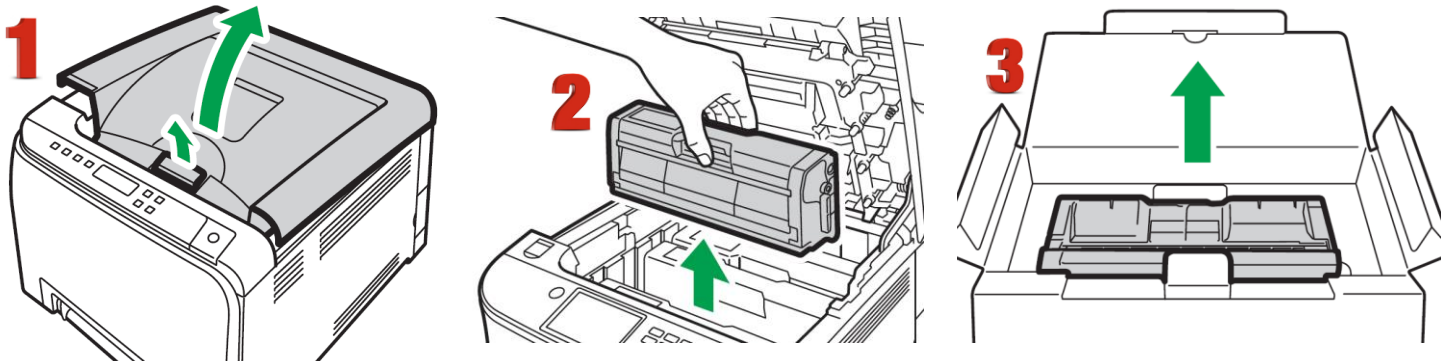
- When removing print cartridges, be careful not to touch the laser scanning unit under the upper cover (the position shown by the arrow in the illustration to the right).
- If cyan, magenta, or yellow toner runs out, you can print in monochrome using just the black toner. Change the color mode setting to Black and White using the machine's driver.
- If black toner runs out, you cannot print at all until the black print cartridge is replaced.



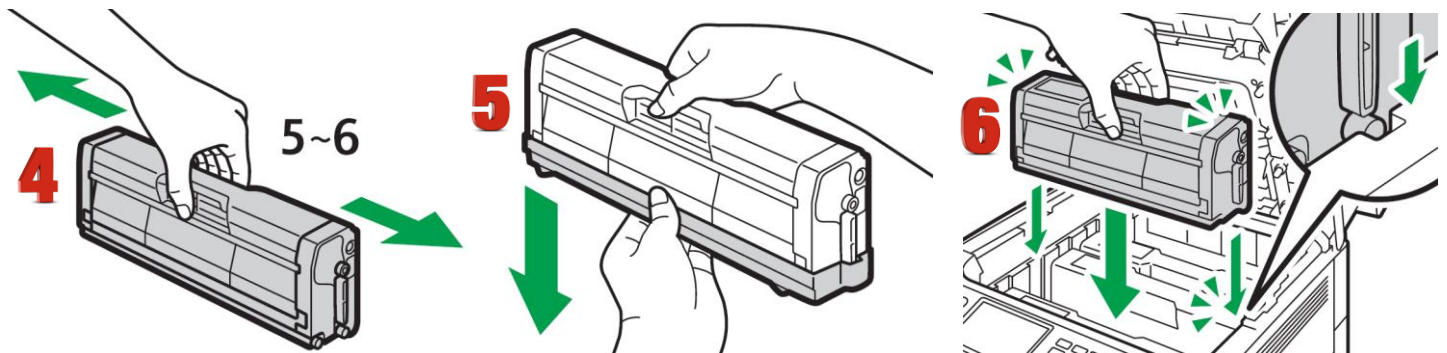
Messages on the screen:

Replace the indicated print cartridge when any of the following messages appear on the screen:
'Replcmnt Requird: Print Cart'

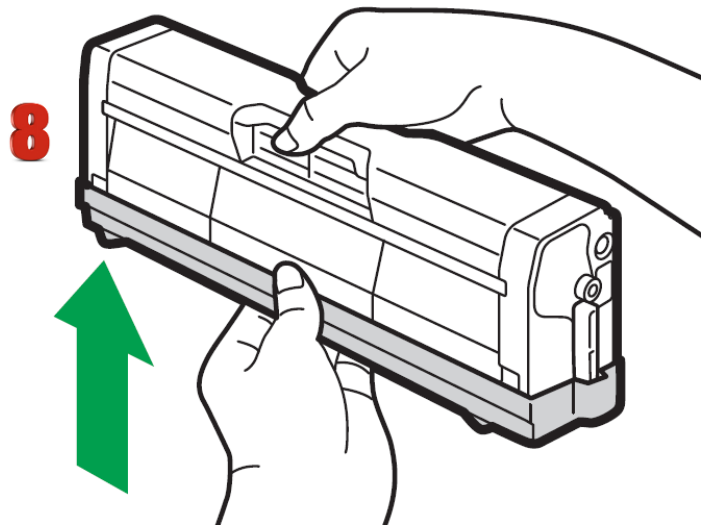
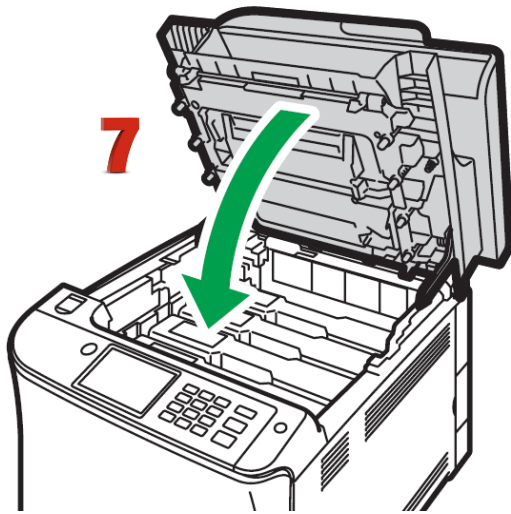
Prepare the indicated print cartridge when any of the following messages appear on the screen:
'Toner is almost empty'



1. Pull up the lever on the top cover, and then carefully raise the top cover.
2. Carefully lift out the print cartridge vertically, holding its center. From the rear, the print cartridges are installed in the order of cyan (C), magenta (M), yellow (Y), and white (w) or black (K).
3. Take the new print cartridge out of the box, and then take it out of the plastic bag.



4. Hold the print cartridge and shake it from side to side five or six times. Even distribution of toner within the bottle improves print quality.
5. Remove the protective cover from the print cartridge.
6. Check the toner color and corresponding location, and then carefully insert the print cartridge vertically.

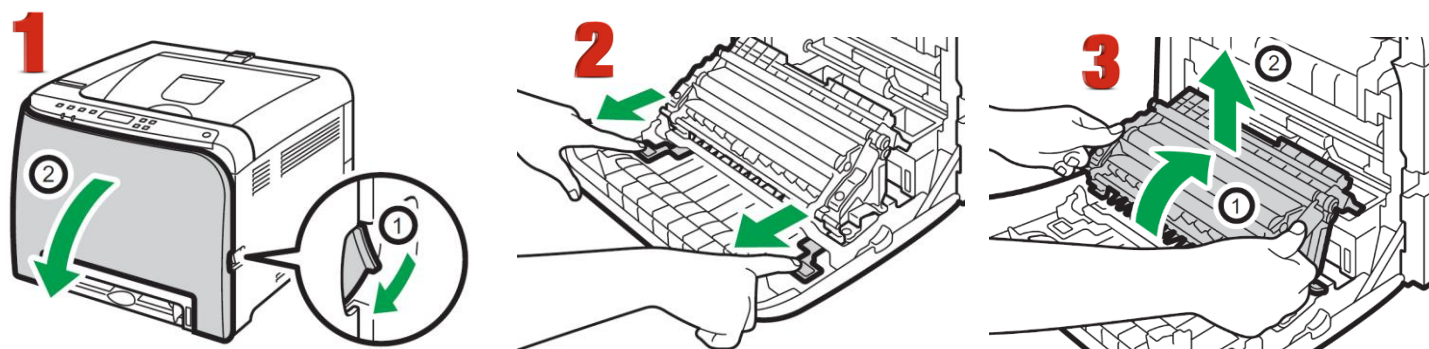


7. Using both hands, hold the center of the top cover and close the cover carefully.
8. Attach the protective cover you removed in Step 5 on the old print cartridge. Then, put the old print cartridge into the bag, and then put it into the box.

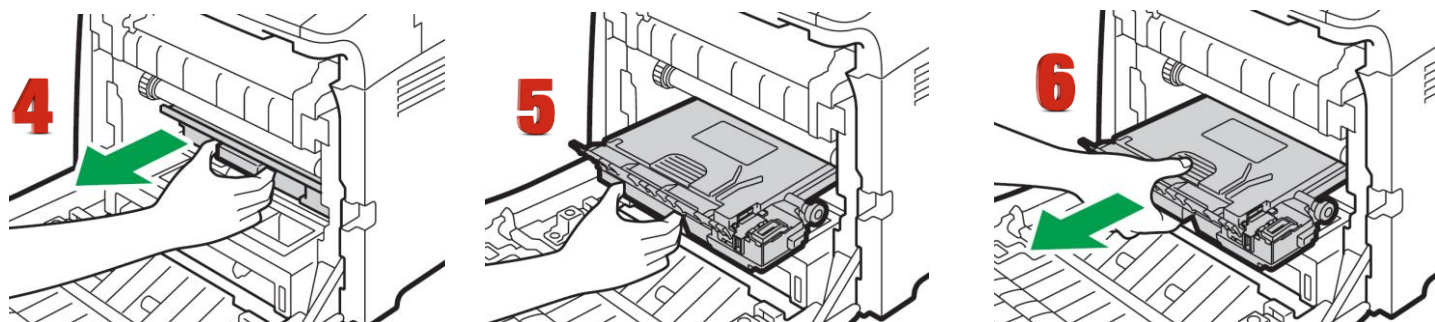
Replacing the Waste Toner Bottle:

Messages on the screen

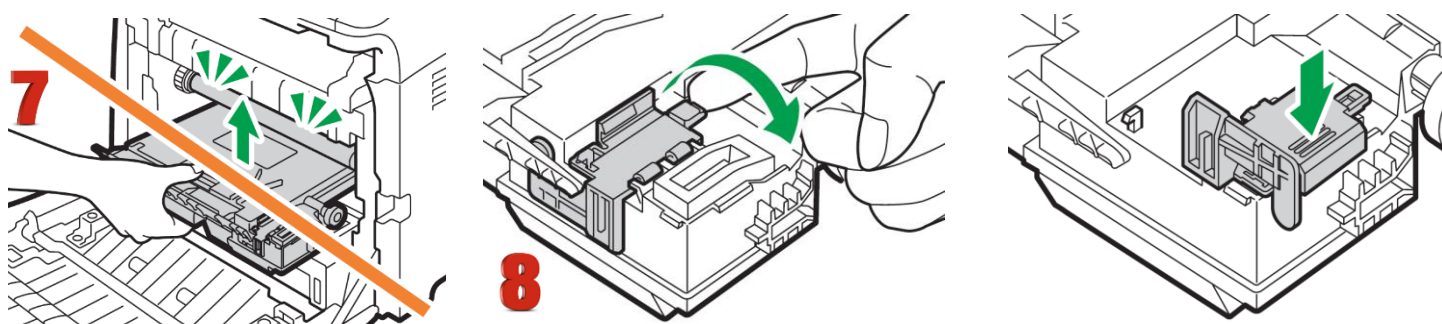
- Replace the waste toner bottle when the following message appears on the screen:
"Waste Toner Bottle full"
- Prepare a waste toner bottle when the following message appears on the screen:
"Waste Toner Bottle almost full"
- Waste toner bottles cannot be reused.
- When removing the waste toner bottle, make sure not to tilt it.
- Make sure the transfer unit is installed. If the transfer unit is not installed, install it before turning on the power.
- Before removing the waste toner bottle from the machine, spread paper or similar material around the area to keep toner from dirtying your workspace.



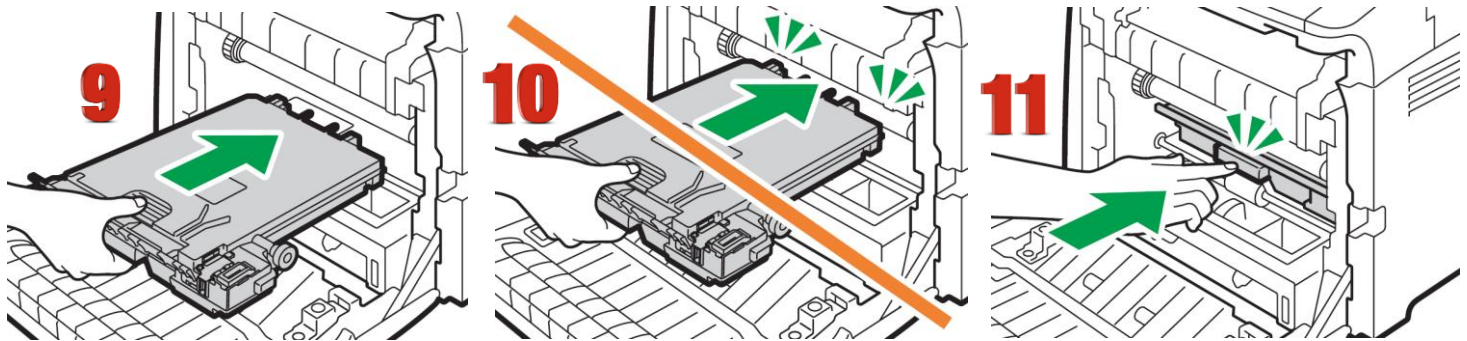
1. Pull the front cover open lever and then carefully lower the front cover.
2. Slide both levers on the front cover forward.
3. Holding the tabs on both ends of the transfer unit, tilt it backwards and lift it up.



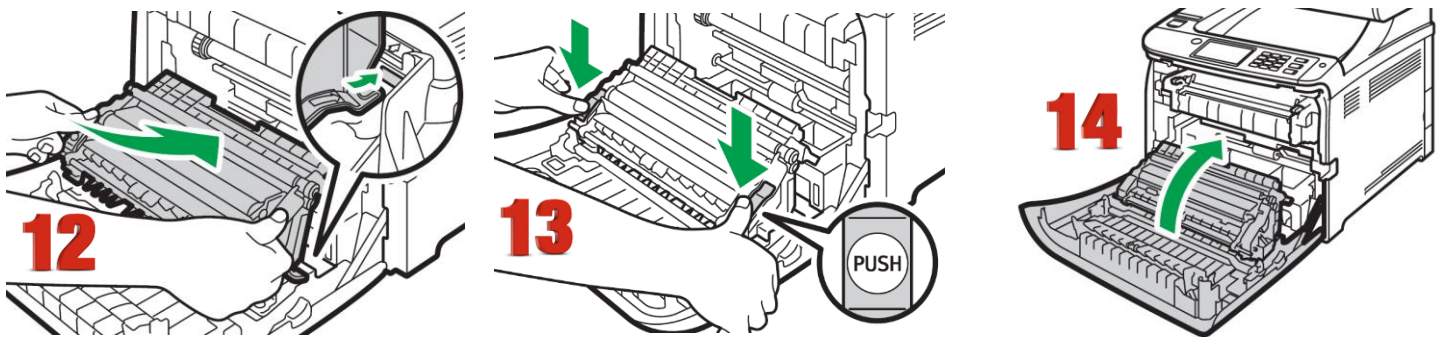
4. Holding the handle at the center of the waste toner bottle, carefully pull it partially out without tilting it.
5. Pull the waste toner bottle halfway out.
6. Holding the bottle firmly, pull it straight out.



7. To prevent the waste toner bottle from coming into contact with the intermediate transfer unit (the position shown by the arrow in the illustration below), do not lift the bottle while pulling it out.
8. Close the bottle cap.



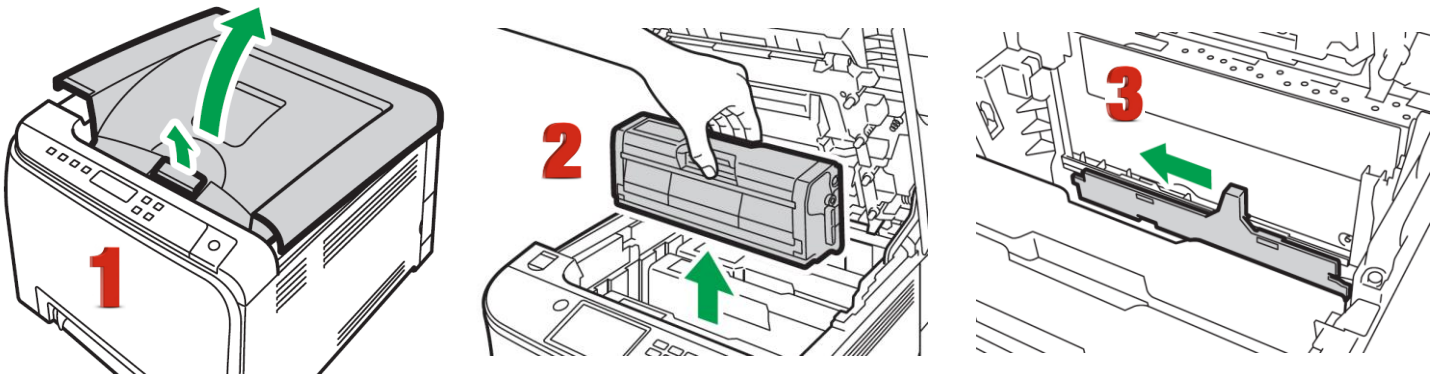
9. Holding the center of the new waste toner bottle, carefully insert it halfway into the machine body. Leave the bottle cap open.
10. To prevent the waste toner bottle from coming into contact with the intermediate transfer unit (the position shown by the arrow in the illustration below), do not lift the bottle while inserting it.
11. Push in the waste toner bottle until it clicks. Pressing the handle at the center, push the bottle all the way in.



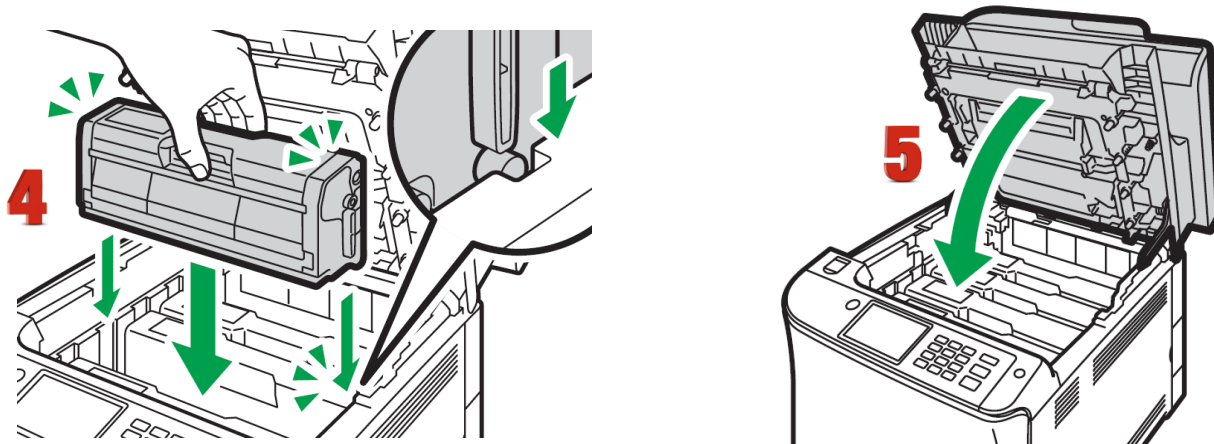
12. Place the transfer unit on the front cover. Slide the transfer unit along the guide rails into the machine.
13. When it stops, push on the PUSH mark until it clicks.
14. Using both hands, carefully push up the front cover until it closes.
14. When closing the front cover, push the upper area of the cover firmly.

Cleaning the Toner Density Sensor:

Clean the toner density sensor when the following message appears on the control panel.
"Density Sensor Require Cleaning"



1. Pull up the lever on the top cover, and then carefully raise the top cover.
2. Remove the rearmost print cartridge.
3. Slide the toner density sensor lever once to the left.



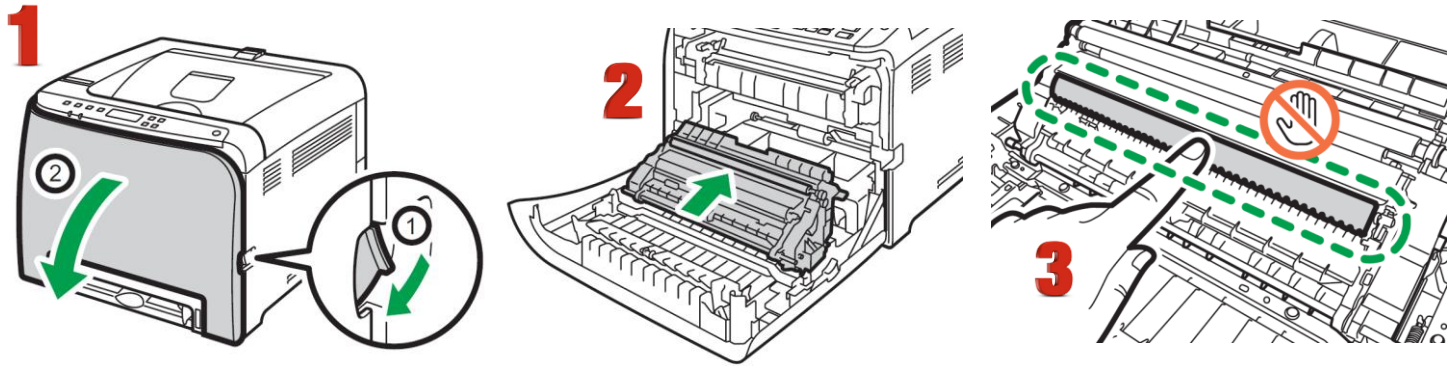
4. Carefully insert the print cartridge removed in Step 2 vertically.
5. Using both hands, hold the center of the top cover and close the cover carefully. Be careful not to trap your fingers.

Cleaning the Registration Roller

The registration roller can become dirty with paper dust if you print to non-standard paper.

Clean the registration roller if white dots appear on prints or if prints are smeared after a paper jam is cleared.

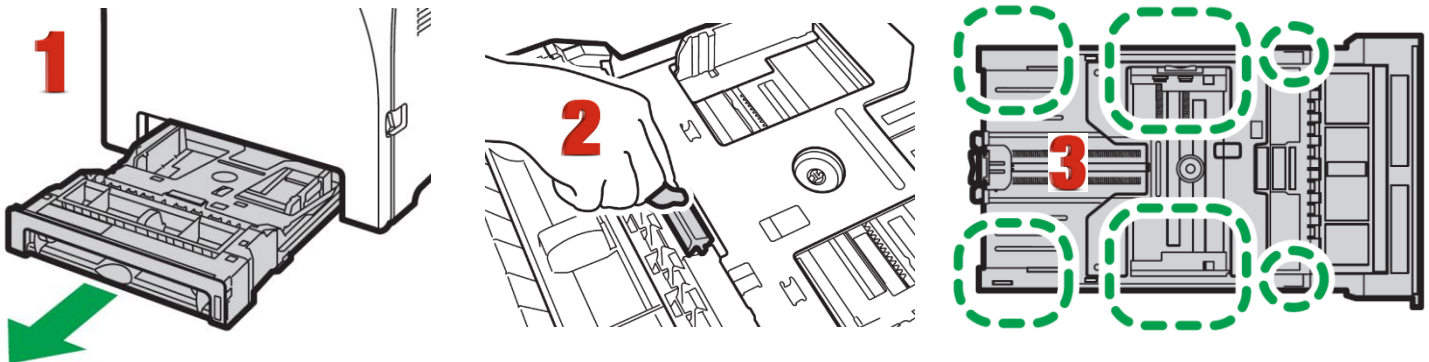
- Do not use chemical cleaning fluids or organic solvents such as thinner or benzene.



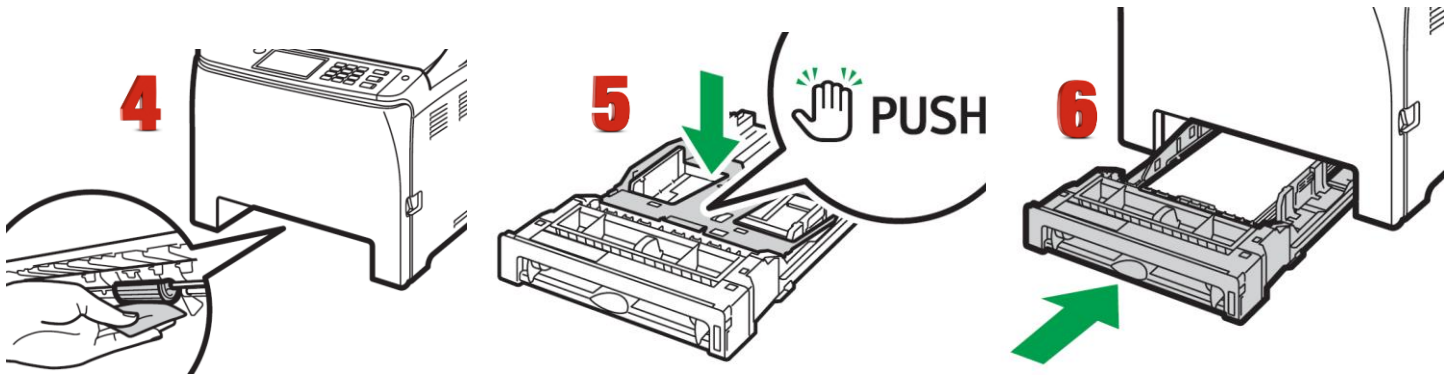
1. Turn off the power and unplug the power cord. Pull the front cover open lever and then carefully lower the front cover. Be sure to set the registration roller in the position shown by the arrow in the illustration below. Do not touch the transfer roller.
2. Clean the registration roller by applying a soft damp cloth while turning it using both hands, carefully push up the front cover until it closes.
3. When closing the front cover, push the upper area of the cover firmly.

Cleaning the Paper Tray, Friction Pad and Paper Feed Roller:

If the friction pad or paper feed roller is dirty, a multi-feed or misfeed might occur. The paper tray can become dirty with paper dust if you print to non-standard paper.




1. Turn off the power and unplug the power cord. Pull out Tray 1 carefully with both hands.
2. Place the tray on a flat surface. If there is paper in the tray, remove it.
3. Wipe the friction pads and the inside of the paper tray with a cloth.



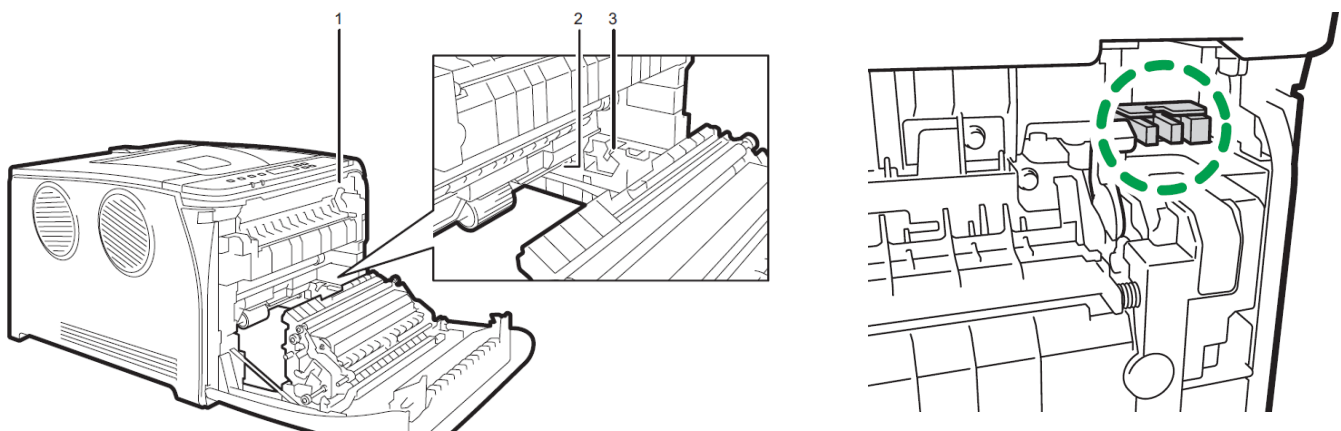
4. Underneath the printer, wipe the rubber part of the roller with a soft damp cloth. After that, wipe it with a dry cloth to remove the moisture.
5. Push the metal plate down until it clicks.
6. Reload the removed paper into the tray, and then push the tray carefully into the machine until it clicks into place.

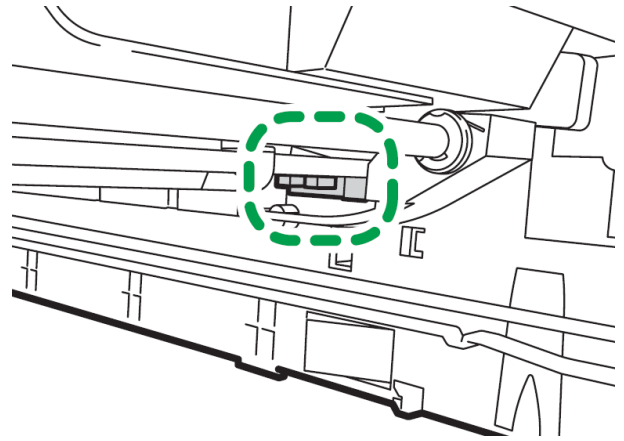
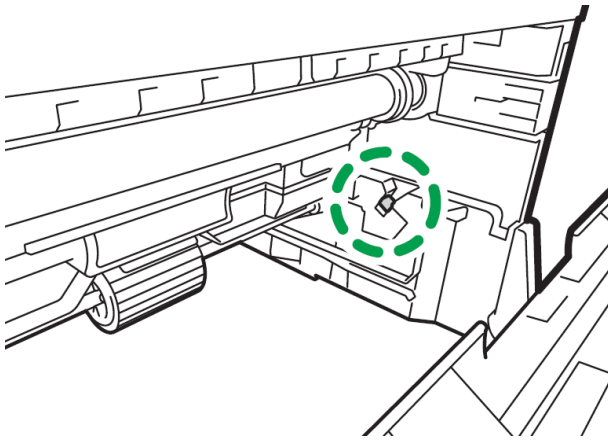
Removing Paper Jams

Caution

- The inside of this machine becomes very hot. Do not touch the parts labeled "  " (indicating a hot surface).
- Some of this machine's internal components get very hot. For this reason, take care when removing misfed paper. Not doing so could result in burns.
- Some of the internal components of this machine might be fragile. When you remove jammed paper, do not touch the sensors, connectors, LEDs, or other fragile parts that are shown in this manual. Doing so may cause malfunctions.

For the location of the sensors in the machine and extended options, see the following illustrations:



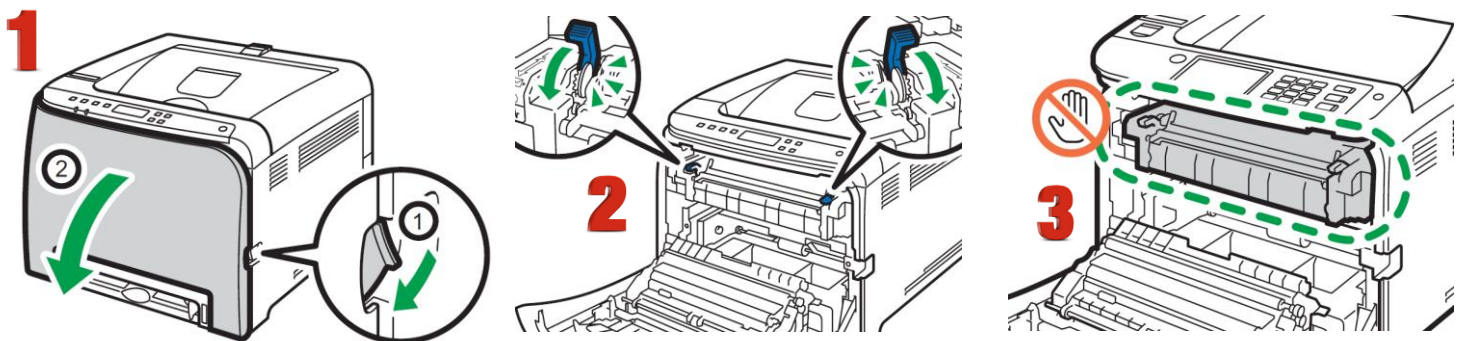


Important

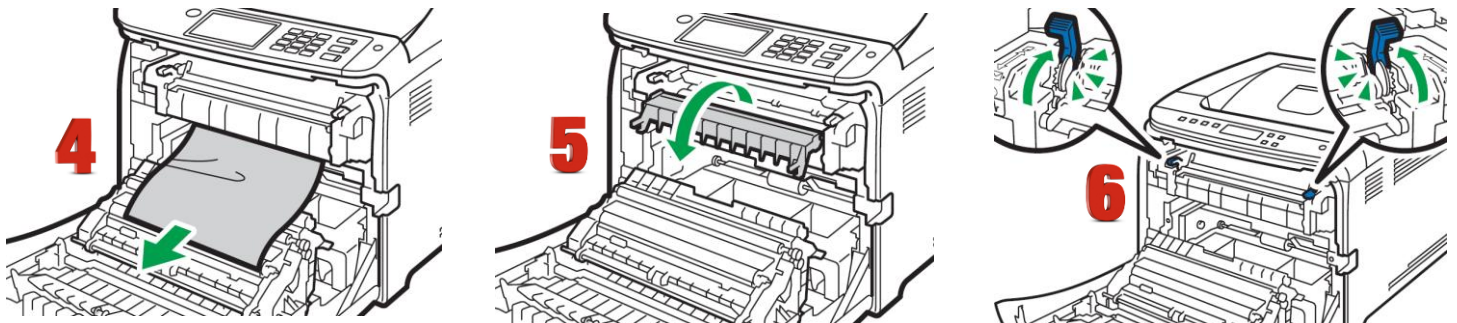
- Jammed paper may be covered in toner. Be careful not to get toner on your hands or clothes.
- Toner on prints made immediately after clearing a paper jam may be insufficiently fused and may smudge. Make test prints until smudges no longer appear.
- Do not forcefully remove jammed paper, as it may tear. Torn pieces remaining inside the machine will cause further jams and possibly damage the machine.
- Paper jam can cause pages to be lost. Check your print job for missing pages and reprint any pages that did not print out.

If paper jams inside the fusing unit, follow the procedure below to remove it.

- Since the temperature around the guide is high, wait for it to cool down before checking for jammed paper.



1. Pull the front cover open lever and then carefully lower the front cover.
2. Lower the fusing unit lever, and pull out the jammed paper carefully.
3. Do not touch the fusing unit.



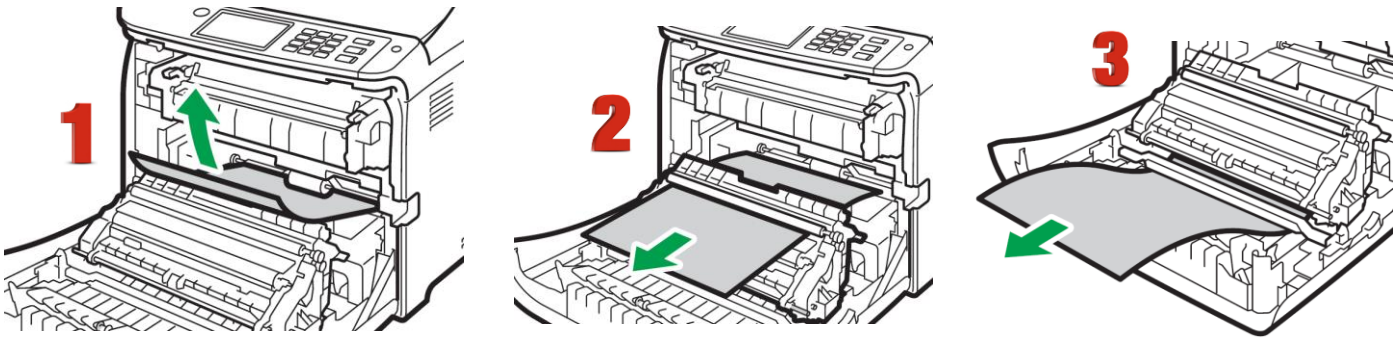
4. Pull the paper downward to remove it. Do not pull it upward.
5. If you cannot find the jammed paper, check for it by pulling down the guide.
6. Pull up the fusing unit levers.

If paper jams inside a tray

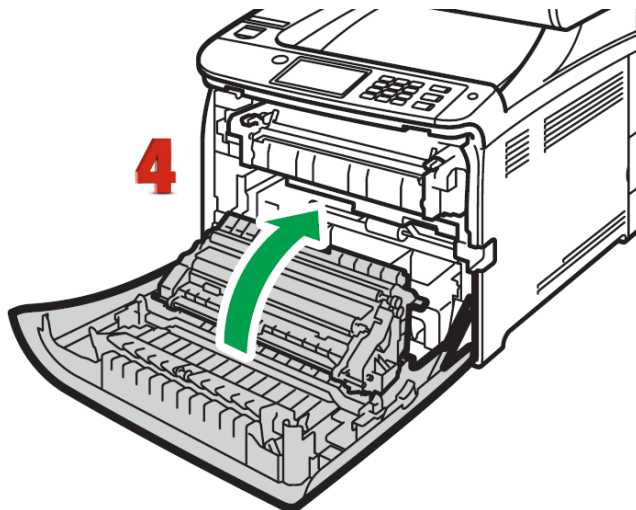
1. Pull out the jammed paper carefully. Do not pull out the paper tray or touch the fusing unit.

If paper has jammed inside the transfer unit

2. Holding both sides of the paper, pull the paper carefully forward.
3. Then pull out.



4. Once the jam is cleared, using both hands, carefully push up the front cover until it closes. When closing the front cover, push the upper area of the cover firmly. After closing the cover, check that the error is cleared.



Use Genuine UniNet iColor® Consumables

Only use genuine UniNet iColor® consumables. The use of incompatible supplies (toner, transfer belts, fusers and registration assemblies) may cause damage to your printer not covered by your warranty.

Printing tips

When transferring images with halftones, it's possible that some of the adhesive from your 2 step paper will not transfer over to the toner during the first step. If you see this happen with your image, just reprint the image with a white overprint using the ProRIP to thicken up the density and give the adhesive something to stick to. Halftone colors use much less toner. Printing the white over the image will fill in the halftones of color, with density below 70%. Using white overprint is necessary, even when transferring to white colored textiles.

There are many variables that could produce different results. Specific steps may need to be altered based on:

- Type and brand of Heat Press: The temperature and duration varies slightly based on the heat press being used. All instructions are based on using a Hotronix Fusion press. Clam shell and other types of swing away presses may also yield different results.
- Type of image: Photos or full color graphics may require a longer press time than vector images or text.
- Type of garment or substrate: Cotton, Polyester, and Spandex material all respond differently to heat, as do hard surfaces like acrylic or wood. All textile instructions are based on cotton garments.
- Toner Coverage: Halftones in image may cause undesired results. Toner coverage should not be less than 70%, otherwise there will be issues with transferring the adhesive to the transfer sheet. Halftones can be corrected by printing white on top of color using the iColor® ProRIP Software to apply a white layer in one pass. This will help with toner coverage and proper adherence to the garment.

Consult the iColor® knowledge base for specific instructions on a variety of transfer paper offered at:

<http://www.icolorprint.com/support>

Technical Support Email: Log a ticket at <https://www.icolorprint.com/get-support>

Technical Support Phone: 631-590-1040, Option 2

Available Media:

iColor® 2-Step **Premium** and **Premium STRETCH** Transfer Media for light and dark colored garments
iColor® 2-Step **Standard** Transfer Media for light and dark colored garments
iColor® 2-Step **Select** Transfer Media for light and dark colored garments
iColor® 1-Step **LIGHT** and **SPEED TRANS LIGHT** Transfer Media for light colored garments
iColor® 2-Step **GLITTER** Adhesive Transfer Media (for use with iColor® 2-Step **Standard** Transfer Media)
iColor® 2-Step **Presto!** Transfer Media for textiles and hard surfaces
iColor® 1-Step **CLASSIC**, **Premium**, **WOOD AND LEATHER** and **CERAMIC** Hard Surface Transfer Media
iColor® 1-Step **AquaClear** Transfer Media
iColor® 2-Step **Temporary Tattoo** Transfer Media

iColor® 540 System Specifications

Print Speed: Print Speed: Up to 26 ppm Color and Monochrome
(Transparency setting speeds may vary)

Processor: Intel 1.46 GHz

Duty Cycle: Up to 75,000 pg/mo.

Duplex: Standard

Memory: 2GB RAM

Resolution: 1200 x 1200 dpi

Emulation: PCL® 6, PCL 5c; PostScript® 3™

Operating Systems: Windows 7, 8.1, 10; Mac® support – OS X 10.5 and higher (Printer only)

Interfaces: 10/100-TX Ethernet, High Speed USB v2.0

Multipurpose Tray: Standard 100-sheet; handles transfer media, card, mailing label stock and banners

Paper Cassette: 500-sheet Legal/Letter/Universal

Paper Sizes (Min./Max.): Multipurpose tray handles up to 100 sheets – 3" x 5" to 8.5" x 49.6";

Paper Cassette – 5.8" x 8.3" to 8.5" x 14"

Paper Weight: Multipurpose Tray - 16 lb. bond – 59lb. bond (60 – 220 gsm); Paper Cassette - 16 lb. bond – 43 lb. index (60 – 163 gsm)

Size: (WxDxH): 15.8" x 18.9" x 15.2" (40 cm x 48 cm x 38.6 cm)

Weight: 64 lb. (29 kg)

Power: 230v