

READ THIS WHOLE MANUAL WHEN SETTING UP YOUR PRINTER. DO NOT TAKE THIS INFORMATION LIGHTLY OR SKIP STEPS.

1. BEFORE DELIVERY

- Printer will be delivered in a large cardboard box. 47.5" (W) x 63" (D) x 33" (H) 313 lbs.
- Make arrangements for help unpacking as delivery company will drop off only.
- If printer package does not fit through doorway, it is okay to un-box outside.

- Unboxed printer weighs 160lbs.
- Review user manual on tipping through a doorway (attached)
- Buy USB Printer Cable. Shorter is better for data transfer. Melco recommends 6ft.

CHOOSING AN ENVIRONMENT

- Cleaner is better.
- Recommended humidity 40-60%.
- Temperature should be comfortable.
- Place on sturdy table. Portable cart available at shopmelco.com.
- Allow free space on left side for the air filter exhaust outlet.

SOFTWARE AND DOWNLOADS

- Download your drivers and software before you take delivery. Your printer runs on Mac or PC from **www.epson.com/support/f2000**
- Go to Epson Support Portal and download docs. **www.epson.com/support/F2000**
The support portal is where you will find training videos and all downloads for the F2000.
WATCH ALL VIDEOS!
- Download User Guide **DO NOT PRINT** **<https://files.support.epson.com/docid/cpd4/cpd40257.pdf>**
ESSENTIAL DOWNLOAD - Page numbers in this manual refer to Users Guide.
- Download Garment Creator and ALL Drivers from Epson Support Portal.
 - Be sure you choose the correct operating system. **DOWNLOAD AND RUN ALL DRIVERS THEN OPEN GARMENT CREATOR.** See inks below for video guides.
- Set up Cost Estimate Tool, refer to Garment Creator Variables Guide (Attached)
 - Understanding Garment Creator Video **http://youtu.be/3Zafica_DyA**
 - Understanding Estimate Tool video **<http://youtu.be/nkYHEx2enAw>**
 - Epson Garment Creator Video **<http://bcove.me/60wae595>**

2. OUT OF THE BOX - PRINTER SET UP

Follow *START HERE* poster that comes with your printer.

FOLLOW THIS POSTER STEP BY STEP! Melco video accompanies start here poster.

Watch Set Up Video from Melco <https://youtu.be/uoSOew8ZuHg>

Save These!

- Platen Lock.
- Waste Tube Plugs (x2).

Removing Tape

- When removing tape for the print head, be sure the fabric wiper remains seated.
- An LCD error at install is likely this issue.

Cable Routing

- Use white cable ties (2 of 4) and loop USB or Ethernet communication cable for strain relief.

Waste Tube Routing

- Use cable ties (2 of 4) positioned under the rear of the unit to route the waste ink tubes.
- Tube position must allow waste ink to gravity drain, no loops or high points.

Charging Ink - 40 Minutes

- Ink cartridges need to be at room temp.
- Shake ALL cartridges for 30 seconds.
- Do not interrupt the ink charging cycle.
- 250 ml cartridges that come with the printer, will not have enough ink to complete charging twice.

DO NOT INTERRUPT CHARGING PROCESS ONCE BEGUN! ONCE COMPLETE, YOUR WHITE INK WILL READ LOW. THIS IS NORMAL.

Connect Your Computer To Printer

- USB cable (no more than 6ft in length)
- Over your network, ethernet cable. Follow instructions in User's Guide for Network Connection.
- Export job to USB drive. In Garment Creator, input your artwork and set print variables. FILE>EXPORT FILE>COMPUTER>Label and save to folder. NOTE: You must save to computer hard drive and DRAG TO USB folder.
- Plug USB in printer and print from USB File List. (Pg. 57-58)

Must Do!

- Update Firmware as needed with LFP Remote Panel 2 (downloaded from support portal)
- Put plastic tweezers in right cartridge bay holder. Required for CAP cleaning.

3. BEFORE YOU PRINT

After charging your printer will read "INK LOW" for white ink.

This is normal. Use these white ink cartridges until they run out. Expect about 10-15 prints.

1. Turn the *Power On Cleaning* function Off (Pg. 125-126 in Users Guide)

- Power on cleaning uses medium head cleaning every time printer is turned on. Okay to turn this feature off to save ink, will not void warranty.
- Do light head cleaning upon power up and nozzle check. 1 or a few light head cleaning will usually clear any clogged nozzles. 9 light cleanings equals 1 medium cleaning.
- Okay to keep Power On function on but note it will use more ink to clean than necessary.

2. Put printer in ECO MODE

- Printer Setup > Tube Washing Setup > Eco Mode
- Tube washing is critical to printer health and eliminates the need to do white ink tube flush. Watch this video on how to do the process. <https://youtu.be/8ynNbojt2VA>

3. Set your *Platen Height & Head Alignment* (Pg. 72-73 in Users Guide)

- Set platen height to #1 and run Head Alignment.
- Watch instructional video. <http://bcove.me/ghsdi3pt>

4. Set *Offset Head Alignment* (Pg. 125)

- Set platen to position 2.
- Set Offset Head Alignment to +2. for every platen number drop
- Offset Head Alignment should be + or - 2 with each platen shift up or down. Print on 2=+2, 3=+4, 4=+6, 5=+8, 6=+10. This is different than what Epson says, either technique is okay.

5. Setting Platen Height for Printing

- Set to platen height 2 for threading shirts.
- Set to platen height 3 for laying shirts flat.
- Epson video on setting platen height. <http://bcove.me/p1qswufe>
- Melco video on platen height. <https://youtu.be/EexGD4lvXRE>

NOW YOU ARE READY TO PRINT

**REVIEW SECTION 4 "OPERATION ESSENTIALS"
AND THE MAINTENANCE MANUAL FOR OPERATIONAL PRACTICES.**

4. OPERATION ESSENTIALS

Go to **ProDTG.com** for the most comprehensive info on the F2000.

Follow Scheduled Maintenance

- Refer to Melco F2000 Maintenance Guide.
- See Epson User Guide page 67 for detailed maintenance instructions.
- Print Epson Maintenance Chart attached to Melco Maintenance Guide.

Ink Cartridges

- Shake all for 30 seconds before 1st use.
- Ink should be at room temp before installing.
- Shake White for 15 seconds before printing.
- Store all cartridges on their flat side. Easier to put pigment particles back into solution.
- Epson White Cartridges have long shelf life.
- Should be used within 18 months.
- 600 ml cartridges are recommended for White do to Monthly Tube Washing requirement.

T-shirt Selection

- Higher quality garments will yield best print results. For example. Gildan will yield poor quality prints where Spectra Apparel will yield best results. Look for 30 single ring spun cotton for best print quality.
- White ink bonds best with 100% cotton.
- You can print on 50-50 but garment quality will determine print results. Gildan 50-50 will show poor white ink where Spectra Apparel 50-50 will show outstanding white ink.
- White ink does not bond well to synthetic fibers.
- You can print on 100% polyester but not with white ink. Print only color ink on poly or other synthetic fibers.
- Experiment with different garment brands and fabric composition. Be sure to run wash tests to ensure ink has bonded with garment. Melco recommends Spectra Apparel.

Pre-treating Garment (Pg. 24-35 in Users Guide)

- Watch Epson video on how to pretreat manually. <http://bcove.me/5h0owd7a>
- Watch Melco video on how to pretreat. https://youtu.be/WngA_6lGJug
- Another Melco pretreat video. https://youtu.be/Cz_NIGYY1hw
- Melco recommends learning how to pretreat manually. A pretreat machine is extremely valuable however learning to pretreat manually will help you understand how pretreat works and how smooth application is important for clean prints.
- Buy the Manual pretreat kit with Epson recommended supplies for pretreating manually on www.shopmelco.com
- Poor print quality is often a result of poor pretreat coverage.

4. OPERATION ESSENTIALS (CONT)

Preparing Artwork

- Garment Creator (GC) is your printers driver and rip.
- GC creates your designs white underbase when using white ink.
- GC has some graphic editing functionality however major edits should be done in Adobe or Corel.
- When designing art in Adobe Photoshop or Corel Paint, design your art about the size you want it to print, 300dpi, and RGB. High quality art will yield high quality prints. Save artwork to print size, as a transparent .tiff or .png.
- If designing in Illustrator or Draw, be sure to export your art to print size as transparent .tiff.
- Low resolution art cannot be made high resolution once saved low.
- Open your high quality art in GC, make adjustments, and print.

Tube Washing

- Do Head Cap Tube Washing every 2-5 days when not printing and at the end of every print day.
- <https://youtu.be/8ynNbojt2VA>

Essential Parts To Have On Hand At All Times

All parts can be ordered from **shopmelco.com**

- 2 - 600ml white ink cartridges. Full cartridges.
 - 2 more than half full cleaning cartridges - Replenish stock after 1 use.
 - 1 Print Head Maintenance Kit - Replace after use.
 - 1 Printer air filter - Replace after use.
 - 1 2L bottle of concentrate pretreat.
 - Tube Washing Kit
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- Call Epson for full support. (562)-276-1305, (888)-377-6611, 6AM to 6PM, Pacific Time, M-F.
If you talk to a support person at Epson that cannot help you, ask for another tech support agent.
 - Call Melco for issues Epson cannot help with. 800-799-8313

BE SURE TO READ THIS WHOLE MANUAL AND REFER TO PRODGT.COM