GTX_{pro} BULK DTF R2R

We share our experience to give you the *best Support*

COOKBOOK

The printer should only be used by operators who are appropriately trained in its safe operation.
The printer is not suitable for use in places where children are present.

Always make sure that you use the latest software for your GTXpro BULK DTF R2R.

You find the latest versions here:

https://base.brother.digital/driver-firmware/gtxpro-roll/

Mandatory temperature and air humidity for the best print result:

30°   85%

18 °   35%

Please check the temperature and air humidity in the menu of the printer:

If temperature is too cold: The printer will switch automatically to "Low-Temp Mode" and reduce t
speed. Raise the temperature of the printer's environment.

If temperature is too high: Please turn down the temperature of the surrounding area of the printe

If humidity is too low: The printer will perform auto-cleaning after every print if the humidity is low
                            than 35%.
                            Please install a humidifier in your workspace.

If humidity is too high: Please try to lower the humidity of the surrounding area of the printer.

Please always keep the temperature and humidity within the required ranges, otherwise the GTX
might get damaged.

The liquids should be stored at a temperature between minimum 0°C and maximum 40°C.

[?] Please turn over the white ink refill tank every week.

[?] Do not use inks or liquids with a temperature below
    18° C or above 30° C .

40°

0 °

The display shows the current loaded pri
the choosen print format, the approximat
consumption for it and the number of pri

A   E

B

C

D

A: Freely assignable speed dial button
B: Button for platen moving
C: Cancel button
D: Print start
MENU/OK: Opens the menu and confirm
[?] : Cursor buttons for moving through th
E: The LEFT cursor button is the go back bu

F: Power switch ON/OFF
G: USB 3.0 Typ A port to load print files from
   USB-stick.
H: LAN port for connection to your PC.
J: USB Typ B port for connection to your PC

G

F   H
       J

[?] Regularly check all moving parts of the machine and look for ink leaks.
[?] Check the level in the waste ink tank and, if necessary, empty it.

[?] Please follow all the instructions shown on the
display.

When you see an "Error/Warning" yellow
number press the "[?]" key to know what you
have to do to erase the Error/Warning.

Check that the GTXpro Roll and the PowDR are still aligned (a laser is helpful).
The brakes of the castors should always be applied.

B
A

A: 23 cm parallel to the printer; B: 25-30 cm parallel to the printer

The film can run skewed through the system for various reasons, even if the machines are precisely aligned. Missalignment of the film leads to poor print results.
The missalignment can be checked on different positions on the runway of the film.

C

E   F G   H   H

D

C:

Is the film roll centred and does the film have equal tension at the edges?

Is the film just aligned with the roll?

D:

Is the fixing lever closed?

E:

Is the film aligned straight on the printing table?

Can the film slide freely through the gu

F:

G:

H:

Is the film in the melting unit well aligned?

If a new powder type has been filled into the
der unit or the unit has been moved, the
sensor must be recalibrated.
Consult the PowDR manual.

Fill the powder tank with the necessary amount
of DTF powder.

You have to perform a nozzle test for CMYK and white every morning before starting your productio

A

B

C

When the nozzle checks are done, run the film out of the back of the printer:

A: Press for transportation of the film.

B: Press the Menu/OK button.

C: Press Cancel when the print comes out of the back of the printer.

This is what the nozzle checks should look like:

Check the nozzle pattern by holding a v
(CMYK print) or black (White print) pap
behind the film.

If not all nozzles are firing, start a cleaning of the affected print head to open the clogged nozzles.

If still more than 10 nozzles are missing, select super cleaning.

Perform a nozzle test to check the result and perform another cleaning if the nozzles still do not spray.

You can find instructions for printing here (>TIP-Sheets > GTXpro Roll > Print Settings/Software Guide):

https://base.brother.digital/tip-sheets/

Please make sure that the resolution of your printfile is not too low.
A resolution of 300 dpi in relation to the print format is recommended.

? ? ? ?

A

Insert the film roll between the jaws.
A: The rolling direction

Center the roll between the edges of the p
Then fasten the thumbscrews.

?

?

Turn the brake knob right side counter-clockwise
until it stops to release the brake completely.

Repeat the operation on the left side.

?

?

Then slightly, with one finger, turn each knob
clockwise till you feel a slight resistance.
It is best to set the buttons identically.

HELPFUL: Attach a spring balance to the
slowly unroll it a little. The resistance valu
not exceed 100 gr.

?

?

B

[?]

[?]

Adjust the guides. The guides should only cover the film with a maximum of half of their width. Then slide the film out of the printer by hand.

Switch OFF the power at the PowDR.

[?]

[?]

Remove the transparent lid.

Pull some film through the printer and in over the rod into the PowDR.

[?]

[?]

Place it under the ionizer and on the conveyor belt.

Open the big lid of the PowDR. Lift it up w handle on the left side until it stops.

[?]

[?]

[?]

[?]

Place the film on the left edge of the belt when installimg a roll with 40 cm width.

Make sure that the film lays completely pa to the conveyor belt.

[?]

[?]

Tape the film at a point in the middle of the roll. The film can thus freely align itself a little.

HELPFUL: Check the alignment of the a laser.

[?]

Give the film some slack when under the ionizer and right before the conveyor belt.

Make sure that the film does not touch any of the powder unit!

[?]

[?]

Make sure that the edges of the film
have the same tension on both sides
If not so, align the machines with each

Never join two films with tape or in any

Switch ON the power.

HELPFUL to know:
Put some powder on the film via the menu to have a little weight on the slack.

Press minus button and hold for 10 sec

In general the chemical composition of white ink includes pigments and other substances which a
not soluble. This insolubility might lead to sedimentation in white ink what has to be eleminated b
agitation before the refill process starts.

If the white ink is not agitated well before refilling, the print result will not be acceptable and the re
container as well as the white ink in the printer will be lost. In addition, the removal of the unusab
white ink from the printer is time-consuming.

Before every refill of white ink you have to agitate the refill canister.

The ink refilling process is guided by the menu. The IC-Stick, which is included with each ink canister, is necessary to activate the refill process in the menu.

– If the IC stick is not in place, the printer will ask for it.
– If the IC stick from a wrong color has been inserted, the printer will detect it and report it.
– If the IC stick is lost or broken, contact your dealer immediately.
– A reserve set of ink enables a continuous production.

Y	1,8 L	C	1,8 L	M	1,8 L
06. 2024		05. 2024		05. 2024		05. 2024
Lot. 0507a5		Lot. 05065		Lot. 05055		Lot. 05045
M045-0031		M045-0031		M045-0031		M045-0031

If the following message is shown on the display
the mentioned color has to be refilled:

Choose "Ink refill" from the menu and follow the guided steps:

[?]   [?]

█ Yellow

[?]   [?]

                                            ▌ Yellow

Insert the IC-Stick from the needed refill bottle
into the dedicated slot of the printer.

[?]   [?]

                                            ▌ Yellow

[?]

▌ Yellow

A rolling scissor lift is helpful for refilling white ink:

Every 30 days a warning appears: the ink tank calibration must be performed for all ink tanks.
If it is not performed after 32 days error, 1011 will occur.
You will not be able to print until calibration is done.

!

If this warning is displayed, ink tank calibration must be performed.

Check the ink level.
If the ink level is on the border (like here), please select the higher number.

6
5
4
3
2
1

Select "Correct tank volume sensor"

Yellow

A flashlight is helpful to check the ink level white tank.

The refill of the Cleaning Solution circuit is done from the bottom tank.
The upper tank is refilled by a pump activated by a sensor.

? Please refill the bottom tank, when "C.S. Empty" is shown on the display.

?

?

Select "Filling solution tank" and follow the
instructions in the menu.

Normal situation:

C

A

B

A: "Obstacle sensor"
It is used to detect any obstacle on t
platen for the print heads.
An error occurs when
obstruction is detected.

B: Film on the platen

C: Print head

Obstruction situation:

C

A

B

A: When the beam of the obstacle sens
an obstacle, the printing process v
stopped immediately to avoid cras
print heads.

On the display Error 2070 appears.

Position:

Normal situation (Sectional view):

E

E: The well aligned film presses the se
down with its tension.

End of film situation (Sectional view):

E: The sensor comes up when:
- the end of the film passes the senso
- the film curves due to misalignme
  and looses contact with the senso

E

The printer will stop immediately.

The following message will be displayed:

[?]

[?]

[?][?][?]

The display changes (see right).

After installing a new film or realignin
The display changes (see next).

[?]

[?]

In the event of a power failure in your work[...] push the print head carriage to the capp[...] sition by hand. This will protect the print[...] from drying out for some minutes, giv[...] some time to solve the problem.

In case of a "Warning/Error" message connected to a maintenance part, you always have to use [...] menu and run "Maintenance Part Clean/Replace".

In case of a "Warning/Error" message connected to the flushing foams, please carry out the following actions:

Position of the flushing foam (white side).

Lift up the flushing receiver and use a was[...] to avoid that ink drips into the GTXpro Bull[...] Remove the flushing foam and clean the re[...] from inside to ensure that the hole in the re[...] is open. Insert a new flushing foam and [...] the receiver. Repeat the same on CMYK s[...]

In case of a "Warning/Error" message connected to the wiper cleaner, please carry out the following ac[...]

In case of a "Warning/Error" message connected to the fan filter, please carry out the following actions:

A

Position of the fan filters.
Please remove the two fan filter holders.

Insert a new filter with the coarse side A fa
the inner area of the GTXpro Bulk in each
Insert the holders in the GTXpro Bulk.

For the maintenance of the PowDR, please refer the PowDR manual.

After the installation of your GTXpro Bulk, the following warning will appear every seven days:

!

Use the following menu to perform cleanir
"Maintenance Part Clean/Replace" after re
the warning on the menu:

[?]   [?]

[?]

Perform the cleaning within 15 min to prevent the print heads from damage.

[?] For cap and exhaust cleaning you need cleaning
sticks T and a bit of cleaning solution.

Make sure that you use new cleaning sticks.
Never use the same cleaning stick for white and
color parts.

[?]   [?]

[?]

When cleaning the exhaust start from th
and go backwards. Always move the sti
from the drain hole placed in front.

[?]

Clean the wiper on both sides, under the t
the wiper holder and remove the dried ink.

[?] Use a new cleaning stick R and fresh cleaning solution
for the cleaning of the nozzle guards of each print head.

View from below
A: Surfaces to be cleaned on the underside of
the print heads.
B: Do not touch the nozzle surface at all.

A

B

B   B

A   A

?

A

B

A: The nozzle guard must be cleaned from underneath through the gap between the platen and the maintenance unit.
B: If the gap seems too narrow for you, you can remove the left slider.

Be careful not to touch the nozzle surfac[e] during cleaning. Move the print head ca[refully by] hand from left to right to reach the comp[lete] nozzle guard.
Do not touch the nozzle surface at all.

? Remove and clean up the side guides of the film on the printing table weekly. Friction causes abrasion of the film at the guides, which can affect the alignment of the film.

Due to the production process, lint and ink mist contaminate the inside of the machine. These must be removed to increase the longevity of the machine.

Use the menu "Maintenance Part Clean/Replace".
Perform the cleaning within 15 min to prevent the print heads from damage.

?   ?

A

B
C

Clean the 3 carriage rollers on top and the roller underside with a new stick R dipped in cleaning solution.

Use a non-fuzzy cloth moistened with a Isopropyl Alcohol (95%) for the cleaning
A: The 3 sides of the roller guide
B: The carriage guide shaft
C: Both sides of the encoder strip.
Do not use Isopropyl Alcohol on any other
Then apply a proper amount of Molykote 30 G
onto the carriage guide shaft (B) only.

Perform a CR Speed Adjustment via the menu:

Follow and wait till finished.

Print out a nozzle check pattern and do a nozzle cleaning if necessary.

Preventive maintenance of the machine is necessary to keep the machine in good working condition and to ensure good printing quality.

The following maintenance intervals must be observed: at 25k / 50k / 75k / 100k prints and so on.

Regular maintenances are carried out by the service technician and can only be done by using the GTXpro Bulk "Preventive Maintenance Tool" .

Insert a USB stick in the front slot of the GTXpro Bulk to be able to copy the logfile. Then use the menu:

The GTXpro Bulk should always be left with power ON, also when it is not used.

Power is needed to perform the recirculation of the white ink every day. This process does not consume

If the GTXpro Bulk is turned OFF for a long time, it might get damaged.

Only pull the plug in
an emergency or
when requested by a
display message!

If the GTXpro Bulk is not going to be used for a prolonged period of time contact your local dealer, because preparatory operations for storage must be carried out.

 If you want to resume production after several hours or days, the following preparatory steps are neces

Inks

Name (Pieces)	Quantity	Order Number
CYAN Refill ink bottle (1)	1.8 L	BGCX40C002K0152
MAGENTA Refill ink bottle (1)	1.8 L	BGCX40M002K0152
YELLOW Refill ink bottle (1)	1.8 L	BGCX40Y002K0152
BLACK Refill ink bottle (1)	1.8 L	BGCX40K002K0152
CYAN Refill ink bottle (1)	9 L	BGCX40C009L0132
MAGENTA Refill ink bottle (1)	9 L	BGCX40M009L0132
YELLOW Refill ink bottle (1)	9 L	BGCX40Y009L0132
BLACK Refill ink bottle (1)	9 L	BGCX40K009L0132
W WHITE Refill ink bottle (1)	18 L	BGCX40W020K0032

Liquids

Name (Pieces)	Quantity	Order Number
CLEANING SOLUTION (1)	1.8 L	BGCX40E002K052
CLEANING SOLUTION (1)	5 L	BGCX40E005K042

Other parts

Name (Pieces)	Quantity	Order Number
FLUSHING FOAM (2)	1	SC0935001
WIPER CLEANER (2)	1	SB6673101
FAN FILTER (2)	1	SB7007001
CLEANING STICK R (50)	1	SB7008001
CLEANING STICK T (100)	1	N40001601

Film

Name	Pieces	Order Nur
SCH-73451 DTF PREMIUM FILM 0.3x100 ROLL	1	N400023
SCH 75125 DTF PREMIUM FILM 0.4X100 ROLL	1	N400023
ITEX-IGDTF2S40 DTF TRANSFER FILM 40CMx100M ROLL	1	N400023

Powder

Name	Pieces	Order Nur
SCH-73325 DTF POWDER 1,5 KG (80-200µ)	1	N400020