

DuPont™ Artistri® Xite F800 Flushing Solution

Textile Auxiliary

Cleaning Procedure

This is a general procedure. Please refer to your printer maintenance instructions for any specific procedures that are recommended for your print system. The following flushing procedure is designed for the DuPont Artistri® dye based inks; Acid, Reactive, Direct Disperse and Dye Sublimation ink series.

Be sure to monitor waste tank throughout the process to avoid overflow.

1. Required components for Conversion:

- a. New bulk filters.
- b. New last chance filters.
- c. Head flush system- syringe (50ml recommended) with filter and head fittings.
- d. Printhead bypass fittings.
- e. 4kg of F800 Flushing solution per color channel and 0.25kg per head. F800 Flushing Solution can be obtained through DuPont.
- f. Artistri® Dye base inks.
- j. Run fill cycle until flush is past last chance filters.
- k. Replace all last chance filters.
- l. Run fill cycle until flush is past the head bypass tubes,
- m. Allow flush to soak in system for a minimum of 6 hours. Flush can be left in system up to 24 hours.
- n. After soak is completed, continue running the fill cycle with the remaining flush in the bulk tank, to ensure the system is as clean as possible.

2. Steps to remove existing ink and change filters:

- a. Disconnect printheads from ink system.
- b. Install printhead bypass fittings.
- c. Empty and wash bulk ink tanks with DI or distilled water.
- d. Ensure that ink system cannot return waste to the bulk tanks.
- e. Fill each bulk tank with at least 4kg of flush.
- f. Run fill cycle on printer until ink line is clean from the bulk ink container to the bulk ink filter.
- g. Replace bulk in filter.
- h. Continue running fill cycle until the ink lines are transparent to the secondary tanks.
- i. Drain and fill the secondary tanks.

3. Steps to flush print heads:

- a. Using flushing system (syringe with filter inline), push ~25ml of flush into printhead outlet and ~25ml flush through printhead inlet, allowing it to come out of the nozzles. In extreme cases, it may be necessary to push flush from the outlet to the inlet and allow it to soak for 5 minutes before flush will flow through the nozzles.
- b. Allow flush to soak in head for at least 10 minutes.
- c. Repeat steps "a" through "b" as needed. Three times is generally sufficient.
- d. Clean the outside of the printhead with a clean wipe to remove any old ink. Avoid getting electrical connectors wet.

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4. Steps to introduce new ink to the printer:

- Empty bulk containers of flush.
- Fill the bulk containers with Artistri® Dye ink.
- Run fill cycle. After the ink has reached the secondary tanks, continue to run? for 30 seconds to a minute.
- Drain the secondary tanks and allow them to refill.
- Repeat steps “c” through “d” three times. This will minimize the amount of residual flush that could dilute the ink.
- Remove printhead bypasses and reconnect printheads.
- Run multiple strong purge and clean cycles to fully prime the printheads.

5. Tips:

- Missing nozzles after an ink changeover should come back with time. It is best practice to perform multiple purges and let the new ink sit overnight so that air is removed from the system.
- Initial jetting sustainability may be poor as air works its way out of the system. This can be overcome by printing at slower speeds before ramping up to normal printing speeds.
- Severe starvation may be a symptom of restricted flow through the last chance filters. Additional replacement of the last chance filters may be required.
- Do not over-exercise the printheads if you observe starvation symptoms as this will affect the life of the printhead.



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