



Hilord Chemical Corporation

Hilord SP-2000 Dye Sublimation Electrostatic Digital Inks for 3M's Scotchprint™ 2000Printer

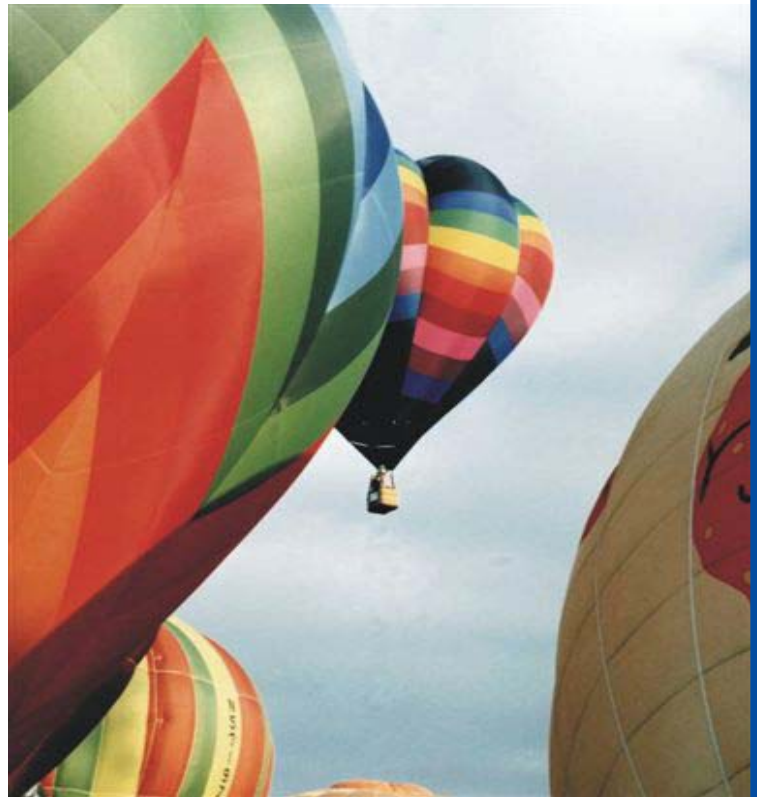
Why convert the Scotchprint™ 2000Printer to “Hilord’s” Dye Sublimation Inks?

Hilord Inks ensure:

- Vibrant, brilliant colors
- Excellent color gamut
- Color and density consistency between different batches
- Minimum maintenance whether the printer is in use or idle
- Competitively priced
- Use with the internal concentrate add system

Specifications:

- Standard Paper: Sihl 80 gram (3M code = 8616)
- Print speed at: 1.0-2.0 ips (120-240 squaremeters per hour)
- Optimal Speed: 1.5 ips (180 square meters per hour)
- System Components: 4-Color premix and 4-Color Concentrate System (CMYK)
- Transfer Conditions: Standard temp = 400 F(204 C), Standard Pressure: 20-25 psi, Standard time = 45 seconds
- Standard Substrate: Polyester/Polysatin cloth.
- Other substrates with suggested manufacturers: various cloths and fabrics (Ibena and Fischer), coated metal (Hilord's Poly-Hi coatings), carpet and other coated materials. Transfer conditions will vary per substrate.



Stay aloft, use Hilord Inks.

Satisfaction Guaranteed:

Hilord is the OEM supplier for these inks. The printers were built around Hilord Inks. Our dealers supply service and parts with the best inks from Hilord.

To Sum Up: Hilord's matched componet system; color curves, inks, coating and recommended media, keep operation costs at a minimum!

SP-2000 Dye Sublimation Electrostatic Digital Ink for 3M's Scotchprint 2000™ Printer

Procedure for Rinsing 3M SP-2000 Scotchprint Printer and Conversion to Dye Sublimation System.

If you do not have access to the service switch on the left side of the printer, (the white, round pull knob), perform steps A-E.

The concentrate-add system you are using (external or internal toner module, 1 liter rectangular bottles) must first be rinsed. If it is already rinsed or you are not using it for some reason, skip step A and proceed to step B.

A. Rinsing concentrate-add system:

1. Remove the conventional concentrate bottles and replace them with fresh rinse.
2. Remove all 4 (or 5 if you have a spot fountain) premix bottles (conventional ink).
3. Replace these premix bottles with empty collection bottles or pans of your choosing. You may use anything that can hold a few hundred milliliters to collect the concentrate that is in the tubing.
4. Go to the toner tab on the Printer-controller menu. Whether you are using the internal add system or the toner cart, you will now highlight "add concentrate (number of strokes)".
5. Add the concentrate (which is now fresh rinse) in increments of 5-10 strokes (internal concentrate-add system) or 20-30 strokes (external toner cart).
6. Add the rinse until you see clear (or nearly clear) rinse dumping into your collection bottles.
7. Wipe the "mouth" of the plumbing with a clean wipe to further clean any remaining concentrate.
8. When you are satisfied that the concentrate-add system is flushed completely, disable it. You may do this by simply changing the add rate to 0.000 ml/ft.



B. Rinsing the Premix Plumbing and Fountain System:

1. Insert 4 (5) fresh rinse bottles with clean inserts into the printer.
2. Make sure that paper is loaded into the printer. This procedure will use about 20-30 feet of paper so it may be wise to use inexpensive or research paper for this procedure.
3. Click the "Advance Media" tab on the main screen of the Printer-Controller. The paper will advance a pre-determined number of feet. If it moves for more than 7-8 feet, stop it by clicking the same button. Wait until all pumps stop for 10 seconds so that the rinse recedes back into the bottle.
4. Repeat the previous step two more times.

C. Physical Cleaning of the Fountain, Writing Heads, Vacuum Channels.

1. Turn off the Printer unit. The switch is on the right side. You should receive an error message on the controller screen that says "MCS Not Communicating".
2. Cut the paper in front of the supply roll (rear of machine) and in front of the plotter. This should enable you to open the top of the printer.
3. Open the printer and carefully remove the paper covering the fountains. Put up locking arm and attach it to ensure the top of the printer stays up safely.
4. Ensure that you have a supply of clean wipes, rinse solution, and Isopropyl Alcohol.
5. Starting with the fountain nearest you, wipe the roller with a dry wipe (spin it between passes to ensure that you get the whole surface). If necessary, dampen a wipe with rinse solution and wipe the roller to clean it more thoroughly. Use a damp wipe (twist the corner until it is a small point) to wipe out the vacuum channel towards the left side drain. Scoop out any debris with a small spatula if needed.
6. When the roller and vacuum channel are clean, lightly dampen a wipe with Isopropyl Alcohol. Dampen the wipe away from the printer. Do not get Alcohol in the fountain, vacuum channel or anywhere else in the printer. Lightly wipe the fountain writing head with a smooth side-to-side motion.
Another option is to use rinse instead if Isopropanol. If you use this, make sure to dry the head thoroughly.

Procedure for Rinsing 3M SP-2000 Scotchprint Printer and Conversion to Dye Sublimation System - Cont.

C. Physical Cleaning of the Fountain, Writing Heads, Vacuum Channels - *Cont.*

7. When all components are clean, lightly wipe them with a dry wipe. Use a different one with the writing head to ensure that no alcohol gets into the printer.
8. Repeat this procedure (STEP C) for all four (or five) fountains, heads, and vacuum channels.

D. Re-Rinsing the Premix Plumbing and Fountain System:

1. Load the paper into the printer and attach it to the take-up roll. Turn the printer on (switch on right).
2. With the premix rinse bottles still in place, repeat STEPS B(3) and B(4) (see above).

E. Loading The Dye-Sublimation System into the Printer.

1. Wait a few minutes after STEP D for the rinse to fully recede into the bottles.
2. Load the four Dye-Sublimation premix and four Dye-Sublimation concentrate bottles into their respective areas. Standard 3M conventional color order should be used. From left to right this is: Black, Yellow, Cyan, and Magenta.
3. Wet down the fountains, plumbing, and vacuum channels with the new system by advancing the paper a few times (as per STEP B 3).
4. Introduce the new concentrate formulas into the plumbing. Remove the premix bottles and replace them with your collection pans. Click "add concentrate" as per STEPS A(4) and A(5) for as many strokes as it takes until you see the new concentrate dripping into the pan (replacing the clear).
5. Re-insert the dye-sublimation premix bottles.

You have now successfully installed Hilord Dye Sublimation Ink.

*If you **do** have access to the service switch on the left side of the printer (the white, round pull knob) perform steps A-E with the following in mind:*

- You can avoid wasting paper by using the service menu to activate the toner pumps and concentrate-add system whenever this procedure says to advance the paper (STEPS B(3),B(4),D(2), and E(3)).
- To take advantage of this feature pull the service switch on the left side of the printer. If you don't have access to it, do not take the printer apart to get to it.
- Go to the service tab on the printer controller.
- Click diagnostic test. You will have to put in a service password. If you have access to the service switch, you should know this password.
- Click on Toner Pumps and choose all colors. Start and stop for about 30 seconds at a time (instead of advancing paper). Give time in between cycles.

Hilord Chemical Corporation

70 Engineers Road
Hauppauge, New York 11788 USA
Telephone: 631-234-7373 1-800-645-1022
Fax: 631-234-4597
Email: info@hilord.com
Web Site: www.hilord.com

Hilord Europe:

Copira Aps
Telephone: ++45-49767676
Email: info@copira.dk

If you have any questions regarding this procedure, please contact Hilord Chemical at 631-234-7373 and request to speak to the Product Manager.