

XTOOL | Apparel Printer Plus

Quick Start Guide



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Meet your humidity module	03
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* The English version is the original instructions verified by the manufacturer.

List of items



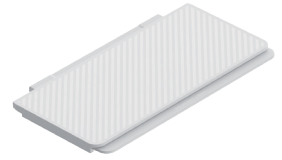
① xTool Apparel Printer Plus



② xTool Apparel Printer film holder and roll 25 m



③ ④ Bracket



⑤ Output tray



⑥ Ink



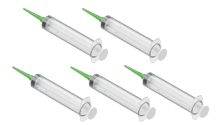
⑦ Moisturizing liquid



⑧ Power cable



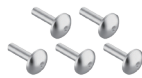
⑨ USB cable



⑩ Syringe



⑪ Screwdriver



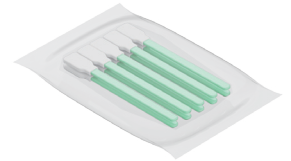
⑫ Screw M4*16
(A spare screw is provided.)



⑬ Cleaner



⑭ Dropper



⑮ Cleaning swab



⑯ Tube



⑰ Cleaning cloth



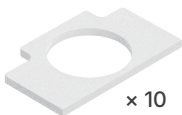
⑱ Lubricating oil



⑲ Plastic bag



⑳ xTool Internal Humidity Module for Apparel Printer



㉑ Ink stack foam



㉒ Quick start guide



㉓ Maintenance instructions



㉔ Safety instructions

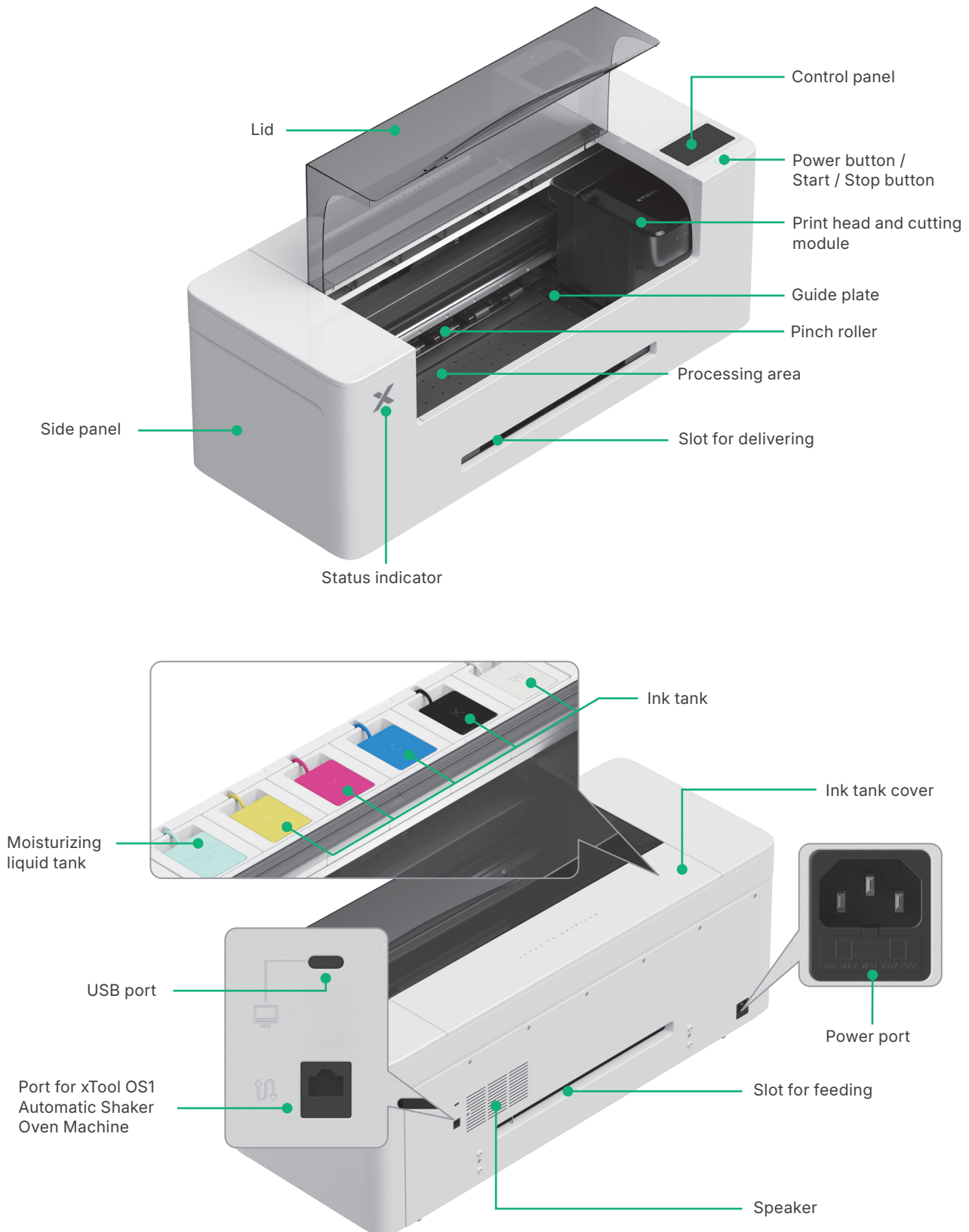


㉕ Essential guidelines

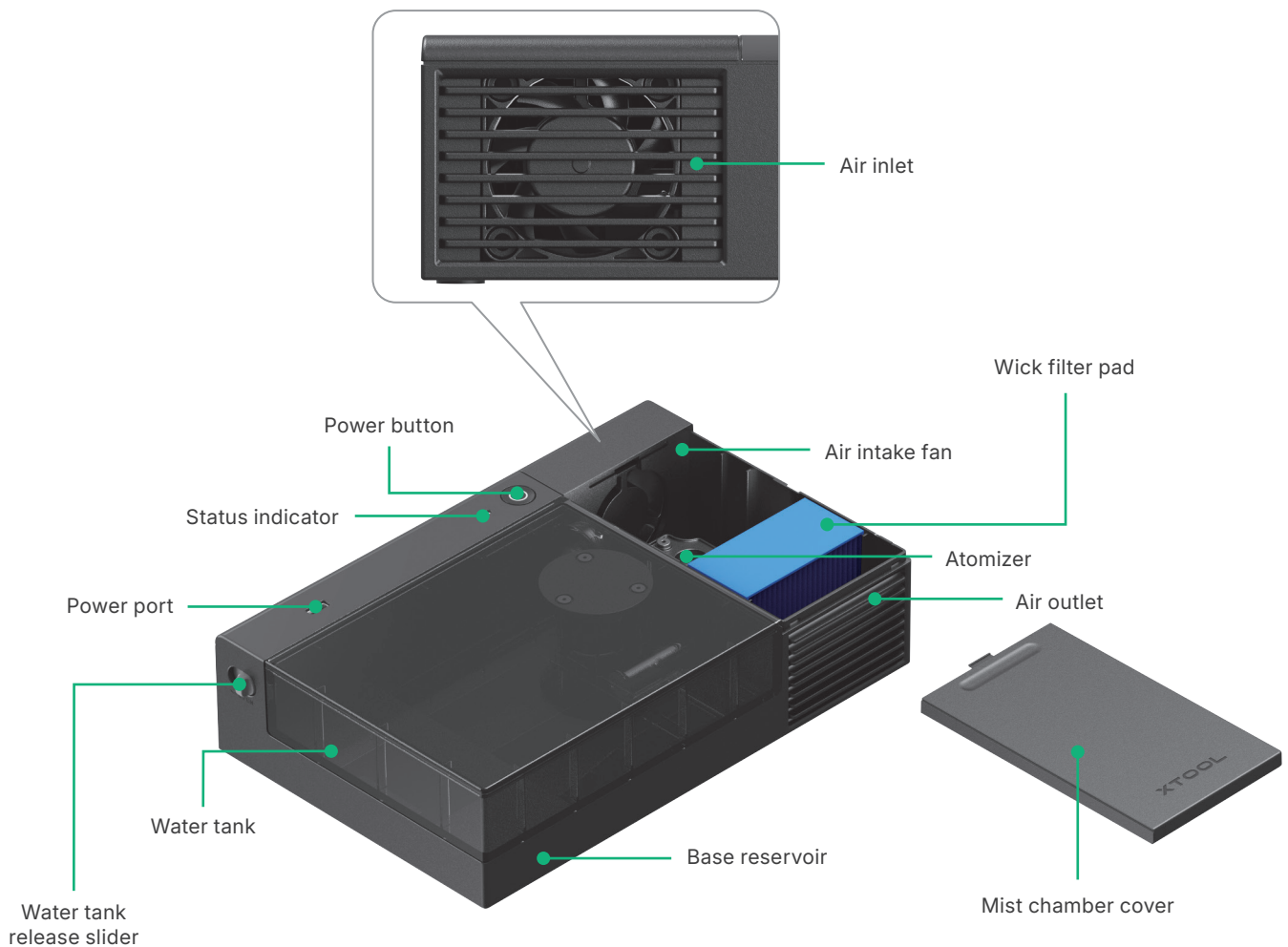


The power cable may vary according to kits. The illustration is for reference only.

Meet your xTool Apparel Printer Plus



Meet your humidity module



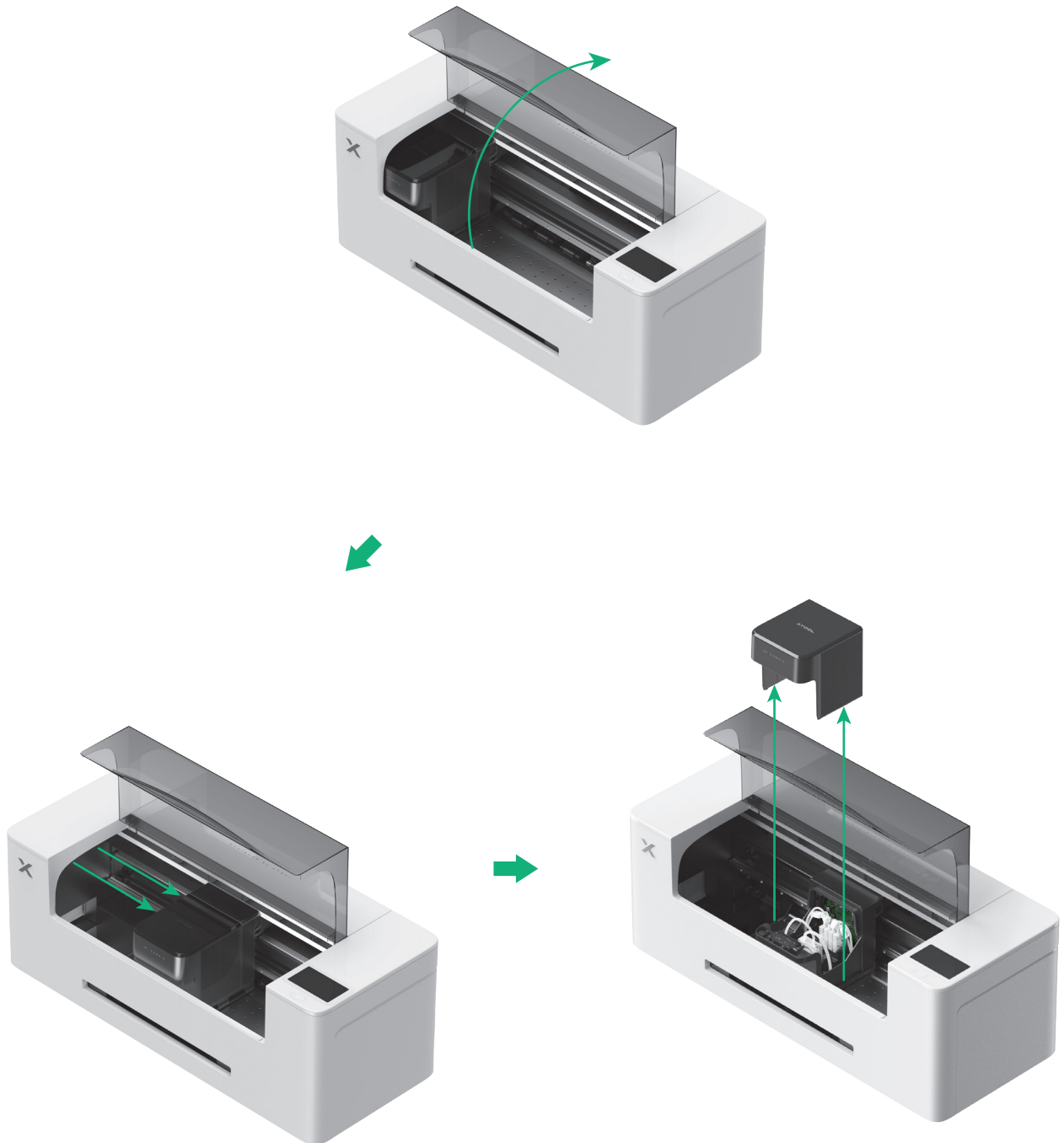
Recommended usage conditions:

- When ambient relative humidity is below 50%, it is recommended to turn on the module to significantly improve print quality.
- When ambient relative humidity is above 70%, it is strongly recommended to turn off the module to prevent excessive humidity from affecting print quality.

Preparations

1 Prepare the print head

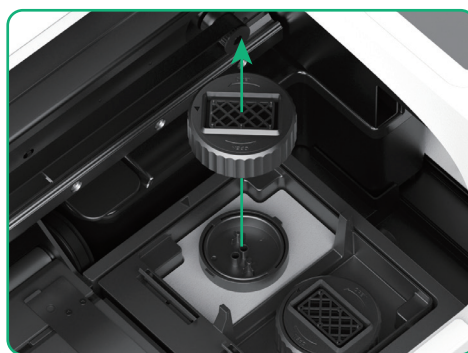
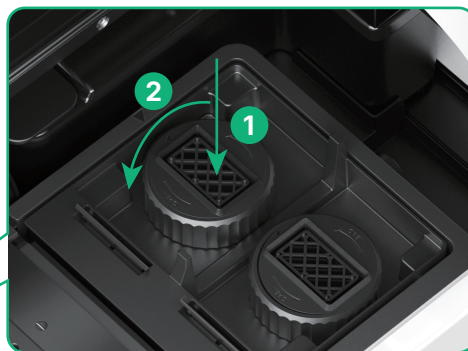
(1)



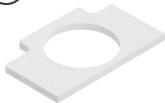
(2) Install the ink stack foam



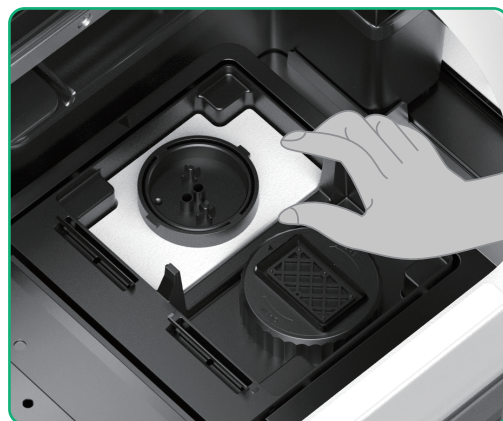
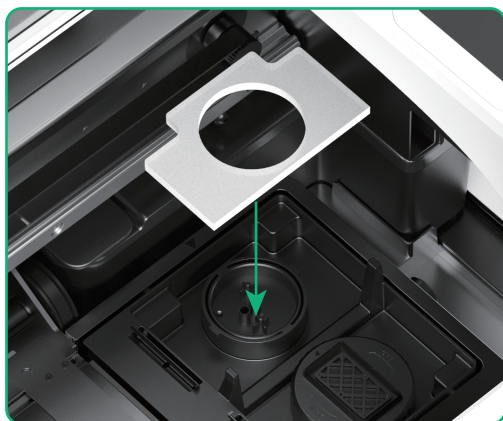
First, press down on the cover, then turn it counterclockwise 45° to open it.



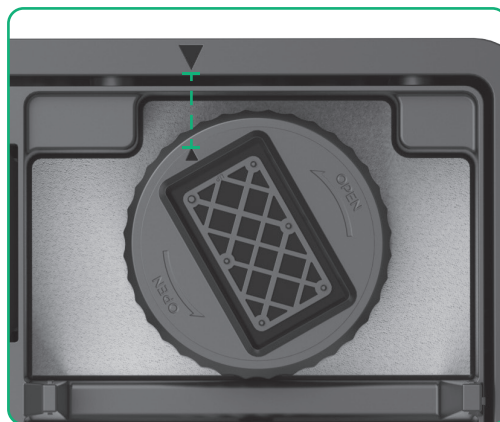
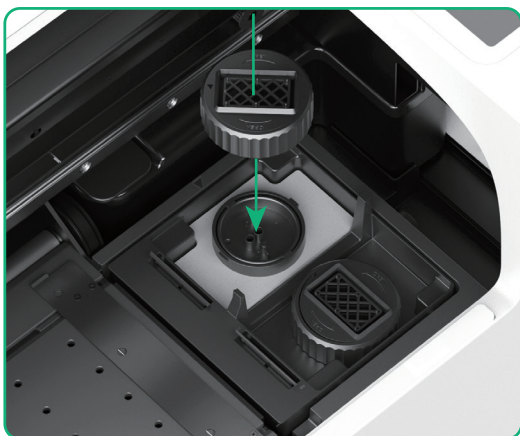
(21)



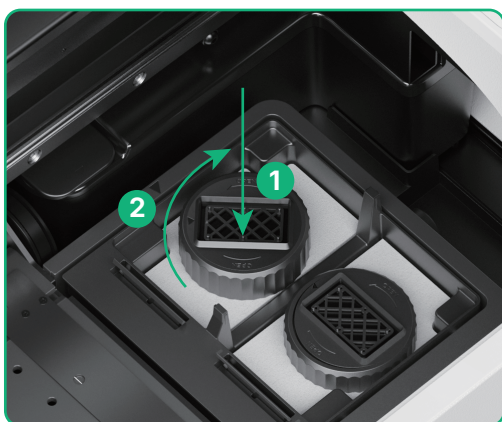
Gloves
(not included in the pack)



Place the foam and press it down with your hand so that it lies flat against the bottom (it is recommended to wear gloves for placing or removing the foam).



Install the ink pad and ensure that the two arrows are aligned



Press down on the cover and turn it clockwise 45° to lock it in place.

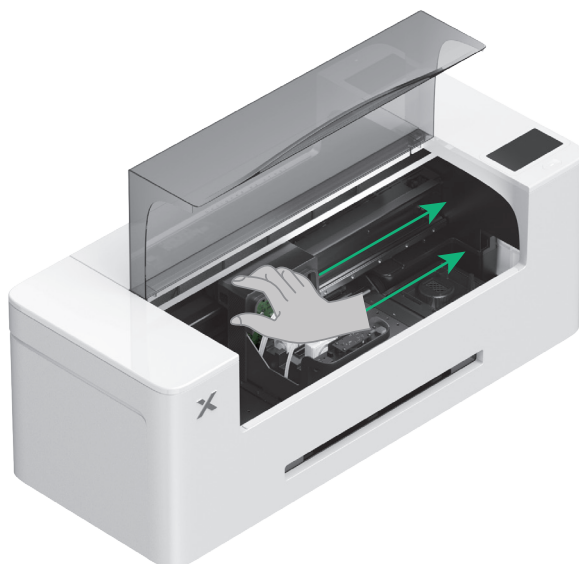


Do not install the ink pad upside down.

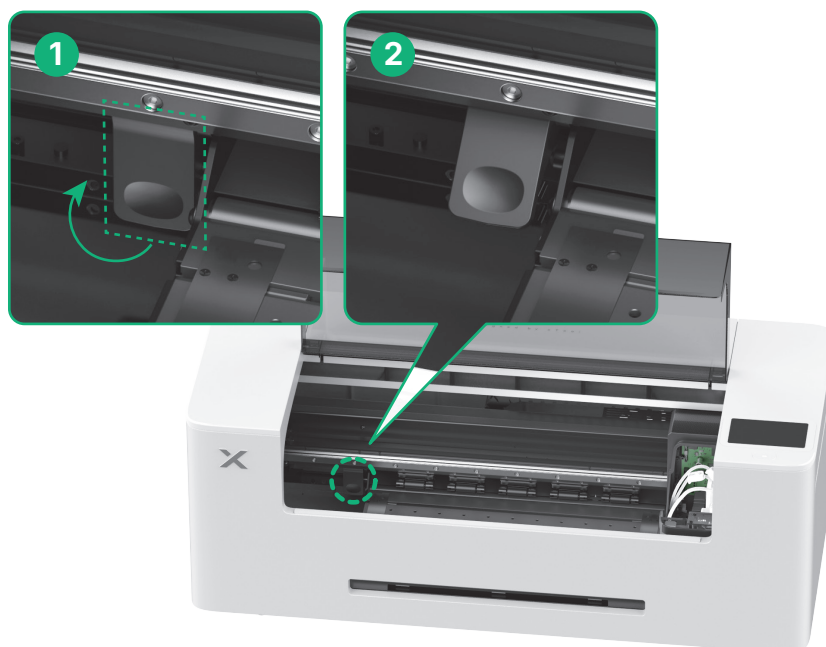


Install the other foam using the same way.

(3) Move the print head to the right

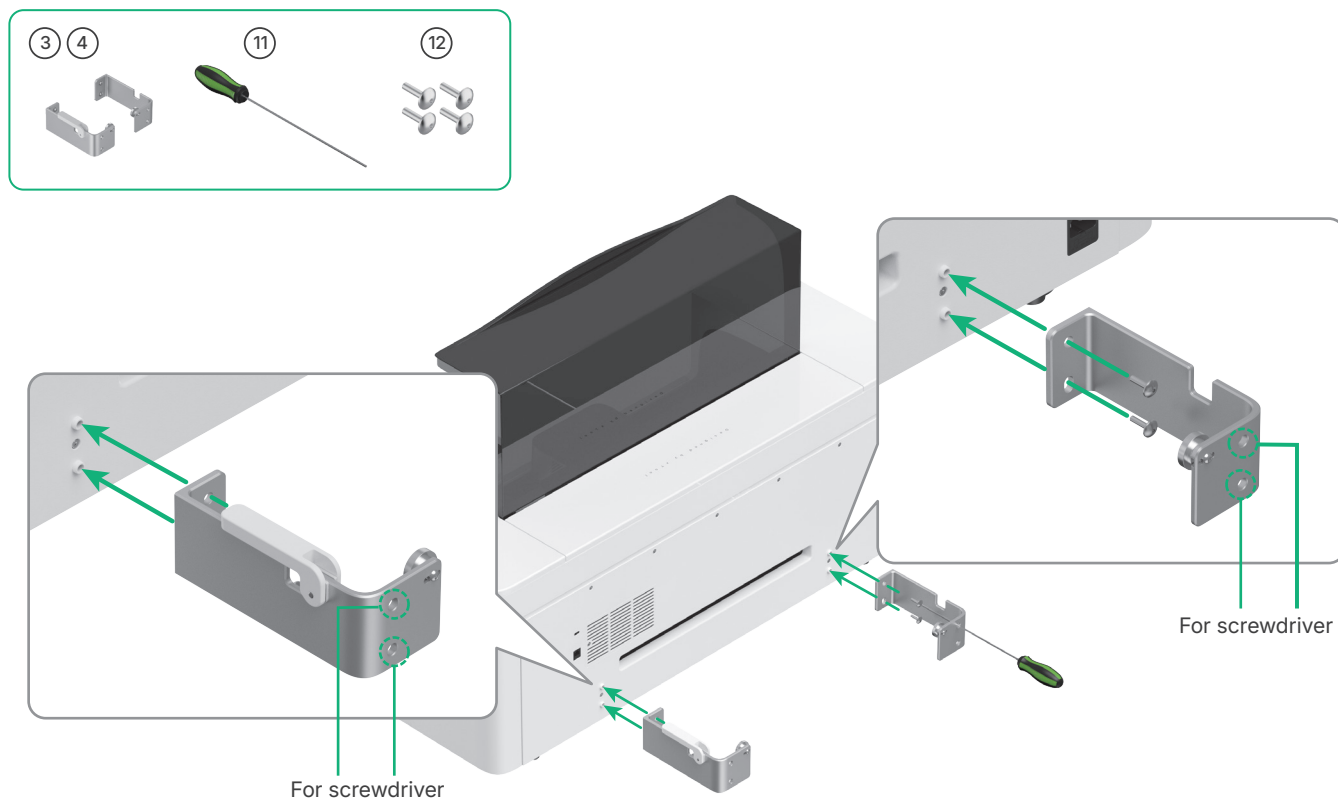


(4) Toggle up the pinch roller switch to open the pinch roller

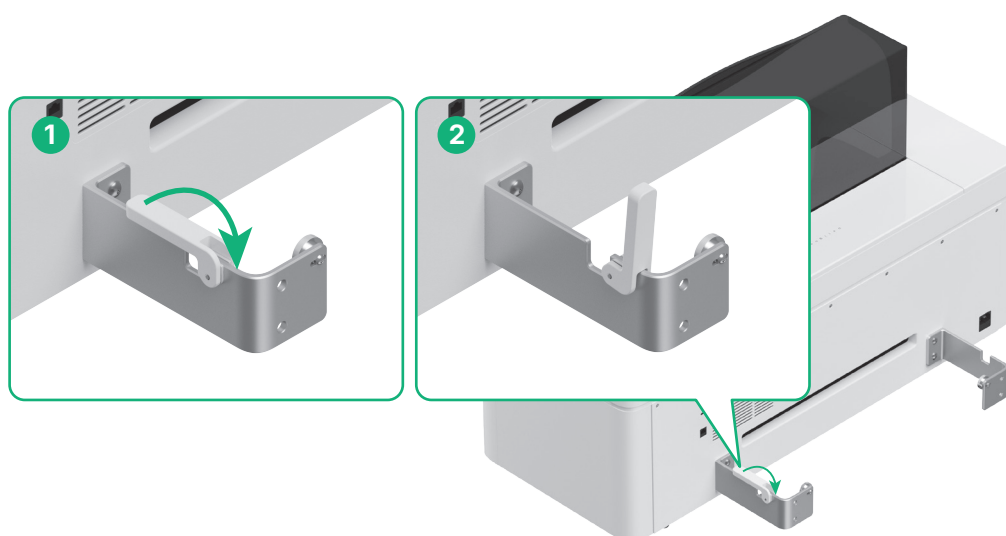


2 Install the bracket and xTool Apparel Printer film roll

(1)



(2)



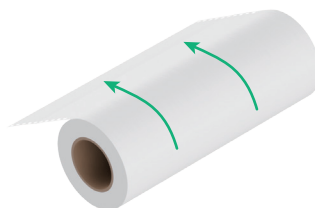
②



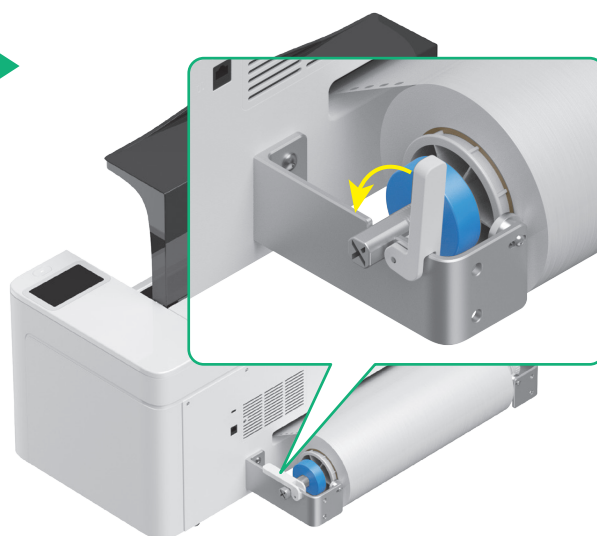
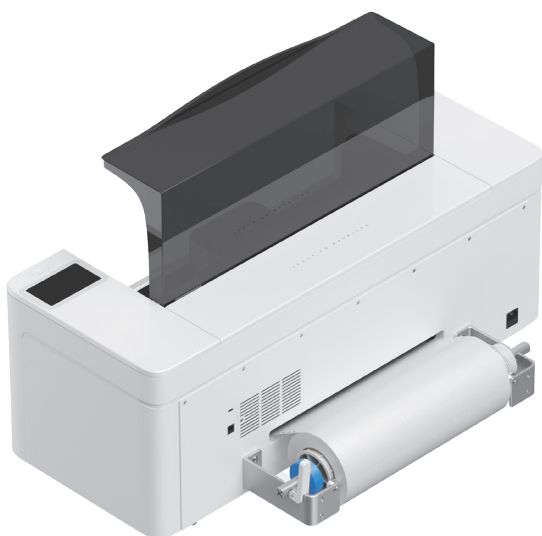
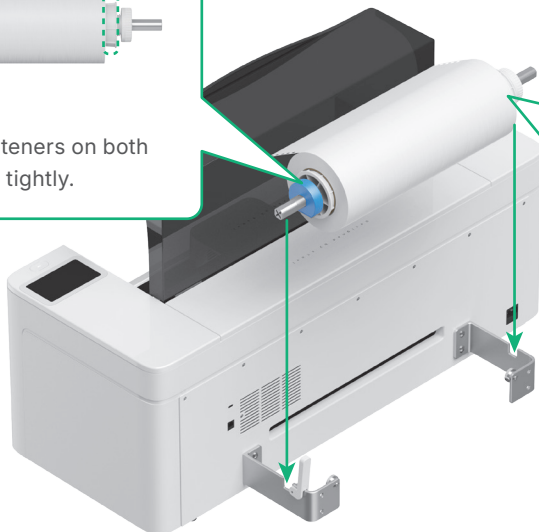
Mind your hands when placing the holder.



Make sure the fasteners on both sides are secured tightly.



Pay attention to the direction of the roll.

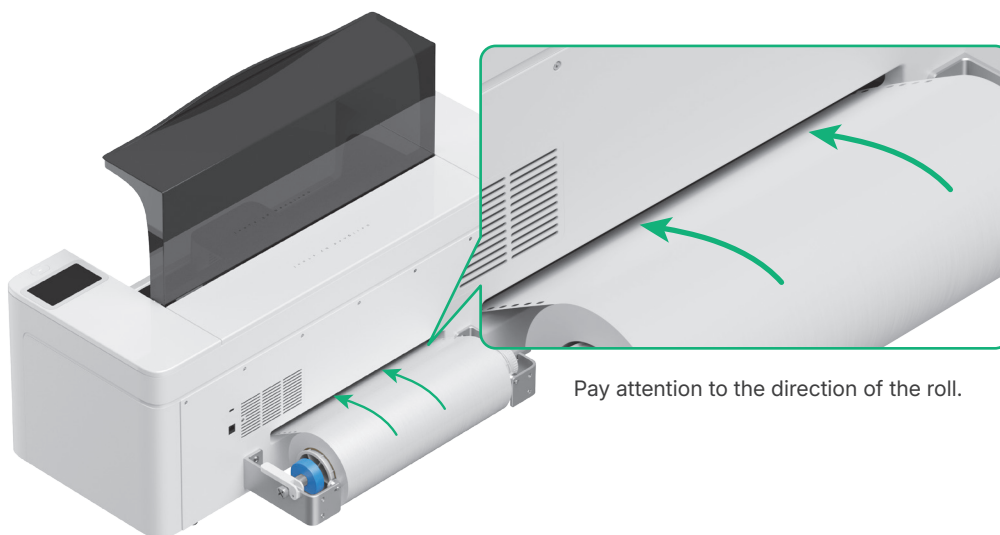


3 Feed xTool Apparel Printer film into the printer



Make sure the sticker on the roll is removed before feeding the film.

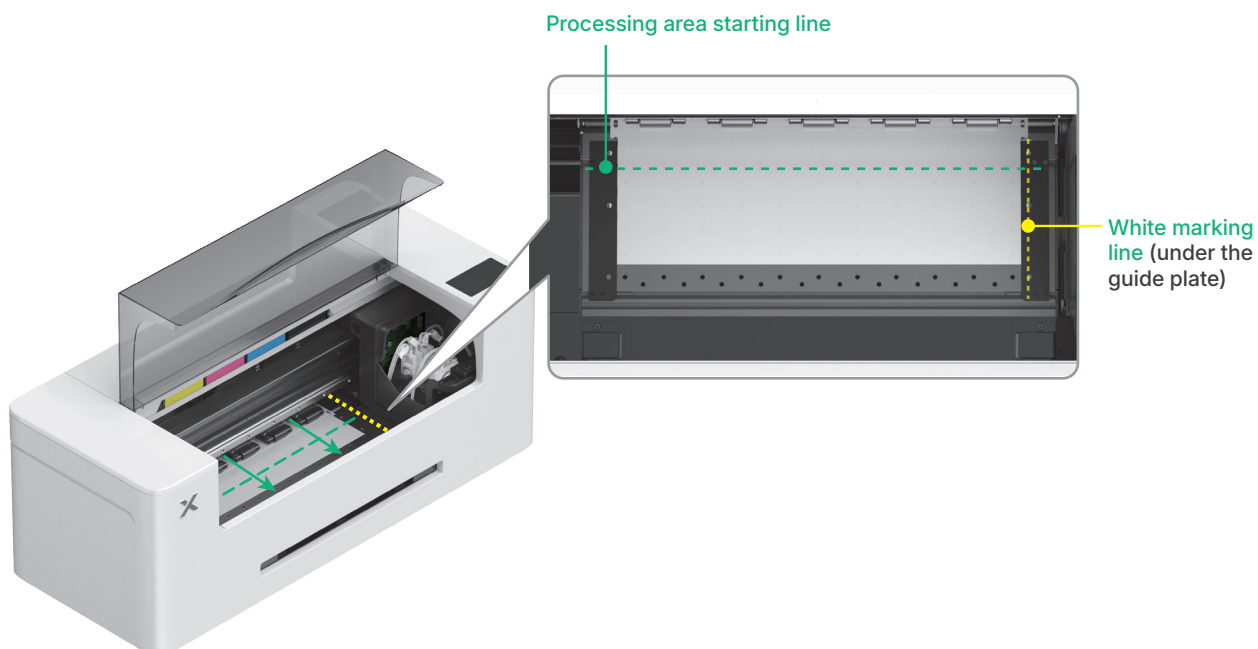
Feed the film into the printer through the feeding slot



Pay attention to the direction of the roll.



Ensure that the film covers the starting position of the processing area, and aligns with the **white marking line** on the right.



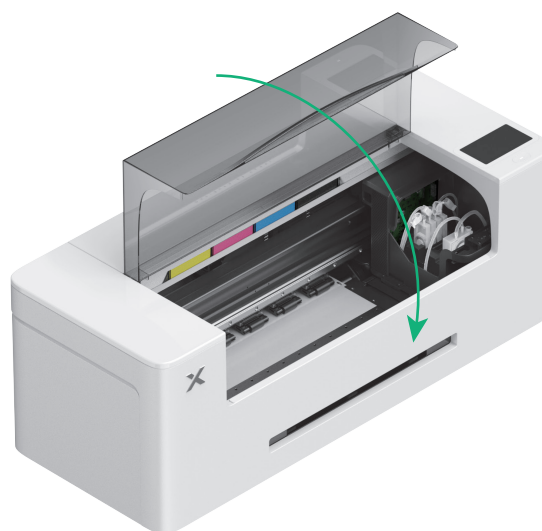
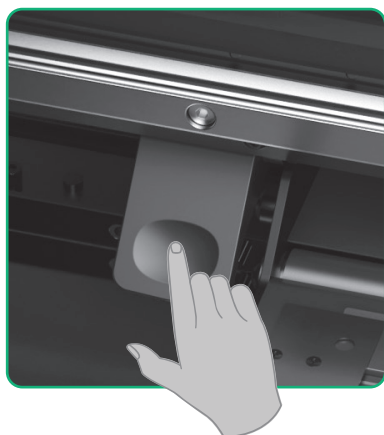
Move the guide plates on both sides to cover the film



Move the edges on both sides of the film to the middle of the guide plate holes. Note that the distance between the guide plate and the film should not be too close or too far. Otherwise, it may cause problems such as film bulging.



Toggle down the pinch roller switch



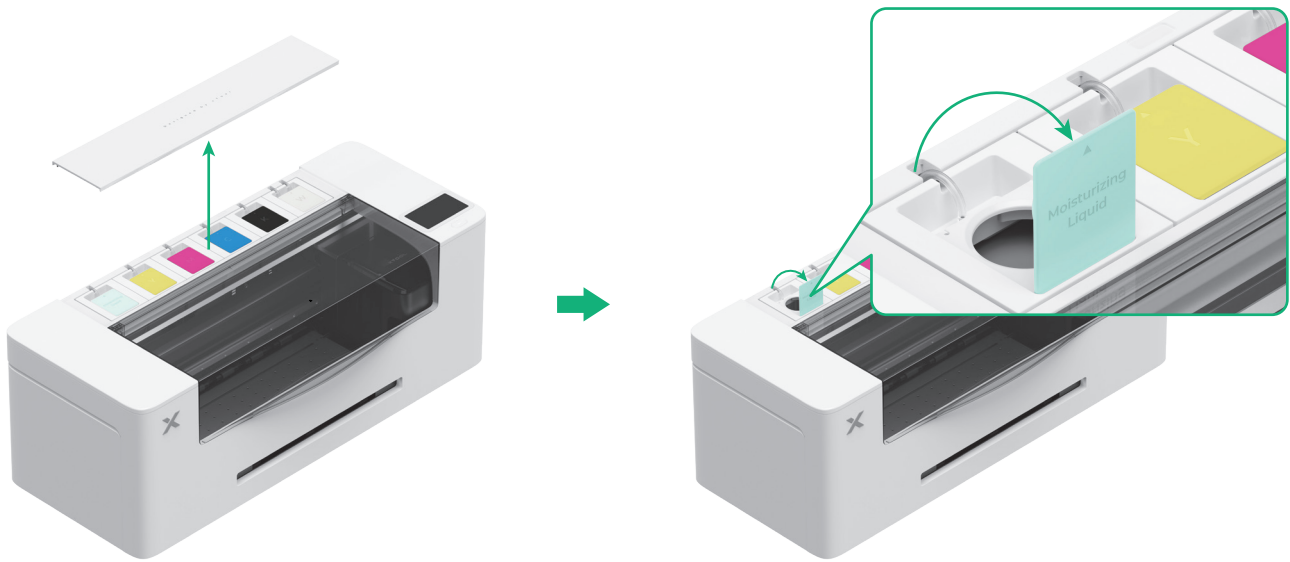
4 Fill in moisturizing liquid and ink

(1) Fill moisturizing liquid into the moisturizing liquid tank

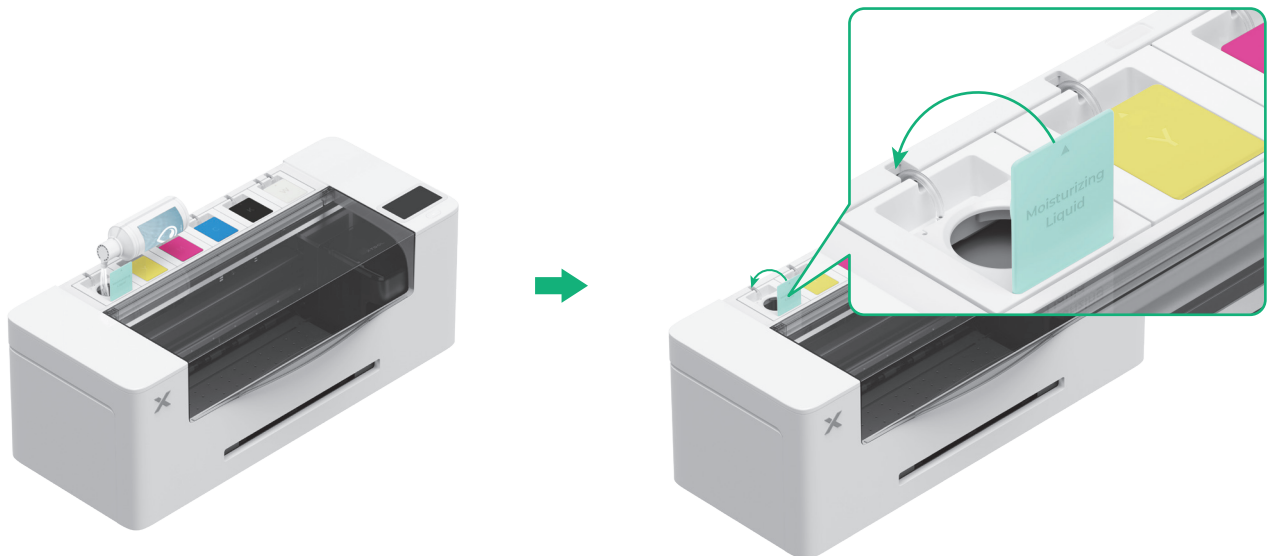


Remove the sealing film before using the moisturizing liquid.





- Fill the moisturizing liquid tank with moisturizing liquid. Be careful not to overfill the moisturizing liquid tank (maximum capacity: 1000 ml).
- Please reserve a proper amount of moisturizing liquid for regular maintenance.



(2) Fill ink into the ink tank



It is advised to exercise caution to prevent stains on clothing when you fill ink. Otherwise, it may leave marks that are difficult to clean.

⑥



Y – Yellow
M – Magenta
C – Cyan
K – Black
W – White



Shake well before adding the **white ink**.



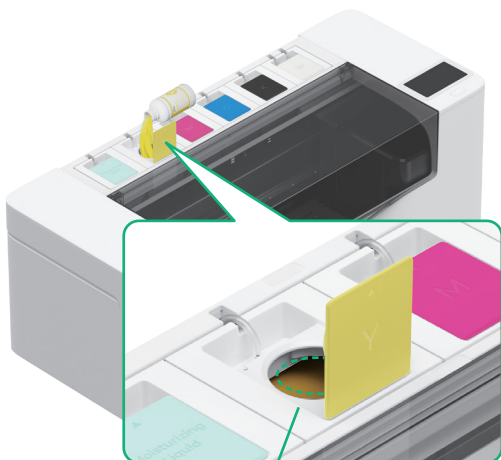
After adding ink, be careful when you open the ink tanks again as ink may splash into the inside of the device.



Fill ink of the matching color to the ink tanks.



Color ink tank: 500 ml
White ink tank: 1000 ml



Note: Do not fill the ink beyond the rim of the ink tank.



Repeat the steps above to fill the other four ink colors.

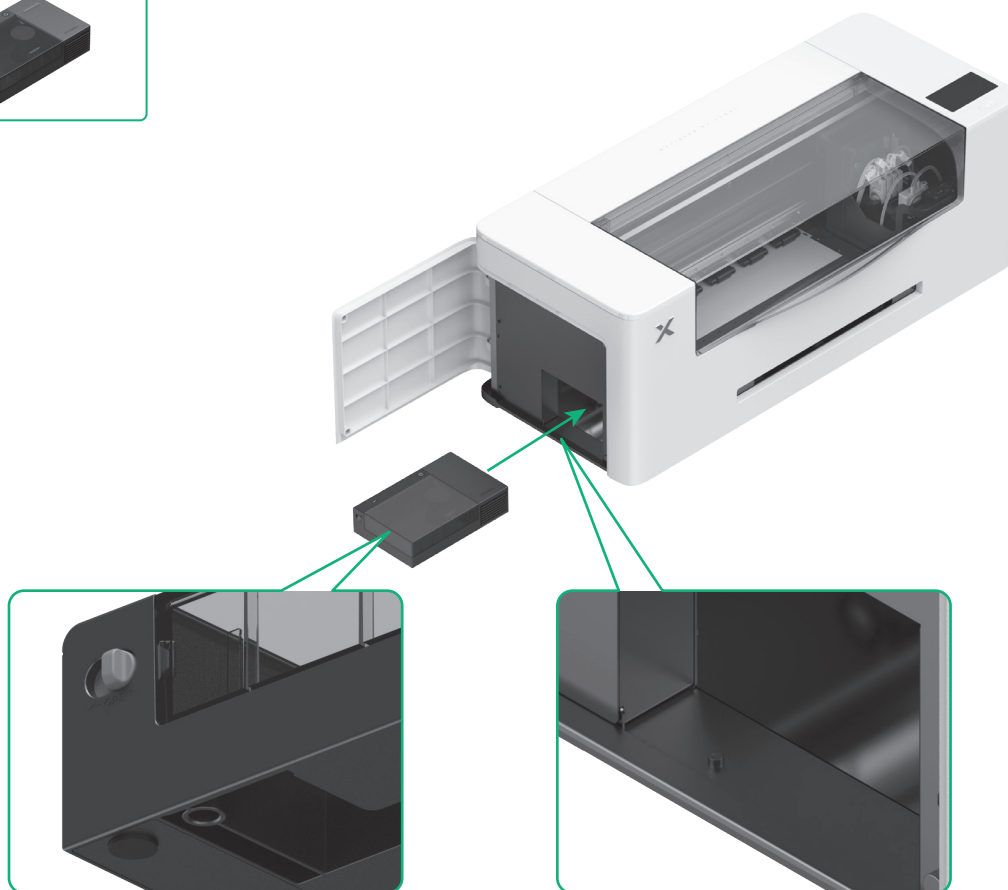


5 Install the humidity module

(1) Open the left-side panel of the printer.



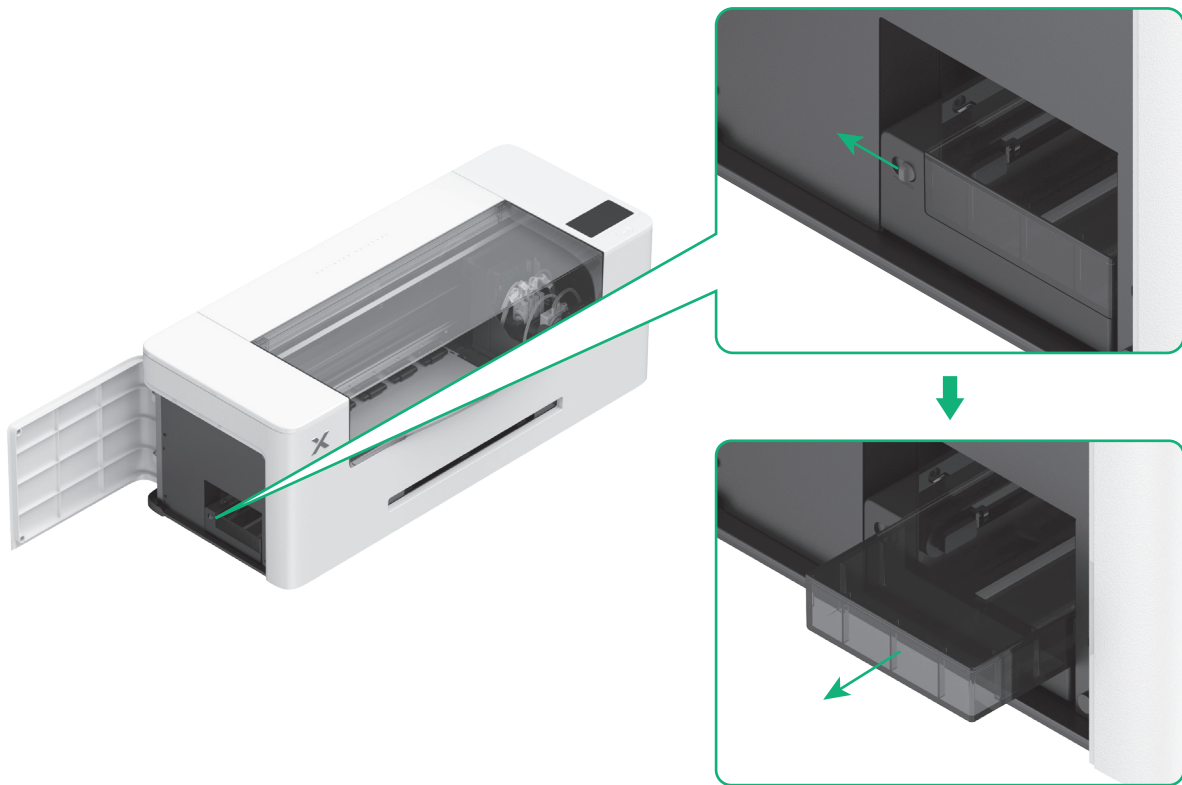
(2) Insert the humidity module horizontally into the printer, ensuring that the air outlet and air inlet of the module face the inside of the printer. Push it inward until the humidity module fits snugly against the inside of the printer and cannot be pushed any further.



Ensure that the recessed hole at the bottom left corner of the humidity module aligns with the protruding screw on the left side of the printer's installation area, and snaps securely onto the screw.

6 Prepare and fill the water tank

(1) Toggle the water tank release slider to the left, and the water tank will pop out automatically.

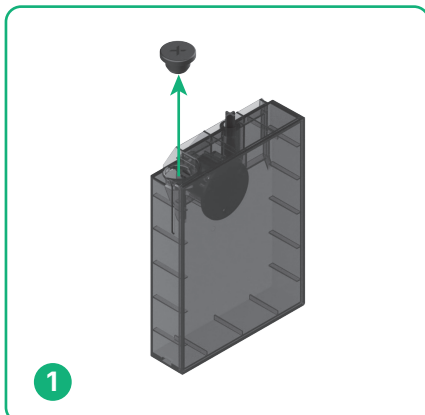


(2) Unplug the silicone plug on the side of the water tank and fill the tank with water. Once filled, insert the silicone plug back tightly.

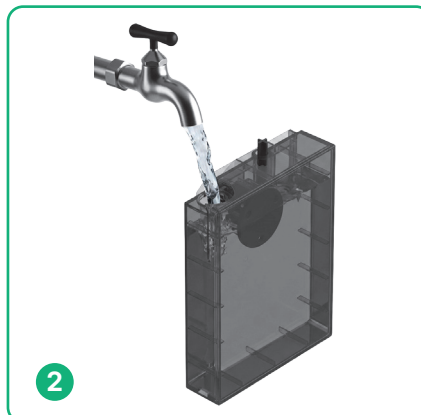


Always use clean tap water

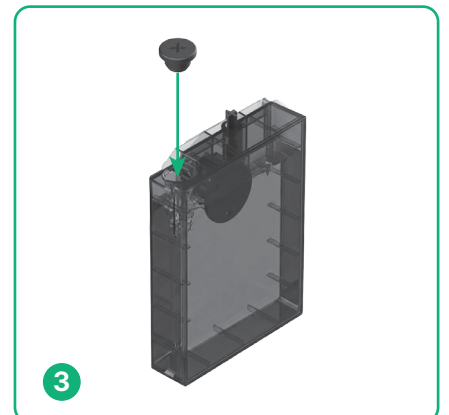
- If local tap water tends to produce white scale deposits, it is recommended to use treated or softened water.
- Do not use purified water or distilled water, as this may affect the humidity module's mist output.
- Water with high levels of impurities or scale can clog the atomizer components and reduce humidification performance.



1



2



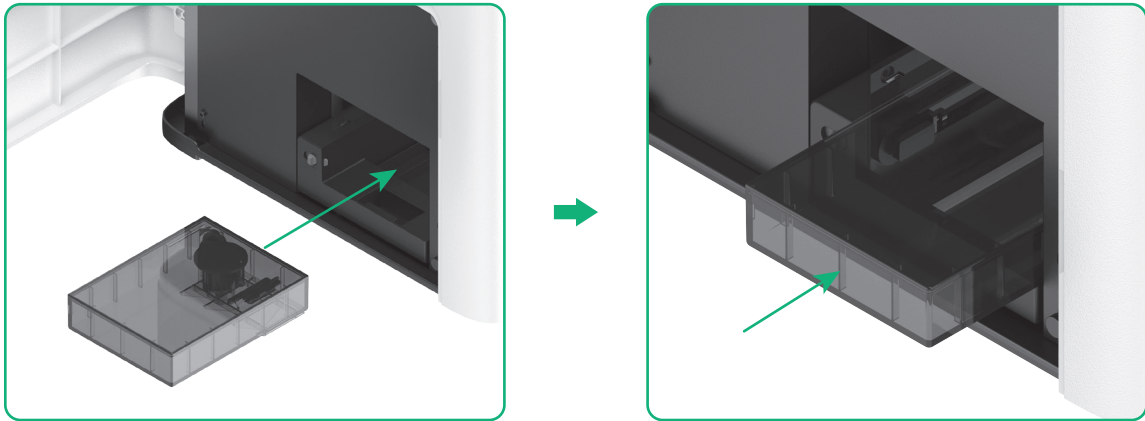
3

(3) Insert the water tank horizontally and push it into the humidity module slowly and steadily to prevent liquid from splashing out. A "click" sound indicates that it is installed in place.



■ Do not tilt the water tank during insertion or when pushing it in to prevent liquid spills that may cause electric shock or device short circuits.

■ If any water droplets are present on the tank surface, wipe them dry before installation.

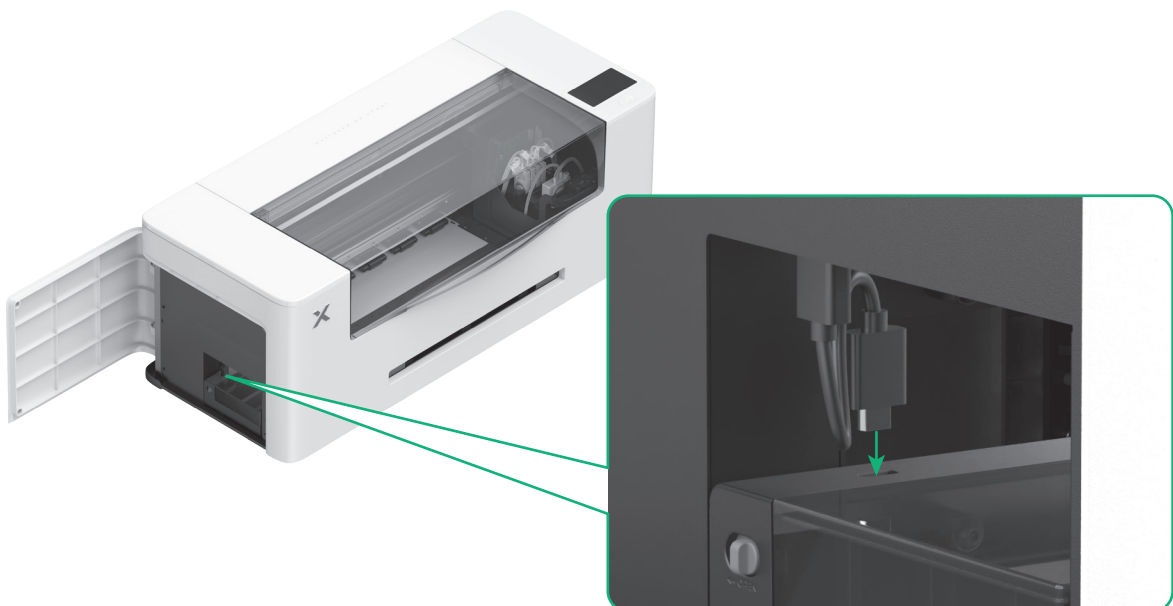


Daily water refilling:

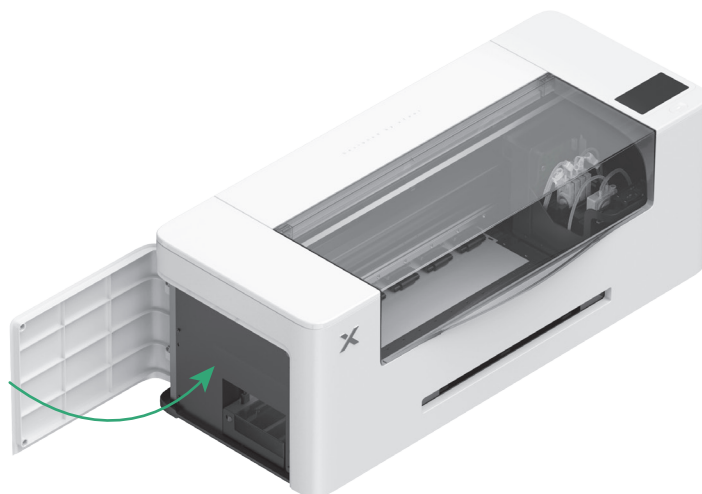
■ During normal use, it is not necessary to remove the entire module. Simply remove and refill the water tank.

7 Connect the humidity module and the printer

(1) Connect the other end of the connection cable to the port of the humidity module.

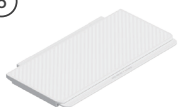


(2) Close the left-side panel of the printer.

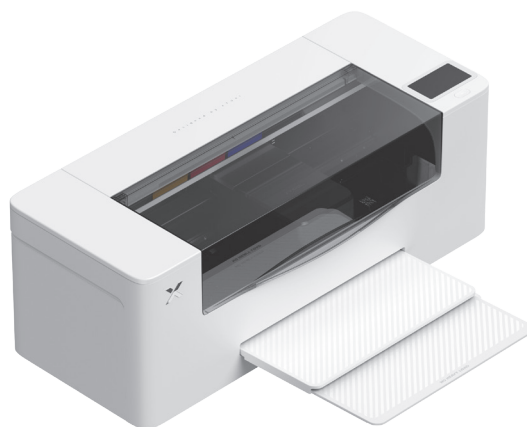
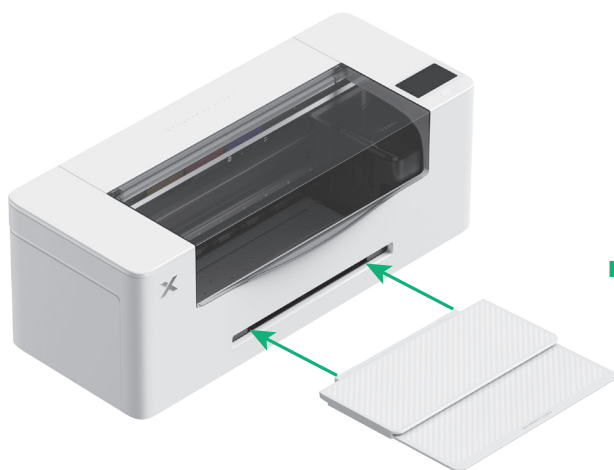


8 Install the output tray

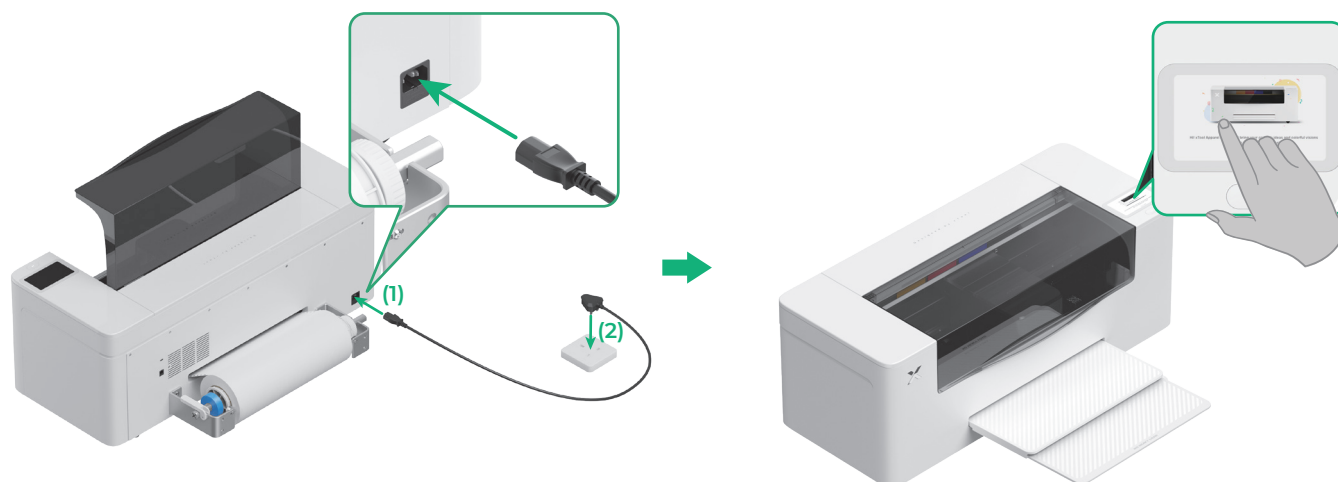
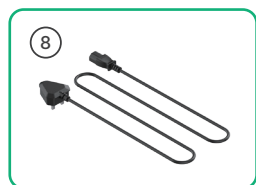
5



When you use the printer, it is not necessary to open the two stands under the output tray.



9 Connect to a power supply and follow the setup



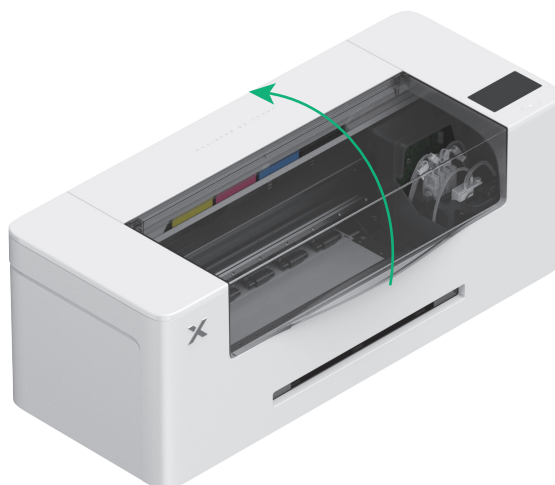
To ensure proper running and maintenance of the device, please keep it connected to a power supply.



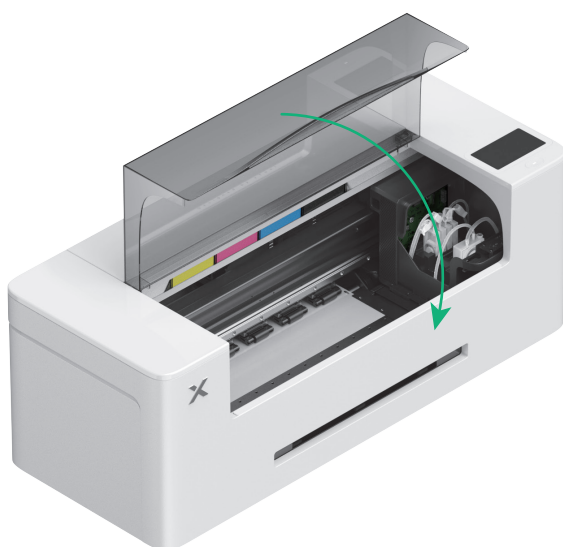
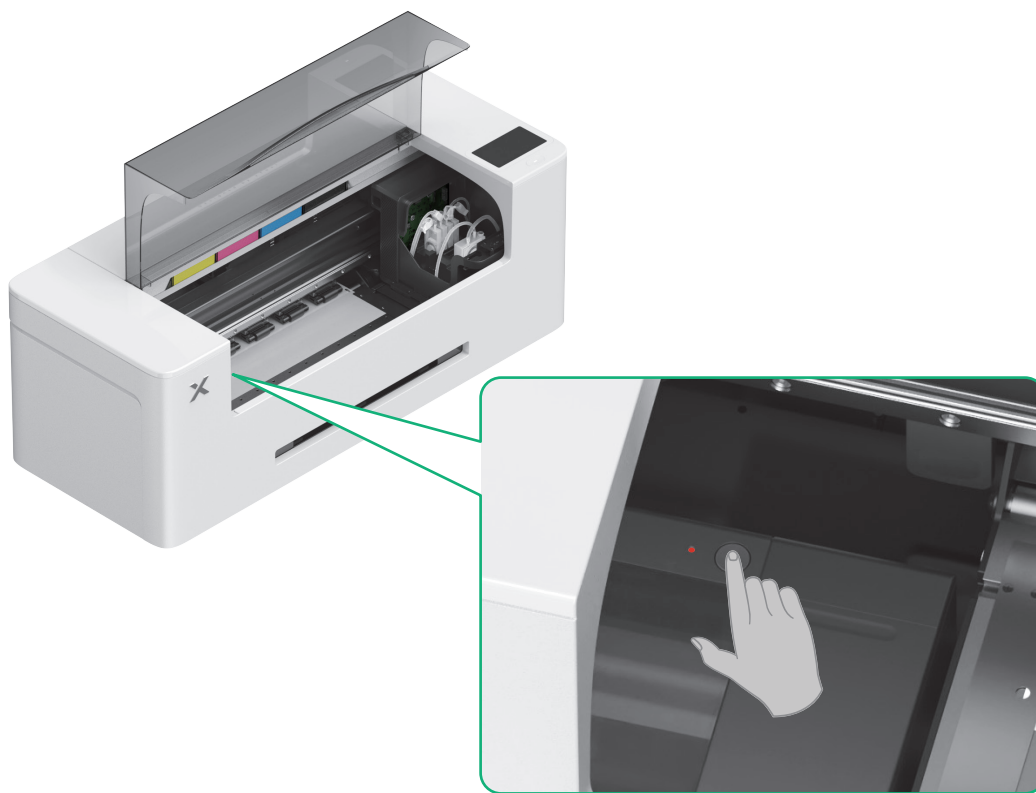
Complete the beginner's guide in the printer before connecting the printer to a computer and using the software.

10 Power on the humidity module

(1)



(2) Press the power button of the humidity module to turn it on.



Pressing the power button again during operation will pause the humidification.

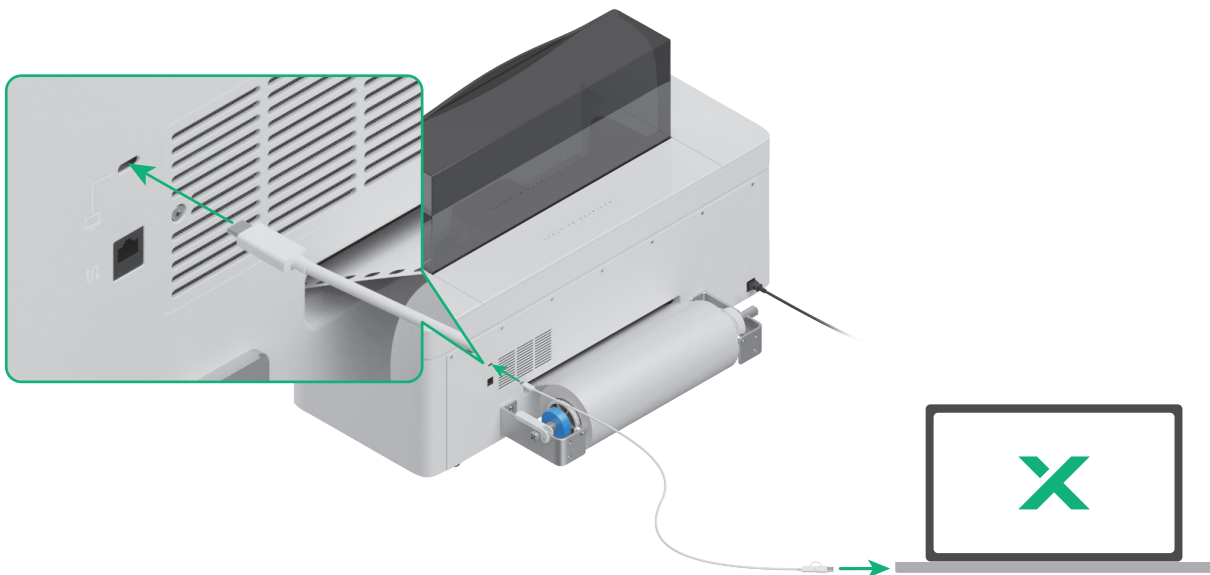
Use xTool Apparel Printer Plus

1 Get the xTool software



Go to s.xtool.com/software to get the xTool software.

2 Connect xTool Apparel Printer Plus to your computer



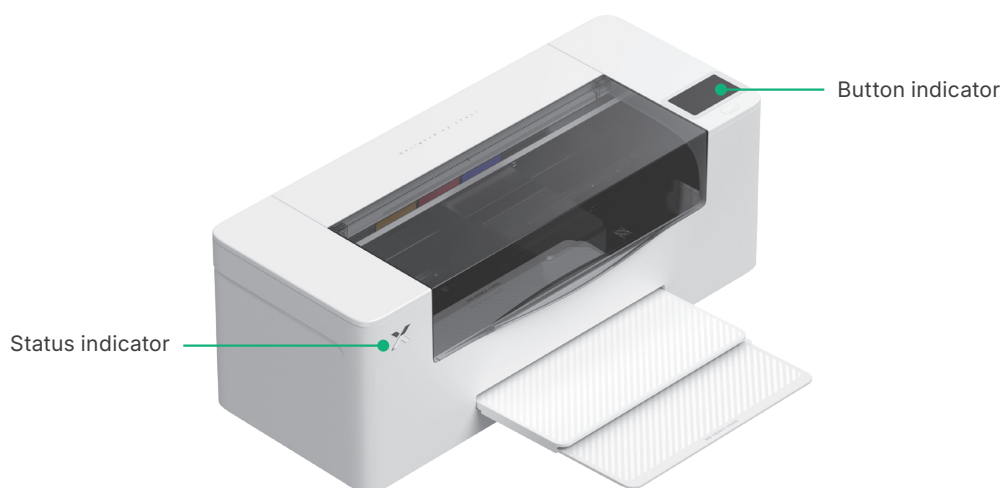
For details about how to process materials using xTool Apparel Printer Plus and the software, scan the QR code or visit support.xtool.com/article/3295.



Indicator description

Apparel Printer Plus indicator

Button indicator	Status indicator	Speaker	Device status
Solid white	Solid white	/	Idle
Going off	Going off	/	Standby
Solid white	Solid green	/	Printing
Solid white	Solid green	Sounding once	Printing paused
Solid white	Blinking purple slowly	Sounding once	Firmware update
Solid white	Blinking purple slowly	Sounding once	Calibrate the print head
Solid white	Blinking purple slowly	Sounding once	Clean the print head
Solid white	Blinking red rapidly	Sounding once	Exception occurs



Humidity module indicator

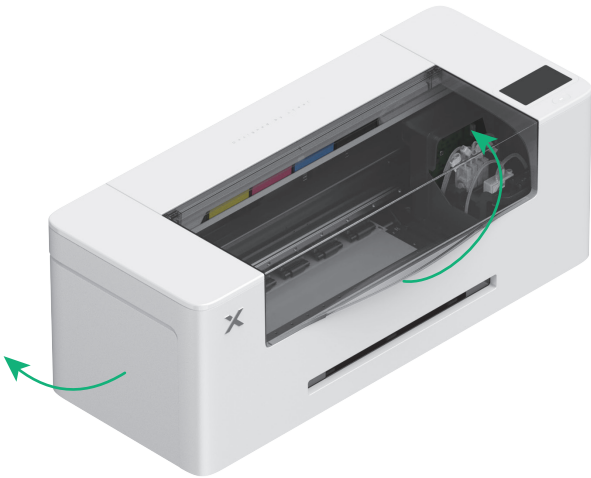
Status indicator	Device status description
Solid	Device is operating normally.
Blinking	Water tank is empty.
Off	Device is powered off or unplugged.

FAQs

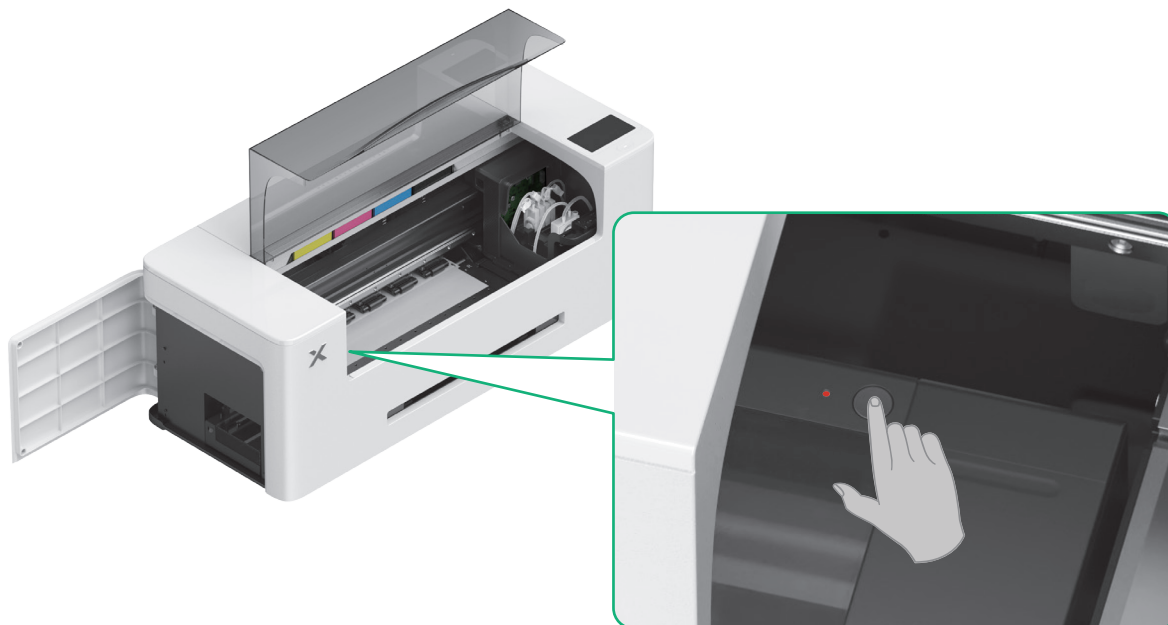
How to remove the humidity module?

- During normal use, do not frequently remove the entire humidity module to avoid spilling liquid from the water tank or base reservoir.
- Only when performing maintenance on the printer or the humidity module, follow the steps below to remove the entire humidity module.

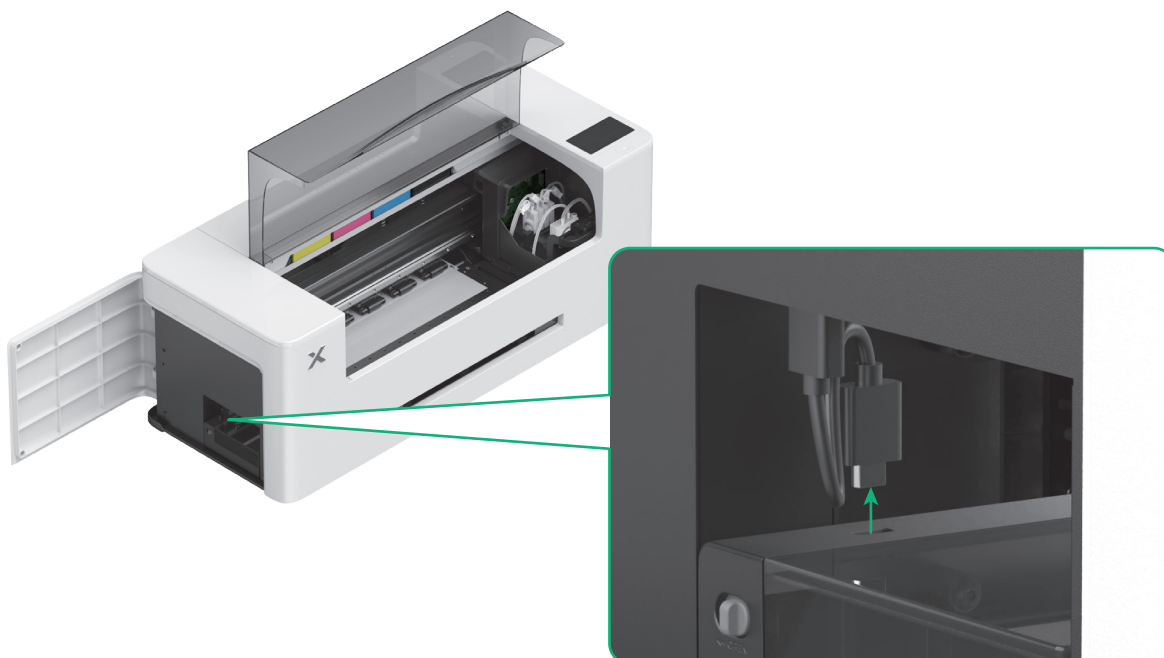
(1) Open the left-side panel and lid of the printer.



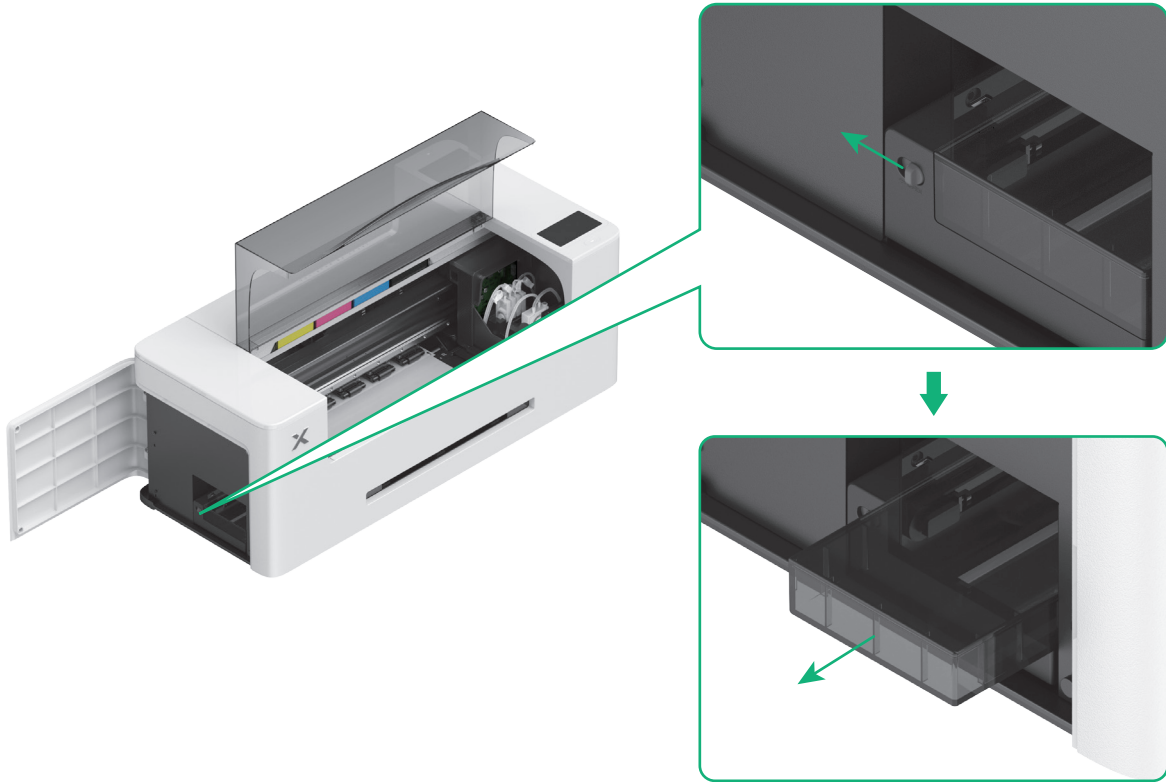
(2) Press the power button to turn off the module.



(3) Unplug the connection cable of the humidity module.



(4) Toggle the water tank release slider to the left to pop out the water tank. Remove the water tank slowly and horizontally to prevent liquid from splashing out.



(5) Use the grip slot on the base reservoir to smoothly pull the humidity module out horizontally.



XTOOL