



Apparel Printer Plus Versatile Bundle



Quick Start Guide

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* The English version is the original instructions verified by the manufacturer.

List of items

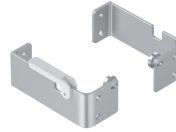
xTool Apparel Printer Plus



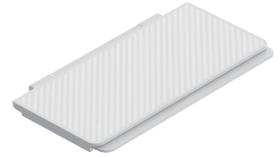
① xTool Apparel Printer Plus



② xTool Apparel Printer film holder and roll 25 m



③ ④ Bracket



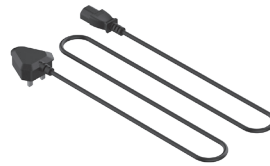
⑤ Output tray



⑥ Ink



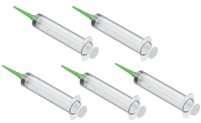
⑦ Moisturizing liquid



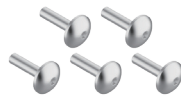
⑧ Power cable



⑨ USB cable



⑩ Syringe



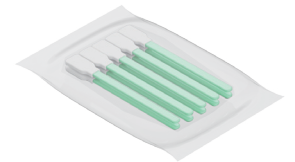
⑪ Screw M4*16
(A spare screw is provided.)



⑫ Cleaner



⑬ Dropper



⑭ Cleaning swab



⑮ Tube



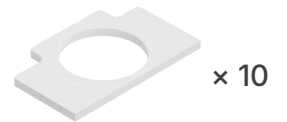
⑯ Cleaning cloth



⑰ Lubricating oil



⑱ xTool Apparel Printer Humidity Module



⑲ Ink stack foam × 10



⑳ Plastic bag



㉑ Quick start guide



㉒ Maintenance instructions



㉓ Safety instructions

xTool OS1 Automatic Shaker Oven Machine



②④ xTool OS1 Automatic Shaker Oven Machine



②⑤ Smoke exhaust pipe



②⑥ Power cable



②⑦ Data cable



②⑧ xTool Selected Apparel Printer Powder



②⑨ Screw M5*50



③⑩ Double-end screwdriver



③⑪ Spanner



③⑫ Cleaning brush



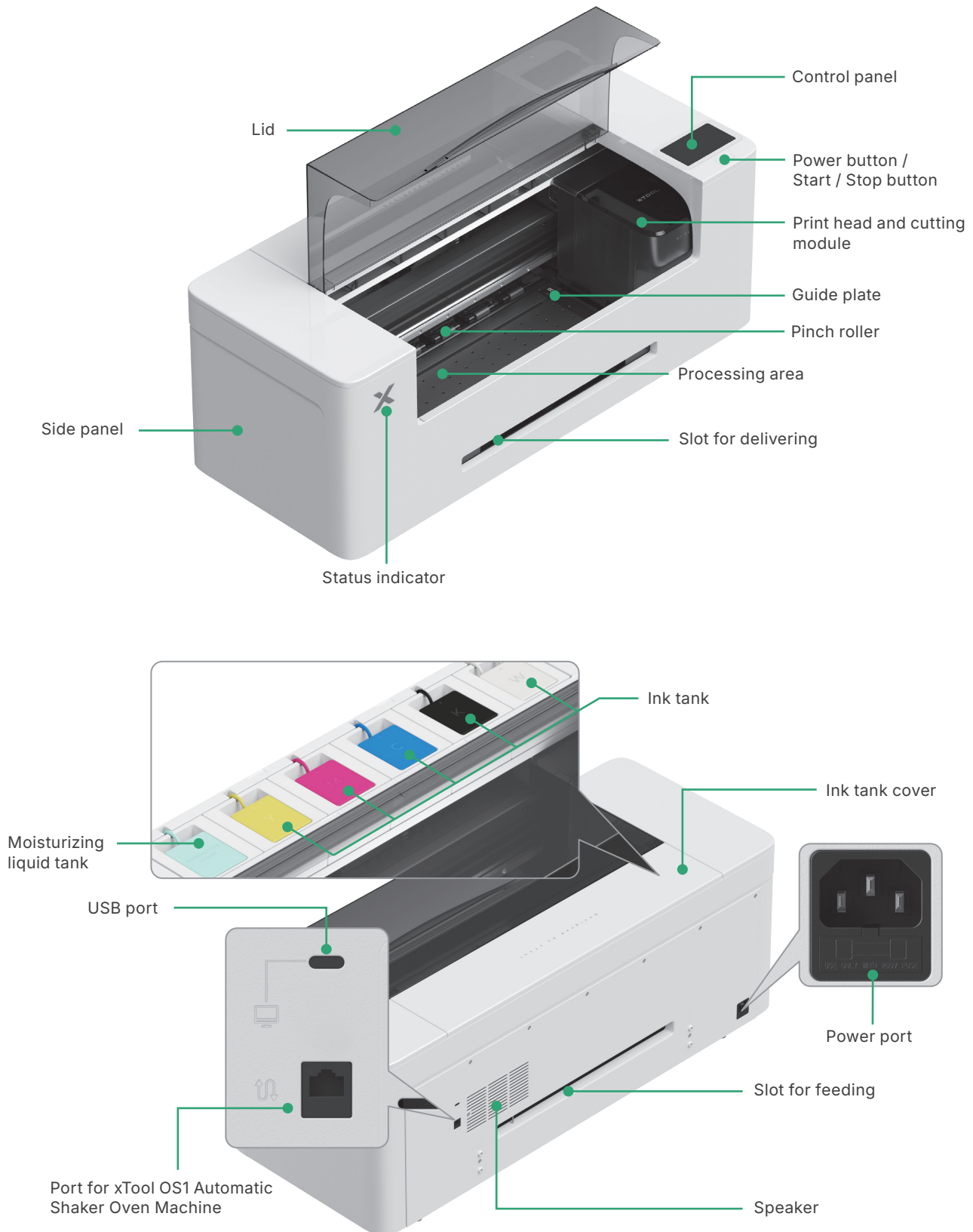
③⑬ Safety instructions



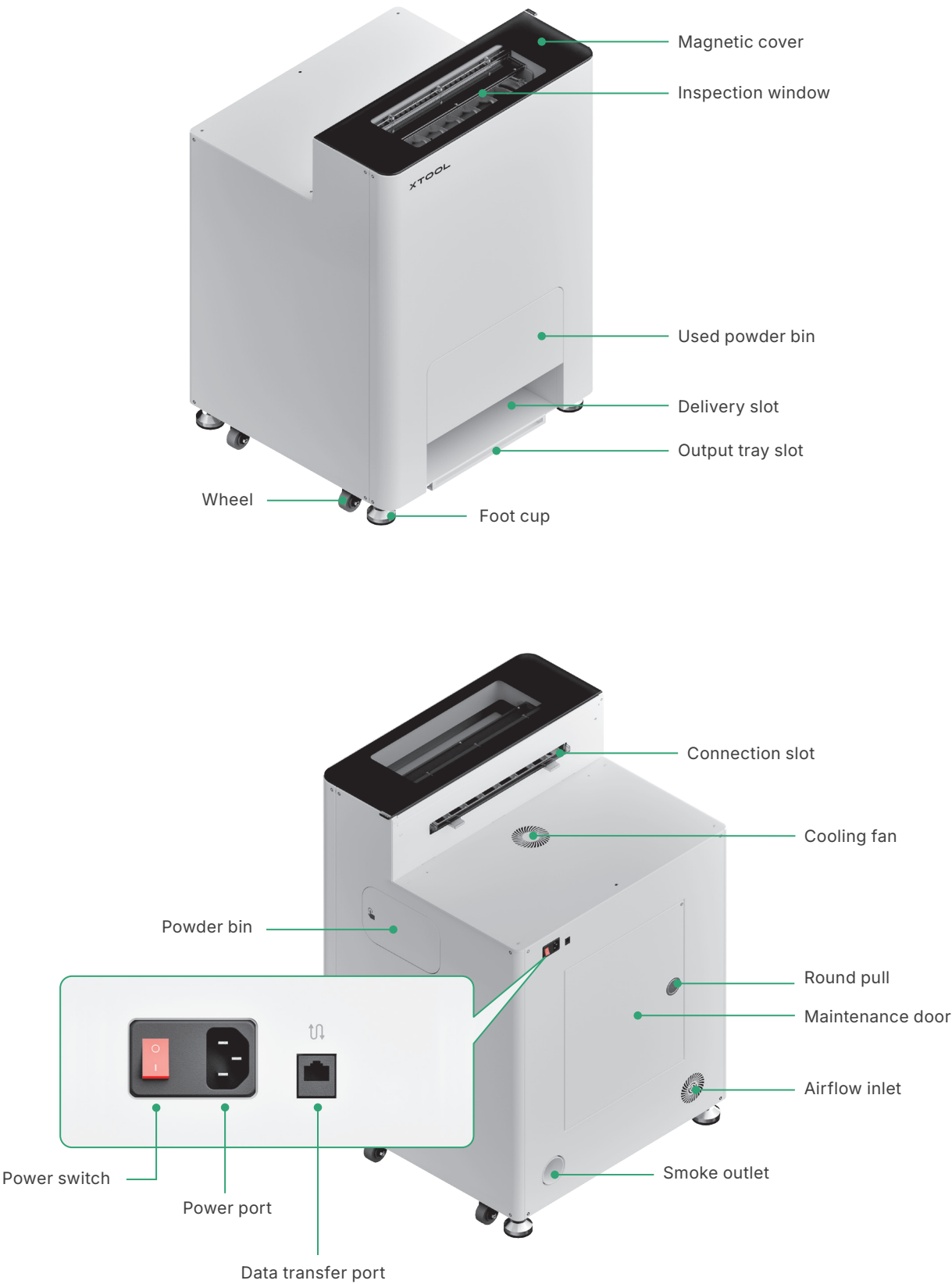
The power cable may vary according to kits. The illustration is for reference only.

Meet your xTool Apparel Printer Plus Versatile Bundle

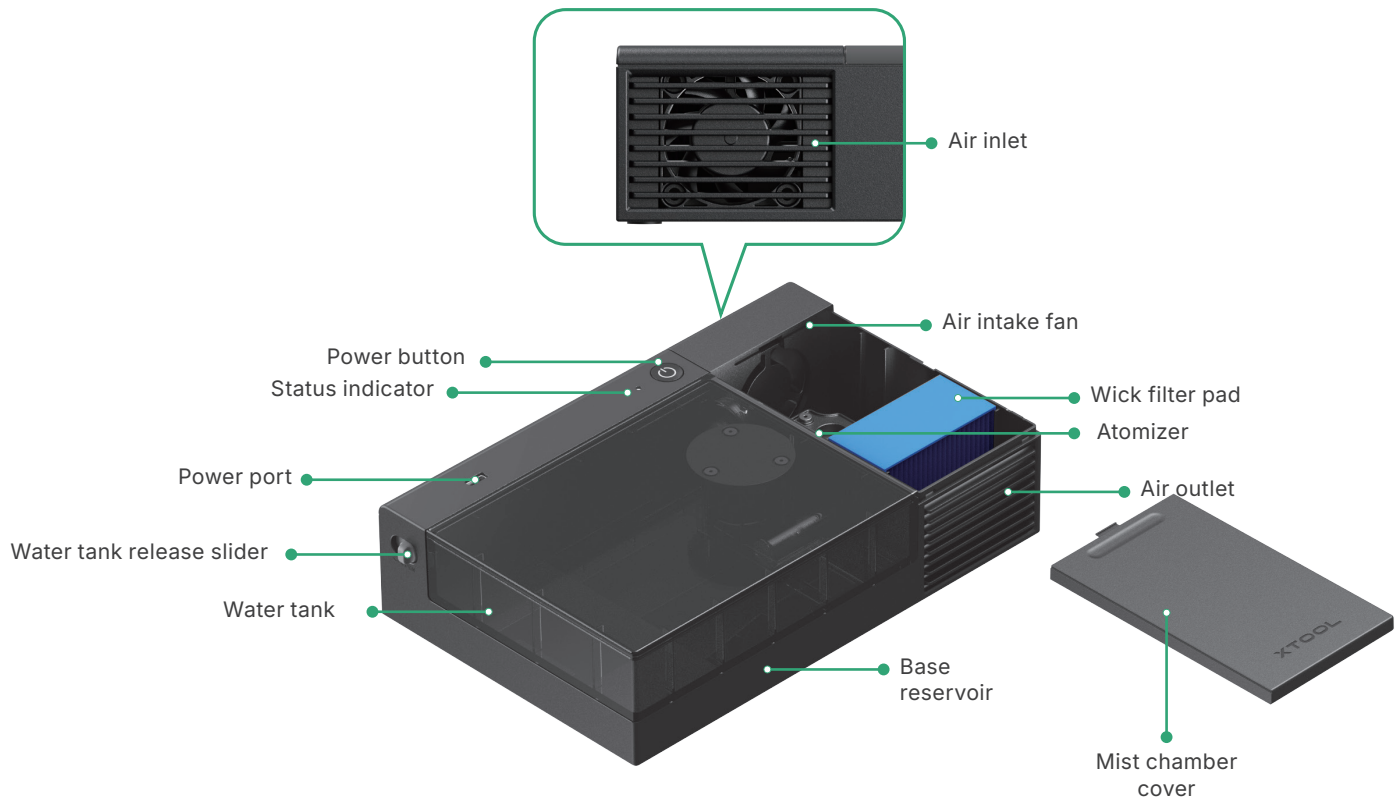
Meet your xTool Apparel Printer Plus



Meet your xTool OS1 Automatic Shaker Oven Machine



Meet your humidity module



Recommended usage conditions:

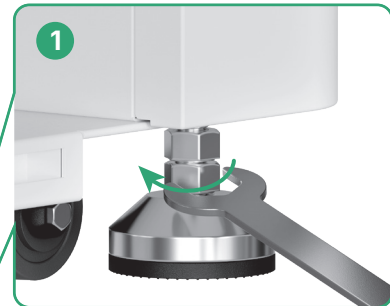
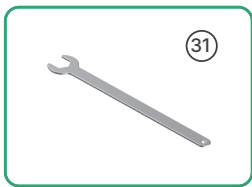
- When ambient relative humidity is below 50%, it is recommended to turn on the module to significantly improve print quality.
- When ambient relative humidity is above 70%, it is strongly recommended to turn off the module to prevent excessive humidity from affecting print quality.

Install xTool OS1 Automatic Shaker Oven Machine and xTool Apparel Printer Plus

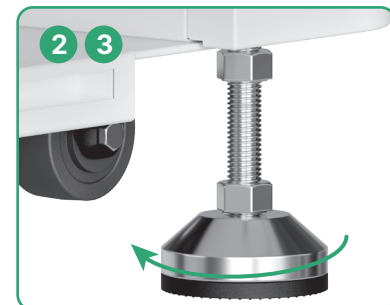
1 Secure xTool OS1

When you place xTool OS1, leave at least 1 m (40 inches) of space at the back and 90 cm (35 inches) of space on both sides for daily use and maintenance.

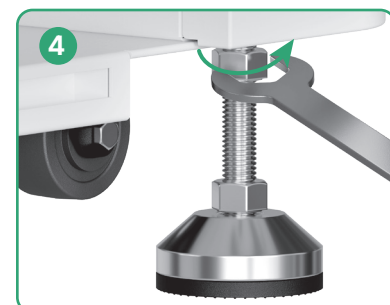




After the position of xTool OS1 is determined, ① unscrew the bottom nuts on the four foot cups with a spanner.



② Unscrew four foot cups with your hands until the foot cups touch the floor. ③ Keep unscrewing the foot cups until the wheels aside are off the floor.



④ Screw the upper nuts on the four foot cups with a spanner.

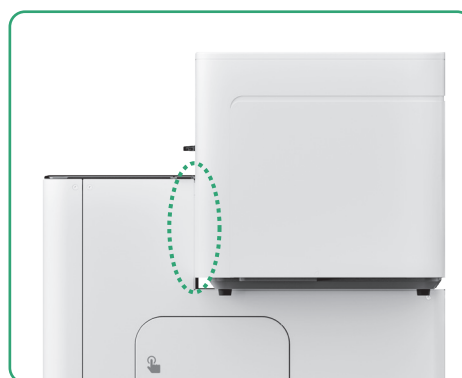
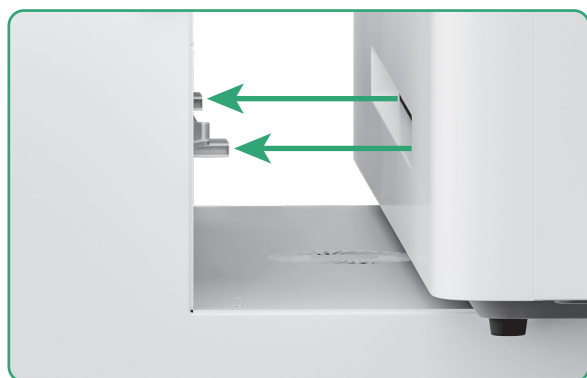


Go to support.xtool.com/article/3297 or scan the QR code to watch the tutorial video.

2 Place xTool Apparel Printer Plus



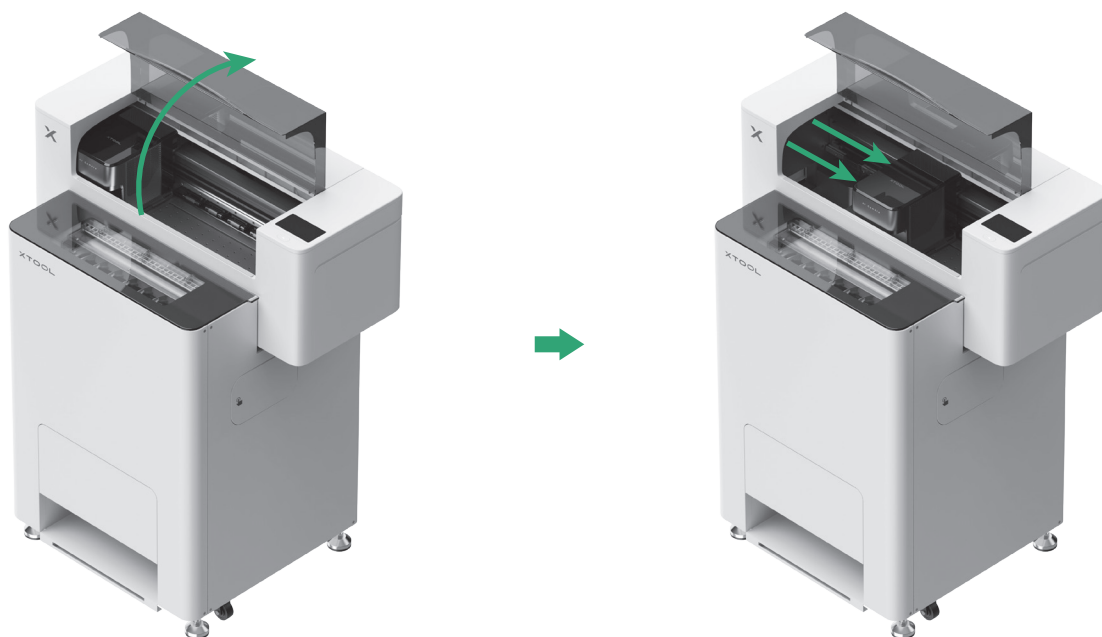
- To ensure your safety and avoid device damage, the printer should be moved by at least two adults. (The printer sold separately)
- Disconnect the power supply of the printer before moving the printer.
- Keep the printer parallel to the ground when moving it. Otherwise, the ink in the printer may spill out.



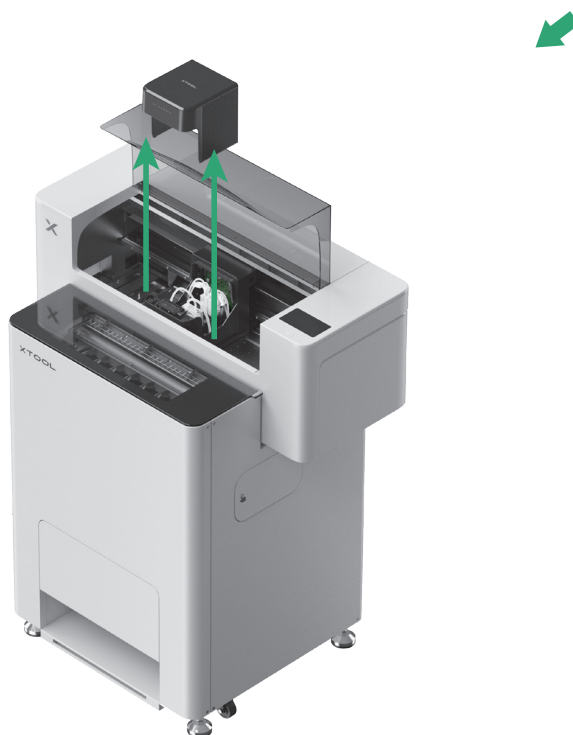
Align the printer's delivery slot with the xTool OS1's connection slot, and connect them together.

3 Prepare the print head

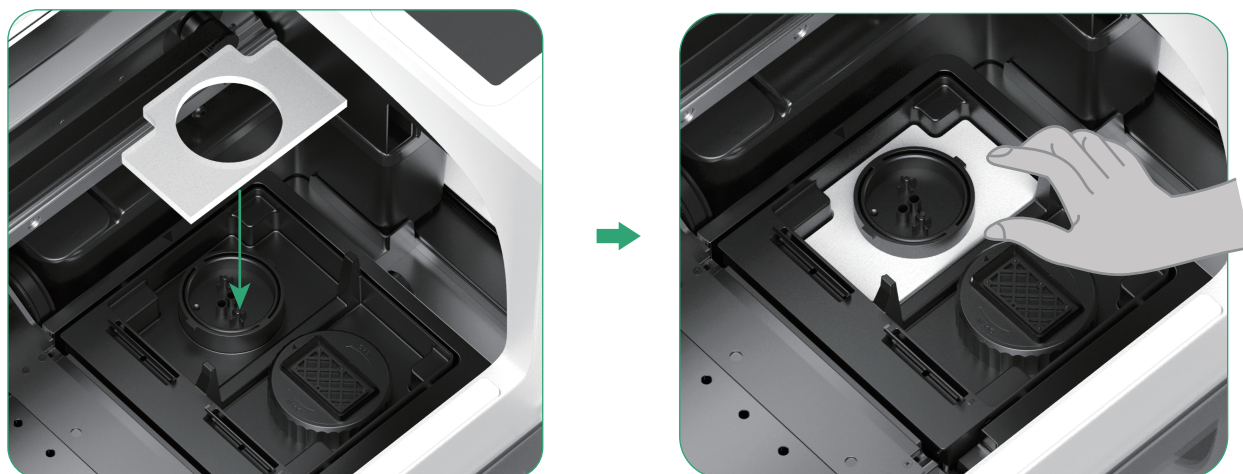
(1)

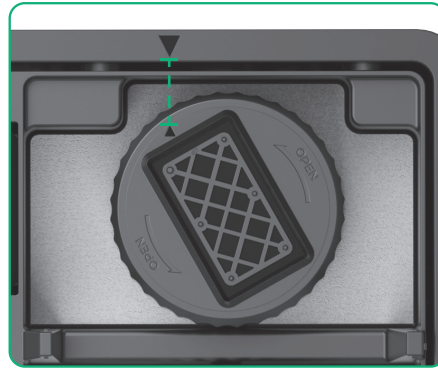


Move the print head to the middle with your hand

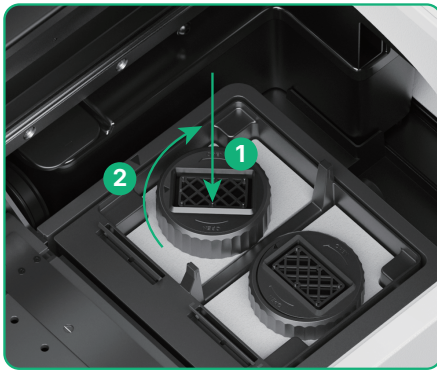


(2) Install the ink stack foam



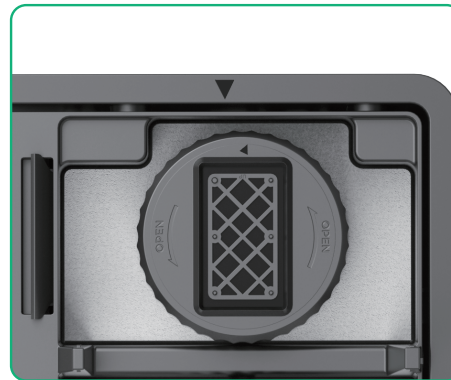


Install the ink pad and ensure that the two arrows are aligned



Do not install the ink pad upside down.

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

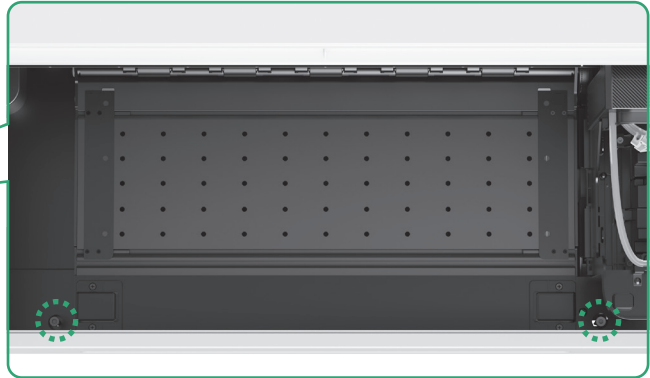
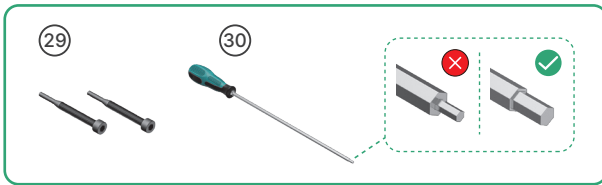


Install the other foam using the same way.



Move the print head to the right

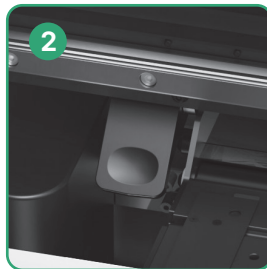
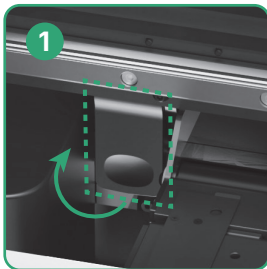
4 Secure xTool Apparel Printer Plus and xTool OS1



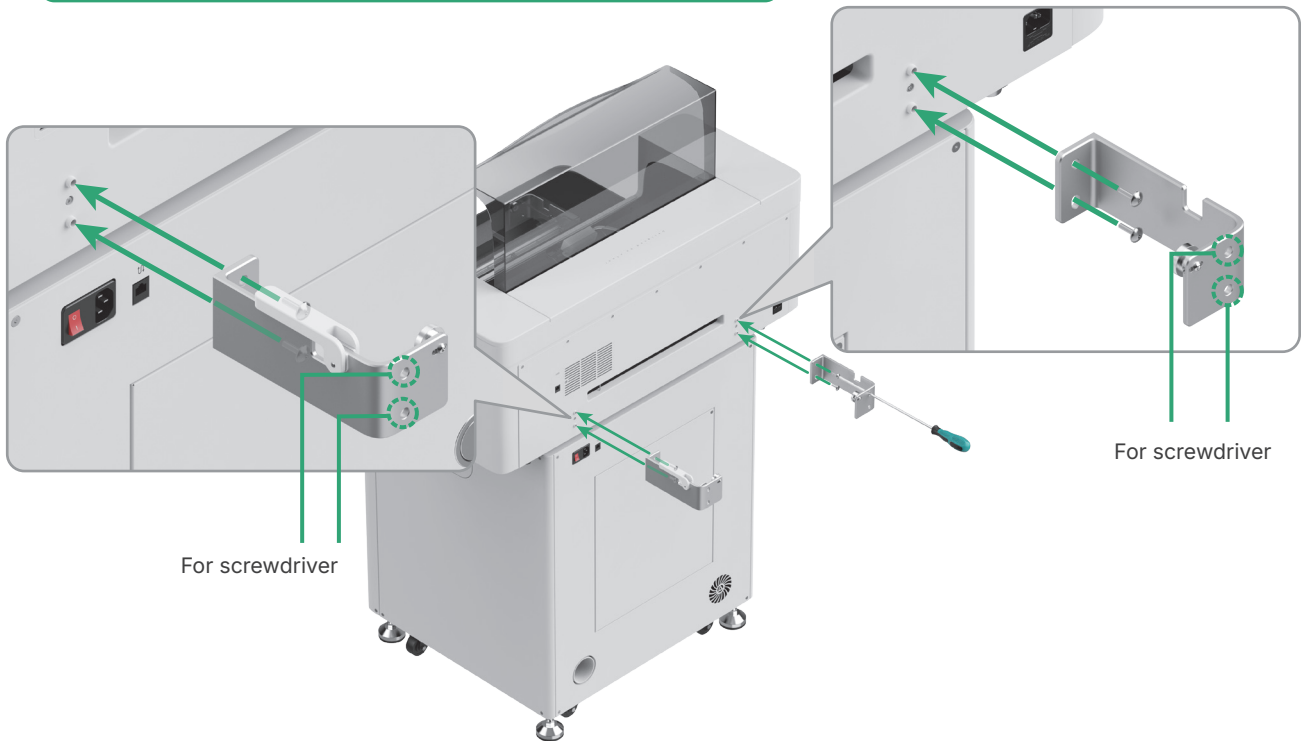
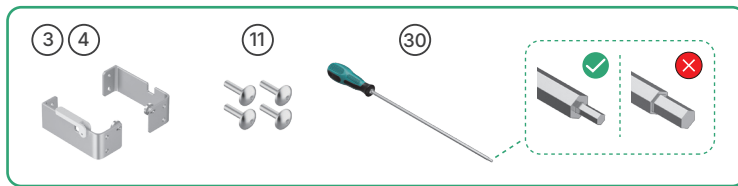
Install two screws in the holes, and tighten them.

5 Install the bracket and xTool Apparel Printer film roll

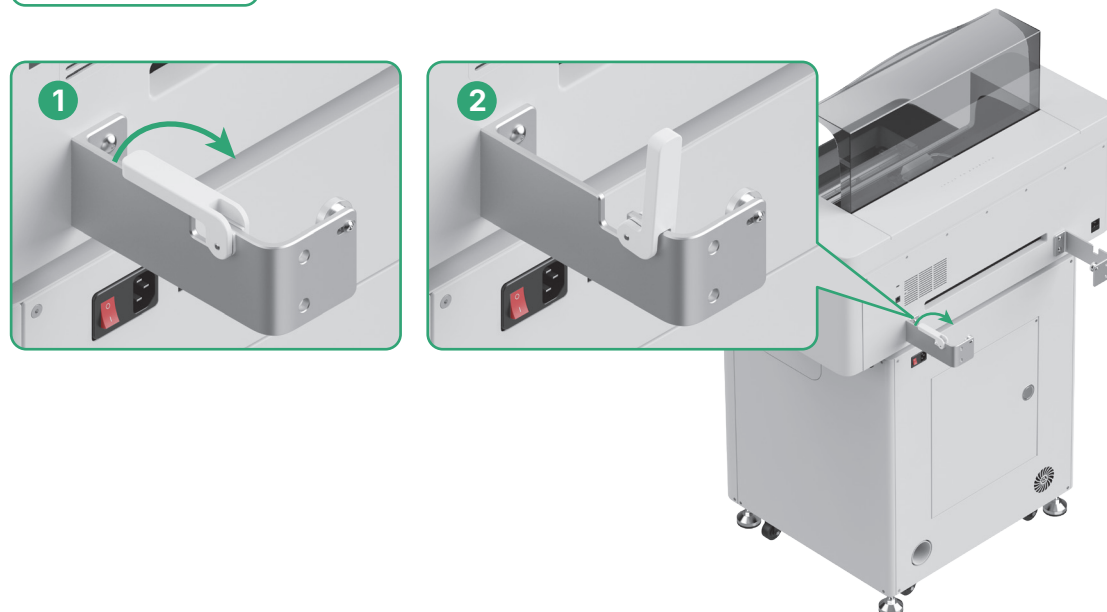
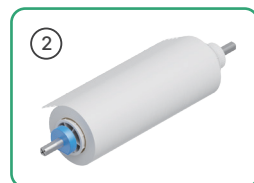
(1) Toggle up the pinch roller switch to open the pinch roller



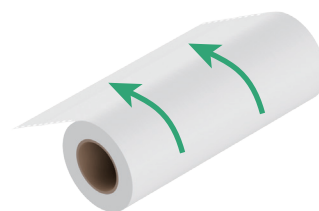
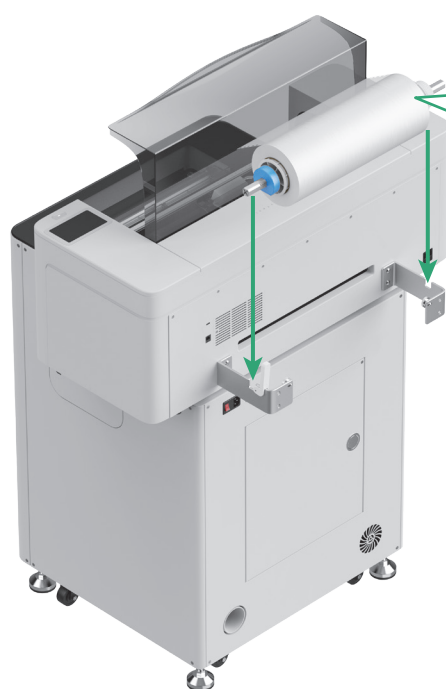
(2)



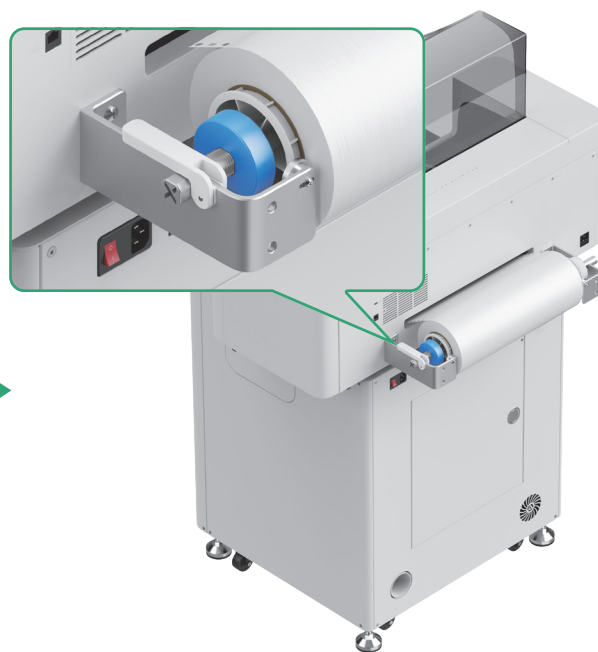
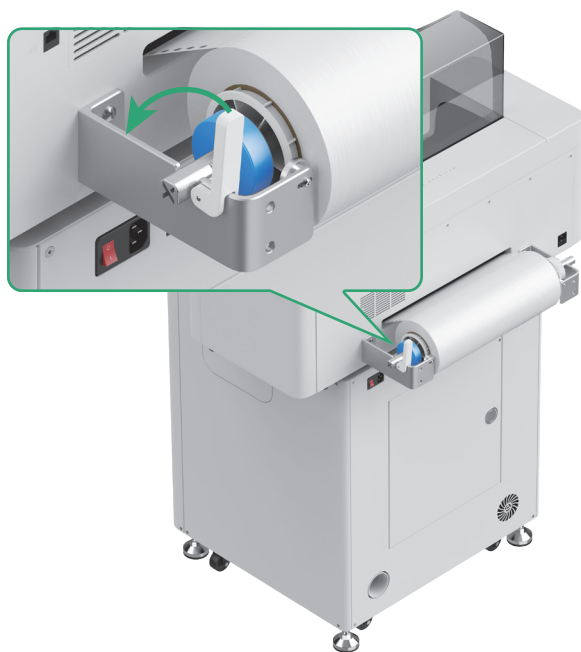
(3)



 Mind your hands when placing the holder.



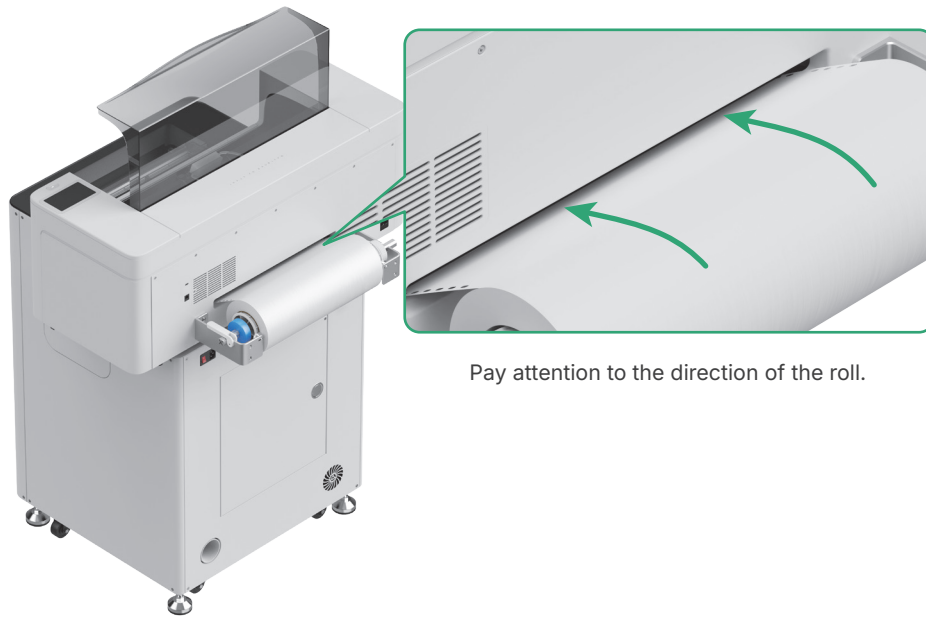
Pay attention to the direction of the roll.



6 Feed xTool Apparel Printer film into the printer



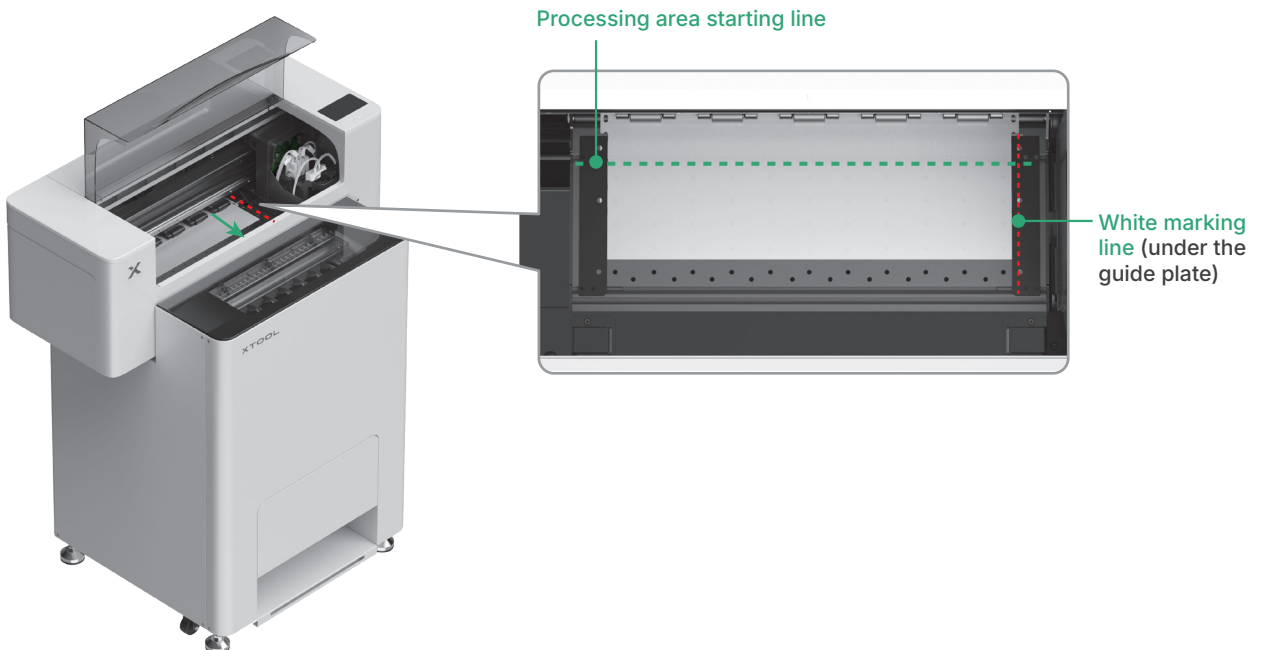
Make sure the sticker on the roll is removed before feeding the film.



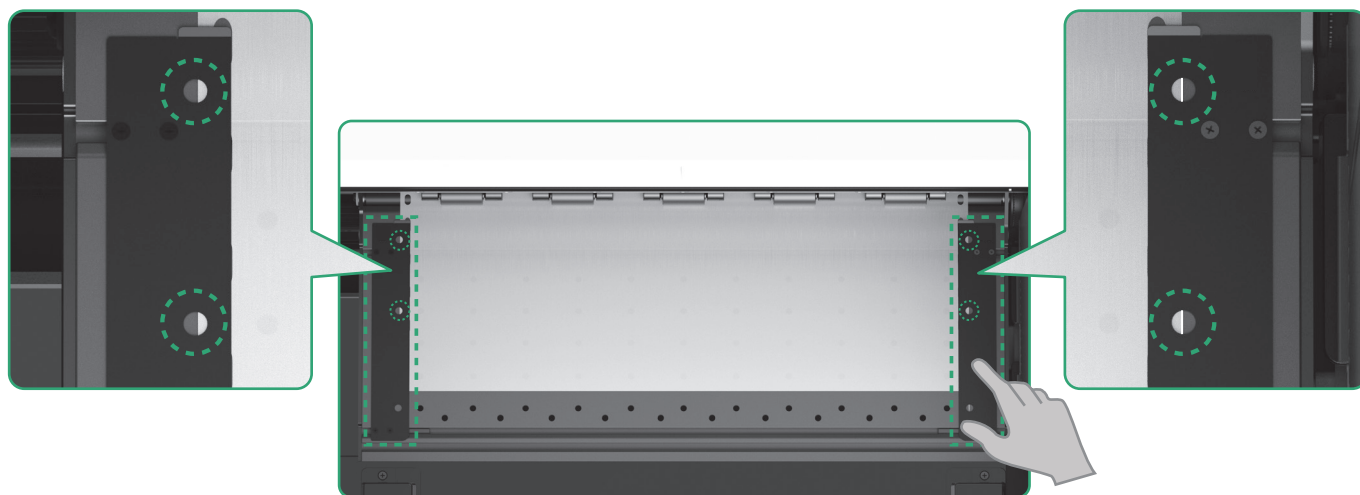
Pay attention to the direction of the roll.



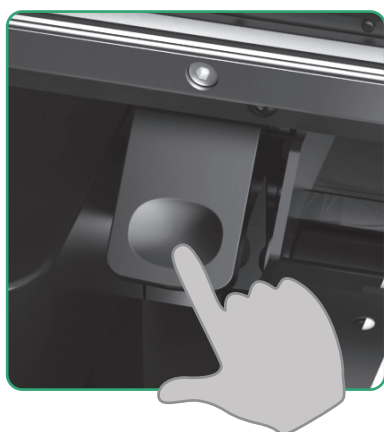
Ensure that the film covers the starting position of the processing area, and aligns with the white marking line on the right.



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.



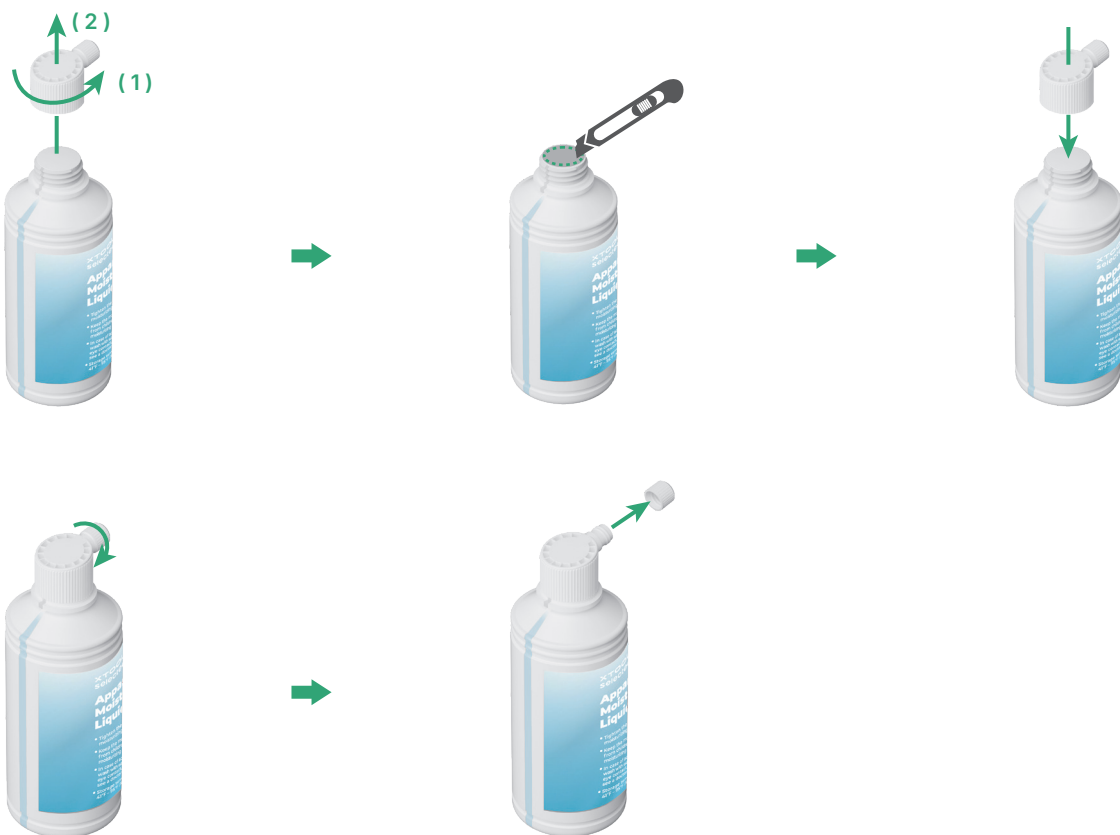
Toggle down the pinch roller switch



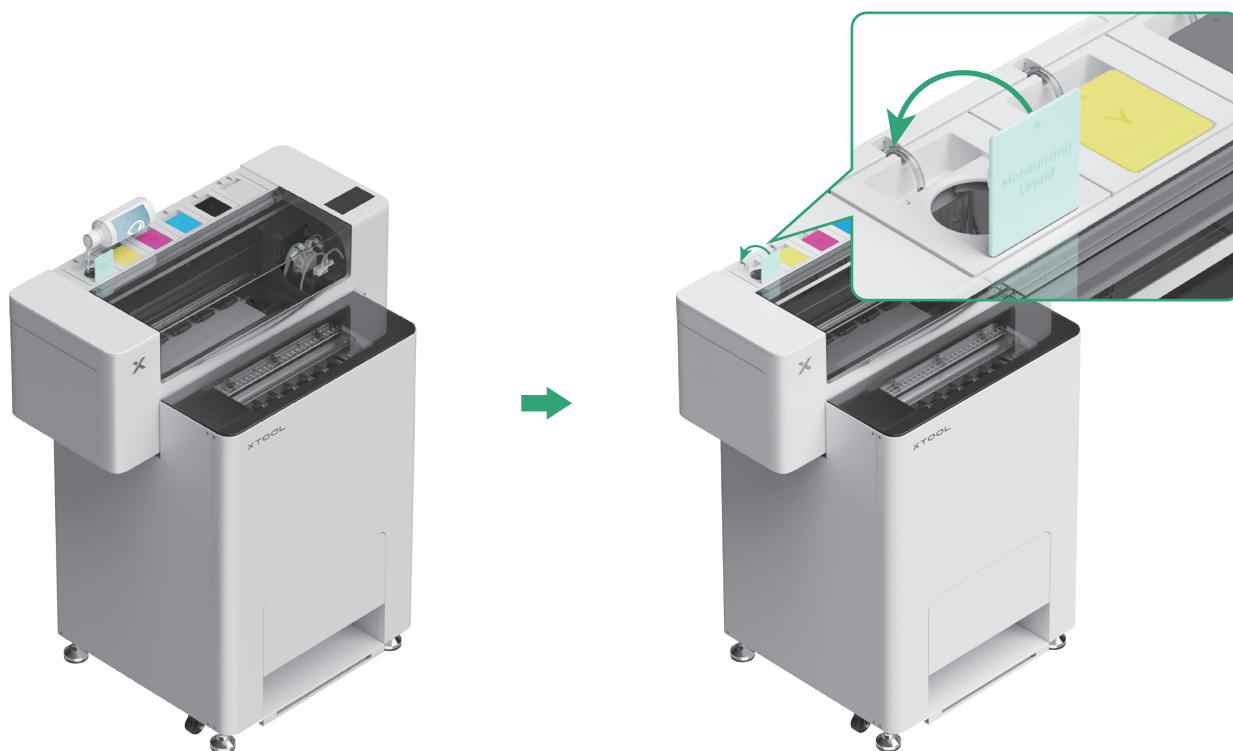
7 Fill in moisturizing liquid and ink

(1) Fill moisturizing liquid into the moisturizing liquid tank





- 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

⑥



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

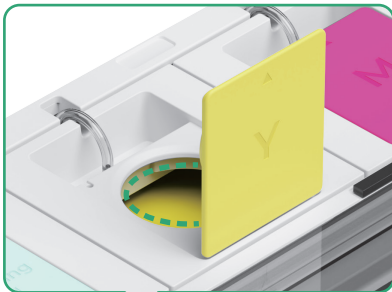


After adding ink, be careful when you open the ink tanks again as ink may splash into the inside of the device.

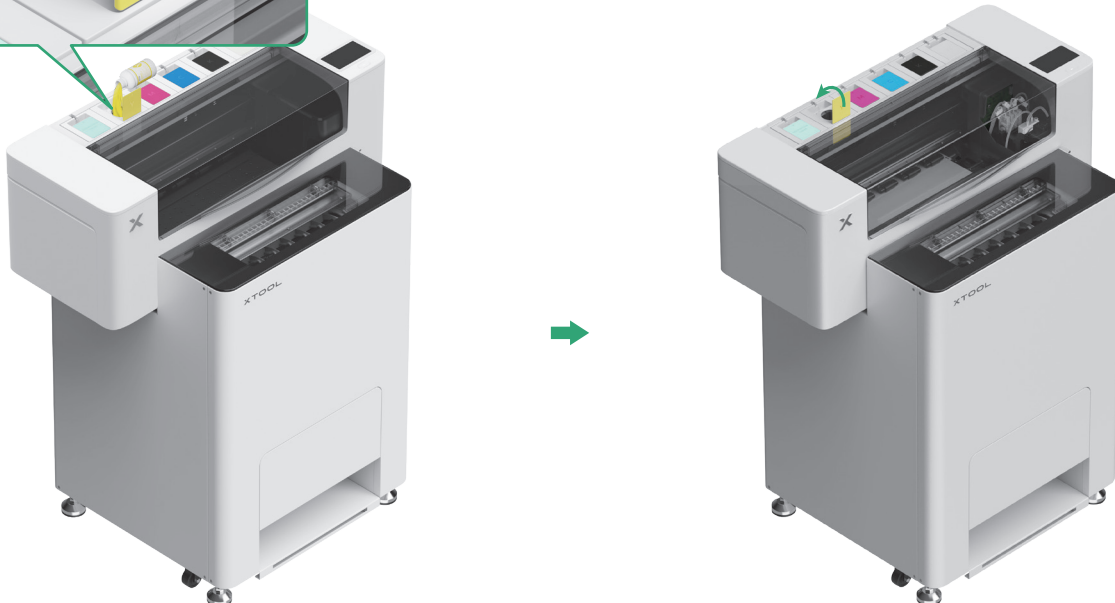
Fill ink of the matching color to the ink tanks.



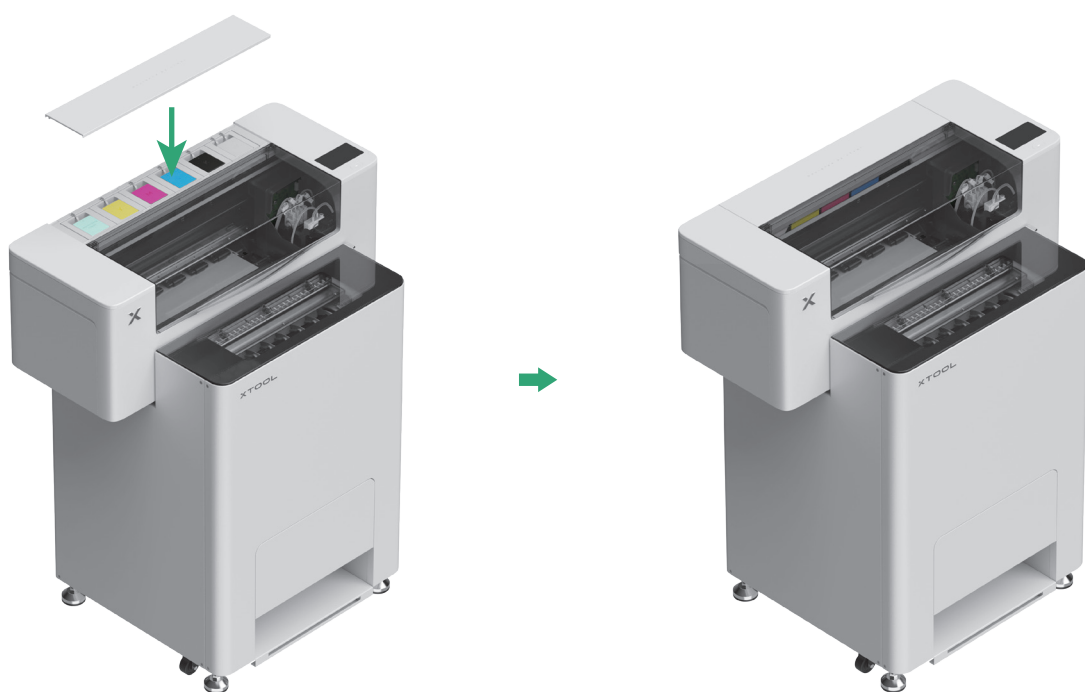
Color ink tank: 500 ml
White ink tank: 1000 ml



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



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

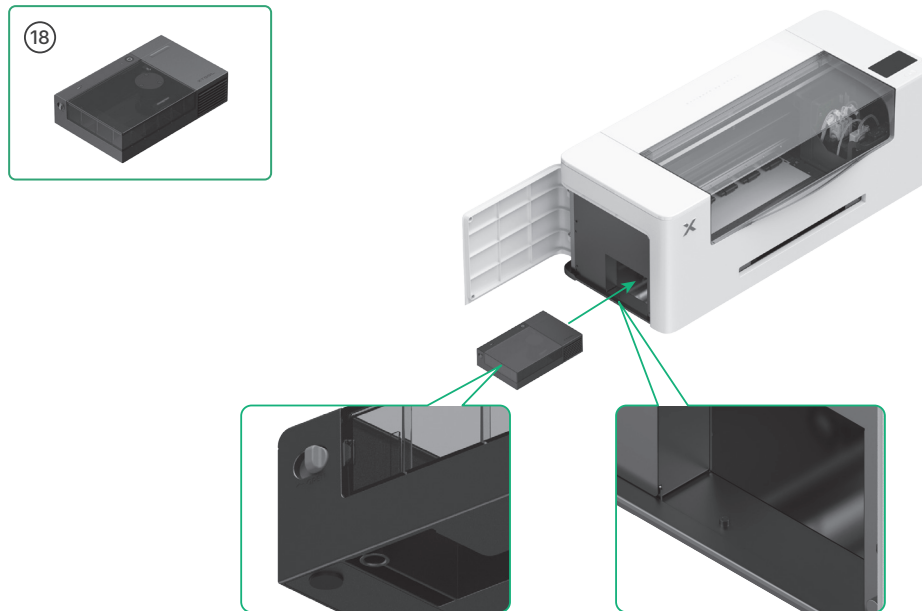


8 Install the humidity module

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



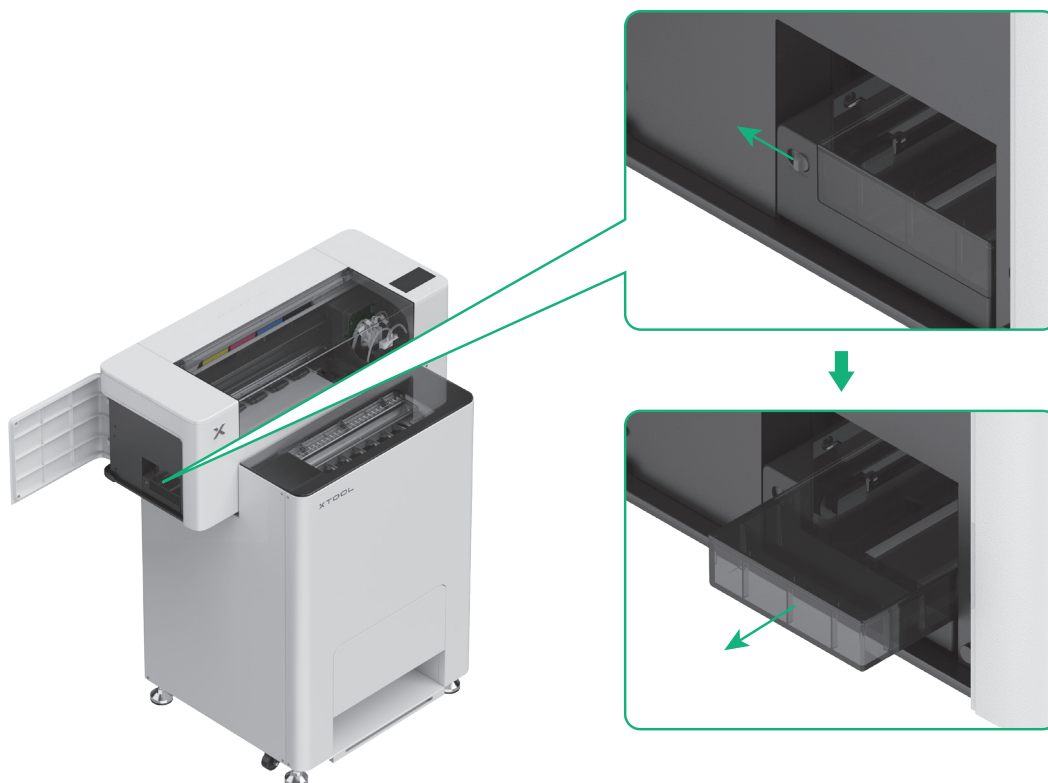
(2) Insert the humidity module horizontally into the printer, ensuring that the air outlet and air inlet of the module face the inside of the printer. Push it inward until the humidity module fits snugly against the inside of the printer and cannot be pushed any further.



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.

9 Prepare and fill the water tank

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

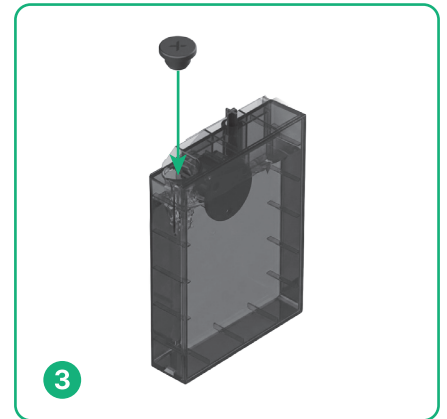
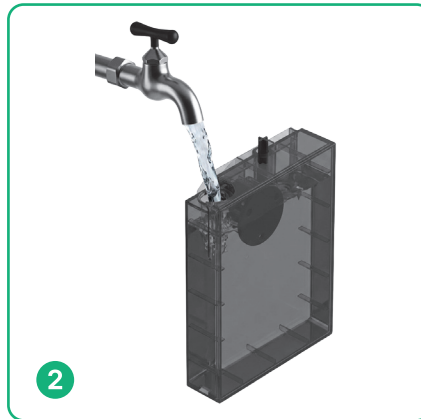
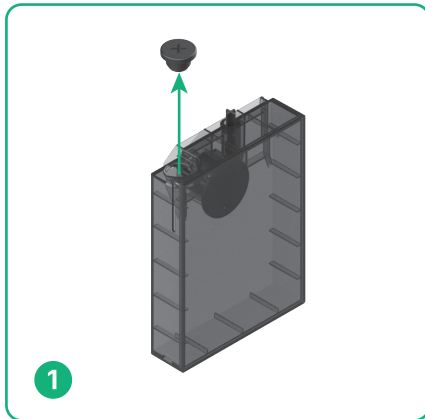


(2) Unplug the silicone plug on the side of the water tank and fill the tank with water. Once filled, insert the silicone plug back tightly.



Always use clean tap water

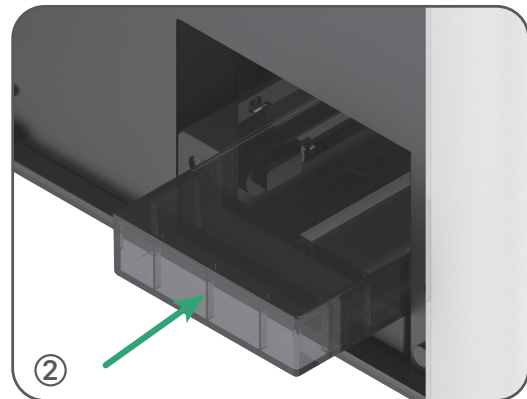
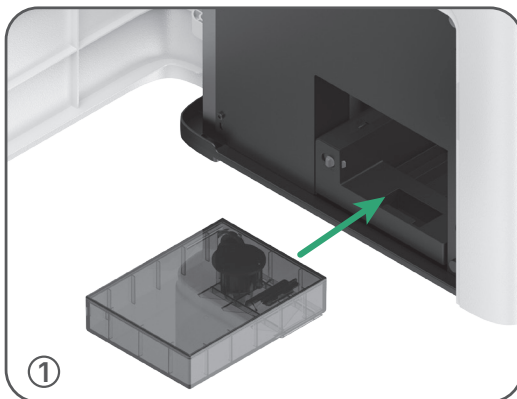
- If local tap water tends to produce white scale deposits, it is recommended to use treated or softened water.
- Do not use purified water or distilled water, as this may affect the humidity module's mist output.
- Water with high levels of impurities or scale can clog the atomizer components and reduce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



(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.

10 Connect the humidity module and the printer

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

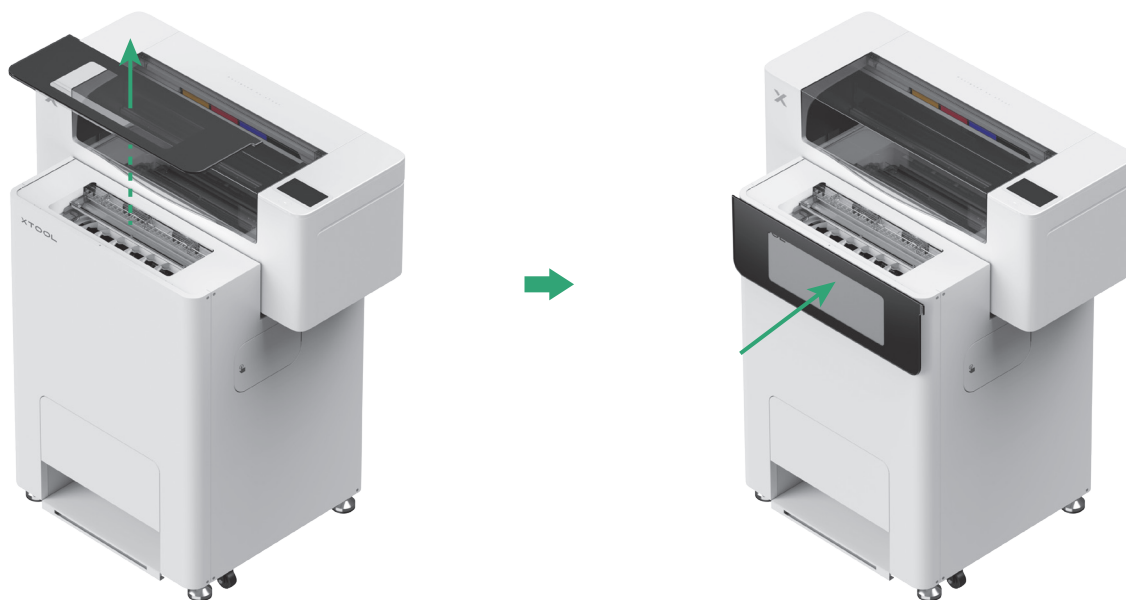


(2) Close the left-side panel of the printer.

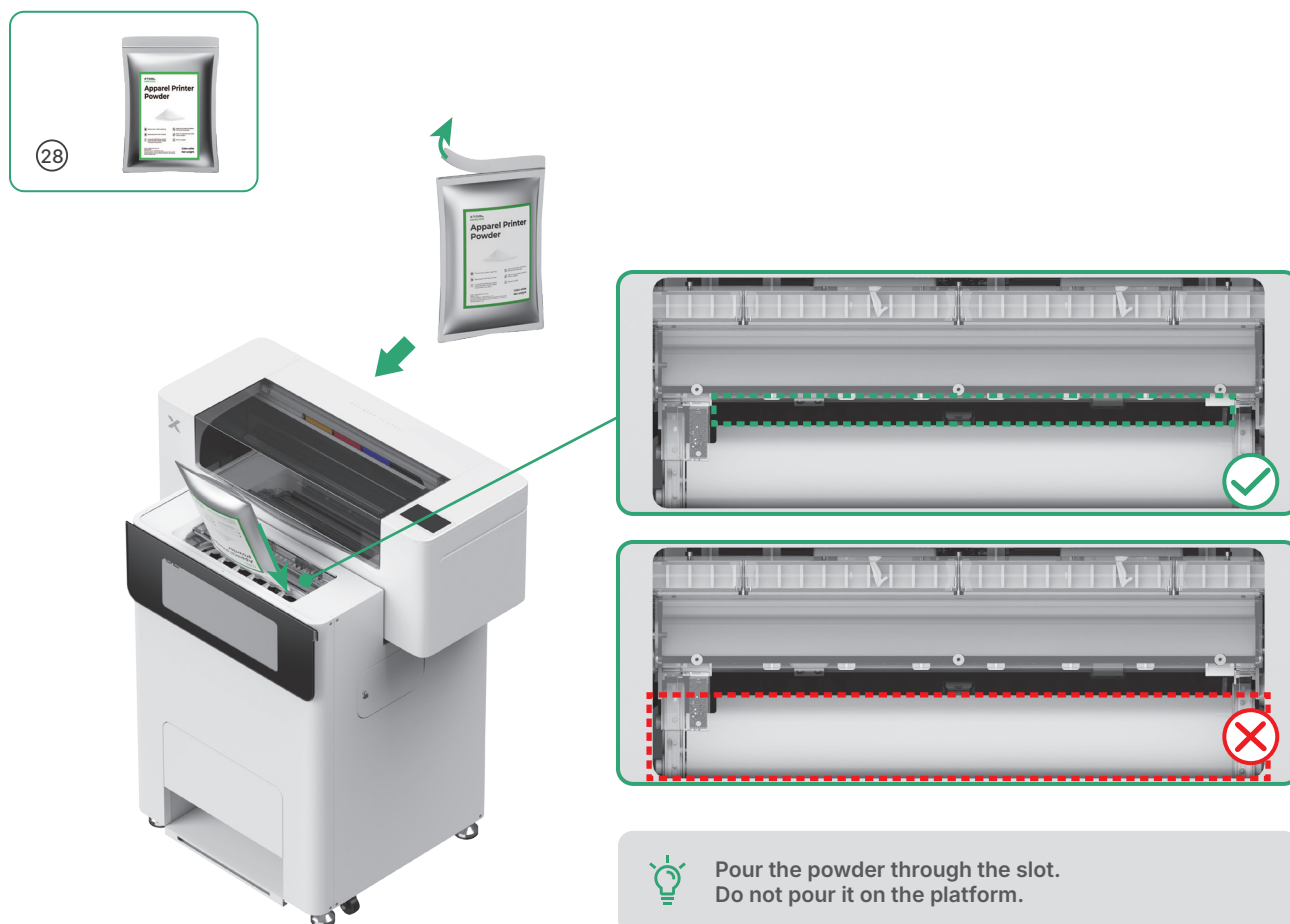


11 Add the powder

(1) Remove the magnetic cover and attach it to the device unit



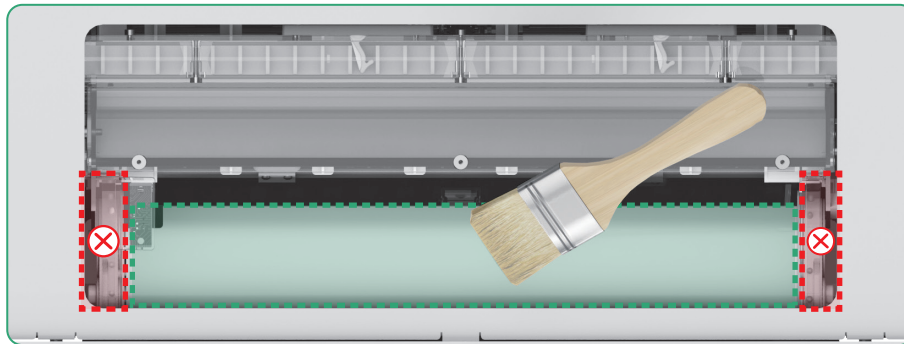
(2) Pour the powder into the powder bin evenly, one pack at a time (The weight of the powder should be ≤ 1 kg).



(3) Clean the powder on the platform



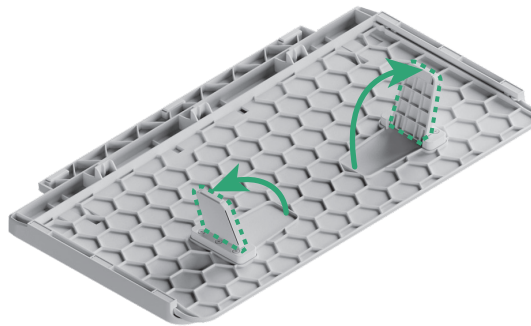
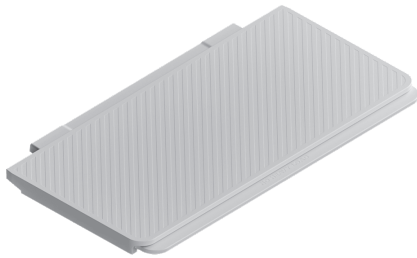
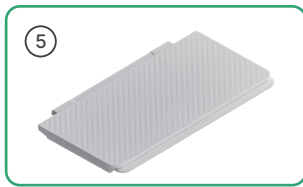
Avoid powder leakage from the side slots during cleaning.



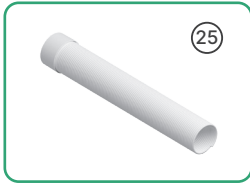
(4) Put the magnetic cover back to its place



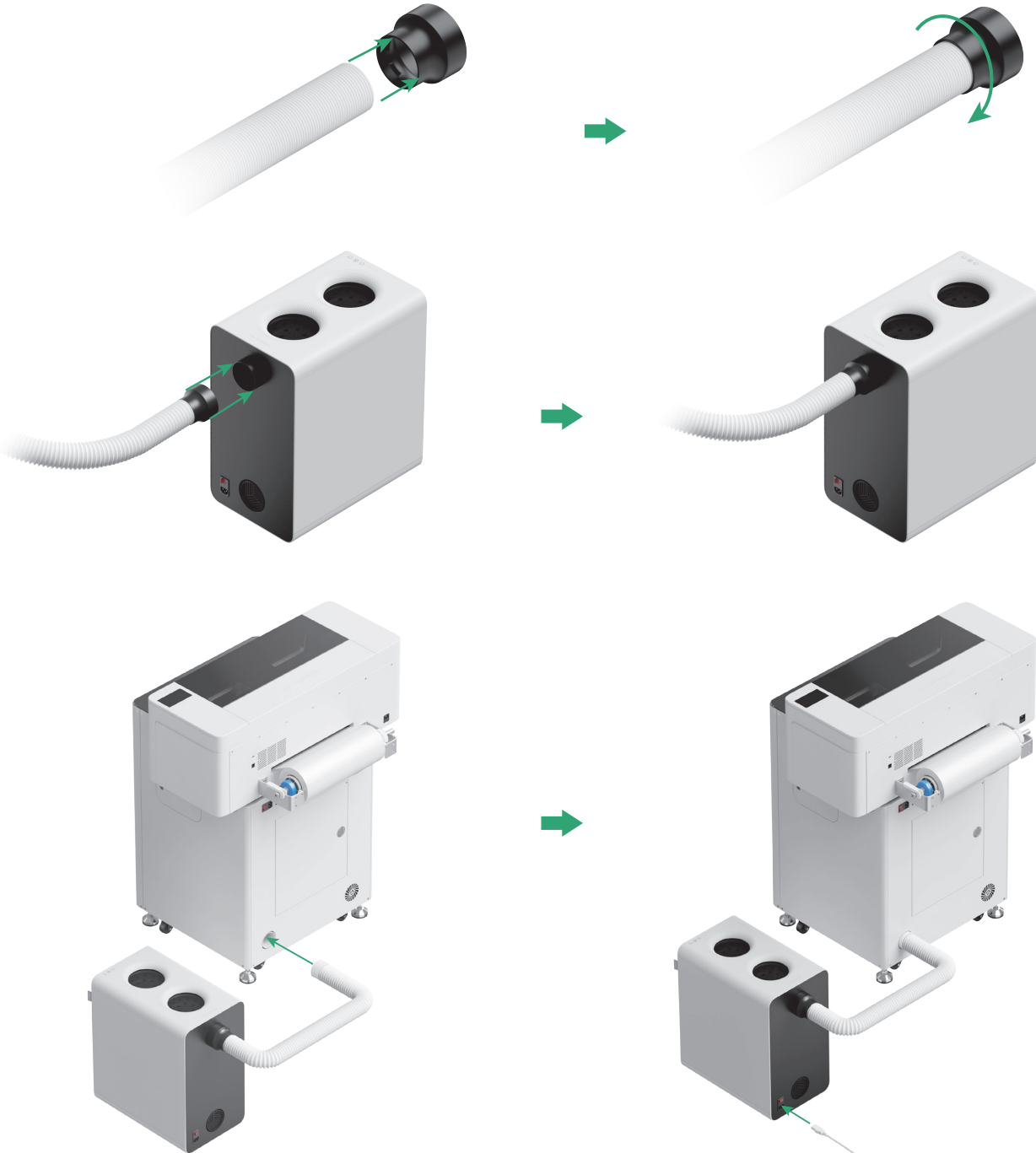
12 Install the output tray



13 Connect xTool OS1 to xTool SafetyPro™ AP2



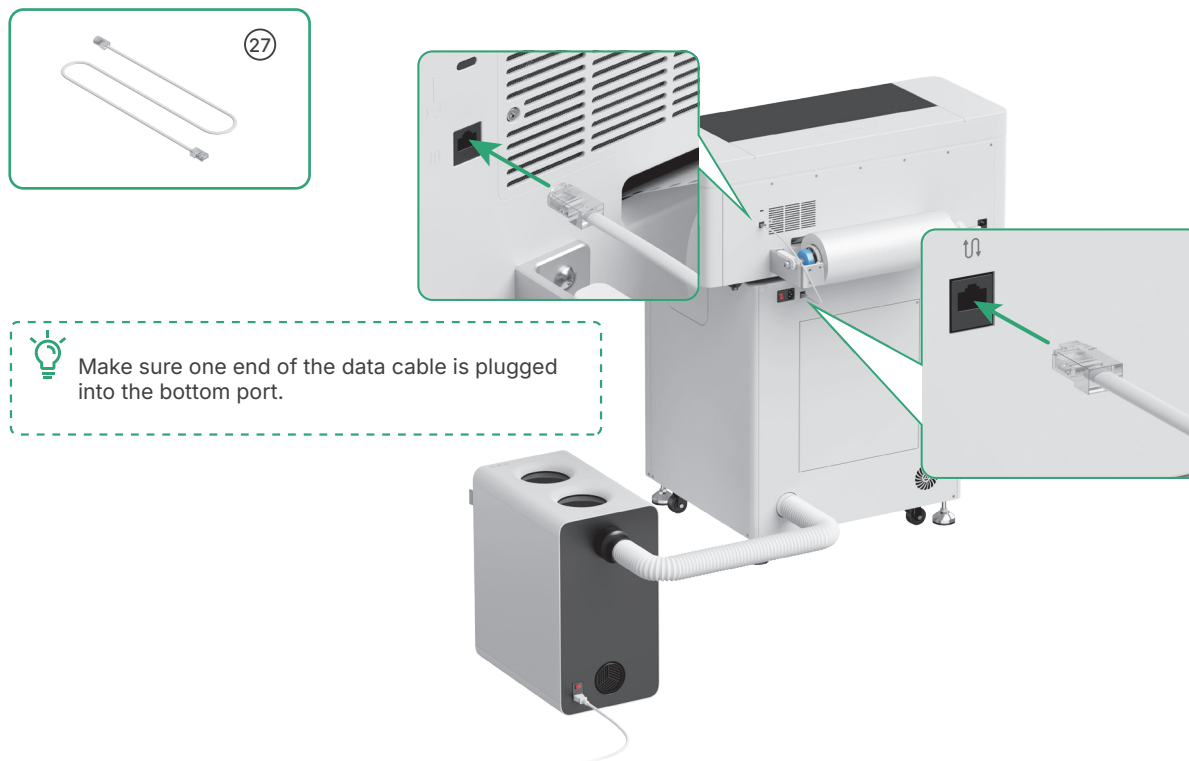
xTool SafetyPro™ AP2 sold separately.



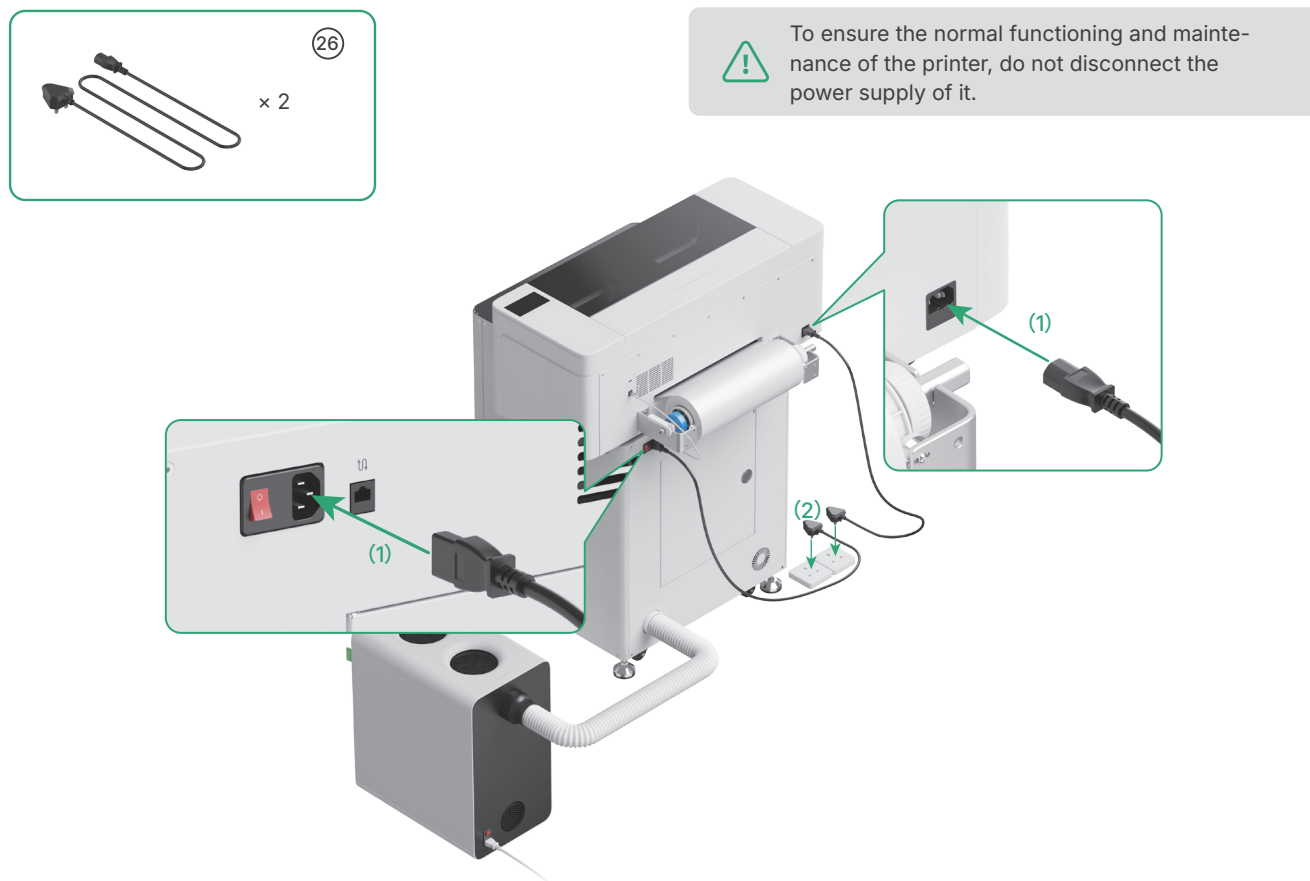
Stretch the smoke exhaust pipe as long as it will go when connecting it to xTool SafetyPro™ AP2.

Use xTool OS1 Automatic Shaker Oven Machine and xTool Apparel Printer Plus

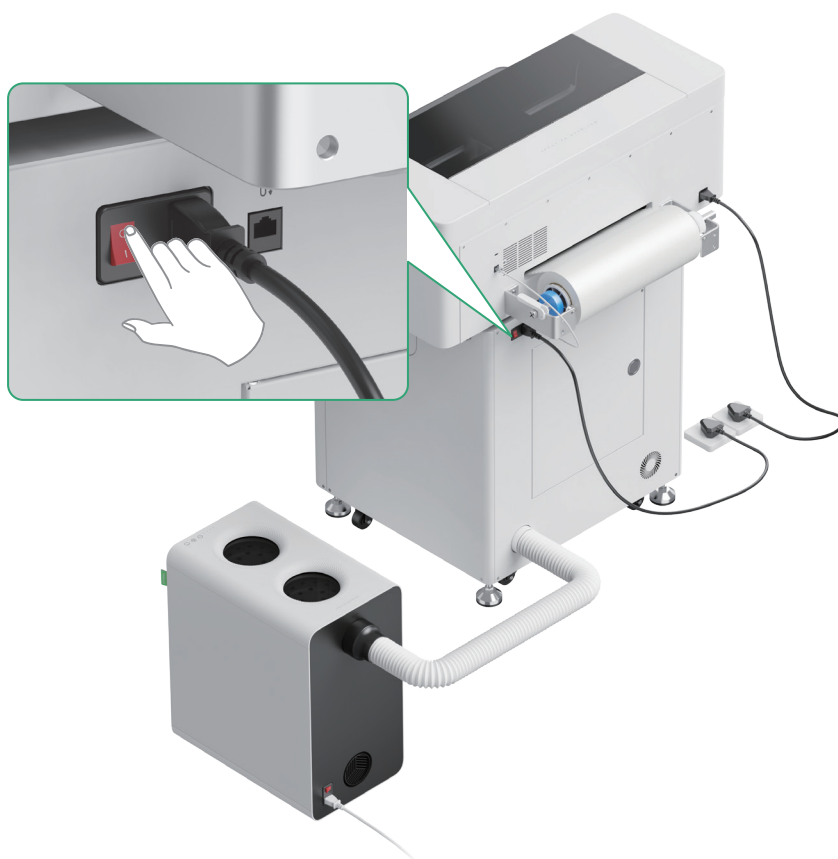
1 Connect xTool OS1 to xTool Apparel Printer Plus



2 Connect to a power supply



Turn on the power switch of xTool OS1



3 Complete the setup

Tap the screen on the printer and complete the device's initial setup



4 Power on the humidity module

(1)



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





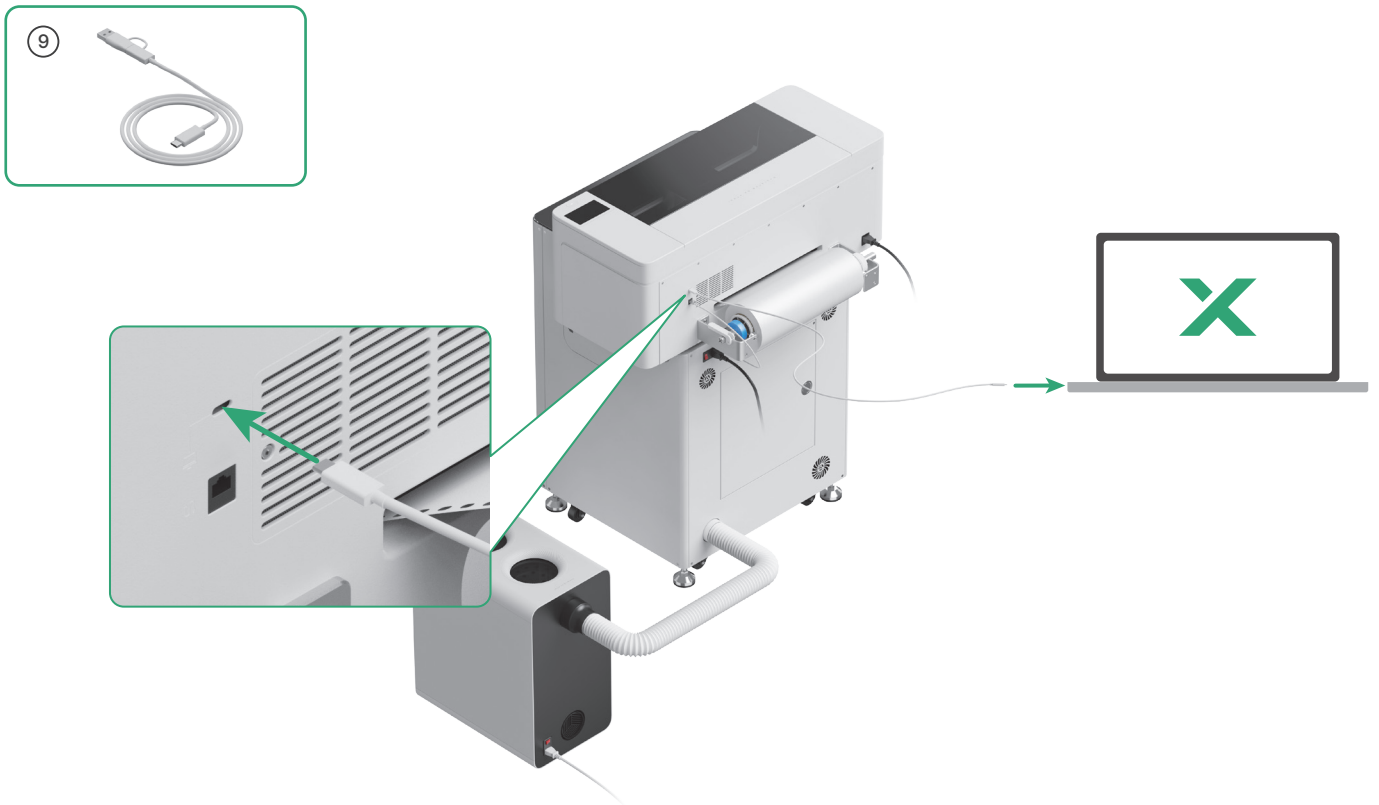
Pressing the power button again during operation will pause the humidification.

5 Get the software



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

6 Connect xTool Apparel Printer Plus to a computer



For details about how to use the software to operate xTool Apparel Printer Plus and xTool OS1, scan the QR code or visit support.xtool.com/article/3298.



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

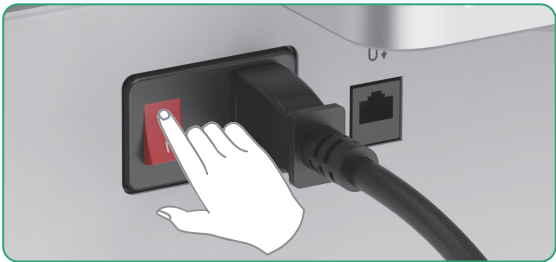
Humidity module indicator

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

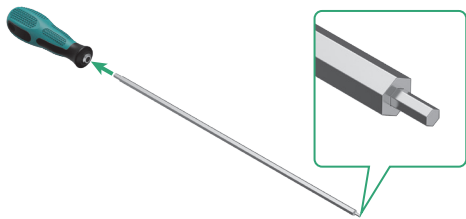
FAQ

1. I want to open the maintenance door. What can I do?

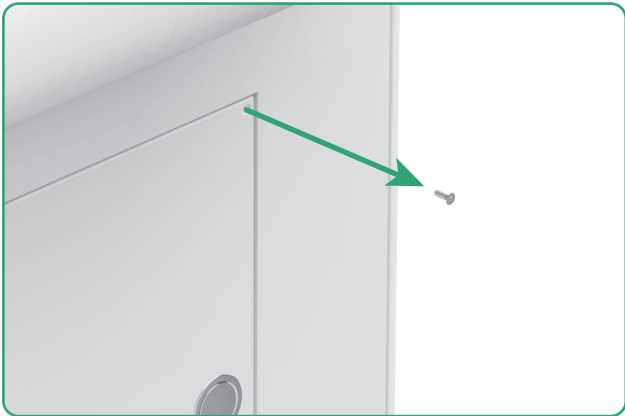
(1) Turn off the power switch of xTool OS1



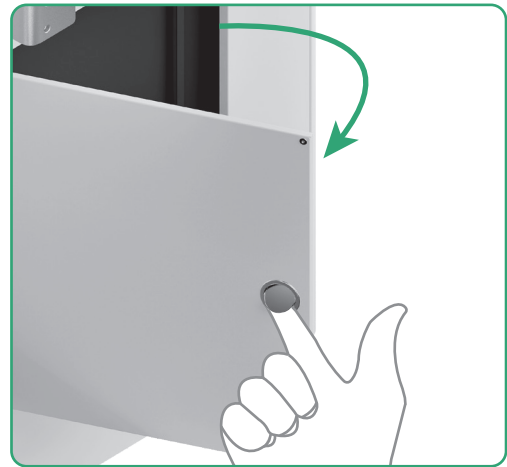
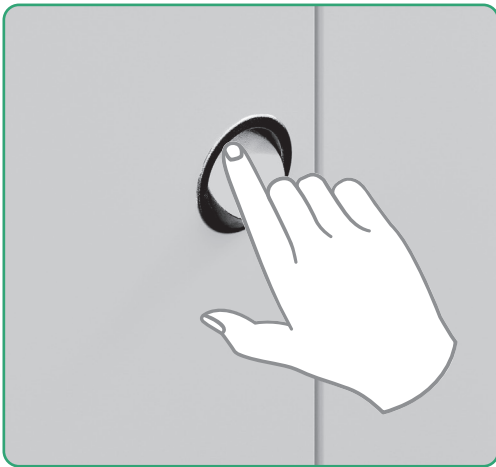
(2) Unscrew the screw of the maintenance door



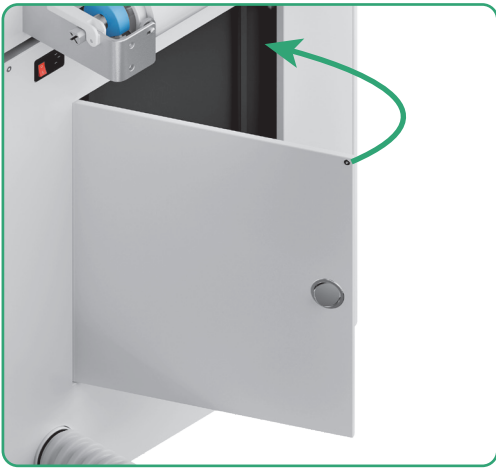
Use the narrow end of the screwdriver



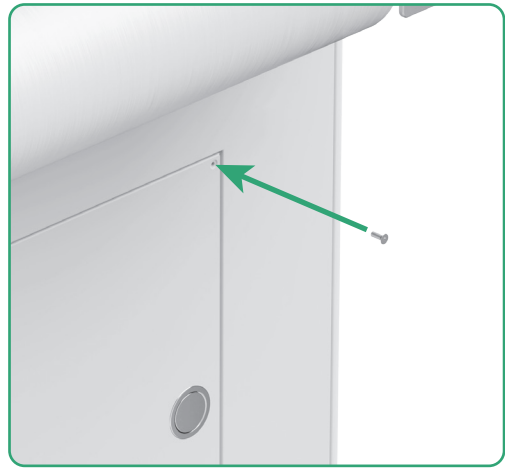
(3) Press the round pull and open the maintenance door



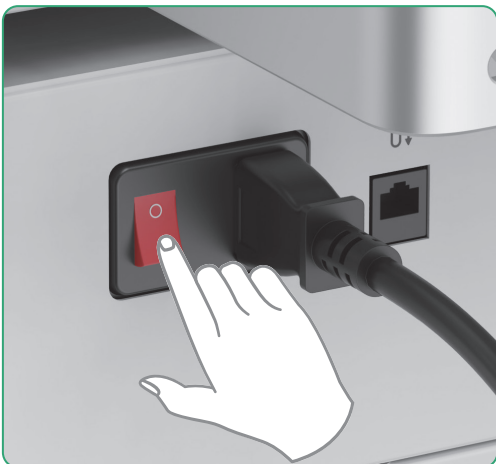
(4) Close the maintenance door after using



(5) Tighten the screw



(6) Turn on the power switch



2. How does xTool SafetyPro™ AP2 work with xTool OS1?

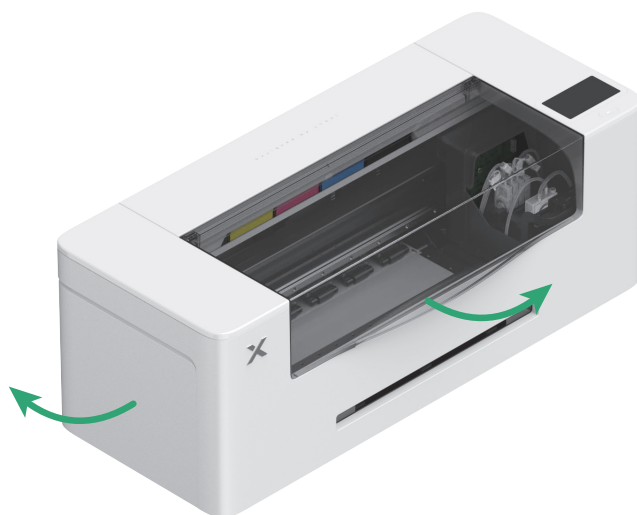
Go to support.xtool.com/article/1646 or scan the QR code to read the article.



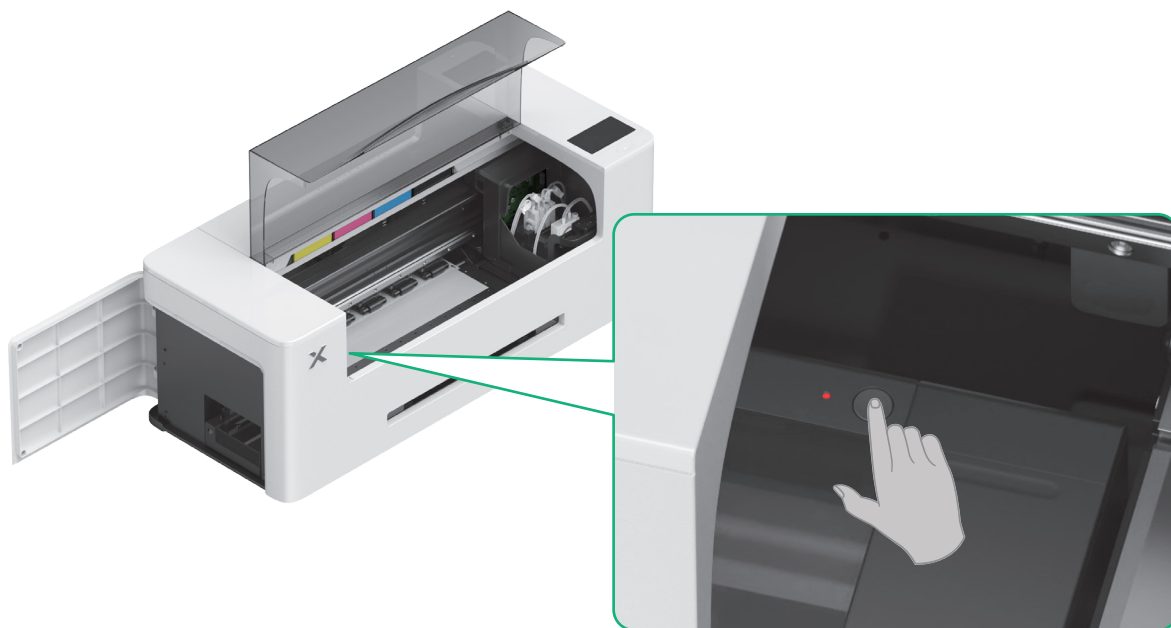
3. How to remove the humidity module?

- 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.

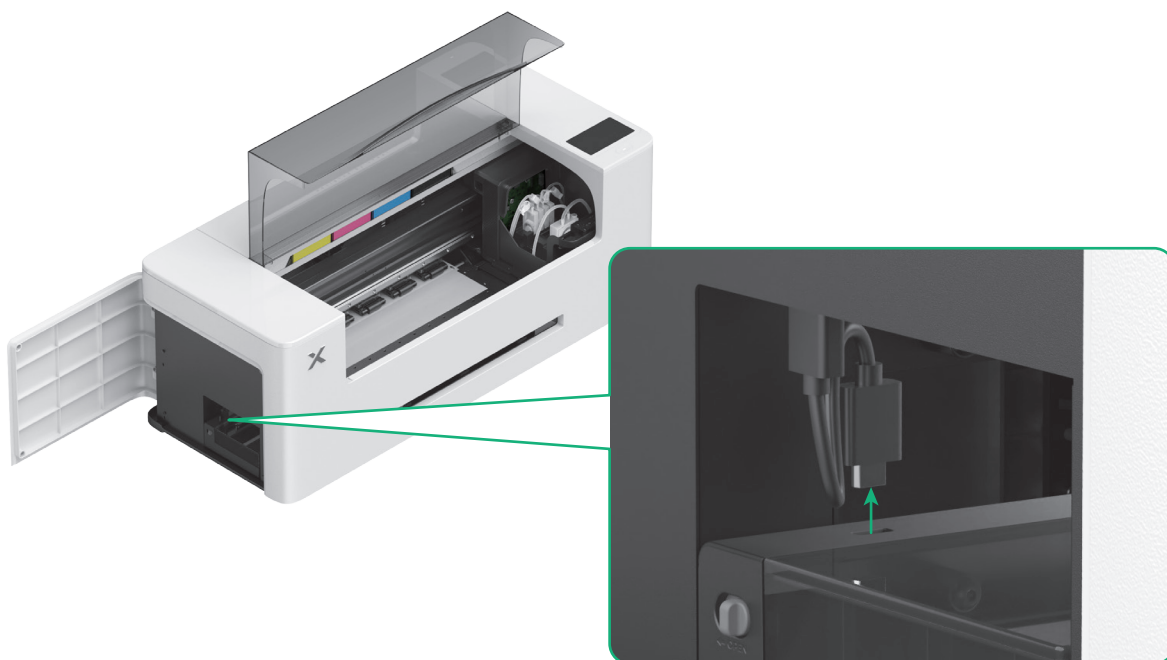
(1) Open the left-side panel and lid of the printer.



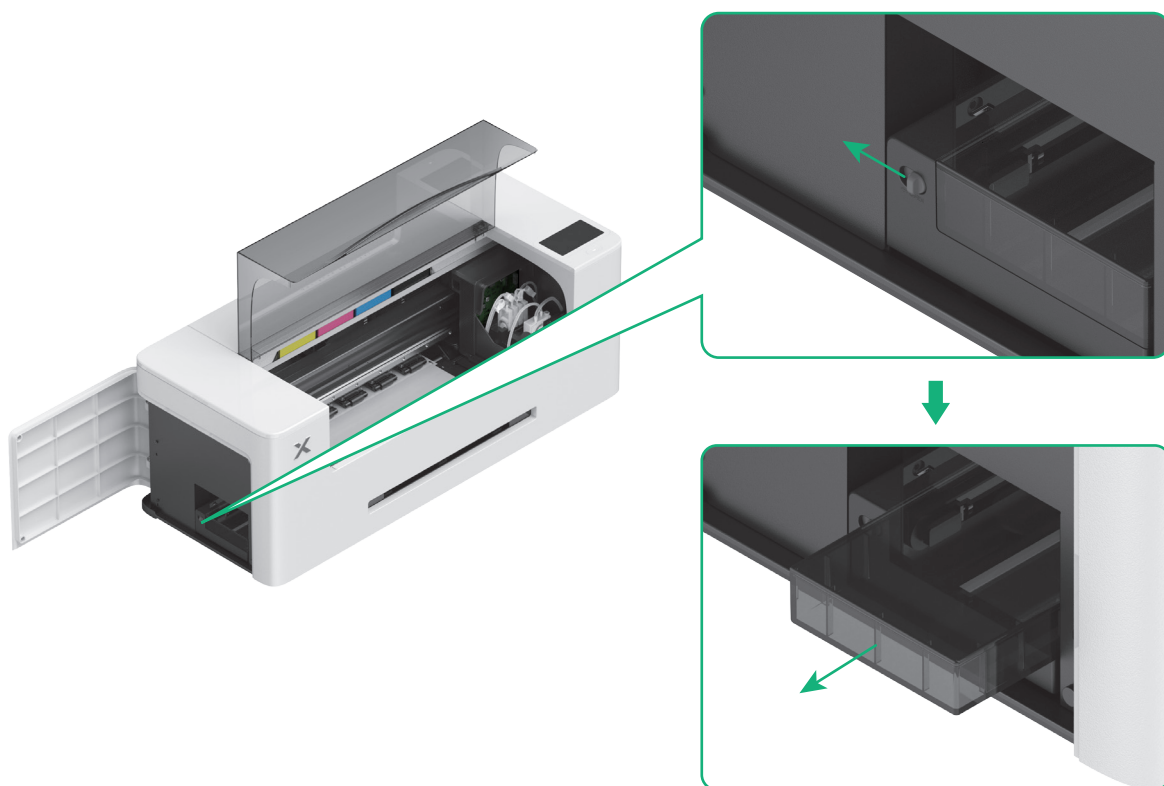
(2) Press the power button to turn off the module.



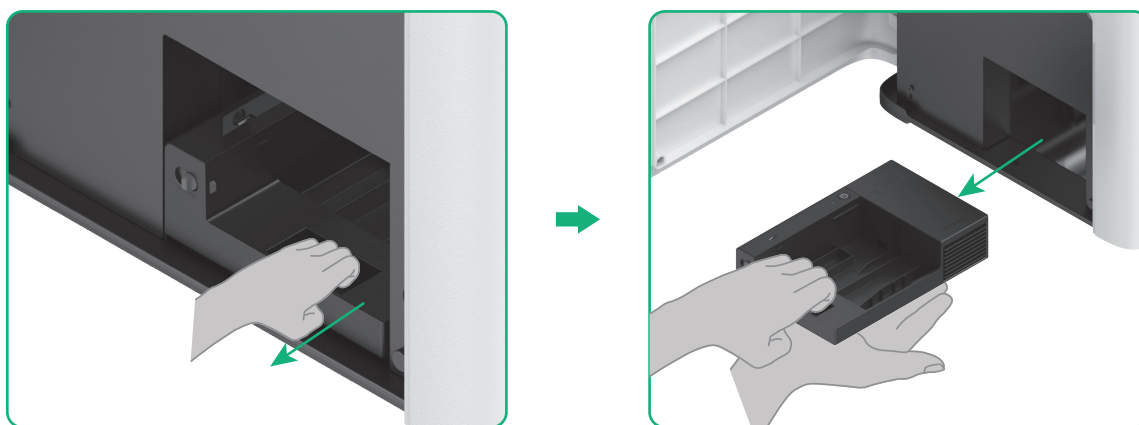
(3) Unplug the connection cable of the humidity module.



(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.



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