

# PRODUCT GUIDE

Mimaki



## 3DUJ-2207

COMPACT INKJET FULL COLOR 3D PRINTER

03-11-2021

V1.02EU

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## Concept

- The 3DUJ-2207 is a compact, photorealistic full-color 3D printer capable of producing more than 10 million unique colors.
- It's perfect for applications where color accuracy and fine detail are critical.
- The 3DUJ-2207 shares the same technology as its predecessor, the 3DUJ-553, including the same resins, support material, and software, but features a much smaller build plate area of 20x20x7.6 cm.
- The smaller desktop-size model is designed to provide a flexible and scalable entry-level option for people and businesses wanting to make a start in 3D full color printing.
- The printer is targeting the design, medical, education, and figurine and gaming sectors, as it can print sharp scanned models in color which require highly precise printed details, including those needed to replicate textures and intricate features.



# Features

- LED-UV curable full color 3D inkjet printer
  - Combining Mimaki technology with high quality 3D printing results in more than 10 million colors, twice more than any current available 3D printer\*1
- Compact design
  - 203 x 203 x 76mm table build area
  - Featuring a compact design and size, passing through a standard office door
- Clear ink is available to enhance product variations
  - 3DUJ-2207 utilizes clear inks that can be jetted independently or combined with colored ink to create translucent objects
- Compatible with ICC profile
  - Output color simulation is easy to proceed from Photoshop for fast and optimized modeling output
- Ultra-thin layers for high quality modeling
  - Using the ultra-thin layer thickness of 28 micron enables smooth details expression at 1200x1200dpi
- Water-soluble support material
  - Simple removal enables highly detailed models to be created without the support material removal affecting the final result
- Stable operation
  - Ink circulation system and NCU prevents missing nozzles and maintains a stable print environment



# Product Overview

**LARGE INK SUPPLY SYSTEM**  
CMYK, White, Clear and Support materials are available in a size of 1Ltr bottle

**MAINTENANCE AREA**  
Easy access to cleaning area

**FRONT COVER**  
Prevents dust from getting on the object

**STAND (OPTION)**  
Use of the optional stand is strongly recommended in order to assure the print quality. Deodorizer/air filter option can be installed internally

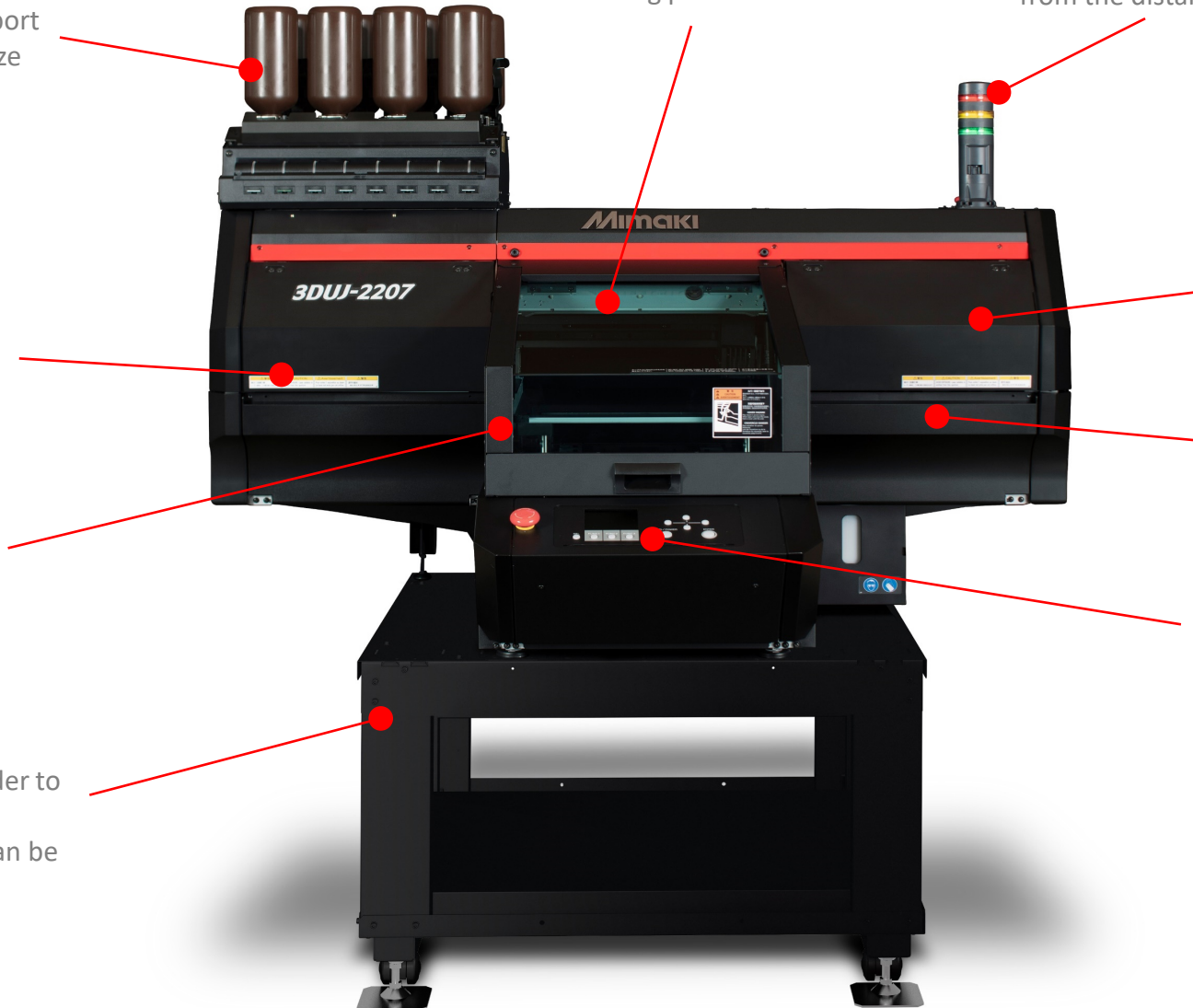
**LED LIGHT AND CAMERA**  
To check and monitor the modeling process

**STATUS INDICATOR**  
Basic printer status visible from the distance

**DUAL PRINT HEADS**  
High Print Speed

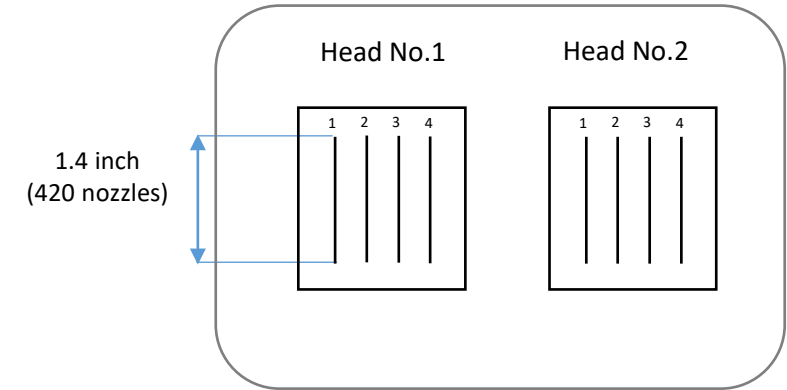
**CAPPING STATION UNIT**  
For automatic cleaning and storage of printheads when the printer is not modeling

**OPERATION PANEL**  
Operation keys and full color LCD indicate a various settings and operation items



# Latest Print Head Technology

Amount of Heads	2
Heads configuration	In-line
Nozzle Configuration	420 nozzles per line, 4 lines per head
Print Resolution	Up to 1200dpi
Droplet Size	Starting from 4pl



## Variable Dots

- Higher Object Quality
- Low grains
- Excellent gradients

## High Durability

- Industrial Graded Print Head
- Piezo technology
- Low long-term costs

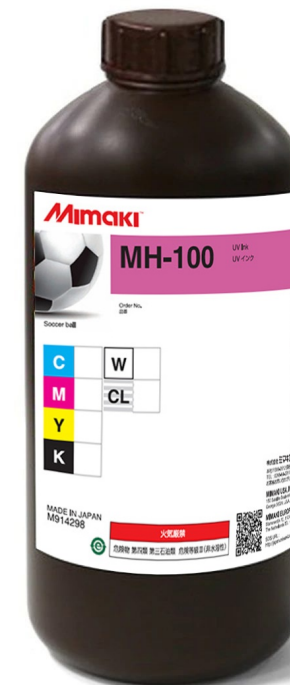


# Modeling Ink

- Modeling ink type: LED-UV
  - Color: MH-100 CMYK W Clear
  - Support material: SW-110 water-soluble<sup>\*1</sup>

Ink	Colours	Supply	Ink set							
			Head No. 1				Head No. 2			
MH-100 SW-110	CMYK W Cl SP	1000ml ink bottle	Y	M	C	K	Cl	SP	SP	W

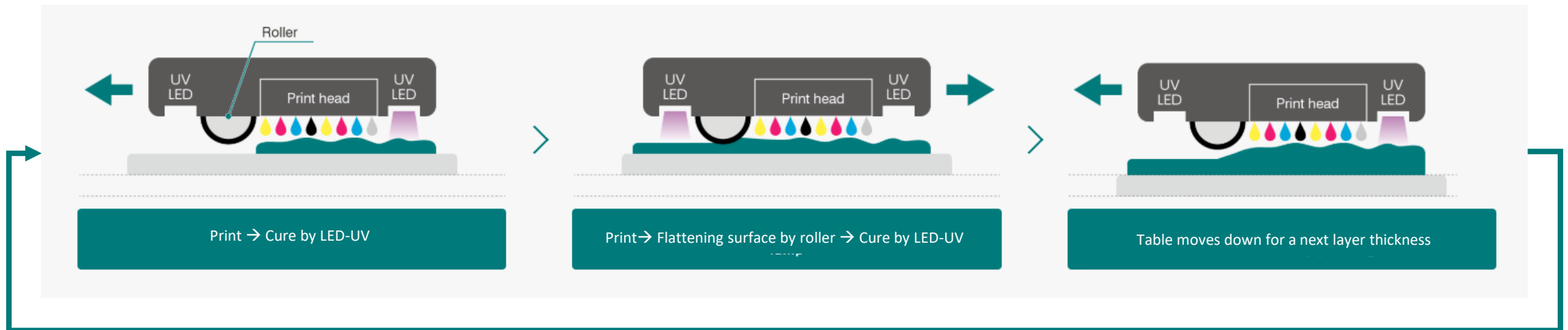
- Modeling ink supply
  - 1000ml bottle



\*1: Uncured waste material is classed as industrial waste and should be disposed of following local laws

## UV curing inkjet method

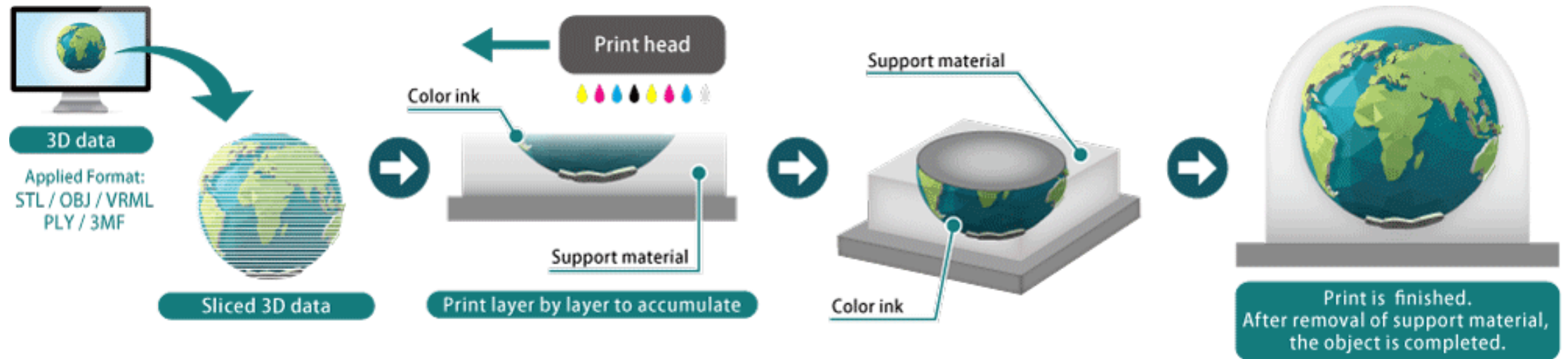
- 3DUJ-2207 performs the 3D-modeling by printing and curing UV ink layers.
- This method is producing full colored objects.
- Combining color, white and transparent inks allows you to produce a colored object with photorealistic high accuracy or with varying transparency.





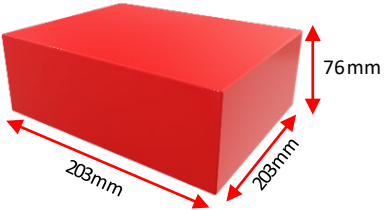
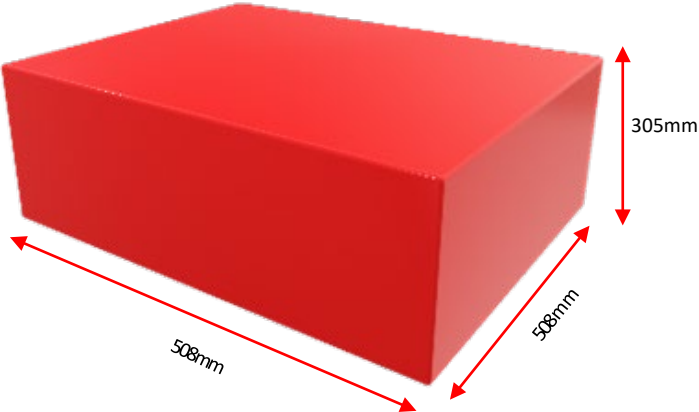


## Layering and coloring

- Modeling is done by a simultaneous print of sliced data of 3D object with color ink and support material



# Comparison to the 3DUJ-553

Item	3DUJ-2207	3DUJ-553
		
Dimension (W x D x H)	1,355 x 1,290 x 856 mm	2,250 x 1,500 x 1,550 mm
Modeling area (W x D x H)	<p>203 x 203 x 76 mm</p> 	<p>508 x 508 x 305 mm</p> 
Modeling time (193 x 193 x 71mm)	Layer thickness 28 $\mu$ m: 111hr	Layer thickness 32 $\mu$ m: 20hr Layer thickness 22 $\mu$ m: 27hr
Ink set	CMYK, White, Clear, Support	CMYK, Clear, Support
Ink supply capacity	1Ltr bottle	Color: 3Ltr tank White, Clear, Support: 5Ltr tank

## Features: Full Color

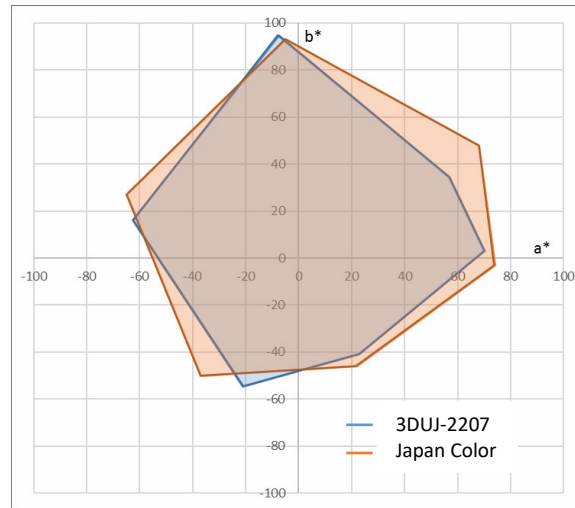
- Reach full color combinations of more than 10-million colors<sup>\*1</sup>
  - Color representation that cannot be realized with powder-based technology
  - Over 10-million colors for photorealistic high accuracy modeling
  
- Combining Mimaki technology with high-quality 3D printing
  - Mimaki's printing and ink technologies are used for high quality 3D printing solutions
  - Extremely fine details, precise line patterns and incredible real expression samples are possible



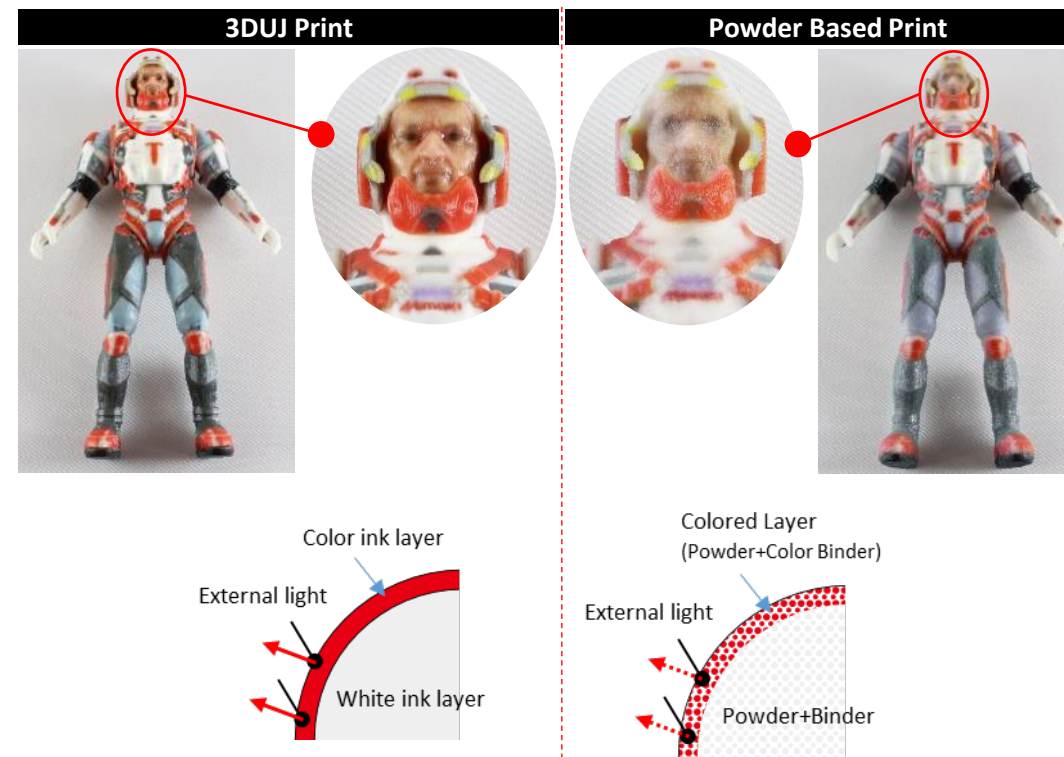
\*1: Based on Mimaki Japan survey of Feb. 2017

## Features: Full Color

- Mimaki 3D printer can realize approx. **89%** of Japan Color\*1



- Comparison with powder based printing



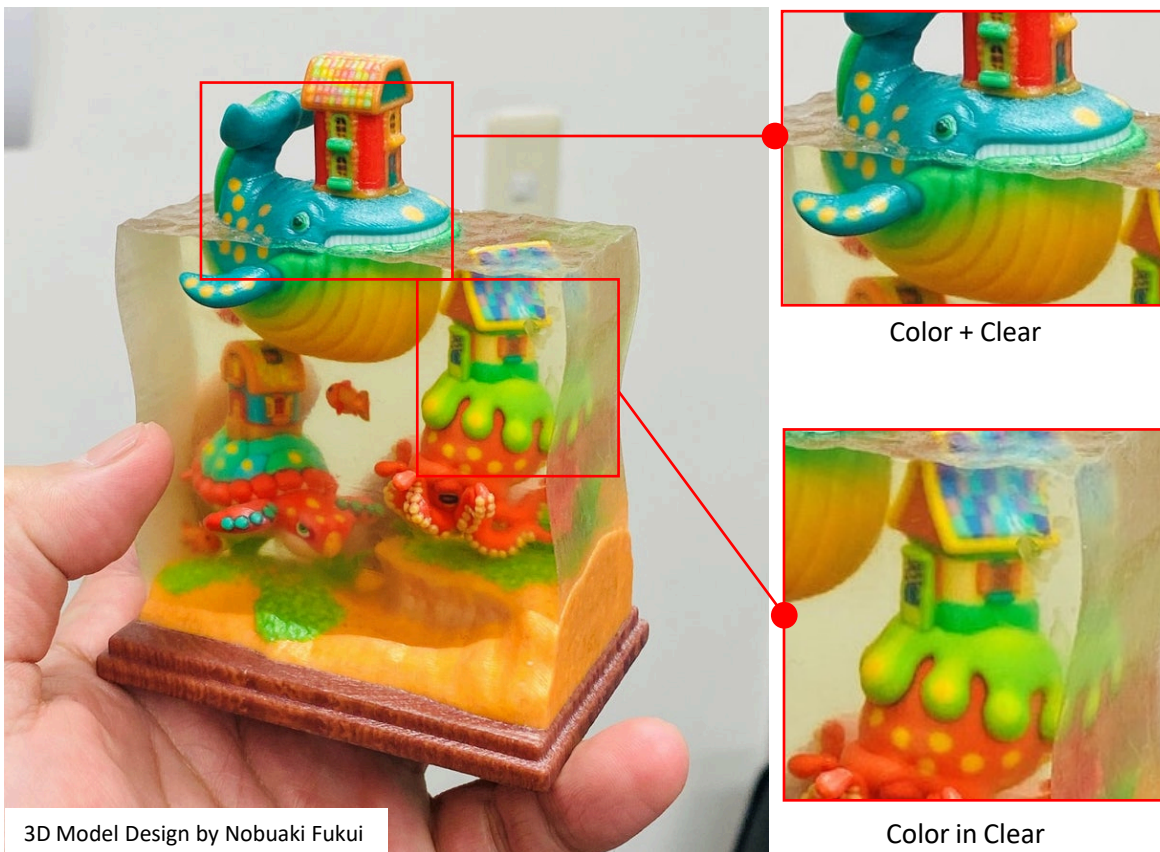
Produces smooth surfaces and fine details with layer thickness as fine as 28micron which cannot be produced by powder-based printers

The object becomes whitish as the powder appears on the surface

## Features: Clear ink

- Clear ink can be printed independently or combined with colored ink to create translucent objects

- Using clear ink adds an additional effect to 3D printed objects, especially if the object is illuminated.



Light OFF

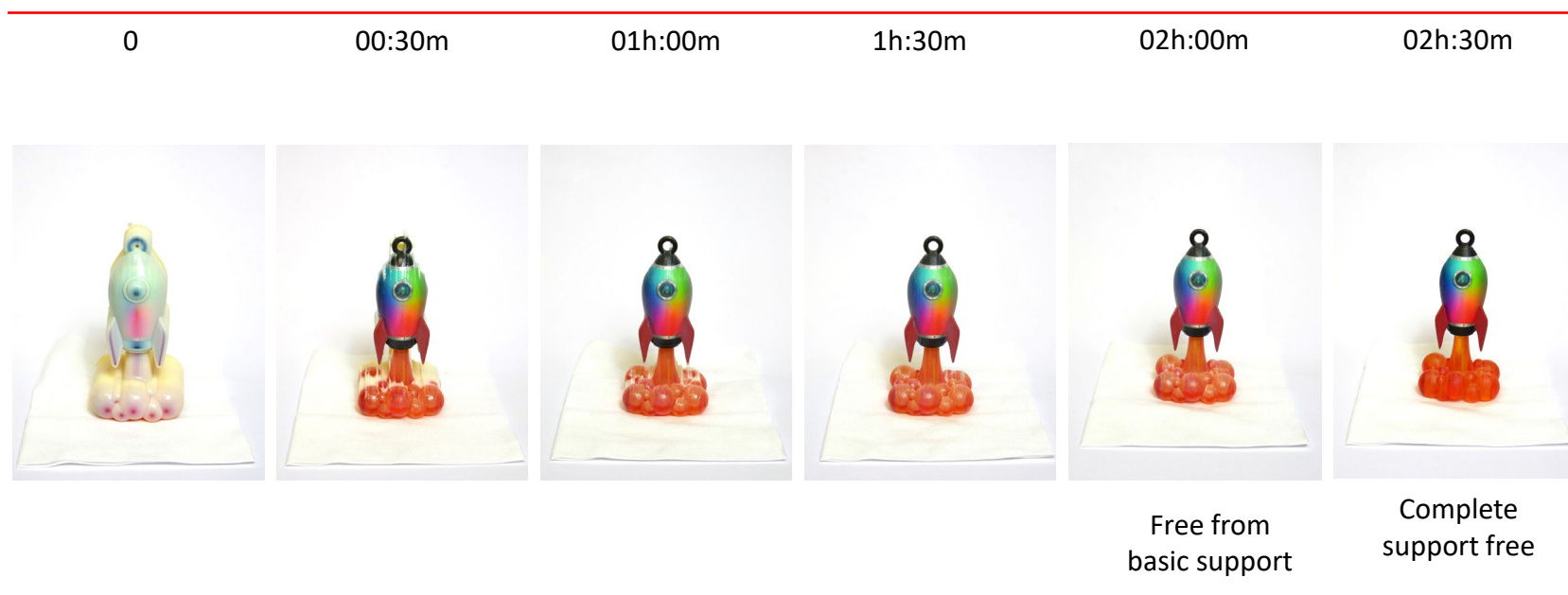


Light ON

## Features: Water-soluble support material

- Efficient removal of water-soluble\*<sup>1</sup> Support Material

- Easy to remove water-soluble support material
- Support material can be removed without any damage on the fine shape of modeled objects



**Condition:**  
 Used liquid: 100% water  
 Program: Program 2  
 Temperature: 35° C  
 Frequency: 90 RPM

- The timeline shown above is an example of removing the support material from the specific model by using the optional 3DCS-322 support removal unit

\* 1: Water used for removing support materials is classed as industrial waste and it is necessary to consign disposal to an industrial waste handler.  
 Leaving the object soaked for a long time after removing the support material may result in a negative effect on the object, such as change in color.  
 Note that the strength of an object is lower when it is still wet.

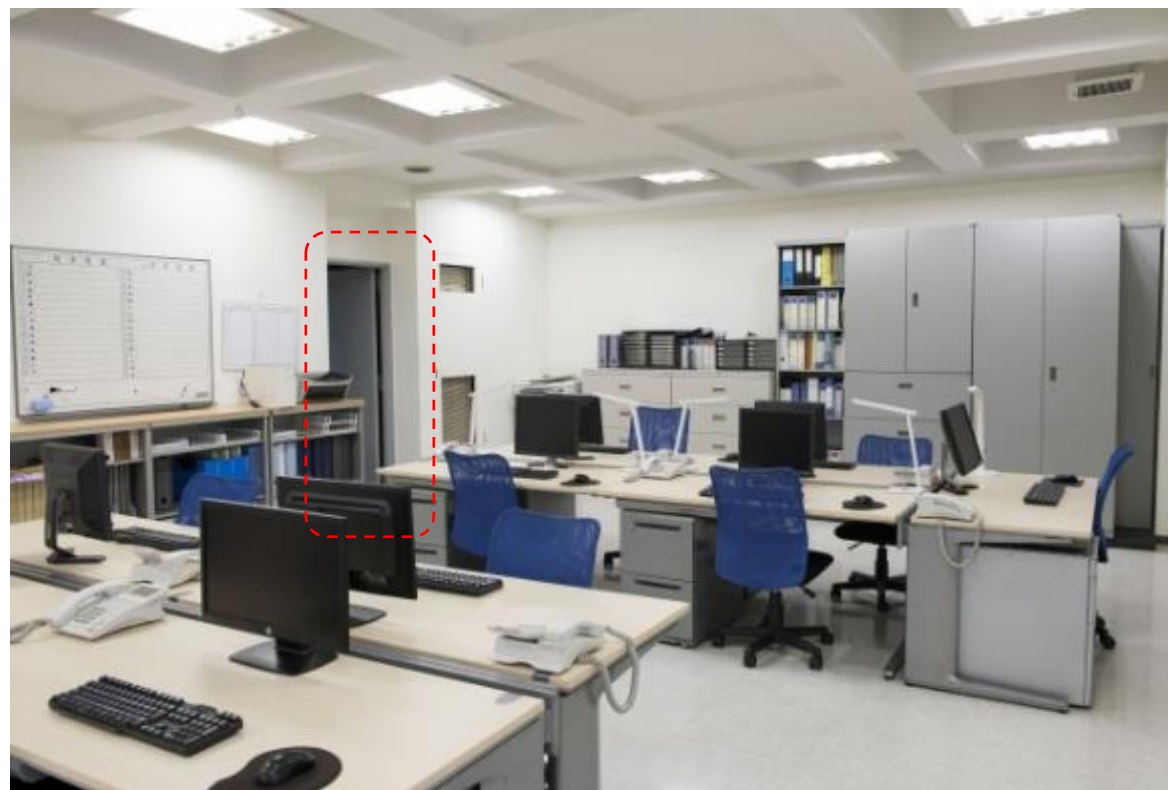
## Features: Compact design

- The 3DUJ-2207 has a compact design and small footprint making it possible to be loaded into an elevator or passing the standard office door without disassembling it
- When equipped with a quiet optional deodorizer, it is ideal for installation in office environments

Standard office elevator



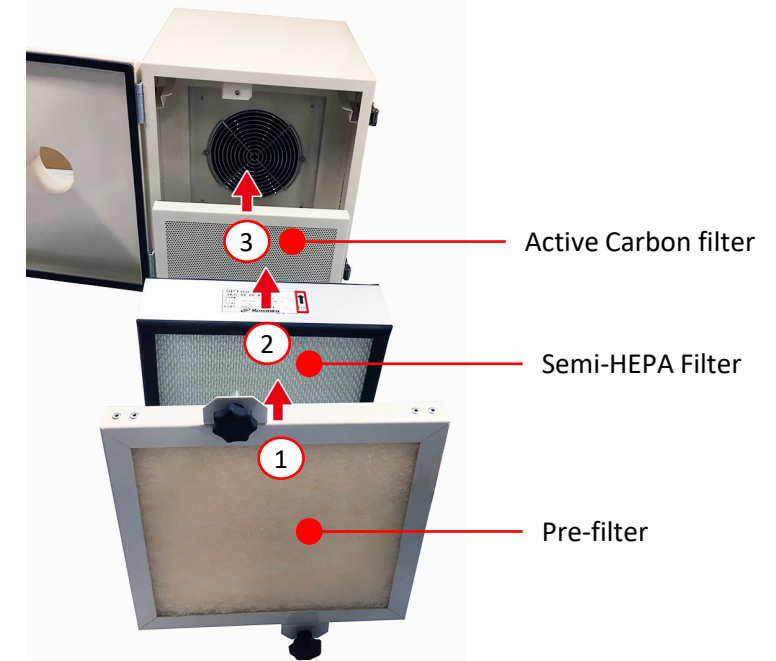
900mm wide office door



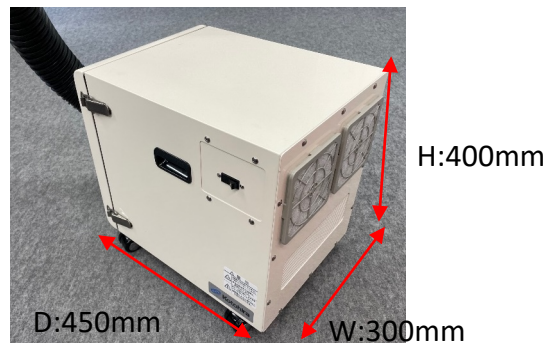
## Features: Usable in an office environment

- An optional deodorizing system is available as a quick and safe solution for using the 3DUJ-2207 in office environments

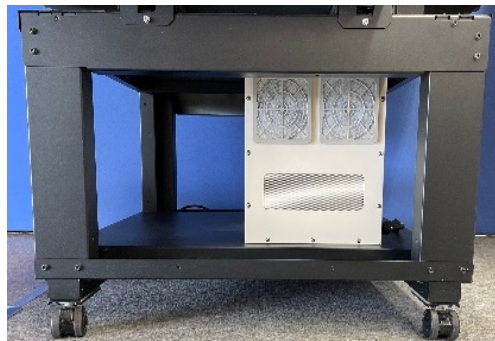
Item	Specification		Remark
Item nr.	OPT-J0515 Deodorizer		
Power supply	Single-phase 100-240 VAC, +/- 10%, 50/60 Hz +/-1 Hz		
Power consumption	120W or less		
Dimensions (WxDxH)	300x450x400mm		
Weight	16kg		
Air flow volume	3,5m <sup>3</sup> /h		
Air flow speed	13,2m/s		
Duct Diameter	75mm		
Noise	68db or less		
Filter	Pre-filter	1 <sup>st</sup> layer	90% removal of particles up to 10 micron
	Semi-HEPA filter*1	2 <sup>nd</sup> layer	95% removal of particles up to 0,3 micron
	Active Carbon filter	3 <sup>rd</sup> layer	Removal of odor and smell



OPT-J0515 as a standalone option



OPT-J0515 under optional installation stand OPT-J0524



\*1: Recommended filter change interval: every 2 months, or as soon as the odor becomes noticeable



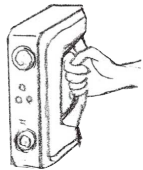
# 3D Process Workflow

## 3D Data Creation

3D modeling



3D Scan



3D Data Download



## 3D Data Correction

3D Error Correction  
Software Image



Error Check



## Layout



Layout



Color Settings

Group	Name	Color Mode
tubes		Color
body		Color
Clear_shell		Clear
heart		Color
logo		White
		Clear
		Skeleton color

## Modeling

*3DUJ-2207*

Modeling

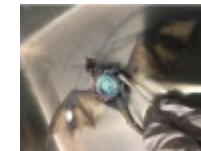


## Support Removal

Water Soluble  
Support Removal

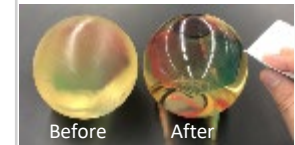


Dry after removal



## Post-processing

Polishing

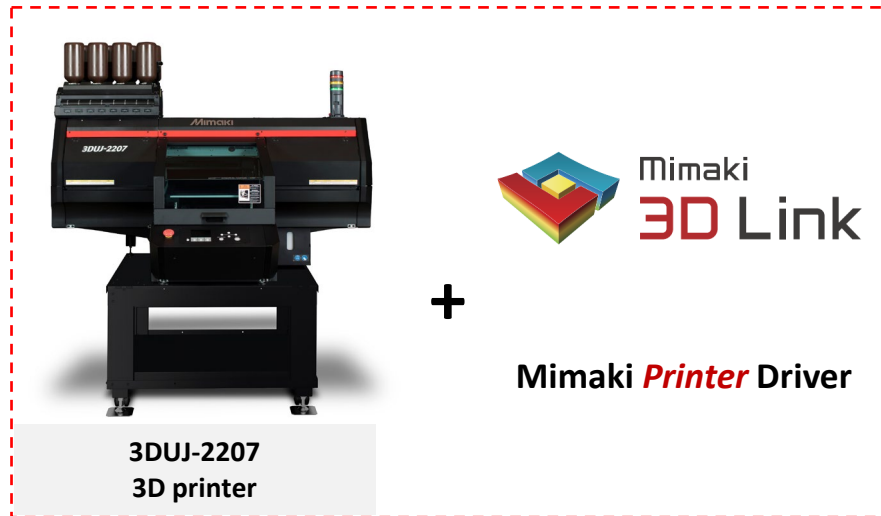


Top Coating

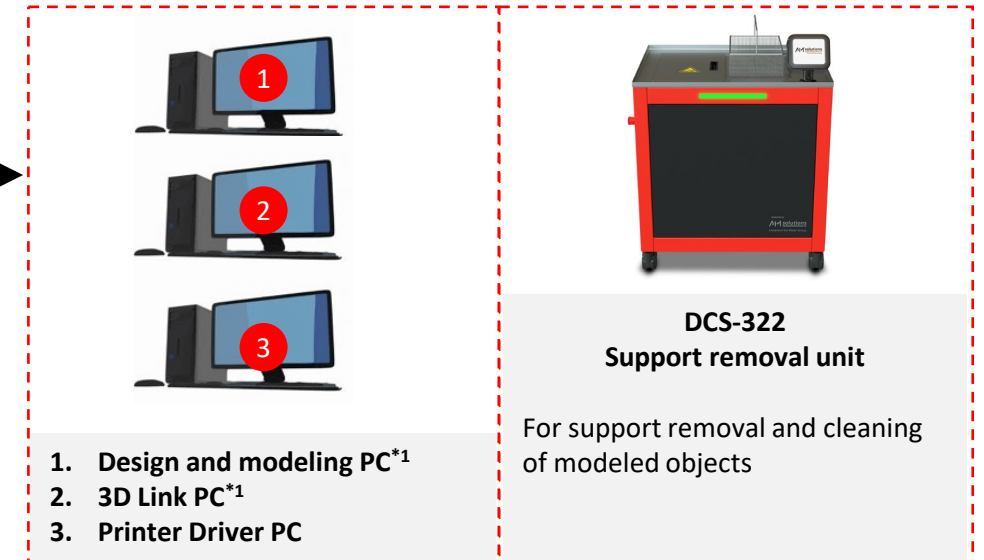


# System Configuration

## Standard configuration



## Prepared by customer



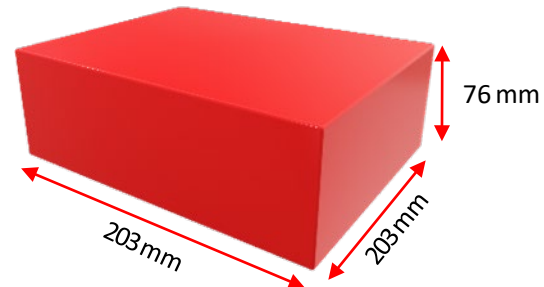
### OPTIONS

Installation Stand

Deodorizing Unit

Support Removal Unit

### Maximum Modeling Size



\*1: A single PC can control both the 3D design and the 3D Link software. The PC specifications must match the requirements needed to run both software. The PC specifications are listed in Appendix "[Recommended PC specification](#)".

# Features: 3D modeling software

- The 3D Link is an intuitive 3D modeling software that enables easy processing of the 3D models

## 1. Organize layout information on one screen

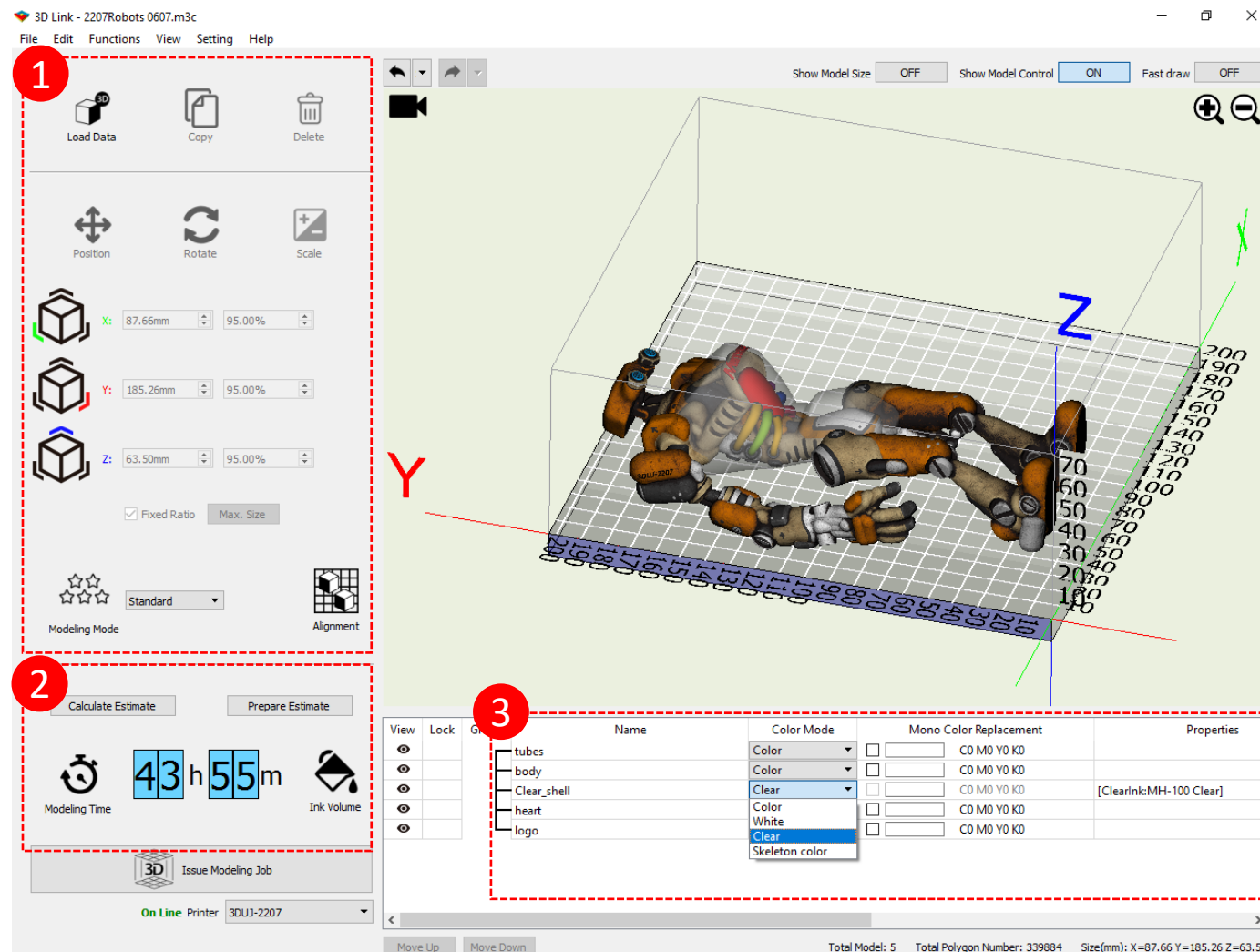
- Loading, copying and deleting data
- Move, rotate, zoom and align
- Select the shape mode

## 2. Estimate Calculation

- Easily calculate the build-up time and the required amount of ink
- The price of the ink unit can be set
- The information can be saved as a PDF/CSV file

## 3. Change the color on-the-fly

- 3D Link software also allows colors to be changed continuously
- Each part of 3D model can be independently colored into COLOR, WHITE, CLEAR or SKELETON COLOR



# Features: 3D processing software

- The Mimaki Printer Driver is a simple, yet effective output software for easy print of the 3D models

## 1. Organize layout information on one screen

- MODELING:** Information about the current processing models
- HISTORY:** A list of completed or deleted models
- SETTING:** Different settings for a modeling objects
- INFORMATION:** various software and printer info

## 2. Remaining ink

- Shows how much ink is left after the ink bottles have been installed

## 3. Data processing

- Various functions are available, such as IMPORT, DELETE and estimate the necessary printing time

3DUJ-2207 CU09B004 : Waiting

Modeling(4) History(35) Setting Information ?

Job No.	Job Name	Preview	Publisher	Reading Time	Modeling Time	Ink Total usage	
<input type="checkbox"/>	128	0426_new Test data_std		2021/07/07 17:16	13Hour10Minute s (Estimate)	369.64 cc (Estimate)	
<input type="checkbox"/>	133	2207_compare_Sample_table_yoko		2021/07/27 17:06	Not Calculated (Estimate)	Not Calculated	
<input type="checkbox"/>	134	2207_compare_Sample_table_yoko		2021/07/27 17:07	Not Calculated (Estimate)	Not Calculated	
<input type="checkbox"/>	137	2207Robots 0607		2021/08/09 12:48	44Hour16Minute s (Estimate)	1301.4 cc (Estimate)	

**Remaining Ink**

Yellow	200 cc
Magenta	450 cc
Cyan	190 cc
Black	210 cc
Clear	280 cc
Support	580 cc
Support	580 cc
White	550 cc
Dispo. Ink	528 cc

HDD remaining 93 %  
1,733GB / 1,862GB

Reset

Select Delete Job import Select Estimate

2021/08/09 13:15

# Productivity Samples\*1

No	Size (mm)			Name	Modeling time (hr:min)	Material consumption (cc)
	X	Y	Z			
1	41,7	135,5	22,2	Razor	11:31	136,68
2	66,3	120,8	66,3	Parfum Bottle	39:58	583,36
3	96,6	164,5	57,8	Game controller	40:13	802,38
4	69,0	150,0	69,0	Five-story high pagoda	41:37	656,80
5	88,0	190,0	32,1	Human body model	25:44	374,43
6	89,9	190,0	65,1	Robot	46:05	932,89



1



2



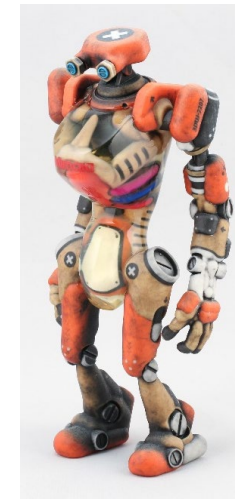
3



4



5



6

\*1: The results are based on the printout of one object per table. The result in the production environment may be different.

## Features: Remote monitoring

- Modeling process can be monitored remotely via the camera



3DUJ-2207



Built-in Camera



Modeling process monitored by camera

Internet

- Modeling process can be monitored from remote site by technical support or by operator

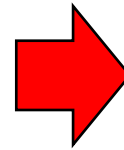
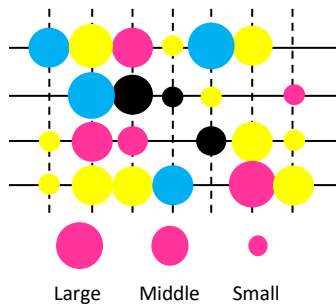


## Features: Variable dots

- Variable dots: Grainy appearance reduction system

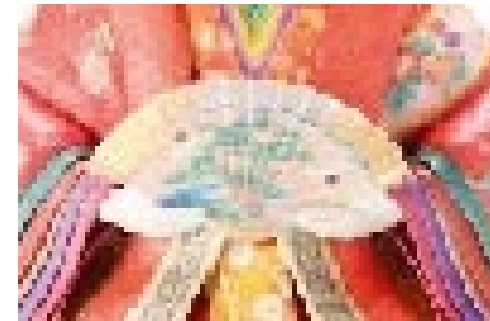
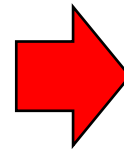
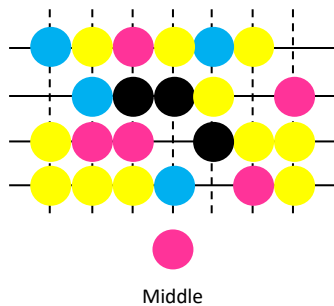
- To reduce a grainy appearance, the 3 most optimum dots are automatically selected, depending on the printing mode.
- Grainy appearance is also reduced by using the 1200x1200dpi high resolution printing mode available for building of high-quality objects

Variable dot



Smooth color modeling with high details

Fixed dot

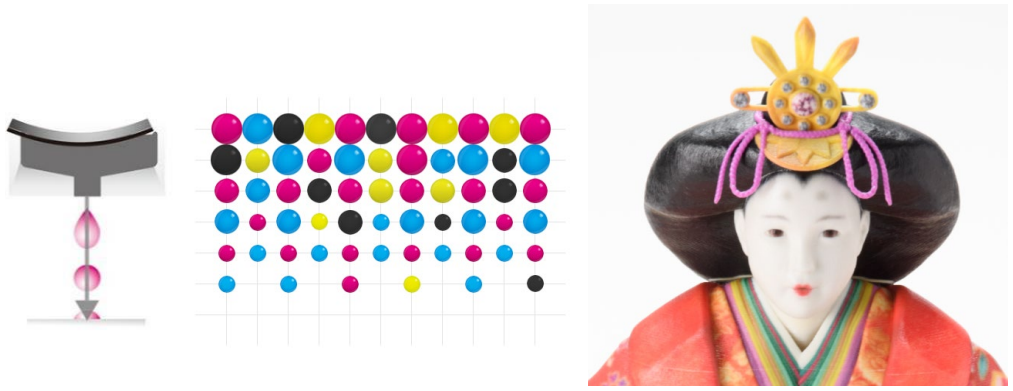


Grainy surface with low details

# Features: Waveform control

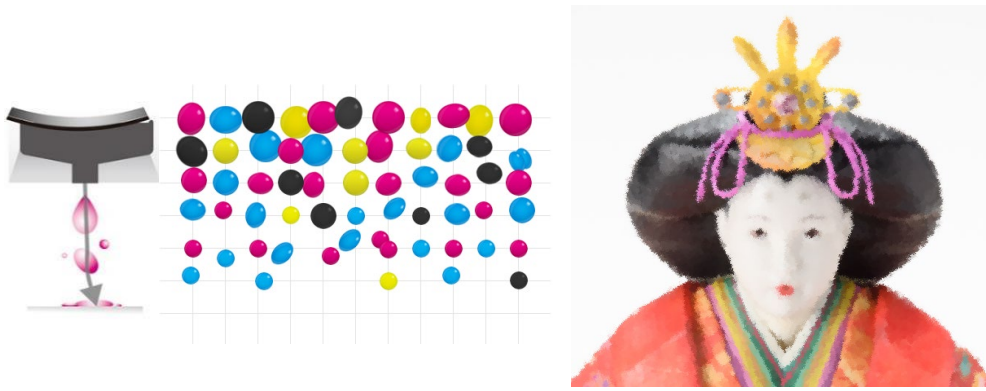
- Waveform control
  - It allows the print head to jet each ink droplet at an optimum angle and to maintain excellent ink droplet circularity
  - For accurate placement of ink drops

With waveform control  
Ink droplets jetted in as nearly perfect circles



High accuracy dot placement  
↓  
Sharp finish without grainy appearance

Ink droplets jetted in as deformed circles

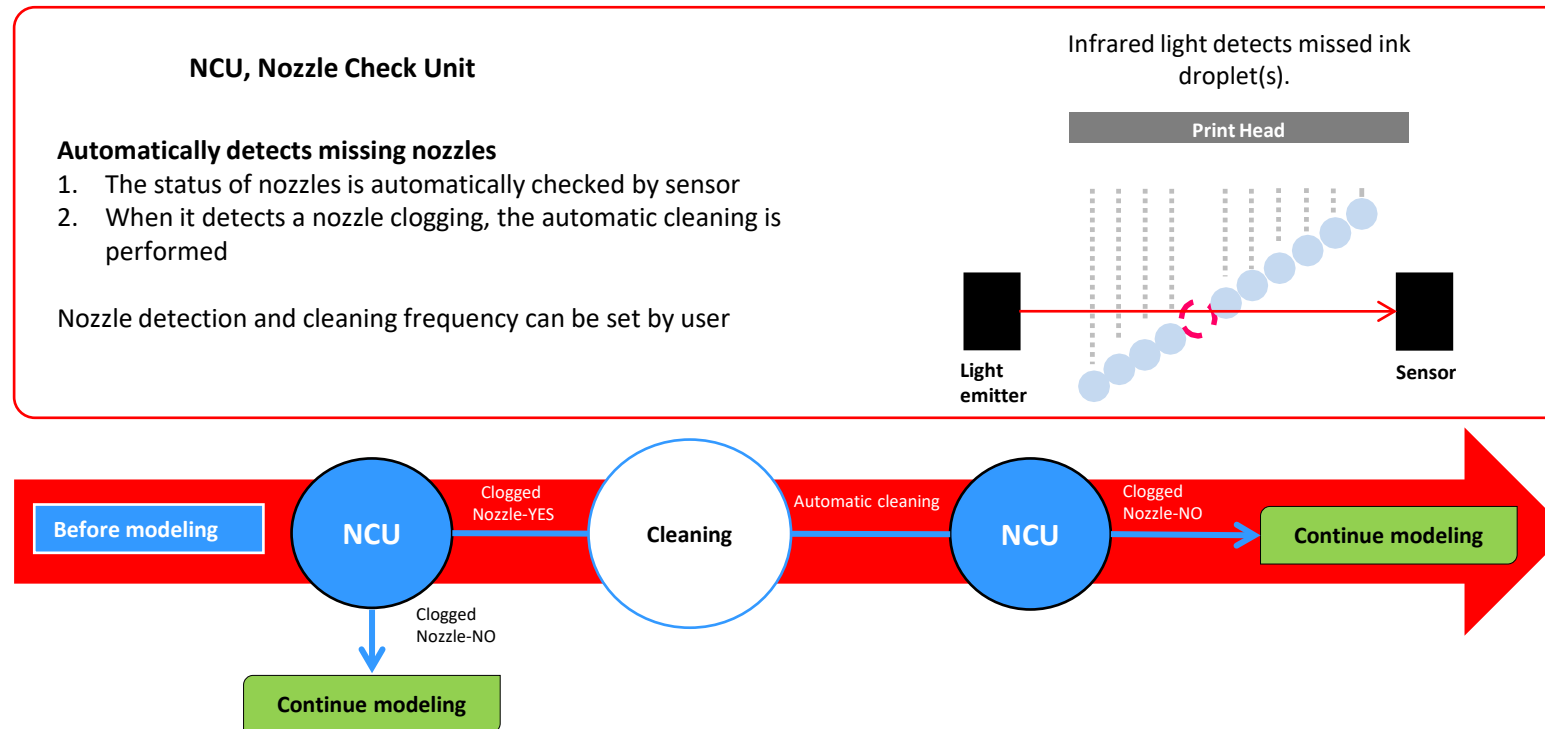


Ink dots overlap  
↓  
Grainy appearance with blurred edge



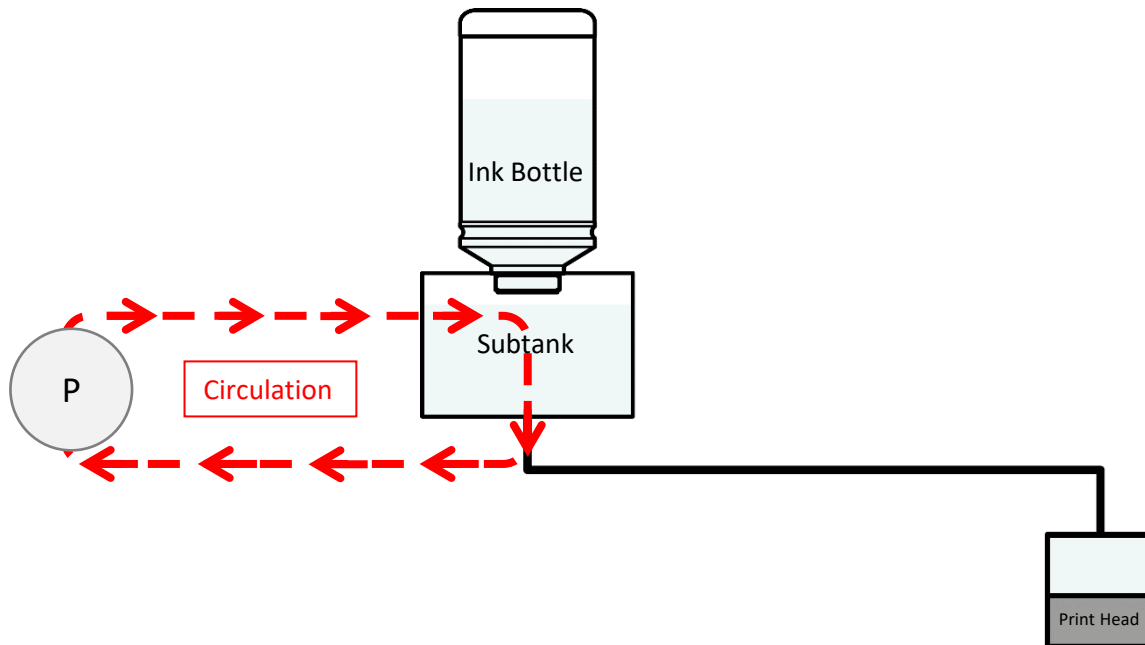
## Features: Automatic maintenance

- Continuous printing with automatic maintenance
  - NCU (*Nozzle Check Unit*) automatically checks the nozzle condition
  - When there are missing nozzles, they will be automatically cleaned
  - If they are still missing after cleaning, the modeling will continue, so there is no need to wait for a service intervention

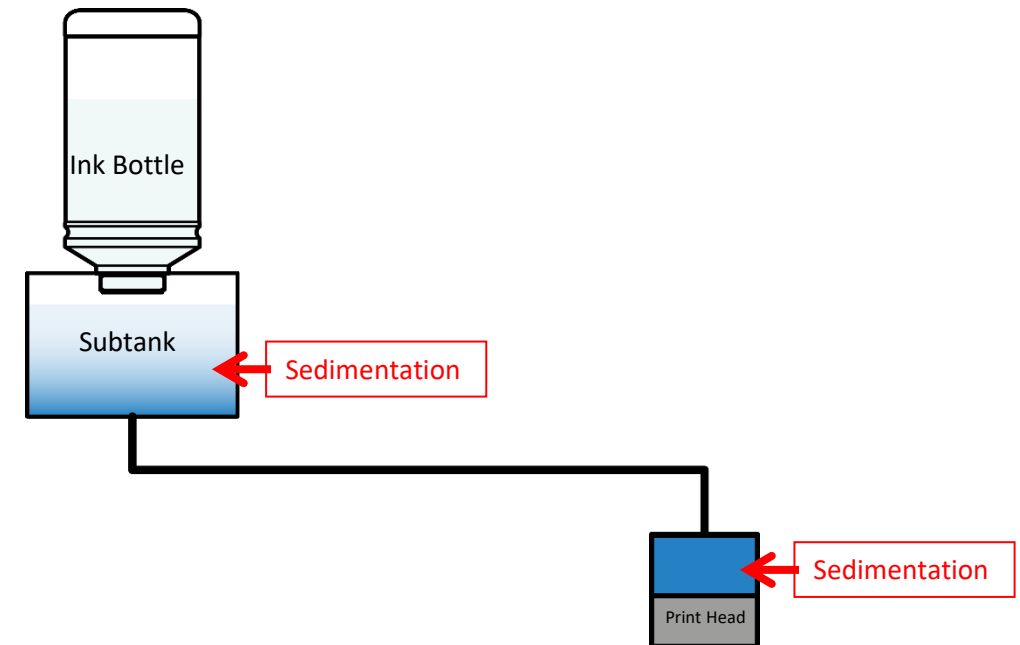


## Features: Uninterrupted printing solution

- MTC (*Mimaki Circulation Technology*) is a white ink circulation for continuous ink stability
  - Prevents pigment sedimentation by periodically circulating the white ink in the subtank
  - The white ink circulation feature accomplishes stable production and reduction of ink discharge and waste



Ink supply 3DUJ-2207: White ink circulation system

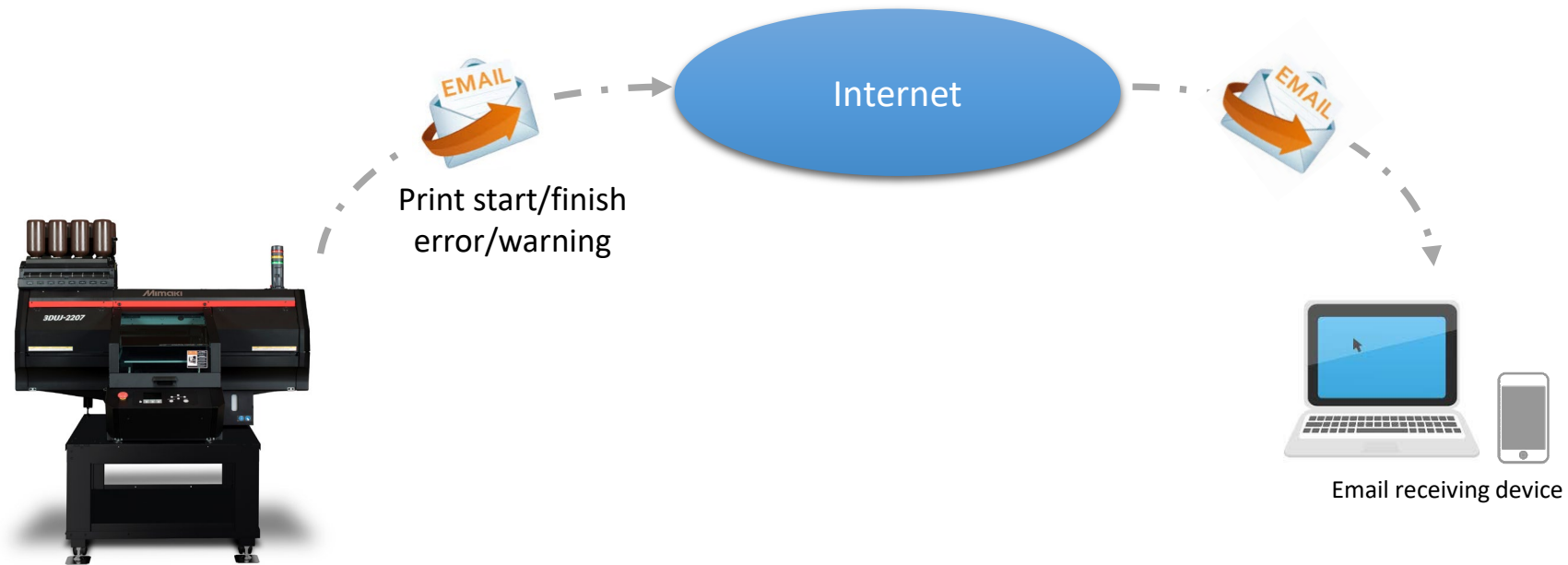


Genuine ink supply: No white ink circulation system

## Features: Event mail

- Event mail

- Status of the printer can be sent from the printer to a mobile phone via the Internet
- For remote status indication of the printer



## Postprocessing: Removal of support materials

- **Optional 3DCS-322 Support Removal Unit**
  - Utilizes proprietary software program and Mimaki-specific designed hardware
  - Agitated flow effectively removes supports with a 'sink-float' process to rotate parts throughout the chamber
  - Motion controlled by software ensures parts are not damaged and removal of supports is consistent
  - Variable motion with optimal energy delivery, and detergent flow results in fast and uniform support removal without residual film
- **Complete post-process solution**
  - Including software, hardware, and washing resin
- **Optional washing resin to optimize the cleaning process**
  - Washing resin RAM-D1 is a pre-mixed detergent that optimizes the removal of supports while leaving the build material in perfect condition.
- **Waste material**
  - Uncured waste material is classed as industrial waste and should be disposed of following local laws
    - Washing resin and support
    - Any waste water and liquids



## Postprocessing: Finishing

Excellent different post-process such as overcoating, and drilling are possible.

- The ink is an acrylic resin type and has the same strength as ABS, making it possible to drill holes and fix screws.
- In addition, the overcoating can be applied, making it possible to finish the product with a different look.

- It has enough strength to withstand 5kg of pulling force when screwed tight.



Before



After

Overcoated object



Drilling



Tapping and drilling

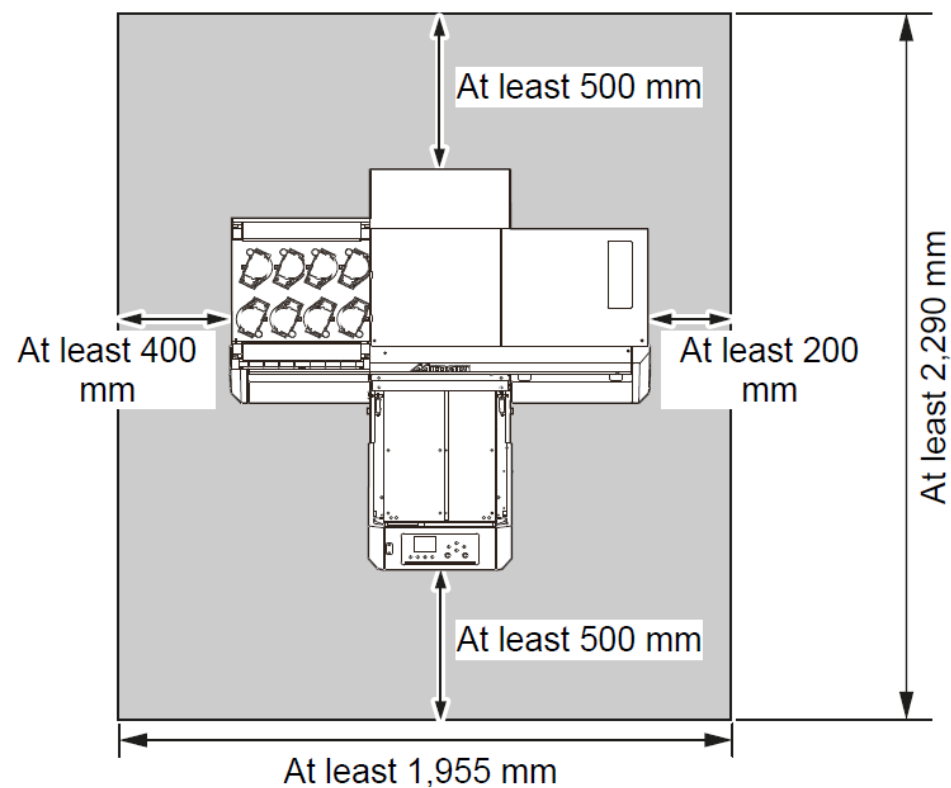


5 kg loading

Drilled object

# Installation space

Machine	Outer dimension	Width	Depth	Height	Weight
3DUJ-2207	Packed	1,500mm	1,150mm	1,120mm	185kg
	Installed	1,355mm	1,290mm	856mm	140kg



- About installation space
  - Do not install on the weak surface floor.
  - Environmental temperature must be 15° to 35 °C
  - Relative humidity must be 35% to 65% Rh
  - Dust level must be less than 0,15mg/m<sup>3</sup>
- Do not install on carpets etc.
  - because those are easy to be charged, and it can affect the image quality.
- Generates ink odor
  - Please use the machine in a well-ventilated environment.
- Use the foot base
  - in order to prevent floor deformation

# Specification

Item		Details
Print head	Type	On-demand piezo head
	Specifications	Two inline heads with 420 rows × 4 rows each
	Resolution	Y: 1,200 dpi X: 1,200 dpi
Ink set	4-color, W, CL, SP	C, M, Y, K, W, CL, SP
Model specifications	Available model size	(W) 203 mm × (D) 203 mm × (H) 76 mm
	Weight	3 kg or less
Distance accuracy	Absolute accuracy	±0.3 mm or ±0.3 % of specified distance, whichever is greater
	Repeatability	±0.2mm or ±0.1% of specified distance, whichever is greater
Perpendicularity		±0.3mm/400mm
Built-in camera		1
Head collision prevention		Laser sensor detection (Class 1)
Ink supply		Ink bottle 1Ltr
Waste ink tank		Bottle type (1,600ml)
UV unit		2 x Air-cooled LED UV units
Interface	Data transfer function	Ethernet 1,000BASE-T
	Email function	Ethernet 10BASE-T/100BASE-TX/1000BASE-T
Commands		MRL-V (MAPS4 compatible)
Noise levels	During standby	Not more than 55 dB (FAST-A, 1 m on all sides)
	Continuous operation	Not more than 65 dB
	Non-continuous operation	Not more than 70 dB
Compliance with standards		VCCI Class A, FCC Class A, IEC 62368-1 ETL compliance, CE marking (EMC Directive, Low Voltage Directive, Machinery Directive, RoHS), CB certified, EAC marking, RCM marking
Power supply specifications		Single phase 100 – 240 V AC ± 10 %, 50/60 Hz ± 1 Hz
Power consumption	Maximum	350 W (500 W when an optional deodorizer is used)
Installation environment	Environment temperature	20 °C to 30 °C
	Relative humidity	35 to 65 %RH (no condensation)
	Temperature range at which accuracy is guaranteed	20 °C to 25°C
Body external dimensions <sup>*1</sup>		1,355 x 1,290 x 856mm
Body weight		140kg

\*1: Standalone machine, excl. ink bottles, optional dedicated stand and deodorizer

## Appendix

- Inks
- Consumables
- Options
- PC specification requirements
- FAQs



## Supply items: inks

Part No.	Description	Volume	Packaging	Remarks
MH100-x-BA	3D MODEL INK MH-100 1L BOTTLE	1,000ml	Bottle	M, C, Y, K, W, Cl
SW110-Z-BA	3D SUPPORT INK SW-110 1LL BOTTLE	1,000ml		SP

# Supply items: consumables

Part No.	Description	Volume	Packaging	Remarks
RAM-D1	Support Removal Liquid	10L	10L Tank	Liquid for 3CDS-322 support removal unit
SPC-0569	F-200/LF-200 CLEANING KIT	100ml x 2	100ml bottlex2	Daily maintenance kit
SPC-0527	Clean stick around the head		50 pcs	Cleaning of the Cap, wiper, bottom of the carriage, NCU
SPC-0387	UV Goggle		1 pce	
A101438	Cotton Swabs		1000pcs	
SPC-0838	Plastic Card		20pcs	Cleaning the roller unit
SPC-0499	KIM TOWEL		50 pcs	
SPC-0574	MAINTENANCE CLOTH		150 sheets	
SPC-0843	Wiper Kit		10pcs	
SPC-0820	Filter set for bottle wiping		4pcs	
SPC-0876	Cap absorber set		1pce	
SPA-0316	Absorbent Sponge		1pce	Sponge only for SPC-0876
SPC-0842	Cap ASSY		1pce	
SPC-0819	MIST FILTER SET		Large: 2 sheets, Small: 10 sheets	
SPA-0319	Cap B Assy v2		8pcs	
SPA-0302	INK receiving pan ASSY		1 pce	
SPA-0290	LED GLASS		2 pcs	
SPC-0837	Scraper		1pce	
SPC-0839	Scraper Blade		1pce	
SPC-0896	Exhaust Unit Filter A		1 set	Filters for OPT-J0515
SPC-0897	Exhaust Unit Filter B		1pce	Active Carbon filter for OPT-J0515

## Supply items: optional items

Part No.	Description	Remarks
OPT-J0524	Installation Stand	Use of the optional stand is strongly recommended in order to assure the print quality
OPT-J0515	Deodorizing Unit	Optional deodorizing unit for office use
3DCS-322	Support Removal Unit	Recommended option for removal of support material

# Recommended PC specification

Item		Requirements	Notes
OS	Edition	Windows 10 Pro or Windows 10 Enterprise, 64-bit	
	Version	1809 or higher	Windows 10 October 2018 Update or later
CPU	Performance Indicators	Intel® Core™ i7-8700 3.2GHz or equivalent or higher	
	RAM (Memory)	32.0 GB or more	
	Speed	3.19 GHz or higher	Equivalent to or faster than Intel® Core™ i7-8700 3.2GHz
	Cores	6 or higher	Equivalent to or faster than Intel® Core™ i7-8700 3.2GHz
	Number of logical processors	12 or higher	Equivalent to or greater than Intel® Core™ i7-8700 3.2GHz
Graphics Board	Performance Indicators	NVIDIA Quadro RTX4000 or equivalent	
	Size	There is enough space in the PC to install a graphics board.	The required GPUs dimension is larger than typical GPUs
	Number of CUDA cores	2304 or higher	Equivalent or better to NVIDIA Quadro RTX4000
	VRAM (memory)	8 GB or more	Equivalent or better to NVIDIA Quadro RTX4000
	Open GL	Compatible with OpenGL 4.x	Equal to or higher than NVIDIA Quadro RTX4000
Power Supply Unit Capacity		500W or more	
USB		3 x USB2.0 or more	Required for mouse, keyboard, and USB camera
Ethernet LAN		2 x LAN ports with 1000BASE-T standard or more	Required for printer connection and external network connection. Can be expanded with a USB to LAN conversion adapter.
Hard Disk	Capacity	1 TB or more	
	C Drive Free Space	500 GB or more	Printer Driver, 3D Link, Team Viewer, etc. together are about 1.2 GB. 500MB (large m3c file) x 600 (items) = 300 GB. 100 GB of temporary files for full-size modeling.
Display	Resolution	Full HD (1920x1080)	24-inch or larger is recommended

	Question	Answer
1	Does the 3DUJ-2207 have an internal tank like the 553? What happens if the ink bottle is empty during molding?	There is no built-in tank. If the ink bottle becomes empty during modeling, modeling will pause. You can resume modeling after replacing the bottle. If the downtime is long, layer lines on the modelled object may be noticeable.
2	Does 3DUJ-2207 have NRS (Nozzle Recovery System)?	There is no NRS on the 3DUJ-2207.
3	Is antifreeze, which was a supply item for 3DUJ-553, unnecessary?	It is not necessary because it is not a water-cooled LED-UV curing unit but an air-cooled LED-UV curing unit.
4	Is the 3DUJ-2207 user site available?	The same user site will be redesigned as the "3DUJ series user site".
5	Is it possible to print 3DUJ-2207 by placing media on it like UJF-3042Mk II?	The table vacuum is also not equipped, but the machine is also not designed for 2D printing.
6	Is there a possibility to increase the molding modes in the future?	We are considering it.
7	How is the color and modeling quality of 3DUJ-2207 compared to 3DUJ-553?	The same 3D data will have different colors due to difference in machine construction and heads specification. The layer height is thicker: 3DUJ-2207 "Standard mode 28 $\mu$ m" compared to 3DUJ-553 "High-definition mode 22 $\mu$ m". However, the resolution in XY direction is higher than the 3DUJ-553 so the result might feel better.
8	How is the modeling speed of 3DUJ-2207 compared to 3DUJ-553?	The 2207 is slower than 3DUJ-553. The speed depends on the modeling conditions such as shape and layout. <ul style="list-style-type: none"> <li>3DUJ-2207 standard mode is about 5 to 6 times slower than 3DUJ-553 standard mode.</li> <li>Comparing with the 3DUJ-553 high-definition mode, the 3DUJ-2207 standard mode is about 4 times slower.</li> </ul> This is just a reference value and will vary depending on the shape and placement method. If you have specific data, please check with 3D Link.
9	What is the heads arrangement in the 3DUJ-553 and 3DUJ-2207?	3DUJ-553: 1 head (2 nozzle rows) x 8 heads, in-line configuration 3DUJ-2207: 1 head (4 nozzle rows) x 2 heads, in-line configuration
10	With the NCU function, nozzle check and cleaning (when missed nozzles are found) are performed at intervals of 60 minutes. But if the auto cleaning function is also ON, when will it be performed?	The "Nozzle check timing by NCU" is carried out after a 30-minute of "cleaning operation of auto cleaning".

	Question	Answer
11	Can I use the ".m3c" file that I used for 3DUJ-553 also with 3DUJ-2207?	The .m3c file for 3DUJ-553 cannot be read as it is into the Printer Driver of 3DUJ-2207 and modeled. However, the .m3c file for 3DUJ-553 can be opened with 3D Link for 3DUJ-2207 to reset the layout etc.
12	Do I need a special installation stand?	Although it is not required, we strongly recommend using a special installation stand because it is necessary to make "leveling adjustments" when installing the machine. Moreover, the stand must be stable enough to prevent vibration during modeling.
13	Is it possible to use 3DUJ-553 ink for 3DUJ-2207?	C, M, Y, and K can be used together because they are the same part number bottles. W, CI, SP are 4.8L bottles and cannot be used with 3DUJ-2207 (1L bottle specification).
14	I am not familiar with the setting conditions and know-how of modeling.	Please refer to the Application Note (attached) for know-how and techniques as 3DUJ series.
15	Please give me some more information about filter replacement for the deodorizer option.	The "pre-filter and semi-HEPA filter" remove particles in the exhaust. The "activated carbon filter" removes odor components in the exhaust. →If you feel that the exhaust flow rate is decreasing, replace the pre-filter and semi-HEPA filter. →When you feel that the exhaust flow rate is not decreasing, replace the pre-filter and semi-HEPA filter. When the exhaust flow rate does not decrease, but the smell is noticeable, replace the activated carbon filter.
16	When using multiple 3DUJ-2207s, is it possible to connect and operate multiple 3DUJ-2207s with one Printer Driver PC?	No. Only one 3DUJ-2207 can be operated with one Printer Driver PC. If you want to run multiple machines at the same time, you will need the same number of Printer Driver PCs as the number of machines.
17	What is the height of the 3DUJ-2207 including the installation stand?	The height of the installation platform is approximately 520mm. (There is an error due to the height adjustment by the level foot.) The machine height of 856mm is without the attached ink bottles. Therefore, the height of the unit is approximately 1,570 mm when it is in operation on the installation platform.
18	When loading two data, why is the estimated ink usage different when arranging them in the X and Y directions?	In addition to the ink used for the model, ink is consumed during modeling due to flushing operations. Therefore, the ink consumption tends to increase as the modeling time increases by changing the arrangement.
19	Is there any difference in the properties of the water (tap water) used to remove the support material, such as "soft water or hard water", depending on the country?	Any type of water works fine.
20	It is difficult to understand the dB unit of the machine and deodorizer, is there any standard for noise?	As a reference: 50dB: quiet office, 60dB: car idling, and 70dB: vacuum cleaner.

## FAQ3

	Question	Answer
21	What happens if I use it outside the recommended temperature range in the installation environment?	There is a risk of reduced print heads stability in environments outside the recommended temperature range.
22	Why is the standard USB cable 1m?	This is because the USB signal may be reduced if the cable is 1 m or longer. When extending, we recommend "2.0 or higher USB cable with repeater".
23	How much faster is the removal time when the support material is removed using an ultrasonic cleaning tank than without ultrasonic cleaning?	Checking reference values (scheduled to be updated in September)

