






Operation/Task:	Large Format			Equipment:	Bronco – Sheet Fed
Owner: Digital Manager	Large Format Print	Date Created: 11/1/25 Revision History:	See last page	Department: Digital	

ALERTS (see below): Critical Step  Quality Check  Tip  Team Safety 

Purpose: This SOP/work instruction describes the process of printing Sheets on the large format

Step #	Alerts	Step Description - “What to Do”	“How to Do it”	“Why to Do it”
1		Safety	<ul style="list-style-type: none"> • Wear required PPE: <ul style="list-style-type: none"> ◦ Gloves (when handling ink or cleaning fluids) • Keep hands clear of carriage and moving gantry • Do not bypass safety interlocks • Be aware of UV curing lamps (avoid direct exposure) • Ensure proper ventilation in print area 	Preventing Injury / toxic exposure

2	☺	Pre Op Checks	<ol style="list-style-type: none"> 1. Power On <ul style="list-style-type: none"> ○ Turn on main power and system control ○ Launch printer interface software 2. Visual Inspection <ul style="list-style-type: none"> ○ Check for debris on table ○ Ensure no obstructions on gantry path 3. Ink Levels <ul style="list-style-type: none"> ○ Verify sufficient ink levels ○ Replace or refill if needed 4. Vacuum System <ul style="list-style-type: none"> ○ Turn on vacuum zones ○ Confirm proper suction 5. Printheads <ul style="list-style-type: none"> ○ Perform nozzle check ○ Clean printheads if necessary 6. Environment <ul style="list-style-type: none"> ○ Confirm temperature and humidity within recommended range (65-75 deg, 40-60 % humidity ideal) 	Basic requirements to Ensure successful operation
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3	◆	Material Prep	<ul style="list-style-type: none"> • Ensure sheets are: <ul style="list-style-type: none"> ○ Flat and not warped ○ Free of dust, oil, or debris • Wipe surface if necessary • Confirm material thickness does not exceed machine limits • Load sheet square to alignment guides 	Ensures successful quality / avoid head crashes
4	◆	Loading Sheet	<ol style="list-style-type: none"> 1. Place sheet onto feed table 2. Align with registration pins or guides 3. Ensure entire front edge of sheet is pressed against the set bar 4. Activate appropriate vacuum zones 5. Confirm sheet is secure and flat 	Ensures a correctly aligned print / ensures consistency among all sheets
5	◆	Setup	<ol style="list-style-type: none"> 1. Load job file into RIP software 2. Select correct: <ul style="list-style-type: none"> ○ Media profile ○ Resolution ○ Pass mode 3. Set sheet layout origin point on press (default 0,0) 4. Adjust print height (carriage height) according to material thickness 5. Perform test print if required 	To make sure that the parameters of the operation match the job description

6	◆	Print	<ol style="list-style-type: none"> 1. Send job from RIP to printer 2. Confirm job settings on control panel 3. Send Job from the Ready que to the Print que by checking the box to the left and clicking the plus symbol at the bottom of the que 4. Within the Print que, engage the press by pressing the play button in the upper left corner of the tab 5. After the belt in engaged and the set bar drops down, of the 3 pedals, press the right pedal on the foot pedal panel to start the print. 6. Monitor: <ul style="list-style-type: none"> ○ Ink laydown ○ Registration ○ Banding or defects 7. Stop job if issues occur 8. If in continuous print mode, feed the next sheet once the set bar drops down again. 9. Carefully remove printed sheets as they exit the belt onto the receiving table rollers 10. Continue until job is complete 	This is the actual print production process.
7	☑	Quality Check	<ul style="list-style-type: none"> • Inspect print for: <ul style="list-style-type: none"> ○ Color accuracy ○ Adhesion ○ Banding or streaking • Reprint if necessary 	Quality Control

Notes: 😊

Routine Maintenance

Daily:

- Clean table surface
- Wipe printheads (if needed) & perform Test Print + Jet Test if necessary
- Empty waste containers

Weekly:

- Perform deep cleaning cycle
- Inspect vacuum filters

Monthly:

- Inspect belts and rails
- Check UV lamp performance

Troubleshooting (Basic)

- **Banding:** Run nozzle check and clean heads
- **Poor adhesion:** Verify substrate compatibility and curing
- **Media shifting:** Increase vacuum or check flatness
- **Ink not curing:** Inspect UV lamps

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1. Only use manufacturer-approved inks and materials
 2. Do not exceed maximum substrate thickness
 3. Report recurring issues to maintenance immediately

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Definitions:

Revision History	Description of Changes	Requested by	Date
Rev 1	First posting to intranet	Digital Manager	3/2026

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