

# Hitachi GEN3 Print Head Recovery Quick Guide

## Step 1. Reverse Flush the print head

If you have a Reverse Flushing cap, set up your print head for reverse flushing as shown on the picture in this document. If you don't have RF Cap, use a suction method of reverse flushing as shown here. Run Syphon cycle. After it's completed, set up your print head for Forward Flushing and run it with Syphon cycle again. Use fluid # 1X for solvent print heads, or 1UV for UV ones. Temperature can be 30°-35°C. Do not exceed Max Temperature indicated on the picture.

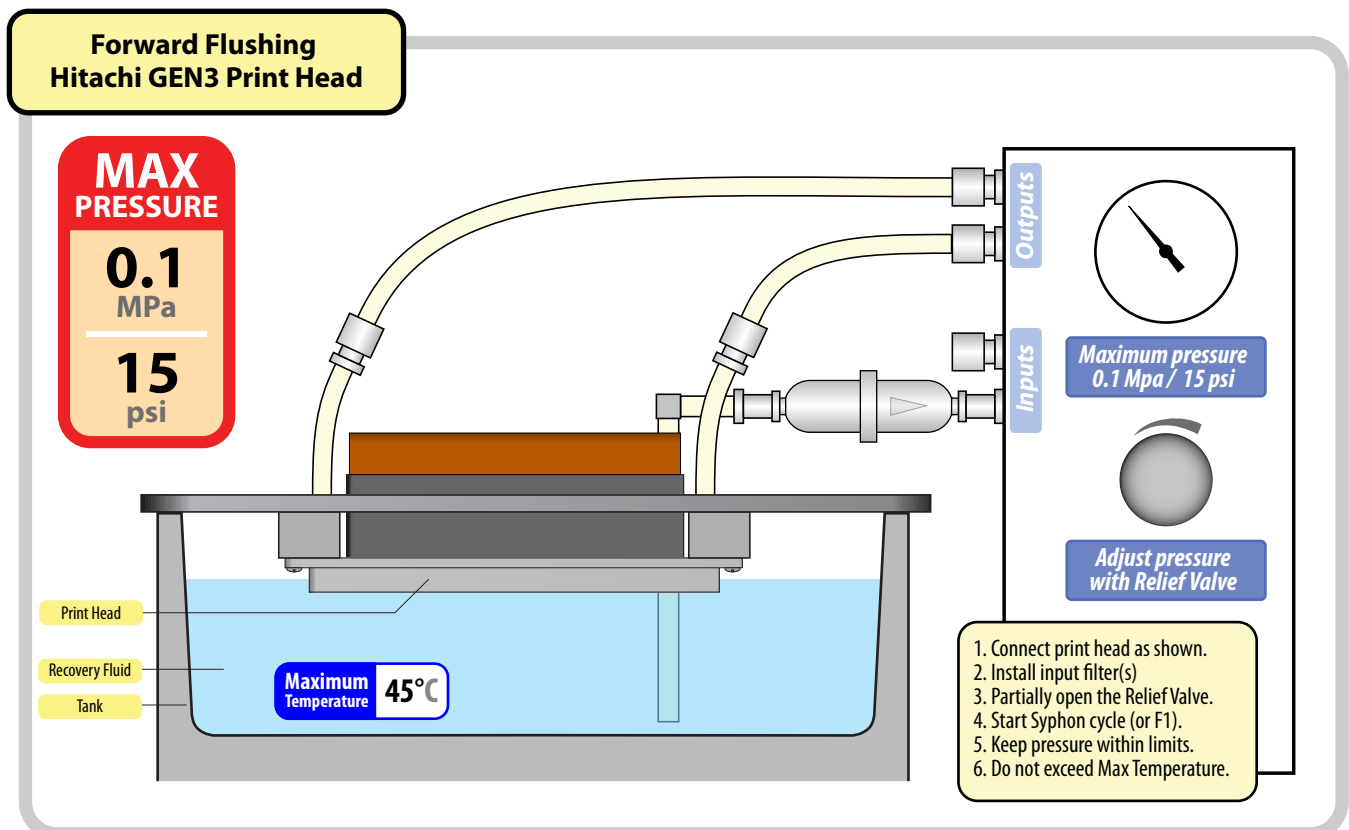
## Step 2. Forward Flush the print head

Set up your print head for forward flushing as shown on the picture below. If the fluid is foamy, run Syphon cycle only. For non-foamy fluids you can run Normal (F1) cycle. Start with temperature of 30°C. After the cycle has been finished, run Drain cycle and check nozzles. If there is improvement, repeat the cycle with a slightly higher temperature. Do not exceed Maximum Temperature.

## Step 3. Proceed with Forward Flushing

If you don't see improvements in the nozzles condition, move on to the next fluid (the fluid with the next number). When changing fluids, follow instructions from our videos. Please note that solvent print head should be recovered with "X" fluids, UV print heads: with "UV" fluids and water-based print heads with "W" fluids. Set temperature to 30°C and go to Step 2.

After the print head has been recovered, fill it with the flushing solution that comes with your ink.

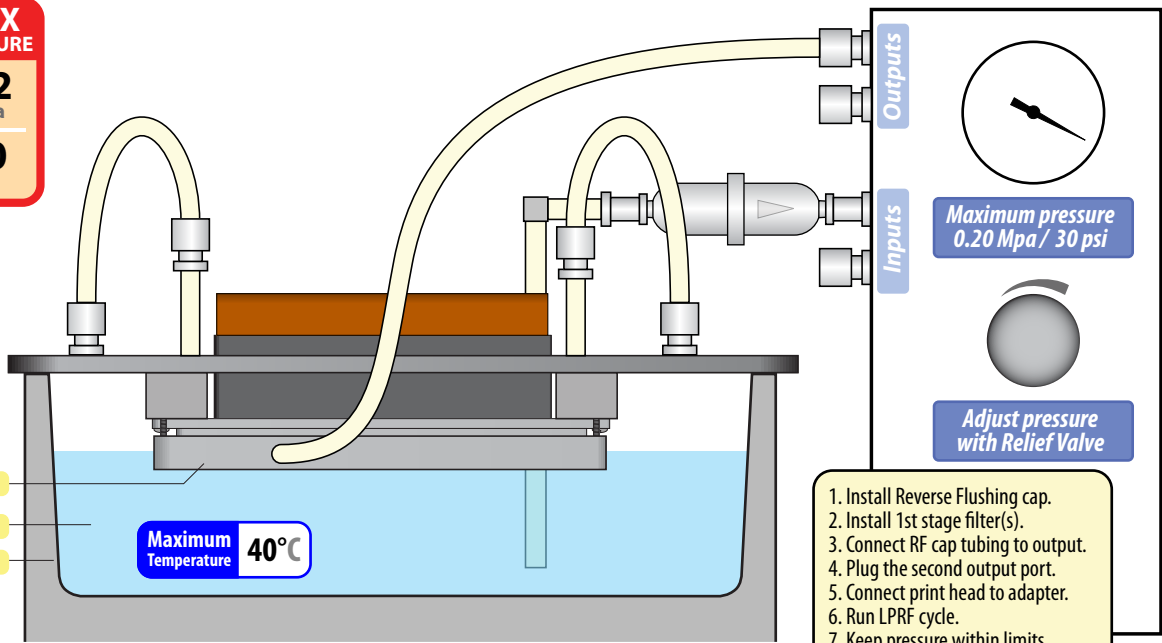


### Reverse Flushing Hitachi GEN3 print head using Reverse Flushing cap

**MAX PRESSURE**  
**0.2 MPa**  
**30 psi**

RF Cap  
 Recovery Fluid  
 Tank

Maximum Temperature **40°C**



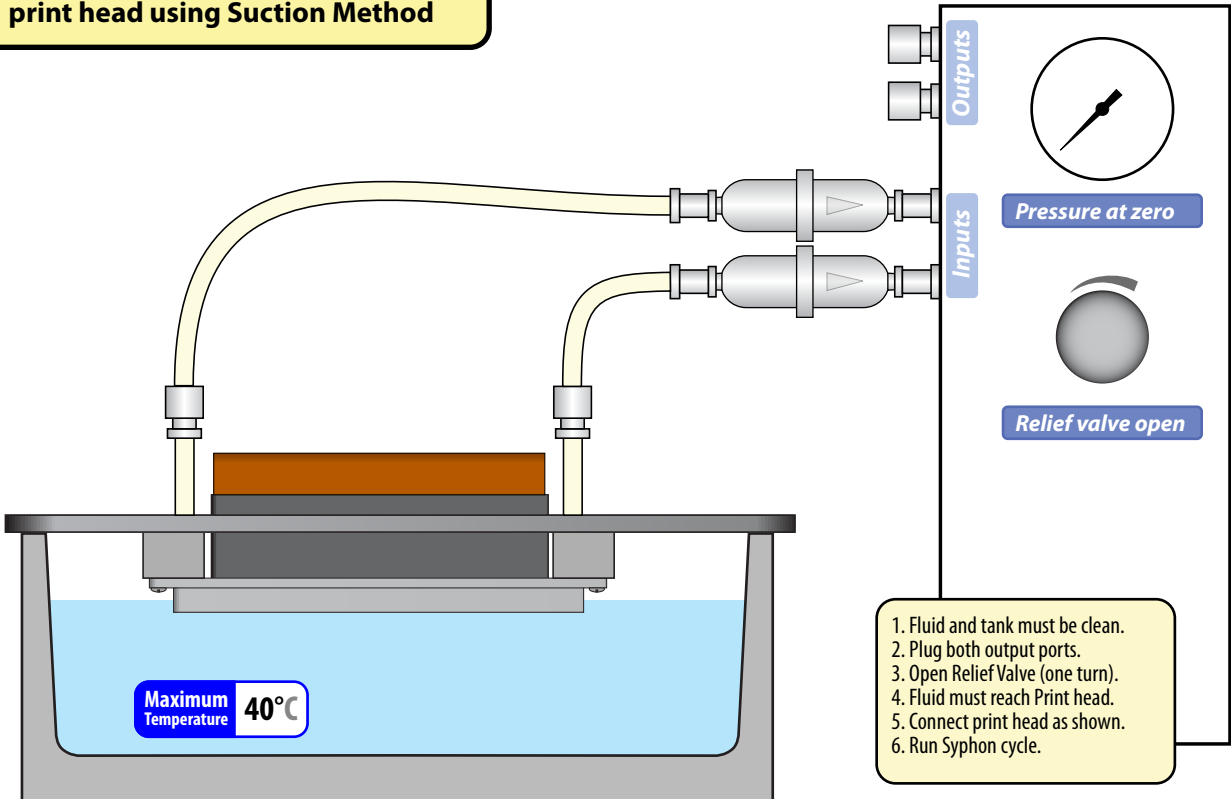
1. Install Reverse Flushing cap.
2. Install 1st stage filter(s).
3. Connect RF cap tubing to output.
4. Plug the second output port.
5. Connect print head to adapter.
6. Run LPRF cycle.
7. Keep pressure within limits.

Maximum pressure  
 0.20 Mpa / 30 psi

Adjust pressure  
 with Relief Valve

### Reverse Flushing Hitachi GEN3 print head using Suction Method

Maximum Temperature **40°C**



1. Fluid and tank must be clean.
2. Plug both output ports.
3. Open Relief Valve (one turn).
4. Fluid must reach Print head.
5. Connect print head as shown.
6. Run Syphon cycle.

Pressure at zero

Relief valve open