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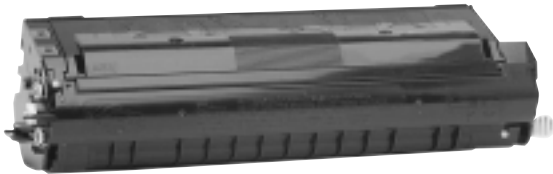
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Fuji-Xerox® XP5/10 (P1)

Remanufacturing Instructions



About the Cartridge

The XP5/10 engine, manufactured by Fuji-Xerox®, is most commonly used in several Apple® LaserWriter® Select and Xerox® models that were introduced between 1993 and 1994. There are three types of Fuji-Xerox XP5/10 (P1) cartridges. One type is used in laser printers such as the Apple Laserwriter Select 360. The other two types are used in the fax machines: Panasonic® Panafax® UF/755 and Pitney Bowes® 9700. All three cartridges are identical except for the guide rails at each end of the cartridge. For more information about the cartridge compatibility, refer to page 2, *How to*

Differentiate XP5/10 Laser and Fax Cartridges.

Remanufacturing the XP5/10 cartridge is very straightforward. The cartridge is held together by two cartridge pins that are tapered at the ends. The pins are easily removed by tapping them through the pin casing to the inside of the cartridge where they fall out through the laser port. SCC's replacement pins feature a slim-line head that install flush to the cartridge, but can be removed without a pair of side cutters.

The cartridge separates into a toner hopper and waste bin section, very similar in design to the LX cartridge. The hopper features a mag roller sleeve that is silver in color, a polyurethane doctor blade, and several foam sealing components. The mag roller sleeve can be recoated through SCC's EnduraMag program. A replacement doctor blade is also available from SCC.

The hopper requires minimal disassembly in

Continued on the next page

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WWW.SCC-INC.COM

Get the latest information on the web at Static Control's Fuji-Xerox® XP5/10 (P1) Online Engine Center www.scc-inc.com/engine/xp5



System Support Series Documents are available on our Web site in Adobe® Acrobat® format.

If you need additional information or technical assistance, please contact the Technical Support Group.

1.800.948.1072 (USA)
 +44 (0) 118 935 1888 (UK)
 email: techservices@scc-inc.com

XP5/10 (P1) Engine Information				
	Apple® Select 300	Apple® Select 360	Xerox® 4505/4510	Pitney Bowes® 9700 Fax
First Ship Date	February 1993	November 1993	April 1994/March 1994	September 1993
Printer/Fax Status	Discontinued	Discontinued	Discontinued	Current
Pages Per Minute	5 ppm	10 ppm	5 ppm/10 ppm	5 ppm
Engine Duty Cycle	150,000 pages/life	300,000 pages/life	10,000 pages/month/ 20,000 pages/month	
Resolution (dpi)	300 dpi	600 dpi	600 dpi/600 dpi	203 x 98 (lines per inch)
Page Size	Let/Legal/Ex/A4	Let/Legal/A4/B5	Let/Legal/Ex/A4/A5/B5	
XP5/10 (P1) Cartridge Information				
	Apple® Select 360	Xerox® 4505/4510	PB9700	
OEM Part Number	M1960G/A	113R5	(Compatible Cartridge)	
OEM Rated Yield	4,000 pages	4,000 pages	8,000 pages	
List Price*	\$126.00	\$103.00	\$195.00	
Avg. Wholesale Price*	\$75.00	\$87.00	\$93.00	
Toner Weight	200 grams			
Toner Class	Magnetic, Monocomponent			
Model Compatibility				
Apple® LaserWriter® Select 300/310/360/610, Pitney Bowes® 9720/9750/9760 PB9700 (Compatible Cartridge), Panafax UF-755 and Xerox® 4505/4505 PS/4510/4510 PS				
*Yield is based on 5% page coverage, unless noted otherwise.				
*Prices as of March 1999				



About the Cartridge

order to clean the hopper and install a seal. There is only one end plate, but it is ultrasonically welded to the hopper and does not require removal. SCC's lay-in seals feature peel-to-expose adhesive backing for fast and easy installation. Some OEM cartridges feature a sealing tape over the doctor blade stamping. Instead of replacing the sealing tape, we recommend installing doctor blade sealing foam underneath the doctor blade stamping to control leakage from the hopper.

The waste bin houses the wiper blade, recovery blade, drum and PCR. The wiper blade is the only component in the cartridge that is inaccessible. Like the LX cartridge, the screws that hold the wiper blade in place are enclosed in the waste bin under the waste bin cover, which is ultrasonically welded to the waste bin assembly. The wiper blade can only be removed by removing the cover.

In cleaning the waste bin we recommend removing the recovery blade for the greatest access to the waste bin. The recovery can be removed and a replacement installed quickly and easily. SCC offers both mylar- and poly-type (PolyBlade™) recovery blades, in addition to installation tools for each type of blade.

Since the introduction of the cartridge, we have noted a difference in the Primary Charge Roller (PCR) used in the Apple cartridges. The Apple 360 uses a PCR with a brittle, film-like coating, and a central tension clip is incorporated in the waste bin to support the installed PCR. In contrast, the Apple 300/310 cartridge used a PCR with a soft, textured surface, and a strip of foam is installed in the waste bin along the length of the installed PCR.

System Support Series Available

SSS#	Title
Product Instructions	
033	Drum Shutter Felt (PX, VX, PC330/770, XP5/10, PB9800)
040	XP 5/10 (P1) Gasket Seal Assembly Installation Kit
045	XP 5/10 (P1) Doctor Blade End Foam
046	XP 5/10 (P1) Doctor Blade Sealing Foam
113	EnduraMag™ Mag Roller Sleeve (LX, NX, SX, FX-V, XP5/10)
128	Cartridge Pins (Multiple Units)
174	Fuji-Xerox® XP 5/10 (P1) PCR Tension Clip
Tech Bulletins	
147	Distinguishing Between the Different Types of XP5/10 (P1) Cartridges

Repetitive Defect Troubleshooting Guide

Interval	Component	Probable Cause of Defect
@ 94mm, 3.70 inches Intervals	OPC Drum	OPC wear, OPC damage, OPC contact, elliptical drum rotation, OPC light exposure degradation, PCR defect
@ 38mm, 1.50 inches Intervals	Primary Charge Roller	PCR wear, PCR contamination, toner properties, poor electrical contact, low RH% conditions, dry paper
@ 47.2mm, 1.86 inches Intervals	Mag Roller	Mag roller wear, mag roller electrical contact, mag roller cleaning damage, mag roller bushing wear, doctor blade failure, toner properties, mag roller contamination
@ 62mm, 2.44 inches Intervals	Upper Fuser Roller	Toner offsetting, upper fuser roller/pressure roller incompatibility, toner properties, upper fusing belt/lower pressure roller wear/contamination
@ 57mm, 2.24 inches Intervals	Lower Pressure Roller	Toner/pressure roller incompatibility, pressure roller wear/contamination (defect will appear on backside of page)
@ 51.3mm, 2.1 inches	Transfer Roller	Repeating interval of light print



Tools and Supplies You Will Need

Use of Compressed Air

As of April 28, 1971, the Occupational Safety & Health Administration (OSHA) Standard, 29 CFR 1910.242 paragraphs a & b for general industry requires effective chip guarding and personal protective equipment (PPE) when using compressed air. When cleaning residual toner particles from cartridges using a compressed air system, you must use air nozzles meeting OSHA requirements. Air nozzles that regulate air pressure to a maximum of 30 psi comply with this standard. Refer to the OSHA publication for any updates or changes that have occurred since the date noted above.

Use of Isopropyl Alcohol

For best results, we recommend using ONLY 91-99% for cleaning as directed in these instructions. 91% isopropyl alcohol is available at most major drug stores; 99% isopropyl alcohol is available through distributors of chemical products. Follow the alcohol manufacturer's safety instructions.

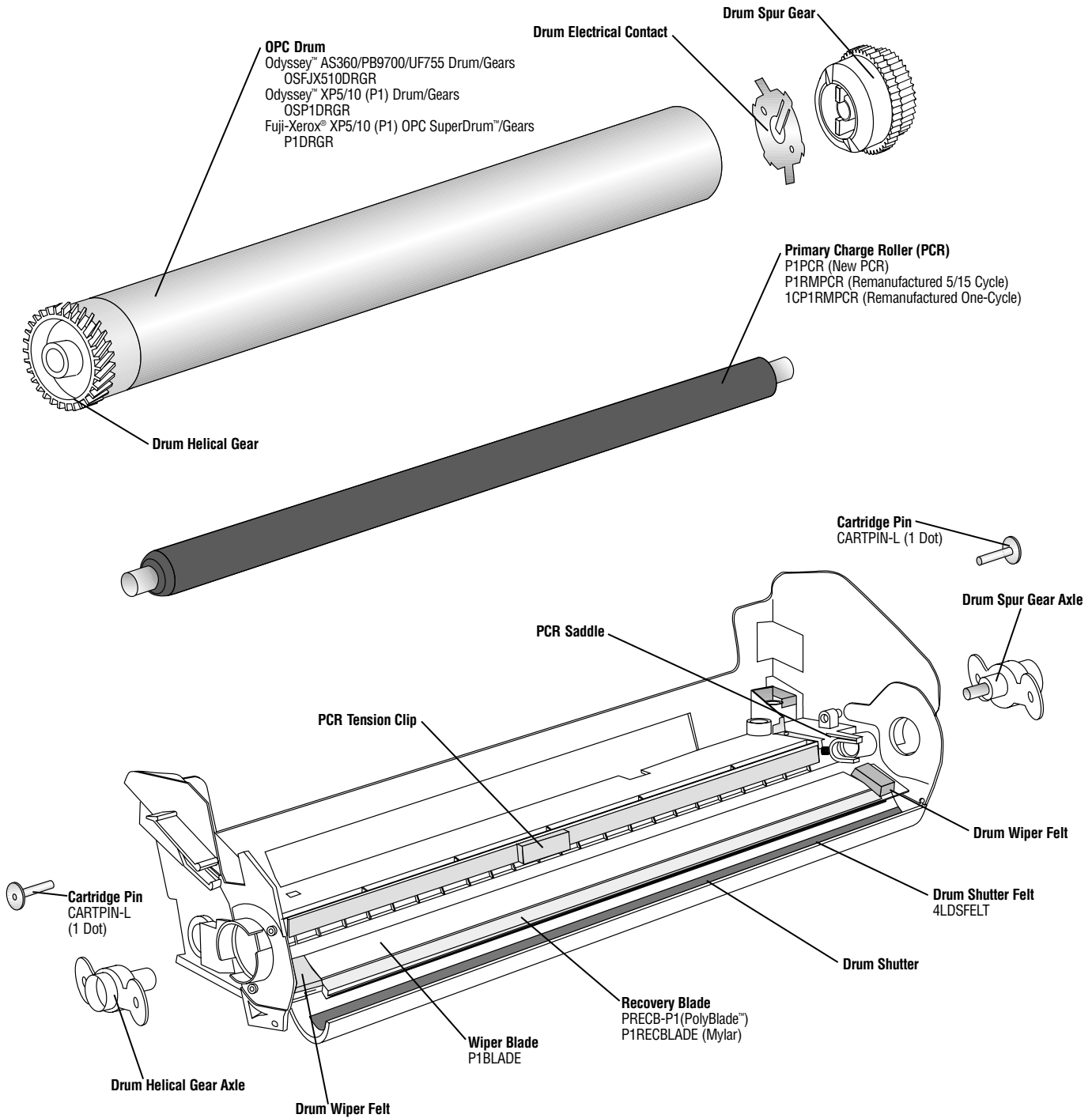
Tools and Supplies You Will Need

For Basic Remanufacturing:

- 7/64" Punch
- Hammer or Mallet
- Small Flat Blade Screwdriver
- Phillips Screwdriver
- Side Cutters
- Compressed Air for Cleaning (See left)
- 91-99% Isopropyl Alcohol (See left)
- Lint-Free Foam Tip Swab LFSWAB
- Lint-Free Cleaning Cloth LFCLOTH
- Kynar Lubricating Powder KPOW
- Cartridge Pins CARTPIN-L
- Toner (MicroGraphics™ 1) P1-200B



Waste Bin Assembly-Terms and Definitions



◆ Tool, Kit or System Available. Contact your SCC Sales Team. *SCC PARTS INDICATED IN GRAY.*

Cartridge Pin

Installed at each end of the cartridge to hold the waste bin and toner hopper sections together.

OPC Drum (Organic Photo Conductor Drum)

An aluminum cylinder coated with light-sensitive organic photoconductive material used to retain an image written to it by a laser beam. (Also called OPC, drum, photoreceptor)

Drum (Helical and Spur) Gears

The spur gear, on the right end of the waste bin section, houses the drum electrical contact. The other gear is the helical gear.

Drum (Helical Gear and Spur Gear) Axles

Installed at the ends of the waste bin section to provide support for the gears.

Drum Electrical Contact

Provides electrical contact between the drum and printer; makes contact with the a metal rod in the spur gear axle when the axle is installed in the drum.

Drum Shutter

Protects the drum from light damage when the cartridge is out of the printer. When the cartridge is installed in the printer, the shutter opens so that the drum is exposed to the paper.

Drum Shutter Felt

Shutter felt is an aftermarket component installed on the interior of the drum shutter felt. It protects the drum from potential damage caused by the opening and closing of the shutter.

Drum Wiper Felt

Wipes the areas on the drum where the mag roller sleeve bearings make contact with the drum; prevents buildup of toner on the drum where the bearings ride.

PCR Saddle

Two saddles support the PCR at each end of the shaft. One saddle, located at the contact (right) end of the cartridge, is made of conductive material. The other saddle is non-conductive. The springs at the base of the saddles maintain tension on the PCR so that it will make constant and uniform contact with the drum.

PCR Tension Clip

Installed in the waste bin of some XP5/10 cartridges to support the center of the PCR.

Primary Charge Roller (PCR)

Uniformly charges the OPC drum. (Also called PCR, charge roller)

Recovery Blade

Acts as a dam at the base of the waste bin, keeping the toner from falling out of the waste bin onto the paper. (Also called catcher blade, scavenger blade)

Waste Bin

A receptacle that catches toner wiped from the drum. (Also called waste hopper or dust bin)

Wiper Blade

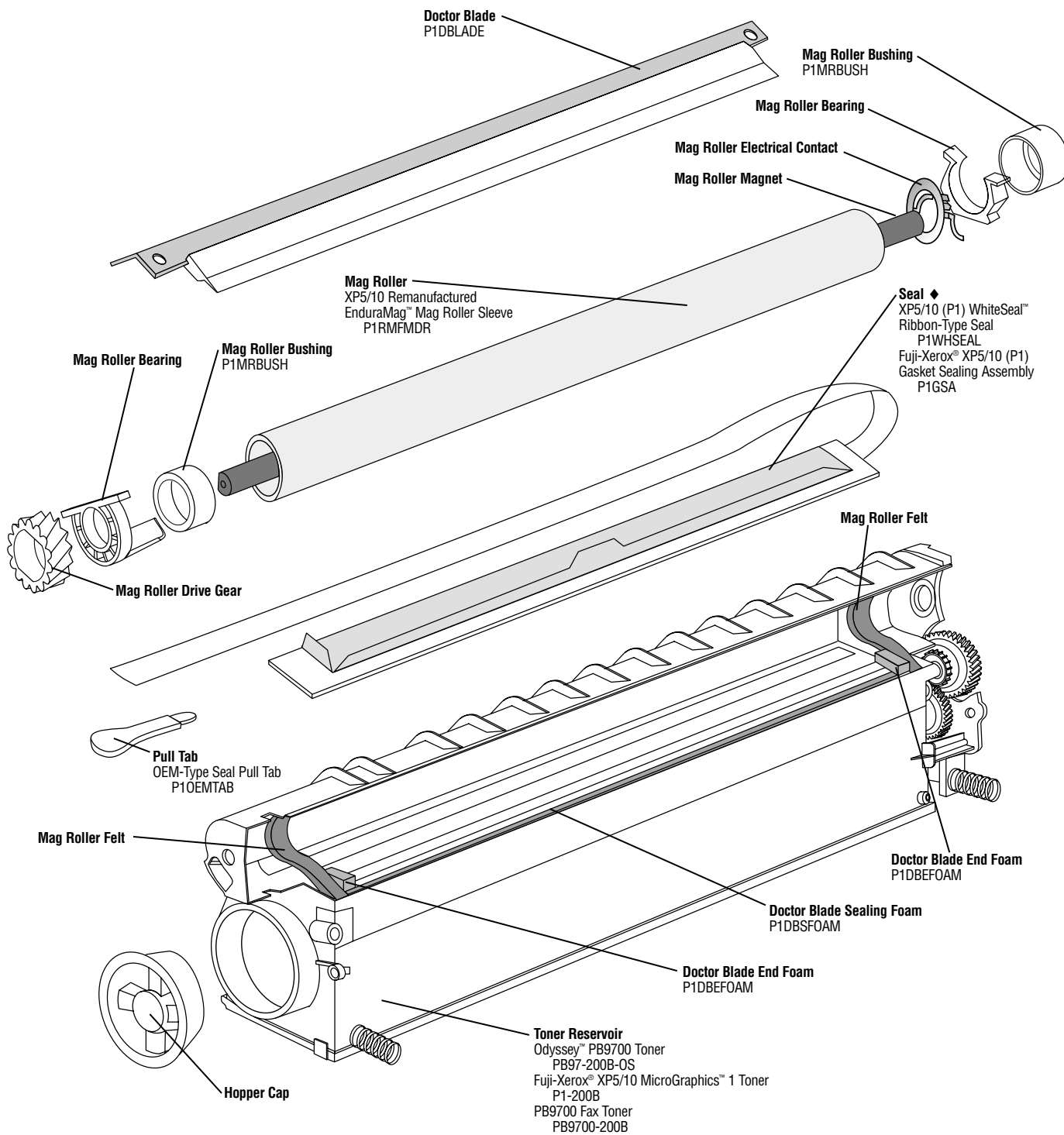
Cleans the drum by wiping away toner not transferred to the paper. Constructed of a metal stamping (base) and polyurethane blade. (Also called cleaning blade)

Wiper Blade End Foam

Bottom layer of foam and top layer of felt seal the area at the end of the polyurethane wiper blade; prevents leakage from the waste bin.



Toner Hopper Assembly-Terms and Definitions



♦ Tool, Kit or System Available. Contact your SCC Sales Team. *SCC PARTS INDICATED IN GRAY.*

Doctor Blade

Uniformly meters the amount of toner on the mag roller. The doctor blade is constructed of a metal stamping (base) and a flexible blade. (Also called metering blade)

Doctor Blade End Foam

Small pieces of foam that seal the ends of the doctor blade and prevent leakage from the toner hopper.

Doctor Blade Sealing Foam

A strip of foam that seals the area between doctor blade stamping and cartridge shell; prevents leakage from the toner hopper.

Hopper Cap

Plugs the fill opening of the hopper.

Hopper Compression Springs

Two springs attached to the hopper section to apply pressure to the waste bin so that the drum is properly seated on the mag roller bushings, maintaining the proper air gap between the drum and mag roller.

Mag Roller

A rotating coated aluminum sleeve around a stationary magnet. The mag roller attracts toner magnetically and applied AC/DC voltage charges the toner and transfers it to the OPC. A doctor blade meters the toner before it is delivered to the OPC. (Also called mag roller, developer roller)

Mag Roller Bearing (Left and Right)

Installed at each end of the mag roller sleeve to prevent lateral movement of the mag roller in the hopper.

Mag Roller Bushings

Placed on each end of the mag roller sleeve to establish a consistent air gap between the mag roller and drum when the cartridge is assembled.

Mag Roller Drive Gear

Rotates the mag roller sleeve around the permanent magnet.

Mag Roller Electrical Contact

Installed on the end of the mag roller sleeve; contacts the metal contact plate in the mag roller end plate and provides electrical contact between the mag roller and printer.

Mag Roller Felt

Material that lines the saddles where the mag roller rests in the hopper; provides a seal at the ends of the mag roller.

Pull Tab

Attached to the seal pull strip to enable the end user to remove the seal pull strip and release toner into the development station.

Seal

Installed over the toner port to contain toner in the hopper. Toner is released to the development station when the seal pull strip is removed by the end user.

Seal Exit Port

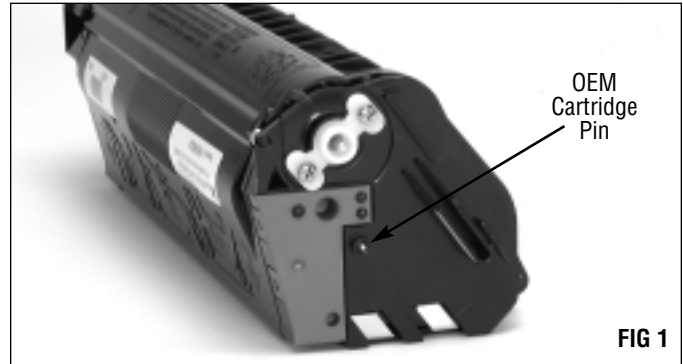
An opening in the hopper from which the seal pull strip exits when removed by the end user.

Toner Port

An opening, occupied by the seal, that runs along the length of the hopper. Once the seal is removed, toner travels through this opening to the development station.

Separating the Cartridge

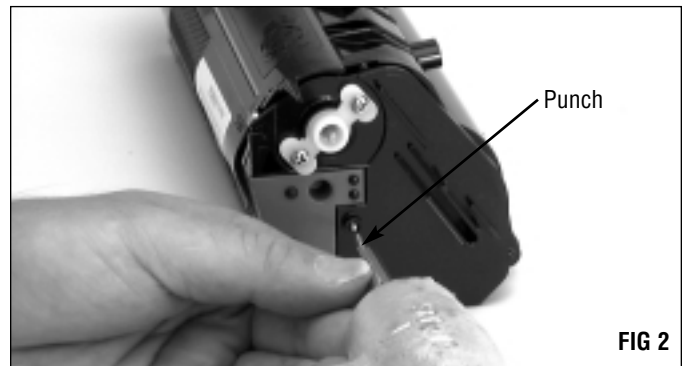
1. Place the cartridge on your work surface with the laser port facing down and the arrow on the printed instructions pointing down (FIG 1). Positioning the cartridge with the laser port down will allow the cartridge pins to fall through the port when the pins are tapped through the pin casing.



2. Remove a cartridge pin from each end of the cartridge (two pins total).

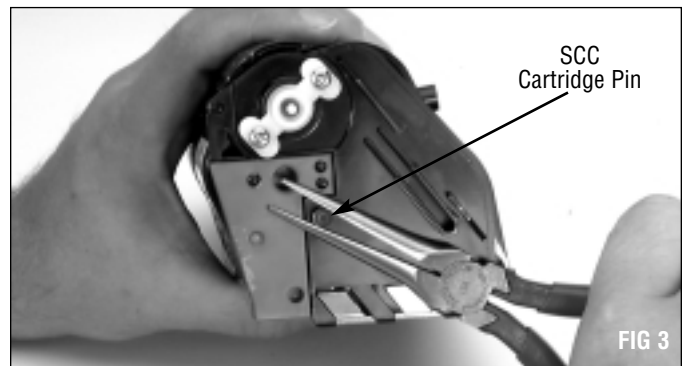
Removing OEM Cartridge Pins:

The OEM Cartridge Pins (CARTPIN-L) are tapered at each end making them difficult to remove with needlenose pliers or side cutters. To remove the pins, first secure the cartridge to your work surface to prevent the cartridge from shifting. Then, place a 7/64" punch over the OEM pin and gently tap the pin through the casing using a hammer or mallet (FIG 2). The pin will fall through the laser port onto your work surface.



Removing SCC Cartridge Pins:

SCC cartridge pin features a slim-line head that installs flush to the cartridge. Remove SCC cartridge pins using a pair of side cutters (FIG 3).



3. Separate the cartridge.

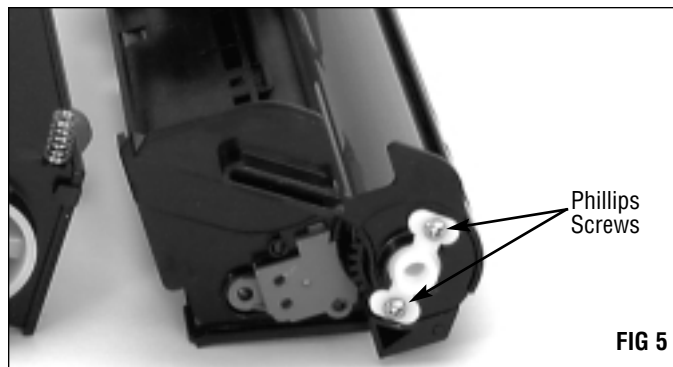
Slowly separate the hopper and waste bin sections (FIG 4). Be careful not to damage the drum.



Disassembling the Waste Bin

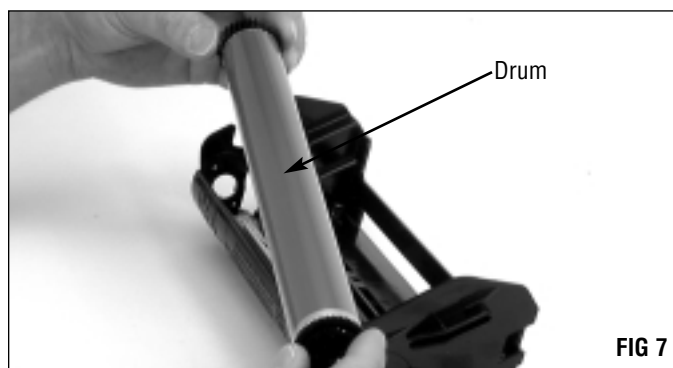
1. Remove the drum axles from each end of the waste bin (FIGs 5 and 6).

Remove the Phillips screws from the axle, then remove the axle. As you remove the last axle, hold the drum gear to prevent the drum from rolling out of the cartridge.



2. Remove the drum (FIG 7).

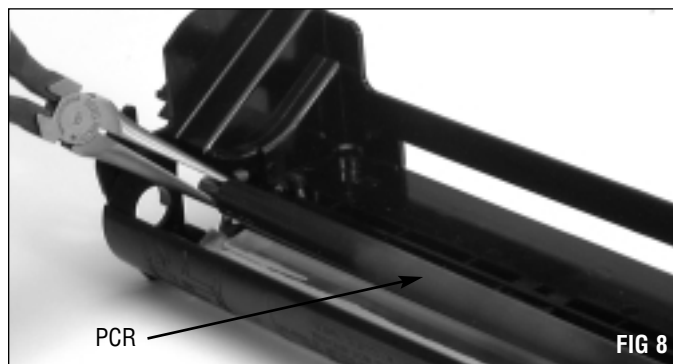
If you plan to reuse the drum, store it in an area that is protected from light and impact damage. Handle the drum by the gears to prevent touching the coated area of the drum.



3. Remove the PCR (FIG 8).

If you plan to reuse the PCR, store it on a flat uniform surface. Handle the PCR by the metal shaft to avoid touching the coated surface of the PCR.

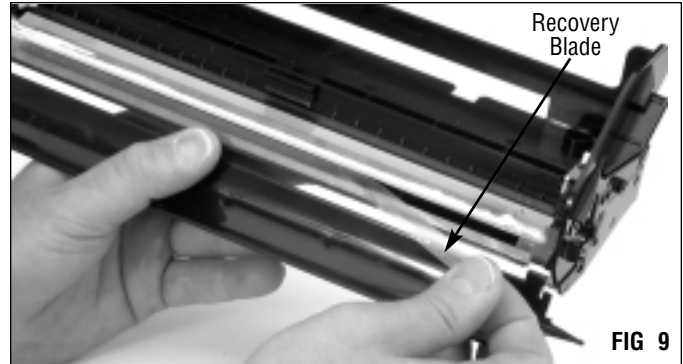
CAUTION Do not stack PCRs, lay anything on top of the PCRs, wrap the PCRs with rubber bands, or touch the coated surface of the PCR with your bare fingers.



Disassembling the Waste Bin

4. Remove the recovery blade (FIG 9).

Since the wiper blade is not easily removed, we recommend removing the recovery blade to gain greater access to the waste bin for cleaning.



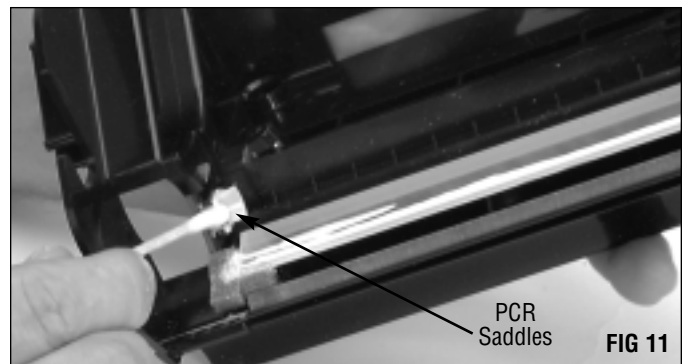
5. Clean the waste bin and cavities with dry, filtered compressed air (FIG 10).

Direct compressed air on the felt and foam sealing components to remove as much toner as possible. Use caution to avoid damaging the wiper blade.



6. Clean the PCR saddles (FIG 11).

Clean toner residue from the PCR saddles using a lint-free swab dampened with 91-99% isopropyl alcohol. Make sure the black PCR saddle is completely free of toner and debris to ensure proper electrical contact.





Disassembling the Toner Hopper

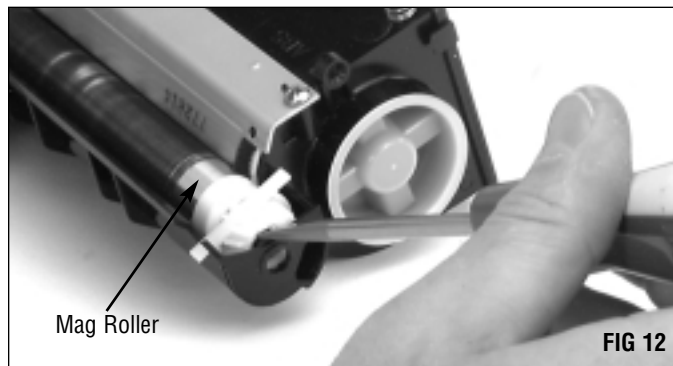
1. Remove the mag roller.

Using a flat blade screwdriver, Carefully shift the magnet axle toward the contact end of the cartridge. Then pry the magnet axle from the hopper and remove the mag roller (FIG 12). Use extreme caution not to scratch the mag roller or damage the mag roller gear.

If you plan to reuse the mag roller, store it in an area that protected from impact damage.

If the mag roller requires replacement, SCC offers a remanufacturing service for the sleeve (P1RMFMDR). Contact a member of you SCC Sales Team for program details.

CAUTION Do not scratch the surface of the mag roller or touch the surface with your fingers. Store the mag roller on a clean, soft surface, but do not stack the rollers on top of each other.



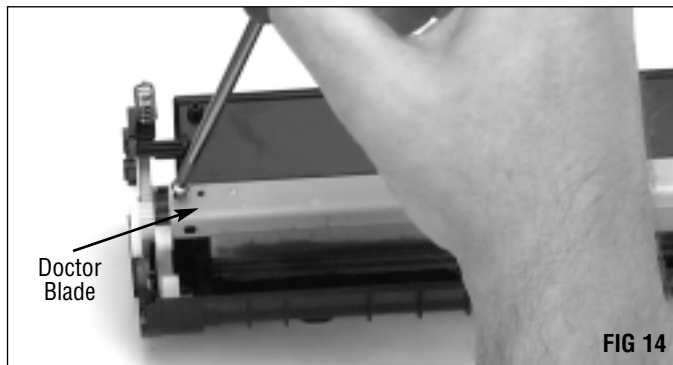
2. Remove the mag roller bushings and mag roller stabilizers (FIG 13).

Note that the mag roller stabilizer at the non-contact end of the hopper may remain in the hopper. Remove the stabilizer from the hopper.



3. Remove the doctor blade.

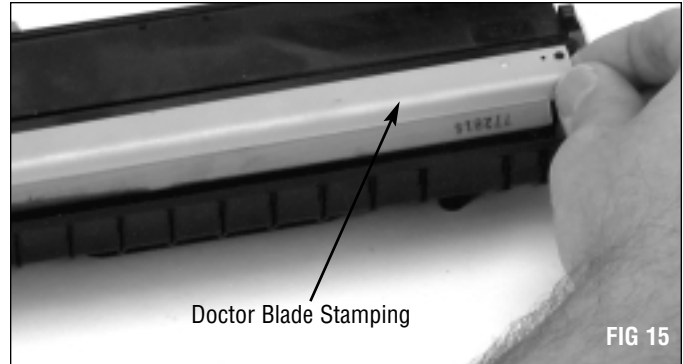
Remove two Phillips screws from the doctor bar (FIG 14).



Disassembling the Toner Hopper

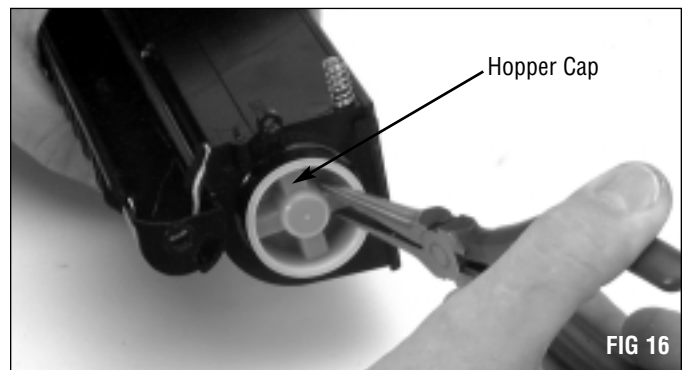
4. Remove the doctor blade.

Remove the blade from the doctor blade stamping (FIG 15).



5. Remove the hopper cap.

Use a pair of needlenose pliers or a flat blade screwdriver to pry the cap from the fill hole (FIG 16).



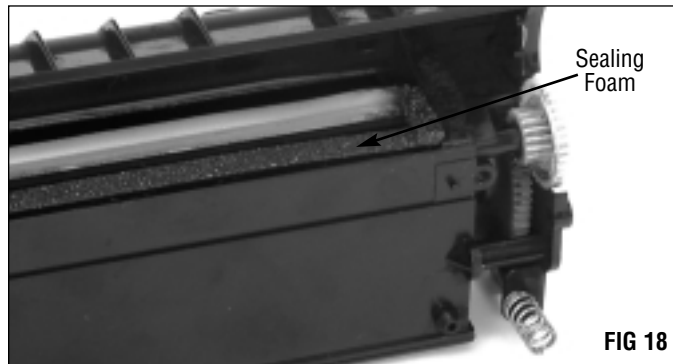
6. Clean the hopper.

Dump toner from the hopper and clean thoroughly with dry, filtered compressed air (FIG 17). Direct compressed air on the sealing foam and felt components to remove as much toner and debris as possible.



6. Inspect the sealing foam components (FIG 18).

Replace foam components that are torn, pitted, compacted with toner or foam that is not secured to the mounting surface. Refer to the instructions included with the individual replacement products for installation procedures. Foam inspection and replacement is also included as part of the seal installation process.

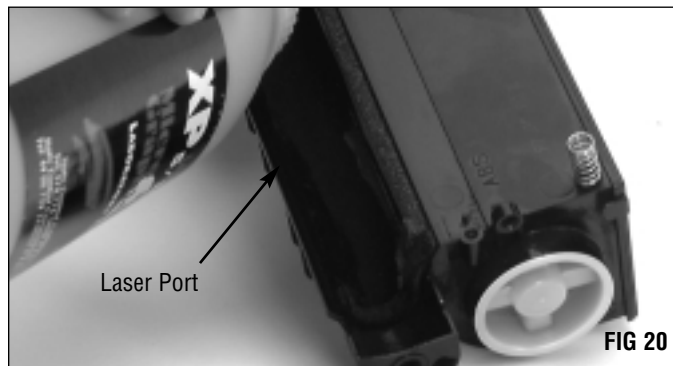


7. Install a Seal (Optional) and Fill the Hopper (FIG 19).

If you plan to ship the cartridge, SCC recommends sealing the hopper as your best protection against toner leakage. SCC offers two types of lay-in seals, a Gasket Sealing Assembly (P1GSA) and a WhiteSeal (P1WHSEAL). Each seal features peel-to-expose adhesive backing for easy installation and leak-proof sealing. The Gasket Sealing Assembly Kit (P1GSAKIT) includes a hopper fixture and several tools to aid seal installation. Contact a member of your SCC Sales Team for more information. For complete sealing instructions, refer to SSS 40, How to Install the XP5/10 Gasket Sealing Assembly.



If you do not seal the cartridge, install the hopper cap on the toner reservoir and fill the hopper through the laser port (FIG 20). Assemble the hopper following the steps in the next section.



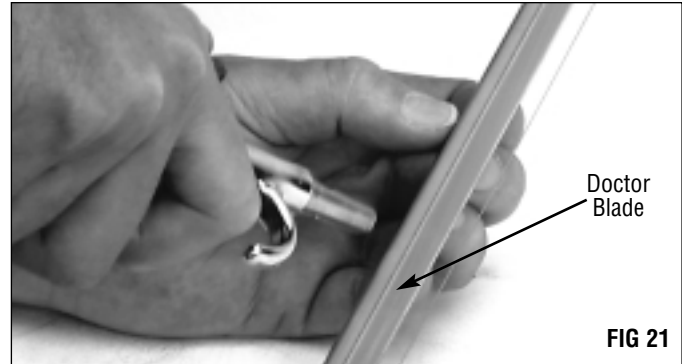


Assembling the Toner Hopper

1. Inspect and clean the doctor blade.

Replace the Doctor Blade (P1DBLADE) if pre-test prints indicated doctor blade failure. Otherwise, clean the blade with dry, filtered compressed air (FIG 21).

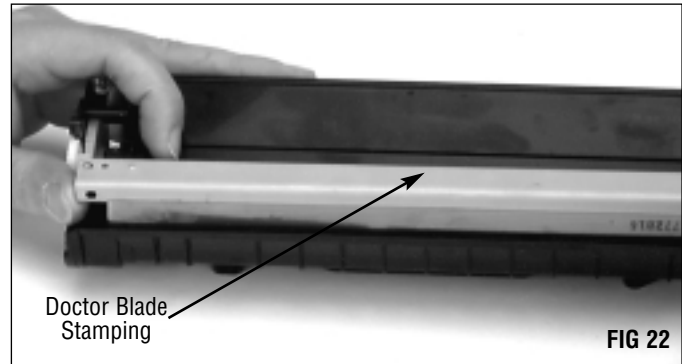
CAUTION Do not use alcohol or alcohol-based cleaners to clean the blade.



2. Install the doctor blade.

Position the doctor blade stamping over the locating posts on the hopper (FIG 22).

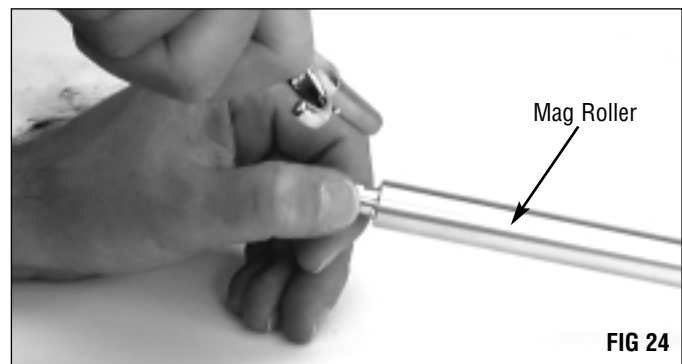
Secure the stamping with two Phillips Screws (FIG 23).



3. Clean the mag roller.

If you plan to reuse the mag roller, clean it with dry, filtered compressed air (FIG 24).

If you are using a recoated or new mag roller sleeve, follow the disassembly instructions carefully to prevent damage to the sleeve. SCC offers an EnduraMag Remanufactured Mag Roller Sleeve (P1RMFMDR) for the XP5/10 application on an exchange basis. Refer to SSS 113, EnduraMag Mag Roller Sleeve (LX, NX, SX, FX-V, XP5/10) for disassembly and assembly instructions.



4. Clean the mag roller electrical contact.

Clean the contact using a lint-free swab dampened with 91-99% isopropyl alcohol (FIG 25).



FIG 25

5. Clean the mag roller bushings.

If you are reusing the bushings, clean them with a lint-free cloth to remove toner and debris (FIG 26).

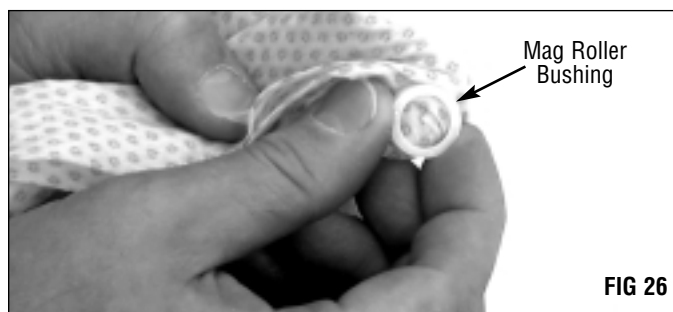


FIG 26

6. Install the mag roller bushings and bearing on the ends of the mag roller.

Before installing the mag roller bushings, inspect them for excessive wear or cracks and replace as needed. For best results, replace the mag roller bushings in pairs. Mag Roller Bushings (P1BUSH) for the XP5/10 application are available from SCC.

Install a bushing on each end of the mag roller. Install the closed bearing and the mag roller drive gear on the non-contact end of the mag roller (FIG 27).

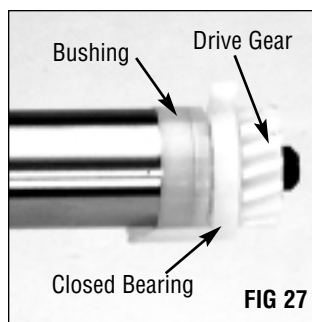


FIG 27

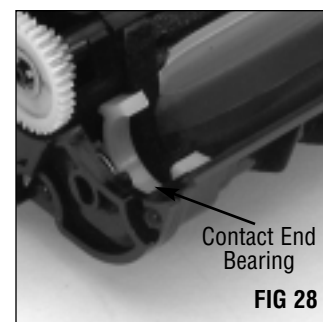


FIG 28

Position the contact end bearing at the non-contact end of the hopper before installing the mag roller (FIG 28).

7. Install the mag roller.

Position the contact end of the mag roller at the contact end of the hopper as shown in FIG 29. The contact end of the axle is keyed and must be located in the keyed slot in the hopper. Rotate the magnet axle at the drive gear end of the mag roller until the keyed axle seats in the slot (FIG 30).

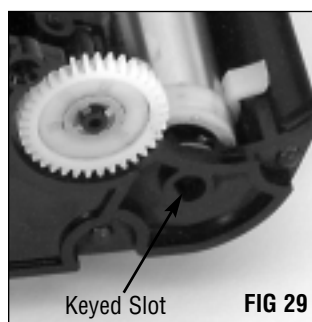


FIG 29



FIG 30



Assembling the Waste Bin Section

1. Install a replacement recovery blade (FIG 31).

Both mylar- (PRECBLADE) and poly-type (PolyBlade™) (PRECB-P1) recovery blades are available from SCC. Recovery Blade Kits (RBIKIT or RBIKIT-PBL) with installation tool and installation instructions are also available for each blade type.

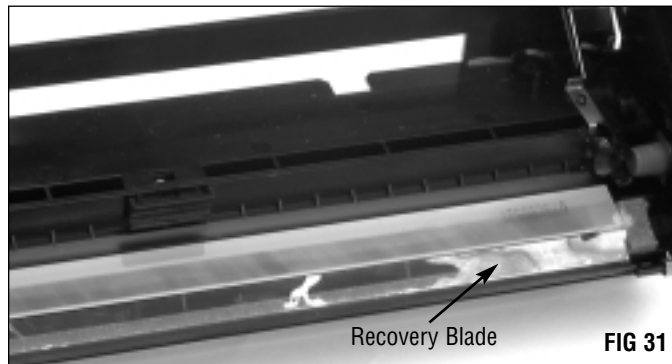


FIG 31

2. Pad the wiper blade.

Kynar® lubricating powder (KPOW) applied to the working edge of the wiper blade will help prevent blade "flip overs" during the first few drum rotations of the remanufactured cartridge.

Apply Kynar lubricating powder evenly to the working edge of the wiper blade (FIG 32).

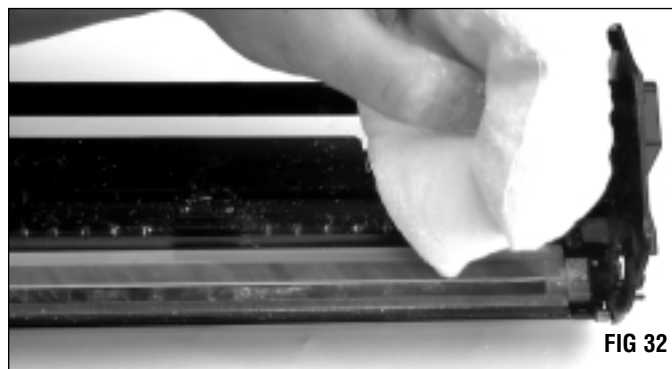


FIG 32

3. Inspect and clean the PCR.

Gently wipe the PCR in one direction. Try not to pinch or dent the surface of the PCR, as the material has poor memory.

OEM PCR: Clean the PCR using a soft, lint-free cloth dampened with water (FIG 33).

SCC XP5/10 PCR: Clean the PCR using a soft, lint-free cloth dampened with isopropyl alcohol.

The OEM XP5/10 PCR is not recoatable through SCC's PCR remanufacturing program; however, SCC offers several PCR replacements. Refer to page 2 for details.

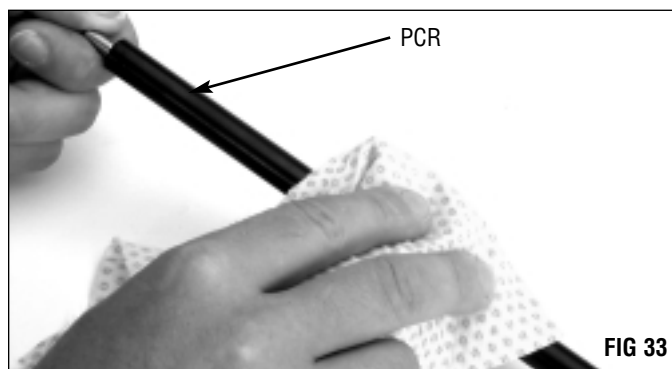


FIG 33

4. Remove PCR tension clip (as required).

If you are using SCC's XP5/10 new PCR, a tension clip must be removed to prevent wear to the new PCR. The tension clip is only featured in certain cartridge models. Check the waste bin and remove the tension clip if present (FIG 34).

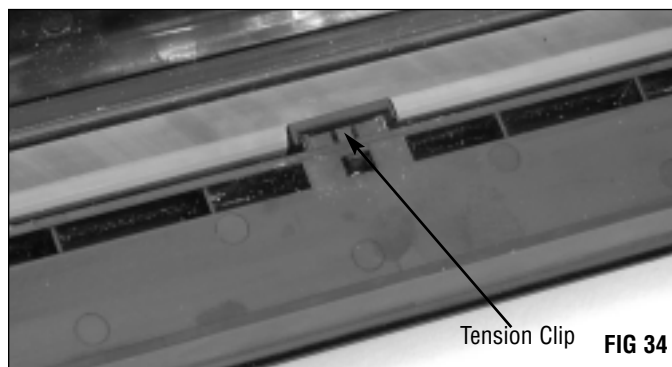


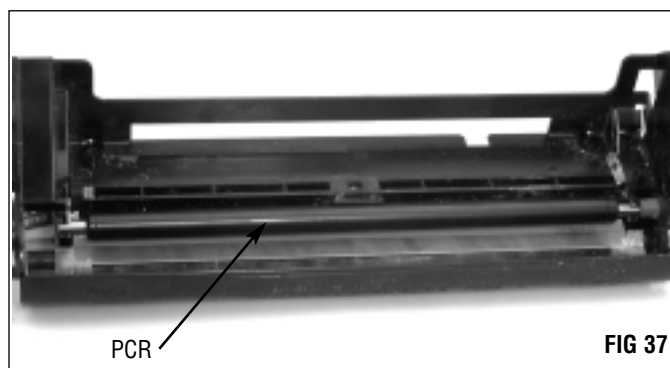
FIG 34

To remove the PCR tension clip, depress the tension clip tab, releasing the pressure from the spring. Remove both the clip and the spring from the waste bin (FIGs 35 and 36).



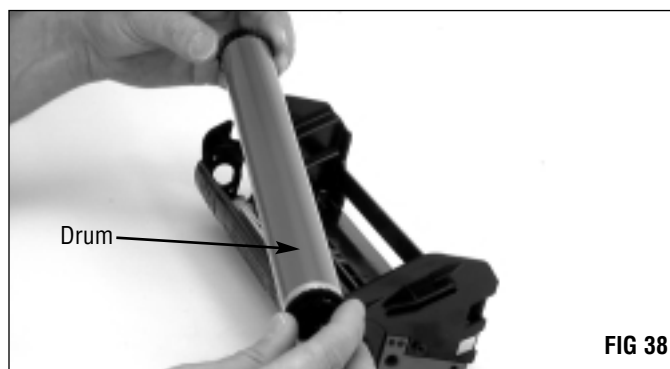
5. Install the PCR.

The PCR shafts should fit securely in the PCR saddles at each end of the waste bin (FIG 37).



6. Inspect and clean the drum.

Inspect the drum for wear or refer to pre-test prints for drum-related defects and replace the drum as required (FIG 38). If you plan to reuse the drum, clean it with dry, filtered compressed air. SCC offers two drums for the XP5/10 application: Odyssey Drum/Gears (OSFJX510DRGR) or SuperDrum/Gears (P1DRGR).



IMPORTANT For best results, do not use cleaning agents or coatings on the drum surface. Be careful not to nick or scratch the drum while cleaning and handling the drum.

7. Pad the drum.

Kynar lubricating powder applied to the coated area of the drum helps prevent wiper blade "flip overs" during the first rotations of the drum.

Apply a layer of lubricating powder to the coated area of the drum being careful to avoid Kynar on the drum gears (FIG 39).



Assembling the Waste Bin Section

8. Install a drum shutter felt (recommended).

A Drum Shutter Felt (4LDSFELT) installed on the interior surface of the drum shutter is recommended to reduce the risk of drum damage caused by the drum shutter. Installation instructions are included with the drum shutter felt.

9. Install the drum.

Position the drum with the spur gear at the contact end of the waste bin as shown in FIG 40.



FIG 40

10. Install the drum axles.

The drum spur gear axle has a metal rod that, when installed in the waste bin, makes contact with an electrical contact in the drum. Install the spur gear axle and secure with two Phillips screws (FIGs 41 and 42).

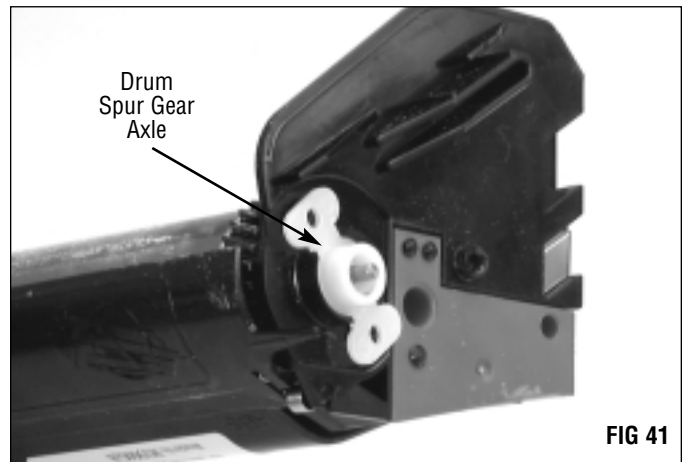


FIG 41

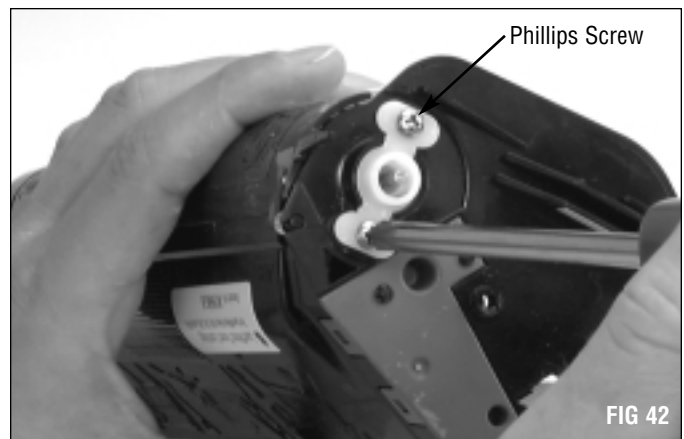
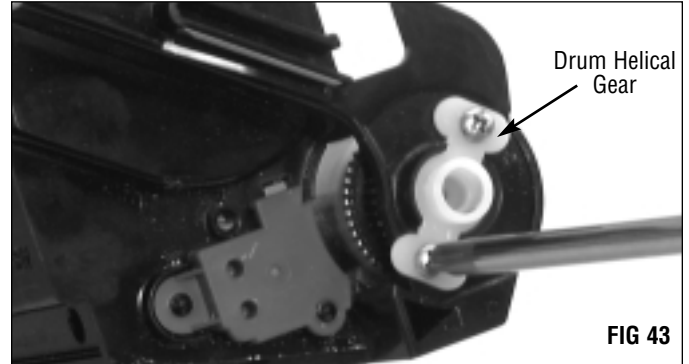


FIG 42

The drum helical gear axle is installed at the non-contact end of the waste bin. Secure the axle with two Phillips screws (FIG 43).



11. Rotate the drum.

Rotate the drum in its normal rotational direction, as indicated by the arrow in FIG 44, at least six full drum rotations. Rotating the drum will help lubricate the drum and blade and prevent blade "flip overs". The lubricating powder wiped from the drum by the wiper blade will deposit in the waste bin.



12. Wipe the lubricating powder from the PCR.

After you have rotated the drum to remove the powder, rotate the drum again in small increments to clean the Kynar from the PCR. As you rotate the drum in its normal rotational direction, wipe the powder from the PCR with a Lint-free Cleaning Cloth (LFCLOTH) as shown in FIG 45.

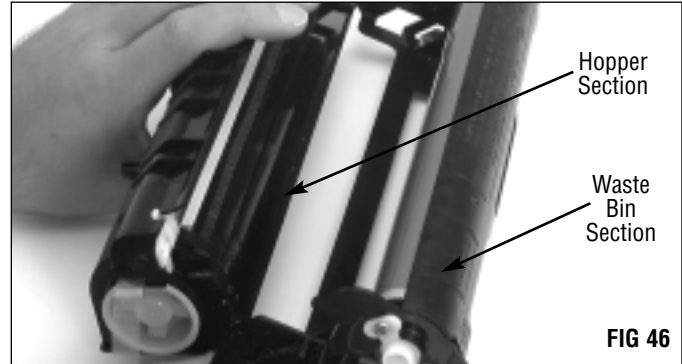




Assembling the Cartridge

1. Reposition the sections.

Position the toner hopper and waste bin sections as shown in FIG 46. Note the orientation of the drum helical gear and the mag roller drive gear.



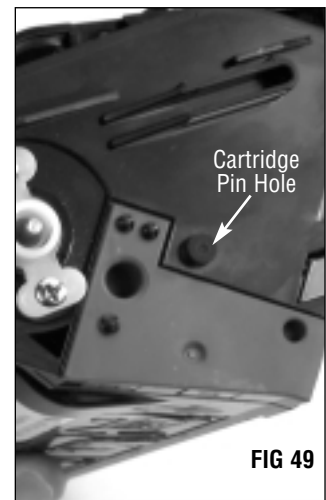
2. Rejoin the sections.

Bring the hopper and waste bin sections together (FIG 47). The springs in the lower corners of the toner hopper section should seat in the spring seats in the waste bin section.



3. Reinstall the cartridge pins.

Align the pin casing holes by gently squeezing together the two cartridge sections. Install a cartridge pin at each end of the cartridge (FIGs 48 and 49). To speed subsequent remanufacturing processes, we recommend using SCC Long Cartridge Pins (CARTPIN-L) in place of the OEM cartridge pins. SCC's cartridge pins feature a slim-line head to facilitate removal. The long cartridge pins are identified by a single dot on the head of the pin.



STATIC CONTROL COMPONENTS, INC.

SCC Imaging Division
3010 Lee Avenue • PO Box 152 • Sanford, NC 27331
US/Can 800-488-2426 • US/Can Fax 800-488-2452
Int'l 919-774-3808 • Int'l Fax 919-774-1287
www.scc-inc.com

Static Control Components (Europe) Limited
Unit 32, Sutton's Business Park • Sutton's Park Avenue • Earley
Reading • Berkshire RG6 1AZ • United Kingdom
Tel +44 (0) 118 935 1888 • Fax +44 (0) 118 935 1177