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Version 1 - June 2007
SYSTEM SUPPORT SERIES™

HP5200 (Canon® LBP-3500/3900/3950)
HP M5035MFP/HP M5027MFP (Canon® LBP-3970/3920)

Reference Info

This printer series represents the first monochrome landscape printer introduced by HP since the HP9000. The printer series, a wide-format, A3 printer features HP's Instant-On Technology that reduces warm-up time.

Each model offers a space-saving footprint ideal for today's small office environments. The printers enable high-volume print jobs and achieve print speeds up to 35 ppm and 25 ppm, respectively, for A4 documents. The entry-level LBP3500 (¥79,000/$690) also offers 25 ppm print speed and is capable of high speed data processing.

SCC's new system-matched Odyssey® toner, drum, wiper blade and chip offer excellent print performance for the HP5200 and Canon® Satera LBP3500, LBP3900 and LBP3950 printers.

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 91-99% Isopropyl Alcohol should be used for cleaning as directed in this instruction. 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.

CARTRIDGE REMANUFACTURING INSTRUCTIONS FOR:

HEWLETT PACKARD® 5200
(Canon® LBP-3500/3900/3950)
HP M5035MFP/HP M5027MFP
(Canon® LBP-3970/3920)

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For the latest cartridge information
Click on "Online Engine Center"

Other System Support Series™
documents available in
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QUESTIONS?

Please call one of our main numbers
and ask for your
Support Team Representative
or E-mail us at:

US AND CANADA
info@scc-inc.com

UK
info@scceurope.co.uk

The following table is summary of the HP5200/HPM5035/HPM5025 and Canon® LBP3500/3900/3950/3970 cartridge specifications. This information was obtained from the OEM's web site and is considered to be the most up to date information at the time of printing.

Printer Information	**Hewlett Packard® 5200**	**Hewlett Packard® 5200tn**
Printer Introduction Price	N/A	N/A
Printer Introduction	May 2006	May 2006
Print Resolution (dpi)	1200/1200	1200/1200
Print Speed (pages per minute)	35 ppm	30 ppm
Duplex	Manual	Manual
Cartridge Information		
Cartridge OEM Part Number	Q7516A	Q7516A
OEM Rated Page Yield	12,000 pages	12,000 pages

Other Printers That Cross to HP5200

Cartridge Information	**HP M5035MFP/ HP M5025MFP**	**Canon® Satera LBP3500/LBP3900/LBP3920/LBP 3950/LBP3970**
Cartridge OEM Part Number	Q7570A	509 (0045B004) / 509 VP (005B005)

Purpose of this SSS

The purpose of this SSS is to provide you a guide and the basic information needed to remanufacture a HP5200 or similar cartridges. This SSS contains information about:

- Separating the two sections.
- Disassembling each section.
- Basic cleaning.
- Reassembling the cartridge.

Your cartridge might have been changed by the original equipment manufacturer (OEM) and include parts or features which are not described in this documentation. The documentation might be updated occasionally to include information about those changes, or technical updates might be available from the SCC Web site.

Before you begin, read the entire SSS to familiarize yourself with the procedures and take notes.

Be sure to follow all necessary safety precautions while working with tools, and chemicals, such as toner and alcohol.

Illustrations

The illustrations and photos in this document might differ slightly from your cartridge. Every effort is made to include the most up to date photos and illustrations at the time of printing. However, the OEM may make changes which were not available at the time of printing.

Safety

Statement 1:

Always wear eye protection while operating power tools.

Statement 2:

Always wear eye protection and protective clothing while working with toner and/or other chemicals.

Statement 3:

Do not swallow or ingest toner, isopropyl alcohol, toner dust, or any chemicals or materials used in the process of remanufacturing

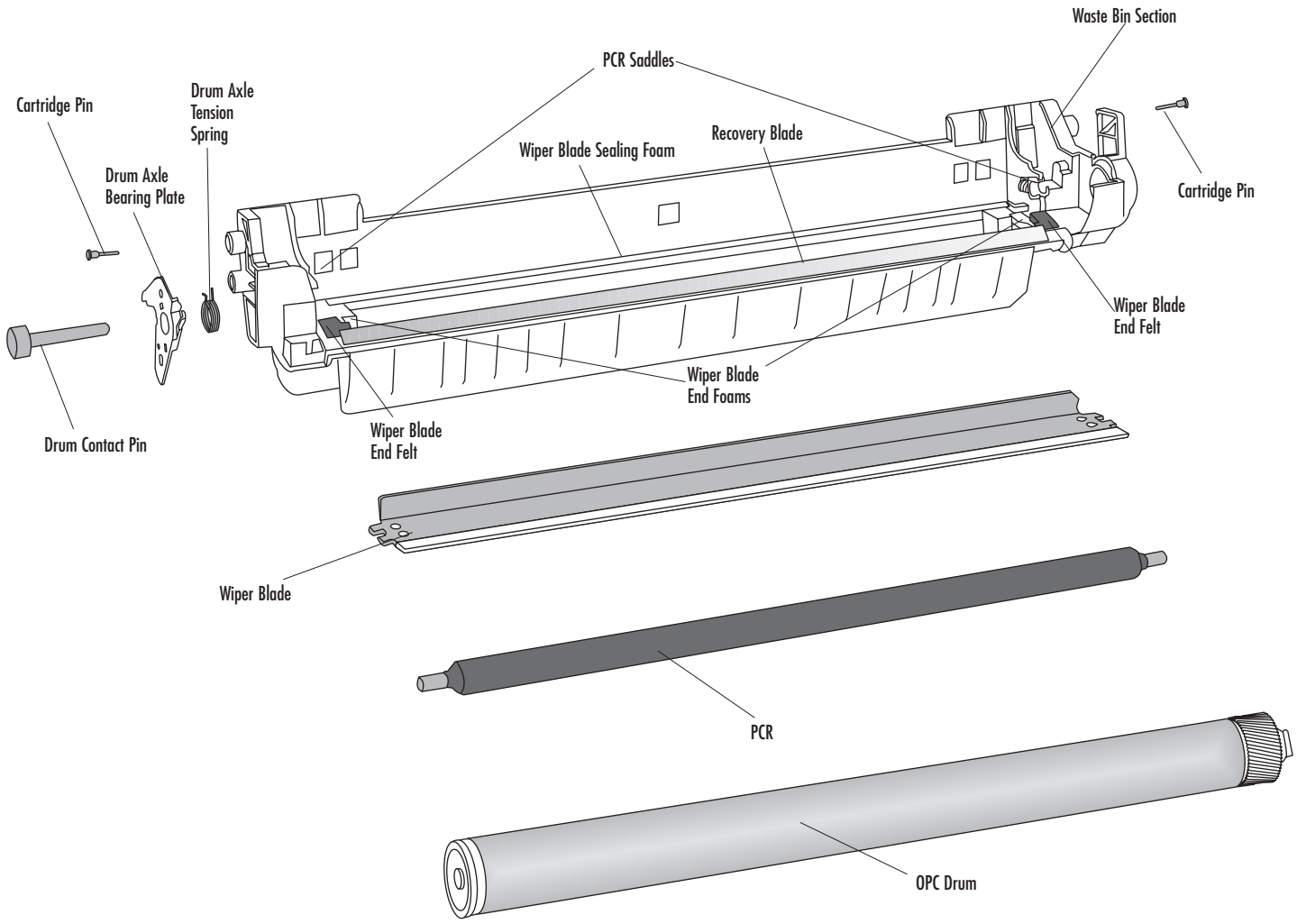
Needed Tools & Supplies

For Basic Remanufacturing:

- Phillips Screwdriver
- Needle Nose Pliers
- Small Needle Nose Pliers
- Compressed Air for Cleaning
- 91%-99% Isopropyl Alcohol
- Lint-Free Foam Tip Swab (LFSWAB)
- Lint-Free Cleaning Cloth (LFCCLOTH)
- Toner Pour Spout For Toner Bottle (TPS90)
- Felt Foam Scraper Tool (FSTOOL)
- Safety Glasses
- Small Flat Blade Screwdriver
- Kynar Powder (KPOW)
- Pry Tool (PRYTOOL-2)
- Hopper Jig (HP52HJIG)
- Pin Removal Kit (HP52PRKIT)
- Conductive Cartridge Lube (CONLUBE)
- End Plate Removal Kit (HP52EPRKIT)
- Hopper Entry Kit (HP52HEKIT)
    - Hopper Entry Tool (HP52HETOOL)
    - Hopper Entry Tool Jig (HP52HEJIG)
- Manual Splitting Tool (HP52SPLITOOL)
- Aluminum Hammer (WXHAMMER)
- Curved Scraper Blade Tool (CSBTOOL)
- HP1320 Hopper Cap (HP1320FMHCAP)

Contact Side

Drive Side

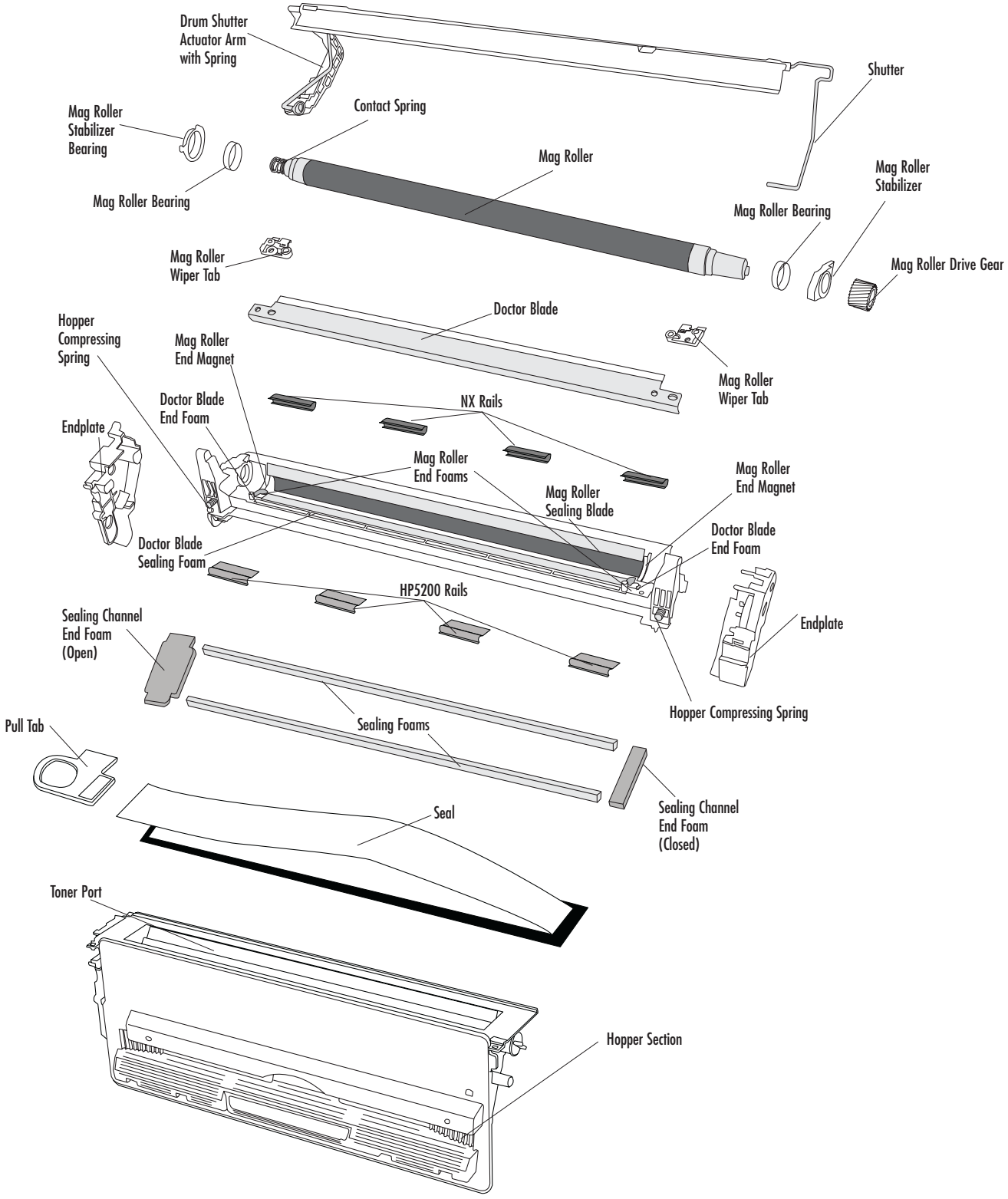


Waste Bin Assembly

product wirelines

Contact Side

Drive Side



Toner Hopper Assembly

product wirelines

Separating the two sections

REMANUFACTURING THE **HEWLETT PACKARD® 5200**

This section provides the information needed to separate the toner hopper and waste bin sections from each other. Before attempting to perform the following procedures, read the entire section carefully. Ensure that you follow all necessary safety precautions.

1. Remove the drum shutter actuator arm from the hopper. See Figure 1a. Using a small flat blade screwdriver, press the tab (Figure 1b) on the drum shutter actuator arm and push out to release the arm away from the hopper as shown in Figure 1c. Be careful not to break the tab.

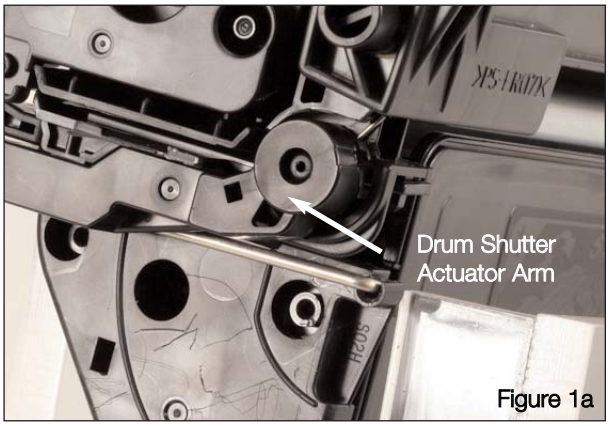


Figure 1a

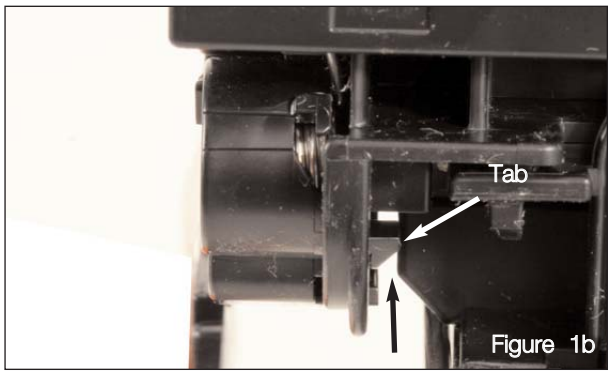


Figure 1b

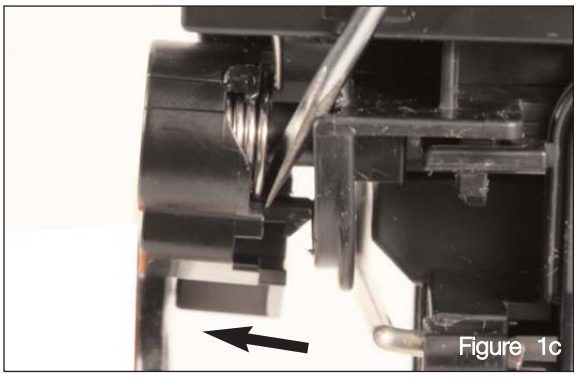


Figure 1c

Note: Reset the drum shutter actuator spring as shown in Figure 2 and set aside for reassembly.

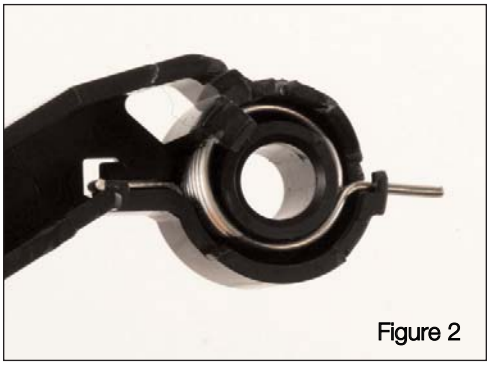


Figure 2

2. Remove the other drum shutter arm from the hopper by rotating the shutter. See Figure 3 & 4.

Note: The shutter is keyed on both ends. Rotate the shutter until the keyed part is in the correct position.

Figure 3

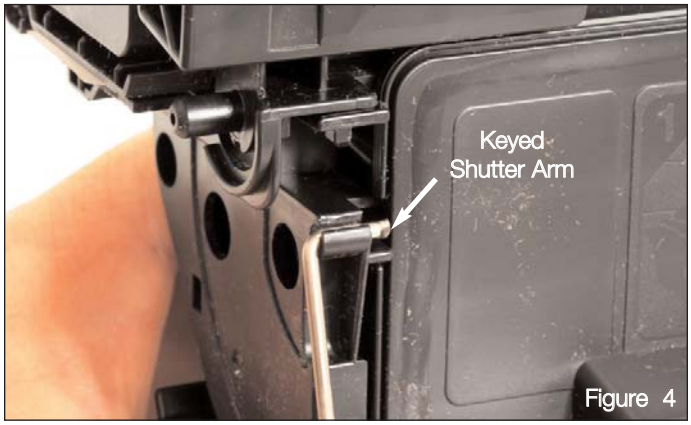


Figure 4

3. Place the pin removal jig onto the cartridge (beveled side inward) as shown in Figure 5a.

4. Insert the drill bit into the drill and secure. Drill the two holes in the cartridge, as shown in Figure 6b.

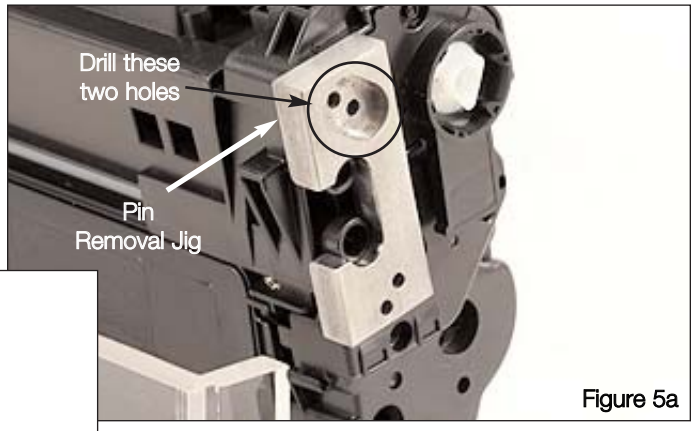


Figure 5a

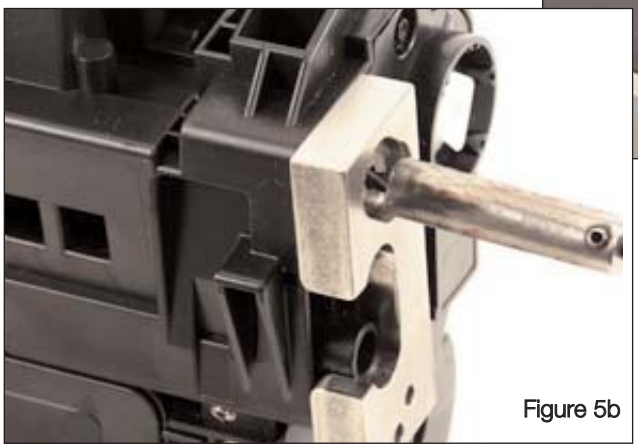


Figure 5b

Note: For illustration purposes the drilling is shown without holding the jig, however the jig needs to be held in place during drilling.

5. Repeat steps 3 & 4 on the contact side of the cartridge as shown in Figure 6a & 6b.

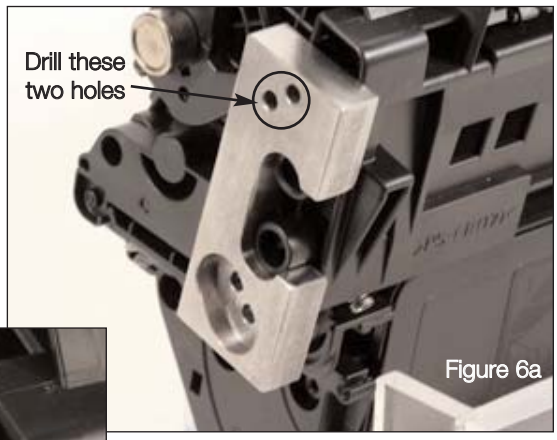


Figure 6a

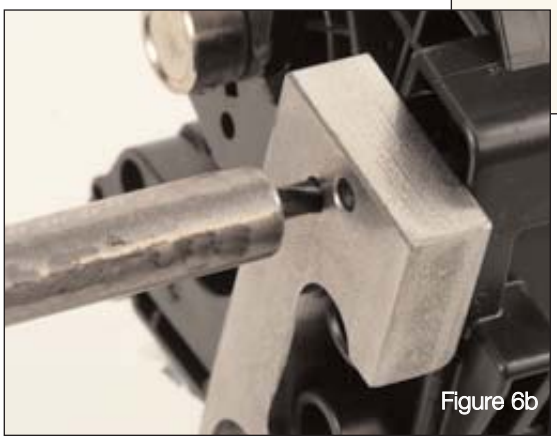


Figure 6b

6. Using small needlenose pliers, remove the cartridge pins. See Figure 7a & 7b.

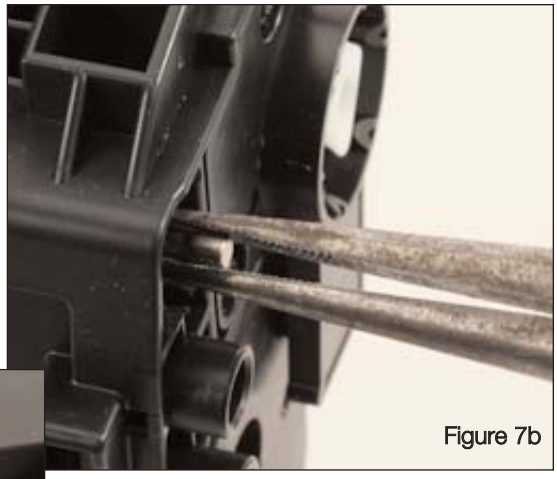


Figure 7b

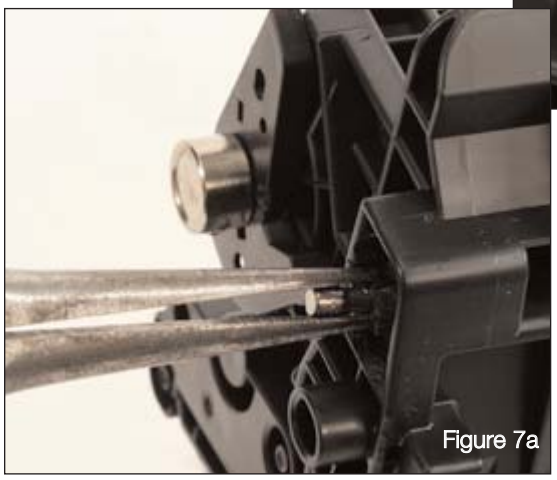


Figure 7a

7. Separate the two sections as shown in Figure 8.

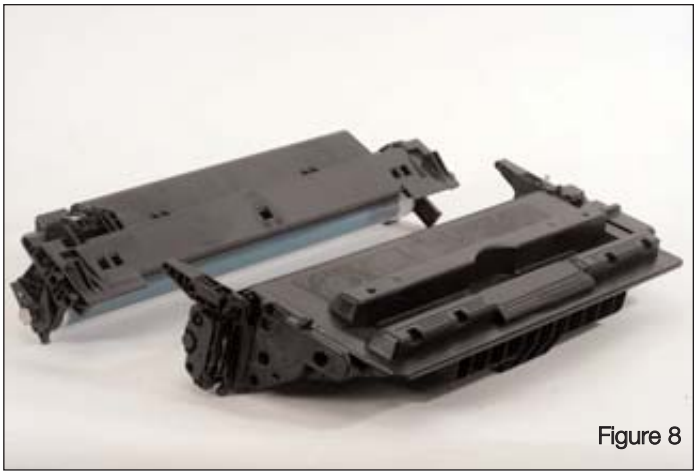


Figure 8

Disassembling the Waste Bin Section

This section provides the information needed to disassemble the waste bin section of the cartridge. At this point you should have separated the toner hopper section from the waste bin, as described earlier in this SSS™. For information on separating the two sections see "*Separating the Toner Hopper and Waste Bin*" on page 1. Before attempting to perform the following procedures, read the entire section carefully. Ensure that you follow all necessary safety precautions.

1. Using needlenose pliers, remove the drum contact pin, see Figure 9.

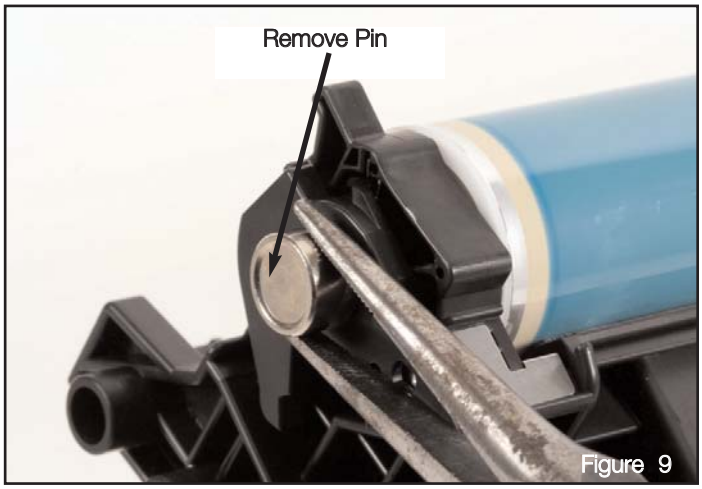


Figure 9

2. Remove the drum axle bearing plate with spring as shown in Figure 10a. Make sure not to lose the spring. Reset the drum axle bearing plate spring as shown in 10b and set aside for reassembly.


Figure 10a

Figure 10b

3. Remove the OPC drum from the waste bin by lifting from the contact side and removing in the direction shown in Figure 11.

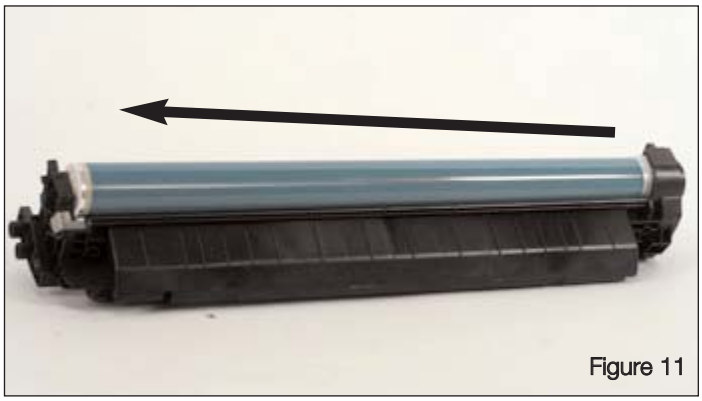


Figure 11

4. Remove the primary charge roller (PCR). Using both hands, grasp the PCR by the shaft and remove it from the PCR saddles as shown in Figure 12. Using a lint free cloth, saturated with deionized water, clean the PCR and set aside to dry.

Note: For illustration purposes, only one hand is shown lifting the PCR.

Figure 12

5. Using a phillips screwdriver remove the two screws on the wiper blade, see Figure 13.

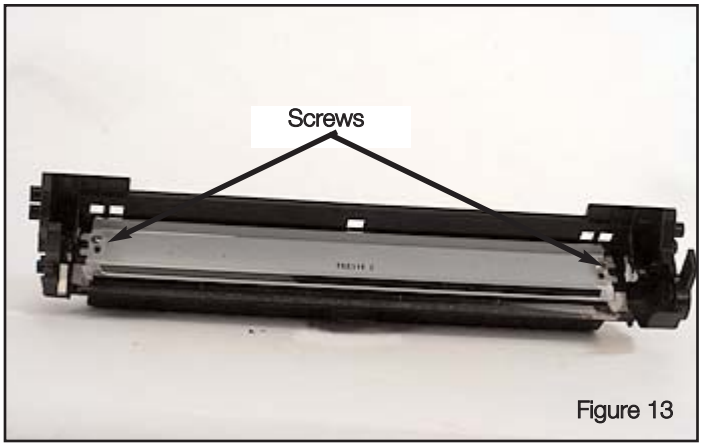


Figure 13

6. Dump any waste toner from the waste bin and clean with dry, filtered compressed air, see Figure 14.

Figure 14

Reassembling the Waste Bin Section

This section provides the information needed to assemble the waste bin section of the cartridge. At this point you should have disassembled and cleaned the entire waste bin as described in this SSS™. If you have not disassembled and cleaned the waste bin see page 1 for instructions. Before attempting to perform the following procedures, read the entire section carefully. Ensure that you follow all necessary safety precautions.

1. Inspect the recovery blade, the wiper blade end felts, the wiper blade end foams, and the wiper blade sealing foam for tears, damage or embedded with toner. Replace if necessary, see Figure 15a, 15b & 15c.

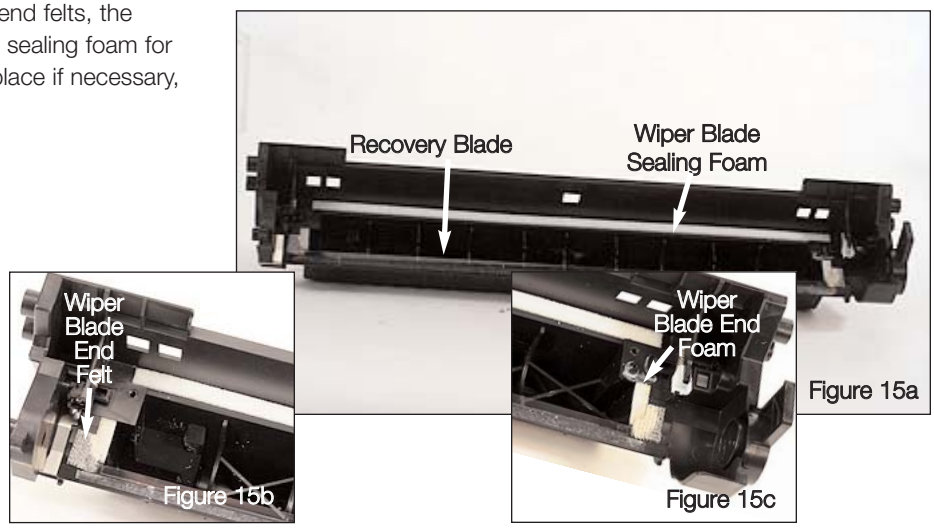


Figure 15a

Figure 15b

Figure 15c

2. Install the wiper blade.

   a. Dip the working edge of the wiper blade in a trough of Kynar™ powder, lubricating the wiper blade. Then repeat once to ensure even coverage.

   b. Using a screwdriver, tap the metal stamping of the blade to remove any excess Kynar™ powder.

   c. Install the wiper blade and secure with two Phillips screws, see Figure 16

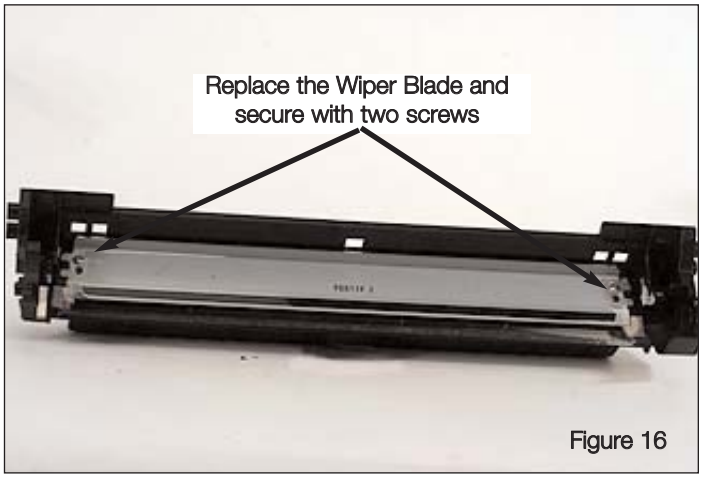


Figure 16

3. Install the PCR in the waste bin section.

   a. Clean the black conductive PCR saddle on the Contact side of the waste bin with a cotton-tipped swab, dampened with 91-99% isopropyl alcohol, see Figure 17a.

   b. Using the lint free swab, apply a small amount of conductive cartridge lubricant to the inside of the black PCR saddle, as shown in Figure 17b.

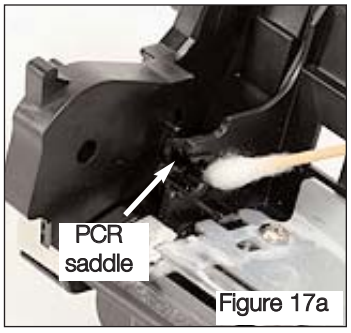


Figure 17a

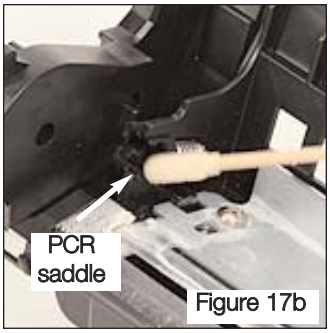


Figure 17b

c. Install PCR into PCR saddles making sure the PCR snaps into place, as shown in Figure 18. Use two hands to snap the PCR back into place.

Note: For illustration purposes, only one hand is shown installing the PCR.

Figure 18

4. Lightly dust the OPC drum with Kynar™ powder and install the drum, drive side first. See Figure 19.

Note: Keep OPC covered to avoid light damage.

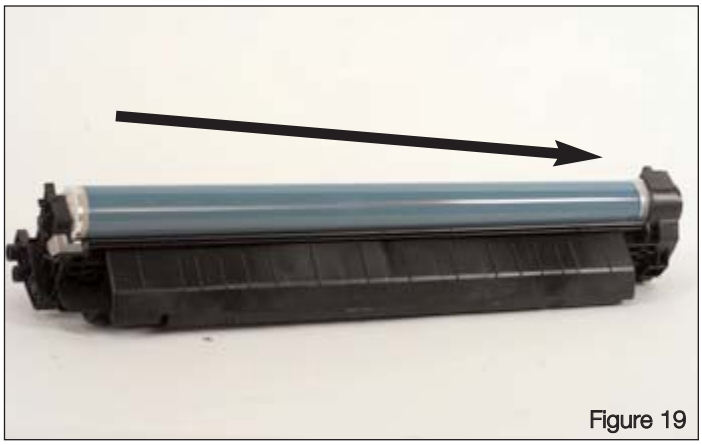


Figure 19

a. Make sure that the spring is positioned in the drum axle bearing plate as shown in Figure 20.

Figure 20

b. Install the drum axle bearing plate. Make sure to align the spring as shown in Figure 21a. Install the drum contact pin as shown in Figure 21b.

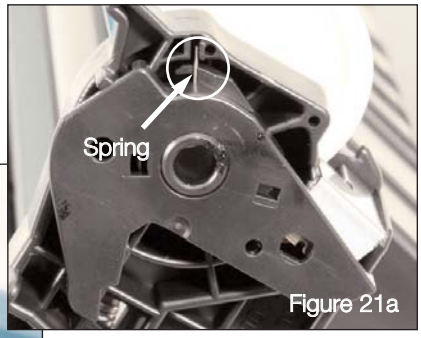


Figure 21a

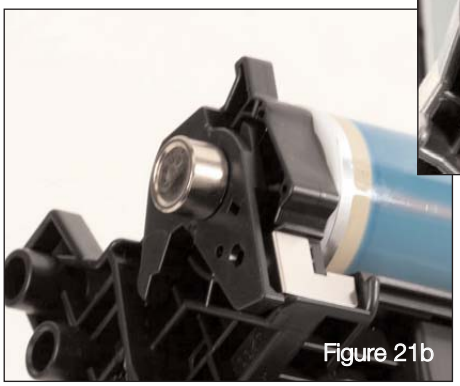


Figure 21b

c. Rotate the drum axle bearing plate to activate the tension spring as shown in Figure 22.


Figure 22

5. Rotate the drum to set the Kynar™ powder on the working edge of the blade. Use a dry lint-free cloth to wipe any residual Kynar™ from the PCR.

Note: Set the waste bin aside, until needed for reassembly. Ensure that the OPC drum is covered and protected from light.

Disassembling the Toner Hopper Section

This section provides the information needed to disassemble the toner hopper section of the cartridge. At this point you should have disassembled and cleaned the entire waste bin as described in this SSS™. If you have not disassembled and cleaned the waste bin see page 1 for instructions. Before attempting to perform the following procedures, read the entire section carefully. Ensure that you follow all necessary safety precautions.

1. Seat the drill template on the end plate by matching the alignment bosses on the template with the cavities on the end plate. See A & B in Figure 23a & 23b.

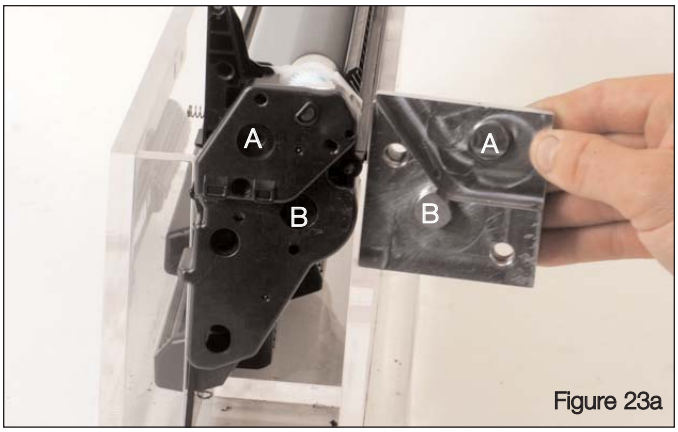


Figure 23a

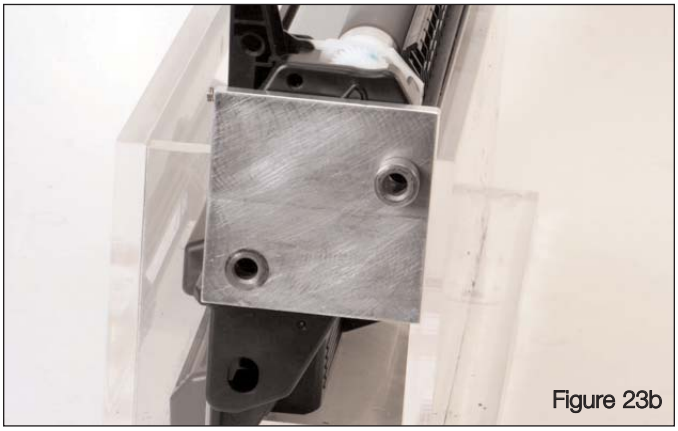


Figure 23b

Note: Hearing and eye protection must be worn when working with any power tool. The drill bit has a stop collar. The stop collar is needed to prevent drilling through hopper wall.

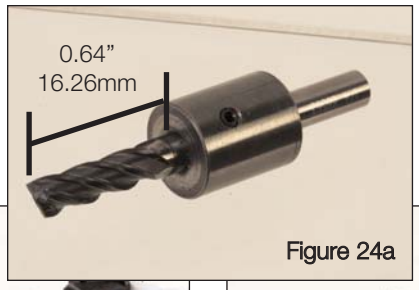


Figure 24a

2. Using an electric drill and the HP5200 end plate removal cutting bit (Figure 24a), carefully drill the first two holes (Figures 24b & 24c). Be sure to hold the template to prevent misalignment.

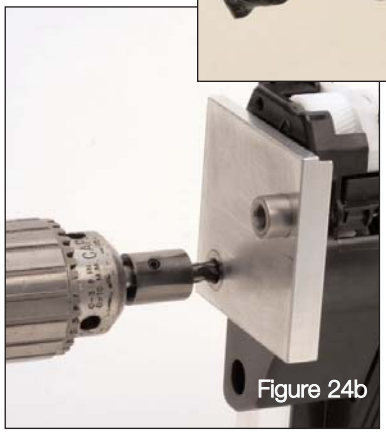


Figure 24b

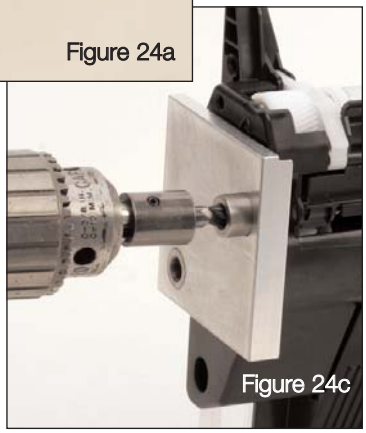


Figure 24c

Note: For illustration purposes the drilling is shown without holding the jig, however the jig needs to be held in place during drilling.

Disassembling the Toner Hopper Section

3. Remove the HP5200 end plate removal cutting bit from the drill and place the HP5200 end plate removal bit (Figure 25a) into the drill. Carefully repeat the drilling in the two holes (Figures 25b & 25c).

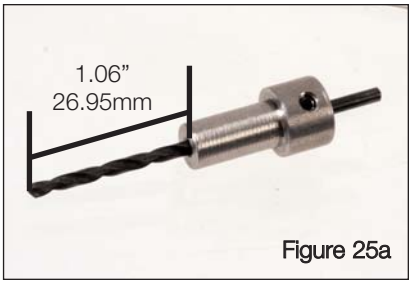


Figure 25a

Note: For illustration purposes the drilling is shown without holding the jig, however the jig needs to be held in place during drilling.

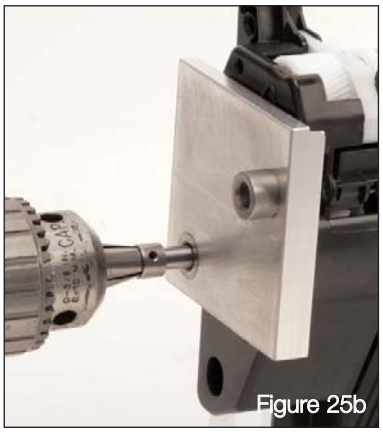


Figure 25b


Figure 25c

4. Remove the end plate as shown in Figure 26a.

Note: If necessary, use the pry tool to pry the end plate off. See Figure 26b.

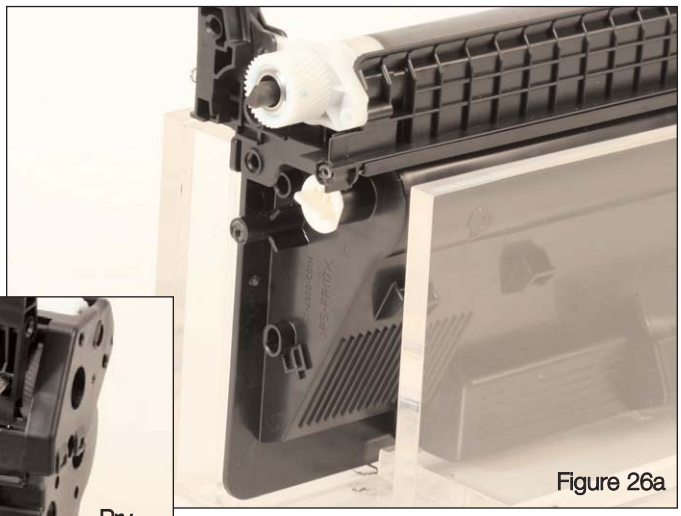


Figure 26a

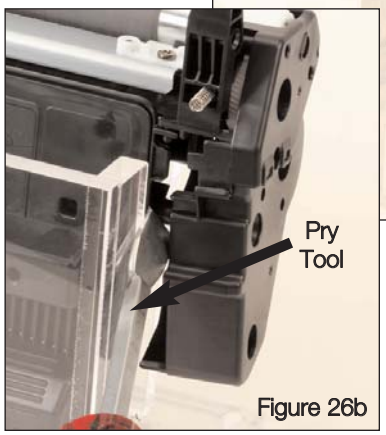


Figure 26b

5. Remove the mag roller gear as shown in Figure 27.


Figure 27

6. Lift the mag roller in order to remove the mag roller stabilizer as shown in Figure 28.

Figure 28

7. Lift the mag roller from the toner hopper section as shown in Figure 29a. Be careful not to scratch the mag roller and damage the doctor blade. Remove the two mag roller bearing from the mag roller.

Note: Be careful not to lose the spring. See Figure 29b.

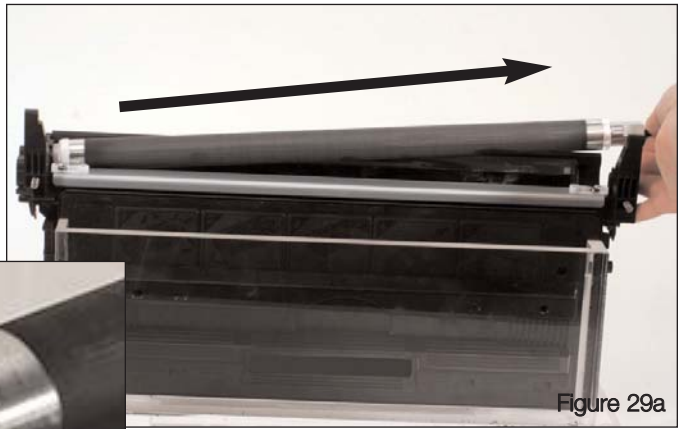


Figure 29a

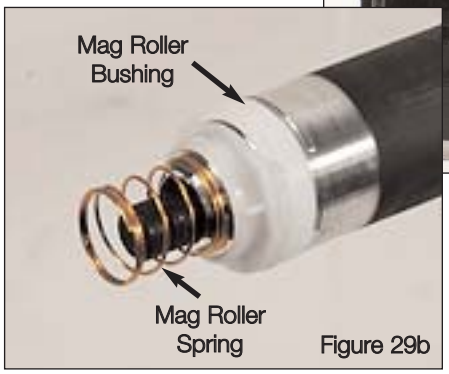


Figure 29b

8. Remove the mag roller stabilizer bearing as shown in Figure 30.

Figure 30

9. Using a phillips screwdriver, remove the two screws that secure the doctor blade to the hopper, as shown in Figure 31.

Note: The doctor blade screws are longer than others in the cartridge. Be sure to place them back in the same place.

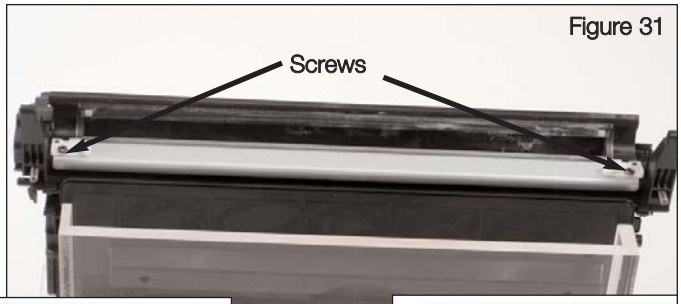


Figure 31

10. Remove the mag roller wiper tabs from each end of the doctor blade, as shown in Figure 32 & 33.

11. Remove the doctor blade from the hopper. Clean

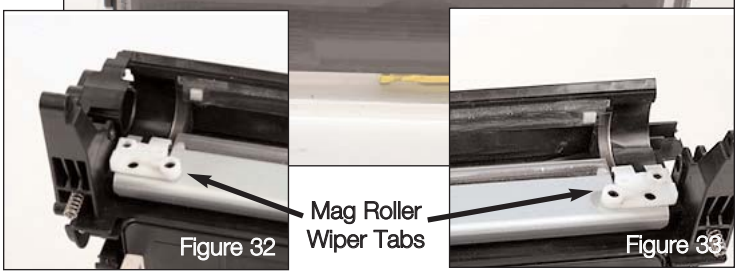


Figure 32
Figure 33

12. Inspect the mag roller sealing blade for signs of wear or damage, replace if necessary as shown in Figure 34, 35 & 36. Inspect foams and replace if torn, damaged or embedded with toner.

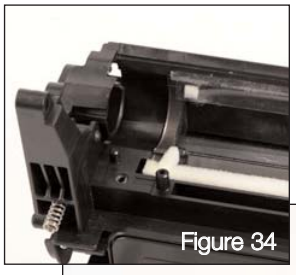


Figure 34

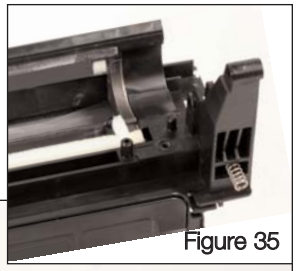


Figure 35


Figure 36

Open and Fill the Hopper

Note: Be sure to wear safety glasses while doing the following steps.

1. Place the slot of the hopper entry jig (Figure 37b) onto the rib of the hopper such that the hopper boss fits in jig recess and tighten the thumb screw as shown in Figure 37a.

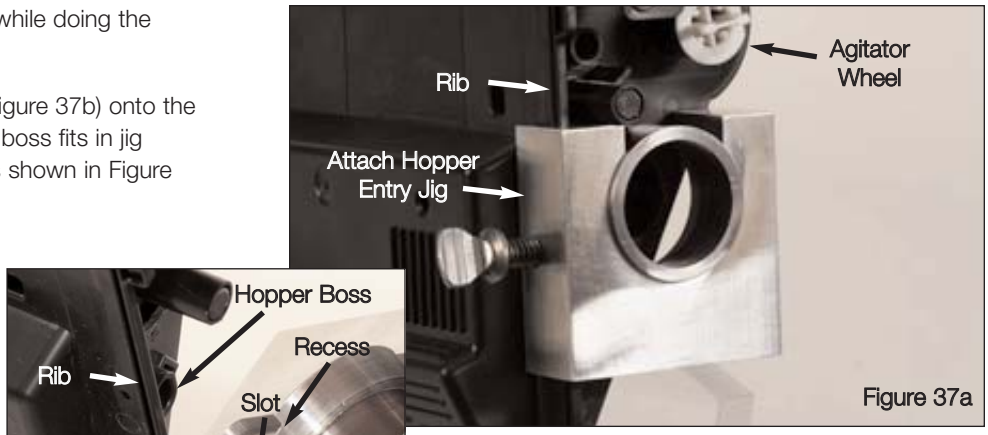


Figure 37a

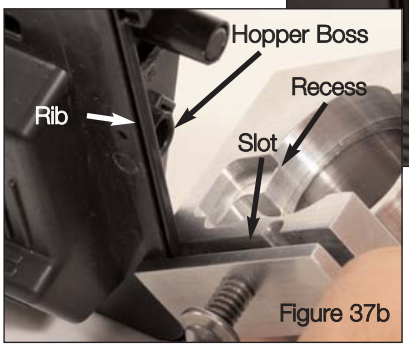


Figure 37b

2. Using a drill, fit the hopper entry tool into the provided space and cut a hole, as shown in Figure 38.

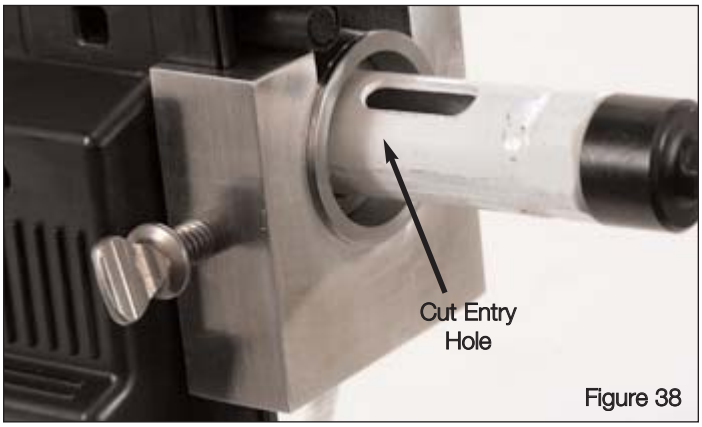


Figure 38

3. Deburr the toner hole with a scraper tool. Clean the hopper using dry, filtered compressed air. Be sure that all plastic shavings and remaining toner are removed from inside the hopper and the surface where the hopper cap will be placed, see Figure 39.


Figure 39

4. Fill hopper with qualified toner. Clean the surface around the toner port opening with 91-99% Isopropyl alcohol and a cotton swab or a dry lint free cloth, as shown in Figure 40.

Figure 40

5. Peel the backing from the hopper cap, as shown in Figure 41a. Attach the hopper cap, to cover the hopper entry hole. See Figure 41b. Ensure that the hopper cap is centered over the hopper entry hole. Misalignment may result in toner leakage. Firmly press down the hopper cap to activate the pressure sensitive adhesive.

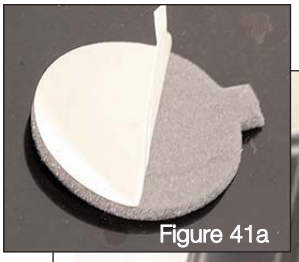


Figure 41a

Figure 41b

Split and Seal the Hopper

1. Using a utility knife, cut the weld and peg on the corner of the hopper as shown in Figure 42.

Note: Be careful not to break or cut the bracket that secures the shutter arm.

Figure 42

2. Secure the hopper jig to the working surface. Place the hopper assembly in the HP5200 hopper jig, see Figure 43.


Figure 43

3. While holding the hopper steady, insert the pry tool into the seal exit port at the lower side of the hopper. See Figure 44. Twist pry tool to break the plastic weld.

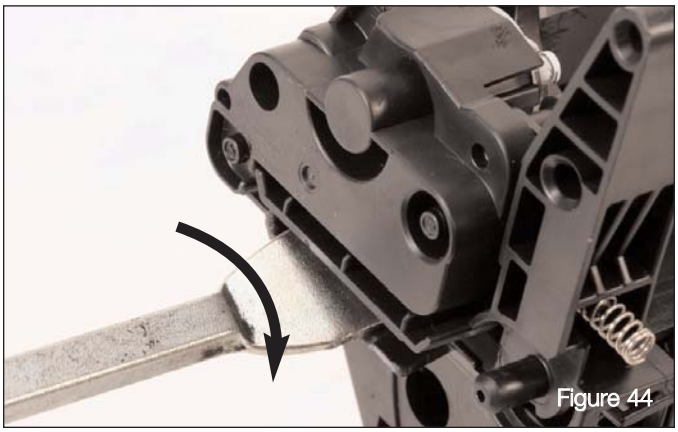


Figure 44

4. Inserting the splitter tool into position. Blade notches (Figure 45a) should be facing down when inserting into the hopper.

   a. Using the splitter tool, slide the tool in at an angle as shown in Figure 45b.

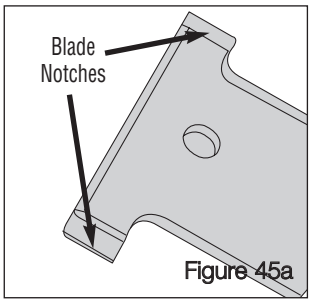


Figure 45a

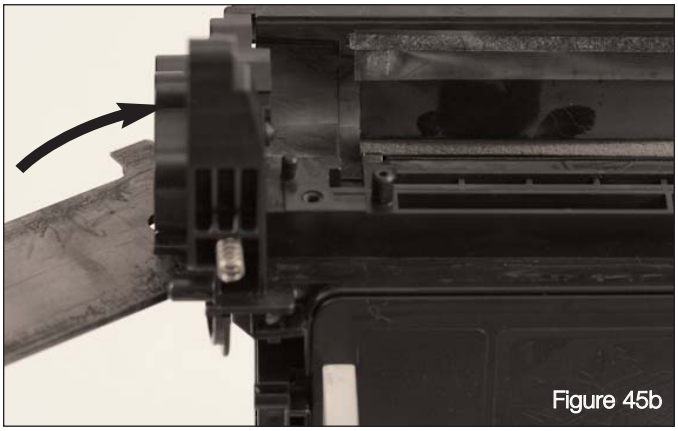


Figure 45b

   b. Then, rotate and slide the tool towards hopper top as shown in Figure 46a. The tool will slide over the ramp and along the welds in order for proper alignment. See Figure 46b for proper orientation.

Note: Figures 46a & 46b show the hopper already split in order to see the welds that are being cut.

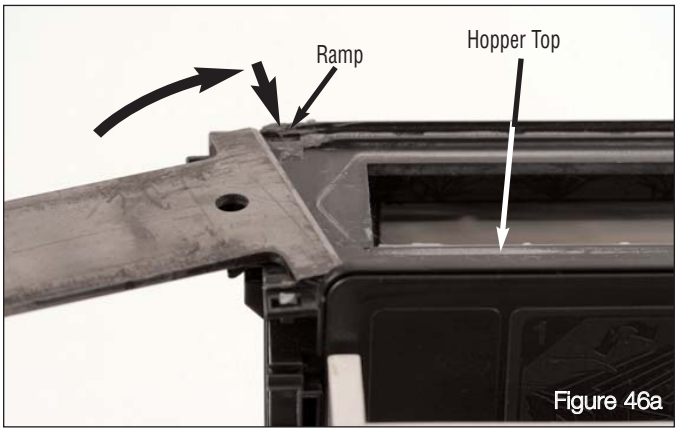


Figure 46a

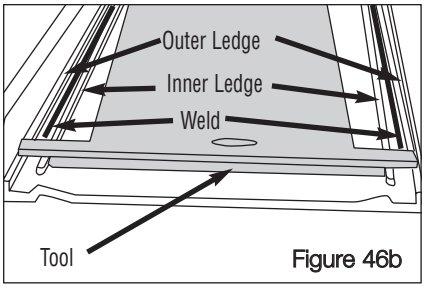


Figure 46b

   c. Finally, push the tool forward in order to orient the tool in the proper position above the exit port, see Figure 47a & 47b.

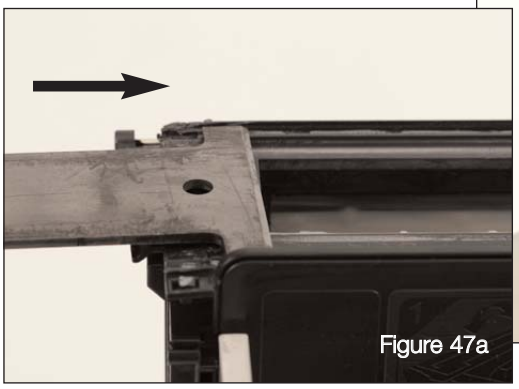


Figure 47a

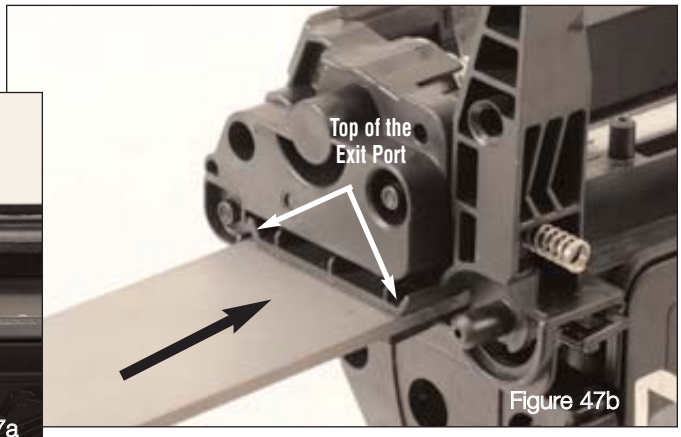


Figure 47b

Note: Figures 48 shows the proper alignment on the lower ramp and the breaking of the plastic weld on the side.

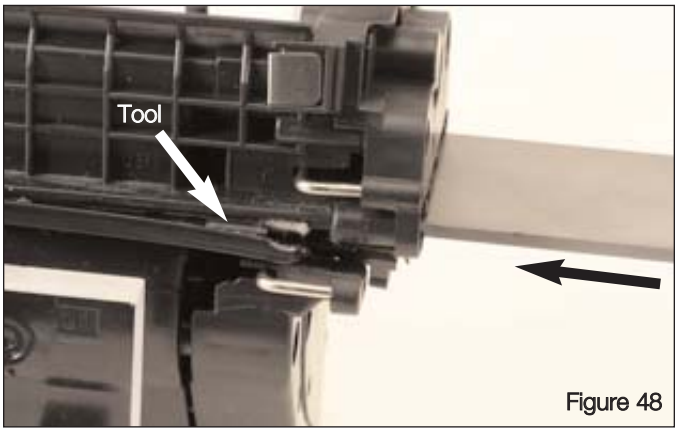


Figure 48

5. Using a hammer, tap on the end of the tool in order for the tool to break the plastic weld. Make sure to keep the tool straight and level at all times, using minimal upward pressure on the tool. See Figure 49a. The peg on the end may break in splitting process. See Figure 49b.

Note: Refer to Figure 46 & 48f to maintain a straight path while hammering.

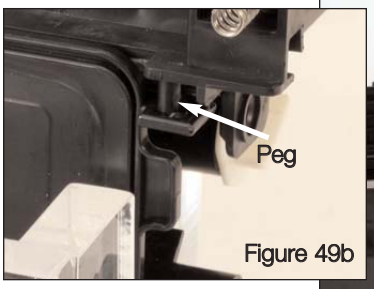


Figure 49b

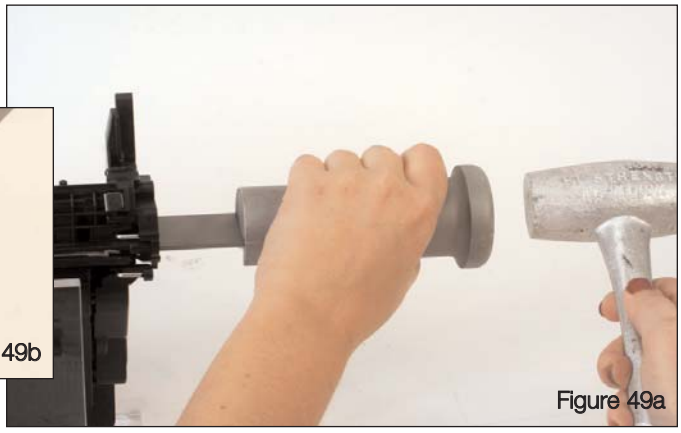


Figure 49a

Important: Ensure the same mag roller section is mated to the same hopper section when reassembling.

6. Thoroughly clean the hopper with dry, filtered compressed air as shown in Figure 50. Inspect the sealing surface. Remove any residual seal material if present. Moisten a lint-free cloth with 91-99% isopropyl alcohol and clean the surface as shown in Figure 50.

Figure 50

7. Remove the release liner from the seal as shown in Figure 51.

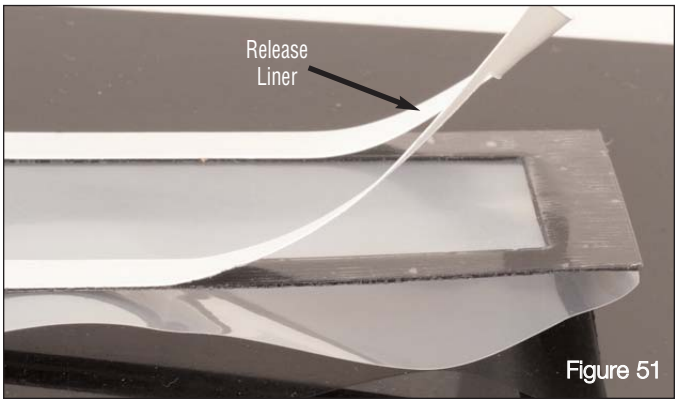


Figure 51

8. Position the seal over the seal opening as shown in Figure 52a, butting the left end of the seal into the inside edge of the hopper. See Figure 52b. Make sure the back of the seal rests flush on the sealing surface and is not up over the back ledge. See Figure 52c.

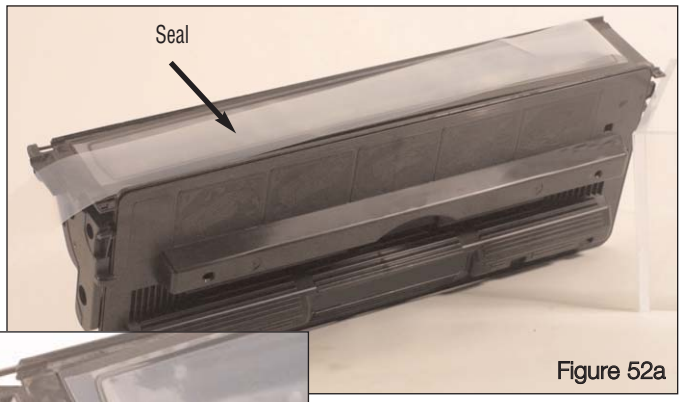


Figure 52a

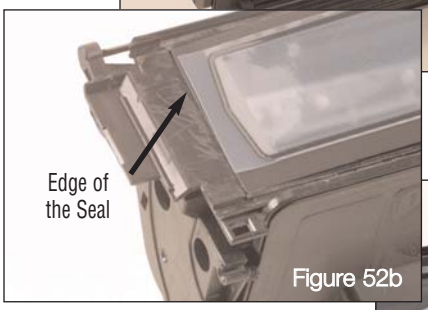


Figure 52b

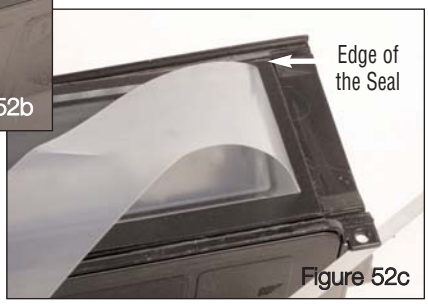


Figure 52c

9. Apply pressure to the perimeter of the seal to secure as shown in Figure 53.

Note: The HP5200 seal features pressure sensitive adhesive. You must apply pressure to the entire perimeter of the seal to activate the adhesive.

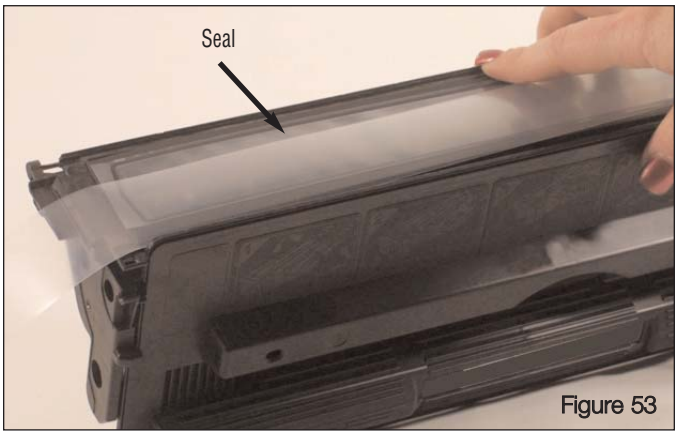


Figure 53

10. Position the mag roller section as seen in Figure 54a. Remove the existing sealing channel end foams on each side of the mag section using a scraper tool. See Figure 54b.

Figure 54a

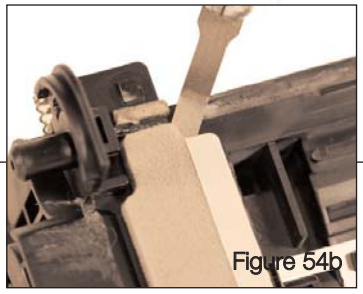


Figure 54b

11. Moisten a lint-free cleaning cloth with 91%-99% isopropyl alcohol and clean the sealing channel surface. See Figure 55. Make sure to remove any residual material and plastic shavings to ensure a clean surface to apply sealing foams.

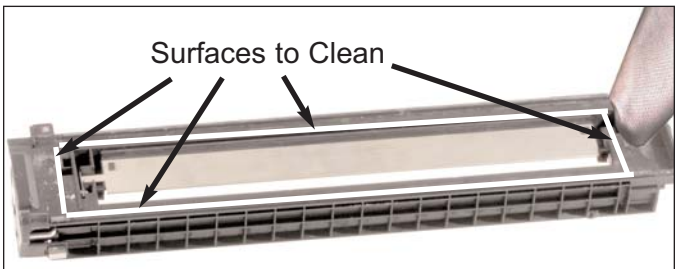


Figure 55

12. Replace the sealing channel end foam - open:

    a. Remove the protective backing from the new sealing channel end foam.

    b. Align the end foam with the inside ledge of the sealing channel surface and set the end foam in place. See diagram for placement as shown in Figure 56.

    c. Press down firmly on the end foam to activate the pressure sensitive adhesive.

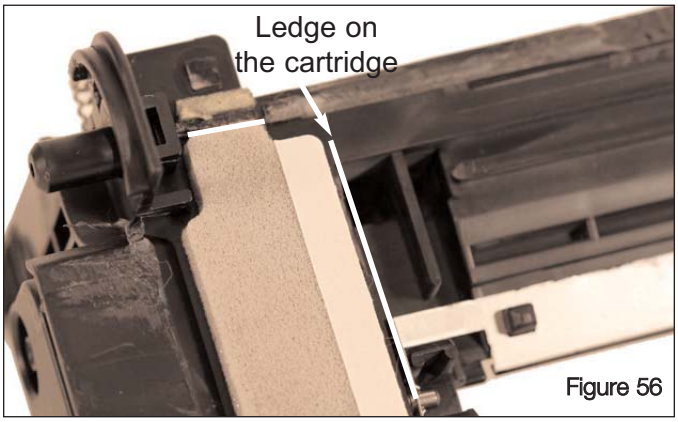


Figure 56

13. Replace the sealing channel end foam - closed:

a. Remove the protective backing from the new sealing channel end foam.

b. Align the upper right corner of the end foam with the top right corner and align with the outside ledge of the sealing channel surface and set the end foam in place. See diagram for placement as shown in Figure 57.

c. Press down firmly on the end felt to activate the pressure sensitive adhesive.

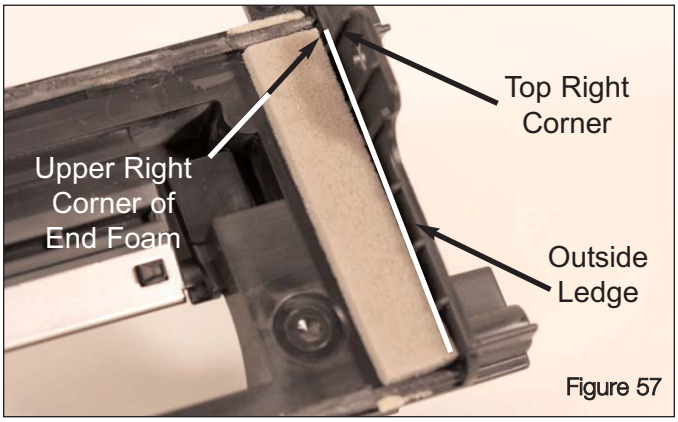


Figure 57

14. Install the HP5200 sealing channel rail foams.

a. Remove the sealing channel rail foam from the adhesive backing as shown in Figure 58a and place the end approximately half way over the sealing channel end foam as shown in Figure 58b.

b. Ensure the rail foam is aligned against the inside recessed edge along the perimeter of the sealing channel, see Figure 58b.

c. The end of the rail foam should lap over the end foam on the opposite end of mag section. Take care to not stretch or pull the foam as you are installing it.

Note: Apply pressure along the entire length of the sealing foam to activate the pressure sensitive adhesive.

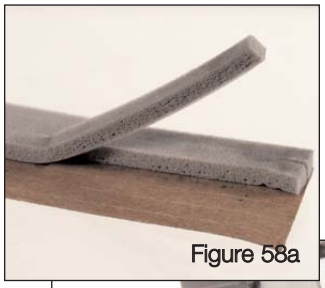


Figure 58a

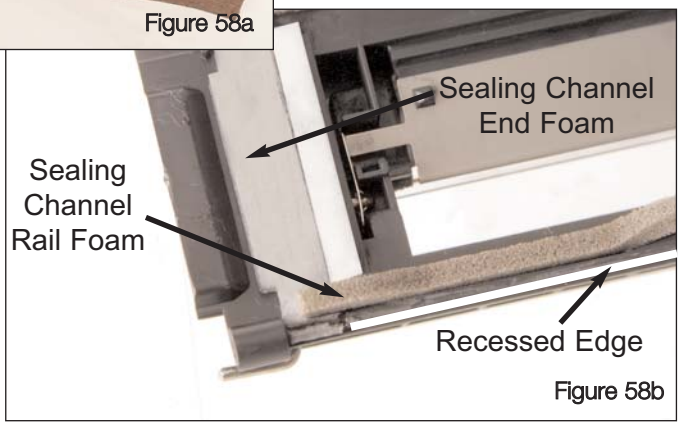


Figure 58b

15. Install the second HP5200 sealing channel rail foam.

a. Remove the sealing channel rail foam from the adhesive backing and place the end approximately half way over the sealing channel end foam as shown in Figure 59a.

b. Ensure the rail foam is aligned against the inside recessed edge along the perimeter of the sealing channel, see Figure 59a.

c. The end of the rail foam should lap over the end foam on the opposite end of mag section. Take care to not stretch or pull the foam as you are installing it.

Note: Apply pressure along the entire length of the sealing foam to activate the pressure sensitive adhesive.

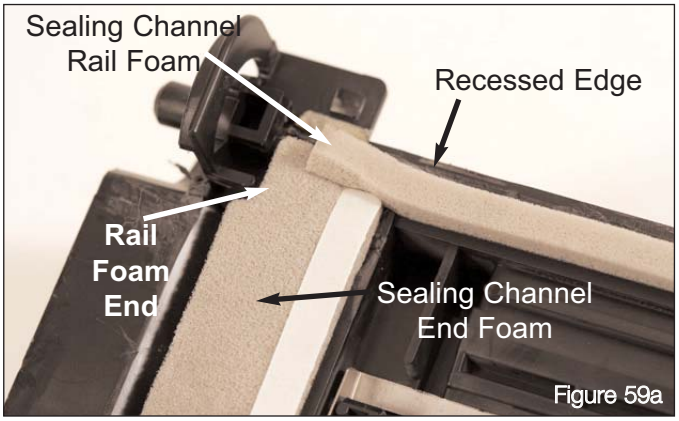


Figure 59a

e. The foams should be placed as shown in Figure 59b, 59c & 59d.

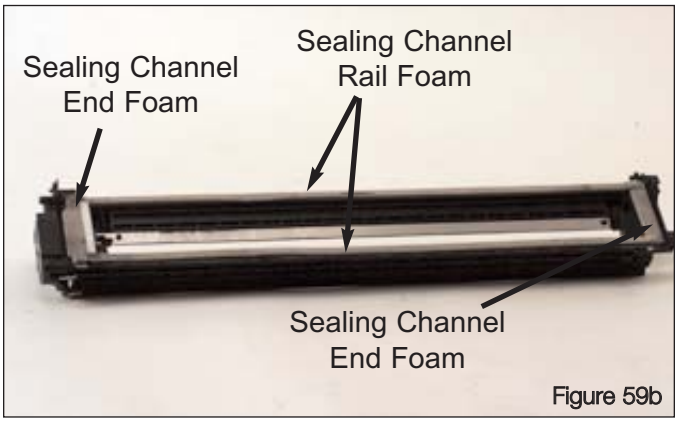


Figure 59b

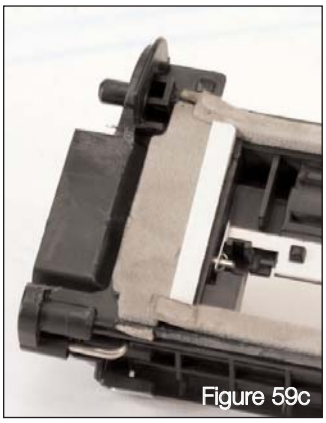


Figure 59c


Figure 59d

16. While holding the seal tail, place the mag section onto the hopper. Apply pressure to the mag section in order to compress the foams so that the rails can be fully seated. Place two NX locking rails in the middle of the lower section of the hopper. See Figure 60b for proper orientation. Position the other two rails (one on each end) on the hopper as shown in Figure 60a.

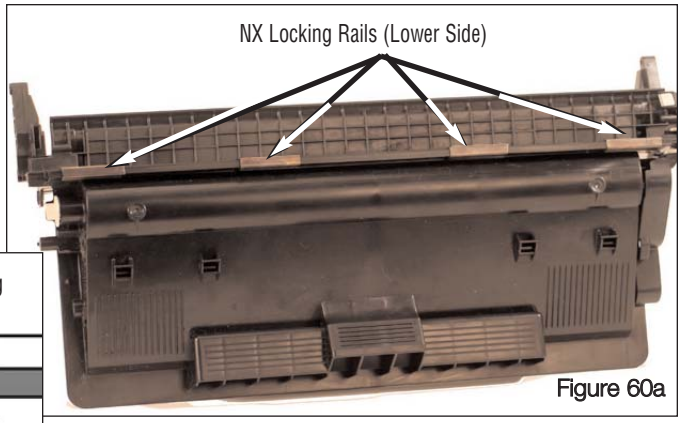


Figure 60a

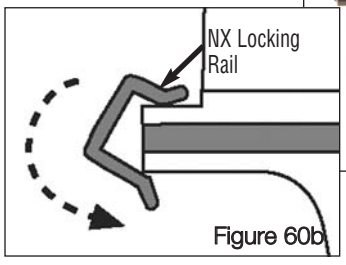


Figure 60b

17. Apply pressure to mag section to compress foams so that the rails are fully seated. Place two HP5200 cartridge locking rails in the middle of the upper section of the hopper. See Figure 61a for orientation. Then position the other two locking rails (one on each end) on the hopper as shown in Figure 61b.

Note: Locking rails are shown in silver for this illustration but are actually black.

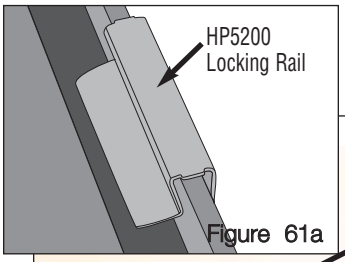


Figure 61a

Figure 61b

18. Install the pull tab.

a. Remove a single adhesive strip from the multi-strip sheet and position the adhesive on the pull tab.

b. Remove the adhesive backing from the adhesive strip shown in Figure 62.

c. Hold the seal tail up and butt the pull tab (adhesive facing up) against the seal exit port. See Figure 63.

d. Apply pressure to the pull tab and seal tail to secure.

e. Remove the excess seal tail.


Figure 62

Figure 63

Reassembling the Toner Hopper Section

REMANUFACTURING THE **HEWLETT PACKARD® 5200**

This section provides the information needed to reassemble the toner hopper section of the cartridge. At this point you should have disassembled and cleaned the entire cartridge as described in this SSS™. If you have not disassembled and cleaned the cartridge see page 1 for instructions. Before attempting to perform the following procedures, read the entire section carefully. Ensure that you follow all necessary safety precautions. The illustrations in this section show an unsplit cartridge.

1. Place the doctor blade on to the locating pins in the hopper. Place the mag roller wiper tabs on each end of the doctor blade. See Figure 65 & 66. Install the doctor blade and secure with screws on each end, see Figure 64.

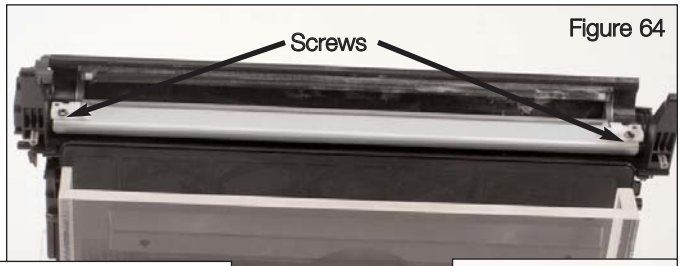


Figure 64


Figure 65

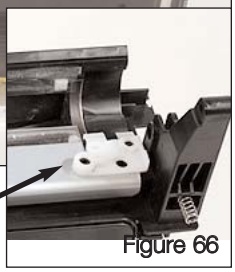


Figure 66

Mag Roller Wiper Tabs

Note: Use the two long screws that were removed during the disassembly of the hopper.

2. Install the mag roller. See Figure 67.

   a. Using a lint-free cotton swab, remove the residual contaminated conductive lubricant. With the wooden end of the lint-free cotton swab, apply a fresh coating of conductive lubricant to the contact plate.

   b. Reinstall the mag roller stabilizer.

   c. Be sure that the mag roller bearings are on the mag roller.

   d. With the flat of the stabilizer facing the mag roller bearing, install the stabilizer on to the drive side of the mag roller, see Figure 68.

   e. Place the mag roller drive gear onto the roller, then place the mag roller completely into the hopper, see Figure 69.

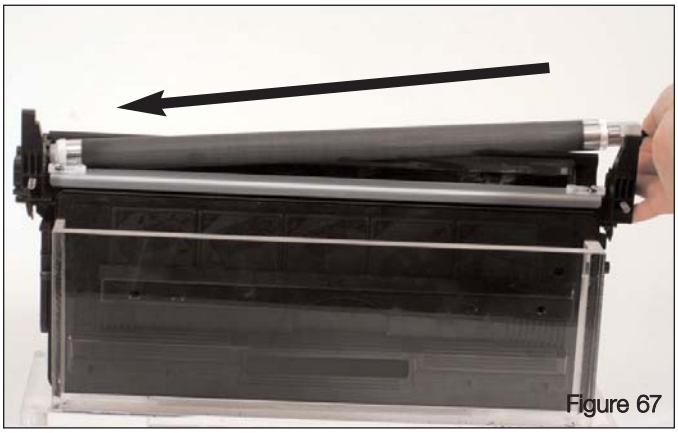


Figure 67

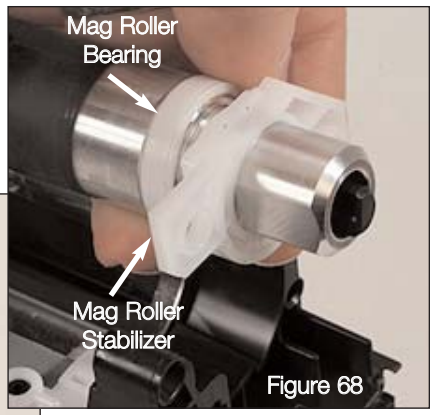


Figure 68

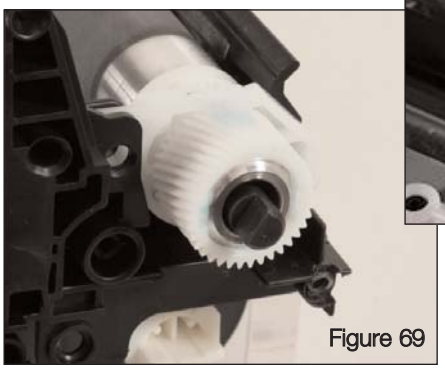


Figure 69

3. Fit the drive side end plate to the hopper section, and secure using screws and washers, see Figure 70.

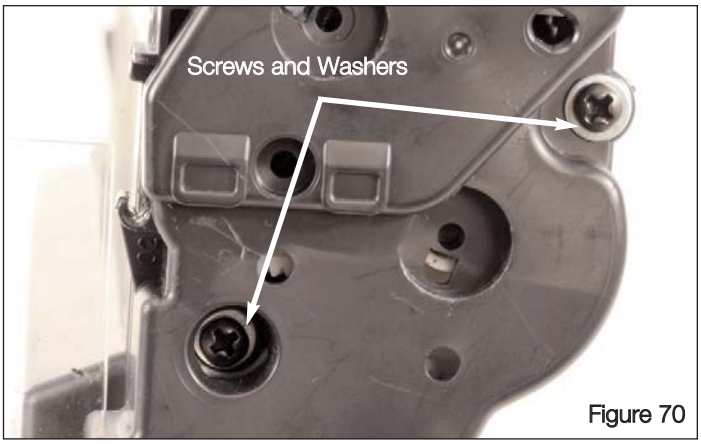


Figure 70

Note: When replacing the screws use a low torque setting on the drill.

Reassembling the Two Sections

This section provides the information needed to reassemble the toner hopper section to the waste bin section. At this point you should have disassembled and cleaned the entire cartridge as described in this SSS™. If you have not disassembled and cleaned the cartridge see page 1 for instructions. Before attempting to perform the following procedures, read the entire section carefully. Ensure that you follow all necessary safety precautions. For illustration purposes, the cartridge shown has not been split or sealed.

1. Join the waste bin to the toner hopper. See Figure 71.

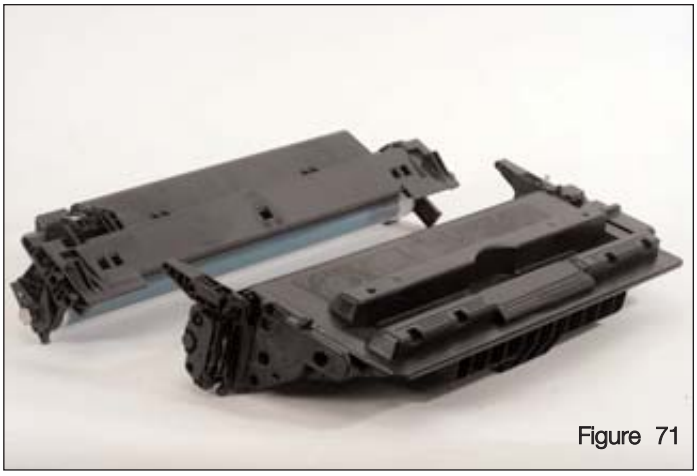


Figure 71

Note: Use caution not to bend the hopper compression springs when mating the waste bin to the hopper.

2. Install the cartridge pins on each side of the cartridge to secure the two halves together, as shown in Figures 72a & 72b.

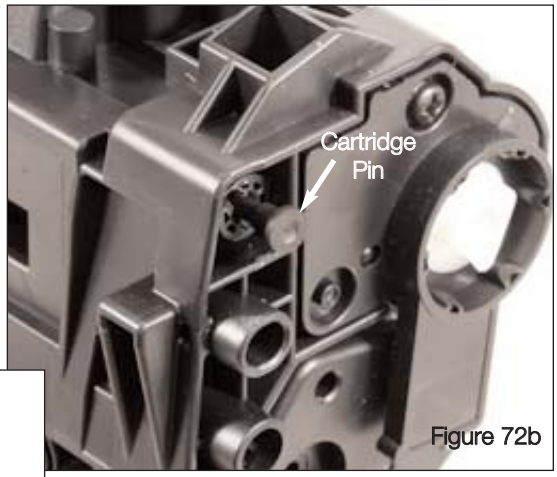


Figure 72b

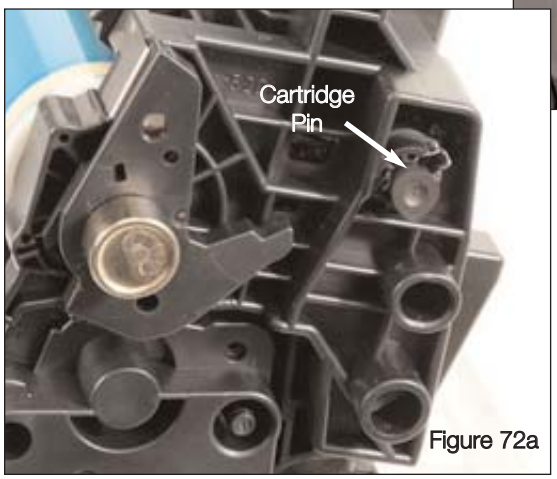


Figure 72a

3. Reinstall the drum shutter arm into the hopper as shown in Figure Figure 73a & 73b.

Note: Align keying features when inserting the drum shutter arm in place.

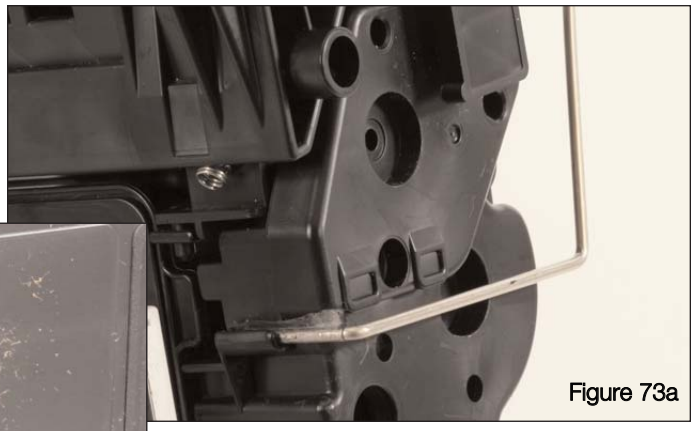


Figure 73a

Figure 73b

4. Make sure that the drum shutter actuator spring is positioned correctly as shown in Figure 74. Reinstall the drum shutter actuator arm to the hopper as shown in Figure 75.

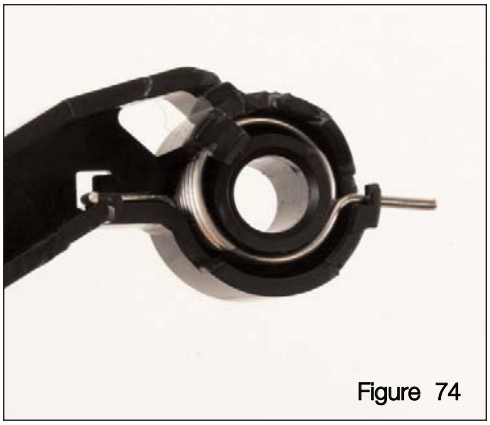


Figure 74

5. Rotate the drum shutter actuator arm to activate the spring. See Figure 75.

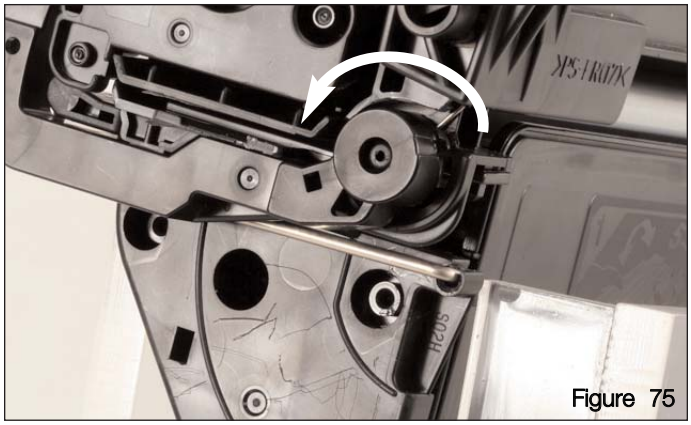


Figure 75

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3010 Lee Avenue • PO Box 152 • Sanford, NC 27331
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www.scc-inc.com

Static Control Components (Europe) Limited
Unit 30, Worton Grange
Reading • Berkshire RG2 0TG • United Kingdom
Tel +44 (0) 118 923 8800 • Fax +44 (0) 118 923 8811