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IBM® 4312, Xerox® P12, NEC® 1200, Apple® 12/640 (Fuji-Xerox® 12)
Remanufacturing Instructions

About the Cartridge

The Fuji-Xerox® 12 (FJX12) engine was first introduced in 1996 in two printers: IBM® Network Printer 12 and Apple® LaserWriter 12/640. The FJX12 engine features 12 ppm print speed and 600 dpi print resolution. The engine also supports edge-to-edge printing, a key selling point for the IBM printer.

The FJX12 cartridge, featuring a compact design, is relatively simple to remanufacture. The cartridge separates into two distinct sections: waste bin section and toner hopper section. These sections are held together with two cartridge pins, one installed at each end of the cartridge and one tension spring installed at the contact end of the cartridge.

The OEM cartridge pins can be removed by tapping them through the hopper and waste bin section pin casings to the interior of the cartridge. The pins should fall out of the cartridge through the laser port. SCC's FJX12 system-qualified, long cartridge pin will facilitate subsequent remanufacturing. The pins feature a slim-line head designed to fit flush to the cartridge and avoid damage to the printer.

The waste bin section houses the OPC drum, PCR, wiper blade and recovery blade. The OPC drum contains two inserts to dampen drum vibrations that result in humming noises. SCC testing has indicated a considerable difference in noise generated when the cartridge is operated without the drum inserts. Therefore, the drum inserts should be used with the replacement drum. SCC's FJX12 Odyssey™ OPC drum is sold with inserts and gears installed.

The PCR merits some cautions regarding print problems in low-humidity conditions. A remanufactured PCR is currently under development.

The FJX12 recovery blade features a flexible poly material design. Both mylar- and poly-type recovery blades are available for the FJX12 application, as well as a SCC system-qualified wiper blade.

Sealing components in the waste bin include wiper blade sealing foam and wiper blade end foams (large and small). The wiper blade sealing foam is unique in that it fits into a channel in the waste bin, instead of adhering to a mounting surface with adhesive.

The hopper section houses a 270-gram toner load, mag roller, and doctor blade. SCC testing has shown that FJX12-specific toner formulation is required for maintaining acceptable fusing performance and minimizing the occurrence of offsetting. SCC spent almost a year developing a toner formulation to meet the specific demands of the FJX12 application.

Table of Contents

World Wide Web

www.scc-inc.com

Printer Compatibility

IBM® Network Printer 12
Apple® LaserWriter® 12/640 PS
NEC® 1200
Xerox® P12

Fuji-Xerox® 12 Quick Reference

Estimated Remanufacturing Time	15-25 minutes
Toner Weight	270 grams
Seal Type	WhiteSeal™ (Lay-in Seal)
Toner Class	Magnetic, Monocomponent
Engine Designation	Fuji-Xerox® 12 (FJX12)
Recommended Test Machine	IBM® Network Printer 12

first edition

About the Cartridge

The FJX12 toner seal is part of the WhiteSeal™ line of ribbon-type seals. The WhiteSeal is a drop-in seal attached to the sealing channel with peel-to-expose adhesive. A FJX12 WhiteSeal Installation Kit, including a hopper fixture, an installation tool, seals and pull tab labels, is available to facilitate seal installation.

Additional sealing components in the hopper include mag roller felts and doctor blade sealing foam. Like the wiper blade sealing foam in the waste bin section, the doctor blade sealing foam fits into a channel in the hopper body. This design facilitates foam removal and installation.

Both the mag roller and doctor blade show signs of wear after the OEM cartridge cycle. The doctor blade is somewhat different from the typical doctor blade design, but closely compares to the XP15/20. The blade is comprised of white silicone applied to a stainless steel shim that is attached to the stamping. A replacement doctor blade and recoated mag roller are currently under development. Contact a member of your SCC Sales Team for product availability.

Cartridge/Supplies Information

	IBM® Network Printer 12 (4312)	Apple® LaserWriter® 12/640 PS
OEM Part Number	63H3005	M4683G/A
OEM Published Yield[1]	6,000 pages	6,000
Price (Retail List-US)[2]	$164	$160

[1]*Yield is based on 5% page coverage unless noted otherwise.*
[2] *Reflection of Prices as of January 1998.*

	IBM® Network Printer 12 (4312)	Apple® LaserWriter® 12/640 PS
OEM Replacement Fuser Unit	Usage Kit (includes replacement fuser and bias transfer roller)	na
OEM Published Yield	150,000 pages[3]	na
OEM Part Number	63H3110	na
Price (Retail List-US)[2]	$249	na

[2] *Reflection of Prices as of January 1998.*
[3]*Yield is based on 5% page coverage.*

Printer Information

	IBM® Network Printer 12 (4312)	Apple® LaserWriter® 12/640 PS
Introduction Date	July 1996	June 1996
Introduction List Price	$1,599	$1,689
Pages Per Minute (ppm)	12 ppm (simplex) 4 ppm (duplex)	12 ppm (simplex)
Engine Duty Cycle	35,000 pages/month	300,000 (engine life)
Processor	33 MHz Intel 80960JF	30 MHz AMD 29040 RISC
Resolution (dpi)	600 (H) x 600 (V) dpi (native) DP-Tek TrueRes edge smoothing	600 (H) x 600 (V) dpi FinePrint res. enhance./PhotoGrade
Energy Star Compliant	yes	
Toner Saving Mode	yes (TonerMiser toner saving mode)	
Page Size	letter, legal, A4, folio, executive (main tray)	3.9"-8.5" (width) x 5.8"-14" (length)
Target Market	small work groups	business, government, education

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:
- Phillips Screwdriver
- Needlenose Pliers
- 3/32" Punch
- Hammer
- Funnel for Toner Bottle
- Compressed Air for Cleaning . . . .*(See left)*
- 91-99% Isopropyl Alcohol . . . .*(See left)*
- Lint-Free Foam Tip Swab . . . . .LFSWAB
- Cotton Swab . . . . .QTIP
- Lint-free Cleaning Cloth . . . . .LFCCLOTH
- Kynar® Lubricating Powder . . . . .KPOW
- Shallow Trough for Dipping the Wiper Blade
- Cartridge Pins . . . . .CARTPIN-L
- Toner FJX12-270B
- Drum Shutter Felt 4LDSFELT
- FJX12 Odyssey™ Drum .OSFJX12DRGR
  (Geared with Drum Inserts)

Item Codes for additional replacement items are included in the body of the instructions.

For seal installation use the following items in addition to the items listed above:

- Fuji-Xerox® 12 (IBM® 4312) WhiteSeal™ Installation Kit
  . . . . .FJX12WHSLKIT
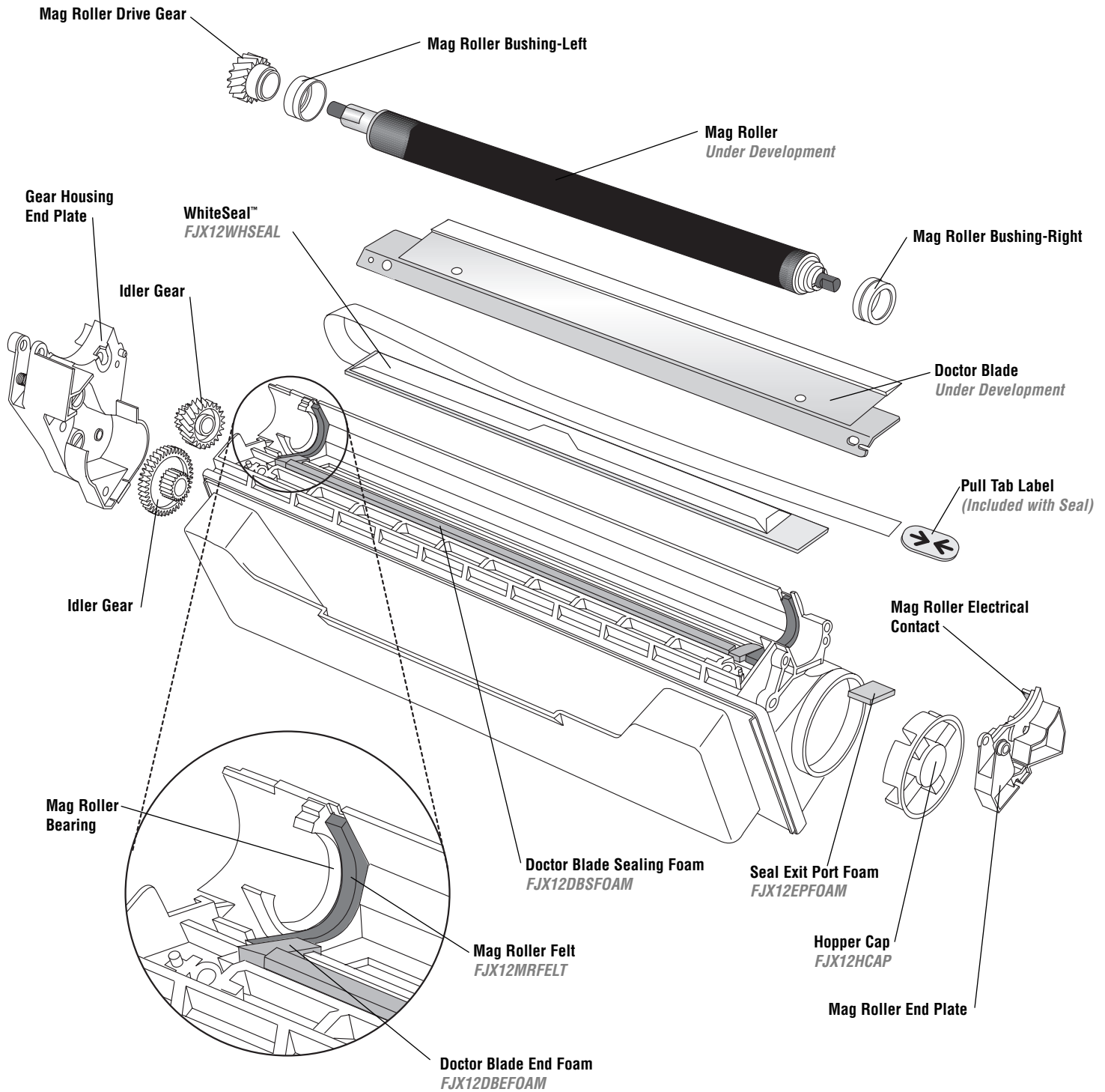 *Contents: hopper fixture (FJX12HJIG, installation tool (GSATOOL), 50 seals (FJX12WHSEAL), and pull tab labels.*

Waste Bin Section

Drum Hub Disk

Drum Electrical Contact

Drum Inserts

OPC Drum
OSFJX12DRGR
(Geared with Inserts)

Primary Charge Roller (PCR)
Under Development

Drum Helical Gear

Recovery Blade
FJX12RECBLADE (Mylar)
PRECB-FJX12 (PolyBlade™)

Drum Hub Disk Axle
(Contains Contact)

Wiper Blade
FJX12BLADE

Cartridge Pin
CARTPIN-L

Drum Shutter and
Drum Shutter Felt
(Not Visible)
4LDSFELT

Hopper
Tension Spring
FJX12HTS

Drum Helical
Gear Axle (Metal)

PCR Saddle

Wiper Blade Sealing Foam
FJX12WBSFOAM

Wiper Blade End Foam
(Large and Small)
FJX12WBEFM-L
FJX12WBEFM-S

Wiper Blade End Foam
(Large and Small)
FJX12WBEFM-L
FJX12WBEFM-S

PCR Saddle

Cartridge Pin
CARTPIN-L

◆ **Tool, Kit or System Available. Contact Your SCC Sales Team. SCC parts indicated in gray.**

Toner Hopper Section

Mag Roller Drive Gear

Mag Roller Bushing-Left

Mag Roller
Under Development

**Gear Housing
End Plate**

WhiteSeal™
FJX12WHSEAL

Mag Roller Bushing-Right

Idler Gear

Doctor Blade
Under Development

Pull Tab Label
(Included with Seal)

Idler Gear

**Mag Roller Electrical
Contact**

**Mag Roller
Bearing**

Doctor Blade Sealing Foam
FJX12DBSFOAM

Seal Exit Port Foam
FJX12EPFOAM

Mag Roller Felt
FJX12MRFELT

Hopper Cap
FJX12HCAP

Mag Roller End Plate

Doctor Blade End Foam
FJX12DBEFOAM

◆ **Tool, Kit or System Available. Contact Your SCC Sales Team. SCC parts indicated in gray.**

Separating the Cartridge

1. **Remove the hopper tension spring.**
   Position the cartridge on your work surface with the drum shutter facing upward (FIG 1).

   Drum Shutter Face Up

   Cartridge Pin

   Hopper Tension Spring

   FIG 1
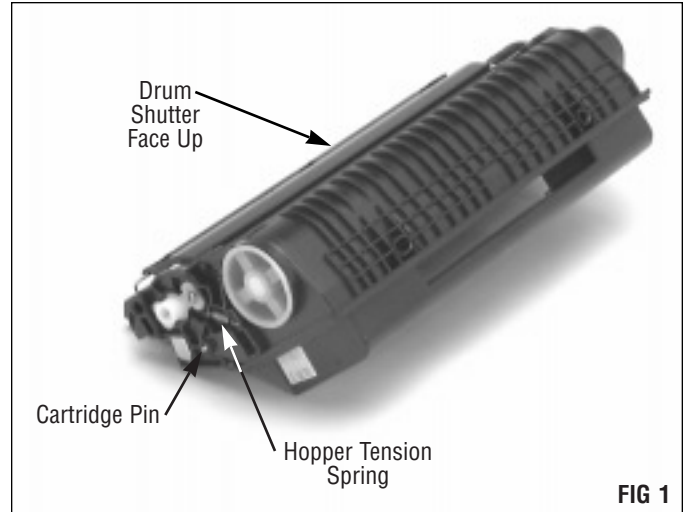
   Remove the hopper tension spring using a pair of needlenose pliers (FIG 2).

   If the spring is damaged or lost, a replacement Hopper Tension Spring (FJX12HTS) is available.

   Hopper Tension Spring

   FIG 2

2. **Remove the cartridge pins.**
   One cartridge pin is located adjacent to each drum axle. Using a 3/32" punch and hammer, carefully tap the pins to the inside of the cartridge as shown in FIGs 3 and 4. The pins should fall out of the cartridge through the laser port.

   Replacement Cartridge Pins (CARTPIN-L), available from SCC, will facilitate pin removal and installation in subsequent remanufacturing cycles.

   Contact End of Cartridge

   Drum Axle

   Cartridge Pin

   Punch

   FIG 3

Non-Contact End of Cartridge

Drum Axle

Cartridge Pin

Punch

FIG 4
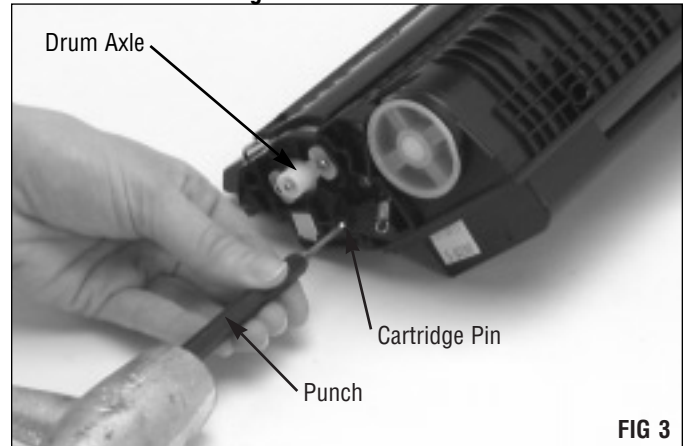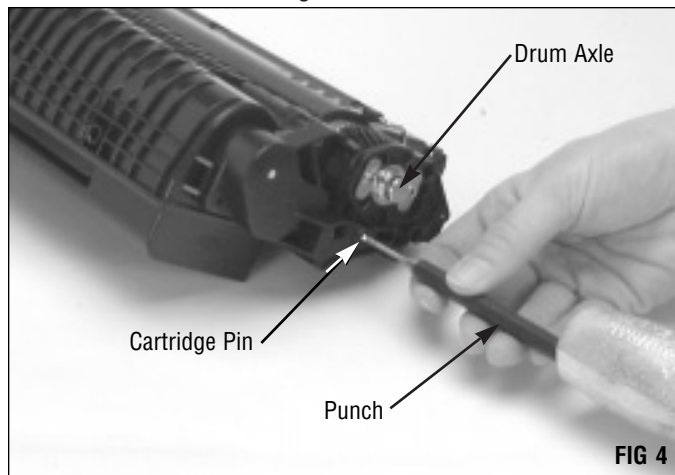
3. Separate the cartridge (FIG 5).

Waste Bin Section

Toner Hopper
Section

FIG 5

IMPORTANT If you removed OEM cartridge pins, make sure the pins are completely removed from the cartridge. The pins may remain in the casing in the toner hopper section (FIG 6).

Remove the Cartridge
Pins from the Cartridge

FIG 6
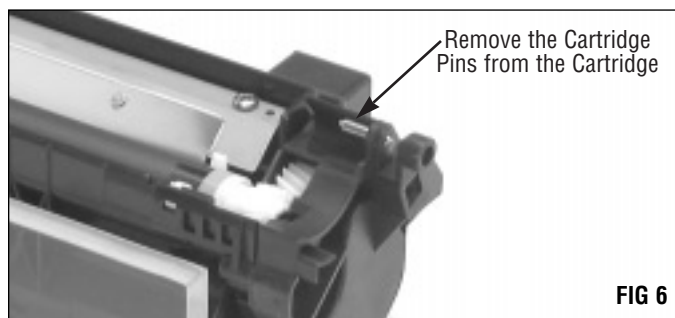
Disassembling the Waste Bin Section

1. **Secure drum shutter.**

   Open the drum shutter as indicated by the arrow in FIG 7. Use a piece of tape to secure the shutter in place.

Secure Shutter with Tape

Drum Shutter

FIG 7
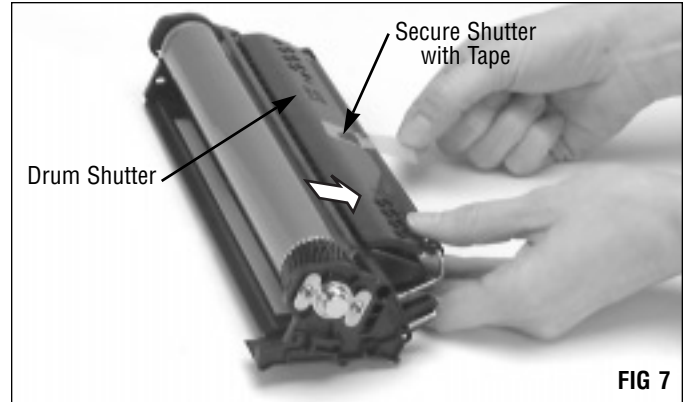
2. **Remove the drum axles from each end of the waste bin (FIGs 8-11).**

Drum Helical Gear

Remove Two Screws From Axle

FIG 8

Remove Axle

FIG 9

Drum Hub Disk

Remove Two Screws from Axle

FIG 10

Remove Axle

FIG 11
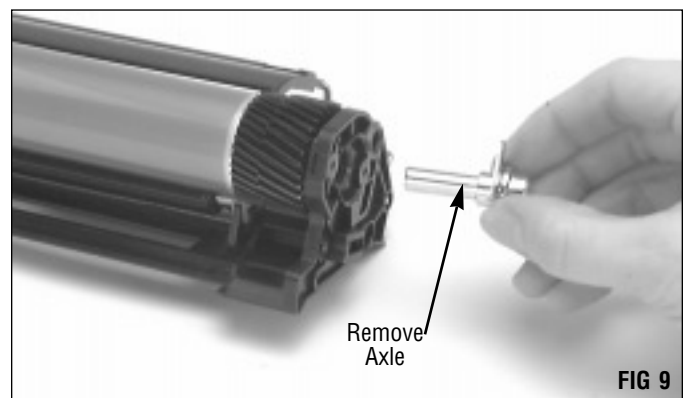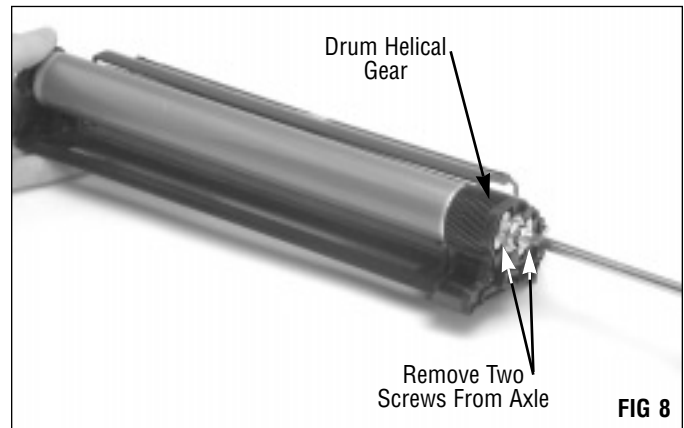
3. **Remove the drum.**

    For best results, we recommend replacing the OEM drum after the OEM cycle and replacing SCC's Odyssey Drum (OSFJX12DRGR) each remanufacturing cycle.

    Note that the drum contains two drum inserts used to dampen drum vibrations during cartridge operation. The inserts must be installed in the drum. SCC's replacement Odyssey Fuji-Xerox 12 Drum is sold with the inserts and gears installed.

    IMPORTANT If you plan to reuse the drum, store it in an area that is protected from light and impact damage.

    To avoid touching the surface of the drum, grasp the drum by the gears. (FIG 12).

Grasp Drum Gear to Remove the Drum

FIG 12

4. **Remove the PCR.**

    Handle the PCR by the shaft or use clean latex gloves (FIG 13). If you plan to reuse the PCR, store it on a flat uniform surface.

    A remanufactured PCR is under development. Contact a member of your SCC Sales Team for availability.

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

PCR
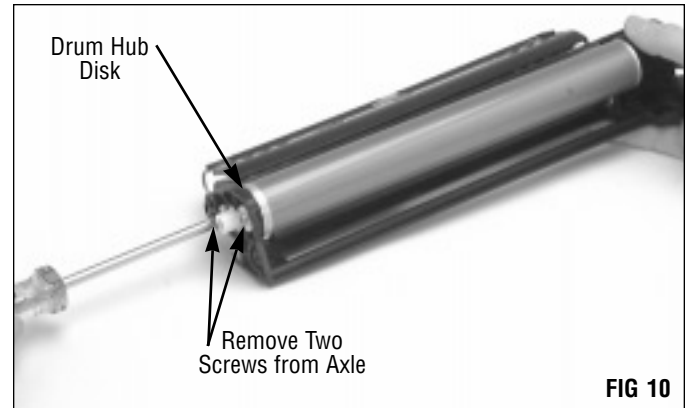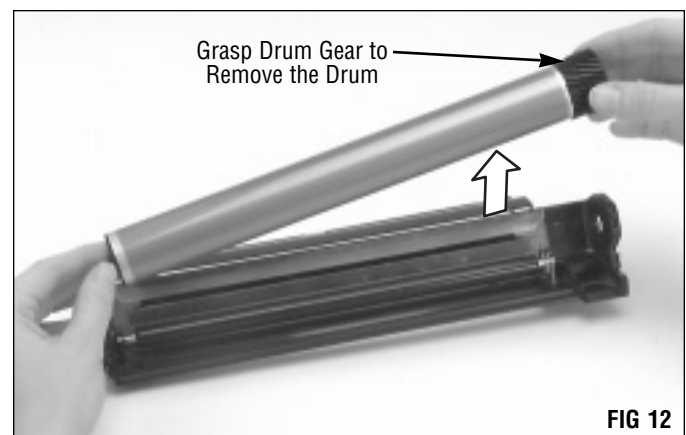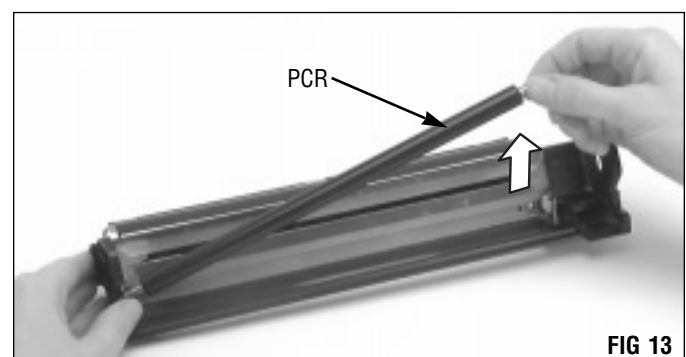
FIG 13

Disassembling the Waste Bin Section

5. Remove the wiper blade.
Remove two screws from the stamping as shown in FIG 14 and lift the blade from the waste bin as shown in FIG 15.

For best results, replace the Wiper Blade (FJX12BLADE) each time you replace the drum.

Remove Two Screws

FIG 14

Wiper Blade

FIG 15
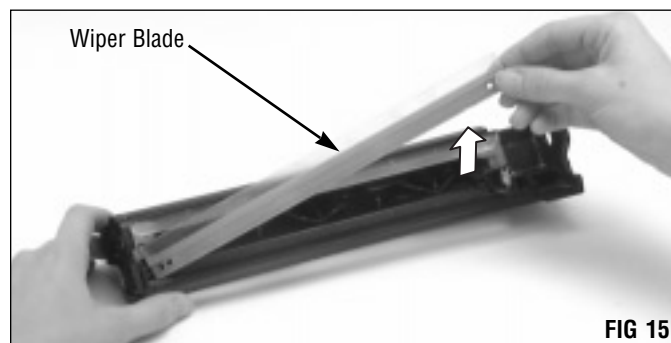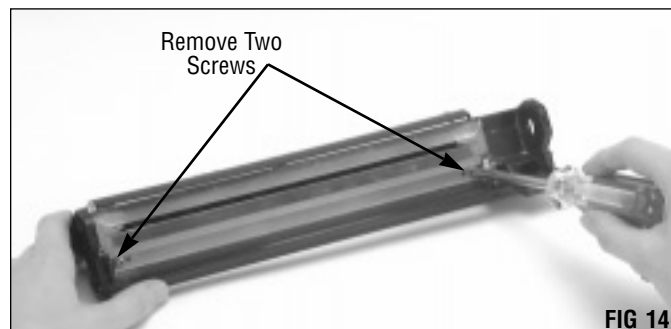
6. Clean the waste bin.
Empty the bulk of the waste toner and clean the waste bin with dry, filtered compressed air (FIG 16). Direct compressed air on and around the wiper blade sealing foam and end foams to remove toner and debris from the foam material. Be careful not to damage the recovery blade.

Wiper Blade End Foam

Wiper Blade Sealing Foam

Recovery Blade

FIG 16
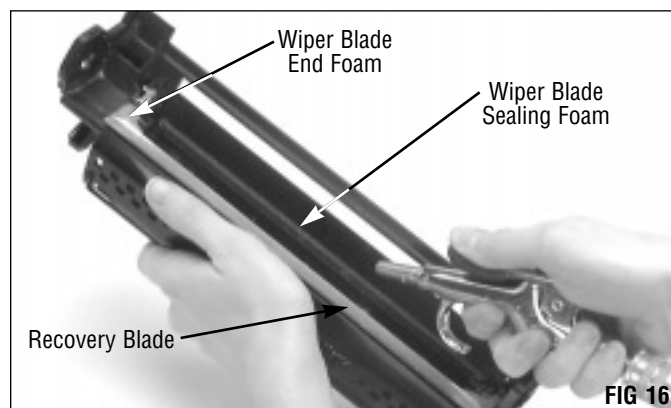
7. Clean PCR saddles (FIG 17).
Clean toner residue from the saddles using a Lint-Free Swab (LFSWAB) dampened with isopropyl alcohol.

PCR Saddle

FIG 17
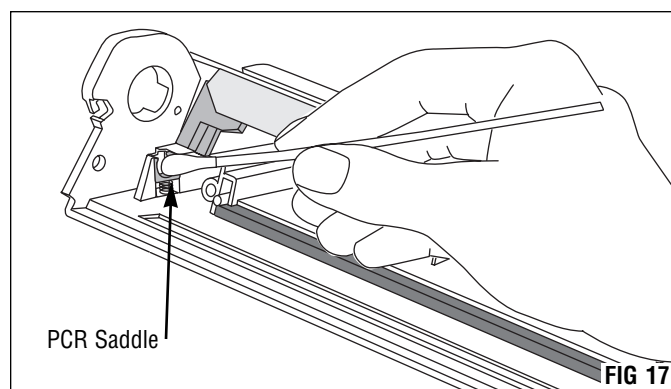
8. **Inspect the sealing components in the waste bin** (FIG 18).
The foam material, such as Wiper Blade Sealing Foam
(FJX12WBSFOAM) and Wiper Blade End Foams, Large and
Small (FJX12WBEFM-S, FJX12WBEFM-L), should display a
smooth surface and be secured to the cartridge surface.
Replace foam components that are ripped, pitted or
missing.

The recovery blade should display a smooth, flat surface
without kinks or waviness along the edge. Replace the
Recovery Blade (FJX12RECBLADE-Mylar; PRECB-FJX12-
PolyBlade™) if it is damaged, dislodged or missing.

Call your SCC Sales Team for product availability.

9. **Install a Drum Shutter Felt.**
The Drum Shutter Felt (4LDSFELT) is an aftermarket
component installed on the interior surface of the shutter to
protect the drum from nicks and scratches during shipping
and handling.

Remove the release liner from the felt (FIG 19).

Position the shutter so that the interior surface of the
shutter is facing upward (FIG 20).

Center the felt on the drum shutter as shown in FIG 20.

*Detailed installation instructions are also included with the
drum shutter felt.*

Wiper Blade End Foam — Recovery Blade — Wiper Blade Sealing Foam — Wiper Blade End Foam

FIG 18

Release Liner — Drum Shutter Felt

FIG 19

Rotate Drum Shutter to Position Interior Surface Upward

Align Felt Along Length of Shutter

FIG 20
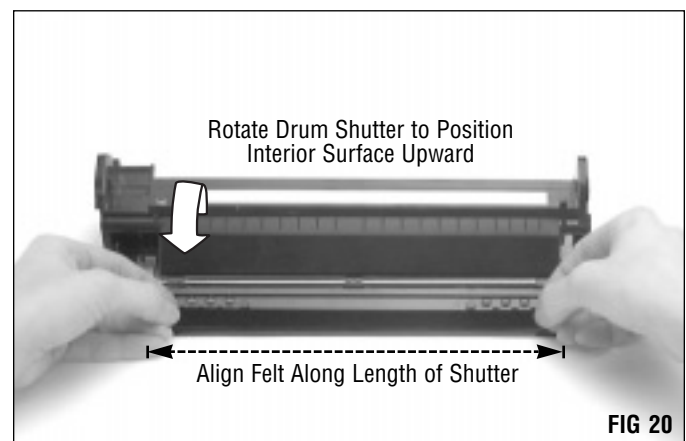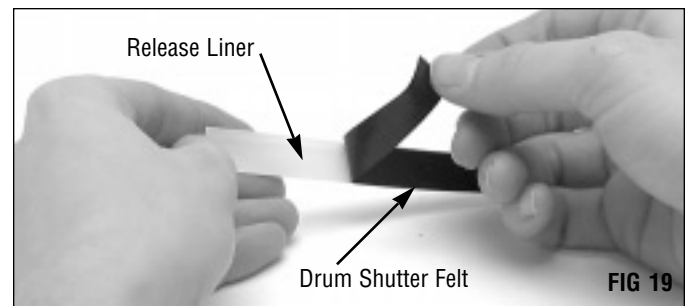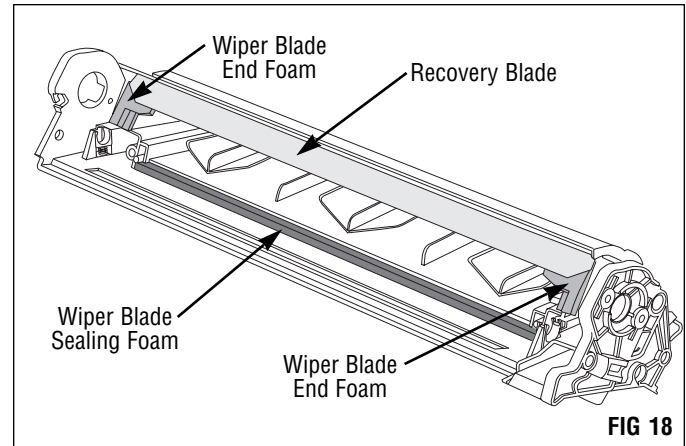
Disassembling the Toner Hopper Section

1. **Place the hopper in the plexiglass holding fixture.**
   SCC offers a Plexiglass Hopper Fixture (FJX12HJIG) for the Fuji-Xerox 12 cartridge to facilitate hopper disassembly and assembly. If you plan to install a seal, note that the fixture is recommended for proper seal installation; the fixture is included in the Fuji-Xerox 12 (IBM 4312) WhiteSeal Installation Kit (FJX12WHSEAL). Secure the fixture to your work surface with bolts or C-clamps.

   Place the hopper in the fixture as shown in FIG 21, noting the orientation of the tall support of the fixture. The cartridge handle fits over the short fixture support.

Cartridge Handle

Short Fixture Support

Tall Fixture Support
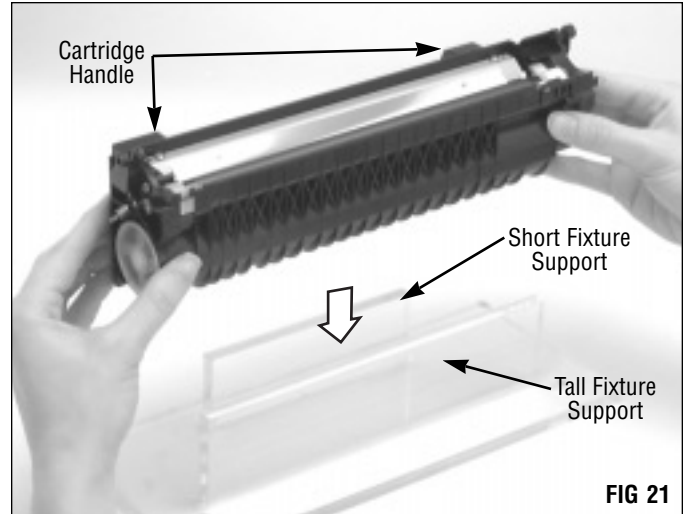
FIG 21

   When placed correctly in the fixture (FIG 22), the hopper should not slide laterally on the fixture.

Cartridge Handle

Tall Fixture Support
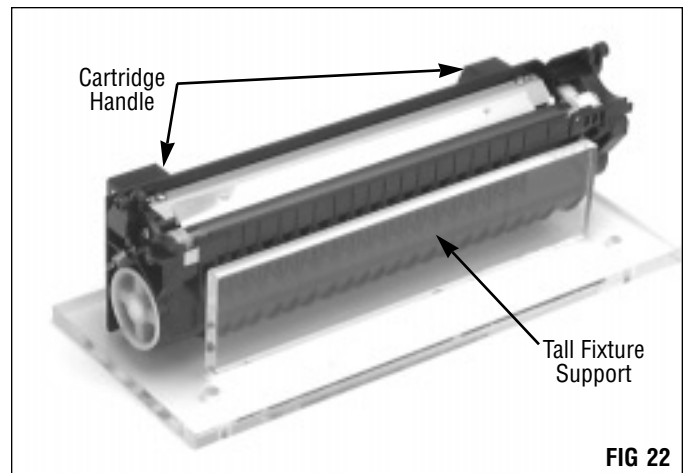
FIG 22

2. **Remove the mag roller end plate.**
   Remove two Phillips screws and remove the end plate (FIGs 23 and 24).

Remove Two Screws

FIG 23

Mag Roller
End Plate

FIG 24
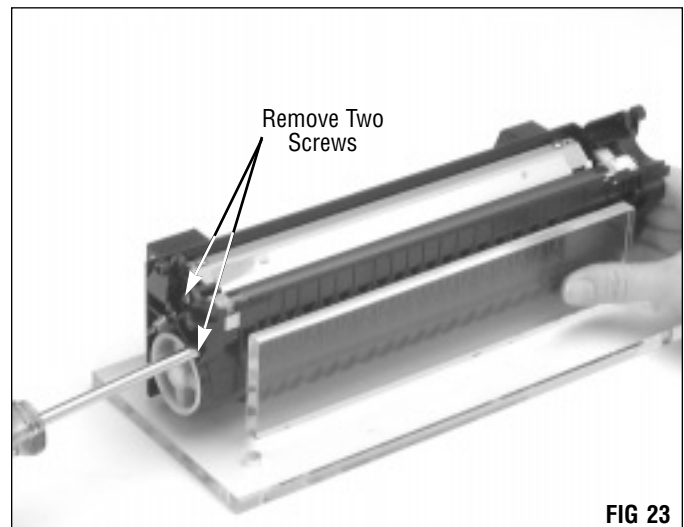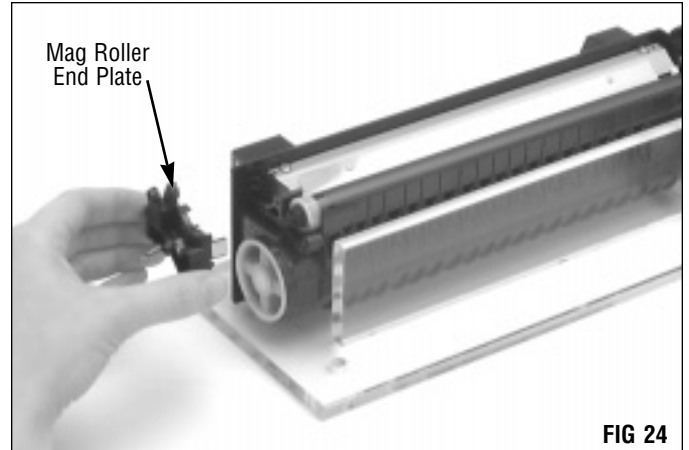
3. **Remove the gear housing end plate.**
    Remove three Phillips screws and remove the end plate
    (FIGs 25 and 26).

Remove Three
Screws

FIG 25

Remove the Gear
Housing End Plate

FIG 26
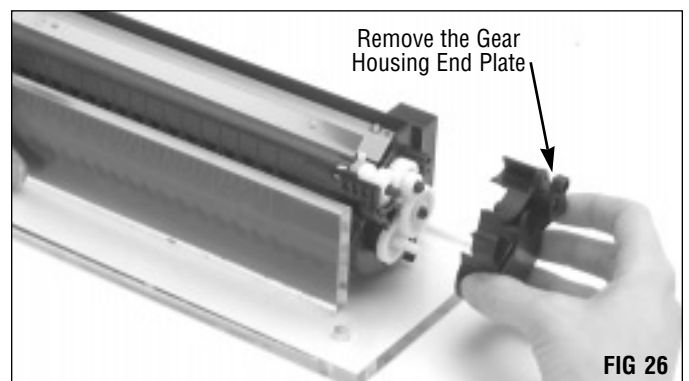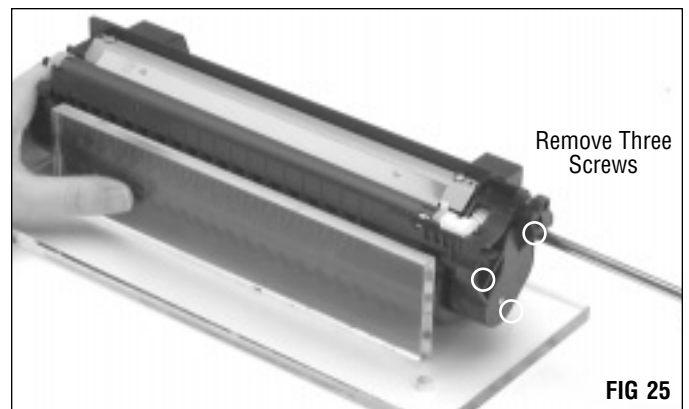
Disassembling the Toner Hopper Section

4. **Remove the mag roller drive gear (FIG 27).**

Remove Mag Roller Drive Gear

FIG 27
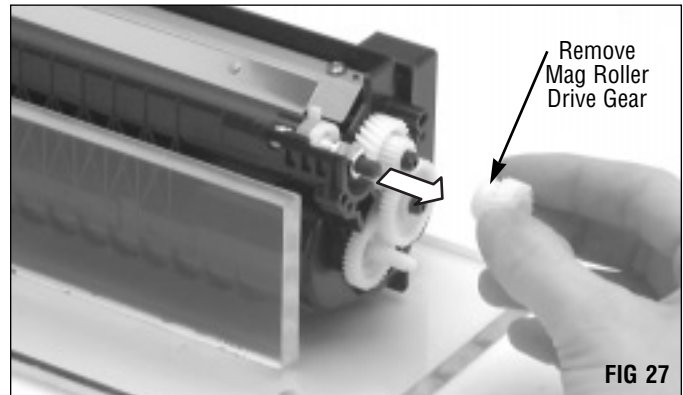
5. **Remove the idler gears (FIGs 28 and 29).**

FIG 28

FIG 29
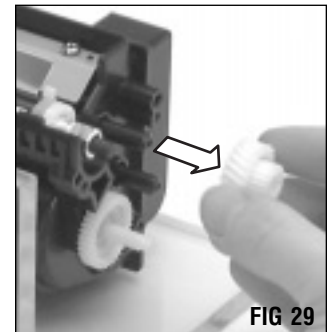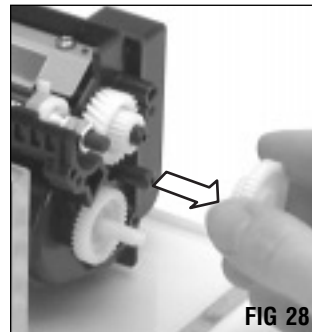
6. **Remove the mag roller.**
    Grasp each end of the mag roller as shown in FIG 30 and lift it from the hopper.

    If you plan to reuse the mag roller, store it on a soft, clean surface. A recoated mag roller for the Fuji-Xerox 12 is currently under development.
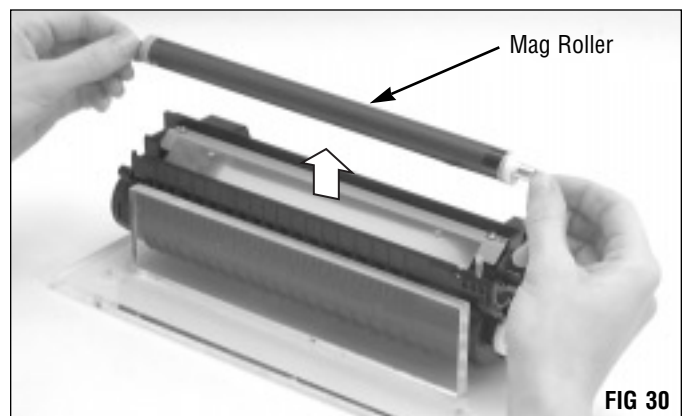
    ⚠ CAUTION Do not touch the surface of the mag roller with your fingers or scratch the surface. Store the mag roller on a soft surface, and DO NOT stack the rollers on top of each other.

Mag Roller

FIG 30

7. **Remove the mag roller bushings from the mag roller (FIG 31).**

Mag Roller Bushings

FIG 31
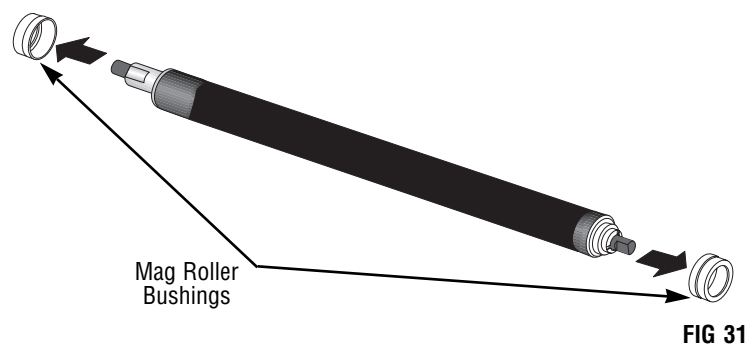
8. **Remove the doctor blade.**
    Remove two screws from the stamping (FIG 32), then carefully remove the blade from the hopper (FIG 33).

    A replacement doctor blade is under development. Contact a member of your SCC Sales Team for product availability.

Remove Two Screws

FIG 32

Doctor Blade

FIG 33
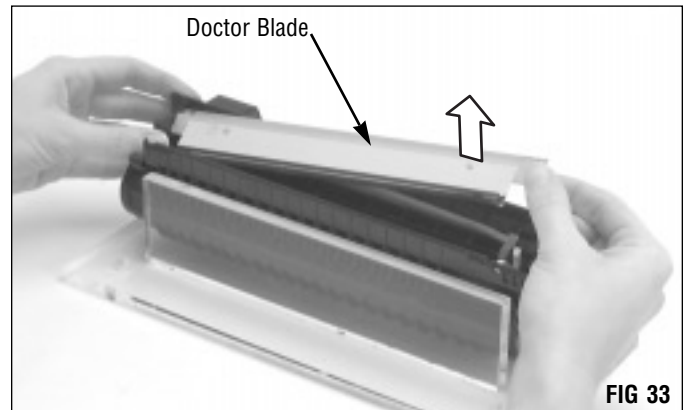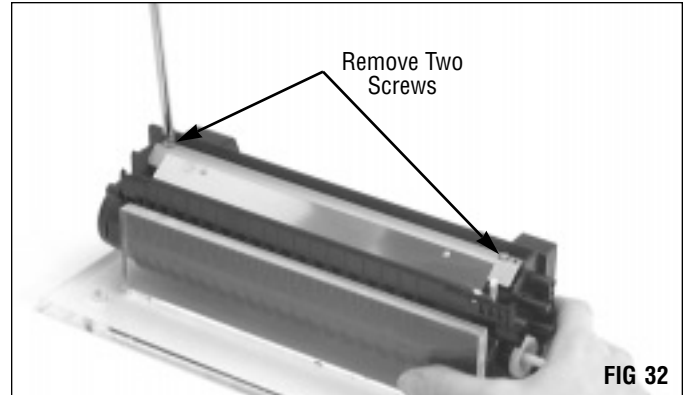
9. **Clean the hopper with dry, filtered compressed air.**
    Direct compressed air on and around foam and felt components to remove as much toner and debris as possible (FIG 34). Refer to FIG 35 on the following page for the location of the foam and felt materials.

Doctor Blade End Foam

Doctor Blade Sealing Foam

FIG 34
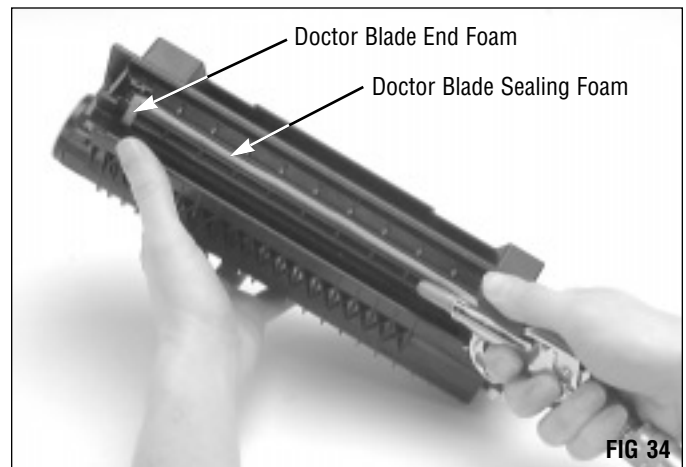
Disassembling the Toner Hopper Section

10. **Inspect the sealing components in the hopper section and replace as required (FIG 35).**

   Foam components such as the Doctor Blade End Foams (FJX12DBEFOAM) and Doctor Blade Sealing Foam (FJX12DBSFOAM) should display a smooth, clean surface. Make sure the foam materials are secured in the correct position.

    Mag Roller Felts (FJX12MRFELT) should display a plush surface. Make sure the felts are securely adhered to the mag roller saddles. Replace the felts if the surface appears shiny and compacted with toner.

    Instructions detailing the installation of the components mentioned above are included in the packaging of the individual products.

    Contact a member of your SCC Sales Team for product availability.

Doctor Blade Sealing Foam

Mag Roller Felt

Doctor Blade End Foams
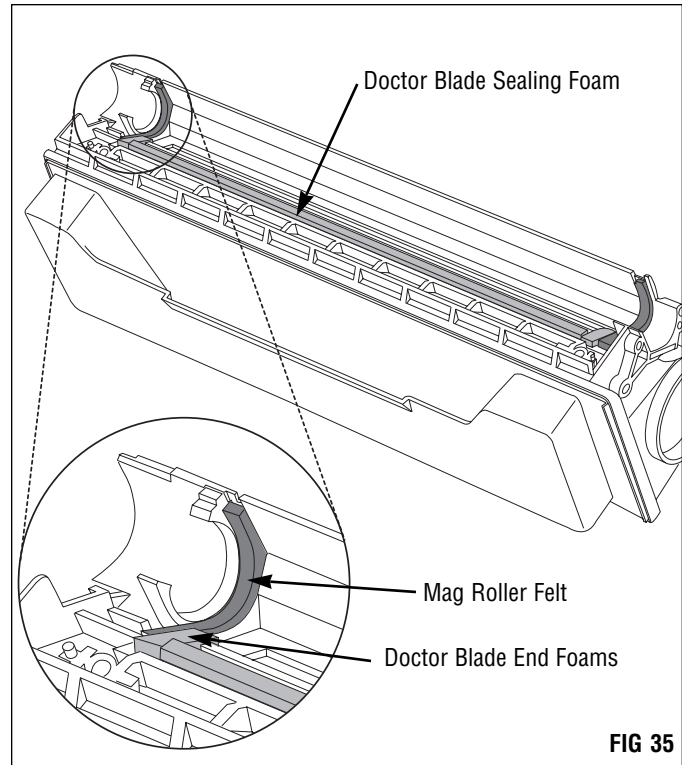
FIG 35

Install a Fuji-Xerox® 12 WhiteSeal™

If you plan to seal the toner hopper, install the seal before continuing to the next section. For complete, step-by-step seal installation instructions, refer to System Support Series 175. SCC's WhiteSeal is an easy-to-install ribbon-type seal with OEM-type appearance. For best installation results, use the Fuji-Xerox 12 (IBM 4312) WhiteSeal Installation Kit (FJX12WHSLKIT) which includes a hopper fixture (FJX12HJIG), an installation tool (GSATOOL), 50 seals (FJX12WHSEAL), and pull tab labels.

If you don't install a seal, fill the hopper through the toner port with 270 grams of toner (FJX12-270B) and reassemble the hopper using the instructions in the following section.

Assembling the Toner Hopper Section

1. **Clean the doctor blade.**
   Clean the doctor blade with dry, filtered compressed air (FIG 36). Clean the working edge of the blade with 91-99% isopropyl alcohol.
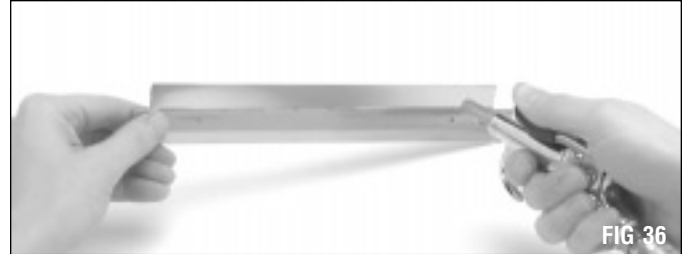
FIG 36

2. **Install the doctor blade.**
   Position the blade stamping on the locating posts and secure the blade with two Phillips screws (FIGs 37).
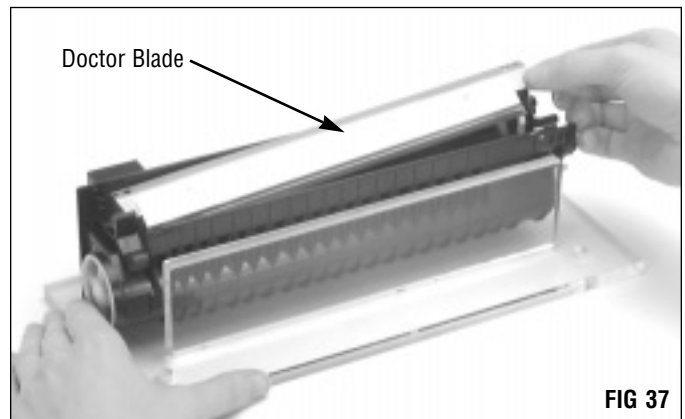
Doctor Blade
FIG 37

3. **Clean the mag roller.**
   Clean the surface of the roller with dry, filtered compressed air only (FIG 38).

   ⚠ **CAUTION** Do not scratch the coated area of the roller with the air nozzle or touch the mag roller surface with your bare fingers.

   A remanufactured mag roller sleeve is under development; contact a member of your SCC Sales Team for product availability.
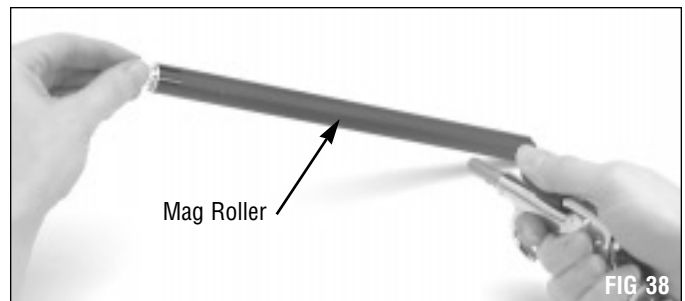
Mag Roller
FIG 38

4. **Clean the mag roller bushings.**
   Clean the bushings with a Lint-Free Swab (LFSWAB) or Lint-Free Cloth (LFCCLOTH) (FIG 39).
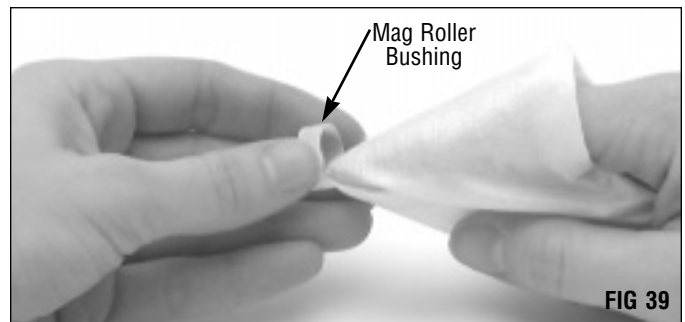
Mag Roller Bushing
FIG 39

Assembling the Toner Hopper Section

5. **Install a mag roller bushing on each end of the mag roller (FIG 40).**

Mag Roller
Bushings

FIG 40
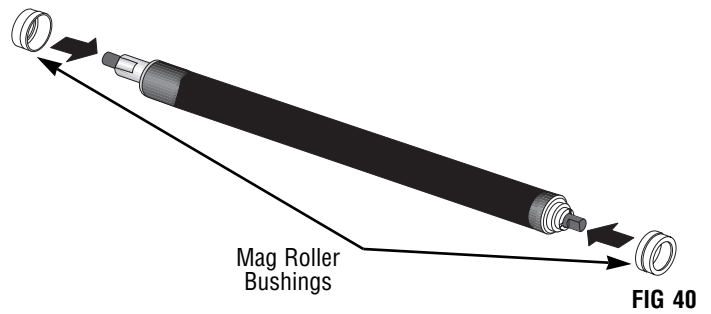
6. **Install the mag roller.**
   Position the mag roller with the metal axle at the right end of the toner hopper (FIG 41).

Metal Axle

FIG 41
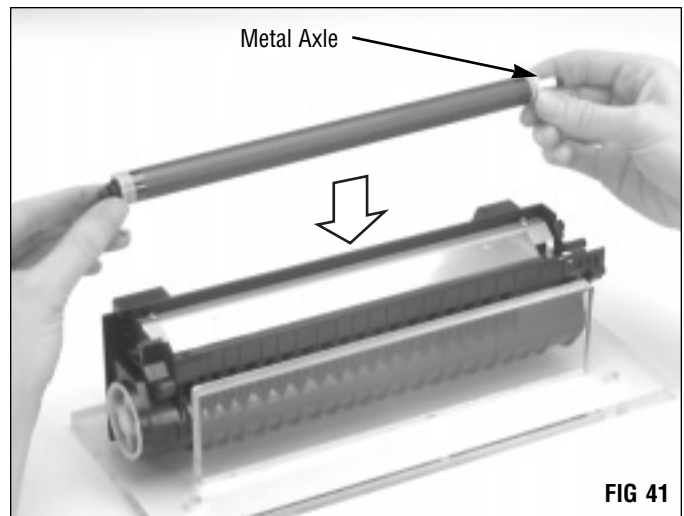
7. **Install the idler gears (FIGs 42 and 43).**

FIG 42

FIG 43
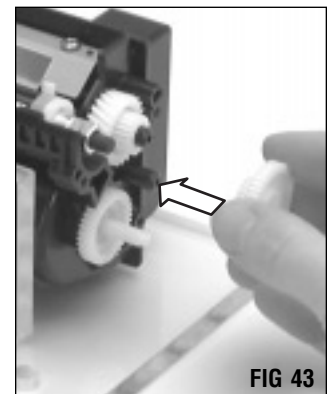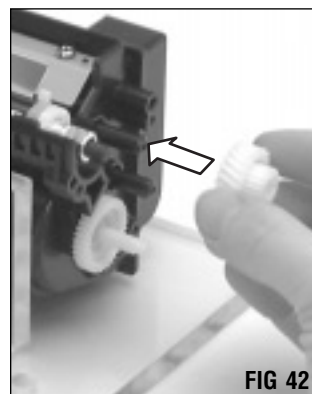
8. **Install the mag roller drive gear (FIG 44) .**
    Note the orientation of the gear as shown in FIG 45.

Install Mag Roller Drive Gear

Gear Orientation

FIG 45

FIG 44
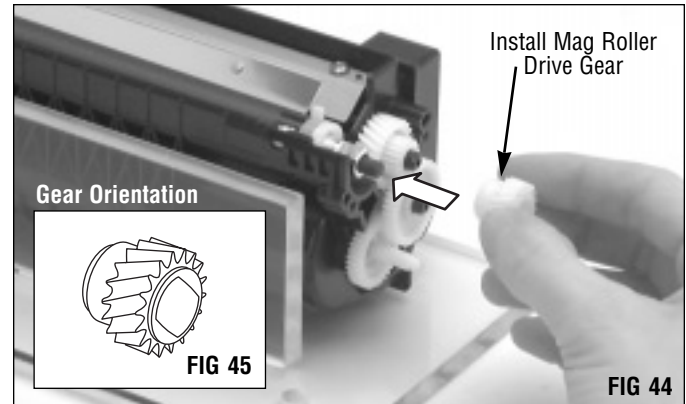
9. **Clean the electrical contact on mag roller end plate.**
    Clean toner and debris from the electrical contact using a Lint-Free Swab (LFSWAB) dampened with isopropyl alcohol (FIG 46).

Electrical Contact

FIG 46
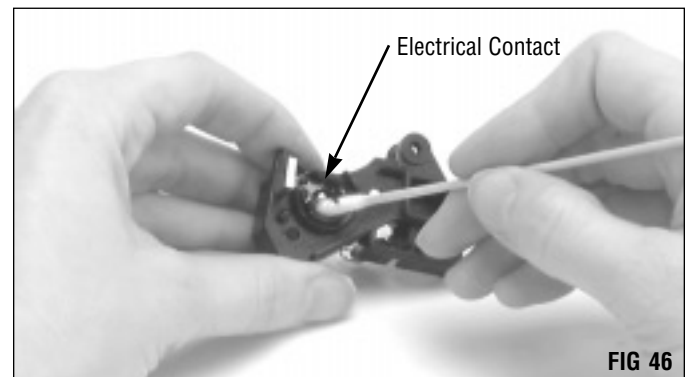
10. **Apply a thin layer of Conductive Cartridge Lubricant (CONCLUBE) to the mag roller electrical contact (FIG 47).**
    Use the wooden end of a swab as an applicator.

Apply Conductive Grease to Contact

FIG 47
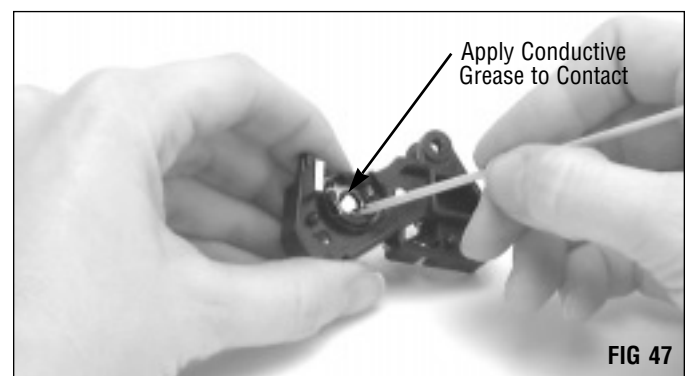
Assembling the Toner Hopper Section

11. **Install the gear housing end plate (FIG 48).**
    Note that the mag roller axle is keyed and fits into a positioner bushing in the end plate. Rotate the magnet at the right end of the hopper to help position the keyed axle in the end plate positioner bushing.

Mag Roller
End Plate

FIG 48
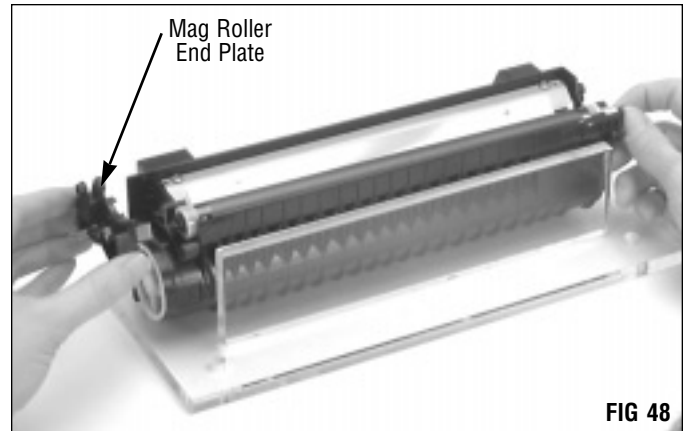
Secure the end plate with two Phillips screws (FIG 49).

Secure the End Plate
with Two Screws

FIG 49
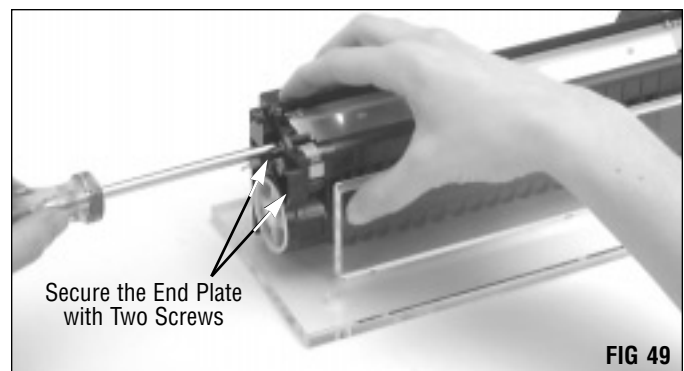
12. **Install the mag roller end plate (FIG 50).**
    Secure the end plate with three Phillips screws (FIG 51).

Gear Housing End Plate

FIG 50

Secure with
Three Screws

FIG 51
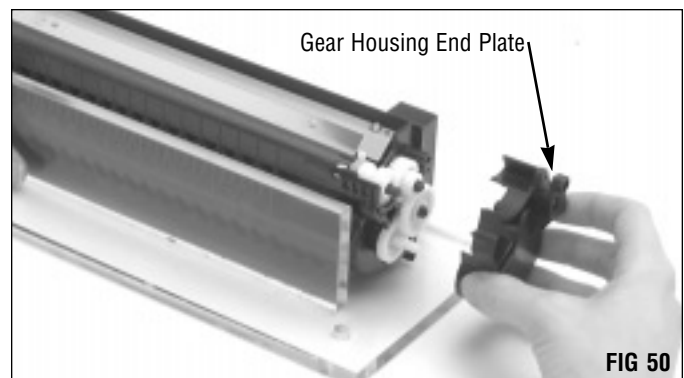
Assembling the Waste Bin Section

1. **Clean the wiper blade.**
   If you plan to reuse the wiper blade, clean it with dry, filtered compressed air (FIG 52).

   ⚠ **CAUTION** For best results we do not recommend using alcohol or any alcohol-based solvent to clean the polyurethane blade. To avoid damage to the working edge of the blade, SCC recommends using only dry, filtered compressed air to clean the wiper blade.


Wiper Blade

FIG 52
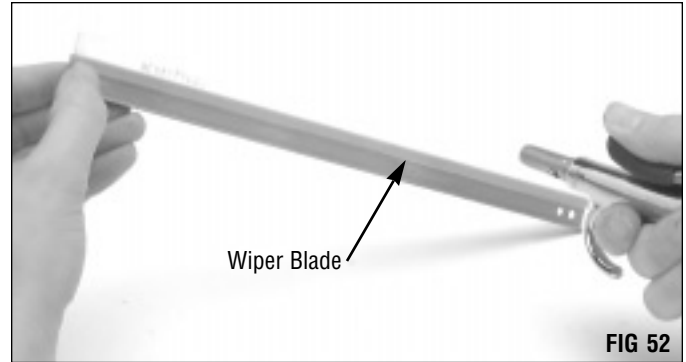
2. **Pad the wiper blade.**
   Kynar Lubricating Powder (KPOW) applied to the working edge of the blade will help prevent blade "flip overs" during the first drum rotations of the remanufactured cartridge. Pad the wiper blade regardless of whether you are using a new replacement blade or reusing the old blade.

   Dip the edge of the blade in a long, shallow container of lubricating powder as shown in FIG 53. Examine the length of blade to ensure even coverage. Repeat.

Kynar Lubricating Powder

FIG 53
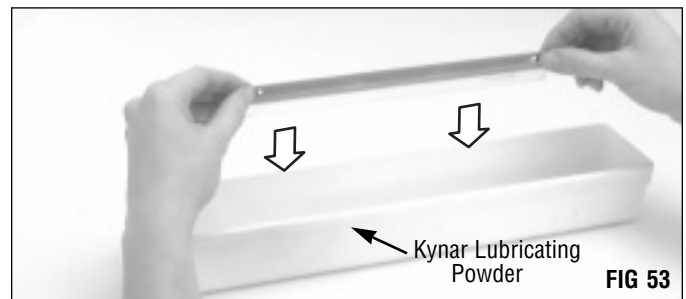
3. **Install the wiper blade**
   Position the stamping over the locating posts in the waste bin (FIG 54), and secure the blade with two Phillips screws (FIG 55).


Wiper Blade

FIG 54

Secure the Wiper Blade with Two Screws

FIG 55
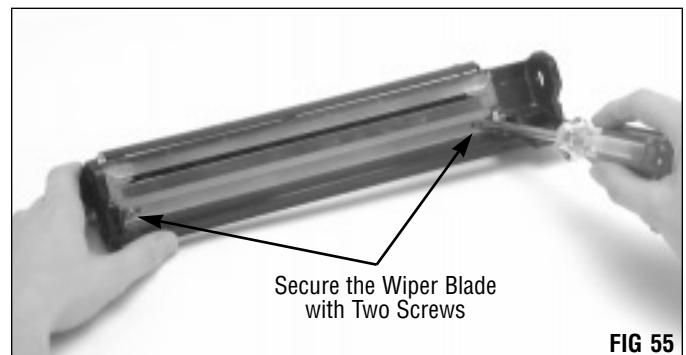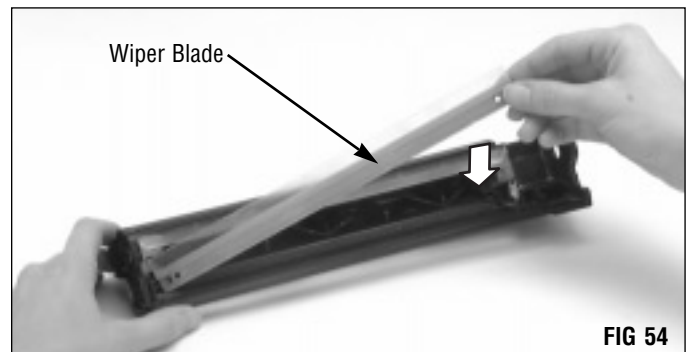
Assembling the Waste Bin Section

4. Clean and inspect the PCR.

If you are reusing an OEM PCR, clean the roller using a soft, lint-free cloth dampened with water.

Gently wipe the PCR in one direction. Be careful not to pinch or dent the surface of the PCR, as the material has poor memory (FIG 56).

Remanufactured PCRs are under development. Contact a member of your SCC Sales Team for product availability.


Wipe PCR in One Direction Only

FIG 56
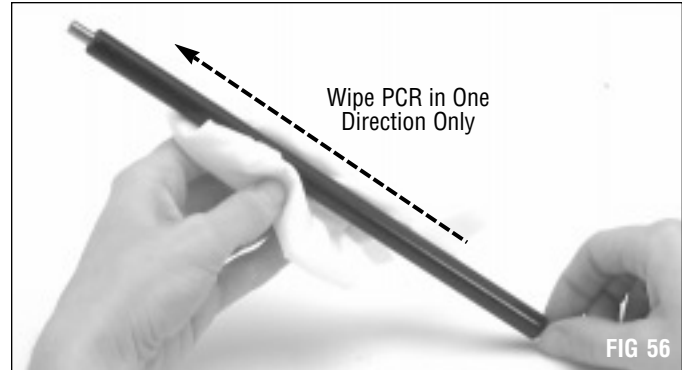
5. Apply Conductive Cartridge Lubricant (CONCLUBE) to the PCR saddle at the contact end of the cartridge (FIG 57).

Note that the saddle at the contact end of the cartridge is black. Apply the lubricant sparingly.

Apply Conductive Lubricant

FIG 57
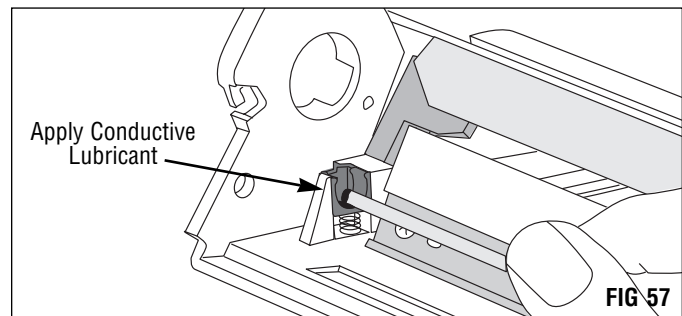
6. Install the PCR (FIG 58).

Make sure the PCR shafts fit securely in the PCR saddles

PCR

PCR Saddles

FIG 58
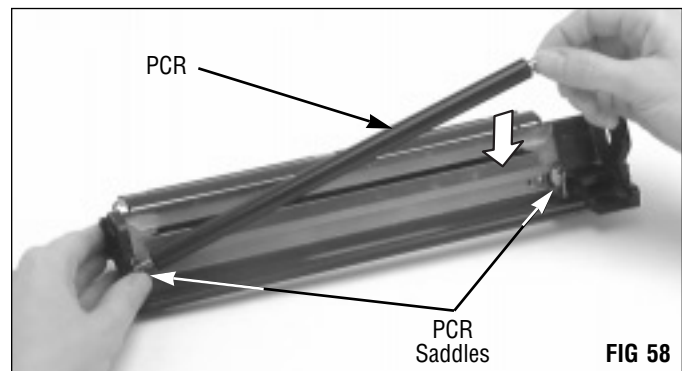
7. Clean and inspect the drum (FIG 59).

If you plan to reuse the drum, clean it with dry, filtered, compressed air.

Inspect the drum for deep concentric wear lines or cracks in the coating and replace the drum with a Fuji-Xerox 12 Odyssey OPC Drum (OSFJX12DRGR) as required.

Drum inserts, installed in the OEM drum, are required for proper cartridge operation. SCC's replacement Fuji-Xerox 12 drum is sold with the inserts and gears installed.
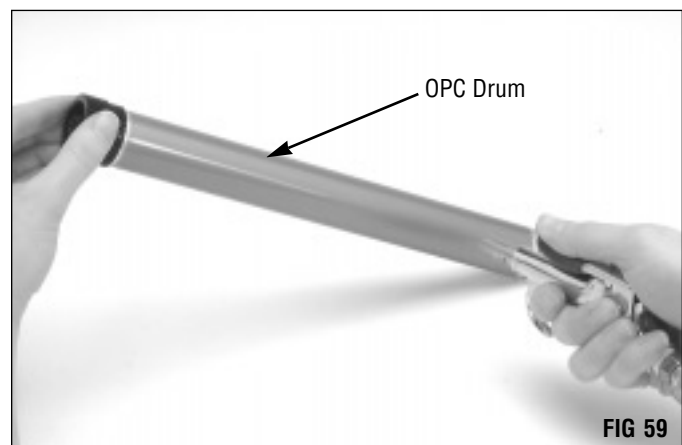
CAUTION For best results, we do not recommend using cleaning agents or coatings on the drum. Be careful not to nick the surface of the drum with the air nozzle.

OPC Drum

FIG 59

8. Pad the drum.
Pad the coated area of the drum with Kynar Lubricating Powder (KPOW) (FIG 60); avoid Kynar on the drum gear.
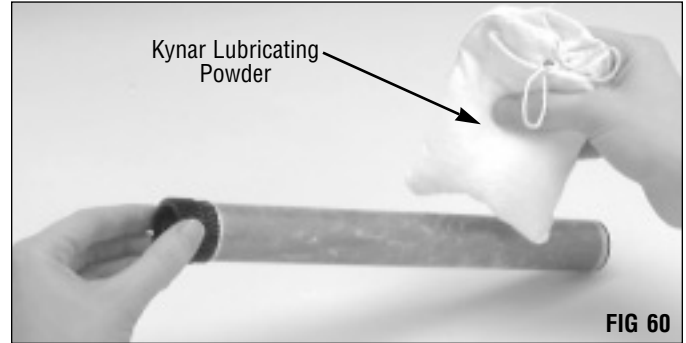

Kynar Lubricating Powder

FIG 60

9. Install the drum.
Place the drum in the waste bin with the helical gear on the right end of the waste bin (adjacent to the white PCR saddle) as shown in FIG 61.
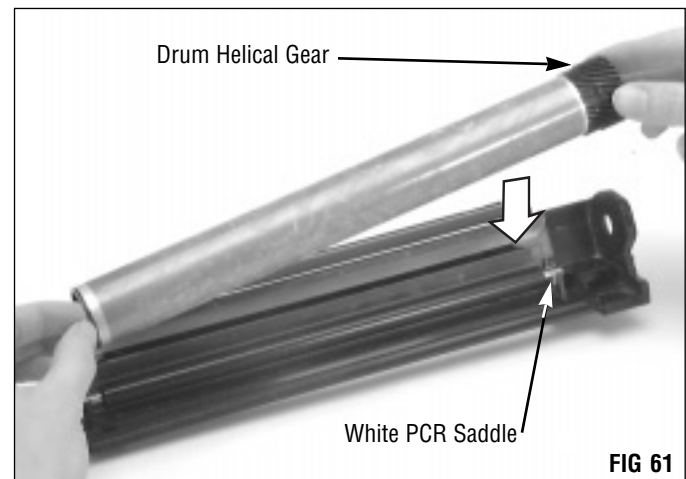

Drum Helical Gear

White PCR Saddle

FIG 61

10. Install the drum hub disk axle.
The plastic drum axle, which contains a metal contact, is installed at the drum hub disk end of the waste bin (FIGs 62 and 63).

Drum Hub Disk

FIG 63

Drum Spur Gear Axle (Contains Contact)
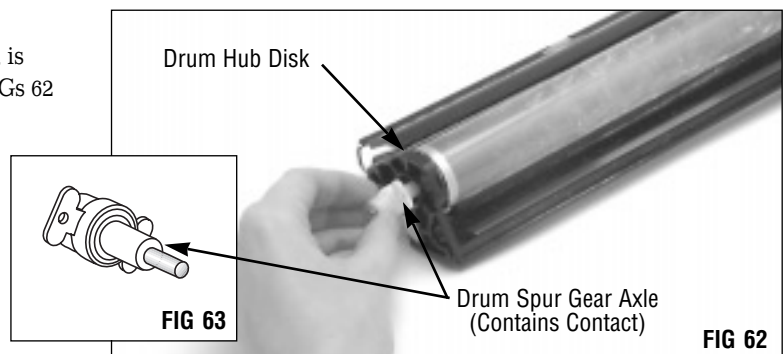
FIG 62

Two screw lengths are used in the FJX12 application. Be sure to use the SHORT screws to secure the drum axles (FIG 64 and 65). The long screws will puncture the waste bin housing.
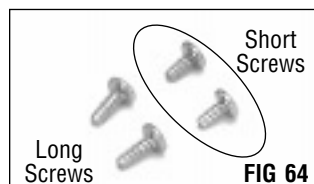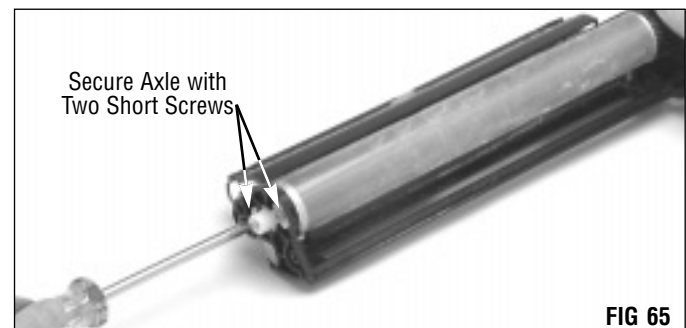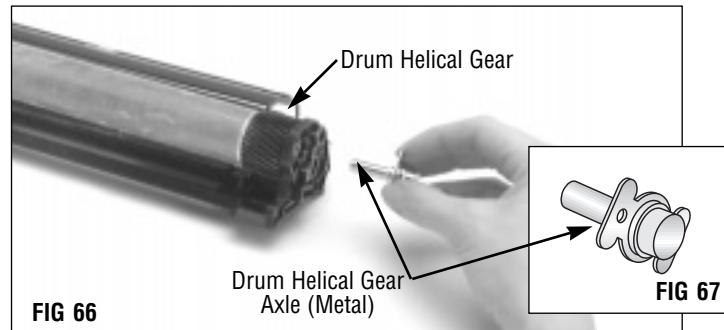

Short Screws

Long Screws

FIG 64


Secure Axle with Two Short Screws

FIG 65

Assembling the Waste Bin Section

11. **Install the drum helical gear axle.**
The metal drum axle is installed at the helical gear end of
the waste bin (FIGs 66 and 67).

Drum Helical Gear

Drum Helical Gear
Axle (Metal)

FIG 66

FIG 67

Two screw lengths are used in the FJX12 application. Be
sure to use the SHORT screws to secure the drum axles
(FIG 68 and 69). The long screws will puncture the waste bin
housing.

Short
Screws

Long
Screws

FIG 69

Secure Axle with
Two Screws

FIG 68
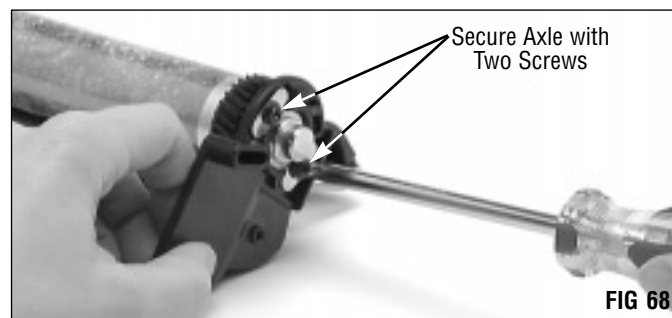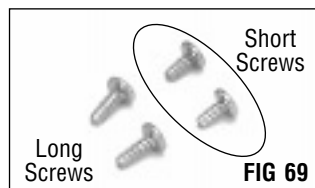
12. **Rotate the drum.**
Rotate the drum in its normal rotational direction, as
indicated by the arrow in FIG 70, at least 6 full drum
rotations. Rotating the drum will help lubricate the wiper
blade and prevent the potential of blade "flip overs".
Lubricating powder wiped from the drum by the wiper
blade will deposit in the waste bin.

Rotate Drum in Direction
Shown to Remove Kynar

FIG 70
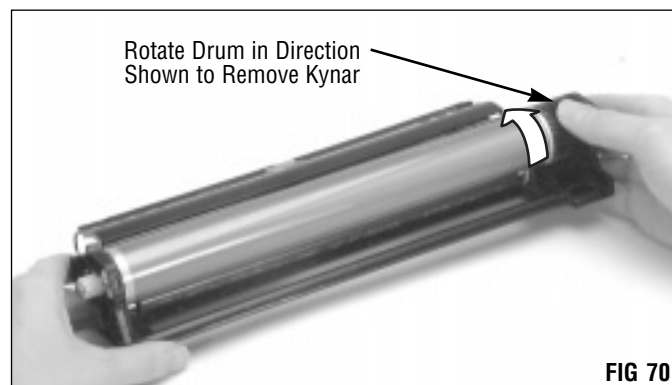
13. **Wipe lubricating powder from the PCR.**
After you have rotated the drum to remove the lubricating
powder, rotate the drum again in small increments in order
to clean the powder from the PCR. As you rotate the drum in
its normal rotational direction, wipe the powder from the
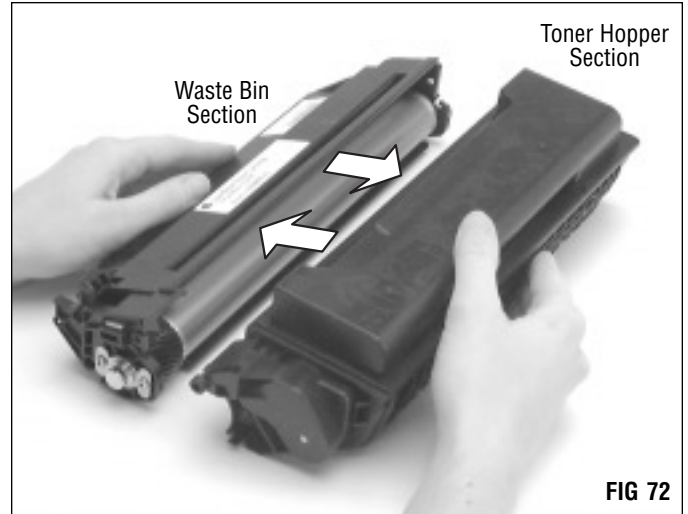PCR with a Lint-Free Cloth (LFCCLOTH) as shown in FIG 71.

You can also use dry, filtered compressed air instead of the
cloth to remove the powder from the PCR.
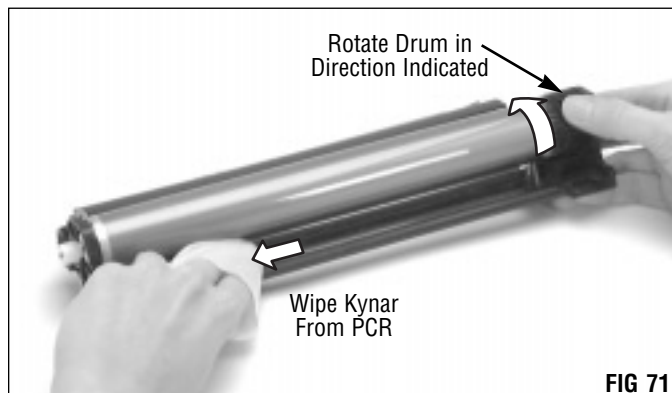
IMPORTANT Make sure there is no lubricating powder
present on the PCR, otherwise repeating voids in solid print
areas at the PCR interval may result.

Rotate Drum in
Direction Indicated

Wipe Kynar
From PCR

FIG 71

Assembling the Cartridge

1. **Bring the two cartridge sections together as shown in FIG 72.**

Waste Bin Section
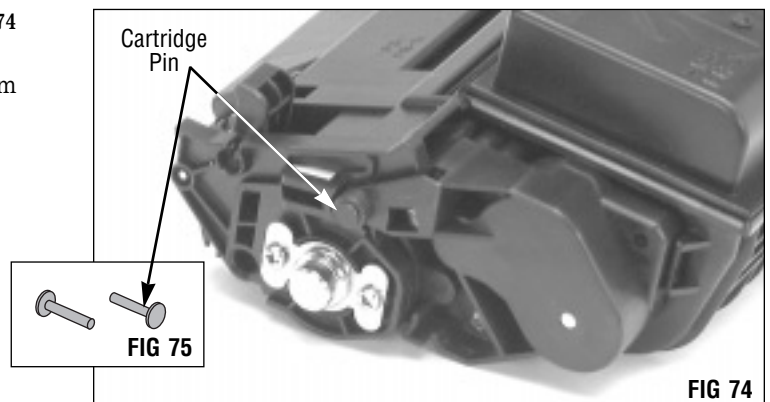
Toner Hopper Section

FIG 72

The hopper section should seat in the waste bin section as shown by the arrows in FIG 73.

FIG 73
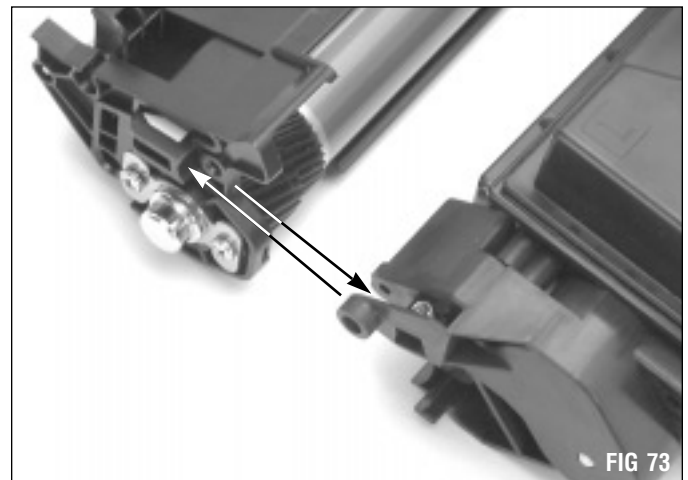
2. **Install cartridge pins at each end of the cartridge (FIGs 74 and 75).**
    Replacement Cartridge Pins (CARTPIN-L), available from SCC, will facilitate pin removal and installation in subsequent remanufacturing cycles.
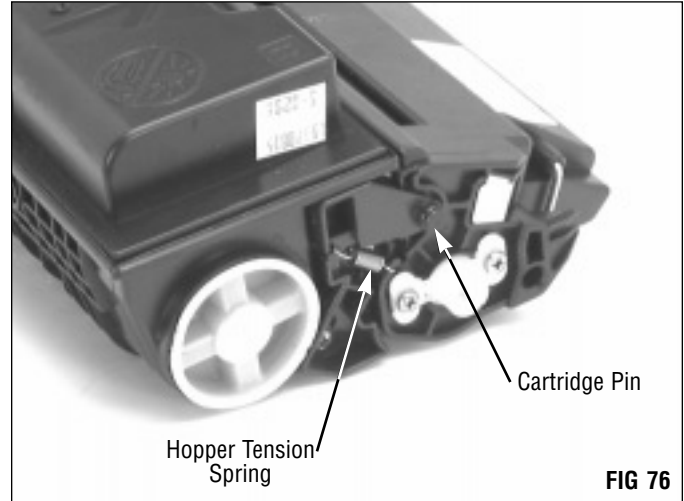

Cartridge Pin

FIG 75

FIG 74

Assembling the Cartridge

3. **Attach the hopper tension spring (FIG 76).**
    Use a pair of needlenose pliers or SCC's Hook Tool
    (HTOOL) to install the spring on the spring posts.

    Replacement Hopper Tension Springs (FJX12HTS) are
    available if the original spring is lost or stretched. A
    stretched hopper tension spring can contribute to light
    print defects.

Cartridge Pin

Hopper Tension
Spring

FIG 76

Notes

Imaging System Technology You Can Count On!

The development of cartridge imaging systems, such as the Fuji-Xerox 12 System, is the primary mission of our technology laboratories. Through extensive testing and research, we develop the optimum combination of matched components for each cartridge system. Our engineering and manufacturing expertise provides us with total control in design, quality and development to produce products from the ground up. The result is a system of components that seamlessly work together in each cartridge application.

This dedication and commitment results in integrated cartridge systems that Static Control fully supports, allowing you to quickly attack new market opportunities with complete confidence in the reliability and performance of your cartridges.

Static Control Components, Inc.