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IBM® 4317, Xerox® 4517, NEC® 1700 (Fuji-Xerox® 17) Remanufacturing Instructions



About the Cartridge

The Fuji-Xerox® 17 (FJX17) engine was first introduced in 1996 in the IBM® Network Printer 17 and Xerox® DocuPrint 4517. The FJX17 engine features 17 ppm print speed, a duplex option, and 600 dpi print resolution. The engine also supports edge-to-edge printing, a key selling point for the IBM printer.

The FJX17 cartridge 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.

The OEM cartridge pins can be removed by tapping them through the hopper and waste bin pin casings to the interior of the cartridge. The pins should fall out of the cartridge through the laser port. SCC recommends replacing the OEM pins with SCC's FJX17 system-qualified, long cartridge pin to facilitate subsequent remanufacturing. The pins feature a slim-line head designed to fit flush to the cartridge and to 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 FJX17 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 for the FJX17 application is currently under development.

The FJX17 recovery blade features a flexible poly material design. Both mylar- and poly-type recovery blades are available for the FJX17 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 hopper section houses a 440-gram toner load, mag roller, doctor blade and mag roller sealing blade. SCC testing has shown that FJX17-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 FJX17 application.

The FJX17 toner seal is part of the WhiteSeal™ line of ribbon-type seals. The WhiteSeal is a drop-in seal that is attached to the sealing channel with peel-to-expose adhesive. A FJX17 WhiteSeal Installation Kit, which includes a hopper fixture, installation

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World Wide Web

www.scc-inc.com

Printer Compatibility

IBM® Network Printer 17
Xerox® DocuPrint 4517
NEC® 1700

Fuji-Xerox® 17 Quick Reference

Estimated Remanufacturing Time	15-25 minutes
Toner Weight	440 grams
Toner Class	Magnetic, Monocomponent
Seal Type	WhiteSeal™ (Lay-in Seal)
Recommended Test Printer	IBM® Network Printer 17
Engine Designation	Fuji-Xerox® 17 (FJX17)

About the Cartridge

tool, seals and pull tab labels, is available to facilitate seal installation.

Additional sealing components in the hopper include mag roller felts that line the mag roller saddles and mag roller seal foam installed underneath the mag roller sealing blade. The OEM sealing foam is a three-part component; the aftermarket replacement, however, is designed as one strip of foam to facilitate installation. The doctor blade sealing foam is installed directly onto the doctor blade stamping.

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 compared 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

	Xerox® DocuPrint 4517/4517mp	IBM® Network Printer 17 (4317)
OEM Part Number	113R95	63H2401
OEM Published Yield ¹	10,000 pages	10,000 pages
Price (Retail List-US) ²	\$205	\$205
OEM Replacement Fuser Unit	Fuser Cartridge	Usage Kit (includes replacement fuser and bias transfer roller)
OEM Published Yield	200,000 pages ³	200,000 pages
OEM Part Number	108R92	63H2324 (US)
Price (Retail List-US) ²	\$270	\$349

¹Yield is based on 5% page coverage unless noted otherwise.

² Estimated prices as of December 1997.

² Estimated prices as of December 1997.

³Yield is based on 5% page coverage.

Printer Information

	Xerox® DocuPrint 4517/4517mp	IBM® Network Printer 17 (4317)
Introduction Date	January 1996	June 1996
Introduction List Price	\$2,070/\$2,850	\$1,999
Pages Per Minute (ppm)	17 ppm (simplex) 13 ppm (duplex)	17 ppm (simplex) 13 ppm (duplex)
Engine Duty Cycle	up to 65,000 pages/month	65,000 pages/month
Processor	(Controller) 25/50 MHz Intel i960	33 MHz Intel 80960CF, 32-bit RISC
Resolution (dpi)	600 (H) x 600 (V) dpi (native) 1,200 (H) x 600 (V) dpi DP-Tek TrueRes edge smoothing (600 dpi only), Quad Dot halftoning	600 (H) x 600 (V) dpi (native) DP-Tek TrueRes edge smoothing
Energy Star Compliant	yes	yes
Toner Saving Mode	yes (SmarToner toner saving mode)	yes (TonerMiser toner saving mode)
Page Size	letter, legal, A4, folio, executive (main tray)	letter, legal, A4, folio, executive (main tray)
Target Market	corporate network printing	

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 LFCLOTH
- Kynar® Lubricating Powder KPOW
- Shallow Trough for Dipping the Wiper Blade
- Cartridge Pins (Set of 2) CARTPIN-L
- Drum Shutter Felt 4LDSFELT
- Toner FJX17-440B
- FJX 17 Odyssey™ Drum OSFJX17DRGR
(Geared with Drum Inserts)

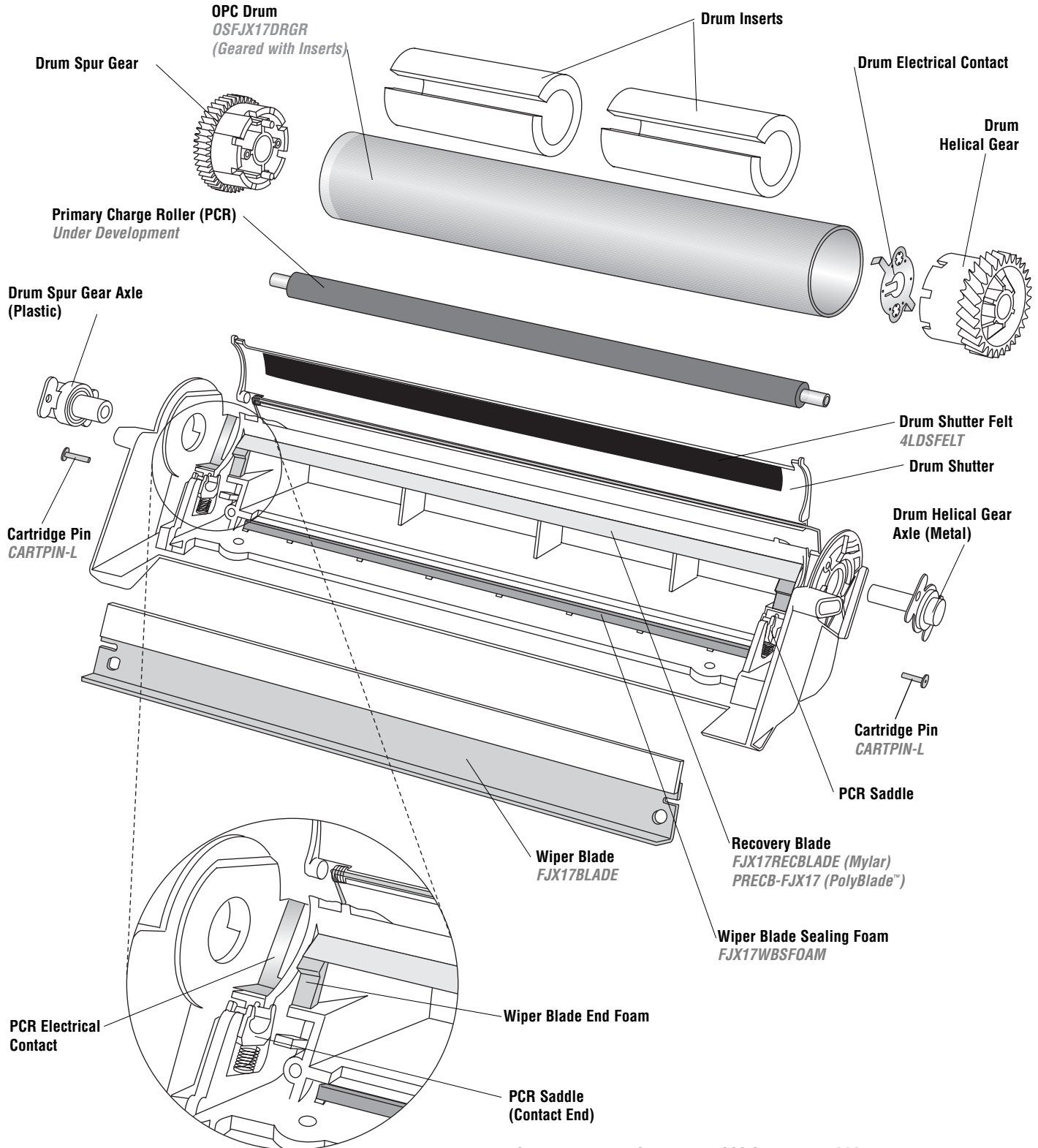
Item Codes for additional replacement items are included in the body of the instructions.

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

- Fuji-Xerox® 17 (IBM® 4317) WhiteSeal™ Installation Kit
..... FJX17WHSLKIT
Contents: hopper fixture (FJX17HJIG), installation tool (GSATool), 50 seals (FJX17WHSEAL), and pull tab labels.



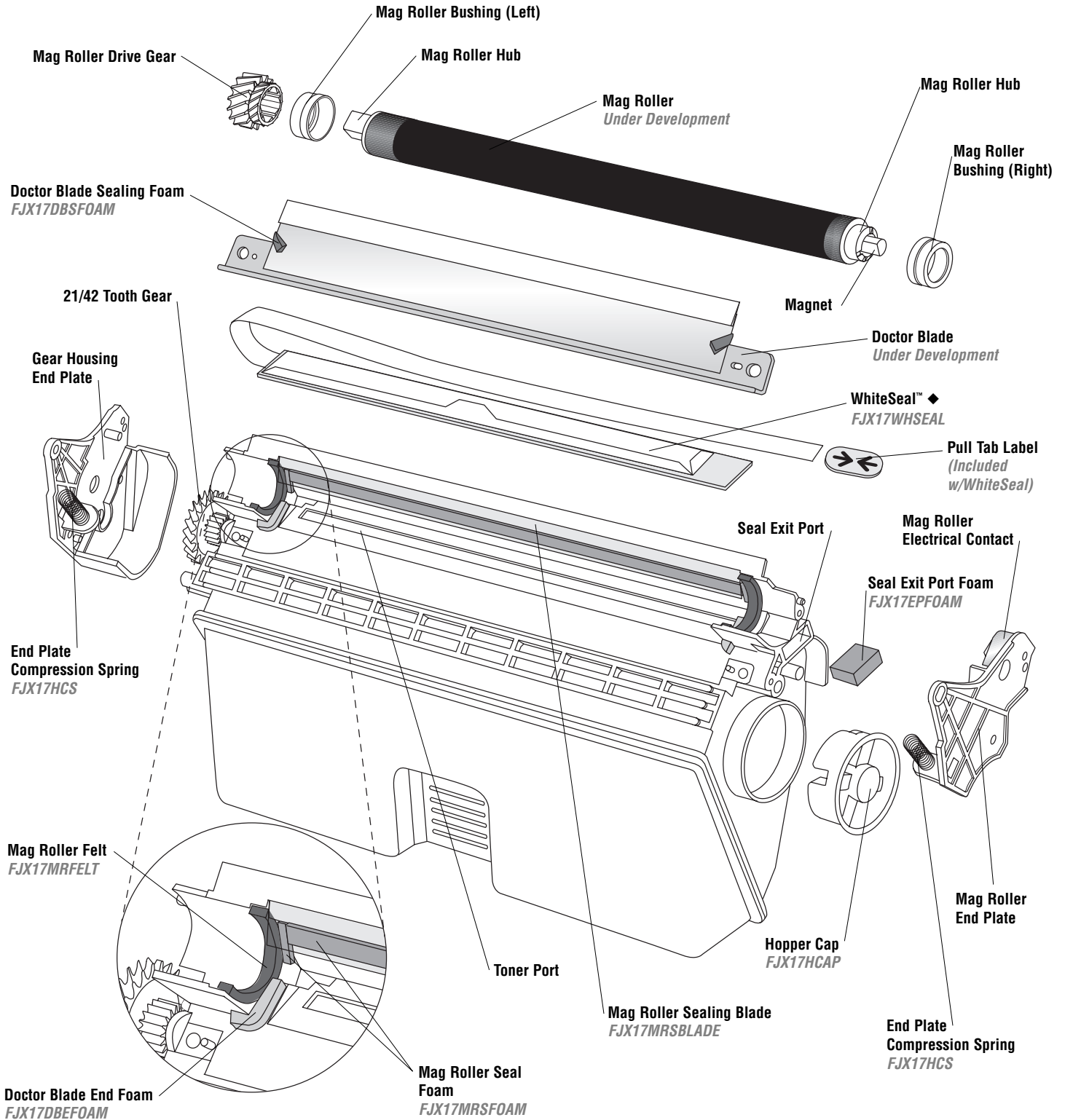
Waste Bin Section



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

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Toner Hopper Section



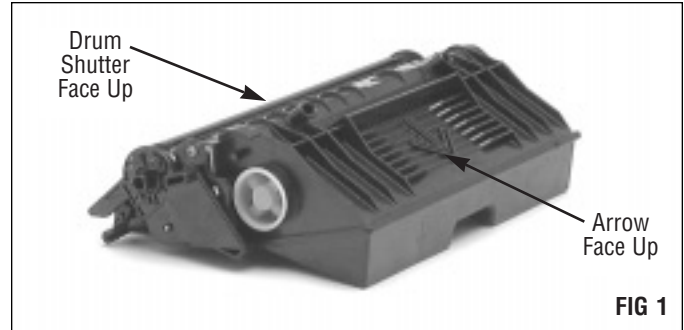
◆ Tool, Kit or System Available. Contact Your SCC Sales Team. SCC parts indicated in gray.

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Separating the Cartridge

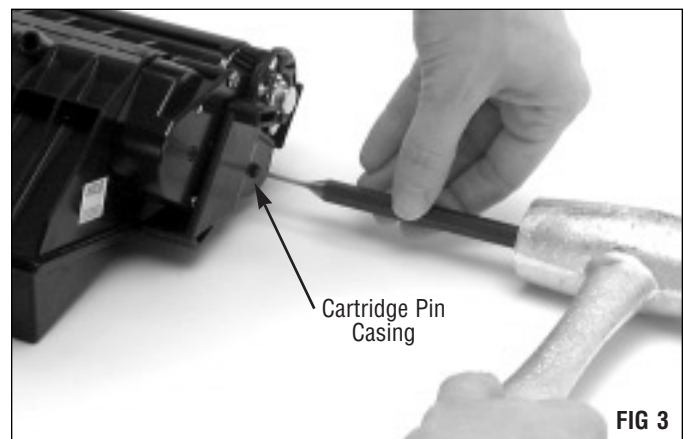
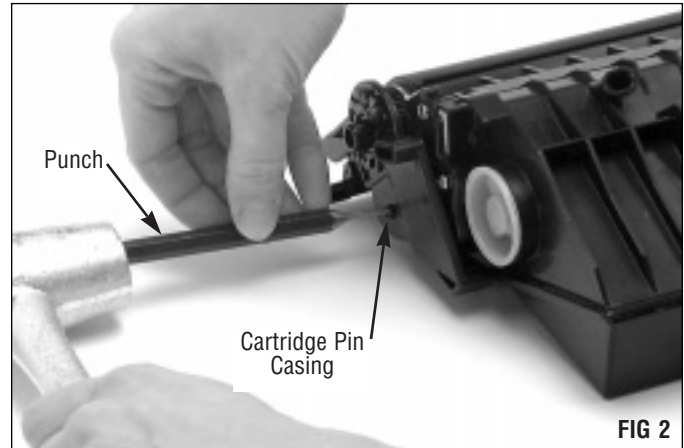
1. Remove the cartridge pins.

Position the cartridge on your work surface with the drum shutter and arrow facing up (FIG 1).



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

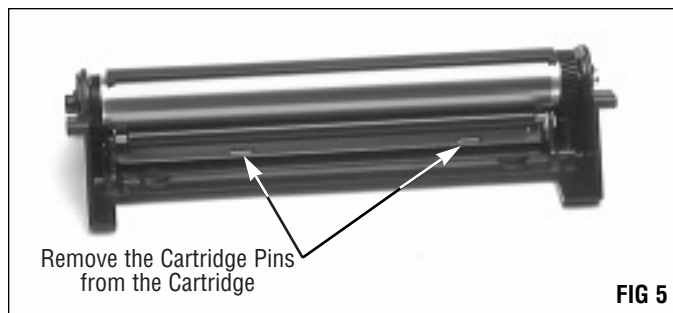
FJX17 system-qualified replacement Cartridge Pins (CARTPIN-L) will facilitate pin removal and installation in subsequent remanufacturing cycles.



2. Separate the cartridge (FIG 4).



IMPORTANT If you removed OEM pins, make sure the pins are completely removed from the cartridge (FIG 5). The pins sometimes remain in the waste bin section.

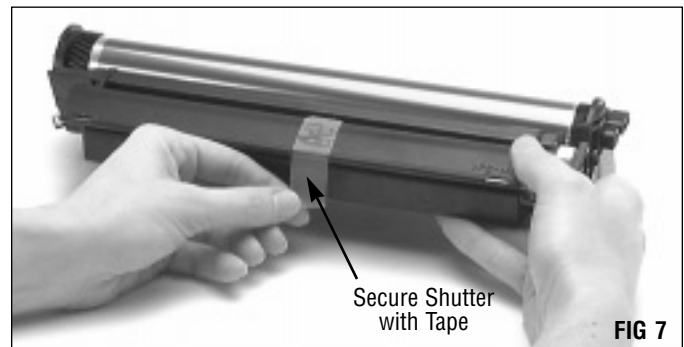
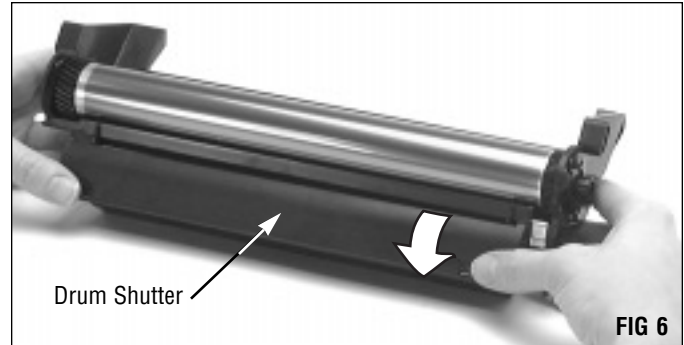




Disassembling the Waste Bin Section

1. Secure drum shutter.

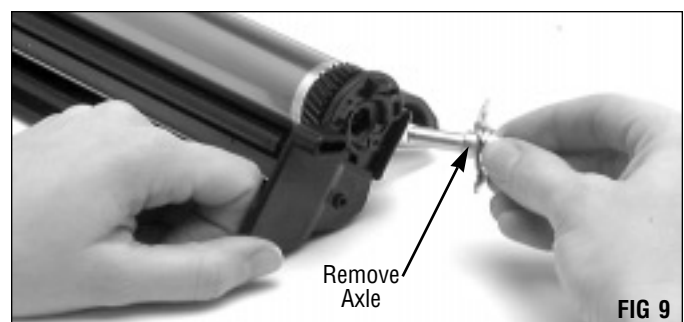
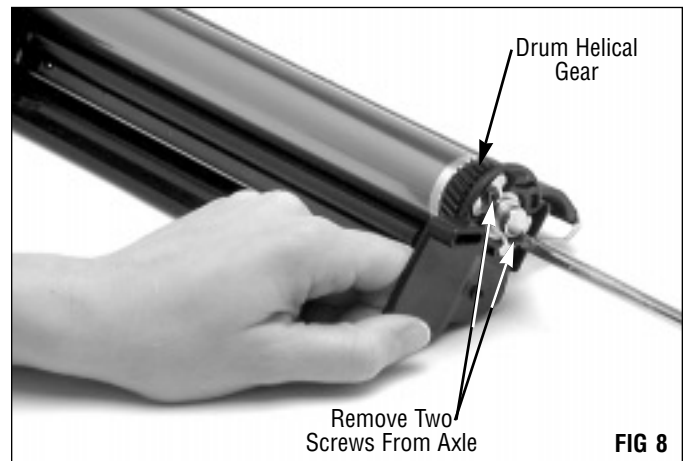
Open the drum shutter as shown by the arrow in FIG 6. Use a piece of tape to secure the shutter in place (FIG 7).



2. Remove the drum helical gear axle.

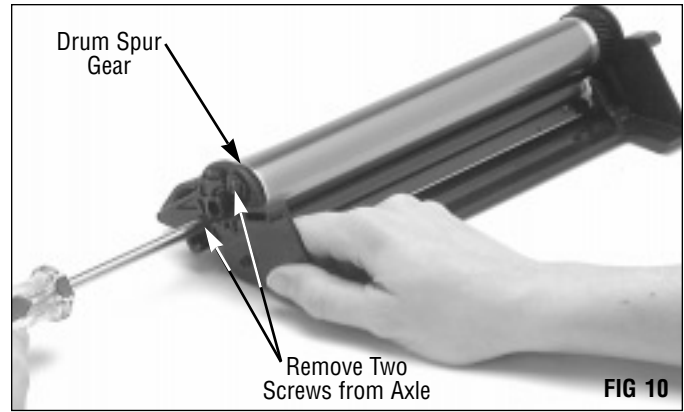
Remove two screws that secure the axle (FIG 8); then remove the axle (FIG 9). Note that the drum helical gear axle is metal.

NOTE In many cases, you can remove only one of the axles and effectively remove the drum. However in remanufacturing FJX 17 cartridges in the SCC Imaging Lab, we have noticed that removing only the spur gear axle to remove the drum can damage the wiper blade end foam. When removing the drum from the helical gear axle (metal axle), the helical gear tends to tear the wiper blade end foam. At this time, a replacement foam is not available. For best results against component damage, remove both drum axles and lift the drum from the waste bin section.



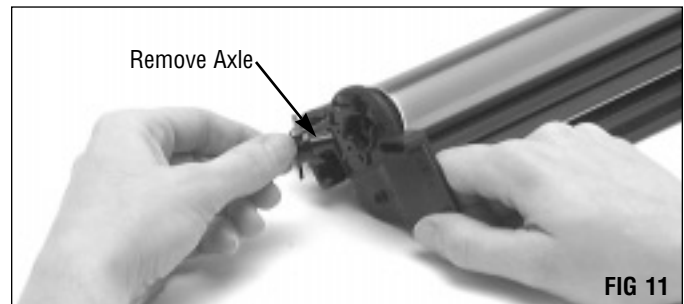
3. **Remove the drum spur gear axle.**

Remove two screws that secure the axle (FIG 10); then remove the axle (FIG 11). Note that the drum spur gear axle is plastic.



4. **Remove the drum.**

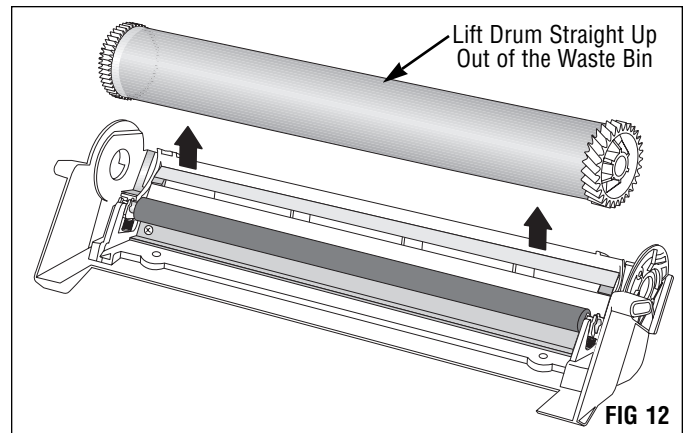
To avoid damage to the wiper blade end foams, grasp the gears at each of the drum and lift it straight from the waste bin (FIG 12).



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

For best results, we recommend replacing the OEM drum after the OEM cycle and replacing SCC's Odyssey Drum (OSFJX17DRGR) each remanufacturing cycle.

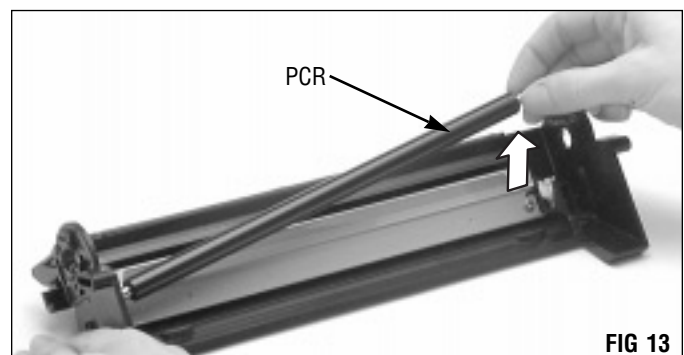
Note that the drum contains two drum inserts used to dampen drum vibrations during cartridge operation. The inserts must be installed in the drum. SCC's replacement Odyssey Fuji-Xerox 17 drum is sold with the inserts and gears installed.



5. **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.



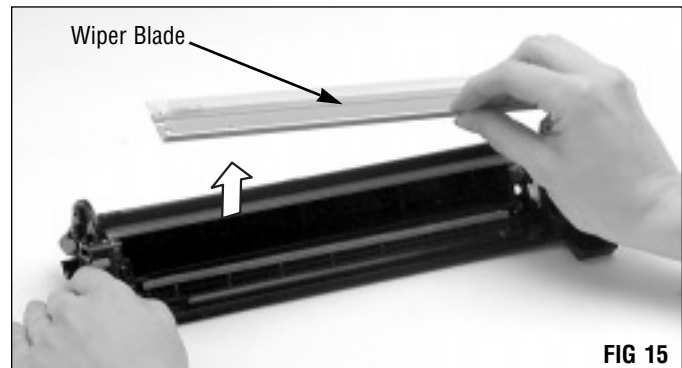
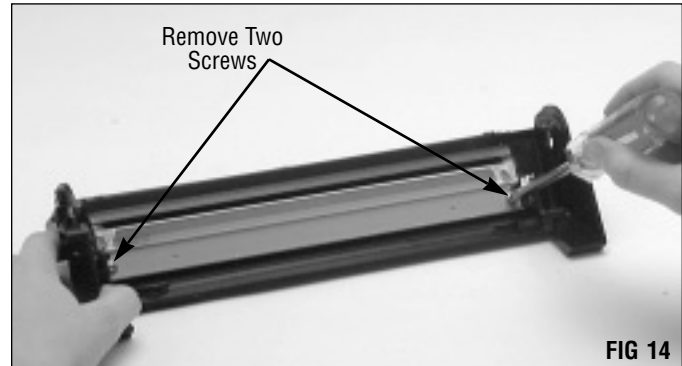
CAUTION Do not stack or lay anything on top of the PCRs, wrap PCRs with rubber bands, or touch the surface of the PCR with your bare hands.

Disassembling the Waste Bin Section

6. Remove the wiper blade.

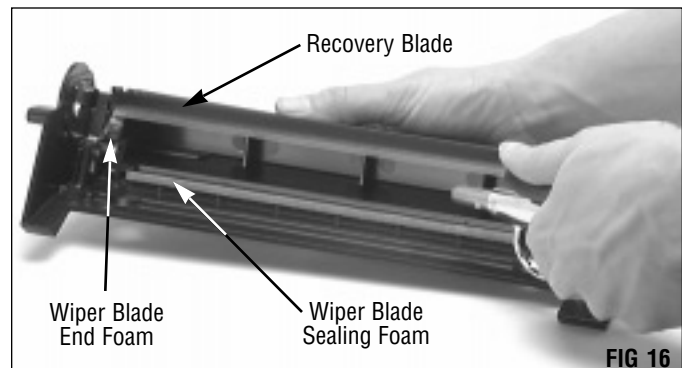
Remove two screws from the stamping as shown in FIG 14 and lift the blade from the waste bin as shown in FIG 15.

For best results, replace the Wiper Blade (FJX17BLADE) each time you replace the drum.



7. 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.

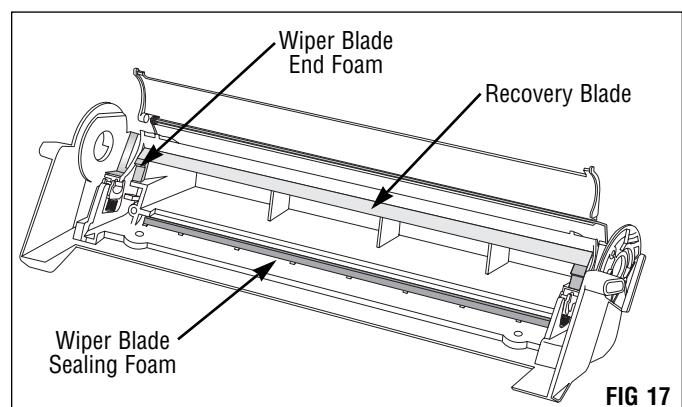


8. Inspect the sealing components in the waste bin (FIG 17).

The foam material, such as Wiper Blade Sealing Foam (FJX17WBSFOAM) and Wiper Blade End Foams, should display a smooth surface and be secured to the cartridge surface. Replace foam components that are ripped, pitted or missing.

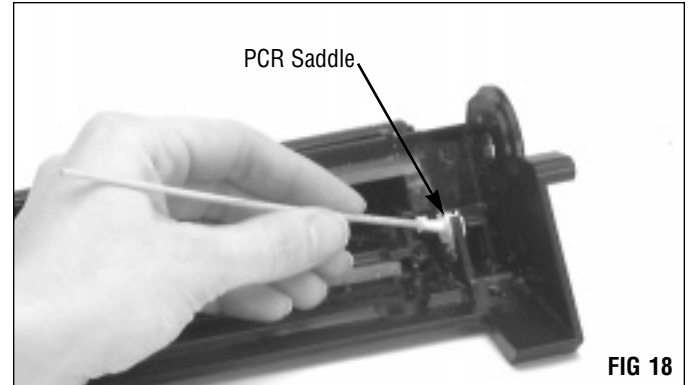
The **recovery blade** should display a smooth, flat surface without kinks or waviness along the edge. Replace the Recovery Blade (FJXRECBLADE-Mylar; PRECB-FJX17-PolyBlade™) if it is damaged, dislodged or missing.

Call your SCC Sales Team for product availability.



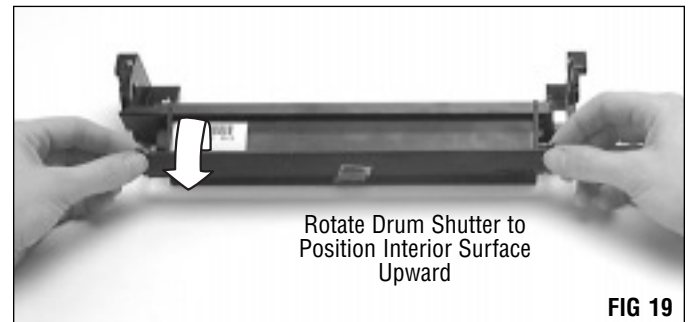
9. Clean the PCR saddles (FIG 18).

Clean toner residue from both PCR saddles using a Lint-Free Swab (LFSWAB) dampened with isopropyl alcohol.

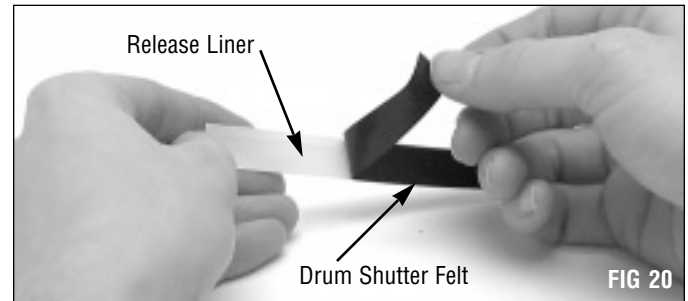
**10. Install a drum shutter felt.**

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.

Position the shutter so that the interior surface of the shutter is facing upward (FIG 19).



Remove the release liner from the felt (FIG 20).



Center the felt on the drum shutter as shown in FIG 21.

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



Disassembling the Toner Hopper Section

1. Place the hopper in the plexiglass holding fixture.

SCC offers a Plexiglass Hopper Fixture (FJX17HJIG) for the Fuji-Xerox 17 cartridge to facilitate hopper disassembly and assembly. If you plan to install a seal, note that the fixture is recommended to facilitate proper seal installation; the fixture is included in the Fuji-Xerox 17 WhiteSeal Kit (FJX17WHSEAL). Secure the fixture to your work surface with bolts or C-clamps.

Place the hopper in the fixture as shown in FIG 22, noting the orientation of the tall fixture support.

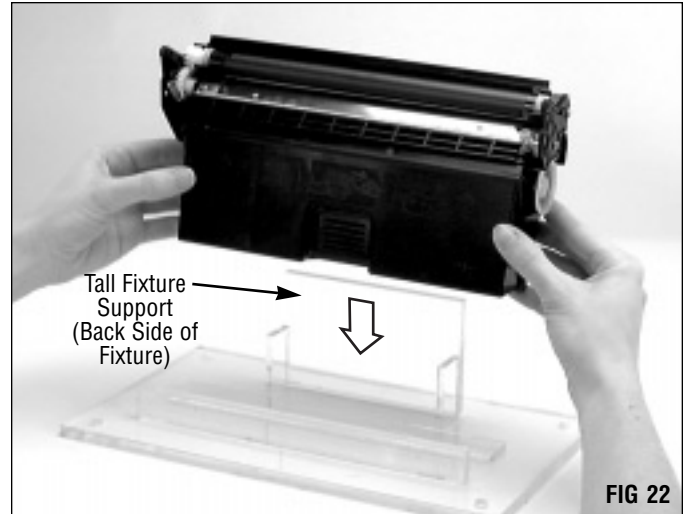


FIG 22

When placed correctly in the fixture, the hopper should lean against the tall fixture support (FIG 23) and should not slide laterally on the fixture.

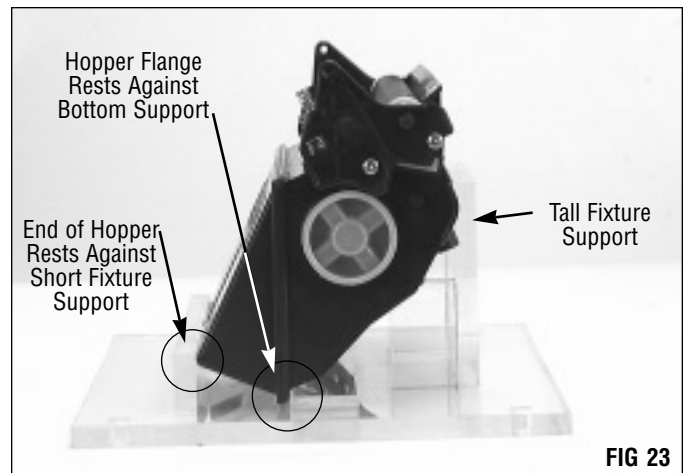


FIG 23

2. Remove the mag roller end plate.

Remove two Phillips screws and remove the end plate (FIGs 24 and 25).

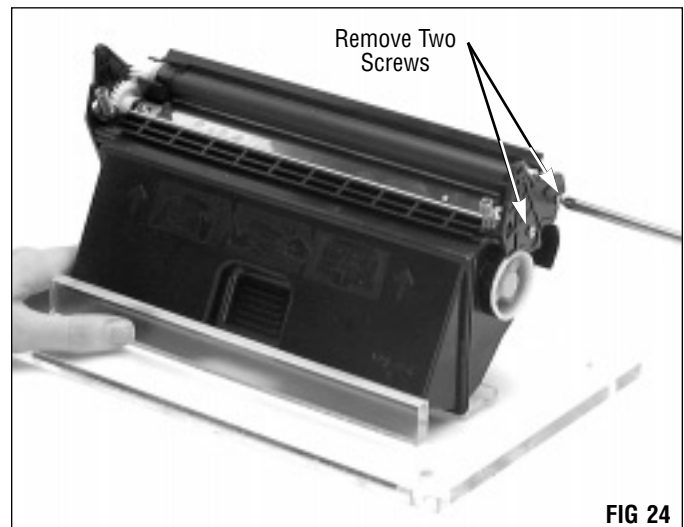
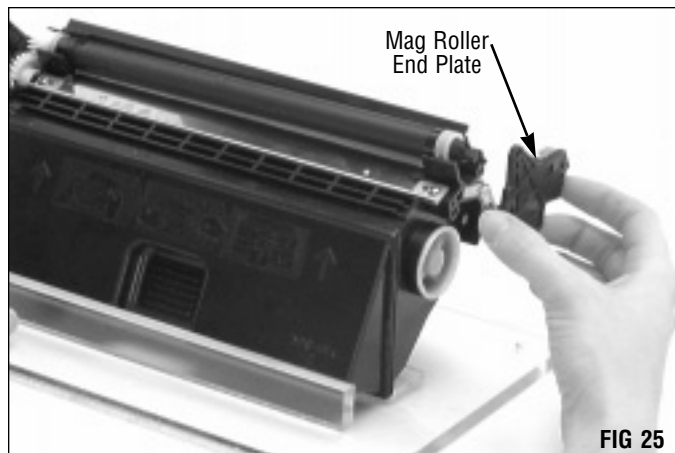
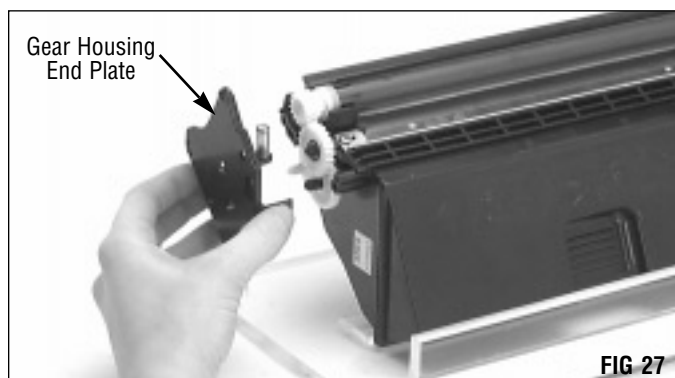
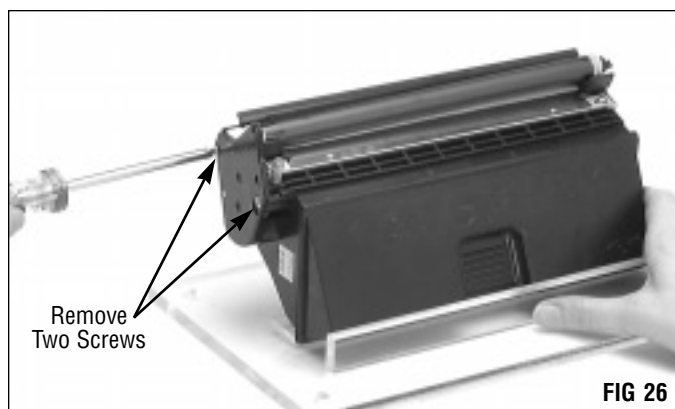


FIG 24



3. **Remove the gear housing end plate.**
Remove two Phillips screws and remove the end plate (FIGs 26 and 27).



4. **Remove the mag roller drive gear (FIG 28).**



Disassembling the Toner Hopper Section

5. Remove the mag roller.

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

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, but **DO NOT** stack the rollers on top of each other.

If you reuse the mag roller, store it on a soft, clean surface. A recoated mag roller for the Fuji-Xerox 17 application is currently under development; contact a member of your SCC Sales Team for product availability.

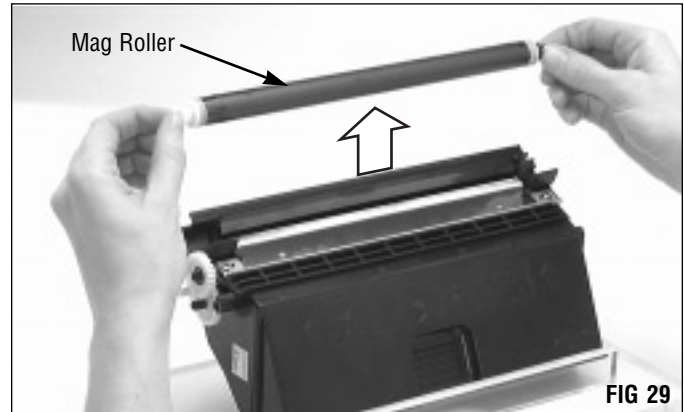


FIG 29

6. Remove the mag roller bushings from the mag roller (FIG 30).

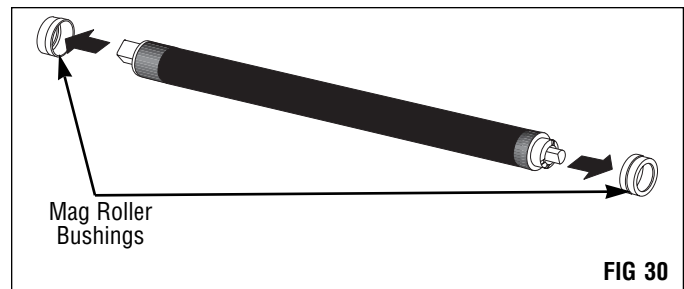


FIG 30

7. Remove the doctor blade.

Remove two screws from the blade stamping (FIG 31); then remove the blade (FIG 32).

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

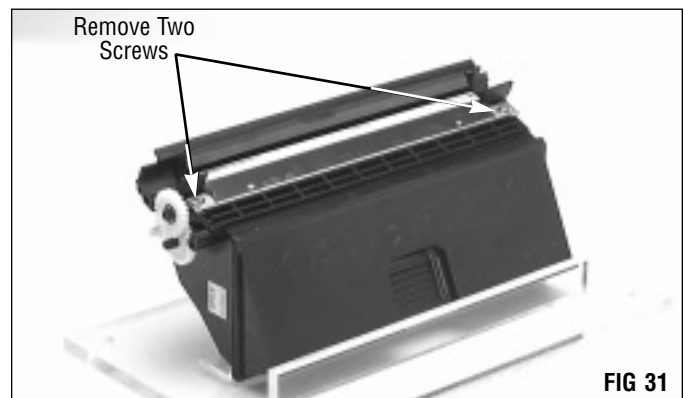


FIG 31

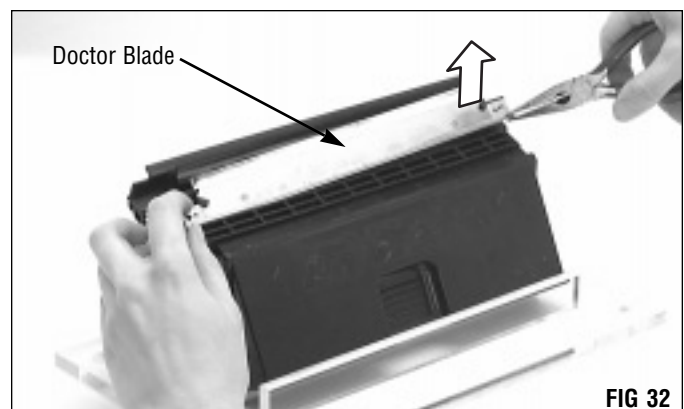


FIG 32

8. **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 33). Take care not to damage the recovery blade. Refer to FIG 34 for the orientation and location of the foam and felt materials.



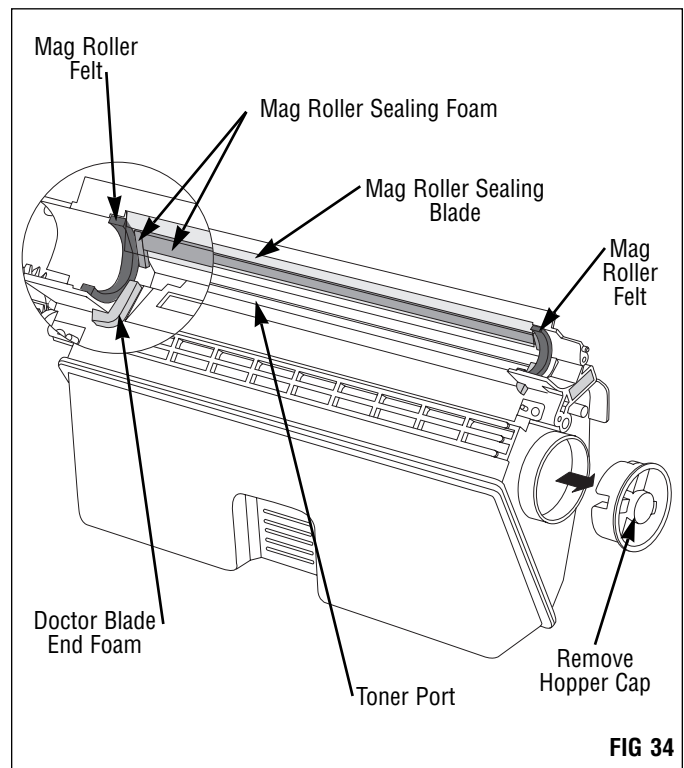
9. **Inspect the sealing components in the hopper section and replace as required (FIG 34).** Foam components such as the Doctor Blade End Foams (FJX17DBEFOAM) and Mag Roller Seal Foam (FJX17MRSFOAM) should display a smooth, clean surface. Make sure the foam materials are secured in the correct position (FIG 34). Note that the mag roller sealing blade must be removed in order to replace the mag roller sealing blade foam.

Mag Roller Felts (FJX17MRFELT) 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.

The Mag Roller Sealing Blade (FJX17MRSBLADE) should exhibit a smooth, flat surface along the entire length of the blade. Make sure the blade is fully attached to the mounting surface particularly at the ends of the blade.

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

10. **Remove the hopper cap if you plan to seal the cartridge (FIG 34).** A replacement Hopper Cap (FJX17HCAP) is available if the OEM cap is damaged or lost.



Install a Fuji-Xerox® 17 (IBM® 4317) WhiteSeal™

If you plan to seal the cartridge, 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 4517 WhiteSeal Kit (FJX17WHSLKIT) that includes a hopper fixture (FJX17HJIG), an installation tool (GSATool), 50 seals (FJX17WHSEAL), pull tab labels and instructions.

If you do not seal the cartridge, fill the hopper through the toner port with the 440 grams of toner (FJX17-440B). Make sure the hopper cap is securely installed in the hopper before filling. Then, assemble the cartridge following the instructions in the remaining sections of this manual.



Assembling the Toner Hopper Section

1. Clean the doctor blade.

Clean the blade with dry, filtered compressed air (FIG 35).

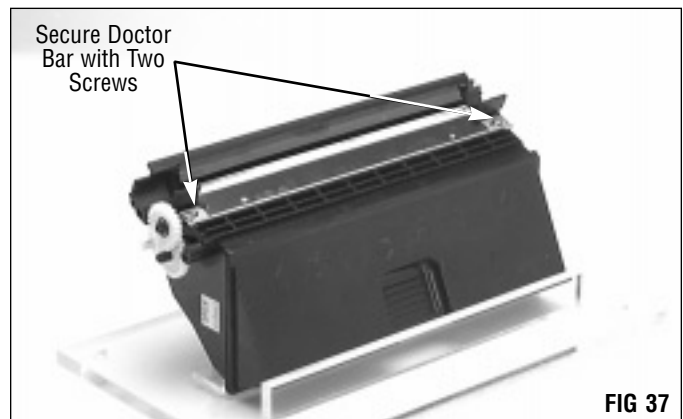
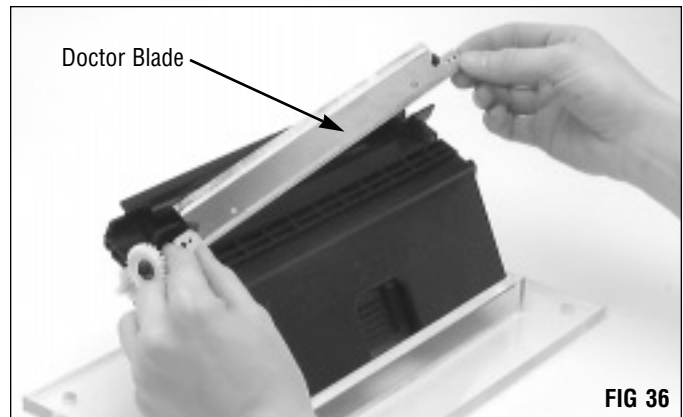
The Doctor Blade Sealing Foam (FJX17DBSFOAM) should display a smooth surface and be securely attached to the blade stamping. Replace the foam if the material is torn or detached from the stamping. *Detailed installation instructions are included with the foam.*

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

CAUTION Do not apply alcohol to the doctor blade sealing foam. The alcohol will attack the adhesive on the foam causing it to peel from the doctor blade stamping. Replace the Doctor Blade Sealing Foam (FJX17DBSFOAM) if damaged.

2. Install the doctor blade.

Position the blade stamping on the locating posts and secure the blade with two Phillips screws (FIGs 36 and 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 fingers.

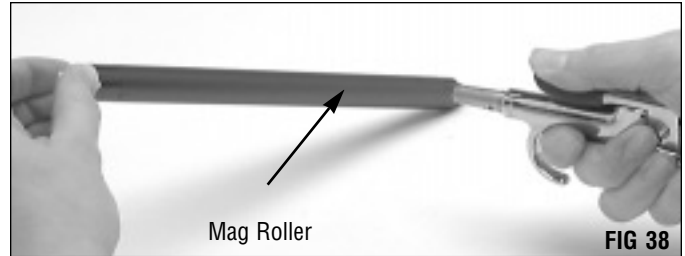


FIG 38

4. **Clean the mag roller bushings.**

Clean the bushings with a Lint-Free Swab (LFSWAB) or Lint-Free Cloth (LFCCLOTH) (FIG 39).

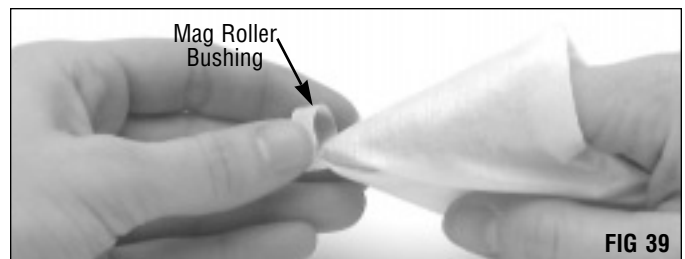


FIG 39

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

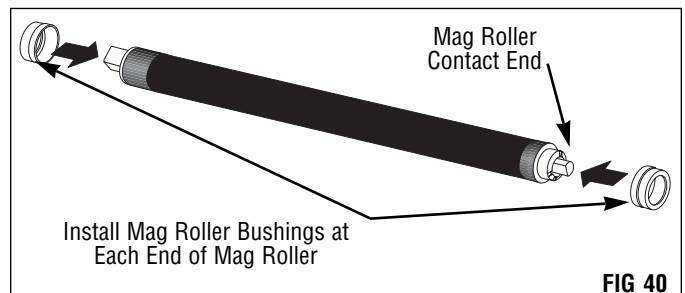


FIG 40

6. **Install the mag roller.**

Position the mag roller with the contact end at the right end of the toner hopper (FIG 41).

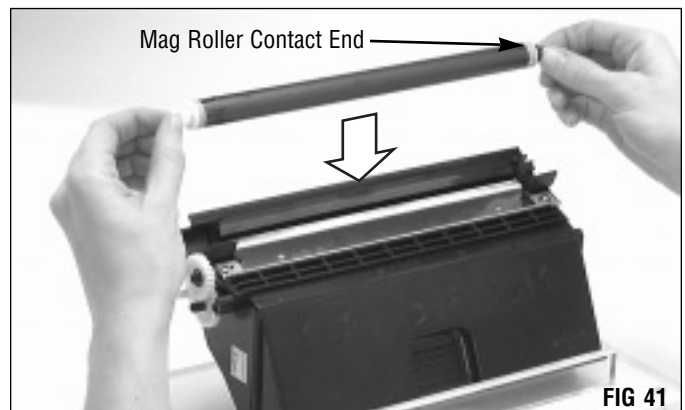
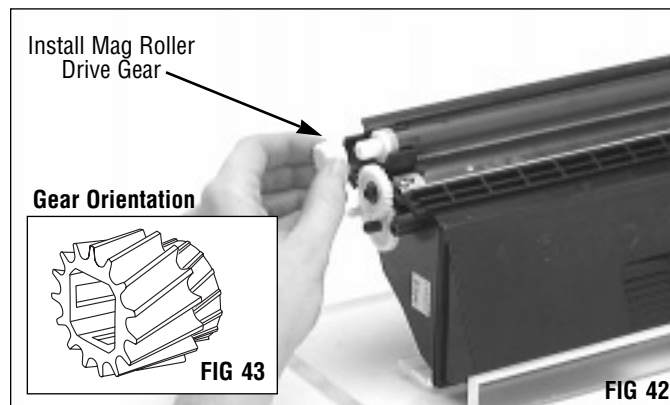


FIG 41

Assembling the Toner Hopper Section

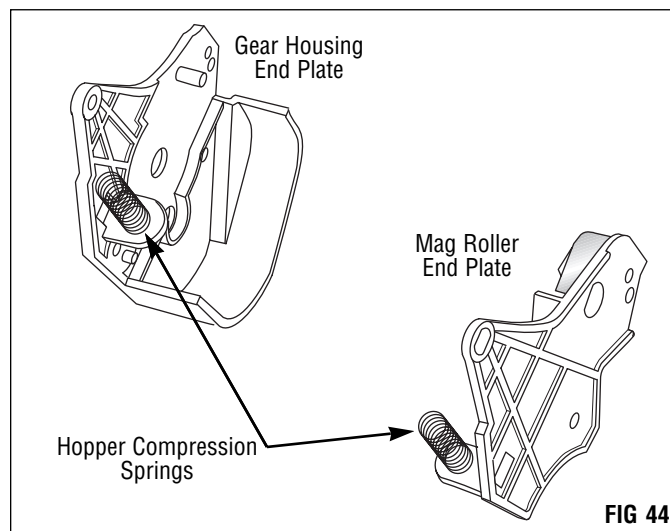
7. Install the mag roller drive gear (FIG 42).

Note the orientation of the gear as shown in FIG 43.



8. Inspect the hopper compression springs on gear housing and mag roller end plates.

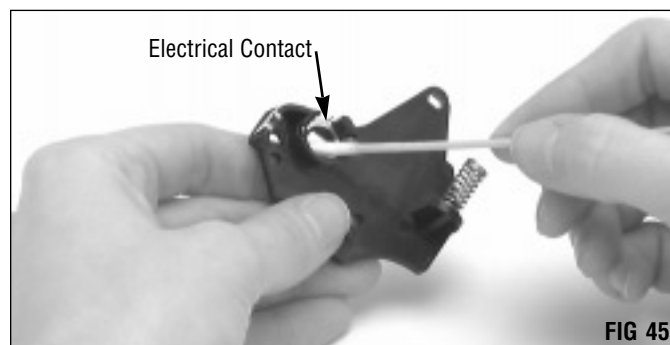
Replacement FJX17 Hopper Compression Springs (FJX17HCS) are available if the original springs are bent, stretched or missing (FIG 44).



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 45).

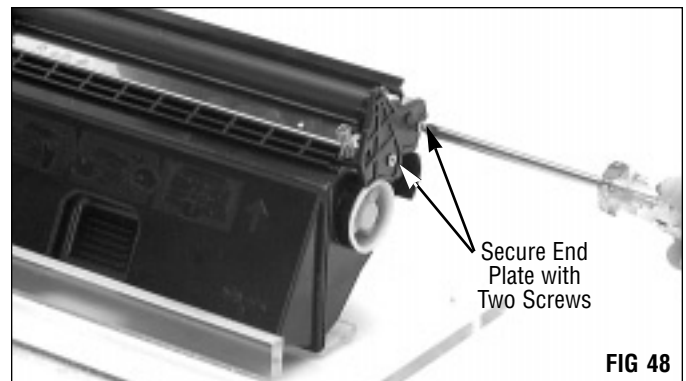
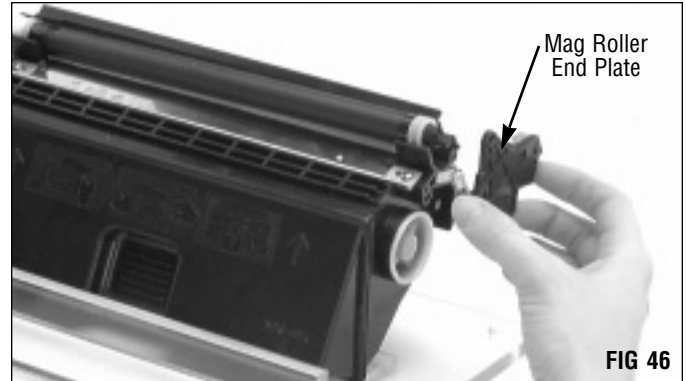
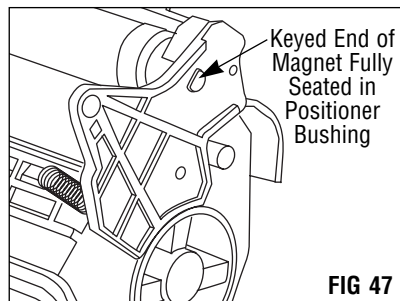
Note that conductive lubricant is NOT used on the electrical contact in the OEM cartridge.



10. Install the mag roller end plate (FIG 46).

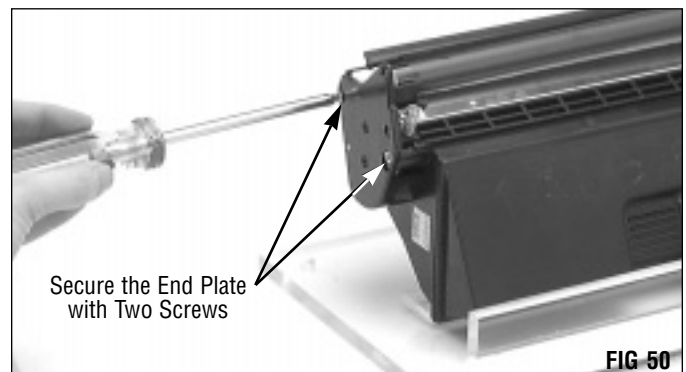
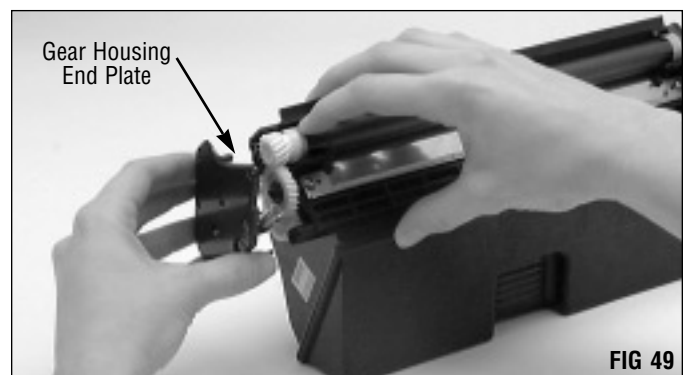
Note that the mag roller axle is keyed and fits into a positioner bushing in the end plate (FIG 47).

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



11. Install the gear housing end plate (FIG 49).

Secure the end plate with two Phillips screws (FIG 50).





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 51).

CAUTION Do not use 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.

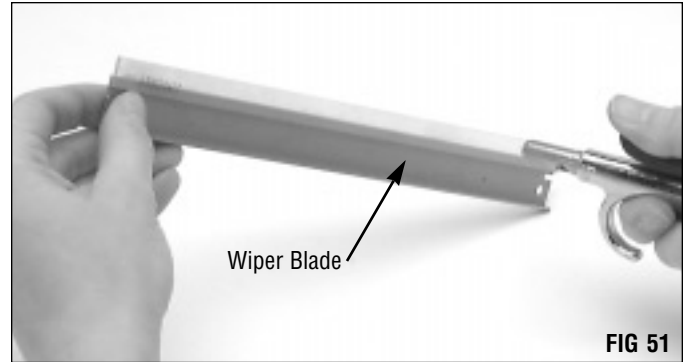


FIG 51

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 52. Examine the blade to ensure even coverage. Repeat.

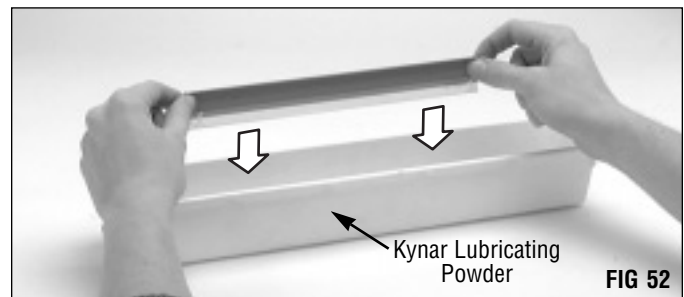


FIG 52

3. Install the wiper blade.

Position the stamping over the locating posts in the waste bin, and secure the blade with two Phillips screws (FIGs 53 and 54).

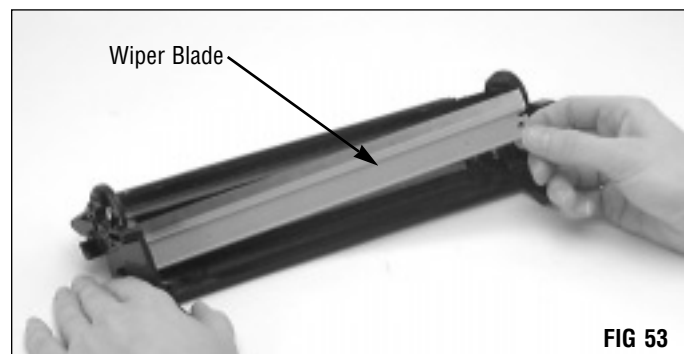


FIG 53



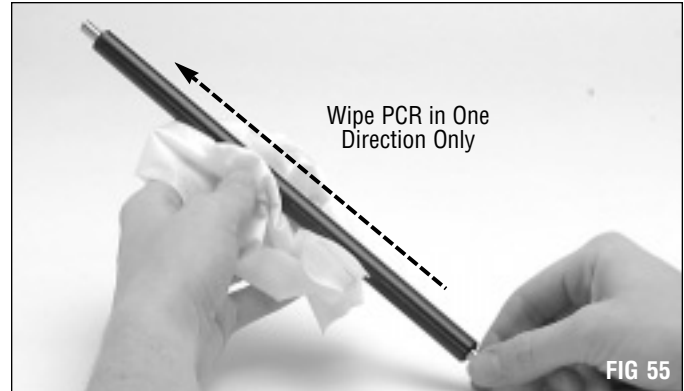
FIG 54

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.

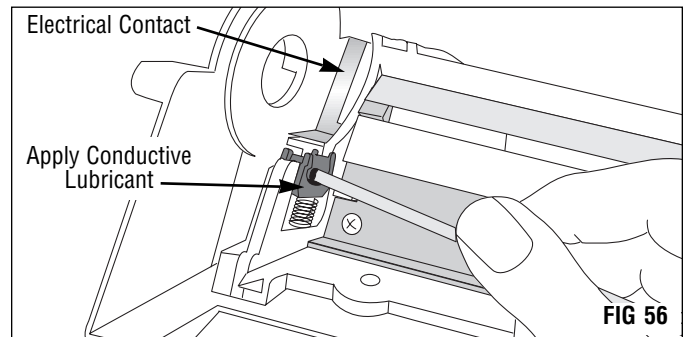
Gently wipe the PCR in one direction. Be careful not to pinch or dent the surface of the PCR, as the material has poor memory (FIG 55).

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



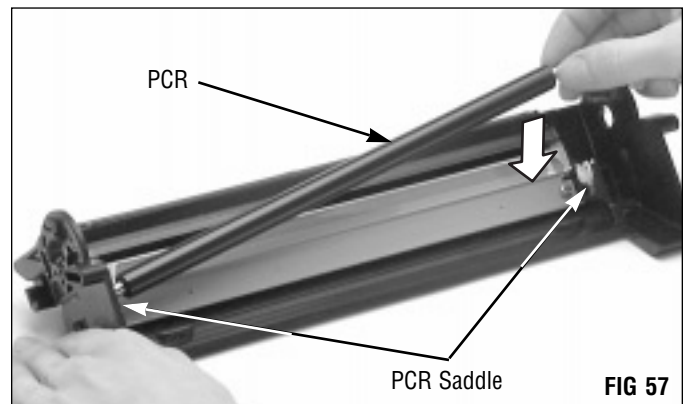
5. **Apply Conductive Cartridge Lubricant (CONCLUBE) to the PCR saddle at the contact end of the cartridge (FIG 56).**

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



5. **Install the PCR (FIG 57).**

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



6. **Clean and inspect the drum.**

If you plan to reuse the drum, clean it with compressed air or a soft, lint-free cloth (FIG 58).

Inspect the drum for deep concentric wear lines or cracks in the coating and replace the OPC Drum (OSFJX17DRGR) as required.

Drum inserts, installed in the OEM drum, are required for proper cartridge operation. SCC's replacement Fuji-Xerox 17 drum is sold with the inserts and gears installed.

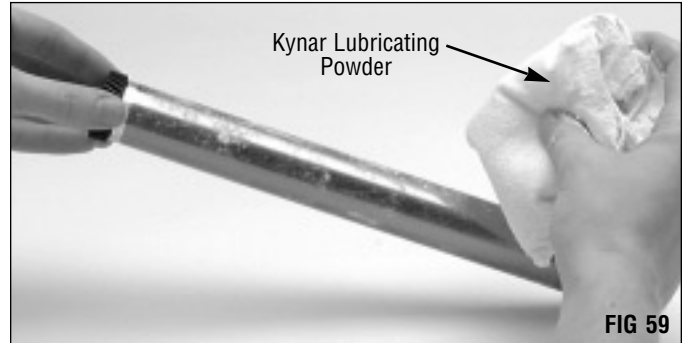


CAUTION Do not use cleaning agents or coatings on the drum. Be careful not to nick the surface of the drum with the air nozzle.

Assembling the Waste Bin Section

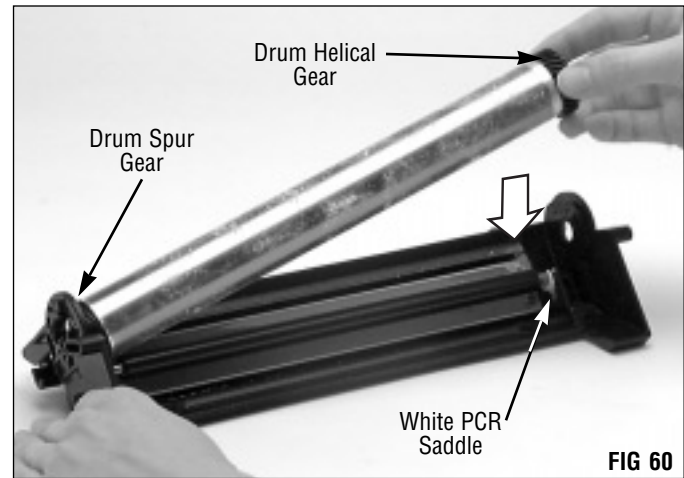
7. Pad the drum.

Pad the coated area of the drum with Kynar Lubricating Powder (KPOW) (FIG 59); avoid Kynar on the drum gears.



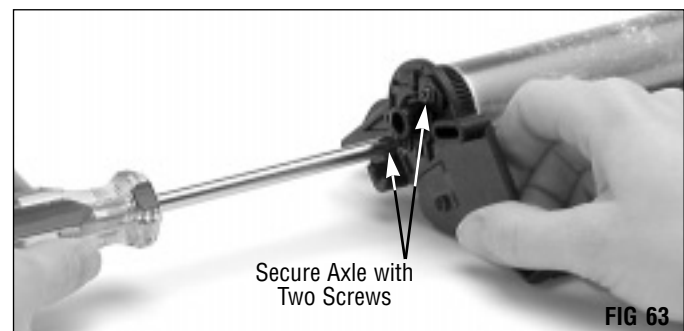
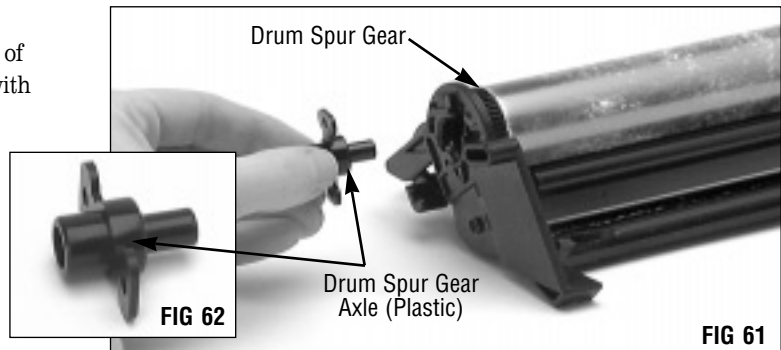
8. Install the drum.

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 60.



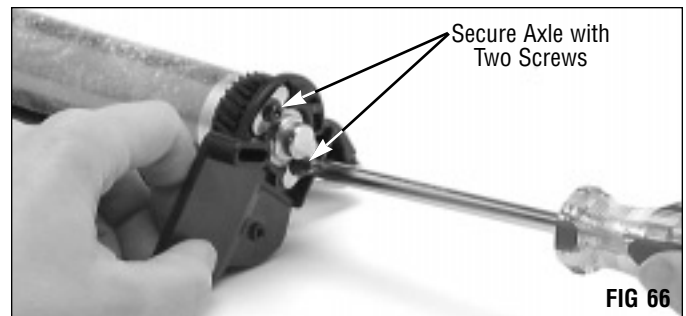
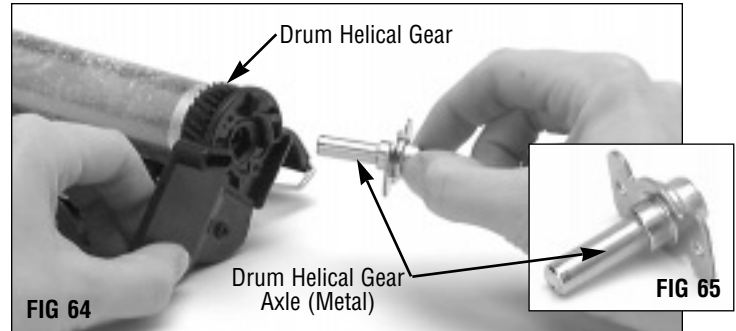
9. Install the drum spur gear axle.

The plastic drum axle is installed at the spur gear end of the waste bin (FIGs 61 and 62). Secure the drum axle with two Phillips screws (FIG 63).

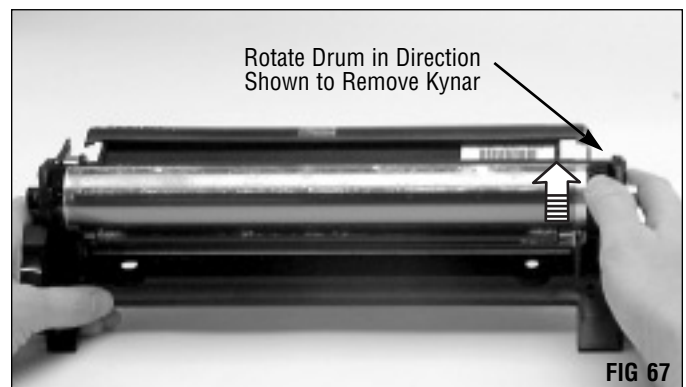


10. Install the drum helical gear axle.

The metal drum axle is installed at the helical gear end of the waste bin (FIGs 64 and 65). Secure the drum axle with two Phillips screws (FIG 66).

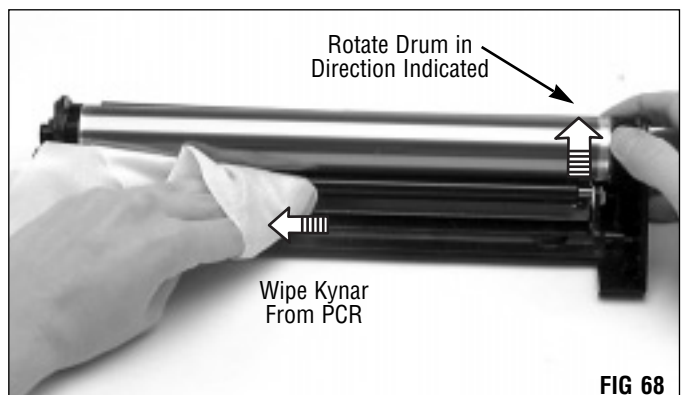
**11. Rotate the drum.**

Rotate the drum in its normal rotational direction, as indicated by the arrow in FIG 67, at least six full drum rotations. Rotating the drum will help lubricate the wiper blade and prevent the potential of blade “flip overs”. The lubricating powder wiped from the drum by the wiper blade will deposit in the waste bin.

**12. Wipe Kynar from the PCR.**

After you have rotated the drum to remove the powder, rotate the drum again in small increments to clean the lubricating 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 (LFCLOTH) as shown in FIG 68.

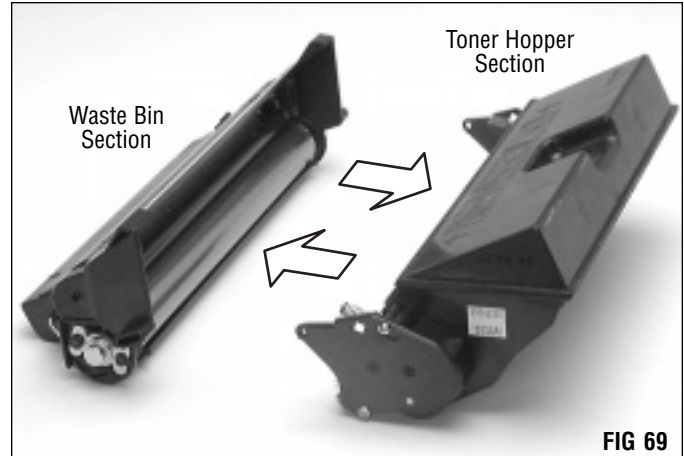
You can also use dry, filtered compressed air instead of the cloth to remove the powder from the PCR.



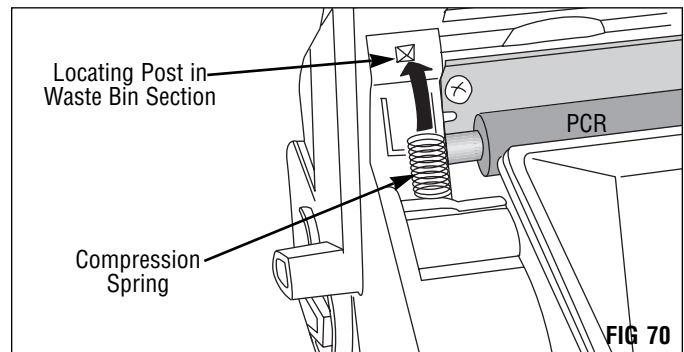
IMPORTANT Make sure there is no Kynar present on the PCR, otherwise repeating voids in solid print areas at the PCR interval may result.

Assembling the Cartridge

1. Bring the two cartridge sections together as shown in FIG 69.

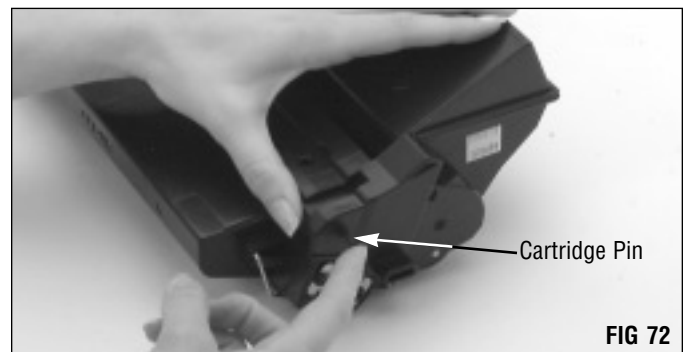
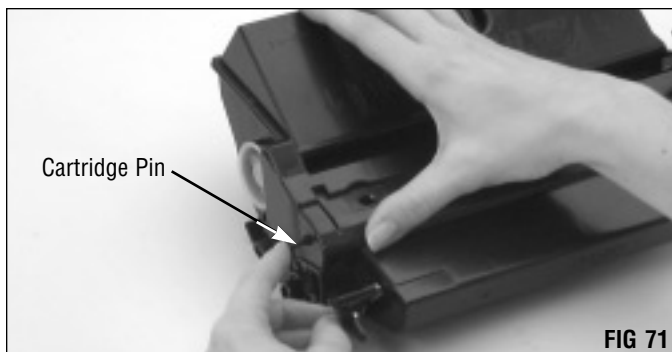


Position the ends of the hopper compression springs on locating posts in the waste bin (FIG 70).

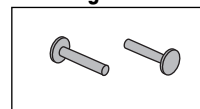


2. Install cartridge pins at each end of the cartridge (FIGS 71 and 72).

FJX17 system-qualified replacement Cartridge Pins (CARTPIN-L) will facilitate pin removal and installation in subsequent remanufacturing cycles.



Cartridge Pin-Long



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