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Xerox® XE/P8 (Sharp AL-800) Remanufacturing Instructions For Toner and Drum Units



About the Cartridge

In May 1998 Xerox® released the DocuPrint® P8 digital printer, which used the eight page-per-minute Sharp® AL-800 engine. The Xerox Document WorkCentre XE 60/62/80/82 digital multifunctional line followed in October 1998 using the same Sharp engine. In 1999, Sharp again used the engine in the AL-800 digital copier series released in January, and in the FO-3800 laser multifunctional in November.

Xerox was very aggressive in pushing these machines into all channels of distribution, including superstores, catalogers, dealers and open wholesale distribution, and placements for the Xerox WorkCentre machines have been continually on the rise.

These units feature a two-piece consumable design, and utilize a monocomponent toner with an 80g OEM toner weight. The consumables are designed for 100% toner transfer, leaving no waste toner. New Xerox machines come with a starter toner cartridge that has a yield of 1,500 pages, while replacement OEM toner cartridges have a rated page yield of 3,000 pages. The OEM drum cartridge has a rated yield of 20,000 pages, and is compatible with both the XE and P8 toner units.

Although the toner cartridges may use the same internal components, it is important to note that external designs vary between the cartridges, which affects compatibility between machine models. The Xerox P8 and XE toner cartridges have different tab configurations on the top of the cartridge, preventing them from being interchangeable. Also, the XE has a solid black sensor which differs from the clear sensor on the P8 toner cartridge.

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 documents are available on o
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Sharp® AL-800 Engine Information

Printer Name	Xerox® DocuPrint® 2 Laser Printer
Date of Printer Introduction (Current/Discontinued)	May 1998 (Current)
Print Speed.....	8ppm

Cartridge Information

Toner Cartridge OEM Part Number (Code)	XE: 6R916
.....	P8: 106R364
Toner Cartridge List/Wholesale Price*.....	XE: \$180/\$100
.....	P8: \$120/\$80
OEM Rated Page Yield.....	3,000 pages @ 5% coverage
Toner Weight	80 grams
Toner Class.....	Non-magnetic, mono-component

Drum Cartridge OEM Part Number (Code).....	13R553 (Xerox®)
Drum Cartridge List/Wholesale Price*	\$165/\$136
OEM Rated Page Yield.....	20,000 pages @ 5% coverage

Belt Unit OEM Part Number (Code)	1710193-001
Unit List/Wholesale Price*	\$269/\$285
OEM Rated Page Yield.....	12,500 pages

*Prices as of April 2000

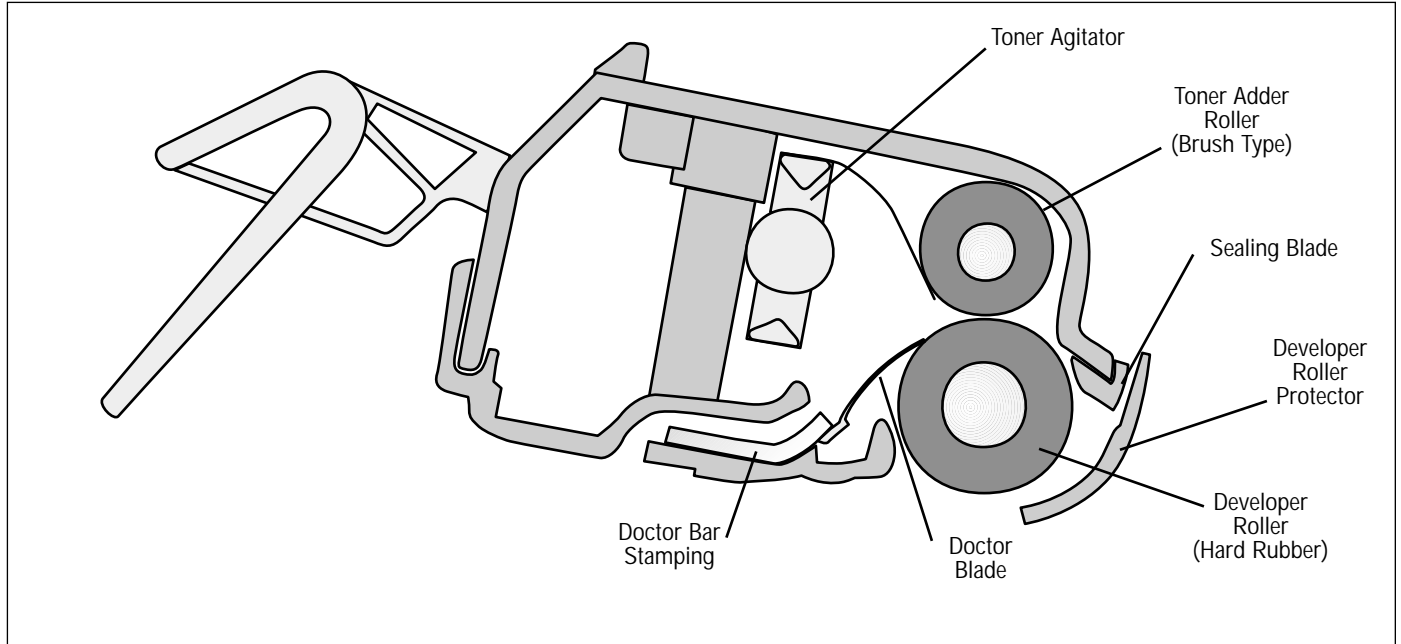
Model Compatibility

Xerox® WorkCentre XE 60/62/80/82/84/90fx, Xerox® DocuPrint® P8, Sharp® AL-800/840/841 copier/printer, Sharp® FO-2600/2800/3800 fax, Samsung® MSYS 5150 printer

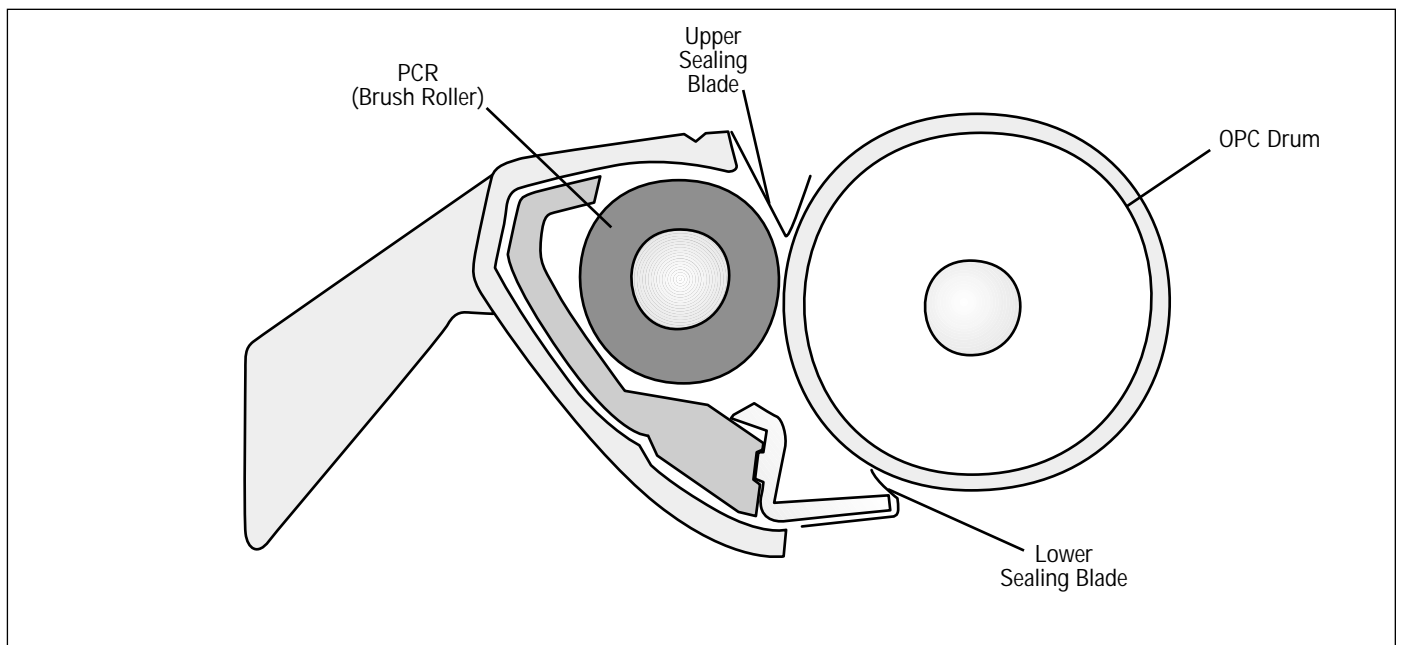
*External variations between cartridges may affect compatibility.



Toner Unit



Drum Unit



About the Cartridge, continued

Key Points

- There are several small loose parts that tend to fall out of both the toner and drum units during remanufacturing. All of these components are critical to the operation of the cartridge.
 - The toner adder roller is sponge-type design
 - The developer roller is made of hard rubber
 - Drum units are compatible with both P8 and XE machines

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.

Tools and Supplies You Will Need

For Basic Remanufacturing:

- Hooked End Metal ToolHTOOL
- Xerox® XE / Xerox® P8 toner, 80g bottle XE80B
- Wooden Handled Cleaning SwabQTIP
- 91-99% Isopropyl Alcohol*See below*
- Compressed Air for Cleaning*See left*
- Needlenose Pliers
- Phillips Screwdriver #2
- Standard Flat-Blade Screwdriver

Additional Items to Consider

- XE Shipping ProtectorXESHPRT

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.



Disassembly of the Toner Unit

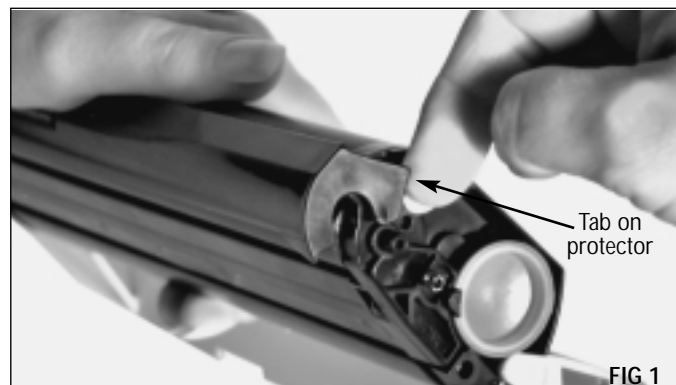
NOTE Both the XE and P8 toner cartridges have several small components that can fall out of the unit during disassembly. Be sure to read each step thoroughly before beginning the process.

1. Remove the developer roller protector

NOTE There is a small tension spring on the drive gear end that can pop off during removal of the developer roller protector. To avoid loss of this spring, remove the protector by the hopper cap end first.

With the hopper cap end up, and the developer roller protector in the closed position, grasp the cartridge around the protector. Take care not to touch the developer roller with your bare skin.

Place your finger under the tab on the developer roller protector (hopper cap end). Lift the locating peg free from the hole in the cartridge, and move the protector up and away from the cartridge (FIG 1).



While still holding the protector against the cartridge, turn the unit around so that you are looking at the drive gear end cap (FIG 2). Carefully lift the cover to free the locating peg from the cartridge, remove the spring, and set them aside.

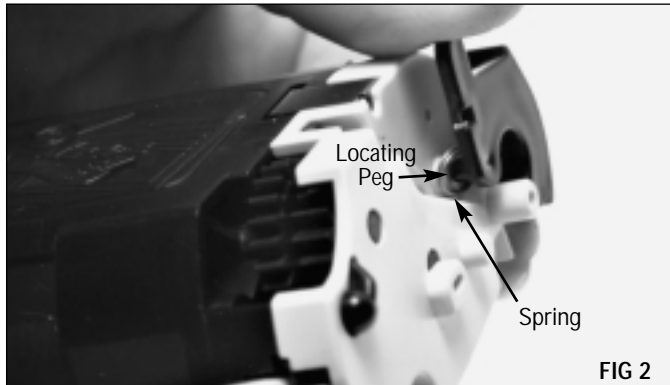


FIG 2

2. Remove the drive gear end cap and related components

Using a Phillips screwdriver, remove the three screws that secure the end cap (FIG 3).

DO NOT REMOVE the end cap until after reading further.

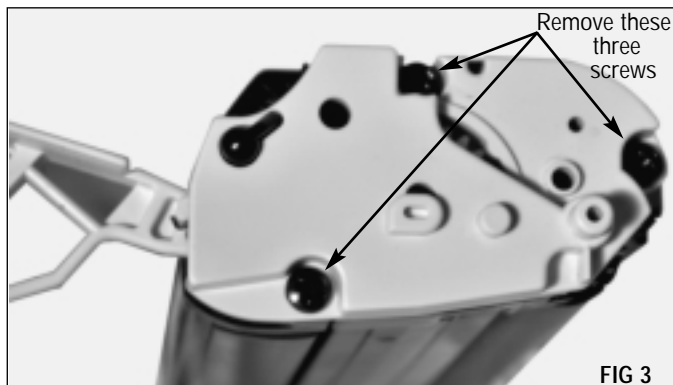


FIG 3

NOTE There are several small, loose parts located beneath the end cap. Loss of any one of these will prevent your cartridge from functioning properly. Please read and follow all steps carefully.

NOTE The handle latch sits on a tiny spring. When removing the endplate, be sure to do it slowly so that the spring and latch do not fall off and become lost.

While holding the cartridge vertical, with the end cap up, carefully remove the endplate by lifting it straight up (FIG 4).

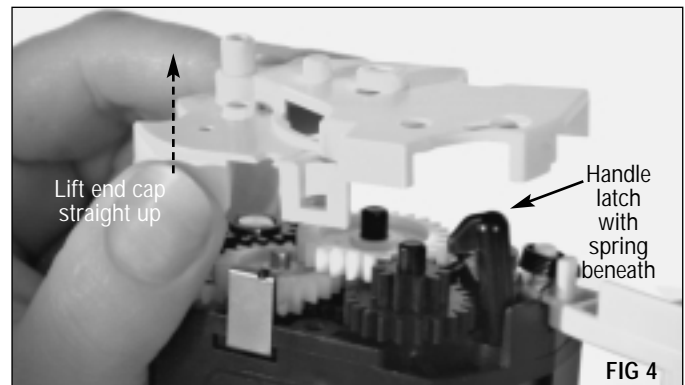


FIG 4

NOTE An electrical contact, held in place by the end cap, may fall off once the end cap is removed. Take care not to lose this contact, as your cartridge will not function without it.

Carefully remove the handle latch and spring (FIG 5). Lift the latch straight up to avoid knocking the spring out of place.

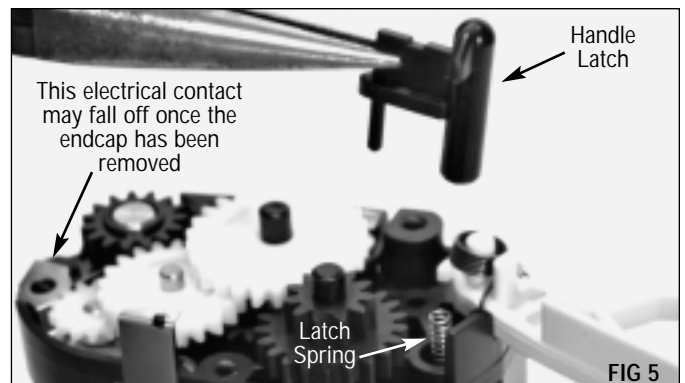
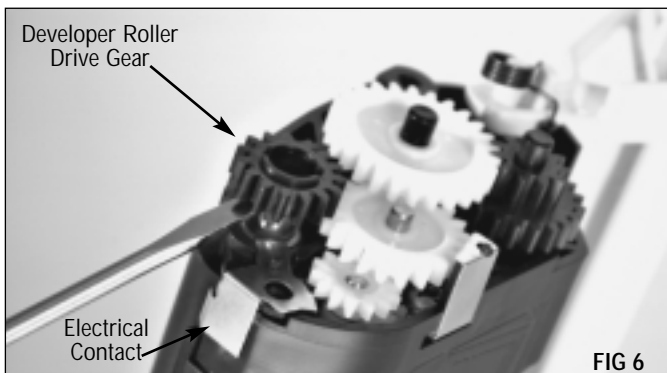


FIG 5

Remove the developer roller drive gear and set it aside (FIG 6). You may need to use a small flat blade screwdriver to loosen the gear.

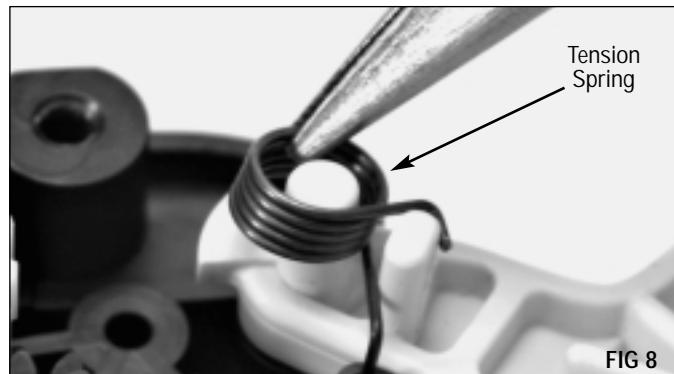


NOTE There is a small silver colored pin inserted into the developer roller axle that insures correct placement of the developer roller drive gear. This pin may fall out when the gear is removed. Take care not to misplace this pin, as your cartridge will not work properly without it.

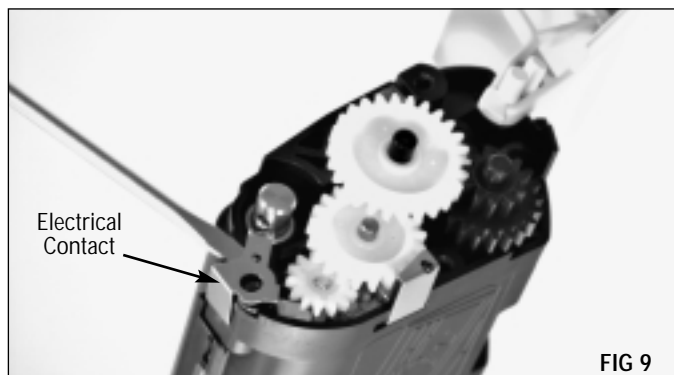
Using needlenose pliers, remove the small pin from the developer roller axle (FIG 7).



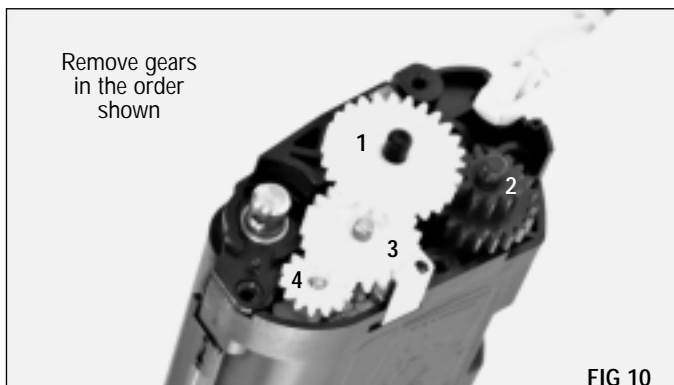
Using needlenose pliers, remove the cartridge handle tension spring (FIG 8).



Remove the electrical contact and set it aside (FIG 9). You may need to use a small flat blade screwdriver to loosen the contact.



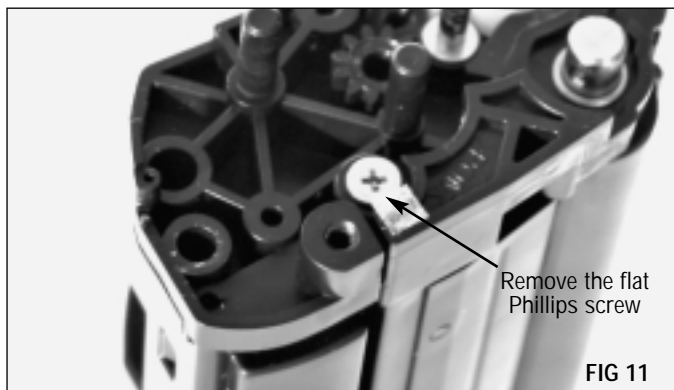
Remove the remaining drive gears in the order shown (FIG 10). You may want to place them on your work surface in the same sequence in which you removed them to make it easier to re-install them correctly.



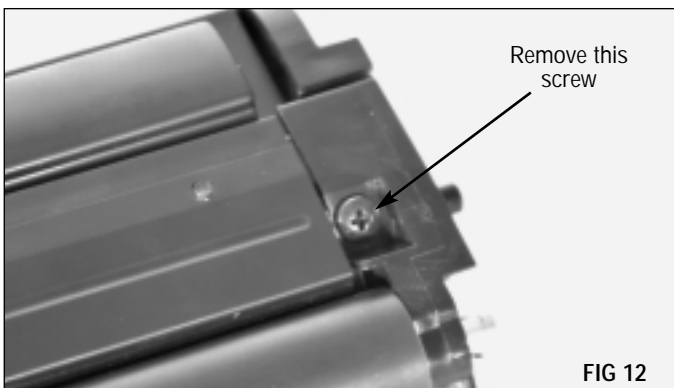
NOTE The cartridge handle has been removed for photographs. It is not necessary to remove the handle for remanufacturing purposes.

3. Remove the developer roller

Using a Phillips screwdriver, remove the brass-colored flat Phillips screw from the developer roller clip on the drive gear end of the cartridge (FIG 11).



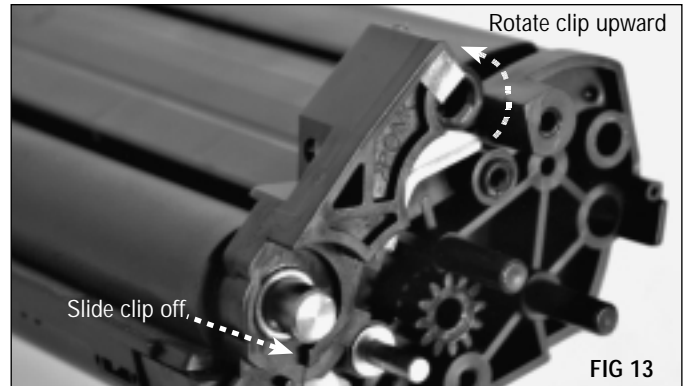
Using a Phillips screwdriver, remove the screw that secures the developer roller clip on the top of the cartridge (FIG 12).



NOTE Do not touch the developer roller with your bare fingers. Use gloves or other protective material while working near the developer roller.

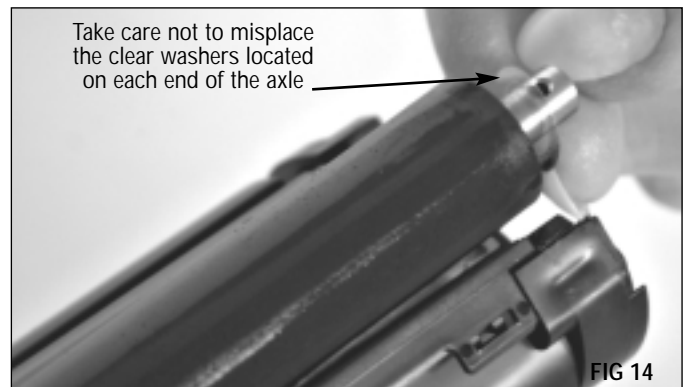
Rotate the clip upward and forward (toward you), then slide it off of the developer roller shaft (FIG 13).

If needed, use a small flat blade screwdriver to pry the clip up.



Touching only the drive gear end of the axle, carefully slide the developer roller out of the housing, grasp the axle by the hopper cap end, and lift the roller up and out of the housing (FIG 14).

Take care not to lose the plastic washer from each end. Place the developer roller on a clean lint-free cloth or other clean, soft surface.



NOTE There is a sealing foam attached to both the cartridge housing and the doctor bar stamping, which prevents removal of the doctor bar assembly. The doctor bar is left in place when cleaning the residual toner from the hopper.

4. Clean the hopper

Using a small flat blade screwdriver, gently pry up the rim of the hopper cap enough to grasp it and remove the cap from the hopper (FIG 15). If you use needlenose pliers, be careful not to distort the edges, which may result in toner leakage.

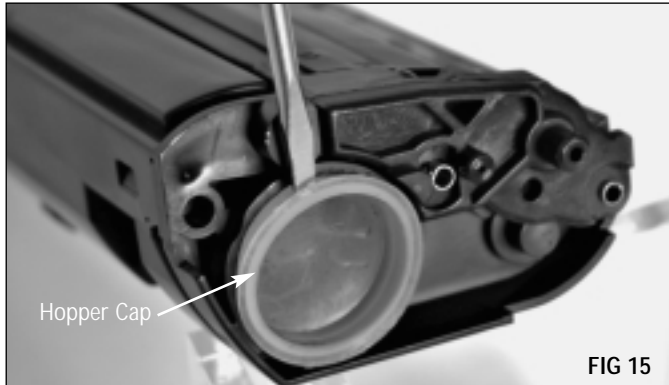


FIG 15

Dump any remaining toner from the hopper, then clean it thoroughly using dry, filtered, compressed air. Be sure to clean around the doctor bar, stamping, toner adder roller, sealing blade and toner agitator (FIG 16).

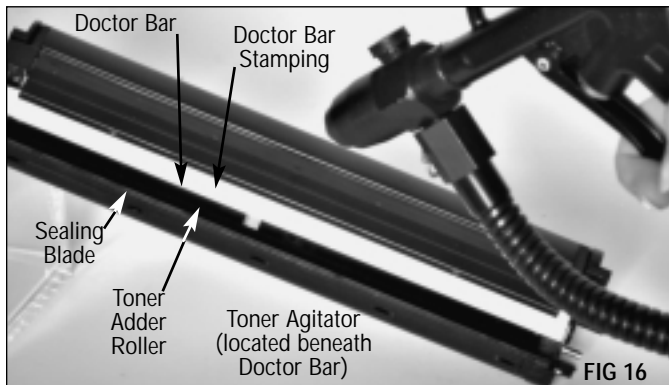


FIG 16

5. Clean the doctor bar

Using the wooden end of a Wooden Handled Cleaning Swab (QTIP), carefully remove any toner build-up from the edge of the doctor bar. Be careful not to scratch or bend the thin metal bar (FIG 17).

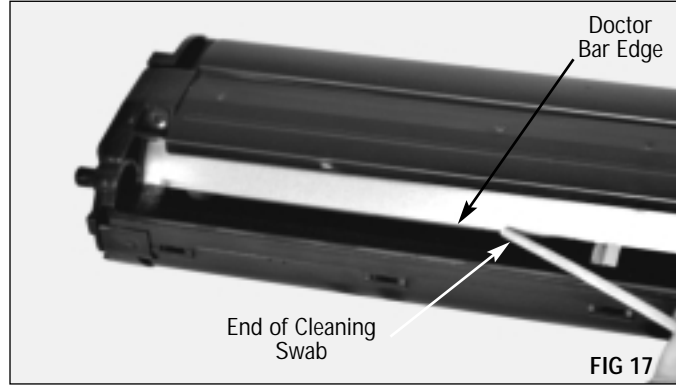


FIG 17

Using the opposite end of the cleaning swab, gently wipe any toner from the surface and underside of the doctor bar and stamping (FIG 18). Using dry, filtered, compressed air, remove any toner that may have fallen into the hopper.

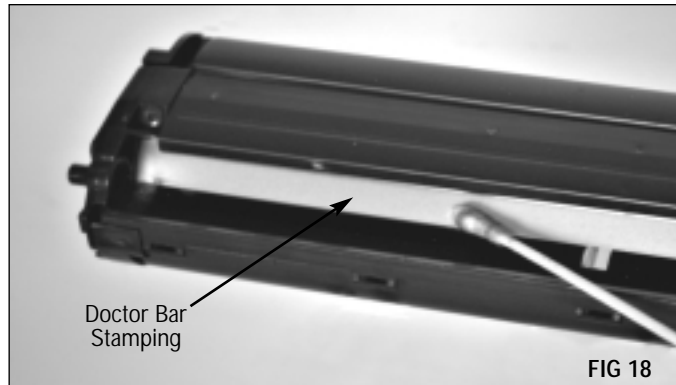


FIG 18

NOTE Build-up on the edge of the doctor bar will result in print defects. Static Control recommends thoroughly cleaning the doctor bar and the area under the stamping each time you remanufacture the cartridge.



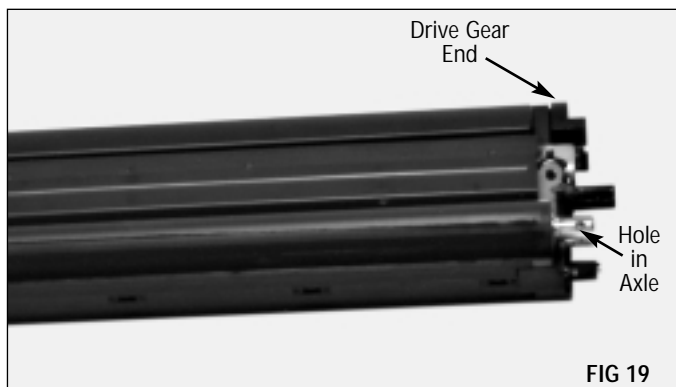
Reassembly of the Toner Unit

1. Clean and reinstall the developer roller

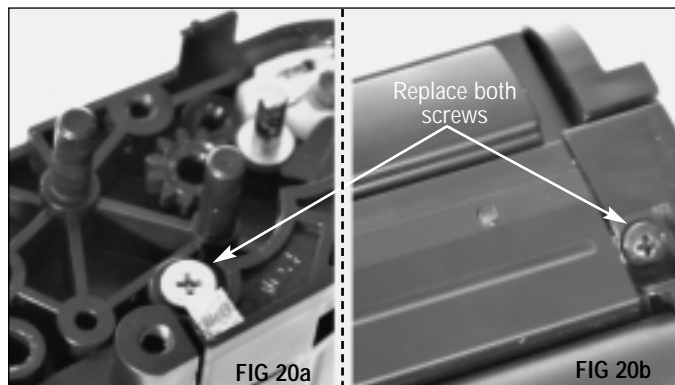
Without touching the rubber surface of the roller with your bare fingers, clean all residual toner from the developer roller using dry, filtered, compressed air. Do not use water, alcohol or other cleaning agents.

Make sure the washers are on each end of the developer roller axle before seating the roller.

Touching only the axle ends, carefully place the developer roller into the housing. The end with the small hole should be at the drive gear end of the cartridge (FIG 19).

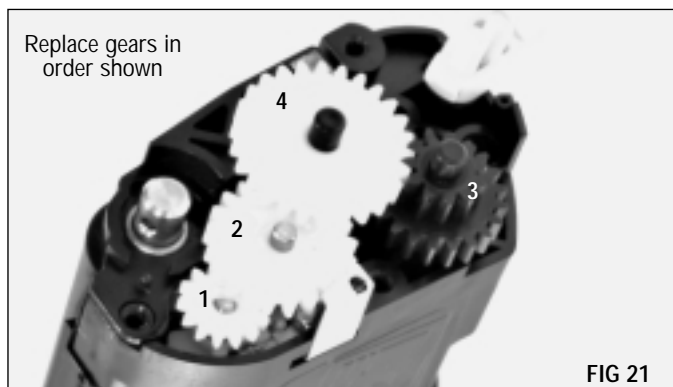


Replace developer roller clip, rotate it down, and replace both Phillips screws (FIG 20a and 20b).



2. Replace the gears and related components

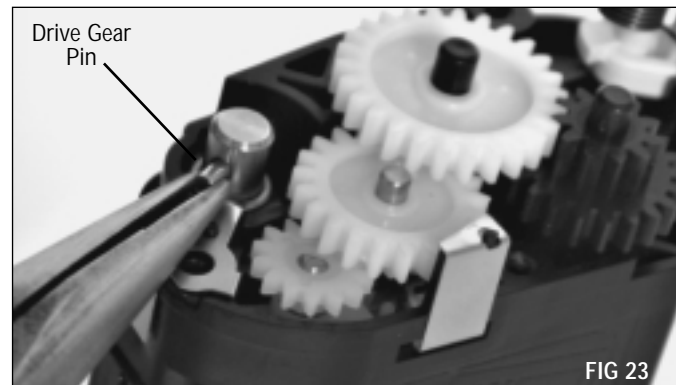
Install the gears - all but the developer roller drive gear, in the order shown (FIG 21).



Replace the electrical contact, making sure it is seated over the placement peg (FIG 22).



While holding the cartridge vertical (drive gear-end up), replace the small developer roller drive gear pin (FIG 23). You may want to use needlenose pliers to hold and guide the pin into place.



The drive gear is keyed to fit over the drive gear pin. Small indentations in the top of the gear are perpendicular to the keyed area on the gear's underside to help with proper placement (FIG 24). Press the gear into place.

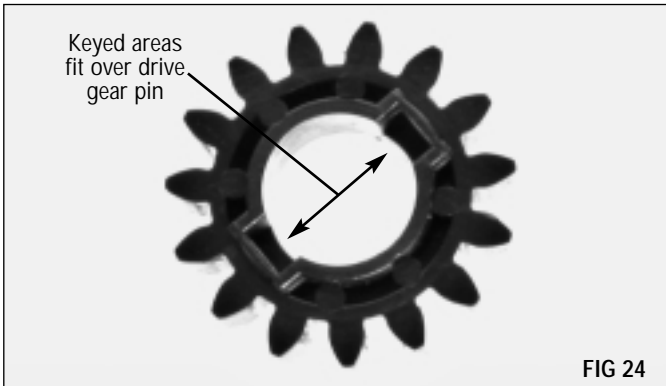


FIG 24

Keeping the unit vertical, place the handle latch spring into position, then slip the latch over the spring (FIG 25). Make sure the placement peg is seated in the corresponding hole in the housing.

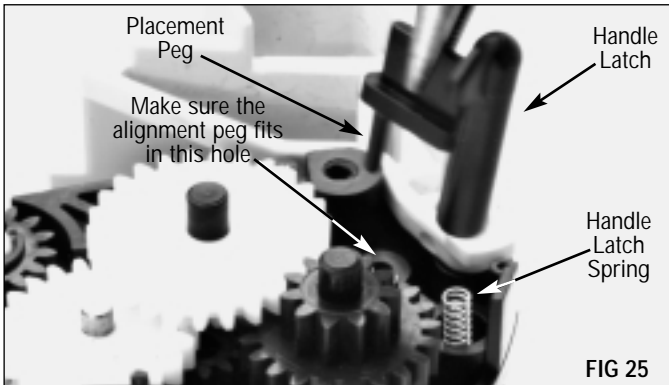


FIG 25

While holding the latch in place, fold the handle down to the point where it holds the latch in place. Seat the brown colored spring over the peg, making sure the straight end is inserted into the correct hole in the housing (FIG 26).

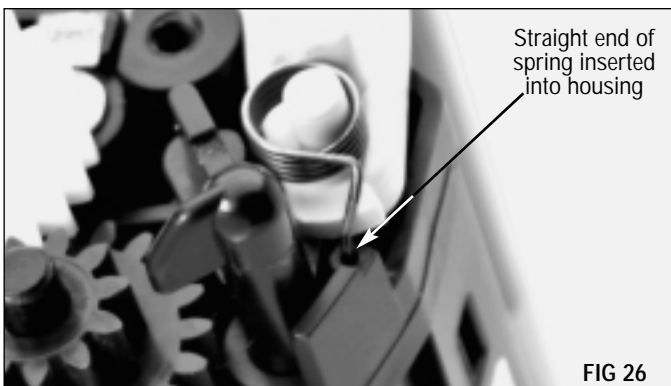


FIG 26

Again, while holding the latch in place, move the handle to the full open position. Using a hook tool, pull the end of the spring around the peg on the handle, locking the spring into place (FIG 27).

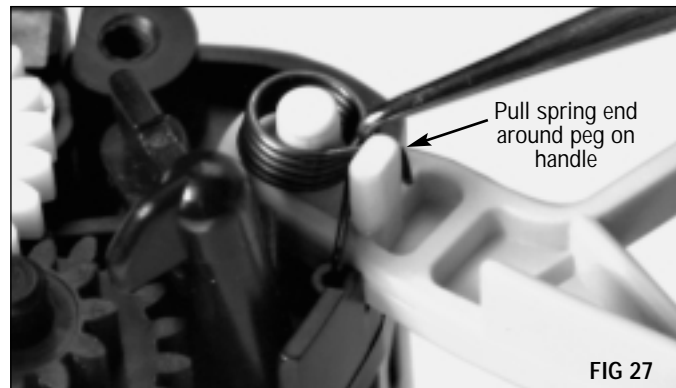


FIG 27

Slip the end cap over the handle latch and into place and secure with three Phillips screws (FIG 28).

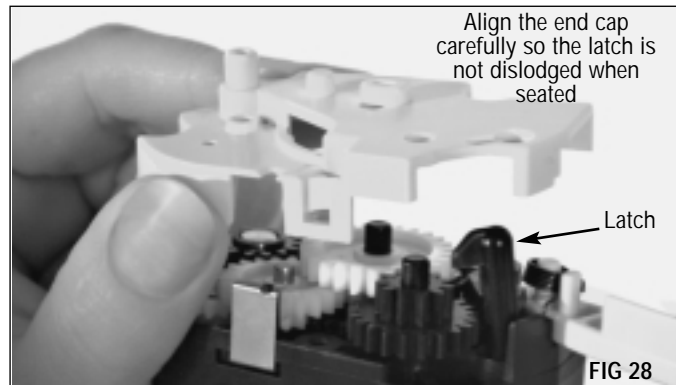


FIG 28

Check to make sure that the handle and latch work properly.

5. Replace the developer roller protector

Place the spring over the raised hub in the end cap. Make sure the straight end of the spring is seated in the small rectangular opening in the end cap (FIG 29).

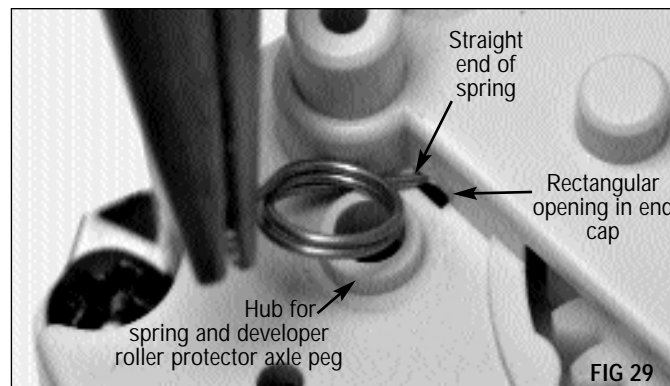
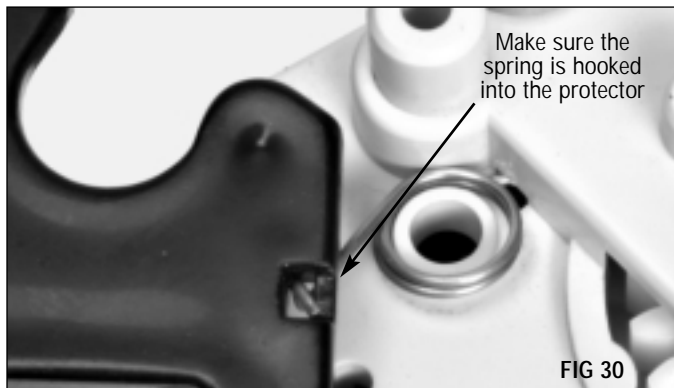
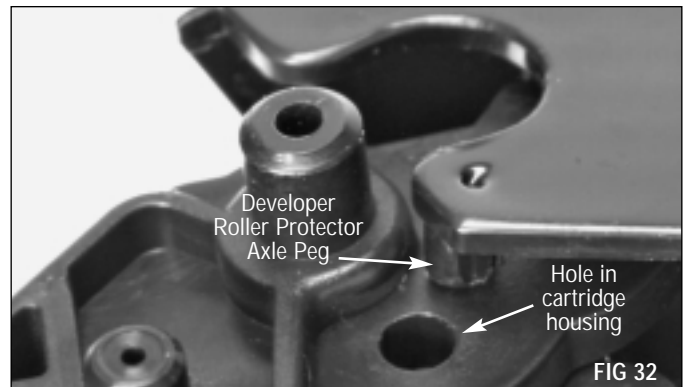


FIG 29

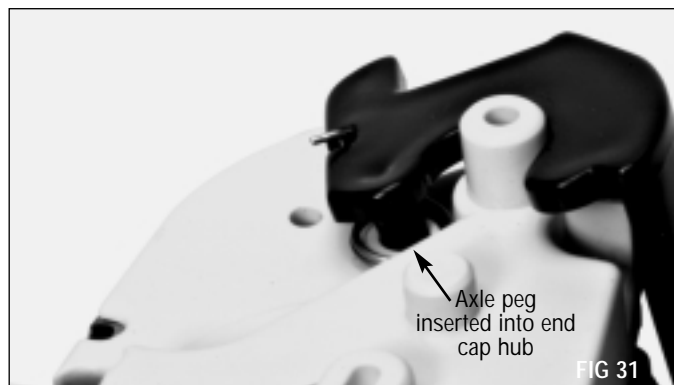
Hold the cartridge with the hopper cap end down, to allow gravity to help keep the spring in place. Slip the developer roller protector over the hooked end of the spring, making sure the spring is secure in the rectangular hole in the protector (FIG 30).



While holding the protector in place with one hand, turn the cartridge over and place the axle peg into the hole in the cartridge housing on the hopper cap end of the cartridge (FIG 32).



Slowly ease the axle peg into the corresponding hole in the developer roller protector (FIG 31). Moving too fast at this point may cause the spring to pop off.



Check to make sure that the developer roller works properly. It should slide easily away from the roller and spring back into place when released.

Fill the hopper with toner and replace the hopper cap.

Static Control recommends the use of a shipping protector to guard against excessive toner leakage during storage and shipping of your XE/P8 toner cartridge. See System Support Series™ #302, "How to Install your Xerox® XE/P8 Shipping Protector" for more information.

Disassembly of the Drum Unit

NOTE There is an electrical contact inside the drum, on the drive gear end that will break off if the drum axle is not removed and replaced correctly. Read all instructions thoroughly before proceeding.

1. Remove the OPC drum

NOTE If you plan to reuse the drum, avoid handling it with your bare hands. Be sure to store it so that it is protected from light and impact damage.

Using a Phillips screwdriver, remove the single screw from the grey end cap (FIG 33).

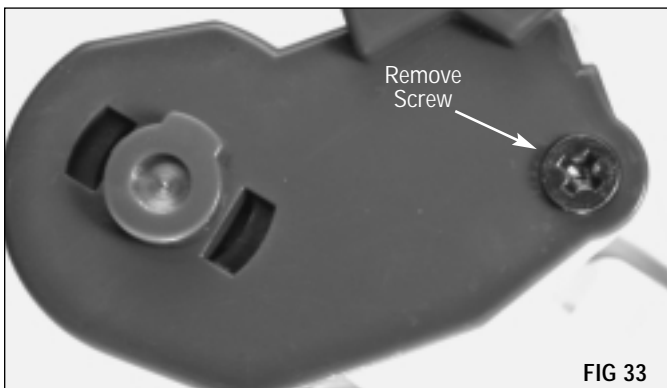


FIG 33

The end cap is keyed to lock into place on the cartridge housing. If you look into the two square holes in the end cap, you will be able to see when the key is lined up for removal of the cap. Note the differences in the alignment in FIG 33 above, and FIG 34 below.

Rotate the end cap until the key is lined up. Using a small flat blade screwdriver, gently pry the end cap up (FIG 34). **Do not** pull the end cap off at this point.

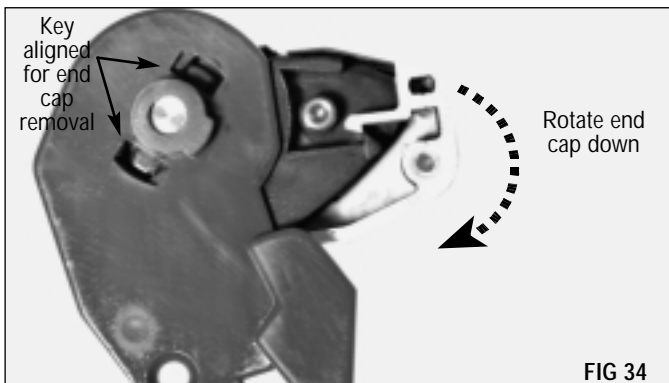


FIG 34

NOTE The drum axle is firmly seated in the grey end cap and will remain attached when the end cap is removed, once the drive gear end locking tab has been released.

Using a small flat blade screwdriver, press the drum axle locking tab to release the drum axle (FIG 35).

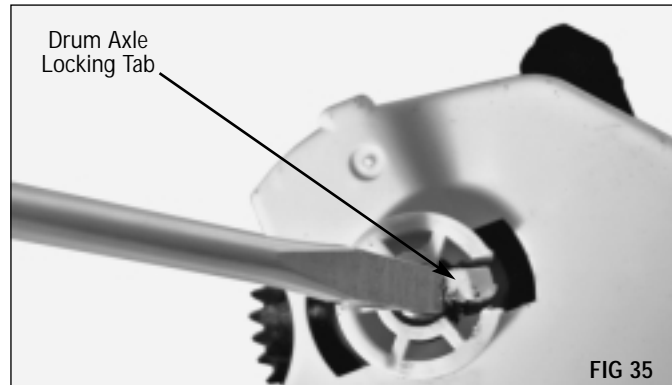


FIG 35

With the axle attached, slide the grey end cap off of the cartridge and out of the drum (FIG 36).

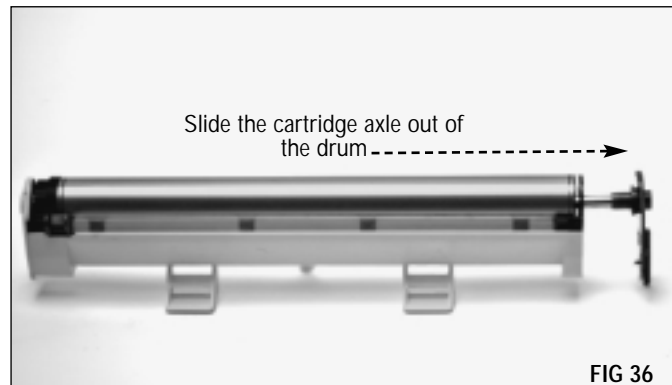


FIG 36

Lift the drum up and slide it off the molded axle hub on the drive gear end cap (FIG 37).

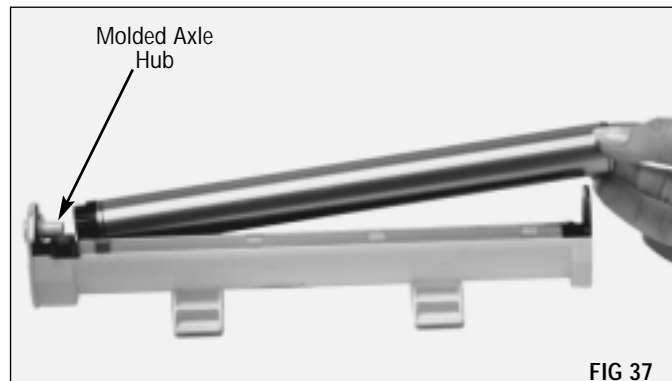


FIG 37

2. Remove the PCR

The drive gear end cap is also keyed to lock into place on the cartridge housing. If you look into the two square holes in the end cap, you will see when the key is lined up for removal of the cap.

Using a Phillips screwdriver, remove the single screw from the drive gear end cap (FIG 38).

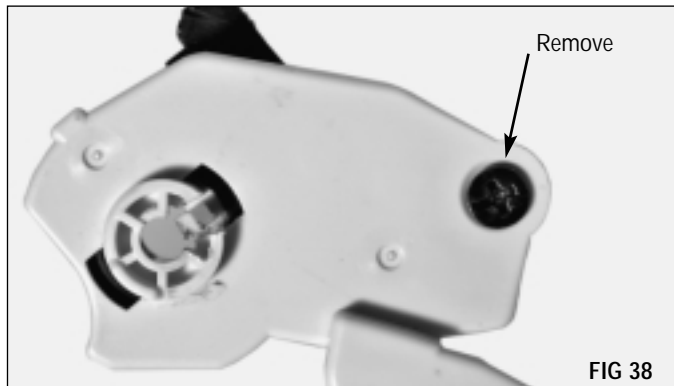


FIG 38

NOTE There are several small gears that may fall out of the housing when the end cap is removed.

While gently pulling up on the end cap, rotate the end cap until the key is lined up (FIG 39). Remove the end cap and set it aside.

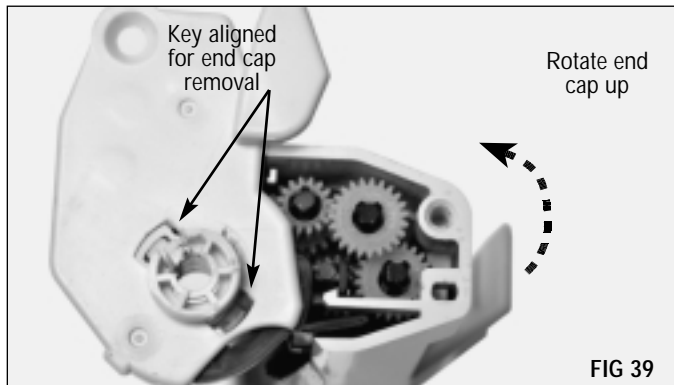


FIG 39

Lift the PCR assembly out of the drum unit housing (FIG 40).

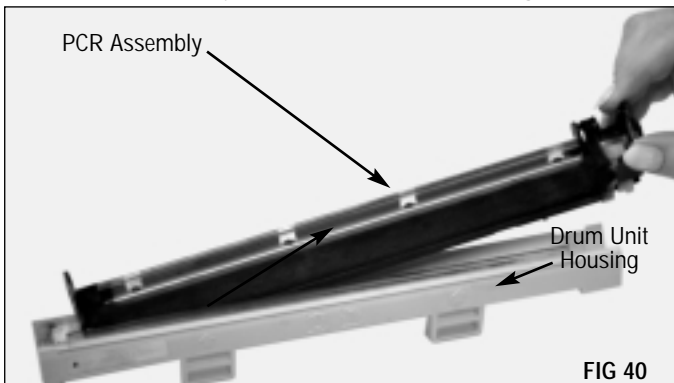


FIG 40

3. Remove the gears

Remove the gears in the order shown (FIG 41). You may want to place them on your work surface in the same sequence in which you removed them, to make it easier to re-install them correctly.

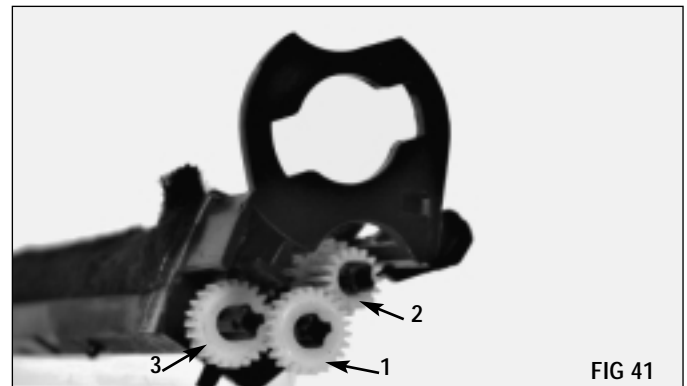


FIG 41

Carefully lift the tab with the PCR felt attached, and fold it back out of the way of the locking mechanism over the PCR shaft (FIG 42).

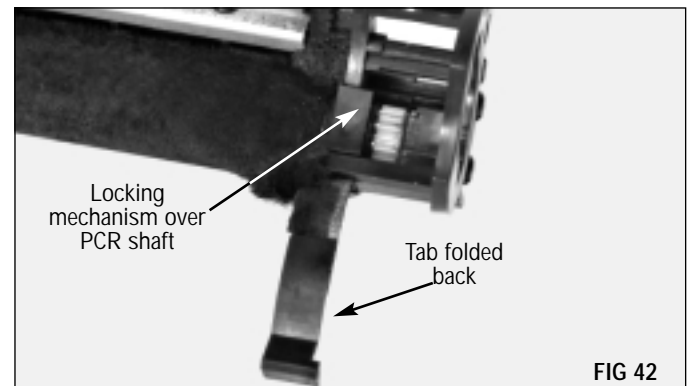


FIG 42

Release the locking tab on the bottom of the PCR assembly and push up to free the PCR (FIG 43).

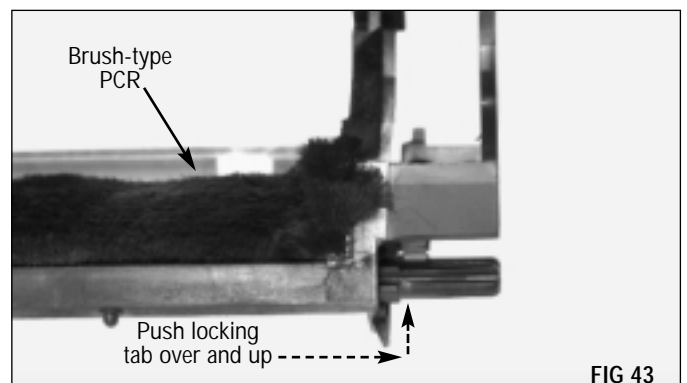
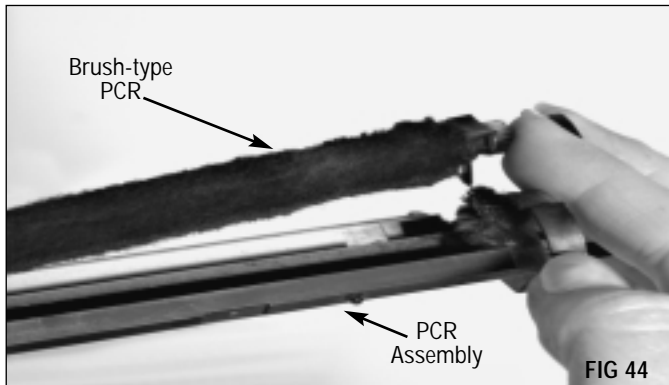


FIG 43

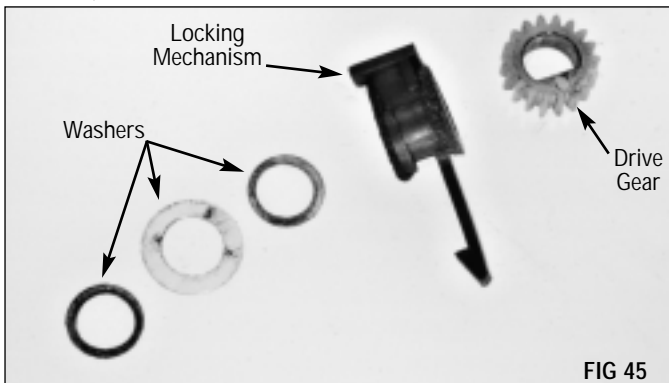
NOTE Do not stack PCRs, lay anything on top of them, wrap them with rubber bands, or touch the surface of the PCR with your bare fingers.

NOTE There are several small components on the end of the PCR shaft that could be easily lost when the PCR is removed from the assembly.

Lift the PCR out of the assembly by the drive gear (FIG 44).



Remove the drive gear, washers and locking mechanism assembly (FIG 45).



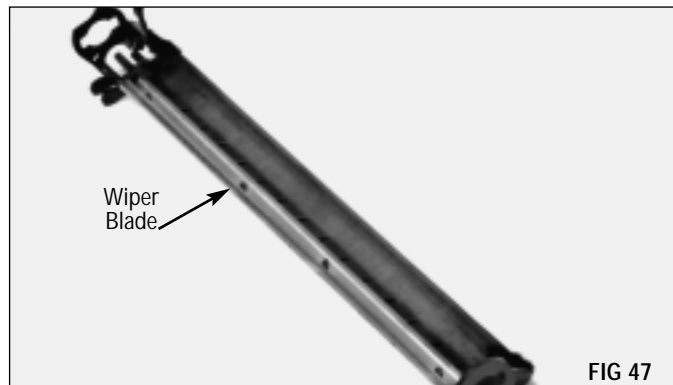
4. Clean the PCR

To clean the PCR, use dry, filtered, compressed air. (FIG 46).



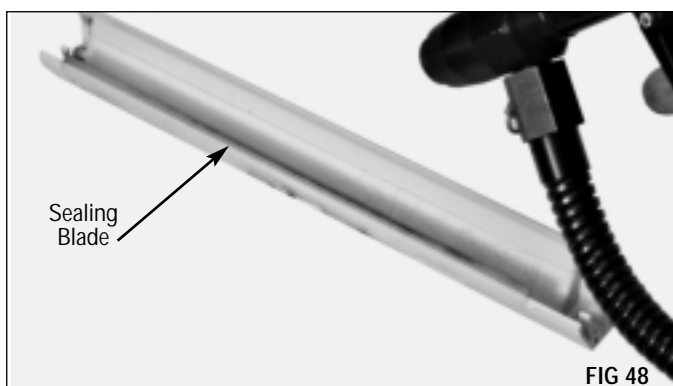
5. Clean the wiper blade assembly

Do not remove the wiper blade from the assembly. Using dry, filtered, compressed air, gently clean the assembly, paying particular attention to the areas around the wiper blade and end foams (FIG 47).



6. Clean the drum cartridge housing

Using dry, filtered, compressed air, clean the housing, paying special attention to the areas around the sealing blade (FIG 48).



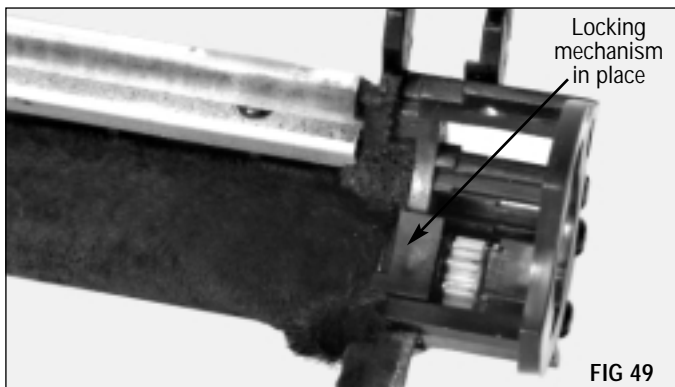


Reassembly of the Drum Unit

1. Replace the PCR

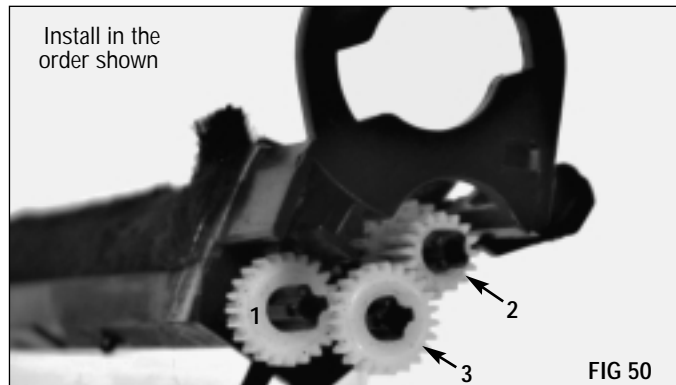
Since the XE uses a brush-type PCR there is no need to pad the drum with lubricating powder.

Replace the locking mechanism, washers and drive gear on the PCR shaft. Position the locking mechanism so that it will fit through the assembly, press and lock into place (FIG 49).



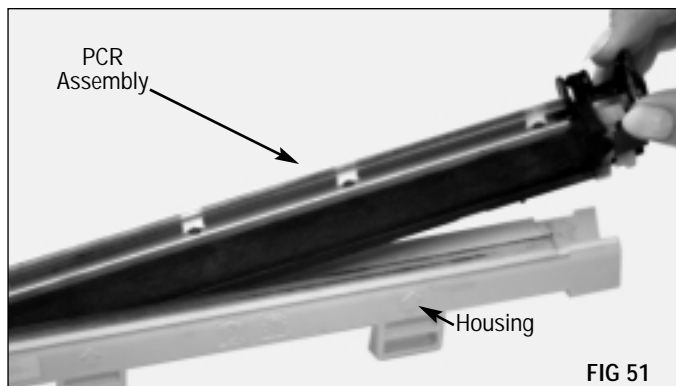
2. Replace the gears

Install the gears in the order shown (FIG 50).



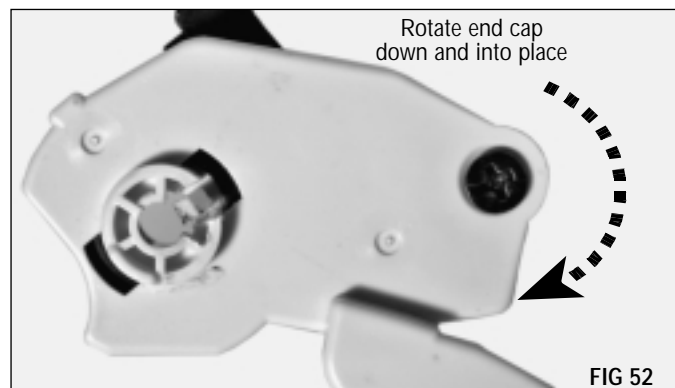
3. Install the PCR Assembly

Place the PCR assembly into the cartridge housing. Be sure not to distort the sealing blade as you seat the assembly (FIG 51).

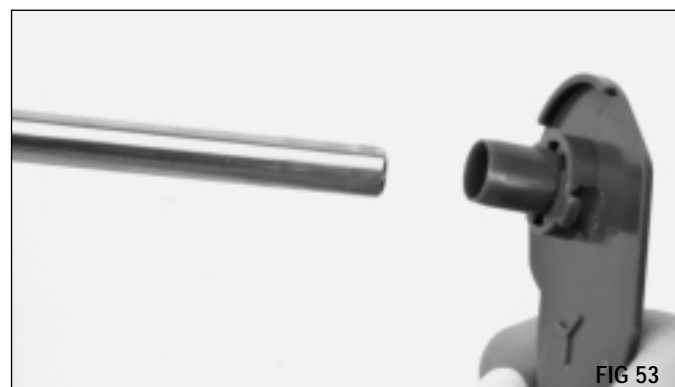


4. Install the OPC axle, drum and end caps

Align the drive gear end cap key, rotate and seat the end cap. Secure with one Phillips screw (FIG 52).



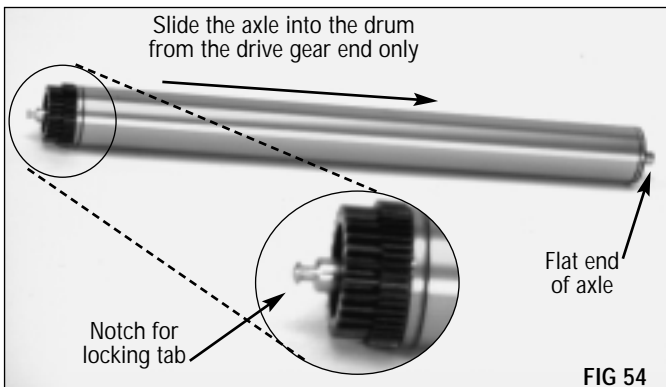
Carefully remove the drum axle from the grey end cap by twisting the axle and pulling it out of the end cap hub (FIG 53).



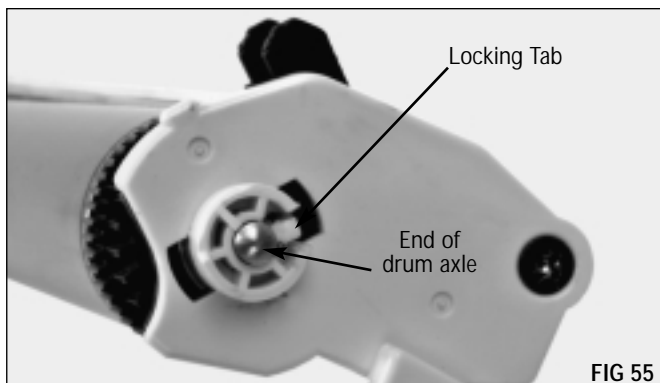
NOTE Avoid handling the drum with your bare hands. Hold it by the plastic areas on the ends of the drum.

NOTE To avoid breaking the contact inside the drum the axle must be installed from the drive gear end only.

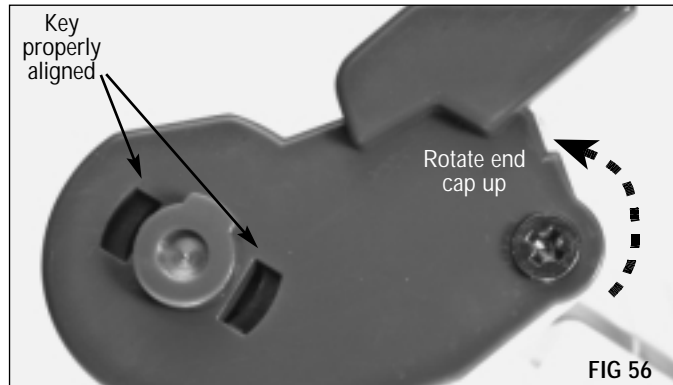
Place the axle into the drive gear end of the drum and carefully slide it into place (FIG 54). Make sure the flat end is on the opposite end of the drum.



Insert the axle into the drive gear end cap, making sure the locking tab is activated (FIG 55). Seat the drum into position in the assembly.



Position the hub on the grey end cap over the drum axle and press it into place. Align the grey end cap key, rotate and seat the end cap. Secure with one Phillips screw (FIG 56).



Be sure to store the drum unit where it will be protected from light and impact damage.



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