

# XEROX® WORKCENTRE PE120

## TONER CARTRIDGE REMANUFACTURING INSTRUCTIONS



XEROX WORKCENTRE PE120 TONER CARTRIDGE

# REMANUFACTURING THE XEROX WORKCENTRE PE120 TONER CARTRIDGE

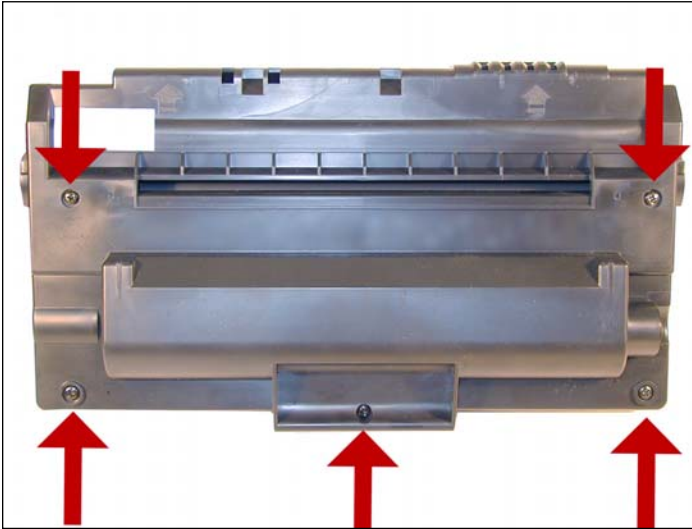
By the Technical Staff at UniNet

## REQUIRED TOOLS

1. Toner approved vacuum
2. A small common screwdriver
3. A Phillips head screwdriver
4. Needle nose pliers

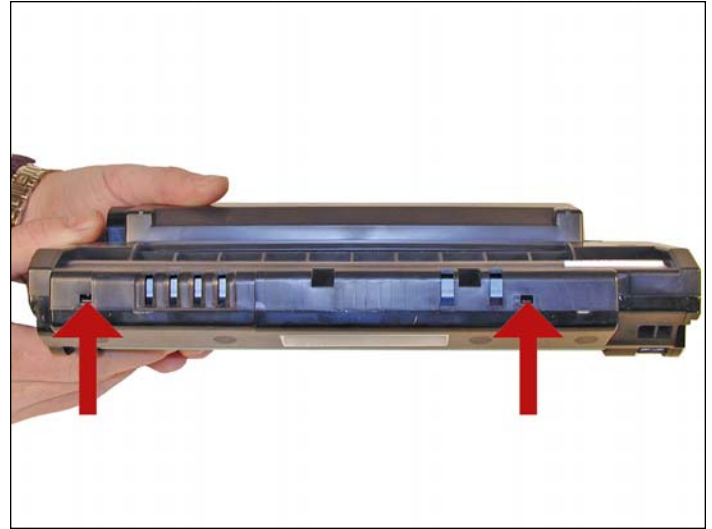
## REQUIRED SUPPLIES

1. Xerox WorkCentre PE120 toner
2. Conductive grease
3. Drum lubricating powder



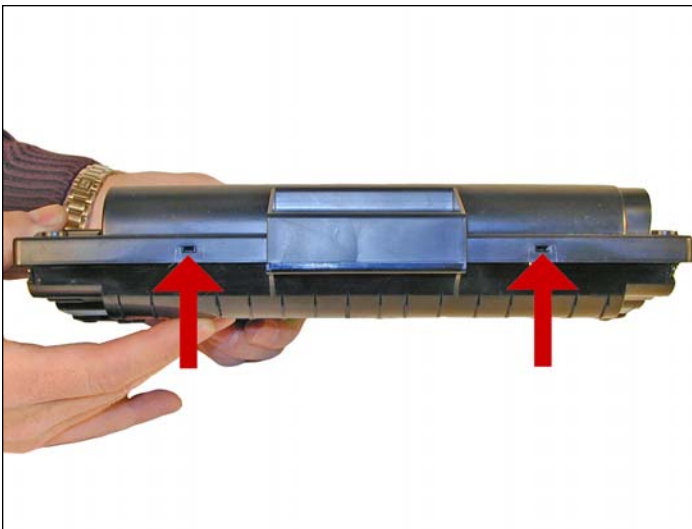
1. Place the cartridge with the handle facing up.

Remove the five top cover screws.

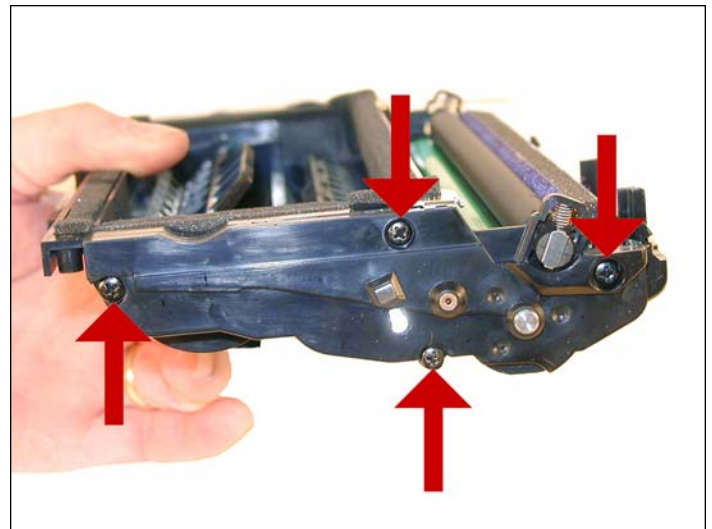


2. On the front edge of the cartridge, there are two tabs.

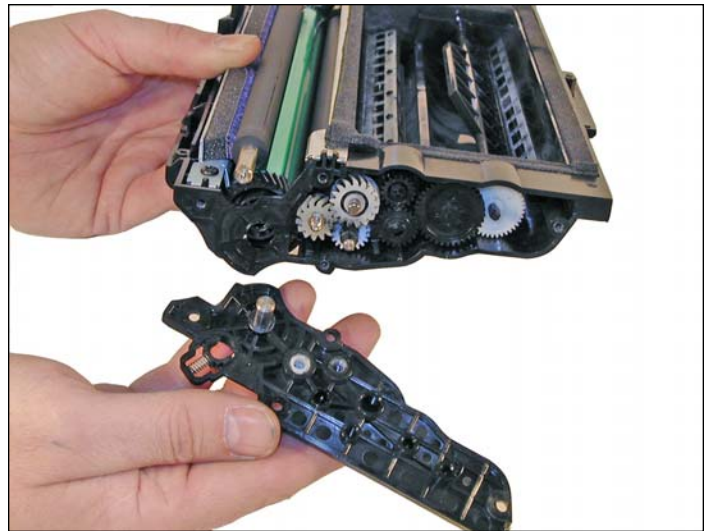
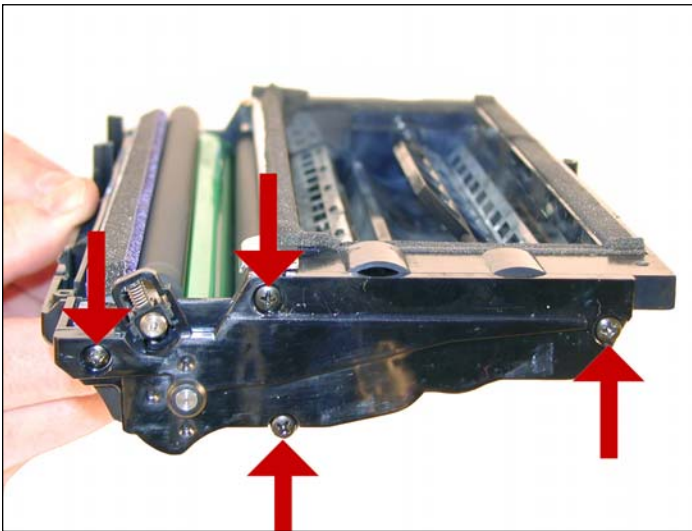
Press the two tabs in and lift the front edge of the cover up.



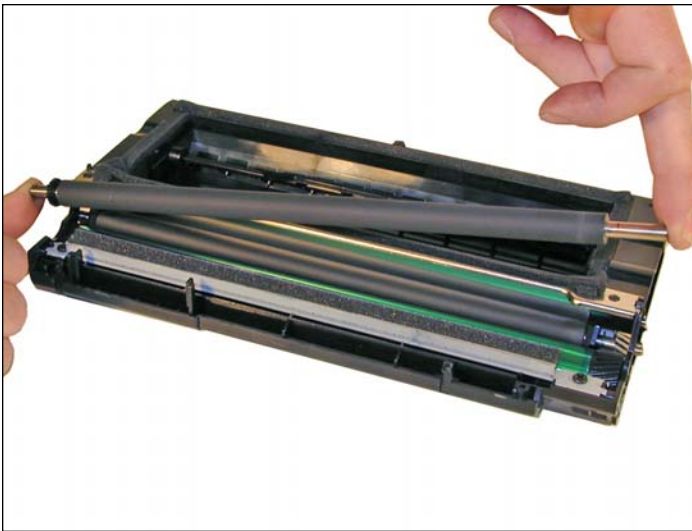
3. Next to the handle of the cartridge to the right and left, there are two more plastic tabs. GENTLY press them in, and remove the cover. **CAUTION:** The upper half of the toner hopper is being removed. If there is a lot of toner left in the hopper, it can dump out all over! Vacuum the hopper clean.



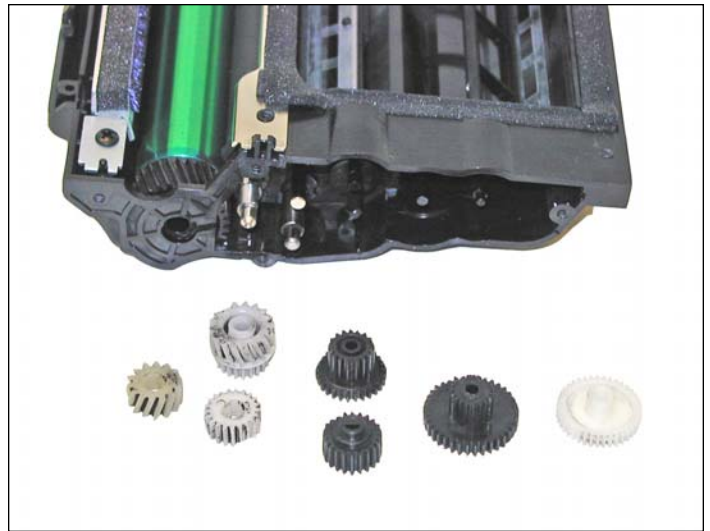
4. With the toner hopper away from you, remove the four screws on the left side end cap. Remove the end cap.



5. Remove the four screws on the right side end cap. Remove the end cap.

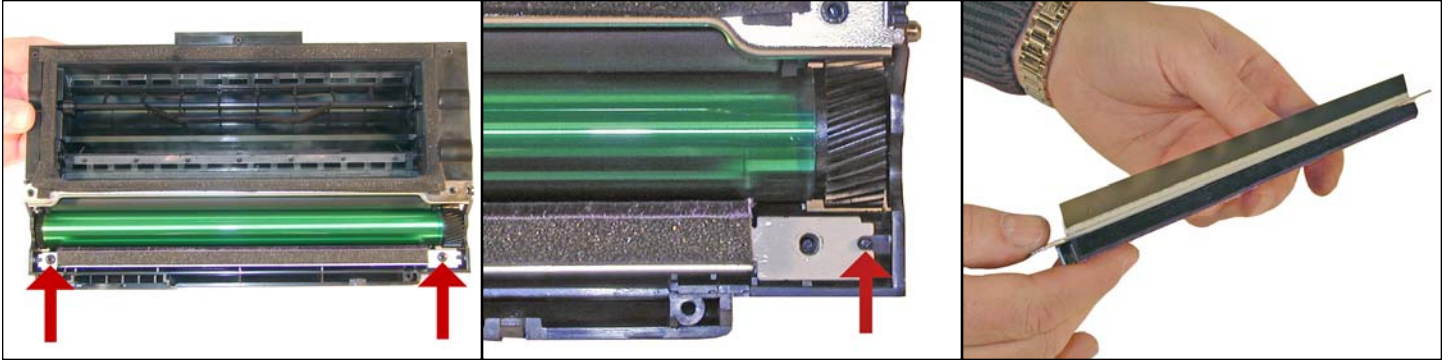


6. Remove the PCR.



7. Also on the right side there is a series of gears under the end cap. Make a note of the location of each gear, and remove them. Clean the PCR with your normal PCR cleaner.

**WARNING:** Do not clean the OEM PCR with alcohol, as this will remove the conductive coating from the roller. If the PCR is an aftermarket, follow the cleaning methods recommended by the manufacturer. If the PCR is an OEM, we recommend it be cleaned with your standard PCR cleaner.



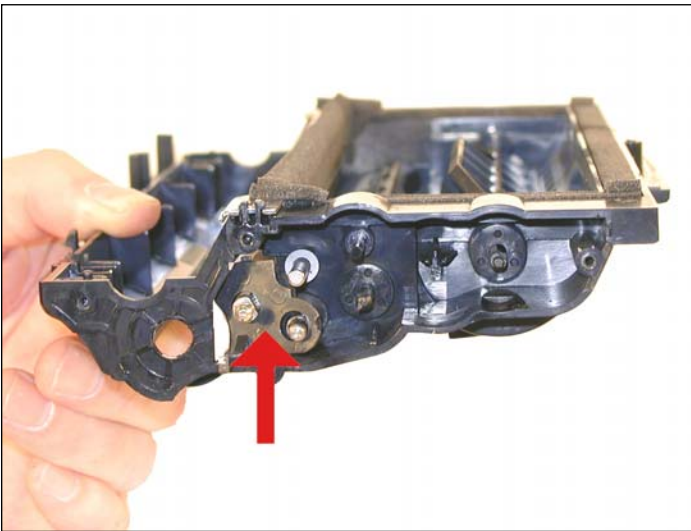
8. There are two screws on the PCR cleaner assembly. Remove them and gently pry the blade up. Be careful not to damage the alignment pins. This PCR cleaner also has what can be considered a wiper blade. It is a very flimsy blade attached to the metal bar. Wipe this blade down with a clean lint free cloth before re-installing. It is very important that the PCR cleaner be cleaned. Vacuum or blow off any residual toner from the foam/felt.



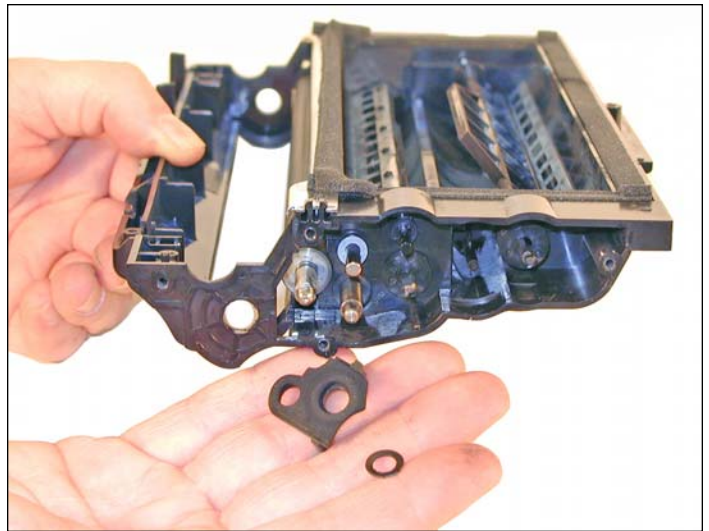
9. With the PCR cleaner assembly removed, the drum can easily be removed by lifting it out. Clean out any remaining toner from the cartridge.



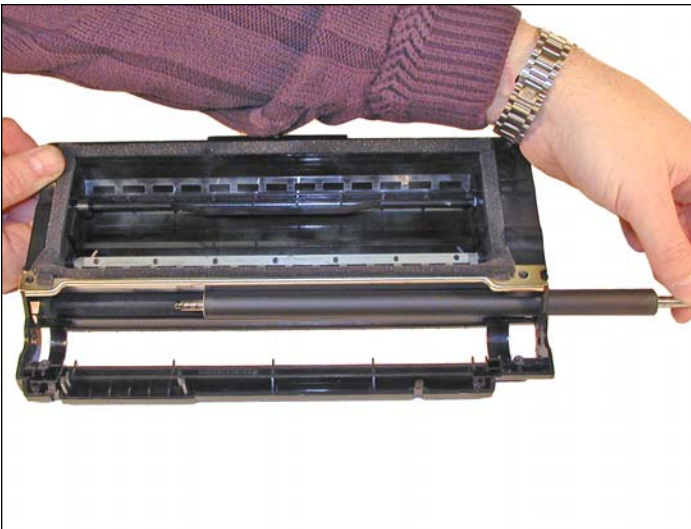
10. Press in on the bottom tab of the developer roller plate (right gear side) to release it.



11. With a small common screwdriver, press the entire plate towards the edge of the developer roller cavity, and lift up. The plate should come loose.

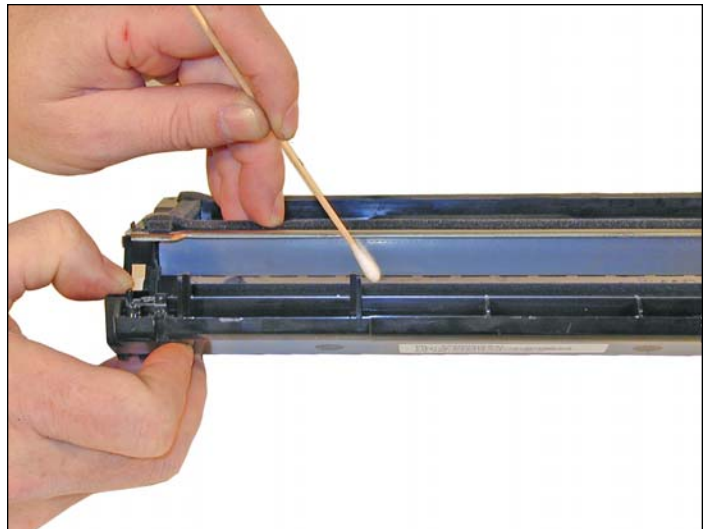


12. Gently pry out the roller plate from the cartridge. The foam seal, and possibly a plastic flat washer will come out with it. Be careful not to damage the foam seal, or loose the flat washer.

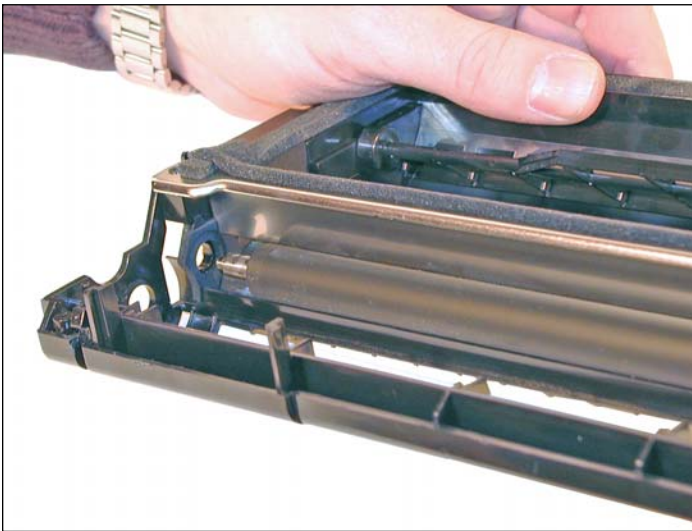


13. Remove the developer roller.

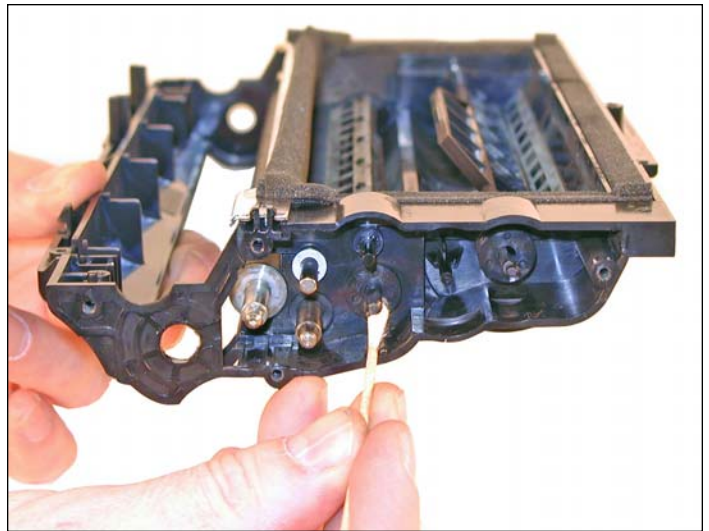
Be careful not to damage or lose the flat washers on the roller.



14. It is highly recommended that the doctor blade be cleaned. Failure to do so will cause streaking. The doctor blade can be cleaned with out removing it. Dampen a cotton swab with alcohol, and clean the blade. Be careful not to press too hard and damage the blade. If the blade has a heavy buildup of toner on it, clean it with acetone, and then alcohol. Removing the blade is difficult because of the foam seals attached. If the seals are torn, the cartridge will leak. That is why we do not recommend it. Once replacement doctor blades are available, they will have to come with replacement foam.



15. Replace the developer roller, and flat washers.

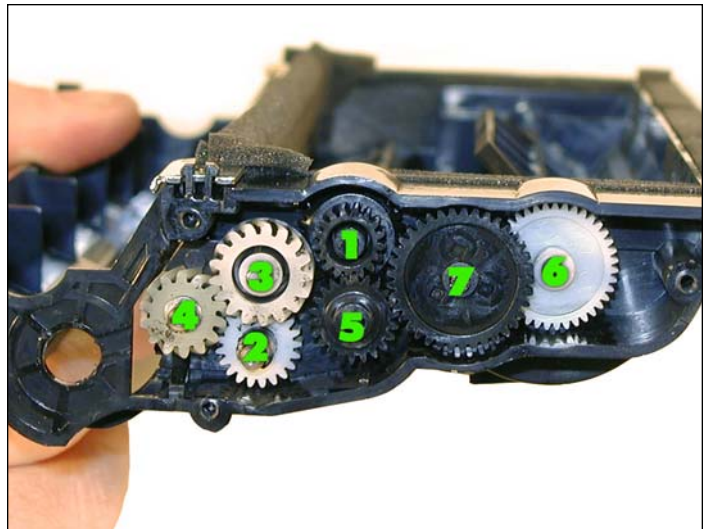


16. If no grease is left on the gears and gear shafts, or it is contaminated with toner clean it all off. Replace it with white lithium grease. Be sure to clean and grease the gear shafts, and inside the gear.



17. Install the roller plate.

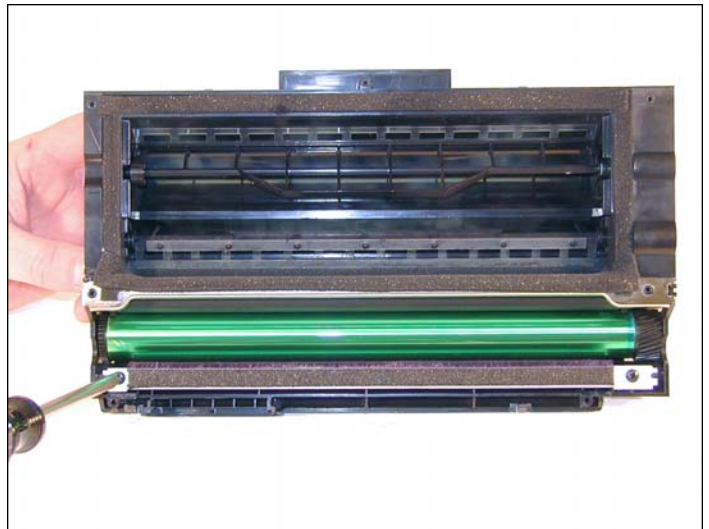
Make sure the tab is locked in place.



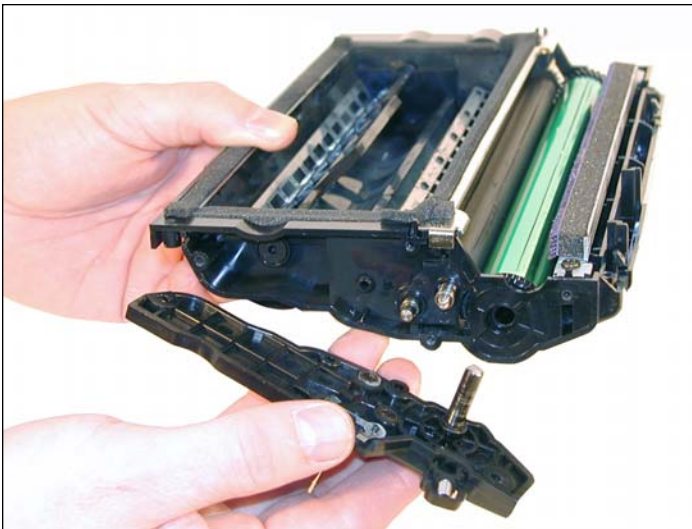
18. Replace the roller plate and seven gears. Look carefully at the picture of the gears. Each gear must fit in this exact way. The gears labeled in order of installation.



19. Install the new drum in place.



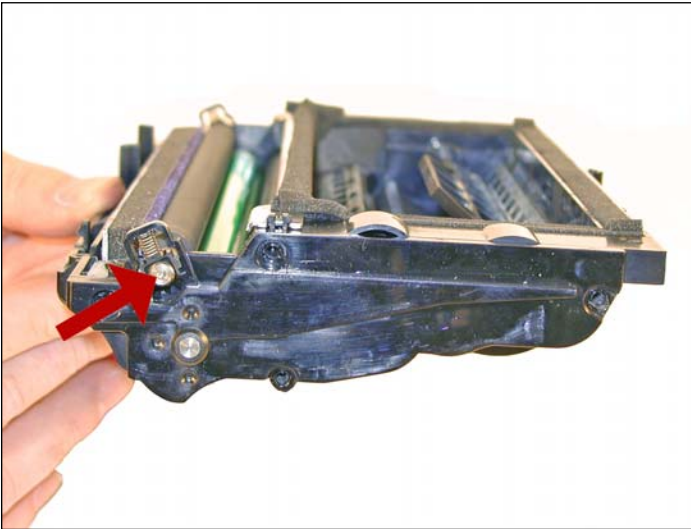
20. Install the PCR cleaner assembly.



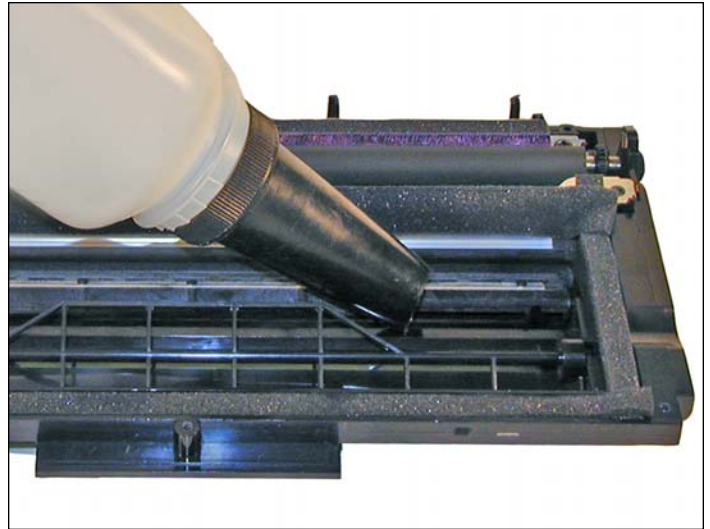
21. Clean the conductive grease off the left side (non gear) end cap and replace with fresh grease. Replace the end cap and four screws.



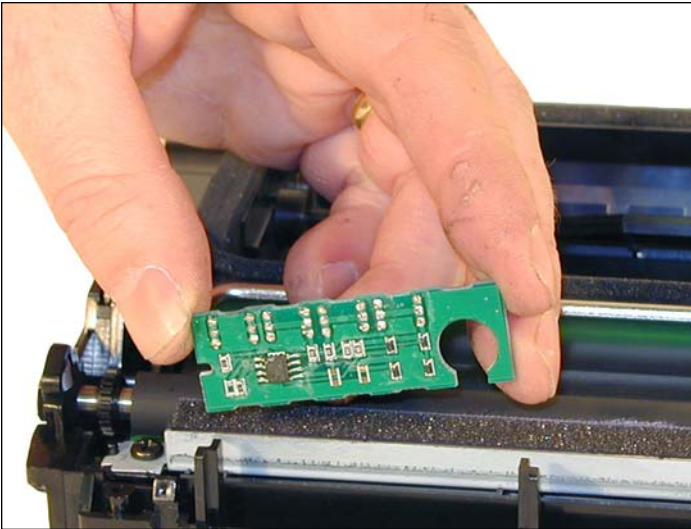
22. Install the PCR. Make sure that the PCR gear is on the correct side and that the shaft is in the PCR holder.



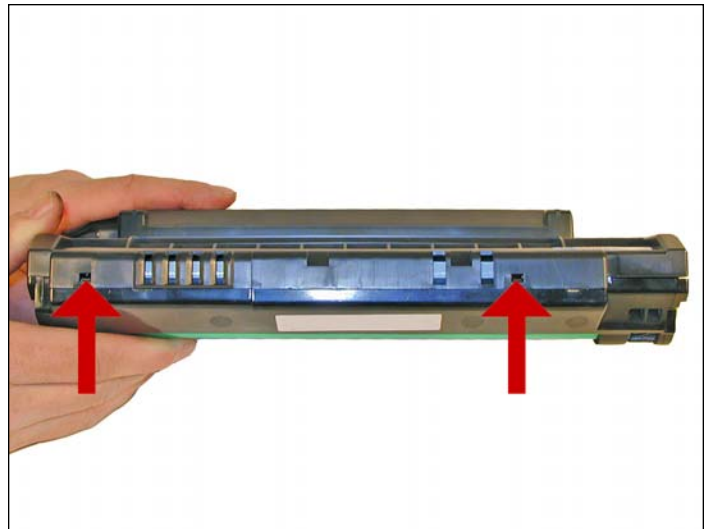
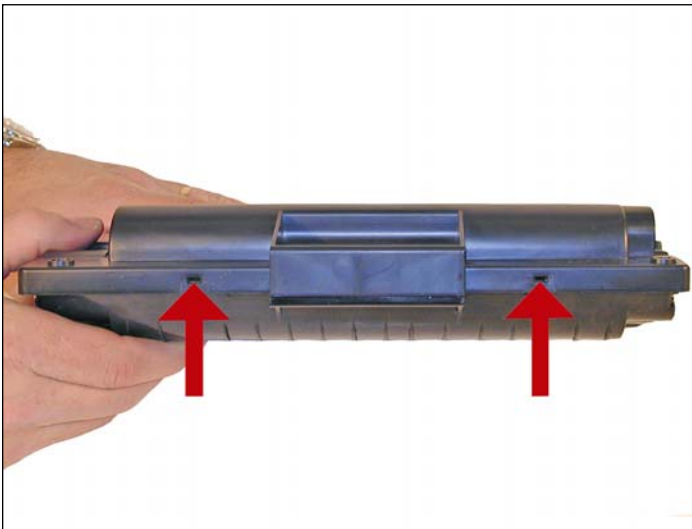
23. Install the right side end cap, and four screws. Make sure the PCR fits correctly in its holder and all the gears are aligned.



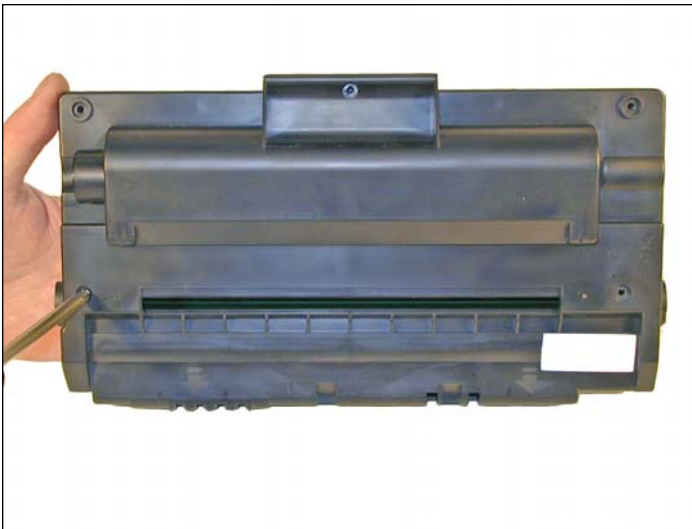
24. Fill the hopper with the appropriate amount of toner. This can also be done through the fill plug, but the fill plug tends to leak and will probably have to be sealed with silicon.



25. Replace the chip. Make sure the chip you install is the correct one for the machine it is to be installed in. New reset boxes are now available that can change the personality of the chip across the full line. This will enable you to test the cartridge in your test machine, and then change the chip to work in your customer's machine if different.



26. Carefully snap the cover on making sure all the tabs lock in place.



27. Install the five screws in the top cover.