

- **Publications**
  - Dealer Catalog #23
  - Catalog Update
- **Chips**
  - Comprehensive Chip List
  - Lexmark Chip Cross Reference
  - Reset Box Information
    - Samsung Reset Box Compatibility
    - MasterSet USB Installation Software
    - MasterSet Parallel Port Installation Software
- **Product Info**
  - Vacuums
  - Packaging
- **Technical Support**
  - Disassembly Instructions
  - Reset Guide Ver. 16
  - Cross Reference Ver. 9 Update
  - Engine Cross References
    - HP
    - Lexmark
    - Samsung
  - Common Terms & Acronyms
  - Cartscan
- **Customer Service**
  - Company Profile
  - Customer Forms
  - Non-Customer Quote
  - Join Email Group
  - International Sales
  - International Distributors
  - Terms & Conditions
  - Track Your Order
  - Contact Us
- **Go to Uninetimaging.com**

## Remanufacturing the Xerox DC-212/214 Toner Cartridge



- **Overview**
- **Supplies Required**
- **Tools Required**
- **Disassembly**
- **Checking the Percentage of Life Left in the Copy Cartridge**
- **Checking to See What Type of Cartridge a Machine is Set For**

## Remanufacturing the Xerox DC-212/214 Toner Cartridge

0327

First released in May 1998, the Xerox DC-212 series of printers are based on a 12-14ppm 600 dpi Fuji-Xerox engine. These cartridges use a non-resettable chip that must be changed each cycle. The DC-212 is rated for 12ppm, and the DC-214 is rated for 14ppm.

Xerox currently has two type cartridges available:

Type 1 113R180/113R181 Sold through Xerox dealers  
Type 5 113R285/113R287 Sold through retail stores

If the wrong type cartridge is installed, a "J8" code will be displayed. (Wrong copy cartridge) We will go over how to tell what type cartridge your machine needs, and what type cartridge is installed at the end of this article.

Both types are rated for 14,000 pages at 6% coverage, and list for \$373.00 each! While these cartridges look different from most, they are fairly simple to do, and as you can see, have very nice margins!

## SUPPLIES REQUIRED



- 820g DC-212 Toner
- New Drum (Highly recommended)
- New Wiper Blade (Highly recommended)
- New Doctor Blade
- Replacement chip
- 99% pure isopropyl alcohol
- cotton swabs
- soft, lint free wipes

## TOOLS REQUIRED



- Toner approved vacuum.
- A small Common screw driver
- A spring hook
- Needle nose pliers
- T-10 Torx bit Driver (Same size as the old CX and PC-2000)

## DISASSEMBLY



- 1) On the top of the cartridge, on either side of the handle. Remove the 2 T-10 Torx screws and the handle. See Figure's 1 & 2
- 2) On the right side of the cartridge, remove the five screws. Two or three of these may be Torx. Remove the waste chamber. The large drum axle pin will come out with the waste chamber. Put it back in loosely to keep the drum safe. See Figure 3
- 3) Vacuum the waste chamber clean
- 4) Remove the indicated screws from the Corona grid Assembly. Leave the side and front screws in! Pry the tabs from the side of the assembly, and remove it. (A spring hook works well for this). See Figure's 4 & 5

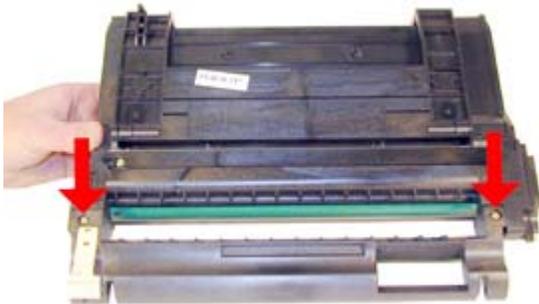


Figure 1

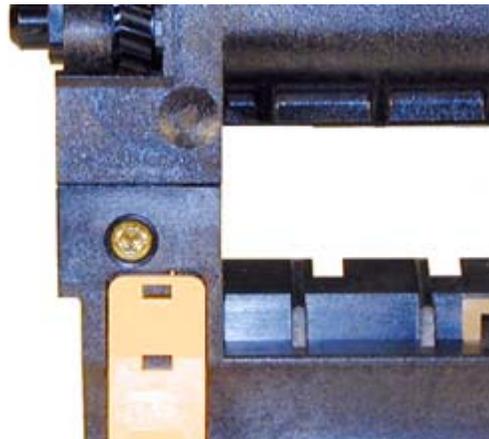


Figure 2

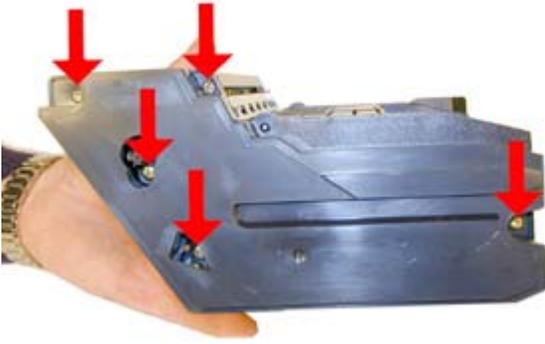


Figure 3



Figure 4

5) There are two large hinge pins, one on each side of the cartridge. Knock both pins in with a small punch or screwdriver until they are loose. Remove the supply chamber, and two pins. See Figure's 6 & 7

6) Remove the drum axle screws and pins from both sides. The large pin comes right out, the smaller has two tabs that must be pressed in before it can be removed. See Figure's 8 & 9.



Figure 5



Figure 6



Figure 7

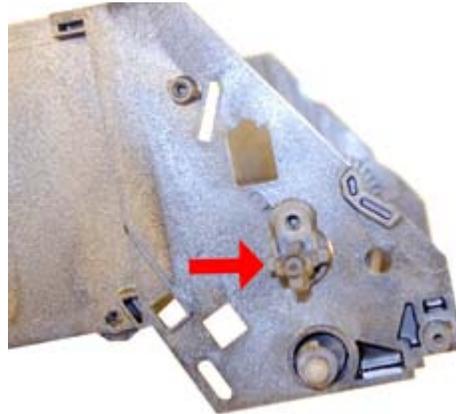


Figure 8

7) Remove the drum. See Figure 10

8) Remove the three screws on the wiper blade, and the blade. Clean out the waste chamber. The auger is locked in place by the gear and will not fall out. See Figure 11

**NOTE:** Be very careful not to damage or distort the thin Mylar Recovery Blade next to the wiper blade. If this blade is bent or damaged in any way, it should be replaced.

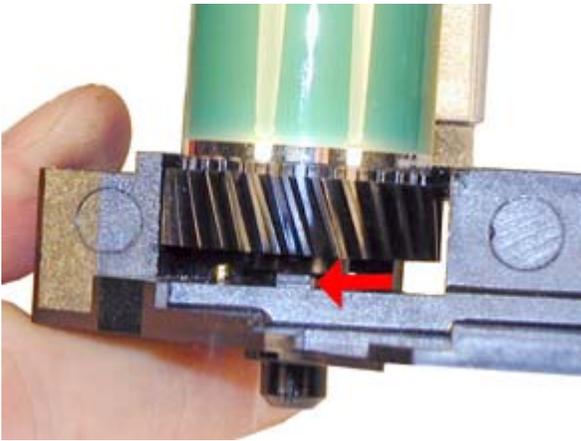


Figure 9



Figure 10

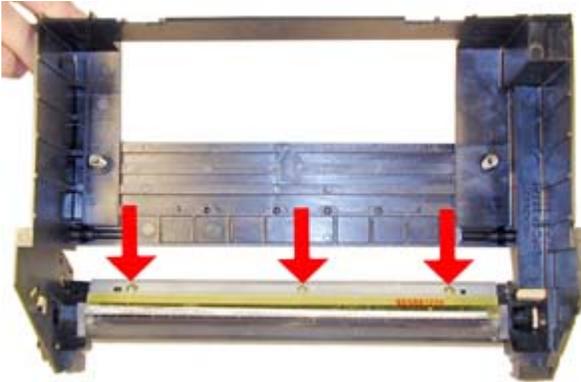


Figure 11

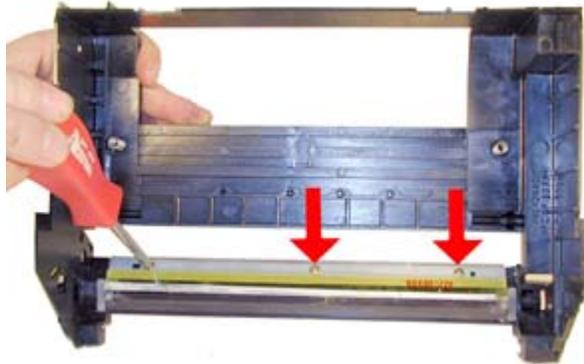


Figure 12

9) Coat the new wiper blade with your preferred lubricant, and install the wiper blade and three screws. See Figure 12

10) Remove the fill plug from the toner supply and dump/vacuum out the remaining toner. Grasp the plug by the center to avoid damaging the plug. See Figure 13

11) Remove the four screws from the gear side end cap, remove the end cap. Note the gears inside the end cap. See Figure's 14 & 15

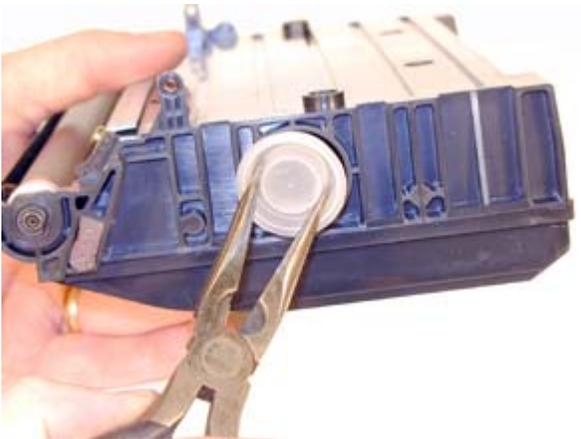


Figure 13

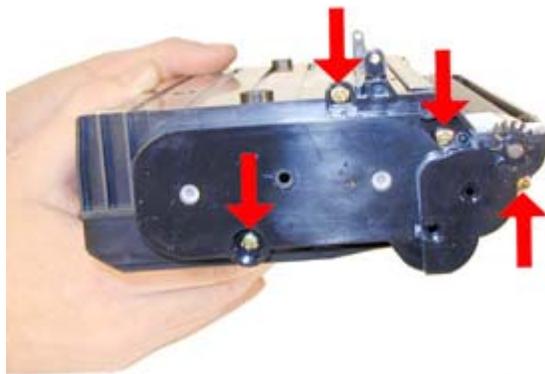


Figure 14



Figure 15



Figure 16

12) Remove the magnetic roller assembly. See Figure 16

13) Remove the two screws and doctor blade. Clean out all the remaining toner from the hopper. Scrape a screw driver across the felt seals so that they "fluff" up. See Figure's 17 & 18

14) Install the Dr. Blade and two screws. See Figure 19



Figure 17

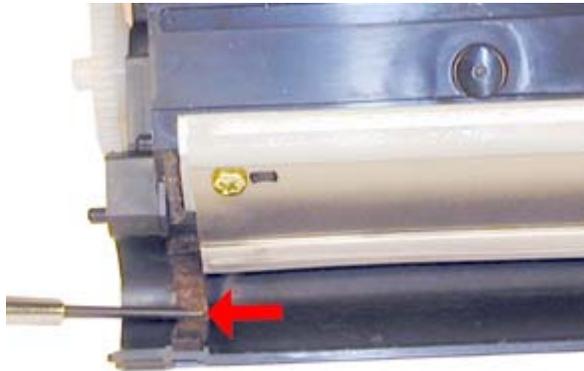


Figure 18



Figure 19



Figure 20

15) Install the magnetic roller assembly keyed end (non gear) side first. See Figure 20

16) Install the end cap. Make sure that all the gears mesh. It is easiest to spin the mag. roller drive gear while pressing in the end cap to get all the gears meshed. If the gears are not meshed properly, the end cap will not sit flush with the cartridge. Install the screws. See Figure 21

17) Fill the hopper with 820g of DC-212 toner. Check for leaks. See Figure 22

18) Place the drum in the waste chamber. Install the two axle pins, large to the non-gear side, and small to the gear side. Screw in the small axle only, leave the large pin loose. See Figure's 23 & 24



Figure 21



Figure 22

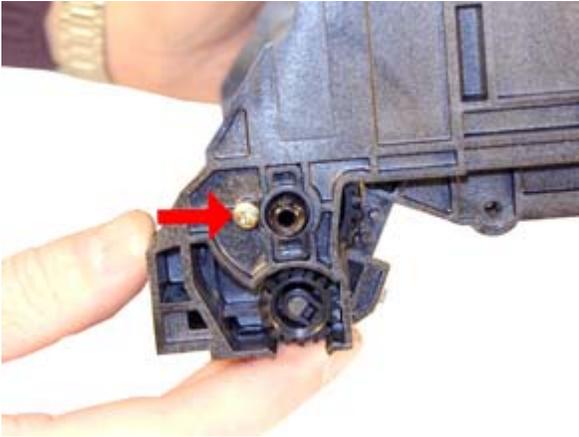


Figure 23



Figure 24

19) Install the corona wire assembly and screw. Make sure the tabs from the assembly are aligned. See Figure 25

20) Install the supply chamber and 2 pins. See Figure 26

21) Remove the large axle pin. See Figure 27

22) Install the cleaned waste chamber. See Figure 28



Figure 25

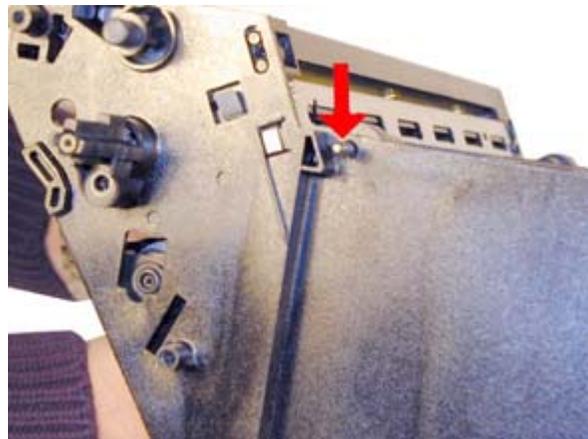


Figure 26



Figure 27



Figure 28

23) Install the large axle pin and screw. See Figure 29

24) Install the four screws on the waste chamber. (two or three of these will be Torx). See Figure 30

25) Install the handle and two Torx screws. See Figure 31

26) Remove the chip assembly from the front edge of the cartridge, and replace with a new one. See Figure 32 & 33



Figure 29

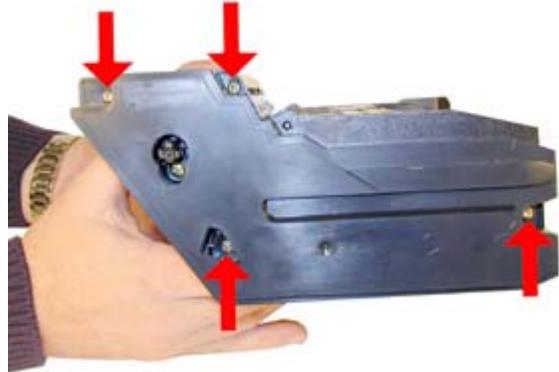


Figure 30



Figure 31

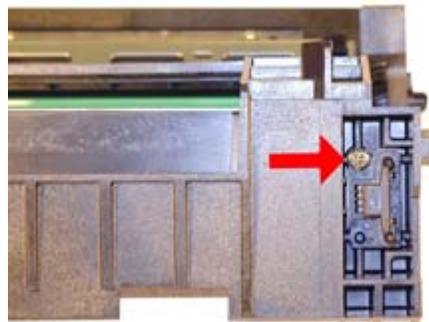


Figure 32

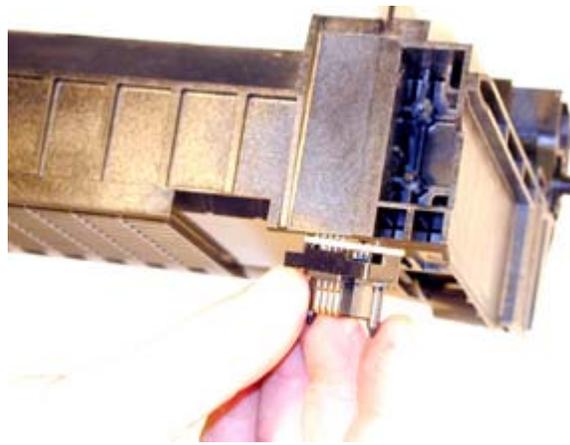


Figure 33

## CHECKING THE PERCENTAGE OF LIFE LEFT IN THE COPY CARTRIDGE



This procedure will display the percentage of life left in the copy cartridge.

- 1) Press and hold the STOP button. Continue to press the STOP button, and press the 2 quantity selector button. Release both buttons.
- 2) A value from 0 to 100 in increments of 5 will display for four seconds. For example: 65 means that 65% of the cartridge life is left.

No mention is made of how this determination is made anywhere in any manual I could find. Is that percentage based on pages printed? The amount of toner used? I'm not sure. The chip is shut down by a low toner signal not by the page count so I would imagine that the percentage is toner left, but I could not confirm that.

## CHECKING TO SEE WHAT TYPE OF CARTRIDGE A MACHINE IS SET FOR



**Warning: The following methods call for entering the diagnostic mode of the machine. Damage can and will occur if the wrong buttons are pressed while in this mode. Only enter the diagnostic mode if you are trained, or familiar with repairing Xerox copiers!**

If a J8 message is showing on the display, the wrong type of cartridge (chip) is installed. Enter the diagnostic mode by holding the "0" button while turning the power on, and then press the "STOP/CLEAR" button. Wait for the optics to finish initializing before doing anything further! After the optics are done, press "202, then "PRINT". The first 3 digit number displayed is the type that the machine is set for; the 2nd 3 digit number that flashes is the type of cartridge installed.

### Common Status (Error) Codes

- C1 Tray 1 misfeed or no paper
- C2 Tray 2 misfeed or no paper
- C3 Bypass tray misfeed or no paper
- E1 Paper jam between the registration sensor and the exit sensor
- E3 Paper jam at exit
- E5 Door open
- J1 500 pages left in cartridge
- J3 Copy cartridge missing or not seated properly
- J7 Copy cartridge must be changed
- J8 Wrong type of cartridge installed. See text above
- U4 Fuser overheat
- U5 Fuser under temperature

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