



Version 3.1

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DocuColor 8000/7000 Operator Manual



Prepared by:

Xerox Corporation
Global Knowledge & Language Services
800 Phillips Road
Building 845
Webster, New York 14580

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Conventions

Standardized conventions have been used in this manual to assist you in visually locating and identifying information quickly.

Symbols



CAUTION: This symbol alerts you to an action that may cause damage to hardware, software, or result in the loss of data.



WARNING: Warnings mark alert users to areas of the machine where there is a possibility of personal injury.



WARNING: This symbol identifies an area on the machine that is HOT and should not be touched.



WARNING: This symbol indicates a laser is being used in the machine and alerts you to refer to the appropriate safety information.



TIP: This symbol identifies information that is being emphasized and is important for you to remember.



The 1 2 3... symbol indicates the beginning of a task or work process you should use to complete a procedure and is followed by the first step of a numbered procedure, task, or work process.



NOTE: *This symbol calls your attention to information that is helpful, but not essential to complete a procedure or task.*

Safety notices

This Xerox product and the recommended supplies are designed and tested to meet strict safety requirements. These include safety agency approval and compliance to established environmental standards. Please read the following instructions carefully before operating the product, and refer to them as needed to ensure the continued safe operation of your product.



TIP: The safety testing and performance of this product have been verified using Xerox materials only.



WARNING: Any unauthorized alteration, which may include the addition of new functions or connection of external devices, may impact the product certification. Please contact your authorized local dealer for more information.

Electrical safety

- Use only the power cord supplied with this equipment.
- Plug the power cord directly into a correctly grounded electrical outlet. Do not use an extension cord. If you do not know whether or not an outlet is grounded, consult a qualified electrician.
- Do not use a ground adapter plug to connect this equipment to an electrical outlet that lacks a ground connection terminal.



WARNING: You may incur a severe electrical shock if the outlet is not grounded correctly.

- Do not place the machine where people may step or trip on the power cord. Do not place objects on the power cord.
- Do not override or disable electrical or mechanical interlocks.
- Do not obstruct the ventilation openings. These openings prevent overheating of the machine.



WARNING: Never push objects of any kind into slots or openings on this equipment. Making a contact with a voltage point or shorting out a part may result in fire or electrical shock.

If any of the following conditions occur, immediately switch off the power to the machine and disconnect the power cord from the electrical outlet. Call an authorized Xerox service representative to correct the problem.

- The machine emits unusual noises or odors.
- The power cord is damaged or frayed.
- A wall panel circuit breaker, fuse, or other safety device is tripped.
- Liquid is spilled into the press.
- The machine is exposed to water.
- Any part of the machine is damaged.

Disconnect device

The power cable is the disconnect device for this equipment and is attached to the back of the machine as a plug-in device. To remove all electrical power from the machine, disconnect the power cable from the electrical outlet.



WARNING: This product must be connected to a protective earth current.

Laser safety

North America

This product complies with safety standards and is certified as a Class 1 Laser product under the Center for Devices and Radiological Health (CDRH) of the United States Food and Drug Administration (FDA) implemented regulations for laser products. This product complies with FDA 21 CFR 1940.10 and 1040.11 except for deviations pursuant to Laser Notice No. 50, dated July 26, 2001. These regulations apply to laser products marketed in the United States. The label on the machine indicates compliance with CDRH regulations and must be attached to laser products marketed in the United States. This product does not emit hazardous laser radiation.



CAUTION: Use of controls or adjustments or performance of procedures other than those specified herein may result in hazardous exposure of laser light.

Since radiation emitted inside this product is completely confined within the protective housing and external covers, the laser beam cannot escape from the machine during any phase of the user operation.

This product contains laser warning labels. These labels are intended for use by the Xerox Service Representative and are placed on or near panels or shields that require special tools for removal. Do not remove any of the panels. There are no operator serviceable areas in these covers.

Europe (EU) and other markets

This product complies with IEC's safety standard 60825-1 (Edition 1.2) issued August 2001.

The equipment complies with laser product performance standards set by governmental, national, and international agencies as a Class 1 Laser Product. It does not emit hazardous radiation as the beam is totally enclosed during all phases of customer operation and maintenance.



CAUTION: Use of controls or adjustments or performance of procedures other than those specified herein may result in hazardous radiation exposure.

This product contains laser warning labels. These labels are intended for use by the Xerox Service Representative and are placed on or near panels or shields that require special tools for removal. Do not remove any of the panels. There are no operator serviceable areas inside these covers.

If you need additional safety information concerning the product or Xerox supplied materials, you may call the following number:

+44 (0) 1707 353434

Safety standards

North America

This Xerox product is safety certified by Underwriters Laboratories Incorporated to Standards UL60950-1 (first edition), and CSA International CAN/CSA C22.2 No. 60950-1-03 (First Edition).

Europe (EU) and other markets

This Xerox product is Safety Certified by NEMKO to publication IEC60950-1 (2001) First Edition.

Maintenance safety

- Do not attempt any maintenance procedure that is not specifically described in the documentation supplied with your product.
- Do not use aerosol cleaners. The use of supplies that are not approved may cause poor performance of the press and could create a dangerous condition.
- Use the supplies and cleaning materials only as directed in this manual. Keep all materials out of the reach of children.
- Do not remove the covers or guards that are fastened with screws. There are no parts behind these covers that you can maintain or service.

Do not perform any maintenance procedures unless you have been trained to do them by a Xerox representative, or unless a procedure is specifically described in one of the manuals included with your press.

Operational safety

Your Xerox equipment and supplies were designed and tested to meet strict safety requirements. These include safety agency examination, approval, and compliance with established environmental standards.

Your attention to the following safety guidelines will help ensure the continued safe operation of your product:

- Use the materials and supplies specifically designed for your product. The use of unsuitable materials may result in poor performance of the machine and possibly a hazardous situation.
- Follow all warnings and instructions that are marked on or supplied with the machine.
- Place the machine in a room that provides adequate space for ventilation and servicing.
- Place the machine on a level, solid surface (not on a thick pile carpet) that has adequate strength to support the weight of the machine.
- Do not attempt to move the machine. A leveling device that was lowered when your machine was installed may damage the carpet or floor.
- Do not set up the machine near a heat source.
- Do not set up the machine in direct sunlight.

- Do not set up the machine in line with the cold air flow from an air conditioning system.
- Do not place containers of coffee or other liquid on the machine.
- Do not block or cover the slots and openings on the machine.
- Do not attempt to override any electrical or mechanical interlock devices.



WARNING: Be careful when working in areas identified with this warning symbol. These areas may be very hot and should not be touched.

If you need any additional safety information concerning the machine or materials, contact your Xerox representative.

Ozone safety

This product produces ozone during normal operation. The ozone is heavier than air, and the quantity is dependent on print volume. Providing the correct environmental parameters, as specified in the Xerox installation procedures, ensures that concentration levels meet safe limits.

If you need additional information about ozone, request the Xerox publication, *OZONE* by calling 1-800-828-6571 in the USA. For a French language version, call 1-800-828-6571 in the USA, then press 2.

Notices

Radio frequency emissions

FCC in the USA

This equipment has been tested and found to comply with the limits for a Class A digital device, pursuant to Part 15 of the Federal Communications Commission (FCC) Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications. Operation of this equipment in a residential area is likely to cause harmful interference in which case the user will be required to correct the interference at his/her own expense.

Changes or modifications to this equipment not specifically approved by the Xerox Corporation may void the user's authority to operate this equipment.



WARNING: Shielded cables must be used with this equipment to maintain compliance with FCC regulations.

In Canada (ICES-003)

This Class "A" digital apparatus complies with Canadian ICES-003.

Cet appareil numérique de la classe "A" est conforme à la norme NMB-003 du Canada.

Regulatory information for RFID

This product generates 13.56 MHz using an Inductive Loop System as a Radio Frequency IDentification system device (RFID). This system is certified in compliance with European Council Directive 99/5/EC and applicable local laws or regulations as applicable.

Safety extra low voltage approval

This Xerox product is in compliance with various governmental agencies and national safety regulations. All system ports meet the Safety Extra Low Voltage (SELV) circuits for connection to customer-owned devices and networks. Additions of customer-owned or third-party accessories that are attached to the press must meet or exceed the requirements previously listed. All modules that require external connection must be installed per the installation procedure.

Certifications in Europe



The CE marking that is applied to this product symbolizes Xerox Declaration of Conformity with the following applicable Directives of the European Union as of the dates indicated:

- January 1, 1995:** Council Directive 73/23/EEC amended by Council Directive 93/68/EEC, approximation of the laws of the member states related to low voltage equipment.
- January 1, 1996:** Council Directive 89/336/EEC, approximation of the laws of the member states related to electromagnetic compatibility.
- March 9, 1999** Council Directive 99/5/EC on radio equipment and telecommunications terminal equipment and the mutual recognition of their conformity.

A full declaration, defining the relevant directives and referenced standards, can be obtained from your Xerox Limited representative or by contacting:

Environment, Health and Safety
The Document Company Xerox
Bessemer Road
Welwyn Garden City
Herts
AL7 1HE
England
Tel Number +44 (0) 1707 353434



WARNING: This system is certified manufactured and tested in compliance with strict safety and radio frequency interference regulations. Any unauthorized alteration which includes the addition of new functions or the connection of external devices may impact this certification. Please contact your local Xerox Limited representative for a list of approved accessories.



WARNING: In order to allow this equipment to operate in proximity to Industrial, Scientific, and Medical (ISM) equipment, the external radiation from the ISM equipment may have limited or special mitigation measures taken.



WARNING: This is a Class A product in a domestic environment. This product may cause radio frequency interference in which case the user may be required to take adequate measures.



WARNING: Shielded cables must be used with this equipment to maintain compliance with Council Directive 89/336/EEC.

It's illegal in the USA

Congress, by statute, has forbidden the reproduction of the following subjects under certain circumstances. Penalties of fine or imprisonment may be imposed on those guilty of making such reproductions.

1. Obligations or Securities of the United States Government, such as:

Certificates of Indebtedness	National Bank Currency
Coupons from Bonds	Federal Reserve Bank Notes
Silver Certificates	Gold Certificates
United States Bonds	Treasury Notes
Federal Reserve Notes	Fractional Notes
Certificates of Deposit	Paper Money

Bonds and Obligations of certain agencies of the government, such as FHA, etc.

Bonds. (U.S. Savings Bonds may be photographed only for publicity purposes in connection with the campaign for the sale of such bonds.)

Internal Revenue Stamps. (If it is necessary to reproduce a legal document on which there is a canceled revenue stamp, this may be done provided the reproduction of the document is performed for lawful purposes.)

Postage Stamps, canceled or uncanceled. (For philatelic purposes, Postage Stamps may be photographed, provided the reproduction is in black and white and is less than 75% or more than 150% of the linear dimensions of the original.)

Postal Money Orders.

Bills, Checks, or Drafts of money drawn by or upon authorized officers of the United States.

Stamps and other representatives of value, of whatever denomination, which have been or may be issued under any Act of Congress.

2. Adjusted Compensation Certificates for Veterans of the World Wars.
3. Obligations or Securities of any Foreign Government, Bank, or Corporation.
4. Copyrighted material, unless permission of the copyright owner has been obtained or the reproduction falls within the "fair use" or library reproduction rights provisions of the copyright law. Further information of these provisions may be obtained from the Copyright Office, Library of Congress, Washington, D.C. 20559. Ask for Circular R21.
5. Certificates of Citizenship or Naturalization. (Foreign Naturalization Certificates may be photographed.)
6. Passports. (Foreign Passports may be photographed.)
7. Immigration Papers.
8. Draft Registration Cards.
9. Selective Service Induction Papers that bear any of the following Registrant's information:
 - Earnings or IncomeDependency Status
 - Court RecordPrevious military service
 - Physical or mental condition
 - Exception: United States military discharge certificates may be photographed.
10. Badges, Identification Cards, Passes, or Insignia carried by military personnel, or by members of the various Federal Departments, such as FBI, Treasury, etc. (unless photograph is ordered by the head of such department or bureau.)
 - Reproducing the following is also prohibited in certain states:
 - Automobile Licenses - Drivers' Licenses - Automobile Certificates of Title.

The above list is not all inclusive, and no liability is assumed for its completeness or accuracy. In case of doubt, consult your attorney.

It's illegal in Canada

Parliament, by statute, has forbidden the reproduction of the following subjects under certain circumstances. Penalties of fines or imprisonment may be imposed on those guilty of making such copies.

1. Current bank notes or current paper money.
2. Obligations or securities of a government or bank.
3. Exchequer bill paper or revenue paper.
4. The public seal of Canada or of a province, or the seal of a public body or authority in Canada, or of a court of law.
5. Proclamations, orders, regulations or appointments, or notices thereof (with intent to falsely cause same to purport to have been printed by the Queen's Printer for Canada, or the equivalent printer for a province).
6. Marks, brands, seals, wrappers or designs used by or on behalf of the Government of Canada or of a province, the government of a state other than Canada or a department, board, Commission or agency established by the Government of Canada or of a province or of a government of a state other than Canada.
7. Impressed or adhesive stamps used for the purpose of revenue by the Government of Canada or of a province or by the government of a state other than Canada.
8. Documents, registers or records kept by public officials charged with the duty of making or issuing certified copies thereof, where the reproduction falsely purports to be a certified copy thereof.
9. Copyrighted material or trademarks of any manner or kind without the consent of the copyright or trademark owner.

The above list is provided for your convenience and assistance, but it is not all inclusive, and no liability is assumed for its completeness or accuracy. In case of doubt, consult your solicitor.

Environmental notices for Canada

Terra Choice Environmental Services, Inc. of Canada has verified that this Xerox product conforms to all applicable Environmental Choice EcoLogo requirements for minimized impact to the environment.



As a participant in the Environmental Choice program, Xerox Corporation has determined that this product model meets the Environmental Choice guidelines for energy efficiency.

Environment Canada established the Environmental Choice program in 1988 to help consumers identify environmentally responsible products and services. Copier, printer, digital press, scanners, and fax products must meet energy efficiency and emissions criteria, and exhibit compatibility with recycled supplies. Currently, Environmental Choice has more than 1600 approved products and 140 licensees. Xerox has been a leader in offering EcoLogo approved products. In 1996, Xerox became the first company licensed to use the Environmental Choice EcoLogo for its copiers, printers, and fax machines.

Product recycling and disposal

If you are managing the disposal of your Xerox product, please note that the product contains lead and other materials whose disposal may be regulated due to environmental considerations. The presence of lead is fully consistent with global regulations applicable at the time that the product was placed on the market.

North America

Xerox operates a worldwide equipment take-back and reuse/recycle program. Contact your Xerox sales representative (1-800-ASK-XEROX) to determine whether this Xerox product is part of the program. For more information about Xerox environmental programs, visit www.xerox.com/environment.

For recycling and disposal information, contact your local authorities. In the United States, you may also refer to the Electronic Industries Alliance web site: www.eiae.org.

Perchlorate Material

This product may contain one or more Perchlorate-containing devices, such as batteries. Special handling may apply, please see www.dtsc.ca.gov/hazardouswaste/perchlorate.

If your product is not part of the Xerox program and you are managing its disposal, please follow the instructions provided in the above paragraph.

European union



Application of this symbol on your equipment is confirmation that you must dispose of this equipment in compliance with agreed national procedures.

In accordance with European legislation end-of-life electrical and electronic equipment subject to disposal must be managed within agreed procedures.

Prior to disposal, contact your local dealer or Xerox representative for end-of-life take-back information.

Other countries

Please contact your local waste authorities and request disposal guidance.

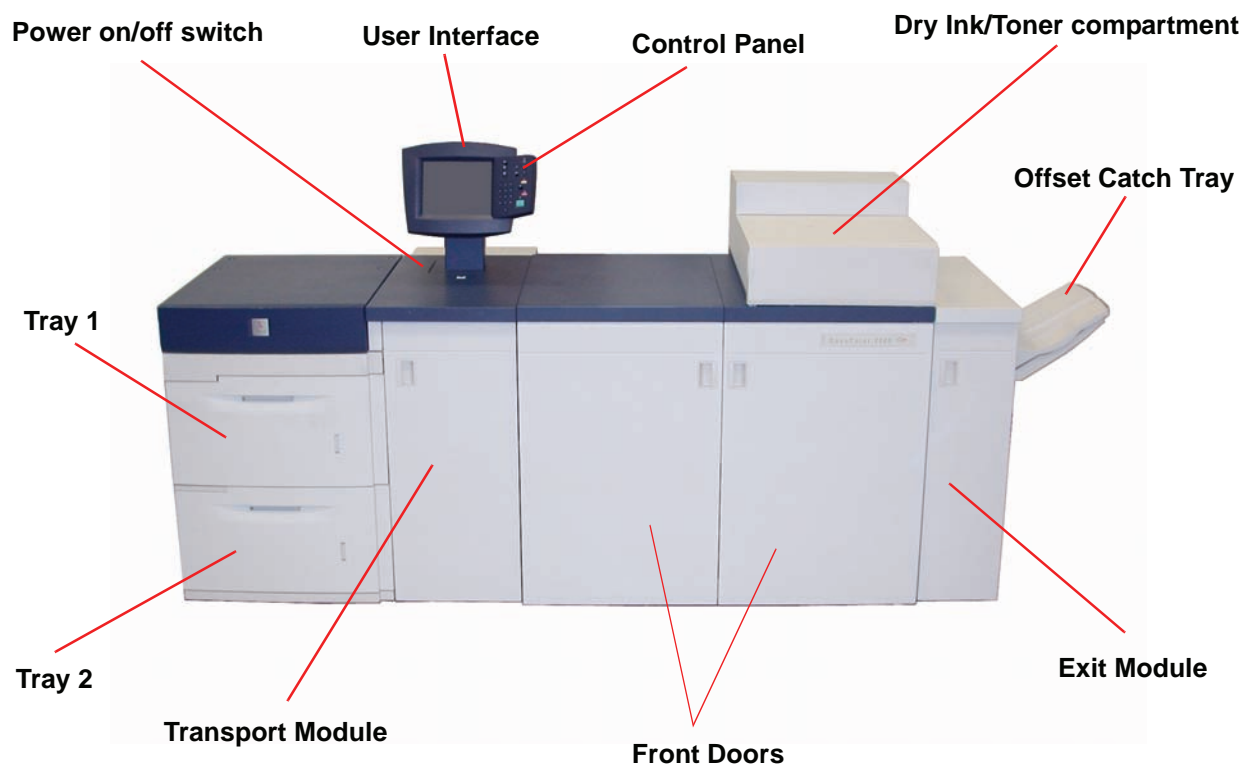
1. Overview



The DocuColor 8000/7000 is a full color/black and white digital press operating at a speed of either eighty prints per minute (DocuColor 8000) or seventy prints per minute (DocuColor 7000). This chapter provides the location, name, and function of the various digital press components including:


- External components
- The User Interface
- The Control Panel
- Internal components

Identifying the external components

Use the illustration below to identify external components listed in the table on the next page.



Part	Description
Paper Tray 1	Holds 2000 sheets of 24 lb. (90 g/m ²) paper.
Paper Tray 2	Holds 2000 sheets of 24 lb. (90 g/m ²) paper.
Transport Module	The Transport Module carries the paper from the paper trays to the upper paper path of the digital press. It also routes the paper from the lower paper path of the digital press to the upper paper path of the digital press when duplexing.
On/Off  On  Off	<p>Press the Power Switch to the On position to power on the digital press. A screen message advises of a short wait while the Fuser warms up and the digital press runs a system check.</p> <p>Press the Power Switch to the Off position to power off the digital press. Allow the digital press to remain off for a minimum of twenty seconds before switching the power on again.</p>
User Interface	<p>The User Interface contains two components: the Control Panel and the Touch Screen.</p> <p>The Touch Screen allows selections to be made by simply touching a button on the screen.</p>

Part	Description
Control Panel	Allows keypad selection of features. Refer to the Control Panel section in this chapter.
Dry Ink/Toner Compartment	Contains the Dry Ink/Toner cartridges. The cartridge colors from left to right, are black, cyan, magenta, and yellow. Refer to the Maintenance Chapter of this manual for instructions on changing the cartridges.
Offset Catch Tray (OCT)	Receives completed print job. Sets are offset for easy separation. Maximum capacity is 500 sheets of 24 lb. (90 g/m ²) paper.
Right/Left Front Doors	Houses the image transfer system for simplex and duplex printing. Open to clear jams in the paper path in the Printing Module and at the Fuser. Follow the instructions precisely for clearing a jam in the Fuser.  WARNING: The Fuser is extremely hot and will cause injury if jam clearing instructions are not followed.
Exit Module	Contains the decurler and the inverter. The decurler removes any curl from the printed page. The inverter is used when duplexing or face down output is selected.

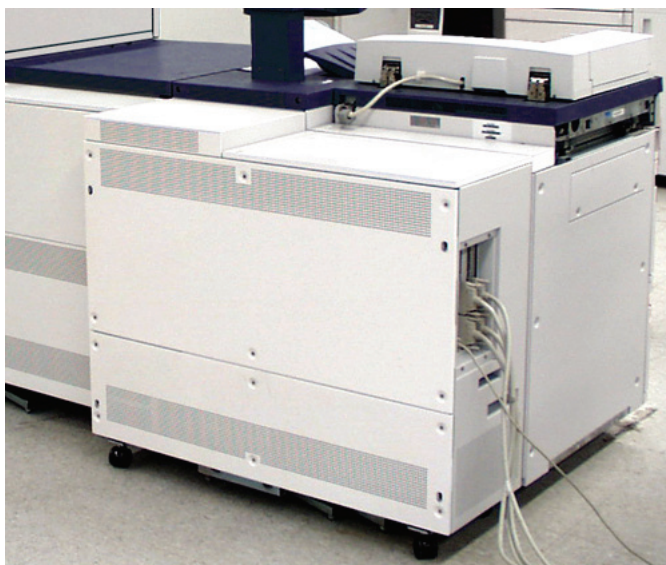
Ecology Module

The Ecology Module connected to the back of the DocuColor 8000/7000 contains the environmental components (ozone and dust filters). The Ecology Module is maintained by the Xerox service representative.



Electrical Module

The Electrical Module houses software, printed wiring boards, and power supplies. The Xerox service representative connects a laptop to the twenty-five pin connector on the Electrical Module to load software or run diagnostics. This connector is for the Xerox service representative only; do not connect a computer cable to it.



CAUTION: Do **not** block the vents of the Electrical Module.



WARNING: Do not remove the covers or guards that are fastened with screws. There are no parts behind these covers that you can maintain or service.

Dry Ink/Toner Waste Bottle

The Dry Ink/Toner Waste Bottle collects the waste dry ink/toner in the printing process. The Dry Ink/Toner Waste Bottle is customer replaceable and located in the rear of the Exit Module.

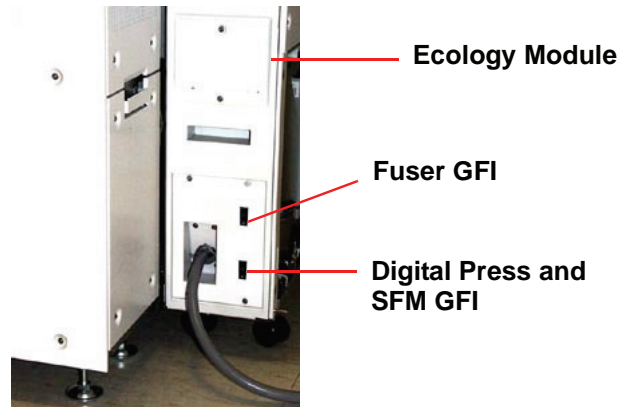
Refer to the Maintenance Chapter of this manual for instructions on changing the Dry Ink/Toner Waste Bottle.

**Dry Ink/Toner
Waste Bottle**



Ground Fault Indicator (GFI) circuit breakers

The digital press is equipped with two safety circuit breakers called a Ground Fault Indicators (GFI). These devices trip if the power to the digital press is interrupted.



Fuser GFI The Fuser receives power through the Fuser GFI.

Digital Press GFI The digital press receives power through the Digital Press GFI. If an optional Second Feeder Module is connected to the Digital Press, then it too receives power from this GFI.

After a power outage occurs: Power on the digital press as soon as possible after the power is restored, and print a job to ensure that there is no damage to the digital press.

If power to the digital press is interrupted,

- Locate the circuit breakers on the Ecology Module on the back of the digital press next to the toner waste bottle.
- If either device is tripped, the switch is in the Off position (down). Flip the switch up.



NOTE: *If the device trips again or if power is not restored by the above procedure, call your Xerox service representative.*



CAUTION: The Pressure Pad in the Fuser remains in an up position if power to the digital press is interrupted while the digital press is in use. The Pressure Pad is not released from this position until the power is restored, the Power Switch is in the On position, and the Start button is pressed.



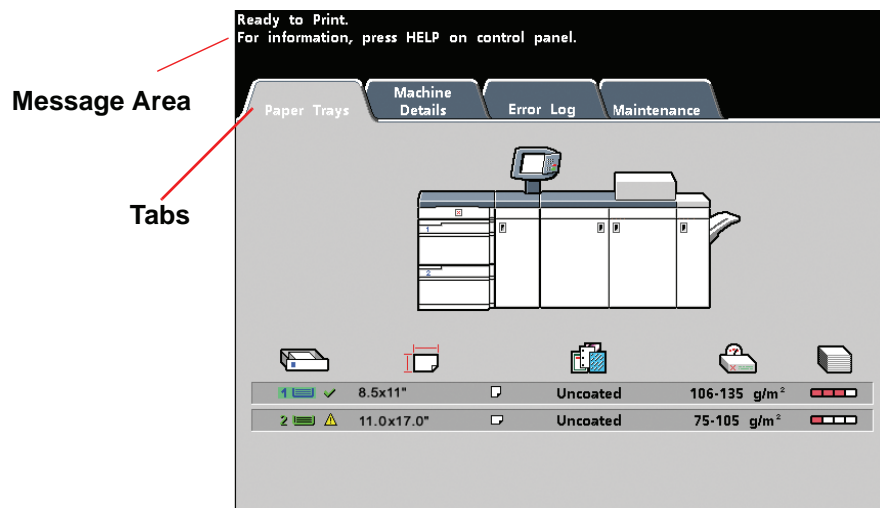
KEY POINT: If the Pressure Pad remains in the up position for a prolonged period of time, print quality defects will occur.

User Interface (UI)

The User Interface (UI) displays messages that indicate the status of the digital press during idle, run, or fault conditions. The UI also displays the default screen selected in the Tools Mode by your System Administrator.



The default screen can be either the *Job Status* or the *Machine Status* screen.



Message Area

The message area at the top of the UI displays messages concerning the digital press status, programming conflicts, or errors. Messages may also provide instructions for the operator.

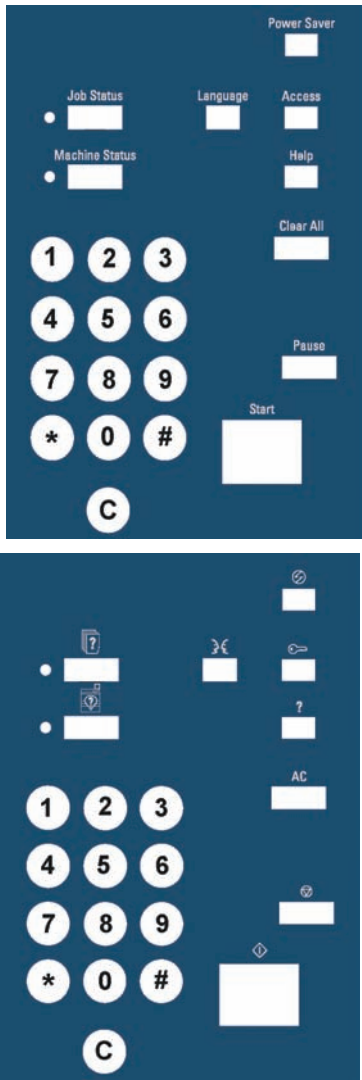
Tabs and Functions

Some UI screens display tabs which contain various selectable options. Options are initially set to the factory default settings. These settings can be changed by your System Administrator in Tools Mode.



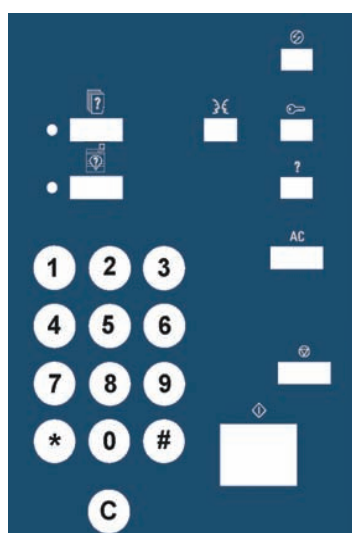
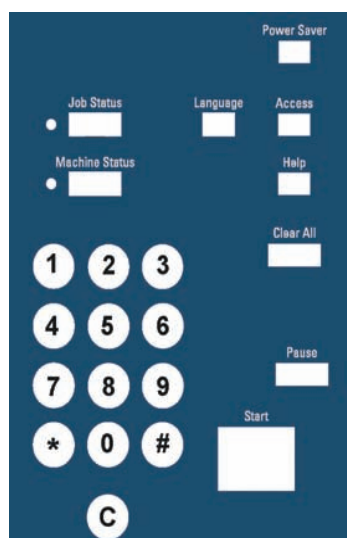
Ask your System Administrator for more information regarding these selections, or refer to the System Administration Guide.

Control Panel



Your digital press has one of two Control Panels: a Control Panel with words or one with international symbols. The function of each button is described in the table on the following pages.

Name	Function
Power Saver	Lights up when the digital press is in Sleep Mode, which lowers the Fuser temperature. Press to return to Standby Mode.
Job Status	Displays a list on the UI of the current jobs and their status. You can hold, release, promote, delete, and see the options selected for each job.
Language	Allows you to select one of two languages to be displayed on the UI.
Access	Allows access to the password-protected Tools Mode and the Auditron Mode.
Machine Status	Accesses the Paper Tray, Machine Details, Error Log, and Maintenance screens. Machine Status is where you find the serial number for the digital press, along with the customer support phone numbers, and the meters that show the count for color, black and white, color large size, and total output.

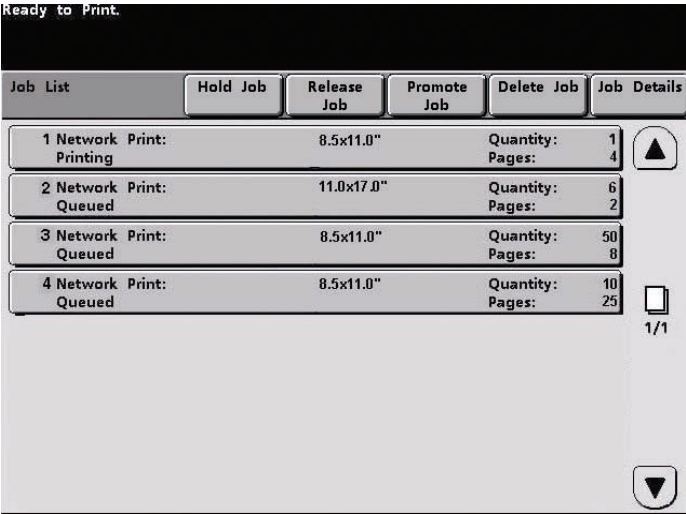


Name	Function
Help	Displays additional information useful in completing a task.
Clear All	The Clear All button is used in the Tools Mode for clearing certain selections or settings. It is also used by the service representative in the diagnostics mode.
Pause	Press the Pause button to pause the printing process in order to perform certain maintenance procedures such as changing the fuser oil or the dry ink/toner cartridge. You must press Pause again to resume the printing process.
Start	The Start button is used in the Tools Mode for certain settings. It is also used by the service representative in the diagnostics mode.
Keypad	Use the keypad to enter your password for access to Tools Mode. Use the keypad for certain Tools Mode features. The keypad is also used by the service representative in the diagnostics mode.

Job Status



When you press the Job Status button, the *Job Status* screen is displayed.



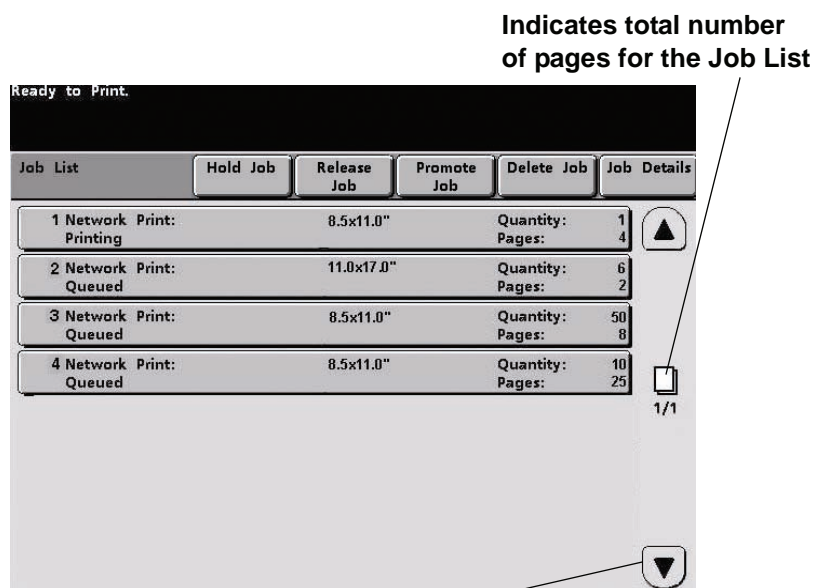
The *Job Status* screen can be set as the initial screen default by your System Administrator. Information about the job includes Job Type, Current Status, Paper Size, Output Quantity (refers to the output in sheets for a single page job and in sets or stacks for a multiple page job), and total Number of Pages.

Jobs are numbered in the order they are received for processing. Job order in the queue may be modified by an automatic Hold (something has to be done to the digital press before continuing), a Manual Hold (at user request), Promotion of one or more jobs, or Delete a job.

To perform one of the following functions, you must first touch the desired job to select it, then touch one of the buttons below.

- Touch **Hold Job** for a manual hold. When a job is in Hold Job status in the queue, it does not print when it reaches the top of the job queue. It is skipped until it is released or deleted.
- Touch **Release Job** to reactivate a job that is on hold in the queue. If the job is being held due to a resource (paper, dry ink/toner, etc.) problem, the job is not released until the resource is provided. A job that is held due to user request can be released by touching the Release button.
- Touch **Promote Job** to advance a selected job in the queue to be processed after the job that is currently printing. Jobs are processed on a first-in/first-out basis when multiple jobs are promoted. Once a job has been promoted, it cannot be skipped by jobs promoted after it.
- Touch **Delete Job** to delete a selected job from the queue. You must answer “Yes” when confirmation of the delete is requested.
- Touch **Job Details** for detailed information about a selected job such as Number of Images processed, Color Mode, Paper Tray in use, Paper Type, and Finishing.

Job names are truncated to sixteen characters on the *Job Status* screen, which may be fewer characters than are displayed on your color server screen.



The Up and Down arrow buttons are selectable when the total number of jobs exceeds one page

Name	Function
Job List	Shows all jobs submitted to the digital press.
Hold Job	Holds a job in the print queue until released.
Release Job	Releases a Hold Job to be printed.
Promote Job	Enables a job to be moved in front of other jobs in the queue.
Delete Job	Deletes a selected job.
Job Details	Shows the programmed options for a selected job.
Up/Down Arrows	Enables scrolling through job list.

Power Saver

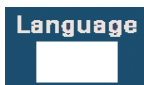


Pressing the Power Saver button puts the digital press in a reduced power consumption mode during which the Fuser temperature is lowered. The digital press automatically goes into this mode after no activity occurs for the factory default time of fifteen minutes. This time can be changed in Tools to reflect a value of 1-240 minutes.



Refer to the System Administration Guide for further information.

Language



The Language button toggles the UI text between two preset languages.

Access



The Access button brings up a screen that requires a password to enter the Tools or Auditron screens.

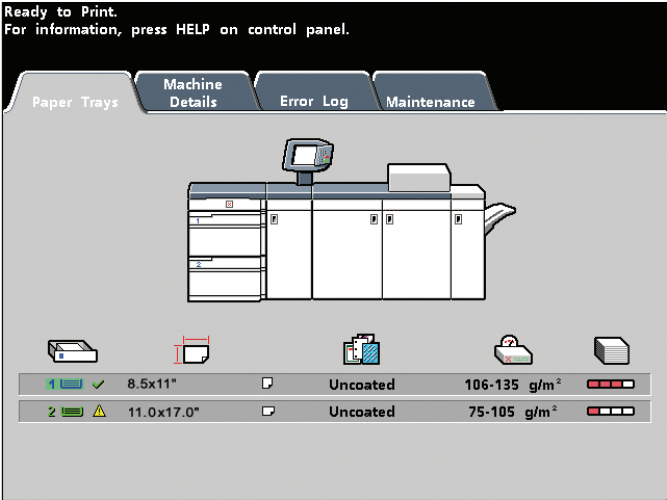


Refer to the System Administration Guide for further information on Tools and Auditron features.

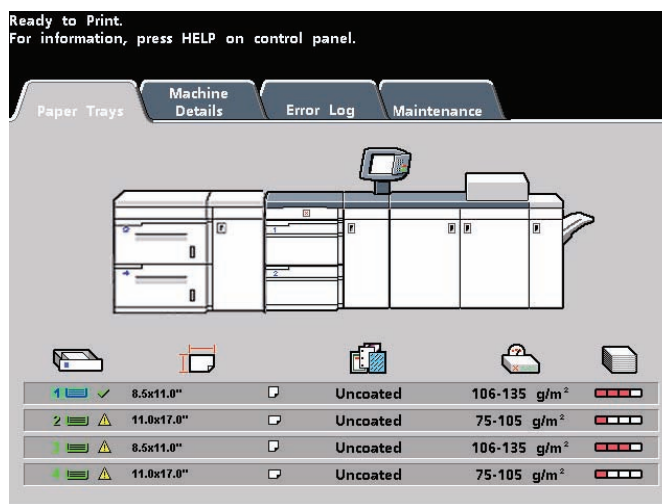
Machine Status



When the Machine Status button on the Control Panel is pressed, the Paper Trays tab screen is displayed by default. The *Machine Status* screen can be set as the initial screen default by your System Administrator.

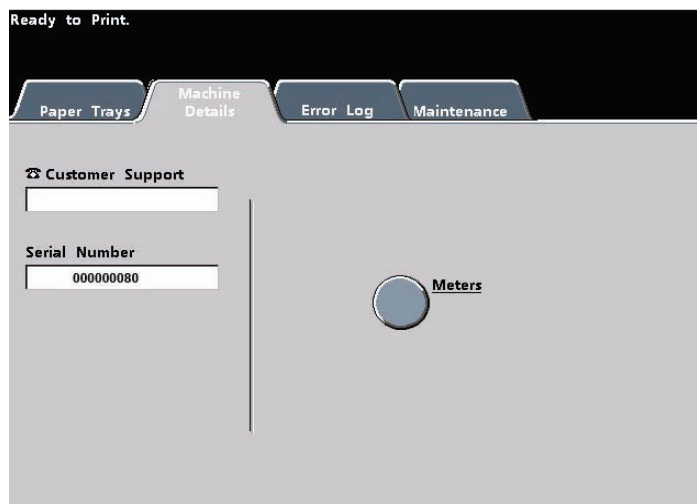


If an optional Second Feeder Module is connected to the digital press, Trays 3 and 4 will appear in the Paper Supply column.



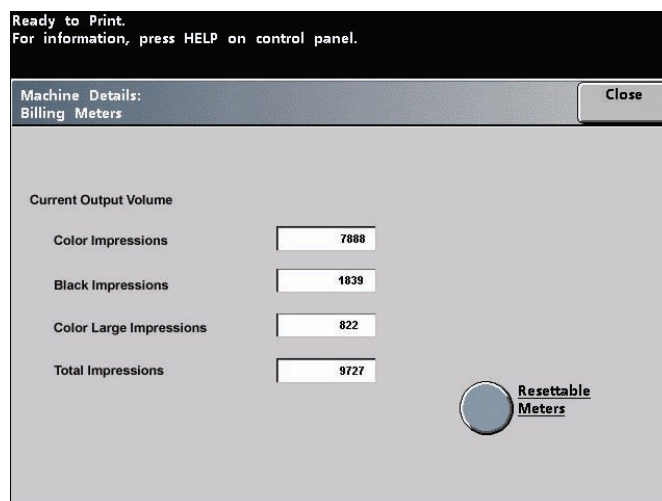
Screen Name	Function
Paper Trays	Shows the trays available, and the size, type, weight and level of the paper in the trays.
Machine Details	Displays the customer support phone number, the serial number of the machine, and access to the <i>Meters</i> screen.
Error Log	Shows all error codes to assist your Xerox service representative in solving problems with the digital press.
Maintenance	Touch the Customer Replaceable Unit button to display the status of the Dry Ink/Toner Cartridges, Dry Ink/Toner Waste Bottle, Charge Corotrons and Fuser Web. A green check mark indicates that the status is Okay. A yellow check mark indicates a Warning. A red circle indicates a Fault.

Machine Details tab



This screen provides the telephone number to call for support, the machine serial number and access to the meter counts.

Meters keep track of print counts. To view the print count, touch the Meters button on the Machine Details screen. The Billing Meters screen is displayed.



To reset the meters to zero, touch the **Resettable Meters** button. On the following screen touch the **Reset** button.

Ready to Print.
For information, press HELP on control panel.

Billing Meters:
Resettable Meters

Reset Close

Current Output Volume

Color Impressions	7888
Black Impressions	1839
Color Large Impressions	822
Total Impressions	9727

Maintenance tab

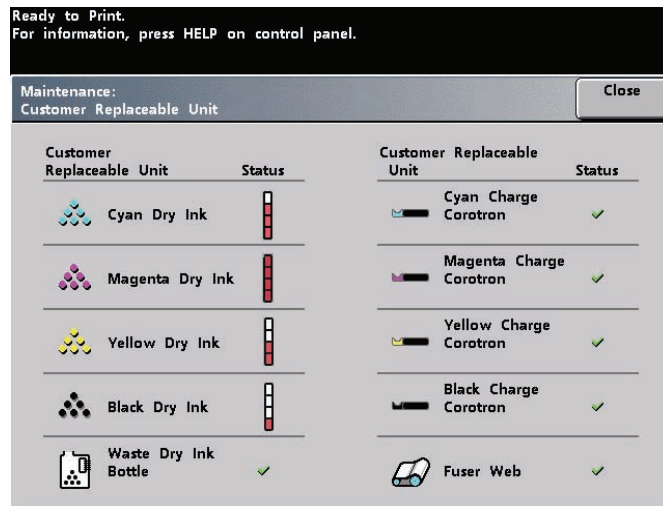
Touch the *Customer Replaceable Unit* button on the *Maintenance* screen to display a list of replaceable items and their status.

Ready to Print.

Paper Trays Machine Details Error Log Maintenance

Customer Replaceable Unit Service Engineer Replaceable Unit

The Customer Replaceable Unit screen displays a gauge or a check mark indicating the level at which the consumable is.



For example, the gauges for the dry ink/toner cartridges indicate the amount of toner in each cartridge:

- The cartridge is full when all four bars are red.
- The cartridge is $\frac{3}{4}$ full when three bars are red.
- The cartridge is $\frac{1}{2}$ full when two bars are red.
- The cartridge is $\frac{1}{4}$ full when one bar is red.



For the other consumables, such as the Waste Dry Ink Bottle, each Corotron, and the Fuser Web, the following applies:



- A green check mark indicates that the level of the consumable is adequate



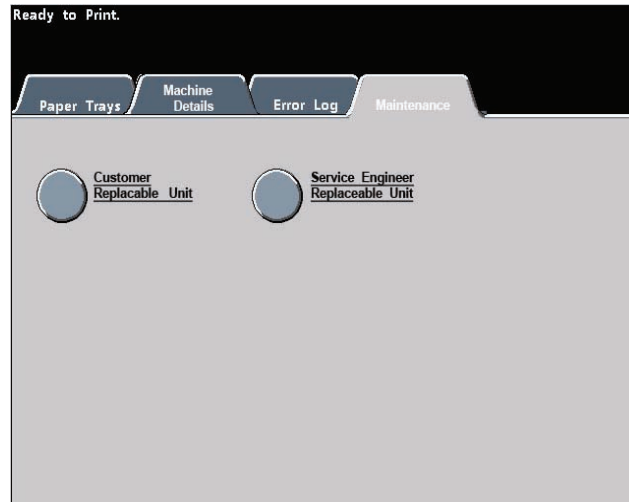
- A yellow triangle alerts you that the level is low, and



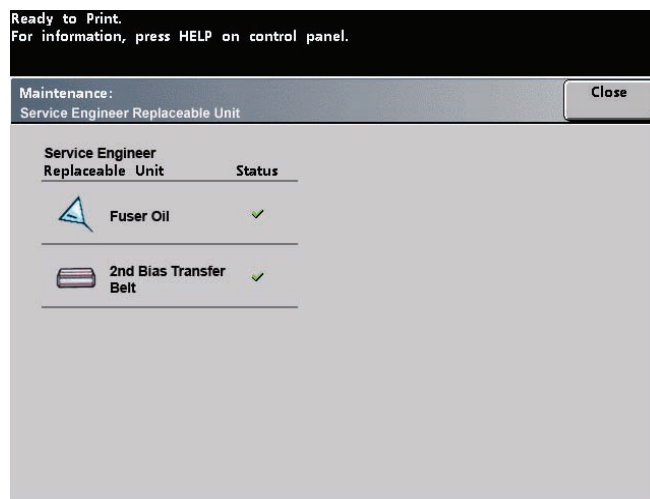
- A red circle indicates that the consumable is depleted

When a consumable item is depleted, the digital press automatically interrupts the current job and does not restart until the consumable is replaced.

Your Xerox service representative uses the Service Engineer Replaceable Unit function to check on the status items that are replaced only by the service engineer.



These items include the fuser oil and the second bias transfer belt.



Help



Press **Help** for an overview of the different options displayed in the various tabs on the UI.

Audio tones

There are three audio tones:

- **Attention:**

The Attention Tone sounds six seconds after a scan job has been completed to remind you to remove the document from the Scanner glass.

- **Button Selection:**

A single tone indicates that the button you pressed can be selected. A double tone indicates that the button is not available.

- **Fault:**

The Fault Tone indicates that the digital press is in a fault condition and does not operate until the fault is cleared.

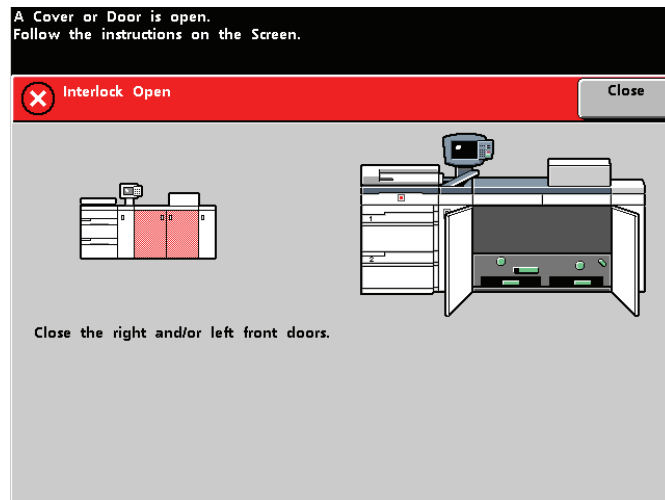
The Audio Tones can be deactivated or made louder or softer through the Tools Mode.



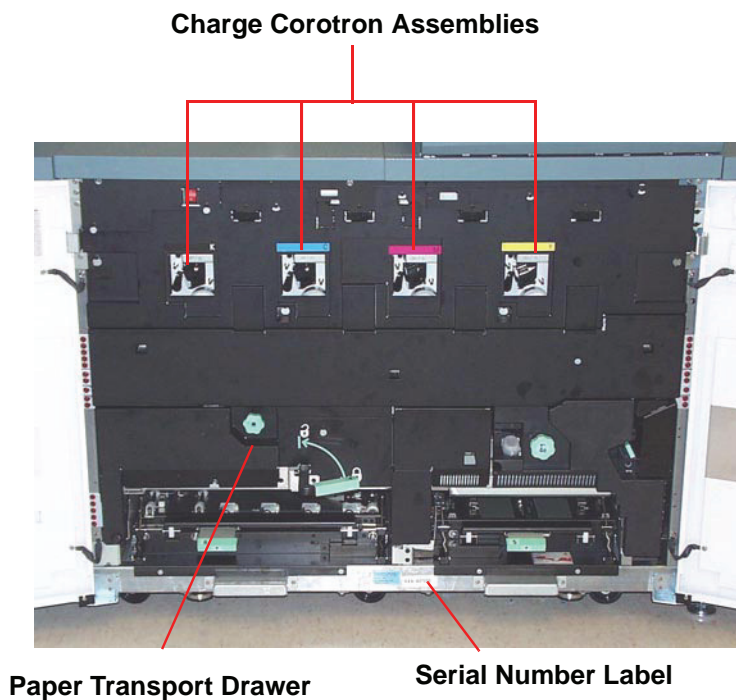
For more information, refer to the System Administration Guide.

Alert screens

An *Alert* screen has a red bar across the screen when a consumable product, such as Dry Ink/Toner, needs to be replaced. An *Alert* screen also indicates that the digital press is unable to make prints because of a fault condition. Follow the instructions on the UI to resolve the problem and resume printing.



Identifying the internal components



Serial number label

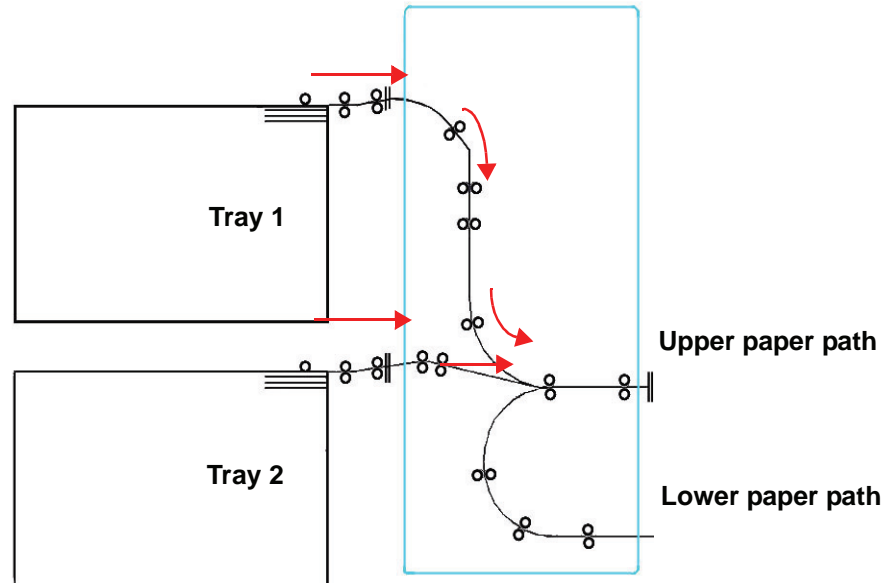
If the digital press loses power and it is impossible to access the Machine Details tab for the serial number, open the two main front doors. The serial number label is in the center of the bottom frame of the digital press.

Paper Transport drawer

This area is where paper is aligned, the image is applied and fused, and the paper is flipped over if duplexing is required.

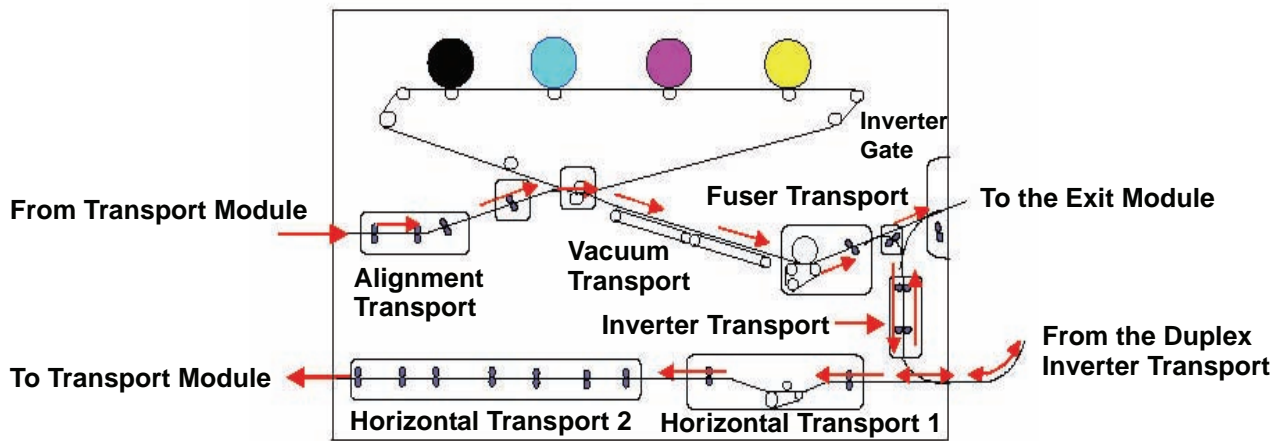
Transport Module

Paper from all trays moves through the Transport Module to the upper paper path in the digital press. The lower paper path carries duplexed sheets through the Transport Module to the digital press upper paper path.



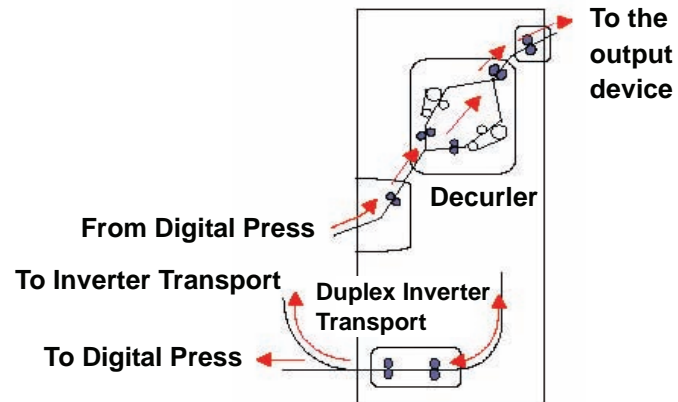
Paper path in the digital press

The paper path transfers an image to the paper and fuses it for both the simplex and duplex selections. It has two areas, the upper paper path and the lower paper path. The upper path is used for both simplexing and duplexing. The lower path is used for duplexing only. The Horizontal Transport 1 decurls the paper when printing duplex.



Exit Module

A completed print passes through the Exit Module to the Offset Catch Tray or other finishing device. The Exit Module contains a Decurler that removes paper curl caused by the fusing process. The Exit Module also contains an Inverter which turns the paper over to image side two when duplexing, or when face down output is selected.



Relocating the digital press

If you need to relocate the digital press, call your Xerox customer representative. The Installation Planning procedure must be conducted for every new site.

Customer documentation updates

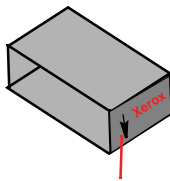
You can get the latest customer documentation updates for your digital press by going to www.xerox.com. Be sure to periodically check this website for the latest information for your digital press.

2. Paper and paper trays

Recommended Materials List (RML)

Refer to the *Color Materials Usage Guide*, the *Recommended Materials List*, and the *Speciality Media Guide: Hints and Tips* for paper guidelines. The *Recommended Materials List* and the *Speciality Media Guide: Hints and Tips* documents are updated on an on-going basis to include new papers and other media. PDF files are available at www.xerox.com. Use the search parameter **DocuColor 8000/7000** and follow the path until you reach the files to download.

Paper handling



Label on ream
instructs you to
"Print arrow side
first"

For the best performance, load paper with the seam side up in all the paper trays. The seam side is where the ream of paper is sealed. Refer to the label on the paper ream.



NOTE: Many suppliers use arrows on the product labels to indicate the preferred side to image first. Use this side (as signaled by the arrow) as equivalent to the seam side when loading the paper.

Many factors affect the performance of paper, including room temperature, humidity, paper quality, dust, and the size of the image area. If jams or paper curl problems occur, remove the paper from the paper tray, turn it over, place it back in the paper tray, and resume printing. If the problem is rectified, continue to load your paper in the same manner.

If the problem is not rectified, load a new ream of paper and try the process again. If the problem persists, your System Administrator may go into the Tools Mode and try the different decurler settings. If, after trying all the previous suggestions, the problem still persists, call your Xerox representative.

For reliable digital press operation and good print quality, Xerox recommends the following:

- Stored paper:**
- On a flat surface. Do not store paper directly on the floor, since this increases the possibility of moisture absorption. Paper should be stored on pallets, shelves, or in cabinets in an area protected from extremes of temperature and humidity.
 - In a low dust area.
 - In a low humidity area. Humidity is one of the most important steps to promote proper paper characteristics. Optimum paper storage conditions include a relative humidity of 35-55%. An increase in humidity may cause paper to develop wavy edges. This occurs because the edges absorb moisture while the rest of the ream remains unaffected. Wavy edges causes jams and misfeeds.
 - In an air-tight, moisture-proof container.

- In a controlled temperature. The temperature in the room where paper is stored has a significant effect on how that paper performs in the machine. Optimum paper storage temperature is 68-76° F (20-24.4° C).



For additional paper handling information, refer to the Color Materials Usage Guide.

Cutting and trimming paper

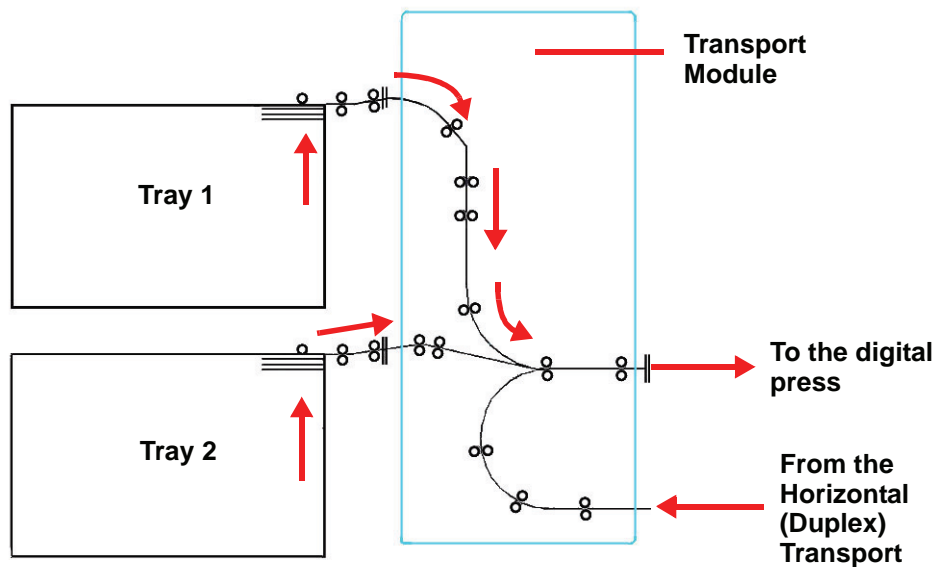
Proper cutting of the paper is important. Mills that offer paper in “cut sizes” crop their papers using state-of-the-art rotary slitters on high performance systems. Slitting and edge trimming by circular knives with dust removal at every cutting point prevents contamination of the paper.

Trimming papers from parent sheets to get the desired output size may generate dust if dull knives are used. The recommendation is to delay trimming until printing has been finalized to prevent paper dust generation and contamination.

If pre-printing is imperative, an in-house maintenance program, including knife sharpness maintenance and dust removal with a vacuum or air system, are key to achieving good results.

Paper trays

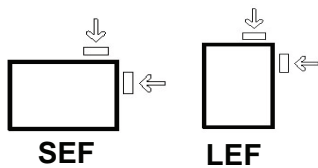
Paper Trays 1 and 2 are the standard paper trays for the basic configuration of the digital press. The following figure shows the paper path from trays 1 and 2 through the Transport Module.



Paper guidelines

For the best results, remember the following:

- Do not load paper or other materials above the **MAX** line on the rear paper guide.
- Do not store extra reams of paper in the paper trays.
- Do not use wrinkled, torn, curled, or folded paper.
- Use the paper sizes and weights shown in the *Recommended Materials List*.
- Follow the suggestions in the *Specialty Media Guide: Hints and Tips*.
- Do not mix sizes or weights of paper in a paper tray.
- Ensure that the tray indicator LEDs are set for the correct paper size, weight range, and paper type.



Copy paper is fed into the digital press in one of two positions: long edge feed (LEF) or short edge feed (SEF). Long edge refers to the long edge of the paper. When you see LEF, position the paper so the long edge is fed first. Short edge refers to the short edge of the paper. When you see SEF, position the paper so the short edge is fed first.



NOTE: It is imperative that you load paper with the paper guides adjusted properly. If the paper is NOT loaded properly, it skews and jams occur.

Curl

When paper is exposed to heat, the paper loses moisture and curls toward the heat source. High coverage jobs tend to curl more due to the toner plastification effect on the paper surface. The system tries to reduce this by using mechanical devices within the paper path called decurlers.

Your system has been designed with an automatic curl control system that uses information such as: the amount of coverage on the page, paper weight, whether the paper is coated or uncoated, and the current humidity and temperature to determine the amount of pressure needed at the different decurlers to reduce output curl.



If you are experiencing excessive curl, remove the paper from the tray, turn it over and replace it in the tray. If the curl is still excessive, refer to the System Administration Guide, Tools Mode chapter, to change the decurler settings to accommodate the environmental and paper conditions.

Paper specifications

Paper	All Paper Trays														
Minimum Paper Size	182mm x 182mm (7.16 x 7.16")														
Maximum Paper Size	320mm x 488mm (12.6 x 19.2")														
Standard Sizes	<table> <tr> <td>B5 LEF/SEF</td><td>A4 LEF/SEF</td></tr> <tr> <td>B4 SEF</td><td>A3 SEF</td></tr> <tr> <td>8 x 10" LEF</td><td>8.5 x 11" LEF/SEF</td></tr> <tr> <td>8.5 x 13" SEF</td><td>8.5 x 14" SEF</td></tr> <tr> <td>11 x 17" SEF</td><td>12 x 18" SEF</td></tr> <tr> <td>Kai8 SEF</td><td>Kai16 LEF</td></tr> <tr> <td>12.6 x 17.7" SEF^X</td><td>12.6 x 19.2" SEF^X</td></tr> </table>	B5 LEF/SEF	A4 LEF/SEF	B4 SEF	A3 SEF	8 x 10" LEF	8.5 x 11" LEF/SEF	8.5 x 13" SEF	8.5 x 14" SEF	11 x 17" SEF	12 x 18" SEF	Kai8 SEF	Kai16 LEF	12.6 x 17.7" SEF ^X	12.6 x 19.2" SEF ^X
B5 LEF/SEF	A4 LEF/SEF														
B4 SEF	A3 SEF														
8 x 10" LEF	8.5 x 11" LEF/SEF														
8.5 x 13" SEF	8.5 x 14" SEF														
11 x 17" SEF	12 x 18" SEF														
Kai8 SEF	Kai16 LEF														
12.6 x 17.7" SEF ^X	12.6 x 19.2" SEF ^X														
Paper Weight Range	60 - 300 g/m ²														
Transparencies ^H	Yes (A4 LEF or 8.5 x 11" LEF)														
Labels ^H	Yes														
Transfer Paper ^H	No														
Coated Paper ^{u b}	Yes														
Tabbed Inserts ^D	Yes														
Drilled	Yes: 2, 3, 4 hole														

^XRefer to the Non-Standard Size Paper section in this chapter.

^DRefer to the Tabbed Inserts section in this chapter.

^HRefer to the *Recommended Materials List* and the Speciality Media Guide for guidelines.

^uDuplex is limited to paper that is 220 g/m² or less.

^bL80 g/m² cannot duplex in high humidity. L85 g/m² coated media is not allowed.

Tray capacity

All paper trays have a capacity of 2000 sheets of 24 lb. (90 g/m²) paper.

Duplexing

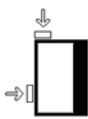
The DocuColor 8000/7000 duplexes prints from all paper trays up to 220 g/m². The system does not duplex media larger than 12.6 x 18 inch (321.1 x 458.1 mm).

Transparency guidelines

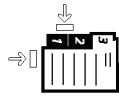
Transparencies can be run from all the paper trays.

Use only the transparencies recommended:

- Xerox Removable Paper Stripe: USA and Canada, 3R5765; Xerox Europe, 3R93179.
- Load transparencies into a tray with the paper stripe side facing DOWN and with the stripe as the leading edge. (The leading edge is the edge that feeds into the digital press first.)
 - Do not mix paper and transparencies in a tray. Jams may occur.
- Ensure that Transparency is selected in the Paper Weight section at the top/front of the paper tray.



Tabbed inserts



Tabbed Inserts can be loaded into the paper trays as Non-Standard paper.

- When loading, the non-tabbed, short edge of the tabbed insert should be the lead edge to the digital press.
- If a jam occurs while running tabbed sets, there is no recovery procedure.
 - You have to manually reassemble your originals and prints, determine where the job left off, and resume printing or cancel the job and start again.
- The size of the tabbed insert should be 9 x 11 inch (229 x 279 mm) for letter size tabs (223.5 x 296 mm for A4 equivalent tabs).
 - The correct weight of the insert should be selected on the tray.
- Select Non-Standard size on the paper tray and on the UI, Tools Mode, input 11 inches or 296 mm for A4 as the X axis and 9 inches or 223.5 mm for A4 as the Y axis dimensions for SEF.



Refer to the System Administration Guide for the procedure to program non-standard size paper.

Drilled paper

Three-hole drilled paper can be run from all the trays either LEF or SEF with the holes facing any direction.

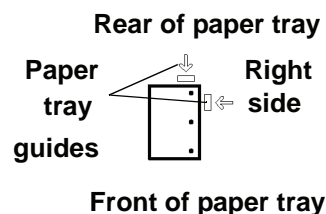


NOTE: If you are stapling 3-hole drilled paper with the optional High Capacity Stacker Stapler 80 (HCSS80), refer to the Accessories chapter for paper loading instructions, based on the position of the staple.

Drilled paper should be run in the Simplex (1-sided) and Duplex (2-sided) orientations shown below to avoid paper jams caused by the holes not aligning correctly with the paper sensor in the press.

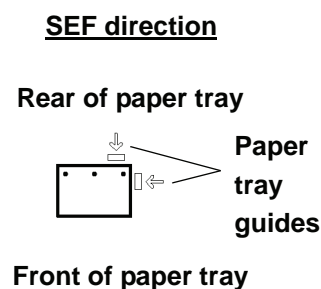
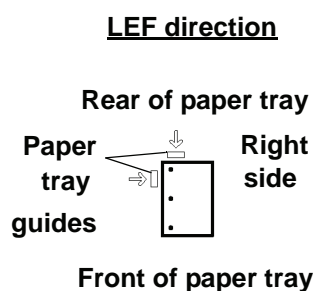
Simplex Print Jobs

Load the drilled paper into any tray in the Long Edge Feed (LEF) direction. Refer to the following illustration:



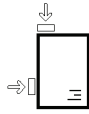
Duplex Print Jobs

Load drilled paper into any tray in either the Long Edge Feed (LEF) or Short Edge Feed (SEF) direction. Refer to the following illustration:



NOTE: If you are stapling 3-hole drilled paper with the optional High Capacity Stacker Stapler 80 (HCSS80), refer to the **Accessories chapter** (see page 3-27 and page 3-43) for paper loading instructions, based on the position of the staple.

Letterhead



Different inks and dry inks/toners are used to produce preprinted letterhead that may not pass through the digital press intact.



Refer to the Specialty Media Guide: Hints and Tips for information on using preprinted letterhead paper.

Nonstandard size paper

Nonstandard size paper is identified as any paper for which there is no paper guide setting within the minimum and maximum sizes for the trays: 7.16 to 12.6 inch LEF or 7.16 to 19.2 inch SEF (182 - 320 mm LEF or 182 x 488 mm SEF)

Non-Standard size paper can be loaded into all the trays. The Non-Standard setting must be selected on the top/front of the paper tray.



Refer to the System Administration Guide for the procedure to program a Non-Standard size paper to be the default setting for a particular tray.

Auto Tray Switching

When Auto Tray Switching (ATS) is activated in the Tools Mode, the digital press automatically switches to another tray containing paper of the identical size, weight, type, and feeding orientation (SEF or LEF) when the tray being used is empty.



Refer to the System Administration Guide for the instruction on enabling ATS.

Auto Paper Selection

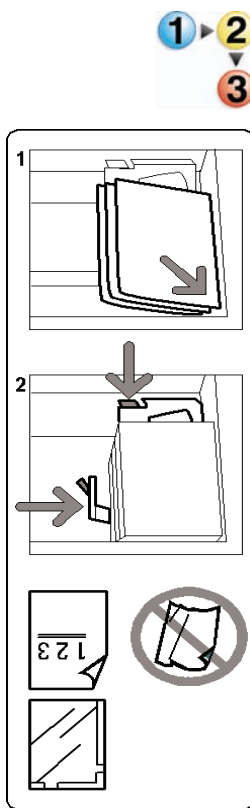
Auto Paper Selection (APS) can be enabled in the Tools Mode. When enabled, the digital press automatically selects the paper tray containing the correct size paper without a specific paper tray being selected.



Refer to the System Administration Guide for information on how to enable Auto Paper Selection or to select a particular tray as the default setting.

When the Single Paper Weight setting in Tools Mode is selected as the default setting, Auto Paper selects only 81-105 g/m² paper in the correct size. When the Mixed Paper Weight Productivity Setting is enabled, Auto Paper selects only 106-135 g/m² paper in the correct size.

Loading paper



Use this procedure to load paper in any paper tray.

1. Pull out the tray slowly until it stops.
2. Load the correct size paper into the tray in the correct feeding orientation. Refer to the orientation labels on each tray.

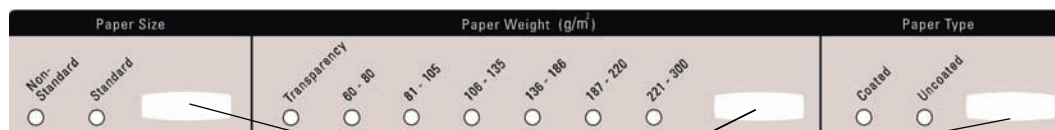
- Load the paper seam side (the side on which the ream of paper is sealed) up in all the trays.
- Do not load materials above the MAX line located on the rear Edge Guide.
- Do not store extra reams of paper in the open area of the paper trays. The tray will become inoperable until the paper is removed.



NOTE: Many suppliers use arrows on the paper ream labels to indicate the preferred side to image first. Use this side (as indicated by the arrow) as equivalent to the seam side when loading the paper.

3. Adjust the paper guides by pressing in the guide release and carefully moving the Edge Guide until it lightly touches the edge of the material in the tray.
4. Although all the trays have auto size detection capability, the paper weight (g/m^2) range must be selected on the Weight Indicator at the top/front of each tray.
 - Selecting the correct paper weight range affects the throughput performance and image quality.

- Press the **selection button** until the light next to the correct weight is illuminated.
 - Refer to the Paper Weight Conversion Tables in this chapter to convert pounds to grams.
5. Select **Transparency** if you are running transparencies.
 6. Select **Non-Standard** paper if the size indicators for the paper guides inside the tray do not show the size of the paper you are loading.
 7. Select **Coated** or **Uncoated** paper.



Selection buttons

Wordless label



Selection buttons

Paper trays air adjustment: Blowers help control the environmental conditions in the paper trays to ensure optimum print capability:

- Each paper tray has two blowers and two fans. The blowers are located in the front of each tray, while the two fans are located on the right-side of the tray.
 - The lead edge blower is on at all times and produces heated air if one of the following selections are made: Coated paper, Transparencies, or plain paper 106 g/m² or heavier. The trail edge blower is on at all times and does not produce heated air.
 - The paper trays also have air adjustment levers on the drawer to regulate the direction of the air.
8. If the paper weight is between 64 and 256 g/m², the position of the air adjustment levers should be toward the front of the tray.
9. If the paper weight is between 257 and 300 g/m², the position of the air adjustment levers should be positioned toward the rear of the tray.



Paper weight conversion tables

Specific weight conversion

Grammage g/m ²	Xerographic Bond, Writing, pounds 17 x 22" - 500 sheets	Offset, Text, Book, pounds 25 x 38"- 500 sheets	Cover, pounds 20 x 26" - 500 sheets	Index, pounds 25.5 x 30.5" - 500 sheets	Bristol and Tag, pounds 22.5 x 28.5" - 500 sheets
60	16	41	22	33	27
64	17	43	24	35	29
75	20	50	28	41	34
80	21	54	30	44	36
90	24	60	33	50	41
105	28	70	39	58	48
120	32	80	44	66	55
135	35	90	50	75	62
150	40	100	55	83	67
158	42	107	58	87	72
163	43	110	60	90	74
176	47	119	65	97	80
200	53	135	74	110	91
203	54	137	75	112	93
216	57	146	80	119	98
220	59	149	81	122	100
259	66	169	92	140	114
280	74	189	104	155	128
300	74	189	104	155	128



Yellow shading indicates grades widely used for this classification

Weight conversion ranges

Grammage g/m²	Xerographic Bond, Writing, pounds 17 x 22" - 500 sheets	Offset, Text, Book, pounds 25 x 38" - 500 sheets	Cover, pounds 20 x 26: - 500 sheets	Index, pounds 25.5 x 30.5" - 500 sheets	Bristol and Tag, pounds 22.5 x 28.5" - 500 sheets
60 - 80	17 - 21	43 - 54	24 - 30	35 - 44	29 - 36
81 - 105	22 - 28	55 - 70	31 - 39	45 - 58	37 - 48
106 - 135	29 - 36	71 - 90	40 - 44	59 - 75	49 - 62
136 - 150	37 - 40	91 - 100	45 - 55	76 - 83	63 - 67
151 - 220	41 - 59	101 - 149	56 - 81	84 - 122	68 - 100
221 - 300	60 - 74	150 - 189	82 - 110	123 - 166	101 - 128

3. Accessories



NOTE: The optional High Capacity Feeder for the DocuColor 2060/2045 may be used with the DocuColor 8000/7000. When connected, it will appear as “Tray 3” on the feature selection screens.

Trays 3 and 4 (Second Feeder Module)

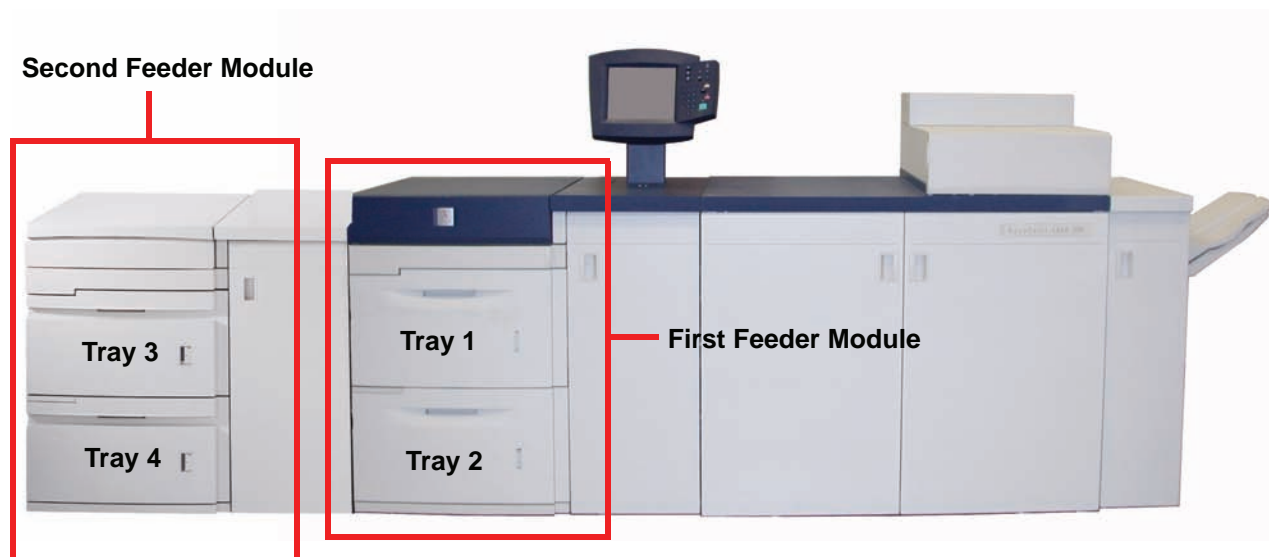
The Second Feeder Module is an optional feeding device that contains Trays 3 and 4. This module holds the same number and types of substrates as the First Feeder Module (FFM), which contains Trays 1 and 2. The First Feeder Module is not optional and is permanently connected to the digital press.

Each tray holds a maximum of 2000 sheets of 24 pound (90 g/m²) paper. Chapter 2 provides more information on using specific types of paper.



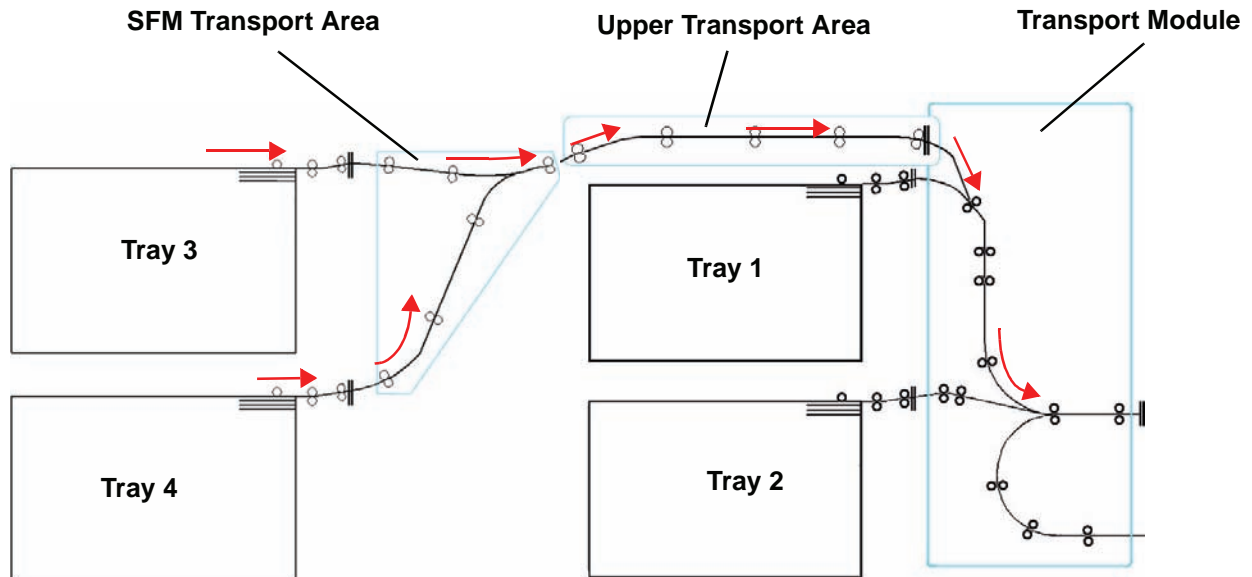
NOTE: Always refer to the *Recommended Materials List* and the *Speciality Media Guide*.

Identifying the parts



Paper path

Paper feeds from the right side of the trays. Sheets move from the transport area behind the right door of the SFM to the Upper Transport area above Paper Trays 1 and 2, then through the Transport Module and into the press.



Paper guidelines

For the best results, remember the following:

- Do not load paper or other materials above the MAX line on the rear paper guide.
- Do not store extra reams of paper in the paper trays.
- Do not use wrinkled, torn, curled, or folded paper.
- Use the paper sizes and weights shown in the *Recommended Materials List*.
- Follow the suggestions in the *Specialty Media Guide: Hints and Tips*.
- Do not mix sizes or weights of paper in a paper tray.
- Ensure that the tray indicator LEDs are set for the correct paper size, weight range, and paper type.



NOTE: *It is imperative that you load paper with the paper guides adjusted properly. If the paper is NOT loaded properly, it will skew and jams will occur.*

Paper Specifications

Paper	All Paper Trays														
Minimum Paper Size	182mm x 182mm (7.16 x 7.16")														
Maximum Paper Size	320mm x 488mm (12.6 x 19.2")														
Standard Sizes	<table> <tr> <td>B5 LEF/SEF</td><td>A4 LEF/SEF</td></tr> <tr> <td>B4 SEF</td><td>A3 SEF</td></tr> <tr> <td>8 x 10" LEF</td><td>8.5 x 11" LEF/SEF</td></tr> <tr> <td>8.5 x 13" SEF</td><td>8.5 x 14" SEF</td></tr> <tr> <td>11 x 17" SEF</td><td>12 x 18" SEF</td></tr> <tr> <td>Kai8 SEF</td><td>Kai16 LEF</td></tr> <tr> <td>12.6 x 17.7" SEF¹</td><td>12.6 x 19.2" SEF¹</td></tr> </table>	B5 LEF/SEF	A4 LEF/SEF	B4 SEF	A3 SEF	8 x 10" LEF	8.5 x 11" LEF/SEF	8.5 x 13" SEF	8.5 x 14" SEF	11 x 17" SEF	12 x 18" SEF	Kai8 SEF	Kai16 LEF	12.6 x 17.7" SEF ¹	12.6 x 19.2" SEF ¹
B5 LEF/SEF	A4 LEF/SEF														
B4 SEF	A3 SEF														
8 x 10" LEF	8.5 x 11" LEF/SEF														
8.5 x 13" SEF	8.5 x 14" SEF														
11 x 17" SEF	12 x 18" SEF														
Kai8 SEF	Kai16 LEF														
12.6 x 17.7" SEF ¹	12.6 x 19.2" SEF ¹														
Paper Weight Range	60 - 300 g/m ²														
Transparencies ²	Yes (A4 LEF or 8.5 x 11" LEF)														
Labels ²	Yes														
Transfer Paper ²	No														
Coated Paper ^{3 4}	Yes														
Tabbed Inserts ⁵	Yes														
Drilled	Yes: 2, 3, 4 hole														

¹Refer to the Non-Standard Size Paper section in this chapter.

²Refer to the *Recommended Materials List* and the Speciality Media Guide for guidelines.

³Duplex is limited to paper that is 220 g/m² or less.

⁴L80 g/m² cannot duplex in high humidity. L85 g/m² coated media is not allowed.

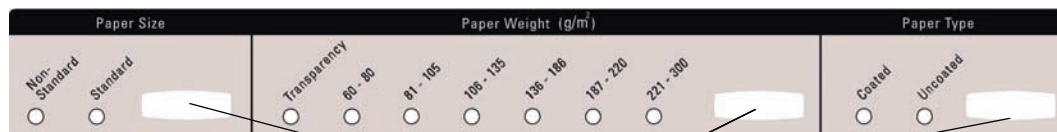
⁵Refer to the Tabbed Inserts section in this chapter.

Loading paper

There are three settings at the top front of the paper trays that must be selected so the system can make adjustments that affect the throughput performance and image quality of your prints.

- *Paper Size*: Non-Standard or Standard
Select **Non-Standard Paper** if the size indicators for the paper guides inside the tray do not show the size of the paper you are loading.
- *Paper Weight*: Transparency or weight ranges.
Select Transparency or the weight range for the paper being loaded.
- *Paper Type*: Coated or Uncoated

Press the selection button until the light next to the correct selection illuminates.



Selection buttons

Wordless label



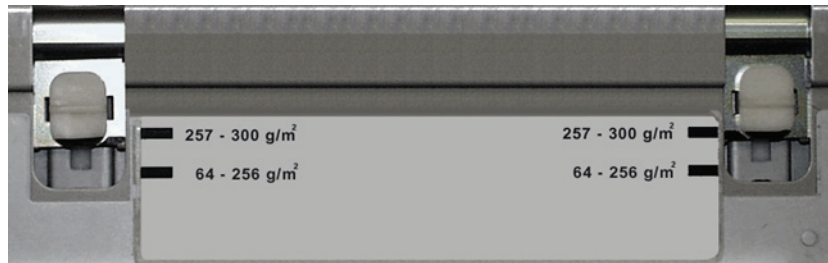
Selection buttons

Paper trays air adjustment

Blowers help control the environmental conditions in the paper trays to ensure optimum print capability:

- Each paper tray has two blowers. The lead edge blower is on at all times and produces heated air if one of the following selections are made: Coated paper, Transparencies, or plain paper 106 g/m² or heavier. The trail edge blower is on at all times and does not produce heated air.
- The paper trays also have air adjustment levers on the drawer to regulate the direction of the air. If the paper weight is between 64 and 256 g/m², the position of the air adjust levers should be toward the front of the tray. If the paper weight is between 257 and 300 g/m², the position of the air adjust levers should be positioned toward the rear of the tray.

Slide the Air Adjustment Levers to accommodate the weight of the paper loaded. Slide the lever forward for paper between 64 and 256 g/m². For papers between 257 and 300 g/m², slide levers toward the back of the tray.



Jam clearance

A paper jam anywhere in the digital press is indicated by a message on the UI. Follow the instructions displayed to clear the jam in the area or areas displayed on the screen and to resume printing. Jam clearance instructions are also provided in the *Problem Solving* chapter.

Physical characteristics

Size

41.7 inches/1060 mm W x 29.5 inches/750 mm D x 38 inches/969 mm H.

Weight

551 pounds/250 Kg.

Floor space requirements

Ask your Xerox representative to refer to the *DocuColor 8000/7000 Installation Planning Guide* for installation work space requirements.

High Capacity Stacker 80

The High Capacity Stacker 80 (HCS80) is an optional finishing device that provides stacking and offsetting capabilities for output to a Stacker Tray. The HCS80 connects to the right side of the digital press and replaces the Offset Catch Tray.



The Stacker Tray has a capacity of 3500 sheets of 24 lb (90 g/m²) centerline paper (or 370 mm high). The Top Tray has a capacity of 250 sheets of 24 lb 90 gm² centerline paper. The HCS80 is supplied with two Stacker Carts. If needed, you can purchase an additional Stacker Cart. Contact your Xerox representative for further details.



NOTE: The Stack Tray cannot support more than 99 lb. (45 kg) of printed material and therefore, cannot hold 3500 sheets of coated paper (for example SRA3).

With the HCS80 you can:

- Select Offset Mode when collated sets are sent to the Stacker Tray.
- Send documents to the top tray.
- Send sets of different sizes to either the Stacker Tray or the top tray.

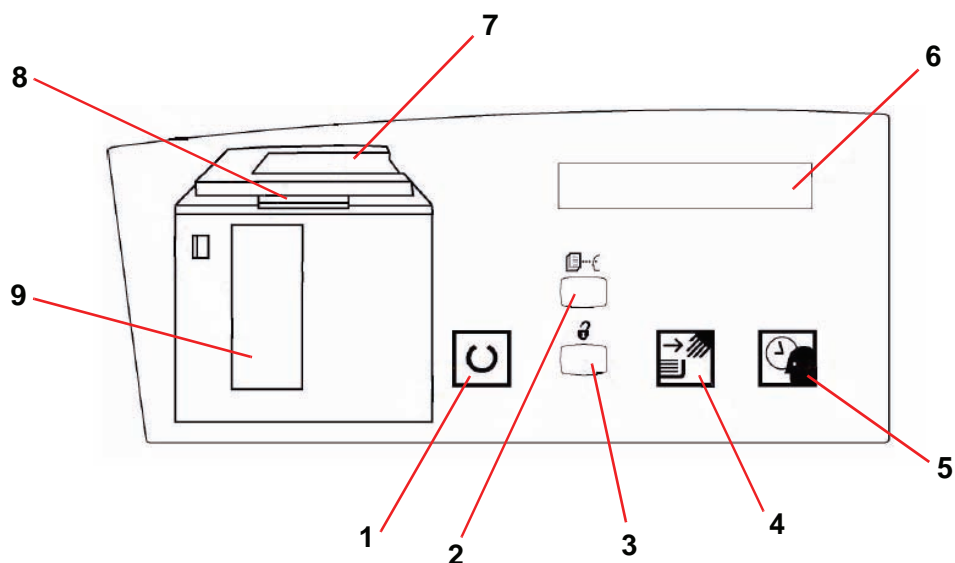


NOTE: *Do not stack larger sets on top of smaller sets. Jams could result.*

- Send a sample set to the top tray.
- Chain two stackers to the digital press and send collated sets to Stacker 1, Stacker 2 or Both Stackers.
- Send collated sets through the stacker to another connected finishing device.

Identifying the parts

Control panel

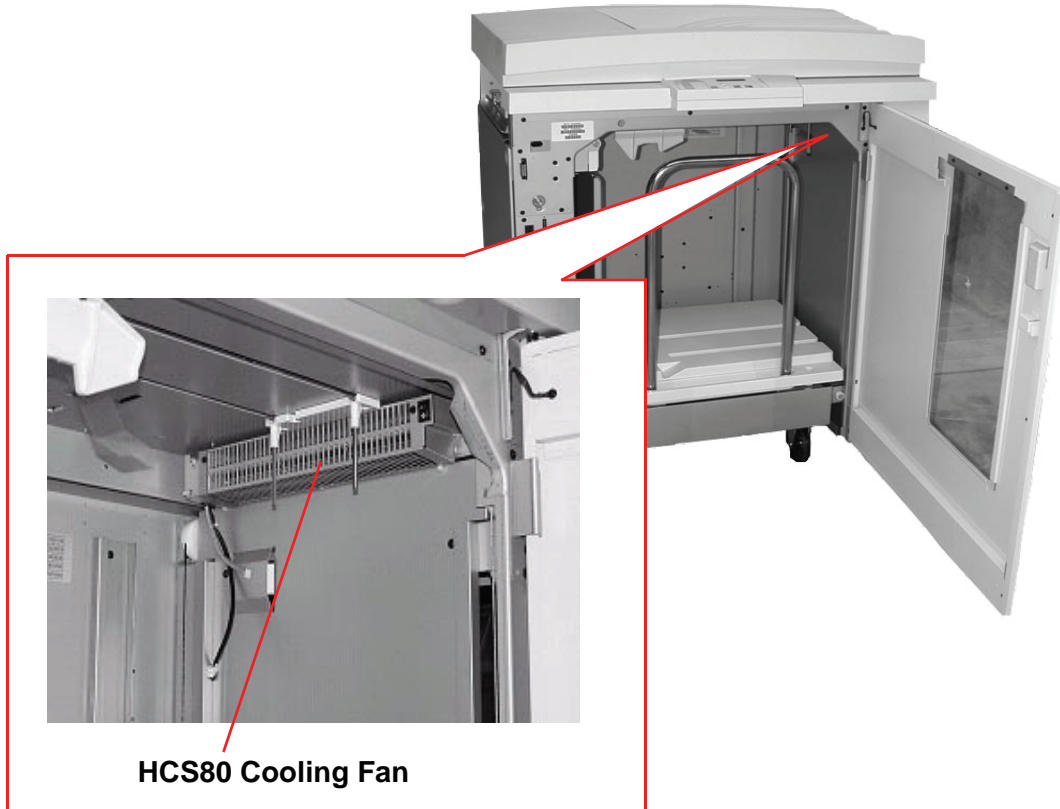


	Name	Function
1	Ready light	The Ready light blinks during initialization and is constant when the HCS80 is in use or in standby mode.
2	Sample set button	Press to have the HCS80 deliver the next collated set to the top tray.
3	Unload button	Press once to lower the Stacker Tray and unlock the front door. If pressed while running a job, all sheets in the paper path are delivered before the Stacker Tray starts to lower.
4	Unload light	Illuminates when the Stacker Tray has reached the down position and the front door can be opened.

	Name	Function
5	Wait light	Blinks when the Stacker Tray is moving up or down.
6	Fault code display	Displays a code when a fault occurs in the HCS80. Refer to the HCS80 fault code table located in the Problem Solving section of this chapter.
7	Top tray jam area	Blinks when there is a jam.
8	Bypass jam area	Blinks when there is a jam.
9	Stacker tray jam area	Blinks when there is a jam or the door is open.
	Keypad	Used by the service representative for diagnostics (not shown). The keypad is located on the front right of the control panel.

Cooling fan

The HCS80 is equipped with a cooling fan that you can switch on and off as required. The cooling fan is located inside the front door:



The cooling fan is normally **Off**. The fan must be switched **On** when you are using coated paper than weighs 120 g/m² (80 lb.) or greater.

For coated paper than weighs less than 120 g/m² (80 lb.) and for uncoated paper, the fan should be switched **Off**.

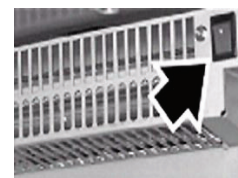
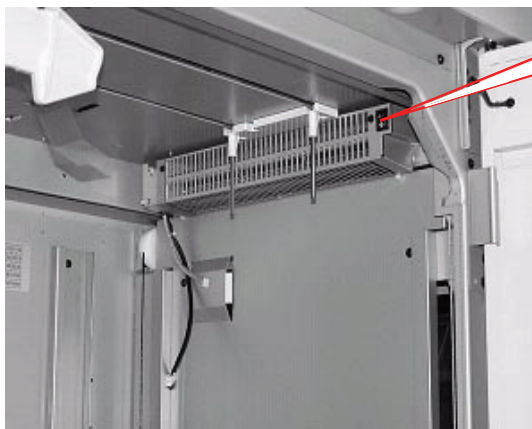


To switch **On** the cooling fan, perform the following steps:

1. Open the front door of the HCS80.



2. Press the cooling fan power switch to the **On** position.



HCS80 Power switch



KEY POINT: Only switch on the cooling fan when running paper that weighs 120 g/m² (80 lb.) or greater.



NOTE: Remember to switch off the fan after your job(s) finishes and when running paper that weigh less than 120 g/m² (80 lb.).

Paper path

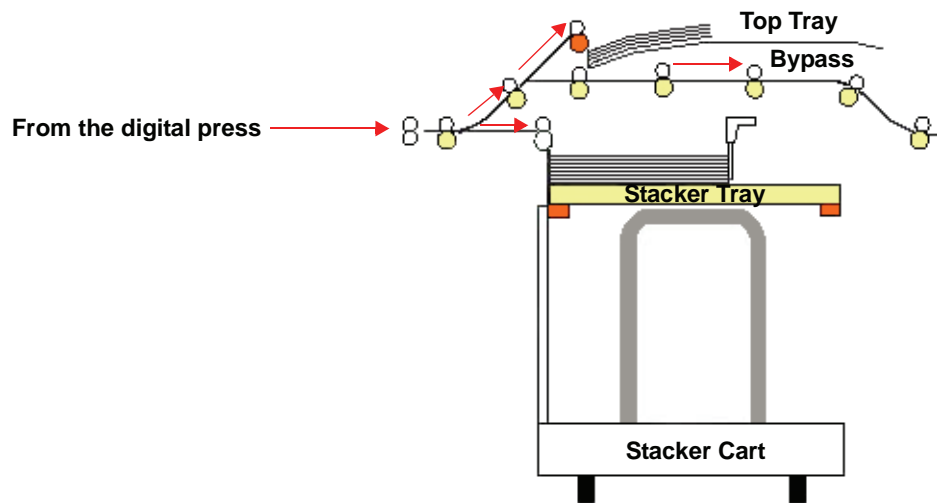


KEY POINT: Labels must be sent to the Top Tray.

Top Tray

Sheets are transported to the Top Tray:

- When sheets are purged after a paper jam.
- When the Sample Set button is selected.
- When selected as an Output Location.



Stacker Tray

Collated sets are transported to the Stacker Tray.

Bypass

The Bypass transports collated sets through the HCS80 to a connected finishing device or to another HCS80.

If your system configuration has two stackers, the bypass on the second stacker is not available.

Paper guidelines

- Stacker Tray will accept 64-280 g/m² (either coated or uncoated stock) with the possibility of degraded stock quality and increased jam rate
- Transparencies may be run to either the Top Tray or the Stack Tray. Stack height should be limited to 100 transparencies.
- Coated paper lighter than 100 g/m² may not run as reliably as coated paper heavier than 100 g/m².
- Non-standard papers longer than 305 mm (12") in the feed direction require 210 mm (8.3") minimum measurement across the feed direction.
- Non-standard papers shorter than 254 mm (10") in the cross-feed direction require 330 mm (13") minimum measurement in the feed direction.

Recommended baseline/centerline

The following papers are considered to be baseline/centerline and are recommended to ensure you receive the best quality from your HCS80:

- Uncoated: Xerox Digital Color Xpressions+, 90 g/m², 24 lbs. In Europe, Xerox Digital Color Colotech+ 90 g/m².
- Coated: Xerox Digital Color Gloss Coated Text (120 g/m² /80 lbs.) In Europe, Xerox Digital Color Colotech + Gloss Coated 120 g/m².

Paper specifications

Paper Size			Output		
Industry Designation	Inches	Orientation	Stacker Tray 60 - 300g/m ²	Bypass 60 - 300 g/m ²	Top Tray 60 - 300 g/m ²
B5	7.2 x 10.1	SEF	Yes	Yes	Yes
B5	7.2 x 10.1	LEF	Yes	Yes	Yes
A4	8.3 x 11.7	SEF	Yes	Yes	Yes
Letter	8.5 x 11	SEF	Yes	Yes	Yes
	8.5 x 13	SEF	Yes	Yes	Yes
Legal	8.5 x 14	SEF	Yes	Yes	Yes
B4	10.1 x 14.3	SEF	Yes	Yes	Yes
	11 x 14.9	SEF	Yes	Yes	Yes
Tabloid	11 x 17	SEF	Yes	Yes	Yes
A3	11.7 x 16.5	SEF	Yes	Yes	Yes
	12 x 18	SEF	Yes	Yes	Yes
SRA3	12.6 x 17.7	SEF	Yes	Yes	Yes
	8 x 10	LEF	Yes	Yes	Yes
A4	8.3 x 11.7	LEF	Yes	Yes	Yes
Letter	8.5 x 11	LEF	Yes	Yes	Yes
Kai8	10.5 x 15.3	SEF	Yes	Yes	Yes
Kai16	10.5 x 7.6	LEF	Yes	Yes	Yes
Transparencies	A4 & Letter	LEF	Yes*	Yes*	Yes*
Labels	A4 & Letter	LEF	No	Yes*	Yes*

*Customer recommendation is to run stacks of less than 100, but there is no system limit on customer selection.

Unloading the Stacker Tray

Use the following procedure to unload the Stacker Tray when it is full, or you want to retrieve a job that has been completed.



1. Press the **Unload** button on the Stacker Control Panel. The Wait light blinks until the Stacker Tray has reached the down position.
2. Open the front door when the Unload Light illuminates.
3. Position the securing bar on top of the stacked paper.
4. Pull the Stacker Cart straight out.
5. Remove the securing bar.
6. Remove the paper from the Stacker Tray.
7. Push the empty Stacker Cart straight into the HCS80.
8. Position the securing bar on the fixed area inside the HCS80.



NOTE: *The front door will not close if the securing bar is not properly attached to the stacker frame.*

9. Close the HCS80 front door.
10. Follow the instructions displayed on the digital press UI to resume printing.

Selecting Features

For jobs coming through the network, refer to the documentation that came with your color server for information on how to select stacker options on the print driver screens.

How to Enable Automatic Output Switching

If your system configuration contains two stackers, you have the option to enable Automatic Output Switching. With Automatic Output Switching, the digital press automatically selects a usable Stacker Tray to deliver your collated sets.

When the Stacker Tray becomes full or when the Unload button is selected, the digital press delivers all paper in the digital press to the same Stacker Tray and then switches to the other Stacker Tray for the rest of the job.



NOTE: *The Stacker Tray has a capacity of 3500 sheets of 24 lb (90 g/m²) centerline paper (or 370mm high). Always refer to the Recommended Materials List and the Speciality Media Guide for up-to-date information on using specific media types with the HCS80.*



KEY POINT: If Auto Tray Switching feature is not enabled, in Tools Mode, the button for Both Stackers is not selectable. For detailed information on how to enable this feature, refer to the *DocuColor 8000/7000 System Administration Guide*.

Using a DFA Finishing Device

A DFA (Digital Finishing Architecture) finishing device can be connected directly to the digital press, or the HCS80.

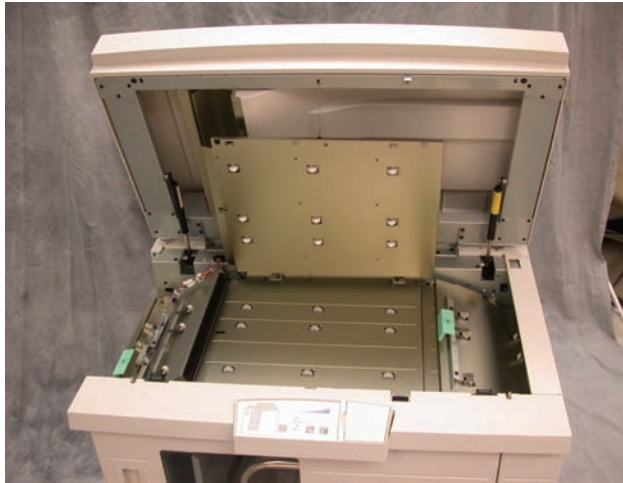
All DFA devices are installed by your Xerox service representative. Once installed, the UI screens provide Finishing Module selections.

For jobs coming through the network, refer to the documentation that came with your color server for information on how to select DFA options on the print driver screens.

Jam clearance

A paper jam in the HCS80 will be indicated by a message on the digital press UI. Follow the instructions displayed. The image on the HCS80 Control Panel will flash showing the area where the jam is located.

Clear Bypass area jam



Perform the following steps to clear the HCS80 jam in the Bypass area and resume printing.

1. Remove any paper from the Top Tray.
2. Lift the HCS80 **Top Cover**.
3. Lift the green handle, or handles, indicated on the UI and remove all paper in the Bypass area. Remove paper only from the areas indicated.
4. Close each green handle.
5. Close the HCS80 **Top Cover**.
6. If the UI indicates there is a jam in the digital press, follow the instructions on the screen to remove any paper in the area indicates. Refer to the *Jam Clearance* section in the *Problem Solving* chapter in this manual.
7. Follow the instructions displayed on the digital press UI to resume printing.

Clear Top Tray and Stacker Tray paper jams



To clear the Top Tray, remove all paper from the Top Tray.

Perform the following steps to clear a jam from the Stacker Tray area and resume printing.

1. Press the **Unload** button on the Stacker Control Panel. The Wait light blinks until the Stacker Tray has reached the down position.
2. Open the front door when the Unload Light illuminates.
3. Position the securing bar on top of the stacked paper.
4. Pull the Stacker Cart straight out.
5. Reach into the Stacker and remove any jammed paper.
6. Push the Stacker Cart straight into the HCS80.
7. Position the securing bar on the fixed area inside the HCS80.



NOTE: *The front door will not close if the securing bar is not properly attached to the stacker frame.*

8. Close the HCS80 front door.
9. Follow the instructions displayed on the digital press UI to resume printing.

Maintenance

Do not clean any area inside the HCS80. If the covers or Front Door require cleaning, dampen a paper towel or soft, clean cloth with a liquid, nonabrasive glass cleaner or water.

To avoid damage to the HCS80, do not pour or spray the cleaner or water directly onto the HCS80. Always apply the liquid to the cloth first.

Do not use any other cleaners or solvents on the HCS80 as they may interact with the paint on the covers, eventually causing the paint to peel.

Problem Solving

If, after following the recommended solutions, the problem persists, call for assistance. The Fault Codes described below appear on the HCS80 display panel.

Fault Code	Cause	Solution
212 100 212 110 212 120 212 130 212 140 212 900	Paper jam	A jam occurred during feeding. Remove sheets from jam clearance areas. Open and close the top cover and front door. A purge sheet may eject to the top tray. If the jam occurs in the second HCS80, be sure to check the Bypass area in the first HCS80.
212 251 212 252 212 253 212 254	Stacker problem	Power off, then power on.
212 302	Top Cover open	Close the top cover.
212 540	Stacker tray full	Empty the Stacker Tray.
212 541	Stacker tray position	<ul style="list-style-type: none"> Press the Unload button. The Wait light blinks until the Stacker Tray has reached the down position. When the Stacker Tray has reached the down position, open the front door. Remove the Stacker Cart. Remove all stacked paper. Position the Stacker Cart securely into the HCS80. Close the front door.
212 542	No Stacker Cart	Open the front door. Remove the Stacker Cart from the HCS80. Position the Stacker Cart securely into the HCS80. Close the front door
212 544	Door open	Close the door

Loss of Power

If power is interrupted to the HCS80:

- Ensure the power cord is plugged in to the proper wall receptacle.
- Ensure that the digital press power is on and the Ground Fault Indicator is in the On position.
- If the power has not been restored by the above procedure, call Xerox Customer Support.

Also call your Xerox service representative if the loss of power to the HCS80 seems to be frequent or excessive.

High Capacity Stacker Stapler 80 (HCSS80)

The High Capacity Stacker Stapler 80 (HCSS80) is an optional finishing device which provides stacking with offset and single or dual stapling output capabilities. Sets of up to fifty sheets of 64-80 g/m² may be stapled.

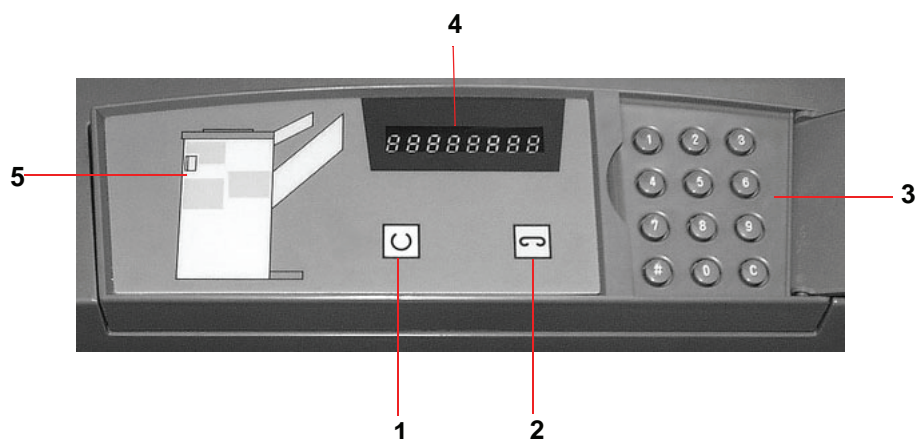
The HCSS80 must be connected to the right end of the digital press, replacing the Offset Catch Tray. The Stack Tray has a capacity of 2000 sheets of 17-21 lb. (64-80 g/m²) paper. The HCSS80 also has an Offset mode which provides separation between the stacked sets sent to the Stack Tray. The High Capacity Stacker Stapler can also send output (not stapled) of 250 sheets of 17-21 lb. (64-80 g/m²) paper to the Top Tray.

Banner sheets can be used with your color server. The banner sheets must be printed on LEF 8.5 x 11 in. paper. Refer to your color server manual for more information on how to turn this feature on.

Identifying HCSS80 Parts



Control Panel



	Name	Function
1	Ready Indicator	The Ready Indicator blinks when the digital press is being initialized. The Ready Indicator is constant when in use or in standby.
2	Staple Indicator	The Staple Indicator blinks when the staple level in the stapler is low. The Staple Indicator is constant when the stapler is empty.
3	Keypad	The keypad, including the C button, is used only by the Xerox service representative.
4	Message Display	Shows the fault codes.
5	Jam Indicator	Area illuminates to indicate the location of a jam in the HCSS80.

Electrical/environmental requirements

Western Hemisphere: 115 VAC, 15 amp, for 60 Hz. and 220 VAC, 10 amp for 50 Hz installations.

Europe: 200-240 Volt 10 amp 50 Hz service outlet.

The HCSS80 requires a separate power source from the digital press.

Environmental requirements	Minimum	Maximum
Temperature:	10° C (50° F)	32° C (90° F)
Relative Humidity (% RH):	5%	85%
Altitude:	Not applicable	Anything greater than 2000 meters (6560 ft.) above sea level may require field adjustments



NOTE: Best machine performance is achieved when conditions are maintained between 20-25° C (68-77° F).

Paper stock specifications

The HCSS80 Top Tray accepts all media types, sizes, and weights supported by the digital press. The Stack Tray accepts all standard media sizes supported by the digital press with the exception of sizes greater than A3/11 x 17 in.

Refer to the chart on the following page for information on accepted media types.

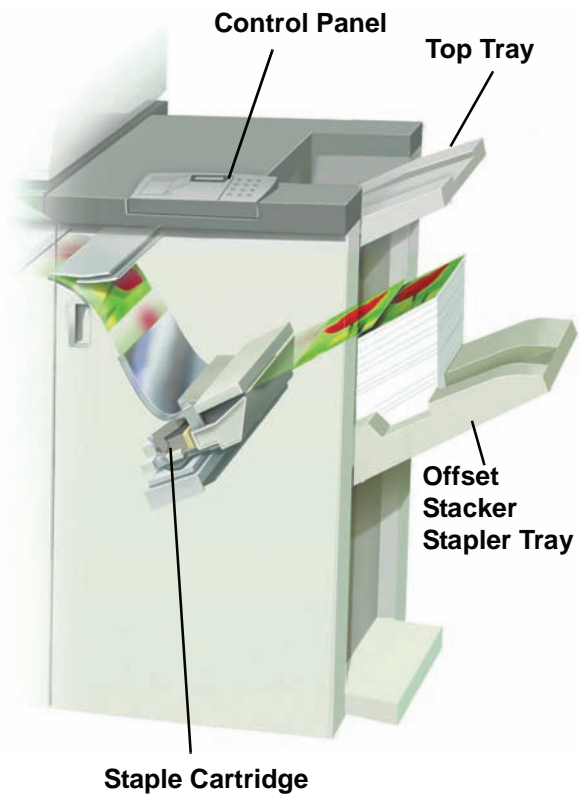
Paper Size				Output		
				Stack Tray 50 sheet maximum for Stapling*		Top Tray
Name	Inches	MM	Orientation	17-59 lb. (60-220 g/m ²) Staple Position		17-75 lb. (60-300 g/m ²)
JIS B5	7.2x10.1	182 x 257	SEF	Yes	Portrait	Yes
A4	8.3x11.7	210 x 297	SEF/LEF	Yes	Portrait/ Landscape	Yes
Letter	8.5x11	216 x 279	SEF/LEF	Yes	Portrait/ Landscape	Yes
	8.5x13	216 x 330	SEF	Yes	Portrait/ Landscape	Yes
	8.5x14	216 x 256	SEF	Yes	Portrait/ Landscape	Yes
JIS B4	10.1x14.33	257 x 364	SEF	Yes	Portrait	Yes
	11x17	279 x 432	SEF	Yes	Portrait/Dual	Yes
A3	11.7x16.5	297 x 420	SEF	Yes	Portrait/ Dual	Yes
	12x18	305 x 457	SEF	No	Not applicable	Yes
SRA3	12.6x17.7	320 x 450	SEF	No	Not applicable	Yes
	12.6x19.2	320 x 488	SEF	No	Not applicable	No
B5	7.2x10.1	182 x 257	LEF	Yes	Portrait	Yes
	8x10	203 x 254	LEF	Yes	Portrait	Yes

* Refer to the table on page 3-31 for information on the stapling capacity for various paper types and weights.



NOTE: Transparencies can be fed to both HCSS80 trays.

Paper Path



As media enters the HCSS80, it is fed to the Top Tray or to the Offset Stacker Stapler Tray, depending on your selections.

Using the HCSS80

Use the HCSS80 by sending a document through the network and making your selections under Job Properties/Parameters. If you are sending a job through the network, refer to the manuals that came with your color server for information on how to set the job Properties/Parameters when using the HCSS80.

Hints and tips

- The HCSS80 cannot staple jobs with mixed sizes of paper.
- The stacking may be skewed on the output from mixed size paper jobs.
- You can use mix-coated and uncoated stock.
- The HCSS80 accepts jobs of mixed weight papers below 59 lb. (220 g/m²).
- Only clear paper jams at the area indicated on the HCSS80 Control Panel. Do not remove paper from any other areas of the paper path.

Stapling Hints

There are three stapling options:

- **Single Staple Position 1:** The HCSS80 places a staple in the upper left corner of SEF or LEF sets.
- **Single Staple Position 2:** The HCSS80 places a staple in the bottom left corner of SEF sets only.
- **Dual Staple:** The HCSS80 places two staples closer to the top/bottom center of the sheets than a single staple.

All three of these positions are illustrated in the Staple Positions table on page 3-32.

Paper specifications for stapling


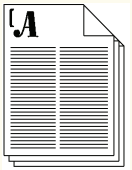





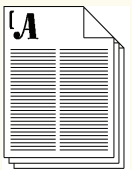





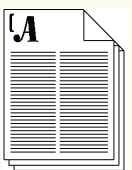

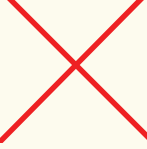
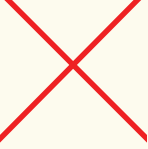
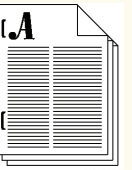












The following chart shows the stapling details for paper size, orientation, destination, and staple position. Numbers have been rounded up or down.




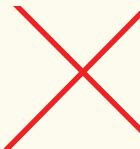





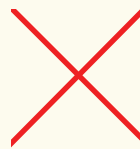


Staple Positions marked with an "O" may be selected in the position indicated. Positions marked with an "x" are not available for stapling. ^❶ Front Corner = Single Staple Position 1 ^❷ Rear Corner = Single Staple Position 2			Output Destination	Staple Position			Output Destination
Inches	MM	Sheet Orientation	HCSS80 Stack Tray 64-220 g/m ² (stapling)	Front corner ^❶	Rear corner ^❷	Dual	HCSS80 Top Tray 64-300 g/m ² (no stapling)
7.2 x 10.1	JIS B5 (182 x 257)	SEF	Yes	O	x	x	Yes
8.3 x 11.7	A4 (210 x 297)	SEF	Yes	O	O	x	Yes
8.5 x 11	216 x 279	SEF	Yes	O	O	x	Yes
8.5 x 13	216 x 330	SEF	Yes	O	O	x	Yes
8.5 x 14	216 x 356	SEF	Yes	O	O	x	Yes
10.1 x 14.3	JIS B4 (257 x 364)	SEF	Yes	O	x	x	Yes
11 x 17	279 x 432	SEF	Yes	O	x	O	Yes
11.7 x 16.5	A3 (297 x 420)	SEF	Yes	O	x	O	Yes
12 x 18	305 x 457	SEF	No	--	--	--	Yes
12.6 x 17.7	320 x 450	SEF	No	--	--	--	Yes
7.2 x 10.1	B5 (182 x 257)	LEF	Yes	O	x	x	Yes
8 x 10	203 x 254	LEF	Yes	O	x	x	Yes
8.3 x 11.7	A4 (210 x 297)	LEF	Yes	O	x	O	Yes
8.5 x 11	216 x 279	LEF	Yes	O	x	O	Yes
10.5 x 15.3	Kai 8 (267 x 388) Asian market size	SEF	Yes	O	x	x	Yes
10.5 x 7.6	Kai 16 (267 x 194) Asian market size	LEF	Yes	O	x	x	Yes



NOTE: Stapled sets of large paper (A3, 11 x 17in. and greater) may stack slightly skewed. The stapled sets will be of high quality.

Staple Positions

Size: Inches (mm)	Staple Position 1 (Front Corner)		Staple Position 2 (Rear Corner)		Dual Staple	
	SEF	LEF	SEF	LEF	SEF	LEF
7.2x10.1 JIS B5 (182x257)						
8x10 (203x254)						
8x5x11 (216x279) A4 8.5x13 (216x330) 8.5x14 (216x356)						
10.1x14.3 JS B4 (257x364) 10.5x15.3 Kai 16 (267x388: Asian market size)						
10.5x7.6 Kai 16 (267x194: Asian market size)						

Size: Inches (mm)	Staple Position 1 (Front Corner)		Staple Position 2 (Rear Corner)		Dual Staple	
	SEF	LEF	SEF	LEF	SEF	LEF
11x17 (279x432) A3						
12x18 (305x457) 12.6x17.7 (320x450)						

Stapling capacity for different paper types and weights

Following is the staple capacity for various types and weights of paper.

Paper Weight	Coated	Uncoated	Mix Sizes
64–80 g/m ²	50	50	No
81–105g/m ²	42	42	No
106–135 g/m ²	31	31	No
136–186 g/m ²	26	26	No
187–220 g/m ²	18	18	No
221–300 g/m ²	No *	No *	No
Transparencies	No	No	No

* 221 to 300 g/m² paper, either coated or uncoated, cannot be stapled. These weights will be stacked in the Top Tray.



KEY POINT: The Offset Stacker/Stapler Tray may be limited to a maximum of 50 staple sets. In order to avoid system shutdown or jams, ensure that small staple set jobs do not exceed 50 sets. Before you send a stapled-print job to the machine, enable the offset jobs feature; this will improve tray capacity.

Unloading the HCSS80

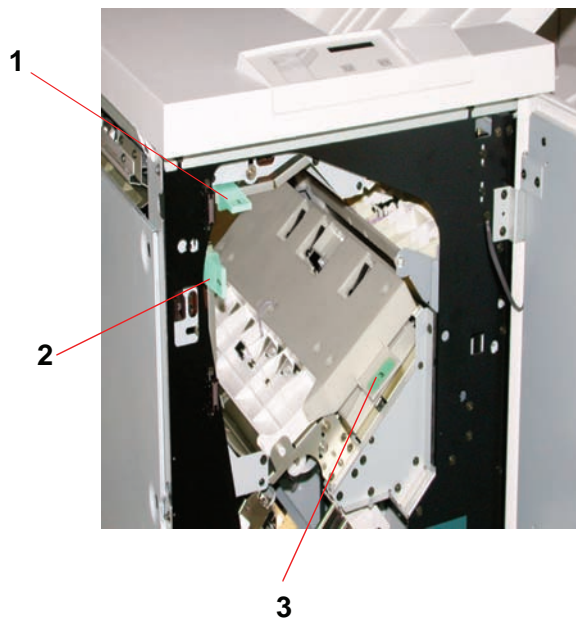
To ensure consistent quality, unload sets of less than four sheets and lighter weight paper after 50 sets are made, or when the curl of the sets inhibits the ability of the sets to exit the HCSS80.

When the Stack Tray is full, Fault Code 112-550 appears in the message display on the HCSS80. The digital press Touch Screen displays a message, "Unload the Main Tray of the Finisher."

The HCSS80 continues to stack sheets into the Stack Tray after the message appears, but excess sheets may have a degraded stacking quality. For best performance, unload the tray when 2,000 sheets have been stacked.

Jam Clearance

A paper jam in the HCSS80 is indicated by a message on the digital press Touch Screen. The HCSS80 Control Panel display illuminates the area where the jam has occurred.

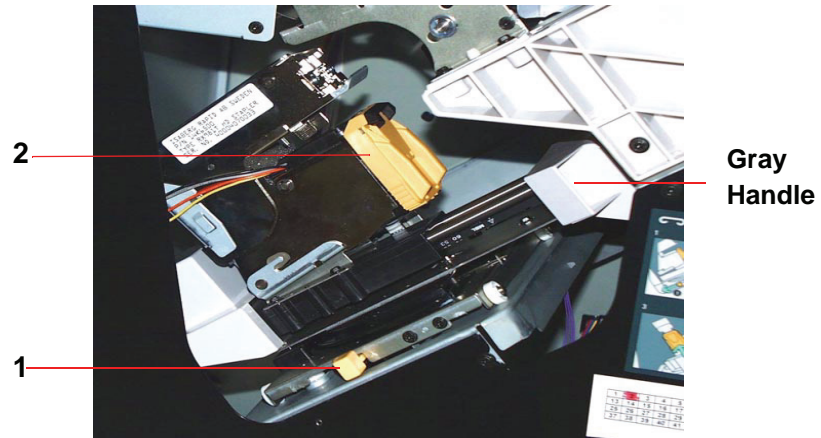


Read the following steps for more information on how to clear a jam.

1. Open the HCSS80 Front Door. There are three possible jam areas as indicated in the photo above. Handle one moves down, handle two moves to the right, and handle three moves up.
2. Remove all jammed paper only from the area indicated on the Touch Screen and the HCSS80 Control Panel Display. Do not remove paper from any other areas.
3. Reposition the handle.
4. Close the HCSS80 Front Door.
5. Follow any instructions on the Touch Screen to restart your print job.

Ordering and Loading Staples

You can order new staple cartridges through the system you normally use for ordering Xerox supplies. The cartridge number to order is 8R12799. You should keep a supply on hand so production is not interrupted while you are waiting for staples to be shipped.



1. Open the front door of the HCSS80.
2. Push the yellow (1) lever down with your left hand. Grasp the grey handle on the cartridge unit and pull it towards you until it stops. Release the yellow lever and the unit will lock into place.
3. Grasp the yellow staple cartridge and pull it towards you. The entire unit will move forward, then the staple cartridge only will pull free of the unit.
4. Insert a new cartridge into the unit, and push it until you hear it click into place.
5. Push the yellow lever down and the cartridge unit automatically swings back into place.

HCSS80 Maintenance

Cleaning the HCSS80

Do not clean any area inside of the HCSS80. If the HCSS80 covers require cleaning, dampen a paper towel or soft, clean cloth with a liquid, nonabrasive glass cleaner or water.

To avoid damage to the HCSS80, do not pour or spray the cleaner or water directly onto the HCSS80. Always apply the liquid to the cloth first.

Do not use any other cleaners or solvents on the HCSS80 or they may interact with the paint on the covers, eventually causing the paint to peel.

Problem Solving

If after reviewing the Problems and following the recommended solutions the problem persists, call for assistance.

Problem	Cause	Solution
Fault Code 112-100 Jam indicated in HCSS80, but actually is in the Exit Module.	Jammed Paper not visible in HCSS80, and fault code does not clear after opening and closing HCSS80 door.	<ul style="list-style-type: none"> • Open the HCSS80 door. • Jammed paper is not visible in the area indicated. Close the HCSS80 door. • The Touch Screen indicates a jam in the Exit Module. Open the Exit Module and clear any visible sheets. • Open and close the HCSS80 door. • Clear any other areas indicated on the Touch Screen.
Fault Code 112-100 Jam indicated in HCSS80. No visible jams in HCSS80 because sheet is located over the Exit Module sensor.	Paper jammed between Exit Module and HCSS80 sensors	<ul style="list-style-type: none"> • Open the HCSS80 door. • Jammed paper is not visible in the area indicated. Close the HCSS80 door. • If the fault code remains, open the Exit Module. No jammed sheets are visible. • Undock the HCSS80. Find the jammed sheet between the Exit Module and the HCSS80. Refer to the Note below this table for information on how to undock the HCSS80. • Clear any other areas indicated on the Touch Screen.

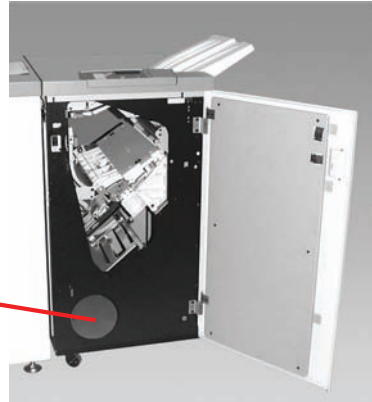
Problem	Cause	Solution
Fault Code 112-130 Jam indicated in HCSS80, but is also in Exit Module.	Paper is jammed over both the Exit Module and HCSS80 sensors.	<ul style="list-style-type: none"> • Open the HCSS80 door. • Clear any visible jams. • If no jammed paper is visible in the HCSS80 area indicated, open the Exit Module door and clear any jammed paper. Close the Exit Module door. • Open and close the HCSS80 door.
Fault Code 112-130 Jam indicated in HCSS80.	Paper is jammed between the Exit Module and the HCSS80 sensors.	<ul style="list-style-type: none"> • Open the HCSS80 door. • If no jammed paper is visible in the area indicated, open the Exit Module door and clear any jammed paper. Close the Exit Module door. • Open and close the HCSS80 door. • If the fault persists, undock the HCSS80 and clear the jammed paper between the Exit Module and the HCSS80. Refer to the Note below this table for information on how to undock the HCSS80.
Fault Code 112-110	Paper jammed in the HCSS80 and the Exit Module during a purge of sheets to the Top Tray.	<ul style="list-style-type: none"> • Clear the jammed paper from the HCSS80. • Clear the jammed paper from the Exit Module. • Open and close the HCSS80 door. • Resume job.
Fault Code 052-310	Communication problem	<ul style="list-style-type: none"> • Cancel or save the job. • Power off the digital press. Wait 15 seconds and power on.
Fault Code 052-321	Connection problem	<ul style="list-style-type: none"> • Cancel or save the job. • Power off the digital press. Wait 15 seconds and power on.
Fault Code 052-320	Unexpected connection	<ul style="list-style-type: none"> • Cancel or save the job. • Power off the digital press. Wait 15 seconds and power on.
Fault Code 052-312	Communication problem	<ul style="list-style-type: none"> • Cancel or save the job. • Power off the digital press. Wait 15 seconds and power on.
Ready Indicator does not illuminate	No power	<ul style="list-style-type: none"> • Check the power cord connected to the power source. • Check that the main switch is on.

Problem	Cause	Solution
Poor Stacking:	Mixed sizes of paper	Run separate jobs and empty stacker.
	High paper curl	<ul style="list-style-type: none"> Adjust digital press decurler. Flip paper in digital press paper tray(s). Rotate paper in the digital press paper tray(s).
	Mechanical obstruction	<ul style="list-style-type: none"> Check for obstruction in the stacker stapler paper path. Ensure that all transports and baffles are properly seated.
Paper Jams:	Use Top Tray	Deselect offset or restart job to the Top Tray.
	High paper curl	<ul style="list-style-type: none"> Adjust digital press decurler. Flip paper in digital press paper tray(s). Rotate paper in the digital press paper tray(s). Switch to heavier paper.



NOTE: To undock the HCSS from the digital press, reach into the circular area near the bottom of the HCSS for the Undocking Lever. Refer to the picture below.

Undocking
Lever inside
here



Pull the lever toward you and hold it in position while moving the HCSS a small distance (25.4mm, 1in.) away from the press. Release the lever and continue to move the HCSS as far as required.

Loss of Power

If power is interrupted to the HCSS80:

- Ensure the power cord is plugged in to the proper wall receptacle.
- Ensure that the digital press power is on.
- If the power has not been restored by the above procedure, call Xerox Customer Support.

Also call your Xerox service representative if the loss of power to the HCSS80 seems to be frequent or excessive.

Common Stacker/Stapler (CSS)

The Common Stacker/Stapler (CSS) is an optional finishing device which provides stacking with offset and single or dual stapling output capabilities. Sets of up to fifty sheets of 64-80 g/m² may be stapled.

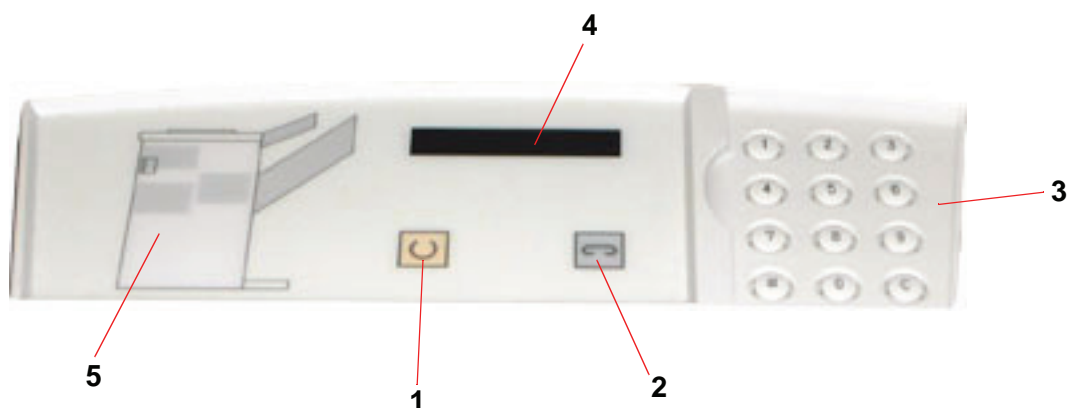
The CSS must be connected to the right end of the digital press, replacing the Offset Catch Tray. The CSS Stack Tray has a capacity of 2000 sheets of 17-21 lb. (64-80 g/m²) paper. The stacker/stapler also has an Offset mode which provides separation between the stacked sets sent to the CSS Stack Tray. The stacker/stapler can also send output (not stapled) of 250 sheets of 17-21 lb. (64-80 g/m²) paper to the CSS Top Tray.

Banner sheets can be used with your color server. The banner sheets must be printed on LEF 8.5 x 11 in. paper. Refer to your color server manual for more information on how to turn this feature on.

Identifying CSS Parts



Control Panel



Item Number	Name	Function
1	Ready Indicator	The Ready Indicator blinks when the digital press is being initialized. The Ready Indicator is constant when in use or in standby.
2	Staple Indicator	The Staple Indicator blinks when the staple level in the stapler is low. The Staple Indicator is constant when the stapler is empty.
3	Keypad	The keypad, including the C button, is used only by the Xerox service representative.
4	Message Display	Shows the fault codes.
5	Jam Indicator	Area illuminates to indicate the location of a jam in the CSS.

Electrical/environmental requirements

Western Hemisphere: 115 VAC, 15 amp, for 60 Hz. and 220 VAC, 10 amp for 50 Hz installations.

Europe: 200-240 Volt 10 amp 50 Hz service outlet.

The stacker/stapler requires a separate power source from the digital press.

Environmental requirements	Minimum	Maximum
Temperature:	10° C (50° F)	32° C (90° F)
Relative Humidity (% RH):	20%	80%
Altitude:	Not applicable	Anything greater than 2000 meters (6560 ft.) above sea level may require field adjustments



NOTE: Best machine performance is achieved when conditions are maintained between 20-25° C (68-77° F).

Paper stock specifications

The CSS Top Tray accepts all media types, sizes, and weights supported by the digital press. The CSS Stack Tray accepts all standard media sizes supported by the digital press with the including sizes that are larger than A3/11 x 17 in.



TIP: Paper that is larger than A3/11 x 17 inch cannot be stapled or offset.

Refer to the following chart for information on accepted media types.

Paper Size				Output		
				CSS Stack Tray 17-59 lb. (60-220 g/m ²)		CSS Top Tray
Name	Inches	MM	Orientation	Can feed to the Stack Tray? Yes/No	Staple Position (50 sheet maximum for Stapling*)	17-75 lb. (60-300 g/m ²)
JIS B5	7.2x10.1	182 x 257	SEF	Yes	Portrait	Yes
A4	8.3x11.7	210 x 297	SEF/LEF	Yes	Portrait/ Landscape	Yes
Letter	8.5x11	216 x 279	SEF/LEF	Yes	Portrait/ Landscape	Yes
	8.5x13	216 x 330	SEF	Yes	Portrait/ Landscape	Yes
	8.5x14	216 x 256	SEF	Yes	Portrait/ Landscape	Yes
JIS B4	10.1x14.33	257 x 364	SEF	Yes	Portrait	Yes
	11x17	279 x 432	SEF	Yes	Portrait/Dual	Yes
A3	11.7x16.5	297 x 420	SEF	Yes	Portrait/ Dual	Yes
	12x18	305 x 457	SEF	Yes	Not available	Yes
SRA3	12.6x17.7	320 x 450	SEF	Yes	Not available	Yes
	12.6x19.2	320 x 488	SEF	Yes	Not available	No
B5	7.2x10.1	182 x 257	LEF	Yes	Portrait	Yes
	8x10	203 x 254	LEF	Yes	Portrait	Yes

* Refer to the table on page 3-47 for information on the stapling capacity for various paper types and weights.

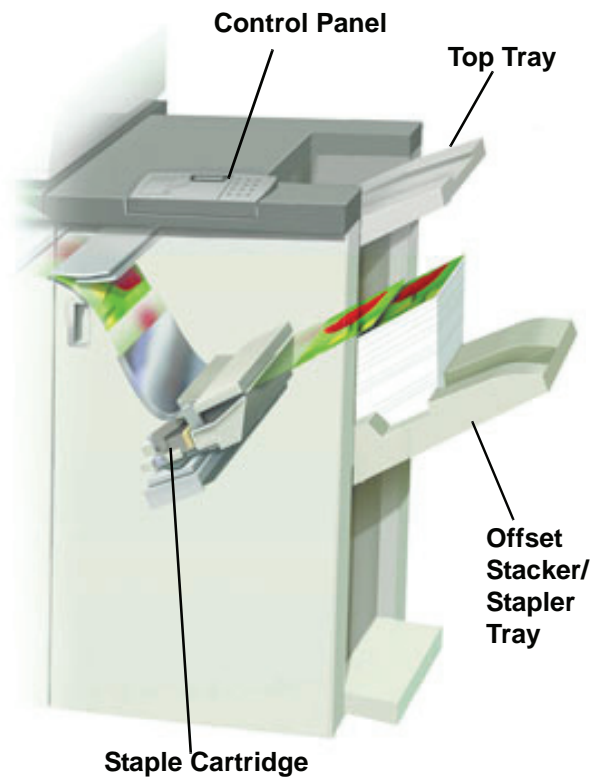


NOTE: Transparencies can be fed to both CSS trays.



TIP: Paper that is larger than A3/11 x 17 inch cannot be stapled or offset.

Paper Path



As media enters the CSS, it is fed to the CSS Top Tray or to the CSS Offset Stacker/Stapler Tray, depending on your selections.

Using the stacker/stapler

Use the CSS by sending a document through the network and making your selections under Job Properties/Parameters. If you are sending a job through the network, refer to the manuals that came with your color server for information on how to set the job Properties/Parameters when using the CSS.

Hints and tips

- The CSS cannot staple jobs with mixed sizes of paper.
- The stacking may be skewed on the output from mixed size paper jobs.
- You can use mix-coated and uncoated stock.
- The CSS accepts jobs of mixed weight papers below 59 lb. (220 g/m²).
- Only clear paper jams at the area indicated on the CSS Control Panel. Do not remove paper from any other areas of the paper path.

Stapling Hints

There are three stapling options:

- **Single Staple Position 1:** The CSS places a staple in the upper left corner of SEF or LEF sets.
- **Single Staple Position 2:** The CSS places a staple in the bottom left corner of SEF sets only.
- **Dual Staple:** The CSS places two staples closer to the top/bottom center of the sheets than a single staple.

All three of these positions are illustrated in the Staple Positions table on page 3-48.

Paper specifications for stapling

The following chart shows the stapling details for paper size, orientation, destination, and staple position. Numbers have been rounded up or down.

Staple Positions marked with an "O" may be selected in the position indicated. Positions marked with an "X" are not available for stapling. ^① Front Corner = Single Staple Position 1 ^② Rear Corner = Single Staple Position 2			Output Destination	Staple Position (Output fed to Stack Tray)			Output Destination
Inches	MM	Sheet Orientation	Stack Tray 64-220 g/m ²	Front corner ^①	Rear corner ^②	Dual	Top Tray 64-300 g/m ² (no stapling)
7.2 x 10.1	JIS B5 (182 x 257)	SEF	Yes	O	X	X	Yes
8.3 x 11.7	A4 (210 x 297)	SEF	Yes	O	O	X	Yes
8.5 x 11	216 x 279	SEF	Yes	O	O	X	Yes
8.5 x 13	216 x 330	SEF	Yes	O	O	X	Yes
8.5 x 14	216 x 356	SEF	Yes	O	O	X	Yes
10.1 x 14.3	JIS B4 (257 x 364)	SEF	Yes	O	X	X	Yes
11 x 17	279 x 432	SEF	Yes	O	X	O	Yes
11.7 x 16.5	A3 (297 x 420)	SEF	Yes	O	X	O	Yes
12 x 18	305 x 457	SEF	Yes	X	X	X	Yes
12.6 x 17.7	320 x 450	SEF	Yes	X	X	X	Yes
12.6 x 19.2	320 x 488	SEF	Yes	X	X	X	Yes
7.2 x 10.1	B5 (182 x 257)	LEF	Yes	O	X	X	Yes
8 x 10	203 x 254	LEF	Yes	O	X	X	Yes
8.3 x 11.7	A4 (210 x 297)	LEF	Yes	O	X	O	Yes
8.5 x 11	216 x 279	LEF	Yes	O	X	O	Yes
10.5 x 15.3	Kai 8 (267 x 388) Asian market size	SEF	Yes	O	X	X	Yes
10.5 x 7.6	Kai 16 (267 x 194) Asian market size	LEF	Yes	O	X	X	Yes


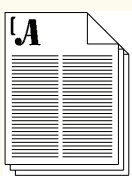





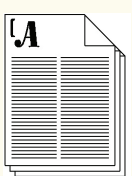




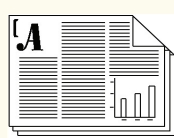
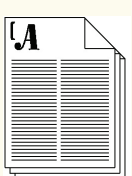



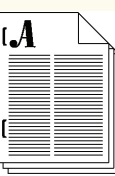







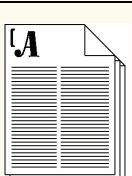


















TIP: Paper that is larger than A3/11 x 17 inch cannot be stapled or offset.



NOTE: Stapled sets of large paper (A3, 11 x 17in. and greater) may stack slightly skewed. The stapled sets will be of high quality.

Staple Positions

Size: Inches (mm)	Staple Position 1 (Front Corner)		Staple Position 2 (Rear Corner)		Dual Staple	
	SEF	LEF	SEF	LEF	SEF	LEF
7.2x10.1 JIS B5 (182x257)						
8x10 (203x254)						
8x5x11 (216x279) A4 8.5x13 (216x330) 8.5x14 (216x356)						
10.1x14.3 JS B4 (257x364) 10.5x15.3 Kai 16 (267x388: Asian market size)						
10.5x7.6 Kai 16 (267x194: Asian market size)						

Size: Inches (mm)	Staple Position 1 (Front Corner)		Staple Position 2 (Rear Corner)		Dual Staple	
	SEF	LEF	SEF	LEF	SEF	LEF
11x17 (279x432) A3						
12x18 (305x457) 12.6x17.7 (320x450)						

Stapling capacity for different paper types and weights

Following is the staple capacity for various types and weights of paper.

Paper Weight	Coated	Uncoated	Mix Sizes
64–80 g/m ²	50	50	No
81–105g/m ²	42	42	No
106–135 g/m ²	31	31	No
136–186 g/m ²	26	26	No
187–220 g/m ²	18	18	No
221–300 g/m ²	No *	No *	No
Transparencies	No	No	No

* 221 to 300 g/m² paper, either coated or uncoated, cannot be stapled. These weights will be stacked in the Top Tray.



TIP: The Offset Stacker/Stapler Tray may be limited to a maximum of 50 staple sets. In order to avoid system shutdown or jams, ensure that small staple set jobs do not exceed 50 sets. Before you send a stapled-print job to the machine, enable the offset jobs feature; this will improve tray capacity.

Unloading the stacker/stapler

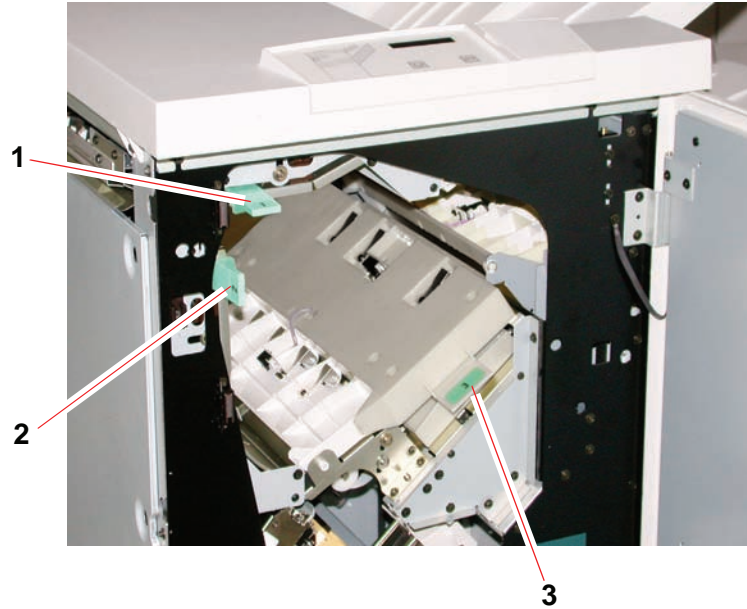
To ensure consistent quality, unload sets of less than four sheets and lighter weight paper after 50 sets are made, or when the curl of the sets inhibits the ability of the sets to exit the stacker/stapler.

When the Stack Tray is full, Fault Code 112-550 appears in the message display on the stacker/stapler. The digital press UI displays a message, “Unload the Main Tray of the Finisher.”

The stacker/stapler continues to stack sheets into the Stack Tray after the message appears, but excess sheets may have a degraded stacking quality. For best performance, unload the tray when 2,000 sheets have been stacked.

Jam Clearance

A paper jam in the stacker/stapler is indicated by a message on the digital press UI. The stacker/stapler Control Panel display illuminates the area where the jam has occurred.

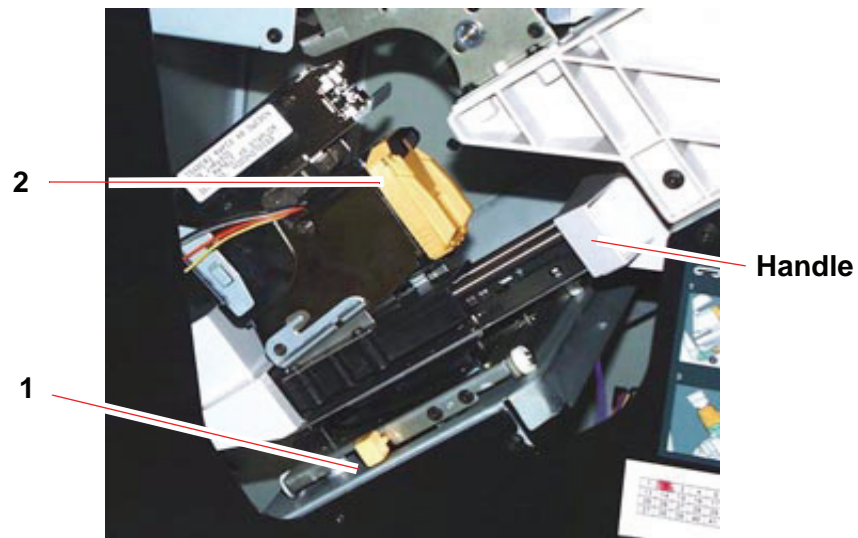


Read the following steps for more information on how to clear a jam.

1. Open the stacker/stapler Front Door. There are three possible jam areas as indicated in the photo above. Handle 1 moves down, Handle 2 moves to the right, and handle 3 moves up.
2. Remove all jammed paper only from the area indicated on the UI and the stacker/stapler Control Panel Display. Do not remove paper from any other areas.
3. Reposition the handle.
4. Close the stacker/stapler Front Door.
5. Follow any instructions on the UI to restart your print job.

Ordering and Loading Staples

You can order new staple cartridges through the system you normally use for ordering Xerox supplies. The cartridge number to order is 8R12799. You should keep a supply on hand so production is not interrupted while you are waiting for staples to be shipped.



1. Open the front door of the stacker/stapler.
2. Push the Lever 1 down with your left hand. Grasp the handle on the cartridge unit and pull it towards you until it stops. Release the lever and the unit will lock into place.
3. Grasp the staple cartridge (2) and pull it towards you. The entire unit will move forward, then the staple cartridge only will pull free of the unit.
4. Insert a new cartridge into the unit, and push it until you hear it click into place.
5. Push the yellow lever down and the cartridge unit automatically swings back into place.

Stacker/stapler Maintenance

Cleaning the stacker/stapler

Do not clean any area inside of the stacker/stapler unless otherwise directed by Xerox. If the stacker/stapler covers require cleaning, dampen a paper towel or soft, clean cloth with a liquid, nonabrasive glass cleaner or water.

To avoid damage to the stacker/stapler, do not pour or spray the cleaner or water directly onto the stacker/stapler. Always apply the liquid to the cloth first.

Do not use any other cleaners or solvents on the stacker/stapler or they may interact with the paint on the covers, eventually causing the paint to peel.

Problem Solving

If after reviewing the Problems and following the recommended solutions the problem persists, call for assistance.

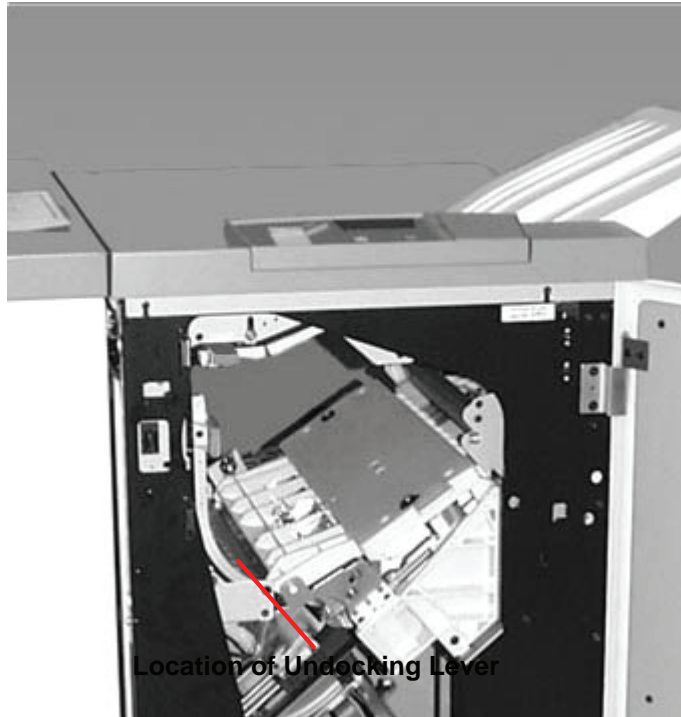
Problem	Cause	Solution
Fault Code 112-100 Jam indicated in stacker/stapler, but actually is in the Exit Module.	Jammed Paper not visible in stacker/stapler, and fault code does not clear after opening and closing stacker/stapler door.	<ul style="list-style-type: none"> Open the stacker/stapler door. Jammed paper is not visible in the area indicated. Close the stacker/stapler door. The UI indicates a jam in the Exit Module. Open the Exit Module and clear any visible sheets. Open and close the stacker/stapler door. Clear any other areas indicated on the UI.
Fault Code 112-100 Jam indicated in stacker/stapler. No visible jams in stacker/stapler because sheet is located over the Exit Module sensor.	Paper jammed between Exit Module and stacker/stapler sensors	<ul style="list-style-type: none"> Open the stacker/stapler door. Jammed paper is not visible in the area indicated. Close the stacker/stapler door. If the fault code remains, open the Exit Module. No jammed sheets are visible. Undock the stacker/stapler. Find the jammed sheet between the Exit Module and the stacker/stapler. Refer to the Note below this table for information on how to undock the stacker/stapler. Clear any other areas indicated on the UI.

Problem	Cause	Solution
Fault Code 112-130 Jam indicated in stacker/stapler, but is also in Exit Module.	Paper is jammed over both the Exit Module and stacker/stapler sensors.	<ul style="list-style-type: none"> • Open the stacker/stapler door. • Clear any visible jams. • If no jammed paper is visible in the stacker/stapler area indicated, open the Exit Module door and clear any jammed paper. Close the Exit Module door. • Open and close the stacker/stapler door.
Fault Code 112-130 Jam indicated in stacker/stapler.	Paper is jammed between the Exit Module and the stacker/stapler sensors.	<ul style="list-style-type: none"> • Open the stacker/stapler door. • If no jammed paper is visible in the area indicated, open the Exit Module door and clear any jammed paper. Close the Exit Module door. • Open and close the stacker/stapler door. • If the fault persists, undock the stacker/stapler and clear the jammed paper between the Exit Module and the stacker/stapler. Refer to the Note below this table for information on how to undock the stacker/stapler.
Fault Code 112-110	Paper jammed in the stacker/stapler and the Exit Module during a purge of sheets to the Top Tray.	<ul style="list-style-type: none"> • Clear the jammed paper from the stacker/stapler. • Clear the jammed paper from the Exit Module. • Open and close the stacker/stapler door. • Resume job.
Fault Code 052-310	Communication problem	<ul style="list-style-type: none"> • Cancel or save the job. • Power off the digital press. Wait 15 seconds and power on.
Fault Code 052-321	Connection problem	<ul style="list-style-type: none"> • Cancel or save the job. • Power off the digital press. Wait 15 seconds and power on.
Fault Code 052-320	Unexpected connection	<ul style="list-style-type: none"> • Cancel or save the job. • Power off the digital press. Wait 15 seconds and power on.
Fault Code 052-312	Communication problem	<ul style="list-style-type: none"> • Cancel or save the job. • Power off the digital press. Wait 15 seconds and power on.
Ready Indicator does not illuminate	No power	<ul style="list-style-type: none"> • Check the power cord connected to the power source. • Check that the main switch is on.

Problem	Cause	Solution
Poor Stacking:	Mixed sizes of paper	Run separate jobs and empty stacker.
	High paper curl	<ul style="list-style-type: none"> Adjust digital press decurler. Flip paper in digital press paper tray(s). Rotate paper in the digital press paper tray(s).
	Mechanical obstruction	<ul style="list-style-type: none"> Check for obstruction in the stacker stapler paper path. Ensure that all transports and baffles are properly seated.
Paper Jams:	Use Top Tray	Deselect offset or restart job to the Top Tray.
	High paper curl	<ul style="list-style-type: none"> Adjust digital press decurler. Flip paper in digital press paper tray(s). Rotate paper in the digital press paper tray(s). Switch to heavier paper.



NOTE: To undock the stacker/stapler from the digital press, reach into the circular area near the bottom of the stacker/stapler for the Undocking Lever. Refer to the picture below.



Pull the lever toward you and hold it in position while moving the stacker/stapler a small distance (25.4mm, 1in.) away from the press. Release the lever and continue to move the stacker/stapler as far as required.

Loss of Power

If power is interrupted to the stacker/stapler:

- Ensure the power cord is plugged in to the proper wall receptacle.
- Ensure that the digital press power is on.
- If the power has not been restored by the above procedure, call Xerox Customer Support.

Also call your Xerox service representative if the loss of power to the stacker/stapler seems to be frequent or excessive.

4. Problem solving

When a problem occurs with your digital press, instructions appear on the UI. Refer to the information in this chapter to help resolve the problem.

General problems

If the digital press has a loss of power and you cannot access the Machine Details screen to get the serial number, open the two main front doors. The serial number label is in the center of the bottom frame of the digital press.

The charts on the following pages lists problems and suggested solutions that apply to your digital press. If the problem persists after following all instructions, call your Xerox representative.



NOTE: *If your color server indicates that the digital press has a fault and the UI does not readily display a message, press the **Machine Status** button on the Control Panel, then touch Error Log on the UI to display the fault history.*

Problem	Suggested solutions
The digital press does not power on.	<ul style="list-style-type: none"> • Ensure the power cord is plugged into the receptacle correctly. • Ensure the power switch inside the front left door is set to the ON position. • Check the GFI circuit breakers. • If the power in your location is working properly, you have tried the suggested solutions, and the digital press does not power on, call for assistance.
Prints are not on desired paper size.	<ul style="list-style-type: none"> • Ensure that the proper paper is loaded in the paper trays. • Select the paper size, tray and weight through the digital press options on your PC. • Ensure that the correct weight is selected on the tray. • Ensure that “Fit to Paper” or an equivalent selection is not selected in your print driver.
Paper is misfed or wrinkles repeatedly.	<ul style="list-style-type: none"> • If a message appears on the UI, follow the instructions displayed and refer to the information in this chapter. • Ensure the proper paper (refer to the Paper chapter of this manual and <i>The Recommended Materials List</i>) is loaded correctly and not filled above the MAX line. • Turn the paper stack around and/or over in the selected paper tray. • Remove a few sheets from the top and the bottom of the stack in the paper tray. • Fan all four edges of the paper in the selected paper tray. • Replace the paper in the selected paper tray with paper from a new package. • Remove any partially fed paper from the trays. • Ensure the paper you are using had been stored properly.

Problem	Suggested Solution
The Touch Screen does not respond to a touch command.	<ul style="list-style-type: none">• Press Clear All on the Control Panel.• Touch a selectable button on the UI. A slight pressure is required to cause the digital press to react.• If the problem persists, open the Front Door of the digital press. Close the Front Door and make a selection on the UI. If the UI does not respond to any touch commands, switch off the power. Wait 15 seconds. Then switch on the power.
Transparencies are too oily.	<ul style="list-style-type: none">• Make 5 blank sheet copies with the Full Color option on paper stock to purge excess oil from system. Reload the transparencies and continue the copying job.• Refer to the <i>Recommended Materials List</i> and the <i>Color Materials Usage Guide</i> for more information about transparencies.
Multiple sheets feed from the paper trays.	<ul style="list-style-type: none">• Do not fill the paper trays above the MAX fill line indicator.• Remove the paper from the tray and fan the sheets to separate the joined sheets.• Predrilled sheets may stick together at the holes. Remove the paper from the tray and fan the sheets to separate the joined sheets.• Paper and transparencies may stick together if environmental conditions are too dry and cause excessive static. Increase the humidity level in the room to minimize static.• Gently fan transparencies to separate the sheets before you load them.

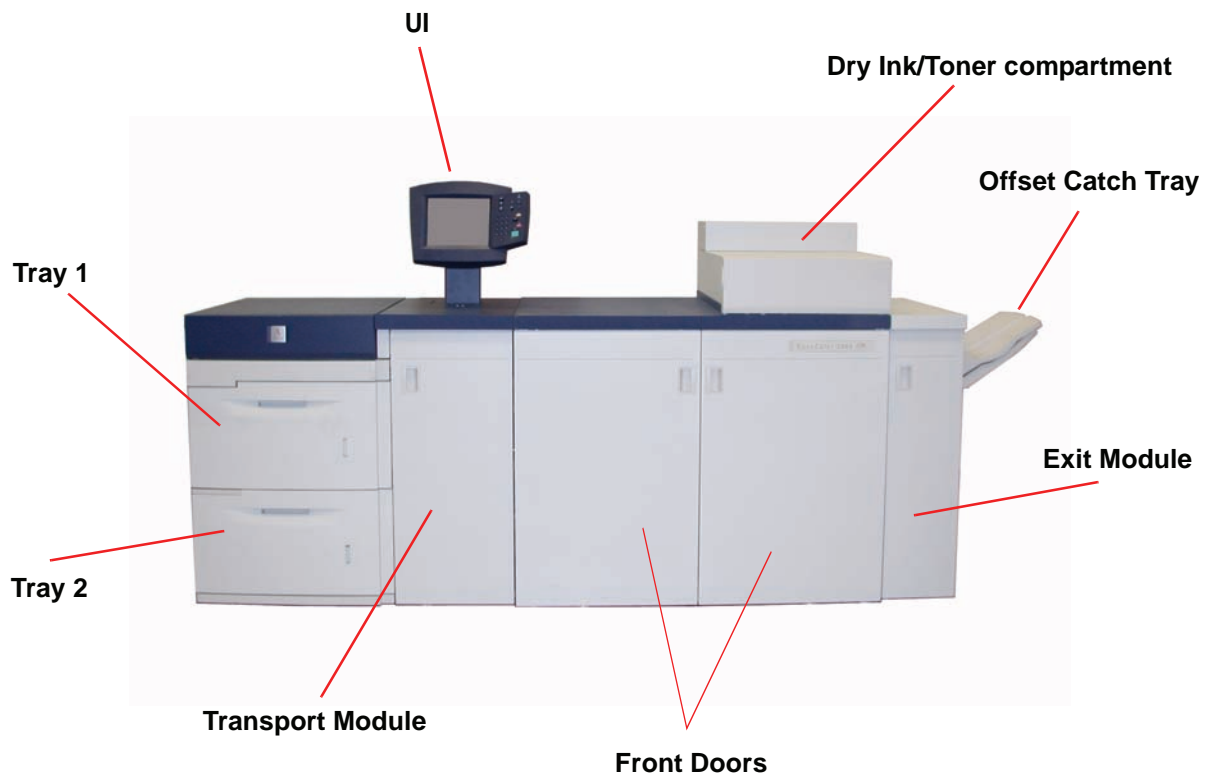
Problem	Suggested Solution
Paper jams when exiting the Paper Trays	<ul style="list-style-type: none"> • Ensure that the edge guides of the paper tray fit snugly against the paper stack. • Do not fill the paper trays above the MAX fill line indicator. • Close the tray slowly to avoid shifting the paper stack.
Output jams when exiting the digital press to the Offset Catch Tray	<ul style="list-style-type: none"> • When no other output device is present, the Offset Catch Tray can hold up to 500 sheets of 24 pound (90 g/m²) paper. Empty the catch tray when output approaches this limit to ensure continuous production. • Ensure the first sheet is not blocking the paper exit, particularly for 11 x 17 inch (A3) output.
Excessive paper curl	<p>Paper curl may be a result of:</p> <ul style="list-style-type: none"> • Ensure that the correct paper weight and paper type are selected. • The mass of dry ink (toner) coverage on the copy - the greater the toner mass, the greater the paper curl. • The paper weight. • The humidity conditions at the digital press. • You can sometimes minimize curl problems by flipping the paper over in the tray and making the copies again. If excessive curl is still present, use a heavier paper. • Empty the output device when output approaches this limit to ensure continuous production.
(continued on the next page).	

Problem	Suggested Solution
Excessive paper curl (continued).	Paper curl may be a result of an attempt to print on thicker paper or on paper stock that is less sensitive to moisture.
It is difficult to perform secondary operations on the output prints, such as writing on them or using adhesives.	This problem is caused by the oil used in the fusing process. The problem can be reduced or eliminated by setting the prints aside for one or two hours before performing a secondary operation on them. Rubbing the print surface with a soft, clean cloth or eraser may also help.

Jam clearance

If a jam occurs, the digital press stops printing and a message is displayed on the UI. Follow all instructions displayed completely and in sequence. Refer to this chapter for additional information to resolve the problem.

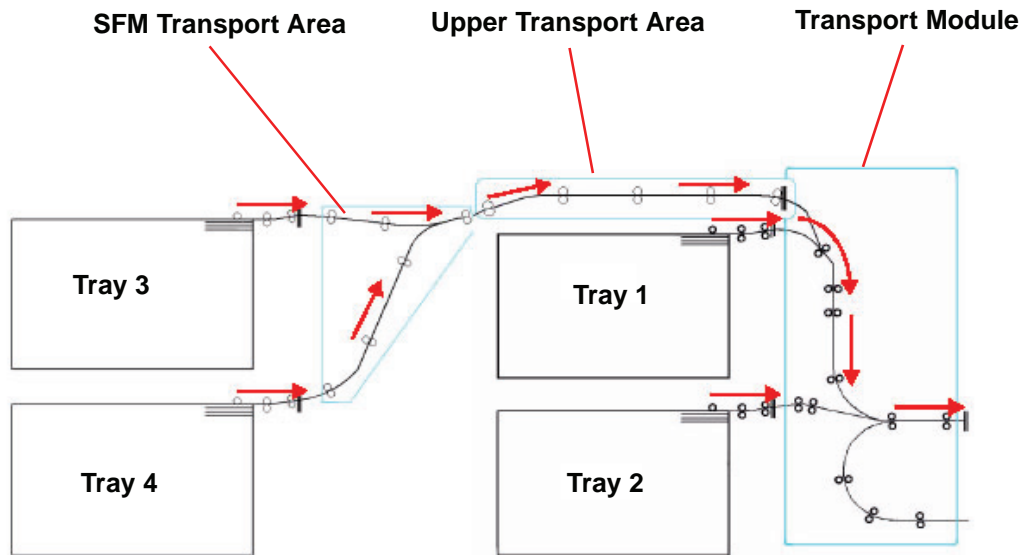
If power is interrupted during the printing process, it is imperative that you clear all other jam areas before you open and clear areas behind the Right and Left Front Doors of the digital press. The following illustration shows the various parts of the digital press. Follow the jam clearance instructions on the UI.



Paper tray jams



CAUTION: Be careful of the Feed Heads and the Feed Rolls. They can be damaged with rough treatment.



The UI displays an animation showing the tray containing the jam.

1. Open the tray with the jam.



CAUTION: If you hear paper tearing, stop opening the tray. Open the door of the Transport Module or the SFM Transport Area and clear the paper from the Transport Module before attempting to open the tray again.

2. Carefully remove all jammed paper.
3. Use the UI to determine if further jams exist and clear those areas.

Upper Transport Area jam

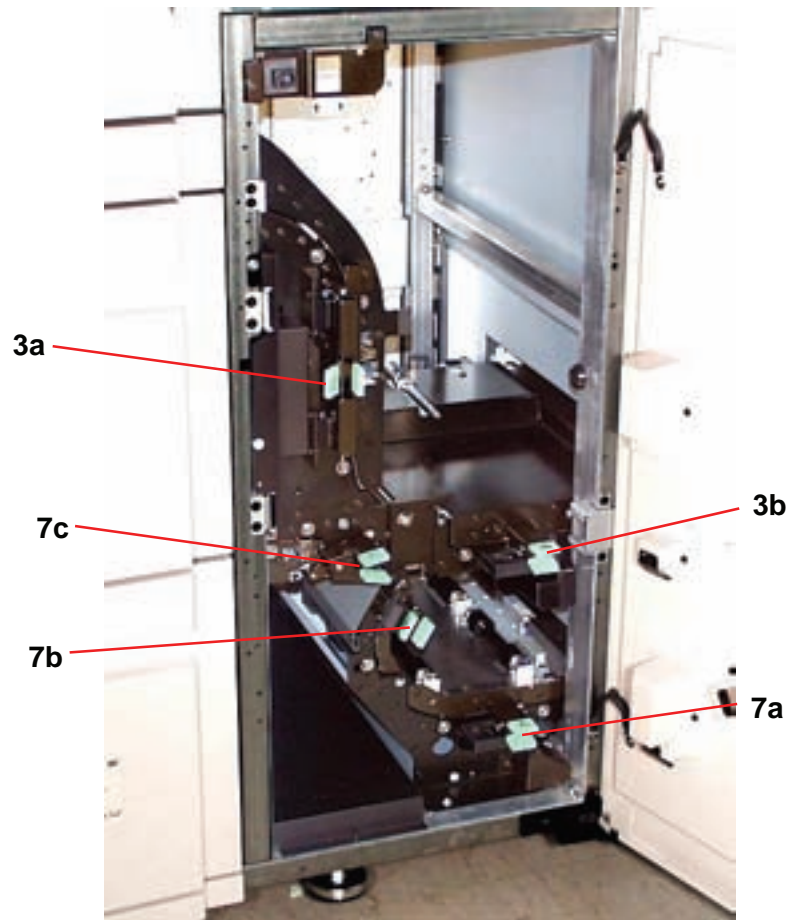
Jams occur in this area only when the Second Feeder Module containing Trays 3 and 4 is connected.



1. Pull out the Transport Area drawer above Tray 1.
2. Lift up the handle.
3. Remove all jammed paper.
4. Return the drawer to its original position.
5. Follow the instructions on the UI to clear other areas or to resume your print job.

Transport Module jams

Open the areas in the Transport Module indicated on the UI.
Carefully remove all jammed paper.

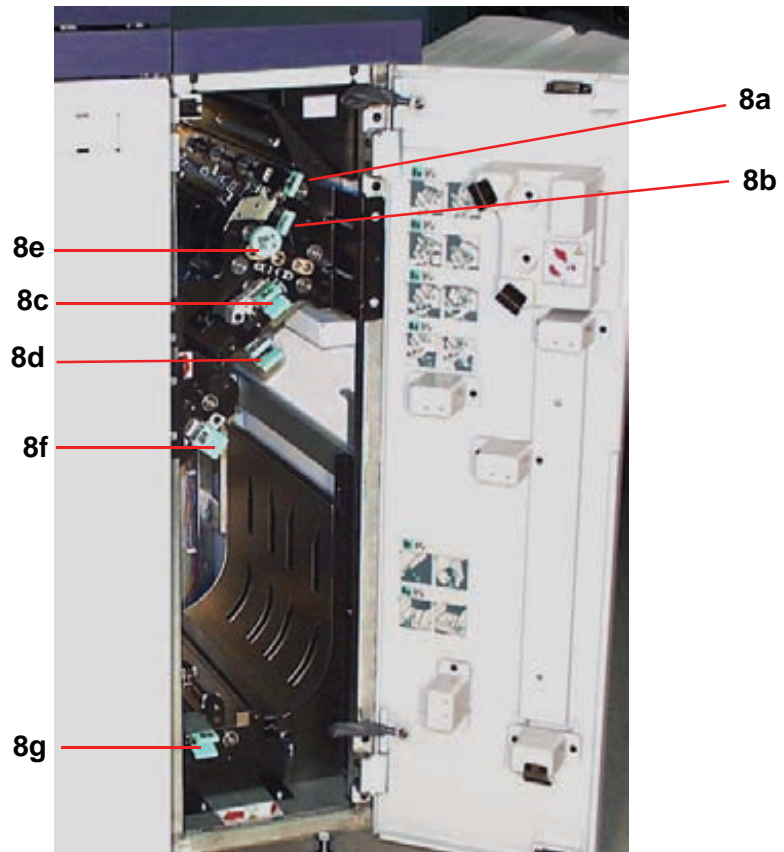


1. Open the Transport Module door.
2. Grasp the green handles 3a, squeeze and move it to the right.
3. Carefully remove all jammed paper.

4. Reposition handles 3a.
5. Lift up green handles 3b.
6. Carefully remove all jammed paper and return handles 3b to the original position.
7. Follow the UI messages and, if required, lift handles 7a and remove all jammed paper. Return handles 7a to the original position.
8. Squeeze handles 7b and lower to the right. Remove all jammed paper. Return handles 7b to the original position.
9. Squeeze handles 7c and lower to the left. Remove all jammed paper. Return handles 7c to the original position.
10. Close the Transport Module door.
11. Follow the instructions on the UI to restart your print job.

Exit Module jams

Follow the instructions on the UI to clear jams from all the areas indicated in the Exit Module. The following picture shows the areas where jams could be located.



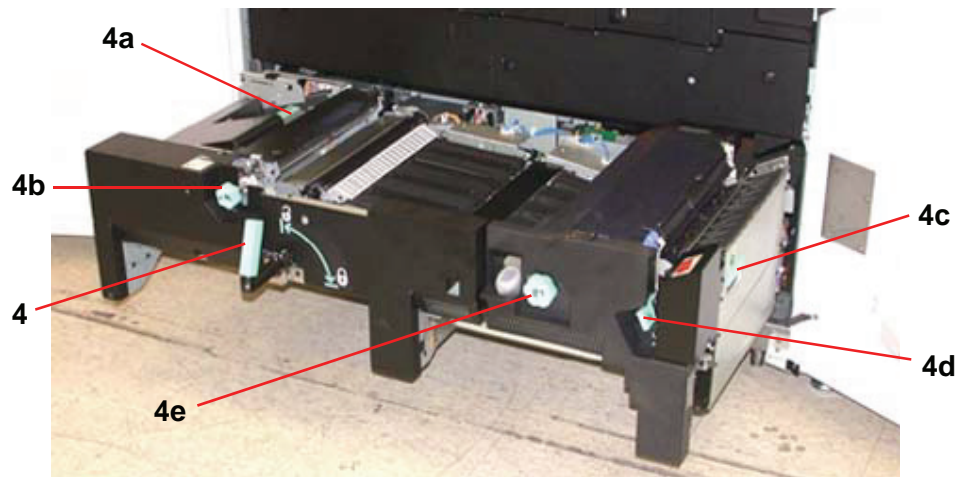
Follow the instructions on the UI to restart your print job.

Right/left door paper path jams

Always follow the instructions on the UI to locate and clear jams.



KEY POINT: It is imperative that you clear all other jam areas before you open and clear the Right and Left Front Door areas.



CAUTION: Be careful when clearing jams in the Fuser area, The Fuser is extremely hot and will cause injury.



1. Open the Right and Left Front Doors when directed to by a UI message.
2. Grasp handle 4 and move it in the direction of the arrow.
3. Slowly pull out the Paper Transport module until it stops.
4. Lift handle 4a and carefully remove all jammed paper, ensuring that all pieces are removed if the paper is torn. Turn the green handle 4b to free any paper that is caught.
5. Reposition green handle 4a.

6. The Fuser area is on the right hand side of the Paper Transport module. Lift handle 4c on the right hand side and pull to open.
7. Lift up handle 4d until it stops and clear any jammed paper. Rotate knob 4e in the direction of the arrow on the knob to clear any paper that is caught.



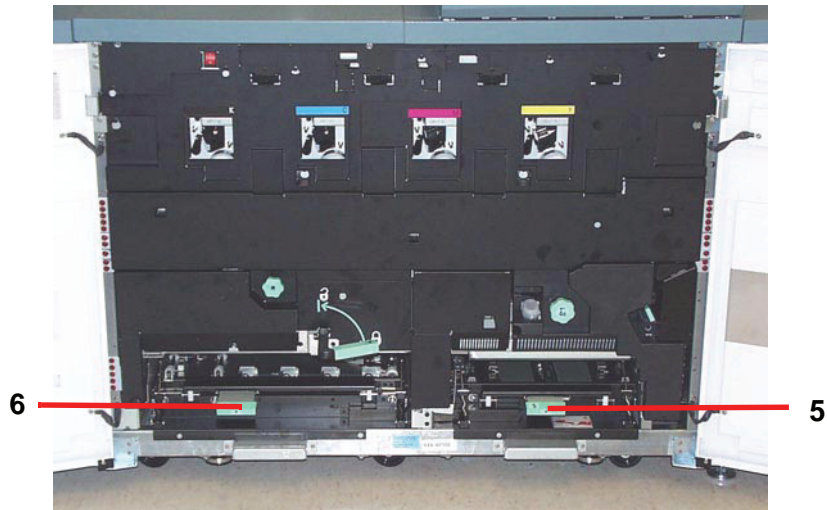
NOTE: Occasionally a sheet of paper wraps around the heat roll. (The heat roll is visible when handle 4d is up). DO NOT attempt to remove this sheet of paper because the stripper fingers may be damaged if you attempt this procedure. Call your Xerox service representative to remove this piece of paper.

Reposition green handle 4d and close area 4c. Ensure these are firmly in place.

8. Grasp handle 4 and slowly push in the Paper Transport until it stops. Turn the handle in the direction of the arrow to lock the module in place.
9. Close the Right and Left Front Doors.
10. Follow the instructions on the UI to restart your print job.

Jam clearance with 2-sided printing

When printing 2-Sided output, the UI will direct you to clear the following areas if a jam occurs.



CAUTION: Be careful when clearing jams in the Fuser area, The Fuser is extremely hot and will cause injury.



1. Lift handles 5 and 6 and clear any paper in the areas.



CAUTION: Paper can rip if not pushed back before removing it from under the lip of this area.

2. Push the paper back until you see the front edge, then remove the paper.
3. Reposition handles 5 and 6 by closing firmly.
4. Close the Right and Left Front Doors.
5. Follow the instructions on the UI to restart your print job.

Fault Codes

When there is a problem with the digital press or an accessory, refer to the UI where the Fault Code and a solution will be displayed. Follow all steps until the problem is corrected. If the problem persists, call one of the following numbers for assistance.

Follow the instructions below before calling for service.



1. Be prepared to provide a complete description of the problem to the service operator. Defining the problem accurately may help you and the operator solve the problem over the phone and minimize downtime. If the problem cannot be solved by telephone, a service representative will be dispatched to your site promptly.
2. Record the displayed Fault Codes.
3. Record the Machine Serial Number. Press the **Machine Status** button on the Control Panel. Touch the **Machine Details** tab and the serial number is displayed. (If the serial number is not displayed, open the Right/Left Front Doors of the digital press. The serial number is also on a white label on the bottom front frame.)
4. If copy quality is a problem, take a copy sample to the telephone with you to help you describe the problem or to assist you when answering the questions from the service operator about the defects.
5. If possible, use a phone near the press when calling for assistance. Follow the instructions provided by the operator.
6. For system support, user help, and service support, call the appropriate number:

US: **1-800-821-2797** (Includes TTY support)

Canada: **1-800-939-3769**

Europe: _____

Latin America: _____

Xerox also provides web-based customer support. Go to:

www.xerox.com/eSupportCentre

5. Technical Data

Digital Press Specifications

Electrical Power

Specifications

200-240V - 50/60 Hz

Single phase - Three wire plus safety ground

Current service - 30 Amp sole use @ 200V to 240V, 60Hz

Range (line to neutral) - 200 V minimum to 240 V maximum

Frequency - 50/60 Hz

Power Consumption

Standby - 2.8 kW

Run - 6 kW

Power Saver - 45W

Warm-up Time

Within 7 minutes from power on or from Power Saver Mode.

First Print Out Time

16 seconds maximum.

Environmental Requirements

The DocuColor 8000/7000 will enter the Power Saver mode after 15 minutes of no activity on the machine.

The factory default time of 15 minutes can be changed in the Tools Mode.

Ambient Temperature and Humidity

10 to 32°C, 15 to 85% RH

50 to 90°F, 15 to 85% RH



NOTE: Above 82°F (28°C), reduced humidity is required to maintain the specified performance.

Altitude

Normal operation: 0 to 2,500 meters (0 to 8,200 feet).

Operation between 2,000 to 2,500 meters (6,557 to 8,200 feet) may require a field adjustment.

Illumination

Normal function (free from print quality defects) can be expected under 3,000 lx maximum.

Noise Levels

	Continuous Noise	Impulse Noise
Standby	55 dB	N/A
IOT Operation	78 dB	83 dB
Full System Operation	81 dB	89 dB

Ozone Emissions

Not to exceed 0.015 mg/m³

Dust

0.4mg/m³ or less per Environment Product Safety Manual, PS-22B008

Capabilities

Tray Capacity

All paper trays (First and Second Feeder modules) have a capacity of 2000 sheets each of 24 pound, 90 g/m² paper.

Throughput

All paper trays:

Type: Coated or uncoated paper, transparencies

Sizes: Minimum = 182mm x 182mm (7.16 x 7.16")

Maximum = 320mm W, 488mm L (12.6 x 19.2")

Weights: 60g/m² to 300g/m²

Size/Loading Orientation:

B5 SEF/LEF

A4 SEF/LEF

B4 SEF

A3 SEF

8 x 10" LEF*

8.5 x 11" SEF/LEF

8.5 x 13" SEF

8.5 x 14" SEF

11 x 17" SEF

8 Kai SEF (267mm x 388mm)

16 Kai LEF (267mm x 194mm)

12 x 18" SEF

12.6 x 17.7 SEF

Print Rates

Use the Productivity Setting in the Tools Mode to optimize the throughput speed for the weight of the paper you are using.

- Selecting **Single Paper Weight** sets the Fuser temperature to 160°C, which optimizes the throughput speed for light and heavy weight papers, according to the weight range that is set in the paper tray, and uses less power.
- Selecting **Mixed Paper Weight** sets the Fuser temperature to 175°C, which optimizes the throughput speed for mixed paper weights from different paper trays, and uses more power.

Refer to the *System Administrator Guide* for the procedure to change the setting.

The following chart illustrates the print speeds for the two modes using 8.5x11" or A4 paper fed LEF.

:

DocuColor 8000/7000								
Substrate	DocuColor 8000				DocuColor 7000			
	Single Paper Weight		Mixed Paper Weight		Single Paper Weight		Mixed Paper Weight	
	1 Sided	2 Sided	1 Sided	2 Sided	1 Sided	2 Sided	1 Sided	2 Sided
60 - 80 g/m ²	80 ppm	40 ppm	80 ppm	40 ppm	70 ppm	35 ppm	70 ppm	35 ppm
81 - 105 g/m ²	80 ppm	40 ppm	80 ppm	40 ppm	70 ppm	35 ppm	70 ppm	35 ppm
106 - 135 g/m ²	80 ppm	40 ppm	60 ppm	30 ppm	70 ppm	35 ppm	60 ppm	30 ppm
136 - 186 g/m ²	60 ppm	30 ppm	60 ppm	30 ppm	50 ppm	25 ppm	50 ppm	25 ppm
187 - 220 g/m ²	60 ppm	30 ppm	40 ppm	20 ppm	50 ppm	25 ppm	40 ppm	20 ppm
221 - 300 g/m ²	40 ppm	-----	40 ppm	-----	35 ppm	-----	35 ppm	-----
Transparencies	30 ppm	-----	30 ppm	-----	30 ppm	-----	30 ppm	-----

*ppm = prints per minute

Physical Characteristics

Digital Press Size

Basic configuration of First Feeder Module, Digital Press with Exit Module, and Offset Catch Tray is 114.8 inches/2916 mm (W) x 43.5 inches/1105 mm (D) x 55.6 inches /1413 mm (H).

Digital Press Weight

2205 pounds/1000 Kg

Floor Space Requirements

Minimum space requirements for the basic configuration of the digital press, not including a color server:

158.3 inches/4020mm W x 134.8 inches/3425mm D.

Metric Conversion Chart



NOTE: Note that most numbers are rounded off.

Inches	Millimeters (mm)	Inches	Millimeters (mm)	Inches/ International Sizes	Millimeters (mm)	Celsius (°C)	Fahrenheit (°F)
0.01	0.254	6	153	13.5	343	10	50
0.04	1	7.2	183	14.0	356	32	90
0.05	1	7.3	185	8.0	203	100	212
0.1	3	7.5	190	15.75	400	200	392
0.15	4	7.8	198	16.9	429	204	400
0.2	5	8.0	203	17.0	432	218	425
0.25	6	8.3	211	24.0	610		
0.28	7	8.4	213				
0.3	7	8.5	216				
0.5	13	8.7	221	5 x 8	127 x 203		
0.6	15	9.0	229	8 x 10	203 x 254		
0.7	18	10.0	254	8 x 11	203 x 279		
0.8	20	10.5	267	A4	210 x 297		
1	25.4	10.8	274	8.5 x 11	216 x 279	Kilo-grams	Pounds
1.4	36	11.0	279	8.5 x 13	216 x 330	1.0	2.205
1.5	38	11.1	282	8.5 x 14	216 x 356	0.454	1.0
1.7	43	11.15	283	8.7 x 14	221 x 356		
1.9	48	11.5	292	9 x 11	229 x 279		
2	51	11.8	300	9 x 14	229 x 356		
2.3	58	11.85	301	11 x 17	279 x 432		
2.5	64	12.5	318	A3	297 x 420		
3	76	13.0	330	12 x 17	305 x 432		
4	104	13.4	340	12 x 18	305 x 457		
5	127	13.45	342	SRA3 12.6 x 17.7	320 x 450		

6. Maintenance

This chapter describes the consumable supply replenishment procedures necessary for keeping your DocuColor 8000/7000 operating reliably.

For troubleshooting problems, refer to the Problem Solving Section of this manual. Problems that cannot be solved need to be referred to your Xerox service representative. Use the procedure in this section when it becomes necessary to request a service call.

The procedure for ordering supplies and a list of the supplies you should keep on-hand are also included in this chapter.

Cleaning procedures

Cleaning the digital press

If the exterior surfaces require cleaning, dampen a paper towel or a soft, clean cloth with a liquid, nonabrasive glass cleaner or water.



WARNING: Do not use any other cleaners or solvents on the digital press as they may interact with the paint on the covers, eventually causing the paint to peel.



WARNING: DO NOT pour or spray liquid directly into any of the paper trays. Always apply the liquid to the cloth first.

Cleaning the UI Touch Screen

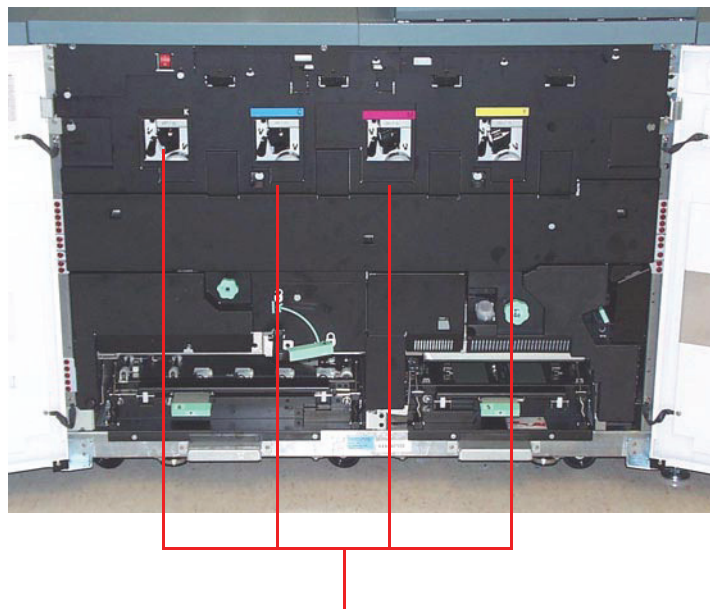
Clean the UI Touch Screen during the digital press warm-up cycle at the start of each day. Remove all dust and fingerprints by wiping the screen with a clean, lint-free cloth.



CAUTION: To avoid damage, do not use any Xerox cleaner, water, or commercial cleaner on the Touch Screen.

Cleaning the Charge Corotrons

There are four Charge Corotron units located behind the front doors of the digital press, one for each dry ink/toner color: Black, Cyan, Magenta, and Yellow.

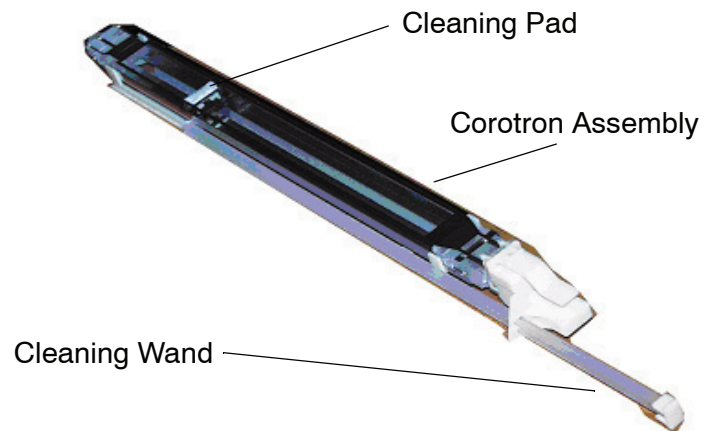


Charge Corotron Assemblies



KEY POINT: Each corotron unit should be cleaned one time daily in order to provide optimum image quality on your prints.

Each corotron assembly is equipped with a cleaning pad and a cleaning wand which makes it very easy to clean the corotron.



NOTE: The picture above shows the Corotron Assembly removed from the digital press. You do not need to remove the assembly in order to clean the Corotron Pad. This picture is for reference only.



KEY POINT: The cleaning pad and wand are components of the Corotron Assembly; they are not separate parts.



Use the following procedure for daily cleaning your corotrons:



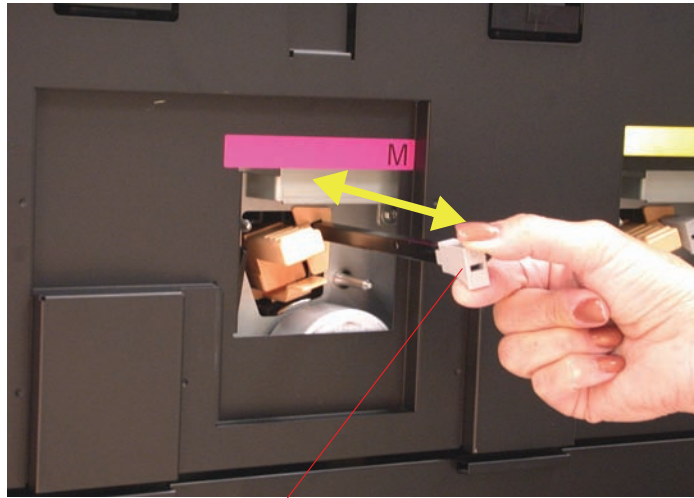
NOTE: *It is recommended that you perform this procedure at the start of every day and after every 5,000 prints.*

1. Open the front doors of the digital press.



Front doors

2. Clean each corotron by **slowly** pulling out and pushing in the Cleaning Wand one time.



Slowly pull out the wand,
then push it back in



KEY POINT: To ensure proper cleaning of the pad, **slowly** pull out the wand **until it reaches the end of the assembly; it will stop when it reaches the end.** Slowly push in the wand until it is fully seated against the corotron assembly.

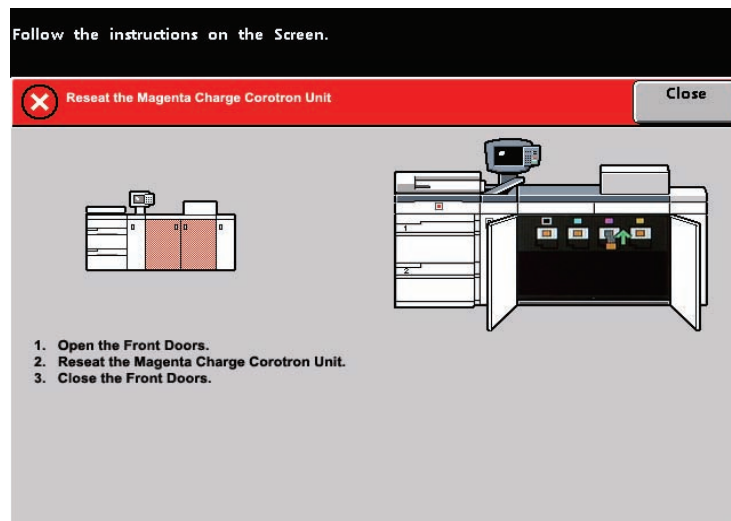


CAUTION: To avoid damage to the corotron assembly, **carefully** and **slowly** pull out the Cleaning Wand. Once the wand reaches the end of the assembly, it stops. Do not continue to pull on the wand as this will remove the wand from the Corotron Assembly, thereby damaging the assembly. If this occurs, you must replace the entire Corotron Assembly.

3. Ensure that the Cleaning Wand is pushed in completely.



- If it is not seated properly, the User Interface will display the following screen:

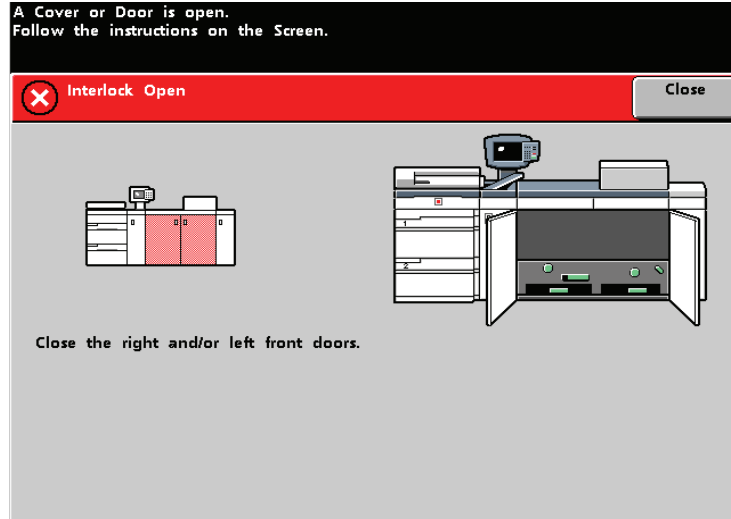


- Repeat Steps 2 and 3.



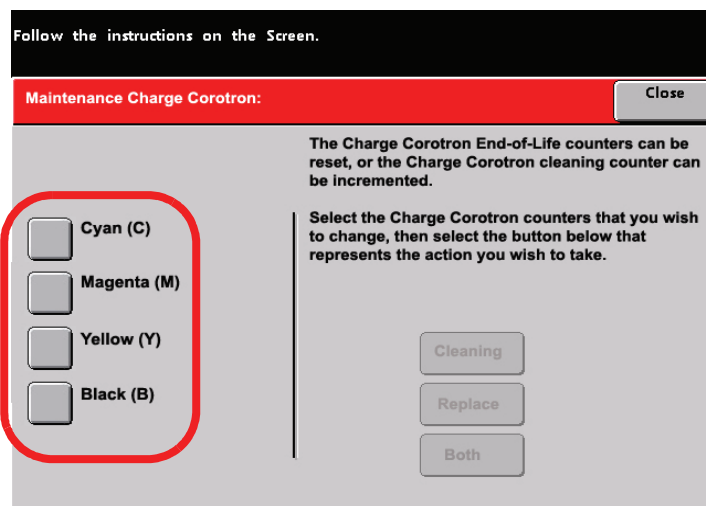
CAUTION: If any problems occur while cleaning the pad or reseating the wand, and/or if the above screen is continually displayed, call your Xerox service representative for assistance.

4. Once the Corotron Cleaning Wand is properly seated in the corotron assembly, the User Interface displays the following message:

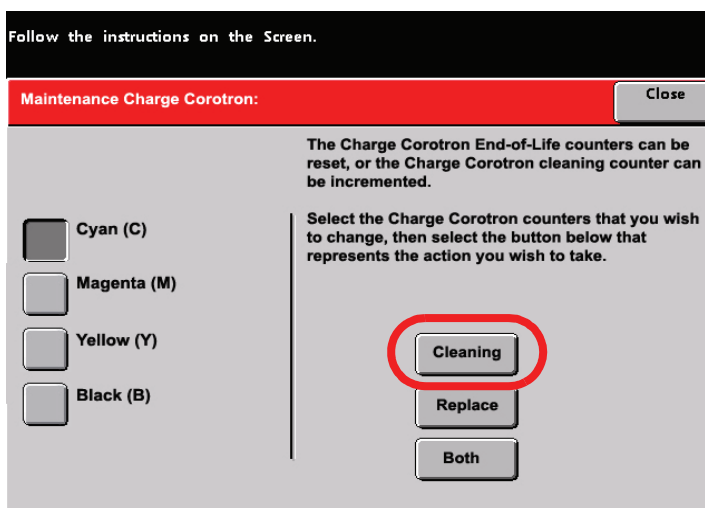


5. Repeat Steps 1-4 until all the corotrons are cleaned.

6. After each corotron is cleaned and the front doors are closed, the following message is displayed:



7. Select one or more corotrons by touching the corresponding button (Cyan, Magenta, Yellow, Black).
8. Select the Cleaning button:



9. The User Interface displays the following screen:

Follow the instructions on the Screen.

Maintenance Charge Corotron:
Increment Cleaning Counter? Close

Are you sure you want to increment the
Charge Corotron Cleaning Counter?

☐ Yes ☐ No

Select **Yes**. The User Interface displays:

Follow the instructions on the Screen.

Maintenance Charge Corotron: Close

The Charge Corotron End-of-Life counters can be
reset, or the Charge Corotron cleaning counter can
be incremented.

Select the Charge Corotron counters that you wish
to change, then select the button below that
represents the action you wish to take.

☒ Clean (C)
☐ Magenta (M)
☐ Yellow (Y)
☐ Black (B)

Cleaning
Replace
Both

After incrementing the counter for a specific corotron (or corotrons), that specific corotron (or corotrons) is no longer selectable.

10. Select the **Close** button to finish the cleaning procedure.

Cleaning the Second Transport and Fusing areas



Use the following procedure if your output prints have dirt or contamination on them or if you receive multiple paper jams in Area 4.



NOTE: It is recommended that you perform this procedure one time per day, preferably at the start of the day before the digital press is switched on and the fuser is hot.



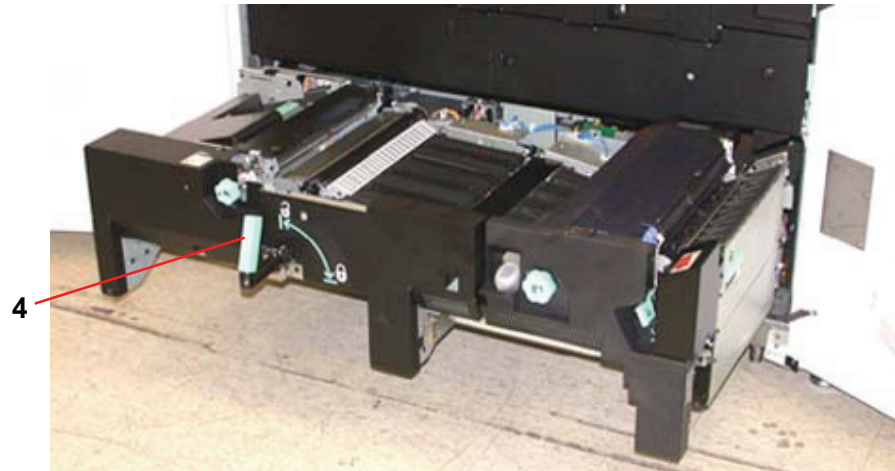
WARNING: If the digital press is switched on and the fuser is hot, be sure to switch off the digital press power and allow 15 minutes for the fuser to cool before performing this procedure.

1. Open the front doors.



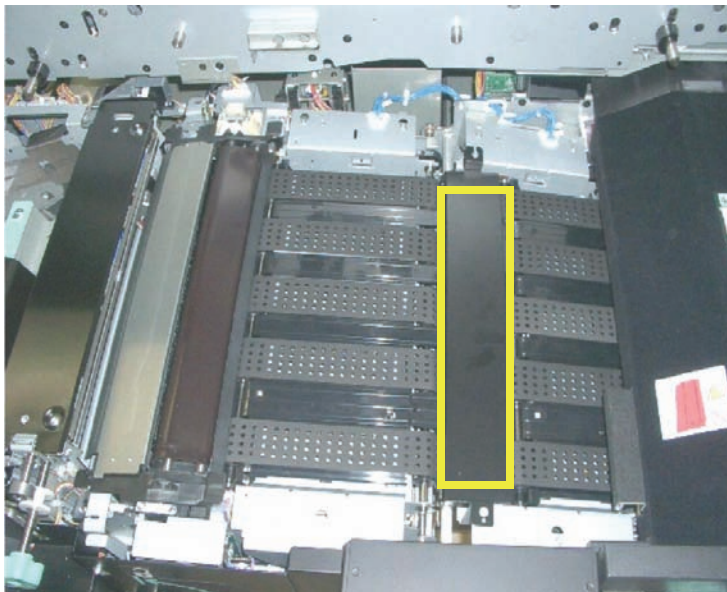
Front doors

2. Grasp handle 4 and move it in the direction of the arrow.



3. Slowly pull out the Paper Transport module until it stops.

4. Clean the chute area as outlined in yellow in the illustration below by wiping it with lint-free cloth:

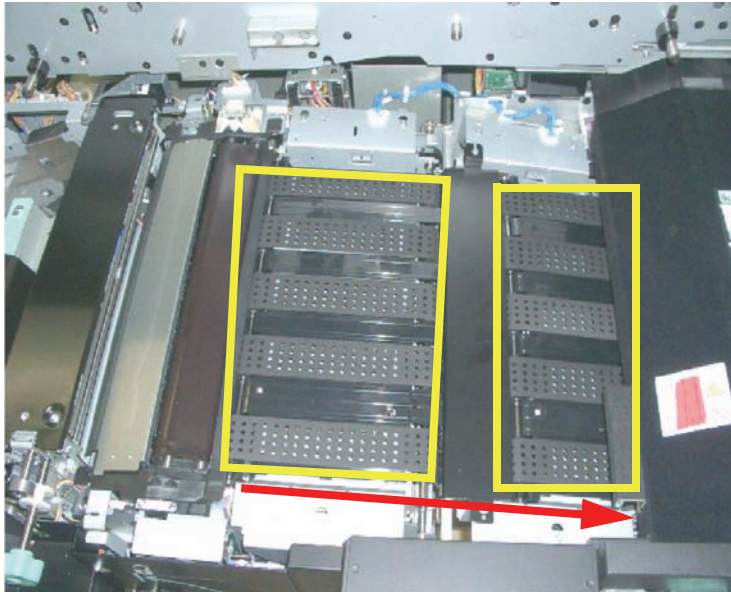


NOTE: It is recommended that you use the lint-free cloth supplied with your digital press, Xerox part number 19K03610.



KEY POINT: Avoid touching the chute area with your bare hands as this will leave grease and dirt on that area and create paper jams.

5. Clean the belts, outlined in yellow:



NOTE: It is recommended that you use the lint-free cloth supplied with your digital press, Xerox part number 19K03610.

- Use a lint-free cloth to wipe the belts
- Using the lint-free cloth, rotate the belts in the direction that paper travels; refer to the arrow in the above illustration. Continue to wipe the belts as you rotate them.

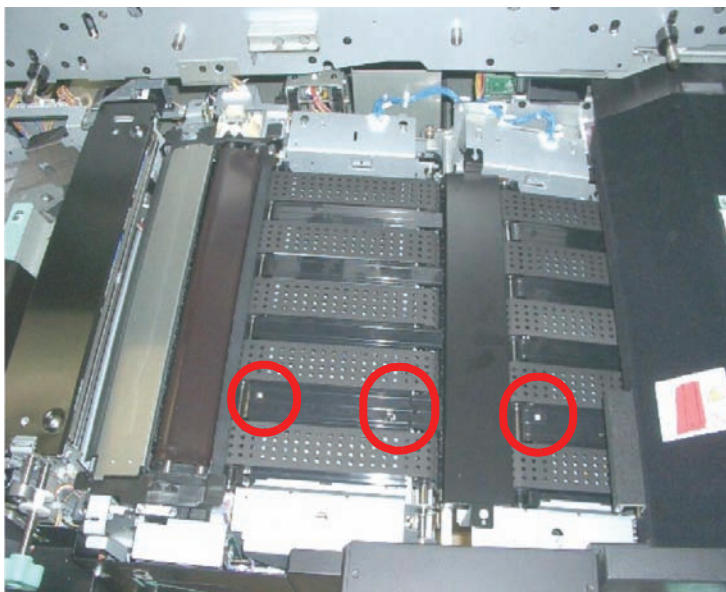
NOTE: Do not rotate the belts with your bare hands as this will leave grease and dirt on them and create paper jams. Rotate the belts by using a lint-free cloth.

- Continue to rotate and wipe the belts until all the belts are clean.
6. Clean the areas between each belt by wiping them with a lint-free cloth.

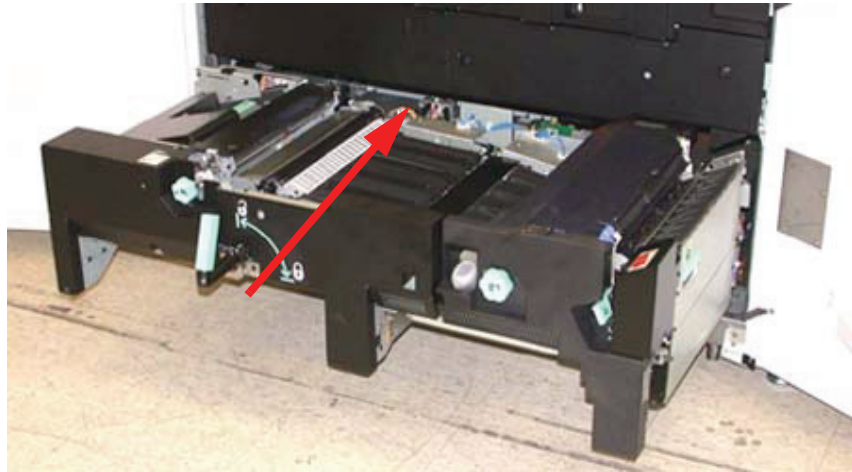


NOTE: It is recommended that you use the lint-free cloth supplied with your digital press, Xerox part number 19K03610.

7. Clean the sensors (circled in red) with a lint-free cloth.



8. Grasp handle 4 and slowly push in the Paper Transport until it stops. Turn the handle in the direction of the arrow to lock the module in place.



9. Close the right and left front doors.
10. Switch on the digital press power.

Cleaning the paper path



Use the following procedure to clean excessive paper dust/fibers from the paper path area.



NOTE: It is recommended that you perform this procedure one time per day, preferably at the start of the day before the digital press is switched on and the fuser is hot.

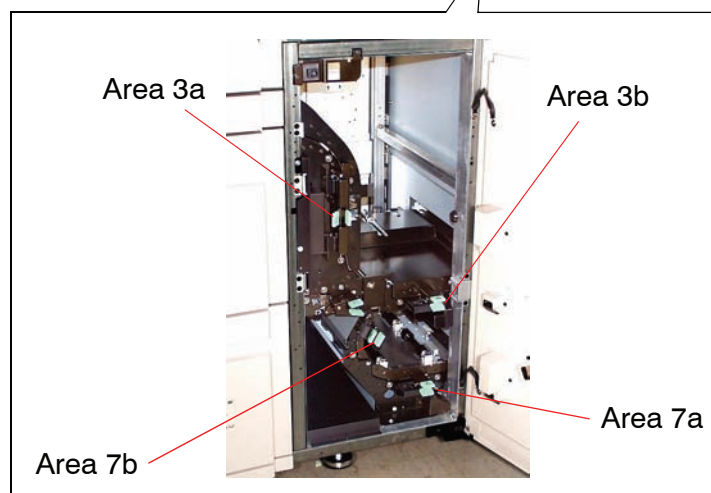
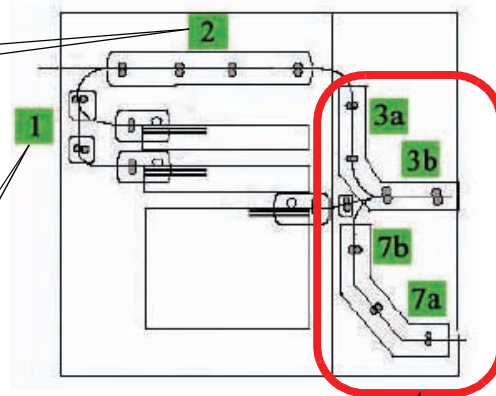
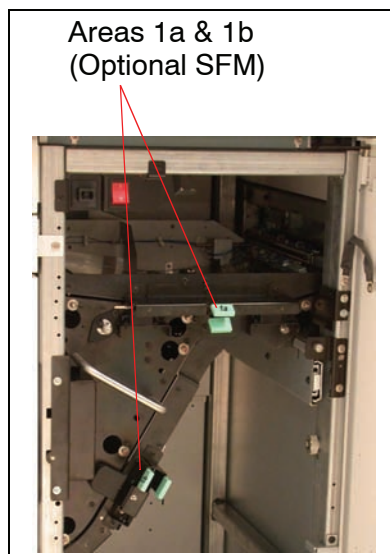
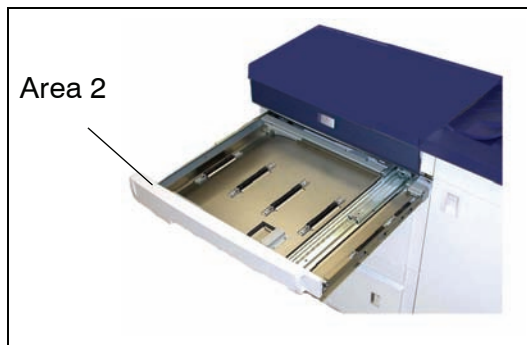


WARNING: If the digital press is switched on and the fuser is hot, be sure to switch off the digital press power and allow 15 minutes for the fuser to cool before performing this procedure.

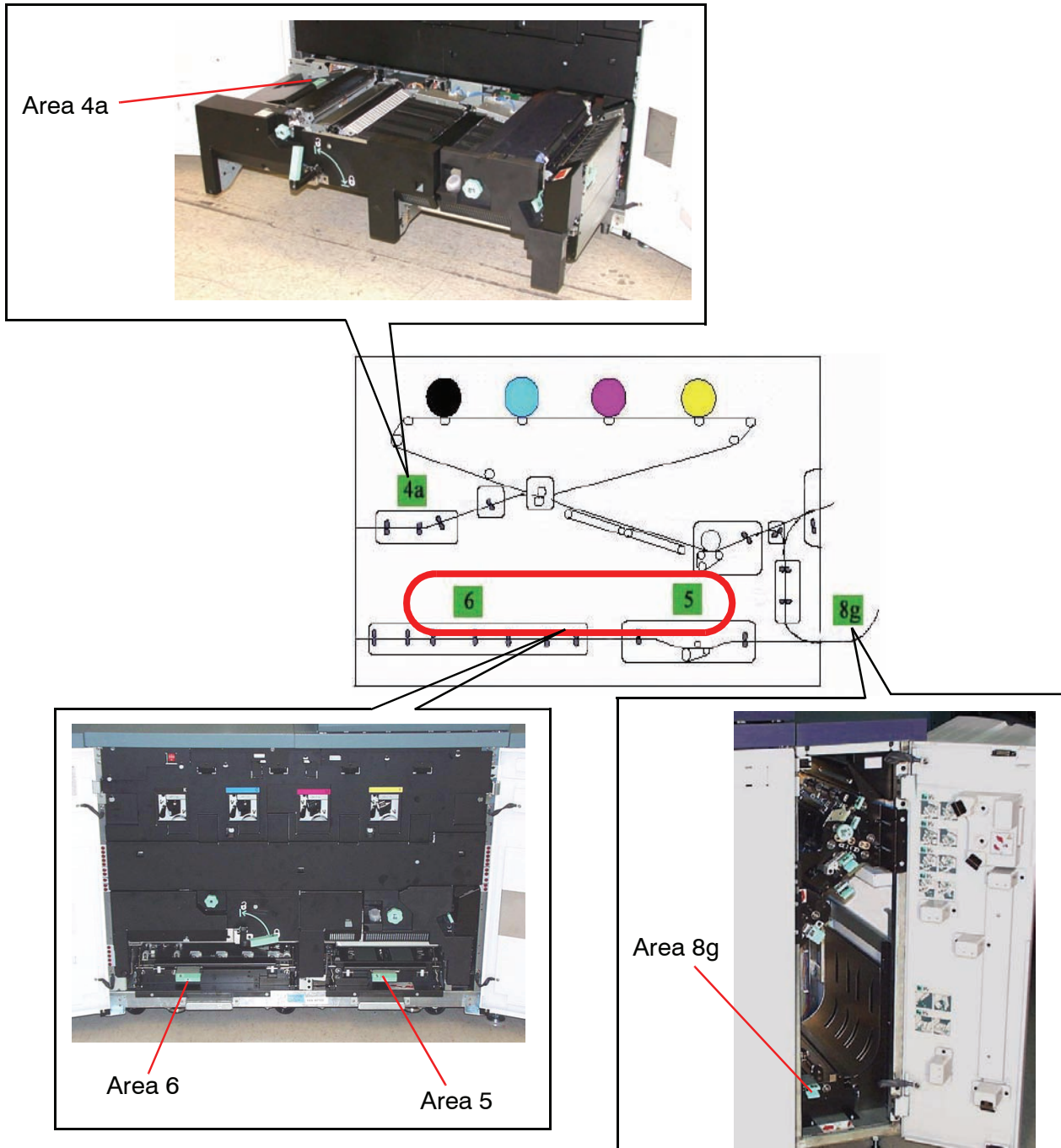


CAUTION: Only clean the recommended areas of the paper path as described in this procedure.

1. Use a damp, water moistened (not wet), lint-free cloth to clean the paper path **only** in the green handle jam clearance areas as shown below.



- a. Open each area and clean both surfaces of the transports.
 - b. Remove any residual moisture with a dry, lint-free cloth.
2. Use a damp, water moistened (not wet), lint-free cloth to clean the paper path **only** in the green handle jam clearance areas as shown below.



- a. Open each area and clean both surfaces of the transports.
- b. Remove any residual moisture with a dry, lint-free cloth.
3. Go to the Xerox DocuColor 8000/7000 Product Support page at <http://www.xerox.com>. At this web site, click on the **Supports & Drivers** link and navigate to the desired product (either DocuColor 8000 or DocuColor 7000).

Scroll to the **Issues and Solutions** section and download the CMYK **Halftone.pdf** patterns for white spots.

4. Use the 70% halftone.pdf test patterns to run fifty prints (8.5 x 11 inch/A4) of each color (C, Y, M, K).
 - a. Examine the prints for white spots.
 - b. Run fifty additional prints for each color still showing the defect.
 - c. Examine the last five prints for spots.
 - d. Run fifty additional prints for each color still showing the defect.
 - e. If the problem continues, contact your Xerox Service Representative.
5. If large amounts of paper dust are frequently observed, contact your Xerox Supplies Representative for an alternate paper recommendation.



NOTE: *If Xerox analysis determines that persistent paper contamination is due to cut papers or the use of non-recommended material, the customer may be liable for extended costs outside the scope of the service contract.*

Replacing Consumable Supplies

A message is displayed on the UI when a consumable item is nearing the replacement time. Another message is displayed when you must replace consumable items. The digital press will not run after this message is displayed until the item is replaced.

You should keep a supply available of the following consumable items:

- Dry Ink/Toner cartridges in all four colors
- Fuser Oil
- An empty Waste Dry Ink/Toner bottle.
- Charge Corotron Assembly
- Fuser Web Assembly

A chart later in this chapter provides the part numbers to order.

Replacing a Dry Ink/Toner Cartridge

Refer to the following procedure when a message to replace a Dry Ink/Toner Cartridge is displayed on the UI. There are also instructions on labels that are affixed to the compartment containing the cartridges.



CAUTION: To prevent spillage, remove Dry Ink/Toner cartridges only when the “**Replace the Dry Ink Cartridge**” message is displayed on the UI.



1. Place a drop cloth below the Dry Ink/Toner area.
2. Open the Dry Ink/Toner Compartment.

Dry Ink Compartment Door

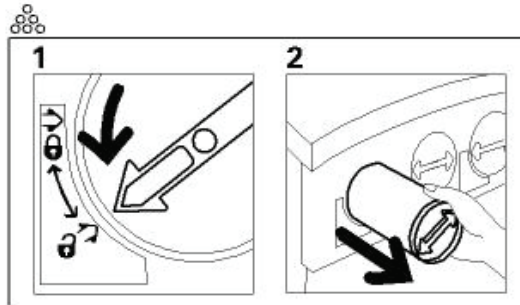


3. Rotate the empty cartridge counter-clockwise until the arrow on the cartridge is aligned with the unlocked padlock on the compartment label.

4. Pull the cartridge completely out of the compartment. Dispose of the empty cartridge according to local regulations.



CAUTION: Do not use warm or hot water, or cleaning solvents, to remove Dry Ink/Toner from your skin or clothing. This will set the Dry Ink/Toner and make it difficult to remove. If any Dry Ink/Toner gets on your skin or clothing, use a brush to remove it, blow it off, or wash it off with cold water and mild soap.



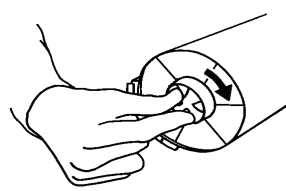
5. Remove a new cartridge from the box.



CAUTION: Dry Ink/Toner settles and compacts during shipping and must be loosened before inserting the cartridge into the machine. Failure to completely loosen the material may cause damage to the gear at the end of the cartridge.



KEY POINT: Vigorously shake and/or slap the new cartridge with your hand until the Dry Ink/Toner is completely loosened. To determine if the material is loose, place your finger tips on the flat side of the gear cogs at the back of the cartridge and turn the gear clockwise. When the gear turns freely, the material is loose and the cartridge can be inserted into the compartment.

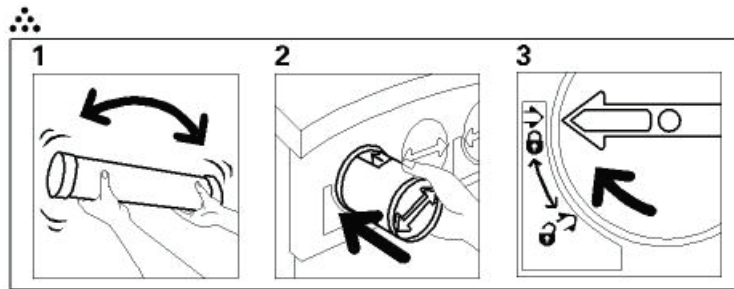


6. To insert the cartridge into the compartment, align the arrow on the cartridge with the unlocked padlock on the compartment and slide the cartridge into the compartment.



CAUTION: If more than one cartridge needs to be replaced at the same time, ensure that the cartridges are replaced in their correct color locations. From left to right, the cartridge colors are black, cyan, magenta, and yellow.

7. Rotate the cartridge clockwise until the arrow on the cartridge is aligned with the locked padlock on the compartment.



8. Close the Dry Ink/Toner compartment.

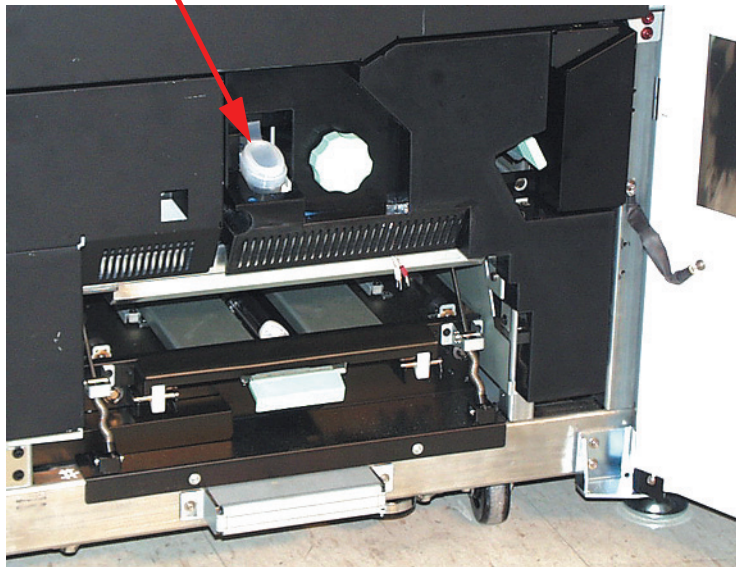
Adding Fuser Oil

A message appears on the UI advising you when to add Fuser Oil. Use the following procedure to replenish the Fuser Oil supply.



1. Open the Right Front Door of the digital press.
2. Place a drop cloth on the floor under the Fuser area. Any oil spilled on a hard floor will make the floor slippery.
3. Refer to the following figure for the location of the Fuser Oil Reservoir Cap.

Fuser Oil Cap



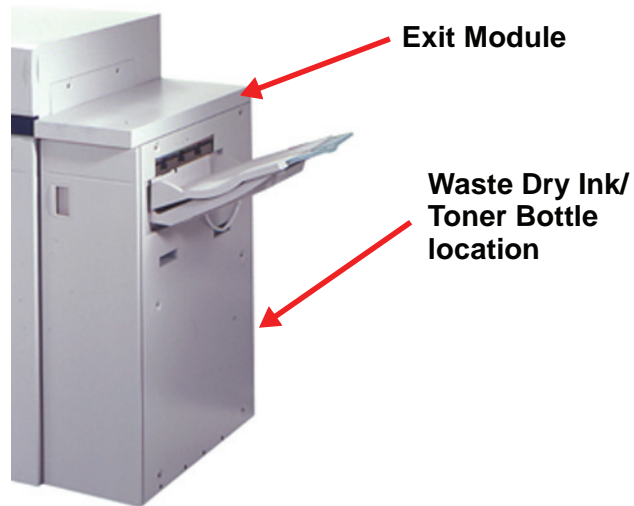
4. To open the Reservoir Cap, grasp the tab at the back of the cap and pull it forward.

5. Remove the cap from the bottle of Fuser Oil and replace it with the Filler Spout Cap. This cap was provided to you when your digital press was installed. Contact your Xerox service representative if you cannot locate the Filler Spout Cap and need another one.
6. Carefully insert the Filler Spout into the opened Fuser Oil Reservoir and squeeze the bottle until the oil reaches the maximum fill level tab visible inside the Reservoir.
7. Remove the Filler Cap from the bottle and place it on a cloth or paper towel to drain. Return the original cap to the bottle of Fuser Oil.
8. Close the Reservoir Cap, ensuring that it snaps into place.
9. Close the Right Front Door of the digital press.

Changing the Waste Dry Ink/Toner Bottle

A message appears on the UI advising you when to replace the Waste Dry Ink/Toner Bottle.

The bottle is located at the back of the Exit Module. Refer to the following figure.

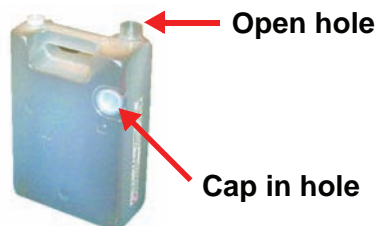


1. Open the Waste Dry Ink/Toner door at the back of the Exit Module. Refer to the following figure.

Exit Module



2. Grasp the handle of the full bottle and pull it out of the machine.
3. Remove the cap from the cap holder on the side of the full bottle and press the cap securely into the open hole on the top of the full bottle.



4. Dispose of the full bottle according to your local regulations.
5. Remove an empty bottle from the carton and insert it into the machine. Ensure that the hole on the top of the bottle is open and facing to the right.
6. Close the Waste Dry Ink/Toner Bottle door.

Replacing a Charge Corotron

When to replace a charge corotron

Unlike other consumable products for the digital press, a “replace corotron” message does not display on the UI. You should replace a corotron unit only when an image quality problem called banding, or rainbow banding, appear on prints. The Maintenance tab screen displays a yellow triangle or a red circle when a pre-determined number of prints using a corotron unit have been made. You should ignore these symbols and continue to use the corotron until banding is seen on prints.

Which charge corotron to replace

If you notice streaks or bands of color across prints, a charge corotron unit may need to be replaced. To determine which unit needs replacing, retrieve and print the file named *Corotron Test.pdf* from the Customer Documentation CD. The output print will show banding in the color bar of the corotron that needs to be replaced. Banding of multiple color bars means several corotrons need to be replaced.

Banding samples

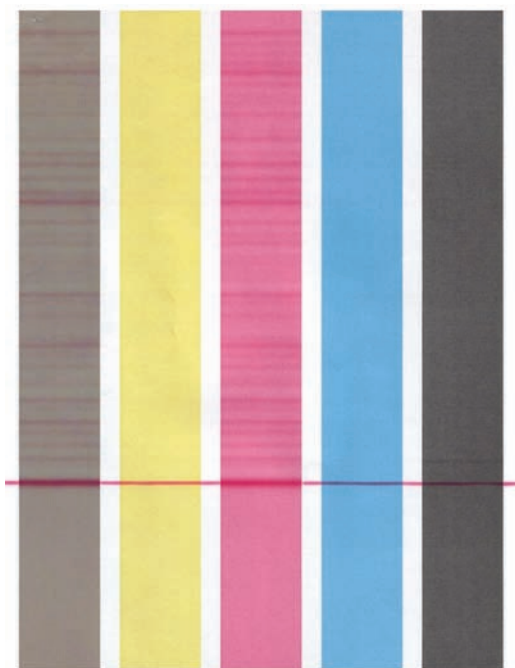
The following examples of the test print show banding in the color bar of the corotron that needs to be replaced and in the 3-color bar. The 3-color bar (CMY) is there to help you identify which color is showing banding.



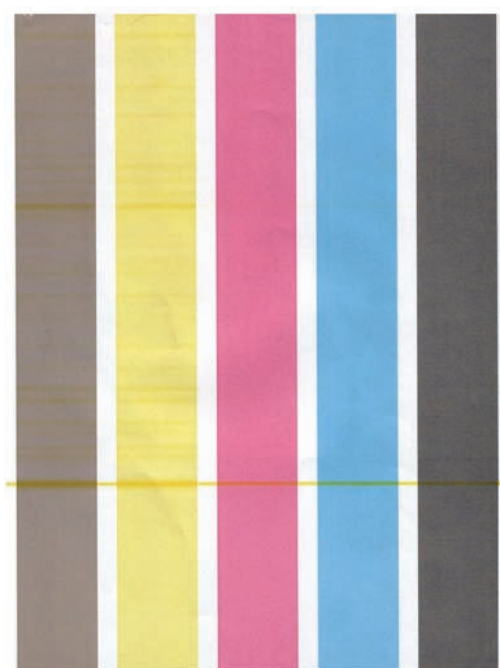
Black Banding



Cyan Banding



Magenta Banding

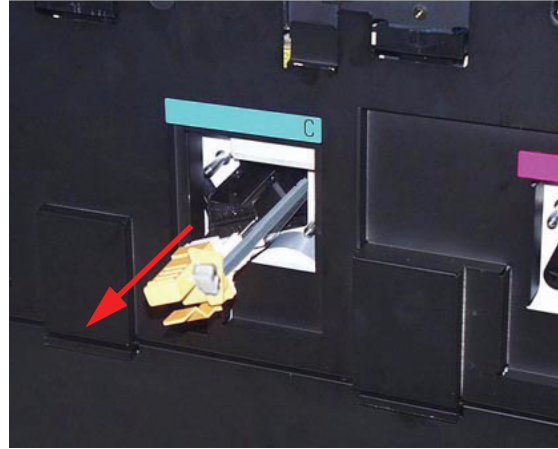
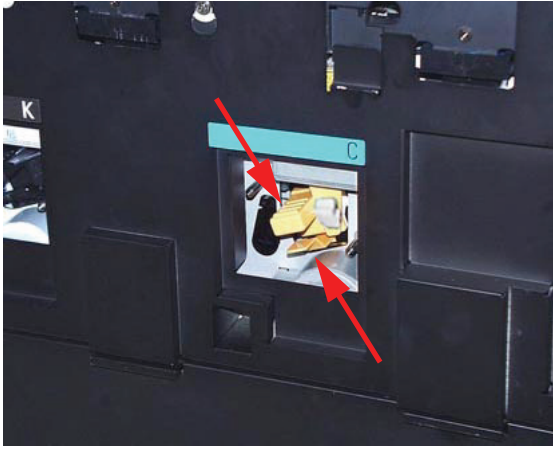


Yellow Banding



Use the following procedure to replace a Charge Corotron.

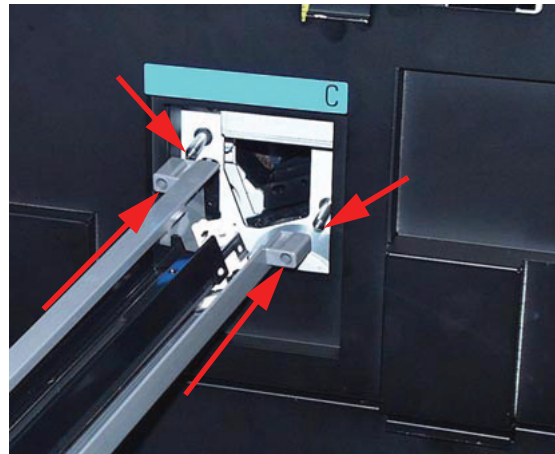
1. Open the front doors of the digital press.
2. Squeeze the handle of the corotron and pull it out of the machine. Dispose of according to your local regulations.



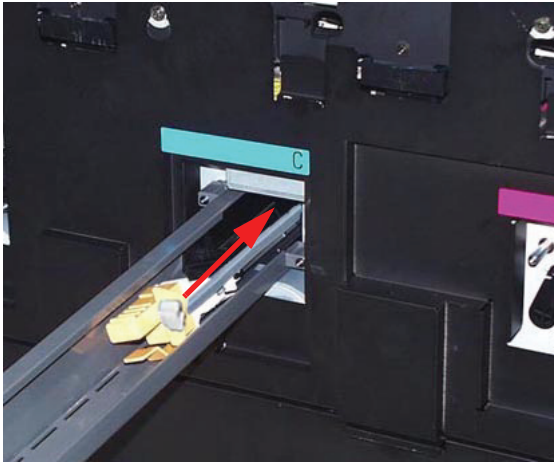
Removing a charge corotron

3. All replacement corotron units come with a protective plastic sleeve that also assists you in correctly inserting the unit.

Grasp the sleeve of the replacement unit with both hands and guide the two holes at the end of the sleeve over the metal bullet-shaped pins next to the opening in the digital press.



4. Grasp the yellow handle of the corotron and push it forward until it stops. Be sure it is firmly set in place. A message will be displayed on the UI if it is not seated correctly.



Push the corotron into the machine



Corotron in place

Pull the plastic sleeve off the bullet-pins and dispose of according to your local regulations.

5. The UI displays a message asking if you would like to reset the counter for the corotron unit. Follow the instructions on the screen to reset the counter.



NOTE: Each time you remove a corotron unit and reseal it, the UI displays a message asking if you would like to reset the counter. In these situations, you should close the screen without resetting the counter.

Replacing the Fuser Web

Two messages will display on the UI regarding the Fuser Web. The first advises you that the web is almost used up and you should be sure to have a new unit on hand. The second message displays when the Fuser Web is completely used and you must replace it. When this message displays, the digital press shuts down and will not print until the web is replaced.

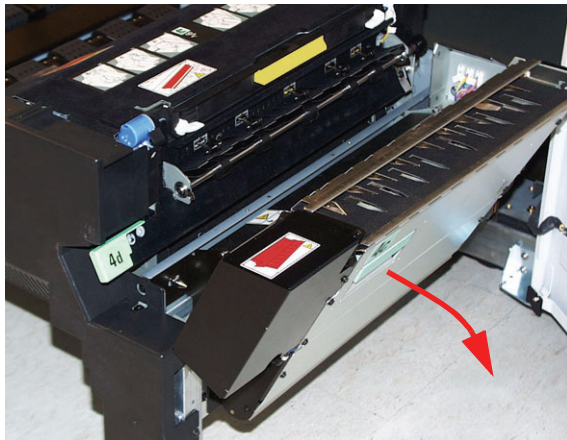


WARNING: The Fuser area is hot. Be careful when working in this area to avoid injury.

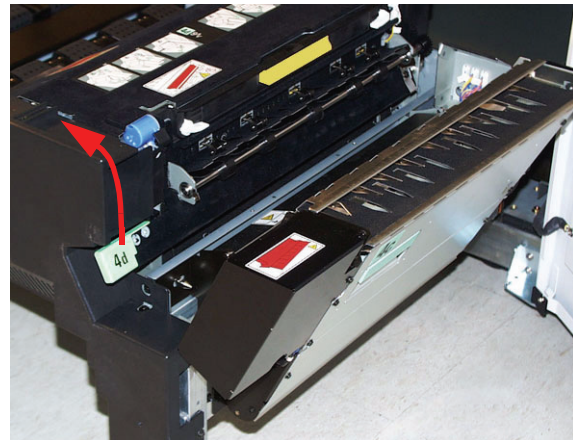


Use the following procedure to replace the Fuser Web.

1. Open the front doors of the digital press.
2. Use handle 4 to pull out the Transfer Drawer.
3. Pull open the Fuser handle 4C.
4. Lift up handle 4d until it stops at the top of the Fuser.



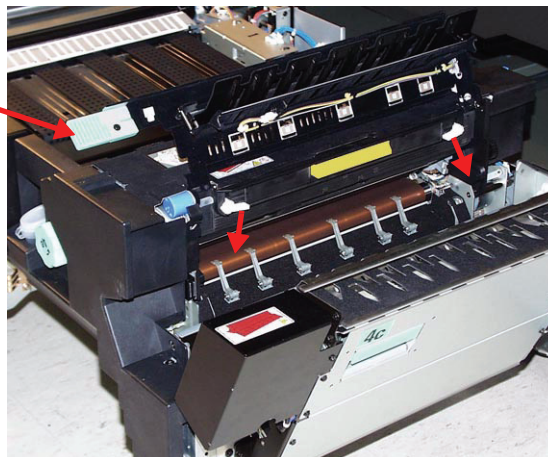
Pull handle 4C



Lift up handle 4d

5. Push down the two white levers.

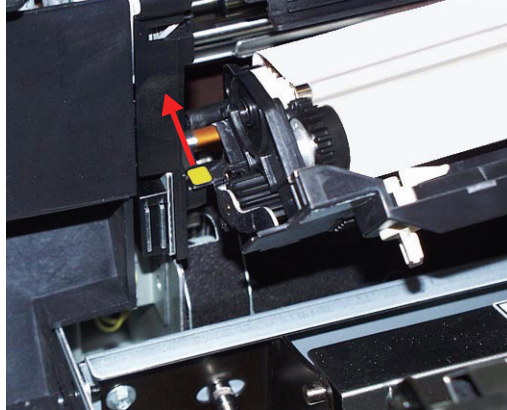
Handle 4d open



6. Grasp the colored handle in the center and pull the web unit down and out of the machine. Dispose of according to your local regulations.



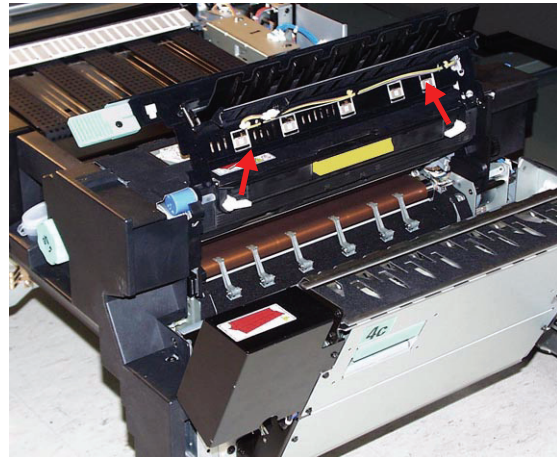
7. Remove the new web unit from the box and the protective covering.
8. Hold the web assembly with both hands and line up the tabs on both sides of the bottom of the assembly with the slides on both sides of the Fuser area. Slide the assembly in until it is firmly in place.



9. Raise the unit to the upright position and push up the two white levers.

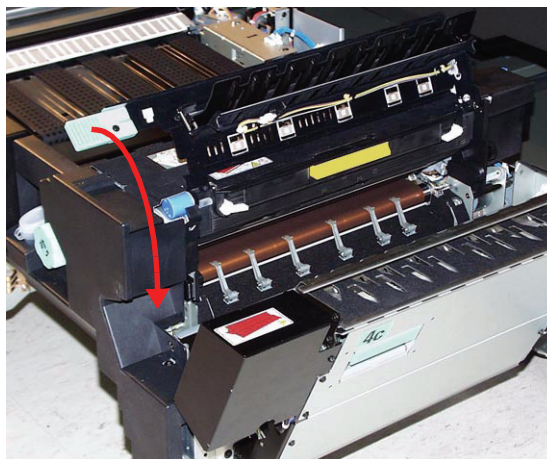


Raise the unit into place



Raise the white levers

10. Lower handle 4d.



11. Lift up handle 4c and raise the Fuser into its original position.

12. Push in and lock the Transfer Drawer, then close the front doors.

Calling for Service

Refer to the UI when there is a problem with the digital press or an accessory. A status code and suggested solutions are displayed on the screen. Follow all steps in the suggested solutions until the problem is corrected. If the problem persists, call for assistance.



Follow the instructions below before calling for service.

1. Be prepared to provide a complete description of the problem to the service operator. Defining the problem accurately may help you and the operator solve the problem over the phone and minimize downtime. If the problem cannot be solved by telephone, a service representative will be dispatched to your site promptly.
2. Record the displayed Fault Codes.
3. Record the Machine Serial Number. Press the **Machine Status** button on the Control Panel. Touch the **Machine Details** tab and the serial number is displayed. (If the serial number is not displayed, open the Right/Left Front Doors of the digital press. The serial number is also on a white label on the bottom front frame.)
4. If copy quality is a problem, take a copy sample to the telephone with you to help you describe the problem or to assist you when answering the questions from the service operator about the defects.
5. If possible, use a phone near the press when calling for assistance. Follow the instructions provided by the operator.

6. For system support, user help, and service support, call the appropriate number:

US: **1-800-821-2797** (Includes TTY support)

Canada: **1-800-939-3769**

Europe: _____

Latin America: _____

Xerox also provides web-based customer support. Go to:

www.xerox.com/eSupportCentre

Consumable Supplies

The following items are consumables for the DocuColor 8000/7000. It is recommended that you have a supply of these items available to eliminate downtime when they need to be replaced.

Supply Item	Supply Number Eastern Hemisphere	Supply Number Western Hemisphere	Supply Unit Shipped with digital press/ Reorder Quantity	Approximate Print Yield/ Carton (Full Color Prints*)
Dry Ink/Toner (Black)	6R90346	6R1199	1	30K
Dry Ink/Toner (Cyan)	6R90347	6R1200	1	50K
Dry Ink/Toner (Magenta)	6R90348	6R1201	1	50K
Dry Ink/Toner (Yellow)	6R90349	6R1202	1	50K
Developer (Black)	5R90246	5R629	1	100K
Developer (Cyan)	5R90247	5R630	1	100K
Developer (Magenta)	5R90248	5R631	1	100K
Developer (Yellow)	5R90249	5R632	1	100K
Fuser Oil	8R13031	8R13031	1	200K
*Waste Dry Ink/Toner Container	8R12662	8R12662	1	50k
*Charge Corotron Unit	13R596	13R596		
*Fuser Web Assembly	8R12966	8R12966		
Paper	Colotech+	Xerox Digital Color Xpressions+	2 reams	

* Please call your Xerox service representative to reorder Waste Dry Ink/Toner Containers, Charge Corotron Units, and Fuser Web Assemblies. These parts are provided to you at no charge when ordered by a Xerox service representative.

Store supply items and Xerox parts in their original packages in a convenient location.

* Dry Ink/Toner yield projections are based on 15 percent area coverage per color (4 colors = 60 percent) at standardized conditions on A4 (8.5x11") Xerox Digital Color Xpressions+ 24 lb. (90 g/m²) and Colotech Plus 90 g/m² reference paper.



NOTE: Actual yields vary greatly, depending on color intensity, area coverage, paper stock, and run mode selected.

To order consumable supplies, call the appropriate number:

US: **1-800-822-2200**

Canada: **French: 1-800-668-0133, English: 1-800-668-0199**

Europe: _____

Latin America: _____

