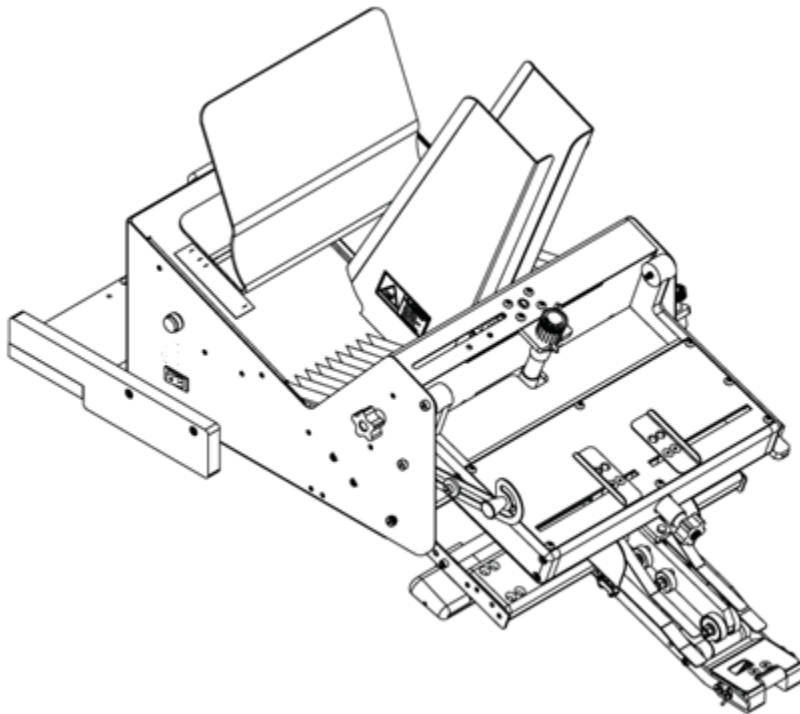


Xerox Customized Envelope Feeder

Problem Solving Guide



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Changes are periodically made to this document. Changes, technical inaccuracies, and typographic errors will be corrected in subsequent editions.

Document Revision: K (August 22, 2022).

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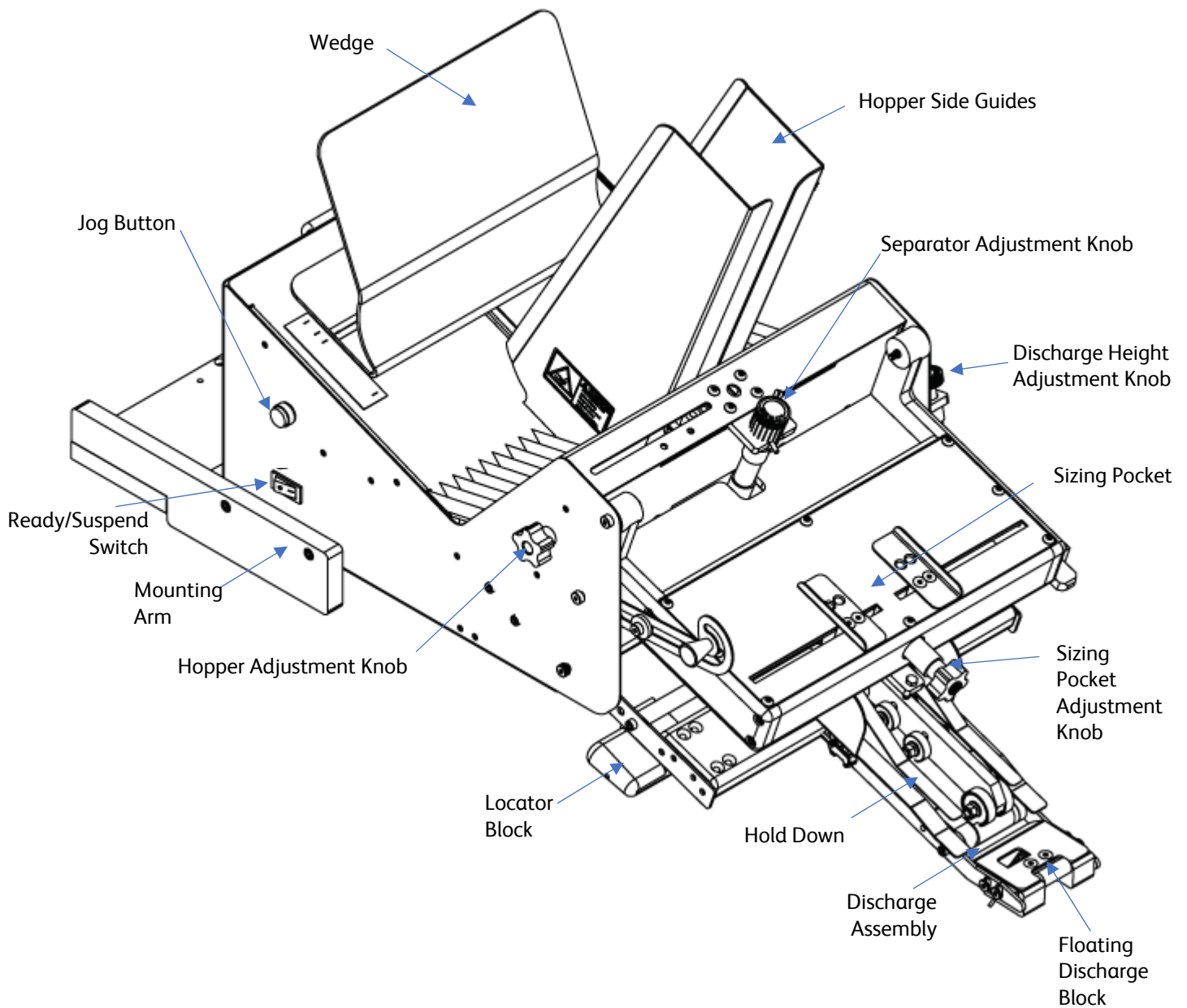
Section 6 Mechanincal/Electrical Components 6-1

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Section 1 Introduction

Overview

The names and locations of the Feeder components are shown below.

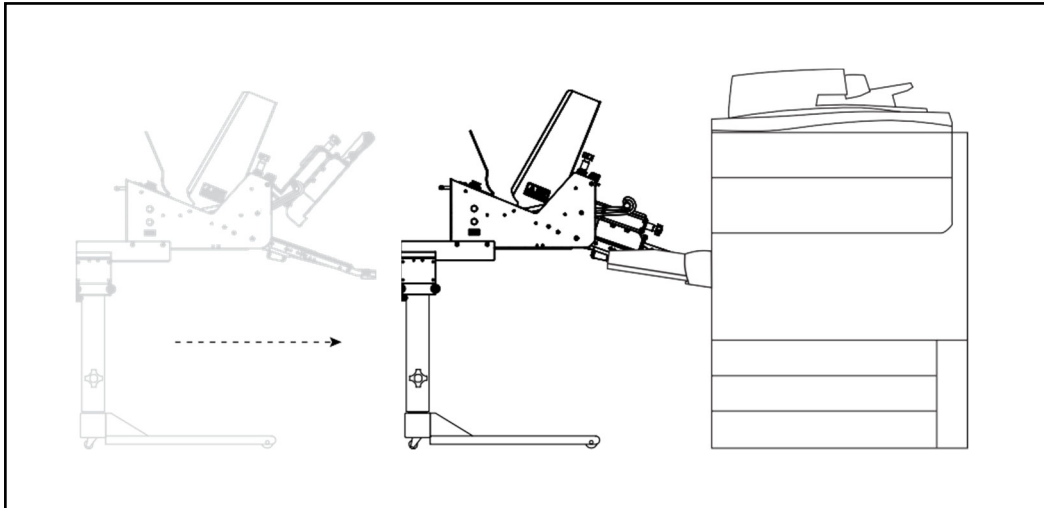


Overview, continued.

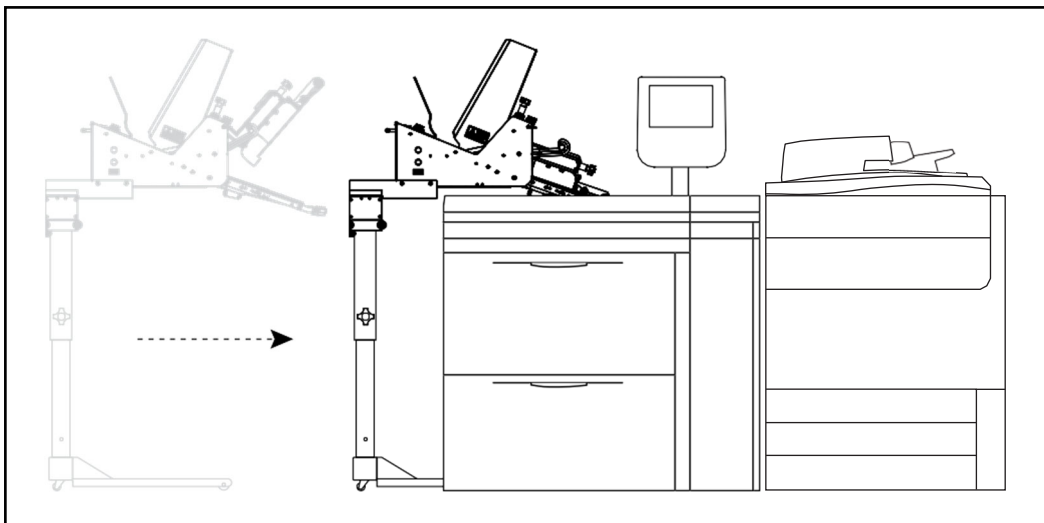
Feature	Description
Hopper Side Guides	The stack of product to be fed is loaded between the Hopper Side Guides to help keep it aligned for entry through the separator assembly area.
Wedge	The wedge provides the support necessary to transfer the center of gravity of the product stack in the hopper up off the deck plate onto the feed belts and against the separator assembly.
Stand (not shown)	The stand supports the Feeder including casters to provide easy mobility.
Feed Belts (not shown)	The feed belts provide the friction and motion necessary to pull individual product from the bottom of the stack and through the separator assembly area. The feed belts must be cleaned with isopropyl alcohol to ensure proper functionality.
Discharge Belt (not shown)	The long discharge belt provides the friction and increased speed necessary to pull the piece of product away from the separator assembly, resulting in a gap between each piece of product as it leaves the separator assembly area. The discharge belts must be cleaned with isopropyl alcohol to ensure proper functionality.
Hold Down	The Hold Down assembly forces the product onto the discharge belt so it can be singled out after it exits the separator assembly. The Hold Down Rollers must be in contact with the clear discharge belt but not so low that the black bar is resting on the belt. This would result in jams.
Separator	The separator assembly is adjustable so the gap between the separator assembly and the feed belts allows only a single piece of product at a time to pass under the separator. Allows quick adjustment from paper thickness to envelope thickness.
Jog Button	Advances the Feeder at a fixed speed. This function is useful during Feeder setup and may be used to clear jams.
Ready/Suspend Switch	Toggles between ready mode and suspend mode.
Stand Mount Interface	Designed to easily fit over the top of the stand. Once installed onto the stand, fasten with provided thumb screws.
Locator Blocks	Designed to help align the Feeder within the Versant Paper Tray while positioning the Feeder during installation, or when clearing a jam.

Installation Configurations

Side MSI (Bypass) Configuration



OHCF MSI (Bypass) Configuration



Installation Video

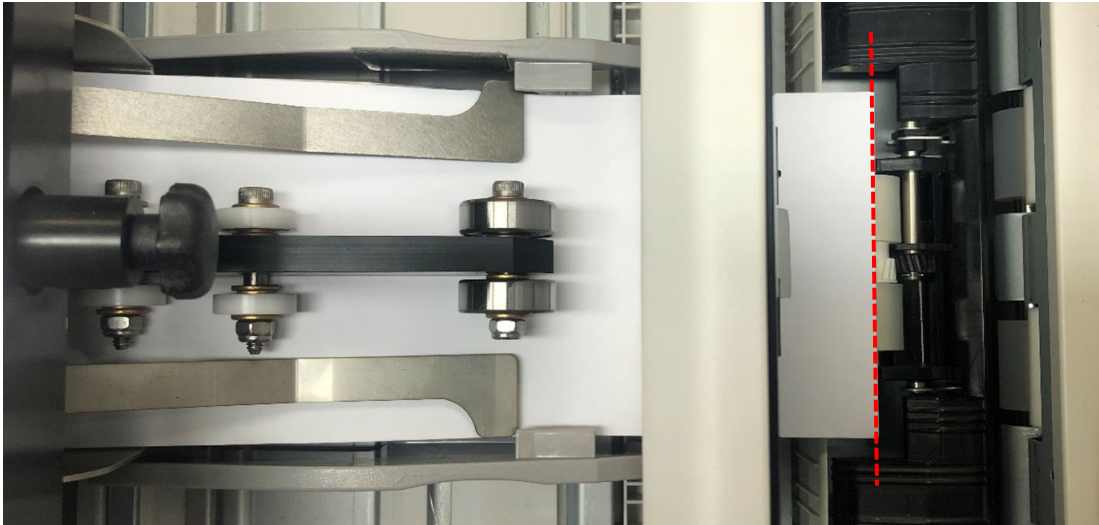
An installation video is accessible by clicking the link below.

<https://xerox.sharepoint.com/teams/USACAS/SitePages/Xerox%20Customized%20Envelope%20Feeder.aspx>

Section 2 Initial Entry RAP

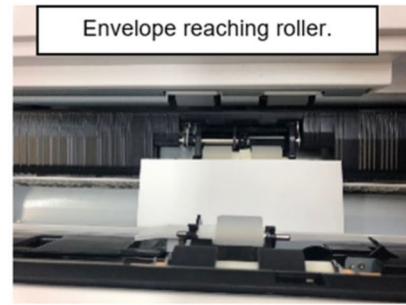
Use the steps on the following page to diagnose problems with the Envelope Feeder

NOTE *If the envelope feeder is set up properly, a single envelope should reach the feed head on the printer approximately halfway over the feed roller at the bottom of the MSI tray.*



Correct envelope feed position

Envelopes are not reaching the correct feed roller position (see below for details).



Y

N

Multiple envelopes are reaching the feed roller at once (multifeeds).

Y

N

Envelopes are jamming at the top of the discharge, wrapping around the separator.



N

Y

Go to page 3-3.

Call Xerox for assistance.

Go to page 3-4.

Go to page 3-8.

Section 3 Troubleshooting

Envelopes are jamming at the top of the discharge, wrapping around the separator.

There are typically only two reasons why envelopes jam directly under the separator. In such scenarios, several envelopes end up getting wrapped around/underneath the separator, as shown below.



The most common root cause for this problem is that the O-ring assemblies are over the belts AND they are too close to the belts. To determine if this is the root cause, follow the procedure in Section B and **RAISE** the O-rings in the separator assembly (turn the “DO NOT ADJUST” knob in the center **CLOCKWISE**, instead of **COUNTER-CLOCKWISE** as noted in Section B).

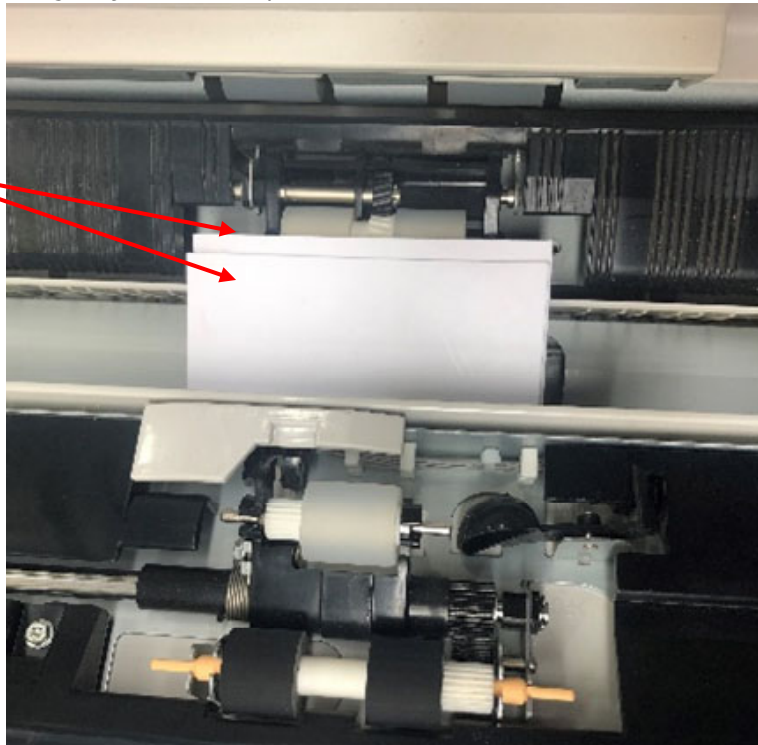


A second, less frequent root cause for jamming right below the separator, is when envelope flaps get caught at the top of the side guides in the discharge. This rarely occurs and only with odd-shaped envelope flaps. In such a scenario, please contact CAS (CAS@Xerox.com, 585-427-5414), as the guides may need custom modification.

Multiple envelopes are reaching the feed roller at once

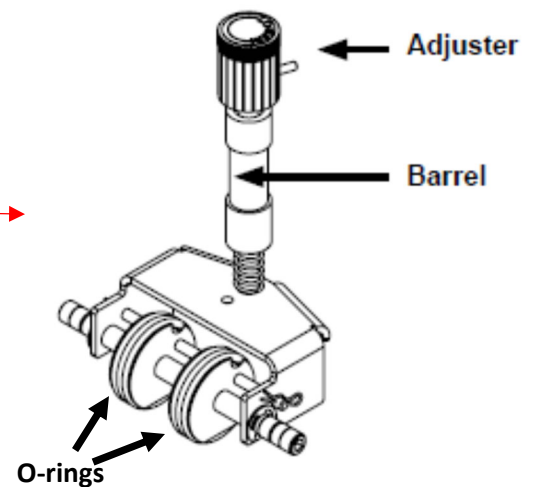
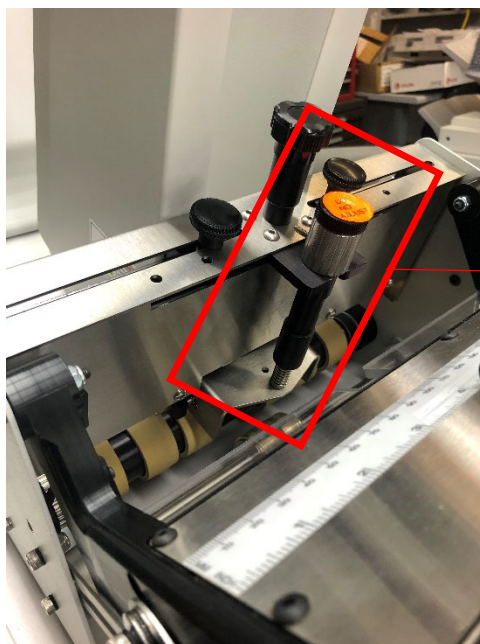
If the envelope feeder is feeding more than one envelope at a time, the printer will usually separate the envelopes and feed one at a time into the printer. However, if the feeder is set up properly, the feeder should be feeding only one envelope will be fed at a time.

Multifeed

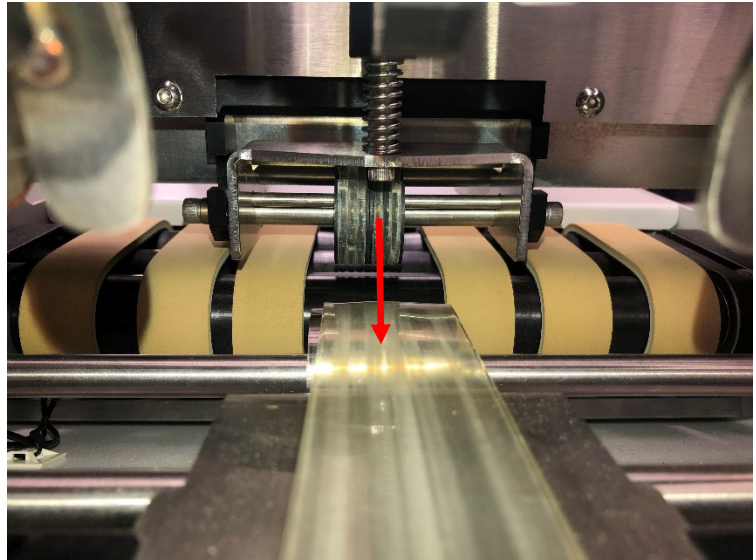


CORRECTIVE ACTION: When the envelope feeder is feeding more than one envelope at a time, it typically means that the separator needs adjustment.

The separator is a removable friction retard assembly in the center of the feeder that enables the feeder to “peel off” an envelope from the bottom of the stack when the belts move (see below).

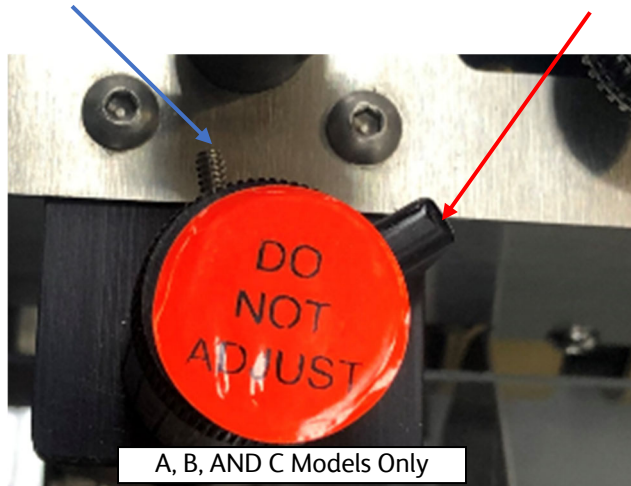


To reduce the likelihood of more than one envelope discharging at once, increase the friction on the separator by turning the “DO NOT ADJUST” knob in the center of the feeder *counterclockwise*. This will lower the O-rings on the bottom of the separator assembly.

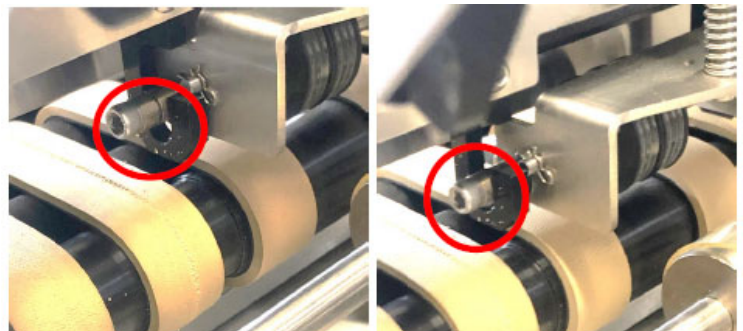


Lowering the separator (increase friction for better separation)

*NOTE: If the threaded **stud** (blue arrow) no longer turns due to the **stop** (red arrow), you can lift the “do not adjust knob” over the stop and continue turning the knob (see below).*



If you do turn past the stop, be sure to double check that the separator assembly did not jump out of the J-channels in the feeder (see below).

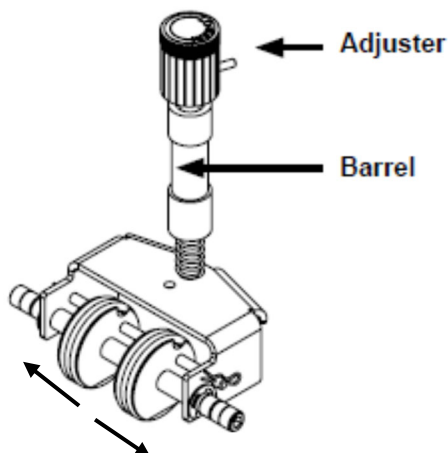


Occasionally, the envelope substrate/material is either too smooth or too rough, and multifeeds still occur even at the lowest setting for the separator. In such instances, you may need to move the O-ring assemblies in the Separator to a position where they are partially or completely **over** the belts instead of the default position in the middle of the belts.

NOTE: Models A, B, and C have the default position of the O-ring assembly in between the belts. Model D has the default position of the O-ring assemblies directly on top of the belts.

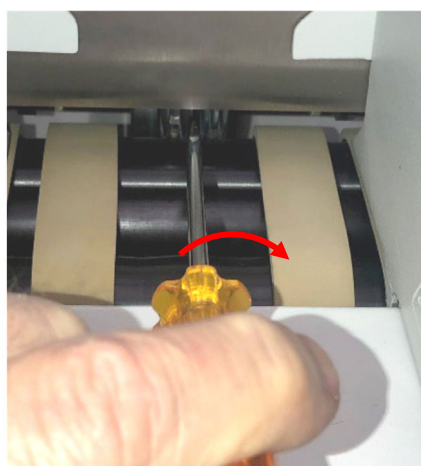
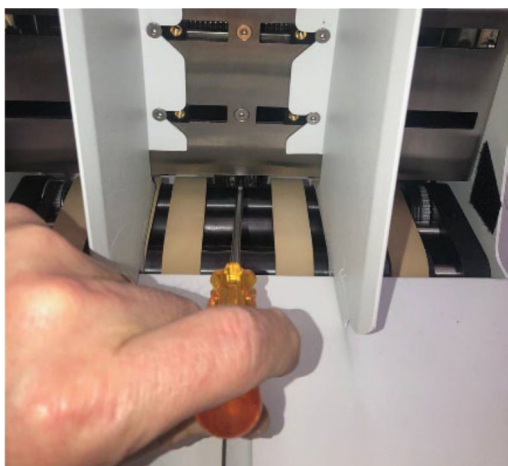
Follow the steps below to access the O-Rings on the Separator

1. Turn the power switch to the Off position and remove the Feeder power cord from the power source.
 2. Move the Feeder away from the Versant Bypass Tray.
 3. Engage the J-Hook to lock the Discharge Assembly of the Feeder in the UP position.
 4. Remove the Separator Assembly from the Separator Bracket by pushing down on the Separator Barrel while lifting up on the Separator Adjustment Knob (see below)
 5. Move the O-Ring assemblies along the shaft to change the O-Ring orientation on the Nudger.
- (See next page for sample settings of O-rings)**



As an alternative, you can use a screwdriver to separate the O-rings without removing the Separator Assembly. Insert a flat-head screwdriver in between the two O-ring assemblies and twist the screwdriver

****BE SURE THE UNIT IS POWERED OFF / UNPLUGGED WHEN PERFORMING THIS PROCEDURE ****



Here are some examples of recommended O-ring assembly locations when feeding non-standard



Off-centered O-ring Assembly Location - Avoids Hitting Windows on Windowed Envelopes



**O-ring Assemblies Located
Directly over the Belts:
D Model Default Position**



**O-ring Assemblies located partially over
the Belts: Ideal when using many
different envelope types/substrates**

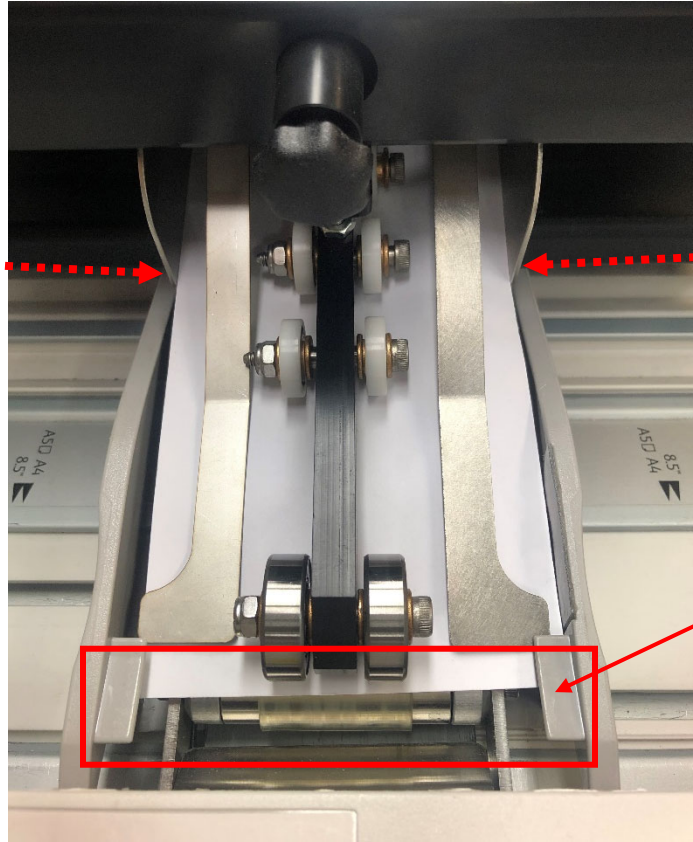
NOTE: O-ring separator adjustment will be significantly more sensitive in the configurations shown above.

Envelopes are not reaching the correct feed position

There are three likely reasons the envelope is not reaching the correct feed position:

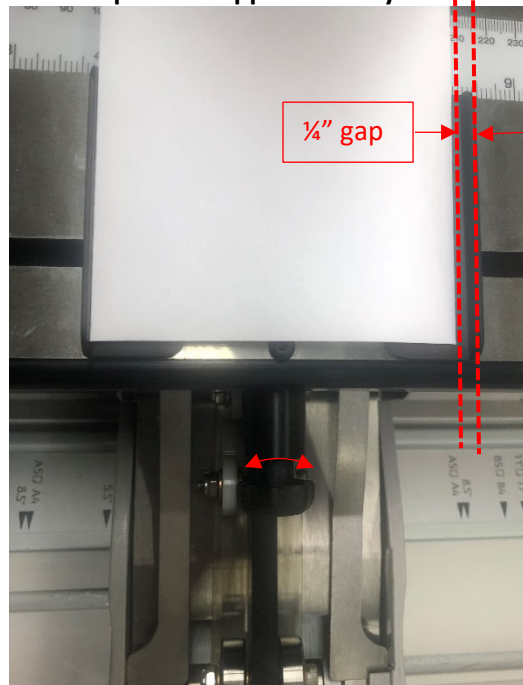
1. The side guides on the feeder discharge are too close together, "Squeezing" the envelope and preventing the envelope from feeding all the way down the envelope feeder discharge (see below).

Side guides are too tight, "Squeezing" envelope



Envelope stops short of correct feed position

CORRECTIVE ACTION: Set side guides to a position approximately $\frac{1}{4}$ " wider than the envelope (see below)



Leave approximately $\frac{1}{4}$ " gap when setting envelope width

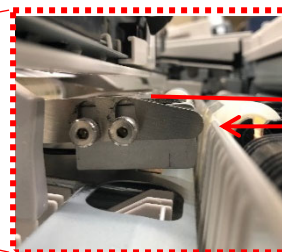
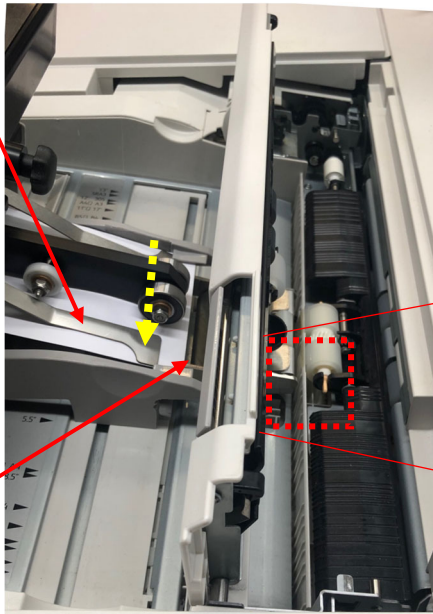
Note: this additional $\frac{1}{4}$ " MUST be added to envelope width when programming the width on the printer/DFE

2. The top guides on the discharge are pressing down on the envelope too much, creating too much downward pressure and preventing the envelope from feeding all the way down the envelope feeder discharge (see below).

The likely root cause for this problem is that the discharge on the envelope feeder is probably too high.

Downward pressure from top guides...

...envelope stops short of correct feed position

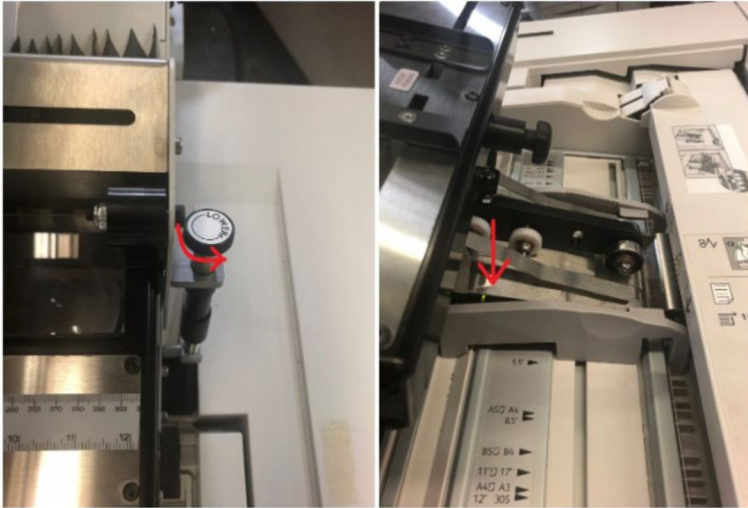


Top of Feed Head

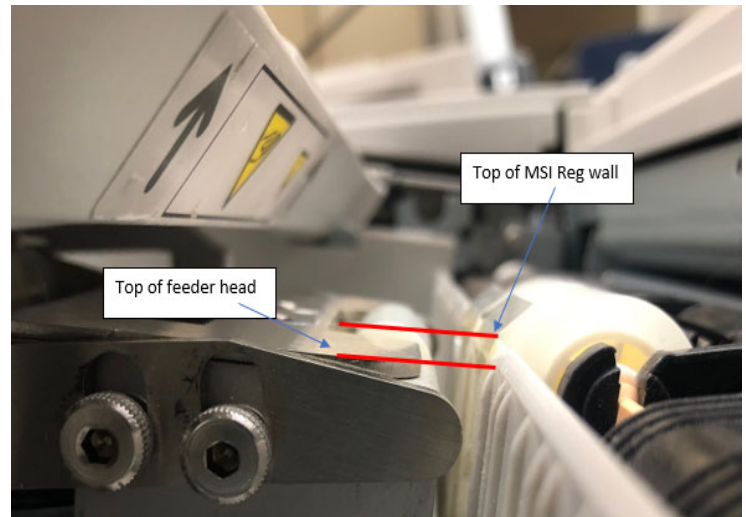
MSI Registration Wall

Discharge Feed Head is higher than MSI Registration Wall causing downward pressure.

CORRECTIVE ACTION: Lower the feeder discharge such that the feed head is slightly lower than the MSI reg wall. This can be done by turning the fluorescent “Do Not Adjust” knob on the INBOARD side of the feeder counterclockwise. It is recommended that you make this change in small increments.

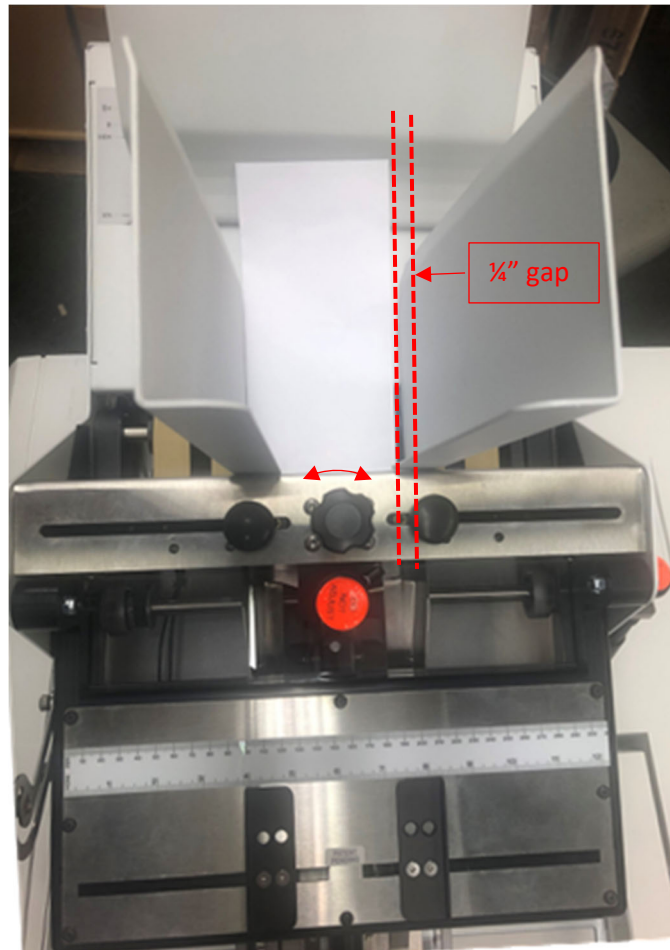


Lowering the feeder discharge



correct feeder head setting

3. Similar to the side guides on the feeder discharge assembly, the side guides in the hopper must be set with approximately $\frac{1}{4}$ " of additional space to ensure envelopes are not "squeezed" in the hopper (see below).



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Section 4 Repairs and Adjustments

SAFETY – READ THIS FIRST



WARNING – For all of the RAPs, it is essential that the following safety procedures are adopted, if not strictly observed there is a severe risk of injury or loss of life

Read this manual thoroughly before proceeding.

- If there is any doubt at any stage, do not proceed but seek clarification.
- This Safety information must be read together with, and does not take the place of, the customer's local procedures and Health and Safety Policies. Reference must be made to local procedures for safe working practices, particularly the dangers of working with electricity.
- Site regulations such as permission/permit to work rules must be followed.
- *"Isolated" means that the equipment is disconnected either by a plug being separated from the socket, or switched off with an approved isolator where the disconnection is a minimum of 3mm.*
- Precautions must be taken to prevent plugs being put back into, either:
 - ✓ lock it off with a personal padlock or lock and tag.
 - ✓ instruct a person to prevent the equipment being reconnected.
 - ✓ if the plug and socket are in visual sight, attach a notice/sign to the isolation point warning that the connection is not to be remade and keep a visual check to prevent any person approaching the isolation point.
- After disconnecting equipment, an electrical test must be made to ensure that the equipment is disconnected from the electrical supply.
- If it is necessary to run the equipment with a cover removed, suitable precautions must be made to prevent any person approaching the equipment and being exposed to danger.
- Never leave equipment unattended with covers removed or in an unsafe condition.
- Handheld devices for making electrical tests, which rely on the human body to complete a test circuit (such as neon-type screwdrivers) are not to be used; devices with insulated test probes are particularly recommended.
- Before installing, maintaining, cleaning, servicing, repairing or removing any covers from the equipment, switch off and disconnect all of the equipment in the system by disconnecting the plug from the socket.
- Only competent persons trained on the equipment may service, maintain, repair or adjust the equipment, or for any other reason, remove any covers or part of the equipment with a tool.
- If left unattended for any time during servicing and/or repair, the equipment must be switched off and isolated.

SAFETY – CONTINUED...

- The equipment must not be used outdoors or in any situation where it is likely to be splashed or exposed to excessive damp.
- When moving the equipment, ensure that suitable facilities, or help, is available to lift or move the equipment; particularly into or from awkward locations where overreaching may occur.
- Do not block any of the ventilation holes on the equipment, either to the sides or on the top.
- Before any work begins, people in the vicinity, or likely to approach the equipment must be warned that the equipment is about to be serviced and/or repaired.
- Every time the equipment is serviced, the following minimum safety checks must be made as a matter of routine:
 - ✓ Correct wiring of the main cord/power cable.
 - ✓ Physical inspection of the main cord/power cable for damage.
 - ✓ Physical check of the cord grips at both ends of the main cord/power cable.
 - ✓ Physical check of cables inside and outside the equipment for discoloration/other signs of overheating or damage.
 - ✓ Any sharp edges in accessible areas must be removed.

REP 4.1 Cleaning Feed Belts, Discharge Belts and O-Rings

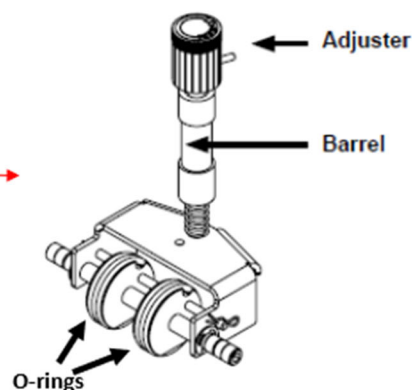
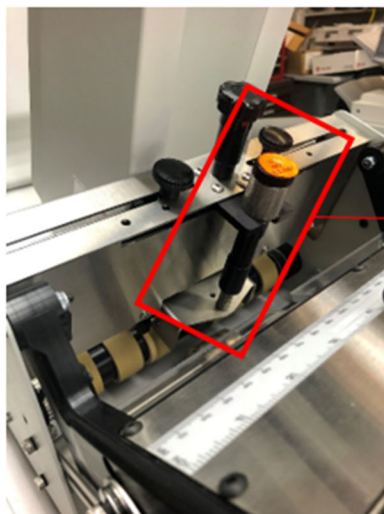
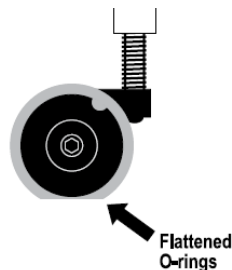
1. Turn the power switch to O (off) and remove the power cord from the power source.
2. Using the alcohol swabs included with the Feeder, press on the center of the stem of the alcohol swab (which causes alcohol to saturate the tip of the swab). If alcohol swabs are not available, apply a small amount of isopropyl alcohol to a soft, clean cloth.
3. For belts, use moderate pressure to wipe across one belt at a time while manually rotating it. Repeat for several rotations of each belt.
4. For O-rings, remove the gate assembly from the gate plate first and then wipe in each direction.

REP 4.2 Cleaning Sensor Lenses

1. Turn the power knob to O (off) and remove the power cord from the power source.
2. Use a soft, dry cloth to wipe gently across the face of each lens.

REP 4.3 Checking for Separator Assembly Wear

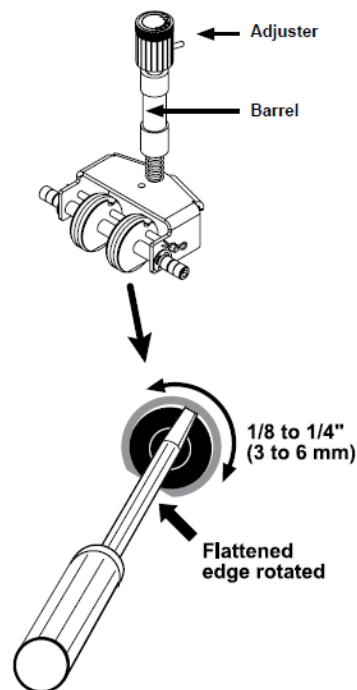
1. Examine the O-ring assembly closely for a flat area at the bottom of the O-ring assembly.
2. If a flat area exists at the bottom of the O-ring assembly, advance the O-rings by performing REP 4.4 (next page).



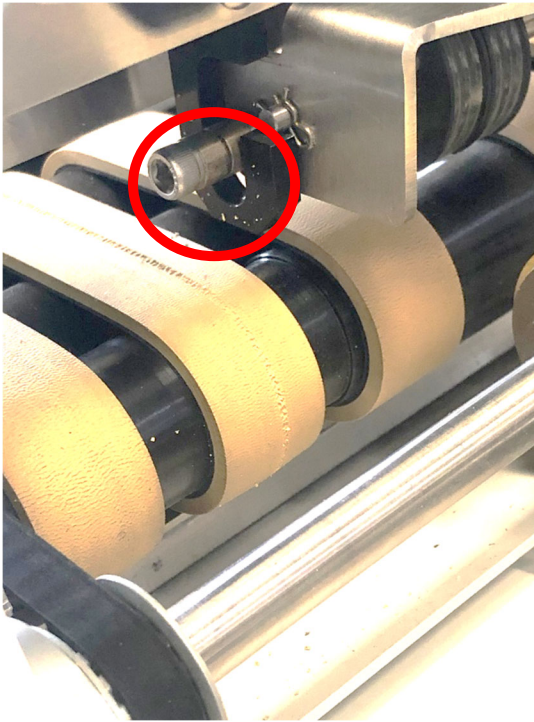
REP 4.4 Separator O-Ring Advancement

Advance the Separator Assembly O-rings when they show wear (see REP 4.3). Follow the steps below to access the O-rings on the Separator:

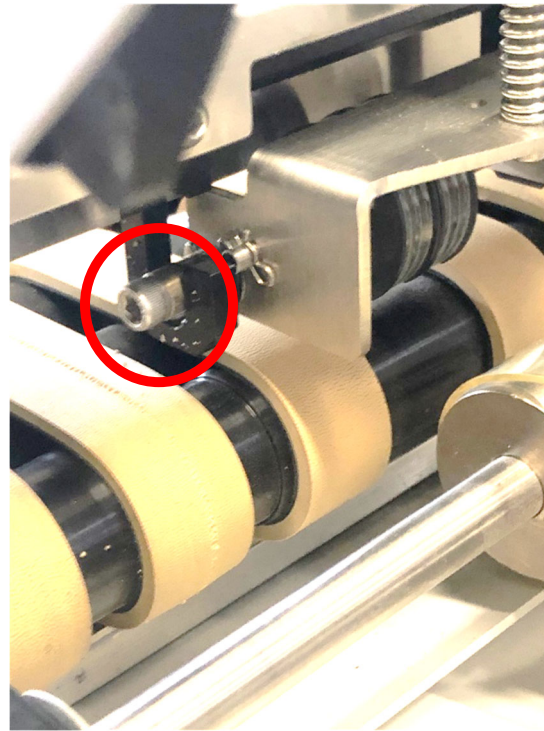
1. Turn the power switch to the Off position and remove the Feeder power cord from the power source.
2. Move the Feeder away from the Versant Bypass Tray.
3. Engage the J-Hook to lock the Discharge Assembly of the Feeder in the UP position.
4. Remove the Separator Assembly from the Separator Bracket by pushing down on the Separator Barrel while lifting up on the Separator Adjustment Knob. Repeat when re-installing.



5. Re-install the Separator Assembly. Be sure the Separator Assembly is firmly seated in the J-Hooks on the feeder:



Incorrect Separator Assembly Installation

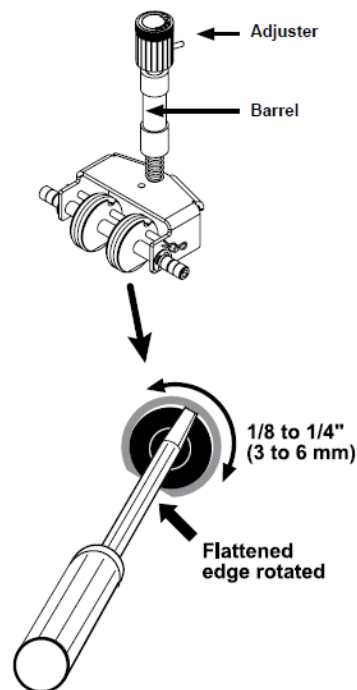


Correct Separator Assembly Installation

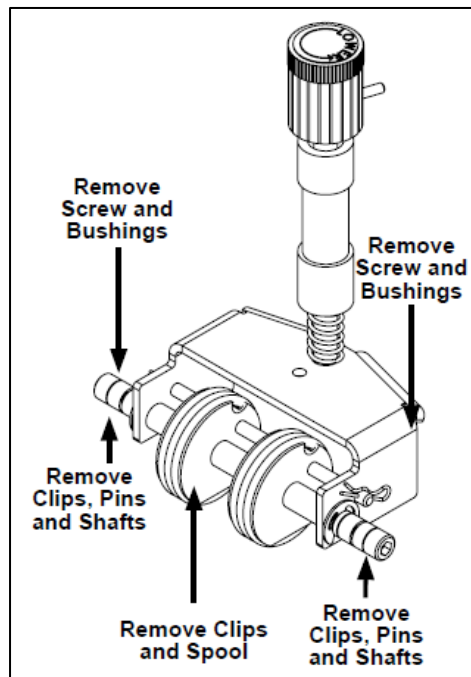
REP 4.5 Separator O-Ring Replacement

Replace the Separator Assembly O-rings when they show wear and after they have been advanced (REP 4.4) to the point where there is no longer a non-flat section available.

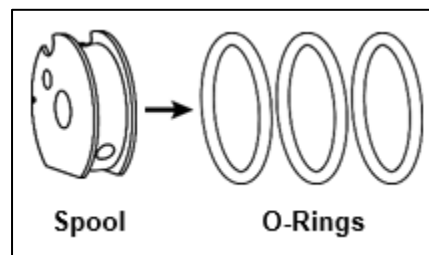
1. Turn the power switch to the Off position and remove the power cord from the power source.
2. Remove the Separator Assembly from the Separator Bracket by pushing down on the Separator Barrel while lifting up on the Separator Adjustment Knob. Repeat when re-installing.



3. Remove two screws to disassemble the indexer bracket from the separator assembly, exposing the O-rings.



4. Slide the O-rings off of the spool.



5. Replace with new O-rings.
6. Reinstall the Separator Assembly.

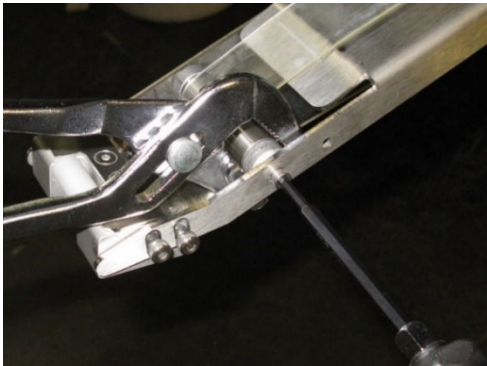
REP 4.6 Carriage Belts

Removal and Replacement

- ___1. Power off the Feeder and unplug the Feeder power cord.
- ___2. Remove the Retard Assembly.
- ___3. Remove the four Top Cover Screws.
- ___4. Loosen and remove the Drive Belt from the Motor.



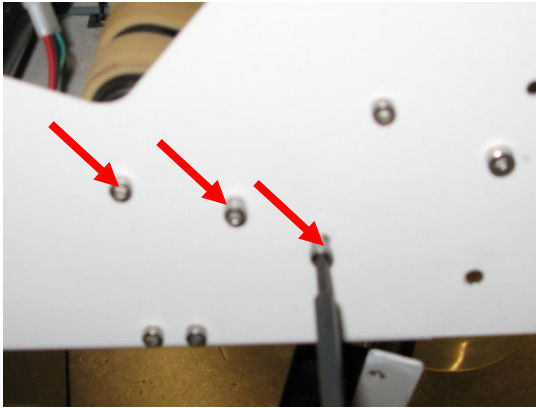
- ___5. Remove the Discharge Tension Roller.



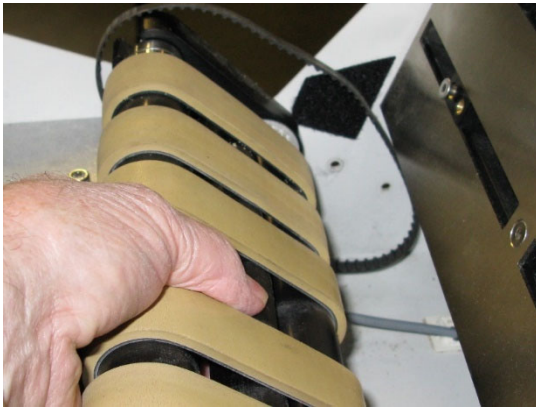
- ___6. Remove the left and right screws from the Discharge Bearing Holder (**CAUTION - the assembly will drop**).



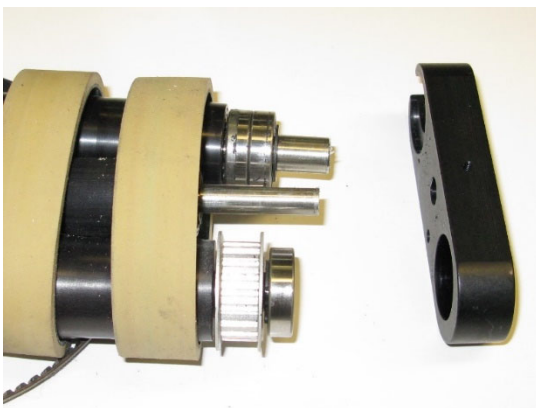
- ___7. Remove the six Screws (three on each side) that hold the Carriage Assembly.



- ___8. Remove the Carriage Assembly.



- ___9. Remove and replace the Carriage Belts.



Reassembly

- ___1. Put the Carriage Assembly back into the Feeder.
- ___2. Align the holes and replace the screws without the discharge drive belt.
- ___3. Replace the Discharge Assembly in the Feeder.
- ___4. Align the holes and replace the screws on the Discharge Drive Belt side of the Carriage.
- ___5. Reinstall the Discharge Belt Tension Roller.
- ___6. Install and tension the Drive Belt.
- ___7. Reinstall the Top Cover.
- ___8. Reinstall the Retard Assembly.

REP 4.7 Versant Error Messages

Does the Versant User Interface display a fault showing “**The original size could not be detected...**”?

N

Y

Adjust the **Versant** Paper Tray Guides (plastic guides) to meet or “hug” the Envelope Feeder Side Guides.



Does the Versant User Interface display a fault showing “**Paper Size/Orientation in Tray 5 is Different...**”?

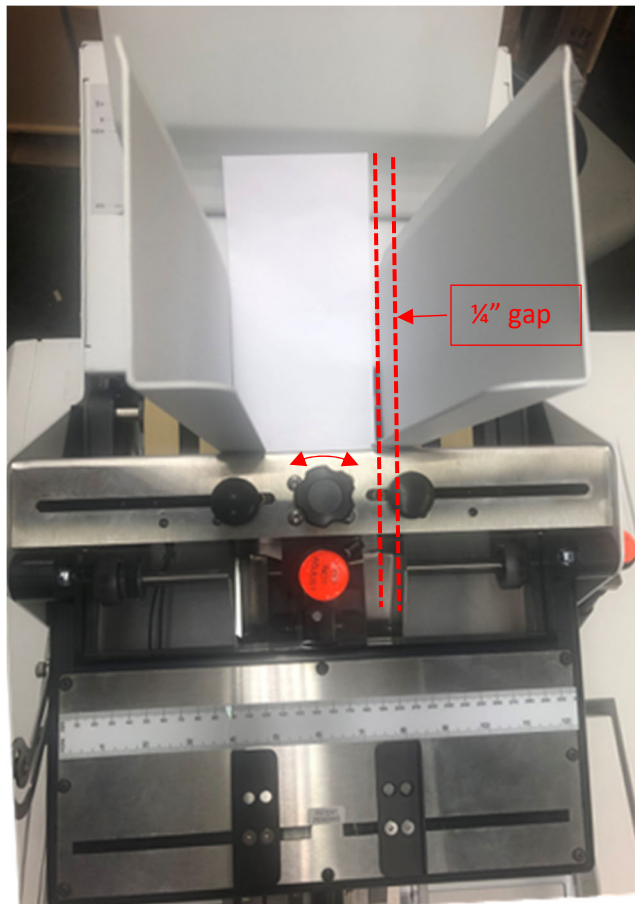
N

Y

Adjust the length value and width value on the *Versant Paper Tray Attributes* screen (on the Versant User Interface) to match the actual media loaded in the Hopper.

NOTE: If the envelope size is measured in hundredths-of-an-inch (for example, 4.75), you may be required to try a slightly larger size (4.8) on the Versant User Interface (since the Versant User Interface only accepts sizes measured in tenths-of-an-inch).

IMPORTANT: the side guides on the feeder actually need to be slightly wider than the envelope. Similar to the side guides on the feeder discharge assembly, the side guides in the hopper must be set with approximately ¼” of additional space to ensure envelopes are not “squeezed” in the hopper (see below).



Go to the top of the next page.

Does the Versant User Interface display a fault showing “Tray 5 is Out of Paper...”?

N

Y

The Paper Present Sensor in the Versant MSI tray may be broken. See the Versant Service Procedure to replace this part.



Are some envelopes (more than one) feeding and printing before the message appears?

N

Y

Clean the Feeder Belts (REP 4.1).



The feeder may not be properly registered against the OHCF or Side MSI Tray.

Remove the Feeder from the OHCF or Side MSI Tray.

For OHCF configurations, reinstall the Feeder and verify the OHCF back guides are adjacent to the Feeder.

For Side MSI Tray configurations, reinstall the Feeder and verify the Side Guide Blocks are adjacent to the Feeder.

OHCF Configuration



MSI Tray Configuration



Call CAS at 585-427-5414 for assistance.

REP 4.8 Separator Adjustment Procedure

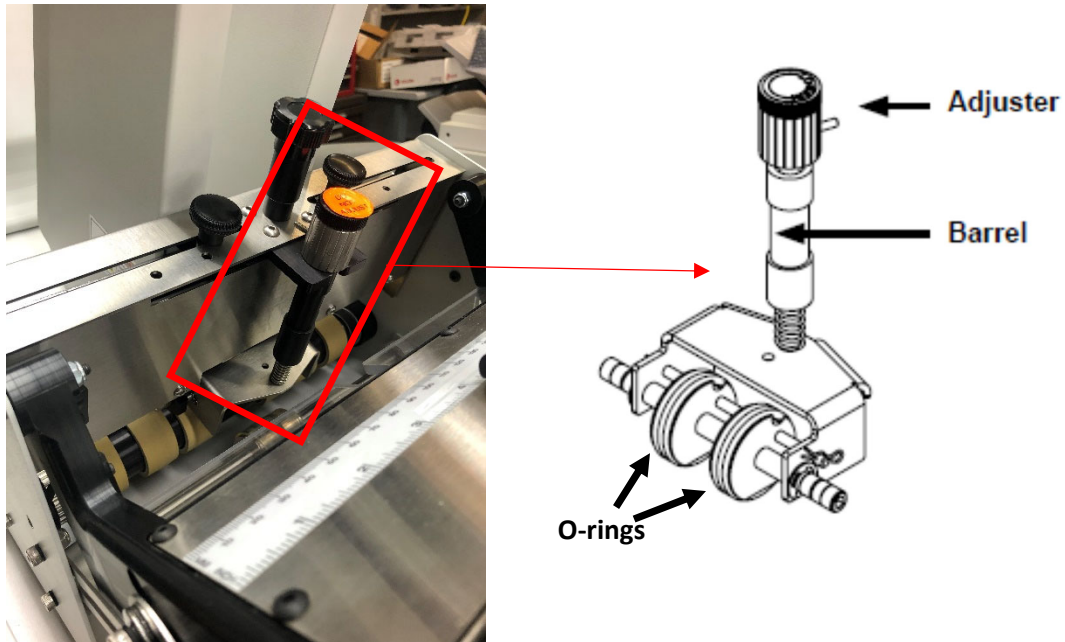
Overview

The gate assembly pre-shingles the product to help the feed belts move one piece of product at a time based on the gap between the gate assembly and the feed belts. Pre-shingling helps the gate to efficiently separate and single-out the product. The gap between the gate and the feed belts is adjustable to accommodate different product thicknesses.

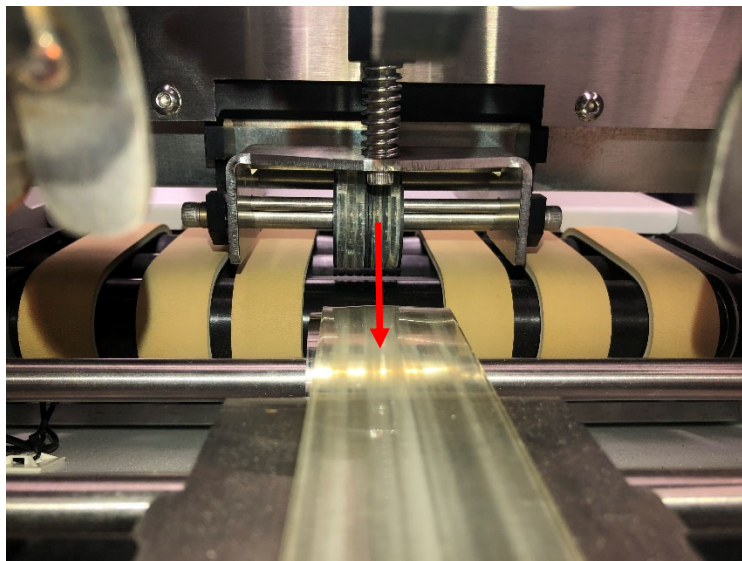
The discharge belts are located under the hold down assembly.

Combined with the hold down assembly, the discharge belts provide the friction necessary to pull the piece of product away from the gate assembly, resulting in a gap between each piece of product as it leaves the gate assembly area.

The Separator is a removable friction retard assembly in the center of the feeder that enables the feeder to “peel off” an envelope from the bottom of the stack when the belts move (see below).

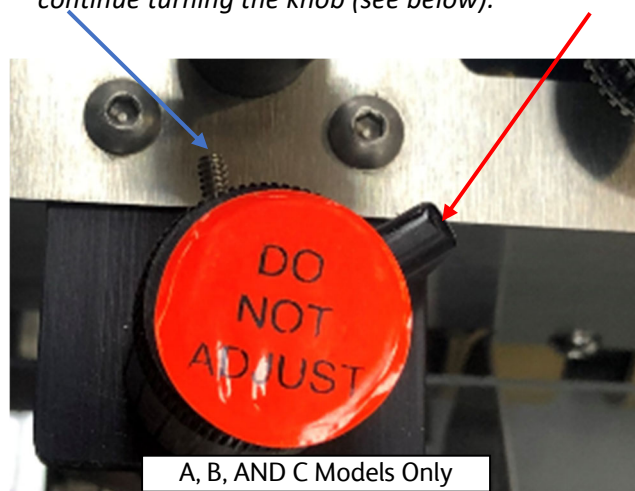


To reduce the likelihood of more than one envelope discharging at once, increase the friction on the Separator by turning the “DO NOT ADJUST” knob in the center of the feeder *counterclockwise*. This will lower the O-rings on the bottom of the Separator Assembly.

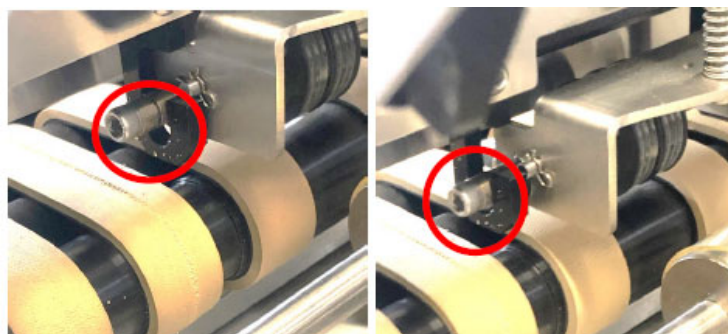


Lowering the Separator (increase friction for better separation)

*NOTE: If the threaded **stud** (blue arrow) no longer turns due to the **stop** (red arrow), you can lift the “do not adjust knob” over the stop and continue turning the knob (see below).*



If you do turn past the stop, be sure to double check that the separator assembly did not jump out of the J-channels in the feeder (see below).



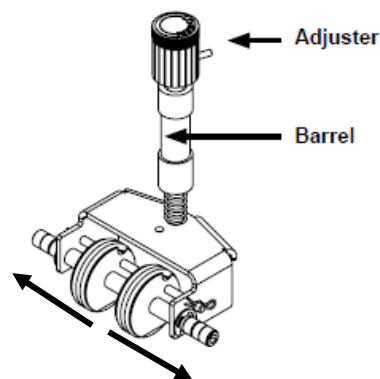
REP 4.9 Not Used

REP 5.0 Separator O-Ring Adjustments for Different Media

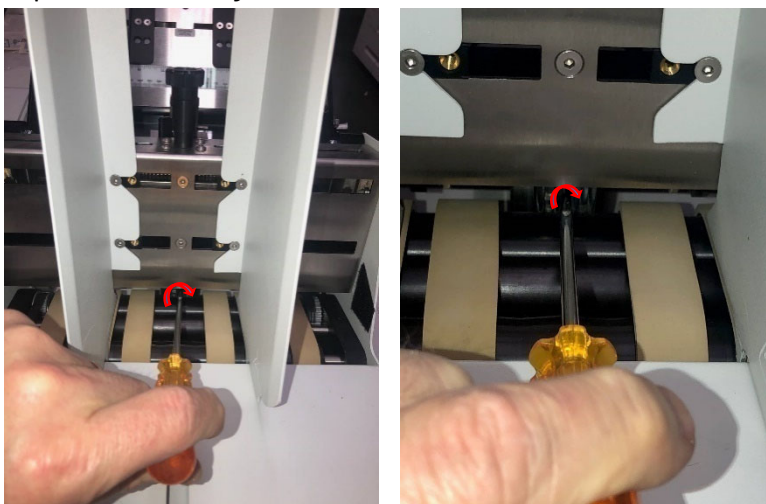
Overview

Advance the Separator Assembly O-Rings when they show wear. Follow the steps below to access the O-Rings on the Separator:

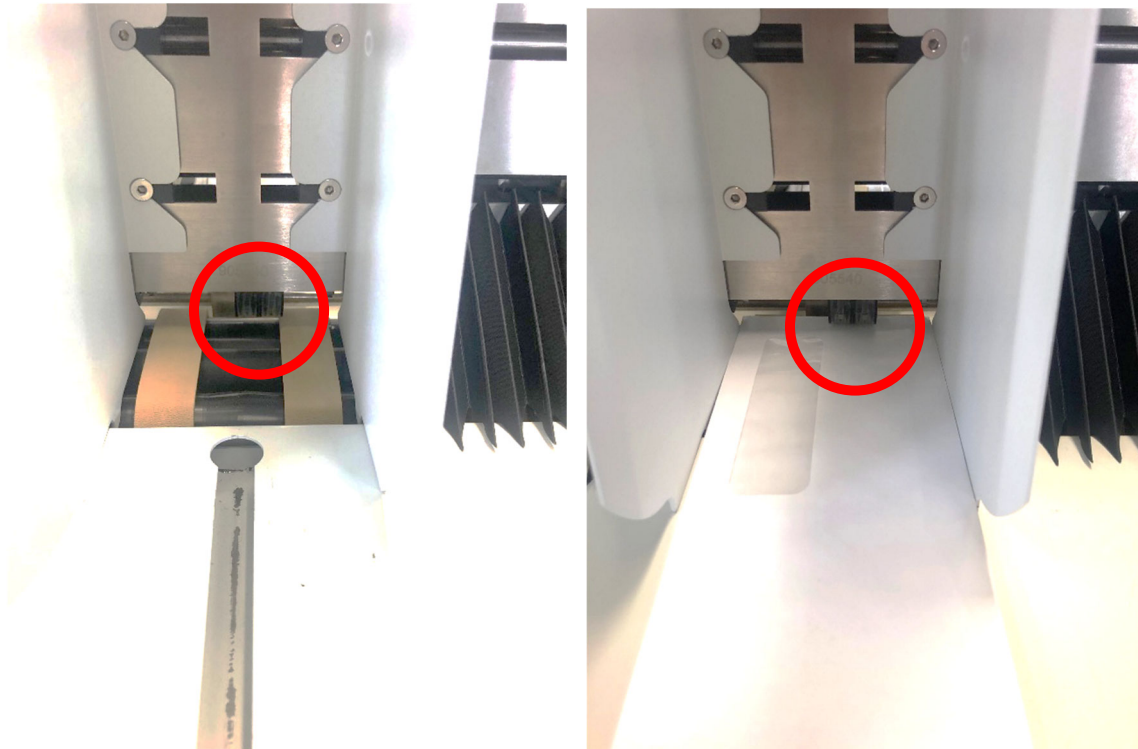
1. Turn the power switch to the Off position and remove the Feeder power cord from the power source.
2. Move the Feeder away from the Versant Bypass Tray.
3. Engage the J-Hook to lock the Discharge Assembly of the Feeder in the UP position.
4. Remove the Separator Assembly from the Separator Bracket by pushing down on the Separator Barrel while lifting up on the Separator Adjustment Knob (Repeat this process when re-installing the Separator Assembly onto the Separator Bracket).
5. Move the O-Ring assemblies along the shaft to change the O-Ring orientation on the Nudger.



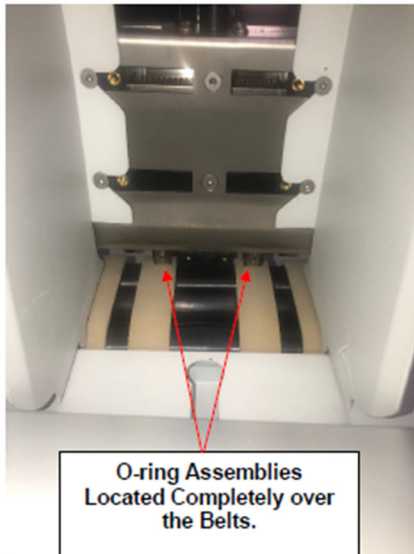
NOTE: As an alternative, you can use a screwdriver to separate the O-rings without removing the Separator Assembly. BE SURE THE UNIT IS POWERED OFF.



6. Slide the O-ring assembly/assemblies to the desired location on the Separator Assembly shafts. Examples of recommended O-ring assembly locations when feeding specific stock are shown below and on the next two pages.



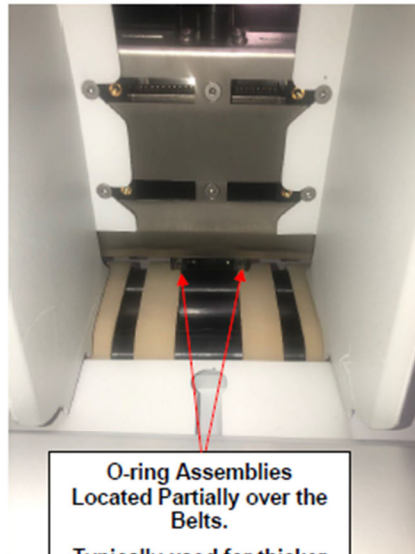
Off-centered O-ring Assembly Location - Avoids Hitting Windows on Windowed Envelopes



**O-ring Assemblies
Located Completely over
the Belts.**

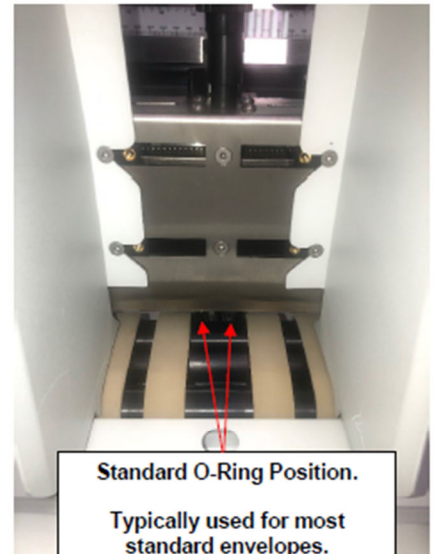
**Typically used for card
stock and other non-
envelope stocks.**

Default Position for
D Model



**O-ring Assemblies
Located Partially over the
Belts.**

**Typically used for thicker
envelopes.**



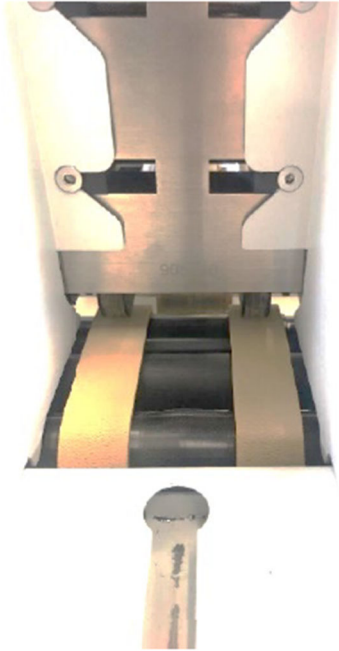
Standard O-Ring Position.

**Typically used for most
standard envelopes.**

Default Position for
A, B, and C Models

NOTE: Models A, B, and C have the default position of the O-ring assembly in between the belts. Model D has the default position of the O-ring assemblies directly on top of the belts.

NOTE: O-ring separator adjustment will be significantly more sensitive in the configuration shown below.



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Section 5 General Procedures

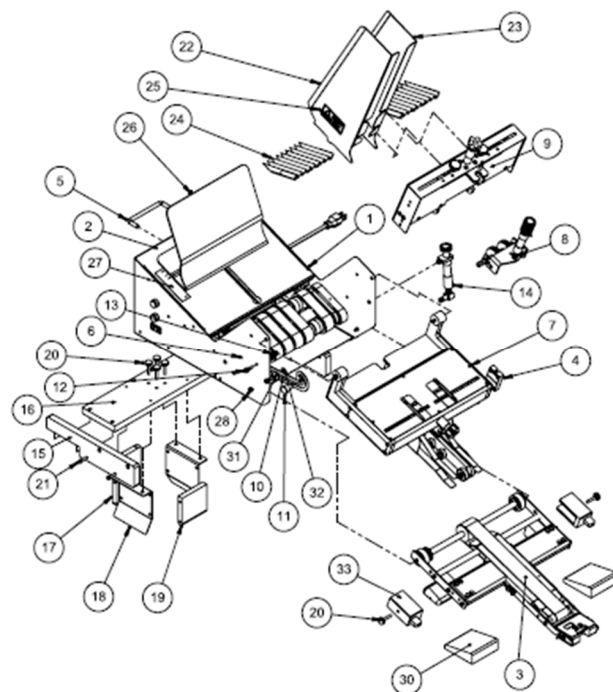
GP 5.1 Cleaning Feed Belts, Discharge Belts and O-Rings

1. Turn the power switch to O (off) and remove the power cord from the power source.
2. Apply a small amount of isopropyl alcohol to a soft cloth.
3. For belts, use moderate pressure to wipe across one belt at a time while manually rotating it.
Repeat for several rotations of each belt.
4. For O-rings, remove the gate assembly from the gate plate first and then wipe in each direction.

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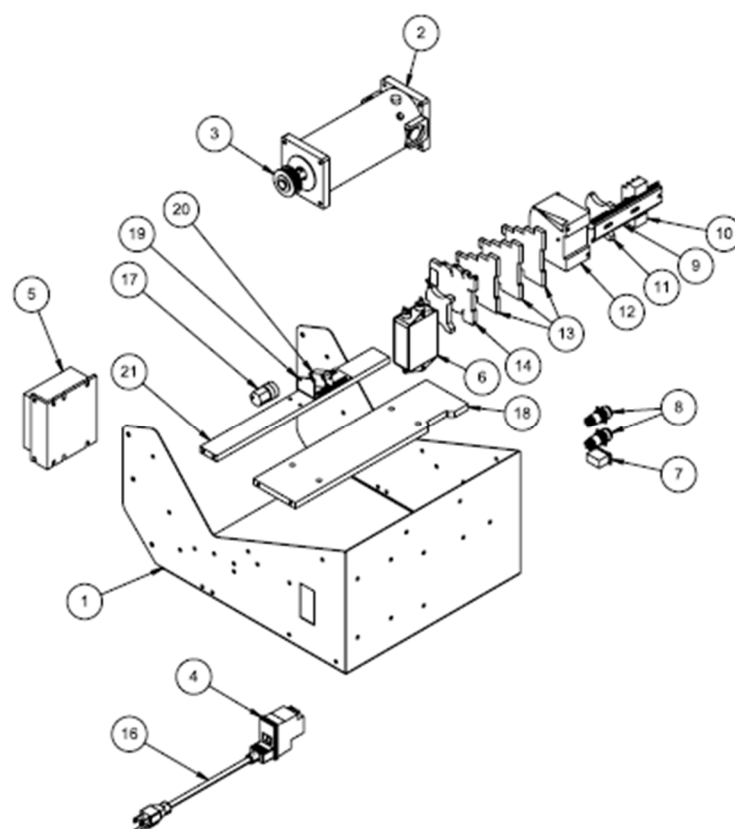
Section 6 Mechanical/Electrical Components

Feeder Assemblies



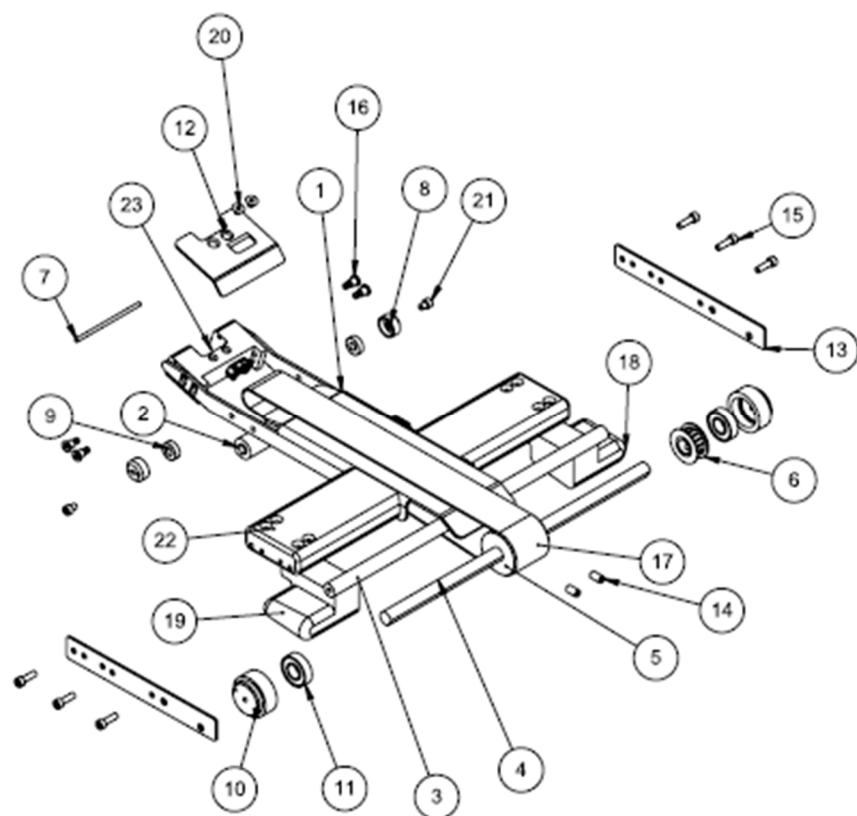
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	311-1705	BACK PANEL LAYOUT 115V
2	1	905763	LOADING DECK W/ PEMS
3	1	311-1816	DISCHARGE ASSEMBLY
4	1	611-0263	INTERLOCK SWITCH, MAGNETIC
5	1	44841002	HANDLE, PULL
6	1	311-1633	ASSY, CARRIAGE PF-125
7	1	311-1834	HINGED DISCHARGE
8	1	311-1846	ASSY, GATE SHEET METAL
9	1	311-1843	XPF HOPPER
10	1	906097	CATCH, J-HOOK
11	1	44857007	HANDLE STUDDED
12	2	102908B24	SCREW SHOULDER SH/SS Ø.25 X .25
13	1	116691B04	HEX NUT NY-LOK SST 10-24
14	1	311-1837	ASSY, HEIGHT ADJ
15	2	905899	STAND CONNECTION ARM
16	1	905881	PLATE, STAND MOUNT XEROX
17	1	905905	HANGER BRACKET
18	2	905930	POST COLLAR
19	1	905931	PLATE, COLLAR JOINER
20	6	311-1746	THREADED KNOB
21	4	102937B05	SHCSS SST 10-32 X .75
22	1	905823	SIDE GUIDE 1624X
23	1	905822	SIDE GUIDE 1624X
24	2	44800001	GUARD, REAR ACCORDION
25	2	53500609	LABEL, WARN INJURY 2.7 X 1.4
26	1	311-1691	ASSY, S WEDGE
27	1	905835	LABEL XEROX LOADING DECK
28	2	905980	SCREW, SHOULDER 1/4 X 10-32
29	1	311-1662	MTG.STAND X125 ENV FDR
30	2	906140	FEED WEDGE
31	1	107544B01	HEAVY FLAT WASHER SS .25 ID X 1/8 THK.
32	2	103272B02	FLAT WASHER SST 1/4 ID
33	2	906136	BYPASS TRAY ALIGNMENT BLOCK

Back Panel Assembly



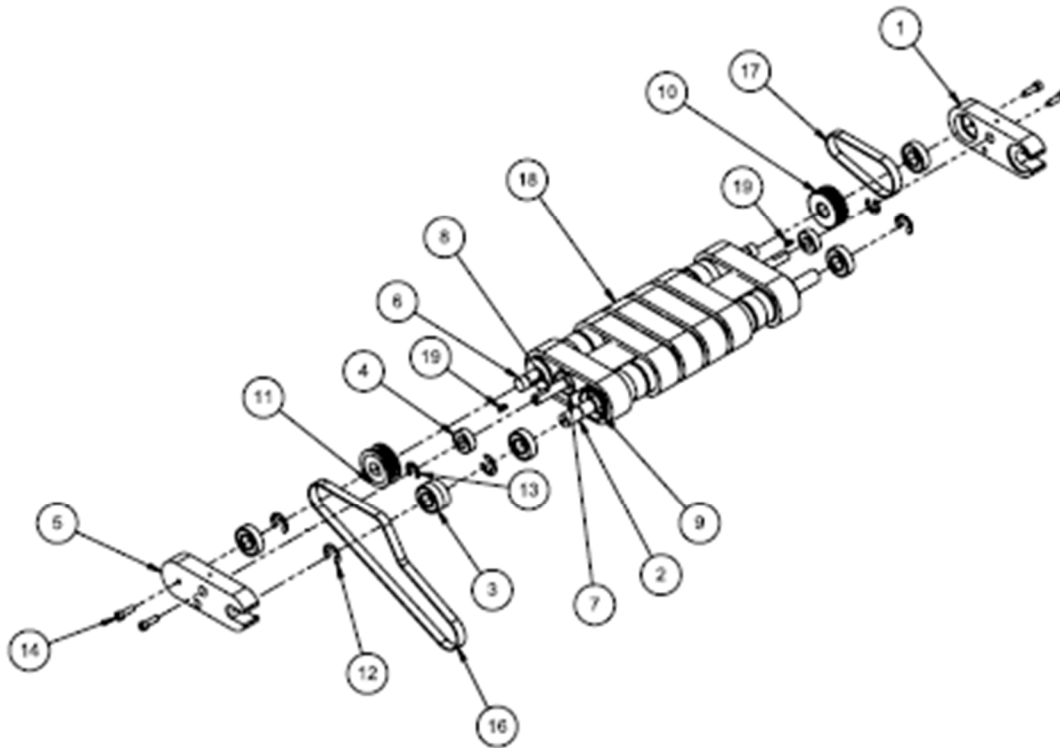
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	905760	FEEDER SHELL
2	1	10501133	ASSY, MTR 90VDC V710
3	1	44681027	PULLEY, TIMING 21T XL 1/2 BORE
4	1	44649034	MODULE, POWER ENTRY
5	1	51745123	DRIVE, REGEN
6	1	611-0233	HARNESS, POWER FILTER CE
7	1	53500014	SWITCH, ON/OFF
8	2	44608033	PUSH BUTTON SWITCH, BLUE
9	1	595-0003	DIN RAIL 35MM X 7MM
10	1	53500454	BASE, 24V RELAY
11	2	53500156	PLATE, ANCHOR END
12	1	44918002	POWER SUPPLY
13	3	197213	RELAY, W/BASE SLIM
14	1	356477	TIME DELAY RELAY FORM C
15	4	53500254	TERMINAL, FEMALE 22-18AWG.
16	1	904950	CORD 115V 15A 7.5FT
17	1	23511290	ASSY, BELT TENSIONER
18	1	905860	MOTOR MOUNT BRACKET
19	1	905862	BRACKET, SENSOR MOUNT
20	1	611-0199	SENSOR, NO PRODUCT
21	1	905863	SENSOR CROSS BAR

Discharge Assembly



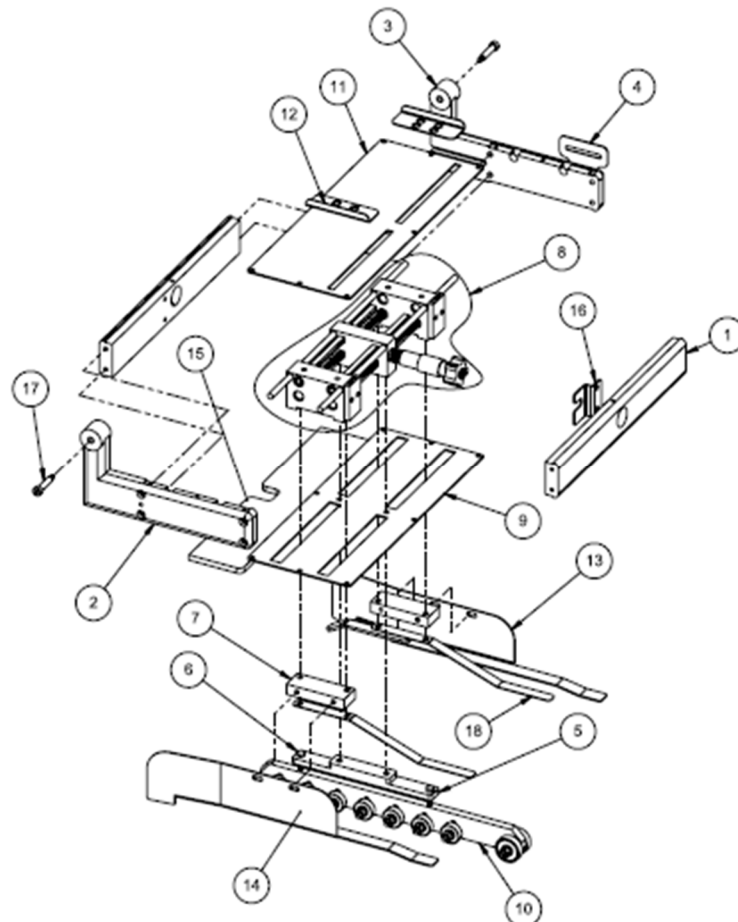
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	905737	DISCHARGE TABLE
2	1	905738	SHAFT, DISCHARGE
3	1	905562	SUPPORT SHAFT PF-125
4	1	905499	DISCHARGE DRIVE SHAFT
5	1	44450008	CROWN PULLEY VACUUM
6	1	43560097	PULLEY, TIMING 16T XL 1/2 BORE
7	1	905815	SHAFT DISCHARGE ROLLER
8	2	44846050	HOLDER, R4 BEARING
9	2	44582021	BEARING, BALL R4 .25 BORE
10	2	23500032	HOLDER, R8 BEARING CUP
11	2	23500094	BEARING BALL R8 .500 BORE
12	1	906115	FLOATING GATE PLATE
13	2	905745	JOIN BRACKET
14	2	102733B07	SSSCPPT BLACK OXIDE 1/4-20 X .50
15	6	102937B04	SHCSS SST 10-32 X .62
16	4	904846	SCREW SHSB 0.25X0.25 316 ULT LOW PROF
17	1	905839	DISCHARGE BELT
18	1	905885	BOTTOM ALIGNMENT BLOCK LH
19	1	905883	BOTTOM ALIGNMENT BLOCK LH
20	2	102916B01	SCREW, FHCS 10-32 X 0.25 SST
21	2	102937B01	SHCSS SST 10-32 X .25
22	2	906035	DISCHARGE, STRONG BLOCK
23	1	905547	FORK BRKT PF-125
24	1	611-0544	SHEET SENSOR

Carriage Assembly



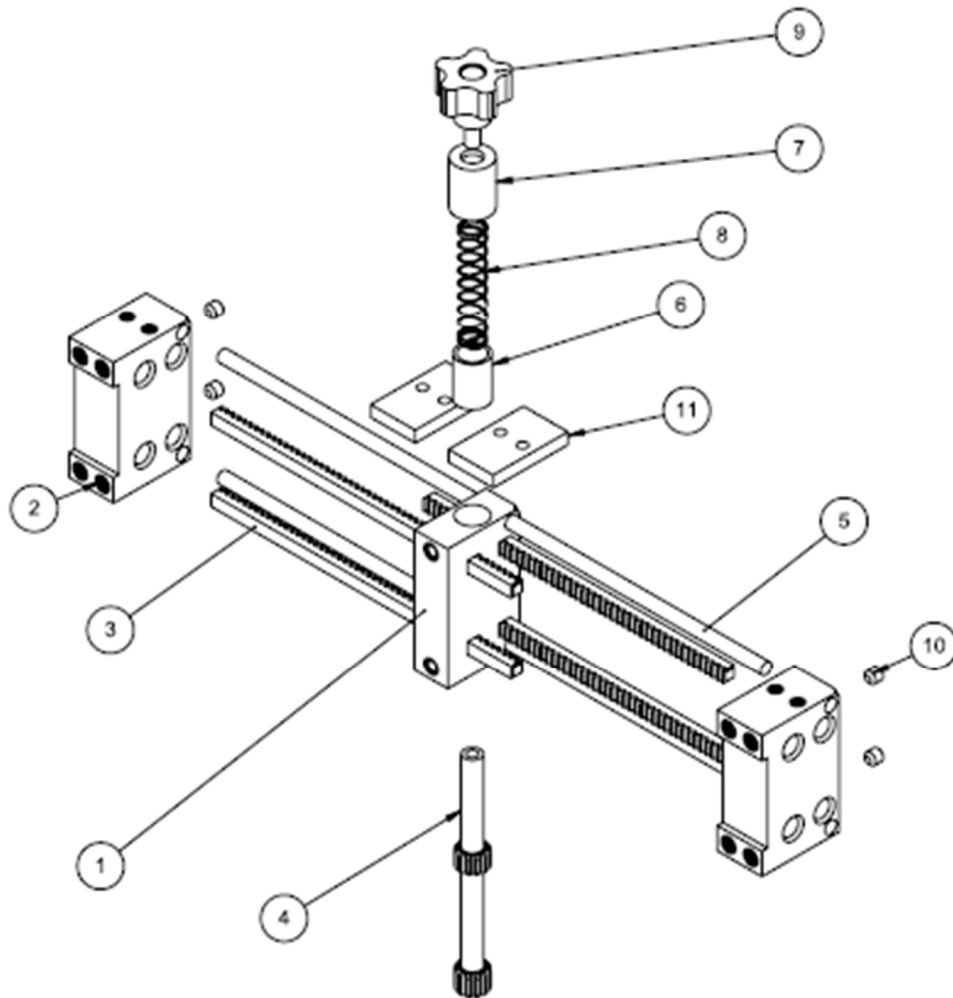
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	905508	LEFT SIDE CARRIAGE PF-125
2	1	43555047	IDLER SHAFT
3	6	23500094	BEARING BALL R8 .500 BORE
4	2	23500095	BEARING BALL R6 .375 BORE
5	1	905507	LEFT SIDE CARRIAGE PF-125
6	1	44630019	DRIVE SHAFT
7	1	44630003	BELT SUPPORT TUBE
8	1	44841056	VACUUM CARRIAGE SHAFT
9	1	44630004	DRIVEN TUBE
10	1	43560098	PULLEY, TIMING 24T XL 1/2 BORE
11	1	23500097	PULLEY, 20T TIMING .50 BORE
12	4	00001155	E-TYPE, STEEL CLIP FOR 1/2 SHAFT
13	2	00001150	E-TYPE, STEEL CLIP FOR 3/8 SHAFT
14	4	102937B04	SHCSS SST 10-32 X .62
16	1	905820	185XL037 DRIVE BELT
17	1	905821	085XL037 TIMING BELT
18	6	23500163	FEED BELT TAN GUM
19	2	905874	WOODRUFF KEY 1/8 X .371

Hinged Discharge Assembly



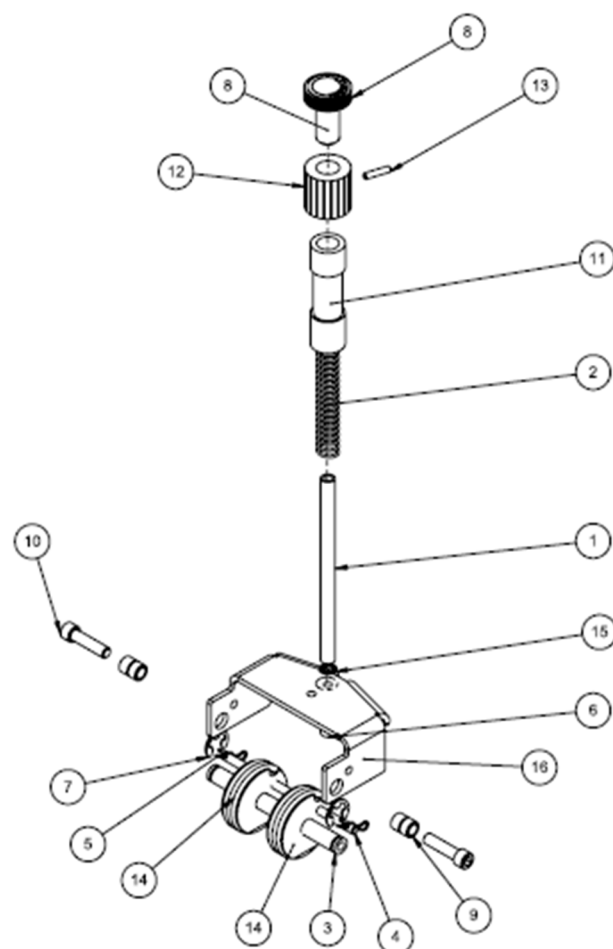
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	2	906028	CROSSBAR PLATE MOUNT
2	1	906025	HOLD DOWN MOUNT ARM RIGHT
3	1	906026	HOLD DOWN MOUNT ARM LEFT
4	1	906096	SAFETY DISCONNECT MOUNT
5	1	906050	HOLD DOWN MOUNTING BAR
6	2	906058	SCREW, HEX MACHINE 10-32 X 7/8
7	2	906032	BLOCK, SPACER
8	1	311-1817	ASSY ADV GAT STRT PLAT 12"
9	1	906030	PLATE, COVER BOTTOM
10	1	311-1686	ASSY, HOLD DOWN
11	1	906027	PLATE, COVER TOP
12	2	906055	BLOCK, ALIGN HORIZ
13	1	311-1839	SIDEGUIDE EXTENDED ANGLE LF
14	1	311-1840	SIDEGUIDE EXTENDED ANGLE RT
15	1	906044	GUARD, LEXAN
16	1	906049	BENT SPRING STOP PLATE
17	2	906078	SCREW, SHOULDER 10-32 X 1
18	2	906133	DOCKING GUIARD RT UPPER

Plate Assembly



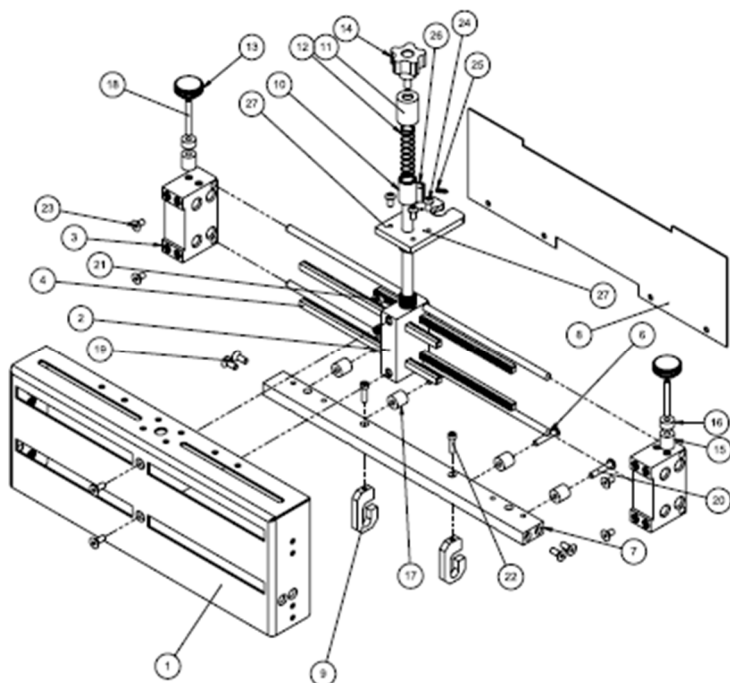
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44646002	BLOCK, SIDE GUIDE
2	2	44646001	BLOCK, SIDE GUIDE ADJUSTING
3	4	44646010	RACK
4	1	44646005	SHAFT, PINION ADJUSTMENT
5	2	906029	GUIDE, RAIL SIDE
6	1	44646007	RETAINER, LOWER SPRING
7	1	44646008	RETAINER, UPPER SPRING
8	1	44646013	SPRING, COMPRESSION
9	1	44646009	KNOB, 5 LOB 1/4-20 X 1/2 LG
10	4	102733B03	SSSCPPT BLACK OXIDE 1/4-20 X .25
11	2	906054	BLOCK, ALIGN VERT

Separator Assembly



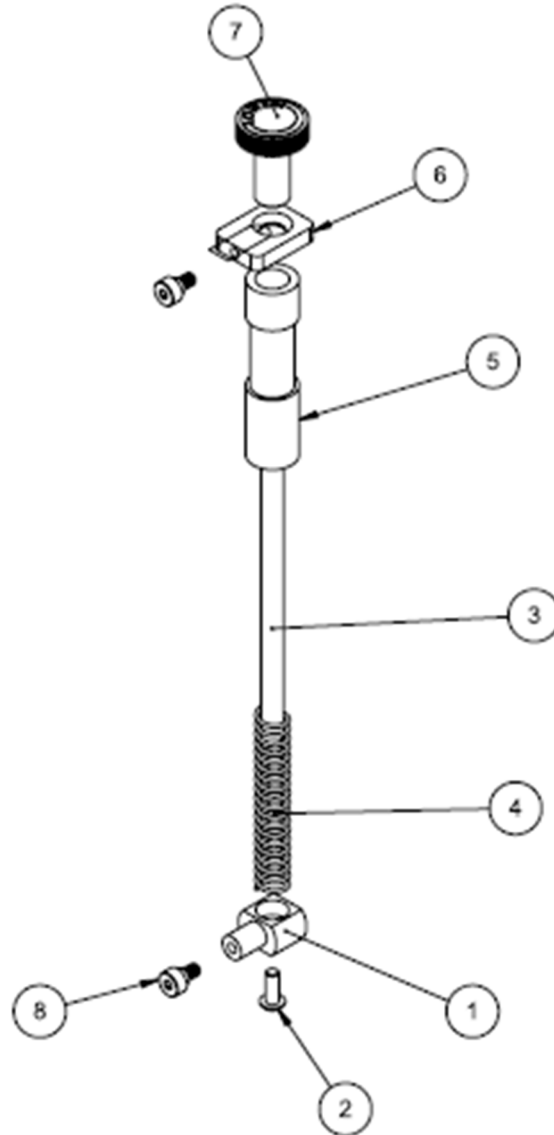
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	906036	SHAFT ADJ GATE LIFT
2	1	23500083	GATE COMPRESSION SPRING
3	1	906128	GATE MOUNTING SHAFT
4	1	23560246	SHAFT, GATE ALIGNMENT
5	2	23560247	HAIR COTTER PIN .19-.25X1.00 ZP
6	1	102937B03	SHCSS SST 10-32 X .50
7	2	904522	E-CLIP, SSTL FOR 3/8 SHAFT
8	1	311-1844	ASSY, KNB GATE CYLNDR ADJSTMNT
9	2	23500082	SPACER, GATE BUSHING OIL
10	2	102938B07	SHCS SSTL 1/4-20 X 1.00
11	1	23560242	CYLINDER GATE SPRING
12	1	906046	KNURLED KNOB
13	1	102727B08	SSSCPPT 6-32 X .62
14	2	311-1465	ASSY O-RING HD SPOOL
15	1	00002609SF	#10 INTERNAL STAR WASHER
16	1	906127	BASE GATE SHEET METAL

Hopper Assembly



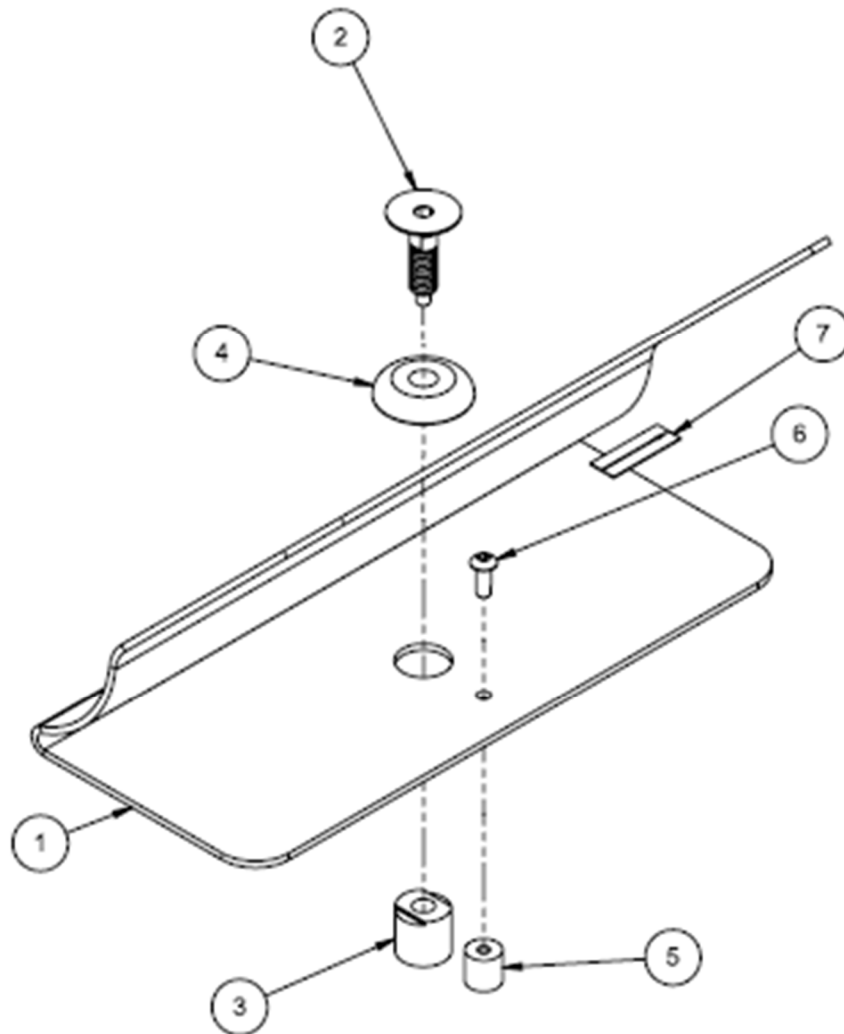
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	44909001	PLATE, GATE STR ST850
2	1	44846002	BLOCK, SIDE GUIDE
3	2	44846001	BLOCK, SIDE GUIDE ADJUSTING
4	4	44846010	RACK
5	1	44846005	SHAFT, PINION ADJUSTMENT
6	2	44846006	GUIDE, RAIL SIDE
7	1	44846003	BAR, LOWER GATE
8	1	44846012	COVER, GUIDE ADJUSTMENT
9	2	15000007	GATE "J" HOOK
10	1	44846007	RETAINER, LOWER SPRING
11	1	44846008	RETAINER, UPPER SPRING
12	1	44846013	SPRING, COMPRESSION
13	2	44881021	THUMB KNOB W/10-32 INSERT
14	1	44846009	KNOB, 5 LOB 1/4-20 X 1/4 LG
15	2	44846015	SPACER, LOWER
16	2	44846016	SPACER .50 OD X .19 ID X .25 LG
17	4	904745	SPACER .50 OD X .19 ID X .50 LG
18	2	102732B13	SSSCPPT BLACK OXIDE 10-32 X 1.50
19	6	102916B03	FHCS SSTL 10-32 X .50
20	4	102957B07	BHCS SST 10-32 X 1.00
21	4	102733B03	SSSCPPT BLACK OXIDE 1/4-20 X .25
22	2	102685B04	SHCS BLACK OXIDE 8-32 X .62
23	4	2802	FHCS SSTL 10-32 X .38
24	4	2805	BHCS SST 10-32 X .38
25	1	906081	6-32 SPRING PLUNGER SS
26	1	906043	ADJ SET SCREW MOUNT
27	1	906040	BRKT PUCK

Height Adjustment Assembly



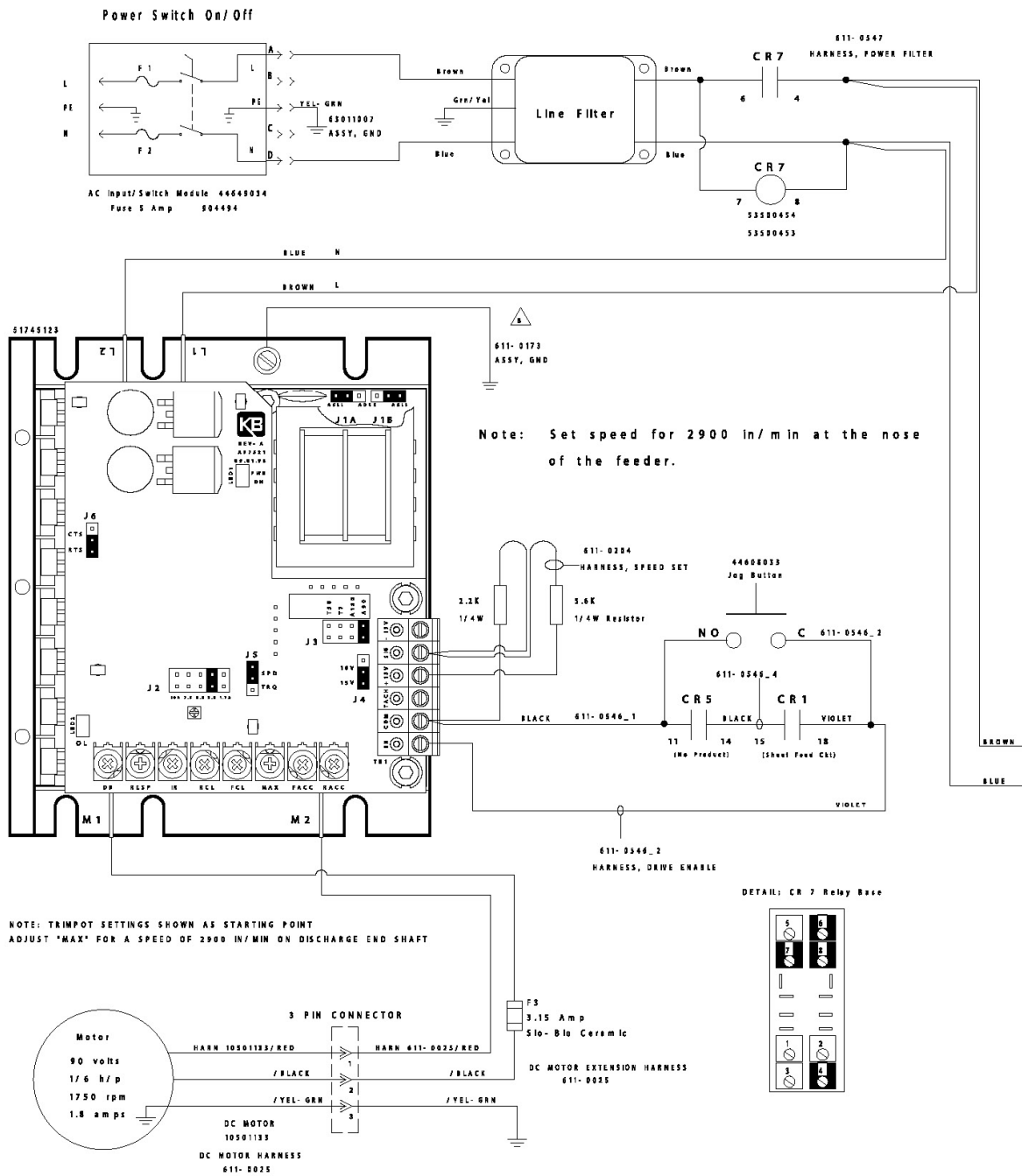
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	906125	BLOCK, MOUNT LOWER HEIGHT ADJ
2	1	102708B03	BHCS BLACK OXIDE 10-32 X .50
3	1	23560084	GATE LIFT SHAFT
4	1	23500083	GATE COMPRESSION SPRING
5	1	23500019	CYLINDER, GATE SPRING TENSION
6	1	906124	BLOCK, MOUNT UPPER HEIGHT ADJ
7	1	23511037	ASSY, KNB GAT CYLNDR ADJSTMNT
8	2	906126	SCREW, SHOULDER 1/4 X 1/8L 10-32

Wedge Assembly

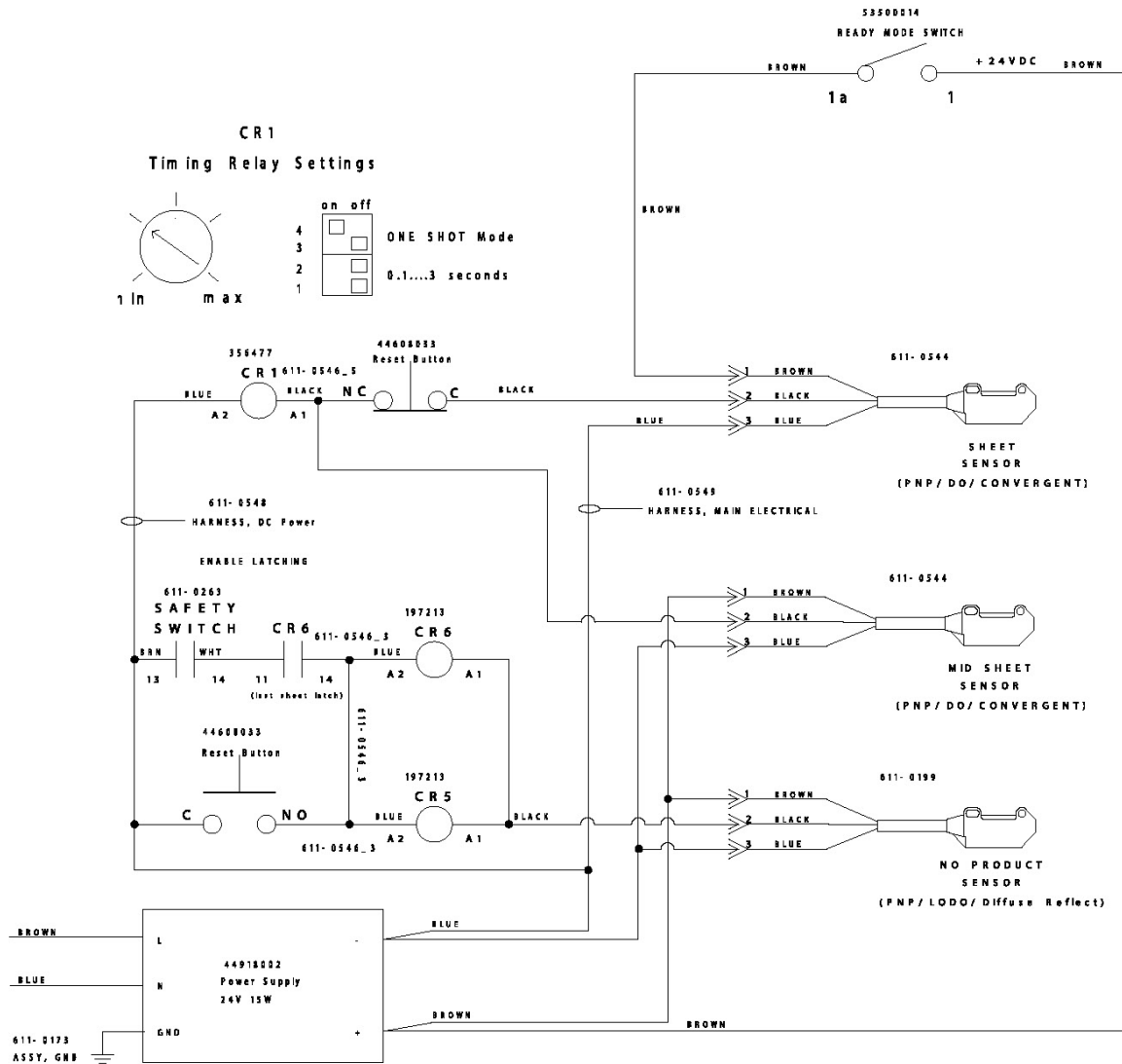


ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	905768	2-TIER WEEDGE PLATE
2	1	905777	WEDGE SPRING PLUNGER
3	1	905778	S WEDGE ALIGNMENT PUCK
4	1	905779	S WEDGE SPACER
5	1	905855	WEDGE KEEPER
6	1	102708B03	BHCSS SST 10-32 X .50
7	1	905858	LABEL XEROX WEDGE

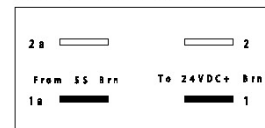
Electrical Schematic – 1 of 2



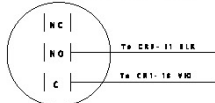
Electrical Schematic – 2 of 2



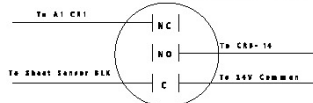
DETAIL: Ready Switch
(1a & 2a are BRASS)



DETAIL: Jog Button
(terminal side view)



DETAIL: Reset Button
(terminal side view)



Support

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Telephone 763-502-0000

Fax 763-502-0100

Email service@streamfeeder.com

Web www.streamfeeder.com

Online Parts Ordering:

http://www.barrywehmiller.com/Login/Loginfailed.asp?reason=denied_empty&script_name=/storefront/partsearch.asp

Telephone Parts Ordering and Inside Service Support (8am-5pm, Monday through Friday, CST)

Main: 1-612-782-1220- Extension 810-3221-Lynn Diskrud

Toll free U.S.A. and Canada: 1- 800-932-3647- Extension 810-3221-Lynn Diskrud

Lynn.diskrud@thieletech.com

Technical Assistance:

1-800-932-3647

1-612-782-1220

techsupportmn@thieletech.com

Obtaining Replacement Parts

Should you determine that a Xerox supplied part is suspect, obtain required spare parts through the normal Xerox spares part process.

