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Xerox[®] Color 800/1000 Press

User Guide



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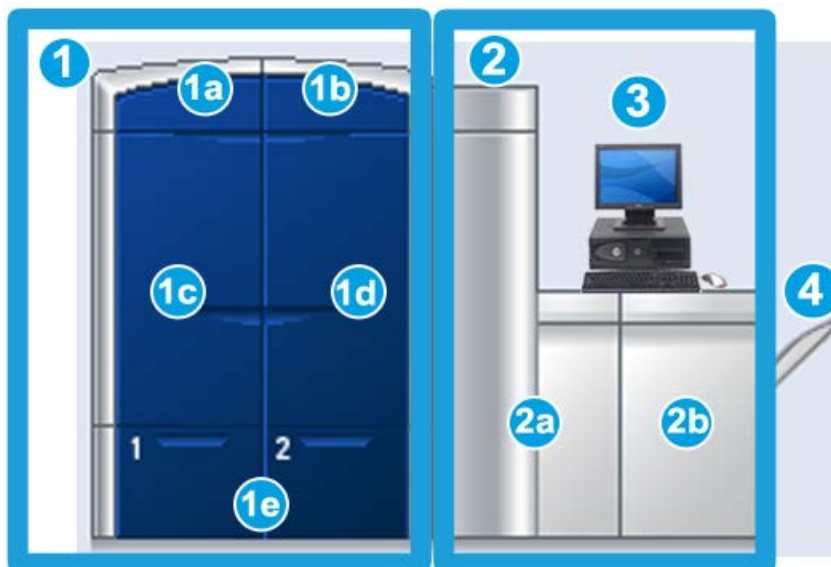
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Product overview

The Xerox 800/1000 Color Press is a full color/black and white network printer that operates at a speed of 80/100 prints per minute.

The following illustration shows a basic configuration of the digital press:



1. Print engine - left side
 - a. Upper left door: containing dry ink/toner cartridges
 - b. Upper right door: containing dry ink/toner cartridges
 - c. Left front door
 - d. Right front door
 - e. Trays 1 and 2; additional feeding accessories available
2. Print engine - right side
 - a. Left front door
 - b. Right front door
3. User Interface (UI)
4. Optional Offset Catch Tray (OCT); additional optional finishing accessories available

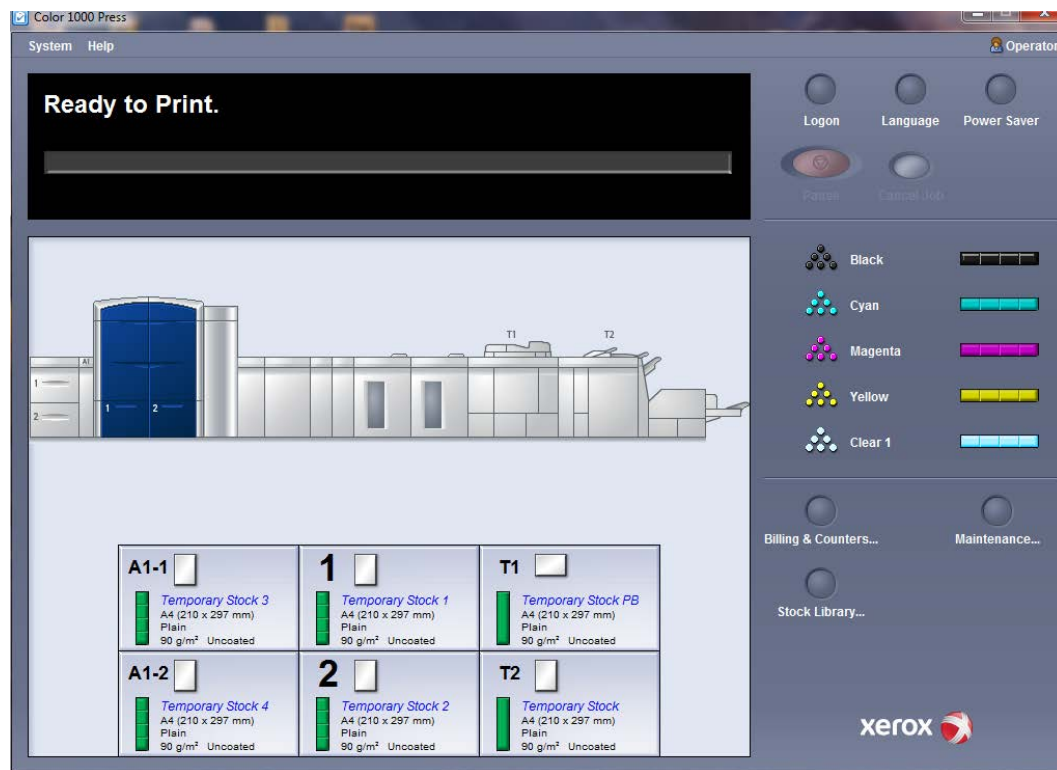
Quick start/links

The following quick links will help you start using your machine quickly and easily:

- [Power on/off the machine](#)
- [Where to find help](#)
- [Loading paper](#)
- [Submitting a print job](#)
- [Jam clearance](#)
- [Replacing a dry ink/toner cartridge](#)
- [Replacing a dry ink/toner waste bottle](#)
- [Logging on as Administrator](#)

User Interface

The User Interface (UI) displays messages that indicate the status of the machine during idle, run, or fault conditions.



Related Topics:

[User Interface help](#)

[System menu](#)

[Job status](#)

[Logon](#)

[Language](#)

[Power saver](#)

[Pause](#)

[Dry ink/toner status area](#)

[Maintenance \(on the UI\)](#)

[Manage Stock Library](#)

[Paper information](#)

[Machine status](#)

Logon

There are three logon levels:

- **Operator:** This is the default logon level.
- **Administrator:** This level allows you to customize the system defaults for your machine and to customize particular print jobs by creating, setting, or changing parameters for certain features.
- **Technical Key Operator:** This level is reserved for users who are certified by Xerox to perform certain maintenance activities that are normally done by a customer service engineer (CSE).

Note

Refer to the System Administration Guide for more information on the Administrator and Technical Key Operator features.

Related Topics:

[Logging on as Administrator](#)

Language

Note

The number of languages available on your system depends on what was installed during the initial installation process.

Selecting a particular Language button immediately changes the language. No confirmation is required.

Change language

To change the language, use the following procedure.

1. Select the **Language** button on the UI.
2. Select the desired language button; the language on the UI changes to the new language and closes the Language window.
3. Select the **Cancel** button to return to the main UI screen.

Power saver

The machine automatically enters the power saver mode after fifteen minutes of inactivity. This time may be changed to reflect a value of 1-240 minutes; you must enter the Administrator mode to change it.

There are two Power Saver modes:

- **System PC & Print Engine:** Selecting this option places both the machine and the System PC in power saver mode.
- **Print Engine Only:** Selecting this option places only the machine in power saver mode.

The system exits the Power Saver mode when a job is sent to be printed or the UI on the System PC is activated.

Note

To manually exit Power Saver mode, press the **Power Saver** button on the System PC.

Refer to the System Administration Guide for more information on this feature.

Print server overview

One of three print servers may be used with your digital press:

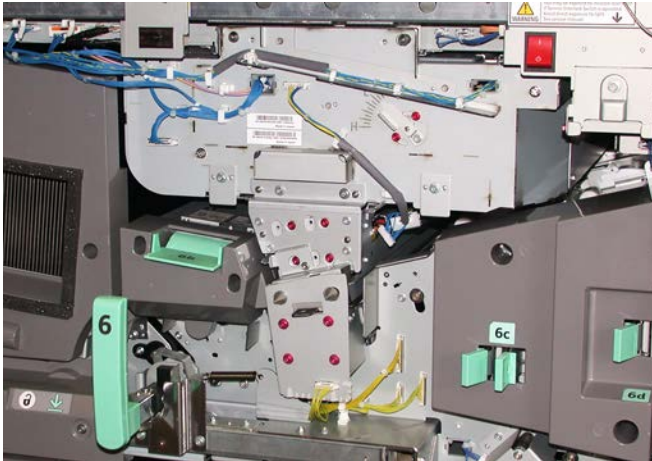
- Xerox® FreeFlow Print Server, for the Xerox® Color 800/1000 Press
- Xerox® CX Print Server, Powered by Creo®
- Xerox® EX Print Server, Powered by Fiery®

Note

For detailed information on your specific print server, refer to the customer documentation that was delivered with it.

Full Width Array

Your digital press may include an internal color calibration function referred to as Full Width Array. This is located in Area 6 of the print engine right side.



Note

The Full Width Array is an OPTIONAL feature that can be purchased for your system. For more information, contact your Xerox representative.

The Full Width Array feature uses xerographic parameters and diagnostics to scan the finished image and correct errors in registration, density and color. This is the process of calibrating the Print Server with the digital press. There are now internal color calibration strips (or tiles) used as reference for known colors of a test pattern. These color values are automatically adjusted to produce accurate and consistent reproductions, and this means that no longer is customer intervention required. It also allows the customer to maintain tighter image quality control over the output of their system.

Note

Refer to your Print Server user documentation when performing the calibration workflow of the Print Server in conjunction with the digital press. Also refer to the System Administration Guide for detailed information on the Full Width Array feature.

Clear dry ink

The clear dry ink is an optional fifth module that provides full and spot page coverage enhancement to print jobs.

The clear dry ink capability utilizes two methods to enhance the coverage area of printed output. These two methods are full flood and spot (applied to specific areas only). Both workflow methods use a “varnish” or clear coat to achieve desired effects, while also maintaining machine productivity. The clear dry ink module is supported by all print servers.



Productivity

With the usage of the clear dry ink module, machine productivity is maintained across all supported media, expanding the realm of endless capabilities including:

- Maintains full rated speed of 80/100 prints per minute (ppm) in five-color mode
- Supports both text and images

Full flood

Full flood varnish provides a uniform, glossy finish on the printed output when it is used with high-end applications. The full flood option provides full page coverage as a clear, glossy finish (varnish) which enhances the overall appearance within an application or on a single sheet.

Spot

Using the spot option within a supported application allows the user to indicate a specific area, or multiple areas where a clear dry ink will be applied to the printed output. This is done in order to accent or highlight the desired area. Spot varnish can be used to:

- “Varnish” (apply a glossy finish to) specific areas of a print job
- Create artistic effects and highlights on a print job
- Enhance the appearance of metallic items with key colors such as silver, gold, or copper
- Enhance pastel colors with a pearly luster affect
- Highlight images for visual variety to make them lift off the page (a three-dimensional affect)
- Draw attention to headline text
- Highlight photos, logos, or other image areas
- Highlight watermarks

Power on/off the machine

Use the power switch to power **ON** or power **OFF** the machine.

- Power on: Press the power switch to the **ON** position to power on the machine.

A screen message advises of a short wait while the fuser warms up and the machine runs a system check. You can program the machine for a job during this time and the printing process will start automatically when the machine is ready.

- Power off: Press the power switch to the **OFF** position to power off the machine.

Note

Allow the machine to remain off for a minimum of 10 seconds before switching the power on again.

The Power on/off switch is found on the Print Engine Right Side as shown in the following illustration. The circled area indicates the location of the power switch.

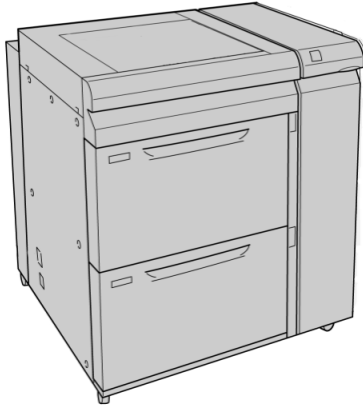


Feeding and finishing devices

Available with your machine is a variety of optional feeding and finishing devices. These devices are briefly discussed on the following pages along with where to find specific information on each device.

Oversized High Capacity Feeder (OHCF)

2-tray Oversized High Capacity Feeder (OHCF)



Related Topics:

[Oversized High Capacity Feeder \(OHCF\)](#)

Interface Module

Important

The Interface Module is required with ALL finishing devices.

The Interface Module provides communication and a paper path between the print engine and any attached finishing device or devices.

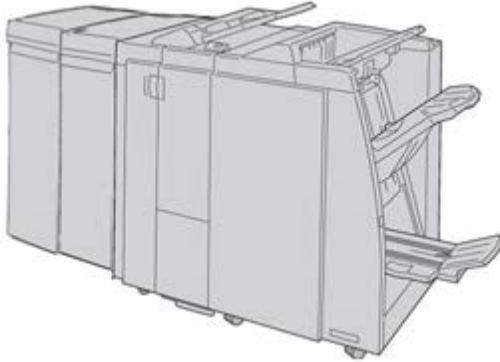


Related Topics:

[Interface Module](#)

GBC AdvancedPunch

The GBC AdvancedPunch provides another level of finishing options to your output by allowing you to punch holes in 8.5 x 11 in./A4 documents which support a variety of binding styles. Punch types include 19-hole to a maximum of 32-Hole for 8.5 x 11 in. media. A4 media supports punch types 21-hole to a maximum of 47-hole.



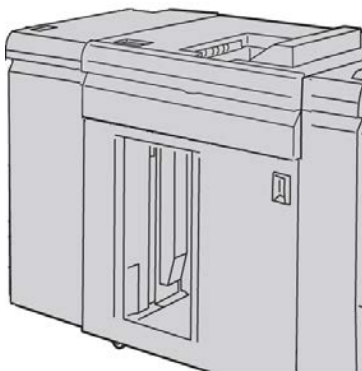
Note

The GBC AdvancedPunch is shown here with the required Interface Module and with the optional Booklet Maker Finisher. The GBC AdvancedPunch can be attached to a variety of optional finishing accessories.

Information on this accessory can be downloaded from www.xerox.com to download the latest version of the desired user guide by entering the product name in the Search field and then selecting the User Documentation link.

High Capacity Stacker (HCS)

The High Capacity Stacker (HCS) is an optional finishing device that provides stacking and offsetting capabilities for output to a Stacker Tray.



Related Topics:

[High Capacity Stacker \(HCS\)](#)

Perfect Binder

The Perfect Binder is an optional finishing device that takes the printed output and binds it into a finished book; an optional front and back cover may be included with the bound output.



Perfect binding is a process in which the leaves (pages) are bound by using an adhesive and trimming off the excess edges. The adhesive holds the interior sheets of the book together. Front and back covers may be included if desired. The final output is a finished, perfect bound book with a wrap-around cover.

Note

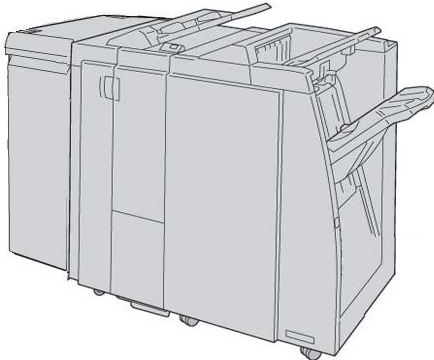
The Perfect Binder requires the Interface Module.

Related Topics:

[Perfect Binder](#)

Standard Finisher

This finisher provides a wide range of finishing/folding options.



Note

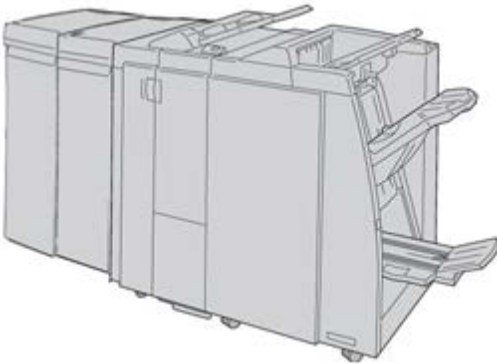
The Standard Finisher is shown here with the required Interface Module and with the optional C/Z Folder.

Related Topics:

[Standard/Booklet Maker Finisher](#)

Booklet Maker Finisher

This finisher provides a wide range of finishing/folding options.



Note

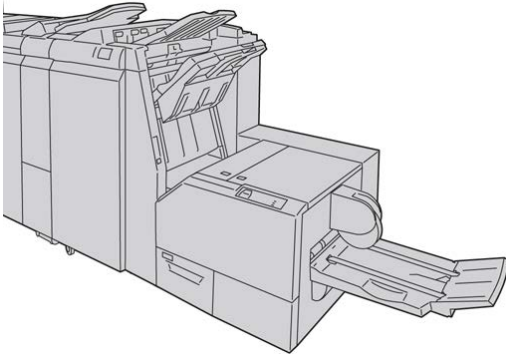
The Booklet Maker Finisher is shown here with the required Interface Module and with the optional C/Z Folder.

Related Topics:

[Standard/Booklet Maker Finisher](#)

SquareFold Trimmer Module

The SquareFold Trimmer Module is an optional finishing device that is used in conjunction with a finishing device that contains a booklet maker.



Note

The SquareFold Trimmer Module is shown here with the required Interface Module and the required Booklet Maker Finisher.

Related Topics:

[SquareFold Trimmer Module](#)

Standard Finisher Plus

The Standard Finisher Plus serves as an interface to transfer paper between the print engine and any third-party, Document Finishing Architecture (DFA) device attached to the machine.



Note

The Standard Finisher Plus requires the Interface Module.

Related Topics:

[Standard Finisher Plus](#)

Third-party finishing devices

Additional third-party, Document Finishing Architecture (DFA) devices are also available. Always refer to the Finishing Solutions Guide and/or contact the Xerox sales representative for more information.

Note

All third-party, DFA devices require BOTH the Interface Module and the Standard Finisher Plus.

Where to find help

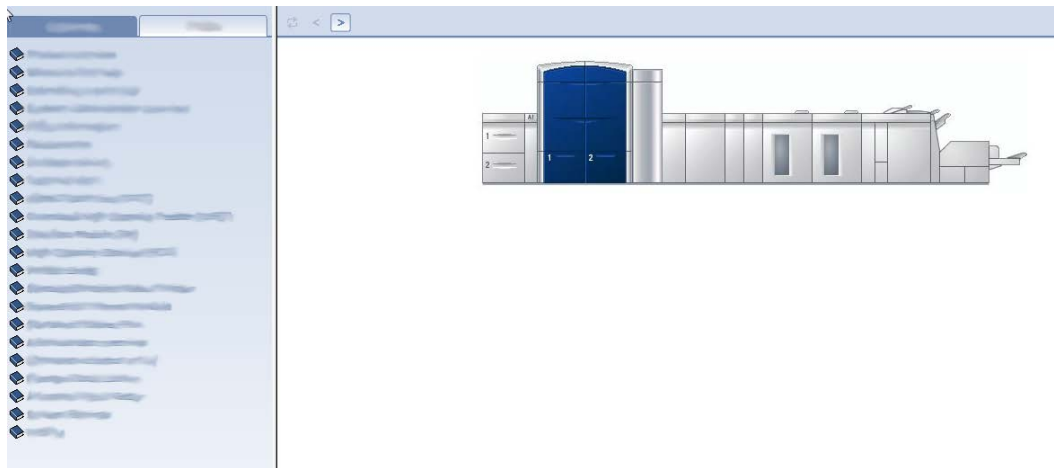
User Interface help

Your machine's User Interface (UI) comes with online Help.

This online Help provides information on:

- How to use and maintain your machine and optional accessories
- How to set up and change passwords and default settings

Selecting **Color 800/1000 Help** from the **Help** pull-down menu opens a new window which displays the same type of information as provided in both this guide and the System Administration Guide.



Once the main Help window opens, various help topics and information are available:

- On the left side of the help window two tabs are available:
 - **Content:** Select this tab to have access to the various machine help information, such as Product Overview or Paper Information.
 - **Index:** Select this tab to access a full index and the selection of specific topics/areas of interest or point of need.
- In the Content area main topics are displayed to the right of the book icons. Selecting a book icon expands the view and provides selections to subtopics.

Where to find help

- The right and left arrow buttons advance forward or backward one topic at a time using the same order as displayed on the Content tab.

Help on the World Wide Web

Xerox on the World Wide Web: For system support, user help, customer documentation, and service support, go to www.xerox.com and click on the **Contact Us** link for specific contact information/telephone numbers in your area.

It may be helpful to know your machine serial number before calling for support. The machine serial number is shown on the Machine Details tab (**System > Machine Details**).

[Related Topics:](#)

[System menu](#)

Print server customer documentation

Supporting customer documentation for your print server is on a CD/DVD and is shipped with the print server. You or your System Administrator should print these documents, after the installation is complete.

Machine/job status

Related Topics:

[Locating the machine serial number](#)

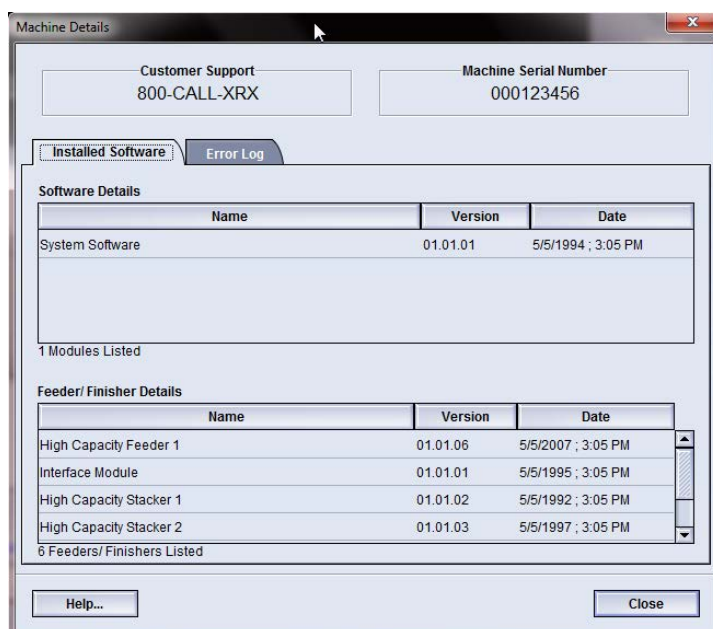
[Calling for service](#)

Machine status

System menu

The System menu allows you to select the following options:

- **Machine Details:** This option provides information about the installed system software, any attached optional feeding/finishing accessories, error log details, customer support telephone number, and the machine serial number.



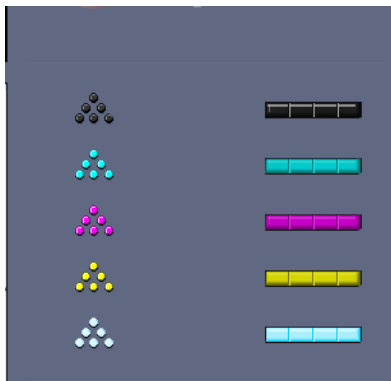
- **Shutdown System PC:** This option shuts down the User Interface and the system PC.

- **Restart User Interface:** This option stops and exits the User Interface and then restarts it.
- **Exit User Interface:** This option exits the User Interface but leaves the System PC running.

Dry ink/toner status area

This area of the UI displays the status of the dry ink/toner cartridges with a gauge indicating the level/amount of dry ink/toner for each cartridge.

Note



Your machine may have an optional fifth dry ink/toner cartridge installed. All characteristics described for the dry ink/toner cartridges also applies to the optional fifth dry ink/toner cartridge as well.

Related Topics:

[Replacing a dry ink/toner cartridge](#)

Billing and Counters

The meters/counters vary depending on your machine configuration and setup.

Related Topics:

[Billing and counters information](#)

[Impressions information](#)

[Viewing/reseting Billing Meters/Usage Counters](#)

Viewing/reseting Billing Meters/Usage Counters

Note

The Billing Meters CANNOT be reset.

1. From the machine's UI, select the **Billing and Counters** feature.
2. The **Billing Meters and Usage Counters** screen is displayed.
3. To reset the counters, perform the following:

- a) Select the Usage Counters tab.
 - b) Select **Reset All**.
A screen displays the following message: Are you sure you want to reset all the usage counters to zero?
 - c) Select **Yes** to reset the counters; select **No** to exit and return to the meters/counters.
4. Select **Close** to exit the meters/counters and return to the main UI.

Billing and counters information

- The **Billing Meters** tab displays the total number of prints for both black and white and color output. The information displayed may vary from market place to market place.

Note

These meters CANNOT be reset.

- The Usage Counter tab works the same way as a trip odometer in a car. It can be reset to zero. Once it is reset to zero, it keeps track of the print count from that point forward until you select the **Reset All** button.

Note

If the optional clear dry ink/toner is present, the Usage Counters tab displays two additional print counters: Clear Impressions and Clear Large Impressions.

Note

The information displayed on this screen may vary from market place to market place.

Impressions information

The meter and counters display the total impression amount. An impression is the image on one side of one sheet of media. The meters and counters display the total impression amount for all printed jobs. The impression information is separated into the following categories:

- **Color Impressions:** This value (number) represents the total number of color impressions regardless of the media size.
 - For each color, one-sided printed output, the meter increases by one.
 - For each color, two-sided printed output, the meter increases by two.
- **Black Impressions:** This value (number) represents the total number of black-only impressions regardless of the media size.
 - For each black-only, one-sided printed output, the meter increases by one.
 - For each black-only, two-sided printed output, the meter increases by two.
- **Total Impressions:** This value (number) represents the total number of ALL impressions regardless of size or color. It is the sum of the Color Impressions and the Black Impressions combined.

- **Color Large Impressions:** This value (number) represents the total number of large color impressions. These impressions are one side of one sheet of large media (for example 11 x17 in./A3). Large Impressions are any prints that are larger than 8.5 x 14 in./B4 size.
 - For each large, color, one-sided printed output, the meter increases by one.
 - For each large, color, two-sided printed output, the meter increases by two.

Note

This meter/counter is NOT added to the Total Impressions meter/counter since it is already added to the Color Impressions meter/counter.

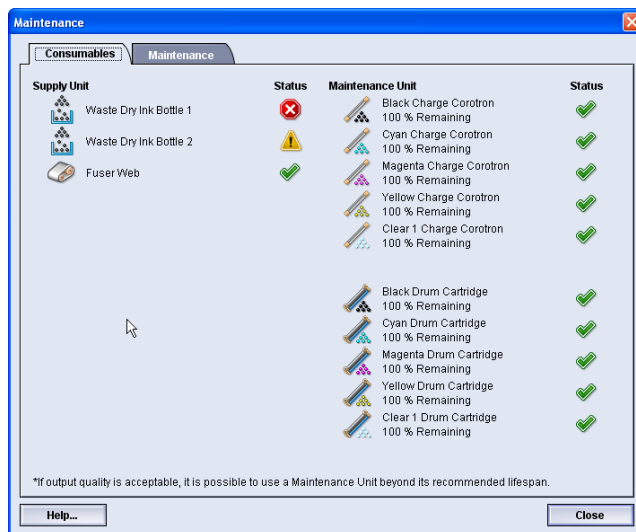
- **Black Large Impressions:** This value (number) represents the total number of large, black-only impressions. These impressions are one side of one sheet of large media (for example 11 x17 in./A3). Large Impressions are any prints that are larger than 8.5 x 14 in./B4 size.
 - For each large, black-only, one-sided printed output, the meter increases by one.
 - For each large, black-only, two-sided printed output, the meter increases by two.

Note

This meter/counter is NOT added to the Total Impressions meter/counter since it is already added to the Black Impressions meter/counter.

Maintenance (on the UI)

Selecting **Maintenance** on the UI opens a window which displays a status of each consumable.



If logged on as Administrator, the additional **Maintenance** tab is available. Refer to the System Administration Guide for more information

Note

When a Customer Replaceable Unit (CRU) consumable item is depleted, the machine automatically interrupts the current job and does not restart until the consumable is replaced.

Tip

The machine does not interrupt a job or stop running if a Service Representative Replaceable Unit status indicates a low or depleted level. Your Service Representative Replaceable Unit may continue to perform as expected far beyond the average life indicator. Your Service Representative uses this status indicator information each time service is performed on your machine.

Related Topics:

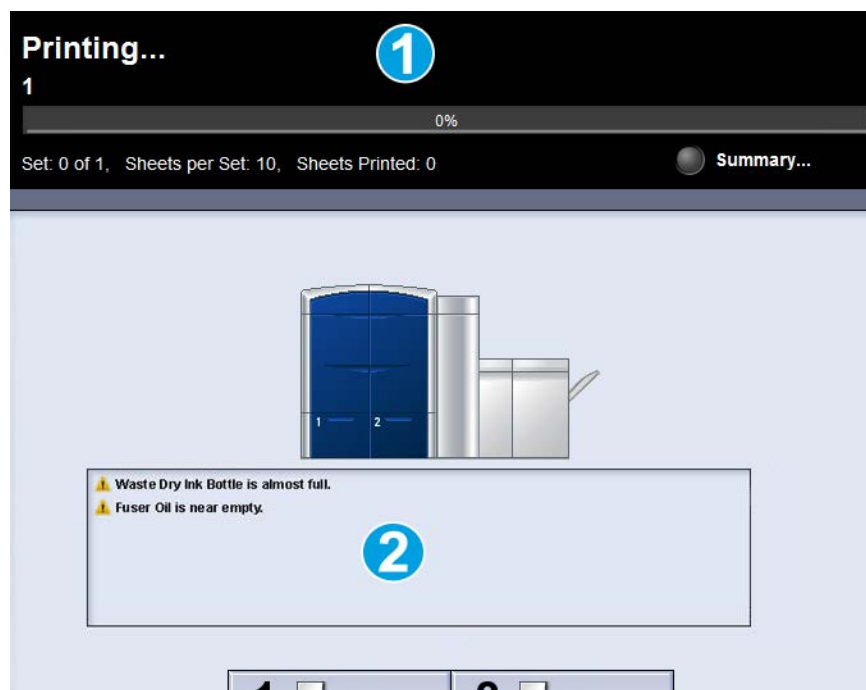
[Replacing consumable supplies](#)

[Consumable supplies](#)

Job status

Job/machine status area

This area of the screen displays the status of the machine as well as displaying the status of any currently printing job (Summary button).



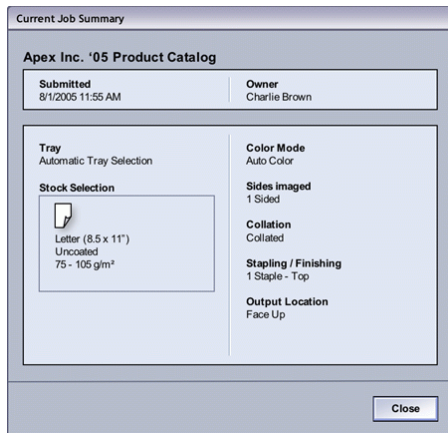
1. Job status area
2. Machine status area

Tip

Some print servers do not update the print engine with the status of the job that is currently printing. This means that the progress bar on the print engine's UI may continue to display zero percentage (0 %) for the printing status. If this occurs, always check the print server's UI for the status of the currently printing job.

Job summary

Selecting the **Summary** button opens the **Current Job Summary** window. The **Summary** button is selectable only when jobs are currently printing.



Pause

Selecting the **Pause** button during a print job stops or pauses the printing process.

Once a print job is paused, you may resume printing or cancel the job.

Note

Depending on the Administrator setting, your machine may automatically resume printing after a preset period of time without selecting the Resume button. Ask your Administrator about this, or refer to the System Administration Guide for more information.

Submitting a print job

These exercises require the PDF files for the User Guide and System Administration Guide. If you do not have an electronic copy of these PDFs, download them from www.xerox.com.

The exercises instruct you on how to print one of the customer documentation guides (User Guide or System Administration Guide).

Printing from your computer

1. From your computer open one of the PDFs files in Adobe Acrobat Reader.
2. Select **File > Print**.
3. Select the desired printer and print queue.
4. Select the **Properties** button (for that machine).
5. Select the desired output options (such as quantity, 1- or 2-sided printing).
6. Select **OK** to close the Properties window.
7. Select **OK** to send the job to the printer.

Printing from the Xerox FreeFlow Print Server

1. Copy the customer documentation PDF files onto a storage device (such as a flash drive or CD/DVD).
2. Connect your storage device to the print server.
3. From the FreeFlow Printer Server, select **Services > Print from File**.
4. Select **Browse**.
5. Browse to your storage device containing the PDF files.
6. Select and highlight one of the PDF files (User Guide, System Administration Guide).
7. Select **OK**.
8. Select the desired print queue.
9. Select the desired output options (such as quantity, 1- or 2-sided printing).

Submitting a print job

10. Select **Print**.

The job is sent to the desired queue and either held or immediately printed.

11. Select **Close**; this closes the Print From File window.

Printing from the Xerox EX Print Server, Powered by EFI

1. Copy the customer documentation PDF files onto a storage device (such as a flash drive or CD/DVD).
2. Connect your storage device to the print server.
3. From the Xerox EX Printer Server, select **File > Import Job**.
4. Select the desired queue (such as **Print** or **Hold**).
5. Select **Add**.
6. Browse to your storage device containing the PDF files.
7. Select and highlight one of the PDF files (User Guide, System Administration Guide).
8. Select **Open**.
9. Select **Import**.

The job is sent to the selected queue or to the printer for immediate printing.

Printing from the Xerox CX Print Server, Powered by Creo

1. Copy the customer documentation PDF files onto a storage device (such as a flash drive or CD/DVD).
2. Connect your storage device to the print server.
3. From the Xerox CX Printer Server, select **File > Import**.
4. Select the desired queue (such as **ProcessStore** or **ProcessPrint**).
5. Browse to your storage device containing the PDF files.
6. Select and highlight one of the PDF files (User Guide, System Administration Guide).
7. Select **Add**.
8. Select **Import**.

The job is sent to the selected queue or to the printer for immediate printing.

System Administrator overview

Logging on as Administrator

1. Select the **Logon** button from the main UI window.
The Logon screen appears.
2. From the Logon screen select Administrator.
3. Use the keyboard to enter the Administrator password.

Note

For security reasons, only asterisks are displayed on the screen.

4. Select the **OK** button.

Note

It is recommended that you change the Administrator password as soon as possible after installing the machine in order to prevent unauthorized access to the Administrator mode.

5. To exit the Administrator mode, select the **Logoff** button.

System administrator options

The system Administrator mode includes setting, changing, and testing the following features:

- Paper Curl Settings (Advanced Stock Setup)
- Running test prints (for changes made to Advanced Stock Setup options)
- System Setting functions, including:
 - Language
 - Changing the Administrator password
 - Resetting the Technical Key Operator password
 - Automatic display of fault windows

System Administrator overview

- Date and time
- Productivity settings
- Power saver settings
- Attention sounds
- Tray options, such as automatic tray switching (ATS)
- Output Devices
- Image quality options
- Full Width Array
- Profiles functions, including:
 - Alignment
 - Fold Adjustment; this feature is displayed if the optional finisher is attached
 - Finishing Devices: This option is available only if an optional, third-party, Document Finishing Architecture (DFA) device is attached to your system. This feature allows you to choose specific settings for that attached DFA device.

For detailed information and instructions on the various Administrator functions, refer to the System Administration Guide.

Paper information

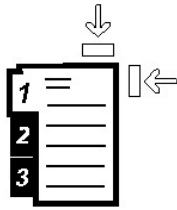
Loading media in Trays 1 and 2

Loading paper

1. Select the appropriate paper stock for your print job.
2. Pull out the tray slowly until it stops.
3. Open the ream of paper with the seam side facing up.
4. Fan the sheets before loading them into the tray.
5. Load and register the paper against the right side of the tray.
6. 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.
Do not load materials above the MAX line located on the rear Edge Guide.
7. If necessary, set the skew adjustment levers to the desired position for your print job.
8. Gently push in the tray until it comes to a stop.
If enabled by your System Administrator, the Paper Tray Properties screen may be displayed on the UI.
9. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.
10. Select **OK** to save the information and close the Tray Properties window.

Loading tab stock

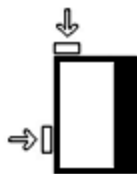
1. Select the appropriate paper stock for your print job.
2. Pull out the tray slowly until it stops.
3. Fan the tab paper before loading into the tray.
4. Load and align the edge of the tab paper against the right edge of the tray in the LEF direction as shown in following illustration:



5. 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.
Do not load materials above the MAX line located on the rear Edge Guide.
6. If necessary, set the skew adjustment levers to the desired position for your print job.
7. Gently push in the tray until it comes to a stop.
If enabled by your System Administrator, the Paper Tray Properties screen may be displayed on the UI.
8. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.
9. Select **OK** to save the information and close the Tray Properties window.

Loading transparencies

1. Select the appropriate paper stock for your print job.
2. Pull out the tray slowly until it stops.
3. Fan the transparencies to stop them from sticking together before loading into the tray.
4. Load transparencies on top of a small stack of same-size paper and align the edge of the transparency against the right edge of the as shown in following illustration:

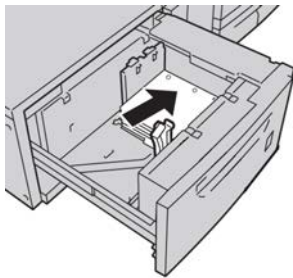


5. Adjust the paper guides by pressing in the guide release and carefully moving the Edge Guide until it lightly touches the edge of the material in the tray.
Do not load materials above the MAX line located on the rear Edge Guide.
6. If necessary, set the skew adjustment levers to the desired position for your print job.
7. Gently push in the tray until it comes to a stop.
If enabled by your System Administrator, the Paper Tray Properties screen may be displayed on the UI.

8. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.
9. Select **OK** to save the information and close the Tray Properties window.

Loading pre-drilled stock for 1-sided print jobs

1. Select the appropriate paper stock for your print job.
2. Pull out the tray slowly until it stops.
3. Open the ream of paper with the seam side facing up.
4. Fan the sheets before loading them into the tray.
5. Load and register the paper against the right side of the tray as depicted below for LEF direction:



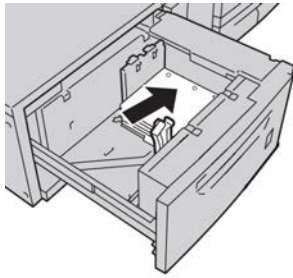
6. Adjust the paper guides by pressing in the guide release and carefully moving the Edge Guide until it lightly touches the edge of the material in the tray.
Do not load materials above the MAX line located on the rear Edge Guide.
7. If necessary, set the skew adjustment levers to the desired position for your print job.
8. Gently push in the tray until it comes to a stop.
If enabled by your System Administrator, the Paper Tray Properties screen may be displayed on the UI.
9. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.
10. Select **OK** to save the information and close the Tray Properties window.

Loading pre-drilled stock for 2-sided print jobs

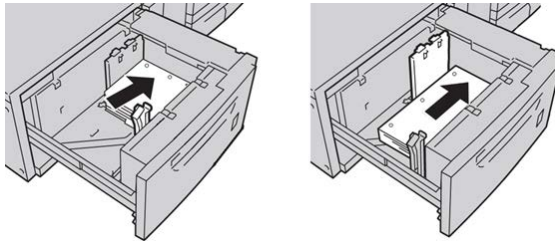
Load drilled paper into any tray in either Long Edge Feed (LEF) or Short Edge Feed (SEF) direction.

1. Select the appropriate paper stock for your print job.
2. Pull out the tray slowly until it stops.
3. Open the ream of paper with the seam side facing up.
4. Fan the sheets before loading them into the tray.

5. Load and register the paper against the right side of the tray as depicted below for LEF direction:



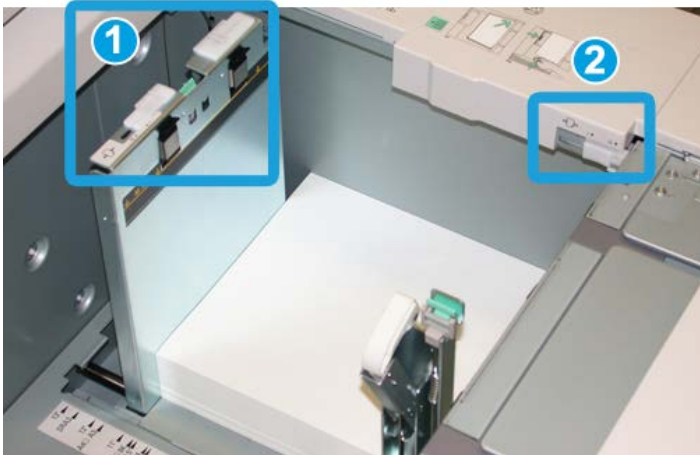
6. Load and register the paper against the right side of the tray as depicted below for SEF direction:



7. 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.
Do not load materials above the MAX line located on the rear Edge Guide.
8. If necessary, set the skew adjustment levers to the desired position for your print job.
9. Gently push in the tray until it comes to a stop.
If enabled by your System Administrator, the Paper Tray Properties screen may be displayed on the UI.
10. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.
11. Select **OK** to save the information and close the Tray Properties window.

Skew adjustment levers

The skew adjustment levers are found in all paper trays. These levers are used to improve paper feed accuracy and to reduce paper skew problems.



1. Rear skew adjustment lever
2. Right-side skew adjustment lever

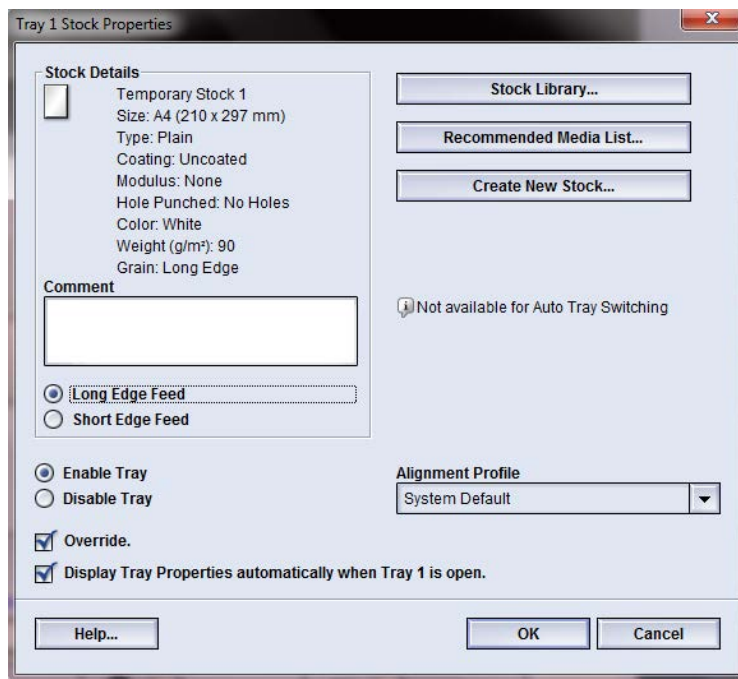
- These levers should remain in their default position. The position of these levers should be changed only when there is a skew problem when running a specific print job and/or specific media type.
- Changing the skew adjustment levers from their default position may cause more skew problems when running certain media types, such as coated, label, transparency, and film.

Use the following procedure to set the skew adjustment levers.

1. Pull out the tray slowly until it stops.
2. Slide the rear skew adjustment lever to the right (as shown in the above picture).
3. Gently push in the tray until it comes to a stop.
4. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.
5. Select **OK** to save the information and close the Tray Properties window.
6. Run your print job.
 - The paper is fed accurately without skew and the printed output is satisfactory; you are finished.
 - The paper is skewed and the printed output is unsatisfactory; proceed to the next step.
7. Pull out the tray slowly until it stops.
8. Return the rear skew adjustment lever to its left, default position.
9. Slide the right-side skew adjustment lever toward the front of the paper tray.
10. Gently push in the tray until it comes to a stop.
11. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.

12. Select **OK** to save the information and close the Tray Properties window.
13. Run your print job.
 - The paper is fed accurately without skew and the printed output is satisfactory; you are finished.
 - The paper is skewed and the printed output is unsatisfactory; proceed to the next step.
14. Pull out the tray slowly until it stops.
15. Return the right-side skew adjustment lever toward the rear of the paper tray; this is its default position.
16. Gently push in the tray until it comes to a stop.
17. If you are still having skew adjustment problems, refer to the Advanced Stock Setup information located in the System Administration Guide.

Tray Properties



From the Tray Properties window the user can view and select a variety of functions on the paper tray. Selections available for the tray vary depending on whether the user is logged in as Operator or Administrator. The following information represents the selections available when logged in as Operator.

- **Stock Details:** This area displays the current tray information including the paper size, type, weight, color, and orientation of the paper (LEF or SEF).
 - **Comment:** This section allows the user to enter information about the paper, such as a brand name or job-specific information. A maximum of 256 characters is allowed.
 - **Long Edge Feed/Short Edge Feed (LEF/SEF):** Indicates the orientation direction that the paper is loaded in the tray: either in the LEF or SEF direction.
- **Enable Tray:** Permits the selected tray to be used.
- **Disable Tray:** Prohibits the selected tray to be used.

- **Override:**
 - When this selection is cleared, the UI displays a message if the current media loaded in the tray does not match the media information displayed on the Tray Properties window. The user must load the tray with the same media as indicated on the Tray Properties window.
 - If selected, the UI never displays a message when there is a media mismatch between the actual tray contents and the information shown on the UI for that tray.
- **Display Tray Properties automatically when Tray is open:** When selected, the Tray Properties window always opens when the tray is open.
- **Stock Library:** This opens the Manage Stock Library window, which contains the names of all the paper stocks that were either created by the user or copied and/or edited from the Recommended Media List (RML). The user selects a desired stock from the list, and that stock is assigned to the tray.
- **Recommended Media List (RML):** Provides a list of all the default, preprogrammed stocks that are available for the machine. The user can select a stock from the RML to assign temporarily to the tray. Once the Tray Properties window is closed, the stock appears name appears in blue/italics indicating that it is a temporary stock. The stock is deleted once a different stock is selected.
- **Create New Stock:** Allows the user to create a new stock that is assigned to the tray. This stock may be saved permanently to the stock library, or it can remain as a temporary stock.
- **Alignment Profile:** Allows the user to select the system default profile or a specific profile that was created and saved from the Administrator mode.

[Related Topics:](#)

[Manage Stock Library](#)

[Advanced Stock Setup options](#)

[Recommended Media List \(RML\)](#)

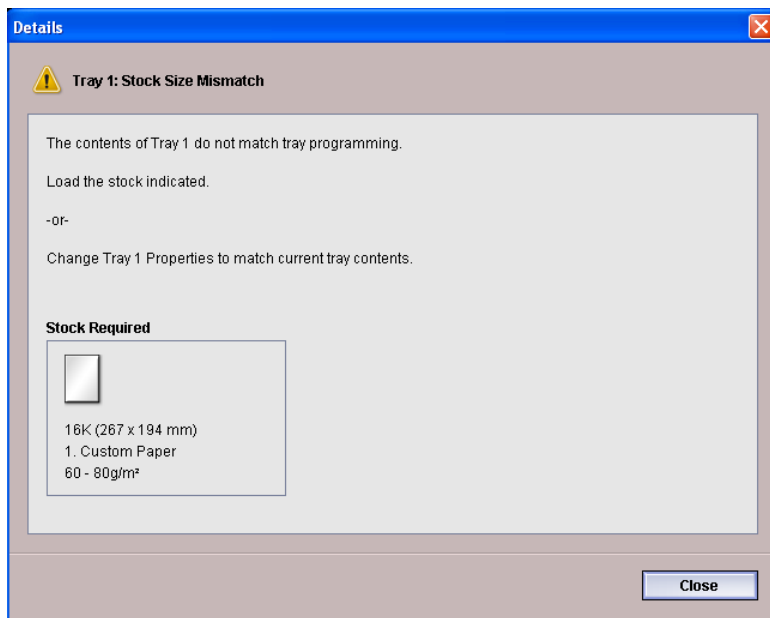
[Creating a new stock \(from Tray Properties\)](#)

Tray stock mismatch

If the paper loaded in a tray does not match the information on the Tray Properties window, the UI may alert you with a Tray Stock Size Mismatch message.

Note

This functionality is available only if it is enabled by the Administrator: refer to the System Administration Guide for more information.



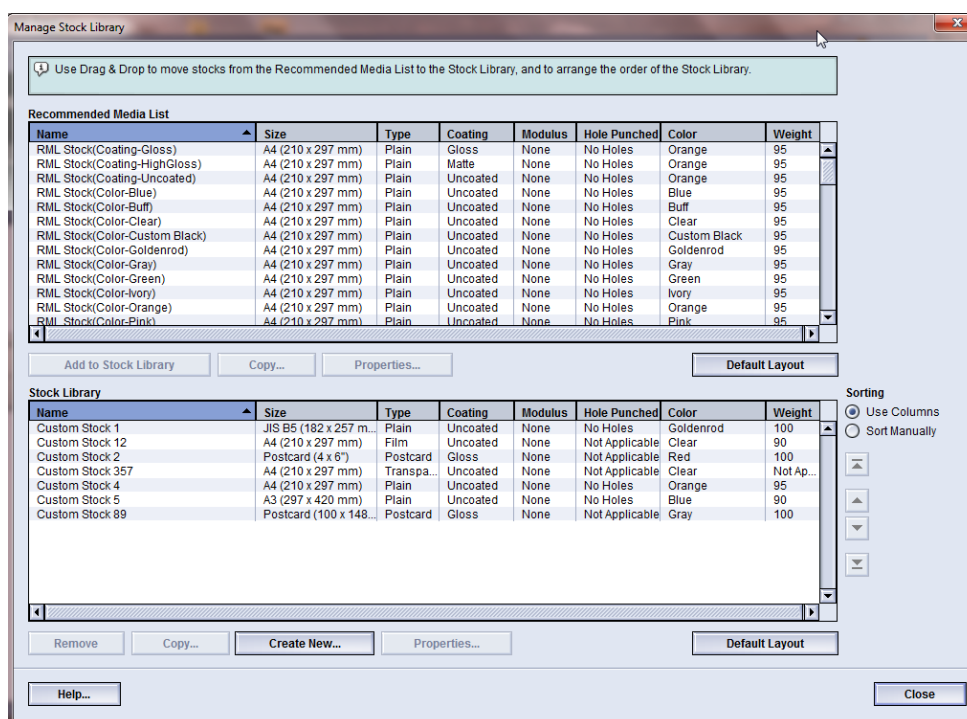
If you receive this message, do the following:

1. Load the stock indicated on the Tray Stock Size Mismatch window, or
2. Change the Tray Properties to match the contents of the tray.
 - a) Verify the paper size, type (coated, uncoated), and weight of the paper loaded in the tray.
 - b) Enter that information on the Tray Properties window.

Manage Stock Library

The Stock Library enables you to define attributes for a stock (such as size, color, type, and weight) and assign a name to identify the stock and its associated attributes.

Selecting the **Stock Library** button opens the Manage Stock Library window.



Note

The appearance of the Stock Library button on the UI is dependent on how the administrator sets this feature in System Settings (while logged on in the Administrator mode). If the Stock Library button is not displayed on the UI, then the administrator has restricted its access to administrators only. In this case, contact your administrator for more information and/or refer to the System Administration Guide.

The Manage Stock Library window contains the Recommended Media List (RML) and the Stock Library list:

- **Recommended Media List (RML):** This list contains the names of all the preprogrammed stocks that are available for the machine.

Manage Stock Library

- **Stock Library:** Much like the RML, this list contains the names of all the stocks that are available for the machine. Unlike the RML, this is a list of stocks that were either created by the user or copied and/or edited from the Recommended Media List (RML). The user selects a desired stock for each tray and/or for specific print jobs.

Related Topics:

[Stock management](#)

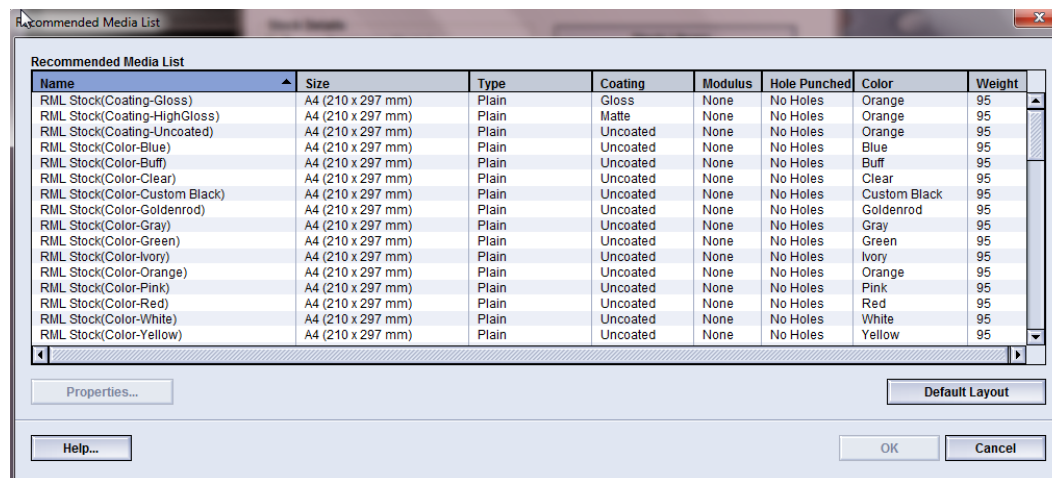
[Recommended Media List \(RML\)](#)

[Manage Stock Library window](#)

Recommended Media List (RML)

Always refer to the Recommended Media List for paper guidelines. The Recommended Media List is updated as required to include new papers and other media. The RML is available at www.xerox.com.

The RML is also available on your machine either through the Tray Properties window or from the Stock Library feature.



The screenshot shows a window titled "Recommended Media List" with a table of paper specifications. The table has columns for Name, Size, Type, Coating, Modulus, Hole Punched, Color, and Weight. The data is as follows:

Name	Size	Type	Coating	Modulus	Hole Punched	Color	Weight
RML Stock(Coating-Gloss)	A4 (210 x 297 mm)	Plain	Gloss	None	No Holes	Orange	95
RML Stock(Coating-HighGloss)	A4 (210 x 297 mm)	Plain	Matte	None	No Holes	Orange	95
RML Stock(Coating-Uncoated)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Orange	95
RML Stock(Color-Blue)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Blue	95
RML Stock(Color-Buffer)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Buff	95
RML Stock(Color-Clear)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Clear	95
RML Stock(Color-Custom Black)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Custom Black	95
RML Stock(Color-Goldenrod)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Goldenrod	95
RML Stock(Color-Gray)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Gray	95
RML Stock(Color-Green)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Green	95
RML Stock(Color-Ivory)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Ivory	95
RML Stock(Color-Orange)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Orange	95
RML Stock(Color-Pink)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Pink	95
RML Stock(Color-Red)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Red	95
RML Stock(Color-White)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	White	95
RML Stock(Color-Yellow)	A4 (210 x 297 mm)	Plain	Uncoated	None	No Holes	Yellow	95

Below the table are buttons for "Properties...", "Default Layout", "Help...", "OK", and "Cancel".

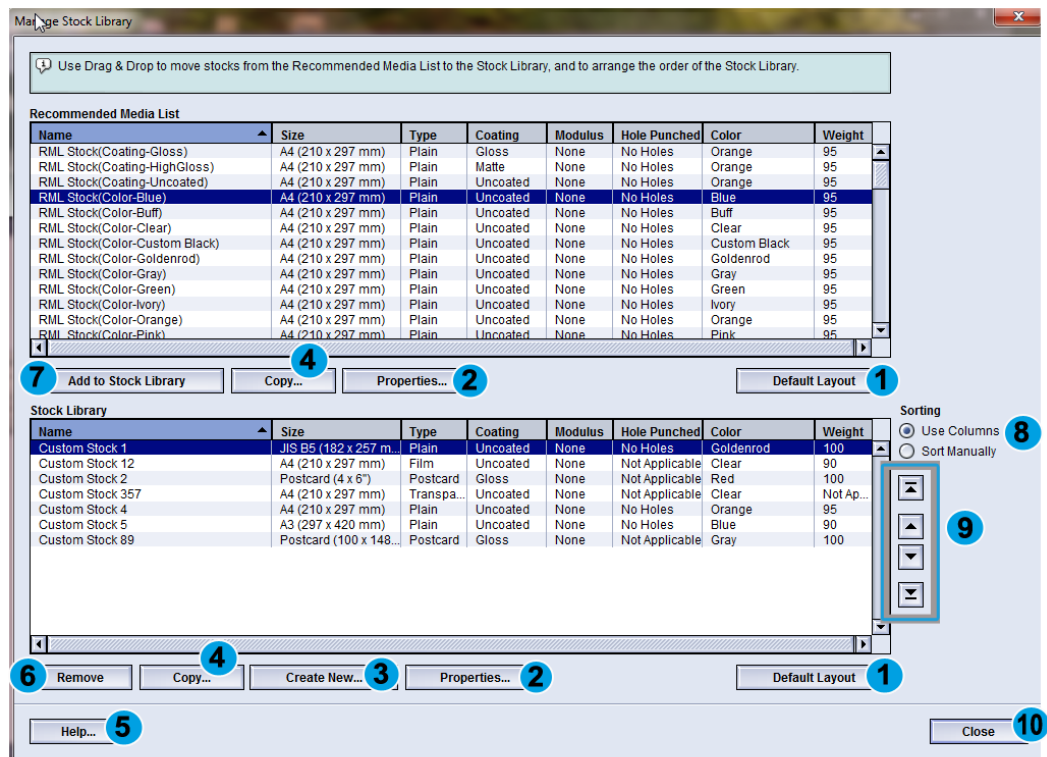
Stock management

Once a stock type is defined, named, and saved as a new stock, it can be easily referenced from the Stock Library. A saved stock can be quickly selected and used for a desired paper tray or print job.

You can perform the following tasks from the Manage Stock Library window:

- Add a stock from the RML to the Stock Library
- Copy RML stocks and customize those stock properties as required
- Copy an existing stock in the Stock Library and customize the stock properties as required
- Edit/change an existing stock entry
- Create and save a new stock; these stocks can be created in one of two ways:
 - From Manage Stock Library
 - From Tray Properties
- Remove/delete a stock entry
- Change the order stocks are shown by moving a stock up/down in the Stock Library list

Manage Stock Library window



The Manage Stock Library window consists of the Recommended Media List (RML), Stock Library list, and the following:

1. **Default Layout:** Select this option to return the Stock Library view to its original layout.
2. **Properties:** Allows the user to view and/or change the properties of stocks listed in the Stock Library list. The stock name cannot be edited/changed. Properties of a stock in the RML can be viewed only; the properties CANNOT be changed.
3. **Create New:** Allows the user to create and save a new stock to the Stock Library list.
4. **Copy:** Allows the user to copy an existing stock from either the RML or the Stock Library list, edit the stock properties, and save it to the Stock Library as a new stock.
5. **Help:** Select this to get online Help information about the Manage Stock Library feature.
6. **Remove:** Allows the user to delete (remove) a stock from the Stock Library list.
7. **Add to Stock Library:** Allows the user to add a stock from the RML to the Stock Library list.
8. **Sorting:** Select either **Use Columns** or **Sort Manually**.
9. **Up/down buttons:** Moves a stock up or down in the Stock Library list.
10. **Close:** Closes/exits the Manage Stock Library window.

Related Topics:

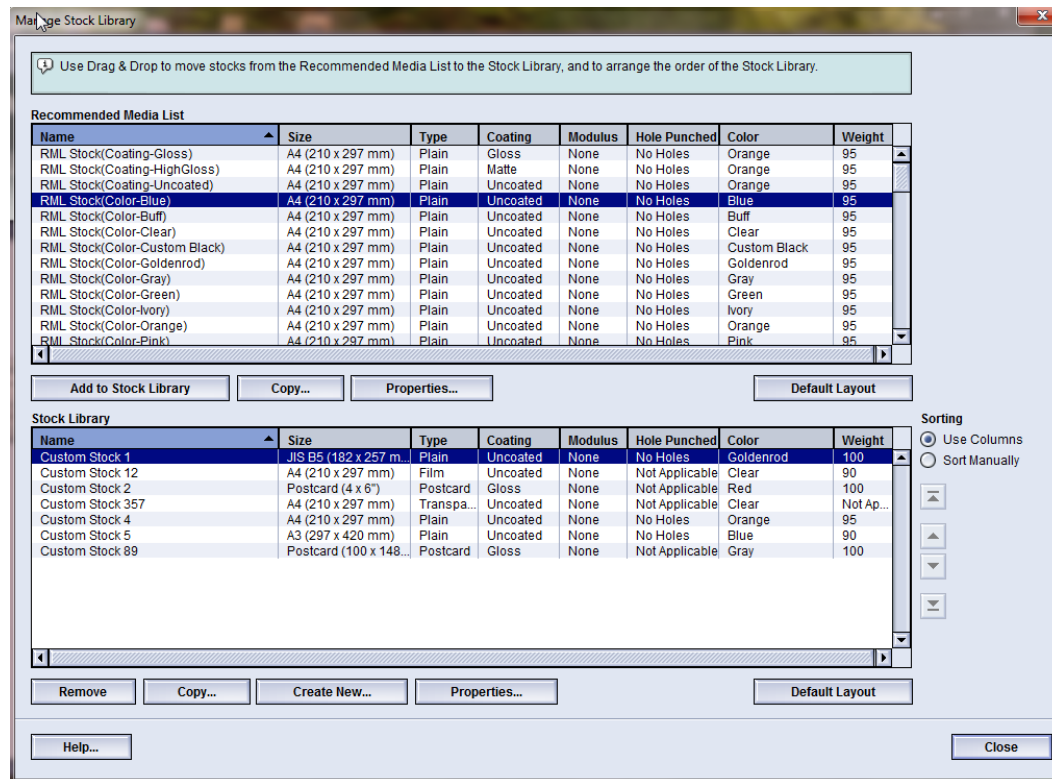
- [Adding a stock entry](#)
- [Copying a stock entry](#)
- [Creating a new stock \(from Manage Stock Library\)](#)
- [Creating a new stock \(from Tray Properties\)](#)
- [Editing an existing stock in the Stock Library](#)
- [Removing a stock from the Stock Library](#)

Adding a stock entry

Use the following procedure when adding a stock to the Stock Library from the Manage Stock Library window.

Note

Only preexisting stocks from the RML can be added to the Stock Library.

1. Select **Stock Library**.

The Manage Stock Library window opens.

2. Select the desired stock from the RML.

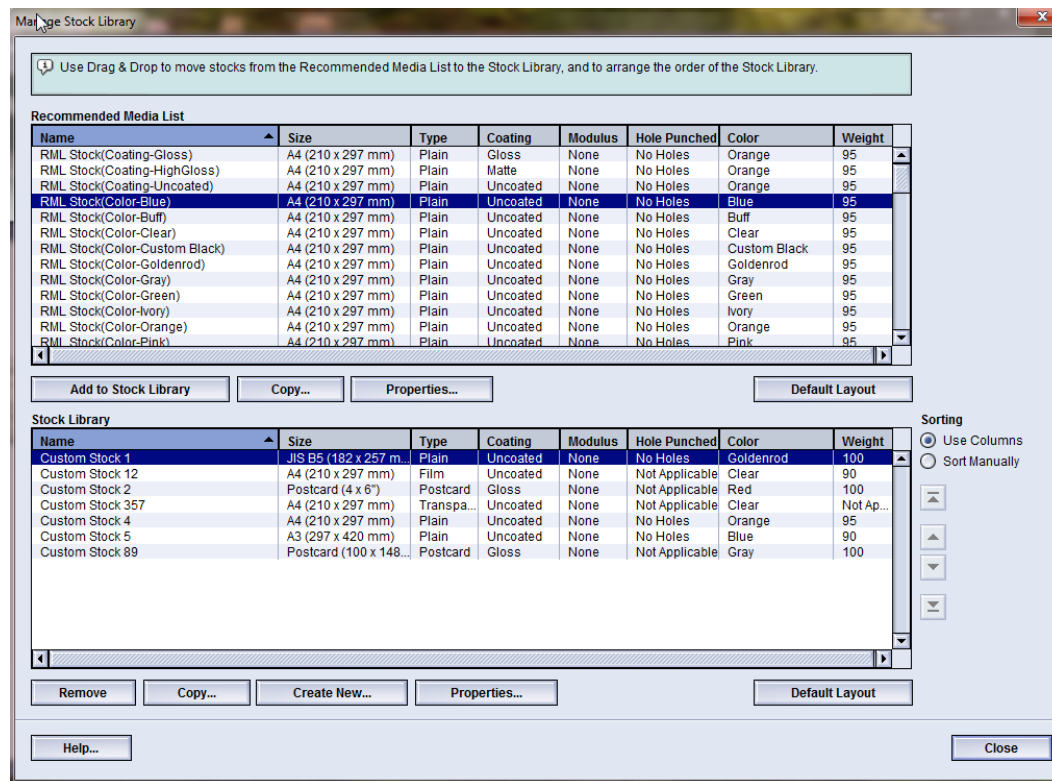
3. Select the **Add Stock Library** button.

The RML stock is added to the bottom of the Stock Library list.

4. Use the **Up/Down** buttons to move the stock within the Stock Library List.
5. Select **Close** to exit Manage Stock Library.

Copying a stock entry

Sometimes an existing stock entry (either from the RML or the Stock Library list) already contains most of the attributes required for a new stock entry. In this case, the user simply copies an existing stock and modifies its attributes to create a new stock entry.



1. Select **Stock Library**.
The Manage Stock Library window opens.
2. Select the desired stock from either the RML or the Stock Library list.
3. Select the **Copy** button.
The Stock Properties window opens.
4. Type a new stock name and modify the attributes as required.
5. Select the **Advanced Setup** button.
 - a) Select the various Advanced Stock Setup options as required.
 - b) Select **OK** to save any selections made and close the Advanced Stock Setup window.
6. Select **OK** to save and close the Stock Properties window.
The stock is added to the bottom of the Stock Library List.
7. Use the **Up/Down** buttons to move the stock within the Stock Library List.
8. Select **Close** to exit Manage Stock Library.

Related Topics:

[Advanced Stock Setup options](#)

[Create/modify Advanced Stock Setup options](#)

Creating a new stock (from Manage Stock Library)

1. Select **Stock Library**.

The Manage Stock Library window opens.

2. Select the **Create New** button.

The **New Stock Setup** window opens.

3. Type a new stock name and modify the attributes as required.

4. Select the **Advanced Setup** button.

a) Select the various Advanced Stock Setup options as required.

b) Select **OK** to save any selections made and close the Advanced Stock Setup window.

5. Select **OK** to save and close the **New Stock Setup** window.

The stock is added to the bottom of the Stock Library List.

6. Use the **Up/Down** buttons to move the stock within the Stock Library List.7. Select **Close** to exit Manage Stock Library.

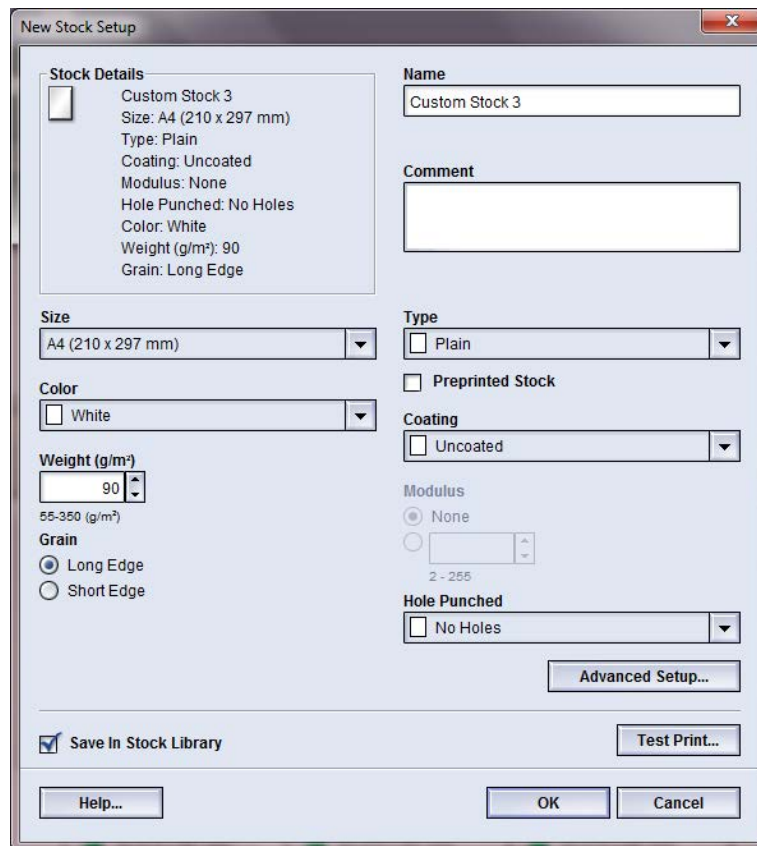
Related Topics:

[Advanced Stock Setup options](#)

[Create/modify Advanced Stock Setup options](#)

[Creating a new stock \(from Tray Properties\)](#)

Creating a new stock (from Tray Properties)



The image shows a 'New Stock Setup' dialog box with the following fields and options:

- Stock Details:** Custom Stock 3, Size: A4 (210 x 297 mm), Type: Plain, Coating: Uncoated, Modulus: None, Hole Punched: No Holes, Color: White, Weight (g/m²): 90, Grain: Long Edge.
- Name:** Custom Stock 3
- Comment:** (Empty text box)
- Size:** A4 (210 x 297 mm) (Dropdown menu)
- Type:** Plain (Dropdown menu)
- Color:** White (Dropdown menu)
- Preprinted Stock:** (Unchecked checkbox)
- Coating:** Uncoated (Dropdown menu)
- Weight (g/m²):** 90 (Spin box, range 55-350)
- Modulus:** None (Radio button)
- Grain:** Long Edge (Selected radio button), Short Edge (Radio button)
- Hole Punched:** No Holes (Dropdown menu)
- Buttons:** Advanced Setup..., Test Print..., Help..., OK, Cancel.
- Save In Stock Library:** (Checked checkbox)

1. From the machine's UI, double-click on the desired tray where the new stock will be loaded.
The Tray Properties window for that tray opens.
2. Select the **Create New** button.
The **New Stock Setup** window opens.
3. Type a new stock name and modify the attributes as required.
4. Select the **Advanced Setup** button.
 - a) Select the various Advanced Stock Setup options as required.
 - b) Select **OK** to save any selections made and close the Advanced Stock Setup window.
5. The stock may be either a temporary stock or a permanent stock in the Stock Library:

- To make the stock a temporary stock, ensure that the Save In Stock Library checkbox is **UNCHECKED**.
 - To permanently save the stock to the Stock Library, ensure that the Save In Stock Library checkbox is **CHECKED**.
6. Select **OK** to save and close the **New Stock Setup** window.
 7. Select **OK** again to close the **Tray Properties** window.

The new stock is displayed on the UI.

Note

Before running the job, be sure to load the tray with the same stock as programmed.

Related Topics:

[Tray Properties](#)

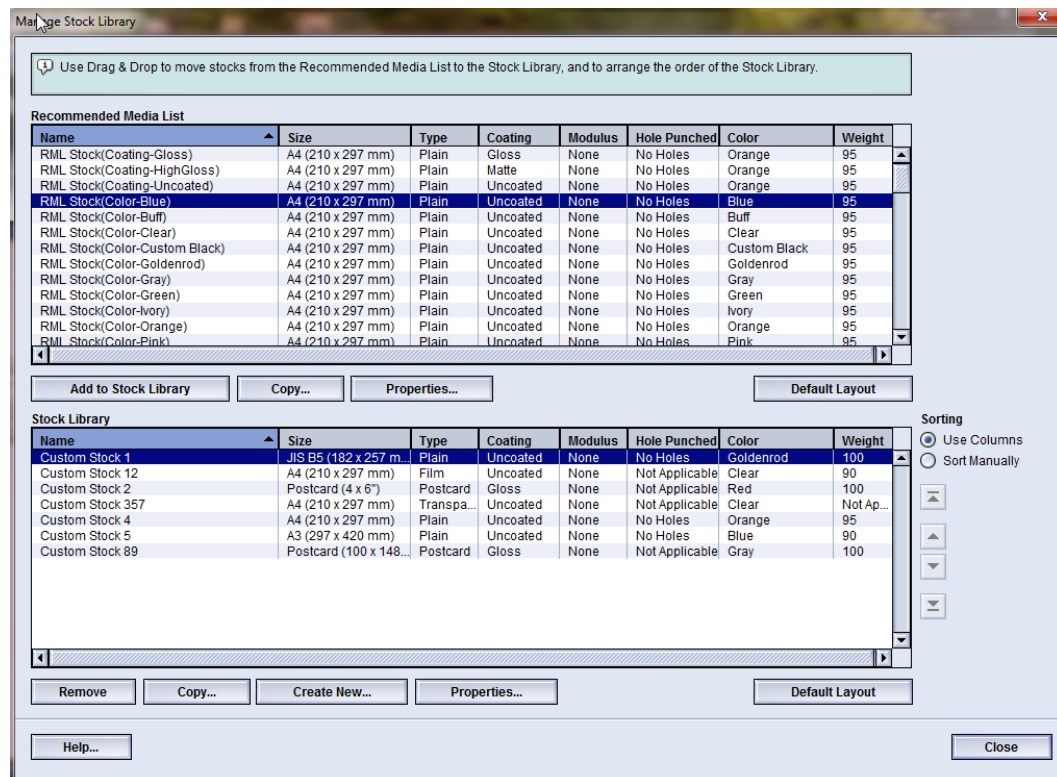
[Advanced Stock Setup options](#)

[Create/modify Advanced Stock Setup options](#)

[Creating a new stock \(from Manage Stock Library\)](#)

Editing an existing stock in the Stock Library

Use the following procedure to edit an existing stock in the Stock Library.



Manage Stock Library

1. Select **Stock Library**.

The Manage Stock Library window opens.

2. Select the desired stock from the Stock Library list.

3. Select the **Properties** button.

The Stock Properties window opens.

4. Modify the attributes as required.

5. Select the **Advanced Setup** button.

a) Select the various Advanced Stock Setup options as required.

b) Select **OK** to save any selections made and close the Advanced Stock Setup window.

6. Select **OK** to save the changes to the stock and close the **Stock Properties** window.

7. Select **Close** to exit Manage Stock Library.

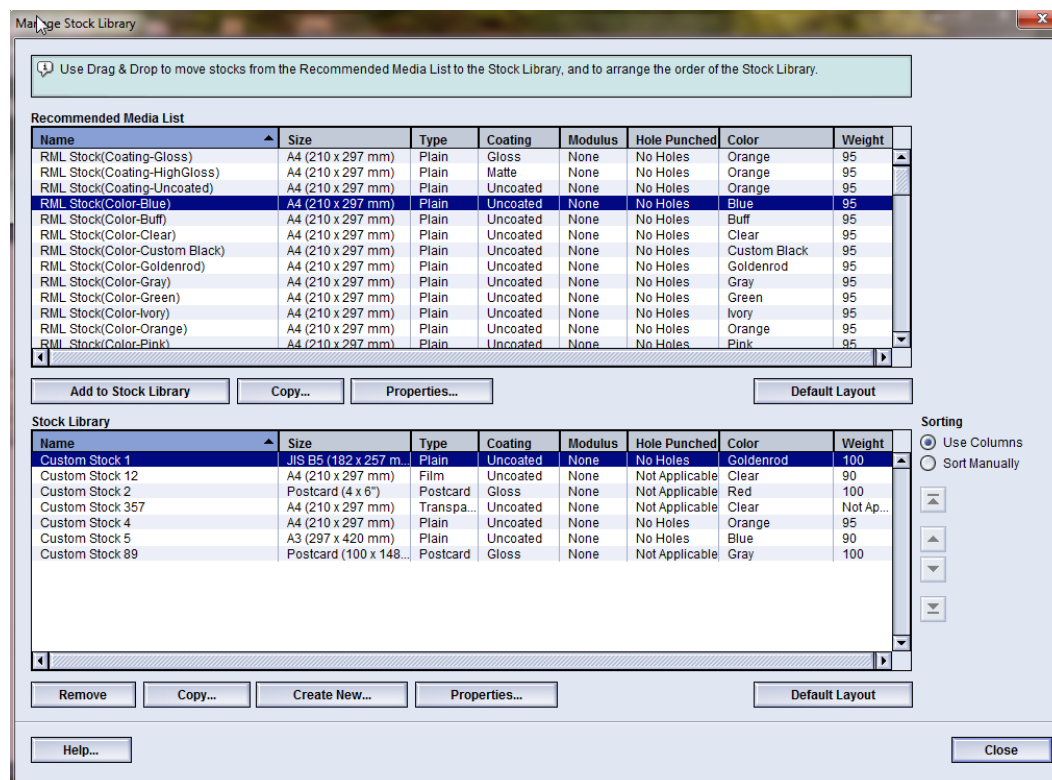
Related Topics:

[Advanced Stock Setup options](#)

[Create/modify Advanced Stock Setup options](#)

Removing a stock from the Stock Library

Use the following procedure to remove a stock from the Stock Library list.



1. Select **Stock Library**.

The Manage Stock Library window opens.

2. Select the desired stock from the Stock Library list.

3. Select the **Remove** button.

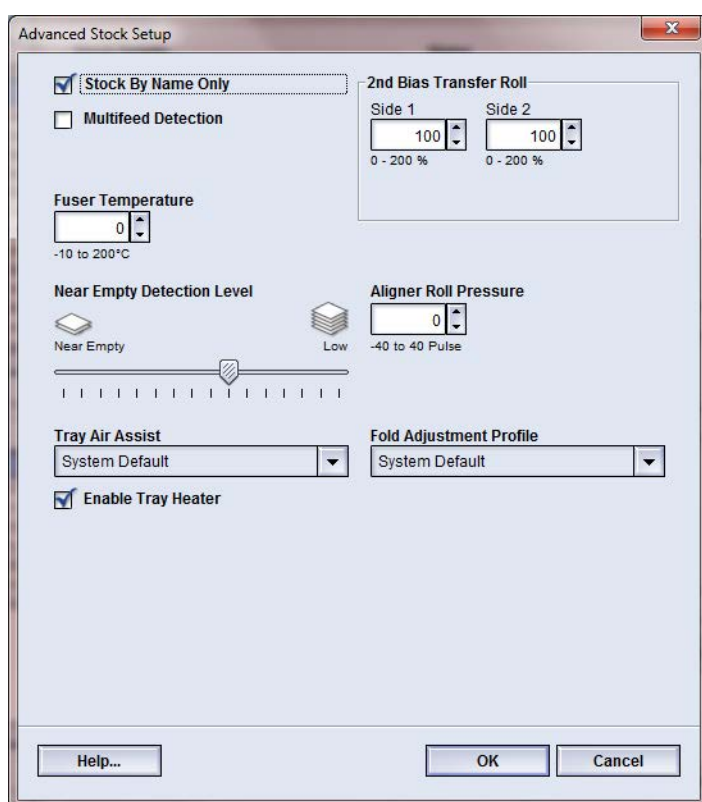
A question window opens and asks Are you sure you want to Delete this stock?

Select **Yes** to delete the stock from the Stock Library list.

4. Select **Close** to exit Manage Stock Library.

Advanced Stock Setup

The **Advanced Stock Setup** feature allows the user to further customize stocks beyond the typical size, weight, type, and other characteristics.



The **Advanced Stock Setup** feature is accessed from either the Stock Properties window or the New Stock Setup window.

Different media (including paper type, weight, and coating/uncoating, paper curl) may require specific and/or special handling by the machine as it is moving through the paper path. For example, some media types may skew or curl as they progress through the printing path of the machine. This may occur on frequently-run jobs and/or on jobs with a high volume output.

The **Advanced Stock Setup** feature allows you set specific custom parameters for different types of media and jobs, such as outlined in the above paragraph. These custom stocks may be used at point of need in order to ensure optimum output quality of your prints/jobs. The stocks may be either a temporary stock for a specific, one-time job, or they can be a permanent stock added to the Stock Library list.

By setting custom stocks for specific media types, you can avoid output prints that are skewed, curled, have too much dry ink/toner or not enough dry ink/toner in areas, or images that are not registered properly on the output print, such as Side 1 and/or Side 2 images that are misregistered.

Note

Once a custom stock is created, either temporarily or permanently, the machine passes this information on to your print server. The print server in turn reflects this information in the print options for the print jobs.

Related Topics:

[Advanced Stock Setup options](#)

[Stock By Name Only](#)

[Multifeed Detection](#)

[Near Empty Detection Level](#)

[Tray Air Assist](#)

[Enable Tray Heater](#)

[Aligner Roll Pressure](#)

[Second \(2nd\) bias transfer roll](#)

[Fuser Temperature](#)

[Fold Adjustment Profile](#)

[Create/modify Advanced Stock Setup options](#)

Advanced Stock Setup options

The **Advanced Stock Setup** feature includes options that affect these areas of the machine:

- Paper tray/paper feed, including:
 - Stock By Name Only
 - Near Empty Detection Level
 - Tray Air Assist
 - Multifeed Detection
 - Enable Tray Heater
- Paper path/paper transportation, including:
 - Aligner Roll Pressure

- 2nd Bias Transfer Roll
- Fuser Temperature
- Folder Adjustment Profile

Each of these options is discussed throughout the remainder of this section, and where required, step-by-step procedures also are provided.

Important

Paper Curl Correction options and the ability to run test prints are available **ONLY** when logged in as Administrator. Refer to the System Administrator Guide for detailed information.

Related Topics:

[Stock By Name Only](#)

[Multifeed Detection](#)

[Near Empty Detection Level](#)

[Tray Air Assist](#)

[Enable Tray Heater](#)

[Aligner Roll Pressure](#)

[Second \(2nd\) bias transfer roll](#)

[Fuser Temperature](#)

[Fold Adjustment Profile](#)

[Create/modify Advanced Stock Setup options](#)

Tips for using Advanced Stock Setup options

Before using any of the Advanced Stock Setup options, keep the following information in mind:

- It is recommended that you choose only one option at a time. This helps you determine whether or not that option is providing the desired printed output.

Important

It is **HIGHLY** recommended that you run test prints after selecting each Advanced Stock option. This allows you to evaluate the printed output and determine if it is acceptable or not. In order to run test prints, you **MUST** be logged on as Administrator.

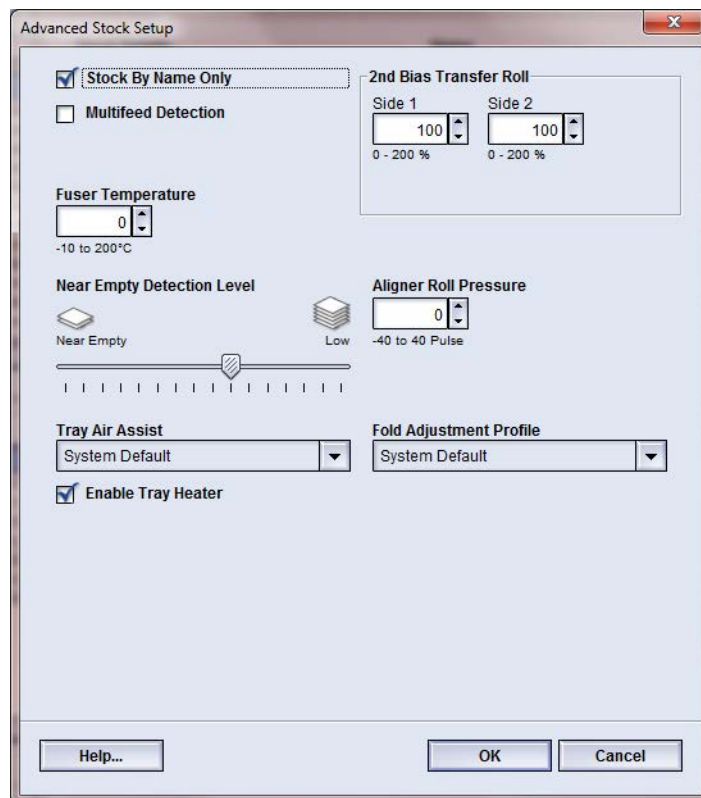
- If you determine that the output is unacceptable, either further adjust the value for a particular option (if applicable) or return the option to its default value and continue to the next option.
- It is important to remember that any settings for a particular option that is used today for a specific print job may not achieve the same desired outcome/output when used on different day for that same print job. This is especially relevant if the room in which the machine is located experiences changes in temperature and humidity.

Advanced Stock Setup

- If you determine that your output still is unacceptable after repeating procedures, log in as Administrator, select the desired options and run test prints. Repeat this process several times, each time running test prints and evaluating the output. If the output is still unacceptable, call your Customer Support Center for help/assistance.

Create/modify Advanced Stock Setup options

Use the following procedure to select the various Advanced Stock Setup options for a new stock entry or to modify/edit an existing stock entry.



1. Perform one of the following:
 - a) Create a new stock entry (from the Manage Stock Library window), or
 - b) Copy an existing stock entry (either from the Manage Stock Library window or from the Tray Properties window), or
 - c) Modify an existing stock entry (from the Manage Stock Library window) by selecting the **Properties** button.
2. From either the New Stock Setup or Stock Properties window, select/modify the attributes as required, including entering a new stock name (if applicable).
3. Select the **Advanced Setup** button.
The Advanced Stock Setup window opens.
4. Select the desired Advanced Stock Setup window, select the various options as required, including:

- a) Stock By Name Only
 - b) Multifeed Detection
 - c) 2nd Bias Transfer Roll; refer to the [Selecting the 2nd Bias Transfer Roll settings](#) procedure for step-by-step instructions
 - d) Fuser Temperature
 - e) Near Empty Detection Level
 - f) Aligner Roll Pressure
 - g) Tray Air Assist
 - h) Fold Adjustment Profile (available only if the optional finisher is attached to your machine)
5. Select **OK** to close the Advanced Stock Setup window.
 6. Select **OK** to save and close either the New Stock Setup window or the Stock Properties window.
 7. Select **Close** to exit Manage Stock Library.

Related Topics:

[Stock By Name Only](#)

[Multifeed Detection](#)

[Near Empty Detection Level](#)

[Tray Air Assist](#)

[Enable Tray Heater](#)

[Aligner Roll Pressure](#)

[Second \(2nd\) bias transfer roll](#)

[Fuser Temperature](#)

[Fold Adjustment Profile](#)

[Selecting the 2nd Bias Transfer Roll settings](#)

Paper tray/paper feed options

Stock By Name Only

When this option is selected/checked (yes or true), stock can be selected from the print server or from the client's print driver only by explicitly selecting its specific stock name (as shown in the Stock Library) and not by matching various parameters (such as weight, type, and coating). Selecting this option (placing a checkmark in the box) prevents the inadvertent use of expensive or specialty stocks for slip-sheets, automatic paper selection, or generic paper requests by the user.

When this option is unchecked (no or false), stocks can be selected from the print server or from the client's print driver by matching the same attributes (such as weight, type, and coating) as those listed for stocks in the Stock Library. Stock names also examined, but are not used exclusively for selection for print jobs.

Multifeed Detection

This option is used in vary rare cases, such as when a job requires the same paper tray to have different media stocks loaded in it. For example, a job requires a special application with heavier stock media:

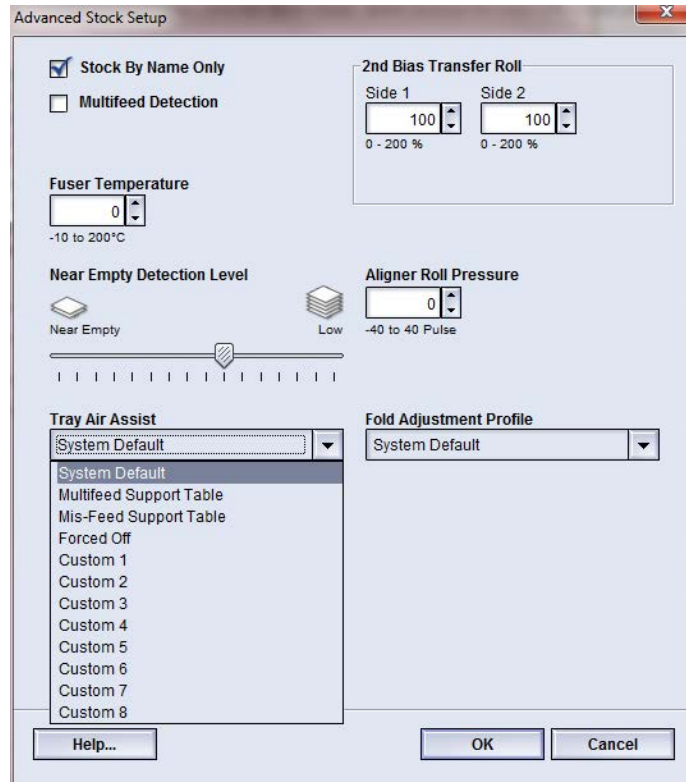
- Tray 1 is loaded with both 24 lb./90 gsm and 130 lb. Cover (350 gsm)
- The print job pulls both stocks from the same tray for the same job.
- With Multifeed Detection selected, the machine detects and avoids any possible multifeed issues. This allows the job to continue running, pulling both stocks from the same tray, and completes the print job without faults or jams.

Near Empty Detection Level

This option is available only if the Tray Near Empty option is selected for the Auto Tray Switch Timing feature (**System Settings > Tray Options**); otherwise, this option is ignored. When available, this option informs the user that a tray is nearing an empty level. This message is displayed to the user depending on where the Near Empty Detection Level indicator is set.

Tray Air Assist

The Tray Air Assist option allows you to optimize and control the environmental conditions in your paper trays, which in turn ensures optimum print capability.



Use this feature to switch on/off fans in a paper tray in order to eliminate misfeeds, multifeeds, paper jams, or other possible tray feeding problems. These fans blow air to the paper stack during the feeding operation and separate sheets of paper thereby providing a stable feed of paper.

The Tray Air Assist options includes the following selections:

- **System Default:** As its name states, this is the default selection. With this selection the paper tray blowers automatically adjust by using system settings that are optimized for Xerox papers.
- **Multifeed Support Table:** Select this option when you have a multifeed condition. This changes the air assist function to lower the air volume so it does not fluff or pick up as many sheets of paper. This is a preset lower volume that is already stored in the machine NVM (NonVolatile Memory).
- **Mis-Feed Support Table:** Select this option when you have a misfeed condition. This changes the air assist function to lower the air volume so that it may reduce paper jams. This is also a preset lower air volume that is stored in the machine NVM.
- **Forced Off:** Select this option when neither of the above options produce a change in the output. This option switches off all air assist functions.

- **Custom 1-8:** By default, these are blank NVM storage settings. If necessary, they are used to create a custom air assist parameter. If none of the other options remedy the situation, your Xerox representative works with both the customer and the Xerox personnel to create a custom setting. This is based on the stock being used and the best air assist values for producing the desired outcome. These values are then entered into the machine NVM and assigned to a specific Custom setting (1-8).

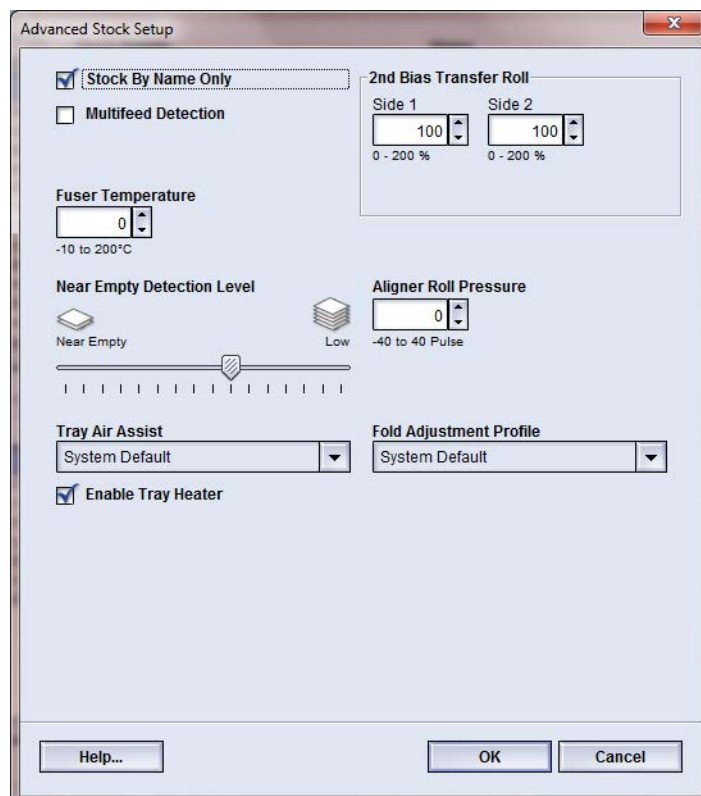
Enable Tray Heater

The Enable Tray Heater option works in conjunction with the Tray Air Assist option. Checking this box, enables the tray heater. The heater maintains the appropriate internal temperature of the paper tray. Depending on the external temperature and humidity, the heater sends information to the tray blowers. The paper tray blowers then switch on and provide the required air to the paper stack, thereby preventing multifeeds or misfeeds from occurring.

Paper path/paper transportation options

Aligner Roll Pressure

Use this option with special paper types that slip or skew thereby causing image misregistration on the printed output. This feature is also used with some light-weight or heavy-weight paper stocks that require less or more roll pressure in order to avoid edge damage to the printed output.



Examples:

- Some coated, heavier paper types slip and skew, thereby misregistering the image on the output prints. In this case, you may want to increase the roll pressure in order to compensate for the slippage and skewing.
- Some light-weight papers may have too much roll pressure applied to them, thereby causing edge damage to the output prints. In this case, you may want to decrease the roll pressure.

Tip

Increasing the roll pressure for some faults, may allow you to postpone a service call. However, you may want to call your service representative as soon as possible in order to restore the machine to its full feeding capabilities.

Note

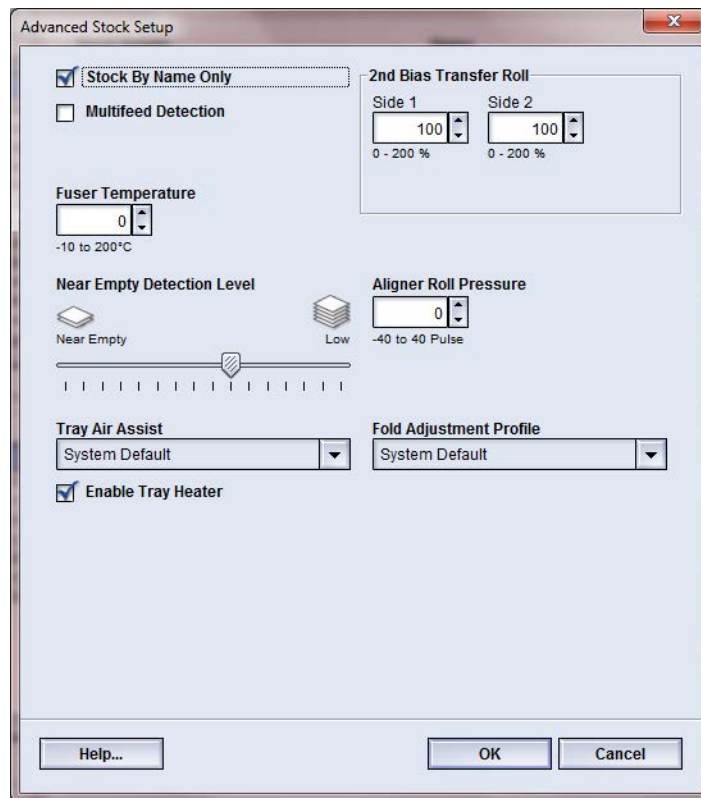
The default setting is 0. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints.

Important

Changing the default setting should be considered a temporary solution because environmental conditions vary from day to day. It is recommended that upon completion of the print job, you return the option to its default setting.

Second (2nd) bias transfer roll

The second bias transfer roll is where the image is transferred from the belt to the paper. The 2nd Bias Transfer Roll (2nd BTR) option is normally used with special stocks like heavier weight paper, such as 220 gsm and greater, 10 pt, or 12 pt. However there are times when it is also used with lighter weight paper as well. When using either heavier or lighter weight paper, you may want or need to adjust Side 1 for all 1-sided jobs.



If defects continually occur in a printed job when using heavier weight paper, check the following areas on your printed output to determine if 2nd Bias Transfer Roll (2nd BTR) adjustments (side 1 and/or side 2) are appropriate.

1. If the job is printed face down or 1-N, check Side 1 for defects on the topside (upper portion) of the stacked sheets, and check Side 2 for defects on the downside (lower portion) of the stacked sheets.
2. If the job is printed face up or N-1, check Side 2 for defects on the topside (upper portion) of the stacked sheets, and check Side 1 for the downside (lower portion) of the stacked sheets.

Note

The default setting for both Sides 1 and 2 is 100 %. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints.

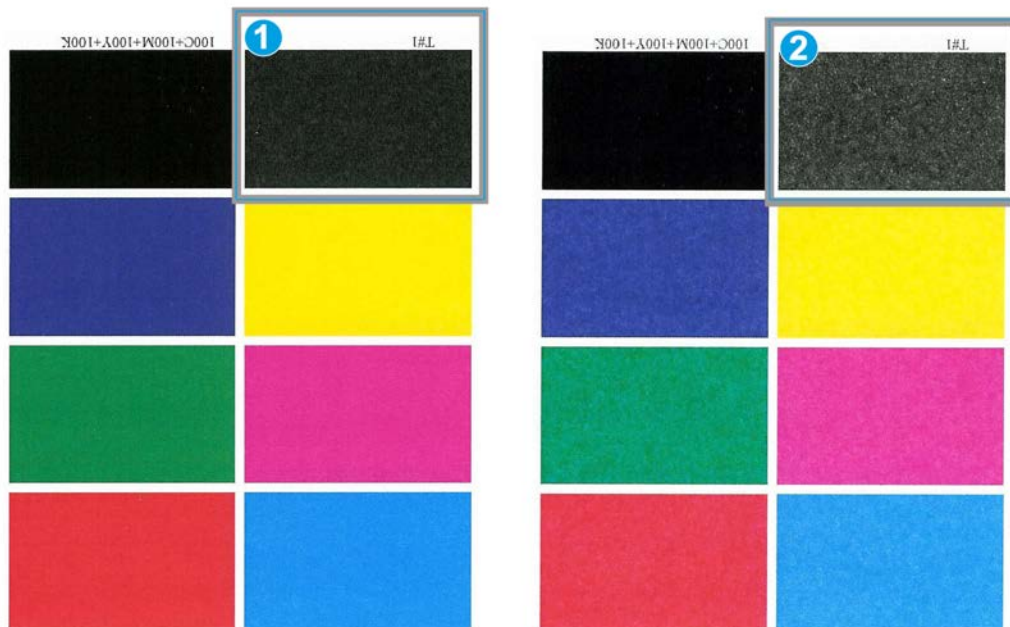
Tip

Test prints may be run in order to check the printed output before saving the changes made to the 2nd Bias Transfer Roll option. However, in order to run test prints, you must be logged in as Administrator. The Test Print option is available ONLY in the Administrator mode.

Related Topics:

[Mottle](#)[Color shift](#)[Selecting the 2nd Bias Transfer Roll settings](#)**Mottle**

Use the 2nd Bias Transfer Roll option when your prints have mottle, which is uneven spotty dry ink/toner coverage that occurs when printing large, solid areas of flat color. Refer to the following illustration for an example of prints with and without mottle.

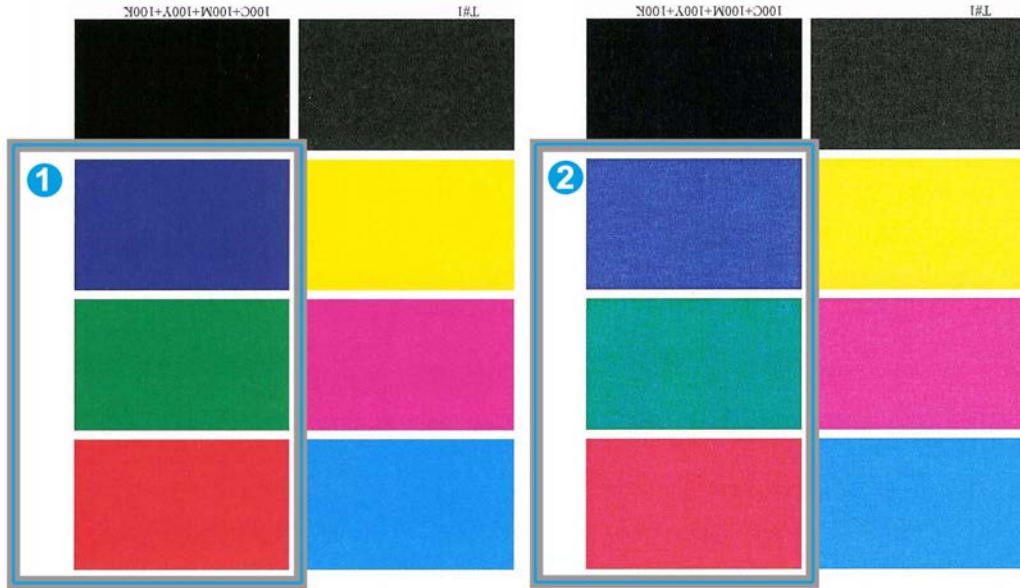


1. No mottle
2. Mottle

If mottle exists, increase one or both of the 2nd BTR values. Evaluate the image quality. If the image quality is equal to or worse than the 100 % default setting, decrease one or both of the 2nd BTR values until a satisfactory image quality is obtained.

Color shift

Use the 2nd Bias Transfer Roll option when your prints have color shift where the colors are much different than what you desire. Refer to the following illustration for an example of prints with and without color shift.



1. No color shift: this is the desired output
2. Color shift: this is an undesired output

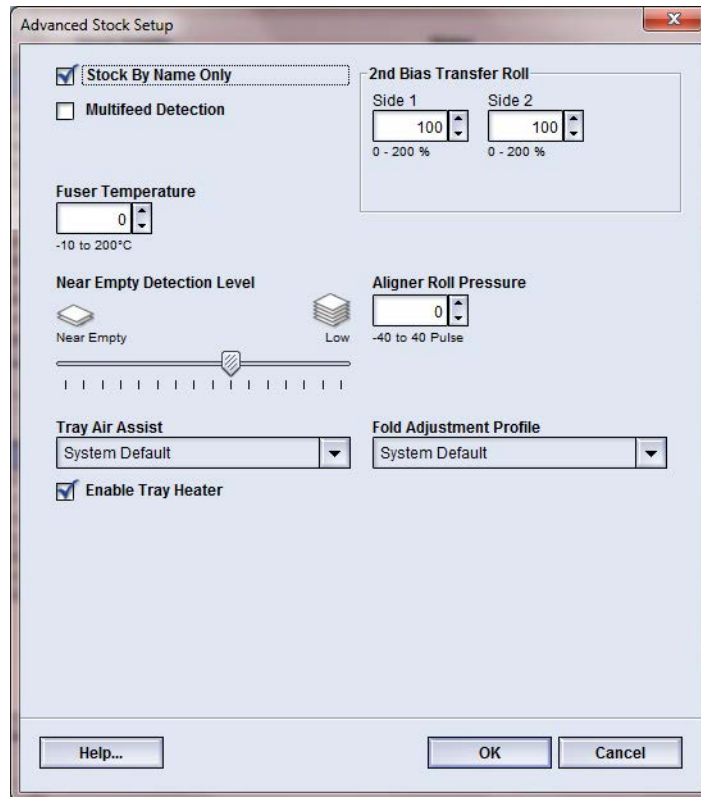
If color shift exists, increase one or both of the 2nd BTR values.

Important

Changing the default setting should be considered a temporary solution because environmental conditions vary from day to day. It is recommended that upon completion of the print job, you return the option to its default setting.

Selecting the 2nd Bias Transfer Roll settings

Use the following procedure to select the settings for the 2nd Bias Transfer Roll (on the Advanced Stock Setup window).



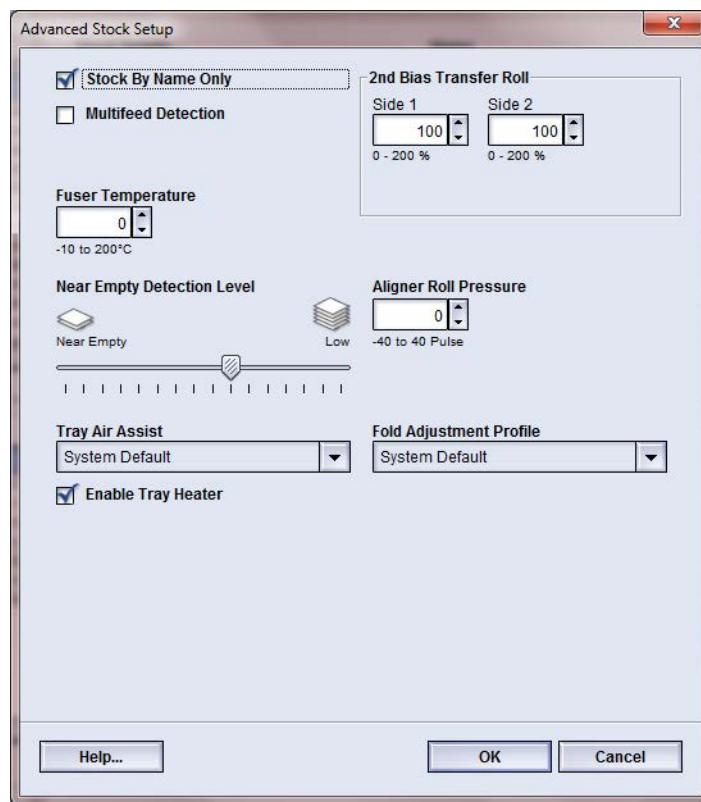
1. Select **Stock Library**.
The Manage Stock Library window opens.
2. Perform one of the following:
 - a) Select the **Create New** button or
 - b) Select the desired stock from either the RML or the Stock Library list, and then select the **Copy** button or
 - c) Select the desired stock from the Stock Library list, and then select the **Properties** button.
 Either the New Stock Setup window or the Stock Properties window opens.
3. Modify the attributes as required.
4. Select the **Advanced Setup** button.
The Advanced Stock Setup window opens.
5. Select the desired 2nd Bias Transfer Roll settings for Side 1 and/or Side 2 as required by using the up/down arrow buttons.
6. Select **OK** to close the Advanced Stock Setup window.

7. Select **OK** to save and close either the New Stock Setup window or the Stock Properties window.
8. Select **Close** to exit Manage Stock Library.

Fuser Temperature

This option allows the user to adjust the fuser temperature for specific media types.

Adjusting the fuser temperature allows the machine to maintain the highest productivity possible when running mixed media jobs, and thereby allows the fuser belt and related components to be cooled rapidly when switching from heavy-weight paper to lighter-weight paper.



In order to maintain the highest productivity possible when running mixed media jobs, the fuser and its related components need to be cooled rapidly when switching from heavy weight paper to lighter weight paper. The technology of this fuser and its related components provide this rapid heating and cooling, thereby ensuring the highest productivity on printed output, especially when running mixed media jobs.

Under most conditions, the fuser temperature is adjusted automatically by the machine at point of need. On those very rare occasions, however, the user may need to minimally adjust the fuser temperature for specific stock weights or a specific job flow (such as running heavy weight cover stock with lighter weight paper).

The Fuser Temperature option allows the user to set the temperature within a range of -1 degree to +5 degrees Celsius (30.2 - 41.5 degrees Fahrenheit).

Note

The default setting is 0. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints.

Tip

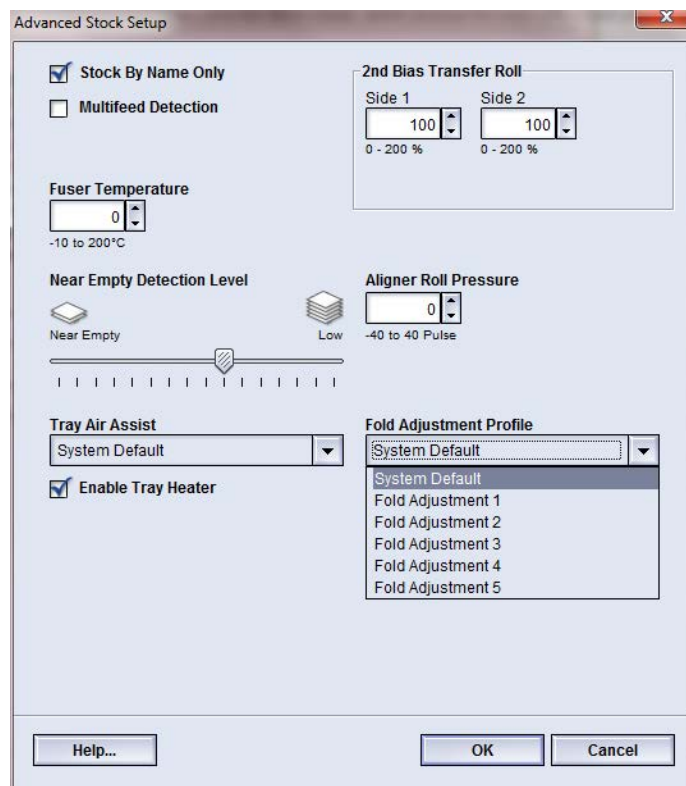
Changing the default setting should be considered a temporary solution because environmental conditions vary from day to day. It is recommended that upon completion of the print job, you return the option to its default setting.

Fold Adjustment Profile

This option allows you to select a desired fold adjustment profile.

Note

This option is available only if your machine has the optional Standard Finisher, Booklet Maker Finisher, or Standard Finisher Plus attached to it.



From the Fold Adjustment Profile pull-down menu, select the desired profile, as required. These profiles are preset profiles, which are created and maintained from the **Profiles** feature on the UI.

Note

Refer to the Profiles chapter of the System Administration Guide for detailed information.

Maintenance

Cleaning procedures

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



Caution

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



Caution

Do not pour or spray liquid directly into any of the paper trays. Always apply the liquid to the cloth first.

Cleaning the UI screen

Clean the UI screen 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 screen.

Cleaning the paper path

Note

It is recommended that you perform the following procedures on a daily basis, preferably at the start of the day before the machine is switched on and the fuser is cool. Only clean the recommended areas of the paper path as described in these procedures.



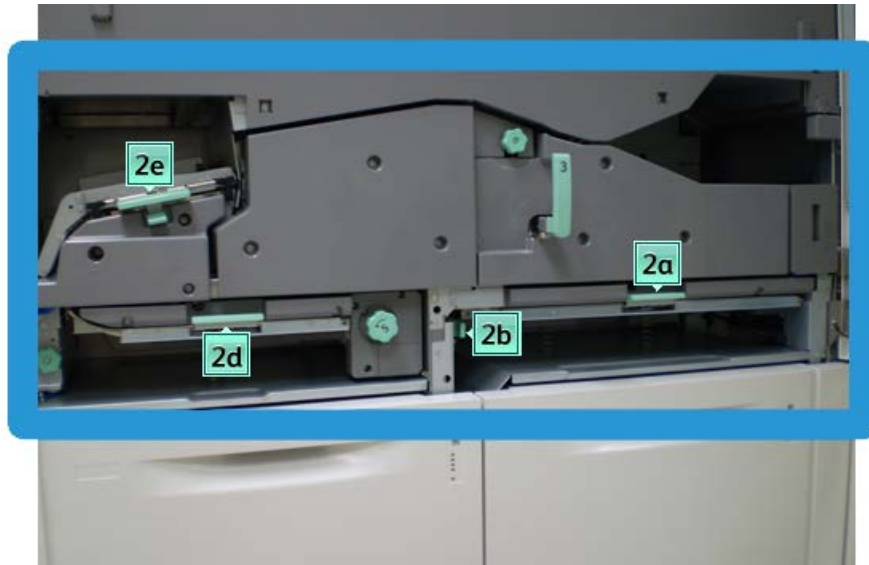
Warning

If the machine is switched on and the fuser is hot, be sure to switch off the machine power and allow 30 minutes for the fuser to cool before performing this procedure.

Note

If large amounts of paper dust are frequently observed, contact your Xerox supplies representative for alternate paper recommendations. If a 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 any extended costs that fall outside the scope of their service contract.

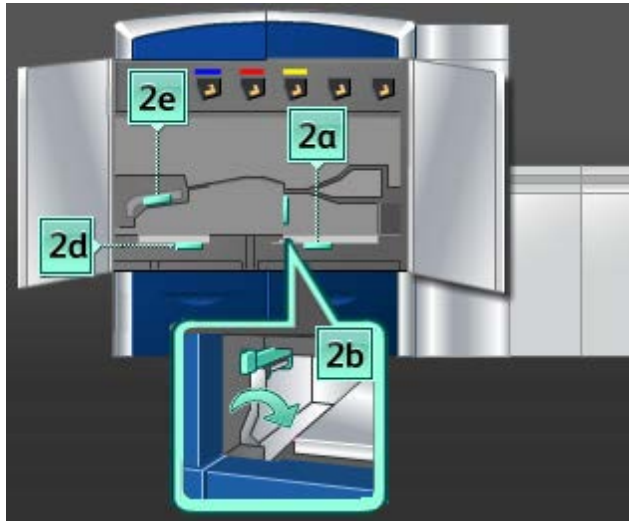
Cleaning the paper path area 2



1. Open the left and right front doors (print engine left side).

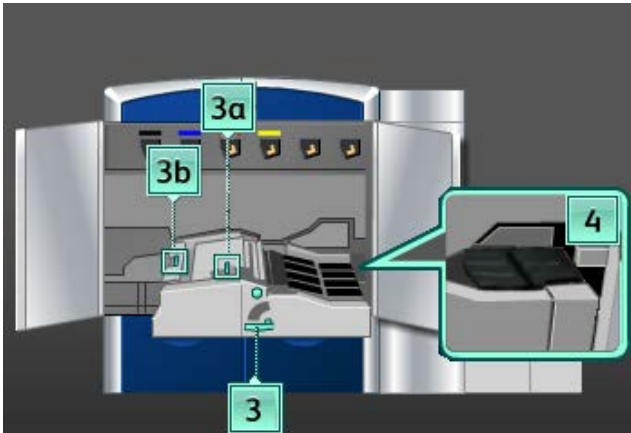


2. Use a damp, water-moistened (not wet), lint-free cloth to clean the paper path only in the green lever jam clearance areas as shown in the illustration.



- a) Open each area and clean the surfaces of the green-handle areas.
 - b) Remove any residual moisture with a dry, lint-free cloth.
3. Return all the green levers to their original positions.
 4. Close the left and right front doors (print engine left side).

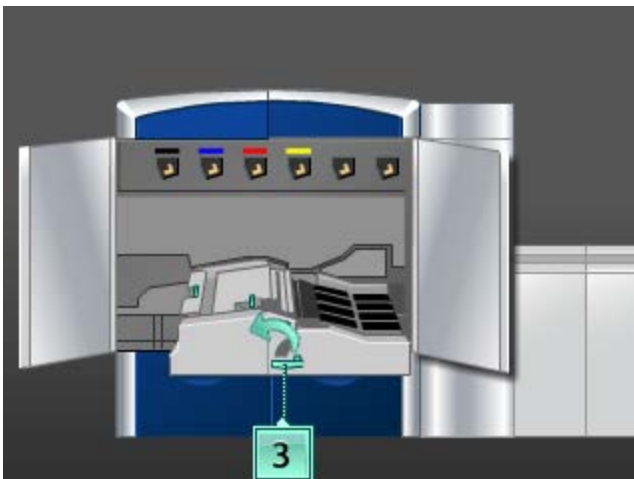
Cleaning the paper path areas 3 and 4



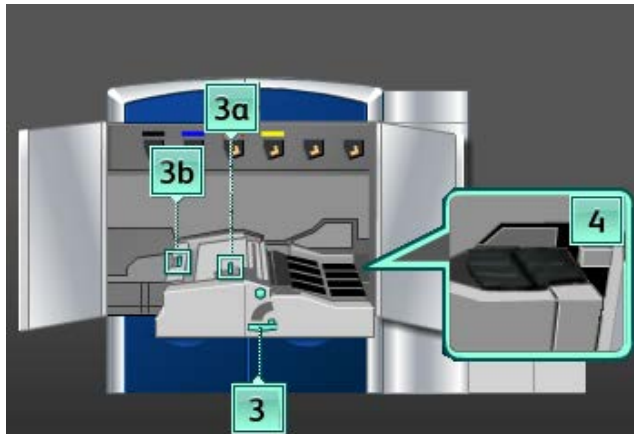
1. Open the left and right front doors (print engine left side).



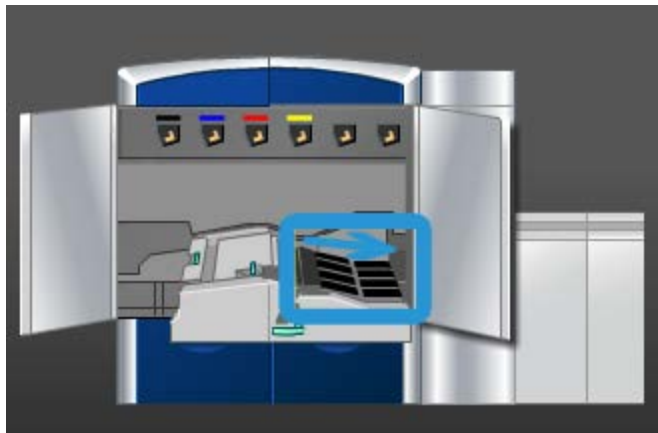
2. Grasp handle 3 and rotate it in the direction of the arrow.



3. Slowly pull out the paper transport drawer until it stops.
4. Use a damp, water-moistened (not wet), lint-free cloth to clean the paper path only in the green lever jam clearance areas as shown in the illustration.



- a) Open each area and clean the surfaces of the green-handle areas.
- b) Remove any residual moisture with a dry, lint-free cloth.
5. Return all the green levers to their original positions.
6. Using a lint-free cloth, clean the belts in Area 3 by rotating them in the direction that paper travels.



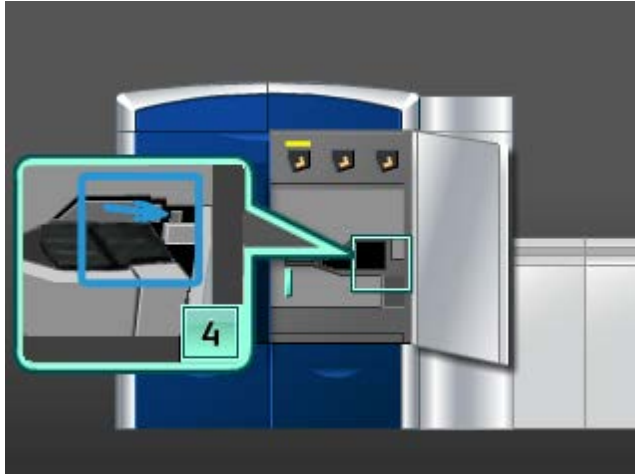
Continue to wipe the belts as you rotate them until all the belts are clean.

Note

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

7. Grasp handle 3 and slowly push in the paper transport drawer until it stops. Turn the handle in the direction of the arrow to lock the module in place.

8. Using a lint-free cloth, clean the belts in Area 4 by rotating them in the direction that paper travels.



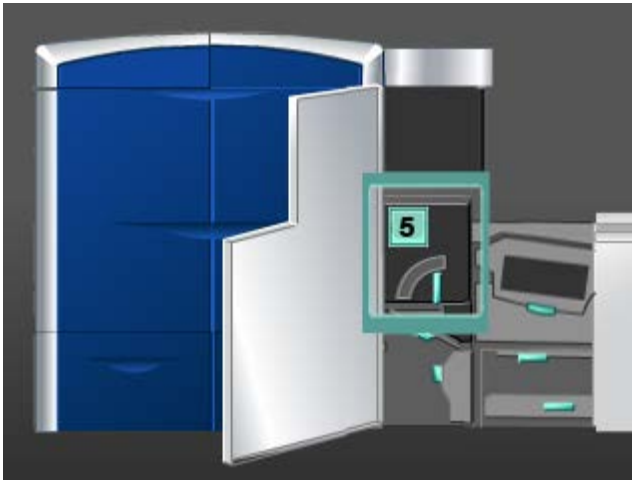
Continue to wipe the belts as you rotate them until all the belts are clean.

Note

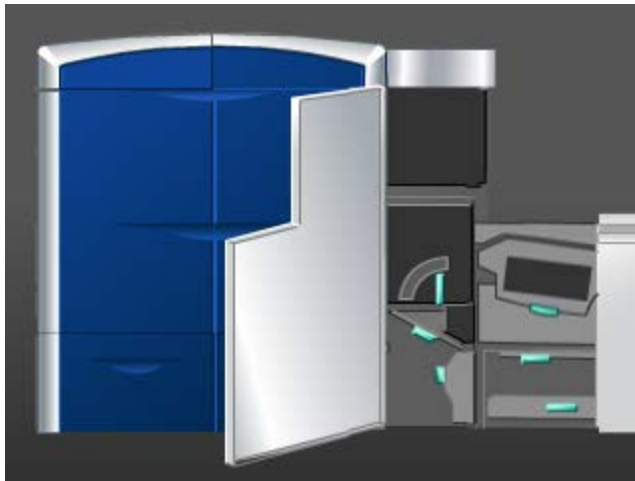
Do not rotate the belts with your bare hands as this will leave grease and dirt on them and may create paper jams. Rotate the belts by using a lint-free cloth.

9. Close the left and right front doors (print engine left side).

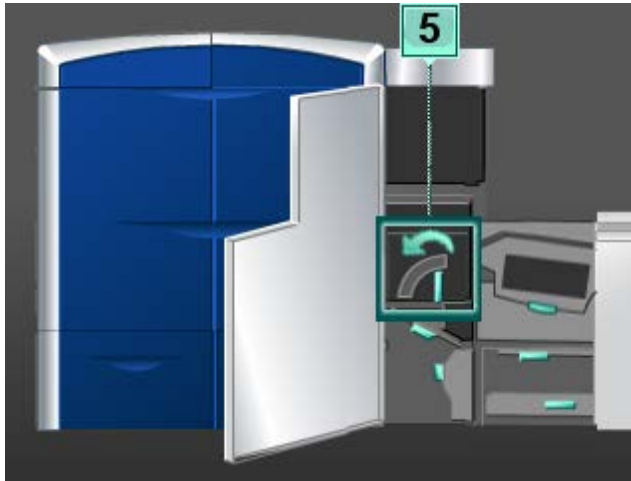
Cleaning the paper path area 5



1. Open the left front door (print engine right side).



2. Grasp handle **5** and rotate it in the direction of the arrow, and slowly pull out the fuser until it stops.



3. Using a lint-free cloth, clean the belts in Area 5 (left side) by rotating them in the direction that paper travels.

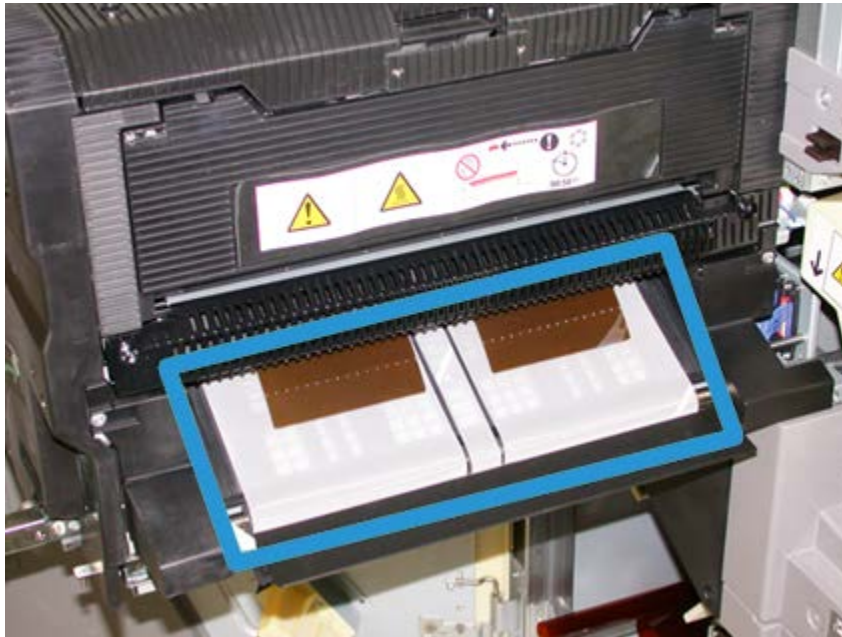


Continue to wipe the belts as you rotate them until all the belts are clean.

Note

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

4. Using a lint-free cloth, clean the belts in Area 5 (right side) by rotating them in the direction that paper travels.



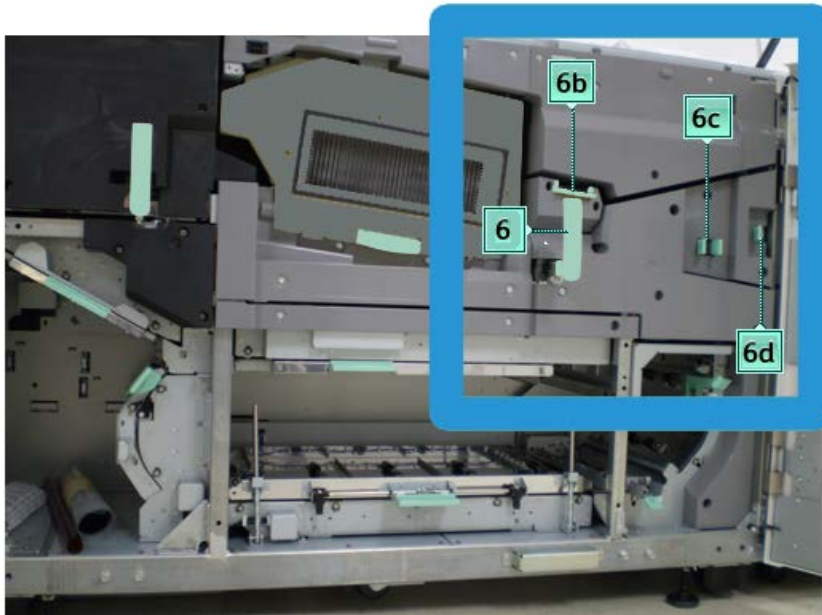
Continue to wipe the belts as you rotate them until all the belts are clean.

Note

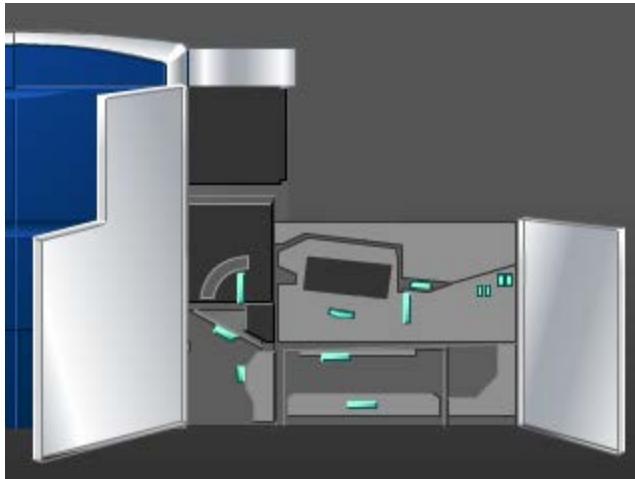
Do not rotate the belts with your bare hands as this will leave grease and dirt on them and may create paper jams. Rotate the belts by using a lint-free cloth.

5. Grasp handle 5 and gently push in the fuser until it stops.
6. Close the left front door (print engine right side).

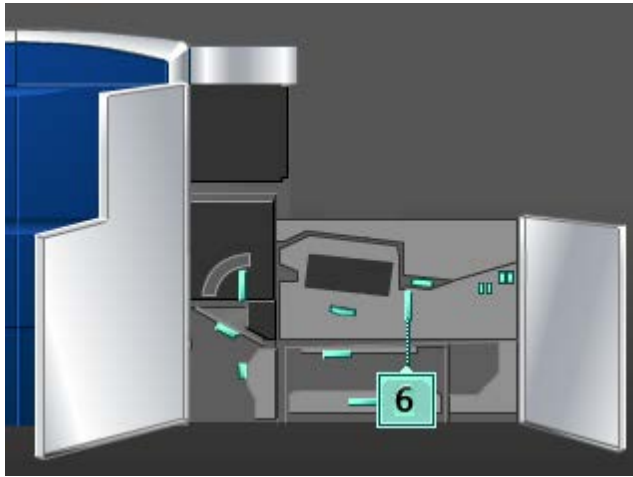
Cleaning the paper path area 6



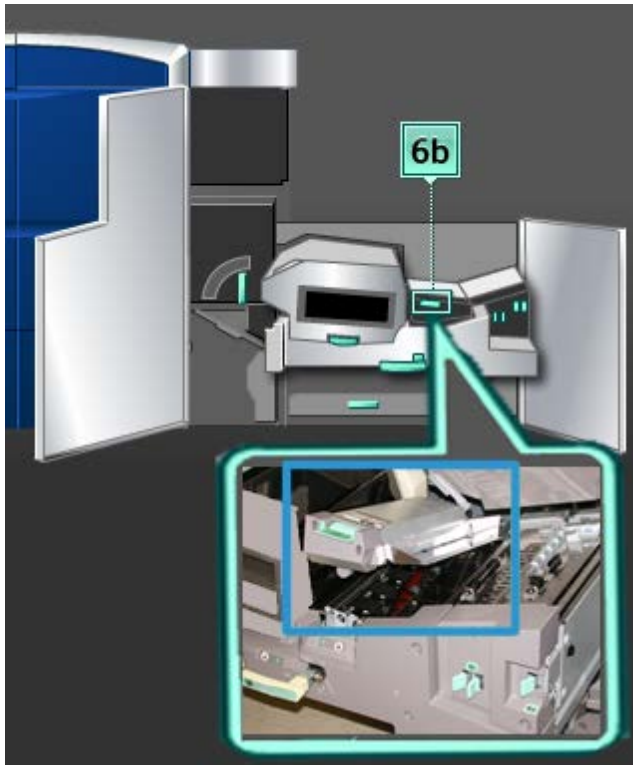
1. Open the left and right front doors (print engine right side).



2. Grasp handle **6** and rotate it in the direction of the arrow, and slowly pull out the exit drawer assembly until it stops.



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

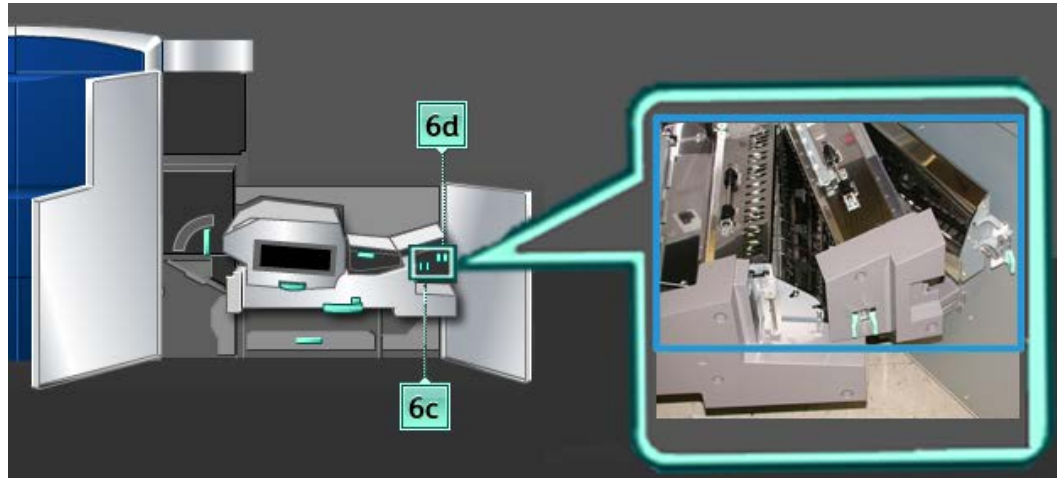


Note

Avoid touching the White Reference Roll when cleaning area 6.

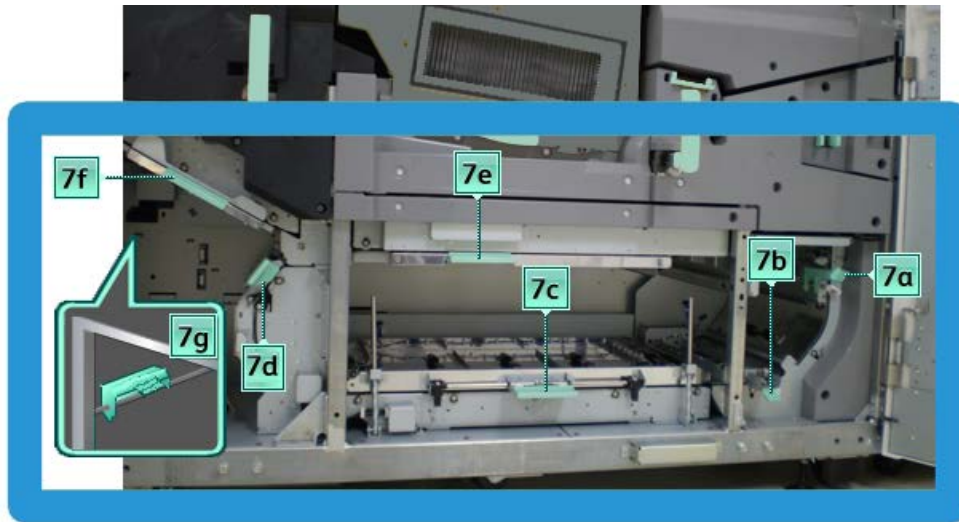
- a) Open each area and clean the surfaces of the green-handle areas.

- b) Remove any residual moisture with a dry, lint-free cloth.
- 4. Return lever **6b** to its original position.
- 5. Use a damp, water-moistened (not wet), lint-free cloth to clean the paper path only in the green lever jam clearance areas as shown in the illustration.

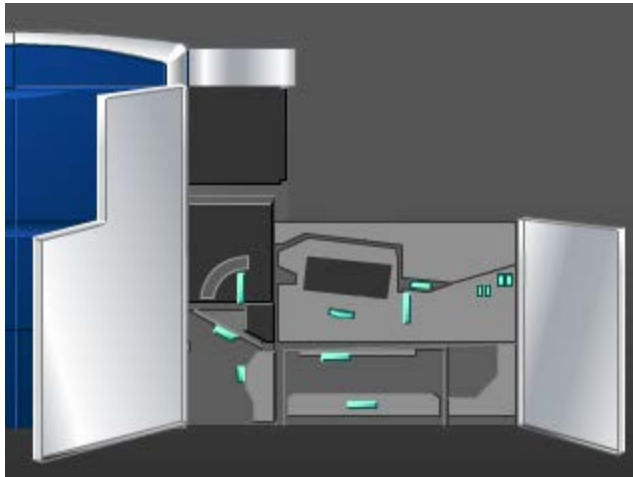


- a) Open each area and clean the surfaces of the green-handle areas.
- b) Remove any residual moisture with a dry, lint-free cloth.
- 6. Return lever **6c** to its original position.
- 7. Return lever **6d** to its original position.
- 8. Grasp handle **6** and gently push in the exit drawer assembly until it stops.
- 9. Rotate handle **6** in the direction of the arrow to lock the exit drawer assembly in place.
- 10. Close the left front door (print engine right side).

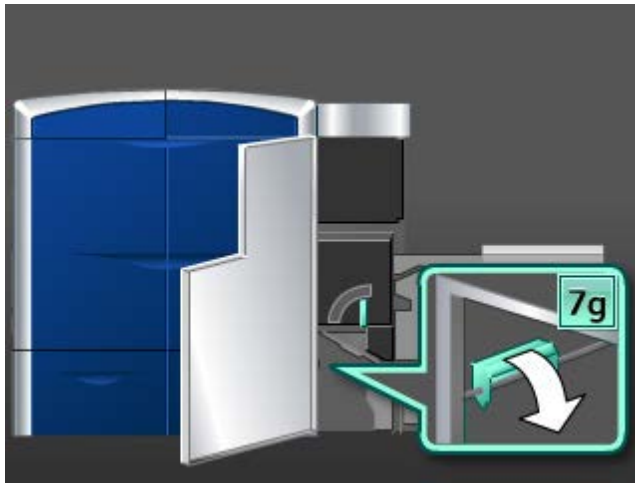
Cleaning the paper path area 7



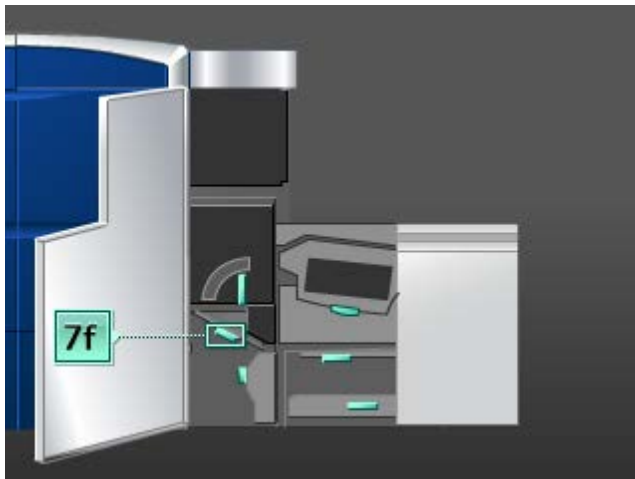
1. Open the left and right front doors (print engine right side).



2. Lift lever **7g** and move it to right.



3. Use a damp, water-moistened (not wet), lint-free cloth to clean the paper path only in the green lever jam clearance areas as shown in the illustration.
 - a) Open each area and clean the surfaces of the green-handle areas.
 - b) Remove any residual moisture with a dry, lint-free cloth.
4. Return lever **7g** to its original position.
5. Grasp lever **7f** and move it downward.

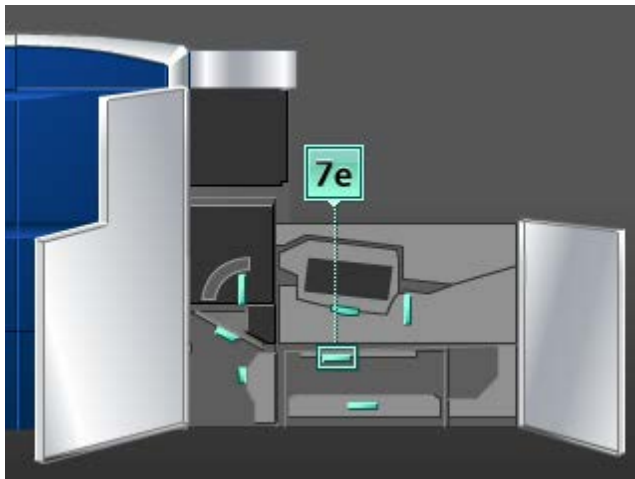


6. Use a damp, water-moistened (not wet), lint-free cloth to clean the paper path only in the green lever jam clearance areas as shown in the illustration.
 - a) Open each area and clean the surfaces of the green-handle areas.
 - b) Remove any residual moisture with a dry, lint-free cloth.
7. Return lever **7f** to its original position.

8. Grasp lever **7d** and move it to the left.

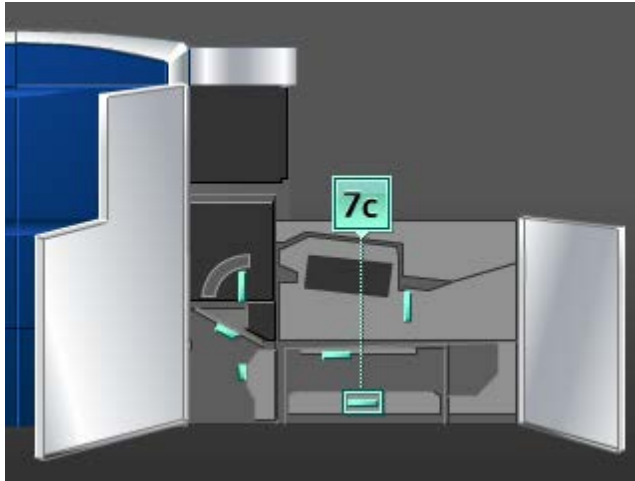


9. Use a damp, water-moistened (not wet), lint-free cloth to clean the paper path only in the green lever jam clearance areas as shown in the illustration.
- a) Open each area and clean the surfaces of the green-handle areas.
 - b) Remove any residual moisture with a dry, lint-free cloth.
10. Return lever **7d** to its original position.
11. Grasp lever **7e** and move it downward.



12. Use a damp, water-moistened (not wet), lint-free cloth to clean the paper path only in the green lever jam clearance areas as shown in the illustration.
- a) Open each area and clean the surfaces of the green-handle areas.
 - b) Remove any residual moisture with a dry, lint-free cloth.
13. Return lever **7e** to its original position.

14. Lift lever **7c**.

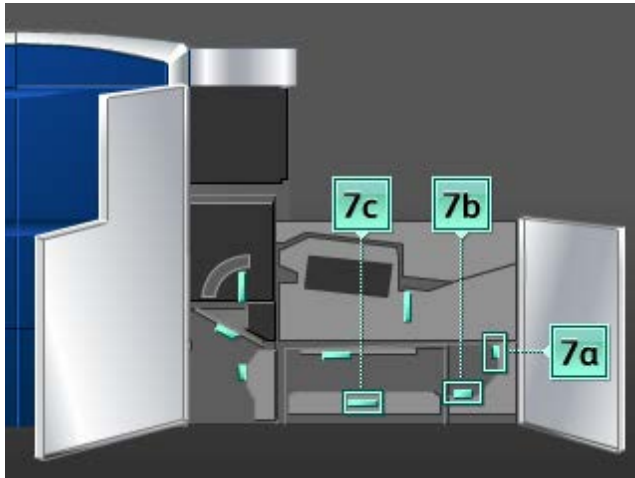


15. Use a damp, water-moistened (not wet), lint-free cloth to clean the paper path only in the green lever jam clearance areas as shown in the illustration.

- a) Open each area and clean the surfaces of the green-handle areas.
- b) Remove any residual moisture with a dry, lint-free cloth.

16. Return lever **7c** to its original position.

17. Lift lever **7b**.



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

- a) Open each area and clean the surfaces of the green-handle areas.
- b) Remove any residual moisture with a dry, lint-free cloth.

19. Return lever **7b** to its original position.

20. Grasp lever **7a** and move it to the left.

21. Use a damp, water-moistened (not wet), lint-free cloth to clean the paper path only in the green lever jam clearance areas as shown in the illustration.
 - a) Open each area and clean the surfaces of the green-handle areas.
 - b) Remove any residual moisture with a dry, lint-free cloth.
22. Return lever **7a** to its original position.
23. Close the left front door (print engine right side).

Replacing consumable supplies

Consumable supplies

Xerox supplies, paper, and throughput material can be ordered from Xerox by going to www.xerox.com and clicking on either the Contact Us link for specific contact information/telephone numbers in your area or by clicking on the Supplies and entering/selecting your specific machine information (product family and model type).

Note

Always refer to www.xerox.com for the latest Consumable Replaceable Units (CRUs) part numbers.

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

The following items are consumables for this machine. It is recommended that you have a supply of these items available to eliminate downtime when they need to be replaced.

Supply Item	Supply Unit Shipped with machine/Reorder Quantity	Approximate Print Yield/Carton (Full Color Prints)
Dry Ink/Toner Cartridge (Black)	1/box	50K
Dry Ink/Toner Cartridge (Cyan)	1/box	55K
Dry Ink/Toner Cartridge (Magenta)	1/box	51K
Dry Ink/Toner Cartridge (Yellow)	1/box	55K
Dry Ink/Toner Cartridge (Clear)	1/box	55K
Dry Ink/Toner Waste Bottle	1	120k
Fuser Web Assembly	1	400K

Note

- Dry Ink/Toner yield projections are based on 7.5 percent area coverage per color (4 colors = 30 percent) at standardized conditions on A4 (8.5 x 11 in.) Xerox Digital Color Xpressions+, 24 lb. (90 g/m²) and Colotech Plus 90 g/m² reference paper. Actual yields vary greatly, depending on color intensity, area coverage, paper stock, and run mode selected.

Maintenance

- Please call your Xerox service representative to reorder the Dry Ink/Toner Bottle Waste, the Fuser Web Assembly, and any of the charge corotron units. These parts are provided to you at no charge when ordered by a Xerox service representative.

Important

The charge corotrons can only be replaced by a trained, qualified Technical Key Operator (TKO).

Replacing a dry ink/toner cartridge



Note

Dry ink/toner cartridges include Black (K), Cyan (C), Magenta (M), Yellow (Y), and any optional cartridges that were purchased. Optional cartridges are shown in the above illustration with the yellow box around them.



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. On the print engine left side, open the upper right and/or upper left door(s).



3. Rotate the cartridge to the unlock position, as shown in the following illustration.



4. Remove and dispose of the empty cartridge according to local regulations.

Tip

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.
6. Vigorously shake and/or slap the new cartridge with your hand until the Dry Ink/Toner is completely loosened.



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.

7. To install the new cartridge, insert it into the compartment with the arrow at the top and gently push it in as far as it will.



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.

8. Rotate the cartridge to the lock position.
9. On the print engine left side, close the upper right and/or upper left door(s).

Dry ink/toner waste bottle

The dry ink/toner waste bottle collects the waste dry ink/toner that occurs during the printing process. The machine contains two dry ink/toner waste bottles which are both located in the rear of the machine.



When a waste bottle is full, a message appears on the UI advising you when to replace the bottle. Since there is a second waste bottle, the machine continues to run as long as that second waste bottle is not full. This allows you to exchange the full bottle with an empty one while the machine continues to print.

Replacing a dry ink/toner waste bottle

Note

When removing a full dry ink/toner waste bottle, **SLOWLY** pull it out of the machine. This will prevent any dry ink/toner from from spilling out of a full waste bottle.

1. Open the dry ink/toner waste bottle panel at the rear of the machine.



2. Grasp the handle of the full bottle and pull it out of the machine.



3. Lift the full bottle out of the machine.



4. 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.



5. Dispose of the full bottle according to your local regulations.
6. Remove a new, empty bottle from the carton and insert it into the machine.
7. Gently push the new bottle into the machine.
8. Close the dry ink/toner waste bottle panel at the rear of the machine.

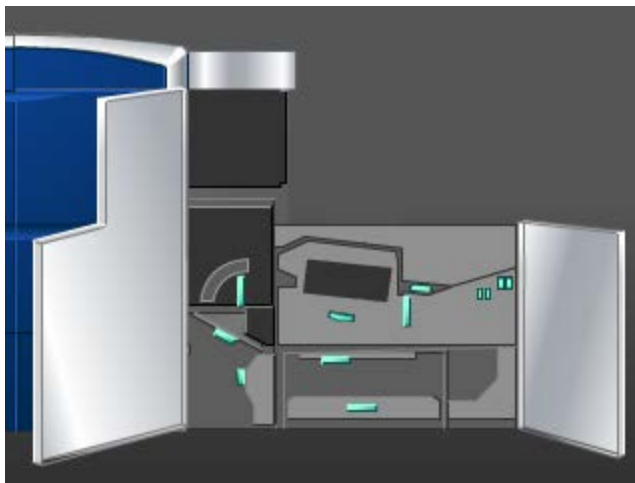
Replacing the fuser web assembly

Two messages will display on the UI regarding the fuser web assembly. 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 machine shuts down and will not print until the web is replaced.

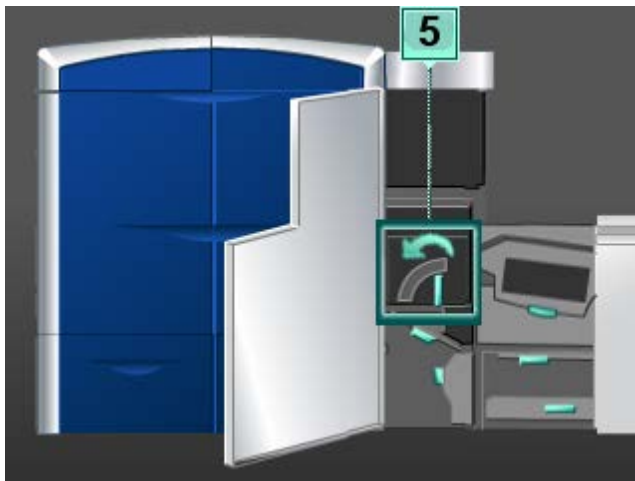
Warning

Be careful when clearing jams in the fuser area, the fuser is extremely hot and will cause injury.

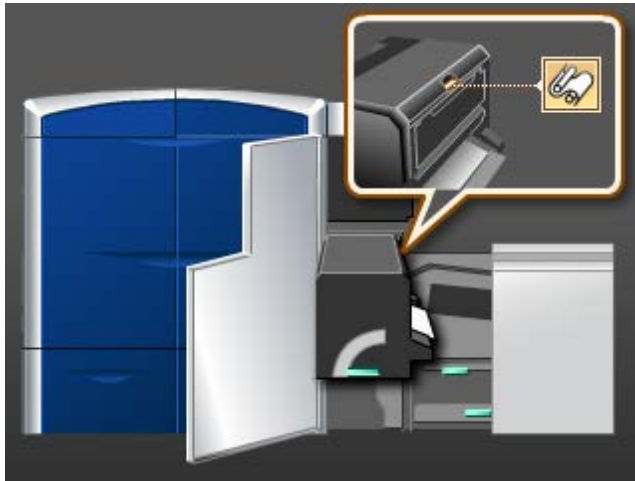
1. Open the left and right front doors (print engine right side).



2. Grasp handle **5** and rotate it in the direction of the arrow, and slowly pull out the fuser until it stops.



3. Push down on the lever; the fuser exit area opens.



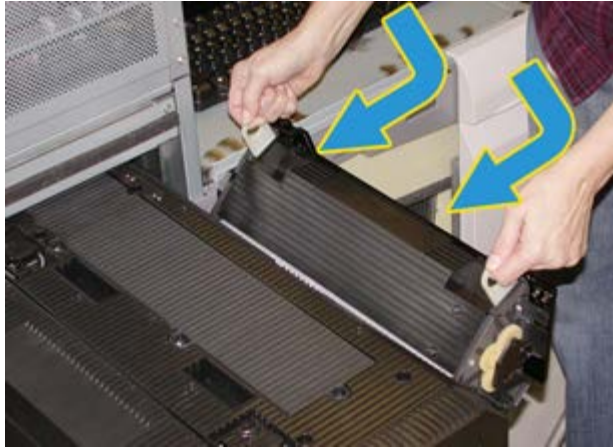
4. Grasp the handles on the fuser web assembly and pull it up and out to remove the assembly.



Dispose of the old fuser web assembly according to your local regulations.

5. Remove the new fuser web assembly from the box and the protective covering.

6. Hold the assembly by the handles with both hands and insert the assembly into the fuser.



7. Close the fuser exit area.



8. Grasp handle **5** and gently push in the fuser until it stops.
9. Rotate handle **5** in the direction of the arrow to lock the fuser module in place.
10. Close the left and right front doors (print engine right side).
11. Follow the instructions on the UI to restart your print job.

10

Problem solving

Locating the machine serial number

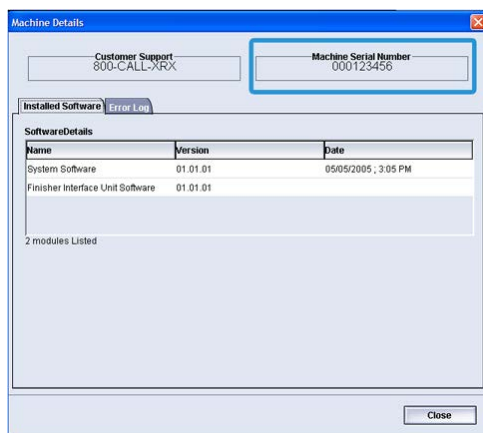
The machine serial number can be accessed from either the machine's UI or by locating it on the inside of the machine.

Related Topics:

[Calling for service](#)

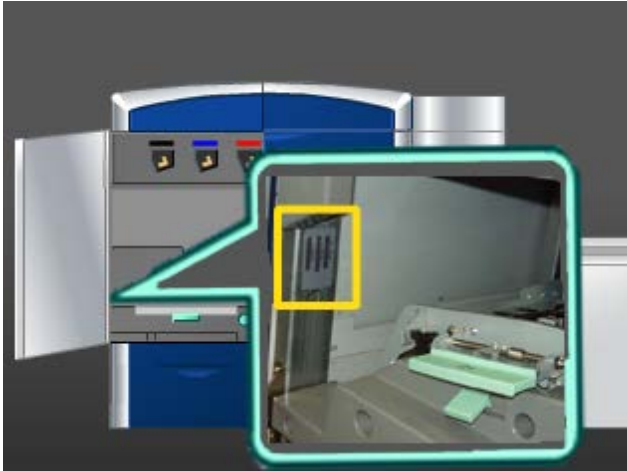
Machine serial number on the UI

The machine's serial number can be found from the UI selecting **System > Machine Details**.



Serial number on the machine

If the machine loses power and it is impossible to access the **Machine Details** tab, the serial number can be found on the machine frame on the lower left side.



Use the following procedure to find the serial number on the machine.

1. Open the left front door (print engine left side).
2. Locate the machine serial number frame on the lower left side.
3. Close the left front door (print engine left side).

Calling for service

1. Record any displayed fault codes.
2. Record the machine serial number by selecting **System > Machine Details** . (If the serial number is not displayed, open the right/left front doors on the print engine left side. The serial number is on a white label on the machine's frame.
3. If output quality is a problem, take a sample as a reference to assist you in describing the problem over the telephone when answering the questions from the customer support operator about the defects.
4. If possible, use a phone near the machine when calling for assistance. Follow the instructions provided by the operator.
5. For system support, user help, and service support, call the appropriate number. For the specific number in your area, go to www.xerox.com and select the **Support** link.

Related Topics:

[Locating the machine serial number](#)

General problems

If the machine 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 machine. If the problem persists after following all the instructions, contact your Xerox representative.

Note

If your print server indicates that the machine has a fault and the UI does not readily display a message, select **System > Machine Details**, then select the Error Log tab to display the fault history.

Problem	Suggested solutions
The machine does not power on	• Ensure the power cord is plugged into the receptacle correctly. • Ensure the power switch inside the front 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 machine does not power on, contact the Customer Support Center for assistance.
There is no power to the machine and you cannot access the Machine Details screen to get the machine serial number.	Open the two main front doors. The serial number is located on the frame area above Trays 1 and 2 on the print engine left side.
The machine does not successfully complete a print job.	• Is your machine connected to the network as a printer? Try printing a test page from your workstation to the machine to verify that the machine is connected on the network. • Verify that the power cable is connected to the machine and to a suitable power socket. • Verify that the network cables are attached securely to the machine and seated properly. • Clear out the print job from the print queue and re-send print job. • Power Off/On the machine to restart it. • Your machine may not be configured on the network. Contact your System Administrator to connect the machine to the network.

Problem solving
(continued)

Problem	Suggested solutions
The machine is taking longer than one minute before printing the next job.	The system requires approximately 2 minutes when switching print modes in order to make any necessary adjustments for the next print job, including color-to-color registration, density, charge levels, bias levels, or other adjustments. • The system has four print modes: - 4 Color (YMCK: Yellow, Magenta, Cyan, Black) - 4 Color plus optional Clear - K (Black) Only - Clear Only • If the next print job is switching print modes, for example from black-only to 4-color, the system requires approximately 2 minutes to make any necessary adjustments. • During this time, the User Interface (UI) displays the “Adjusting Image Quality” message. • The next job begins printing once the system completes its adjustments. Other information to remember includes: • From a cold start (power on or power saver), system takes less than 5 minutes to start printing. • From standby mode, system usually takes less than 1 minute to start printing.
After clearing a paper jam, the machine’s User Interface (UI) displays the message “Charge Corotron device is not properly installed.” None of the charge corotron assemblies were changed or touched.	• The machine automatically cleans the charge corotron assemblies every 1,000 prints. • If a paper jam occurs while the machine is performing a charge corotron cleaning, the cleaning process is interrupted and a message is displayed on the UI. • To clear this message and resume printing, simply cancel out of the message. Important The charge corotrons can only be replaced by a trained, qualified Technical Key Operator (TKO).
Prints are not on desired paper size	• Ensure that the proper paper is loaded in the paper trays. • Select the paper size, tray and weight through the machine options on your PC. • Ensure that the correct weight is set on the Tray Properties window. • Ensure that “Fit to Paper” or an equivalent selection is not selected in your print driver.

(continued)

Problem	Suggested solutions
Paper is misfed or wrinkles repeatedly	• If a message appears on the UI, follow the instructions displayed. • Ensure the proper paper is loaded correctly and not filled above the MAX line. Refer to The Recommended Materials List. • 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.
The UI does not respond to a command	• Select System > Restart User Interface. • Select System > Shutdown System PC. After the System PC shuts down, wait 15 seconds and restart it by pressing the on/off button on the PC. • If the problem persists, call the Customer Support Center.
The UI is locked up.	If the UI is locked up, and the mouse or keyboard do not work, press and hold the UI power button on the PC until the UI powers down. Wait 30 seconds and press the PC power button to reboot the UI.
The UI monitor screen is blank.	• Verify that the UI monitor button is pressed and lit. • Verify that the PC UI monitor cable is seated properly into the back of the PC.
Multiple sheets feed from the paper trays	• 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.
Paper jams when exiting the Paper Trays	• 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.

Problem solving
(continued)

Problem	Suggested solutions
Output jams when exiting the machine to the Offset Catch Tray	• 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	Paper curl may be a result of: • Ensure that the correct paper weight and paper type are selected. • The mass of dry ink (toner) coverage on the print output - the greater the dry ink/toner mass, the greater the paper curl. • The paper weight and whether or not it is coated or uncoated. • The humidity conditions at the machine. • 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. • To ensure continuous production, empty the output device when the output approaches the maximum amount that the device can hold; refer to the specifications for that output device for output limit amount. • An attempt to print on thicker paper or on paper stock that is less sensitive to moisture. Paper curl can be adjusted in the following ways: • When logged in as the System Administrator by using the Advanced Stock Setup feature (Paper Curl Correction option); refer to the System Administration Guide for more information. • If you have the optional Interface Module (IM) attached, you can use the manual decurl buttons on the IM's control panel. Refer to the section later in this guide called Interface Module (IM). • If you have the optional Standard/Booklet Maker Finisher attached, you can use the manual decurl buttons on the finisher. Refer to the section later in this guide called Standard/Booklet Maker Finisher.
Software Tool Fault message: A software tool that is running on the System Computer did respond properly.	This occurs when an error to the LogHarvest Plus tool occurs. The LogHarvest Plus tool is shown as a house icon on the bottom right side of the UI screen. To resolve this error, select Programs > Startup > LogHarvest Plus.

Related Topics:

- [Power on/off the machine](#)
- [Locating the machine serial number](#)
- [System menu](#)
- [Cleaning procedures](#)
- [Replacing consumable supplies](#)

Jam clearance

Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

Related Topics:

- [Fault codes](#)
- [Paper jams in Trays 1 and 2](#)
- [Paper jams in area 2](#)
- [Paper jams in areas 3 and 4](#)
- [Paper jams in area 5](#)
- [Paper jams in area 6](#)
- [Paper jams in area 7](#)

Paper jams in Trays 1 and 2



1. Pull out the tray slowly until it stops.
2. Remove jammed paper.

Note

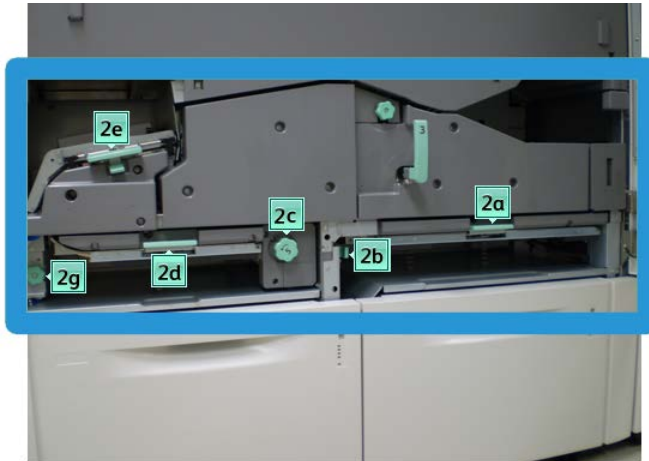
If paper is torn, check inside the machine and remove it.

3. Gently push in the tray until it comes to a stop.

Problem solving

4. Follow the instructions on the UI to clear other areas or to resume your print job.

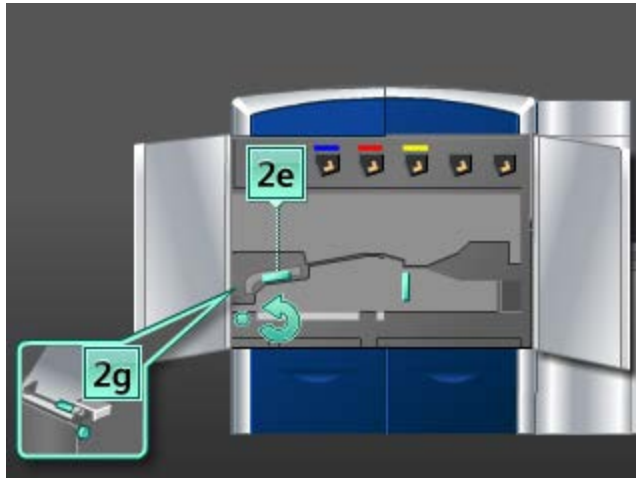
Paper jams in area 2



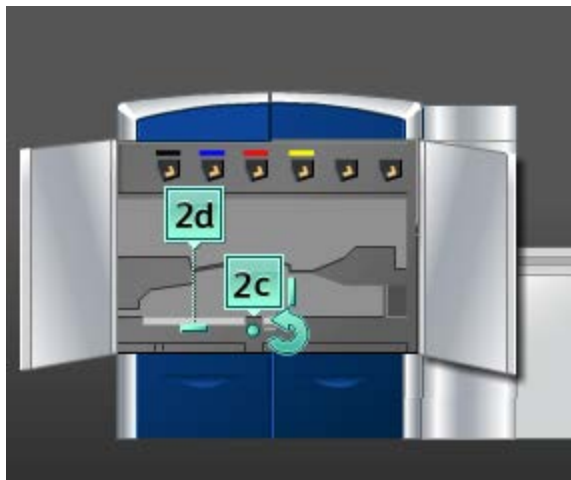
1. Open the left and right front doors (print engine left side).



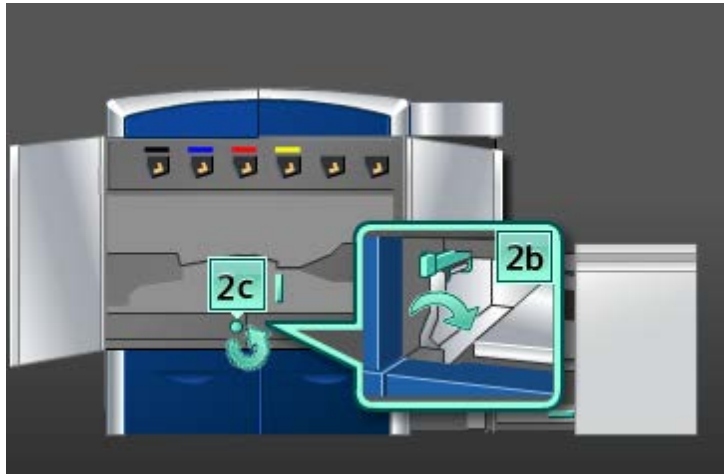
2. Lift lever **2e** to remove jammed paper.



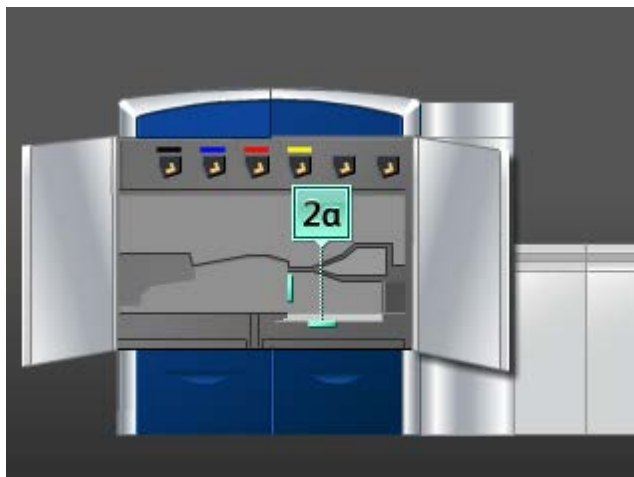
3. Rotate knob **2g** in the direction of the arrow to remove jammed paper.
4. Return lever **2e** to its original position.
5. Push down on lever **2d** and rotate knob **2c** in the direction of the arrow to remove jammed paper.



6. Return lever **2d** to its original position.
7. Grasp lever **2b** and move it to the right. Rotate knob **2c** in the direction of the arrow to remove jammed paper.

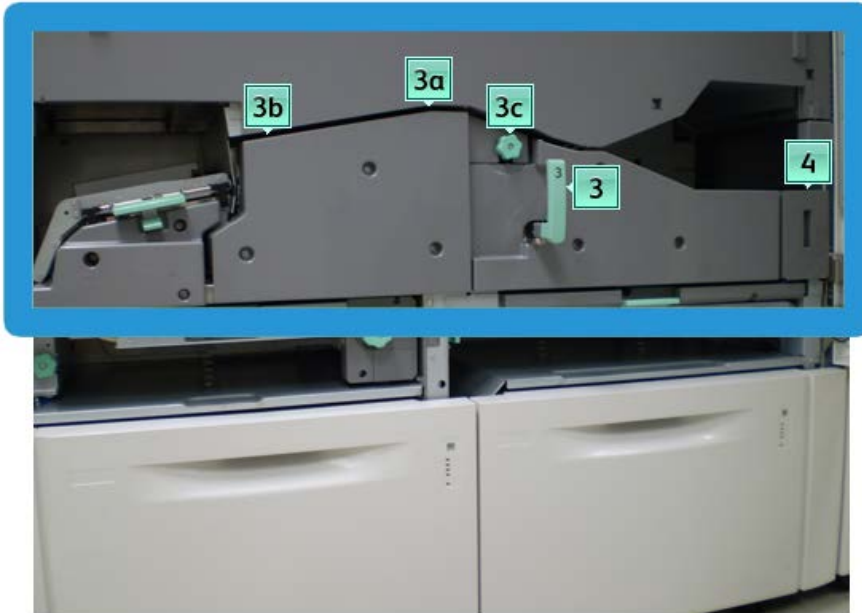


8. Return lever **2b** to its original position.
9. Push down on lever **2a** to remove jammed paper.



10. Return lever **2a** to its original position.
11. Close the left and right front doors (print engine left side).
12. Follow the instructions on the UI to clear other areas or to resume your print job.

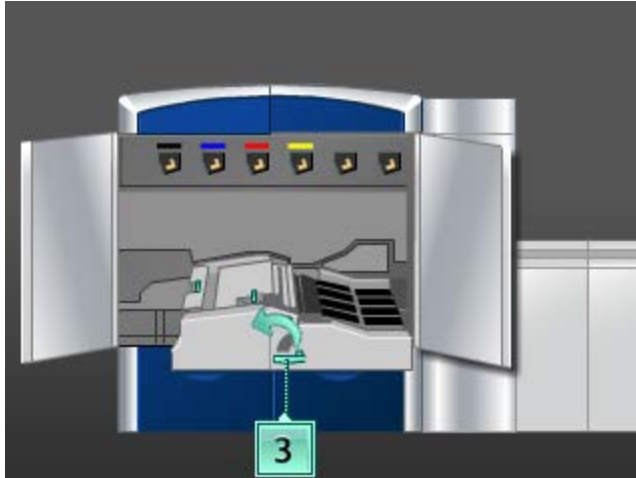
Paper jams in areas 3 and 4



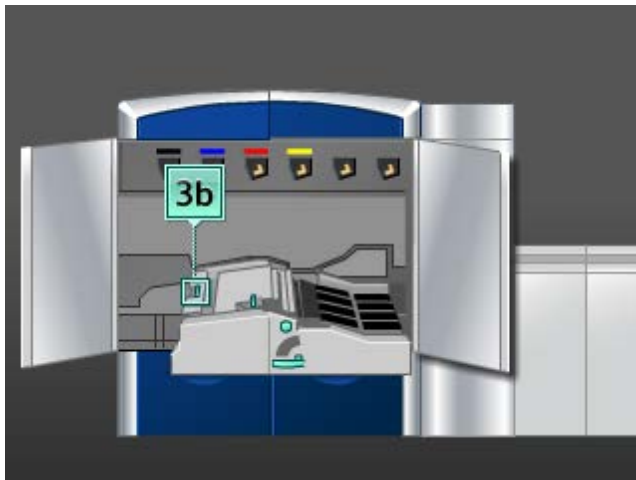
1. Open the left and right front doors (print engine left side).



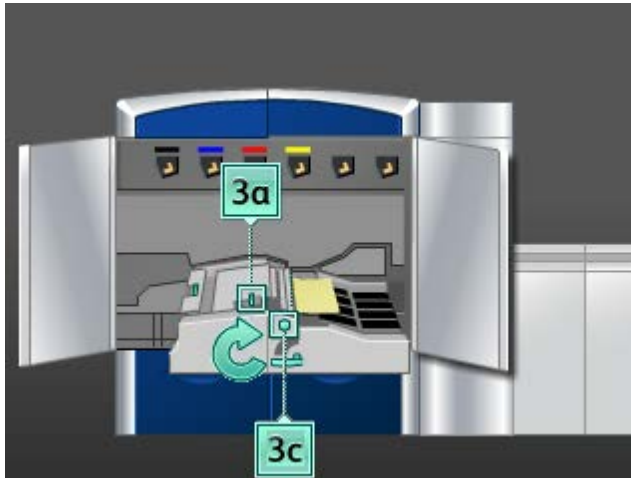
2. Grasp handle 3 and rotate it in the direction of the arrow.



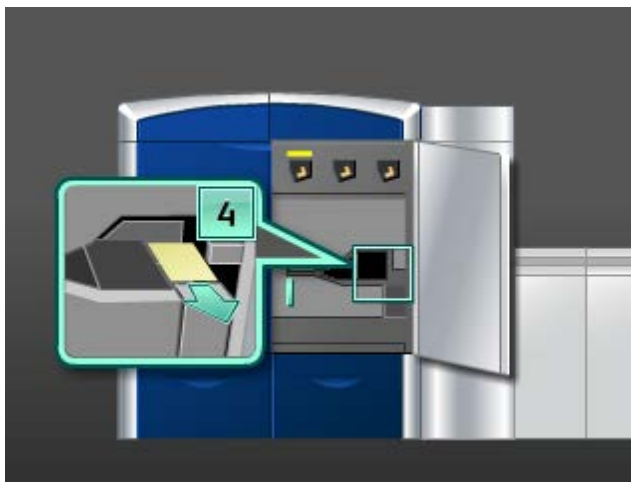
3. Slowly pull out the paper transport drawer until it stops.
4. Lift lever **3b**, move it to the left, and remove the jammed paper.



5. Return lever **3b** to its original position.
6. Lift lever **3a**, move it to the left, and rotate knob **3c** in the direction of the arrow to remove jammed paper.



7. Return lever **3a** to its original position.
8. Grasp handle **3** and slowly push in the paper transport drawer until it stops. Turn the handle in the direction of the arrow to lock the module in place.
9. Remove any paper from area **4**.



10. Close the left and right front doors (print engine left side).
11. Follow the instructions on the UI to clear other areas or to resume your print job.

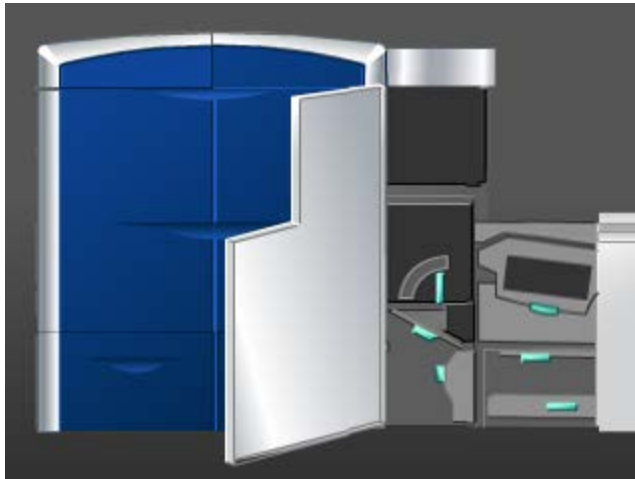
Paper jams in area 5



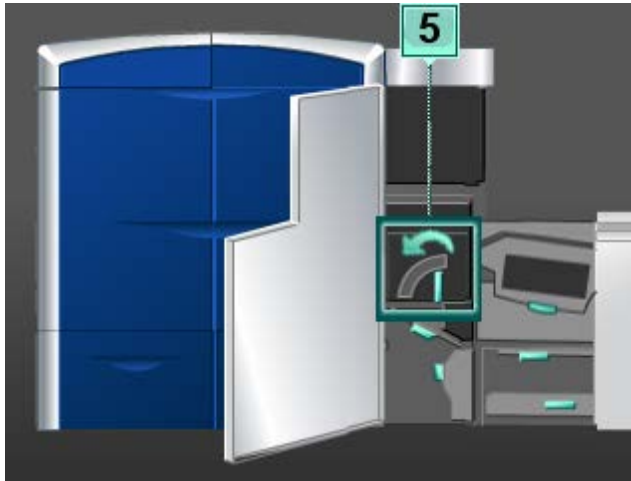
Warning

Be careful when clearing jams in the fuser area, the fuser is extremely hot and will cause injury.

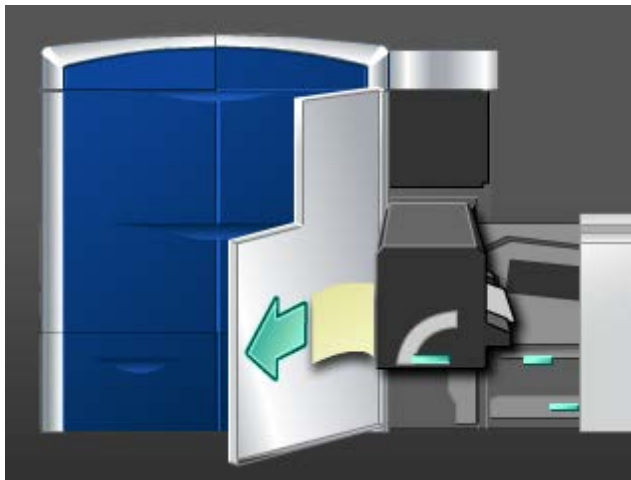
1. Open the left front door (print engine right side).



2. Grasp handle **5** and rotate it in the direction of the arrow, and slowly pull out the fuser until it stops.

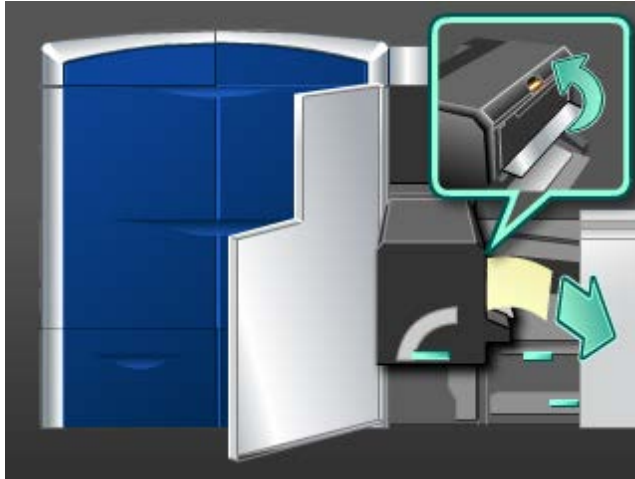


3. Carefully remove any jammed paper on the left side of the fuser.



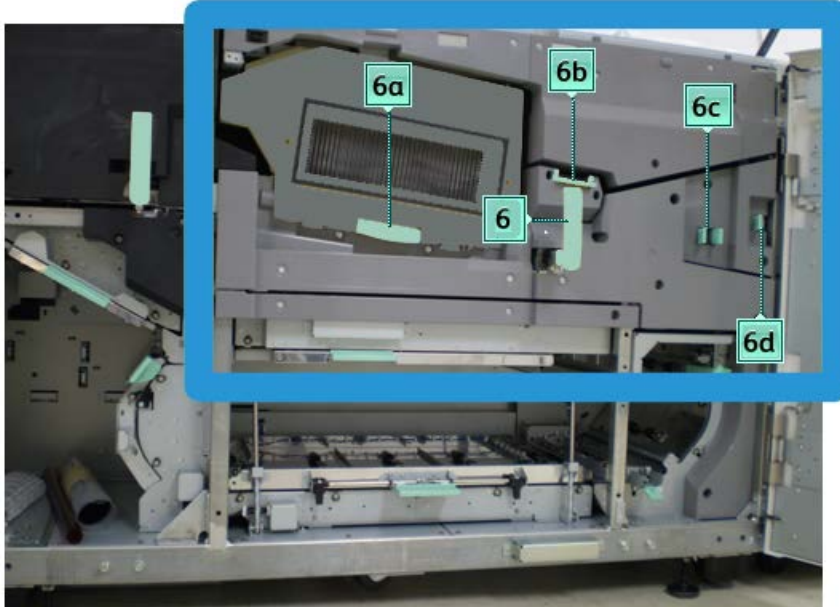
Problem solving

4. Push down on the lever; the fuser exit area opens. Carefully remove any jammed paper on the right side of the fuser.

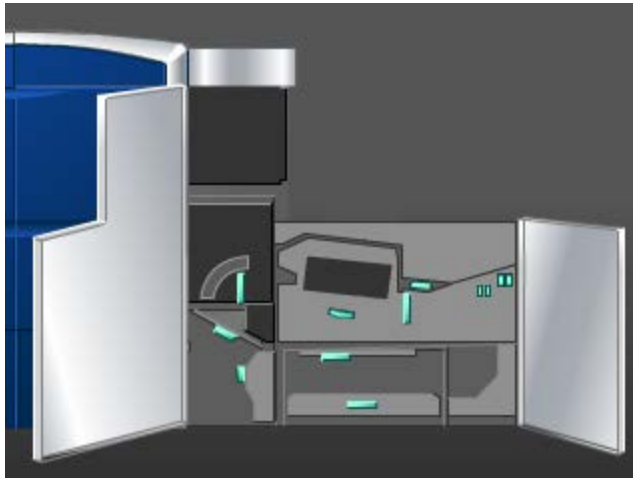


5. Close the fuser exit area.
6. Grasp handle **5** and gently push in the fuser until it stops.
7. Rotate handle **5** in the direction of the arrow to lock the fuser module in place.
8. Close the left front door (print engine right side).
9. Follow the instructions on the UI to clear other areas or to resume your print job.

Paper jams in area 6

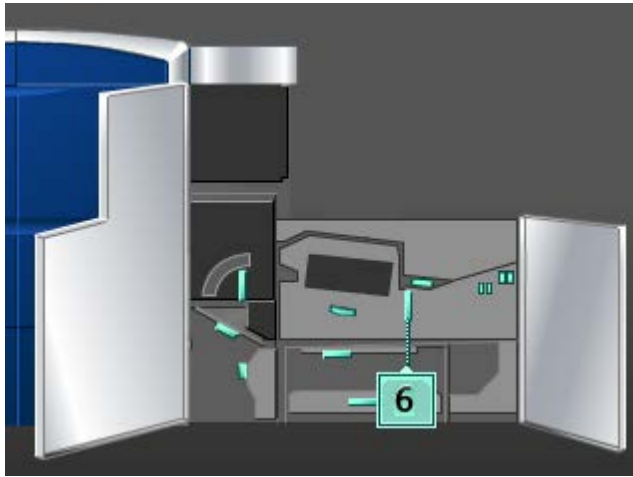


1. Open the left and right front doors (print engine right side).

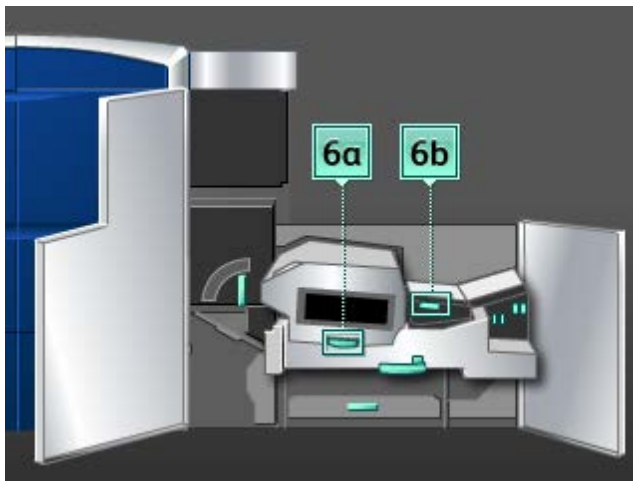


Problem solving

2. Grasp handle **6** and rotate it in the direction of the arrow, and slowly pull out the exit drawer assembly until it stops.

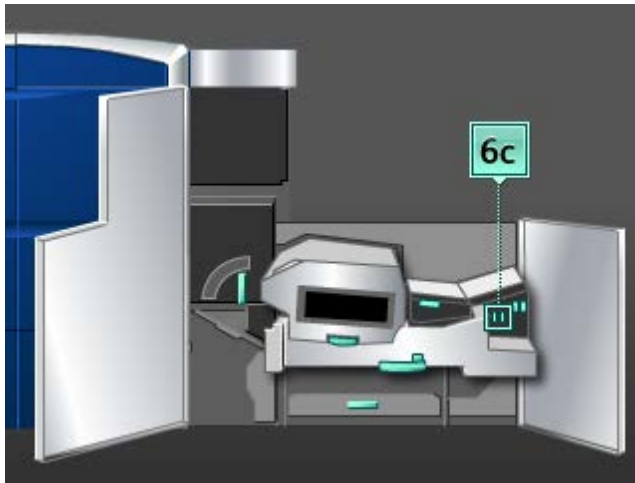


3. Lift levers **6a** and **6b** and remove the jammed paper.

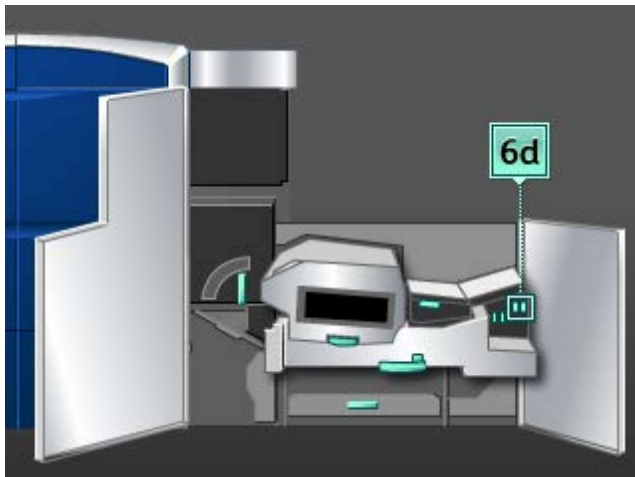


4. Return levers **6a** and **6b** to their original positions.

5. Grasp lever **6c**, move it to the right, and remove the jammed paper.

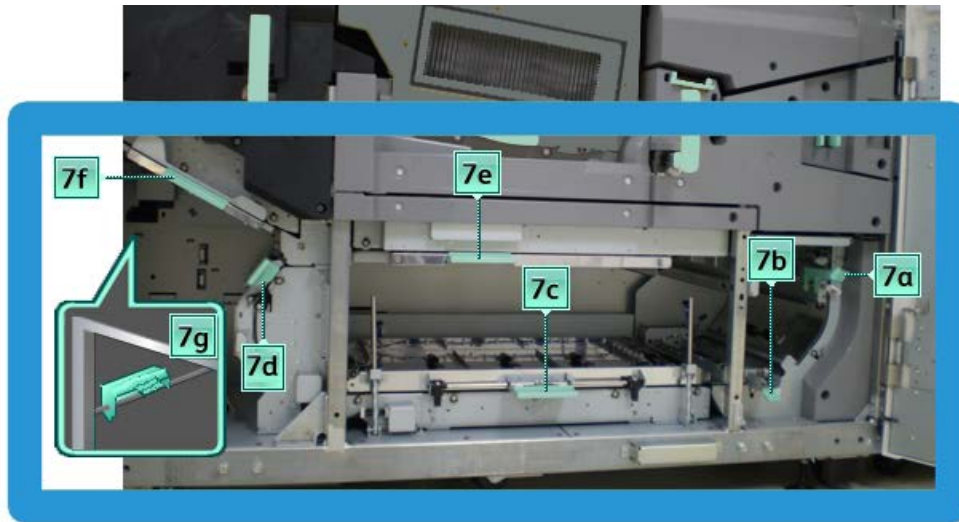


6. Return lever **6c** to its original position.
7. Grasp lever **6d**, move it to the right, and remove the jammed paper.



8. Return lever **6d** to its original position.
9. Grasp handle **6** and gently push in the exit drawer assembly until it stops.
10. Rotate handle **6** in the direction of the arrow to lock the exit drawer assembly in place.
11. Close the left and right front doors (print engine right side).
12. Follow the instructions on the UI to clear other areas or to resume your print job.

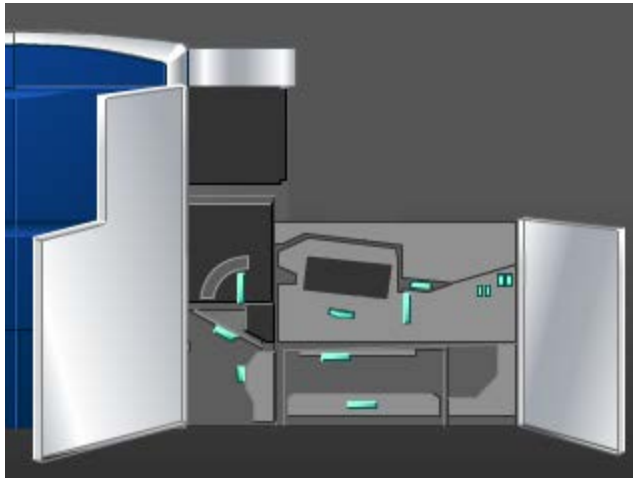
Paper jams in area 7



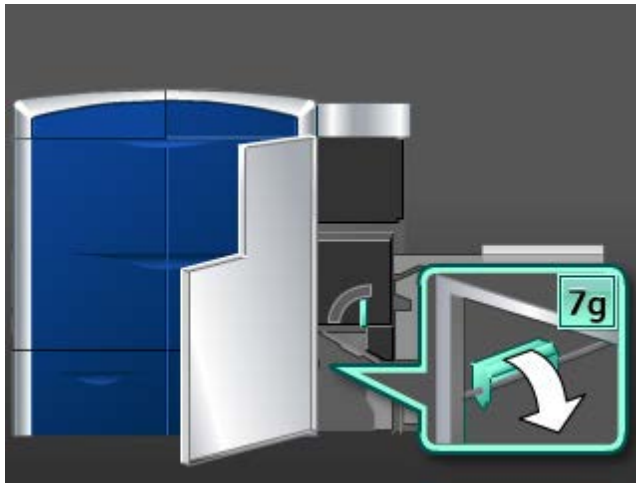
Note

Area 7 is used for 2-sided (duplexing) only.

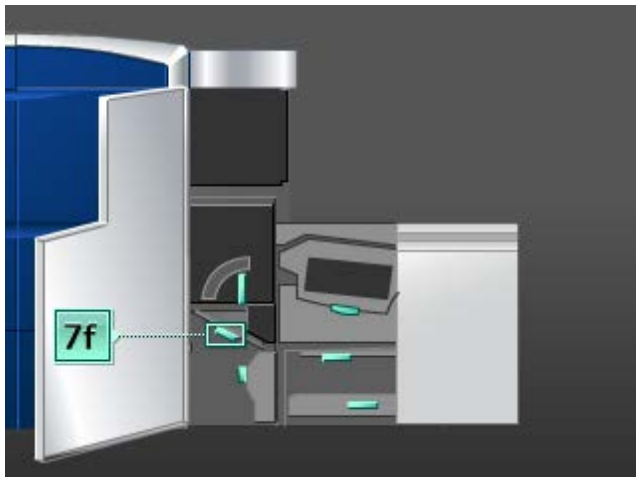
1. Open the left and right front doors (print engine right side).



2. Lift lever **7g** and move it to right to remove jammed paper.



3. Return lever **7g** to its original position.
4. Grasp lever **7f**, move it downward, and remove the jammed paper.



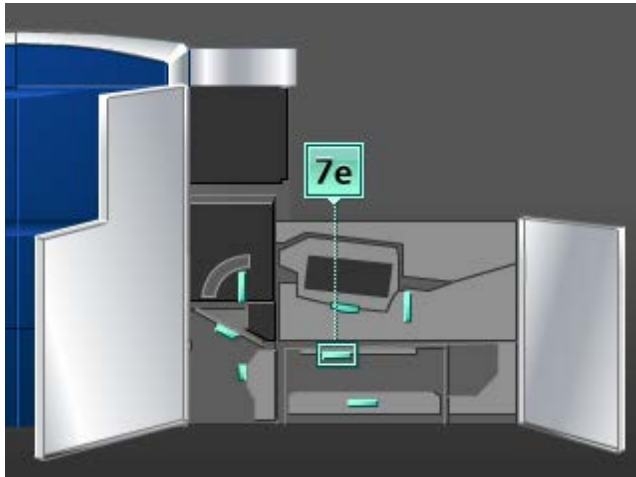
5. Return lever **7f** to its original position.

Problem solving

6. Grasp lever **7d**, move it to the left, and remove the jammed paper.

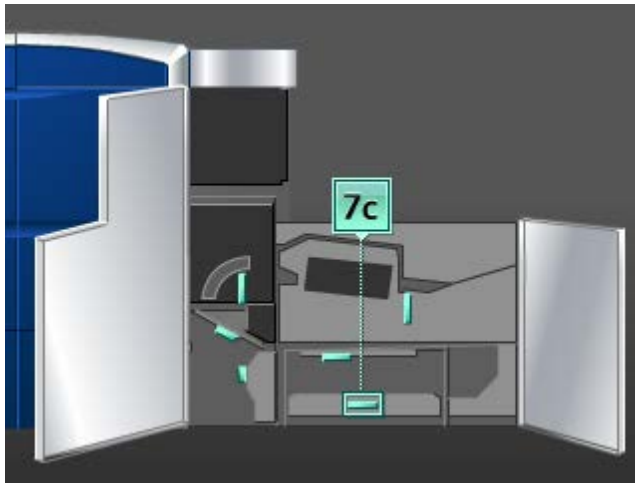


7. Return lever **7d** to its original position.
8. Grasp lever **7e**, move it downward, and remove the jammed paper.

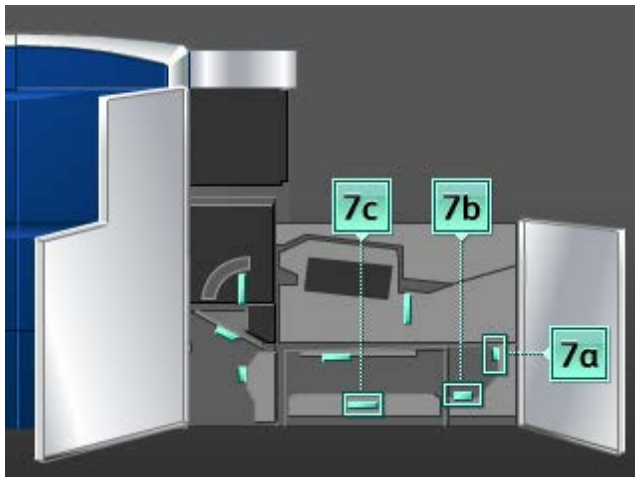


9. Return lever **7e** to its original position.

10. Lift lever **7c** and remove the jammed paper.



11. Return lever **7c** to its original position.
12. Lift lever **7b** and remove the jammed paper.



13. Return lever **7b** to its original position.
14. Grasp lever **7a**, move it to the left, and remove the jammed paper.
15. Return lever **7a** to its original position.
16. Close the left and right front doors (print engine right side).
17. Follow the instructions on the UI to clear other areas or to resume your print job.

Fault codes

If the printing ended abnormally, or a malfunction occurred in the machine, then a fault code is displayed. If a fault code appears on the machine and it is not listed in the table below, or if a fault persists after following the listed solution, then contact your Xerox Customer Support Center. If a fault code is displayed, all print data on the machine as well as print data stored in the machine's built-in memory is discarded.

Fault code	Possible cause	Recommended solution
010 300	Fuser Drawer is open.	Open the front doors and verify that the fuser door is closed. Power Off/On the machine.
010 310, 010 311, 010 312, 010 313, 010 314, 010 315, 010 316, 010 317, 010 318, 010 319, 010 321, 010 323, 010 324, 010 325, 010 326, 010 327, 010 328, 010 333, 010 334, 010 335, 010 336, 010 337, 010 338, 010 341, 010 342, 010 343, 010 344, 010 347, 010 348, 010 349, 010 350, 010 351, 010 352, 010 353, 010 354, 010 355, 010 356, 010 357, 010 369, 010 370, 010 371, 010 374, 010 379, 010 380, 010 386, 010 387, 010 389	Fuser belt speed faults	Power Off/On the machine. If error persists, contact the Customer Support Center.
010 360, 010 401	A Fuser temperature error or disconnection	Power Off/On the machine. If error persists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
010 362, 010 363, 010 364, 010 365	Paper curl (decurler faults)	Power Off/On the machine. If error persists, contact the Customer Support Center.
010 366	The Fuser Belt Out sensor did not change state within one second after the Fuser Motor is energized	Power Off/On the machine. If error persists, contact the Customer Support Center.
010 367 010 368	Sensor failure	Power Off/On the machine. If error persists, contact the Customer Support Center.
010 381 010 382	Pressure Roll fan error	Power Off/On the machine. If error persists, contact the Customer Support Center.
010 400	Fuser Web fault	Power Off/On the machine. If error persists, contact the Customer Support Center.
010 406	Fuser Belt fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
010 407	Pressure Roll fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
010 408	Sheet Life limit occurred	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.

Problem solving
(continued)

Fault code	Possible cause	Recommended solution
010 409	Presser Role Finger fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
010 410	Trim Transfer Belt limit fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
010 411	V-Tray Belt Exit fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
010 412	Upper Cooling Belt fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
010 413	Roll Assembly fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
010 416	Lower Cooling Belt fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
010 600 010 601	Environmental Temperature Sensor error	Power Off/On the machine. If error persists, contact the Customer Support Center.
010 602 010 603 010 603 010 604	Pressure Roll IRS1 and IRS2 Sensing failure	Power Off/On the machine. If error persists, contact the Customer Support Center.
010 606	Fuser Belt problem	Power Off/On the machine. If error persists, contact the Customer Support Center.
010 910	Fuser Web fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
010 911	Fuser Web is not installed correctly	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
024 210, 024 211, 024 700, 024 701	Communication error between the system and the Attention light	Power Off/On the machine. If error persists, contact the Customer Support Center.
024 910	Accessory card for the Print Server is pulled out, resulting in Print Server not starting	Re-insert the accessory card. Power Off/On the machine.

Problem solving
(continued)

Fault code	Possible cause	Recommended solution
024 911 024 912	Paper stock mismatch fault with the Print Server	Cancel job. Power Off/On. Check paper stock in tray and ensure that stock matches the Tray Properties on the machine UI.
024 913	Operation control cannot be done since Stock file parameters designated for a job differ between when receiving the job and when print the job	Cancel job. Power Off/On the machine.
024 914	Sheet Queue is full	Cancel job. Power Off/On the machine.
024 915	The “STOP” button on the PC UI was selected during a job	Resume the job. Cancel job. Power Off/On the machine.
024 916	The “Delete” button on the PC UI or Print Server UI was selected during a job	Power Off/On the machine.
027 321	Detected no power to the Print Server	Cancel job. Power Off/On the Print Server.
027 322	Initialize request from the Print Server	Cancel job. Power Off/On the Print Server.
027 323, 027 324, 027 325, 027 326, 027 327, 027 328, 027 329, 027 330, 027 331	Print Server video cable fault codes	Cancel job. Power Off/On the Print Server. Power Off/On the machine. If error persists, contact the Customer Support Center.
027 400	Print job is stopped at the Print Server	Resume job at Print Server. Power Off/On the machine. If error persists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
042 310, 042 311, 042 312, 042 313, 042 314, 042 315, 042 316, 042 317, 042 318, 042 319, 042 321, 042 322, 042 323, 042 324, 042 325, 042 326, 042 327, 042 328, 042 329, 042 330, 042 331, 042 332, 042 333, 042 334	Machine Drum Motor faults	Power Off/On the machine. If error persists, contact the Customer Support Center.
042 335	Transfer Belt Drive Motor error	Power Off/On the machine. If error persists, contact the Customer Support Center.
042 336	Belt position failure	Power Off/On the machine. If error persists, contact the Customer Support Center.
042 337	Belt Edge Sensor error	Power Off/On the machine. If error persists, contact the Customer Support Center.
042 338, 042 339, 042 340, 042 341, 042 342, 042 343, 042 344, 042 347, 042 348, 042 349, 042 350, 042 351, 042 352, 042 353, 042 354, 042 355, 042 356, 042 357, 042 358, 042 359, 042 360, 042 361, 042 362, 042 363, 042 364, 042 365, 042 366, 042 367, 042 368, 042 369, 042 370, 042 371, 042 372, 042 373, 042 374, 042 375, 042 376, 042 377, 042 378, 042 379, 042 380, 042 381	Broken Fan fault codes	Power Off/On the machine. If error persists, contact the Customer Support Center.
042 382, 042 383, 042 384, 042 385, 042 386, 042 387,	Drum Encoder signal errors	Power Off/On the machine. If error persists, contact the Customer Support Center.
042 400, 042 401, 042 402, 042 403, 042 404, 042 405, 042 406, 042 407, 042 408, 042 409, 042 410	Various machine faults	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.

Problem solving
(continued)

Fault code	Possible cause	Recommended solution
042 600, 042 601, 042 602, 042 603, 042 604, 042 605, 042 606, 042 607, 042 608, 042 609, 042 610, 042 611	Drum Motor phase faults	Power Off/On the machine. If error persists, contact the Customer Support Center.
042 620, 042 622, 042 623, 042 624, 042 625, 042 626, 042 627, 042 628, 042 629, 042 630, 042 631, 042 632, 042 633, 042 634, 042 635, 042 636	Registration Belt fault codes	Power Off/On the machine. If error persists, contact the Customer Support Center.
045 312, 045 313, 045 314	Software logic fault	Power Off/On the machine. If error persists, contact the Customer Support Center.
045 316, 045 317, 045 319, 045 320, 045 330, 045 331, 045 332, 045 333, 045 334, 045 335, 045 336, 045 337, 045 339, 045 340, 045 341,	RAM Mother board faults	Power Off/On the machine. If error persists, contact the Customer Support Center.
045 321, 045 322, 045 324, 045 325	Non-Volatile Memory test failure with the Mother board	Power Off/On the machine. If error persists, contact the Customer Support Center.
045 326, 045 327, 045 328, 045 329, 045 342, 045 353, 045 358, 045 359, 045 360, 045 361, 045 362, 045 363, 045 364, 045 365, 045 366, 045 367, 045 368, 045 369, 045 370, 045 371, 045 372, 045 373, 045 374, 045 375, 045 376, 045 377, 045 378, 045 600, 047 310, 047 320,	Communication failure	Power Off/On the machine. If error persists, contact the Customer Support Center.
045 349 045 350	Software logic errors	Power Off/On the machine. If error persists, contact the Customer Support Center.
045 351 045 352	Detected a Drive Mother Board faults	Power Off/On the machine.
045 354, 045 355, 045 356, 045 357	Software mismatch	Power Off/On the machine. If error persists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
045 379, 045 380, 045 381, 045 382, 045 383, 045 384, 045 385	Burned-out fuse on the Drive Mother Board	Power Off/On the machine. If error persists, contact the Customer Support Center.
045 390, 045 391, 045 392, 045 393, 045 394	NVM data failures	Power Off/On the machine. If error persists, contact the Customer Support Center.
048 300	A front door on the machine is open	Close the front door. Power Off/On the machine.
048 324	This jam occurs when the optional GBC AdvancedPunch is attached. The jam may occur between the GBC AdvancedPunch and the optional finishing device.	• Clear any jams between the GBC AdvancedPunch and the optional finishing device (such as the High Capacity Stacker or Standard/Booklet Maker Finisher). • Fully open/close the jam clearance lever between the GBC AdvancedPunch and the optional finishing device. • After clearing all jams, a sheet will be ejected from the GBC AdvancedPunch to the optional finishing device; remove the ejected sheet.

Problem solving
(continued)

Fault code	Possible cause	Recommended solution
061 310, 061 311, 061 312, 061 313, 061 314, 061 315, 061 316, 061 317, 061 318, 061 319, 061 320, 061 321, 061 322, 061 323, 061 324, 061 325, 061 326, 061 327, 061 328, 061 329, 061 330, 061 331, 061 332, 061 333, 061 334, 061 335, 061 336, 061 337, 061 338, 061 339, 061 340, 061 341, 061 342, 061 343, 061 344, 061 345, 061 346, 061 347, 061 348, 061 349, 061 350, 061 351, 061 352, 061 353, 061 354, 061 355, 061 356, 061 357, 061 358, 061 359, 061 360, 061 361, 061 362, 061 363, 061 364, 061 365, 061 366, 061 367, 061 368, 061 369, 061 370, 061 371, 061 372, 061 373, 061 374, 061 375	Machine fault codes	Power Off/On the machine. If error persists, contact the Customer Support Center.
061 382, 061 383, 061 384, 061 385, 061 386, 061 387	Read/Write failure	Power Off/On the machine. If error persists, contact the Customer Support Center.
061 388, 061 389, 061 390, 061 391, 061 392, 061 393	Power failure	Power Off/On the machine. If error persists, contact the Customer Support Center.
061 602, 061 603, 061 604, 061 605, 061 606, 061 607	Drum Signal Error	Power Off/On the machine. If error persists, contact the Customer Support Center.
061 608, 061 609, 061 610, 061 611, 061 612, 061 613	Random Optical Scan signal error	Power Off/On the machine. If error persists, contact the Customer Support Center.
071 101	Feed Out sensor issue in Tray 1	Remove jammed paper in Tray 1. Power Off/On the machine. If error persists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
071 210, 071 211, 071 212, 071 213, 071 214, 071 215, 071 216, 071 217, 071 218, 071 219, 071 221, 071 222, 072 210, 072 211, 072 212, 072 213, 072 214, 072 215, 072 216, 072 217, 072 218, 072 219, 072 221, 072 222,	Tray 1 or Tray 2 malfunctioned	Check paper loaded in Tray 1 or Tray 2. Power Off/On the machine. If error persists, contact the Customer Support Center. Note Trays other than Tray 1 or Tray 2 can be used, depending on which tray (Tray 1 or Tray 2) is effected.
071 401	Fault for the Feed/Retard/Nudger Roll in Tray 1	If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
071 901	Paper jam in Tray 1	Remove jammed paper in Tray 1. Power Off/On the machine. If error persists, contact the Customer Support Center.
071 940	Empty or Near Empty paper levels for Tray 1	Ensure that the paper is loaded properly into Tray 1. Power Off/On the machine. If error persists, contact the Customer Support Center.
071 941	Incorrect paper position during print job. This may have occurred due to paper being loaded incorrectly into Tray 1.	Verify the correct paper orientation of the print job and the desired paper tray selection. If error persists, contact the Customer Support Center.
071 942	Tray 1 fault when printing from Tray 1.	Verify the correct paper orientation of the print job and the desired paper tray selection. Power Off/On the machine. If error persists, contact the Customer Support Center.

Problem solving
(continued)

Fault code	Possible cause	Recommended solution
071 943 072 943	Trays 1 or 2 are offline. This may result in no paper being available in Tray 1 or Tray 2, and switching to another tray was not possible.	Verify that the paper was properly loaded into Tray 1 or Tray 2. Power Off/On the machine. If error persists, contact the Customer Support Center.
071 944 071 945 072 944	Print Server set to pull paper from Tray 1 or Tray 2 but that Tray 1 or Tray 2 is not physically set	Verify that the paper was properly loaded into Tray 1 or Tray 2. Power Off/On the machine. If error persists, contact the Customer Support Center.
072 101	Tray 2 sensor fault	Remove jammed paper. Power Off/On the machine. If error persists, contact the Customer Support Center.
072 901	Fault for the Feed/Retard/Nudger Roll in Tray 2.	Power Off/On the machine. If error persists, contact the Customer Support Center.
072 940 072 942	Empty or Near Empty paper levels for Tray 2, and tray was not able to switch to another paper tray.	Ensure that the paper is loaded into Tray 2 properly. Power Off/On the machine. If error persists, contact the Customer Support Center.
072 941	Incorrect paper position during print job, paper sheets were loaded in the wrong position.	Verify the correct paper orientation of the print job and the desired paper tray selection. Power Off/On the machine. If error persists, contact the Customer Support Center.
073 900 073 901	Paper jam in the Duplex sensor	Remove jammed paper. Power Off/On the machine. If error persists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
077 100, 077 101, 077 102, 077 103, 077 104, 077 105, 077 106, 077 107, 077 108, 077 109, 077 111, 077 112, 077 113, 077 114, 077 115, 077 116, 077 117, 077 118, 077 119, 077 121, 077 122, 077 123, 077 124, 077 125, 077 126, 077 127, 077 128, 077 129, 077 130, 077 131, 077 132, 077 134, 077 135, 077 136, 077 137, 077 138, 077 139, 077 140, 077 900, 077 900, 077 901, 077 902, 077 903, 077 904, 077 905, 077 906, 077 907, 077 908, 077 909, 077 910, 077 911, 077 912, 077 913, 077 914, 077 915, 077 916, 077 917, 077 918, 077 919, 077 920, 077 921, 077 922, 077 923, 077 924, 077 925, 077 926, 077 928, 077 929, 077 930, 077 931, 077 932, 077 933, 077 934, 077 935, 077 937, 077 938, 077 939	Paper jam fault codes	Check for any obstructions in the paper path by removing jammed papers. Power Off/On the machine. If error persists, contact the Customer Support Center.
077 213 077 214	Jam at the Feed Out sensor did not turn on	Power Off/On the machine.
077 300 077 301 077 302	Transport Chute open in the paper tray area	Power Off/On the machine. If error persists, contact the Customer Support Center.
077 303 077 304	The Front left and right doors are open on either the print engine left side or print engine right side.	Close the Doors. Power Off/On the machine. If error persists, contact the Customer Support Center.
077 305	The Exit Drawer is open	Visually inspect the Exit Door. Open, then close the door. Power Off/On the machine. If error persists, contact the Customer Support Center.

Problem solving
(continued)

Fault code	Possible cause	Recommended solution
077 306	Unable to detect the Paper Path Drawer in the print engine left side.	Visually inspect the Paper Path Module. Open and close the Paper Path Module while inspecting for any obvious causes of failure. Power Off/On the machine. If error persists, contact the Customer Support Center.
077 307	Service Interlock is open	Close the Service Interlock. Power Off/On the machine. If error persists, contact the Customer Support Center.
077 310	Side Shift Motor error	Power Off/On the machine. If error persists, contact the Customer Support Center.
077 320, 077 321, 077 322, 077 323, 077 324	Machine mechanical faults	Power Off/On the machine. If error persists, contact the Customer Support Center.
077 331, 077 332, 077 333, 077 334, 077 335, 077 336 077 337, 077 338, 077 339, 077 340, 077 341, 077 342, 077 343, 077 344, 077 345, 077 346, 077 347, 077 348, 077 349, 077 350, 077 351, 077 352, 077 353, 077 354, 077 355, 077 355, 077 356	Path Sensor fault	Power Off/On the machine. If error persists, contact the Customer Support Center.
077 400	A Job is started during the Air Assist Warm Up	Verify that the Air Assist is ready. Power Off/On the machine. If error persists, contact the Customer Support Center.
077 401	V-Tra Brush Life limit fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
077 600	Outside temperature exceeded the specified range	Power Off/On the machine. If error persists, contact the Customer Support Center.
077 601	Lead Registration out of the desired range	Check for any obstructions in the paper path. Power Off/On the machine. If error persists, contact the Customer Support Center.
077 602	Outside humidity exceeded the specified range of the machine	Power Off/On the machine. If error persists, contact the Customer Support Center.
077 603, 077 604, 077 605, 077 606, 077 607, 077 608, 077 609, 077 610, 077 611, 077 612, 077 613, 077 614, 077 615, 077 616, 077 617	Contact Image Sensor fault	Power Off/On the machine. If error persists, contact the Customer Support Center.
077 618, 077 619, 077 620, 077 621	Aligner Nip/Release fault	Remove jammed paper. Power Off/On the machine. If error persists, contact the Customer Support Center.
077 622	Unit Skew Motor error	Remove jammed paper. Power Off/On the machine. If error persists, contact the Customer Support Center.
077 941 077 942	Size of the paper discrepancy	Remove jammed paper. Cancel job. Power Off/On. Check paper stock in tray and ensure that stock matches the Tray Properties on the machine UI.
089 310, 089 311, 089 312, 089 313, 089 314, 089 315	Image Registration Control Technology setting value error	Power Off/On the machine.
089 600, 089 601, 089 602	Sensor failure or E Patch was not created correctly	Power Off/On the machine. If error persists, contact the Customer Support Center.

Problem solving
(continued)

Fault code	Possible cause	Recommended solution
089 603, 089 604, 089 605, 089 606, 089 607, 089 608, 089 609, 089 610, 089 611, 089 612, 089 613, 089 614, 089 615, 089 616, 089 617, 089 618, 089 619, 089 620, 089 621, 089 622, 089 623, 089 624, 089 625, 089 626, 089 627, 089 628, 089 629, 089 630, 089 631, 089 632, 089 633	Color registration fault codes	Power Off/On the machine.
089 920 089 921	Dry ink/toner waste bottle is not set correctly	Reset the Dry ink/toner waste bottle in the correct position. Power Off/On the machine.
089 922 089 923	Dry ink/toner waste bottle is full	Empty Dry ink/toner waste bottle. Power Off/On the machine.
089 925, 089 926, 089 927, 089 928, 089 929	Communication faults with the Drum Customer Replaceable Unit Memory	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). Important Drum cartridges can be replaced ONLY by a trained, qualified Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
091 310, 091 311, 091 312, 091 313, 091 314, 091 315	High Voltage Power Supply Charge Corotron cleaner error	Power Off/On the machine. If error persists, contact the Customer Support Center.
091 316	Customer Replaceable Unit Memory communication error	Power Off/On the machine. If error persists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
091 317, 091 318, 091 319, 091 320, 091 321, 091 322, 091 323	Charge Corotron Cleaner Motor error	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). Important The charge corotrons can only be replaced by a trained, qualified Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
091 400, 091 401, 091 402, 091 403, 091 404, 091 405, 091 406, 091 407, 091 408, 091 409, 091 410, 091 411 091 412, 091 413, 091 414, 091 415, 091 416, 091 417	Charge Corotron fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). Important The charge corotrons can only be replaced by a trained, qualified Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
091 418, 091 419, 091 420, 091 421, 091 422, 091 423, 091 424, 091 425, 091 426, 091 427, 091 428, 091 429 091 430, 091 431, 091 431 091 433, 091 434, 091 435	Drum Cartridge fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). Important Drum cartridges can be replaced ONLY by a trained, qualified Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
091 436, 091 437	Dry ink/toner waste bottle near full	Replace Dry ink/toner waste bottle.

Problem solving
(continued)

Fault code	Possible cause	Recommended solution
091 910, 091 911, 091 912, 091 913, 091 914, 091 915	Charge Corotron is not set correctly	Reset Charge Corotron in the correct position. Important This can be performed ONLY be a trained, qualified Technical Key Operator (TKO). Power Off/On the machine. If error persists, contact the Customer Support Center.
091 916, 091 917, 091 918, 091 919, 091 920, 091 921	Drum Customer Replicable Unit Memory is not set correctly	Reset the Drum CRUM in the correct position. Important This can be performed ONLY be a trained, qualified Technical Key Operator (TKO). Power Off/On the machine. If error persists, contact the Customer Support Center.
091 922, 091 923, 091 924, 091 925, 091 926, 091 927	Charge Corotron wire error	Power Off/On the machine. If error persists, contact the Customer Support Center.
091 928, 091 929, 091 930, 091 931, 091 932, 091 933	A Charge Corotron has reached its end of life	Power Off/On the machine. If error persists, contact the Customer Support Center.
091 934, 091 935, 091 936, 091 937, 091 938, 091 939	Drum Cartridge fault	Power Off/On the machine. If error persists, contact the Customer Support Center.
092 310, 092 311, 092 312, 092 313, 092 314, 092 315	Drum charge voltage is not meeting the required specifications	Power Off/On the machine. If error persists, contact the Customer Support Center.
092 350, 092 351, 092 352, 092 353, 092 354, 092 355	Slot Motor failed	Power Off/On the machine. If error persists, contact the Customer Support Center.
092 356, 092 357, 092 358, 092 359, 092 360, 092 361	There is a problem with the Imaging System.	Power Off/On the machine. If error persists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
092 606, 092 607, 092 608, 092 609, 092 610, 092 611, 092 612, 092 613, 092 614, 092 615, 092 616, 092 617, 092 618, 092 619, 092 620, 092 621, 092 622, 092 623	Mini-Automatic Density Control fault codes	Power Off/On the machine. If error persists, contact the Customer Support Center.
092 624, 092 625, 092 626, 092 627, 092 628, 092 629, 092 630, 092 631, 092 632, 092 633, 092 634, 091 635, 092 636, 092 637, 092 638, 092 639, 092 640, 092 641	Density patch variances	Power Off/On the machine. If error persists, contact the Customer Support Center.
092 642 092 643 092 644 092 945	Automatic Density Control Sensor faults.	Power Off/On the machine. If error persists, contact the Customer Support Center.
092 646 092 647	Temperature sensor failure	Power Off/On the machine. If error persists, contact the Customer Support Center.
092 648 092 649	Humidity sensor failure	Power Off/On the machine. If error persists, contact the Customer Support Center.
092 650, 092 651, 092 652, 092 653, 092 654, 092 655, 092 656, 092 657, 092 658, 092 659, 092 660, 092 661	Automatic Dry ink/Toner Control output error	Power Off/On the machine. If error persists, contact the Customer Support Center.
092 662, 092 663, 092 664, 092 665, 092 666, 092 667, 092 668, 092 669, 092 670, 092 671, 092 672, 092 673, 092 674, 092 675, 092 676, 092 677, 092 678, 092 679, 092 680, 092 681, 092 682, 092 683, 092 684, 092 685	Electro Static Voltage value faults.	Power Off/On the machine. If error persists, contact the Customer Support Center.
092 920, 092 921, 092 922, 092 923, 092 924, 092 925, 092 926, 092 927, 092 928, 092 929, 092 930, 092 931, 092 932, 092 933, 092 934, 092 935, 092 936, 092 937	Drum Customer Replaceable Unit Memory errors	Power Off/On the machine. If error persists, contact the Customer Support Center.

Problem solving
(continued)

Fault code	Possible cause	Recommended solution
092 938	This fault was generated when the software for cleaning the Charge Corotron Cleaner did not function correctly	Power Off/On the machine. If error persists, contact the Customer Support Center.
093 310, 093 911, 093 912, 093 913, 093 914, 093 915, 093 916, 093 917, 093 918, 093 919, 093 920, 093 921	Dispensing errors	Power Off/On the machine. If error persists, contact the Customer Support Center.
093 322	Customer Replaceable Unit Memory communication failure	Power Off/On the machine. If error persists, contact the Customer Support Center.
093 400, 093 401, 093 402, 093 403, 093 404, 093 405 093 406, 093 407, 093 408, 093 409, 093 410, 093 411	Dry ink/toner fault	Replace Dry ink/toner Cartridge.
093 413, 093 414, 093 415, 093 416, 093 417, 093 418	Dispenser Replacement timing fault	Contact the Customer Support Center.
093 910, 093 911, 093 912, 093 913, 093 914, 093 915	Communication failure between the Customer Replaceable Unit Memory and Dry ink/toner Cartridge	Reinsert Dry ink/toner Cartridge. Power Off/On the machine.
093 916, 093 917, 093 918, 093 919, 093 920, 093 921, 093 922, 093 923, 093 924, 093 925, 093 926, 093 927, 093 928, 093 929, 093 930, 093 931, 093 932, 093 933 093 934, 093 935, 093 936, 093 937, 093 938, 093 939	Dry ink/toner cartridge faults	Reinsert Dry ink/toner Cartridge. Power Off/On the machine.
093 940	The machine continued printing while the toner/dry ink door was open	Close the Dispense Door. Power Off/On the machine.
093 941	Unable to detect the Image Belt Transfer Module (IBT)	Close the Door. Power Off/On the machine.
094 310 094 311	Image Belt Transfer (IBT) error	Power Off/On the machine. If error persists, contact the Customer Support Center.
094 312	Second Bias Transfer Belt does not make contact or retract	Power Off/On the machine. If error persists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
094 313	Second Nip Adjustable Motor Cam Home Sensor error	Power Off/On the machine. If error persists, contact the Customer Support Center.
094 314, 094 315, 094 316 094 317	Retract Roll error fault	Power Off/On the machine. If error persists, contact the Customer Support Center.
094 414	Detected a reversible condition with the Image Belt Transfer	Power Off/On the machine. If error persists, contact the Customer Support Center.
094 415, 094 416, 094 417, 094 418, 094 419	Bias Transfer Belt fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
094 420 094 421 094 424	Fault for the Image Belt Transfer (IBT)	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
094 422	Trim Transfer Module fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
094 423	Filter fault	Power Off/On the machine. If the error persists, consult your trained Xerox Productivity Plus (XPP) representative; this person is also known as the Technical Key Operator (TKO). If error persists, contact the Customer Support Center.
094 600, 094 601, 094 602, 094 603, 094 604, 094 605	Bias Transfer Roll faults	Power Off/On the machine. If error persists, contact the Customer Support Center.

Problem solving
(continued)

Fault code	Possible cause	Recommended solution
094 606	Environment Temperature measurement error	Power Off/On the machine. If error persists, contact the Customer Support Center.
094 607	Environment Humidity measurement error	Power Off/On the machine. If error persists, contact the Customer Support Center.
094 910 094 911	Engine Existence Switch Mismatch fault	Power Off/On the machine. If error persists, contact the Customer Support Center.
094 930, 094 931, 094 932, 094 933, 094 934, 094 935	Detected "Out of Dry ink/toner"	Replace empty Dry ink/toner Cartridge. Power Off/On the machine.
094 936	Toner/dry ink door is open	Close the Dispense Cover.
102 313	Communication problem	Power Off/On the machine. If error persists, contact the Customer Support Center.
102 316	Detected the User Interface power was turned Off	Power Off/On the machine.
121 310 121 311	Communication failure	Power Off/On the machine. If error persists, contact the Customer Support Center.
121 333, 121 334, 121 335, 121 336	EPSV fault	Power Off/On the machine. If error persists, contact the Customer Support Center.
124 310	RAM failure	Power Off/On the machine. If error persists, contact the Customer Support Center.
124 311	An error in the Non-Volatile Memory area	Power Off/On the machine. If error persists, contact the Customer Support Center.
124 312	System Logic error	Power Off/On the machine. If error persists, contact the Customer Support Center.
124 313 124 314	There is a problem with a USB flash drive that is installed in a USB port on the PC UI.	Power Off/On the machine. If error persists, contact the Customer Support Center.
124 315	Inconsistency with the Billing Counter	Power Off/On the machine. If error persists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
124 316	Inconsistency with the Serial Number	Power Off/On the machine. If error persists, contact the Customer Support Center.
124 318 124 319	The Interface Module software/hardware is incompatible.	Power Off/On the machine. If error persists, contact the Customer Support Center.
124 320	Communication failure between the machine and the Print Server	Power Off/On the machine. If error persists, contact the Customer Support Center.
124 321 124 322 124 323	Information inconsistencies with the Customer Replaceable Unit Memory	Power Off/On the machine. If error persists, contact the Customer Support Center.
124 324 124 325 124 326	Information inconsistencies between the machine Printed Wiring Board and the Customer Replaceable Unit Memory	Power Off/On the machine. If error persists, contact the Customer Support Center.
124 327 124 328 124 329	Problem with a Drum module	Power Off/On the machine. If error persists, contact the Customer Support Center.
124 330 124 331 124 332	Customer Replaceable Unit Memory failure with the System Printing Wiring Board	Power Off/On the machine. If error persists, contact the Customer Support Center.

Related Topics:[Jam clearance](#)[Paper jams in Trays 1 and 2](#)[Paper jams in area 2](#)[Paper jams in areas 3 and 4](#)[Paper jams in area 5](#)[Paper jams in area 6](#)[Paper jams in area 7](#)

Image quality

This section contains a problem-solving table to help you locate and resolve an image quality problem. Locate the defect in the Problem column and perform the task in the Suggested solutions column. If the problem persists after following all the instructions, contact the Customer Support Center.

Problem	Suggested solutions
White and dark spots or blotches on printed output (especially after printing jobs with low dry ink/toner area coverage)	This may be caused by too much dry ink/toner being applied to the drum; perform the Dry ink/toner cleaning procedure. Refer to the System Administration Guide for information and instructions on performing this procedure.
Color lines, Streaks, Spots, Smears, or Bands.	Before performing any of these steps, always check the status of the CRU's/Supplies by pressing Maintenance button on the PC UI. • If lines or streaks are present, check the Image Belt Transfer (IBT) Cleaner Assembly for wear or damage, and replace as required. • If the defect occurs every 36 mm on the prints, do not replace the drum. This interval is caused by a damaged or defective Developer Housing. • If lines, streaks or deletions in the process direction appear only with Black, then replace the Black Corotron Assembly. Important The charge corotrons can only be replaced by a trained, qualified Technical Key Operator (TKO). • If spots or bands occur every 126 mm on the prints, the Yellow, Magenta, or Cyan Drum is damaged or light-shocked. Important Drum cartridges can be replaced ONLY by a trained, qualified Technical Key Operator (TKO).

(continued)

Problem	Suggested solutions
Output contains color lines, streaks, spots, stripes (either dotted or continuous), and/or has scratches or undefined edges.	- Run jobs with individual colors (yellow, magenta, cyan) in order to determine which color drum may be damaged or light-shocked. - Replace the appropriate color drum cartridge. Important Drum cartridges can be replaced ONLY by a trained, qualified Technical Key Operator (TKO). - If spots or bands occur every 188 mm, the Black Drum is damaged or light-shocked. Replace the Black Drum Cartridge. Important Drum cartridges can be replaced ONLY by a trained, qualified Technical Key Operator (TKO). - Ensure that the paper tray guides are against the edges of the loaded paper.
Low gloss bands appear on printed output	Running all weights at rated speeds may result in a Cross Process Low Gloss Band. On the heavy-weight stocks, this gloss band defect starts approximately five inches (127 mm) from the lead edge and is approximately three inches (76 mm) wide. On light-weight stocks, the defect starts approximately six inches (152 mm) from the lead edge and is approximately two inches (50 mm) wide. Note If this defect occurs, return the Productivity Setting to the Single Paper Weight setting. If the defect still occurs after running another print, call your Xerox service representative for further assistance.
Output is completely black or gray over the entire paper	Before calling the Welcome and Support Center, write down your machine's serial number.
White lines, Streaks, Spots, Bands or Deletions	Ensure that the paper loaded is within machine specifications. Go to the Paper and Media section for information for information on paper specifications and storage.
Output contains white stripes either dotted or continuous, has scratches or areas of white where the original was a dark image	Load a new ream of paper into the selected paper tray.
Black Lines, Streaks, Spots, Smears or Bands	Before performing any of the following steps, always check the status of the CRUs/Supplies by pressing the Maintenance button on the PC UI.
Output has a black border at the edge, only some of the image is visible	Ensure that the paper size and type is correctly set for the selected paper tray.

Problem solving
(continued)

Problem	Suggested solutions
Output is too light or washed out, solid areas not black or inconsistent shading	If there is a message about low dry ink/toner on the screen, replace the dry ink/toner cartridge.
Image is Skewed or Crooked	Ensure that the paper tray guides are against the edges of the loaded paper.
Output is not straight but slanted at an angle	• Ensure that the paper loaded is within the machine specifications. Go to the Paper information section for information on paper and storage. Refer to the Technical data section for paper specific information. • Load a new ream of paper into the selected paper tray. • Open the front door and check that there are no obstacles in the paper path.
Unfused Dry ink/toner rubs off	Ensure that the paper loaded is within machine specifications. Go to the Paper information section for information on paper and storage. Refer to the Technical data section for paper specific information.
Ink on the output is not permanent and smears, smudges, and rubs off	Load a new ream of paper into the selected paper tray.
Misregistration or Image Shift	Ensure that the paper tray guides are against the edges of the loaded paper.
Trail edge of output contains dry ink/toner deletions, density inconsistency, or is lacking in color depth; this occurs mainly when using heavier or lighter weight stock	While in the Administrator mode: • Create a custom stock and add to the Stock Library • Make adjustments to the 2nd Bias Transfer setting in Advanced Stock and run the job again • If necessary, continue to adjust the 2nd Bias Transfer setting until the desired output is achieved • If output is still unacceptable, contact the Customer Support Center

Charge corotrons

Important

The charge corotrons can only be replaced by a trained, qualified Technical Key Operator (TKO).

When to replace a charge corotron assembly

Unlike other consumable products for the machine, 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” appears on the 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 assembly 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 **CorotronTest.pdf** from the customer documentation CD/DVD. 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 three-color bar. The three-color bar (CMY) is there to help you identify which color is showing banding.



1. Black banding
2. Cyan banding
3. Magenta banding
4. Yellow banding

Technical data

Machine specifications

Tray capacity

Paper trays 1 and 2 are identical and each tray has a capacity of holding 2,000 sheets. The trays accommodate the following:

- Paper weights between 15 lb. Bond to 130 lb. Cover (55 gsm to 350 gsm)
- Paper sizes starting at 7.2 x 7.2 in. (182 x 182 mm) to a maximum of 13 x 19.2 in. (330 x 488 mm)
- If using the optional Postcard bracket, minimum size is 101.64 x 152.4 mm (4 x 6 inches)

Note

For more information on the optional Postcard bracket, refer to the Oversized High Capacity (OHCF) section of this guide and the Customer Support Center.

- All stock types including transparencies, labels, letterhead, coated and uncoated, drilled, and carbonless
- Long Edge Feed (LEF)/portrait or Short Edge Feed (SEF)/landscape loading of paper (dependent on the actual paper size)

The trays also:

- Have auto size detection capability; the loaded paper size, weight, type, and orientation is displayed on the UI screen once the tray is closed.
- Automatically adjust the tray position in the front and back based on the paper size; this is done once the tray is closed.

Note

For tray capacity information on the optional Oversized High Capacity Feeder (OHCF), refer to the appropriate section later in this guide.

Throughput information for all paper trays

- Type: Coated or uncoated paper, transparencies, labels, transfer paper, tabbed inserts, drilled (LEF), carbonless paper

Technical data

- Sizes: Minimum = 182 x 182 mm (7.2 x 7.2 inches)

Note

If the optional Postcard bracket is used, the minimum size is 101.64 x 152.4 mm (4 x 6 inches). For more information on the optional Postcard bracket, refer to the Oversized High Capacity (OHCF) section of this guide.

- Maximum = 330.2 x 488 mm (13 x 19.2 inches)
- Weights: 15 lb. Bond - 130 lb. Cover (55-350 gsm) coated/uncoated

Machine warmup time

The machine warmup times vary depending on the current state/mode of the machine. Machine warmup times are listed as follows:

- From a cold start (either power on or power saver mode), less than 5 minutes
- From Sleep Mode/Power Saver, less than 5 minutes
- From standby, less than 1 minute
- When switching print modes (such as from black-only to 4-color), approximately 2 minutes

First print-out time

From standby mode, system usually takes less than 1 minute to the start printing

- From a cold start (power on or power saver), system takes less than 5 minutes to start printing

Paper specifications

Note

Always refer to the Recommended Media List (RML) for a comprehensive list of recommended media. The RML can be access from the Manage Stock Library and can also be downloaded from www.xerox.com.

Paper Type	Paper Size	Dimensions (mm) SEF x LEF	Weight (gsm)	Coating Type
Plain paper	B5 SEF/LEF	182.0 x 257.0	55 to 80	Uncoated
Embossed	A4 SEF/LEF	210.0 x 297.0	81 to 105	Coated
Postcard	A4-Cover SEF/LEF	223.0 x 297.0	106 to 135	
Drilled	DT Special A4 SEF/LEF	226.0 x 310.0	136 to 150	
	B4 SEF	257.0 x 64.0	151 to 186	
	A3 SEF	297.0 x 420.0	187 to 220	
	SRA3 SEF	320.0 x 450.0	221 to 256	
	DT Special A3 SEF	310.0 x 432.0	257 to 300	
	4 x 6 in. SEF	101.6 x 152.4	301 to 350	
	7.25 x 10.5 in. SEF/LEF	184.2 x 266.7		
	8 x 10 in. SEF/LEF	203.2 x 254.0		
	8.46 x 12.4 in. SEF	215.0 x 315.0		
	8.5 x 11 in. SEF/LEF	215.9 x 279.4		
	8.5 x 13 in. SEF/LEF	215.9 x 330.2		
	8.5 x 14 in. SEF	215.9 x 355.6		
	9 x 11 in. SEF/LEF	228.6 x 279.4		
	11 x 15 in. SEF	279.4 x 381.0		
	11 x 17 in. SEF	279.4 x 431.8		
	12 x 18 in. SEF	304.8 x 457.2		
	12.6 x 19.2 in. SEF	320.0 x 488.0		
	13 x 18 in. SEF	330.2 x 457.2		
	16-kai (TFX) SEF/LEF	194.0 x 267.0		
	16-kai (GCO) SEF/LEF	195.0 x 270.0		
	Pa-kai (TFX) SEF	267.0 x 388.0		
	pa-kai (GCO) SEF	270.0 x 390.0		
Executive LEF	10.5 x 7.25 in. LEF	184.2 x 266.7	---	---
Quatro LEF	8 x 10 in.	203.2 x 254.0	---	---
Government-Legal SEF/LEF	8.5 x 13 in.	215.9 x 330.2	---	---
DT Special A4 SEF/LEF	8.90 12.20 in.	226.0 x 310.0	---	---
DT Special A3 SEF	12.20 x 17.00 in.	310.0 x 432.0	---	---

Technical data
(continued)

Paper Type	Paper Size	Dimensions (mm) SEF x LEF	Weight (gsm)	Coating Type
SRA3 SEF	12.60 x 17.72 in.	320.0 x 450.0	---	---
Transparency	8.5 x 11 in./A4 LEF	215.9 x 279.4	---	---
Labels	8.5 x 11 in./A4 LEF	215.9 x 279.4	190	Gloss Matte
Tabbed Inserts	8.5 x 11 in./A4 LEF	215.9 x 279.4	163	Uncoated

Environmental specifications

The machine enters the Power Saver mode after 15 minutes of inactivity on the machine. The factory default time of 15 minutes can be changed when logged on as the Administrator. For more information, refer to the System Administration Guide.

Ambient temperature and humidity

10 to 32o C, 15 to 85 % Relative Humidity (RH) J zone (Dew condensation is inhibited)

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Offset Catch Tray (OCT)

The OCT receives the completed print job. Output print sets are offset for easy separation. The maximum capacity of the OCT is 500 sheets of 24 lb. (90 gsm) paper.



Enabling the Offset Mode on the EX Print Server

Note

This information applies only to users who have the EX Print Server connected to the print engine.

When printing jobs, if a message displays indicating that the OCT is not offsetting, check the EX Print Server to ensure that the Offset Mode is enabled. Use the following procedure to enable the Offset Mode:

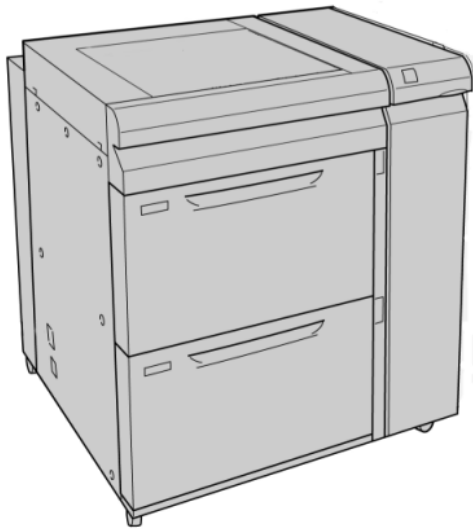
1. If necessary, cancel the job from printing.
2. Select the desired job.
3. Open the job Properties.
4. Select the Finishing tab.
5. Ensure that Offset Catch Tray is selected for the Output Tray.
6. Select the Offset Mode (shown with a check mark in the box).
7. Select OK to save and close the Properties window.
8. Resend the print job.

13

Oversized High Capacity Feeder (OHCF)

Overview

The optional 2-drawer Oversized High Capacity Feeder (OHCF) provides feeds in a variety of stock sizes, including standard sizes and oversized stock up to 13 x 19.2 in./330.2 x 488 mm paper. Each drawer holds 2000 sheets.



Note

The OHCF comes equipped from manufacturing with the Postcard bracket.

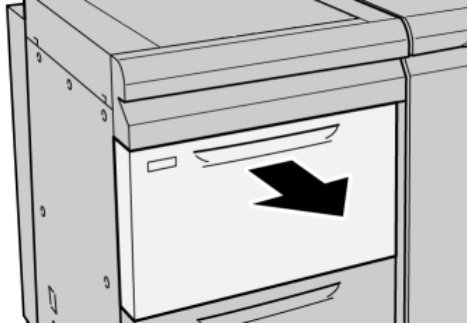
Postcard bracket

The Postcard bracket is delivered with the OHCF from manufacturing. The Postcard bracket allows you to print on smaller size media without requiring post-processing cutting or sorting. The Postcard bracket specifically accommodates 4 x 6 in. (101.6 x 152.4 mm) SEF media.

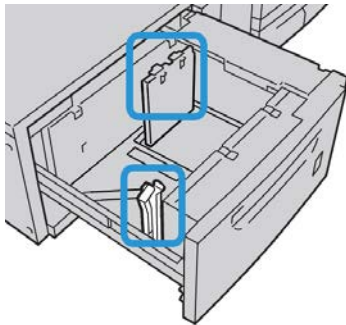
Using the Postcard bracket

Use the following procedure for installing and using the Postcard bracket when printing on smaller media (4 x 6 in./101.6 x 152.4 mm).

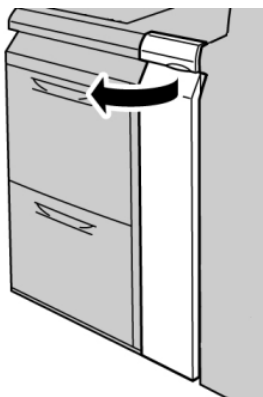
1. Slowly open one of the paper trays until it stops and remove the paper.



2. Move the paper guides out to their largest position.



3. Open the front cover of the OHCF.

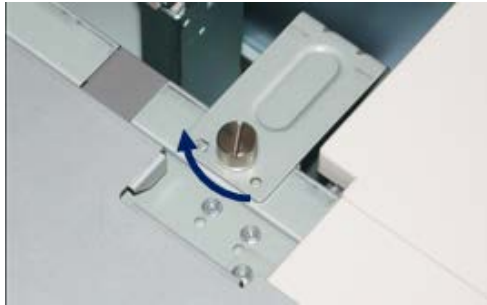


4. Remove the Postcard bracket from inside the OHCF front cover.

5. Install the Postcard bracket so that it sits on the locating pins on the upper frame and in the grooves on the bottom of the tray.



6. Tighten the thumb screw so it locks the Postcard bracket in place.



7. Load the postcard stock and adjust the paper guides against the stock.



8. Close the paper tray and confirm the new settings on the UI.
9. Run your print job.
10. Upon completion of your print job, remove the postcard stock and the Postcard bracket from the tray.
11. Store the Postcard bracket inside the OHCF front cover area.

Loading media in the OHCF

Loading paper in the OHCF

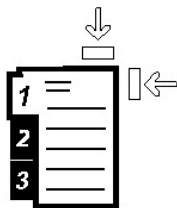
1. Select the appropriate paper stock for your print job.
2. Pull out the tray slowly until it stops.
3. Open the ream of paper with the seam side facing up.
4. Fan the sheets before loading them into the tray.
5. Load paper into the tray.
6. Adjust the paper guides by pressing in the guide release and carefully moving the Edge Guide until it lightly touches the edge of the material in the tray.
Do not load materials above the MAX line located on the rear Edge Guide.
7. If necessary, set the skew adjustment levers to the desired position for your print job.
8. Gently push in the tray until it comes to a stop.
If enabled by your System Administrator, the Paper Tray Properties screen may be displayed on the UI.
9. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.
10. Select **OK** to save the information and close the Tray Properties window.

Loading tabs in the OHCF

Note

If the optional GBC AdvancedPunch is attached to your machine, refer to the GBC AdvancedPunch customer documentation for instructions on loading tab stock in the trays.

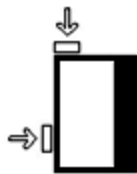
1. Select the appropriate paper stock for your print job.
2. Pull out the tray slowly until it stops.
3. Fan the tab paper before loading into the tray.
4. Load and align the edge of the tab paper against the right edge of the tray in the LEF direction as shown in following illustration:



5. 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.
Do not load materials above the MAX line located on the rear Edge Guide.
6. If necessary, set the skew adjustment levers to the desired position for your print job.
7. Gently push in the tray until it comes to a stop.
If enabled by your System Administrator, the Paper Tray Properties screen may be displayed on the UI.
8. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.
9. Select **OK** to save the information and close the Tray Properties window.

Loading transparencies in the OHCF

1. Select the appropriate paper stock for your print job.
2. Pull out the tray slowly until it stops.
3. Fan the transparencies to stop them from sticking together before loading into the tray.
4. Load transparencies on top of a small stack of same-size paper and align the edge of the transparency against the right edge of the as shown in following illustration:



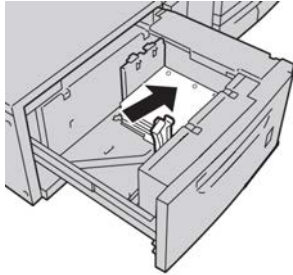
5. Adjust the paper guides by pressing in the guide release and carefully moving the Edge Guide until it lightly touches the edge of the material in the tray.
Do not load materials above the MAX line located on the rear Edge Guide.
6. If necessary, set the skew adjustment levers to the desired position for your print job.
7. Gently push in the tray until it comes to a stop.
If enabled by your System Administrator, the Paper Tray Properties screen may be displayed on the UI.
8. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.

Loading pre-drilled stock into the OHCF for 1-sided print jobs

1. Select the appropriate paper stock for your print job.
2. Pull out the tray slowly until it stops.

Oversized High Capacity Feeder (OHCF)

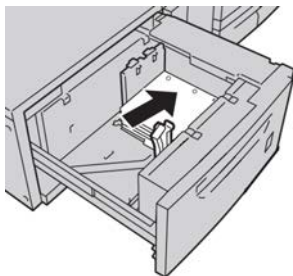
3. Open the ream of paper with the seam side facing up.
4. Fan the sheets before loading them into the tray.
5. Load and register the paper against the right side of the tray as depicted below for LEF direction:



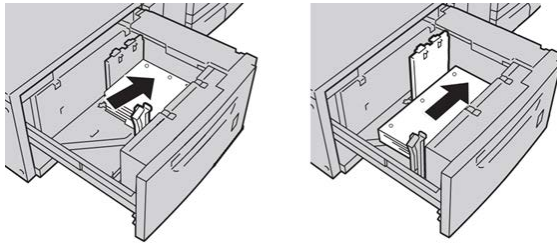
6. Adjust the paper guides by pressing in the guide release and carefully moving the Edge Guide until it lightly touches the edge of the material in the tray.
Do not load materials above the MAX line located on the rear Edge Guide.
7. If necessary, set the skew adjustment levers to the desired position for your print job.
8. Gently push in the tray until it comes to a stop.
If enabled by your System Administrator, the Paper Tray Properties screen may be displayed on the UI.
9. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.
10. Select **OK** to save the information and close the Tray Properties window.

Loading pre-drilled stock into the OHCF for 2-sided print jobs

1. Select the appropriate paper stock for your print job.
2. Pull out the tray slowly until it stops.
3. Open the ream of paper with the seam side facing up.
4. Fan the sheets before loading them into the tray.
5. Load and register the paper against the right side of the tray as depicted below for LEF direction:



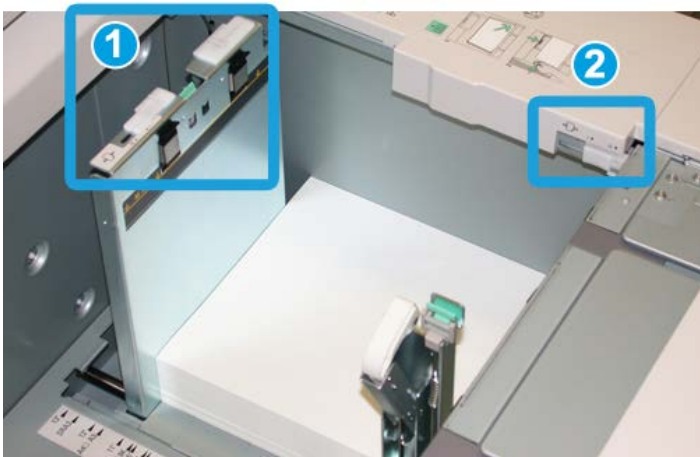
6. Load and register the paper against the right side of the tray as depicted below for SEF direction:



7. 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.
Do not load materials above the MAX line located on the rear Edge Guide.
8. If necessary, set the skew adjustment levers to the desired position for your print job.
9. Gently push in the tray until it comes to a stop.
If enabled by your System Administrator, the Paper Tray Properties screen may be displayed on the UI.
10. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.
11. Select **OK** to save the information and close the Tray Properties window.

Skew adjustment levers

The skew adjustment levers are found in all paper trays. These levers are used to improve paper feed accuracy and to reduce paper skew problems.



1. Rear skew adjustment lever

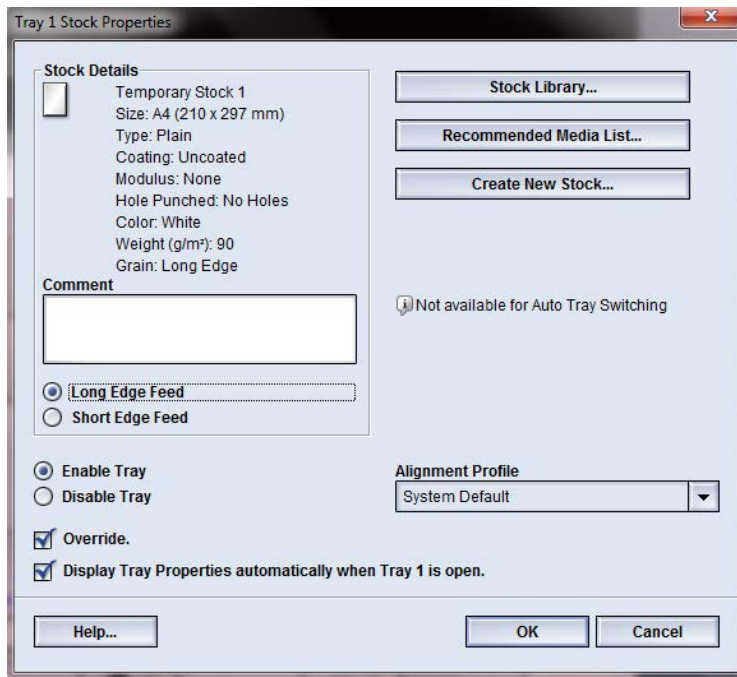
2. Right-side skew adjustment lever

- These levers should remain in their default position. The position of these levers should be changed only when there is a skew problem when running a specific print job and/or specific media type.
- Changing the skew adjustment levers from their default position may cause more skew problems when running certain media types, such as coated, label, transparency, and film.

Use the following procedure to set the skew adjustment levers.

1. Pull out the tray slowly until it stops.
2. Slide the rear skew adjustment lever to the right (as shown in the above picture).
3. Gently push in the tray until it comes to a stop.
4. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.
5. Select **OK** to save the information and close the Tray Properties window.
6. Run your print job.
 - The paper is fed accurately without skew and the printed output is satisfactory; you are finished.
 - The paper is skewed and the printed output is unsatisfactory; proceed to the next step.
7. Pull out the tray slowly until it stops.
8. Return the rear skew adjustment lever to its left, default position.
9. Slide the right-side skew adjustment lever toward the front of the paper tray.
10. Gently push in the tray until it comes to a stop.
11. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, paper curl and/or alignment option.
12. Select **OK** to save the information and close the Tray Properties window.
13. Run your print job.
 - The paper is fed accurately without skew and the printed output is satisfactory; you are finished.
 - The paper is skewed and the printed output is unsatisfactory; proceed to the next step.
14. Pull out the tray slowly until it stops.
15. Return the right-side skew adjustment lever toward the rear of the paper tray; this is its default position.
16. Gently push in the tray until it comes to a stop.
17. If you are still having skew adjustment problems, refer to the Advanced Stock Setup information located in the System Administration Guide.

Tray Properties



From the Tray Properties window the user can view and select a variety of functions on the paper tray. Selections available for the tray vary depending on whether the user is logged in as Operator or Administrator. The following information represents the selections available when logged in as Operator.

- **Stock Details:** This area displays the current tray information including the paper size, type, weight, color, and orientation of the paper (LEF or SEF).
 - **Comment:** This section allows the user to enter information about the paper, such as a brand name or job-specific information. A maximum of 256 characters is allowed.
 - **Long Edge Feed/Short Edge Feed (LEF/SEF):** Indicates the orientation direction that the paper is loaded in the tray: either in the LEF or SEF direction.
- **Enable Tray:** Permits the selected tray to be used.
- **Disable Tray:** Prohibits the selected tray to be used.

- **Override:**
 - When this selection is cleared, the UI displays a message if the current media loaded in the tray does not match the media information displayed on the Tray Properties window. The user must load the tray with the same media as indicated on the Tray Properties window.
 - If selected, the UI never displays a message when there is a media mismatch between the actual tray contents and the information shown on the UI for that tray.
- **Display Tray Properties automatically when Tray is open:** When selected, the Tray Properties window always opens when the tray is open.
- **Stock Library:** This opens the Manage Stock Library window, which contains the names of all the paper stocks that were either created by the user or copied and/or edited from the Recommended Media List (RML). The user selects a desired stock from the list, and that stock is assigned to the tray.
- **Recommended Media List (RML):** Provides a list of all the default, preprogrammed stocks that are available for the machine. The user can select a stock from the RML to assign temporarily to the tray. Once the Tray Properties window is closed, the stock appears name appears in blue/italics indicating that it is a temporary stock. The stock is deleted once a different stock is selected.
- **Create New Stock:** Allows the user to create a new stock that is assigned to the tray. This stock may be saved permanently to the stock library, or it can remain as a temporary stock.
- **Alignment Profile:** Allows the user to select the system default profile or a specific profile that was created and saved from the Administrator mode.

Related Topics:

[Manage Stock Library](#)

[Advanced Stock Setup options](#)

[Recommended Media List \(RML\)](#)

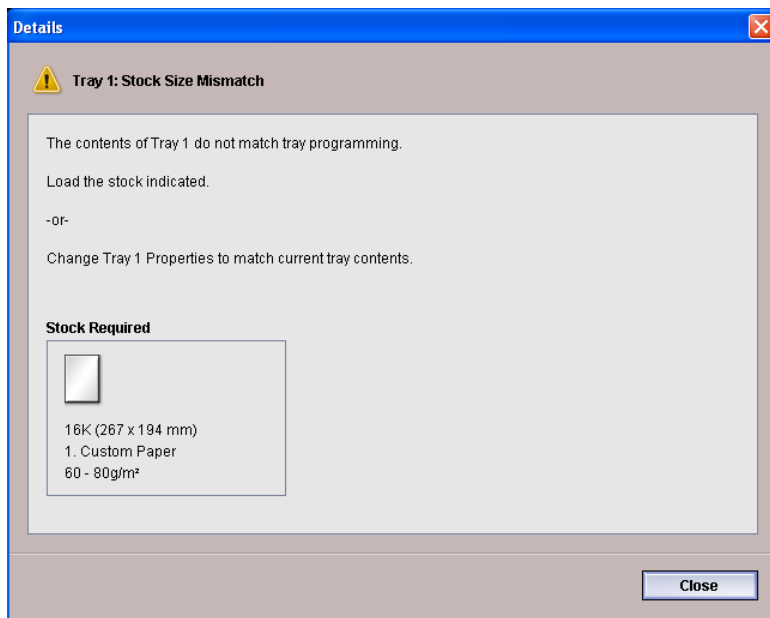
[Creating a new stock \(from Tray Properties\)](#)

Tray stock mismatch

If the paper loaded in a tray does not match the information on the Tray Properties window, the UI may alert you with a Tray Stock Size Mismatch message.

Note

This functionality is available only if it is enabled by the Administrator: refer to the System Administration Guide for more information.



If you receive this message, do the following:

1. Load the stock indicated on the Tray Stock Size Mismatch window, or
2. Change the Tray Properties to match the contents of the tray.
 - a) Verify the paper size, type (coated, uncoated), and weight of the paper loaded in the tray.
 - b) Enter that information on the Tray Properties window.

OHCF problem solving

Clearing OHCF jams

Tip

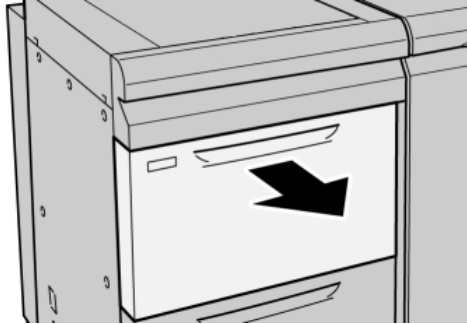
Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

Note

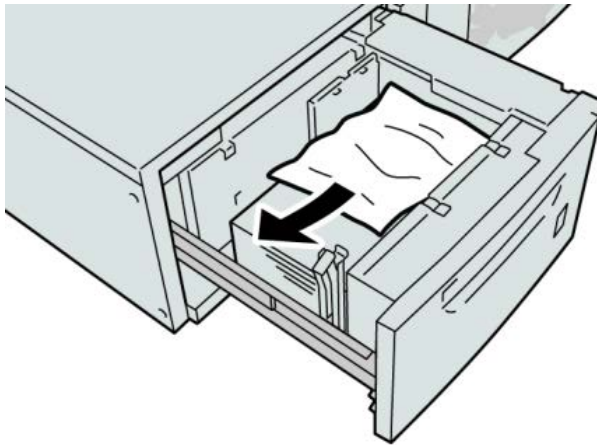
Remedies differ according to the paper jam location. Follow the instructions displayed to remove the jammed paper.

Paper jams inside the OHCF trays

1. Pull out the tray where the paper jam occurred.



2. Remove the jammed paper.



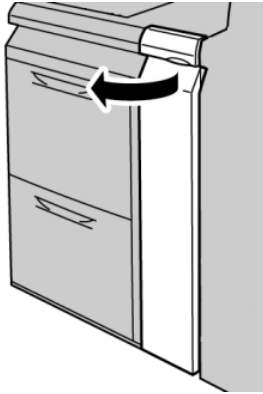
Note

If paper is torn, check inside the machine and remove it.

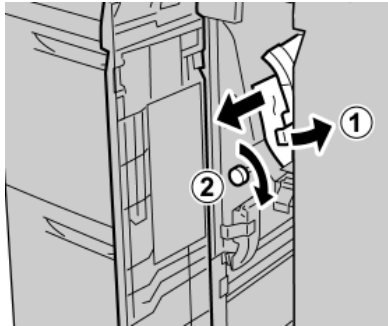
3. Gently push in the tray until it comes to a stop.

OHCF paper jams at lever 1a and knob 1c

1. Open the front cover of the OHCF.



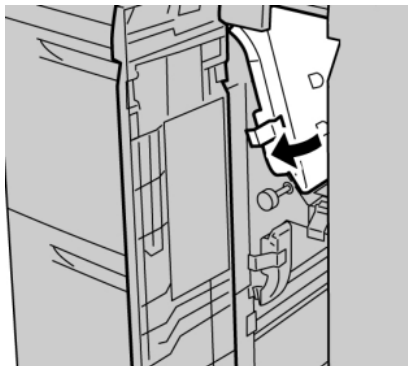
2. Move the lever **1a** to the rightward and turn the knob **1c** to the right. Remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

3. Return the lever 1a to the original position.



Oversized High Capacity Feeder (OHCF)

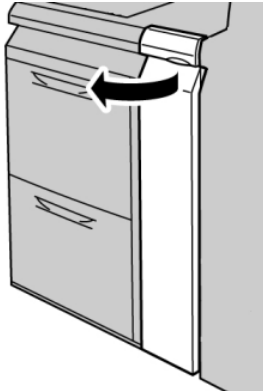
4. Close the front cover of the OHCF.

Note

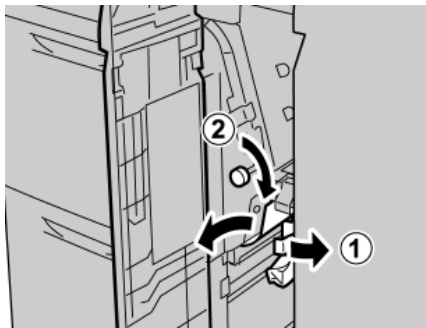
If the front cover of the OHCF is not completely closed, a message will appear and the machine will not operate.

OHCF paper jams at lever 1b and knob 1c

1. Open the front cover of the OHCF.



2. Move the lever **1b** to the rightward and turn the knob **1c** to the right. Remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

3. Return the lever **1b** to the original position.



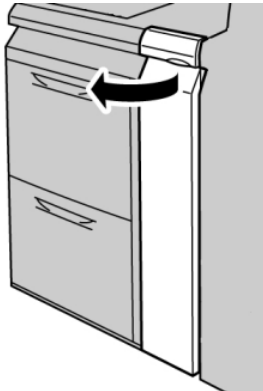
4. Close the front cover of the OHCF.

Note

If the front cover of the OHCF is not completely closed, a message will appear and the machine will not operate.

OHCF paper jams at lever 1d and knob 1c

1. Open the front cover of the OHCF.



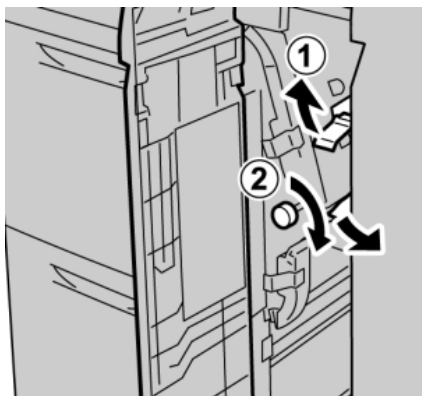
2. Move the lever **1d** upwards and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

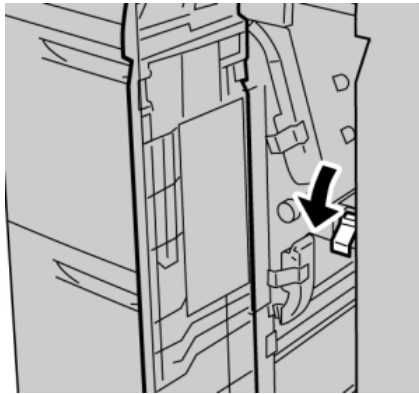
3. If the paper cannot be removed, turn the knob **1c** clockwise, and then remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the lever **1d** to the original position.



5. Close the front cover of the OHCF.

Note

If the front cover of the OHCF is not completely closed, a message will appear and the machine will not operate.

OHCF fault codes

Fault code	Possible cause	Recommended solution
024 955, 024 956	An OHCF tray is empty or out of paper	Add paper to correct OHCF Tray.
077 210	An OHCF tray is broken	1. Power Off/On. 2. If problems persist, contact the Customer Support Center. Trays other than the OHCF trays may be used in the interim.
078 100, 078 101, 078 102	An OHCF tray has malfunctioned	1. Check the paper in the malfunctioning tray. 2. Power Off/On the machine. 3. If the errors persist, contact the Customer Support Center.

Oversized High Capacity Feeder (OHCF)

(continued)

Fault code	Possible cause	Recommended solution
078 210, 078 211	An Optional OHCF tray malfunctioned	1. Check the paper setting of the paper trays and power Off/On the machine. 2. If problems persist, contact the Customer Support Center. Note Trays other than the OHCF trays may be used in the interim.
078 260, 078 261, 078 262, 078 263, 078 264, 078 265, 078 266, 078 267, 078 268, 078 269, 078 270, 078 271, 078 272, 078 273, 078 274, 078 275, 078 276, 078 277, 078 278, 078 279, 078 280	An OHCF tray malfunctioned	1. Check the paper loaded in the trays. 2. Power Off/On the machine. 3. If problems persist, contact the Customer Support Center.
078 300, 078 301, 078 500, 078 901, 078 941, 078 942, 078 943	An OHCF tray has malfunctioned	1. Check the paper in the malfunctioning tray. 2. Power Off/On the machine. 3. If the errors persist, contact the Customer Support Center.

OHCF specifications

Oversized High Capacity Feeder (OHCF/Trays A1-1 and A1-2)

Item	Specification
Sheet size	SEF: 8.5 x 11 in./A4, 8.5 x 13 in., 8.5 x 14 in., 10 x 14 in./B4, 11 x 17 in./A3, 12 x 18 in., 12.6 x 17.7 in./SRA3, 13 x 18 in., 13 x 19 in., 12.6 x 19.2 in., B5, 4 x 6 in./101.6 x 152.4 mm(postcard) LEF: B5, 7.25 x 10.5 in. (executive), A4, 8.5 x 11 in., 8.0 x 10 in. Custom sizes: 182-330 mm (7.2-13 in.) width and 182-488 mm (7.2-19.2 in.) length
Paper weight	18 lb. to 130 lb. cover/55-350 gsm

(continued)

Item	Specification
Paper capacity	2000 sheets/drawer Important: When using up to Xerox 24 lb./90 gsm paper.

Oversized High Capacity Feeder (OHCF)

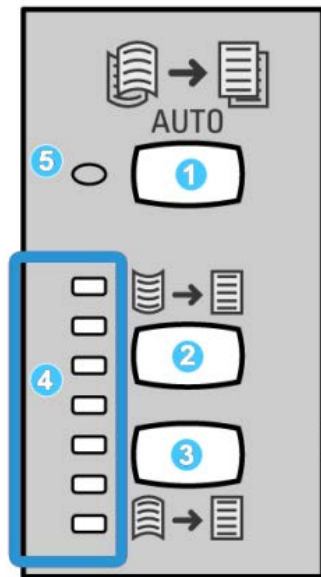
Interface Module

Overview



The Interface Module is an optional finishing device that is used in conjunction with other optional finishing devices. It is shown here with the optional High Capacity Stacker.

Control panel

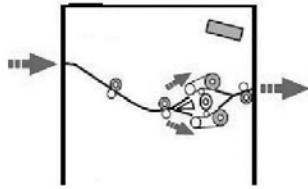


The Control Panel consists of the following:

1. Auto Curl button: This button selects the Auto Decurl function.
2. Manual Curl Up button: This button selects the three values of manual up curl.
3. Manual Curl Down button: This button selects the three values of manual down curl.
4. Curl Up/Down indicators: These indicate the amount of manual curl (up or down) that is selected.
5. Auto Curl indicator: This indicates that the Auto Curl Mode is selected.

If you want to quickly and at the point-of-need adjust the paper curl on the printed output, you may use the Interface Module's Manual Curl Up or Down buttons. If the printed output contains too much curl after using these buttons, refer to the System Administration Guide for information on adjusting the paper curl by using the Paper Curl Correction feature (Advanced Stock Setup). The Interface Module paper curl buttons are discussed in more detail later in this section.

Paper path



As media enters the Interface Module, it is fed to the Interface Module decurler for paper curl correction. The Interface Module decurler has both upper and lower decurler rolls that apply pressure to the media based upon the following:

- System default
- Manual selections made at the Interface Module control panel

Based on the paper curl (decurl) settings, the Interface Module decurler gate routes the paper to either the up-curl (cupped) path, or the down-curl (bridged) path. The degree of pressure is applied independently to the upward and downward decurler arms.

From the Interface Module decurler, the print media is cooled and routed from the Interface Module to the optional finishing device(s) that is/are connected to your machine.

Paper curl settings on the Interface Module

Preset decurler settings

Your Interface Module is designed with several automated presettings for controlling paper curl. When using these settings, the amount of curl correction is automatically set by the Interface Module decurler. Therefore, if paper curl is a problem, use one of the preset Interface Module decurler settings in order to eliminate the problem.

When the media passes through the Interface Module decurler, you are notified of the current amount of curl correction by-way-of the various LEDs on the Interface Module Control Panel. If you require more curl correction, you can manually select curl correction from the Interface Module Control Panel.

Manual decurler buttons

The Interface Module manual decurler mode has seven levels of curl correction that are available at the Interface Module Control Panel: three levels of Up-curl correction and three levels of Down-curl correction, plus a No correction level.

The amount of curl correction is changed by selecting a related button. The current selected amount of curl correction is displayed by the Control Panel LEDs.

Problem solving

Clearing jams

Tip

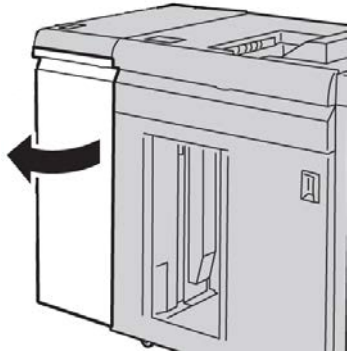
Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

Note

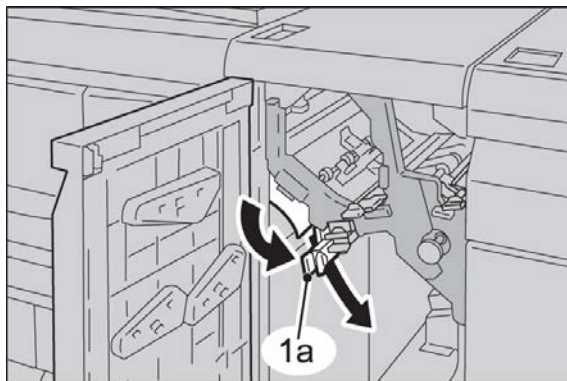
Remedies differ according to the paper jam location. Follow the instructions displayed to remove the jammed paper.

Paper jams at lever 1a

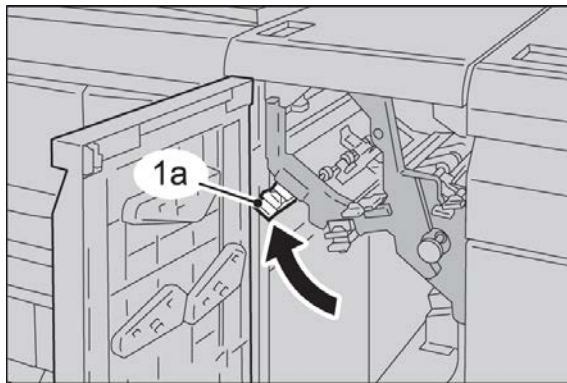
1. Open the front cover of the Interface Module.



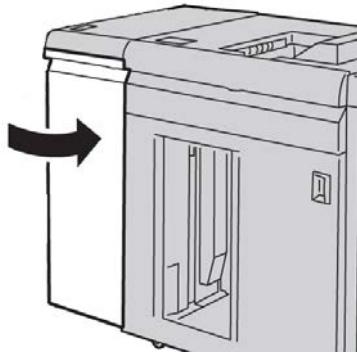
2. Move the lever **1a** downwards and remove the jammed paper.



3. Return the lever **1a** to the original position.



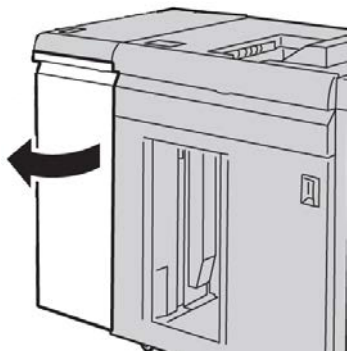
4. Close the front cover of the Interface Module.



5. Follow the instructions on the UI to clear other areas or to resume your print job.

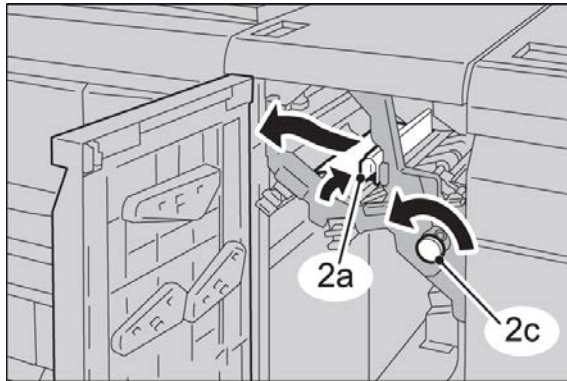
Paper jams at lever 2a

1. Open the front cover of the Interface Module.



Interface Module

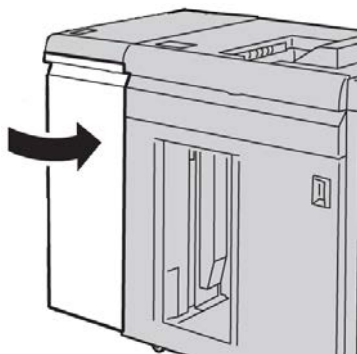
2. Move the lever **2a** upwards, turn the knob **2c** counterclockwise, and remove the jammed paper.



3. Return the lever **2a** to the original position.



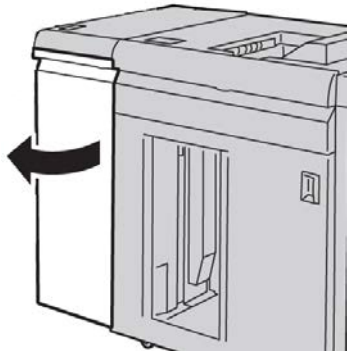
4. Close the front cover of the Interface Module.



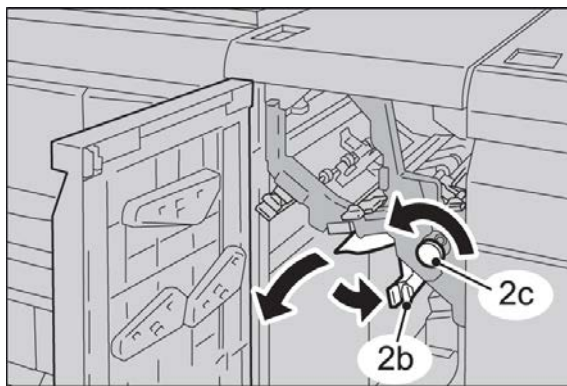
5. Follow the instructions on the UI to clear other areas or to resume your print job.

Paper jams at lever 2b

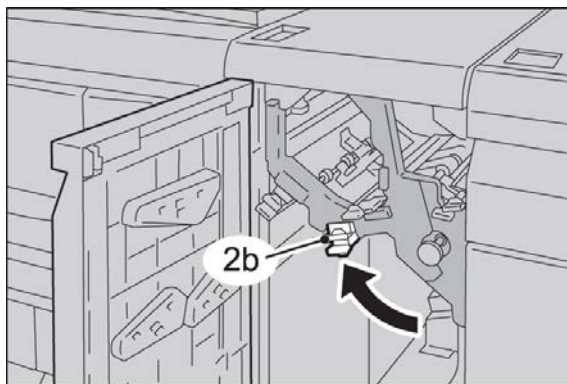
1. Open the front cover of the Interface Module.



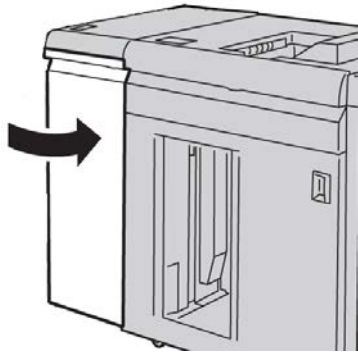
2. Move the lever downwards, turn the knob **2c** counterclockwise, and remove the jammed paper.



3. Return the lever **2b** to the original position.



4. Close the front cover of the Interface Module.



5. Follow the instructions on the UI to clear other areas or to resume your print job.

Fault codes

The fault code table lists problems and suggested solutions that apply to the Interface Module. If the problem persists after following all instructions, call your Xerox Customer Support Center.

Fault code	Possible cause	Recommended solution
048-100 048-101 048-102 048-103 048-900 048-901 048-903	Paper jam: - A jam occurred during feeding. - A jam notification is displayed on the UI.	- Open the front door. - Carefully remove all sheets and paper scraps from the jam clearance areas. - Close the front door. Verify the paper used is within the approved paper specifications.
048-300	The front door is open.	Close the front door.
048-310 048-311 048-312 048-313 048-314 048-315 048-316	Decurler sensor or belt problem	Power off, then power on.
048-317 048-318 048-319	Cooling fan failure	Power off, then power on.

(continued)

Fault code	Possible cause	Recommended solution
048-320 048-321 048-322 048-324 048-325 048-326 048-327	Communication failure or connection failure	• Check the connection between the Interface Module and the connected finishing device or devices. • Fully clear any jams between the Interface Module and the connection finishing device or devices. • Ensure all jam clearance handles/levers are returned to their closed positions. • After clearing all jams, remove any ejected paper from the finishing output area. • Power Off/On the machine.

High Capacity Stacker (HCS)

Overview

The High Capacity Stacker (HCS) is an optional finishing device that provides stacking and offsetting capabilities for output to a Stacker Tray.



Note

The HCS requires the Interface Module. The Interface Module acts as a communication device and paper path between the machine and the HCS.

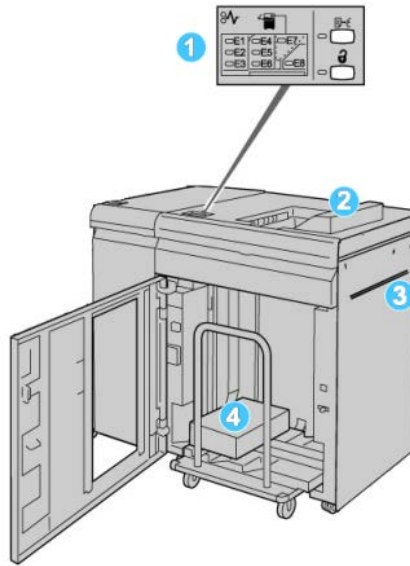
1. Interface Module
2. High Capacity Stacker (HCS)

Note

Your system can accommodate a maximum of two High Capacity Stackers at one time. If your system has two stackers attached, they are referred to as B1 and B2. Also, with two stackers attached, and when one of them is full, automatic switching occurs between the two stackers to ensure maximum productivity for your system.

Identifying the components

The HCS is comprised of the following components:



1. **Control Panel:** Provides manual control of the various HCS functions
2. **Top Tray:** Holds a maximum of 500 sheets

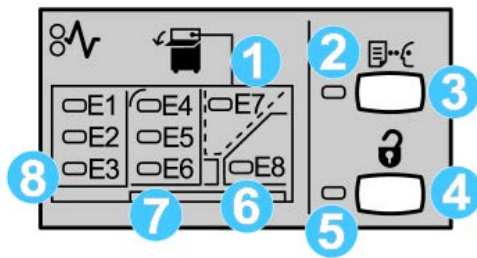
Note

Labels must be delivered to the Top Tray.

3. **Bypass:** Used only when a second stacking/finishing device is installed. This path transports media through the HCS to another connected finishing device.
4. **Stacker Tray/Cart:** Collated sets (up to a total of 5000 sheets) are transported to the Stacker Tray, which is located on a moveable Stacker Cart.

Control panel

The HCS control panel consists of:



1. Top Tray jam: This indicator blinks when there is a jam in the top tray area (E7).
2. Sample indicator: This indicator blinks until a proof set is delivered to the top tray.
3. Sample button: Press this button to have the HCS deliver an additional sample print such that the stack integrity is maintained. A single-page sample is provided to the output area.
4. Unload button: Press once to lower the Stacker Tray and unlock the HCS front door.
5. Unload indicator: This indicator lights when the Stacker Tray has reached the down position and the front door can be opened.
6. Exit jam: This indicator blinks where there is a jam in the exit area (E8).
7. Stacker Transport jam area: These indicators blink when there is a jam in Areas E4, E5, and/or E6.
8. Stacker Entrance jam area: These indicators blink when there is a jam in Areas E1, E2, and/or E3.

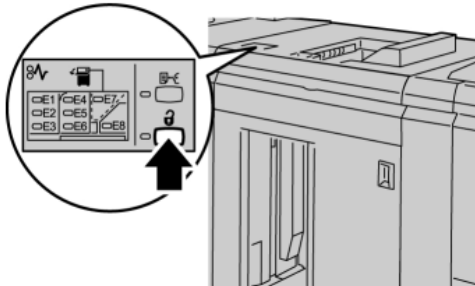
HCS top tray

The Top Tray offers the following:

- Copies/prints are aligned easily without folds or wrinkles in the output.
- To enable easier pick-up of the output, the HCS can be stopped by selecting the Stop button on the machine's UI.

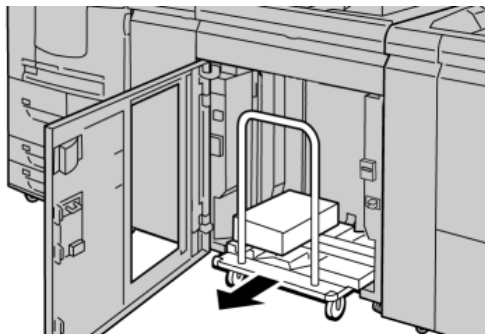
Unloading the Stacker Tray

1. Press the Unload button on the HCS control panel.



Wait until the Unload indicator lights and then open the HCS front door.

2. Open the front door after the **Unload** indicator lights.
3. Position the securing bar on top of the stacked paper.
4. Pull the Stacker Cart straight out of the HCS.



5. Remove the securing bar.
6. Remove the paper from the Stacker Tray.
7. Push the empty Stacker Cart straight into the HCS.
8. Position the securing bar on the fixed area inside the HCS.
9. Close the front door; the tray will rise to the operate position.

Problem solving

General problems

HCS tampers no longer in contact with paper

Cause: Problem occurs when printing with Clear dry ink/toner and using media that is 120 gsm, coated, and large stock sizes (such as 12 x 18 in./304.8 x 457.2 mm).

Remedy: Adjust the paper curl before printing the job. Refer to the System Administration Guide for specific information on paper curl settings and adjustment.

Jam clearance

Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

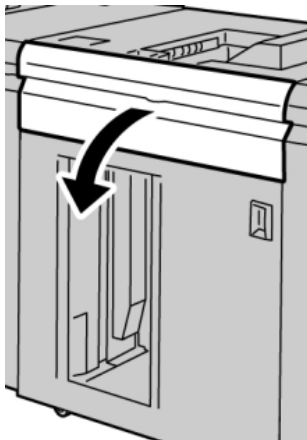
Note

Remedies differ according to the paper jam location. Follow the instructions displayed to remove the jammed paper.

HCS entrance jams (E1, E2, and E3)

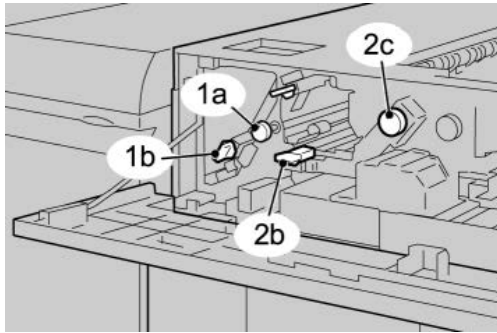
Perform the following steps to clear the jam and resume printing:

1. Open the HCS Front Cover.



High Capacity Stacker (HCS)

2. Lift the green handle(s) and/or rotate the green knob and remove all paper in the entrance area.

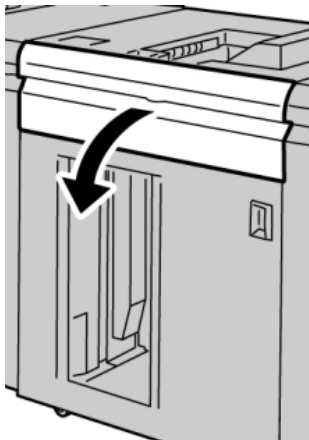


3. Close the green handle(s).
4. Close the HCS Front Cover.
5. If the UI indicates there is a jam in the print engine, follow the instructions on the screen to remove any paper in the area indicates.
6. Follow the instructions displayed on the UI to resume printing.

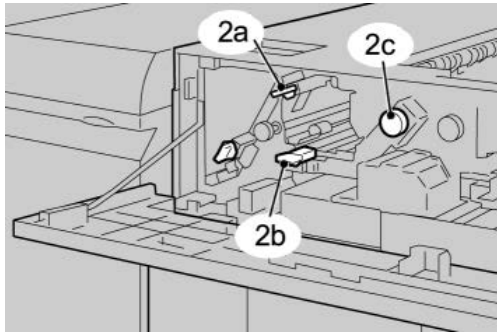
HCS transport jams (E4, E5, and E6)

Perform the following steps to clear the jam and resume printing:

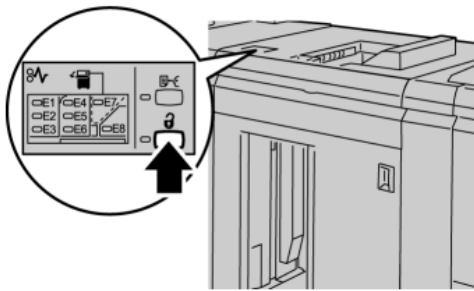
1. Open the HCS Front Cover.



2. Lift the green handle(s) and/or rotate the green knob and remove all paper in the entrance area.

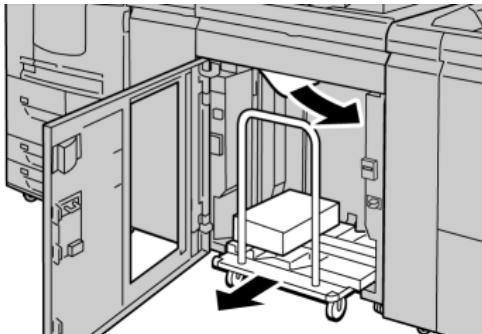


3. Close the green handle(s).
4. Close the HCS Front Cover.
5. Press the Unload button on the HCS control panel.



Wait until the Unload indicator lights and then open the HCS front door.

6. Open the front door after the **Unload** indicator lights.
7. Pull out the stacker cart and gently remove the jammed paper.



8. Push the stacker cart straight into the HCS.
9. Close the front door.

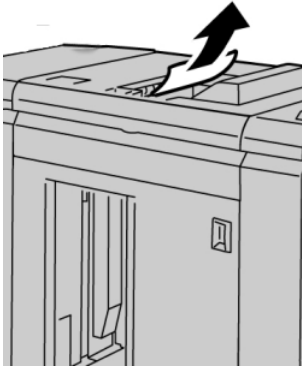
High Capacity Stacker (HCS)

10. If the UI indicates there is a jam in the print engine, follow the instructions on the screen to remove any paper in the area indicates.
11. Follow the instructions displayed on the UI to resume printing.

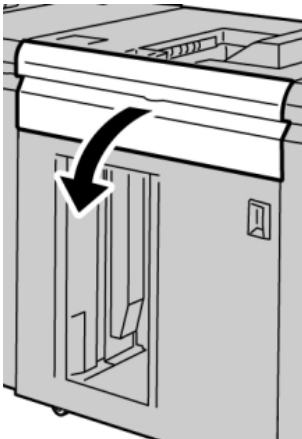
HCS top tray jam (E7)

Perform the following steps to clear the jam and resume printing:

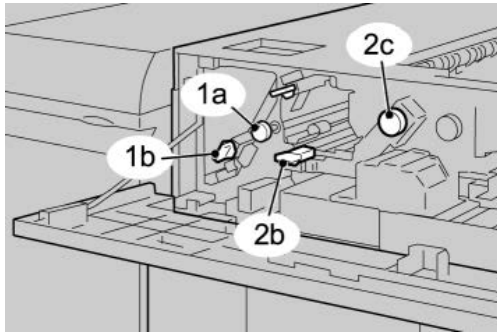
1. Remove any output delivered to the Top Tray.



2. Open the HCS Front Cover.



3. Lift the green handle(s) and/or rotate the green knob and remove all paper in the entrance area.

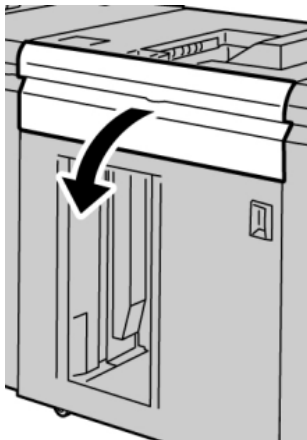


4. Close the green handle(s).
5. Close the HCS Front Cover.
6. If the UI indicates there is a jam in the print engine, follow the instructions on the screen to remove any paper in the area indicates.
7. Follow the instructions displayed on the UI to resume printing.

HCS exit jam (E8)

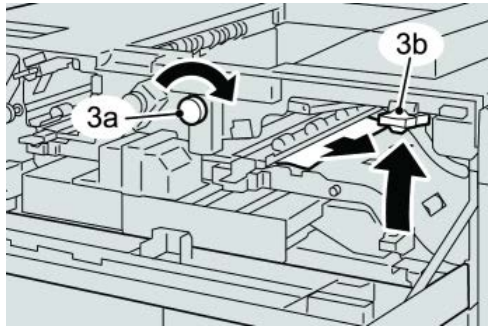
Perform the following steps to clear the jam and resume printing:

1. Open the HCS Front Cover.

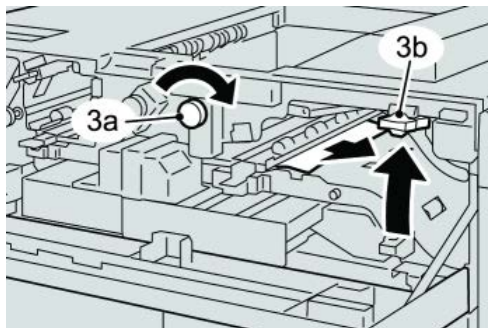


High Capacity Stacker (HCS)

2. Lift the green handle and/or rotate the green knob and remove all paper in the entrance area.



3. Lift the green handle and/or rotate the green knob and remove all paper in the entrance area.



4. Close the green handle(s).
5. Close the HCS Front Cover.
6. If the UI indicates there is a jam in the print engine, follow the instructions on the screen to remove any paper in the area indicates.
7. Follow the instructions displayed on the UI to resume printing.

Hints and tips for using the HCS

Refer to the following hints and tips when using the HCS:

1. Check the paper in the Stock Tray for curl.
 - a) If no curl is present and if the output is acceptable (meets customer satisfaction), you are finished.
 - b) If no curl is present and the if the output is NOT acceptable, call for service.
 - c) If curl IS present, continue to the next step.
2. Check the paper in the Stock Tray for curl.
3. Adjust the paper curl by using the decurler controls on the top of the Interface Module.
4. If the output has not improved, adjust the paper curl again.
5. If the output still has not improved, call the Customer Support Center.

Loss of power

If power is interrupted to the HCS:

- Ensure the power cord is plugged in to the proper wall receptacle
- Ensure that the machine power is switched “On”
- Ensure that the Ground Fault Indicator is in the “On” position
- If the power has not been restored by checking the above items, then call for service

Fault codes

Fault code	Possible cause	Recommended solution
049-100 049-101 049-102	Top Tray sensor fault	• Carefully remove all sheets and paper scraps from jam clearance areas. • Power Off/On the machine • If the problem still exists, contact the Customer Support Center.
049 104 049 105 049 106 049 108	Bypass exit sensor fault	• Carefully remove all sheets and paper scraps from jam clearance areas. • Power Off/On the machine • If the problem still exists, contact the Customer Support Center.
049 113 049 114 049 115 049 116	Stacker sensor fault	• Carefully remove all sheets and paper scraps from jam clearance areas. • Power Off/On the machine • If the problem still exists, contact the Customer Support Center.
049 117 049 119	Bypass path sensor fault	• Carefully remove all sheets and paper scraps from jam clearance areas. • Power Off/On the machine • If the problem still exists, contact the Customer Support Center.
049 121	Stacker exit sensor jam	• Carefully remove all sheets and paper scraps from jam clearance areas. • Power Off/On the machine • If the problem still exists, contact the Customer Support Center.

High Capacity Stacker (HCS)

(continued)

Fault code	Possible cause	Recommended solution
049 210 049 211	HCS front door sensor fault	• Open the HCS front door. • Carefully remove all sheets and paper scraps from the jam clearance areas. • Power Off/On the machine • Close the HCS front door. • If the problem still exists, contact the Customer Support Center.
049 212 049 213	Stacker up/down failure	• Power Off/On the machine • If the problem still exists, contact the Customer Support Center.
049 214 049 215 049 216	Stacker cart sensor fault	• Power Off/On the machine • If the problem still exists, contact the Customer Support Center.
049 217 049 218	Stacker full sensor fault	• Power Off/On the machine • If the problem still exists, contact the Customer Support Center.
049 219	HCS Front Door fault	• Power Off/On the machine • If the problem still exists, contact the Customer Support Center.
049 220 049 221	Stacker upper/lower limit fault	• Power Off/On the machine • If the problem still exists, contact the Customer Support Center.
049 224 049 225	Paper in/out sensor failure	• Carefully remove all sheets and paper scraps from jam clearance areas. • Power Off/On the machine • If the problem still exists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
049 228, 049 229, 049 232, 049 233, 049 234, 049 235, 049 236, 049 237, 049 238, 049 239, 049 240, 049 241, 049 242, 049 243, 049 248, 049 251, 049 252, 049 253, 049 280, 049 281, 049 282, 049 283, 049 284, 049 285,	HCS sensor failure	- Carefully remove all sheets and paper scraps from jam clearance areas. - Power Off/On the machine - If the problem still exists, contact the Customer Support Center.
049 286 049 287 049 288 049 300 049 310 049 500 049 700	HCS communication or software fault	- Check the connection between the Interface Module and the HCS. - Power Off/On the machine - If the problem still exists, contact the Customer Support Center.
049 900 049 901 049 902 049 903 049 905 049 907 049 908	The HCS detects paper remaining at: - Top tray - Bypass - Stacker Cart No paper is present: - HCS sensor fault	- Carefully remove all sheets and paper scraps from jam clearance areas. - Power Off/On the machine - If the problem still exists, contact the Customer Support Center.
049 940	HCS Front Door fault	- Power Off/On the machine - If the problem still exists, contact the Customer Support Center.
049 941	Stacker Cart fault	- Power Off/On the machine - If the problem still exists, contact the Customer Support Center.
049 945	HCS detects Top Tray as always full	- Carefully remove all sheets and paper scraps from jam clearance areas. - Power Off/On the machine - If the problem still exists, contact the Customer Support Center.

High Capacity Stacker (HCS)

(continued)

Fault code	Possible cause	Recommended solution
049 960 049 964	Sensor fault	- Power Off/On the machine - If the problem still exists, contact the Customer Support Center.
049 965 049 966	Stacker height limit or full detection fault	- Power Off/On the machine - If the problem still exists, contact the Customer Support Center.
049 967	HCS detects paper still remaining on stacker cart after the front door was opened/closed.	- Open the HCS front door. - Remove any paper from stacker cart. - Close front door - If necessary, power Off/On the machine - If the problem still exists, contact the Customer Support Center.
049 968	Mix size, stacker full detection fault	- Open the HCS front door. - Remove any paper from stacker cart. - Close front door - If necessary, power Off/On the machine - If the problem still exists, contact the Customer Support Center.
049 969	Stacker cart elevator motor fault	- Open the HCS front door. - Remove any paper from stacker cart. - Close front door - If necessary, power Off/On the machine - If the problem still exists, contact the Customer Support Center.
049 970 049 971 049 972	Stacker limit or full sensor fault	- Open the HCS front door. - Remove any paper from stacker cart. - Close front door - If necessary, power Off/On the machine - If the problem still exists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
049 973	HCS falsely detects that the Paper Unload button is pressed.	• Open the HCS front door. • Remove any paper from stacker cart. • Close front door • If necessary, power Off/On the machine • If the problem still exists, contact the Customer Support Center.

Specifications

Paper guidelines

- Stacker Tray will accept 55-350 gsm (either coated or uncoated stock) with the possibility of degraded stock quality and increased jam rate for stocks that are heavier than 300 gsm.
- 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 gsm may not run as reliably as coated paper heavier than 100 gsm.
- Non-standard papers longer than 305 mm (12 in.) in the feed direction require 210 mm (8.3 in.) minimum measurement across the feed direction.
- Non-standard papers shorter than 254 mm (10 in.) in the cross-feed direction require 330 mm (13 in.) minimum measurement in the feed direction.

High Capacity Stacker (HCS)

Perfect Binder

The Perfect Binder is an optional finishing device that takes the printed output and binds it into a finished book; an optional front and back cover may be included with the bound output.

Perfect binding is a process in which the leaves (pages) are bound by using an adhesive and trimming off the excess edges. The adhesive holds the interior sheets of the book together. Front and back covers may be included if desired. The final output is a finished, perfect bound book with a wrap-around cover.

Binder components

External components



1 Compiler tray LED

This LED lights when the compiler tray cover is locked indicating that the binder is in operation. This safety feature prevents access to the internal components.

Note

The LED also lights when the printer and Perfect Binder are powering on. Upon completion of the power-on process, the LED switches off.

2 Compiler tray cover

Open this cover to clear jams or to add a book block (printed, finished book) for manual mode operations.

3 Top cover

Open this cover to clear paper jams.

4 Compiler tray

This tray gathers the finished sheets into a book block, and the book block is used to make the final finished book.

5 Cover inserter

Load paper here for covers or inserts.

6 Adhesive filling tray

Open this tray to insert adhesive pellets for the binding process.

7 and 8 Left and right front doors

Open these doors to clear paper jams or to access internal components.

9 Front doors LED

When a binding operation is in progress the LED changes to orange; this indicates that the front doors are locked. When no binding is in process, the LED is not illuminated, and the front doors may be opened to clear jams and to access the internal components.

Note

The LED also lights when the printer and Perfect Binder are powering on. Upon completion of the power-on process, the LED switches off.

10 Trimmer waste tray

Excess paper trimmed from the book block sheets are stored in this tray. The tray is easily removed to recycle the waste trimmings.

11 Book stacker tray

Finished (completed) bound books are transported to this area.

12 Book stacker tray release button and LED

Press this button to open the book stacker tray. A flashing green light indicates that the tray is in the process of being opened or closed. A steady green light indicates that the tray is open, and completed books may be removed.

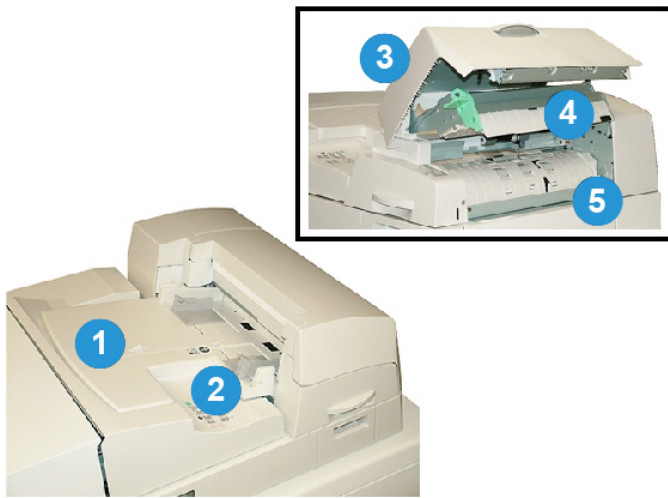
13 Book stacker tray Full indicator

This LED flashes when a binding operation is in process. A steady green light indicates that the Book stacker tray is full.

14 Entrance transport front door

Open this door to clear jams from the incoming paper path area (E4). Also, the adhesive pellet scoop is stored in this area.

Cover inserter

**1 Cover inserter tray**

This tray is for loading cover media and inserts that will be bound with to the book block during the binding process.

2 Paper width guide

Adjust this guide so that it touches the loaded media in the tray.

3 Inserter cover

Open this cover to access internal components.

4 Inserter inner cover

Open this cover to clear jams.

5 Right inserter baffle

Open this baffle to clear jams.

Internal components



1 Cover transport

This moves the cover sheets from the cover inserter to the binding area.

2 Bypass transport

This transport moves the cover media to the binding area; the cover media may come either from the cover inserter tray or from the printer (network print job). If book binding is not required, the printed output is transferred from the incoming paper path (from the left of the Perfect Binder) directly through the binder and to the next finishing device in line.

3 Adhesive unit

Applies adhesive to the book block in order to bind the spine of the pages together.

4 Binding area

This area binds book block to the cover material.

5 Cutter area

This area is where the book block pages are cut/trimmed. Finished books then are transported to the book stacker tray.

Binder control panel



1 Fault indicators/location

These indicators light when a fault or a jam occurs in a particular area of the binder.

2 Adhesive temperature indicator

This indicator displays the status of the adhesive temperature:

Indicator flashing on/of

The binder is warming up; adhesive is warming up.

Indicator is off (no light)

The binder is in power saver mode.

Indicator is on (steady light)

The binder is ready for operation.

3 Start/Adhesive temperature button

Press this button to warm up the adhesive or to start the manual mode process for a job.

Binder circuit breaker



1 Circuit breaker

Located on the rear of the binder. Power to the machine is automatically interrupted when a circuit is overloaded or when a short circuit is detected. The overload causes the power switch to move to the **Off** position. The overload condition is reset by flipping the switch to the **On** position.

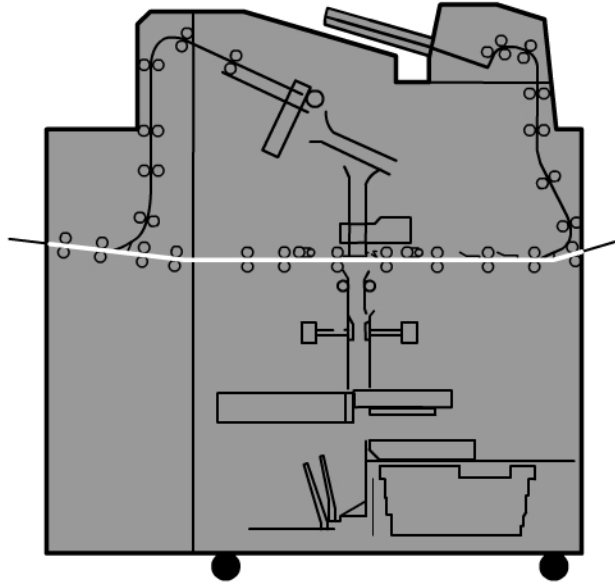
2 Circuit breaker Test button

This button may be activated with a pencil point to test the circuit breaker.

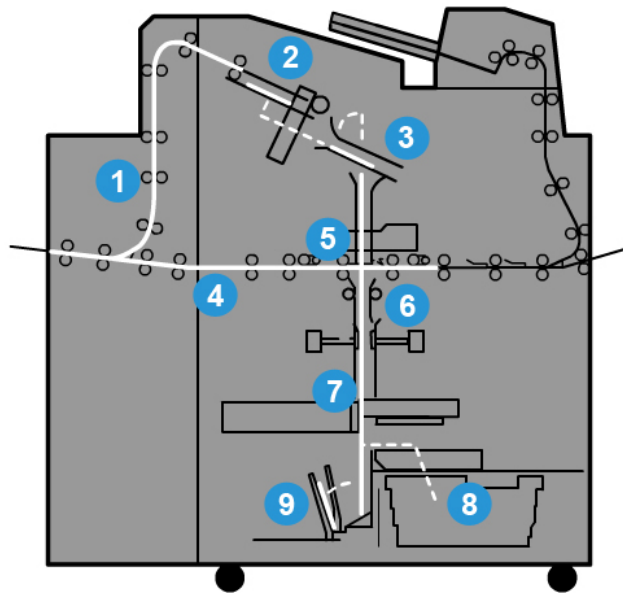
Book binding path

Bypass path

The bypass path is used when an incoming job does not require the binder. The job enters from the printer's paper path, is fed through the binder, and is delivered to the next finishing device in line.



Standard path



1 Incoming print job

This paper path moves the incoming paper to the compiler tray.

2 Compiler tray

Upon arrival to the compiler tray, the paper is then assembled into a book block.

3 Sub-grip/main grip

The sub-grip and main grip move the book block to the adhesive unit.

4 Bypass transport

If designated, an incoming cover is moved along the bypass transport to the adhesive unit and awaits the book block.

5 Adhesive unit

Adhesive is applied to the spin of the book block.

6 Binding area

The adhesive-coated book block and cover media are bound together and then continue to the next phase of the binding process. If no cover media was specified, the book block continues through the paper path for trimming and delivery to the book stacker tray.

7 Trimming

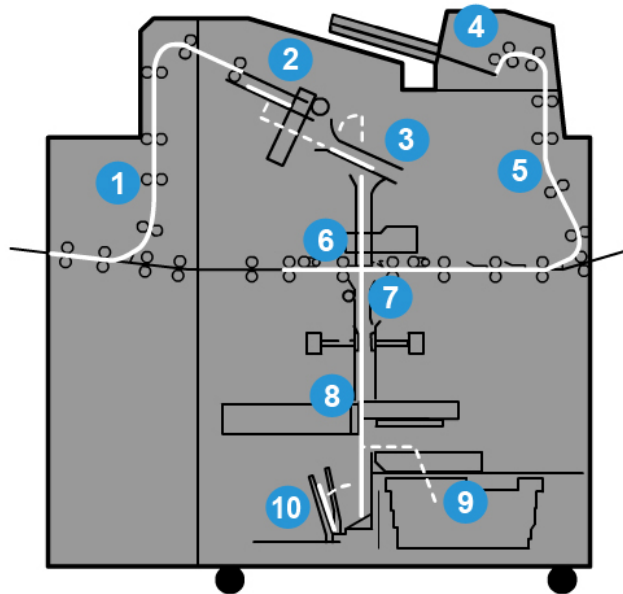
The three unbound edges of the book are trimmed to size by the cutter unit.

8 Trimmer waste tray

Once the book edges are trimmed, the paper cuttings are deposited in the trimmer waste tray.

9 Book stacker tray

Finally, the finished books are stacked in the book stacker tray.

Cover inserter path**1 Incoming print job**

This paper path moves the incoming paper to the compiler tray.

2 Compiler tray

Upon arrival to the compiler tray, the paper is then assembled into a book block.

3 Sub-grip/main grip

The sub-grip and main grip move the book block to the adhesive unit.

4 Cover inserter

If desired, cover media is loaded into this tray.

5 Bypass transport

The bypass transport moves the cover media to the adhesive unit where it awaits the book block.

6 Adhesive unit

Adhesive is applied to the spine of the book block.

7 Binding area

The adhesive-coated book block and cover media are bound together and then continue to the next phase of the binding process. If no cover media was specified, the book block continues through the paper path for trimming and delivery to the book stacker tray.

8 Trimming

The bound book edges are trimmed to size by the cutter unit.

9 Trimmer waste tray

Once the book edges are trimmed, the paper cuttings are deposited in the trimmer waste tray.

10 Book stacker tray

Finally, the finished books are stacked in the book stacker tray.

Power on/off

Important

The binder's power is controlled by the system. When the system powers on, the binder also powers on. When the system powers off, the binder does the same.

Power Saver mode

The binder's power saver mode is independent from that of the system's power saver. However, if desired, it is possible to set both power saver modes to the same interval. The binder's default time is 10 minutes; after 10 minutes of inactivity, the binder enters power saver (and the heater unit for the adhesive switches off). This time may be changed to reflect a value of 1-240 minutes; you must enter the Administrator mode to change it.

If the system's power saver is set to a time interval that is less than the binder's, then when the system enters power saver, the binder also enters power saver. By default the system automatically enters power saver after 15 minutes of inactivity. This time may be changed to reflect a value of 1-240 minutes; you must enter the Administrator mode to change it.

Note

To keep the binder at maximum running efficiency, it is recommended that the power saver time interval for the binder is kept at the default 10 minutes.

Loading media in the cover inserter tray

This tray provides an alternate source for cover stocks. Covers may be printed and supplied by the printer, or they may be manually loaded into this tray. This is especially useful if you have pre-printed covers that you want to use for the book job.



Caution

Do not use paper that is torn, crimped, stapled, or taped.

Note

- Do not load paper of different sizes.
 - A maximum of 200 sheets of cover stock may be loaded in the tray.
 - Available paper sizes for the cover inserter tray are:
 - Paper width (front-to-back): 10 1/2 - 13 in. (B4/257 - 330.2 mm)
 - Paper length (lead-to-trail edge): 14.33 (B4) - 19 3/16 in. (364 - 488 mm)
1. Open the ream of paper with the seam side facing up.
 2. Fan the sheets before loading them into the tray.
 3. Load the paper into the inserter tray and adjust the guide to the width of the paper.

Note

Ensure that there are no defects in the paper and that all edges of the paper are aligned prior to inserting the paper into the Inserter.

- a) Load the paper with the outside facing upwards and the top towards the rear of the tray.
- b) Align the sheets against the back wall of the tray.



4. From the printer's UI, enter the correct paper information, including size, type, and weight from the Tray Properties window.
5. Select **OK** to save the information and close the Tray Properties window.

Removing books from the binder

1. The book stacker tray LED lights indicating that a finished book was delivered to book stacker tray.
2. Press the button to open the book stacker tray.
3. Remove the book and close the tray.

Submitting a job to the binder

These exercises require the PDF files for the User Guide and System Administration Guide. If you do not have an electronic copy of these PDFs, download them from www.xerox.com.

The exercises instruct you on how to print one of the customer documentation guides (User Guide or System Administration Guide).

Printing from your computer to the binder

1. From your computer open one of the PDFs files in Adobe Acrobat Reader.
2. Select **File > Print**.
3. Select the desired printer.
4. Select the printer's Hold queue.
5. Select **OK** to send the job to the printer.

The job is sent to and remain in the printer's Hold queue until released for printing.

6. Go the print server that is connected to the printer.
7. To print the job, go the correct print server procedure in this section and follow the instructions to setup and release the job for printing to the binder.

Printing from the Xerox FreeFlow Print Server to the Perfect Binder

The following procedures provide instructions on different types of binder print jobs sent from the print server to the binder. Carefully read and perform the steps to successfully print your job.

Binder manual mode with the FreeFlow Print Server

This procedure describes how to use the binder's manual mode for both covers and book blocks to create a finished book. Both covers and the book block (book pages) are preprinted prior to using the binder's manual mode.

1. Preprint covers and book block (pages) separately and place them within reach of the Perfect Binder.
2. Load the preprinted covers into the binder's cover inserter tray. Adjust the paper guides to gently touch the edges of the paper.
3. At the system's UI, confirm/change the tray properties for the preprinted covers. Tray appears on the system's UI as T1.
4. At the print server, select **Printer > Finishing** .
The Finishing window opens and displays the available finishers.
5. From the Internal Finishers area of the window, double-click Perfect Binder.
The Perfect Binder Settings window opens.
6. For Manual Mode, select the Enable radio button.
This setting takes the binder offline from the press/printer. Any stackers or binders configured inline before the binder are be available to the press/printer, but finishing devices located inline after the binder cannot be used while it is in manual mode.
7. Under Units, select either inches or mm for the measurement unit.
8. For Mode Type, select Bind and Trim for normal binding operation.
9. From the Book Block Stock menu, select the specific stock on which the book blocks are preprinted.
10. In the Cover area of the window, select the stock on which the covers are pre-printed.
11. For cover Position, accept the default values of 0.00 for Center and Side.
12. For Rotation Adjustment, accept the default values of 0.00 for Top, Front and Bottom.
13. In the Trim area of the window, select Full-Bleed.
This trims the three sides of the bound book that are not bound. This selection provides the best quality output.
14. From the Standard Size drop down menu, select the size you want for the finished book.
15. For Vertical Position, leave the default value of 0.00.

If you want more trimmed from the bottom and less trimmed at the top, decrease the setting. If you want more trimmed from the top and less trimmed at the bottom, increase the setting. The total trim amount remains the same, but the bound book is shifted up or down during the cutting process.

16. Select **OK**.

The Perfect Binder is now ready for manual operation and is offline from the printer for print line jobs. The parameters that you entered have been sent to the binder for the manual operation. Other jobs can be run on the printer, as long as they output to a stacker before the Perfect Binder, and not a finishing device after it in the configuration.

17. At the binder, open the compiler tray cover.

18. Lift Handles **1** and **2** to gain access to the book block area.

19. Insert the book block (printed pages of the book) into the area in the LEF and face down direction.

20. Move the green lever to adjust the paper guides to the edge of the paper.

21. Close Handles **2** and **1**.

22. Close the compiler tray cover.

23. Press the green **Start** button on the binder's control panel.

The book is now bound and/or trimmed.

24. Push the green button to open the book stacker tray and to retrieve the book.

25. Go to the print server.

26. Select **Printer > Finishing**.

27. Double-click Perfect Binder and click **Disable**.

The binder is no longer in manual mode.

Printing/binding with preprinted covers to the FreeFlow Print Server

This procedure uses covers that are preprinted on large stock, such 11 x 17 in./A3, and loaded into the binder's cover inserter tray. A single file containing the book block is printed and sent to the binder. At the binder the covers are automatically fed and bound to the book block producing a finished book.

1. Load the preprinted covers into the binder's cover inserter tray. Adjust the paper guides to gently touch the edges of the paper.
2. At the system's UI, confirm/change the tray properties for the preprinted covers.
Tray appears on the system's UI as T1.
3. For the book block pages, load the desired stock into one of the printer's trays and confirm on the settings on the system's UI.
4. Send the job containing both your cover and the book block pages to the print server's Hold queue.

5. From the print server, select the job in the Hold queue and then select **Job Properties**.
The Job Properties window opens.
6. Select the **Basic** tab.
7. For Paper Stock, select the **Loaded Stocks** button and select the specific stock that you loaded.
8. For Sides Imaged, select **2 Sided**.
9. Select the Stapling/Finishing menu and select **Perfect Bind > Portrait Left**.
This setting places the spine on the left side of the book as it faces you.
10. Select Finishing Settings.
The Perfect Binder Settings window opens.
11. Under Units, select either inches or mm for the measurement unit.
12. From the Type, select **Pre-printed Cover**.
13. For Stock, select the cover stock that you previously loaded into the binder's cover inserter tray.

Select it from Loaded Stocks since it was previously loaded in the tray.
14. For cover Position, accept the default values of 0.00 for Center and Side.
15. For Rotation Adjustment, accept the default values of 0.00 for Top, Front and Bottom.
16. In the Trim area of the window, select Full-Bleed.
This trims the three sides of the bound book that are not bound. This selection provides the best quality output.
17. From the Standard Size drop down menu, select the size you want for the finished book.
18. For Vertical Position, leave the default value of 0.00.

If you want more trimmed from the bottom and less trimmed at the top, decrease the setting. If you want more trimmed from the top and less trimmed at the bottom, increase the setting. The total trim amount remains the same, but the bound book is shifted up or down during the cutting process.
19. Select **OK** to save and close.
20. Select **Print**.
The job is sent to the printer and binder.
21. From the binder, the book stacker tray LED lights indicating that a finished book was delivered to book stacker tray.
22. Press the button to open the book stacker tray.
23. Remove the book and close the tray.

Printing/binding from a single file to the FreeFlow Print Server

This procedure uses a single file that contains a large first sheet to serve as a wrap-around cover. The remainder of the pages in the file are book block size.

1. Open and verify that the first page of your file is correctly laid out for either 1 Sided or 2 Sided printing. It must be a size larger than the body pages (book block).

Once verified, close the file.

2. Load the cover stock into one of the printer's trays, and confirm the settings on the UI.
3. For the book block pages, load the desired stock into one of the printer's trays and confirm on the settings on the system's UI.
4. Send the job containing both your cover and the book block pages to the print server's Hold queue.
5. From the print server, select the job in the Hold queue and then select **Job Properties**.
The Job Properties window opens.
6. Select the **Basic** tab.
7. For Paper Stock, select the **Loaded Stocks** button and select the specific stock that you loaded.
8. For Sides Imaged, select **2 Sided**.
9. Select the Stapling/Finishing menu and select **Perfect Bind > Portrait Left**.
This setting places the spine on the left side of the book as it faces you.
10. Select Finishing Settings.
The Perfect Binder Settings window opens.
11. Under Units, select either inches or mm for the measurement unit.
12. From the Type, select **Cover Within Job**.
13. For Stock, select the tray where the cover stock is loaded.

Select it from Loaded Stocks since it was previously loaded in the tray.

14. For cover Position, accept the default values of 0.00 for Center and Side.
15. For Rotation Adjustment, accept the default values of 0.00 for Top, Front and Bottom.
16. In the Trim area of the window, select Full-Bleed.
This trims the three sides of the bound book that are not bound. This selection provides the best quality output.
17. From the Standard Size drop down menu, select the size you want for the finished book.
18. For Vertical Position, leave the default value of 0.00.

If you want more trimmed from the bottom and less trimmed at the top, decrease the setting. If you want more trimmed from the top and less trimmed at the bottom, increase the setting. The total trim amount remains the same, but the bound book is shifted up or down during the cutting process.

19. Select **OK** to save and close.

20. Select **Print**.

The job is sent to the printer and binder.

21. From the binder, the book stacker tray LED lights indicating that a finished book was delivered to book stacker tray.

22. Press the button to open the book stacker tray.

23. Remove the book and close the tray.

Printing from the Xerox CX Print Server, Powered by Creo to the Perfect Binder

The following procedures provide instructions on different types of binder print jobs sent from the print server to the binder. Carefully read and perform the steps to successfully print your job.

Binder manual mode with the CX Print Server

This procedure describes how to use the binder's manual mode for both covers and book blocks to create a finished book. Both covers and the book block (book pages) are preprinted prior to using the binder's manual mode.

1. Preprint covers and book block (pages) separately and place them within reach of the Perfect Binder.

2. Load the preprinted covers into the binder's cover inserter tray. Adjust the paper guides to gently touch the edges of the paper.

3. At the system's UI, confirm/change the tray properties for the preprinted covers. Tray appears on the system's UI as T1.

4. From the print server icon bar, select the **Activate Perfect Binder** icon.

The Printer Status icon on the left of the screen displays Manual_Perfect_Binder.

5. From the Tools drop-down menu, select **Manual Perfect Binder** tool.

The Manual Perfect Binder window opens.

6. For Job Type, select either **Binding** or **Trimming**.

The Binding option binds and trims, while the Trimming option only trims.

If you select Trimming, a window opens to set the trim amount for the fore edge.

7. Select Save to the Trim Settings window.

8. From Trim method, select **None**, **Fore Edge** or **Cut to Size**.

9. Select **Save** after setting the Trim settings.
10. Under Body parameters, select:
 - a) The Paper size of the book block.
 - b) A Paper Type (if different from Plain paper)
 - c) The Coating (Uncoated, Gloss or Matte)
11. Under Cover parameters, select:
 - a) The cover Paper size
 - b) A Paper Type (if different from Plain paper)
 - c) The Coating (Uncoated, Gloss or Matte)
12. Select **Submit**.
13. Select **OK** to the message that parameters have been sent to the binder.
14. Select **Close** on the Manual Perfect Binder window.
15. At the binder, open the compiler tray cover.
16. Lift Handles **1** and **2** to gain access to the book block area.
17. Insert the book block (printed pages of the book) into the area in the LEF and face down direction.
18. Move the green lever to adjust the paper guides to the edge of the paper.
19. Close Handles **2** and **1**.
20. Close the compiler tray cover.
21. Press the green **Start** button on the binder's control panel.

The book is now bound and/or trimmed.
22. Push the green button to open the book stacker tray and to retrieve the book.
23. Go to the print server.
24. Select the Perfect Binder icon on the print server icon bar.

The Printer Status now displays Ready, and the binder immediately returns to online with the printer.

Printing/binding from a single file to the CX Print Server

This procedure uses a single file that contains both the cover and the book block. The file is submitted to the print server, set to be finished at the Perfect Binder, and then released for processing and printing.

1. Load the cover stock into one of the printer's trays, and confirm the settings on the UI.
2. For the book block pages, load the desired stock into one of the printer's trays and confirm on the settings on the system's UI.
3. Send the job containing both your cover and the book block pages to the print server's Hold queue.
4. From the print server, select the job in the Hold queue and then select **Job Properties**.

The Job Properties window opens.

5. On the Copies and pages screen, enter the number of copies to print and bind.
6. Select **Print Method**, and select **Simplex** or **Duplex** from the menu.

For Duplex, you can select **head to head** or **head to toe** layout.

7. Select **Paper Stock**, and select the parameters for the book body paper.
8. Select **Finishing** to set parameters for the cover stock.
 - a) From Output tray, select **Perfect Binder Tray**.
 - b) From the Pull Cover From, select the source tray for the cover stock. This will be a specific tray on the press or the binder's cover inserter tray.

If you intend to print the cover from the file, you must select a tray on the press.

- c) From Cover Content, select the desired option.
- d) If there is a spine title or image in the file, select **From file** for the Spine entry; otherwise, accept the default Blank.
- e) From Binding, select the location for the binding: **Left**, **Right**, **Top**, or **Bottom**.

This is generally Left for most Western countries and sometimes Top for a calendar-like orientation.

- f) Select the **Trimming job** box, to set trim mode.
- g) For Mode, select either **Fore Edge** or **Cut to Size**.
9. Select **Save** after setting the Trim settings.
10. Review the picture of the selected setup.
11. Verify that this is the desired layout.
12. Select **Submit** to print the job.
13. From the binder, the book stacker tray LED lights indicating that a finished book was delivered to book stacker tray.
14. Press the button to open the book stacker tray.
15. Remove the book and close the tray.

Printing/binding from two files to the CX Print Server

This procedure uses one file for covers that are preprinted on large stock and loaded into the binder's cover inserter tray. A second file containing the book block is then printed at the printer and sent to the binder where the covers are automatically fed and bound to the book block.

1. Submit the cover file to the Hold queue of the print server.
2. From the print server's Hold queue, open the cover file's Job Properties.
3. On the Copies and pages screen, enter the number of copies to print and bind.
4. Select **Print Method**, and select **Simplex** or **Duplex** from the menu.

For Duplex, you can select **head to head** or **head to toe** layout.

5. Select **Paper Stock**, and select the parameters for the book body paper.
6. Select **Finishing** to set parameters for the cover stock.
7. From Output tray, select any tray or **Auto Output Tray**.
8. Save and close the Job Properties and release the cover job for printing.
9. Retrieve the printed covers from the output tray.
10. Load the preprinted covers into the binder's cover inserter tray. Adjust the paper guides to gently touch the edges of the paper.
11. At the system's UI, confirm/change the tray properties for the preprinted covers.
Tray appears on the system's UI as T1.
12. Submit the file containing the book block (pages) to the Hold queue of the print server.
13. For the book block pages, load the desired stock into one of the printer's trays and confirm on the settings on the system's UI.
14. From the print server, select the job in the Hold queue and then select **Job Properties**.
The Job Properties window opens.
15. On the Copies and pages screen, enter the number of copies to print and bind.
16. Select **Print Method**, and select **Simplex** or **Duplex** from the menu.

For Duplex, you can select **head to head** or **head to toe** layout.

17. Select **Paper Stock**, and select the parameters for the book body paper.
18. Select **Finishing** to set parameters for the cover stock.
 - a) From Output tray, select **Perfect Binder Tray**.
 - b) From the Pull Cover From, select the binder's cover inserter tray for the cover stock.
 - c) From Cover Content, select the desired option.
 - d) If there is a spine title or image in the file, select **From file** for the Spine entry; otherwise, accept the default Blank.
 - e) From Binding, select the location for the binding: **Left**, **Right**, **Top**, or **Bottom**.

This is generally Left for most Western countries and sometimes Top for a calendar-like orientation.

- f) Select the **Trimming job** box, to set trim mode.
 - g) For Mode, select either **Fore Edge** or **Cut to Size**.
19. Select **Save** after setting the Trim settings.
20. Select **Submit** to print the job.
21. From the binder, the book stacker tray LED lights indicating that a finished book was delivered to book stacker tray.
22. Press the button to open the book stacker tray.
23. Remove the book and close the tray.

Printing from the Xerox EX Print Server, Powered by EFI to the Perfect Binder

The following procedures provide instructions on different types of binder print jobs sent from the print server to the binder. Carefully read and perform the steps to successfully print your job.

Binder manual mode with the EX Print Server

This procedure describes how to use the binder's manual mode for both covers and book blocks to create a finished book. Both covers and the book block (book pages) are preprinted prior to using the binder's manual mode.

1. Preprint covers and book block (pages) separately and place them within reach of the Perfect Binder.
2. Load the preprinted covers into the binder's cover inserter tray. Adjust the paper guides to gently touch the edges of the paper.
3. At the system's UI, confirm/change the tray properties for the preprinted covers.
Tray appears on the system's UI as T1.
4. At the print server, place the binder in manual mode.
5. At the binder, open the compiler tray cover.
6. Lift Handles **1** and **2** to gain access to the book block area.
7. Insert the book block (printed pages of the book) into the area in the LEF and face down direction.
8. Move the green lever to adjust the paper guides to the edge of the paper.
9. Close Handles **2** and **1**.
10. Close the compiler tray cover.
11. Press the green **Start** button on the binder's control panel.
The book is now bound and/or trimmed.
12. Push the green button to open the book stacker tray and to retrieve the book.
13. Go to the print server.
14. At the print server, disable the binder's manual mode and place it back online with the system.

Printing/binding with preprinted covers to the EX Print Server

This procedure uses covers that are preprinted on large stock, such 11 x 17 in./A3, and loaded into the binder's cover inserter tray. A single file containing the book block is printed and sent to the binder. At the binder the covers are automatically fed and bound to the book block producing a finished book.

1. Load the preprinted covers into the binder's cover inserter tray. Adjust the paper guides to gently touch the edges of the paper.

2. At the system's UI, confirm/change the tray properties for the preprinted covers.
Tray appears on the system's UI as T1.
3. For the book block pages, load the desired stock into one of the printer's trays and confirm on the settings on the system's UI.
4. Send the job containing the book block pages to the print server's Hold queue.
5. From the print server, select the job in the Hold queue and then select **Job Properties**.
The Job Properties window opens.
6. Select **Quick Access** and set Copies to the number of copies you want to print and bind.
7. If printing on both sides of the book block pages, for Duplex, select **Top - Top or Top - Bottom**.
8. Select the **Layout** tab from the menu bar.
9. Select the **Booklet** radio button.
10. In the Booklet Type area, select **1-up Perfect**.
A window opens to set Perfect Binder parameters.
11. To the left of 1-up Perfect, select the location of the binding on the book:
 - **Left Binding**: this is the default and commonly used for books printed in the west.
 - **Top**: this provides a calendar-type binding.
 - **Right Binding**: This is used for books published in Asian or Middle-Eastern languages.
12. In the Trim area, select the trim amount; options include:
 - **Use Specified Values**: Uses the trim control arrows to manually set trim amounts for the three sides of the book that are not bound.
 - **None**: No trimming occurs for the job, just binding.
 - **Minimum Trim**: the print server automatically applies the minimum trim possible, which is less than .25 in./6.35 mm.
 - **Calculate Trim From Finish Size**: This sets the width and height of the finished size of the bound book, after trimming is complete.

Use the Trim Angles button only when the corners of a bound book are not 90° and therefore the book is not square. If you have already bound some books and know that one of the sides of the bound book is not being trimmed straight, you can adjust the Top, Bottom and Fore edge angle.
13. Select the Body Paper Size for the paper that you loaded in the printer tray for the book block.
14. Select the Cover Paper Size for the paper that you loaded in the printer tray for the covers.
15. In the Cover Content area of the window, for Content input, select **Pre-Printed**.

16. For Spine Width, use the arrows to set the size of the spine.
17. Under Body Position, for Booklet Scaling, select **None** or **Shrink to Body Size**.
18. For Centering Adjustment, select how you want the book images positioned on the pages: **At the center** or **At the spine**. You can use the arrows to fine tune the position if needed.
19. Select **Print** to print and bind the book.

If you want to check your trim and position settings before printing a large number of copies, select **Print > Proof Print**.

20. From the binder, the book stacker tray LED lights indicating that a finished book was delivered to book stacker tray.
21. Press the button to open the book stacker tray.
22. Remove the book and close the tray.

Printing/binding from a single file to the EX Print Server

This procedure uses a single file that contains both the cover and the book block. The file is submitted to the print server, set to be finished at the Perfect Binder, and then released for processing and printing.

1. Load the cover stock into one of the printer's trays, and confirm the settings on the UI.
2. For the book block pages, load the desired stock into one of the printer's trays and confirm on the settings on the system's UI.
3. Send the job containing both your cover and the book block pages to the print server's Hold queue.
4. From the print server, select the job in the Hold queue and then select **Job Properties**. The Job Properties window opens.
5. Select **Quick Access** and set Copies to the number of copies you want to print and bind.
6. If printing on both sides of the book block pages, for Duplex, select **Top - Top** or **Top - Bottom**.
7. Select the **Layout** tab from the menu bar.
8. Select the **Booklet** radio button.
9. In the Booklet Type area, select **1-up Perfect**.
A window opens to set Perfect Binder parameters.
10. To the left of 1-up Perfect, select the location of the binding on the book:
 - **Left Binding:** this is the default and commonly used for books printed in the west.
 - **Top:** this provides a calendar-type binding.
 - **Right Binding:** This is used for books published in Asian or Middle-Eastern languages.

11. In the Trim area, select the trim amount; options include:

- **Use Specified Values:** Uses the trim control arrows to manually set trim amounts for the three sides of the book that are not bound.
- **None:** No trimming occurs for the job, just binding.
- **Minimum Trim:** the print server automatically applies the minimum trim possible, which is less than .25 in./6.35 mm.
- **Calculate Trim From Finish Size:** This sets the width and height of the finished size of the bound book, after trimming is complete.

Use the Trim Angles button only when the corners of a bound book are not 90° and therefore the book is not square. If you have already bound some books and know that one of the sides of the bound book is not being trimmed straight, you can adjust the Top, Bottom and Fore edge angle.

12. Select the Body Paper Size for the paper that you loaded in the printer tray for the book block.

13. Select the Cover Paper Size for the paper that you loaded in the printer tray for the covers.

14. In the Cover Content area of the window, for Content input, select one of the following:

- **Front & Back Separately:** Select if the front cover images are on the first page and the back cover images are on the last page of the file. If you select this setting, also set both the Front Cover (Page 1) and Back Cover (Page N) menus to one of the following: Print on Outside, Print on Inside, Print on Both Sides, or Do not Print.

Note

When you print on both sides of the front cover, Page 2 is placed on the inside of the cover, and when you print on both sides of the back cover, the next-to-last-page (Page N-1) is placed on the inside.

- **Front & Back Together:** Select if the first page of the file is a large sheet that contains both the front cover and the back cover. The binder wraps this cover sheet around the book block. If you select this setting, also set the Content menu to **Print on the outside of the cover** (if there are images on just the front of the cover page in the file), or **Print on Both sides of the cover** (if there are images on the front and back of the cover page in the file).
- **Pre-Printed:** Select if you printed the cover separately and you do not want the print server to create a cover from the file.

15. For Spine Width, use the arrows to set the size of the spine.

For Spine Content, select **Document Page** if you want to print on the spine and the image is located in the file.

16. Under Body Position, for Booklet Scaling, select **None** or **Shrink to Body Size**.
17. For Centering Adjustment, select how you want the book images positioned on the pages: **At the center** or **At the spine**. You can use the arrows to fine tune the position if needed.
18. Select **Print** to print and bind the book.

If you want to check your trim and position settings before printing a large number of copies, select **Print > Proof Print**.
19. From the binder, the book stacker tray LED lights indicating that a finished book was delivered to book stacker tray.
20. Press the button to open the book stacker tray.
21. Remove the book and close the tray.

Maintenance

While performing maintenance activities, always keep the following items in mind:

- It is recommended that you perform all cleaning procedures on a daily basis, preferably at the start of the day before the system is switched on and while the fuser is cool.
- If the system is switched on and the fuser is hot, be sure to switch off the system power and allow 30 minutes for the fuser to cool before performing any cleaning procedures.
- Only clean the recommended areas of the paper path as described in the cleaning procedures.

Cleaning the binder

1. Switch off the system by pressing the power button (which is located on the Print Engine, Right Side).
2. Disconnect the power cord at the back of the binder.
3. Use a damp, water-moistened (not wet), lint-free cloth to clean the covers and doors.
4. Open each green-handle area and clean the surfaces of these areas.
5. Remove any residual moisture with a dry, lint-free cloth.
6. Return all the green levers to their original positions.
7. Reconnect the power cord to the binder.
8. Power on the system.

Empty the trimmer waste tray

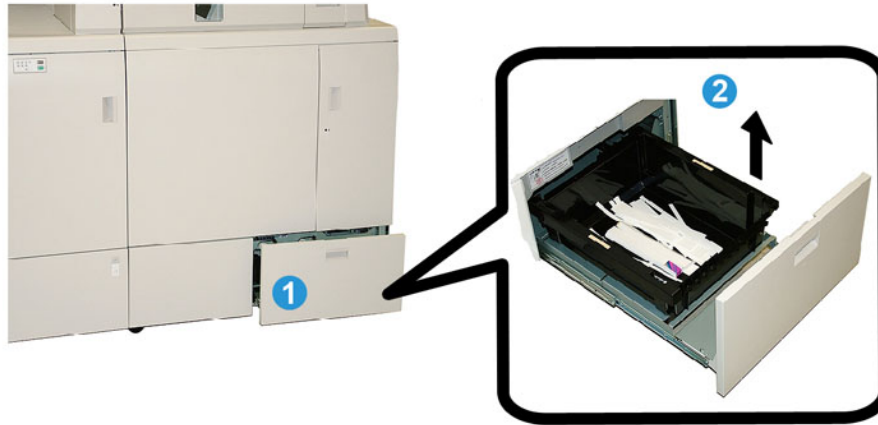
Read the following before performing this procedure:

- Do not open the trimmer waste tray while the binder is in operation. Wait until the completion of a job before opening and emptying the tray.

- Do not place a plastic bag into the tray. This reduces the capacity of the tray and may cause equipment damage or fault codes to be generated.
- When the trimmer waste tray is full, the printer stops running and a message displays stating that the bin is full and will resume after it is emptied.

Tip

During larger binding jobs, the trimmer waste tray may require emptying more frequently.



1. Open the trimmer waste tray.
2. Lift and remove the inside tray/bin.
3. Empty the contents of the tray/bin into a waste container.
4. Visually check to ensure that all scraps are removed from the tray area of the machine.
5. Reinstall the tray/bin into the trimmer waste tray.
6. Gently close the trimmer waste drawer.

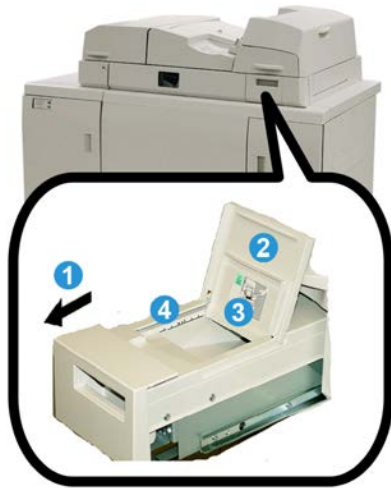
Adhesive filling tray

Read the following before performing this procedure:

- The adhesive supply may be replenished while the binder is in operation.
- Use only the specified adhesive for use in the binder. Any other adhesive may result in binder malfunction.
- Store the adhesive in a cool, well-ventilated area and away from high temperature and humidity. The adhesive may combust if placed in an area with open flame or high temperature.
- Do not over-fill the adhesive replenishment hopper; otherwise the covers may not close properly and adhesive pellets may get into other areas of the binder causing malfunctions.

- Do not use adhesive pellets that have fallen on the floor as they may contain dirt and dust which may cause binder malfunctions.
- Do not place anything other than the adhesive pellets into the adhesive replenishment hopper as this may cause a fire in the binder.
- The adhesive pellets are transferred to the binder as the supply in the binder is consumed. The binder can contain about 0.8 pounds (380 grams) of adhesive.

Replenishing the adhesive filling tray



1. Open the adhesive filling tray.
2. Open the outer cover.
3. Open the inner cover.
4. Using the supplied scoop, add adhesive pellets to the replenishment hopper until the height of the pellets is even and level and just below the adhesive limit line.
5. Close the inner and outer covers.
6. Close the adhesive filling tray; an audible click is heard when the tray locks into position.

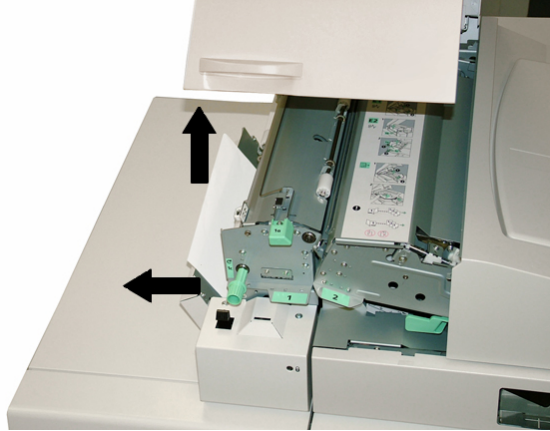
Binder problem solving

Note

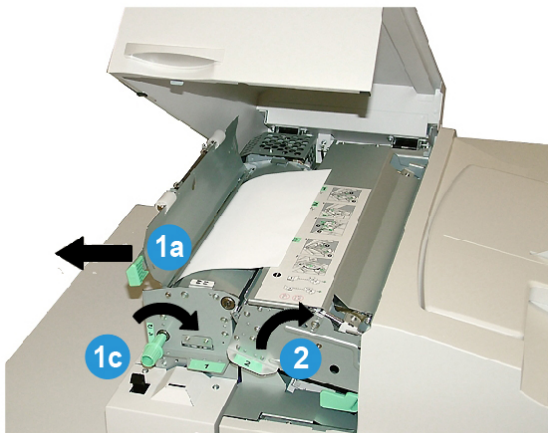
- Paper jams are displayed on both the printer's UI and the binder's control panel.
- Clear multiple paper jams in the sequence indicated on the printer's UI and on the binder's control panel.

Paper jams in areas E1 and E2

1. Open the compiler tray cover.
2. Move handle **1b** to the left and remove any jammed paper.



3. Move handle **1a** to the left, rotate the knob **1c**, and remove any jammed paper.

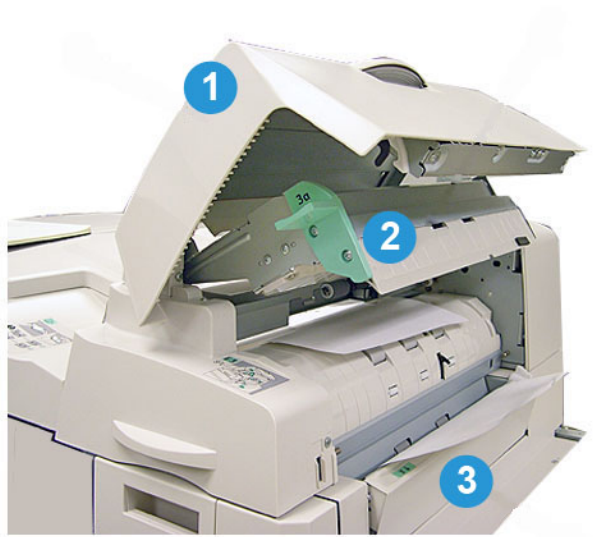


4. Lift handle **2** to the right and remove any jammed paper.
5. Return handles **2**, **1a**, and **1b** their original positions.
6. Close the compiler tray cover.
7. Follow the instructions displayed on the system's UI to restart your print job.

Paper jams in area E3

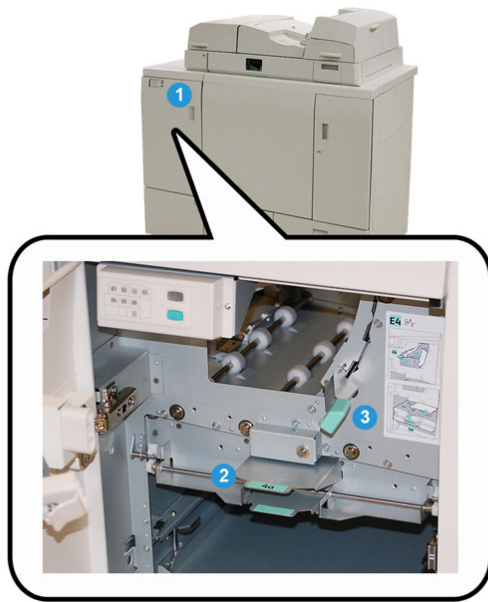
Note

If a jam occurs after the book block leaves the compiler area, the paper is purged with the spin glued to the book block but without a cover attached.



1. Open the inserter cover.
2. Open the inserter inner cover (**3a**).
3. Open the right guide (**3b**).
4. Remove any jammed paper.
5. Close the areas **3b**, **3a**, and the inserter cover.
6. If desired, reload paper into the cover inserter tray.
7. Follow the instructions displayed on the system's UI to restart your print job.

Paper jams in area E4



1. Open the entrance transport front door.
2. Open area **4a** and remove any jammed paper.
3. Open area **4b** and remove any jammed paper.
4. Remove handles **4b** and **4c** to their original positions.
5. Follow the instructions displayed on the system's UI to restart your print job.

Paper jams in areas E5 and E6

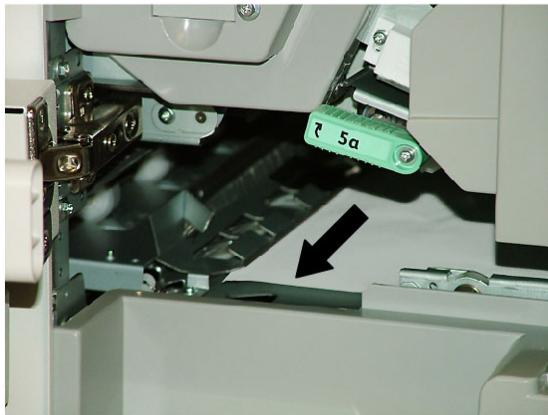
Note

The binder's left and right front doors will not open when the front cover LED is lit.

1. Open the left and right doors.

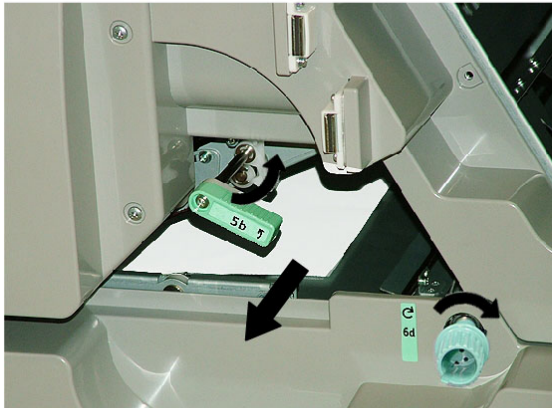


2. Lift handle **5a** and remove any jammed paper.

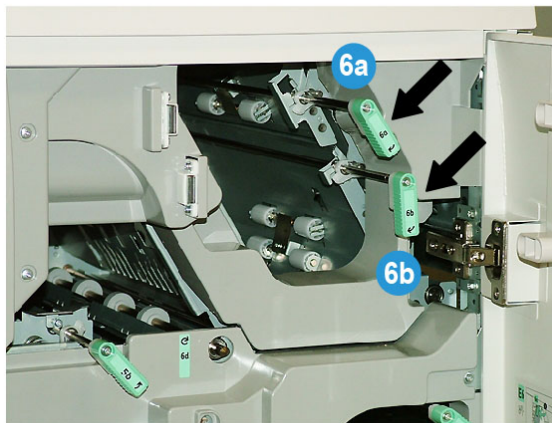


3. Return handle **5a** to its original position.

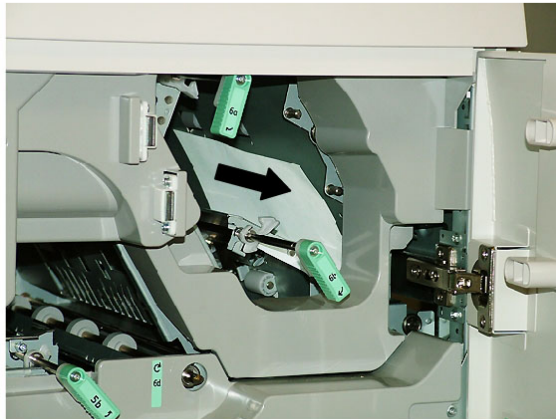
4. Lift handle **5b**, rotate knob **6d**, and remove any jammed paper.



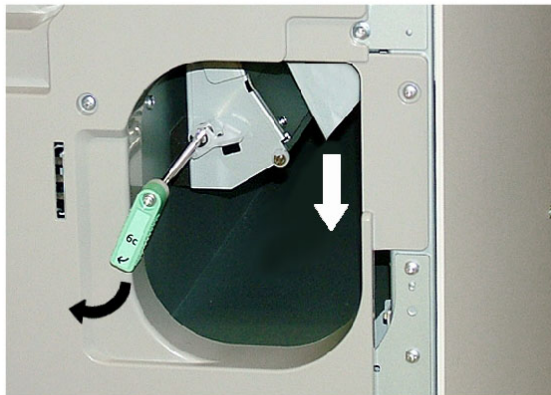
5. Return handle **5b** to its original position.
6. Open areas **6a** and **6b**.



7. Remove any paper jammed paper.



8. Return handles **6a** and **6b** to their original positions.
9. Open area **6c** and remove any jammed paper.



10. Return handle **6c** to its original position.
11. Close the binder's left and right front doors.
12. Follow the instructions displayed on the system's UI to restart your print job.

General problems

Power interruption during operation

Note

When power is interrupted to the binder during a print job, the book trimmings may remain in the paper path. Perform the following steps to clear the paper path.

1. Switch off the system by pressing the power button.
2. Open the book stacker tray.
3. Check for the presence of paper cuttings/trimmings the tray.
If cuttings/trimmings are present, remove them.
4. Close the book stacker tray.
5. Run a test job to ensure that the binder performs correctly.

Adjusting the printed image and trim

If the printed book is not within the desired parameters, you can adjust the settings from the system's UI.

Important

The various image and trim adjustment options may vary from one print server to another. Refer to your print server customer documentation for more information on these options and how to use them.

Fault codes

053 100

Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

053 101

Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

053 102

Cause: Paper jam

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053 103

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053 105

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053 148

Cause: Paper jam

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053 210

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 211

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053 298

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 299

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 301

Cause: A cover or door is open

Remedy: Close the opened cover or door; follow the instructions displayed on the system's UI to restart your job.

053 302

Cause: A cover or door is open

Remedy: Close the opened cover or door; follow the instructions displayed on the system's UI to restart your job.

053 303

Cause: A cover or door is open

Remedy: Close the opened cover or door; follow the instructions displayed on the system's UI to restart your job.

053 304

Cause: A cover or door is open

Remedy: Close the opened cover or door; follow the instructions displayed on the system's UI to restart your job.

053 305

Cause: A cover or door is open

Remedy: Close the opened cover or door; follow the instructions displayed on the system's UI to restart your job.

053 310

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 311

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 312

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 313

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 314

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 315

Cause: Software problem

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 316

Cause: Software problem

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 326

Cause: Software problem

Remedy: Recheck the thickness of the incoming job; resend job. If fault continues, contact the Customer Support Center.

053 327

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 328

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 332

Cause: Software problem

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 333

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 334

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 335

Cause: Software problem

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

053 400

Cause: Book stacker tray is open

Remedy: Close the tray. If fault continues, power on/off the system. If fault continues, contact the Customer Support Center.

053 401

Cause: Top cover is open

Remedy: Close the cover. If fault continues, power on/off the system. If fault continues, contact the Customer Support Center.

053 404

Cause: Adhesive filling tray is open

Remedy: Close the tray. If fault continues, power on/off the system. If fault continues, contact the Customer Support Center.

053 405

Cause: Trimmer waste tray is full

Remedy: Empty the tray. Follow the instructions displayed on the system's UI to restart your print job.

053 406

Cause: Book stacker tray is full

Remedy: Empty the tray. Follow the instructions displayed on the system's UI to restart your print job.

053 407

Cause: Cutter blade is nearing or at end of life

Remedy: Contact your service representative.

053 408

Cause: Cutter blade is nearing or at end of life

Remedy: Contact your service representative.

053 409

Cause: Adhesive level is low or empty

Remedy: Add more adhesive pellets to the adhesive filling tray.

053 410

Cause: Cutter blade is nearing or at end of life

Remedy: Contact your service representative.

053 411

Cause: Trimmer waste tray is full

Remedy: Empty the tray.

053 412

Cause: Adhesive level is low or empty

Remedy: Add more adhesive pellets to the adhesive filling tray. Follow the instructions displayed on the system's UI to restart your print job.

053 900

Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

053 901

Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

053 902

Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

053 903

Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

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Cause: Paper jam

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Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

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Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

053 912

Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

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Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

053 914

Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

053 915

Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

053 916

Cause: Paper jam

Remedy: Remove the jammed paper; follow the instructions displayed on the system's UI to restart your job.

053 922

Cause: Cannot detect the size loaded in the cover inserter tray or the amount loaded in the tray exceeds maximum quantity.

Remedy: Remove contents from the tray; reload media into the tray, and ensure that the correct tray programming information is reflected on the system's UI.

054 210

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

054 211

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

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Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

055 254

Cause: Internal component failure

Remedy: Power off/on the system. If fault continues, contact the Customer Support Center.

153 700

Cause: Cutter blade is nearing or at end of life

Remedy: Contact your service representative.

153 701

Cause: Book stacker tray is full

Remedy: Empty the tray. Follow the instructions displayed on the system's UI to restart your print job.

153 702

Cause: Book stacker tray is open

Remedy: Close the tray. If fault continues, power on/off the system. If fault continues, contact the Customer Support Center.

153 703

Cause: Defective books which were not trimmed or a book job that was cancelled in the middle of the job, were delivered to the book stacker tray.

Remedy: Open the book stacker tray and remove the defective books. Dispose of accordingly. Close the tray. If fault continues, power on/off the system. If fault continues, contact the Customer Support Center.

153 704

Cause: Defective books which were not trimmed or a book job that was cancelled in the middle of the job, were delivered to the book stacker tray.

Remedy: Open the book stacker tray and remove the defective books. Dispose of accordingly. Close the tray. If fault continues, power on/off the system. If fault continues, contact the Customer Support Center.

153 705

Cause: Trimmer waste tray is open

Remedy: Close the tray. If fault continues, power on/off the system. If fault continues, contact the Customer Support Center.

Binder specifications

Binding type

Perfect binding: The process in which the leaves (pages) are bound by using an adhesive and trimming off the excess edges. The adhesive holds the interior sheets of the book together. Front and back covers may be included if desired. The final output is a finished, perfect bound book with a wrap-around cover.

Cutting type

Full Bleed, Face cut, and No cut

Cutting distance

Top/bottom: Minimum: 0.55 in./14 mm; maximum: 2.125 in./54 mm

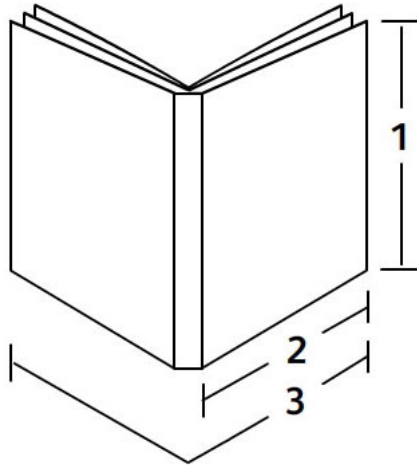
Fore Edge: Minimum: 0.275 in./7 mm; maximum: 1.34 in./34 mm

Book thickness

Minimum: 0.118 in./3 mm

Maximum: 1 in./25.4 mm

Book dimensions



1 Book width

Minimum: 10.1 in./257 mm

Maximum: 12.6 in./320 mm

Note

The minimum

2 Book block (body pages)

Minimum: 7.16 in./182 mm

Maximum: 9 in./182-228.6 mm

3 Cover

Minimum: 14.22 in./364 mm

Maximum: 19.2 in./488 mm

Book block (body pages)

Book pages are fed into the binder in the long edge feed (LEF) direction.

Acceptable paper sizes:

8.5 x 11 in./A4 (LEF); 6.93 x 9.84 in./B5 (LEF); SRA4/8.85 x 12.59 in. (LEF)

Acceptable paper weights:

17-43.5 lb. bond (64-163 gsm)

Note

Paper stock weights 106-163 gsm are limited to interleaf, a maximum of 10 sheets per book, evenly distributed.

Approximate number of sheets per book (thickness)

10-200 sheets of 17 lb./64 gsm - 20 lb./80 gsm bond paper with a maximum thickness of 1 in./25.4 mm or less for coated stocks

10-150 sheets of 20 lb./80 gsm - 28 lb. 105 gsm bond paper; maximum thickness of 1 in./25.4 mm or less for coated stocks

1-10 sheets of 28 lb./106 gsm - 43.5 lb./163 gsm for all stocks

Cover

Maximum number of 1 sheet per book and the sheet is fed into the binder in the short edge feed (SEF) direction.

Acceptable paper sizes:

11 x 17 in./A3 (SEF), 9.84 x 13.90 in./B4 (SEF), SRA3/12.59 x 17.71 in. (SEF)

Acceptable paper weights:

24-80 lb. bond (90-300 gsm), 350 gsm Xerox Colotech

Binder's bypass mode

Refer to the printer's specifications for acceptable paper sizes and weights. These paper types can be transported through the binder's bypass mode directly to the next inline finishing device. The printer's specifications can be found earlier in this user guide.

Adhesive container capacity

Approximately 0.8 lb./380 grams; contains approximately enough adhesive for 135 books at 100 pages per book for 8.5 x 11 in./A4, 17 lb. (64 gsm) paper.

Cover inserter tray capacity

200 sheets of 20 lb./80 gsm

Trimmer waste tray capacity

Approximately enough space for paper cuttings from approximately 15 books (when binding 100 books of 8.5 x 11 in./A4 sheets and trimming them to 6.93 x 9.84 in./B5 size).

Perfect Binder

Book stacker tray capacity

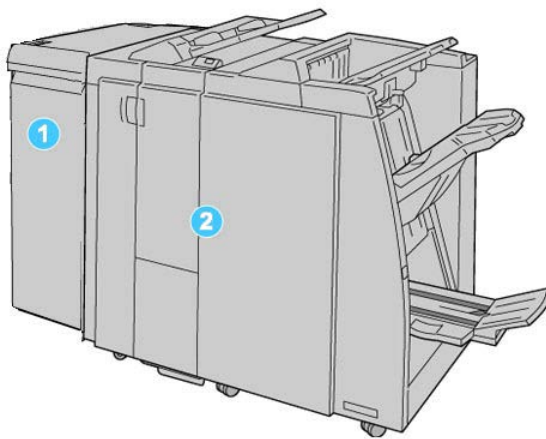
Approximately 4.17 in./106 mm width capacity

Warm-up time

Approximately 440 seconds (7 minutes) or less

17

Standard/Booklet Maker Finisher

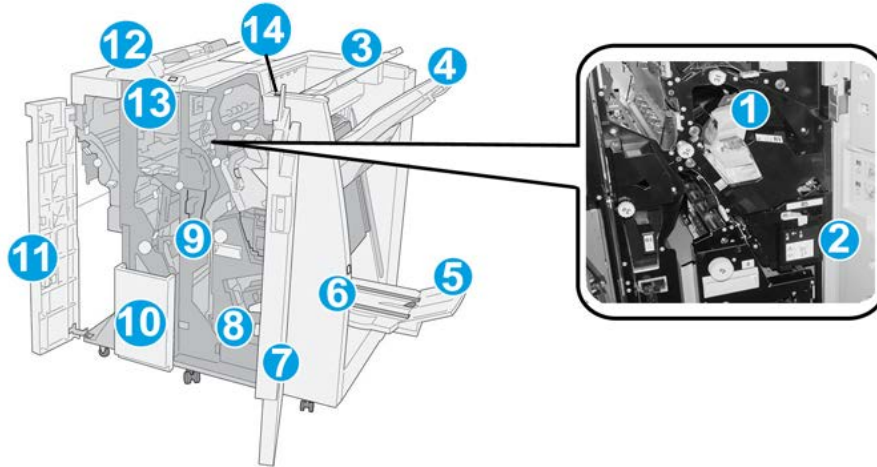


1. Interface Module: This REQUIRED module acts as a communication device and as a paper path between the machine and the Standard Finisher or Booklet Maker Finisher.
2. Standard or Booklet Maker Finisher: These finishers provide a wide range of finishing and folding options. The Booklet Maker Finisher is shown in the above illustration.

Note

The Standard Finisher or Booklet Maker Finisher may be referred to simply as the finisher.

The Standard/Booklet Maker finisher is comprised of the following components:



No.	Component	Function
1	Staple cartridge	Contains staples; remove this cartridge to replace staples and clear staple jams.
2	Staple waste container	Container for staple waste; remove this container when full.
3	Top tray	The Top Tray is used for stacked output, and can receive up to 500 sheets of 20 lb./80 gsm paper. Copies are delivered here when specific output features are selected, such as Automatic sorting, Collated, Uncollated, or Normal.
4	Stacker (middle) tray	The Stacker Tray is used for offset and/or stapled output, and can hold up to 2000 sheets of 20 lb./80 gsm paper. This tray also receives copies when you punched and Z-folded copies. Note Both the Top and Stacker Trays can be used for hole punched output (optional)
5	Booklet output tray	This is available only with the Booklet Maker Finisher. The Booklet tray receives saddle-stitched booklets when you select C-Fold or C-Fold + Stapling.
6	Booklet output tray button	This is available only with the Booklet Maker Finisher. When you press this button, the booklet output tray is raised so you can retrieve booklets from the output area.
7	Right cover	Open to clear paper jams, replace staples, clear jammed staples, or remove the scraps from the puncher.
8	Staple cartridges for booklet	This is available only with the Booklet Maker Finisher. There are two staple cartridge for booklet. Remove this cartridge to replace staples and clear staple jams.
9	Punch scrap container	Collects the scraps from the puncher. Open to remove the scraps.

(continued)

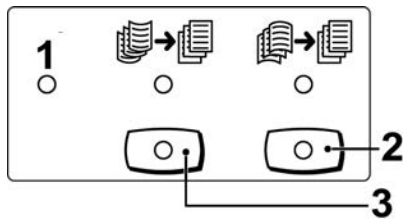
No.	Component	Function
10	C/Z-Fold output tray (optional)	The optional Folder tray receives copies when you select C-folding or Z-folding of 8.5 x 11 in./A4 output and 11 x 17 in./A3 media.
11	Left cover.	Open this cover to access the machine and to clear paper jams.
12	Post-process inserter (Tray 8/Tray T1)	This tray is called either Tray 8 or Tray T1. Its name depends on which machine to which the finisher is attached. Features for Tray 8/T1 include the following: • This tray is standard on this finisher and is used to load paper that will be used as separators and covers. • Paper loaded here is not printed on; use this tray for pre-printed stock and for insertion into the printed output. (This tray is also known as the Interposer). • Tray 8 holds a maximum of 200 sheets when using 20 lb./75 gsm paper. • Paper can be loaded in the LEF or SEF direction.
13	C/Z-Fold output tray button	Press this button to open C/Z-Fold output tray.
14	Manual decurl button	When you press this button, it activates a decurling feature for the output material. This applies especially to lighter weight paper.

Manual decurling feature on the finisher

The finisher provides a manual decurling feature which allows you to adjust the curl of the print output at point of need.

Pressing the Decurler button on the finisher switches the decurl feature between the Auto, On, and Off modes.





1. **Auto** button: When this indicator is lit, the appropriate curl correction is automatically performed depending on the sizes and orientation of the printed output. The button should be set to Auto for most situations. The button automatically switches to the Auto mode when:
 - The machine is switched on
 - The machine exits the Power Saver mode
2. When this button is pressed and the downward curl indicator is lit, downward curl correction is performed on all printed output. If your output is curled downward, press this button to prevent downward curls.
3. When this button is pressed and the upward curl indicator is lit, upward curl correction is performed on all printed output. If your output is curled upward, press this button to prevent upward curls.

Note

When no indicator is lit, the machine does not perform any curl correction to the printed output.

Folding feature

If your machine is equipped with the optional C/Z Folder, you can make prints using the folding option. The option folds your prints in half (single) or in thirds (C-fold or Z-fold types). The folding option is selected from the print driver.

Note

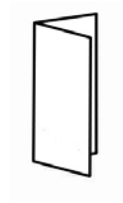
In order to use the folding option, the orientation of documents must be short-edge feed (SEF). You must select a paper tray that contains SEF stock.

Fold types

These fold types are available:

Single Fold (Bi-Fold)

A Bi-Fold has one fold which creates two panels to the output.

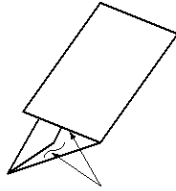


Note

The Single Fold option is available only with the Booklet Maker Finisher.

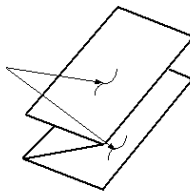
C-Fold

A C-Fold has two folds which creates a three-panel output.



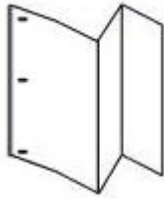
Z-Fold

A Z-Fold has two folds that are folded in opposite directions, resulting in a type of fan fold.



Z-Fold Half Sheet (shown here with 3-hole punch)

As with a regular Z-Fold, it has two folds that are folded in the opposite directions. The difference between a regular Z-Fold and a Z-Fold Half Sheet is that the Z-Fold Half Sheet is not folded in two equal folds. The two folds are unequal which allows one edge of the Z-Fold Half Sheet to have a longer edge, and the longer edge allows for stapling or hole punching.



Loading paper/tabs in Tray 8/T1 (Post-Process Inserter)

1. If necessary, remove any remaining media that is currently loaded in Tray 8/T1.
2. Hold the center of the paper guides and slide them to their desired paper size.



3. Load the paper/tabs, aligning it to the front side of the tray.



- a) If the paper is preprinted, load the paper with the printed side facing up.
 - b) If the media is tab stock, load the tab side to be fed first (in the direction of the arrow as shown in the above illustration).
4. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, decurler and/or alignment option
If enabled by your System Administrator, the Paper Tray Properties screen may be displayed on the UI.
5. Select **OK** to save the information and close the Tray Properties window.

Maintenance

Standard/Booklet Maker consumable supplies

Xerox supplies, including staples, staple cartridges, and staple waste containers can be ordered from Xerox by going to www.xerox.com and clicking on either the Contact Us link for specific contact information/telephone numbers in your area or by clicking on the Supplies and entering/selecting your specific machine information (product family and model type).

Note

Always refer to www.xerox.com for the latest Consumable Replaceable Units (CRUs) part numbers.

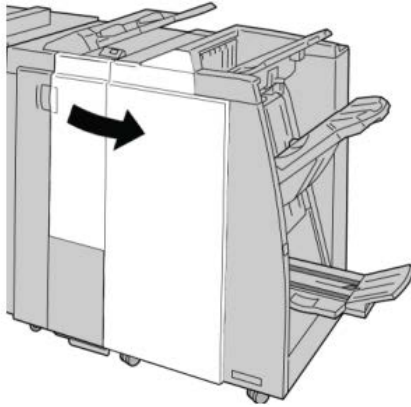
Store supply items and Xerox parts in their original packages in a convenient location.

Supply Item	Supply Unit Shipped with finisher/Reorder Quantity
Staple cartridge/staple waste container	4 staple cartridges (5000 staples per cartridge) and 1 staple waste container per carton
Booklet Maker Finisher staple cartridge	4 pack: 5000 staple refills each

Replace the standard staple cartridge

A message displays on the UI when it is time to replace a staple cartridge.

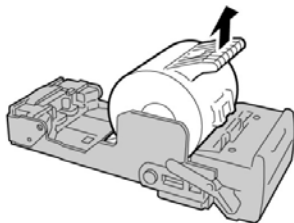
1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



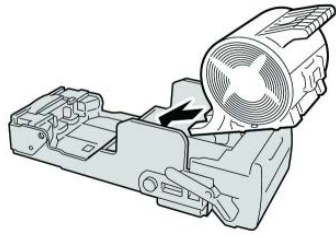
3. Grasp the Staple Cartridge handle located at **R1**, and pull out the staple cartridge from the finisher.



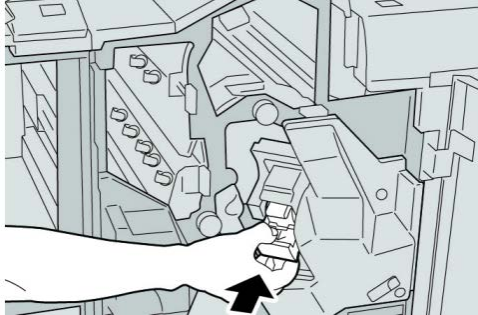
4. Hold the positions as indicated by the arrow and remove the staple cartridge from the unit.



5. Push a new staple cartridge into the unit.



6. Reinstall the cartridge unit to its original position in the finisher.



7. Close the Right Cover on the finisher.

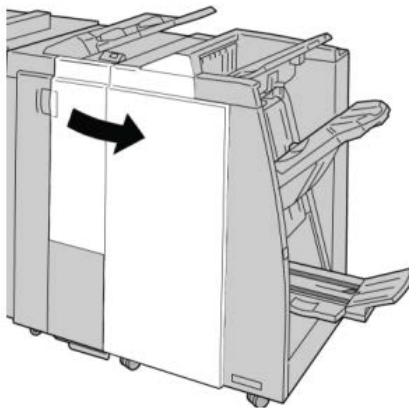
Note

A message will display and the machine will not operate if the right cover is open even slightly.

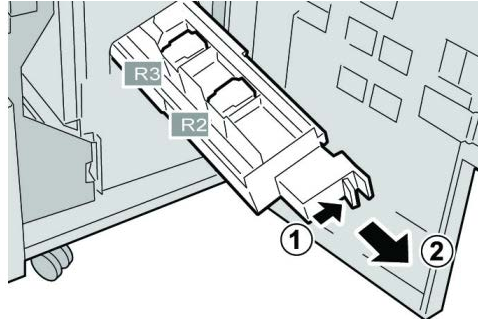
Replace the booklet stapler cartridge

In addition to the standard stapler, the Booklet Maker Finisher is equipped with a booklet stapler. When this booklet stapler needs to be replaced, a message appears on the UI.

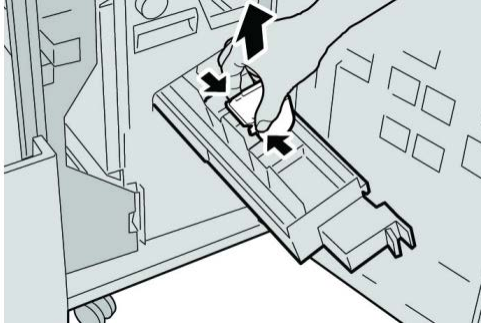
1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



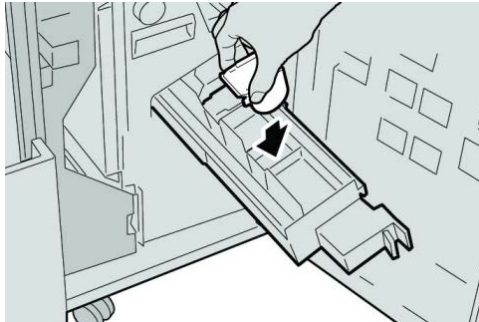
3. While pressing the lever to the right, pull out the booklet staple cartridge unit.



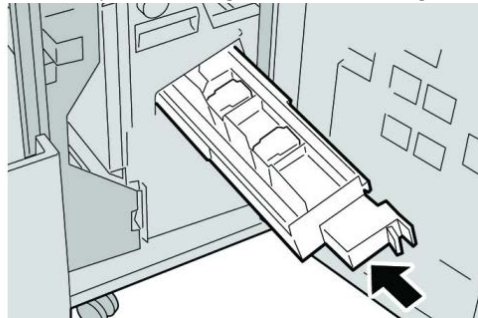
4. Hold the tabs of the staple cartridge unit by the tabs and lift to remove it.



5. While holding the tabs of a new staple cartridge, push it into the unit.



6. Push the staple cartridge unit to its original position in the machine.



7. Close the Right Cover on the finisher.

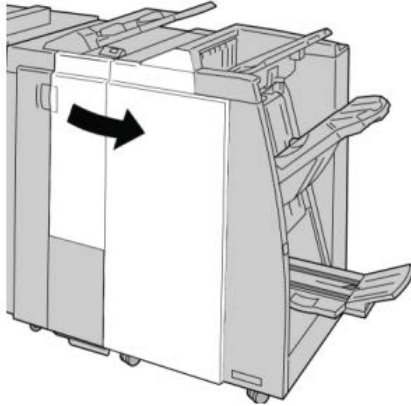
Note

A message will display and the machine will not operate if the right cover is open even slightly.

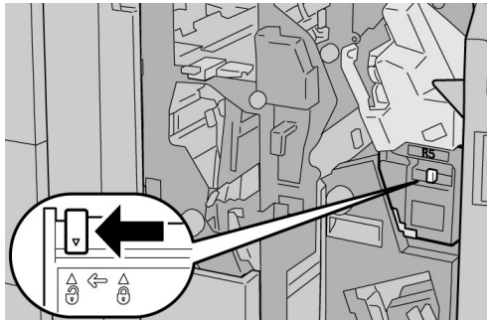
Replacing the Staple Waste Container on the finisher

The machine displays a message indicating that the Staple Waste Container is full. To replace the container:

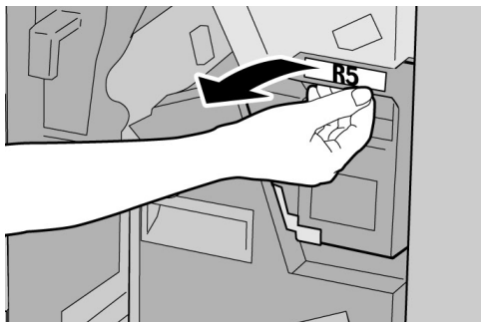
1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



3. Locate the Staple Waste Container (R5) in the finisher, and move the lock lever to the unlock position.



4. Hold R5 as shown in the figure and remove the staple waste container from the machine.



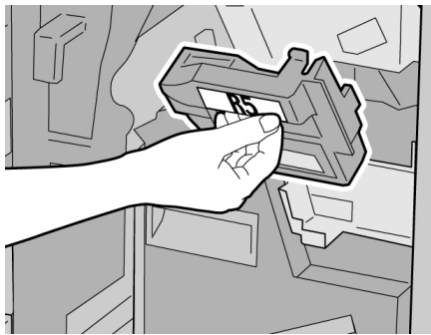
5. Place the used staple waste container into a supplied plastic bag.



Note

Do not return a disassembled (used) container to the Customer Support Center.

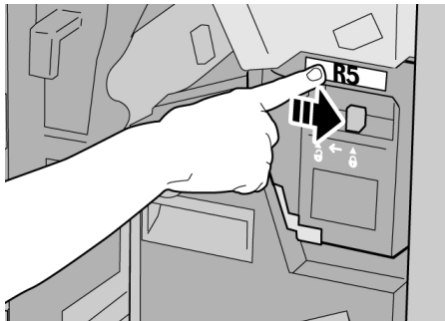
6. Hold the new staple waste container by the **R5** handle area and push it into the machine.



Note

To prevent injury, do not put your fingers on top of the container.

7. Push **R5** until the lock lever moves to the locked position.



8. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

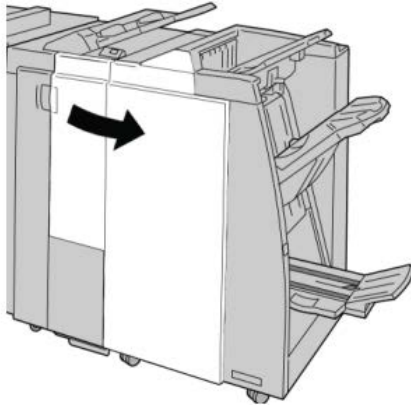
Empty the Punch Waste Container

The UI displays a message indicating when it is time to empty the Punch Waste Container.

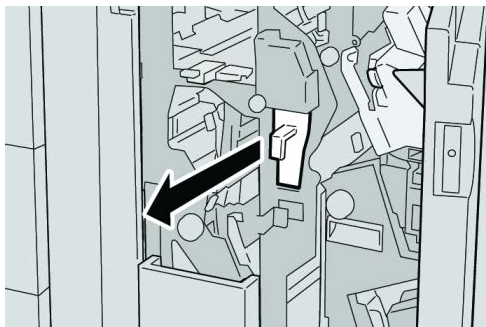
**Caution**

Only remove the Punch Waste Container while the system is powered ON. If you switch off the power when emptying the container, the machine cannot detect that the container was emptied.

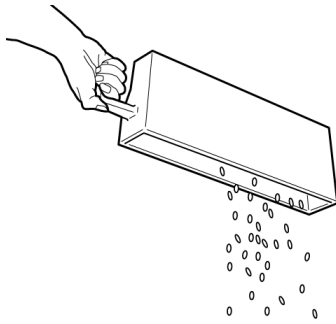
1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



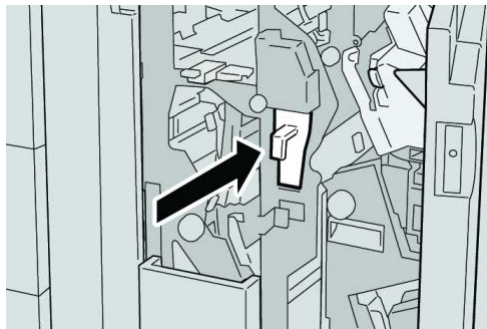
3. Pull the container out of the finisher (R4).



4. Discard all the punch scraps in an appropriate container.



5. Reinsert the empty container into the machine.



6. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

Finisher problem solving

Tip

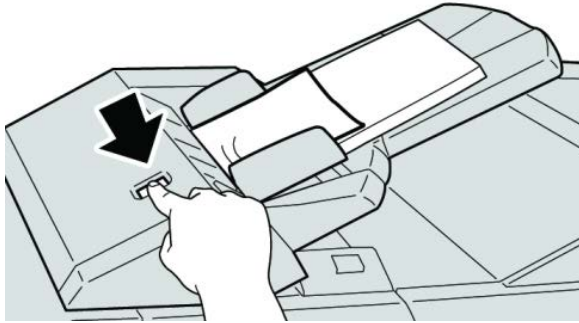
Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

Note

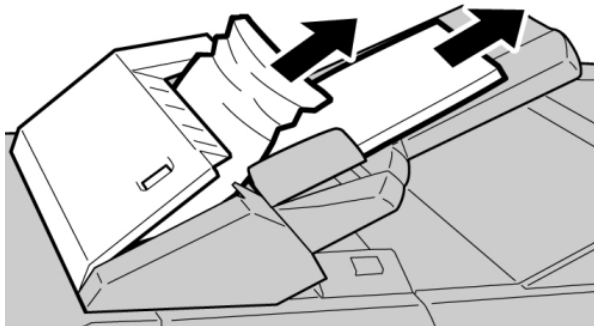
Remedies differ according to the paper jam location. Follow the instructions displayed to remove the jammed paper.

Paper jams in Tray 8/T1 (Post-Process Inserter)

1. Press the **Cover** button.



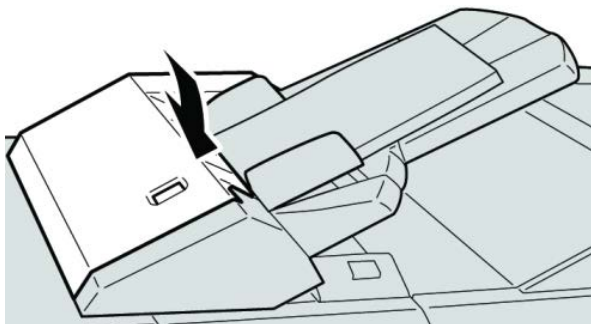
2. Open cover **1e** and then remove the jammed paper and all paper loaded in the tray.



Note

If paper is torn, check inside the machine and remove it.

3. Fan the paper you removed, making sure that all four corners are neatly aligned, and then load them again.
4. Push cover **1e** until you hear it click into place.

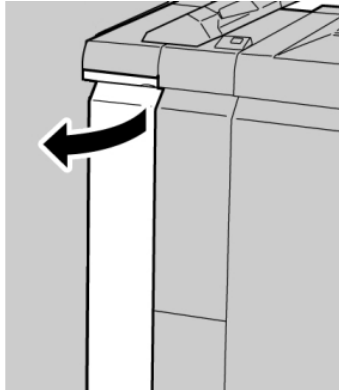


Note

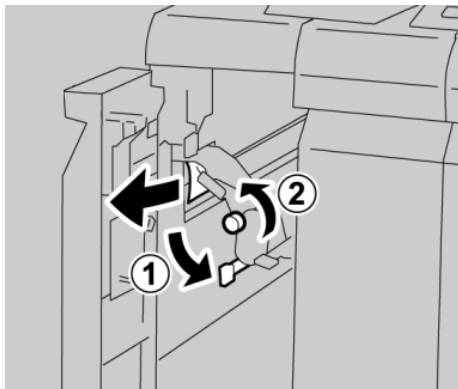
A message will be displayed and the machine will not operate if the cover is open even slightly.

Paper jams at lever 1a and knob 1c

1. Make sure that the machine has stopped printing.
2. Open the finisher left cover.



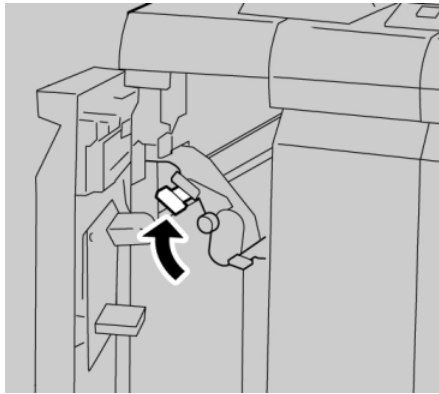
3. Move lever **1a** downwards and turn knob **1c** left. Remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

- Return lever **1a** to the original position.



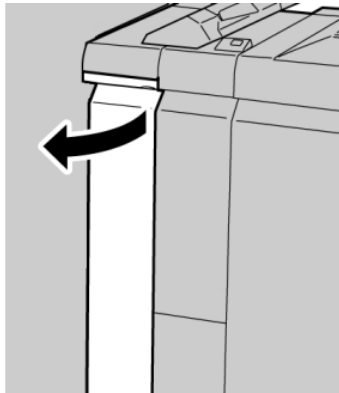
- Close the finisher left cover completely.

Note

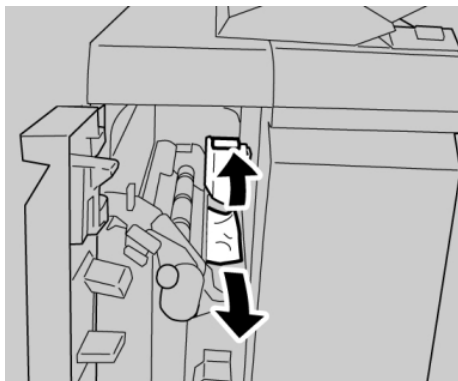
The machine will not operate if the cover is open even slightly.

Paper jams at lever 1d

- Make sure that the machine has stopped printing.
- Open the finisher left cover.



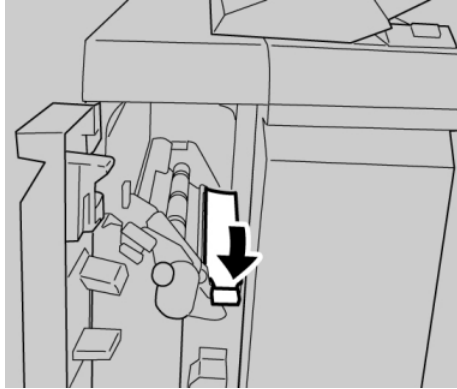
- Move lever **1d** upwards and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Move the lever **1d** to the original position.



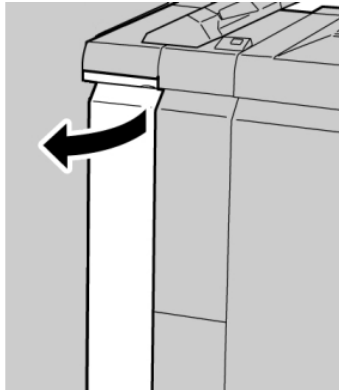
5. Close the finisher left cover completely.

Note

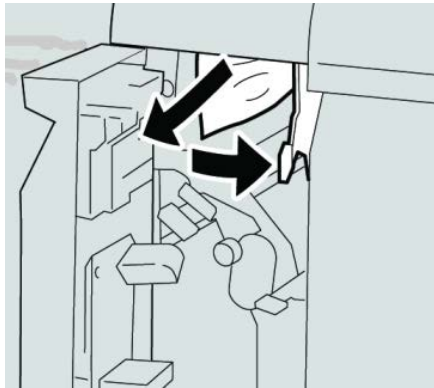
The machine will not operate if the cover is open even slightly.

Paper jams at lever 1b

1. Make sure that the machine has stopped printing.
2. Open the finisher left cover.



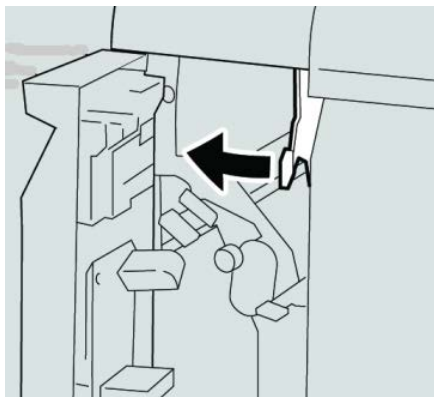
3. Move the lever **1b** to the right and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Move the lever **1b** to the original position.



5. Close the finisher left cover completely.

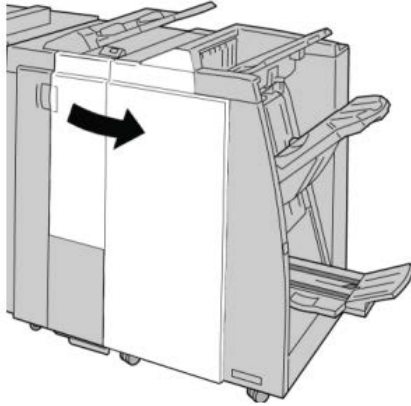
Note

The machine will not operate if the cover is open even slightly.

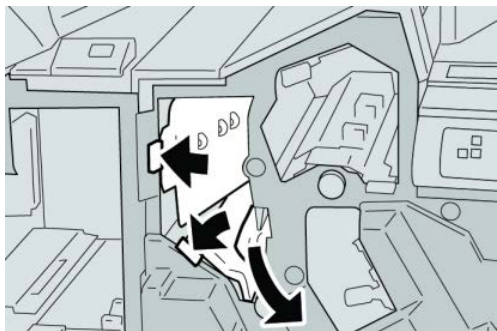
Paper jams at lever 3b and 3d

1. Make sure that the machine has stopped printing.

2. Open the Right Cover on the finisher.



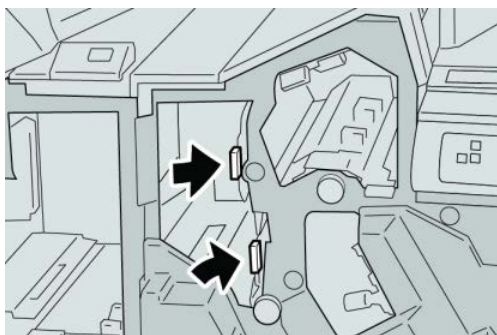
3. Move the levers **3b** and **3d**; remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the levers **3b** and **3d** to their original positions.



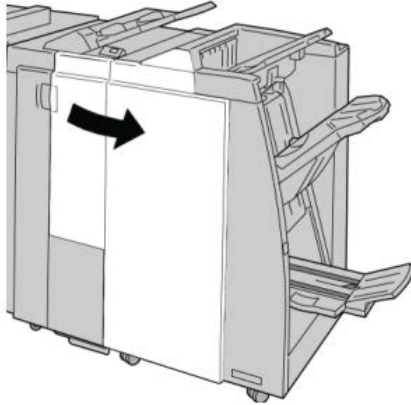
5. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams at lever 3e and knob 3c

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



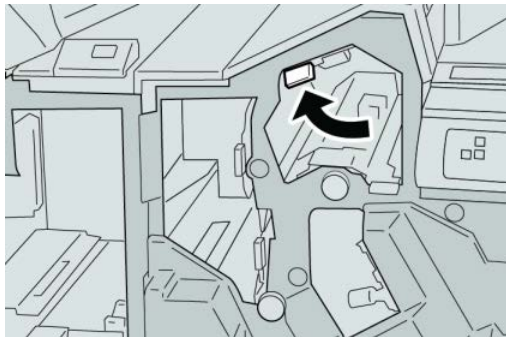
3. Move the lever 3e and turn the knob 3c; remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the lever 3e its original position.



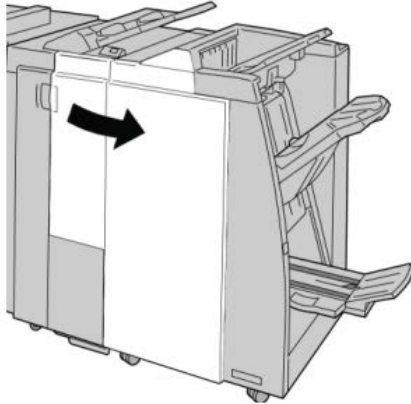
5. Close the Right Cover on the finisher.

Note

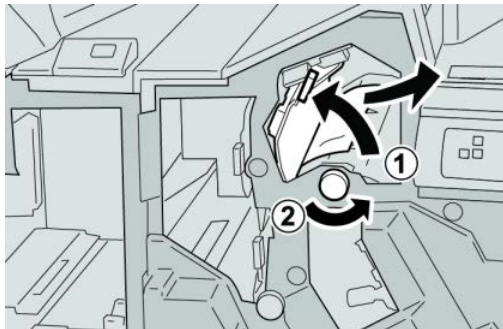
A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams at lever 3g and knob 3f

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



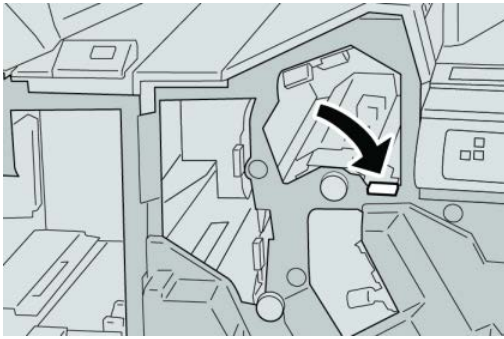
3. Move the lever **3g** and turn the knob **3f** and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the lever **3g** its original position.



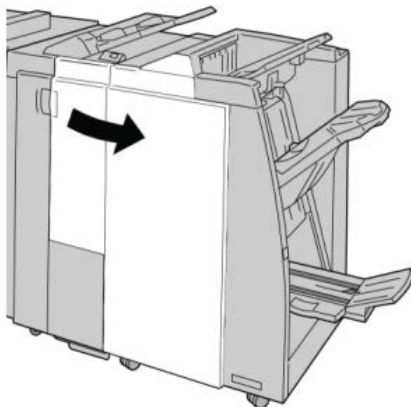
5. Close the Right Cover on the finisher.

Note

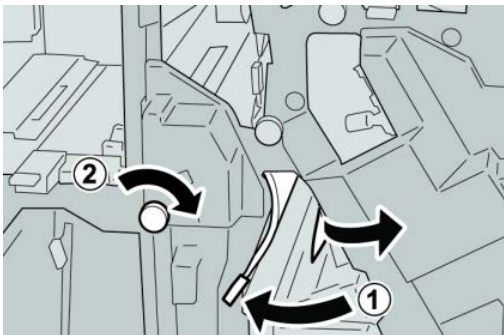
A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams at lever 4b and knob 3a

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



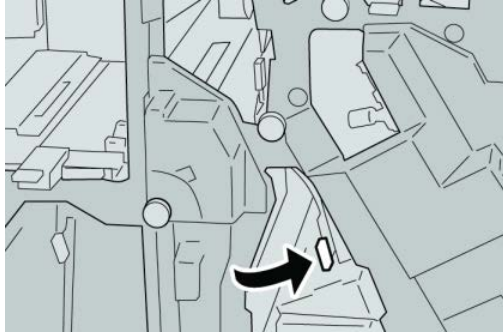
3. Move the lever **4b** and turn the knob **3a**; remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the lever **4b** its original position.



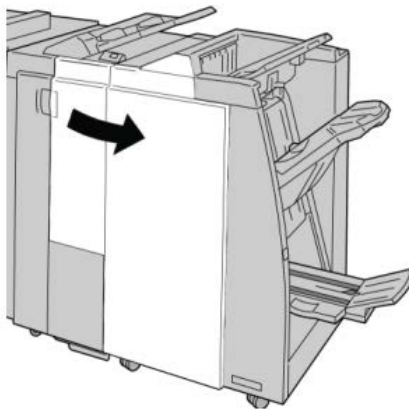
5. Close the Right Cover on the finisher.

Note

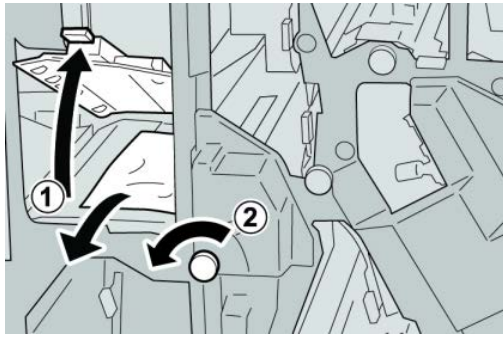
A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams at lever 2a and knob 3a

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



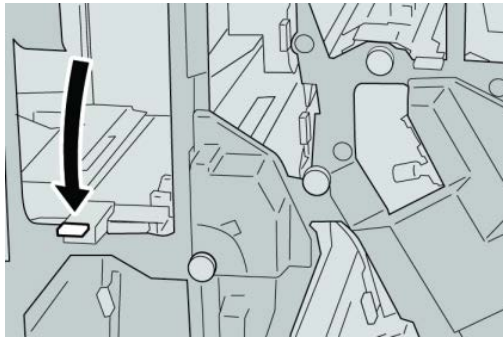
3. Move the lever **2a** and turn the knob **3a**; remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the lever **2a** to its original position.



5. Close the Right Cover on the finisher.

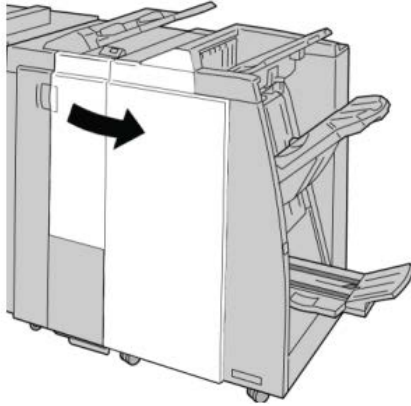
Note

A message will display and the machine will not operate if the right cover is open even slightly.

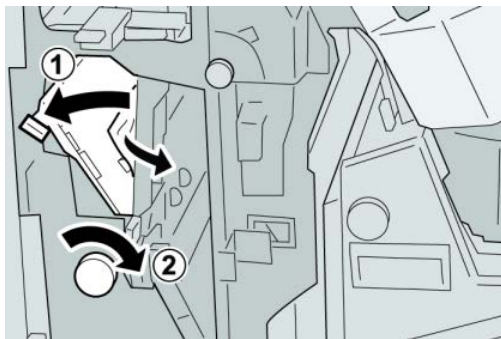
Paper jams at lever 2b and knob 2c

1. Make sure that the machine has stopped printing.

2. Open the Right Cover on the finisher.



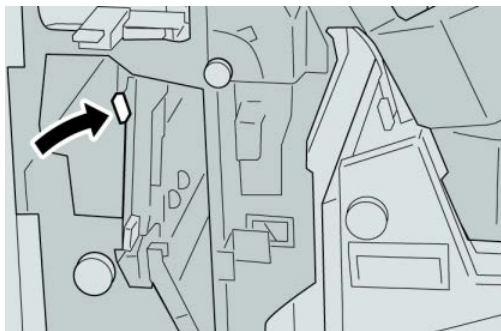
3. Move the lever **2b** and turn the knob **2c**; remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the lever **2b** to its original position.



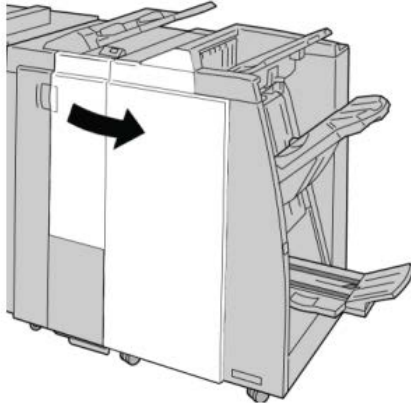
5. Close the Right Cover on the finisher.

Note

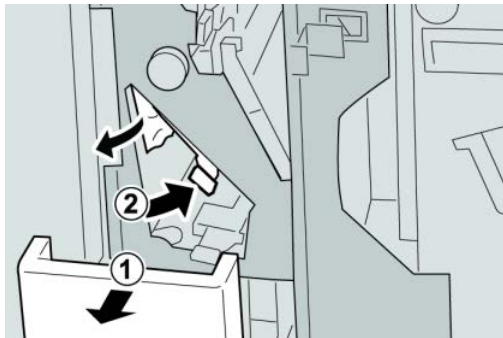
A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams at 2c, 2e, 2f, and 2d

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



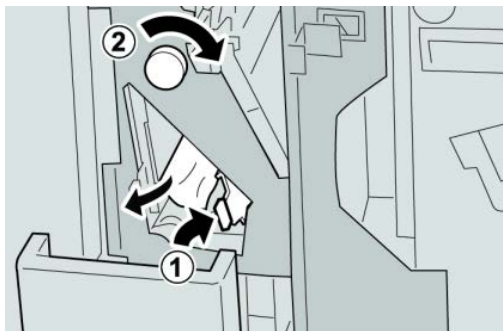
3. Pull out the folder output tray (**2d**), swing lever **2e/2f** to the right, and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

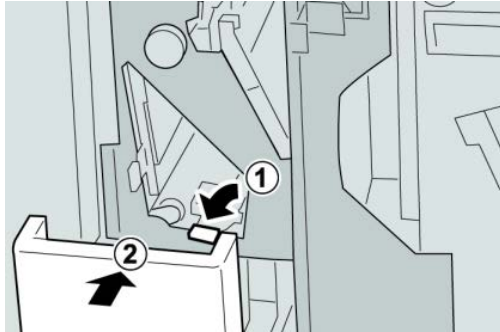
4. If you cannot remove the paper, return the lever **2e/2f** to its original position. Swing the lever **2e/2f**, turn the knob **2c** to the right, and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

5. Return the opened lever (**2f**) or (**2e**) to its original position, and close the output tray (**2d**).



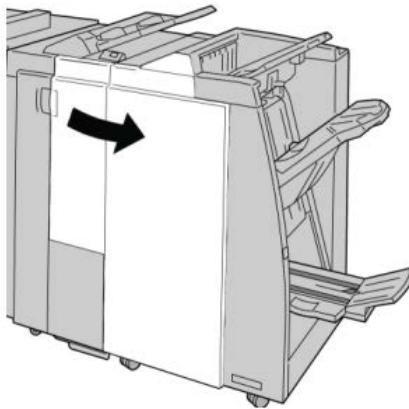
6. Close the Right Cover on the finisher.

Note

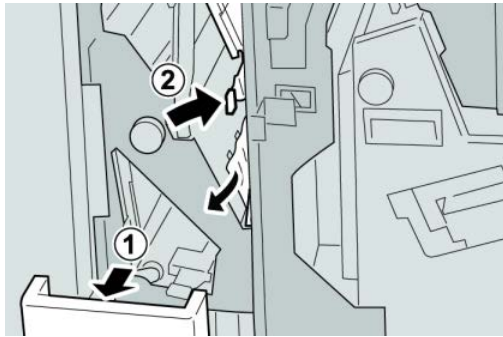
A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams at 2d and lever 2g

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



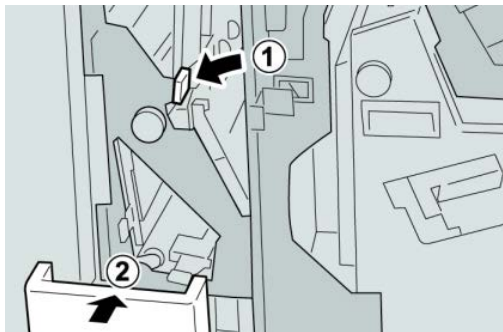
3. Pull out the folder output tray (**2d**), swing lever the **2g**, and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the opened lever (**2g**) to its original position, and close the output tray (**2d**).



5. Close the Right Cover on the finisher.

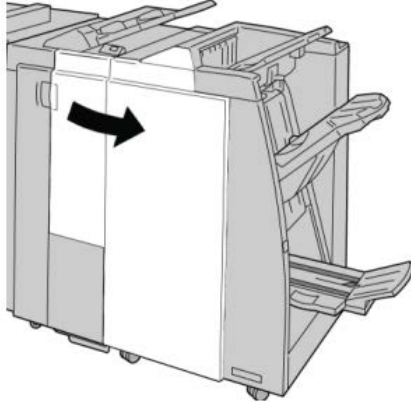
Note

A message will display and the machine will not operate if the right cover is open even slightly.

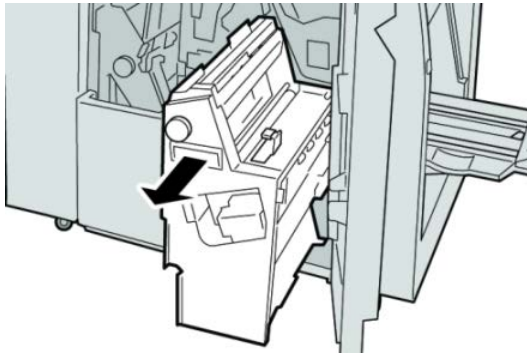
Paper jams at unit 4 and knob 4a

1. Make sure that the machine has stopped printing.

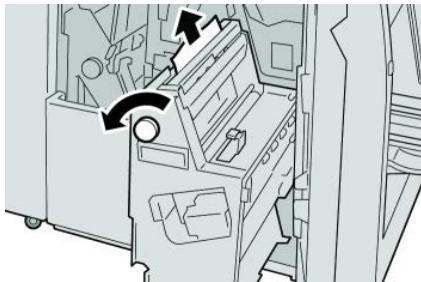
2. Open the Right Cover on the finisher.



3. Pull out unit 4.



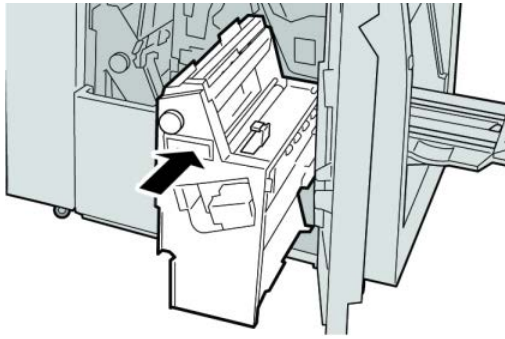
4. Turn the knob 4a to remove the jammed paper from the left side of unit 4.



Note

If paper is torn, check inside the machine and remove it.

5. Return unit **4** to its original position.



6. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams at finisher top tray

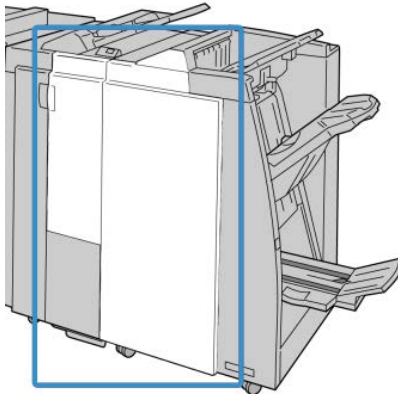
1. Make sure that the machine has stopped printing.
2. Remove jammed paper from the finisher top tray.



Note

If paper is torn, check inside the machine and remove it.

3. Open and close the finisher right cover.

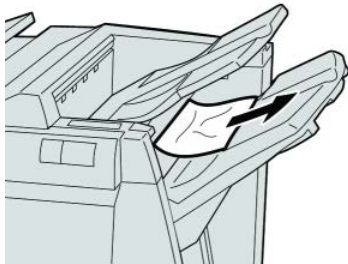


Note

The machine will not operate if the cover is open even slightly.

Paper jams at finisher stacker tray

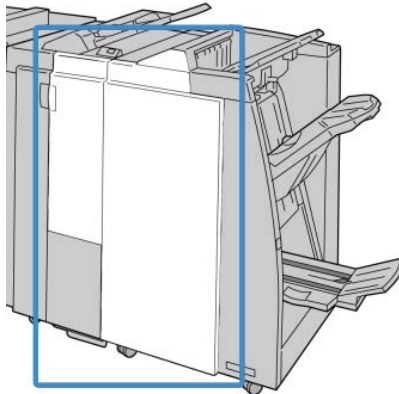
1. Make sure that the machine has stopped printing.
2. Remove jammed paper from the finisher stacker tray.



Note

If paper is torn, check inside the machine and remove it.

3. Open and close the finisher right cover.

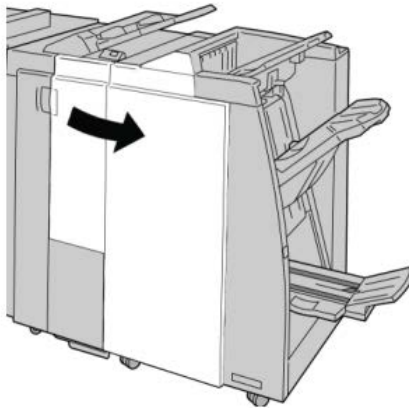


Note

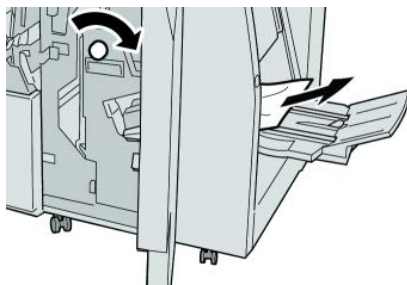
The machine will not operate if the cover is open even slightly.

Paper jams at the optional booklet maker tray

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



3. Turn knob **4a** and remove any jammed paper from the optional booklet maker tray.



Note

If paper is torn, check inside the machine and remove it.

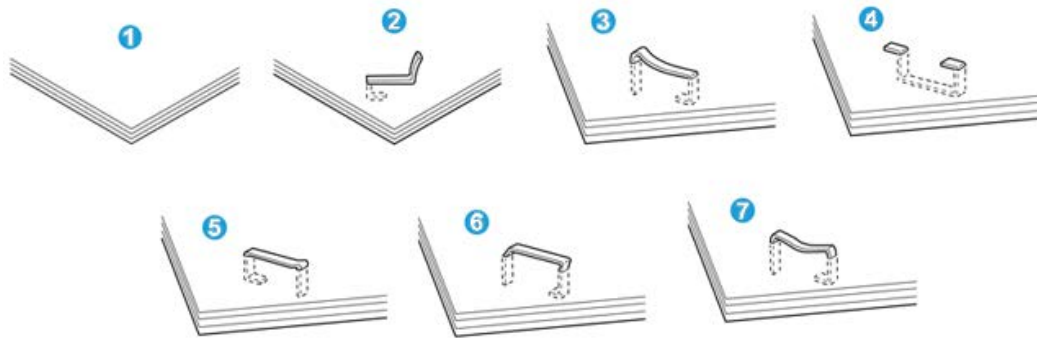
4. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

Stapler faults

Follow the procedures provided when the output is not stapled or the staples are bent. Contact our Customer Support Center if the problem persists after you have tried the following solutions. Stapler faults on output may look similar to the ones shown in the following illustration.



1. No staple
2. Bent staple
3. One side of staple rising up
4. Staple bent in reverse direction
5. Flattened staple
6. Entire staple rising up
7. Staple rising up with center pressed in

If the output is stapled as shown in the figure above, contact our Customer Support Center.

Note

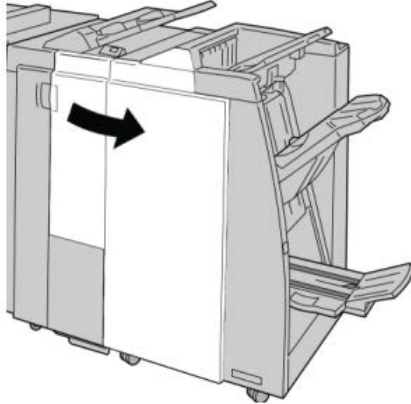
Depending on the type of paper that is being stapled, the stapled nails may be bent. If the bent nails are stuck inside the machine, they may eventually cause paper jams. Remove the bent staple when opening the staple cartridge cover. If you do not remove the bent staple, a staple jam may occur as a result. Use the staple cartridge cover only when removing the bent staple.

Staple jams in the standard staple cartridge

Note

Always check inside the finisher for any individual staples or staple remnants.

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



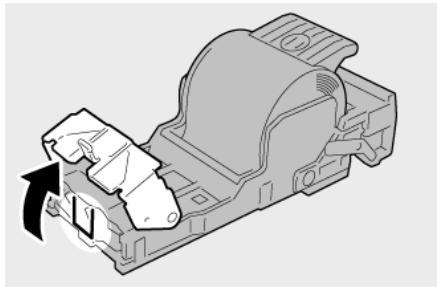
3. Grasp the Staple Cartridge handle located at **R1**, and pull out the staple cartridge from the finisher.



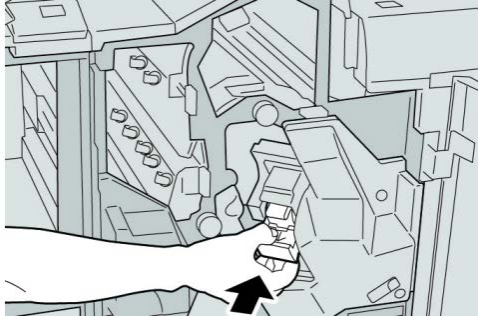
4. Check the inside of the finisher for any remaining staples, and if necessary, remove them.
5. Open the staple cartridge unit as shown and remove the jammed staple.

Warning

To avoid injury to your fingers, carefully remove the jammed staples from the cartridge.



6. Reinstall the cartridge unit to its original position in the finisher.



7. Close the Right Cover on the finisher.

Note

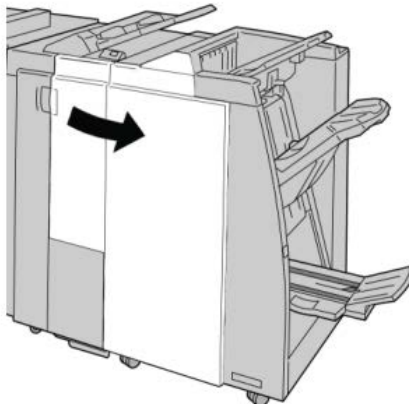
A message will display and the machine will not operate if the right cover is open even slightly.

Staple jams in the booklet maker cartridge

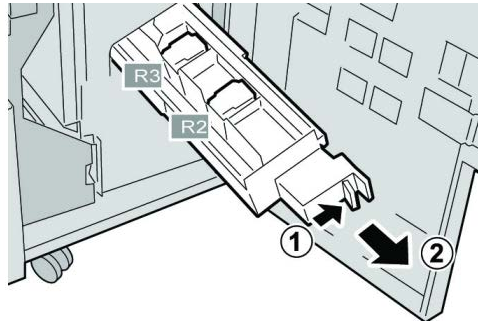
Note

Always check inside the finisher for any individual staples or staple remnants.

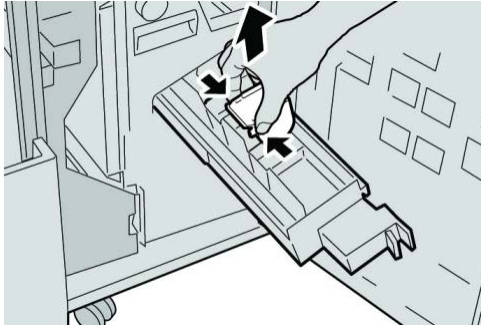
1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



3. While pressing the lever to the right, pull out the booklet staple cartridge unit.



4. Hold the tabs of the staple cartridge unit by the tabs and lift to remove it.

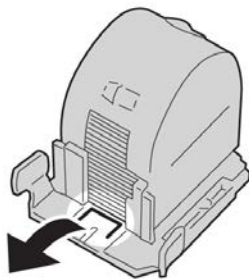


5. Remove the jammed staples from the cartridge.

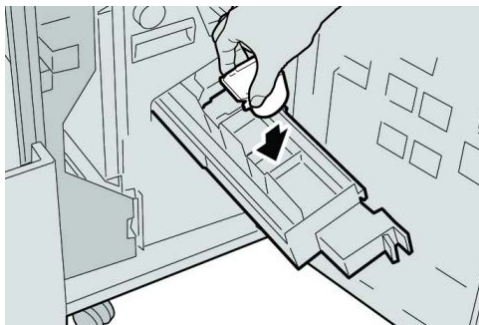


Warning

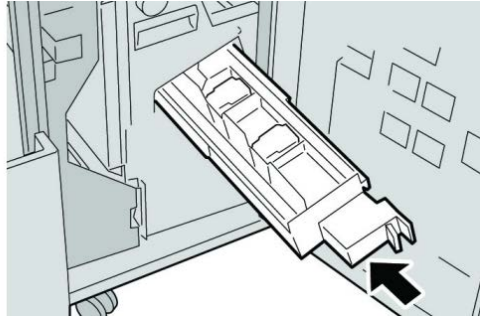
To avoid injury to your fingers, carefully remove the jammed staples from the cartridge.



6. While holding the tabs of a new staple cartridge, push it into the unit.



7. Push the staple cartridge unit to its original position in the machine.



8. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

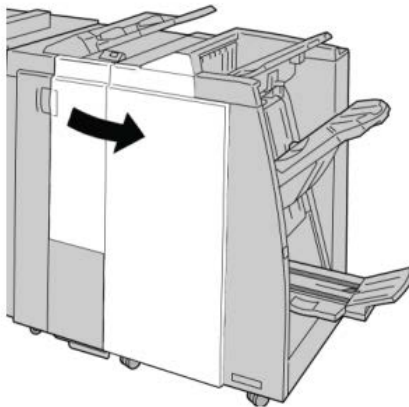
Reinserting the standard staple cartridge

Use this procedure if the standard staple cartridge is inserted incorrectly into the machine.

Note

Always check inside the finisher for any individual staples or staple remnants.

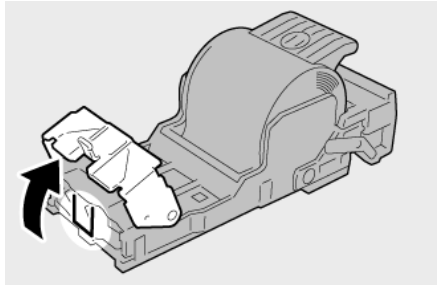
1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



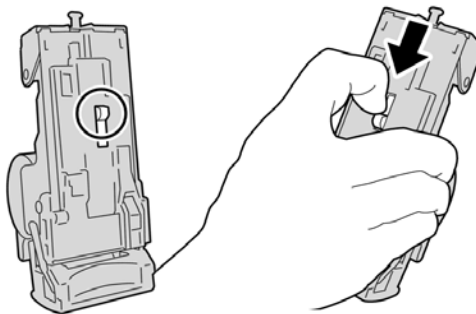
3. Grasp the Staple Cartridge handle located at **R1**, and pull out the staple cartridge from the finisher.



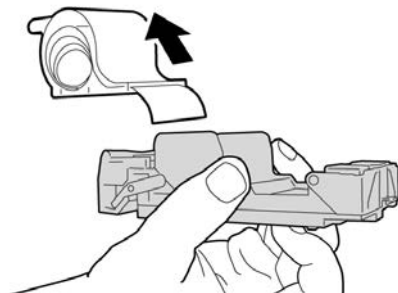
4. If necessary, the staple cartridge unit as shown and remove the jammed staple.



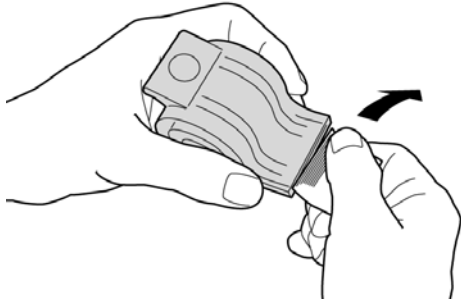
5. Move the lever on the rear of the staple cartridge unit in the downward direction.



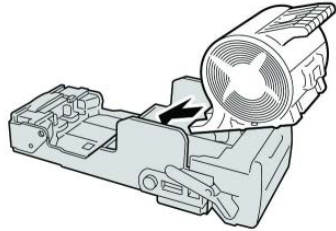
6. While holding the lever down, turn over the unit and remove the staple cartridge from the unit.



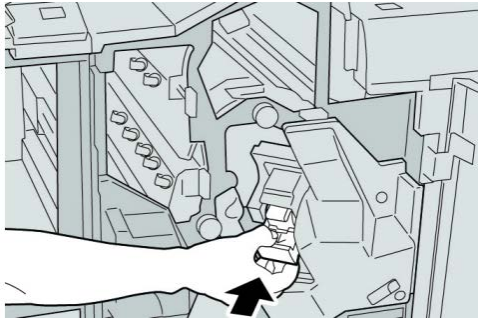
7. Detach the outside staples along the line.



8. Push a new staple cartridge into the unit.



9. Reinstall the cartridge unit to its original position in the finisher.



10. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

Fault codes

If an error caused the printing to end abnormally, or a malfunction occurred in the Booklet Maker Finisher, then an error code is displayed.

If an error code appears that is not listed in the table below, or if an error persists after following the listed solution, then contact your Xerox Customer Support Center.

If an error code is displayed, all print data of the machine as well as print data stored in the machine's built-in memory is discarded.

Fault code	Possible cause	Recommended solution
012 125, 012 132, 012 211, 012 212, 012 213, 012 214, 012 215, 012 216, 012 217, 012 218, 012 219, 012 221, 012 223, 012 225, 012 226, 012 227, 012 228, 012 229, 012 230, 012 235, 012 236, 012 237, 012 238, 012 239, 012 240, 012 241, 012 243, 012 246, 012 247, 012 248, 012 250, 012 251, 012 252, 012 253, 012 254, 012 255, 012 260, 012 263, 012 264, 012 265, 012 282, 012 283, 012 291, 012 296	The Finisher malfunctioned	- Check for any obstructions in the paper path and clear them. - Power Off/On the machine, and if necessary, resend/restart your print job. If the error persists, contact the Customer Support Center.
012 400	Staple Waste Container near full	Follow the procedures to remove and replace the staple waste container in the finisher.
012 949	Finisher Puncher Waste Container is not attached	Check that the punch waste container is installed in the finisher and inserted correctly.
024 931	The Staple Waste Container is full or near full	Remove the Staple Waste Container and reinstall a new one.
024 932	The Staple Waste Container is not attached	Check that the Staple Waste Container is installed in the finisher and inserted correctly.
024 943	The booklet staple cartridge is empty or stapling error occurred.	Check the staple cartridge and reset correctly. If necessary, replace with a new cartridge. Resume job.
024 957	Insertor trays are empty/out of paper	Add paper to the paper trays of the Insertor.
024 974	Designated paper size and the size of paper in the tray differs when feeding paper	Reset the paper or cancel the job.
024 976	Finisher staple fault	Check staples and reset correctly.
024 977	Finisher staple feeding is not ready	Check staples and reset correctly.
024 978	Booklet Finisher staple operation is not ready	Check staples and reset correctly.

Standard/Booklet Maker Finisher
(continued)

Fault code	Possible cause	Recommended solution
024 979	The staple cartridge is empty	Check staples. Follow procedures to remove and replace staple cartridge.
024 980	The finisher stacker tray is full	Remove all paper from the stacker tray.
024 981	The finisher top tray is full	Remove all paper from the finisher top tray.
024 982	The finisher stacker tray lower safety warning in on	Remove all paper from the stacker tray and remove any other obstructions.
024 983	The finisher booklet tray is full	Remove all paper from the booklet tray.
024 984	The booklet stapler low staple F signal is on	Remove all paper from the booklet tray.
024 985	The booklet stapler low staple R signal is on	Remove all paper from the booklet tray.
024 987	The booklet folder tray is full	Remove all paper from the tray. Set the output tray for three fold.
024 988	The booklet folder tray is full	Check that the folder tray is correctly attached and set.
024 989	There is a problem with the booklet maker stapler	Check the staple cartridge and reset correctly.
047 320	A communication error has occurred with the Finisher	Power Off/On the machine. If the error persists, contact the Customer Support Center.
112 700	Punch Waste Container is full or near full	Remove and empty the waste container and reinstall.
116 790	The settings for stapling are canceled and prints the data	Confirm the staple position and try to print again.
124 705	The settings for punching are canceled	Confirm the punching position and try to print again.
124 706	The settings for folding are canceled	Confirm the folding settings and try to print again.
124 709	The number of pages exceeds the number of pages that can be stapled	Decrease the number of pages, or cancel the stapling settings, then try to print again.

Specifications

Standard/Booklet Maker Finisher

Item	Specification
Tray Type	- Top Tray: Collated/Uncollated Note Transparencies can be sent to the TOP tray of the finisher ONLY. Transparencies cannot be sent to the stacker (middle) tray. - Stacker (middle) Tray: Collated/Uncollated (Offset available)
Supported Paper Size	Top Tray: - Maximum: SRA3, 13 x19 in., 12.6 x19.2 in., 330 x 488 mm (custom size) - Minimum: 100 x 148 mm (SEF), 4 x 6 in. (SEF), A6 (SEF) postcards Stacker (middle) Tray: - Maximum: 13 x 19 in. (330 x 488 mm), SRA3 - Minimum: B5, Executive (7.25 x 10.5 in.) Optional C/Z Folder tray: Supports A4 (SEF) and 8.5 x 11 in. (SEF) Delivery to a supported third-party, DFA device: - Maximum: 13 x 19 in., SRA3 - Minimum: B5, Executive (7.25 x 10.5 in.)
Supported Paper Weight	Trays: - Top Tray: 55-350 gsm - Stacker (middle) Tray: 55-300 gsm - Optional C/Z Folder tray: 64-90 gsm Delivery to a supported third-party, DFA device: 55-350 gsm
Tray Capacity	- Top Tray: 500 sheets - Optional C/Z Folder tray: Minimum 30 sheets *When using A4 LEF, B5 LEF, 8.5 x 11 in. LEF, 8 x 10 in. LEF, 7.5 x 10.5 in. LEF only. When using paper of other sizes, tray capacity is 1,500 sheets and 100 sets. **Tray may not support some paper types.

(continued)

Item	Specification
Stapling (variable length)	Maximum staple sheets: 100 sheets • When using paper of size larger than A4 or 8.5 x 11 in., the maximum number of sheets that can be stapled is 65. • Staple nails may bend when using certain paper types. Paper size: • Maximum: A3/11 x 17 in. • Minimum: B5, Executive (7.25 x 10.5 in.) Staple position: • 1 location: (front: angled stapling, center: parallel stapling, back: parallel stapling*) • 2 locations: (parallel stapling) • 4 locations: A4 (LEF) and 8.5 x 11 in. (LEF) parallel staplin *: Angled stapling for A3 and A4
Hole Punching	Supported paper size: • Maximum: A3/11 x 17 in. • Minimum: B5 LEF (2 holes), A4 LEF (4 holes) Number of holes: 2, 4, 3 (optional) Paper type: 55-220 gsm

(continued)

Item	Specification
Booklet Creation/Single Fold	Maximum number of sheets: • Fold and Staple: 25 sheets • Fold only: 5 sheets When using Xerox 20 lb./75 gsm paper, only 14 sheets can be stapled if adding a cover. Paper size: • Maximum: A3, 13 x 18 in. • Minimum: A4 SEF, 8.5 x 11 in. SEF Note When using light-weight stocks, media jams may occur with Booklet Creation, Single Fold, and stapling for output that is 25 sheets or more. If media jams do occur, it is recommended that a different media type is selected for the job. Paper type: Fold only or Fold and Staple: 55-350gsm uncoated, 106-300gsm coated Paper Weights/Booklet Capacity: • 64-80 gsm, Uncoated: 25 sheets • 81-90 gsm, Uncoated: 20 sheets • 91-105 gsm, Uncoated: 10 sheets • 106-128 gsm, Uncoated: 10 sheets, Coated: 10 sheets • 129-150 gsm, Uncoated: 10 sheets, Coated: 10 sheets • 151-176 gsm, Uncoated: 10 sheets, Coated: 10 sheets • 177-220 gsm, Uncoated: 5 sheets, Coated: 5 sheets • 221-256gsm, 4 sheets max. coated or uncoated • 257-350gsm, 3 sheets max, coated or uncoated
Folding	Note Non-stapled fold sets are limited to 5 sheets of paper.
Tray 8/T1 (Post-Process Inserter; also called Interposer)	Paper size: • Maximum: A3/11 x 17 in. • Minimum: B5, Executive (7.25 x 10.5 in.) The machine does not print on paper loaded in Tray 8/T1. Capacity: 200 sheets when using Xerox 20 lb./75 gsm paper. Paper type: 64-220 gsm

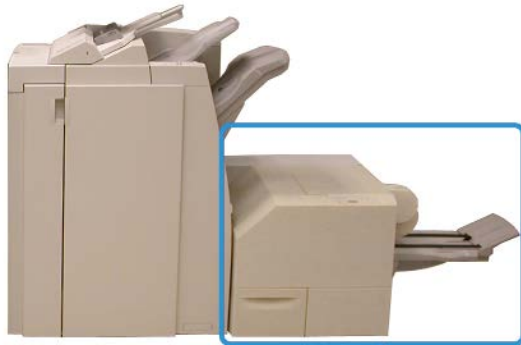
Optional C/Z Folder

Item	Specification
Z-Fold Half Sheet	• Z-paper size: 11 x 17 in./A3, 10 x 14 in./B4, 8K • Capacity: - Maximum: 80 sheets (A3/11 x 17 in. Xerox 20 lb./75 gsm paper Z folding) - 20 sheets for 8K and 10 x 14 in./B4 • Paper type: 16-24 lb./64-90 gsm • Output tray: Stacker (middle) tray
C-Fold Z-Fold	• Paper size: A4/8.5 x 11 in. • Number of sheets to be folded: 1 sheet • Capacity: Minimum 30 sheets (When using Xerox 20 lb./75 gsm paper.) • Paper type: 16-24 lb./64-90 gsm • Output tray: C/Z Folder tray
Single Fold	Refer to Booklet Creation/Single Fold specifications for more information

SquareFold Trimmer Module

Overview

The SquareFold Trimmer Module is an optional finishing device that is used in conjunction with another optional finishing device that contains a booklet maker.



Note

The SquareFold Trimmer Module requires a finisher with a booklet maker attached.

The SquareFold Trimmer Module:

- Receives the booklet from the booklet maker area of the finisher
- Flattens the booklet spine, thereby reducing the booklet's thickness and giving it the appearance of a perfect-bound book
- Trims/cuts away the face (edge) of the booklet, resulting in a neat finished edge

The booklet is assembled and stapled in the booklet area of the finisher; therefore, the booklet enters the SquareFold Trimmer Module already assembled. Any adjustments to the image of the original and its placement on the booklet page must be done from the machine UI, your print driver, or from the print server.

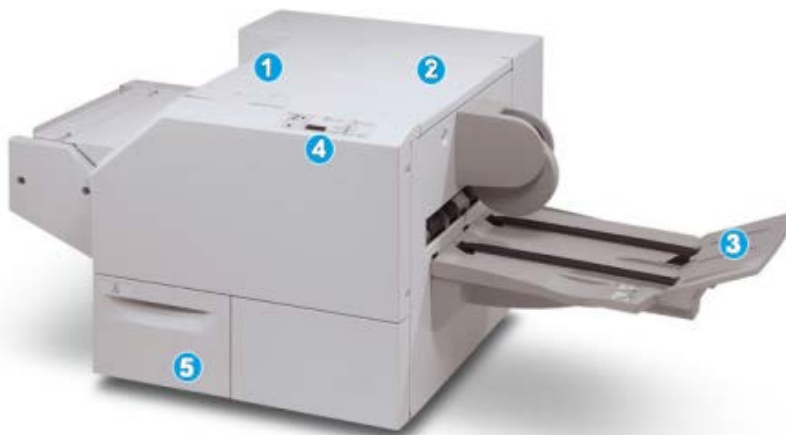
Note

Always refer to the SquareFold Trimmer Module Hints and Tips section before using the SquareFold Trimmer Module. The hints and tips section provides valuable information about setting up your jobs, which in turn ensures the best possible output for your print/copy jobs.

You may want to run one or more test prints/copies before running larger jobs.

Identifying the components

Main components



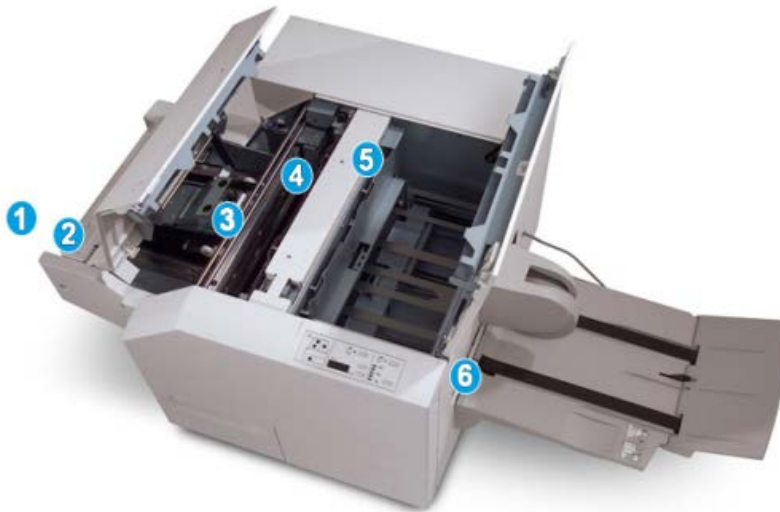
The main components consist of:

1. Top Left Cover: Open this cover to remove paper jams. The square fold mechanism is found in this area.
2. Top Right Cover: Open this cover to remove paper jams. The trimming mechanism is found in this area.
3. Booklet Output Tray: This tray receives square-fold booklet output from the finisher.
4. Control Panel: The Control Panel consists of a mimic display, buttons, and various indicator lights.
5. Trimmer Waste Container: Collects scrap/waste from the trimmer. Pull open to remove and dispose of trimmer waste scraps.

Note

The top covers cannot be opened during normal operation or when the machine is idle. The covers can be opened only when an indicator is lit and a jam/fault occurs within the SquareFold Trimmer Module.

Paper path

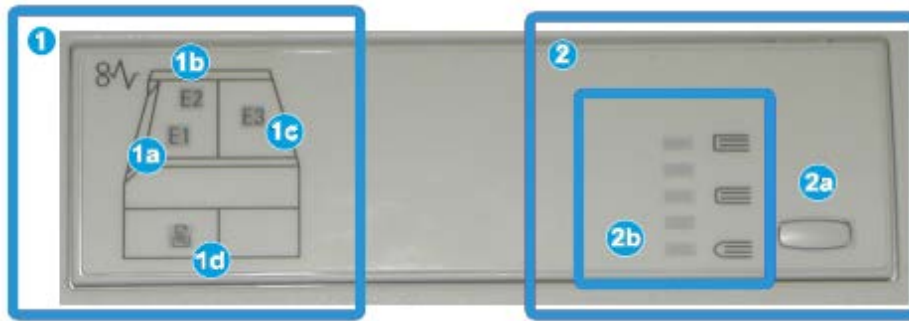


1. The booklet leaves the booklet area of the finisher and enters SquareFold Trimmer Module.
2. The Booklet Exit sensor (in the SquareFold Trimmer Module) detects the lead edge (spine) of booklet and moves the booklet to square fold area.
3. Once the booklet spine reaches the square fold area, the booklet is clamped and the square-folding operation begins.
4. The booklet is flattened and the spine squared according to the square-fold setting indicated on the control panel.
5. After the booklet is flattened and the spine squared, it is moved to the trimmer area.
 - a. Based on the finished booklet size, the booklet is moved until the trail edge reaches the trimmer cutter.
 - b. The trail edge is trimmed/cut (based on the finished booklet size entered for the Trimmer Mode Setting).
6. The booklet then moves to the exit area where it is transported to the Booklet Output Tray.

Note

Booklets exiting/leaving the SquareFold Trimmer Module may contain trim remnants/scraps from the previously trimmed booklet. This is due to static electricity build-up and is normal. If booklets contain trim remnants/scraps, simply remove and discard them.

Control panel



The control panel consists of the following:

1. Fault indicators: These indicators light when a fault or jam occurs in a particular area of the SquareFold Trimmer Module.
 - a. This indicator lights when a jam occurs as the booklet is leaving the exit area of the finisher.
 - b. This indicator lights when a jam occurs in the square fold area.
 - c. This indicator lights when a jam occurs in the trimmer area.

Note

If one of these indicators (1a, 1b, 1c) is lit, the top covers can be opened, and the jam/fault cleared; otherwise, during normal operation or when the machine is idle, the top covers cannot be opened.

- d. This indicator lights when the Trimmer Waste Container is pulled out or when it is full.
2. Square Fold options: This area of the control panel contains the following:

Note

The Square Fold options are available from your computer print driver, from your print server, or from your machine UI (if it is a copier/printer). This is discussed in more detail in the section entitled Square Fold options.

- a. Settings button: Press this button to adjust the Square Fold setting; refer to the next item.
- b. Square Fold options: Select the desired setting; these settings are discussed in more detail in the section entitled "Square Fold options."

Square Fold feature

The Square Fold feature can be selected/accessed from your computer print driver, the machine UI, or from the print server.

Note

The Square Fold feature is available only when your machine is connected to both a finisher with a booklet maker and the SquareFold Trimmer Module.

Note

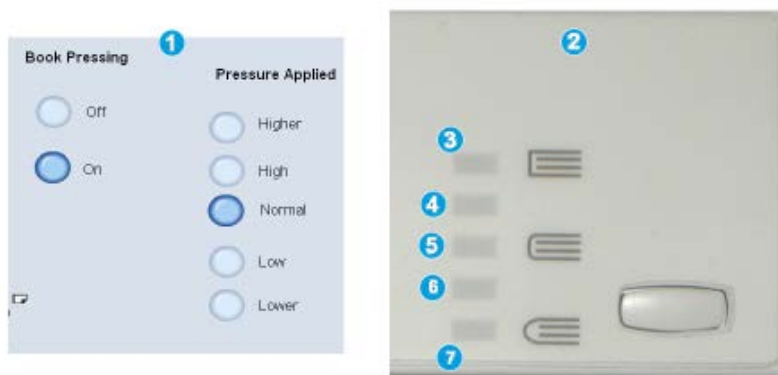
The term Book Pressing is used synonymously with the terms Square Fold or Square Folding.

Square fold options

The Square Fold (Book Pressing) feature can be switched on or off based on user preference. When the feature is switched on, you can select one of five options depending on your requirements for the finished booklet job.

Note

For the remainder of this section, the SquareFold Trimmer Module Control Panel and the machine UI screens are shown. The individual print server and print driver screens are not shown. The descriptions given for each of the Square Fold options are applicable for network print jobs and apply to any print server/print driver connected to the machine.



1. Square Fold/Book Pressing options on the machine UI; the illustration shown is a representation only. The actual images on the machine UI may vary depending on the machine to which it is connected.
2. SquareFold Trimmer Module control panel
3. **+2/Higher/High 2:** Use this setting when you want the most amount of pressure applied to the spine of the booklet. The more pressure applied to the booklet, the more square the booklet spine will be. +2 is the greatest amount of pressure that can be applied to the booklet.

Additionally, you may want to select this setting when your finished booklet is five pages or less and on heavier weight paper (200 gsm or greater).

4. **+1/High/High 1:** Use this setting when you want a greater amount of pressure applied to the spine of the booklet, but not as much pressure as the +2 setting uses.
5. **Auto/Normal:** This is the machine default setting and is used for most jobs.

6. **-1/Low/Low 1:** Use this setting when you want less pressure applied to the spine of the booklet. The less pressure applied to the booklet, the more rounded the booklet spine will be.
7. **-2/Lower/Low 2:** Select this setting when your finished booklet is five pages or less and on lighter weight paper (100 gsm or lower). -2 is the least amount of pressure that can be applied to the booklet.

Choose the setting that best fits your needs for the booklet output.

Note

You may want to run one or more test prints before running larger jobs.

The following illustration shows two different booklets: one booklet which was square-folded and one booklet that was not square-folded.



1. This booklet was not square-folded. It has a more rounded, thicker appearance to the spine of the booklet.
2. This booklet was square-folded. The booklet spine is flattened and squared, giving it the appearance of a perfect-bound book.

Accessing the Square Fold options

For network print jobs, the Square Fold feature and its related options can be accessed either from your computer's print driver (before the job is submitted for printing or at the print server (after the job is submitted for printing). To access the Square Fold feature/options for network print jobs, perform the following:

1. For jobs being sent from your computer, continue to the next step.
 - For jobs already at the print server, continue to Step 3.
2. From your computer, open the desired job in its appropriate application (for example, Microsoft Word or Adobe Reader).
 - a) Select **File** and **Print**.
 - b) From the Print window, select the desired machine (with the SquareFold Trimmer Module attached to it), and then select **Properties** for that machine.

- c) Continue to Step 4.
3. From the print server, if applicable, open the Properties of the desired job:
 - a) Double click on the job (from either the Hold or Printed Jobs queues).
 - b) From the Properties window, go to the Finishing/Output tab.
 - c) Continue to the next step.
4. Ensure that the correct output tray is selected (Booklet Maker Tray).
5. If necessary, ensure that the correct Stapling/Finishing/Folding features are selected.
6. Select the desired Square Fold (Book Pressing) option.
7. Select **OK** to save selections and close any Properties windows.
8. Send the the job to the machine.

Trimmer feature

The Trimmer feature can be selected/accessed from your computer print driver, the machine UI, or from the print server.

Note

The Trimmer feature is available only when your machine is connected to both a finisher with a booklet maker and the SquareFold Trimmer Module.

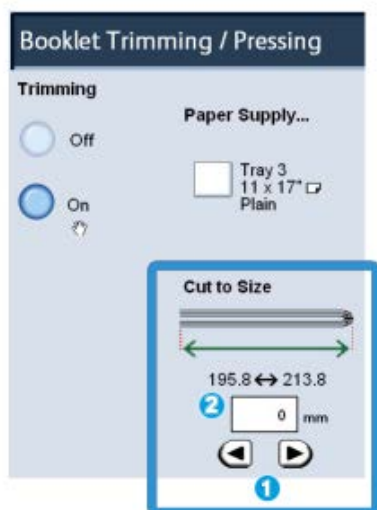
Trimmer options

When using the Trimmer options, always consider the following:

- Booklets exiting/leaving the SquareFold Trimmer Module may contain trim remnants/scraps from the previously trimmed booklet. This is due to static electricity build-up and is normal. If booklets contain trim remnants/scraps, simply remove and discard them.
- The Trimmer feature can be switched on or off based on user preference. When the feature is switched on, you can adjust the trim setting in 0.1 mm/0.0039 in. increments depending on your requirements for the finished booklet job.

Note

For the remainder of this section, the machine UI screen is shown. The individual print server and print driver screens are not shown. The descriptions given for each of the Trimmer options are applicable for network print jobs, and apply to any print server/print driver connected to the machine.



1. Select the arrow buttons to decrease or increase the trimmer setting. Adjustments are made in 0.1 mm/0.0039 in. increments.
2. The trimmer setting is based on:
 - The number of sheets in the finished booklet,
 - The finished booklet width size (such as 8.5 in./210 mm or 5.5 in./149 mm),
 - The media type (for example coated/uncoated, glossy), and
 - The media weight

Note

Important! You may have to experiment with various settings in order to determine the best settings for your particular job. Also, you may want to run one or more test prints before running larger jobs in order to ensure the best possible booklet output.

Note

Trim settings cannot be adjusted to remove less than 2 mm (0.078 in.) or more than 20 mm (0.787 in.) of edge material from the booklet. Adjustments less than 2 mm (0.078 in.) may produce poor trim quality, and adjustments greater 20 mm (0.078 in.) will result in no trimming to the booklet edge.

Choose the setting that best fits your needs for the booklet output.

Trim guidelines

The following table shows various scenarios using different paper weights, media types, and trim setting selections. Use this table as a guideline when selecting a trim setting for your specific job.

Note

The settings shown in the following table are provided as examples and are not meant to represent every possible job scenario; again, use this table as a guideline only.

Scenario number	Paper Size	Finished booklet size	Paper weight (lbs./gsm)	Approximate trim setting (mm)	Number of pages in finished booklet
1	8.5 x 11 in./A4 (210 x 298 mm)	5.5 x 8.5 in./149 x 210 mm	20 lbs./75 gsm	130	20
2	8.5 x 11 in./A4 (210 x 298 mm)	5.5 x 8.5 in./149 x 210 mm	24 lbs./90 gsm	125	14
3	8.5 x 11 in./A4 (210 x 298 mm)	5.5 x 8.5 in./149 x 210 mm	32 lbs./120 gsm	135	10
4	8.5 x 11 in./A4 (210 x 298 mm)	5.5 x 8.5 in./149 x 210 mm	20 lbs./75 gsm	125	10
5	8.5 x 11 in./A4 (210 x 298 mm)	5.5 x 8.5 in./149 x 210 mm	80 lbs./120 gsm	135	12
6	8.5 x 14 in./B4 (250 x 353 mm)	8.5 x 7 in./250 x 176.5 mm	20 lbs./75 gsm	172	6
7	8.5 x 14 in./B4 (250 x 353 mm)	8.5 x 7 in./250 x 176.5 mm	24 lbs./90 gsm	170	6
8	11 x 17 in./A3 (297 x 420 mm)	8.5 x 11 in./A4 (210 x 297 mm)	24 lbs./90 gsm	200	14
9	11 x 17 in./A3 (297 x 420 mm)	8.5 x 11 in./A4 (210 x 297 mm)	80 lbs./216 gsm	205	5
10	11 x 17 in./A3 (297 x 420 mm)	8.5 x 11 in./A4 (210 x 297 mm)	20 lbs./80 gsm	210	22
11	11 x 17 in./A3 (297 x 420 mm)	8.5 x 11 in./A4 (210 x 297 mm)	24 lbs./90 gsm	210	8
12	11 x 17 in./A3 (297 x 420 mm)	8.5 x 11 in./A4 (210 x 297 mm)	80 lbs./120 gsm	205	10
13	12 x 18 in./305 x 458 mm	6 x 9 in./152 x 229 mm	80 lbs./120 gsm	220	6
14	12 x 18 in./305 x 458 mm	6 x 9 in./152 x 229 mm	80 lbs./120 gsm	215	5
15	12 x 18 in./305 x 458 mm	6 x 9 in./152 x 229 mm	80 lbs./120 gsm	210	4
16	12 x 18 in./305 x 458 mm	6 x 9 in./152 x 229 mm	28 lbs./105 gsm	220	16
17	12 x 18 in./305 x 458 mm	6 x 9 in./152 x 229 mm	80 lbs./120 gsm	210	14

Accessing the Trimmer options

For network print jobs, the Trimmer feature and its related options can be accessed either from your computer's print driver (before the job is submitted for printing or at the print server (after the job is submitted for printing). To access the Trimmer feature/options for network print jobs, perform the following:

1. For jobs being sent from your computer, continue to the next step.
 - For jobs already at the print server, continue to Step 3.
2. From your computer, open the desired job in its appropriate application (for example, Microsoft Word or Adobe Reader).
 - a) Select **File** and **Print**.
 - b) From the Print window, select the desired machine (with the SquareFold Trimmer Module attached to it), and then select **Properties** for that machine.
 - c) Continue to Step 4.
3. From the print server, if applicable, open the Properties of the desired job:
 - a) Double click on the job (from either the Hold or Printed Jobs queues).
 - b) From the Properties window, go to the Finishing/Output tab.
 - c) Continue to the next step.
4. Ensure that the correct output tray is selected (Booklet Maker Tray).
5. If necessary, ensure that the correct Stapling/Finishing/Folding features are selected.
6. Select the desired Trimmer option.
7. Select **OK** to save selections and close any Properties windows.
8. Send the the job to the machine.

Hints and tips

Printing full-page images on booklets

When using full-page images, ensure that the finished booklet size accommodates any full-page images, and that when the booklet is trimmed, these images are not truncated. Refer to the illustration.



1. This booklet has preprinted front and back covers with a full-page image. It was printed on 8.5 x 14 in./B4 paper. The front cover, which was trimmed, displays the entire image.
2. This same booklet was printed on 8.5 x 11 in./A4 paper. The image on the front cover is truncated after trimming it.

Before you print any booklet job, you should consider your whole job, including the following:

- What is the desired size of the finished booklet?
- Does the booklet contain full-page images?
- Are you using preprinted covers with full-page images?
- Are you trimming the booklet?
- Do you need to shift any full-page images in order to ensure they fit on the finished booklet?

These are important questions which can affect the output of your booklet jobs, especially if you are using full-page images and trimming the booklet edges.

Follow these tips

Follow these tips to ensure you get your desired output:

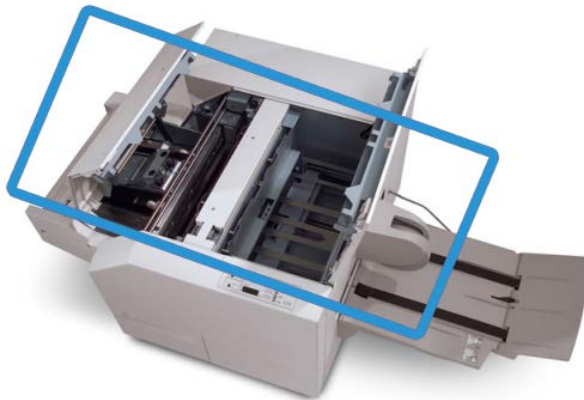
- Always run one or more test prints of your job before running a larger output quantity.
- Review your test prints for truncated images/text.
- If any images/text need shifting, use the various selections from your application's print driver; refer to your print driver's Help information.
- Remember: it may take one or more test prints before you achieve your desired output.

Problem solving

Jam clearance

Note

The top covers cannot be opened during normal operation or when the machine is idle. The covers can be opened only when an indicator is lit and a jam/fault occurs within the SquareFold Trimmer Module. For indicator details, refer to the control panel information earlier in this section.



The paper path is shown in the above illustration. Clear any paper jams that may occur along the paper path. If a jam occurs, the machine stops printing, and a message may be displayed on the User Interface (UI).

Note

To determine if the jam/fault is within the finisher or with the SquareFold Trimmer Module, always begin your troubleshooting with the SquareFold Trimmer Module.

Clearing jams

Use the following procedure to clear jams or faults and then resume printing:

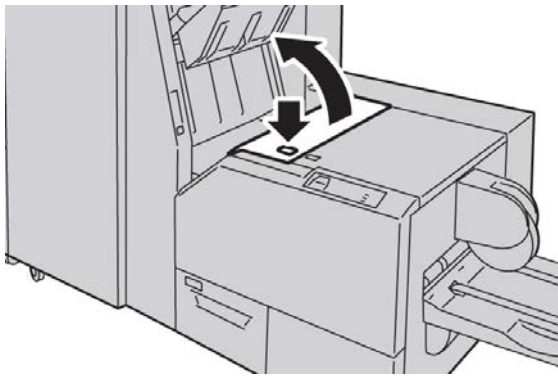
1. Follow the instructions displayed on the machine's UI.
2. If instructed by the machine's UI, open the Top Left Cover and the Top Right Cover of the SquareFold Trimmer Module.
3. Look for any jammed booklets within the SquareFold Trimmer Module paper path and remove them.
4. Check for loose trim scraps along the paper path and remove them.
5. Close the Top Left and Right Covers.
6. Empty the Trimmer Waste Container.
7. Ensure that the Trimmer Waste Container is completely pushed in/closed.

8. Ensure that all covers on the SquareFold Trimmer Module are closed.
9. If the SquareFold Trimmer Module Control Panel and/or the machine's UI indicate there is still a jam, recheck the SquareFold Trimmer Module (steps 1-8).
10. If necessary, open the finisher to look for jams/faults along the finisher path.
11. Follow the instructions displayed on the machine UI to resume printing.

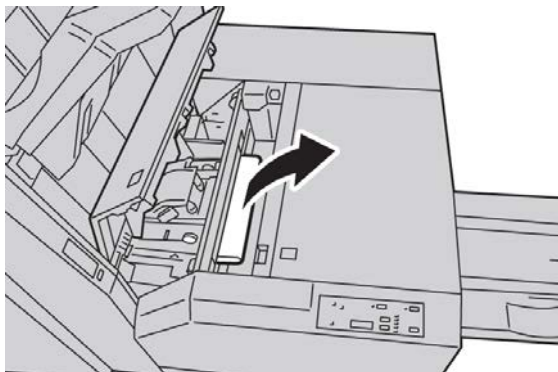
Clearing E1/E2 jams

Use the following procedure to clear jams when the E1 and/or E2 LED is lit on the SquareFold Trimmer Module control panel.

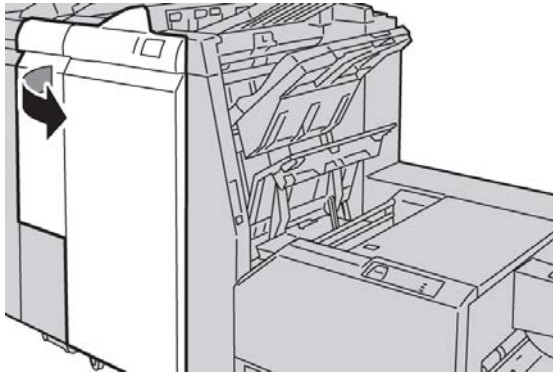
1. Make sure that the machine is not in operation, and press the button on the left cover of the Trimmer unit to open the cover.



2. Remove the jammed paper.



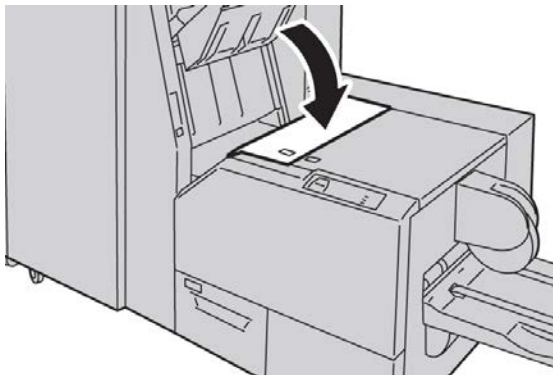
3. If you cannot remove the paper in Step 2, open the right cover of the finisher.



4. Turn the knob 4a to the right, and then remove the jammed paper.



5. Close the left cover of the Trimmer unit.



6. If you opened the right cover of the finisher in Step 3, close the cover.

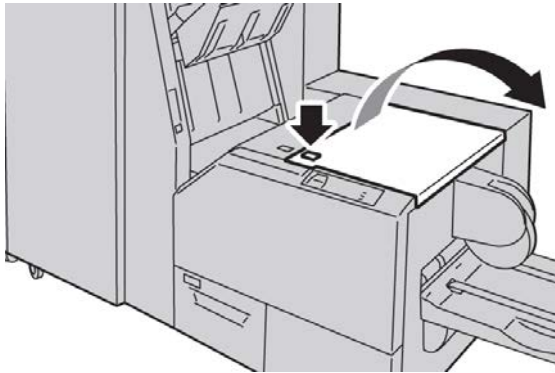
Note

A message will be displayed and the machine will not operate if the right cover of the finisher is even slightly open.

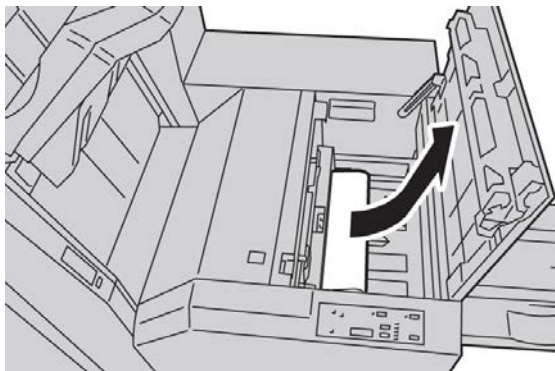
Clearing E3 jams

Use the following procedure to clear jams when the E3 LED is lit on the SquareFold Trimmer Module control panel.

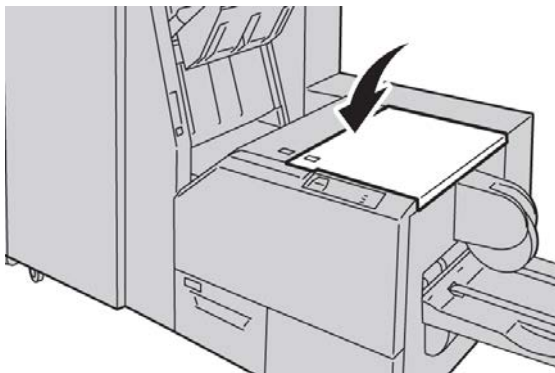
1. Make sure that the machine is not in operation, and press the button on the right cover of the Trimmer unit to open the cover.



2. Remove the jammed paper.



3. Close the right cover of the Trimmer unit.



Fault codes

If a jam/fault occurs in the SquareFold Trimmer Module, the machine's UI displays a jam/fault message. The following table provides a list of fault codes for the SquareFold Trimmer Module and a list of related finisher fault codes.

Note

The top covers cannot be opened during normal operation or when the machine is idle. The covers can be opened only when an indicator is lit and a jam/fault occurs within the SquareFold Trimmer Module. For indicator details, refer to the control panel information earlier in this section.

Fault code	Possible cause	Recommended solution
013-100 013-101 013-102 013-103 013-104 013-105 013-106 013-303 013-915 013-916 013-917 013-918 013-919	Jam/fault with the SquareFold Trimmer Module	1. Open the Top Left and Right Covers of the SquareFold Trimmer Module. 2. Carefully remove all sheets and paper scraps from jam clearance areas. 3. Close the SquareFold Trimmer Module Top Left and Right Covers. 4. Check the Trimmer Waste Container: • If full, empty the container and reinsert it into the SquareFold Trimmer Module. • If the container is partially pulled out, push it completely in. 5. If necessary, follow any remaining instructions on the machine's UI. 6. If fault persists, repeat Steps 1-5; if fault persists after that, call for service.

(continued)

Fault code	Possible cause	Recommended solution
013-221 013-222 013-223 013-224 013-225 013-226 013-227 013-228 013-229 013-230 013-231 013-232 013-233 013-234 013-235 013-236 013-237 013-238 013-239 013-240 013-241 013-242 013-243 013-246	Jam or communication error with the SquareFold Trimmer Module	1. Power off/on the machine. 2. If fault persists, call for service.
013-303 013-304	A top cover is open.	1. Open the Top Left and Right Covers of the SquareFold Trimmer Module. 2. Close the SquareFold Trimmer Module Top Left and Right Covers. 3. If fault persists, power off/on the machine. 4. If fault persists, call for service.
013-208 013-940 013-941	The Trimmer Waste Container is full or has a fault.	1. Pull open the container and empty any trimmer scraps from it. 2. Reinsert the container into the SquareFold Trimmer Module. 3. Ensure that the container is fully pushed in, and that the indicator light is not lit. 4. If fault persists, repeat Steps 1-3. 5. If fault persists, power off/on the machine. 6. If fault persists, call for service.

SquareFold Trimmer Module
(continued)

Fault code	Possible cause	Recommended solution
013-943	Booklet Tray on the SquareFold Trimmer Module is full.	1. Remove any booklets from the tray. 2. If fault persists, power off/on the machine. 3. If fault persists, call for service.
012-115 012-264 012-302	Finisher jam or fault	1. If machine's UI continues to reflect a fault/jam, open the finisher and remove any jams. Close the finisher cover(s). 2. Follow the instructions shown on the machine's UI to resume printing. 3. If fault persists, power off/on the machine. 4. If fault persists, call for service.

Technical data

Specifications

Item	Specifications
Paper size	• Maximum: 13 x 18 in./330 x 457 mm • Minimum: 8.5 x 11 in./A4 SEF Note The SquareFold Trimmer Module requires both Interface Module and the Booklet Maker Finisher.
Trim capacity	• 5-20 sheet booklet (up to 80 imaged sides) at 24 lb./90 gsm • 5-25 sheet booklet (up to 100 imaged sides) at 200 lb./80 gsm Cut amount: 2-20 mm, adjustable in 0.1 mm increments
Paper weights	16 lb. bond-90 lb. cover (60-220 gsm)

Standard Finisher Plus

The Standard Finisher Plus acts as a communication device and provides a paper path between the print engine, the required Interface Module, and any third-party, Document Finishing Architecture (DFA) device that is attached to the machine.

The Standard Finisher Plus supports a number of optional finishing devices ranging from light-production print engines to futuristic devices that utilize other communication and physical interfaces.

Overview

Note

The Standard Finisher Plus requires the Interface Module.



The Standard Finisher Plus is comprised of these two modules:

1. Finisher Module
2. Finishing Transport

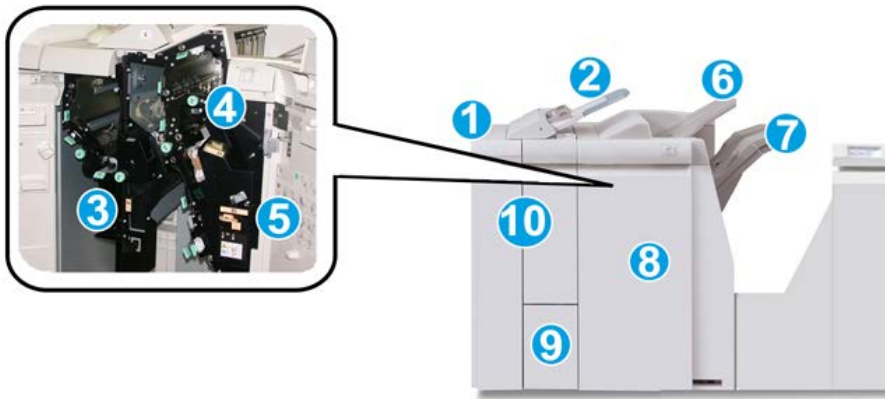
Output prints are fed from the machine (and any attached optional finishing device) to the Finisher Module. The Finishing Transport serves as an interface to transfer paper from the Finisher Module and the attached third-party output device. The Finishing Transport moves the paper from the Finisher Module to one of the three Finishing Transport exits. The height of the paper entry on the third-party, DFA device must align with the Finishing Transport exit 1 or exit 2.

The Finishing Transport is built to support a number of finishing operations ranging from light-production print engines to futuristic devices that utilize other communication and physical interfaces.

Finisher Module

Finisher Module main components

The Finisher Module includes the following components:



No.	Component	Function
1	Finisher Module	Output prints are fed from the machine through the required Interface Module to the Finisher Module which then feeds the prints to the Finishing Transport for delivery to a third-party output device. The Finisher Module is shown here with the optional C/Z Folder.
2	Post-process inserter (Tray 8/Tray T1)	- This tray is standard on this finisher and is used to load paper that will be used as separators and covers. - Paper loaded here is not printed on; use this tray for pre-printed stock and for insertion into the printed output. (This tray is also known as the Interposer). - Tray 8 holds a maximum of 200 sheets when using 20 lb./75 gsm paper. - Paper can be loaded in the LEF or SEF direction.
3	Punch scrap container	Collects the scraps from the puncher. Open to remove the scraps.

(continued)

No.	Component	Function
4	Staple cartridge	Contains staples; remove this cartridge to replace staples and clear staple jams.
5	Staple waste container	Container for staple waste; remove this container when full.
6	Top tray	The Top Tray is used for stacked output, and can receive up to 500 sheets of 20 lb./80 gsm paper. Copies are delivered here when specific output features are selected, such as Automatic sorting, Collated, Uncollated, or Normal.
7	Stacker (middle) tray	The Stacker Tray is used for offset and/or stapled output, and can hold up to 2000 sheets of 20 lb./80 gsm paper. This tray also receives copies when you punched and Z-folded copies. Note Both the Top and Stacker Trays can be used for hole punched output (optional)
8	Right cover	Open to clear paper jams, replace staples, clear jammed staples, or remove the scraps from the puncher.
9	C/Z-Fold output tray (optional)	The optional Folder tray receives copies when you select C-folding or Z-folding of 8.5 x 11 in./A4 output and 11 x 17 in./A3 media.
10	Left cover.	Open this cover to access the machine and to clear paper jams.

Folding feature

If your machine is equipped with the optional C/Z Folder, you can make prints using the folding option. The option folds your prints in half (single) or in thirds (C-fold or Z-fold types). The folding option is selected from the print driver.

Note

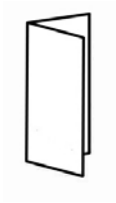
In order to use the folding option, the orientation of documents must be short-edge feed (SEF). You must select a paper tray that contains SEF stock.

Fold types

These fold types are available:

Single Fold (Bi-Fold)

A Bi-Fold has one fold which creates two panels to the output.

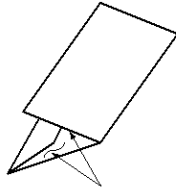


Note

The Single Fold option is available only with the Booklet Maker Finisher.

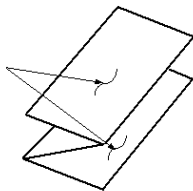
C-Fold

A C-Fold has two folds which creates a three-panel output.



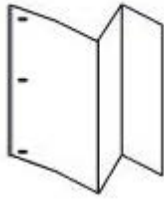
Z-Fold

A Z-Fold has two folds that are folded in opposite directions, resulting in a type of fan fold.



Z-Fold Half Sheet (shown here with 3-hole punch)

As with a regular Z-Fold, it has two folds that are folded in the opposite directions. The difference between a regular Z-Fold and a Z-Fold Half Sheet is that the Z-Fold Half Sheet is not folded in two equal folds. The two folds are unequal which allows one edge of the Z-Fold Half Sheet to have a longer edge, and the longer edge allows for stapling or hole punching.

**Loading paper/tabs in Tray 8/T1 (Post-Process Inserter)**

1. If necessary, remove any remaining media that is currently loaded in Tray 8/T1.
2. Hold the center of the paper guides and slide them to their desired paper size.



3. Load the paper/tabs, aligning it to the front side of the tray.



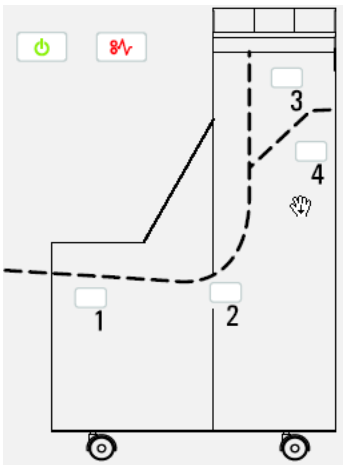
- a) If the paper is preprinted, load the paper with the printed side facing up.
 - b) If the media is tab stock, load the tab side to be fed first (in the direction of the arrow as shown in the above illustration).
4. From the Tray Properties window, enter the correct paper information, including size, type, weight, and if necessary, decurler and/or alignment option
If enabled by your System Administrator, the Paper Tray Properties screen may be displayed on the UI.
 5. Select **OK** to save the information and close the Tray Properties window.

Finishing Transport

Finishing Transport main components

The Finishing Transport is comprised of the following components:



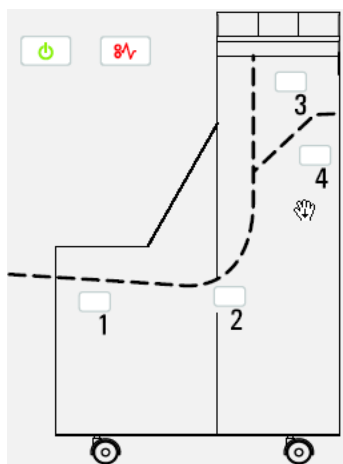
No.	Component	Function
1	Finishing Transport	The Finishing Transport serves as an interface to transfer paper from the Finisher Module and the attached third-party output device..
2	Finishing Transport status display 	This display indicates the status of the Finishing Transport and shows the locations of any paper jams.

(continued)

No.	Component	Function
3	Finishing Transport front door	Open to clear paper jams and clean the paper path areas.

Finishing Transport status indicators

The mimic display indicates the status of the Finishing Transport and the location of the paper jams.



Refer to the following table for detailed information on the

Location	LED Color	Status	Reason
Power indicator 	Green	ON	The Finishing Transport power is on and functioning properly.
		OFF	The Finishing Transport power is off.
Fault indicator 	Red	ON	May be one of the following: - Paper jam indication - Open front door
Area 1	Red	ON	Paper jam in Area 1
Area 2	Red	ON	Paper jam in Area 2
Area 3	Red	ON	Paper jam in Area 3
Area 4	Red	ON	Paper jam in Area 4

Standard Finisher Plus maintenance

Standard Finisher Plus consumable supplies

Xerox supplies, paper, and throughput material can be ordered from Xerox by going to www.xerox.com and clicking on either the Contact Us link for specific contact information/telephone numbers in your area or by clicking on the Supplies and entering/selecting your specific machine information (product family and model type).

Note

Always refer to www.xerox.com for the latest Consumable Replaceable Units (CRUs) part numbers.

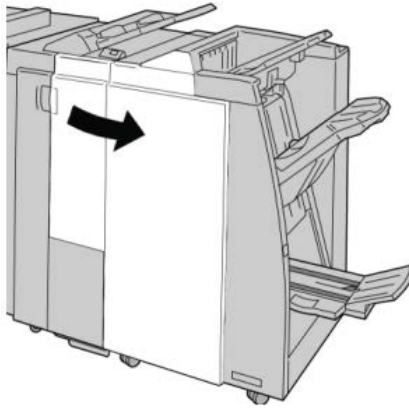
Store supply items and Xerox parts in their original packages in a convenient location.

Supply Item	Supply Unit Shipped with finisher/Reorder Quantity
Staple cartridge/staple waste container	4 staple cartridges (5000 staples per cartridge) and 1 staple waste container per carton

Replace the standard staple cartridge

A message displays on the UI when it is time to replace a staple cartridge.

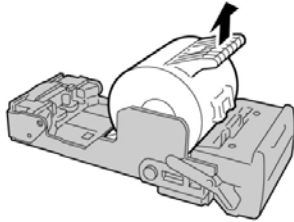
1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



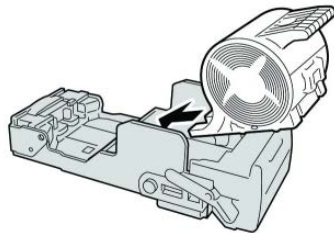
3. Grasp the Staple Cartridge handle located at **R1**, and pull out the staple cartridge from the finisher.



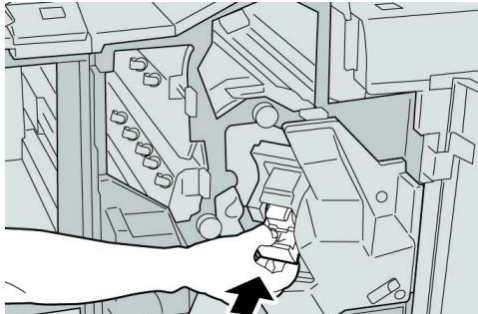
4. Hold the positions as indicated by the arrow and remove the staple cartridge from the unit.



5. Push a new staple cartridge into the unit.



6. Reinstall the cartridge unit to its original position in the finisher.



7. Close the Right Cover on the finisher.

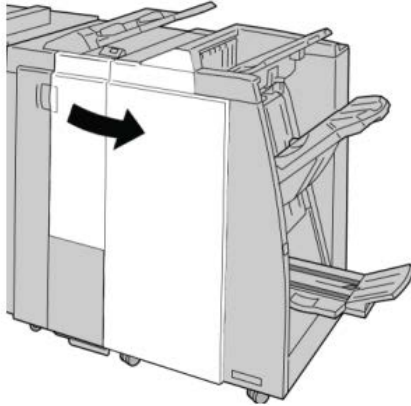
Note

A message will display and the machine will not operate if the right cover is open even slightly.

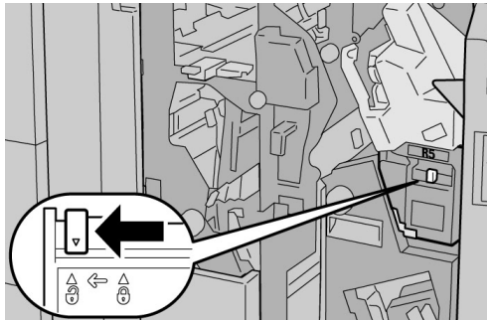
Replacing the Staple Waste Container on the finisher

The machine displays a message indicating that the Staple Waste Container is full. To replace the container:

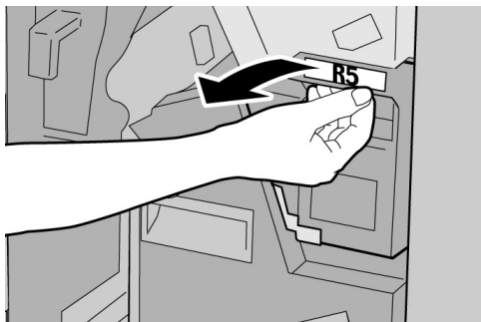
1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



3. Locate the Staple Waste Container (**R5**) in the finisher, and move the lock lever to the unlock position.



4. Hold R5 as shown in the figure and remove the staple waste container from the machine.



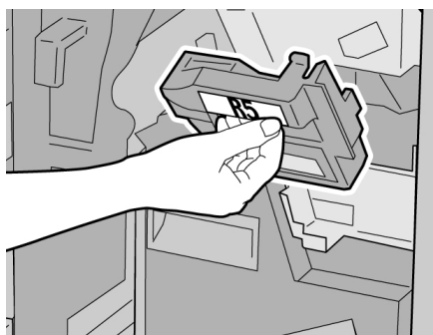
5. Place the used staple waste container into a supplied plastic bag.



Note

Do not return a disassembled (used) container to the Customer Support Center.

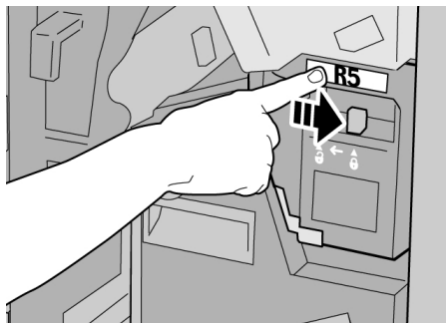
6. Hold the new staple waste container by the **R5** handle area and push it into the machine.



Note

To prevent injury, do not put your fingers on top of the container.

7. Push **R5** until the lock lever moves to the locked position.



8. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

Empty the Punch Waste Container

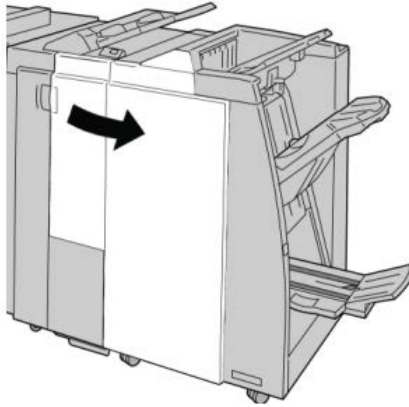
The UI displays a message indicating when it is time to empty the Punch Waste Container.



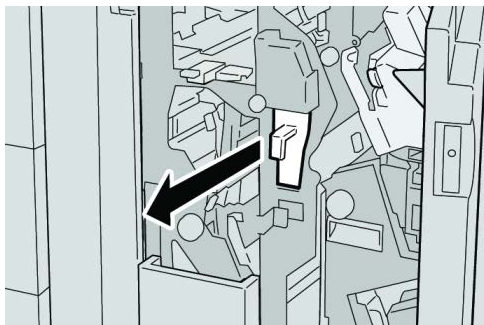
Caution

Only remove the Punch Waste Container while the system is powered ON. If you switch off the power when emptying the container, the machine cannot detect that the container was emptied.

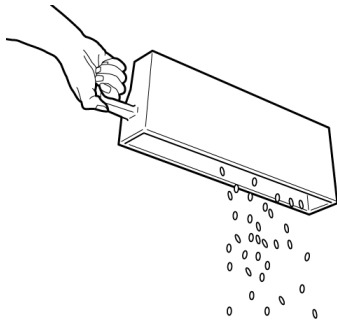
1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



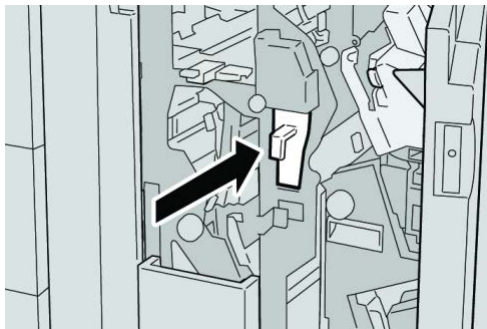
3. Pull the container out of the finisher (R4).



4. Discard all the punch scraps in an appropriate container.



5. Reinsert the empty container into the machine.



6. Close the Right Cover on the finisher.

Note

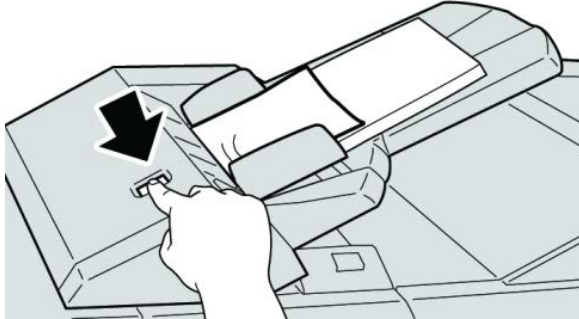
A message will display and the machine will not operate if the right cover is open even slightly.

Problem solving

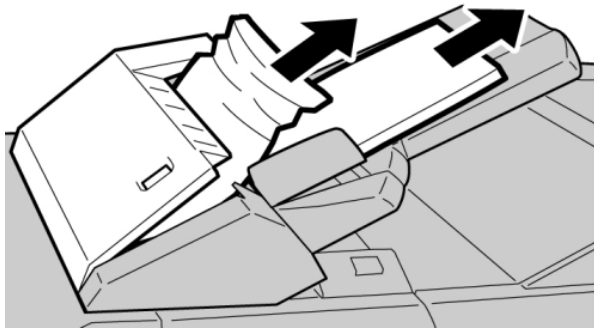
Paper jams in the Finisher Module

Paper jams in Tray 8/T1 (Post-Process Inserter)

1. Press the **Cover** button.



2. Open cover **1e** and then remove the jammed paper and all paper loaded in the tray.

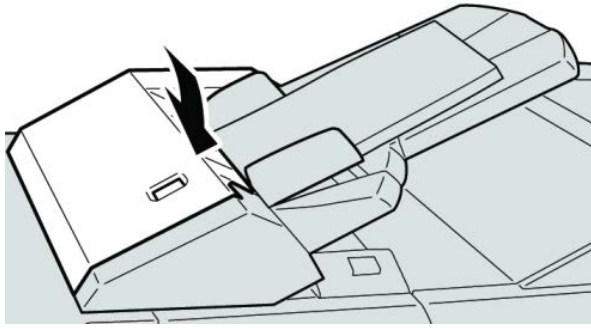


Note

If paper is torn, check inside the machine and remove it.

3. Fan the paper you removed, making sure that all four corners are neatly aligned, and then load them again.

4. Push cover **1e** until you hear it click into place.



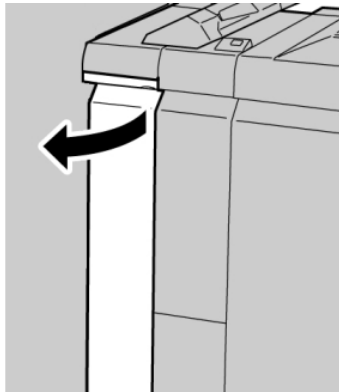
Note

A message will be displayed and the machine will not operate if the cover is open even slightly.

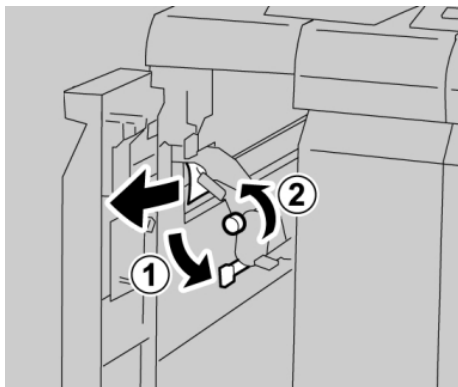
Paper jams inside the finisher left cover

Paper jams at lever **1a** and knob **1c**

1. Make sure that the machine has stopped printing.
2. Open the finisher left cover.



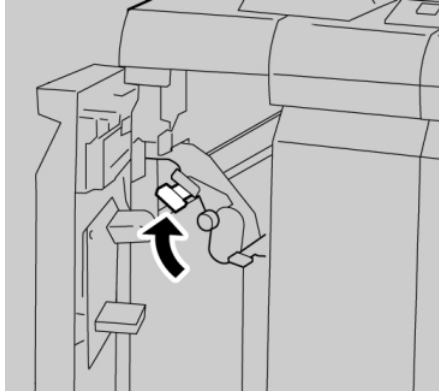
3. Move lever **1a** downwards and turn knob **1c** left. Remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return lever **1a** to the original position.



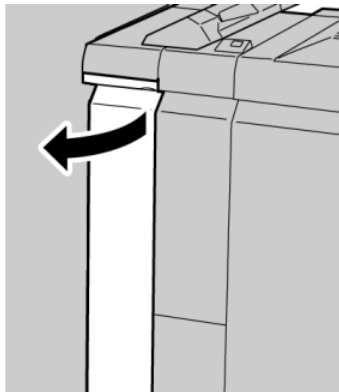
5. Close the finisher left cover completely.

Note

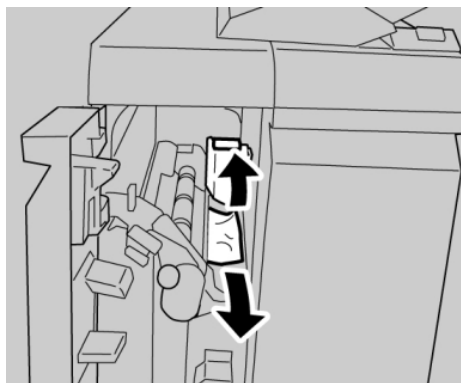
The machine will not operate if the cover is open even slightly.

Paper jams at lever 1d

1. Make sure that the machine has stopped printing.
2. Open the finisher left cover.



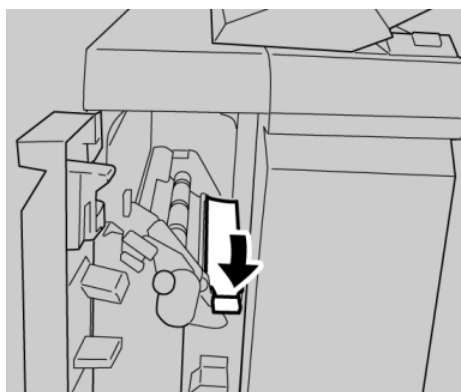
3. Move lever **1d** upwards and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Move the lever **1d** to the original position.



5. Close the finisher left cover completely.

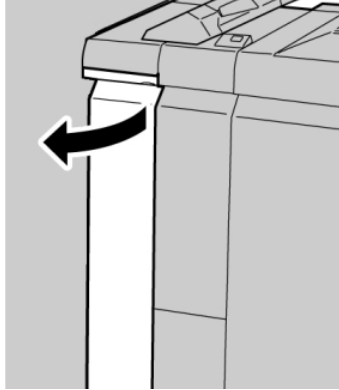
Note

The machine will not operate if the cover is open even slightly.

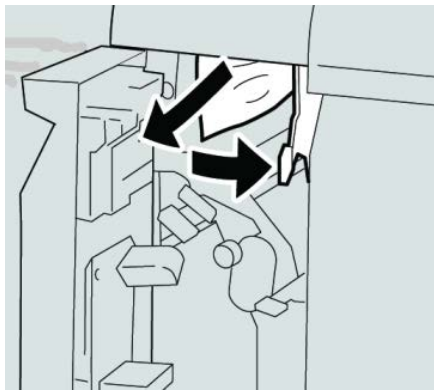
Paper jams at lever 1b

1. Make sure that the machine has stopped printing.

2. Open the finisher left cover.



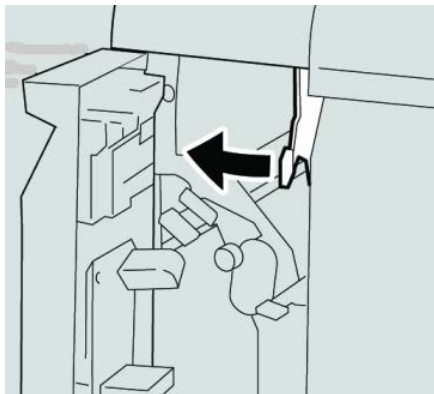
3. Move the lever **1b** to the right and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Move the lever **1b** to the original position.



5. Close the finisher left cover completely.

Note

The machine will not operate if the cover is open even slightly.

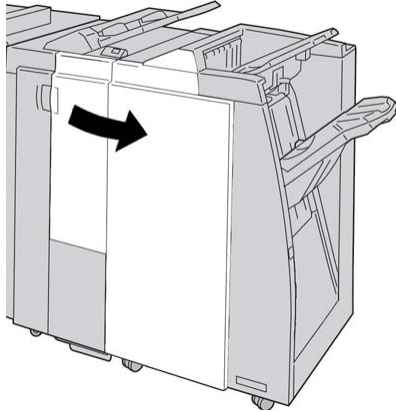
Paper jams inside the finisher right cover

Paper jams at lever 3b and 3d

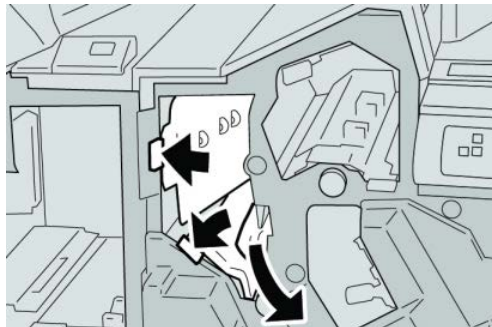
Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



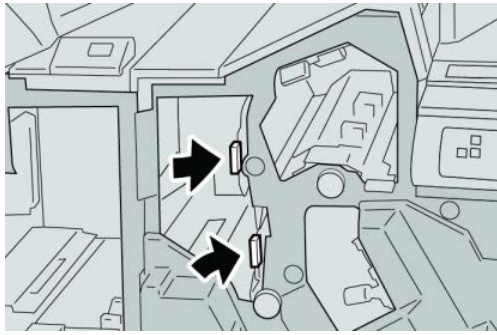
3. Move the levers **3b** and **3d**; remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the levers **3b** and **3d** to their original positions.



5. Close the Right Cover on the finisher.

Note

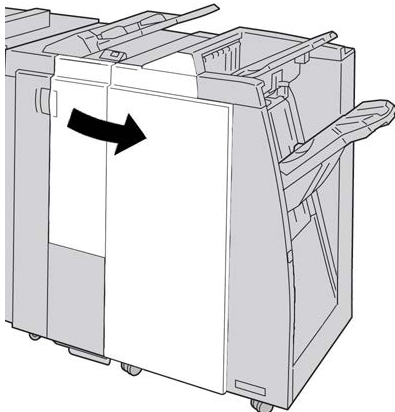
A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams at lever 3e and knob 3c

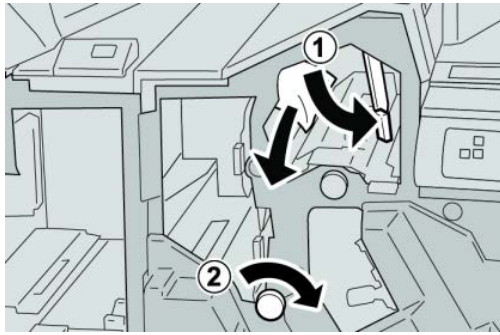
Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



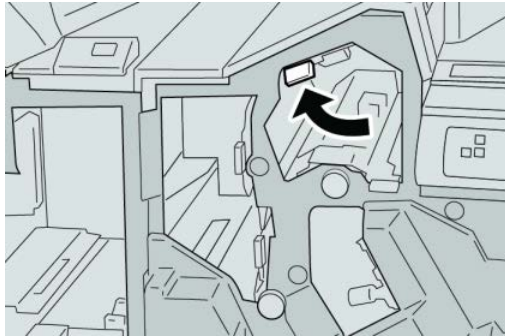
3. Move the lever **3e** and turn the knob **3c**; remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the lever **3e** its original position.



5. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

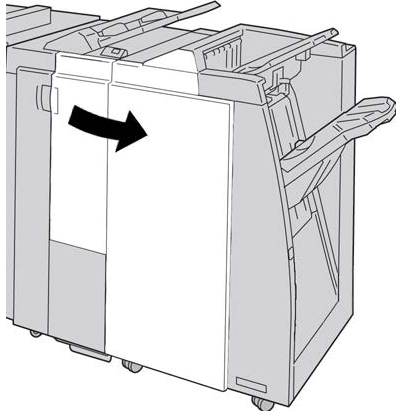
Paper jams at lever 3g and knob 3f

Tip

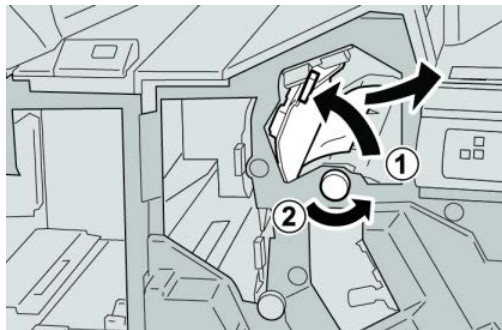
Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

1. Make sure that the machine has stopped printing.

2. Open the Right Cover on the finisher.



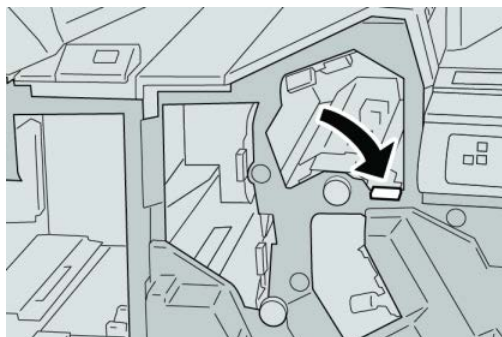
3. Move the lever **3g** and turn the knob **3f** and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the lever **3g** its original position.



5. Close the Right Cover on the finisher.

Note

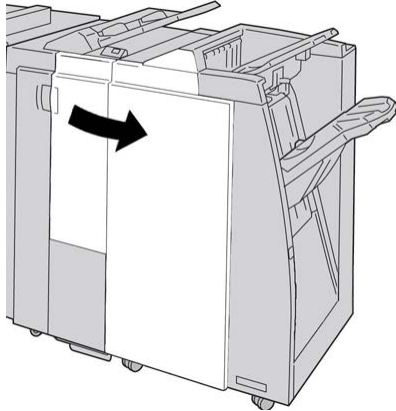
A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams at lever 4b and knob 3a

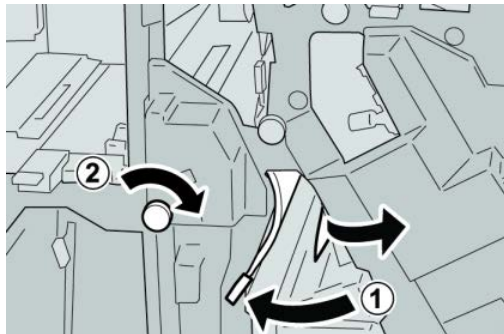
Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



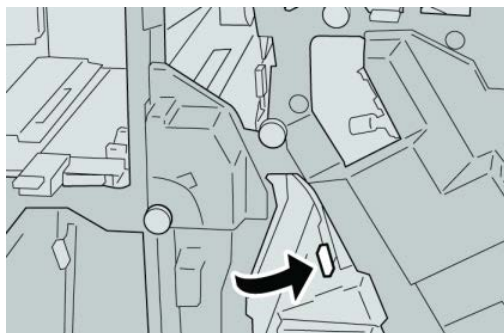
3. Move the lever **4b** and turn the knob **3a**; remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the lever **4b** its original position.



5. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams at the optional C/Z Folder

Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

This section describes how to remedy paper jams that occur at the following locations:

- Paper jams at lever 2a and knob 3a
- Paper jams at lever 2b and knob 2c
- Remove jams at knob 2c, levers 2e and 2f, and the folder output tray (2d)
- Paper jams at the folder output tray (2d) and at lever 2g

Note

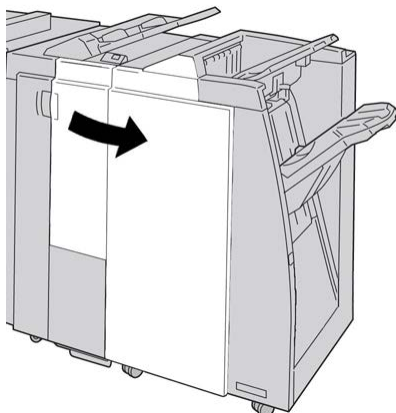
Remedies differ according to the paper jam location. Follow the instructions displayed to remove the jammed paper.

Paper jams at lever 2a and knob 3a

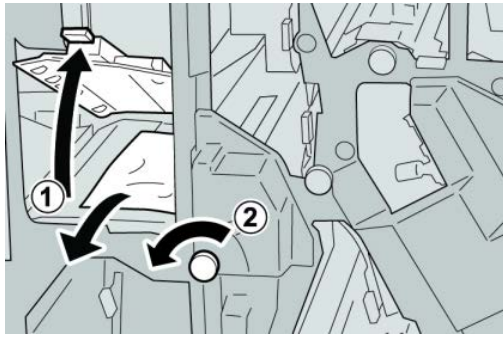
Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



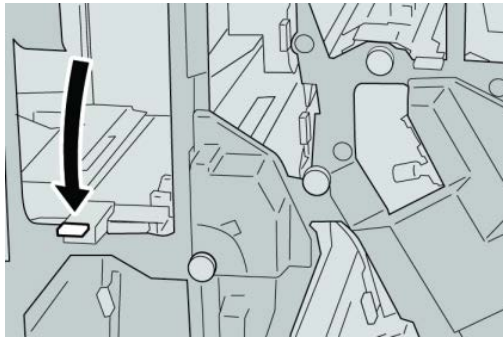
3. Move the lever **2a** and turn the knob **3a**; remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the lever **2a** to its original position.



5. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

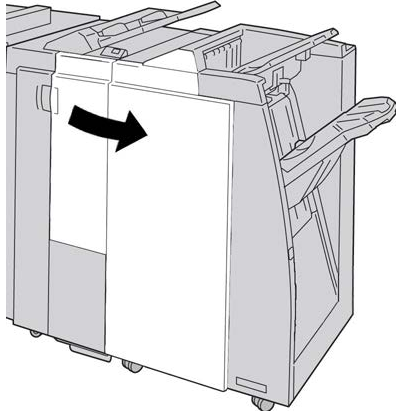
Paper jams at lever 2b and knob 2c

Tip

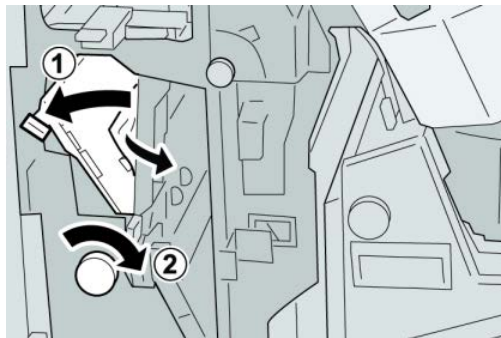
Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

1. Make sure that the machine has stopped printing.

2. Open the Right Cover on the finisher.



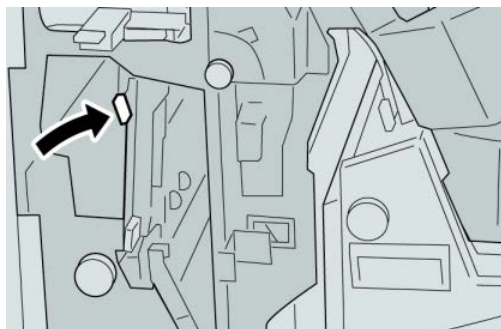
3. Move the lever **2b** and turn the knob **2c**; remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the lever **2b** to its original position.



5. Close the Right Cover on the finisher.

Note

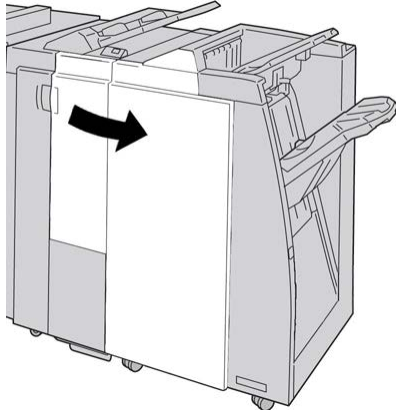
A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams at 2c, 2e, 2f, and 2d

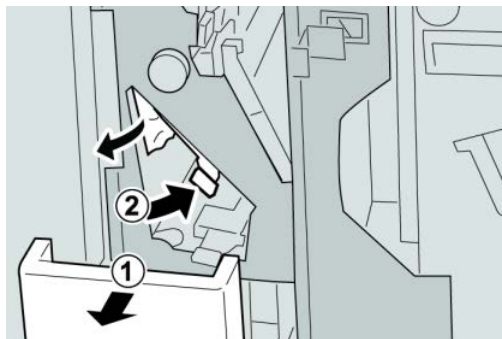
Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



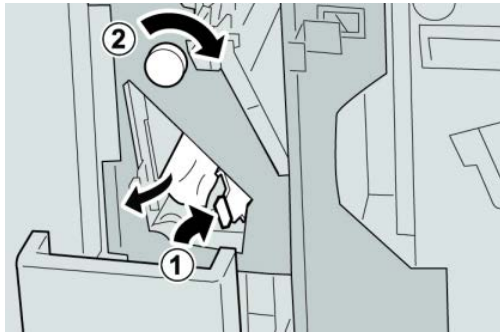
3. Pull out the folder output tray (2d), swing lever 2e to the right, and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

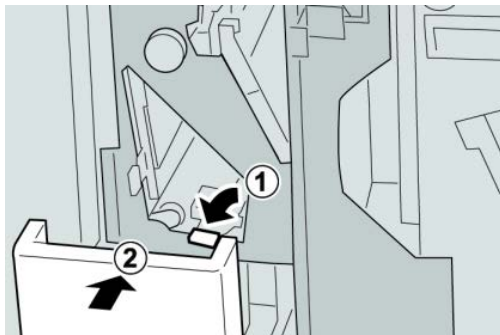
4. If you cannot remove the paper, return the lever **2e** to its original position. Swing the lever **2e**, turn the knob **2c** to the right, and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

5. Return the opened lever (**2f**) or (**2e**) to its original position, and close the output tray (**2d**).



6. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

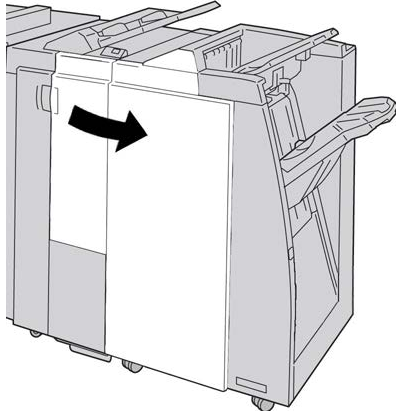
Paper jams at 2d and lever 2g

Tip

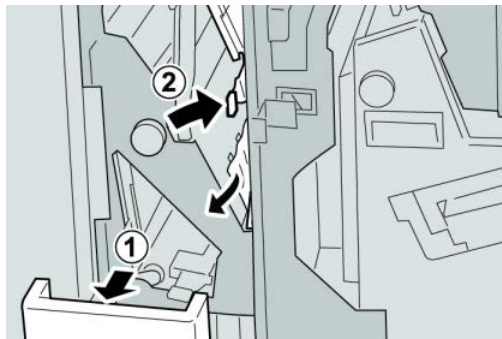
Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

1. Make sure that the machine has stopped printing.

2. Open the Right Cover on the finisher.



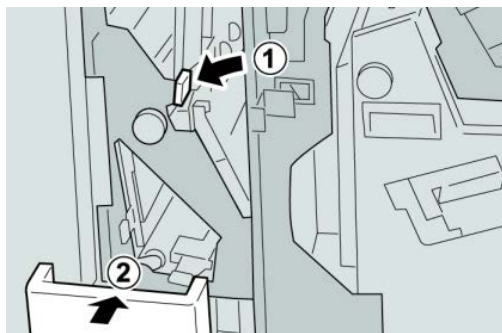
3. Pull out the folder output tray (**2d**), swing lever the **2g**, and remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the opened lever (**2g**) to its original position, and close the output tray (**2d**).



5. Close the Right Cover on the finisher.

Note

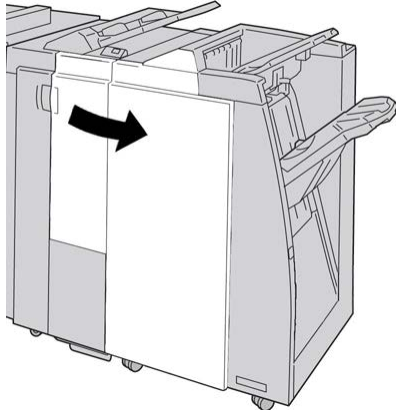
A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams in areas 4b and 4c

Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

1. Make sure that the machine has stopped printing.
2. Open the Right Cover on the finisher.



3. Move the levers **4b** and **4c**; remove the jammed paper.



Note

If paper is torn, check inside the machine and remove it.

4. Return the opened levers (**4b** and **4c**) their original positions.
5. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

Paper jams at the finisher output area

Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs.

This section describes how to remedy paper jams that occur at the following locations:

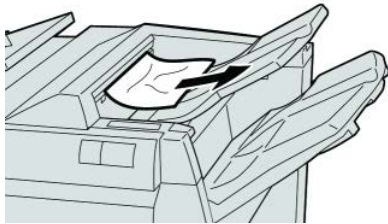
- Paper jams at the finisher top tray
- Paper jams at the finisher stacker tray

Note

Remedies differ according to the paper jam location. Follow the instructions displayed to remove the jammed paper.

Paper jams at finisher top tray

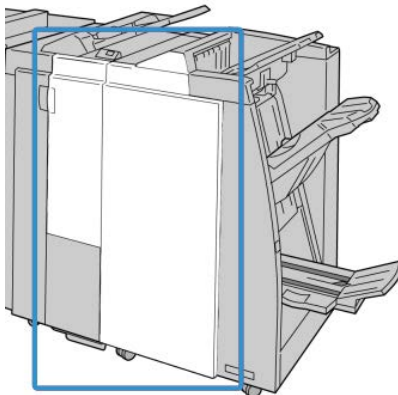
1. Make sure that the machine has stopped printing.
2. Remove jammed paper from the finisher top tray.



Note

If paper is torn, check inside the machine and remove it.

3. Open and close the finisher right cover.

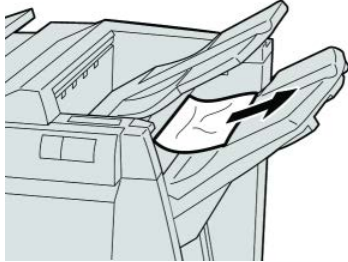


Note

The machine will not operate if the cover is open even slightly.

Paper jams at finisher stacker tray

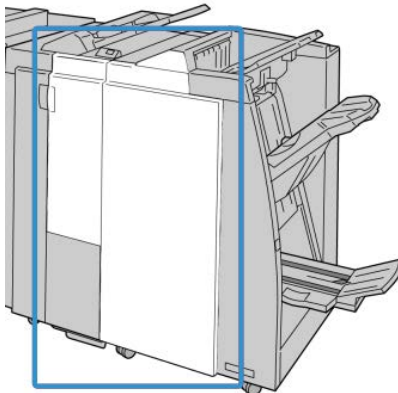
1. Make sure that the machine has stopped printing.
2. Remove jammed paper from the finisher stacker tray.



Note

If paper is torn, check inside the machine and remove it.

3. Open and close the finisher right cover.



Note

The machine will not operate if the cover is open even slightly.

Paper jams in the Finishing Transport

Paper jams in area 1

Remedies differ according to the paper jam location. Follow the instructions displayed to remove the jammed paper.

Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs. If paper is torn, check inside the Finishing Transport and remove it.

1. Open the Finishing Transport front door.



2. Grasp the green handle **1** and gently pull downwards.



3. Remove the jammed paper.

For a paper jam at the exit of the Finisher Module and the entry of the Finishing Transport, remove it by pulling the paper towards the Finishing Transport.

4. Return the green handle **1** to its original position.
5. Close the Finishing Transport front door.

6. Ensure that the paper jam indication is cleared from the Finishing Transport status display.
7. Follow the instructions on the UI to restart your print job.

Paper jams in area 2

Remedies differ according to the paper jam location. Follow the instructions displayed to remove the jammed paper.

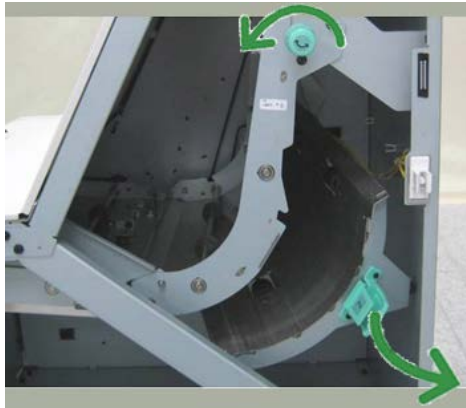
Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs. If paper is torn, check inside the Finishing Transport and remove it.

1. Open the Finishing Transport front door.



2. Grasp the green handle 2 and gently pull down and toward the right.



3. Remove the jammed paper.
4. If necessary, rotate the green knob in the direction shown to remove any jammed paper in this area.
5. Return the green handle 2 to its original position.
6. Close the Finishing Transport front door.

7. Ensure that the paper jam indication is cleared from the Finishing Transport status display.
8. Follow the instructions on the UI to restart your print job.

Paper jams in area 3

Remedies differ according to the paper jam location. Follow the instructions displayed to remove the jammed paper.

Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs. If paper is torn, check inside the Finishing Transport and remove it.

1. Open the Finishing Transport front door.



2. Grasp the green handle 3 and gently pull toward the left.



3. Remove the jammed paper.
4. Return the green handle 3 to its original position.
5. Close the Finishing Transport front door.
6. Ensure that the paper jam indication is cleared from the Finishing Transport status display.

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

Paper jams in area 4

Remedies differ according to the paper jam location. Follow the instructions displayed to remove the jammed paper.

Tip

Always ensure that all paper jams, including any small ripped pieces of paper, are cleared before proceeding with your print jobs. If paper is torn, check inside the Finishing Transport and remove it.

1. Open the Finishing Transport front door.



2. Grasp the green handle **4** and gently pull toward the right.

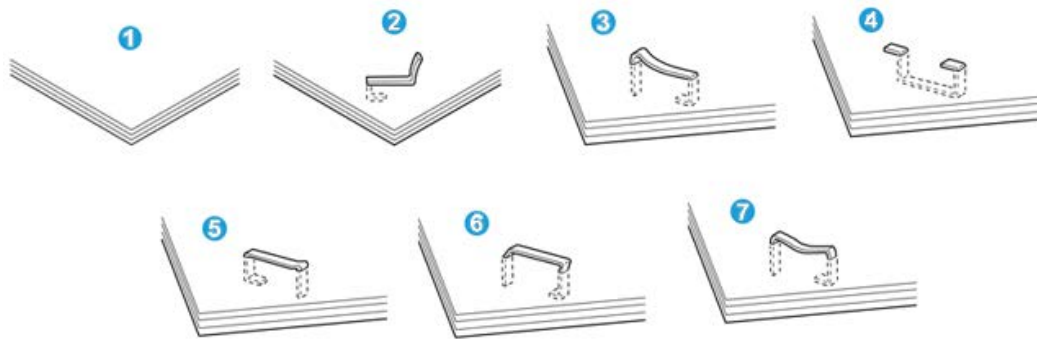


3. Remove the jammed paper.
4. Check for and remove any jammed paper between the exit from the Finishing Transport and the entrance to the attached third-party device.
5. Return the green handle **4** to its original position.
6. Close the Finishing Transport front door.
7. Ensure that the paper jam indication is cleared from the Finishing Transport status display.

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

Stapler faults

Follow the procedures provided when the output is not stapled or the staples are bent. Contact our Customer Support Center if the problem persists after you have tried the following solutions. Stapler faults on output may look similar to the ones shown in the following illustration.



- No staple
- Bent staple
- One side of staple rising up
- Staple bent in reverse direction
- Flattened staple
- Entire staple rising up
- Staple rising up with center pressed in

If the output is stapled as shown in the figure above, contact our Customer Support Center.

Note

Depending on the type of paper that is being stapled, the stapled nails may be bent. If the bent nails are stuck inside the machine, they may eventually cause paper jams. Remove the bent staple when opening the staple cartridge cover. If you do not remove the bent staple, a staple jam may occur as a result. Use the staple cartridge cover only when removing the bent staple.

Staple jams in the standard staple cartridge

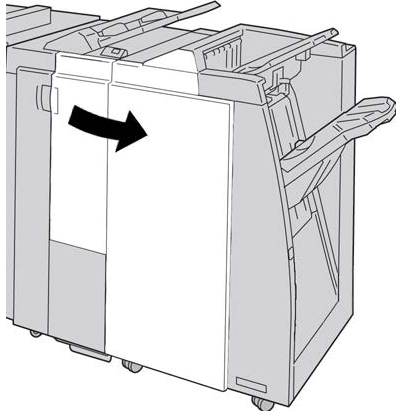
Perform the following procedure to clear staple jams in the standard stapler cartridge

Note

Always check inside the finisher for any individual staples or staple remnants.

- Make sure that the machine has stopped printing.

2. Open the Right Cover on the finisher.



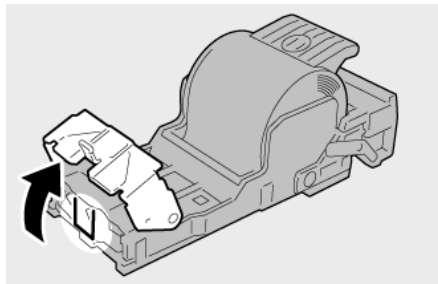
3. Grasp the Staple Cartridge handle located at R1, and pull out the staple cartridge from the finisher.



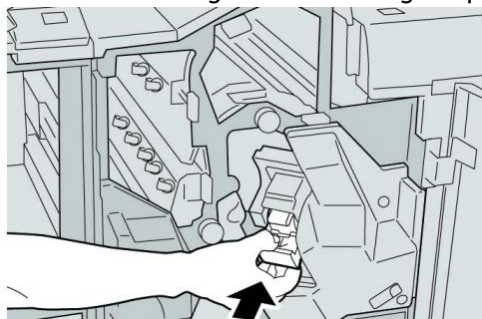
4. Check the inside of the finisher for any remaining staples, and if necessary, remove them.
5. Open the staple cartridge unit as shown and remove the jammed staple.

 Warning

To avoid injury to your fingers, carefully remove the jammed staples from the cartridge.



6. Reinstall the cartridge unit to its original position in the finisher.



7. Close the Right Cover on the finisher.

Note

A message will display and the machine will not operate if the right cover is open even slightly.

Standard Finisher Plus fault codes

Finisher Module fault codes

If an error code appears that is not listed in the table below, or if an error persists after following the listed solution, then contact your Xerox Customer Support Center.

Fault code	Possible cause	Recommended solution
013 108	The transport in sensor in the Finishing Transport did not switch ON within a specified amount of time.	- Check for any obstructions or paper jams in the Finishing Module and Finishing Transport paper paths and clear them. - If necessary, power Off/On the machine, and if necessary, resend/restart your print job. - If the fault persists, contact the Customer Support Center.
013 109	The transport exit sensor in the Finishing Transport did not switch ON within a specified amount of time.	
013 110	The transport exit sensor in the Finishing Transport did not switch OFF within a specified amount of time.	
013 910	Paper jam at the transport in sensor (Finishing Transport)	
013 911	Paper jam at the transport exit sensor (Finishing Transport)	

Finishing Transport fault codes

If an error code appears that is not listed in the table below, or if an error persists after following the listed solution, then contact your Xerox Customer Support Center.

Fault code	Possible cause	Recommended solution
051 900, 051 100, 051 101, 051 102, 051 103, 051 104, 051 105, 051 106, 051 107, 051 108, 051 109, 051 110, 051 111	Paper jam	- Check for any obstructions or paper jams in the Finishing Module and Finishing Transport paper paths and clear them. - If necessary, power Off/On the machine, and if necessary, resend/restart your print job. - If the fault persists, contact the Customer Support Center.
051 300	Finishing Transport front door is open.	Close the front door of the Finishing Transport.
051 210	Registration clutch solenoid fault	- If necessary, power Off/On the machine, and if necessary, resend/restart your print job. - If the fault persists, contact the Customer Support Center.
051 211	Diverter solenoid fault	
051 310	Finishing Transport firmware fault upgrade	

Third-party DFA fault codes

The following table provides a list of fault codes that indicate that a jam or fault has occurred in the attached third-party, Document Finishing Architecture (DFA) device.

If an error code appears that is not listed in the table below, or if an error persists after following the listed solution, then contact your Xerox Customer Support Center.

Fault code	Possible cause	Recommended solution
051 910, 051 911	Either the DFA device is not ready or other fault has occurred with it.	- Refer to any user documentation that came with your DFA device and follow the instructions to bring the device back online. - If necessary, power Off/On the machine, and if necessary, resend/restart your print job. - If the fault persists, contact the Customer Support Center.

(continued)

Fault code	Possible cause	Recommended solution
051 912	The DFA device is either full or out of supplies	Refer to any user documentation that came with your DFA device and follow the instructions to clear the fault and/or replenish the depleted supplies.
051 913, 051 914, 051 915	Paper jam in the DFA device	- Refer to any user documentation that came with your DFA device and follow the instructions to clear the fault. - If necessary, set the correct profile value; refer to the System Administration Guide, Profiles chapter for more information. - If necessary, refer to the DFA user documentation for setting/changing profile values. - If necessary, power Off/On the machine, and if necessary, resend/restart your print job. - If the fault persists, contact the Customer Support Center.

Specifications

This section provides specifications on the Standard Finisher Plus.

Finisher Module specifications

Item	Specification
Tray Type	- Top Tray: Collated/Uncollated - Stacker (middle) Tray: Collated/Uncollated (Offset available)

Standard Finisher Plus
(continued)

Item	Specification
Supported Paper Size	Top Tray: - Maximum: SRA3, 13 x19 in., 12.6 x19.2 in., 330 x 488 mm (custom size) - Minimum: 100 x 148 mm (SEF), 4 x 6 in. (SEF), A6 (SEF) postcards Stacker (middle) Tray: - Maximum: 13 x 19 in. (330 x 488 mm), SRA3 - Minimum: B5, Executive (7.25 x 10.5 in.) Booklet Tray (optional Booklet Maker Finisher only): - Maximum: 13 x 18 in., SRA3 - Minimum: A4 (SEF), 8.5 x 11 in. (SEF) Optional C/Z Folder tray: Supports A4 (SEF) and 8.5 x 11 in. (SEF) Delivery to a supported third-party, DFA device: - Maximum: 13 x 19 in., SRA3 - Minimum: B5, Executive (7.25 x 10.5 in.)
Supported Paper Weight	Trays: - Top Tray: 55-350 gsm - Stacker (middle) Tray: 55-300 gsm - Booklet Tray (optional Booklet Maker Finisher only): - Center binding 64-300 gsm - Center folding 60-105 gsm - Optional C/Z Folder tray: 64-90 gsm Delivery to a supported third-party, DFA device: 55-350 gsm
Tray Capacity	- Top Tray: 500 sheets - Stacker (middle)Tray: 2,000 sheets, 200 sets* - Booklet Tray (optional Booklet Maker Finisher only): 20 sets** - Optional C/Z Folder tray: Minimum 30 sheets *When using A4 LEF, B5 LEF, 8.5 x 11 in. LEF, 8 x 10 in. LEF, 7.5 x 10.5 in. LEF only. When using paper of other sizes, tray capacity is 1,500 sheets and 100 sets. **Tray may not support some paper types.

(continued)

Item	Specification
Stapling (variable length)	Maximum staple sheets: 100 sheets • When using paper of size larger than A4 or 8.5 x 11 in., the maximum number of sheets that can be stapled is 65. • Staple nails may bend when using certain paper types. Paper size: • Maximum: A3/11 x 17 in. • Minimum: B5, Executive (7.25 x 10.5 in.) Staple position: • 1 location: (front: angled stapling, center: parallel stapling, back: parallel stapling*) • 2 locations: (parallel stapling) • 4 locations: A4 (LEF) and 8.5 x 11 in. (LEF) parallel stapling *: Angled stapling for A3 and A4
Hole Punching	Supported paper size: • Maximum: A3/11 x 17 in. • Minimum: B5 LEF (2 holes), A4 LEF (4 holes) Number of holes: 2, 4, 3 (optional) Paper type: 55-220 gsm

Standard Finisher Plus
(continued)

Item	Specification
Booklet Creation/Single Fold	Maximum number of sheets: • Fold and Staple: 25 sheets • Fold only: 5 sheets When using Xerox 20 lb./75 gsm paper, only 14 sheets can be stapled if adding a cover. Paper size: • Maximum: A3, 13 x 18 in. • Minimum: A4 SEF, 8.5 x 11 in. SEF Note When using light-weight stocks, media jams may occur with Booklet Creation, Single Fold, and stapling for output that is 25 sheets or more. If media jams do occur, it is recommended that a different media type is selected for the job. Paper type: Fold only or Fold and Staple: 55-350gsm uncoated, 106-300gsm coated Paper Weights/Booklet Capacity: • 64-80 gsm, Uncoated: 25 sheets • 81-90 gsm, Uncoated: 20 sheets • 91-105 gsm, Uncoated: 10 sheets • 106-128 gsm, Uncoated: 10 sheets, Coated: 10 sheets • 129-150 gsm, Uncoated: 10 sheets, Coated: 10 sheets • 151-176 gsm, Uncoated: 10 sheets, Coated: 10 sheets • 177-220 gsm, Uncoated: 5 sheets, Coated: 5 sheets • 221-256gsm, 4 sheets max. coated or uncoated • 257-350gsm, 3 sheets max, coated or uncoated
Folding	Note Non-stapled fold sets are limited to 5 sheets of paper.
Tray 8/T1 (Post-Process Inserter; also called Interposer)	Paper size: • Maximum: A3/11 x 17 in. • Minimum: B5, Executive (7.25 x 10.5 in.) The machine does not print on paper loaded in Tray 8/T1. Capacity: 200 sheets when using Xerox 20 lb./75 gsm paper. Paper type: 64-220 gsm

Optional C/Z Folder

Item	Specification
Z-Fold Half Sheet	• Z-paper size: 11 x 17 in./A3, 10 x 14 in./B4, 8K • Capacity: - Maximum: 80 sheets (A3/11 x 17 in. Xerox 20 lb./75 gsm paper Z folding) - 20 sheets for 8K and 10 x 14 in./B4 • Paper type: 16-24 lb./64-90 gsm • Output tray: Stacker (middle) tray
C-Fold Z-Fold	• Paper size: A4/8.5 x 11 in. • Number of sheets to be folded: 1 sheet • Capacity: Minimum 30 sheets (When using Xerox 20 lb./75 gsm paper.) • Paper type: 16-24 lb./64-90 gsm • Output tray: C/Z Folder tray

Finishing Transport specifications

Item	Specification
Paper size	7.16 x 19.2 in./182 x 488 mm, Process direction. Center Registered: 7.16 x 13 in./182 x 330.2 mm, Process direction
Paper weight	52-350 gsm
Transparencies/coated paper	Transparencies/Coated Paper Stock can be used
Speed	50 to 155 prints per minute (ppm)

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