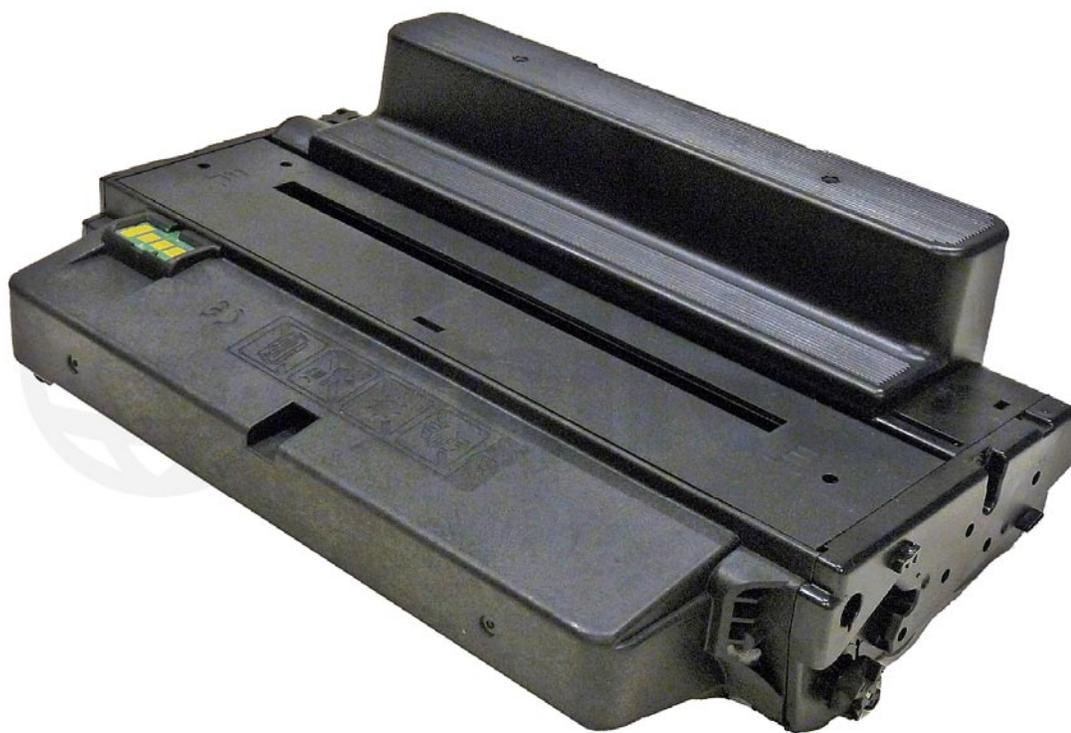


XEROX® WORKCENTRE 3315

TONER CARTRIDGE REMANUFACTURING INSTRUCTIONS



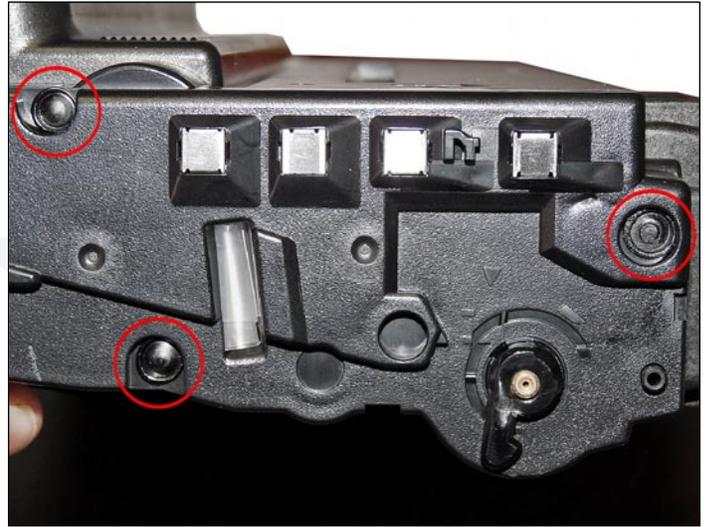
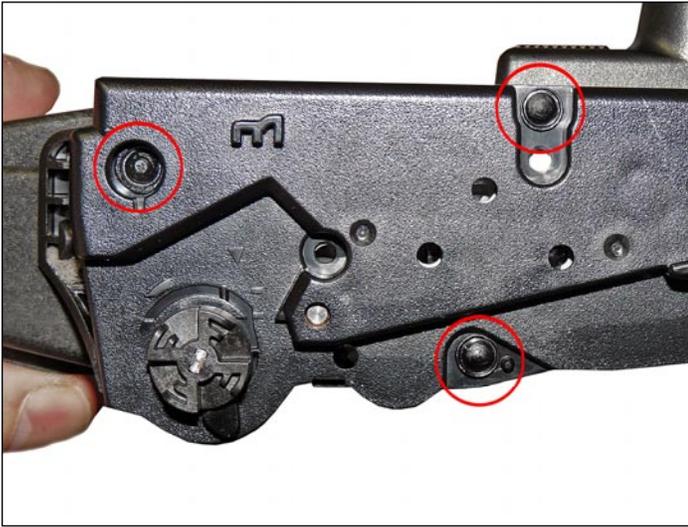
XEROX WORKCENTRE 3315 TONER CARTRIDGE

REMANUFACTURING THE XEROX WORKCENTRE 3315 TONER CARTRIDGE

By Mike Josiah and the Technical Staff at UniNet

First released in November 2013, the Xerox WorkCentre 3315 series of printers are based on a 31-35 ppm engine with a maximum resolution of 1200 x 1200 dpi. The first page out is stated to be under 6.5 seconds. Depending on the model number, other options/specs are available including MFP versions and Wi-Fi connectivity.

The Toner cartridges do not have a drum cover, and come new with a piece of heavy paper with a thin sheet of foam on the inside taped around the cartridge.



These cartridges, just like most others these days, have plastic rivets that need to be cut off, holes drilled, and screws installed to hold them back on. It's not a hard process and it's covered completely in the instructions.

CARTRIDGES USED IN THESE MACHINES

WorkCentre 3315

106R02308	2,300 pages	USD\$119.75*
106R02310	5,000 pages	USD\$192.95*

WorkCentre 3325

106R02310	5,000 pages (3315 also)	USD\$192.95*
106R02312	11,000 pages	USD\$332.65*

Phaser 3320

106R02304	5,000 pages	USD\$221.00*
106R02306	11,000 pages	USD\$339.00*

*Pricing, in U.S. American Dollars, as of June 2015.

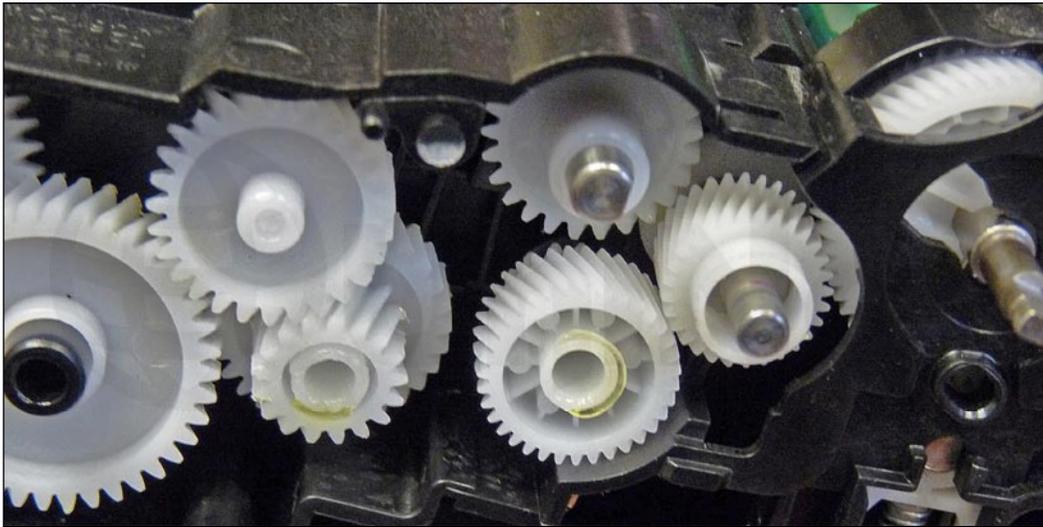
All the cartridges have a chip, and it has to be replaced each cycle. The OEM chips are regional so be sure to get the proper chip for your region.



IMPORTANT! Besides different yields, there are two types of cartridges in the field - **New** and **Old styles**. The main difference is the **drum**; the **new** style has 59 teeth and the **old** style drum has 39. The gear trains are also different, but for ordering purposes, you need to know which drum your cartridge has. The following figures show the New and Old style drum gears and the associated internal gears.



FULL GEAR TRAIN - OLD STYLE



FULL GEAR TRAIN - NEW STYLE



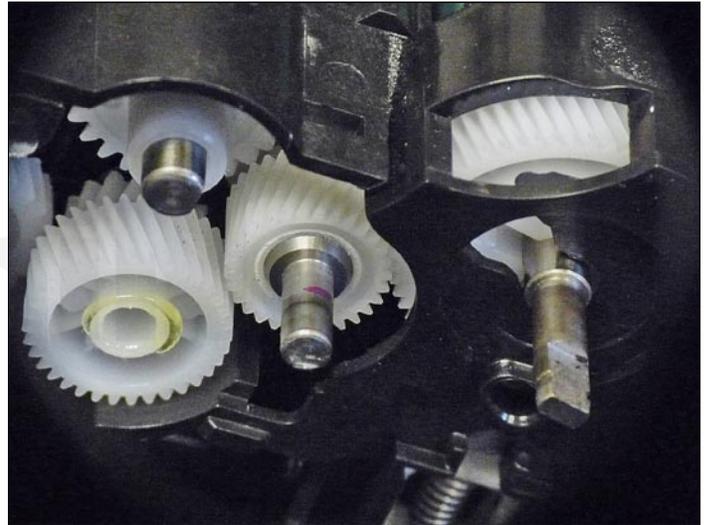
OLD CARTRIDGE GEARS



NEW CARTRIDGE GEARS



THREE OLD GEARS



THREE NEW GEARS

MACHINES IN THIS SERIES**WorkCentre 3315****WorkCentre 3325****Phaser 3320**

Cartridge troubleshooting will be listed at the end of these instructions.

REQUIRED TOOLS

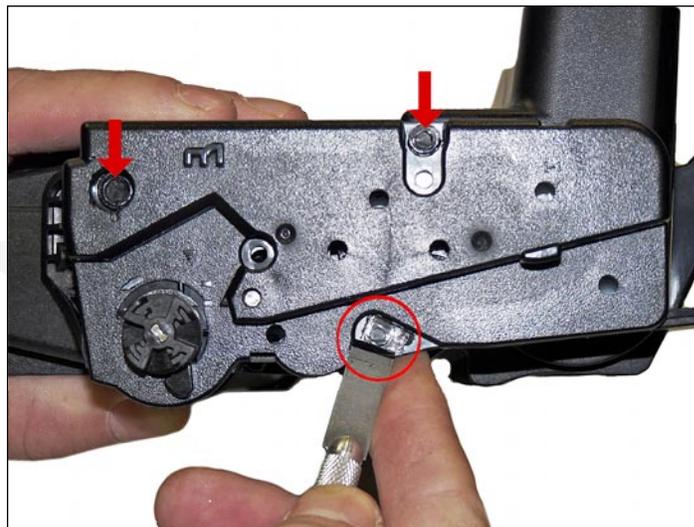
1. Toner approved vacuum
2. A small Common screwdriver
3. A Phillips head screwdriver
4. Needle nose pliers

REQUIRED SUPPLIES

1. Replacement Toner for use in the Xerox WC 3315 series
2. New replacement chip (check for the right cartridge # and the proper region)
3. New OPC drum (optional). Make sure you have the correct drum (see note above)!
4. New developer roller (optional)
5. New PCR (optional)
6. New wiper blade (optional)
7. New doctor Blade (optional)
8. Conductive grease
9. 99% isopropyl alcohol
10. Drum lubricating powder
11. Small tube of silicone caulk



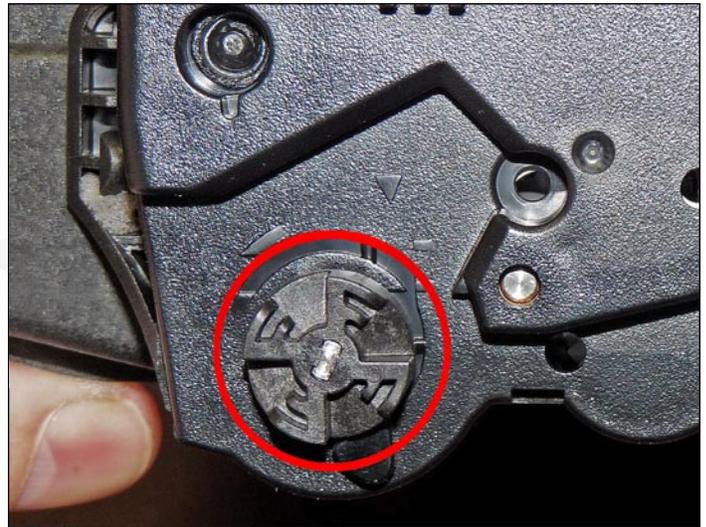
1. On the contact side of the cartridge, slice off the heads of the three plastic rivets with a chisel blade knife. If your knife is too wide, you may find it necessary to drill out the upper recessed rivets on both sides. Leave the end cap on for now.



2. On the opposite side end cap take the chisel blade knife and slice off the heads of the three plastic rivets. See above step for recessed rivets. Leave the end cap on for now.



3. The drum axle arms on both sides of the cartridge stay with the end cap. There is no need to remove them.



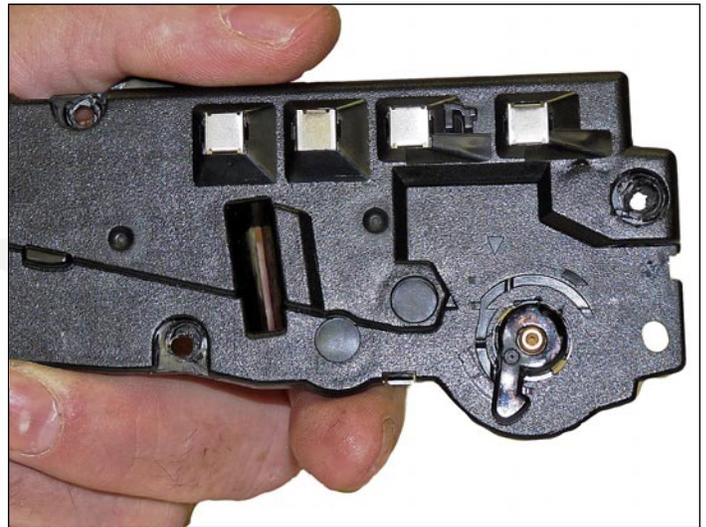
4. Remove the drum drive gear.



5. While still on the same side, locate the two tabs.

Press in on each tab, and remove the end cap.

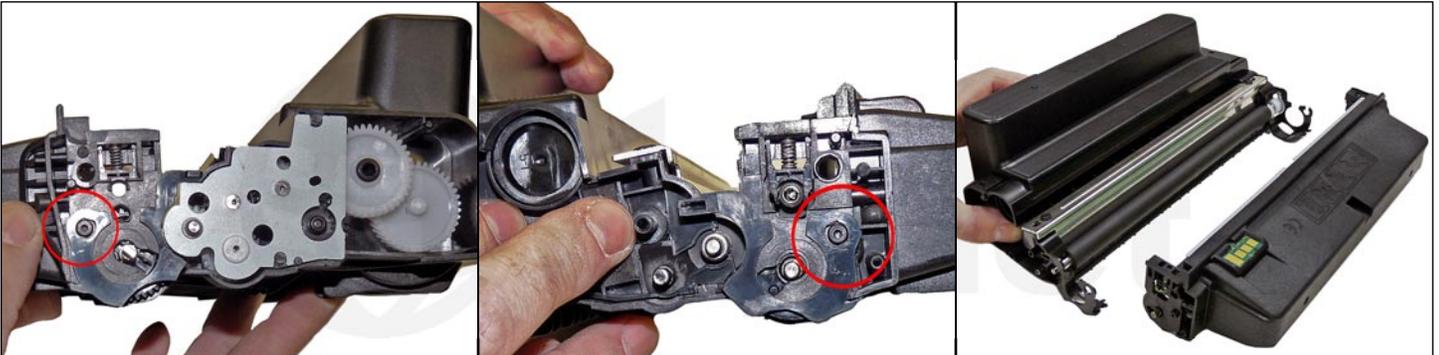
The drum axle arm will come off with the end cap.



6. On the right side end cap, press in on the three tabs and remove the end cap.



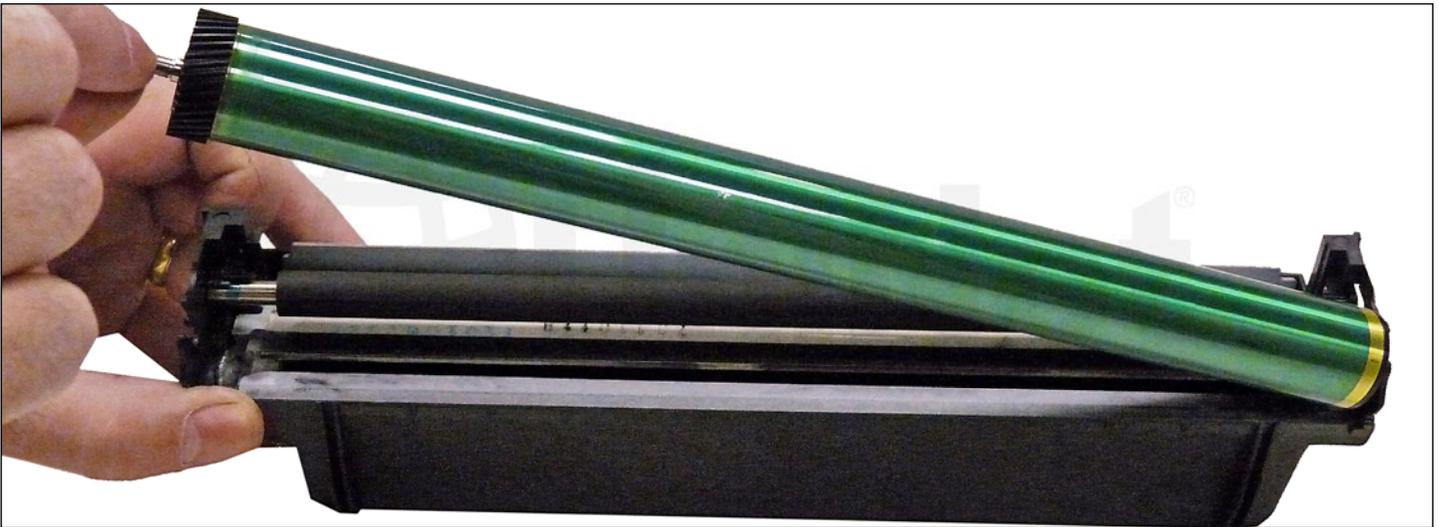
7. Separate the two halves slightly and lift off the middle top cover.



8. Gently pry up on the tabs on both sides of the cartridge and remove the waste hopper.

Be careful to hold the drum so it does not become damaged.

Remove the drum/waste assembly.



9. Remove the drum.



10. Remove the PCR from the assembly.

11. Clean the PCR with your normal PCR cleaner.

WARNING: Do not clean the OEM PCR with alcohol, as this will remove the conductive coating from the roller.

If the PCR is an aftermarket, follow the cleaning methods recommended by the manufacturer.

If the PCR is an OEM, we recommend it be cleaned with your standard PCR cleaner.



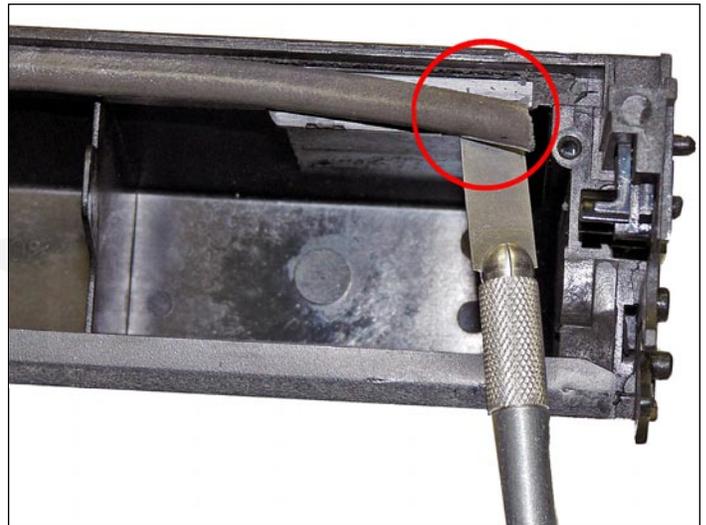
12. Remove the two screws from the wiper blade, and remove the blade.

It's easy to remove if you slide it out from under the PCR holders.

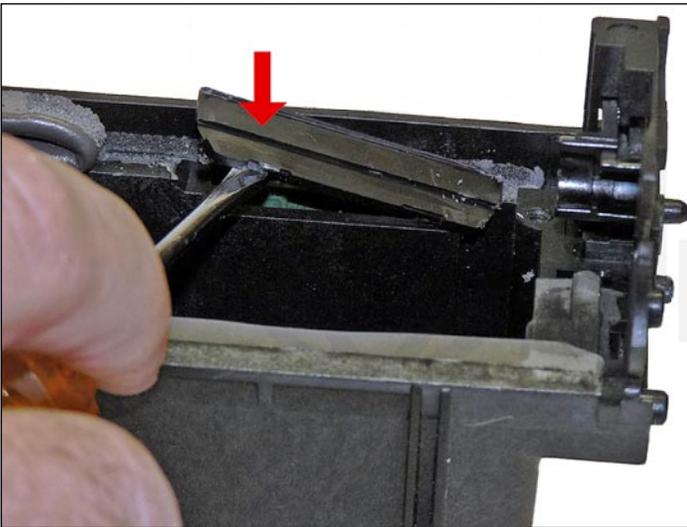


13. Clean out all the waste toner from the hopper.

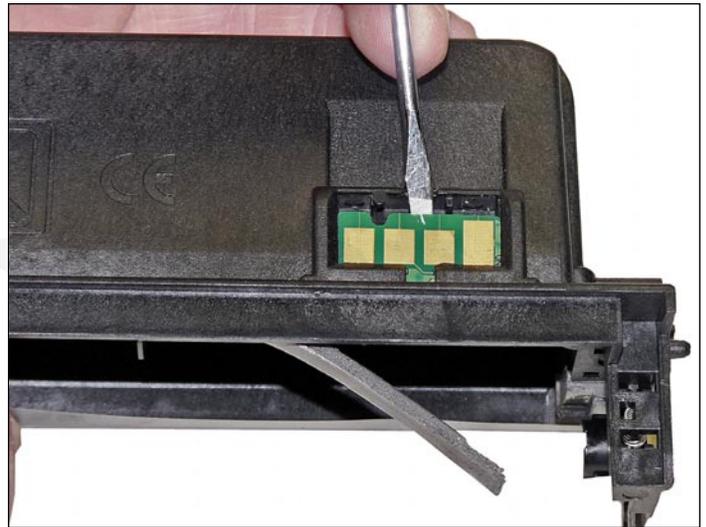
Make sure the seals are clean.



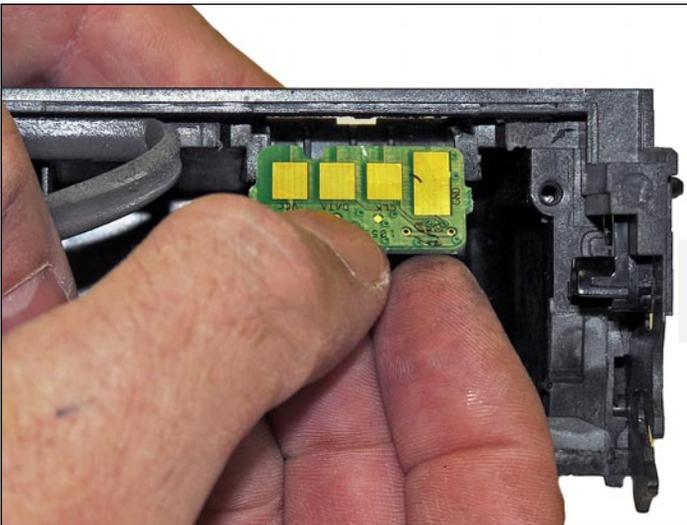
14. Carefully remove the wiper blade seal from the right (chip) side. Peel the seal back around 3 inches.



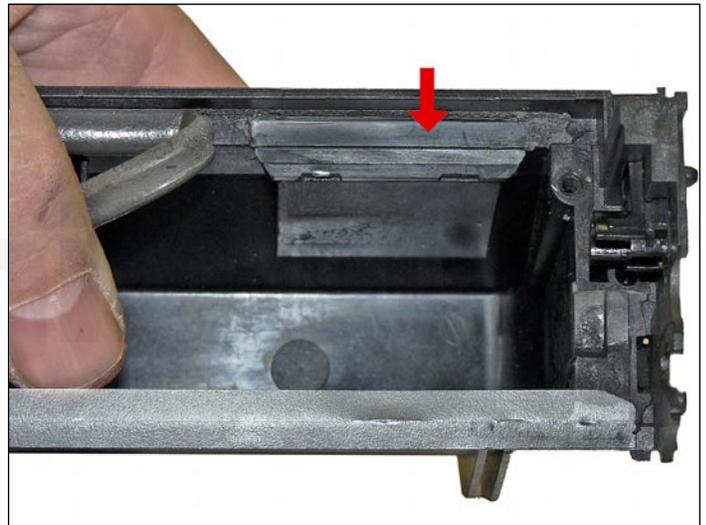
15. Pry up the chip cover.



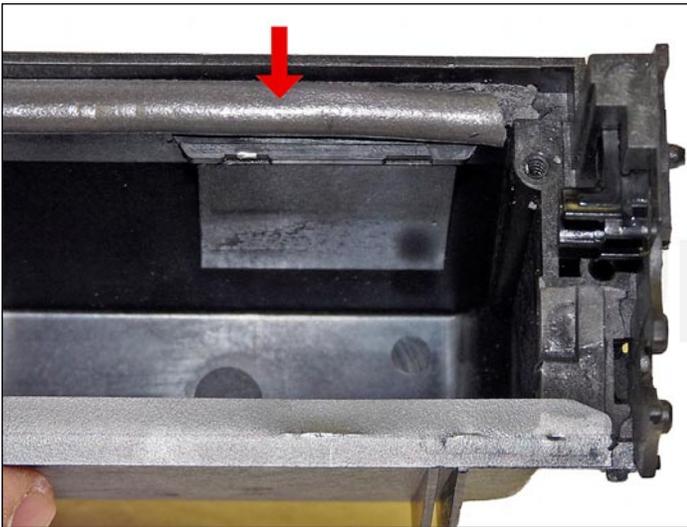
16. Lift up on the tab as shown, and press the chip out through the opening.



17. Replace the chip.



18. Replace the chip cover.



19. Re-install the wiper blade seal. Use 100% silicon if the seal tore to prevent any leaks. Just like the OEM did, be careful not to use any silicon on the chip cover area, otherwise it will be very difficult to replace the chip on the next cycle.



20. Install the new wiper blade and two screws.

It is easier to install if you slide it in under the PCR holders.



21. Place a small amount of conductive grease in the holders.

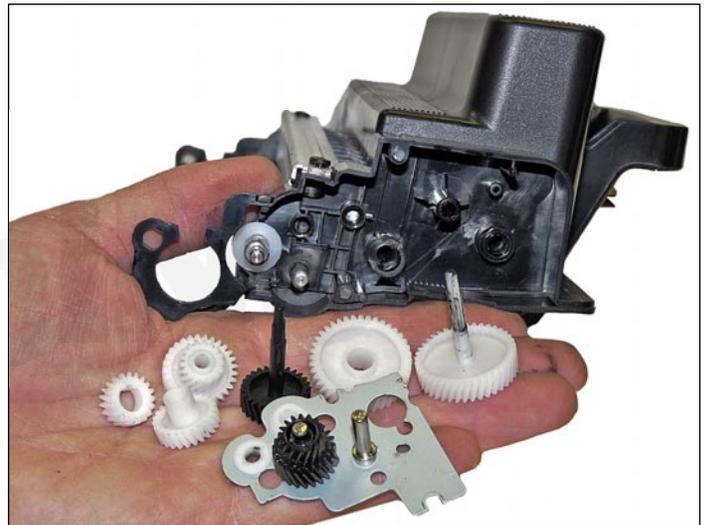
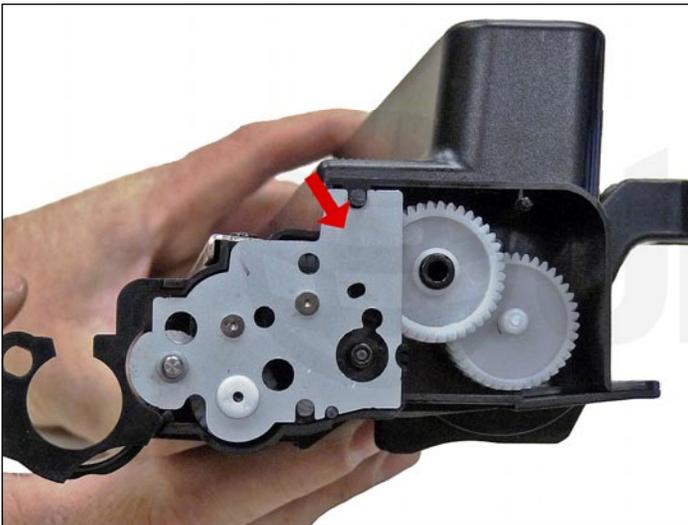
Install the PCR, long shaft side to the gear or non-chip side.



22. Install the drum with the large gear to the gear or non-chip side of the drum into the waste hopper.



23. On the supply hopper, carefully pry out the fill plug and dump out any remaining toner. The fill plug can be difficult to remove as it is recessed. Take a small common screwdriver and work it around the edge lifting slightly until it comes loose.



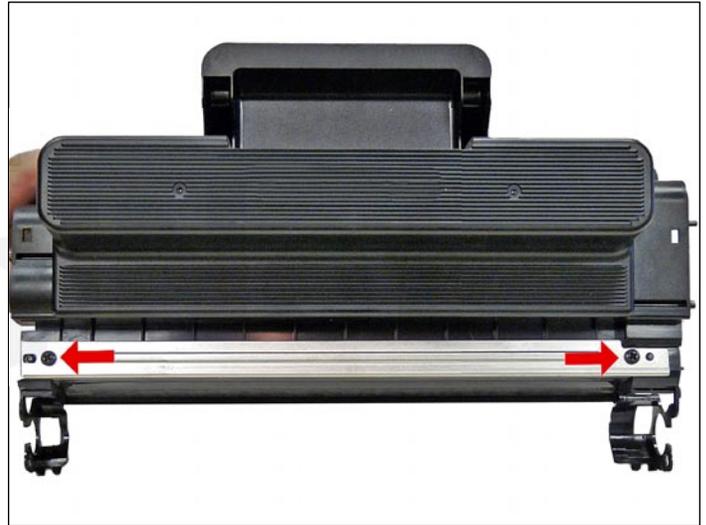
24. Pry off the gear plate, and remove the gears.



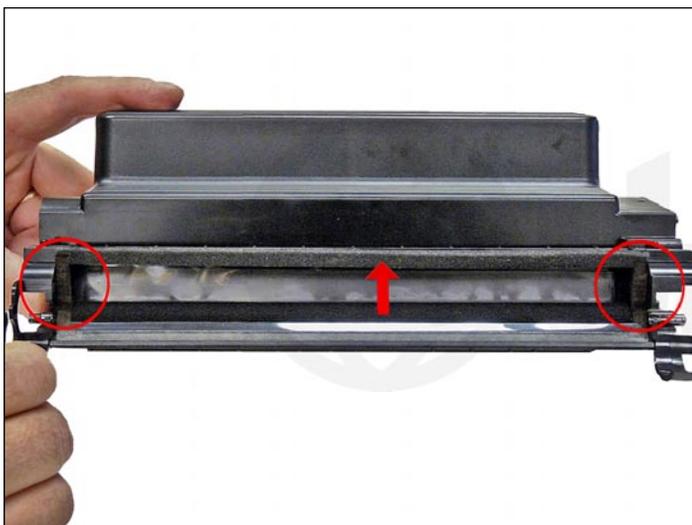
25. Remove the developer roller bushings from both sides.



26. Remove the developer roller.



27. Remove the two screws from the doctor blade, and remove the blade.



28. Clean out all the remaining toner from the hopper.

29. Make sure the doctor blade sealing foam and the developer rollers seals are clean and intact.



30. Clean the doctor blade edge, so there is no evidence of build up along the edge. If any buildup exists, the cartridge will streak. No chemicals should be used. We have found using a clean ice cream type wooden stick works great for scraping the blade clean without damaging it.



31. Install the seal when available through the developer roller opening.



32. Pull the tail of the seal through the seal port.



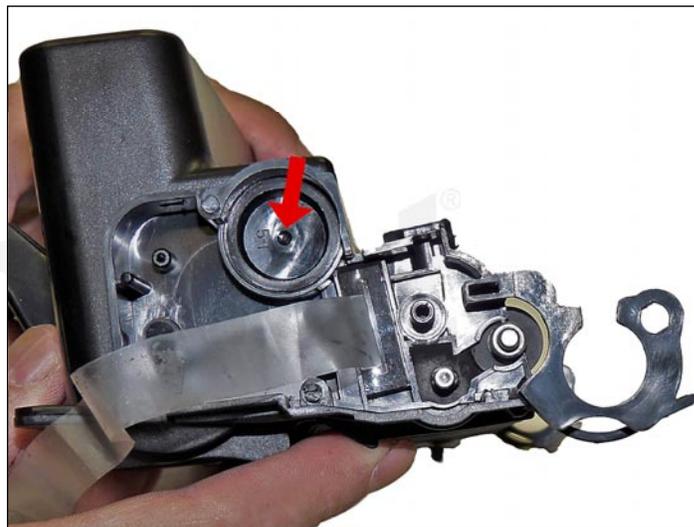
33. Install the doctor blade and two screws.



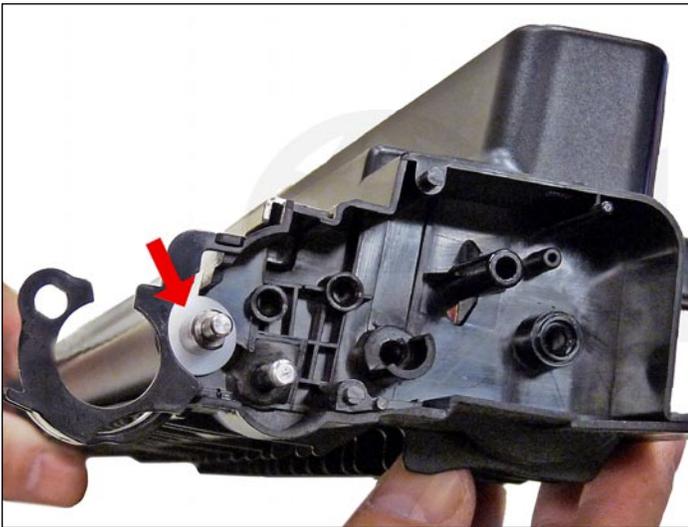
34. Clean the developer roller with a dedicated DVR cleaner, and replace into the hopper. Place the long shaft side to the gear side of the cartridge. It should snap in place if installed correctly.



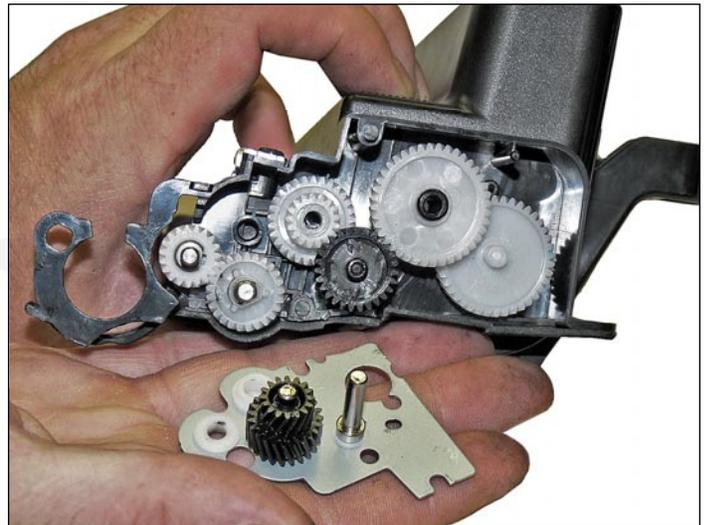
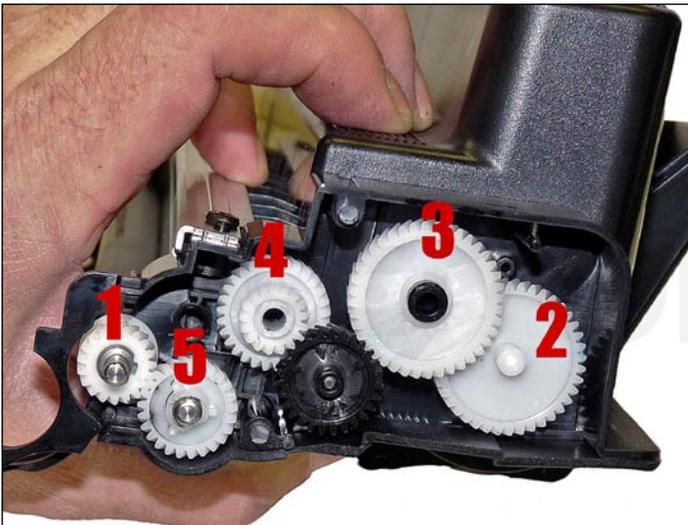
35. Clean and replace the conductive grease on the short shaft side of the roller.



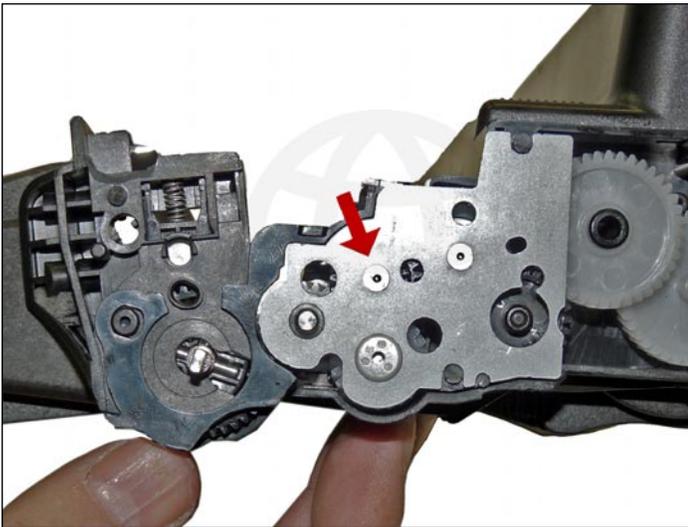
36. Fill the hopper with toner for use in the WorkCentre 3315 series. Replace the fill plug and check for leaks.



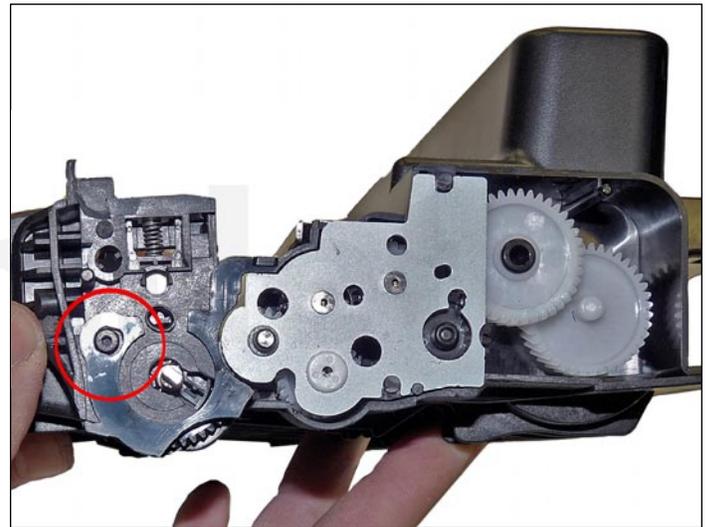
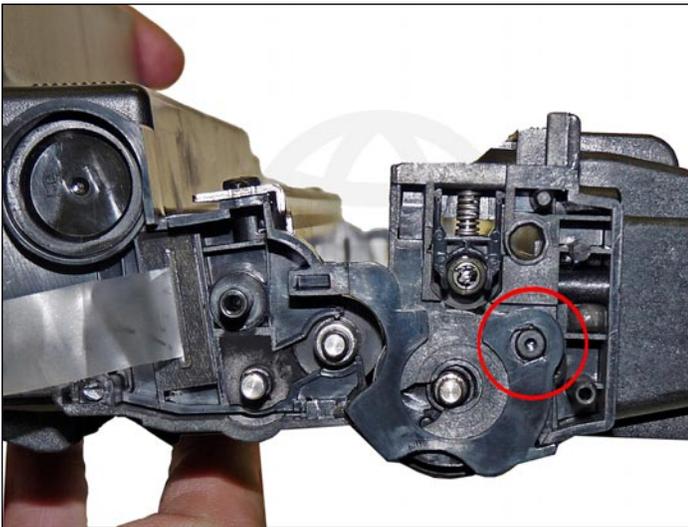
37. Replace the bushings on both side of the developer roller.



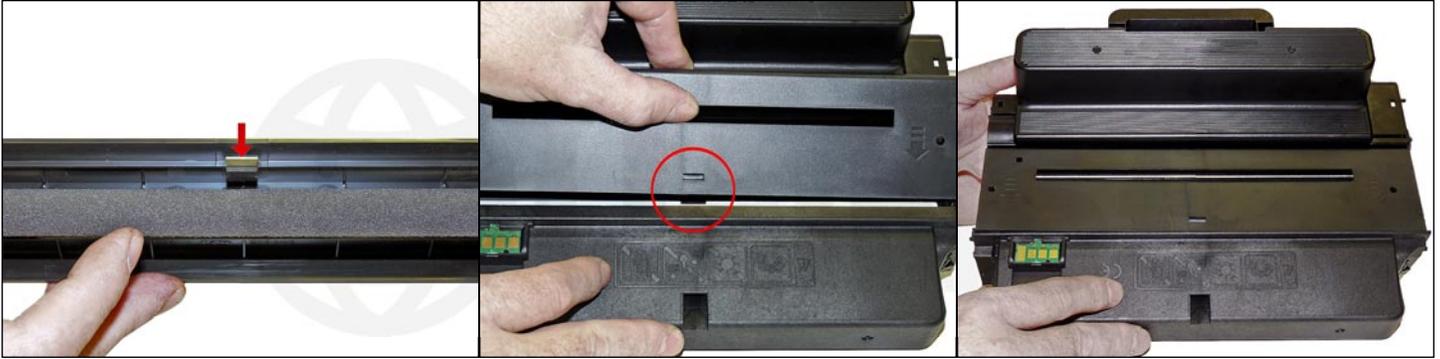
38. Install the gears in the order as shown.



39. Install the gear axle plate.

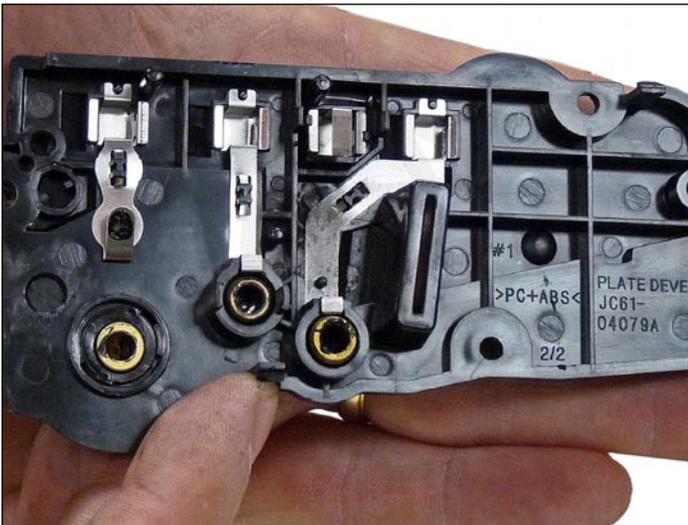


40. Fit both sides of the waste hopper tabs into the toner hopper.



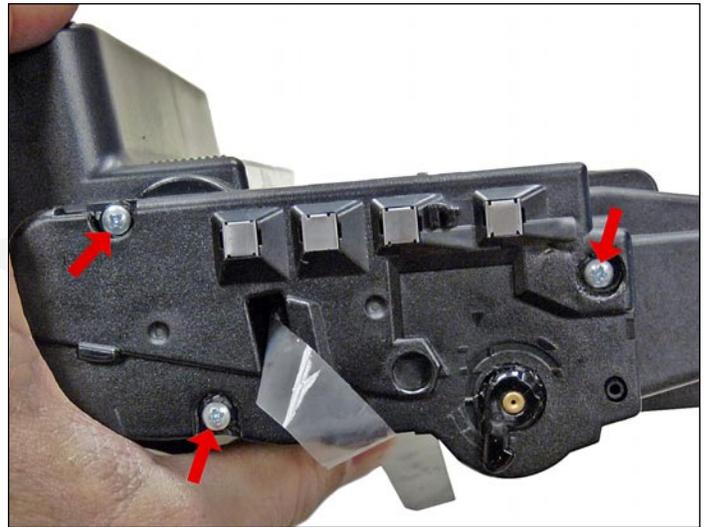
41. Slide the cleaned middle top cover/PCR cleaner assembly into place.

Make sure the center tab fits under the edge of the doctor blade



42. Clean the contacts on the left side end cap, and replace the conductive grease.

Snap the end cap into place.



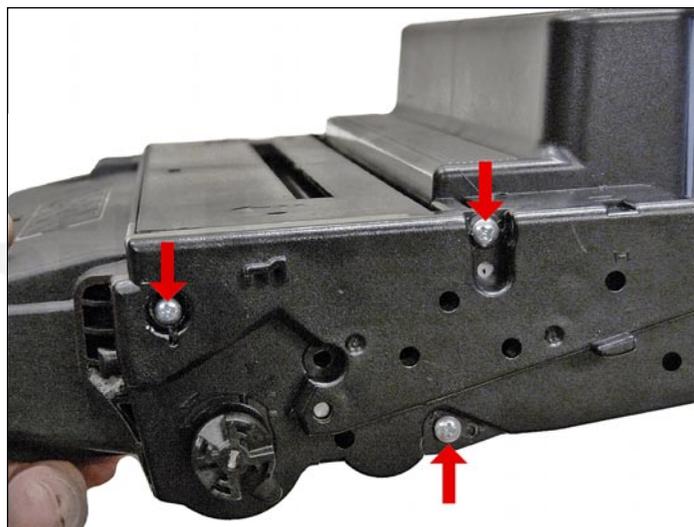
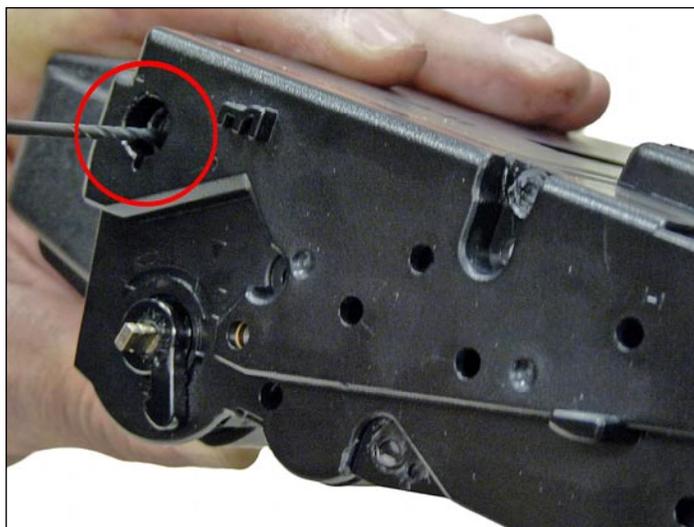
43. Drill three small holes that correspond to the screw size you're using.

Install the three screws into the end cap.



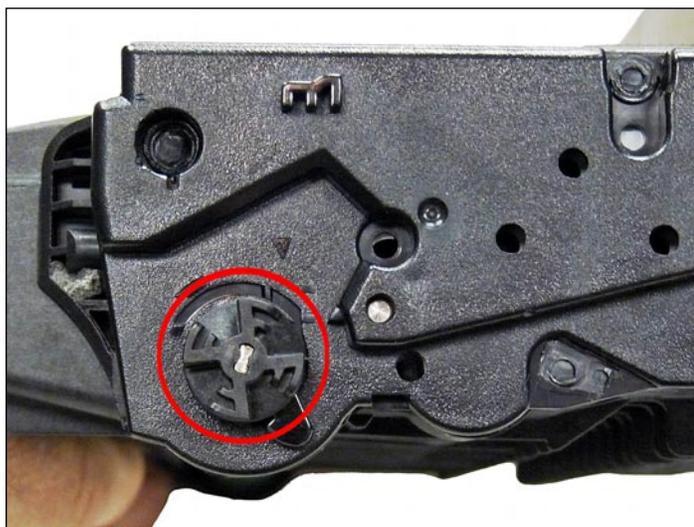
44. Clean the hubs on the gear or right side end cap.

Snap the end cap into place.

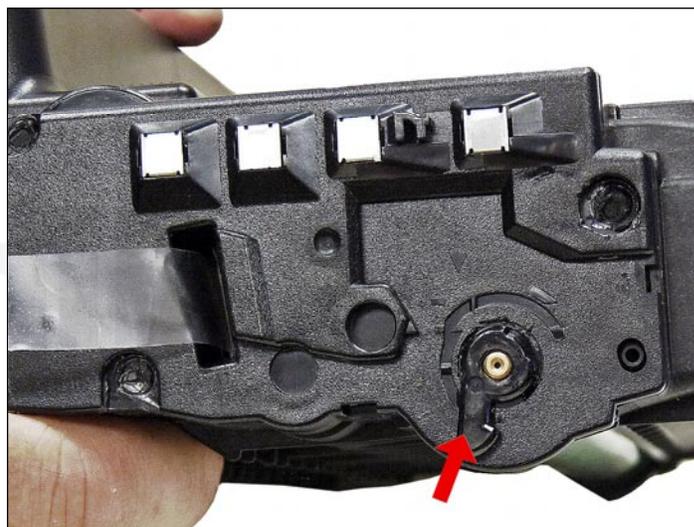


45. Drill three small holes that correspond to the screw size you're using.

Install the three screws into the end cap.



46. Install the drum drive gear.



47. The drum separators are fixed to the end caps. They should be set as shown. These arms keep the drum and developer rollers separated until the cartridge is installed in the printer.

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Upper heat roller:	77.5mm
OPC drum:	75.6mm
Lower pressure roller:	75.4mm
Supply roller:	49.0mm
Transfer roller:	47.0mm
PCR:	37.5mm
Developer roller:	35.0mm