xerox

DocuColor® 7002/8002
User Guide

Table of Contents

1

Machine Introduction

Machine Introduction

The DocuColor 7002/8002 is a full color/black and white digital press operating at a speed of eighty prints per minute. This chapter provides the location, name, and function of the various digital press components including:

- External components
- The User Interface (UI)
- The Control Panel
- Internal components
- Optional Accessories

Major Components

Number	Part	Description
1	On/Off ![On] On ![Off] Off	Press the Power Switch to the **On** position to power on the digital press. A screen message advises of a short wait while the Fuser warms up and the digital press runs a system check. Press the Power Switch to the **Off** position to power off the digital press. Allow the digital press to remain off for a minimum of twenty seconds before switching the power on again.
2	User Interface	The User Interface contains two components: the Control Panel and the Touch Screen and is used for messaging and to select settings.
3	Control Panel	Allows keypad selection of features.
4	Dry Ink/Toner Compartment	Contains the Dry Ink/Toner cartridges. The cartridge colors from left to right, are black, cyan, magenta, and yellow. Refer to the Maintenance Chapter of this manual for instructions on changing the cartridges.
5	Offset Catch Tray (OCT)	Receives completed print job. Sets are offset for easy separation. Maximum capacity is 500 sheets of 24 lb. (90 g/m^2) paper.
6	Exit Module	Contains the decurler and the inverter. The decurler removes any curl from the printed page. The inverter is used when duplexing or face down output is selected.
7	Right/Left Front Doors	Houses the image transfer system for simplex and duplex printing. Open to clear jams in the paper path in the Printing Module and at the Fuser. Follow the instructions precisely for clearing a jam in the Fuser.
8	Transport Module	The Transport Module carries the paper from the paper trays to the upper paper path of the digital press.
9	Paper Tray 2	Holds 2000 sheets of 24 lb. (90 g/m^2) paper.
10	Paper Tray 1	Holds 2000 sheets of 24 lb. (90 g/m^2) paper.

User Interface (UI)

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

1. Touch Screen
2. Control Panel

Touch Screen
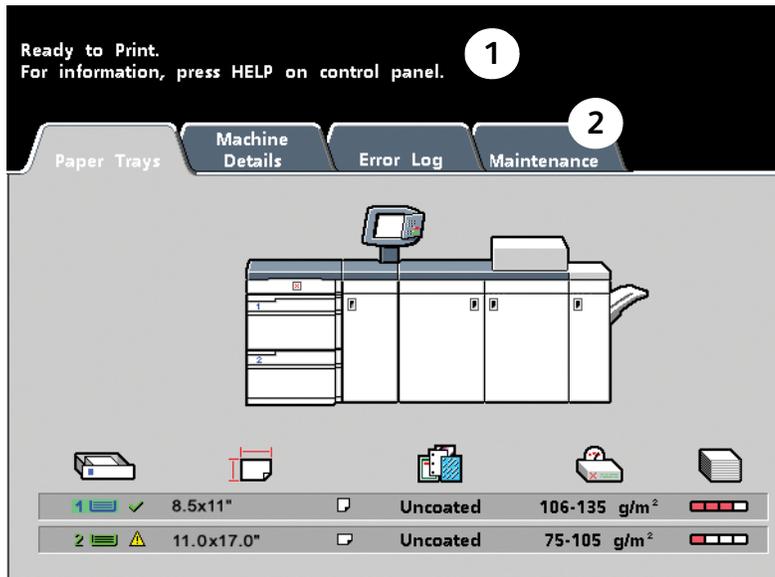
Number	Part	Description
1	Message Area	The message area at the top of the UI displays messages concerning the digital press status, programming conflicts, or errors. Messages may also provide instructions for the operator.
2	Tabs and Functions	Some UI screens display tabs containing various selectable options.

Control Panel

Keypad

Use the numeric keypad to enter your password for access to Tools Mode. Use the keypad for certain Tools Mode features. The keypad is also used by the service representative in the diagnostics mode.

Your digital press has one of two Control Panels: a Control Panel with words or one with international symbols. See the following for button functions.

Power Saver

Lights up when the digital press is in Sleep Mode. Press to return to Standby Mode.

Job Status

Displays a list on the UI of the current jobs and their status. You can hold, release, promote, delete, and see the options selected for each job.

Language

Allows you to select one of two languages.

Access

Allows access to the password-protected Tools Mode and the Auditron Mode.

Machine Status

Accesses the Paper Tray, Machine Details, Error Log, and Maintenance screens. Machine Status is where you find the serial number for the digital press, the customer support phone numbers, and the meters that show the count for color, black and white, color large size, and total output.

Help

Displays additional information useful in completing a task.

Clear All

The Clear All button is used in the Tools Mode for clearing certain selections or settings. Pause

Pause

Press the Pause button to pause printing in order to perform certain maintenance procedures such as changing the dry ink/toner cartridge. You must press Pause again to resume printing.

Start

The Start button is used in the Tools Mode for certain settings. It is also used by the service representative in the diagnostics mode.

Internal Spectrophotometer

Your digital press includes an internal Spectrophotometer, which is located in area 8A of the Exit Module.
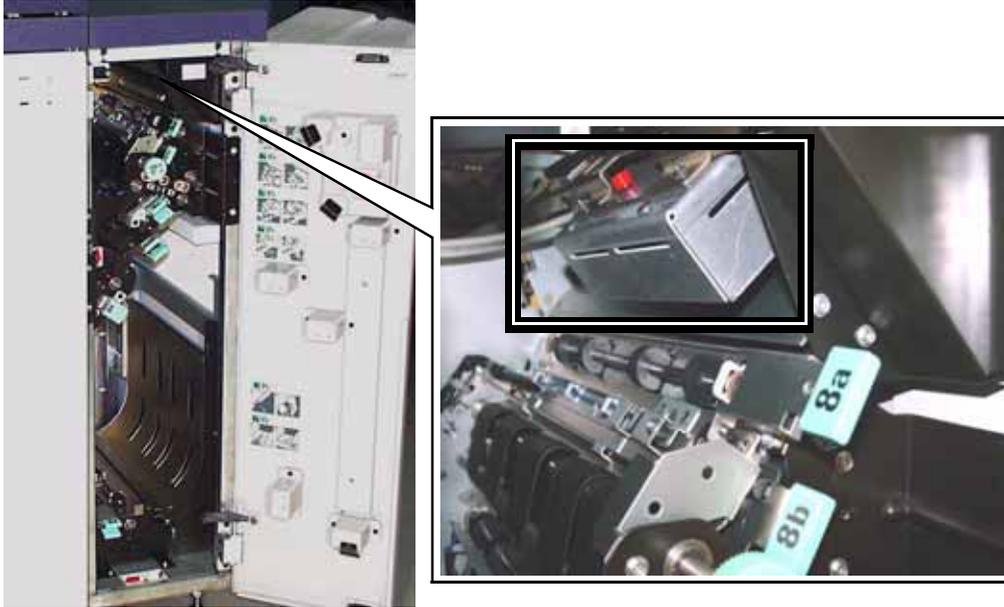
The internal Spectrophotometer is sometimes referred to as the "Inline Sensor" (ILS). The internal Spectrophotometer provides the customer with an internal calibration internal tool that ensures the digital press is ready to print colors. This feature provides the customer with the ability to calibrate the digital press from the Color Server without manually feeding calibration charts (also known as "calibration targets"). The customer can use this either in the present, or program it to calibrate at a designated time. It also allows the customer to maintain tighter control over the output of thier system.

Note

Refer to your Color Server's user documentation when performing the calibration workflow of the Color Server in conjunction with the digital press.

Job Management

Job Status

When you press the Job Status button, the *Job Status* screen is displayed.
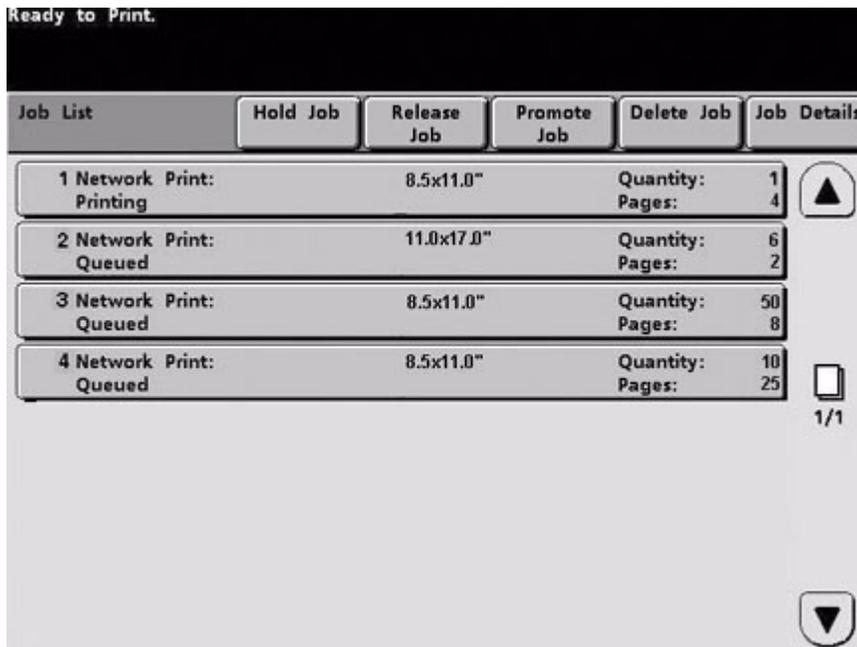
The *Job Status* screen includes Job Type, Current Status, Paper Size, Output Quantity (refers to the output in sheets for a single page job and in sets or stacks for a multiple page job), and total Number of Pages.

Jobs are numbered in the order they are received for processing.

Review the information that is provided for controlling the print workflow;

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

For more information about help, refer to Machine Details located in the Appendix.

Optional accessories

Optional feeding accessories

Feeding accessory	Description	Where to find information
Trays 3 and 4 (Second Feeder Module))	The two-tray Second Feeder Module (SFM), also referred to as Trays 3 and 4, provides an extra 4,000 sheet capacity of either 8.5 x 11 in. or A4 paper. Each drawer holds 2,000 sheets (16 lb. Bond to 80 lb. Cover/52 gsm to 216 gsm).	Information on Trays 2 and 4) can be found in this user guide. Refer to the following chapters for more information: • Loading Paper • How to Clear Jams • Optional Accessories • Specifications • Appendix

Optional finishing accessories

Finishing accessory	Description	Where to find information
High Capacity Stacker (HCS)	The HCS is an optional finishing device that provides stacking and offsetting capabilities for output to a Stacker Tray. The HCS80 connects to the right side of the digital press replaces the Offset Catch Tray (OCT).	Information on the High Capacity Stacker (HCS) be found in this user guide. Refer to the following chapters for more information: • How to Clear Jams • Optional Accessories • Basic Troubleshooting • Specifications • Appendix

Finishing accessory	Description	Where to find information
High Capacity Stacker/Stapler (HCSS) or Common Stacker/Stapler (CSS)	The HCSS and CSS are optional finishing devices (referred to as finishers) that provide stacking with offset and single or dual stapling output capabilities.	Information on the HCSS and CSS be found in this user guide. Refer to the following chapters for more information: • How to Clear Jams • Optional Accessories • Basic Troubleshooting • Specifications • Appendix
Xerox Document Binder 120-D (DB120-D)™	The Document Binder 120-D is a third-party, Document Finishing Architecture (DFA) device that uses a unique perfect binding technology combined with pre-formed covers to create a high quality professionally bound document. The Document Binder120-D provides: • Inline thermal binder • Binds 8.5 x 11" and A4 documents up to 120 pages in a variety of eye-catching pre-formed or custom covers • Requires Xerox High Capacity Stacker 80 to connect inline finishing devices	Information on the Document Binder 120-D can be found in the **Finishing Solutions Guide**; contact your Xerox sales representative for more information.
Duplo SCC Nearline Booklet Maker System™	The Duplo SCC Nearline Booklet Maker is a third-party device that provides: • Nearline booklet maker with stitch, fold, and face trim features • Automatic set-up and bar code reader options	Information on the Duplo SCC Nearline Booklet Maker can be found in the **Finishing Solutions Guide**; contact your Xerox sales representative for more information.

Finishing accessory	Description	Where to find information
Horizon ColorWorks/ColorWorks Pro Booklet Maker™	The Horizon ColorWorks or ColorWorks Pro Booklet Maker is a third-party, Document Finishing Architecture (DFA) device that provides inline booklet maker with scoring, bleed trim, face trim, stacking, folding, and stapling features. The ColorWorks Pro version provides additional scoring, full-bleed trim, and covers feed.	Information on the Horizon ColorWorks Booklet Maker c can be found in the **Finishing Solutions Guide**; contact your Xerox sales representative for more information.
Duplo DC-645 Slitter-Cutter-Creaser™	The Duplo DC-645 Slitter-Cutter-Creaser is a third-party device that provides: • Cutting and creasing operations in a single pass, plus it has the unique Duplo feature of being able to automatically adjust and compensate for image drift. • The ability to manage heavier media and larger sheet sizes at higher finishing speeds. Note This is an offline device.	Information on the Duplo DC-645 Slitter-Cutter-Creaser can be found in the **Finishing Solutions Guide**; contact your Xerox sales representative for more information.
Duplo Ultra 145A UV Offline Coater™	The Duplo Ultra 145A UV Offline Coater is a third-party device that provides high quality, cost-effective ultraviolet coating on documents. Note This is an offline device.	Information on the Duplo Ultra 145A UV Offline Coater can be found in the **Finishing Solutions Guide**; contact your Xerox sales representative for more information.

Finishing accessory	Description	Where to find information
Horizon Perfect Binder BQ-270x™	The Horizon Perfect Binder BQ-270xis a third-party device that provides: • High-quality production perfect binding with fully automated operation and push-button simplicity. • Intelligent touch-screen control console • Newly-developed adhesive application and side-gluing system • Automatic air-suction cover feeding with in-line scoring • Job programming and • Same-location loading and unloading for easier single-person operation Note This is an offline device.	Information on the Horizon Perfect Binder BQ-270x can be found in the **Finishing Solutions Guide**; contact your Xerox sales representative for more information..
GBC® Fusion Punch II™	The GBC Fusion Punch II is a third-party, Document Finishing Architecture (DFA) device that provides in-line printer punching that combines printing and punching into one step. Single sheets are punched and emerge ready to be finished into lay flat documents	Information on the GBC Fusion Punch II can be found in the **Finishing Solutions Guide**; contact your Xerox sales representative for more information..
Kern 515 EasyMailer®	The Kern 515 EasyMailer is a third-party device that allows for 11" x 17" (A3) or 8.5" x 11" (A4) cut sheet processing delivering a personalized envelope wrapped around an equally personalized letter.	Information on the Kern 515 EasyMailer can be found in the **Finishing Solutions Guide**; contact your Xerox sales representative for more information..

Where to Find Help 2

1-800 Telephone numbers

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

US: 1-800-821-2797 (Includes TTY Support)

Canada: 1-800-939-3769

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

www.xerox.com/eSupportCentre

How to find the machine serial number

You can find the serial number two places:

1. Press the **Machine Status** button on the Control Panel and then press the **Machine Details** tab, or
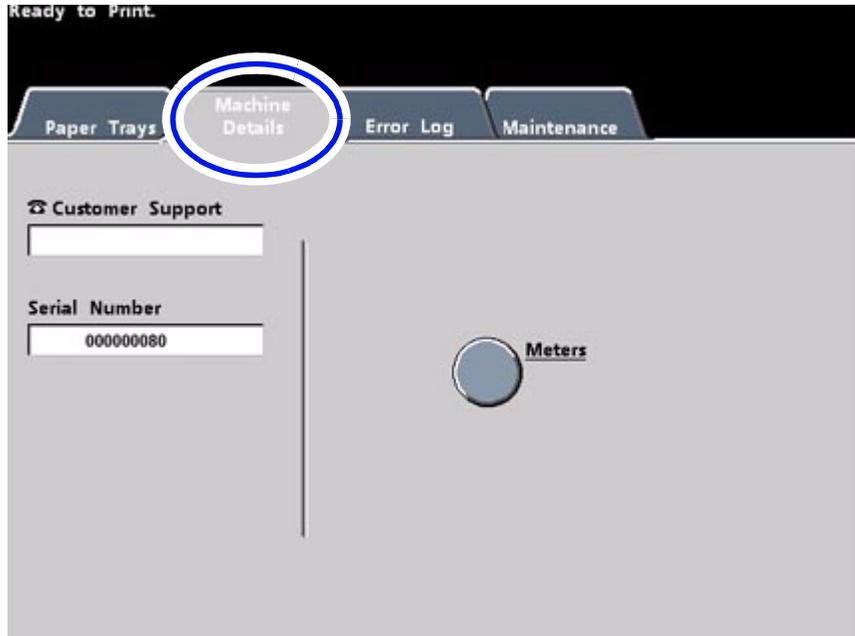
2. Open the front doors to locate the serial number plate on the frame.

How to read the Billing Meters
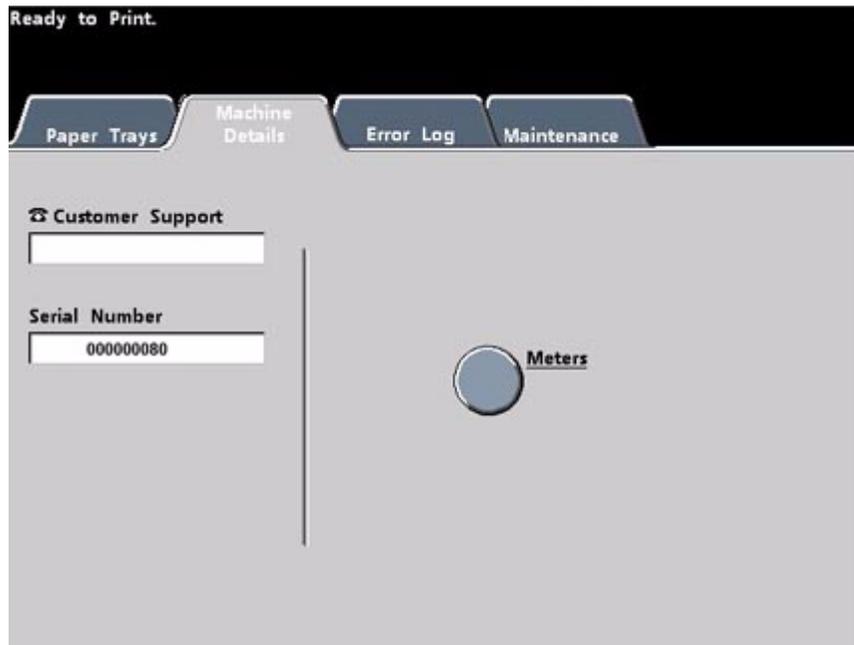
1. Press the **Machine Status** button on the Control Panel.
2. Press the **Machine Details** Tab.
3. Press the **Meters** button.

Reference Documents

There are additional reference documents available to you that provide more detailed information. Refer to the list below for the title, description and the location of the document.

Document	Description	Location
System Administration Guide	Provides detailed descriptions of System Administrator functions	Found on the Customer Documentation CD
Decurler Adjustment	An adjustment to help correct decurling problems	Found on the Customer Documentation CD
Specialty Media Guide	Provides specialty media recommendations, hints and tips regarding best printing practices.	Found on the Customer Documentation CD
Chapter 3 Loading Paper	Quick reference to loading paper	Found on the Customer Documentation CD
Corotron Test	Test opattern used to help determine image quality problem	Found on the Customer Documentation CD
Safety Guide	All the safety information associated with this machine	Found on the Customer Documentation CD

Loading Paper

3

Loading paper (Trays 1-4)

1. Lift the handle and pull out the paper tray.
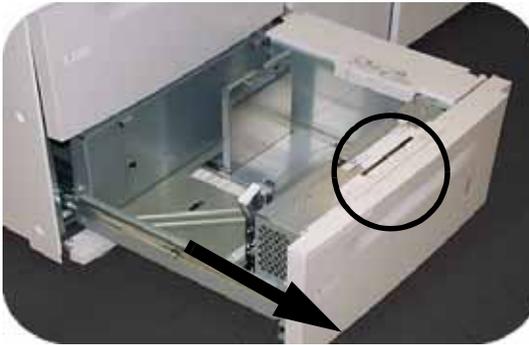
2. Select the appropriate paper stock for your print job.

3. Open the ream of paper seam side up and place it in the tray.

4.   Place the paper in the front right corner of the tray.
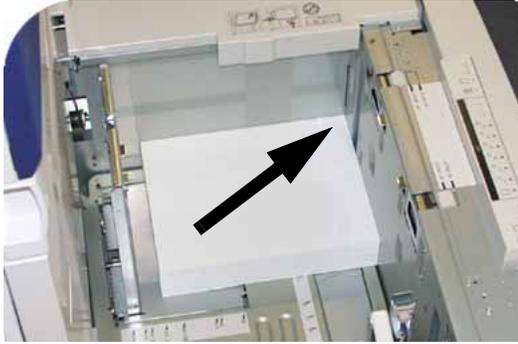
5.   **Do Not** exceed the "Max" fill line.
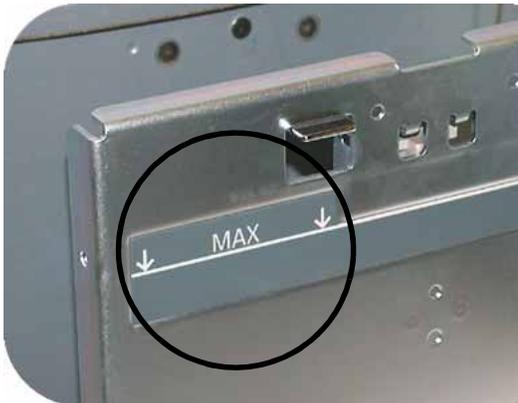
6.   Squeeze the green levers, and slide the Paper Guides until they touch the side of the paper.
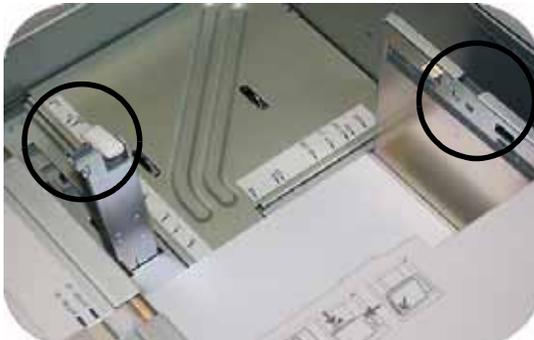
7.   Press the button to select **Non-Standard** or **Standard** at the front of the tray. The green light will indicate your selection.

Non-standard size paper is any paper for which there is no paper guide setting within the minimum and maximum sizes for the trays: 7.16 to 12.6 inch Long Edge Feed (LEF) or 7.16 to 19.2 inch SEF (182 - 320 mm LEF or 182 x 488 mm Short Edge Feed (SEF)
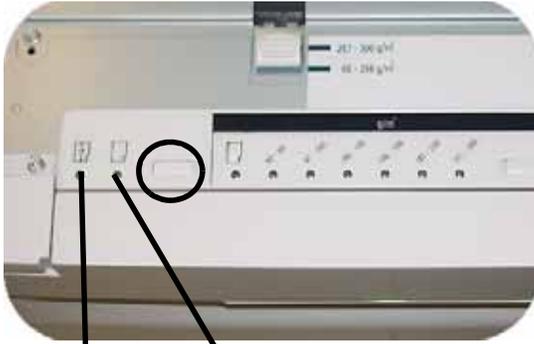
Non-Standard   Standard

8. Press the button to select **Transparency** or the appropriate paper weight. The green light will indicate your selection.

Transparency

9. Press the button to select **Coated** or **Uncoated**. The green light will indicate your selection.
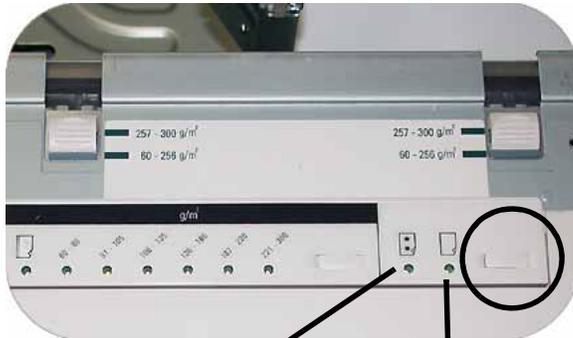
Coated   Uncoated

10. Select the position of the Paper Tray Blowers to match the weight of the paper stock in the tray.
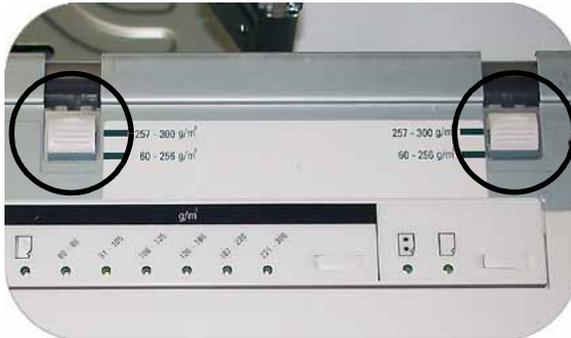
11. Slide the tray back into the machine until it locks into place.

Paper Tray Guidelines

For best results, remember the following:

- **Do not** store reams of paper in any of the trays.

- **Do not** use wrinkled, torn, curled, or folded paper.

- **Do not** mix sizes or weights of paper in a paper tray.

How to Clear Jams 4

Printer jam clearance

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

If power is interrupted during the printing process, it is imperative that you clear areas behind the Right and Left Front Doors <u>last</u>. Clear all other jam areas first.

Paper tray jams

⚠️ **CAUTION**

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

⚠️ **CAUTION**

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

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

Upper Transport Area

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

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

Transport Module

Refer to the video located on the Customer Documentation CD as needed.

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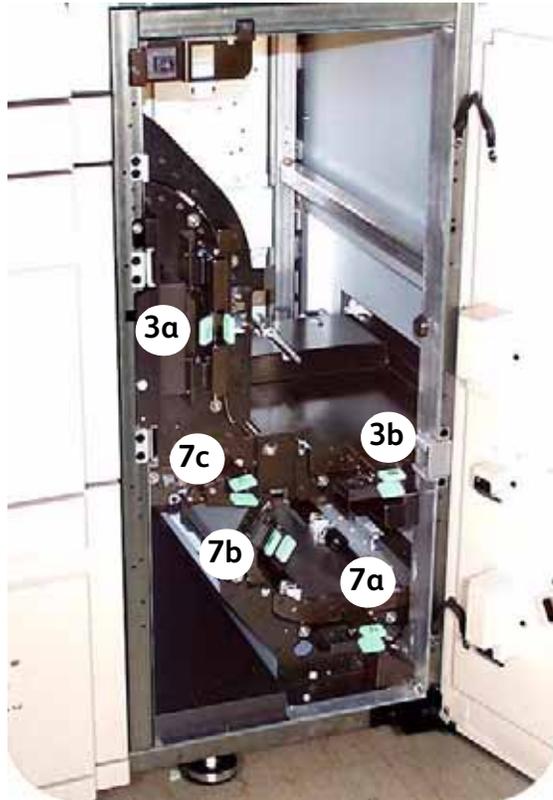
1. Open the Transport Module door.
2. Grasp the green handles 3a, squeeze and move it to the right.
3. Carefully remove all jammed paper.
4. Reposition handles 3a.
5. Lift up green handles 3b.
6. Carefully remove all jammed paper and return handles 3b to the original position.
7. Follow the UI messages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

Exit Module

Note

Refer to the video located on the Customer Documentation CD as needed.

Follow the instructions on the UI to clear jams from all the areas indicated in the Exit Module.

Follow the instructions on the UI to restart your print job.
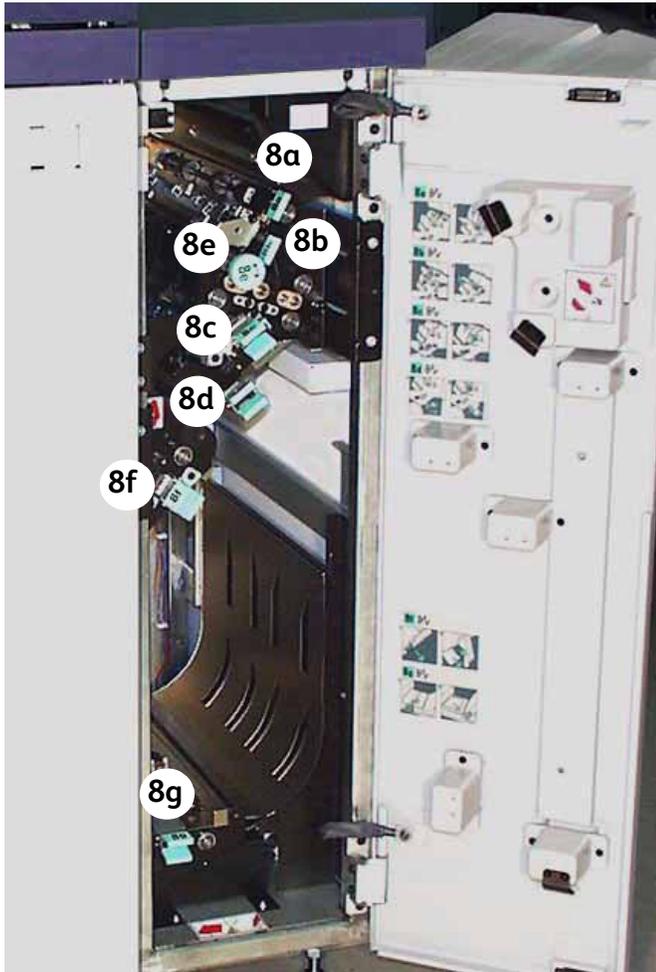
Right/Left Door Paper Path

⚠ **WARNING**

Be careful when clearing jams in the Fuser Area. The Fuser is extremely hot and will cause injury.

Note

Refer to the video located on the Customer Documentation CD as needed.

Tip

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

Note

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

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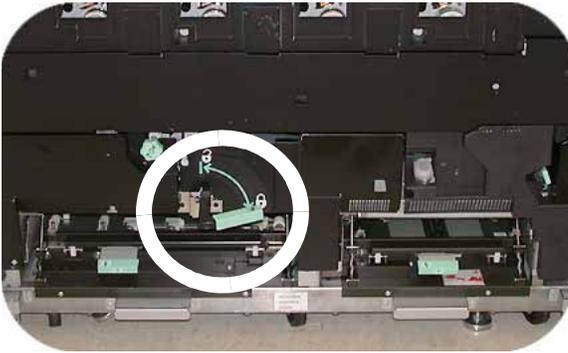
3. Slowly pull out the Paper Transport module until it stops.
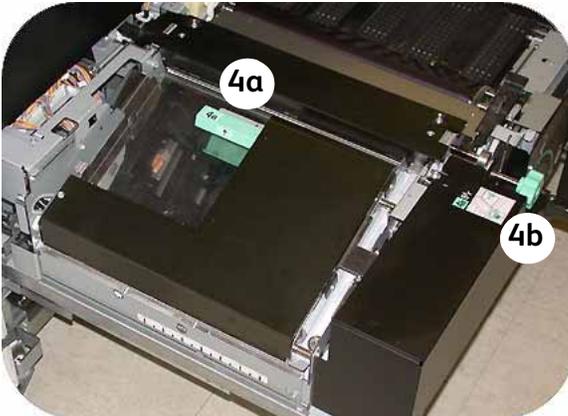
4. Lift handle 4a and carefully remove all jammed paper, ensuring that all pieces are removed if the paper is torn. Turn the green handle 4b to free any paper that is caught.
5. Reposition green handle 4a.

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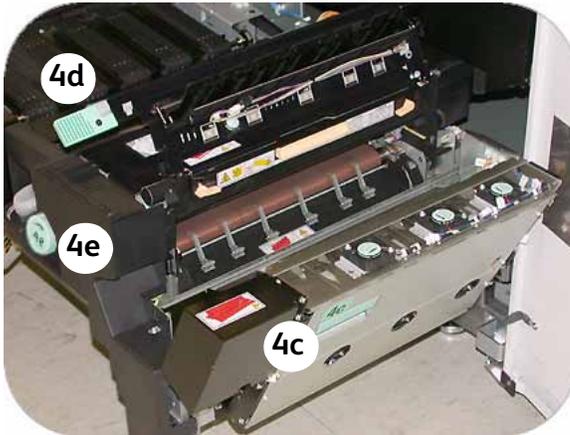
7. Lift up handle 4d until it stops and clear any jammed paper. Rotate knob 4e in the direction of the arrow on the knob to clear any paper that is caught.

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

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

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

10. Close the Right and Left Front Doors.

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

Jam Clearance with 2-Sided Printing

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

1. Open the Right and Left Front Doors when directed to by a UI message.
2. Lift handles 5 and 6 and clear any paper in the areas.
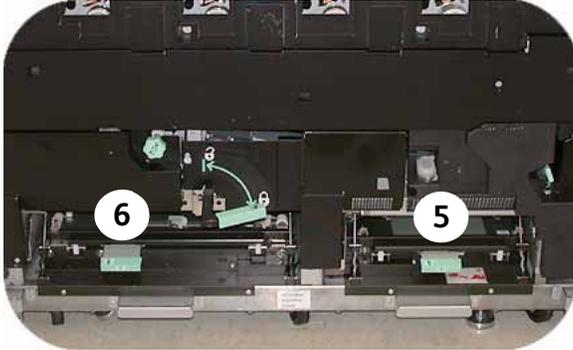
⚠️ **CAUTION**

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

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

High Capacity Stacker 80 (HCS80)

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

Bypass Area

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

1. Remove any paper from the Top Tray.
2. Lift the HCS80 **Top Cover**.

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

High Capacity Stacker/Stapler (HCSS) and Commn Stacker/Stapler (CSS)

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

Read the following steps for more information on how to clear a jam.
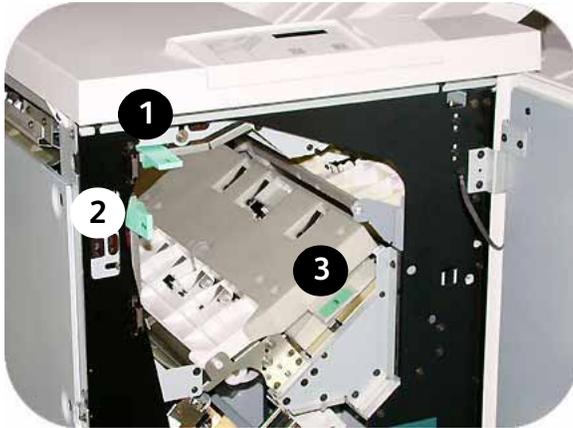
1.   Open the finisher Front Door. There are three possible jam areas. Handle 1 moves down, handle 2 moves to the right, and handle 3 moves up.
2.   Remove all jammed paper only from the area indicated on the Touch Screen and the finisher Control Panel Display. Do not remove paper from any other areas.
3.   Reposition the handle.
4.   Close the finisher Front Door.
5.   Follow any instructions on the Touch Screen to restart your print job.

How to adjust Paper Curl

5

Paper Curl

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

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

If the curl is unacceptable, you can change the setting.

To change the paper curl setting, you must enter the Tools mode.

Tool Mode

1. To enter Tools Mode, press the **Access** button on the Control Panel. The *Access Password* Screen appears.

2. Use the keypad to enter your password.
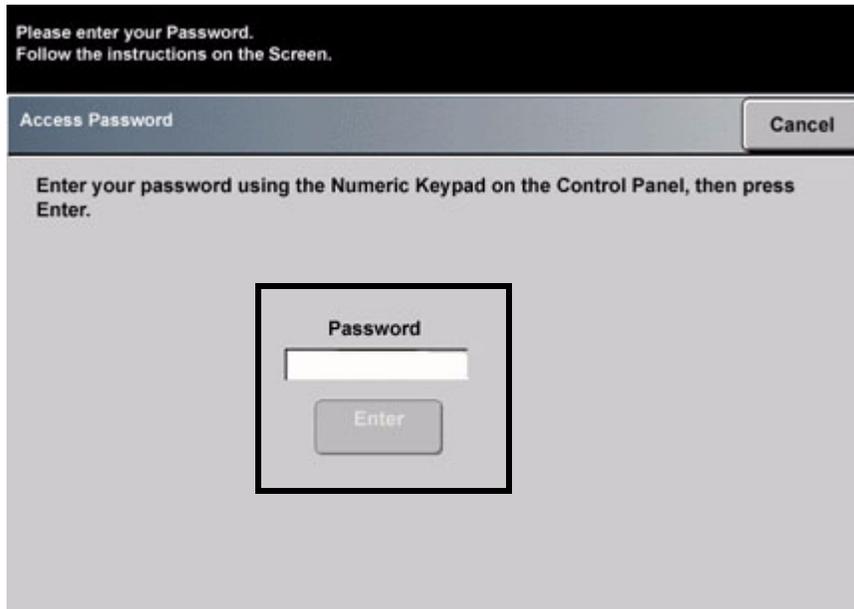
3. Press the **Enter** button.

4. Press the **Tools Pathway** button to enter the Tools Mode.

5. Press the **Machine Default 2** Tab and then press the **Decurler Setup** button.

6. When the Decurler Setup screen appears, enter the paper tray number you are using, coated or non-coated and the paper weight.

7. The default curl setting (Paper Type) for the selected paper will be displayed (A-D). Type A is selected in the example screen.

8. Select a different setting (A-D) and run the job again. Some experimentation may be needed to find the correct setting.

Note

If you are not able to find an acceptable setting that minimizes curl, refer to the document entitled **DocuColor 7002/8002 Decurler Adjustment**.

How to Run Tabs

<div style="text-align: right; font-size: 3em;">6</div>

Tabs

Tabbed Inserts can be loaded into the paper trays as Non-Standard paper.
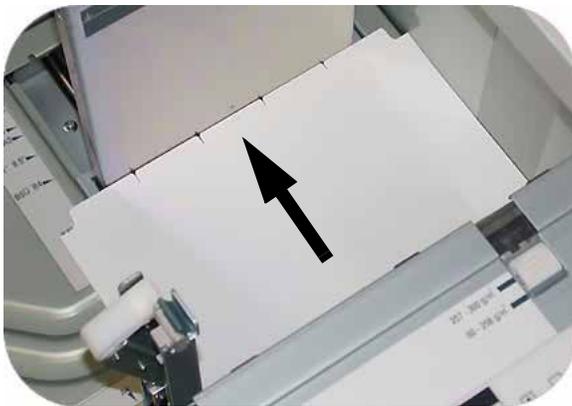
1. Load 9 X 11 inch tab stock (228 x 279 mm) in the paper tray with the tabs with the short edge of the tabs in the lead edge position.

Note

If a jam ocurrs, there is no recovery procedure. You will need to manually recover.

2. Press the button to select the appropriate tab weight. The green light will indicate your selection.
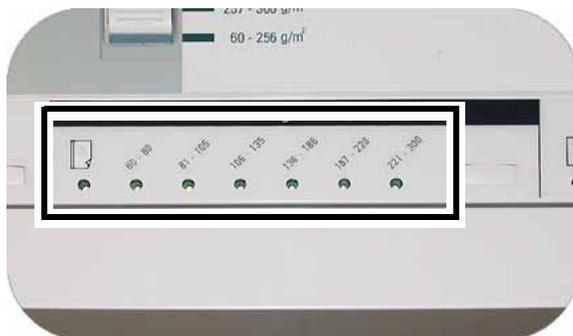
3. Press the button to select **Non Standard** or **Standard** at the front of the tray. The green light will indicate your selection.

Standard

Non-standard
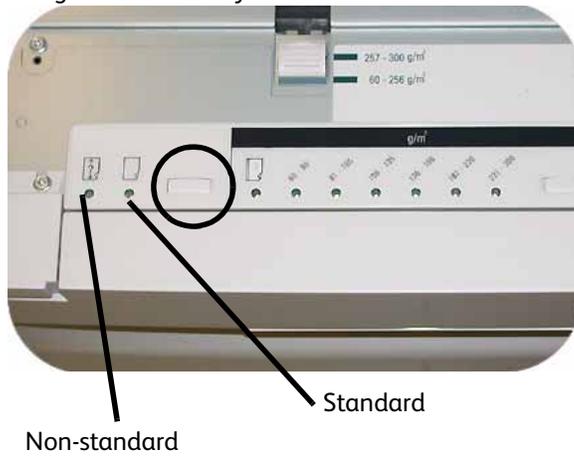
4. Press the button to select **Coated** or **Uncoated**. The green light will indicate your selection.

Coated

Uncoated
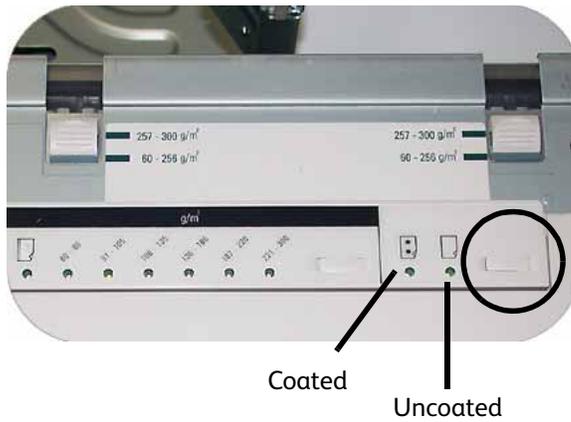
5. Enter Tools Mode: Press the **Access** button on the Control Panel. The *Access Password* Screen appears.

6.   Use the keypad to enter your password.

Please enter your Password.
Follow the instructions on the Screen.

Access Password   Cancel

Enter your password using the Numeric Keypad on the Control Panel, then press
Enter.

Password
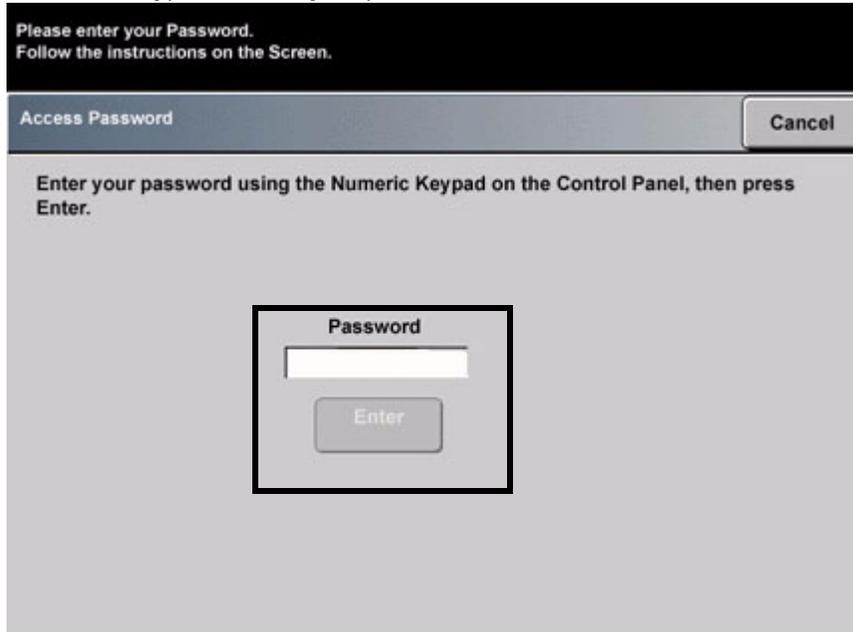
Enter

7.   Press the **Enter** button.
8.   Press the **Tools Pathway** button to enter the Tools Mode.
9.   Press the **Non-Standard Paper Size** button.

Tools Mode.

Machine   Machine   Service Call   Exit Tools
Defaults 1   Defaults 2

Initial Screen   Audio Tones   Set Date & Time

NVM Read / Write   Productivity   Dual Language
                         Setting

Tray Priority   Auto Tray   Non-Standard
                         Switching   Paper Size

System Timers   Oversize Paper   D-MAX Setup
                         Offset
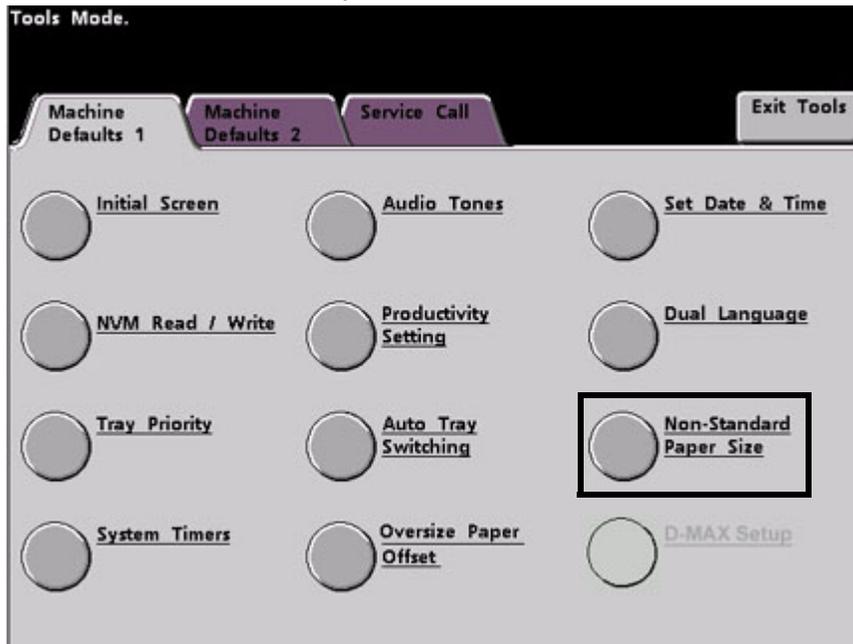
10. Select the appropriate Paper Tray and enter 11 in the X Axis box and 9 in the Y Axis box by using the up and down arrow buttons.
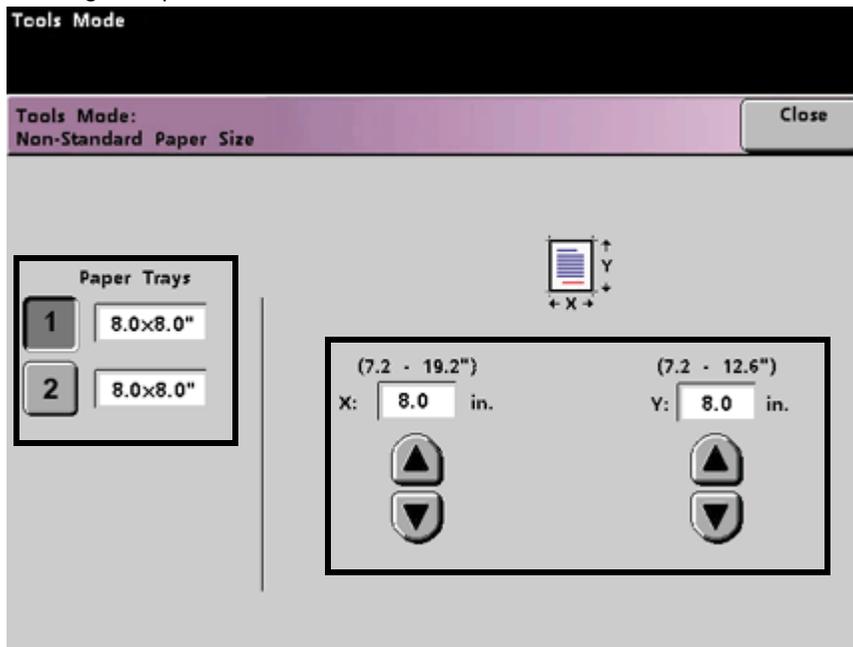
11. Run the tab job.

Productivity Settings

7

Overview

The productivity of the digital press relates to the continuous speed of the media output as measured in prints per minute (ppm). The continuous speed is dependent on paper size, paper weight, and fuser temperature. Use this productivity setting to optimize the throughput speed for the type of paper you run most frequently.

Productivity Setting options are shown and explained in the illustration:
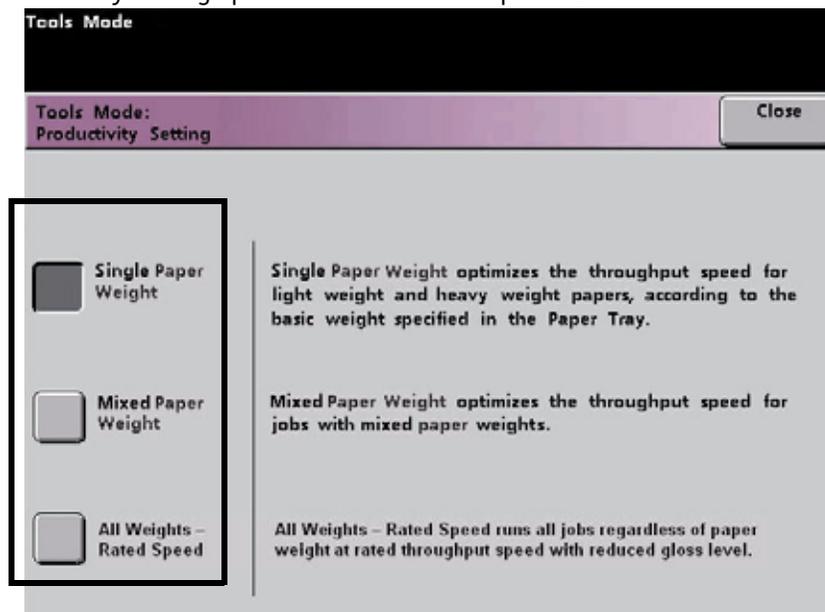
- **Single Paper Weight:**

This setting optimizes the throughput speed for light weight or heavy weight papers, according to the weight range that is set in the paper tray.

- **Mixed Paper Weight:**

This setting optimizes the throughput speed of print jobs that contain mixed media weights from different paper trays.

- **All Weights Rated Speed**:

This setting runs all jobs at the rated speed regardless of the paper weight. Gloss level may appear lower on heavier weight media. If a higher level of gloss is required, run the job at the **Single Paper Weight** setting.

Changing the Productivity Setting

1. Enter Tools Mode: Press the **Access** button on the Control Panel. The *Access Password* Screen appears.

2. Use the keypad to enter your password.
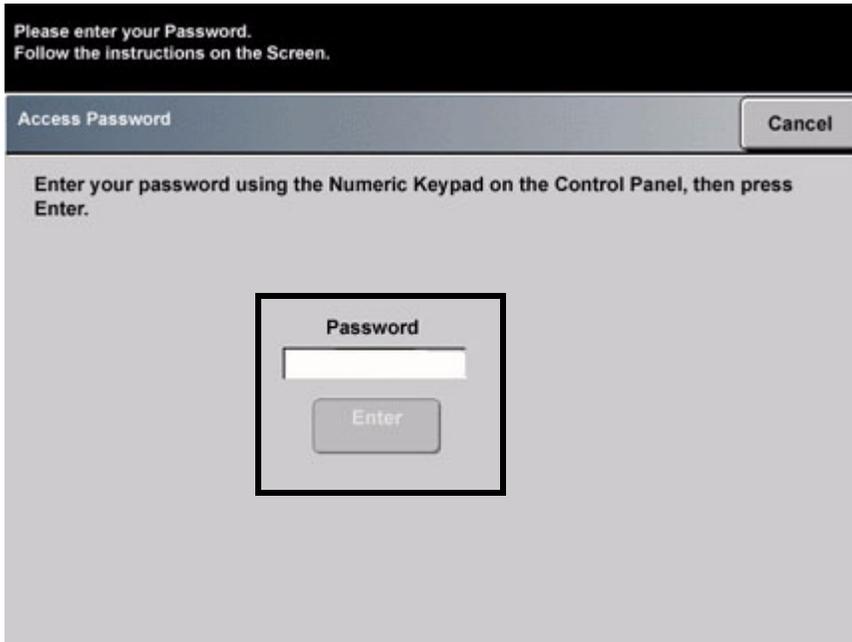
3. Press the **Enter** button.

4. Press the **Tools Pathway** button to enter the Tools Mode.

5. Press the **Productivity Setting** button.
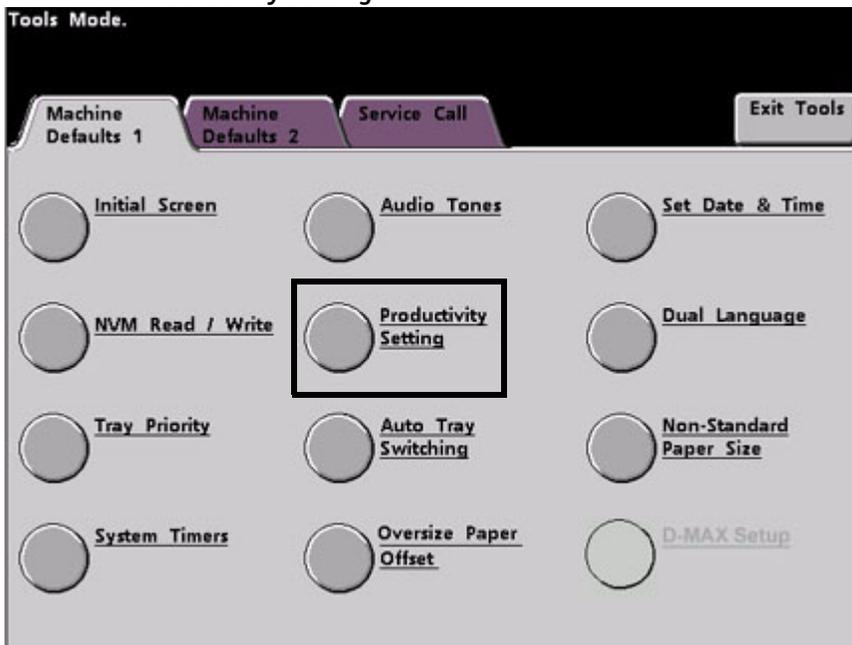
6.   Select the desired productivity setting.
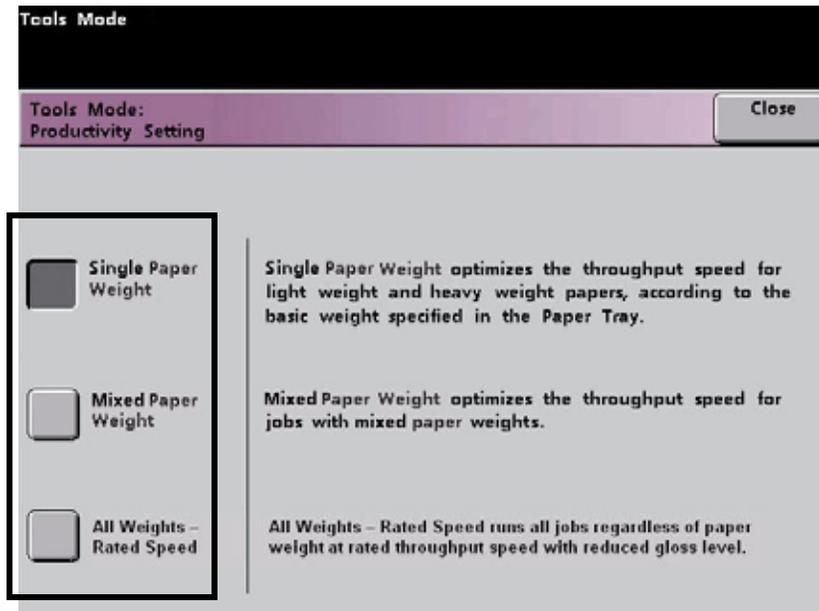
7.   Select **Close**.

All jobs will run at the selected productivity setting until changed in Tools Mode.

Optional Accessories

8

The accessories included in this module are:

- Paper Trays 3 and 4
- High Capacity Stacker 80 (HCS80)
- High Capacity Stacker Stapler 80 (HCSS80)/Common Stacker Stapler (CSS)

Trays 3 and 4 (Second Feeder Module)

Tray 3

Tray 4

The Second Feeder Module (SFM) is an optional feeding device that contains Trays 3 and 4. This module holds the same number and types of Media as Trays 1 and 2.

The specifications and operation are identical to the First Feeder Module. (Trays 1 and 2).

High Capacity Stacker 80 (HCS80)

Control Panel   Top Tray

Bypass
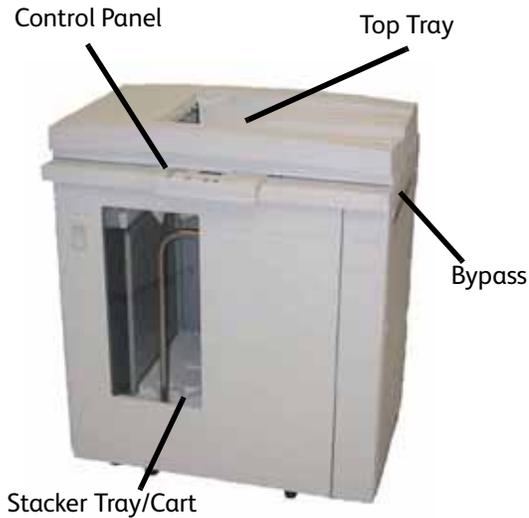
Stacker Tray/Cart

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

Top Tray

Sheets are transported to the Top Tray:

- When sheets are purged after a paper jam.
- When the Sample Set button is selected.
- When selected as an Output Location.
- Labels must be sent to the Top Tray.

Stacker Tray/Cart

Collated sets are transported to the Stacker Tray located on a moveable Stacker Cart.

Bypass

The Bypass (only required when a second stacking device is installed) transports collated sets through the HCS80 to a connected finishing device or to another HCS80.

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

Identifying the parts
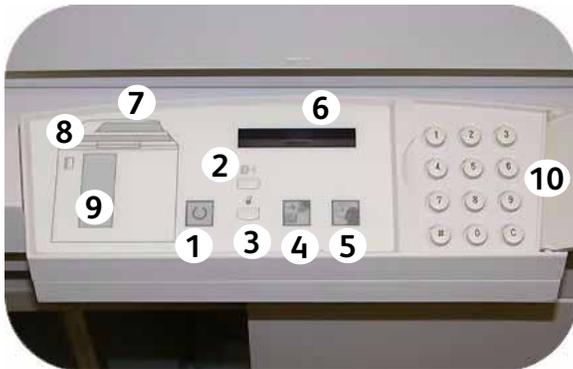
1 Ready light

The Ready light blinks during initialization and is constant when the HCS80 is in use or in standby mode.

2 Sample set button

Press to have the HCS80 deliver the next collated set to the top tray.

3 Unload button

Press once to lower the Stacker Tray and unlock the front door.

4 Unload light

Illuminates when the Stacker Tray has reached the down position and the front door can be opened.

5 Wait light

Blinks when the Stacker Tray is moving up or down.

6 Fault code display

Displays a code when a fault occurs in the HCS80. Refer to the HCS80 fault code table located in the Problem Solving section of this chapter.

7 Top tray jam area

Blinks when there is a jam.

8 Bypass jam area

Blinks when there is a jam.

9 Stacker tray jam area

Blinks when there is a jam or the door is open.

10 Keypad

HCS80 Cooling fan

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

Only switch on the cooling fan when running paper that weighs 120 g/m^2 (80 lb.) or greater.

Remember to switch off the fan after your job(s) finishes and when running paper that weigh less than 120 g/m^2 (80 lb.).
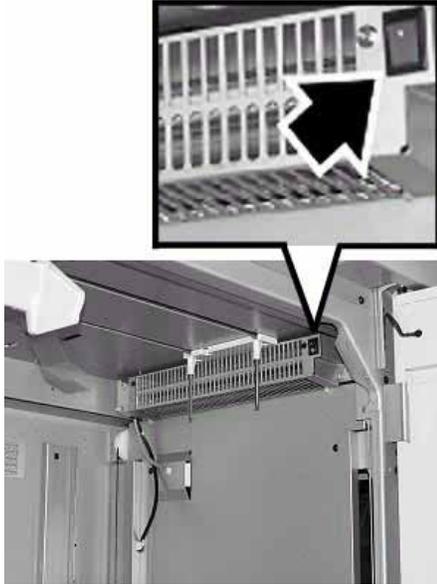
Unloading the HCS80 Stacker Tray

Use the following procedure to unload the Stacker Tray when it is full, or to retrieve a completed job.

1. Press the **Unload** button on the Stacker Control Panel. The Wait light blinks until the Stacker Tray has reached the down position.

2.   Open the front door when the Unload Light illuminates.

3.   Position the securing bar on top of the stacked paper.

4.   Pull the Stacker Cart straight out. Remove the securing bar.
5.   Remove the paper from the Stacker Tray.
6.   Push the empty Stacker Cart straight into the HCS80.
7.   Position the securing bar on the fixed area inside the HCS80.
8.   Close the door. The tray will rise to the operate position.

HCSS80/CSS

The HCSS80 and CSS are optional finishing devices (referred to as finishers) that provide stacking with offset and single or dual stapling output capabilities.

The finishers must be connected to the right end of the digital press, replacing the Offset Catch Tray. The finishers also have an Offset mode that provides separation between the stacked sets sent to the Stack Tray. The finishers can also send output (not stapled) to the Top Tray.

Identifying the components

Control
Panel   Top Tray

Offset Stacker/
Stapler Tray
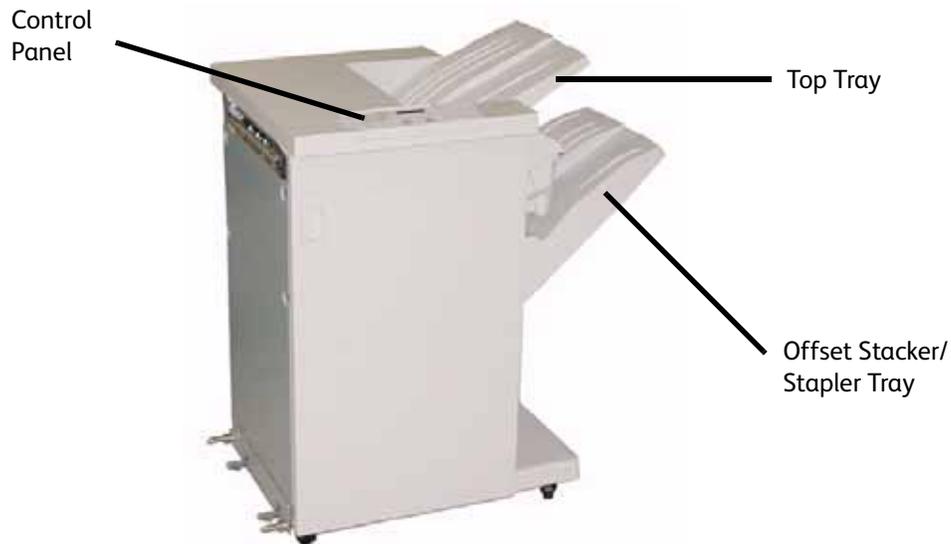
HCSS80/CSS Control Panel
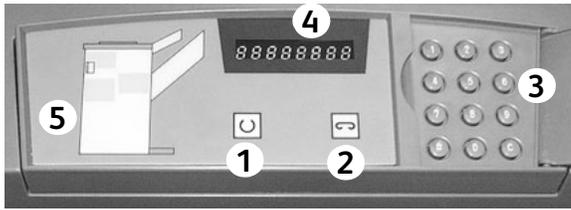
1 Ready Indicator
The Ready Indicator blinks when the digital press is being initialized. The Ready Indicator is constant when in use or in standby.

2 Staple Indicator
The Staple Indicator blinks when the staple level in the stapler is low. The Staple Indicator is constant when the stapler is empty.

3 Keypad
The keypad, including the C button, is used only by the Xerox service representative.

4 Message Display
Shows the fault codes.

5 Jam Indicator
Area illuminates to indicate the location of a jam in the HCSS80.

HCSS80/CSS Paper Path

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

The Stapler Cartridge is a customer replaceable item.
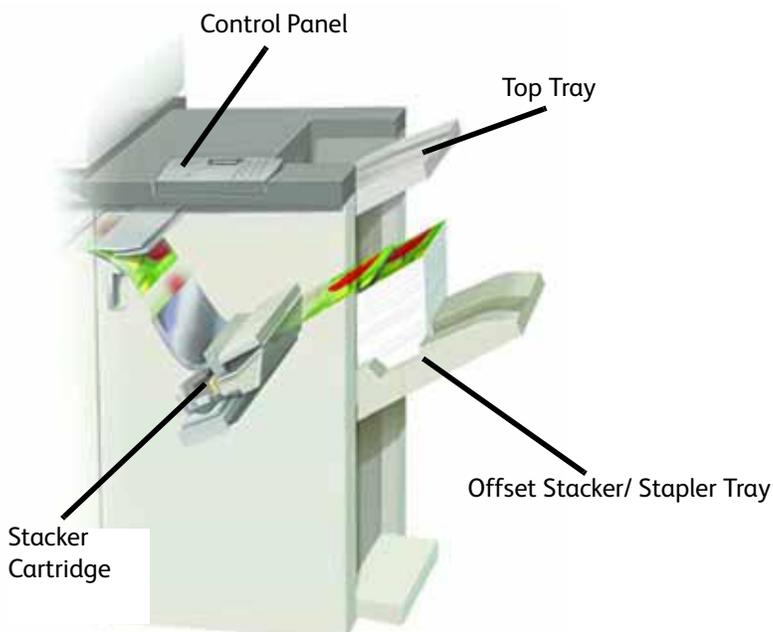
HCS80/CSS Operation

Some important tips to remember:

- The finishers cannot staple jobs with mixed sizes of paper.
- The stacking may be skewed on the output from <u>mixed-size</u> paper jobs.
- Only remove paper jams at the area indicated on the finisher Control Panel. Do not remove paper from any other areas of the paper path.

HCS80/CSS Stapling Hints

There are three stapling options:

- **Single Staple Position 1:** The finishers place a staple in the upper left corner of Short Edge Feed (SEF) or Long Edge Feed (LEF) sets.
- **Single Staple Position 2:** The finishers place a staple in the bottom left corner of <u>SEF sets only</u>.
- **Dual Staple:** The finishers place two staples closer to the top/bottom center of the sheets than a single staple.

Unloading the HCS80/CSS Finishers

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

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

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

Loading Staples in the HCS80/CSS

1. Open the front door.
2. Push the yellow lever down with your left hand.
3. Grasp the grey handle on the cartridge unit and pull it towards you until it stops. Release the yellow level and the unit will lock into place.
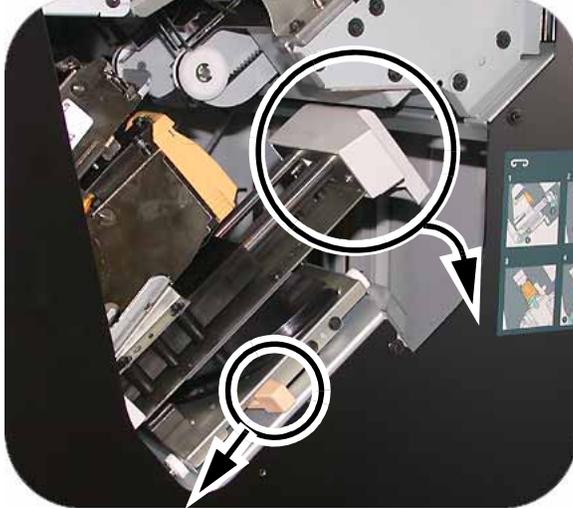
4. Grasp the yellow staple cartridge and pull it towards you.

   The entire unit will move forward, then the staple cartridge only will pull free of the unit.
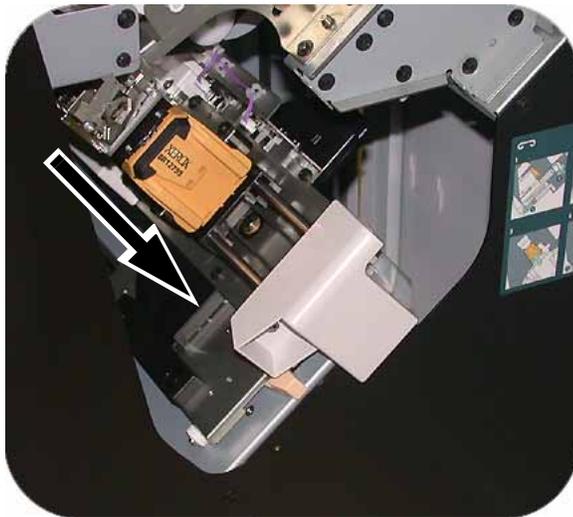
5.   Insert a new cartridge into the unit until you hear it click into place.

6.   Push the Cartridge in to the Stapler Unit.
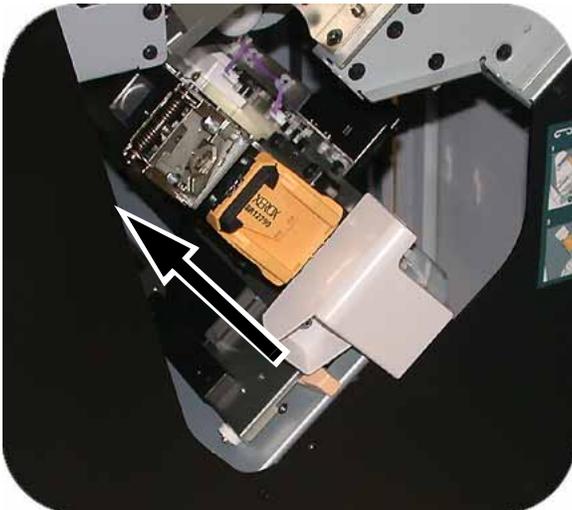
7.   Push the yellow lever down and the cartridge unit automatically swings back into place.
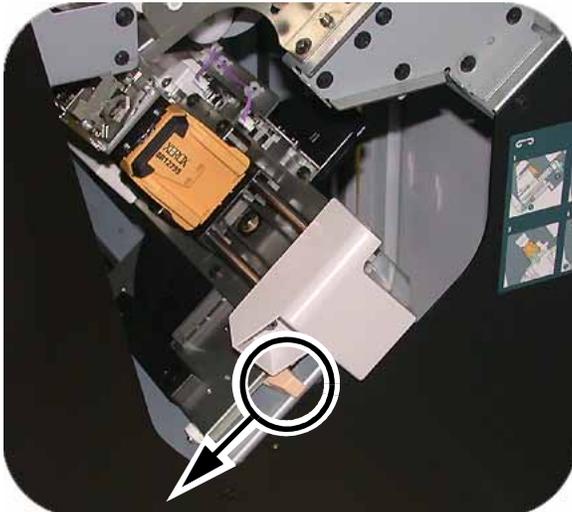
Undocking the Stacker Stapler

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

Maintenance

9

Cleaning the Digital Press

Note

Refer to the video located on the Customer Documentation CD as needed.

> ⚠ **CAUTION**
> - Do NOT use any other cleaners or solvents on the digital press as they may interact with the paint on the covers, eventually causing the paint to peel.
> - DO NOT pour or spray liquid directly into any of the paper trays. Always apply the liquid to the cloth first.

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

Cleaning the UI Touch Screen

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

> ⚠ **CAUTION**
> To avoid damage, do not use any cleaner, water, or commercial cleaner on the Touch Screen.

Cleaning the Corotrons

Refer to the video located on the Customer Documentation CD as needed.

The Corotrons should be cleaned every day and after 5,000 prints.

1. Open the Front Doors and slowly pull out the cleaning wand for each corotron fully and then push the wand back into place.
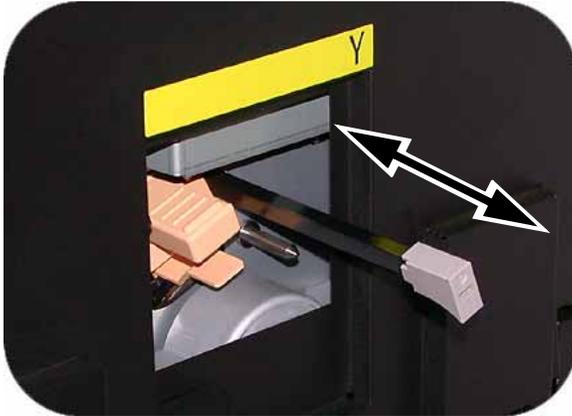
If it is not seated properly, the User Interface will display the information on the screen. Reseat the appropriate corotron.
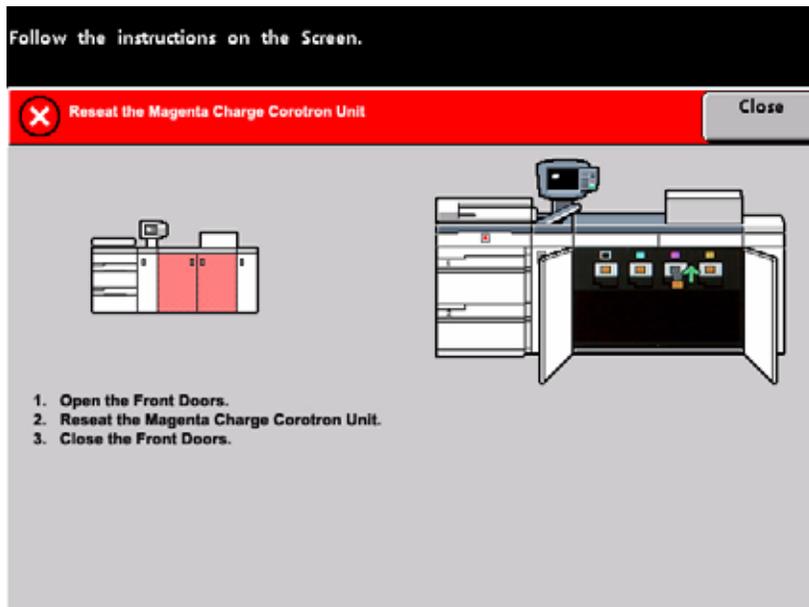
⚠️ **CAUTION**

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

2. After the corotrons are cleaned, follow the prompts on the UI to record the activity.

3. Once all the Corotron Cleaning Wands are properly seated in the corotron assembly, the User Interface displays the Interlock Open screen. Close the Front Doors.

4. After all the corotrons are cleaned and the front doors are closed, the Maintenance Charge Corotron screen is displayed. Select one or more corotrons by touching the corresponding button (Cyan, Magenta, Yellow, Black).
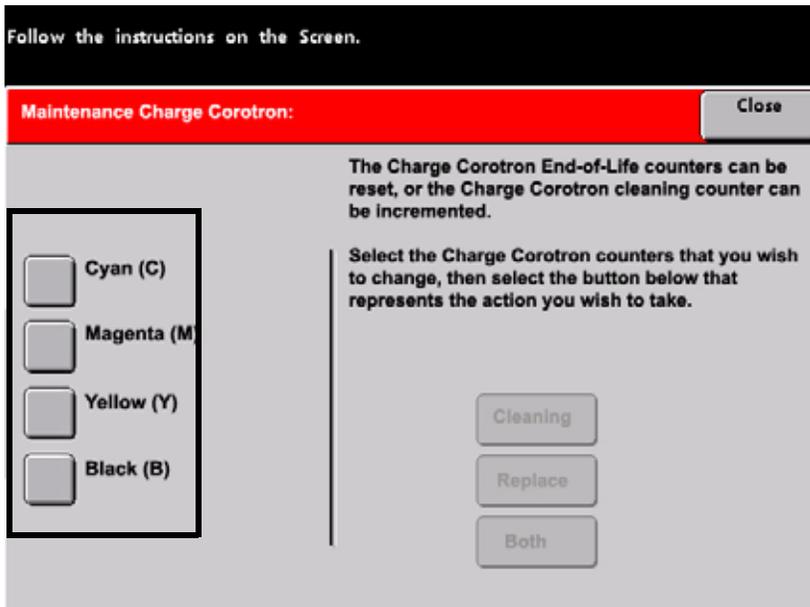
5. Select the Cleaning button.
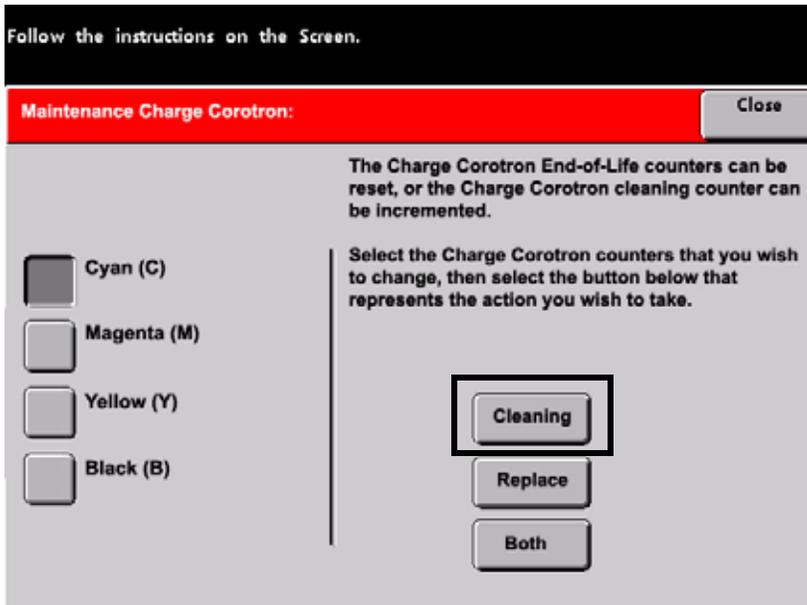
6. Select **Yes**.
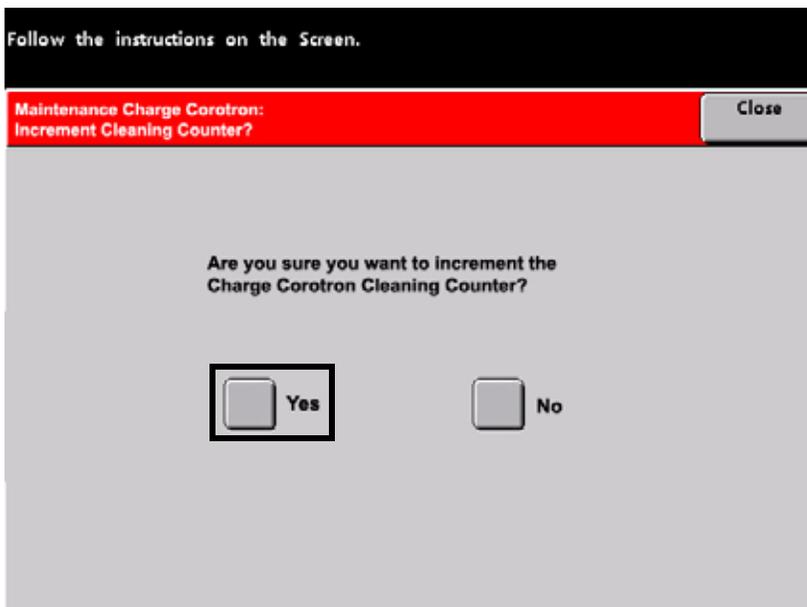
Note
After incrementing the counter for a specific Corotron(s), it is no longer selectable.

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

Cleaning the Paper Transport and Fusing Areas

Note

Refer to the video located on the Customer Documentation CD as needed.

⚠️ **WARNING**

If the digital press is switched on and the fuser is hot, switch off the digital press power and allow the Fuser to cool for 15 minutes.

1. Open the Front Doors and pull out the Paper Transport Drawer using handle 4.
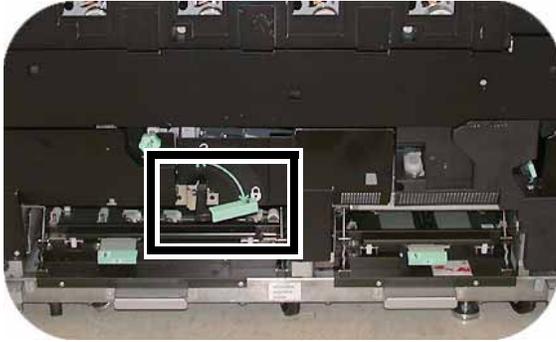
2. Clean the chute area with a lint-free cloth that was supplied with the digital press (Xerox Part Number: 19K03610).
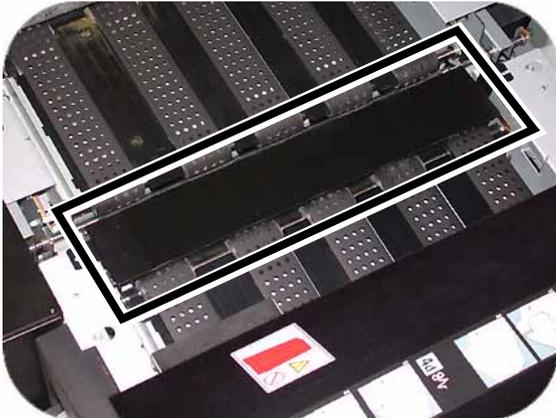
3. Clean the Horizontal Transport Belts and the surrounding area with a lint-free cloth that was supplied with the digital press (Xerox Part Number: 19K03610).

Note

Rotate the belts from left to right as you continue to wipe them. Use the cloth to rotate them as using your hands could leave grease or dirt and create paper jams.

4. Clean the sensors with a lint-free cloth that was supplied with the digital press (Xerox Part Number: 19K03610).
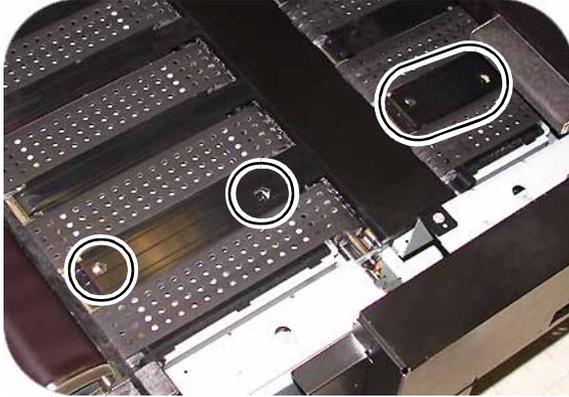
5. Close the Paper Transport Drawer.

Replacing Consumable Supplies

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

Note

Refer to the video located on the Customer Documentation CD as needed.

Replacing A Dry Ink/Toner Cartridge

Replace the Dry Ink Cartridge when the "Replace the Dry Ink Cartridge" message is displayed on the UI.

1. Place a drop cloth on the floor below the Dry Ink compartment and open the Dry Ink compartment door

2. Rotate the Dry Ink Cartridge to the "Unlock" label.

3. Remove and dispose of the empty cartridge.

Note

Before installing a new cartridge, vigorously shake the cartridge to ensure that the material is not compacted.

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

5. Rotate the cartridge to the "Lock" label.

Adding Fuser Oil

Add Fuser Oil when the "Add Fuser Oil" message is displayed on the UI.

Note

Refer to the video located on the Customer Documentation CD as needed.

1. Open the Right Front Door and place a drop cloth on the floor.
2. Open the Reservoir Cap.
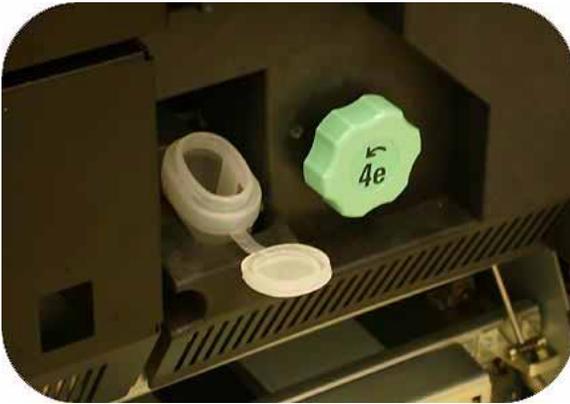
3. Position the Filler Spout Cap on the oil bottle to add oil the reservoir.

4. Do not fill above the MAX line.

5. Replace the reservoir cap and close the Right Front Door.

Changing the Waste Dry Ink Bottle

Change the Waste Bottle when the "Change Waste Bottle" message is displayed on the UI.

Refer to the video located on the Customer Documentation CD as needed.

The waste bottle is located inside a lower rear compartment of the Exit Module.

1. Open the Waste Bottle Door and pull the out the bottle.

2. Install the cap (found on the side of the bottle) and dispose of the bottle in accordance to local regulations.

3. Install the new bottle and close the door.

Replacing a Corotron

When to replace a charge corotron

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

Which charge corotron to replace

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

Banding samples

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

Black Banding

Cyan Banding

Magenta Banding

Yellow Banding
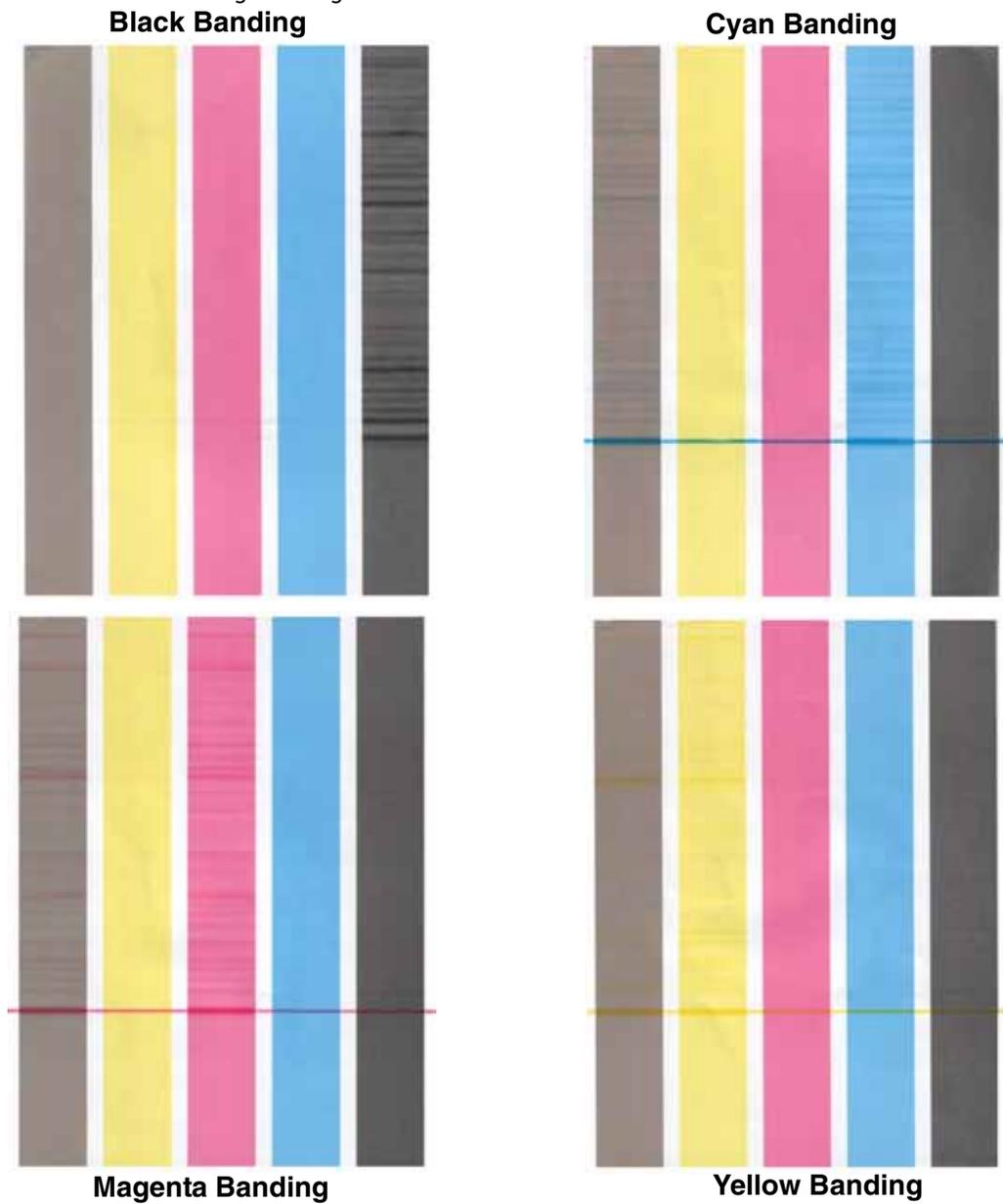
Corotron Replacement

Note

Refer to the video located on the Customer Documentation CD as needed.

1. Open the front doors.
2. Squeeze the corotron handle and slowly pull the corotron completely out of the machine.
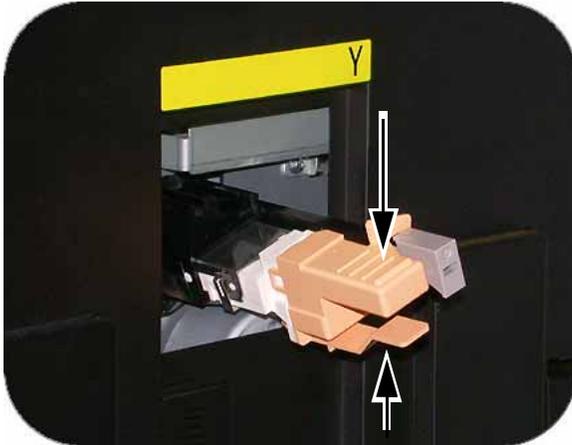
3. Dispose of the corotron according to local regulations.
4. Insert the plastic guide sleeve on the new corotron onto the guide pins on the frame.
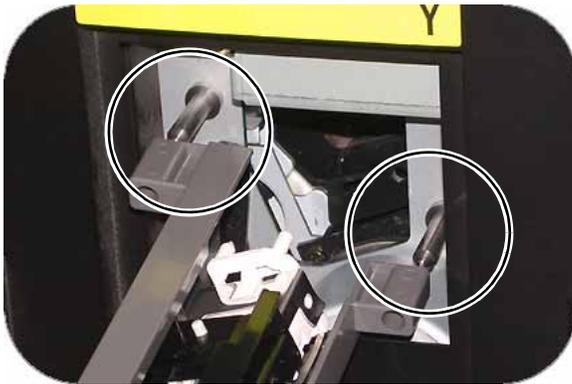
5. Push the corotron into the machine until the handle clicks into place. Remove the plastic sleeve and close the doors.

Note

DO NOT reset the counter on the UI.

Replacing the Fuser Web

Note

Refer to the video located on the Customer Documentation CD as needed.

There are two messages for the Fuser Web:

- Web is near empty (can continue to use machine)
- Web is empty (must replace).

⚠ **WARNING**

The Fuser area may be Hot; be extremely careful when replacing the web.

1. Open the front doors and pull out the Paper Transport Drawer using handle 4.
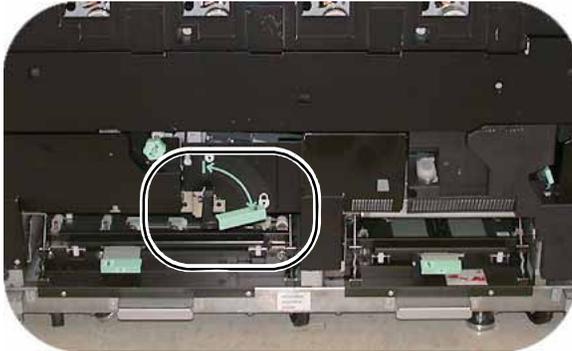
2. Pull open the Fuser Handle 4c and lift handle 4d.
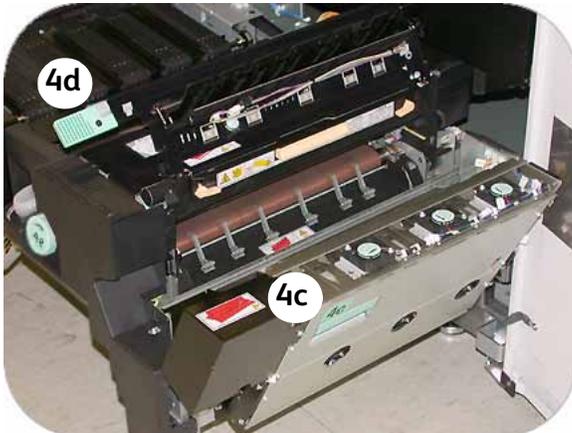
3. Rotate the yellow levers down.
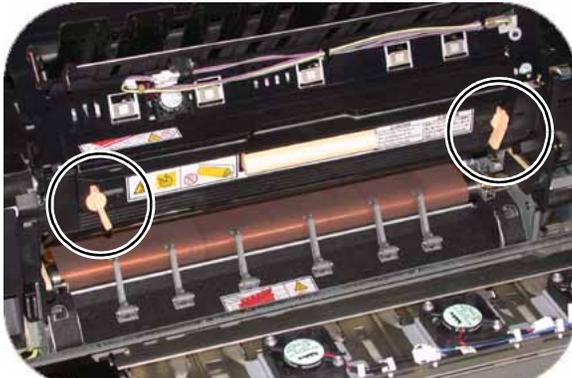
4. Lower and pull out the Fuser Web. Dispose of the web according to local regulations.

5. Align the yellow tabs on the sides of the Fuser Web with the yellow marker on each rail and slide the web all the way into the fuser.
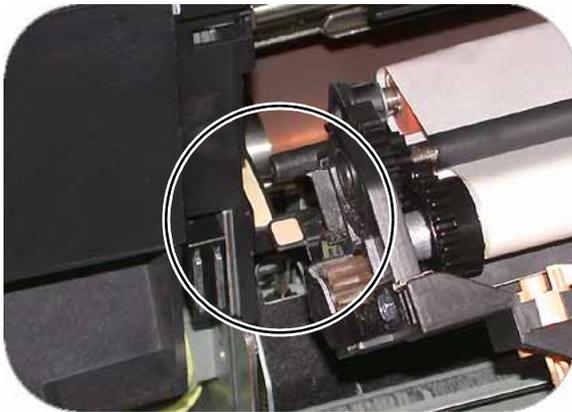
6. Raise the web up until it clicks into place and rotate the yellow levers up to lock the web.

7. Lower handle 4d and close the Fuser Exit Module (handle 4c).

8. Close the Paper Transport Drawer and close the Front Doors.

Consumable Supplies

The following items are consumables for the DocuColor 7002/8002. It is recommended that you have a supply of these items available to eliminate downtime when they need to be replaced.

Supply Item	Supply Number Eastern Hemisphere	Supply Number Western Hemisphere	Supply Unit Shipped with digital press/ Reorder Quantity	Approximate Print Yield/ Carton (Full Color Prints*)
Dry Ink/Toner (Black)	6R1435	6R1431	1	30K
Dry Ink/Toner (Cyan)	6R1436	6R1432	1	50K
Dry Ink/Toner (Magenta)	6R1437	6R1433	1	50K
Dry Ink/Toner (Yellow)	6R1438	6R1434	1	50K
Developer (Black)	5R737	5R737	1	100K
Developer (Cyan)	5R738	5R738	1	100K
Developer (Magenta)	5R739	5R739	1	100K
Developer (Yellow)	5R740	5R740	1	100K
Fuser Oil	8R13031	8R13031	1	200K
*Waste Dry Ink/Toner Container	8R12662	8R12662	1	50k
*Charge Corotron Unit	13R596	13R596		
*Fuser Web Assembly	8R12966	8R12966		
Paper	Colotech+	Xerox Digital Color Xpressions+	2 reams	

10

Basic Troubleshooting

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

Digital Press Troubleshooting

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

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

Note

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

Problem	Suggested Solutions
The digital press does not power on.	• Ensure the power cord is plugged into the receptacle correctly. • Ensure the power switch inside the front left door is set to the ON position. • Check the Ground Fault Interrupter (GFI) circuit breakers, located in the bottom left side of the Electrical module next to the power cord. • If the power in your location is working properly, you have tried the suggested solutions, and the digital press does not power on, call for assistance.
Prints are not on desired paper size.	• Ensure that the proper paper is loaded in the paper trays. • Select the paper size, tray and weight through the digital press options on your PC. • Ensure that the correct weight is selected on the paper tray. • Ensure that "Fit to Paper" or an equivalent selection is not selected in your print driver.
Paper is misfed or wrinkles repeatedly. Note Perform one step at a time. If the problem continues, perform the next step in the list.	• If a message appears on the UI, follow the instructions displayed. • Ensure the proper paper (refer to the Paper chapter of this manual and *The Recommended Materials List)* is loaded correctly and not filled above the MAX line. • Turn the paper stack around and/or over in the selected paper tray. • Remove a few sheets from the top and the bottom of the stack in the paper tray. • Fan all four edges of the paper in the selected paper tray. • Remove any partially fed paper from the trays. • Ensure the paper you are using had been stored properly. • Replace the paper in the selected paper tray with paper from a new package.
The Touch Screen does not respond to a touch command.	• Press **Clear All** on the Control Panel. • Touch a selectable button on the UI. A slight pressure is required to cause the digital press to react. • If the problem persists, open the Front Door of the digital press. Close the Front Door and make a selection on the UI. If the UI does not respond to any touch commands, switch off the power. Wait 15 seconds. Then switch on the power.
Transparencies are too oily.	• Make 5 blank sheet copies with the Full Color option on paper stock to purge excess oil from system. Reload the transparencies and continue the copying job. • Refer to the *Recommended Materials List* and the *Color Materials Usage Guide* for more information about transparencies.

Problem	Suggested Solutions
Multiple sheets feed from the paper trays.	• Do not fill the paper trays above the MAX fill line indicator. • Fan the paper, transparencies or drilled stock 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.
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.
Output jams when exiting the digital press 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/m^2) 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	• Ensure that the correct paper weight and paper type are selected. • You can sometimes minimize curl problems by flipping the paper over in the tray and making the copies again. If excessive curl is still present, use a heavier paper. • Empty the output device when output approaches this limit to ensure continuous production.
It is difficult to perform secondary operations on the output prints, such as writing on them or using adhesives.	This problem is caused by the oil used in the fusing process. The problem can be reduced or eliminated by setting the prints aside for one or two hours before performing a secondary operation on them. Rubbing the print surface with a soft, clean cloth or eraser may also help.
Low gloss bands appearing on printed output.	Running all weights at rated speed may result in a **Cross Process Low Gloss Band**. On the heavy-weight stocks, this low 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.

Printer Fault Codes

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

Prior to your call, record the following information:

1. A complete description of the problem.
2. Fault Code(s) located at the top of the Control Panel.

   The Machine Serial Number. Press the **Machine Status** button and then touch the **Machine Details** tab to read the serial number. If the serial number is not displayed, open the Right/Left Front Doors of the digital press. The serial number is also on a white label on the bottom front frame.
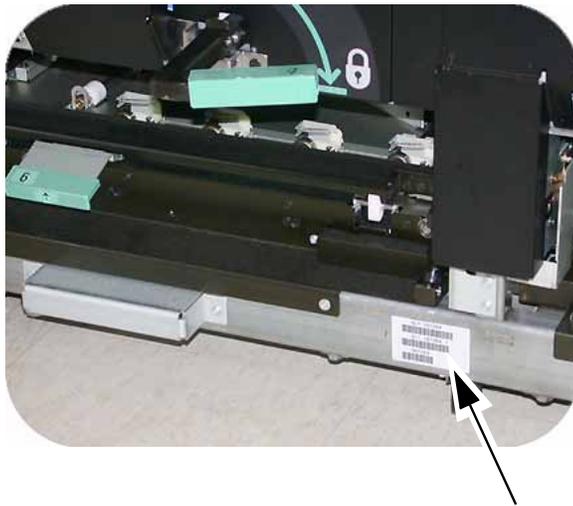
3. If copy quality is the problem, have a sample available to help you describe the defect.
4. If possible, use a phone near the press when calling for assistance.

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

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

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

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

www.xerox.com/eSupportCentre

HCS80 Troubleshooting

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

Fault Code	Cause	Solution
212 100 212 110 212 120 212 130 212 140 212 900	PaperJam	• A jam occurred during feeding. • Remove sheets from jam clearance areas. • Open and close the top cover and front door. A purge sheet may eject to the top tray. • If the jam occurs in the second HCS80, be sure to check the Bypass area in the first HCS80.
212 251 212 252 212 253 212 254	Stacker Problem	Power off, then power on.
212 302	Top Cover open	Close the Top Cover.
212 540	Stacker Tray full	Empty the Stacker Tray.
212 541	Stacker Tray position	• Press the Unload button. The Wait light blinks until the Stacker Tray has reached the down position. • When the Stacker Tray has reached the down position, open the front door. • Remove the Stacker Cart. • Remove all stacked paper. • Position the Stacker Cart securely into the HCS80. • Close the front door.
212 542	No Stacker Cart	• Open the front door. • Remove the Stacker Cart from the HCS80. • Position the Stacker Cart securely into the HCS80. • Close the front door
212 544	Door open	Close the door

Loss of Power

Problem	Solution
If power is interrupted to the finisher	• Ensure the power cord is plugged in to the proper wall receptacle • Ensure that the digital press power is "On." • Ensure that the Ground Fault Indicator is in the On position • If the power has not been restored by the above procedure, call for service.

HCSS and CSS Problem Solving

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

Problem	Cause	Solution
Fault Code 112-100 Jam indicated in finisher, but actually is in the Exit Module.	Jammed Paper not visible in finisher, and fault code does not clear after opening and closing HCSS80 door.	• Open the finisher door. • Jammed paper is not visible in the area indicated. Close the finisher door. • The Touch Screen indicates a jam in the Exit Module. Open the Exit Module and clear any visible sheets. • Open and close the finisher door. • Clear any other areas indicated on the Touch Screen.
Fault Code 112-100 Jam indicated in finisher. No visible jams in finisher because sheet is located over the Exit Module sensor.	Paper jammed between Exit Module and finisher sensors	• Open the finisher door. • Jammed paper is not visible in the area indicated. Close the finisher door. • If the fault code remains, open the Exit Module. No jammed sheets are visible. • Undock the finisher. Find the jammed sheet between the Exit Module and the finisher. Refer to the Note below this table for information on how to undock the finisher. • Clear any other areas indicated on the Touch Screen.
Fault Code 112-130 Jam indicated in finisher, but is also in Exit Module.	Paper is jammed over both the Exit Module and finisher sensors.	• Open the finisher door. • Clear any visible jams. • If no jammed paper is visible in the finisher area indicated, open the Exit Module door and clear any jammed paper. Close the Exit Module door. • Open and close the finisher door.

Problem	Cause	Solution
Fault Code 112-130 Jam indicated in finisher.	Paper is jammed between the Exit Module and the finisher sensors.	• Open the finisher door. • If no jammed paper is visible in the area indicated, open the Exit Module door and clear any jammed paper. Close the Exit Module door. • Open and close the finisher door. • If the fault persists, undock the finisher and clear the jammed paper between the Exit Module and the finisher. Refer to the Note below this table for information on how to undock the finisher.
Fault Code 112-110	Paper jammed in the finisher and the Exit Module during a purge of sheets to the Top Tray.	• Clear the jammed paper from the finisher. • Clear the jammed paper from the Exit Module. • Open and close the finisher door. • Resume job.
Fault Code 052-310	Communication problem	• Cancel or save the job. • Power off the digital press. Wait 15 seconds and power on.
Fault Code 052-321	Connection problem	• Cancel or save the job. • Power off the digital press. Wait 15 seconds and power on.
Fault Code 052-320	Unexpected connection	• Cancel or save the job. • Power off the digital press. Wait 15 seconds and power on.
Fault Code 052-312	Communication problem	• Cancel or save the job. • Power off the digital press. Wait 15 seconds and power on.
Ready Indicator does not illuminate	No power	• Check the power cord connected to the power source. • Check that the main switch is on.
Poor Stacking:	Mixed sizes of paper	• Run separate jobs and empty stacker.
	High paper curl	• Adjust digital press decurler. • Flip paper in digital press paper tray(s). • Rotate paper in the digital press paper tray(s).
	Mechanical obstruction	• Check for obstruction in the stacker stapler paper path. • Ensure that all transports and baffles are properly seated.
Paper Jams:	Use Top Tray	• Deselect offset or restart job to the Top Tray.
	High paper curl	• Adjust digital press decurler. • Flip paper in digital press paper tray(s). • Rotate paper in the digital press paper tray(s). • Switch to heavier paper.

11 Specifications

This chapter provides specifications for the printer and optional accessories.

Printer Specifications

Paper specifications

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

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

Refer to the Tabbed Inserts section in this chapter.

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

+ L80 g/m^2 cannot duplex in high humidity. L85 g/m^2 coated media is not allowed.

Tray Capacity

All paper trays have a capacity of 2000 sheets of 24 lb. (90 g/m^2) paper.

Duplexing

The system does not duplex media larger than 12.6 x 18 inch (321.1 x 458.1 mm).

Transparency Guidelines

Use only the transparencies recommended.

Transparencies can be run from all the paper trays.

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

Tabbed Inserts

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

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

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

Drilled Paper

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

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

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

Simplex Print Jobs

Rear of paper tray

Paper tray guides

Right side

Front of paper tray
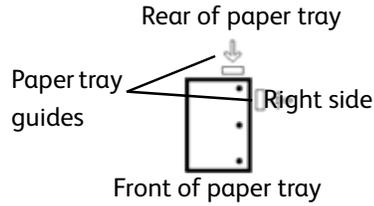
Load the drilled paper into any tray in the Long Edge Feed (LEF) direction. Refer to the illustration on the left.

Duplex Print Jobs

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

LEF direction
Rear of paper tray

Paper tray guides

Right side

Front of paper tray

SEF direction
Rear of paper tray

Paper tray guides

Front of paper tray
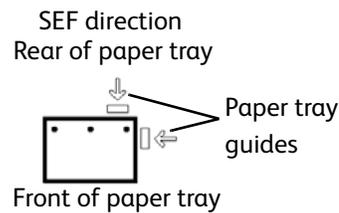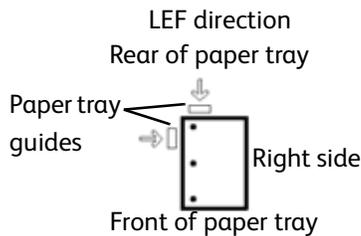
Letterhead

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

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

Nonstandard size paper

Nonstandard size paper is identified as any paper for which there is no paper guide setting within the minimum and maximum sizes for the trays: 7.16 to 12.6 inch LEF or 7.16 to 19.2 inch SEF (182 - 320 mm LEF or 182 x 488 mm SEF)
Non-Standard size paper can be loaded into all the trays. The Non-Standard setting must be selected on the top/front of the paper tray.

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

Paper weight conversion tables

Grammage g/m²	Xerographic Bond, Writing, pounds 17 x 22" - 500 sheets	Offset, Text, Book, pounds 25 x 38"- 500 sheets	Cover, pounds 20 x 26" -500 sheets	Index, pounds 25.5 x 30.5" - 500 sheets	Bristol and Tag, pounds 22.5 x 28.5" - 500 sheets
60	16	41	22	33	27
64	17	43	24	35	29
75	20	50	28	41	34
80	21	54	30	44	36
90	24	60	33	50	41
105	28	70	39	58	48
120	32	80	44	66	55
135	35	90	50	75	62
150	40	100	55	83	67
158	42	107	58	87	72
163	43	110	60	90	74
176	47	119	65	97	80
200	53	135	74	110	91
203	54	137	75	112	93
216	57	146	80	119	98
220	59	149	81	122	100
259	66	169	92	140	114
280	74	189	104	155	128
300	74	189	104	155	128

Yellow shading indicates grades widely used for this classification

Weight conversion ranges

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

High Capacity Stacker 80 Specifications

HCS80 Paper Specifications

Paper	All Paper Trays
Minimum Paper Size	182mm x 182mm (7.16 x 7.16")
Maximum Paper Size	320mm x 488mm (12.6 x 19.2")
Standard Sizes	B5 LEF/SEFA4 LEF/SEF B4 SEFA3 SEF 8 x 10" LEF8.5 x 11" LEF/SEF 8.5 x 13" SEF8.5 x 14" SEF 11 x 17" SEF12 x 18" SEF Kai8 SEFKai16 LEF 12.6 x 17.7" SEF[1]12.6 x 19.2" SEF[1]
Paper Weight Range	60 - 300 g/m²
Transparencies[2]	Yes (A4 LEF or 8.5 x 11" LEF)
Labels[2]	Yes
Transfer Paper[2]	No
Coated Paper[3 4]	Yes
Tabbed Inserts[5]	Yes
Drilled	Yes: 2, 3, 4 hole

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

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

- L80 g/m^2 cannot duplex in high humidity. L85 g/m^2 coated media is not allowed.

- Refer to the Tabbed Inserts section in this chapter.

HCS80 Paper Guidelines

- Stacker Tray will accept 64-280 g/m^2 (either coated or uncoated stock) with the possibility of degraded stock quality and increased jam rate

- Transparencies may be run to either the Top Tray or the Stack Tray. Stack height should be limited to 100 transparencies.

- Coated paper lighter than 100 g/m^2 may not run as reliably as coated paper heavier than 100 g/m^2.

- Non-standard papers longer than 305 mm (12") in the feed direction require 210 mm (8.3") minimum measurement across the feed direction.

- Non-standard papers shorter than 254 mm (10") in the cross-feed direction require 330 mm (13") minimum measurement in the feed direction.

HCS80 Recommended Baseline/Centerline

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

- Uncoated: Xerox Digital Color Xpressions+, 90 g/m^2, 24 lbs. In Europe, Xerox Digital Color Colotech+ 90 g/m^2.

- Coated: Xerox Digital Color Gloss Coated Text (120 g/m^2 /80 lbs.) In Europe, Xerox Digital Color Colotech + Gloss Coated 120 g/m^2.

HCS80 Paper Destination Specifications

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

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

HCSS and CSS Specifications

Electrical / Environmental Requirements

Western Hemisphere:

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

Europe:

200-240 Volt 10 amp 50 Hz service outlet.

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

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

Note

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

Paper Stock Specifications

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

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

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

* Refer to the table on page 10 for information on the stapling capacity for various paper types and weights.

Note:
Transparencies can be fed to both trays.

Paper Specifications for Stapling

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

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

10.5 x 15.3	Kai 8 (267 x 388) Asian market size	SEF	Yes	O	x	x	Yes
10.5 x 7.6	Kai 16 (267 x 194) Asian market size	LEF	Yes	O	x	x	Yes

Note

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

Staple Positions

Size: Inches (mm)	Staple Position 1 (Front Corner)		Staple Position 2 (Rear Corner)		Dual Staple	
	SEF	LEF	SEF	LEF	SEF	LEF
7.2x 10.1 JIS B5 (182x 257)	✔	✔	✗	✗	✗	✗
8x10 (203x 254)	✗	✔	✗	✗	✗	✗
8x5x11 (216x 279) A4 8.5x13 (216x 330) 8.5x14 (216x 356)	✔	✔	✔	✗	✗	✔
10.1x 14.3 JS B4 (257x 364) 10.5x 15.3 Kai 16 (267x 388: Asian market size)	✔	✗	✗	✗	✗	✗
10.5x 7.6 Kai 16 (267x 194: Asian market size)	✗	✔	✗	✗	✗	✗
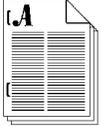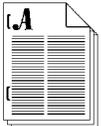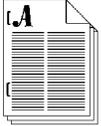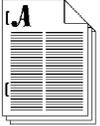
Size: Inches (mm)	Staple Position 1 (Front Corner)		Staple Position 2 (Rear Corner)		Dual Staple	
	SEF	LEF	SEF	LEF	SEF	LEF
11x17 (279x 432) A3		✗	✗	✗		✗
12x18 (305x 457) 12.6x 17.7 (320x 450)	✗	✗	✗	✗	✗	✗

Stapling capacity for different paper types and weights

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

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

* 221 to 300 g/m^2 paper, either coated or uncoated, cannot be stapled. These weights will be stacked in the Top Tray.

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

For information about technical data, refer to the Digital Press Technical Data located in the Appendix.

12

Appendix

This appendix contains supplemental detailed information. Refer to this information as required or when directed from previous chapters in the User Guide.

Machine Details

This screen provides the telephone number to call for support, the machine serial number and access to the meter counts.
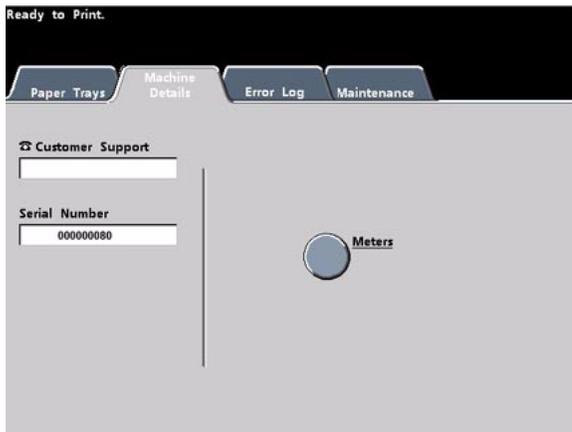
Meters keep track of print counts. To view the print count, touch the Meters button on the Machine Details screen. The Billing Meters screen is displayed.

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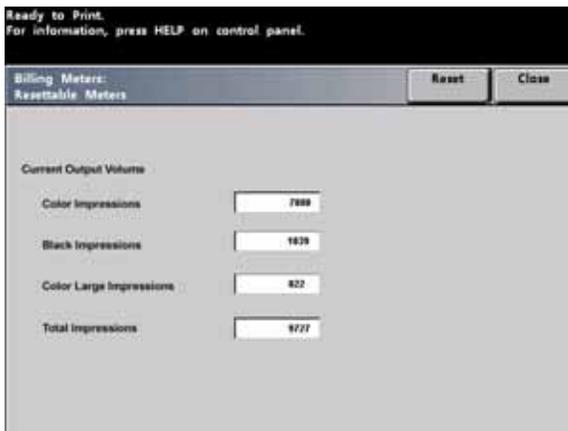
Maintenance tab

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

The Customer Replaceable Unit screen displays a gauge or a check mark indicating the level at which the consumable is.
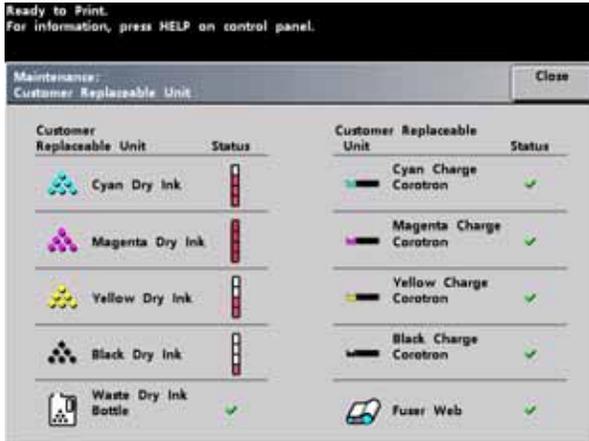
For example, the gauges for the dry ink/toner cartridges indicate the amount of toner in each cartridge:

- The cartridge is full when all four bars are red.

- The cartridge is $^3/_4$ full when three bars are red.

- The cartridge is $^1/_2$ full when two bars are red.

- The cartridge $^1/_4$ full when one bar is red.

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

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

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

- A red circle indicates that the consumable is depleted

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

Your Xerox service representative uses the Service Engineer Replaceable Unit function to check on the status items that are replaced only by the service engineer.
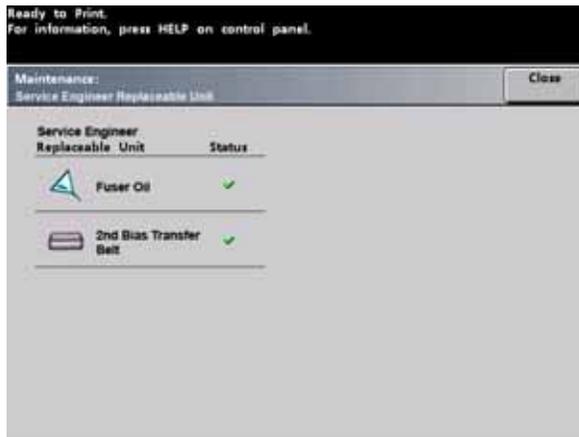
These items include the fuser oil and the second bias transfer belt.

Help

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

Audio Tones

There are three audio tones:

- **Attention:**

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

- **Button Selection**:

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

- **Fault**:

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

The Audio Tones can be deactivated or made louder or softer through the Tools Mode. For more information, refer to the System Administration Guide.

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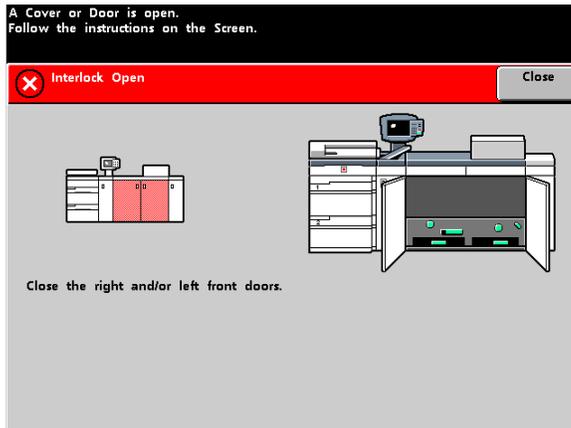
An *Alert* screen has a red bar across the screen when a consumable product, such as Dry Ink/Toner, needs to be replaced. An *Alert* screen also indicates that the digital press is unable to make prints because of a fault condition. Follow the instructions on the UI to resolve the problem and resume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

Digital Press Technical Data

Electrical Power Specifications

- 200-240V - 50/60 Hz
- Single phase - Three wire plus safety ground
- Current service - 30 Amp sole use @ 200V to 240V, 60Hz
- Range (line to neutral) - 200 V minimum to 240 V maximum
- Frequency - 50/60 Hz

Power Consumption

- Standby - 2.8 kW
- Run - 6 kW
- Power Saver - 45W

Warm-up Time

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

First Print Out Time

16 seconds maximum.

Environmental Requirements

The DocuColor 7002/8002 will enter the Power Saver mode after 15 minutes of no activity on the machine.

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

Ambient Temperature and Humidity

- 10 to 32˚C, 15 to 85 % RH
- 50 to 90˚F, 15 to 85 % RH

Note
Above 82˚F (28˚C), reduced humidity is required to maintain the specified performance.

Altitude

- Normal operation: 0 to 2,500 meters (0 to 8,200 feet).
- Operation between 2,000 to 2,500 meters (6,557 to 8,200 feet) may require a field adjustment.

Illumination

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

Noise Levels

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

Ozone Emissions

Not to exceed 0.015 mg/^{m3}

Dust

0.4mg/m^3 or less per Environment Product Safety Manual, PS-22B008

Capabilities

Tray Capacity

All paper trays (First and Second Feeder modules) have a capacity of 2000 sheets each of 24 pound, 90 g/m^2 paper.

Throughput

All paper trays:

Type:

Coated or uncoated paper, transparencies

Sizes:

- Minimum = 182mm x 182mm (7.16 x 7.16")
- Maximum = 320mm W, 488mm L (12.6 x 19.2")

Weights:

$60g/m^2$ to $300g/m^2$

Size/Loading Orientation:

- B5 SEF/LEF
- A4 SEF/LEF
- B4 SEF
- A3 SEF
- 8 x 10" LEF*
- 8.5 x 11" SEF/LEF
- 8.5 x 13" SEF
- 8.5 x 14" SEF
- 11 x 17" SEF
- 8 Kai SEF (267mm x 388mm)
- 16 Kai LEF (267mm x 194mm)
- 12 x 18" SEF
- 12.6 x 17.7 SEF

Print Rates

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

- Selecting **Single Paper Weight** sets the Fuser temperature to 160°C, which optimizes the throughput speed for light and heavy weight papers, according to the weight range that is set in the paper tray, and uses less power.
- Selecting **Mixed Paper Weight** sets the Fuser temperature to 175°C, which optimizes the throughput speed for mixed paper weights from different paper trays, and uses more power.
- Selecting **All Weights Rated Speed** runs/prints all stocks at the rated throughput speed regardless of weight. The digital press produces/prints images with a reduced level of gloss on the output.

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

The following charts illustrate the print speeds for the three modes using 8.5x11" or A4 paper fed LEF:

DocuColor 7002						
DocuColor 7002						
Substrate	**Single Paper Weight**		**Mixed Paper Weight**		**All Weights Rated Speed**	
	1 Sided	2 Sided	1 Sided	2 Sided	1 Sided	2 Sided
60-80 g/m^2	70 ppm	35 ppm	70 ppm	35 ppm	70 ppm	35 ppm
81-105 g/m^2	70 ppm	35 ppm	70 ppm	35 ppm	70 ppm	35 ppm
106-135 g/m^2	70 ppm	35 ppm	60 ppm	30 ppm	70 ppm	35 ppm
136-186 g/m^2	50 ppm	25 ppm	50 ppm	25 ppm	70 ppm	35 ppm
187-220 g/m^2	50 ppm	25 ppm	40 ppm	20 ppm	70 ppm	35 ppm
221-300 g/m^2	35 ppm	17.5 ppm	35 ppm	17.5 ppm	70 ppm	35 ppm
Transparencies	30 ppm	-------	30 ppm	------	30 ppm	------

DocuColor 8002						
DocuColor 8002						
Substrate	**Single Paper Weight**		**Mixed Paper Weight**		**All Weights Rated Speed**	
	1 Sided	2 Sided	1 Sided	2 Sided	1 Sided	2 Sided
60-80 g/m^2	80 ppm	40 ppm	80 ppm	40 ppm	80 ppm	40 ppm
81-105 g/m^2	80 ppm	40 ppm	80 ppm	40 ppm	80 ppm	40 ppm
106-135 g/m^2	80 ppm	40 ppm	60 ppm	30 ppm	80 ppm	40 ppm
136-186 g/m^2	60 ppm	30 ppm	60 ppm	30 ppm	80 ppm	40 ppm
187-220 g/m^2	60 ppm	30 ppm	40 ppm	20 ppm	80 ppm	40 ppm
221-300 g/m^2	40 ppm	20 ppm	40 ppm	20 ppm	80 ppm	40 ppm
Transparencies	30 ppm	-------	30 ppm	------	30 ppm	------

*ppm = prints per minute

Physical Characteristics

Digital Press Size

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

Digital Press Weight

2205 pounds/1000 Kg

Floor Space Requirements

Minimum space requirements for the basic configuration of the digital press, not including a color server: 158.3 inches/4020mm W x 134.8 inches/3425mm D.