CHAPTER 8: PRINT DRUM SECTION

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Mechanism

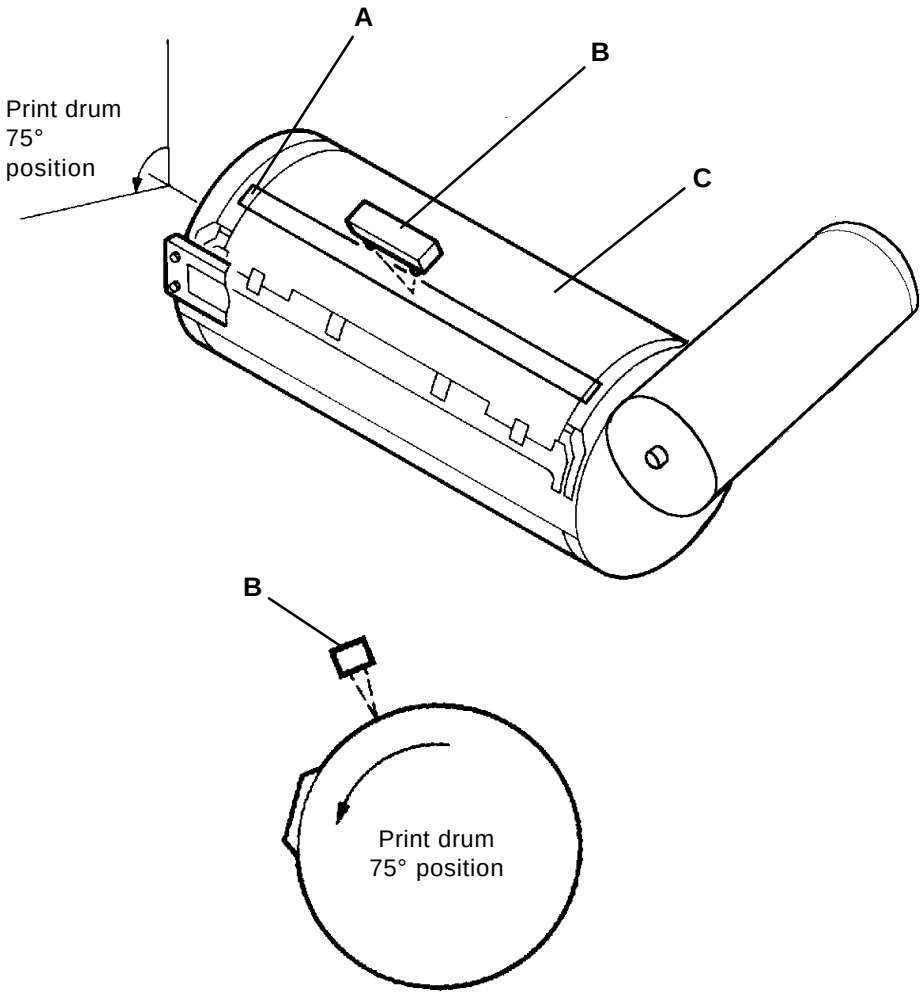
1. Master on Drum (in Printing) Check Mechanism

This mechanism checks whether there is a master on the print drum when printing begins.

The print drum begins to rotate when the START key is pressed, and when the print drum reaches the 75° position, the Master sensor [B] checks whether there is a master [C] on the print drum.

The information checked by the Master sensor [B] is stored until either the print drum is pulled out or the power is switched off. Subsequent printing therefore starts immediately after the START key is pressed.

If light is not reflected back to the Master sensor [B] (implying that the master is absent) when the print drum reaches the 75° position at the start of the printing, it is assumed that there is no master on the print drum.



A: Light absorber strip

B: Master sensor (reflective type)

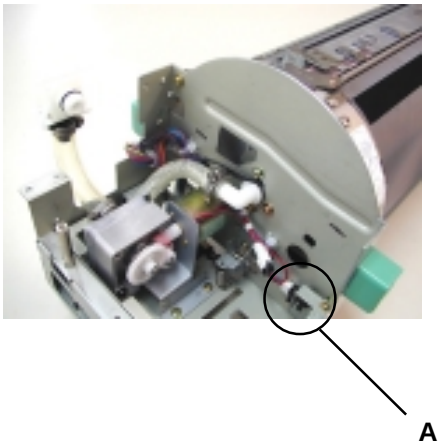
C: Master

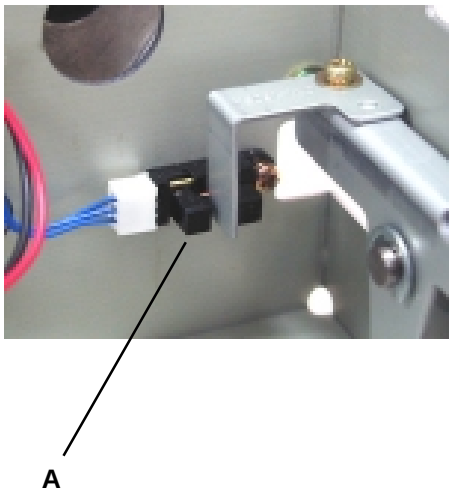
2. Print Drum Set Mechanism

The Print drum set sensor [A] checks whether the print drum is correctly set in the machine.

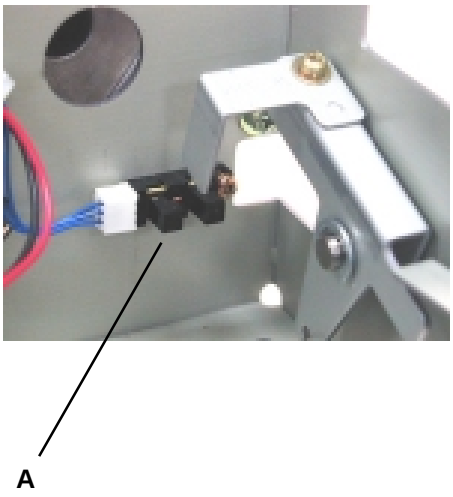
A light beam from the Print drum set sensor [A] is transmitted when the levers are gripped, and blocked when they are released.

The light beam of print drum set sensor [A] is therefore transmitted if the print drum is not correctly set in the machine.





Print drum set sensor light beam is blocked.
Print drum is assumed to be in place.



Print drum set sensor light beam is transmitted.
Print drum is assumed not to be in place.

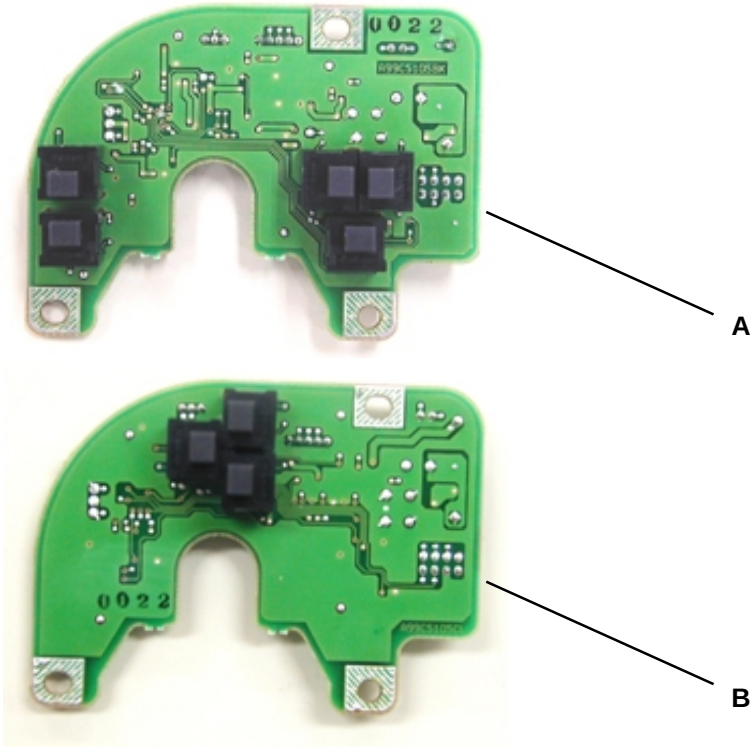
A: Print drum set sensor

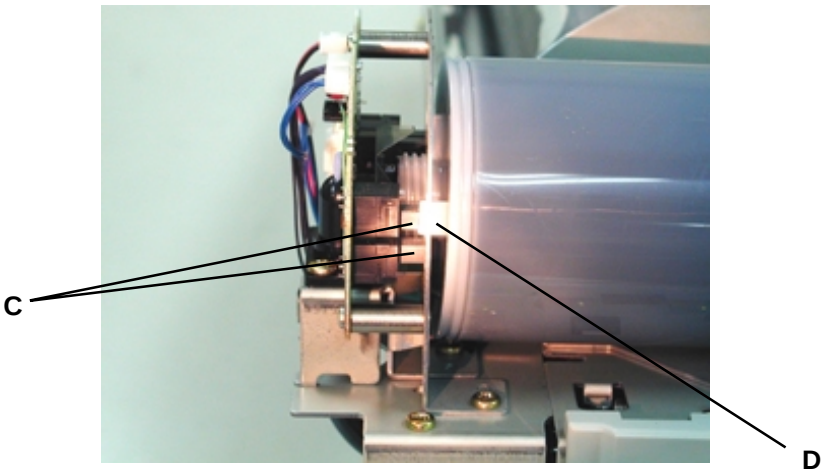
3. Ink Cartridge Set Switch PCB

Different Ink cartridge set switch PCBs are used for the black ink and color ink print drums.

The black ink cartridge set switch PCB [A] has five sensors, while the color ink cartridge set switch PCB [B] has three sensors.

The sensors on the Ink cartridge set switch PCB determines whether correct ink for the print drum is set in place.





A: Ink cartridge set switch PCB (for black ink)

B: Ink cartridge set switch PCB (for color ink)

C: Ink cartridge set switch PCB sensors

D: Protrusion on the front end of the ink cartridge presses sensor actuator on the Print drum set switch PCB.

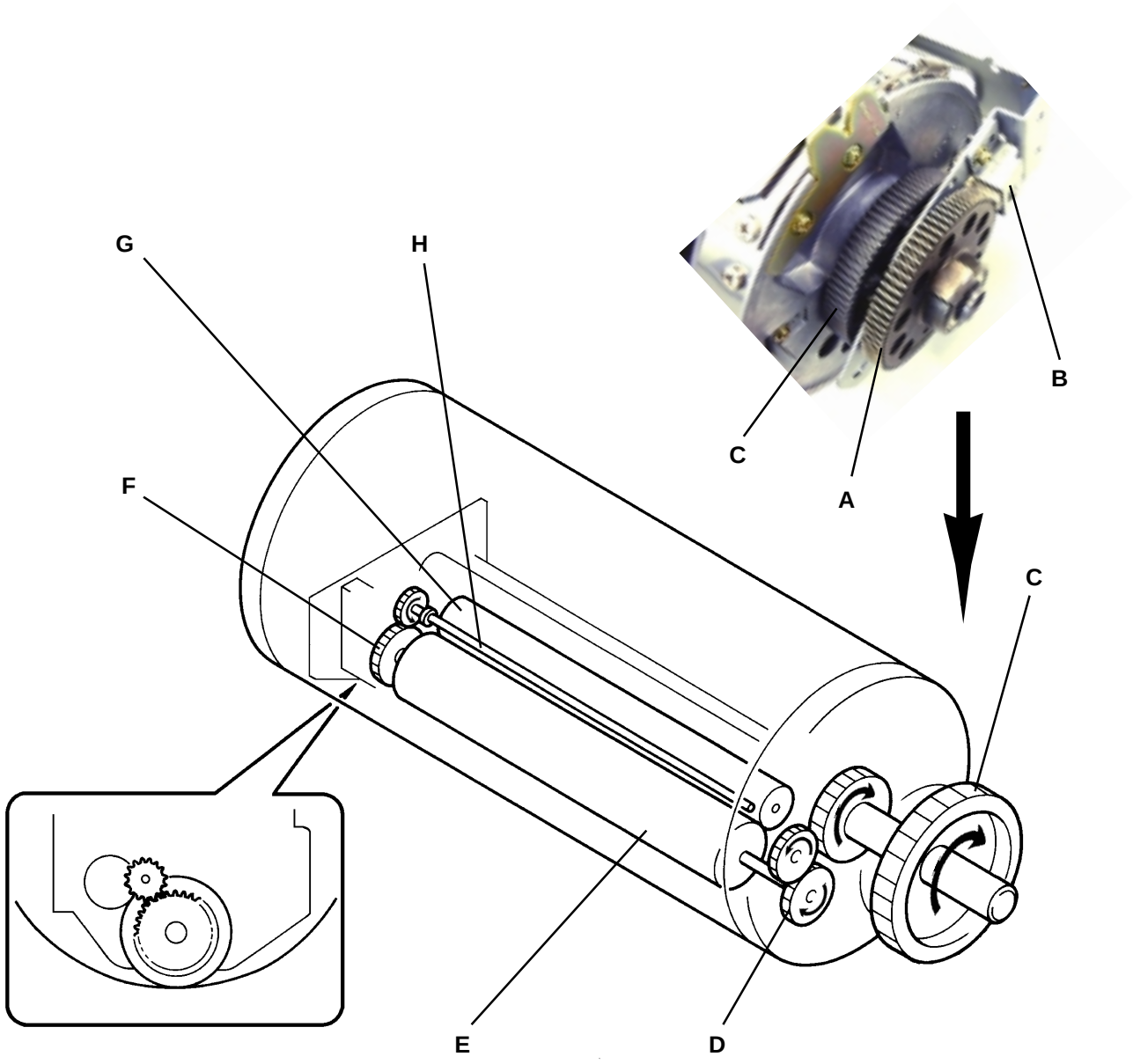
4. Squeegee Roller Rotation Mechanism

The main motor drives the Joint gear [A] via the Junction gear ass'y [B], and this rotates the Print drum main gear [C].

The rotation also drives the Squeegee roller gear (R) [D] via the gears to rotate the Squeegee roller [E].

The Squeegee roller [E] drives the Driven shaft [H] via the Squeegee roller gear (F) [F].

The Squeegee roller gear (R) [D] contains a one-way clutch to prevent the Squeegee roller [E] from rotating when the print drum is manually rotated in the reverse direction.



A: Joint gear
B: Junction gear ass'y
C: Print drum main gear
D: Squeegee roller gear (R)
E: Squeegee roller
F: Squeegee roller gear (F)
G: Doctor roller
H: Driven shaft

5. Inking Mechanism

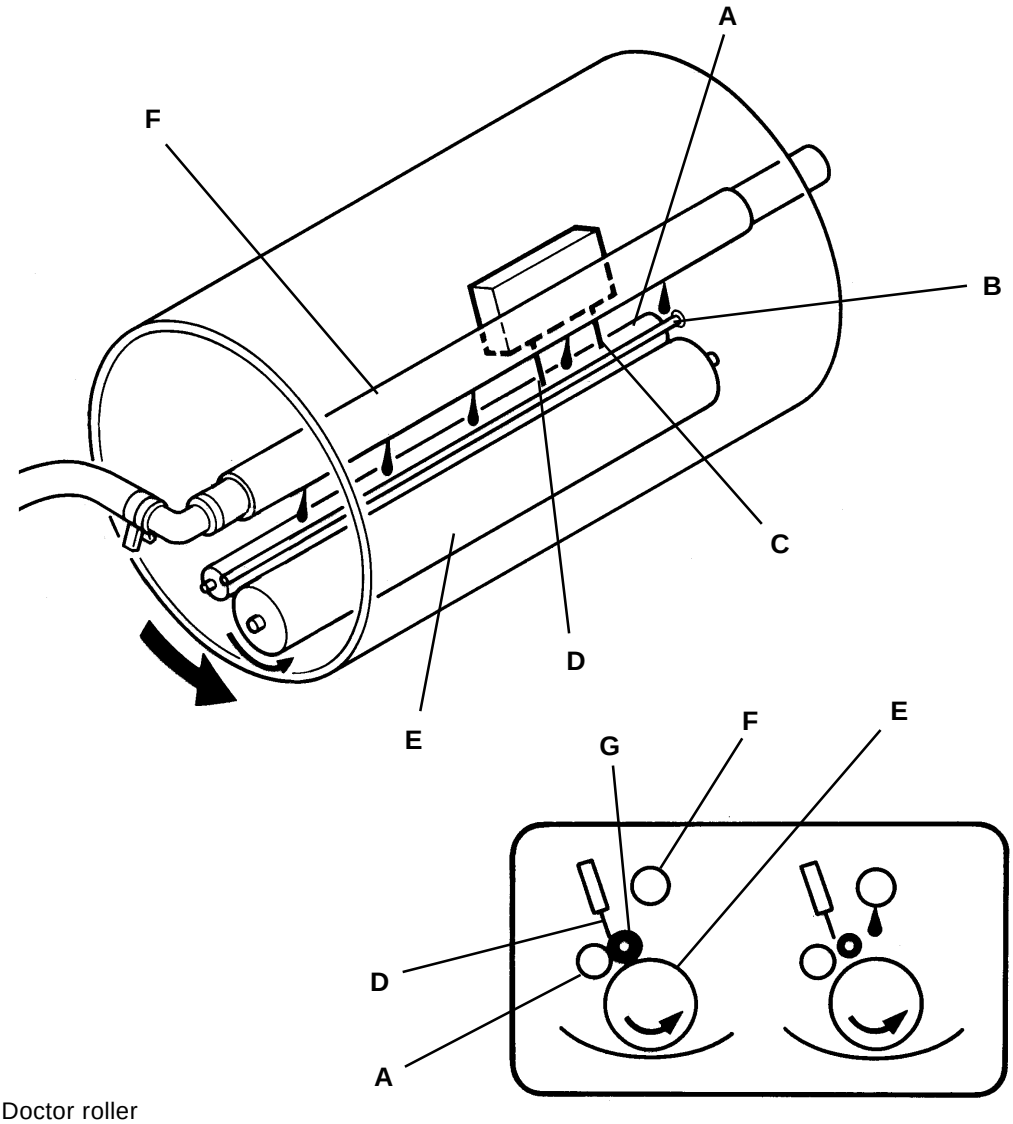
When the main motor is operating and the print drum is rotating, if the ink bead moves away from the Ink sensor [D], the inking motor activates to pump in the ink from the ink cartridge.

The ink pumped is fed via the hose onto the squeegee roller [E] from the holes in the Ink distributor [F]. The inking motor is switched off when the ink reaches the Ink sensor [D].

The ink deposited on the squeegee roller [E] is made into ink bead between the Squeegee roller [E] and Doctor roller [A]. The Driven shaft is rotated to build a smooth ink bead.

The ink is transferred onto the print drum from Squeegee roller [E] via a small gap between the Squeegee roller [E] and Doctor roller [A].

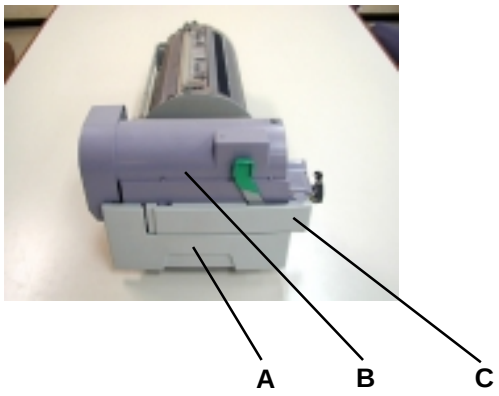
The Overflow sensor [C] checks to prevent ink from overflowing inside the print drum.



A: Doctor roller
B: Driven shaft
C: Overflow sensor
D: Ink sensor
E: Squeegee roller
F: Ink distributor
G: Ink bead

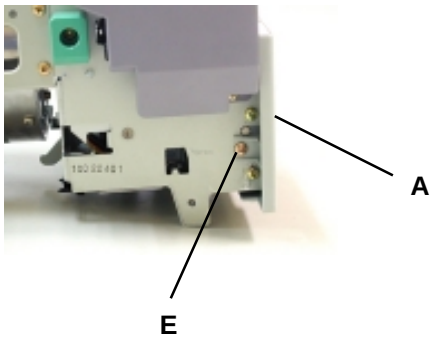
Removal and Assembly

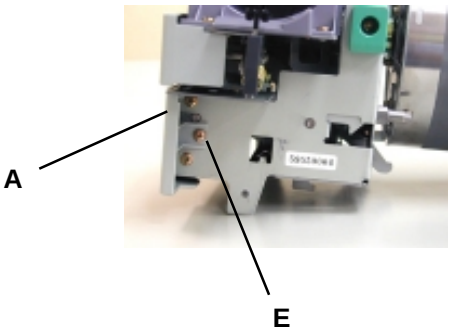
1. Removing the Print Drum Front Cover, Ink Cartridge Guide Ass'y, Drum Front Upper Cover



Removing the Print Drum Front Cover

(1) Remove the left- and right-hand mounting screws (M4 x 6: 1 pc each) [E] on the Print drum front cover [A], and then remove the cover itself.

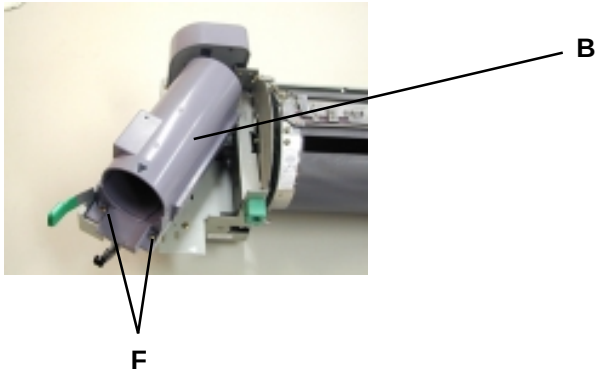




Removing the Ink Cartridge Guide Ass'y

(2) Pull the Ink cartridge release lever [D] and open the swing base.

(3) Remove the mounting screws (M4 x 6: 2 pcs) [E] on the Ink cartridge guide ass'y [B], and then remove it.



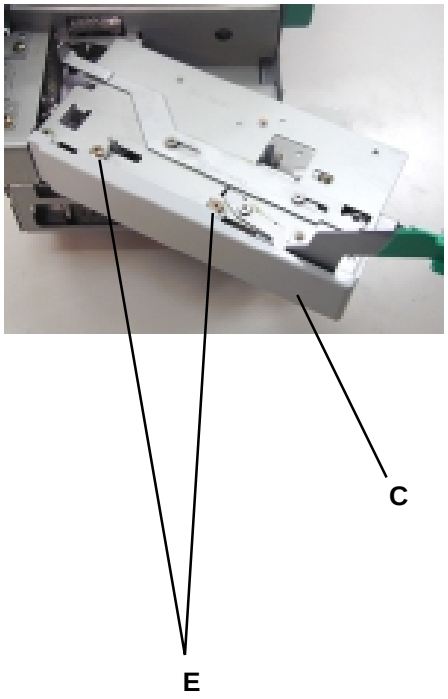
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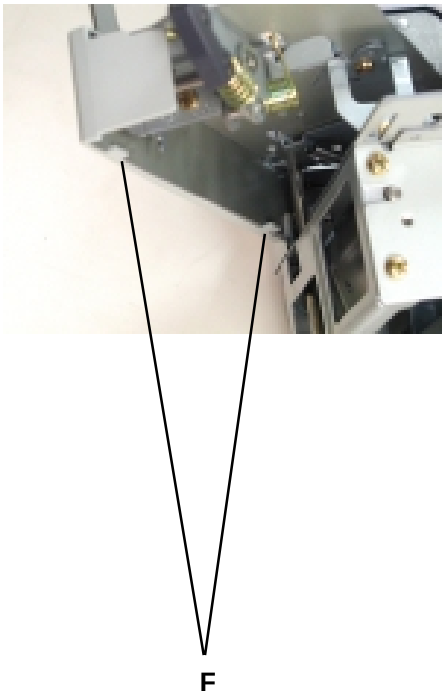
A: Print drum front cover
B: Ink cartridge guide ass'y
C: Drum front upper cover
D: Ink cartridge release lever
E: Mounting screws M4 x 6: 2 pcs
F: Mounting screws M4 x 6: 2 pcs

Removing the Drum Front Upper Cover

(4) Remove the Ink cartridge guide ass'y.

(5) Remove the mounting screws (M4 x 6: 2 pcs) [E] on the Drum front upper cover [C], and then remove without damaging the two hooks [F] at the inside bottom of the cover.



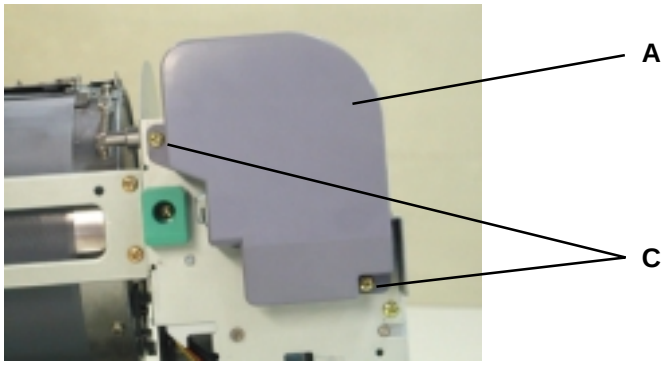


C: Drum Front Upper Cover
E: Mounting screw (M4 x 6: 1 pc)
F: Hooks (inside bottom of the cover)

2. Removing the Ink Cartridge Set Switch Cover and Ink Cartridge Set Switch PCB

Removing the Ink Cartridge Set Switch Cover

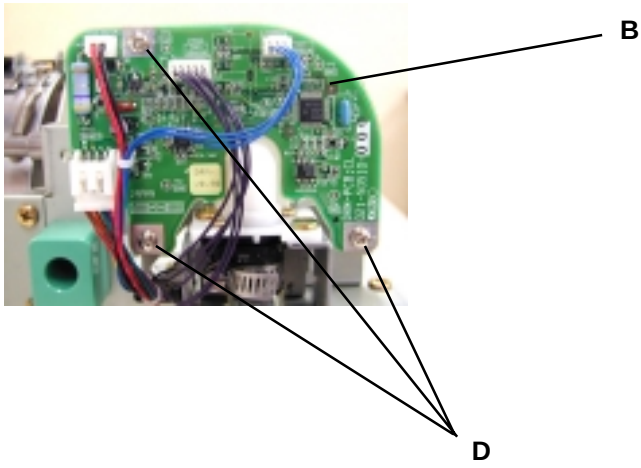
(1) Remove the mounting screws (M4 x 6: 2 pcs) [C] on the Ink cartridge set switch PCB cover [A], and then remove the cover.



Removing the Ink Cartridge Set Switch PCB

(2) Remove the four connectors on the Ink cartridge set switch PCB [B].

(3) Remove the mounting screws (M4 x 6: 3 pcs) [D] on the Ink cartridge set switch PCB [B], and then remove the PCB.



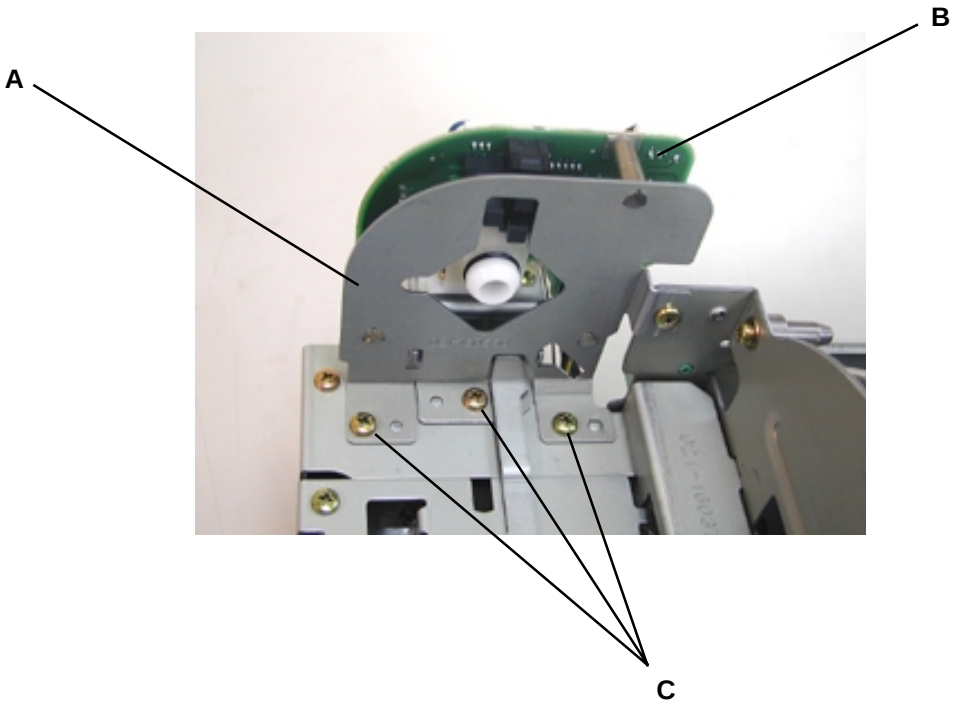
A: Ink cartridge set switch PCB cover
B: Ink cartridge set switch PCB
C: Mounting screws M4 x 6: 2 pcs
D: Mounting screws M4 x 6: 3 pcs

3. Removing the Ink Cartridge Set Switch PCB Mounting Bracket

(1) Pull out the print drum, pull out the ink cartridge, and remove the following components.

- rint drum front cover
- Ink cartridge guide ass'y
- Drum front upper cover
- Ink cartridge set switch PCB cover
- vInk cartridge set switch PCB

(2) Remove the mounting screws (M4 x 6: 3 pcs) [C] on the Ink cartridge set switch PCB mounting bracket [A], and remove the bracket.



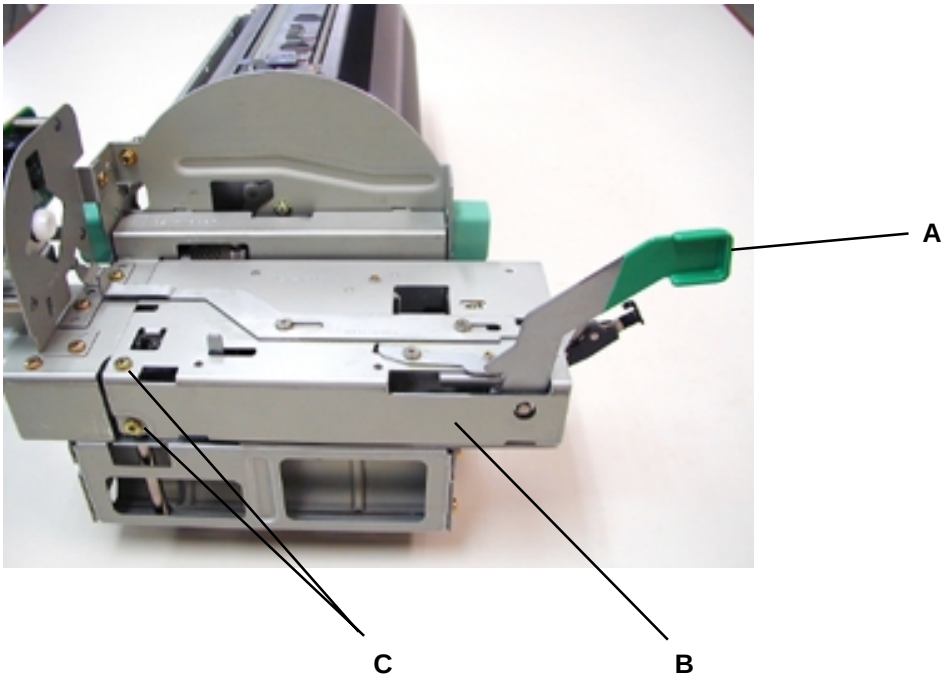
A: Ink cartridge set switch PCB mounting bracket
B: Ink cartridge set switch PCB
C: Mounting screws (M4 x 6: 3 pcs)

4. Removing the Swing Base Ass'y

(1) Pull out the print drum, pull out the ink cartridge, and remove the following components.
- Print drum front cover
- Ink cartridge guide ass'y
- Drum front upper cover

(2) Remove the mounting screws (M4 x 6: 2 pcs) [C] on the Swing base ass'y [B].

(3) Push the Ink cartridge release lever ass'y [A] down, open the Swing base ass'y [B], and remove from the print drum.



A: Ink cylinder release lever ass'y
B: Swing base ass'y
C: Mounting screw (M4 x 6: 2 pcs)

5. Removing the Ink Cartridge Guide Bottom Ass'y

(1) Pull out the print drum, pull out the ink cartridge, and remove the following components.

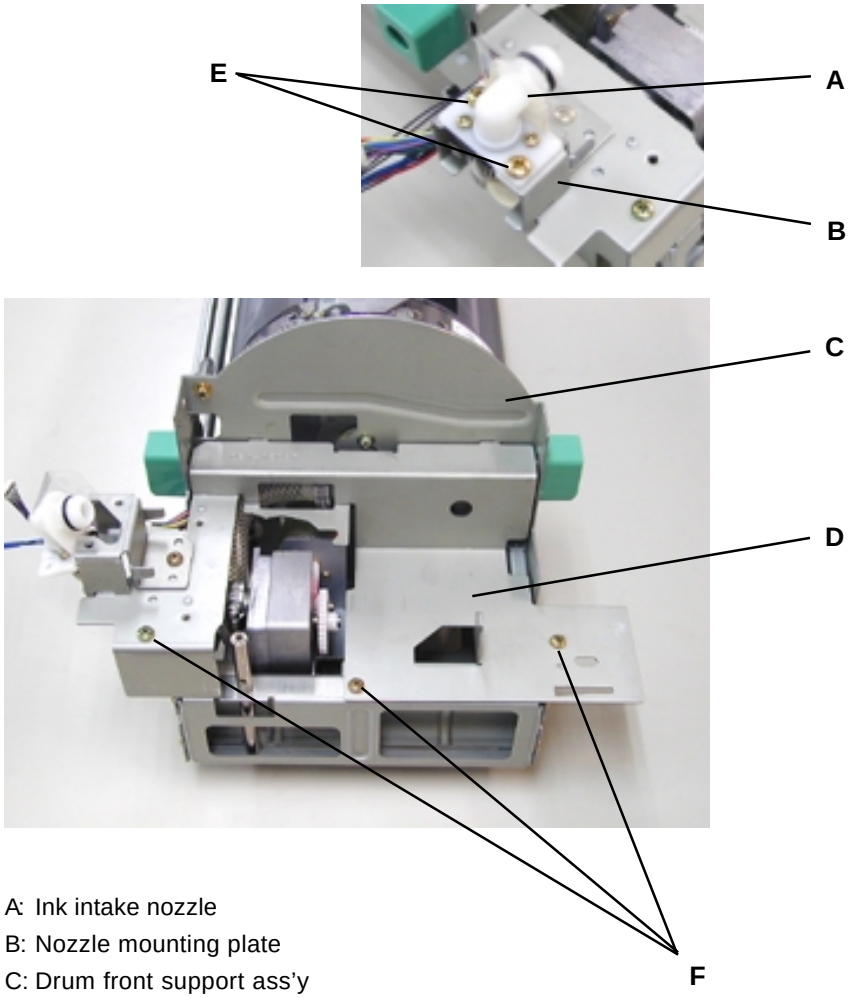
- Print drum front cover
- Ink cartridge guide ass'y
- Drum front upper cover
- Ink cartridge set switch PCB cover
- Ink cartridge set switch PCB mounting bracket
- Swing base ass'y

(2) Remove the mounting screws (M4 x 6: 2 pcs) [E] on the Ink intake nozzle [A], and detach the Ink intake nozzle [A] from the Nozzle bracket [B].

(3) Remove the mounting screws (M4 x 6: 3 pcs) [F] on the Ink cartridge guide bottom ass'y [D], and remove the ink cartridge guide bottom ass'y [D].

[Precautions on Reassembly]

- When mounting the Ink cartridge ass'y [D], engage the horizontal hooks into the Drum front support ass'y [C].



A: Ink intake nozzle
B: Nozzle mounting plate
C: Drum front support ass'y
D: Ink cartridge guide bottom ass'y
E: Mounting screws (M4 x 6: 2 pcs)
F: Mounting screws (M4 x 6: 3 pcs)

6. Removing the Ink Pump Unit and Inking Motor

Removing the Ink Pump Unit

(1) Pull out the print drum, pull out the ink cartridge, and remove the following components.

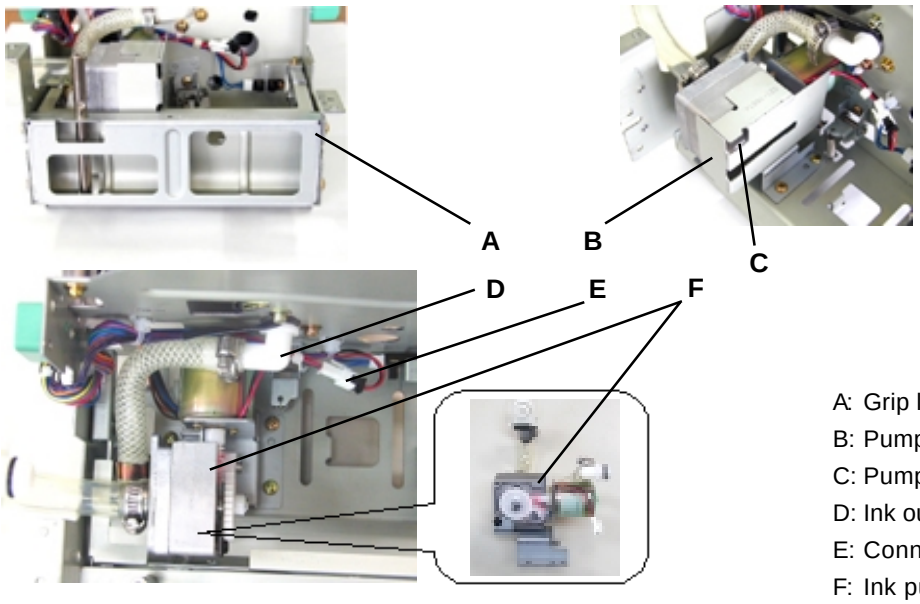
- Print drum front cover
- Ink cartridge guide ass'y
- Drum front upper cover
- Ink cartridge set switch PCB cover
- Ink cartridge set switch PCB mounting bracket
- Swing base ass'y
- Ink cartridge guide bottom ass'y

(2) Remove the mounting screws (M4 x 6: 2 pcs) on the Grip lever [A], and remove the Grip lever [A].

(3) Remove the mounting screw (M4 x 6: 1 pc) [C] on the Pump cover [B], and remove the Pump cover [B].

(4) Pull out the Ink outlet nozzle [D] from the ink distributor.

(5) Unplug the Inking motor connector [E], remove the mounting screws (M4 x 6: 3 pcs) on the Ink pump unit [F], and remove the Ink pump unit [F].

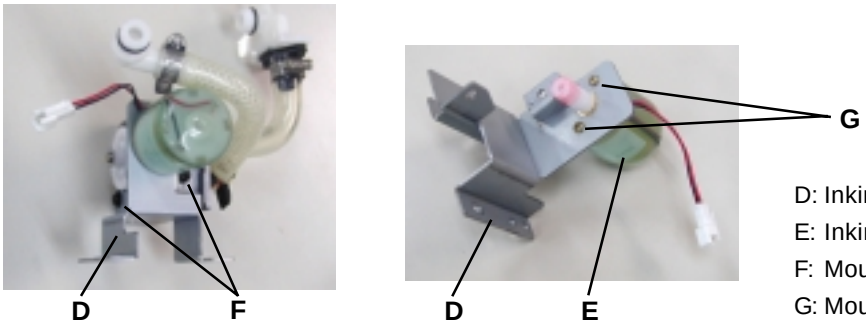


A: Grip lever
B: Pump cover
C: Pump cover mounting screw
D: Ink outlet nozzle
E: Connector
F: Ink pump unit

Removing the Inking Motor

(4) Remove the mounting screws (M4 x 6: 2 pcs) [F] on the Inking motor bracket [D], and then remove the Inking motor [E] together with its mounting bracket from the ink pump unit.

(5) Remove the mounting screws (M3 x 4: 2 pcs) [G] on the Inking motor [E], and detach the Inking motor [E] from the Inking motor bracket [D].



D: Inking motor bracket
E: Inking motor
F: Mounting screws (M4 x 6: 2 pcs)
G: Mounting screws (M3 x 4: 2 pcs)

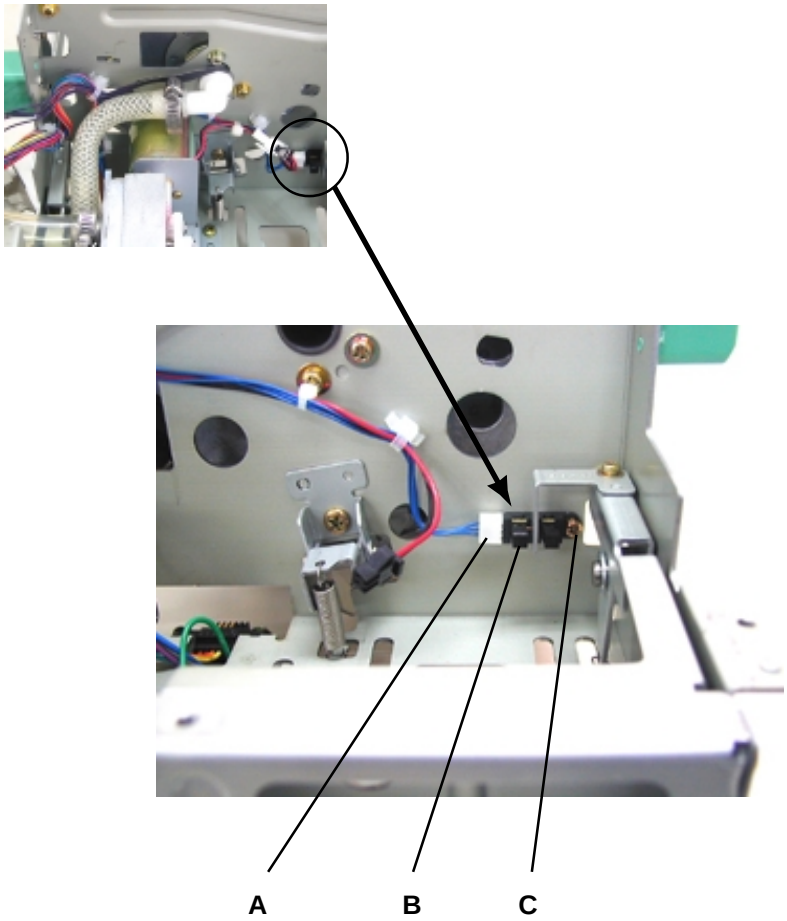
7. Removing the Print Drum Set Sensor

(1) Pull out the print drum, pull out the ink cartridge, and remove the following components.

- Print drum front cover
- Ink cartridge guide ass'y
- Drum front upper cover
- Ink cartridge set switch PCB cover
- Ink cartridge set switch PCB mounting bracket
- Swing base ass'y
- Ink cartridge guide bottom ass'y

(2) Remove the mounting screw (M3 x 6: 1 pc) [C] on the Print drum set sensor [B], and remove the sensor with the connector attached.

(3) Unplug the connector [A] from the Print drum set sensor [B].



A: Connector
B: Print drum set sensor
C: Mounting screw (M3 x 6: 1 pc)

8. Removing the Screen

[Suggestion prior to starting work]

- Attaching the Print drum stand [B] (Part No. 015-26836-002) to the rear of the Print drum side frame ass'y [A] makes the work easier by keeping the print drum level.

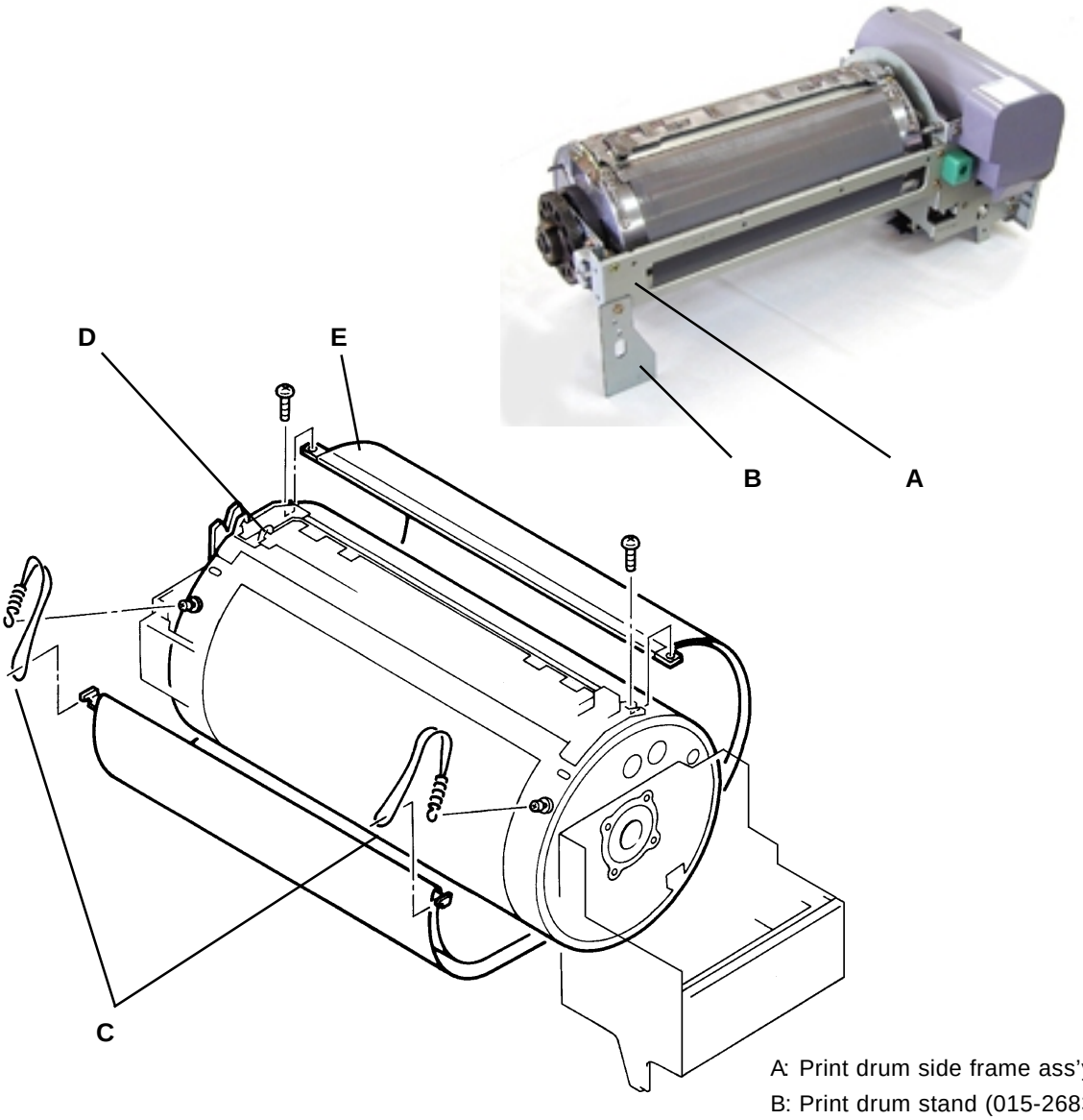
(1) Make a confidential master, and pull out the print drum.

(2) Remove the two Screen springs [C].

(3) Remove the mounting screws (M4 x 8: 2 pcs), which holds both the Clamp plate base [D] and the Screen [E], and then pull the Screen [E] from underneath the Clamp plate base [D] to remove.

[Precautions on Reassembly]

- Take care not to fold the Screen [E].



A: Print drum side frame ass'y
B: Print drum stand (015-26836-002)
C: Screen springs
D: Clamp plate base
E: Screen

9. Removing the Print Drum Body

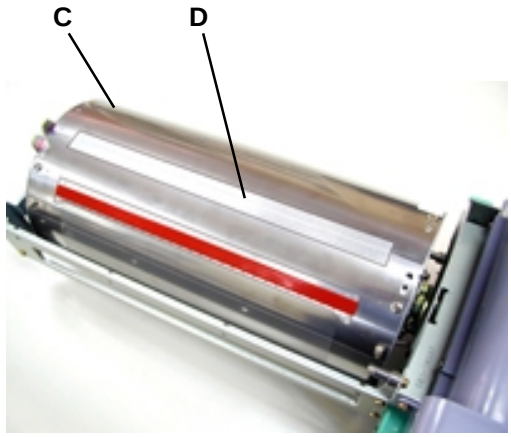
(1) Make a confidential master, pull out the print drum, and remove the following component.
- Screen

(2) Remove the mounting screws (special screws: 2 pcs) [B] and remove the Clamp plate base [A].

(3) Peel off the tape [D] on the print drum body [C] alignment section. (Reuse the tape when reassembling.)

(4) Remove the remaining 10 mounting screws (M4 x 8: 8 pcs and special screws: 2 pcs) on the Print drum body [C], and remove the Print drum body [C].

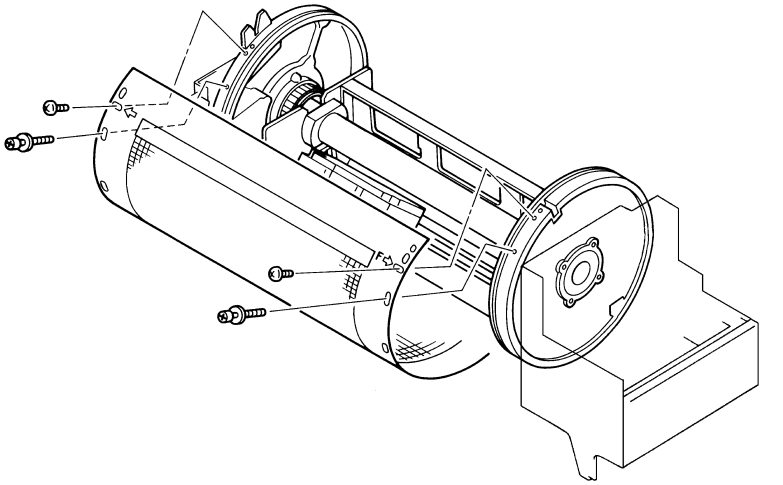
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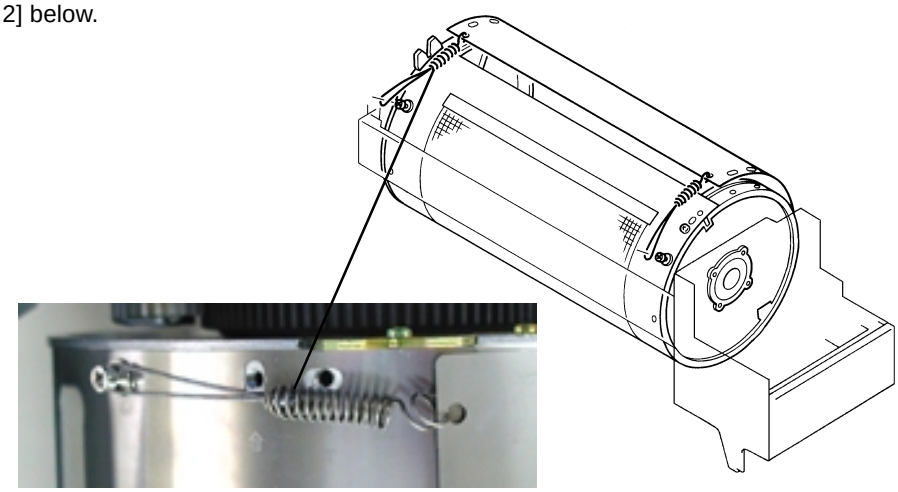
A: Clamp plate base
B: Special screws
C: Print drum body
D: Tape
E: Print drum support (F)
F: Print drum support (R)

[Precautions on Reassembly: 1]

- Arrow marks are engraved on both sides of the Print drum body, and “F” is engraved at the front. Likewise, arrow marks are engraved on both the right and left Print drum supports.
  Align the arrow marks on the Drum body with those on the Print drum supports with the engraved “F” on the Drum body at the front. Then attach the Drum body onto the Print drum supports with mounting scres (M4 x 8: 2 pcs).
  Next attach the Special screws.

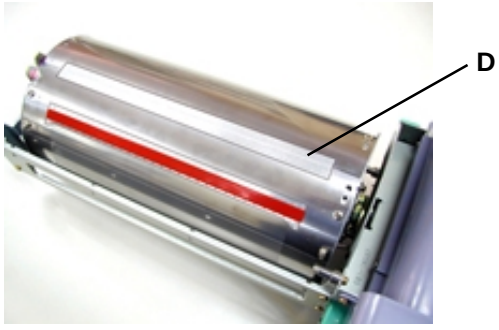


- Hook the Screen springs into the holes at the leading edges of the Print drum body, and hook the loop ends over the Special screws. Then attach the remaining screws while applying tension on the Drum body with the springs. When nearing the last screws, remove the Screen springs and attach the remaining screws and Clamp plate base after checking the [Precautions on Reassembly: 2] below.



[Precautions on Reassembly: 2]

- Before attaching the Clamp plate base to the Print drum body, affix the tape [D] to the joint section of the Print drum body [C]. If the tape originally attached to the print drum cannot be reused, insulation tape may be used. The tape is used to reduce the noise originating from the joint section of the Print drum body during the printing.



D: Tape

10. Removing the Ink Sensor PCB

(1) Pull out the print drum, and remove the following components.
- Screen
- Print drum body

(2) Unplug the connector on the Ink sensor PCB [B].

(3) Remove the mounting screws (M3 x 8: 2 pcs) on the Ink sensor cover [A], and remove the Ink sensor cover [A] with the Ink sensor PCB [B] inside.

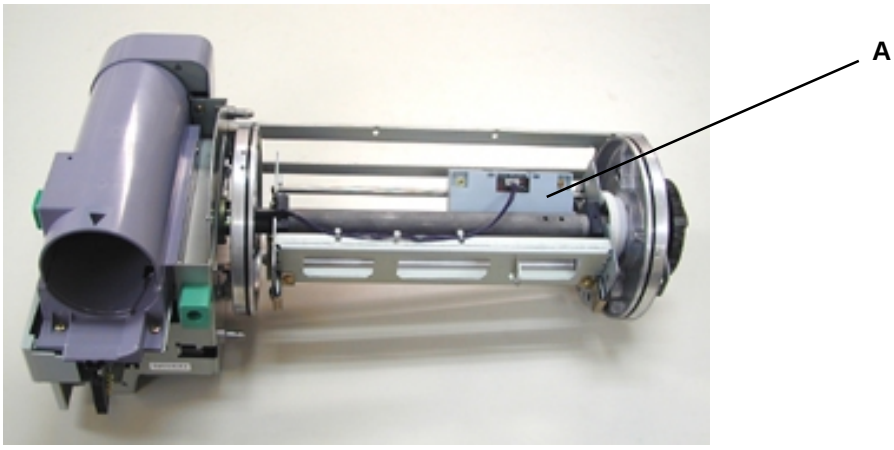
(4) Remove the Ink sensor PCB [B] from the Ink sensor cover [A].

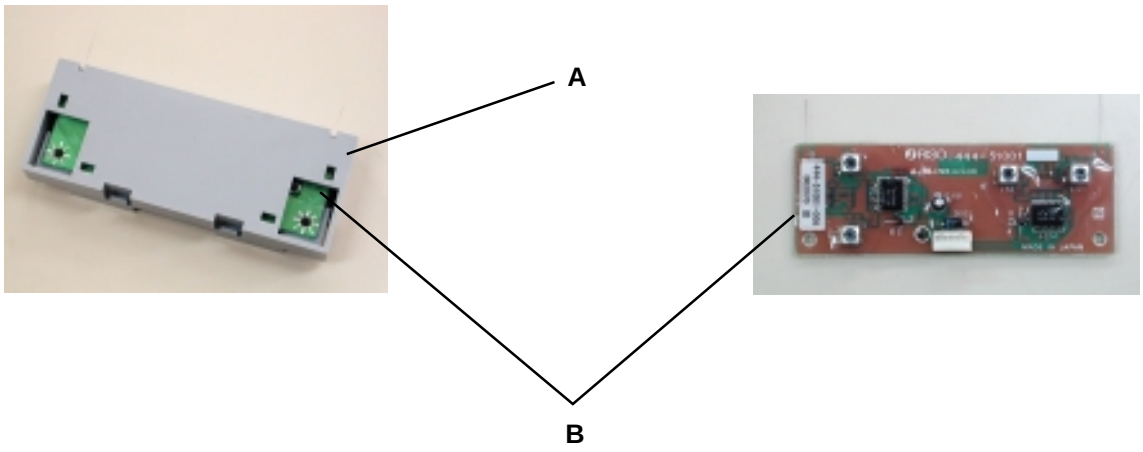
[Work Precautions]

- Take care not to fold or bend the Ink sensor or Overflow sensor.
  If they are bent, straighten them out by hand.

[Checking after Reassembly]

- Check that the Ink sensor does not touch the Doctor roller or Driven shaft.





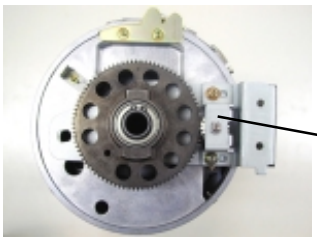
A: Ink sensor cover
B: Ink sensor PCB

11. Removing the Squeegee Roller

(1) Pull out the print drum, and remove the following components.

- Print drum front cover
- Ink cartridge guide ass'y
- Drum front upper cover
- Ink cartridge set switch PCB cover
- Ink cartridge set switch PCB mounting bracket
- Swing base ass'y
- Ink cartridge guide bottom ass'y
- Ink pump unit
- Screen
- Print drum body
- Ink sensor PCB

(2) Remove the two mounting screws on the Junction gear ass'y [A], and remove the Junction gear ass'y [A].

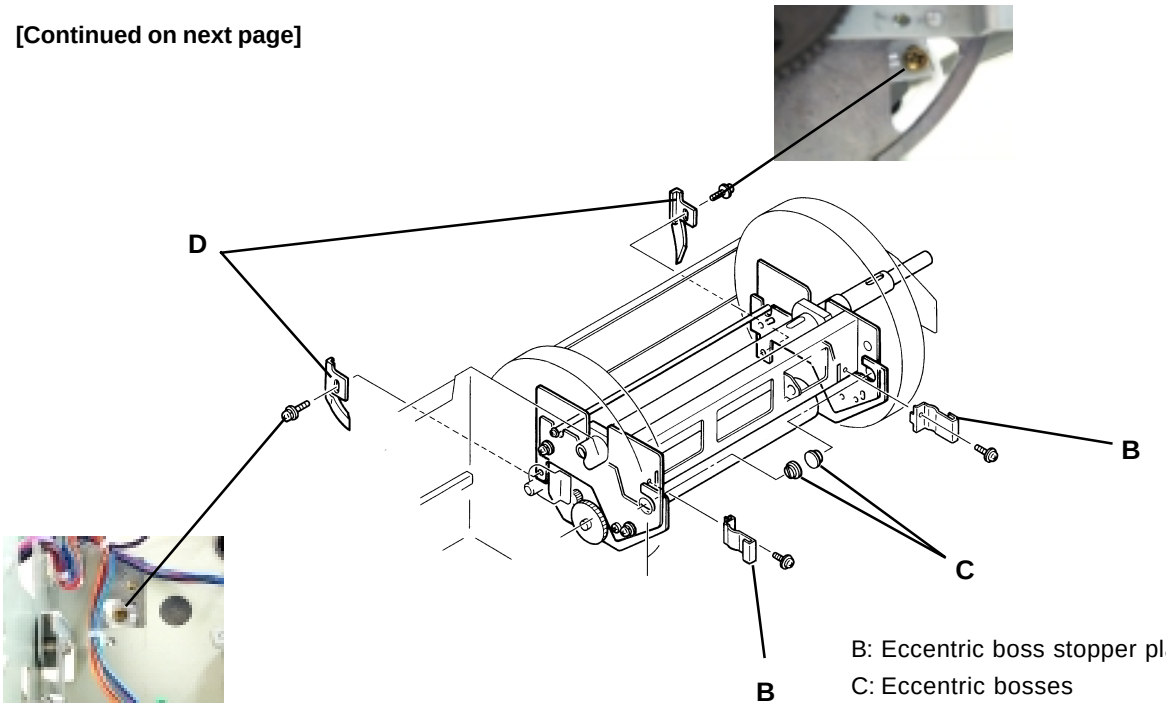


A: Junction gear ass'y

(3) Remove the mounting screws (3 x 6: 1 pc each) on the two Eccentric boss stopper plates [B], and remove the Eccentric bosses [C].

(4) With the print drum at position A, remove the mounting screws (M4 x 6: 1 pc each) on the Ink blocking plates [D] via the holes in the left and right Print drum supports.

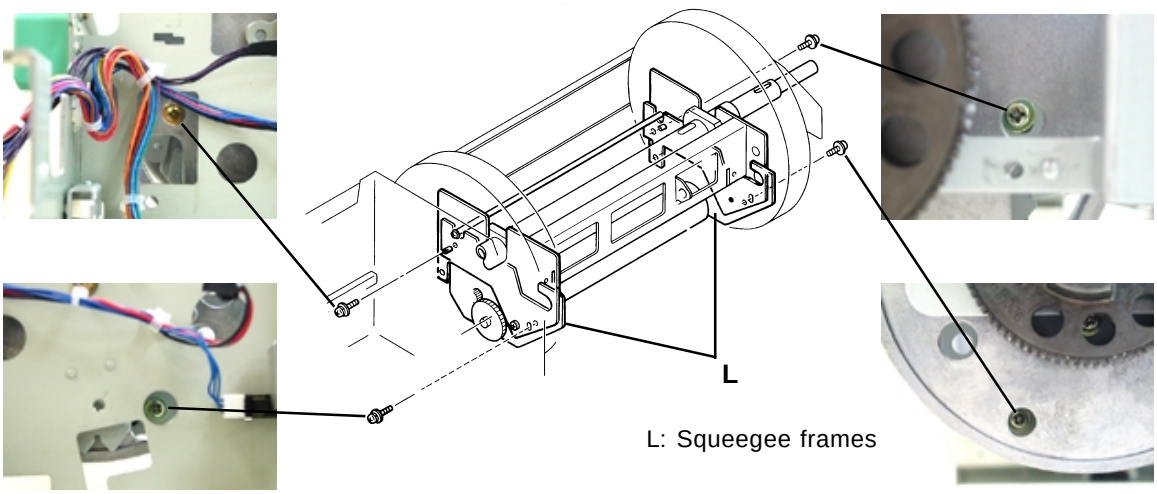
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B: Eccentric boss stopper plate
C: Eccentric bosses
D: Ink blocking plates

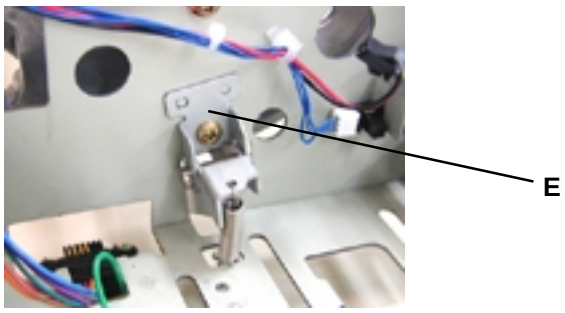
REMOVING THE SQUEEGEE ROLLER

(5) With the print drum at position-A, remove the mounting screws (M4 x 8: 2 pcs each) on the Squeegee frames [L] via the holes in the left and right Print drum supports.



L: Squeegee frames

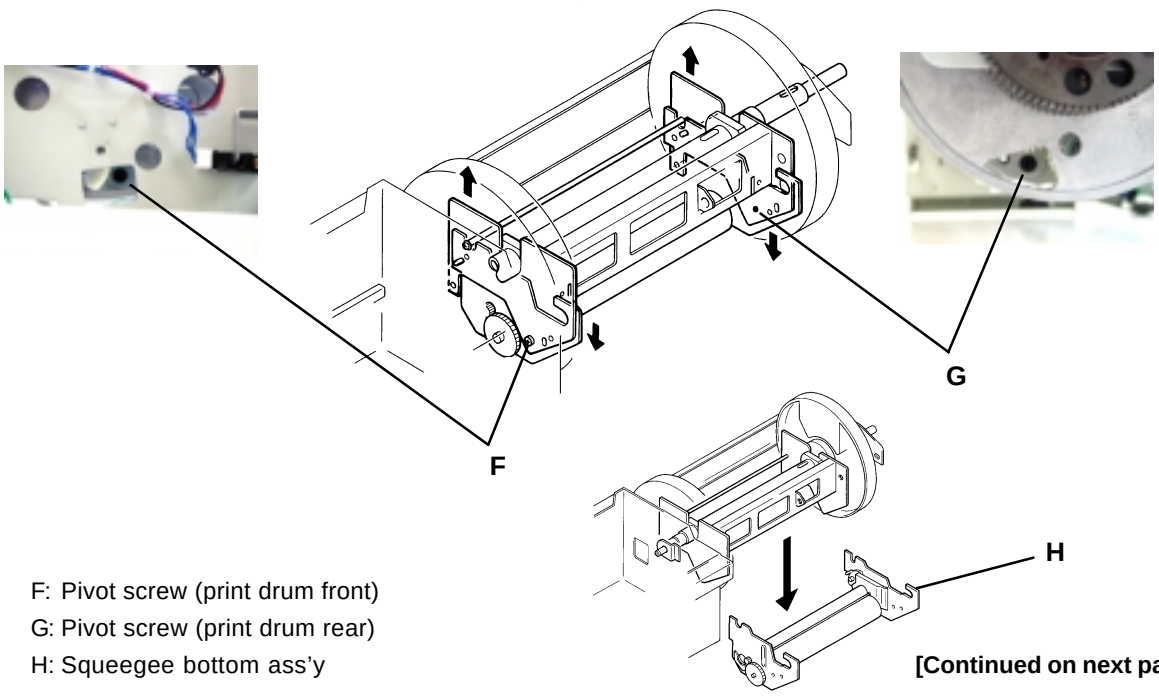
(6) Remove the mounting screw (M4 x 6: 1 pc), and remove the Print drum lock plate ass'y [E].



E: Print drum lock plate ass'y

(7) Remove the Pivot screw [F] on the front of the print drum via the opening in the Print drum support (F) where the Print drum lock plate ass'y was removed. Likewise, remove the Pivot screw [G] on the front of the print drum via the opening in the Print drum support (R).

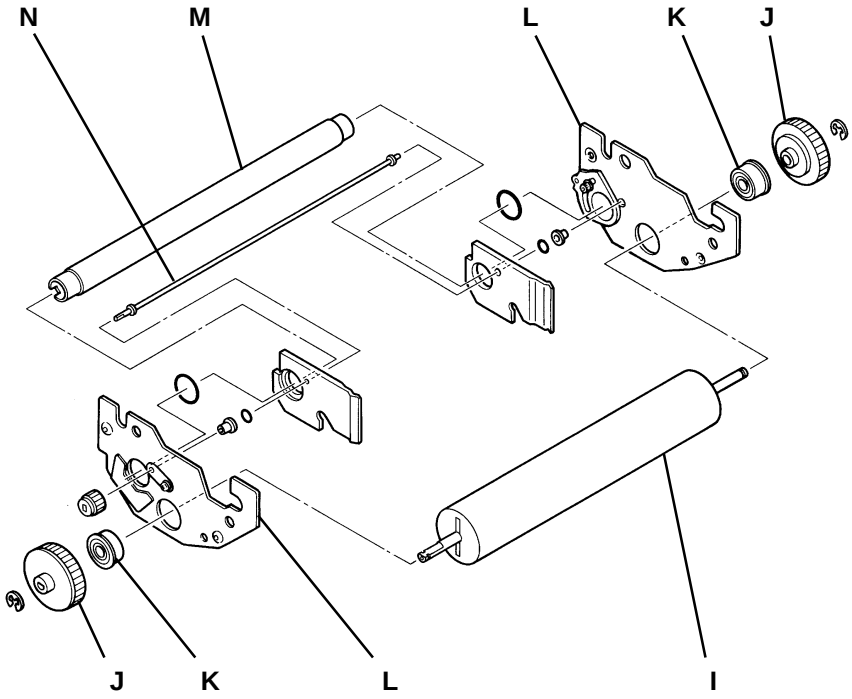
(8) Remove the Squeegee bottom ass'y [H] from the squeegee unit.



F: Pivot screw (print drum front)
G: Pivot screw (print drum rear)
H: Squeegee bottom ass'y

[Continued on next page]

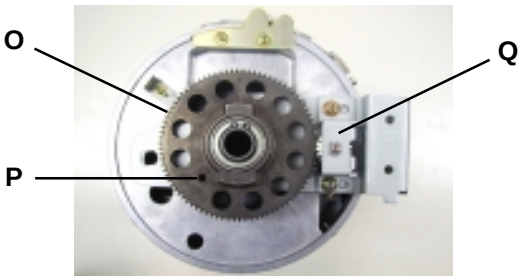
(7) Remove the E-rings on both ends of the Squeegee roller [I], remove the gears [J], remove the bearings [K], and then remove the Squeegee roller [I] from the Squeegee frame [L].
(The Doctor roller [M] and Driven shaft [N] will also come loose when removing the Squeegee roller [I], and are disassembled as shown below.)



I: Squeegee roller
J: Gear
K: Bearing
L: Squeegee frame
M: Doctor roller
N: Driven shaft

[Precautions on Reassembly]

- Align the positioning hole [P] in the Joint gear [O] over the positioning holes in the Drum rear frame plate and Print drum main gear.
- Adjust the position of the Junction gear ass'y [Q] to allow a small amount of backlash between the Junction gear and the Joint gear [O] (and Print drum main gear).



O: Joint gear
P: Joint gear positioning holes
Q: Junction gear ass'y

[Adjustment after Reassembly]

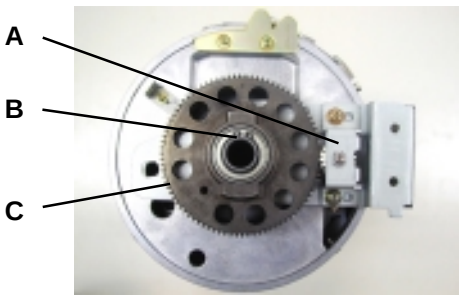
- Squeegee gap adjustment
- Ink blocking plate position adjustment
- Squeegee pressure balance adjustment

12. Removing the Print Drum Supports (R) and (F)

(1) Pull out the print drum, remove the ink cartridge, and remove the following components.
- Print drum front cover
- Ink cartridge guide ass'y
- Drum front upper cover
- Ink cartridge set switch PCB cover
- Ink cartridge set switch PCB mounting bracket
- Swing base ass'y
- Ink cartridge guide bottom ass'y
- Screen
- Print drum body

(2) Unplug the connector on the Ink sensor PCB.

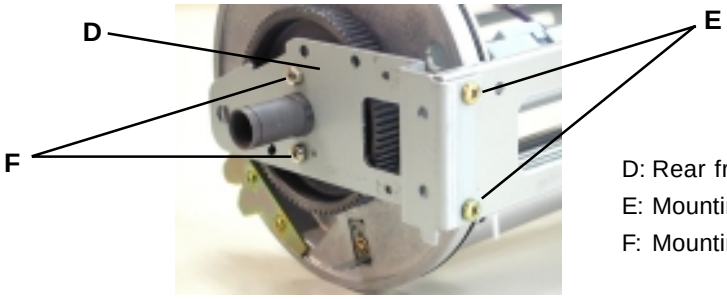
(3) Remove the mounting screws (M4 x 8: 2 pcs) on the Junction gear ass'y [A], and remove the Junction gear ass'y [A].



A: Junction gear ass'y
B: C-ring
C: Joint gear

(4) Remove the C-ring [B] retaining the Joint gear [C] on the ink distributor, and remove the Joint gear [C].

(5) Remove the mounting screws (M4 x 6: 2 pcs) [E] retaining the Drum rear frame plate [D] to the print drum side frame ass'y.



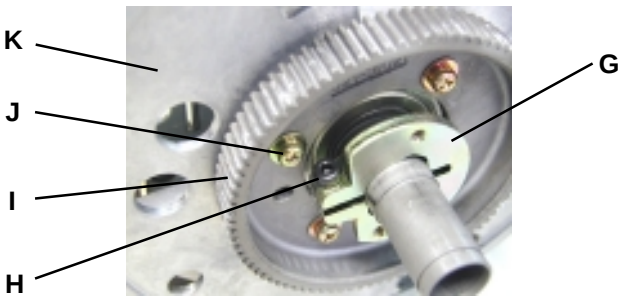
D: Rear frame
E: Mounting screw (M4 x 6: 2 pcs)
F: Mounting screw (M4 x 8: 2 pcs)

(6) Remove the screws (M4 x 8: 2 pcs) [F] that hold the Drum rear frame plate [D] to the Drum shaft clamper [G], and slide out the Drum rear frame plate [D] from the ink distributor.

(7) Loosen the 3-mm Allen bolts [H] on the Drum shaft clamper [G], and slide out the Drum shaft clamper [G] from the ink distributor.

(8) Remove the mounting screws (M4 x 12: 4 pcs) [J] on the Print drum main gear [I], and slide out the Print drum main gear [I] from the ink distributor.

[Continued on next page]

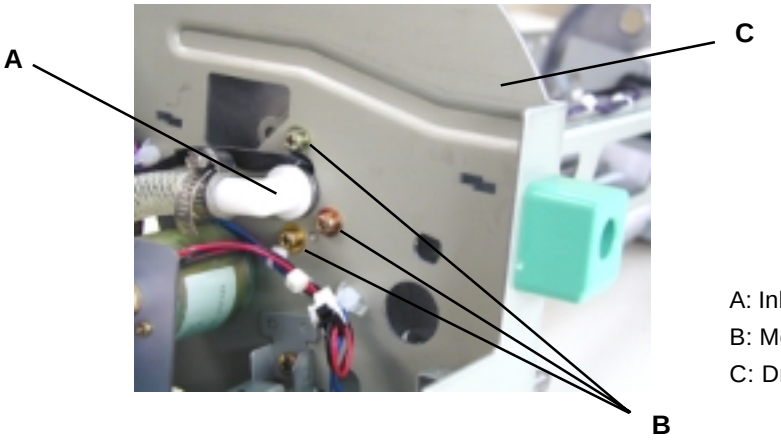


G: Drum shaft clamper
H: 3-mm Allen bolts
I: Print drum main gear
J: Mounting screw (M4 x 12: 4 pcs)
K: Print drum support (R)

(9) Pull the print drum support (R) [K] from the ink distributor.

(10) Pull the Ink outlet nozzle [A] from the ink distributor.

(11) Remove the mounting screws (M4 x 8: 3 pcs) [B] on the Drum front support ass'y [C], and remove the Drum front support ass'y [C] from the drum shaft clamper.

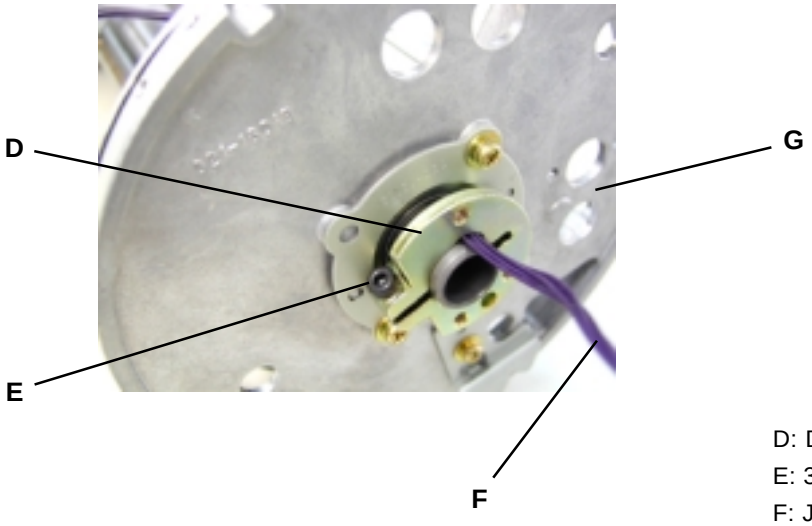


A: Ink outlet nozzle
B: Mounting screws (M4 x 8: 3 pcs)
C: Drum front support ass'y

(12) Loosen the 3-mm Allen bolt [E] on the Drum shaft clamper [D], and slide out the Drum shaft clamper [D] from the ink distributor.

(13) Slide out the Print drum support (F) [G] from the ink distributor, and pull the junction wire harness [F] out through the Print drum support (F) [G].

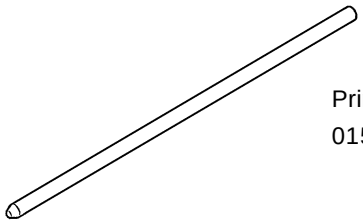
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D: Drum shaft clamper
E: 3-mm Allen bolt
F: Junction wire harness
G: Print drum support (F)

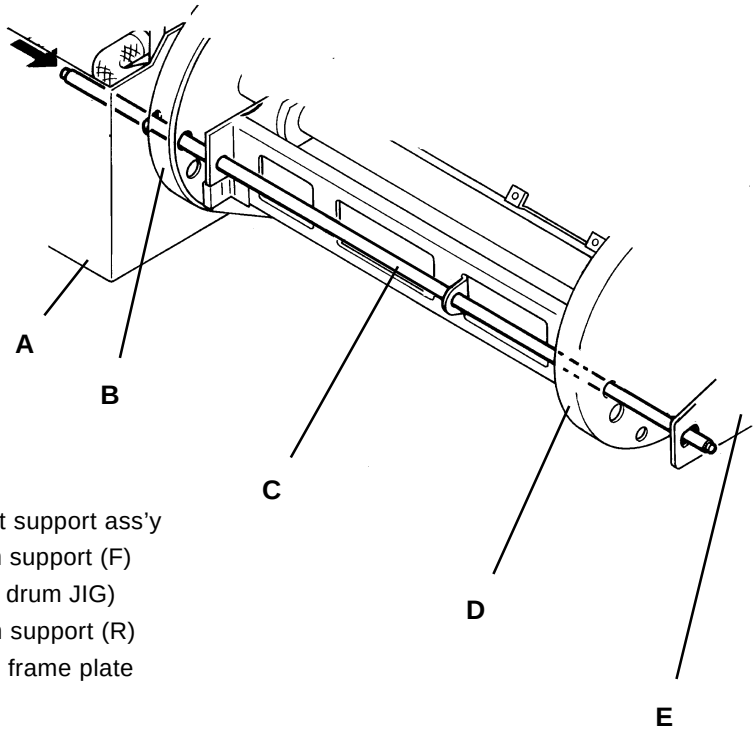
[Precautions on Reassembly: 1]

- Use the tool (Print drum JIG) when tightening the drum shaft clamper mounting screws.



Print drum JIG
015-26128-008

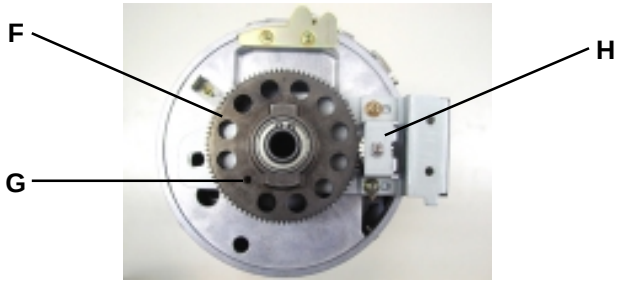
- Move the print drum to position A, insert the tool (Print drum JIG) through the holes in the Drum front support ass'y [A], Print drum support (F) [B], Print drum support (R) [D], and Drum rear frame plate [E], and then tighten the Allen bolts on both Drum shaft clampers.



A: Drum front support ass'y
B: Print drum support (F)
C: Tool (Print drum JIG)
D: Print drum support (R)
E: Drum rear frame plate

[Precautions on Reassembly: 2]

- Align the positioning hole [G] in the Joint gear [F] over the positioning holes in the Drum rear frame plate and Print drum main gear.
- Adjust the position of the Junction gear ass'y [H] to allow a small amount of backlash between the Junction gear and the Joint gear [F] (and Print drum main gear).



F: Joint gear
G: Joint gear positioning holes
H: Junction gear ass'y

Adjustment

1. Filter Cleaning

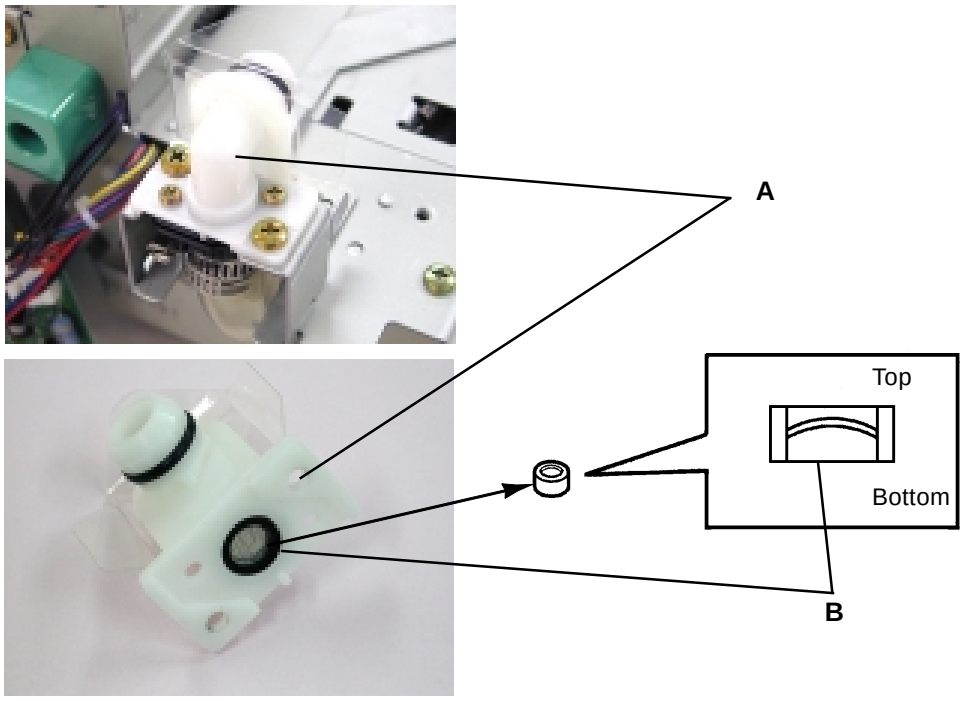
(1) Pull out the print drum, remove the ink cartridge, and remove the following components.
- Ink cartridge guide ass'y
- Drum front upper cover
- Ink cartridge set switch PCB cover
- Ink cartridge set switch PCB mounting bracket

(2) Remove the mounting screws (M4 x 6: 2 pcs and M3 x 10: 2 pcs) on the Ink intake nozzle [A], and remove the nozzle.

(3) Remove the Filter [B] and clean it.

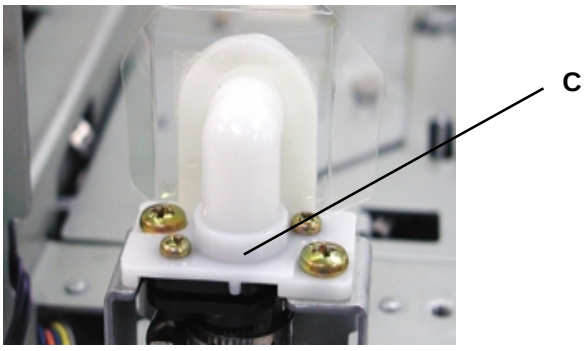
[Symptoms]

- If foreign matter is drawn into the filter, ink will no longer be drawn in, resulting in a lack of ink in the print drum.



[Precautions on Reassembly]

- Mount the Filter [B] with the rounded top facing upwards.
- Engage the lug on the bottom of the Ink intake nozzle [A] into the slot in the lower base [C].



A: Ink intake nozzle
B: Filter
C: Lug and slot

2. Squeegee Gap Adjustment

(1) Pull out the print drum, and remove the following components.

- Screen
- Print drum body

(2) Clean out the ink inside the squeegee unit.

(3) Using a feeler gauge, check that the gap between the Squeegee roller and Doctor roller is in specified setting (0.08 mm ±0.02 mm at front and rear).

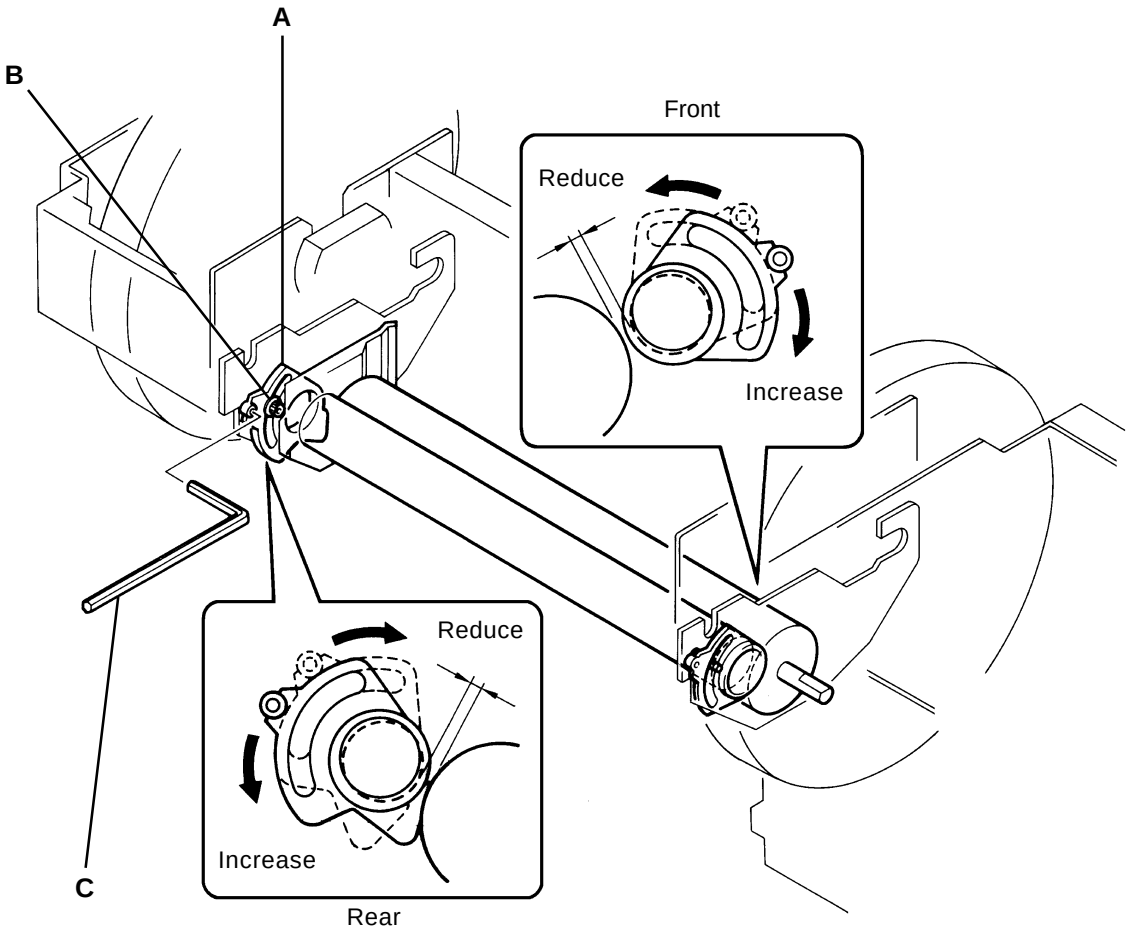
(4) If the gap is outside the specifications, loosen the retaining screw on the Doctor roller adjust plate [A] with 3mm Allen wrench.

(5) Insert the Allen wrench [C] into the hole in the Doctor roller adjust plate [A], and make the adjustment by moving the adjustment plate.

(6) Tighten the retaining screw.

[Symptoms]

- If the gap is too large, more ink than is necessary will be transferred onto the inside surface of the print drum, causing ink to leak.
- Conversely, if the gap is too small, insufficient ink will be transferred onto the inside surface of the print drum, possibly resulting in uneven printing density due to lack of ink.



A: Doctor roller adjust plate
B: Allen bolt for 3 mm Allen wrench
C: 2.5 mm Allen wrench

3. Ink Blocking Plate Position Adjustment

Front

(1) Pull out the print drum, remove the ink cartridge, and remove the following components.

- Print drum front cover
- Ink cartridge guide ass'y
- Drum front upper cover
- Ink cartridge set switch PCB cover
- Ink cartridge set switch PCB mounting bracket
- Swing base ass'y
- Ink cartridge guide bottom ass'y
- Ink pump unit

(2) Loosen the mounting screw on the Ink blocking plate (F) [A] via the opening in the Print drum support (F).

(3) Insert a slot-head screwdriver into the slot in the Ink blocking plate (F) [A] and move the plate until it is flush with the inside surface of the print drum. Tighten the mounting screw.

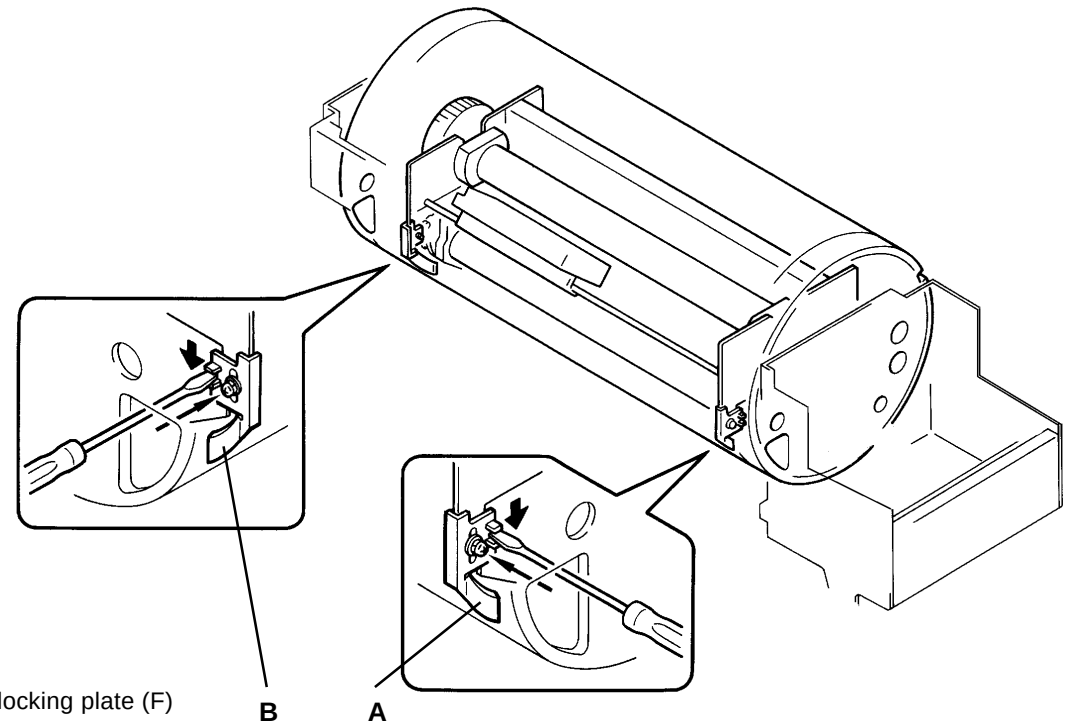
Rear

(1) Pull out the print drum, and loosen the mounting screw on the Ink blocking plate (R) [B] via the opening in the Print drum support (R).

(2) Insert a slot-head screwdriver into the slot in the Ink blocking plate (R) [B] and move the plate until it is flush with the inside surface of the print drum. Tighten the mounting screw.

[Symptoms]

- If the ink blocking plates are not flush with the inside surface of the print drum, they will not be able to block the ink exuded to the ends of the Squeegee roller. Ink will accumulate inside the print drum, and in the worst cases, ink may leak out from the print drum body.



A: Ink blocking plate (F)
B: Ink blocking plate (R)

4. Squeegee Pressure Balance Adjustment

(1) Create a master with test chart No. 15 and print to check the left and right print density balance.

(2) If the left and right print density is not balanced, adjust as shown below.

Front

(3) Pull out the print drum, remove the ink cartridge, and remove the following components.

- Print drum front cover
- Ink cartridge guide ass'y
- Drum front upper cover
- Ink cartridge set switch PCB cover
- Ink cartridge set switch PCB mounting bracket
- Swing base ass'y
- Ink cartridge guide bottom ass'y
- Ink pump unit

(4) Loosen the two retaining screws on the squeegee frame via the opening in the Print drum support (F).

(5) Insert a slot-head screwdriver via the opening in the Print drum support (F), turn the Eccentric boss [A], and adjust so that the gap between the squeegee roller and the print drum body is approx. 0.3 mm.

(6) Tighten the two retaining screws [B] on the squeegee frame.

Rear

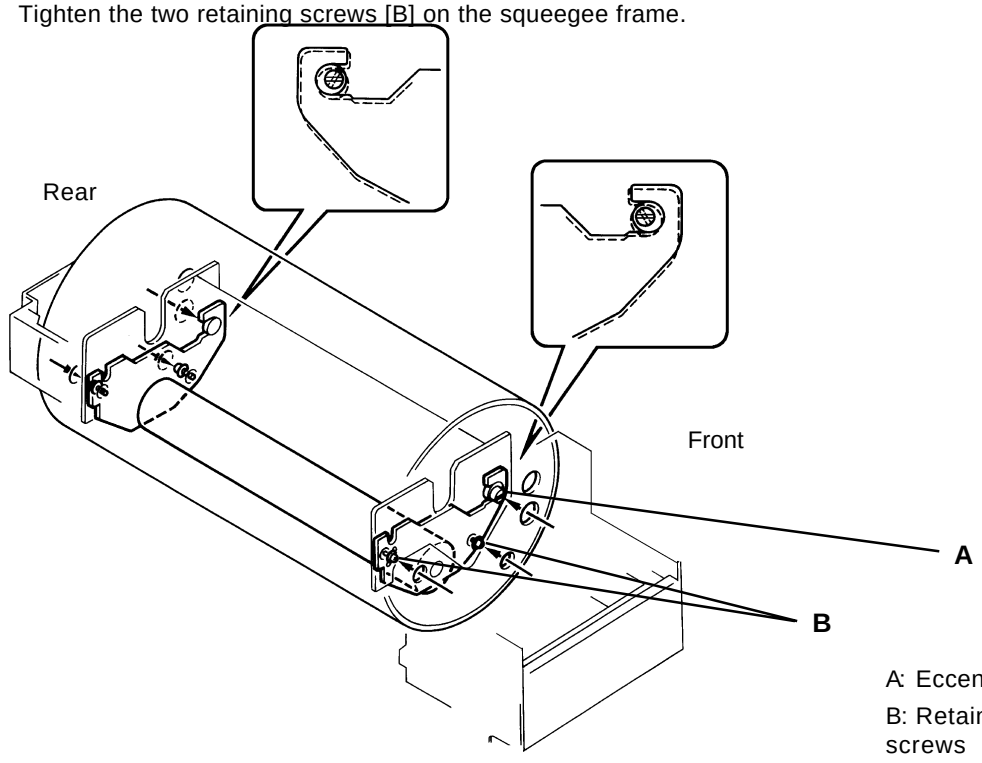
(3) Pull out the print drum, remove the ink cartridge, and remove the following component.

- Junction gear ass'y

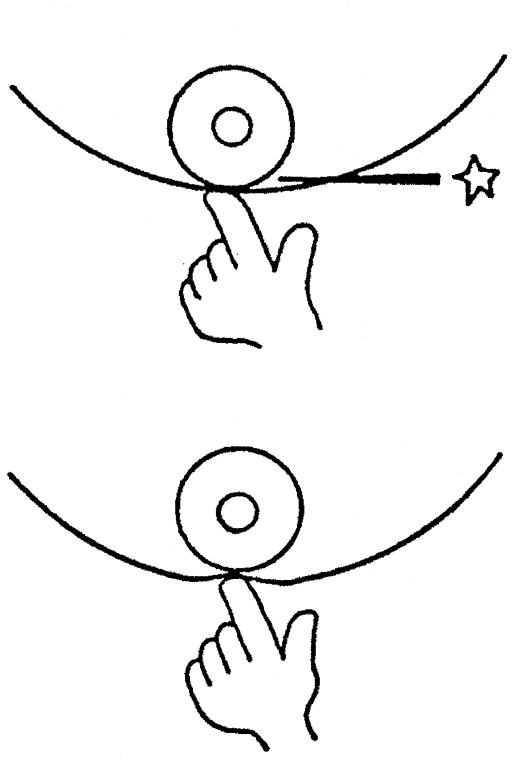
(4) Loosen the two retaining screws on the squeegee frame via the opening in the Print drum support (R).

(5) Insert a slot-head screwdriver via the opening in the Print drum support (R), turn the Eccentric boss [A], and adjust so that the gap between the squeegee roller and the print drum body is approx. 0.3 mm.

(6) Tighten the two retaining screws [B] on the squeegee frame.



A: Eccentric boss
B: Retaining screws



[Continued on next page]

- Using your finger, press the print drum from underneath, and adjust the gap to approx. 0.3 mm.

[Checking after Adjustment]

- Run an actual print after the adjustment to check the left and right print density balance.
  If the left and right print density balance is incorrect, the squeegee pressure must be readjusted.

[Symptoms]

- Incorrect left and right squeegee pressure causes unbalanced print density.
- If the squeegee pressure is too high (gap too small), more ink than is needed will be transferred onto the print drum and may cause ink leakage.
- If the squeegee pressure is too low (gap too large), the print density will be reduced, and excess load will be applied on the print drum and may shorten the life of the drum body.

[Memo]