

## The 20 Step Remanufacturing Process Laser Toner Cartridges



1. Every empty laser toner cartridge is inspected for damage. Only high quality cartridges and parts are accepted.
2. A Quality Assurance team print tests all critical components, like toner, and inspects the remaining parts.
3. Each cartridge is disassembled and inspected. The shell is inspected and cleaned. All manufacturer labels are removed. Parts are replaced if there is any sign of damage.
4. The toner waste hopper is disassembled, cleaned, and inspected.
5. The primary charge roller is inspected, cleaned, and refurbished, if necessary.
6. The toner hopper is disassembled, inspected, and cleaned.
7. The toner hopper is prepared for the sealing process. The toner hopper is split. If applicable, the sections are then inspected and the surface is prepared for the sealing process.
8. The developing roller (or mag roller) is cleaned, inspected, and refurbished, if necessary.
9. Small parts are inspected and cleaned ultrasonically, if applicable, including gears, bushing, and corona wires.
10. Wiper blades are replaced. Doctor blades are cleaned and inspected or replaced, if necessary.
11. The toner hopper is sealed. The appropriate seal is applied, either heat activated adhesive or pressure adhesive. Foam strips are then applied, followed by a toner leak test, as applicable. If the seal fails, it is rejected.
12. The toner hopper is filled with premium graphics toner. Each toner hopper is weighed to verify fill amount. The cap is installed and the hopper is tested for leaks.
13. The toner hopper is assembled, and pre-qualified developing rollers and doctor blades are installed. Final assembly is completed with pre-qualified parts.
14. The waste hopper is assembled and a new aftermarket wiper blade is installed per design. Assembly is completed with pre-qualified parts and a shutter protector is added, if needed.
15. The premium drum (OPC) is installed. Powder and lubricant are added for reliable performance, and the drum is matched to the toner.
16. The cartridge final assembly process begins. The developing roller is primed with toner and lot stickers are attached to the cartridge.
17. After assembly, each cartridge is print tested for performance. If any print defects are detected the cartridge is rejected.
18. In-process testing begins. Random cartridges are evaluated (including destructive testing) by quality assurance. If any cartridge fails, the entire lot is placed on hold and re-inspected.
19. Cartridges are inspected and cleaned for the last time.
20. Cartridges are securely wrapped and inserted into a protective shipping carton. An instruction sheet is also included with installation and cleaning information.

**Contact us at 800.448.1422  
for more information.**