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Xerox[®] Iridesse™ Production Press

Carrier Procedures Manual

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Page	Issue

This document is intended for use by authorized Logistic Service Providers only and is not for resale.

This document describes the Pre-Install process steps/packaging items that must be used to ensure the product can be safely shipped after Pre-Install before shipping to the Customer.

While every care has been taken in the preparation of this manual, no liability will be accepted by Xerox arising out of the use of this manual including, but not limited to, inaccuracies or omissions.

Any damage/installation failures caused by Pre-Installation steps deviating from the described process in this document will be at own risk, no warranty replacements will be guaranteed.

Note:

Notes are signified by the use of the “info” symbol. The word “Note” is used in Carrier manuals. A note is used to alert personnel to a procedure, practice, condition or statement that is necessary to accomplish a task efficiently.

Notes usually precede the step describing the action that needs additional explanation, but may follow the step if necessary for clarity.

Stop:

Stops are signified by the use of the “stop sign” symbol. The word “Stop” is used in the Carrier manual. A stop is used to alert personnel of a decision that is necessary at that point or information that is important before proceeding.

Stops usually precede the step or are represented as a step, but may follow the step if necessary for clarity.

Caution:

Cautions are used whenever a procedure, practice, condition, or statement, if not strictly observed, could result in damage to the equipment. Cautions are identified with an “Alert” symbol and the word CAUTION (all caps) at the beginning of the paragraph.

Cautions **always** precede the step with the action.

Warning:

Warnings are used whenever a procedure, practice, condition, or statement, if not strictly observed, could result in personal injury or death. Warnings are identified with the appropriate warning symbol and the word WARNING (all caps, bold) at the beginning of the paragraph. When a specific warning symbol is not available, an “Alert” symbol will be used to identify these general warnings.

Warnings **always** precede the step with the action.

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General Information

Product	Product Code/ Part Numbers North America (60 Hz)	Install Responsibility North America	Product Code/Part Numbers Europe (50 Hz)	Install Responsibility Europe
Pallet 1 - IOT Left Module	2XL/100S14375*	CSE	XiPP120V_F	LSP
Pallet 2 - IOT Right Module	4XL/100S14377*	CSE	4XL/100S14377	LSP
Printer Power Cord (60 Amp)	497K19060	CSE	---	---
Multi-National Nationalization Kit	---	---	650S42620	LSP
XPP Basic	497K19610	CSE	---	---
Step Stool	497K05860	N/A	497K05860	N/A
Parts Cabinet	497K06490	Carrier	497K07470	LSP
PC UI	43B/097N02308	CSE	59B/097S04979	LSP
22 TFT Monitor	42B/097N02307	CSE	75B/097S04980	LSP
Remote Service Disconnect - Opt Out Kit	U9A	CSE	---	---
Mobility Plate A	497K04440	Carrier	497K04440	LSP
Mobility Plate B	497K05270	Carrier	497K05270	LSP
Power Strip	498K16920	CSE	---	---
5th Color IOT Enablement Kit	497K18570	CSE	497K18570	LSP
6th Color IOT Enablement Kit	497K18580	CSE	497K18580	LSP
Clear MM Specialty Dry Ink Kit	497K19500	CSE	497K19500	LSP
Gold MM Specialty Dry Ink Kit	497K19510	CSE	497K19510	LSP
Silver MM Specialty Dry Ink Kit	497K19530	CSE	497K19530	LSP

LSP = Logistic Service Provider, C = Customer, CSE = Customer Service Engineer

Note: 2XL / XiPP120V_F identifies Pallet 1 [IOT Left Module and Ecology Module* (ECO Box)]

Note: 4XL/100S14377 identifies Pallet 2 [IOT Right Module, Ecology Module 2* (ECO Box 2), Four Toner Cartridges, Two Chassis Assy LVPS boxes, Cover Tray FDR box and an unmarked box.]

* Modules that will be docked and leveled by the Carrier.

Note: The ECO Box shipped on Pallet 1 and ECO Box 2 shipped on Pallet 2 are docked and leveled by the Carrier.

Table 1.1.1

1.0.0 General Information

1.1.0 Product Codes and Part Numbers

1.1.1 The product codes and part numbers for the Xerox® Iridesse™ Production Press system and the accessories are shown in Table 1.1.1.

Product	Product Code/ Part Numbers North America (60 Hz)	Install Responsibility North America	Product Code/Part Numbers Europe (50 Hz)	Install Responsibility Europe
CCU Cart	X0Y/097S04716	Carrier	X0Y/097S04716	LSP
MSI Bypass Tray	497K09130	Carrier	497K09130	LSP
Oversize High Capacity Feeder (OHCF)	B4E/097S04591	CSE	450S03106	LSP
Power Cord	498K18310	Carrier	498K18310	LSP
I-tra kit for the HCF	497K18640	CSE	497K18640	LSP
Dual Advanced High Capacity Feeder (DAHCF)	P4X/097S04666	CSE	450S03107	LSP
OCT (Offset Catch Tray)	497K02420	Carrier	497K02420	LSP
OCT Exit Roll Kit	497K04660	CSE	497K13980	LSP
High Capacity Stacker (HCS)	MAY/097S03930	CSE	450S03138	LSP
HCS Dolly	NBV/098S05050	Carrier	098S05050	LSP
HCS UI Fixed Angle Kit	498K17820	C/CSE	498K17820	C/CSE
Production Ready Finisher (Standard Finisher)	3AE/097S04749	CSE	097S04749	LSP
Production Ready Booklet Maker Finisher	4AE/097S04750	CSE	097S04750	LSP
Production Ready Finisher (Standard Finisher Plus)	5AE/097S04751	CSE	097S04751	LSP
Partner Finishing Interface Module (PFIM)	XMH/097S04171	CSE	097S04171	CSE
Interface Decurler Module	7AE/097S04753	CSE	097S04753	LSP
PR Punch Module 2/3	097K16710	Carrier	---	---
PR Punch Module 2/4	---	---	097K16720	LSP

LSP = Logistic Service Provider, C = Customer, CSE = Customer Service Engineer

Table 1.1.1 (continued)

1.1.2 The product codes and part numbers for the Xerox® Iridesse™ Production Press system and the accessories are shown in Table 1.1.1 (continued).

Product	Product Code/ Part Numbers North America (60 Hz)	Install Responsibility North America	Product Code/Part Numbers Europe (50 Hz)	Install Responsibility Europe
PR Punch Module - Swedish	---	---	097K16739	LSP
CZ Folder Module	2AE/097S04748	CSE	450S03139	LSP
Fin IF Cable 3M	497K17460	Carrier	497K17460	LSP
Fin IF Cable 4M	497K17470	Carrier	497K17470	LSP
SquareFold® Trimmer	6AE/097S04752	CSE	097S04752	LSP
Crease and Two-sided Trimmer	7XL/097S04958	CSE	450S03153	LSP
Interpose Module	0AE/097S04746	CSE	097S04746	LSP
GBC AdvancedPunch Pro	X5K/097N02204	CSE	497K18750	LSP
GBC Die for AdvancePunch Pro	497N04064	Carrier	497N04064	LSP
EFI™ Standalone - NX Premium DFE	2A8/097N02291	CSE	2A8/097N02291	LSP
Additional LAC for Fiery Compose Option	497N05471	C/CSE	497N05471	C/CSE
Additional LAC for Fiery Impose Option	497N05470	C/CSE	497N05470	C/CSE
Specialty Dry Ink 5th Color	497N05269		497N05269	C/CSE
3 Bay HDD Enclosure	497N04850	C/CSE	497N04850	C/CSE
Swappable HDD Kit, 1 TB (X2) 500GB	497N04813	C/CSE	497N04813	C/CSE
FreeFlow® VI Compose SW and License	NWR	CSE	300S01843	CSE
FreeFlow® VI Design Pro SW and License	NWT	CSE	300S01844	CSE
Quick Print Sign	497K06860	CSE	--	--

LSP = Logistic Service Provider

Table 1.1.1 (continued)

1.1.3 The product codes and part numbers for the Xerox® Iridesse™ Production Press system and the accessories are shown in Table 1.1.1 (continued).

Product Code/ Part Number	Packaged Weight kg	Packaged Weight lb	Packaged Size (L x W x H) mm	Packaged Size (L x W x H) in.	Stack Height
Pallet 1 - Crated 2XL/100S14375	---	---	2400 x 1276 x 2292	94.5 x 50.25 x 90.25	1
Pallet 1 - Uncrated 2XL/100S14375	960	2112	2159 x 1149 x 2013	85 x 45.25 x 79.25	1
Eco Box*	---	---	1092 x 470 x 1689	43 x 18.5 x 66.5	--
Pallet 2 - Crated 4XL/100S14377	---	---	2400 x 1226 x 2191	94.5 x 48.25 x 86.25	1
Pallet 2 - Uncrated 4XL/100S14377	650	1430	2197 x 1048 x 1676	86.5 x 41.25 x 66	1
Eco Box 2**	---	---	559 x 419 x 1689	22 x 16.5 x 66.5	--
497K04440	10	23	533 x 940 x 51	21 x 37 x 2	--
497K05270	8.6	19	533 x 787 x 51	21 x 31 x 2	--
B4E / 450S03106	240	530	905 x 1130 x 1180	35.5 x 44 x 46	1
497K18640	7	15.4	627 x 223 x 353	24.7 x 8.8 x 13.9	--
497K06490 / 497K07470	71	193	914 x 610 x 1981	36 x 24 x 78	--
43B/097N02308 / 59B/097S04979	9	20	516 x 298 x 523	20.3 x 11.75 x 20.6	--
42B/097N02307 / 75B/097S04980	6.4	14.1	457 x 373 x 239	18 x 14.7 x 9.4	--
P4X / 450S03107	235	518	905 x 1130 x 1180	36.75 x 44.5 x 46.5	1
7AE/097S04753	75	165.3	864 x 1105 x 559	34 x 43.5 x 22	1
0AE/097S04746	61.5	135.6	895 x 1143 x 775	35.25 x 45 x 30.5	1
X5K / 497K1850	105	232	1194 x 991 x 864	47 x 39 x 34	1
497N04064	3.5	7.8	155 x 102 x 574	6.1 x 4 x 22.6	1
MAY / 450S03138	91	200	787 x 1143 x 1219	31 x 45 x 48	--
NBV/098S05050	15	33	572 x 541 x 442	22.5 x 21.3 x 17.4	--
498K17820	1	2	95 x 32 x 122	3.75 x 1.25 x 4.8	--
7XL / 450S03153	148	326.3	787 x 902 x 1207	31 x 35.5 x 47.5	1

* = Items shipped on pallet 1.

** = Item shipped on pallet 2.

Table 1.2.1

1.2.0 Product Weights and Sizes

1.2.1 The packaged weights and sizes are shown in Table 1.2.1.

Product Code/ Part Number	Packaged Weight kg	Packaged Weight lb	Packaged Size (L x W x H) mm	Packaged Size (L x W x H) in.	Stack Height
2AE / 450S03139	74	164	864 x 1137 x 470	34 x 44.75 x 18.5	1
3AE/097S04749	112	247	1010 x 832 x 1410	39.75 x 32.75 x 55.5	1
4AE/097S04750	117	258	1010 x 832 x 1410	39.75 x 32.75 x 55.5	1
5AE/097S04751	102	225	1010 x 832 x 1410	39.75 x 32.75 x 55.5	1
497K16710	6.4	14.1	752 x 343 x 312	29.6 X 13.5 X 12.3	--
6AE/097S04752	120	264.6	895 x 908 x 768	35.25 x 35.75 x 30.25	--
497K09130	8.4	18.5	711 x 236 x 213	28 x 9.3 x 8.4	--
497K02420	1.3	2.8	551 x 152 x 152	21.7 x 6 x 6	--
497K13980	.6	1.3	150 x 545 x 155	5.9 x 21.5 x 6.1	--
XMH/097S04171	152	335	899 x 861 x 1255	35.4 x 33.9 x 49.4	--
497K17460	.5	1	155 x 246 x 76	14.25 x 9.7 x 3	--
497K17470	.5	1	155 x 246 x 76	14.25 x 9.7 x 3	--
497K18570	.7	15.7	749 x 551 x 450	29.5 x 21.7 x 17.7	--
497K18580	4.3	9.5	749 x 551 x 450	29.5 x 21.7 x 17.7	--
497K19500 / 497K19510 / 497K19530	24	54	851 x 597 x 782	33.5 x 23.5 x 30.8	--
498K18310	.5	1.1	155 x 246 x 76	14.25 x 9.7 x 3	--
X0Y/097S04716	68.5	151	1207 x 1003 x 1232	47.5 x 39.5 x 48.5	--
2A8/097N02291	115	253	1219 x 914 x 1346	48 x 36 x 53	--
497N05471	.5	1	248 x 311 x 25	9.75 x 12.25 x 1	--
497N05470	.5	1	248 x 311 x 25	9.75 x 12.25 x 1	--
497N05269	1.4	3	483 x 432 x 76	19 x 17 x 3	--
497N04850	7.7	17	406 x 330 x 330	16 x 13 x 13	--
497N04813	7.7	17	406 x 330 x 330	16 x 13 x 13	--

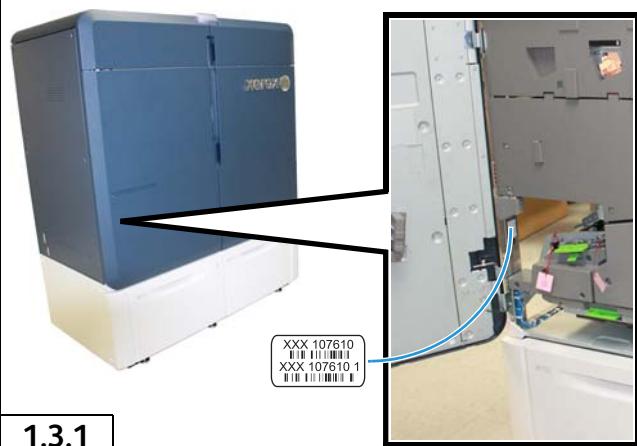
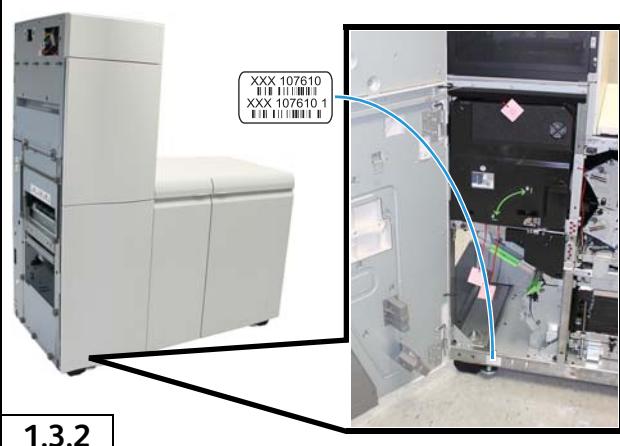
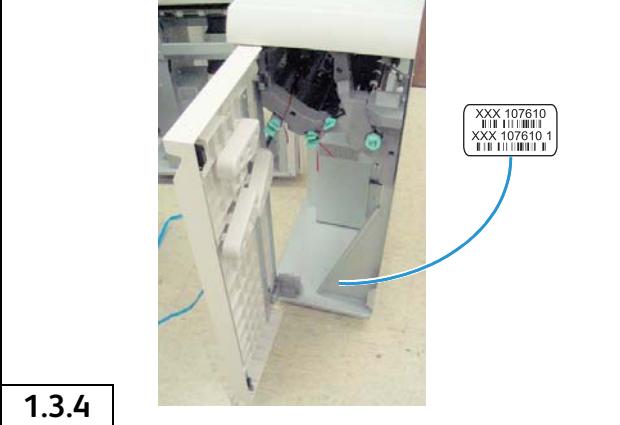
Table 1.2.1 (continued)

1.2.2 The packaged weights and sizes are shown in Table 1.2.1 (continued).

Product Code/Part Number	Unpackaged Weight		Unpackaged Size (L x W x H)	
	kg	lb	mm	in.
Pallet 1 - 2XL/100S14375*	794	1750	1537 x 775 x 1848	60.5 x 30.5 x 72.75
Pallet 1 - Ecology Module (Eco Box)	116	256	927 x 318 x 1619	36.5 x 12.5 x 63.75
Pallet 2 - 4XL/100S14377*	435	960	1461 x 819 x 1740	57.5 x 32.25 x 68.5
Pallet 2 - Ecology Module 2 (Eco Box 2)	20	44	489 x 318 x 1619	19.25 x 12.5 x 63.75
497K04440	4	9	502 x 914 x 6	19.75 x 36 x 0.25
497K05270	7	16	502 x 749 x 6	19.75 x 29.5 x 0.25
B4E / 450S03106	190	419	991 x 762 x 991	39 x 30 x 39
43B/097N02308 / 59B/097S04979	5.2	11.4	318 x 292 x 76	12.5 x 11.5 x 3.5
42B/097N02307 / 75B/097S04980	4.8	10.6	495 x 338 x 178	19.5 x 13.3 x 7
497K02420	4	9	599 x 541 x 343	23.6 x 21.3 x 13.5
497K06490 / 497K07470	61	140	914 x 610 x 1981	36 x 24 x 78
2A8/097N02291	21.8	48.1	527 x 235 x 578	20.75 x 9.25 x 22.75
P4X / 450S03107	190	419	991 x 762 x 991	39 x 30 x 39
7AE/097S04753	48	106	340 x 699 x 990	13.5 x 27.5 x 39
0AE/097S04746	45	99	521 x 699 x 1238	20.5 x 27.5 x 48.75
X5K / 497K18750	86	190	356 x 730 x 991	14 x 28.75 x 39
MAY / 450S03138	158	348	800 x 724 x 997	31.5 x 28.5 x 39.25
NBV/098S05050	13	28	660 x 445 x 546	26 x 17.5 x 21.5
7XL / 450S03153	118	260	603 x 692 x 991	23.75 x 27.25 x 39
2AE / 450S03139	52	115	229 x 686 x 991	9 x 27 x 39
3AE/097S04749	85	187	851 x 686 x 1181	33.5 x 27 x 46.5
4AE/097S04750	105	231	851 x 686 x 1181	33.5 x 27 x 46.5
5AE/097S04751	90	198	851 x 686 x 1181	33.5 x 27 x 46.5
6AE/097S04752	107	235	978 x 724 x 546	38.5 x 28.5 x 21.5
XMH/097S04171	67	148	832 x 654 x 1003	32.75 x 25.75 x 39.5
XOY/097S04716	40.4	89	978 x 445 x 1067	38.5 x 17.5 x 42

Table 1.2.2

1.2.3 The unpackaged weights and sizes are shown in Table 1.2.2.

2XL/100S14375 / XiPP120V_F**4XL/1000S14377****B4E / 450S03106, P4X / 450S03107****7AE/097S04753**

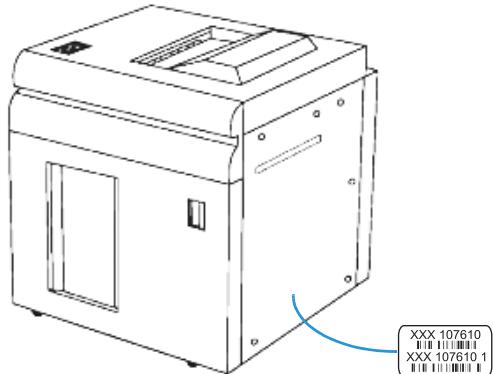
1.3.0 Serial Plate Location

1.3.1 The Xerox® Iridesse™ Production Press IOT Left serial plate is located on the left frame member behind the front left cover.

1.3.2 The Xerox® Iridesse™ Production Press IOT Right serial plate is located on the bottom frame member behind the front left cover.

1.3.3 The 2 Tray Oversize High Capacity Feeder (B4E / 450S03106) and the Dual Advanced High Capacity Feeder (P4X / 450S03107) serial plate is located on the lower frame behind the front right cover.

1.3.4 The Interface Decurler Module (IDM) serial plate is located on the bottom right behind the front cover.

0AE/097S04746**1.3.5****X5K / 497K18750****1.3.6****MAY / 450S03138****1.3.7****7XL / 450S03153****1.3.8**

1.3.5 The Interposer Module serial plate is located on the bottom frame member behind the front cover.

1.3.6 The GBC AdvancedPunch Pro serial plate is located on the middle frame member behind the front cover.

1.3.7 The High Capacity Stacker (HCS) serial plate is located on the right side frame member inside the front cover.

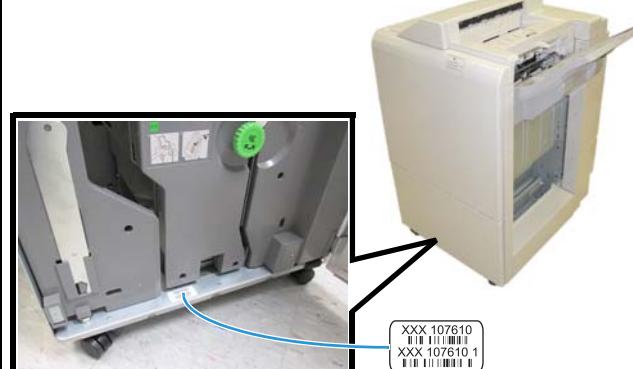
1.3.8 The Crease and Two-side Trimmer serial plate is located on the middle frame member behind the front cover.

2AE / 450S03139



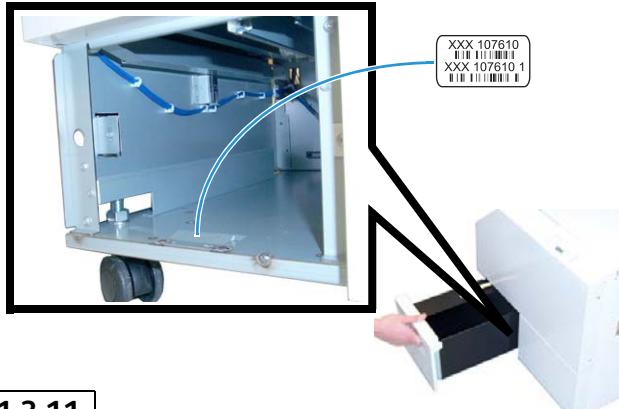
1.3.9

3AE/097S04749, 4AE/097S04750, 5AE/097S04751



1.3.10

6AE/097S04052



1.3.11

XMH/097S04171



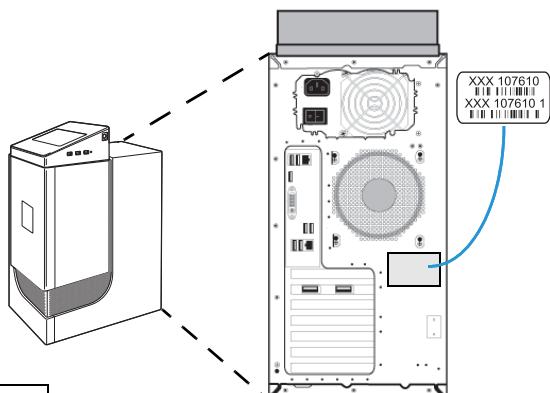
1.3.12

1.3.9 The CZ Folder serial plate is located on the right side bottom edge.

1.3.10 The Production Ready Finisher serial plate is located on the bottom middle edge behind the front door.

1.3.11 The Integrated SquareFold® Trimmer serial plate is located on the bottom surface under the left drawer.

1.3.12 The PFIM serial plate is located on the bottom surface behind the front door.

43B/097N02308**1.3.13****2A8/097N02291****1.3.14****X5K / 497K18750**Circuit
Breaker**1.4.1****MAY / 450S03138**Circuit
Breaker**1.4.2**

1.3.13 The PC UI serial number is located on the rear of the controller.

1.3.14 The EFI™ Controller serial number is located on the rear of the controller.

1.4.0 Location of the Power Switch



Note: The GBC AdvancedPunch Pro (X5K / 497K18750) does not have a power switch. This module only has a circuit breaker.

i Note: The High Capacity Stacker (HCS) (MAY / 450S03138) does not have a power switch. This module only has a circuit breaker.

1.4.2 The HCS circuit breaker is located on the rear left edge of the module.

1.4.1 The GBC Hole Punch circuit breaker is located on the rear bottom edge of the module.

2XL/100S14375 / XiPP120V_F, 4XL/1000S14377

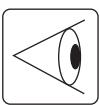


1.5.1

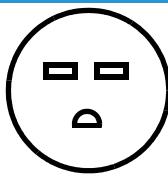
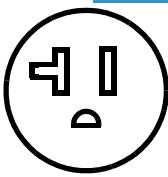
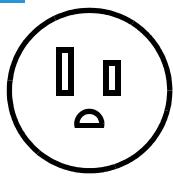


60 Amp 50 Amp
208-240 Volts 220-240 Volts
60 Hz 50 Hz
(WH) (Europe)

B4E / 450S03106, P4X / 450S03107, 7AE/097S04753, X5K / 497K18750, MAY / 450S03138, 7XL / 450S3140,
 2AE / 450S3139, 3AE/097S04749, 4AE/097S04750, 5AE/097S04751, 6AE/097S04752



1.5.2



0.4-6.0 Amp
100-240 Volts
(WH and Europe)

1.5.0 Product Amp Identification



Note: Steps 1.5.1 and 1.5.2 are informational only. The Carrier is not responsible for powering on the Xerox® Iridesse™ Production Press system. Powering up the system is the responsibility of the CSE.

1.5.1 The Xerox® Iridesse™ Production Press Base Configuration is a 60 Amp, 208-240 Volts, 60 Hz machine for the Western Hemisphere and a 50 Amp, 200-240 Volts, 50 Hz machine for Europe.

1.5.2 The accessories are 0.4-6.0 Amp and 100-240 Volt modules.

2

LSP-Configuration Europe Only



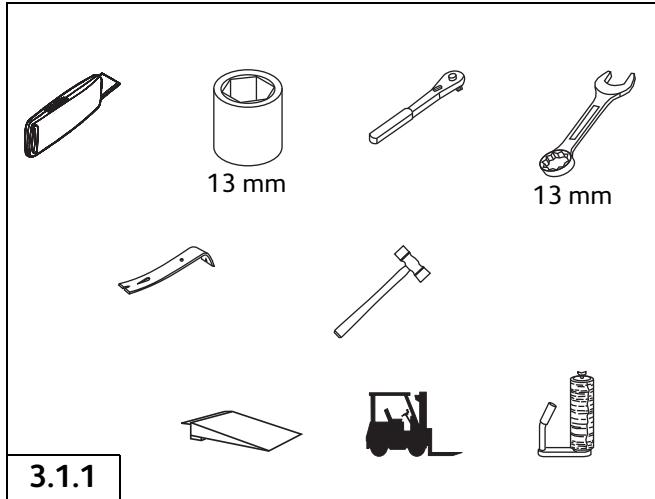
2.0.0 LSP- Configuration Processes



Stop: Because this manual has not been globalized, this section does not apply to the Xerox® Iridesse™ Production Press.
Proceed to Section 3 of this manual.

3

Warehouse



Depalletization Location (US only)

Modules	Product Code	Warehouse	Customer Site
IOT Left*	2XL	Yes	No
IOT Right**	4XL	Yes	No
OHCF	B4E	Yes	No
DAHCF	P4X	Yes	No
Interface Decurler Module	7AE	No	Yes
Interposer Module	OAE	No	Yes
GBC Advanced-Punch Pro	X5K	No	Yes
HCS	MAY	Yes	No
Crease and Two-sided Trimmer	7XL	Yes	No
CZ Folder	2AE	No	Yes
Production Ready Finisher	3AE, 4AE, 5AE	No	Yes
PFIM	XMH	No	Yes
CCU Cart	X0Y	No	Yes
EFI™ NX Premium DFE	2A8	No	Yes

* Includes Eco Box

** Includes Eco Box 2 and miscellaneous boxes

Table 3.2.1

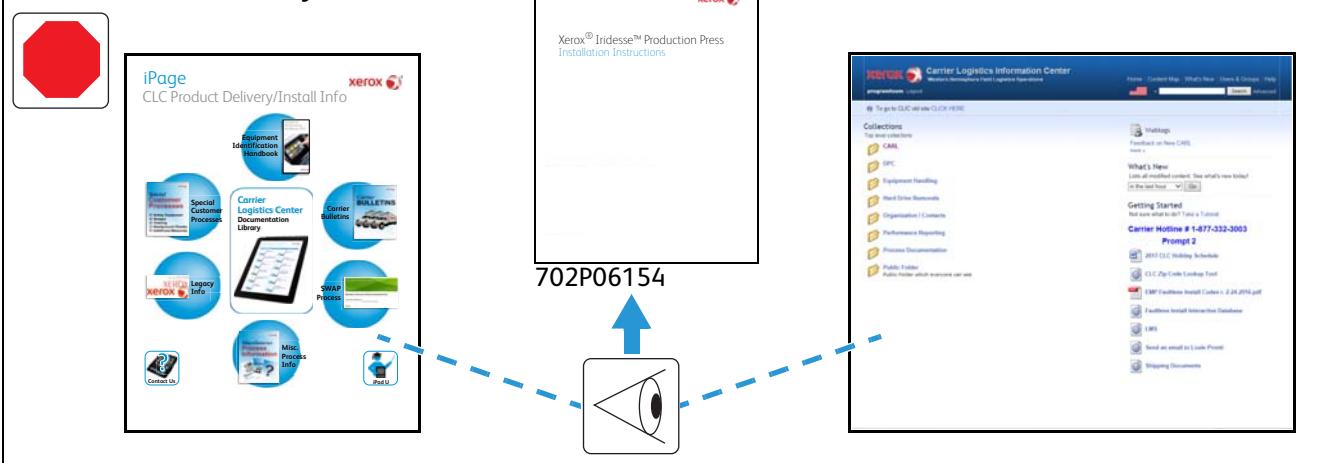
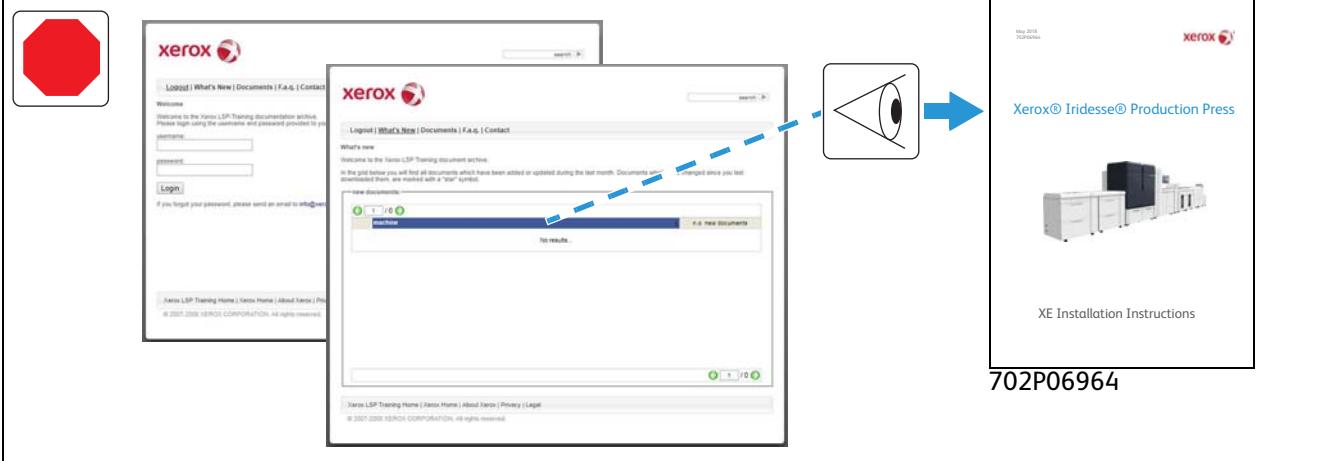
3.0.0 Warehouse

3.1.0 Tools and Materials Required

3.1.1 The tools and materials required to unpack the Xerox® Iridesse™ Production Press are shown.

3.2.0 Location for Depalletization of each Module (US only)

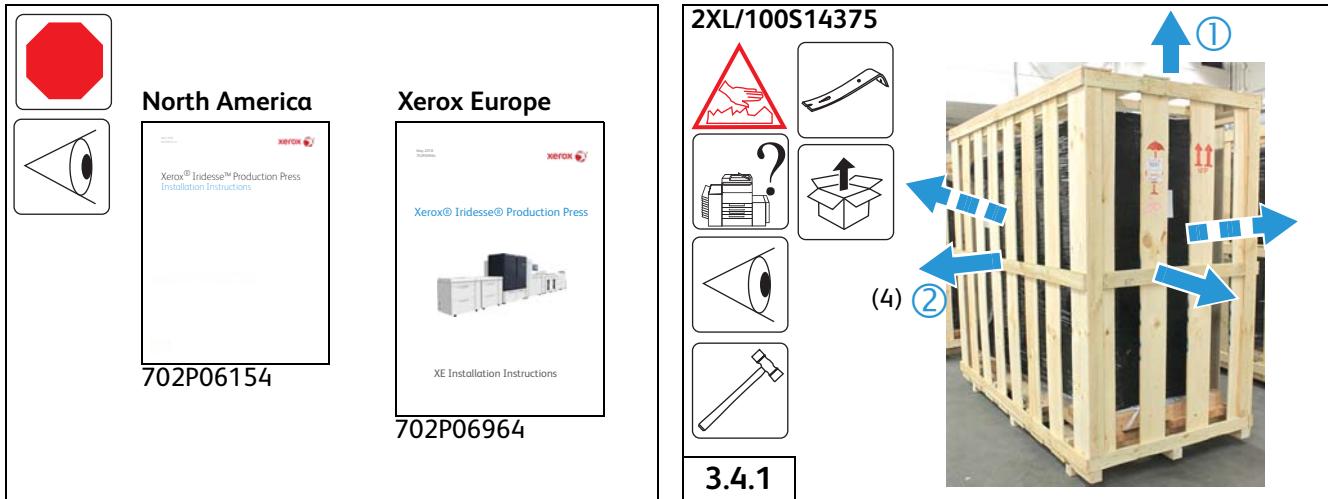
3.2.1 Shown in Table 3.2.1 is a quick look at which modules, if present, are depalletized at the warehouse or at the Customer site.

Xerox North America only:**Xerox Europe only:**

3.3.0 Retrieve the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964)

Stop: Xerox North America only: If required, use the Xerox® Iridesse™ Production Press Install Instructions (702P06154) that can be found on iPage and the CLIC website (<https://carrierlogistics.external.xerox.com/docushare/dsweb/HomePage>), along with the procedures documented within this manual to unpack and depalletize all appropriate modules and optional accessories indicated within Table 3.2.1 on page 3-2.

Stop: Xerox Europe only: If required, use the Xerox® Iridesse™ Production Press Install Instructions (702P06964) that can be found on the LSP Training website (www.xerox-lsptraining.com), along with the procedures documented within this manual to unpack and depalletize all appropriate modules and optional accessories.



Stop: Both here and after, when the Xerox® Iridesse™ Production Press Installation Instructions are mentioned / referenced throughout this document, the part numbers and document covers for the North America and Xerox Europe Installation Instructions are different. Even though both cover may not be shown, both the part numbers will be. The North American version has a part number of 702P06154 and the Xerox Europe version has a part number of 702P06964. These procedures will only be available electronically. Be sure to check the appropriate website for the correct Xerox® Iridesse™ Production Press Installation Instructions.

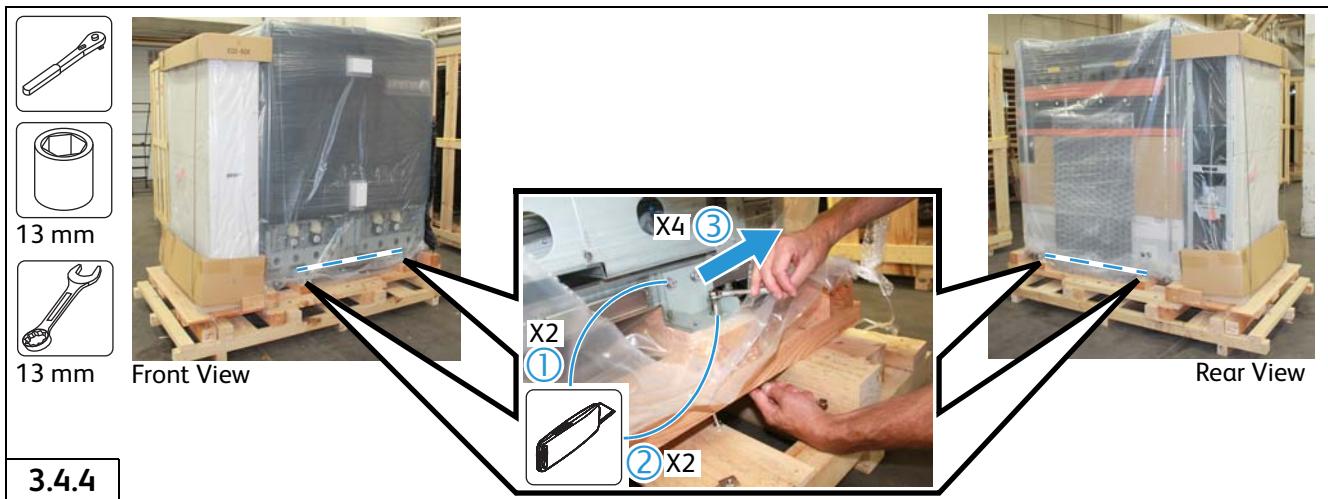
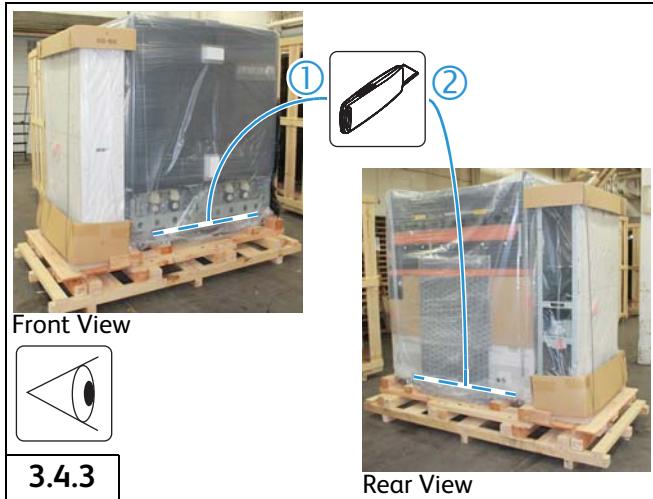
3.4.0 Unpack and Depalletize the Printer Left Module (2XL/100S14375 / XiPP120V_F)



WARNING: Extra care needs to be taken when the IOT Left module is uncrated. Nails and metal brackets can cause personal injury.

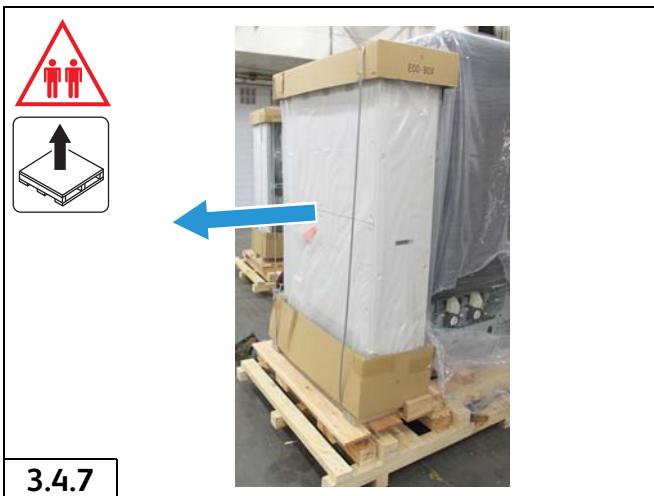
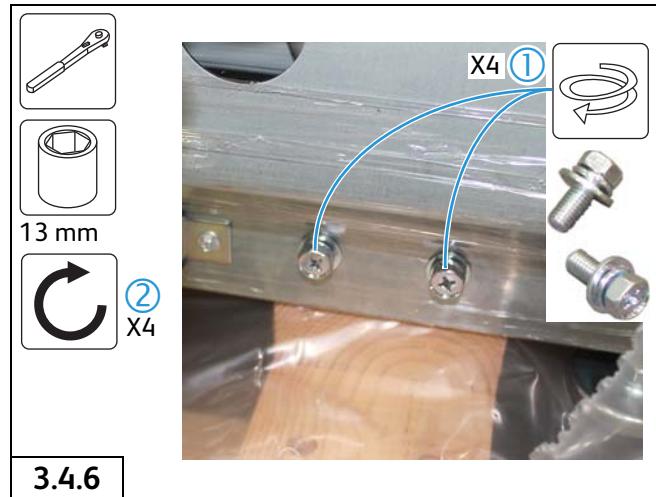
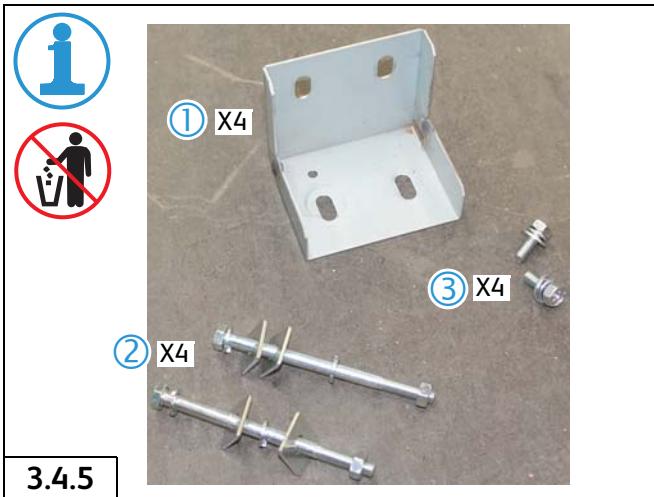
3.4.1 If a crate is present, use a crowbar and hammer ① to carefully remove the crate top and ② the four walls from around the palletized IOT Left module and Eco Box.

3.4.2 Cut and remove the stretchwrap from around the palletized IOT Left module and Eco Box.



3.4.3 ① Cut an opening along the front and
② rear bottom edge of the bag around the palletized IOT Left module and Eco Box.

3.4.4 ① Use a 13 mm socket and wrench to remove the bolts, two per bracket, securing the shipping brackets to the base of the printer. Then,
② remove the nuts from the bolts, two per bracket, that secure the shipping bracket to the pallet. ③ Remove the shipping brackets (4).



Note: The bolts that secure the shipping brackets to the pallet may remain captured within the pallet due to the length.

3.4.5 ① Do not discard the four brackets, ② eight long bolts / hardware and eight ③ bolts.

3.4.6 ① Re-install and ② tighten the eight bolts back into the original holes within the bottom frame of the IOT Left module.



WARNING: Due to the size and weight of the packaged Eco Box, two people are required to depalletize this module.

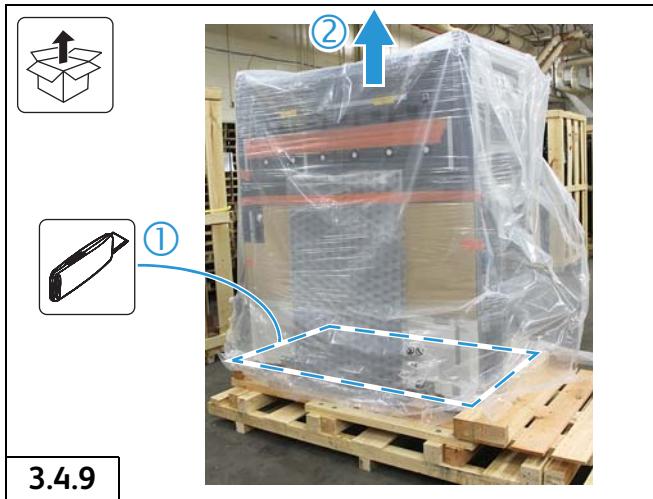
3.4.7 Use two people to lift and remove the

packed Eco Box from the left side of the IOT Left pallet.

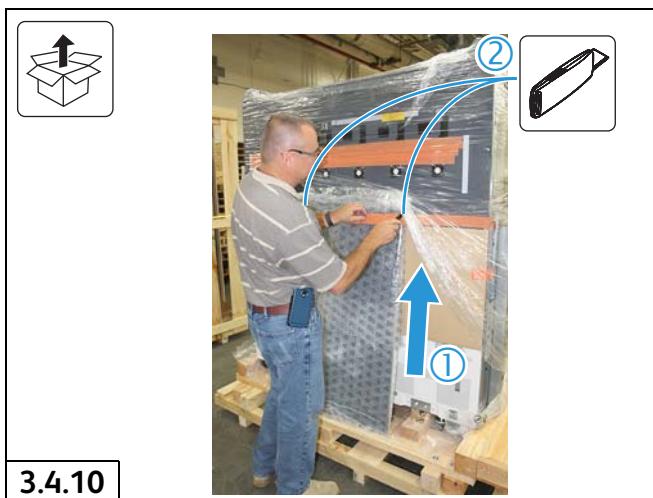
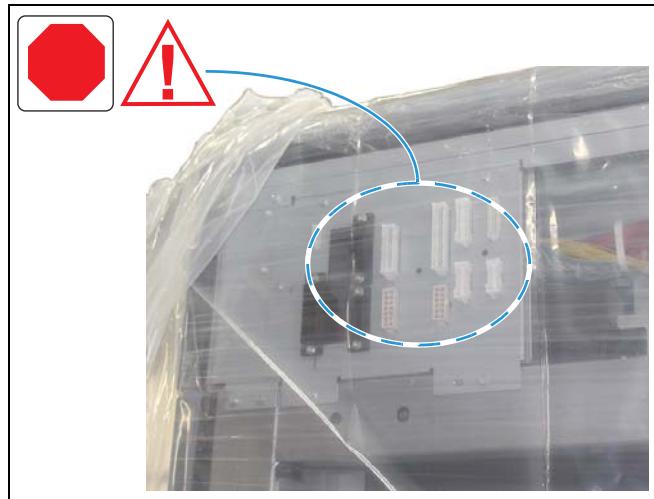


WARNING: Due to the size and weight of the packaged Eco Box, two people are required to move this module.

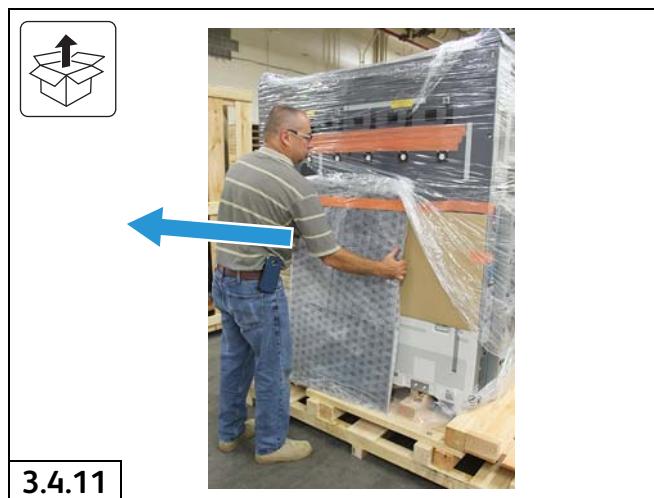
3.4.8 Set the packaged Eco Box aside.



3.4.9



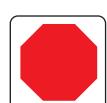
3.4.10



3.4.11

3.4.9 ① Cut the base of the bag around the IOT Left module and ② remove the bag from over the module.

3.4.11 Remove the bubblepacked panels from the rear of the palletized IOT Left module.

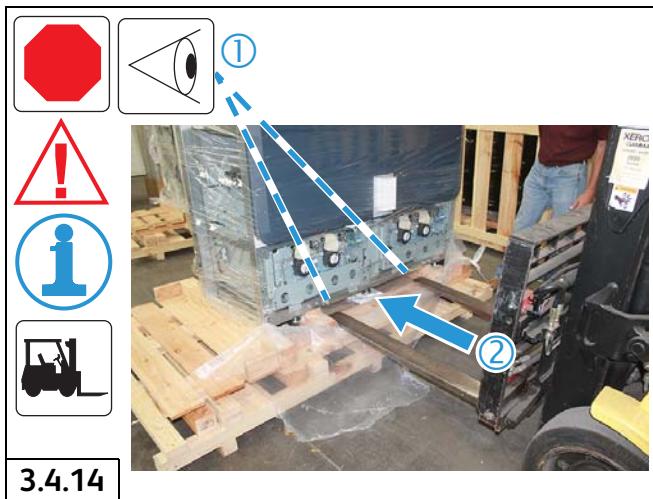
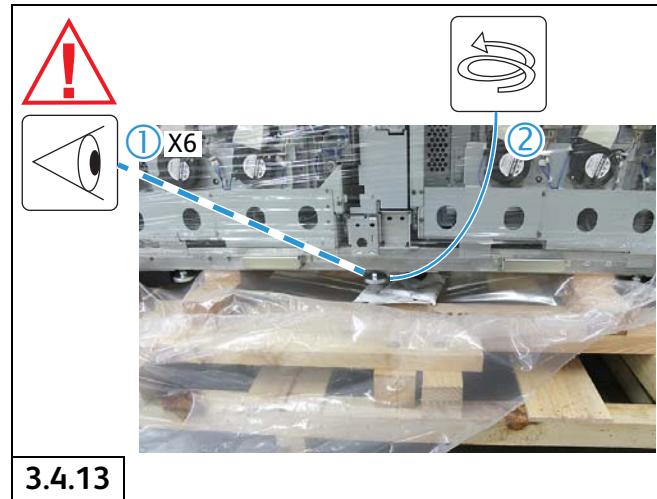
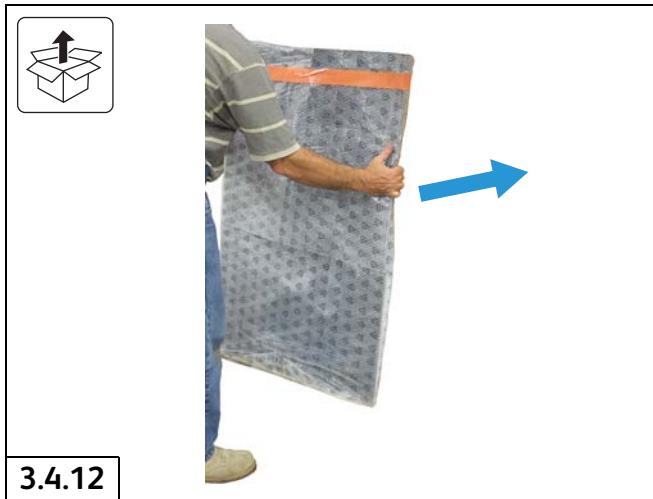


Stop: Take note of the connectors on the right side top front edge of the module.



CAUTION: Extra care needs to be taken when handling the IOT Left module. Connectors located on the right side top front edge of the module can be very easily damaged.

3.4.10 ① Lift the stretchwrap on the rear of the printer and ② cut the tape on the left and right sides of the bubblepack panels.

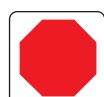


3.4.12 Set the bubblepacked panels aside.



CAUTION: If stabilizing feet are not up and out of the way prior to depalletizing or moving the IOT Left module, damage to the feet can occur.

3.4.13 Prior to depalletizing the IOT Left module, ① check the three stabilizing feet in the front and the three in the rear of the module to ensure they have not rotated down during transit. If so, ② raise them back up hand-tight to the bottom frame member.



Stop: Ensure the forks are placed under the IOT Left from the front side of the module.



CAUTION: When the forks are placed under the IOT Left, ensure the forks extend all the way through to the rear of the module.



Note: Take note of the mark on pallet stringer for load center of gravity when items are being removed from the crate and module pallet.

3.4.14 ① Check to see where the stabilizing feet are located and ② then carefully position the forks under the IOT Left module.



3.4.15



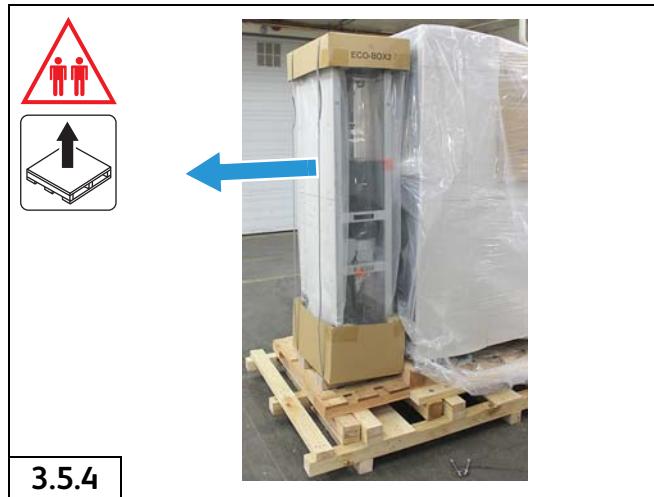
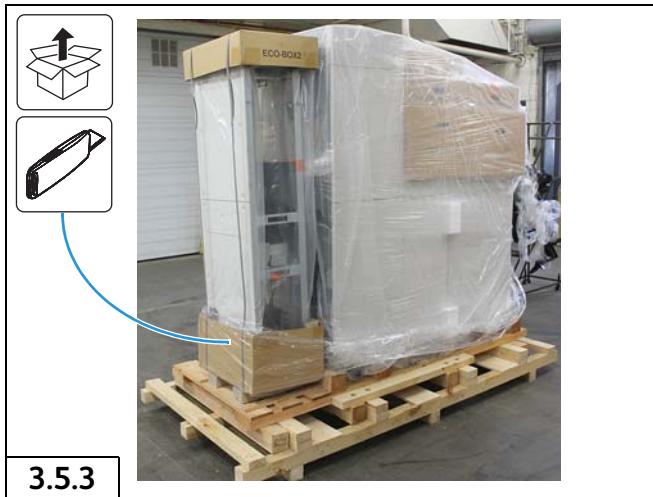
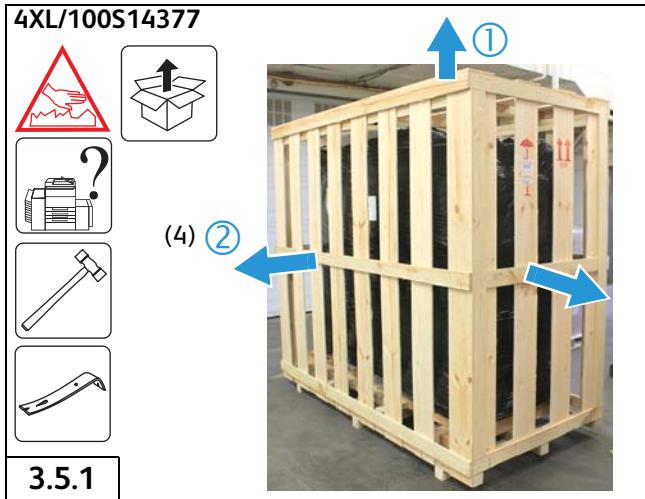
3.4.16



WARNING: A second person is required to stabilize the module as it is being depalletized.

3.4.15 ① Lift and ② remove the IOT Left from the pallet.

3.4.16 ① Place the IOT Left on the floor and
② carefully remove the forks from under the module.



3.5.0 Unpack and Depalletize the IOT Right (4XL/100S14377)



CAUTION: Extra care needs to be taken when the IOT Right module is being uncrated. Nails and sharp metal brackets could cause personal injury.

3.5.1 If a crate is present: use a crowbar and hammer ① to remove the crate top and ② four walls from around the palletized IOT Right module.

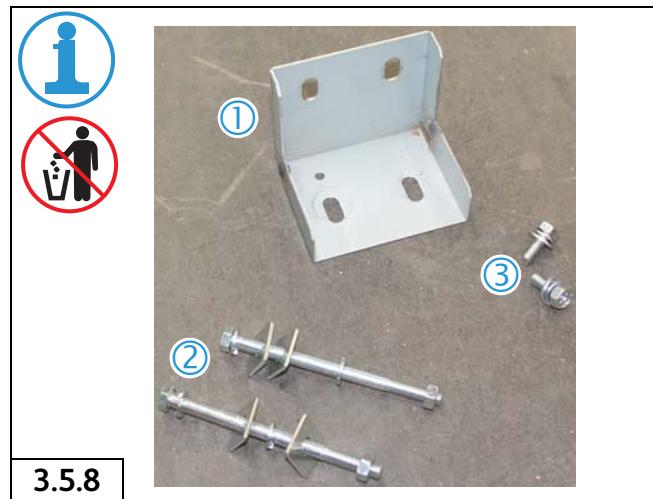
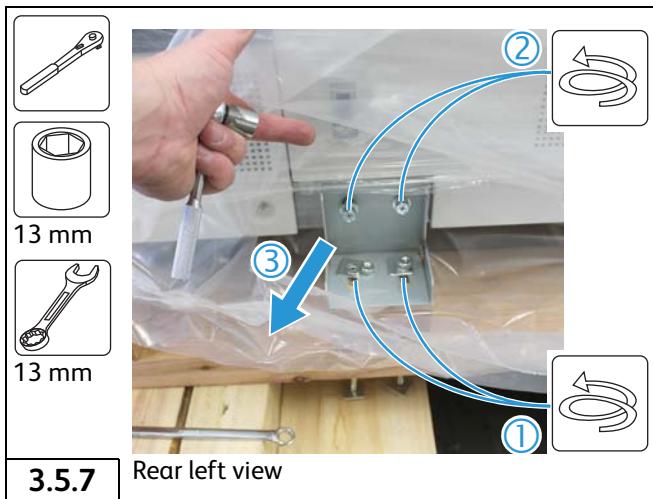
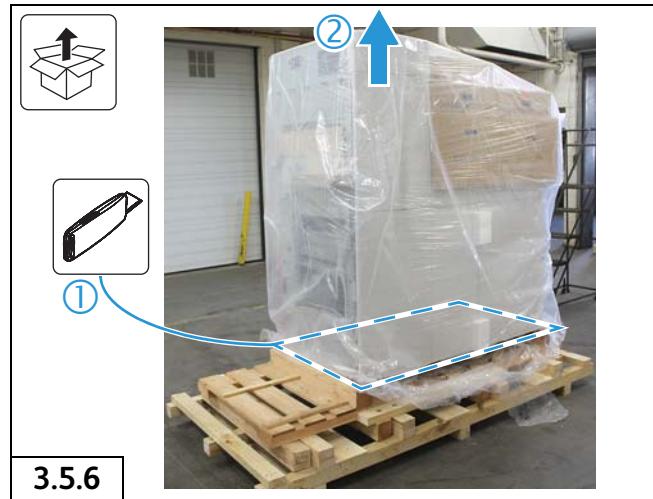
3.5.2 Cut and remove the outer layer of stretchwrap from around the IOT Right module and Eco Box 2.

3.5.3 Cut and remove the inner layer of stretchwrap from around the IOT Right and Eco Box 2 (if present).



WARNING: Due to the size and weight of the packaged Eco Box 2, two people are required to depalletize this module.

3.5.4 Use two people to lift and remove the packed Eco Box 2 from the left side of the IOT Right pallet.



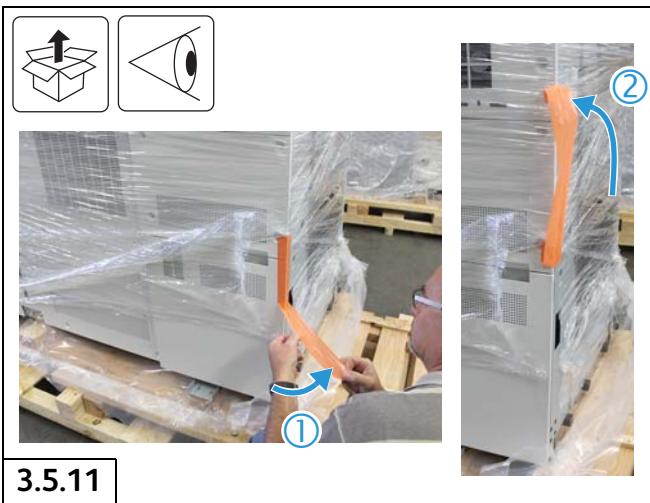
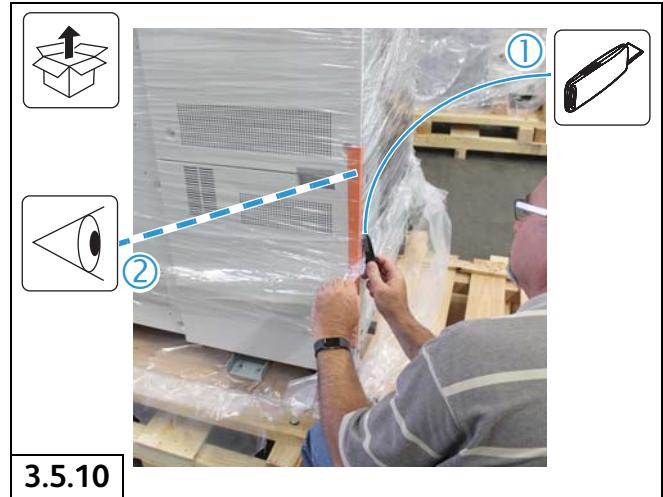
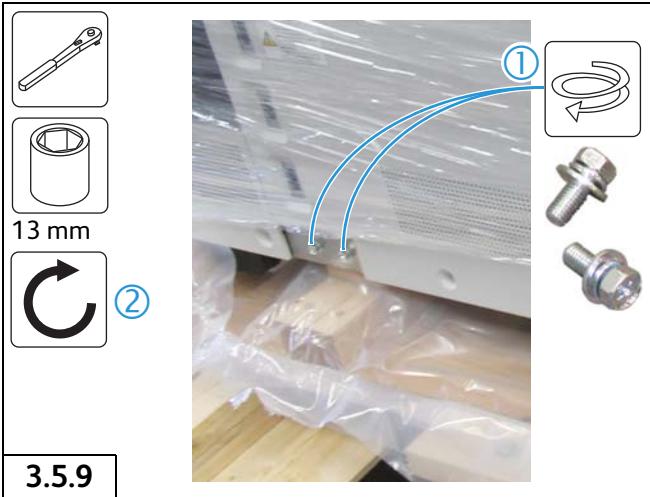
3.5.5 Set the packaged Eco Box 2 aside.

3.5.6 Cut the base of the bag around the IOT Right and remove the bag from over the printer.

3.5.7 ① Use a 13 mm socket and wrench to remove the bolts, two per bracket, that secure the shipping brackets to the base of the printer. Then, ② remove the nuts from the bolts, two per bracket, securing the shipping bracket to the pallet. ③ Remove the shipping bracket from the rear left corner of the printer.



Note: The bolts that secure the shipping brackets to the pallet can remain captured within the pallet.

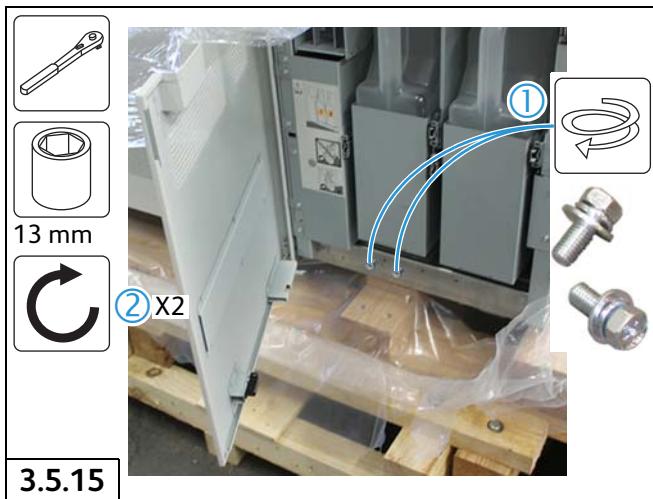
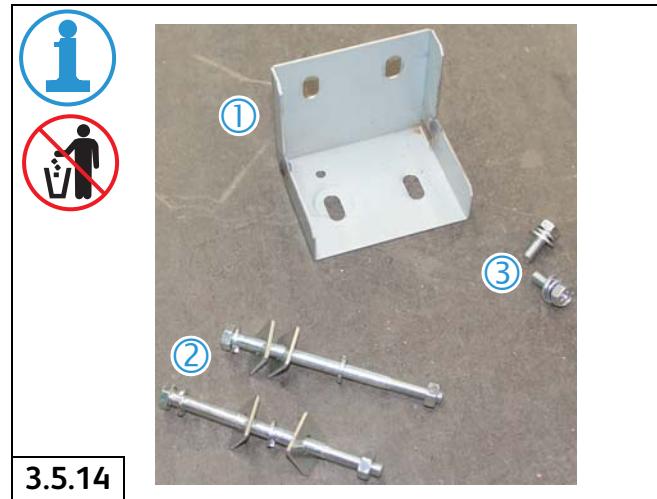
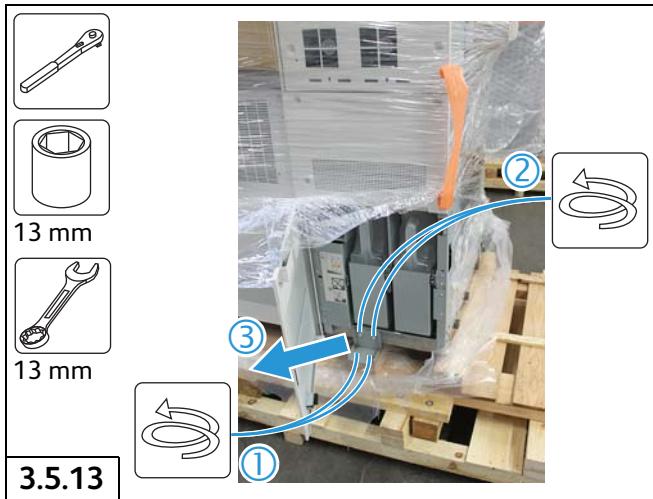


3.5.9 ① Re-install two of the short bolts back into the original holes in the rear left bottom frame of the IOT Right module. ② Then tighten the two bolts.

3.5.10 ① Carefully cut the stretchwrap up the rear right cover of the IOT Right to ② just above the rear right cover.

3.5.11 ① Loosen the tape in the rear right corner and ② secure the tape up and out of the way of the rear right cover.

3.5.12 Open the rear bottom right cover.



3.5.13 Use a 13 mm wrench and socket to ① remove the two nuts from the bolts securing the shipping bracket to the pallet and ② the two bolts securing the shipping bracket to the IOT Right module. ③ Remove the bracket from the rear bottom right frame of the IOT.



Note: The bolts that secure the shipping brackets to the pallet can remain captured within the pallet.

3.5.14 ① Do not discard the four brackets, ② the eight long bolts with hardware or ③ the eight short bolts.

3.5.15 ① Re-install and ② tighten the two bolts back into their original holes within the rear right bottom frame of the IOT.

3.5.16 Close the rear bottom right cover on the IOT.



3.5.17



3.5.18



3.5.19



3.5.20



3.5.17 ① Loosen the tape and ② re-position it on the rear bottom right edge of the IOT Right so the cover is secured.

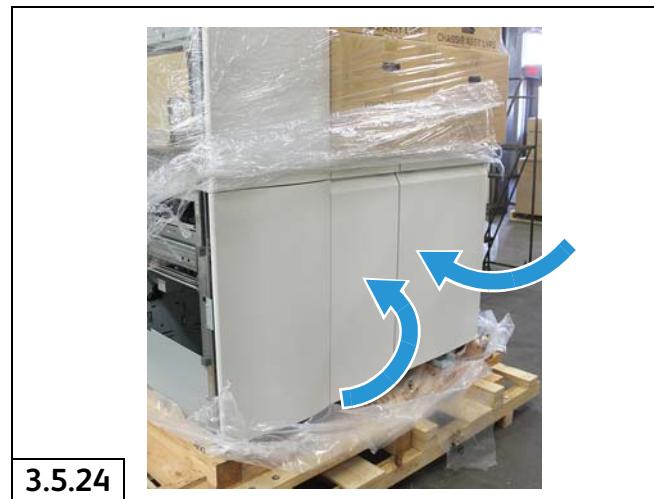
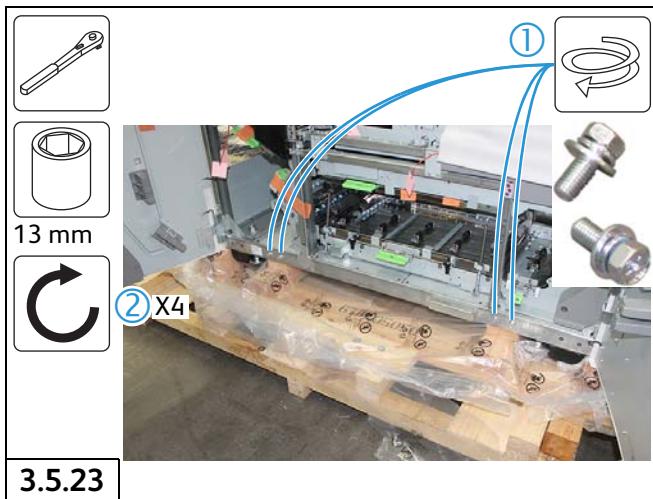
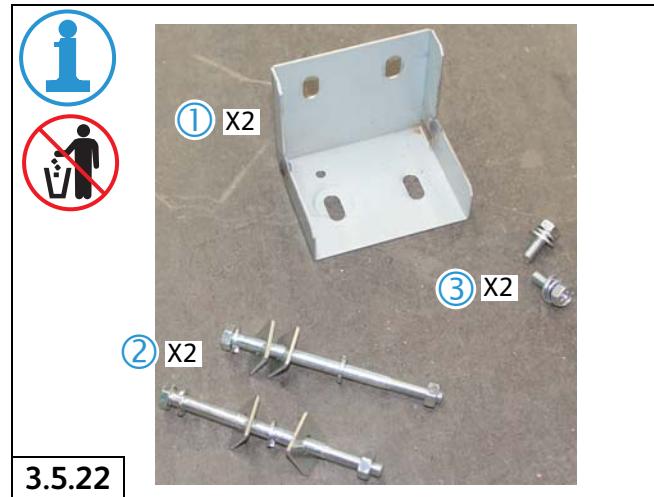
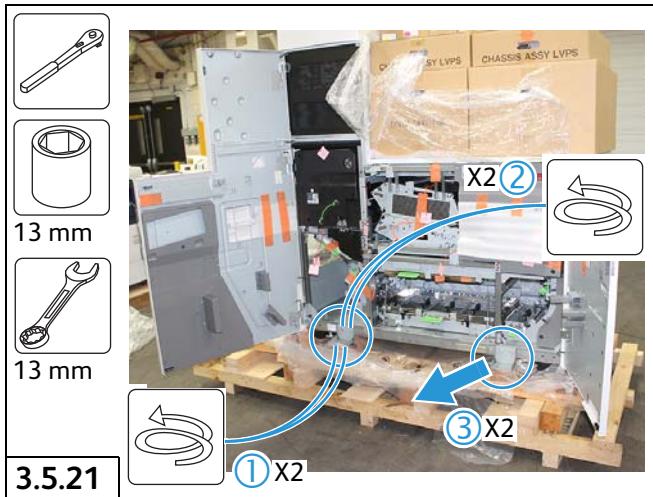
3.5.18 ① Cut the stretchwrap up the two front corners of the IOT Right and ② lift the stretchwrap.



Note: Do not discard the two foam blocks. The two foam blocks will need to be reinstalled prior to the module being shipped to the Customer location.

3.5.19 ① Remove the two foam blocks from between the two front covers, ② then set them aside so they can be reinstalled later in the process.

3.5.20 Open the front covers of the IOT Right module.



3.5.21 Use a 13 mm wrench and socket to
 ① remove the two nuts from the bolts that secure
 the two shipping brackets on the front of the
 printer to the pallet and ② the two bolts that
 secure the two shipping bracket to the printer.
 ③ Remove the brackets from the front bottom
 right and left frame of the printer.

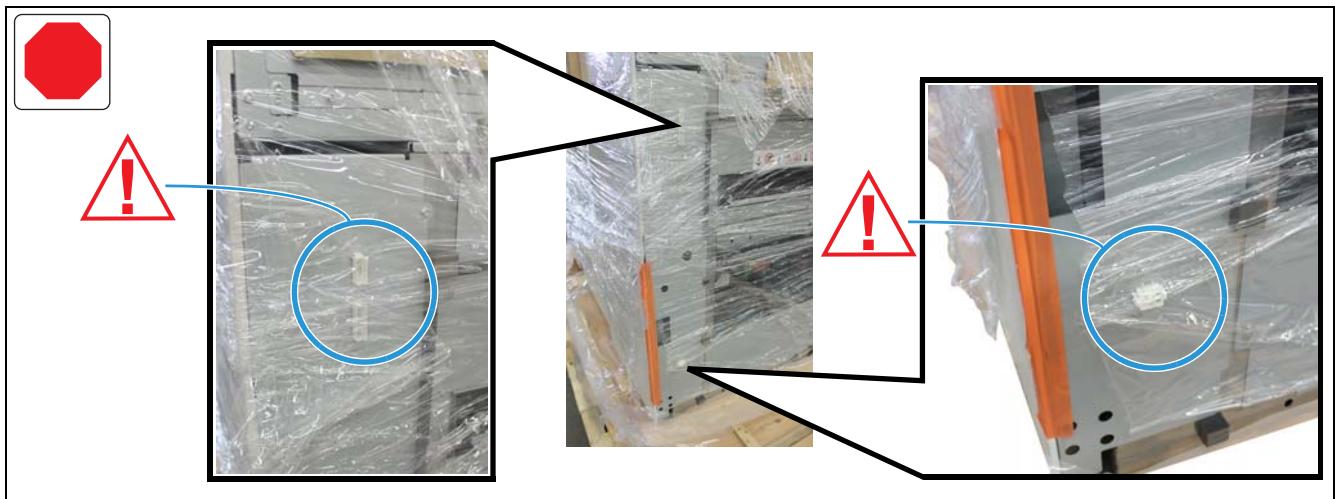


Note: The bolts securing the shipping
 brackets to the pallet can remain cap-
 tured within the pallet.

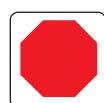
3.5.22 ① Do not discard the four brackets, ② the
 eight long bolts with hardware or ③ the eight
 short bolts.

3.5.23 ① Re-install and ② tighten the two bolts
 back into the original holes within the rear right
 bottom frame of the printer.

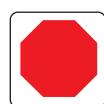
3.5.24 Close the IOT Right front covers.



3.5.25 Re-position the cut stretchwrap over the front of the IOT Right module.



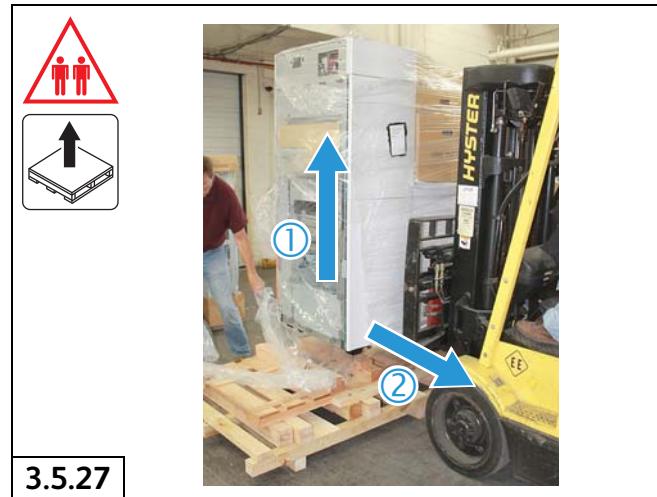
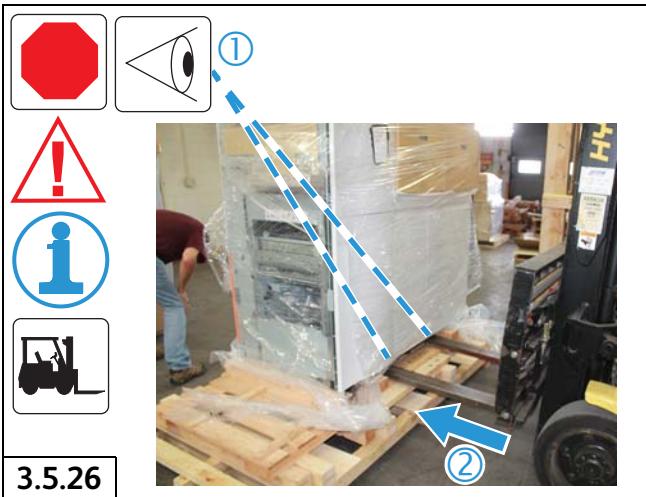
Stop: When handling the IOT Right module, extra care is required so damage to the connectors located on the left side of the module does not occur.



Stop: Take note of the connectors on the left side rear edge of the module.



CAUTION: Extra care needs to be taken when handling the IOT Right module. Connectors located on the left side rear edge of the module can be very easily damaged.



3.5.28



Stop: Place the forks under the front side of the IOT Right module to depalletize.



CAUTION: When placing the forks under the IOT Right module to be depalletized, ensure the forks extend all the way through to the rear of the module.



Note: Take note of the mark on pallet stringer for load center of gravity when items are being removed from pallet.

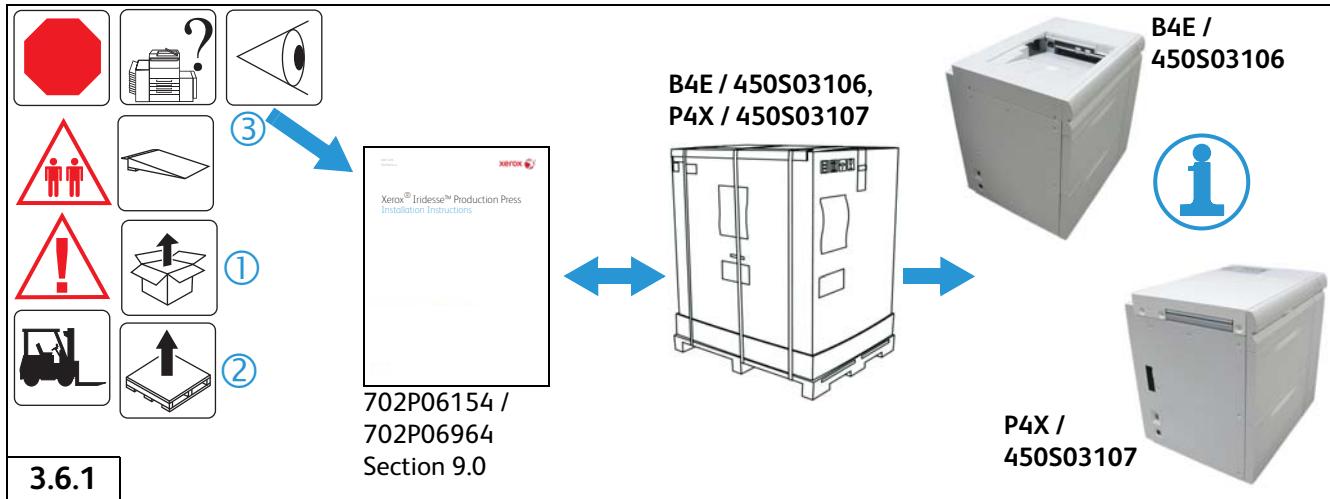
3.5.26 ① Check to see where stabilizing feet are located, ② then carefully position the forks under the printer.



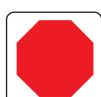
WARNING: A second person is required to stabilize the IOT Right as it is being depalletized.

3.5.27 ① Lift and ② remove the IOT Right from the pallet.

3.5.28 ① Place the IOT Right on the floor and ② carefully remove the forks from under the module.



3.6.0 Unpack and Depalletize the Oversize High Capacity Feeder (OHCF) (B4E / 450S03106) and Dual Advanced Oversize High Capacity Feeder (DAHCF) (P4X / 450S03107) (if present)



Stop: Depalletize the OHCF / DAHCF, using either a ramp or forklift.



WARNING: Due to the size and weight of the OHCF / DAHCF, two people are required to depalletize these modules.

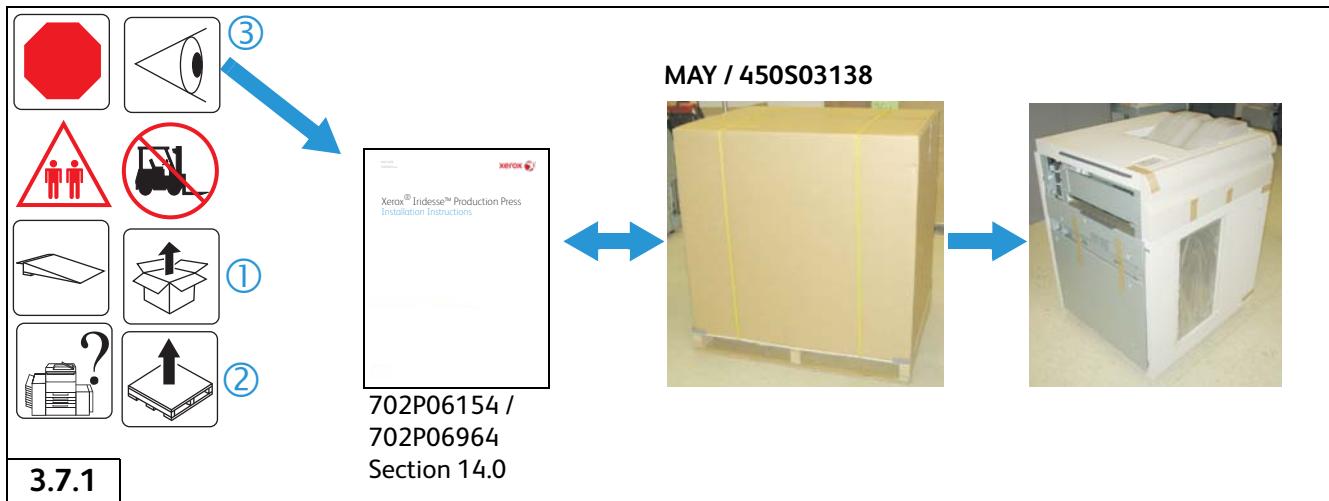


CAUTION: If a forklift is being used to depalletize the OHCF / DAHCF, check for location of casters under the modules before positioning forks.

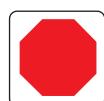


Note: Do not remove the taped items from inside the right cavity of the OHCF / DAHCF.

3.6.1 ① Unpack and ② depalletize the OHCF / DAHCF ③ using Section 9.0 in the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964).



3.7.0 Unpack and Depalletize the High Capacity Stacker (HCS) (MAY / 450S03138) (if present)



Stop: When HCS is depalletized, only a ramp can be used. **Do not** use a forklift to remove the HCS from the pallet. Damage to the HCS will occur.

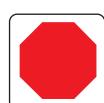


WARNING: Due to the size and weight of the HCS, two people are required to depalletize the HCS.

3.7.1 ① Unpack and ② depalletize the HCS
③ using Section 14.0 in the Xerox® Iridesse™ Production Press Installation Instructions
(702P06154 / 702P06964).



3.8.0 Unpack and Depalletize the Crease and Two-sided Trimmer (7XL / 450S03153) (if present)



Stop: When Crease and Two-sided Trimmer is depalletized, only a ramp can be used. **Do not** use a forklift to remove the Crease and Two-sided Trimmer from the pallet.



WARNING: Due to the size and weight of the Crease and Two-side Trimmer, two people are required to depalletize the Trimmer.

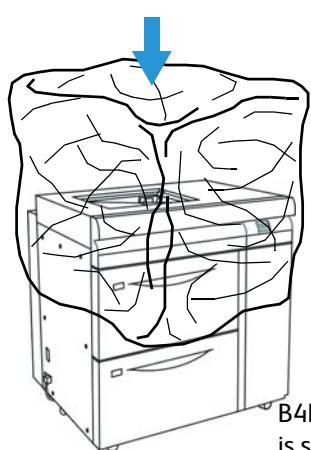
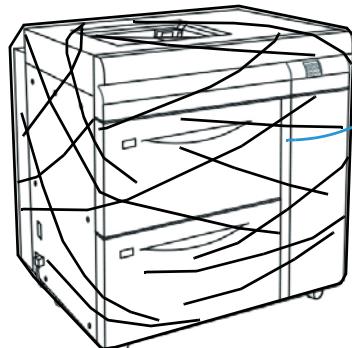
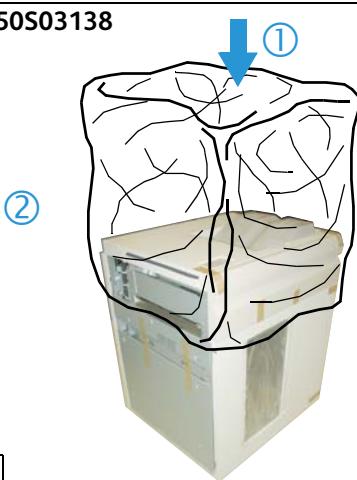
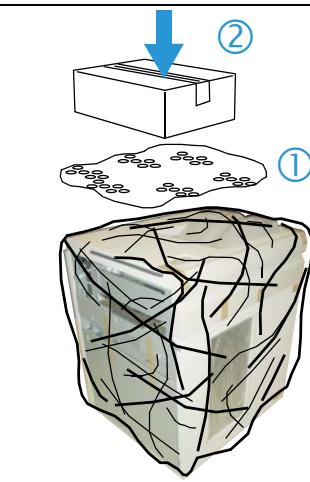
3.8.1 ① Unpack and ② depalletize the Crease and Two-side Trimmer ③ using Section 16.0 in the Xerox® Iridesse™ Production Press Install Instruc-

tions (702P06154 / 702P06964) and the Xerox® Crease and Two-sided Trimmer Installation Instructions (607E23330).

3.9.0 Prepare the Modules for the Move to the Customer Location

3.9.1 ① Retrieve the bubblepacked panels set aside earlier and ② place them on top of the IOT Left. ③ Secure the panels in place with a layer of stretchwrap.

3.9.2 ① Retrieve the foam blocks set aside earlier. ② Lift stretchwrap in the front of the IOT Right module and ③ re-install the two foam blocks between the two front covers. ④ Then secure the lower portion of the IOT Right with a layer of stretchwrap.

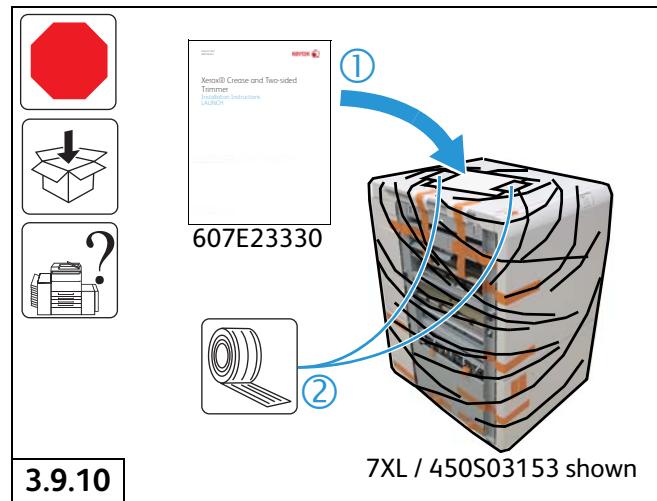
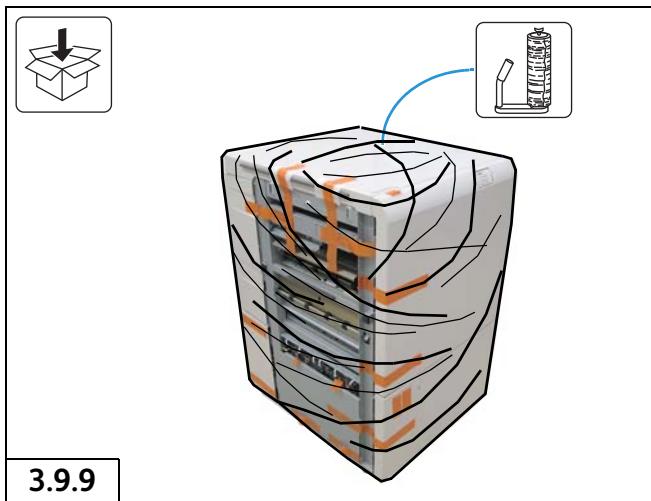
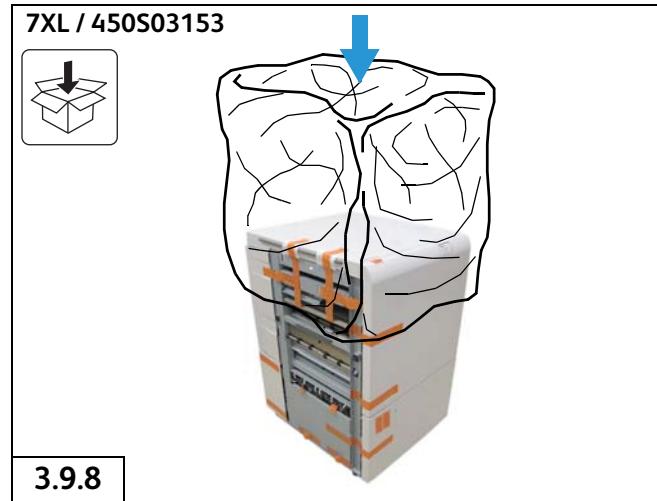
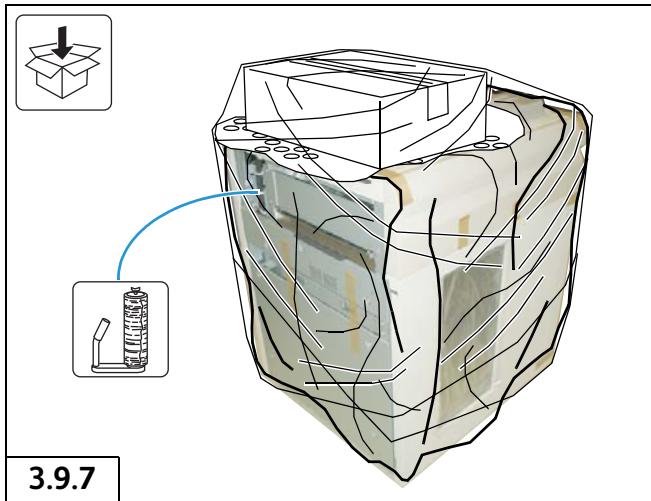
B4E / 450S03106, P4X / 450S03107**3.9.3**B4E / 450S03106
is shown**B4E / 450S03106, P4X / 450S03107****3.9.4****MAY / 450S03138****3.9.5****3.9.6**

3.9.3 ① Reinstall the shroud over the OHCF / DAHCF and ② then secure with stretchwrap.

3.9.4 Secure the OHCF / DAHCF with a layer of stretchwrap.

3.9.5 ① Reinstall the shroud over the HCS and ② secure the module with a layer of stretchwrap.

3.9.6 ① Place a layer of bubblepack and ② the boxed dolly on top of the HCS.



3.9.7 Secure the boxed dolly to the top of the HCS with stretchwrap.

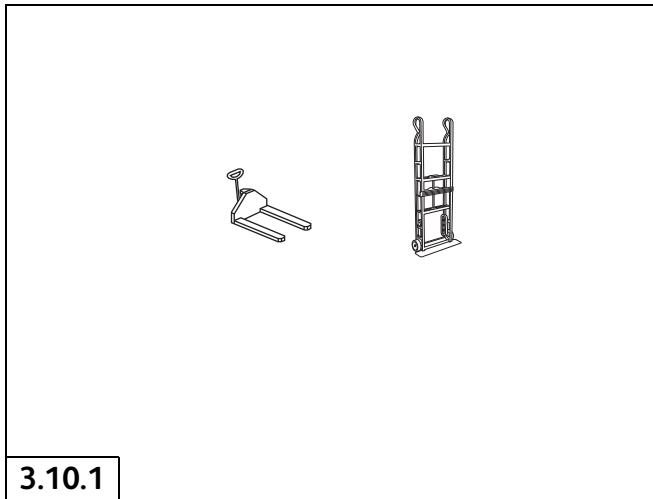
3.9.8 Reinstall the shroud over the Crease and Two-sided Trimmer.

3.9.9 Secure the Crease and Two-Side Trimmer module with a layer of stretchwrap.

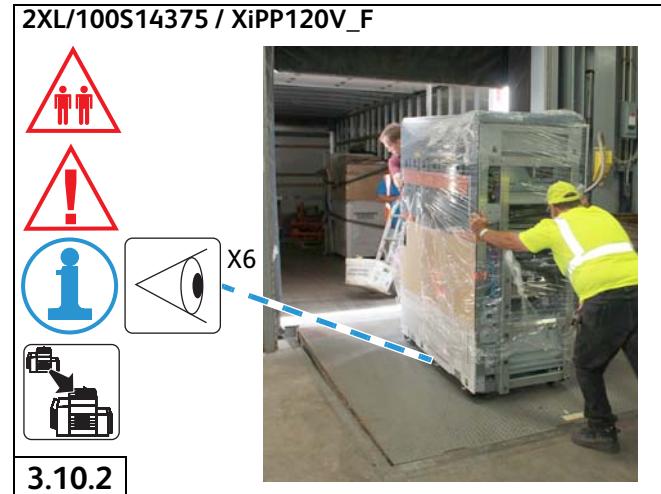


Stop: Upon the completion of the unpack, depalletization and assembly of the appropriate modules at the warehouse, it is important that all the accessory module installation instructions are packed back up with the appropriate module. This will guarantee that they will be available for use at the Customer location.

3.9.10 ① Place individual accessory installation instructions used at the warehouse on top of the appropriate module, then ② tape them in place so that they get transported to the Customer location with the module.



3.10.1



3.10.2

3.10.0 Move the Modules to the Truck for Delivery

3.10.1 The tools required for moving the modules to the truck for delivery are shown.



WARNING: Due to the weight and size of the IOT Left module, two people are required to move the module.



CAUTION: When moving the IOT Left module, push on the corner frame members only. Do not push on any covers or internal components as damage to the module can occur.



Note: Prior to moving the IOT Left module, check to ensure the six stabilizing pads are up against the frame of the module.

3.10.2 Use two people to move the IOT Left module on to the truck.

4XL/100S14377



3.10.3



3.10.4



3.10.5



WARNING: Due to the weight and size of the IOT Right module, two people are required to move the module.



CAUTION: When moving the IOT Right module, push on the corner frame members only. Do not push on any covers or internal components as damage to the module can occur.

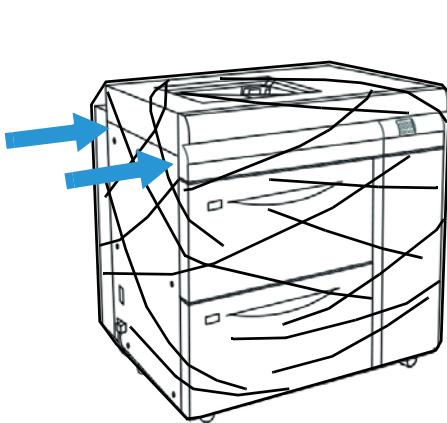
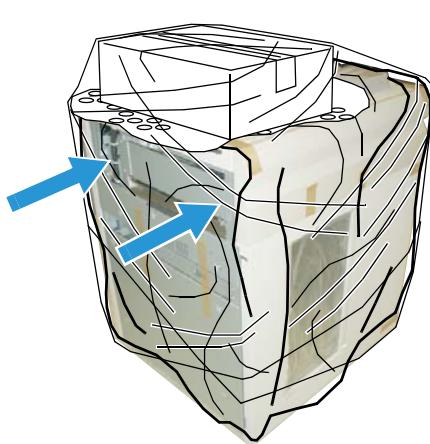


Note: Prior to moving the IOT Right, check to ensure the stabilizing pads are up against the frame of the module.

3.10.3 Use two people to move the IOT Right module on to the truck.

3.10.4 Use an appliance dolly to move the Eco Box to the truck.

3.10.5 Use an appliance dolly to move the Eco Box 2 to the truck.

B4E / 450S03106, P4X / 450S03107**3.10.6****MAY / 450S03138****3.10.7**

WARNING: Due to the weight and size of the OHCF or DAHCF, two people are required to move the module.



CAUTION: When moving the OHCF or the DAHCF module, push on corner frame members only. Do not push on any covers or internal components as damage to the module can occur.

3.10.6 Use two people to move the OHCF / DAHCF to the truck.



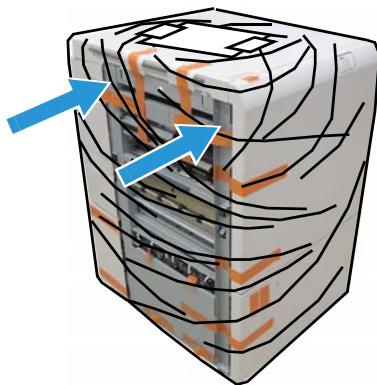
WARNING: Due to the weight and size of the HCS, two people are required to move the module.



CAUTION: When moving the HCS module(s), push on corner frame members only. Do not push on any covers or internal components as damage to the module cab occur.

3.10.7 Use two people to move the HCS to the truck.

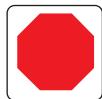
7XL / 450S03153



3.10.8



3.10.9



(674K01892)

3.11.1



Stop: All remaining modules and kits are to be moved to the truck fully packaged.



WARNING: Due to the weight and size of the Crease and Two-side Trimmer, two people are required to move the module.



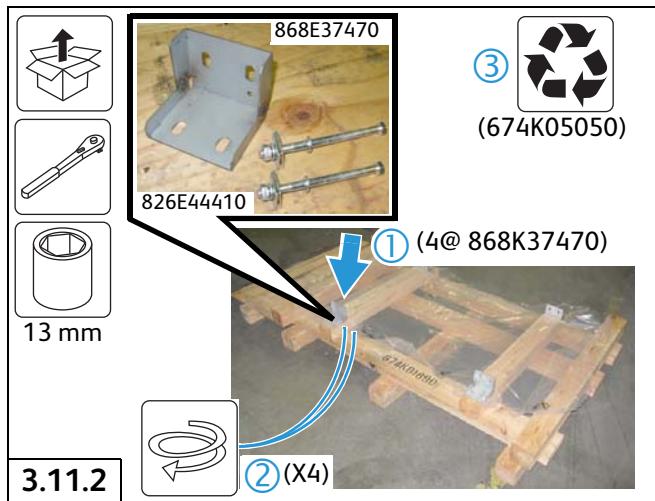
CAUTION: When moving the Crease and Two-side Trimmer, push on corner frame members only. Do not push on any covers or internal components as damage to the module can occur.

3.11.0 Recycle the Pallets and Hardware

3.11.1 ① Reinstall the four shipping brackets (868E37470) on the IOT Left module pallet (674K01892). ② Secure them in place with two 13 mm bolts (826E44410) in each bracket.
③ Recycle the pallet and hardware.

3.10.8 Use two people to move the Crease and Two-side Trimmer to the truck.

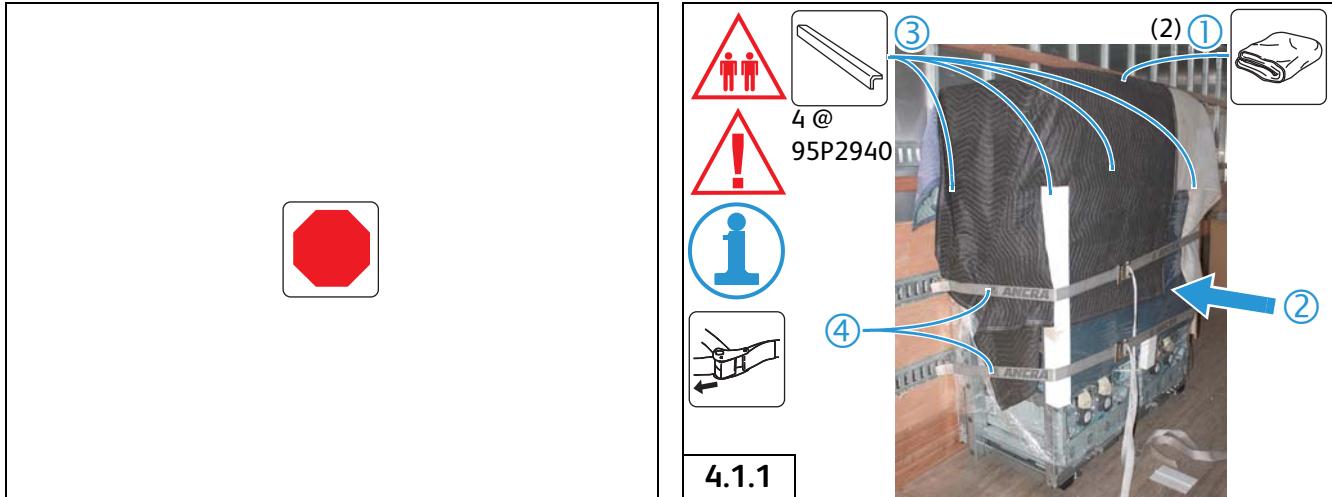
3.10.9 Use a pallet jack to move any palletized modules or kits to the truck.



3.11.2 ① Reinstall the four shipping brackets (868E37470) on the IOT Right module pallet (674K05050). ② Secure them in place with two 13 mm bolts (826E44410) in each bracket.
③ Recycle the pallet and hardware.

4

Delivery



4.0.0 Delivery

 **Stop:** Due to the high point load on the casters of the IOT Left and IOT Right modules, sheets of Masonite could need to be used to traverse tiled or wood flooring to prevent damage to these surfaces at Customer location.

4.1.0 Strapping Procedures

 **WARNING:** Due to the weight and size of the IOT Left module, two people are required when moving the module.

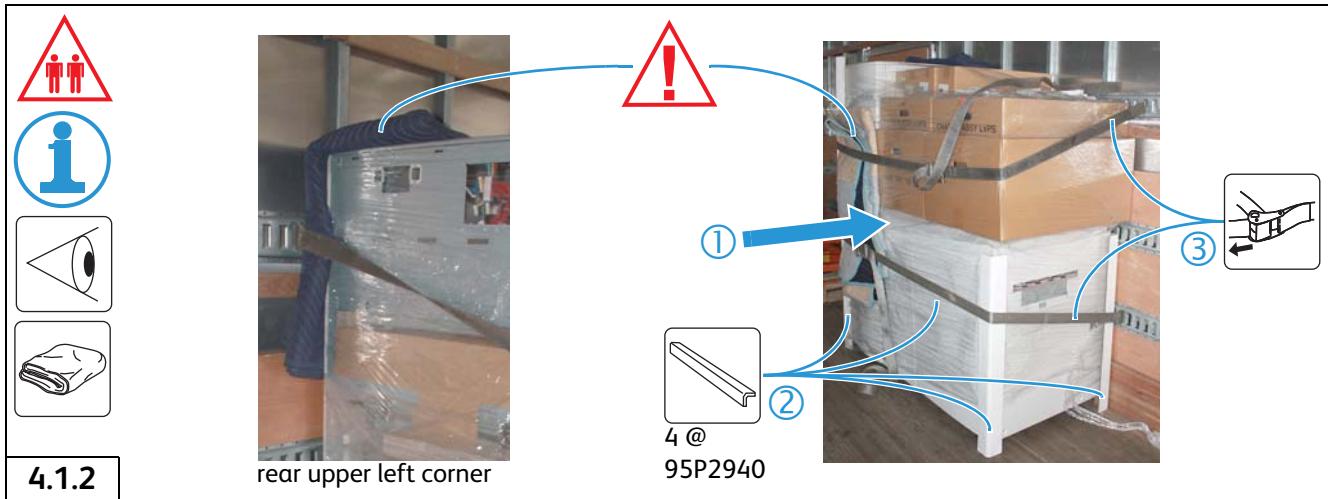
 **CAUTION:** When strapping the IOT Left module into the truck, ensure to secure with two straps, one high and one low.

Ensure not to over tighten the straps when securing into the truck.



Note: When positioning the IOT Left module in the truck, ensure to position the rear of the module against the wall of the truck.

4.1.1 ① Cover the IOT Left module with two blankets and ② position the IOT Left module against the wall of the truck. ③ Position cornerboards on each of the corners and ④ then using two straps secure the IOT Left module into the truck.



4.1.2

rear upper left corner



WARNING: Due to the size and weight of the IOT Right module, two people are required when moving the module.



CAUTION: Prior to positioning the IOT Right module against the wall of the truck, ensure a folded blanket is positioned between the rear upper left corner of the module and the wall of the truck.

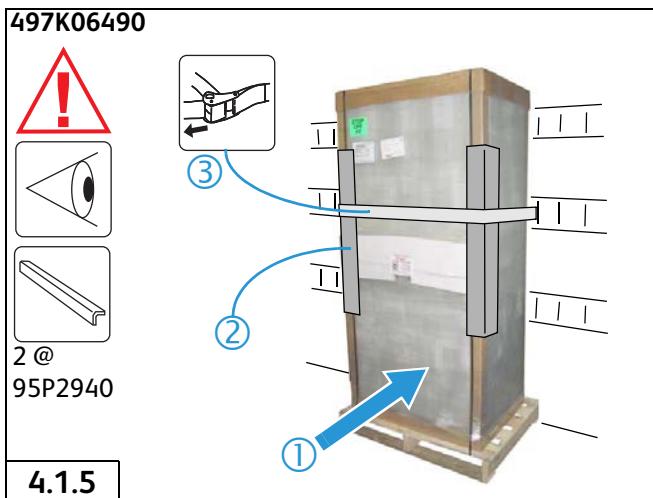
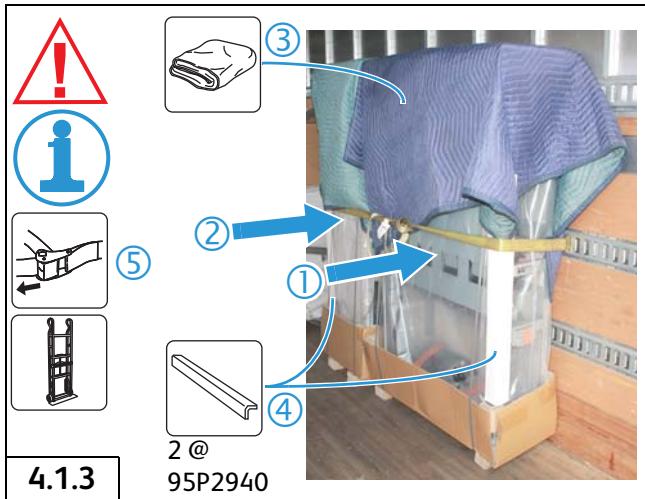


CAUTION: When strapping the IOT Right module in the truck, ensure to position a folded blanket between the front of the module and the straps to keep the strap ratchets from damaging the front covers.



Note: When positioning the IOT Right module on the truck, ensure the rear of the module is positioned against the wall.

4.1.2 ① Position the IOT Right module against the wall of the truck and ② place a cornerboard (95P2940) on each of the four corners. ③ Using two straps, secure the module into the truck.



WARNING: Do not apply too much tension when strapping the Eco Box and Eco Box 2 modules in the truck.



Note: When placing the blanket over the two modules, the blanket should be positioned between the modules and wall of the truck.

4.1.3 ① Position the Eco Box and ② Eco Box 2 against the wall of the truck next to each other. ③ Place a blanket over the two modules. ④ Place a cornerboard (95P2940) on each of the outside corners (2), then ⑤ strap the modules into the truck.

4.1.4 Position the palletized boxed kits on the truck for delivery to the Customer location.



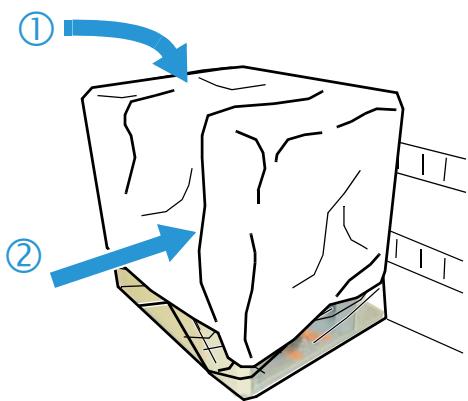
CAUTION: Do not to apply too much tension when strapping the parts cabinet in the truck.

4.1.5 ① Position the packaged Parts Cabinet against the wall of the truck. ② Place a corner-board (95P2940) on the outer corners of cabinet and ③ strap it to the wall of the truck.

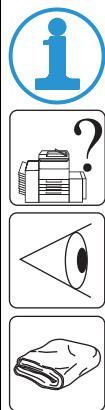
B4E / 450S03106



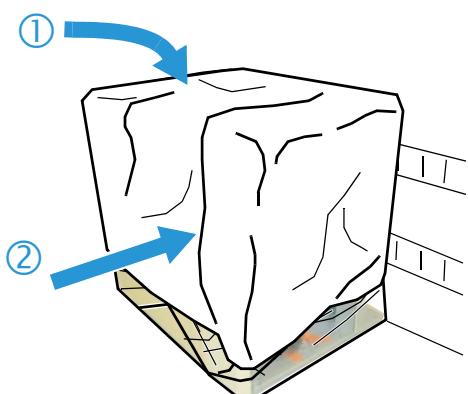
4.1.6



P4X / 450S03107



4.1.8



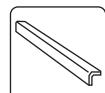
Note: When the OHCF is strapped into the truck, the rear of the module must be placed against the wall of the truck.

4.1.6 ① Cover the OHCF with a folded blanket and ② position the module against the wall of the truck.

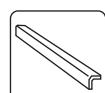
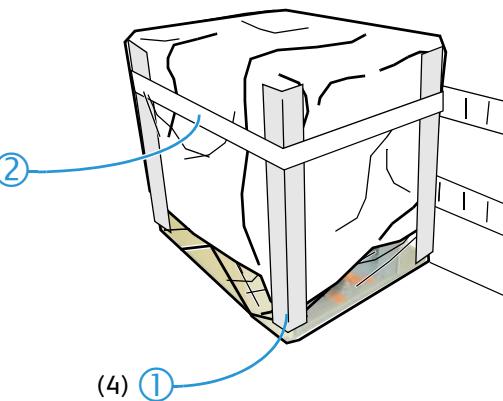
4.1.7 ① Position a cornerboard (95P2940) on each corners and ② strap the OHCF into the truck.



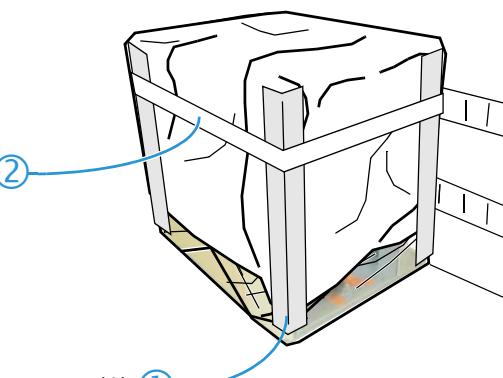
Note: When the DAHCF is strapped into the truck, the rear of the module must be placed against the wall of the truck.

4@
95P2940

4.1.7

4@
95P2940

4.1.9



4.1.8 If a DAHCF is present, ① cover the DAHCF with a folded blanket and ② position the module against the wall of the truck.

4.1.9 ① Position a cornerboard (95P2940) on each corners and ② strap the DAHCF into the truck.

7AE/097S04753



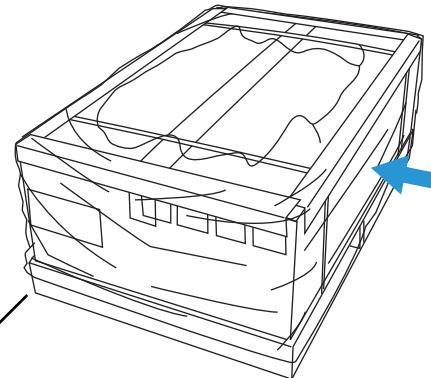
4.1.10



X5K / 497K18750



4.1.11



0AE/097S04746

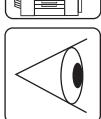


4.1.12

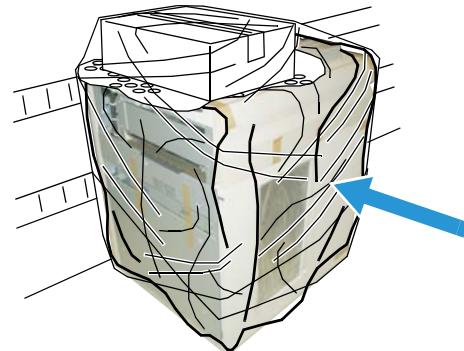
Note: Due to the low profile of the packaged IDM, a strap to secure the module to the wall of the truck should not be necessary.



MAY / 450S3138



4.1.13



4.1.12 If an Interposer Module is present, ① place the packaged module against the wall of the truck and ② strap the module into the truck.



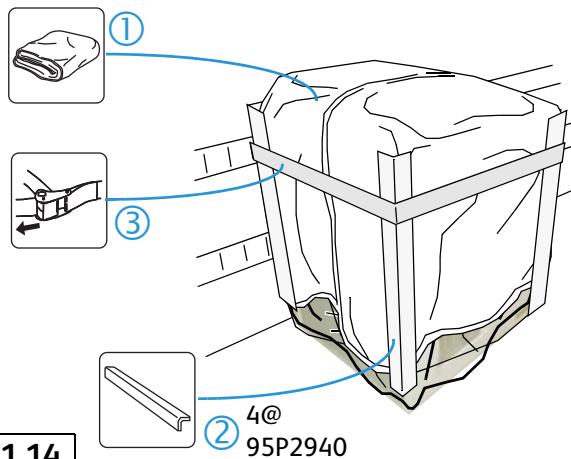
Note: When positioning an HCS in the truck, the rear of the module must be positioned against the wall.

4.1.10 If an IDM is present, place the packaged module against the wall of the truck.

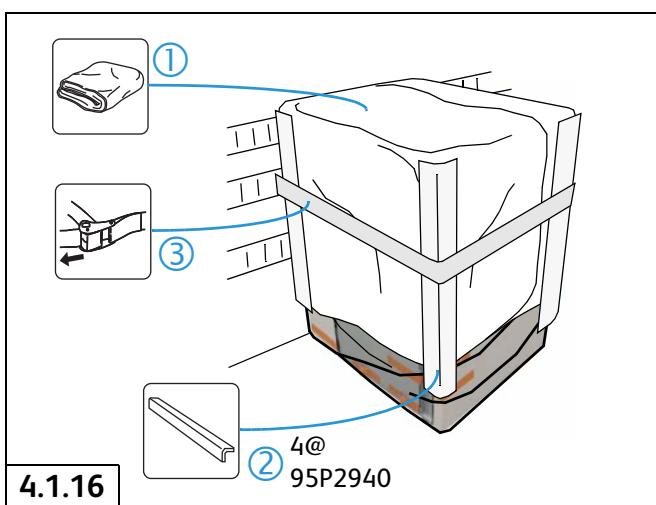
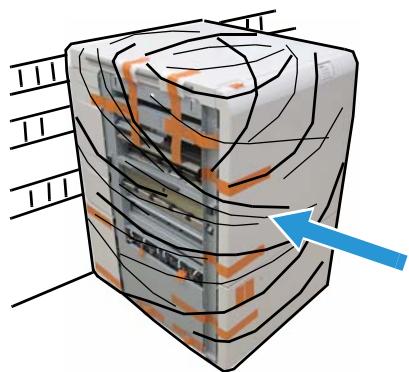
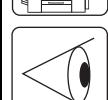
Note: Due to the low profile of the packaged GBC, a strap to secure the module to the wall of the truck should not be necessary.

4.1.11 If a GBC AdvancedPunch Pro is present, place the packaged module against the wall of the truck.

4.1.13 If an HCS is present, position the HCS against the wall of the truck.



1AE/097S04747



2AE / 450S03139

**4.1.17**

4.1.14 ① Cover the HCS with a folded blanket, ② place a cornerboard (95P2940) on each corner and ③ strap the module into the truck.



Note: When positioning the Creaser and Two-sided Trimmer in the truck, the rear of the module must be positioned against the wall.

Note: Due to the low profile of the packaged CZ Folder, a strap to secure the module to the wall of the truck should not be necessary.

4.1.15 If a Creaser and Two-sided Trimmer is present, position the module against the wall of the truck.

4.1.16 ① Cover the Creaser and Two-sided Trimmer with a folded blanket. Then ② place a cornerboard (95P2940) on each corner and ③ strap the module into the truck.

4.1.17 If a CZ Folder is present, place the packaged module against the wall of the truck for transport to the Customer location.

3AE/097S04749, 4AE/097S04750, 5AE/097S04751



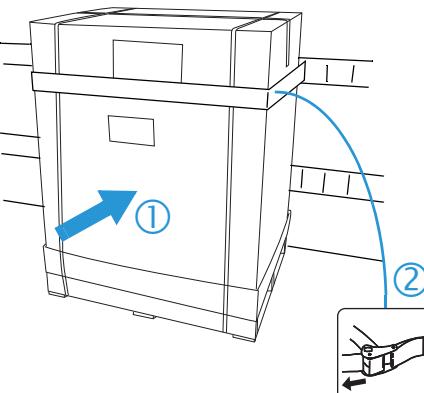
4.1.18

6AE/097S04752



4.1.19

XMH/097S04171



4.1.20

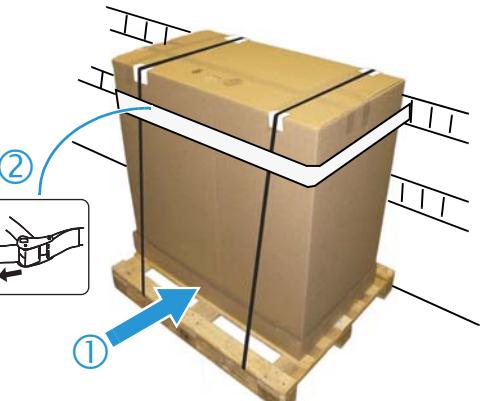
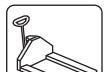
4.1.18 If a Production Ready Finisher is present,
① place the palletized finisher against the wall of the truck and ② strap the module into the truck.



Note: If an Integrated SquareFold® Trimmer module is present, due to the low center of gravity and the dimensions of the packaged module, this module only needs to be loosely strapped into the truck.

4.1.19 If a SquareFold® Trimmer is present,
① place the packaged module against the wall of the truck and ② run a loose strap around it for transport to the Customer location.

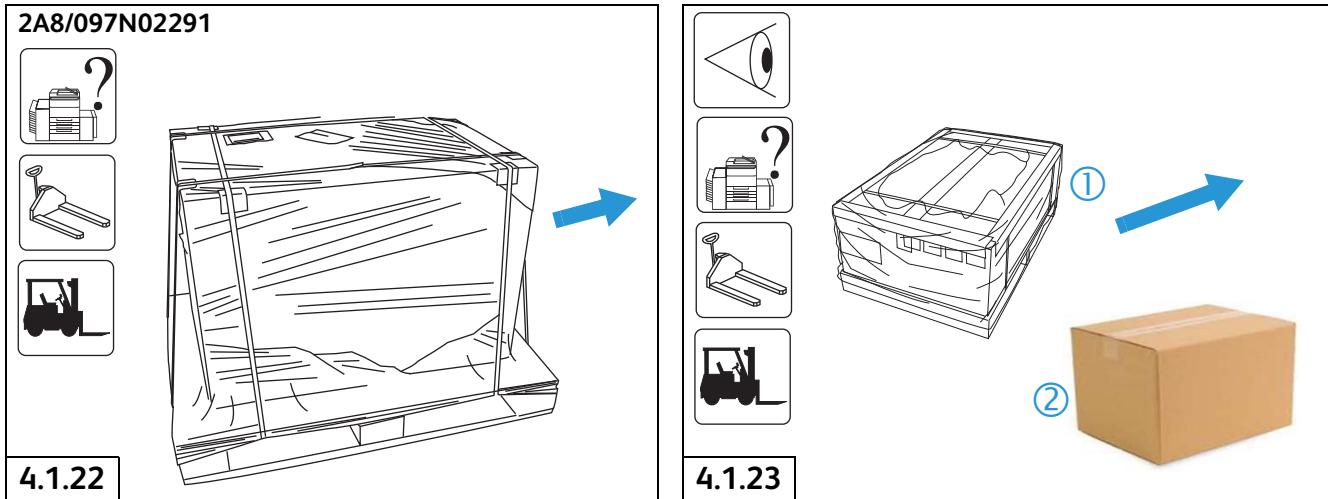
X0Y/097S04716



4.1.21

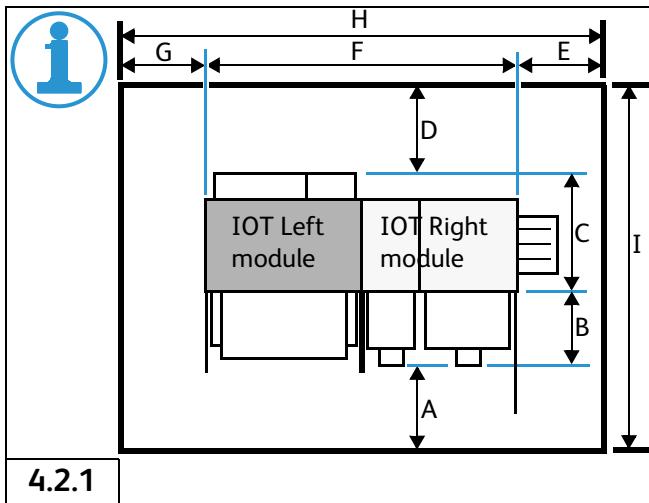
4.1.20 If a PFIM is present, ① position the packed module against the wall of the truck and ② strap the module into the truck.

4.1.21 If a CCU Cart is present: ① Place the packaged cart module against the wall of the truck and ② strap the module into the truck.



4.1.22 If an EFI™ DFE is present, place the packed DFE on the truck against the wall of the truck for transport to the Customer location.

4.1.23 ① Place all remaining fully packaged and/or palletized items, ② boxed items/kits on the truck.



Space Requirements		
	Fixed	
Dimension	in.	mm
A	29.0	740
B	23.4	594
C	42.2	1073
D	39.4	1000
E	29.0	740
F	118.0	2995
G	29.0	740
H	176.0	4475
I	135.8	3448

Table 4.2.1



4.2.0 Space Requirements

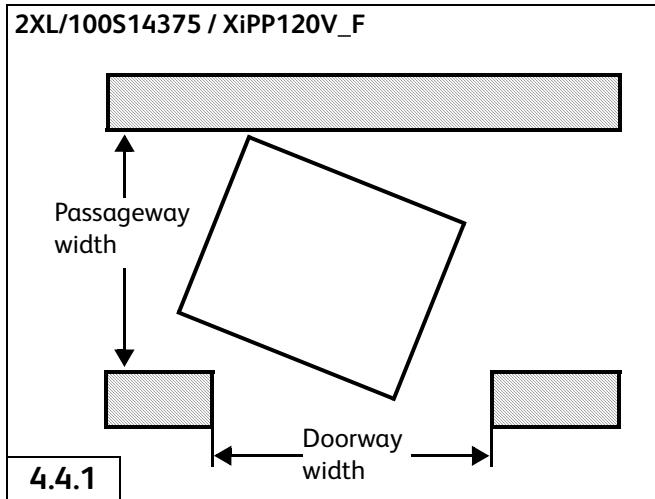
i Note: All configurations are fixed when it comes to the base system.

4.2.1 Space requirements for the Xerox® Iridesse™ Production Press common for all configurations are shown in Table 4.2.1.

4.3.0 Special Handling - Stair Climbing IOTs (if required)

Stop: Due to the size of the Xerox® Iridesse™ Production Press IOT Left and IOT Right modules, stair climbing for these modules is not applicable. Due to size of the Printers, if the Printers are able to be delivered, all other modules, accessories, and pallets will be

able to be delivered. No stair climbing will be required.

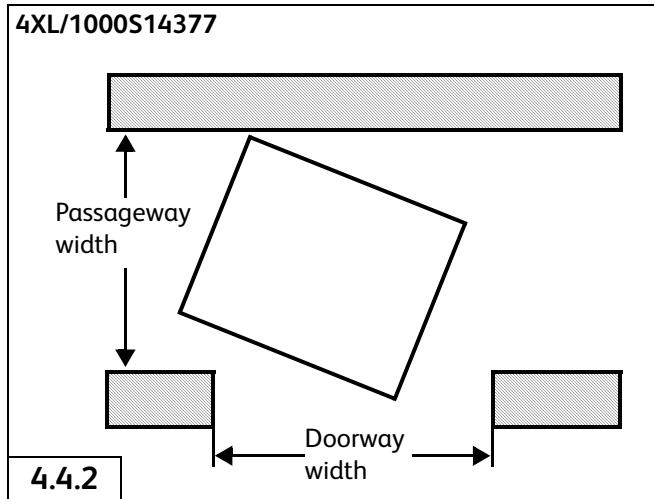


Doorway Width		Min. Passageway	
in.	mm	in.	mm
32.00	813	58.12	1476
33.00	838	56.36	1432
34.00	864	54.70	1390
35.00	889	53.14	1350
36.00	914	51.66	1312
37.00	940	50.27	1277
38.00	965	48.94	1243
39.00	991	47.69	1211
40.00	1016	46.50	1181
41.00	1041	45.36	1152
42.00	1067	44.28	1125
43.00	1092	43.25	1099
44.00	1118	42.27	1074
45.00	1143	41.33	1050
46.00	1168	40.43	1027
47.00	1194	39.57	1005
48.00	1219	38.75	984
49.00	1245	37.95	964
50.00	1270	37.20	945
51.00	1295	36.47	926
52.00	1321	35.76	909
53.00	1346	35.09	891
54.00	1372	34.44	875
55.00	1397	33.81	859
56.00	1422	33.21	844
57.00	1448	32.63	829
58.00	1473	32.06	815
59.00	1499	31.52	801
60.00	1524	31.00	787

Table 4.4.1

4.4.0 Turning Radii

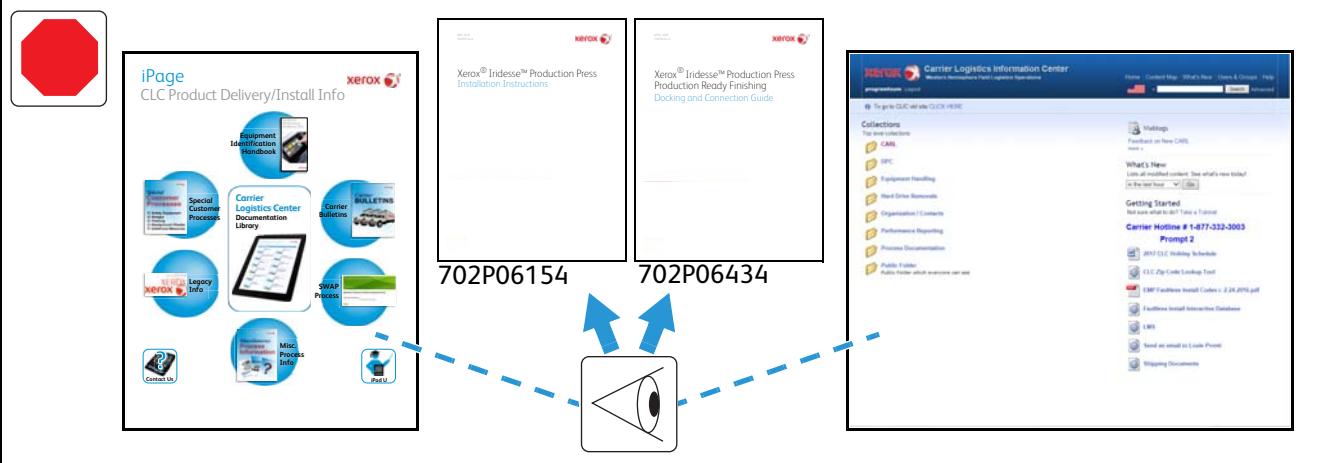
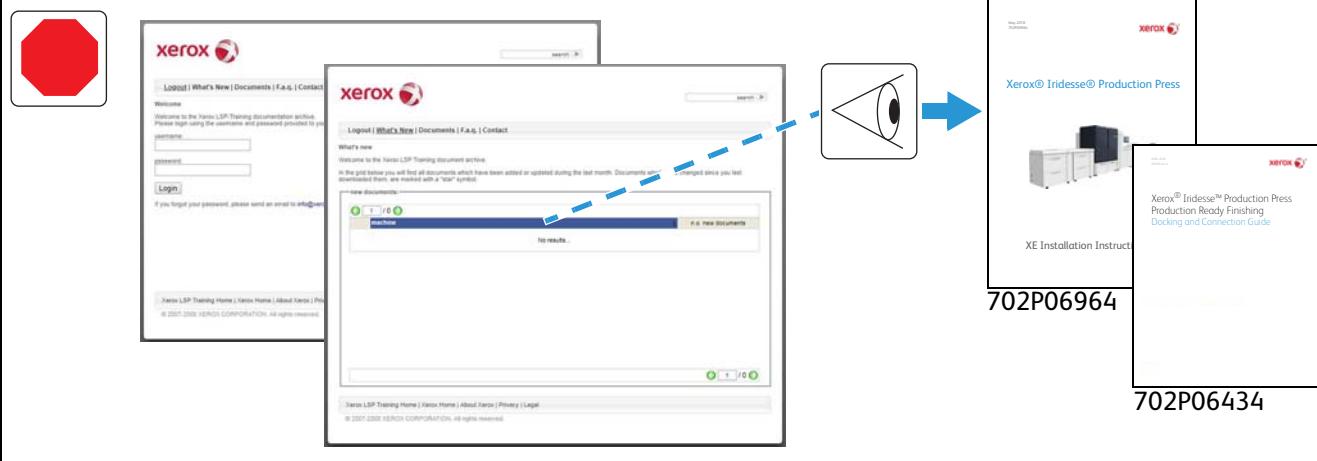
4.4.1 Turning radii for the IOT Left module are shown in Table 4.4.1.



Doorway Width		Min. Passageway	
in.	mm	in.	mm
29.50	749	55.55	1411
30.50	775	53.72	1365
31.50	800	52.02	1321
32.50	826	50.42	1281
33.50	851	48.91	1243
34.50	876	47.50	1207
35.50	902	46.16	1173
36.50	927	44.89	1140
37.50	953	43.70	1110
38.50	978	42.56	1081
39.50	1003	41.48	1054
40.50	1029	40.46	1028
41.50	1054	39.48	1003
42.50	1080	38.55	979
43.50	1105	37.67	957
44.50	1130	36.82	935
45.50	1156	36.01	915
46.50	1181	35.24	895
47.50	1207	34.50	876
48.50	1232	33.78	858
49.50	1257	33.10	841
50.50	1283	32.45	824
51.50	1308	31.82	808
52.50	1334	31.21	793
53.50	1359	30.63	778
54.50	1384	30.06	764
55.50	1410	29.52	750
56.50	1435	29.00	737
57.50	1461	28.5	724

Table 4.4.2

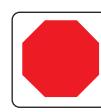
4.4.2 Turning radii for the IOT Right module are shown in Table 4.4.2.

Xerox North America only:**Xerox Europe only:**

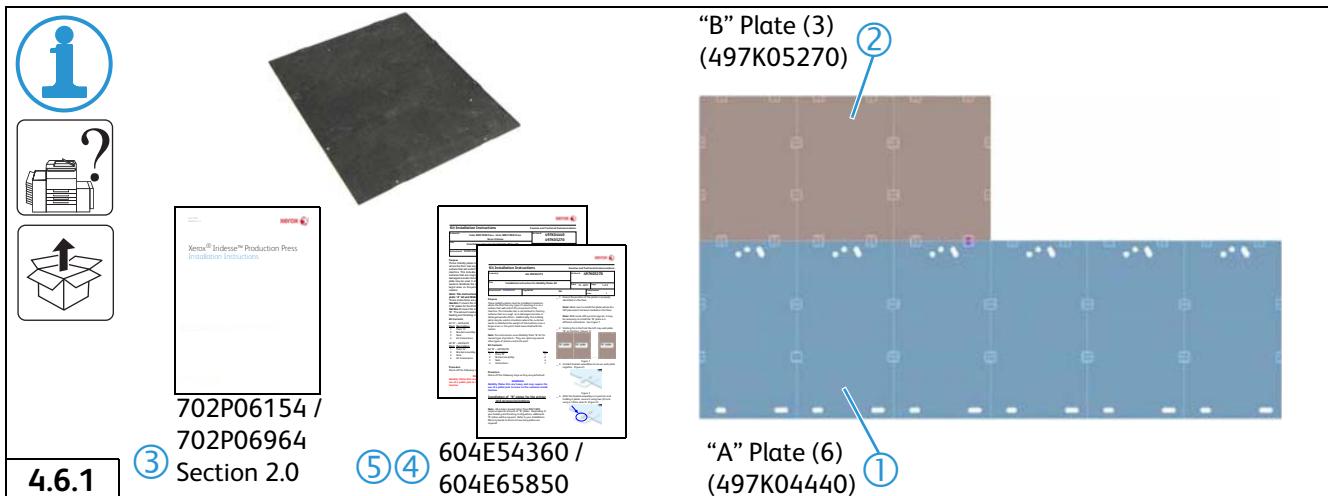
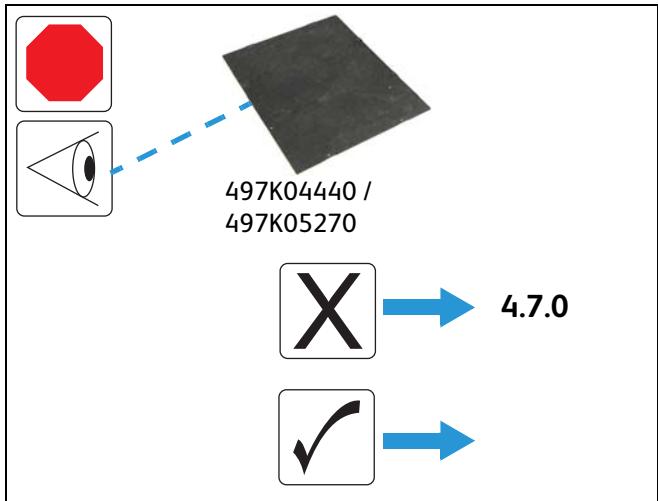
4.5.0 Retrieve the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and the Xerox® Iridesse™ Production Press Productions Ready Finishing Docking and Connection Guide (702P06434)

Stop: Xerox North America only: Use the Xerox® Iridesse™ Production Press Installation Instructions (702P06154) and the Xerox® Iridesse™ Production Press Docking and Connection Guide (702P06434) that can be found on iPage (<https://drive.google.com/file/d/1egdkfiQNmfpJFVlmrCpYdggGIbd8bQ/view>) or the CLIC website (<https://carrierlogistics.external.xerox.com/docushare/dsweb/HomePage>). Also, use the installation instructions within this

section and the instructions packed with the individual accessories to depalletize, unpack, dock and connect the accessory modules.



Stop: Xerox Europe only: Use the Xerox® Iridesse™ Production Press Installation Instructions (702P06964) and the Xerox® Iridesse™ Production Press Docking and Connection Guide (702P06434) that can be found on the LSP Training website (www.xerox-lsptraining.com). Also, use the installation instructions within this section and the instructions packed with the individual accessories to depalletize, unpack, dock and connect the accessory modules.



4.6.0 Unpack and Position Mobility Plates (if present)

Stop: Check to see if there are mobility plates present. If mobility plates are not present, proceed to 4.7.0 "Unpack and Assemble the Xerox® Iridesse™ Production Press IOT Left (2XL/100S14375 / XiPP120V_F) Module" on page 4-16. If mobility plates are present, continue on to the next step.

Note: The Mobility Plate "A" Kit (497K04440) contains two plates per kit. The Mobility Plate "B" Kit (497K05270) contains one plate per kit.

4.6.1 The Xerox® Iridesse™ Production Press base system is covered by using ① six "A" plates and ② three "B" plates. ③ Refer to 'Section 2.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and/or the ④ instructions (604E54360) packed within the Common Mobility Plate "A" Kit (497K04440) and ⑤ (604E65850) Common Mobility Plate "B" Kit (497K05270) for positioning and installation of all of the mobility plates.

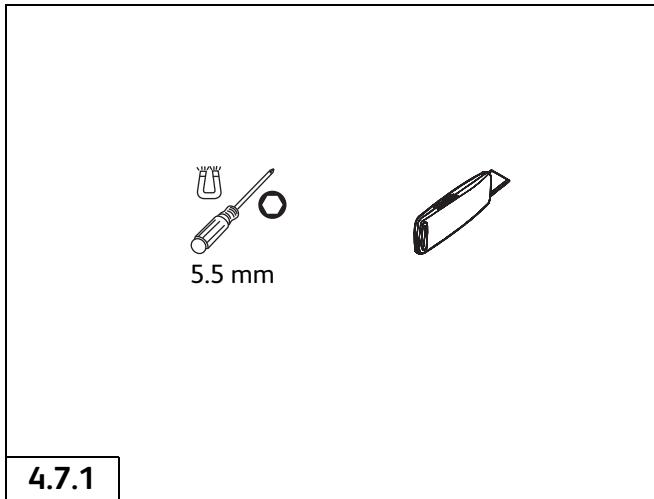
Xerox® Iridesse™ Production Press Configuration	Number of "B" Plates (497K05270) needed (including 3 for the Eco Box / Eco Box 2 Assembly)	Number of "A" Plates (497K04440) needed (Base configuration)
Base configuration (2XL / XiPP120V_F & 4XL/100S14377) + Offset Catch Tray (497K02420)	4 plates needed	IOTs need 6 "A" Plates
High Capacity Feeder (B4E / 450S03106) + Base configuration (2XL & 4XL) + Offset Catch Tray (497K02420)	6 plates needed	IOTs need 6 "A" Plates
Base configuration (2XL / XiPP120V_F & 4XL/100S14377) + Interface Decurler Module (7AE/097S04753) + Productions Ready Finisher (3AE/097S04749)	6 plates needed	IOTs need 6 "A" Plates
Base configuration (2XL / XiPP120V_F & 4XL/100S14377) + Interface Decurler Module (7AE/097S04753) + C/Z Folder (2AE / 450S03139) + Productions Ready Finisher or Finisher with Booklet Maker (3AE/097S04749 / 4AE/097S04750 / 5AE/097S04751)	6 plates needed	IOTs need 6 "A" Plates
Base configuration (2XL / XiPP120V_F & 4XL/100S14377) + Interface Decurler Module (7AE/097S04753) + High Capacity Stacker (MAY / 450S03138)	6 plates needed	IOTs need 6 "A" Plates
Base configuration (2XL / XiPP120V_F & 4XL/100S14377) + Interface Decurler Module (7AE/097S04753) + Interposer (0AE/097S04746) + Productions Ready Finisher or Finisher with Booklet Maker (3AE/097S04749 / 4AE/097S04750 / 5AE/097S04751)	6 plates needed	IOTs need 6 "A" Plates
Base configuration (2XL / XiPP120V_F & 4XL/100S14377) + Interface Decurler Module (7AE/097S04753) + Interposer (0AE/097S04746) + High Capacity Stacker (MAY / 450S03138)	6 plates needed	IOTs need 6 "A" Plates
Dual Advanced High Capacity Feeder (P4X / 450S03107) + High Capacity Feeder (B4E / 450S03106) + Base configuration (2XL / XiPP120V_F & 4XL/100S14377) + Interface Decurler Module (7AE/097S04753) + Interposer (0AE/097S04746) + GBC Advanced Punch Pro (X5K / 497K18750) + High Capacity Stacker (MAY / 450S03138) + High Capacity Stacker (MAY / 450S03138) + Crease and Two-side Trimmer (7XL / 450S03153) + C/Z Folder (2AE / 450S03139) + Productions Ready Finisher Booklet Maker (3AE/097S04749 / 4AE/097S04750 / 5AE/097S04751) + Square-Fold Trimmer (6AE/097S04752)	18 plates needed	IOTs need 6 "A" Plates

Table: 4.6.2

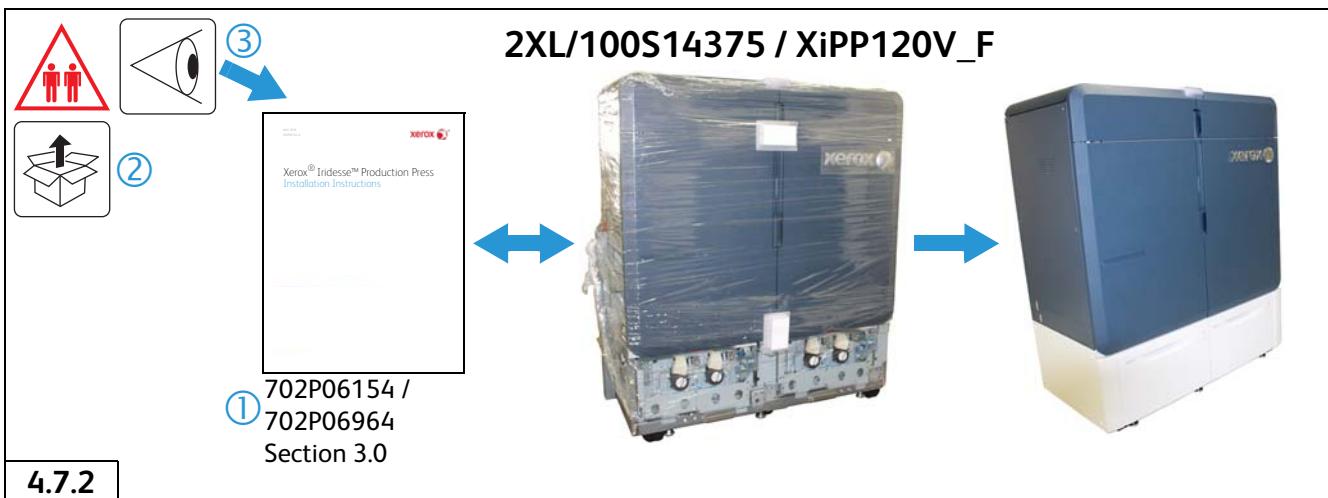


Note: The configuration shown that requires only the four "B" plates consists of the Base configuration with an Offset Catch Tray. This configuration does not contain any feeding or finishing modules.

4.6.2 Due to the number of accessories offered, and the potential configurations that are possible, Table 4.6.2 only shows the configurations with the least amount, as well as the most amount of "B" plates required. All other potential configurations utilize between 7 and 18 "B" plates if the mobility plates are present.



4.7.1



4.7.2

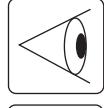
4.7.0 Unpack and Assemble the Xerox® Iridesse™ Production Press IOT Left (2XL/100S14375 / XiPP120V_F) Module

4.7.1 The tools required to unpack and assemble the Xerox® Iridesse™ Production Press IOT Left module are shown.

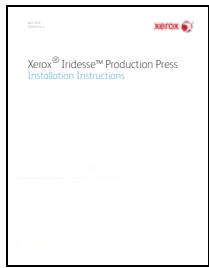


WARNING: Due to the size and weight of the IOT Left module, two people are required to move the module.

4.7.2 ① Refer to 'Section 3.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② unpack and ③ assemble the IOT Left for docking.

**4.8.1**

①

702P06154 /
702P06964
Section 4.0**4XL/100S14377****4.8.2**

4.8.0 Unpack the Xerox® Iridesse™ Production Press IOT Right (4XL/100S14377)

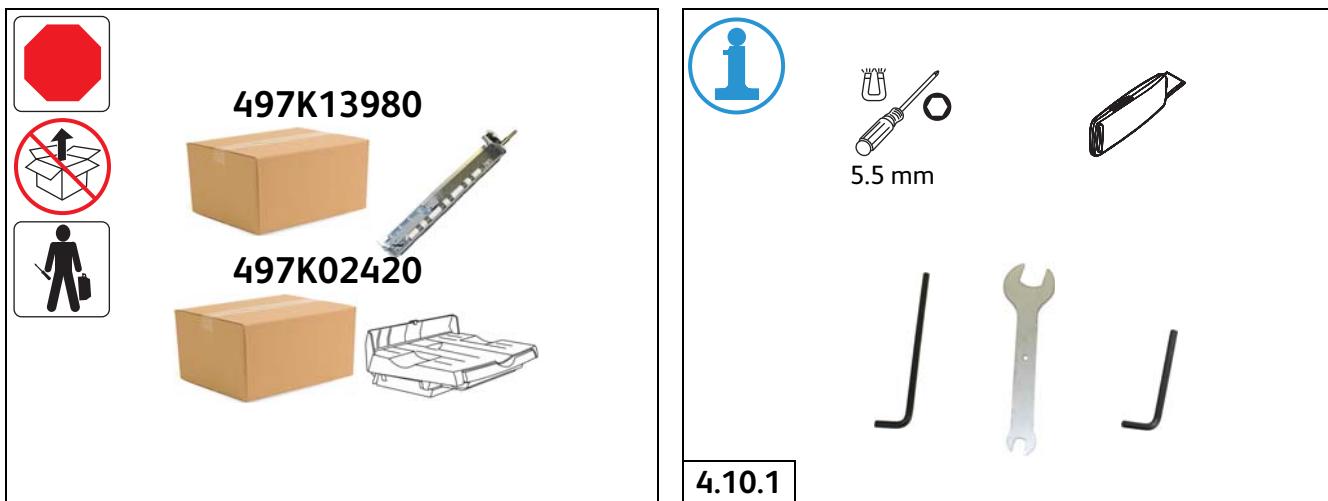
4.8.1 The tools required to unpack and prepare the Xerox® Iridesse™ Production Press IOT Right are shown.



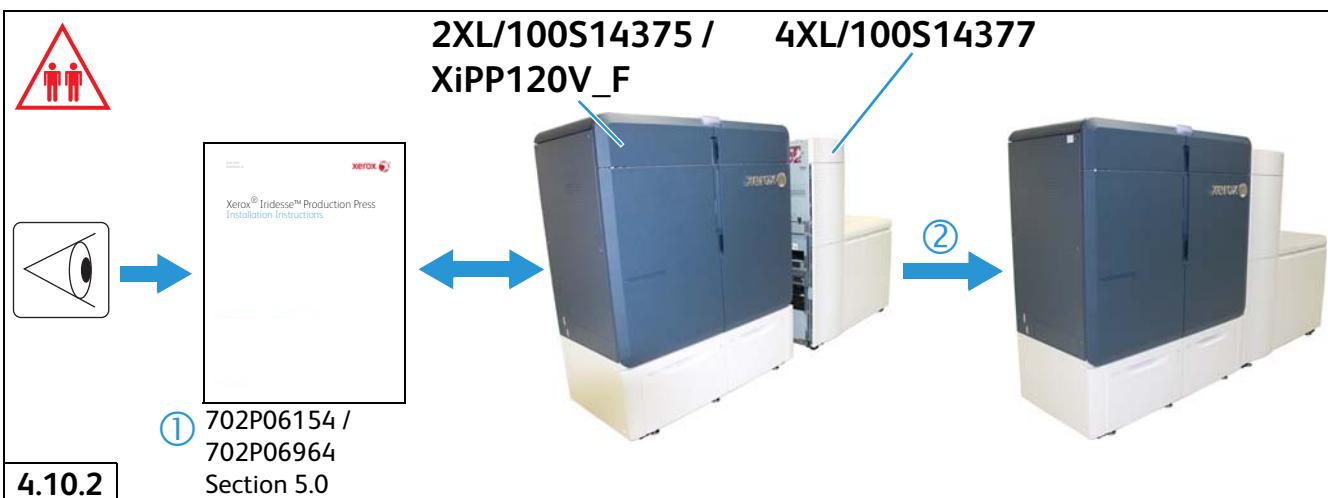
WARNING: Due to the size and weight of the IOT Right module, two people are required to move the module.

 Note: When unpacking the boxed items from the top of the IOT Right module, keep boxes together and set them aside near by. Items packed within these boxes will be needed throughout the installation process of the IOT Right and IOT Left modules.

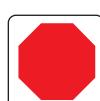
4.8.2 ① Refer to 'Section 4.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964), ② unpack and prepare the IOT Right for docking.



4.10.1



4.9.0 Unpack and Install the OCT Exit Roll Kit (497K13980) and the OCT (497K02420) (if present)



Stop: If an OCT Exit Roll Kit and OCT are present, the Carrier is not responsible for installing these items. The CSE is responsible for unpacking and installing the OCT Exit Roll Kit and OCT into the IOT Right module.

4.10.0 Dock the Xerox® Iridesse™ Production Press IOT Right Module (2XL/100S14375 / XiPP120V_F) to the IOT Left Module (4XL/100S14377)



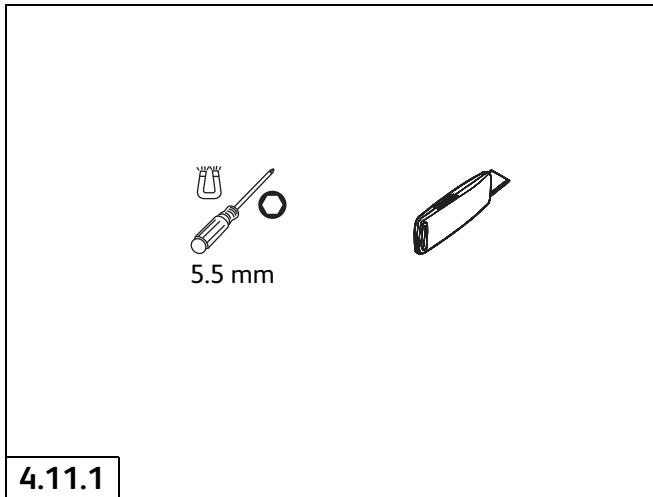
Note: The Allen Wrenches and wrench are shipped boxed with the system.

4.10.1 The tools required to dock the Xerox® Iridesse™ Production Press IOT Right module to the IOT Left module are shown.



WARNING: Due to the size and weight of the IOT Right, two people will be required to dock the IOT Right to the IOT Left.

4.10.2 ① Refer to 'Section 5.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② dock the IOT Right module to the IOT Left module.

**4.11.1****4.11.2**

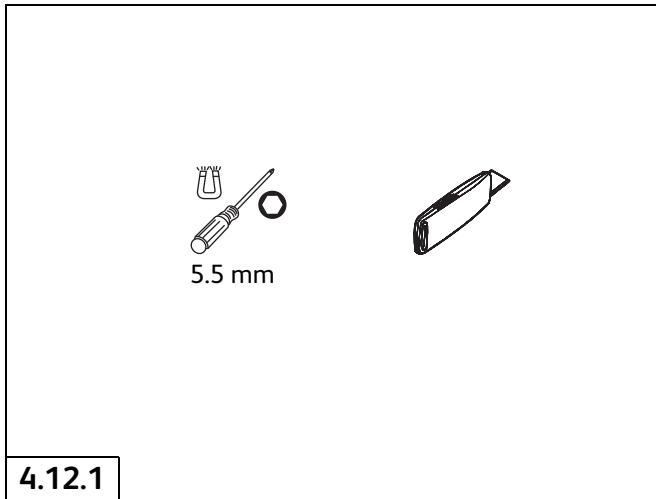
4.11.0 Unpack and Assemble the Xerox® Iridesse™ Production Press Eco Box

4.11.1 The tools required to unpack and assemble the Xerox® Iridesse™ Production Press Eco Box are shown.



WARNING: Due to the size of the ECO Box, two people will be required to remove the module from the bottom corrugated tray and cut plastic bag.

4.11.2 ① Refer to 'Section 6.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② unpack and ③ assemble the Eco Box.



4.12.1



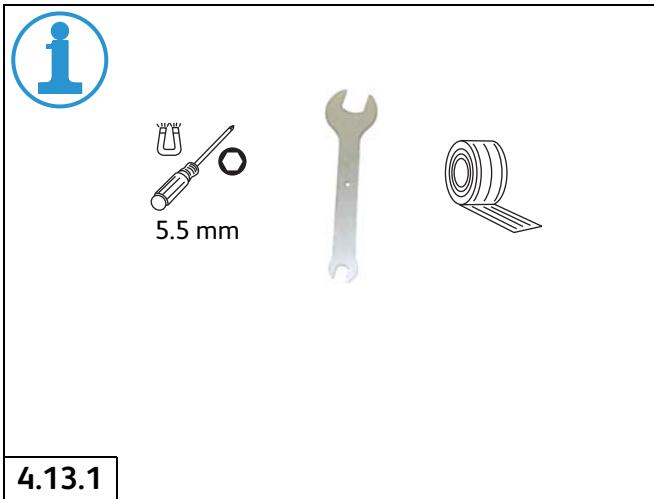
4.12.0 Unpack and Assemble the Xerox® Iridesse™ Production Press Eco Box 2

4.12.1 The tools required to unpack and assemble the Xerox® Iridesse™ Production Press Eco Box 2 are shown.

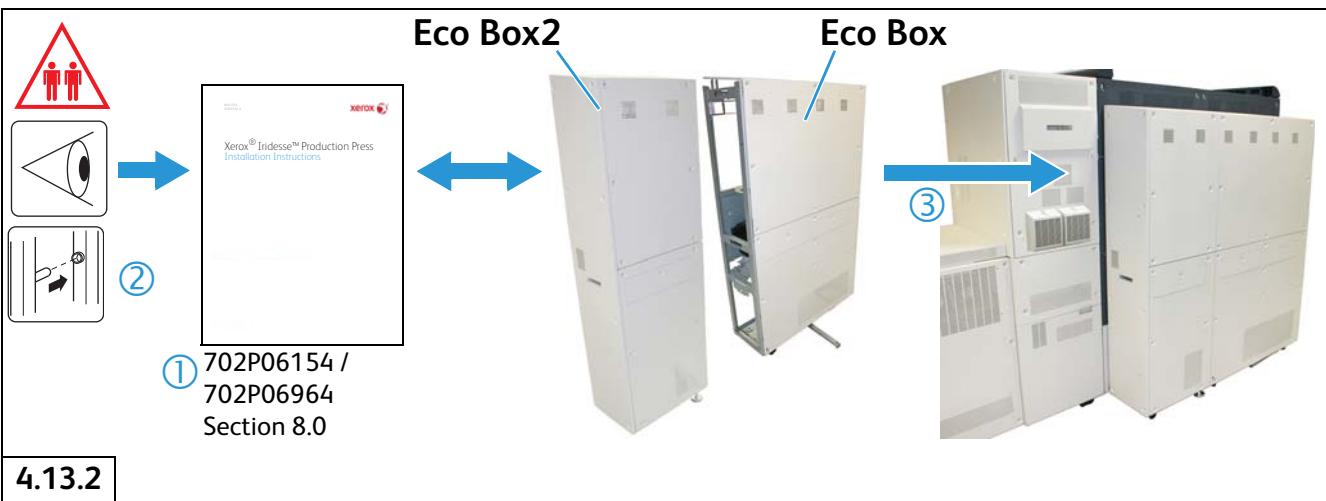


WARNING: Due to the size of the ECO Box 2, two people will be required to remove the module from the bottom corrugated tray and cut plastic bag.

4.12.2 ① Refer to 'Section 7.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② unpack and ③ assemble the Eco Box 2.



4.13.1



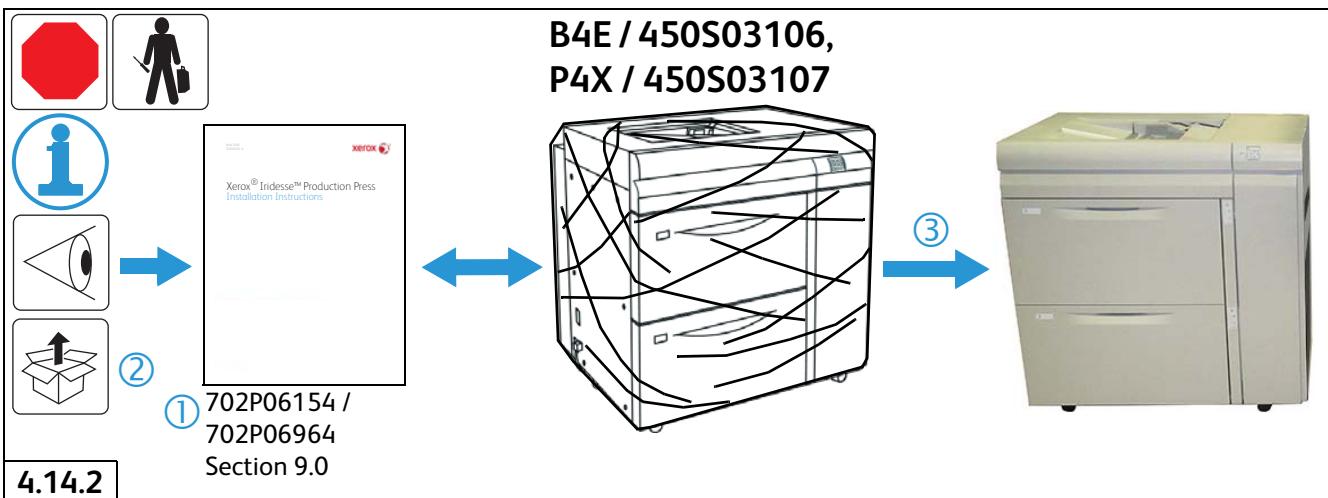
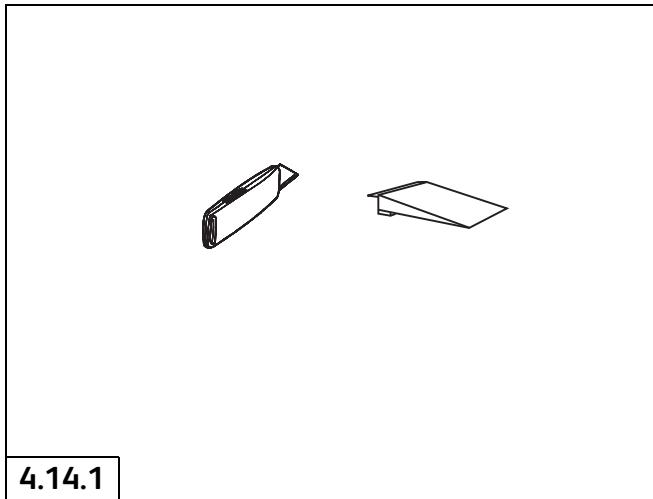
4.13.0 Dock and Position the Xerox® Iridesse™ Production Press Eco Box and Eco Box 2 Assembly

4.13.1 The tools and material required to dock and position the Xerox® Iridesse™ Production Press Eco Box and the Eco Box 2 assembly are shown.



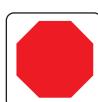
WARNING: Due to the size and the instability of the ECO Box and ECO Box 2, two people will be required to dock these modules.

4.13.2 ① Refer to 'Section 8.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② dock and ③ position the Eco Box / Eco Box 2 assembly.



4.14.0 Unpack and Depalletize the Oversized High Capacity Feeder (OHCF) (B4E / 450S03106) and Dual Advanced High Capacity Feeder (DAHCF) (P4X / 450S03107) (if present)

4.14.1 The tools required for unpacking the OHCF and DAHCF are shown.

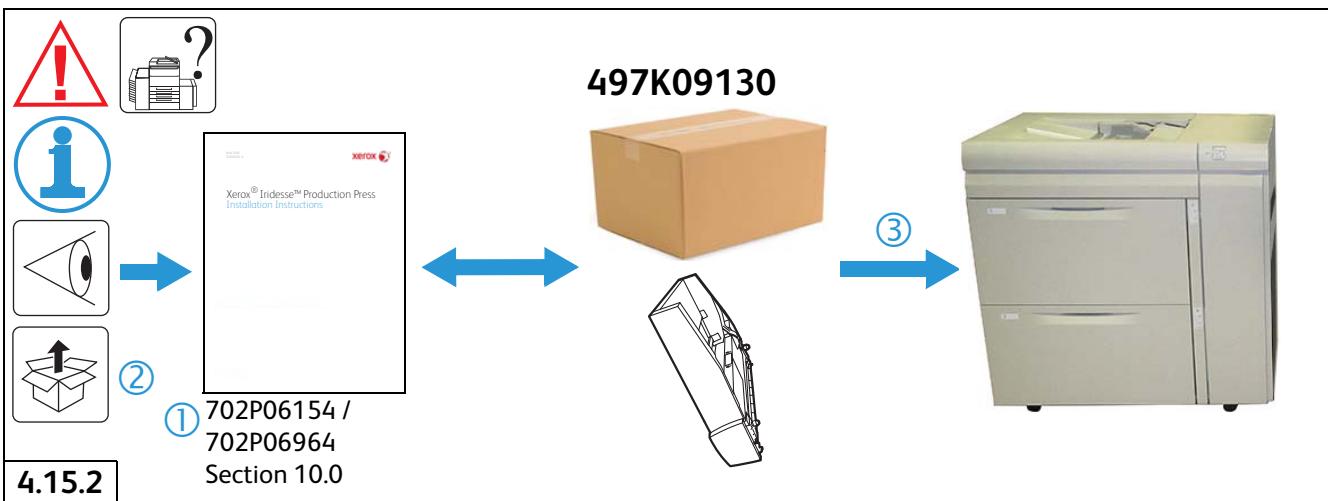
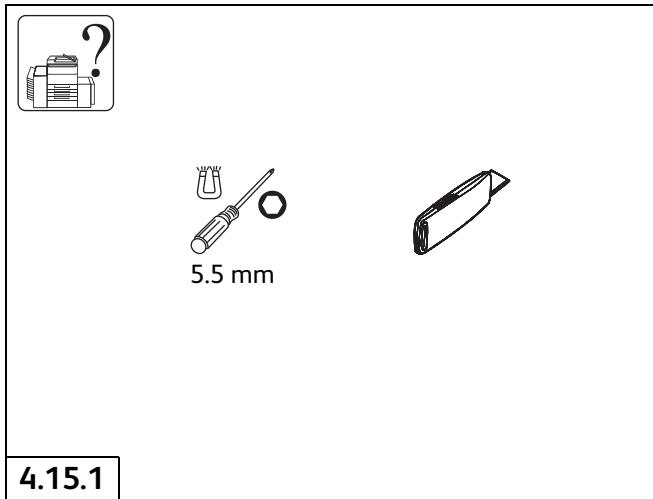


Stop: The docking of the OHCF or OHCF/DAHCF to the IOT Left module is the responsibility of the CSE. The Carrier will position the OHCF or OHCF/DAHCF to the left of the IOT Left module (2XL/100S14375 / XiPP120V_F).



Note: The docking hardware is packed in left side bottom of OHCF and DAHCF.

4.14.2 ① Refer to 'Section 9.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② unpack and prepare ③ the OHCF and DAHCF, if present, for docking.



4.15.0 Unpack and Install the MSI Kit (497K09130) (if present)

4.15.1 The tools required to unpack and install the MSI Kit are shown.

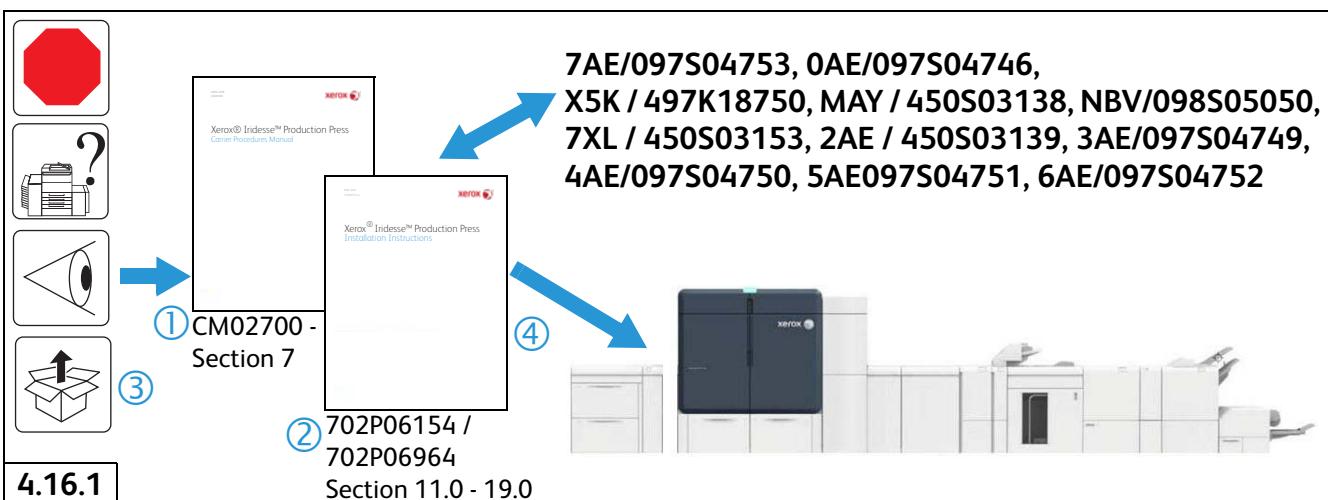
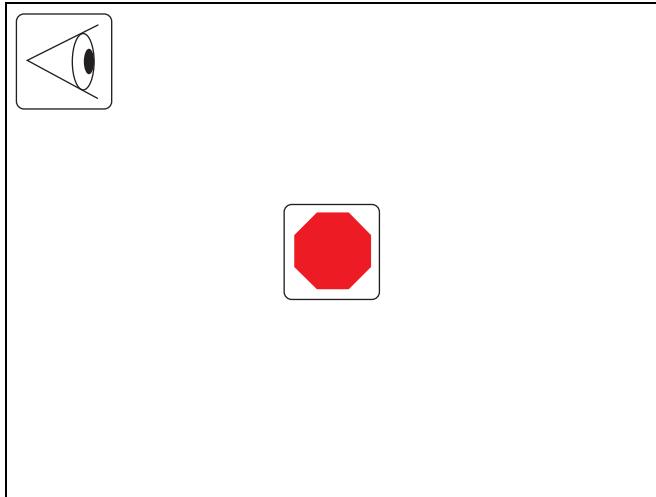


CAUTION: When installing the spring-loaded cover on the bottom of the MSI tray, flex the cover just enough so that the pins align and it drops into position.



Note: Ensure to install the two screws behind the spring-loaded cover to secure the MSI Kit in place.

4.15.2 ① Refer to ‘Section 10.0’ within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② unpack and ③ install the MSI Kit into the top of the OHCF.



4.16.0 Unpack and Install the Production Ready Finishing Accessories (if present)

Stop: The tools required to unpack and install the Production Ready accessories are shown at the beginning of each accessory Section, or at the beginning of the individual installation instructions packed with most of the accessories.

Stop: Depending on which accessories are present, the corresponding section(s) will need to be referred to within the Xerox® Iridesse™ Production Press Installation Instructions.

4.16.1 ① Refer to Section 7 - Accessories within this manual and to ② Sections 11.0 - 19.0 within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ③ unpack and ④ install potential Production Ready accessories that may be present.



4.17.0 Unpack, Assemble and Position the Fiery NX Premium Standalone DFE

4.17.1 ① Refer to Section 7 - Accessories within this manual and ② to ‘Section 20.0’ within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ③ unpack, ④ assemble and position the Fiery NX Premium Standalone DFE.

4.18.0 Unpack and Position the Partner Finishing Interface Module (PFIM)

4.18.1 ① Refer to Section 7 - Accessories within this manual and ② to ‘Section 21.0’ within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ③ unpack, ④ and position the PFIM.



4.19.0 Unpack and Position the CCU Cart

4.19.1 ① Refer to Section 7 - Accessories within this manual and ② to 'Section 22.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ③ unpack, ④ and position the CCU Cart.

4.20.0 Unpack and Position the Parts Cabinet (497K06490 / 497K07470)

4.20.1 ① Refer to 'Section 23.0' in the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② unpack and ③ position the Parts Cabinet.



4.21.0 Communication Cable and Power Cord Installation

4.21.1 ① Refer to ‘Section 24.0’ within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and ② the Xerox® Iridesse™ Production Press Production Ready Finishing Docking and Connection Guide (702P06434) ③ for making all cable connections.

4.22.0 Final Steps

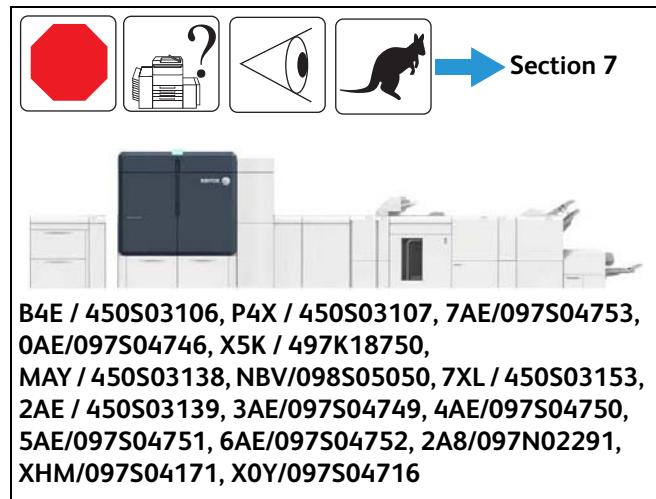
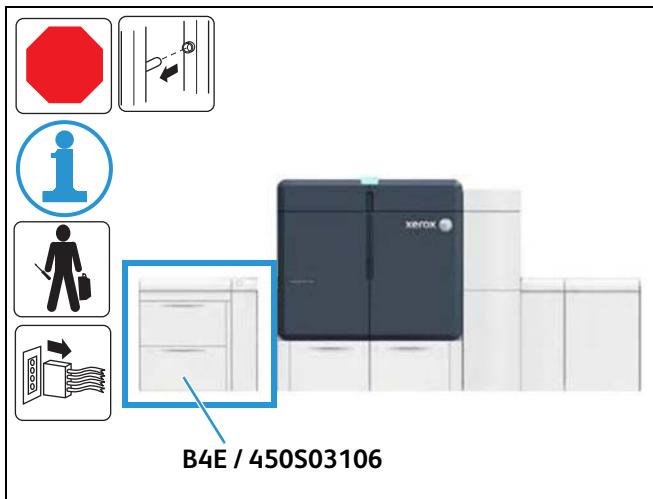
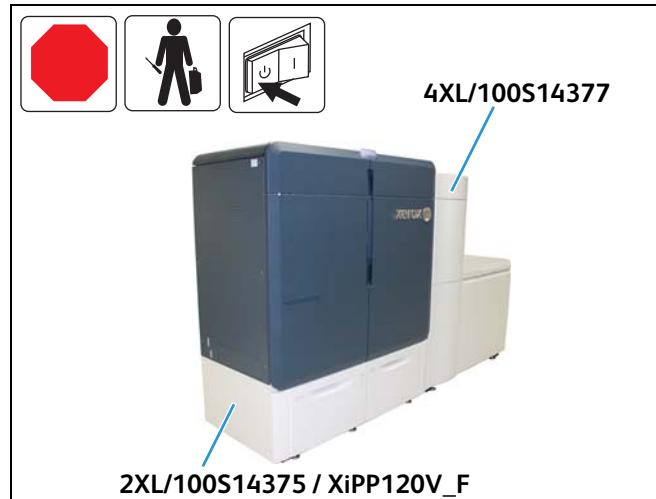
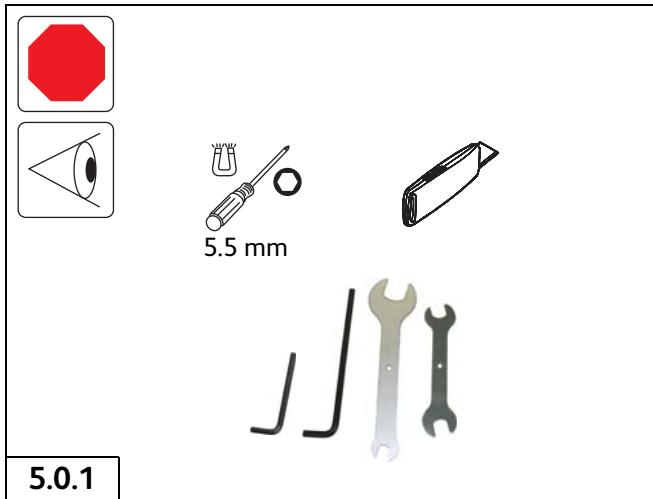
i Note: The base configuration consisting of the IOT Left module and IOT Right modules is shown. The OHCF that is part of the base configuration is not shown. If a configuration consisting of any of the Production

Ready Finishing modules are present, the remaining boxed items and kits will be position to the right of the last module in the finishing chain.

4.22.1 ① Refer to ‘Section 25.0’ in the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② position all the remaining boxed items and kits to the right of the installed system. ③ Do not unpack any of the remaining boxed items or kits as these are to be left for the CSE or Customer.

5

Relocation-Removal



5.0.0 Relocation-Removal

Stop: The Allen wrenches and wrenches that were shipped with the system should be located within the parts cabinet so that the Carriers can undock and Relocate/ Remove the system.

5.0.1 The tools required for the Relocation/ Removal of the Xerox® Iridesse™ Production Press base configuration are shown.

5.1.0 Power Off the Xerox® Iridesse™ Production Press

Stop: It is the responsibility of the CSE to power the Xerox® Iridesse™ Production Press down, disconnect power, and pre-

pare the IOT Left and IOT Right modules internally for the move. Level of preparation will be determined by the type of move that is required.

Stop: It is the responsibility of the CSE to disconnect and undock the Oversized High Capacity Feeder (OHCF) (B4E / 450S03106) and Dual Advanced High Capacity Feeder (DAHCF) (P4X / 450S03107), if present, from the IOT Left (2XL/100S14375 / XiPP120V_F) module.

Stop: Prior to undocking and moving the base system, if accessories are present, go to "Section 7 - Accessories" and prepare all accessories that are present first.



5.1.1



5.1.2



Stop: Due to the high point load on the casters of the IOT Left and IOT Right modules, sheets of Masonite may be needed to traverse tiled or wood flooring to prevent damage.



Note: Base system for the Xerox® Iridesse™ Production Press consists of the IOT Left module, IOT Right module with Electrical Box installed, and Eco Box.



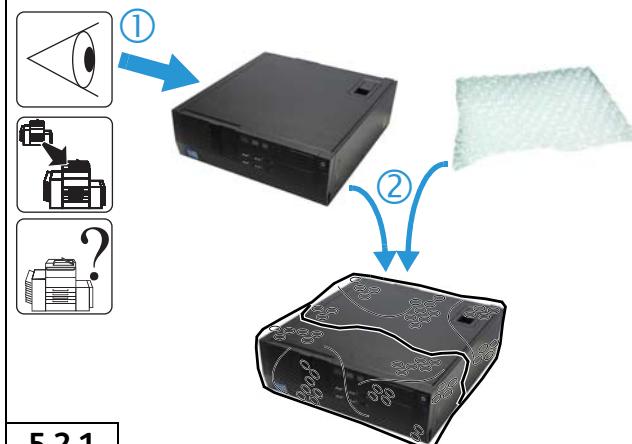
Note: The two wrenches and two Allen wrenches that were shipped with the system will be needed.

5.1.1 The tools required for a relocation or removal are shown.

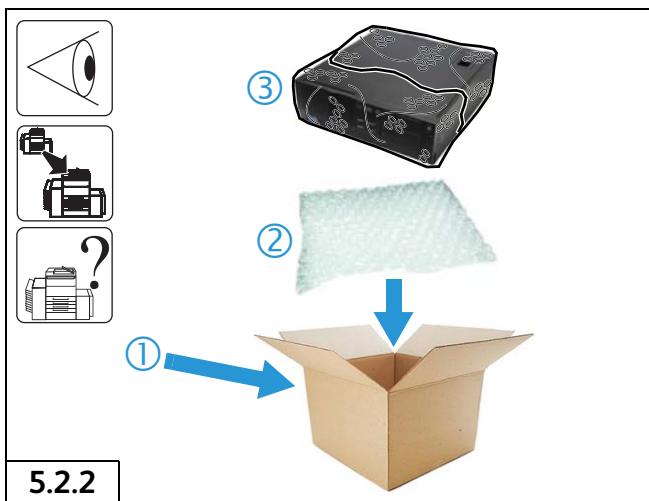
5.1.2 The materials required for a relocation or removal are shown.



43B/097N02308 / 59B/097S04979

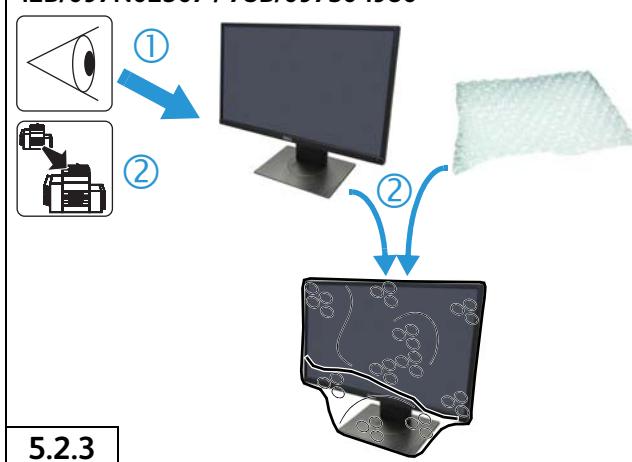


5.2.1



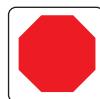
5.2.2

42B/097N02307 / 75B/097S04980

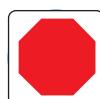


5.2.3

5.2.0 Prepare the PC UI and Monitor for the Move



Stop: It will be the responsibility of the CSE to power down and disconnect all cables, including the power cord and communication cables from the PC UI and monitor.



Stop: If the relocation of the system is within the same building the PC UI, monitor, keyboard, mouse and all cables can be carried to the new install location. If the relocation of the system requires it to be loaded onto a truck, all items will need to be packed within a generic box.

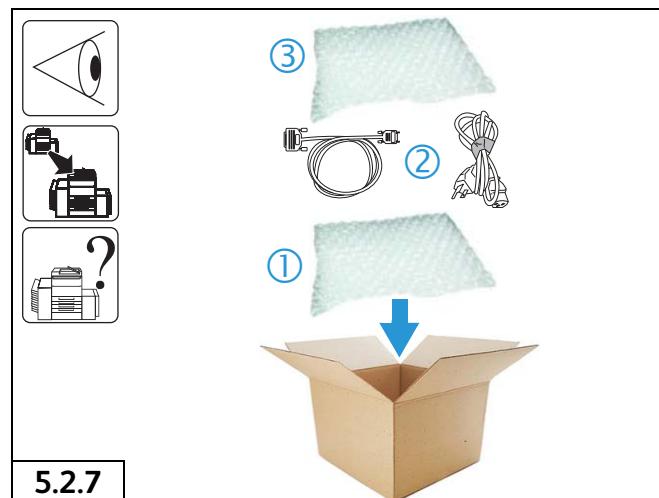
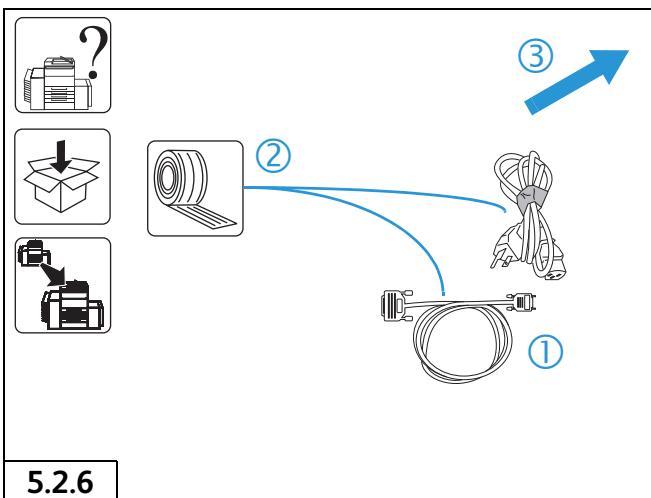
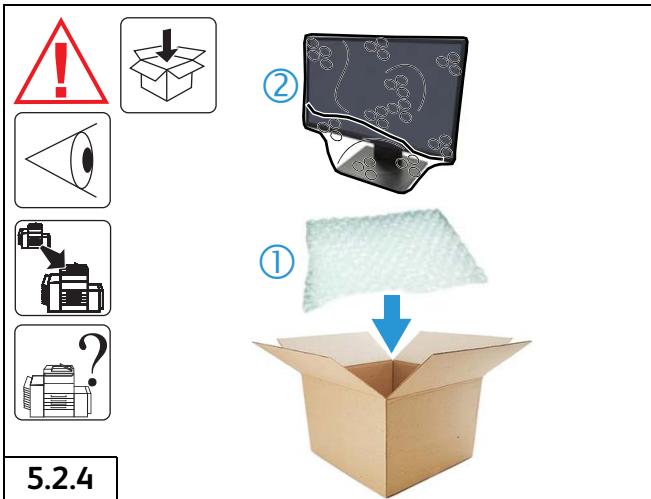


Stop: When moving the controller, ensure to move the keyboard and mouse with it to the new location.

5.2.1 ① Retrieve the PC UI controller and ② wrap it in a layer of bubblepack.

5.2.2 ① Retrieve a generic box (95E67490) and ② place a layer of bubblepack in the bottom.
③ Place the packed PC UI in the box.

5.2.3 ① Retrieve the PC UI monitor and ② wrap it in a layer of bubblepack.



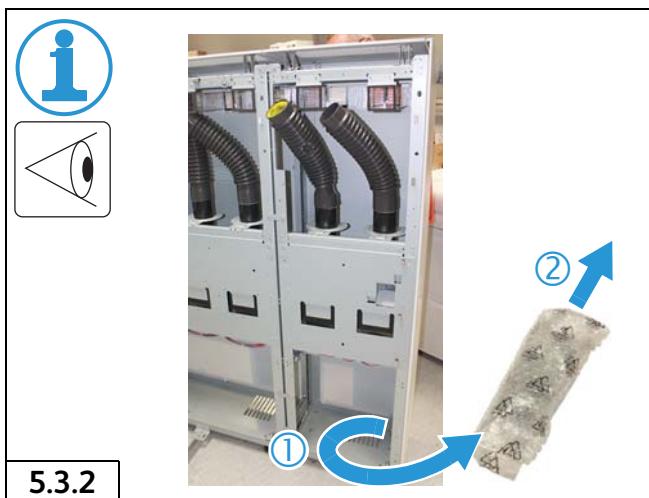
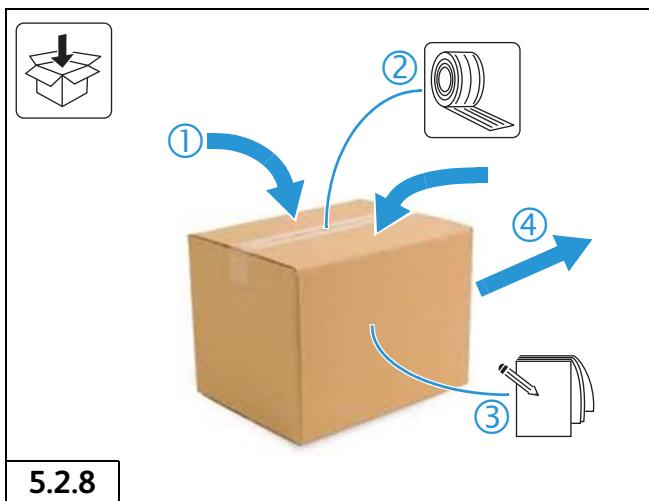
CAUTION: When placing the packed PC UI monitor in the box, ensure the screen is positioned on top of the PC UI face down. If not, damage to the monitor may occur.

5.2.4 ① Place a layer of bubblepack on top of the PC UI and ② place the packed monitor in the box.

5.2.5 ① Place a layer of bubblepack over the top of the monitor. Then, ② place the keyboard and ③ mouse in the box.

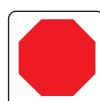
5.2.6 ① Coil and ② tape the cables and the power cords. ③ Move all of the cables to the new install location.

5.2.7 ① Place a layer of bubblepack on top of the monitor and ② placed all the taped cables and cords in the box. ③ Fill all voids with bubblepack.



5.2.8 ① Close and ② secure the box with tape. ③ Write the contents 'PC UI' on the outside of the box and ④ move the boxed PC UI to the new location or truck.

5.3.0 Prepare the Eco Box / Eco Box 2 Assembly for the Move



Stop: It is the responsibility of the CSE to disconnect the Eco Box / Eco Box 2 Assembly from the rear of the IOT Left module.



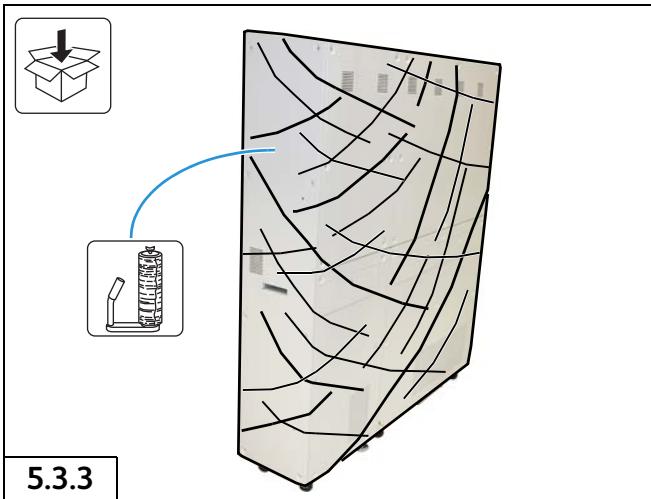
WARNING: Due to the size and instability of the Eco Box / Eco Box 2 Assembly, two people will be required when moving the assembly.

5.3.1 Move the Eco Box / Eco Box 2 Assembly out away from the rear of the IOT Left Module.

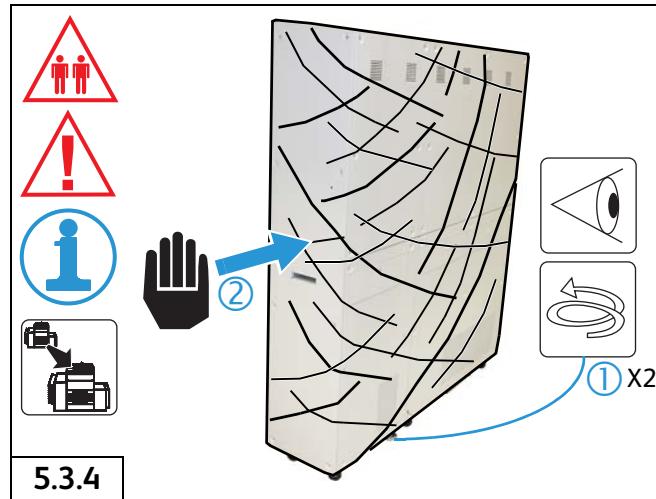


Note: The bundle in the bottom of the Eco Box / Eco Box Assembly contains the saved shipping brackets that were removed from the IOT Left and IOT Right modules installation. These brackets will be reinstalled later in the process.

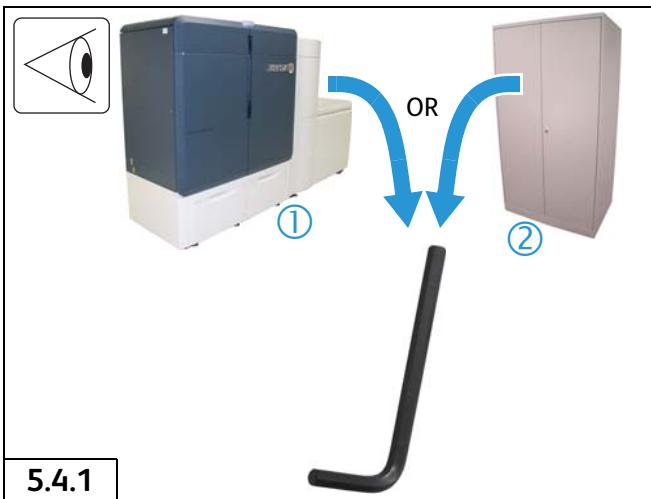
5.3.2 ① Remove and ② set aside the bundle containing the shipping brackets and screws from within the bottom of the Eco Box / Eco Box 2 Assembly.



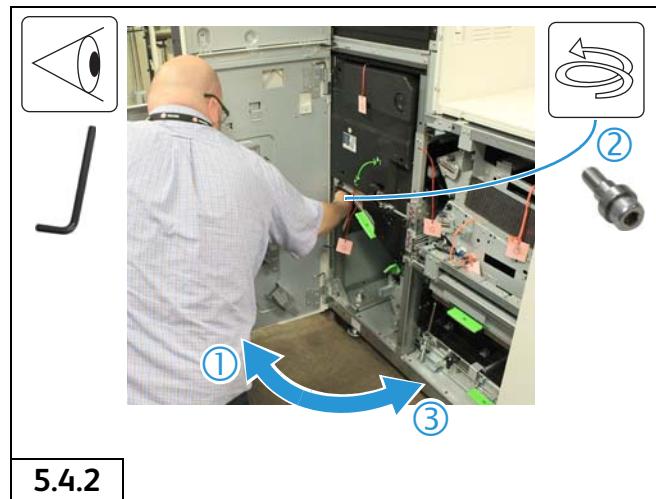
5.3.3



5.3.4



5.4.1



5.4.2

5.3.3 Cover the Eco Box / Eco Box 2 Assembly with a layer of stretchwrap.



WARNING: Due to the size of the Eco Box / Eco Box 2 Assembly two people are required when moving this assembly. Due to instability, extra care must be taken when moving this module.



CAUTION: When moving the assembly, the fly-out on the front side of the Eco Box must remain attached to provide stability.

5.3.4 ① Raise the two leveling feet up to the bottom of the Eco Box / Eco Box 2 Assembly and

carefully ② move the assembly to the new install location or truck.

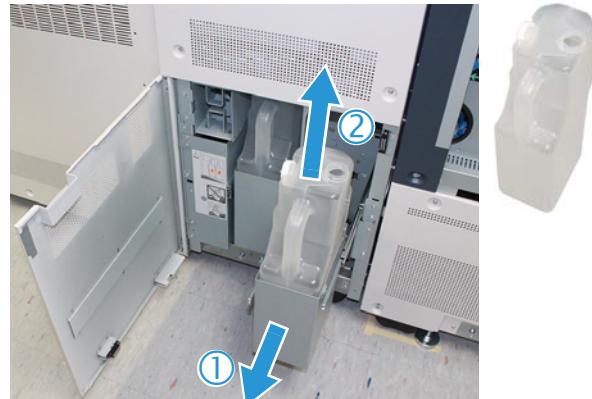
5.4.0 Undock the IOT Right Module from the IOT Left Module

5.4.1 ① Retrieve the Allen wrench that was originally shipped with the system from either the top of the IOT Right module or ② from within the Parts Cabinet.

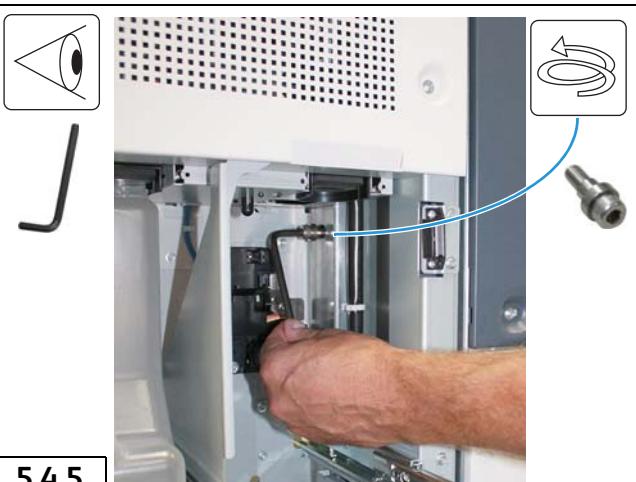
5.4.2 ① Open the IOT front cover. Using the Allen wrench, ② remove the docking bullet from the left side frame member of the IOT. ③ Close the IOT front cover.



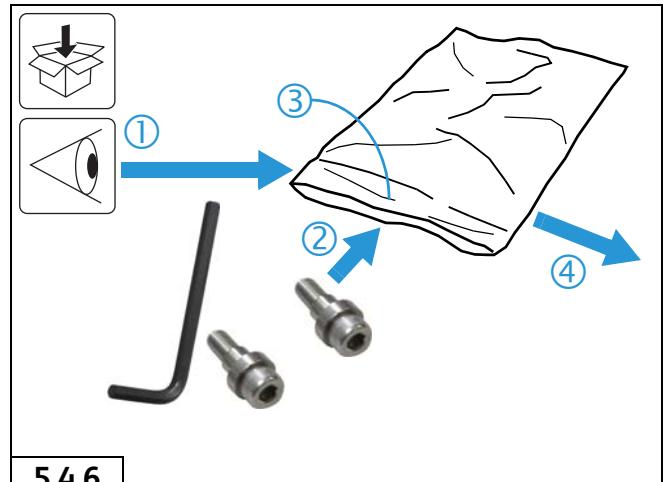
5.4.3



5.4.4



5.4.5



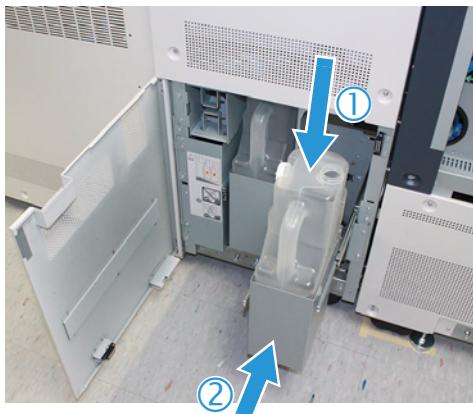
5.4.6

5.4.3 Open the rear bottom left cover of the IOT Right module.

5.4.4 S① Slide the right waste toner container out on its rails. Then, ② remove the waster toner container from the holder.

5.4.5 Using the Allen wrench, remove the docking bullet from the inside right side of the rear cavity.

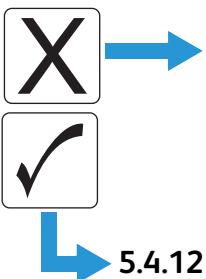
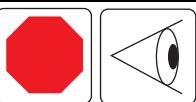
5.4.6 ① Retrieve a plastic bag and ② place the two docking bullets and ③ Allen wrench inside the bag. ④ Set the bag aside.



5.4.7



5.4.8



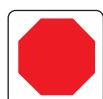
5.4.12



5.4.9

5.4.7 ① Place the waste toner container back into the holder. Then, ② slide the waste toner container back into place within the IOT.

5.4.8 Close the rear bottom left cover of the IOT Right module.



Stop: Because the CSE had to prepare the machine prior to the Carrier arriving, IOT Right top cover may have been left off. If not, continue on to the next step. If so, go to step 5.4.12 on page 5-10.



Note: The step stool (497K05860) will be required to obtain access to the top of the IOT Right module.

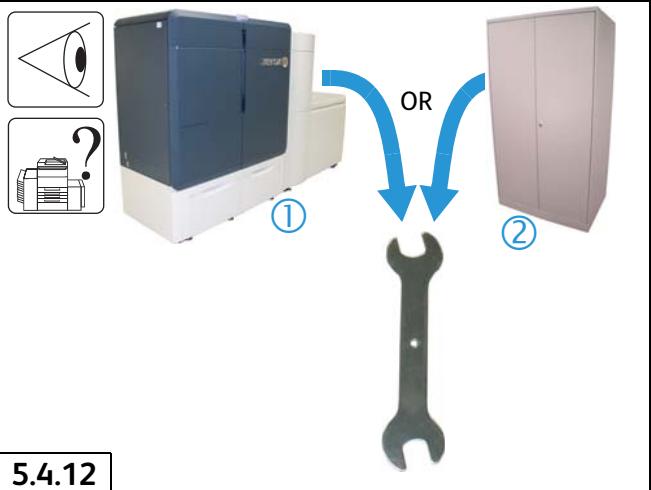
5.4.9 If required, using a 5.5 mm hex driver, remove the four screws securing the IOT Right top cover.



5.4.10



5.4.11



5.4.12

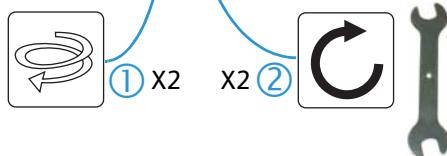
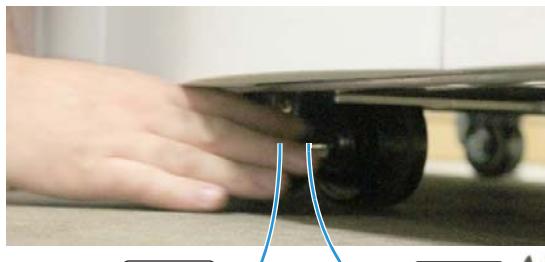
5.4.13

5.4.10 Remove the top cover from the IOT Right.

5.4.11 ① Set the top cover and ② four screws aside to be reinstalled later in the process.

5.4.12 ① Retrieve the smaller wrench that was originally shipped with the system from either the top of the IOT Right module or ② from within the Parts Cabinet.

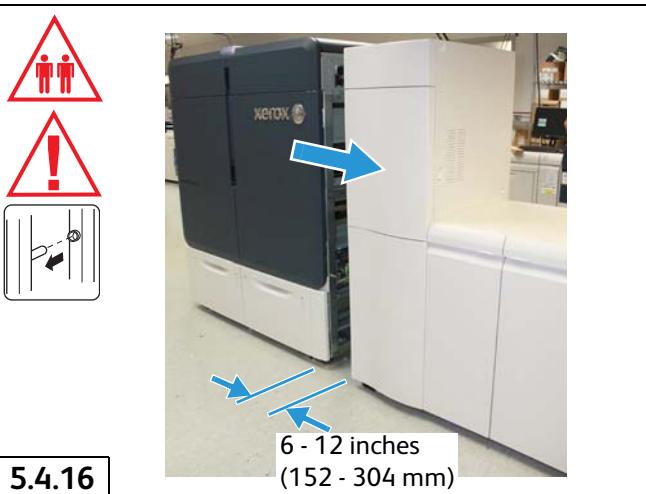
5.4.13 Open the front covers of the IOT right.



5.4.14



5.4.15



5.4.14 ① Loosen the two front stabilizing feet from the floor. ② Raise the two stabilizing feet hand-tight to the bottom frame of the module.

5.4.15 Close the IOT Right front covers.

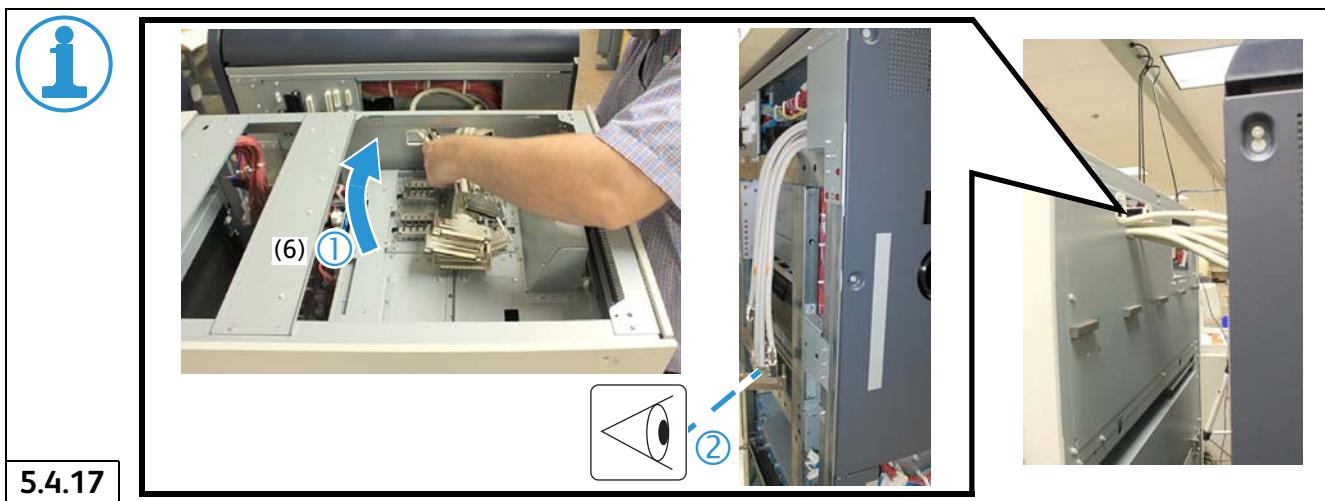


WARNING: Due to the size of the IOT Right module, two people will be required to undock the module from the IOT Left module.

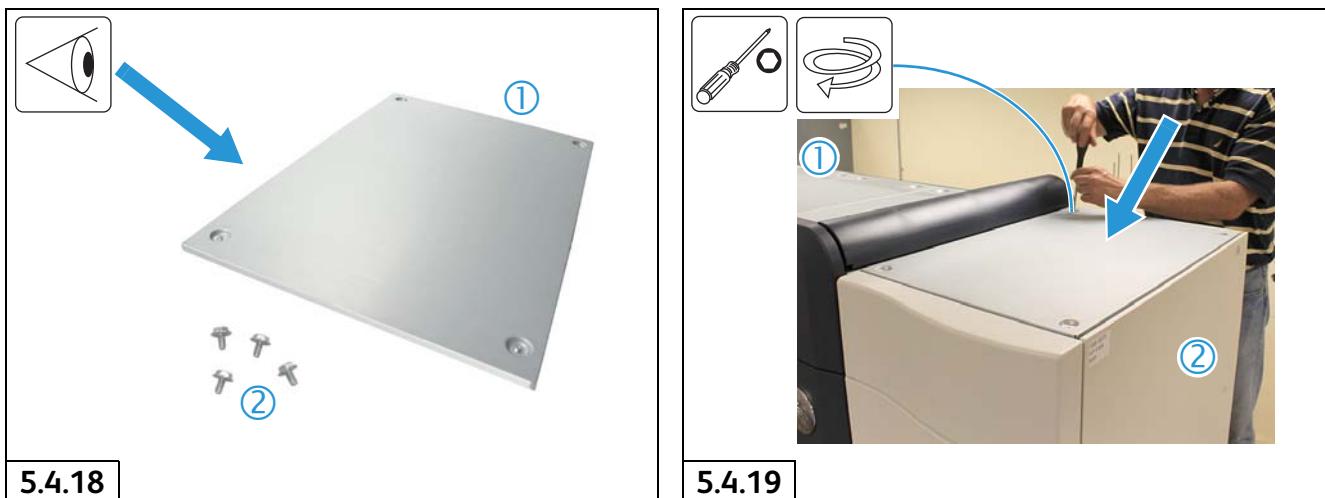
CAUTION: When undocking the IOT Right module, only move the module 6 - 12 inches (152 - 304 mm) away from the IOT Left module. Disconnected communication cables within the top of the IOT Right module

may cause damage if the module is moved any farther prior to routing the cables out from the top of the IOT.

5.4.16 ① Using two people, carefully undock the IOT Right from the IOT Left and ② move it approximately 6 - 12 inches (152 - 304 mm) to the right.



5.4.17



5.4.18

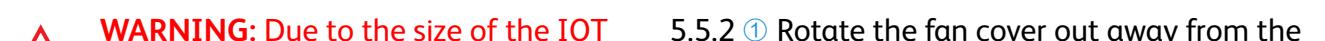
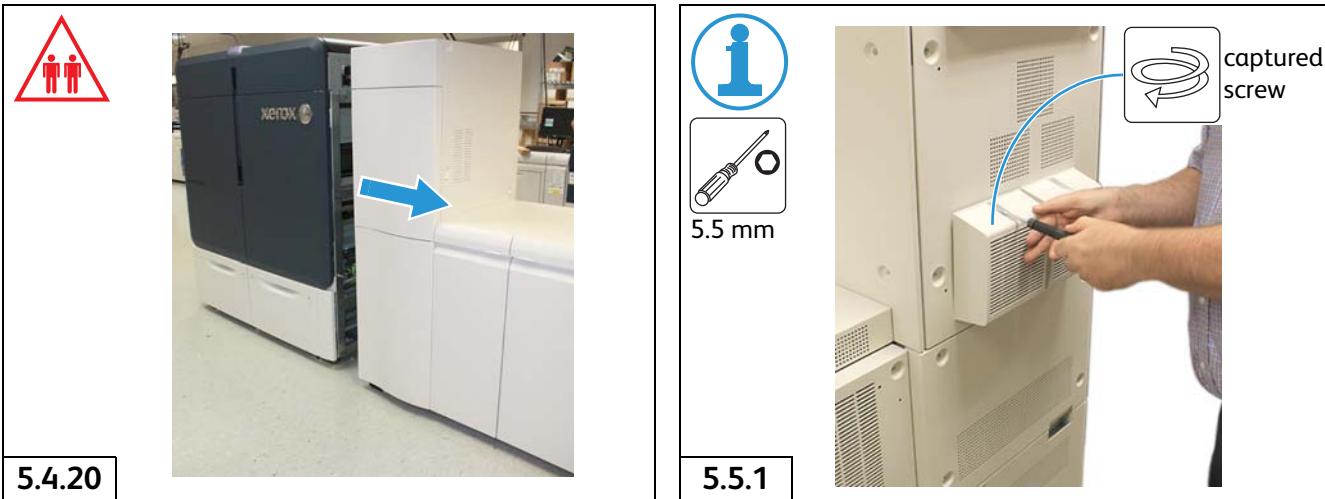
5.4.19

Note: The step stool (497K05860) will be required to remove the communication cables from the top of the IOT Right.

5.4.17 ① Carefully route the six communication cables out from the top of the IOT Right. ② Position the communication cable down along side the IOT Left module.

5.4.18 ① Retrieve the IOT Right top cover and ② four screws set aside earlier.

5.4.19 ① Reinstall the top cover on the IOT Right and ② secure in place with the four original screws.



WARNING: Due to the size of the IOT Right module, two people will be required to undock the IOT Right module from the IOT Left module.

5.4.20 Move the IOT Right away from the IOT Left.

5.5.0 Prepare the IOT Right Module for the Move



Note: The single screw securing each of the fan covers is a captured screw.

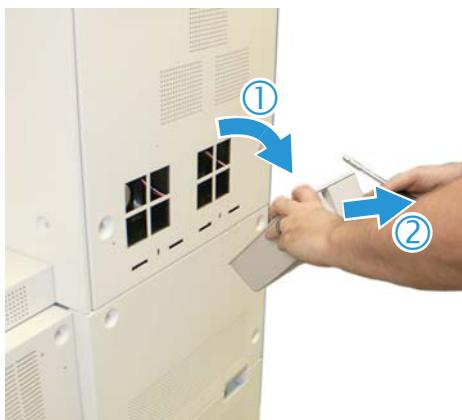
5.5.1 Unscrew the screw within the rear left fan cover.

5.5.2 ① Rotate the fan cover out away from the Right Print module and ② remove the cover from the rear of the module.

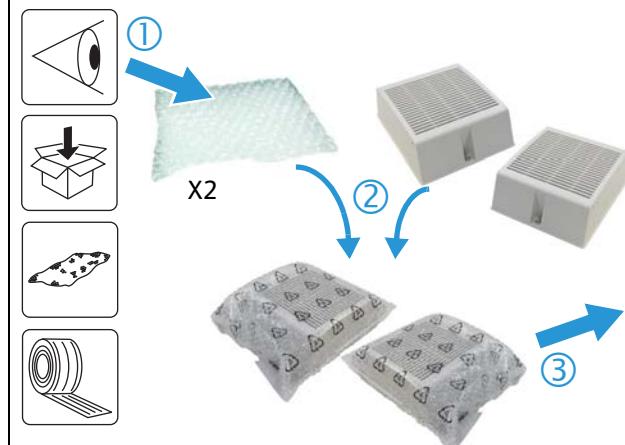


Note: The screw securing the fan cover is a captured screw.

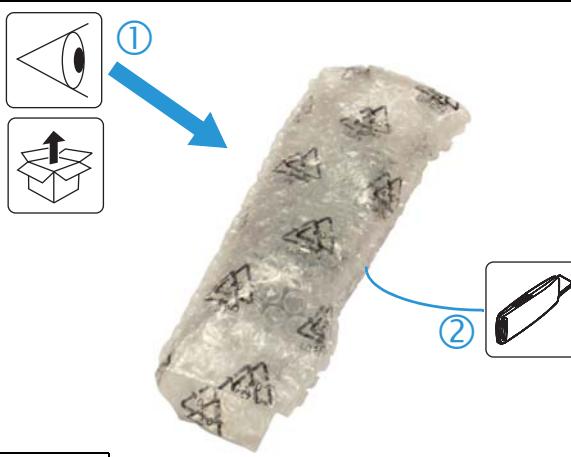
5.5.3 Unscrew the screw within the rear right fan cover.



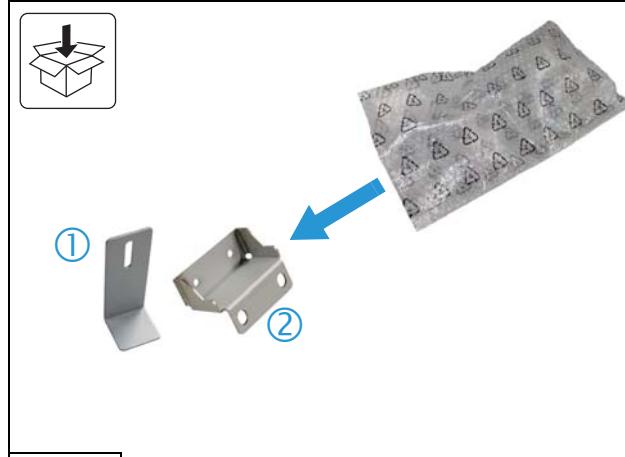
5.5.4



5.5.5



5.5.6



5.5.7

5.5.4 ① Rotate the rear right fan cover out away from the Right Print module and ② remove the cover from the rear of the module.

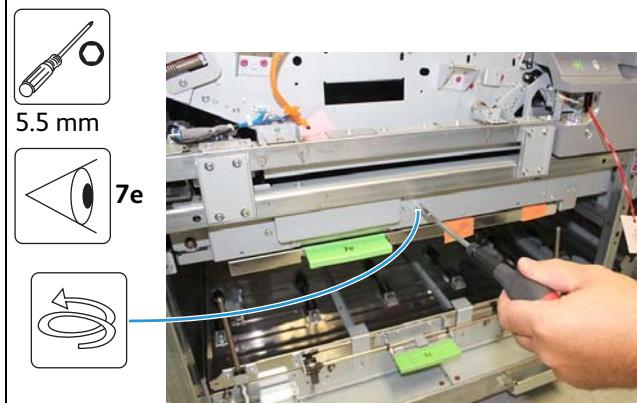
5.5.5 ① Retrieve two pieces of bubble pack and ② wrap the two fan covers separately. ③ Set the two wrapped covers aside.

5.5.6 ① Retrieve the bubble packed bundle removed from the base of the Eco Box / Eco Box 2 assembly earlier. ② Cut the tape securing the bundle.

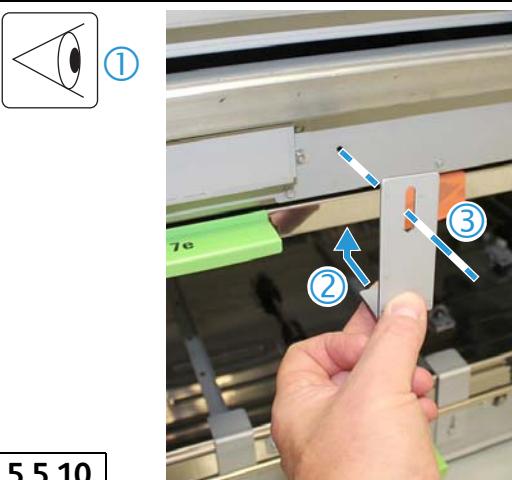
5.5.7 ① Remove the IOT Right front and ② right side shipping brackets.



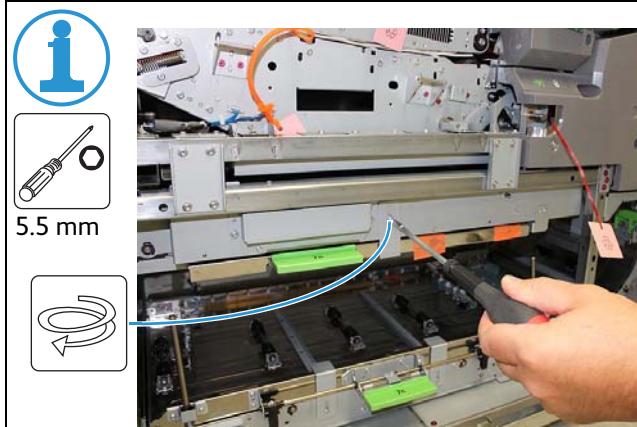
5.5.8



5.5.9



5.5.10



5.5.11

5.5.8 Open the front covers of the IOT Right module.

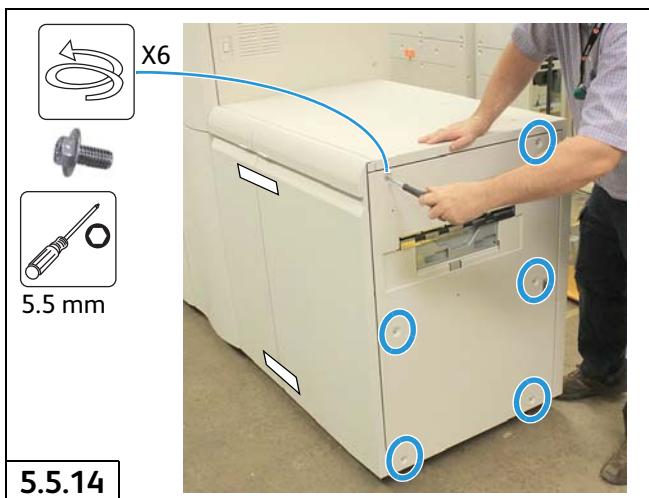
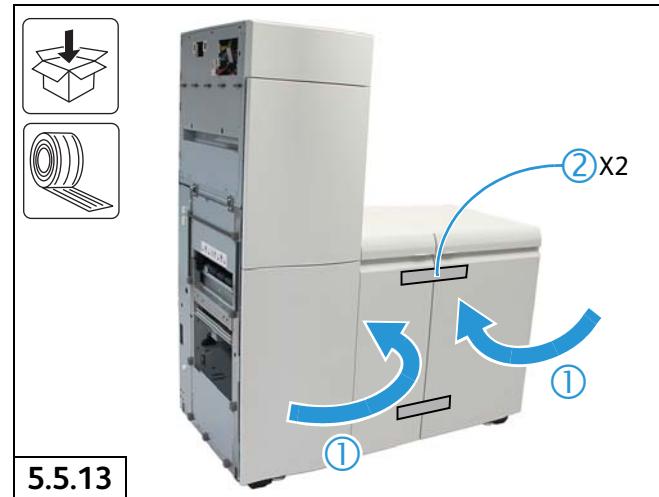
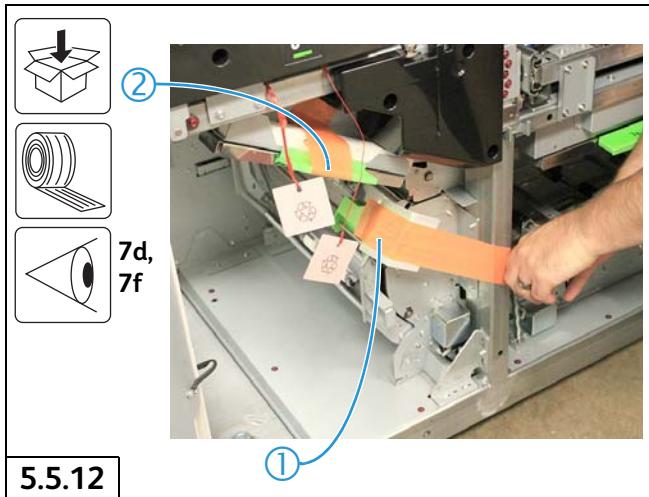
5.5.11 Secure the shipping bracket in place with the single screw that was removed.

5.5.9 Using a 5.5 mm Hex Driver, remove the screw just to the right of baffle 7e.

5.5.10 ① Retrieve the IOT Right front shipping bracket, ② position the bottom lip of the shipping bracket under the 7e baffle and ③ align the slotted hole in the bracket with the hole in the upper portion of the baffle.



Note: Prior to securing the shipping bracket in place, ensure the bottom lip of the bracket is tight up against the baffle frame.

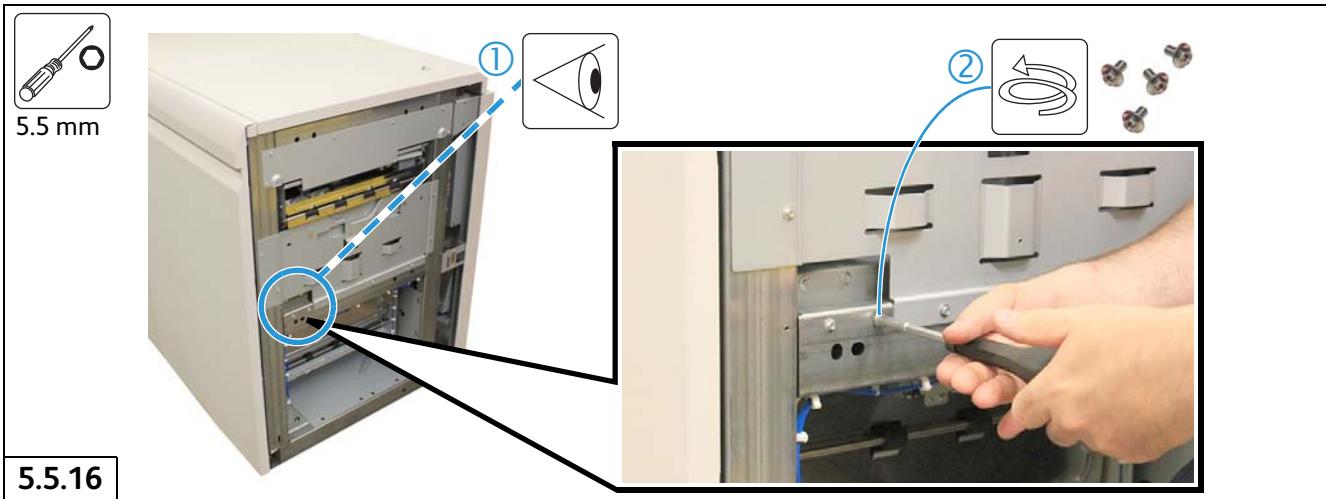


5.5.12 ① Secure baffles 7d and ② 7f closed with tape.

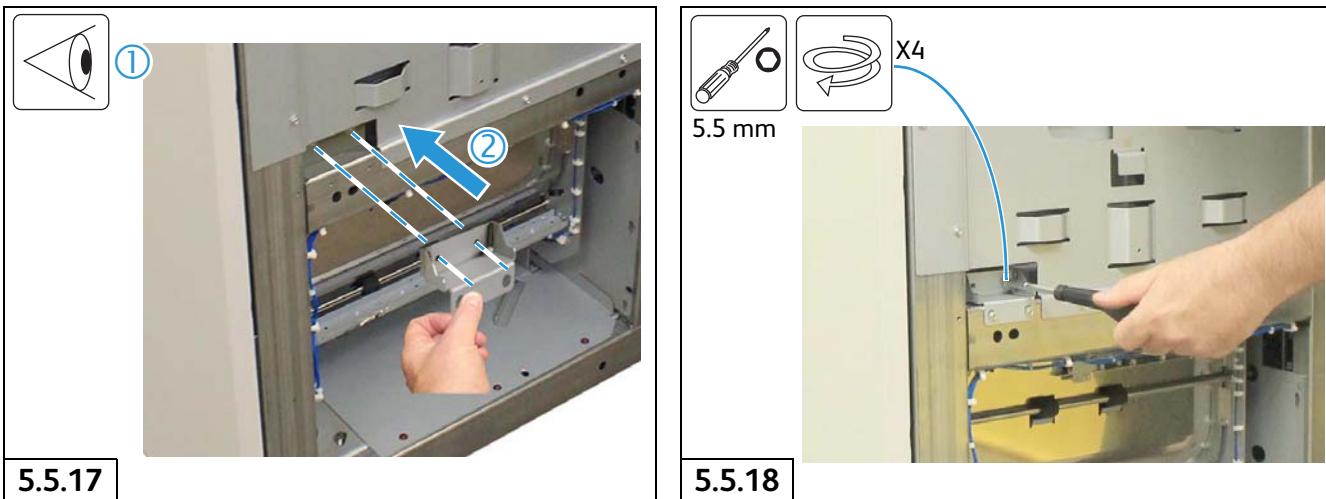
5.5.13 ① Close the IOT Right front covers and ② secure them with tape.

5.5.14 Using a 5.5 mm hex driver, remove the six screws securing the right side cover on the IOT Right.

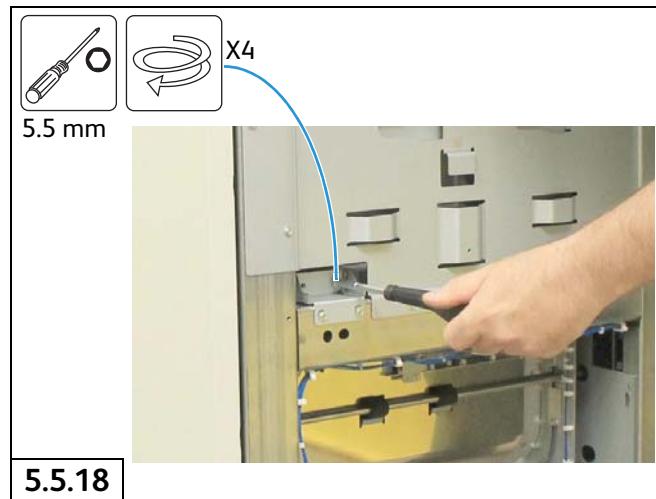
5.5.15 Lift and remove the cover.



5.5.16



5.5.17

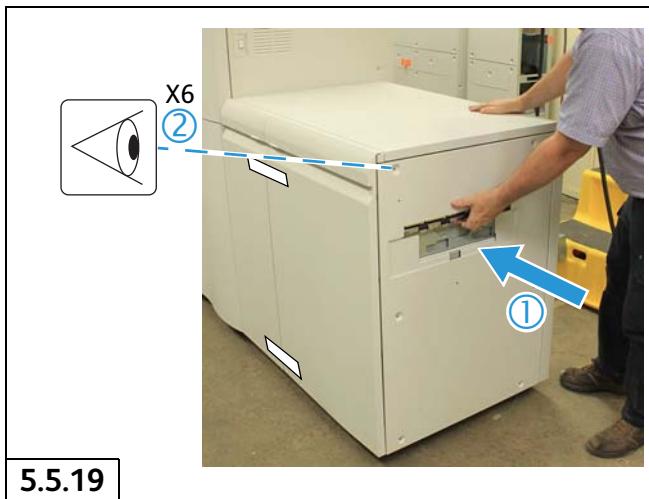


5.5.18

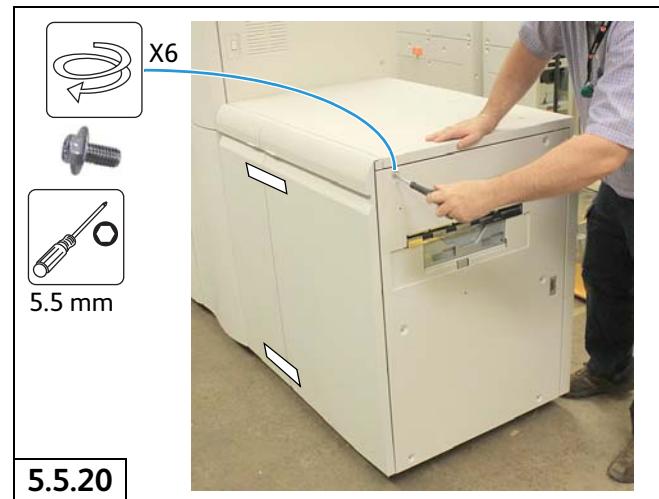
5.5.16 ① Locate and ② remove the four shipping bracket screws from the right side front middle of the IOT Right.

5.5.17 ① Retrieve the right side shipping bracket unpacked earlier and ② position within the recess, aligning the hole in the bracket with the holes in the recess and within the frame member.

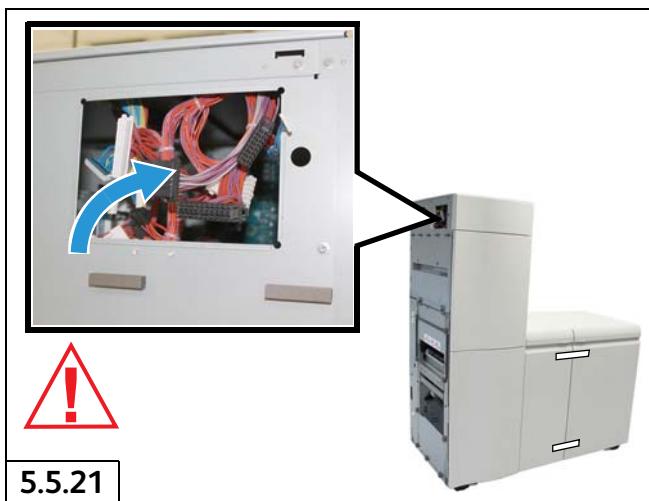
5.5.18 Secure the shipping bracket in place with the four original screws.



5.5.19



5.5.20



5.5.21

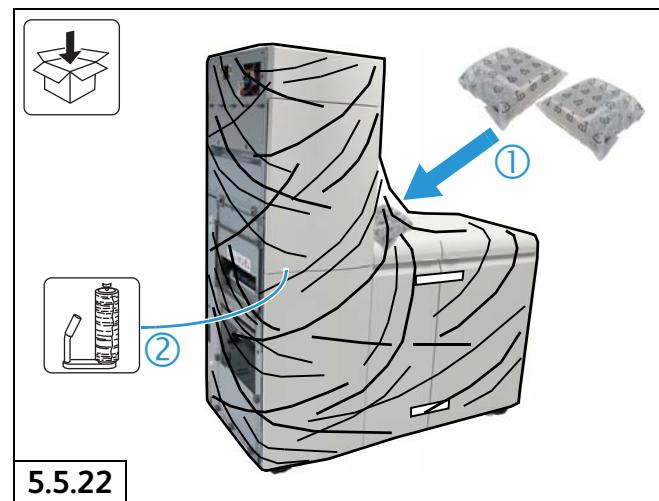
5.5.19 ① Reinstall the right side cover by ② aligning the six screw holes.

5.5.20 Secure the right side cover in place with the six original screws.



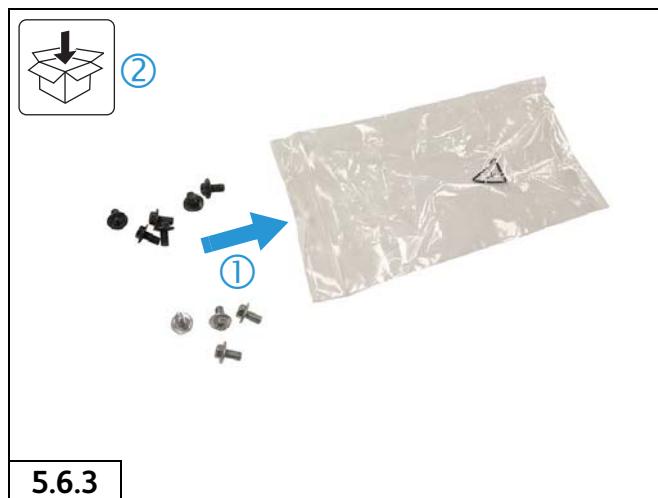
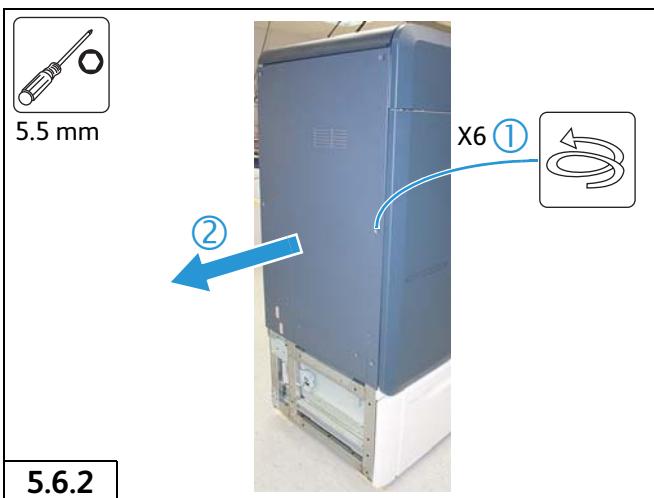
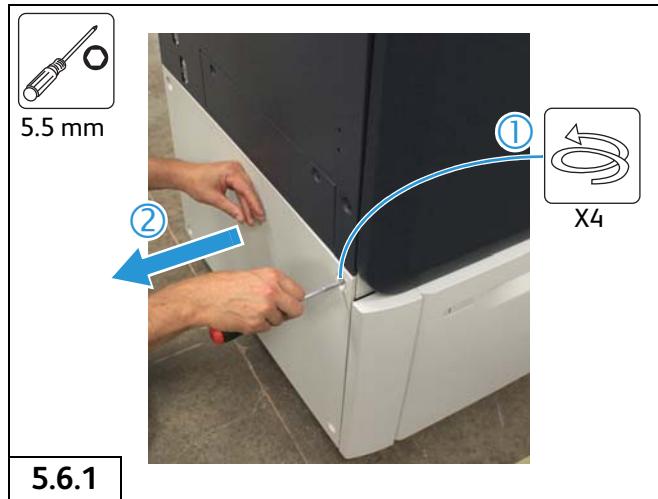
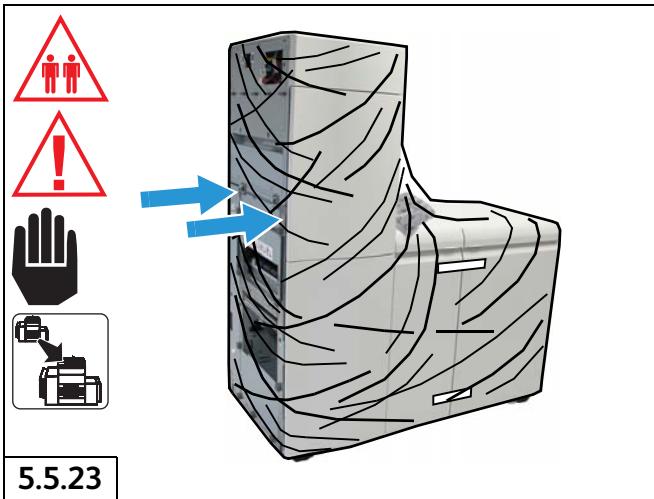
CAUTION: To avoid damage to the cable connectors on the left side top of the IOT Right, position all connector within the opening prior to stretchwrapping the module.

5.5.21 Position all cable connectors within the left side top opening of the IOT Right.



5.5.22

5.5.22 ① Place the two bubblepacked fan covers on top of the IOT Right and ② secure the IOT with a layer of stretchwrap.



WARNING: Due to the size and weight of the IOT Right module, two people are required to move the module.



CAUTION: When moving the IOT Right module, be sure to push on the corner frame members. Do not push on the covers as damage may occur to the covers.

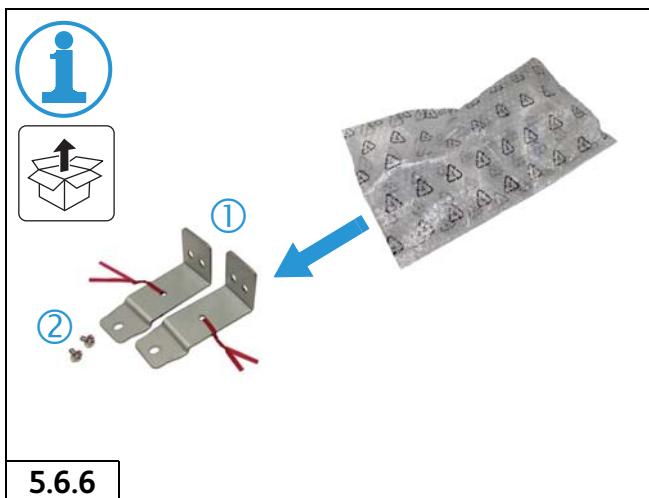
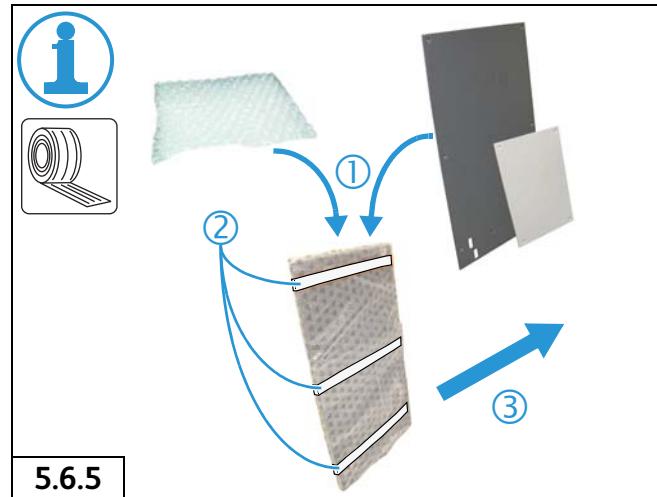
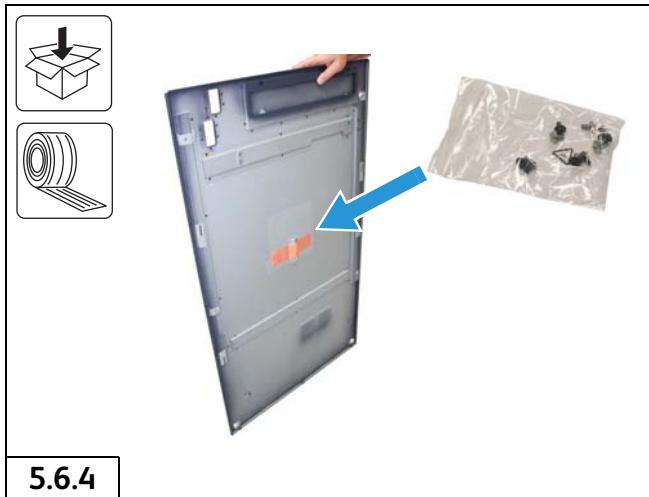
5.5.23 Move the IOT Right module to the new location or truck.

5.6.0 Prepare the IOT Left for the Move

5.6.1 ① Remove the four screws securing the left side bottom cover. ② Remove the cover from the IOT Left.

5.6.2 ① Remove the six screws securing the left side top cover. ② Remove the cover from the IOT Left.

5.6.3 ① Place the 10 screws in a plastic bag and ② seal the bag.



5.6.4 Tape the bag of hardware to the inside surface of the left side top cover.



Note: Ensure there is a layer of bubblepack between the two covers when wrapping the two covers in bubblepack.

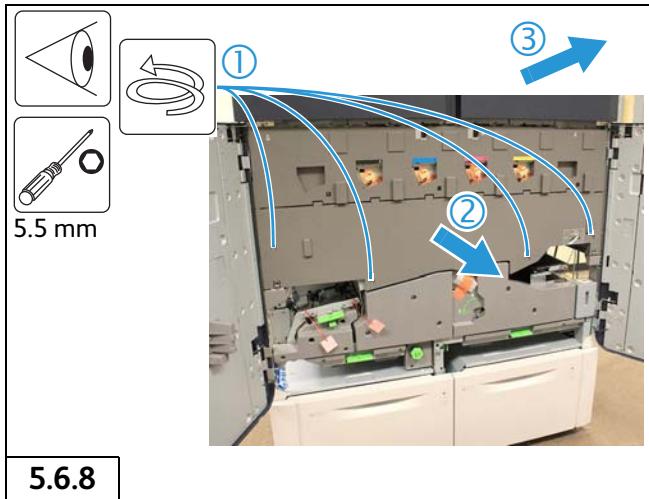
5.6.5 ① Wrap the two left side cover in a layer of bubblepack, ② secure them with tape and ③ then set them aside.



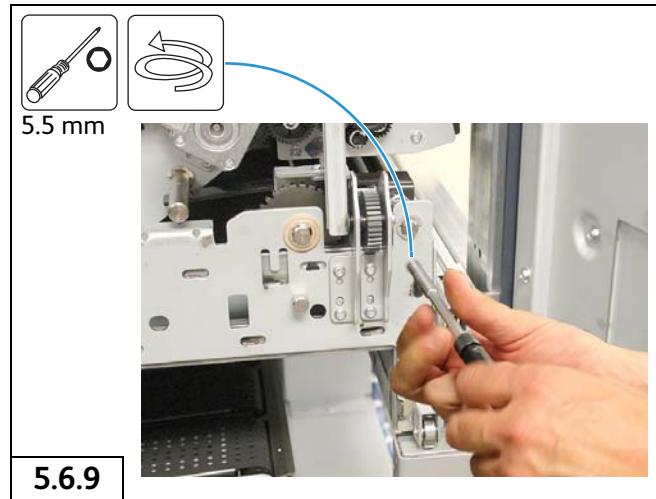
Note: The two screws are to be used with the bracket that will get installed on the front left side of the IOT.

5.6.6 ① Remove the two IOT Left front shipping brackets and ② two screws from the bubblepack bag.

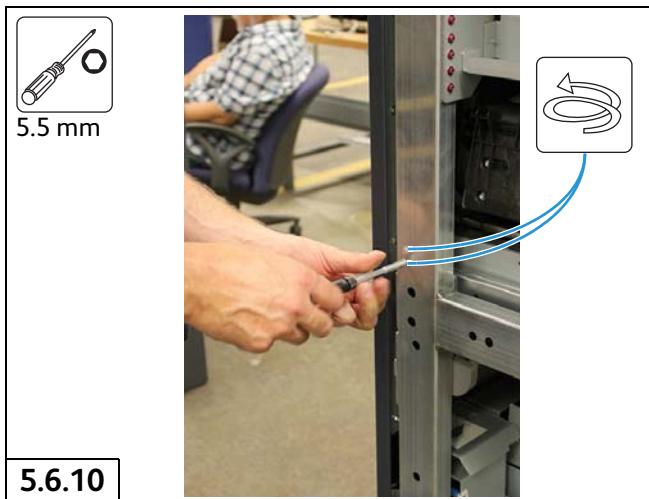
5.6.7 Open the IOT Left front covers.



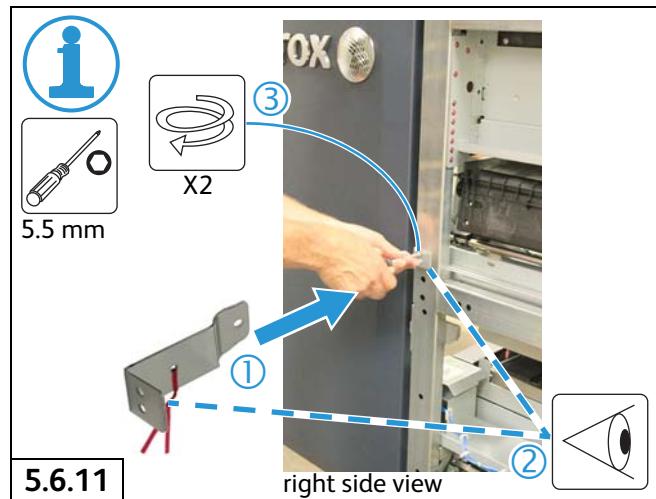
5.6.8



5.6.9



5.6.10



5.6.11

5.6.8 ① Loosen the four captured screws securing the front middle cover. ② Remove and ③ set aside the cover.

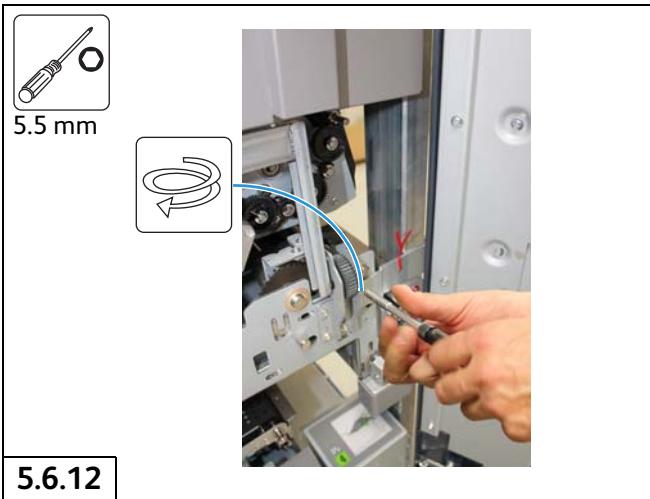
5.6.9 Remove the single screw from the front right side of the IOT.

5.6.10 Using a 5.5 mm hex driver, remove the two screws from the right side front frame.

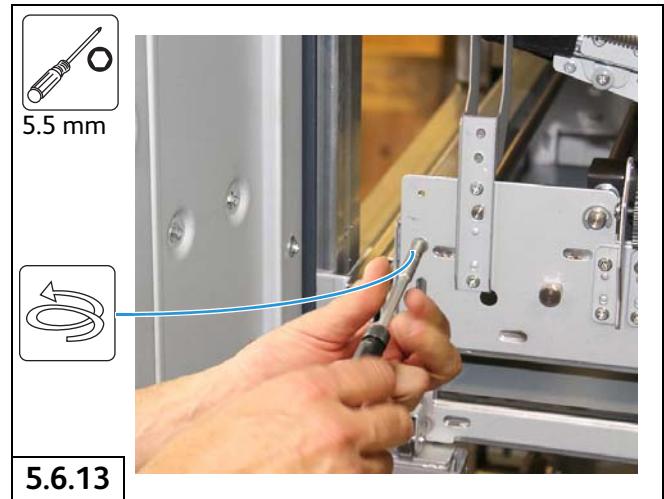


Note: When installing the shipping bracket from the right side of the IOT, the single opening on the end of the bracket should align with the hole in the front of the machine where the screw was just removed from.

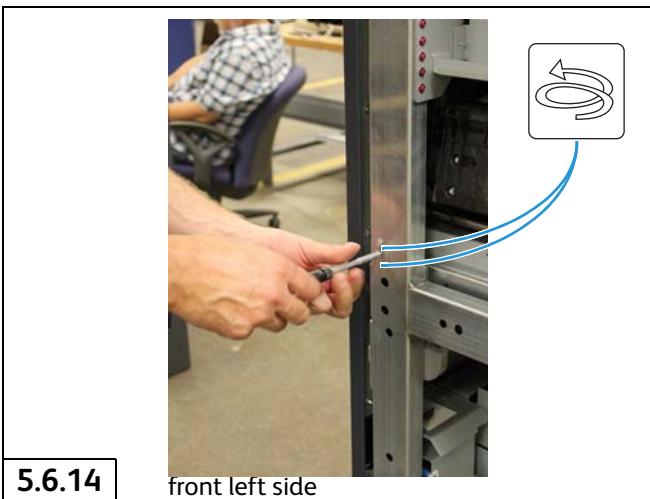
5.6.11 ① Install one of the shipping brackets from the right side front edge of the IOT, behind the front cover. ② Align the two holes in the bracket with the two holes in the IOT right side frame. ③ Secure the bracket with the two screws unpacked with the brackets.



5.6.12

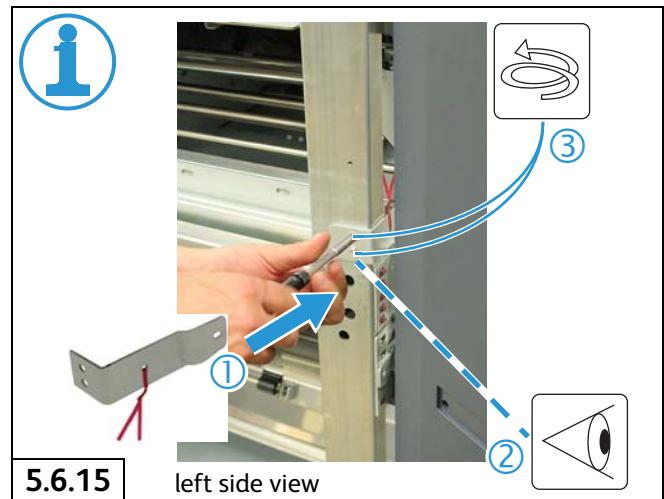


5.6.13



5.6.14

front left side



5.6.15

left side view

5.6.12 Secure the shipping bracket in the front of the IOT with a single screw.

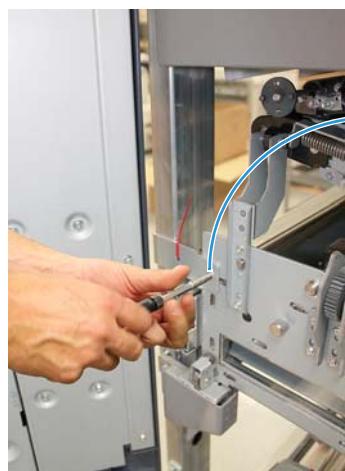
5.6.13 Remove the screw from the front left side of the IOT.

5.6.14 Remove the two screws from the left side front frame member.

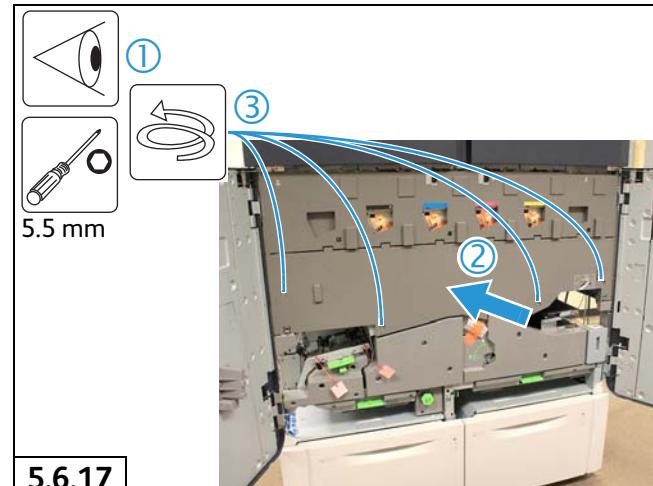
5.6.15 ① Install the remaining shipping bracket from the left side front edge of the IOT behind the front cover so ② the holes within the flange of the bracket align with the holes in the frame member. ③ Secure the bracket with two screws.



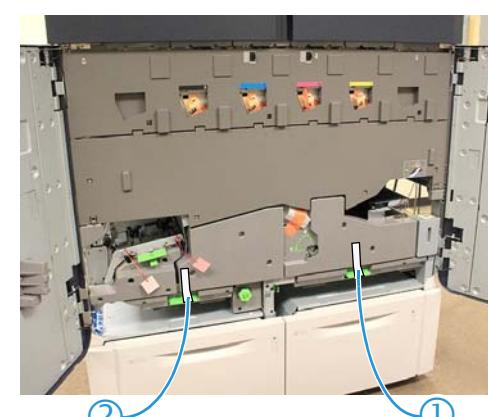
Note: When installing the shipping bracket from the left side of the IOT, the single opening on the end of the bracket should align with the hole in the front of the machine where the screw was just removed.



5.6.16



5.6.17



5.6.18



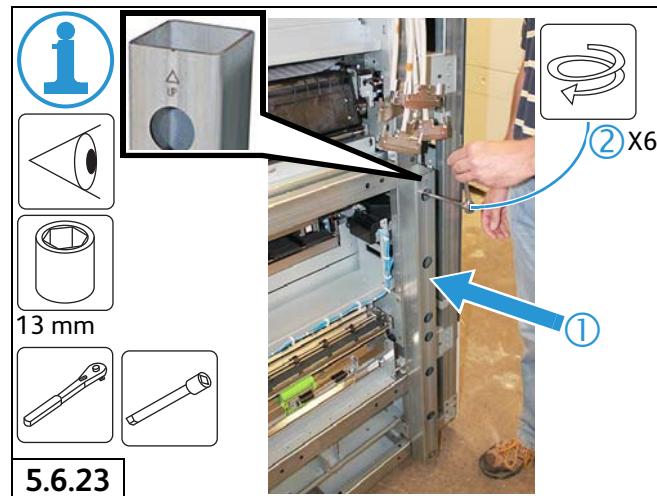
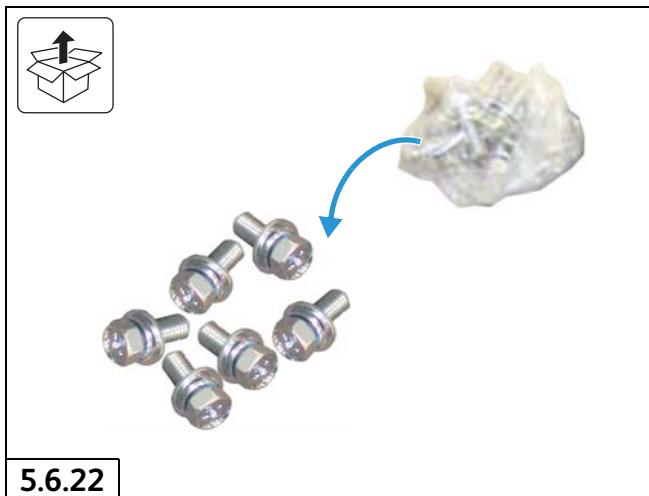
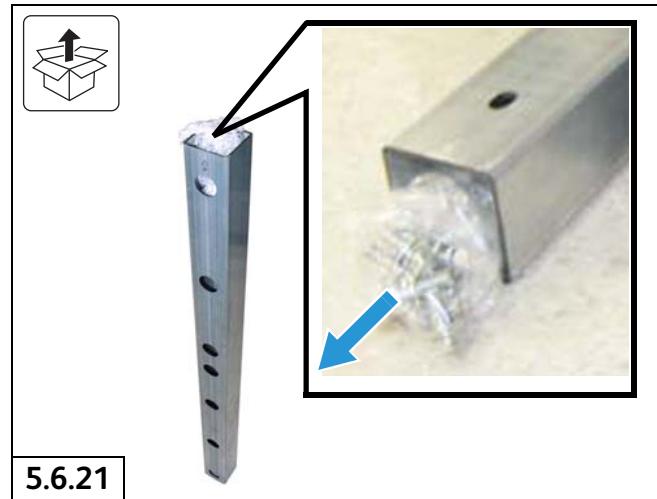
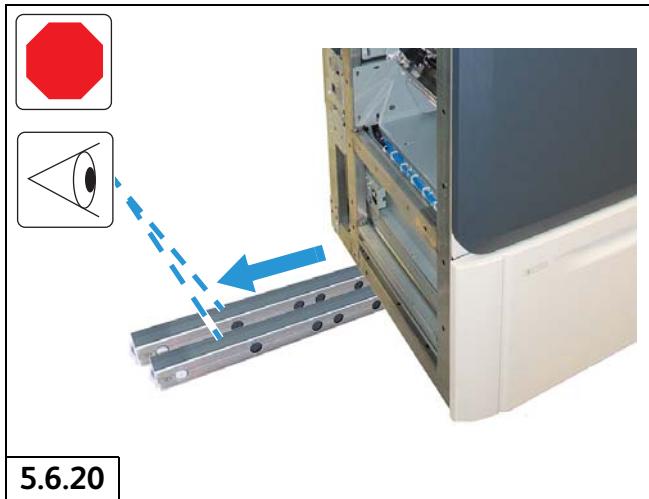
5.6.19

5.6.16 Secure the shipping bracket in the front of the IOT with a single screw.

5.6.17 ① Secure paper baffles 2a and ② 2d with a piece of tape.

5.6.18 ① Retrieve and ② reinstall the front middle cover. ③ Secure the cover in place by securing the four captured screws.

5.6.19 Close the IOT left front covers.



Stop: If the two shipping support bars are not under the IOT Left module, ask the Customer for help locating them so they can be reinstalled before moving the IOT.

5.6.20 Remove the two shipping support bars from under the IOT Left.

5.6.21 Remove the packed hardware from within the end of the shipping bar.

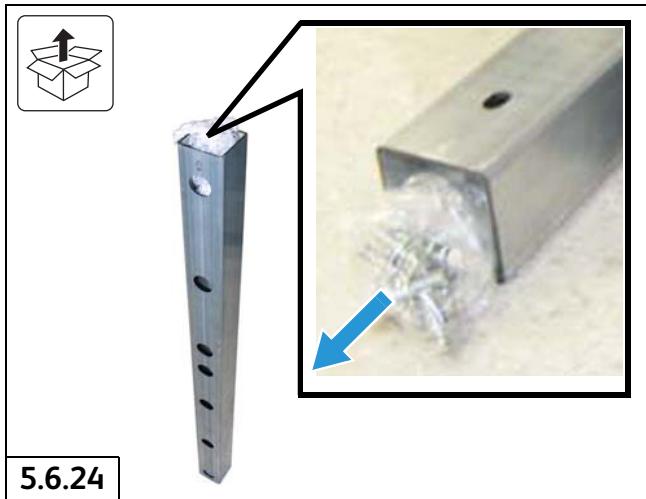
5.6.22 Remove the hardware from the packaging.



Note: When reinstalling the shipping support bars on the left and right sides of the IOT Left, ensure the triangle with the

word UP is positioned on the top outside of each of the two shipping bars.

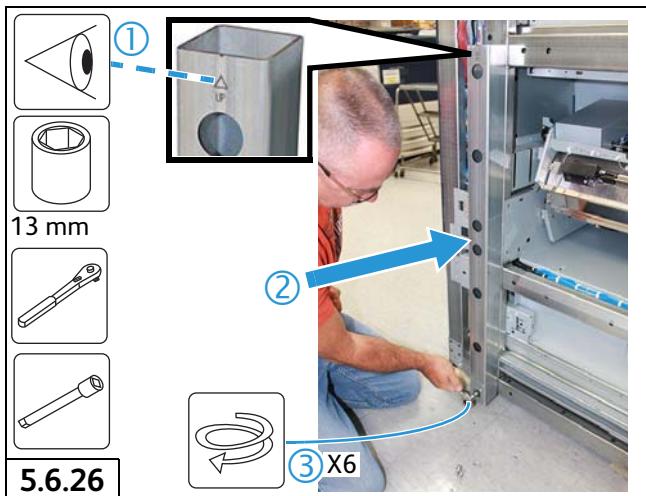
5.6.23 ① Position the shipping bar accordingly, aligning the holes within the bar with the holes in the IOT right side rear frame. **②** Secure the shipping bar to the frame using the six bolts.



5.6.24



5.6.25



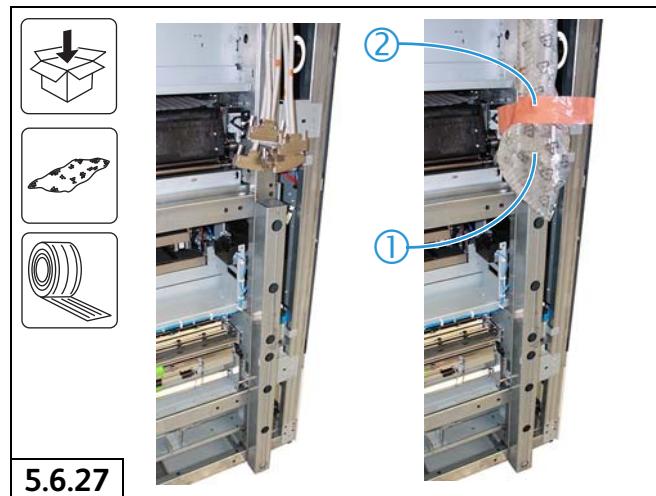
5.6.26

5.6.24 Remove the packed hardware from within the end of the shipping bar.

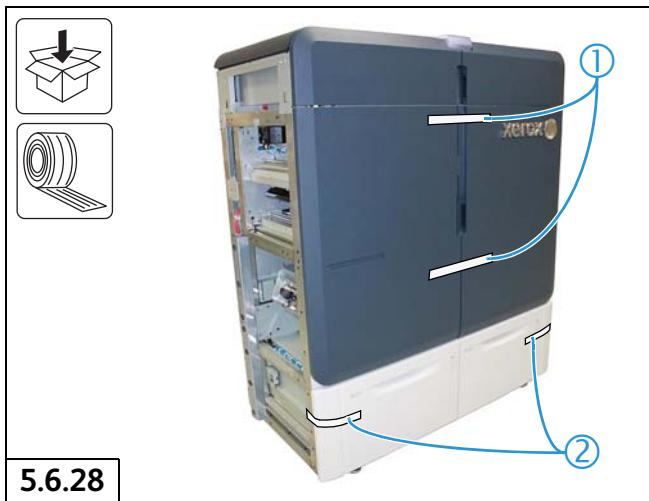
5.6.25 Remove the hardware from the packaging.

5.6.26 ① Ensuring the arrow is located at the top when the shipping bar is installed, ② position the shipping bar accordingly, aligning the holes within the bar with the holes in the IOT left side rear frame. ③ Secure the shipping bar to the frame using the six bolts.

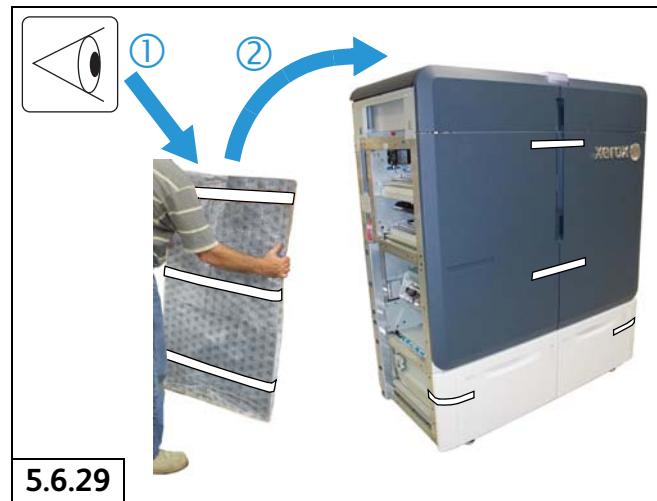
5.6.27 ① Wrap the communication cables on the right rear side of the IOT in a layer of bubblepack. ② Then, secure the cables to the side of the IOT with a piece of tape.



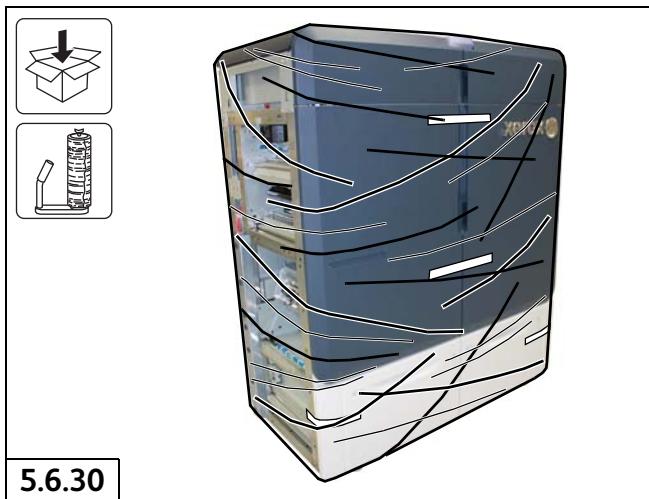
5.6.27



5.6.28



5.6.29

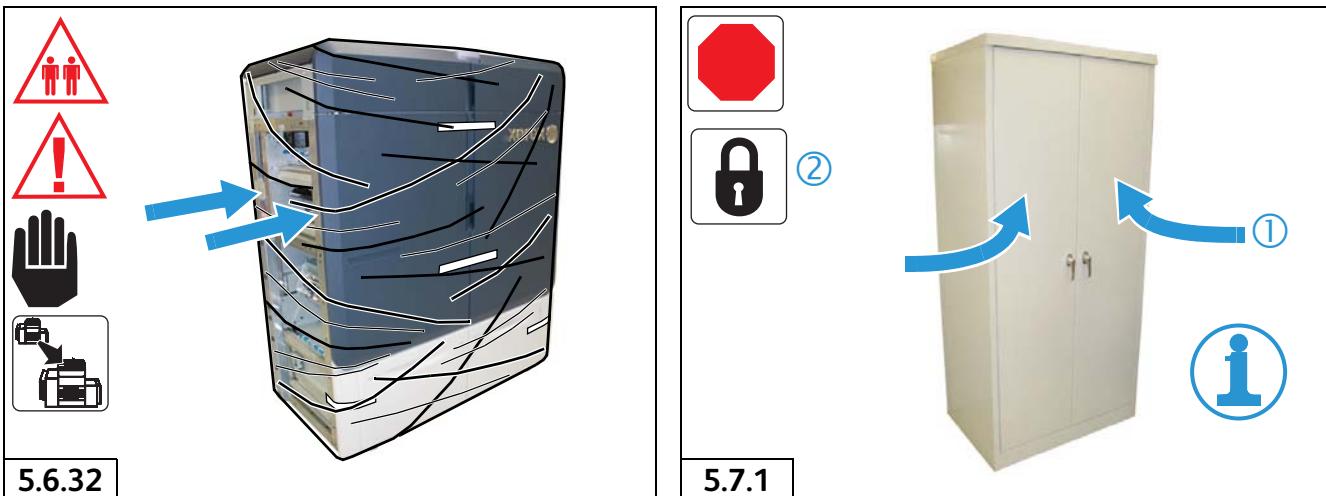
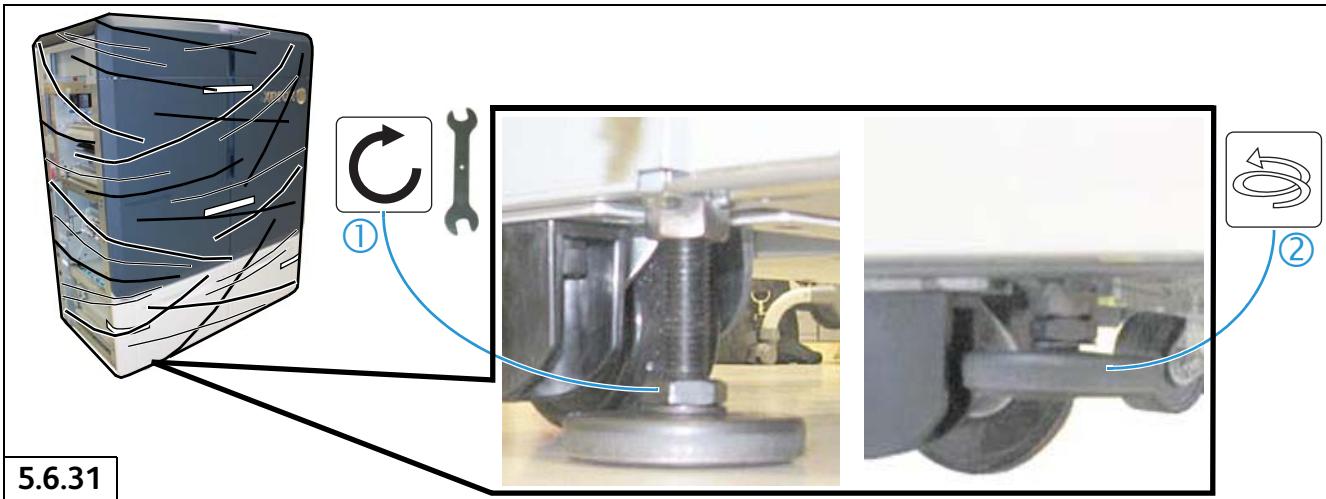


5.6.30

5.6.28 ① Secure the IOT Left front covers and
② paper trays with tape.

5.6.29 ① Retrieve the bubblepacked left side cov-
ers and ② place them on top of the IOT Left.

5.6.30 Secure the IOT Left with a layer of
stretchwrap.



5.6.31 Using the smaller wrench that was shipped with the system, ① loosen the nut on the top of the six leveling pads and ② raise the pads hand-tight up to the IOT frame.



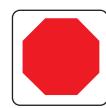
WARNING: Due to the size and weight of the IOT Left module, two people are required to move the module.



CAUTION: When moving the IOT Left module, be sure to push on the corner frame members. Do not push on the covers as damage to the covers may occur.

5.6.32 Move the IOT Left module to the new location or truck.

5.7.0 Relocating the Parts Cabinet

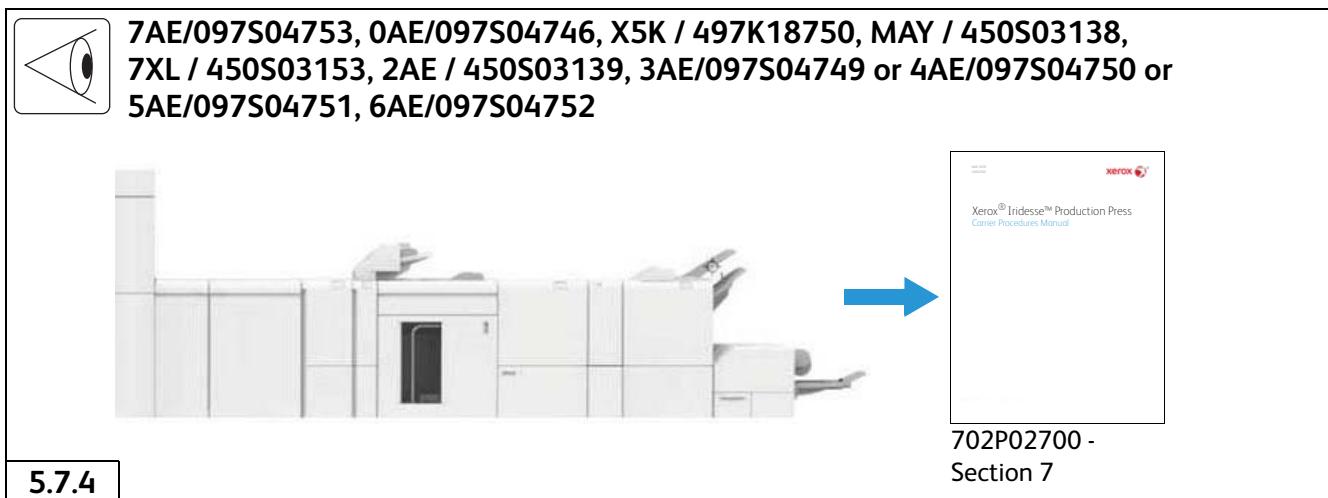
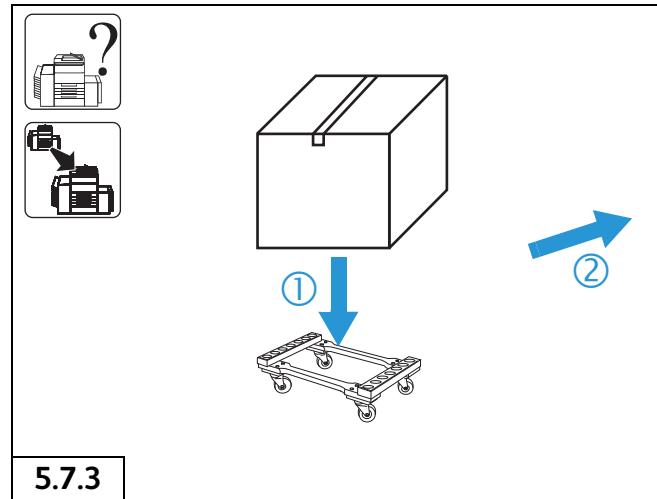
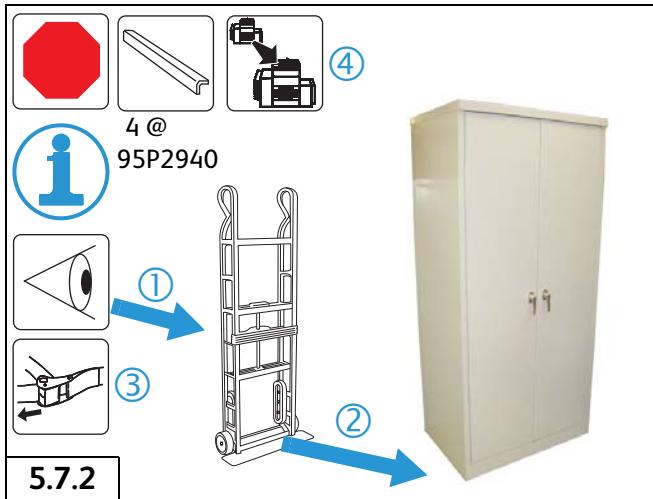


Stop: The CSE will be responsible for removing and packing all consumables and items within the parts cabinet.



Note: Leave the keys in the door while moving the cabinet to the new location.

5.7.1 If required, ① close and ② lock the doors on the parts cabinet.



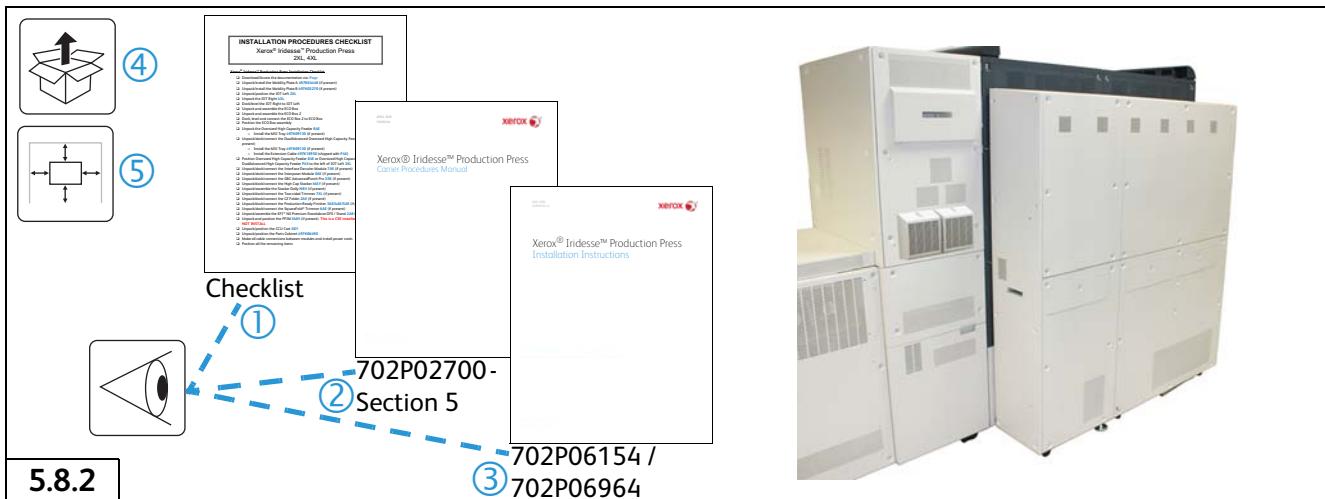
Stop: Ensure that extra care is taken when tipping and moving the cabinet to the new install location. The shelves inside the cabinet are not secured in place and may fall off the clips or may become unstable when moving.

Note: Ensure that excessive tension is not used when strapping the parts cabinet(s) to the appliance dolly. Keep cabinet in upright position at all times.

5.7.2 ① Retrieve an appliance dolly and ② position it under the left or right side of the cabinet. ③ Strap the parts cabinet to the dolly using corner boards (95P2940) on all four corners. ④ Move the parts cabinet to the new location.

5.7.3 ① Place the box(es) containing the items removed from the parts cabinet on a dolly and ② move them to the new install location.

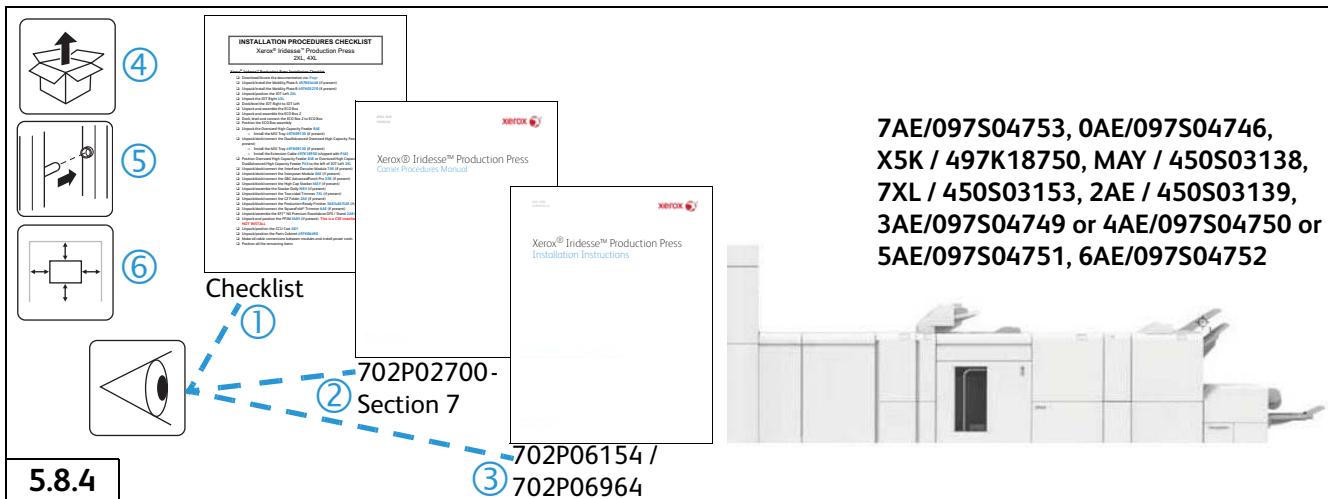
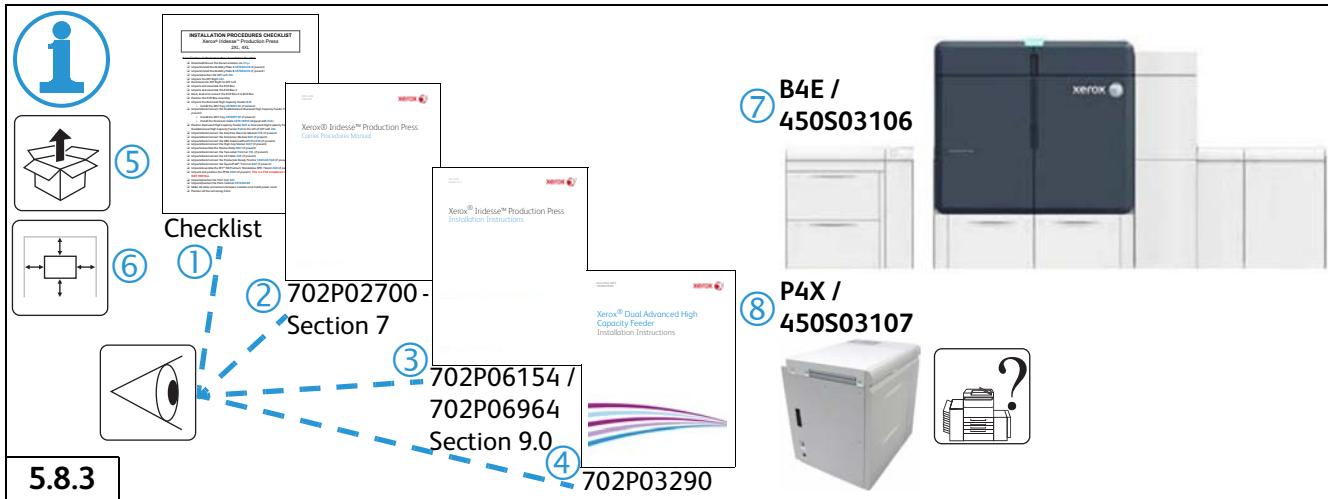
5.7.4 For the preparation of any optional accessory, refer to Section 7 within this manual.



5.8.0 Repositioning and Docking the System

5.8.1 ① Refer to the Xerox® Iridesse™ Checklist, ② Xerox® Iridesse™ Production Press Carrier Procedures Manual (CM02700), Section 5 and ③ the Xerox® Iridesse™ Production Press Install Instructions (702P06154 / 702P06964) to ④ unpack, ⑤ position and ⑥ dock the IOT Right module to the IOT Left module.

5.8.2 ① Refer to the Xerox® Iridesse™ Checklist, ② Xerox® Iridesse™ Production Press Carrier Procedures Manual (CM02700), Section 5 and ③ the Xerox® Iridesse™ Production Press Install Instructions (702P06154 / 702P06964) to ④ unpack and ⑤ position the Eco Box / Eco Box 2 assembly in the rear of the IOT Left module.

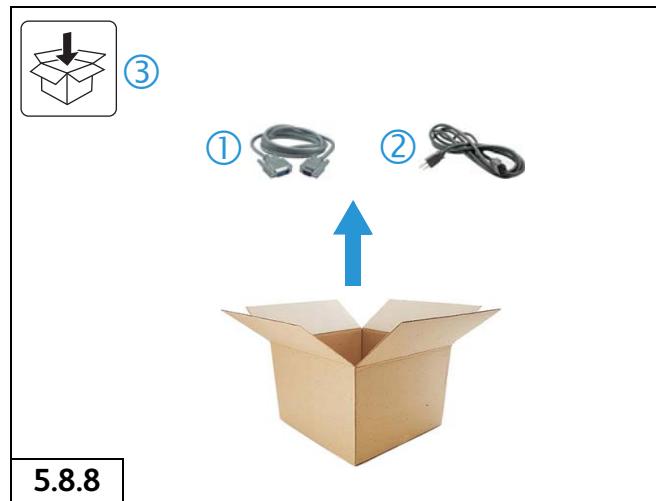
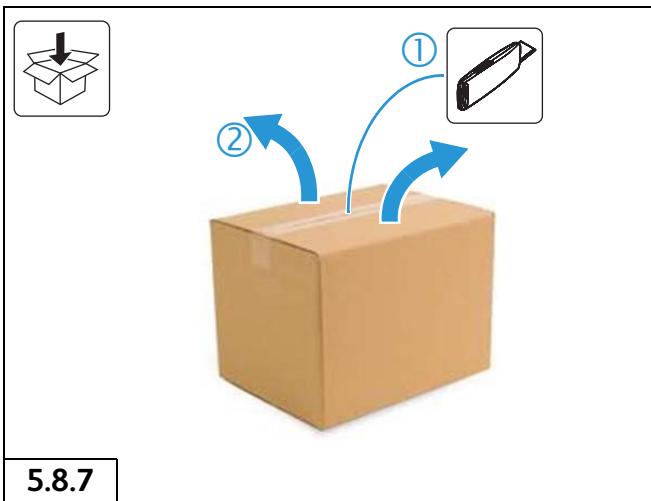
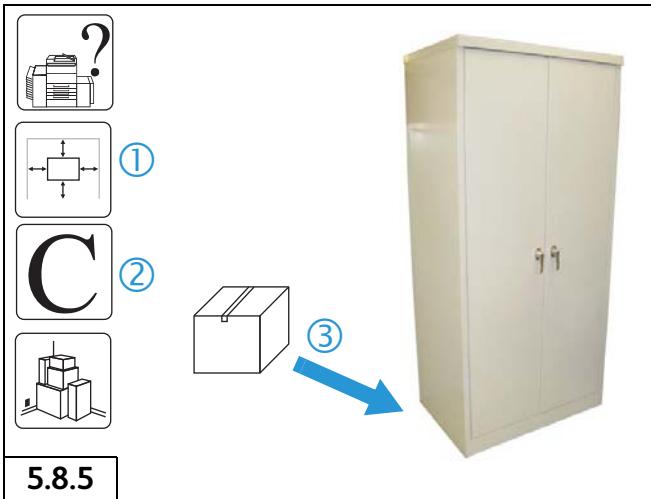


i Note: The Oversize High Capacity Feeder (B4E / 450S03106) is part of the base configuration and will be present at every install. The Dual Advanced High Capacity Feeder (P4X / 450S03107) is an optional accessory and may be present on any install.

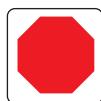
5.8.3 ① Refer to the Xerox® Iridesse™ Checklist, ② Xerox® Iridesse™ Production Press Carrier Procedures Manual (CM02700) - Section 7, ③ the Xerox® Iridesse™ Production Press Install Instructions (702P06154 / 702P06964) - Section 9.0 and the ④ Xerox® Dual Advanced High Capacity Feeder Install Instructions (702P03290), if required, to ⑤ unpack and ⑥ position the ⑦ Oversize High Capacity Feeder (B4E / 450S03106) and

⑧ the Dual Advanced High Capacity Feeder (P4X / 450S03107) if present.

5.8.4 ① Refer to the Xerox® Iridesse™ Checklist, ② Xerox® Iridesse™ Production Press Carrier Procedures Manual (CM02700), Section 5 and ③ the Xerox® Iridesse™ Production Press Install Instructions (702P06154 / 702P06964) to ④ unpack, ⑤ dock and/or ⑥ positioning all of the remaining optional accessories, if present.



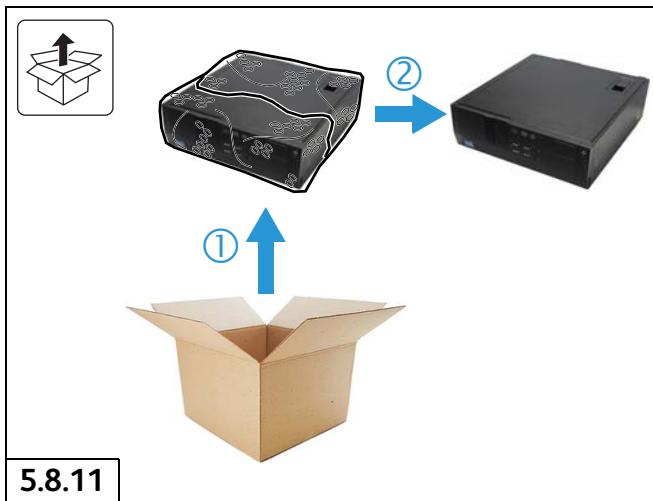
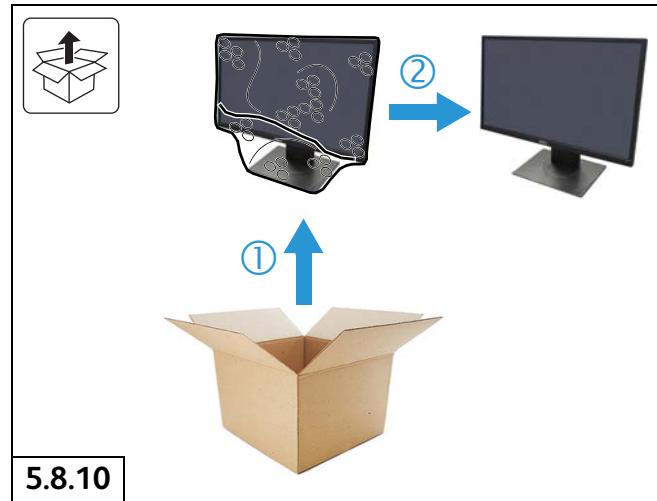
5.8.5 ① Position the parts cabinet according to site template or ② per Customer request. ③ Then, position the box(es) containing items removed from the cabinet on the floor next to the cabinet.



Stop: It is the responsibility of the CSE to make all connections and get the PC UI up and running.

5.8.6 ① If the system move is within the same building, ② place the PC UI controller, ③ monitor, ④ keyboard, ⑤ mouse, and ⑥ cables on the floor next to the system for the CSE.

5.8.7 If PC UI was packed up for the move, ① cut and ② open the packed box.

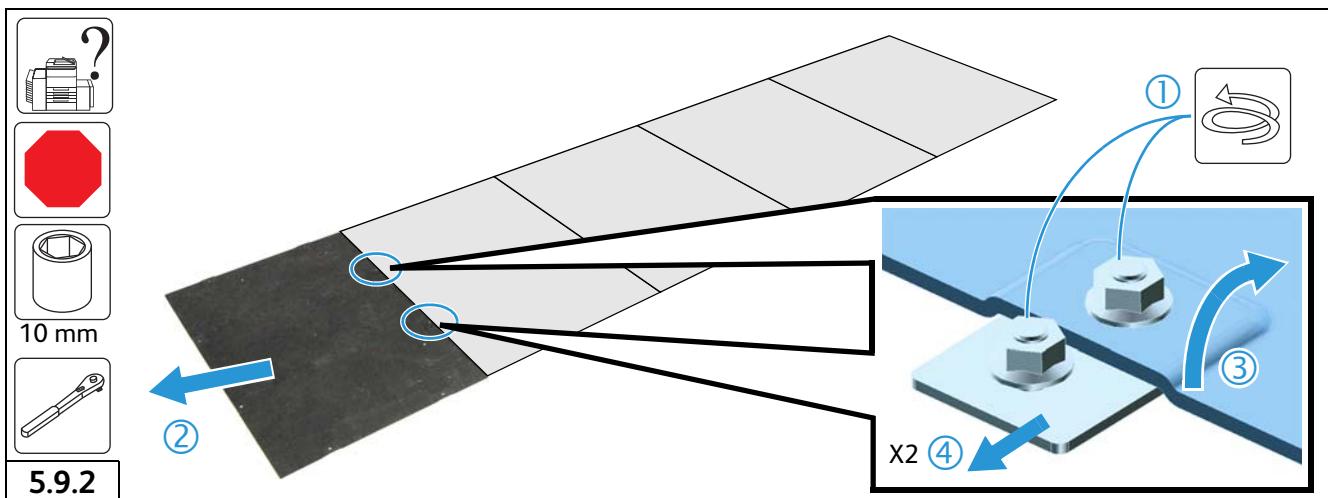
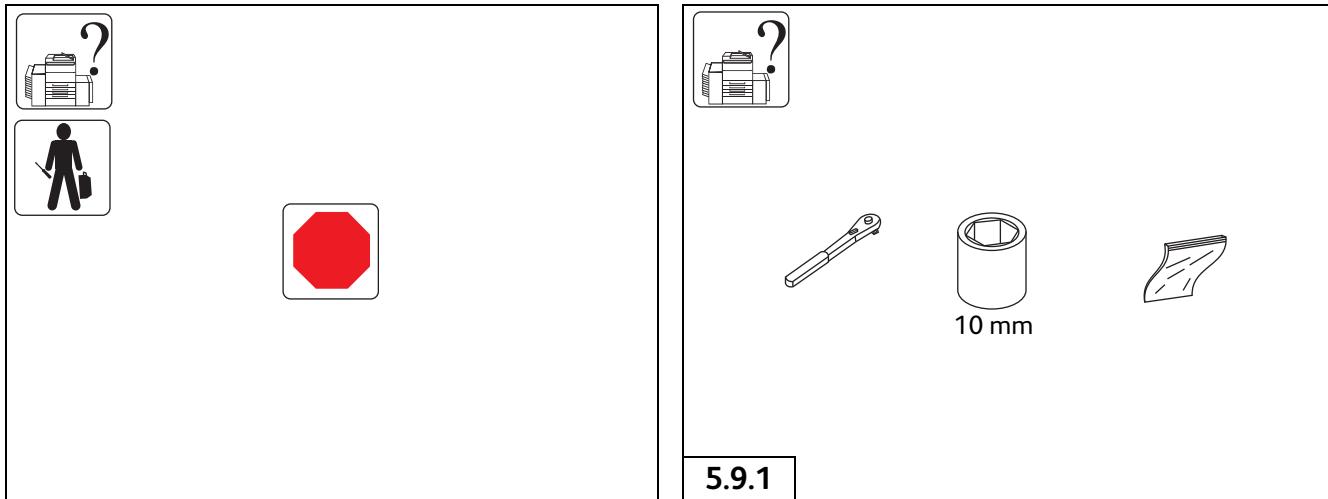


5.8.9 ① Remove the keyboard and ② the mouse from the box.

5.8.10 ① Remove the monitor from the box and ② unpack the monitor from the bubblepack.

5.8.11 ① Remove the PC UI from the box and ② unpack the PC UI from the bubblepack.

5.8.12 ① Place the PC UI controller, ② monitor, ③ keyboard, ④ mouse, and ⑤ cables on the floor next to the system. ⑥ It is the responsibility of the CSE to make all connections and get the PC UI up and running.



Stop: If there are no accessories present the relocation of the Xerox® Iridesse™ Production Press base system is complete. It will be the responsibility of the CSE to complete the installation of the modules and get the system up and running.

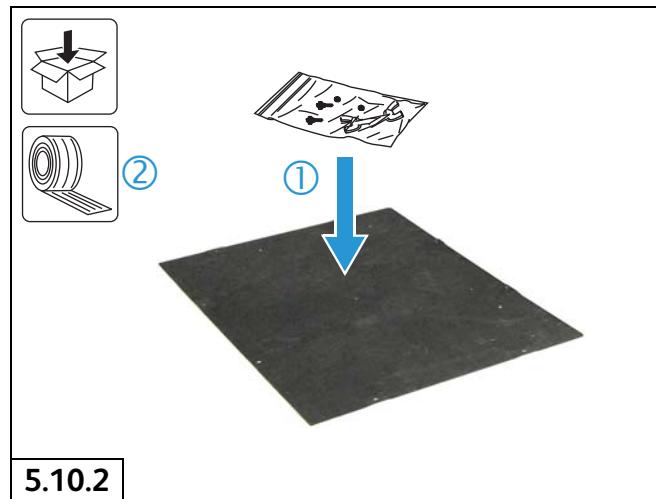
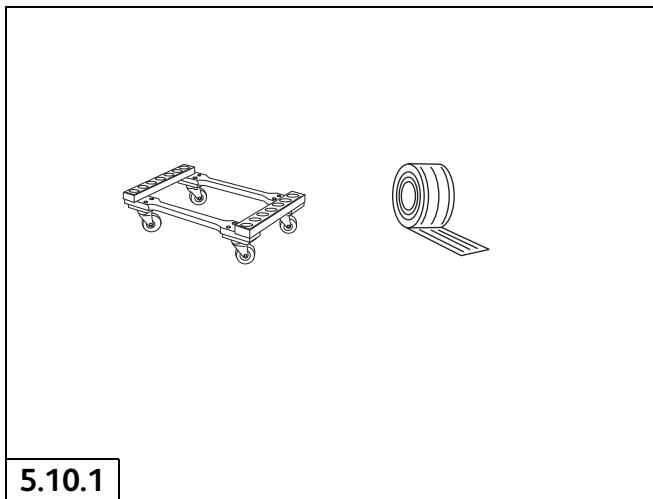
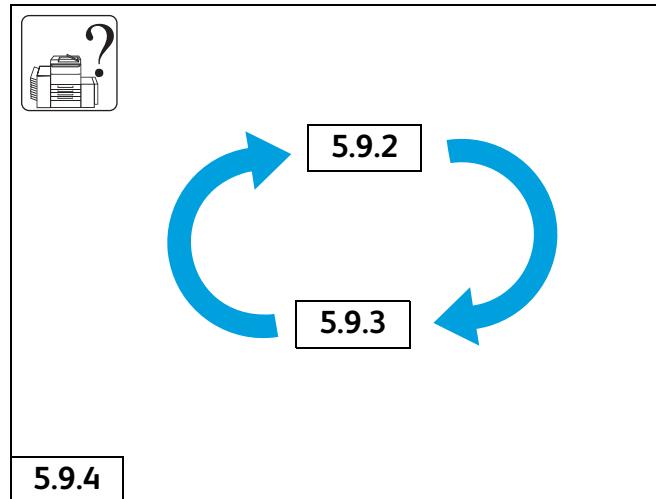
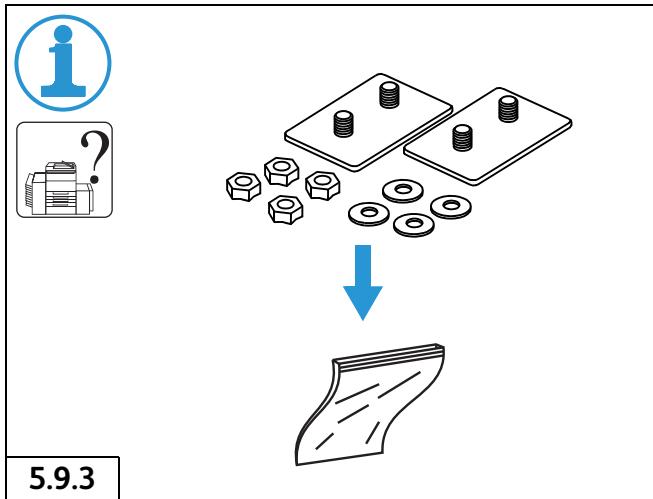
5.9.0 Disconnect and Undock Mobility Plates (497K05270) (if present)

5.9.1 Tools and material required to disconnect and undock the mobility plates.

Stop: If mobility plates are present, there is a minimum of five plates which covers the base configuration. If accessories are present, depending on which configuration is

present, an additional three or more mobility plates may be present.

5.9.2 ① Remove the nuts (2) from each of the bracket assemblies (2) connecting two of the plates together. ② Disconnect mobility plate. ③ Lift the edge of the next mobility plate and ④ remove the two plate docking brackets.



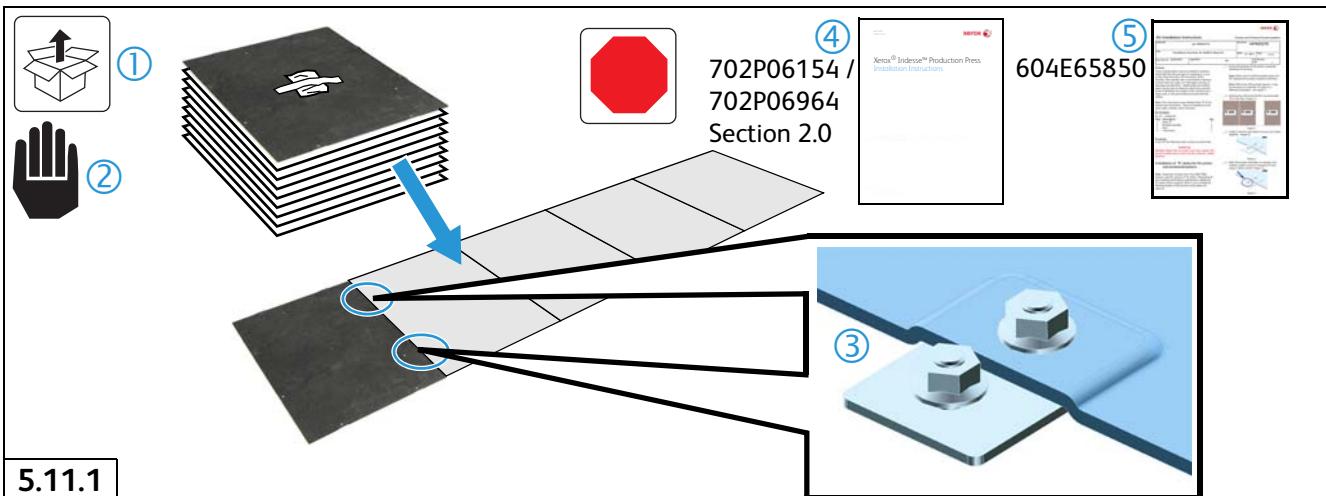
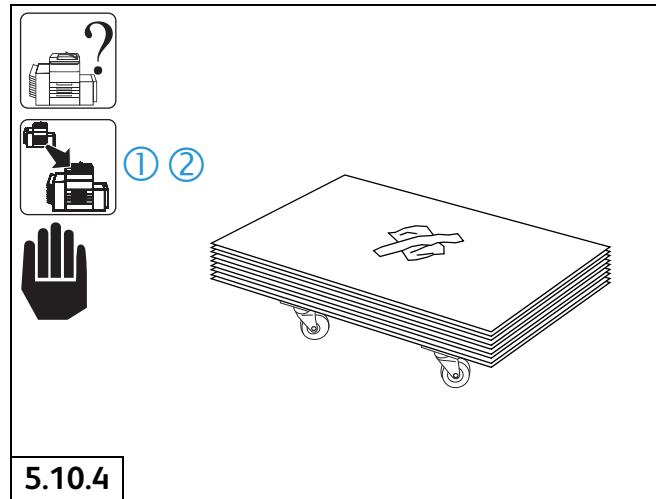
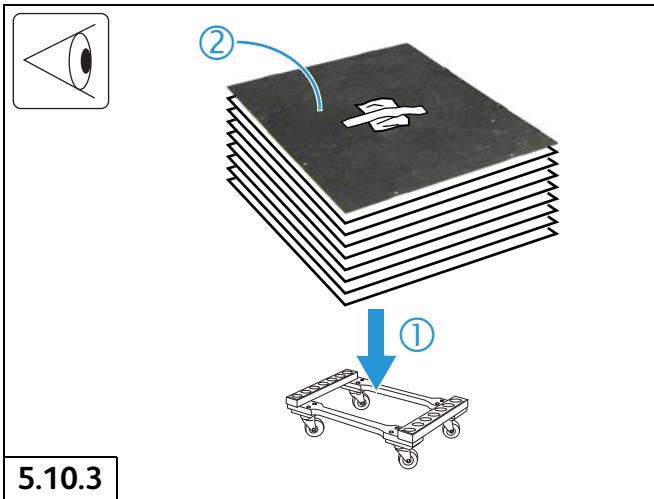
i Note: Depending upon the configuration there may be several mobility plates present. Ensure that all brackets and hardware are placed inside the plastic bag.

5.9.3 Retrieve a plastic bag and place hardware into the bag.

5.9.4 Repeat steps 5.9.2 and 5.9.3 for all remaining mobility plates.

5.10.0 Prepare Mobility Plates for the Move (497K05270) (if present)

5.10.1 Tool and material needed to move the mobility plates.



5.10.3 ① Stack the mobility plates on top of the dolly. ② Place the plate with the taped bag of hardware on top of the stack.

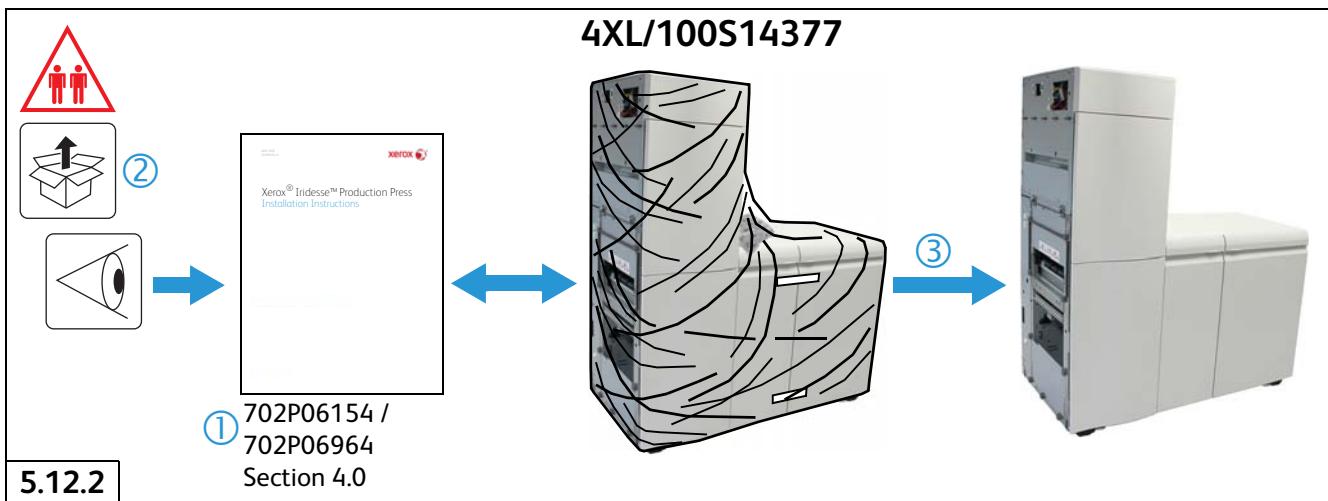
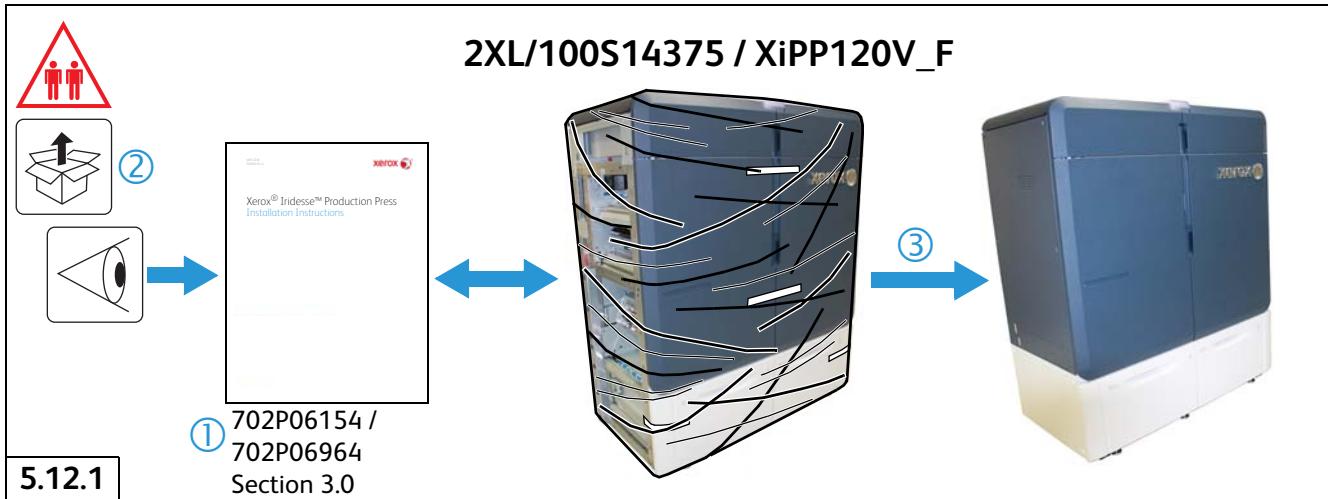
5.10.4 ① Move the mobility plates to the new install location or ② to the truck.

5.11.0 Reinstall Mobility Plates (497K05270) (if present)

Stop: If "B" Plates are present, there are several machine configurations that potentially could be present. Refer to the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964), found packed in the Nationalization Kit (650S42520 XC / 650S4253X/650S4254X XE) or refer to the

mobility plate placement instructions (604E65850) found packed in the Common Mobility Plate "B" Kit (497K05270).

5.11.1 If present, ① unpack, ② position, and ③ assemble mobility plates according to ④ Section 2.0 of the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and/or ⑤ installation instructions (604E65850) from Mobility Plates Kit (497K05270).



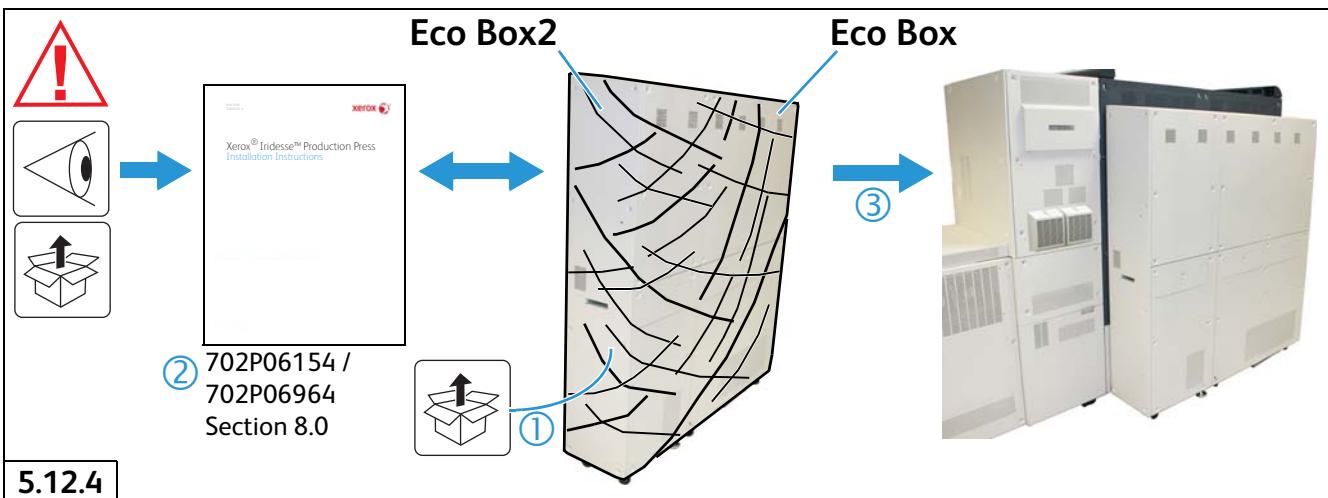
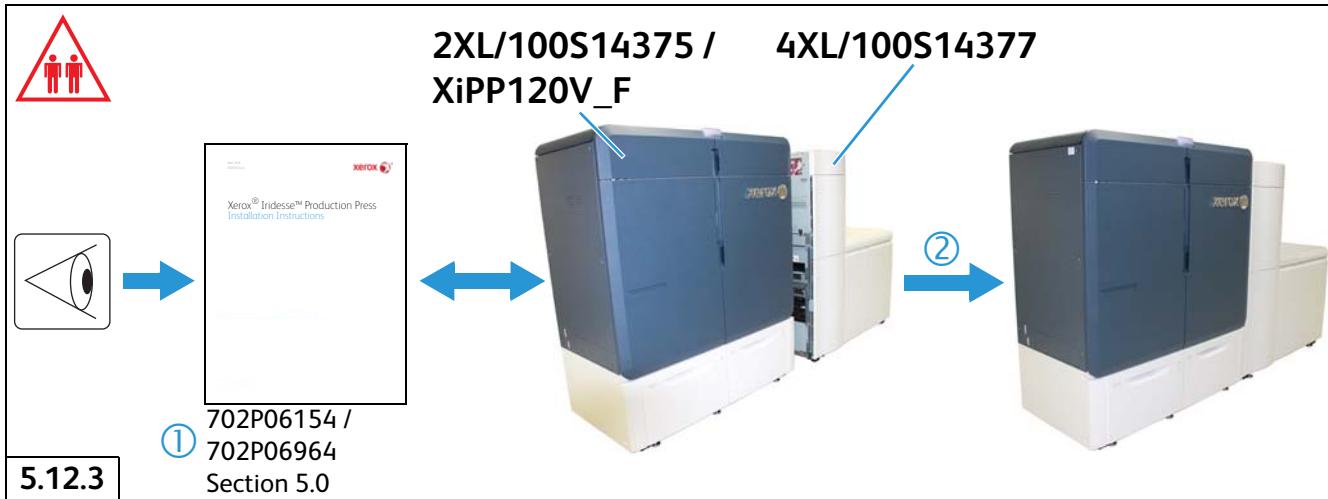
5.12.0 Reinstalling the Base System (8AA/100S14008 / XV3100V_F, 7AA/100S14007, B4E / 450S03106)

WARNING: Due to the size and weight of the IOT Left module, two people are required to move the module.

5.12.1 ① Refer to 'Section 3.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② unpack and ③ prepare the IOT Left for docking.

WARNING: Due to the size and weight of the IOT Right module, two people are required to move the module.

5.12.2 ① Refer to 'Section 4.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② unpack and ③ prepare the IOT Right for docking.



WARNING: Due to the size and weight of the IOT Right, two people will be required to dock the IOT Right to the IOT Left.

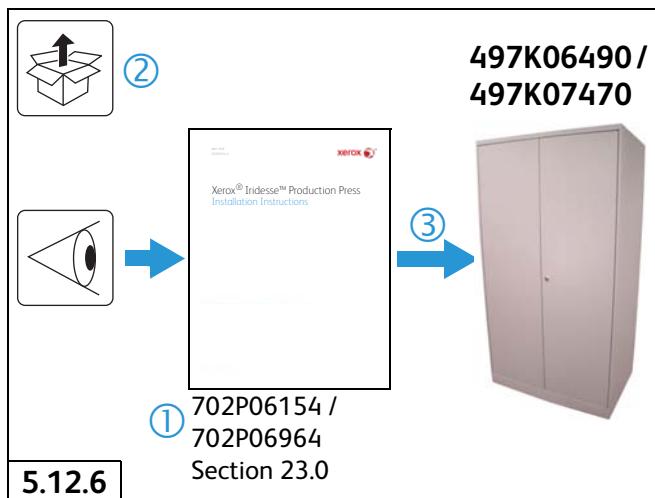
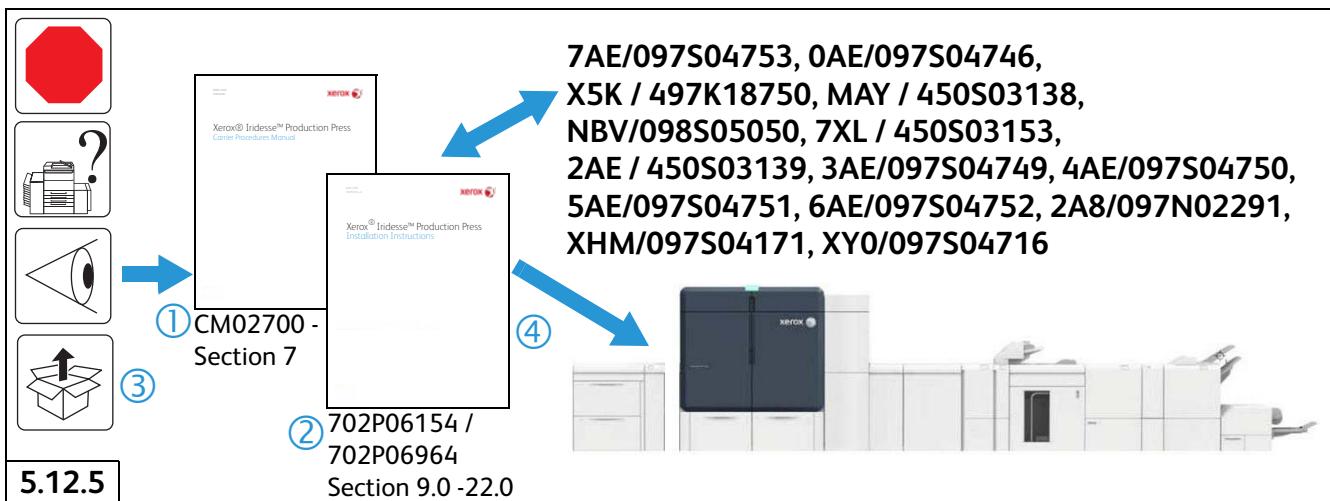
5.12.3 ① Refer to 'Section 5.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② dock the IOT Right module to the IOT Left module.



WARNING: Due to the weight and instability of the ECO Box / ECO Box 2 Assembly, two people will be required to unpack and position the assembly.

5.12.4 ① Cut and remove the stretchwrap from around the module Eco Box / Eco Box 2 assembly.

② Refer to 'Section 8.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ③ position the Eco Box / Eco Box 2 assembly.



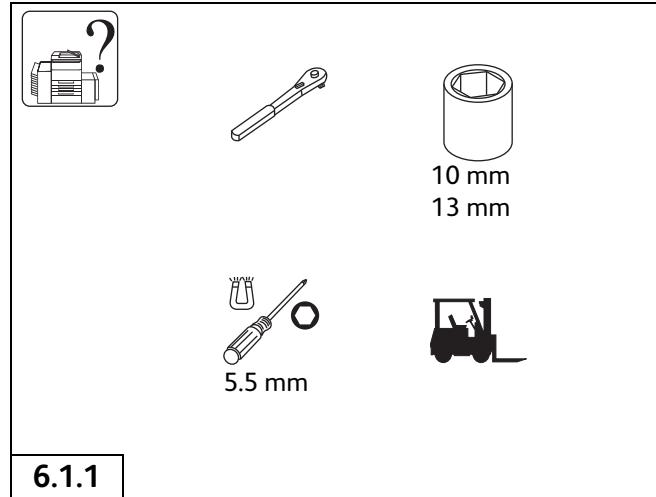
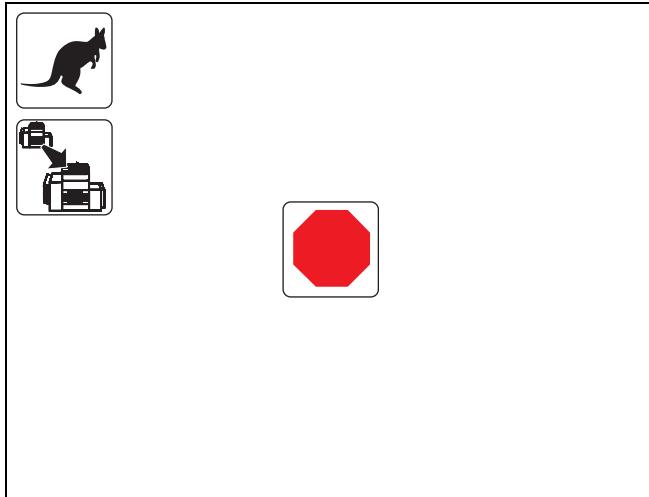
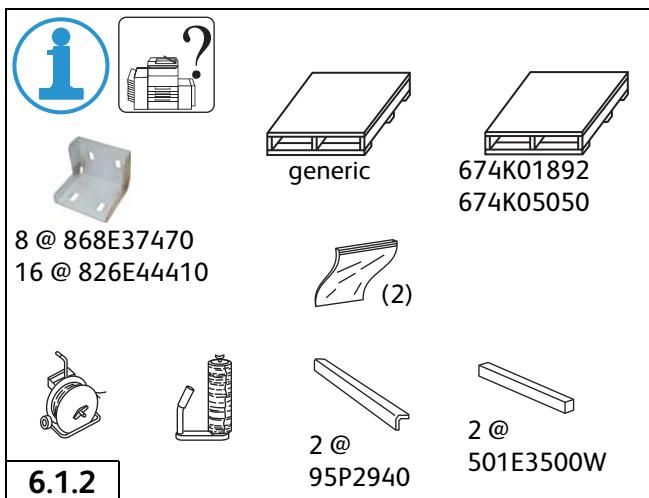
Stop: Depending on which accessories are present, the corresponding section(s) will need to be referred to within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964).

5.12.5 ① Refer to Section 7 - Accessories within this Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and to ② Sections 9.0 - 22.0 to ③ unpack and ④ install potential Production Ready accessories that may be present.

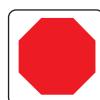
5.12.6 ① Refer to ‘Section 23.0’ in the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② unpack and ③ position the Parts Cabinet.

6

Rpack-Return

**6.1.1****6.1.2**

6.0.0 Repack-Return



Note: Perform all steps in “Relocation-Removal” in Section 5 excluding the “Repositioning and Docking the System”.
Move all modules to the truck.

6.1.0 Tools and Material Required

6.1.1 The tools required for a Xerox® Iridesse™ Production Press system return are shown.



Note: The 674K01892 pallet is for the return of the IOT Left and Eco Box module. The 674K05050 pallet is for the IOT Right and the Eco Box 2 module.

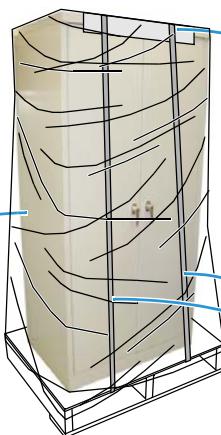
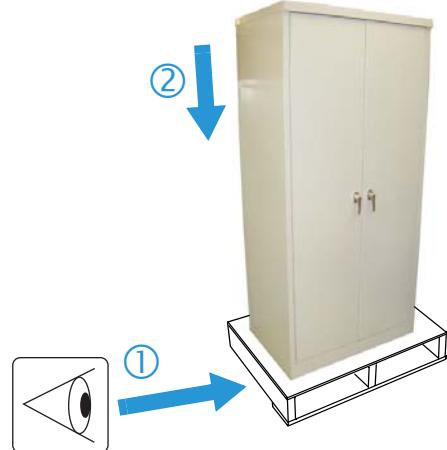
6.1.2 The materials required for a Xerox® Iridesse™ Production Press system return are shown.

497K06490 / 497K07470



generic similar in size

6.2.1



6.2.2

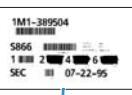
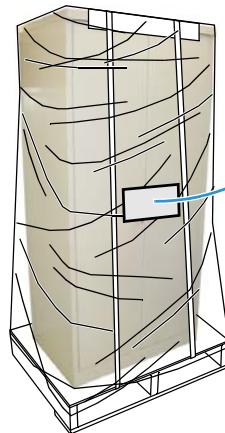
1M1-389504

S866

1 2 4 6

SEC 07-22-95

6.2.3



6.2.4

6.2.0 Preparing the Parts Cabinet



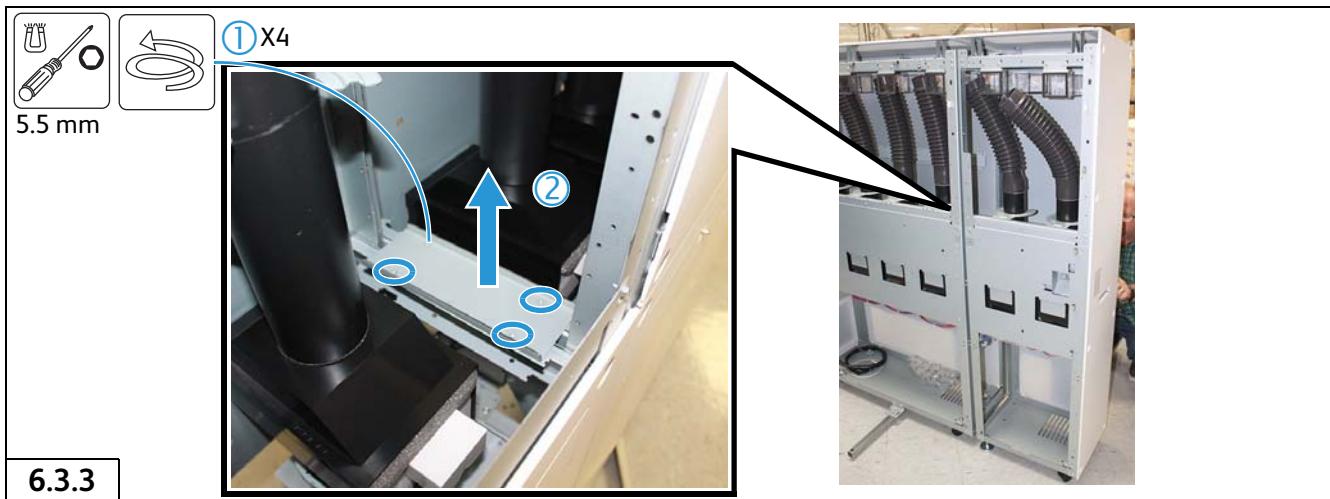
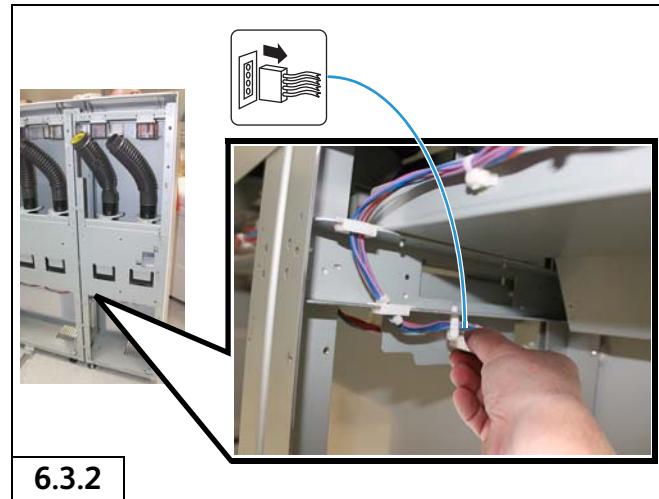
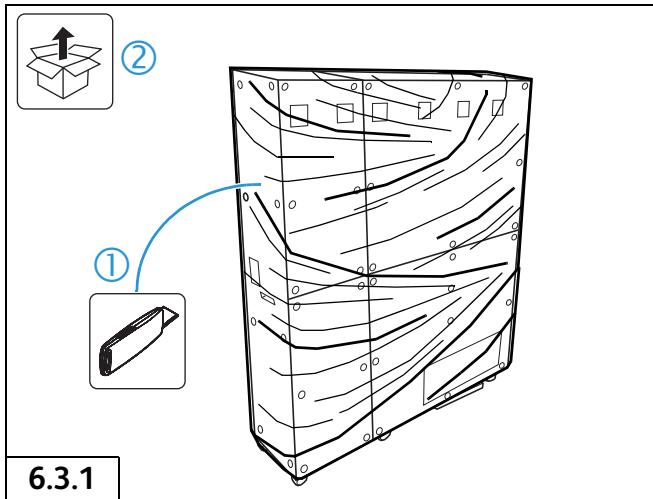
WARNING: Due to the size of the parts cabinet, two people will be required to palletize the module.

6.2.1 ① Retrieve a generic pallet similar in size to the parts cabinet (497K06490 / 497K07470) and ② place the parts cabinet on the pallet.

6.2.2 ① Place a cornerboard (95P2940) on the front and rear top edges of the cabinet. ② Secure the cabinet to the pallet with two bands and ③ then stretchwrap the cabinet.

6.2.3 Generate the bar code label. Cross off non-applicable codes.

6.2.4 ① Attach bar code label to stretchwrap at open end of the pallet. ② Move parts cabinet to the truck.

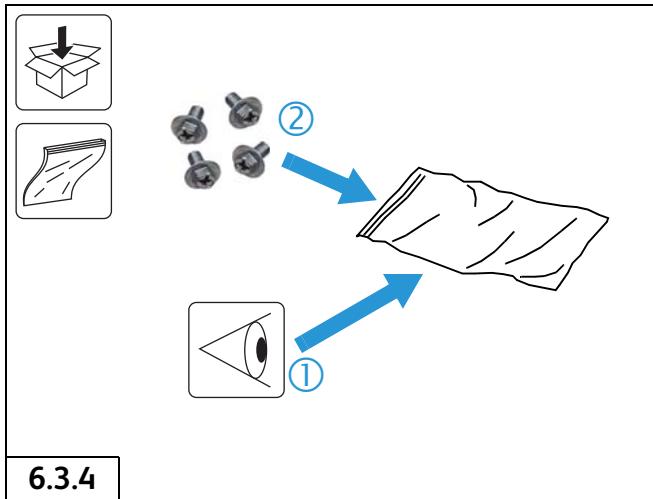


6.3.0 Undock the Eco Box / Eco Box 2 Assembly

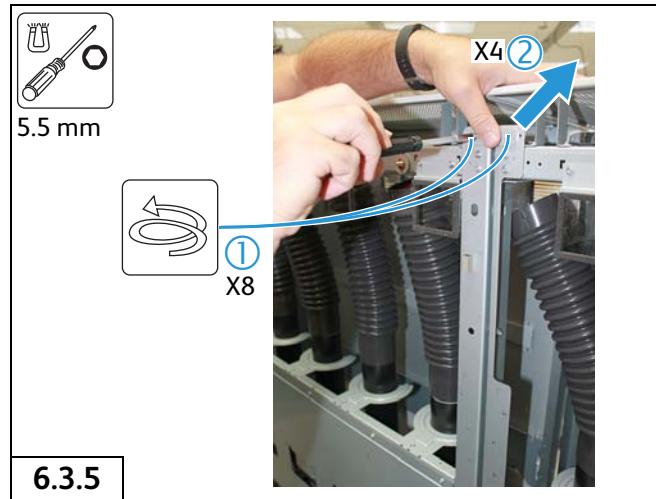
6.3.1 ① Cut and ② remove the stretchwrap from around the Eco Box / Eco Box 2 assembly.

6.3.2 Disconnect the small cable from within the Eco Box 2 inside left of the module.

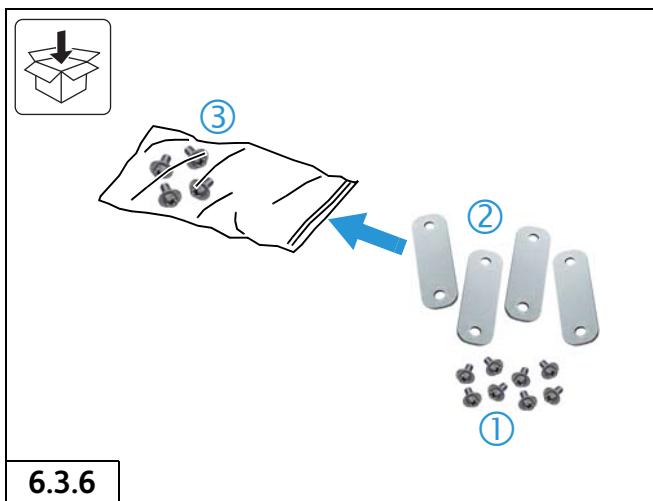
6.3.3 Using a 5.5 mm hex driver, ① remove the four screws securing the joint plate between the 5th Housing Module and the Eco Box. ② Remove the joint plate from between the modules.



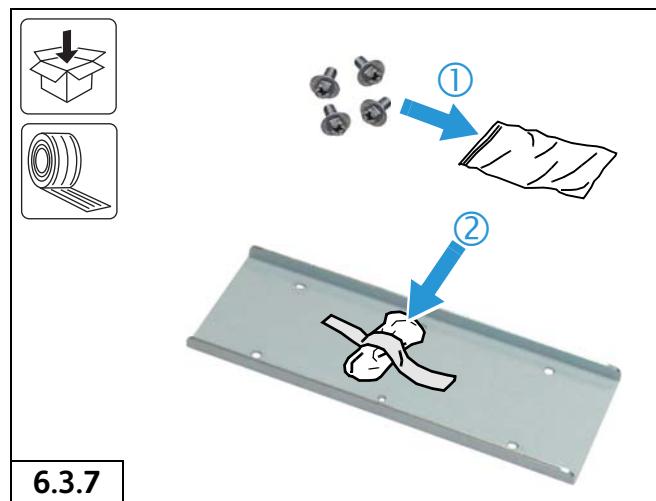
6.3.4



6.3.5



6.3.6



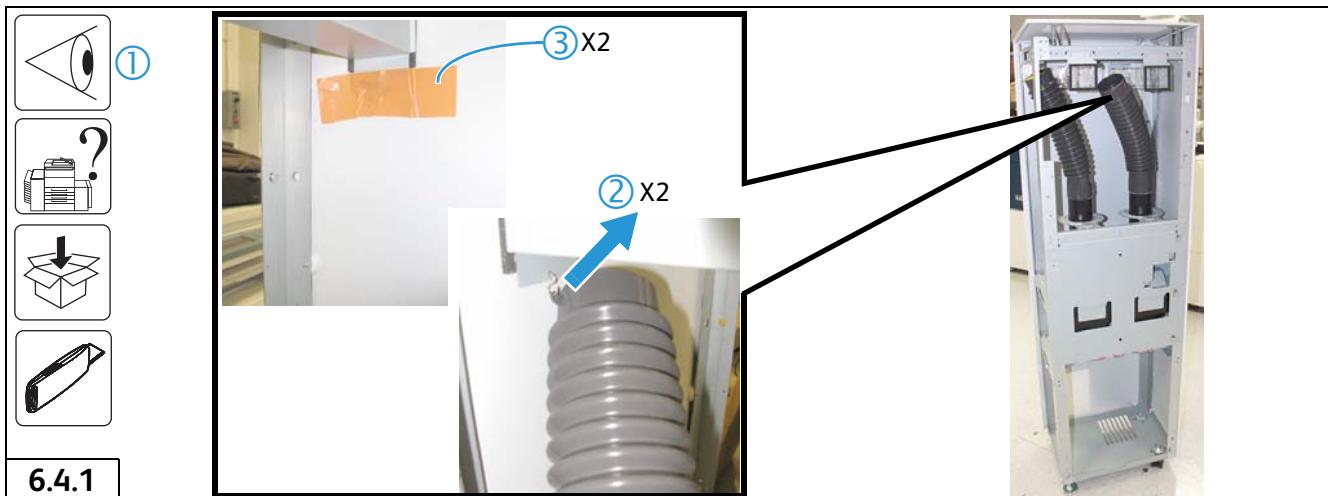
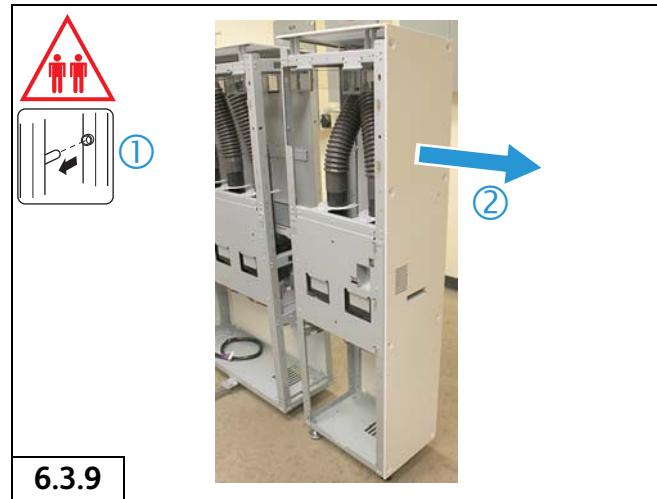
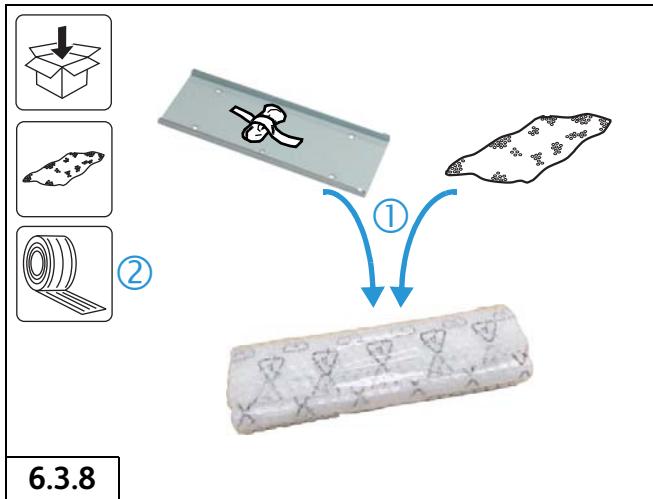
6.3.7

6.3.4 ① Retrieve a plastic bag and ② place the four screws within the bag.

6.3.5 Using a 5.5 mm hex driver, ① remove the eight screws and ② the four connectors attaching the frames of the Eco Box and Eco Box 2.

6.3.6 ① Place the eight screws and ② four connectors in the plastic bag with the other hardware. Then, ③ close the bag.

6.3.7 ① Fold the bag of hardware and ② tape the bag to the joint plate.



6.3.8 ① Wrap the joint plate in a layer of bubblepack and ② secure with tape.

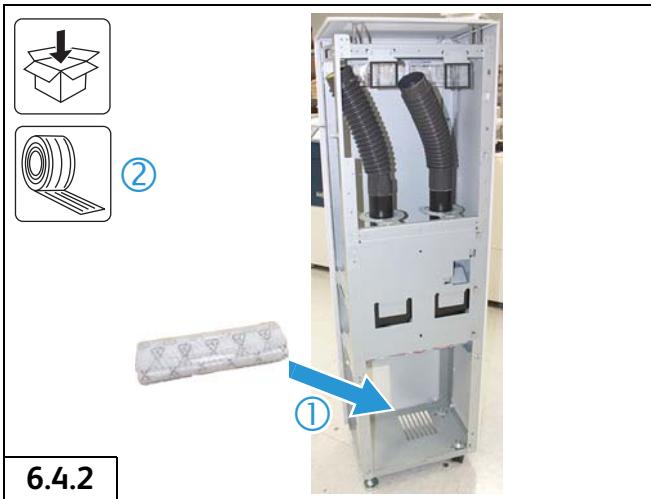


WARNING: Due to the size and the instability of the Eco Box and Eco Box 2, two people will be required to separate the modules.

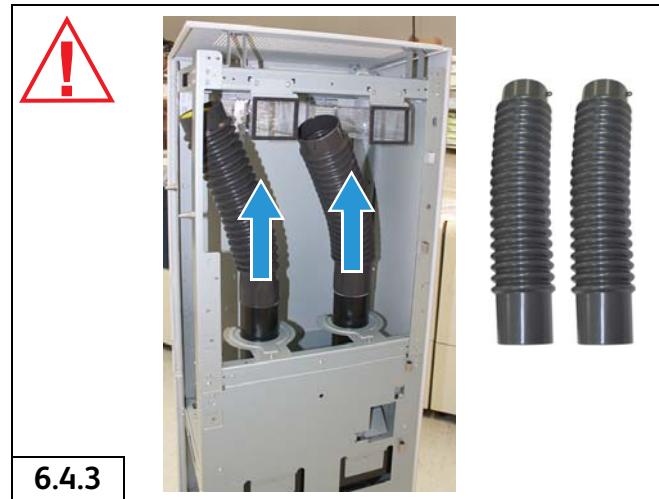
6.4.0 Preparing the Eco Box 2 for a Return

6.4.1 ① If the CSE has not disconnected the flex tubes, ② disconnect the top of the two flex tubes from the two "S" hooks at the top rear edge of the Eco Box 2 assembly. ③ Tape the two "S" hooks to the inside rear cover.

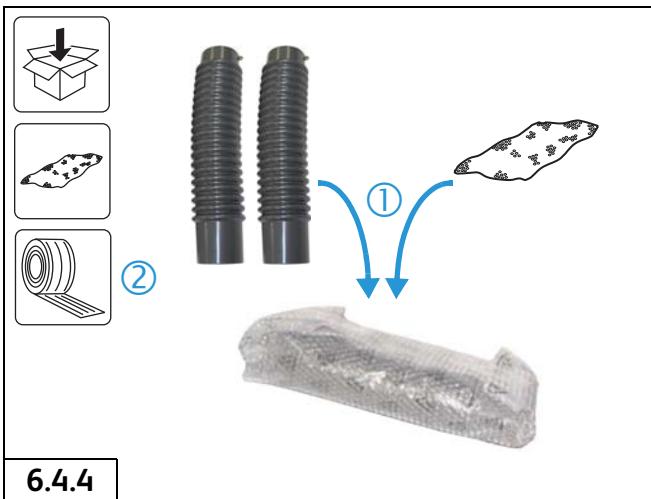
6.3.9 ① Carefully undock and ② move the Eco Box 2 away from the Eco Box.



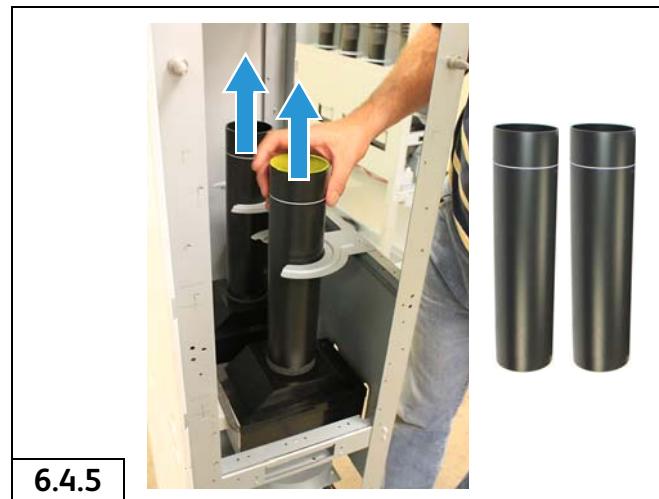
6.4.2



6.4.3



6.4.4



6.4.5

6.4.2 ① Place the wrapped joint plate in the bottom of the Eco Box 2 and ② secure in place with a piece of tape.

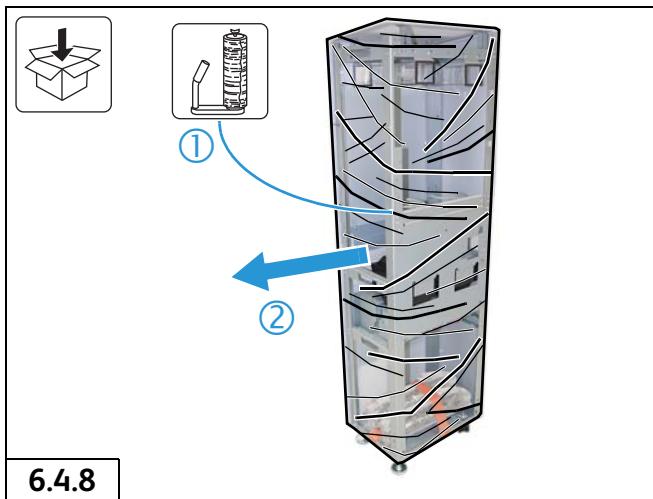
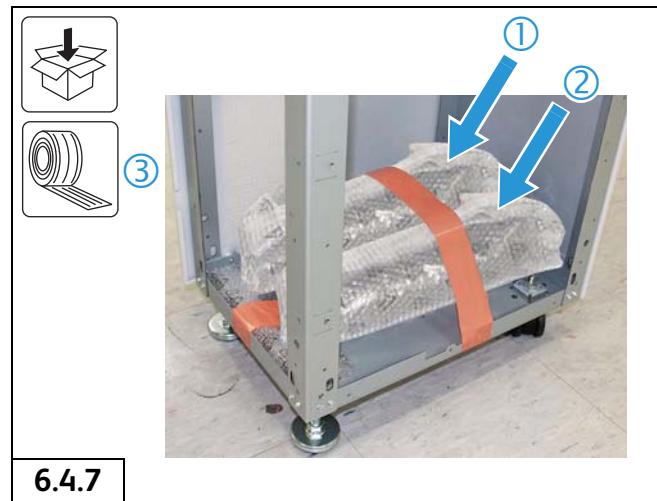


CAUTION: When removing the flex tubes and fixed tubes from the Eco Box 2 module extra care needs to be taken as loose toner may fall from the tubes. If toner does fall from the tubes, be sure to clean toner up from Customer location.

6.4.3 Remove the two flex tubes from the top of the two fixed tubes within the Eco Box module.

6.4.4 ① Wrap the two flex tubes in a layer of bubblepack and ② secure with tape.

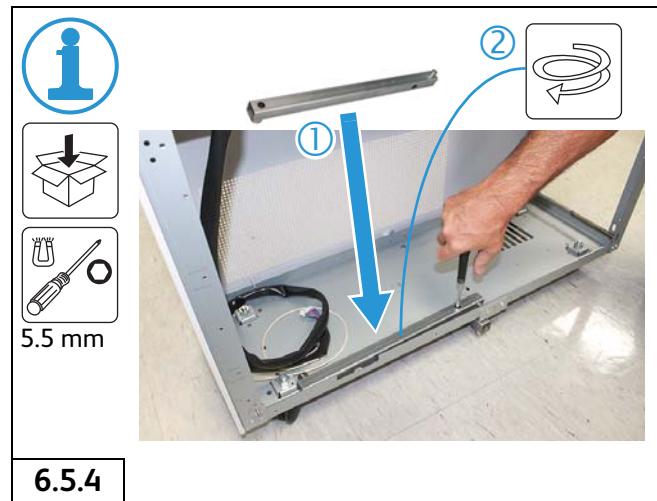
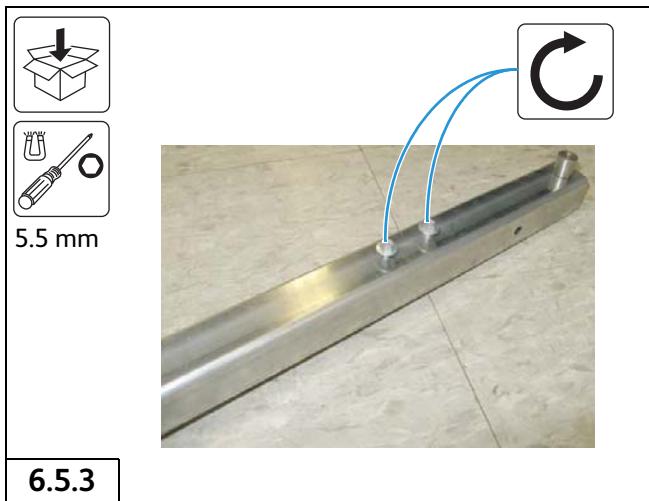
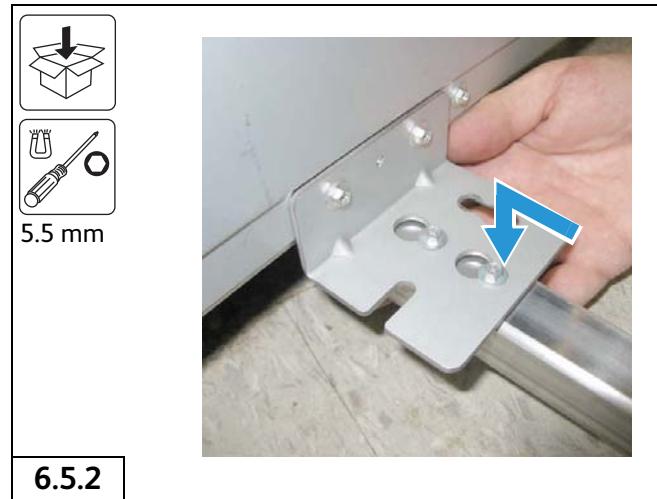
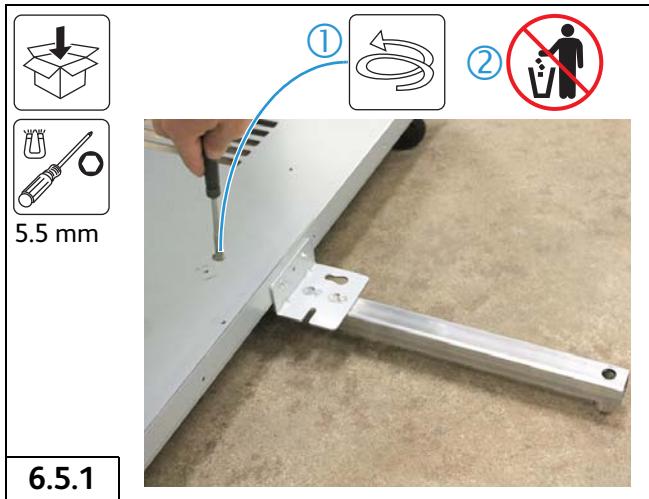
6.4.5 Remove the fixed tube from the top of the filter boxes within the Eco Box module.



6.4.6 ① Wrap the two fixed tubes in a layer of bubblepack and ② secure with tape.

6.4.7 ① Place the bubblepacked flex and ② fixed tubes in the bottom of the Eco Box Module and ③ secure them with tape.

6.4.8 ① Secure the Eco Box Module with a layer of stretchwrap and ② place the Eco Box aside to be palletized later in the process.



6.5.0 Prepare the Eco Box for a Return

6.5.1 ① Remove the single screw on the inside bottom surface of the Eco Box securing the front stabilizing bar. ② Do not discard screw.

6.5.2 ① Loosen the two screws securing the bar to the bracket and ② slide the stabilizing bar back and out from the bracket.

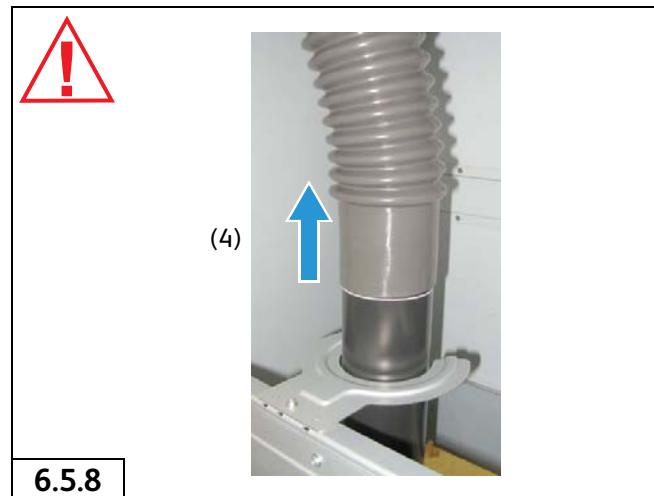
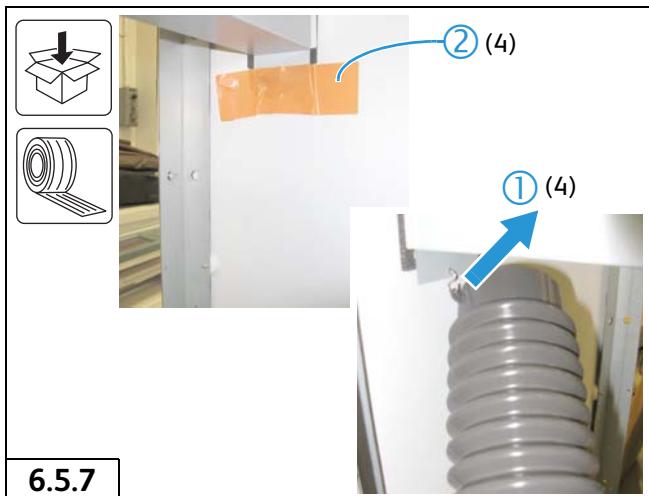
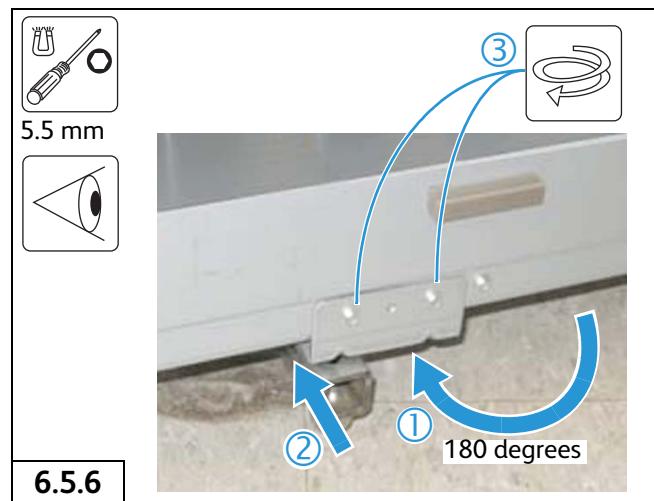
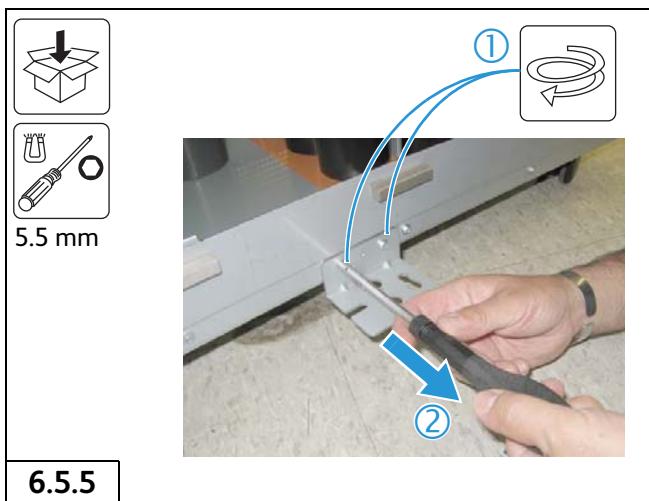
6.5.3 Tighten the two screws in the top of the bar.



Note: Secure the stabilizing bar by inserting the screw down through the larger side hole in the bar into the bottom surface.

6.5.4 ① Place the stabilizing bar on the front inside bottom surface of the Eco Box.

② Secure the bar in place using the screw removed from the same hole earlier.



6.5.5 ① Remove the two screws and ② bracket from the bracket on the bottom front frame of the Eco Box.

6.5.6 ① Rotate the stabilizer bar bracket 180 degrees horizontally and ② reinstall the bracket flange under the module. ③ Secure the bracket in place with the two original screws.

6.5.7 ① Disconnect the top of the four flex tubes from the "S" hooks at the top rear edge of the module. ② Tape the "S" hooks to the inside rear cover.

CAUTION: When removing the flex tubes and fixed tubes from the Eco Box extra care needs to be taken as loose toner may fall from the tubes. If toner does fall from the tubes, be sure to clean toner up from Customer location.

6.5.8 Remove the four flex tubes from the top of the fixed tubes.

(4)



6.5.9



6.5.10



6.5.11

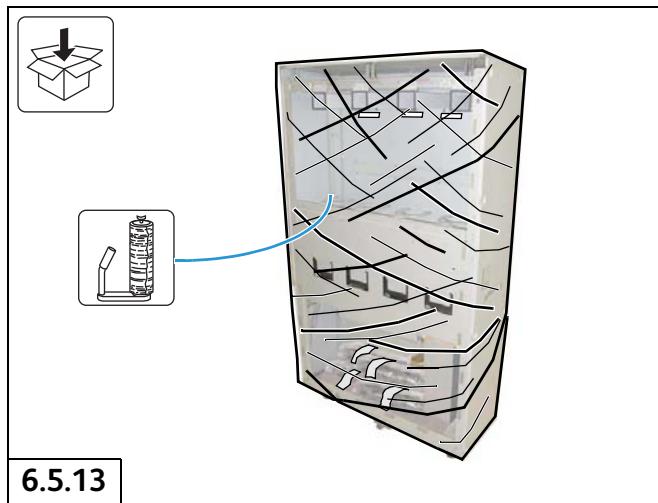
6.5.12

6.5.9 Remove the four fixed tubes from the filter box inside the Eco Box.

6.5.10 ① Retrieve and ② wrap two of the four flex tubes together in bubblepack. ③ Wrap the remaining two tubes together in bubblepack.

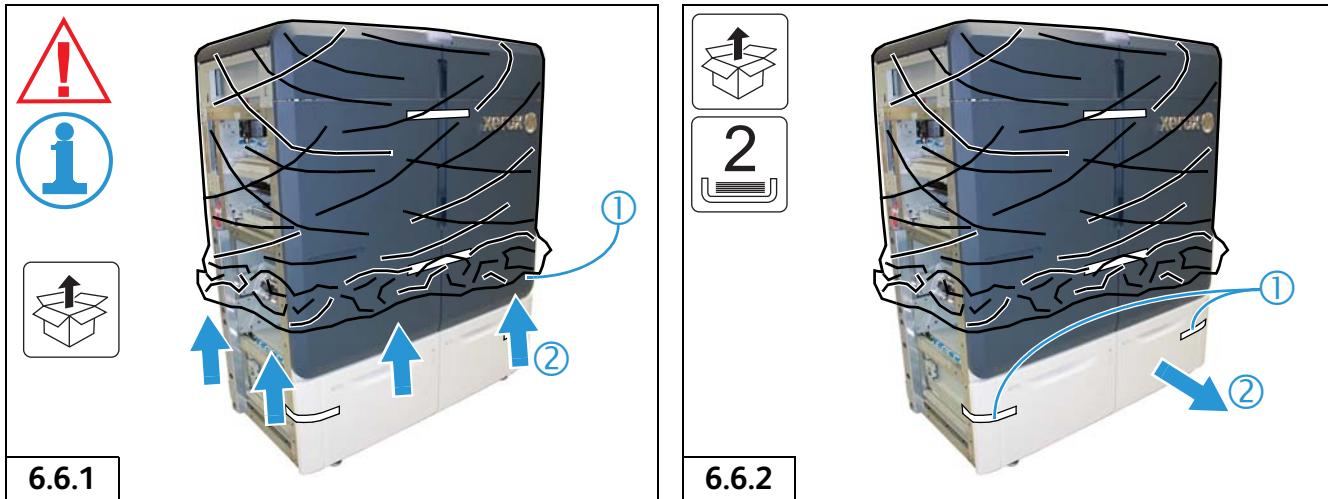
6.5.11 ① Retrieve and ② wrap two of the four fixed tubes together in bubblepack. ③ Then, wrap the remaining two tubes together in bubblepack.

6.5.12 ① Place the bubblepacked fixed and flex tubes in the bottom of the Eco Box and ② secure them in place with tape.



6.5.13

6.5.13 Wrap the Eco Box with stretchwrap.



6.6.0 Prepare the IOT Left Module for a Return

CAUTION: When handling the IOT Left Module, ensure that extra care is taken not to damage any of the connectors located on the right side front top edge of the module.

CAUTION: When removing the stretchwrap from the bottom of the IOT Left Module, extra care needs to be taken as not to damage the covers of the module.

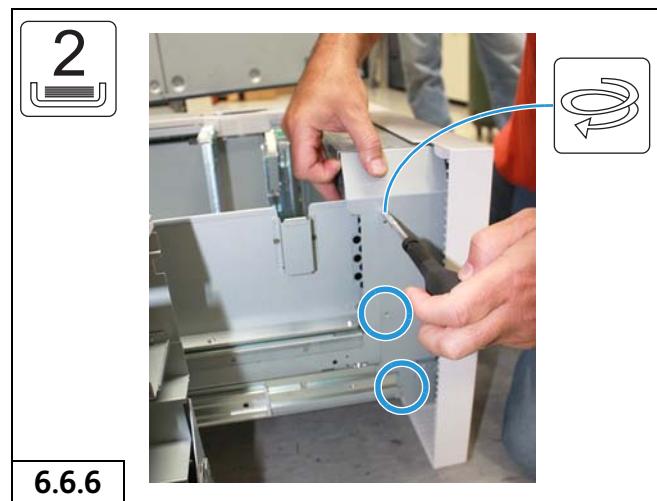
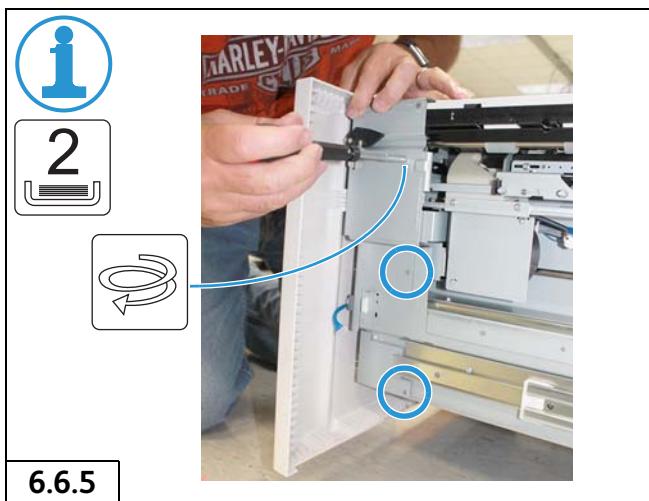
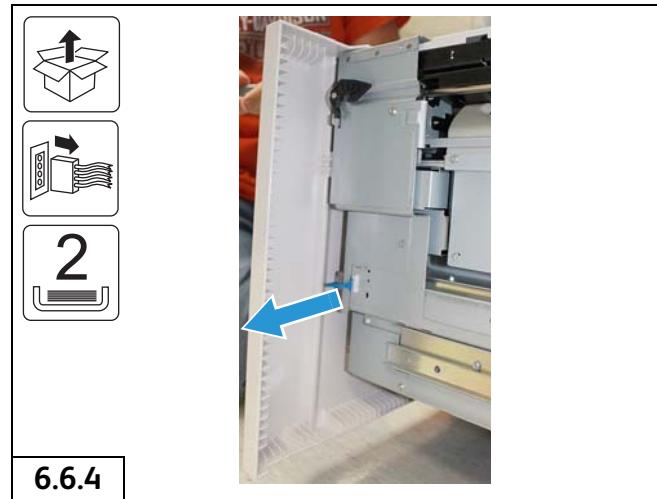
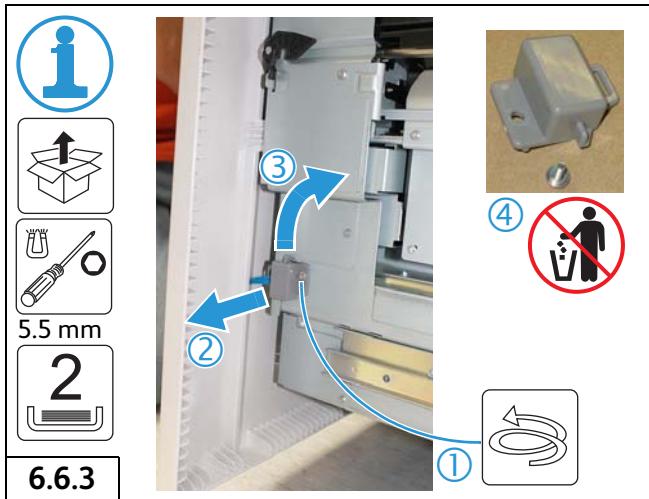
Note: The bubblepacked left side cover should remain on top of the module.



Note: When lifting the stretchwrap from the bottom of the IOT Left Module, this will allow the Carriers access to the paper trays.

6.6.1 ① Cut and ② lift the stretchwrap from the bottom of the IOT Left to just above the front two bottom paper tray drawers.

6.6.2 ① Remove the tape securing the two paper trays and ② open the paper tray 2 drawer.



Note: Retain the connector cover and screw. DO NOT discard.

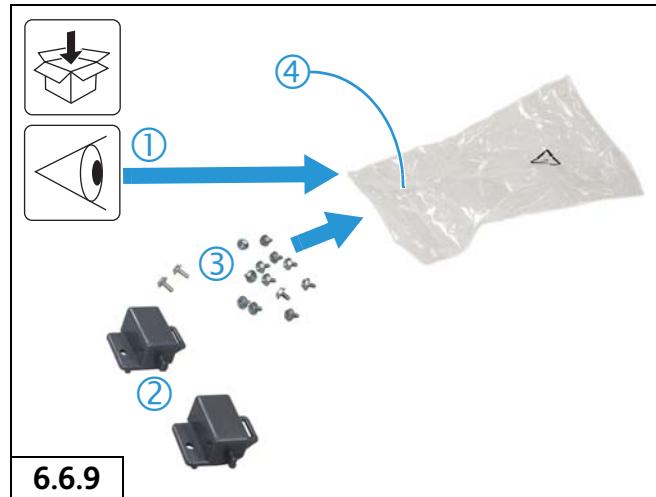
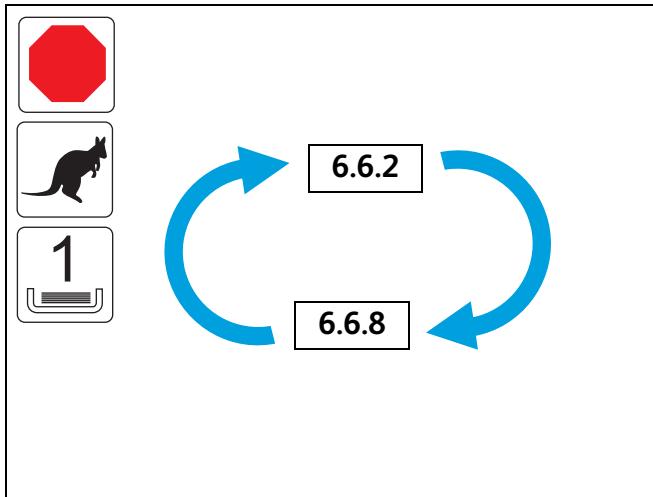
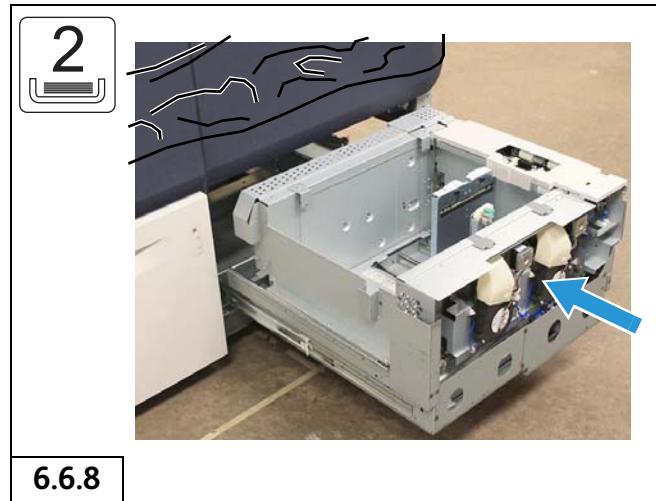
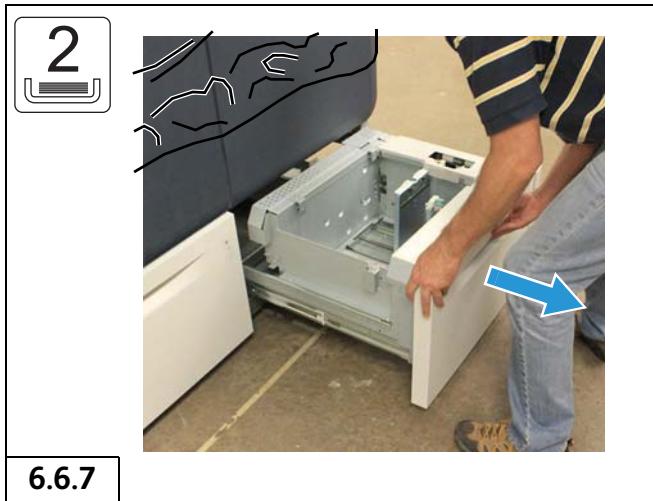
6.6.3 ① Remove the single screw securing the small connector cover on the right front edge of the drawer. ② Remove the connector cover from the side of the drawer and ③ then from around the connector harness. Do not discard the cover or screw.

6.6.4 Disconnect the cover connector from the right side of the paper tray 2 drawer.

Note: Retain the six paper tray cover screws. DO NOT discard.

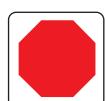
6.6.5 Remove the three screws from the right front side of the drawer securing the cover to the drawer

6.6.6 Remove the three screws from the left front side of the drawer securing the cover to the drawer.



6.6.7 Remove the Tray 2 front cover from the drawer.

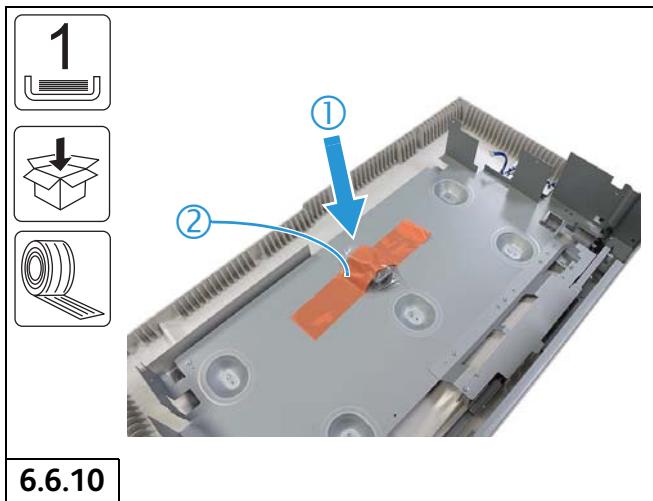
6.6.8 Close the paper tray 2 drawer.



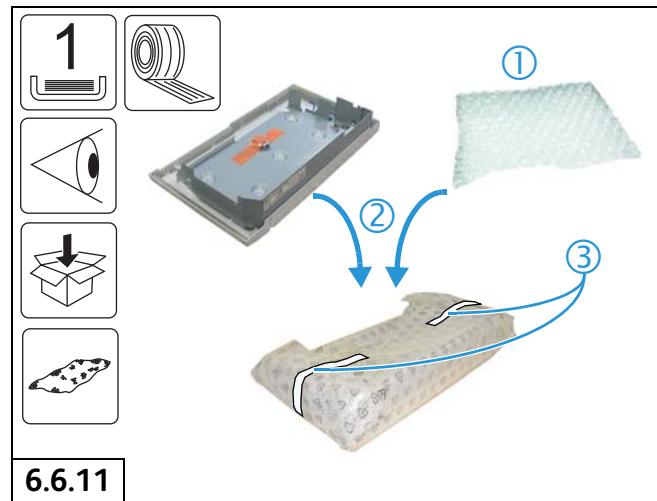
Stop: Perform steps 6.6.2 on page 6-13 through 6.6.8 on page 6-15 for paper tray 1.

6.6.9 ① Retrieve a plastic bag and ② place the 2 cable connectors and ③ 14 screws inside the bag.

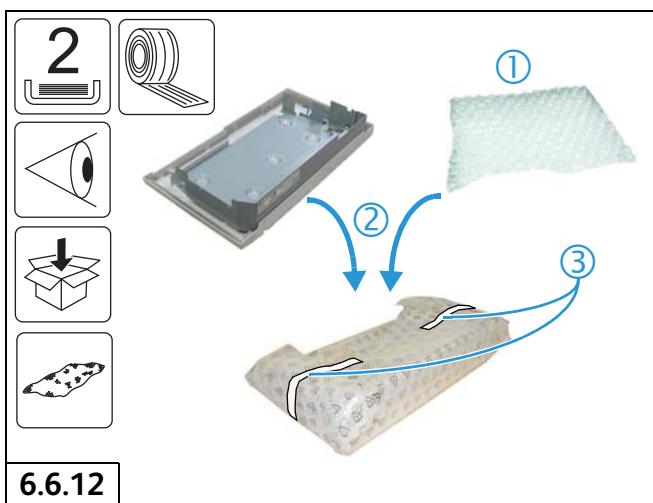
④ Close the bag.



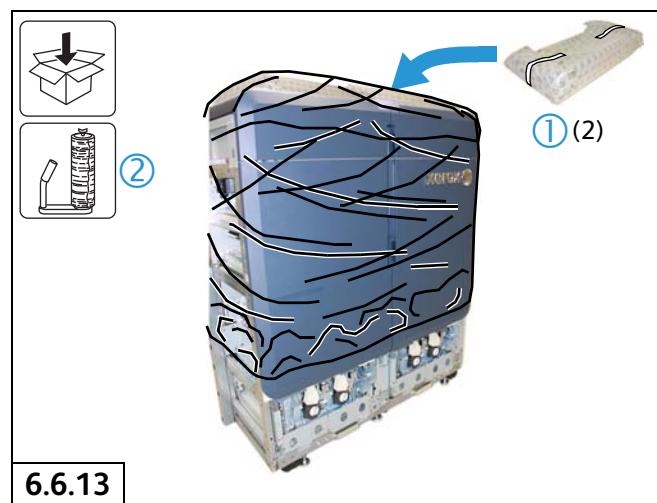
6.6.10



6.6.11



6.6.12



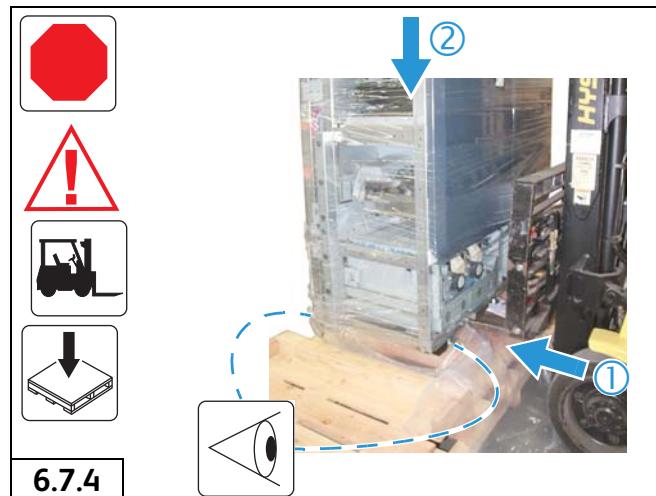
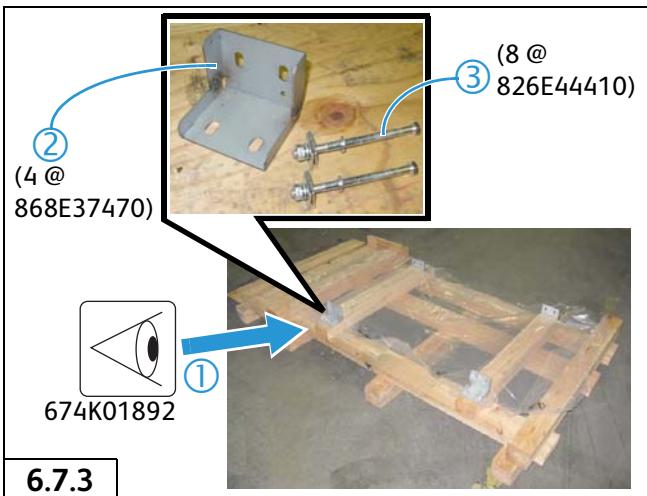
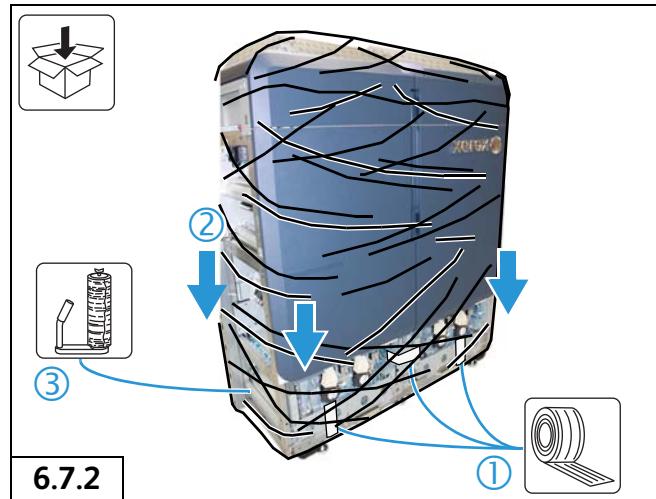
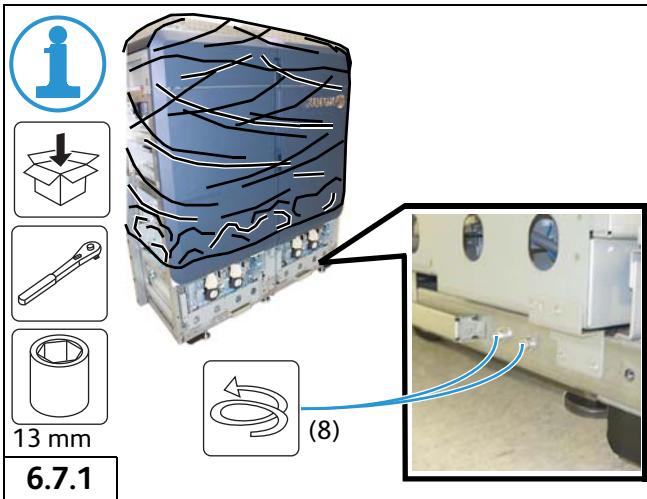
6.6.13

6.6.10 ① Place the closed bag of hardware on the inside surface of Tray 1 cover and ② secure it in place with tape.

6.6.11 ① Retrieve a piece of bubblepack and ② wrap the Tray 1 cover within the bubblepack.
③ Secure the Tray cover with tape.

6.6.12 ① Retrieve a piece of bubblepack and ② wrap the Tray 2 cover within the bubblepack.
③ Secure the Tray cover with tape.

6.6.13 ① Place the two bubblepacked tray covers on top of the IOT Left and ② secure them in place with stretchwrap.



6.7.0 Palletizing the IOT Left and Eco Box



Note: Bolts for securing the IOT Left to the bracket are stored in the original holes in the bottom frame of the module.

6.7.1 Remove the eight shipping bracket bolts (four from the front and four from the rear) from module bottom frame.

6.7.2 ① Tape the front paper trays closed and ② lower the pulled up stretchwrap at the bottom of the IOT. ③ Secure the bottom of the IOT Left with a layer of stretchwrap.

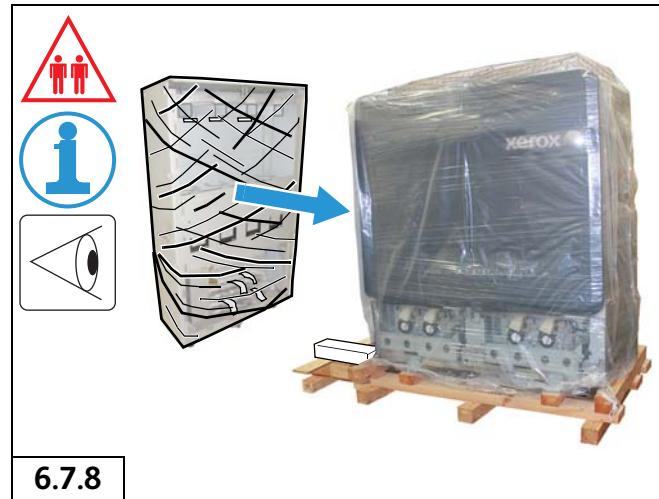
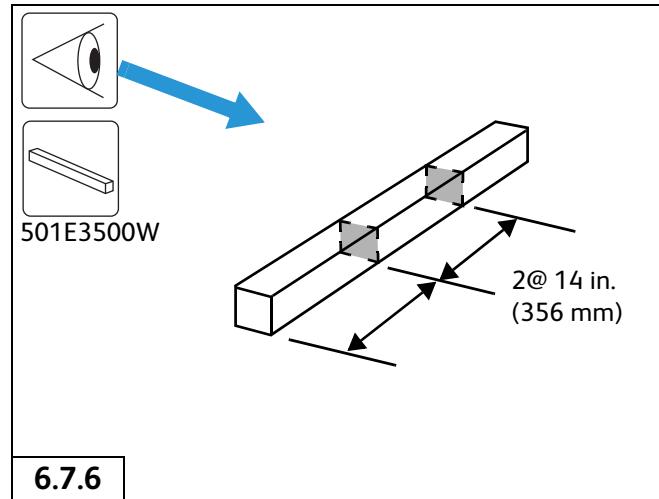
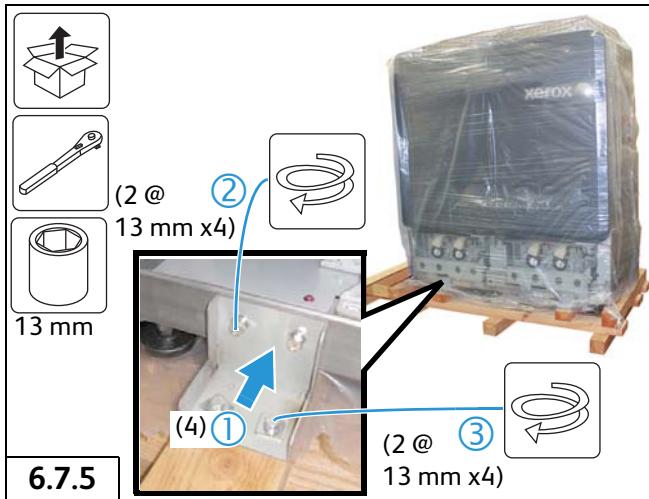
6.7.3 ① Retrieve the IOT Left recycled pallet (674K01890 or 674K01892), ② four brackets (868E37470), and ③ eight bolts (826E44410).

Stop: Use a forklift only when palletizing the IOT Left.



CAUTION: Before placing the forks under the IOT Left, ensure to check for the location of stabilizing feet and casters. Ensure that the forks are placed just inside the shipping bracket bolt holes located in the frame of the module. Ensure the forks extend through to the opposite side of the module. Extra care should be taken when placing the forks under the IOT Left.

6.7.4 Using a forklift, ① place the forks under the IOT Left Module. Lift and ② place the module on the recycled original pallet.



6.7.5 ① Position the four shipping brackets accordingly with holes in module frame, two on the front and two on the rear. ② Secure each bracket to the frame with two 13 mm bolts (eight total) and ③ to the pallet with two 13 mm bolts (eight total).

6.7.6 Cut two 14 in. (356 mm) long pieces from one wooden block (501E3500W).

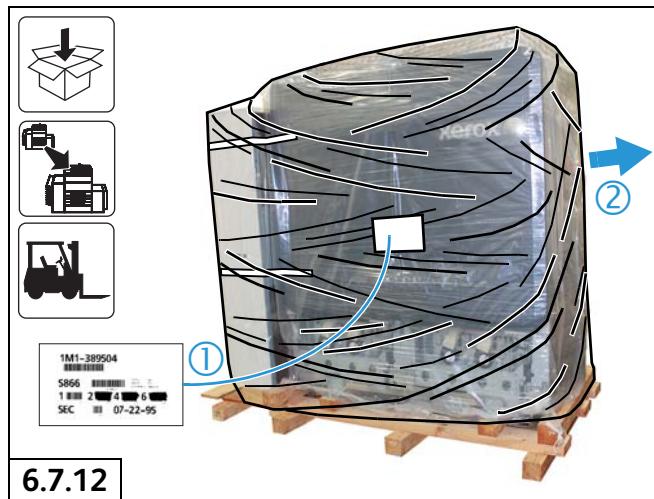
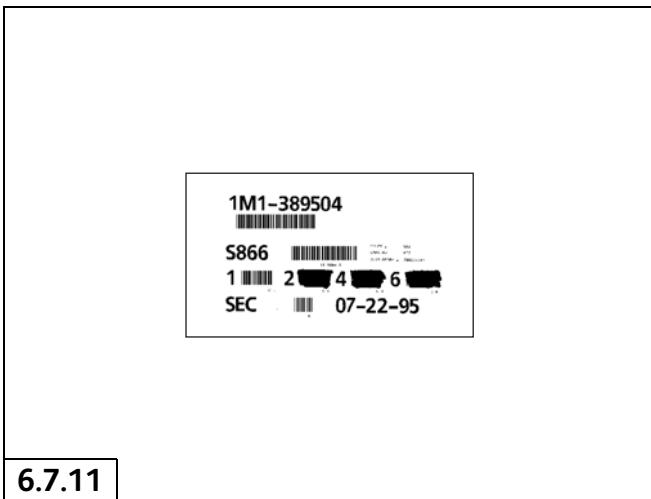
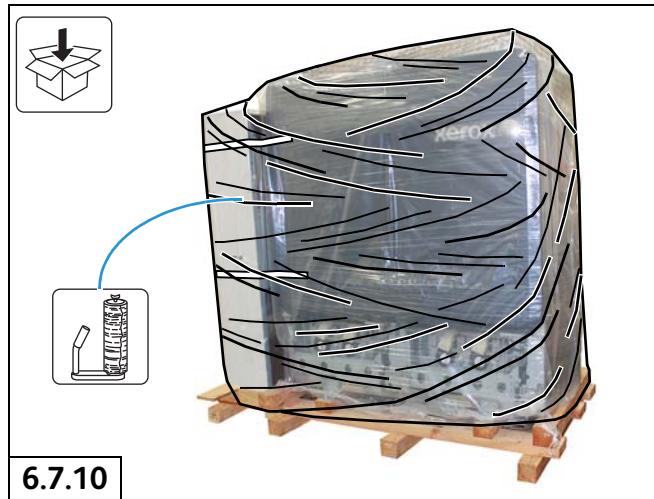
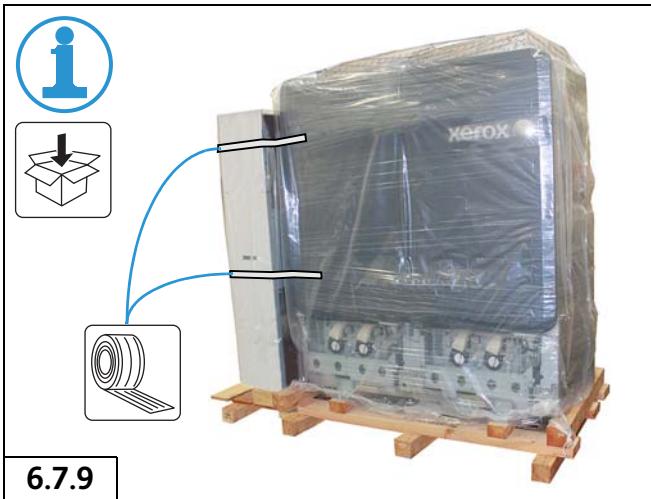
6.7.7 Place two of the cut blocks on the left side of the IOT Left pallet.



WARNING: Due to the weight and size of the Eco Box, two people will be required to place the packed module on the left end of the IOT Left pallet.

Note: Center the Eco Box on the cut blocks within the recess on the left side of the pallet.

6.7.8 Lift and place the Eco Box on top of the cut blocks on the left side of the IOT Left pallet.



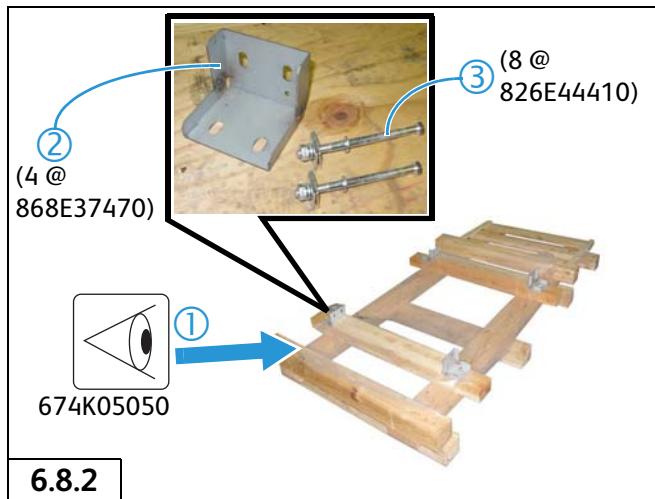
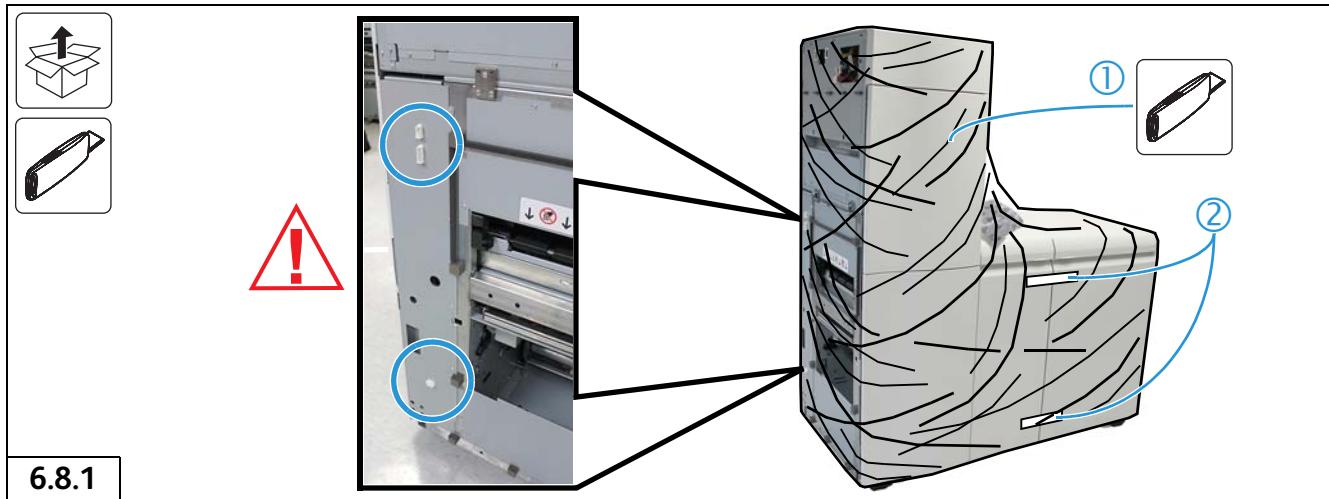
Note: Secure the Eco Box to the IOT Left by running tape both in the front and rear of the modules.

6.7.9 Using tape, secure the Eco Box to the IOT Left.

6.7.10 Secure the IOT Left and Eco Box with a layer of stretchwrap.

6.7.11 Generate the bar code label. Cross off non-applicable codes.

6.7.12 ① Attach bar code label to stretchwrap at open end of the pallet. ② Move IOT Left Module to the truck.

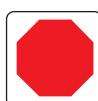
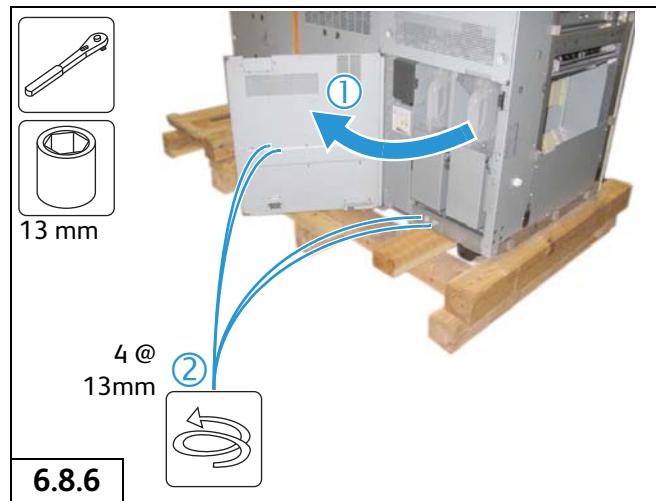
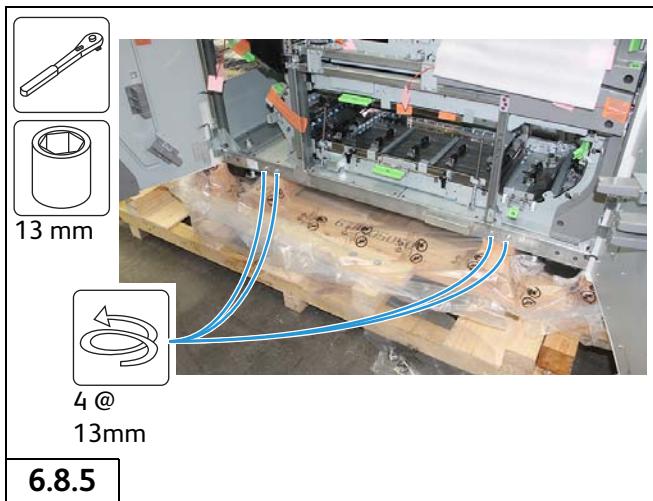
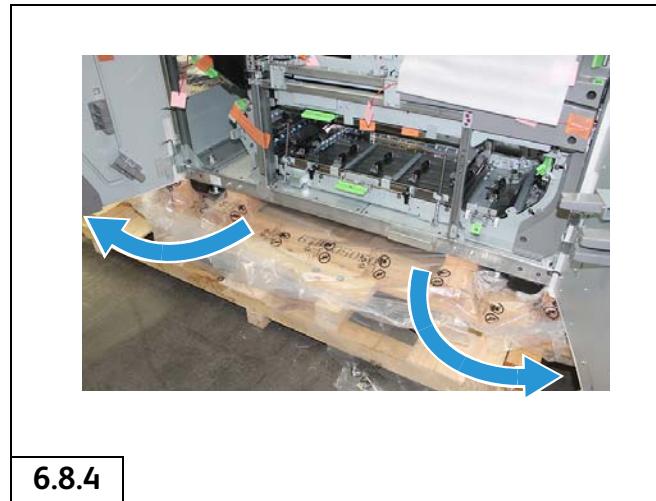
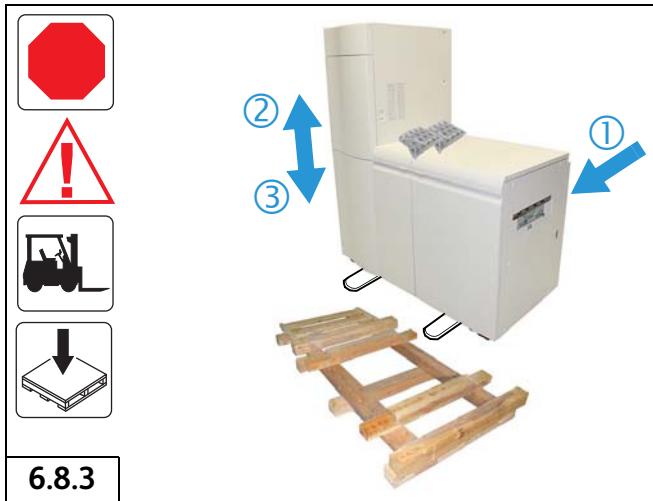


6.8.0 Preparing the IOT Right Module for a Return

CAUTION: When handling the IOT Right module, ensure that extra care is taken not to damage any of the connectors located on the left side rear edge of the module.

6.8.1 ① Cut and remove stretchwrap from around the IOT Right Module. ② Remove the tape securing the front covers.

6.8.2 ① Retrieve the IOT Right Module recycled pallet (674K05050), ② four brackets (868E37470), and ③ eight bolts (826E44410).



Stop: Use a forklift only when palletizing the IOT Right Module.



CAUTION: When palletizing the IOT Right Module, ensure to place the fork under the module from the rear.



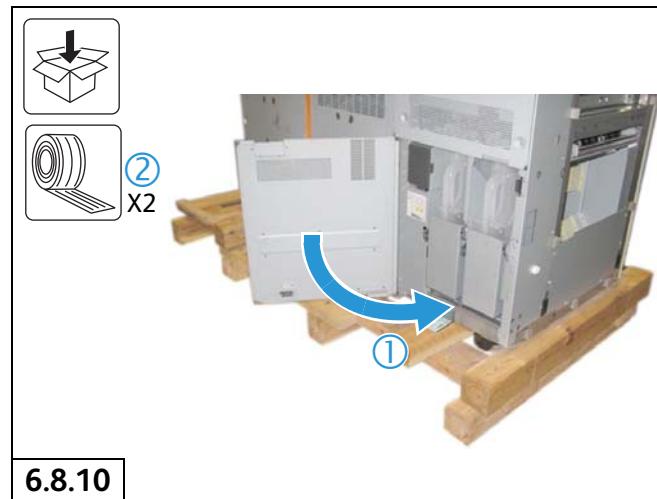
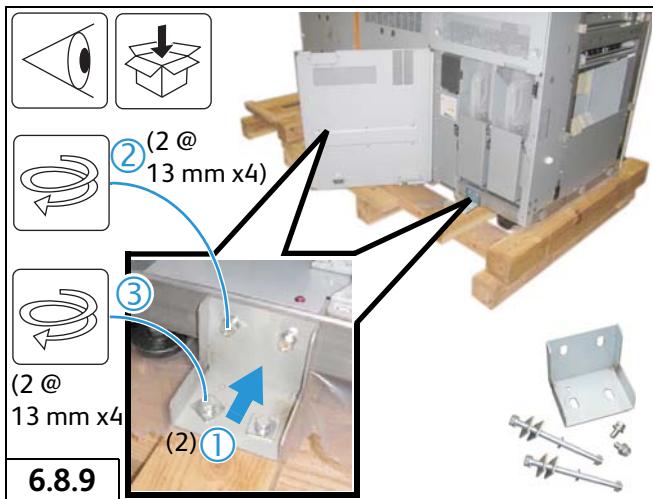
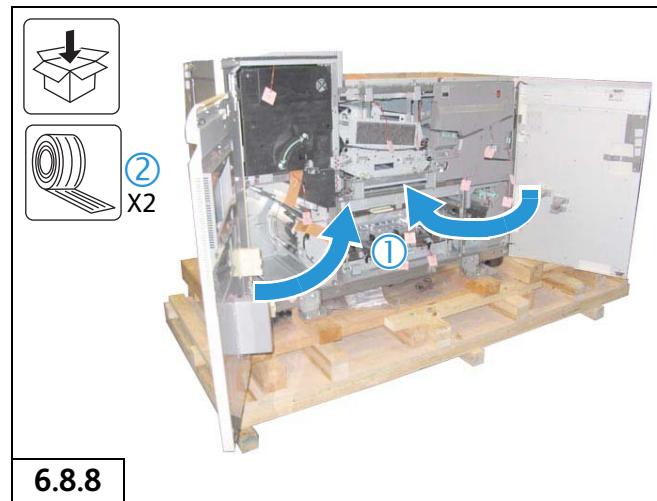
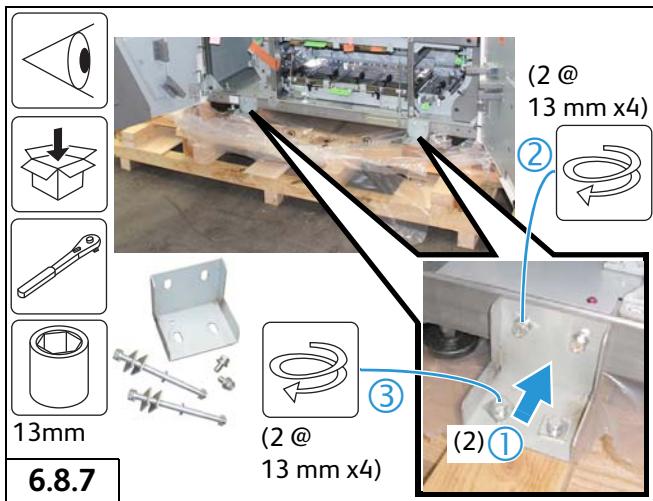
CAUTION: Before placing the forks under the IOT Right Module, ensure to check for the location of stabilizing feet and casters. Ensure that the forks are placed just inside the shipping bracket bolt holes located in the frame of the module. Ensure the forks extend through to the front side of the module.

6.8.3 ① Place the forks under the IOT Right Module, ② lift and ③ place the module on the recycled original pallet accordingly.

6.8.4 Open the front covers of the IOT Right Module.

6.8.5 Remove the four 13 mm bolts from the front bottom frame of the IOT Right frame.

6.8.6 ① Open the rear right cover and ② remove the four 13 mm bolts from the rear bottom frame of the IOT Right frame.

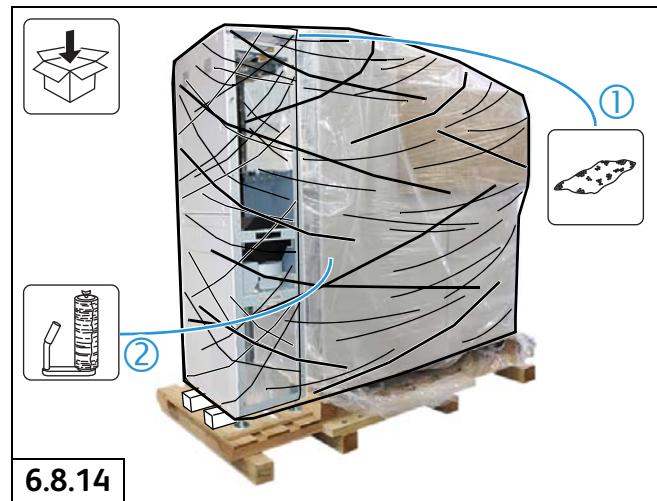


6.8.7 ① Position the two shipping brackets accordingly with the holes in the front module frame.
 ② Secure each bracket to the frame with two 13 mm bolts (four total) and ③ to the pallet with two 13 mm bolts (four total).

6.8.8 ① Close the front covers and ② secure the covers with two pieces of tape, one high and one low on the covers.

6.8.9 ① Position the two shipping brackets accordingly with holes in the rear module frame.
 ② Secure each bracket to the frame with two 13 mm bolts (eight total) and ③ to the pallet with two 13 mm bolts (four total).

6.8.10 ① Close the rear right bottom cover and ② secure the cover with two pieces of tape, one high and one low on the cover.



6.8.11 ① Retrieve and ② place any miscellaneous box(es) containing items from the Parts cabinet on top right side of the IOT Right. Then, ③ secure the boxes in place with a layer of stretchwrap.

6.8.12 ① Retrieve a wooden block and ② cut it in half. ③ Position the two halves on the left end of the IOT pallet.



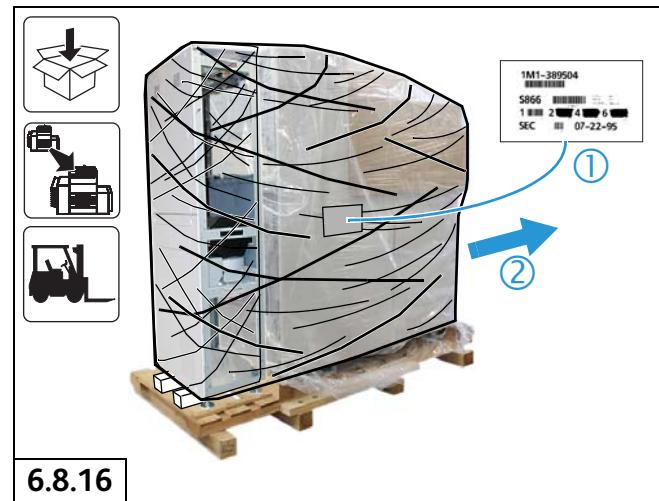
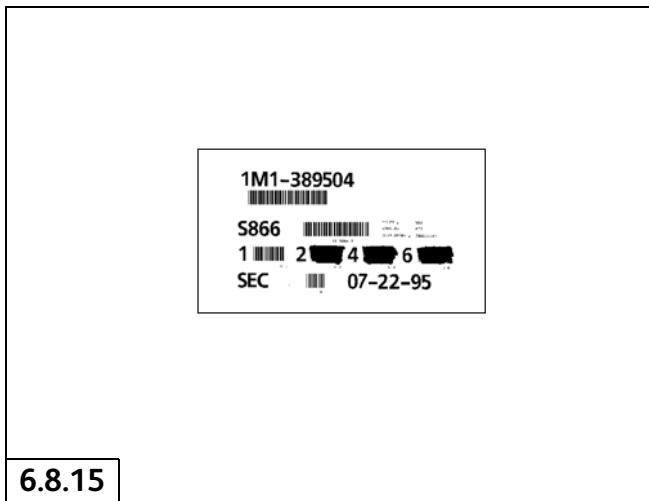
WARNING: Due to the size of the ECO Box 2, two people will be required to place the module on the pallet.



Note: When placing the ECO Box 2 on the blocks, be sure that the blocks are positioned just inside the casters and leveling feet on the bottom of the module.

6.8.13 Using two people, lift and place the ECO Box 2 on the wooden blocks on the left end of the pallet.

6.8.14 ① Place a folded piece of bubblepack over the inside top edge of the ECO Box 2 and ② then secure the module to the IOT Right with a layer of stretchwrap.

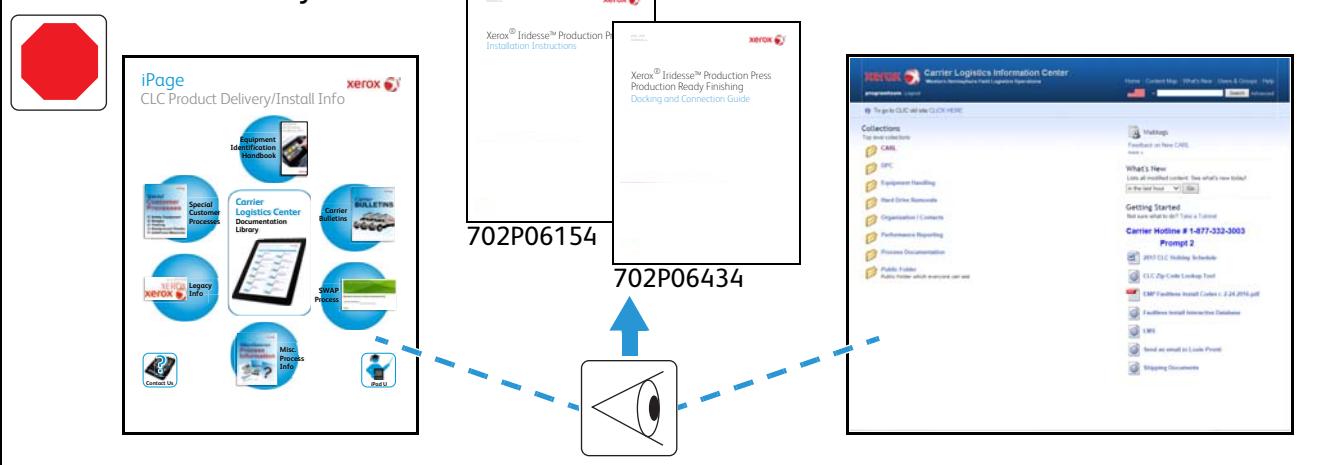
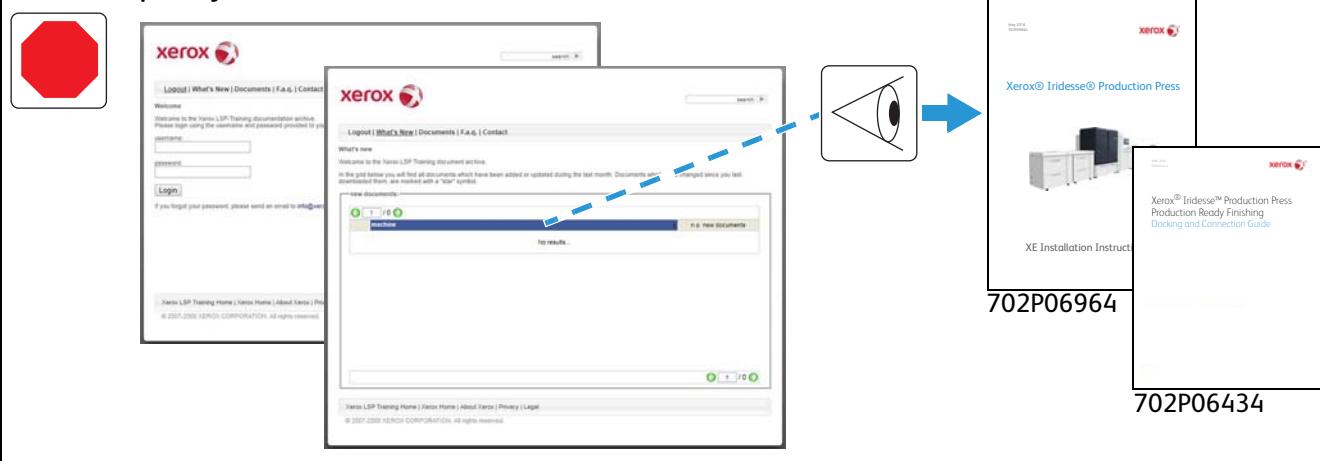


6.8.15 Generate the bar code label. Cross off non-applicable codes.

6.8.16 ① Attach bar code label to stretchwrap at open end of the pallet. ② Move IOT Right Module to the truck.

7

Accessories

Xerox North America only:**Xerox Europe only:**

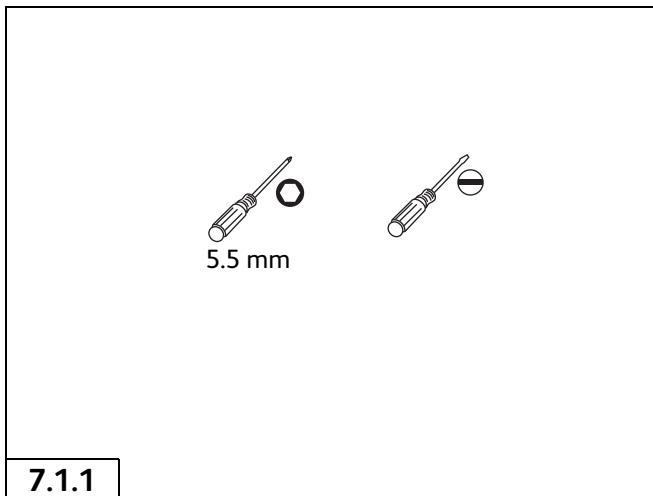
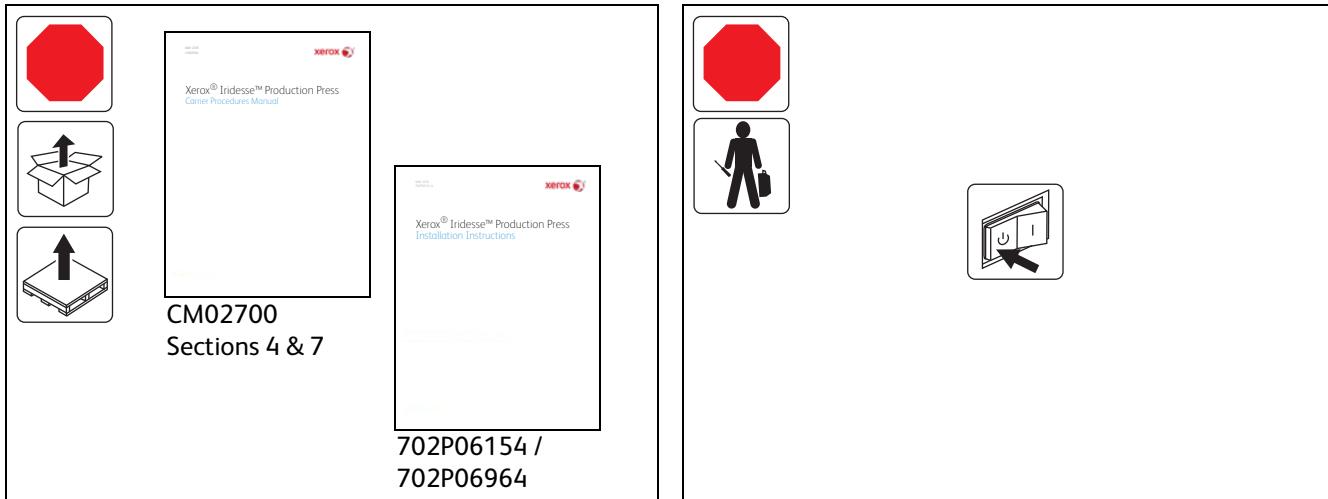
7.0.0 Accessories Section

7.1.0 Accessories Install - Preparing for Installation

Stop: Xerox North America only: Use the Xerox® Iridesse™ Production Press Installation Instructions (702P06154) and the Xerox® Iridesse™ Production Press Docking and Connection Guide (702P06434) that can be found on iPage and the CLIC website (<https://carrierlogistics.external.xerox.com/docushare/dsweb/HomePage>). Also, use the installation instructions within this section and the instructions packed with the individual accessories to depalletize, unpack, dock and connect the accessory modules.



Stop: Xerox Europe only: Use the Xerox® Iridesse™ Production Press Installation Instructions (702P06964) and the Xerox® Iridesse™ Production Press Docking and Connection Guide (702P06434) that can be found on the LSP Training website (www.xerox-lsptraining.com). Also, use the installation instructions within this section and the instructions packed with the individual accessories to depalletize, unpack, dock and connect the accessory modules.

**7.1.1**

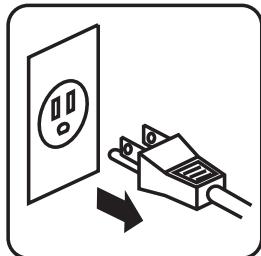
Stop: All accessories are unpacked, depalitzed (if required) and installed (if required) using the Xerox® Iridesse™ Carrier Procedures Manual (CM02700), Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964), and the accessory install instruction that are packed with most of the optional accessories.

Stop: The powering down of the system is the responsibility of the CSE.

7.1.1 The tools required to prepare the modules for the installation are shown.



disconnect all power cords to wall receptacles.



7.2.1

7AE/097S04753 (if present)



5.5 mm

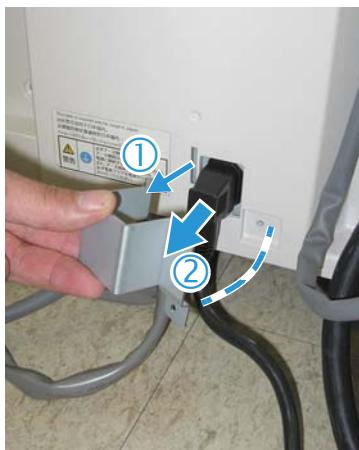


7.2.2

7AE/097S04753 (if present)



7.2.3



7.2.0 Accessories Relocation/Removal/Return - Remove Power Cords and Interface Cables

7.2.1 Disconnect all power cords from the wall receptacle on the present configuration.

7.2.2 Using a 5.5 mm hex driver, remove the single screw from the power cord protector on the rear bottom of the IDM.

7.2.3 ① Remove the power cord protector from around the power cord and ② then disconnect the power cord from the rear of the IDM. ③ Coil the power cord.

7AE/097S04753 (if present)



7.2.4



7.2.4 ① Disconnect the interface cable from the right side rear bottom edge of the IOT and ② from the rear of the IDM. ③ Coil the interface cable.

7AE/097S04753 (if present)



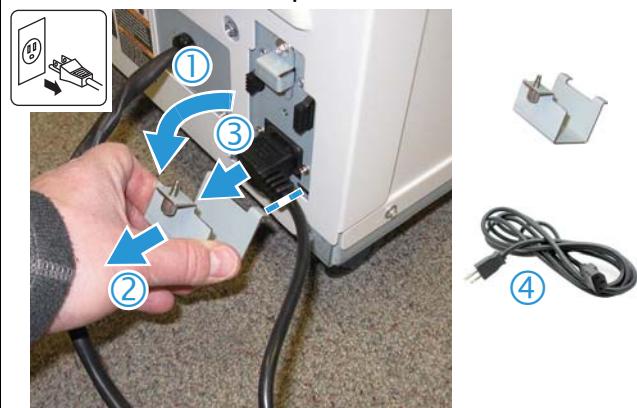
7.2.5

X5K / 497K18750 (if present)



7.2.6

X5K / 497K18750 (if present)



7.2.7

X5K / 497K18750 (if present)



7.2.8

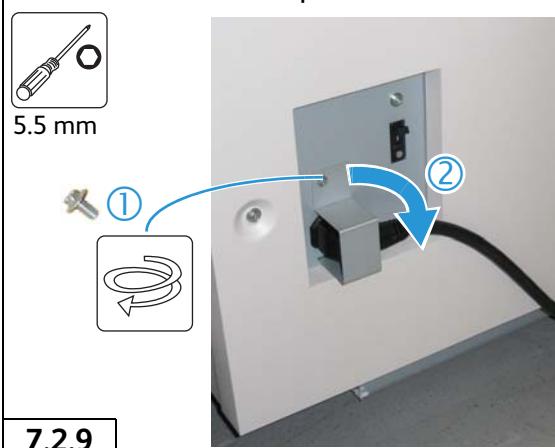
7.2.5 ① Place the power cord protector and screw, ② along with the coiled power and ③ interface cable on top of the IDM.

7.2.6 Using a flat blade screwdriver, ① loosen the captured screw, if required, securing the power cord protector on the rear bottom of the GBC. Then, ② unscrew the thumb screw.

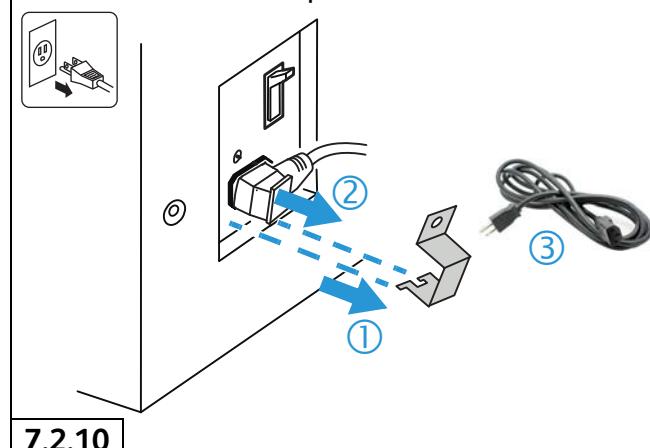
7.2.7 ① Rotate power cord protector down and ② remove from the rear of the GBC. ③ Remove power cord and ④ coil it up.

7.2.8 ① Place the power cord protector and ② coiled power cord on top of the GBC.

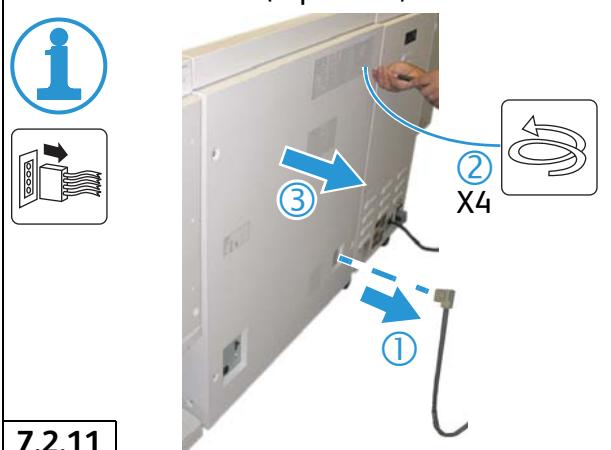
MAY / 450S03138 (if present)



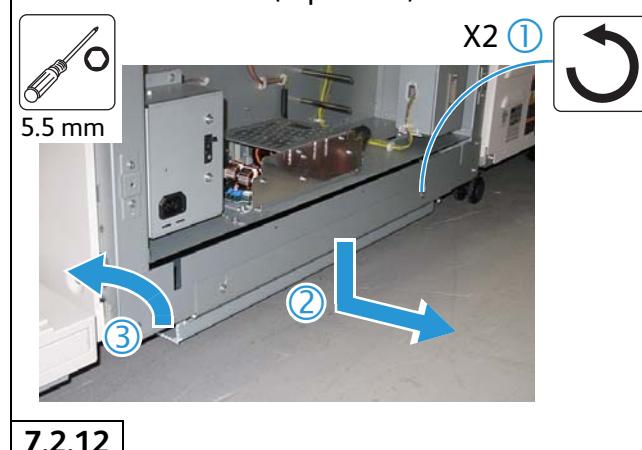
MAY / 450S03138 (if present)



MAY / 450S03138 (if present)



MAY / 450S03138 (if present)



7.2.9 Using a 5.5 mm hex driver, ① remove the single screw securing the power cord protector in place. ② Rotate the top of the protector out away from the HCS.

7.2.10 ① Remove the power cord protector and ② then the power cord from the rear of the HCS. ③ Coil the power cord up.



Note: Once the Interface cable is disconnect from the IDM it will need to be coiled and shipped with the HCS.

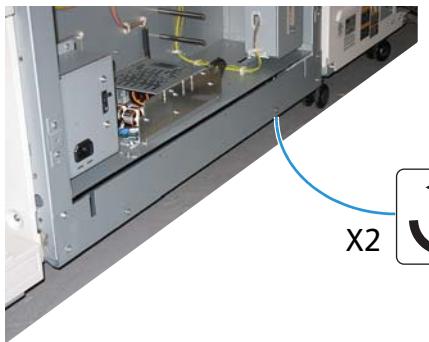
7.2.11 ① Disconnect the interface cable from the back of the HCS. ② Remove the screws (4) and ③ the rear cover of the HCS.

7.2.12 ① Loosen the two screws securing the cable channel on the rear bottom edge of the HCS. ② Remove the cable channel from the rear of the HCS ③ while removing all cables from within the cable channel.

MAY / 450S03138 (if present)

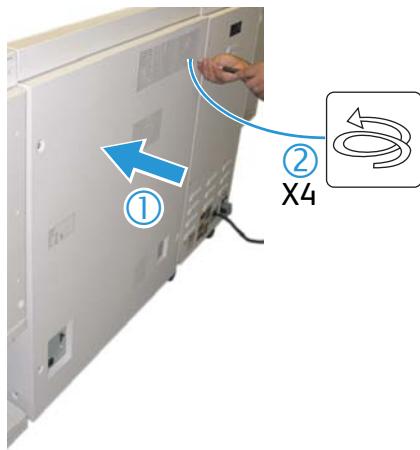


5.5 mm



7.2.13

MAY / 450S03138 (if present)



7.2.14

MAY / 450S03138 (if present)



7.2.15

7.2.13 Re-tighten the screws (2) on the rear bottom edge of the HCS.

7.2.14 ① Reinstall the HCS rear cover and
② secure in place with the original screws (4).

7.2.15 ① Place the power cord protector and
screw ② along with the coiled power cord and
③ cable channel on top of the HCS.

7.2.16 Remove the single screw securing the
power cord protector.

7XL / 450S03153 (if present)

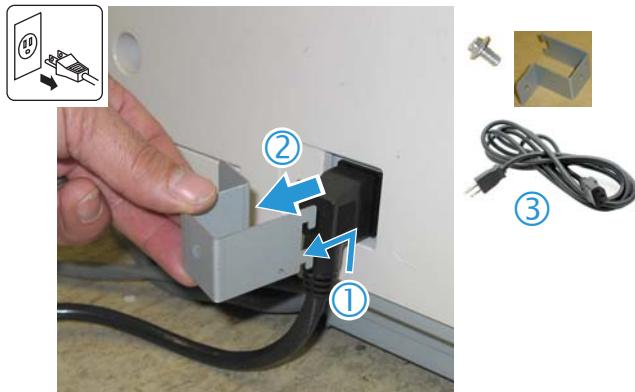


5.5 mm



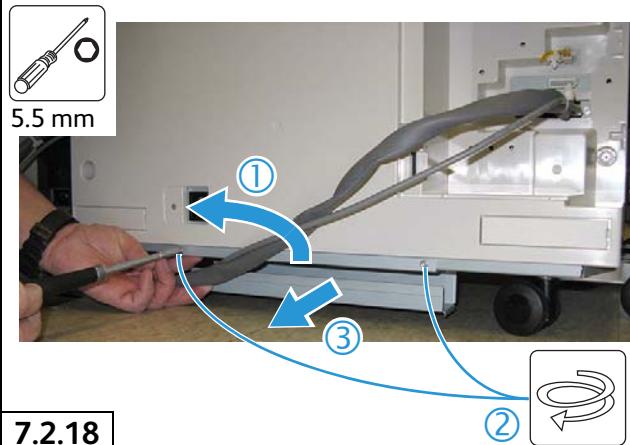
7.2.16

7XL / 450S03153 (if present)



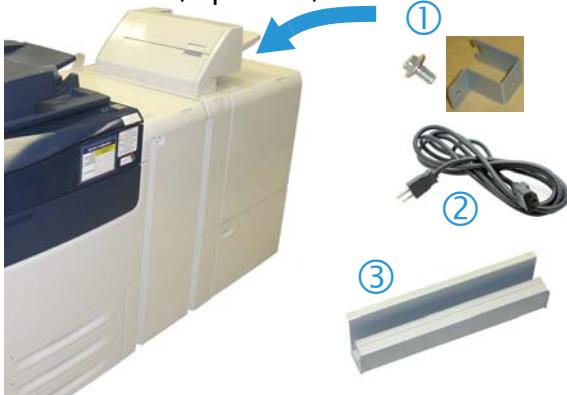
7.2.17

7XL / 450S03153 (if present)



7.2.18

7XL / 450S03153 (if present)



7.2.19

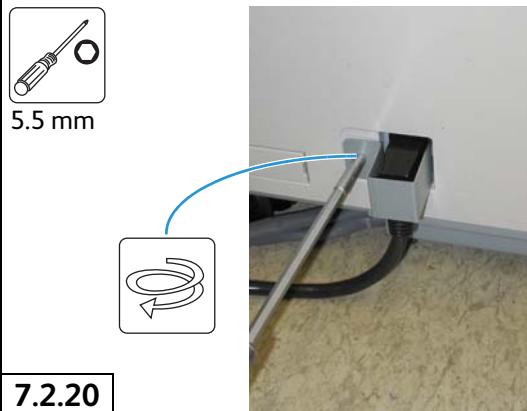
7.2.17 ① Lift and remove the protector from the rear of the Crease and Two-sided Trimmer. ② Disconnect and ③ coil the power cord.

7.2.18 ① Remove all cables from within the cable channel. Then, ② remove the two screws securing and ③ the cable channel from the rear bottom edge of the Crease and Two-sided Trimmer.

7.2.19 ① Place the power cord protector and screw ② along with coiled power cord and ③ cable channel on top of the Crease and Two-sided Trimmer.

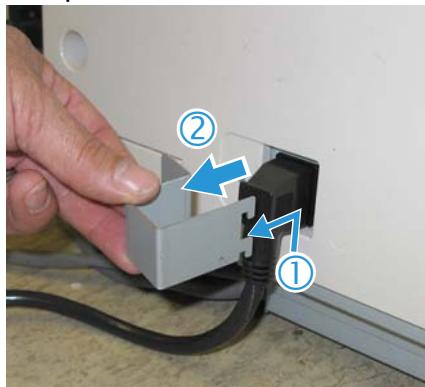
7.2.20 Using a 5.5 mm hex driver, remove the single screw securing the power cord protector on the rear bottom edge of the PR Finisher.

3AE/097S04749 / 4AE/097S04750 / 5AE/097S04751 (if present)



7.2.20

3AE/097S04749 / 4AE/097S04750 /
5AE/097S04751 (if present)



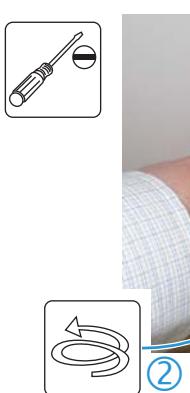
7.2.21

3AE/097S04749 / 4AE/097S04750 /
5AE/097S04751 (if present)



7.2.22

6AE/097S04752 (if present)



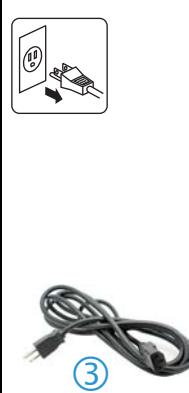
7.2.23

7.2.21 ① Lift and remove the protector from the rear of the PR Finisher. ② Disconnect and ③ coil the power cord.

7.2.22 ① Place the power cord protector and screw ② along with coiled power cord on top of the PR Finisher.

7.2.23 Using a flat blade screwdriver, ① loosen the captured thumb-screw, if required, on the rear bottom edge of the SquareFold Trimmer. Then, ② unscrew the thumb-screw securing the power cord protector in place and ③ rotate the protector away from the module.

6AE/097S04752 (if present)



7.2.24

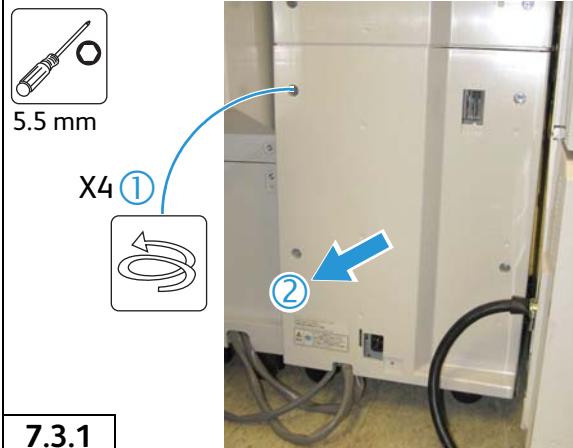
7.2.24 ① Lift and remove the protector from the rear of the SquareFold Trimmer ② Disconnect and ③ coil the power cord.

6AE/097S04752 (if present)



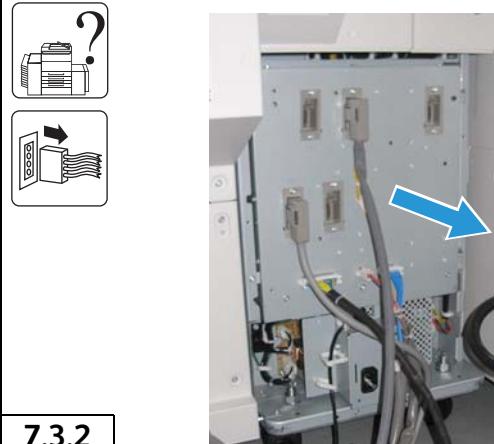
7.2.25

7AE/097S04753 (if present)



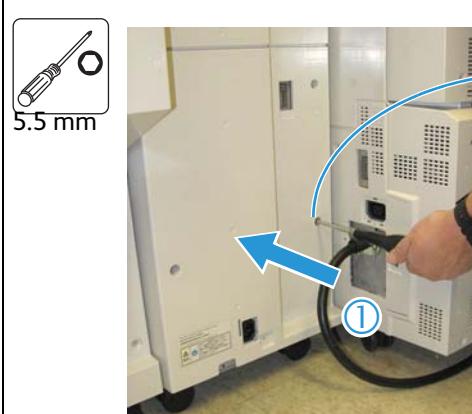
7.3.1

7AE/097S04753 (if present)



7.3.2

7AE/097S04753 (if present)



7.3.3

7.2.25 ① Place the power cord protector and screw ② along with coiled power cord on top of the SquareFold Trimmer.

7.3.0 Accessories Relocation/Removal/Return - Remove Power Cords and Interface Cables

7.3.1 ① Remove the screws (4) and ② the rear bottom cover from the IDM.

7.3.2 Disconnect all cables attached to the rear of the IDM.

7.3.3 ① Reinstall the rear bottom IDM cover and ② secure in place with screws (4).

OAE / 497K18750 (if present)



5.5 mm



X4



7.3.4

OAE / 497K18750 (if present)



7.3.5

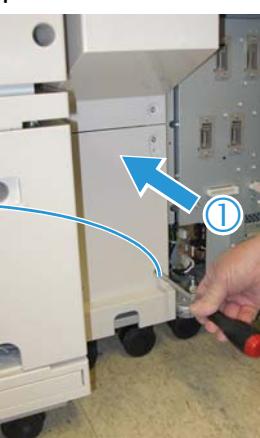
OAE / 497K18750 (if present)



5.5 mm



X4



7.3.6

X5K / 497K18750 (if present)



7.3.7

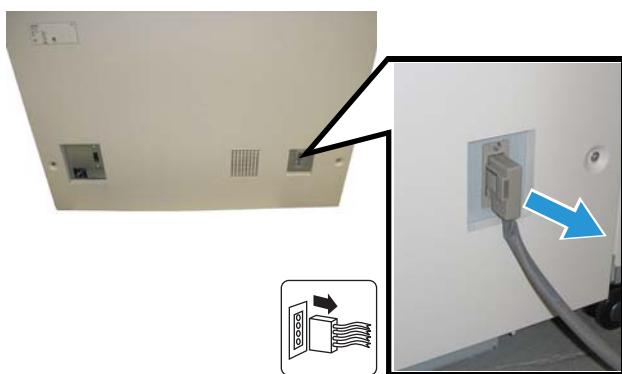
7.3.4 ① Remove the screws (4) and ② the rear cover on the Interposer.

7.3.5 Position the hardwired Interposer cables within the rear of the module.

7.3.6 ① Reinstall the rear Interposer cover and ② secure with screws (4).

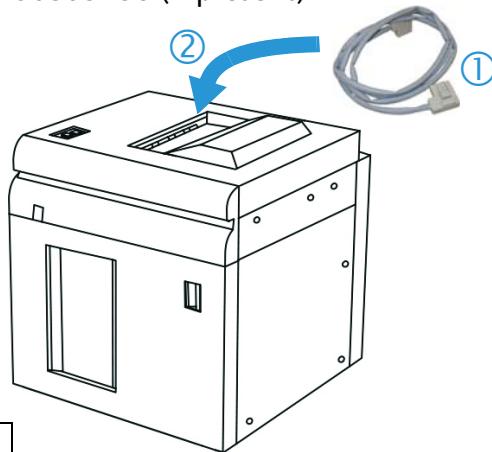
7.3.7 Position the GBC interface cable in the rear of the module.

MAY / 450S03138 (if present)



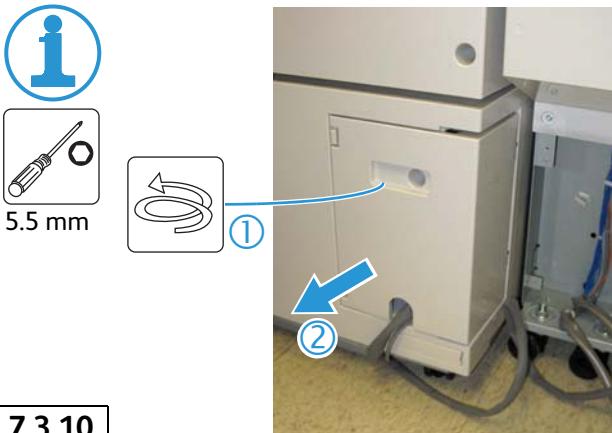
7.3.8

MAY / 450S03138 (if present)



7.3.9

7XL / 450S03153 (if present)



7.3.10

7.3.8 Disconnect the interface cable from the rear of the HCS.

7.3.9 ① Coil and ② place the interface cable on top of the HCS with the other items place on top of the module earlier.



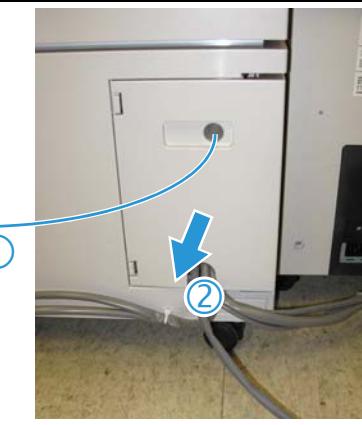
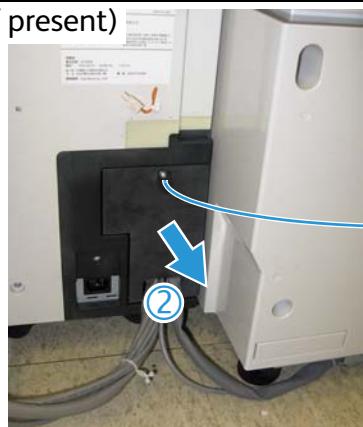
Note: If a Crease and Two-sided Trimmer is present, this module could be attached to a CZ Folder (2AE / 450S03139) if present or a PR Finisher (3AE, 4AE, 5AE) if present.

7.3.10 ① Remove the single screw and ② cover from the rear bottom of the Crease and Two-sided Trimmer.

7XL / 450S03153 (if present)



5.5 mm

3AE/097S04749 / 4AE/097S04750 /
5AE/097S04751(if present)**7.3.11**

7XL / 450S03153 (if present)



OR

3AE/097S04749 / 4AE/097S04750 /
5AE/097S04751(if present)**7.3.12**

Note: If both a CZ Folder and PR Finisher are present, the Crease and Two-sided Trimmer is attached to the CZ Folder. It is when the PR Finisher by itself is present that the Crease and Two-sided Trimmer is connected to this module.

7.3.11 ① Remove the single screw and ② cover from the CZ Folder (if present) and/or the PR Finisher (if present).

7.3.12 ① Disconnect all cables run to the rear of the CZ Folder (if present) ② and/or PR Finisher (if present).

7XL / 450S03153 (if present)



5.5 mm



7.3.13



7XL / 450S03153 (if present)



7.3.14

7XL / 450S03153 (if present)



5.5 mm



7.3.15

3AE/097S04749 / 4AE/097S04750 /
5AE/097S04751(if present)

5.5 mm



7.3.16



7.3.13 If CZ Folder is present, ① position the hardwired cables in the rear of the module. ② Reinstall CZ Folder rear cover and ③ secure with single screw.

7.3.14 ① Coil the hardwired cables up in the back of the Crease and Two-sided Trimmer and ② position them within the opening in the rear of the module.

7.3.15 ① Reinstall the Crease and Two-sided Trimmer rear bottom cover and ② secure with the single screw.

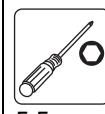
7.3.16 ① Reinstall the rear bottom cover on the PR Finisher and ② secure with the single screw.

3AE/097S04749 / 4AE/097S04750 /
5AE/097S04751(if present)



7.3.17

6AE/097S04752 (if present)



5.5 mm



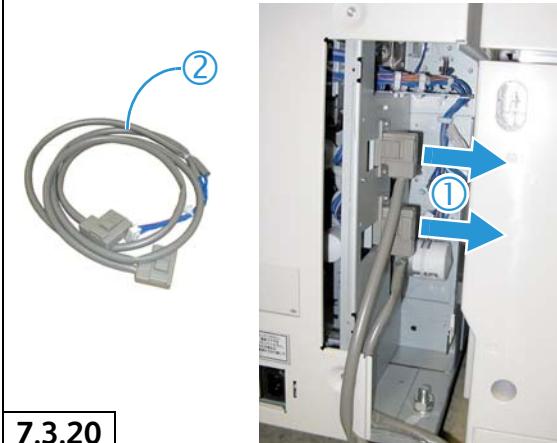
7.3.18

6AE/097S04752 (if present)



7.3.19

6AE/097S04752 (if present)



7.3.20

7.3.17 Place the interface cable on top of the PR Finisher with the other items.

7.3.18 ① Remove the screws (2) and ② remove the rear right cover from the SquareFold Trimmer.

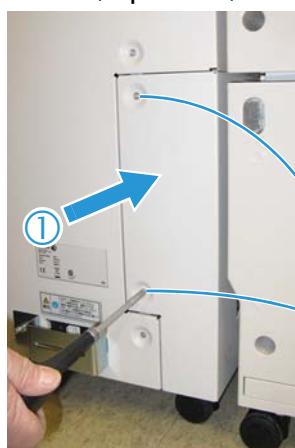
7.3.19 ① Open the cable clip and ② remove the cables routed through the clip.

7.3.20 ① Disconnect the interface cables from within the rear right cavity. Coil the interface cable up.

6AE/097S04752 (if present)



5.5 mm



7.3.21

6AE/097S04752 (if present)

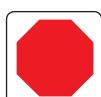


7.3.22

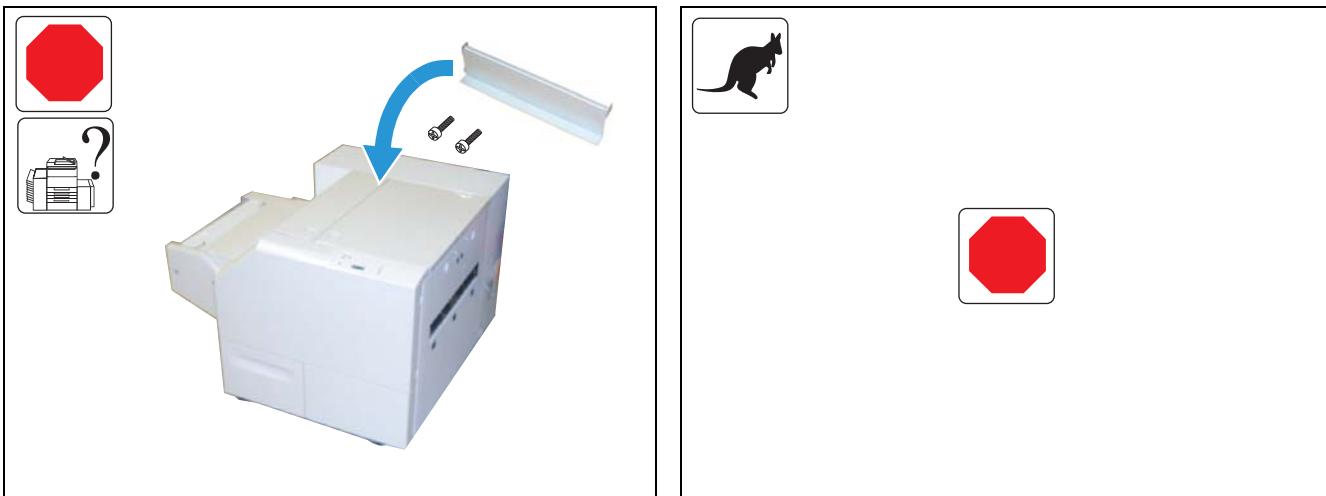
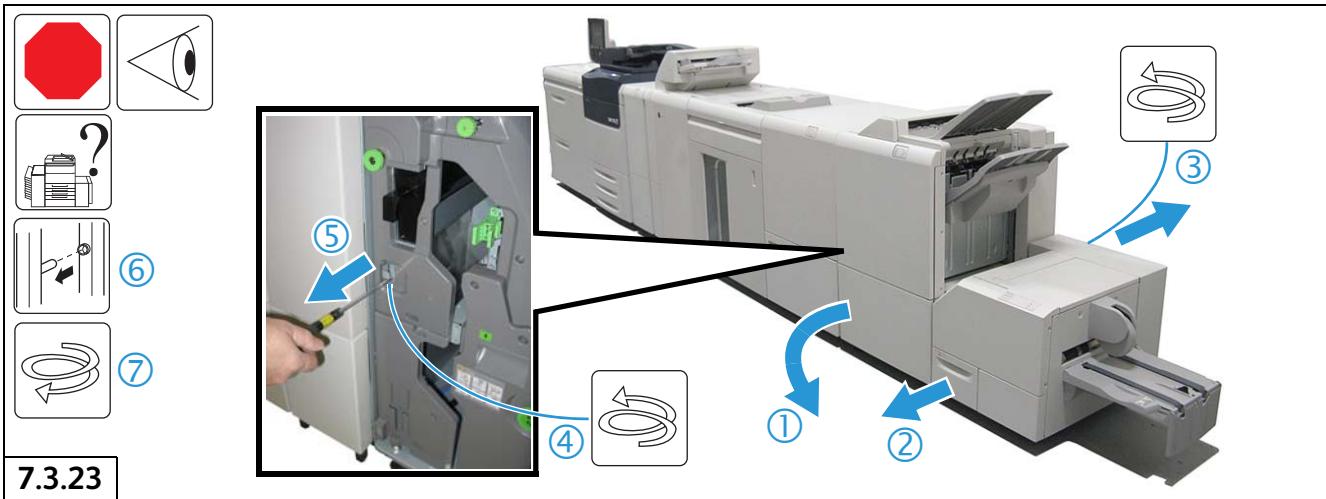


7.3.21 ① Reinstall the SquareFold rear cover and
② secure with two screws.

7.3.22 Place the coiled interface cable on top of
the SquareFold Trimmer.



Stop: All interface cables and power
cords, along with power cord protectors
and cable channels (if present) should be
placed on top of the appropriate modules. It is
critical that these items stay with the modules
that they were removed from.

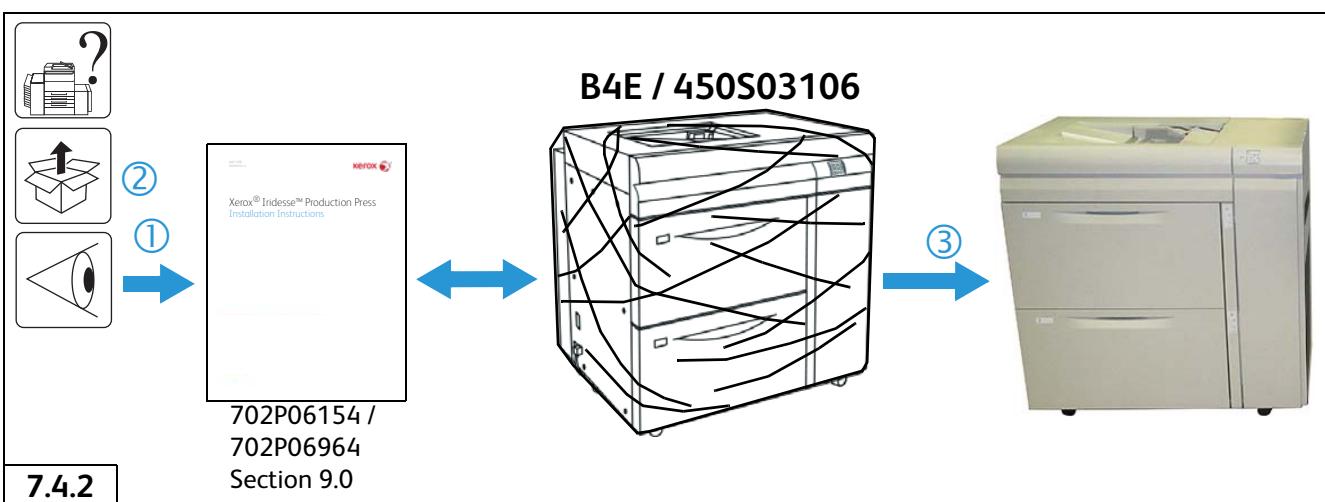
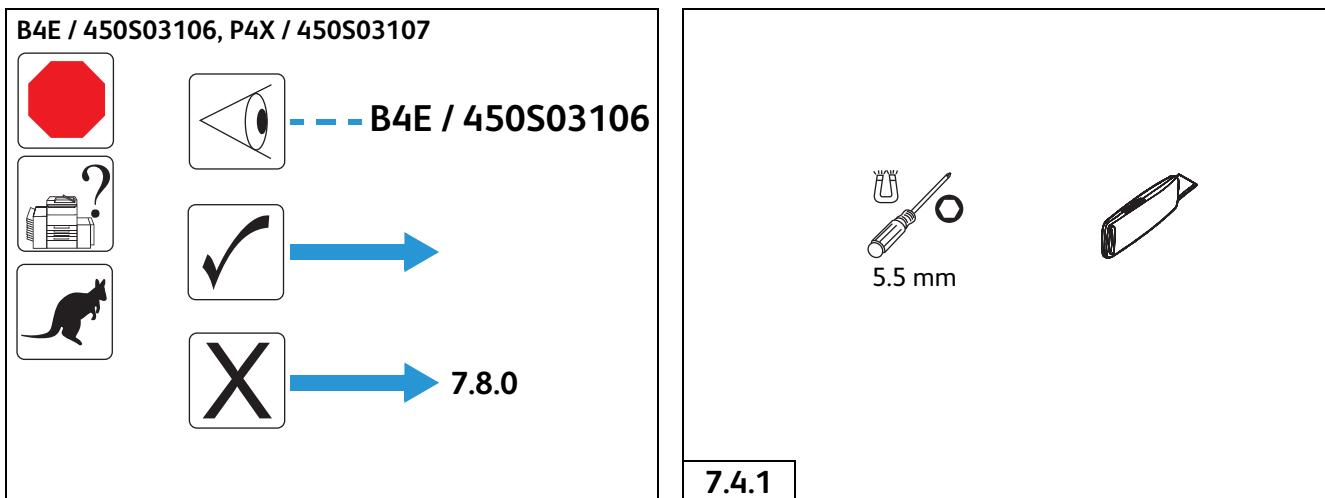


Stop: Depending on which modules are present, refer to the install process and docking steps of the individual modules. Using these procedures, go through and undock all modules starting with the right most accessory and working back to the left toward the IOT.

7.3.23 Depending on which configuration is present, ① open front covers (if required), ② remove waste tray (if applicable), ③ remove rear cover (if required), ④ remove docking screws, ⑤ disengage docking latches and ⑥ undock the individual modules. ⑦ Reinstall all docking latch screws back into their original locations.

Stop: Docking brackets from module to the left along with screws (2) must be removed from upstream module and kept with appropriate module. Docking bracket and screws (2) must be placed on top of appropriate module for repacking within individual Relocation/Removal processes.

Stop: Proceed to the Relocation/Removal/Return processes, per accessory, for the handling of the individual module.

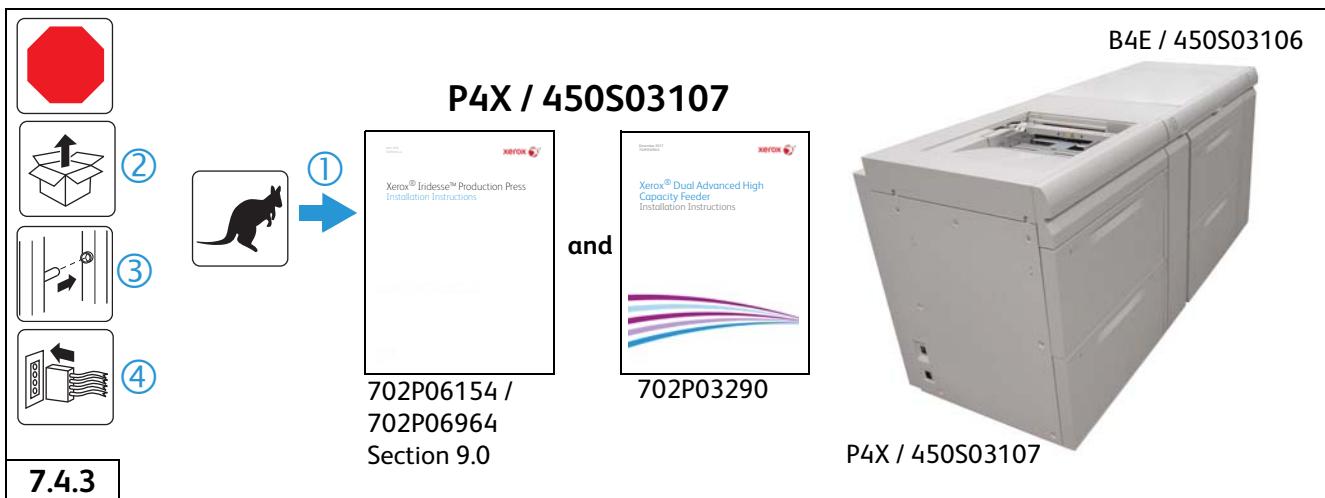
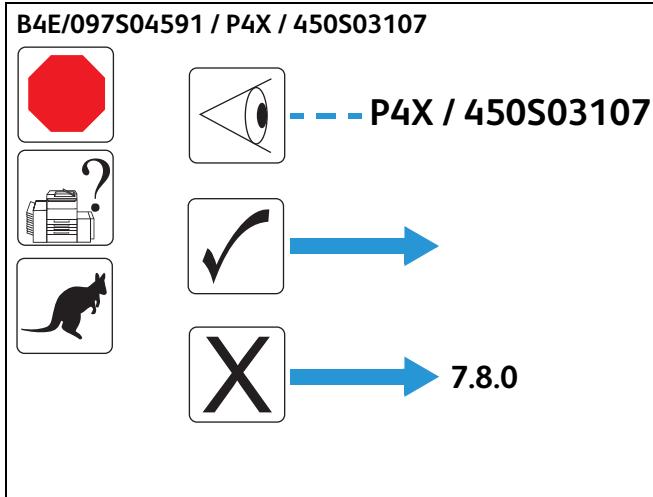


7.4.0 Accessory A: Delivery - Preparing the Over-size High Capacity Feeder (OHCF) (B4E / 450S03106) (if present) and Dual Advanced High Capacity Feeder (DAHCF) (P4X / 450S03107) (if present)

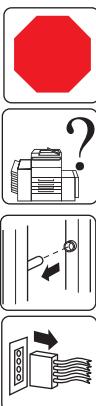
 Stop: If an OHCF (B4E / 450S03106) is present, continue on to the next step. If an OHCF is not present, go to 7.8.0 - "Accessory C: Delivery - Depalletize, Unpack, and Install the Interface Decurler Module (IDM) (7AE/097S04753) (if present)" on page 7-30.

7.4.1 The tools required to unpack and prepare the Xerox® Iridesse™ Production Press - OHCF and DAHCF, if present, are shown.

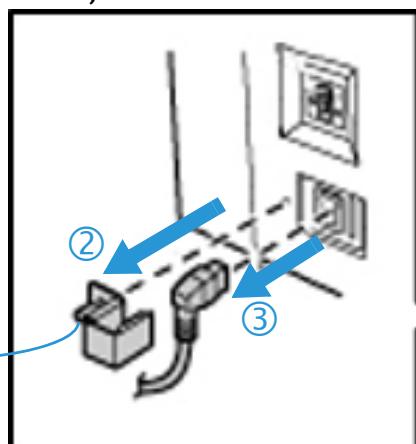
7.4.2 ① Refer to ‘Section 9.0’ within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) to ② unpack and ③ position the OHCF (B4E / 450S03106).



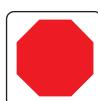
7.4.3 ① Refer to 'Section 9.0' within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and the Xerox® Dual Advanced High Capacity Feeder Installation Instructions (702P03290) to ② unpack ③ dock and connect ④ the DAHCF (P4X / 450S03107) to the OHCF (B4E / 450S03106).

B4E / 450S03106, P4X / 450S03107B4E / 450S03106,
configuration is shown**B4E / 450S03106, P4X / 450S03107****B4E / 450S03106, P4X / 450S03107**

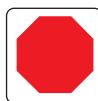
7.5.1



7.5.0 Preparing the OHCF (B4E / 450S03106) (if present) and the Dual Advanced High Capacity Feeder (DAHCF) (P4X / 450S03107) (if present) for a Relocation or Removal



Stop: It is the responsibility of the CSE to undock and disconnect the OHCF or OHCF / DAHCF configuration assembly (if present) from the IOT Left. Carriers should find the feeder(s) positioned next to the IOT Left (2XL/100S14375 / XiPP120V_F).



Stop: If the move of the system is within the same room or is a room-to-room move, the DAHCF (if present) can remain docked to the OHCF, providing no obstacles need to be overcome. If the move of the OHCF / DAHCF assembly encounters an obstacle between loca-

tions, needs to be moved to a different floor within a building or needs to be moved to the truck for the relocation, the two modules will need to be undocked.



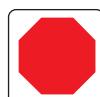
Note: The handling of the DAHCF (P4X / 450S03107) is identical to that of the OHCF (B4E / 450S03106).

7.5.1 ① Unscrew the thumbscrew and ② remove the power cord protector from the side of the OHCF and DAHCF (if present). ③ Disconnect the power cord(s) from the modules. ④ Place the coiled power cord and ⑤ protector on top of the corresponding module.

B4E / 450S03106**7.5.2****B4E / 450S03106, P4X / 450S03107****7.5.3****P4X / 450S03107****B4E / 450S03106****P4X / 450S03107****7.5.4**

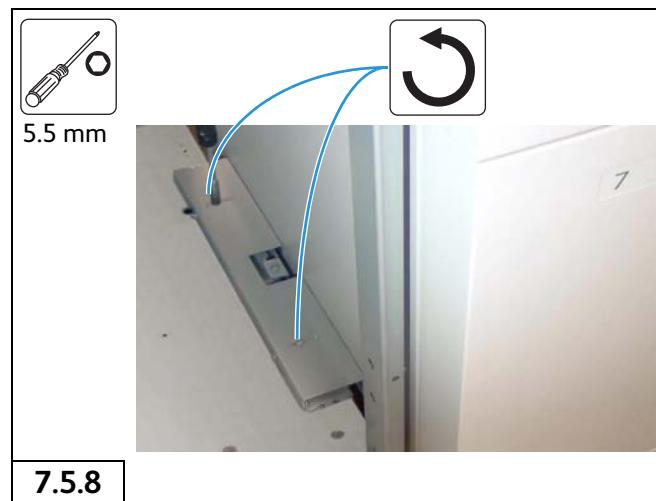
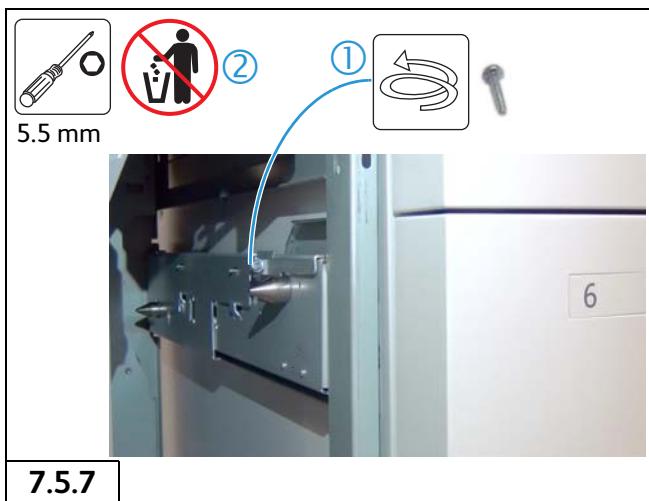
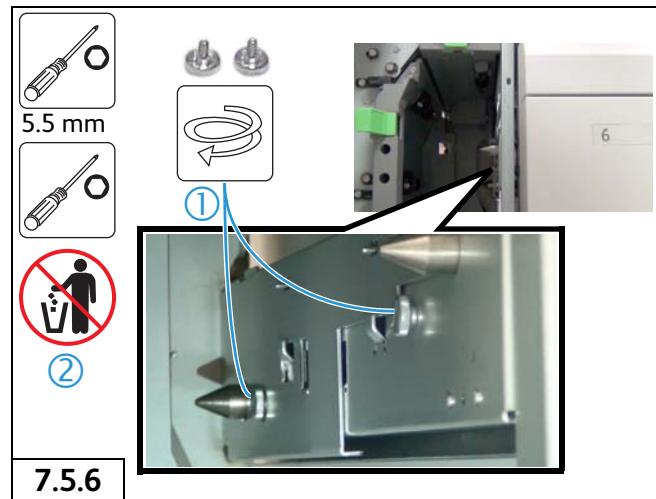
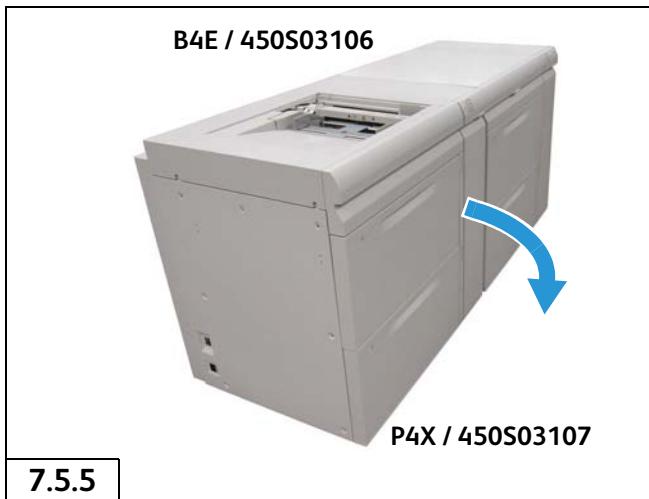
7.5.2 ① If an OHCF only is present, ② unlock the casters and ③ move the module to the new location.

7.5.3 ① If the undocking of the DAHCF is not required, ② unlock the casters in the front of the OHCF and DAHCF. ③ Move the OHCF / DAHCF assembly to the new location.



Stop: If a DAHCF is present, and needs to be undocked, continue on to the next step. If not, go to step 7.5.16 on page 7-24.

7.5.4 Disconnect the two communication cables from the DAHCF in the rear of the module.

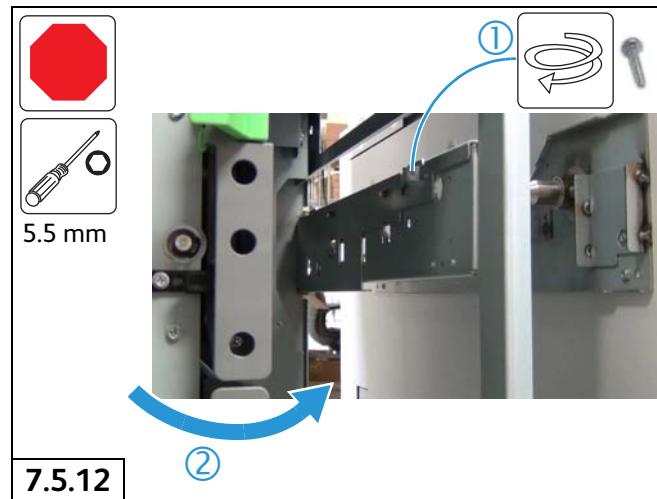
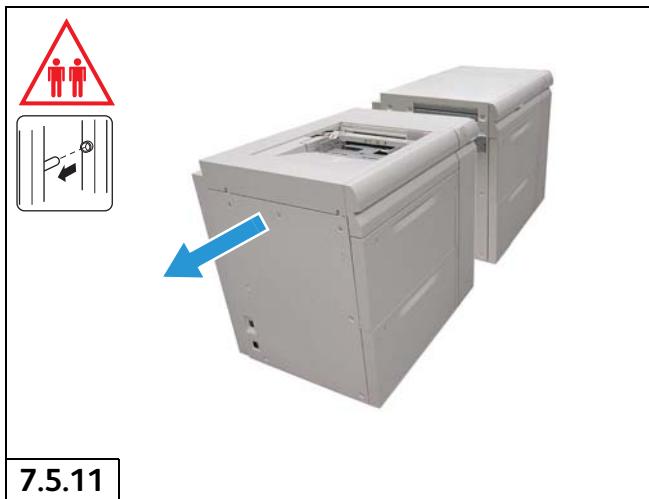
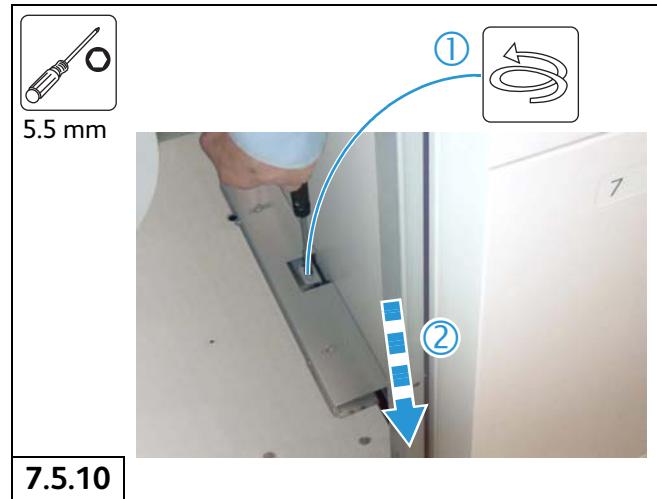
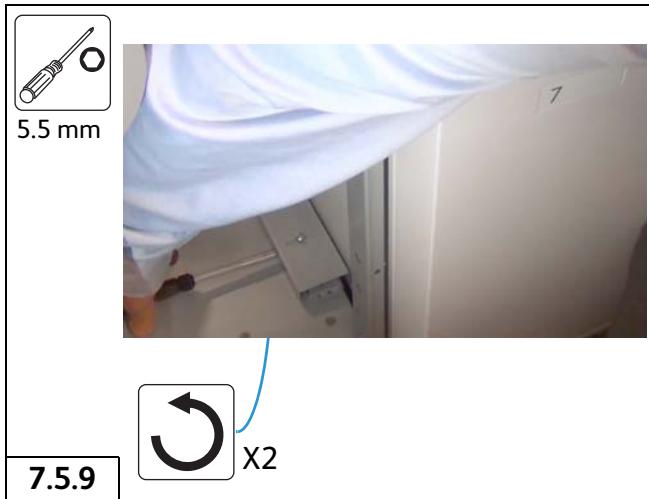


7.5.5 Open the front cover of the DAHCF.

7.5.6 ① Remove the two thumb-screws from the docking bracket inside the DAHCF. ② Do not discard the thumb-screws.

7.5.7 ① Remove the single screw securing the DAHCF to the OHCF. ② Do not discard.

7.5.8 Loosen the two securing screws from the top of the docking bracket assembly.



7.5.9 Loosen the two securing screws from the inside edge of the lower docking bracket assembly.

7.5.10 ① Loosen the single screw on the top of the lower docking bracket assembly, ② releasing the assembly from the OHCF right frame member.

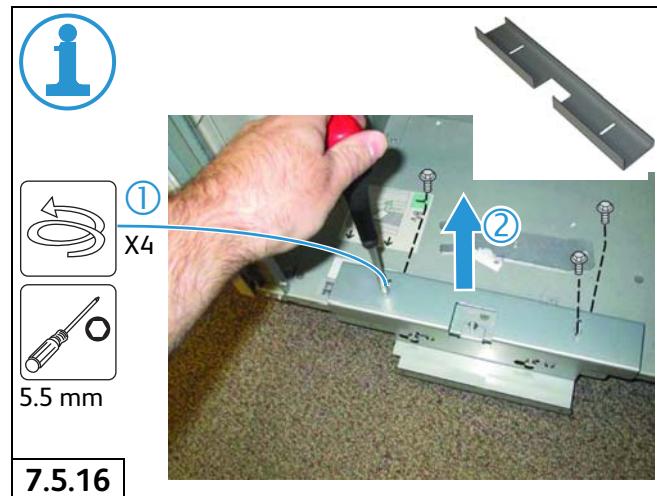
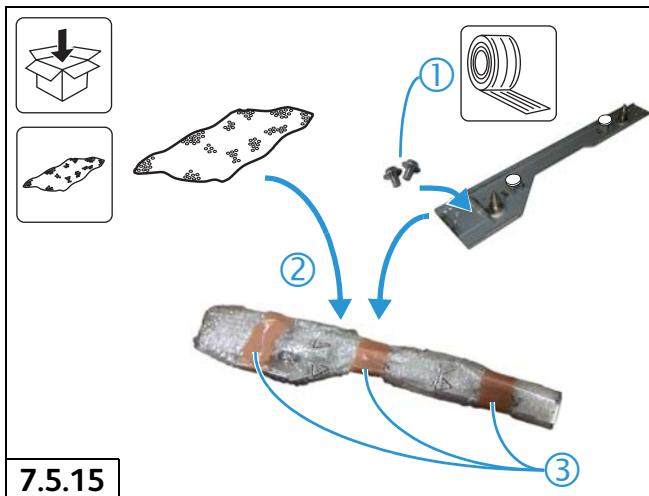
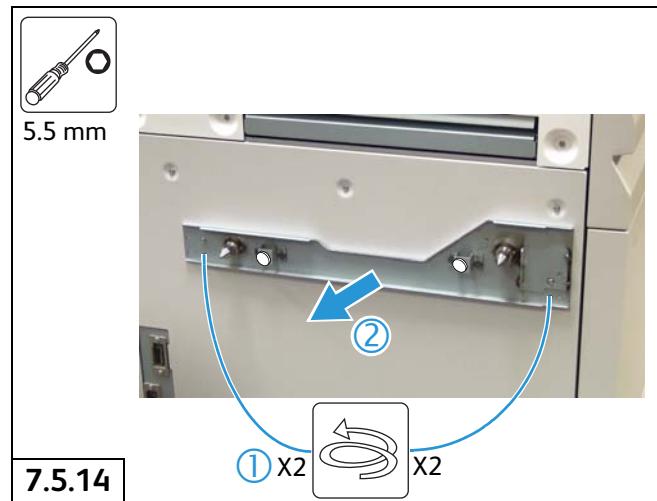
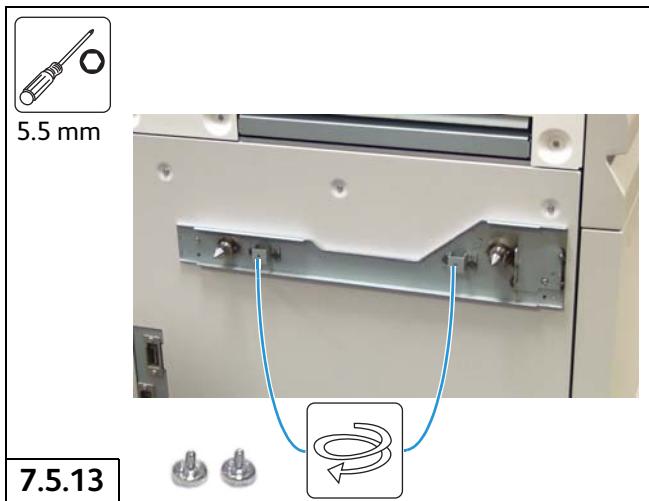


WARNING: Due to the size and weight of the DAHCF (P4X / 450S03107), two people will be required to undock this module from the OHCF (B4E / 450S03106).

7.5.11 Undock the DAHCF from the OHCF.

Stop: If a DAHCF (P4X / 450S03107) is present, repeat step 7.5.1 - 7.5.29 for preparing this module. If not, continue on to the next step.

7.5.12 ① Reinstall the single long securing screw into the original hole within the inside right side of the DAHCF. ② Close the front right cover of the DAHCF.



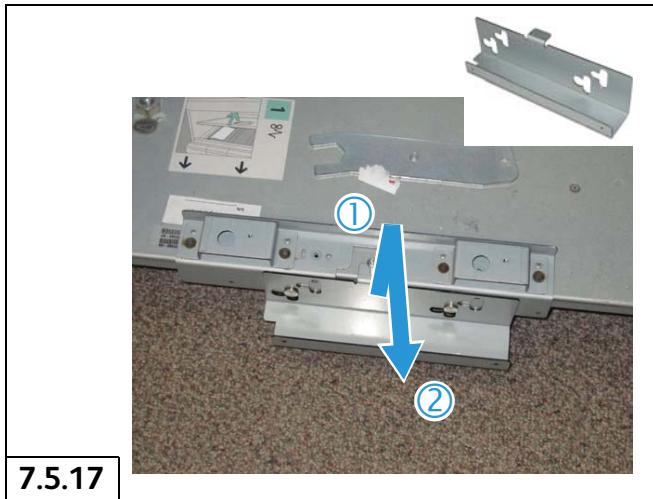
7.5.13 Reinstall the two thumb-screws back into the upper docking bracket on the left side of the OHCF (B4E / 450S03106).

7.5.14 ① Remove the four screws, two on each end, from the docking bracket. ② Remove the docking bracket from the left side of the OHCF (B4E)

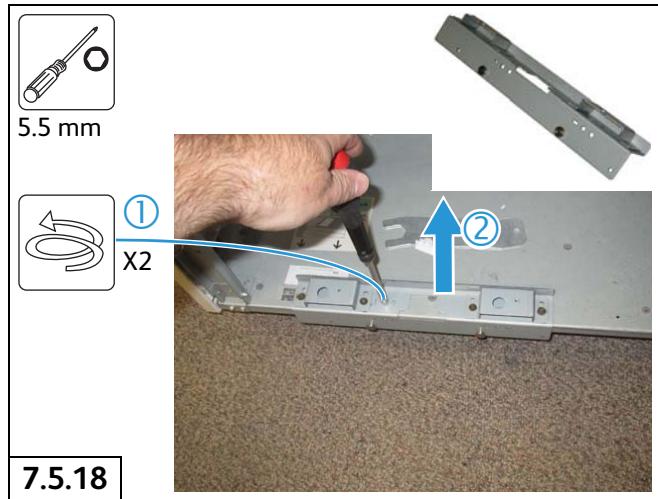
7.5.15 ① Tape the four securing screws to the docking bracket. ② Wrap the docking bracket in a layer of bubblepack and ③ secure with tape.

Note: Two of the securing screws are located on the inside surface of the bracket and two are located on the top surface of the bracket.

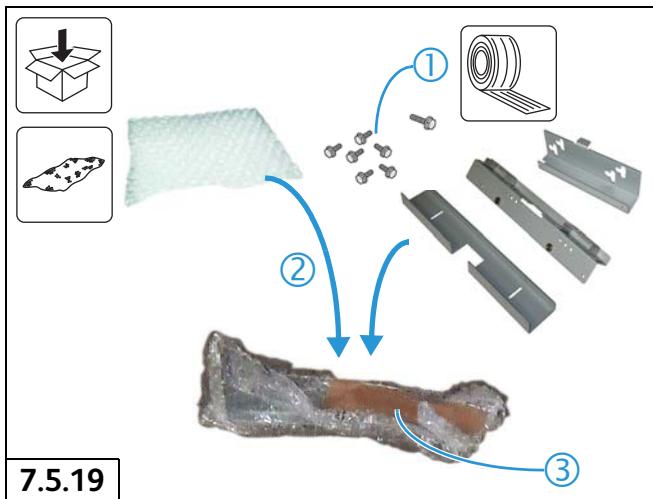
7.5.16 ① Remove the four screws from the upper bracket and ② remove the bracket from the OHCF bracket assembly.



7.5.17



7.5.18

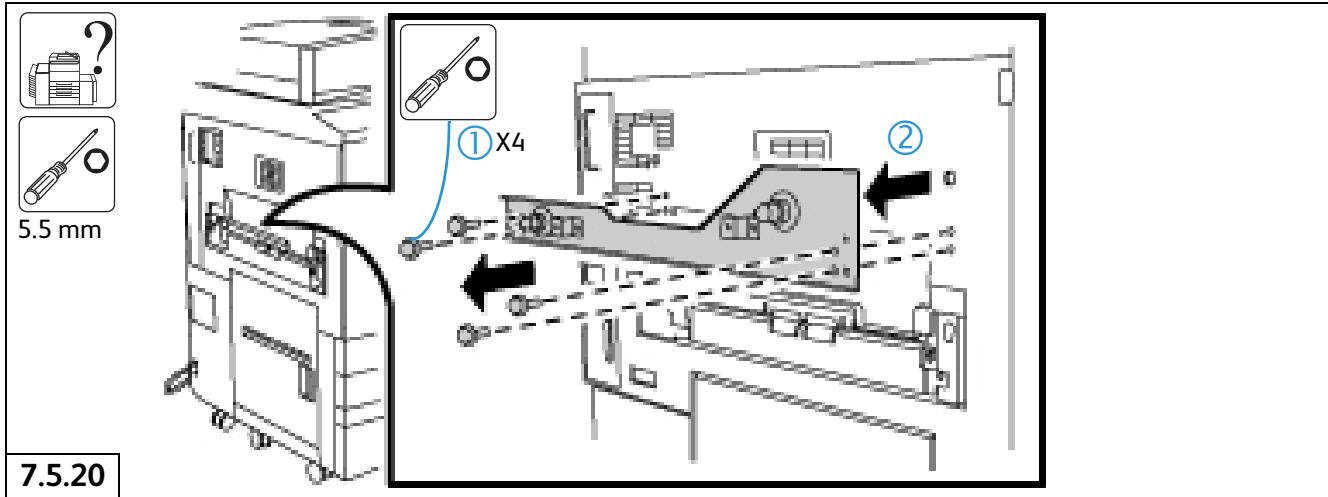


7.5.19

7.5.17 ① Slide the middle bracket up and ② off the studs on the side of the OHCF frame.

7.5.18 ① Remove the two screws and ② the lower bracket from the OHCF.

7.5.19 ① Tape the seven screws to one of the three brackets and ② then wrap the three brackets together in bubblepack and ③ secure with tape.



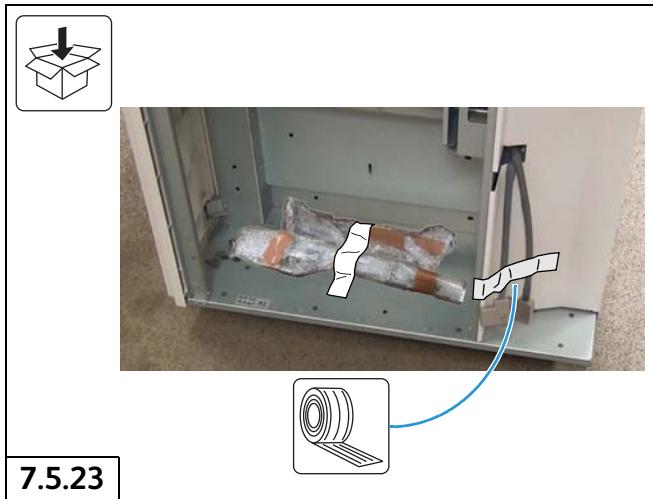
7.5.20 If the OHCF only is present, ① remove the four screws securing the docking bracket to the left side of the IOT Left module. ② Remove the docking bracket from the module.



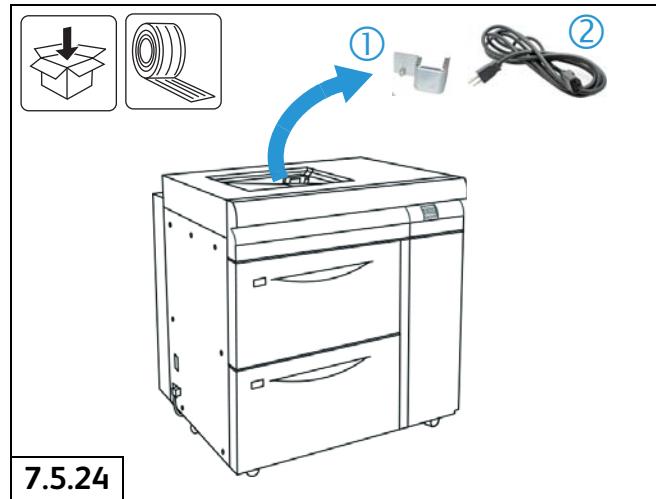
Note: The lower docking bracket assembly and upper docking bracket will need to be stored within both the DAHCF, if present, and the OHCF, if present.

7.5.21 ① Place the bubblepack lower docking brackets and ② upper docking bracket inside the right side of the DAHCF and/or OHCF if module.

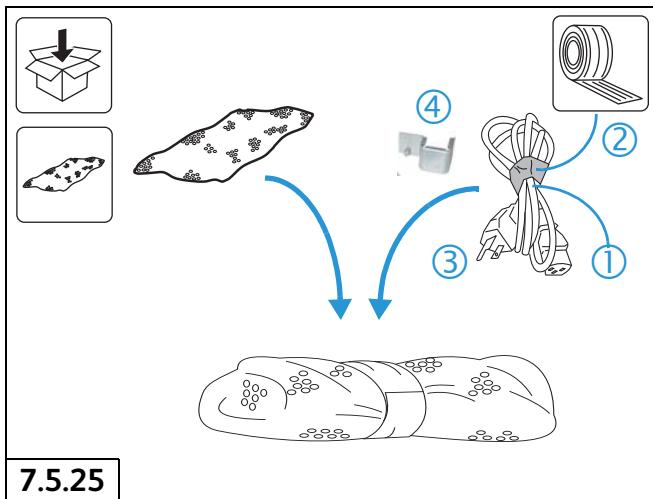
7.5.22 Secure the brackets in place with tape.



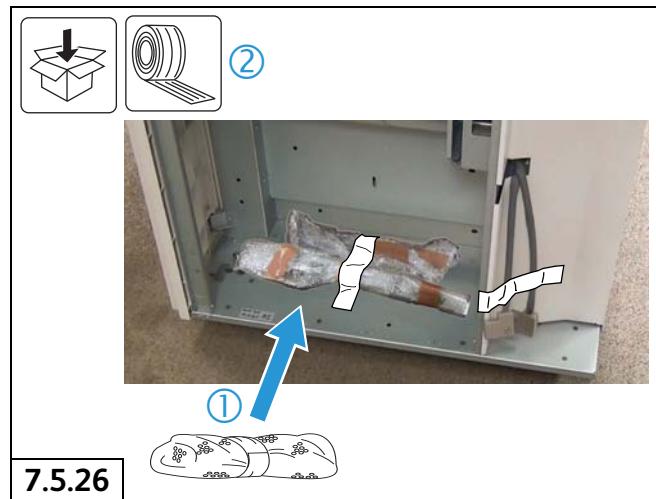
7.5.23



7.5.24



7.5.25



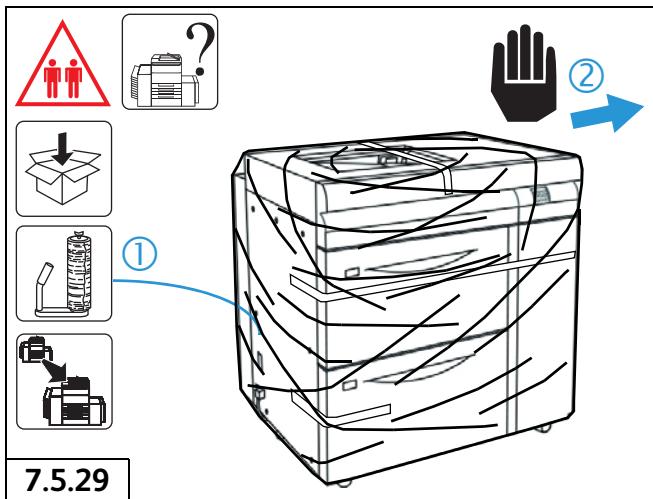
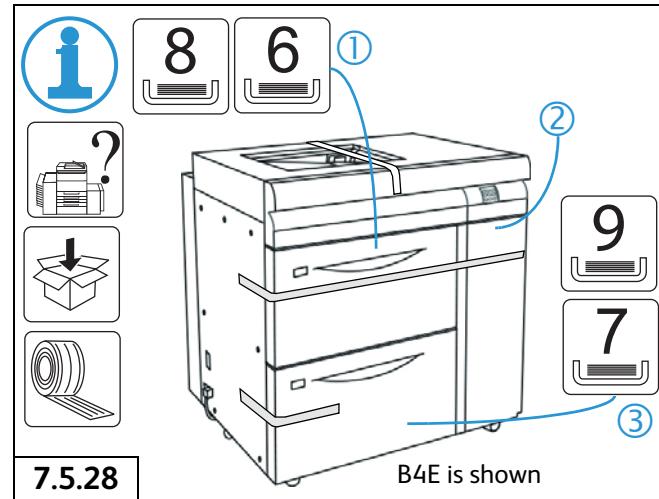
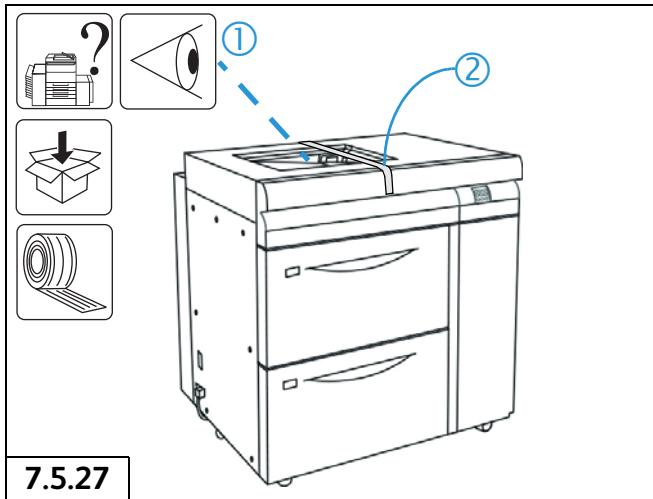
7.5.26

7.5.23 Secure the interface cable on the right side rear edge of the module with tape.

7.5.24 ① Remove the protector and ② coiled power cord from the top input tray.

7.5.25 ① Coil and ② tape the power cord. ③ Wrap the power cord and ④ power cord protector in a piece of bubblepack.

7.5.26 ① Place the coiled power cord and protector in the right side bottom of the module.
② Secure the bundle in place with tape.



7.5.27 ① If MSI Tray is present, ② secure the MSI in place by running a piece of tape from front to rear over the top of the MSI Tray to the rear of the module.



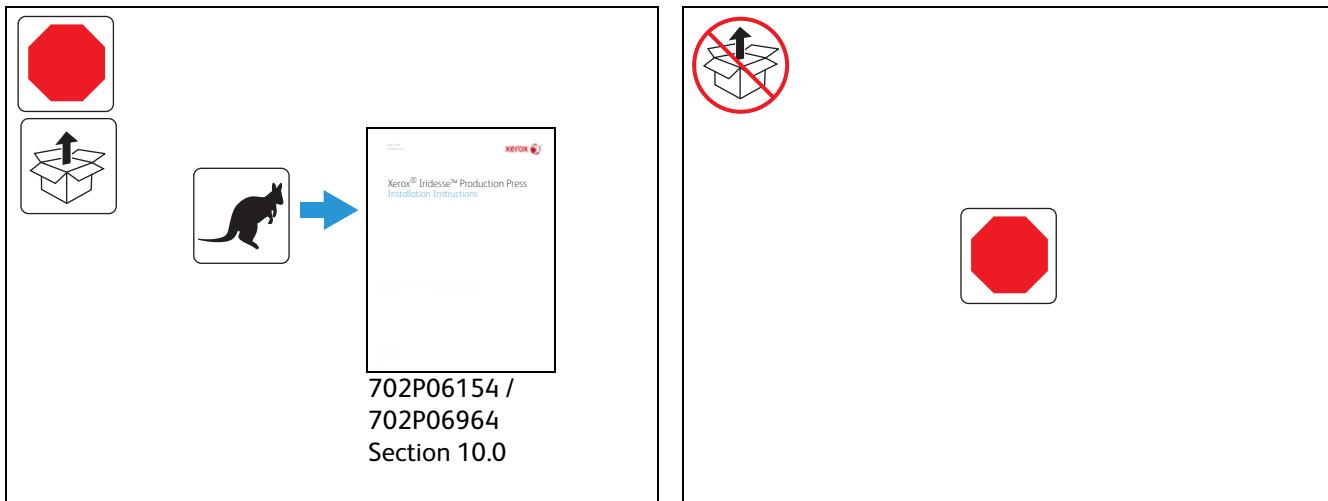
Note: Tray 6 and Tray 7 are found on the OHCF (B4E / 450S03106). Trays 8 and Tray 9 are found on the DAHCF (P4X / 450S03107) (if present).

7.5.28 ① Secure paper tray 6 or 8 and ② the front right cover by running a piece of tape across the entire front of the OHCF. ③ Secure paper tray 7 or 9 with tape.



WARNING: Due to the weight and size of the OHCF/DAHCF, two people will be required to move the module.

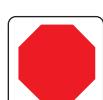
7.5.29 ① Secure the OHCF (if present) and ② DAHCF (if present) by stretchwrapping the module and ③ moving the module to the new location or truck.

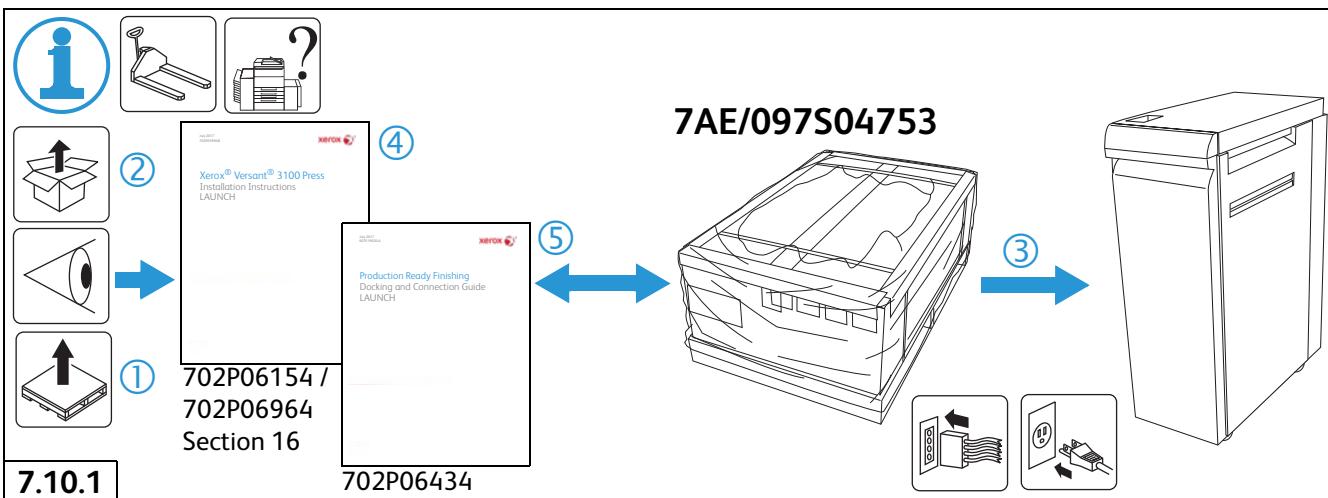
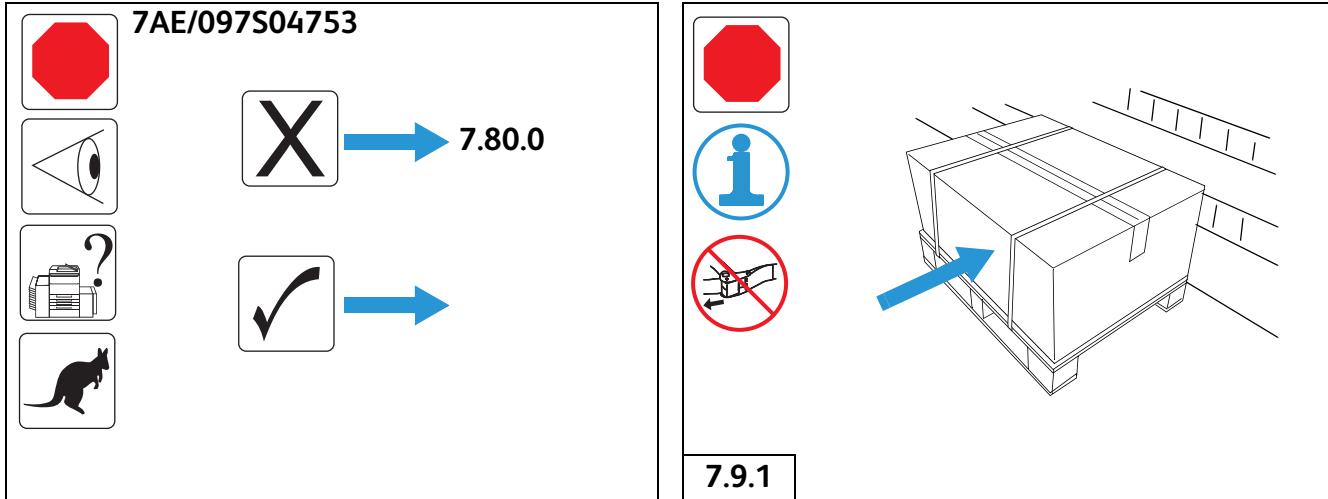


7.6.0 Accessory B: Delivery - Preparing the MSI Tray (497K09130) for Installation

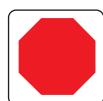
 **Stop:** If a DAHCF (P4X / 450S03107) is present, refer to Section 10.0 within the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) for the installation of the MSI Kit (497K09130).

7.7.0 Relocation or Removal - Preparing the MSI Tray for the Move

 **Stop:** The MSI Tray is to remain installed within the top of the DAHCF (P4X / 450S03107) module.

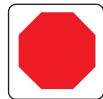


7.8.0 Accessory C: Delivery - Depalletize, Unpack, and Install the Interface Decurler Module (IDM) (7AE/097S04753) (if present)



Stop: If an IDM is not present, go to 7.80.0 "Accessory K: Delivery - Preparing the EFI™ Standalone NX Premium DFE (2A8/097N02291)" on page 7-128. If an IDM is present, continue to the next step.

7.9.0 Strapping the IDM



Stop: The IDM should be delivered to the Customer location fully packaged.



Due to the size of the palletized IDM, no strap is required.

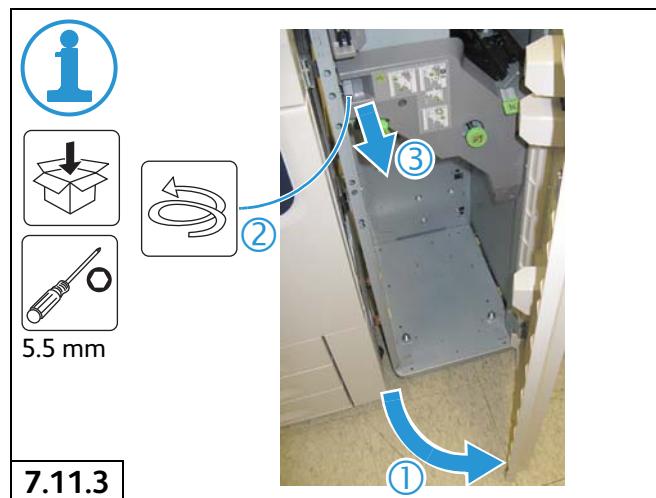
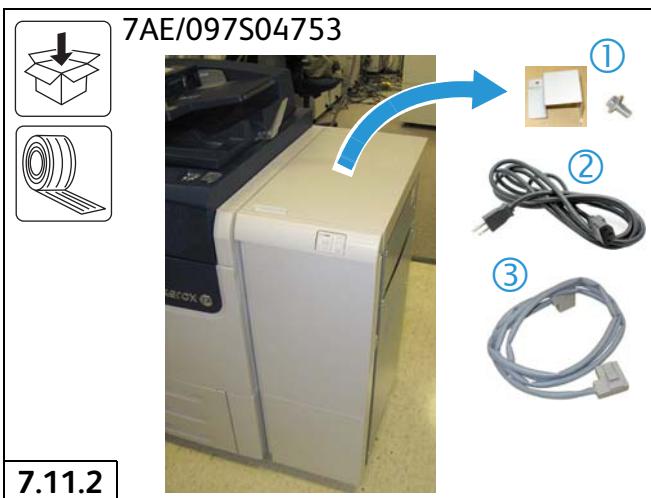
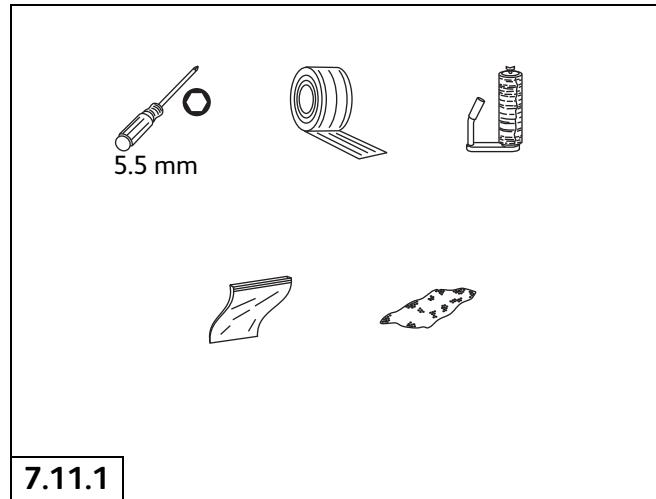
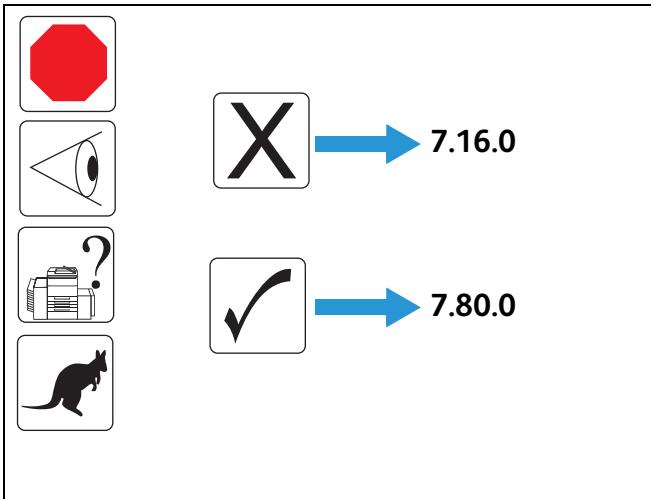
7.9.1 Place fully packaged IDM against the wall of the truck.

7.10.0 Install the IDM



Note: Installation of the IDM includes docking and making all electrical connections.

7.10.1 ① Depalletize, ② unpack, and ③ install the IDM (7AE/097S04753) using the ④ Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and ⑤ Production Ready Finishing Docking and Connection Guide (702P06434).



Stop: If additional finishing accessories are present, go to 7.16.0 "Accessory D: Delivery - Depalletize, Unpack, and Install the Interposer Module (0AE/097S04746) (if present)" on page 7-38. If there are no additional finishing accessories, go to 7.80.0 "Accessory K: Delivery - Preparing the EFI™ Standalone NX Premium DFE (2A8/097N02291)" on page 7-128.

7.11.0 Relocation - Preparing the IDM (if present) for the Move

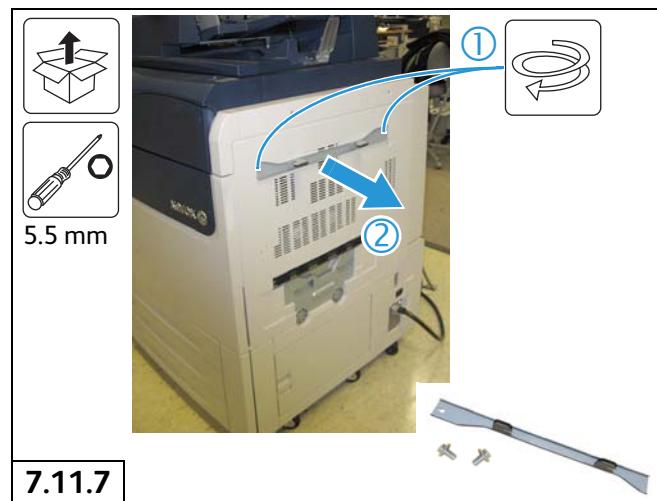
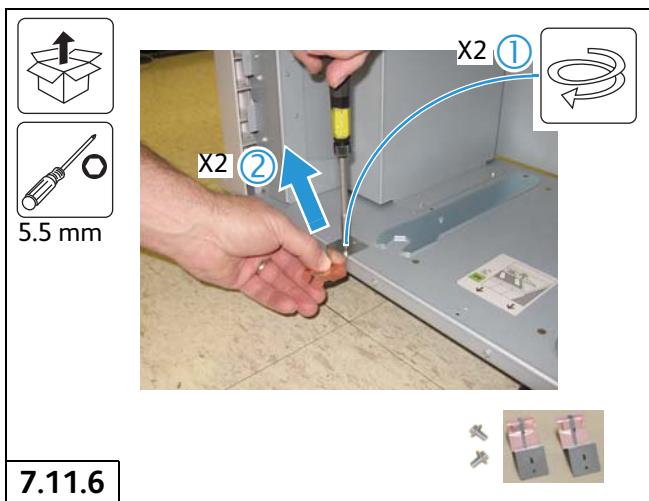
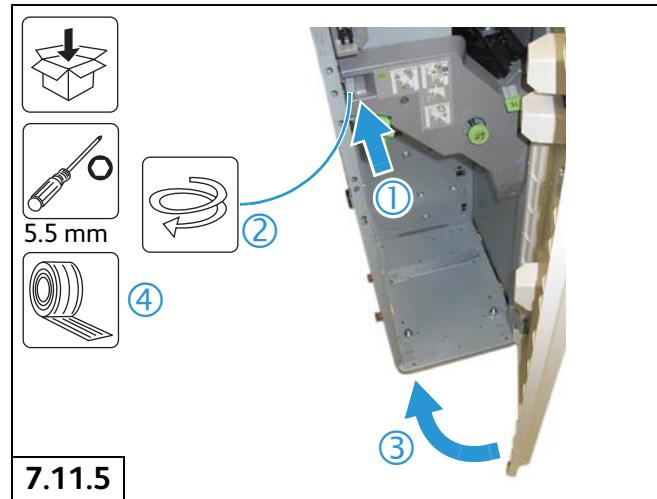
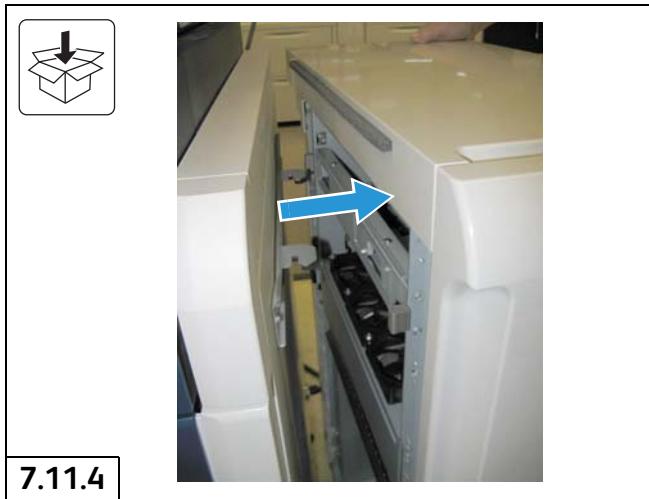
7.11.1 The tool and materials required to relocate an IDM are shown.

7.11.2 ① Remove the power cord protector and screw, ② power cord, and ③ interface cable from the top of the IDM



Note: The locking screw will release the docking bracket from the Processor.

7.11.3 ① Open the front door of the IDM, ② remove the locking screw from the upper left side, and ③ slide latch toward front of IDM to unlatch module.



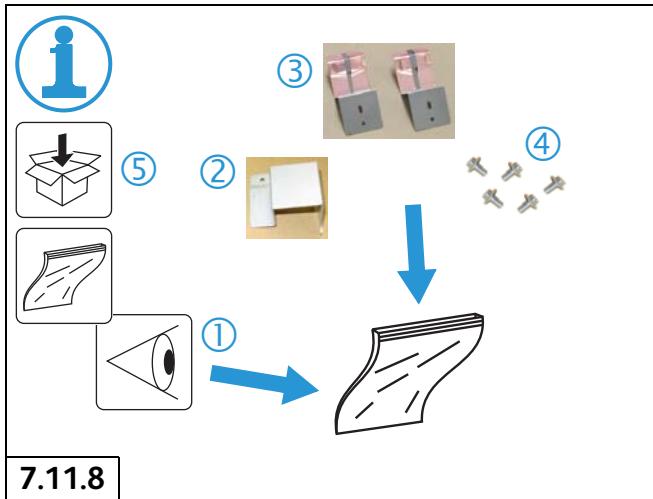
7.11.4 Undock the IDM from the right side of the Processor.

7.11.5 ① Push the docking latch in and ② reinstall the locking screw into the front of the IDM.

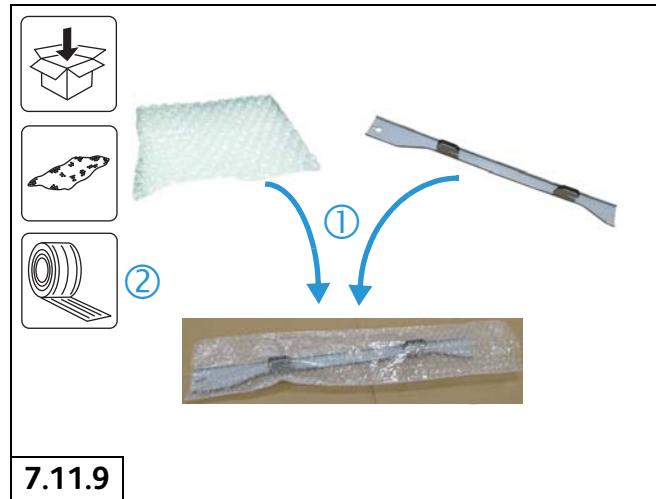
③ Close and ④ tape the front door of the IDM.

7.11.6 ① Remove the single screw from each grounding pad (2) and ② remove the grounding pads (2) from the left bottom edge of the IDM module.

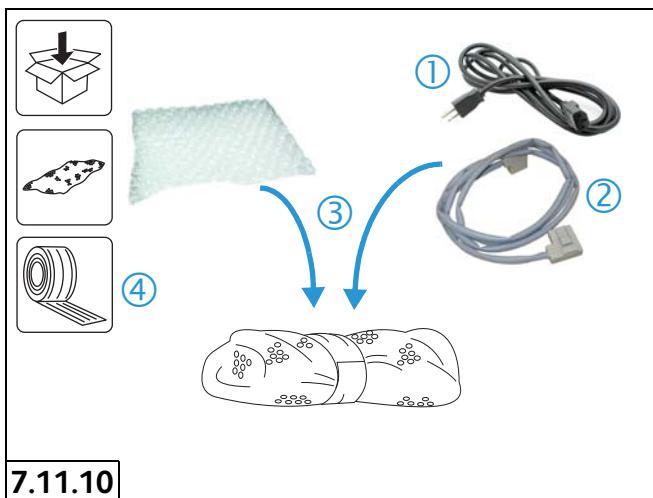
7.11.7 ① Remove the screws (2) and ② IDM docking bracket from the right side of the IOT.



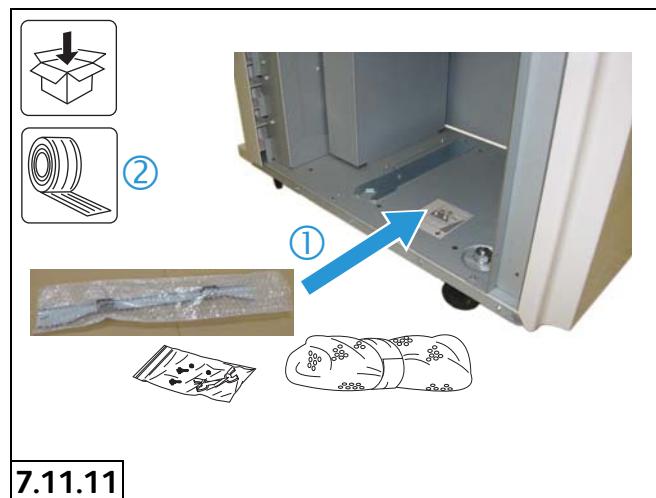
7.11.8



7.11.9



7.11.10



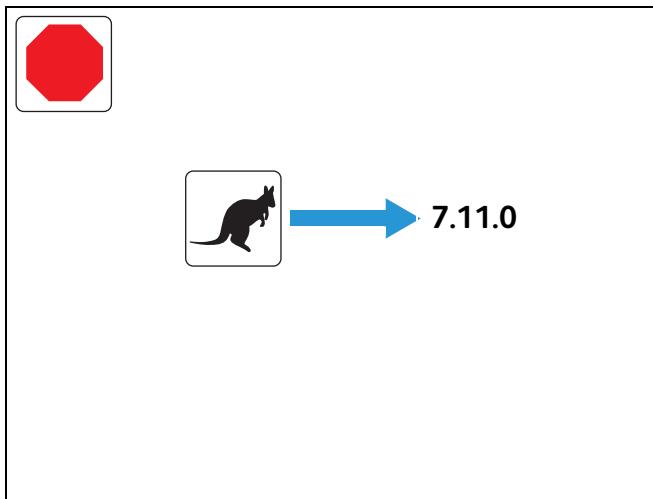
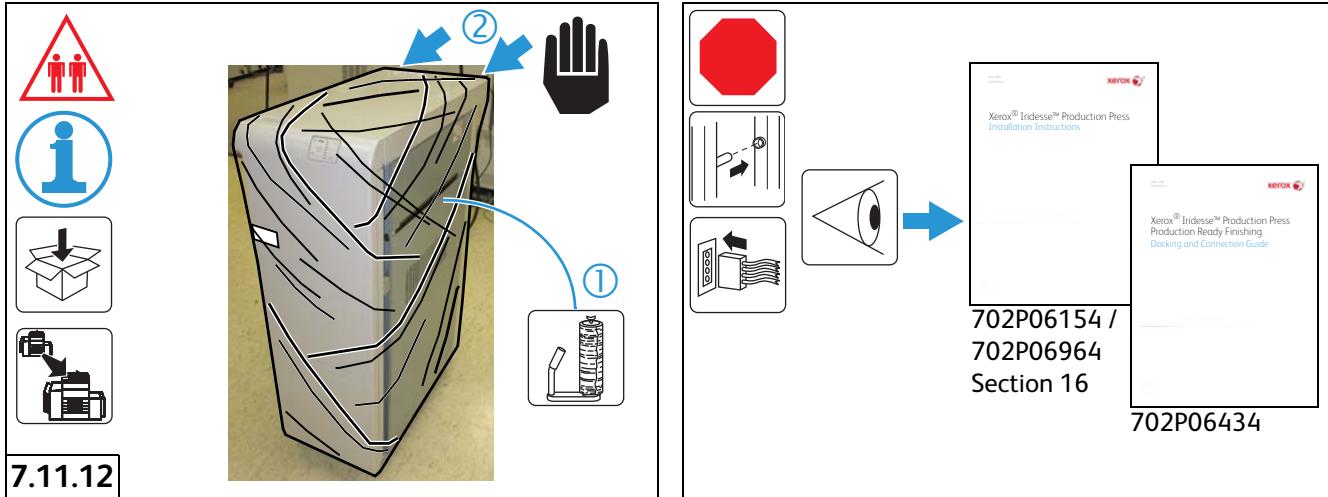
7.11.11

i Note: The screws (5) are from the two grounding pads, power cord protector, and docking bracket.

7.11.8 ① Retrieve a plastic bag and ② place the power cord protector, ③ grounding pads (2), and ④ screws (5) in the bag. ⑤ Close the bag.

7.11.9 ① Wrap the docking bracket in a layer of bubblewrap and ② secure with tape.

7.11.10 ① Wrap the power cord and ② interface cable in a layer of ③ bubblewrap and ④ secure with tape.



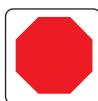
WARNING: Due to the instability of the IDM when moving, two people are required to move this module.



Note: If the system is being relocated within the same building, a layer of stretchwrap will not be required.

7.11.12 ① If required, secure the IDM with a layer of stretchwrap, if required, and ② move the module to the new location or truck.

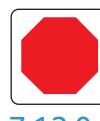
7.12.0 Reinstalling the IDM (if present)



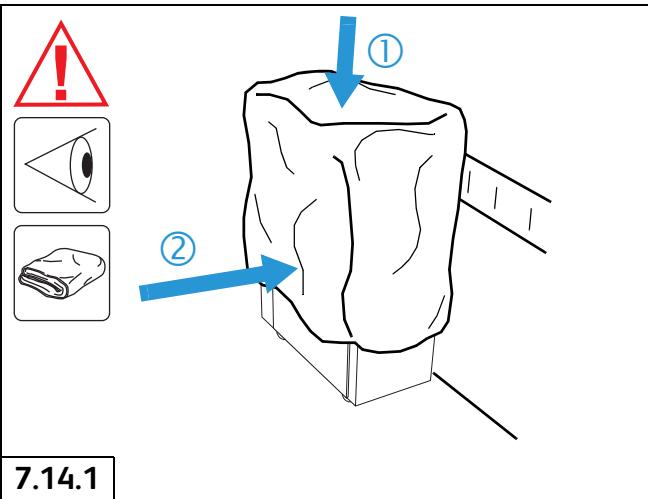
Stop: Use the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) (if present)

and the Production Ready Finishing Docking and Connection Guide (702P06434) to get the IDM reinstalled, docked and connected.

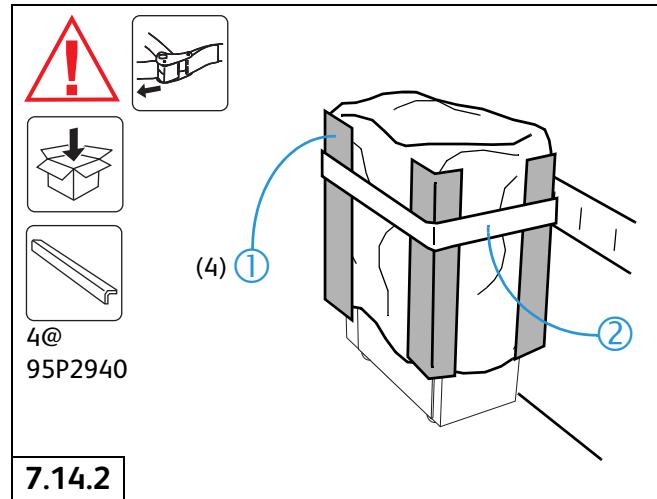
7.13.0 Removal - Preparing the IDM (if present) for the Move



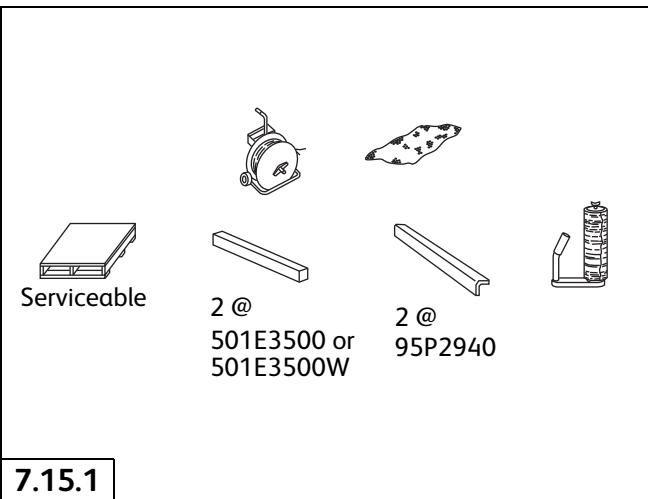
Stop: Perform all the steps in 7.11.0 "Relocation - Preparing the IDM (if present) for the Move" on page 7-31, except for 7.12.0 "Reinstalling the IDM (if present)" on page 7-34.



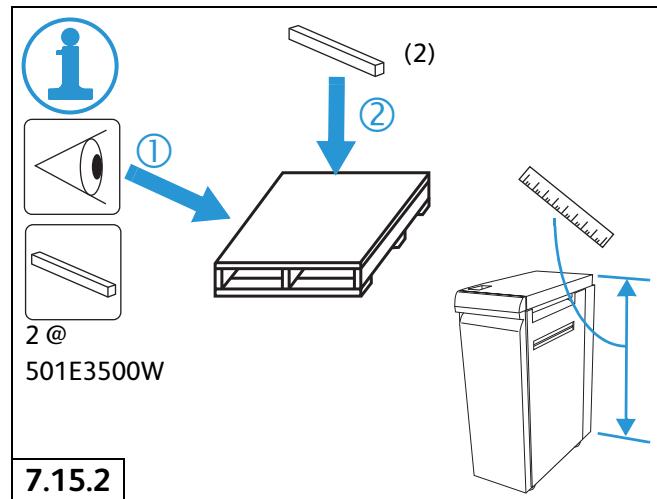
7.14.1



7.14.2



7.15.1



7.15.2

7.14.0 Strapping the IDM (if present)



CAUTION: When placing the IDM against the wall of the truck, ensure that the right side of the module is against the wall of the truck.

- 7.14.1 ① Cover the IDM with a folded blanket and ② place the IDM against the wall of the truck.



CAUTION: When strapping the IDM into the truck, do not apply too much tension to the strap. Damage to the module may occur.

- 7.14.2 ① Place a cornerboard (95P2940) on each of the corners and ② strap the IDM into the truck.

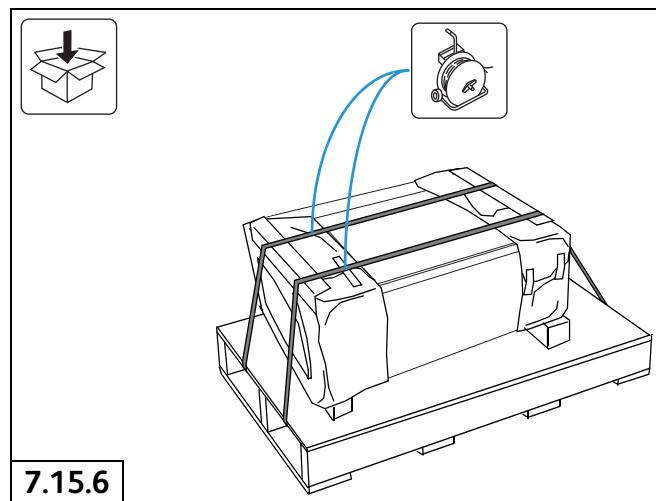
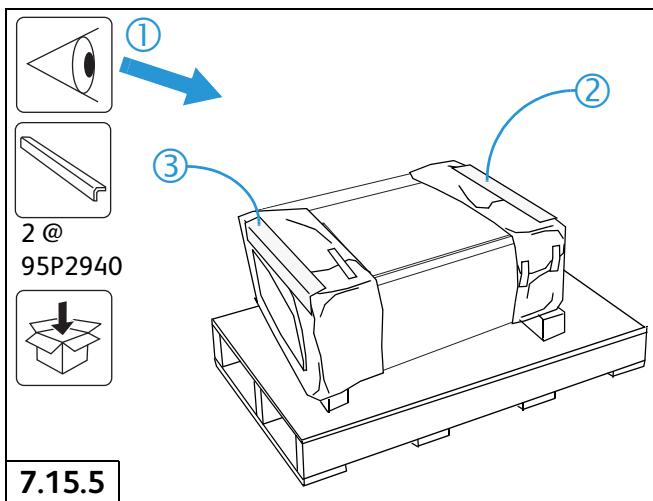
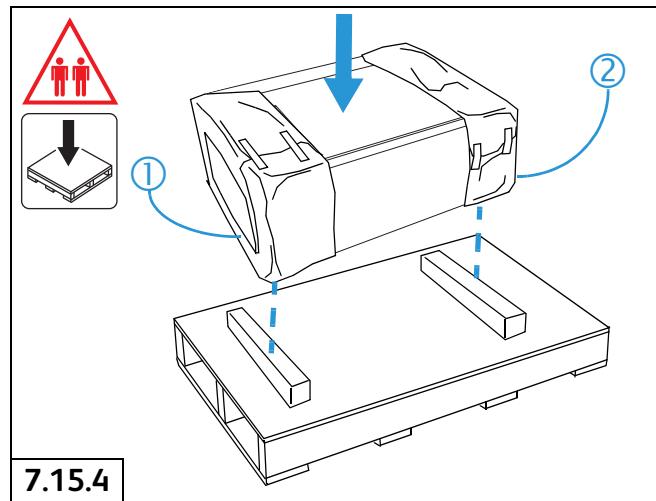
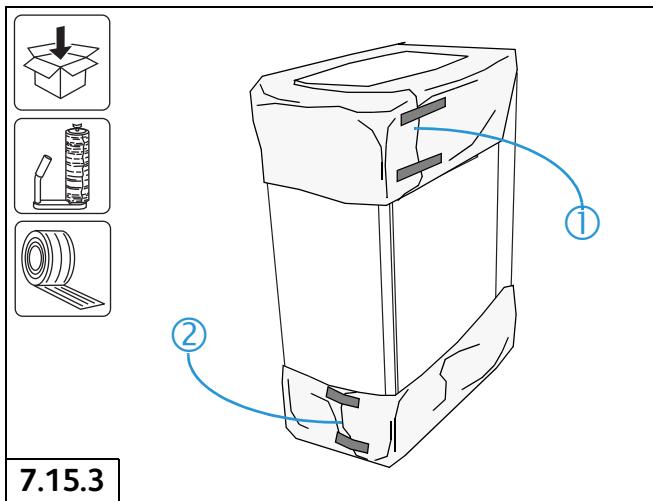
7.15.0 Returning the IDM (if present)

7.15.1 Materials required for returning the IDM.



Note: When placing the blocks on the pallet, ensure they are positioned so that the IDM, when on its side, is supported by both blocks.

- 7.15.2 ① Retrieve a pallet similar in size and ② place two wooden blocks (501E3500W) on the deck of the pallet.



7.15.3 ① Tape a piece of bubblepack around the top and ② bottom of the IDM.

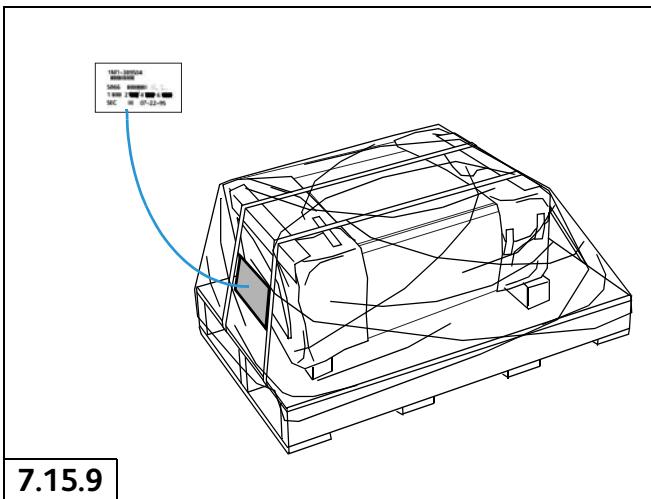
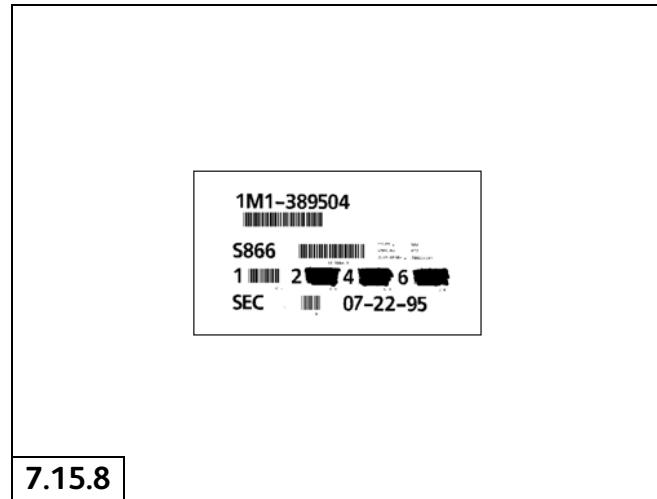
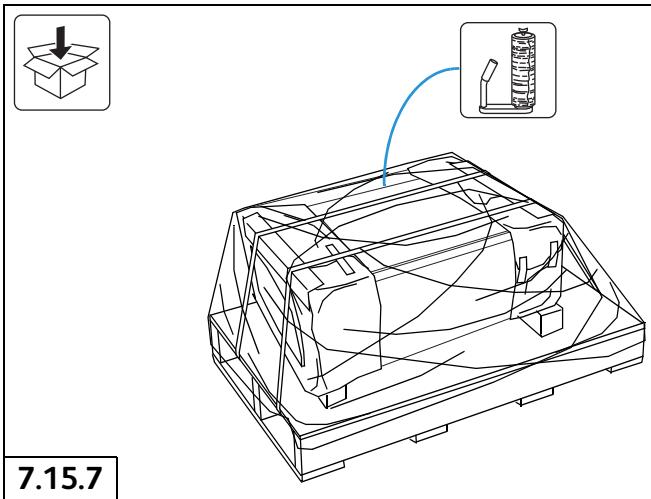


WARNING: Due to the size and weight of the IDM, two people are needed to place the IDM on the blocks on the pallet.

7.15.4 ① Place the IDM on the two wooden blocks so that the top left edge and ② the bottom left edge rest on the two blocks.

7.15.5 ① Retrieve and ② place a cornerboard on the top right and ③ left edges of the IDM.

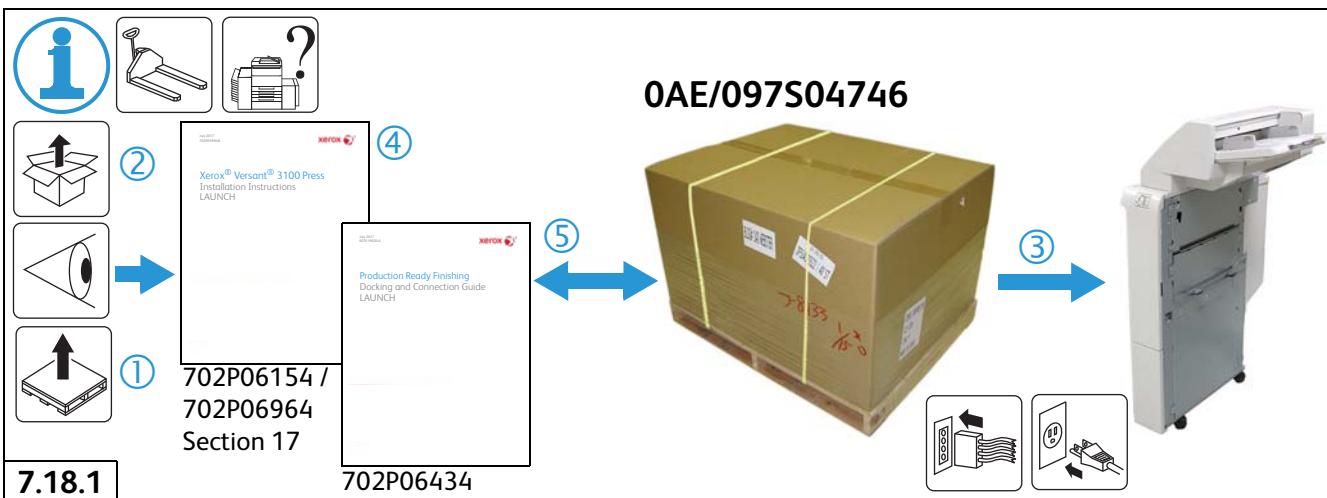
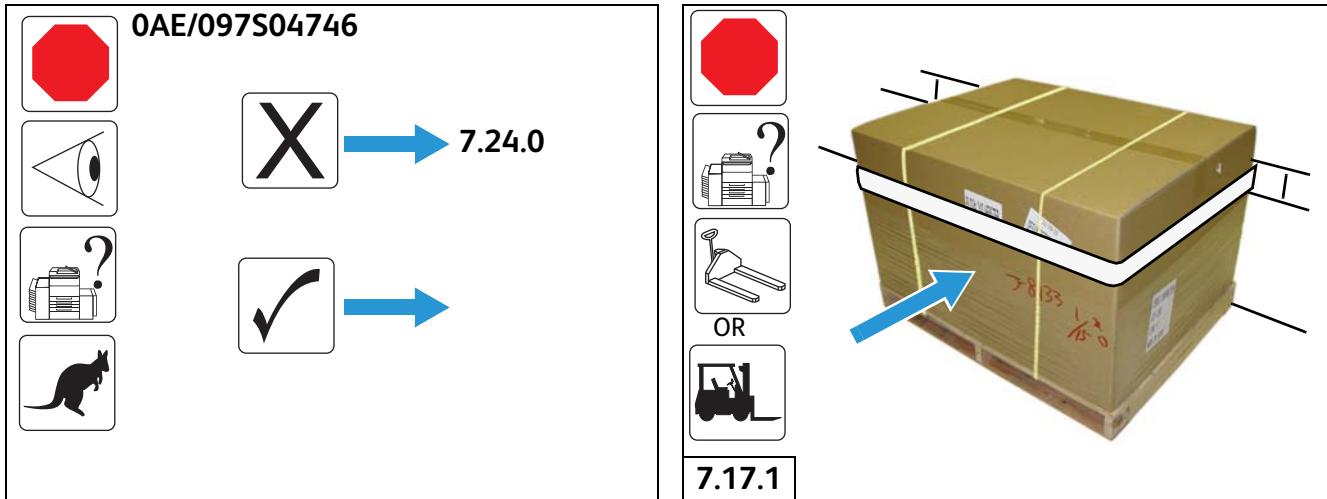
7.15.6 Secure the IDM to the pallet with two bands.



7.15.7 Cover the IDM with stretchwrap.

7.15.8 Generate the bar code label. Cross off the non-applicable codes.

7.15.9 Apply the bar code label to the stretchwrap at the open end of the pallet.



7.16.0 Accessory D: Delivery - Depalletize, Unpack, and Install the Interposer Module (0AE/097S04746) (if present)

Stop: If an Interposer Module is not present, go to 7.24.0 "Accessory E: Depalletize, Unpack, and Install the GBC AdvancedPunch Pro (X5K / 497K18750) (if present)" on page 7-55. If an Interposer is present, continue to the next step.

7.17.0 Strapping the Interposer Module (if present)

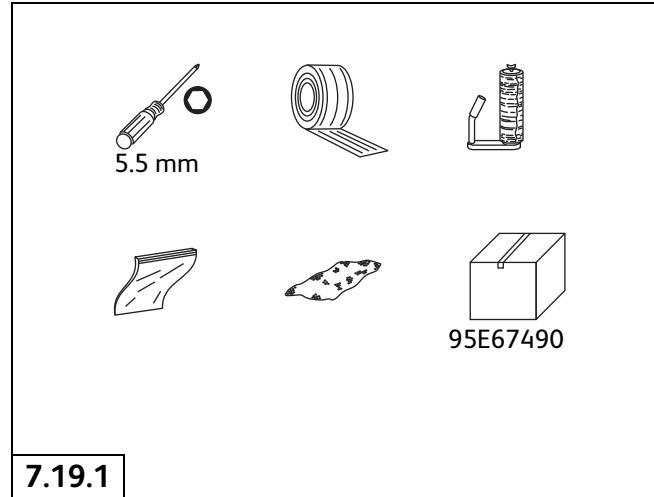
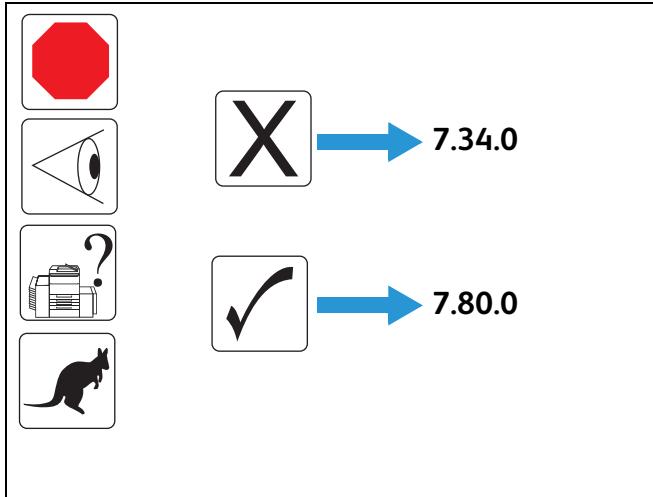
Stop: The Interposer Module should be delivered to the Customer location fully packaged.

7.17.1 If an Interposer Module is present, place the packaged module against the wall of the truck and strap it in place for transport to the Customer location.

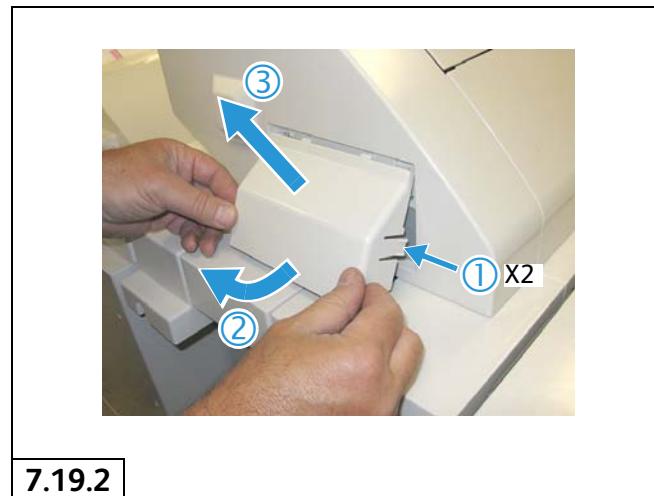
7.18.0 Install the Interposer Module (if present)

Note: Installation of the Interposer Module includes docking and making all electrical connections.

7.18.1 ① Depalletize, ② unpack, and ③ install the Interposer Module (0AE/097S04746) using the ④ Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and ⑤ Production Ready Finishing Docking and Connection Guide (702P06434).



7.19.1



7.19.2

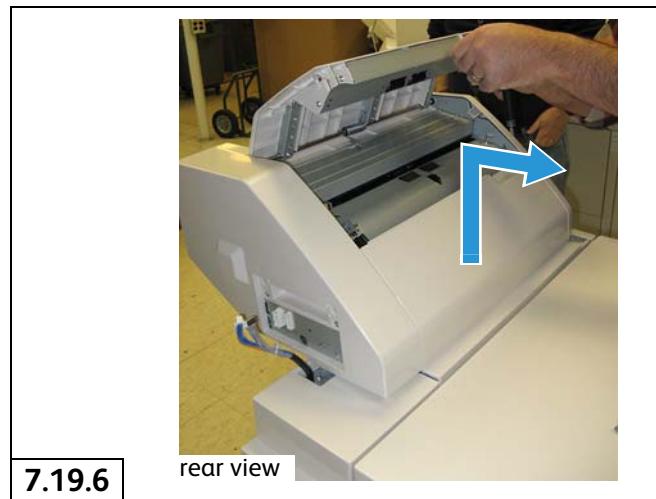
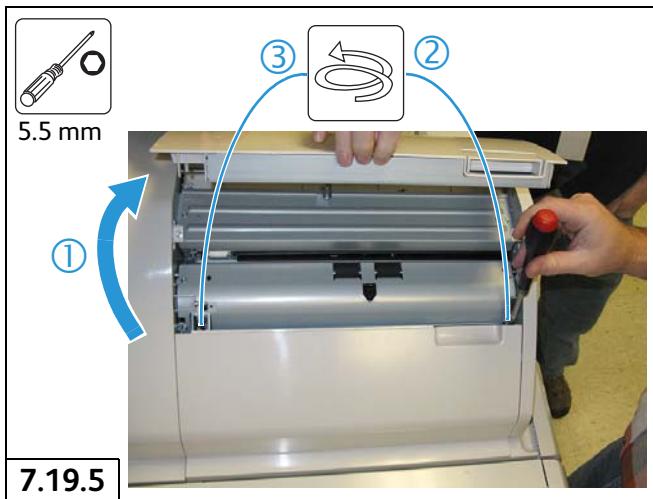
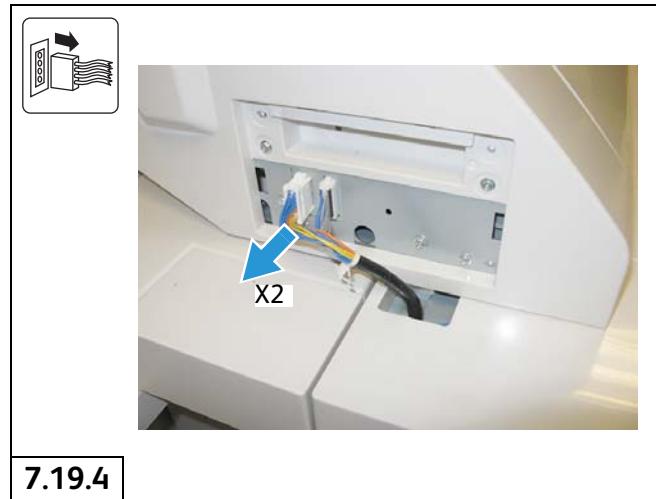
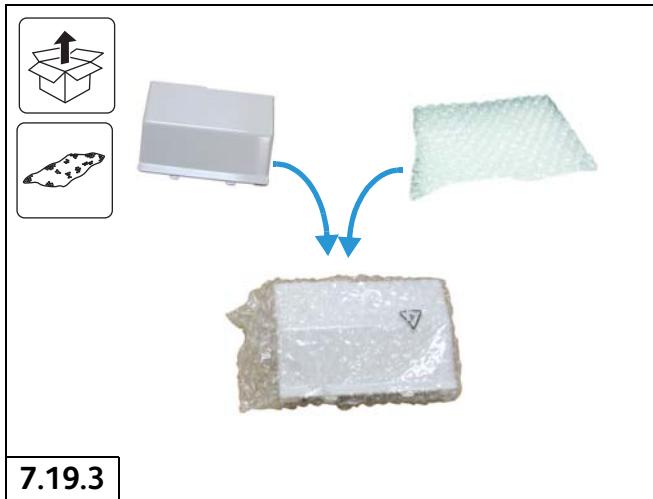
Stop: If there are additional finishing accessories, go to 7.34.0 "Accessory F: Delivery - Unpack and Depalletize the High Capacity Stacker (HCS) (MAY / 450S03138) (if present)" on page 7-64. If there are no additional finishing accessories, go to 7.80.0 "Accessory K: Delivery - Preparing the EFI™ Standalone NX Premium DFE (2A8/097N02291)" on page 7-128.

Stop: Prior to undocking the Interposer module from the upstream module the Inserter needs to be removed from the top of the Interposer.

7.19.2 ① Press in on the sides (2) of the Inserter rear cover, ② rotate the bottom of the cover out and ③ then remove the rear cover from the inserter.

7.19.0 Relocation - Preparing the Interposer Module (if present) for the Move

7.19.1 The tool and materials required to prepare the Interposer module are shown.

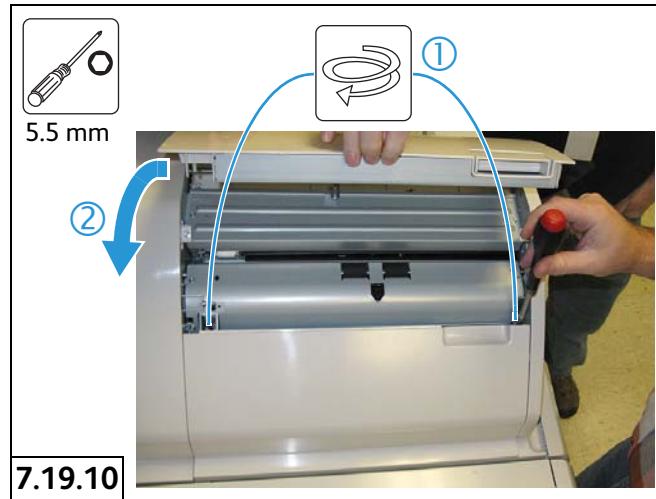
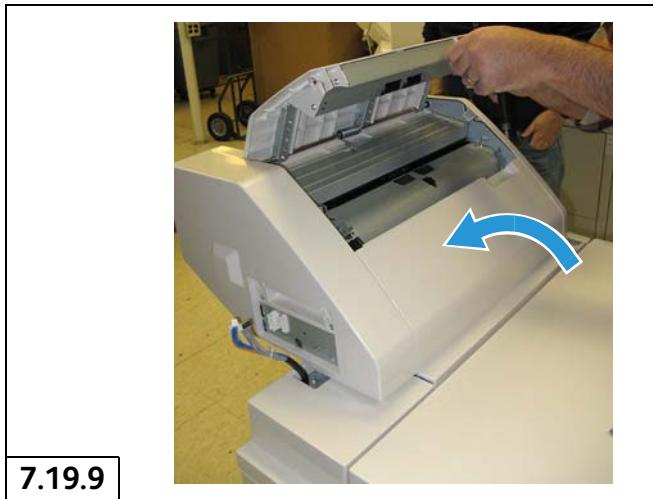
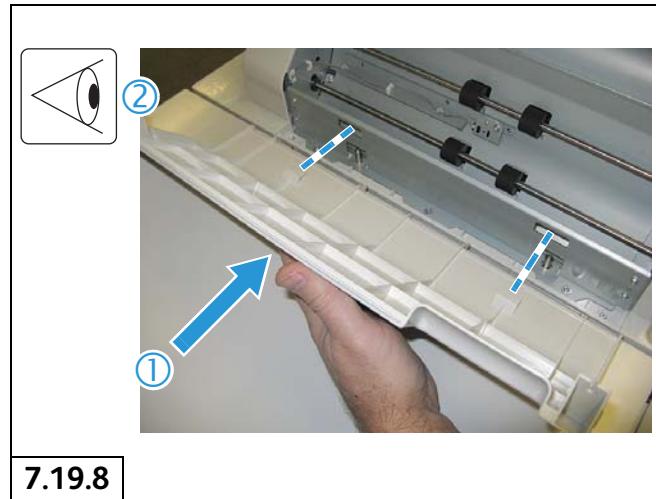
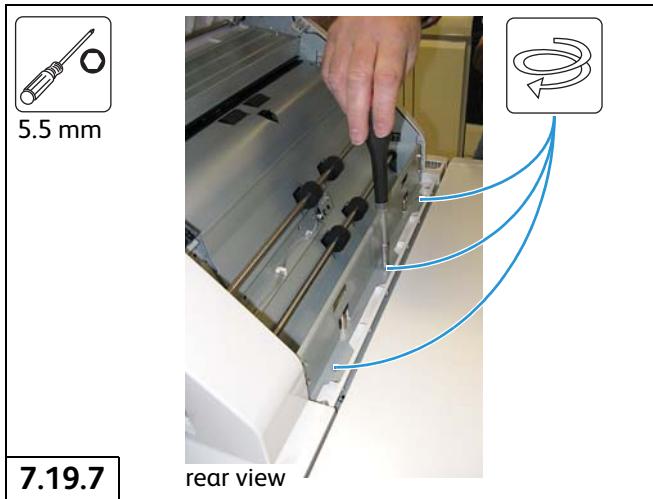


7.19.3 Wrap the inserter cover in a layer of bubblepack.

7.19.4 Disconnect the connectors (2) from the rear of the Inserter.

7.19.5 ① Open the upper left cover of the Inserter and ② remove the screws (2), one to the front and ③ one to the rear, down inside the Inserter.

7.19.6 Lift and remove the bottom left cover from the Inserter.

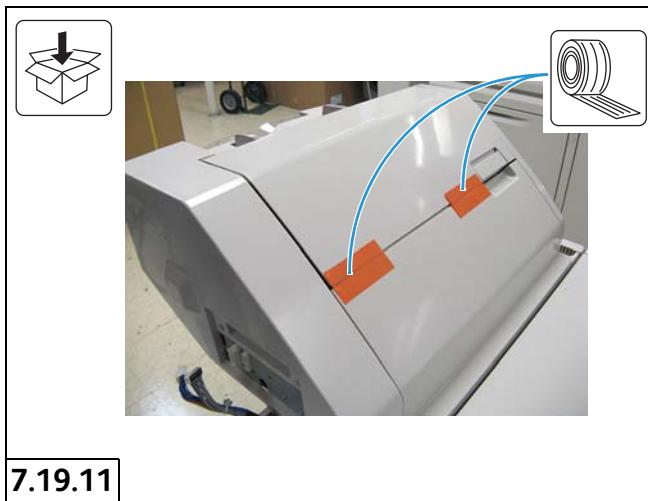


7.19.7 Remove the screws (3) from along the left bottom edge of the Inserter.

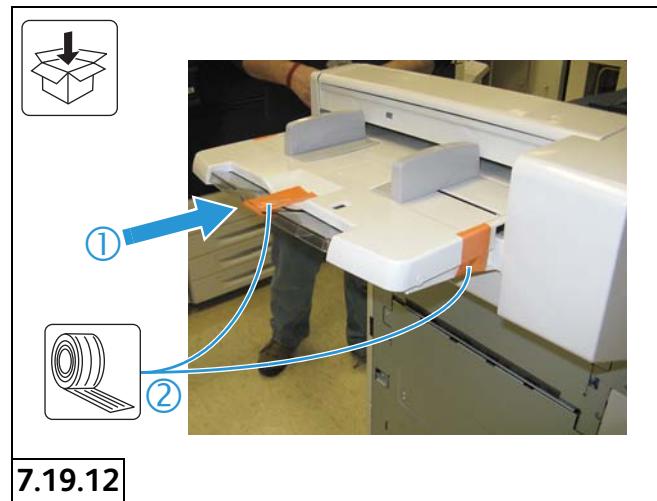
7.19.8 ① Reinstall the lower left cover onto the Inserter by aligning the tabs on the cover ② with the slots in the Inserter.

7.19.9 Rotate the lower left cover into position.

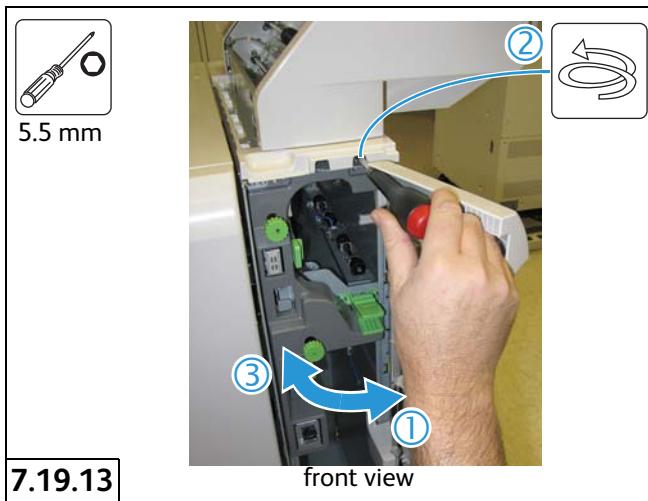
7.19.10 ① Secure the lower left cover by reinstalling the two original screws. ② Close the upper left cover of the Inserter.



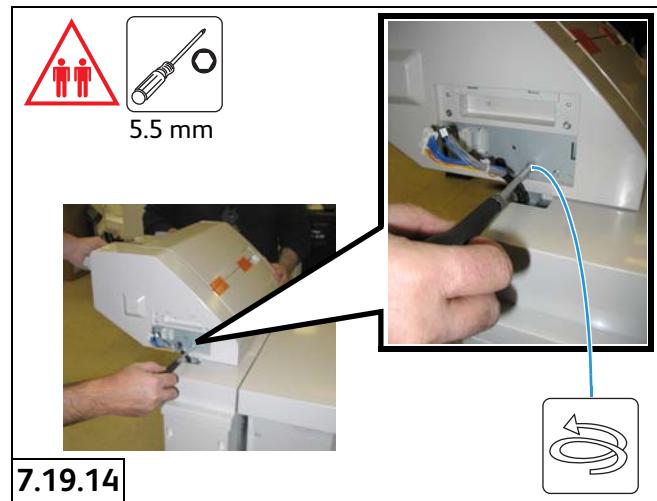
7.19.11



7.19.12



7.19.13



7.19.14

7.19.11 Secure the upper and lower left Inserter covers with tape.

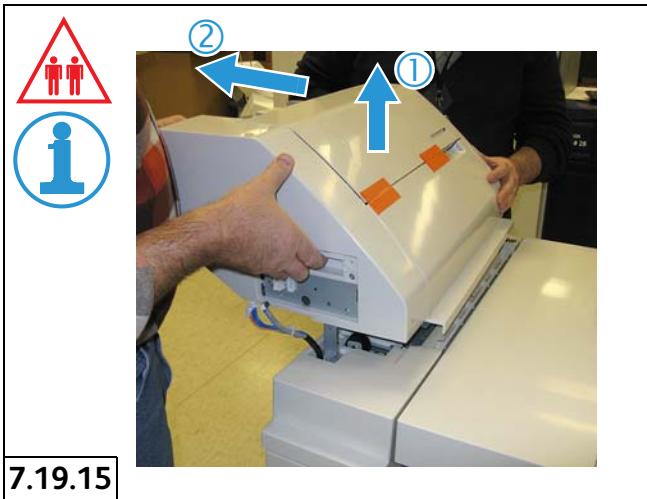
7.19.14 Remove the single screw from the rear bottom edge of the inserter.

7.19.12 ① Close Inserter top input tray and
② secure with tape.

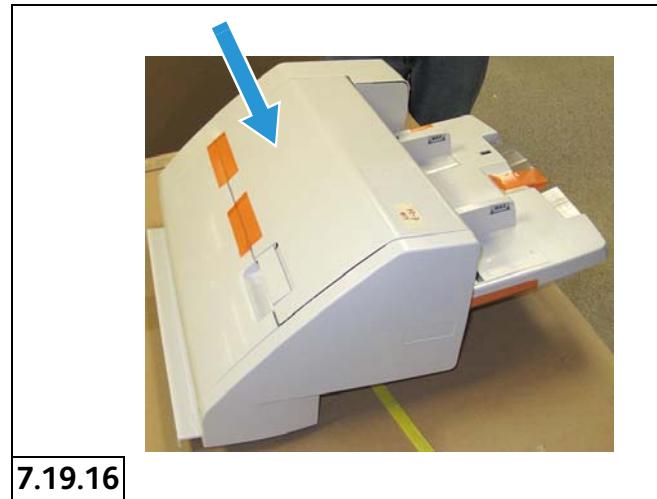
7.19.13 ① Open the front cover of the Interposer and ② remove the single screw from along the top edge of the Interposer. ③ Close the front cover.



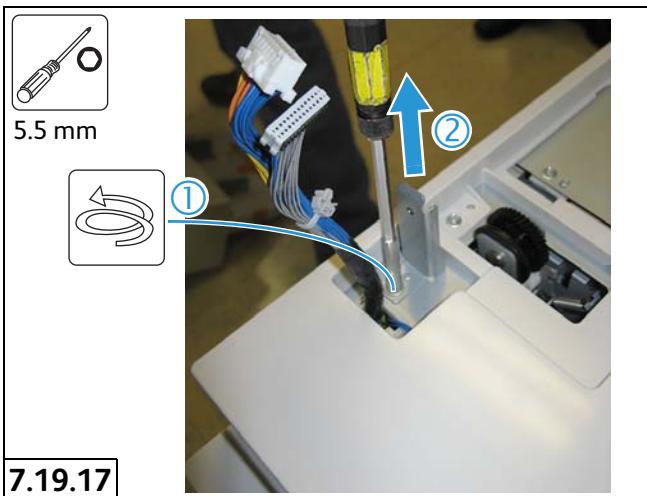
WARNING: Due to the size of the Inserter and the instability once the rear screw is removed, two people are required to stabilize and remove Inserter on top of the Interposer.



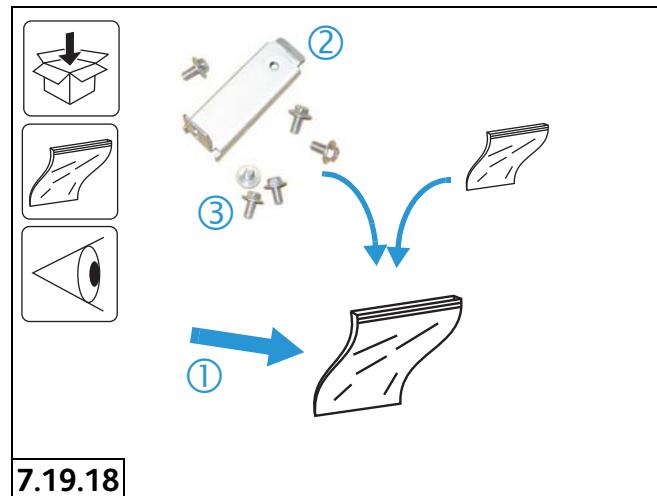
7.19.15



7.19.16



7.19.17



7.19.18

WARNING: Due to the size of the Inserter and the need to lift it straight up and off the Inserter mounting bracket, two people are required to remove the Inserter from the top of the Interposer.

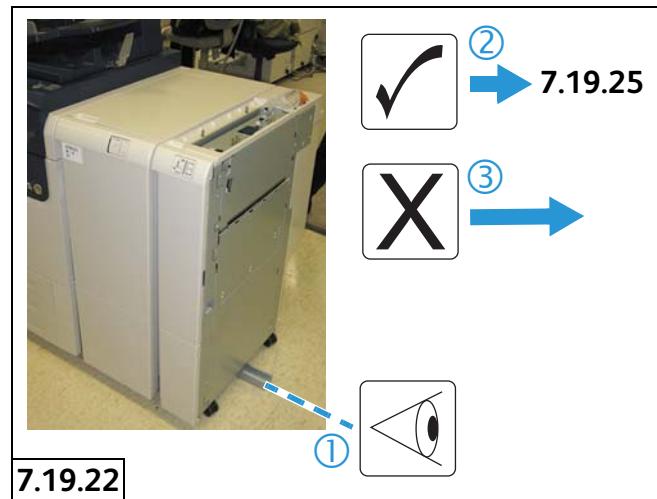
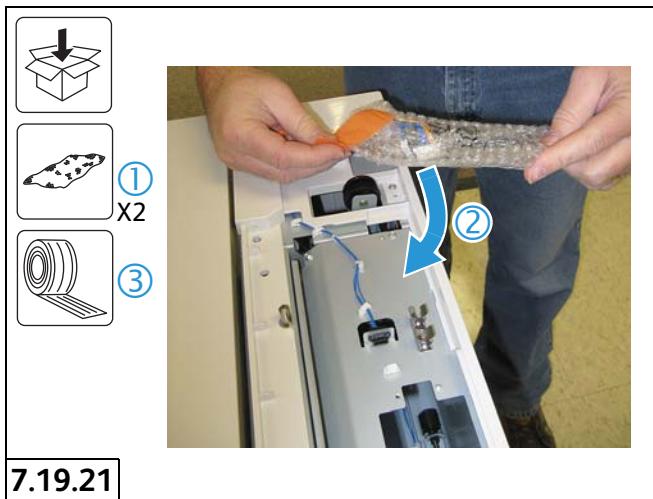
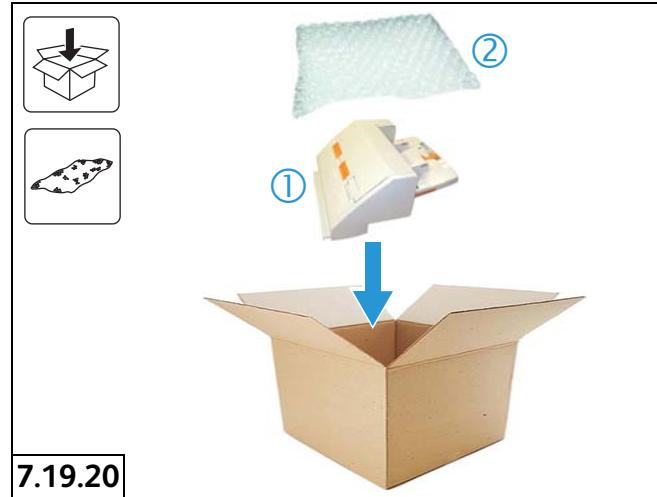
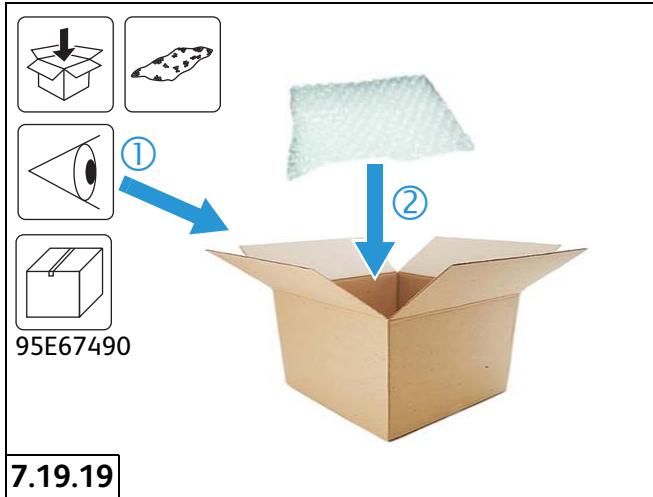
Note: Because of the mounting bracket on the rear edge of the Interposer, when removing the Inserter from the top of the Interposer, lift straight up and off the bracket.

7.19.15 Using two people, ① lift the Inserter up and ② off the Interposer.

7.19.16 Place the Inserter on a flat surface.

7.19.17 ① Remove the single screw and
② Inserter mounting bracket from the top rear edge of the Interposer.

7.19.18 ① Retrieve a small plastic bag and
② place the mounting bracket and ③ screws (6) in the bag.

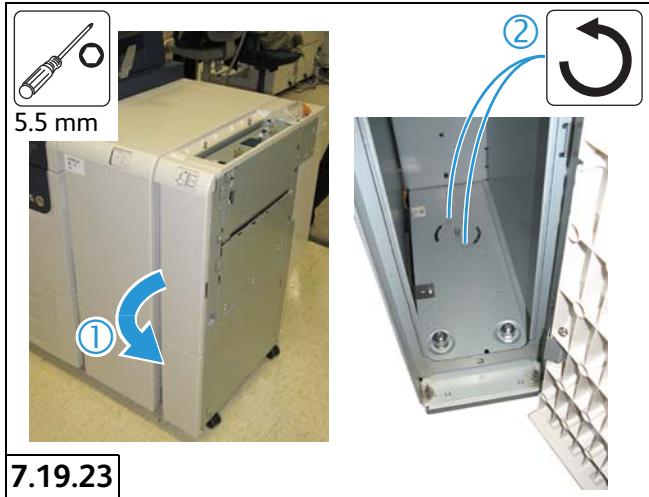


7.19.19 ① Retrieve a generic box (95E67490) and ② place a folded layer of bubblepack in the bottom of the box.

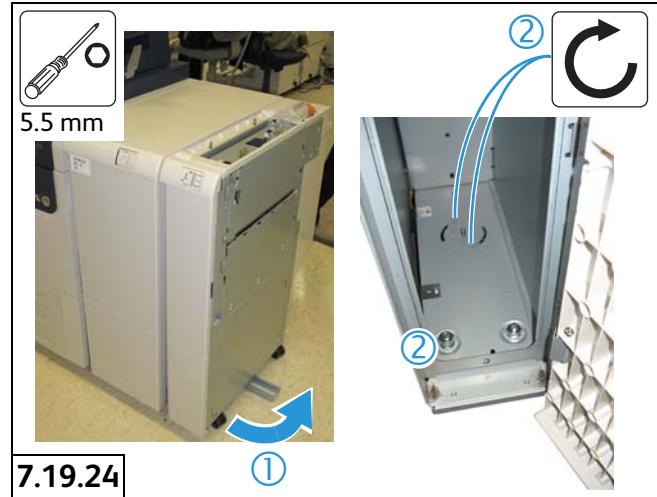
7.19.20 ① Place the Inserter in the box and ② cover with a folded layer of bubblepack.

7.19.21 ① Wrap the cable connections (2) on the top of the Interposer in a small piece of bubblepack, ② position on the top of the top of the Interposer and ③ then secure them in place with tape.

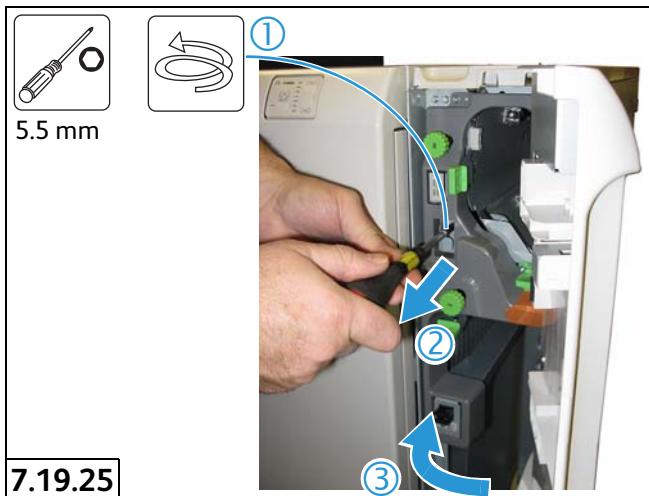
7.19.22 ① Check to ensure the stabilizer bar under the Interposer is in the out position. ② If it is, go to step 7.19.25, ③ if not, continue on to the next step.



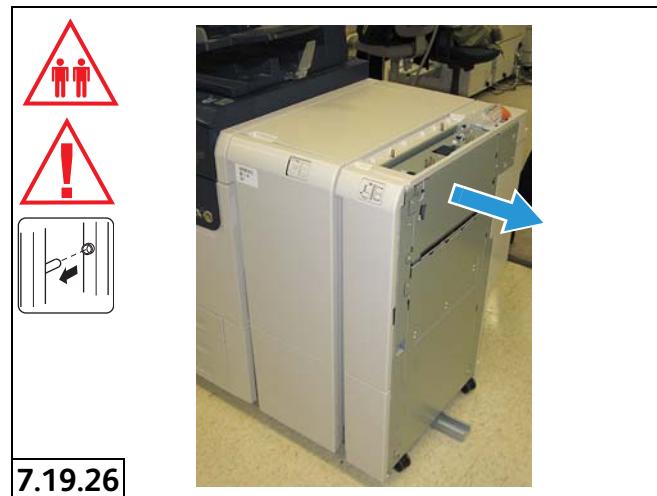
7.19.23



7.19.24



7.19.25



7.19.26

7.19.23 ① Open the front cover of the Interposer.
② Loosen the two screws securing the stabilizing foot.

WARNING: Do not rotate the stabilizing foot in under the module when the Interposer is undocked.

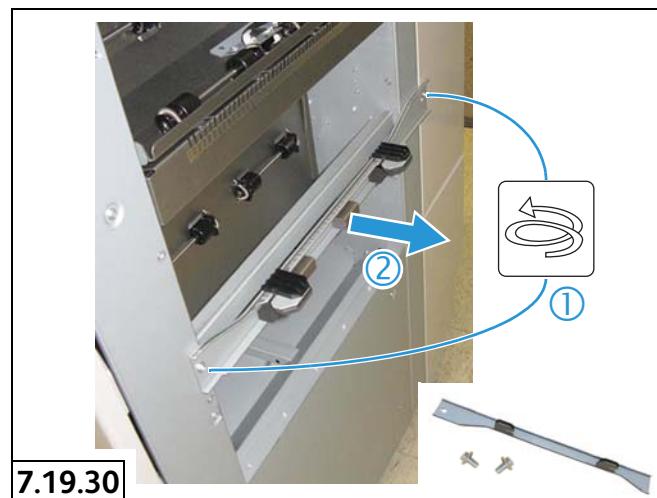
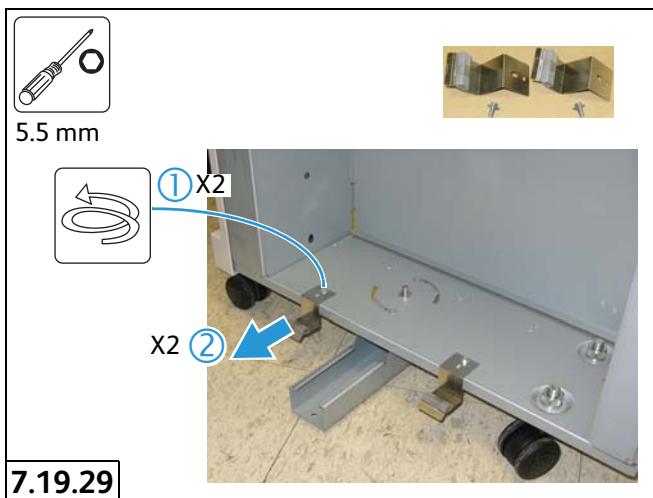
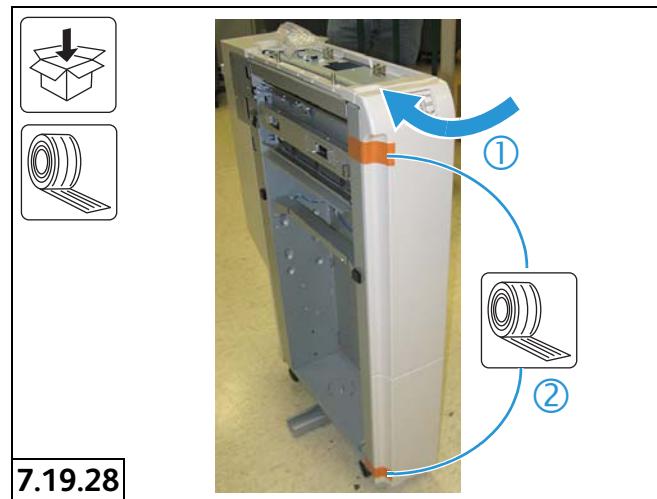
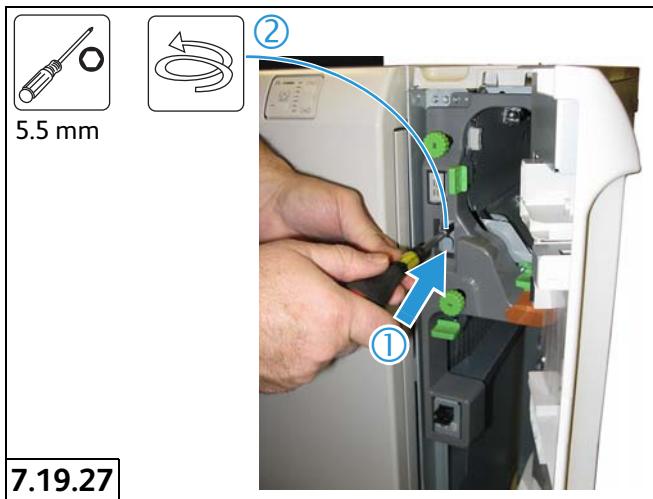
7.19.24 ① Rotate the foot out into position and
② then tighten the two securing screws.

7.19.26 Undock the Interposer module from the IDM.

7.19.25 ① Remove the docking latch screw and
② release the docking latch.



WARNING: Because the Interposer module is unstable and can tip over very easily, two people are required to move this module once it is undocked.



7.19.27 ① Reposition the docking latch and
② reinstall the docking latch screw in the front of
the Interposer module.

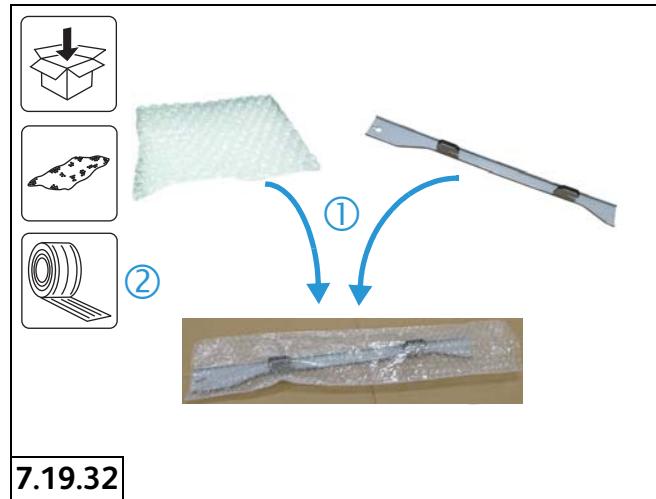
7.19.28 ① Close Interposer front cover and
② secure with tape.

7.19.29 ① Remove the screws (1 per) and ② the
grounding pads from the left bottom side of the
Interposer.

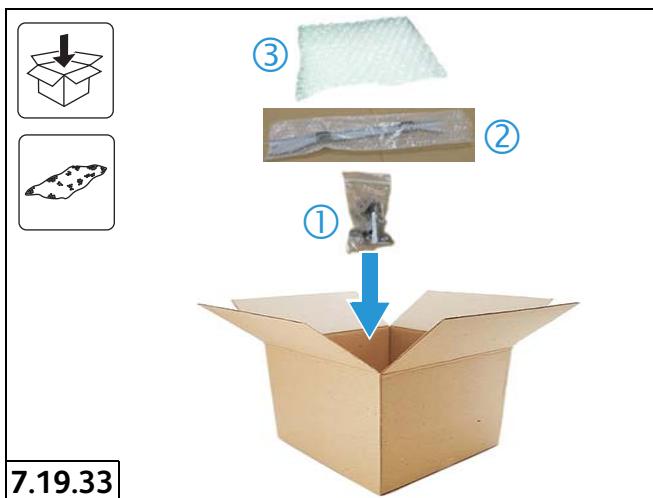
7.19.30 ① Remove the screws (2) and ② the dock-
ing bracket from the right side of the IDM.



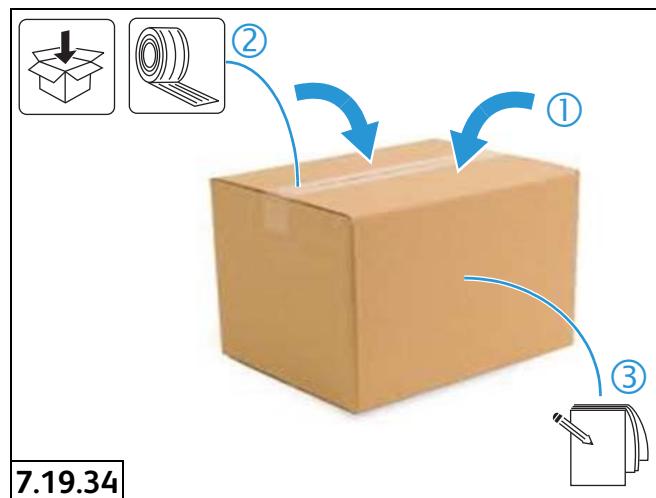
7.19.31



7.19.32



7.19.33



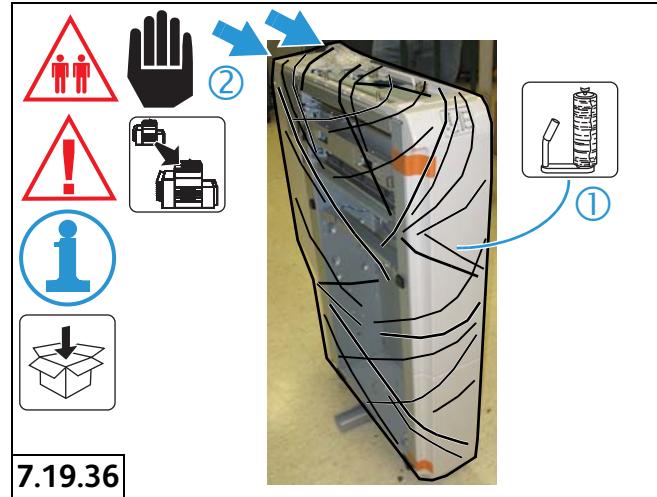
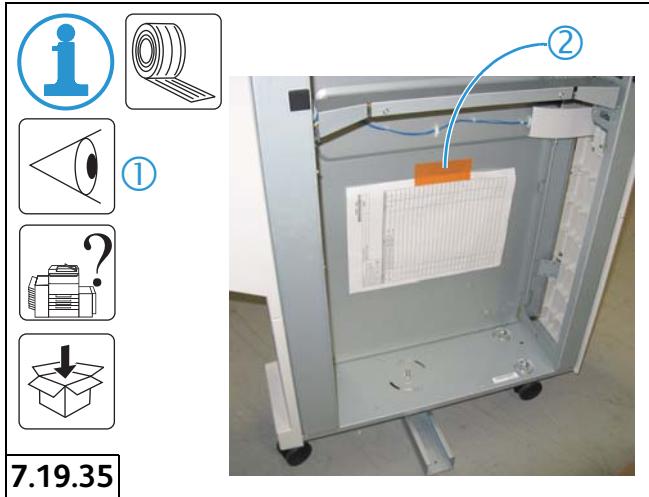
7.19.34

7.19.31 ① Place the grounding pads and ② screws (4), two from grounding pads and two from docking bracket, in the bag with the other bracket / hardware. ③ Close the bag.

7.19.32 ① Wrap the docking bracket in a layer of bubblepack and ② secure with tape.

7.19.33 ① Place the bag containing the hardware and ② bubblepacked docking bracket in the box with the Inserter. ③ Fill all voids with bubblepack.

7.19.34 ① Close and ② tape the box shut.
③ Write the contents 'INSERTER / HARDWARE' on the outside of the box.



i Note: For the Interposer there may be two NVM sheets present, one for the Interposer and one for the Inserter. Ensure they are stored together for the move.

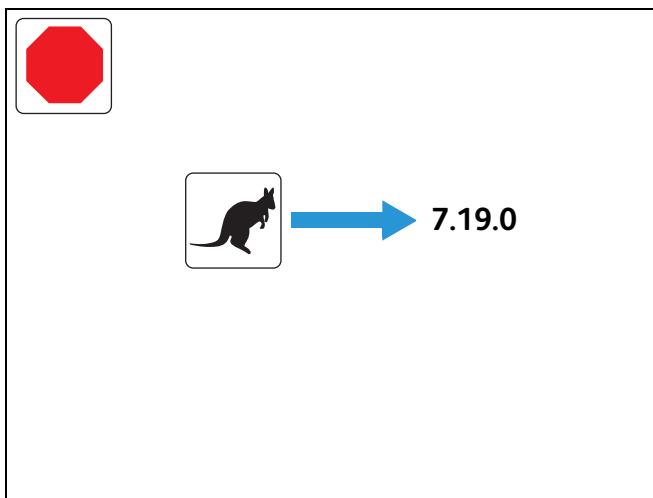
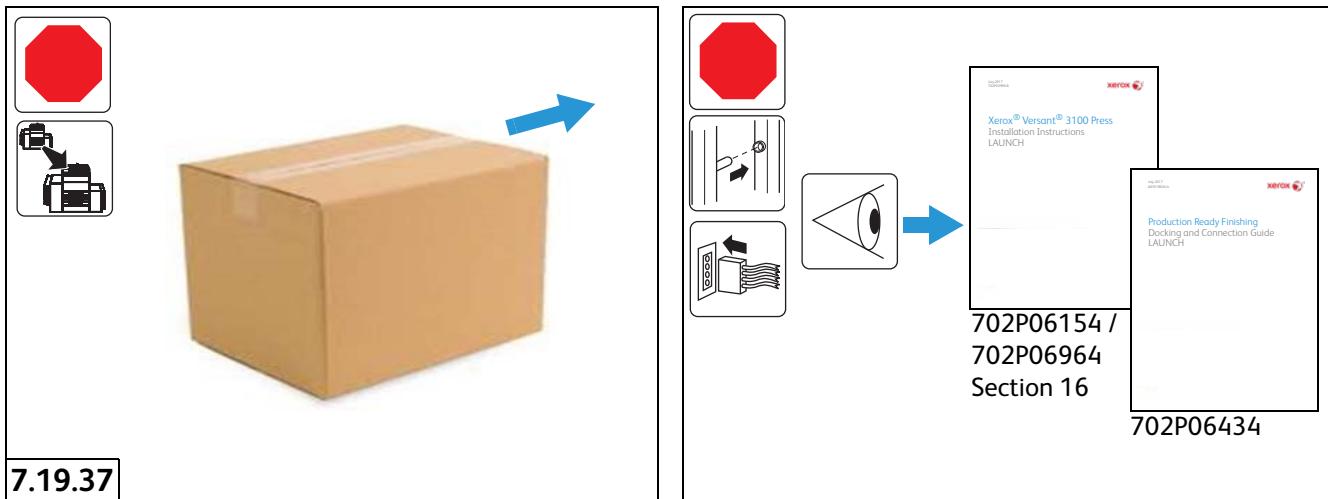
7.19.35 If NVM Sheets are present, ① retrieve them and ② tape them to the inside right panel of the Interposer module.

WARNING: Due to the size and instability of the Interposer Module, two people are required to move this module. Ensure that the stabilizing bar under the module remains in the out position when moving the module on its casters.

CAUTION: Due to the low clearance under the stabilizing bar, extra care needs to be taken when moving this module over thresholds and uneven surfaces.

i Note: If the system is being relocated within the same building, securing the Interposer with a layer of stretchwrap is not required.

7.19.36 ① Secure the Interposer Module with a layer of stretchwrap, if required, and ② move the module to the new location or truck.



 Stop: The boxed Inserter must be kept with the Interposer module at all times when relocating.

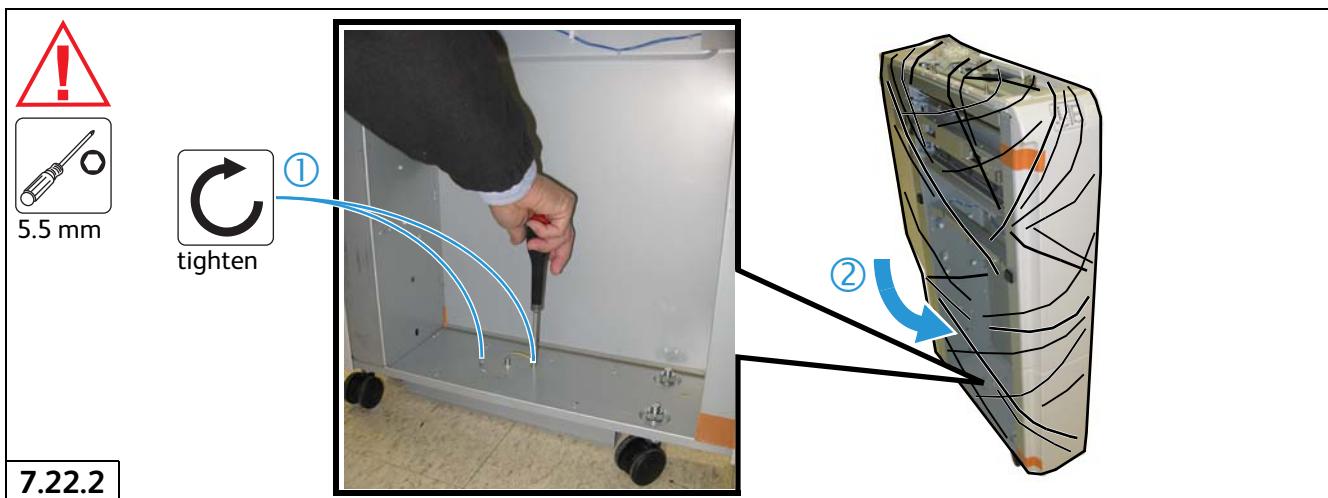
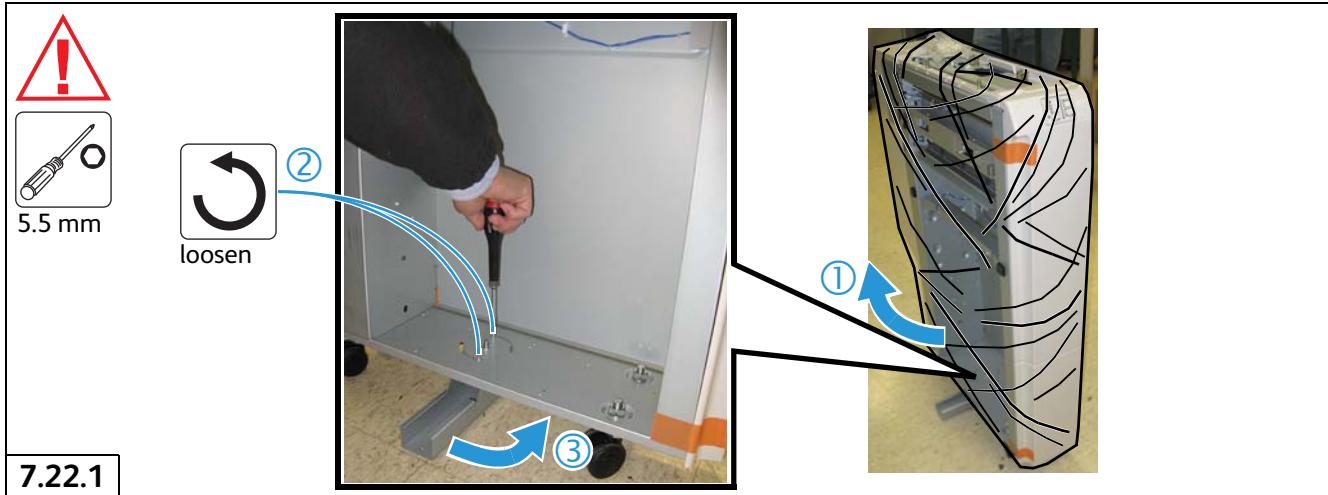
7.19.37 Move the boxed Inserter to the new location or truck with the Interposer Module.

7.20.0 Reinstalling the Interposer Module (if present)

 Stop: Use the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) (if present) and the Production Ready Finishing Docking and Connection Guide (702P06434) to get the Interposer Module reinstalled, docked and connected.

7.21.0 Removal - Preparing the Interposer Module (if present) for the Move

 Stop: Perform all the steps in 7.19.0 "Relocation - Preparing the Interposer Module (if present) for the Move" on page 7-39, except for 7.20.0 "Reinstalling the Interposer Module (if present)" on page 7-49.



7.22.0 Strapping the Interposer Module

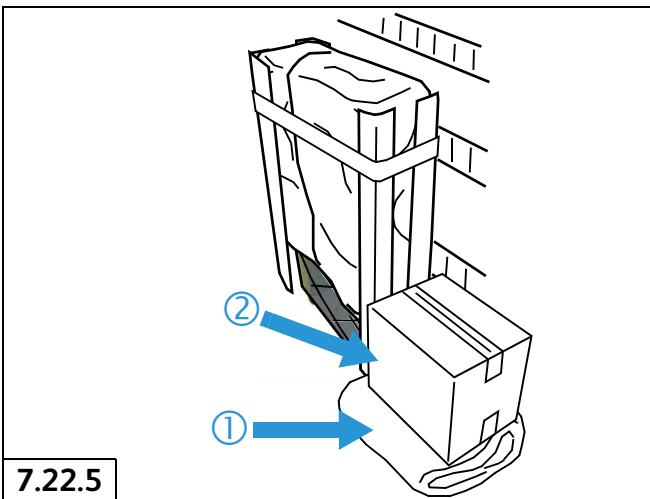
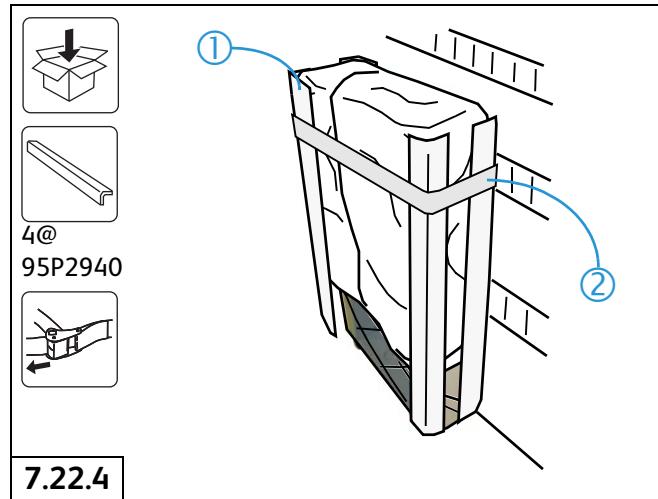
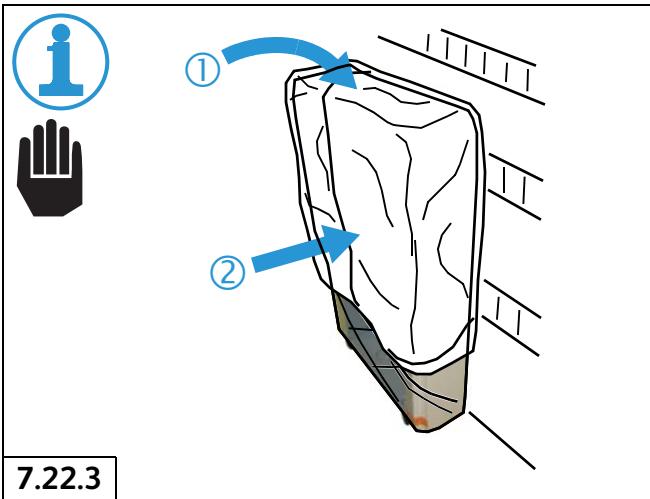
CAUTION: When strapping the Interposer module on a truck, the stabilizing bar will need to be rotated under the module. Position the right side of the Interposer module against the wall of the truck.

7.22.1 ① Lift the stretchwrap on the left side of the Interposer. Using a 5.5 mm hex driver, ② loosen the screws (2) on the inside bottom of the Interposer module. ③ Rotate the stabilizing foot in under the module.



WARNING: Once the stabilizing bar is positioned under the module the module will become less stable. Extra care needs to be taken.

7.22.2 Using a 5.5 mm hex driver, ① tighten the screws (2) securing the stabilizer bar under the module. ② Reposition the stretchwrap down over the left side of the Interposer.

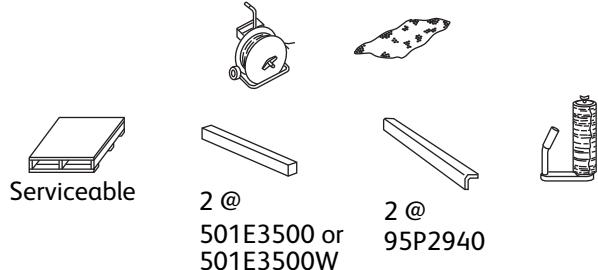


Note: When strapping the Interposer module into the truck ensure the right side of the module is positioned against the wall of the truck.

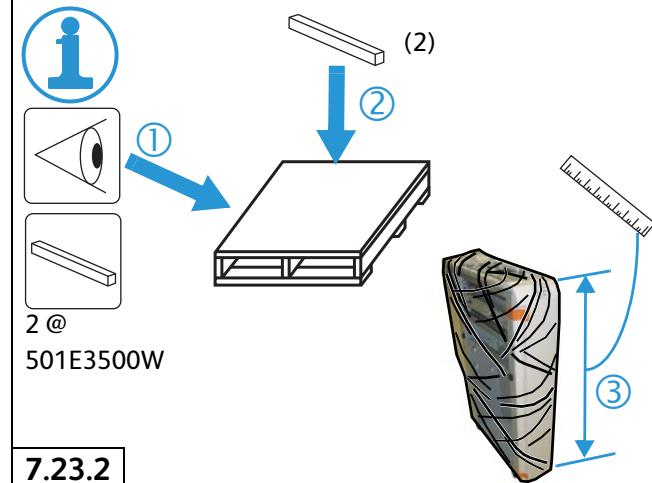
7.22.3 ① Cover the Interposer module with a folded blanket. ② Position the Interposer against the truck wall.

7.22.4 ① Place a cornerboard (95P2940) on each of the corners (4) and ② strap the Interposer into the truck.

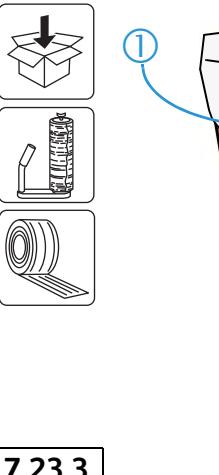
7.22.5 ① Place a folded blanket on the floor next to the Interposer and ② place the boxed Inserter Module on the blanket.



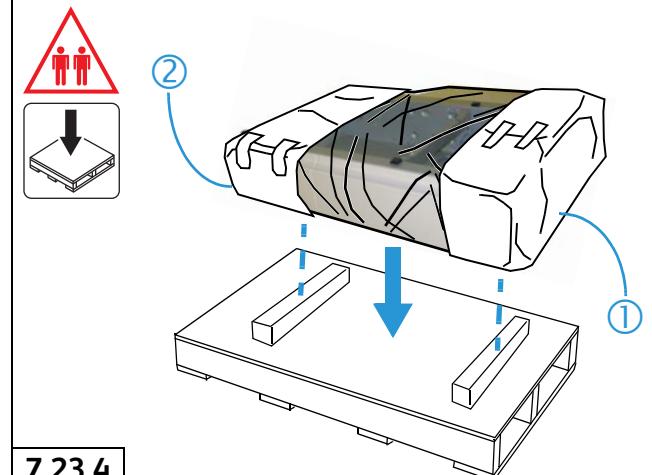
7.23.1



7.23.2



7.23.3



7.23.4

7.23.0 Return - Preparing the Interposer Module (if present) for the Move

7.23.1 Materials required for returning the Interposer Module.



Note: When placing the blocks on the pallet, ensure they are positioned so that the Interposer, when on its side, is supported by both blocks.

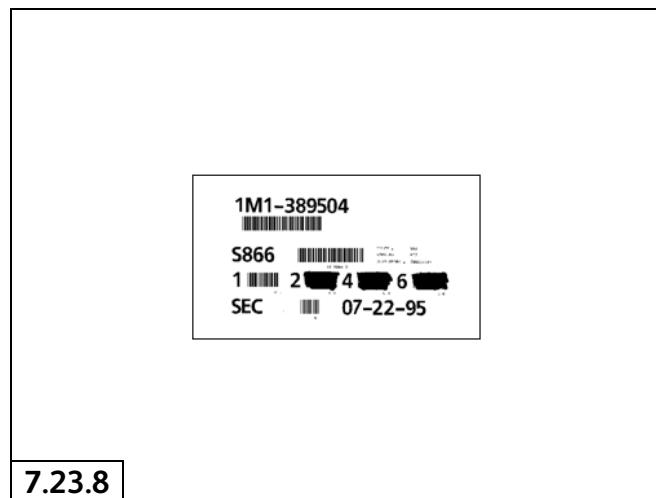
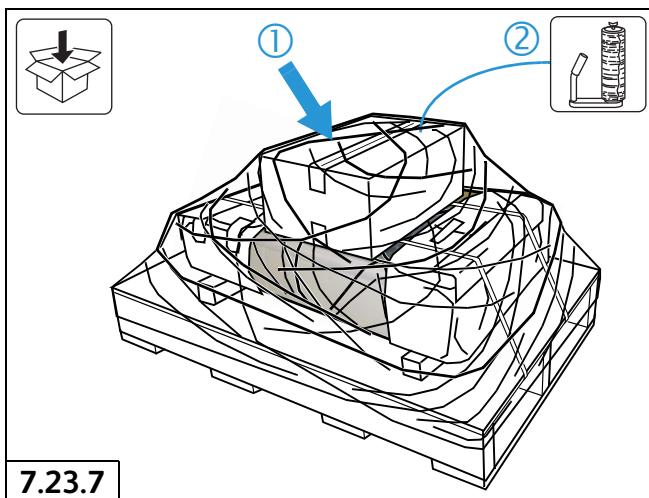
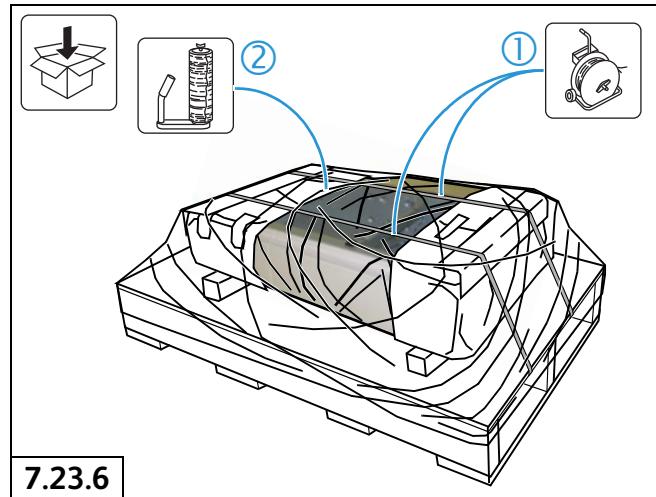
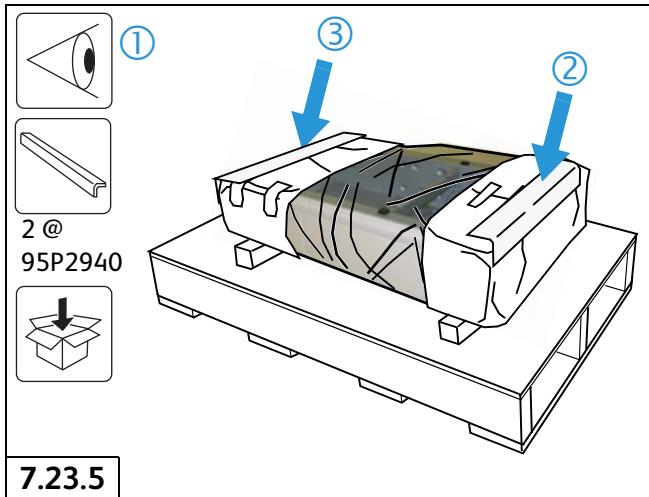
7.23.2 ① Retrieve a pallet similar in size and ② place two wooden blocks (501E3500W) on the deck of the pallet ③ based on the height of the module.

7.23.3 ① Tape a piece of bubblepack around the top and ② bottom of the Interposer Module.



WARNING: Due to the size and weight of the Interposer Module two people are required to place the module on the blocks on the pallet.

7.23.4 ① Place the Interposer Module on the two wooden blocks so that the top right edge and ② the bottom right edge rest on the blocks.

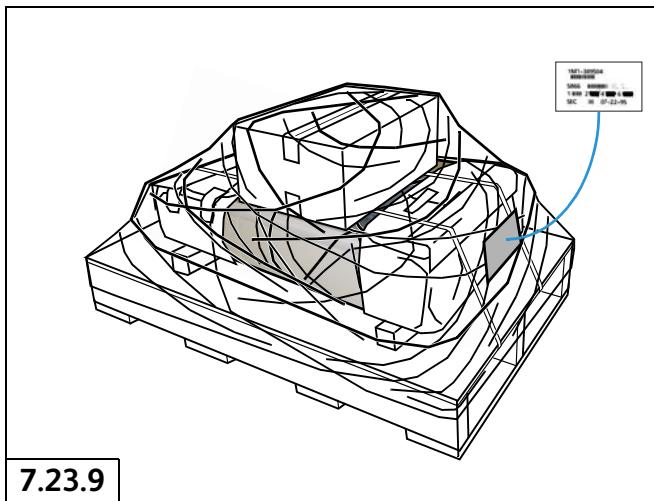


7.23.5 ① Retrieve and ② place a cornerboard on the left side top and ③ bottom edges.

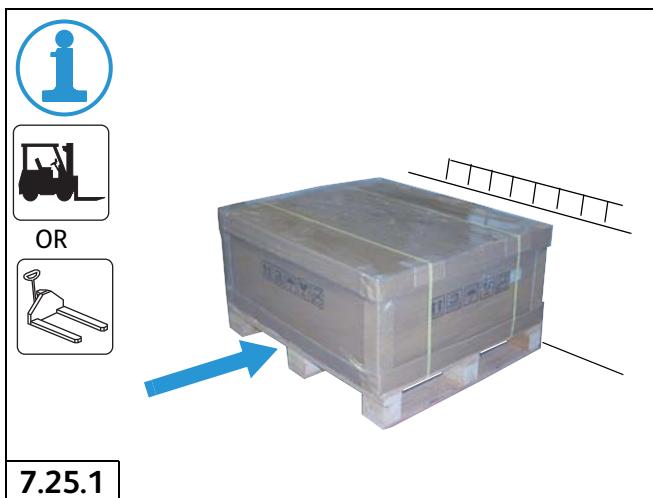
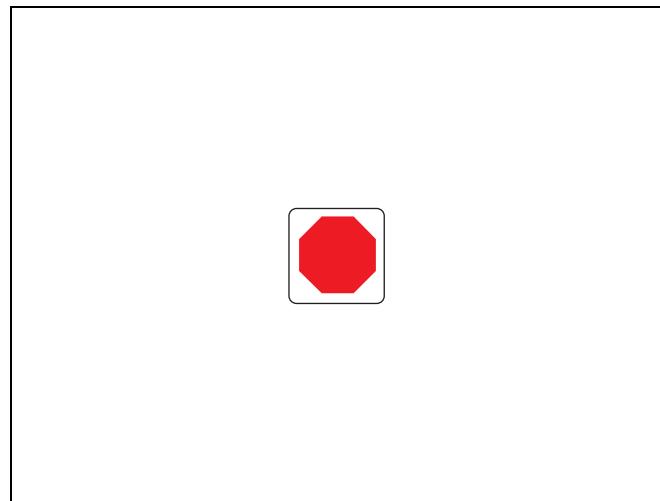
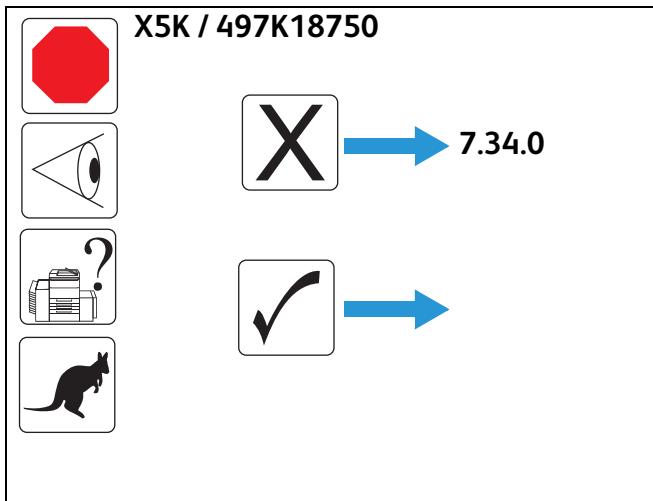
7.23.6 ① Secure the Interposer Module to the pallet with two bands and ② then cover it with a layer of stretchwrap.

7.23.7 ① Place the boxed Inserter on top of the Interposer and ② secure in place with a layer of stretchwrap.

7.23.8 Generate the bar code label. Cross off the non-applicable codes.



7.23.9 Apply the bar code label to the stretchwrap at the open end of the pallet.



7.24.0 Accessory E: Depalletize, Unpack, and Install the GBC AdvancedPunch Pro (X5K / 497K18750) (if present)

Stop: If a GBC AdvancedPunch Pro is not present, go to 7.34.0 "Accessory F: Delivery - Unpack and Depalletize the High Capacity Stacker (HCS) (MAY / 450S03138) (if present)" on page 7-64. If a GBC AdvancedPunch Pro is present, continue onto the next step.

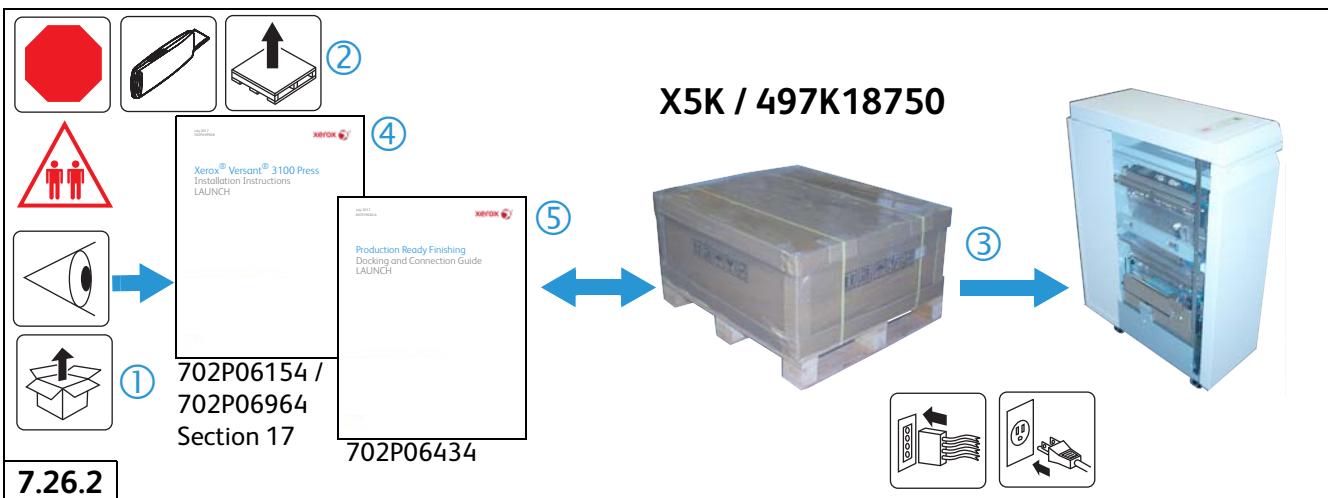
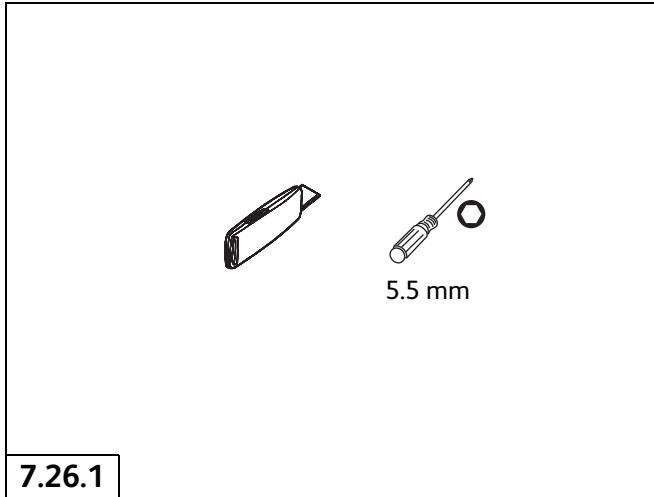
Stop: If a GBC AdvancedPunch Pro is present, DO NOT unpack and/or depalletize the module at the warehouse. Deliver the GBC to the Customer location fully packaged.

7.25.0 Strapping Procedures



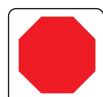
Note: Due to the low center of gravity and the dimensions of the packaged GBC this module will not need to be strapped into the truck.

7.25.1 Position the fully packaged GBC against the wall of the truck.



7.26.0 Delivery - Positioning the GBC (if present)

7.26.1 Tool required for unpacking, depalletizing, and installing the GBC is shown.

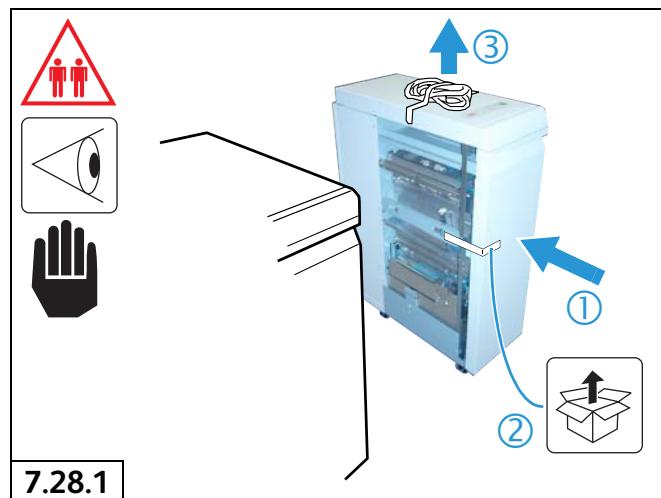
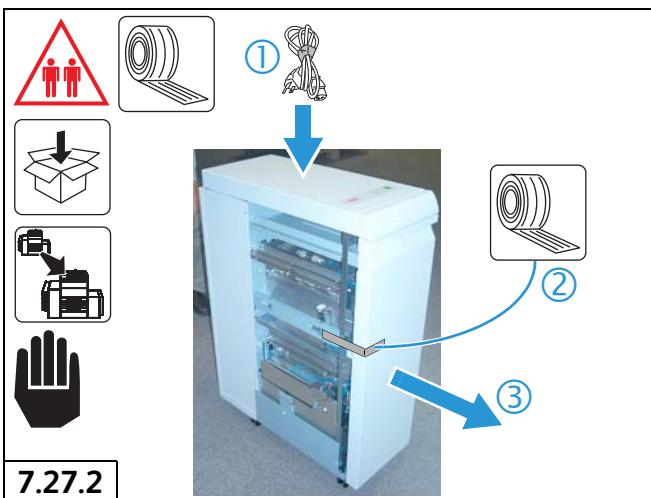
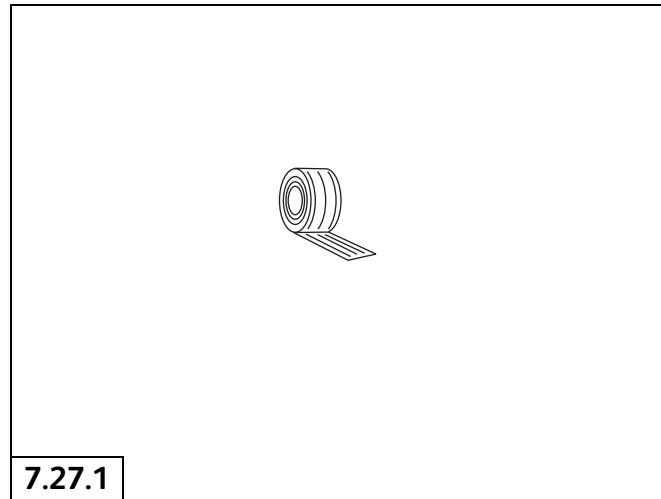
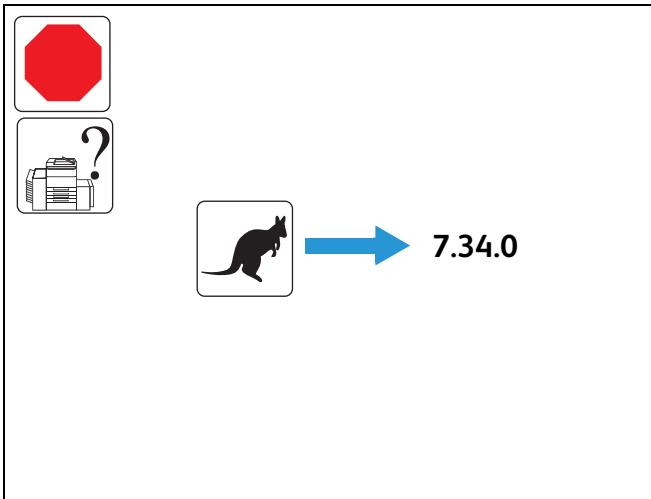


Stop: The Carrier is responsible for unpacking and depalletizing the GBC module at the Customer site. Once depalletized the Carrier will also be responsible for docking, connecting, and getting the module up and running.



WARNING: Due to the size and weight of the GBC module, two people are required to depalletize the module.

7.26.2 ① Unpack, ② depalletize and ③ install the GBC AdvancedPunch Pro (X5K / 497K18750) using the ④ Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) ⑤ and Production Ready Finishing Docking and Connection Guide (702P06434).



Stop: If there are additional finishing accessories, go to 7.34.0 "Accessory F: Delivery - Unpack and Depalletize the High Capacity Stacker (HCS) (MAY / 450S03138 (if present)" on page 7-64.

7.27.0 Simple Relocation - Preparing the GBC for the Move

7.27.1 Material required for preparing the GBC for a simple relocation is shown.



WARNING: Due to the instability of the GBC, two people are required to move the module to the new install location.

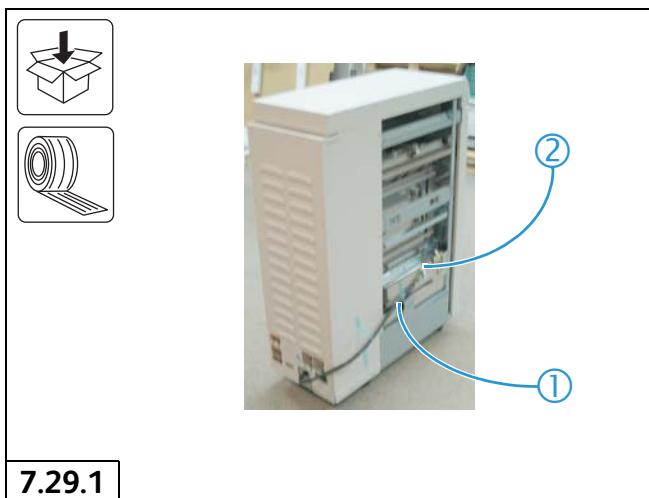
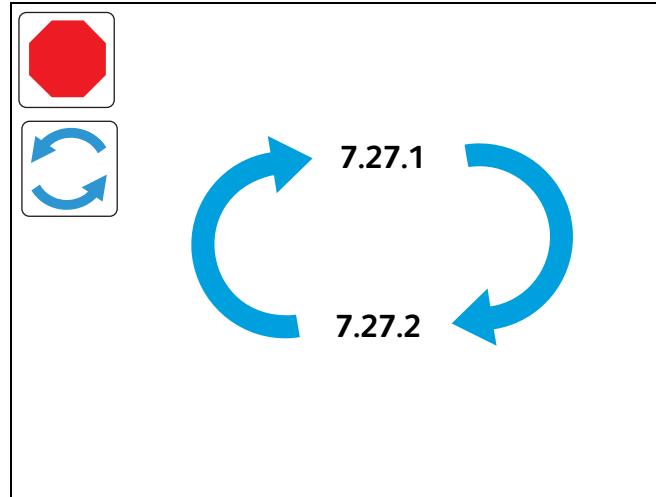
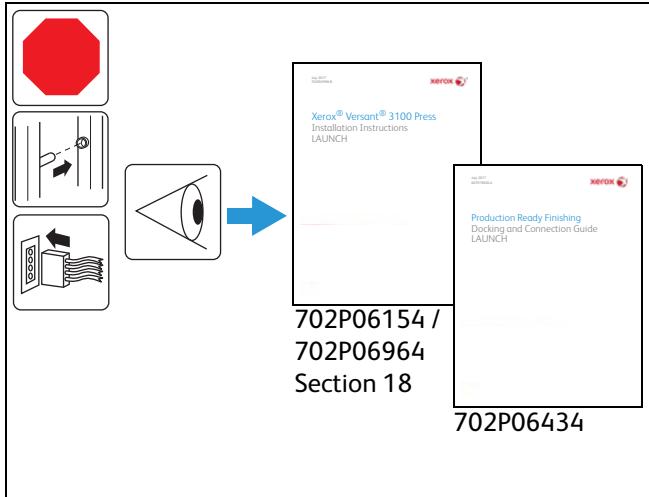
7.27.2 ① Coil and tape the power cord on top of the GBC. ② Tape the front door of the GBC closed and ③ move the module to the new location.

7.28.0 Reinstalling the GBC

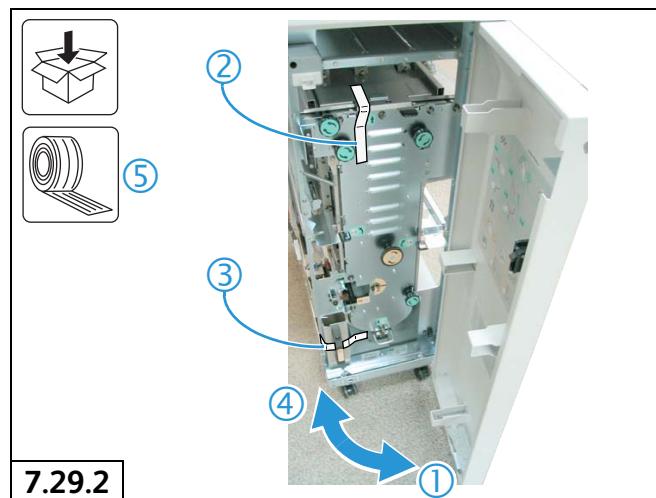


WARNING: Due to the instability of the GBC module, two people are required to position the module to the right of the IDM.

7.28.1 ① Position the GBC to the right of the IDM, then ② remove the tape from the front door. ③ Remove the taped power cord from the top of the module.



7.29.1



7.29.2

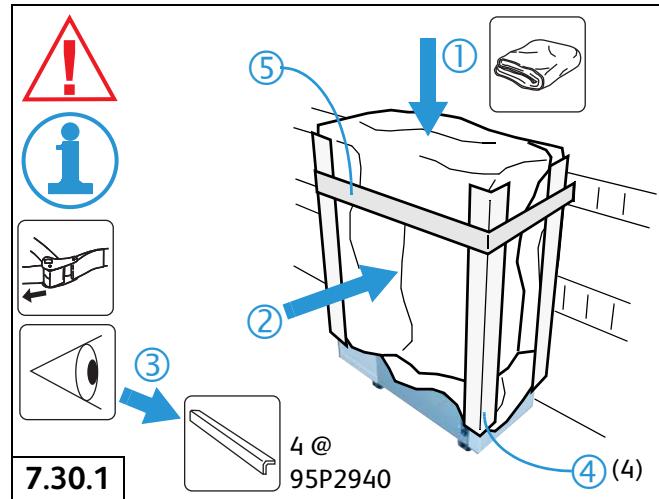
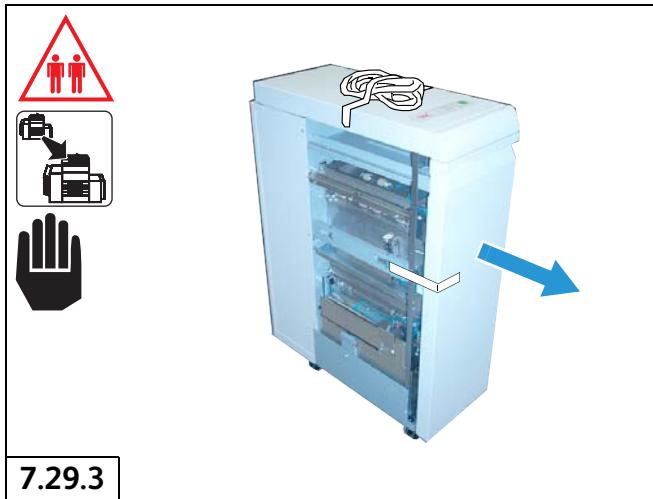
Stop: Use the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) (if present) and the Production Ready Finishing Docking and Connection Guide (702P06434) to get the GBC reinstalled, docked and connected.

7.29.0 Complex Relocation - Preparing the GBC for the Move (if present)

Stop: Repeat all steps in "Simple Relocation - Preparing the GBC for the Move" except for taping the GBC front cover closed, relocating the module, and "Reinstalling the GBC".

7.29.1 ① Position and ② tape the interface cable from the rear of the GBC to the left side of the module.

7.29.2 ① Open the GBC front cover and ② secure baffle 1 and ③ hole punch box with tape. ④ Close the front cover and ⑤ secure with tape.



WARNING: Due to the instability of the GBC, two people are required to move the module to the truck.

7.29.3 Move the GBC to the truck.

7.30.0 Strapping the GBC



CAUTION: When placing the GBC in the truck, ensure the right side of the module is positioned against the wall of the truck.

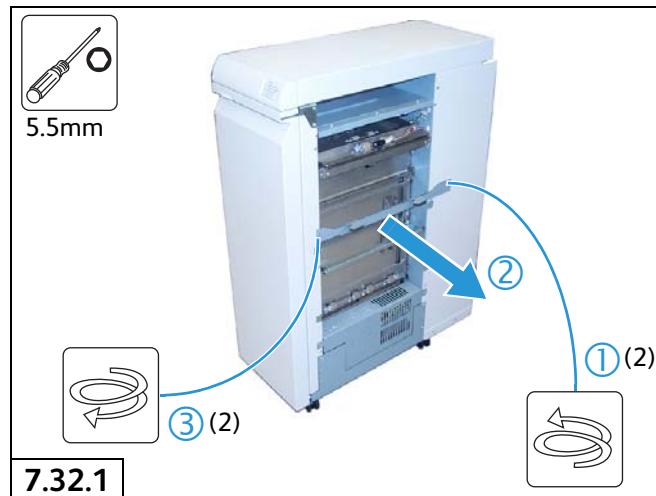
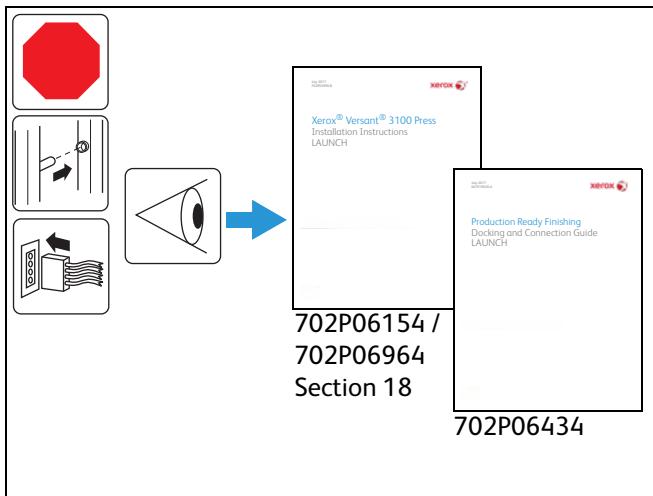
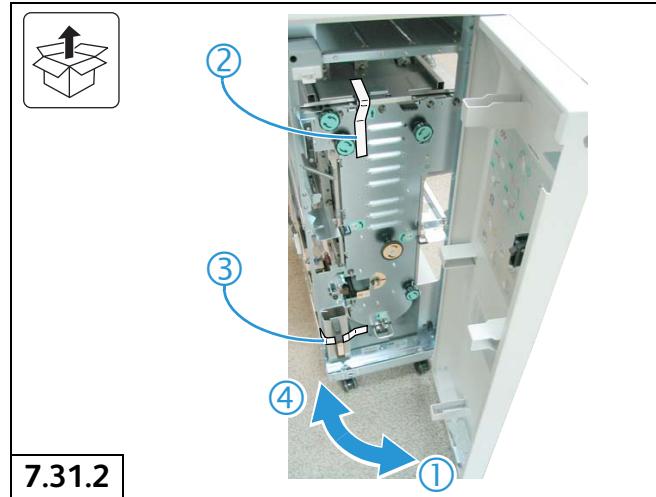
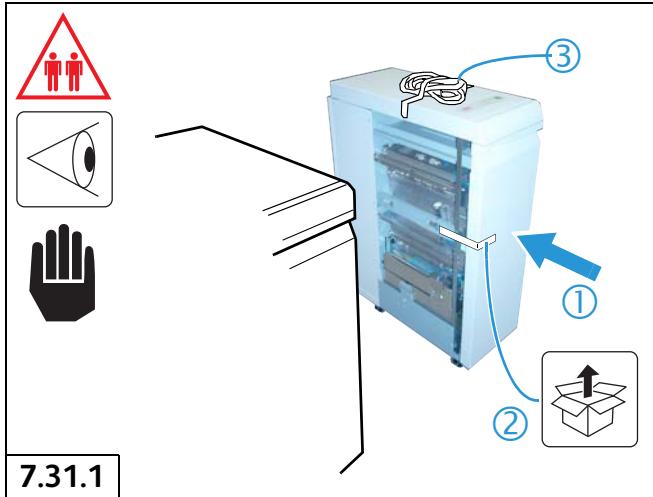


CAUTION: When strapping the GBC into the truck, ensure not to over tighten the strap when securing the module into the truck.



Note: When covering the GBC with the blanket, ensure that the blanket is positioned between the right side of the module and the wall of the truck.

7.30.1 ① Cover the GBC with a blanket and ② then position the module against the wall of the truck. ③ Retrieve and ④ place cornerboards on all four corners of the GBC. ⑤ Strap the module into the truck.



7.31.0 Reinstalling the GBC



WARNING: Due to the instability of the GBC module, two people are required to position the module to the right of the IDM.

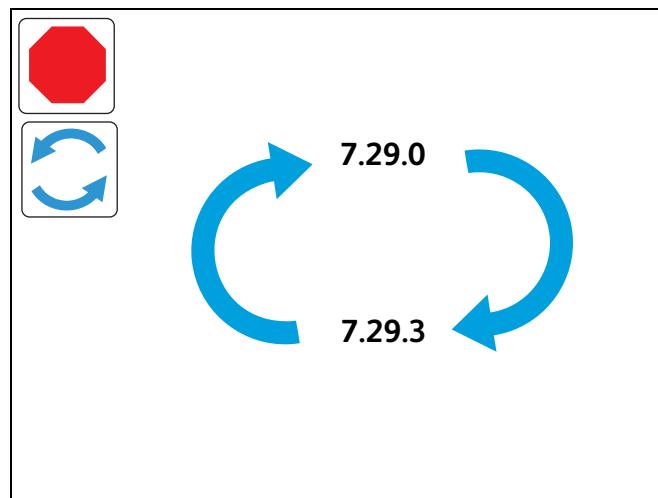
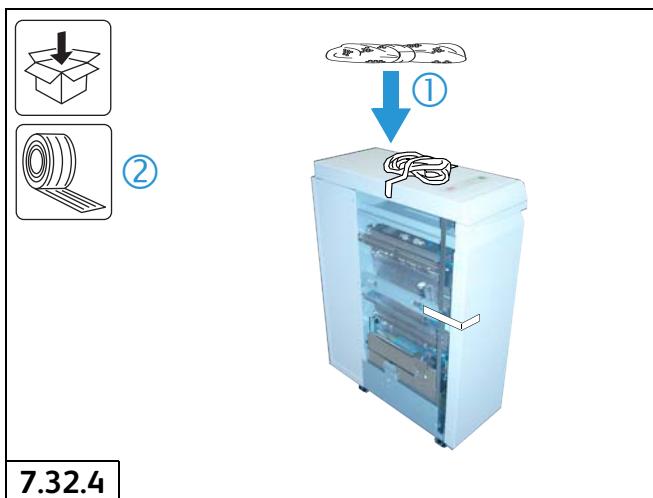
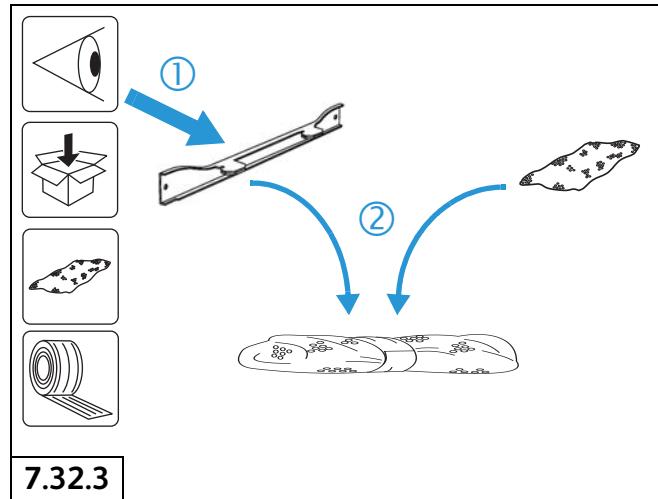
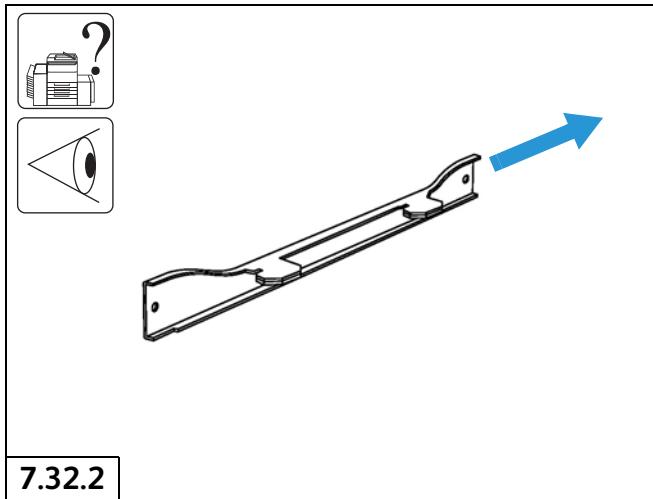
- 7.31.1 ① Position the GBC to the right of the IDM,
- ② remove the tape from the front door, and
- ③ the taped power cord from the top of the module.

- 7.31.2 ① Open the front cover of the GBC and
- ② remove the tape from baffle 1 and ③ punch box.
- ④ Close module front cover.

Stop: Use the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) (if present) and the Production Ready Finishing Docking and Connection Guide (702P06434) to get the GBC reinstalled, docked and connected.

7.32.0 Removal - Preparing the GBC (if present)

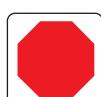
- 7.32.1 ① Remove the two screws and ② docking bracket from the right side of the GBC.
- ③ Reinstall the two screws back into the holes on the right side of the module.



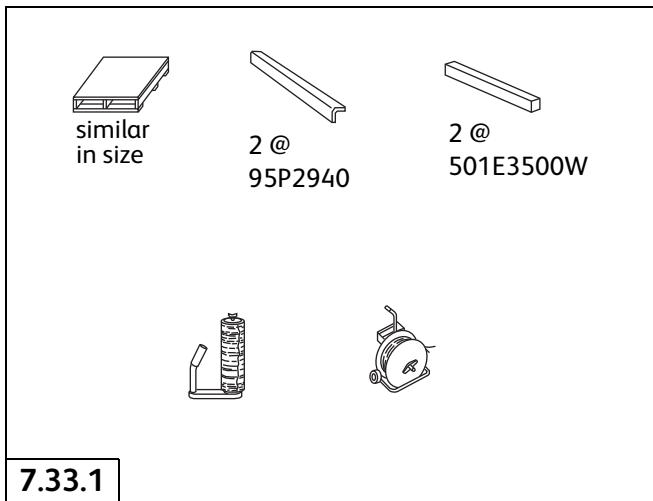
7.32.2 Place the docking bracket with the module to the right of the GBC.

7.32.3 ① Retrieve docking bracket that was attached to the IDM and ② wrap it in bubblepack.

7.32.4 ① Place the bubblepacked docking bracket on top of the GBC and ② secure it in place with tape.



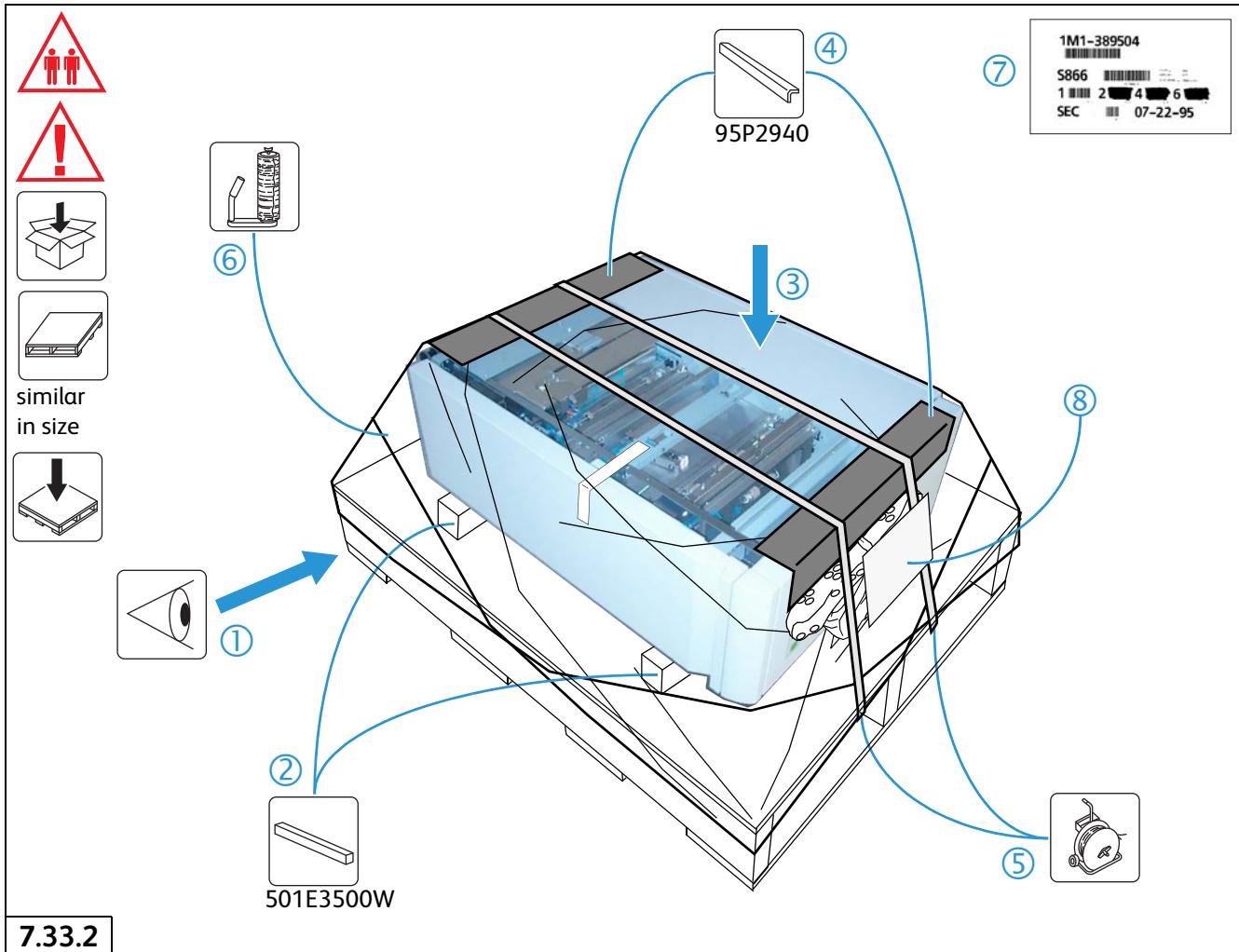
Stop: Perform all steps in "Complex Relocation - Preparing the GBC for the Move (if present)" on page 7-58, except for "Reinstalling the GBC" on page 7-60.



7.33.1

7.33.0 Returning the GBC (if present)

7.33.1 Materials required for palletizing the GBC are shown.



WARNING: Due to the size and weight of the GBC, two people are required to place the module on the generic pallet.

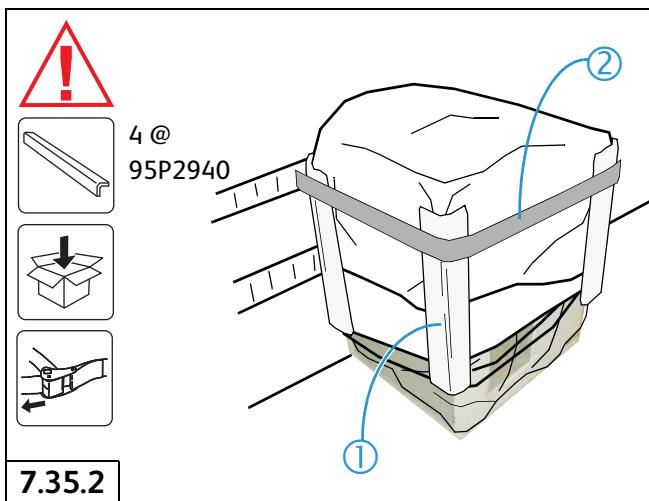
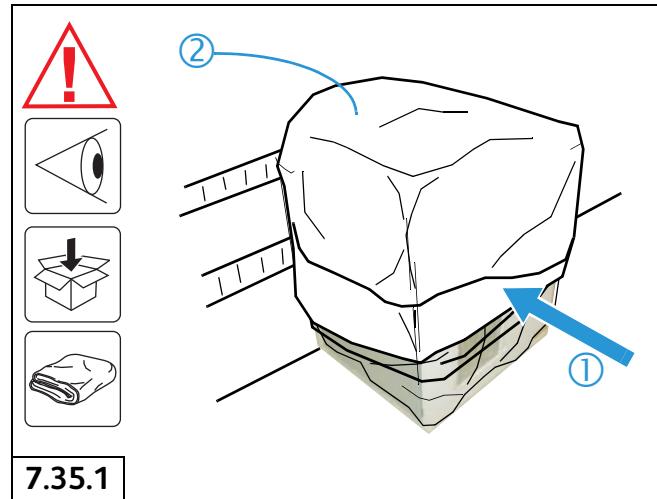
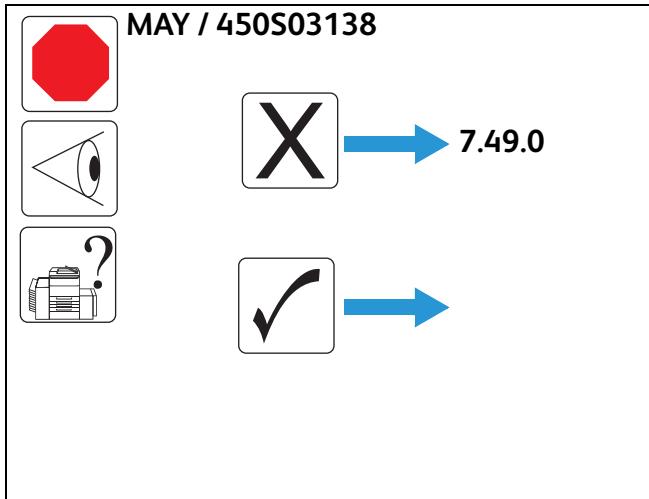


CAUTION: When placing the GBC on the wooden blocks, ensure the blocks are positioned on the frame member of the module.

- ⑤ - Band the module to the pallet.
- ⑥ - Secure the module to the pallet with stretchwrap.
- ⑦ - Generate bar code label. Cross off the non-applicable codes.
- ⑧ - Attach bar code label to the stretchwrap at the open end of the pallet.

7.33.2 Perform the following steps for preparing the GBC for a return:

- ① - Retrieve a generic pallet.
- ② - Place two blocks (501E3500W) on the deck of the pallet.
- ③ - Lift and place the GBC on the two blocks.
- ④ - Place a cornerboard on the top and bottom left side of the module.



7.34.0 Accessory F: Delivery - Unpack and Depalletize the High Capacity Stacker (HCS) (MAY / 450S03138) (if present)

Stop: If a HCS is not present, go to 7.49.0 "Accessory G: Delivery - Depalletize, Unpack, and Install the Crease and Two-sided Trimmer (7XL / 450S03153) (if present)" on page 7-81. If a HCS is present, continue onto the next step.

7.35.0 Strapping the HCS

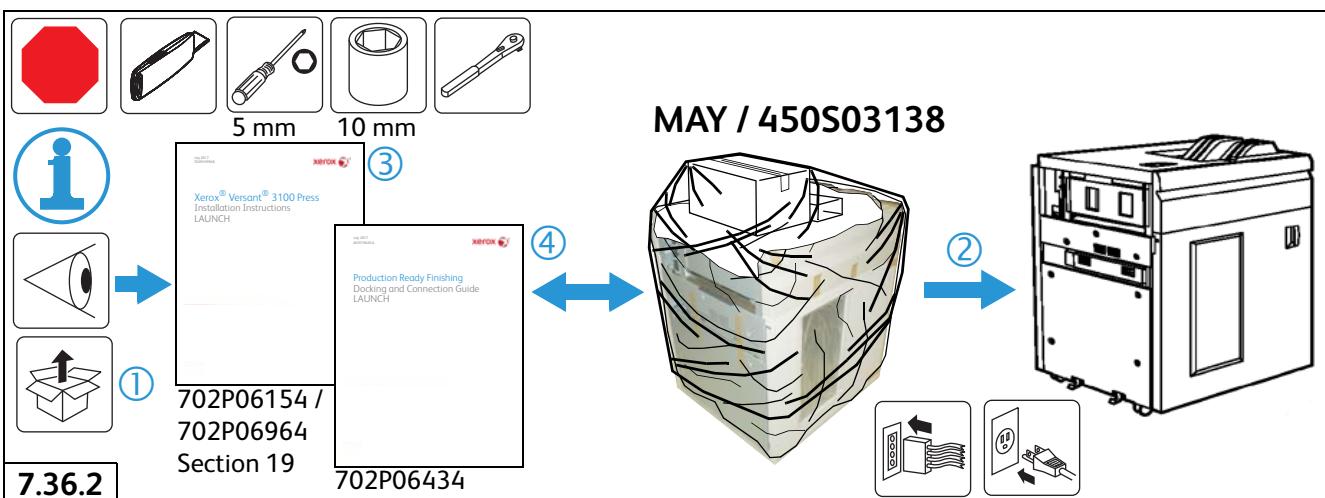
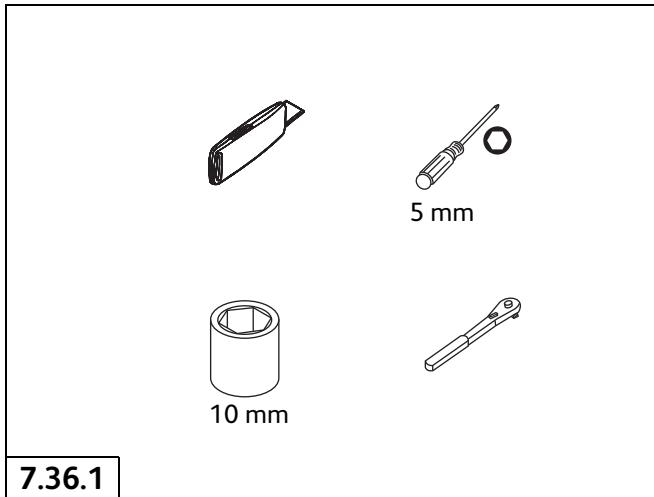
CAUTION: When strapping the HCS into the truck, ensure the rear side of the module is positioned against the wall of the truck.

CAUTION: When placing the blanket over the top of the HCS, ensure the blanket is positioned between the module and the wall of the truck.

- 7.35.1 ① Position the HCS against the truck wall.
② Cover the module with a blanket.

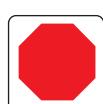
CAUTION: When strapping the HCS into the truck, ensure not to apply too much tension on the module.

- 7.35.2 ① Place a cornerboard (95P2940) on each of the HCS corners and ② strap the module into the truck.



7.36.0 Position, Unpack, and Assemble the HCS (if present)

7.36.1 The tools required to unpack, depalletize, and install the HCS are shown.

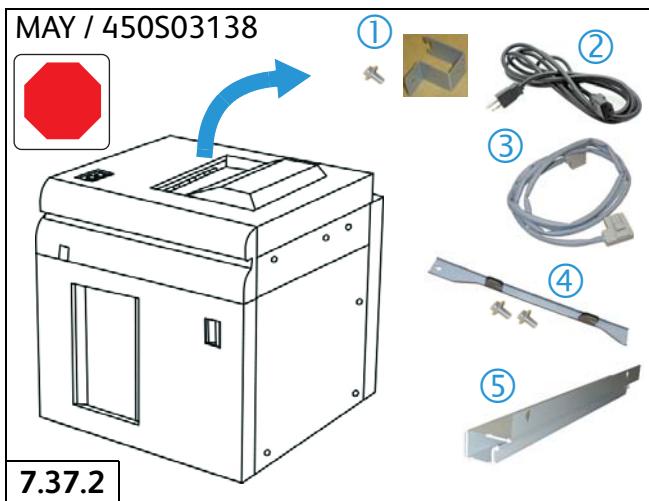
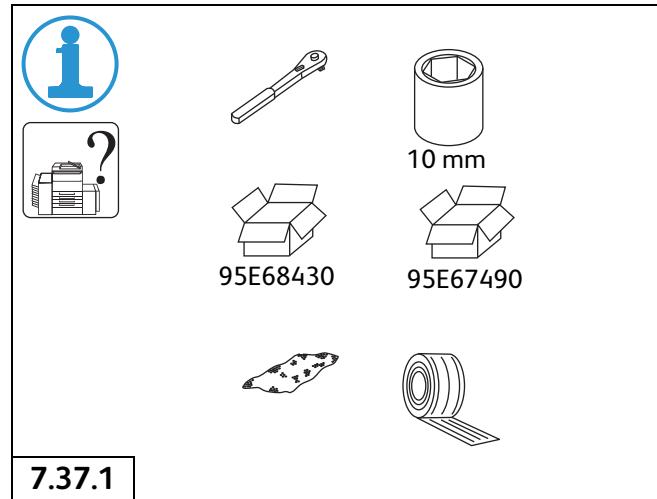
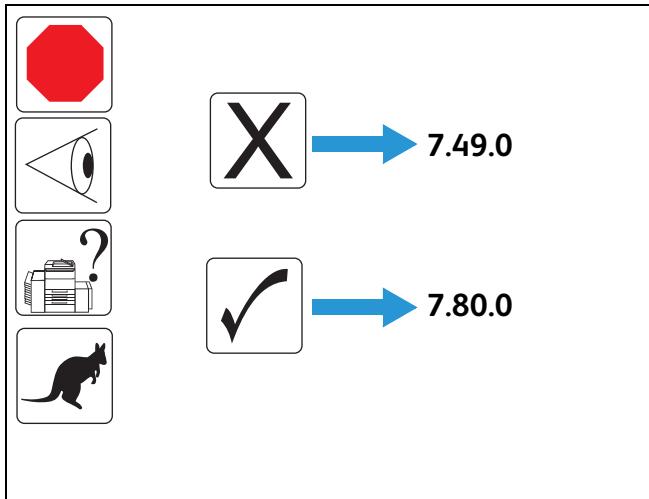


Stop: The assembly of the HCS includes the HCS dolly(ies) that are present.



Note: Installation of this module includes docking and making all electrical connections.

7.36.2 ① Unpack and ② install the HCS (MAY / 450S03138) (if present), using the ③ Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and ④ Production Ready Finishing Docking and Connection Guide (702P06434).



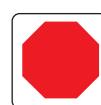
Stop: If there are additional finishing accessories, go to 7.49.0 "Accessory G: Delivery - Depalletize, Unpack, and Install the Crease and Two-sided Trimmer (7XL / 450S03153) (if present)" on page 7-81. If there are no additional finishing accessories, go to 7.80.0 "Accessory K: Delivery - Preparing the EFI™ Standalone NX Premium DFE (2A8/097N02291)" on page 7-128.

7.37.0 Relocation - Preparing the HCS for the Move (if present)

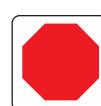


Note: The number of 95E67490 boxes is determined by how many HCS dollies are present.

7.37.1 The tools and materials required to relocate the HCS and dolly(ies) are shown.

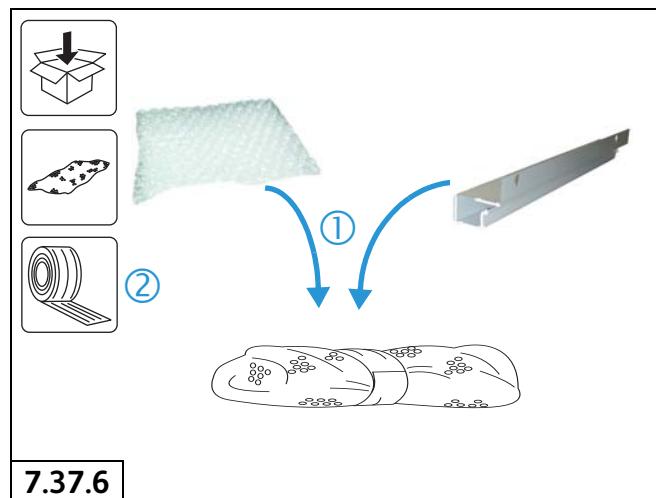
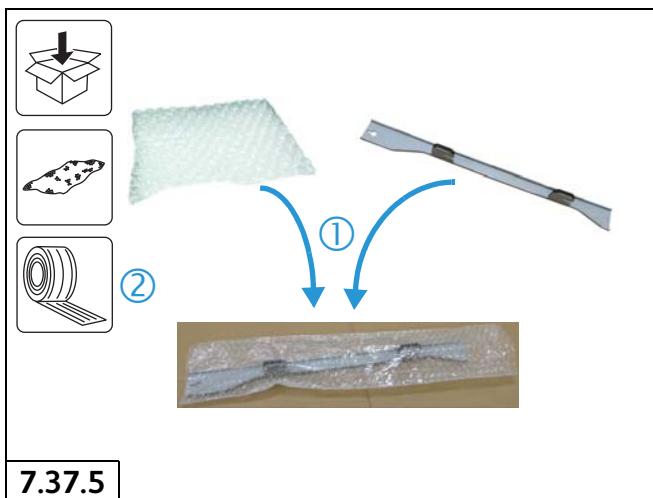
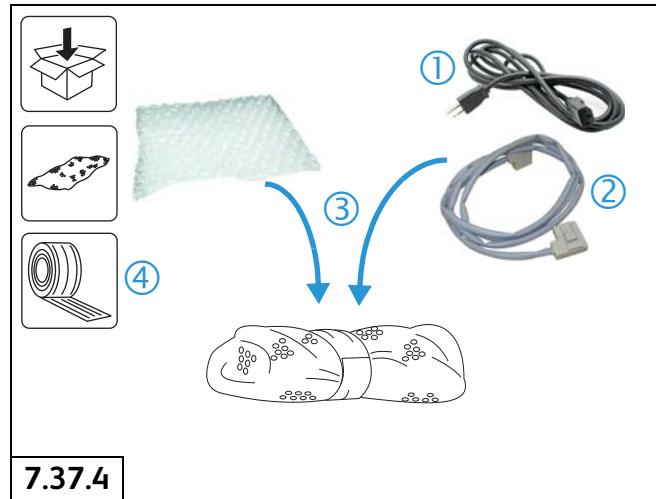
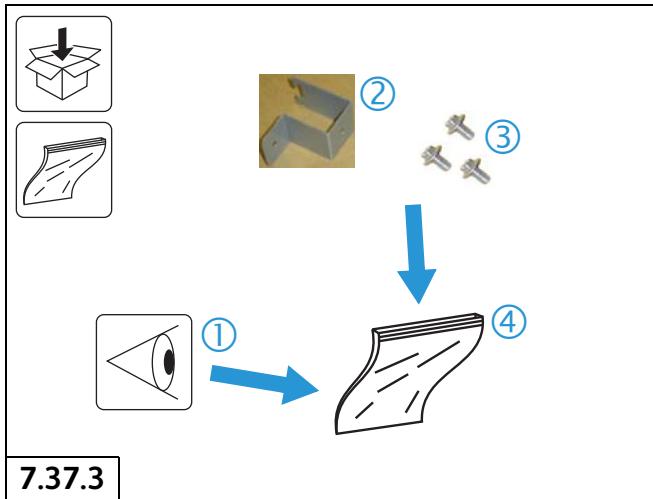


Stop: Removal of power cord and interface cable along with the undocking of the module from the upstream module should already be complete.



Stop: Items on top of HCS can remain there if the move of the system is within the same room or floor of the Customer location.

7.37.2 ① Remove the power cord protector and screw, ② coiled power cord, ③ coiled interface cable, ④ docking bracket and screws and ⑤ cable channel on top of the HCS.

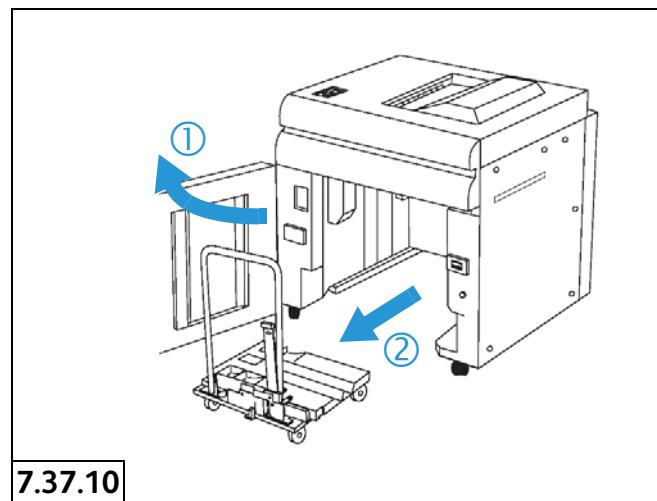
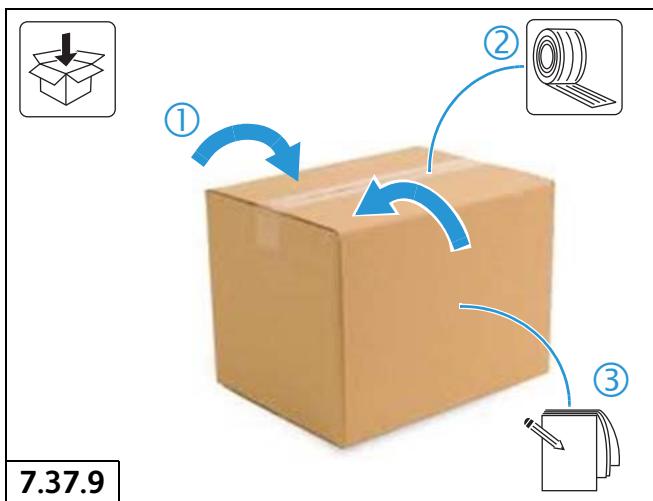
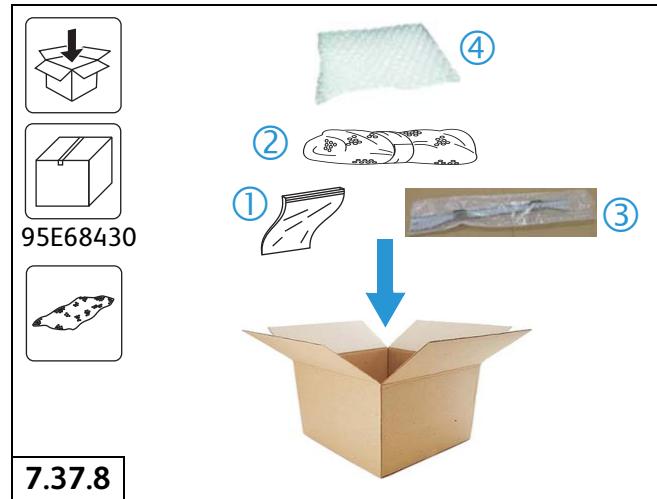
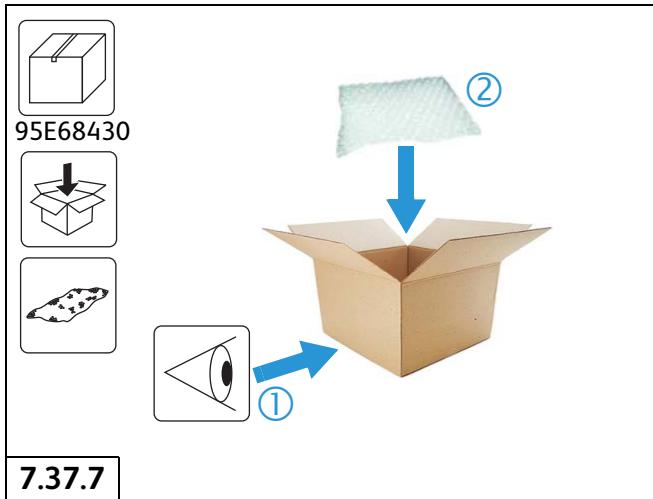


7.37.3 ① Retrieve a small plastic bag, ② place the power cord protector and ③ screws (3) in the bag.
④ Close the bag.

7.37.4 ① Wrap the coiled power cord and ② interface cable in a layer of ③ bubblepack and
④ secure with tape.

7.37.5 ① Wrap the docking bracket in a layer of
bubblepack and ② secure with tape.

7.37.6 ① Wrap the cable channel in a layer of
bubblepack and ② secure with tape.

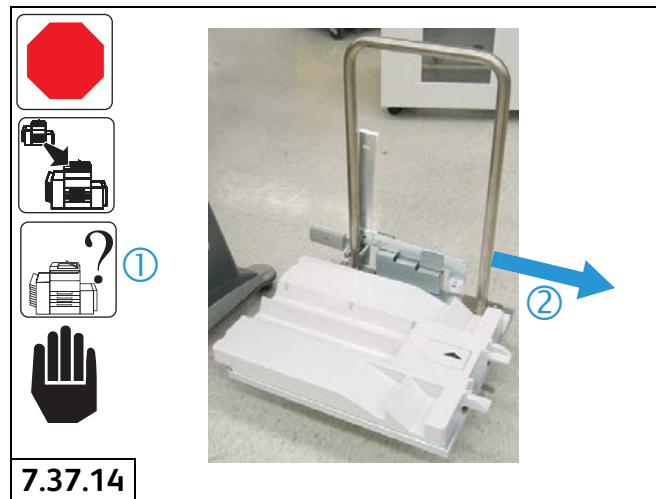
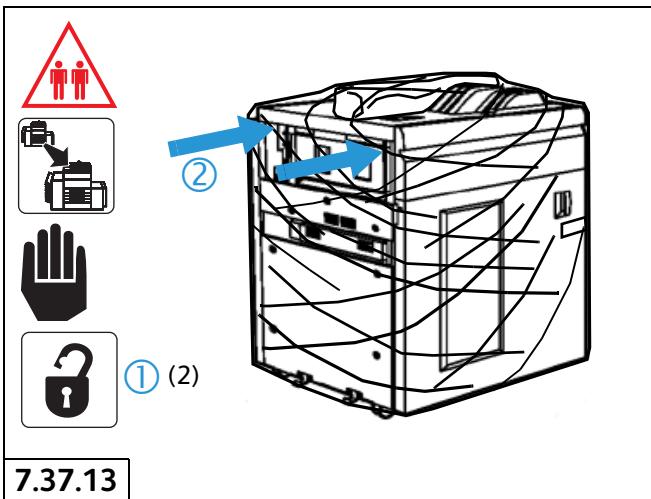
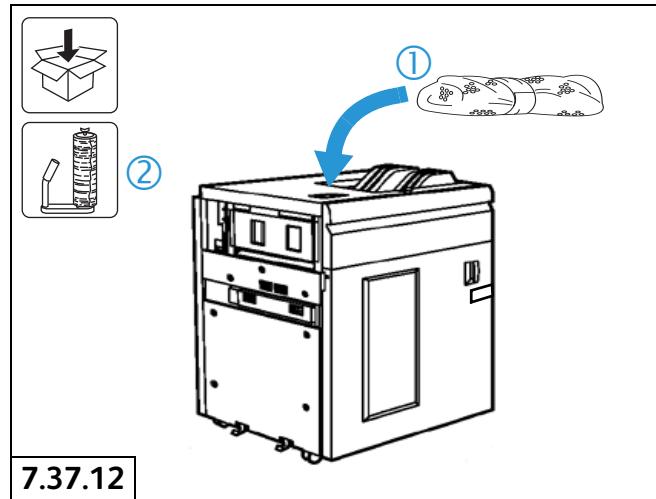
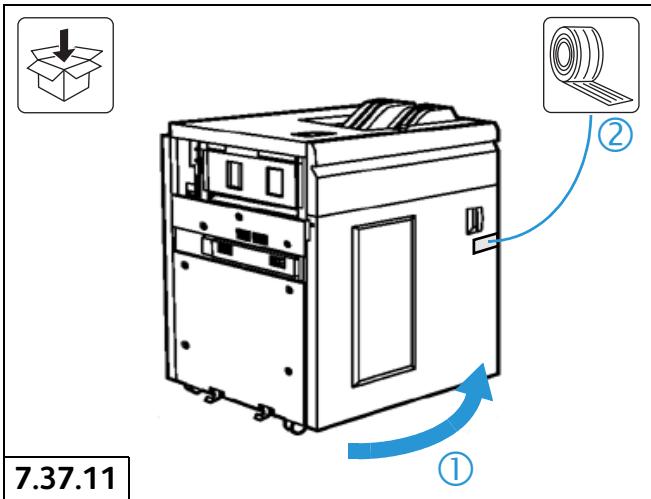


7.37.7 ① Retrieve a generic box (95E68430) and ② place a layer of bubblepack in the bottom of the box.

7.37.8 ① Place the bag of hardware, ② packed cables and ③ packed docking bracket within the box. Then, ④ fill all voids with bubblepack.

7.37.9 ① Close and ② secure the box with tape.
③ Write the content on the outside of the box.

7.37.10 ① Open the front door of the HCS and ② remove the HCS dolly (if present).



7.37.11 ① Close and ② tape the front cover of the HCS.

7.37.12 ① Place the packed cable channel on top of the HCS. ② Secure items in place with a layer of stretchwrap.

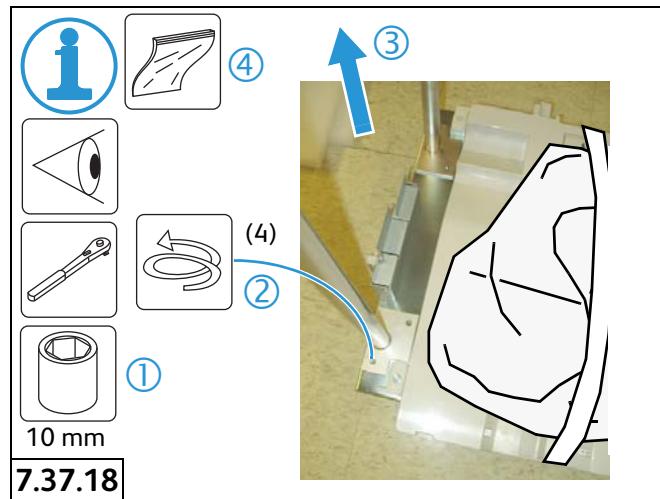
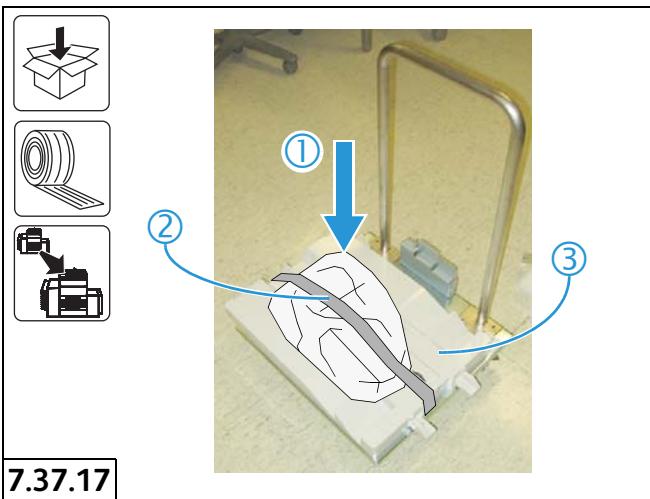
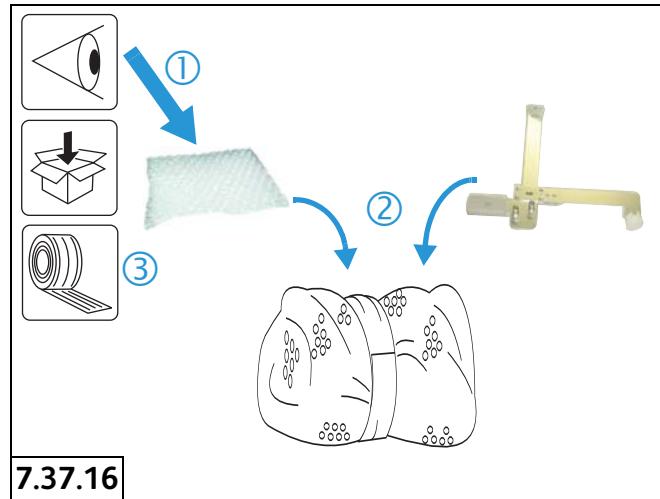
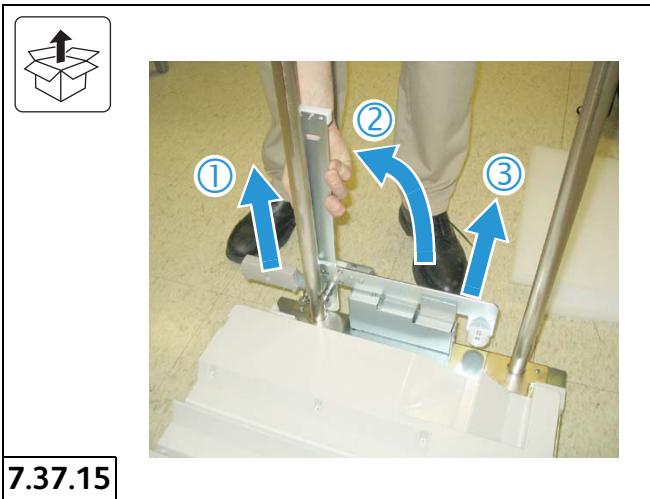


WARNING: Due to the size and weight of the HCS, two people are required to move the HCS to the new install location.

7.37.13 ① Unlock the casters (2) and ② move the HCS to the new install location or truck.

Stop: Because there may be more than one cart present, be sure to look around or ask Customer about any additional carts that may need to be moved to the new location.

7.37.14 If relocation is within the same room or on the same floor, move the HCS dolly(ies) to the new install location or truck.



7.37.15 If relocation is to another location or if the dolly(ies) are being returned, ① raise the lock-down from the actuator, ② rotate the lock-down, ③ and remove the lock-down from the dolly handle.

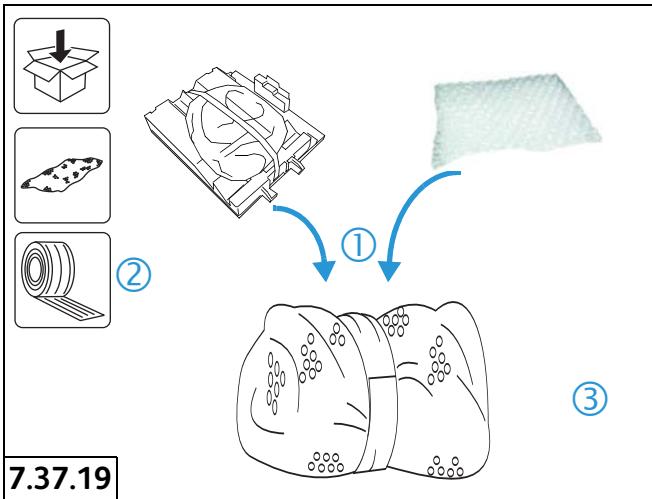
7.37.16 ① Retrieve a piece of bubblepack and ② wrap the lock-down. ③ Secure the bubblepacked lock-down with tape.

7.37.17 ① Place lock-down on the top of the base cover. ② Tape the bubblepacked lock-down and ③ the base cover to the dolly base.

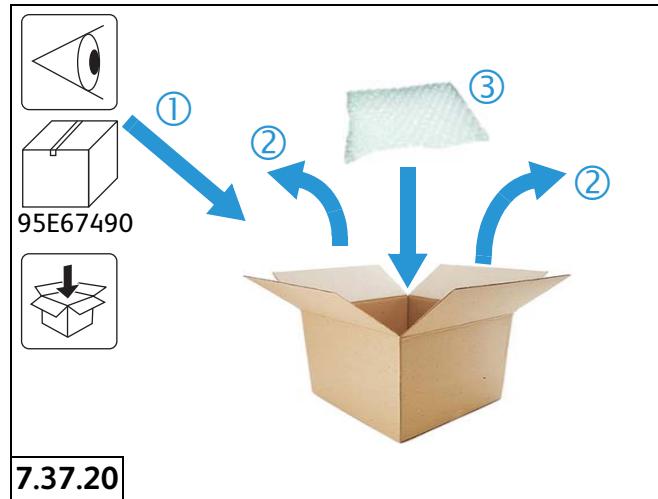


Note: Hardware consists of four bolts and four lock washers.

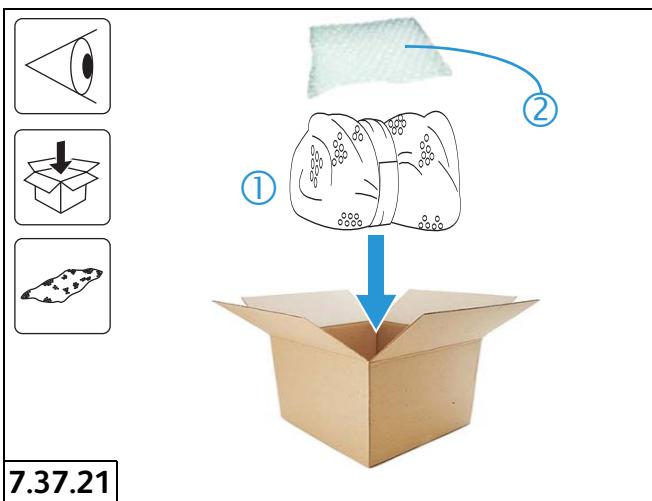
7.37.18 ① Using a 10 mm socket, ② remove the four bolts securing the dolly handle to the dolly base. ③ Remove the handle from the base of the dolly. ④ Place all hardware in plastic bag.



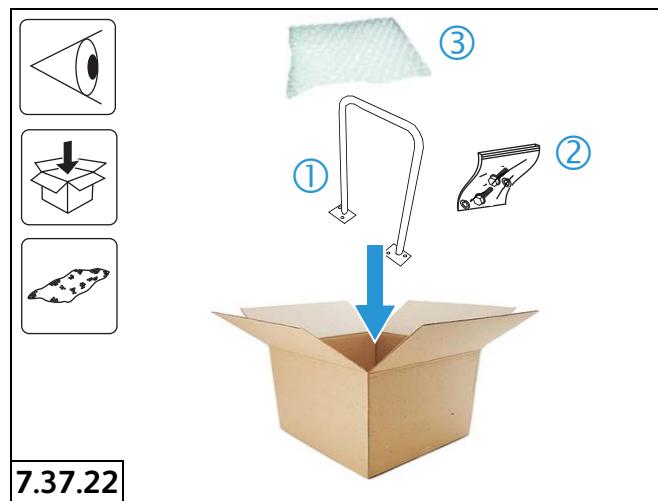
7.37.19



7.37.20



7.37.21



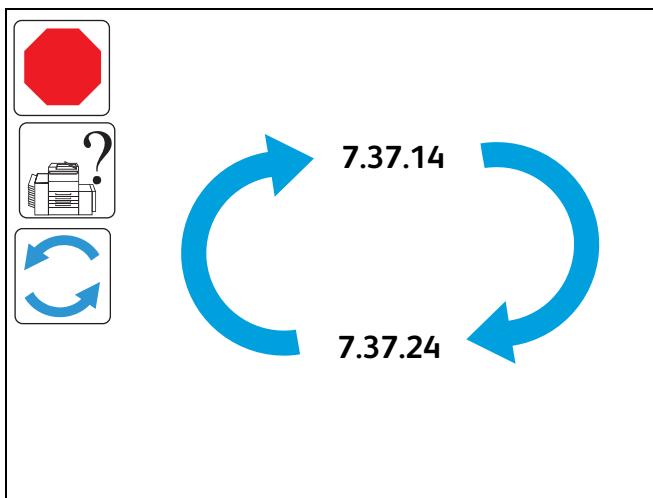
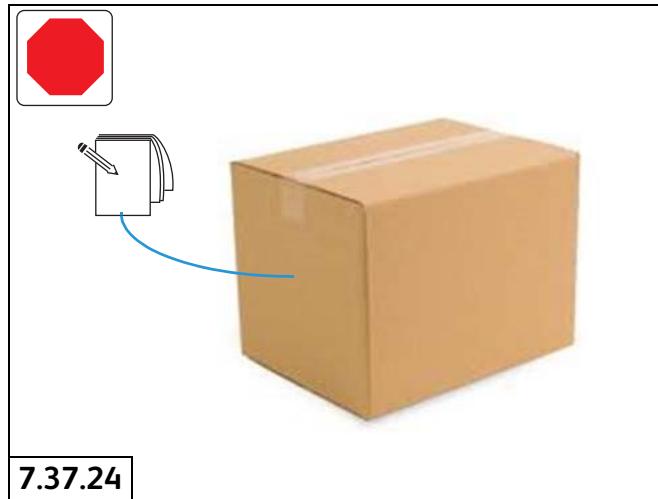
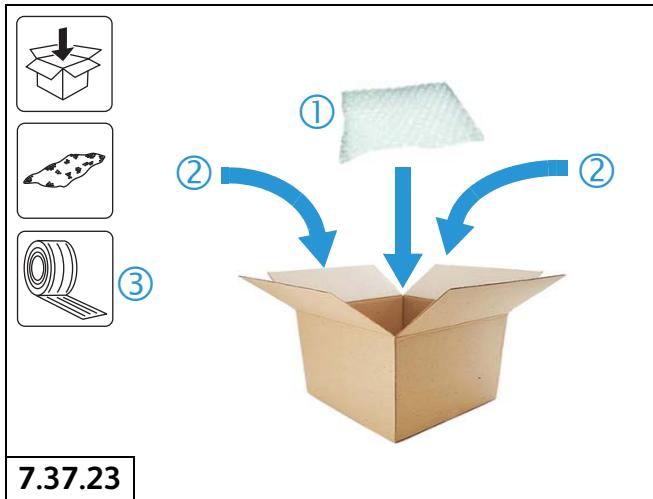
7.37.22

7.37.19 ① Wrap the dolly base and base cover and bubblepacked lock-down in a piece of bubblepack. ② Secure the bubblepacked items with tape.

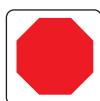
7.37.20 ① Retrieve a generic box (95E67490), ② open it, and ③ line the bottom with a layer of bubblepack.

7.37.21 ① Place the wrapped dolly base in the bottom of the generic box. ② Cover base with a layer of bubblepack.

7.37.22 ① Retrieve and place the dolly handle and ② bag of hardware in the box. ③ Cover the handle with a layer of bubblepack.

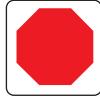


7.37.23 ① Fill all voids with bubblepack. ② Close and ③ secure the box with tape.

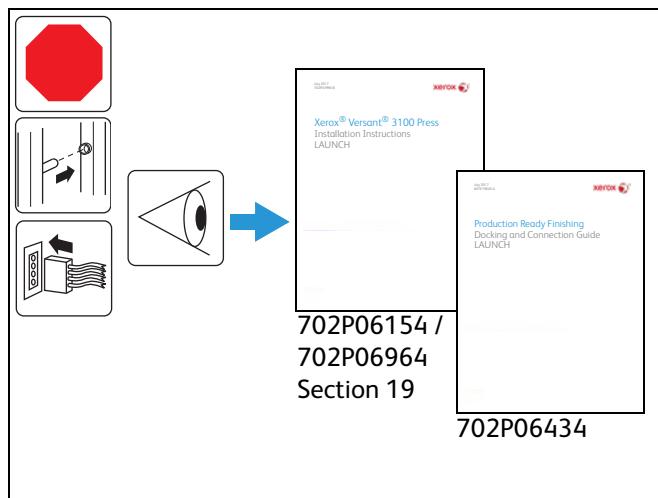


Stop: One boxed dolly is to remain with the HCS at all times.

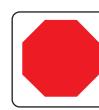
7.37.24 Write the contents on the outside of the box. If there are additional dollies that are present, these dollies are to be kept together with the HCS.



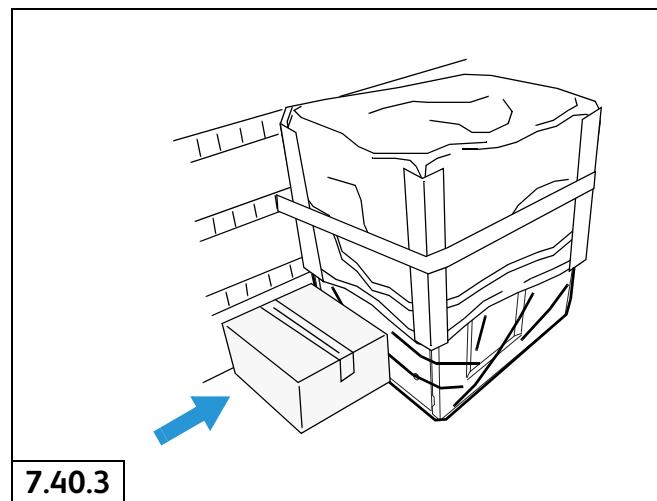
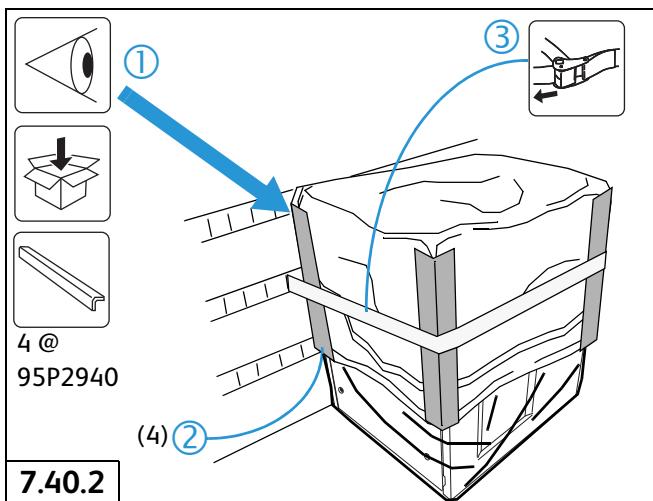
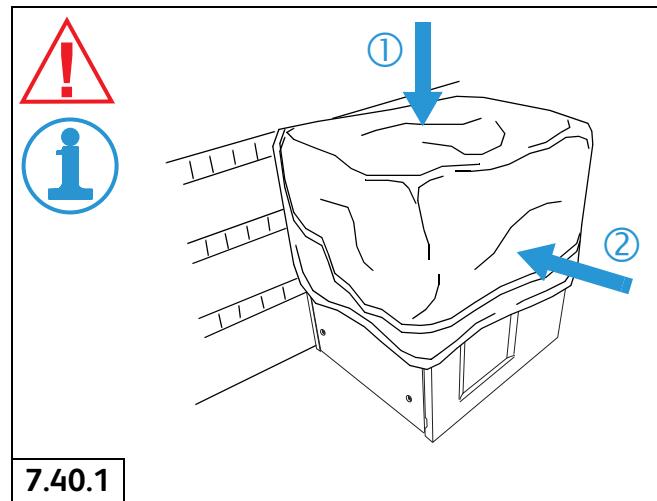
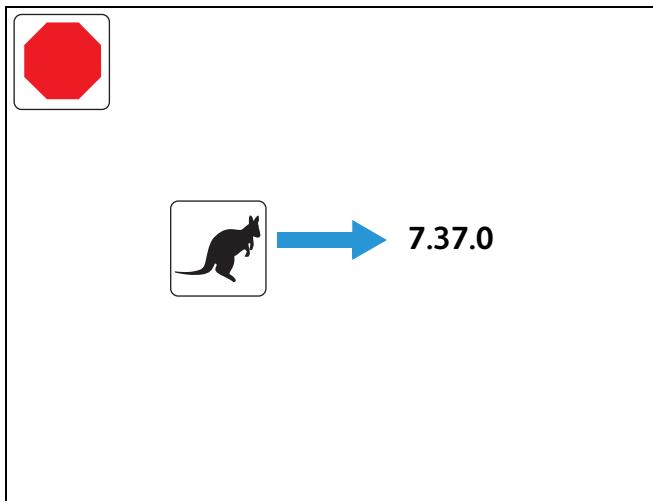
Stop: If additional dollies are present, repeat steps 7.37.14 on page 7-69 through 7.37.24 on page 7-72 for each of the dollies.



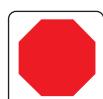
7.38.0 Reinstalling the HCS



Stop: Use the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) (if present) and the Production Ready Finishing Docking and Connection Guide (702P06434) to get the HCS reinstalled, docked and connected. Included with the reinstallation of the HCS is the handling of the dolly(ies).



7.39.0 Return - Preparing the HCS for the Move (if present)



Stop: Perform all steps in 7.37.0 "Relocation - Preparing the HCS for the Move (if present)" page 7-66. Do not perform the reinstallation procedures.

7.40.0 Strapping the HCS



CAUTION: When placing the HCS in the truck, ensure the rear of the HCS is against the wall of the truck.

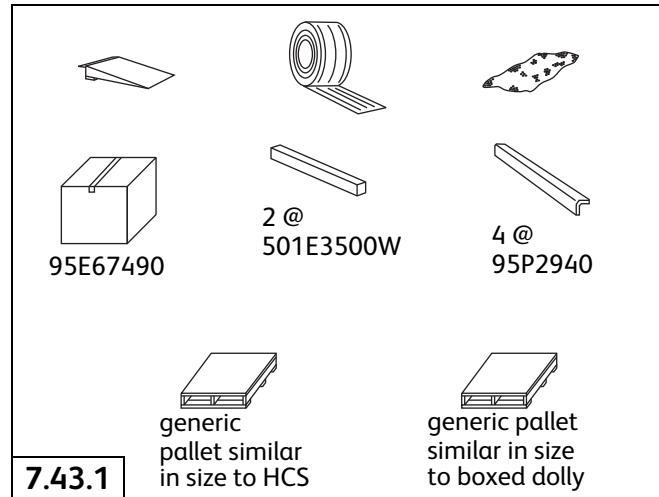
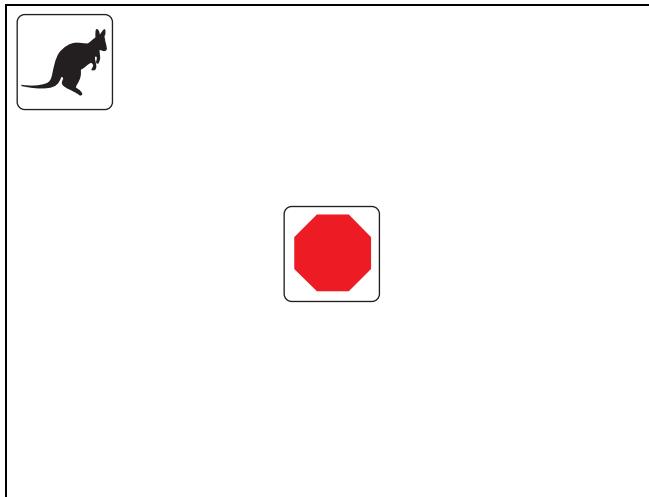
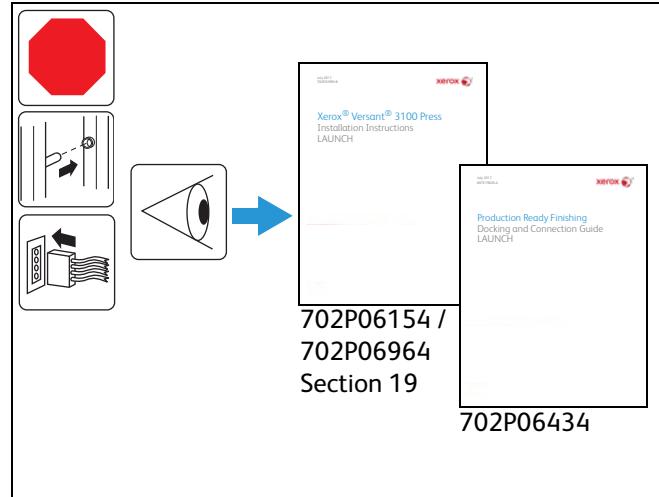
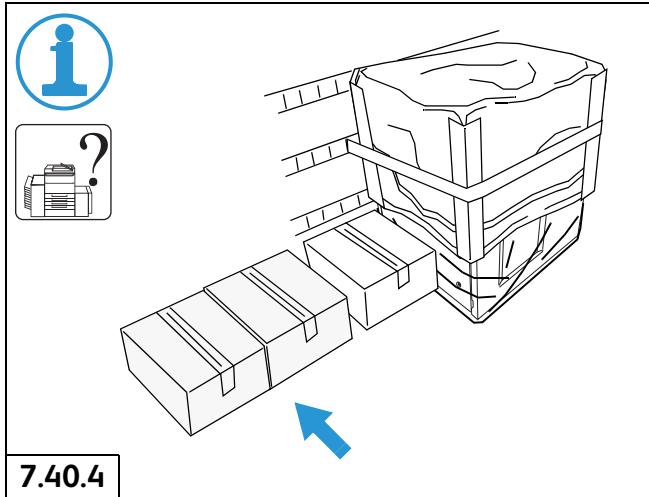


Note: When covering the HCS with the blanket, ensure that the blanket is positioned between the rear of the module and the wall of the truck.

7.40.1 ① Cover the HCS with a blanket and ② then position the module against the wall of the truck.

7.40.2 ① Retrieve and ② place cornerboards on all four corners of the HCS. ③ Strap the HCS into the truck.

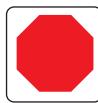
7.40.3 Place the boxed dolly on the floor next to the HCS.



Note: Try and keep all additional dollies together. There could possibly be three additional dollies present.

7.40.4 If additional dollies are present, place the additional boxed dollies on the floor of the truck.

7.41.0 Reinstalling the HCS



Stop: Use the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) (if present) and the Production Ready Finishing Docking and Connection Guide (702P06434) to get the HCS reinstalled, docked and connected. Included with the reinstallation of the HCS is the handling of the dolly(ies).

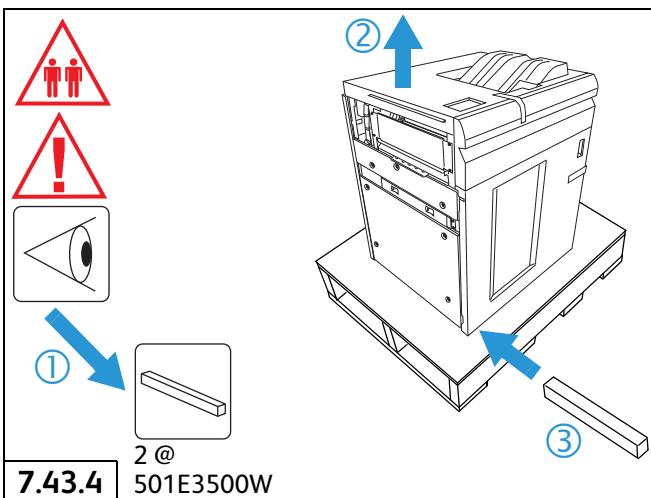
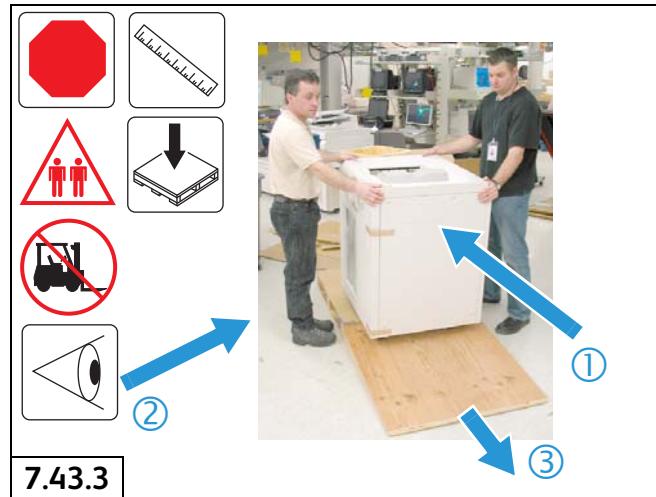
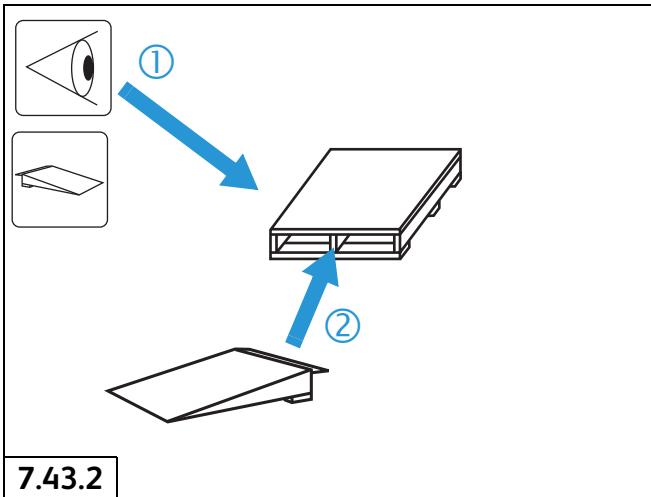
7.42.0 Removal of the HCS (if present)



Stop: Perform all steps in "Return - Preparing the HCS for the Move (if present)" on page 7-73, except for "Reinstalling the HCS" on page 7-74.

7.43.0 Returning the HCS (if present)

7.43.1 The tool and materials required to palletize the HCS are shown.



7.43.2 ① Retrieve a generic pallet similar in size and ② place a ramp at one end of it.



Stop: Due to the open cavity of the HCS, **do not use a forklift to palletize the HCS.**



WARNING: Due to the size and weight of the HCS, two people are required to palletize the HCS.

7.43.3 Using two people, ① palletize the HCS by rolling the module up the ramp onto the pallet. ② Center HCS on the pallet. ③ Remove the ramp from alongside the pallet.

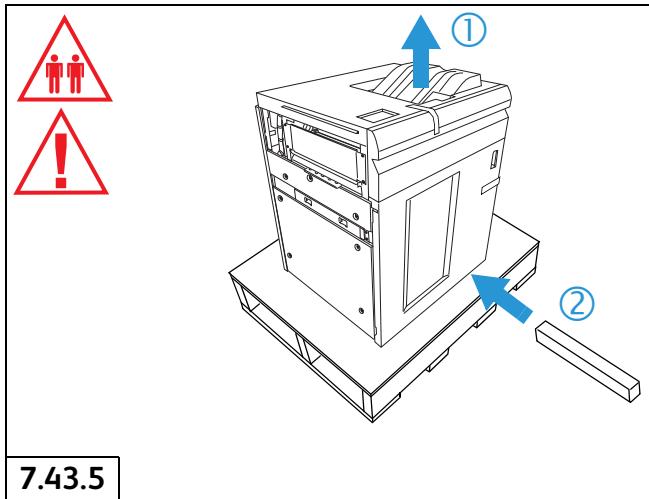


WARNING: Due to the size and weight of the HCS, two people are required to place the blocks under the HCS.

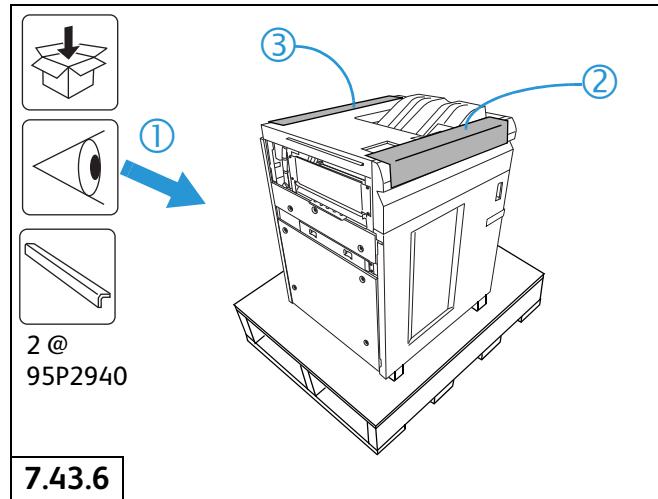


CAUTION: When placing the blocks under the HCS, ensure the frame of the module is resting on the wooden blocks.

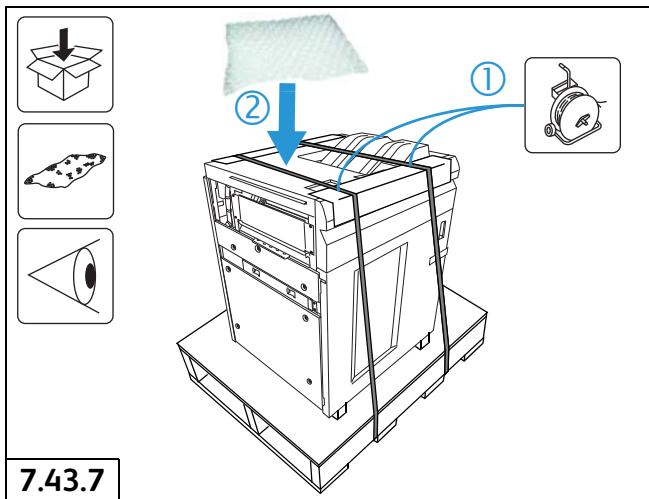
7.43.4 ① Retrieve two wooden blocks (501E3500W). ② Lift the left side of the HCS and ③ slide one block under the module.



7.43.5



7.43.6



7.43.7



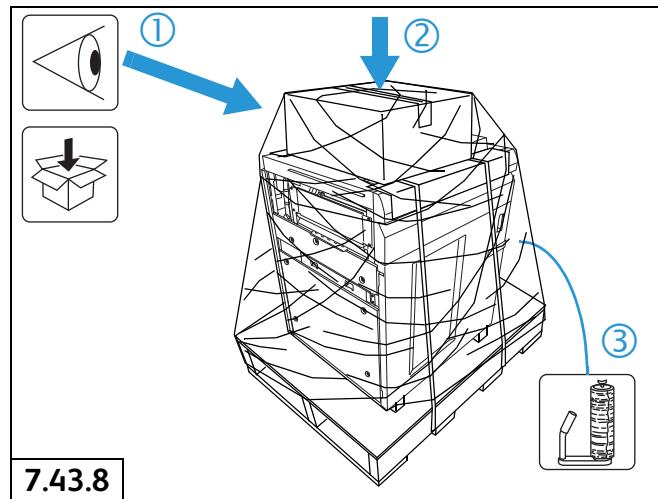
WARNING: Due to the size and weight of the HCS, two people are required to place the blocks under the HCS.



CAUTION: When placing the blocks under the HCS, ensure the frame of the module is resting on the wooden blocks.

7.43.5 ① Lift the right side of the HCS and ② slide the other wooden block (501E3500W) under the module.

7.43.6 ① Retrieve and ② position two corner-boards (95P2940) on the top front and ③ rear edges of the HCS.



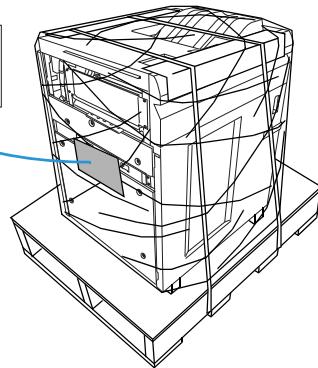
7.43.8

7.43.7 ① Secure the HCS to the pallet by ensuring the two bands are positioned over the corner-boards. ② Place a layer of bubblepack over the top of the HCS.

7.43.8 ① Retrieve the boxed dolly and ② place it on the top left side of the HCS. ③ Secure the boxed dolly to the top of the HCS with stretchwrap.

**7.43.9****7.43.10**

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**7.44.1****7.44.2**

7.43.9 Generate the bar code label. Cross off the non-applicable codes.

7.44.2 ① Band the boxes to that pallet and ② cover them with stretchwrap.

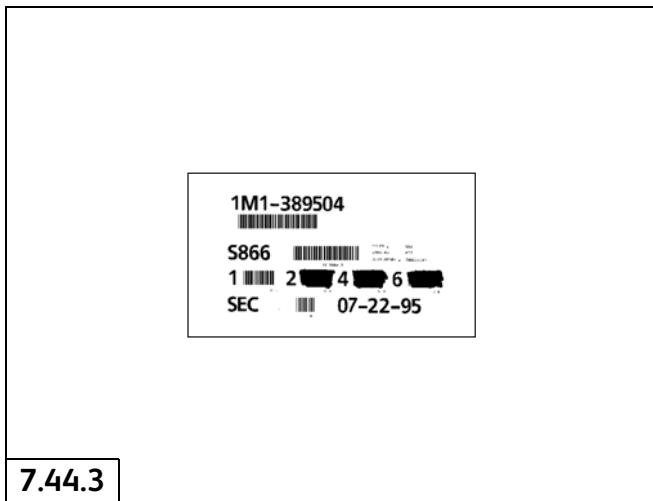
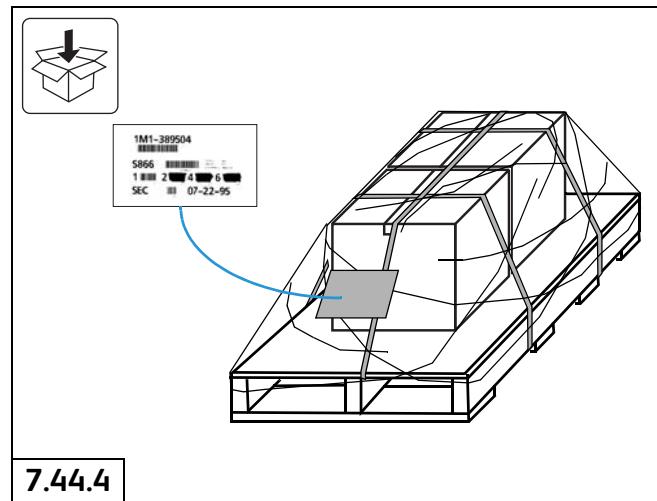
7.43.10 Apply the bar code label to the stretchwrap at the open end of the pallet.

7.44.0 Returning the HCS Additional Dollies (if present)



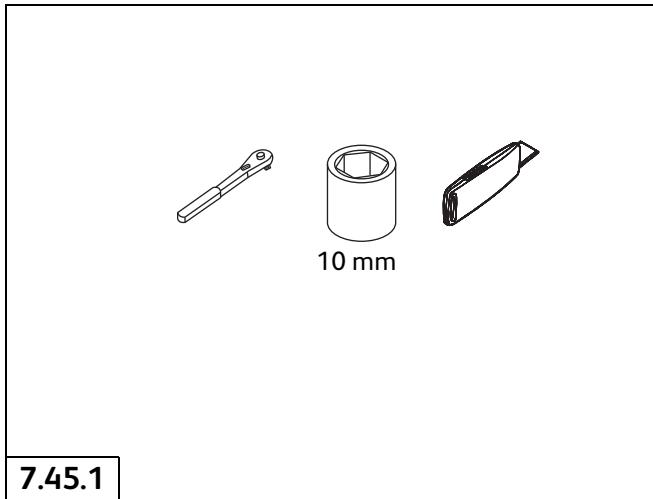
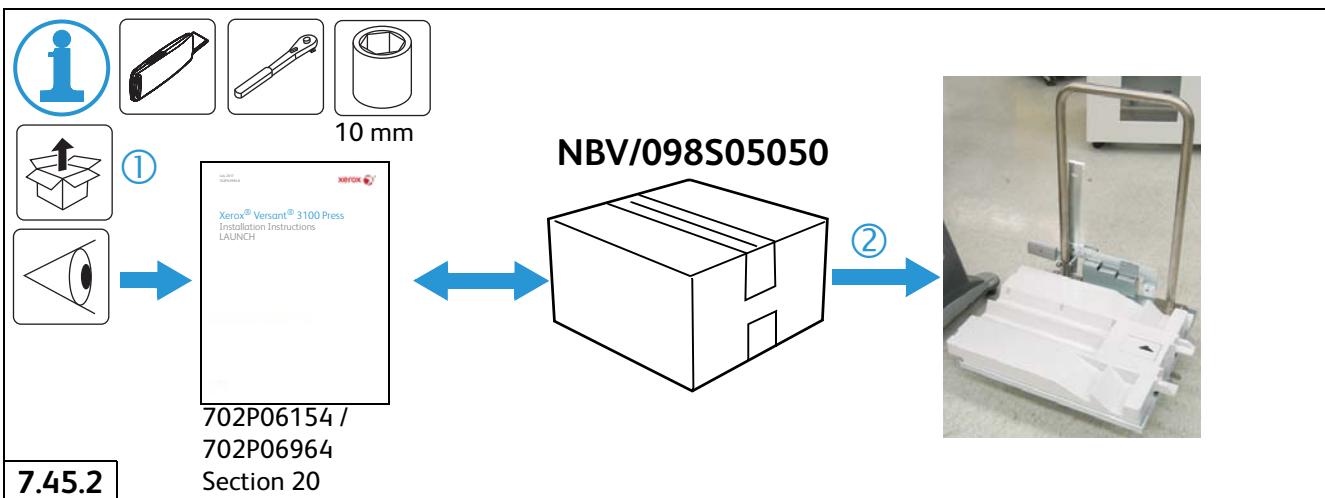
Note: The overall pallet configuration will depend on the number of boxed dollies that are returned.

7.44.1 ① Retrieve a generic pallet and ② stack all boxed dollies on the pallet.

**7.44.3****7.44.4**

7.44.3 Generate the bar code label. Cross off the non-applicable codes.

7.44.4 Apply the bar code label to the stretchwrap at the open end of the pallet.

**7.45.1**

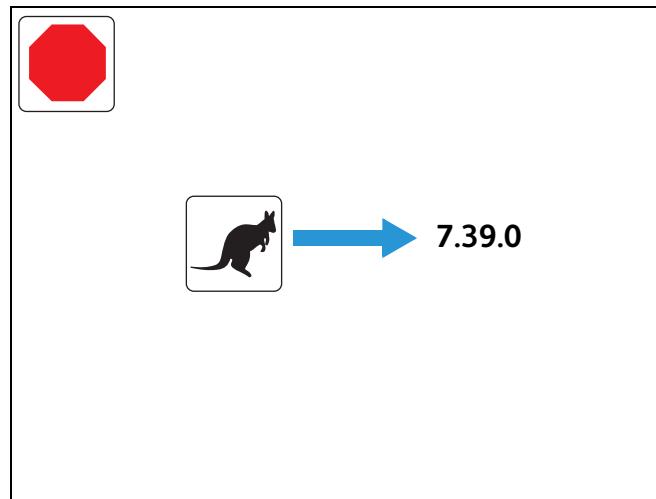
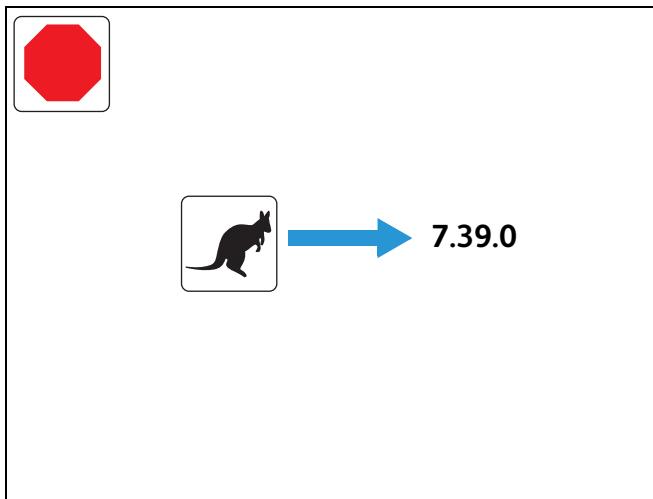
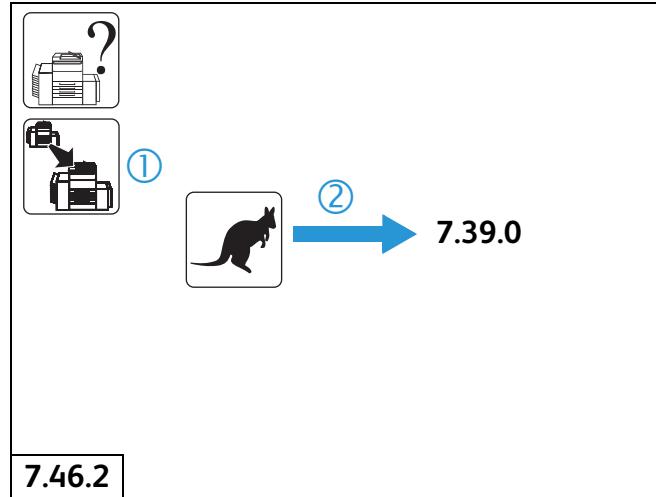
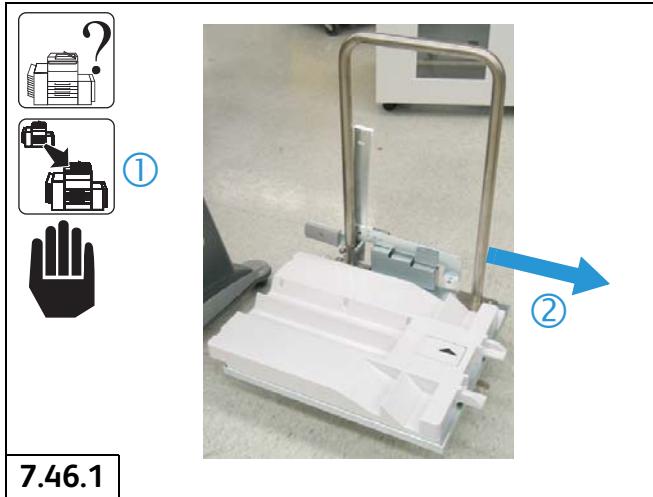
7.45.0 Accessory F: Unpack and Assemble HCS Dolly (NBV/098S05050) (if present)

7.45.1 The tools required to unpack and install the HCS Dolly are shown.



Note: The unpack and installation of the extra HCS Dolly is identical to that of the dolly that is shipped with the HCS (MAY / 450S03138).

7.45.2 ① Unpack and ② assemble the extra HCS Dolly(ies) using the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964).



7.46.0 Relocation - HCS Dolly

7.46.1 ① If relocation is within the same building,
② move the HCS dolly(ies) to the new install location
by rolling them to the location.

7.46.2 ① If relocation is to another building,
② refer to 7.39.0 "Return - Preparing the HCS for
the Move (if present)" on page 7-73 for preparing
any extra HCS Dolly(ies) that are present.

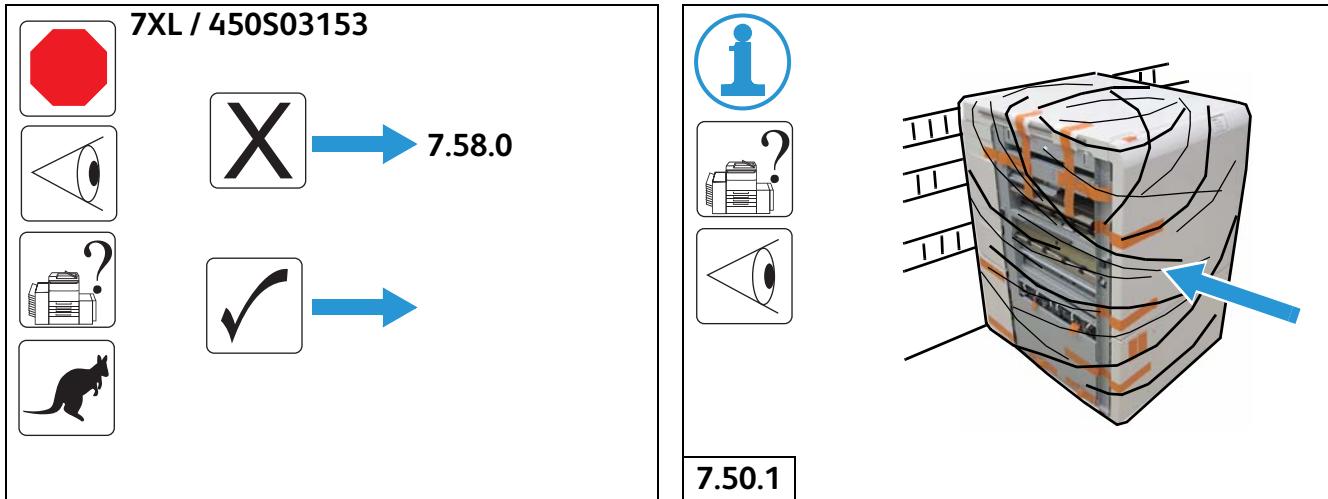
7.47.0 Returning - HCS Dolly

 Stop: Perform all steps in 7.39.0 "Return - Preparing the HCS for the Move (if present)" on page 7-73, except for "Reinstalling the HCS" on page 7-74.

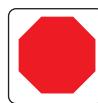
7.48.0 Returning HCS Additional Dolly



Stop: Perform all steps in 7.39.0 "Return - Preparing the HCS for the Move (if present)" on page 7-73, except for "Reinstalling the HCS" on page 7-74.



7.49.0 Accessory G: Delivery - Depalletize, Unpack, and Install the Crease and Two-sided Trimmer (7XL / 450S03153) (if present)

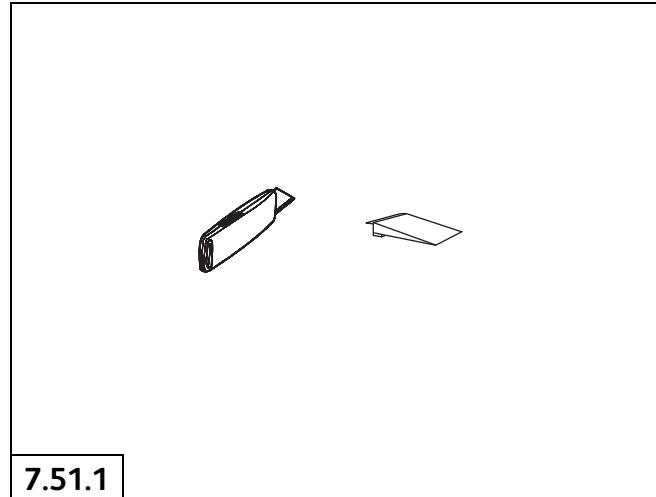
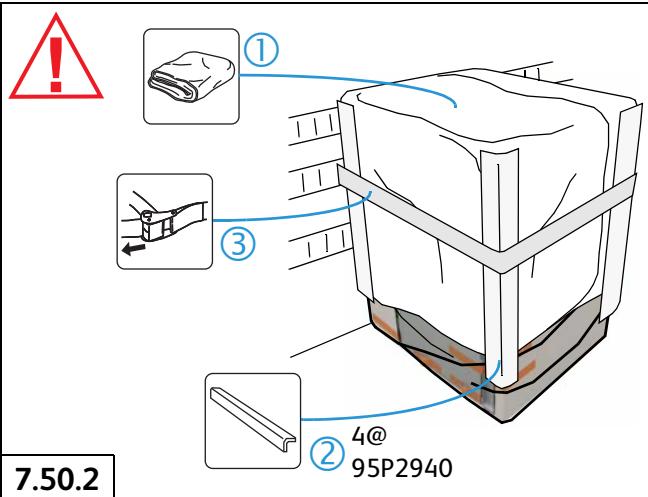
 Stop: If a Crease and Two-sided Trimmer is not present, go to 7.58.0 "Accessory H: Delivery - Depalletize, Unpack, and Install the CZ Folder (2AE / 450S03139) (if present)" on page 7-91. If a Crease and Two-sided Trimmer is present, continue onto the next step.

7.50.0 Strapping the Crease and Two-sided Trimmer



Note: When positioning the Crease and Two-sided Trimmer in the truck, ensure the rear of the module is positioned against the wall.

7.50.1 If a Crease and Two-sided Trimmer is present, position the rear of the module against the wall of the truck.



CAUTION: When securing the Crease and Two-sided Trimmer in the truck, ensure to avoid excess tension while strapping.

7.50.2 ① Cover the Crease and Two-sided Trimmer with a folded blanket, ② position corner-boards on each of the corners and ③ strap the module in the truck.

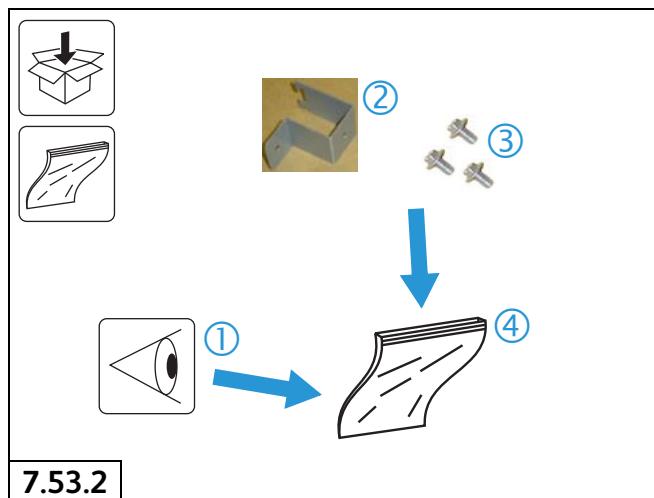
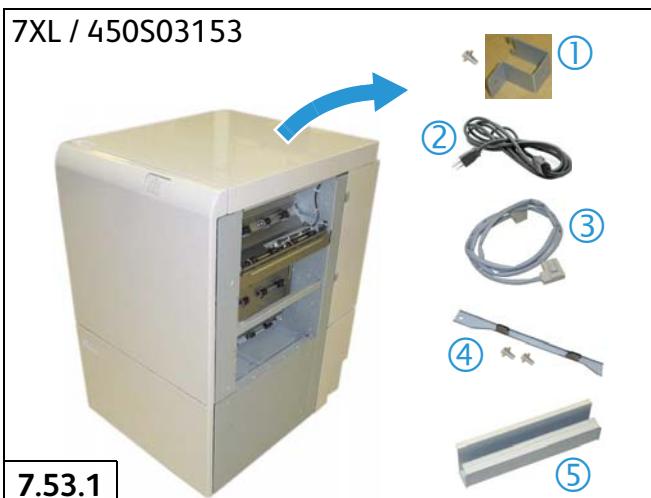
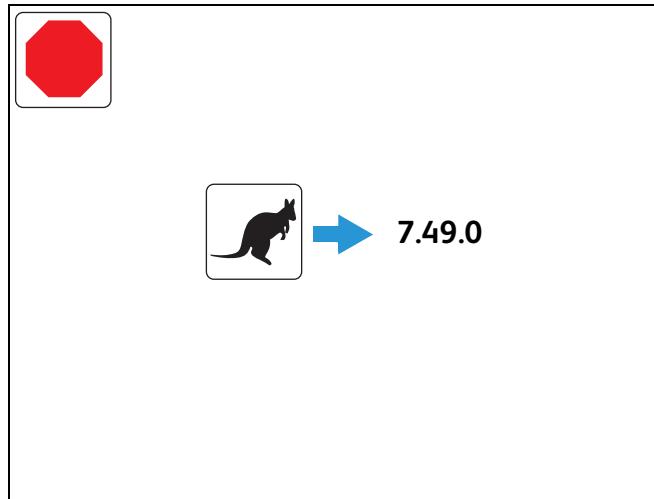
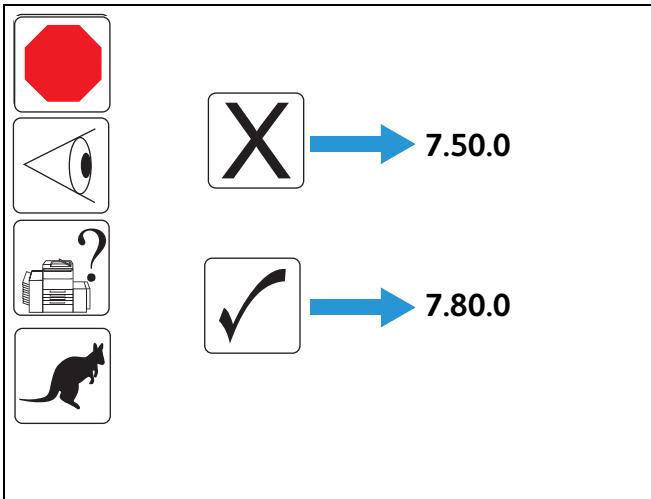
7.51.0 Unpack and Install the Crease and Two-sided Trimmer (if present)

7.51.1 The tools required to unpack and install the Crease and Two-sided Trimmer are shown.



Note: Installation of this module includes docking and making all electrical connections.

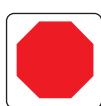
7.51.2 ① Depalletize, ② unpack, and ③ install the Crease and Two-sided Trimmer (if present), ④ using the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and ⑤ Production Ready Finishing Docking and Connection Guide (702P06434)



7.52.0 Strapping the Crease and Two-sided Trimmer



Stop: Perform all the steps in 7.50.0 "Strapping the Crease and Two-sided Trimmer" on page 7-81.

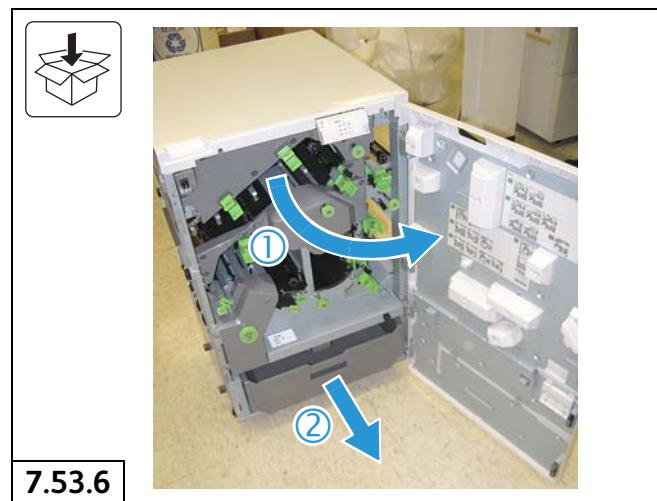
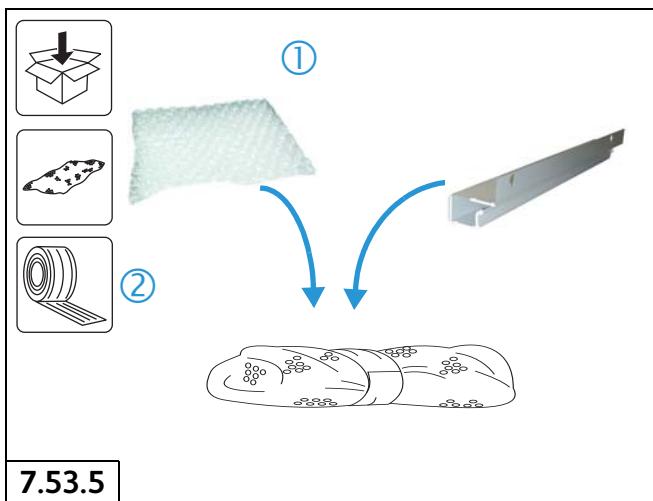
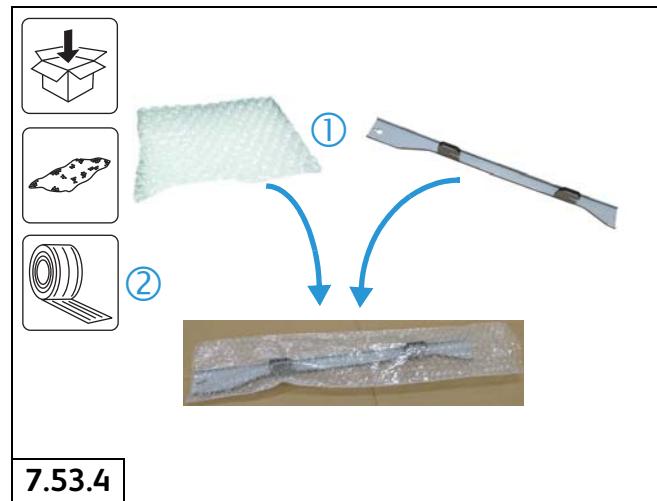
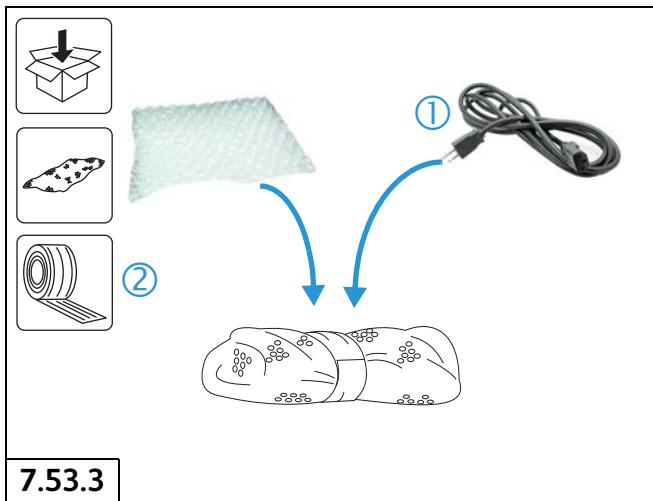


Stop: If there are additional finishing accessories, go to 7.49.0 "Accessory G: Delivery - Depalletize, Unpack, and Install the Crease and Two-sided Trimmer (7XL / 450S03153) (if present)" on page 7-81, if not, go to 7.80.0 "Accessory K: Delivery - Preparing the EFI™ Standalone NX Premium DFE (2A8/097N02291)" on page 7-128.

7.53.0 Repack - Preparing the Crease and Two-sided Trimmer for the Move

7.53.1 ① Remove the protector and screw, ② coiled power cord, ③ coiled interface cable, ④ docking bracket and screws and ⑤ cable channel on top of the HCS.

7.53.2 ① Retrieve a small plastic bag, ② place the power cord protector and ③ screws (3) in the bag. ④ Close the bag.

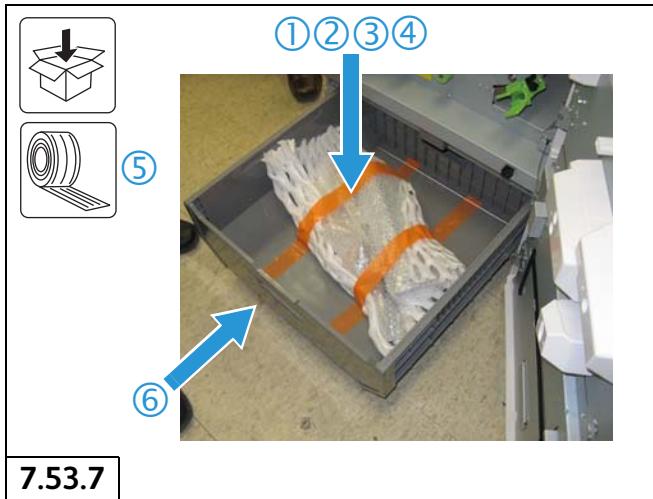


7.53.3 ① Wrap the coiled power cord in a layer of bubblepack and ② secure with tape.

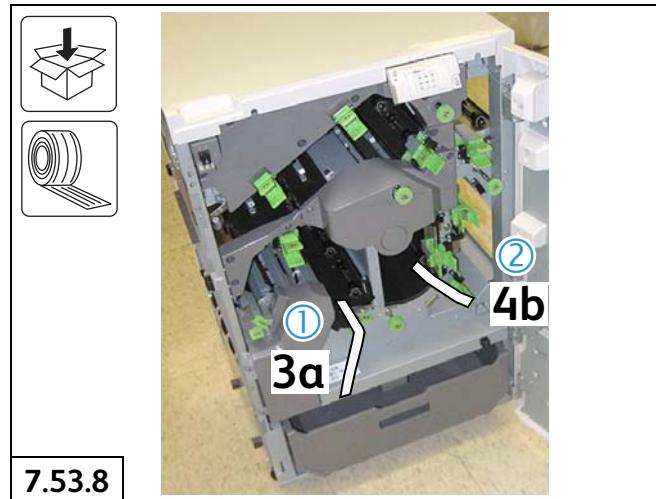
7.53.4 ① Wrap the docking bracket in a layer of bubblepack and ② secure with tape.

7.53.5 ① Wrap the cable channel in a layer of bubblepack and ② secure with tape.

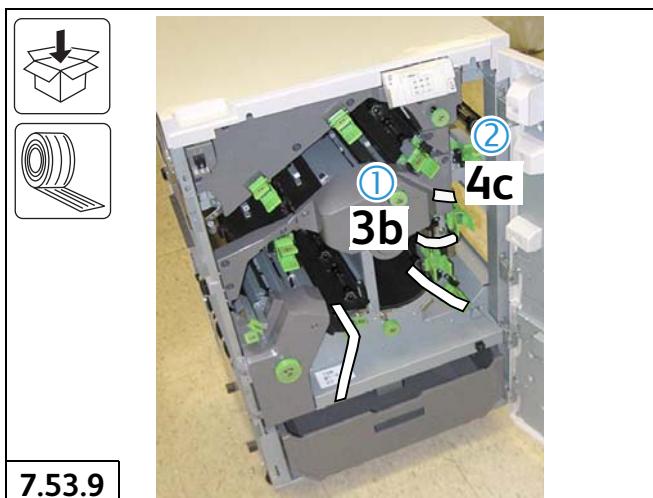
7.53.6 ① Open the front cover of the Crease and Two-sided Trimmer and ② open the bottom drawer.



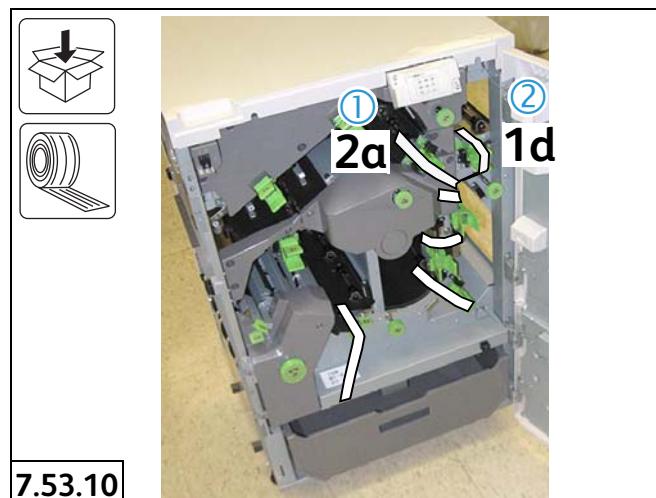
7.53.7



7.53.8



7.53.9



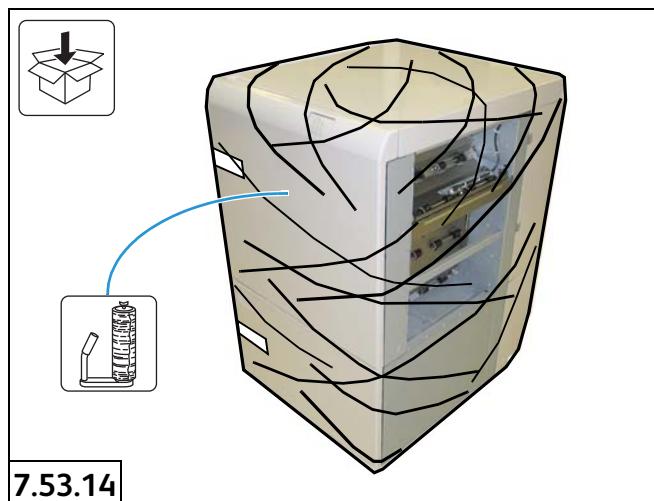
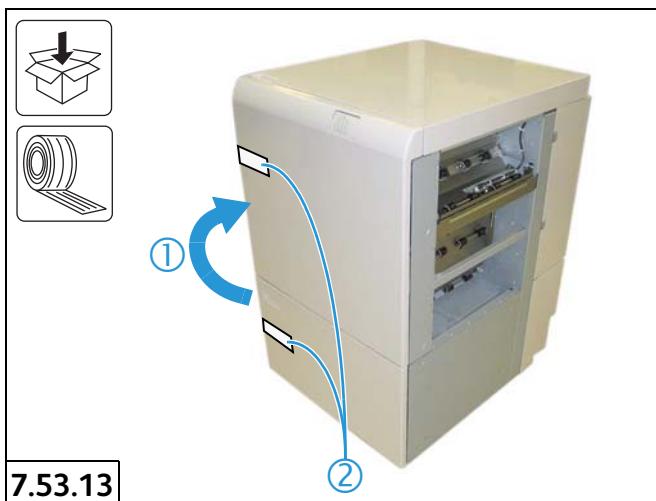
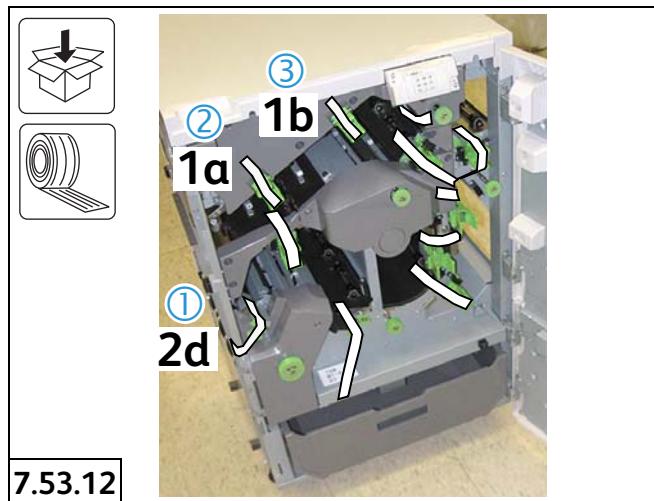
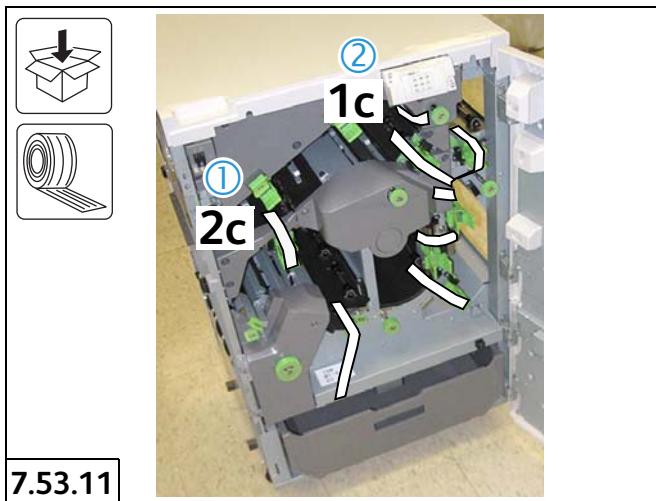
7.53.10

7.53.7 ① Place the bag of hardware, ② packed cables ③ packed docking bracket and ④ packed cable channel within the drawer. ⑤ Secure all items within the drawer with tape. ⑥ Close the bottom drawer.

7.53.8 ① Secure baffles '3a' and ② '4b' with tape.

7.53.9 ① Secure baffles '3b' and ② '4c' with tape.

7.53.10 ① Secure baffles '2a' and ② '1d' with tape.

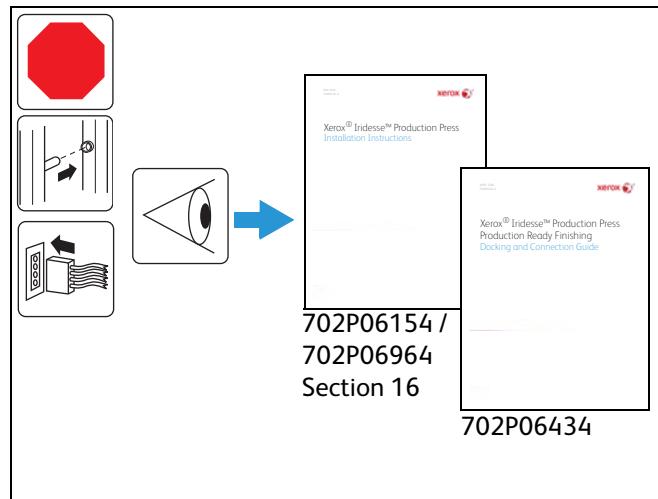
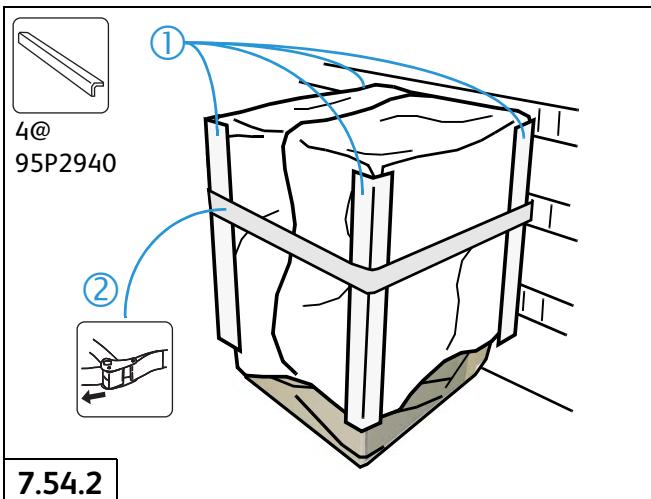
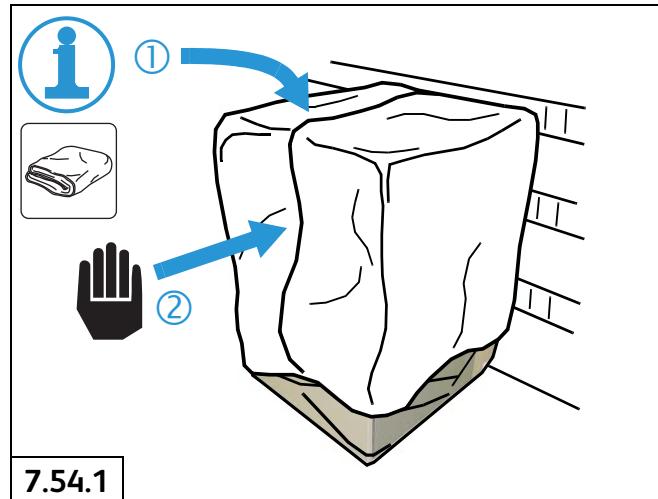
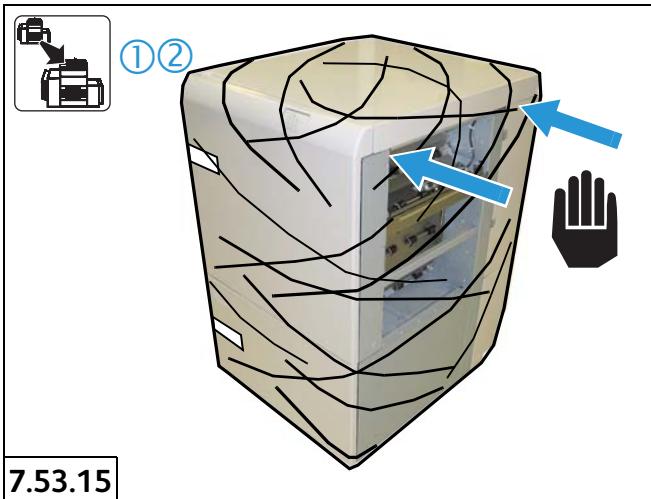


7.53.11 ① Secure baffles '2c' and ② '1c' with tape.

7.53.12 ① Secure baffles '2d', ② '1a' and ③ '1b' with tape.

7.53.13 ① Close the front cover of the Trimmer and ② secure with tape.

7.53.14 Secure the module with a layer of stretchwrap.



7.53.15 ① Move the prepared module to the new location or ② to the truck.

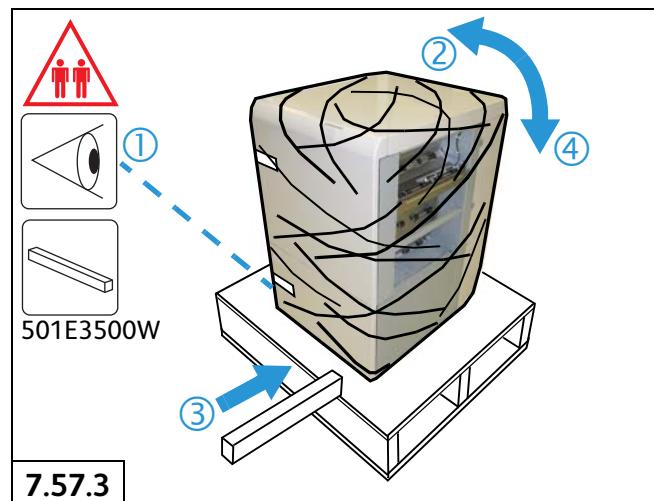
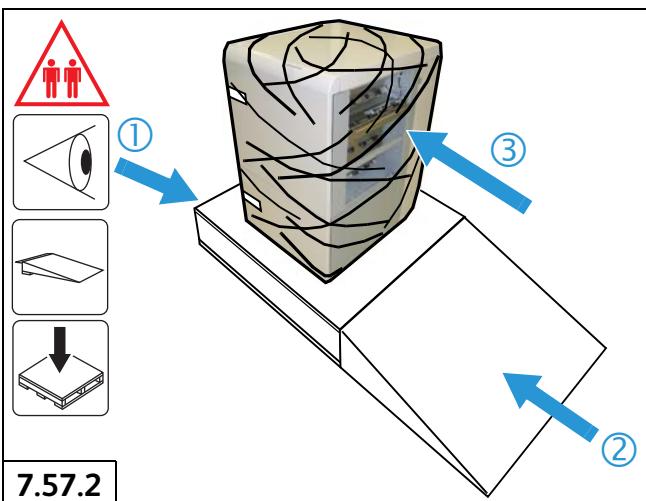
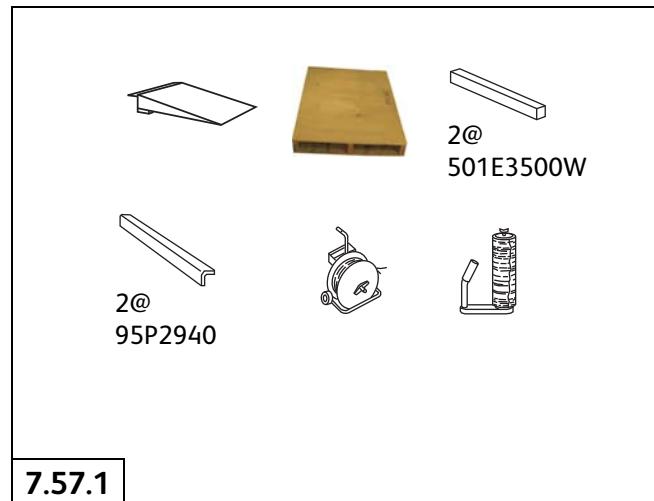
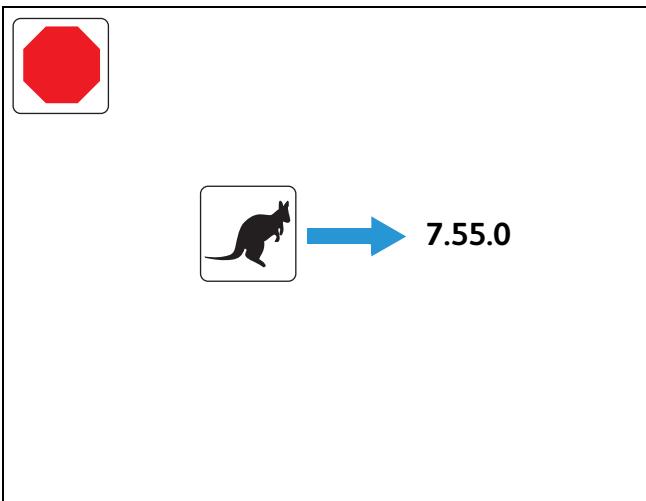
7.54.0 Strapping the Two-side Trimmer in the Truck



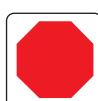
Note: When the Two-side Trimmer is strapped in the truck, ensure to position the rear side of the module against the wall of the truck.

7.54.1 ① Cover the Two-side Trimmer with a blanket and ② position the module against the wall of the truck.

7.54.2 ① Position a cornerboard on each of the corners (4) and ② strap the Trimmer into the truck.



7.56.0 Removal - Preparing the Crease and Two-sided Trimmer for the Move



Stop: Perform all the steps in 7.53.0

"Repack - Preparing the Crease and Two-sided Trimmer for the Move" on page 7-83, except for 7.55.0 "Reinstalling the Crease and Two-sided Trimmer" on page 7-87.

7.57.0 Palletize the Crease and Two-sided Trimmer

7.57.1 The tool and materials required to palletize the Crease and Two-sided Trimmer are shown.



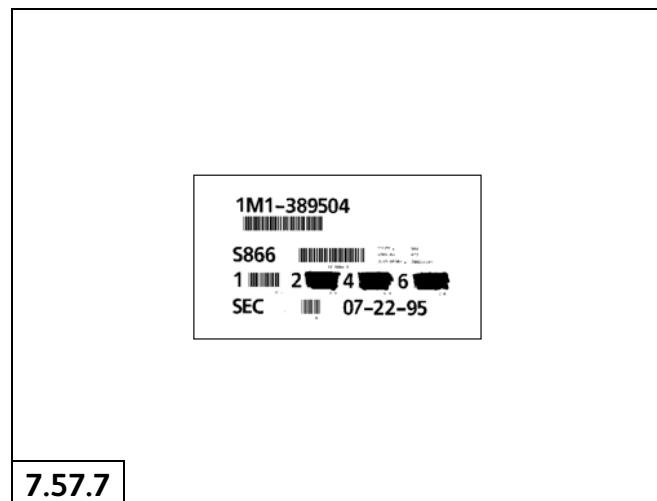
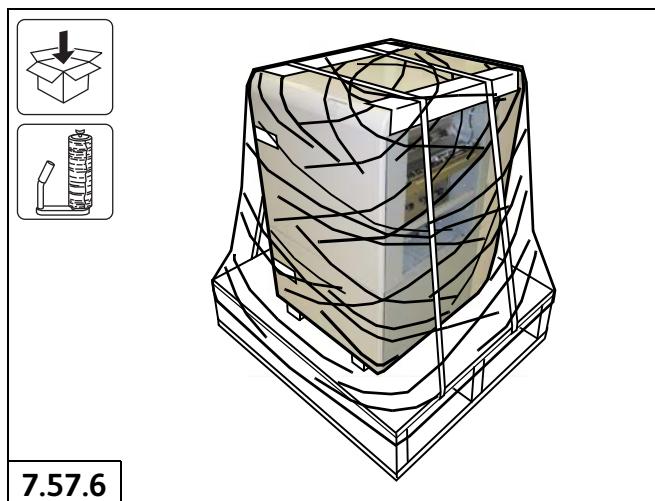
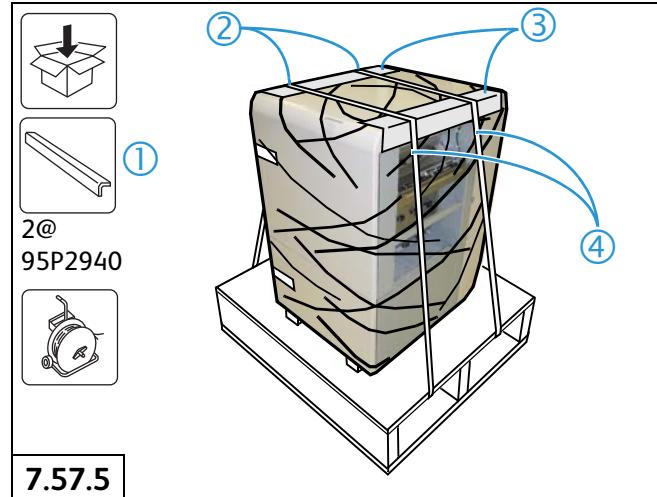
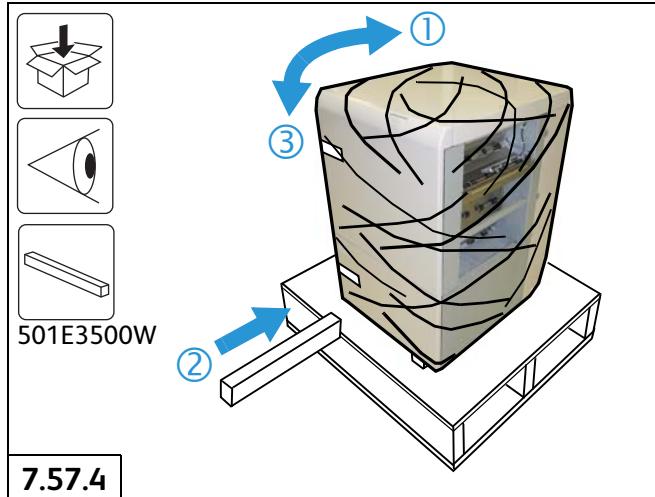
WARNING: Due to the size and weight of the Trimmer, two people are required to palletize the module.

7.57.2 ① Retrieve a pallet similar in size and ② position a ramp alongside the pallet. Using two people, ③ palletize the Trimmer.



WARNING: Due to the size and weight of the Trimmer, two people are required to position the blocks under the module.

7.57.3 ① Position the Trimmer accordingly on the pallet. ② Lift one side of the Trimmer and ③ position a wood block (501E3500W) under the module just inside the casters. ④ Lower the Trimmer onto the block.

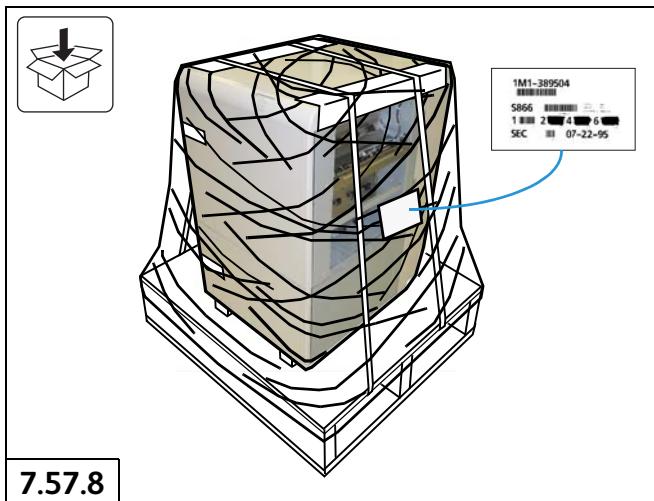


7.57.4 ① Lift the other side of the Trimmer and ② position a second wood block (501E3500W) under the module just inside the casters. ③ Lower the Trimmer onto the block.

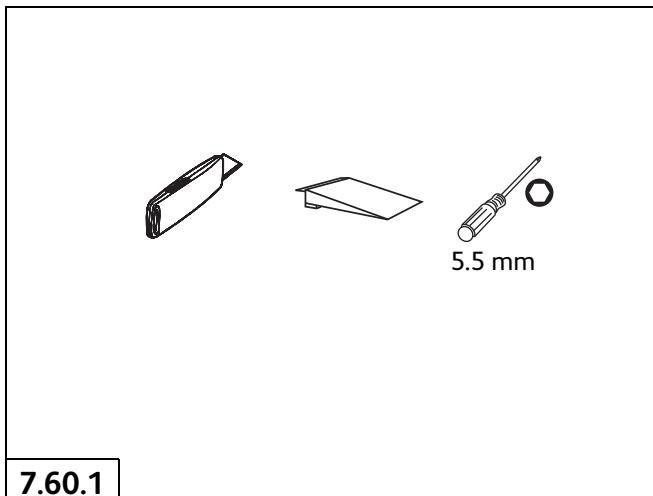
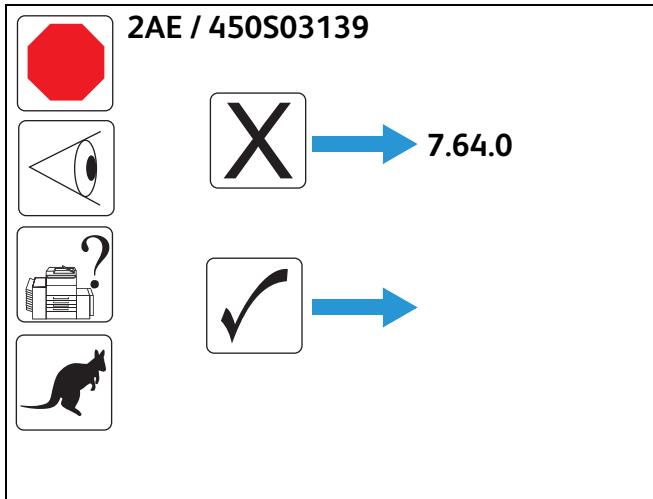
7.57.5 ① Retrieve two cornerboards and ② place one on the top left and ③ right edges of the module. ④ Secure the Finisher to the pallet with positioning the bands over the cornerboards.

7.57.6 Secure the Finisher with a layer of stretchwrap.

7.57.7 Generate Bar Code label, cross of non-applicable codes.



7.57.8 Attach Bar Code label to the stretchwrap on the open end of the pallet.



7.58.0 Accessory H: Delivery - Depalletize, Unpack, and Install the CZ Folder (2AE / 450S03139) (if present)

Stop: If a CZ Folder is not present, go to 7.64.0 "Accessory I: Delivery - Depalletize, Unpack and Position Production Ready Finisher (3AE/097S04749, 4AE/097S04750, 5AE/097S04751) (if present)" on page 7-101. If a CZ Folder is present, continue onto the next step.

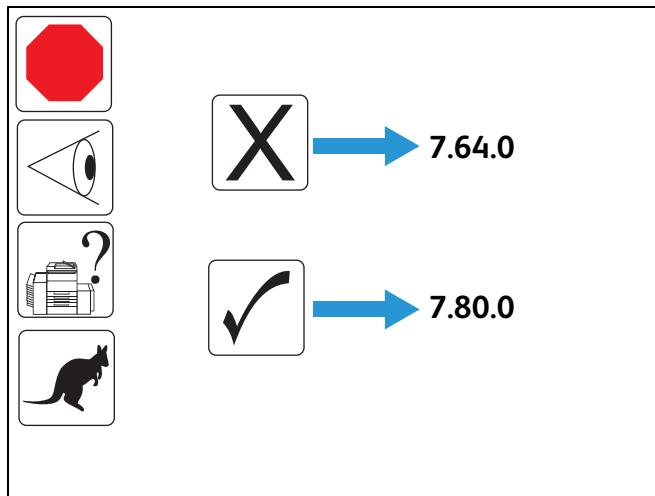
7.59.0 Strapping the CZ Folder

CAUTION: When securing the CZ Folder in the truck, ensure to avoid excess tension while strapping.

7.59.1 ① If a CZ Folder is present, ② using a pallet jack or ③ forklift, ④ place the packaged module against the wall of the truck for transport to the Customer location.

7.60.0 Unpacking and Installing the CZ Folder (if present)

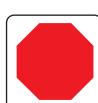
7.60.1 The tools required to unpack and install the CZ Folder are shown.



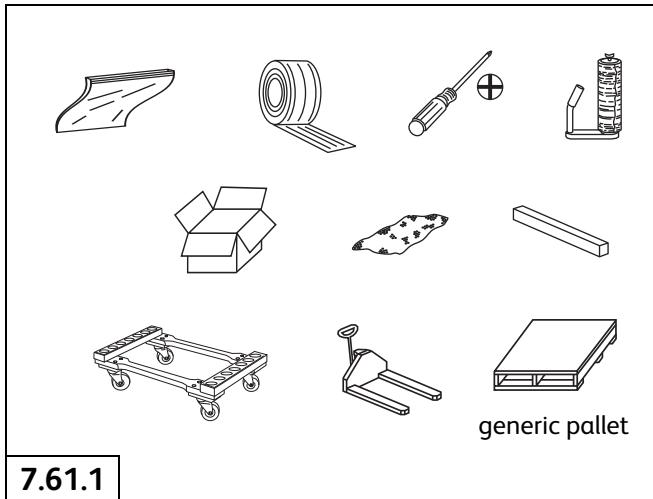
Note: Installation of this module includes docking and making all electrical connections.

on page 7-101. If not, go to 7.80.0 "Accessory K: Delivery - Preparing the EFI™ Standalone NX Premium DFE (2A8/097N02291)" on page 7-128.

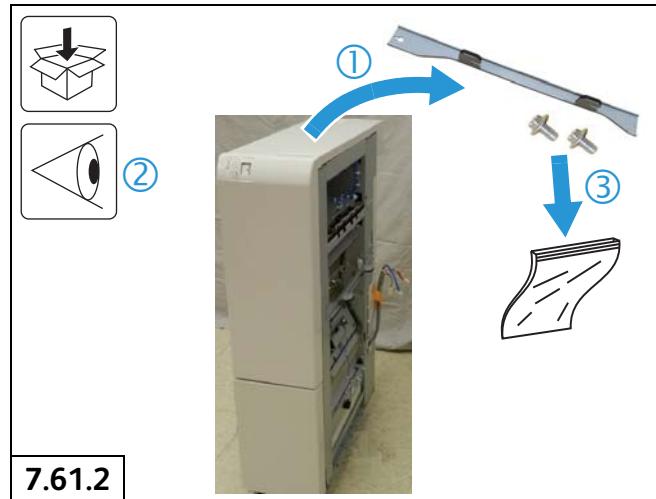
7.60.2 ① Depalletize, ② unpack and ③ install the CZ Folder (if present), ④ using the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and the ⑤ Production Ready Finishing Docking and Connection Guide (702P06434).



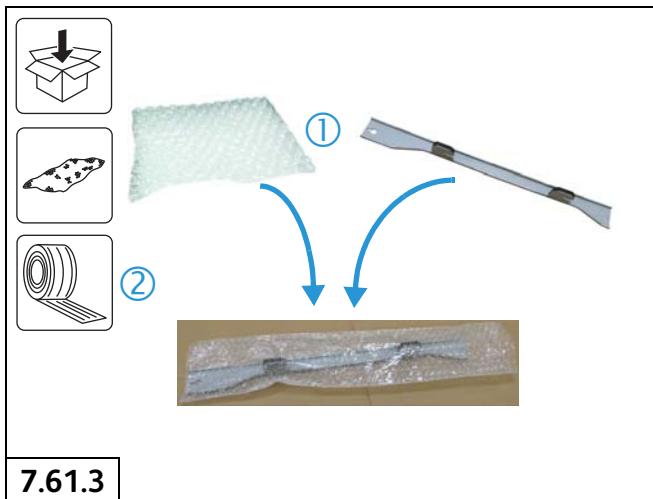
Stop: If there are additional finishing accessories, go to 7.64.0 "Accessory I: Delivery - Depalletize, Unpack and Position Production Ready Finisher (3AE/097S04749, 4AE/097S04750, 5AE/097S04751) (if present)"



7.61.1



7.61.2



7.61.3



7.61.4

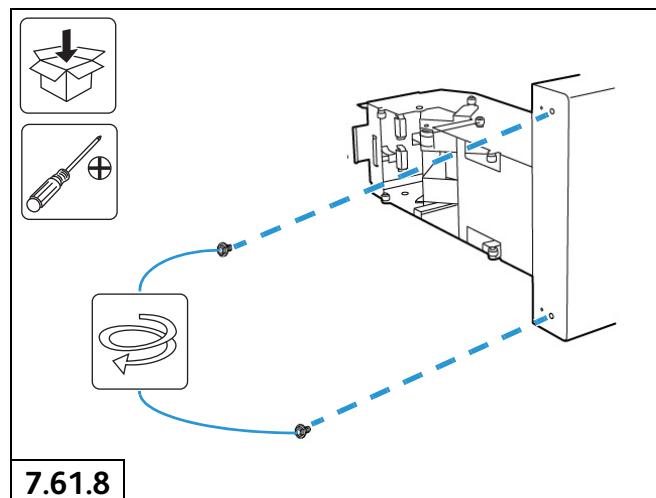
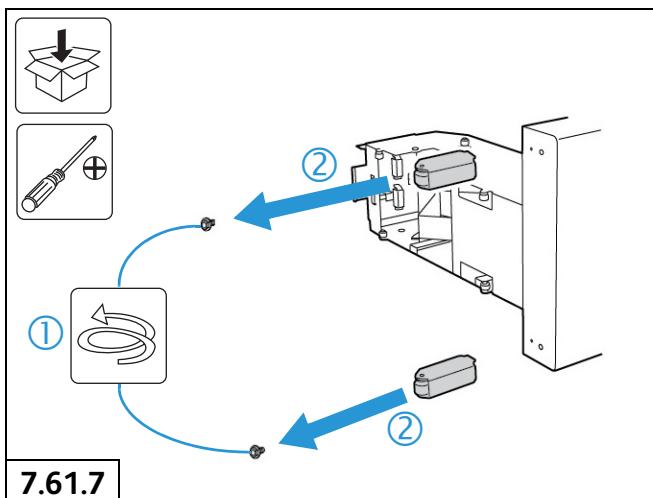
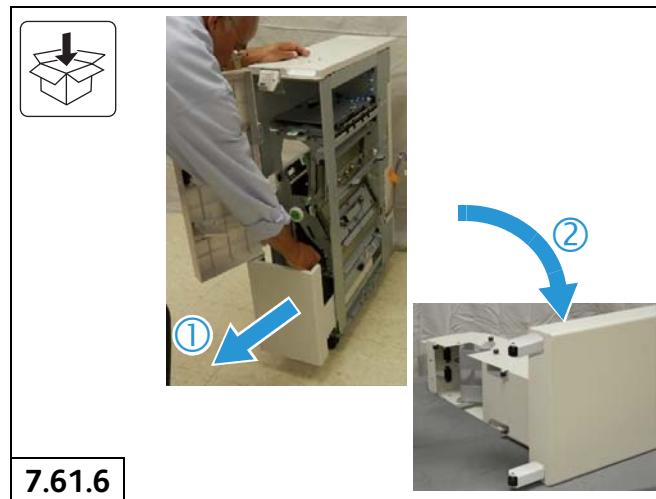
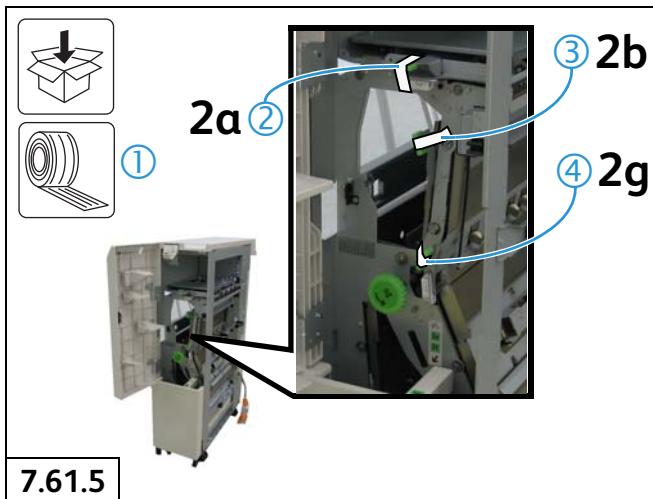
7.61.0 Relocation - Preparing the CZ Folder for the move.

7.61.1 The tools and materials used for relocating the CZ Folder are shown.

7.61.2 ① Remove the docking bracket and screws from the top of the CZ Folder. ② Retrieve a small plastic bag and ③ place the screws in the bag.

7.61.3 ① Wrap the docking bracket in a layer of bubblepack and ② secure with tape.

7.61.4 Open the top front door of the CZ Folder module.

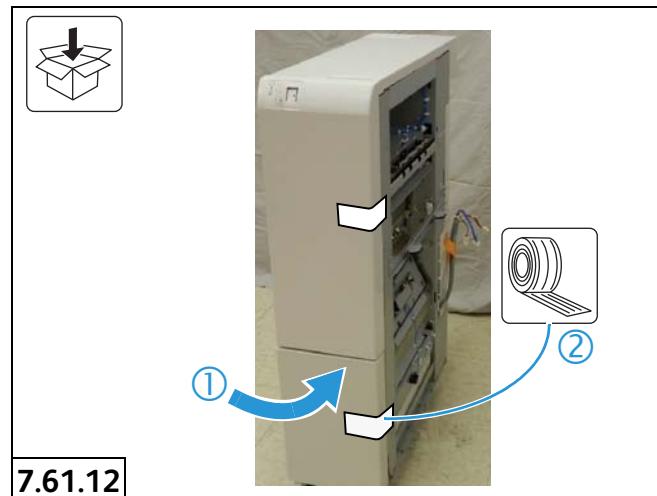
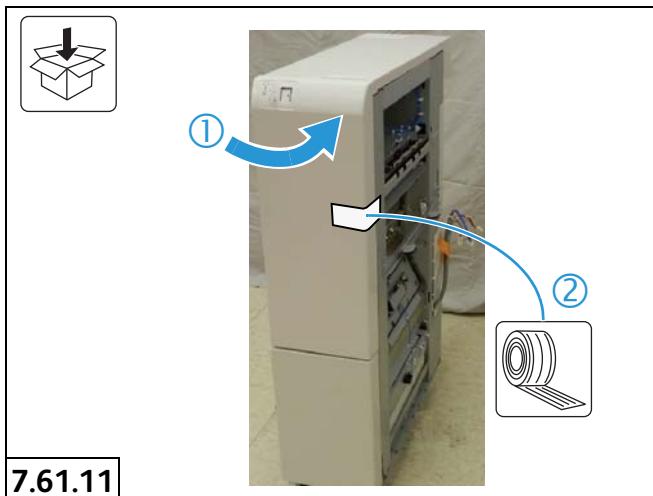
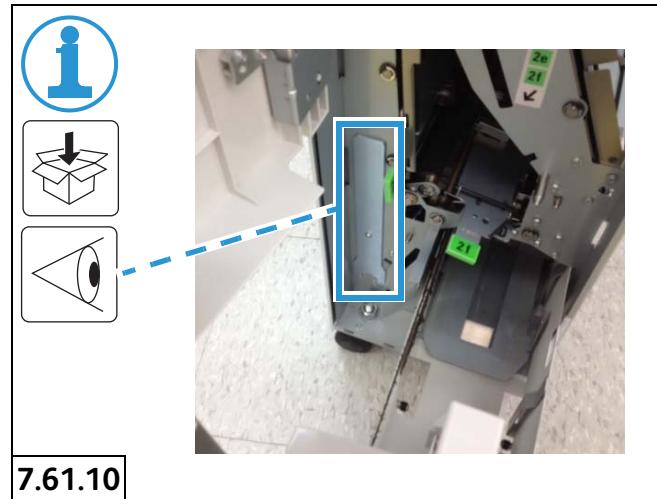
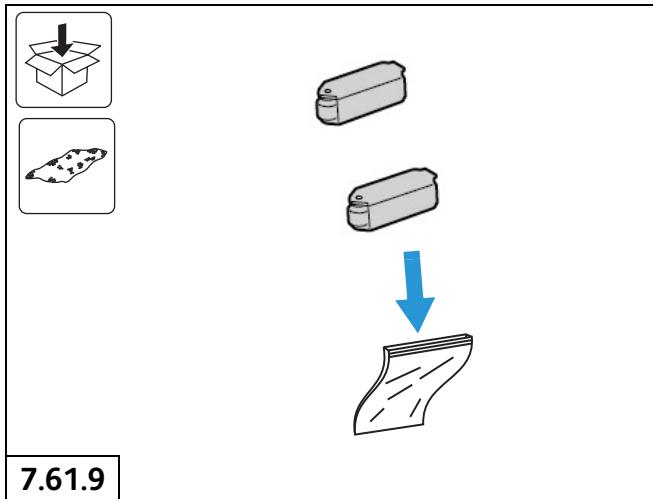


7.61.5 ① Use tape to secure baffle handles ② 2a, ③ 2b, and ④ 2g.

7.61.6 ① Remove the front output tray from the CZ Folder and ② lay it on its side.

7.61.7 Using a screwdriver, ① remove the screws (2 - 1 per) holding on the CZ Folder output tray support wheels, then ② remove the support wheel assemblies (2).

7.61.8 Reinstall the screws (2) back into the bottom of the output tray.



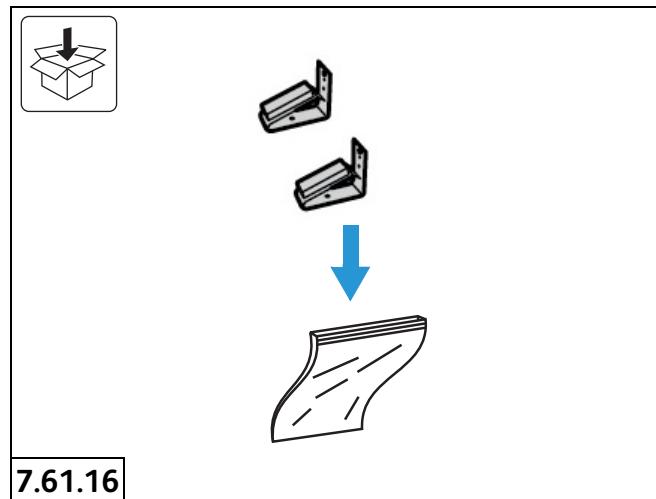
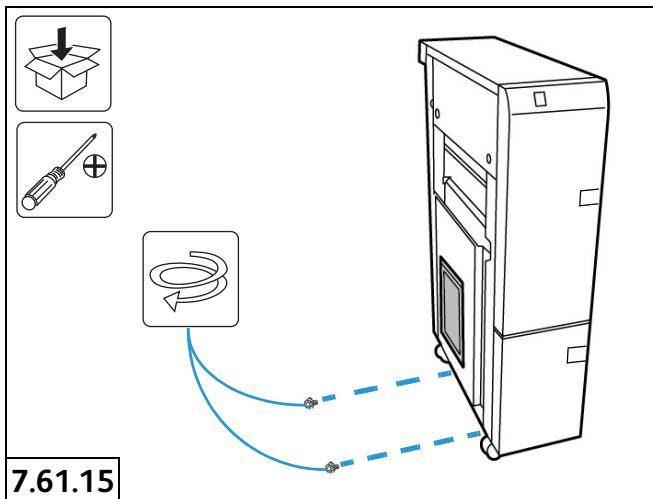
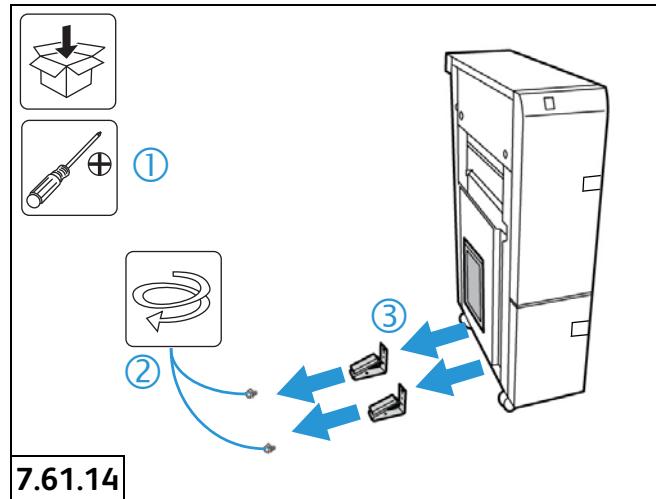
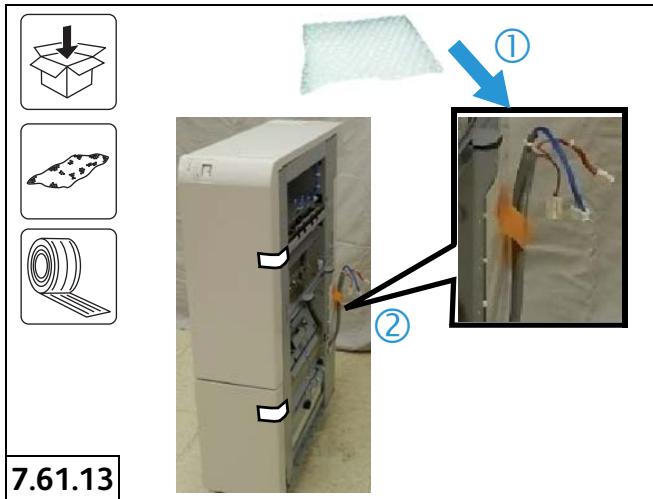
7.61.9 Place the two support wheel assemblies into the plastic bag with the other hardware.



Note: If leveling wrench is not attached to the inside of the CZ Folder, Carrier needs to find and reinstall it into the front of the module.

7.61.10 Check to ensure that the CZ Folder leveling wrench is attached to the inside of the CZ Folder module.

7.61.11 ① Close the top front door of the CZ Folder, then ② secure with tape.

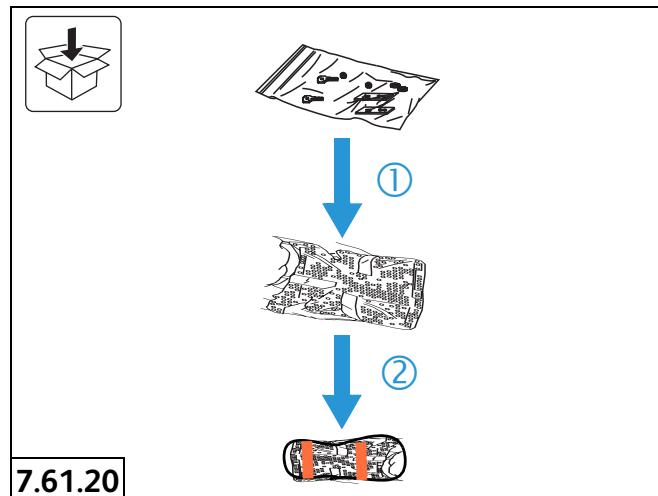
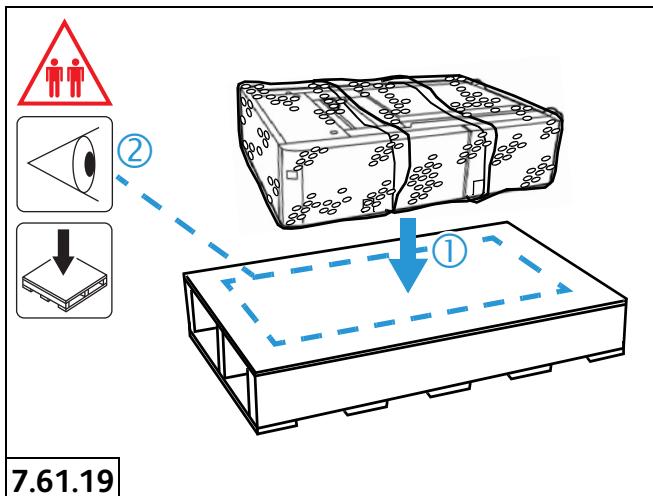
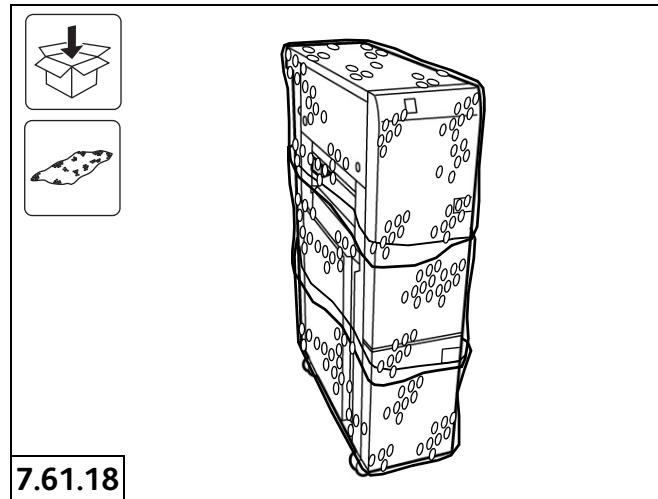
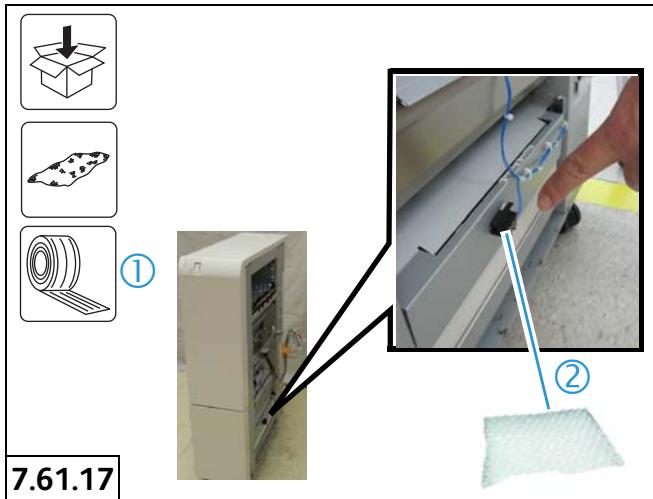


7.61.13 ① Wrap the communications cable wire harnesses on the right side of the CZ Folder in bubblepack, then ② tape it to the right side of the module.

7.61.14 ① Use a screwdriver to ② remove the two screws holding the grounding pads onto the bottom left side of the CZ Folder module. Then ③ pull the grounding pads off the module.

7.61.15 Reinstall the two screws back into their original holes in the CZ Folder module

7.61.16 Place the two grounding pads into the plastic bag with the rest of the CZ Folder module hardware.



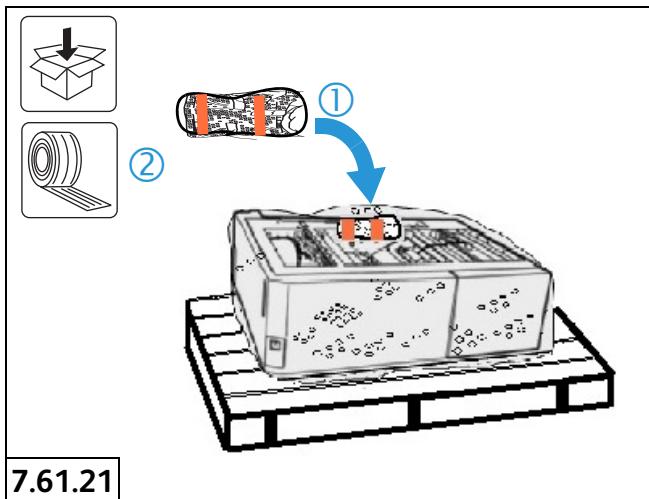
7.61.17 ① Tape a piece of folded bubblepack over the ② sensor on the bottom right side of the CZ Folder frame.

7.61.18 Wrap the CZ Folder module in bubblepack.

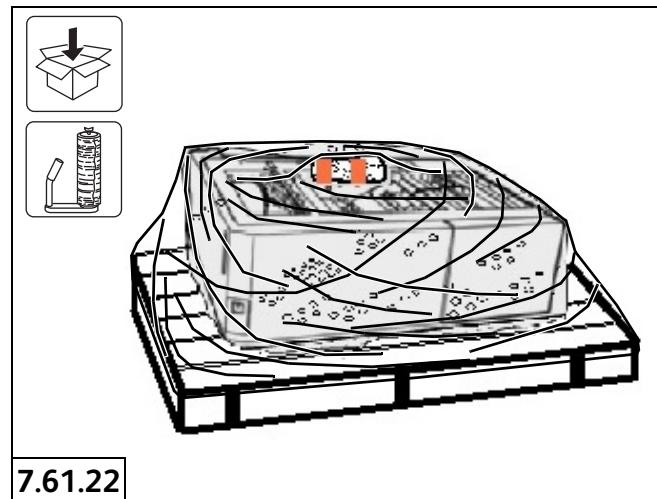


WARNING: Due to the weight and size of the CZ Folder module, two people are required to lift the module onto the pallet.

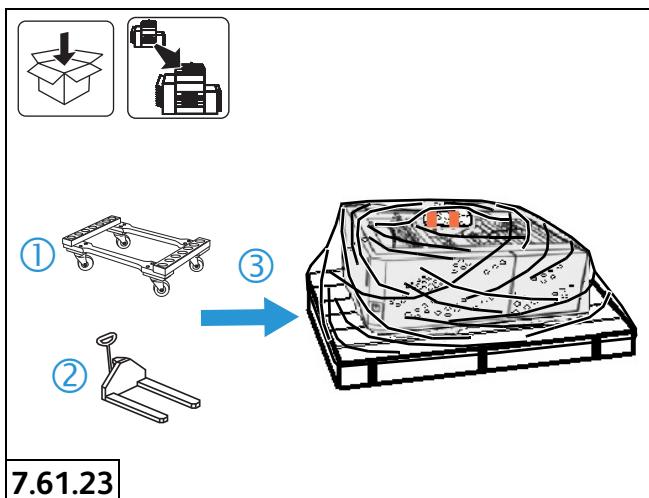
7.61.19 ① Lay the bubblepacked CZ Folder module on its left side on the deck of the pallet.
② Center the module on the pallet.



7.61.21



7.61.22



7.61.23

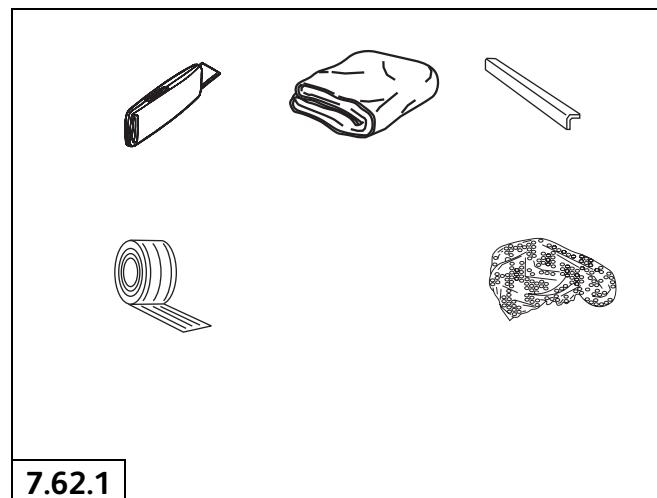
7.61.21 ① Place the bundled hardware on the top of the CZ Folder and ② secure in place with tape.

7.61.22 Secure the CZ Folder module to the pallet with a layer of stretchwrap the.

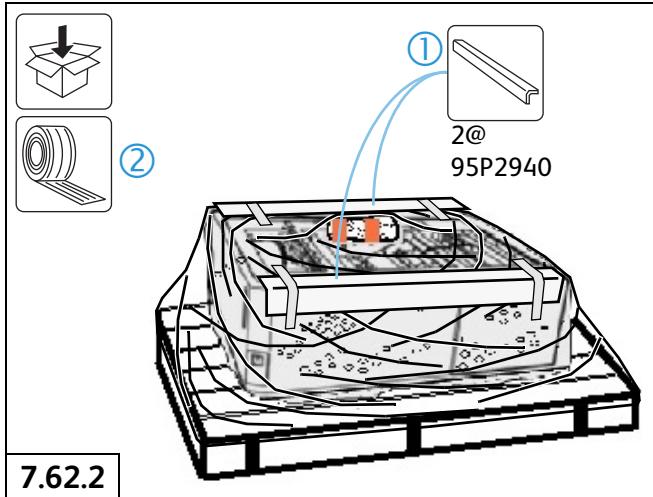
7.61.23 Use a ① dolly or a ② pallet jack to ③ move the CZ Folder module to the truck.

7.62.0 Preparing the CZ Folder Module for Returning

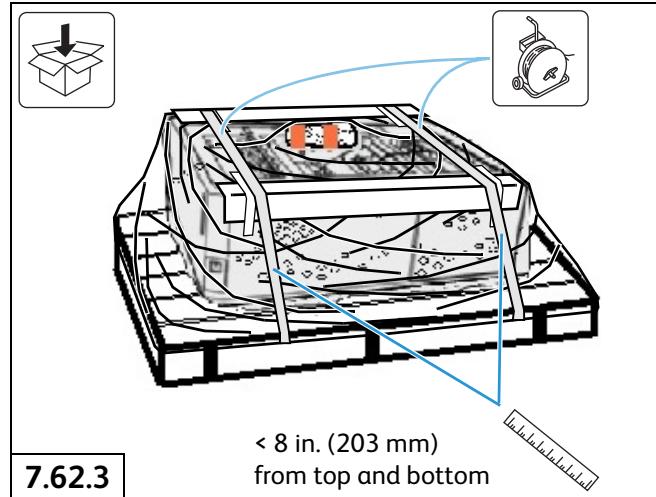
7.62.1 The tool and materials required to return the CZ Folder module are shown.



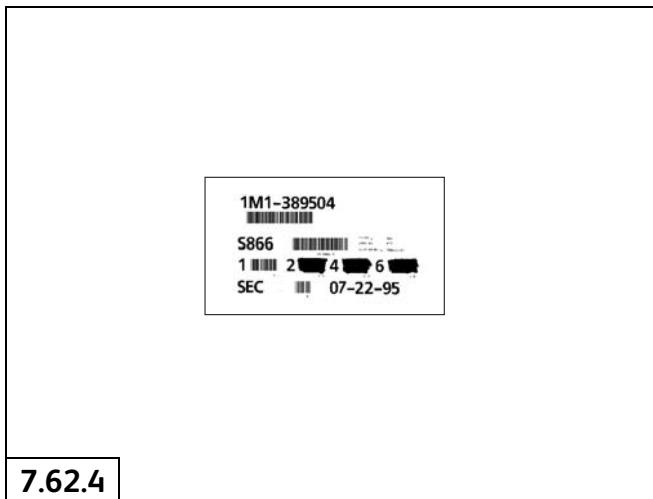
7.62.1



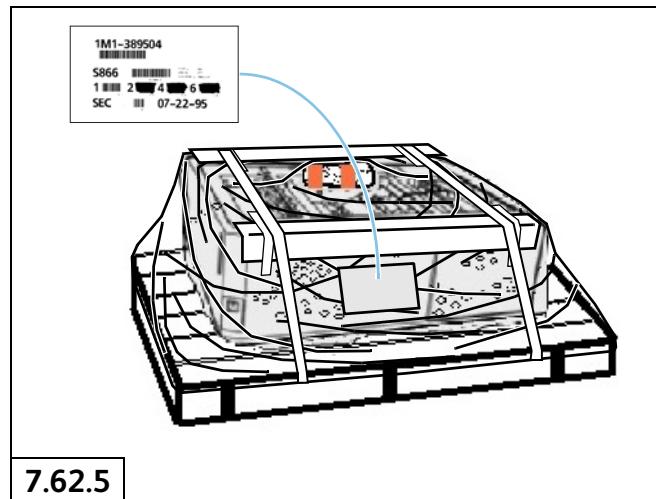
7.62.2



7.62.3



7.62.4



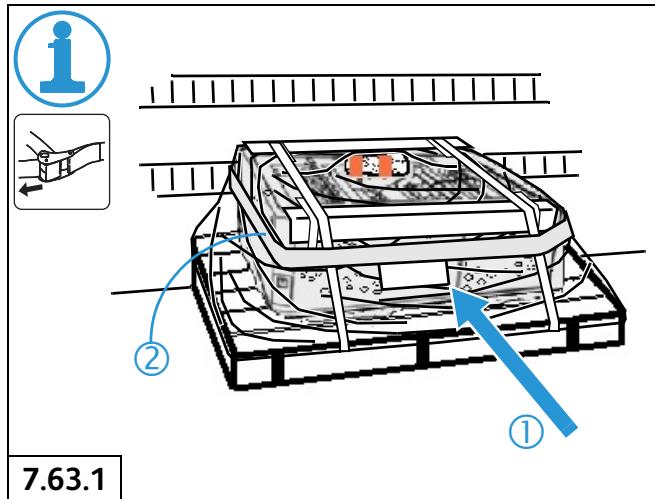
7.62.5

7.62.2 ① Place two cornerboards over the front and rear edges of the CZ Folder. Then ② secure them in place with tape.

7.62.3 Band the CZ Folder module to the pallet using two bands placed no more than 8" from the top and bottom corners of the CZ Folder module.

7.62.4 Generate a bar code label, crossing off non-applicable codes.

7.62.5 Attach the bar code label to the stretchwrap at the open end of the pallet.



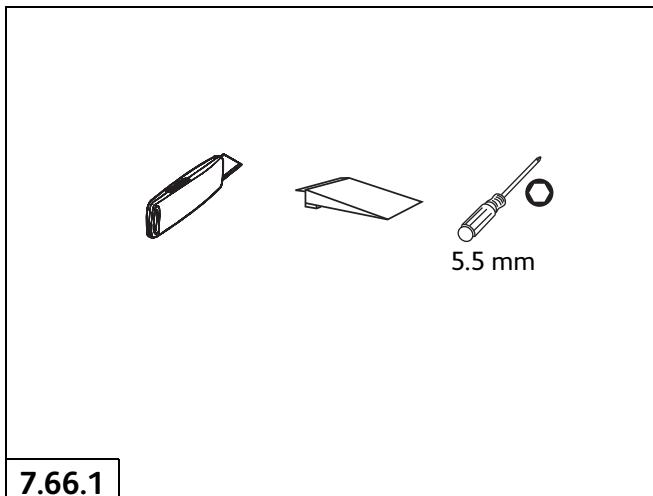
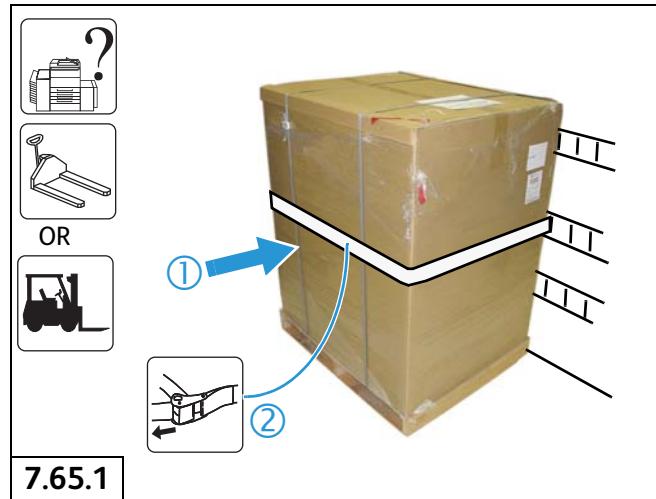
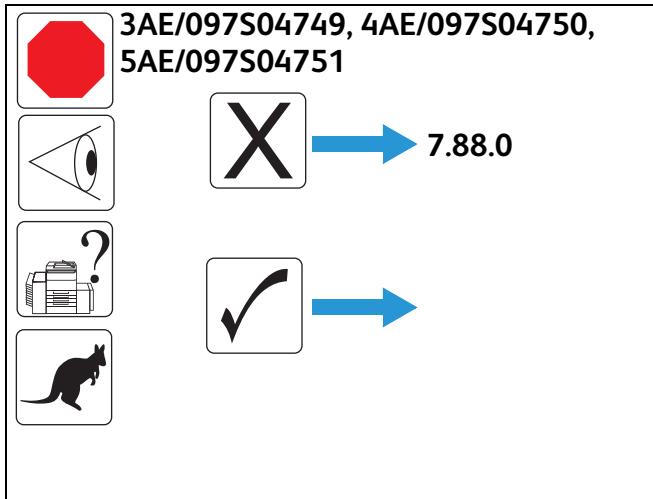
7.63.1

7.63.0 Strapping the CZ Folder



Note: Due to the low profile of the palletized CZ Folder, the strap may only be able to be positioned around the module loosely.

7.63.1 ① Position the palletized CZ Folder against the wall of the truck and ② strap into place.



7.64.0 Accessory I: Delivery - Depalletize, Unpack and Position Production Ready Finisher (3AE/097S04749, 4AE/097S04750, 5AE/097S04751) (if present)

Stop: If a Production Ready Finisher is not present, go to 7.88.0 "Accessory I: Delivery - Preparing the Partner Finishing Interface Module (PFIM) (XMH/097S04171) (if present)" on page 7-140. If a Production Ready Finisher is present, continue onto the next step.

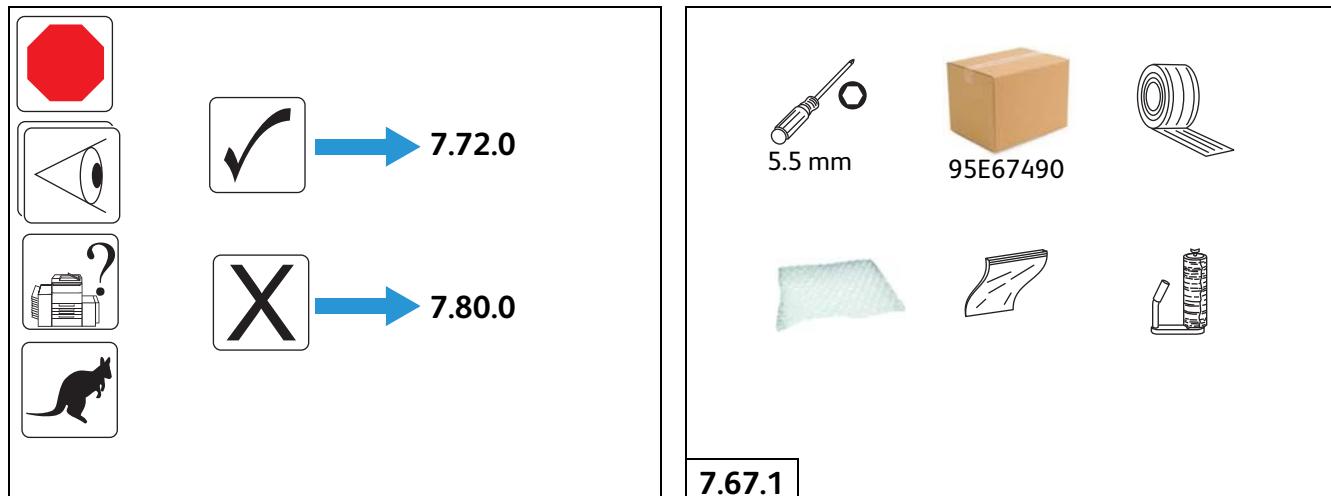
Stop: The Production Ready Finisher should be delivered to the Customer location on the pallet and fully packaged.

7.65.0 Strapping the Production Ready Finisher (if present)

7.65.1 ① Position the Production Ready Finisher against the wall of the truck and ② secure it in place with a single strap.

7.66.0 Unpack and Install the Production Ready Finisher (if present)

7.66.1 The tools required to unpack and install the Production Ready Finisher are shown.



Stop: The Carrier is responsible for unpacking, depalletizing, docking and connecting the module. CSE is responsible for getting the module up and running.

7.66.2 ① Depalletize, ② unpack and ③ position the Production Ready Finisher (3AE/097S04749, 4AE/097S04750, 5AE/097S04751) (if present), ④ using the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and ⑤ Production Ready Finishing Docking and Connection Guide (702P06434).

Stop: If there are additional finishing accessories, go to 7.72.0 "Accessory J: Depalletize, Unpack, and Install the Inte-

grated SquareFold® Trimmer (6AE/097N04752) (if present)" on page 7-118. If there are no additional finishing accessories, go to 7.80.0 "Accessory K: Delivery - Preparing the EFI™ Standalone NX Premium DFE (2A8/097N02291)" on page 7-128.

7.67.0 Relocation - Preparing the Production Ready Finisher for the Move

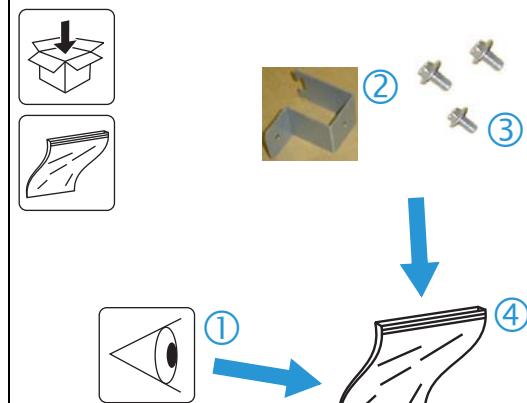
7.67.1 The tool and materials required to prepare the PR Finisher for the move are shown.



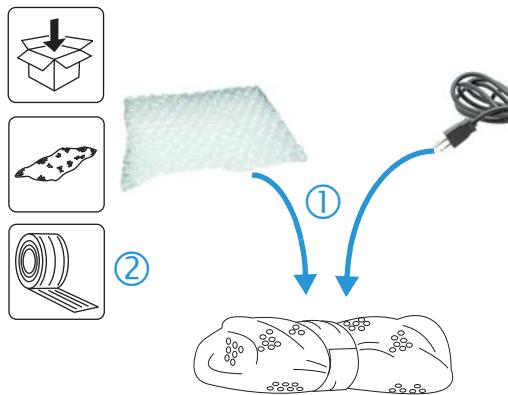
3AE/097S04749 / 4AE/097S04750 /
5AE/097S04751



7.67.2



7.67.3



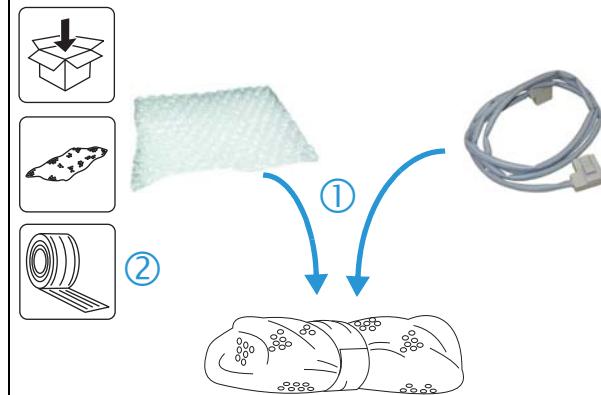
7.67.4

7.67.2 ① Remove the power cord protector and screw, ② power cord, ③ interface cable and docking bracket and screws (2) from the top of the PR Finisher.

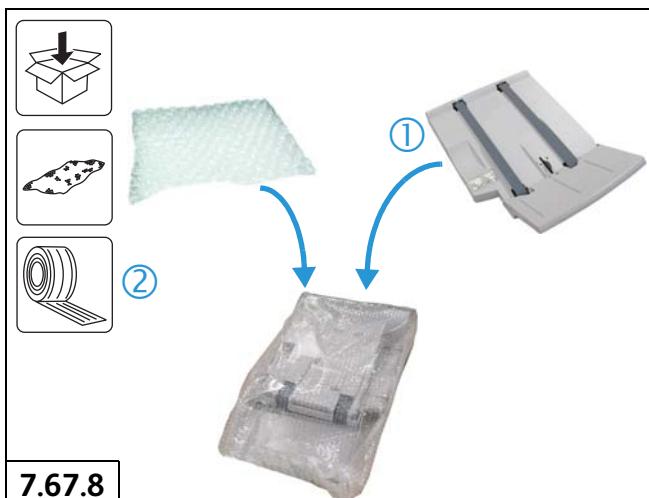
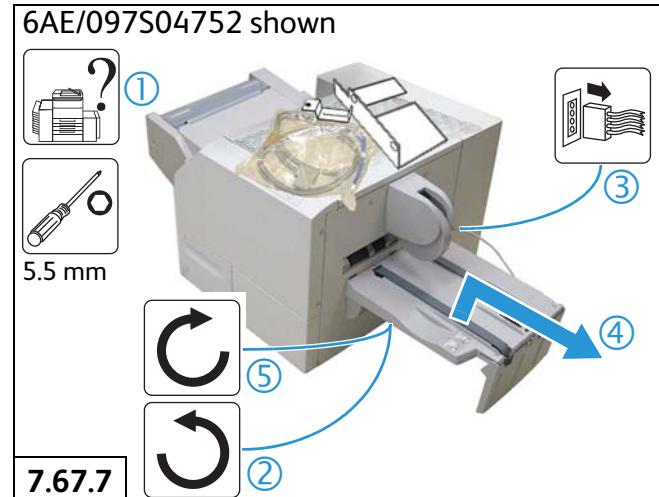
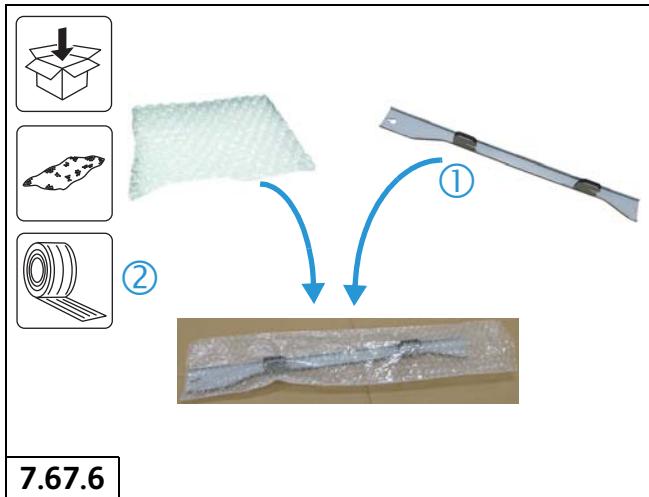
7.67.3 ① Retrieve a small plastic bag, ② place the power cord protector and ③ screws (3) in the bag.
④ Close the bag.

7.67.4 ① Wrap the coiled power cord in a layer of bubblepack and ② secure with tape.

7.67.5 ① Wrap the coiled interface cable in a layer of bubblepack and ② secure with tape.



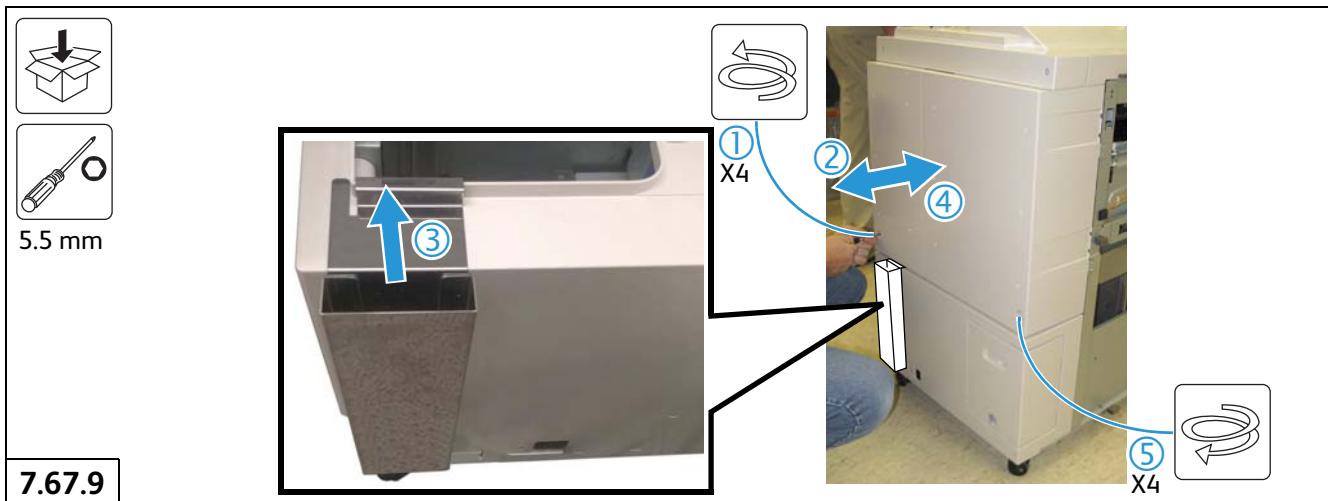
7.67.5



7.67.6 ① Wrap the docking bracket in a layer of bubblepack and ② secure with tape.

7.67.7 ① If a SquareFold Trimmer (6AE/097S04752) or just a PR Finisher (3AE/097S04749 / 4AE/097S04750 / 5AE/097S0475) is present, ② loosen the single screw under the Booklet Maker Tray, ③ disconnect interface cable and then ④ lift the tray up and off the right side of the SquareFold Trimmer or from within the right side bottom cavity of the PR Finisher. ⑤ Retighten the screw on the right side of the SquareFold Trimmer.

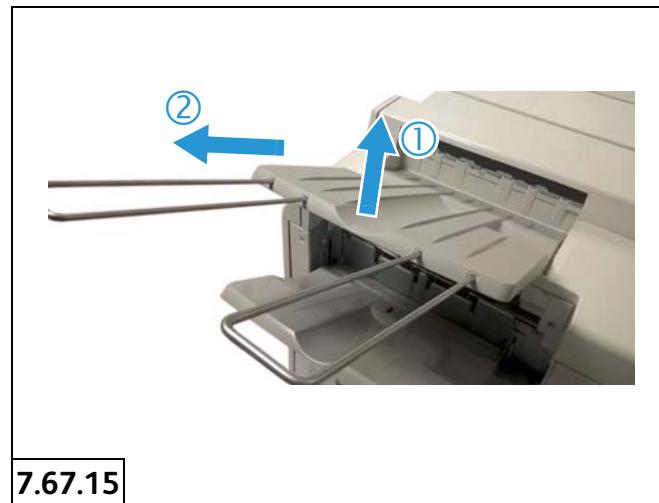
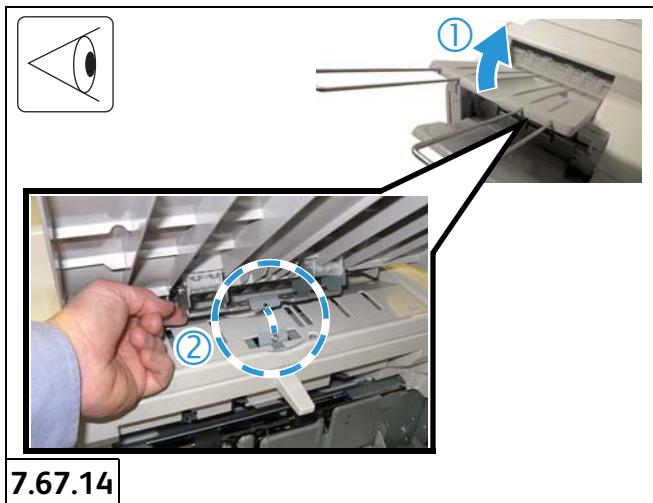
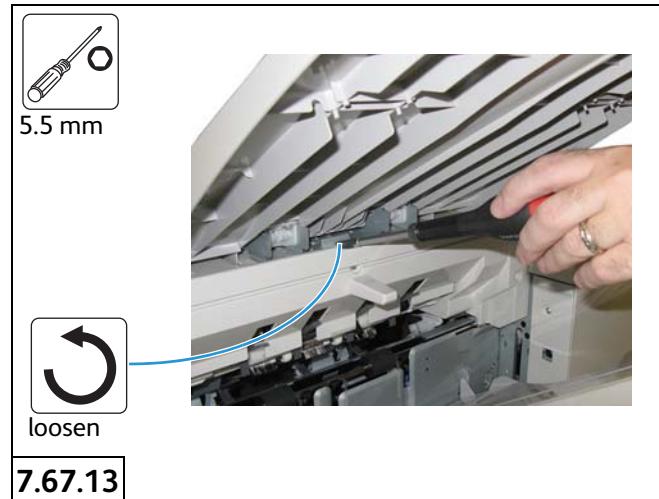
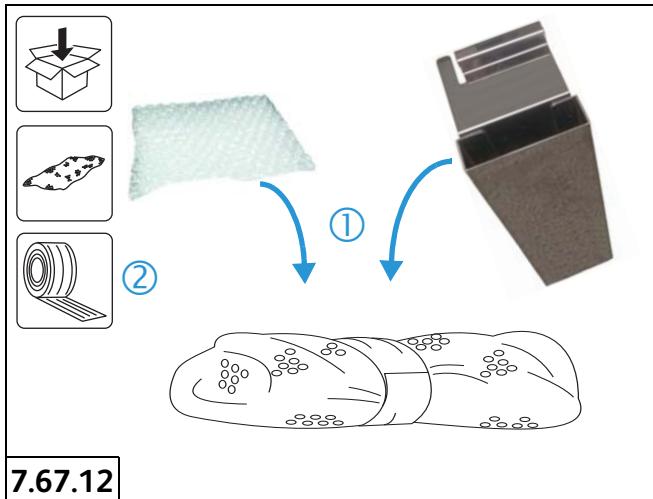
7.67.8 ① Wrap the Booklet Maker Tray in a layer of bubblepack and ② secure with tape.



7.67.9 ① Remove the screws (4) securing the PR Finisher rear cover and ② remove the cover. ③ Lift and remove the storage bin from the rear left side of the finisher. ④ Reinstall the rear cover back in place and ⑤ then secure in place with the original screws (4).

7.67.10 ① Tip the storage bin over and ② retrieve the four small covers from within the bin.

7.67.11 Place the four small covers in the plastic bag with the other hardware.

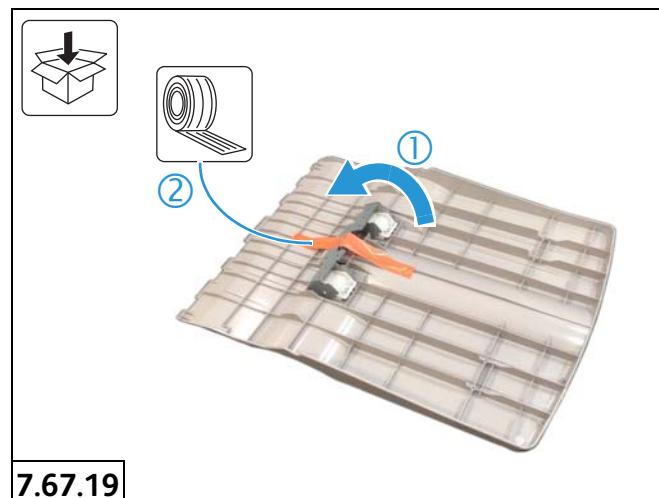
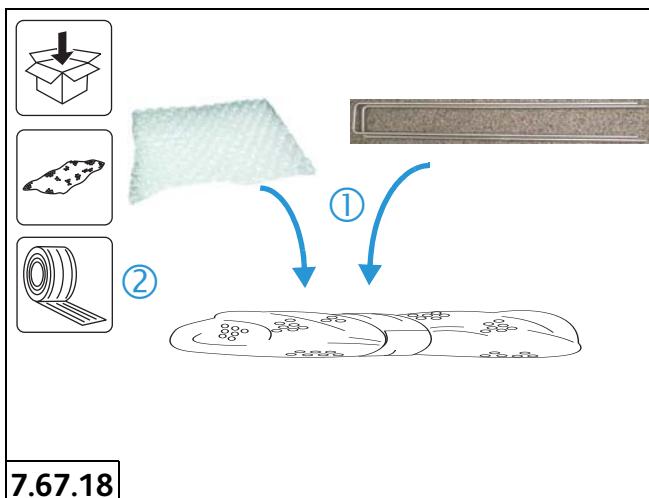
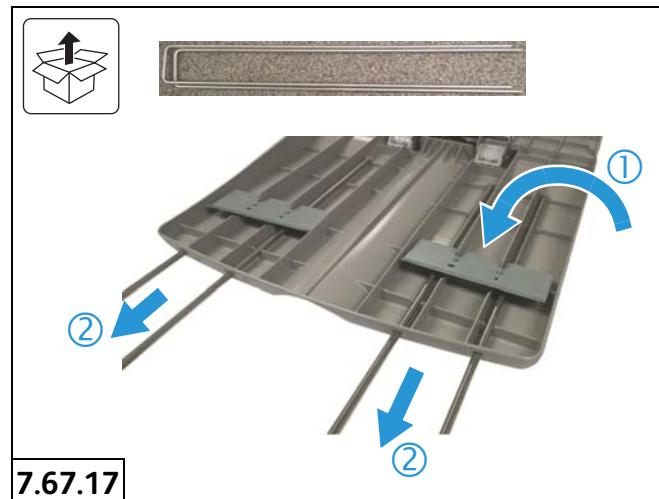
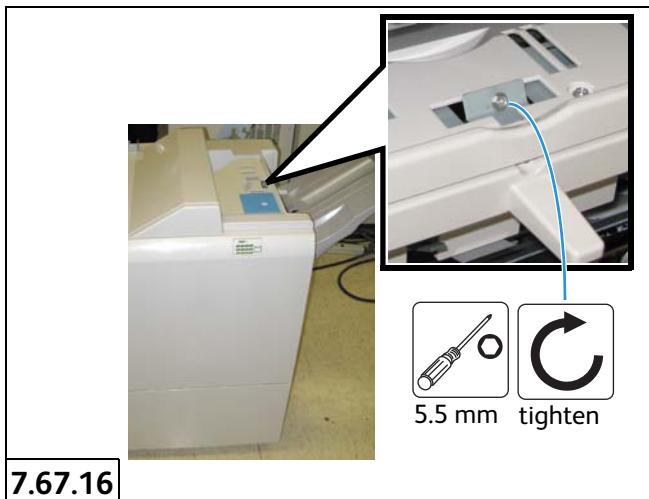


7.67.12 ① Wrap the storage bin in a layer of bubblewrap ② secure with tape.

7.67.13 Loosen the screw on the underside of the top output tray.

7.67.14 ① Lift the tray slightly and ② disengage the tray bracket under the top output tray from the securing tab/screw.

7.67.15 ① Lift and ② remove the top output tray from the top of the PR Finisher.

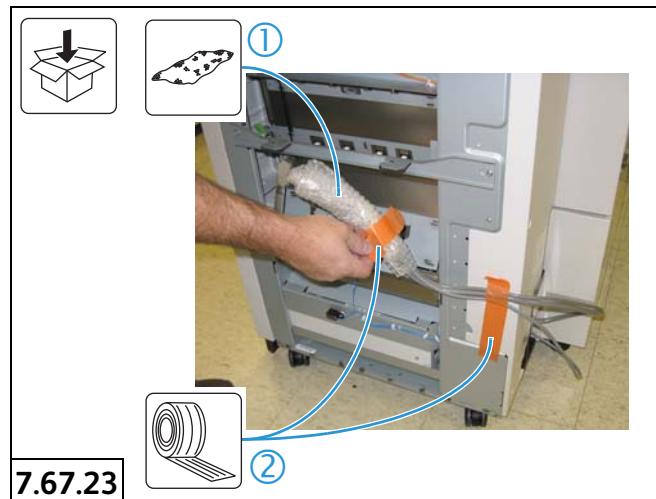
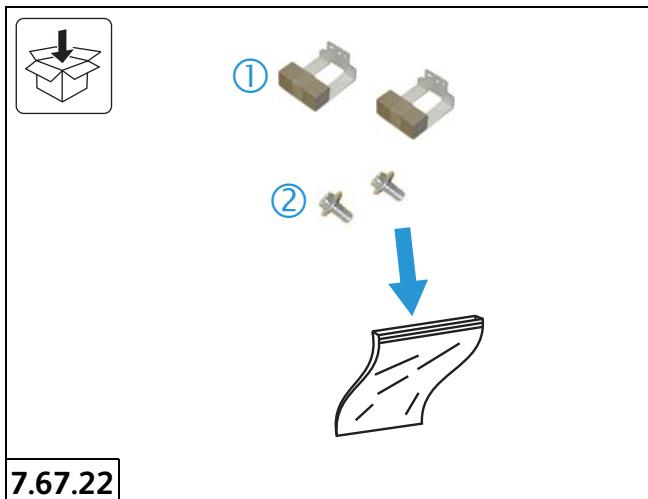
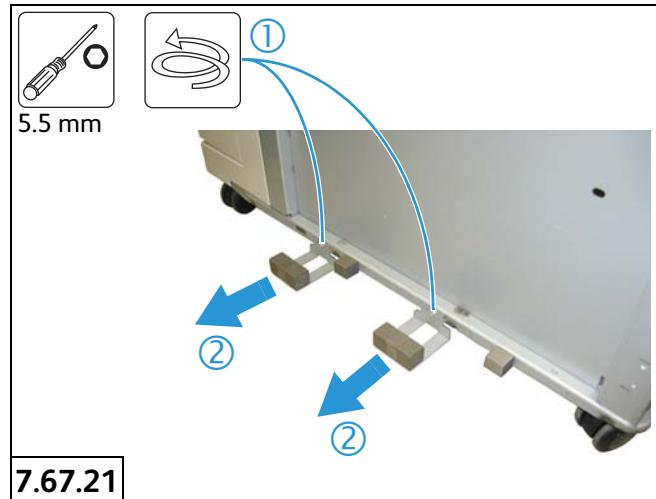
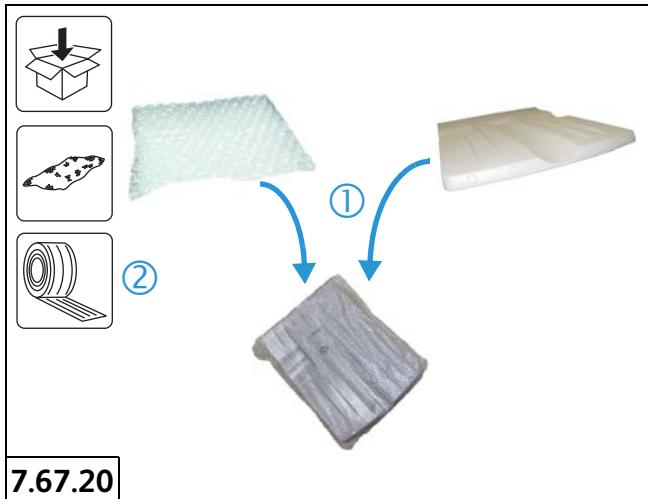


7.67.16 Tighten securing screw on top right side of the module.

7.67.17 ① Turn the output tray over and
② remove the tray extensions (2) from the tray.

7.67.18 ① Wrap the tray extensions (2) in a layer of bubblepack and ② secure with tape.

7.67.19 ① Pivot the docking bracket on the underside of the output tray and ② then secure in place with tape.

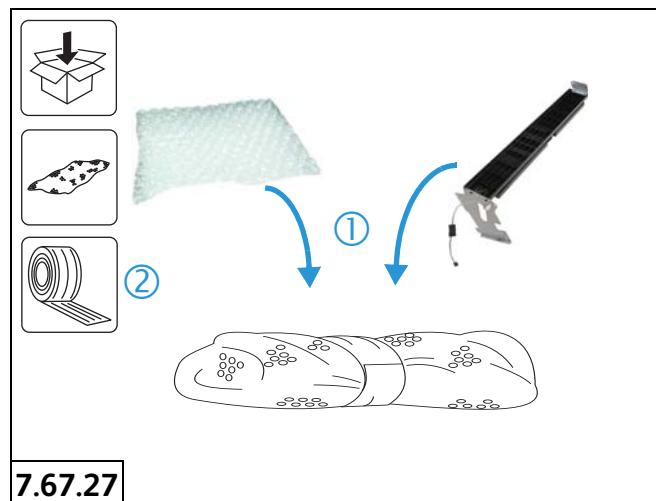
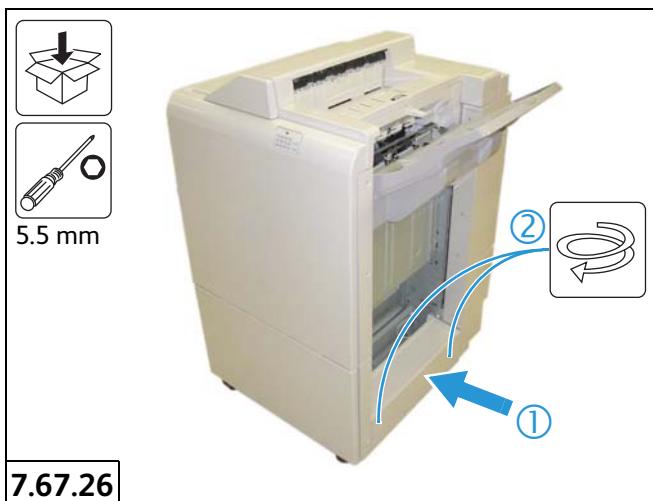
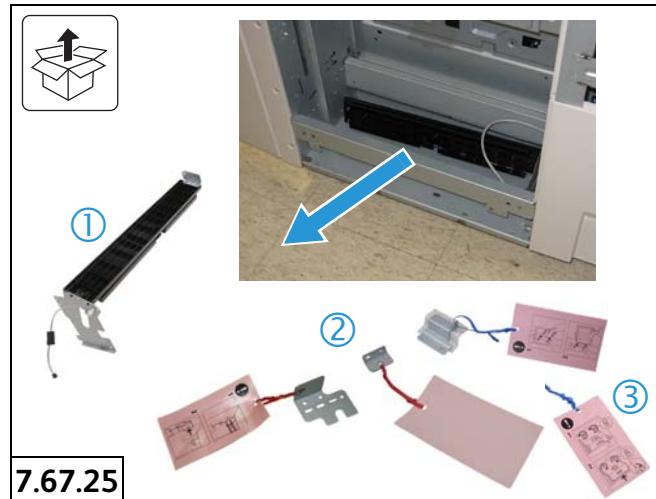
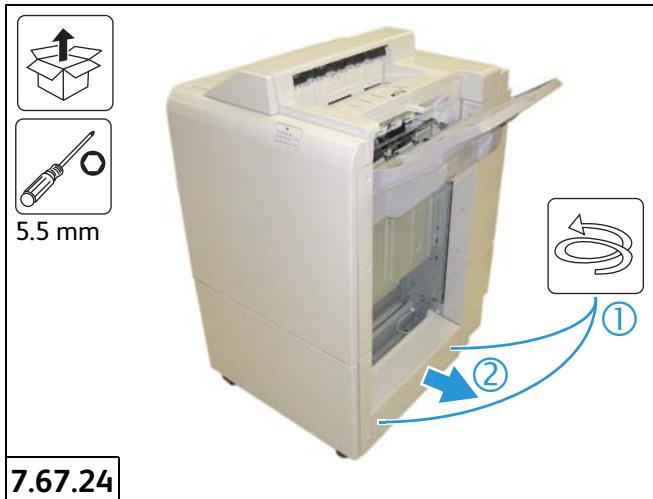


7.67.20 ① Wrap the output tray in a layer of bubblepack and ② secure with tape.

7.67.21 ① Remove the screw (1 per) securing each grounding pad (2) and ② remove the grounding pads from the right side bottom edge of the finisher.

7.67.22 ① Place the grounding pads (2) and ② screws (2) in the plastic bag with the other hardware. Close the bag.

7.67.23 ① Wrap the hardwired cable connection from the rear of the Finisher in bubblepack and ② secure with tape on the right side of the Finisher.

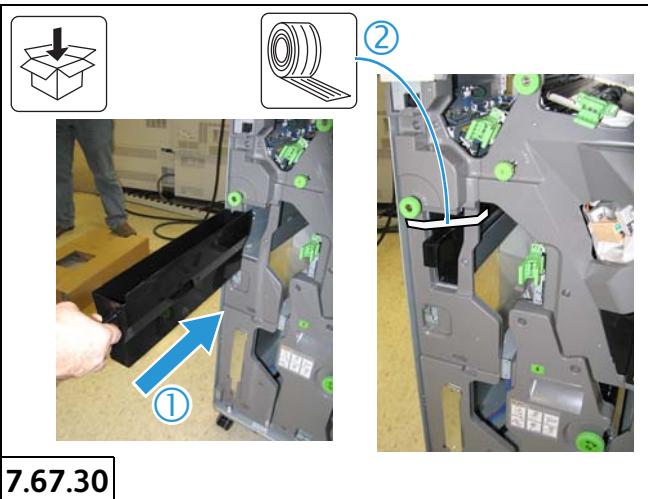
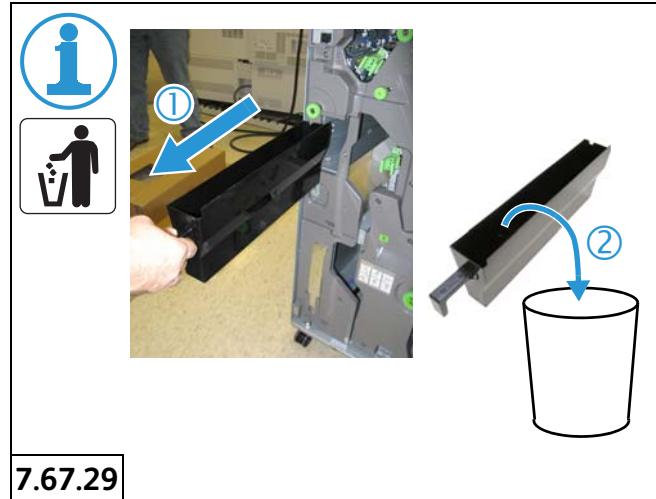


7.67.24 ① Remove the screws (2) and ② right side bottom cover from the module.

7.67.25 ① Remove the output feed assembly, ② shipping brackets (3) and ③ shipping bracket tag from the cavity.

7.67.26 ① Reinstall the right side bottom cover and ② secure with two original screws.

7.67.27 ① Wrap the output feed assembly in a layer of bubblepack and ② secure with tape.



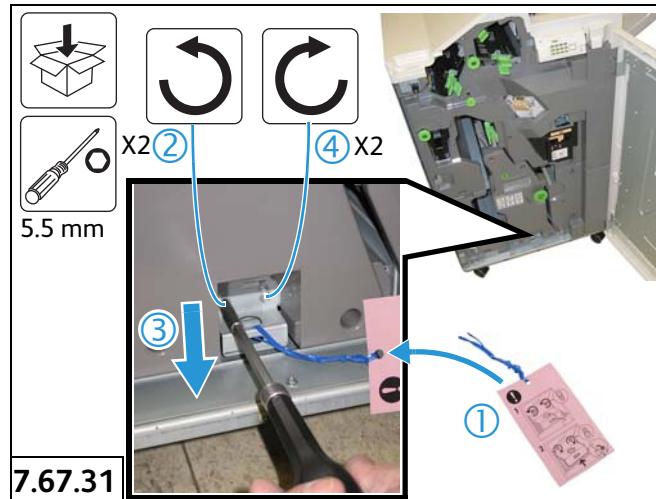
7.67.28 Open the front cover of the finisher.



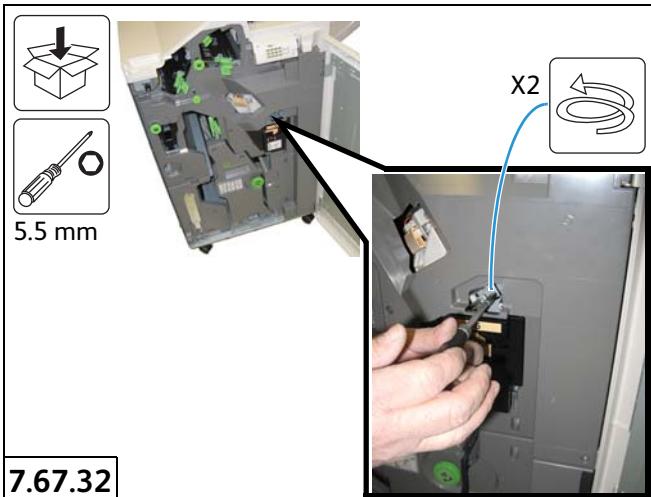
Note: Do not discard the waste bin, only empty the contents from within the bin so that it does not spill while in transit.

7.67.29 ① Remove the waste bin from the front left side of the finisher. ② Empty the bin by dumping the scraps into a trash can.

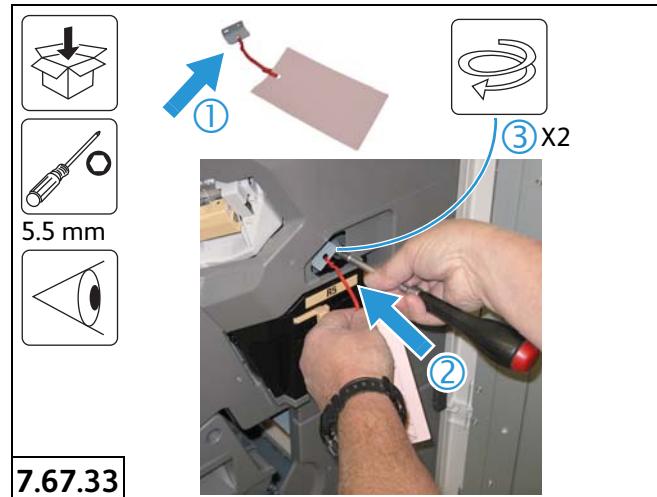
7.67.30 ① Reinstall the waste bin back into the finisher and ② secure it in place with tape.



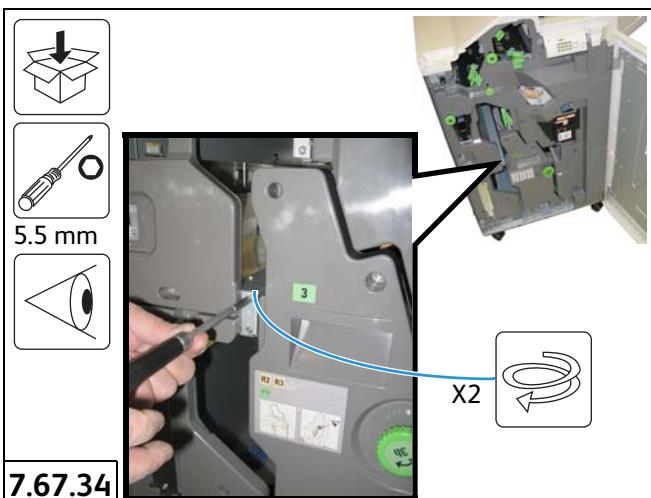
7.67.31 ① Reattach the shipping bracket tag to the bracket on the front middle bottom of the Finisher. ② Loosen the two screws securing the shipping bracket and ③ lower the bracket. ④ Secure the bracket in place by tightening the two screws.



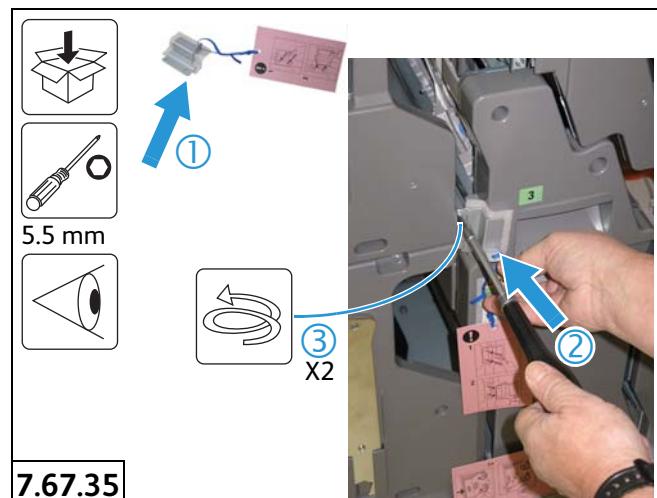
7.67.32



7.67.33



7.67.34



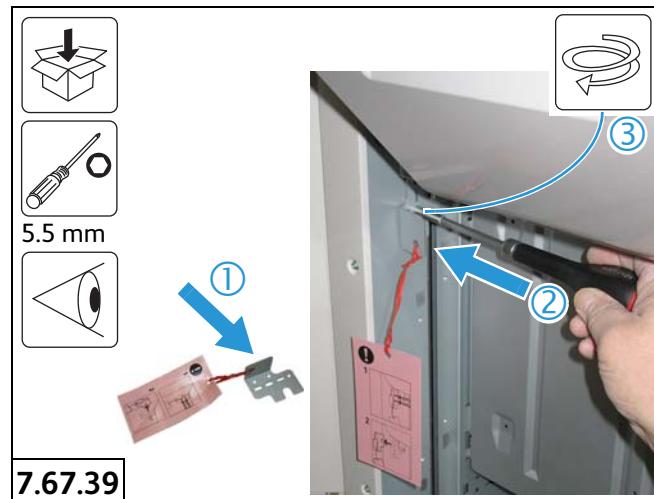
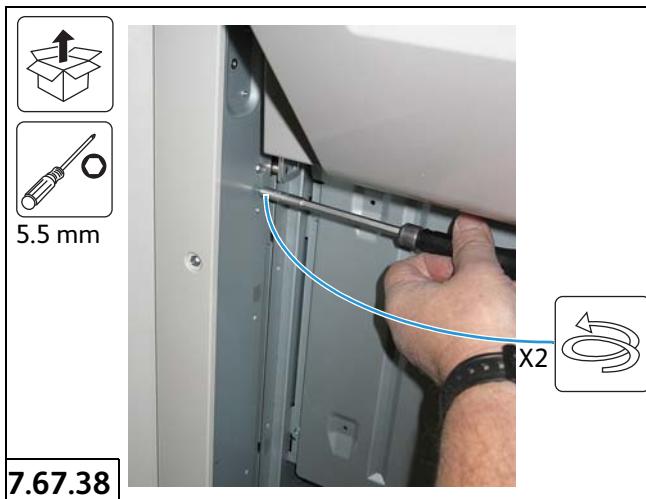
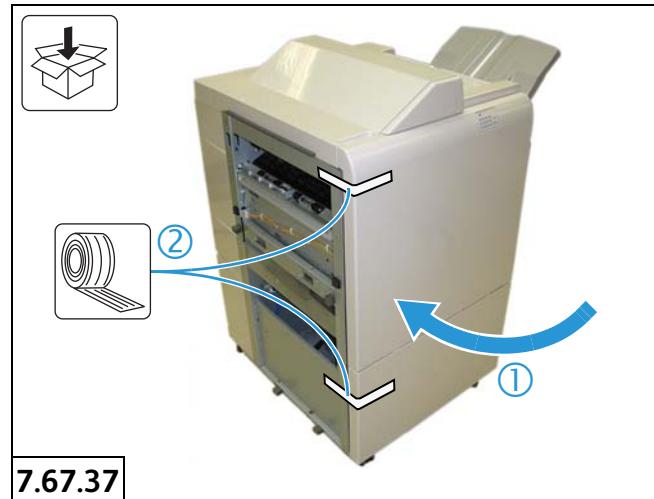
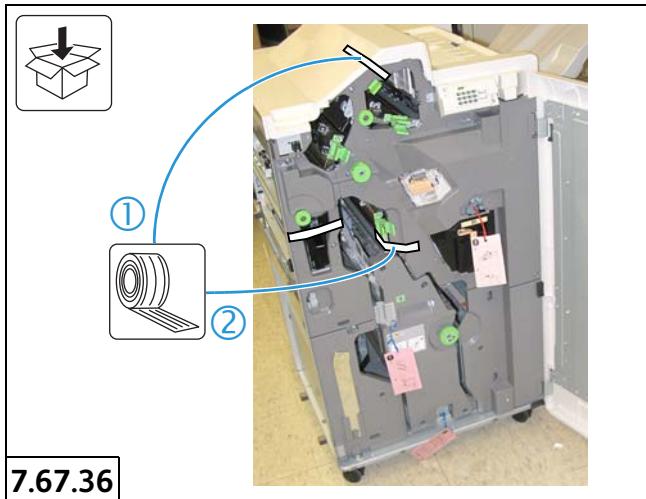
7.67.35

7.67.32 Remove the two shipping bracket screws from the area just above the R5 label on the front right side of the finisher.

7.67.33 ① Retrieve the smallest of the three shipping brackets and ② install it into the area above the R5 area according to attached tag. ③ Secure it in place with the screws (2) just removed.

7.67.34 Remove the screws (2) in the area just to the left of '3' label.

7.67.35 ① Retrieve the smaller of the remaining two shipping brackets and ② install the shipping bracket in the area just to the left of '3' according to the attached tag. ③ Secure the bracket in place with screws (2).

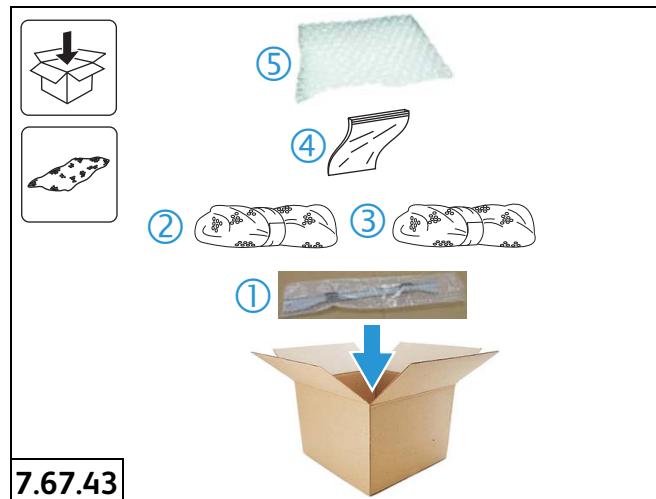
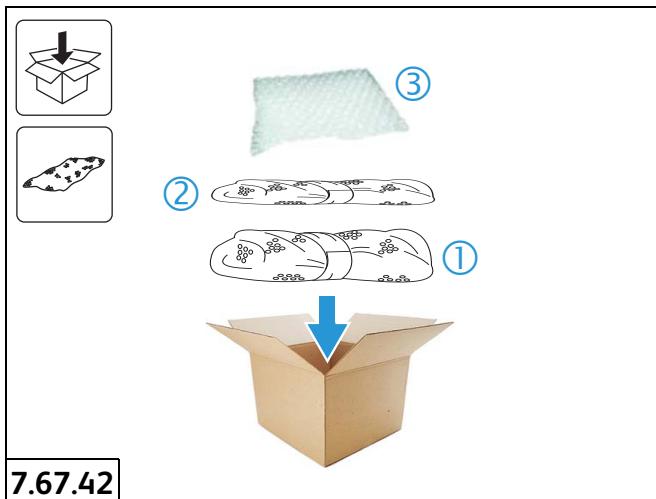
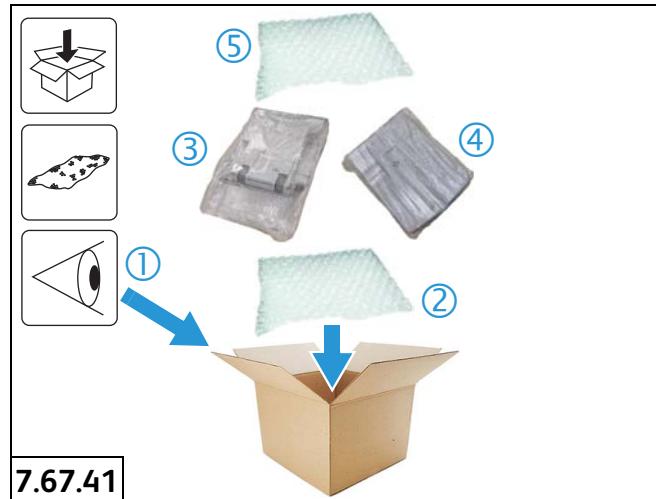
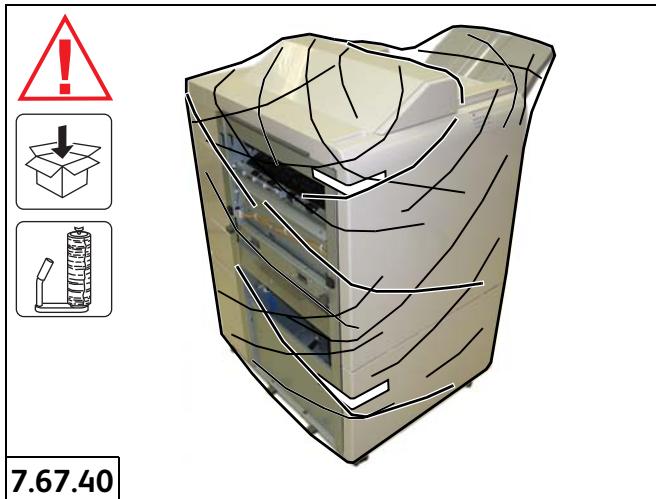


7.67.36 ① Secure front top and ② middle baffles with tape.

7.67.37 ① Close front cover of the finisher and ② secure with tape.

7.67.38 Remove shipping bracket screws (2) from right side front inside edge of output tray area.

7.67.39 ① Retrieve the remaining shipping bracket and ② install it into the right side front inside edge of output tray area according to attached tag. ③ Secure it in place with the screws (2) just removed.



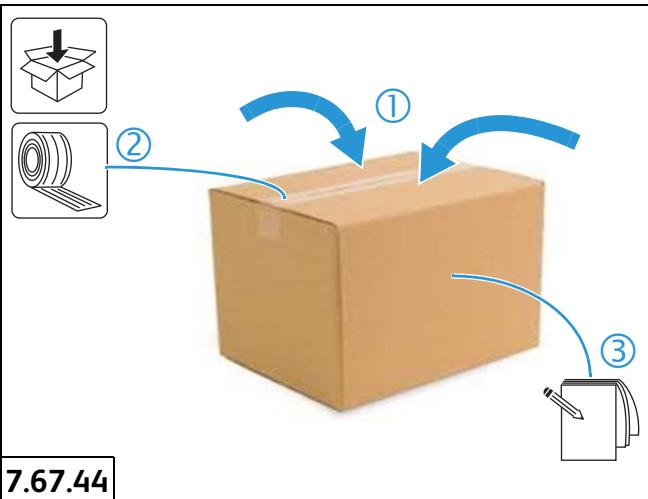
CAUTION: When covering the finisher with a layer of stretchwrap, ensure that too much tension is not applied on the top output tray. If so, damage may occur.

7.67.40 Secure the module with a layer of stretchwrap.

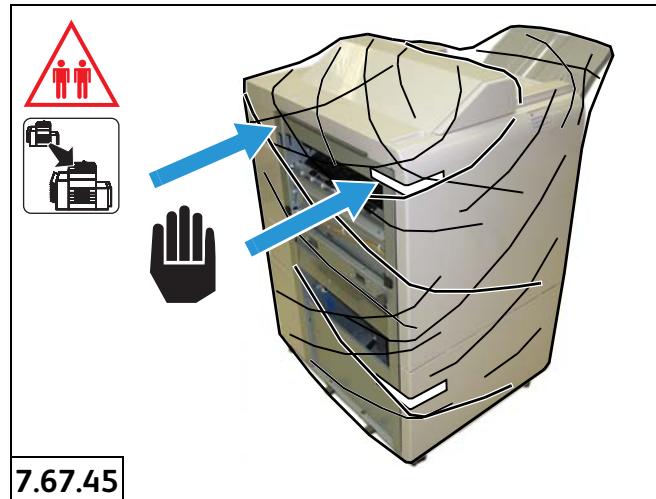
7.67.41 ① Retrieve a generic box and ② place a layer of bubblepack in the bottom. ③ Place the packed booklet maker tray and ④ packed top output tray in the box and ⑤ cover it with a layer of bubblepack.

7.67.42 ① Place the packed storage bin and ② packed top output tray extensions in the box. ③ Place a layer of bubblepack over the top of the two items.

7.67.43 ① Place the packed docking bracket, ② packed power cord, ③ packed interface cable and ④ bag of hardware in the box. Then, ⑤ fill all voids with bubblepack.



7.67.44



7.67.45



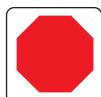
7.67.46

7.67.44 ① Close the box and ② secure the top of the box with tape. ③ Write the contents on the outside of the box.



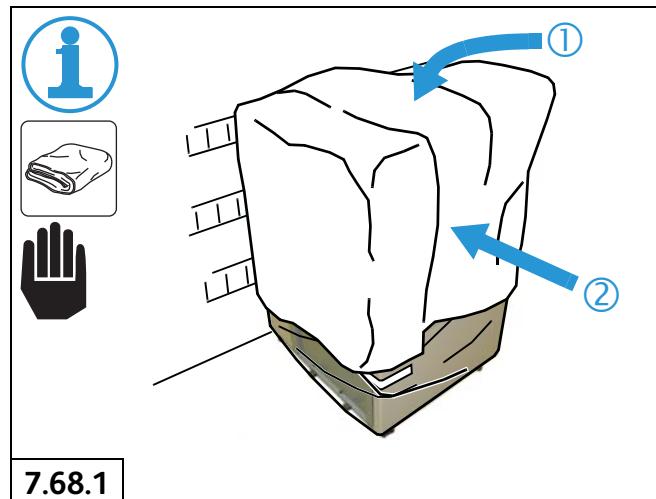
WARNING: Due to the weight and size of the PR Finisher, two people are required to move the module.

7.67.45 Move the PR Finisher to the new location or to the truck.



Stop: The box containing the miscellaneous items for the PR Finisher stays with the PR Finisher when being relocated.

7.67.46 Move the boxed miscellaneous items to the new location or truck with the Finisher.



7.68.1

7.68.0 Strapping the Production Ready Finisher (if present) into the Truck

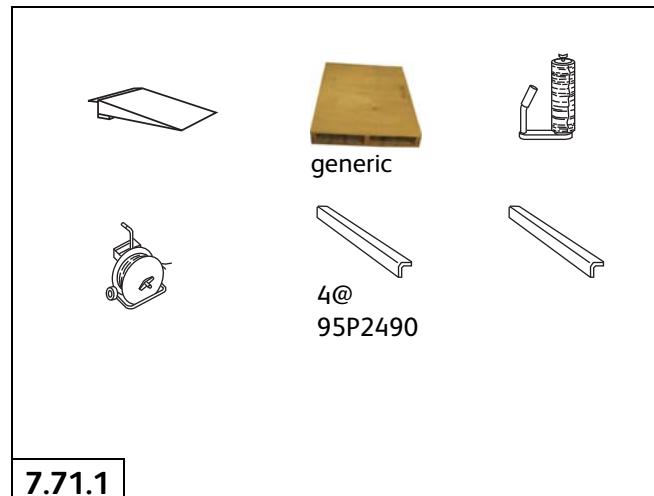
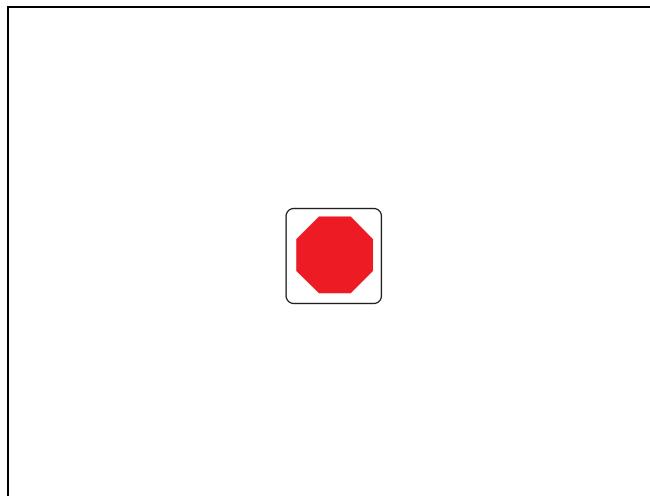
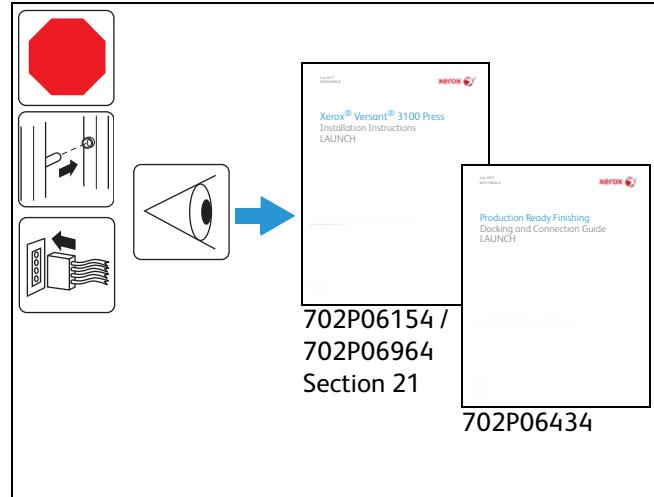
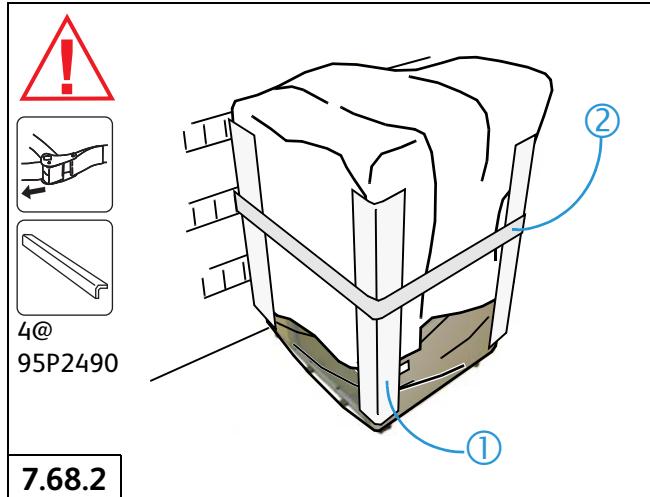


Note: When strapping the PR Finisher into the truck, ensure the rear of the module is positioned against the wall of the truck.



Note: When covering the finisher with the blanket, ensure the blanket is positioned between the wall of the truck and the finisher.

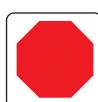
7.68.1 ① Place a folded blanket over the top of the finisher and ② position the module against the wall of the truck.



CAUTION: When strapping the PR Finisher into the truck, ensure the strap is run under the top output tray on the left top side of the module.

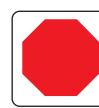
7.68.2 ① Position a cornerboard (95P2940) on each of the four corners and ② strap the module into the truck.

7.69.0 Reinstall - Unpack and Install the Production Ready Finisher (if present)



Stop: Use the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) (if present) and the Production Ready Finishing Docking and Connection Guide to reinstall, dock and connect the PR Finisher.

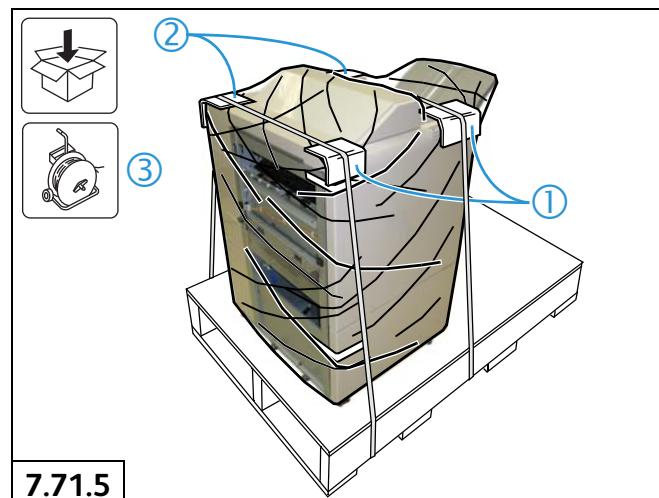
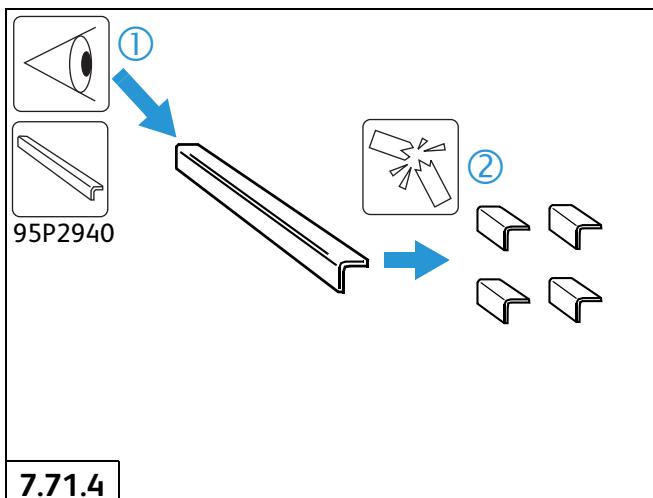
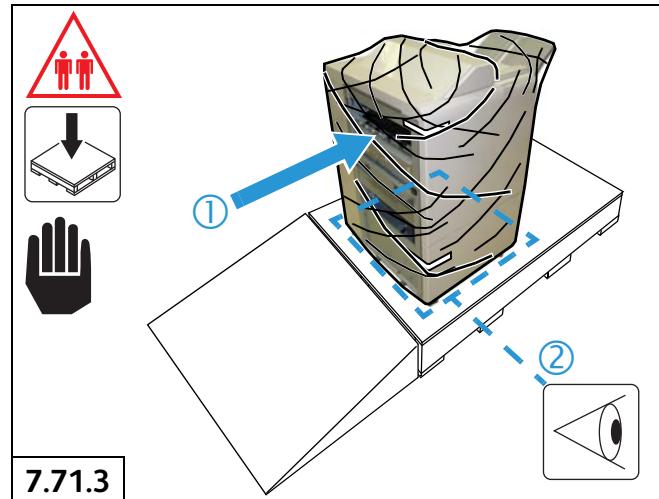
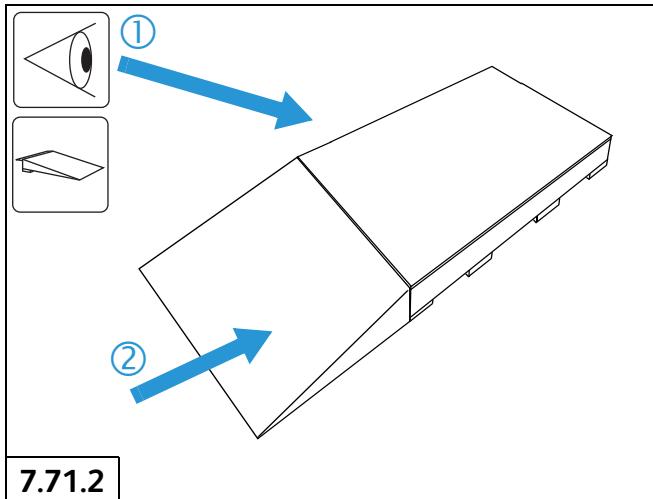
7.70.0 Removal - Preparing the PR Finisher for the Move (if present)



Stop: Perform all the steps in "Relocation - Preparing the Production Ready Finisher for the Move" on 7.67.0, except for 7.69.0 "Reinstall - Unpack and Install the Production Ready Finisher (if present)" on page 7-115.

7.71.0 Return - Preparing the Production Ready Finisher (if present) for the Move

7.71.1 The tool and materials required to return the PR Finisher are shown.



7.71.2 ① Retrieve a generic pallet and ② position a ramp at one end.

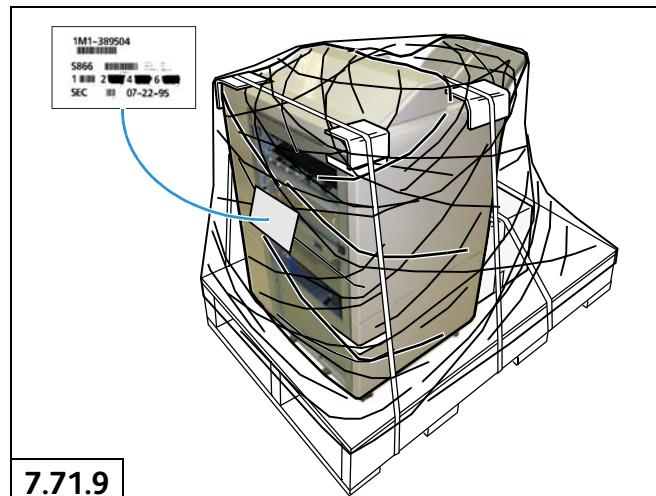
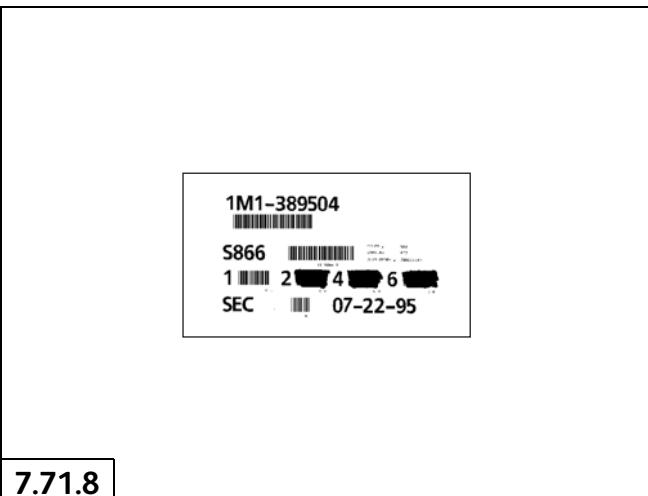
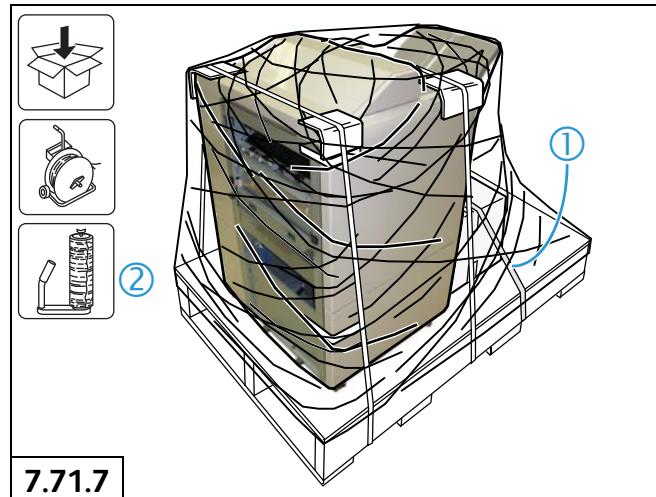
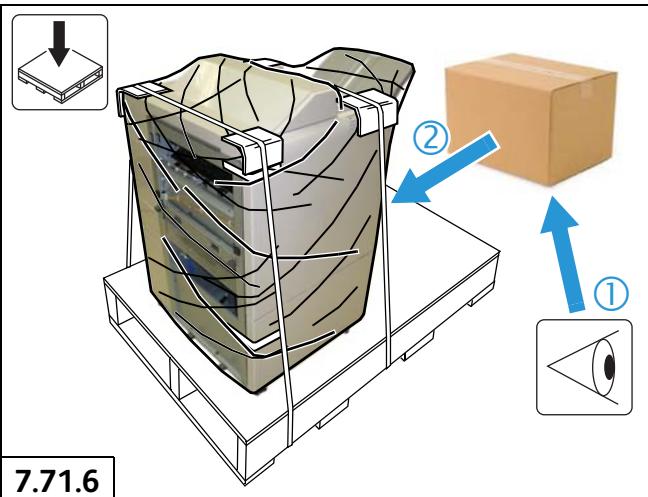


WARNING: Due to the weight and size of the PR Finisher, two people are required to palletize the module.

7.71.3 ① Palletize the PR Finisher and ② position the module at one end of the pallet.

7.71.4 ① Retrieve a single corner board and ② break it into four equal pieces.

7.71.5 Position the four cornerboard pieces on the top of the PR Finisher, ① two on the front edge and ② two on the rear edge. Then, ③ secure the PR Finisher to the pallet using banding.

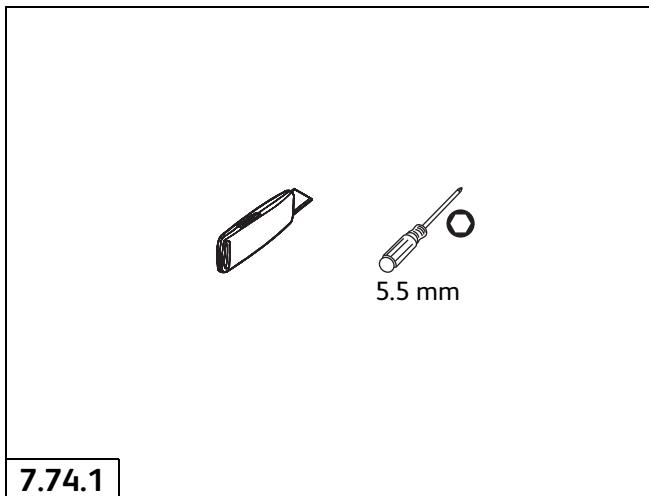
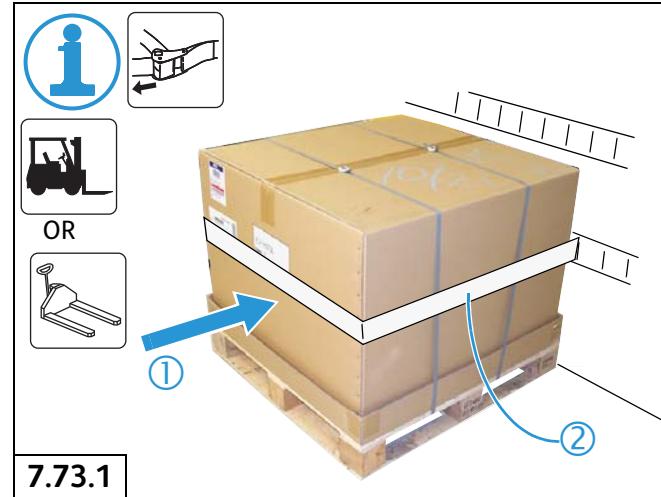
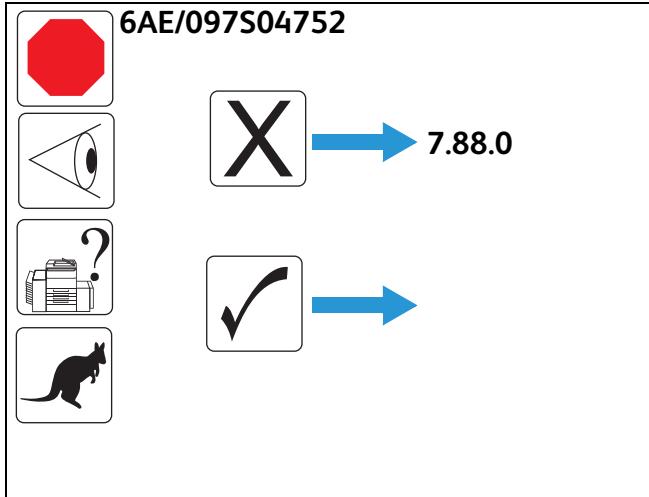


7.71.6 ① Retrieve the box that contains the miscellaneous items and ② position on the pallet next to the PR Finisher.

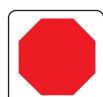
7.71.7 ① Secure the box to the pallet with a single band over the box. Then, ② secure the box and PR Finisher to the pallet with a layer of stretchwrap.

7.71.8 Generate the bar code label. Cross off the non-applicable codes.

7.71.9 Apply the bar code label to the stretchwrap at the open end of the pallet.



7.72.0 Accessory J: Depalletize, Unpack, and Install the Integrated SquareFold® Trimmer (6AE/097N04752) (if present)



Stop: If an Integrated SquareFold® Trimmer is not present, go to 7.88.0 "Accessory L: Delivery - Preparing the Partner Finishing Interface Module (PFIM) (XMH/097S04171) (if present)" on page 7-140. If an Integrated SquareFold® Trimmer is present, continue onto the next step.

7.73.0 Strapping Procedures



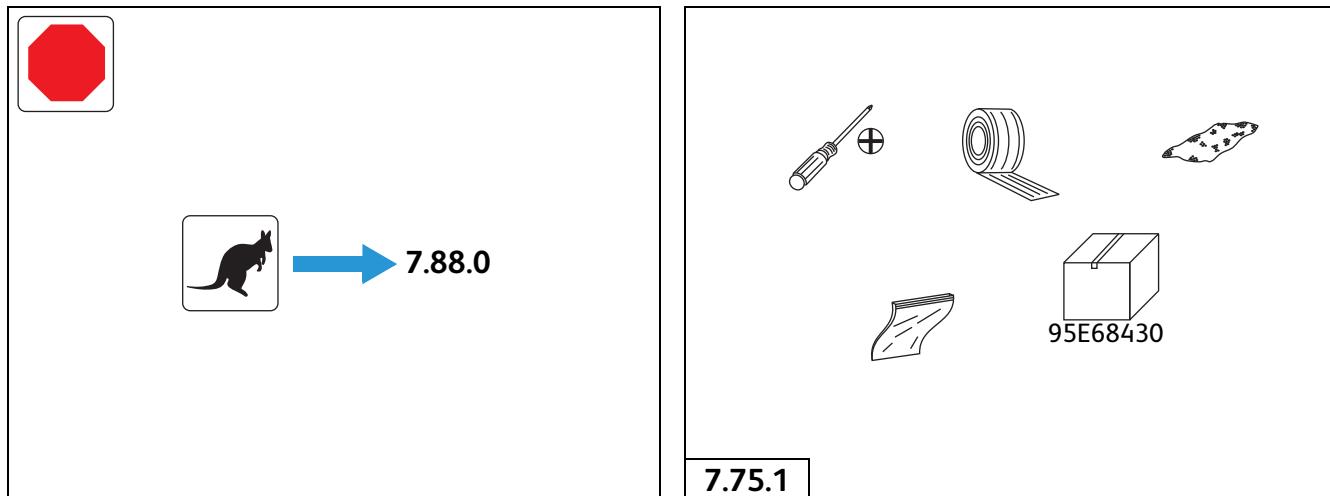
Note: If an Integrated SquareFold® Trimmer module is present, due to the low center of gravity and the dimensions of

the packaged module, this module only needs to be loosely strapped into the truck.

7.73.1 If a SquareFold® Trimmer is present, **①** place the packaged module against the wall of the truck and **②** place a loose strap around it for transport to the Customer location.

7.74.0 Delivery - Position, Unpack, and Assemble the Integrated SquareFold® Trimmer (if present)

7.74.1 The tools required to unpack, depalletize, and install the Integrated SquareFold® Trimmer are shown.



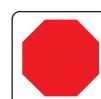
Stop: The Carrier is responsible for unpacking and depalletizing the Integrated SquareFold® Trimmer module at the Customer site. Once depalletized the Carrier will also be responsible for docking, connecting, and getting the module up and running.



WARNING: Due to the size and weight of the Integrated SquareFold® Trimmer, two people will required to depalletize the module.

7.74.2 ① Depalletize, ② unpack and, ③ install the Integrated SquareFold® Trimmer (TLX) using the ④ Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) and

⑤ Production Ready Finishing Docking and Connection Guide (702P06434).



Stop: Go to 7.88.0 "Accessory L: Delivery - Preparing the Partner Finishing Interface Module (PFIM) (XMH/097S04171) (if present)", on page 7-140.

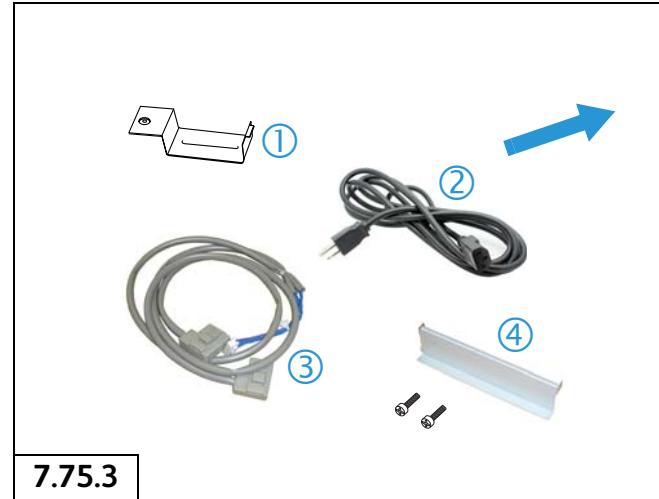
7.75.0 Relocation - Preparing the Integrated SquareFold® Trimmer for Move

7.75.1 The tool and materials required for preparing the Integrated SquareFold® Trimmer for relocation are shown.

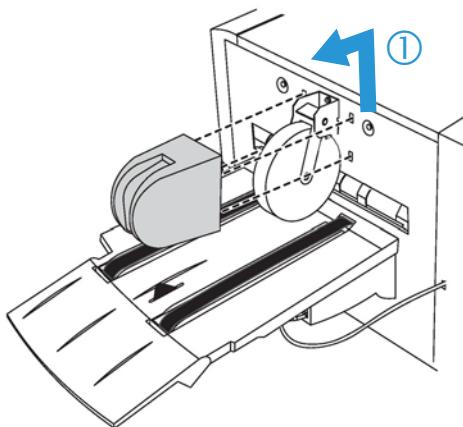
6AE/097S04752



7.75.2



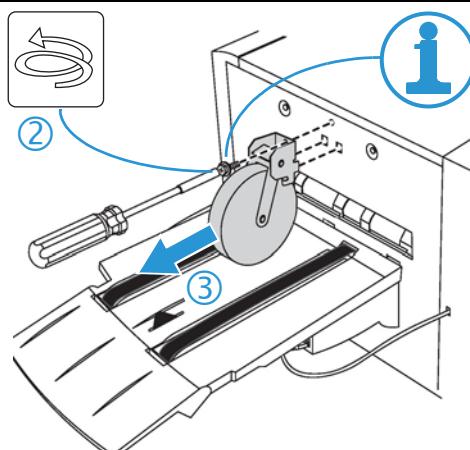
7.75.3



7.75.4

7.75.2 ① Remove the power cord protector, ② power cord ③ interface cable and ④ docking bracket / screws (2) from the top of the Square-Fold Trimmer.

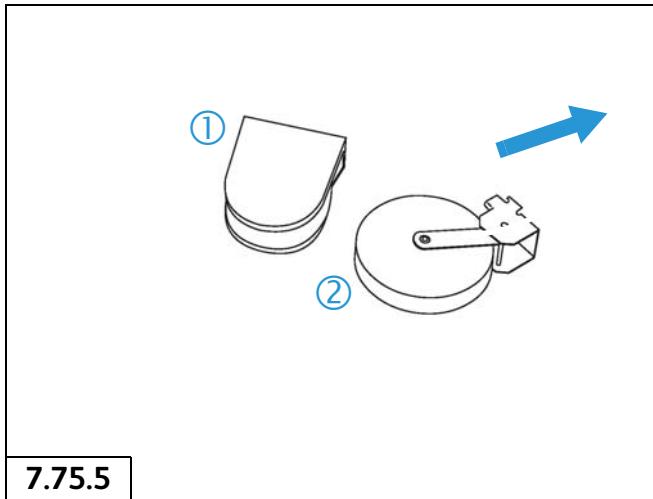
7.75.3 ① Set the bracket, ② power cord ③ interface cable and ④ docking bracket / screws (2) aside.



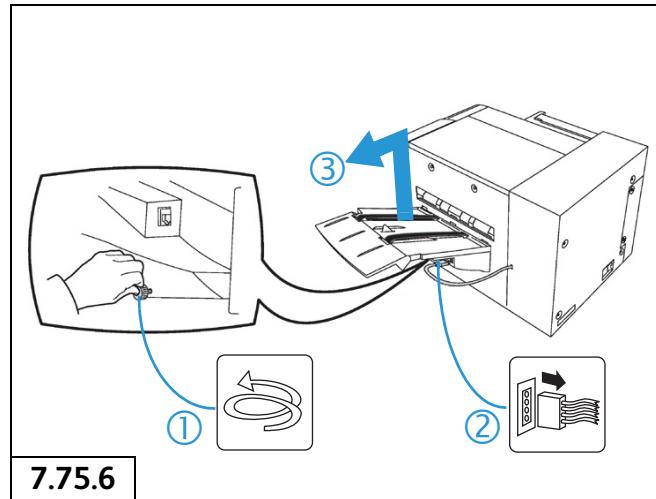
7.75.4 ① Lift and remove the Booklet Maker Tray wheel cover. ② Remove screw and ③ Booklet Maker Tray wheel from the left side of the Square-Fold® Trimmer.



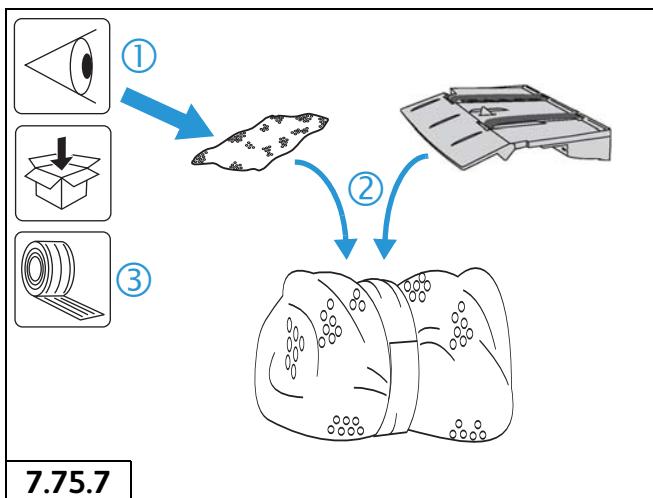
Note: Reattach the single screw to the right side of the SquareFold Trimmer so that it does not get lost.



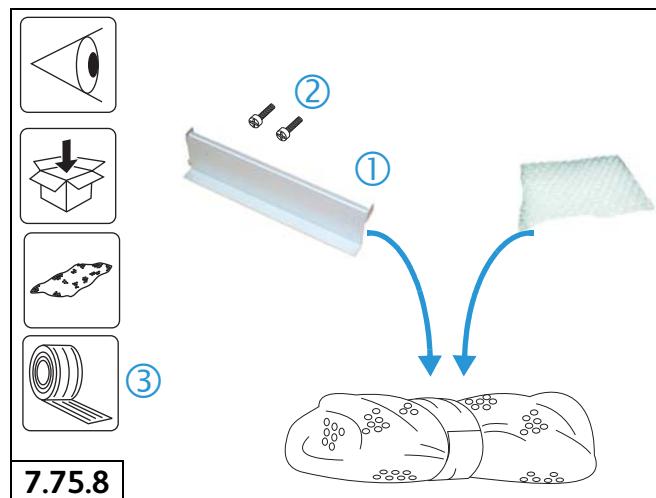
7.75.5



7.75.6



7.75.7



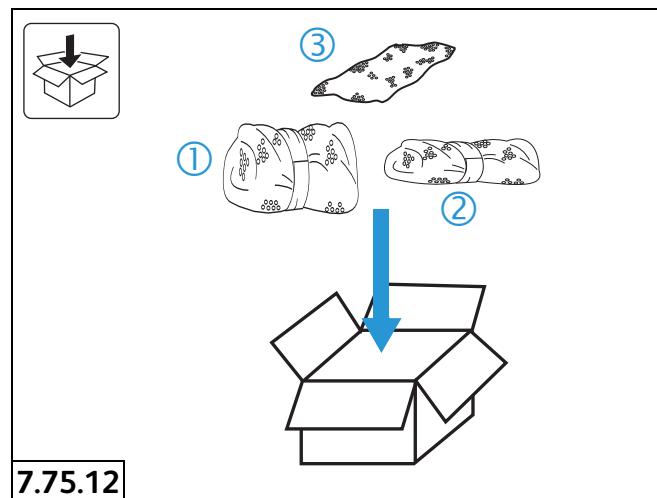
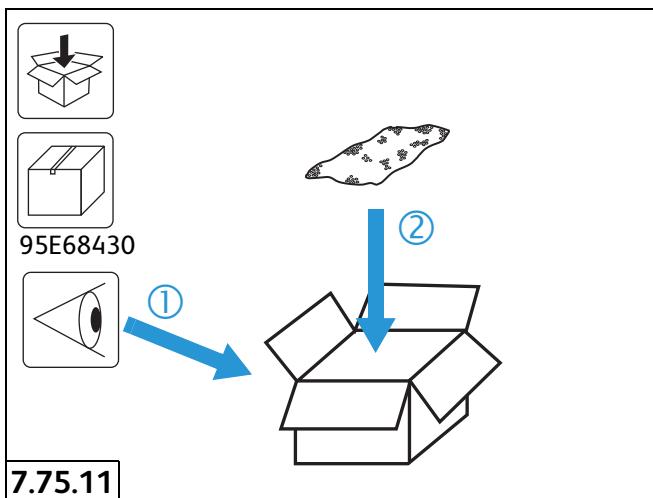
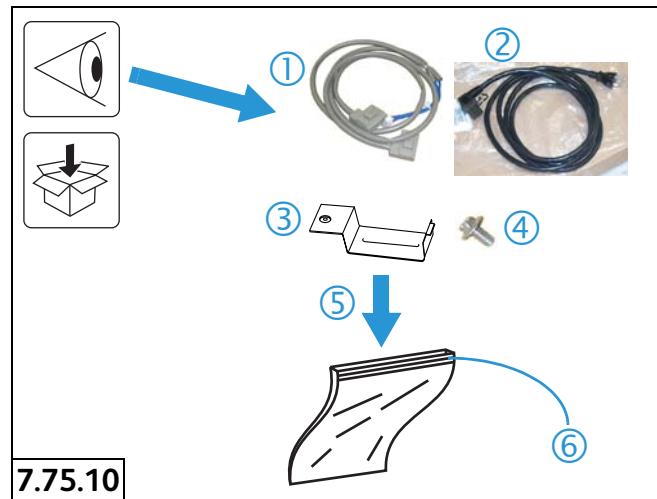
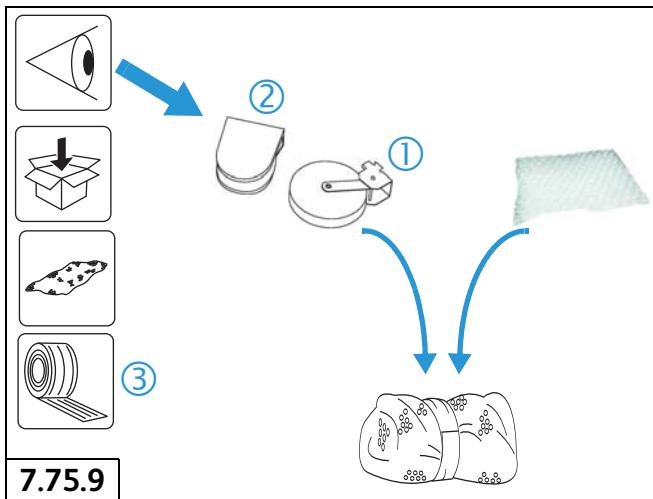
7.75.8

7.75.5 ① Set the tray wheel cover and ② tray wheel aside.

7.75.6 ① Remove the thumbscrew from under the Booklet Maker Tray and ② disconnect the communication cable from tray. ③ Lift and remove the Booklet Maker Tray from the right side of the SquareFold® Trimmer.

7.75.7 ① Retrieve a piece of bubblepack and ② wrap the Booklet Maker Tray in the bubblepack. ③ Secure the wrapped tray with tape.

7.75.8 ① Wrap the docking bracket and ② screws (2) in the bubblepack. ③ Secure the bubblepacked bracket with tape.

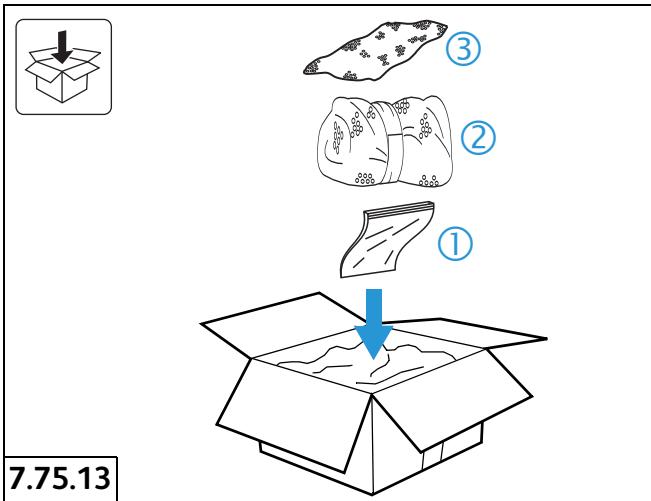


7.75.9 ① Wrap the tray wheel and ② tray wheel cover in the bubblepack. ③ Secure the bubblepacked items with tape.

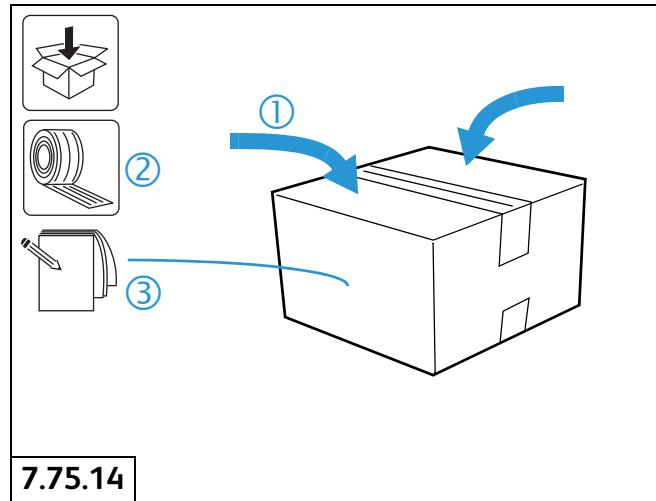
7.75.10 ① Retrieve interface cable, ② power cord, ③ power cord bracket and ④ screw. ⑤ Place them in a large plastic bag. ⑥ Seal the bag closed.

7.75.11 ① Retrieve a generic box (95E68430) and ② place a layer of bubblepack in the bottom of the box.

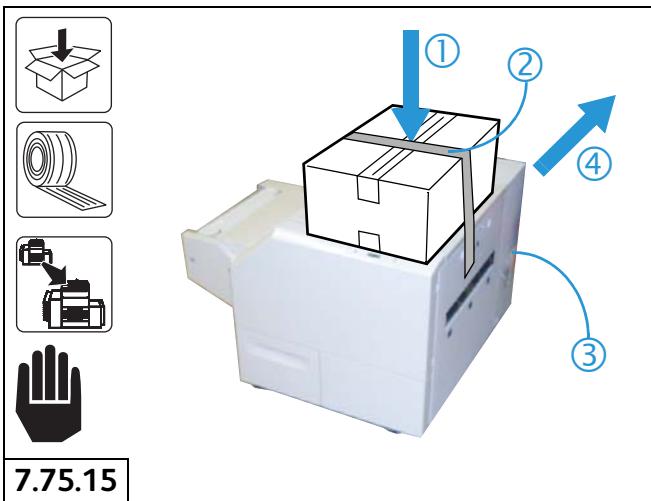
7.75.12 ① Place the bubblepacked Booklet Maker Tray and ② docking bracket into the box. ③ Cover them with a layer of bubblepack.



7.75.13



7.75.14

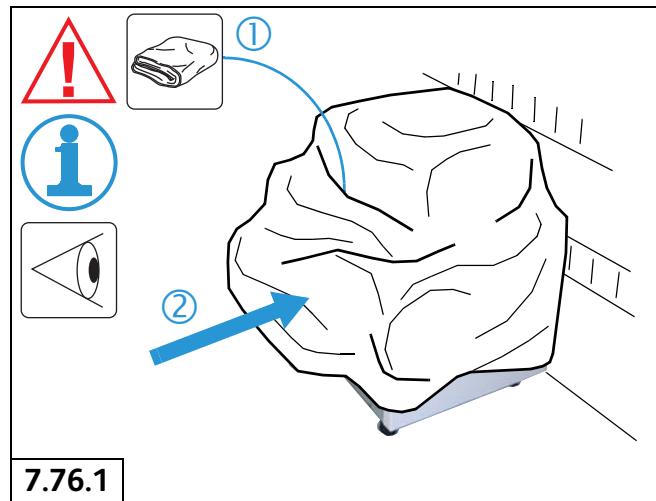


7.75.15

7.75.13 ① Place the bag containing the cables and power cord bracket and ② the bubblepacked tray cover and wheel in the box. ③ Fill all voids with bubblepack.

7.75.14 ① Close and ② secure the box with tape.
③ Write the contents on the outside of the box.

7.75.15 ① Place and ② secure the boxed items on top of the Integrated SquareFold® Trimmer.
③ Tape the interface cable on the right rear side of the module and ④ move the items to the truck.



7.76.1

7.76.0 Strapping the Integrated SquareFold® Trimmer

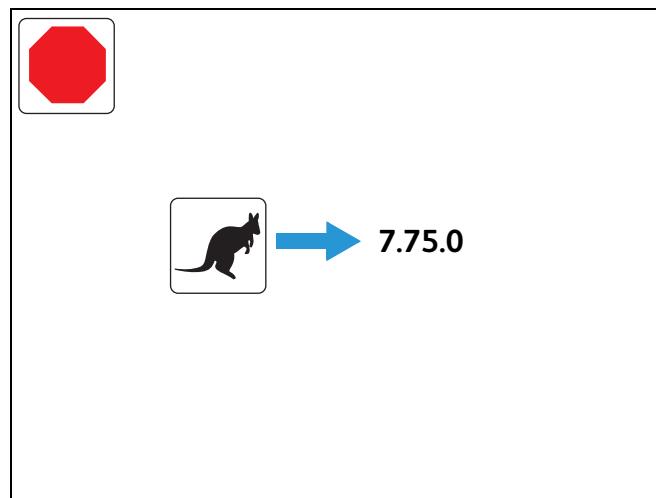
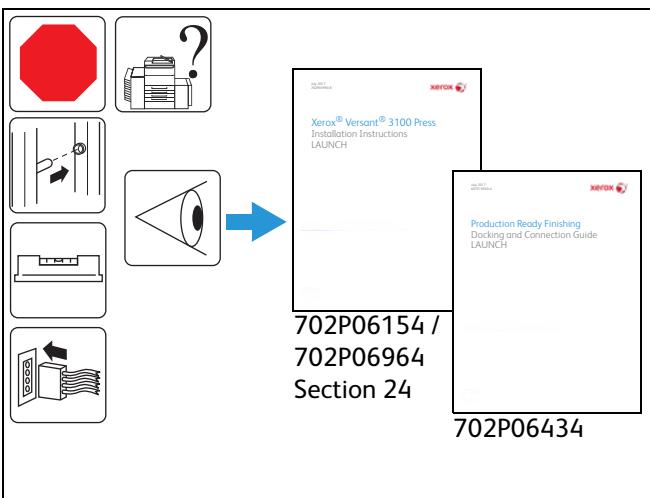
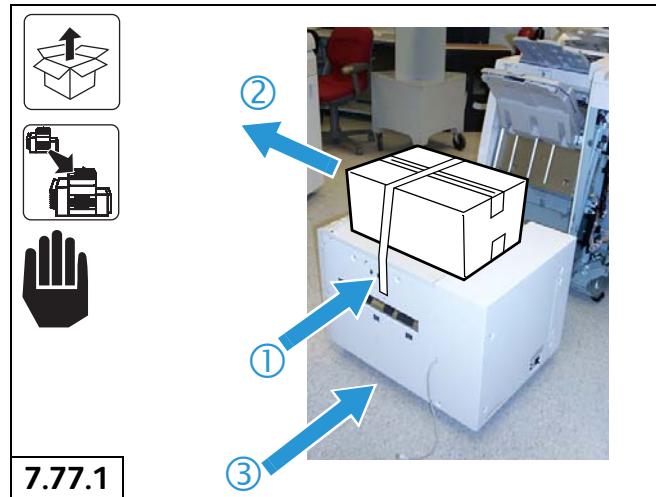
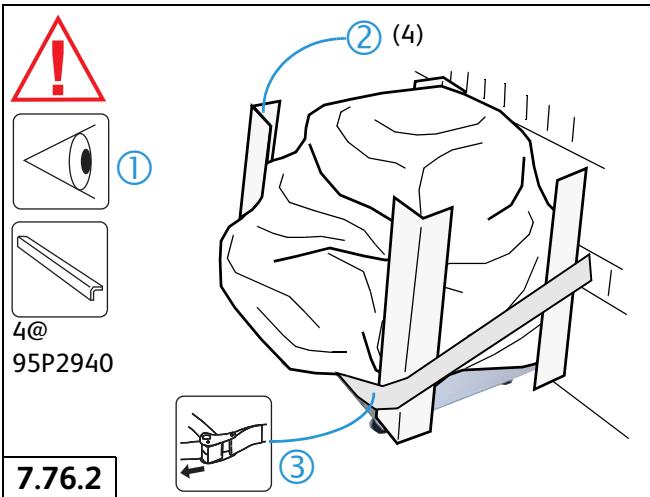


CAUTION: When placing the Integrated SquareFold® Trimmer in the truck, ensure the right side of the module is positioned against the wall of the truck.



Note: When covering the Integrated SquareFold® Trimmer with the blanket, ensure that the blanket is positioned between the right side of the module and the wall of the truck.

7.76.1 ① Cover the Integrated SquareFold® Trimmer with a blanket and ② then position the module against the wall of the truck.



CAUTION: When strapping the Integrated SquareFold® Trimmer into the truck, ensure to run the strap under the input area on the left side of the module. Do not over tighten strap when securing into the truck.

7.76.2 ① Retrieve and ② place cornerboards on all four corners of the Integrated SquareFold® Trimmer. ③ Strap the module into the truck.

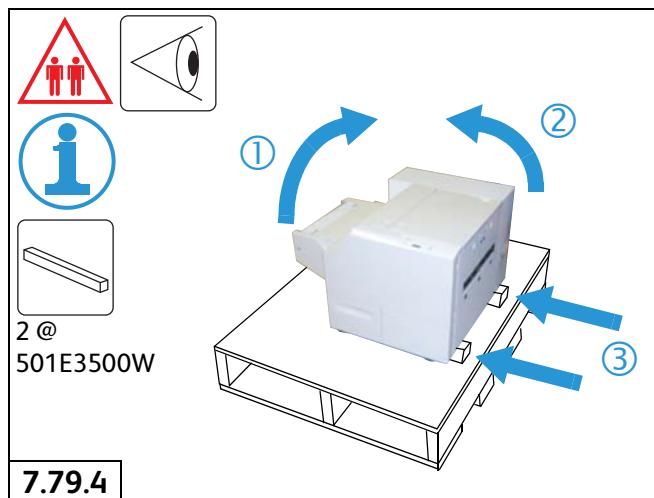
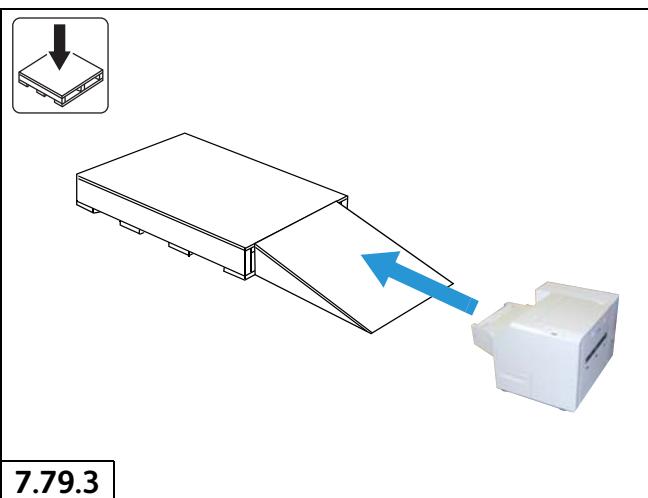
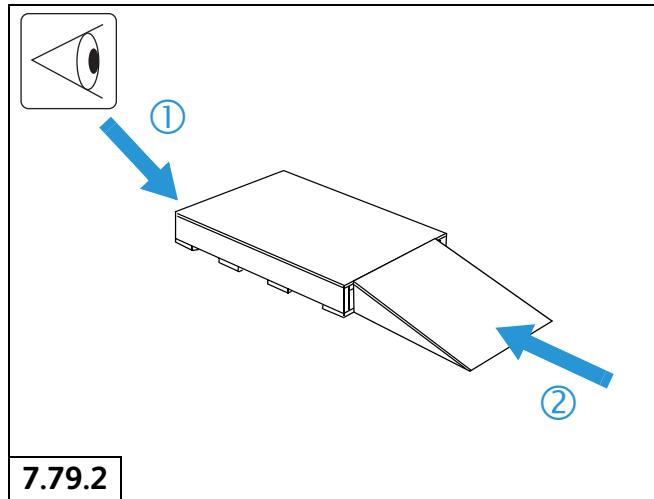
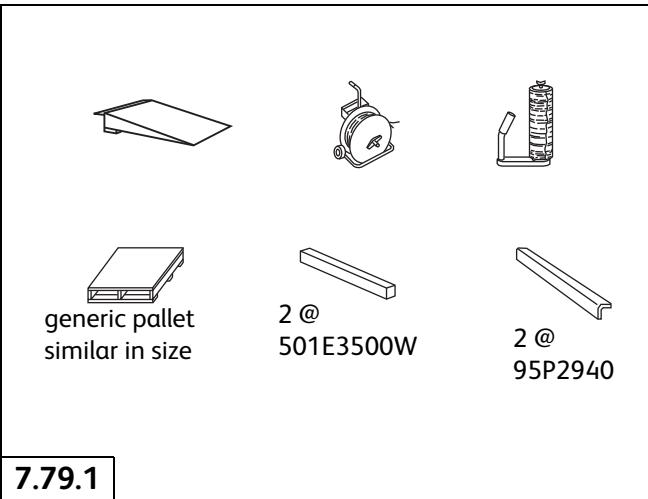
7.77.0 Reinstalling the Integrated SquareFold® Trimmer

7.77.1 ① Position the Integrated SquareFold® Trimmer to the right of the PR Finisher. ② Remove the taped box from the top of the module and ③ place it on the floor next to the Trimmer.

Stop: Use the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964) (if present) and the Production Ready Finishing Docking and Connection Guide to reinstall, dock, and connect the SquareFold Trimmer.

7.78.0 Removal - Preparing the Integrated SquareFold® Trimmer

Stop: Perform all steps in 7.75.0 "Relocation - Preparing the Integrated SquareFold® Trimmer for Move" on page 7-119 except for "Reinstalling the Integrated SquareFold® Trimmer" on page 7-124.



7.79.0 Returning the Integrated SquareFold® Trimmer

7.79.1 The tool and materials required to palletize the Integrated SquareFold® Trimmer are shown.

7.79.2 ① Retrieve a generic pallet similar in size and ② place a ramp at one end of it.

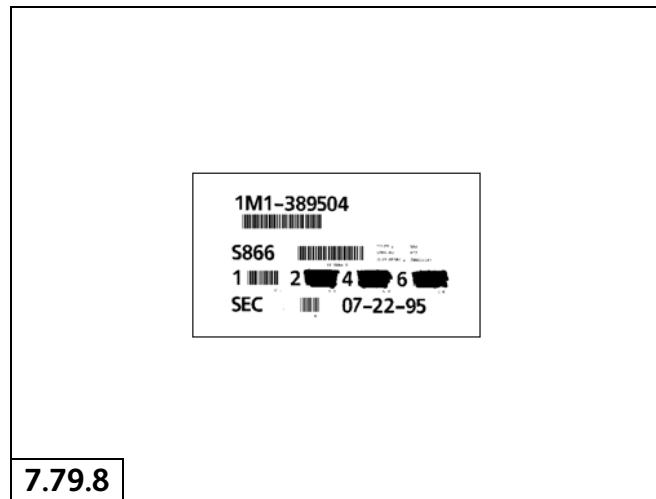
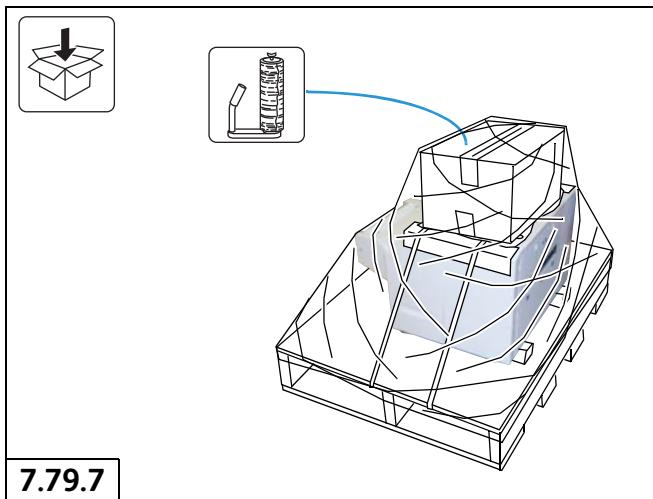
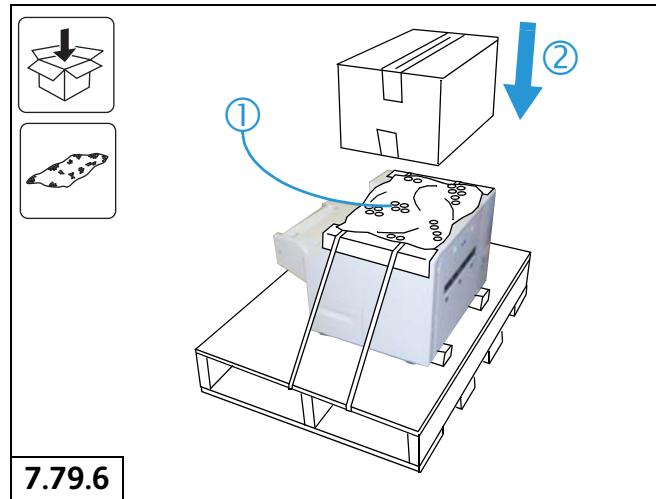
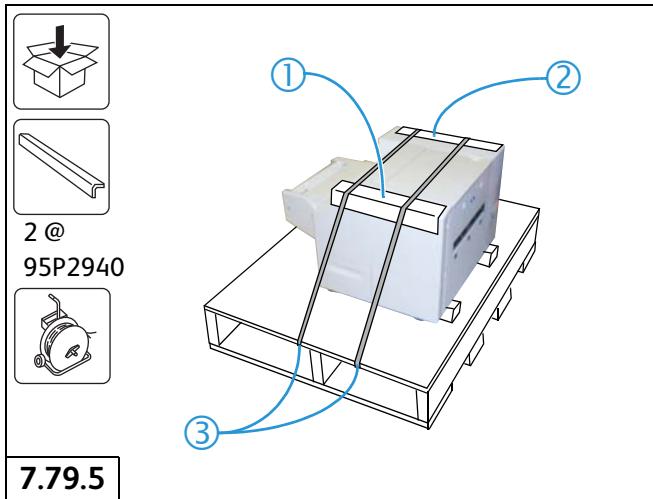
7.79.3 Roll the Integrated SquareFold® Trimmer onto the pallet.



WARNING: Due to the size and weight of the Integrated SquareFold® Trimmer, two people are required to position the wooden blocks under the front and rear bottom of the module.

Note: When positioning the wooden blocks under the Integrated SquareFold® Trimmer, ensure to position them just inside the casters.

7.79.4 ① Lift the front and ② rear of the Integrated SquareFold® Trimmer and ③ position a wooden block (501E3500W) under each end of the module.

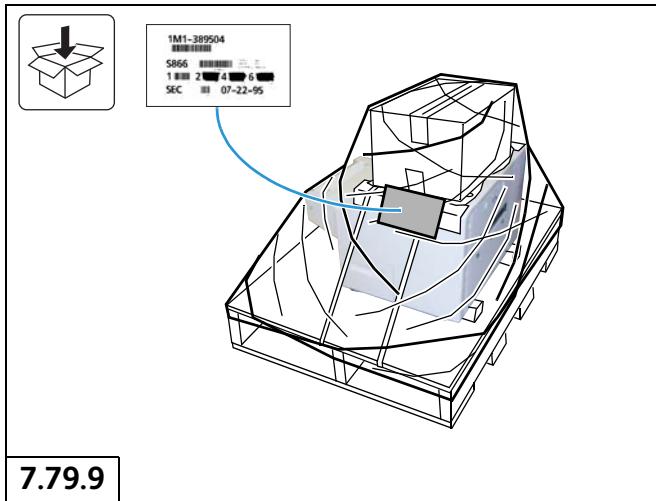


7.79.5 ① Place a cornerboard (95P2940) along the top front and ② rear edges of the module.
 ③ Secure the Integrated SquareFold® Trimmer to the pallet with two bands.

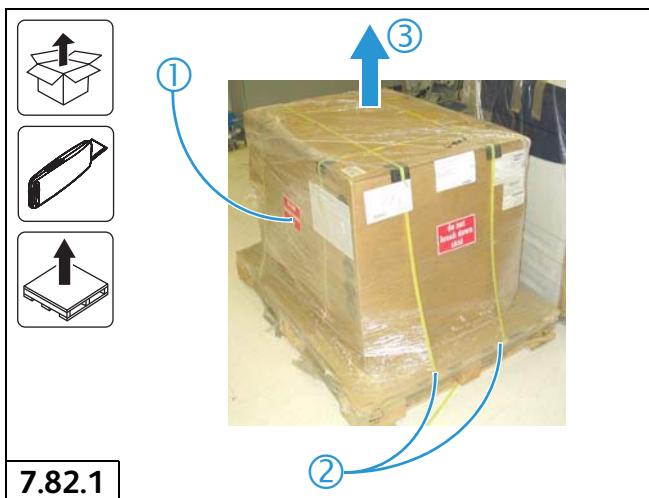
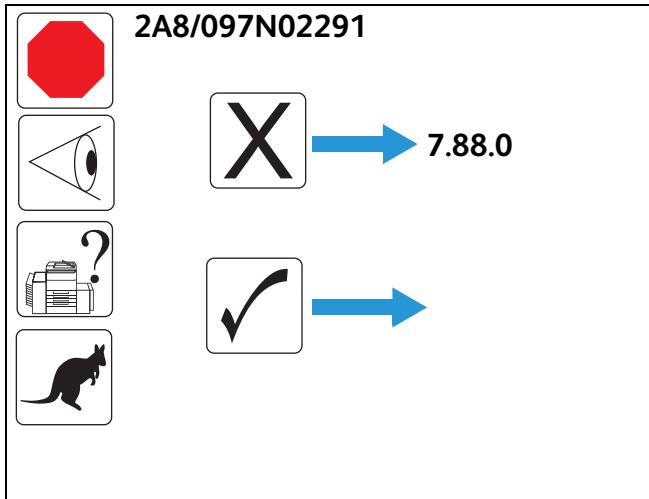
7.79.6 ① Place a layer of bubblepack on top of the Integrated SquareFold® Trimmer and ② place the box containing the miscellaneous items on top of the Integrated SquareFold® Trimmer.

7.79.7 Secure items on the pallet with stretchwrap.

7.79.8 Generate the bar code label. Cross off the non-applicable codes.



7.79.9 Apply the bar code label to the stretchwrap at the open end of the pallet.



7.80.0 Accessory K: Delivery - Preparing the EFI™ Standalone NX Premium DFE (2A8/097N02291)

Stop: If an EFI™ Standalone NX Premium DFE (2A8/097N02291) is not present, go to 7.88.0 “Accessory L: Delivery - Preparing the Partner Finishing Interface Module (PFIM) (XMH/097S04171) (if present)” on page 140. If an EFI™ Standalone is present, continue onto the next step.

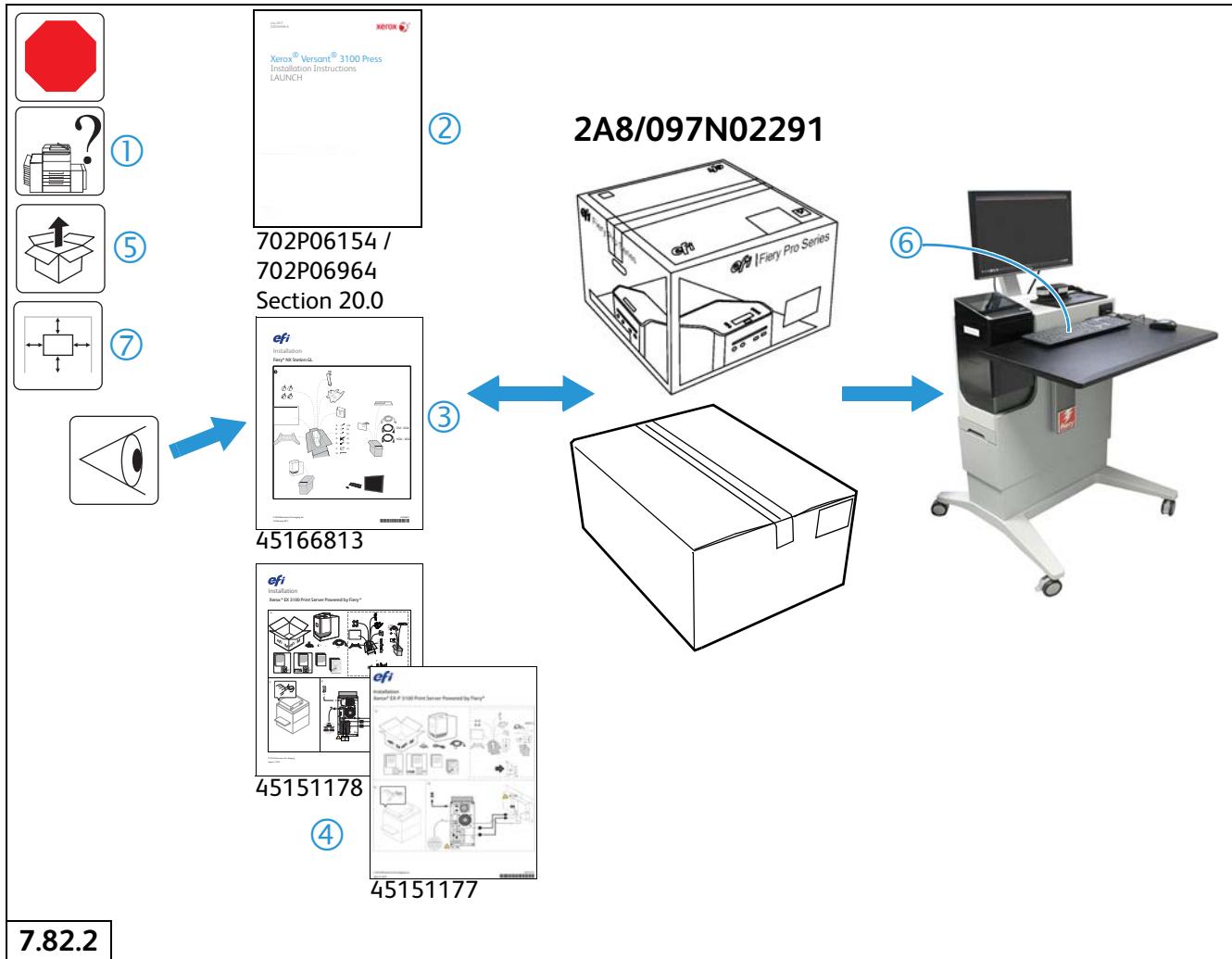
7.81.0 Delivery - Strapping the EFI™ Standalone NX Premium DFE

Note: Due to the size of the fully packaged EFI™ Standalone NX Premium DFE, no straps are required.

7.81.1 Place the fully packaged EFI™ NX Premium DFE on the floor against the wall of the truck.

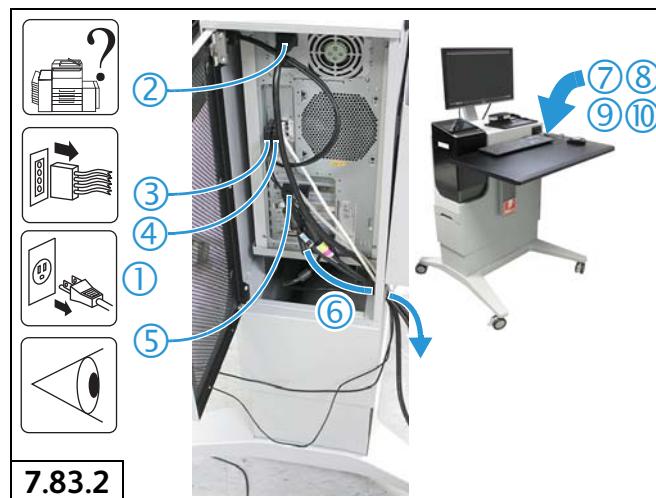
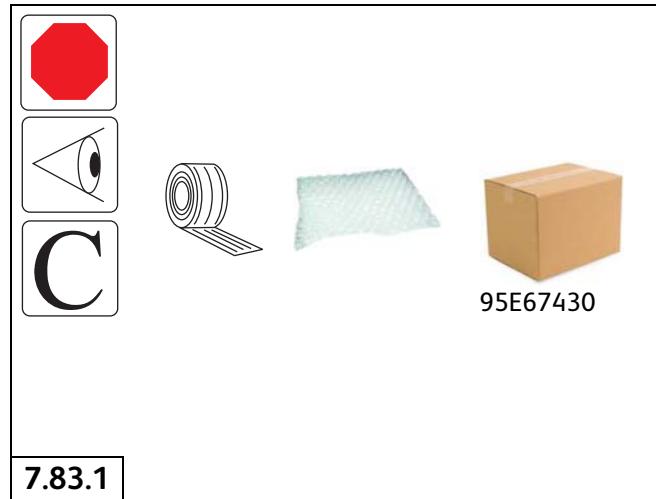
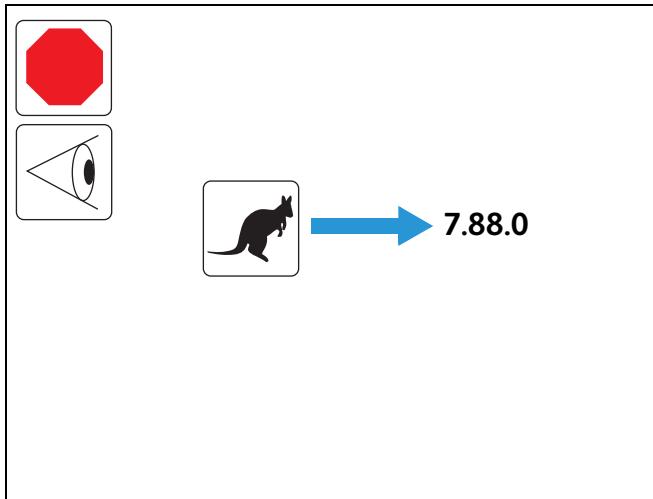
7.82.0 Unpack, Install, and Position the EFI™ Standalone NX Premium DFE (if present)

7.82.1 If the EFI™ NX Premium DFE stand is present, ① cut and remove the stretch-wrap and ② bands from around the palletized boxes.
③ Remove the two boxes from the pallet.



Stop: The Carrier unpacks, assembles and positions the EFI™ Standalone NX Premium DFE only. The CSE will get the DFE connected and up and running.

7.82.2 ① If the EFI™ Standalone NX Premium DFE (2A8/097N02291) is present, **②** use the Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964), **③** Fiery NX Station GL (45166813) (if required) **④** the EFI™ NX Premium DFE Installation Instructions (45151178 or 45151177) packed with the controller box to **⑤** unpack, **⑥** install, and **⑦** position next to the assembled system.



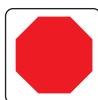
Stop: Once the EFI™ NX Premium DFE has been positioned, go to 7.88.0.

7.83.0 Relocation for an EFI™ Standalone NX Premium DFE



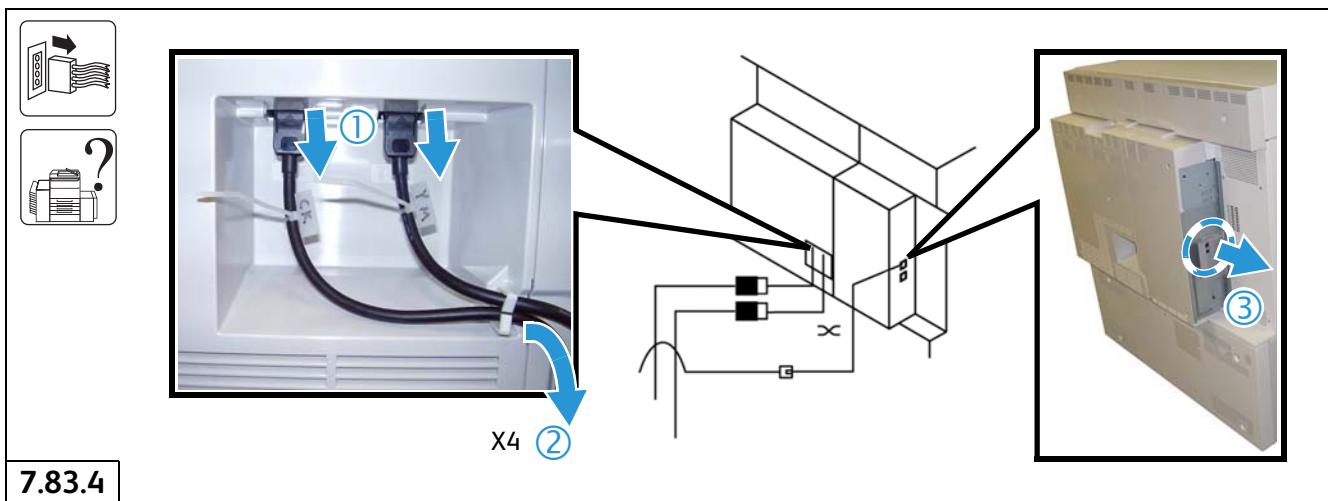
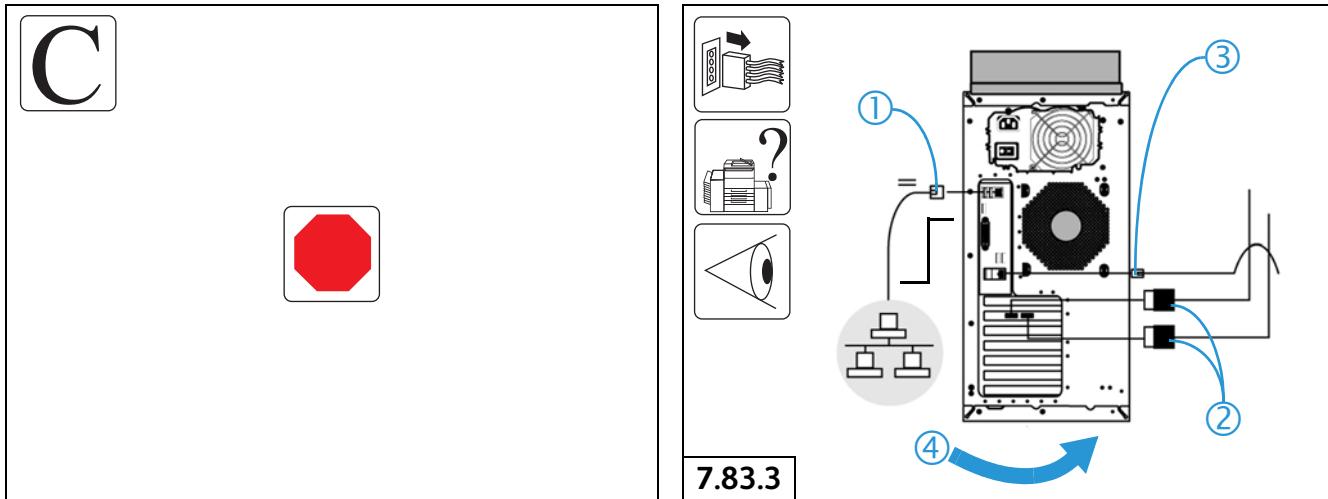
Stop: When packing the EFI™ NX Premium DFE, ensure the network cable does not get packed with the DFE. This cable remains with the Customer.

7.83.1 Materials required to pack the EFI™ NX Premium DFE are shown.



Stop: The CSE will power the EFI™ NX Premium DFE controller off and disconnect the power cord from the wall receptacle.

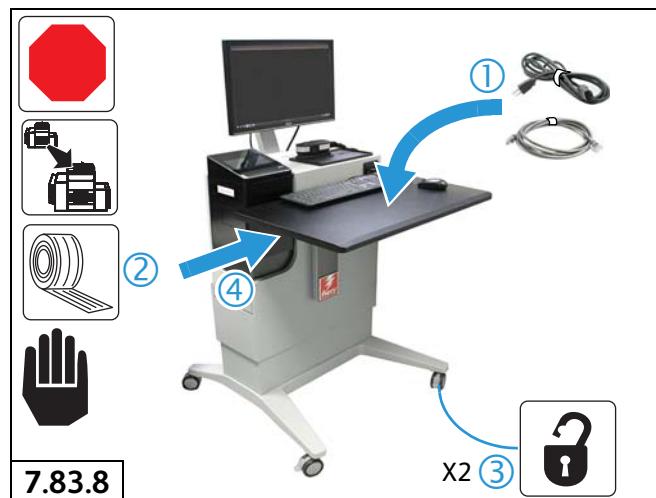
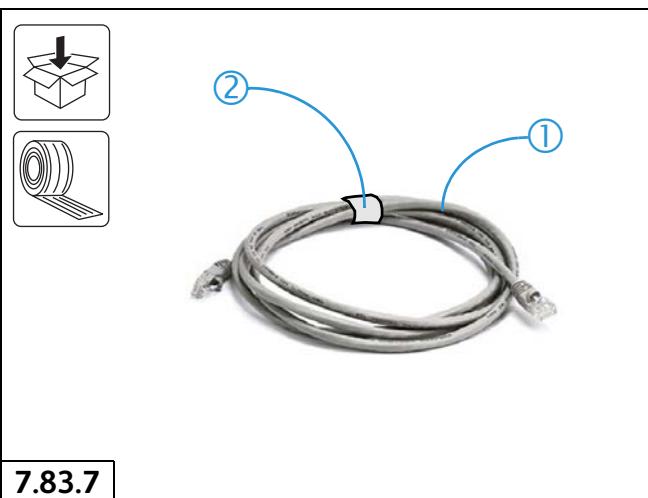
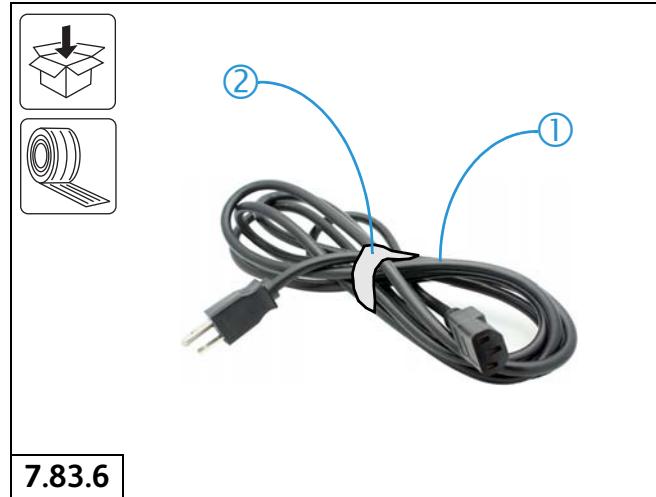
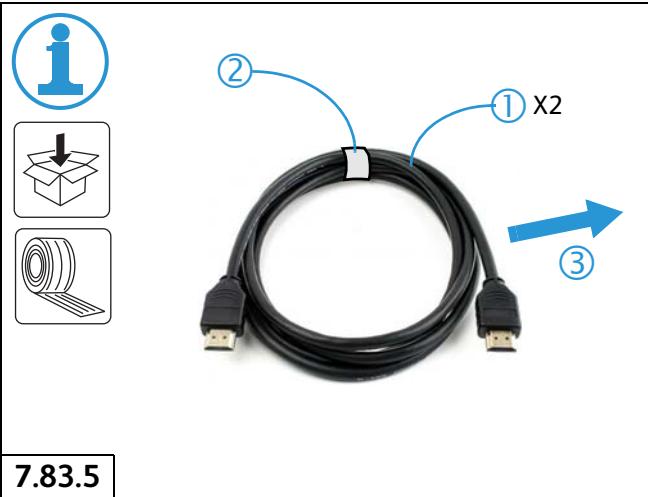
7.83.2 If required, ① disconnect the controller power cord from the wall outlet and ② then from the controller. Disconnect ③ the keyboard cable ④ mouse cable and ⑤ and other cable(s) (if present) from the rear of the controller. ⑥ Route them out through the hole in the rear panel and ⑦ place disconnected keyboard cable, ⑧ mouse cable, ⑨ monitor interface cable and ⑩ power cord on top of EFI™ stand.



 Stop: Ask the Customer to disconnect the DFE network cable from their network.

7.83.3 ① Disconnect the network, ② Printer interface cables (2) (CK and YM), ③ and Ethernet cable from the DFE controller. ④ Close the right side cover

7.83.4 ① Disconnect the Color Interface cables (2) (CK and YM) and ② remove them from the rear cable clips (4) on the rear of the IOT. Disconnect the ③ Ethernet cable from the rear middle of IOT Left.



Note: Color Interface cables are to be shipped with the IOT Left module.

7.83.5 ① Coil and ② tape the Color Interface cables. ③ Place these cables with the IOT Left for the move.

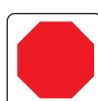
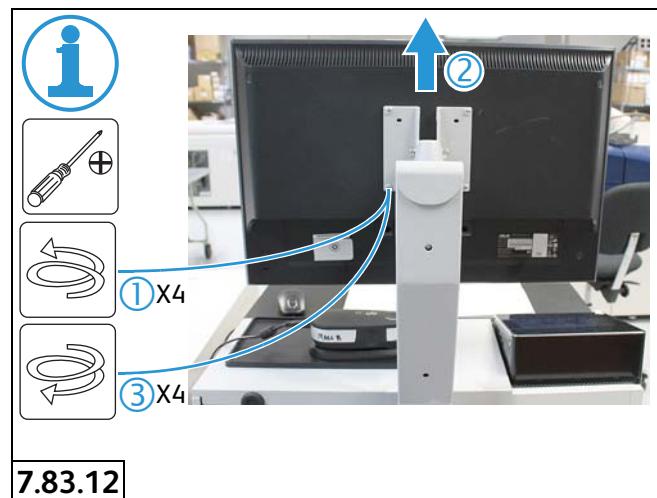
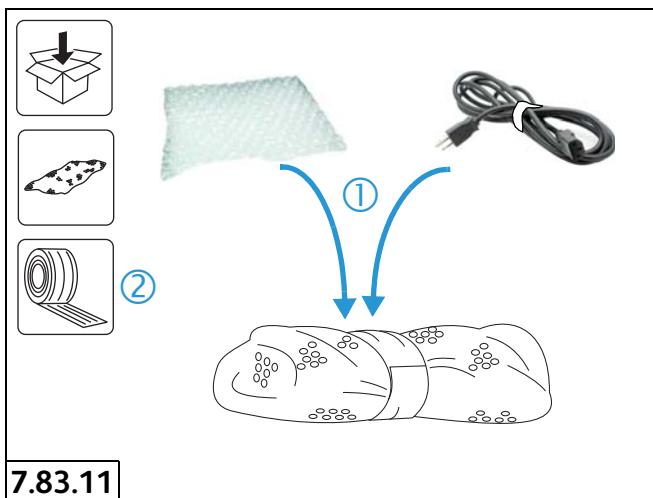
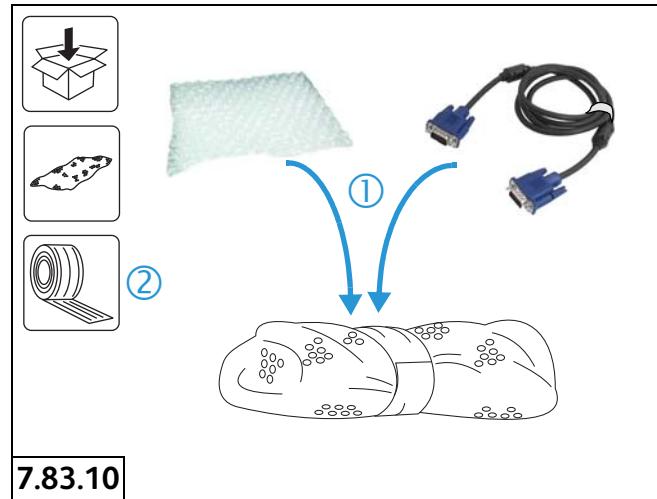
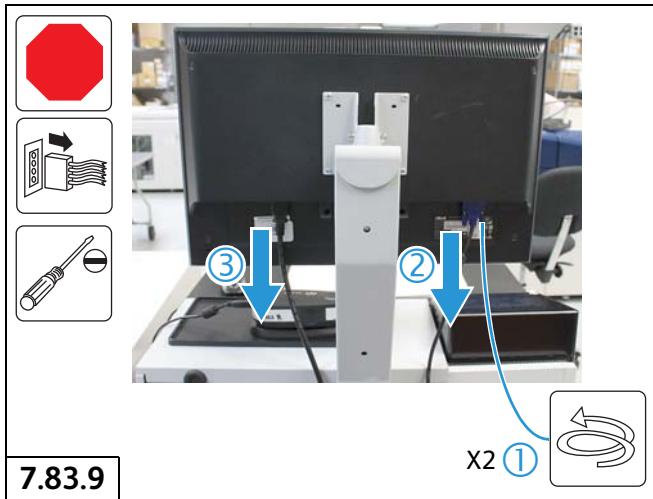
7.83.6 ① Coil and ② tape the power cord.

7.83.7 ① Coil and ② tape the Ethernet cable.



Stop: If the relocation is within the same building, place the coiled cable on top of the EFI™ stand work shelf for the move.

7.83.8 ① Place all coiled cables on top of the EFI™ stand and ② secure them in place with tape. ③ unlock the stand casters and ④ move the EFI™ NX Premium DFE to the new locations.



Stop: If the relocation is to another building or if this is a return, cables, keyboard and mouse will need to be packed up in a generic box.

7.83.9 ① Unscrew and ② disconnect the monitor interface cable from the rear of the monitor.
③ Disconnect the monitor power cord from the rear of the Monitor.

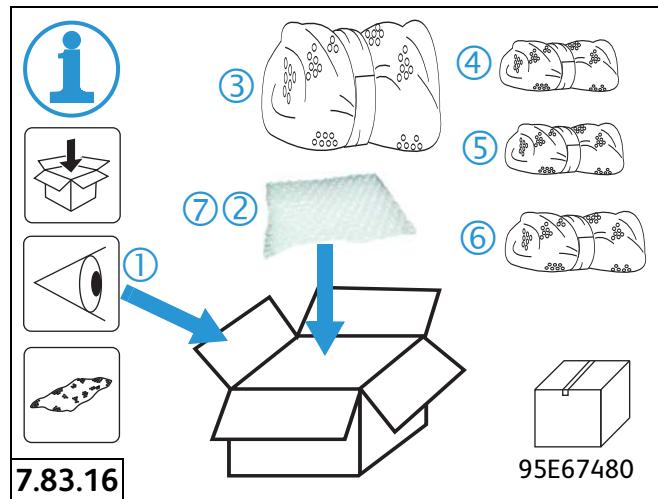
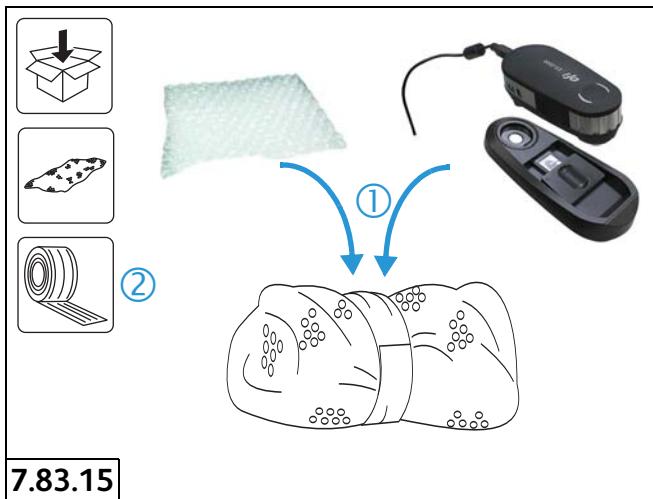
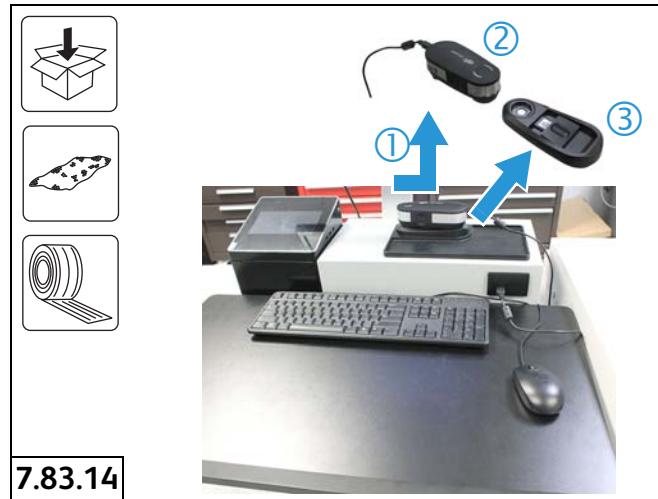
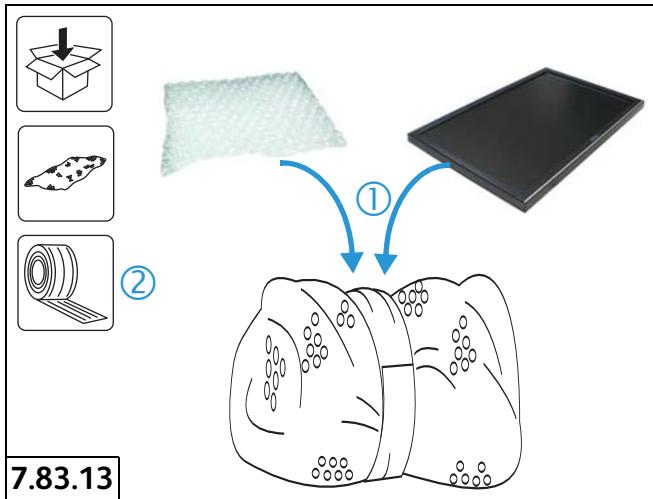
7.83.10 ① Wrap the monitor interface cable in a pieces of bubblepack and ② secure it with tape.

7.83.11 ① Wrap the monitor power cord in a pieces of bubblepack and ② secure it with tape.



Note: Mounting screws (4) need to be reinstalled in the rear of the monitor so that they do not get lost.

7.83.12 ① Remove the screws (4) securing the monitor to the stand monitor mount and
② remove the monitor. ③ Reinstall the screws (4) back into the rear of the monitor.



7.83.13 ① Wrap the monitor in a piece of bubblepack and ② secure with tape.

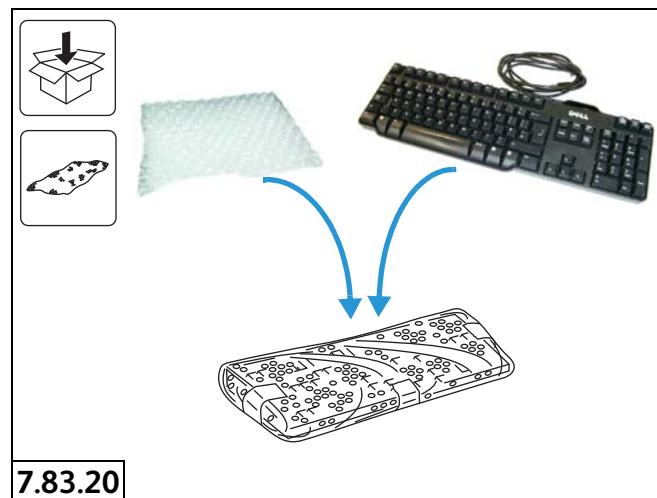
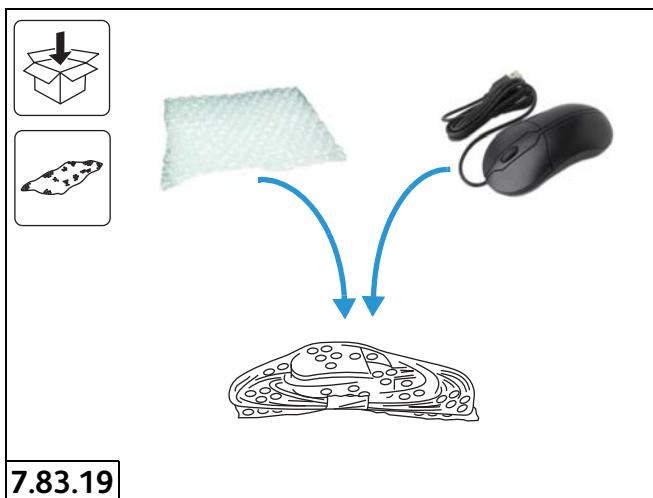
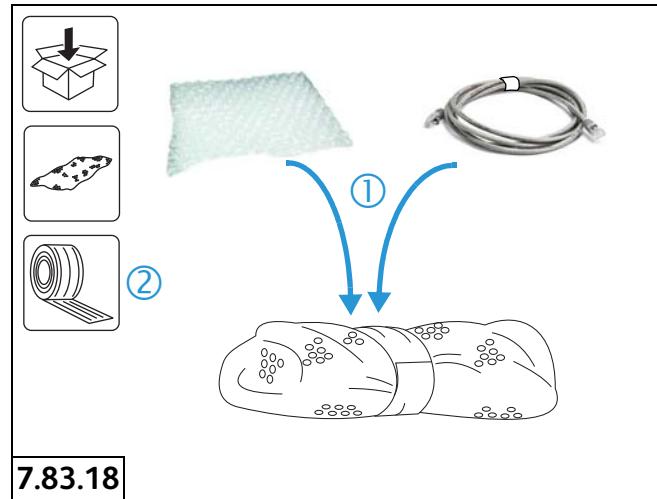
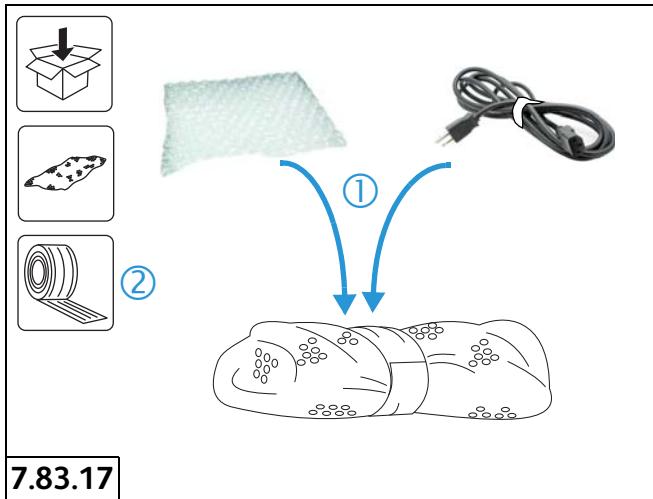
7.83.14 If a Spectrophotometer is present,
① slide the Spectrophotometer to the right and
② remove it from the top of the stand. ③ Remove
the Spectrophotometer carriage from the top of
the stand.

7.83.15 ① Wrap both the Spectrophotometer and
② carriage in a piece of bubblepack and secure
with tape.



Note: When placing the monitor in the
box ensure it is placed screen down.

7.83.16 ① Retrieve a generic box (95E67480) and
② place a layer of bubblepack in the bottom of
the box. ③ Place the bubblepack monitor,
④ interface cable and ⑤ power cord in the box.
⑥ and Spectrophotometer. Then, ⑦ cover items
with a layer of bubblepack.

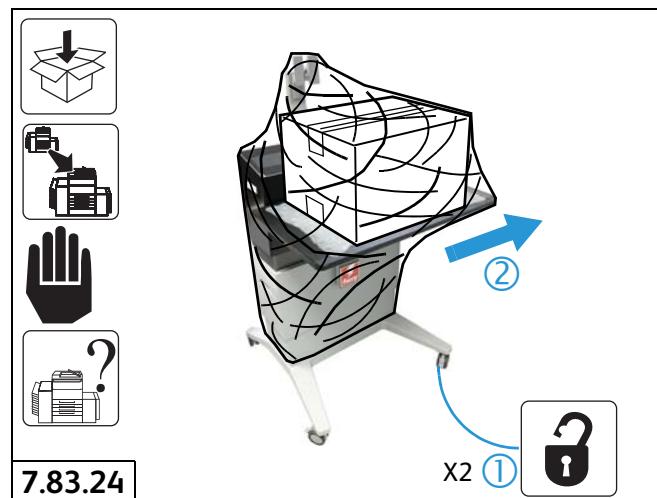
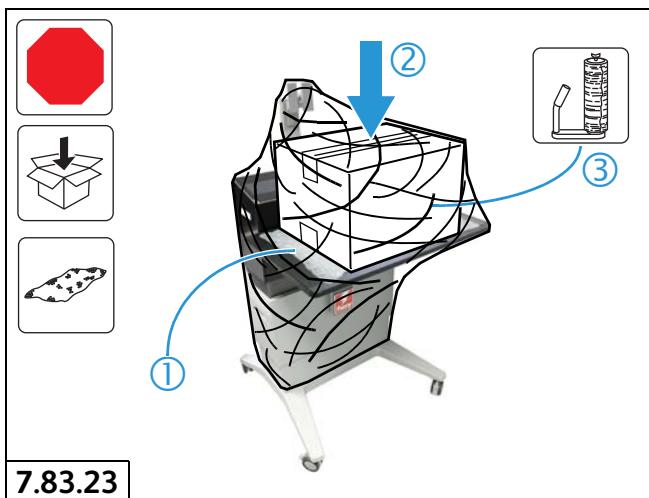
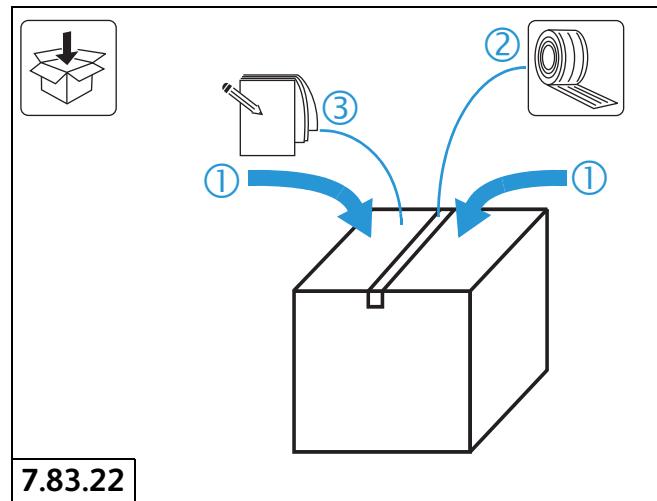
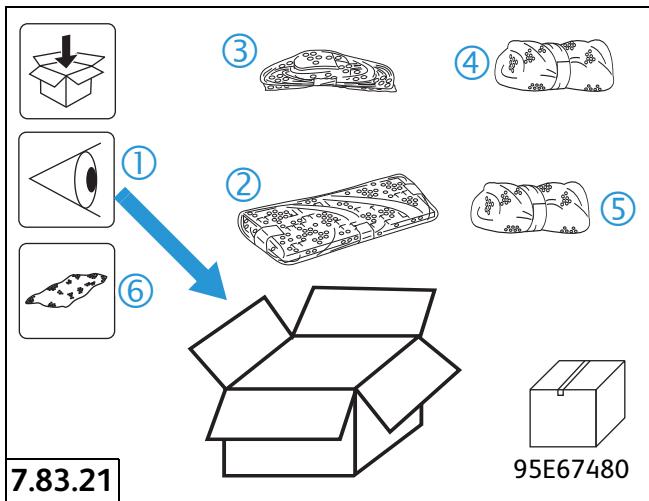


7.83.17 Wrap the power cords in a piece of bubblepack and secure with tape.

7.83.18 Wrap the Ethernet cable in a piece of bubblepack and secure with tape.

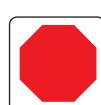
7.83.19 Wrap the mouse in a piece of bubblepack.

7.83.20 Wrap the keyboard in a piece of bubblepack.



7.83.21 ① Place the bubblepacked ② keyboard, ③ mouse, ④ power cord and ⑤ Ethernet cable in a generic box (95E67480). ⑥ Fill all voids with bubblepack.

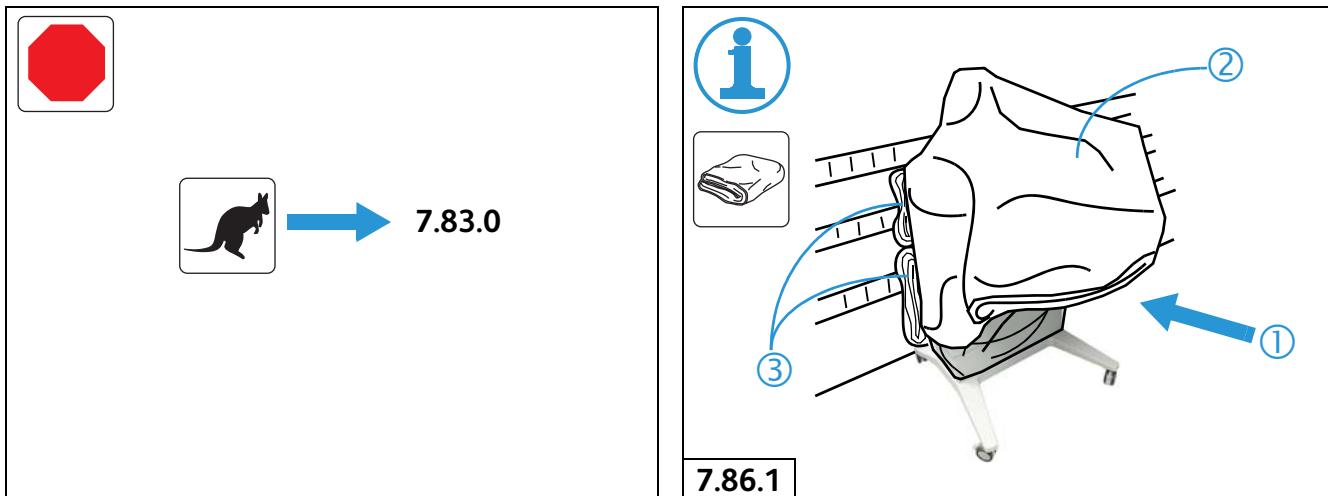
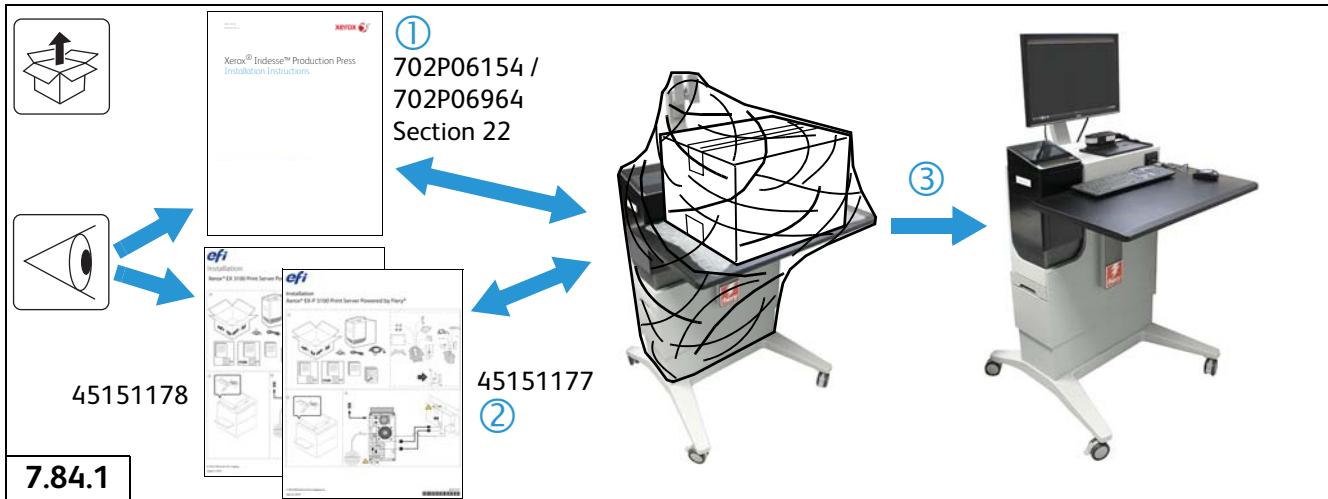
7.83.22 ① Close and ② tape the box. ③ Write the contents on the outside of the box.



Stop: Please ensure that the box containing the monitor, keyboard, mouse, Spectrophotometer and cables stays with the EFI™ NX Premium DFE stand.

7.83.23 ① Place a layer of bubblepack on the stand top surface and ② place the box containing the EFI™ NX Premium DFE items on the bubblepack. ③ Secure the box in place by covering the stand with a layer of bubblepack.

7.83.24 ① Unlock the stand casters and ② move the EFI™ NX Premium DFE to the new locations or truck.



7.84.0 Reinstall - EFI™ Standalone NX Premium DFE

7.84.1 ① Refer to the Xerox® Iridesse™ Carrier Procedures Manual Installation Instructions (702P06154 / 702P06964) or ② the install procedures (45151177 or 45151178) for ③ unpacking and reinstalling the EFI™ NX Premium DFE.

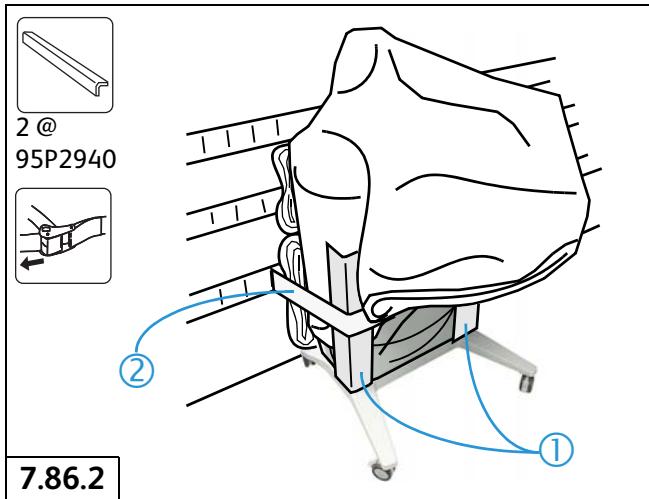
7.85.0 Removal - EFI™ Standalone NX Premium DFE

Stop: Perform all steps in 7.83.0 "Relocation for an EFI™ Standalone NX Premium DFE" on page 7-130, except for 7.84.0 "Reinstall - EFI™ Standalone NX Premium DFE" on page 7-137.

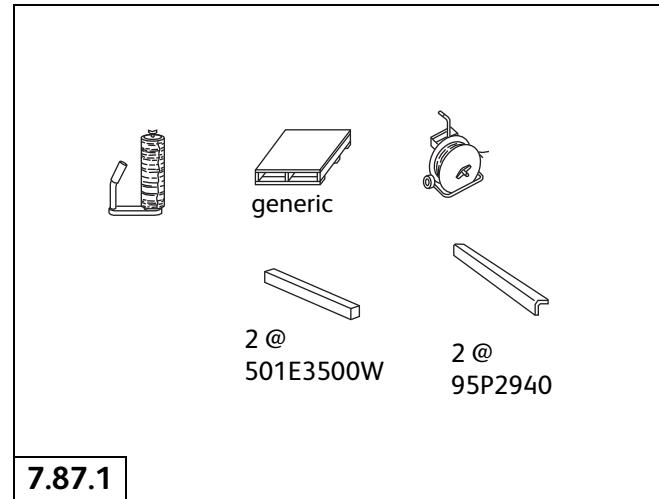
7.86.0 Strapping the EFI™ Standalone NX Premium DFE

Note: When positioning the EFI™ stand in the truck, ensure the rear of the stand is positioned against the wall of the truck and that folded blankets are positioned between the wall and the stand to fill the gap prior to strapping.

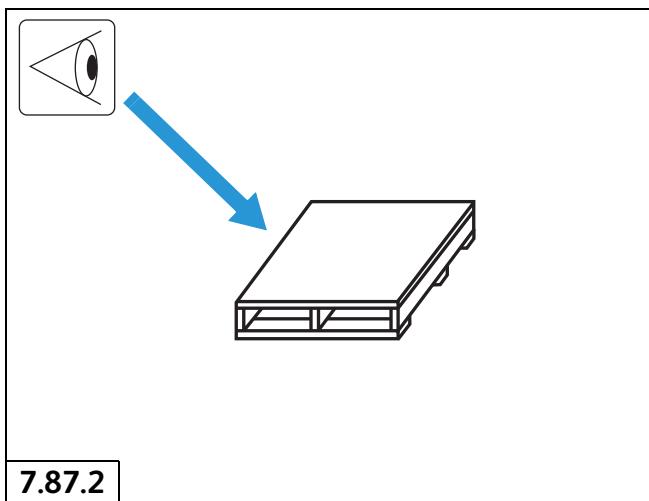
7.86.1 ① Position the EFI™ stand against the wall of the truck and ② cover the stand with a blanket. ③ Fill the void between the wall and the stand with a couple folded blankets.



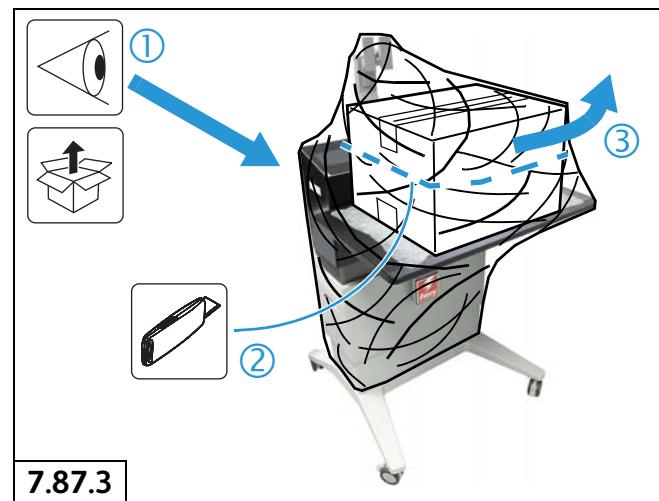
7.86.2



7.87.1



7.87.2



7.87.3

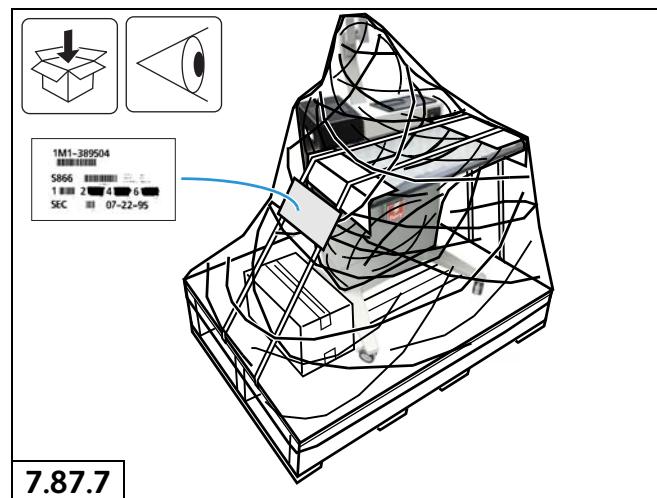
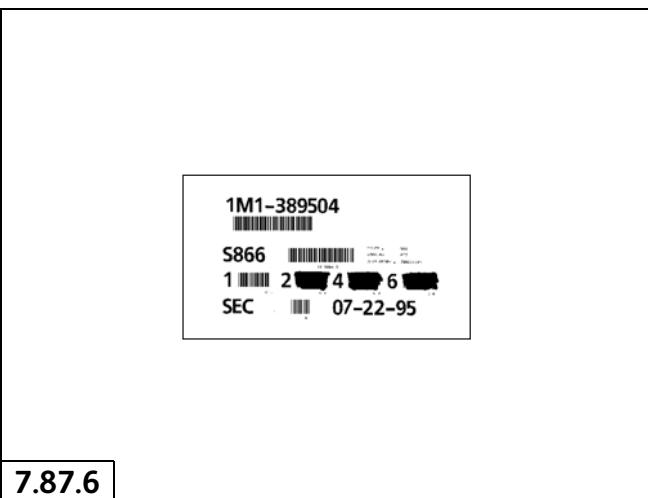
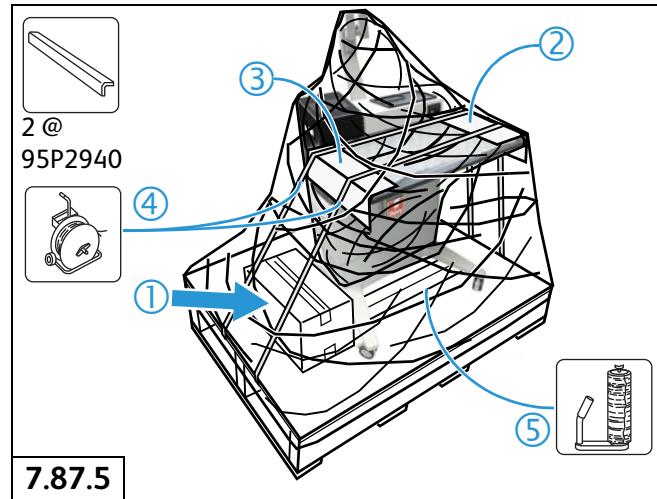
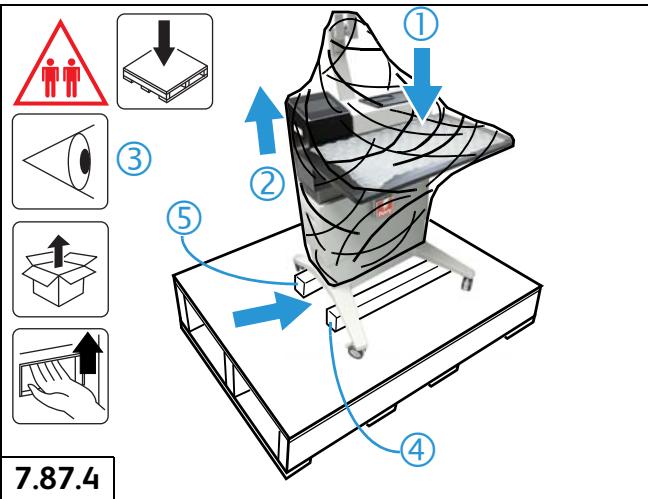
7.86.2 ① Place cornerboards on the front two corners of the stand base and ② strap the stand into the truck.

7.87.0 Return - EFI™ Standalone NX Premium DFE

7.87.1 Materials required for a return of an EFI™ NX Premium DFE are shown.

7.87.2 Retrieve a generic pallet similar in size.

7.87.3 ① Retrieve the boxed EFI™ NX Premium DFE controller stand. ② Cut an opening in the stretchwrap from around the top of the stand and ③ remove the boxed items from the top of the stand.



 **WARNING:** Due to the size and weight of the EFI™ stand, two people are required to lift and place the stand on the generic pallet and then position the blocks under the stand.

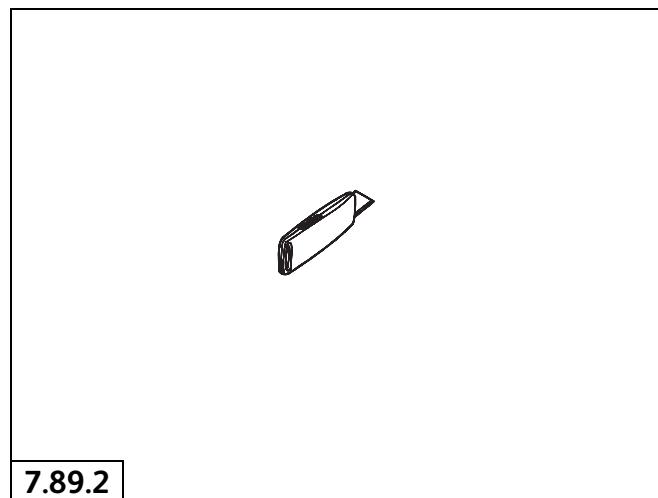
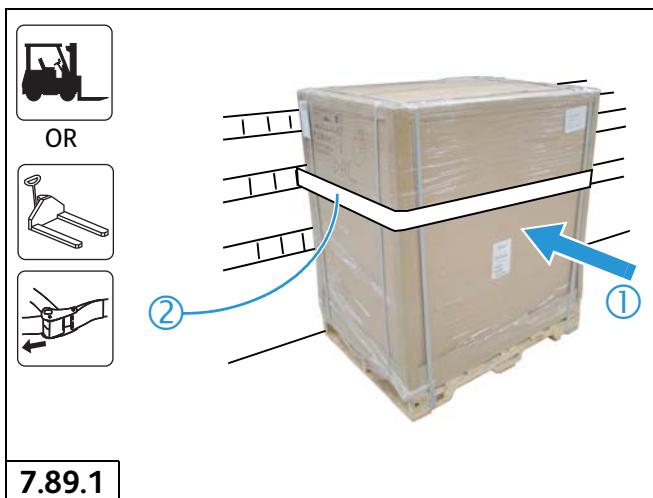
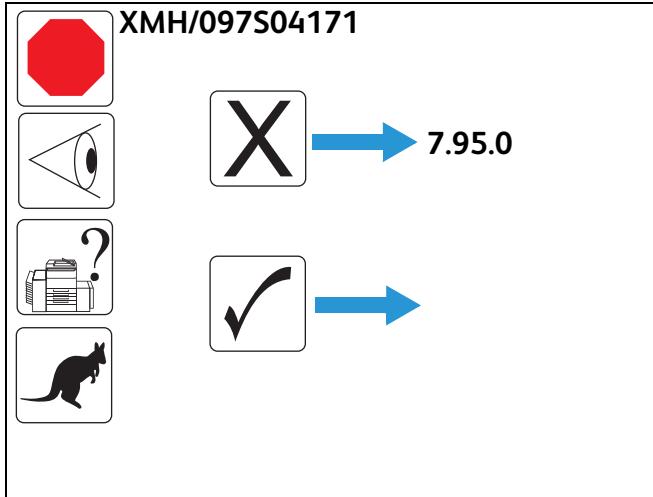
7.87.4 ① Place the stretchwrapped EFI™ stand on the generic pallet. ② Lift the stand and ③ position the blocks (2), left to right, under the stand just inside the casters, ④ one in the front and ⑤ one in the rear.

7.87.5 ① Place the boxed EFI™ NX Premium DFE items alongside the EFI™ stand. ② Place corner-boards on the right and ③ left sides of the EFI™ top surface. ④ Secure the stand to the pallet with

two bands. ⑤ Secure all palletized items on the pallet by using a layer of stretchwrap.

7.87.6 Generate the bar code label. Cross off the non-applicable codes.

7.87.7 Apply the bar code label to the stretchwrap at the open end of the pallet.



7.88.0 Accessory L: Delivery - Preparing the Partner Finishing Interface Module (PFIM) (XMH/097S04171) (if present)

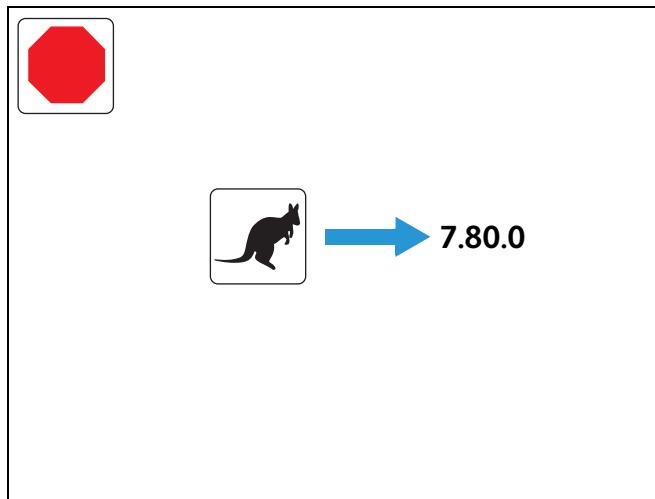
Stop: If a PFIM is not present, go to 7.95.0 "Accessory M: Delivery - Unpack and Position the CCU Cart (if present)" on page 7-147. If a PFIM is present, continue onto the next step.

Stop: If a PFIM is present, **do not** unpack and/or depalletize the module at the warehouse. The PFIM should be delivered to the Customer location fully packaged.

7.89.0 Strapping Procedures

7.89.1 ① Position the fully packaged PFIM against the wall of the truck and ② strap it in place.

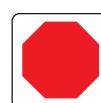
7.89.2 Tool used to unpack the PFIM is shown.



Stop: The Carrier is responsible for unpacking and depalletizing the PFIM at the Customer site. Once depalletized the Carrier is responsible for positioning the module to the right of the Production Ready Finisher. It is the responsibility of the CSE to dock, level, make electrical connections, and get the module up and running.



7.89.3 ① Unpack, ② depalletize, and ③ position the PFIM (XHM/097S04171) to the right of the PR Finisher (5AE/097S04751) using the ④ Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964).



Stop: Go to 7.80.0 "Accessory K: Delivery - Preparing the EFI™ Standalone NX Premium DFE (2A8/097N02291)", on page 7-128.



7.90.1



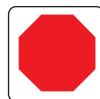
7.90.2



7.90.3

7.90.0 Relocation - Prepare the PFIM for the Move

7.90.1 Materials required for preparing the PFIM for a Relocation/Removal are shown.



Stop: It is the responsibility of the CSE to disconnect all cables, power cords, and undock the PFIM from the PR Finisher.

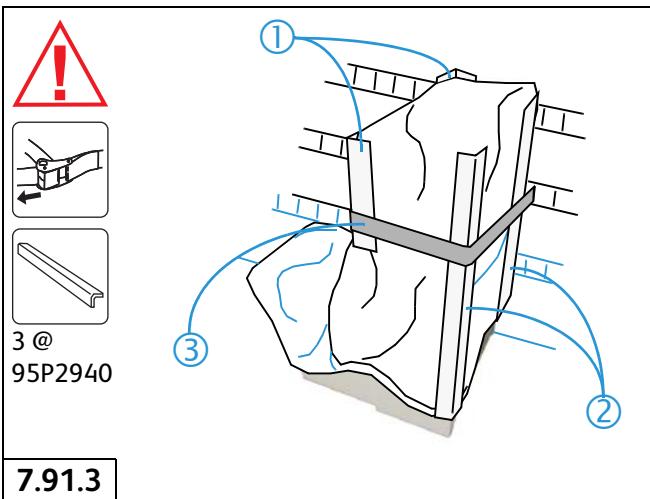
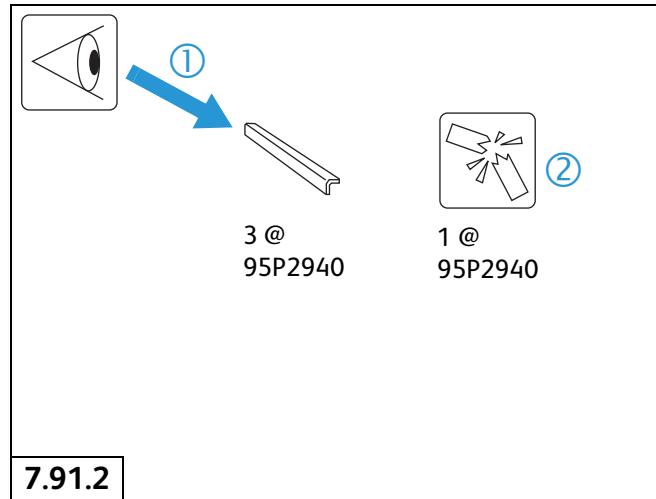
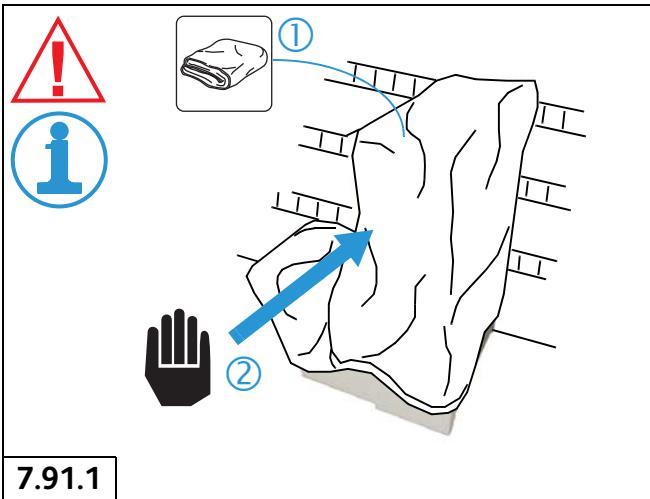
7.90.2 Tape the front cover of the module closed.



CAUTION: Due to fixed casters being on the right side of the module, please take extra care when moving the PFIM.

Note: The casters on the right side of the module are fixed and casters on the left side are swivel.

7.90.3 Carefully move the PFIM to the new location or truck.



7.91.0 Strapping the PFIM



CAUTION: When placing the PFIM in the truck, ensure the rear side of the module is positioned against the wall of the truck.



Note: When covering the PFIM with the blanket, ensure that the blanket is positioned between the rear side of the module and the wall of the truck.

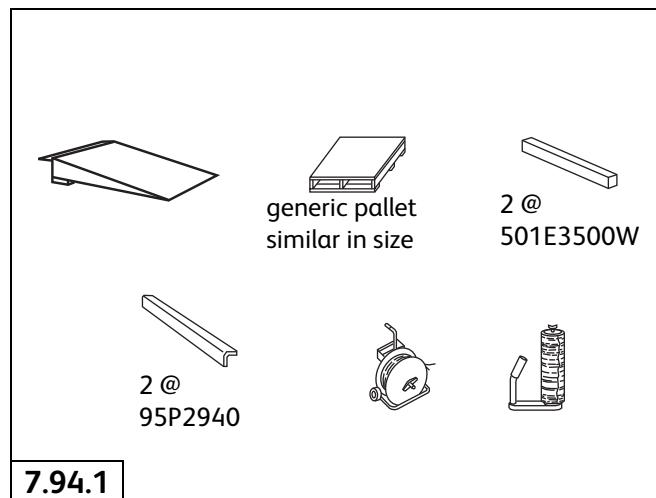
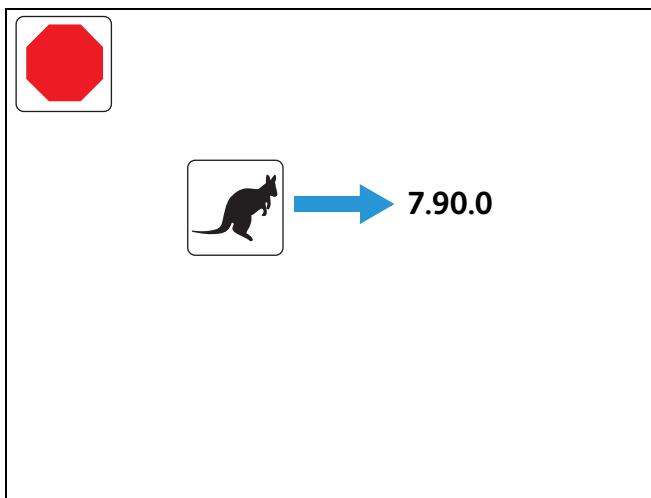
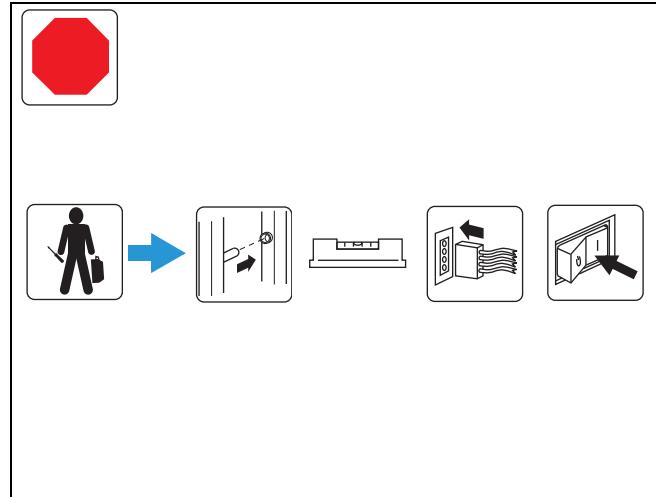
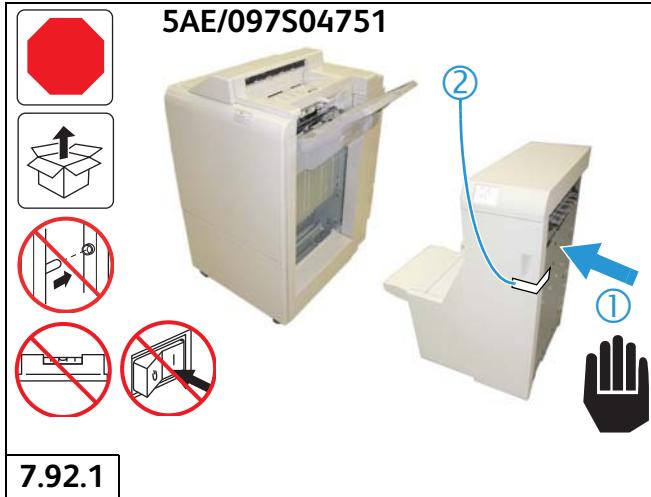
7.91.1 ① Cover the PFIM with a blanket and ② then position the module against the wall of the truck.

7.91.2 ① Retrieve three cornerboards and ② break one into two equal lengths.

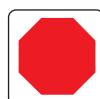


CAUTION: When strapping the PFIM into the truck, ensure to run the strap around the upper part of the module. Do not over tighten strap when securing into the truck.

7.91.3 ① Place the two smaller cornerboards on the front and rear edges of the upper left side. ② Place the two larger cornerboards on the front and rear edges on the right side. ③ Strap the module around the top into the truck.

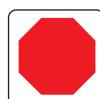


7.92.0 Reinstalling the PFIM



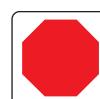
Stop: Carriers are not responsible for docking, leveling, connecting, or getting this module up and running.

- 7.92.1 ① Position the PFIM to the right of the finisher. ② Remove the tape securing the PFIM front cover.



Stop: It is the responsibility of the CSE to dock, level, connect and get the PFIM up and running.

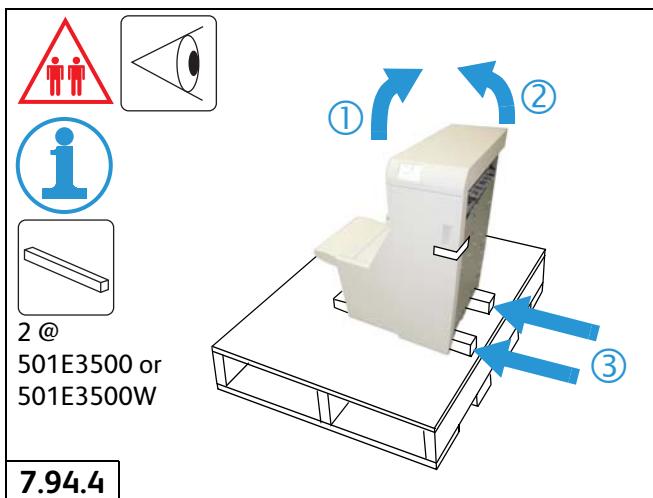
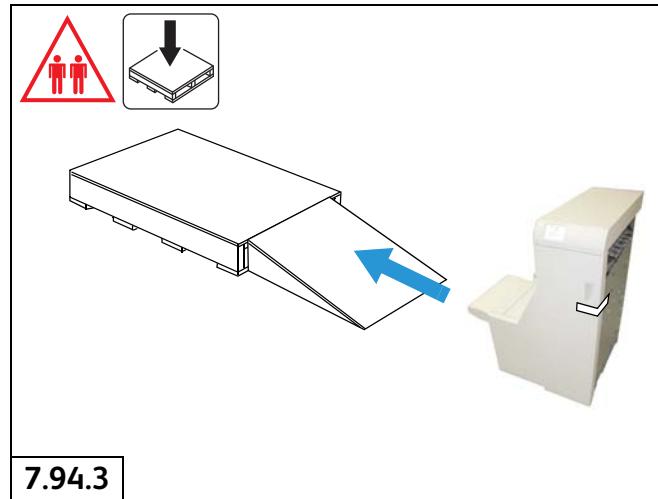
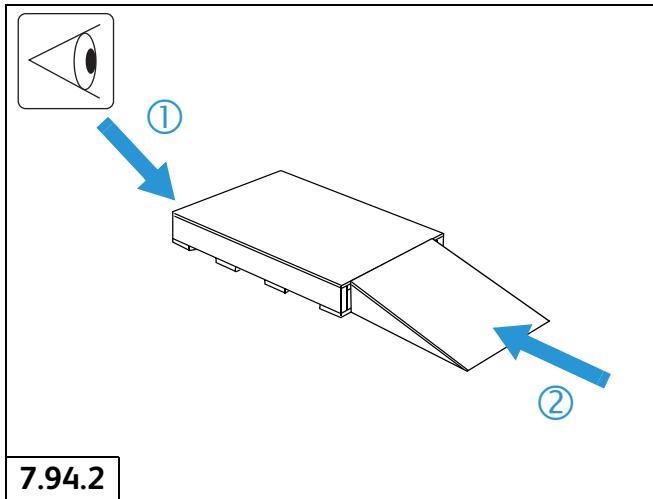
7.93.0 Removal - Preparing the PFIM



Stop: Perform all steps in 7.90.0 "Relocation - Prepare the PFIM for the Move" on page 7-142 except for 7.92.0 "Reinstalling the PFIM" on page 7-144.

7.94.0 Return - Preparing the PFIM

- 7.94.1 The tool and materials required to palletize the PFIM are shown.



7.94.2 ① Retrieve a generic pallet similar in size and ② place a ramp at one end of it.

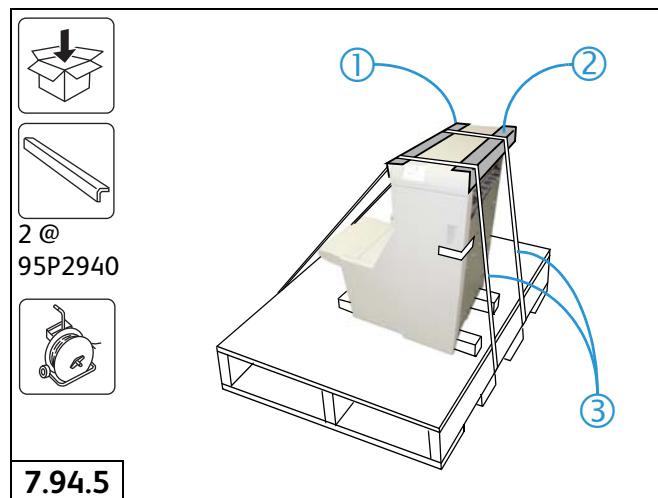


WARNING: Due to the size and weight of the PFIM, two people are required to palletize the module.

7.94.3 Roll the PFIM onto the pallet.



WARNING: Due to the size and weight of the PFIM, two people are required to position the wooden blocks under the front and rear bottom of the module.

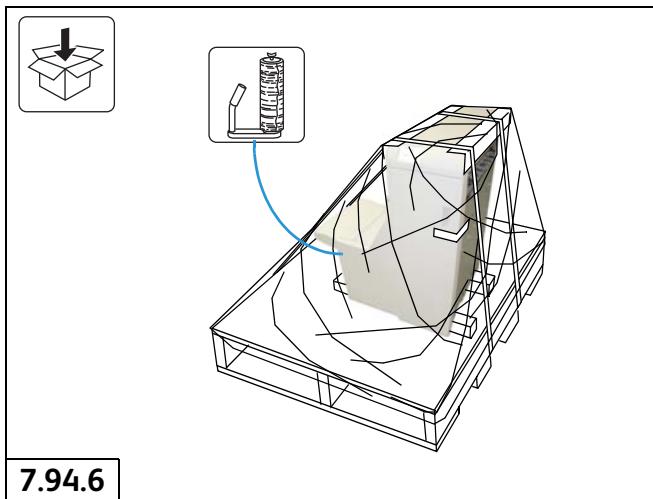


7.94.5

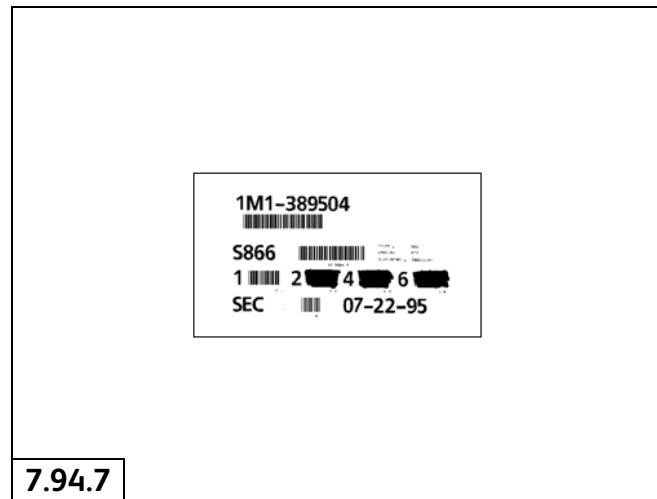
Note: When positioning the wooden blocks under the PFIM, ensure to position them just inside the casters.

7.94.4 ① Lift the front and ② rear of the PFIM and ③ position a wooden block (501E3500 or 501E3500W) under each end of the module.

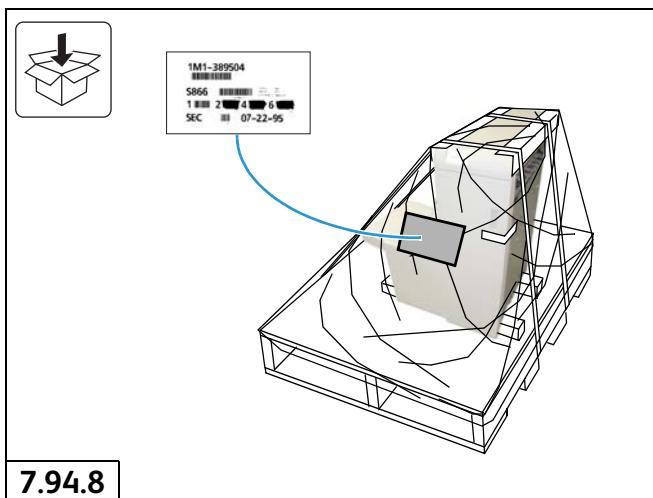
7.94.5 ① Place a cornerboard (95P2940) on the top left and ② right edges of the module.
③ Secure the PFIM to the pallet with two bands.



7.94.6



7.94.7

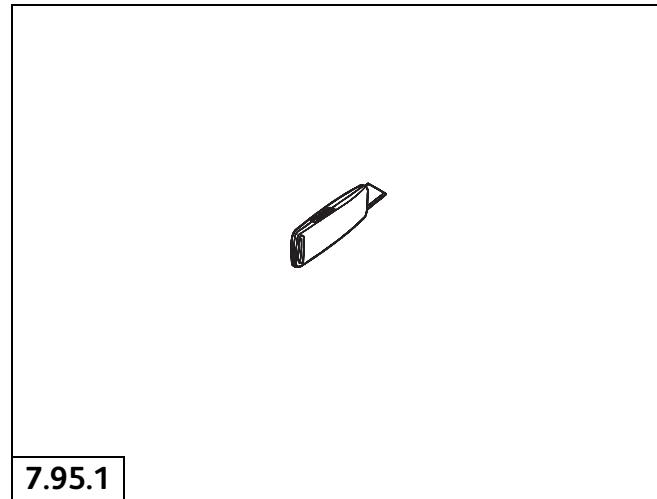
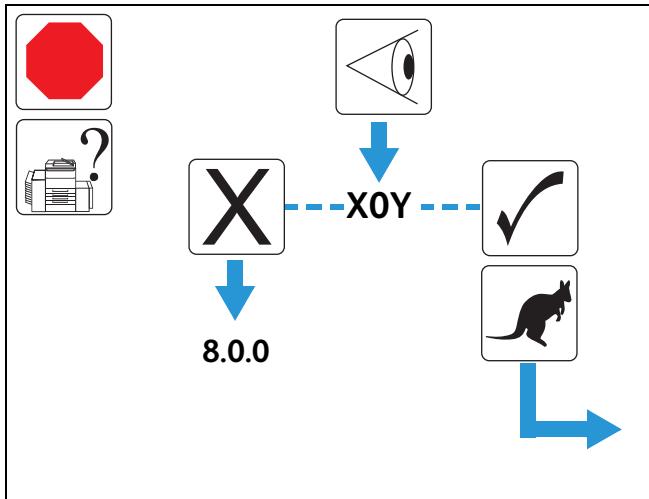


7.94.8

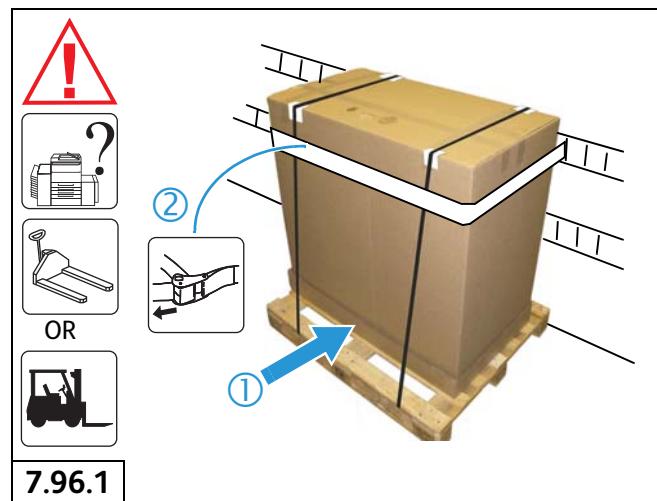
7.94.6 Cover the PFIM with a layer of stretchwrap.

7.94.7 Generate the bar code label. Cross off the non-applicable codes.

7.94.8 Apply the bar code label to the stretchwrap at the open end of the pallet.

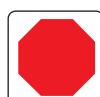


7.95.1



7.96.1

7.95.0 Accessory M: Delivery - Unpack and Position the CCU Cart (if present)



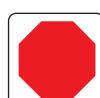
Stop: If a CCU Cart (X0Y) is not present, go to "Section 8" on page 8-1. If a CCU Cart is present, continue onto the next step.



CAUTION: When securing the CCU Cart to the wall of the truck, ensure not to over-tighten the strap.

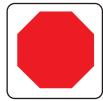
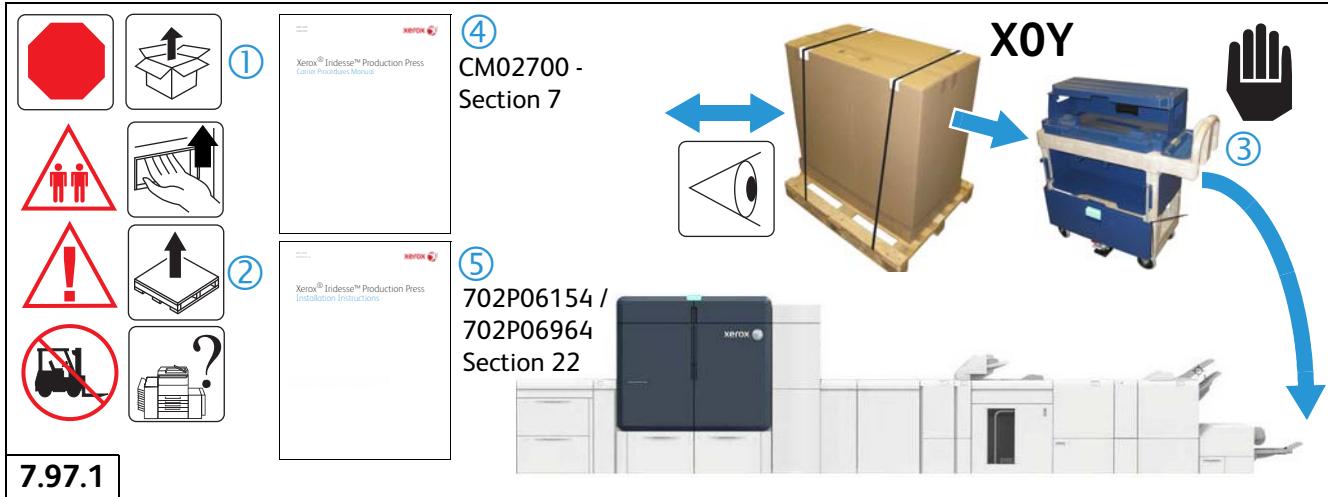
7.95.1 The tool required to unpack and position the CCU Cart is shown.

7.96.0 Strapping the CCU Cart



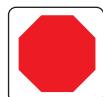
Stop: The CCU Cart should be delivered to the Customer location fully packaged.

7.96.1 **If a CCU Cart is present:** ① Place the palletized cart module against the wall of the truck and ② secure with a single strap.



7.98.1

7.97.0 Unpack and Position the CCU Cart (if present)



Stop: Carrier is responsible for unpacking and positioning the CCU Cart only.



WARNING: Due to the size and weight of the CCU Cart, two people will required to depalitize the module.

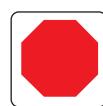


CAUTION: When lifting the cart be sure to lift using the cart frame. Do not lift using the covers.

7.97.1 ① Unpack, ② depalitize, and ③ position the CCU Cart (X0Y) to the IOT Right Module using ④ procedures in Section 7 of the Xerox® Iridesse™

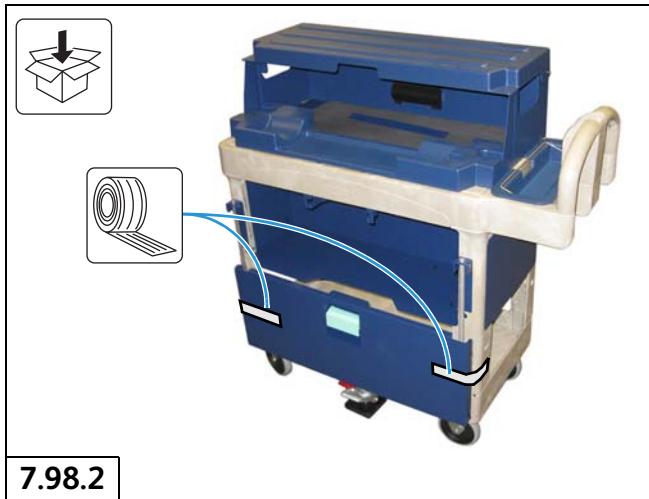
Production Press Carrier Manual and 'Section 22' of the ⑤ Xerox® Iridesse™ Production Press Installation Instructions (702P06154 / 702P06964).

7.98.0 Relocation/Removal - Preparing the CCU Cart (if present)

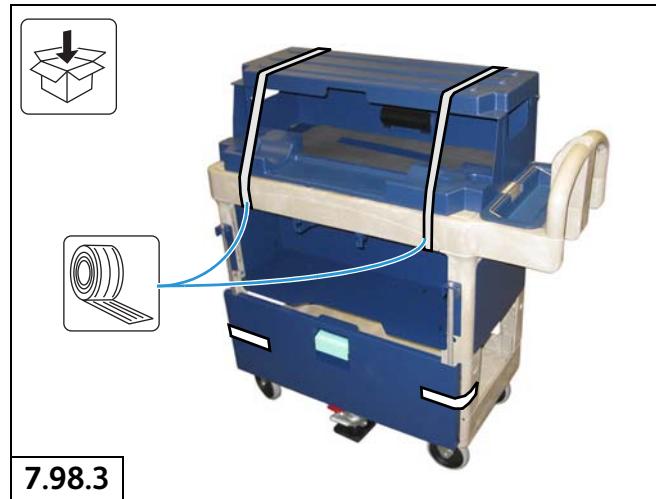


Stop: The CSE must remove and pack up any item(s), if present, from within the CCU Cart.

7.98.1 The material required for a Relocation/Removal of a CCU Cart is shown.



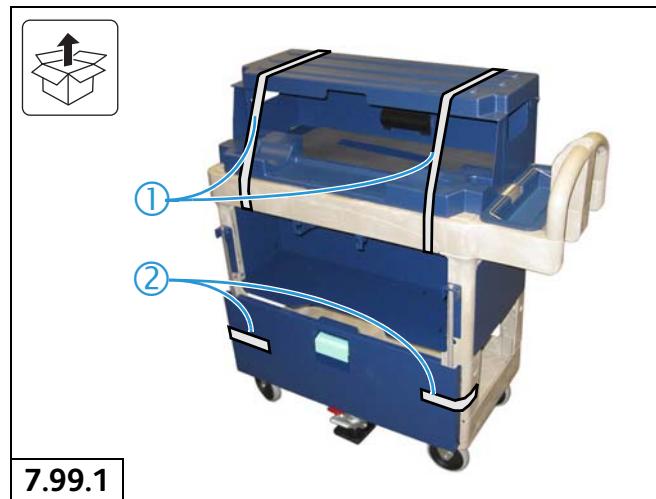
7.98.2



7.98.3



7.98.4



7.99.1

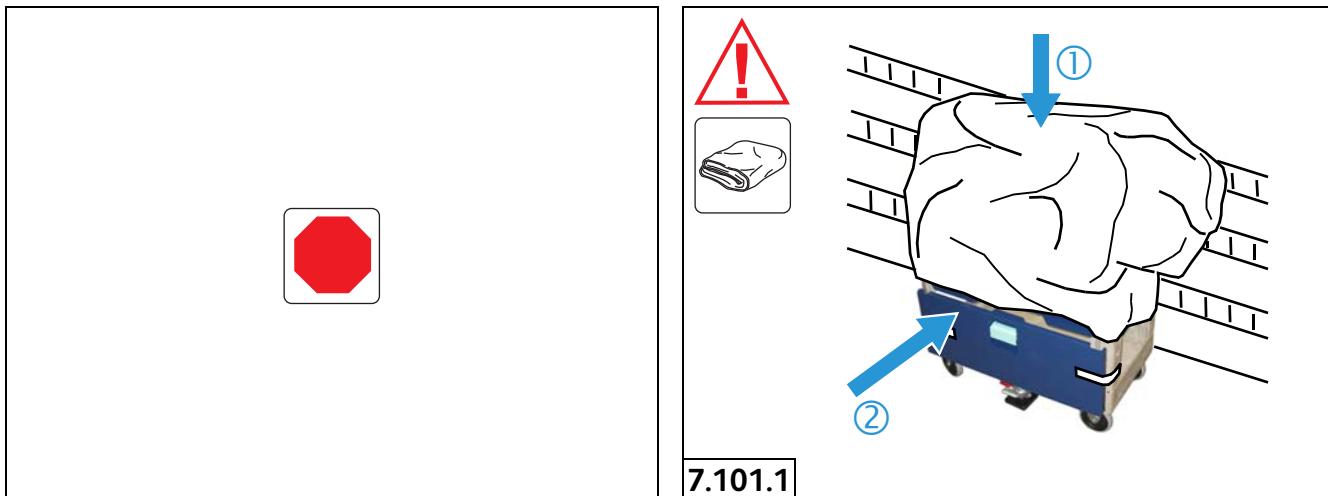
7.98.2 Secure front cover in its lowest position with a piece of tape on the left and right sides of the cover.

7.98.3 Secure the top cover in place by installing two pieces of tape over the top of the cart.

7.98.4 ① Release the foot brake and ② move the cart to the new location or to the truck.

7.99.0 Unpack and Reposition the CCU Cart

7.99.1 ① Remove the tape from the top and ② front covers of the cart.



7.99.2 Position the cart next to the installed system.

7.100.0 Removal - Preparing the CCU Cart for the Move

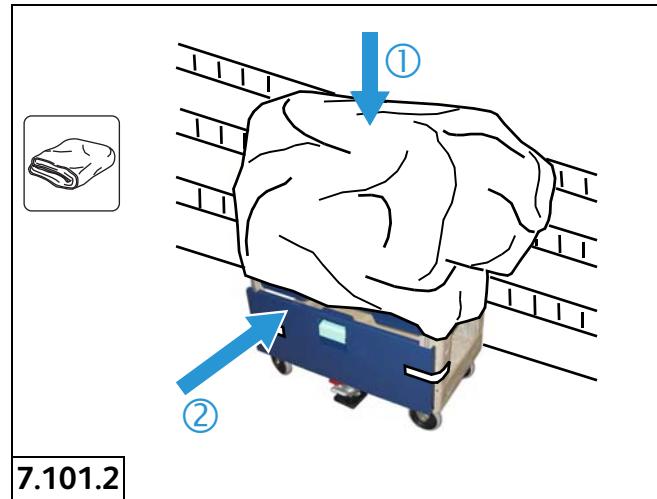
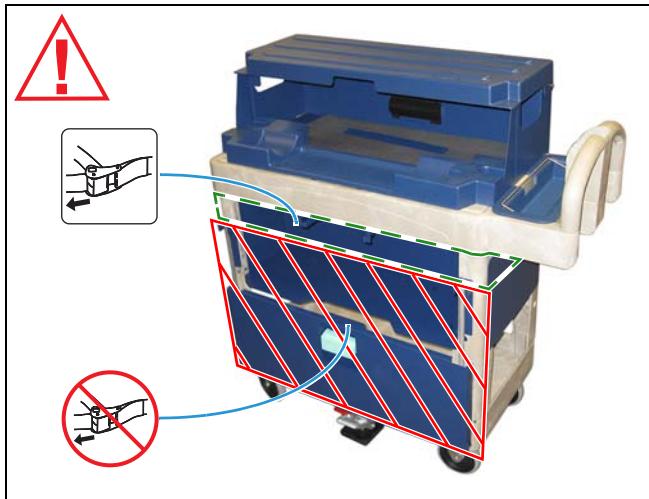
 Stop: Perform all the steps in "Relocation Removal - Preparing the CCU Cart (if present)" on page 7-148, except for "Unpack and Reposition the CCU Cart" on page 7-149.

7.101.0 Strapping the CCU Cart

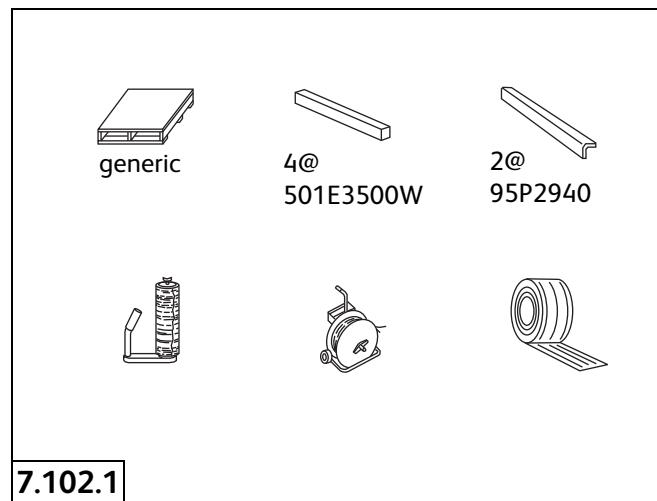
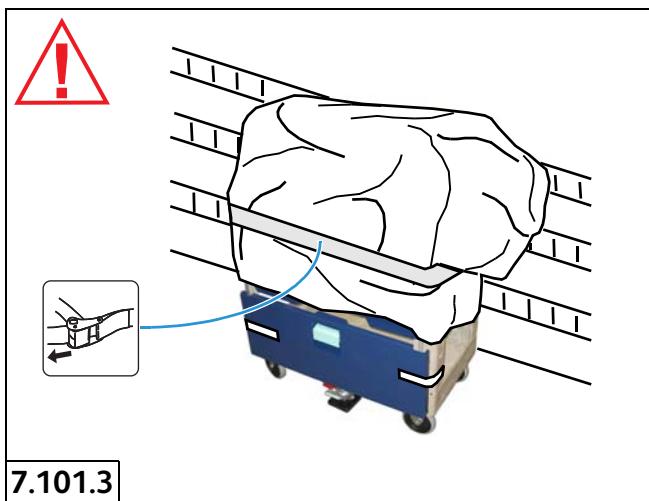


CAUTION: When placing the CCU Cart against the wall of the truck, ensure that the blanket is positioned between the cart and wall. Ensure the rear side of the cart is positioned against the wall of the truck.

7.101.1 ① Cover the CCU Cart with a folded blanket and ② place the cart against the wall of the truck.



7.101.2



7.102.1

! CAUTION: When strapping the CCU Cart to the wall of the truck, DO NOT run strap over the bottom front cover or the front cover rails. Ensure that the strap is run above the tops of the front door rails, yet below the handle on the right side of the cart.

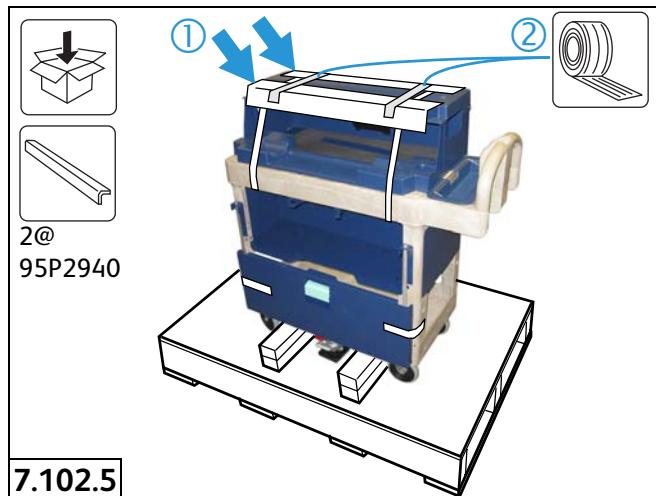
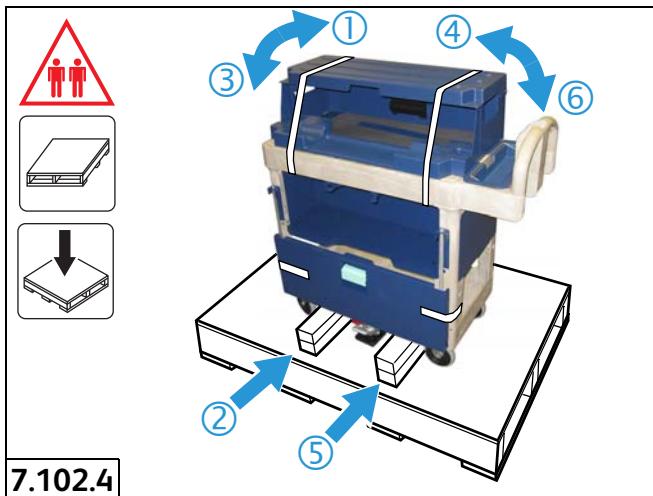
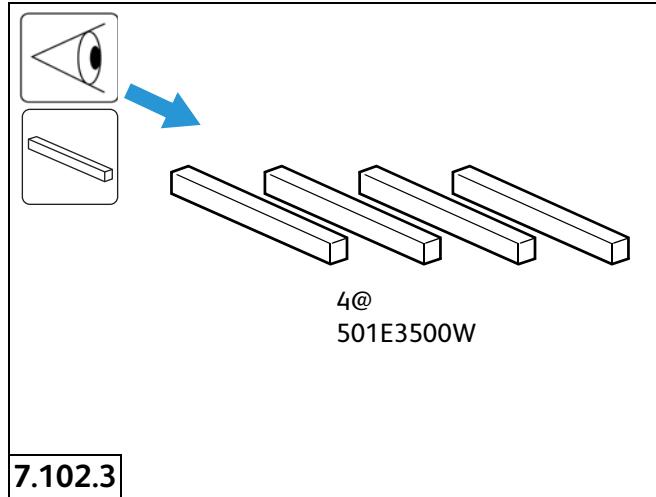
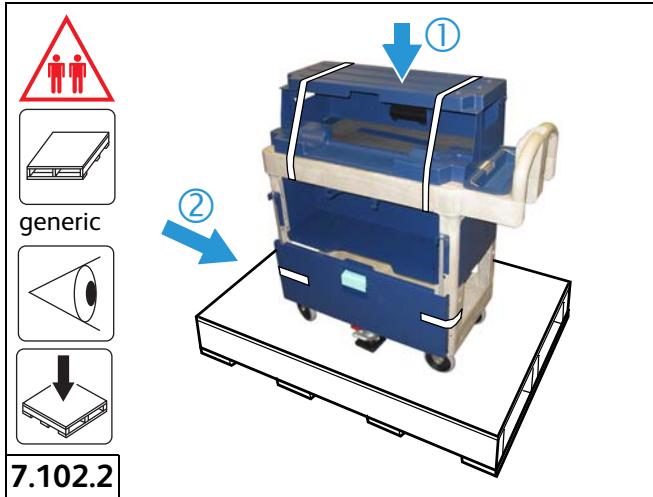
7.101.2 ① Place a folded blanket over the top of the cart and ② then position the cart against the wall of the truck.

! CAUTION: Ensure not to apply too much tension when strapping the CCU Cart into the truck.

7.101.3 Secure the CCU Cart to the wall of the truck with one strap.

7.102.0 Returning the CCU Cart

7.102.1 The materials required to prepare the CCU Cart for a return are shown.



 **CAUTION:** Due to the weight and size of the CCU Cart, two people will be required to place the cart on the generic pallet.

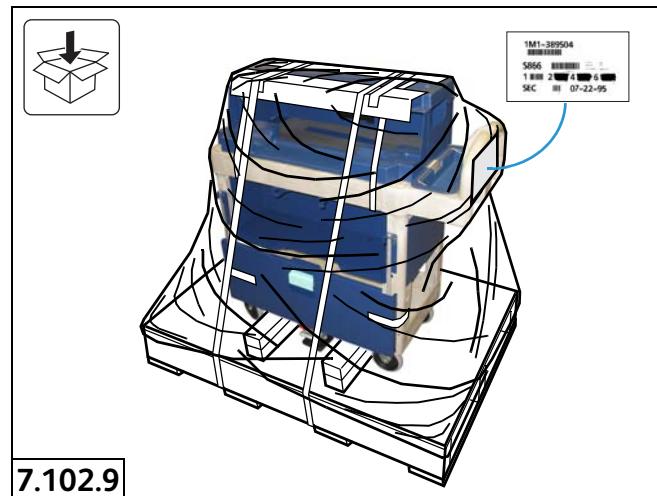
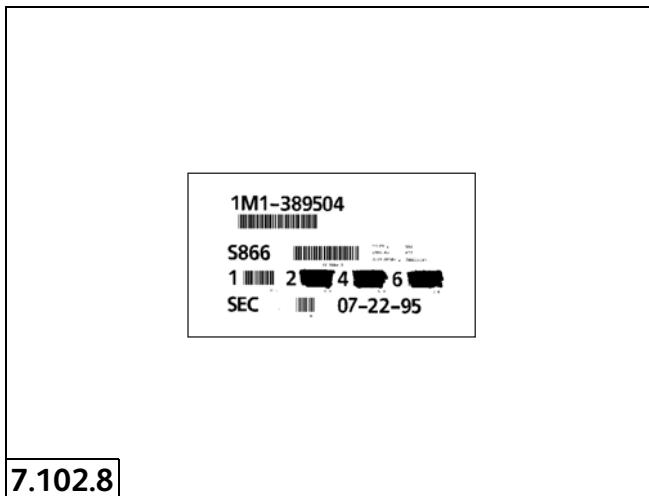
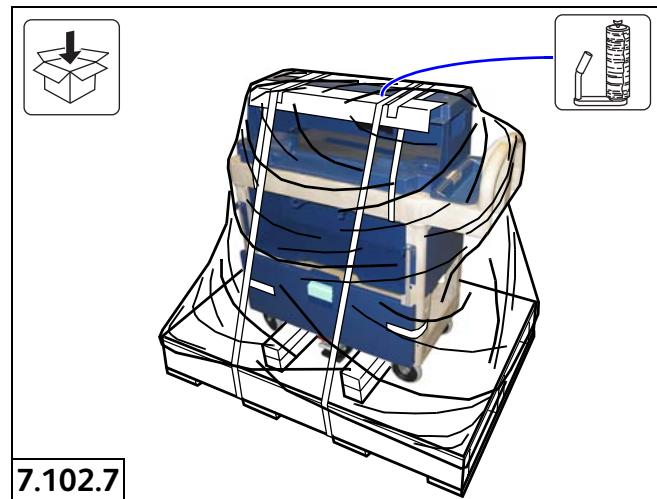
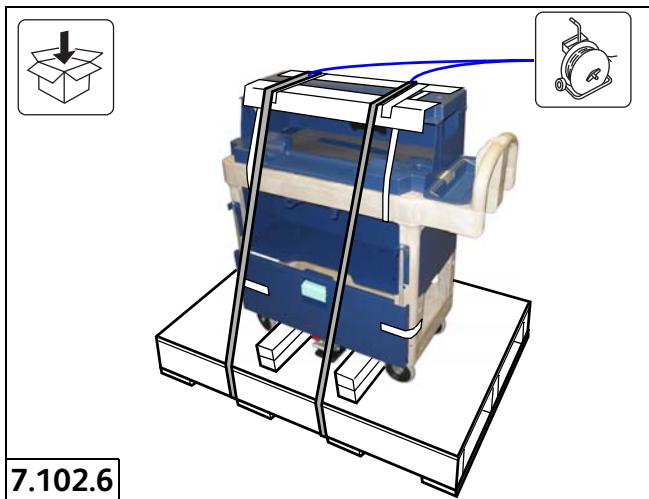
7.102.2 ① Retrieve a generic pallet and ② using two people, place the CCU Cart on the pallet.

7.102.3 Retrieve four wooden blocks (501E3500W).

7.102.4 ① Lift the left end of the cart and ② slide two stacked wooden blocks (501E3500W) under the end of the cart, just inside the casters.
 ③ Lower the cart onto the blocks. ④ Lift the right end of the cart and ⑤ slide the remaining two stacked blocks under the right side of the cart, just

inside the casters. ⑥ Lower the cart onto the blocks.

7.102.5 ① Retrieve and ② secure the corner-boards (95P2940) (2) to the top front and rear edges of the cart using tape.



7.102.6 Secure the cart to the pallet with two bands.

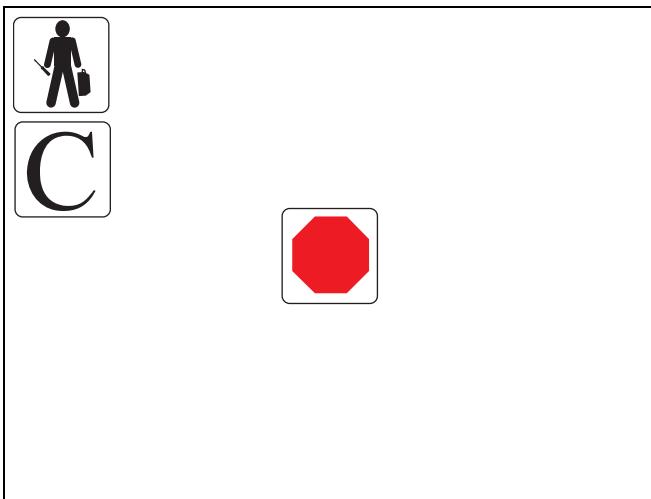
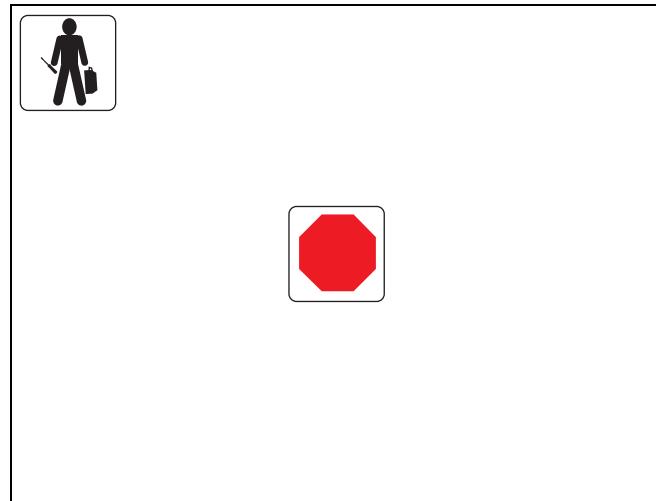
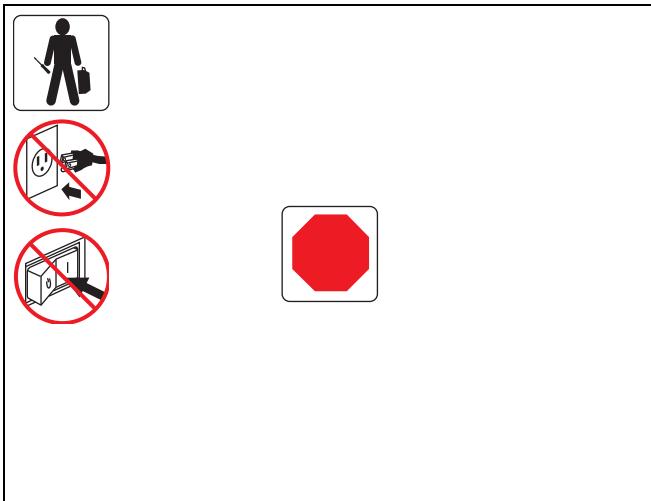
7.102.7 Secure the cart with a layer of stretchwrap.

7.102.8 Generate the bar code label. Cross off the non-applicable codes.

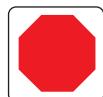
7.102.9 Attach the bar code label to the stretchwrap at the open end of the pallet.

8

Ready-to-Run

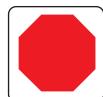


8.0.0 Ready-to-Run



Stop: The Carrier, Installer and LSP do not attach the IOT or the accessories power cords to the wall receptacle. The CSE is responsible for plugging in all modules into a wall receptacle and get the system up and running.

8.1.0 Functional Check



Stop: Because the Xerox® Iridesse™ Production Press system is not powered on by the Carriers, Installer or LSP, the Functional Check procedures are the responsibility of the CSE to complete.

8.2.0 Product Demonstration



Stop: Because the Xerox® Iridesse™ Production Press is powered on by a CSE, the product demonstration for the Customer is performed by the CSE.