6400 Line Matrix Printers - what's new 3/11/2004

Time didn't allow updating all manuals. Here's what's up:

- The i-series manuals were updated the summer of 2003,
- The new "Generation II" models, for the Far East market, allowed us to update the maintenance procedures for the earlier models.
- The MIM procedures should be used for the respective models.
- The stacker procedures are somewhat more complete in the MIM for models 050, P5P, etc.
  - The Main Menu will take to those newer stacker procedures (for either model family)
  - The i-series specific MIM procedure will have the former (August 2003) stacker procedure
- The parts catalog is more updated in the February 2004 MIM
  - I recommend that you use the MIM and parts catalog for the model you are servicing
    - Error codes and MIM procedures are correct for those models
  - If there is confusion within the parts catalog, then check the MIM for models 050, P5P, etc.
- The 2003 Ethernet manual under the i-series "Additional Customer Documentation" is more current, however it does not correctly refer to the earlier models. If you can get over the model names being incorrect, then it is the better manual to use.
- There are additional Programmer's Reference Manuals for far-Eastern printer models. Those are included under the "Additional Customer Documentation" menu

- MIM updates for Models 050, P50, 010, P10, 015, 020, D3x, D6x, D8x
- Print Quality Tips - double hammer bank models (x20 and i24 only)
- i-series MIM updates

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050, P50, 010, (etc.) MIM Updates

The following changes are effective on 3/11/04

Location	Currently	Correct information
Page 54, error 024, Action step 6	References the Multi-platform interface card.	It should be the Coax/Twinax attachment card
Page 512, Figure 62	Part No. for Coax/Twinax expansion card is 24H9011	It should be 10R3923

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I-series MIM Updates - The following changes are effective on 3/11/04

Location	Currently	Correct information
Page 68, step 4	References page 257	It should be page 260
Page 474, item 30	Part No. 57P1473	54P1473 kit does NOT include camshaft
Page 474, item 30		10R2884 - camshaft
Page 518, step 5		Paper tent alignment is shown on page 546, figure 97. An additional note: Removing the paper tent may improve stacker reliability, when printing shorter (fold-to-fold) forms.
Page 54, error 024, Action step 6	References the Multi-platform interface card.	It should be the Coax/Twinax attachment card
Page 481, Figure 60	Part No. For C/T card is 24H9011	It should be 10R3923
Page 199 step 5 and page 600	Refer to print quality problems relating to banding.	Additionally there are other failures that may have banding-like symptoms. Click here to determine those errors

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Double Hammer bank PQ notes (Models x20 and i24 only):

Determining if problem is banding, platen camshaft alignment, or platen angle adjustment. (revised 07/24/03)

Banding:

The above picture shows banding. Note that one line starts out dark on the left side and transitions to light towards the right. The next line starts out light on the left side and transitions to dark on the right. This repeats every other line. Do not be concerned about the lightness of the print in this picture. It is just to illustrate the "banding" effect.

If this is the case, return to the Banding section of the MIM.

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Platen camshaft alignment:

If the "light print" pattern is inconsistent, the platen gap should be checked. If the platen gap is correct, but the light print is inconsistent with different form thickness settings, the camshaft alignment is suspect. Please contact your DDS and second-level support.

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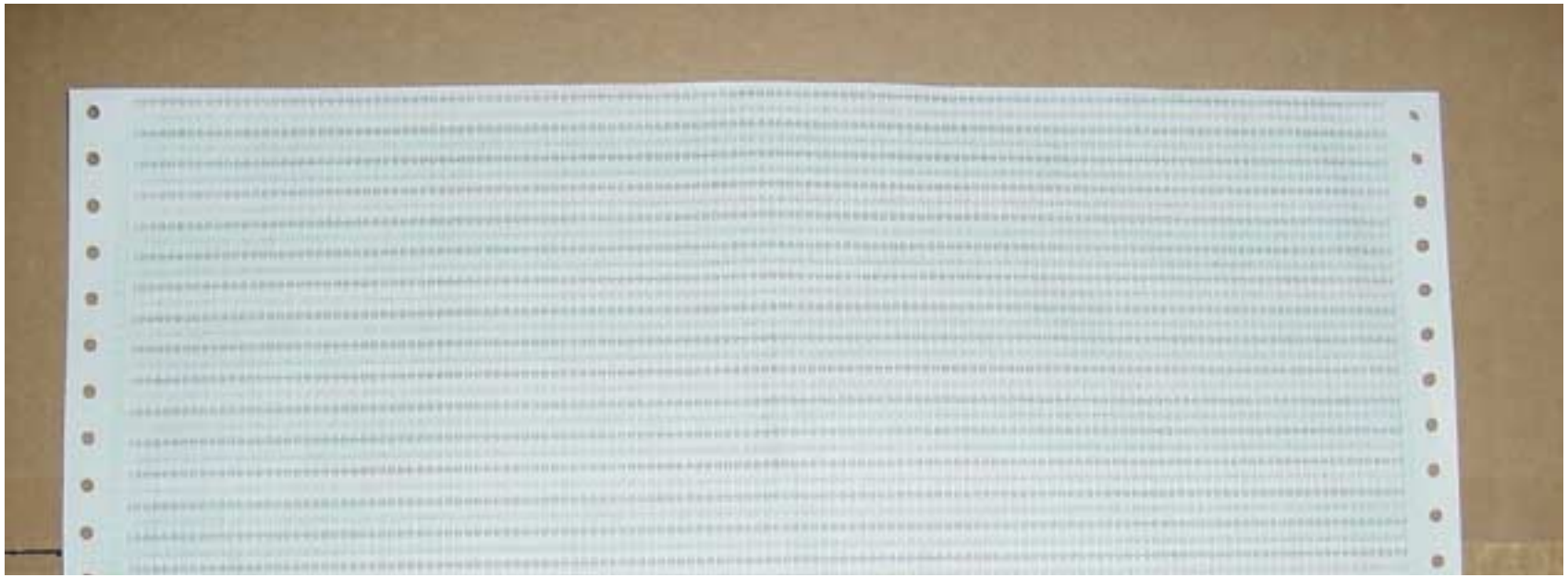
Platen angle adjustment:

The following picture shows platen angle misalignment.
Note that one line is uniformly dark across the page. The next line is uniformly light across the page. This repeats e



very other line.
If the print problem looks like the above picture, continue with the platen angle adjustment procedure.

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Platen angle adjustment procedure:
If you confirm a misaligned platen angle, we recommend that you contact your DDS and second-level support, for guidance. This is the procedure that they would be walking you through:

Perform this adjustment to achieve uniform density printing by tilting the platen to better match the dual hammer bank of fret tips. This adjustment might be required on new installed machine and is NOT expected to be required again after being satisfactorily completed.

TOOLS REQUIRED:

Use single part forms when making this adjustment.
New Ribbon
Flat blade screwdriver
Allen wrench set; 7/32 - inch for both platen gap adjust and angle adjustment.
Set the character width to 136 characters and 6LPI.

PROCEDURE:
Special note: If the platen bracket assembly, MIM figure A page 474 is damaged, order IBM PN 75P2177 - Platen Bracket kit. This will provide all six parts shown in the figure -> 1 bracket, 1 leaf spring, 1 teflon pad and 3 screws. There will be some level of pre-assembly. Install the assembly in the reverse order from removal steps. Then proceed with the following adjustment steps.

Verify the platen gap following MIM procedure. **NOTE:** Loosen platen open belt following procedure in MIM.
Remove the tape/foil (discard) and plastic cap that covers the set screw in the top of the assembly.
Important: This screw has very few threads. Do not drop it into the printer.
Set the forms width to 13.6 inches or 136 characters, 6 LPI. You can do this by selecting serial interface under Printer Control Menu option. **NOTE:** When you print an 'H' pattern later, this gives you full width characters on the page(no wrapping as 132 characters does).
IMPORTANT: Set the forms thickness lever initially to B.

Run the 'H' pattern print test using the Operator print tests in the menu. Let pattern print while performing the adjustment.

Slowly adjust the set screw and note how far (1/4 turns) you are turning it and in which direction. **NOTE:** The screw can be fairly difficult to turn at first.
While the print test is running, slowly turn the set screw in both directions to determine the change in 'H' pattern appearance:

Slowly turn the set screw CLOCKWISE and note the change in the H character
Slowly turn the set screw COUNTER CLOCKWISE and note the change in the H character

Now adjust the set screw until the 'H' pattern characters have uniform density on every print line.

Repeat this procedure with the forms thickness lever in position A.
Replace the plastic cap over the set screw.
Reverify platen gap.
Adjust hammer phasing if necessary.

Helpful note:

CW adjustment will make bottom line become lighter once optimum darkness has been achieved.
CCW adjustment will make the top line become lighter once optimum darkness has been achieved.

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