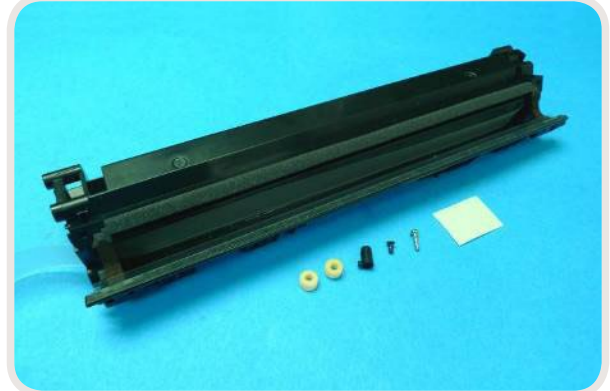




Installation Instructions for HM254EMPTY HP COLOR LASERJET PRO M254/MFP-M280/MFP-M281/ M154/MFP-M180/MFP-M181/M252/MFP-M277 'X' TONER HOPPER 60 GRMS FILL (WITH SEAL)

OEM HP M252/MFP-M277 (CF400A-CF403A or CF400X-CF403X) Cartridge
OEM HP M254/MFP-M280/MFP-M281
(CF540A-CF453A or CF540X-CF543X) cartridge
OEM HP M154/MFP-M180/MFP-M181 (CF510A-CF513A) cartridge

HM254EMPTY HP COLOR LASERJET PRO M254/MFP-M280/
MFP-M281/M154/MFP-M180/MFP-M181/M252/MFP-M277
'X' TONER HOPPER 60 GRMS FILL (WITH SEAL)



**HM254EMPTY HP COLOR LASERJET PRO M254/MFP-M280/MFP-M281/M154/MFP-M180/MFP-M181/M252/
MFP-M277 'X' TONER HOPPER 60 GRMS FILL (WITH SEAL) includes the following:**

1. Toner Hopper. This includes a Clear Seal and Exit Port Plug. All sealing foams and Developer Roller Sealing Blade are pre-installed.
2. Conductive Pin.
3. Screws for Contact Side Stabilizer.
4. Toner Adder Roller Sealing Foams.
5. Fill Hole Seal.

If using the 'A' cartridge, the Static Control Hopper will increase the capacity to greater than that of the OEM 'X' cartridge.

Conversion Procedures

STEP 1



The photo shows a HM254EMPTY Toner Hopper. Fill hopper with toner and use the Fill Hole Seal to seal the fill hole as shown.

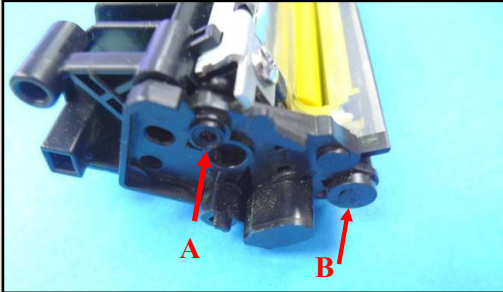
You need to disassemble and use the following parts from the OEM Toner Hopper either from the 'A' or 'X' cartridge:

1. Inner Gear Side End Cap,
2. Gear Side Stabilizer,
3. Contact Side Stabilizer,
4. Developer Roller Isolator,
5. Developer Roller Bearings,
6. Developer Roller Drive Gears.
7. Gear Set
8. Developer Roller
9. Toner Added Roller
10. Doctor Blade

Carefully clean all components before re-using.



**Installation Instructions for HM254EMPTY HP COLOR LASERJET PRO M254/MFP-M280/MFP-M281/
M154/MFP-M180/MFP-M181/M252/MFP-M277 'X' TONER HOPPER 60 GRMS FILL (WITH SEAL)**

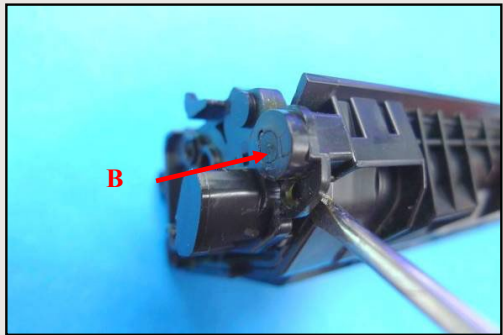


STEP 2

Disassembly the Contact Side Stabilizer from the OEM cartridge. It is welded on the OEM Toner Hopper by two points which are pointed out in the photo on the left.

Important

You must drill a 2.9mm diameter hole, 8mm deep, at Point A and at 90° to the face of the stabilizer on the OEM Contact Side Stabilizer to remove the heat stake post.

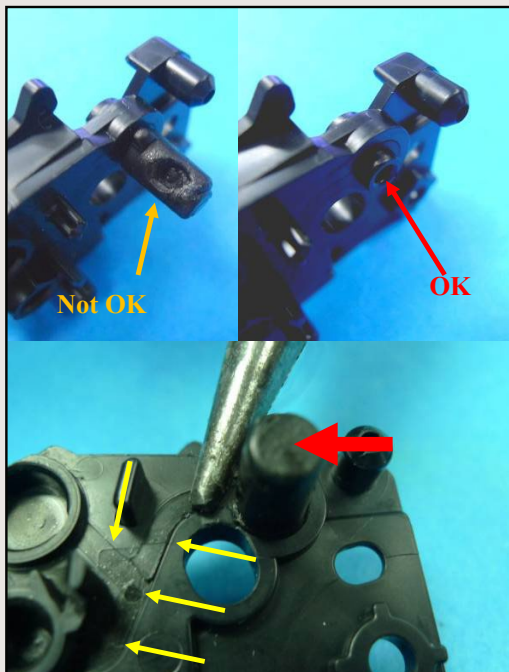


STEP 3

Then insert a flat screw driver between the Contact Side Stabilizer and Toner Hopper, and pry off the Contact Side Stabilizer making sure you pry it off squarely.

Important

**Make sure you do not damage the Contact Side Stabilizer by prying it off squarely.



STEP 4

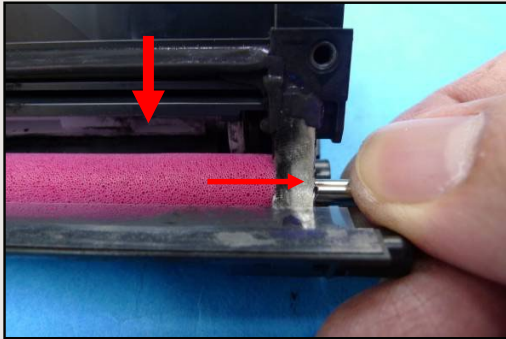
Remove the OEM Conductive Pin as indicated by the orange arrow if it has not fallen off when the initial hole is drilled through it. Follow the instruction in Red below.

Important

Use a pair of flat long nosed pliers to hold the insert molded conductive part (Indicated by Yellow Arrows) in the Contact Side Stabilizer as in the photo. This is to protect the insert molded conductive part during removal of the Conductive Pin. Then push the Conductive Pin in a sideways direction as shown by the Red Arrow until the Pin comes away.



**Installation Instructions for HM254EMPTY HP COLOR LASERJET PRO M254/MFP-M280/MFP-M281/
M154/MFP-M180/MFP-M181/M252/MFP-M277 'X' TONER HOPPER 60 GRMS FILL (WITH SEAL)**



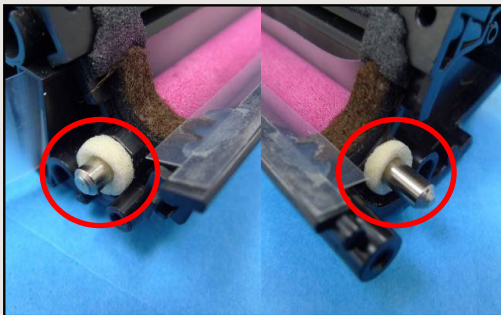
STEP 5

Pull the TONER ADDED ROLLER over to the right side of the OEM toner hopper to carefully compress the foam, as in the photo. Take out the TONER ADDED ROLLER from the left side. Make sure the adhesive under the compressed foam section is smooth.



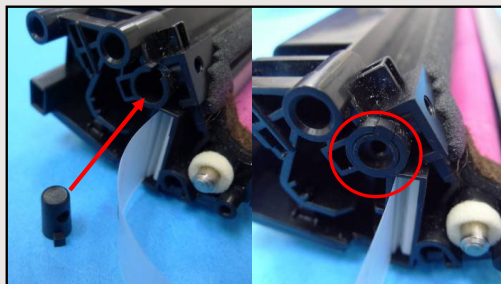
STEP 6

Put the right side of the TONER ADDED ROLLER into the HM254EMPTY Toner Hopper, then gently push it to compress the foam. Slide the left side into the hopper as in the photo above. Make sure the foam on the TONER ADDED ROLLER has returned to the normal position after installation.



STEP 7

Install the Toner Adder Roller Sealing Foams which comes with the HM254EMPTY Hopper on both sides as shown in the photo.



STEP 8

Install the Conductive Pin which comes with the HM254EMPTY Hopper on the Left side of the toner hopper as shown in the photo.

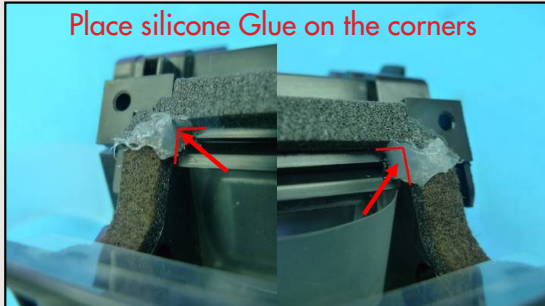
Important

****Make sure the Conductive Pin you use is from the HM254EMPTY. Do not use the OEM Conductive Pin as it is probably damaged.**



**Installation Instructions for HM254EMPTY HP COLOR LASERJET PRO M254/MFP-M280/MFP-M281/
M154/MFP-M180/MFP-M181/M252/MFP-M277 'X' TONER HOPPER 60 GRMS FILL (WITH SEAL)**

STEP 9

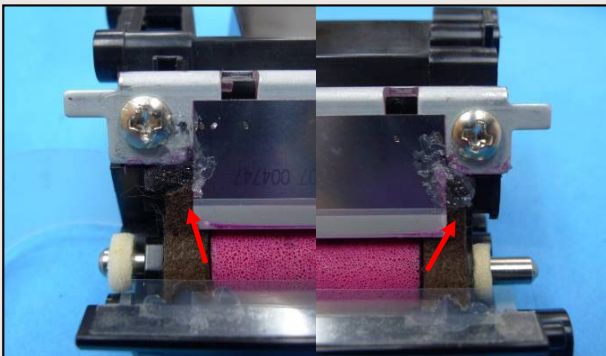


Carefully place silicone glue on the corners of the Doctor Blade Sealing Foam and the joints of the Developer Roller End Felts and Doctor Blade Sealing Foam as shown in the photos.

Important

****Make sure the silicone glue does not touch the Developer Roller.**

STEP 10



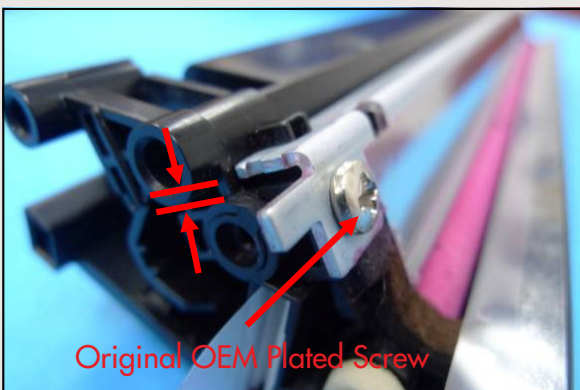
Install the Doctor Blade onto the Hopper before the silicone glue has dried. This will make sure the silicone glue fills the space under and between the doctor blade and sealing foams properly, as shown in the photos. Clean any excess glue after fitting the doctor blade.

Important

****Make sure the silicone glue does not touch the Developer Roller.**

**** Make sure the Doctor Blade is lubricated with toner along the edge where it contacts the Developer Roller.**

STEP 11



Install the Doctor Blade onto the Hopper. Gap the blade to around 1.1mm. This 1.1mm is the gap measured from the OEM. Hold blade firmly in place and screw onto the hopper.

Important

**** Make sure you use the original OEM plated conductive screw to re-fix the doctor blade in place. Do not use a black screw.**

**** However different combinations of the OPC Drum and Toner, may require a slightly different gap.**



**Installation Instructions for HM254EMPTY HP COLOR LASERJET PRO M254/MFP-M280/MFP-M281/
M154/MFP-M180/MFP-M181/M252/MFP-M277 'X' TONER HOPPER 60 GRMS FILL (WITH SEAL)**

STEP 12



Place the Left and Right Developer Roller Bushing on each end of the Developer Roller.

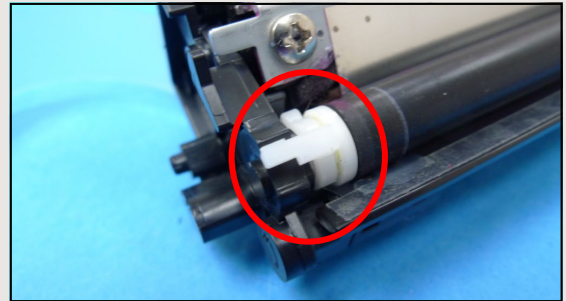
Place the Developer Roller Isolator on the left end of the Developer Roller.

Place the Developer Roller into the hopper.

Important

**Do not place the Developer Roller Isolator on the Developer Roller if not using an OEM OPC Drum in the cartridge.

STEP 13



Then install the Gear Side Stabilizer and Contact Side Stabilizer on the hopper.

Important

**Make sure the 2.9mm diameter hole is drilled right through the OEM Contact Side Stabilizer as shown in the photo. Initial drilling to 8mm depth will achieve this.

**Make sure the Developer Roller Isolator is in the locking position as shown in the photo if reusing an OEM drum.

**Static Control offers the HM452SHPROT which also has a function to separate the Toner Hopper Section and Waste Section

STEP 14



Use the Screws which come with the HM254EMPTY to tighten the Contact Side Stabilizer as shown in the photo.

Important

** Make sure the Contact Side Stabilizer is screwed onto the Toner Hopper properly. If this is not screwed properly, the Stabilizer may not give enough pressure to the Toner Adder Roller Sealing Foams (Foam Washer) to seal that section.

**Make sure the tail of the Clear Seal comes out between the Contact Side Stabilizer and Toner Hopper as shown in the photo.

** Make sure you use the Plated Conductive Screw from this Kit in the position shown. Do not use the Black Screw.



Installation Instructions for HM254EMPTY HP COLOR LASERJET PRO M254/MFP-M280/MFP-M281/
M154/MFP-M180/MFP-M181/M252/MFP-M277 'X' TONER HOPPER 60 GRMS FILL (WITH SEAL)

STEP 15



Use the Black Screws which are supplied with the HM254EMPTY to tighten the Contact Side Stabilizer as shown in the photo.

Important

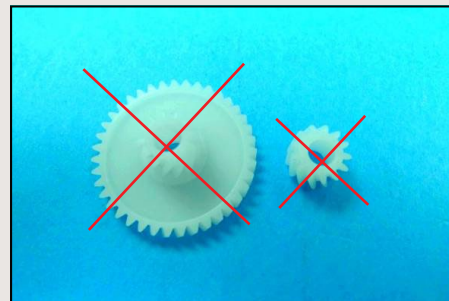
** Make sure the Contact Side Stabilizer is screwed onto the Toner Hopper properly. If this is not screwed properly, the Stabilizer may not give enough pressure to the Toner Adder Roller Sealing Foams (Foam Washer) to seal that section.

STEP 16



Install the gear set in the Gear Side Stabilizer as shown in the photo.

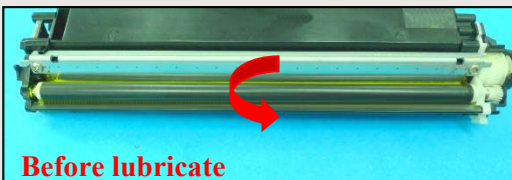
Install the Inner Gear Side End Cap. Tighten the screw on the Inner Gear Side End Cap.



Important

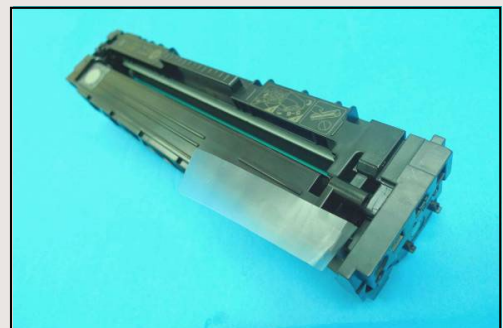
** Do not install the two gears shown in the photo above onto the HM254EMPTY Toner Hopper.

STEP 17



Put some toner on the top of Developer Roller and then rotate it to lubricate the Developer Roller and Doctor Blade.

STEP 18



Assembly of the Static Control Hopper is now complete.

Finish Cartridge showing where the pull seal exits.



Static Control®

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