Model: Model A-P3	Date: 1-May-02	No.: MG065001

Modified Article: Feed Shaft and Tightener Bracket			Prepared by: E. Fukuyama
From: Technical Services sec. Service Planning Dept.			
Reason for Modification:	☐ Parts catalog correction ☐ To facilitate assembly ☐ Part standardization	☐ Vendor change ☒ To improve reliability ☐ Other	☐ To meet standards ( )

The following changes have been made to reduce noise.

A. Noise generated by vibration of the Electrical Clutch Feed Shaft and Drive Gear:
See the replacement procedure on the next page.

To support the free end of the shaft with a bushing:
1. Lengthened the Feed Shaft from 229mm to 249mm.
2. Added a Bushing and e-ring.
3. Modified the shaft of the Tightener Bracket to accommodate the new bushing (hole added).

To hold the clutch firmly in place:
1. Added a Roller to be pressed closely against the clutch.
2. Added a Pressure Plate to attach the Roller.

B. Noise from the Bushing of the Driven Roller Shaft:
Changed the material of the Bushing.

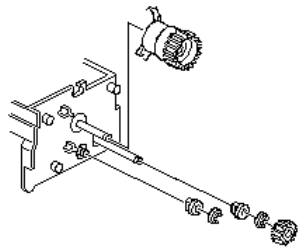
Old part number	New part number	Description	Q'ty	Int	Page	Index
AA140660	AA140753	Feed Shaft	1-1	X/X	11	21
A2326061	G0656801	Tightener Bracket	1-1	X/O	11	38
A2326057	G0656800	Bracket-by-pass Feed Drive	1-1	X/O	11	41
A2326065	G0656802	Rail By-pass Feed	1-1	X/O	11	39
-	GA080002	Bushing – 6mm	0-1	-	11	35
-	07200040E	Retaining Ring – M4	0-1	-	11	104
-	B0046062	Pressure Plate	0-1	-	11	42
	AF040575	Driven Roller	0-1	-	11	43
08053480	GA080002	Bushing – 6mm	1-1	X/O	11	102-35

Note: Whenever replacing the old Feed Shaft with the new one, the following parts from the above list must all be replaced <u>together as a set:</u>

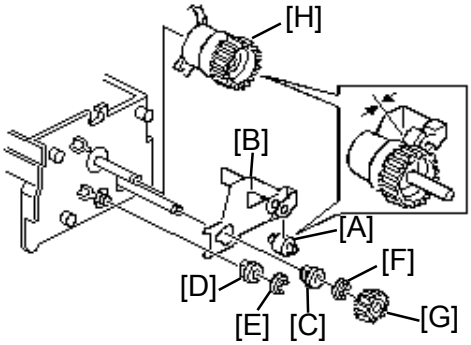
AA140753, G0656801, G0656802, GA080002, 07200040E

Replacement Procedure for parts modified in section A above

Prep:
Remove the Tightener Bracket, Retaining Ring, Bushing and Electrical Clutch as shown below.



1. Replace the Feed Shaft with AA140753.



2. Attach the Driven Roller [A] to the Pressure Plate [B], then peel off the outer layers of the double-sided tape (2 places) on the Pressure Plate.

3. Set the Bushing [C] in the hole in the Pressure Plate, then mount the two together onto the Feed Shaft.
   Note: Be careful not to let the exposed double-sided tape contact the Side Plate.

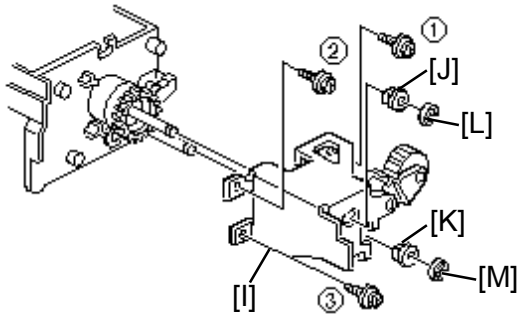
4. Set Bushing [D] in the cutout on the side of the Pressure Plate, then push in the Pressure Plate along with the two bushings. After it is set in position, attach e-rings [E] and [F].

5. Press the Pressure Plate firmly against the Side Plate so that the double-sided tape catches and secures the two together.

6. Attach the Gear [G].

7. Attach the Electrical Clutch [H].

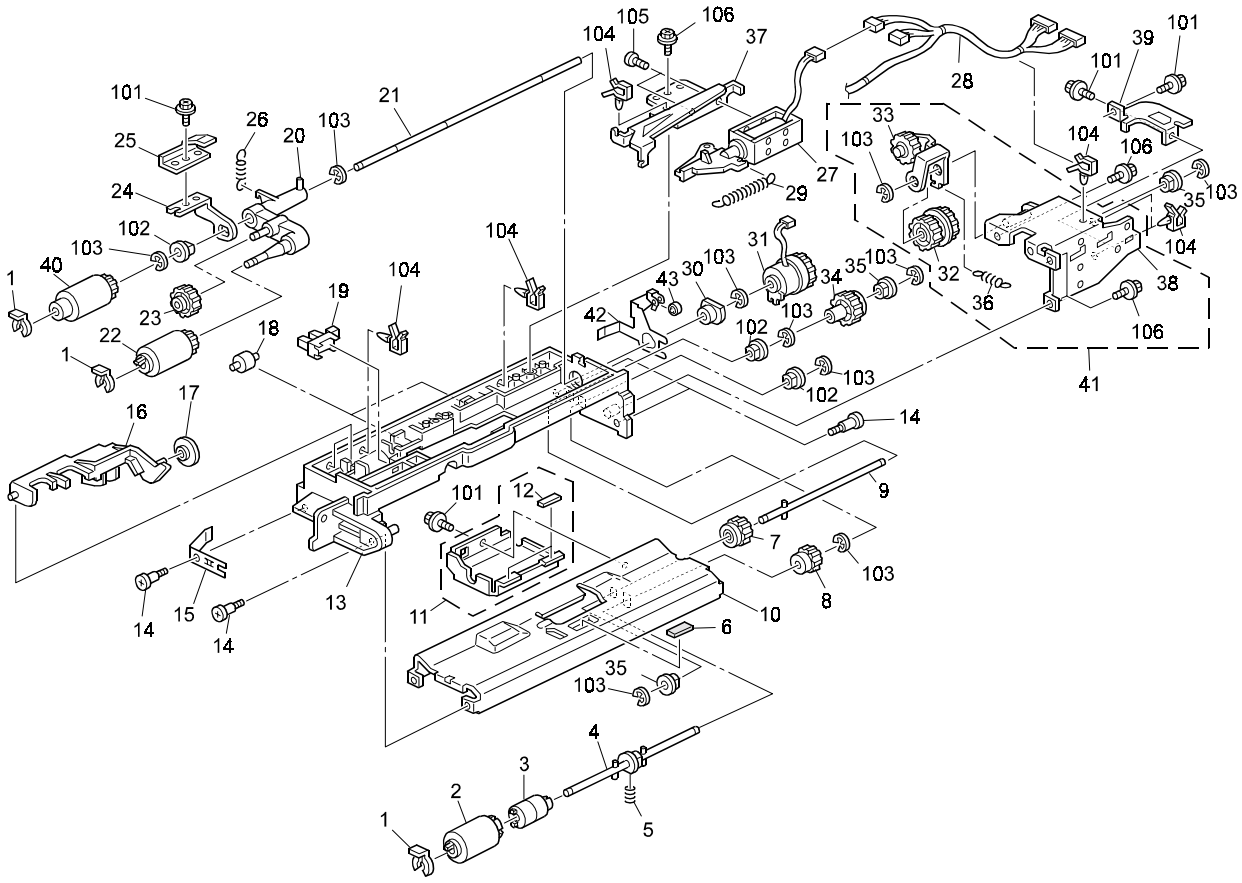
Model: Model A-P3	Date: 1-May-02	No.: MG065001



8. Remove the Arm Tightener, Gear and Spring attached to the Tightener Bracket removed in the Prep stage above, then attach them to the new Tightener Bracket [I].

9. Attach the Tightener Bracket [I] and Bushings [J] and [K]. Then, tighten the screws in the order shown.

10. Attach e-rings [L] and [M].



RAI (China) Production

MODEL NAME	V/Hz	DESTINATION	CODE	SERIAL NUMBER
Lanier 2145 AG	115/60	USA, Canada	G065-14	
Savin MLP45 Gestetner P7145	115/60	USA, Canada	G065-15	P7226300158
Ricoh Aficio AP4510	115/60	USA	G065-17	P7226300169
Gestetner P7145 nashuatec P7145 Rex-Rotary P7145	220/50	Europe, Asia, etc.	G065-22	P7226400014
Lanier 2145 AH	220/50	Europe	G065-24	
Infotec IP 4510	220/50	Europe	G065-26	
Ricoh Aficio AP4510	220/50	Europe, Asia, etc.	G065-27	P7226300156

RICOH **M**odification **B**ulletin

Reissued: 7-Jan-03

Model: Model A-P3	Date: 18-Jun-02	No.: MG065002a

MB Correction

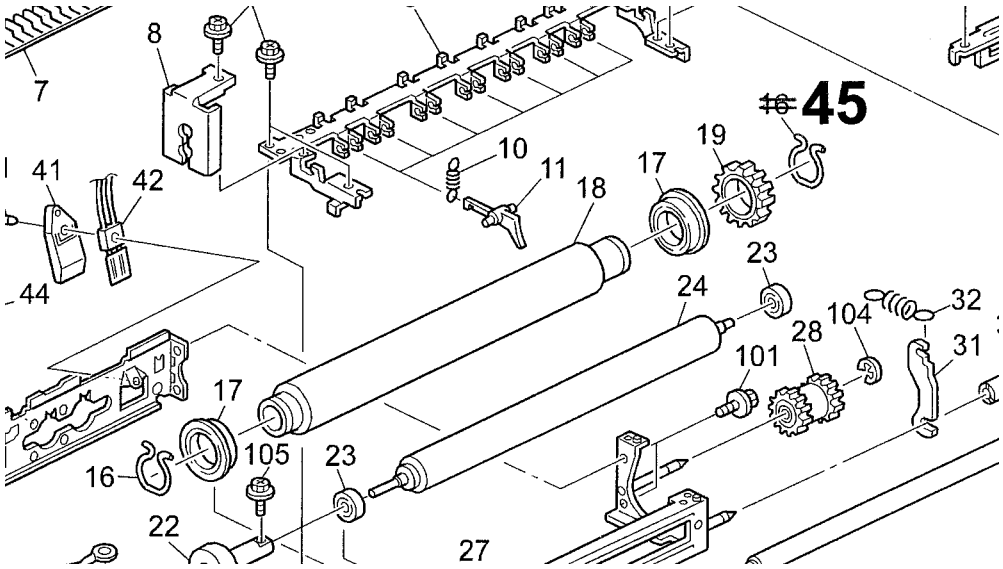
The items in bold italics have been corrected or added.

Modified Article: C - Ring - Hot Roller			Prepared by: K.Takagi
From: Technical Services sec. Service Planning Dept.			
Reason for Modification:	☐ Parts catalog correction ☐ To facilitate assembly ☐ Part standardization	☐ Vendor change ☒ To improve reliability ☐ Other	☐ To meet standards ( )

Previously, a pressure-release device was added to the fusing unit maintenance kit to prevent deformation of the Pressure Roller during long periods of storage. However there are cases in the field where this device is not properly removed, and the Hot Roller C-ring detaches when the fusing knob is turned.

The shape of the C-ring ***on the gear side*** has been changed so that it will stay in place even in such cases. Although this only occurs with the maintenance kit, this modification was made because the same C-ring is common to both the kit and the mainframe.

Old part number	New part number	Description	Q'ty	Int	Page	Index
A2324064	G0654140	C Ring - Hot Roller	2-1	X/O	31	45

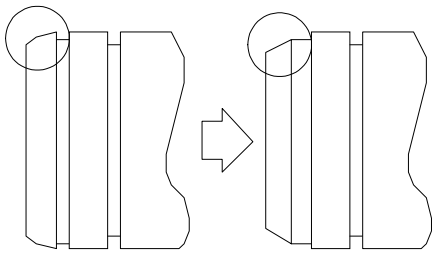


Model: Model A-P3	Date: 1-Jul-02	No.: MG065003

Modified Article: Hot Roller			Prepared by: K. Takagi
From: Technical Services sec. Service Planning Dept.			
Reason for Modification:	☐ Parts catalog correction ☐ To facilitate assembly ☐ Part standardization	☐ Vendor change ☐ To improve reliability ☒ Other	☐ To meet standards ( )

As previously announced in MB #MG065002, the C-ring was modified to ensure that it does not slip off the Hot Roller. However due to variations in roller diameter, it became necessary to separate the thicker rollers out from stock for use on the A-P3. To eliminate this need, and to ensure that all C-rings will stay properly fastened, the outer diameter of the Hot Roller has been increased by 0.2 mm.

Visual distinction:
The old roller (left) contains a groove on the fusing knob end.



AE011064 AE011071

Old part number	New part number	Description	Q'ty	Int.	Page	Index	Note
AE011064	AE011071	Hot Roller – 39.8 mm T0.4	1	O/O	31	18	

RICOH **M**odification **B**ulletin

Model: Model A-P3	Date: 29-Jul-02	No.: MG065004

Modified Article: Transfer Unit Case			Prepared by: K. Takagi
From: Technical Services sec. Service Planning Dept.			
Reason for Modification:	☐ Parts catalog correction ☐ To facilitate assembly ☒ Part standardization	☐ Vendor change ☐ To improve reliability ☐ Other	☐ To meet standards ( )

To make it easier for service technicians to clean the Used Toner Tank on the A-C2, the Toner Tank Cover was fixed to the Transfer Unit Case with screws. To improve serviceability of these components on the A-P3, and to standardize parts, the Transfer Unit Case has been changed over to the one used on the A-C2.

Old part number	New part number	Description	Q'ty	Int.	Page	Index	Note
G0353900	B0043900	Case – Transfer Unit	1	O/O	25	12	

RAI (China) Production

MODEL NAME	V/Hz	DESTINATION	CODE	SERIAL NUMBER
Lanier 2145 AG	115/60	USA, Canada	G065-14	P72264xxxxx
Savin MLP45 Gestetner P7145	115/60	USA, Canada	G065-15	P7226400034
Ricoh Aficio AP4510	115/60	USA	G065-17	P7226400042
Gestetner P7145 nashuatec P7145 Rex-Rotary P7145	220/50	Europe, Asia, etc.	G065-22	P7226400014
Lanier 2145 AH	220/50	Europe	G065-24	P72264xxxxx
Infotec IP 4510	220/50	Europe	G065-26	P72264xxxxx
Ricoh Aficio AP4510	220/50	Europe, Asia, etc.	G065-27	P7226400001

Model: Model A-P3	Date: 31-Mar-03	No.: MG065005

Modified Article: Development Roller Assy			Prepared by: K.Takagi
From: Technical Services Sec. Service Planning Dept.			
Reason for Modification:	☐ Parts catalog correction ☐ To facilitate assembly ☐ Part standardization	☐ Vendor change ☒ To improve reliability ☐ Other	☐ To meet standards ( )

The DG has been narrowed from 0.4±0.05mm to 0.38±0.03mm to ensure that toner does not stick to the operator side of the Development Roller.

Old part number	New part number	Description	Q'ty	Int.	Page	Index	Note
B0043100	B0043101	Development Roller Assy	1	O/O	29	4	

RAI (China) Production

MODEL NAME	V/Hz	DESTINATION	CODE	SERIAL NUMBER
Lanier 2145 AG	115/60	USA, Canada	G065-14	P72361xxxxx
Savin MLP45 Gestetner P7145	115/60	USA, Canada	G065-15	P7227200094
Ricoh Aficio AP4510	115/60	USA	G065-17	P7227200094
Gestetner P7145 nashuatec P7145 Rex-Rotary P7145	220/50	Europe, Asia, etc.	G065-22	P7227200166
Lanier 2145 AH	220/50	Europe	G065-24	P72361xxxxx
Infotec IP 4510	220/50	Europe	G065-26	P72361xxxxx
Ricoh Aficio AP4510	220/50	Europe, Asia, etc.	G065-27	P7227200001

Model: Model A-P3	Date: 4-Jul-03	No.: MG065006

Modified Article: Chromium Free			Prepared by: Y.Urushihara
From: 1st Tech. Support Sec. Service Support Dept.			
Reason for Modification:	☐ Parts catalog correction ☐ To facilitate assembly ☐ Part standardization	☐ Vendor change ☐ To improve reliability ☒ Other	☐ To meet standards ( )

The following have been changed to Chromium-free components to further minimize the potential impact on the environment.

Old part number	New part number	Description	Q'ty	Int	Page	Index	Note
AW010090	AW010061	Exit Sensor - Fusing	1-1	O/O	27	18	

Model: Model A-P3	Date: 19-Mar-04	No.: MG065007

Modified Article: Fusing Unit			Prepared by: Y.Urushihara
From: 1st Tech. Support Sec. Service Support Dept.			
Reason for Modification:	☐ Parts catalog correction ☐ To facilitate assembly ☒ Part standardization	☐ Vendor change ☐ To improve reliability ☐ Other	☐ To meet standards ( )

The pressure lever has been changed in accordance with parts standardization with Model A-C2/C3.

Old part number	New part number	Description	Q'ty	Int	Page	Index	Note
G0657320	G0657321	Fusing Unit-NA	1-1	O/O	31	2	
G0657720	G0657721	Fusing Unit-NA	1-1	O/O	31	2	
B0044056	B0774056	Pressure Lever	1-1	O/O	31	31	

RICOH **M**odification **B**ulletin **PAGE: 1/1**

Model: Model A-P3	Date: 25-Mar-04	No.: MG065008

Modified Article: Heater			Prepared by: Y.Urushihara
From: 1st Tech. Support Sec. Service Support Dept.			
Reason for Modification:	☐ Parts catalog correction ☐ To facilitate assembly ☐ Part standardization	☒ Vendor change ☐ To improve reliability ☐ Other	☐ To meet standards ( )

The following has been changed due to a vendor change.

Old part number	New part number	Description	Q'ty	Int	Page	Index	Note
AX440149	AX440198	Heater – 120V 650W 215mm	1-1	O/O	31	20	
AX440150	AX440199	Heater – 230V 650W 215mm	1-1	O/O	31	20	

RAI (China) Production

MODEL NAME	V/Hz	DESTINATION	CODE	SERIAL NUMBER
Lanier 2145 AG	115/60	USA, Canada	G065-14	P72362xxxxx
Savin MLP45 Gestetner P7145	115/60	USA, Canada	G065-15	P7236100106
Ricoh Aficio AP4510	115/60	USA	G065-17	P7236100120
Gestetner P7145 nashuatec P7145 Rex-Rotary P7145	220/50	Europe, Asia, etc.	G065-22	P7236100001
Lanier 2145 AH	220/50	Europe	G065-24	P72362xxxxx
Infotec IP 4510	220/50	Europe	G065-26	P72362xxxxx
Ricoh Aficio AP4510	220/50	Europe, Asia, etc.	G065-27	P7236100031

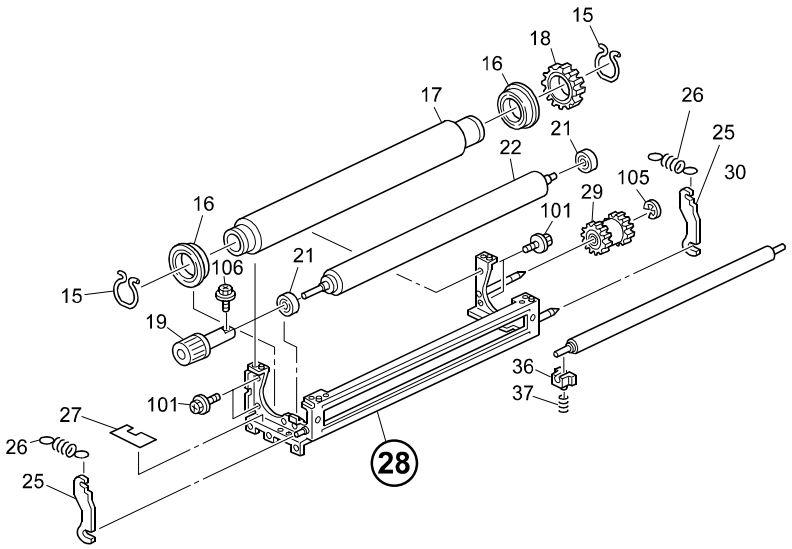
Modification Bulletin

Model: Model A-P3	Date: 17-Aug-04	No.: MG065009

Modified Article: Frame – Fusing Unit			Prepared by: Y.Urushihara
From: 1st Tech. Support Sec. Service Support Dept.			
Reason for Modification:	☐ Parts catalog correction ☐ To facilitate assembly ☐ Part standardization	☒ Vendor change ☐ To improve reliability ☐ Other	☐ To meet standards ( )

The following has been changed due to a vendor change.

Old part number	New part number	Description	Q'ty	Int	Page	Index	Note
A2324051	B0774051	Frame – Fusing Unit	1-1	O/O	31	27	



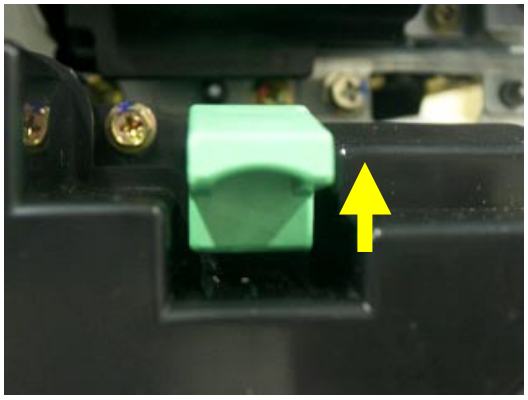
Model: Model A-P3	Date: 7-Jan-05	No.: MG065010

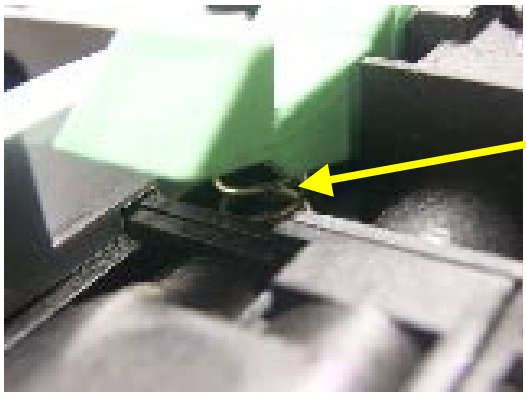
Modified Article: SPRING: STOPPER: PCU			Prepared by: K. Takagi
From: 1st Tech. Support Sec. Service Support Dept.			
Reason for Modification:	☐ Parts catalog correction ☐ To facilitate assembly ☐ Part standardization	☐ Vendor change ☒ To improve reliability ☐ Other	☐ To meet standards ( )

Old part number	New part number	Description	Q'ty	Int	Page	Index	Note
AA063646	G0652219	SPRING: STOPPER: PCU	1	O/O	21	34	

Change: The pressure of the PCU stopper spring was increased (9.8N to 20N).
Reason: To make sure the stopper does not move when drive is supplied to the PCU.

Note: If the stopper moves, the PCU can move out of position a few millimeters. This can cause poor connection of the TD sensor, or incorrect development bias on the development roller.





Model: Model A-P3	Date: 7-Jan-05	No.: MG065010

RAI (China) Production

MODEL NAME	V/Hz	DESTINATION	CODE	SERIAL NUMBER
Lanier 2145 AG	115/60	USA, Canada	G065-14	P72365xxxxx
Savin MLP45 Gestetner P7145	115/60	USA, Canada	G065-15	P7236400260
Ricoh Aficio AP4510	115/60	USA	G065-17	P7236400168
Gestetner P7145 nashuatec P7145 Rex-Rotary P7145	220/50	Europe, Asia, etc.	G065-22	P7236400001
Lanier 2145 AH	220/50	Europe	G065-24	P72365xxxxx
Infotec IP 4510	220/50	Europe	G065-26	P72365xxxxx
Ricoh Aficio AP4510	220/50	Europe, Asia, etc.	G065-27	P7236300183