3M

Instructions and Parts List

3M-Matic™

700a Type 39600

Adjustable

Case Sealer

with

AccuGlide™ II

Taping Heads

Important Safety Information

Read "Important Safeguards", pages 3-5 and also operating "Warnings", page 14 BEFORE INSTALLING OR OPERATING THIS EQUIPMENT.

Spare Parts

It is recommended you immediately order the spare parts listed on page 31, Section I and page 17, Section II. These parts are expected to wear through normal use and should be kept on hand to minimize production delays.

Serial No. _____

For reference, record machine serial number here.

3M Packaging Systems Division

3M Center, Building 220-8W-01
St. Paul, MN 55144-1000

To Our Customers:

This is the 3M-Matic™/AccuGlide™/Scotch™ brand equipment you ordered. It has been set up and tested in the factory with "Scotch" brand tapes. If technical assistance or replacement parts are needed, call or Fax the appropriate number listed below.

Included with each machine is an Instructions and Parts List manual.

Technical Assistance:

3M-Matic™ Helpline – 1-800/328 1390. Please provide the customer support coordinator with the machine number, machine type/model and serial number. If you have a technical question that does not require an immediate response, you may Fax it to 715/381 0248.

Replacement Parts and Additional Manuals

Order parts by part number, part description and quantity required. Also, when ordering parts and/or additional manuals, include machine name, number and type. A parts order form is provided at the back of this manual.

3M/Tape Dispenser Parts
241 Venture Drive **1-800/344 9883**
Amery, WI 54001-1325 **FAX# 715/268 8153**

Minimum billing on parts orders will be $25.00. Replacement part prices available on request.
$10.00 restocking charge per invoice on returned parts.
Note : Outside the U.S., contact the local 3M subsidiary for parts ordering information.

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3M Packaging Systems Division
3M Center, Building 220-8W-01
St. Paul, MN 55144-1000

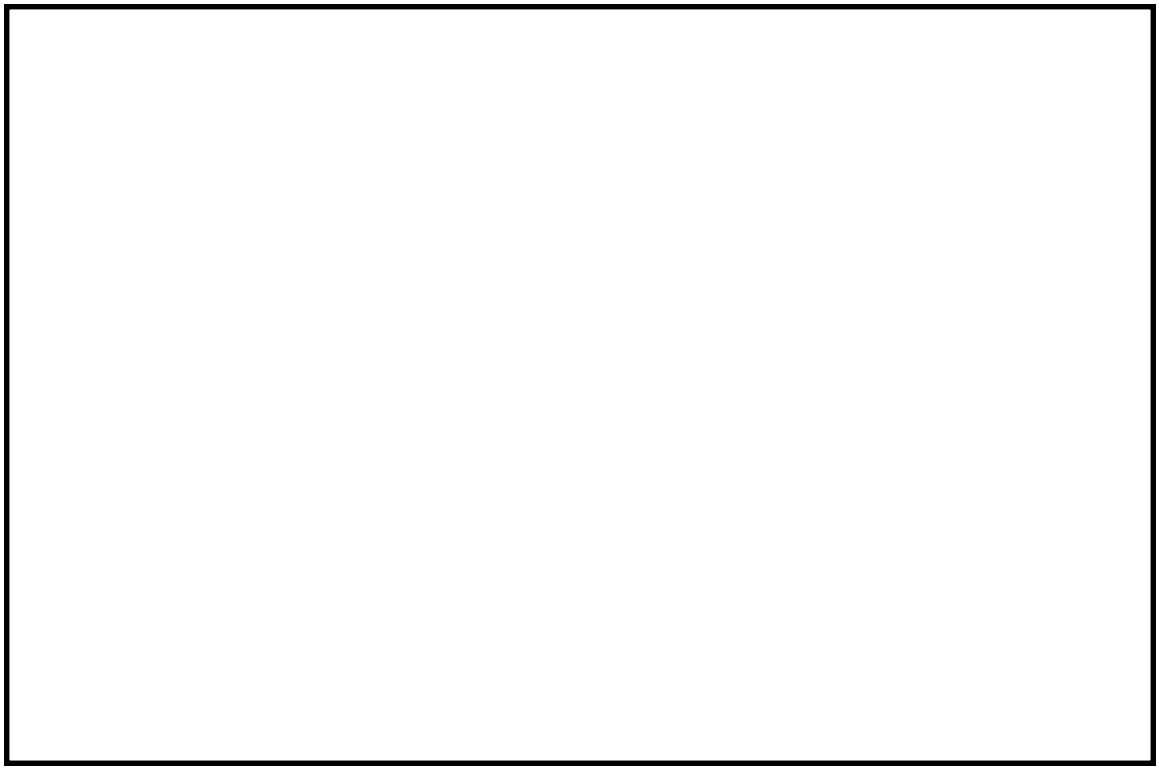
Printed in U.S.A.

To Our Customers:

This is the 3M-Matic™/AccuGlide™/Scotch™ brand equipment you ordered. It has been set up and tested in the factory with "Scotch" brand tapes. If any problems occur when operating this equipment, and you desire a service call, or phone consultation, call, write or Fax the appropriate number listed below.

Included with each machine is an Instructions and Parts List manual.

SERVICE, REPLACEMENT PARTS AND ADDITIONAL MANUALS AVAILABLE DIRECT FROM:



Order parts by part number, part description and quantity required. Also, when ordering parts and/or additional manuals, include machine name, number and type.

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3M Center, Building 220-8W-01
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1-800/328 1390

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Instruction Manual

700a, Adjustable Case Sealer, Type 39600

This instruction manual is divided into two sections as follows:

Section I Includes all information related to installation, operation and parts for the case sealer.
Section II Includes specific information regarding the AccuGlide™ II STD 2 Inch Taping Heads.

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Section I – 700a Adjustable Case Sealer

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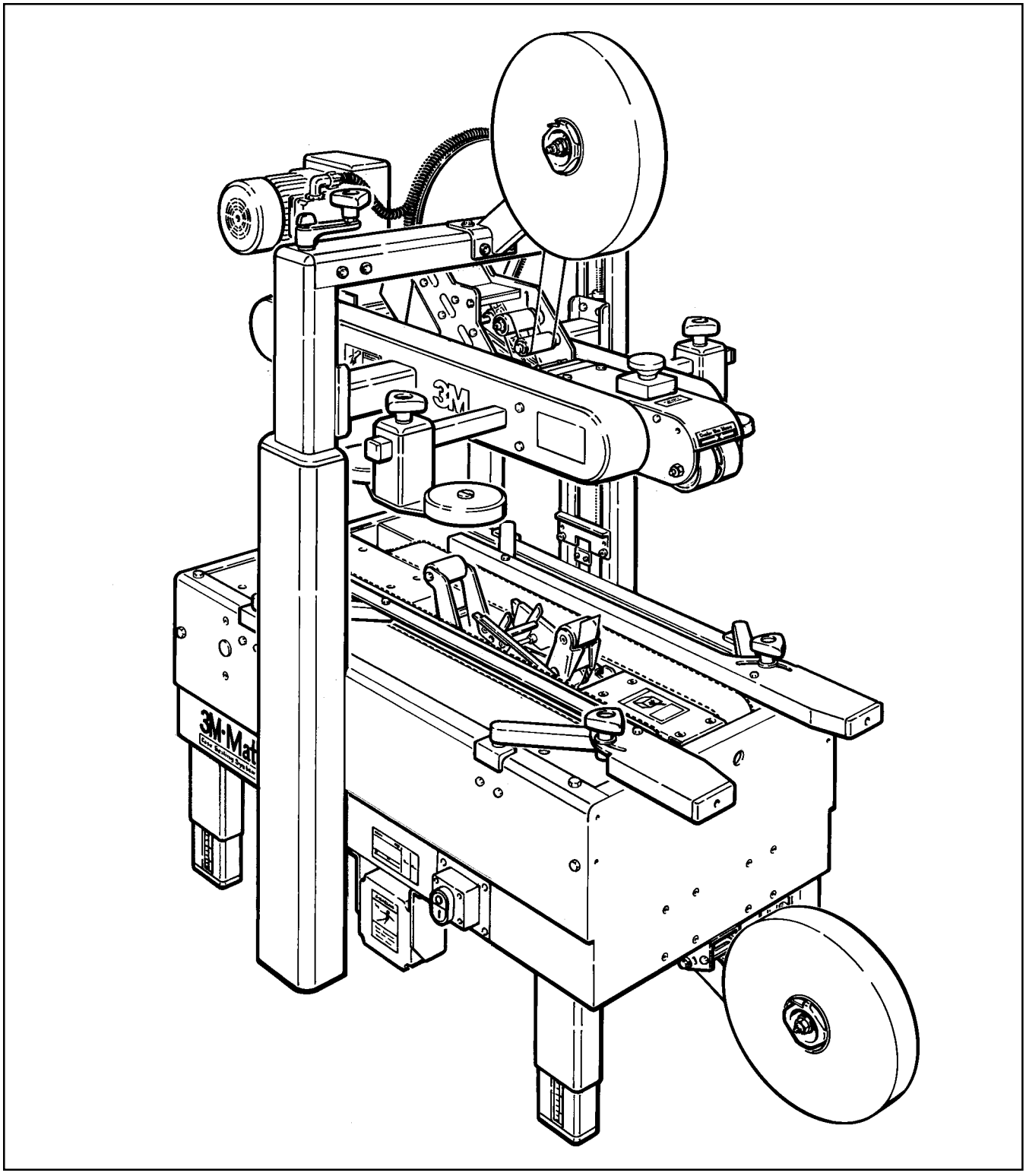
Page

Section II – AccuGlide™ II STD 2 Inch Taping Heads

(See Section II for Table of Contents)

Description

The **3M-Matic™ 700a Adjustable Case Sealer** with **AccuGlide™ II** Taping Heads is designed to apply a “C” clip of **Scotch™** brand pressure-sensitive film box sealing tape to the top and bottom center seam of regular slotted containers. The 700a is manually adjustable to a wide range of box sizes (see "Specifications – Box Weight and Size Capacities", Page 7).



3M-Matic™ 700a Adjustable Case Sealer, Type 39600 (Note – Lower tape supply roll and bracket assembly are shown in the alternate location)

Equipment Warranty and Limited Remedy: THE FOLLOWING WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, THE IMPLIED WARRANTY OF MERCHANTABILITY, THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE AND ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, A CUSTOM OR USAGE OF TRADE:

3M sells its **3M-Matic™ 700a Adjustable Case Sealer, Type 39600** with the following warranties:

1. The drive belts and the taping head knives, springs and rollers will be free from all defects for ninety (90) days after delivery.
2. All other taping head parts will be free from all defects for three (3) years after delivery.
3. All other parts will be free from all defects for two (2) years after delivery.

If any part is proved to be defective within its warranty period, then the exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to repair or replace the part, provided the defective part is returned immediately to 3M's factory or an authorized service station designated by 3M. A part will be presumed to have become defective after its warranty period unless the part is received or 3M is notified of the problem no later than five (5) calendar days after the warranty period. If 3M is unable to repair or replace the part within a reasonable time, then 3M at its option, will replace the equipment or refund the purchase price. 3M shall have no obligation to provide or pay for the labor required to install the repaired or replacement part. 3M shall have no obligation to repair or replace (1) those parts failing due to operator misuse, carelessness, or due to any accidental cause other than equipment failure, or (2) parts failing due to non-lubrication, inadequate cleaning, improper operating environment, improper utilities or operator error.

Limitation of Liability: 3M and seller shall not be liable for direct, indirect, special, incidental or consequential damages based upon breach of warranty, breach of contract, negligence, strict liability or any other legal theory.

The foregoing Equipment Warranty and Limited Remedy and Limitation of Liability may be changed only by a written agreement signed by authorized officers of 3M and seller.

Contents – 700a Adjustable Case Sealer

(1) 700a Adjustable Case Sealer, Type 39600
(1) Upper Assembly Height Adjustment Crank/Hardware
(1) Upper Tape Drum/Bracket/Hardware
(2) Column Stop Bracket/Hardware
(1) Tool/Spare Parts Kit
(1) Instruction and Parts Manual

Important Safeguards

This safety alert symbol identifies important messages in this manual. READ AND UNDERSTAND THEM BEFORE INSTALLING OR OPERATING THIS EQUIPMENT.

Important – In the event the following safety labels are damaged or destroyed, **they must be replaced to ensure operator safety**. A label kit, part number 78-8098-9175-3 is available as a stock item or individual labels can be ordered. See Parts Illustration/List, Section I, pages 58 and 59.

The **"Warning – Hazardous Voltage"** label, shown in **Figure 1-2**, is attached to the cover of the electrical enclosure. The label warns service personnel to unplug the power supply before attempting any service work on the case sealer.

Figure 1-2 – Electrical Warning Label

The **"Warning – Sharp Knife"** label, shown in **Figure 1-1**, is attached to both sides of the upper frame at the location of the cut-off blade on the upper taping head. The labels warn operators and service personnel of the very sharp knife used to cut the tape at the end of the tape application.

Figure 1-1 – Knife Warning Label

The **"Warning – Moving Belts"** labels, shown in **Figure 1-3**, are attached to both sides of the upper belt guards at the infeed end of the machine. The labels warn operators to keep hands or loose clothing away from this area because of moving belts.

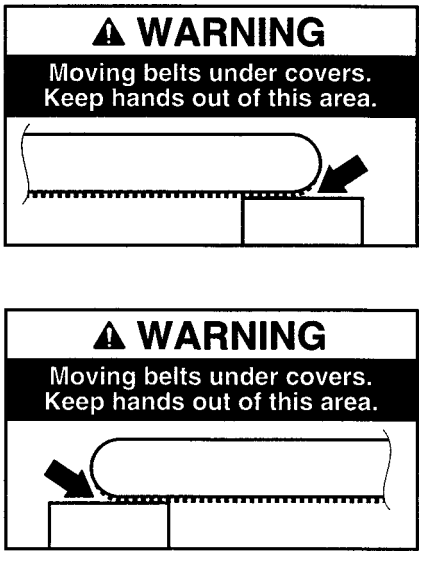


Figure 1-3 – Box Drive Belt Warning Label

Important Safeguards (Continued)

The **"Caution – Pinch Point"** label, shown in **Figure 1-4**, is attached to the center plate at the exit end of the machine bed. The label warns the operator to keep hands out of this area when the drive belts are running.

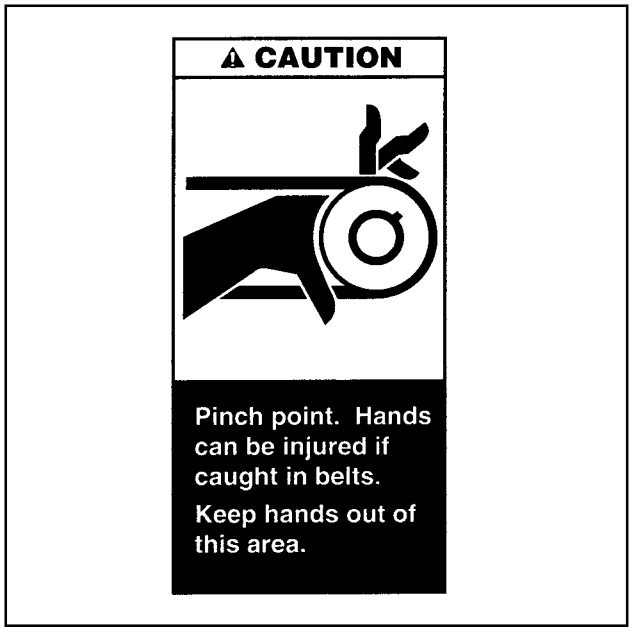


Figure 1-4 – Pinch Point Caution Label

The 700a is equipped with a "Red" emergency stop switch located on the top/front of the upper ski assembly. The **"Stop"** label, shown in **Figure 1-4,** is located near the switch and reminds operators and casual personnel of the function of this switch.

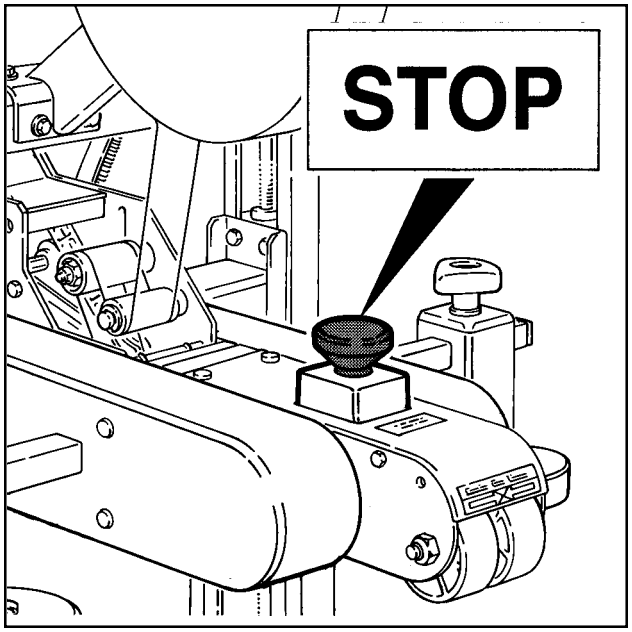


Figure 1-6 – Stop Label

The **"Safety Instructions"** label, shown in **Figure 1-5**, is attached to the top/front of the upper ski assembly. The label provides convenient safeguard instructions for the operator and service personnel.

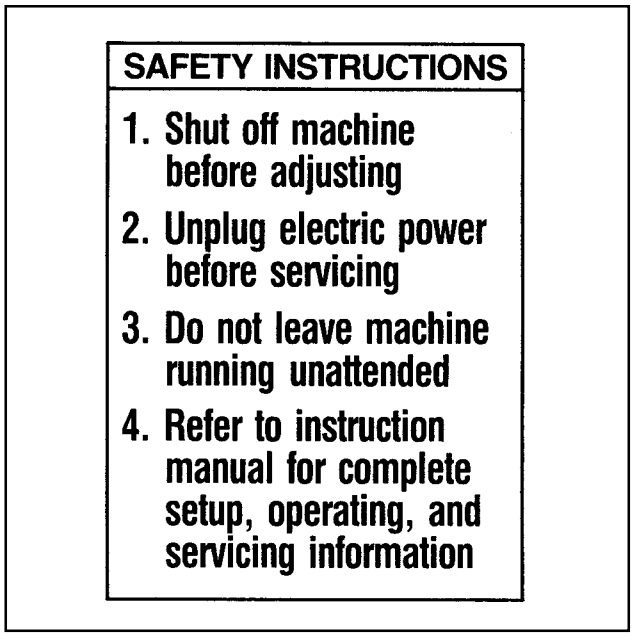


Figure 1-5 – Safety Instruction Label

The **"O/I"** (Off/On) label, shown in **Figure 1-7**, is attached to the front surface of the electrical switch on the side of the machine frame. The label reminds operators which button is "On" or "Off".

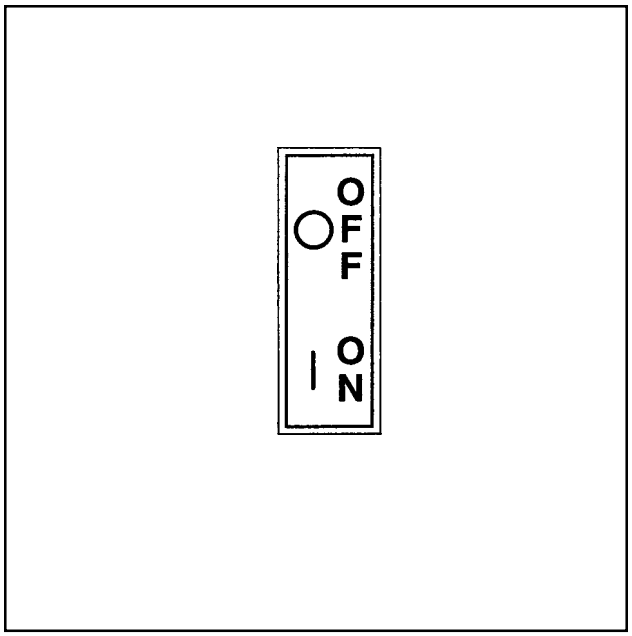


Figure 1-7 – Electrical On/Off Label

Important Safeguards (Continued)

The **"Center Box Here"** label, shown in **Figure 1-8,** is attached to the front of the upper frame to remind the operator of the proper box placement procedure.

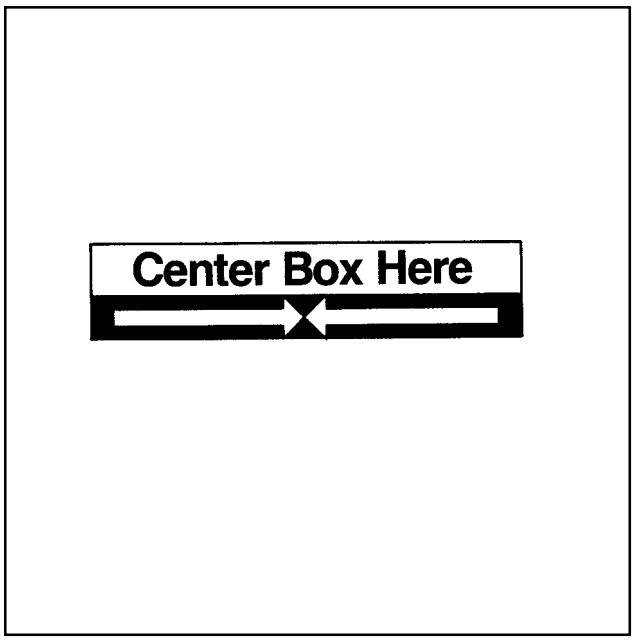


Figure 1-8 – Center Box Label

The **"Up/Down/Lock"** label, shown in **Figure 1-9**, is located on the top surface, on each side, of the upper column assembly. The label reminds the operator of the direction to turn the height adjustment crank to raise and lower the upper drive belts/taping head and the locking feature.

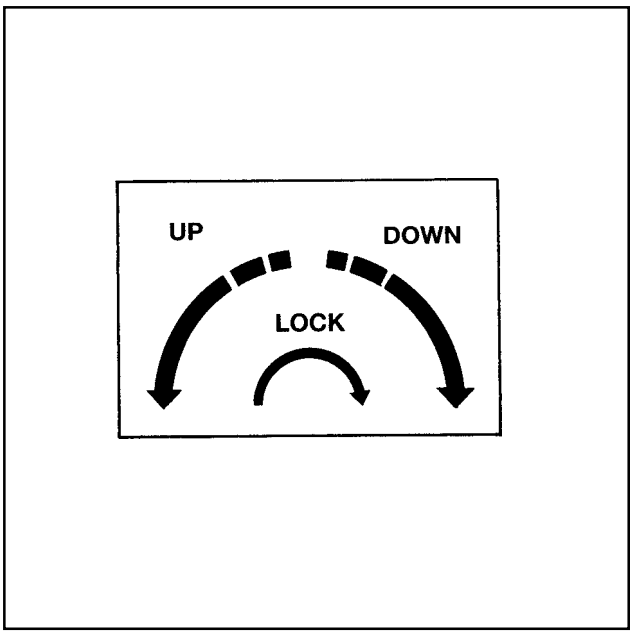


Figure 1-9 – Up/Down/Lock Label

The **"Notice – Taping Head Latch"** label, shown in **Figure 1-10** is attached to the top surface of the upper, left belt guard at the front edge of the taping head. The label reminds operators and service personnel to keep latch down except to remove taping head.

Figure 1-10 – Upper Taping Latch Label

The **"Caution – Pinch Point"** label, shown in **Figure 1-11**, is attached to the top of the compression roller brackets on both sides of the machine. The label reminds operator to keep hands away from compression rollers when machine is running.

Figure 1-11 – Pinch Point Caution Label

Specifications

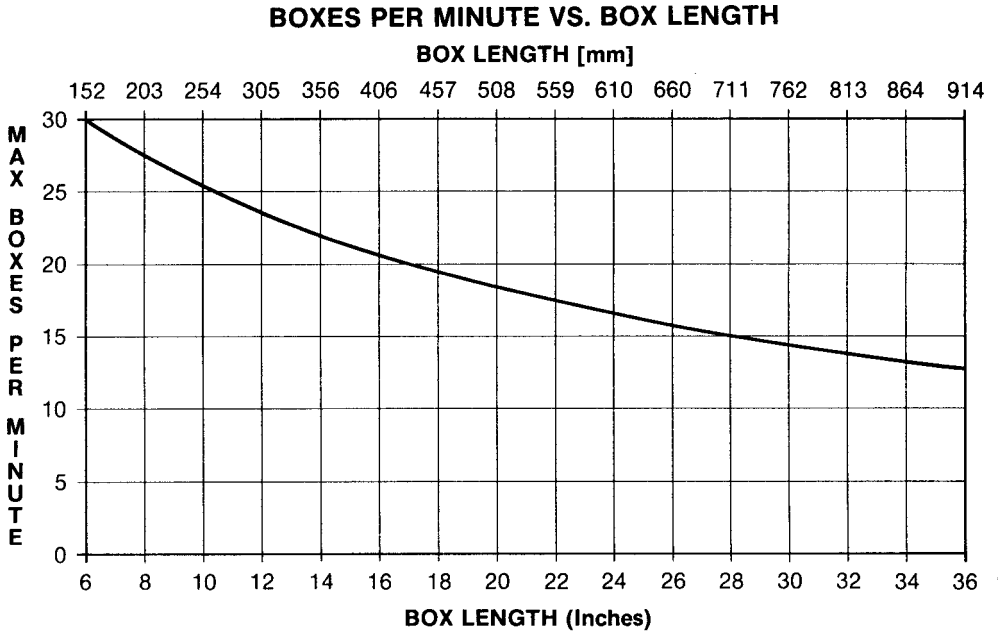
1. **Power Requirements:**

   Electrical - 115 VAC, 60 Hz, 3.8 A (440 watts)

   The machine is equipped with a 2.4 m [8 foot] standard neoprene covered power cord and a grounded plug. Contact your 3M Representative for power requirements not listed above.

2. **Operating Rate:**

   Box drive belt speed is approximately 0.4 m/s [78 feet per minute].



Actual production rate is dependent on operator's dexterity.
Boxes must be 18 inches [455mm] apart minimum.

3. Operating Conditions:

Use in dry, relatively clean environments at 5º to 40º C [40º to 105º F] with clean, dry boxes.

Note: *Machine should not be washed down or subjected to conditions causing moisture condensation on components.*

4. **Tape:**

   Scotch™ brand pressure-sensitive film box sealing tapes.

5. **Tape Width:**

   36 mm [1 1/2 inch] minimum to 48 mm [2 inch] maximum

(Specifications continued on next page)

Specifications (Continued)

6. **Tape Roll Diameter:**

   Up to 405 mm [16 inch] maximum on a 76.2 mm [3 inch] diameter core.
   (Accommodates all system roll lengths of **Scotch**™ brand film tapes.)

7. **Tape Application Leg Length – Standard:**

   70 mm ± 6 mm [2.75 inch ±.25 inch]

   Tape Application Leg Length – Optional:
   50 mm ± 6 mm [2 inch ±.25 inch]
   (See "Special Set-Up Procedure – Changing the Tape Leg Length", Page 25.)

8. **Box Board:**

   Style – regular slotted containers – RSC
   125 to 275 P.S.I. bursting test, single wall or double wall B or C flute.

9. **Box Weight and Size Capacities:**

   A. Box Weight, filled – up to 38.6 kg [85 lbs.] maximum. Contents must support flaps.

   B. Box Size:

	Minimum	**Maximum**
Length –	150 mm [6.0 inch]	Unlimited
Width –	150 mm [6.0 inch]*****	550 mm [21.5 inch]
Height –	120 mm [4.75 inch]****** *******	620 mm [24.5 inch] *******

   ***** Cartons narrower than 250 mm [10 inch] in width may require more frequent belt replacement because of limited contact area.
   ****** 90 mm [3.5 inch] height with heads adjusted to apply 50 mm [2 inch] tape leg lengths. (See "Special Set-Up Procedure – Changing the Tape Leg Length", Page 25.)
   ******* 165 mm [6.5 inch] minimum to 725 mm [28.5 inch] maximum height with columns adjusted to upper position. (See "Special Set-Up Procedure – Box and Machine Bed Height Range", Page 26.)

   Special modifications may be available for carton sizes not listed above.
   Contact your 3M Representative for information.

   Note: The case sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is .5 or less, then several boxes should be test run to assure proper machine performance.

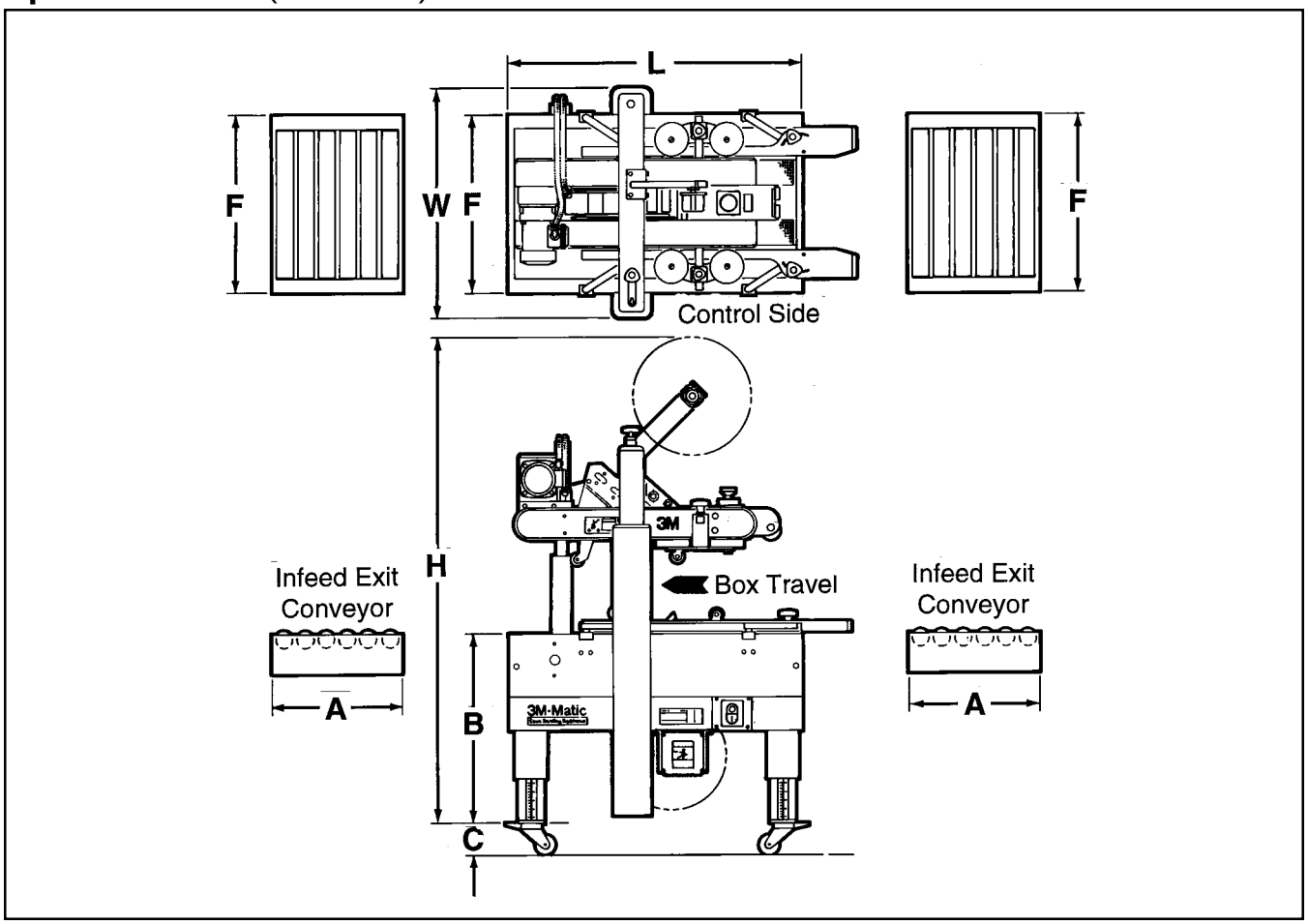
   DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

$$\frac{\textbf{BOX LENGTH IN DIRECTION OF SEAL}}{\textbf{BOX HEIGHT}} = \textbf{MUST BE GREATER THAN .5}$$

   Any box ratio approaching this limitation should be test run to assure performance.

(Specifications continued on next page.)

Specifications (Continued)



10. Machine Dimensions:

	W	L	H	A*	B	C**	F
Minimum							
mm	790	1030	1350	460	610	100	625
[Inches]	[31]	[40 .5]	[53]	[18]	[24]***	[4]	[24.5]
Maximum							
mm			2185		890		
[Inches]	- -	- -	[86]***	- -	[35]***	- -	- -

* Infeed/Exit conveyors are optional

** Casters are optional

*** When columns are adjusted to upper position, "B" minimum dimension is 520 mm [20.5 inch], maximum dimension is 780 mm [31 inch] and "H" maximum dimension is 2290 mm [90 inch]. (See "Special Set-Up Procedure – Box and Machine Bed Height Range", Page 26.)

Weight – 180 kg [400 lbs] crated (approximate)
160 kg [350 lbs] uncrated (approximate)

11. **Set-Up Recommendations:**

- Machine must be level.
- Customer supplied infeed and exit conveyors (if used) should provide straight and level box entry and exit.
- Exit conveyors (powered or gravity) must convey sealed boxes away from machine.

Installation and Set-Up

Receiving And Handling

After the machine has been uncrated, examine the case sealer for damage that might have occurred during transit. **If damage is evident, file a damage claim immediately** with the transportation company and also notify your 3M Representative.

Machine Set-Up

Important – Read "Warnings", on page 14, before attempting to set-up the case sealer for operation.

The following instructions are presented in **the order recommended** for setting up and installing the case sealer, as well as **for learning the operating functions and adjustments**. Following them step by step will result in your thorough understanding of the machine and an installation in your production line that best utilizes the many features built into the case sealer. Refer to Figure 3-1 to identify the various components of the case sealer.

Note – *A tool kit consisting of metric open end and hex socket wrenches is provided with the machine. These tools should be adequate to set-up the machine, however, other tools supplied by the customer will be required for machine maintenance.*

PACKAGING AND SEPARATE PARTS

1. Remove straps and staples and lift fiberboard cover off pallet.
2. Remove protective wrapping around machine.
3. Cut and remove cable tie from electrical conduit.
4. Cut cable ties that secure upper assembly to machine bed on each side.
5. Remove tape drum bracket bolts (4) from top crossbar and install tape drum bracket from parts box as shown in Figure 2-1A.
6. Loosen and move both compression rollers out so they don't catch on side guides.
7. Install height adjustment crank and locking knob on top of left column as shown in Figure 2-1B. Crank upper assembly up high enough to allow clear access to lower taping head. Remove and discard the two cushion shipping blocks.
8. Using 17 mm wrench, remove nuts from top of side guides. Replace with black knobs from parts box. Figure 2-1C.
9. Cut and remove cable ties on both upper and lower taping heads. (Applying/buffing rollers are held retracted for shipment.)

WARNING – Follow this step carefully as spring pressure is applied to applying and buffing arms when cable tie is removed. Keep hands/fingers AWAY from tape cut-off blade under orange blade guard. Blade is extremely sharp and can cause severe injury.

Hold taping head BUFFING ROLLER and cut and remove cable tie that holds applying/ buffing arms retracted. See Figure 2-1D. Allow buffing/applying arms to extend slowly.

10. Install machine stops onto columns as shown in Figure 2-1E. Use the lowest hole position and bolt into the lowest threaded insert on the column. (The upper hole position in the stops is only used when the taping heads are adjusted to apply 50 mm [2 inch] tape legs or boxes lower than 120 mm [4.75 inch] need to be sealed.)

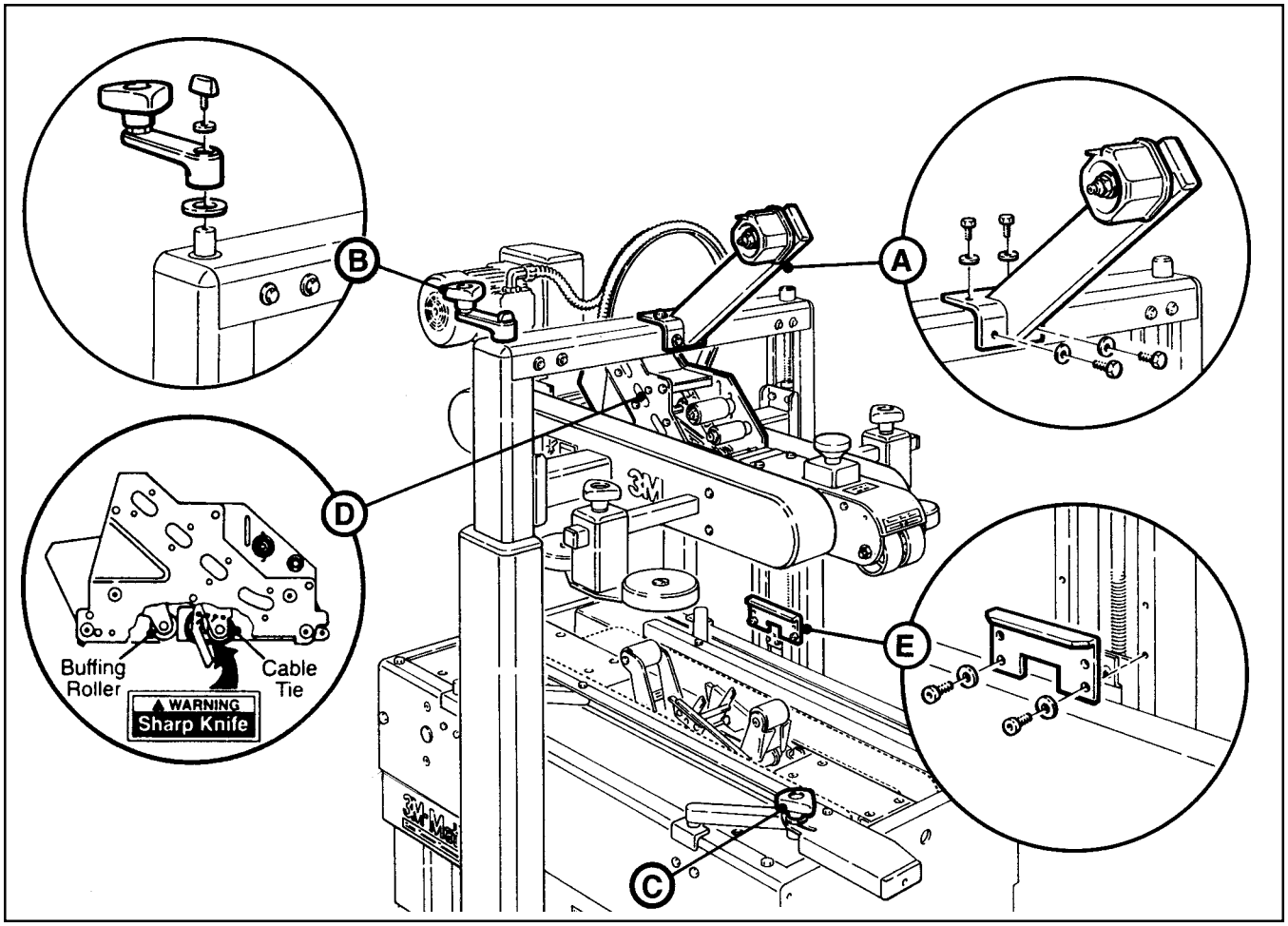


Figure 2-1 – 700a Frame Set-Up

11. Check for free action of both upper and lower taping heads.

> **WARNING – Keep hands/fingers away from tape cut-off blade under orange blade guard. Blade is extremely sharp and can cause severe injury.**

Push buffing roller into head to check for free, smooth action of taping heads.

12. Ensure that the tape drum bracket assembly, located on the lower taping head, is mounted straight down, as shown in Figure 2-2A. The tape drum bracket assembly can be pivoted to provide tape roll clearance in certain cases.

13. Remove fasteners that secure case sealer legs to pallet.

14. Use appropriate material handling equipment to remove the machine from the pallet and move it into position.

    Whenever the machine is lifted with a fork truck, insure that the forks span completely across the machine frame and do not contact any wiring or mechanism under the machine frame. In some cases the lower taping head may need to be removed to avoid damage.

> **CAUTION – Machine weighs approximately 160 kg [350 pounds] uncrated.**

15. Continue with the remainder of the Installation and Set-Up procedure through page 12.

MACHINE BED HEIGHT

Adjust machine bed height. The case sealer is equipped with four adjustable legs that are located at the corners of the machine frame. The legs can be adjusted to obtain different machine bed heights from 610 mm [24 inch] minimum to 890 mm [35 inch] maximum.

Note – *Minimum machine bed height can be reduced to 520 mm [20.5 inch] by moving outer columns up one set of mounting holes. However, this change also reduces minimum box height of 120 mm [4.8 inch] to 165 mm [6.5 inch]. (See "Special Set-Up Procedure – Box/Machine Bed Height Range", page 26.)*

Refer to Figure 2-2C and set the machine bed height as follows:

1. Use appropriate material handling equipment and blocking techniques to raise the machine frame to allow adequate leg adjustment.

⚠ CAUTION – Machine weighs approximately 160 kg [350 pounds] uncrated.

2. Loosen, but do not remove, two M8 x 1.25 socket head screws in one leg (use M6 hex wrench). Adjust the leg length for the desired machine bed height. Retighten the two screws to secure the leg. Adjust all four legs equally.

OUTBOARD TAPE ROLL MOUNTING
(Lower Taping Head)

Remove the tape drum bracket assembly, spacer and fasteners from the lower taping head. Install and secure on the infeed end of the lower frame, as shown in Figure 2-2B.

TAPE LEG LENGTH

Taping heads are pre-set to apply 70 mm [2.75 inch] long tape legs. To change tape leg length to 50 mm [2.0 inch], see "Special Set-Up Procedure – Changing the Tape Leg Length", page 25.

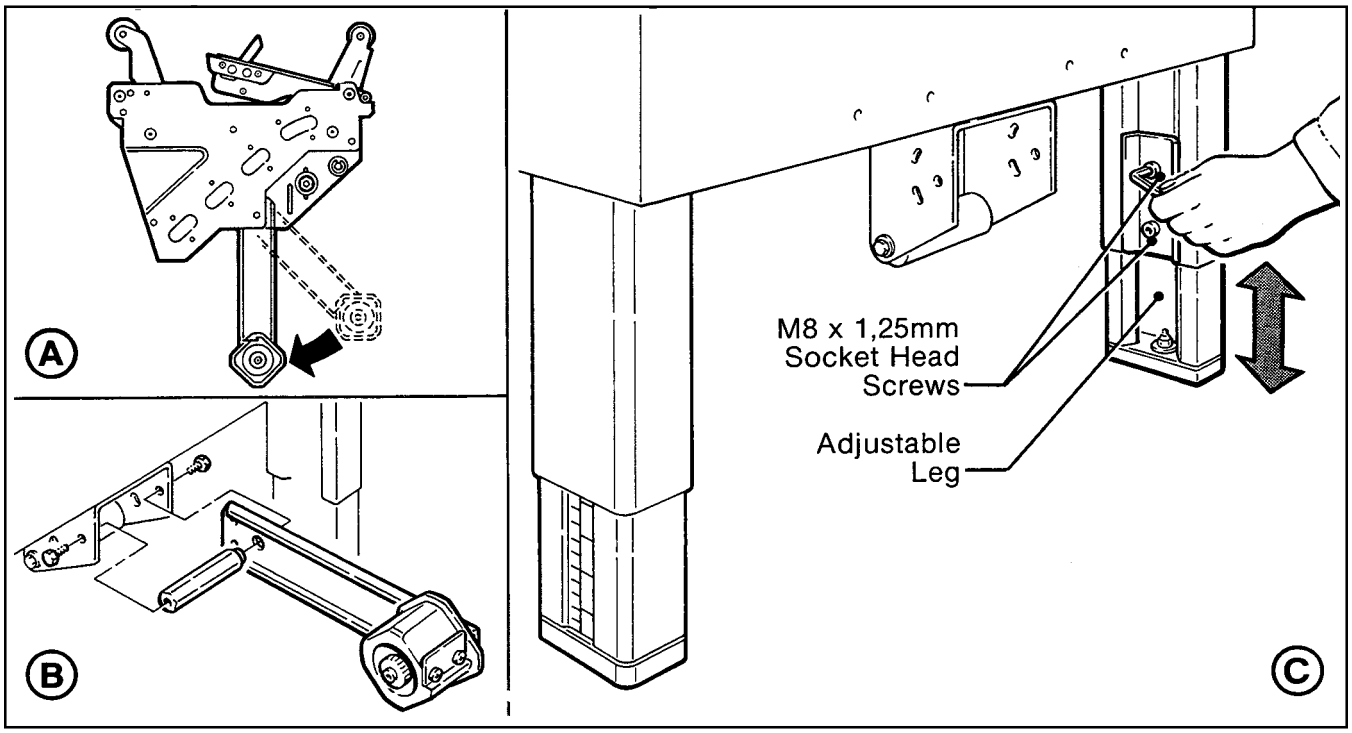


Figure 2-2 – Machine Bed Height Adjustment and Lower Tape Drum Bracket Position

Installation and Set-Up (Continued)

BOX SIZE CAPACITY OF CASE SEALER

At its factory setting, the case sealer handles box sizes up to 620 mm [24.5 inch] maximum height. If larger capacity is needed, the machine can be adjusted to accommodate boxes up to 725 mm [28.5 inch] high. Refer to "Special Set-Up Procedure – Box and Machine Bed Height Range", page 26. **Note – Adjusting machine to accommodate 725 mm [28.5 inch] high boxes also increases minimum box size to 165 mm [6.5 inch].**

ELECTRICAL CONNECTION AND CONTROLS

The electrical control box (with circuit breaker) and "On/Off" switch are located on the lower left side of the machine frame. See Figure 3-1. If desired, for operator convenience, the "On/Off" switch can be relocated to the right side of the machine frame. A standard three conductor power cord with plug is provided at the back of the electrical control box for 115 Volt, 60 Hz., 3.8 Amp electrical service. The receptacle providing this service shall be properly grounded. Before the power cord is plugged into 115 Volt, 60 Hz outlet make sure that all packaging materials and tools are removed from the machine. **Do not plug electrical cord into outlet until ready to run machine.**

Use of an extension cord is not recommended. However, if one is needed for temporary use, it must have a wire size of 1.5 mm diameter [AWG 16], have a maximum length of 30.5 m [100 ft], and must be properly grounded.

WARNING – To prevent shock and fire hazard: Position extension cord where it will be out of the way of foot or vehicle traffic. Extension cord is only for temporary use – do not use for a permanent installation.

Note – *Machines outside the U.S. may be equipped with 220/240 Volt, 50 Hz systems or other electrical requirements compatible with local practice.*

INITIAL START-UP OF CASE SEALER

After completing the "Installation and Set-Up" procedure, continue through "Operation" for tape loading and start-up to be sure case sealer is properly adjusted to run boxes

Operation

IMPORTANT – Before operating the case sealer, read the "Safety Labels", pages 3-5 and "Warnings" on page 14 as well as all of the "Operation" instructions.

Refer to Figure 3-1 below to acquaint yourself with the various components and controls of the case sealer. Also see Figures 3-1 and 3-2 in Section II for taping head components.

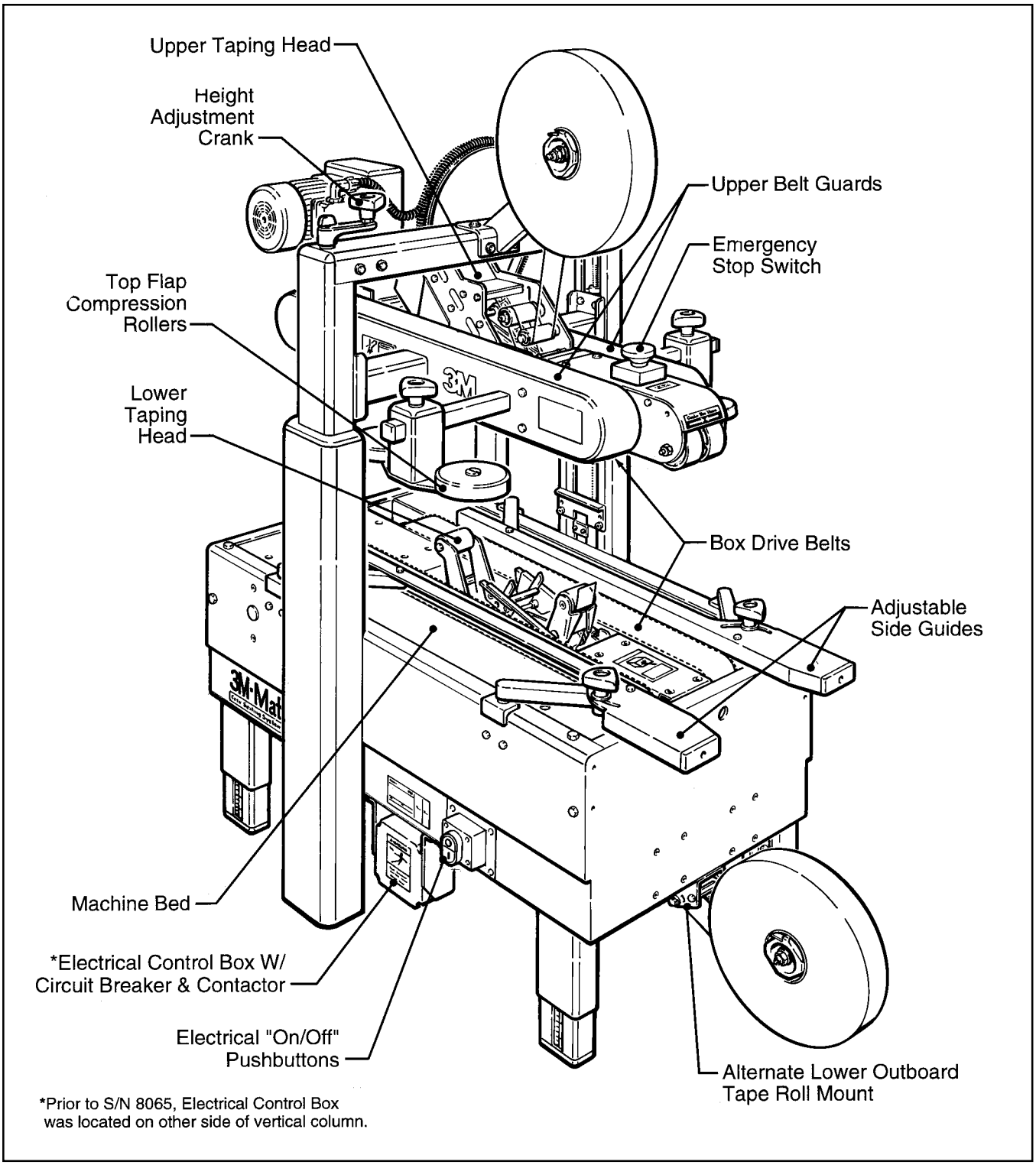


Figure 3-1 – 700a Case Sealer Components (Left Front View)

WARNINGS

1. **Turn electrical supply off and disconnect before servicing taping heads or performing any adjustments or maintenance on the machine.**
2. **Do not leave machine running unattended.**
3. **Before turning drive belts on, be sure no tools or other objects are on the machine bed.**
4. **Keep hands and loose clothing away from moving belts.**
5. **Keep hands and clothing away from taping heads when machine is running. A box traveling through the machine causes taping head rollers to retract when box enters and extend as box leaves taping head.**
6. **Never attempt to work on any part of the machine, load tape or remove jammed boxes from the machine while machine is running.**
7. **When feeding boxes to the machine by hand, push box in from end only – DO NOT PUSH WITH HANDS ON ANY CORNER OF THE BOX.**
8. **Both the upper and lower taping heads utilize extremely sharp knife blades. The blades are located under the orange blade guard which has the 'WARNING – SHARP KNIFE" label. Before loading tape, refer to Figures 3-1 and 3-2 in Section II to identify the blade location. Keep hands out of these areas except as necessary to service the taping heads.**
9. **Turn drive belts "Off" when machine is not in use.**
10. **Failure to comply with these warnings could result in severe personal injury and/or equipment damage.**

Electrical "On/Off" Switch

The box drive belts are turned on and off ("Off" button is red) with the electrical switch on the side of the machine frame.

Note – *The case sealer has a circuit breaker located in the electrical enclosure on the lower left side of the machine frame. If circuit becomes overloaded and circuit breaker trips,* ***unplug the machine electrical cord*** *and determine cause of overload. After two minutes, open the electrical enclosure and reset the circuit breaker by lifting the reset lever. Close the electrical enclosure, plug machine electrical cord into outlet and restart machine by pressing "I" (On) button.*

Emergency Stop Switch

The machine electrical supply can be turned off by pressing the latching emergency stop switch. To restart machine, rotate emergency stop switch (releases switch latch) and then restart machine by pressing "I" (On) button on side of machine frame.

Tape Loading/Threading

See Section II, Pages 7 and 8

Note – *If lower tape drum is mounted in alternate lower outboard position, remove taping head from machine bed by pulling straight up, insert threading needle in taping head and replace taping head. Install tape roll on drum (adhesive on tape leg up), thread tape under knurled roller on outboard mount, then attach tape to threading needle and pull tape through taping head with threading needle.*

CAUTION – Taping head weighs approximately 7.2 kg [16 pounds] without tape. Use proper body mechanics when removing or installing taping head.

Operation (Continued)

Box Size Set-Up

1. ADJUST UPPER TAPING HEAD

   The upper taping head is positioned for the box height by means of the height adjustment crank shown in Figure 3-2. Turn crank clockwise to lower head, counterclockwise to raise head.

   Move the top flap compression rollers to a position wider than the box.

   Place box on infeed end of machine bed with both top and bottom flaps folded and insert under upper head ski approximately 150 mm [6 inch] as shown in Figure 3-3. Lower the head until all flaps are fully closed. Align box top flap center seam with arrows on front of upper frame.

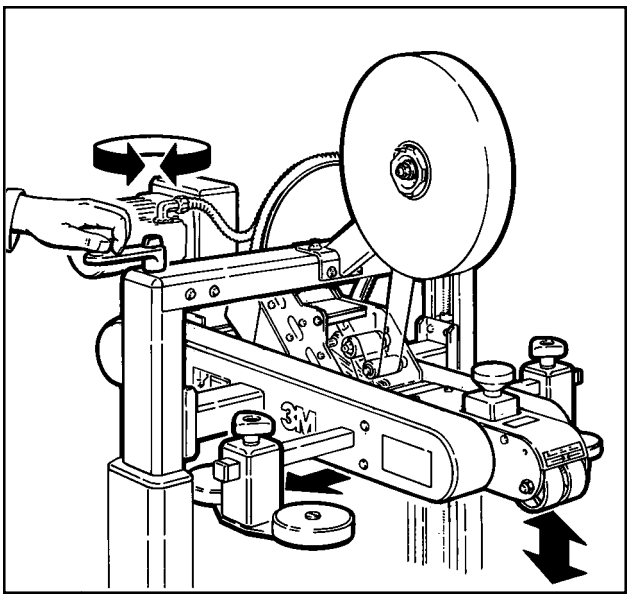


Figure 3-2 – Upper Taping Head

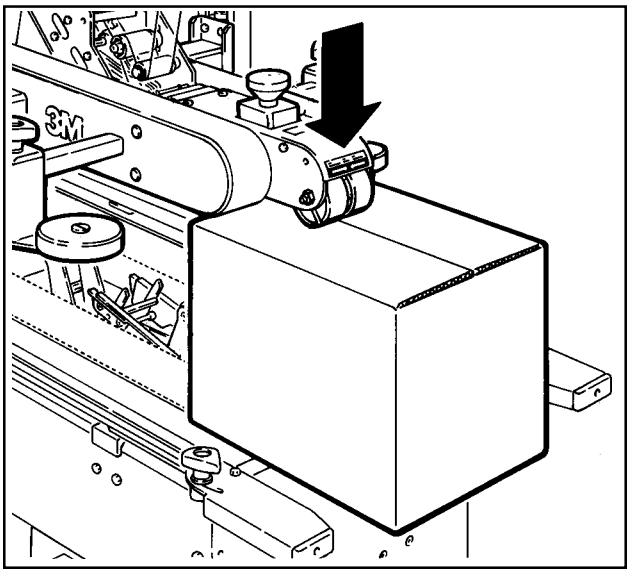


Figure 3-3 – Upper Taping Head

2. ADJUST SIDE GUIDES (Figure 3-4)

   Align box top flap center seam with arrows on front of ski.

   Move side guides against each side of box to hold box in position, centered on arrows on front of ski.

   Tighten hand knobs to secure side guides.

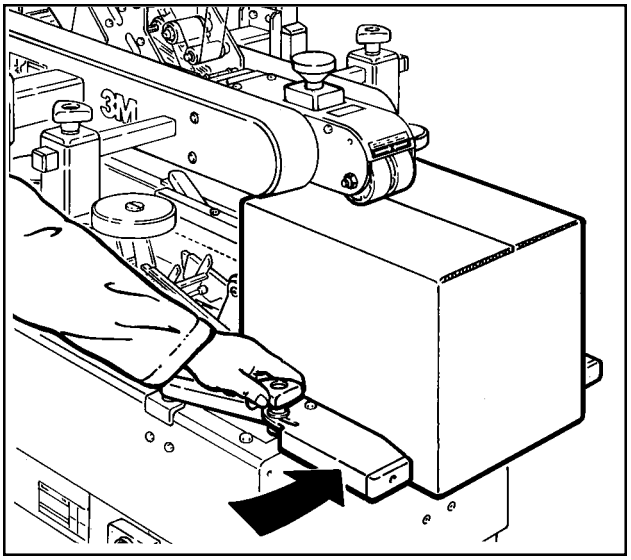


Figure 3-4 – Side Guides

Operation (Continued)

3. RUN BOXES TO CHECK ADJUSTMENT (Figure 3-5)

   Turn electrical switch to **"On"** to start drive belts. Move box forward under upper taping head until it is taken away by drive belts. If box is hard to move under head or is crushed, **raise** head slightly. If box movement is jerky or stops under upper head, **lower** upper head slightly to add more pressure between box and drive belts.

   Note – *Upper head has unique feature for overstuffed boxes. The head will raise up to 13 mm [1/2 inch] to compensate for this type of condition.*

⚠ CAUTION – If drive belts are allowed to slip on box, excessive belt wear will occur.

4. TOP FLAP COMPRESSION ROLLERS (Figure 3-6)

   The top flap compression rollers, have two mounting positions to provide side compression through the full range of box widths.

   The rollers have been pre-assembled in position **"B"** to accommodate box widths from 200 mm [8 inch] to 545 mm [21.5 inch] maximum.

   To accommodate box widths less than 200 mm [8 inch] to 140 mm [5.5 inch] minimum, move all four rollers to position **"A"**.

   Adjust the top flap compression rollers against top edge of box and tighten knobs to secure rollers in operating position.

5. ADJUST COMPRESSION ROLLERS

   Adjust the top flap compression rollers against top edge of box and tighten knobs to secure rollers in operating position as shown in Figure 3-7.

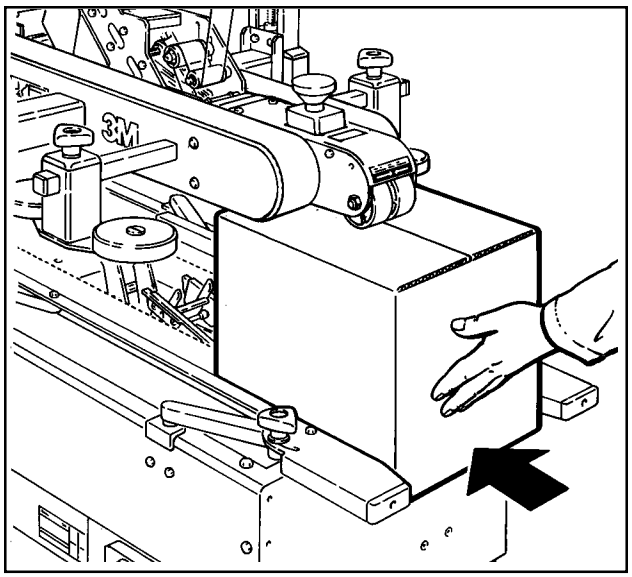


Figure 3-5 – Check Adjustments

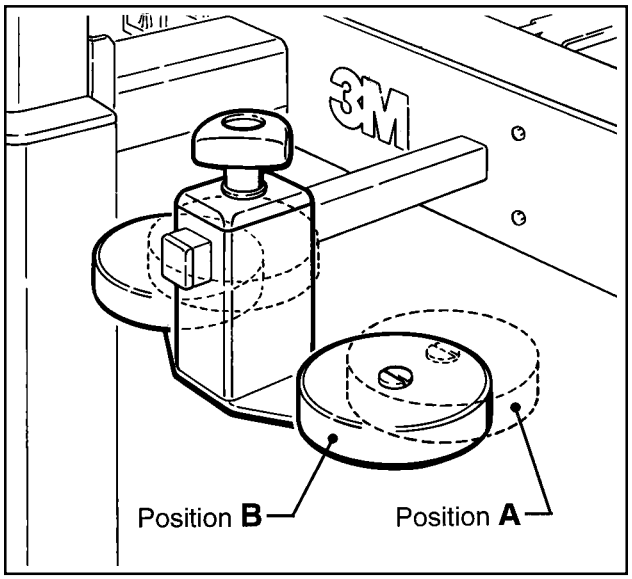


Figure 3-6 – Compression Rollers

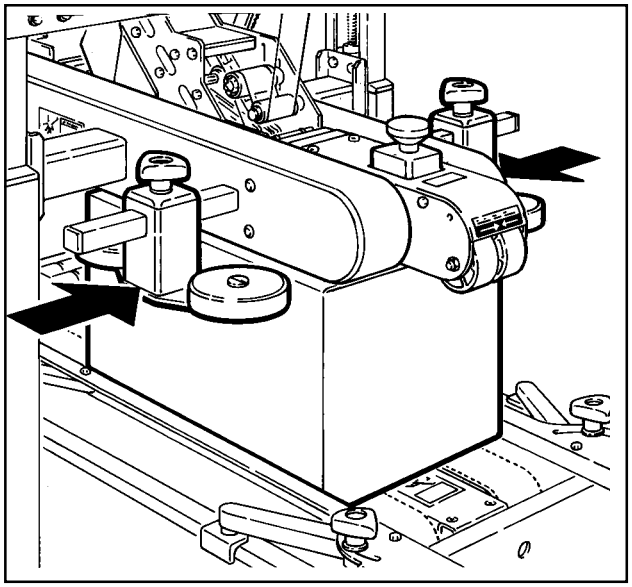


Figure 3-7 – Compression Rollers

Operation (Continued)

Box Sealing

1. Feed boxes to machine at minimum 455 mm [18 inch] intervals.

2. Turn electrical supply "Off" when machine is not in use.

3. Reload and thread tape as necessary.

4. Be sure machine is cleaned and lubricated according to recommendations in "Maintenance" section of this manual.

Notes –

1. Machine or taping head adjustments are described in "Adjustments" Section I for machine or Section II for taping heads.

2. Box drive motors are designed to run at a moderate temperature of 40°C [104°F]. In some cases, they may feel hot to the touch.

Maintenance

The case sealer has been designed for long, trouble free service. The machine will perform best when it receives routine maintenance and cleaning. Machine components that fail or wear excessively should be promptly repaired or replaced to prevent damage to other portions of the machine or to the product.

WARNING – Turn off electrical power supply and disconnect power cord from electrical supply before beginning maintenance. If electrical power is not disconnected, severe injury to personnel could result.

Cleaning

Note – Never attempt to remove dirt from the machine by blowing it out with compressed air. This can cause the dirt to be blown inside the motor and onto sliding surfaces which may cause premature equipment wear. Never wash down or subject equipment to conditions causing moisture condensation on components. Serious equipment damage could result.

Regular slotted containers produce a great deal of dust and paper chips when processed or handled in equipment. If this dust is allowed to build-up on machine components, it can cause component wear and overheating of drive motor. The dust build-up can best be removed from the machine by a shop vacuum. Depending on the number and type of boxes sealed in the case sealer, this cleaning should be done approximately once per month. If the boxes sealed are dirty, or if the environment in which the machine operates is dusty, cleaning on a more frequent basis may be necessary. Excessive dirt build-up that cannot be removed by vacuuming should be wiped off with a damp cloth.

Lubrication

Most of the machine bearings, including the drive motor, are permanently lubricated and sealed and do not require additional lubricant.

Figure 4-1 illustrates the machine points that do require lubrication every 250 hours of operation. Lubricate the points indicated by arrows (⇨) with a small amount of multi-purpose grease.

Note – *Wipe off excess oil and grease. It will attract dust which can cause premature equipment wear and jamming. Take care that oil and grease are not left on the surface of rollers around which tape is threaded, as it can contaminate the tape's adhesive.*

TAPING HEAD LUBRICATION – See Section II, "Maintenance – Lubrication", page 10.

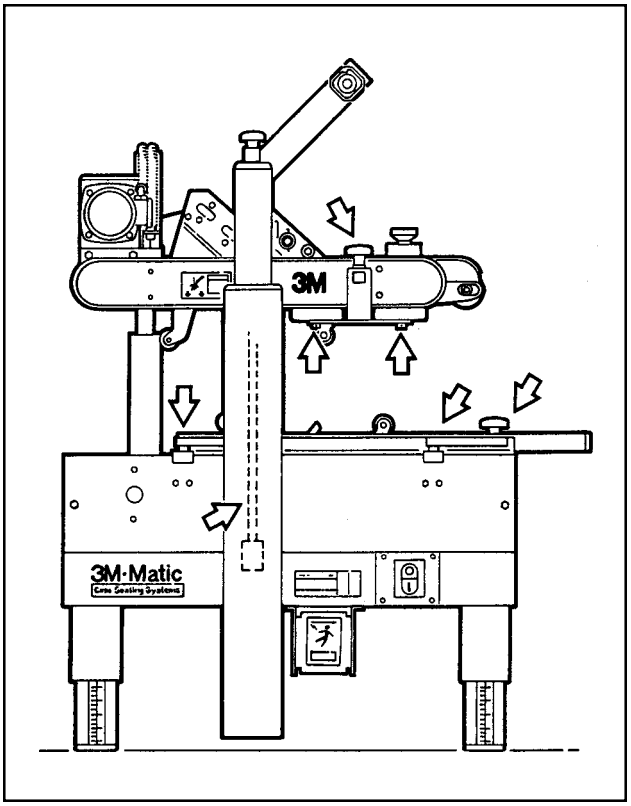


Figure 4-1 – Lubrication Points – Frame

WARNING – Turn off electrical power supply and disconnect power cord from electrical supply before beginning maintenance. If power cord is not disconnected, severe injury to personnel could result.

Box Drive Belt Replacement

Note – *3M recommends the replacement of drive belts in pairs, especially if belts are unevenly worn.*

LOWER DRIVE BELTS
Figure 4-2

1. Remove and retain center plate **(A)** and four screws.
2. Remove and retain side cover **(B)** and fasteners.
3. Loosen, but do not remove lock nut **(C)**.
4. Loosen tension screw **(D)** until all belt tension is removed.
5. Pull belt splicing pin **(E)** out and remove belt.
6. Place new belt over pulleys with laced splice at top. Insert splicing pin. **Note - Pin must not extend beyond edge of belt.**
7. Adjust belt tension as explained in "Adjustments - Box Drive Belt Tension", Page 21.
8. Replace side cover and center plate and secure with original fasteners.

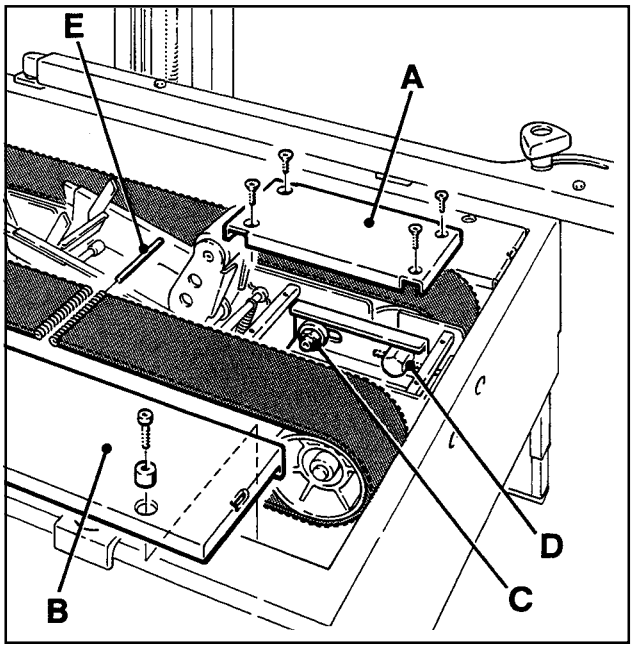


Figure 4-2 – Lower Drive Belt Replacement

UPPER DRIVE BELTS
Figure 4-3

1. Remove and retain front cover **(A)** and four screws.
2. Loosen, but do not remove lock nut **(C)**.
3. Loosen tension screw **(D)** until all tension is removed from belt.
4. Move compression roller assembly out to full open position.
5. Remove 4 screws on side of belt guard **(E)** and slide belt guard out to expose belt.
6. Pull belt splicing pin **(F)** out and remove belt.
7. Place new belt over pulleys with laced splice at top. Insert splicing pin. **Note – Pin must not extend beyond edge of belt.**
8. Adjust belt tension as explained in "Adjustments – Box Drive Belt Tension", page 21.
9. Replace front cover and belt guard(s) and secure with original fasteners.

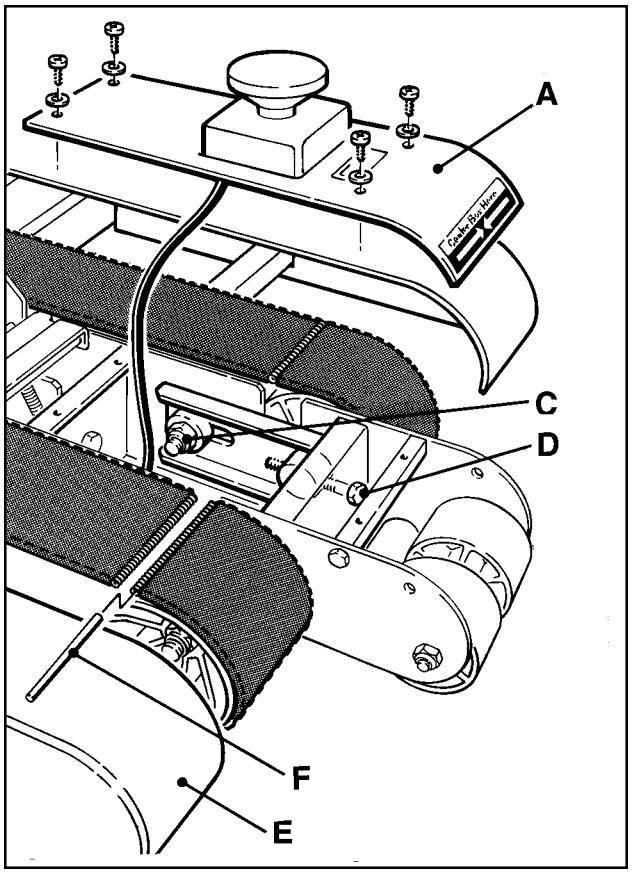


Figure 4-3 – Upper Drive Belt Replacement

Maintenance (Continued)

WARNING – Turn off electrical power supply and disconnect power cord from electrical supply before beginning maintenance. If power cord is not disconnected, severe injury to personnel could result.

Circuit Breaker

The case sealer is equipped with a circuit breaker which trips if the motors are overloaded. Located inside the electrical enclosure on the side of the machine frame just below the machine bed, the circuit breaker has been pre-set at 2.2 amps and requires no further maintenance.

If circuit is overloaded and circuit breaker trips, unplug machine from electrical power:

1. Determine cause of overload and correct.
2. Remove electrical enclosure cover.
3. Press "Reset" and then press "On" button. If circuit breaker will not reset, wait 2 minutes and retry.
4. Replace cover.
5. Plug in machine.
6. Press machine "On" button to resume case sealing.

Blade Replacement, Taping Head

See Section II, "Maintenance – Blade Replacement", page 9.

Adjustments

WARNING – Turn off electrical power supply and disconnect power cord from electrical supply before beginning adjustments. If power cord is not disconnected, severe injury to personnel could result.

Box Drive Belt Tension

The four continuously moving drive belts convey boxes through the tape applying mechanism. The box drive belts are powered by an electric gear motor.

Tension adjustment of these belts may be required during normal operation. Belt tension must be adequate to positively move the box through the machine and the belts should run fully on the surface of the pulleys at each end of the frame. The idler pulleys on the infeed end are adjusted in or out to provide proper belt tension. Each belt is adjusted separately.

Belt tension is obtained by tightening the adjustment screw so that a moderate pulling force of 3.5 kg [7 lbs.] applied at the midspan, as shown in Figure 5-1, will deflect the belt 25 mm [1 inch]. This will assure positive contact between the belt and the drive pulley on the discharge end of the drive assembly. **Note – Figure 5-1 illustrates the lower drive belts, however, upper belts are adjusted in the same manner.**

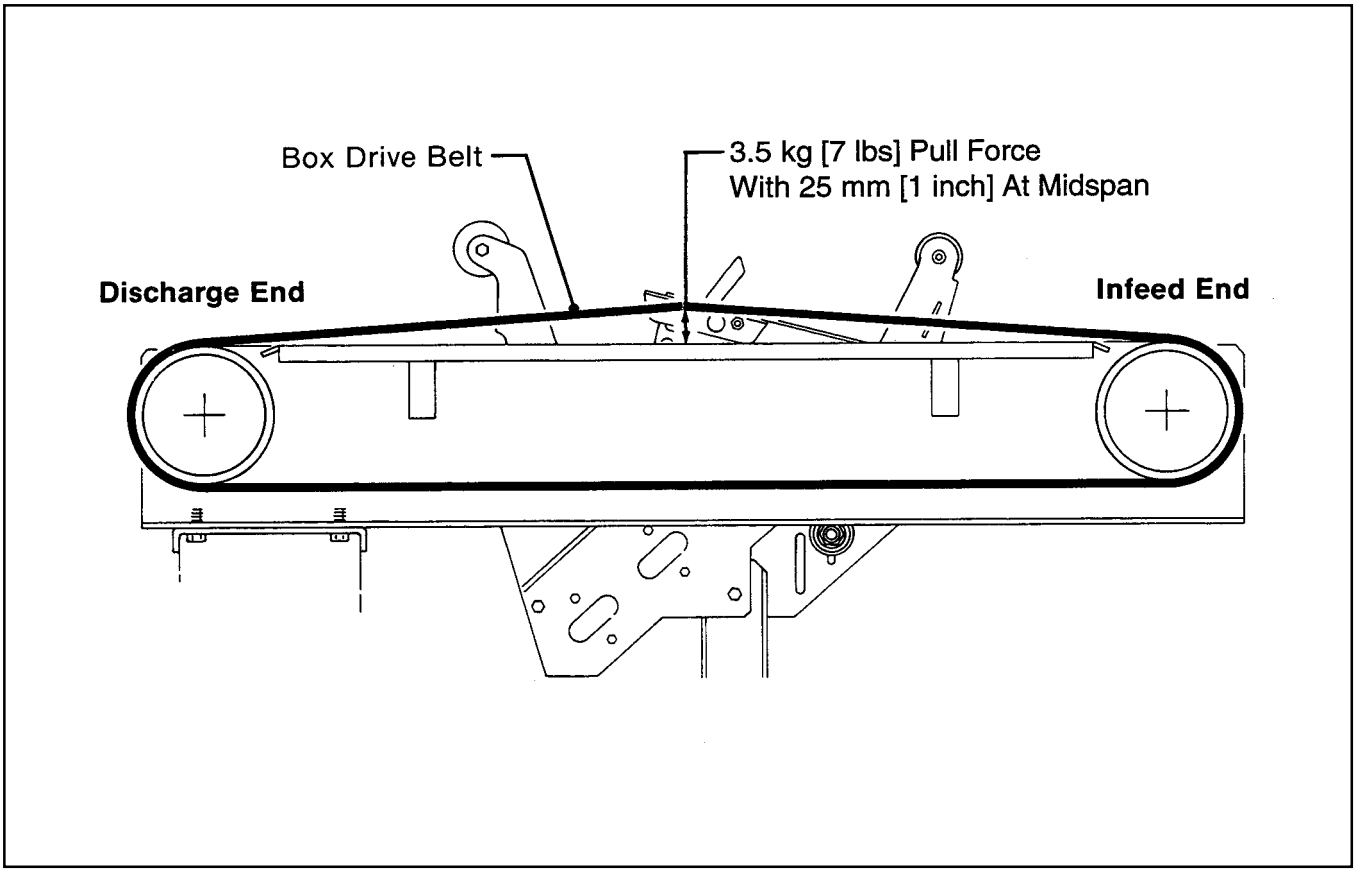


Figure 5-1 – Box Drive Belt Tension Adjustment

Adjustments (Continued)

WARNING – Turn off electrical power supply and disconnect power cord from electrical supply before beginning adjustments. If power cord is not disconnected, severe injury to personnel could result.

Refer to Figure 5-2 and 5-3 and adjust belt tension as follows:

1. Remove and retain center plate/front cover and four screws.
2. Loosen, but do not remove, M10 lock nut with a 17 mm open end wrench.
3. Reset the tension on the drive belts as needed. Adjust the M8 tension screws in (clockwise) to **increase** tension or out (counterclockwise) to **decrease** tension. Tighten lock nut to secure tension setting.
4. Replace center plate/front cover and secure with original screws.

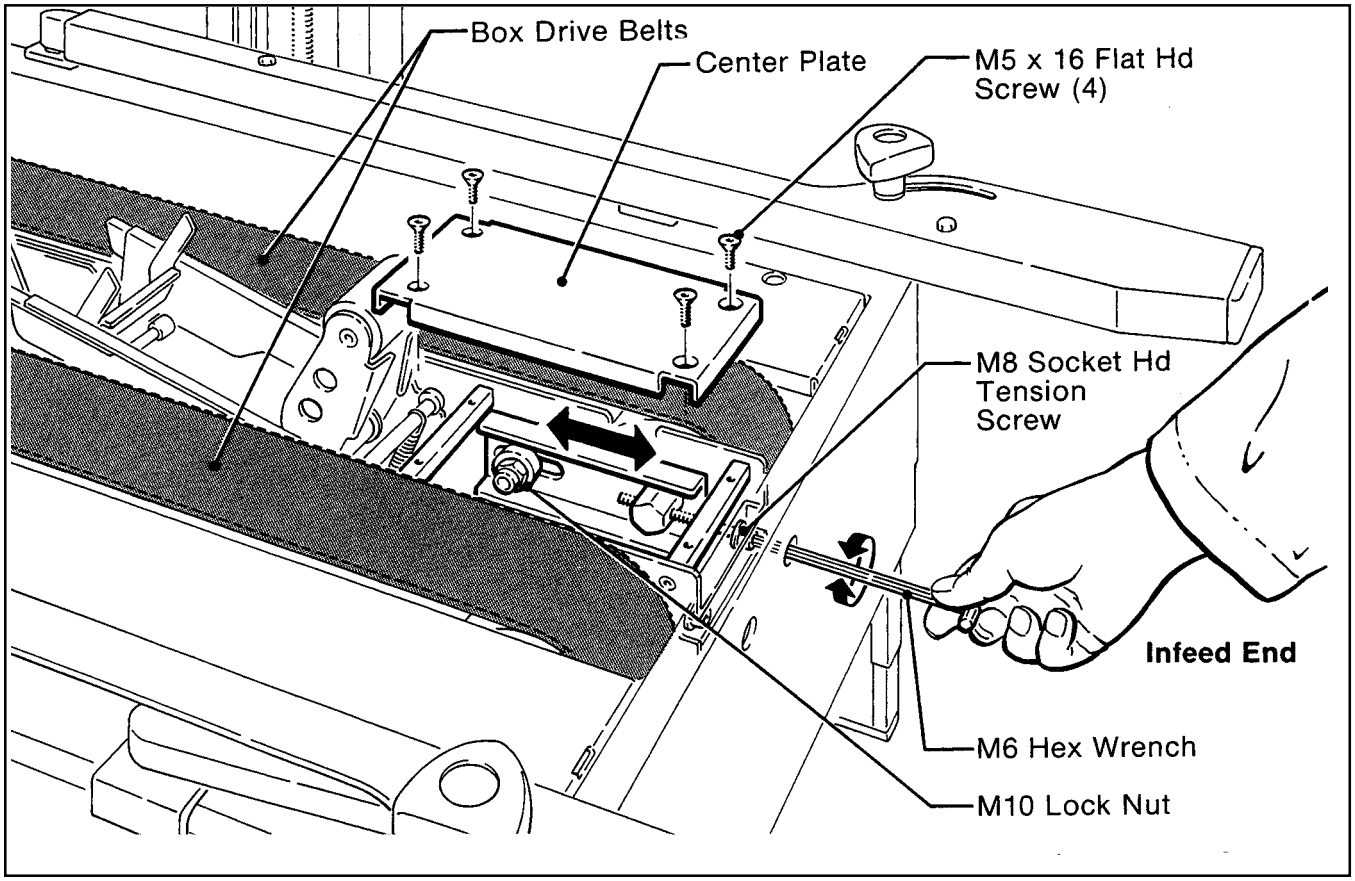


Figure 5-2 – Box Drive Belt Tension Adjustment, Lower Belts (Infeed End)

Adjustments (Continued)

WARNING – Turn off electrical power supply and disconnect power cord from electrical supply before beginning adjustments. If power cord is not disconnected, severe injury to personnel could result.

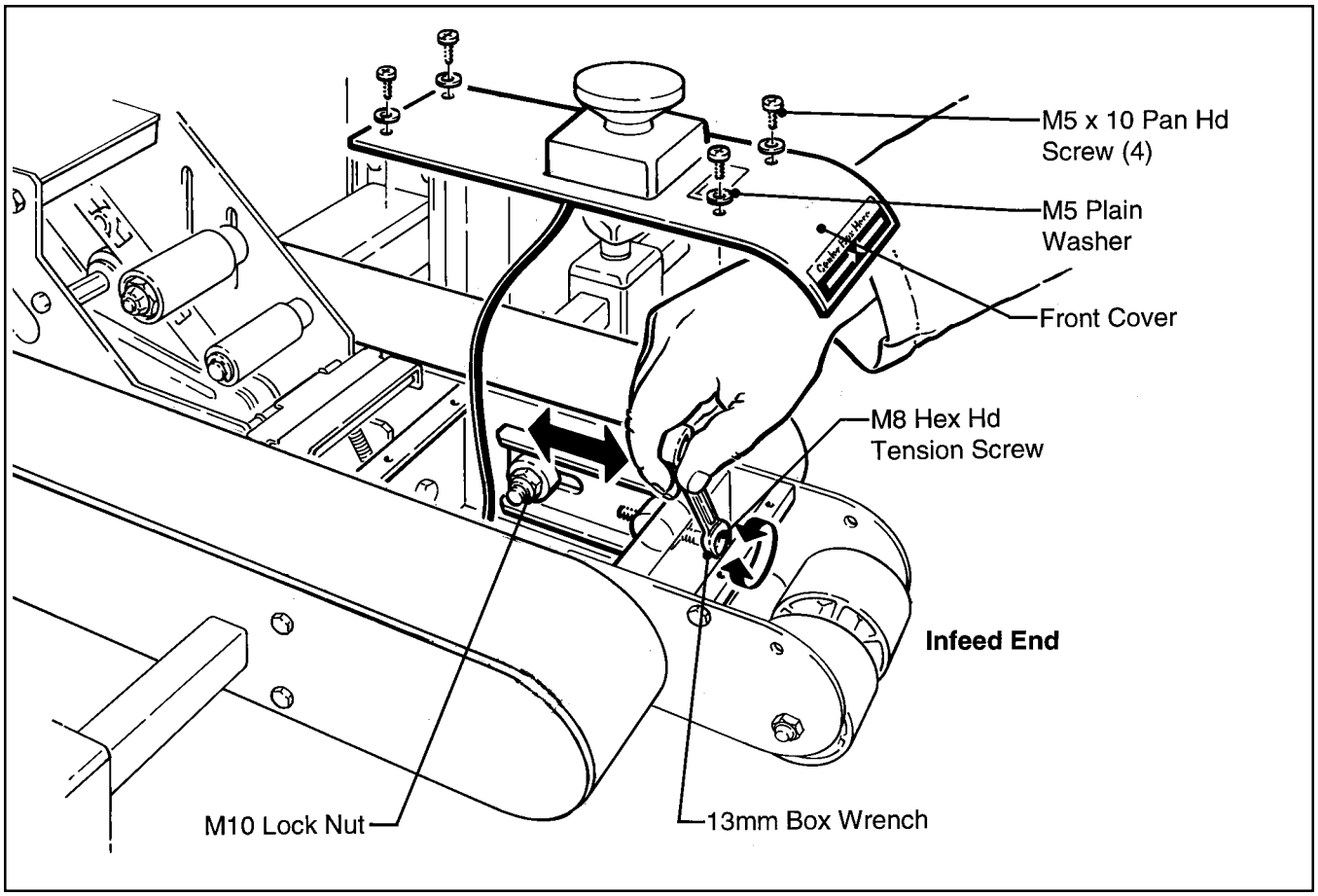


Figure 5-3 – Box Drive Belt Tension Adjustment, Upper Belts (Infeed End)

Taping Head Adjustments – Refer to Section II

WARNING – Use care when working near tape cut-off blades on taping heads as blades are extremely sharp. If care is not taken, severe injury to personnel could result.

TAPE WEB ALIGNMENT – Section II, Page 11

TAPE DRUM FRICTION BRAKE – Section II, Page 11

APPLYING MECHANISM SPRING – Section II, Page 12

ONE-WAY TENSION ROLLER – Section II, Page 12

TAPE LEG LENGTH ADJUSTMENT – Section II, Page 13

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Special Set-Up Procedure

WARNING – Turn off electrical power and disconnect power cord from electrical supply before beginning Special Set-Up Procedure. If power cord is not disconnected, severe injury to personnel could result.

Changing the Tape Leg Length
(From 70 to 50 mm [2-3/4 to 2 inch])

The following changes to the case sealer frame and upper/lower taping heads will allow the taping of boxes 90 mm [3.5 inch] minimum height.

CASE SEALER FRAME
(Refer to Figure 6-1A)

1. Raise the upper head assembly by turning crank handle counterclockwise. Remove and retain the two screws and washers that secure the stop bracket in position "A".
2. Remount and secure the stop bracket in the lower position "A-A" with original fasteners through top holes of stop bracket. Relocate both right and left stop brackets.

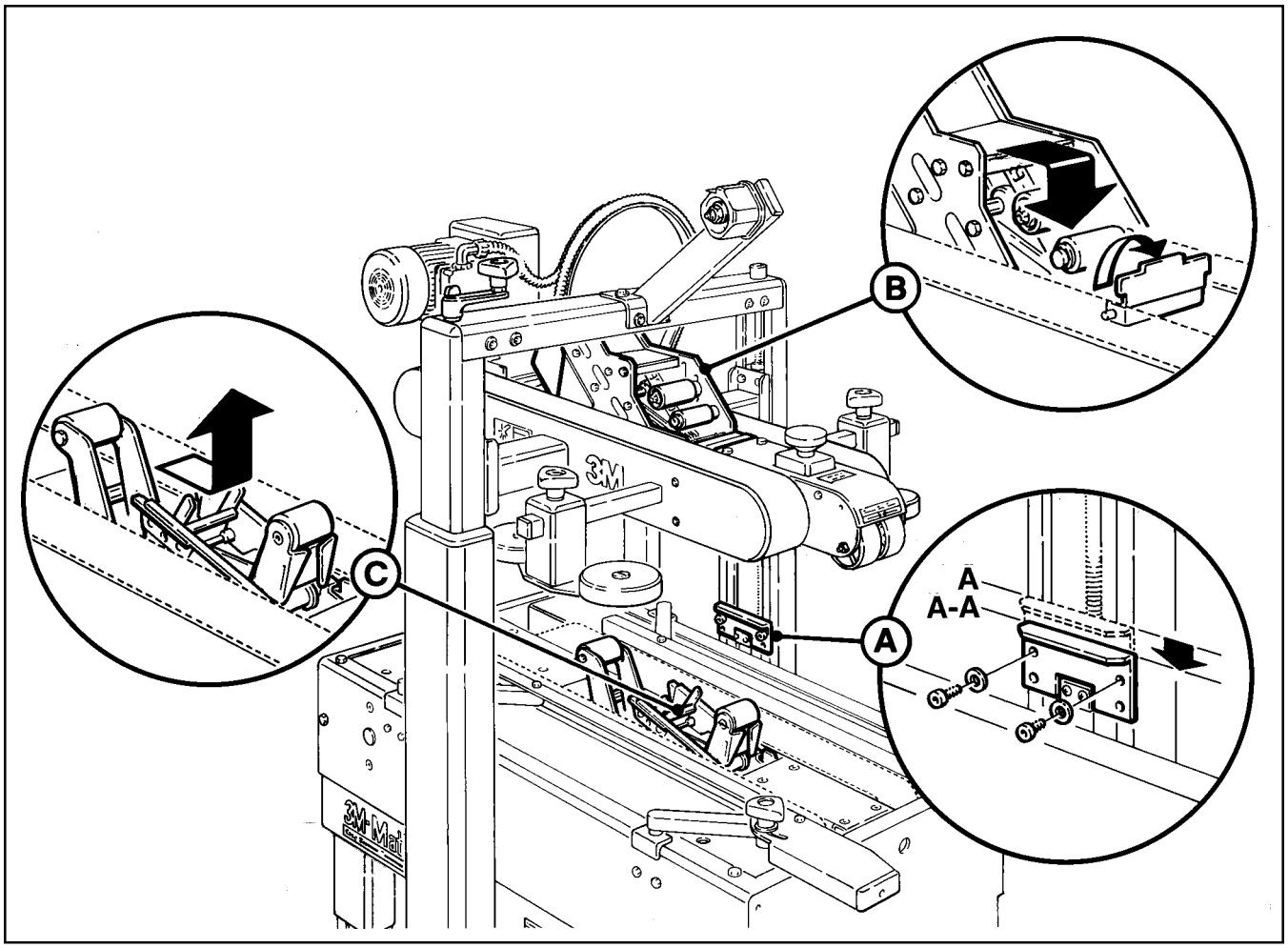

Figure 6-1 – Case Sealer Frame Changes

Special Set-Up Procedure (Continued)

WARNING – Turn off electrical power and disconnect power cord from electrical supply before beginning Special Set-Up Procedure. If power cord is not disconnected, severe injury to personnel could result.

TAPING HEADS

WARNING – Use care when working near blades as blades are extremely sharp. If care is not taken, severe injury to personnel could result.

1. Remove tape from upper taping head and raise upper assembly to a convenient working height.
2. Pivot up the clamp that secures the upper taping head as shown in Figure 6-1B.
3. Hold upper taping head applying and buffing arms from under upper assembly, slide head forward and down to remove. See Figure 6-2.

CAUTION

1. **Holding taping head in another way may increase the danger of being injured by the tape cut-off blade.**
2. **Taping head weighs approximately 7.2 kg [16 lbs]. Use proper body mechanics when lifting or holding taping head.**

4. Raise upper assembly to provide working room around lower taping head and remove tape from taping head.
5. Lift the lower taping head, shown in Figure 6-3 and 6-1C, straight up to remove it from the case sealer bed.
6. Refer to Section II, "Adjustments – Changing Tape Leg Length", page 13 for taping head set-up.
7. Replace taping heads reverse of disassembly.

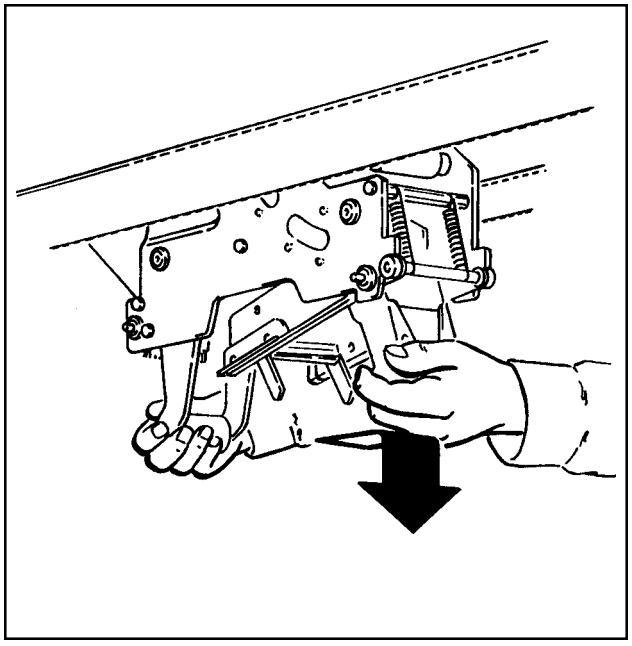

Figure 6-2 – Remove Upper Taping Head

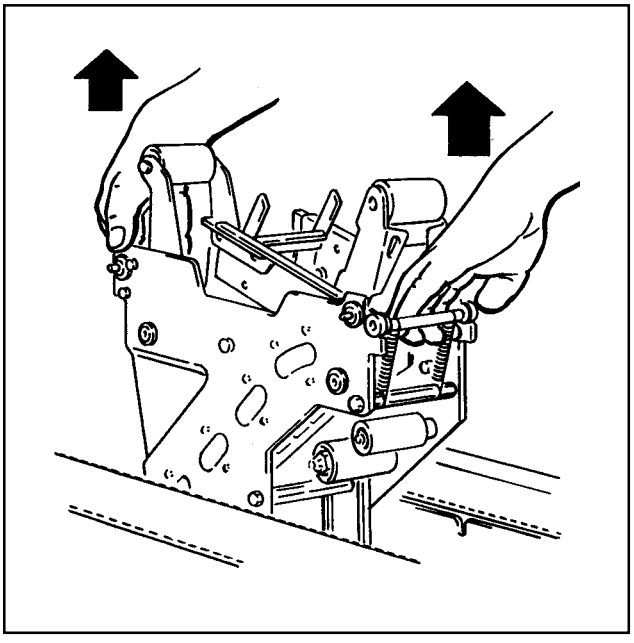

Figure 6-3 – Remove Lower Taping Head

Special Set-Up Procedure (Continued)

Box and Machine Bed Height Range – Refer to Figure 6-4

Moving the outer columns up one set of mounting holed increases the maximum box size handled by the 700a case sealer and decreases the minimum machine bed height.
Note – This also increases the minimum box height from 120 mm [4.8 inch] to 165 mm [6.5 inch].

To move the outer columns up one set of mounting holes:

1. Place minimum 305 mm [12 inch] high blocks at the front and rear of the upper taping head assembly as shown in Figure 6-4A. **Important – Blocks (front and rear) must be same height in order to keep upper taping head assembly parallel with machine bed/drive belts.** Crank the upper taping head assembly down until it touches these blocks.
2. Remove and retain the six screws and plain washers that fasten each column to the frame. Figure 6-4B.
3. Turn the height adjustment crank clockwise to raise the outer columns up one set of mounting holes (100 mm [4 inch]).

> **WARNING – Blocks and spacers must be capable of supporting the 45.4 Kg [100 pound] weight of the outer columns and upper taping head assembly.**

4. Install and tighten the six screws and plain washers in each column that were removed in Step 2. Crank upper taping head assembly up and remove blocks.

If desired, the bed height can now be decreased to 520 mm [20.5 inch] by adjusting legs upward. (See "Installation and Set-Up – Machine Bed Height", Page 11.)

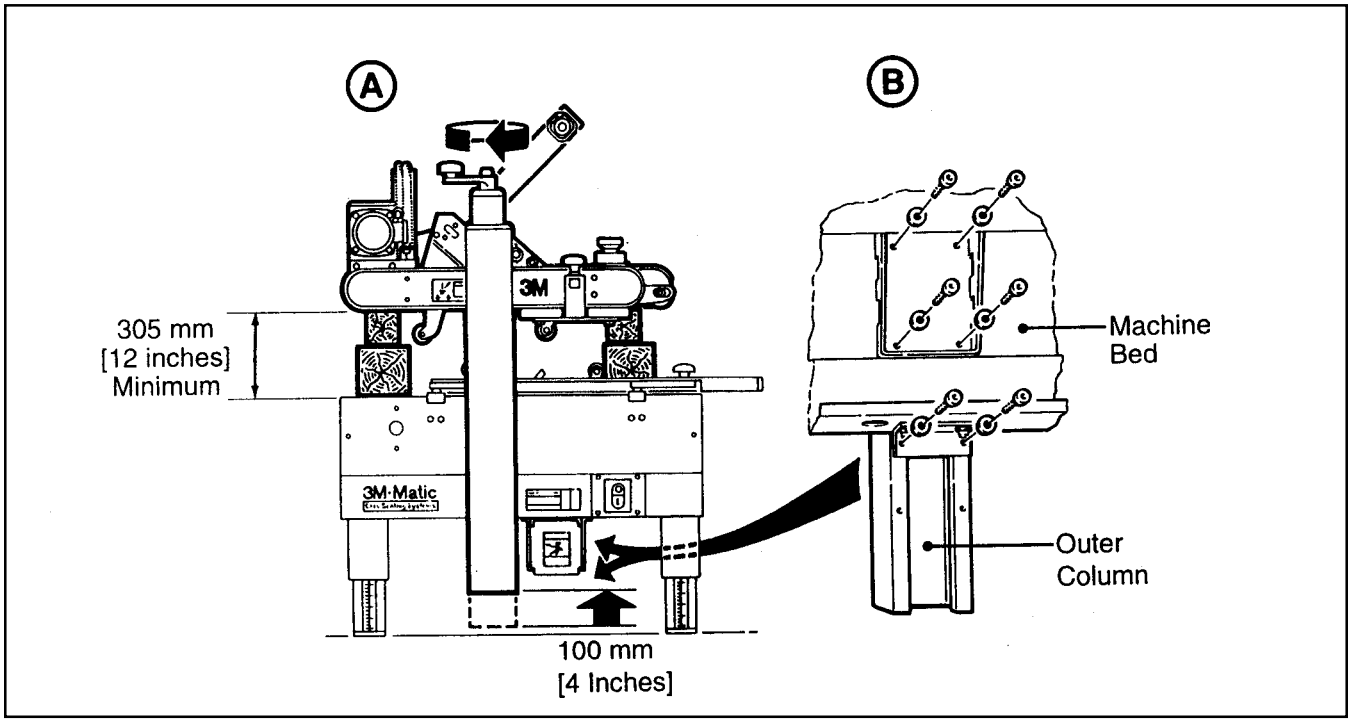

Figure 6-4 – Box and Machine Bed Height Range

Troubleshooting

The Troubleshooting Guide lists some possible machine problems, causes and corrections. Also see Section II "Troubleshooting", pages 15 and 16 for taping head problems.

Troubleshooting Guide

Problem	Cause	Correction
Drive belts do not convey boxes	Narrow boxes	Check machine specifications. Boxes are narrower than recommended, causing slippage and premature belt wear.
	Worn drive belts	Replace drive belts
	Top taping head does not apply enough pressure	Adjust the box height adjustment with the crank
	Top flap compression rollers in too tight	Readjust compression rollers
	Taping head applying spring holder missing	Replace spring holder
	Taping head applying spring set too high	Reduce spring pressure
Drive belts do not turn	Worn or missing friction rings	Replace friction rings
	Drive belt tension too low	Adjust belt tension
	Electrical disconnect	Check power and electrical plug
	Circuit breaker not at correct setting	Set to correct current value
	Motor not turning	Evaluate problem and correct
Upper and lower applying mechanisms interfere with each other	Machine's minimum height stop does not match tape head leg length setting	Check manual to make sure taping heads match machine setting
Drive belts break	Worn belt	Replace belt
Light boxes tip back on exit	Upper ski down too far	Carefully adjust upper ski
Squeaking noise as boxes pass through machine	Dry compression rollers	Lubricate compression rollers
	Dry column bearings	Lubricate column bearings
	Defective column bearings	Replace column bearings

Electrical Diagram

WARNING – Turn off electrical power and disconnect power cord from electrical supply before beginning service. If power cord is not disconnected, personnel could be exposed to dangerous voltages that could cause severe injury or equipment damage.

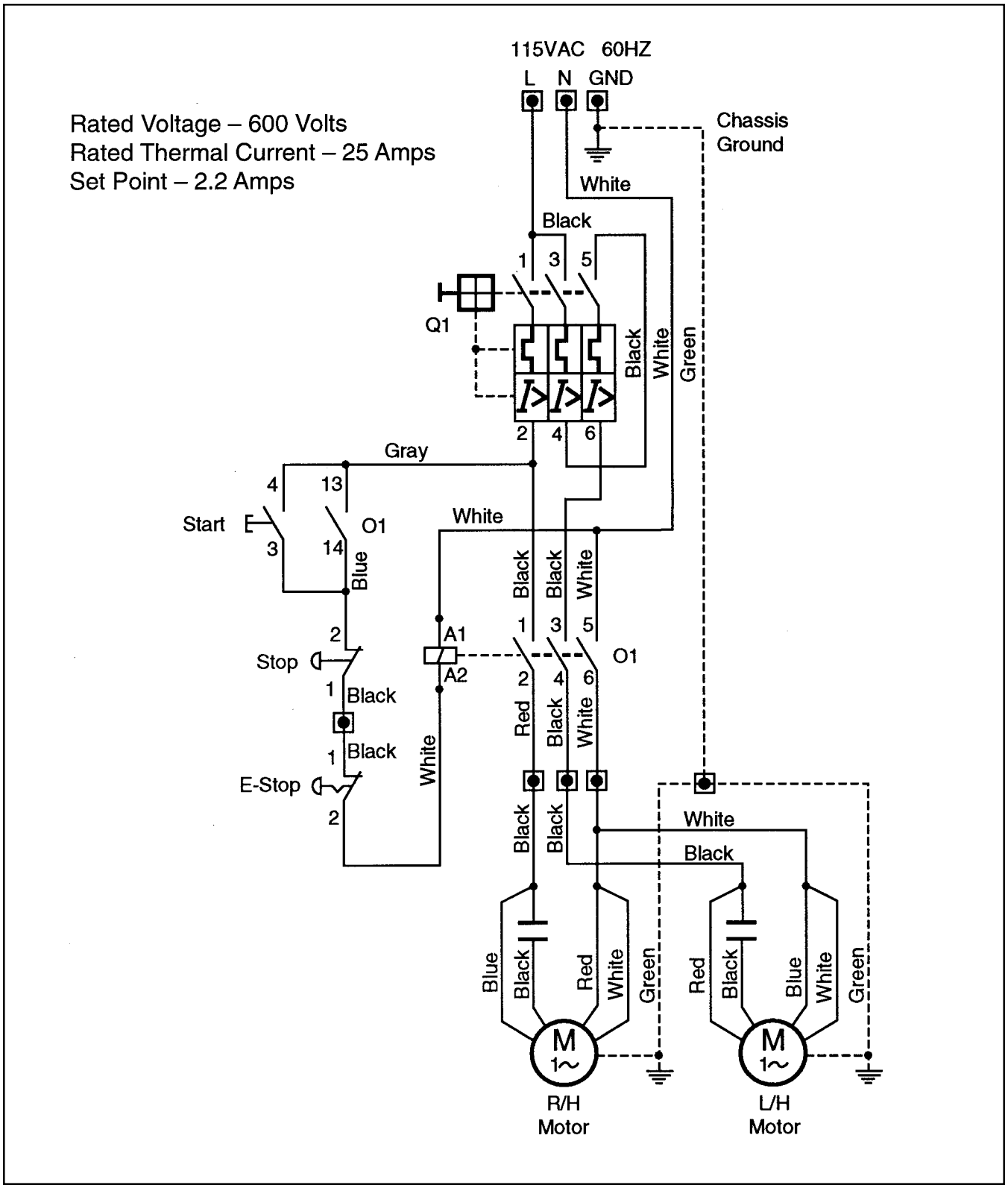

Figure 7-1 – Electrical Diagram

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Replacement Parts And Service Information

Spare Parts

It is suggested that the following spare parts be ordered and kept on hand:

Qty.	Ref. No.	Part Number	Description
4	5667-43 & 5668-59	78-8070-1531-4	Belt - Drive W/Pin

Also see Section II, page 17 for recommended taping head spare parts.

Label Kit

In the event that any labels are damaged or destroyed, **they must be replaced to ensure operator safety.** A label kit, part number 78-

Tool Kit

A tool kit, part number 78-8060-8476-6, is available as a stock item. The kit contains the necessary open end and hex socket wrenches for use with the metric fasteners on the case sealer. The threading tool, part number 78-8076-4726-4, contained in above kit is also available as a replacement stock item.

Replacement Parts Ordering Information and Service

Refer to the first page of this instruction manual "Replacement Parts and Service Information".

Options/Accessories

For additional information on the options/accessories listed below, contact your 3M Representative.

Part Number	Option/Accessory
78-8052-6553-1	Box Hold Down Attachment, Model 18500
78-8069-3983-7	Caster Kit Attachment
78-8069-3924-1	Conveyor Extension Attachment
78-8069-3926-6	Low Tape Sensor Kit
78-8114-0828-1	AccuGlide II STD 2 Inch Upper Taping Head, Type 39600
78-8114-0829-9	AccuGlide II STD 2 Inch Lower Taping Head, Type 39600
78-8079-5505-5	Three Flap Folder Kit
78-8079-5560-0	Tape Application Sensor
78-8095-4854-4	2-Inch Tape Edge Fold Attachment, Upper Head
78-8095-4855-1	2-Inch Tape Edge Fold Attachment, Lower Head

Replacement Parts – Illustrations and Parts Lists

700a Adjustable Case Sealer, Type 39600
Frame Assemblies

To Order Parts:

1. Refer to first illustration, **Frame Assemblies,** page 35 for the **Figure Number** that identifies a specific portion of the machine.

2. Refer to the appropriate **Figure or Figures** to determine the parts required and the parts reference number.

3. The Parts List that follows each illustration, includes the **Reference Number, Part Number** and **Part Description** for the parts on that illustration.

> **Note –** The complete description has been included for standard fasteners and some commercially available components. This has been done to allow obtaining these standard parts locally, if desired.

4. Order parts by **Part Number, Part Description** and **Quantity** required. Also include machine name, number and type.

5.. Refer to the first page of this instruction manual **"Replacement Parts and Service Information"** for replacement parts ordering information.

> **IMPORTANT –** Not all the parts listed are normally stocked items. Some parts or assemblies shown are available only on special order. Contact 3M/Tape Dispenser Parts to confirm item availability.

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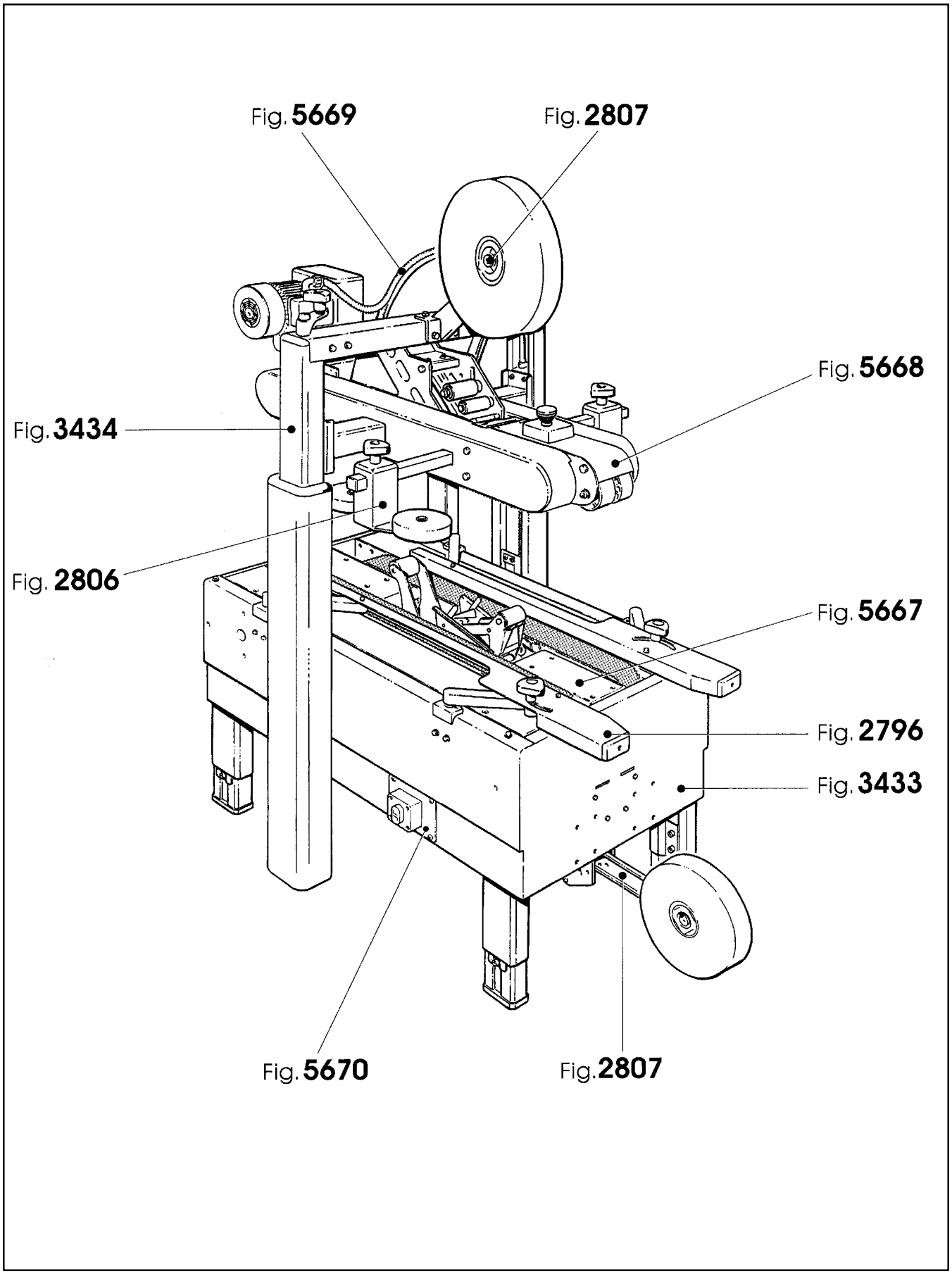
700a Adjustable Case Sealer



Frame Assemblies

700a Adjustable Case Sealer

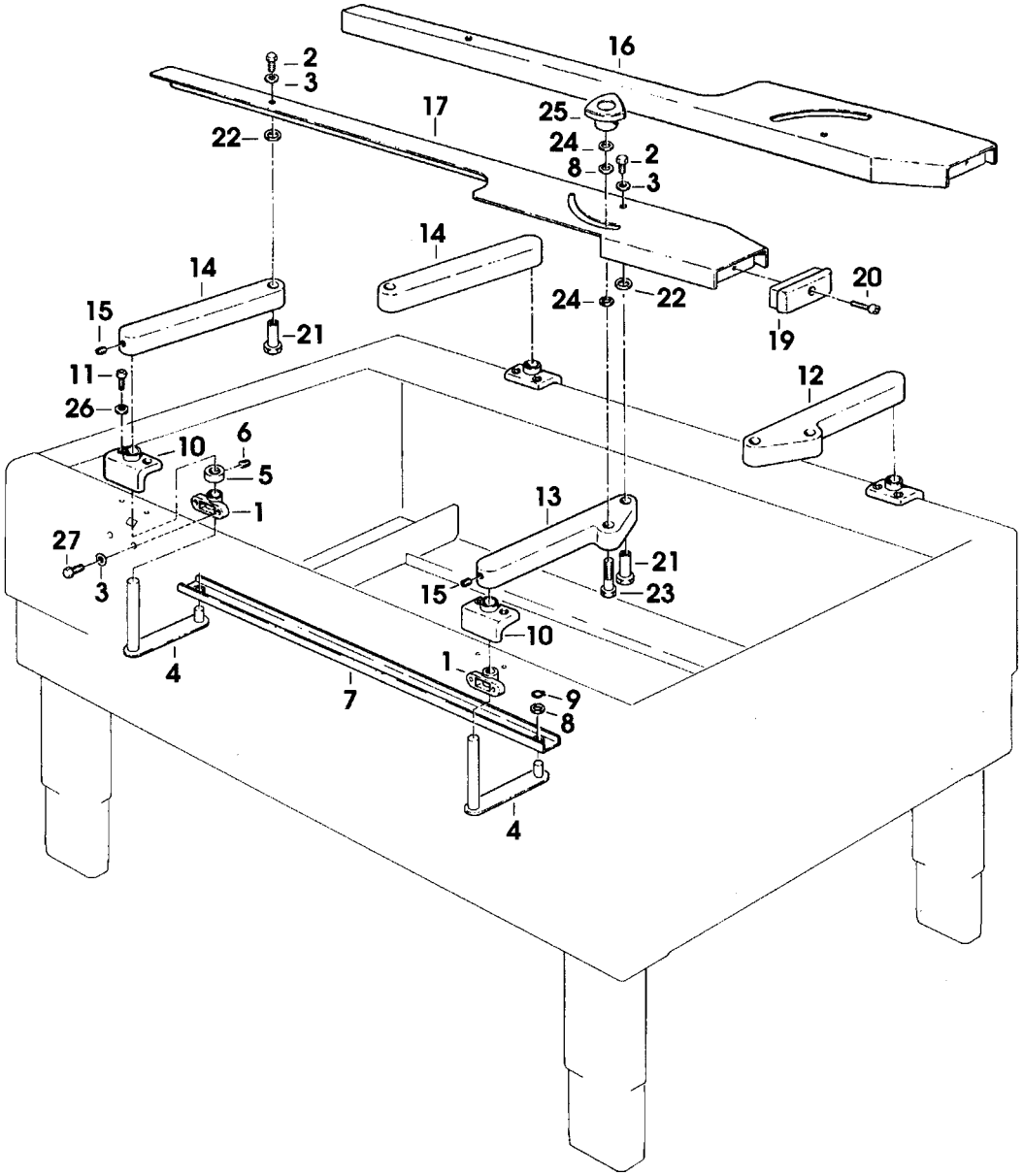


Figure 2796

Figure 2796

Ref. No.	3M Part No.	Description
2796-1	78-8070-1536-3	Support – Guide Arm
2796-2	78-8010-7169-3	Screw – Hex Hd, M6 x 12
2796-3	26-1000-0010-3	Washer – Flat, M6
2796-4	78-8070-1537-1	Lever With Pivot
2796-5	78-8070-1538-9	Bushing
2796-6	26-1003-8816-9	Screw – Set, M5 x 6
2796-7	78-8070-1539-7	Link – Guide
2796-8	78-8017-9074-8	Washer – 15 mm, Nylon
2796-9	78-8052-6733-9	Ring – M10, Special
2796-10	78-8070-1540-5	Support – Lever
2796-11	78-8032-0382-3	Screw – Soc Hd, M5 x 16
2796-12	78-8070-1541-3	Guide Arm – Front, Right
2796-13	78-8070-1542-1	Guide Arm – Front, Left
2796-14	78-8070-1543-9	Guide Arm – Rear
2796-15	78-8076-4505-2	Screw – Set, M6 x 8
2796-16	78-8070-1544-7	Guide – Right
2796-17	78-8113-6792-5	Guide – Left, W/English Language Label
2796-19	78-8070-1546-2	Cap – Guide
2796-20	26-1003-7953-1	Screw – Soc Hd, M5 x 30
2796-21	78-8070-1547-0	Shaft - Guide
2796-22	78-8070-1548-8	Washer – 20 x 12, 5 x 1 Nylon
2796-23	26-1003-5852-7	Screw – Hex Hd, M10 x 40
2796-24	26-1004-5510-9	Washer – Plain, M10
2796-25	78-8070-1549-6	Knob – VTR-B-M10
2796-26	78-8005-5735-3	Washer – Lock, M5
2796-27	78-8032-0375-7	Screw – Hex Hd, M6 x 16

700a Adjustable Case Sealer

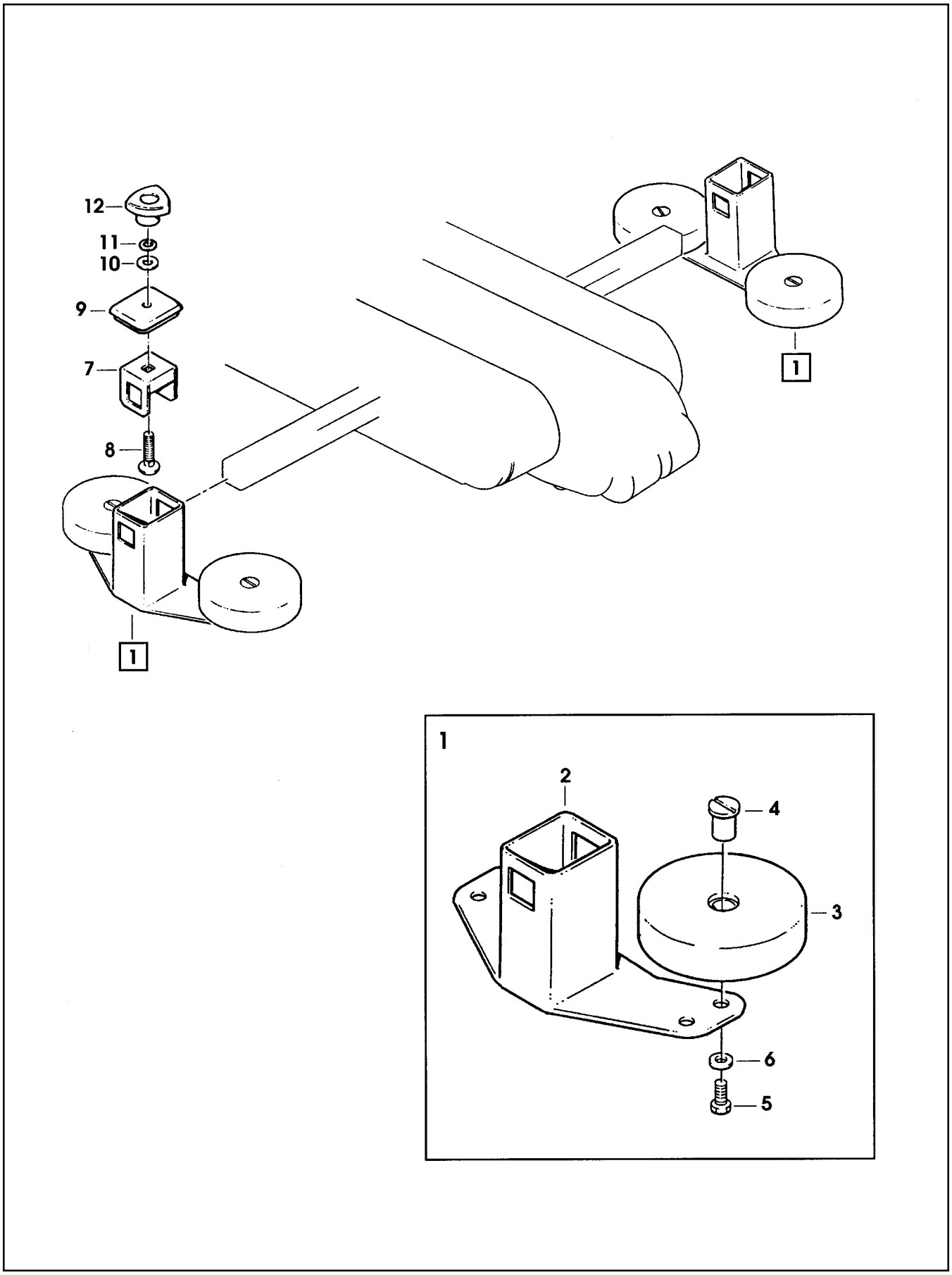


Figure 2806

Figure 2806

Ref. No.	3M Part No.	Description
2806-1	78-8076-4626-6	Compression Roller Assembly
2806-2	78-8076-4627-4	Support – Compression Roller
2806-3	78-8076-4628-2	Roller – Compression
2806-4	78-8076-4629-0	Shaft – Roller
2806-5	26-1003-5841-0	Screw – M8 x 16
2806-6	78-8017-9318-9	Washer – Plain 8 mm
2806-7	78-8076-4630-8	Plate – Tube, Roller
2806-8	78-8076-4631-6	Screw – M10 x 35
2806-9	78-8076-4632-4	Cap – Support
2806-10	78-8017-9074-8	Washer – Nylon 15 mm
2806-11	26-1004-5510-9	Washer – Plain, M10
2806-12	78-8070-1549-6	Knob – VTR-B-M10

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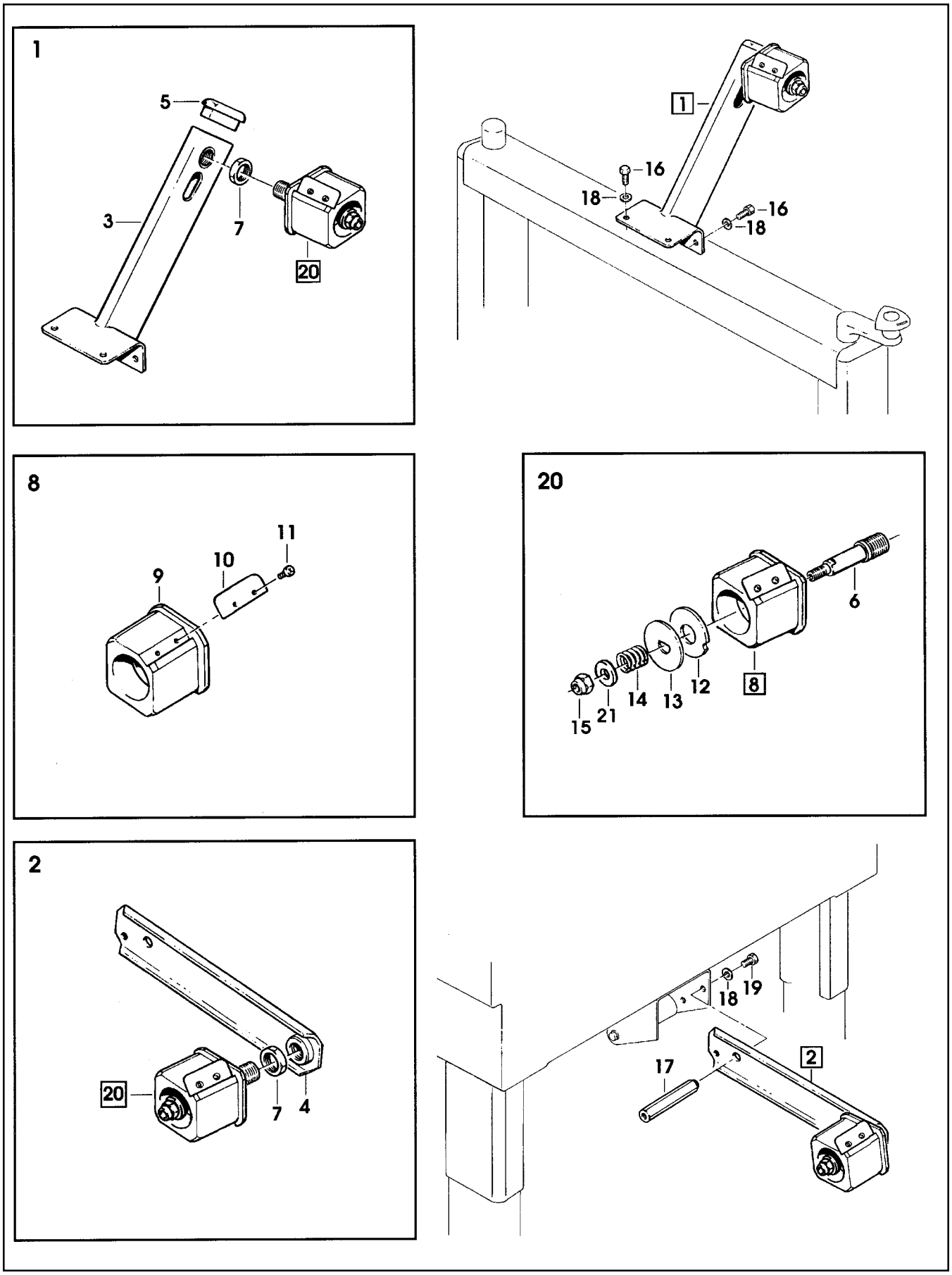

Figure 2807

Figure 2807

Ref. No.	3M Part No.	Description
2807-1	78-8076-4633-2	Tape Roll Bracket Assembly
2807-2	78-8070-1565-2	Tape Drum Bracket Assembly
2807-3	78-8070-1566-0	Bracket – Tape Drum
2807-4	78-8070-1395-4	Bracket – Bushing Assembly
2807-5	78-8070-1568-6	Cap – Bracket
2807-6	78-8076-4519-3	Shaft – Tape Drum
2807-7	78-8017-9169-6	Nut – M18 x 1
2807-8	78-8070-1569-4	Tape Drum Assembly – 2 Inch Wide
2807-9	78-8052-6749-5	Tape Drum
2807-10	78-8052-6268-6	Leaf Spring
2807-11	26-1002-5753-9	Screw – Self Tapping
2807-12	78-8060-8172-1	Washer – Friction
2807-13	78-8052-6271-0	Washer – Tape Drum
2807-14	78-8100-1048-4	Spring – Core Holder
2807-15	78-8017-9077-1	Nut – Self-Locking, M10 x 1
2807-16	78-8032-0375-7	Screw – Hex Hd M6 x 16
2807-17	78-8070-1215-4	Spacer – Stud
2807-18	26-1000-0010-3	Washer – Flat M6
2807-19	78-8010-7169-3	Screw – Hex Hd M6 x12
2807-20	78-8060-8474-1	Tape Drum Assembly – 2 Inch Head
2807-21	26-1004-5510-9	Washer – Plain, M10

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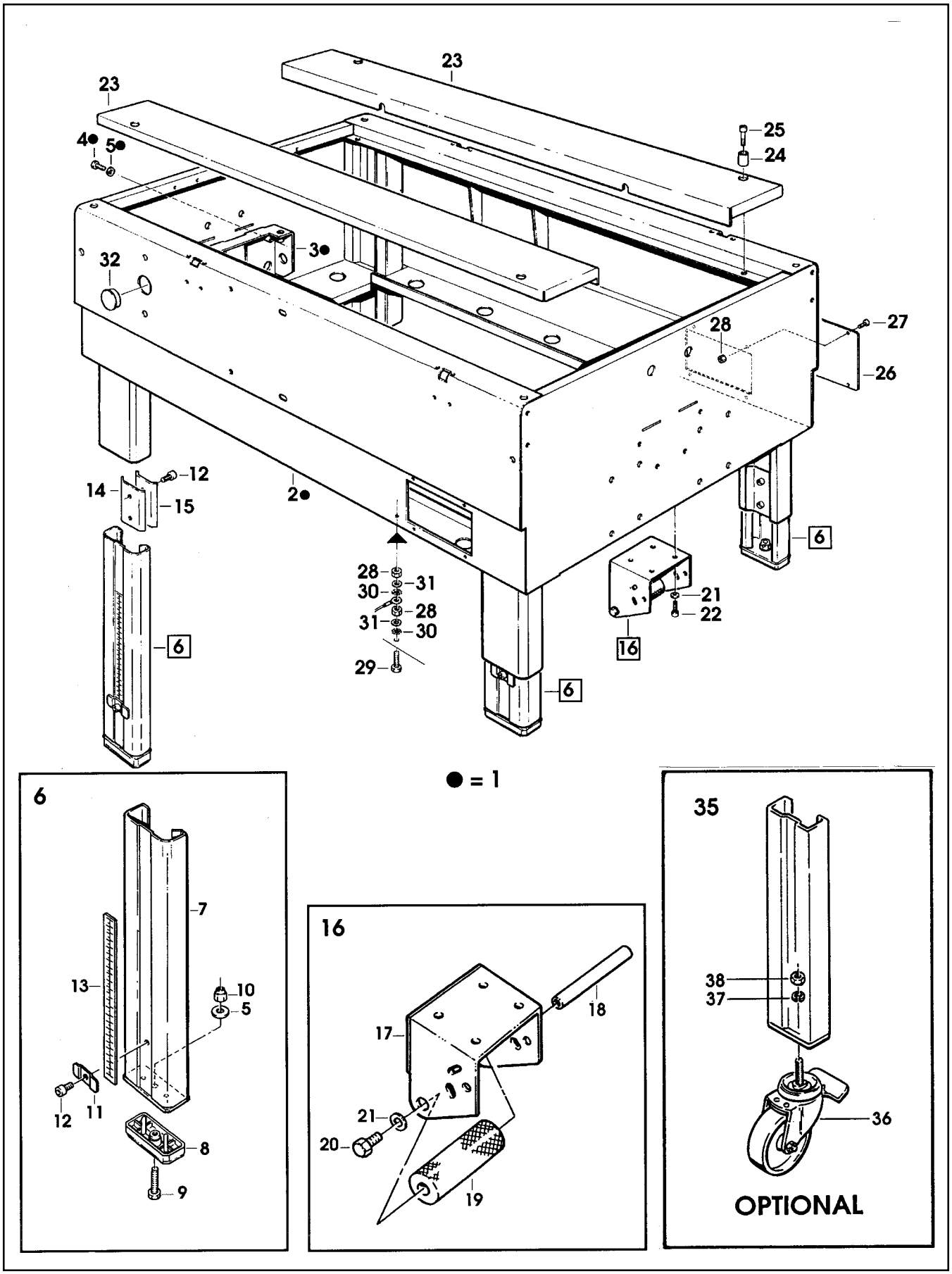

Figure 3433

Figure 3433

Ref. No.	3M Part No.	Description
3433-1	78-8091-0309-2	Conveyor Bed Assembly
3433-2	78-8091-0310-0	Bed – Conveyor
3433-3	78-8091-0307-6	Support – Drive
3433-4	26-1003-5842-8	Screw – Hex Hd M8 x 20
3433-5	78-8017-9318-9	Washer – Plain 8 mm
3433-6	78-8076-5381-7	Leg Assembly – Inner W/Stop
3433-7	78-8076-5382-5	Leg – Inner
3433-8	78-8060-8480-8	Pad – Foot
3433-9	78-8055-0867-4	Screw – Hex Hd M8 x 30
3433-10	78-8017-9313-0	Nut – Self Locking M8
3433-11	78-8076-5383-3	Stop – Leg
3433-12	26-1003-7963-0	Screw – Soc Hd M8 x 16
3433-13	78-8060-8481-6	Label – Height
3433-14	78-8052-6677-8	Clamp – Inner
3433-15	78-8052-6676-0	Clamp – Outer
3433-16	78-8076-5392-4	Support – Tape Drum
3433-17	78-8060-8483-2	Support – Outboard Roll
3433-18	78-8060-8484-0	Shaft – Roller
3433-19	78-8060-8485-7	Roller
3433-20	78-8032-0375-7	Screw – Hex Hd M6 x 16
3433-21	26-1000-0010-3	Washer – Flat M6
3433-22	26-1003-7957-2	Screw – Soc Hd M6 x 16
3433-23	78-8076-4620-9	Plane – Conveyor Bed
3433-24	78-8060-8486-5	Bushing
3433-25	78-8010-7211-3	Screw – Soc Hd M6 x 25
3433-26	78-8060-8487-3	Cover – Switch
3433-27	78-8060-8087-1	Screw – M5 x 10
3433-28	78-8010-7417-6	Nut – Hex M5
3433-29	78-8060-8488-1	Screw – Hex Hd M5 x 20
3433-30	78-8046-8217-3	Washer – Special
3433-31	78-8005-5741-1	Washer – Flat M5
3433-32	78-8076-4701-7	Cap – /28
3433-35	78-8098-9076-3	Caster Assembly
3433-36	26-1009-9096-4	Caster – Dual Locking
3433-37	26-1009-9094-9	Washer – Spring, Helical, M12
3433-38	26-1009-9095-6	Nut – M12

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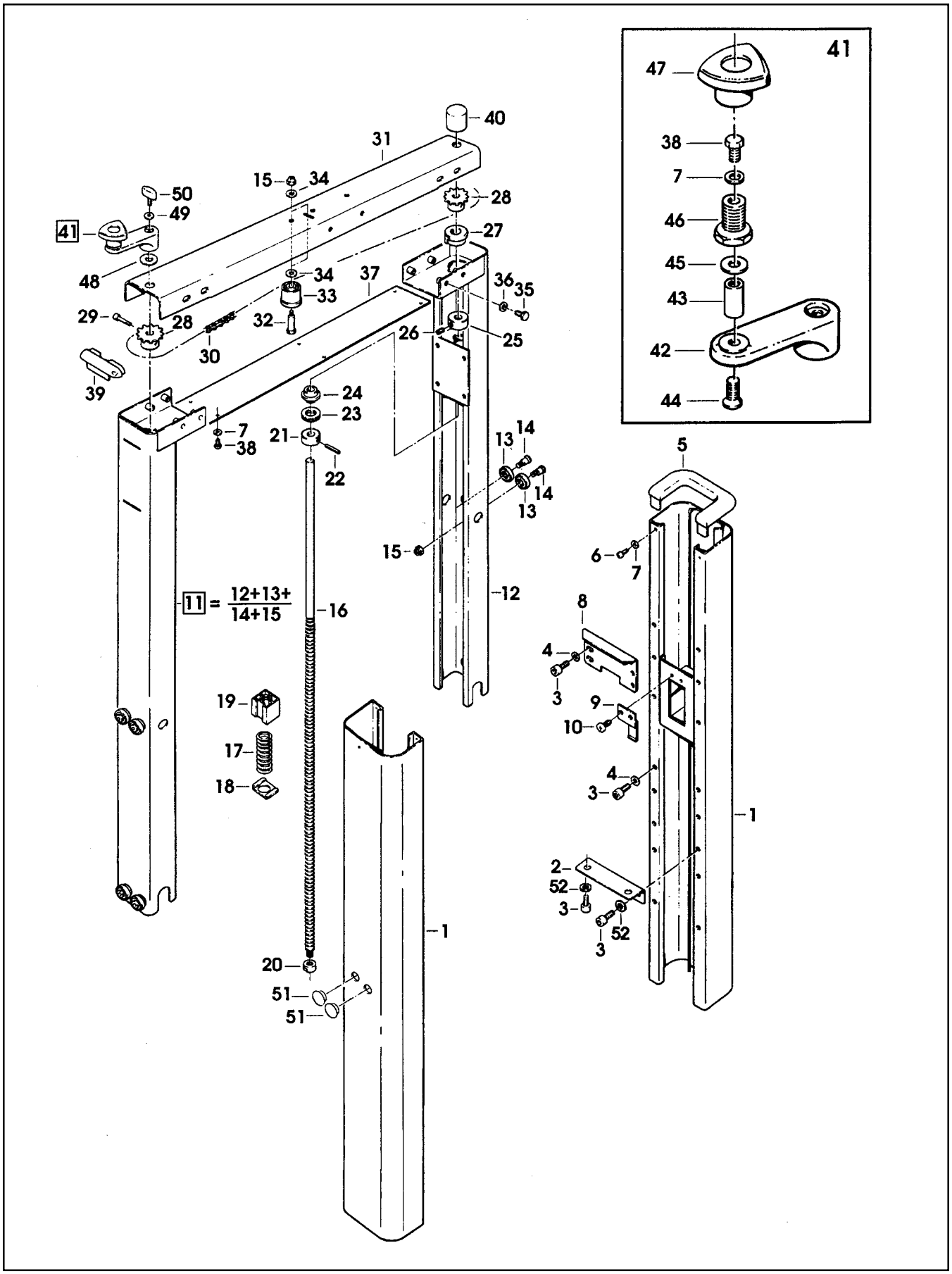

Figure 3434

Figure 3434

Ref. No.	3M Part No.	Description
3434-1	78-8060-8489-9	Column – Outer
3434-2	78-8060-8490-7	Plate – Column Mounting
3434-3	26-1003-7964-8	Screw – Soc Hd Hex Soc Dr, M8 x 20
3434-4	78-8017-9318-9	Washer – Plain 8 mm
3434-5	78-8060-8491-5	Cap – Column
3434-6	26-1002-4955-1	Screw – Self Tap 8P x 13
3434-7	78-8005-5740-3	Washer – Plain 4 mm
3434-8	78-8060-8492-3	Stop – Height
3434-9	78-8076-5482-3	Plate – Nut Stop
3434-10	78-8060-8087-1	Screw – M5 x 10
3434-11	78-8060-8494-9	Column Assembly – Inner
3434-12	78-8060-8495-6	Column – Inner
3434-13	78-8054-8617-8	Bearing – Special
3434-14	78-8054-8589-9	Screw – Special
3434-15	26-1003-6916-9	Nut – Locking, Plastic Insert M6
3434-16	78-8060-8496-4	Lead Screw
3434-17	78-8054-8997-4	Spring
3434-18	78-8054-8970-1	Bed Plate – Spring
3434-19	78-8054-8571-7	Nut – Plastic
3434-20	78-8054-8968-5	Nut – Special
3434-21	78-8054-8585-7	Collar
3434-22	78-8054-8586-5	Pin
3434-23	78-8054-8584-0	Spacer
3434-24	78-8054-8583-2	Bushing
3434-25	78-8060-8497-2	Bushing – Lead Screw
3434-26	78-8059-5617-0	Set Screw – M6 x 8
3434-27	78-8060-8498-0	Bushing – Inner Column
3434-28	78-8060-8499-8	Sprocket – 3/8" Z = 13
3434-29	26-1003-7946-5	Screw – Soc Hd M4 x 25
3434-30	78-8070-1501-7	Chain – 3/8" P = 156
3434-31	78-8113-6755-2	Housing – Chain, W/English Language Label
3434-32	78-8060-7878-4	Idler Screw
3434-33	78-8070-1503-3	Roller – Chain Tensioning
3434-34	78-8042-2919-9	Washer – Triple M6
3434-35	26-1003-5829-5	Screw – Hex Hd M6 x 12
3434-36	26-1000-0010-3	Washer – Flat M6
3434-37	78-8070-1504-1	Cover
3434-38	78-8010-7157-8	Screw – Hex Hd M4 x 10
3434-39	78-8070-1505-8	Cap – Inner Column
3434-40	78-8070-1506-6	Cover – Screw
3434-41	78-8076-4807-2	Crank Assembly
3434-42	78-8076-5422-9	Crank
3434-43	78-8070-1509-0	Shaft – Crank
3434-44	26-1005-5316-8	Screw – Flat Hd Hex Dr M5 x 16
3434-45	78-8070-1510-8	Washer – Nylon
3434-46	78-8070-1511-6	Bushing
3434-47	78-8070-1512-4	Knob – VTR-B-M12
3434-48	78-8076-4800-7	Washer – Crank
3434-49	78-8076-4809-8	Washer – Crank
3434-50	78-8076-4821-3	Key – Stop
3434-51	78-8054-8821-6	End Cap
3434-52	26-1004-5507-5	Washer – M8

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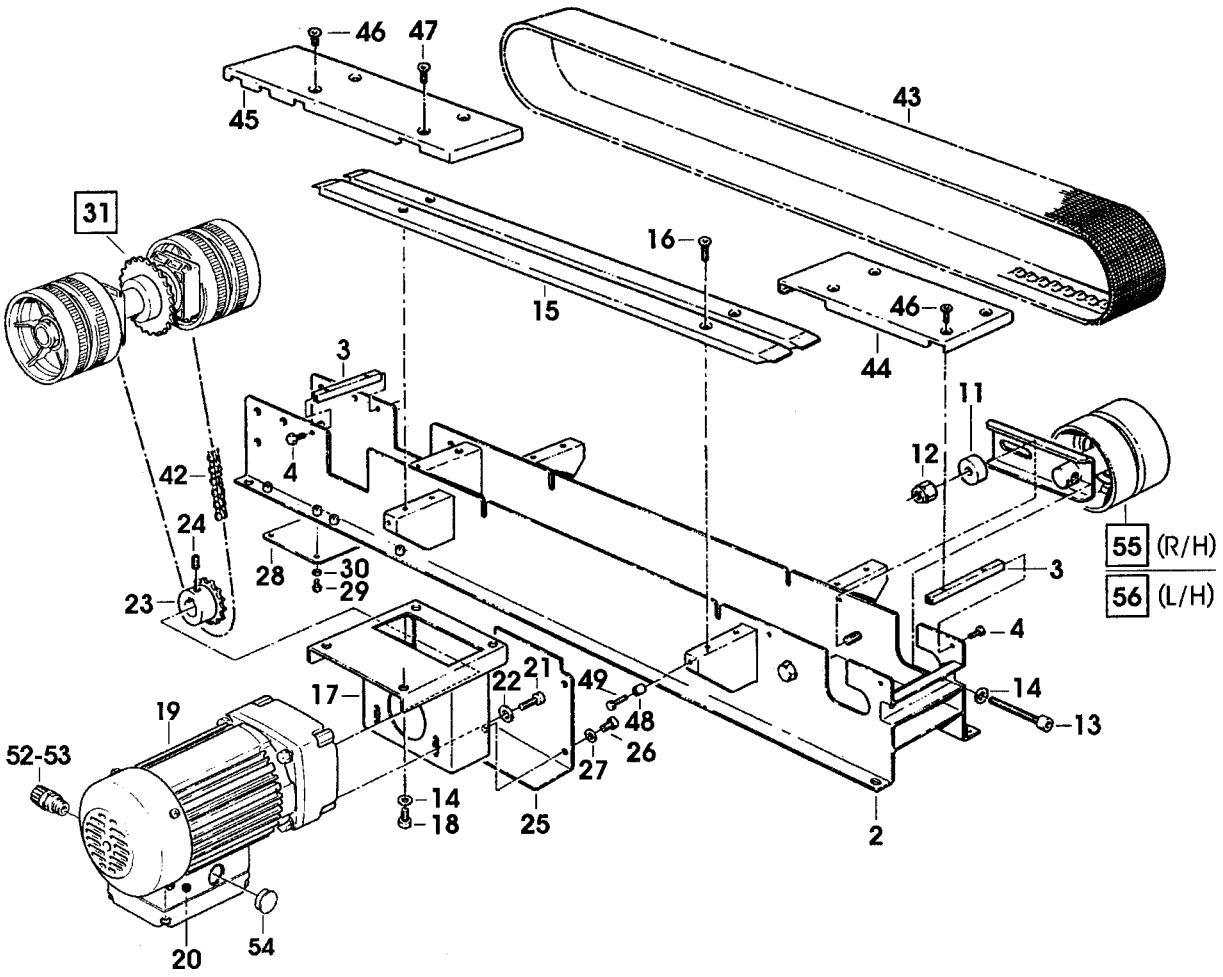

Figure 5667/1 of 2

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Ref. No.	3M Part No.	Description
5667-1	78-8100-1128-4	Drive Assembly – BTM, W /O Motor
5667-2	78-8070-1580-1	Frame – Drive
5667-3	78-8070-1514-0	Spacer
5667-4	26-1003-5829-5	Screw – Hex Hd, M6 x 12
5667-7	78-8052-6710-7	Roller – Idler
5667-8	78-8052-6709-9	Washer – Special
5667-9	78-8010-7435-8	Washer – Lock M6
5667-10	26-1003-7957-2	Screw – Soc Hd M6 x 16
5667-11	78-8070-1518-1	Spacer – Shaft
5667-12	26-1003-6918-5	Nut – Hex Plastic Insert M10
5667-13	78-8070-1519-9	Screw – Soc Hd, Hex Hd, M8 x 70
5667-14	78-8017-9318-9	Washer – Plain, 8 mm
5667-15	78-8070-1520-7	Guide – Drive Belt
5667-16	26-1005-4757-4	Screw – Flat Hd, Soc Dr, M x 20
5667-17	78-8070-1521-5	Support – Gearbox
5667-18	26-1003-7964-8	Screw – Soc Hd, Hex Soc Dr, M8 x 20
5667-19	78-8070-1522-3	Gearmotor – 115V, 60HZ
5667-20	78-8076-4515-1	Capacitor – 115V Gearmotor
5667-21	78-8070-1523-1	Screw – 1/4-28 x 1/2 SHCS
5667-22	78-8042-2919-9	Washer – Triple
5667-23	78-8070-1524-9	Sprocket – 3/8 ", Z=17
5667-24	78-8023-2479-4	Screw – Set W/End Cup,M6 x 10
5667-25	78-8070-1526-4	Cover – Chain
5667-26	78-8010-7209-7	Screw – Soc Hd, M6 x 12
5667-27	26-1000-0010-3	Washer – Flat M6

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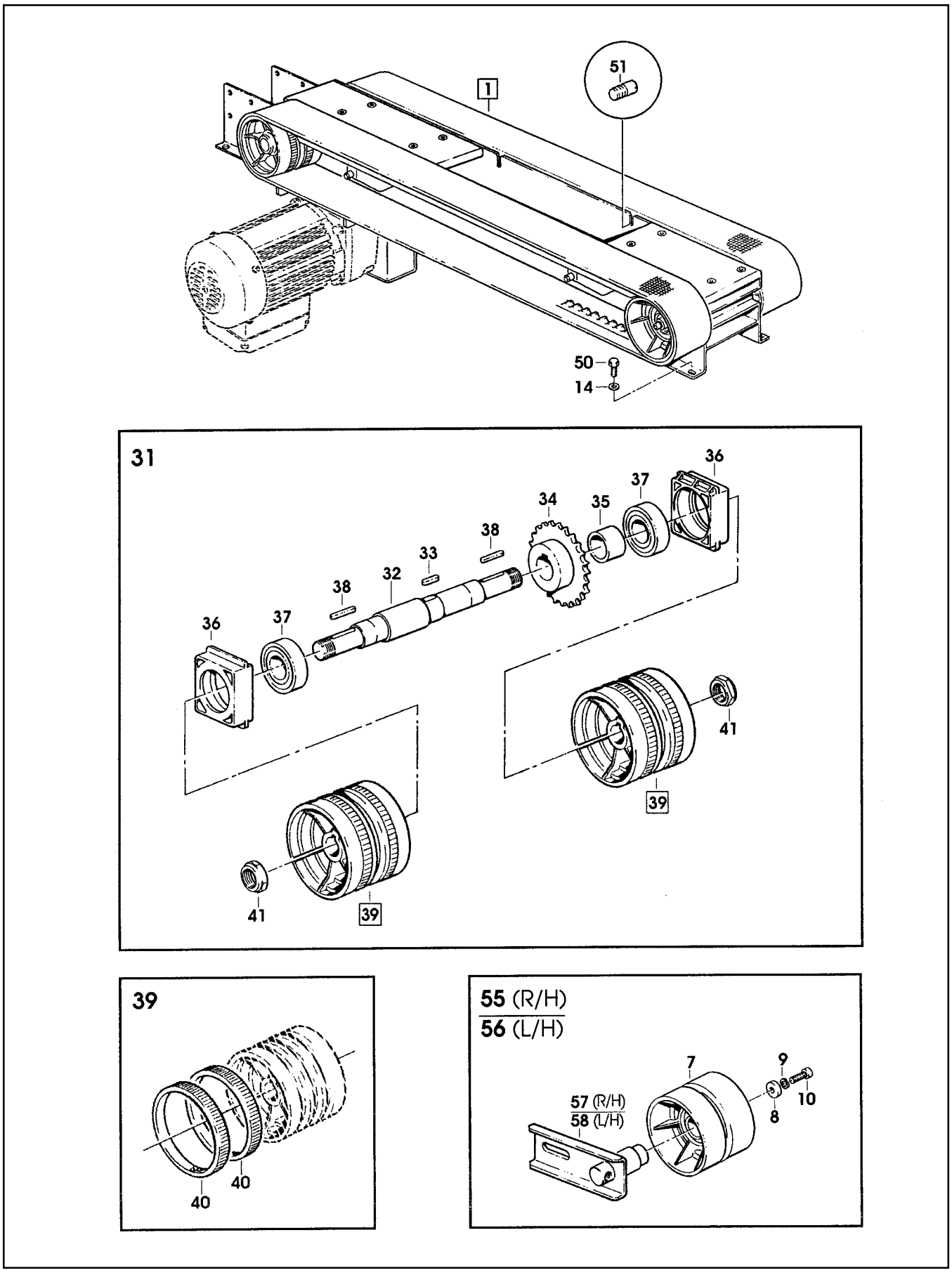

Figure 5667/2 of 2

Figure 5667 (Page 2 of 2)

Ref. No.	3M Part No.	Description
5667-28	78-8076-4562-3	Cover – Bottom
5667-29	26-1003-5820-4	Screw – Hex Hd, M5 x 12
5667-30	78-8005-5741-1	Washer – Flat, M5
5667-31	78-8070-1527-2	Shaft – With Drive Pulleys
5667-32	78-8070-1528-0	Shaft – Gearbox
5667-33	78-8057-5811-3	Key – 6 x 6 x 20 mm
5667-34	78-8054-8986-7	Sprocket – 3/8" Pitch 28 Teeth
5667-35	78-8054-8984-2	Bushing
5667-36	78-8070-1529-8	Support – Shaft
5667-37	78-8070-1530-6	Bearing – 6205-2RS
5667-38	78-8057-5739-6	Key – M5 x 5 x 30 mm
5667-39	78-8076-5105-0	Pulley Assembly – Drive
5667-40	78-8052-6713-1	Ring – Polyurethane
5667-41	78-8060-8416-2	Nut – Special M20 x 1
5667-42	78-8070-1525-6	Chain – 3/8" P=54
5667-43	78-8070-1531-4	Belt – Drive With Hook
5667-44	78-8070-1584-3	Cover – Drive, Front
5667-45	78-8113-6794-1	Cover – Drive, Rear, W/English Language Label
5667-46	26-0001-5862-1	Screw – Flat Hd Soc, M5 x 12
5667-47	26-1005-5316-8	Screw – Flat Hd, Hex Dr, M5 x 16
5667-48	78-8070-1534-8	Stud – Side Plate
5667-49	78-8060-8488-1	Screw – Hex Hd, M5 x 20
5667-50	26-1003-5841-0	Screw – M8 x 16
5667-51	78-8076-4500-3	Stud – Mounting
5667-52	78-8076-4715-7	Cord Grip
5667-53	78-8076-5211-6	Set Nut – GMP 113.5
5667-54	78-8060-7885-9	End Cap – /25 x 1,2
5667-55	78-8100-1236-5	Belt Tensioning Assembly – R/H
5667-56	78-8100-1237-3	Belt Tensioning Assembly – L/H
5667-57	78-8100-1238-1	Belt Tensioning – R/H
5667-58	78-8100-1239-9	Belt Tensioning – L/H

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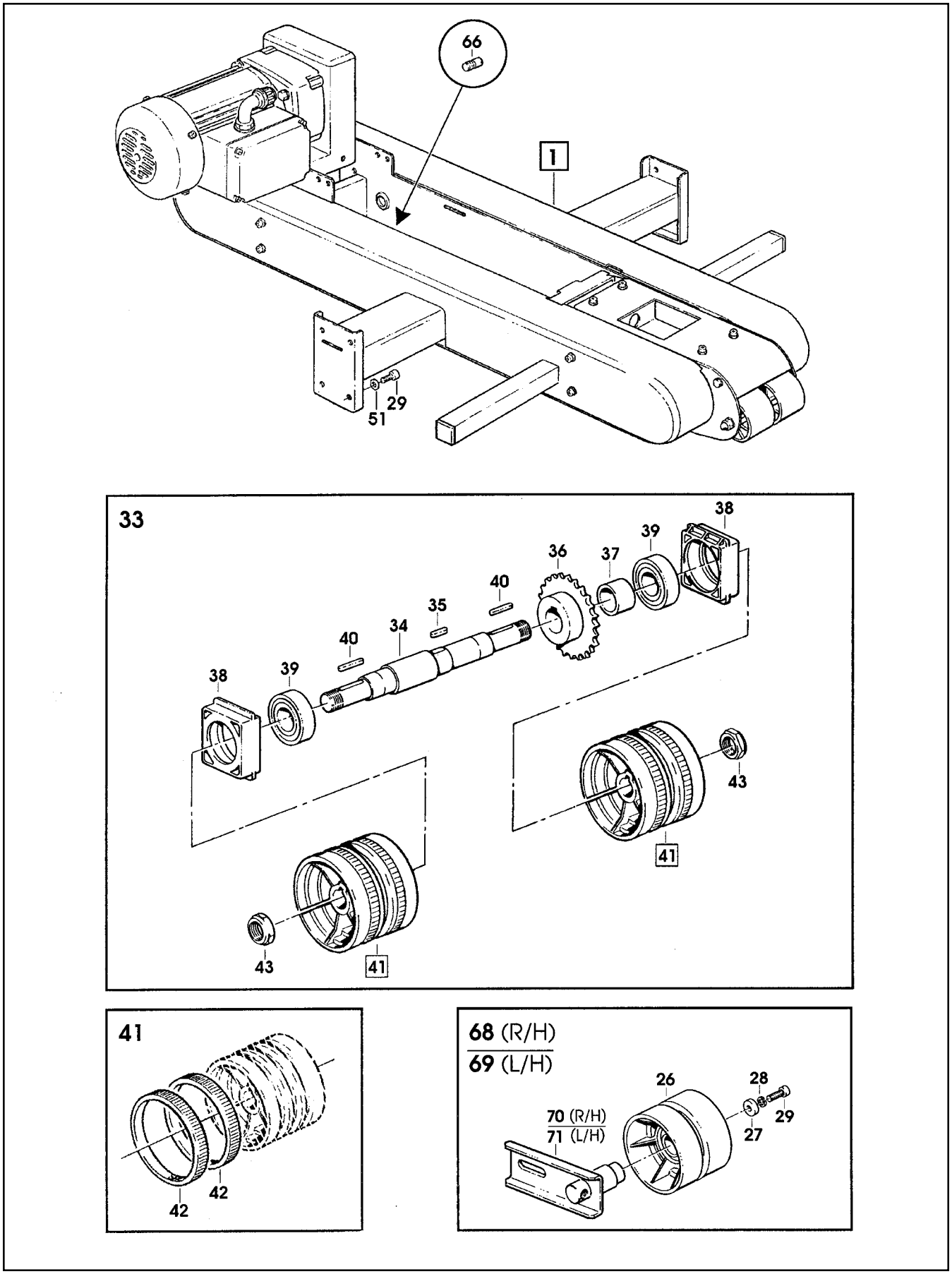

Figure 5668/1 of 2

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Ref. No.	3M Part No.	Description
5668-1	78-8100-1129-2	Upper Drive Assembly – W /O Motor
5668-2	78-8070-1588-4	Frame – Drive, Upper
5668-3	78-8070-1520-7	Guide – Drive Belt
5668-4	26-1005-4757-4	Screw – Flat Hd M5 x 20
5668-5	78-8070-1589-2	Clamp – Upper Head
5668-6	78-8070-1590-0	Shaft – Roller
5668-7	26-1003-7948-1	Screw – Soc Hd M5 x 10
5668-8	78-8070-1514-0	Spacer
5668-9	78-8010-7169-3	Screw – Hex Hd M6 x 12
5668-10	26-1000-0010-3	Washer – Flat M6
5668-11	78-8100-1130-0	Tube – Roller
5668-12	78-8052-6641-4	Roller
5668-13	78-8070-1592-6	Spacer – Roller
5668-14	78-8100-1131-8	Shaft – Roller
5668-15	78-8100-1132-6	Nut – Special, M8
5668-16	78-8017-9318-9	Washer – Plain 8 mm
5668-17	78-8060-7693-7	Roller – 32 x 38
5668-18	78-8070-1593-4	Spacer – Roller
5668-19	26-1003-5820-4	Screw – Hex Hd, M5 x 12
5668-20	78-8005-5741-1	Washer – Flat, M5
5668-21	78-8070-1599-1	Tube – Compression Roller
5668-22	78-8052-6652-1	Cap – End
5668-23	26-1003-5841-0	Screw – M8 x 16
5668-26	78-8052-6710-7	Roller – Idler
5668-27	78-8052-6709-9	Washer – Special
5668-28	78-8010-7435-8	Washer – Lock M6
5668-29	26-1003-7957-2	Screw – Soc Hd M6 x 16
5668-30	78-8070-1518-1	Spacer – Shaft
5668-31	26-1003-6918-5	Nut – Hex Plastic Insert M10
5668-32	78-8070-1594-2	Screw – Hex Hd M8 x 60
5668-33	78-8070-1527-2	Shaft – With Drive Pulleys
5668-34	78-8070-1528-0	Shaft – Gearbox

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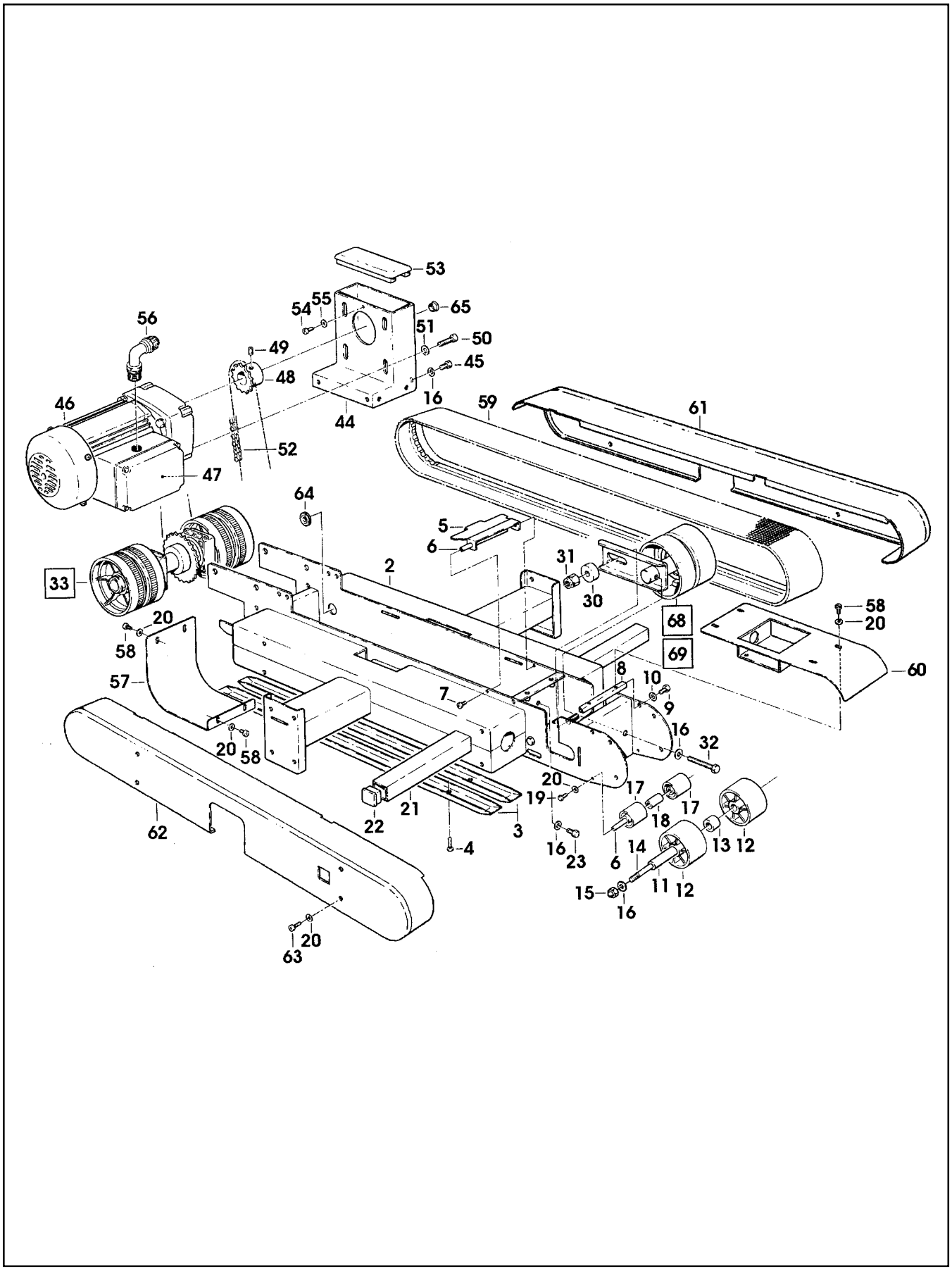

Figure 5668/2 of 2

Figure 5668 (Page 2 of 2)

Ref. No.	3M Part No.	Description
5668-35	78-8057-5811-3	Key – 6 x 6 x 20 mm
5668-36	78-8054-8986-7	Sprocket – 3/8" Pitch 28 Teeth
5668-37	78-8054-8984-2	Bushing
5668-38	78-8070-1529-8	Support – Shaft
5668-39	78-8070-1530-6	Bearing – 6205-2RS
5668-40	78-8057-5739-6	Key – M5 x 5 x 30 mm
5668-41	78-8076-5105-0	Pulley Assembly – Drive
5668-42	78-8052-6713-1	Ring – Polyurethane
5668-43	78-8060-8416-2	Nut – Special, M20 x 1
5668-44	78-8070-1595-9	Support – Drive
5668-45	26-1003-5842-8	Screw – Hex Hd, M8 x 20
5668-46	78-8070-1522-3	Gearmotor – 115V, 60HZ
5668-47	26-1011-8828-7	Capacitor – 115V Gearmotor
5668-48	78-8070-1524-9	Sprocket – 3/8" Z=17
5668-49	78-8023-2479-4	Set Screw – W/End Cup M6 x 10
5668-50	78-8070-1523-1	Screw – 1/4-28 x 1/2 SHCS
5668-51	78-8042-2919-9	Washer – Triple, M6
5668-52	78-8070-1597-5	Chain – 3/8" P=62
5668-53	78-8070-1598-3	Cover
5668-54	26-1002-4955-1	Screw – Self Tap 8P x 13
5668-55	78-8005-5740-3	Washer – Plain 4 mm
5668-56	78-8070-1596-7	Union – Elbow, PG 13,5
5668-57	78-8076-4622-5	Cover – Rear Upper
5668-58	78-8060-8087-1	Screw – M5 x 10
5668-59	78-8070-1531-4	Belt – Drive, With Hook
5668-60	78-8113-6791-7	Cover – Upper, Front, W/English Language Label
5668-61	78-8113-6790-9	Guard – Belt, R/H, W/English Language Label
5668-62	78-8113-6789-1	Guard – Belt, L/H, W/English Language Label
5668-63	78-8076-4625-8	Screw – Special, M5 x 16
5668-64	78-8076-4702-5	Grommet – /28
5668-65	78-8054-8821-6	End – Cap
5668-66	78-8076-4500-3	Stud – Mounting
5668-67	78-8100-1042-7	Washer – /15 x 6.35 x 2
5668-68	78-8100-1236-5	Belt Tensioning Assembly – R/H
5668-69	78-8100-1237-3	Belt Tensioning Assembly – L/H
5668-70	78-8100-1238-1	Belt Tensioning – R/H
5668-71	78-8100-1239-9	Belt Tensioning – L/H

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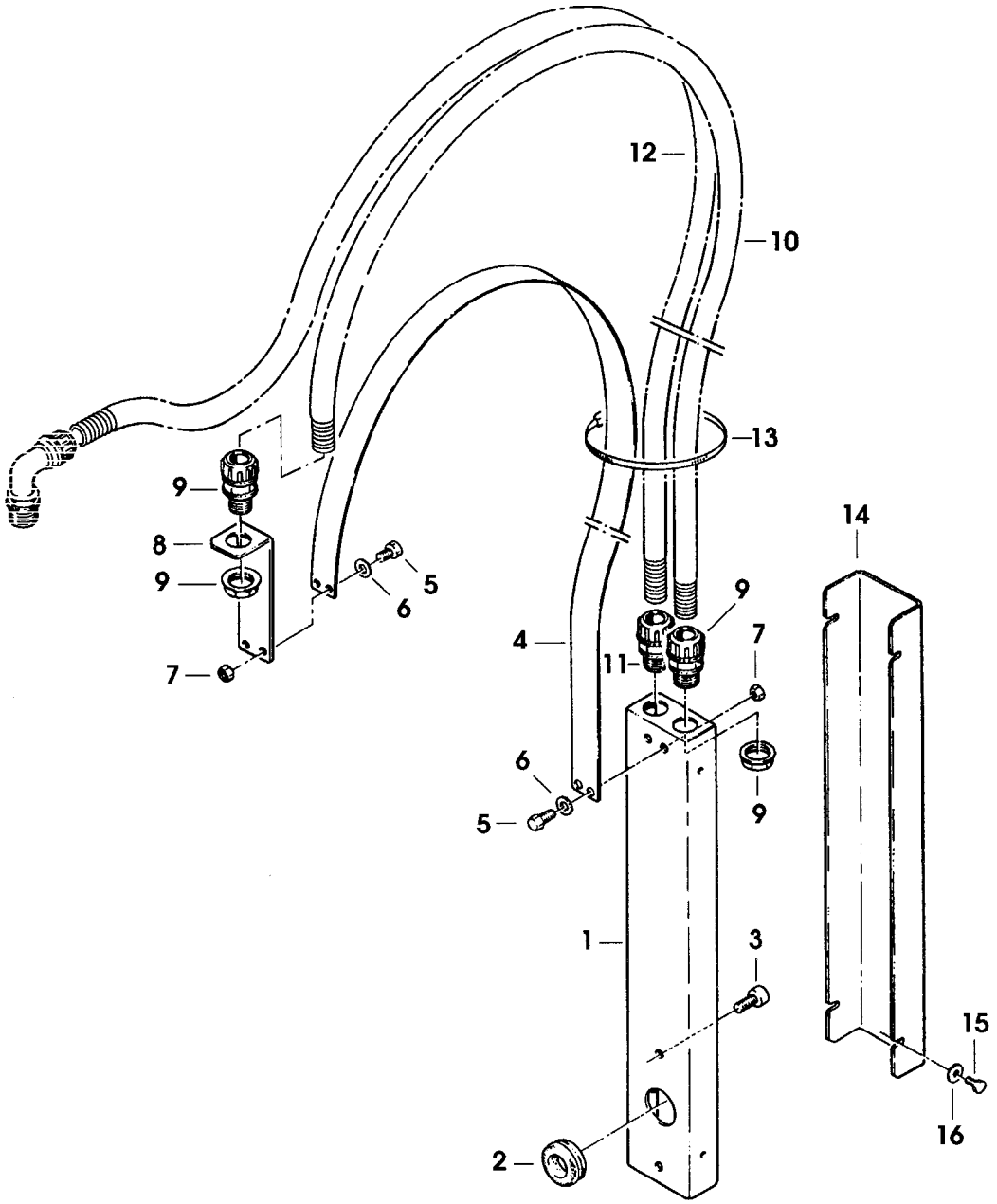

Figure 5669

Figure 5669

Ref. No.	3M Part No.	Description
5669-1	78-8091-0660-8	Housing – Wire
5669-2	78-8076-4702-5	Grommet – /28
5669-3	26-1003-7963-0	Screw – Soc Hd M8 x 16
5669-4	78-8076-4636-5	Strap – Wire
5669-5	78-8010-7163-6	Screw – Hex Hd M5 x 10
5669-6	78-8005-5741-1	Washer – Plain M5
5669-7	78-8010-7417-6	Nut – Hex M5
5669-8	78-8100-1135-9	Bracket – Strap
5669-9	78-8076-4520-1	Union PG13 – Sleeve /16
5669-10	78-8076-4521-9	Sleeving – Wire, 900 mm /16
5669-11	78-8076-4638-1	Union PG 13.5 – Sleeve /14
5669-12	78-8076-4640-7	Sleeving – Wire, 11 mm /14
5669-13	78-8060-8029-3	Clamp – 140 x 3,5
5669-13	78-8076-4641-5	Cover
5669-14	78-8010-7157-8	Screw – Hex Hd M4 x 10
5669-15	78-8017-9018-5	Washer – Plain M4

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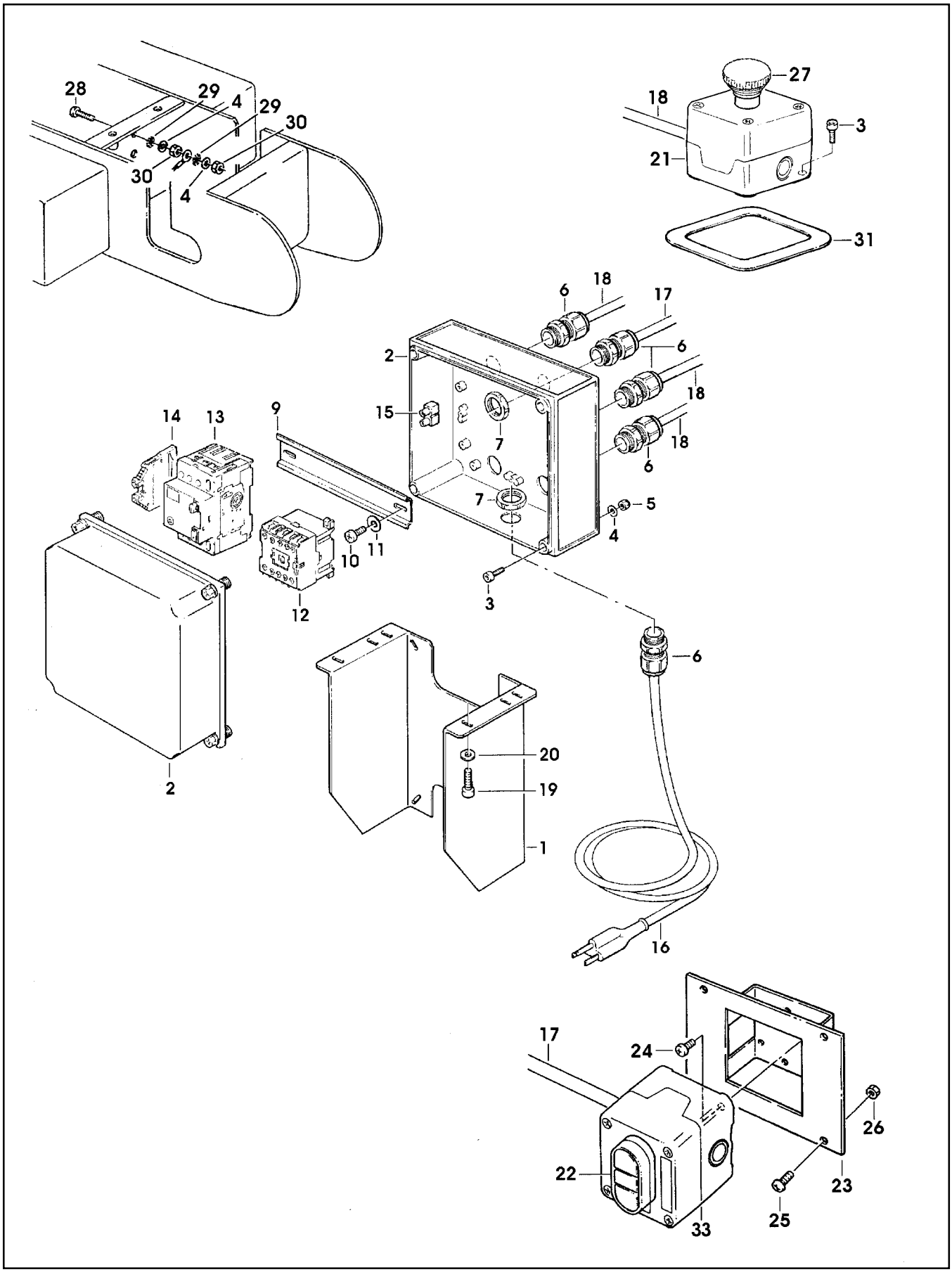
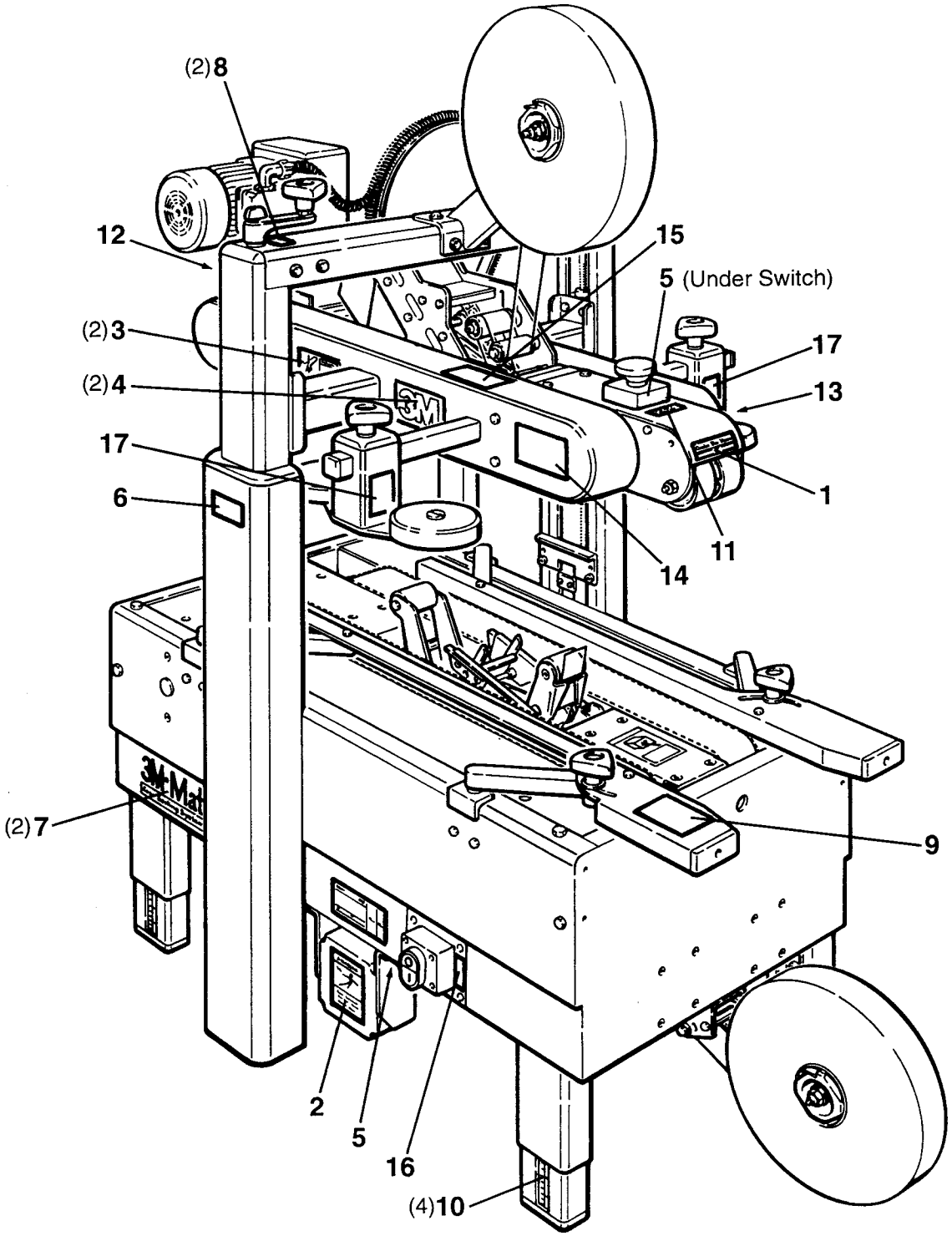


Figure 5670

Figure 5670

Ref. No.	3M Part No.	Description
5670-1	78-8094-6379-3	Support – Box
5670-2	78-8113-6759-4	Box – W/English Language Label
5670-3	78-8094-6381-9	Screw – Soc Hd, Hex Hd, M4 x 15
5670-4	78-8005-5740-3	Washer – Plain, 4 mm
5670-5	26-1003-6914-4	Nut – Plastic Insert, M4
5670-6	78-8076-4715-7	Cord Grip
5670-7	78-8076-5211-6	Set Nut – GMP 13.5
5670-9	78-8094-6382-7	Guide – Mounting
5670-10	78-8028-8208-0	Screw – 6P x 9,5
5670-11	78-8017-9018-5	Washer – Plain, M4
5670-12	78-8094-6383-5	Contactor – CA4-5-10, 110V, 60HZ
5670-13	78-8076-5378-3	Circuit Breaker, KTA-3-25
5670-14	78-8094-6384-3	Ground Clamp – VGPE 4/6
5670-15	78-8076-4968-2	Terminal
5670-16	78-8028-7909-4	Power Cord – U.S.A.
5670-17	78-8100-1038-5	Cable – 3 x 20 AWG, 5 MT
5670-18	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
5670-19	26-1003-7957-2	Screw – Soc Hex Hd, M6 x 16
5670-20	26-1000-0010-3	Washer – Flat, M6
5670-21	78-8076-5194-4	Box – E-Stop, Yellow
5670-22	78-8094-6386-8	Switch – On/Off, DM3N-C-01/10
5670-23	78-8100-1039-3	Support – On/Off Switch
5670-24	78-8017-9257-9	Screw – Phillis Head, M4 x 10
5670-25	78-8060-8087-1	Screw – M5 x 10
5670-26	78-8010-7417-6	Nut – Hex, M5
5670-27	26-1014-5845-8	E-Stop – 800EM-MTS644-3LX01
5670-28	78-8091-0538-6	Screw – Hex Hd, M4 x 25
5670-29	78-8076-4716-5	Star Washer – M4
5670-30	78-8010-7416-8	Nut – Hex, M4
5670-31	78-8100-1234-0	Collar
5670-33	78-8114-4896-4	Box – On/Off, Grey

700a Adjustable Case Sealer



Safety and Information Labels

Safety and Information Labels

A label kit, part number 78-8098-9175-3, is available as a stock item. It contains all the safety and information labels used on the case sealer, or labels can be ordered separately from the following list.

Ref. No.	3M Part No.	Description	Qty.
1	78-8070-1318-6	Label – Box Centering	1
2	78-8070-1329-3	Label – Warning	1
3	78-8070-1336-8	Label – Warning	2
4	78-8070-1339-2	Information – 3M Logo	2
5	78-8069-3852-6	Label – Ground	2
6	78-8068-3859-1	Label – Service and Spares	1
7	78-8062-4266-1	Label – Product	1
8	78-8070-1628-8	Label – Up and Down/Lock	2
9	78-8070-1366-5	Label – Safety Instructions	1
10	78-8060-8481-6	Label – Leg	4
11	78-8095-1141-9	Label – Stop	1
12	78-8113-6717-2	Label – Caution	1
13	78-8113-6768-5	Label – Caution, R/H	1
14	78-8113-6769-3	Label – Caution, L/H	1
15	78-8113-6770-1	Label – Notice	1
16	78-8113-6775-0	Label – Electrical On/Off	1
17	78-8113-6912-9	Label – Caution, Pinch Point	2