



Instructions and Parts List

3M-MaticTM

a80f

Type 11000

Adjustable Case Sealer

with

AccuGlideTM 2+ Taping Heads

Serial No. _____
For reference, record machine serial number here.



3M Industrial Adhesives and Tapes
3M Center, Building 220-5E-06
St. Paul, MN 55144-1000



Important Safety Information

BEFORE INSTALLING
OR OPERATING THIS
EQUIPMENT

Read, understand, and
follow all safety and
operating instructions.

Spare Parts

It is recommended you
immediately order the
spare parts listed in the
"Spare Parts/Service
Information" section.

These parts are expected
to wear through normal
use, and should be kept
on hand to minimize
production delays.

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3M St. Paul, MN 55144-1000
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This instruction manual covers safety aspects, handling and transport, storage, unpacking, preparation, installation, operation, adjustments, maintenance, troubleshooting, repair work and servicing plus parts list of the **3M-Matic™ a80f** Adjustable case sealer.

3M Industrial Adhesives and Tapes
3M Center, Building 220-5E-06
St. Paul, MN 55144-1000

Edition April 2011

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The manufacturer reserves the right to change the product at any time without notice.

Replacement Parts and Service Information

To Our Customers:



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

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

Technical Assistance / Replacement Parts and Additional Manuals:

Contact your local service provider. Provide the customer support coordinator with the model/machine name, machine type, and serial number that are located on the identification plate
(For example: Model a80f - Type 11000 - Serial Number 13282).

Identification Plate

	3M Company St. Paul, MN 55144 USA	Part Number <input type="text"/>	3M-Matic™ For Industrial Use Only			
Model <input type="text"/>		Serial Number <input type="text"/>	Year <input type="text"/>	Ampere <input type="text"/>	Watt <input type="text"/>	
Type <input type="text"/>			Volt <input type="text"/>	Hertz <input type="text"/>	Phase <input type="text"/>	



3M Industrial Adhesives and Tapes
3M Center, Building 220-5E-06
St. Paul, MN 55144-1000

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TAPING HEAD INFORMATION -
MANUAL 2: AccuGlide™ 2+ STD 2 Inch Taping Heads (See MANUAL 2 for Table of Contents)

ABBREVIATIONS AND ACRONYMS

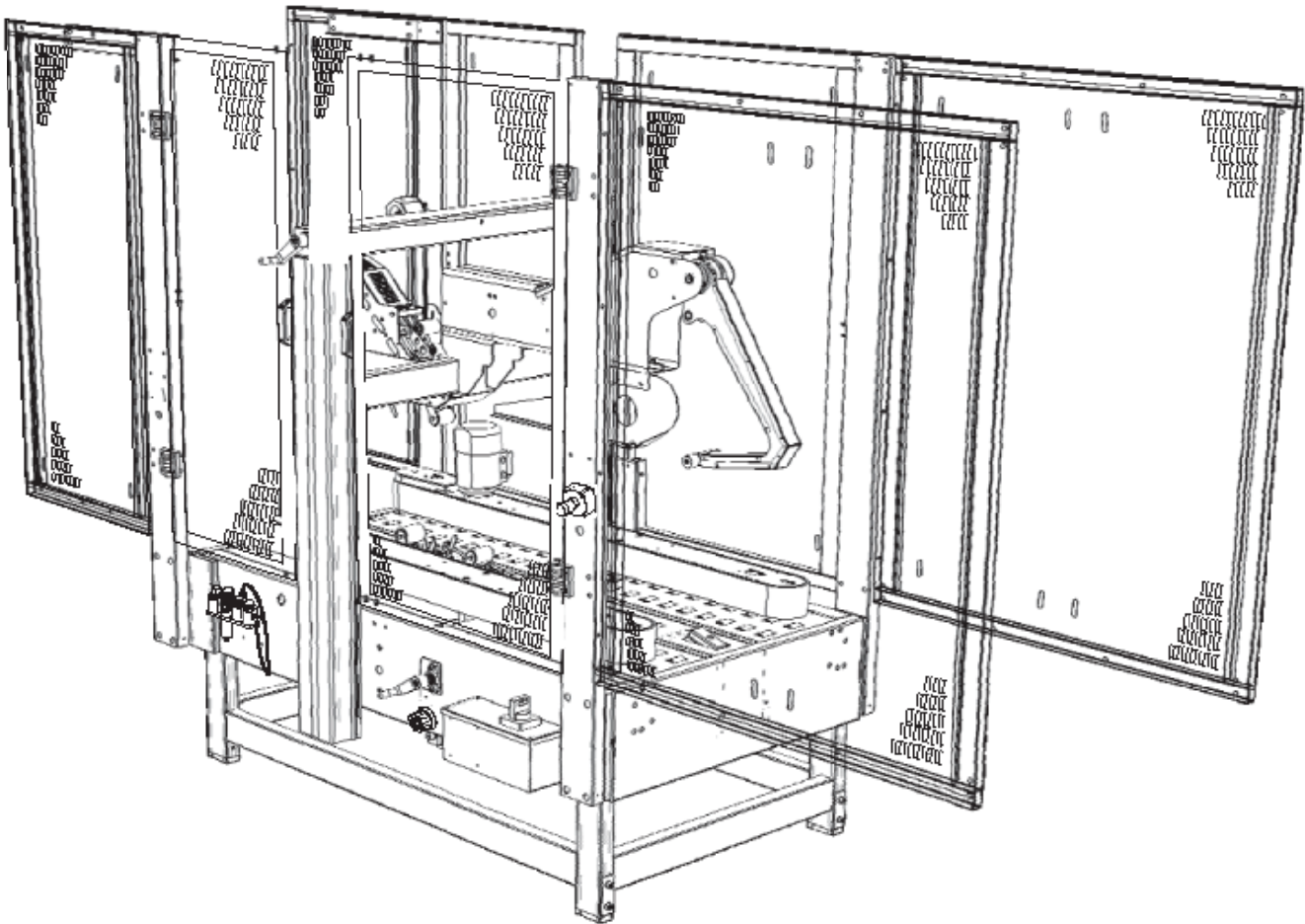
LIST OF ABBREVIATIONS, ACRONYMS

3M-Matic	- Trademark of 3M St. Paul, MN 55144-1000
AccuGlide	- Trademark of 3M St. Paul, MN 55144-1000
Scotch	- Trademark of 3M St. Paul, MN 55144-1000
Drw.	- drawing
Ex.	- for example
Figure	- exploded view figure no. (spare parts)
Figure	- Illustration
Max.	- maximum
Min.	- minimum
Nr.	- number
N/A	- not applicable
OFF	- machine not operating
ON	- machine operating
PLC	- Programmable Logic Control
PP	- Polypropylene
PU/PU Foam	- Polyurethane Foam
PTFE	- Polytetrafluorethelene
PVC	- Poly-vinyl chloride
W	- Width
H	- Height
L	- Length

1-INTRODUCTION

1.1 Manufacturing Specifications / Description / Intended Use

The intended use of the **3M-Matic™ a80f Adjustable Case Sealer with AccuGlide™ 2+ Taping Heads** is to automatically seal the top and bottom center seams of regular slotted containers. It will accept filled regular slotted containers from an existing conveyor, fold the top flaps and apply a "C" clip of **Scotch™** brand pressure-sensitive film box sealing tape to the top and bottom center seams of the box. The **a80f** has been designed and tested for use with **Scotch™** brand pressure-sensitive film box sealing tape.



3M-Matic™ a80f Adjustable Case Sealer, Type 11000

1.2 How to Read and Use the Instruction Manual

This instruction manual covers safety aspects, handling and transport, storage, unpacking, preparation, installation, operation, Setup and adjustments, technical and manufacturing specifications, maintenance, troubleshooting, repair work and servicing, electric diagrams, warranty information, disposal (ELV), a definition of symbols, plus a parts list of the 3M-Matic™ **a80f** Adjustable case sealer 3M Industrial Adhesives and Tapes Division 3M Center, Bldg. 220-5E-06 St. Paul, MN 55144-1000 (USA) / Edition April 2011 / Copyright 3M 2011 / All rights reserved. The manufacturer reserves the right to change the product at any time without notice. Publication © **3M 2011 44-0009-2096-5**.

1.2.1 Importance of the Manual

The manual is an important part of the machine; all information contained herein is intended to enable the equipment to be maintained in perfect condition and operated safely. Ensure that the manual is available to all operators of this equipment and is kept up to date with all subsequent amendments. Should the equipment be sold or disposed of, please ensure that the manual is passed on. Electrical and pneumatic diagrams are included in the manual. Equipment using PLC controls and/or electronic components will include relevant schematics or programs in the enclosure and in addition, the relevant documentation will be delivered separately.

1.2.2 Manual Maintenance

Keep the manual in a clean and dry place near the machine. Do not remove, tear, or rewrite parts of the manual for any reason. Use the manual without damaging it. If the manual has been lost or damaged, ask your after-sale service for a new copy.

1.2.3 Consulting the Manual

The manual is composed of:

- Pages which identify the document and the machine
- Index of the subjects
- Instructions and notes on the machine
- Enclosures, drawings and diagrams
- Spare parts (last section)

All pages and diagrams are numbered. The spare parts lists are identified by the figure identification number.

All the notes on safety measures or possible dangers are identified by the symbol:



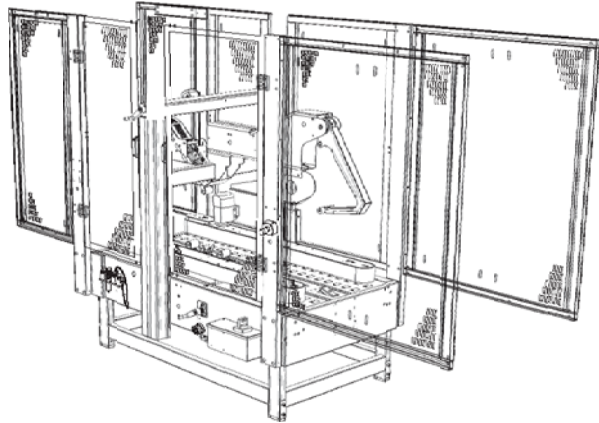
1.2.4 How to Update the Manual in Case of Modifications to the Machine


Modifications to the machine are subject to manufacturer's internal procedures. The user receives a complete and up-to-date copy of the manual together with the machine. Afterwards the user may receive pages or parts of the manual which contain amendments or improvements made after its first publication. The user must use them to update this manual.

2-GENERAL INFORMATION

2.1 Data Identifying Manufacturer and Machine

3M
**3M Industrial Adhesives
and Tapes**
3M Center Bldg. 220-5E-06
St. Paul, MN 55144-1000 (USA)



3M 3M Company St. Paul, MN 55144 USA	Part Number	3M-Matic™ For Industrial Use Only			
	Model		Year	Ampere	
Type	Serial Number		Volt	Hertz	Phase

2.2 Warranty

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™ a80f Adjustable Case Sealer, Type 11000** 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 – a80f Adjustable Case Sealer

- (1) **a80f** Adjustable Case Sealer, Type 11000
- (1) Tool/Spare Parts Kit
- (1) Instruction and Parts Manual

3-SAFETY

3.1 General Safety Information

Read all the instructions carefully before starting work with the machine; please pay particular attention to sections marked by the symbol:

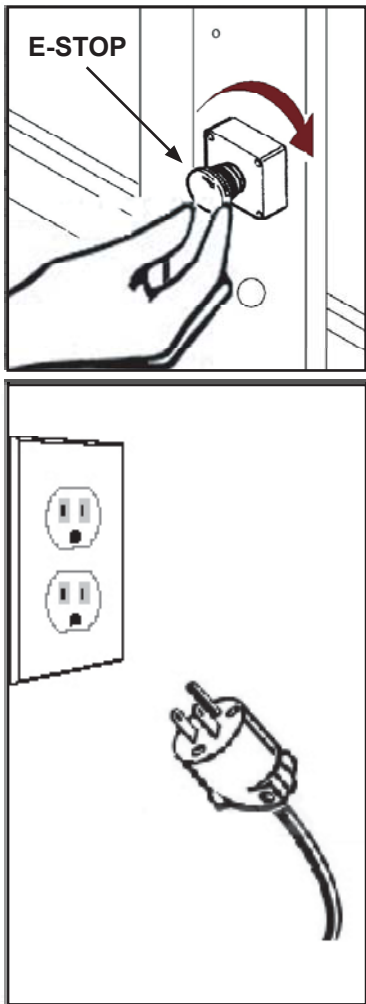


Figure 3-1

The machine is provided with a LATCHING EMERGENCY STOP BUTTON (**Figure 3-1**); when this button is pressed, it stops the machine at any point in the working cycle. Maintain clear access to power cord while machine is operating. Disconnect plug from power source before machine maintenance (**Figure 3-1**). Also disconnect air if the machine has a pneumatic system. Keep this manual in a handy place near the machine. This manual contains information that will help you to maintain the machine in a good and safe working condition.

3.2 Explanation of Signal Word and Possible Consequences



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





CAUTION: Indicates a potentially hazardous situation, which, if not avoided, may result in minor or moderate injury and/or property damage.





WARNING: Indicates a potentially hazardous situation, which, if not avoided, could result in death or serious injury and/or property damage.

3.3 Table of Warnings

 WARNING
<ul style="list-style-type: none">• To reduce the risk associated with mechanical and electrical hazards:<ul style="list-style-type: none">– Read, understand, and follow all safety and operating instructions before operating or servicing the case sealer.– Allow only properly trained and qualified personnel to operate and service this equipment.

 WARNING
<ul style="list-style-type: none">• To reduce the risk associated with hazardous voltage:<ul style="list-style-type: none">– Position electrical cord away from foot and vehicle traffic.

 WARNING
<ul style="list-style-type: none">• To reduce the risk associated with pinches, entanglement and hazardous voltage:<ul style="list-style-type: none">– Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.

 WARNING
<ul style="list-style-type: none">• To reduce the risk associated with pinches and entanglement hazards:<ul style="list-style-type: none">– Do not leave the machine running while unattended.– Turn the machine off when not in use.– Never attempt to work on any part of the machine, load tape, or remove jammed boxes from the machine while the machine is running.


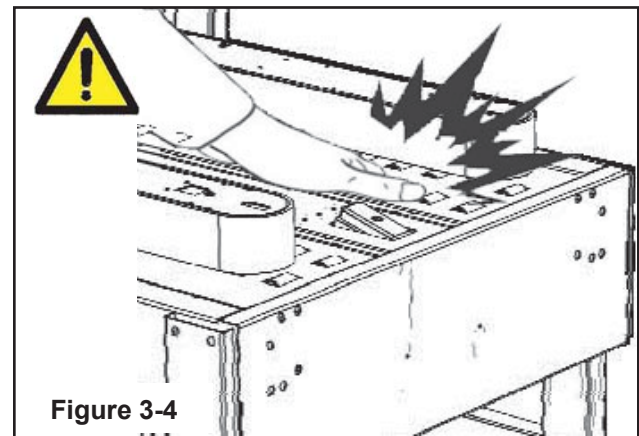
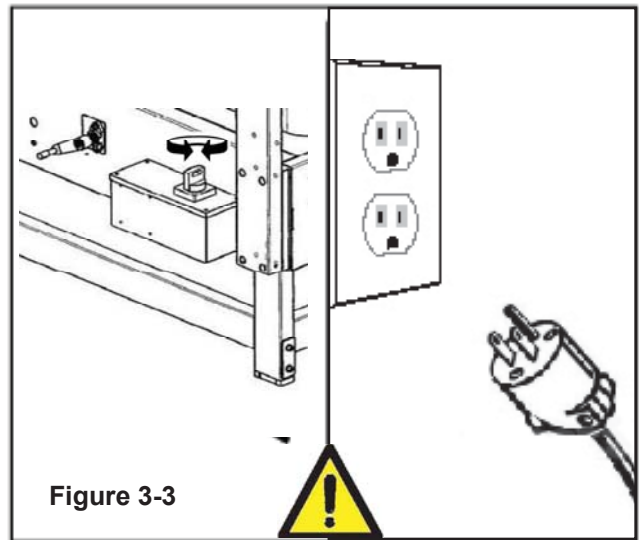
	SAFETY INSTRUCTIONS <ol style="list-style-type: none">1. Shut off machine before adjusting2. Unplug electric power before servicing3. Do not leave machine running unattended4. Refer to instruction manual for complete setup, operating, and servicing information
---	--

Figure 3-2





WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp.

Important : Never remove the safety device which covers the blade on the top and bottom taping units. Any error may cause serious injuries (**Figure 3-5**).

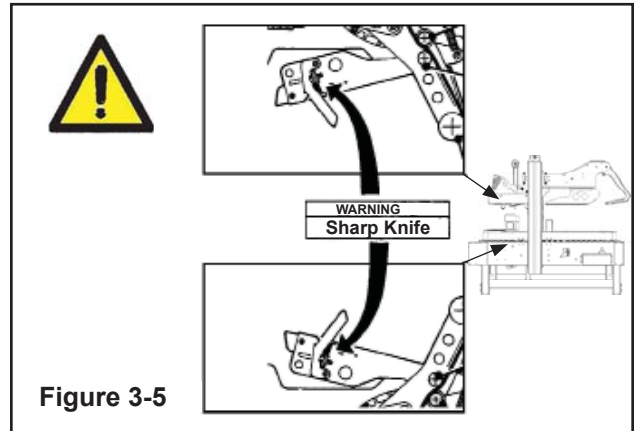


Figure 3-5



WARNING

- **To reduce the risk associated with fire and explosion hazards:**
 - Do not operate this equipment in potentially flammable/explosive environments.



WARNING

- **To reduce the risk associated with muscle strain:**
 - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment.
 - Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift.

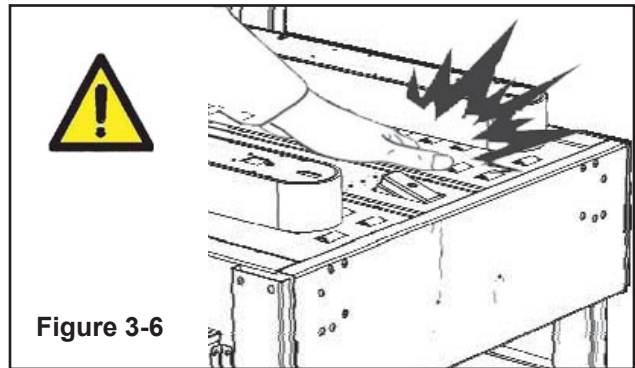


Figure 3-6



CAUTION

- **To reduce the risk associated with pinch hazards:**
 - Keep hands clear of the upper head support assembly as boxes are transported through the machine.
 - Keep hands, hair, loose clothing, and jewelry away from box compression rollers.
 - Always feed boxes into the machine by pushing only from the end of the box.
 - Keep hands, hair, loose clothing, and jewelry away from moving belts and taping heads.

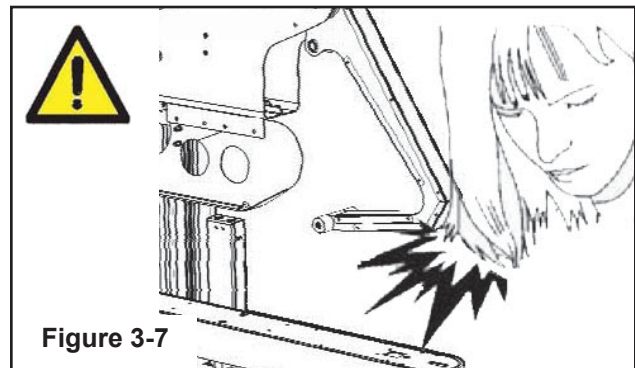


Figure 3-7

3.4 Operator's Qualifications

- Machine Operator
- Mechanical Maintenance Technician
- Electrical Maintenance Technician
- Manufacturer's Technician/Specialist

3.5 Number of Operators

The operations described below have been analyzed by the manufacturer; the recommended number of operators for each operation provides the best and safest work performance.

Note: A smaller or greater number of operators could be unsafe.

3.6 Instructions for a Safe Use of the Machine / Definition of Operator's Qualifications

Only persons who have the skills described in the skill levels section should be allowed to work on the machine. It is the responsibility of the user to appoint the operators having the appropriate skill level and the appropriate training for each category of job.

3.7 Residual Hazards

The case sealer has been designed and incorporates various safety protections which should never be removed or disabled. Notwithstanding the safety precautions conceived by the designers of the machine, it is essential that the operator and service personnel be warned that the residual hazards exist which cannot be eliminated.

3.8 Recommendations and Measures to Prevent Other Hazards which Cannot be Eliminated

- The operator must stay on the working position shown in the Operation Section (**Figure 12-1**).
- The operator must never touch the running driving belts or put his hands inside any cavity.
- The operator must pay attention to the blades during the tape replacement.



WARNING

- **To reduce the risk associated with mechanical and electrical hazards:**
 - Read, understand, and follow all safety and operating instructions before operating or servicing the case sealer.
 - Allow only properly trained and qualified personnel to operate and service this equipment.

3.9 Personal Safety Measures

Safety glasses, safety gloves, safety helmet, safety shoes, air filters, ear muffs - None is required except when recommended by the user.

3.10 Predictable Actions which are Incorrect and Not Allowed

- Never try to stop/hold the box while being driven by the belts.
Only use the EMERGENCY STOP BUTTON.
- Never work without the safety protections.
- Never remove or disable the safety devices.
- Only authorized personnel should be allowed to carry out the adjustments, repairs or maintenance which require operation with reduced safety protections. During such operations, access to the machine must be restricted. When the work is finished, the safety protections must immediately be reactivated.
- The cleaning and maintenance operations must be performed after disconnecting the electric power.
- Do not modify the machine or any part of it. The manufacturer will not be responsible for any modifications.
- Clean the machine using only dry cloths or light detergents. Do not use solvents, petrols, etc.
- Install the machine following the suggested layouts and drawings. The manufacturer will not be responsible for damages caused by improper installation.

3-SAFETY (continued)

3.11 Operator's Skill Levels Required to Perform the Main Operations on the Machine

The Table shows the minimum operator's skill for each machine operation.

Important: The factory manager must ensure that the operator has been properly trained on all the machine functions before starting work.

Skill 1: Machine Operator

This operator is trained to use the machine with the machine controls, to feed cases into the machine, make adjustments for different case sizes, to change the tape and to start, stop and restart production.

Skill 2: Mechanical Maintenance Technician

This operator is trained to use the machine as the MACHINE OPERATOR and in addition is able to:

- Work with the safety protection disconnected
 - Check and adjust mechanical parts
 - Carry out machine maintenance operations/repairs
- He is not allowed to work on live electrical components

Skill 2a: Electrical Maintenance Technician


This operator is trained to use the machine as the MACHINE OPERATOR and in addition is able to:

- Work with the safety protection disconnected
- Check and adjust mechanical parts
- Carry out machine maintenance operations / repairs / adjustments / repair electrical components

He is allowed to work on live electrical panels, connector blocks, control equipment, etc.

Skill 3: Specialist from the Manufacturer

Skilled operator sent by the manufacturer or its agent to perform complex repairs or modifications (on agreement with the customer).

 WARNING
<ul style="list-style-type: none"> • To reduce the risk associated with mechanical and electrical hazards: – Allow only properly trained and qualified personnel to operate and service this machine

Operator's Skill Levels Required to Perform the Main Operations on Machine

Operation	Machine Status	Required Operator Skill	Number of Operators
Machine installation and setup	Running with safety protections disabled	2 and 2a	2
Adjusting box size	Stopped by pressing the EMERGENCY STOP button	1	1
Tape replacement	Stopped by pressing the EMERGENCY STOP button	1	1
Blade replacement	Electric power disconnected	2	1
Drive belt replacement	Electric power disconnected	2	1
Ordinary maintenance	Electric power disconnected	2	1
Extraordinary mechanical maintenance	Running with safety protections disabled	3	1
Extraordinary electrical maintenance	Running with safety protections disabled	2a	1

3.12 Component Locations

Refer to **Figure 3-8** below to acquaint yourself with the various components and controls of the case sealer. Also refer to Manual 2 for taping head components.

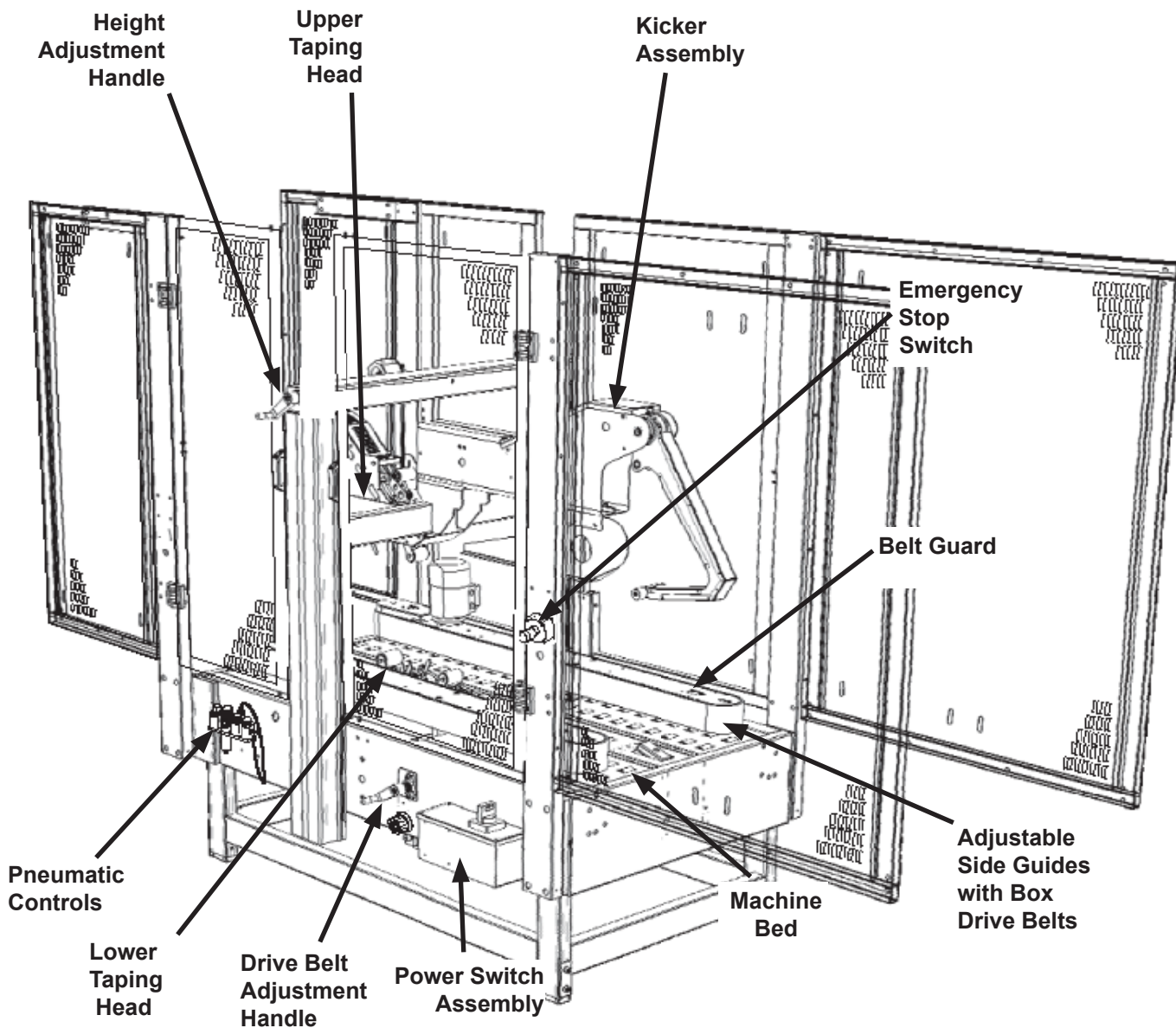


Figure 3-8—**a80f Case Sealer Components (Left Front View)**

3-SAFETY (continued)

3.13 Warnings and Replacements Labels

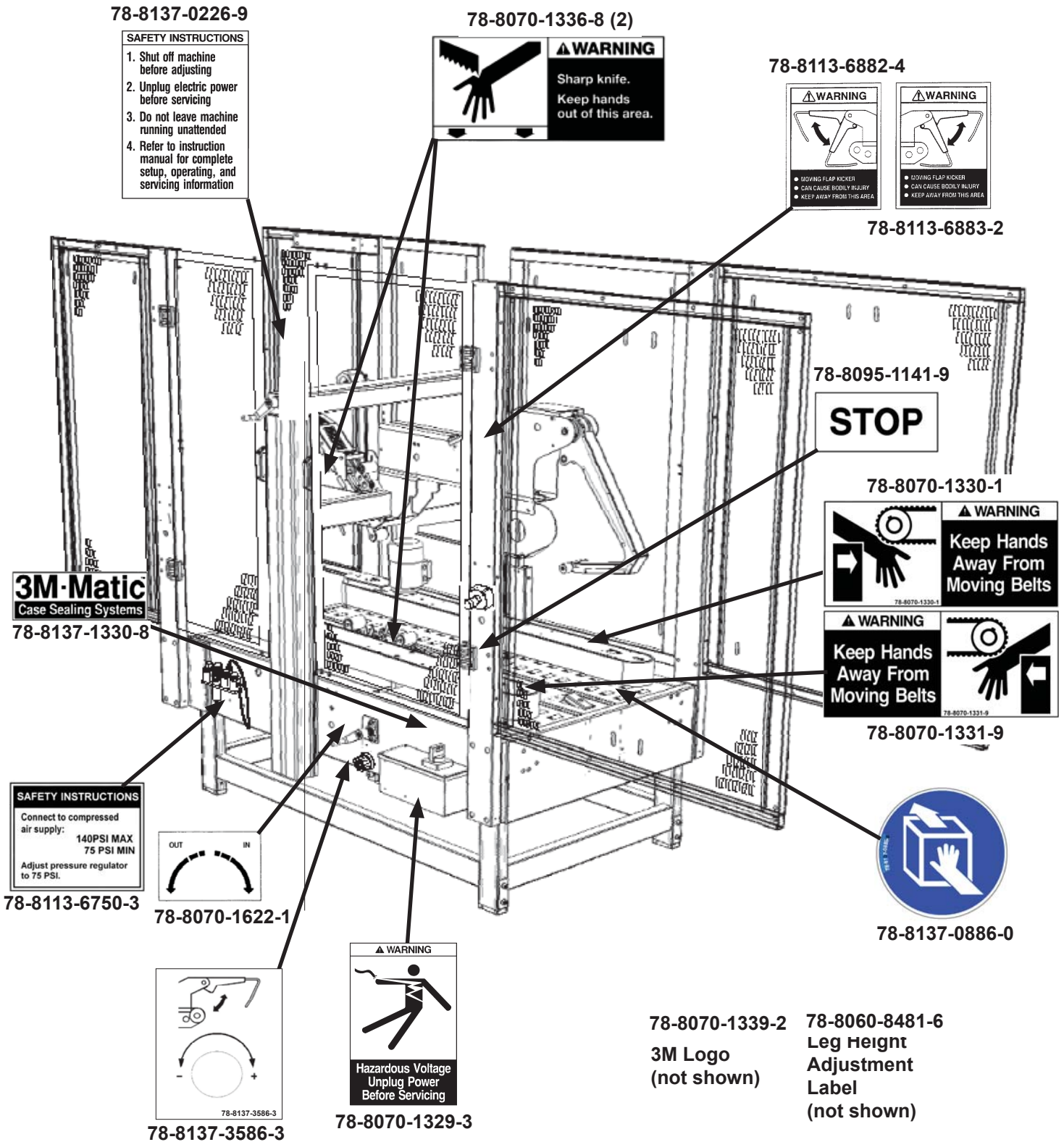


Figure 3-10 - Replacement Labels / 3M Part Numbers

4-SPECIFICATIONS

4.1 Power Requirements:

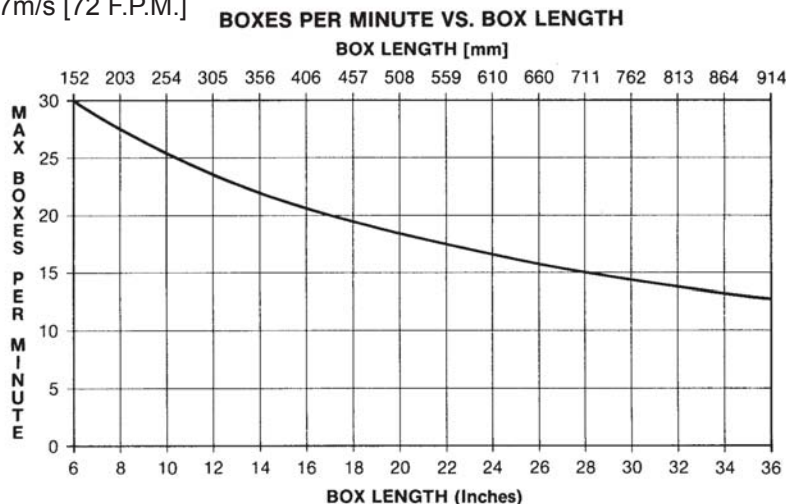
Electrical – 115 VAC, 60 Hz, 3.6 A

Pneumatic – 6.5 bar gauge pressure [95 PSIG], 2.5 SCFM
75 liter/minute @ 21° C., 1.01 bar maximum at maximum cycle rate.
A pressure regulator/filter is included.

The machine is equipped with two 1/6 HP gearmotors and comes 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. Contact your 3M Representative for power requirements not listed above.

4.2 Operating Rate:

Belt speed is 0.37m/s [72 F.P.M.]



Actual production rate is dependent on operator's dexterity.
Boxes must be 18 inches [457mm] apart minimum.

Actual production rate is dependent on operator's dexterity. Boxes must be 18 inches (457mm) apart minimum.

4.3 Operating Conditions

Use in dry, relatively clean environments at 4.4° C to 48.9° C [40° F to 120° F] with clean, dry boxes.

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



WARNING

- To reduce the risk associated with fire and explosion hazards:
- Do not operate this equipment in potentially flammable or explosive environments.

4.4 Tape

Scotch® pressure-sensitive film box sealing tapes.

4.5 Tape Width:

Minimum – 36mm [1-1/2 inches]

Maximum – 48mm [2 inches]

4.6 Tape Roll Diameter

Up to 405mm [16 inch] maximum on a 76mm [3 inch] diameter core. (Accommodates all system roll lengths of Scotch® film tapes.)

4-SPECIFICATIONS (continued)

4.7 Tape Application Leg Length – Standard

70mm ± 6mm [2.75 inch ±. 25 inch]

Tape Application Leg Length – Optional

50mm ± 6mm [2 inch ±. 25 inch]

(See "Removing Taping Heads Procedure – Changing the Tape Leg Length".)

4.8 Box Board

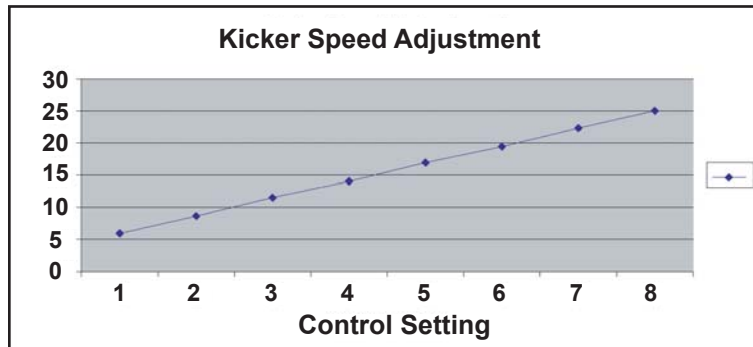
Style – regular slotted containers – RSC

125 to 275 P.S.I. bursting test, single wall or double wall B or C flute.

23-44 lbs. per inch of width Edge Crush Test (ECT)

4.9 Box Kicker Adjustment

Fine Tunes the timing of the box kicker (contact your 3M Representative for more information)



4.10 Box Weight and Size Capacities

A. Box Weight, filled: 5 lbs.– 65 lbs. [2.3kg–29.5kg]. Contents must support flaps.

B. Box Size:	Minimum	Maximum
Length:	152mm [6.0 inch]	610mm [24.0 inch]
Width:	120mm [4.75 inch]*	546mm [21.5 inch]
Height:	120mm [4.75 inch]**	546mm [21.5 inch]

* Boxes lower than 165mm [6-1/2 inches] and wider than 320mm [12-1/2 inches] require removal of compression rollers.

With taping heads adjusted to apply 50mm [2 inch] tape legs, minimum box height is 95 mm [3-3/4 inches] with box widths greater than 195 mm[7-3/4 inches]. See "Special Setup Procedure - Changing the Tape Leg Length", page 34.

** With columns adjusted to upper position, maximum box height increase to 725 mm [28-1/2 inches] and minimum box height increases to 225mm [8-3/4 inches]. See "Special Setup Procedure – Outer Column Re-Positioning"

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 0.6 or less, test run several boxes to ensure proper machine performance.

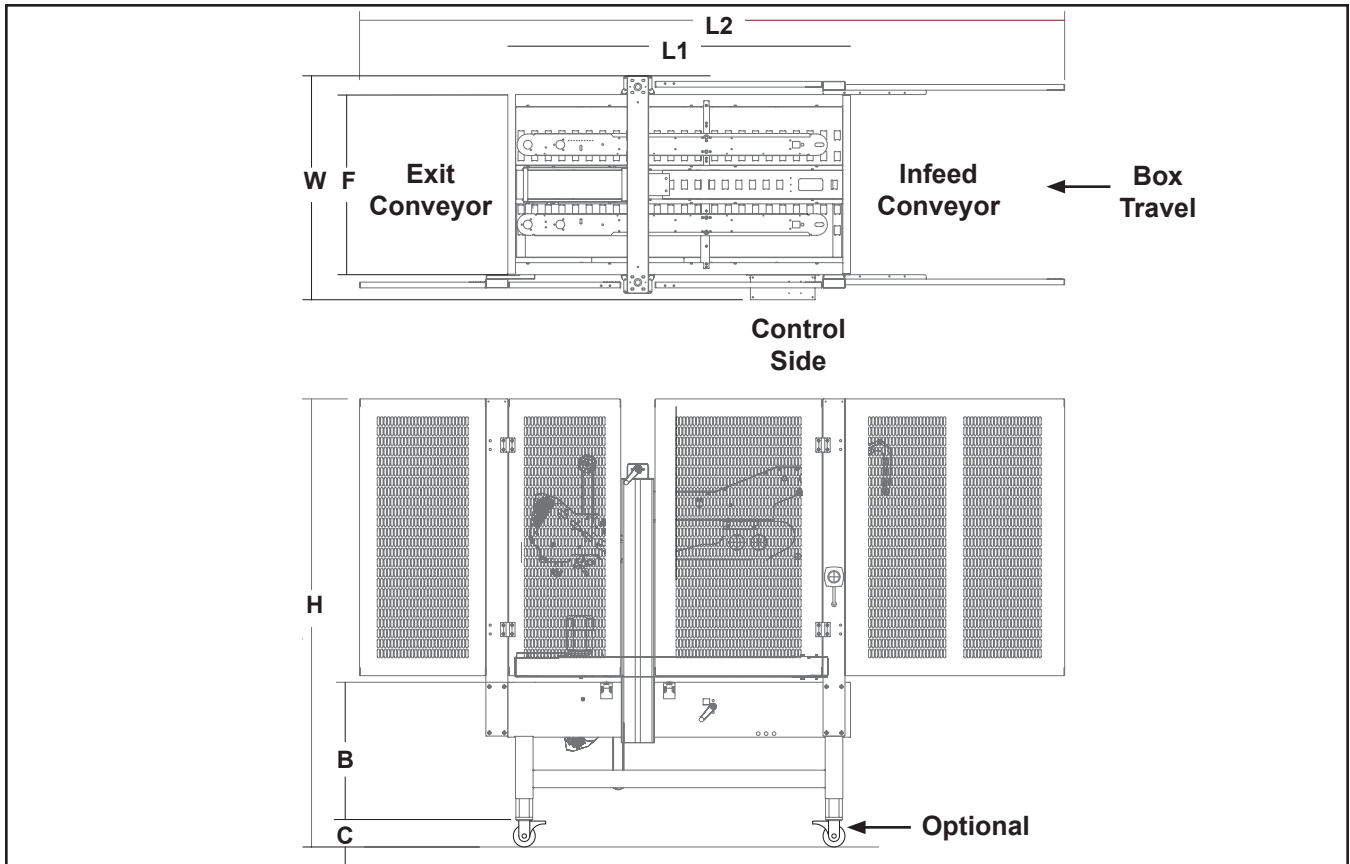
In addition, the box score lines must be sufficient to facilitate automatic flap folding. Certain environmental conditions, such as high humidity, can be detrimental to automatic flap folding.

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

$$\frac{\text{BOX LENGTH IN DIRECTION OF SEAL}}{\text{BOX HEIGHT}} = \text{SHOULD BE GREATER THAN 0.6}$$

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

4-SPECIFICATIONS (continued)



4.11 Machine Dimensions

	W	L1	L2	H	B	F	C
Minimum							
mm	985	1920	2375	1575	610	825	106
[Inches]	[38-3/4]	[75-5/8]	[93-7/16]	[62]	[24]	[32-1/2]	[4.2]
Maximum							
mm	985	1920	2375	2185	890	825	106
[Inches]	[38-3/4]	[75-5/8]	[93-7/16]	[86]	[35]	[32-1/2]	[4.2]

Weight – 290 kg [631 lbs.] crated (approximate)
 250 kg [545 lbs.] uncrated (approximate)

4.12 Machine Noise Level: Acoustic pressure measured at a distance of 1m. from machine with Scotch PVC adhesive tape in operation; 78dB Acoustic radiation pressure at 1.6m. height with Scotch PVC adhesive tape in operation; 73dB Measurement taken with appropriate instrument: (Type SPYRI-MICROPHON 11).

4.13 Setup 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.

5-SHIPMENT-HANDLING-STORAGE, TRANSPORT

5.1 Shipment and Handling of Packed Machine

- The machine is fixed on the pallet with four (4) bolts and can be lifted by using a fork truck.
- The package is suitable to travel by land and by air.
- Optional sea freight package is available.

Packaging Overall Dimensions(Figure 5-1)

See Specifications.

During the shipment it is possible to stack a maximum of two (2) machines (Figure 5-2).

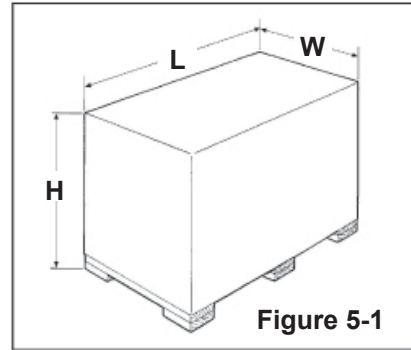


Figure 5-1

5.2 Packaging for Overseas Shipment (Optional - Figure 5-3)

The machines shipped by sea freight are covered by an aluminum/polyester/polythene bag which contains dehydrating salts.

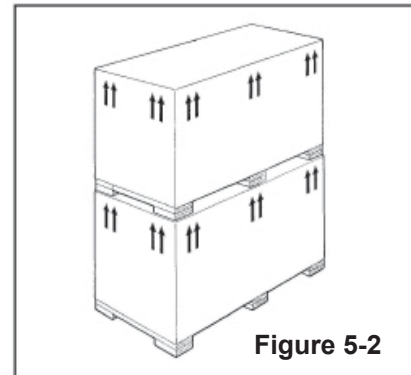


Figure 5-2

5.3 Handling and Transportation of Uncrated Machine

The uncrated machine should not be moved except for short distances and indoors ONLY. Without the supporting pallet, the machine is exposed to damage and may cause injuries. To move the machine use belts or ropes, paying attention to place them in the points indicated using care to not interfere with the lower taping head.

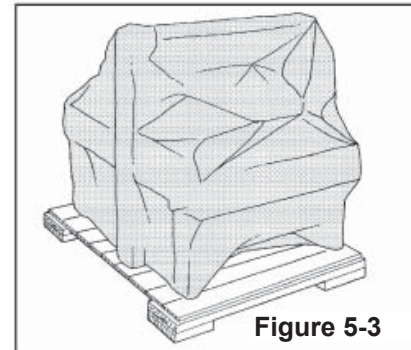
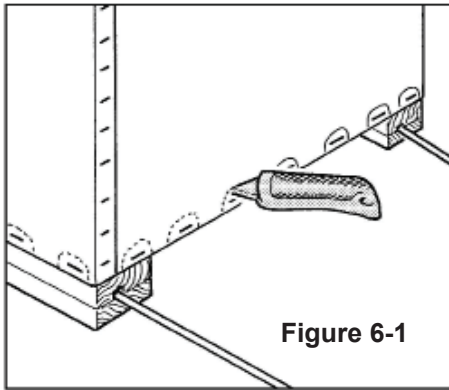


Figure 5-3

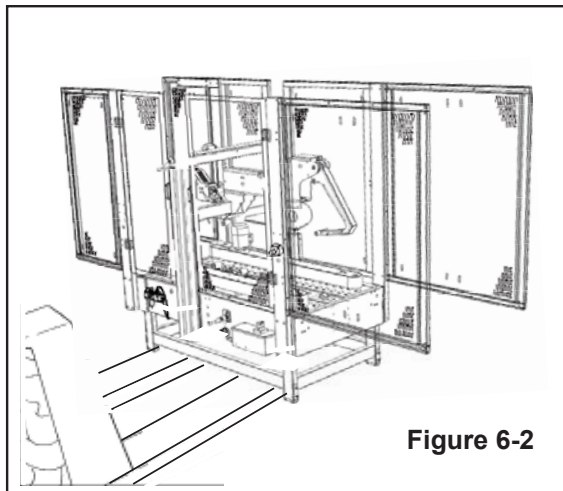
6-UNPACKING

6.1 Uncrating

Cut straps. Cut out staple positions along the bottom of the shipping box or remove staples with an appropriate tool (**Figure 6-1**)



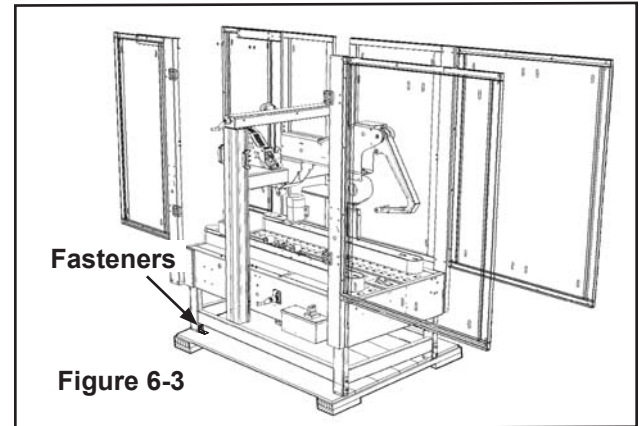
After cutting out or removing the staples, lift the shipping box in order to clear the machine
Note: Two (2) persons required.



Transport the machine with a fork-lift truck to the operating position. Lift the pallet at the point indicated in **Figure 6-2** (weight of machine - see **Section 4**).

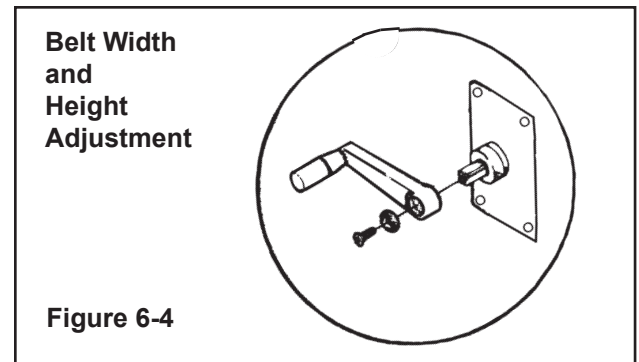
Removal of Pallet

Using a 10mm combination wrench, remove the fasteners that secure the case sealer legs to pallet at each leg (as shown in **Figure 6-3**).



Remove the leg height adjustment cap screws and replace with the cap screws from the tool kit. Loosen both cap screws. Remove and replace them one at a time to keep the inner threaded plate in position.

Locate on the machine (or in the spare parts box) the Height Adjustment and Drive Belt Adjustment handles. Using a 3mm hex wrench, install the handles on the side of the machine pointing outward (as shown in **Figure 6-4**).



6.2 Disposal of Packaging Materials

The a80f package is composed of:

- Wooden pallet
- Cardboard shipping box
- Wooden supports
- Metal fixing brackets
- PU foam protection
- PP plastic straps
- Dehydrating salts in bag
- Special bag of laminated polyester/aluminium/ Polyethylene (sea freight package only)
- Polyethylene protective material

For the disposal of the above materials, please follow the environmental directives or the law in your country.

7-INSTALLATION

7.1 Operating Conditions

(see Section 4).

7.2 Space Requirements for Machine Operation and Maintenance Work

Minimum distance from wall (**Figure 7-1**):

A = 1.0m. (39.4 inches)

B = 0.7m. (27.6 inches)

Minimum height = 2.7m. (106.3 inches)

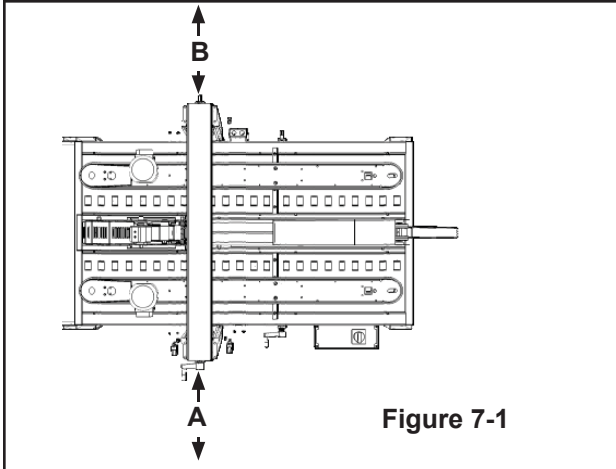


Figure 7-1



WARNING

- To reduce the risk associated with mechanical and electrical hazards:
 - Read, understand, and follow all safety and operating instructions before operating or servicing the case sealer.

7.3 Tool Kit Supplied with the Machine

A tool kit containing some tools are supplied 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.



WARNING

- To reduce the risk associated with muscle strain:
 - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment.
 - Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift.

7.4 Machine Positioning / Bed Height

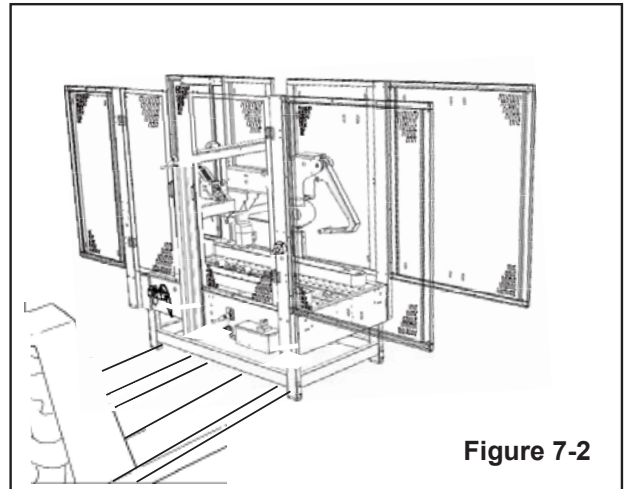


Figure 7-2

Adjust machine bed height. The case sealer is equipped with four (4) adjustable legs that are located at the corners of the machine frame. The legs can be adjusted to obtain different machine bed heights from 610mm [24 inches] minimum to 890mm [35 inches] maximum.

Refer to **Figure 7-3** and set the machine bed height as follows:

1. Raise and block up the machine frame to allow adequate leg adjustment.
2. Loosen, but do not remove, two (2) M8 x 16mm socket head screws in one leg (M6 hex wrench). Adjust the leg length for the desired machine bed height. Retighten the two (2) screws to secure the leg. Adjust all four (4) legs equally.

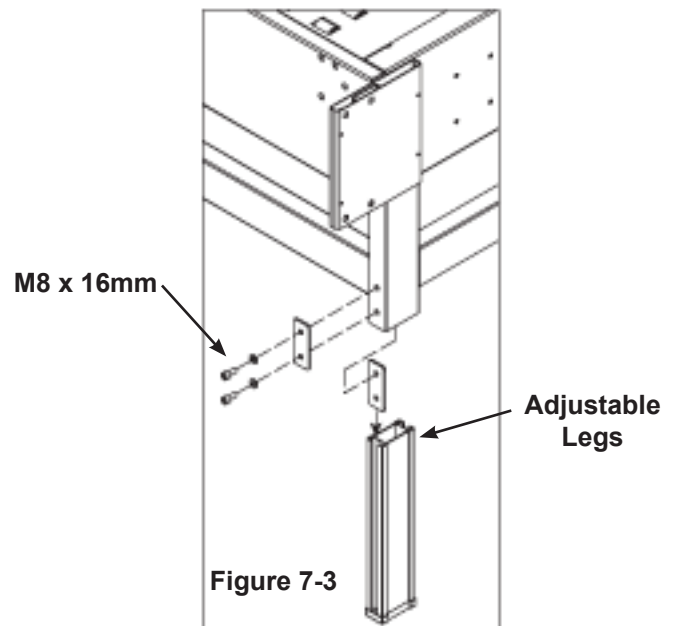


Figure 7-3

7.5 Removal of Plastic Ties

Cut the plastic which attaches the top head to the frame and remove the polystyrene blocks (**Figure 7-4**).

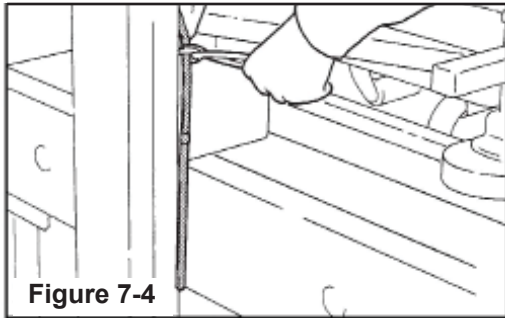


Figure 7-4

7.6 Assembly Completion

1. Raise the upper head by turning the height adjustment handle clockwise and remove the polystyrene blocks.
2. Cut the plastic ties holding the upper and lower taping heads in position. Hold taping head buffing roller while cutting the plastic tie. Allow buffing/applying arms to extend slowly (**Figure 7-5**).
3. Verify that the upper and lower taping heads move freely by pushing the buffing roller into the taping head.
4. Ensure that the tape drum bracket assembly (located on the upper and lower taping heads) is mounted vertically as shown in **Figure 7-6**.

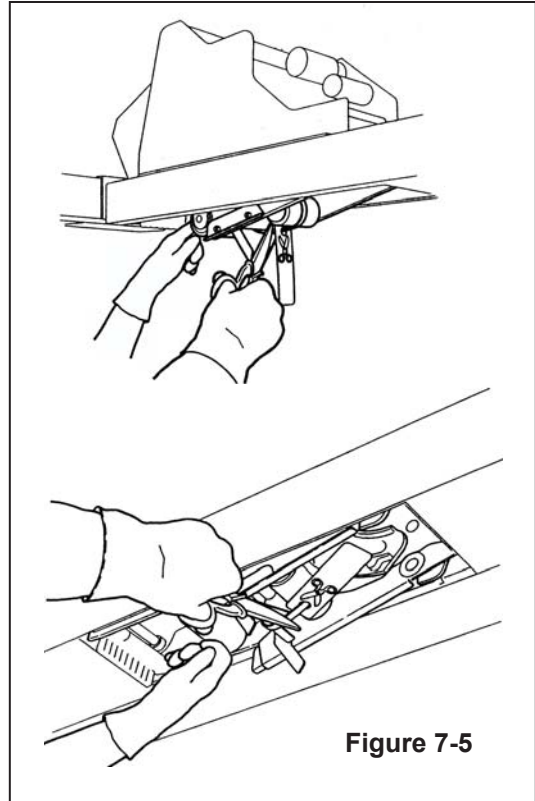


Figure 7-5

Note: The tape drum bracket assembly may be pivoted to provide tape roll clearance if necessary.

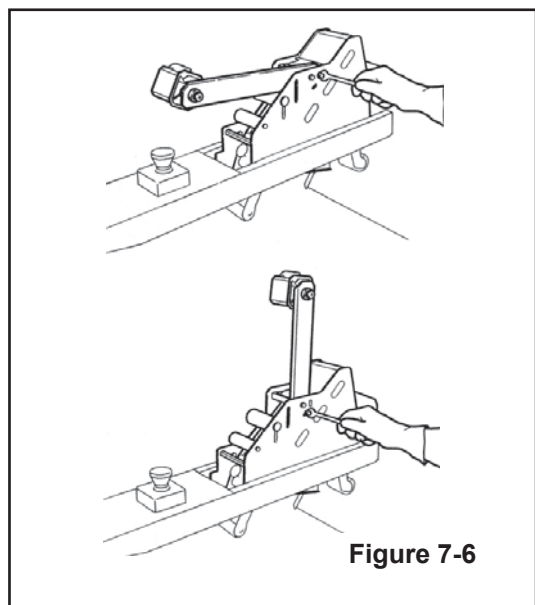


Figure 7-6



WARNING

- To reduce the risk associated with sharp blade hazards:
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp.



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp.

7.7 Completion of Taping Heads

See Manual 2 for Complete Instructions:

Important – Do not cut against the apply roller - roller damage could occur.



WARNING

- **To reduce the risk associated with mechanical and electrical hazards:**
 - Read, understand, and follow all safety and operating instructions before operating or servicing the case sealer.
- **To reduce the risk associated with hazardous voltage:**
 - Position electrical cord away from foot and vehicle traffic.

7.8 Preliminary Electric Inspection

Before connecting the machine to the mains please carry out the following operations:

- 7.8.1** Make sure that the socket is provided with an earth protection circuit and that both the mains voltage and the frequency match the specifications on the name plate.
- 7.8.2** Check that the connection of the machine to the mains meets the safety regulations in your country.
- 7.8.3** The machine is fitted with a main switch. The user will be responsible for testing the short-circuit current in its facility and should check that the short-circuit amperage setting of the machine is compatible with all the components of the mains system.

7.9 Machine Connection to the Mains

For technical specifications:

See Section 4 -Specifications

- Push the LATCHING EMERGENCY STOP BUTTON.
- The main switch is normally turned OFF.

Connect the power cord supplied with the machine to a wall socket using a plug which complies with the safety regulations of your country.

**7.10 Inspection of Phases
(For Three-Main Phases Only)**

(N/A for this machine)

7-INSTALLATION (continued)

7.11 Pneumatic Connection

Important: Use care when working with compressed air.

For compressed air supply see Technical Specifications,


1. Read and remove safety tag from pneumatic "On/Off" valve.
2. Connect the main air supply line to the inlet side of the On/Off valve using the barbed fitting and hose clamp provided. The customer supplied air hose (8mm [5/16 inches] Inner Diameter) must be clamped tightly to the barbed fitting.

If another type of connector is desired, the barbed fitting can be removed and replaced with the desired threaded connector.

Important: Always turn the air valve **Off** when the air supply line is being connected or disconnected.

3. Turn the air supply on by turning the air On/Off valve to On.

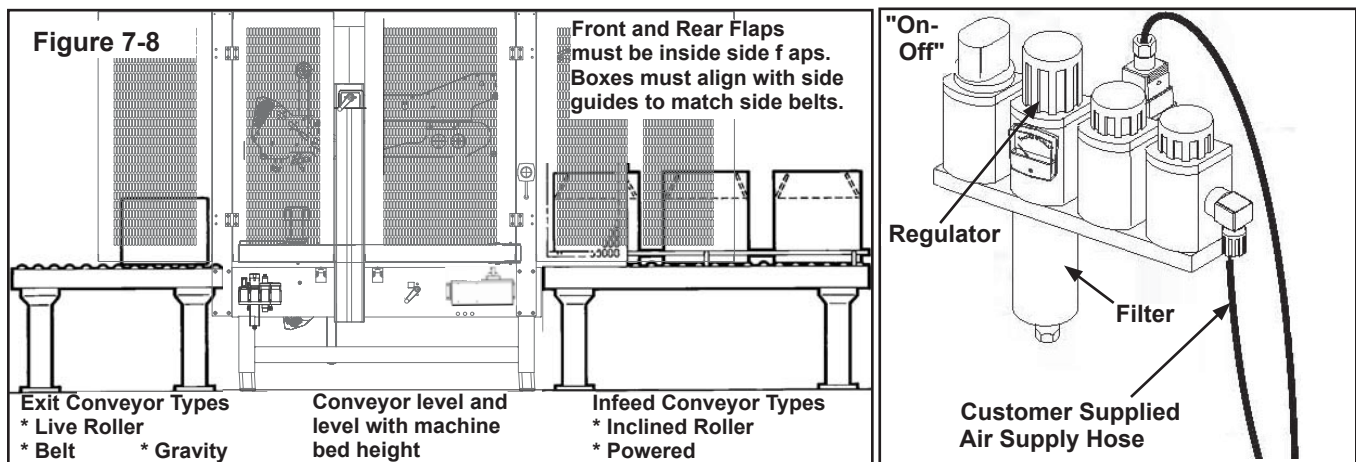
Note: The air valve has provisions for lock out/tag out according to plant regulations.


WARNING

- **To reduce the risk associated with muscle strain:**
 - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment.
- **To reduce the risk associated with impact hazards:**
 - Always turn the valve "Off" when air supply line is being connected or disconnected.

7.12 Infeed Conveyor Assembly

1. Remove the conveyor and the package of parts from the carton.
2. Verify that the package contains two flat plates, ten (10) M8 x 20 hex socket head screws, and ten (10) M8 flat washers.
3. To assemble the infeed conveyor, refer to **Figure 7-8** and locate the bolt holes on the infeed end of the case sealer frame and the bolt holes on the infeed conveyor.
4. Place the flat plates over the conveyor and the frame on each side.
5. Insert a screw in each hole so that only a few threads take hold. **Note:** Be sure to line up and level the Machine and Infeed Conveyor Rollers. Adjustments can be made to the position of the infeed conveyor before tightening screws.
6. Ensure that infeed conveyor rollers are level with machine infeed rollers. Adjust position of the bed height and infeed conveyor before tightening all screws. When adjusting Case Sealer Legs, block up the machine frame to allow adequate leg adjustment. This will help to prevent damage to the boxes and ensure proper performance.
7. Install case sealer in production line. When installing the case sealer, be sure to observe the following guidelines.
 - a. Case sealer must be installed level – it is not designed to convey boxes uphill.
 - b. Infeed conveyor must convey boxes to case sealer at the target speed indicated in Specifications (**Section 4**).
 - c. Precautions must be taken to prevent excessive box pressure against the case sealer infeed gate. This will help to prevent damage to the boxes and ensure proper performance.
 - d. Infeed and exit conveyors must provide straight entrance and exit of boxes to/from case sealer and exit conveyor must positively convey boxes away from machine



8-THEORY OF OPERATION

8.1 Description of the Working Cycle

The operator pushes the carton between the two side belts causing the two side belts to drive the box through the taping heads which automatically closes and seals the top and bottom seams. The carton is then expelled on the exit conveyor.

8.2 Definition of Running Mode

The case sealer a80f has only one (automatic) operating mode with:

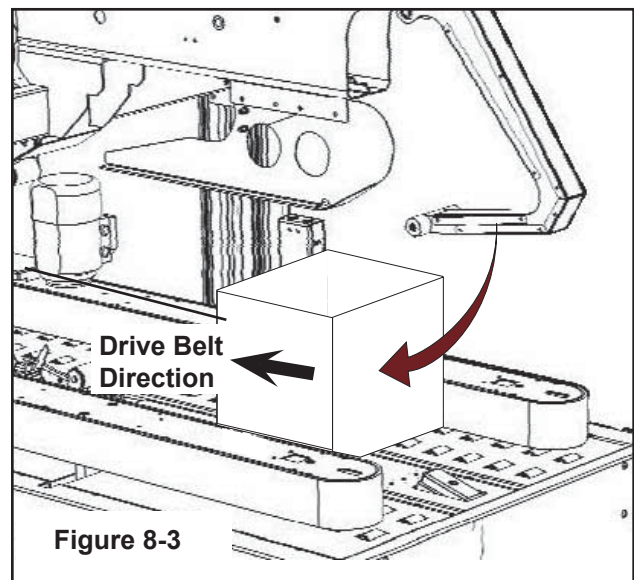
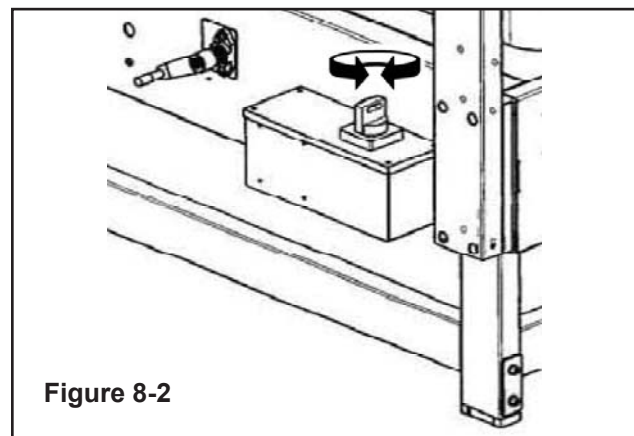
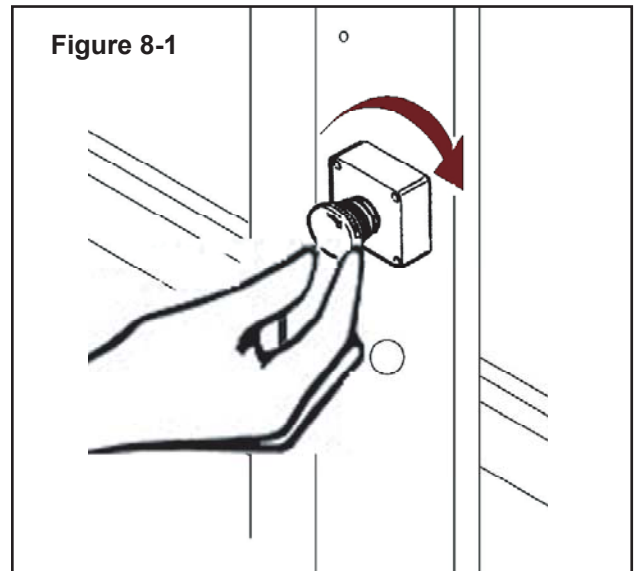
- The EMERGENCY STOP BUTTON unlocked (**Figure 8-1**)
- The main rotary switch "ON" (**Figure 8-2**)

8.3.1 Normal Stop Procedure

When the rotary main switch is turned OFF, the machine stops immediately at any point of the working cycle. The same thing happens in case of electrical failure or when the machine is disconnected from the mains.

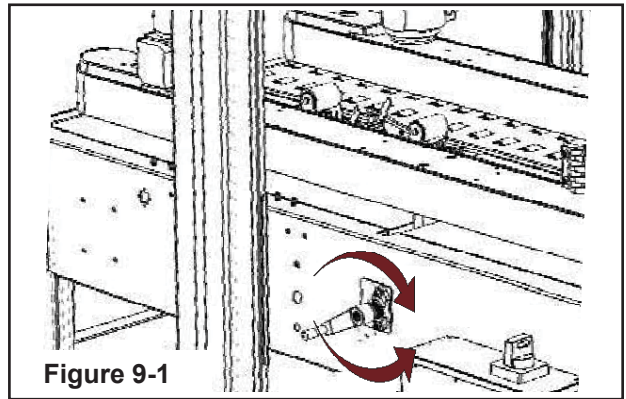
8.3.2 Emergency Stop

The latching EMERGENCY STOP BUTTON is located on the machine frame.

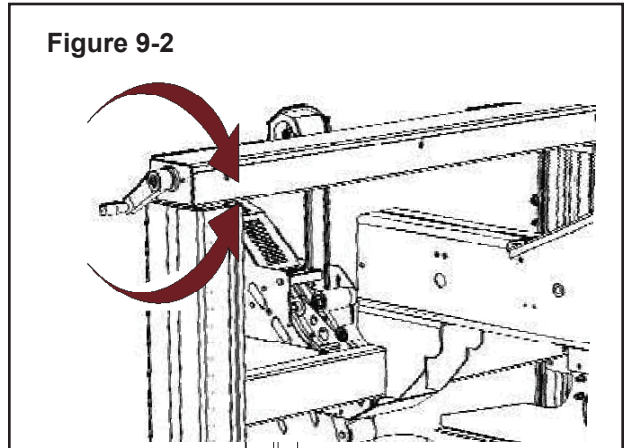


9-CONTROLS

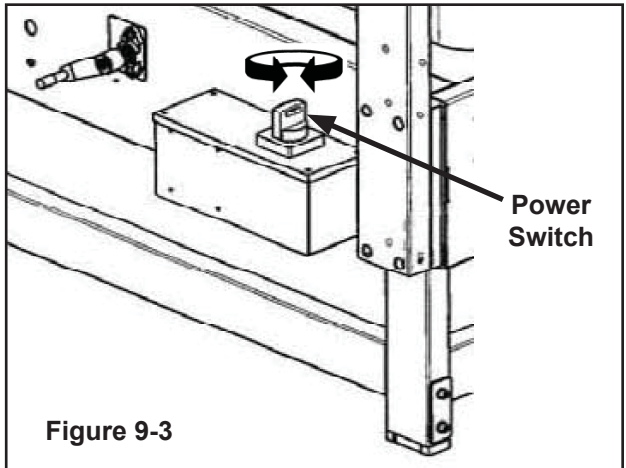
9.1 Box Width Adjusting Knobs



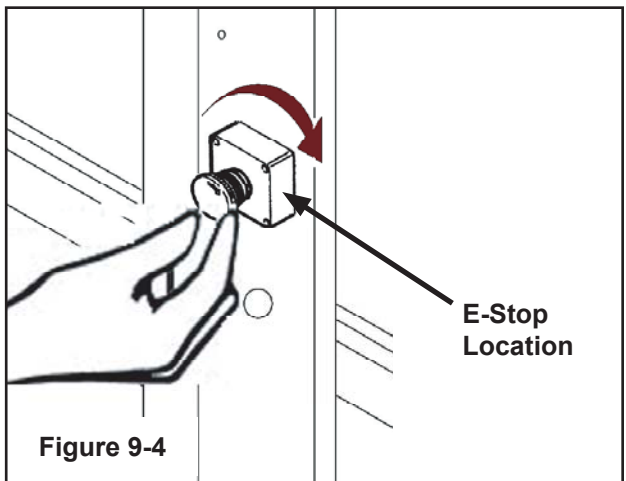
9.2 Box Height Adjusting Crank



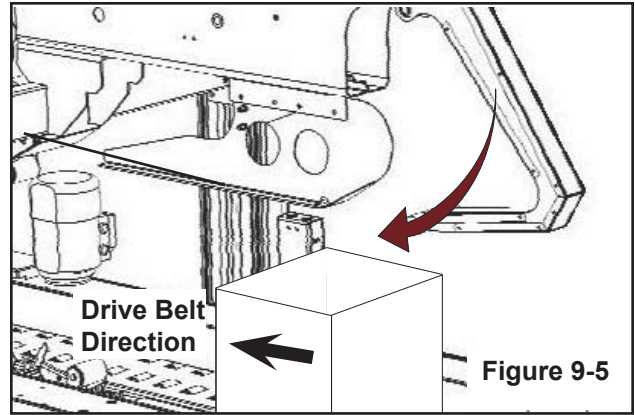
9.3 On / Off Power Switch



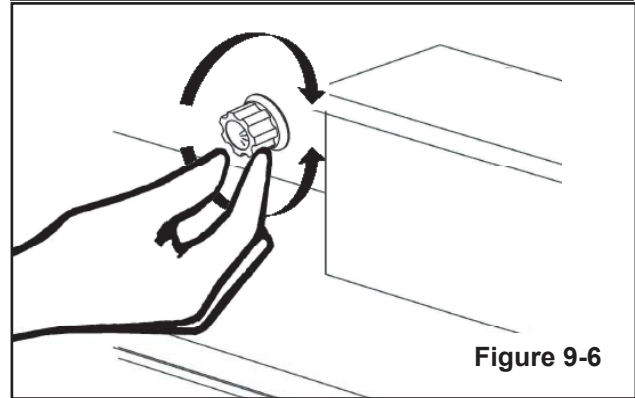
9.4 Latching Emergency Stop Button



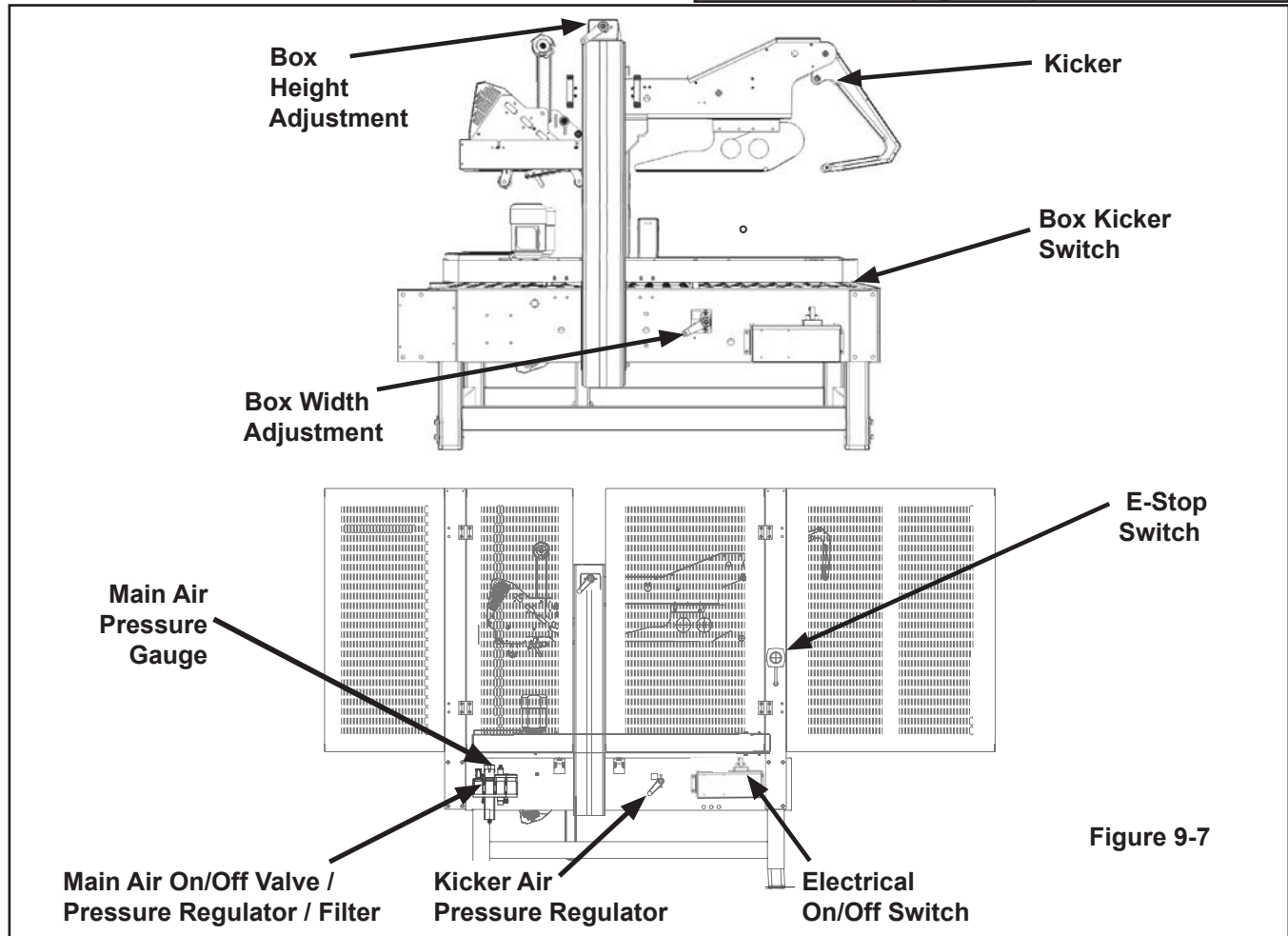
9.5 Box Conveying / Tape Seal Application



9.6 Kicker Adjustment Knob



9.7 Location of Controls



10-SAFETY DEVICES OF THE MACHINE

10.1 Blade Guards

Both the top and bottom taping units have a blade guard (See Manual 2):
AccuGlide™ 2+ STD 2 Inch Taping Heads).



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp.

10.2 Emergency Stop Button

The box drive belts are turned on and off with the electrical switch on the side of the machine frame.

The machine electrical supply can be turned off by pressing the latching emergency stop switch. To restart machine, rotate the emergency stop switch clockwise to release the switch latch. Restart machine by pushing the Start button (Figure 10-1).



WARNING

- **To reduce the risk associated with pinches, entanglement and hazardous voltage:**
 - Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.



WARNING

- **To reduce the risk associated with hazardous voltage:**
 - Position electrical cord away from foot and vehicle traffic.

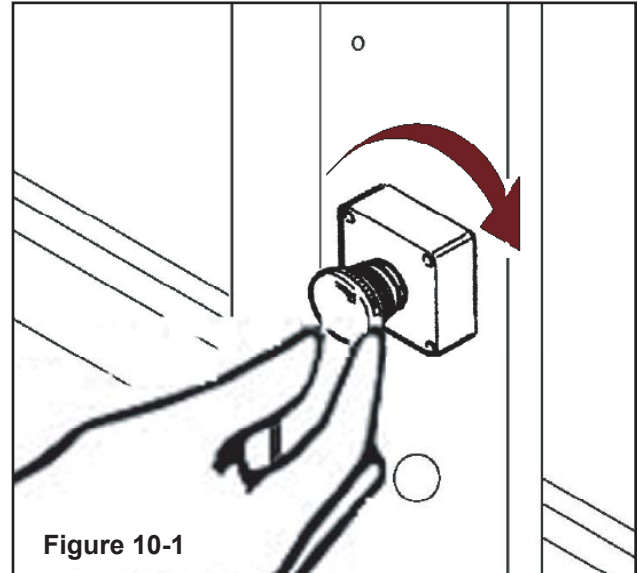


Figure 10-1

10.3 Electric System / Circuit Breaker

The electric system is protected by a ground wire whose continuity has been tested during the final inspection. The system is also subject to insulation and dielectric strength tests.

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 and requires no further maintenance.



WARNING

- **To reduce the risk associated with mechanical and electrical hazards:**
 - Allow only properly trained and qualified personnel to operate and service this equipment.

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

1. Determine cause of overload and correct.
2. Plug in machine.
3. Press machine "On" button to resume case sealing.

Important: The use of an extension cord is not recommended. However, if one is needed for temporary use, it must:

- Have a wire size of 1.5mm diameter [AWG 16]
- Have a maximum length of 30.5m [100 ft]
- Be properly grounded.

11 - SET UP AND ADJUSTMENTS

11.1 Box Width Adjustment

Place the box on the infeed end of frame bed and align top flap center seam with arrows on front of upper frame. Then, using the hand crank on the side of the machine, move the side belts inward until they come in contact with the side of the box to be sealed (**Figure 11-1**).

11.2 Box Height Adjustment

Lower top head by turning the height adjustment crank clockwise until it lightly presses the case (**Figure 11-2**).

11.3 Adjustment of Top Flap Compression Rollers

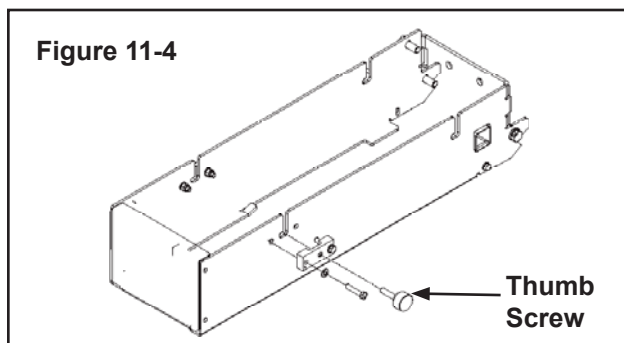
Note: This step applies to machines with the optional box compression rollers.

For machines with box compression rollers, move the top flap compression rollers until they contact the sides of the box. Tighten knobs to secure rollers in operating position (**Figure 11-3**).

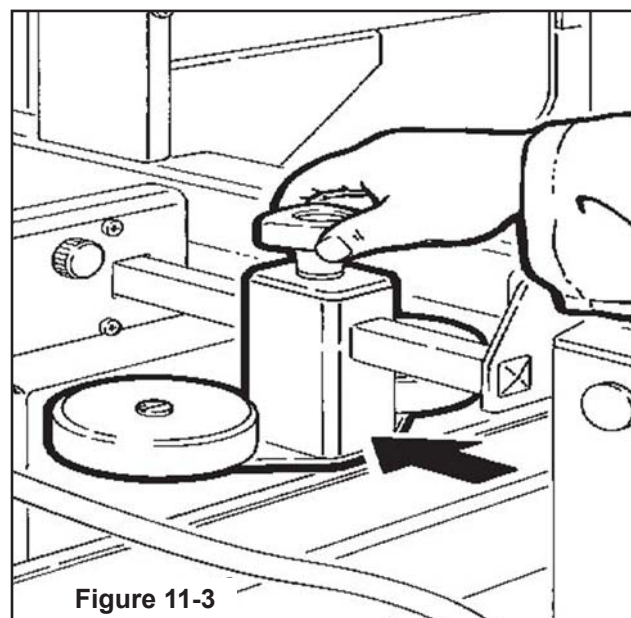
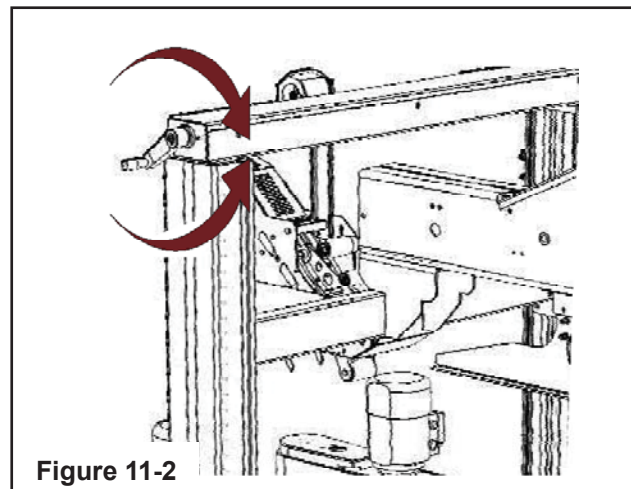
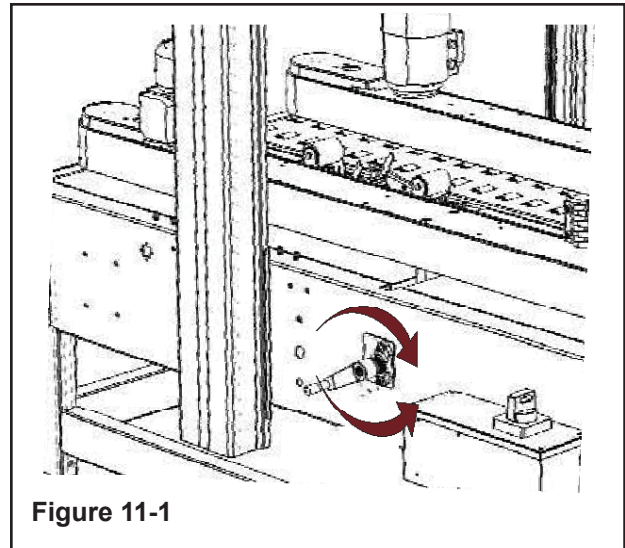
11.4 Changing the Tape Leg Length

Taping heads are preset to apply 70mm [2.75 inches] long tape legs. To change tape leg length to 50mm [2.0 inches], refer to Instructions below and also to Manual 2, "Removing Taping Heads Procedure - Changing the Tape Leg Length".

1. Remove tape from upper taping head and raise upper assembly to a convenient working height.
2. Loosen the upper taping head clamp thumb screw (**Figure 11-4**).



3. Slide head forward and lift upward to remove
4. Raise upper assembly to provide working room around lower taping head and remove tape from taping head.
5. Lift the lower taping head straight up to remove it from the case sealer bed (**Figure 11-11**).
6. Refer to Manual 2, "Adjustments—Changing Tape Leg Length", for taping head setup.
7. Replace taping heads in the reverse order of disassembly.



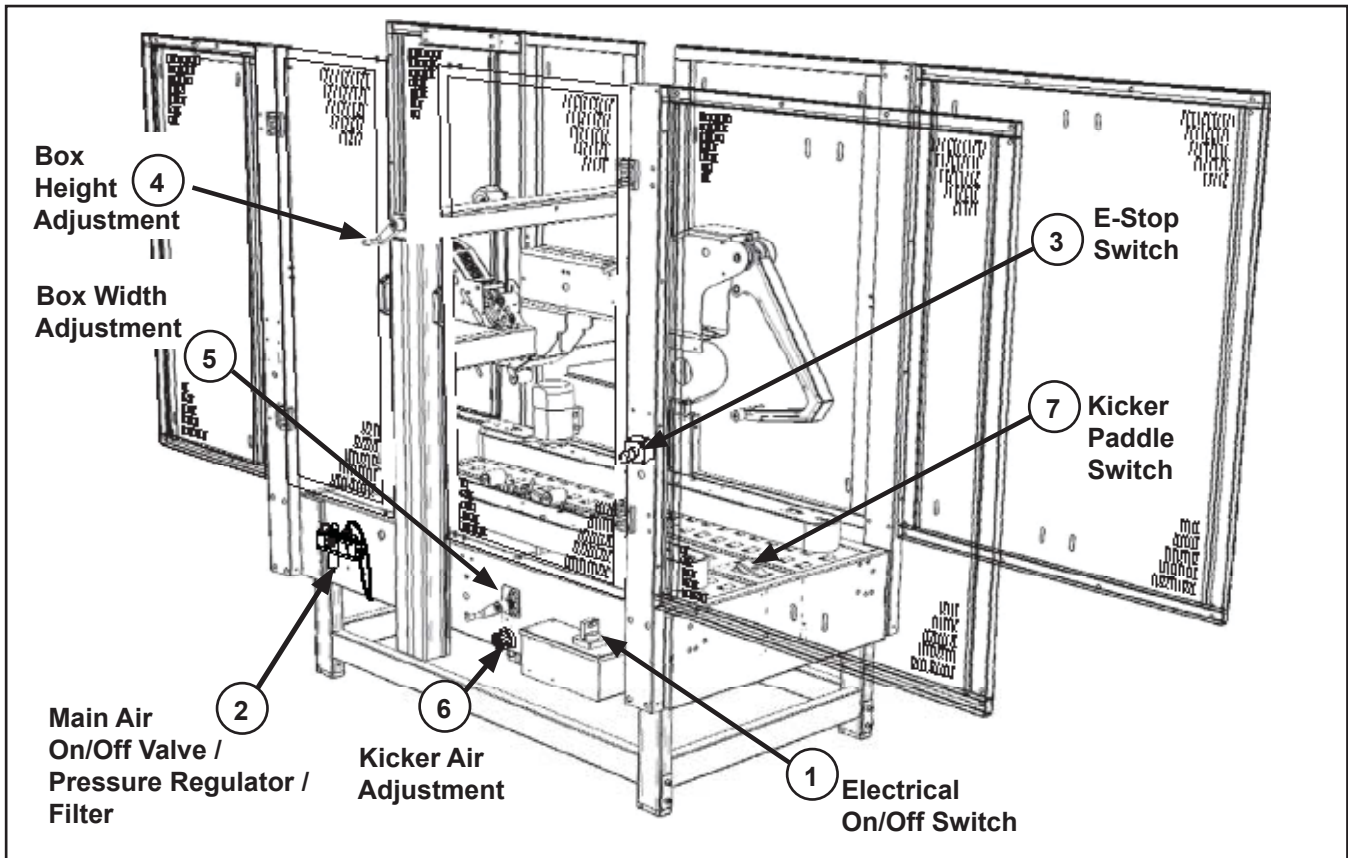


Figure 11-4 – Controls, Valves and Switches

11.5 Controls, Valves, and Switches
(Figure 11-4)

- ① **Electrical "On/Off" Switch**
The box drive belts are turned on and off with the electrical switch on the side of the machine guard at the infeed end.

Note –

The electric system is protected by a ground wire whose continuity has been tested during the final inspection. The system is also subject to insulation and dielectric strength tests.

- ② **Main Air "On/Off" Valve/Pressure Regulator/Filter – Figure 11-5**
This set of pneumatic components controls, regulates and filters plant air supply to the two separate control circuits of the case sealer.

Note – Turning air supply "Off" automatically bleeds air pressure from the case sealer air circuits.

Always turn the air "Off" when machine is not in use, when servicing the machine, or when connecting or disconnecting air supply line.

Note – The air valve has provisions for lockout/tagout according to plant regulations.

Pressure Regulator regulates main air pressure to the machine to adjust pressure, pull knob up and turn – push down to lock setting.

Filter removes dirt and moisture from plant air before it enters the case sealer pneumatic circuits. If water collects in bottom of bowl, lift up on the valve on the bottom of bowl to drain.

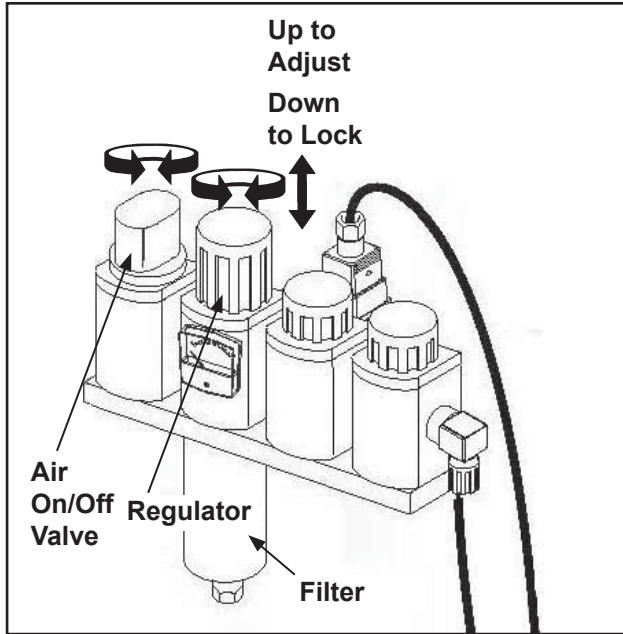


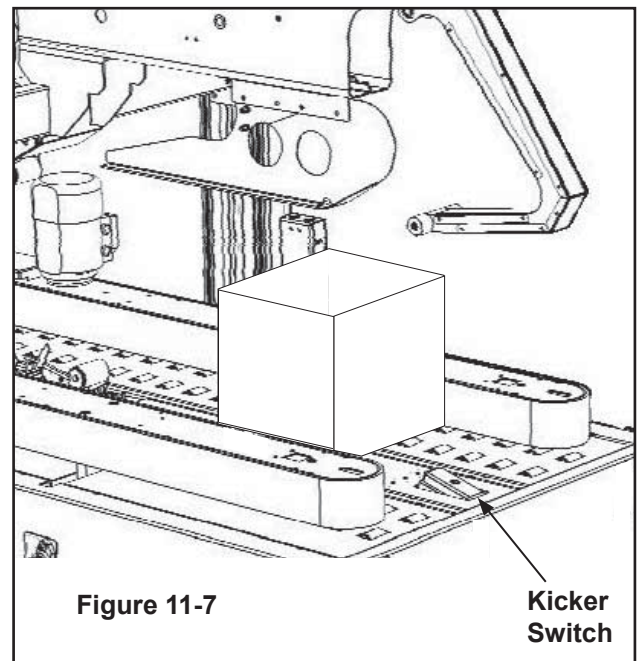
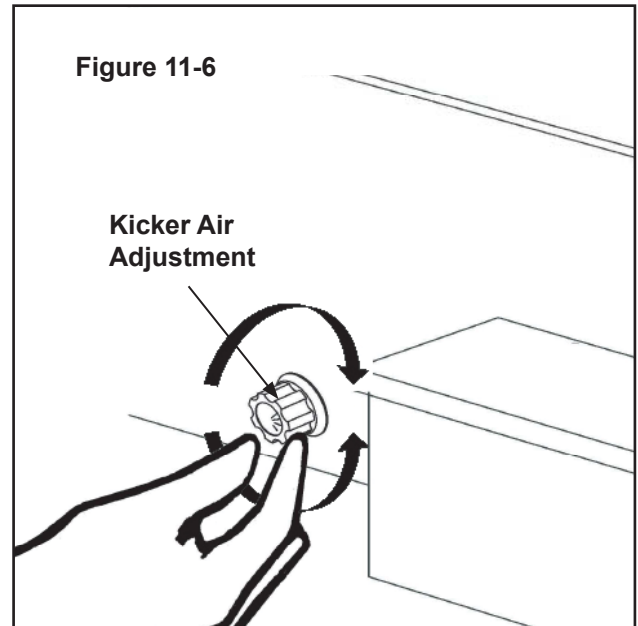
Figure 11-5 – "On/Off" Valve/Regulator/Filter

- ③ **Emergency "Stop" Switch**
The two emergency "Stop" switches are mounted for operator convenience, on both sides of the case sealer. Pushing either of these switches will stop the drive motors/belts and exhaust air from the flap kicker.

To restart machine, rotate emergency stop switch (release switch latch) and then restart machine by rotating the Electrical Box on/off switch.

- ④ **Height Adjustment Crank, Upper Taping Head**
Raises and lowers upper taping head/flap folders to accommodate box height.
- ⑤ **Width Adjustment Crank**
Adjusts distance between side drive belts to accommodate box width.
- ⑥ **Box Kicker Adjustment**
Fine Tunes the timing/force of the box kicker. **Figure 11-6** (contact your 3M Representative for more information)

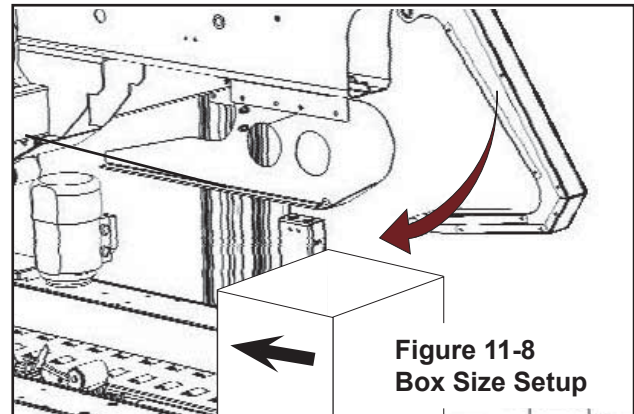
- ⑦ **Kicker Paddle Switch**
Initializes Kicker process. Kicker swings down to push box through Taping heads (**Figure 11-6 and 11-7**).



11.6 Run Boxes to Inspect Adjustment

Figure 11-8

Run several test boxes through the machine, and observe the flap kicking action. Adjust the kicker adjustment knob so the kicker "kicks" earlier or later as required (see figure 11-9). In general, it is better to set the kicker to "kick" early because it contacts the flap higher above the score-line which results in more reliable flap folding.



CAUTION

- **To reduce the risk associated with pinch hazards:**
 - Keep hands clear of the upper head support assembly as boxes are transported through the machine.
 - Keep hands, hair, loose clothing, and jewelry away from box compression rollers.
 - Always feed boxes into the machine by pushing only from the end of the box.
 - Keep hands, hair, loose clothing, and jewelry away from moving belts and taping heads.
 - Keep hands away from drive belts and flap kicker when feeding boxes to the machine.

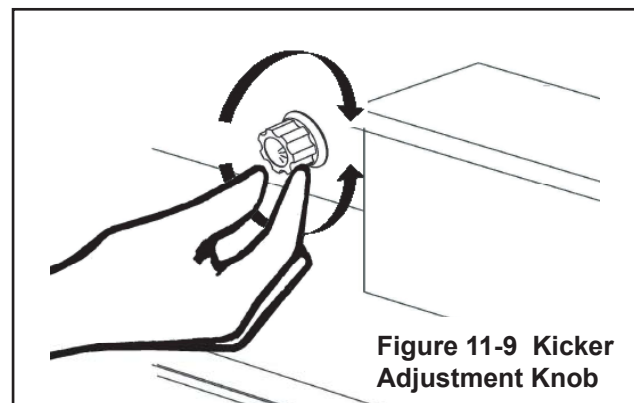
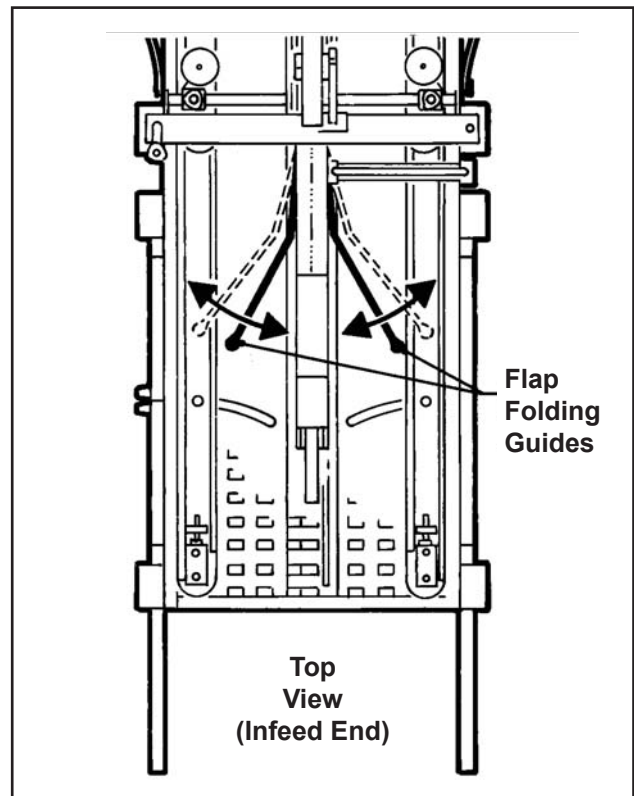


Figure 11-10

The upper side flap folding guides can be adjusted in or out to accommodate the width of the box. For optimum performance, the side flap folding guides should be adjusted to the narrowest position which allows them to catch any side flaps that may be bent outward past vertical.

Note – Box flaps should not be bent outward past vertical more than 15° when entering case sealer.



11 - SET UP AND ADJUSTMENTS (continued)

Important: Before starting the machine, verify that no tools or other objects are on the conveyor bed.

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



CAUTION

- **To reduce the risk associated with pinch hazards:**
 - Keep hands clear of the upper head support assembly as boxes are transported through the machine.
 - Keep hands, hair, loose clothing, and jewelry away from box compression rollers.
 - Always feed boxes into the machine by pushing only from the end of the box.
 - Keep hands, hair, loose clothing, and jewelry away from moving belts and taping heads.

Drive Belt Tension

Belt tension must be adequate to positively move boxes through the machine and belts should run fully on the surface of the pulleys at each end of the frame. The idler pulleys on the infeed end are positioned by tension adjustment screws.

To adjust tension, see **Section 13** Maintenance and Repairs "Maintenance – Drive Belt Replacement/Tension Adjustment".

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

12-OPERATION

12.1 Operator's Correct Working Position and Operational Flow (Figure 12-1).

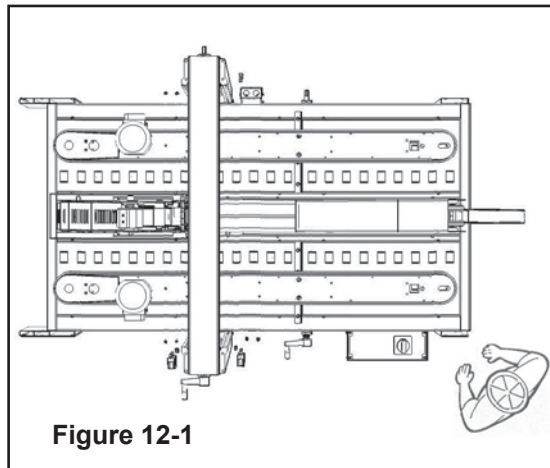


Figure 12-1

Once the box has been filled, push it between the side drive belts. Always keep hands in position (as shown in Figure 12-2).

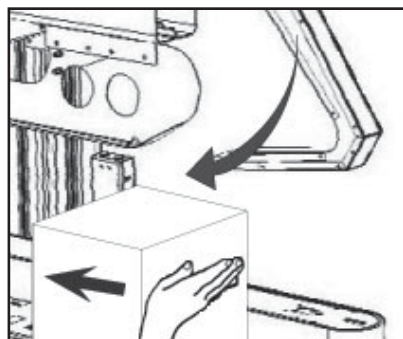


Figure 12-2

The box will be automatically sealed with adhesive tape on the top and bottom box seams. Then the box will be expelled on the exit conveyor.

12.2 Starting the Machine

Important: Before starting the machine, verify that no tools or other objects are on the conveyor bed.

Turn the main rotary switch ON (I) after the EMERGENCY BUTTON is released (Figure 12-3).

12.3 Starting Production

After having adjusted the machine according to the box dimensions (height-width), let the machine run without cartons and check its safety devices. Then start the working cycle.

12.4 Tape Replacement and Threading

Skill 1 - Operator

See Manual 2:

AccuGlide™ 2+ STD 2 Inch Taping Heads.

Press the LATCHING EMERGENCY STOP BUTTON.



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp.

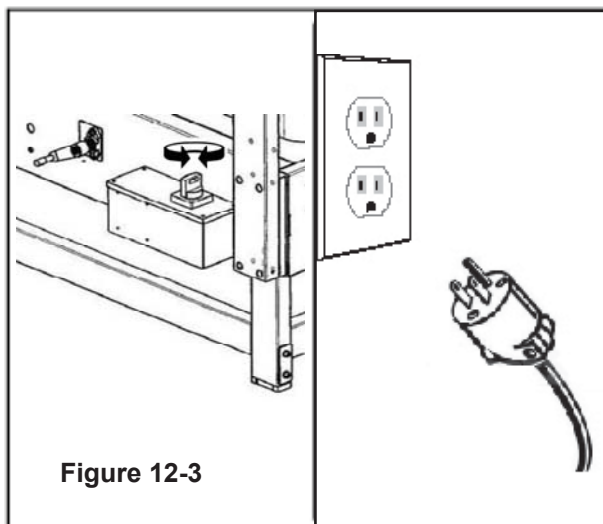


Figure 12-3

12.5 Box Size Adjustment

Repeat all the operations shown in Section 11 - Setup and Adjustments.

12.6 Cleaning

Before carrying out any cleaning or maintenance operation stop the machine by turning the main rotary switch to OFF (0) and disconnect the electric power (Figure 12-3).

12.7 Table of Operation Adjustments - Operator Qualifications

1	Tape loading and threading	1
2	Tape web alignment	1
3	Adjustment of one way tension roller	1
4	Adjustment to box size (H and W)	1
5	Top flap compression rollers	1
6	Adjustment of tape applying spring	1
7	Conveyor bed height adjustment	1
8	Special Adjustment-Changing tape leg length	2
9	Special Adjustment-Column re-positioning	2

12.8 Safety Devices Inspection

- 1 Taping units blade guard
- 2 Latching emergency stop button
- 3 STOP/OFF (0) turn rotary switch on main power

12.9 Troubleshooting Guide

PROBLEM	CAUSE	CORRECTION
Drive belts do not convey boxes	Narrow boxes Worn drive belts or friction rings Top taping head does not apply enough pressure Top flap compression roller too tight Taping head applying spring holder missing Taping head applying spring set too high	Check machine specifications. Boxes are narrower than recommended causing slippage and premature belt wear Replace drive belts or friction rings Adjust the box height adjustment using the crank handle Readjust compression rollers Replace spring holder Reduce spring pressure
Drive belts do not turn	Worn or missing friction rings Drive belt tension too low Electrical disconnect Motor not turning Circuit breaker Motor capacitor Motor fan cover dented	Replace friction rings Adjust belt tension Check power and electrical plug Evaluate and correct
Upper and lower taping head 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 Improper setup causing boxes to jam	Replace belt
Light boxes tip back on exit	Upper head assembly down too far	Carefully adjust upper head assembly
Squeaking noise as boxes pass through machine	Dry compression rollers Dry column bearings Defective column bearings	Lubricate compression rollers Lubricate column bearings Replace column bearings
Flap Kicker kicks at wrong time	Kicker Pressure improperly set	Fine Tune with Kicker Adjusting Knob

Troubleshooting (continued)

Problem	Cause	Correction
Upper drive assembly does not move up or moves up slowly	<p>Lower air pressure</p> <p>Defective head raising valve</p> <p>Worn head raising valve actuator</p> <p>Clogged or damaged exhaust mufflers on the upper ends of the head raising cylinders</p> <p>Defective head power valve</p>	<p>Disconnect the air supply. Make sure main pressure regulator reads zero. Reconnect air supply and adjust regulator to read 5 bar [70 PSIG].</p> <p>Clean or replace head raising valve</p> <p>Replace valve</p> <p>Clean or replace exhaust mufflers</p> <p>Clean or replace the head power valve</p>
Upper taping head does not move down at the end of the taping cycle	<p>Upper drive assembly force adjust regulator set too light</p> <p>Defective top drive assembly force adjust regulator</p> <p>Defective "OR" valve</p> <p>Defective head power valve</p>	<p>Adjust the upper drive assembly force adjust regulator to increase the force against the top of the box. Turn air regulator counterclockwise.</p> <p>Replace regulator</p> <p>Clean or replace valve</p> <p>Clean or replace valve</p>
Upper head assembly comes down too fast or too hard	<p>Upper drive assembly force adjust regulator set too heavy</p> <p>Defective upper drive assembly force adjust regulator</p> <p>Cushion screw misadjusted</p> <p>Cushion screw missing</p>	<p>Adjust upper drive assembly force adjust regulator to decrease force against top of box. Turn regulator clockwise.</p> <p>Replace regulator</p> <p>Adjust cushion screw at base of cylinder</p> <p>Replace screw</p>
Centering drive assemblies move slower than normal	<p>Centering force adjust regulator set too low</p> <p>Centering guide cylinder speed controls not in correct adjustment</p> <p>Defective centering guide power valve</p>	<p>Adjust regulator</p> <p>Adjust speed controls mounted on centering guide cylinder</p> <p>Clean or replace valve</p>

13-MAINTENANCE AND REPAIRS

13.1 Safety Measures (see section 3)

Carrying out maintenance and repairs may imply the necessity to work in dangerous situations. (See **Section 3**)

13.2 Tools and Spare Parts Supplied with the Machine

See Spare Parts Order Section.



WARNING

- **To reduce the risk associated with mechanical and electrical hazards:**
 - Read, understand, and follow all safety and operating instructions before operating or servicing the case sealer.
 - Allow only properly trained and qualified personnel to operate and service this equipment.
- **To reduce the risk associated with pinches, entanglement and hazardous voltage:**
 - Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.

13.3 Recommended Frequency of Inspection and Maintenance Operations

Operation	Frequency	Qualification	Sections
Inspection safety features	daily	1	13.4
Cleaning of machine	weekly	1	13.6
Cleaning of cutter blade	weekly	2	13.7
Oiling of felt pad	weekly	2	13.7
Lubrication	monthly	2	13.8-13.9
Blade replacement	when worn	2	See Manual 2
Drive belt replacement	when worn	2	13.10

13.4 Inspections to be Performed Before and After Every Maintenance Operation

Before every maintenance operation turn the rotary switch to OFF on the main power and disconnect the plug from the control panel. During the maintenance operation only the operator responsible for this duty must work on the machine. At the end of every maintenance operation check the safety devices.

13.5 Check Efficiency of Safety Features

1. Blade guard assembly upper taping head
2. Blade guard assembly lower taping head
3. Emergency stop button with mechanical lock (interrupt supply of electrical power)
4. Turn rotary switch STOP/OFF on main power
5. Drive Belt safety guards

13.6 Cleaning of Machine

Qualification / Skill 1

A weekly cleaning with dry rags or diluted detergents is necessary. Cardboard boxes produce a significant quantity of dust and paper chips when processed or handled in case sealing equipment. If this dust is allowed to build up on machine components, it can cause component wear and overheating of drive motors. The dust buildup is best removed from the machine with a vacuum cleaner. Depending on the number of cartons processed, this cleaning should be done weekly. Excessive buildup that cannot be removed by vacuuming should be removed with a damp cloth.

13.7 Cleaning of Cutter Blade

Qualification / Skill 2

- Should tape adhesive buildup occur, carefully wipe clean with oily cloth or brush. Oil prevents the buildup of tape adhesive (**Figure 13-1**).
- Worn or damaged cutter blades must be replaced promptly in order to guarantee a perfect cut of the tape. Lubricate the felt pad on the blade guard without saturating it.

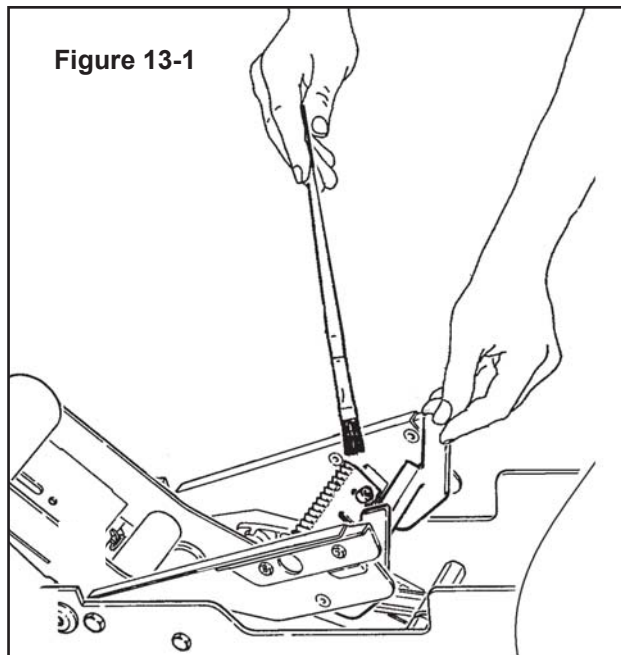


Figure 13-1



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp.

13.8 Lubrication

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

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

13.9 Lubrication Products

- Synthetic Silicone Spray may be used on Lead Screw and Adjustment Handle (**Figure 13-2**).

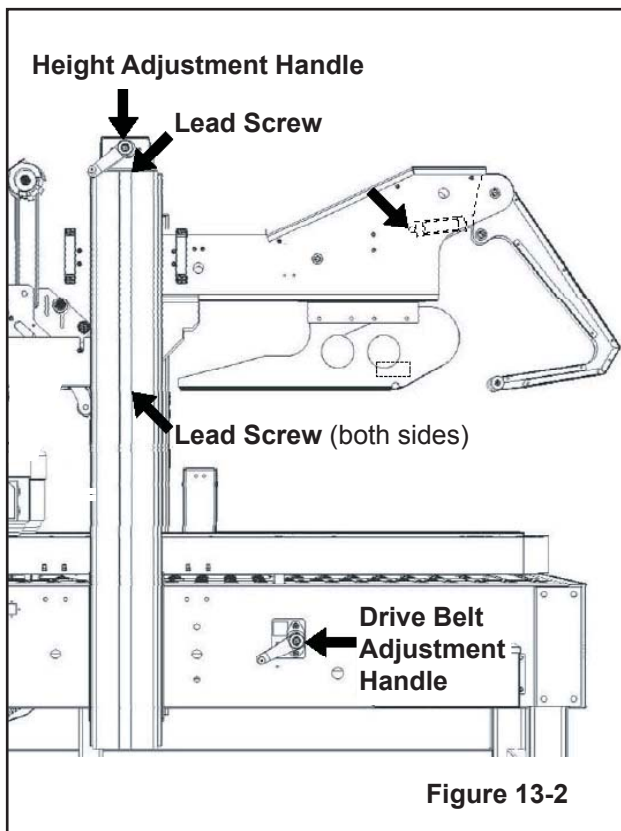


Figure 13-2

 **WARNING**

- **To reduce the risk associated with pinches, entanglement and hazardous voltage:**
 - Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.

Drive Belt Replacement/Tension Adjustment

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

REPLACEMENT
TENSION ADJUSTMENT

(See Figure 13-3)

1. Raise upper taping head to its fully raised position.
2. Disconnect motor plug (A).
3. Remove and retain the six screws (B) and side cover (C).

Note – Keep motor in vertical position to prevent gear oil from leaking out of motor.

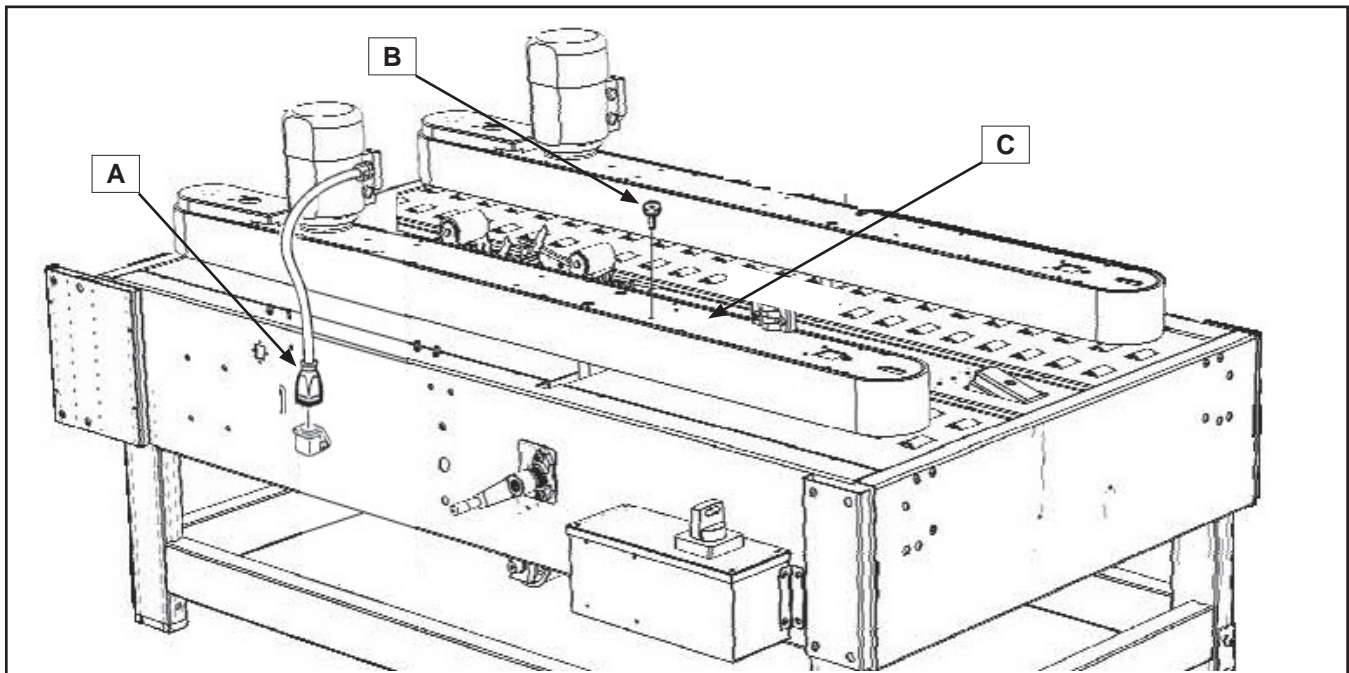


Figure 13-3 – Drive Belt Replacement

(See Figure 13-4)

4. Loosen, but do not remove lock nuts (H) on both the upper and lower belt tension assemblies.
5. Turn belt adjustment screws (J) clockwise to end of adjustment on both upper and lower tension assemblies.
6. Locate belt lacing (joint) by turning belt manually. Remove splicing with pliers. Remove and discard belt.

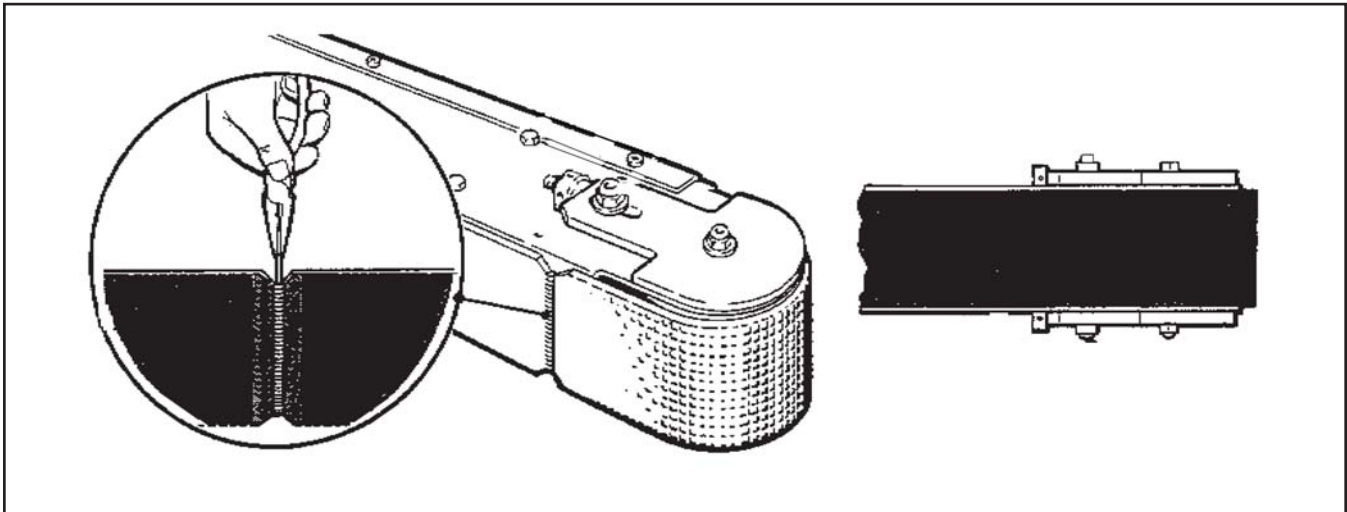


Figure 13-4 – Drive Belt Replacement/Tension Adjustment

7. **Important** – Before installing new drive belt, check belt inside surface for drive direction arrows and install belt accordingly. If no arrows are shown, belt may be installed either way.

Install new belt around drive rollers and insert splicing pin. Pin must not extend beyond edge of belt.

8. Set drive belt tension – turn adjustment screws equally on both upper and lower tension assemblies. Turn screws clockwise to reduce belt tension, counterclockwise to increase tension.

Use force gauge to pull belt outward one inch [25mm] at midspan, as shown in **Figure 13-5**, with a moderate pulling force of 7 lbs. [3.5 kg]. Tighten lock nuts on both tension assemblies to secure tension setting.

9. Assembly is reverse of disassembly.

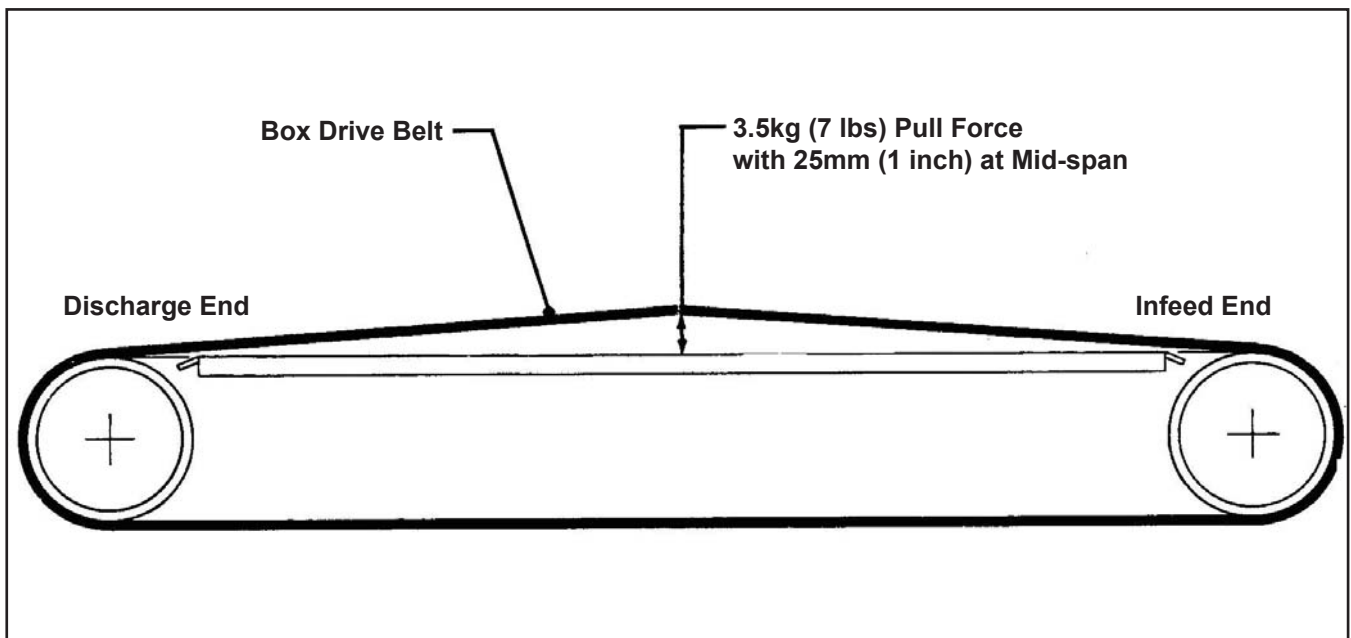
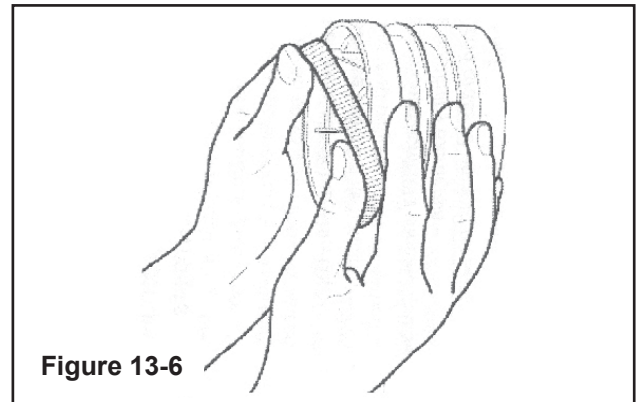


Figure 13-5 – Drive Belt Tension Adjustment (Top View)

13.11 Box Drive Belt Tension and Drive Pulley Rings

Before installing a new belt, check the orange plastic drive pulley rings for wear. If torn, broken, or worn smooth, replace the rings (**Figure 13-6**).



WARNING

- **To reduce the risk associated with mechanical and electrical hazards:**
Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.

Box Drive Belt Tension

The two (2) 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 (for Belt Tension Adjustment - refer to **Section 11 / Setup and Adjustments**). 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 3.5kg [7 lbs.] applied at the mid span, as shown in **Figure 13-5**, will deflect the belt 25mm [1 inch]. This will assure positive contact between the belt and the drive pulley on the discharge end of the drive assembly.

**13-12 – Filter / Circuit Breaker /
Upper Tape Head Leveling - Length - Head**

Air Line Filter – (Figure 13-7)

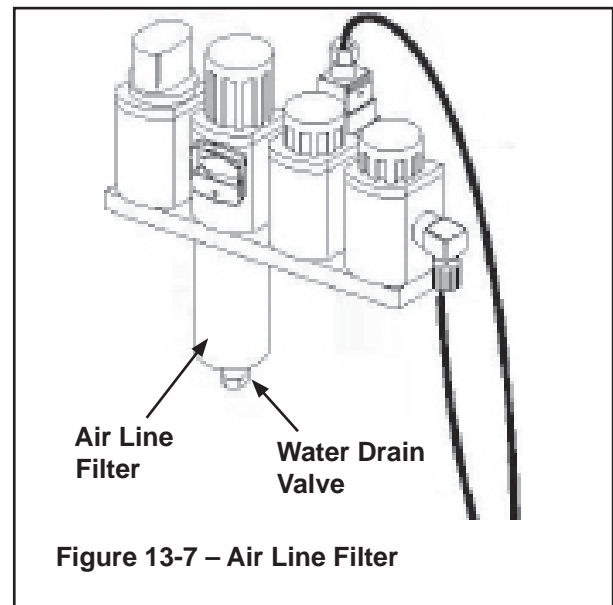
Periodically check the air line filter to drain water and clean as necessary. Do not allow water to go above the filter element.

Circuit Breaker

The case sealer is equipped with a circuit breaker which trips if the motors are overloaded. Located inside the electrical control box on the side of the machine, the circuit breaker has been pre-set 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. Plug in machine. Wait two minutes.
3. Rotate Switch to "On".



 **WARNING**

- **To reduce the risk associated with mechanical and electrical hazards:**
 - Allow only properly trained and qualified personnel to operate and service this equipment.

Upper Taping Head Leveling

If the upper taping head is not horizontal, it can be leveled by adjusting the self-locking nut.

1. Loosen the five bolts on each side of crossbar shown in **Figure 13-8A**.
2. Take measurement from exit end of upper head assembly and front of flap folding ski to machine bed, as shown in **Figure 13-8**. Upper assembly must be level $\pm 1.5\text{mm}$ [$\pm 1/16$ inch].
3. Retighten five bolts on each side of crossbar to secure adjustment.

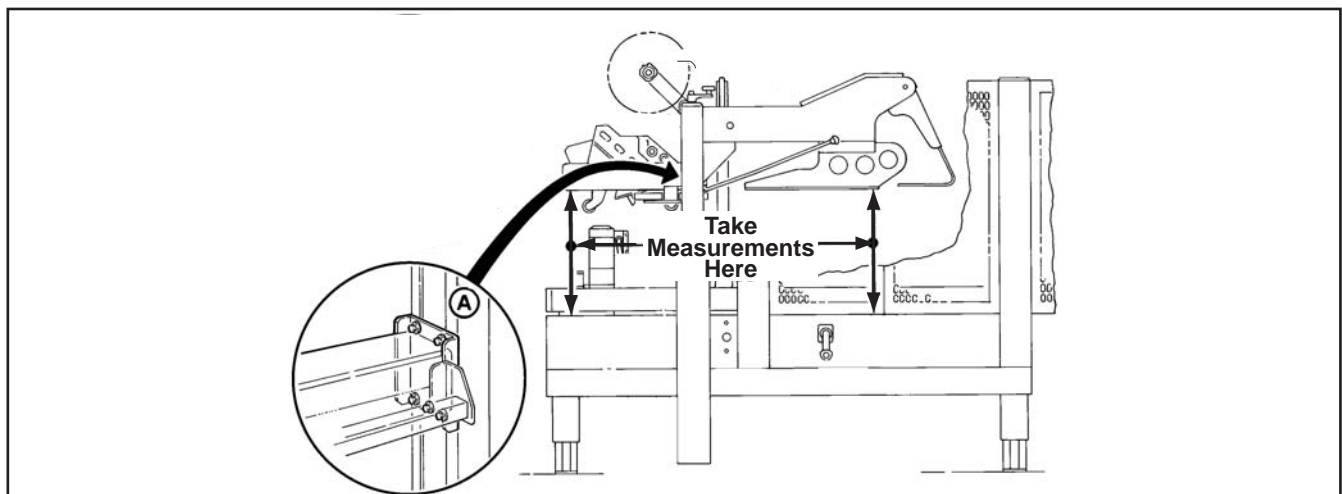


Figure 13-8 – Upper Taping Head Leveling

13-MAINTENANCE AND REPAIRS (continued)

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

The following changes to the case sealer frame and upper/lower taping heads will allow the taping of boxes 95mm [3-3/4 inch] minimum height with box widths greater than 195mm [7-3/4 inch].

Case Sealer Frame

Crank upper taping head frame up high enough to allow clearance for removal of lower taping head.

Taping Heads



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp.

1. Remove tape rolls from both upper and lower taping heads.
2. Loosen, but do not remove, the two retaining screws that secure the upper taping head. See **Figure 13-9A**. Slide the head forward and lift straight up to remove it from case sealer.
3. Lift the lower taping head, shown in **Figure 13-9B**, straight up to remove it from the machine bed.
4. Refer to Manual 2, Adjustments – Changing Tape Leg Length" for taping head Setup.
5. Replace taping heads in case sealer, reverse of disassembly.

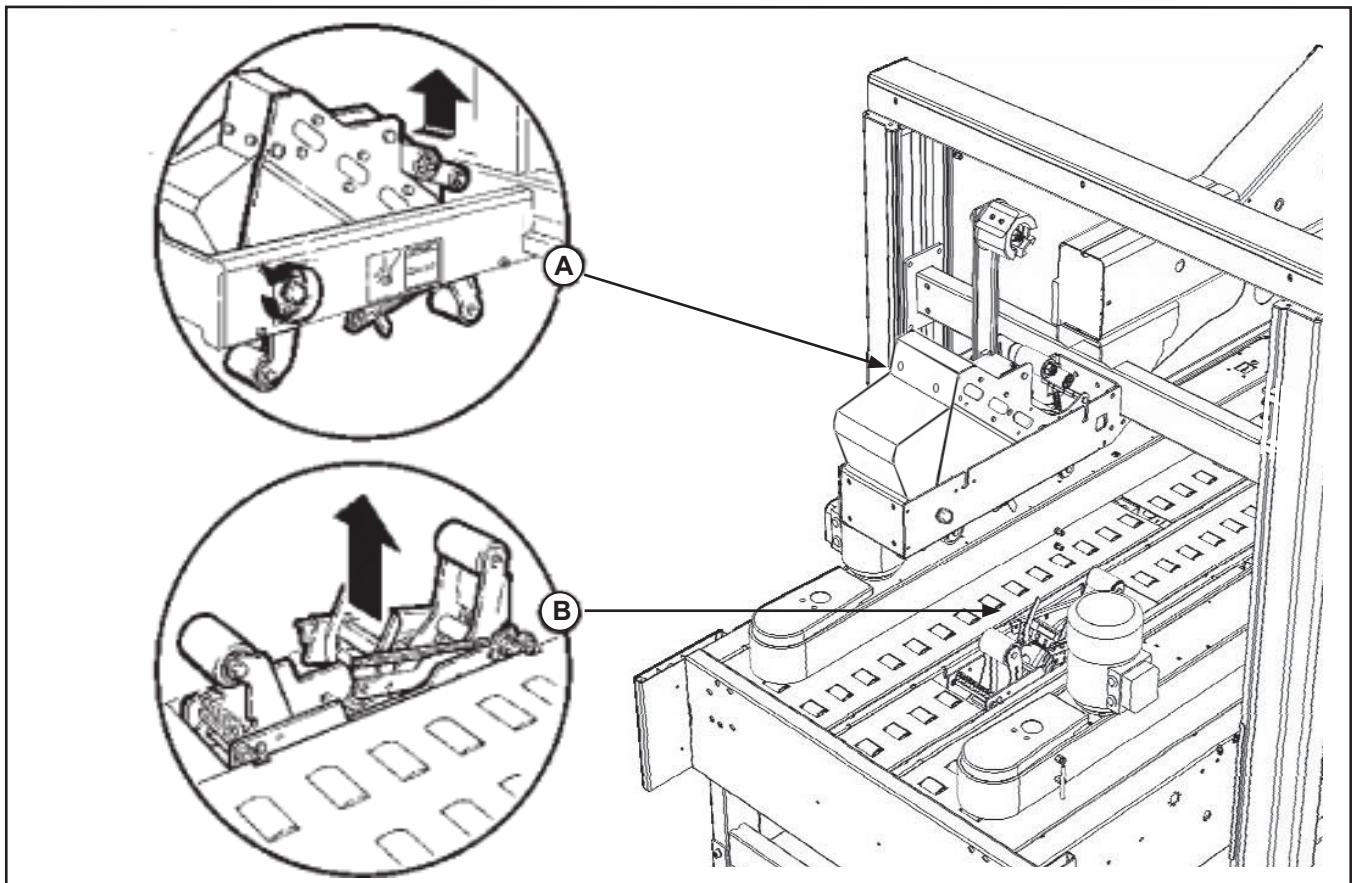


Figure 13-9 – Removing Taping Heads from Case Sealer

14.1 Information for Disposal of Machine

The machine is composed of the following materials:

- Steel structure
- Nylon rollers
- Drive belts in PVC
- Nylon pulleys

For machine disposal, follow the regulations published in each country.

14.2 Emergency Procedures

In case of danger/fire:
 Disconnect plug of power cable from power supply.
(Figure 14-1)

IN CASE OF FIRE

Use a fire extinguisher containing CO2 **(Figure 14-2)**.

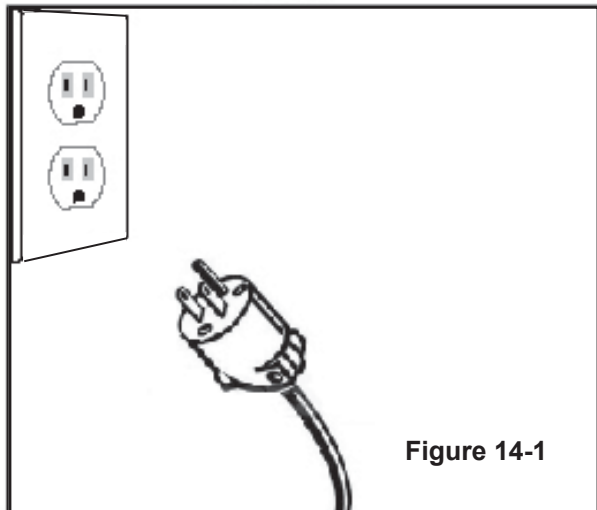


Figure 14-1

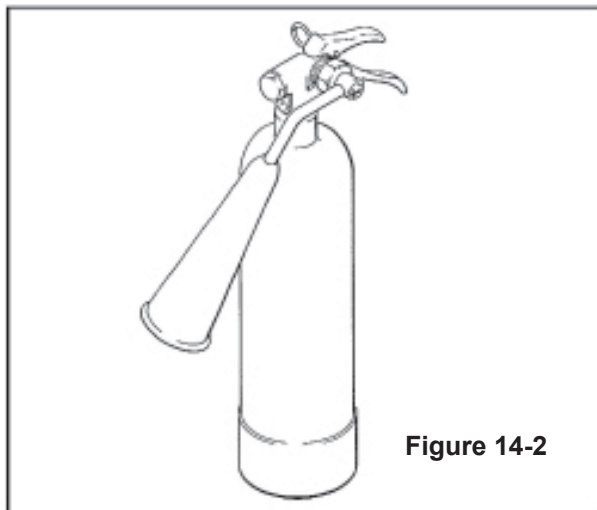


Figure 14-2

15.1 Statement of Conformity

See Section 1.1.

15.2 Emission of Hazardous Substances

Nothing to report

15.3 List of Safety Features

List of components/assemblies with safety functions

- EMERGENCY STOP BUTTON WITH MECHANICAL LOCK
- Thermal cut-out relay
- Fixed guards upper drive belts
- Blade guard assemblies on both taping heads
- **Important:** Install earth wire protection on electrical installation.

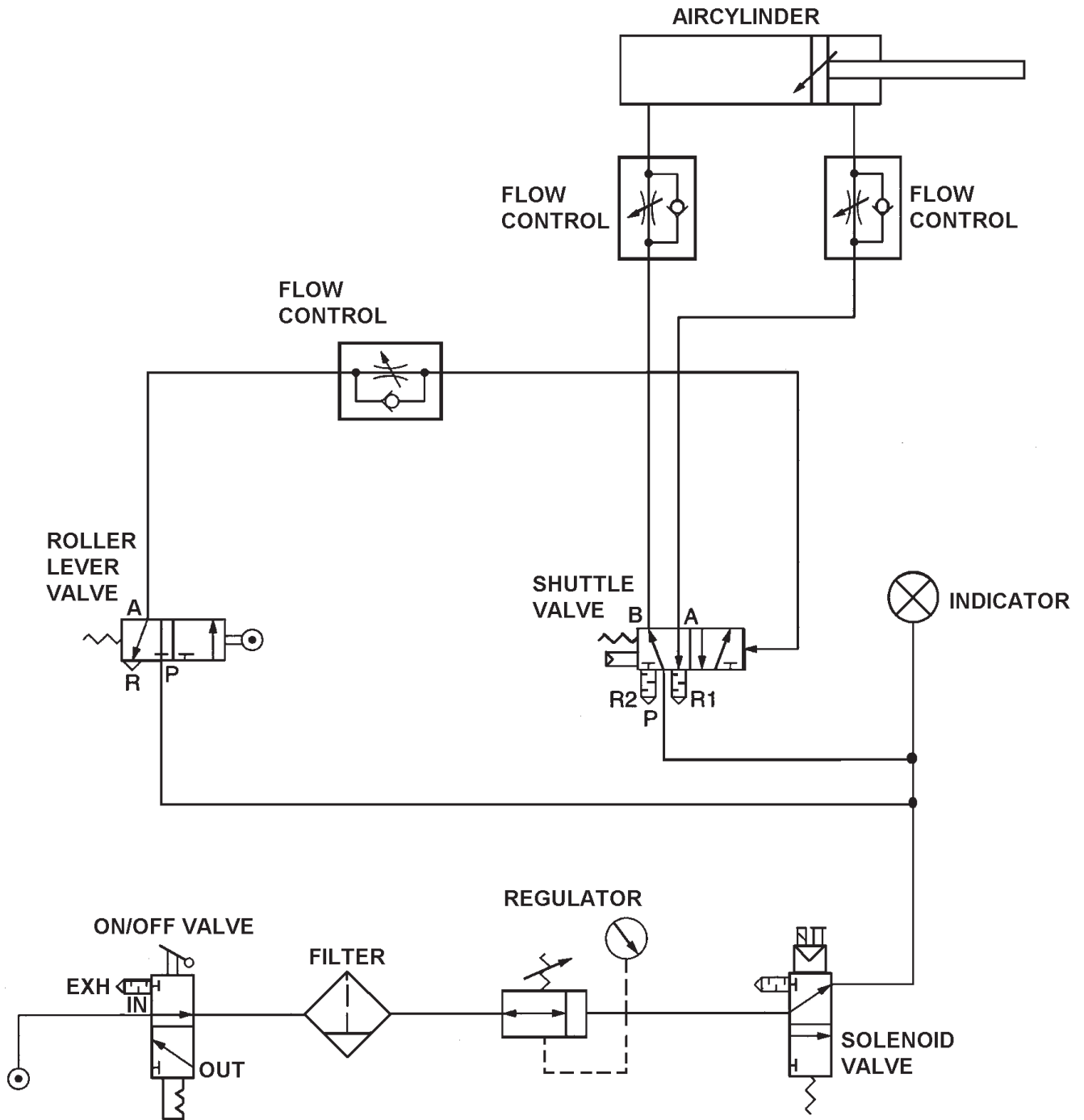
All safety features/components must be explained and highlighted to all operators and to the person responsible for spare parts in order to ensure that these components are always on hand or ordered as a priority procedure.

ONLY USE ORIGINAL REPLACEMENT PARTS

15.4 Copies of Test Reports, Certifications (etc.) Required by User

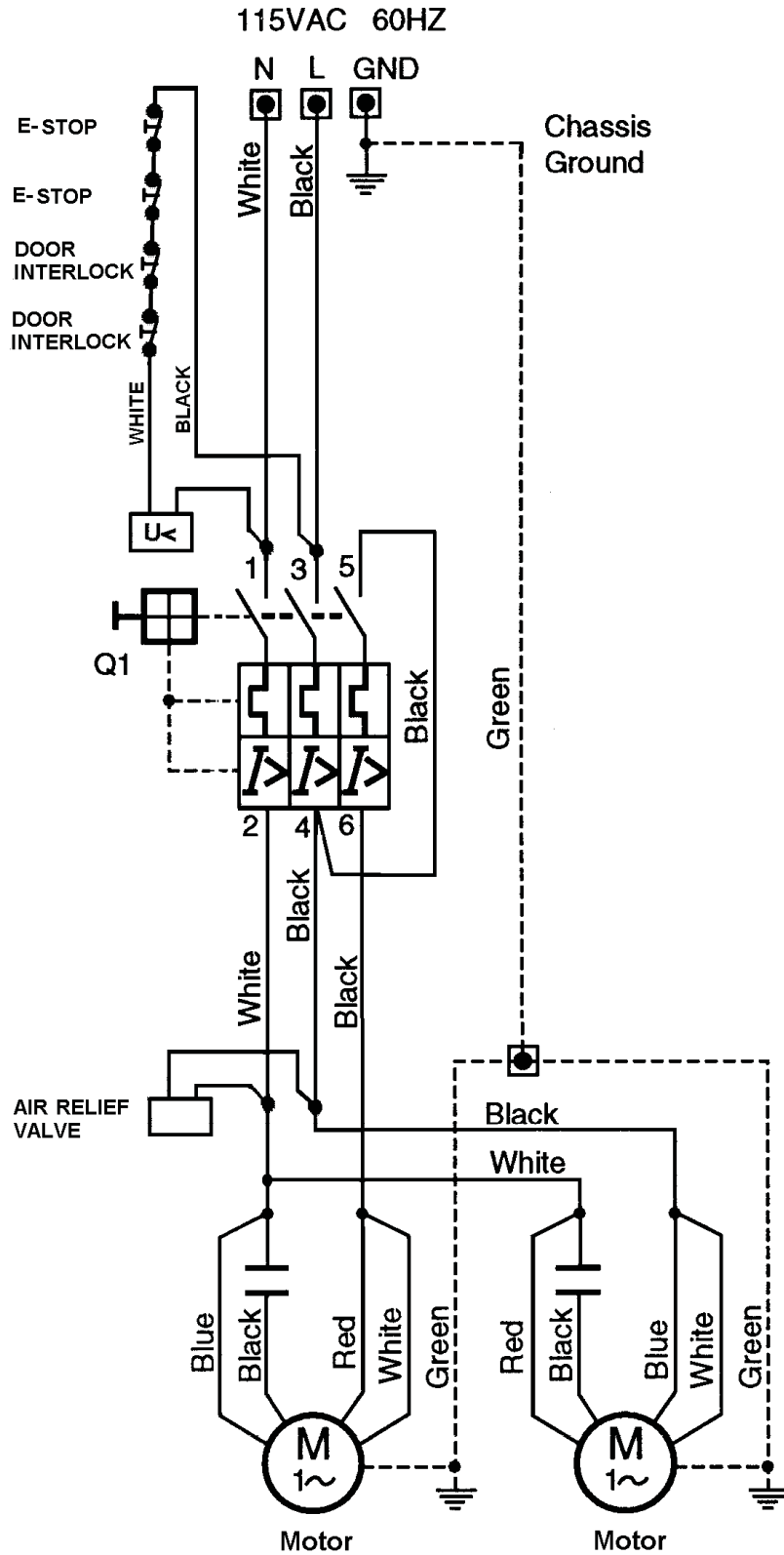
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16.1 Pneumatic Diagram



16.1 Electric Diagram

1 Phase



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16.2 Spare Parts Order

Replacement Parts Ordering Information and Service

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

Order parts by quoting the following information:

(Refer to the Identification Plate on the Machine)

- MACHINE MODEL
- SERIAL NUMBER
- FIGURE NO.
- POSITION
- 3M PART NO. (11 DIGITS)
- DESCRIPTION
- QUANTITY

Refer to Manual 2 for recommended taping head spare parts.

Important:

The machine is constantly revised and improved by our designers. The spare parts catalogue is also periodically updated. It is very important that all the orders of spare parts make reference to the serial number of the machine (located on the identification plate on the machine).

The manufacturer reserves the right to modify the machine at any time without notice.

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

a80f

Qty.	3M-Part Number	Description
2	78-8054-8841-4	Belt, Drive with Pin

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.

Labels

In the event that any labels are damaged or destroyed, they must be replaced to ensure operator safety. Refer to **Section 3-Safety**.

a80f Adjustable Case Sealer, Type 11000 Frame Assemblies

To Order Parts:

1. Refer to first illustration, **Frame Assemblies**, 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.

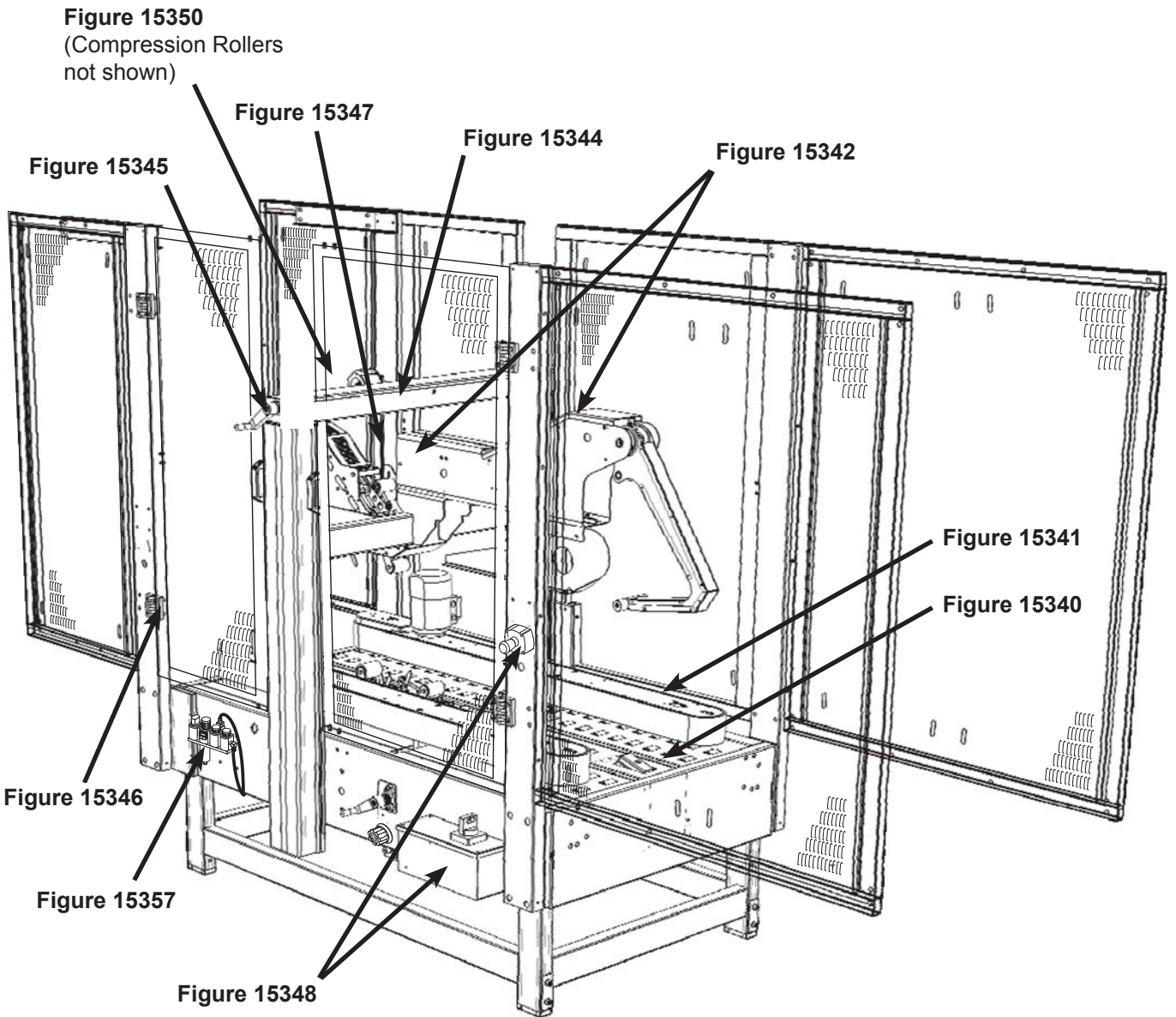
4. Order parts by Part Number, Part Description and Quantity required. Also include the model/machine name, machine type, and serial number that are located on the identification plate.
5. Refer to the first page of this instruction manual “**Replacement Parts and Service Information**” for replacement 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.

Options and Accessories

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

Part Number	Option/Accessory
70-0064-0353-2	AccuGlide™ 2+ STD 2 Inch Upper Taping Head, Type 10500
70-0064-0354-0	AccuGlide™ 2+ STD 2 Inch Lower Taping Head, Type 10500
78-8060-8476-6	Tool and Parts Kit
70-0066-5937-2	a80f-if Powered Infeed Conveyor



**Frame
Assemblies**

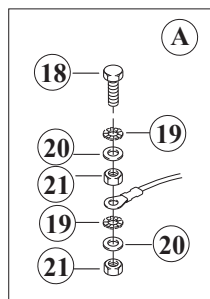
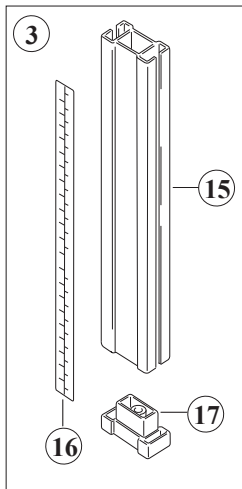
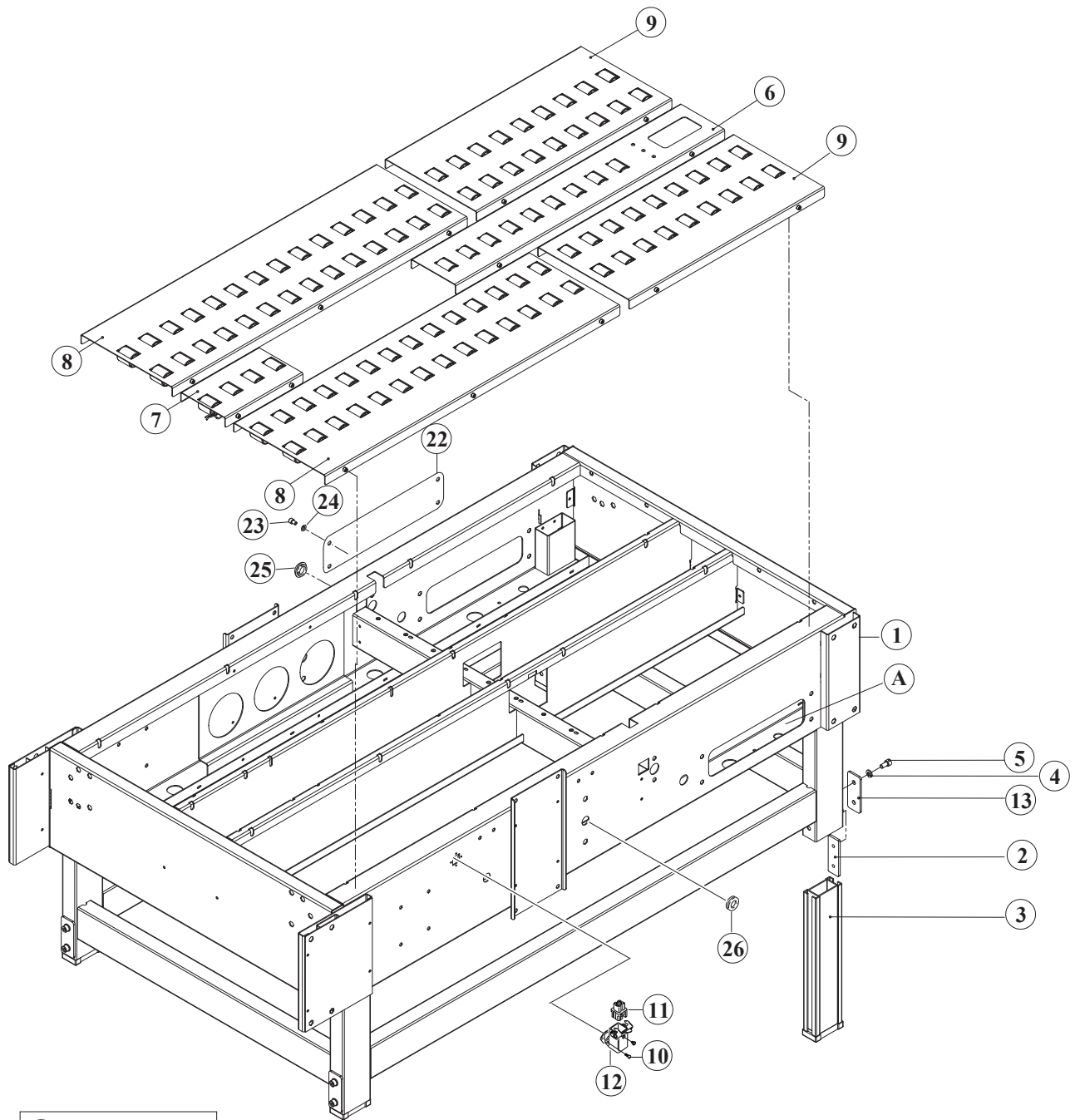


Figure 15340 / 1

a80f

Figure 15340 / 1

Ref. No.	3M Part No.	Description
15340-1	78-8137-4048-3	Bed - Conveyor
15340-2	78-8137-0635-1	Clamp - Leg
15340-3	78-8137-0619-5	Leg Assembly
15340-4	78-8017-9318-9	Washer - Plain Metric 8mm
15340-5	26-1003-7963-0	Screw - Soc. Hd. M8 X 16
15340-6	78-8137-4049-1	Conveyor - Center
15340-7	78-8137-0846-4	Plate w/Rollers Assembly
15340-8	78-8137-4050-9	Conveyor - Lateral
15340-9	78-8137-4051-7	Conveyor - Short Lateral
15340-10	78-8028-8208-0	Screw - 6P X 9,5
15340-11	78-8060-7873-5	Plug - Female
15340-12	78-8060-7876-8	Cover - Plug Lateral
15340-13	78-8129-6100-7	Bracket
15340-15	78-8137-0640-1	Leg Inner
15340-16	78-8137-4053-3	Label - Leg
15340-17	78-8137-0641-9	Pad - Foot
15340-18	78-8060-8488-1	Screw - Hex.Hd. M5 X 20
15340-19	78-8046-8217-3	Washer - Special
15340-20	78-8005-5741-1	Washer - Flat M5
15340-21	78-8010-7417-6	Nut - Metric, Hex Stl. M5
15340-22	78-8137-4054-1	Cover
15340-23	26-1003-7957-2	Screw Soc. Hd. Hex Hd. M6 X 16
15340-24	26-1000-0010-3	Washer - Flat M6

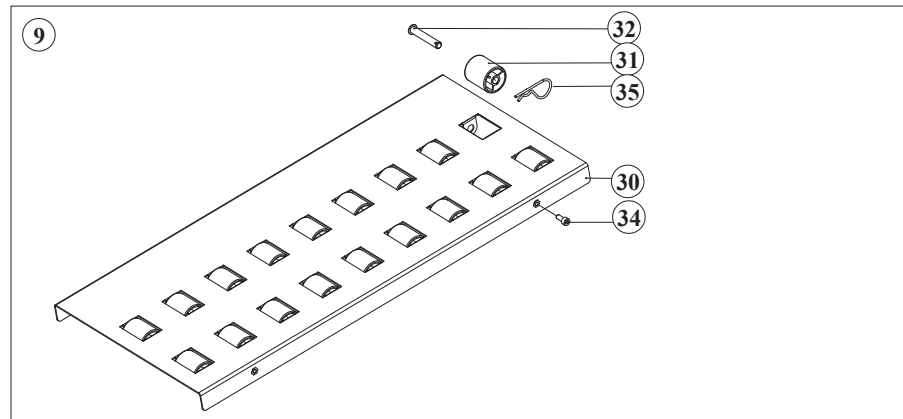
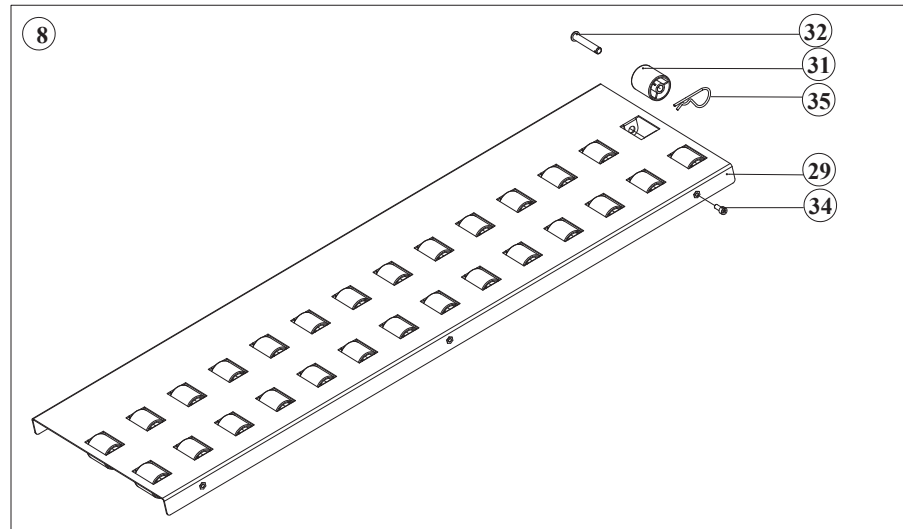
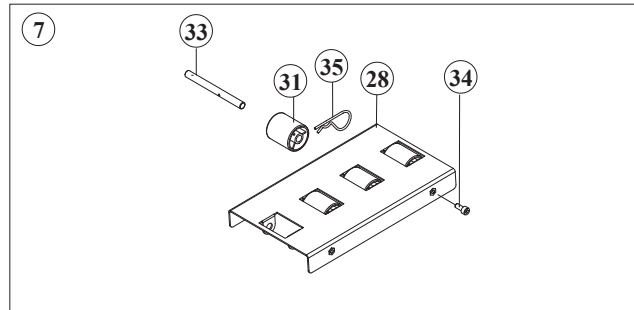
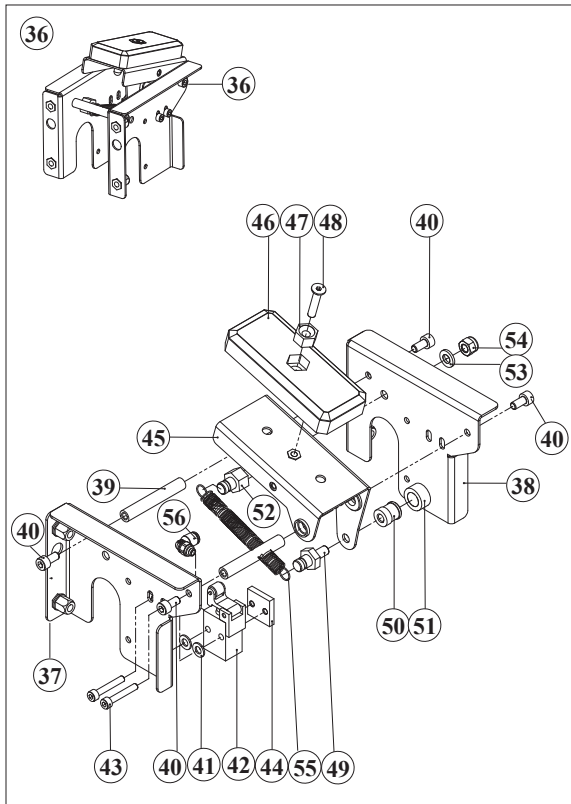
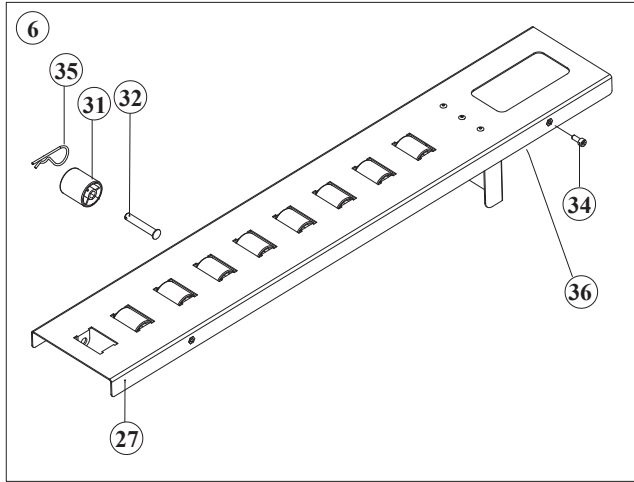


Figure 15340 / 2

Figure 15340 / 2

Ref. No.	3M Part No.	Description
15340-25	78-8076-4536-7	Cap /45 X 1.5
15340-26	78-8060-7758-8	Grommet DG 13,5
15340-27	78-8137-4055-8	Conveyor - Central, Infeed
15340-28	78-8137-0852-2	Central Conveyor
15340-29	78-8137-4056-6	Conveyor - Lateral Exit
15340-30	78-8137-4057-4	Conveyor - Short, Lateral Infeed
15340-31	78-8060-7693-7	Roller 32 X 38
15340-32	78-8076-5384-1	Shaft - Roller
15340-33	78-8137-0853-0	Plate w/Rollers Assembly
15340-34	26-1003-7949-9	Screw Soc. Hd. Hex Soc. M5 X 12
15340-35	78-8137-0735-9	Pin / 1,8
15340-36	78-8137-4058-2	Cam
15340-37	78-8137-0770-6	Valve Support L/H
15340-38	78-8137-0757-3	Valve Support R/H
15340-39	78-8137-0753-2	Hinge
15340-40	26-1003-7948-1	Screw, Soc.Hd Hex Soc.M5 X 10
15340-41	78-8005-5741-1	Washer - Flat, M5
15340-42	26-1005-6358-9	3 Way - 2 Position Valve
15340-43	26-1003-7946-5	Screw - Soc.HD. M4 X 25
15340-44	78-8059-5607-1	Plate - Threaded
15340-45	78-8137-0693-0	Cam
15340-46	78-8137-0825-8	Red Pad - Foot
15340-47	78-8137-0754-0	Holder - Hex. Wrench
15340-48	78-8091-0537-8	Screw - Allen, M5 X 25
15340-49	78-8137-0767-2	Holder - Spring
15340-50	78-8137-0755-7	Hose Connector
15340-51	78-8070-1269-1	Bumper
15340-52	78-8137-0758-1	Holder - Spring
15340-53	26-1000-0010-3	Washer - Flat M6
15340-54	78-8091-0418-1	Nut - Self Locking, M6
15340-55	78-8137-0759-9	Spring
15340-56	78-8057-5732-1	Fitting - Elbow

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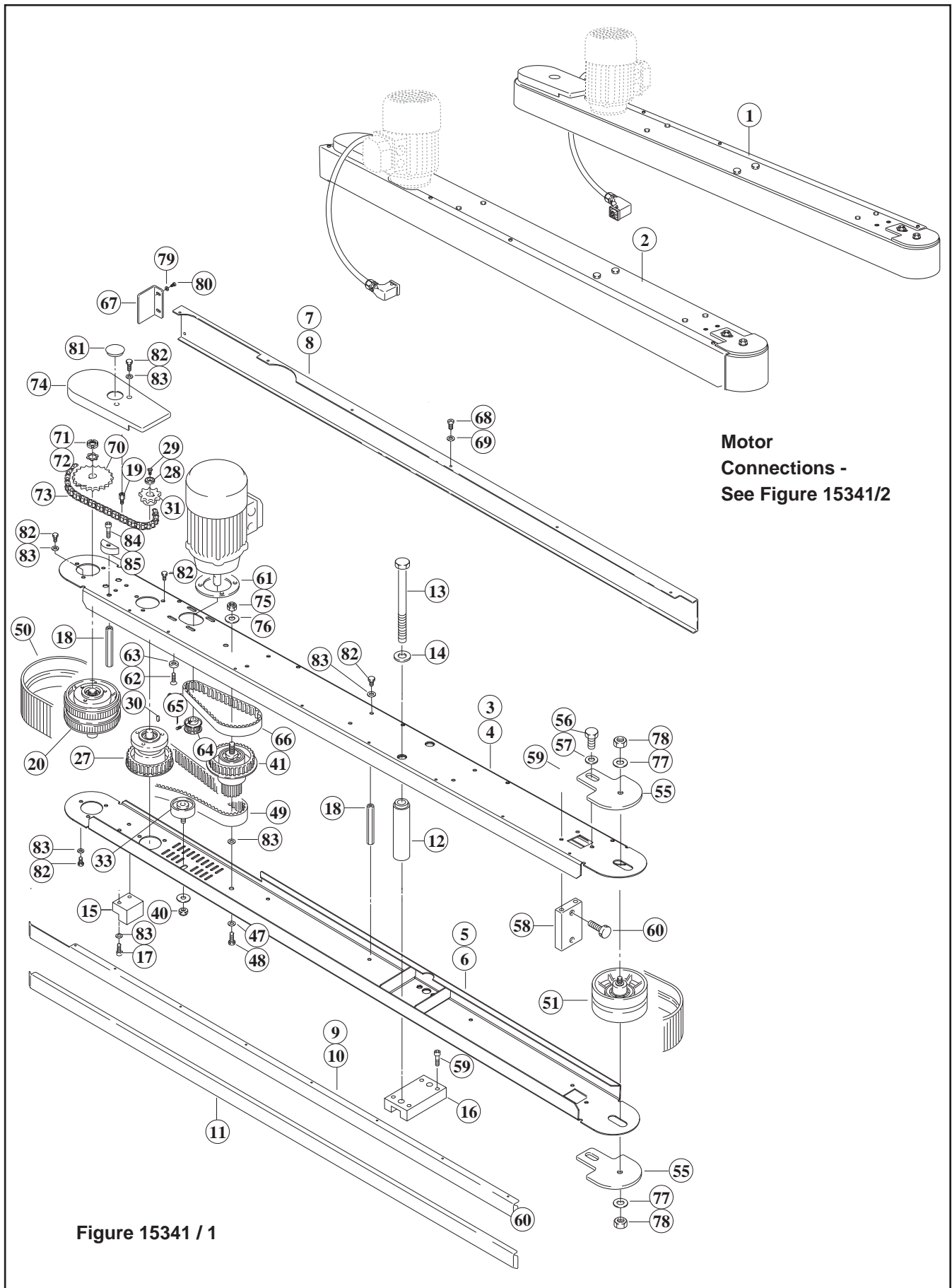


Figure 15341 / 1

Figure 15341 / 1

Ref. No.	3M Part No.	Description
15341-1	78-8137-4059-0	Drive Assy - R/H - w/o Motor
15341-2	78-8137-4060-8	Drive Assy - L/H - w/o Motor
15341-3	78-8137-4061-6	Guide - Upper, R/H
15341-4	78-8137-4062-4	Guide - Upper, L/H
15341-5	78-8137-4063-2	Guide - Lower, R/H
15341-6	78-8137-4064-0	Guide - Lower, L/H
15341-7	78-8137-4065-7	Cover - Drive, R/H
15341-8	78-8137-4066-5	Cover - Drive, L/H
15341-9	78-8137-3791-9	Upper Plate, R/H
15341-10	78-8137-3794-3	Upper Plate, L/H
15341-11	78-8137-3792-7	Lower Plate
15341-12	78-8137-3798-4	Spacer - Drive
15341-13	78-8137-3799-2	Screw - Metric, M10 X 110, Hex Hd.
15341-14	78-8137-3800-8	Washer / 10,5 / 26 X 4
15341-15	78-8137-3797-6	Slide - Drive
15341-16	78-8137-4067-3	Fixing Block
15341-17	26-1003-7960-6	Screw, Soc. Hd M6 X 30
15341-18	78-8054-8910-7	Spacer - Hex
15341-19	78-8054-8891-9	Screw Special
15341-20	78-8137-3776-0	Drive Pulley Assy
15341-21	78-8137-3777-8	Pulley Assy - Drive
15341-22	78-8052-6713-1	Ring - Polyurethane
15341-23	78-8060-7648-1	Flange Assy - Ball Bearing 6002- 2RS
15341-24	78-8046-8135-7	Key - 5 X 5 12mm
15341-25	26-0001-5862-1	Screw, Flat Hd. Soc.M5 X 12
15341-26	78-8054-8877-8	Washer, 5,5/20 X 4
15341-27	78-8137-3778-6	Pulley - Keyed
15341-28	78-8054-8877-8	Washer, 5,5 / 20 X 4
15341-29	26-0001-5862-1	Screw, Flat Hd Soc.M5 X 12
15341-30	78-8028-8244-5	Key - 4 X 4 X 10mm
15341-31	78-8060-8019-4	Sprocket - 3/8" 28 Teeth
15341-32	78-8137-3780-2	Pulley - PD30 L075F
15341-33	78-8060-8006-1	Jockey Pulley Assy
15341-34	78-8060-8009-5	Jockey Pulley
15341-35	78-8060-8007-9	Pi - Jockey Pulley
15341-36	78-8060-8008-7	Bearing 6004-2RS
15341-37	78-8017-9061-5	Snap Ring - for 20mm Shaft
15341-38	78-8060-8010-3	Snap Ring - 42mm Shaft
15341-39	78-8017-9313-0	Nut Self Locking M8 Nick. Pl.
15341-40	26-1004-5507-5	Washer M8
15341-41	78-8060-8011-1	Wrap Pulley Assy
15341-42	78-8076-5106-8	Pulley Assy - Idler
15341-43	78-8023-2410-9	Bearing - 6000-2RS O.D. 26mm
15341-44	78-8023-2544-5	Bearing - 6203-2RS / 17 - 40 - 12
15341-45	78-8054-8887-7	Shaft - Pulley Wrap

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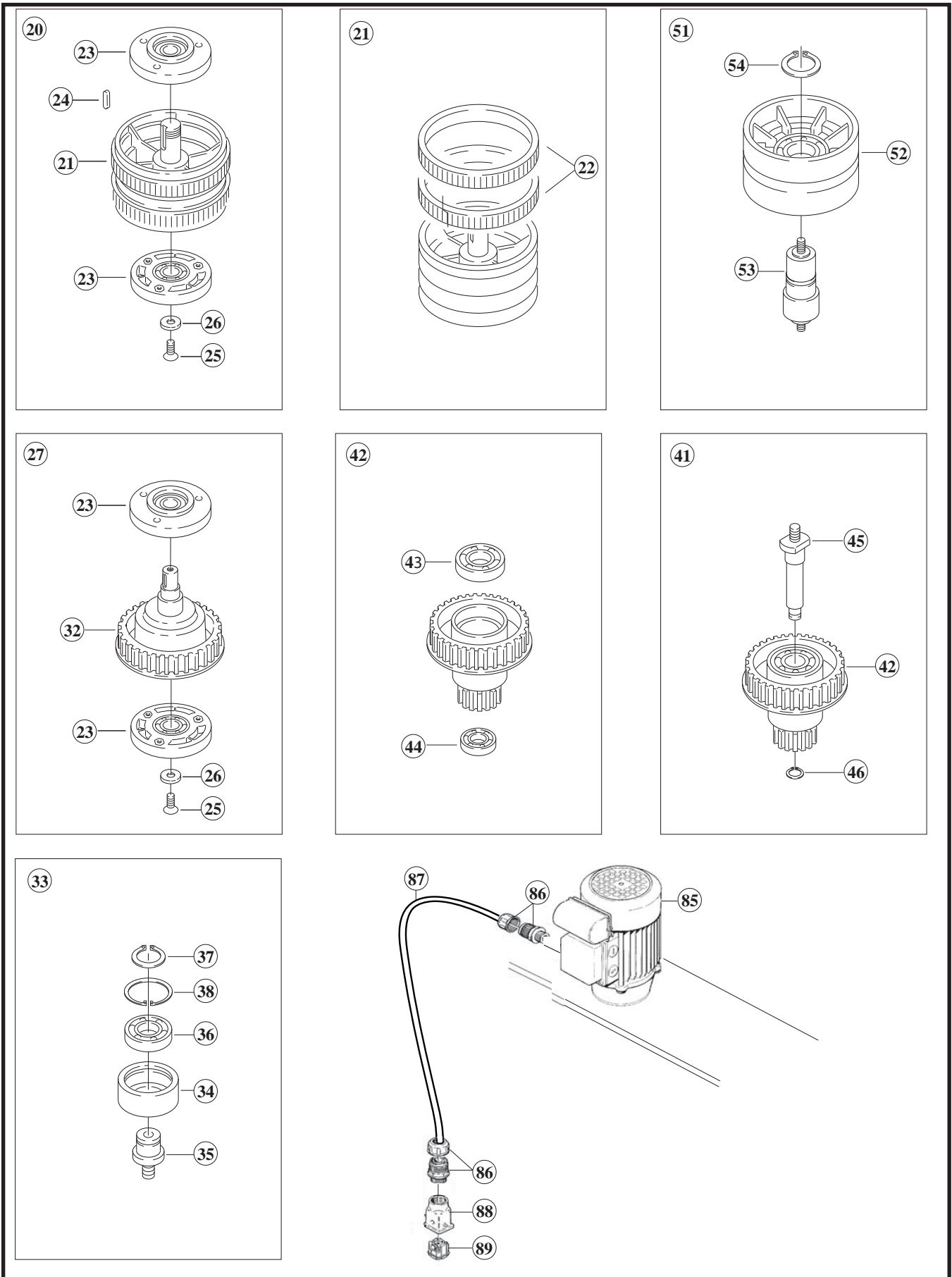


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Ref. No.	3M Part No.	Description
15341-46	78-8016-5855-6	E - Ring 10mm
15341-47	78-8032-0375-7	Screw Metric M6 X 16 Hex. Hd.
15341-48	78-8042-2919-9	Washer - Triple, M6
15341-49	78-8137-3781-0	Belt - Timing 250 L 075
15341-50	78-8054-8841-4	Drive Belt 12AF
15341-51	78-8060-8014-5	Idler Roller Assy
15341-52	78-8052-6710-7	Roller - Idler
15341-53	78-8054-8913-1	Shaft - Roller
15341-54	12-7997-0272-0	E-Ring, M-25
15341-55	78-8137-3782-8	Plate - Belt Adjustment
15341-56	26-1002-4189-7	Screw - Hex. Hd. M10 X 20
15341-57	26-1004-5510-9	Washer- Plain, M10
15341-58	78-8137-3783-6	Block - Drive
15341-59	78-8010-7210-5	Screw - Soc. HD. Hex. Soc. M6 X 20
15341-60	78-8114-4855-0	Screw - Special
15341-61	78-8094-6050-0	Spacer - Motor
15341-62	26-1005-4757-4	Screw - Flat HD, Soc. Dr. M5 X 20
15341-63	78-8060-8073-1	Washer- Motor
15341-64	78-8054-8885-1	Pulley - Timing14 Teeth 60HZ Motor
15341-65	26-1003-8816-9	Screw, Set M5 X 6
15341-66	78-8060-8140-8	Timing Belt 160 X L050
15341-67	78-8137-3786-9	Cover - Drive, Rear
15341-68	26-1002-4955-1	Screw - Self Tap 8P X 13
15341-69	78-8005-5740-3	Washer Plain-Metric 4mm Nick.
15341-70	78-8060-8019-4	Sprocket - 3/8" 28 Teeth
15341-71	78-8057-5835-2	Centering Washer
15341-72	78-8057-5834-5	TAB Washer
15341-73	78-8137-4068-1	Chain P3/8" - L=51
15341-74	78-8076-5112-6	Cover - Chain
15341-75	78-8017-9313-0	Nut Self Locking M8 Nick.PI.
15341-76	26-1004-5507-5	Washer M8
15341-77	78-8017-9318-9	Washer - Plain - Metric 8mm
15341-78	26-1003-6904-5	Nut - Hex, M8
15341-79	78-8005-5741-1	Washer- Flat, M5
15341-80	26-1003-5820-4	Screw - Hex Hd. M5 X 12
15341-81	78-8137-3793-5	Plastic Cap DP-1375
15341-82	78-8010-7169-3	Screw - Metric, M6 X 12, Hex Hd.
15341-83	26-1000-0010-3	Washer - Flat M6
15341-85	78-8094-6473-4	Motor - 100/115V, 50/60HZ, 1-Phase
15341-86	78-8076-4532-6	Cord Grip
15341-87	78-8137-5955-8	Cable - Flex
15341-88	78-8060-7877-6	Plug Housing - Vertical
15341-89	78-8060-7875-0	Plug - Male

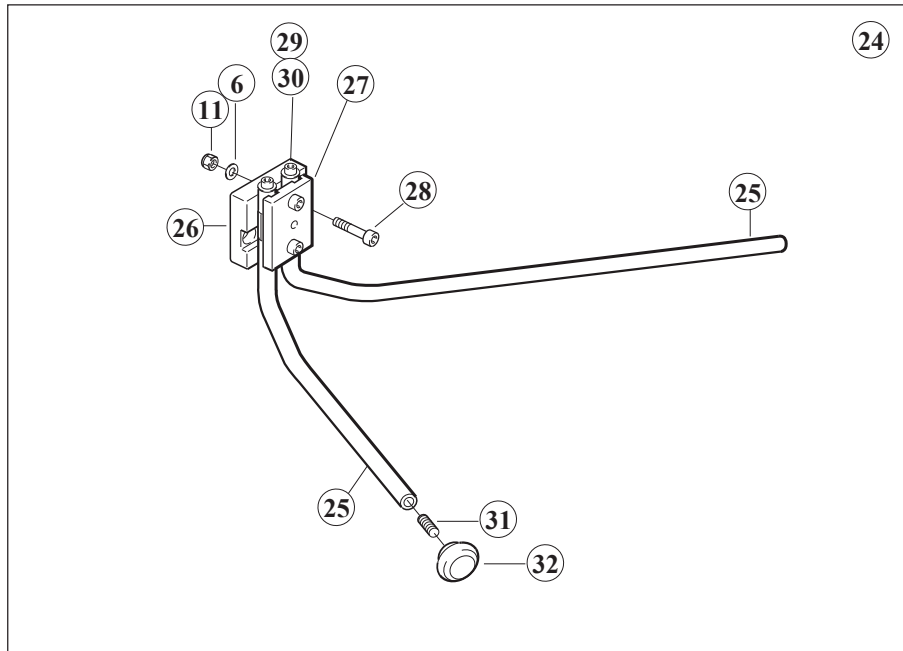
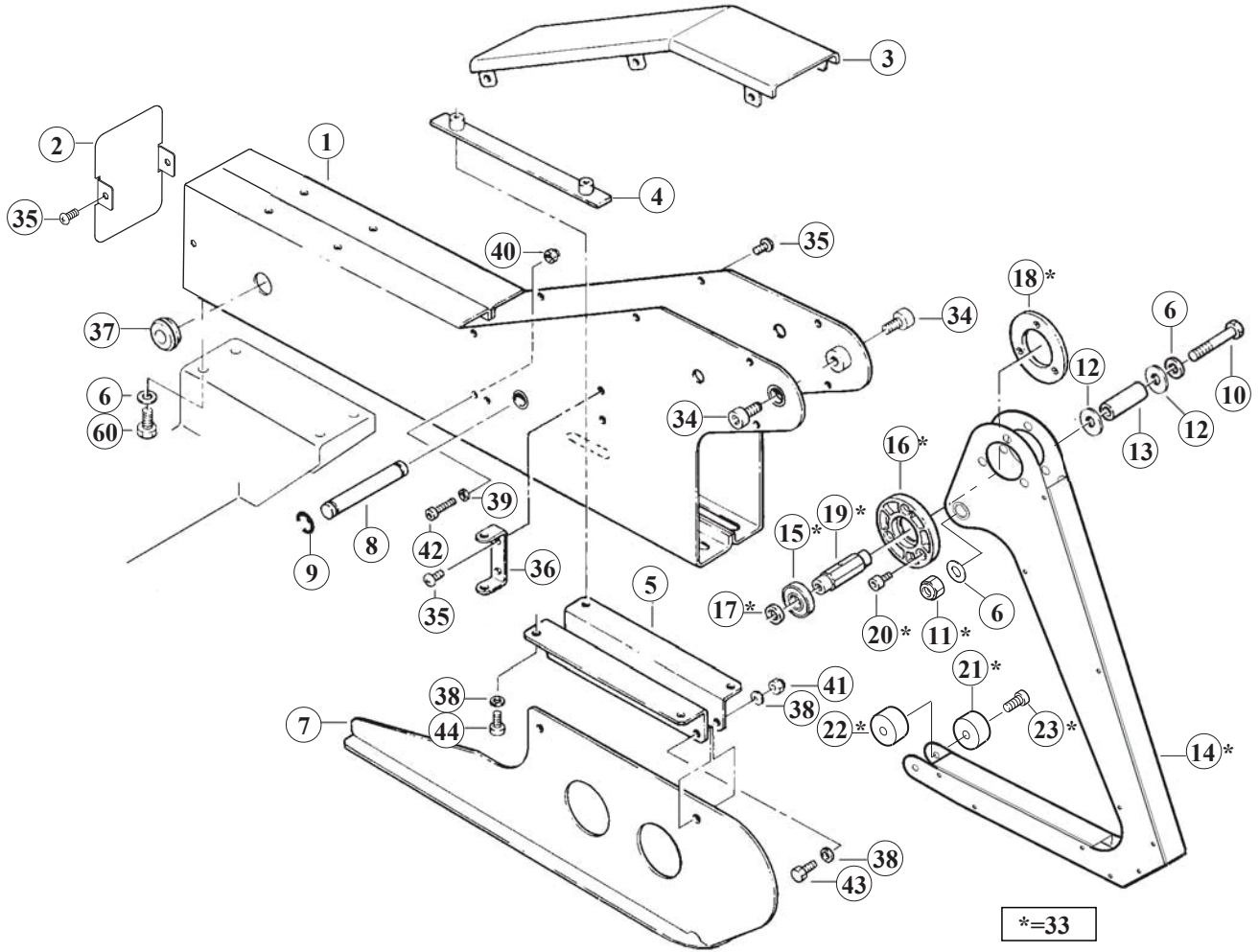


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Figure 15342 / 1

Ref. No.	3M Part No.	Description
15342-1	78-8137-4073-1	Support - Flap Folder
15342-2	78-8137-4074-9	Cover - Rear
15342-3	78-8137-4075-6	Cover - Flap Folder
15342-4	78-8076-4833-8	Strap
15342-5	78-8137-4076-4	Plate- Box Guide
15342-6	78-8017-9318-9	Washer - Plain - Metric 8mm
15342-7	78-8114-4629-9	Flap Folder - Front
15342-8	78-8076-4831-2	Pin - Air Cylinder
15342-9	78-8056-3965-1	Ring - 8 DIN 6799
15342-10	26-1002-5949-3	Screw - Hex. Hd. M8 x 60
15342-11	78-8017-9313-0	Nut - Self Locking M8 Nick. Pl.
15342-12	78-8017-9059-9	Washer - Flat for M12 Screw
15342-13	78-8114-4696-0	Spacer- Cylinder.
15342-14	78-8137-4077-2	Flap Folder
15342-15	26-1000-4350-9	Radial Ball Bearing - 6002-2RS, O.D. 32
15342-16	78-8114-4709-9	Support - Bearing
15342-17	78-8114-4712-3	Spacer- Bearing
15342-18	78-8114-4710-7	Washer - Support
15342-19	78-8114-4711-5	Shaft - Support, Hex.
15342-20	78-8010-7209-7	Screw, Soc. Hd. M6 X 12
15342-21	78-8137-4078-0	Bushing, Side
15342-22	78-8137-4079-8	Bushing, Middle
15342-23	26-1003-7960-6	Screw, Soc.Hd M6 X 30
15342-24	78-8114-4627-3	Side Flap Folder Assy
15342-25	78-8100-1079-9	Side Flap Folder
15342-26	78-8100-1077-3	Block
15342-27	78-8100-1080-7	Plate- Side Flap Folder
15342-28	78-8070-1519-9	Screw - Soc. Hd. Hex. Hd. M8 X 70
15342-29	78-8010-7209-7	Screw - Soc. Hd.M6 X 12
15342-30	78-8042-2919-9	Washer - Triple, M6
15342-31	78-8060-7863-6	Grain M6 X 20
15342-32	78-8076-4546-6	Knob
15342-33	78-8137-4080-6	Flap Folder, Rear
15342-34	26-1003-7964-8	Screw Soc. Hd. Hex Soc. Dr, M8 X 20
15342-35	78-8017-9066-4	Screw - Metric, M5 X 12
15342-36	78-8091-0740-8	Holder - Hex. Wrench
15342-37	78-8060-7785-1	Grommet DG 16
15342-38	26-1000-0010-3	Washer - Flat M6
15342-39	78-8005-5740-3	Washer Plain - Metric 4mm Nick.
15342-40	26-1003-6914-4	Nut, Plastic Insert M4
15342-41	26-1003-6916-9	Nut Locking Plastic Insert M6
15342-42	26-1003-7947-3	Screw Soc. Hd. Hex Soc. M4 X 35
15342-43	78-8032-0375-7	Screw Metric M6 X 16 Hex. Hd.
15342-44	78-8010-7210-5	Screw - Soc. Hd. Hex. Soc. M6 X 20

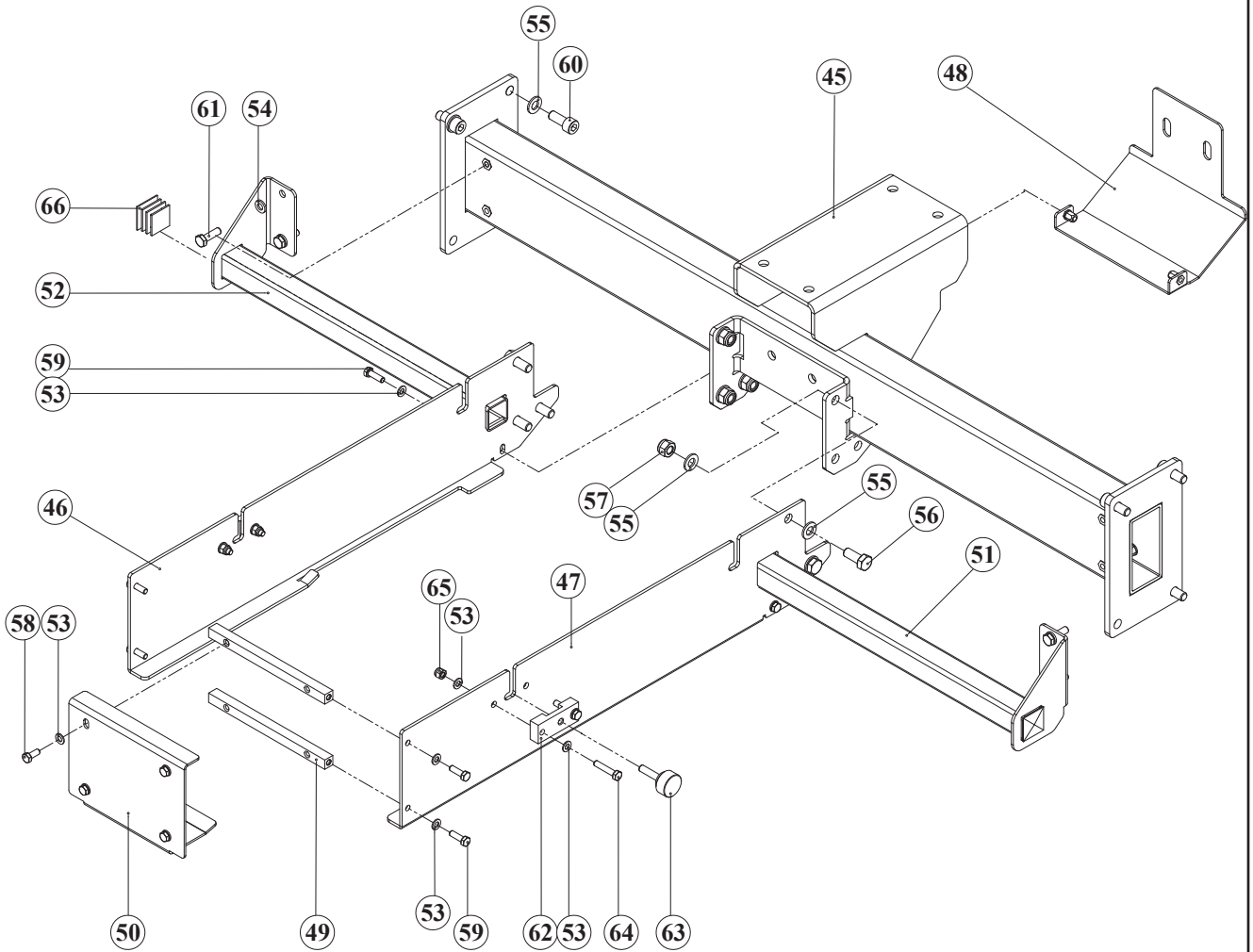
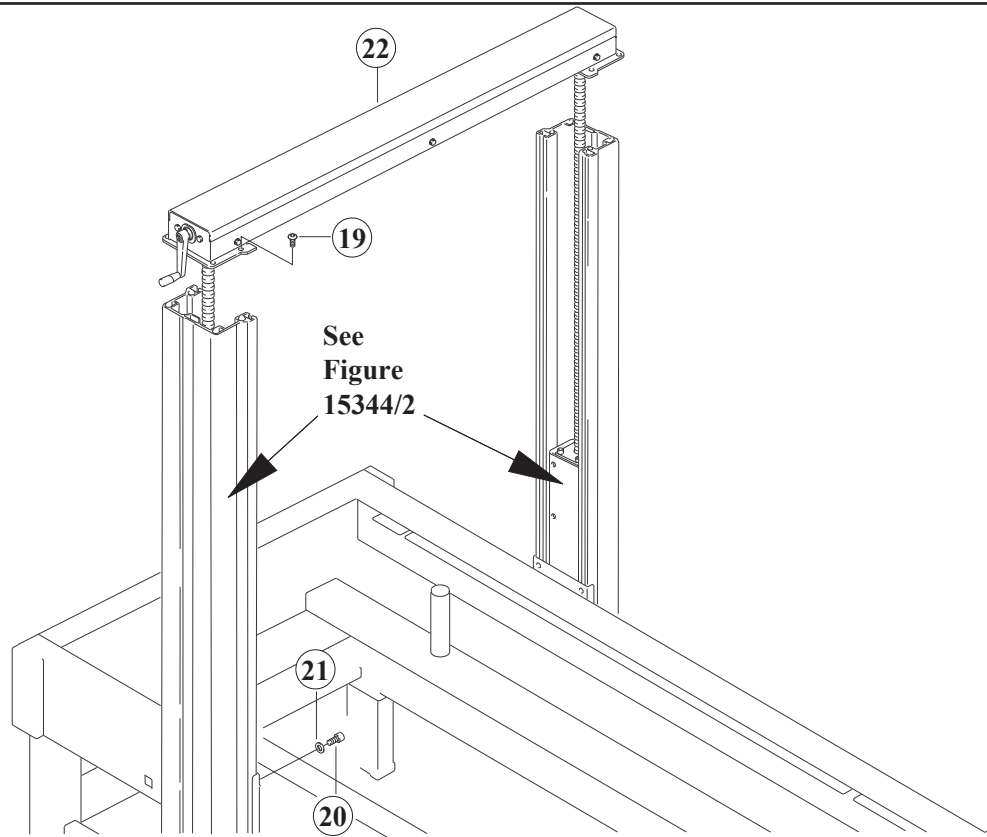


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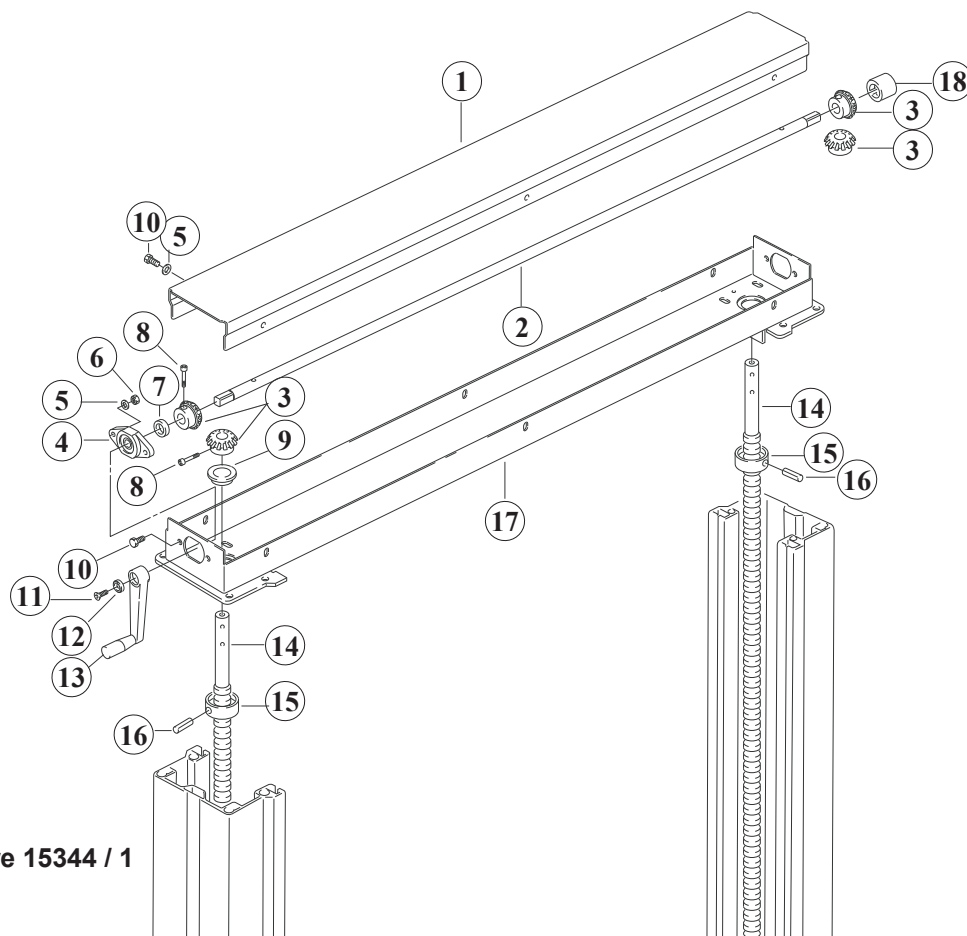
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Ref. No.	3M Part No.	Description
15342-45	78-8137-5921-0	Cross Bar, Flap Folder
15342-46	78-8137-5922-8	Frame - Upper Head, R/H
15342-47	78-8137-5923-6	Frame - Upper Head, L/H
15342-48	78-8137-5925-1	Upper Plate
15342-49	78-8137-5926-9	Spacer
15342-50	78-8137-5927-7	Cover - Upper Frame
15342-51	78-8137-5928-5	Support - L/H Roller
15342-52	78-8137-5929-3	Support - R/H Roller
15342-53	78-8005-5741-1	Washer - Flat M5
15342-54	26-1000-0010-3	Washer - Flat M6
15342-55	78-8017-9318-9	Washer - Plain - Metric 8mm
15342-56	26-1003-5842-8	Screw Hex. Hd. M8 X 20
15342-57	78-8017-9313-0	Nut Self Locking M8 Nick. Pl.
15342-58	26-1003-5820-4	Screw - Hex Hd. M5 X 12
15342-59	26-1002-5820-6	Screw - Hex Hd. M5 X 16
15342-60	26-1003-7964-8	Screw Soc. Hd. Hex Soc. Dr, M8 X 20
15342-61	78-8010-7193-3	Screw - Metric, M6 X 20, Hex. Hd.
15342-62	78-8137-5930-1	Fixing Block
15342-63	78-8137-5931-9	Knob
15342-64	78-8018-7616-6	Screw - Metric, M5 X 25, Hex Hd.
15342-65	26-1005-6859-6	Nut - Self-Locking M5
15342-66	78-8052-6652-1	Cap - End



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Ref. No.	3M Part No.	Description
15344-1	78-8137-5904-6	Cover - Crossbar
15344-2	78-8137-5907-9	Shaft
15344-3	78-8137-5905-3	Sprocket
15344-4	78-8129-6304-5	Support w/Bearing
15344-5	26-1000-0010-3	Washer - Flat M6
15344-6	78-8010-7418-4	Nut - Metric, Hex, Stl., M6
15344-7	78-8129-6308-6	Spacer - Sprocket
15344-8	26-1003-7946-5	Screw - Soc.Hd. M4 X 25
15344-9	78-8060-8125-9	Bushing
15344-10	78-8032-0375-7	Screw Metric M6 X 16 Hex.Hd.
15344-11	26-0001-5862-1	Screw, Flat Hd Soc. M5 X 12
15344-12	78-8060-8073-1	Washer - Motor
15344-13	78-8129-6118-9	Handle
15344-14	78-8137-5906-1	Screw - Leading
15344-15	78-8129-6143-7	Bushing
15344-16	78-8054-8586-5	Pin
15344-17	78-8137-5902-0	Crossbar - Upper
15344-18	78-8070-1506-6	Cover - Screw
15344-19	78-8076-4503-7	Screw - M6 X 12
15344-20	26-1003-7964-8	Screw Soc. Hd. Hex Soc. Dr, M8 X 20
15344-21	78-8017-9318-9	Washer - Plain - Metric 8mm
15344-22	78-8137-5903-8	Crossbar - Upper

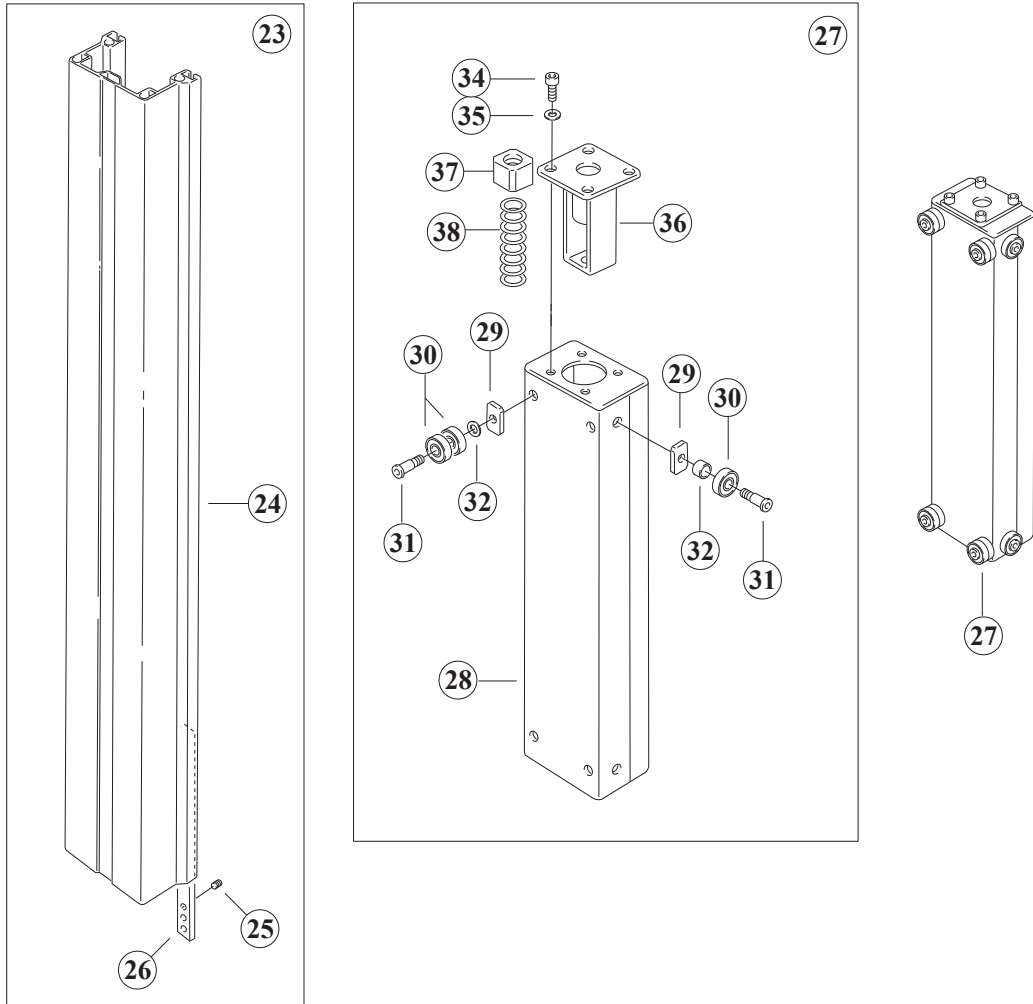


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Ref. No.	3M Part No.	Description
15344-23	78-8137-5944-2	Fixing Plate - Column
15344-24	78-8137-5945-9	Fixed Column
15344-25	78-8060-7889-1	Set Screw M8 X 10
15344-26	78-8137-0895-1	Plate - Column
15344-27	78-8137-5946-7	Column - Inner, Assy
15344-28	78-8137-5947-5	Column - Inner
15344-29	78-8129-6311-0	Plate
15344-30	78-8129-6147-8	Bearing - Ball
15344-31	78-8129-6312-8	Screw - Bearing
15344-32	78-8129-6314-4	Washer - Special, 18/7
15344-33	78-8129-6313-6	Washer - Special
15344-34	26-1003-7963-0	Screw - Soc. Hd. M8 X 16
15344-35	78-8017-9318-9	Washer - Plain - Metric 8mm
15344-36	78-8137-5948-3	Support - Nut
15344-37	78-8129-6125-4	Nut
15344-38	78-8129-6317-7	Spring - Column

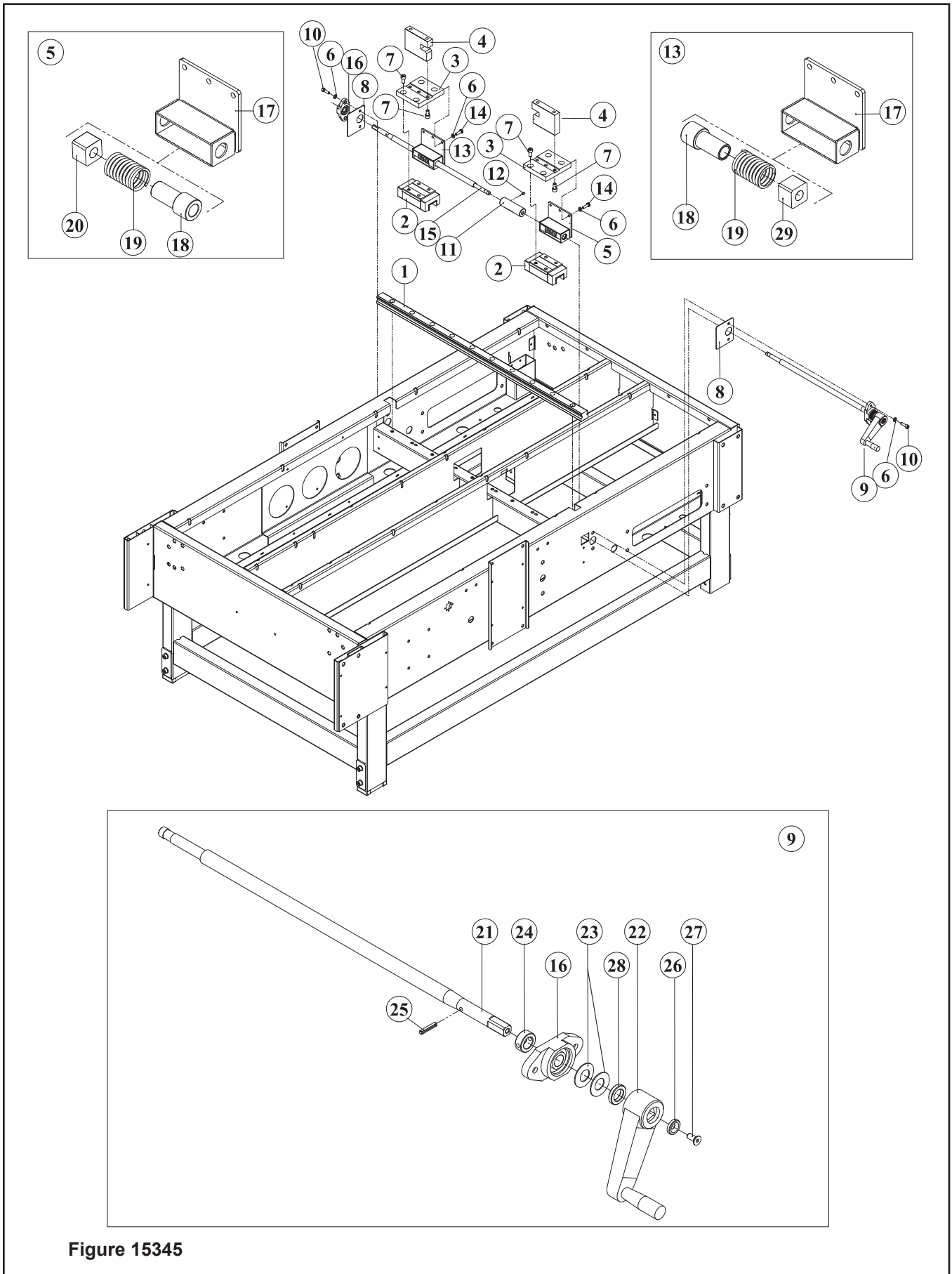


Figure 15345

Figure 15345

Ref. No.	3M Part No.	Description
15345-1	78-8137-5908-7	Guide MRR-30-816-N
15345-2	78-8137-5909-5	Slider
15345-3	78-8137-5910-3	Support Plate - Lower
15345-4	78-8137-5911-1	Support Plate - Upright
15345-5	78-8137-5912-9	Support L/H Assy - Nut
15345-6	26-1000-0010-3	Washer - Flat M6
15345-7	26-1003-7963-0	Screw - Soc. Hd. M8 X 16
15345-8	78-8137-5913-7	Protection Plate - Guide
15345-9	78-8137-5914-5	Adjustment Screw Assy.
15345-10	78-8010-7210-5	Screw - Soc. Hd. Hex. Soc. M6 X 20
15345-11	78-8137-5915-2	Coupling - Screw
15345-12	78-8119-8994-2	Set Screw M5 x 8
15345-13	78-8137-5916-0	Support R/H Assy - Nut
15345-14	78-8010-7193-3	Screw - Metric, M6 X 20, Hex. Hd.
15345-15	78-8137-5917-8	Screw, Centering R/H
15345-16	78-8129-6304-5	Support w/Bearing
15345-17	78-8137-5918-6	Nut Support Assy
15345-18	78-8137-0919-9	Bushing
15345-19	78-8137-5919-4	Spring / 36
15345-20	78-8129-6126-2	Nut
15345-21	78-8137-5920-2	Screw, Centering L/H
15345-22	78-8129-6118-9	Handle
15345-23	78-8060-7984-0	Washer, Belleville
15345-24	78-8129-6113-0	Bushing
15345-25	78-8137-0922-3	Pin, Spring 4 x 20
15345-26	78-8060-8073-1	Washer - Motor
15345-27	26-0001-5862-1	Screw, Flat Hd Soc.M5 X 12
15345-28	78-8119-8844-9	Spacer
15345-29	78-8129-6125-4	Nut

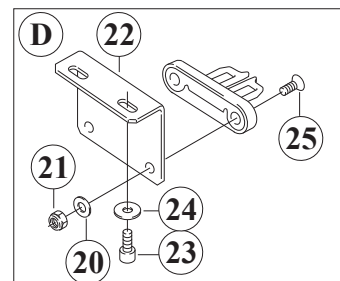
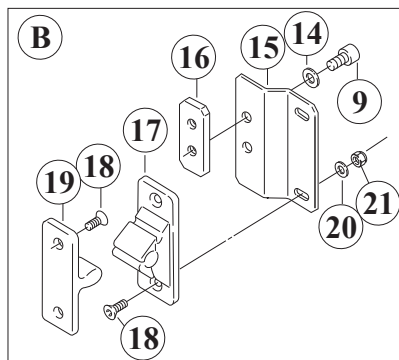
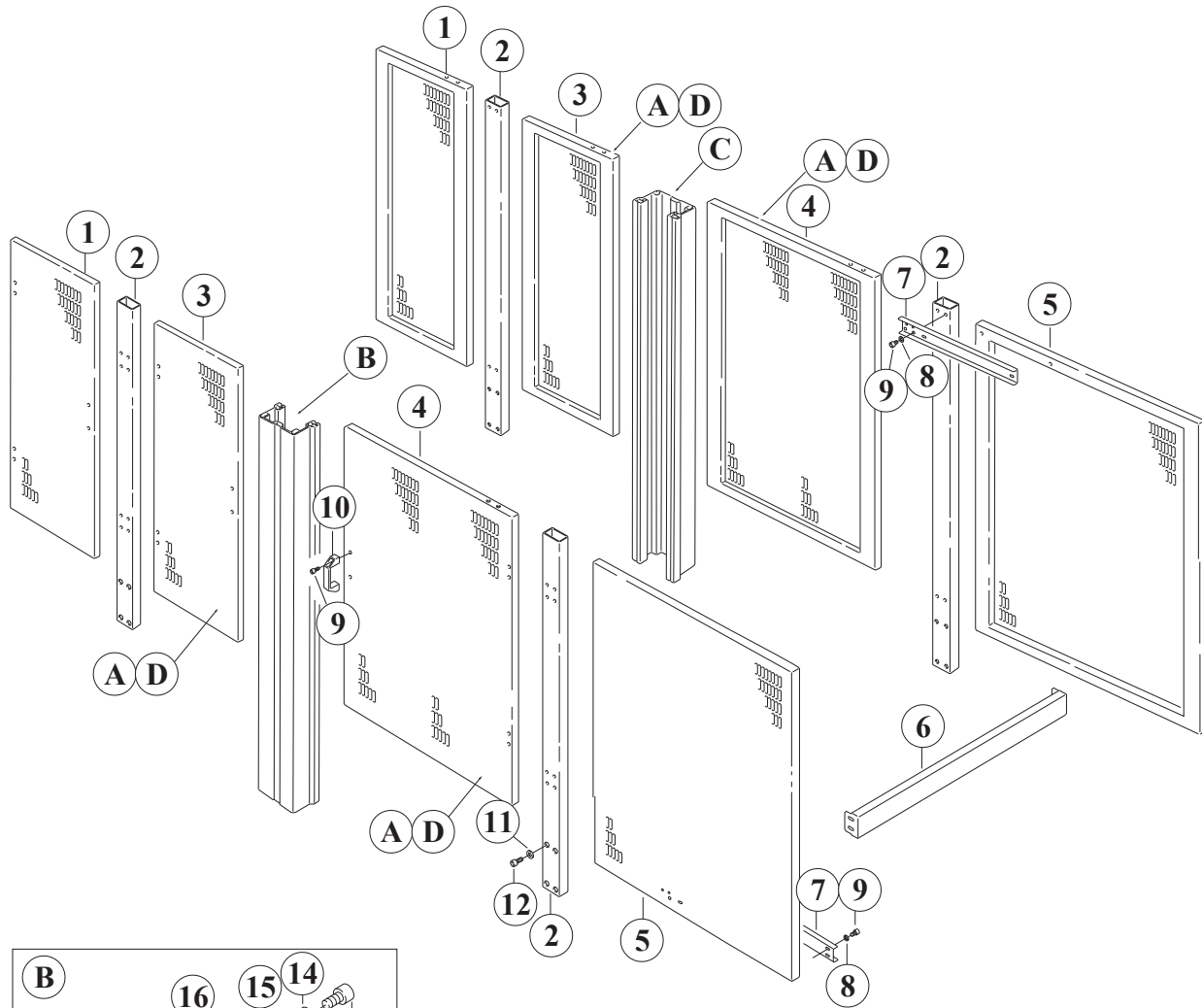
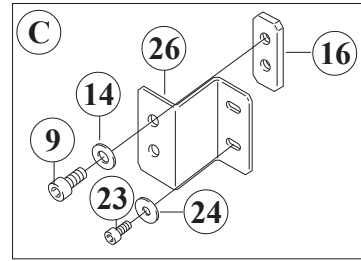
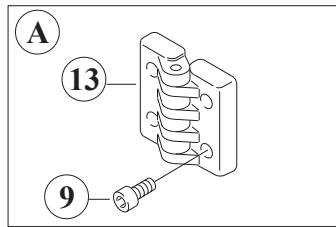


Figure 15346

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Figure 15346

Ref. No.	3M Part No.	Description
15346-1	78-8137-5932-7	Exit Panel
15346-2	78-8137-5934-3	Jamb
15346-3	78-8137-5935-0	Door L=510 - Safety Guard
15346-4	78-8137-5936-8	Door L=740 - Safety Guard
15346-5	78-8137-5937-6	Fixed Panel - Entry
15346-6	78-8137-5938-4	Crossbar - Safety Guard
15346-7	78-8137-5939-2	Panel Mounting Bracket
15346-8	78-8042-2919-9	Washer- Triple, M6
15346-9	26-1003-7957-2	Screw Soc. Hd. Hex Hd. M6 X 16
15346-10	78-8060-7807-3	Handle
15346-11	78-8017-9318-9	Washer - Plain - Metric 8mm
15346-12	26-1003-7964-8	Screw Soc. Hd. Hex Soc. Hd., M8 X 20
15346-13	78-8129-6293-0	Hinge
15346-14	78-8137-5940-0	Washer
15346-15	78-8137-5941-8	Plate
15346-16	78-8129-6290-6	Plate
15346-17	78-8076-4932-8	Lock - Wing
15346-18	26-0001-5862-1	Screw, Flat Hd Soc. M5 X 12
15346-19	78-8076-4931-0	Drawbar - Lock
15346-20	78-8005-5741-1	Washer- Flat, M5
15346-21	26-1005-6859-6	Nut - Self-Locking M5
15346-22	78-8137-5942-6	Bracket Switch
15346-23	26-1003-7949-9	Screw Soc. Hd. Hex Soc. M5 X 12
15346-24	26-1005-5316-8	Washer
15346-25	78-8129-6293-0	Screw, Flat Hd. Hex Dr. M5 X 16
15346-26	78-8137-5943-4	Mounting Bracket Door

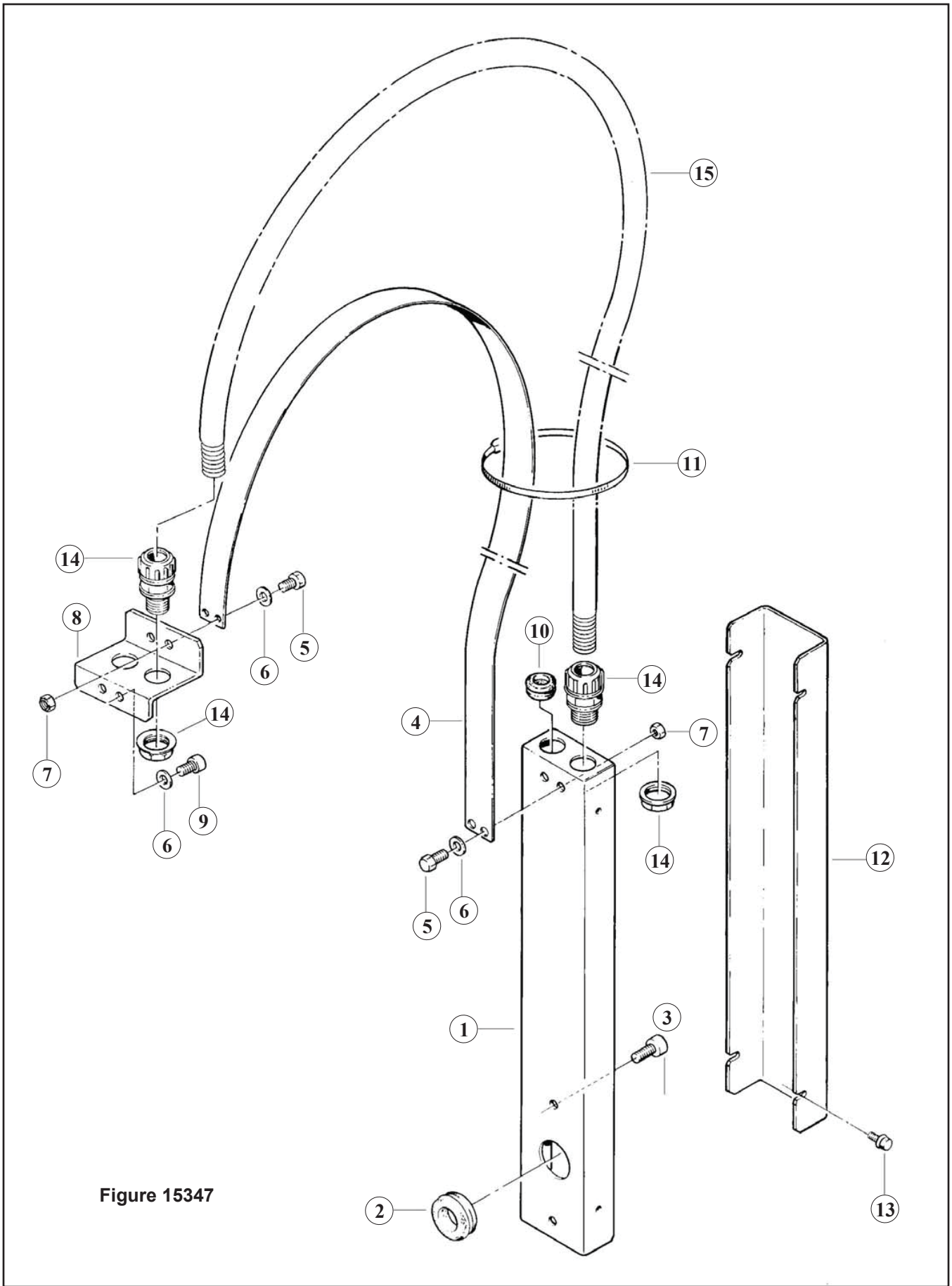
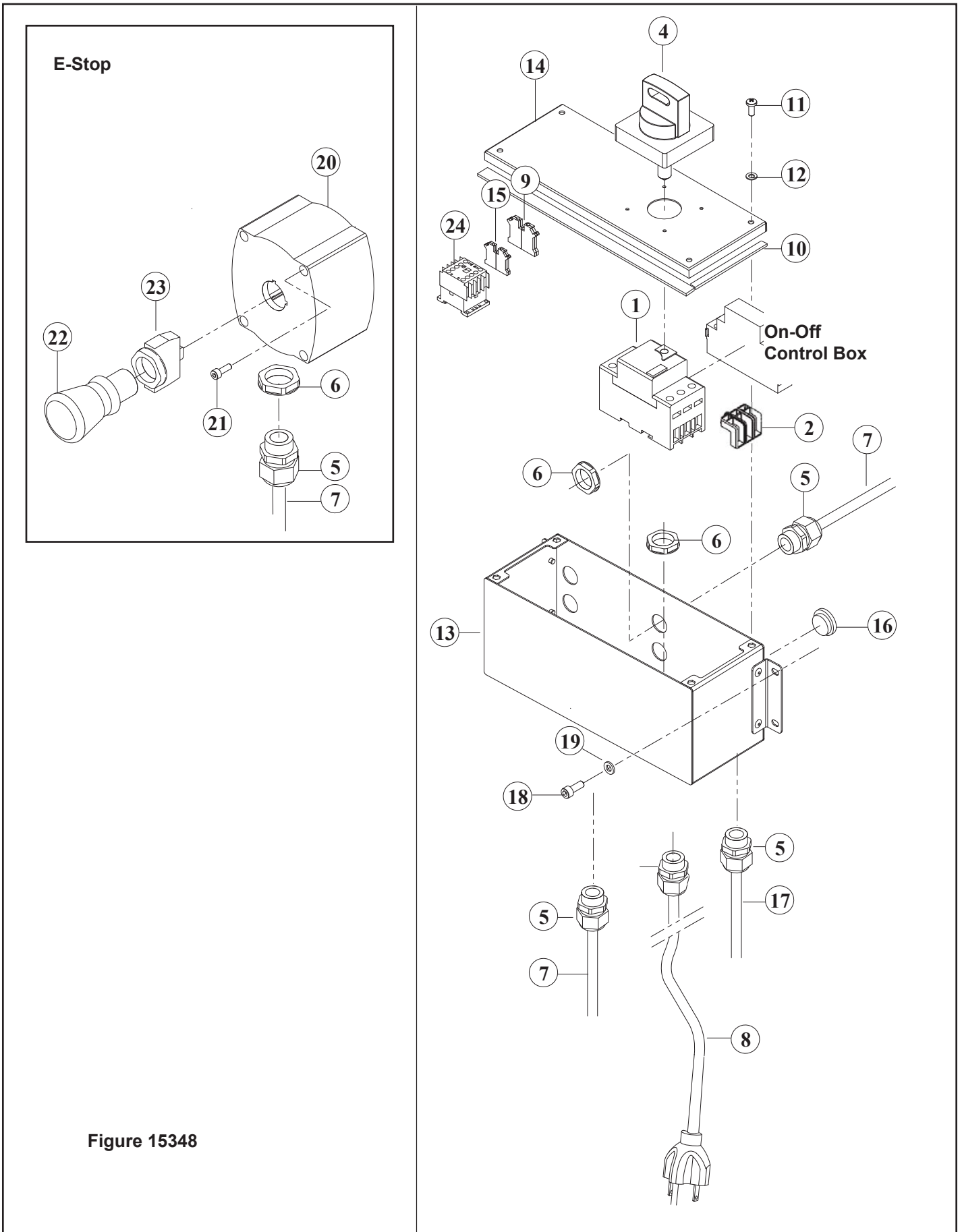


Figure 15347

a80f

Figure 15347

Ref. No.	3M Part No.	Description
15347-1	78-8091-0660-8	Housing - Wire
15347-2	78-8076-4702-5	Grommet - Heyco SB1093-13
15347-3	78-8091-0656-6	Screw - Hex. Soc. Hd. M8 X 12
15347-4	88-1375-9491-7	Strap - Wire
15347-5	78-8010-7163-6	Screw - Metric, M5 X 10, Hex. Hd.
15347-6	78-8005-5741-1	Washer - Flat, M5
15347-7	26-1005-6859-6	Nut - Self-Locking M5
15347-8	78-8091-0660-8	Plate - Strap
15347-9	26-1003-7949-9	Screw Soc. Hd. Hex Soc. M5 X 12
15347-10	78-8060-7758-8	Grommet DG13,5
15347-11	78-8060-8029-3	Clamp
15347-12	78-8137-4052-5	Cover Housing
15347-13	83-0002-7336-3	Screw - Hex Hd M4 X 14 Zinc Pl
15347-14	78-8076-4520-1	Union PG13 - Sleeve /16
15347-15	78-8076-5229-8	Sleeving - /16, 1180mm



a80f

Figure 15348

Ref. No.	3M Part No.	Description
15348-1	78-8137-0780-5	Switch 4-6.3 A
15348-2	78-8137-0782-1	Spacer
15348-3	78-8137-0604-7	Coil - Low Tension
15348-4	78-8137-0606-2	Lockable Knob
15348-5	78-8137-0607-0	Cable Gland
15348-6	78-8129-6469-6	Nut
15348-7	78-8137-5956-6	Cable
15348-8	78-8028-7909-4	Power Cord U.S.A.
15348-9	78-8094-6384-3	Clamp
15348-10	78-8119-8554-4	Adhesive Rubber Seal
15348-11	78-8094-6145-8	Screw- Phillips M5 X 12
15348-12	78-8005-5741-1	Washer - Flat, M5
15348-13	78-8137-5950-9	Box - Switch
15348-14	78-8137-5951-7	Cover
15348-15	78-8091-0412-4	Terminal - VU 4-2.5
15348-16	78-8137-0796-1	Plug
15348-17	78-8137-5957-4	Cable
15348-18	26-1003-7957-2	Screw Soc. Hd. Hex Hd. M6 X 16
15348-19	26-1000-0010-3	Washer - Flat M6
15348-20	78-8137-0608-8	Plastic Box
15348-21	26-1003-7943-2	Screw - Soc. Hd. M4 X 12
15348-22	78-8137-0609-6	Emergency Button
15348-23	78-8137-0797-9	Contact Cartridge w/Latch
15348-24	78-8094-6383-5	Contacto 115V 60HZ

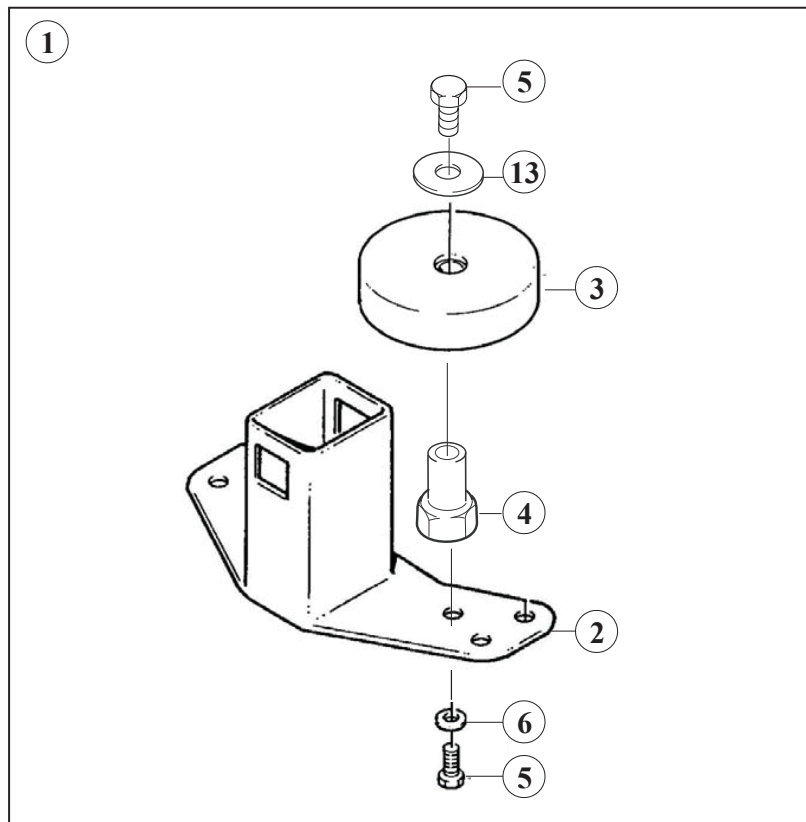
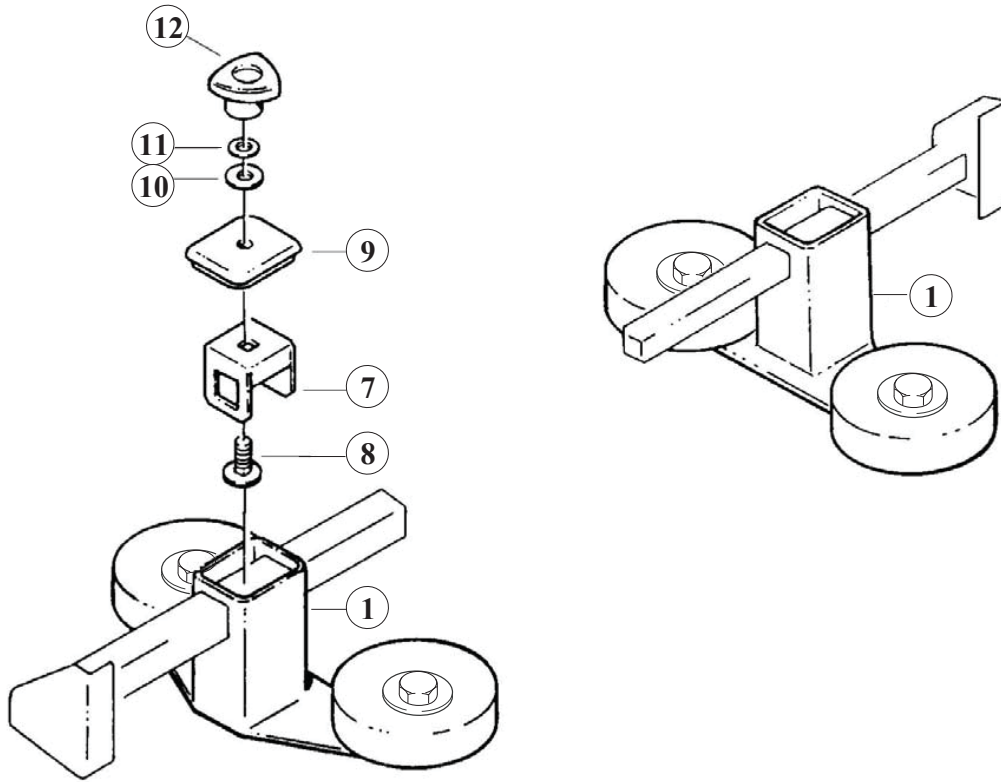


Figure 15350

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Figure 15350

Ref. No.	3M Part No.	Description
15350-1	78-8137-5953-3	Side Roller Assy
15350-2	78-8137-5952-5	Support - Compression Roller
15350-3	78-8054-8974-3	Pressure Roller
15350-4	78-8137-5954-1	Shaft - Roller
15350-5	26-1003-5841-0	Screw M8 X 16
15350-6	78-8017-9318-9	Washer - Plain - Metric 8mm
15350-7	78-8076-4630-8	Plate - Tube, Roller
15350-8	78-8076-4631-6	Screw - M10 X 35
15350-9	78-8076-4632-4	Cap - Support
15350-10	78-8017-9074-8	Washer - Nylon 15mm
15350-11	26-1004-5510-9	Washer - Plain, M10
15350-12	78-8070-1549-6	Knob VTR-B-M10
15350-13	78-8052-6703-2	Washer - Special

Figure 15357

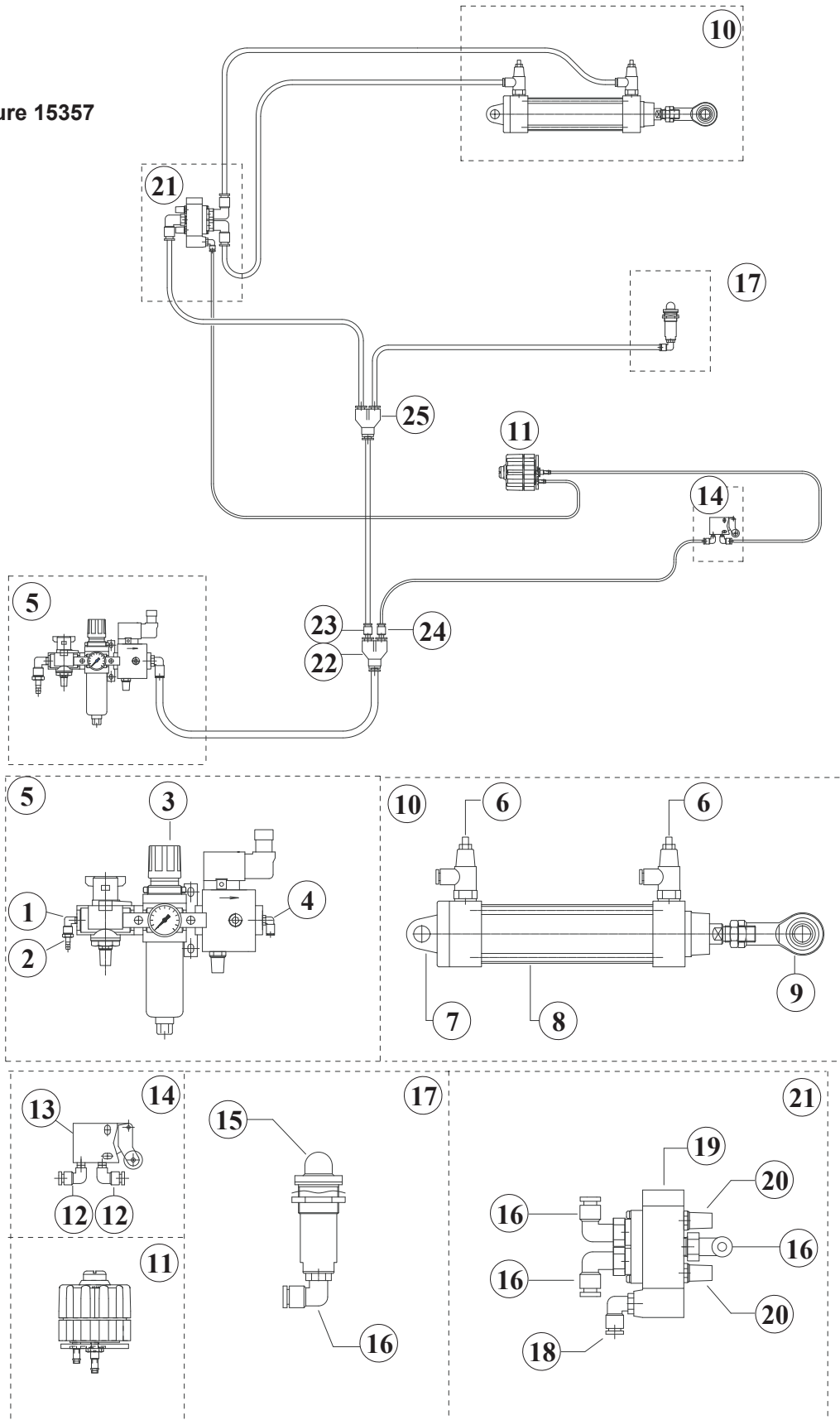


Figure 15357

Ref. No.	3M Part No.	Description
15357-1	78-8060-7900-6	Union
15357-2	26-1005-6897-6	Hose Connector
15357-3	78-8137-5958-2	Air Handling Unit
15357-4	78-8091-0313-4	Elbow - 3199.08.10
15357-5	78-8137-5959-0	Air Handling Unit Assy
15357-6	78-8137-5960-8	One Way Flow Regulator
15357-7	26-1017-3315-7	Swinging Flange
15357-8	78-8137-5961-6	Cylinder DNCB-40-125-PPV-A
15357-9	78-8057-5747-9	Mount, Cylinder Rod End
15357-10	78-8137-5962-4	Cylinder Assy
15357-11	78-8137-5963-2	Flow Regulator
15357-12	78-8057-5732-1	Fitting- Elbow
15357-13	26-1005-6358-9	3 Way - 2 Position Valve
15357-14	78-8137-5964-0	Valve
15357-15	78-8076-4665-4	Indicator - Visual
15357-16	26-1005-6893-5	90 Degree Elbow
15357-17	78-8129-6391-2	Indicator Assy
15357-18	78-8055-0756-9	Union - Rotating
15357-19	78-8137-5965-7	Pneumatic Valve
15357-20	26-1005-6890-1	Muffler
15357-21	78-8137-5966-5	Valve Assy
15357-22	78-8114-4704-0	Union - 3140A0800
15357-23	78-8114-4705-7	Union - KQR 06-08
15357-24	78-8137-5967-3	Reducing Nipple
15357-25	78-8094-6079-9	Union - Y, Female
15357-26	78-8119-8640-1	Union Elbow
15357-27	78-8114-4653-9	Joint
15357-28	78-8060-7861-0	End Cap

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Instructions and Parts List

3M-Matic[™]

AccuGlide[™] 2+ STD 2 Inch Upper and Lower Taping Heads

Type 10500

Serial No. _____

For reference, record taping head(s) serial number(s) here.



3M Industrial Adhesives and Tapes
3M Center, Building 220-5E-06
St. Paul, MN 55144-1000



Important Safety Information

BEFORE INSTALLING
OR OPERATING THIS
EQUIPMENT

Read, understand, and
follow all safety and
operating instructions.

Spare Parts

It is recommended you
immediately order the
spare parts listed in the
"Spare Parts/Service
Information" section.
These parts are expected
to wear through normal
use, and should be kept
on hand to minimize
production delays.

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Replacement Parts and Service Information

To Our Customers:

This is the 3M-Matic™/AccuGlide™/Scotch® equipment you ordered. It has been set up and tested in the factory with Scotch® 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 / Replacement Parts and Additional Manuals:

Call the 3M-Matic™ Help line at 1-800 328-1390. Provide the customer support coordinator with the model/machine name, machine type, and serial number that are located on the identification plate (For example: Model 200a / Accuglide 2+ / 2 inch - Type 10500 - Serial Number 13282).

United States -

3M Tape Dispenser Parts


241 Venture Drive

1-800-344-9883

Amery, WI 54001-1325

Fax: 1-715-268-8153

Identification Plate

3M 3M Company St. Paul, MN 55144 USA	Part Number	3M-Matic™		 4000563
	Model	For Industrial Use Only		
Type	Serial Number	Year	Ampere	Watt
		Volt	Hertz	Phase

**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.



3M Industrial Adhesives and Tapes

3M Center, Building 220-5E-06
St. Paul, MN 55144-1000

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Replacement Parts And Service Information

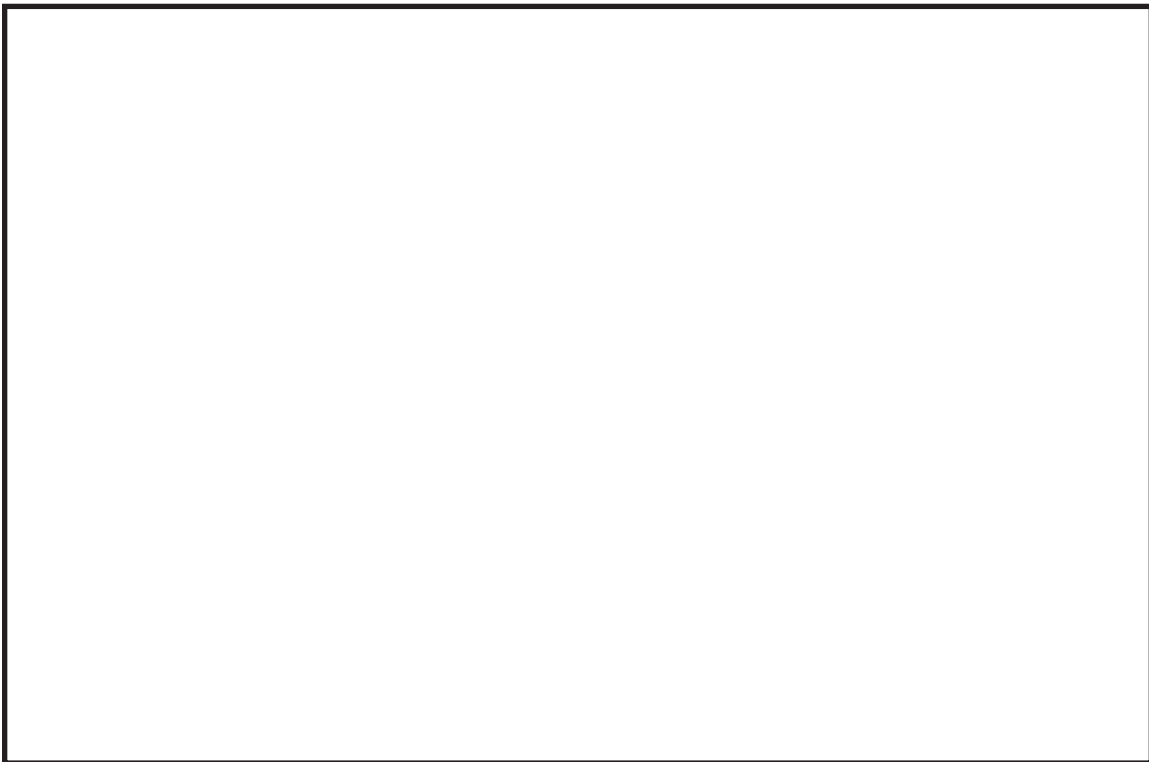
To Our Customers:

This is the 3M-Matic™/AccuGlide™/Scotch® equipment you ordered. It has been set up and tested in the factory with Scotch® 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 or additional manuals, include model/machine name, machine type, and serial number that are located on the identification plate.



3M Industrial Adhesives and Tapes

3M Center, Building 220-5E-06
St. Paul, MN 55144-1000

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Instruction Manual

AccuGlide™ 2+ STD 2 Inch Upper and Lower Taping Heads Type 10500

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General Information - Warranty

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

3M sells its **AccuGlide™ 2+ STD 2 Inch Upper and Lower Taping Heads, Type 10500** with the following warranty:

1. The Taping Head blade, springs and rollers will be free from defects in material and manufacture for ninety (90) days after delivery.
2. All other Taping Head parts will be free from defects in material and manufacture for three (3) years after delivery.

If any part is defective within this warranty period, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to repair or replace the part. 3M must receive actual notice of any alleged defect within a reasonable time after it is discovered, but in no event shall 3M have any obligation under this warranty unless it receives such notice within five (5) business days after the expiration of the warranty period. All notices required hereunder shall be given to 3M solely through the 3M-Matic™ Help line (800-328-1390). To be entitled to repair or replacement as provided under this warranty, the part must be returned as directed by 3M to its factory or other authorized service station designated by 3M. If 3M is unable to repair or replace the part within a reasonable time after receipt thereof, 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 remove any part or equipment or to install the repaired or replacement part or equipment. 3M shall have no obligation to repair or replace those parts failing due to normal wear, inadequate or improper maintenance, inadequate cleaning, non-lubrication, improper operating environment, improper utilities, operator error or misuse, alteration or modification, mishandling, lack of reasonable care, or due to any accidental cause.

Limitation of Liability: Except where prohibited by law, 3M and seller will not be liable for any loss or damage arising from this 3M equipment, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including breach of warranty, breach of contract, negligence, or strict liability.

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

AccuGlide™, Scotch™, and 3M-Matic™ are Trademarks of 3M, St. Paul, Minnesota 55144-1000

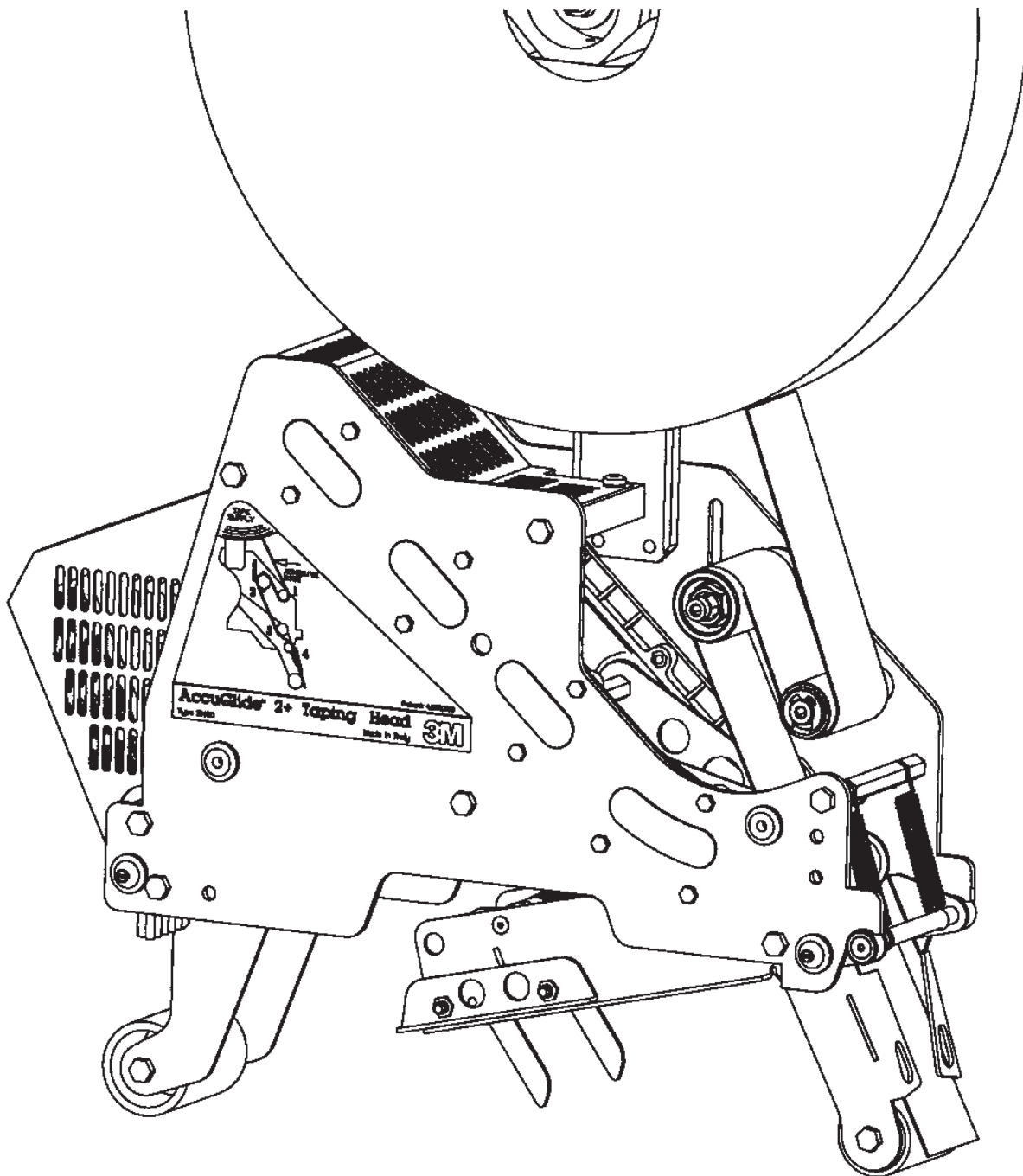
Intended Use

The intended use of the **AccuGlide™ 2+ STD 2 Inch Upper and Lower Taping Heads** is to apply a "C" clip of Scotch® pressure-sensitive film box sealing tape to the top and/or bottom center seam of regular slotted containers.

These taping heads are incorporated into most standard **3M-Matic™** case sealers. The compact

size and simplicity of the taping head also makes it suitable for mounting in box conveying systems other than **3M-Matic™** case sealers. This includes replacement of other types of taping, gluing or stapling heads in existing case sealing machines.

The **AccuGlide™ 2+ STD Taping Heads** have been designed and tested for use with Scotch® pressure-sensitive film box sealing tape.



AccuGlide™ 2+ STD 2 Inch Upper Taping Head, Type 10500

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Taping Head Contents

AccuGlide™ 2+ STD 2 Inch Upper and Lower Taping Heads consist of:

Qty.	Part Name
1	Taping Head Assembly
1	Tape Drum and Bracket Assembly
1	Hardware and Spare Parts Kit
1	Threading Tool

General Information

This instruction manual covers safety aspects, handling and transport, storage, unpacking, preparation, installation, operation, set-up and adjustments, technical and manufacturing specifications, maintenance, troubleshooting, repair work and servicing, electric diagrams, warranty information, disposal (ELV), a glossary with a definition of symbols, plus a parts list of the 3M-Matic™ Accuglide 2+ (2 inch) 3M Industrial Adhesives and Tapes Division 3M Center, Bldg. 220-5E-06 St. Paul, MN 55144-1000 (USA) Edition December 2011/Copyright 3M 2011. All rights reserved The manufacturer reserves the right to change the product at any time without notice.

How to use this Manual

The manual is an important part of the machine; all information contained herein is intended to enable the equipment to be maintained in perfect condition and operated safely. Ensure that the manual is available to all operators of this equipment and the manual is kept up to date with all subsequent amendments. Should the equipment be sold or disposed of, please ensure that the manual is passed on with the machine.

Electrical and pneumatic diagrams are included in the manual. Equipment using PLC controls and/or electronic components will include relevant schematics or programs in the enclosure (or will be delivered separately as needed)

Keep the manual in a clean and dry place near the machine. Do not remove, tear or rewrite parts of the manual for any reason. Use the manual without damaging it. However, if the manual has been lost or damaged, ask your after sale service for a new copy (if it is possible, please have the manual name, part number, and revision information and/or model/machine name, machine type, and serial number) that are located on the identification plate (For example: **Accuglide 2+/2 inch - Type 10500 - Serial Number 13282**).

Note:

All the important warning notes related to the operation of the machine are identified by the symbol:



Updating the Manual

Modifications to the machine are subject to manufacturer's internal procedures. The user may receive pages or parts of the manual which contain amendment made after its first publication. The user must use them to update this manual.

Important Safeguards



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

Explanation of Signal Word Consequences



CAUTION: Indicates a potentially hazardous situation, which, if not avoided, may result in minor or moderate injury and/or property damage.



WARNING: Indicates a potentially hazardous situation, which, if not avoided, could result in death or serious injury and/or property damage.



WARNING

- **To reduce the risk associated with mechanical hazards:**
 - Read, understand and follow all safety and operating instructions before operating or servicing the case sealer
 - Allow only properly trained and qualified personnel to operate and/or service this equipment
- **To reduce the risk associated with shear, pinch, and entanglement hazards:**
 - Turn air and electrical supplies off on associated equipment before performing any adjustments, maintenance, or servicing the taping heads
 - Never attempt to work on the taping head or load tape while the box drive system is running
- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp



CAUTION

- **To reduce the risk associated with muscle strain:**
 - Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift
- **To reduce the risk associated with impact hazards:**
 - Place the taping head on a smooth level surface when maintaining or servicing this equipment

(Important Safeguards continued on next page)

Important Safeguards (continued)

Important - In the event the following safety labels are damaged or destroyed, they must be replaced to ensure operator safety. See "Replacement Parts Illustrations and Parts Lists" for label part numbers.

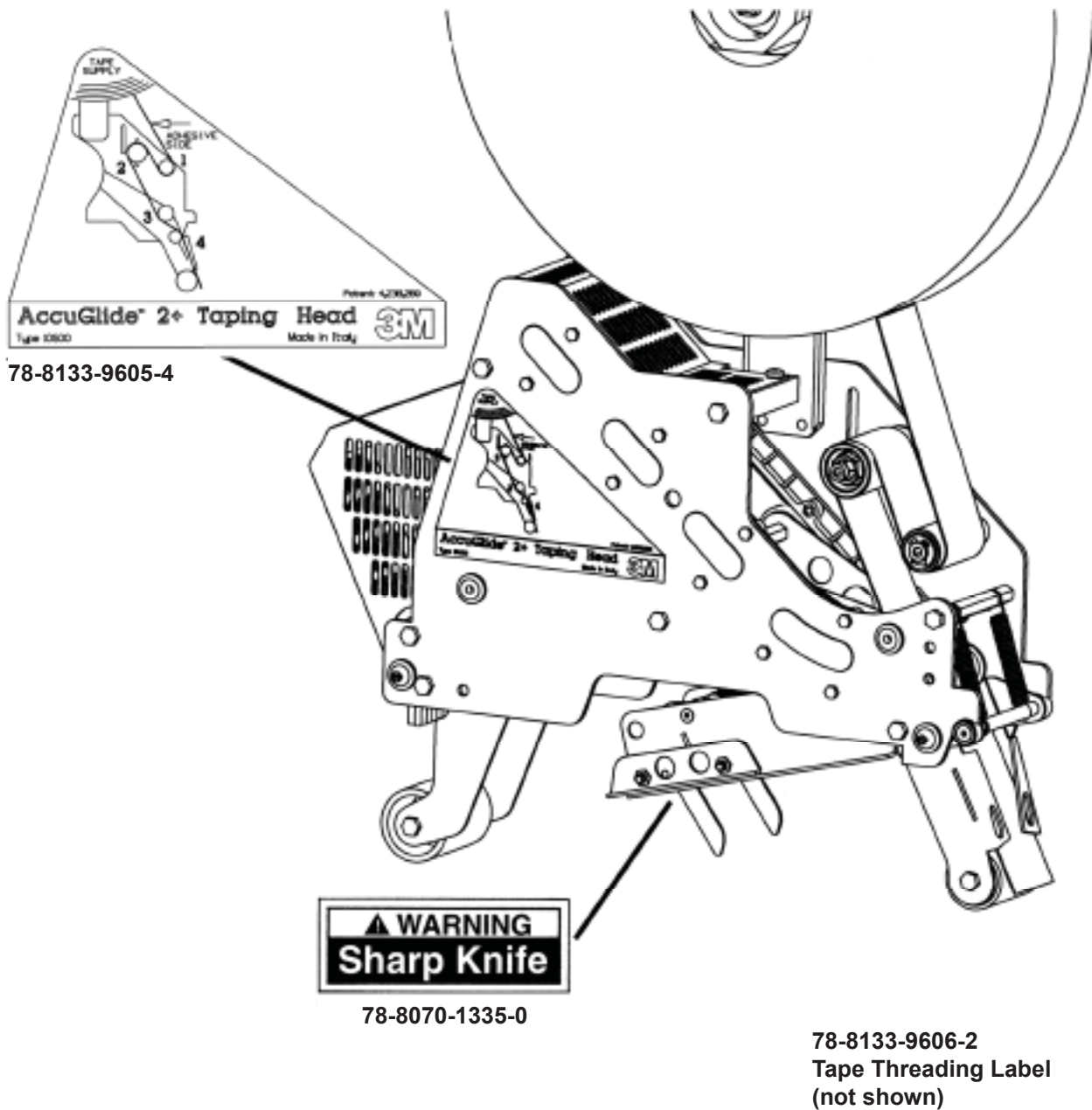


Figure 1-1 Replacement Labels/3M Part Numbers

Specifications

1. Tape:

For use with Scotch® pressure-sensitive film box sealing tapes.

2. Tape Width:

36mm or 1-1/2 inches minimum to 48mm [2 inches] maximum.

3. Tape Roll Diameter:

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

4. Tape Application Leg Length - Standard:


70mm ± 6mm [2-3/4 inches ± 1/4 inch]

Tape Application Leg Length - Optional:

50mm ± 6mm [2 inches ± 1/4 inch] (See "Adjustments – Tape Leg Length.")

5. Box Size Capacities:

For use with center seam regular slotted containers.

Minimum	Maximum	
Length – 150mm [6 inches]	_____	Unlimited
Height – 120mm [4-3/4 inches]	(most "3M-Matic" Case Sealers)	 Limited by Case Sealer
90mm [3-1/2 inches]	(with optional 2 inch leg length)	
Width – 115mm [4-1/2 inches]		

When upper and lower taping heads are used on "3M-Matic" case sealers, refer to the respective instruction manual specifications for box weight and size capacities.

6. Operating Rate:

Conveyor speeds up to 0.40m/s [80FPM] maximum.

7. Operating Conditions:

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

Important – Taping heads should not be washed down or subjected to conditions causing moisture condensation on components.

8. Taping Head Dimensions:

Length	–	457mm [18 inches]
Height	–	560mm [22 inches] (with tape drum)
Width	–	105mm [4-1/8 inches] (without mounting spacers)
Weight	–	Packaged: 7.7kg [17 lbs.]
		Unpackaged: 6.7kg [15 lbs.]

(Specifications continued on next page.)

Specifications (continued)

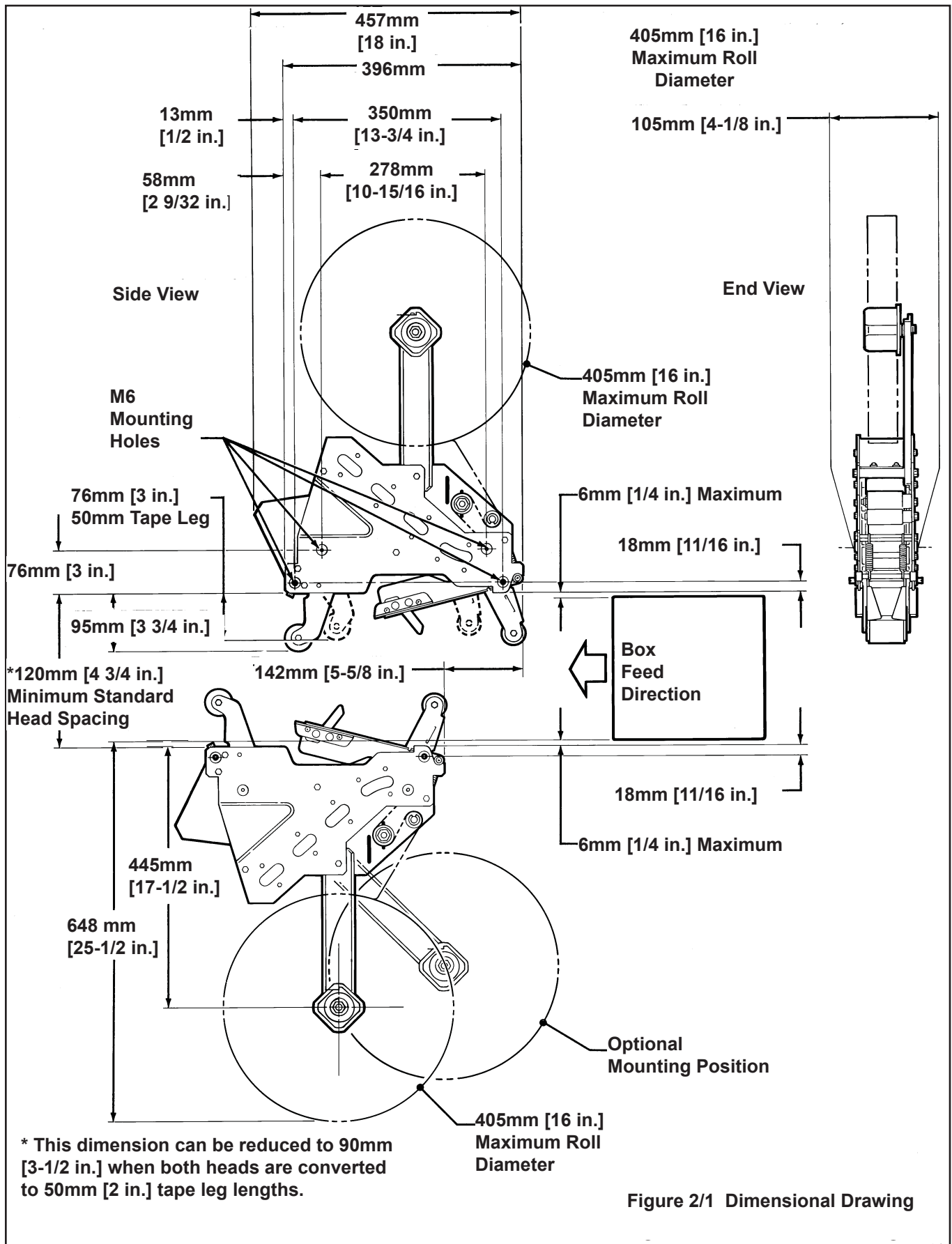


Figure 2/1 Dimensional Drawing

Installation



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards.
The blades are extremely sharp

Receiving And Handling

After the taping head assembly has been unpackaged, examine the unit 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.

Installation Guidelines

The taping head assembly can be used in converting existing or in custom made machinery. It can be mounted for top taping or bottom taping. Refer to "Box Size Capacities," as well as **Figure 2-1** in the Specifications section, for the following points in making such installations:



CAUTION

- **To reduce risk associated with muscle strain:**
 - Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift

Important – Always conduct a hazard review to determine appropriate guarding requirements when the installation is in an application other than 3M-Matic™ equipment

1. The box conveying system must positively propel the box in a continuous motion, not exceeding 0.40 m/s [80 feet per minute], past the taping head assembly since the box motion actuates the taping mechanism.
2. If a pusher or cleated conveyor is being used, steps should be taken in the conveyor design to prevent the pusher from contacting the applying or buffing roller arms resulting in damage to the taping head.

3. **Figure 2-1** illustrates the typical mounting relationship for opposing taping head assemblies to allow taping of box heights down to 90mm [3-1/2 inches]. To tape box heights down to 70mm [2-3/4 inches], the taping heads must be completely staggered so only one tape seal is being applied at one time.

Note – AccuGlide™ 2+ STD Upper Taping Head is supplied with a buffing arm guard. Adjustments to this guard may be required to install the taping head into some older design 3M-Matic™ case sealers.

4. Mounting studs are provided with the taping head, but special installations may require alternate means for mounting.
5. Box hold-down or guide skis should be provided and the taping head mounted so that the side plates are 6mm [1/4 inch] maximum away from the ski surface on which the box rides.

Tape Leg Length

Taping heads are factory set to apply standard 70mm [2-3/4 inch] tape legs. The heads can be converted to apply 50mm [2 inch] tape legs if desired but both upper and lower heads must be set to apply the same tape leg length. See "Adjustments – Changing Tape Leg Length From 70 to 50mm [2-3/4 to 2 Inches]."

Also, the conveyor speed at which the product moves through the taping heads, affects the leading and trailing tape leg length. See "Adjustments section – Leading Tape Leg Length Adjustment."

Tape Width Adjustment

Taping heads are factory set to apply 48mm [2 inch] wide tape. If it is necessary to align the tape or to apply narrower tapes, refer to "Adjustments – Tape Web Alignment" for set-up procedure.

Operation

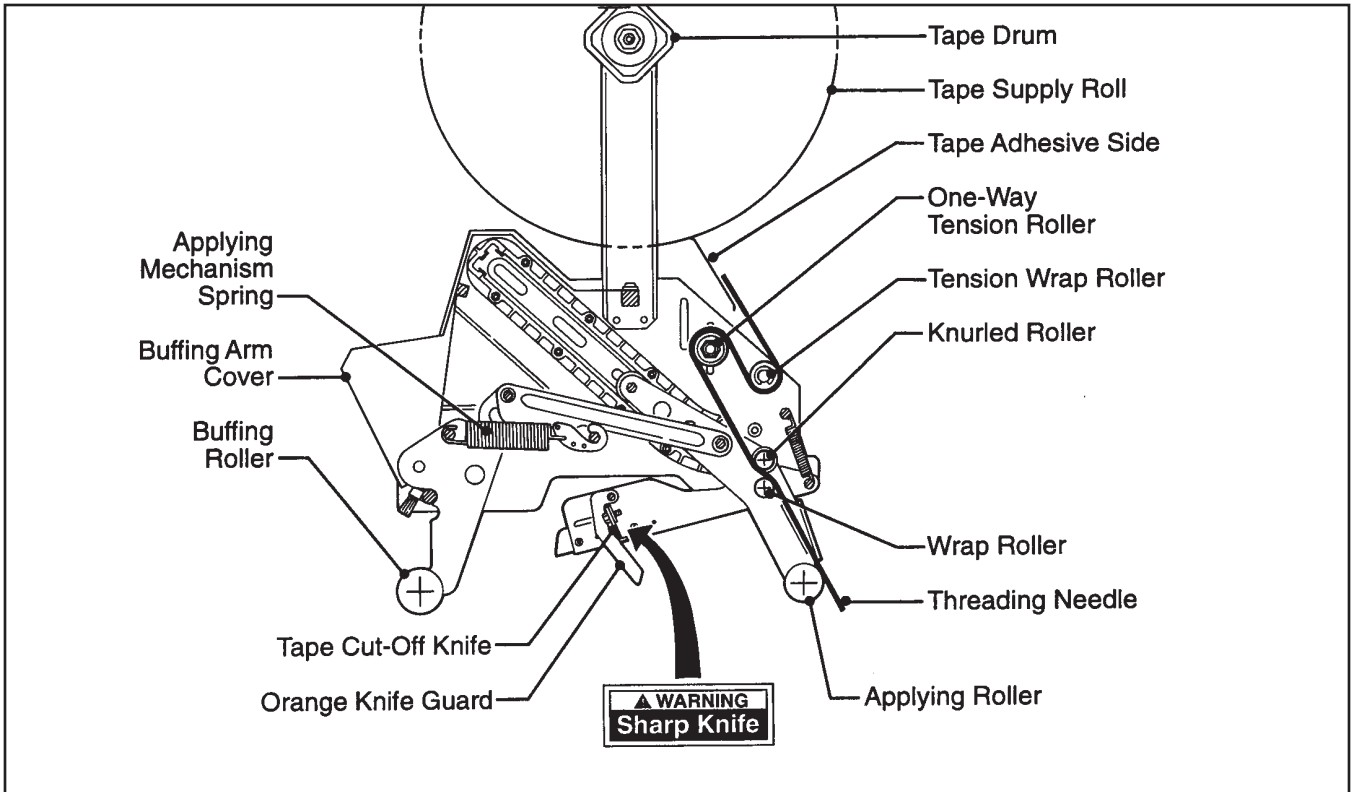


Figure 3-1 Taping Head Components/Threading Diagram - Upper Head (Left Side View)

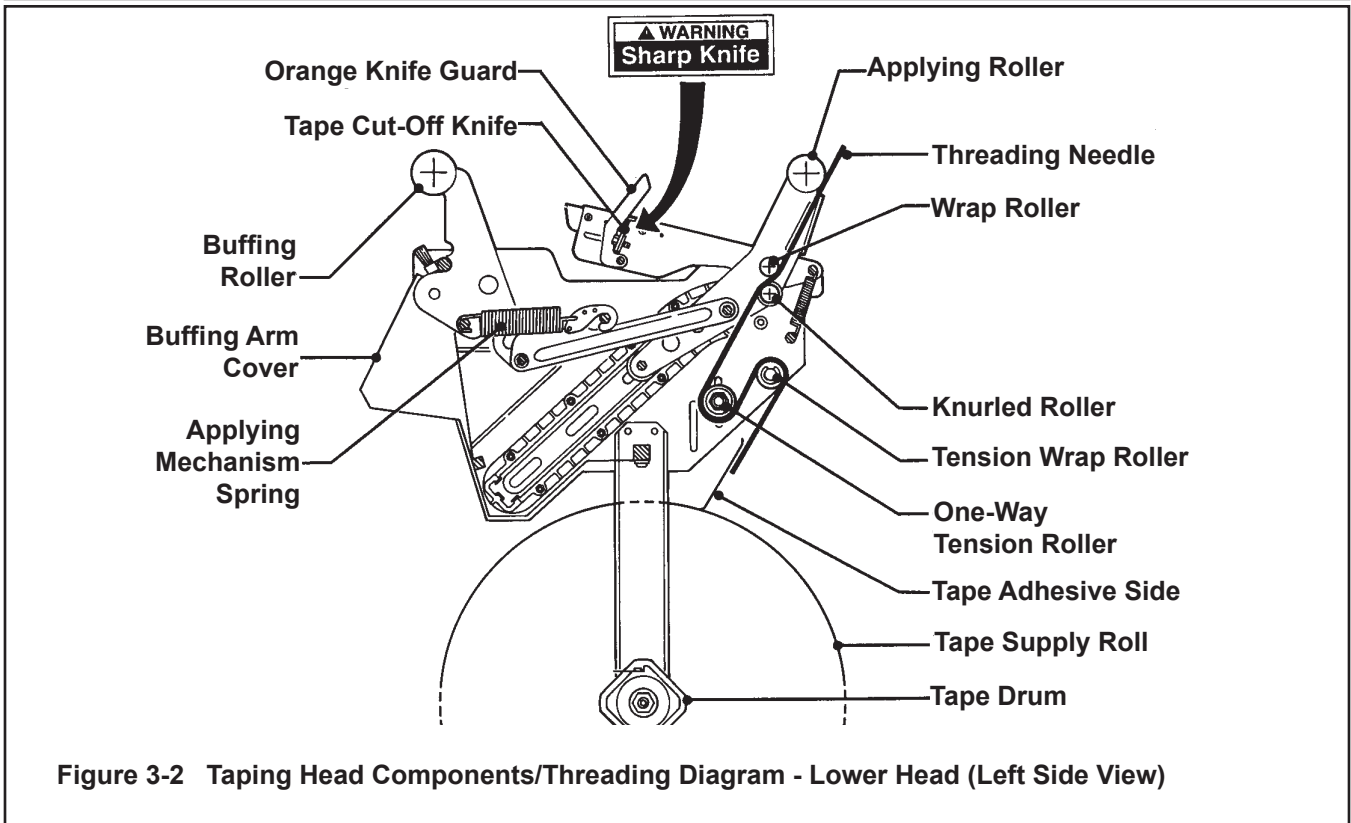


Figure 3-2 Taping Head Components/Threading Diagram - Lower Head (Left Side View)

(Operation continued on next page)

Operation (continued)



WARNING

- **To reduce the risk associated with shear, pinch, and entanglement hazards:**
 - Turn air and electrical supplies off on associated equipment before performing any adjustments, maintenance, or servicing the machine or taping heads
 - Never attempt to work on the taping heads or load tape when the box drive system is running
- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards.
The blades are extremely sharp

It is recommended that the detailed instructions and sketches in this manual be referred to the first few times the taping head is loaded/threaded until the operator becomes thoroughly familiar with the tape loading operation.

Note – Remove tape roll before removing taping head from machine to minimize weight.



CAUTION

- **To reduce the risk associated with muscle strain:**
 - Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift
- **To reduce the risk associated with impact hazards:**
 - Place the taping head on a smooth level surface when maintaining or servicing this equipment

Tape Loading – Upper Taping Head

1. Place the upper taping head in a convenient working position.
2. Use **Figures 3-3 to 3-5** and tape threading label. Position the tape supply roll so the adhesive side of tape is facing the front of the taping head as it is pulled from the supply roll.
3. Attach the threading needle to the end of the roll. Guide the threading needle around the wrap roller (Position 1) then back around the one-way tension roller (Position 2).
4. Continue pulling the threading needle down and guide it between the two rollers on the apply arm (Position 3).

5. Pull the threading needle down until the tape travels between the apply plate and the ears of the apply arm (Position 4) until it extends past the applying roller. When properly threaded the adhesive side of the tape should be facing the knurled rollers at position 2 and also position 3.
6. Cut away any excess tape.

Important – Do not cut against the apply roller - roller damage could occur.

Tape Loading – Lower Taping Head

1. Remove the lower taping head from the conveyor bed or associated equipment and place it a convenient working position.
2. The lower taping head is loaded and threaded in the same manner as the upper head. Follow the upper taping head tape loading/threading procedure.

Figure 3-3

Insert threading needle through rollers in direction indicated by arrows.

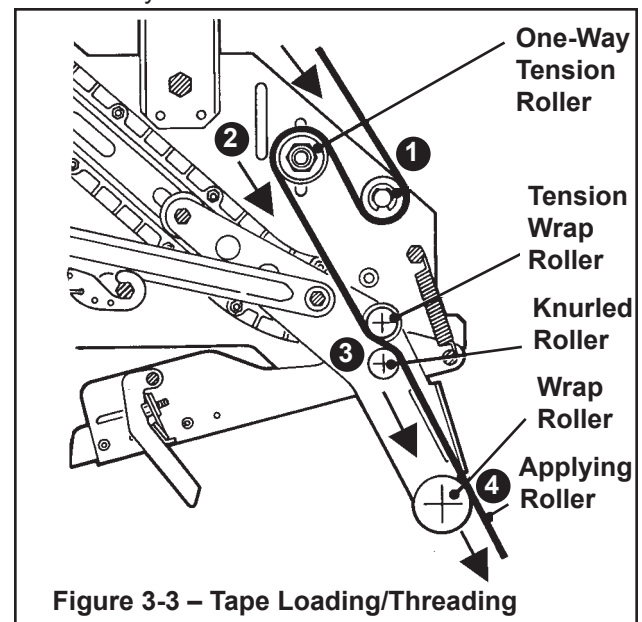


Figure 3-3 – Tape Loading/Threading

Figure 3-4

Place tape roll on tape drum to dispense tape with adhesive side forward. Seat tape roll fully against back flange of drum. Adhere tape lead end to threading needle as shown.

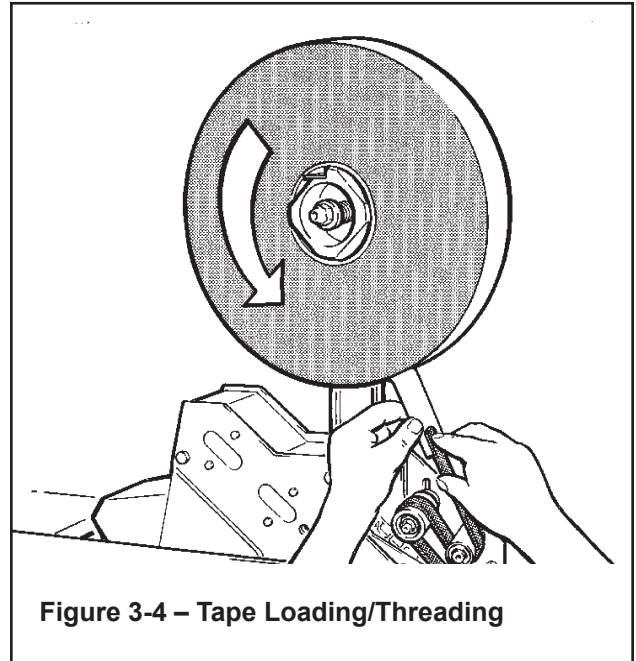


Figure 3-4 – Tape Loading/Threading



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp.

Manually turn tape roll to create slack tape while pulling threading needle through tape applying mechanism until needle is through and tape is in alignment with applying roller.

Excess tape can be cut with a scissors at applying roller.

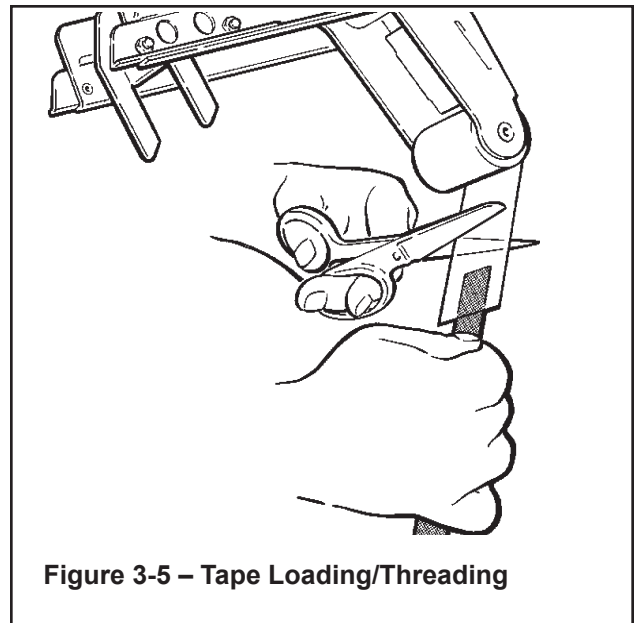


Figure 3-5 – Tape Loading/Threading



WARNING

- **To reduce the risk associated with shear, pinch, and entanglement hazards:**
 - Turn air and electrical supplies off on associated equipment before performing any adjustments, maintenance, or servicing the taping heads
 - Never attempt to work on the taping head or load tape while the box drive system is running
- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp

The AccuGlide™ 2+ STD 2 Inch Taping Head has been designed for long, trouble free service. The taping head will perform best when it receives routine maintenance and cleaning. Taping head components that fail or wear excessively should be promptly repaired or replaced to prevent damage to other portions of the head or to the product.

Blade Replacement, Upper and Lower Taping Heads – Figure 4-1



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp

1. Loosen, but do not remove, the blade screws (A). Remove and discard old blade.
2. Mount the new blade (B) with the beveled side away from the blade holder.

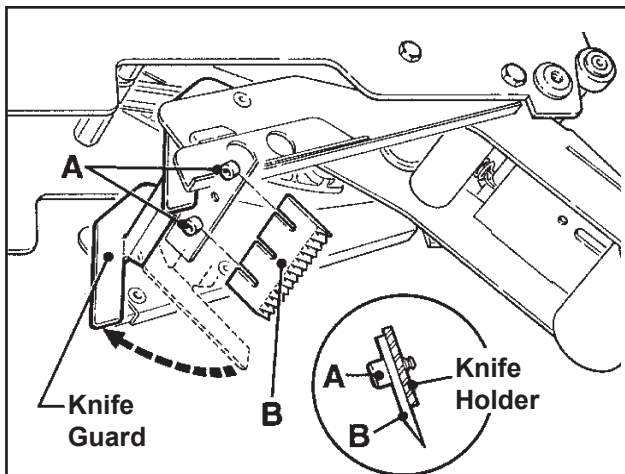


Figure 4-1 – Blade Replacement

3. Bottom the blade slots against the screws. (This will position the blade at the correct angle.) Tighten the blade screws to secure the blade.

Note – Check the blade position to insure proper clearance between blade and guard by slowly pivoting the blade guard back.

Blade Guard

The blade guard covers the blade whenever a box is not being taped. Periodically check to be sure the blade guard is functioning properly and returning to cover the blade. Replace any defective parts.

Blade Oiler Pad



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp

To reduce adhesive build-up, the taping heads are equipped with a factory pre-lubricated felt oiler pad that provides a film of oil on the cutting edge of the blade. Blade maintenance should include keeping the felt oiler pad saturated with SAE #30 non-detergent oil.

Should tape adhesive build-up occur on blade, carefully wipe the blade clean with an oily cloth.

(Maintenance continued on next page.)



WARNING

- **To reduce the risk associated with shear, pinch, and entanglement hazards:**
 - Turn air and electrical supplies off on associated equipment before performing any adjustments, maintenance, or servicing the taping heads
 - Never attempt to work on the taping head or load tape while the box drive system is running
- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp

Cleaning

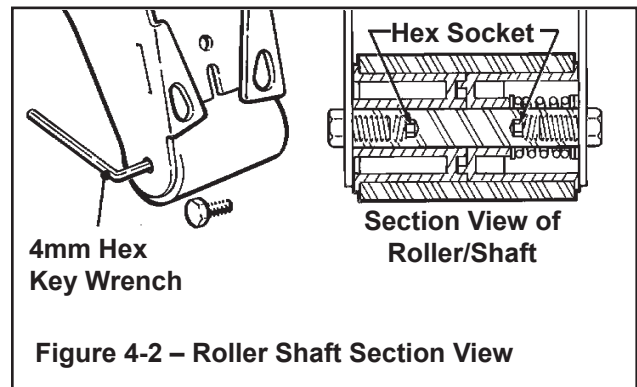
Regular slotted containers produce a great deal of dust and paper chips when conveyed through taping heads. If this dust is allowed to build-up on the heads, it can cause wear on the moving parts. Excessive dirt build-up should be wiped off with a damp cloth. Cleaning should be done once per month, depending on the number and type of boxes used. If the boxes used are dirty, or if the environment in which the heads operate is dusty, cleaning on a more frequent basis may be necessary.

Note – Never attempt to remove dirt from taping heads by blowing it out with compressed air. This can cause the dirt to be blown inside the components onto sliding surfaces. Dirt in these areas can cause serious equipment damage. Never wash down or subject taping heads to conditions causing moisture condensation on components. Serious equipment damage could result.

Applying/Buffering Roller Replacement

Replacing roller requires removal of shaft and mounting screws. With no area on the shaft to grip, the shaft often turns when attempting to remove the second screw.

To ease removal of second screw, a 4mm hex socket has been provided at the bottom of the threads in both ends of the shaft. Insert a 4mm hex key wrench into this socket after removing one screw to hold the shaft for removal of the second screw (**Figure 4-2**).



Adjustments



WARNING

- **To reduce risk associated with shear, pinch, and entanglement hazards:**
 - Turn air and electrical supplies off associated equipment before performing any adjustments, maintenance, or servicing the machine or taping heads.
 - Never attempt to work on the taping head or load tape while the box drive system is running.

Tape Latch Alignment – Figure 5-1

The Latching tape drum assembly is pre-set to accommodate 48mm [2 inch] wide tape. The tape drum assembly is adjustable to provide alignment of narrower tapes.

To move the latch to a position that corresponds to a new tape core width (**Figure 5-1**):

1. Remove screw from the latch.
2. Move the latch to the position that corresponds to the tape core width.
3. Replace screw in the new latch location.

To adjust or center the tape width on the centerline of the taping head, and therefore box center seam, (**Figure 5-2**):

1. Loosen the locking hex nut behind tape drum bracket on tape drum shaft. Use an adjustable wrench or 25mm open end wrench.
2. Turn tape drum shaft in or out to center the tape web (use 5mm hex wrench).
3. Tighten locking hex nut to secure the adjustment.

No other components require adjustment for tape web alignment.

Tape Drum Friction Brake – Figure 5-3

The tape drum friction brake on each taping head is pre-set for normal operation to prevent tape roll over travel. Should tension adjustment be required, turn the self-locking nut on the shaft to vary compression of the spring. Turn the nut clockwise to increase the braking force, and counterclockwise to decrease the braking force. Adjust brake to minimum tension to prevent excessive tape roll over travel.

Note – Excess braking force will cause poor tape application and may lead to tape tabbing on the trailing tape leg.

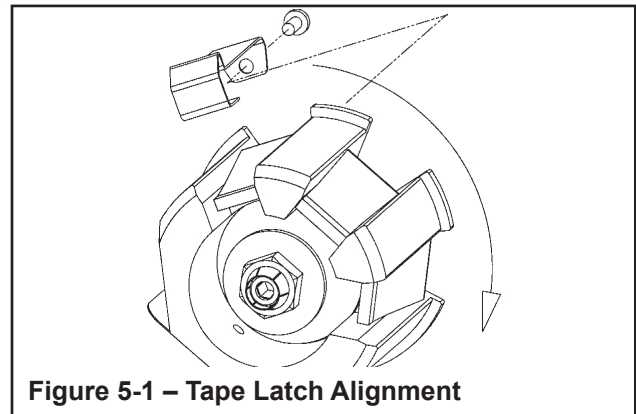


Figure 5-1 – Tape Latch Alignment

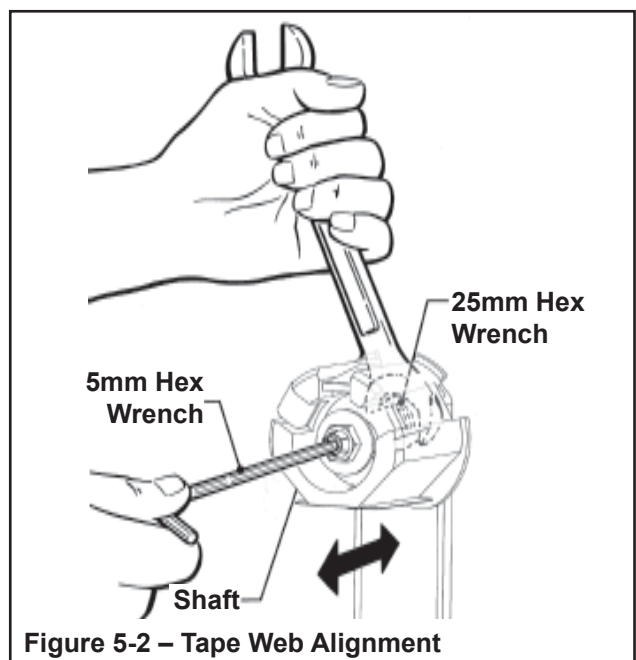


Figure 5-2 – Tape Web Alignment

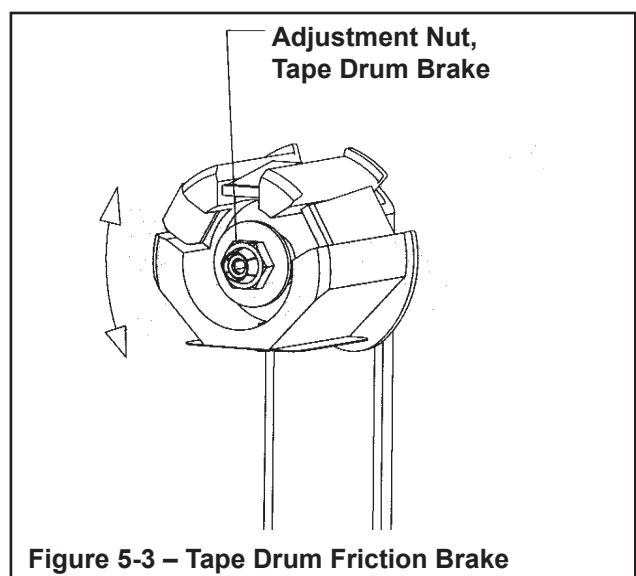


Figure 5-3 – Tape Drum Friction Brake

(Adjustments continued on next page.)



WARNING

- **To reduce risk associated with shear, pinch, and entanglement hazards:**
 - Turn air and electrical supplies off associated equipment before performing any adjustments, maintenance, or servicing the machine or taping heads.
 - Never attempt to work on the taping head or load tape while the box drive system is running.

Applying Mechanism Spring

To obtain access to the spring, remove the taping head cover (four mounting screws). Replace cover when finished.

The applying mechanism spring, shown in **Figures 5-4A and 5-4B**, controls applying and buffing roller pressure on the box and returns the mechanism to the reset position. The spring pressure is pre-set, as shown in **Figure 5-4A** for normal operation, but is adjustable.

If a tape gap appears on the trailing surface of the box increase spring pressure. If the front of the box is being crushed by the applying roller decrease spring pressure.

Removing the spring end loop from the spring holder and placing loop in other holes provided, as shown in **Figure 5-4B**, will adjust the spring pressure.

One-Way Tension Roller
Figure 5-5

The one-way tension roller is factory set. When replacing this assembly, the roller must have 0,5 kg [1 lb.] minimum tangential force when turning.

To Adjust Tension:

1. Wrap a cord or small strap (non-adhesive) 4-6 turns around the tension roller.
2. Attach a spring scale to the end of the cord or strap.
3. Turn the adjusting nut with the socket wrench provided, until a force of approximately 0.5 kg to 0.9 kg [1 to 2 lbs.] is required to turn the roller by pulling on the spring scale.

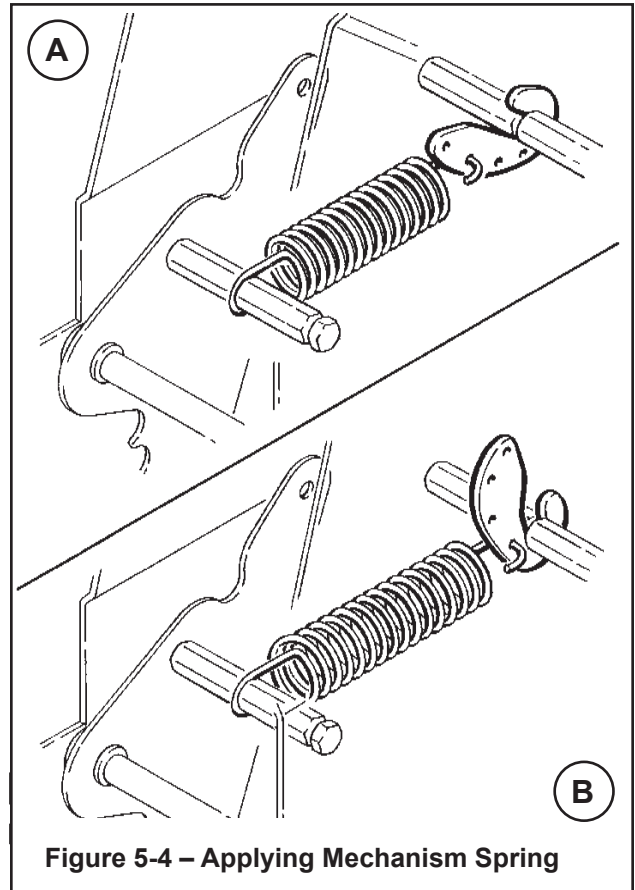


Figure 5-4 – Applying Mechanism Spring

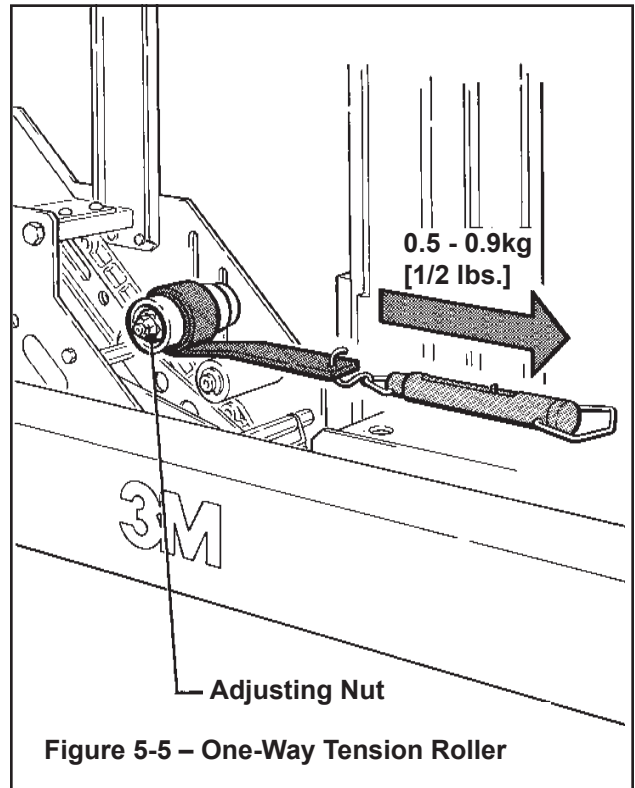


Figure 5-5 – One-Way Tension Roller

(Adjustments continued on next page.)



WARNING

- To reduce the risk associated with shear, pinch, and entanglement hazards:
- Turn air and electrical supplies off associated equipment before performing any adjustments, maintenance, or servicing the machine or taping heads.
- Never attempt to work on the taping head or load tape while the box drive system is running.

Tape Leg Length



WARNING

- To reduce the risk associated with sharp blade hazards:
- Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp

Leading Tape Leg Length Adjustment – Figure 5-6

The one-way tension roller position is adjustable to control the leading tape leg length.

Moving this roller farther away from the box top or bottom surface will decrease the leading leg length. Moving it closer to the box top or bottom surface will increase the leading leg length.

Changing Tape Leg Length from 70 to 50mm [2-3/4 to 2 Inches] – Figure 5-7

Note – When changing tape leg length, both upper and lower heads must be adjusted to apply the same leg lengths.

1. Remove and retain two hex head screws and remove the brush from normal position “A” on side frame.
2. Remount and secure brush in position “A-A” on side frame forward of normal location using original fasteners.
3. Remove cut-off bracket extensions from position “B”.
4. Remount cut-off bracket extensions in forward position “B-B”.
5. Remove and retain the one-way tension roller assembly from slot “C” in frame.
6. Remount tension roller assembly near top of slot “C-C” in frame using original fasteners.
7. Adjust tension roller according to “Leading Tape Leg Length Adjustment” above.

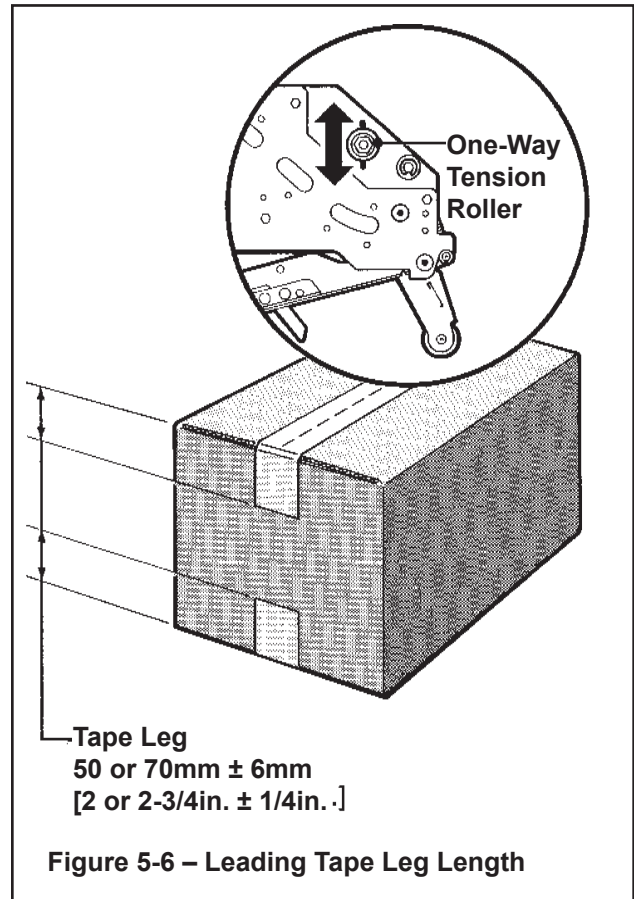


Figure 5-6 – Leading Tape Leg Length

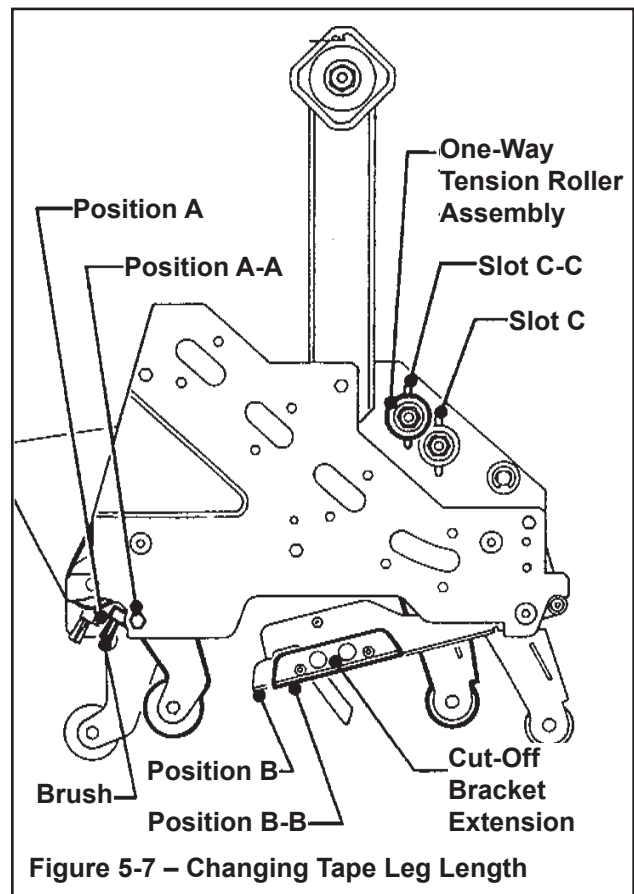


Figure 5-7 – Changing Tape Leg Length

Troubleshooting

Troubleshooting Guide

Problem	Cause	Correction
The tape leg on the front of the case is too long	The tape is threaded incorrectly	The tape must go around the wrap roller before going around the one-way tension roller
	The tape tension is too low	Adjust the one-way tension roller
	The knurled roller drags	Check for adhesive build-up between the knurled roller and its shaft. Clean and lubricate shaft. Remove all lubricant from roller surfaces.
	Tape tracks to one side or drags on the support tabs of applying frame	Adjust the tape web alignments
	The one-way tension roller is not correctly positioned	Position the roller in its mounting slot so that the tape extends just beyond the centerline of the applying roller
	Taping head is not set up properly	Check leg length adjustments
The blade does not cut tape or the tape end is jagged or shredded	The blade is dull and/or has broken teeth	Replace the blade
	Tape tension is insufficient	Increase tape tension by adjusting the one-way tension roller
	Adhesive has built up on the blade	Clean and adjust the blade
	The blade is not positioned properly	Make sure the blade is bottomed out against the mounting bolts
	The blade is dry	Lubricate the blade oiler pad on the blade guard
	The blade is in backwards	Mount the blade so that the beveled edge is away from the entrance of the head
	One or both cutter springs are missing or stretched	Replace the defective spring(s)
	Tension roller surface is not fully contacting the taping head frame	Make sure one-way bearing is below the surface of the tension roller. If not, press bearing further into roller or replace roller.

Troubleshooting (continued)

Troubleshooting Guide

Problem	Cause	Correction
Tape is tabbing on the trailing leg on the back of the box	There is excess tension on the tape drum assembly and/or the one-way tension roller assembly	Adjust the one-way tension roller and/or the tape drum assembly
	Rollers in the tape path do not rotate freely	Clean adhesive deposits from the surface, ends, and shafts of the rollers. Then lubricate roller shafts. Remove all lubricant from roller surfaces.
	The blade is not cutting tape properly	Refer to tape cutting problems
	The tape is threaded incorrectly	Re thread the tape
	Applying mechanism spring has too little tension	Move spring hook to next tighter hole
The tape end does not stay in application position in front of the applying roller	The tape is incorrectly threaded	Re thread the tape
	Flanged knurled roller overruns on return of applying mechanism to its rest position	Adjust tension roller position in mounting slot to lengthen tape leg
	Applying roller overruns on return of applying mechanism to its rest position	There should be a slight drag when rotating the applying roller. If not, check friction springs and/or friction pins and replace if necessary
	The one-way tension roller is not correctly positioned	Position roller in its mounting slot so that tape end extends beyond centerline of applying roller
	The one-way tension roller is defective	Replace the one-way tension roller
Tape not centered on box seam	Tape drum not centered	Reposition tape drum
	Centering guides not centered	Adjust centering guides
	Box flaps not of equal length	Check box specifications

Spare Parts/Service Information

Recommended Spare Parts

Listed are a set of spare parts that will periodically require replacement due to normal wear. These parts should be ordered to keep the taping heads in production:

AccuGlide™ 2+ STD 2 Inch Upper Taping Head

Qty.	Part Number	Description
4	78-8076-4500-3	Stud – Mounting
1	78-8070-1274-1	Spring – Upper Extension (Silver)
1	78-8017-9173-8	Blade – 65 mm/2.56 Inch
2	78-8052-6602-6	Spring – Cutter
1	78-8076-4726-4	Tool – Tape Threading

AccuGlide™ 2+ STD 2 Inch Lower Taping Head

Qty.	Part Number	Description
1	78-8017-9173-8	Blade – 65 mm/2.56 Inch
2	78-8052-6602-6	Spring – Cutter
4	78-8076-4500-3	Stud – Mounting
1	78-8070-1273-3	Spring – Lower Extension (Black)
1	78-8076-4726-4	Tool – Tape Threading

In addition to the above set of spare parts supplied with the taping head, it is suggested that the following spare parts be maintained which will require replacement under normal wear of the taping head.

Qty.	Part Number	Description
1	78-8057-6179-4	Roller – Applying
1	78-8057-6178-6	Roller – Buffing
1	78-8113-7030-9	Spring – Torsion

Replacement Parts and Service

Refer to the first page of this instruction manual “**Replacement Parts and Service Information**”.

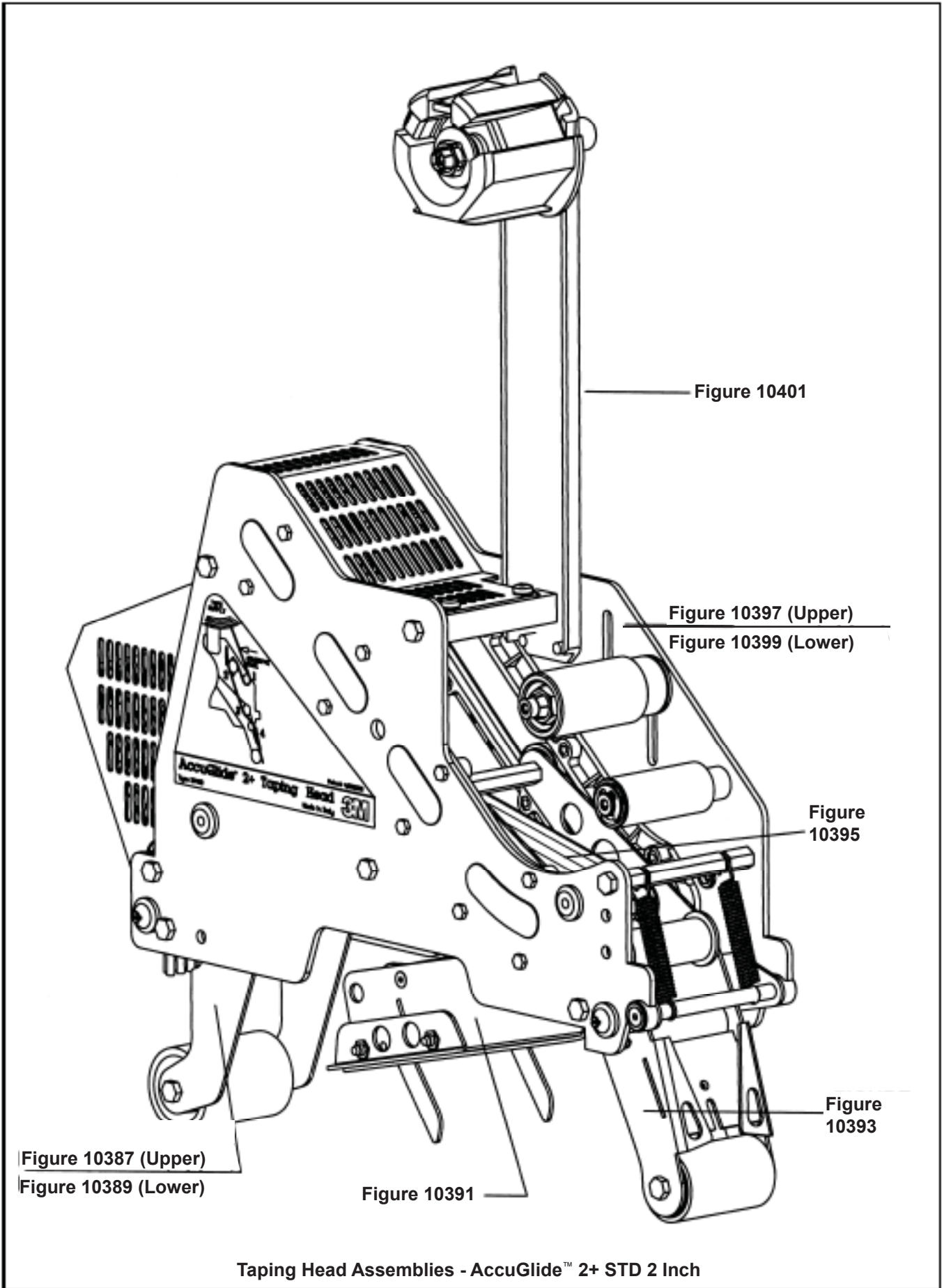
Replacement Parts Illustrations and Parts Lists
AccuGlide™ 2+ STD 2 Inch Upper Taping Head, Type 10500
AccuGlide™ 2+ STD 2 Inch Lower Taping Head, Type 10500

1. Refer to the **Taping Head Assemblies** Figure to find all the parts illustrations identified by **figure numbers**.
2. Refer to the figure or figures to determine the **individual parts** required and the **parts reference number**.
3. The **replacement parts list**, that follows each illustration, includes the **part number** and **part description** for the parts in 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, should the customer elect to do so.

4. 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 a special order basis. Contact 3M/Tape Dispenser Parts to confirm item availability.



Taping Head Assemblies - AccuGlide™ 2+ STD 2 Inch

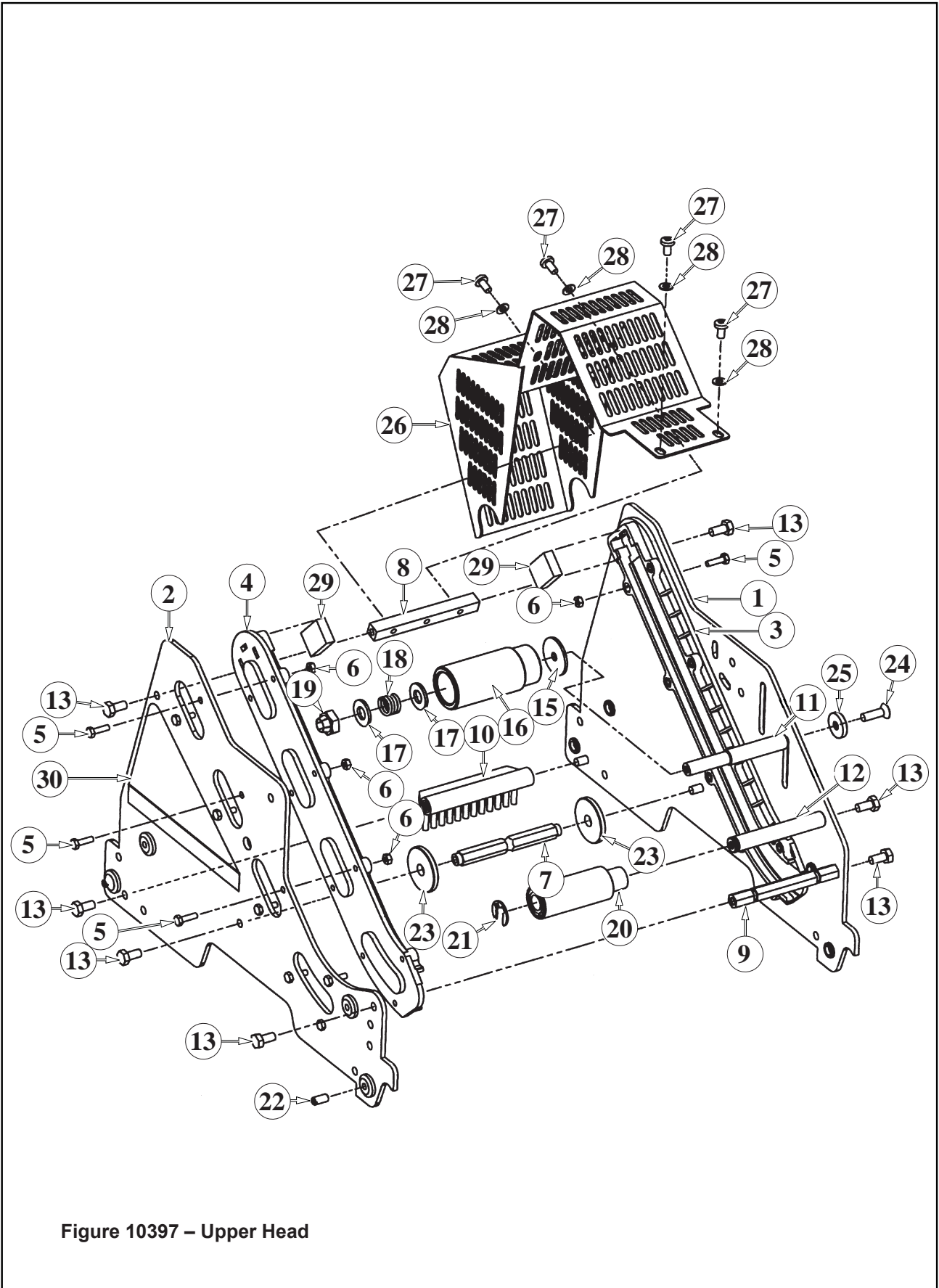


Figure 10397 – Upper Head

AccuGlide™ 2+ STD 2 Inch

Figure 10397 – 2" Upper Head

Ref. No.	3M Part No.	Description
10397-1	78-8133-9456-2	Frame – Tape Mount Upper Assembly
10397-2	78-8133-9458-8	Frame – Front Upper Assembly
10397-3	78-8068-4143-9	Guide – #1
10397-4	78-8068-4144-7	Guide – #2
10397-5	78-8060-7818-0	Screw – Hex Hd, M4 x 12
10397-6	78-8010-7416-8	Nut – Hex Jam, M4
10397-7	78-8070-1251-9	Spacer – Spring
10397-8	78-8054-8764-8	Spacer – 10 x 10 x 90 mm
10397-9	78-8052-6560-6	Spacer – Front
10397-10	78-8060-7936-0	Brush Assembly
10397-11	78-8052-6564-8	Shaft – Tension Roller
10397-12	78-8052-6568-9	Shaft – Wrap Roller
10397-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10397-15	78-8100-1009-6	Washer – Special
10397-16	78-8052-6565-5	Roller – Top Tension
10397-17	26-1004-5510-9	Washer – Plain, M10
10397-18	78-8052-6567-1	Spring – Compression
10397-19	78-8017-9077-1	Nut – Self Locking, M10 x 1
10397-20	78-8052-6569-7	Roller – Wrap
10397-21	26-1000-1613-3	Ring – Retaining, Tru-Arc #1-420-0120-100
10397-22	78-8076-4500-3	Stud – Mounting
10397-23	78-8076-5242-1	Stop – Cut-Off Frame
10397-24	78-8060-8179-6	Screw – Flat Hd Hex, M6 x 20
10397-25	78-8076-5477-3	Washer – Special /6.5 x 20 x 4
10397-26	78-8100-1047-6	Guard – Head
10397-27	78-8060-8087-1	Screw – M5 x 10
10397-28	78-8005-5741-1	Washer – Flat, M5
10397-29	78-8133-9615-3	Bumper
10397-30	78-8133-9605-4	Label – Threading, English Language

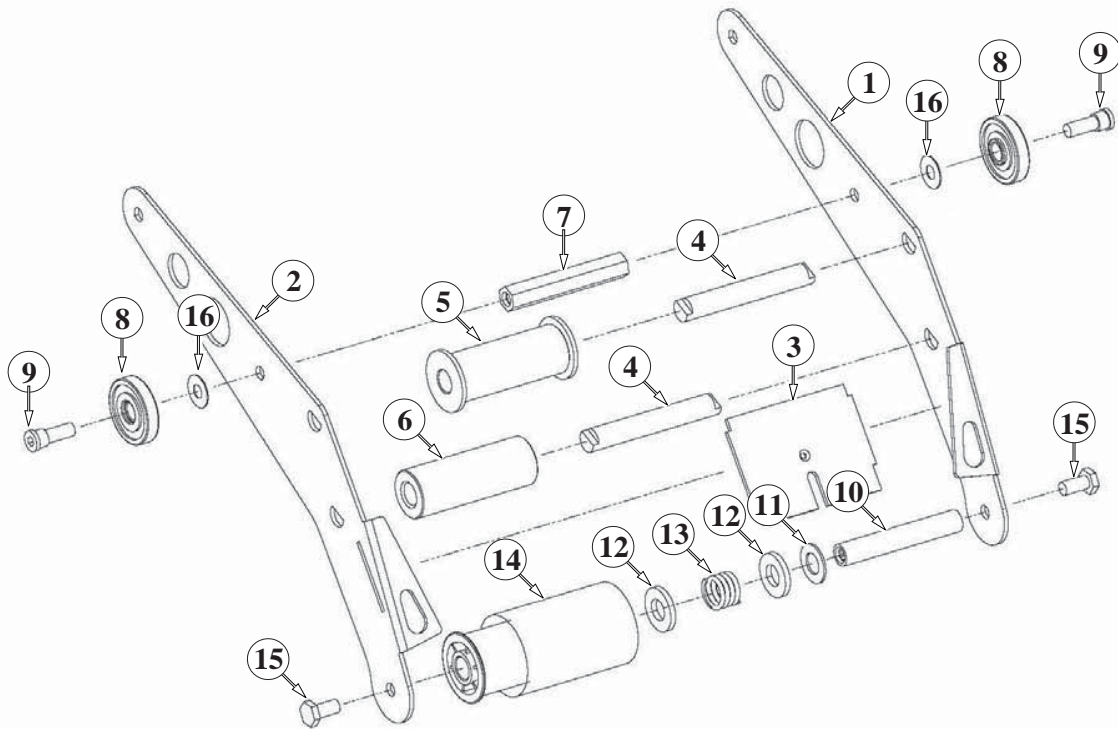


Figure 10393 – Upper and Lower Heads

AccuGlide™ 2+ STD 2 Inch

Figure 10393 – 2" Upper and Lower Heads

Ref. No.	3M Part No.	Description
10393-1	78-8133-9509-8	Applying Arm #1
10393-2	78-8133-9510-6	Applying Arm #2
10393-3	78-8070-1221-2	Plate – Tape
10393-4	78-8070-1309-5	Shaft Roller
10393-5	78-8070-1367-3	Roller – Knurled Assembly
10393-6	78-8070-1266-7	Roller – Wrap
10393-7	78-8052-6580-4	Spacer
10393-8	78-8017-9082-1	Bearing – Special, 30 mm
10393-9	78-8017-9106-8	Screw – Bearing Shoulder
10393-10	78-8052-6575-4	Shaft – Roller
10393-11	78-8017-9074-8	Washer – Nylon, 15 mm
10393-12	26-1004-5510-9	Washer – Friction
10393-13	78-8052-6567-1	Spring – Compression
10393-14	78-8137-1438-9	Assembly – Applying Roller
10393-15	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10393-16	78-8094-6151-6	Washer - Flat, 6.5 ID x 15 OD x 0.5 Thk

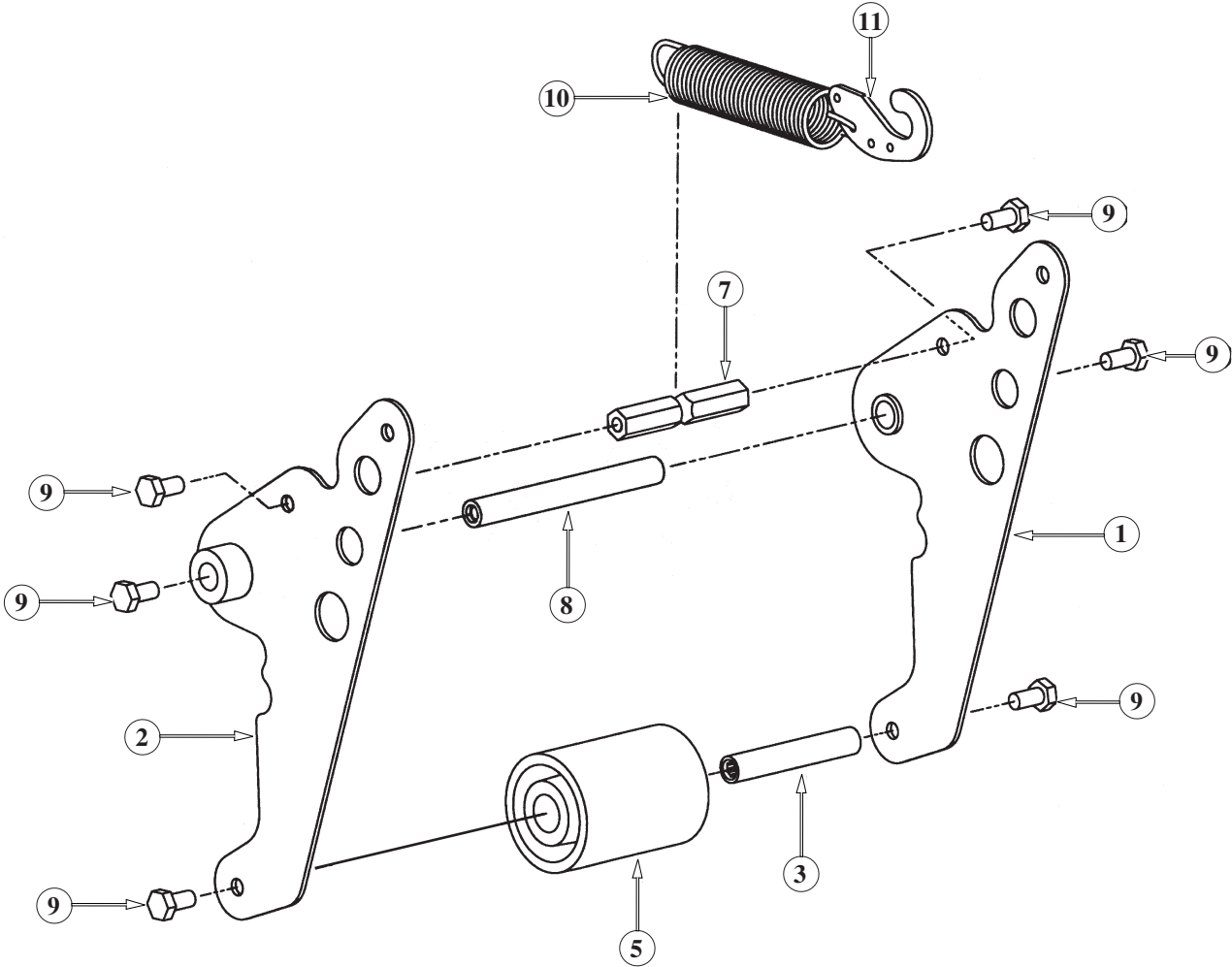


Figure 10387 – Upper Head

AccuGlide™ 2+ STD 2 Inch

Figure 10387 – 2" Upper Head

Ref. No.	3M Part No.	Description
10387-1	78-8070-1392-1	Buffing Arm – Sub Assembly
10387-2	78-8070-1391-3	Buffing Arm – Sub Assembly
10387-3	78-8052-6575-4	Shaft – Roller
10387-5	78-8137-1398-5	Roller - Buffing Assembly
10387-7	78-8070-1220-4	Spacer – Spring
10387-8	78-8017-9109-2	Shaft – 10 x 90 mm
10387-9	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10387-10	78-8070-1274-1	Spring – Upper (Silver)
10387-11	78-8070-1244-4	Holder – Spring

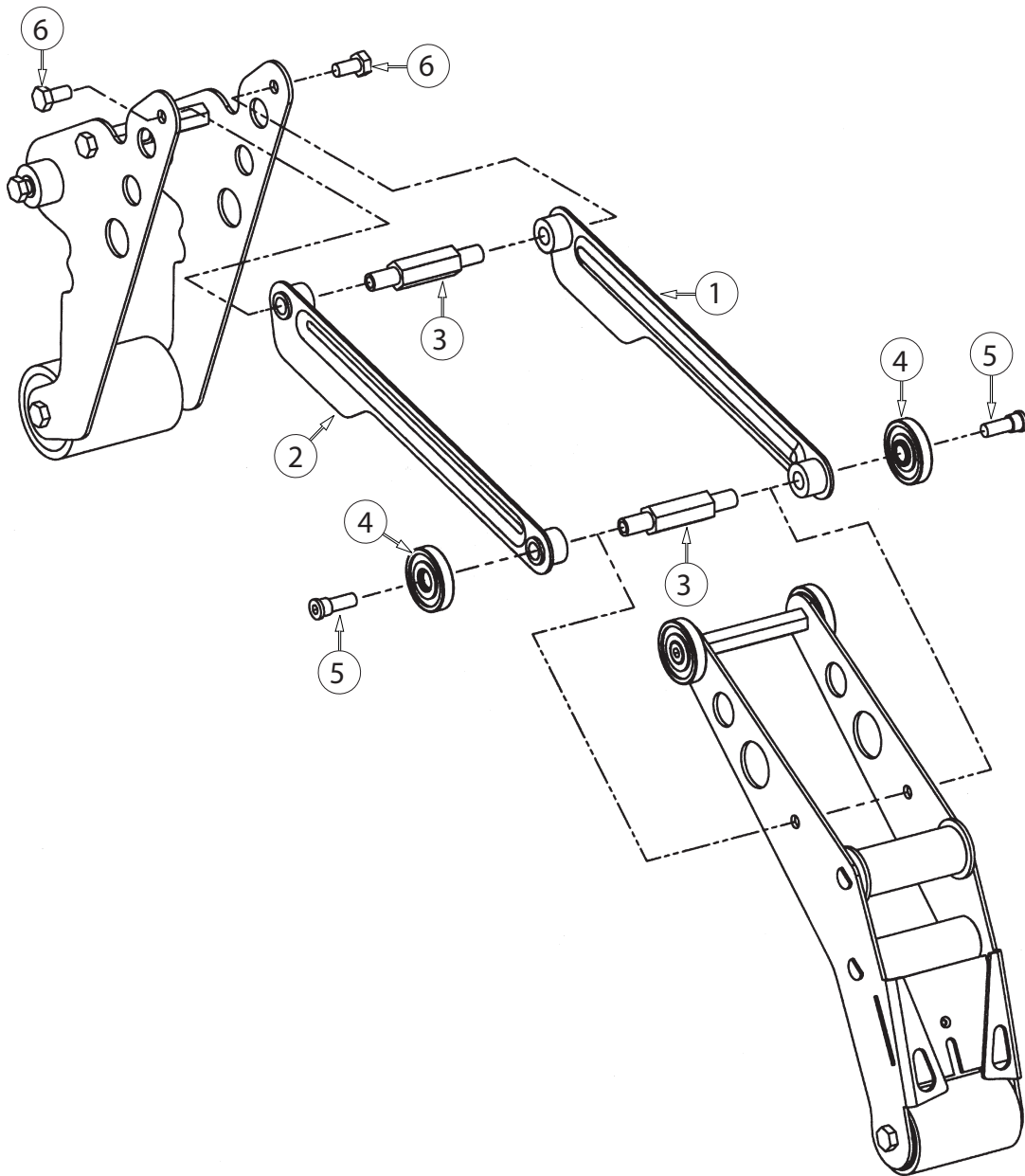


Figure 10395 – Upper and Lower Heads

AccuGlide™ 2+ STD 2 Inch

Figure 10395 – 2" Upper and Lower Heads

Ref. No.	3M Part No.	Description
10395-1	78-8070-1388-9	Link – Arm Bushing Assembly
10395-2	78-8070-1389-7	Link – Arm Bushing Assembly
10395-3	78-8070-1271-7	Shaft – Pivot
10395-4	78-8017-9082-1	Bearing – Special 30 mm
10395-5	78-8017-9106-8	Screw – Bearing Shoulder
10395-6	26-1003-5829-5	Screw – Hex Hd, M6 x 12

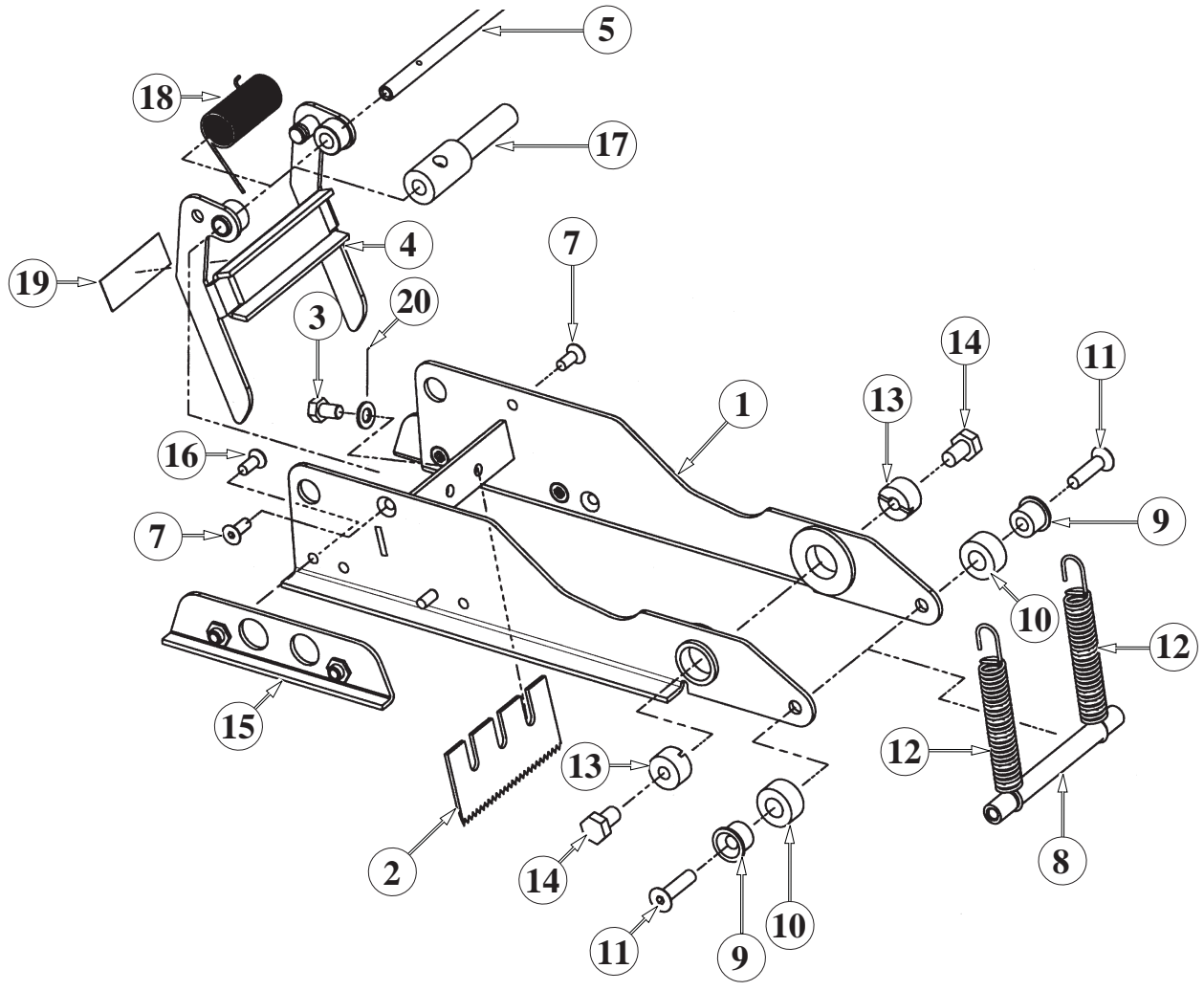


Figure 10391 – Upper and Lower Heads

AccuGlide™ 2+ STD 2 Inch

Figure 10391 – 2" Upper and Lower Heads

Ref. No.	3M Part No.	Description
10391-1	78-8070-1217-0	Frame – Cut-Off Weldment
10391-2	78-8017-9173-8	Blade – 65 mm/2.56 Inch
10391-3	26-1003-8596-7	Screw - Hex Hd M5 x 8 w/ Ext. Tooth Lockwasher
10391-4	78-8070-1371-5	Blade Guard Assembly – W/English Language Label
10391-5	78-8052-6597-8	Shaft – Blade Guard
10391-7	26-1005-4758-2	Screw – Flat Hd, Soc Dr, M4 x 10
10391-8	78-8017-9135-7	Shaft – Spacer
10391-9	78-8052-6600-0	Spacer
10391-10	78-8070-1269-1	Bumper
10391-11	26-1005-4757-4	Screw – Flat Hd, Soc Dr, M5 x 20
10391-12	78-8052-6602-6	Spring – Cutter
10391-13	78-8017-9132-4	Pivot – Cutter Lever
10391-14	26-1003-5828-7	Screw – Spec, Hex Hd, M6 x 10
10391-15	78-8070-1216-2	Slide – Extension
10391-16	26-1008-6574-5	Screw – Flat Hd, Phil Dr, M4 x 10
10391-17	78-8113-7031-7	Bushing – 58.5 mm Long
10391-18	78-8113-7030-9	Spring – Torsion
10391-19	78-8070-1335-0	Label – Warning, English

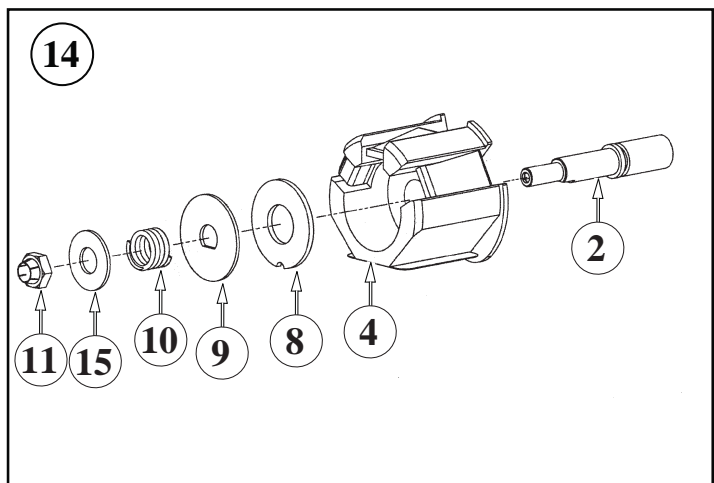
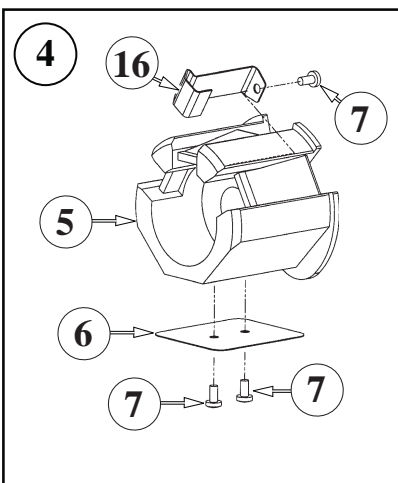
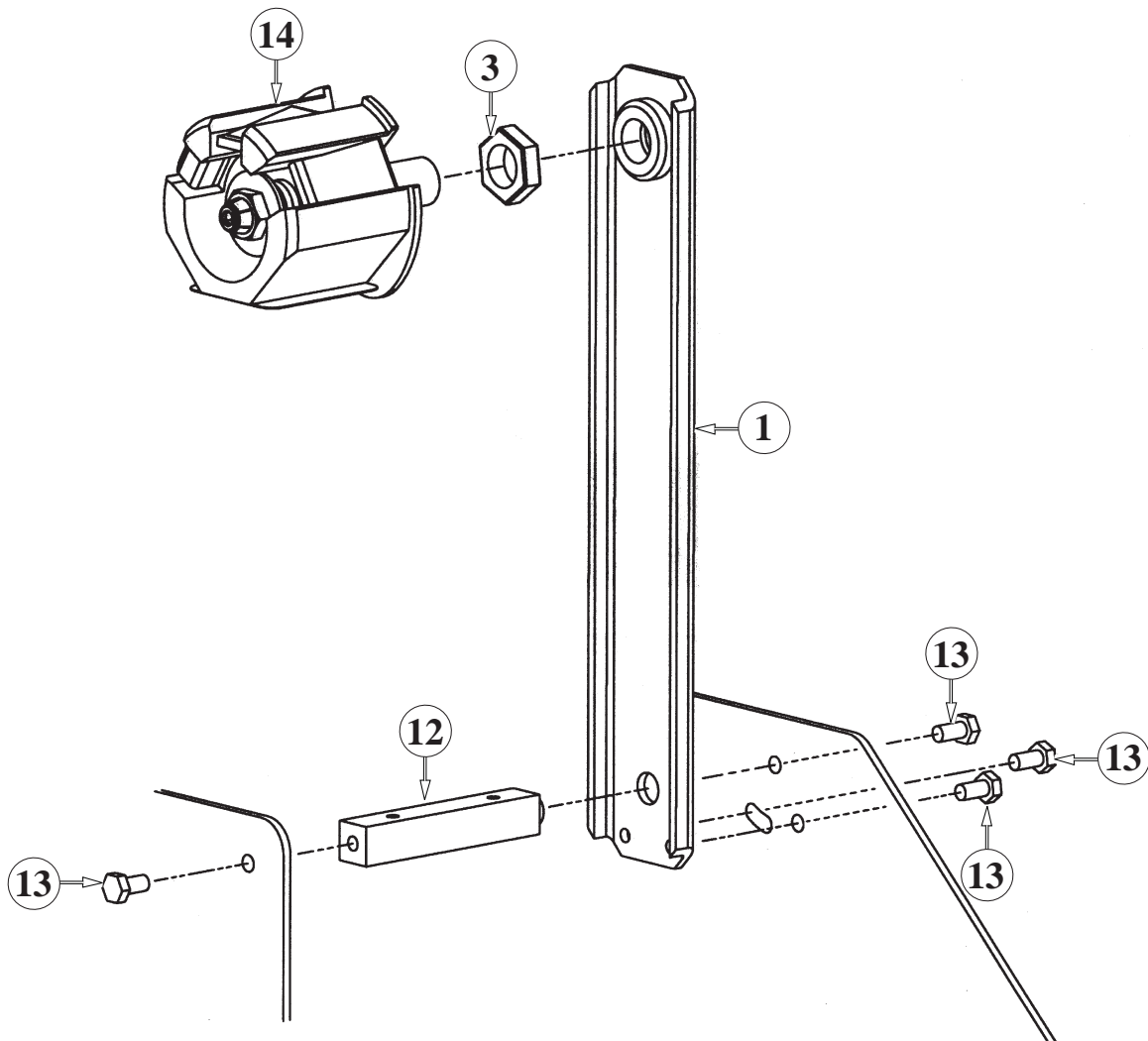


Figure 10401 – Upper and Lower Heads

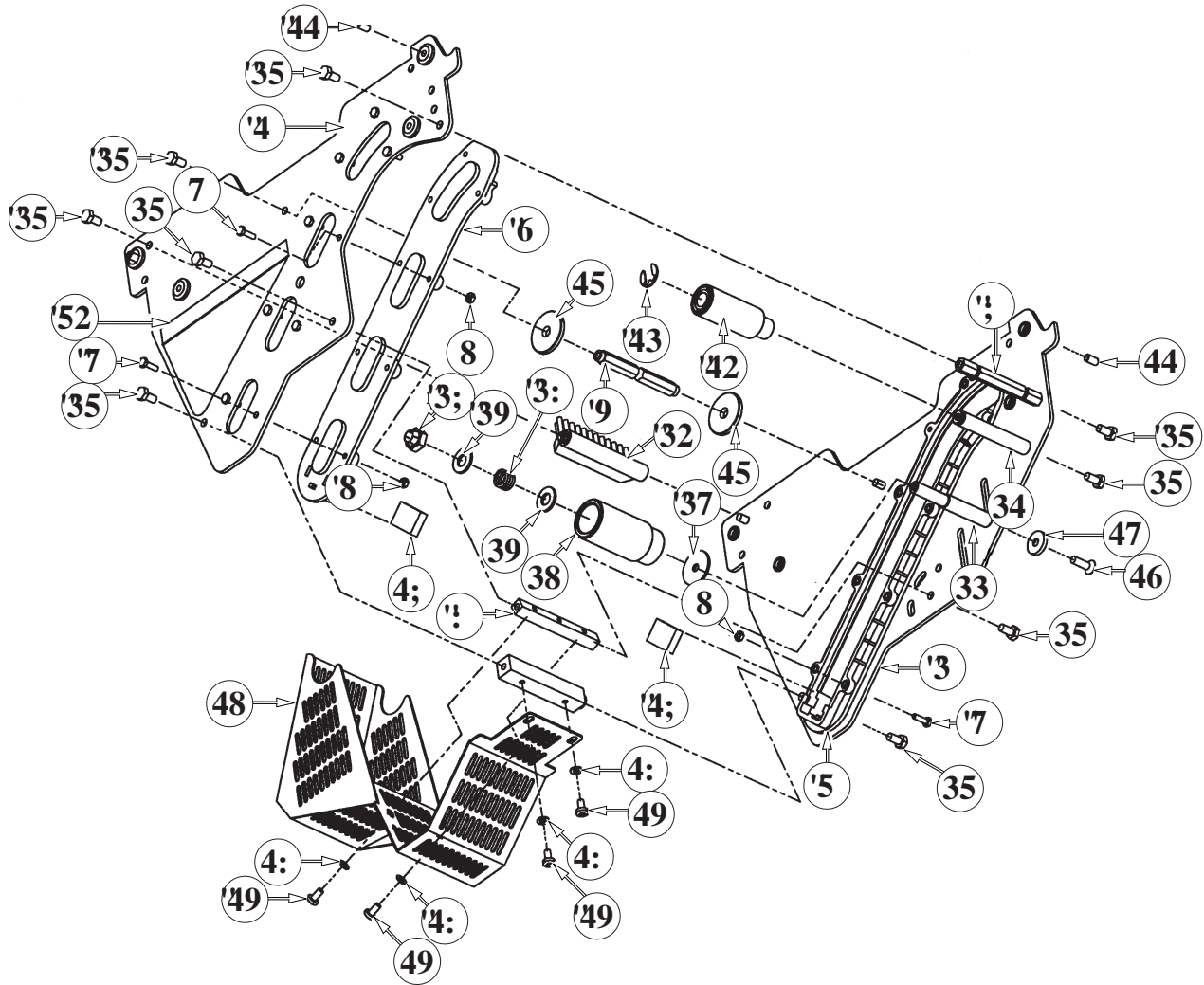


Figure 10399 – Lower Head

AccuGlide™ 2+ STD 2 Inch

Figure 10399 – 2" Lower Head

Ref. No.	3M Part No.	Description
10399-1	78-8133-9502-3	Frame – Tape Mount Lower Assembly
10399-2	78-8133-9500-7	Frame – Front Lower Assembly
10399-3	78-8068-4144-7	Guide – #2
10399-4	78-8068-4143-9	Guide – #1
10399-5	78-8060-7818-0	Screw – Hex Hd, M4 x 12
10399-6	78-8010-7416-8	Nut – Hex, M4
10399-7	78-8070-1251-9	Spacer – Spring
10399-8	78-8054-8764-8	Spacer – 10 x 10 x 90 mm
10399-9	78-8052-6560-6	Spacer – Front
10399-10	78-8060-7936-0	Brush Assembly
10399-11	78-8052-6564-8	Shaft – Tension Roller
10399-12	78-8052-6568-9	Shaft – Wrap Roller
10399-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10399-15	78-8100-1009-6	Washer – Special
10399-16	78-8052-6606-7	Roller – Tension Bottom
10399-17	26-1004-5510-9	Washer – Plain, M10
10399-18	78-8052-6567-1	Spring – Compression
10399-19	78-8017-9077-1	Nut – Self Locking, M10 x 1
10399-20	78-8052-6569-7	Roller – Wrap
10399-21	26-1000-1613-3	Ring – Retaining, Tru-Arc #1-420-0120-100
10399-22	78-8076-4500-3	Stud – Mounting
10399-23	78-8076-5242-1	Stop – Cut-Off Frame
10399-24	78-8060-8179-6	Screw – Flat Hd Hex, M6 x 20
10399-25	78-8076-5477-3	Washer – Special /6.5 x 20 x 4
10399-26	78-8100-1047-6	Guard – Head
10399-27	78-8060-8087-1	Screw – M5 x 10
10399-28	78-8005-5741-1	Washer – Flat, M5
10399-29	78-8133-9615-3	Bumper
10399-30	78-8133-9606-2	Label – Threading, English Language

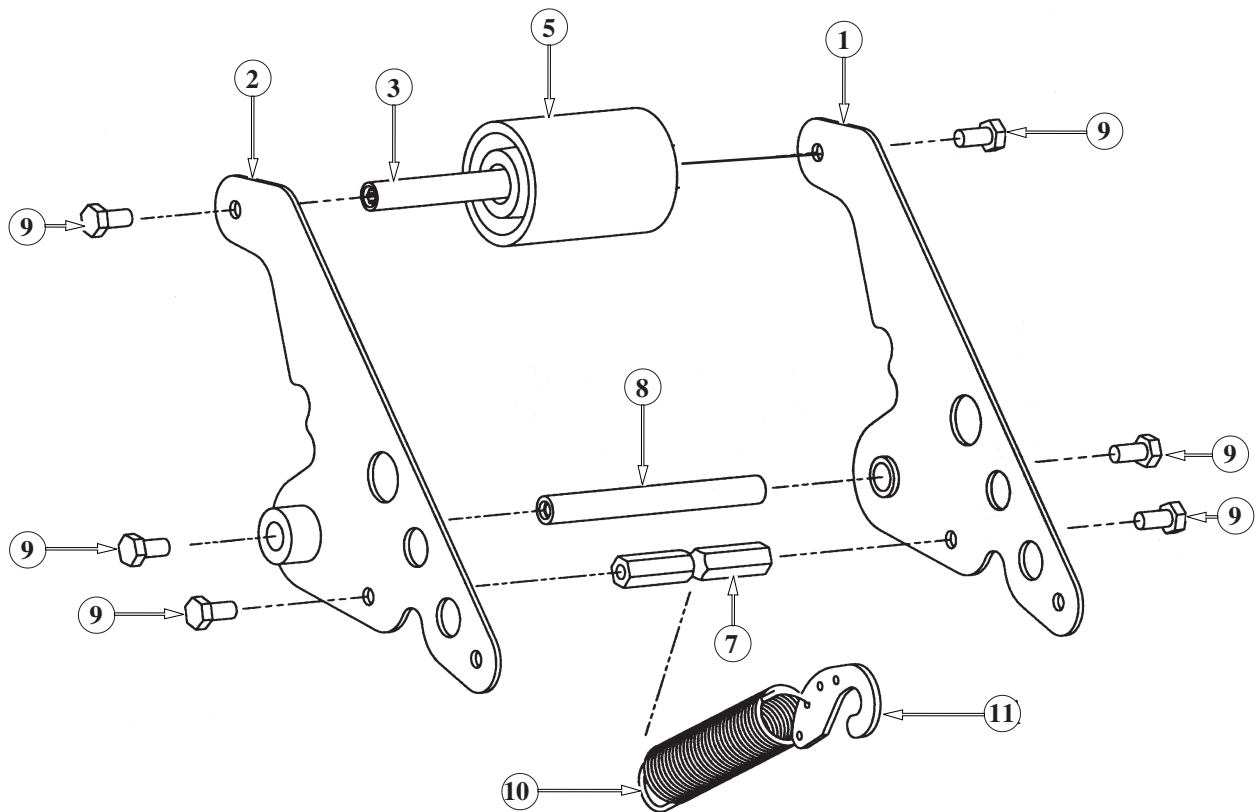


Figure 10389 – Lower Head

AccuGlide™ 2+ STD 2 Inch

Figure 10389 – Lower Head

Ref. No.	3M Part No.	Description
10389-1	78-8070-1391-3	Buffing Arm Sub Assembly, #1
10389-2	78-8070-1392-1	Buffing Arm Sub Assembly, #2
10389-3	78-8052-6575-4	Shaft – Roller
10389-5	78-8137-1398-5	Roller - Buffing Assembly
10389-7	78-8070-1220-4	Spacer – Spring
10389-8	78-8017-9109-2	Shaft – 10 x 90 mm
10389-9	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10389-10	78-8070-1273-3	Spring – Lower (Black)
10389-11	78-8070-1244-4	Holder – Spring

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