



Instructions and Parts List

3M-Matic™

800af Type 41100

**Adjustable
Case Sealer**

with

AccuGlide™ **3**
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
Printed in U.S.A.

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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™ 800af** Adjustable case sealer.

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

Edition February 2013

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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 800af - Type 41100 - Serial Number 13282).

Identification Plate

3M 3M Company St. Paul, MN 55144 USA		Part Number <input type="text"/>		3M-Matic™ For Commercial Use Only			 4000563
Model <input type="text"/>	Serial Number <input type="text"/>		Year <input type="text"/>	Ampere <input type="text"/>	Volt <input type="text"/>		
Type <input type="text"/>			Volt <input type="text"/>	Hertz <input type="text"/>	Phase <input type="text"/>		



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(For Taping Head Information - See MANUAL 2: AccuGlide™ 3 Taping Heads - 2 inch)

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TAPING HEAD INFORMATION -

MANUAL 2: AccuGlide™ 3 Taping Heads - 2 inch (See MANUAL 2 for Table of Contents)

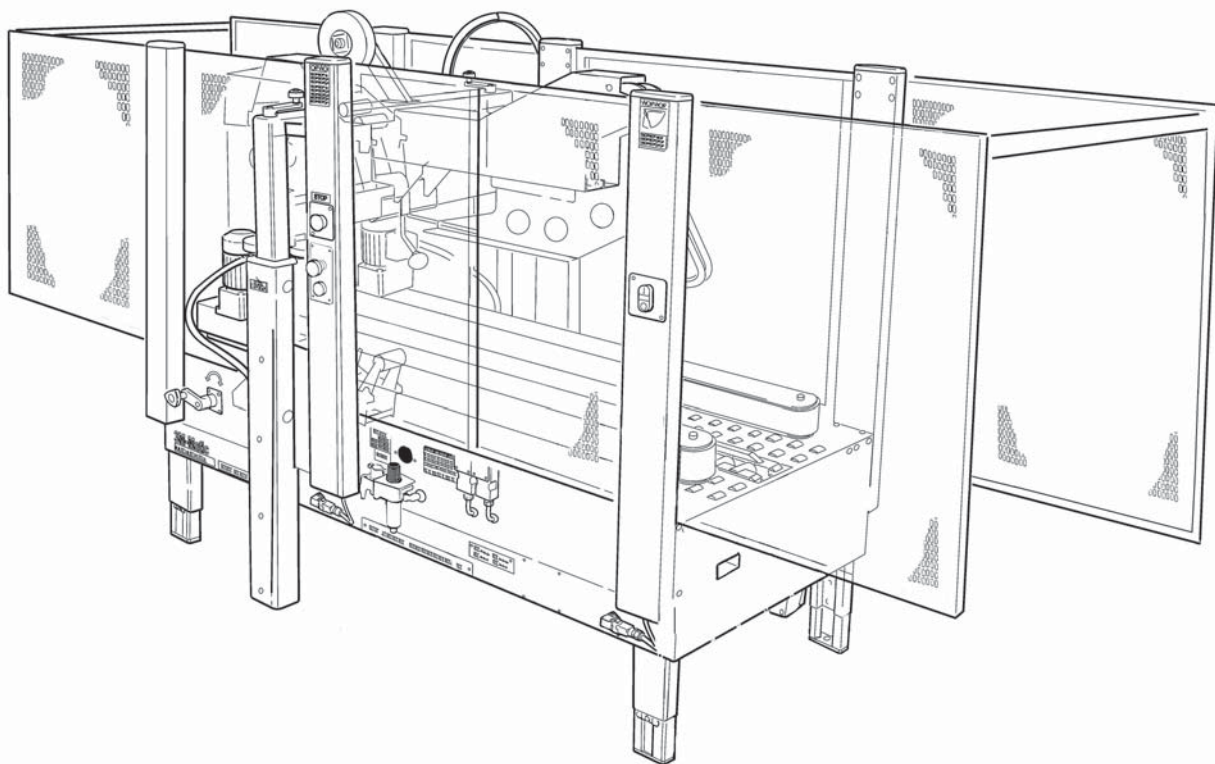
ABBREVIATIONS AND ACRONYMS

LIST OF ABBREVIATIONS, ACRONYMS

3M-Matic	- Trademark of 3M St. Paul, MN 55144-1000
Scotch	- Trademark of 3M St. Paul, MN 55144-1000
Drw.	- drawing
Ex.	- for example
Fig.	- 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
PTFE	- Polytetrafluorethelene
PU / PU-Foam	- Polyurethane Foam
PVC	- Poly-vinyl chloride
W	- Width
H	- Height
L	- Length

1.1 Manufacturing Specifications / Description / Intended Use

The **3M-Matic™ 800af Adjustable Case Sealer with AccuGlide™ 3 Taping Heads** automatically seals the top and bottom center seams of regular slotted containers without the need for an operator. 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. An integral gate provides the proper spacing of incoming boxes. Infeed conveyor speed must not exceed 0.5 m/s [100 F.P.M.] maximum. This machine also features an energy saving control. The machine has been designed and tested for use with **Scotch™** brand pressure-sensitive film box sealing tape.



3M-Matic™ 800af Adjustable Case Sealer, Type 41100

1-INTRODUCTION (continued)

1.1 Manufacturing Specifications / Description / Intended Use (continued)

The 3M-Matic™ case sealing machines have been designed and manufactured in compliance with the legal requirements at the date of inception.

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™ 800af Adjustable case sealer 3M Industrial Adhesives and Tapes Division 3M Center, Bldg. 220-5E-06 St. Paul, MN 55144-1000 (USA) Edition February 2013 Copyright 3M 2013 All rights reserved. The manufacturer reserves the right to change the product at any time without notice Publication ©

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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. In case 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.

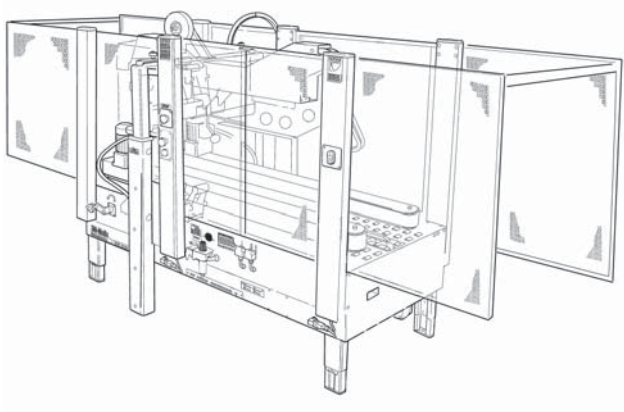
2-GENERAL INFORMATION

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)



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

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™ 800af Adjustable Case Sealer, Type 41100** 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 – 800af Adjustable Case Sealer

- (1) **800af** Adjustable Case Sealer, Type 41100
- (1) Tool/Spare Parts Kit
- (1) Instruction and Parts Manual

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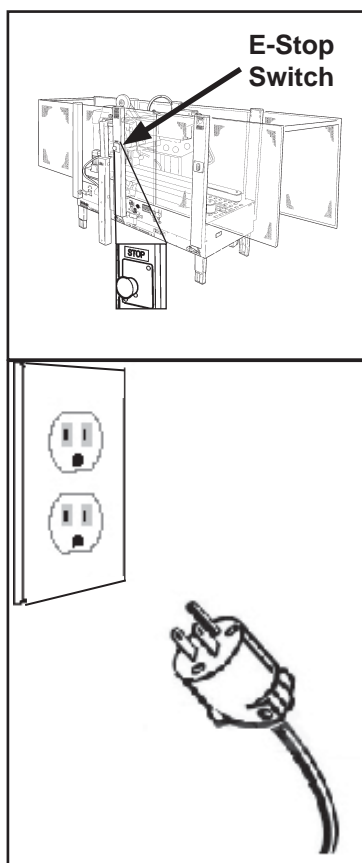
3-SAFETY

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 seal – 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.


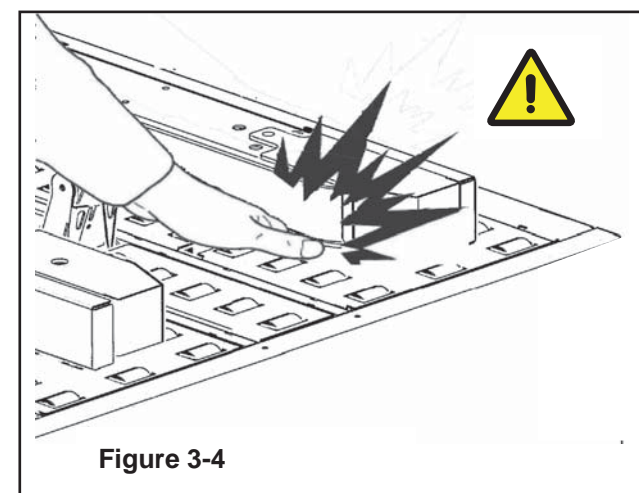
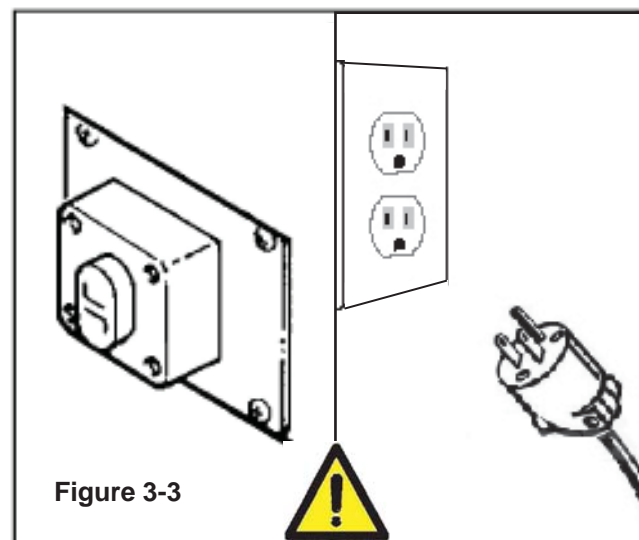
	SAFETY INSTRUCTIONS <ol style="list-style-type: none"> 1. Shut off machine before adjusting 2. Unplug electric power before servicing 3. Do not leave machine running unattended 4. Refer to instruction manual for complete setup, operating, and servicing information
---	---

Figure 3-2



Important! Cavity in the conveyor bed. Never put your hands inside any part of the machine while it is working. Serious injury may occur (Figure 3-4).



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! Tape cutting blade. Never remove the safety device which covers the blade on the top and bottom taping units. Blades are extremely sharp. Any error may cause serious injuries (**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.



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, jewelry away from moving belts and taping heads.

Important! Side flap compression rollers. Never keep hands on the box while it is driven by the belts (**Figure 3-7**).

Important! Drive belts. Never work on the machine with loose hair or loose garments such as scarfs, ties or sleeves (**Figure 3-8**).

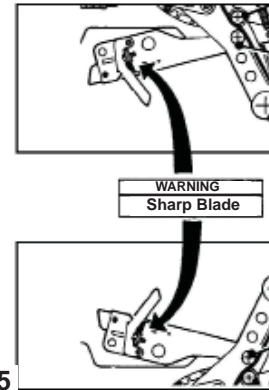


Figure 3-5

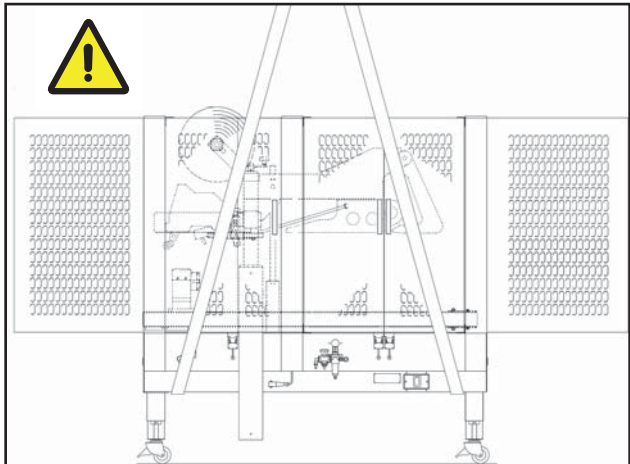


Figure 3-6

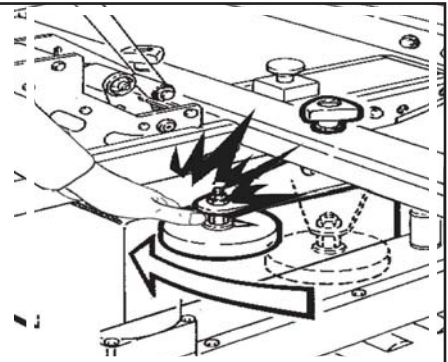


Figure 3-7

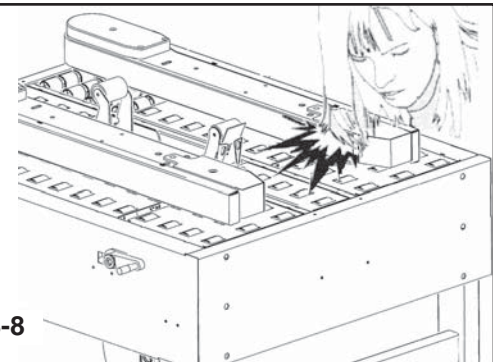


Figure 3-8

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 **800af** incorporates various safety protections which should never be removed or disabled. It is essential that the operator and service personnel be warned that 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. He 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.
- 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.
- 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.

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: <ul style="list-style-type: none"> – 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 - Important Safeguards

3.12 Component Locations

Refer to **Figure 3-9** below to acquaint yourself with the various components and controls of the case sealer. Also refer to Manual 2 for taping head components.

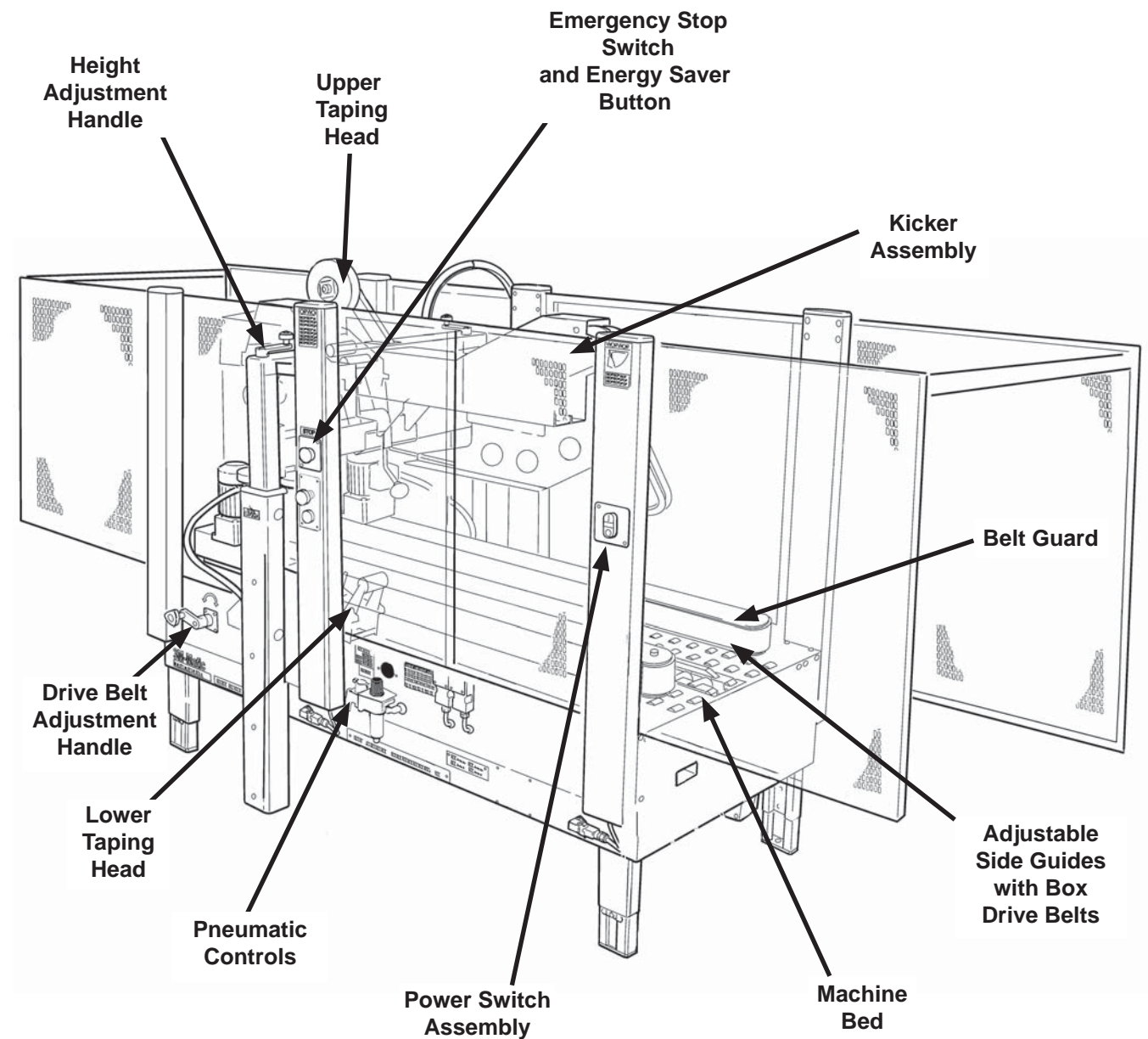


Figure 3-9 800af Case Sealer Components (Left Front View)

3.13 Warning Labels

Important – In the event the following safety labels are damaged or destroyed, **they must be replaced to ensure operator safety**. A label kit is available as a stock item or individual labels can be ordered (**Figure 3-10**).

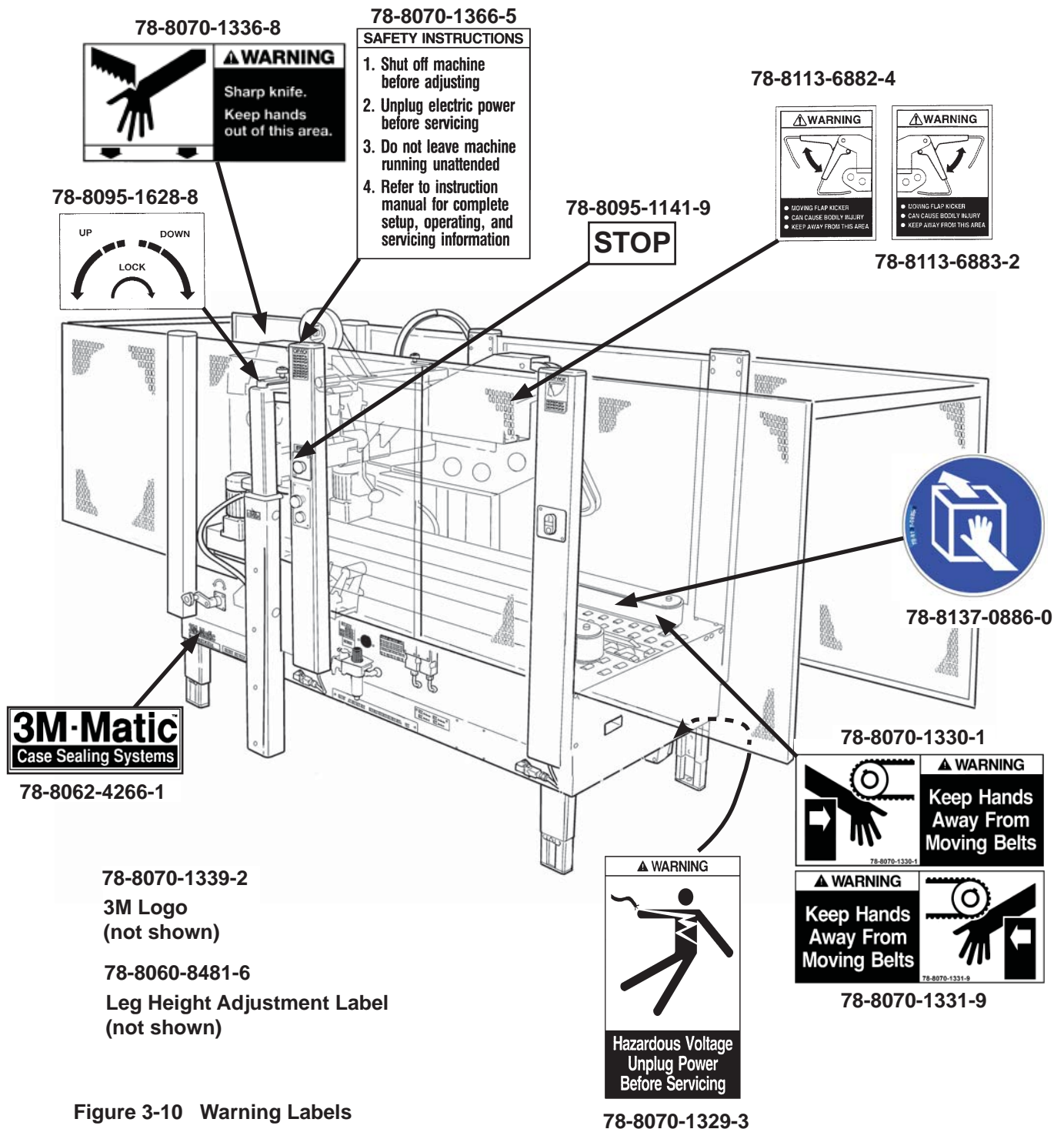


Figure 3-10 Warning Labels

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4 - Specifications

4.1 Power Requirements:

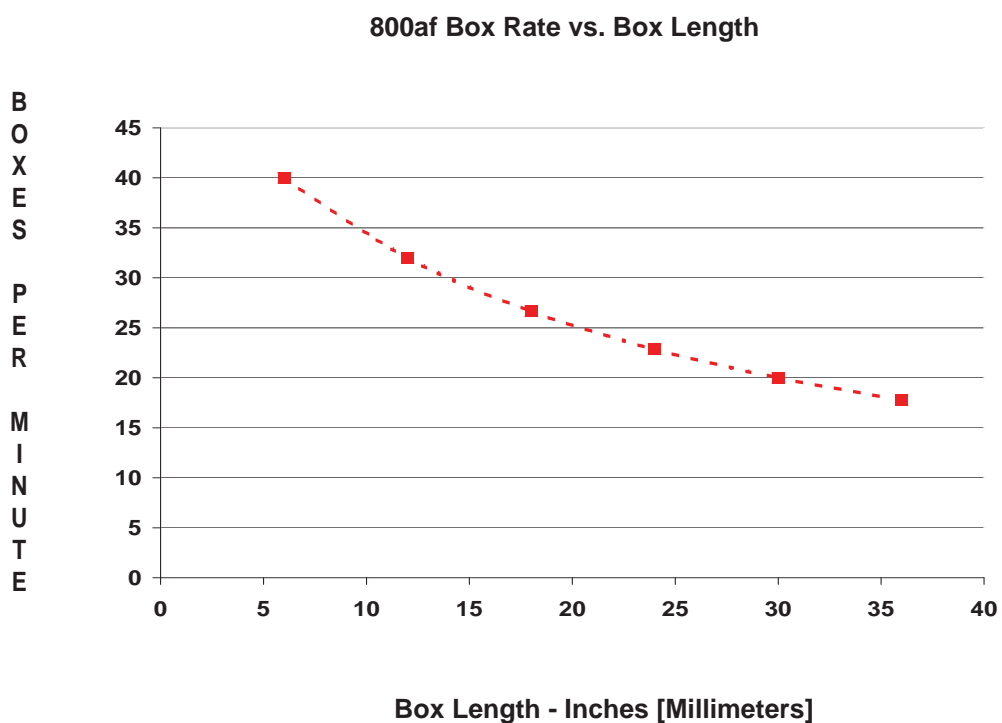
Electrical: 120 VAC, 60 Hz, 6A

Pneumatic: 5 bar gauge pressure [70PSIG]

110 liter/min @ 21°C, 1.01 bar [3.75 SCFM] at 15 boxes per minute

A pressure regulator is included

4.2 Operating Rate:



* Approximate, dependent on infeed conditions.

Note: Machine is shipped with both cams (A and B) installed. To obtain production rate shown with dotted line (cam A only), cam B must be removed. See "Adjustments – Gate Operation".

(continued)

4 - Specifications (continued)

4.3 Operating Conditions:

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

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

4.4 Tape:

Scotch™ brand pressure-sensitive film box sealing tapes.

4.5 Tape Width:

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

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™** brand film tapes.)

4.7 Tape Application Leg Length – Standard:

70mm ± 6mm [2-3/4 inch ±1/4 inch]

Tape Application Leg Length – Optional:

50mm ± 6mm [2 inch ±1/4 inch] (See "Special Setup 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 B or C flute.

(continued)

4 - Specifications (continued)

4.9 Box Weight and Size Capacities:

A. Box Weight, filled – contents must support flaps.

Minimum – weight must be sufficient to hold carton on the conveyor bed with bottom flaps fully closed or 1.4 kg [3 lb.] minimum.

Maximum – 40 kg [85 lb.]

B. Box Size:

Minimum: Length – 150mm [6 inches]
Width – 120mm [4-3/4 inches]
Height – 120mm [4-3/4 inches]*

Maximum: Length – 760mm [30 inches]
Width – 545mm [21-1/2 inches]
Height – 620mm [24-1/2 inches]**

* 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 195mm [7-3/4 inches]. See "Special Setup Procedure - Changing the Tape Leg Length".

** With columns adjusted to upper position, maximum box height increase to 725mm [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 is designed to accommodate most boxes complying with the 1976 FBA and PMMI*** voluntary standard "Tolerances for Top Opening" regular slotted containers (RSC).

Two of the requirements of the standard are the following:

1. The box length is not more than twice the box width.
2. The box length is not more than four times the box depth.

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.

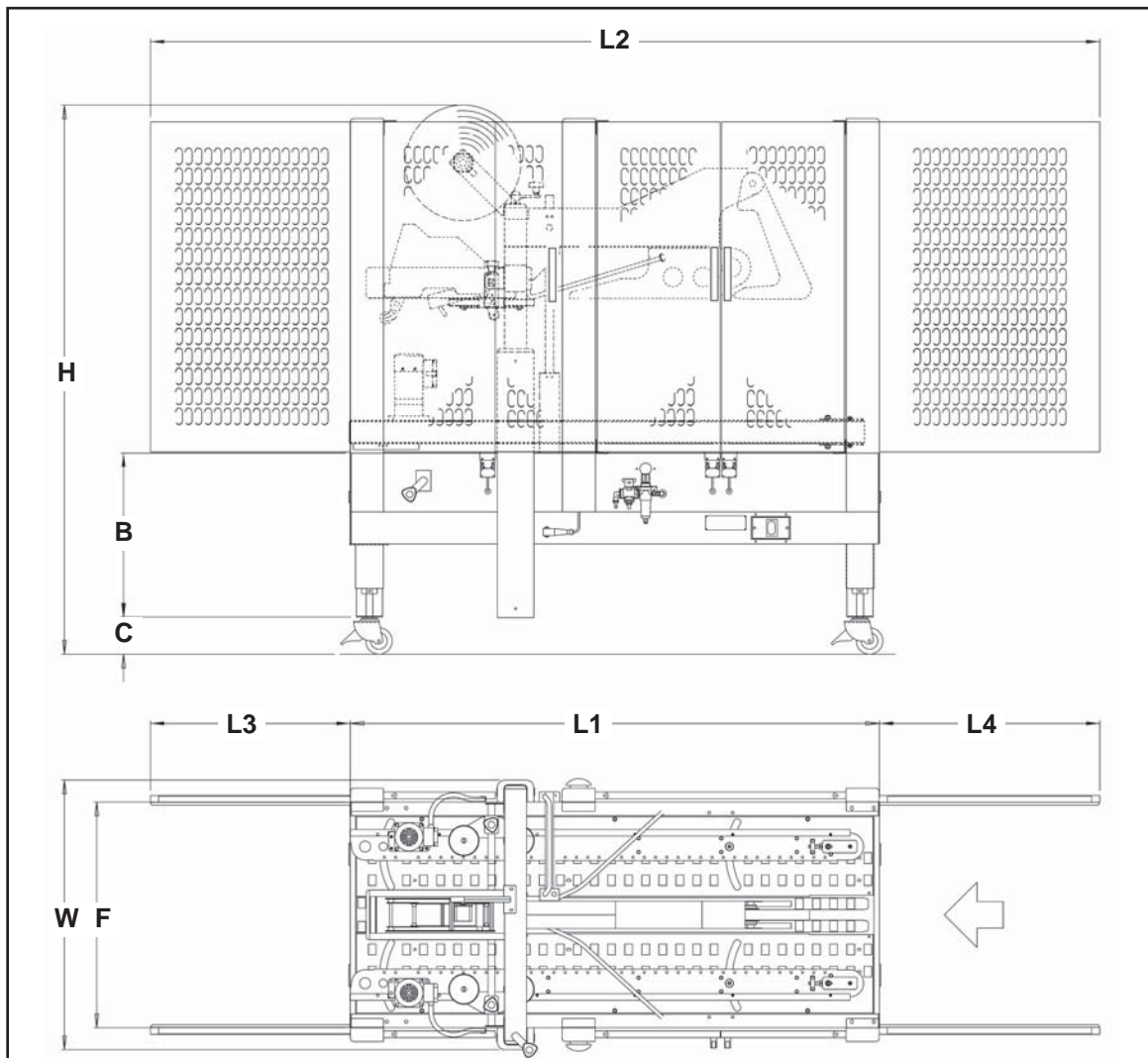
***Fibre Box Association, Packaging Machinery Manufacturer's Association

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

BOX LENGTH IN DIRECTION OF SEAL **MUST BE GREATER THAN .6**
BOX HEIGHT

If any of the above criteria are not met boxes should be test run to assure proper machine performance.

(continued)



4.10 Machine Dimensions

	W	F	H	L1	L2	L3	L4	B	C
mm	985	825	1575-2185	1920	3445	725	800	610-890	135
Inches	38-3/4	32-1/2	62-86	75-5/8	135-5/8	25-1/2	31-1/2	24-35	5-1/4 (Optional)

Weight – approximate 176.9 kg [390 pounds] crated
 approximate 371.8 kg [820 pounds] uncrated

4.11 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).

4.12 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 2 machines (**Figure 5-2**).

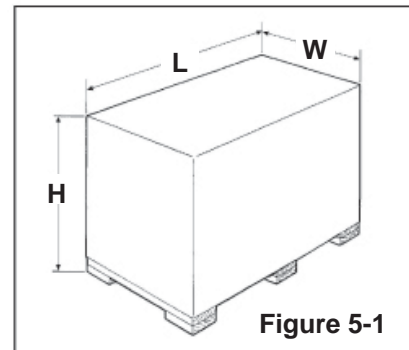


Figure 5-1

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.

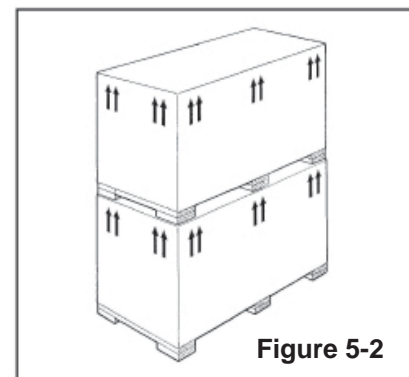


Figure 5-2

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 5-4**).

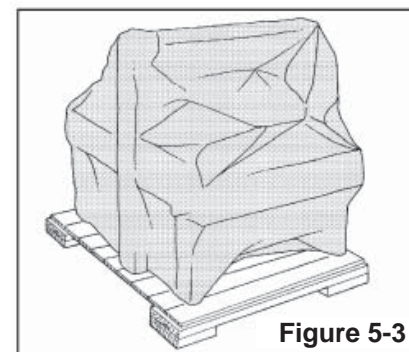


Figure 5-3

5.4 Storage of the Packed or Unpacked Machine

If the machine is not used for a long period, please take the following precautions:

- Store the machine in a dry and clean place.
- If the machine is unpacked it is necessary to protect it from dust.
- Do not stack anything over the machine.
- It is possible to stack a maximum of 2 machines (if they are in their original packing).

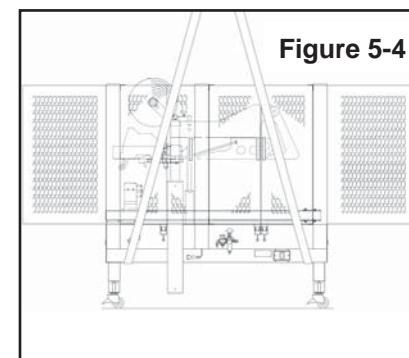
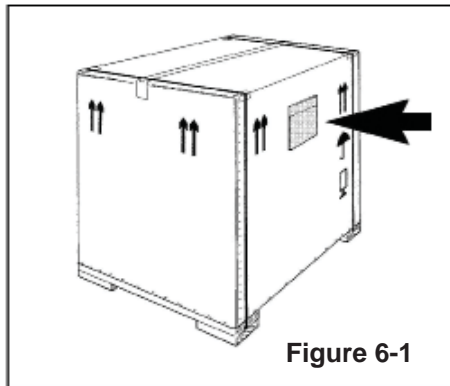


Figure 5-4

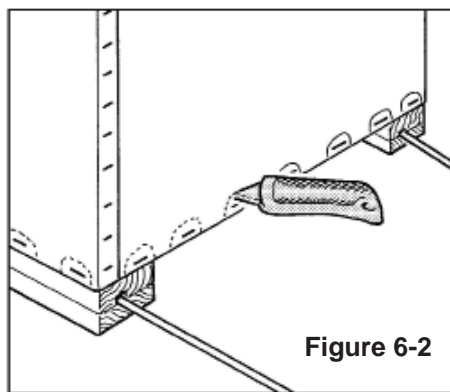
6-UNPACKING

6.1 Uncrating

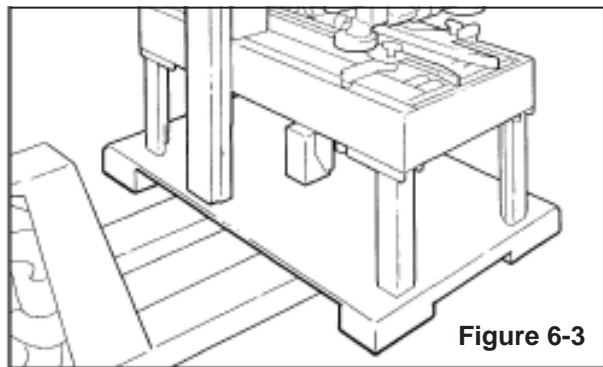
The envelope attached to the shipping box contains the uncrating instructions of the machine (**Figure 6-1**).



Cut straps. Cut out staple positions along the bottom of the shipping box (or remove staples with an appropriate tool - **Figure 6-2**)



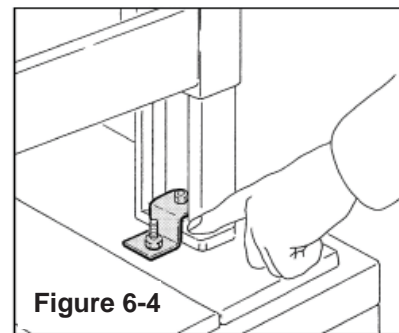
After cutting out or removing the staples, lift the shipping box in order to clear the machine (two persons required).



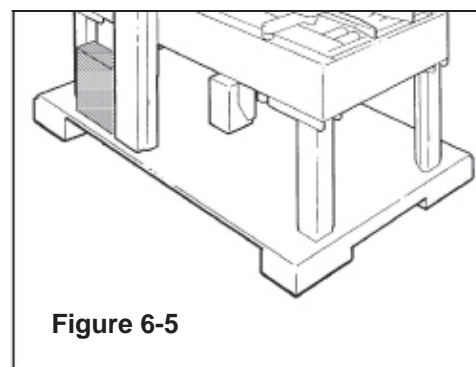
Transport the machine with a fork-lift truck to the operating position. Lift the pallet at the point indicated in **Figure 6-3** (weight of machine + pallet = See **Specifications**).

Removal of Pallet

Using a 10mm combination wrench, remove the fasteners that secure the case sealer legs to pallet (as shown in **Figure 6-4**).



A package is located under the machine body. Retrieve the instruction manual for additional procedures of the setup. The package also contains parts removed for shipping, spare parts and tools (**Figure 6-5**).



6.2 Disposal of Packaging Materials

The **800af** 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

The machine should operate in a dry and relatively clean environment (See Specifications).

7.2 Space Requirements for Machine Operation and Maintenance Work

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

A = 1000mm.

B = 700mm.

Minimum height = 2700mm.

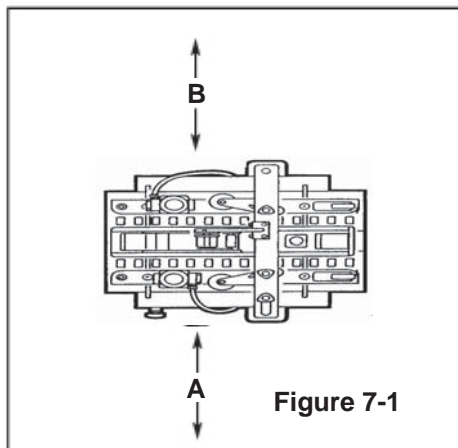


Figure 7-1

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 setup the machine, however, other tools supplied by the customer will be required for machine maintenance.

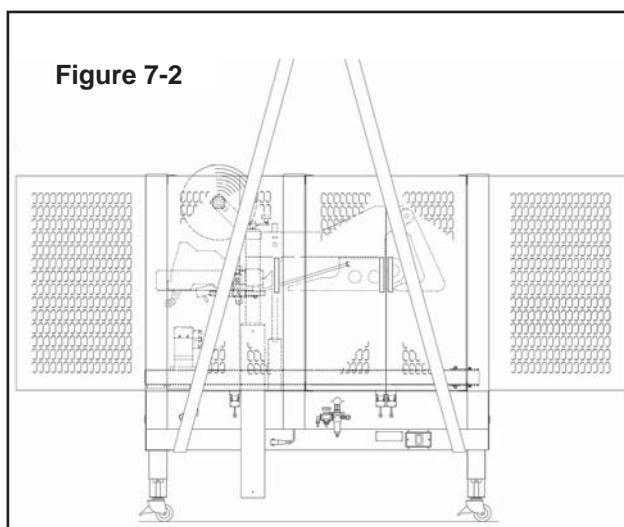


Figure 7-2



WARNING

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



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 Setup / Bed Height

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 (see specifications).

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.

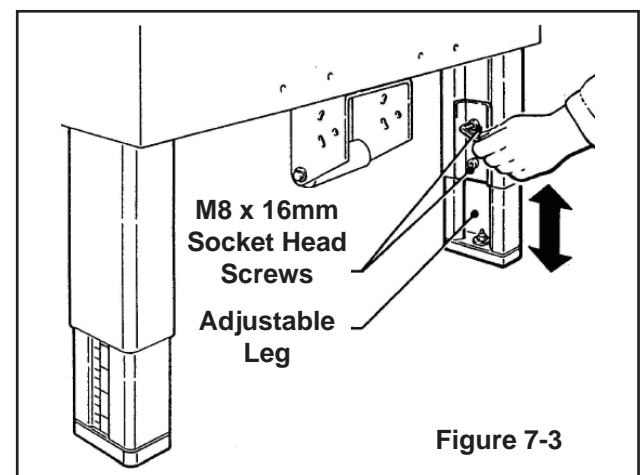
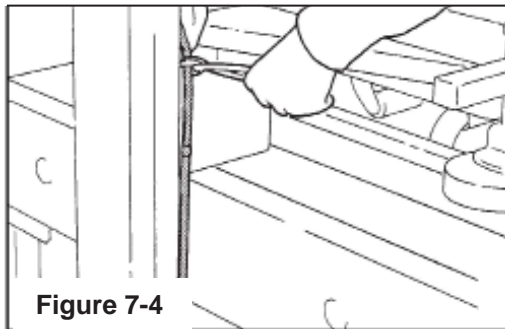


Figure 7-3

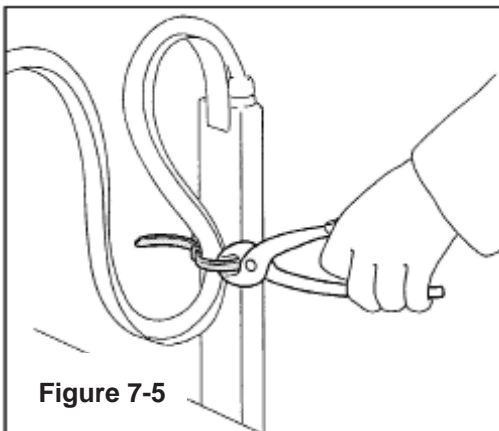
7-INSTALLATION (continued)

7.5 Removal of Plastic Ties

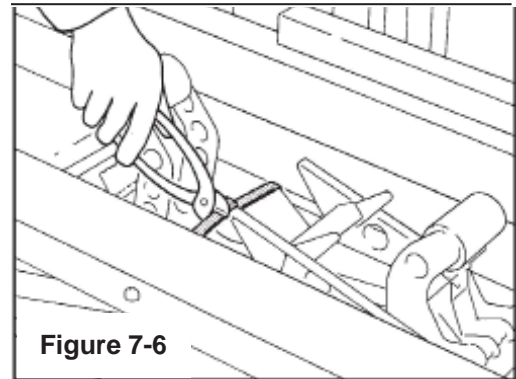
Cut the plastic which attaches the top head to the frame and remove the polystyrene blocks (**Figure 7-4**).



Cut the plastic strap which attaches the strip and the EMERGENCY STOP cable to the frame (**Figure 7-5**).



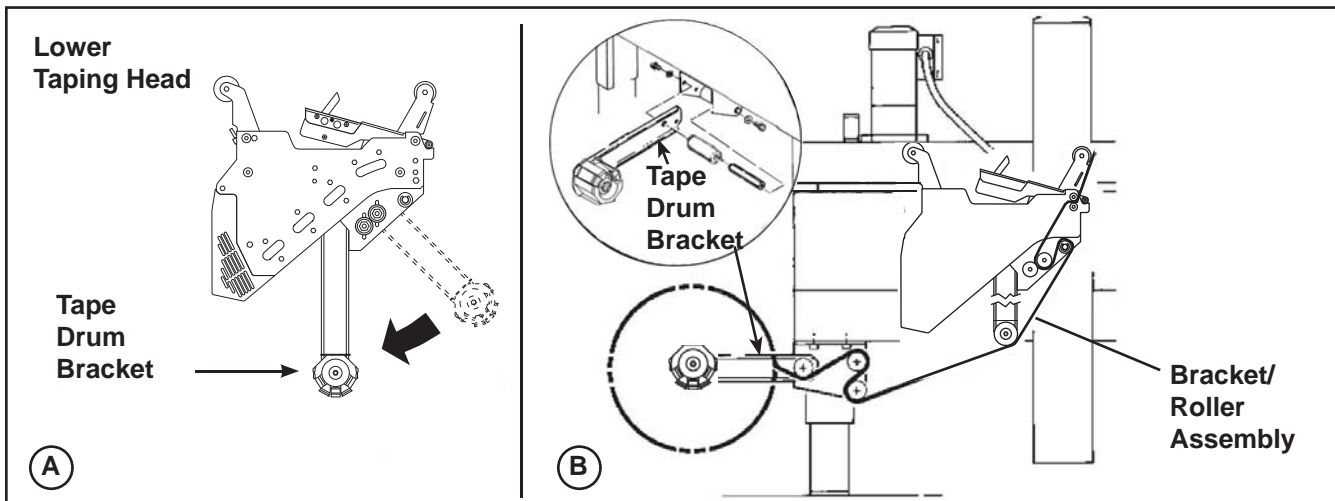
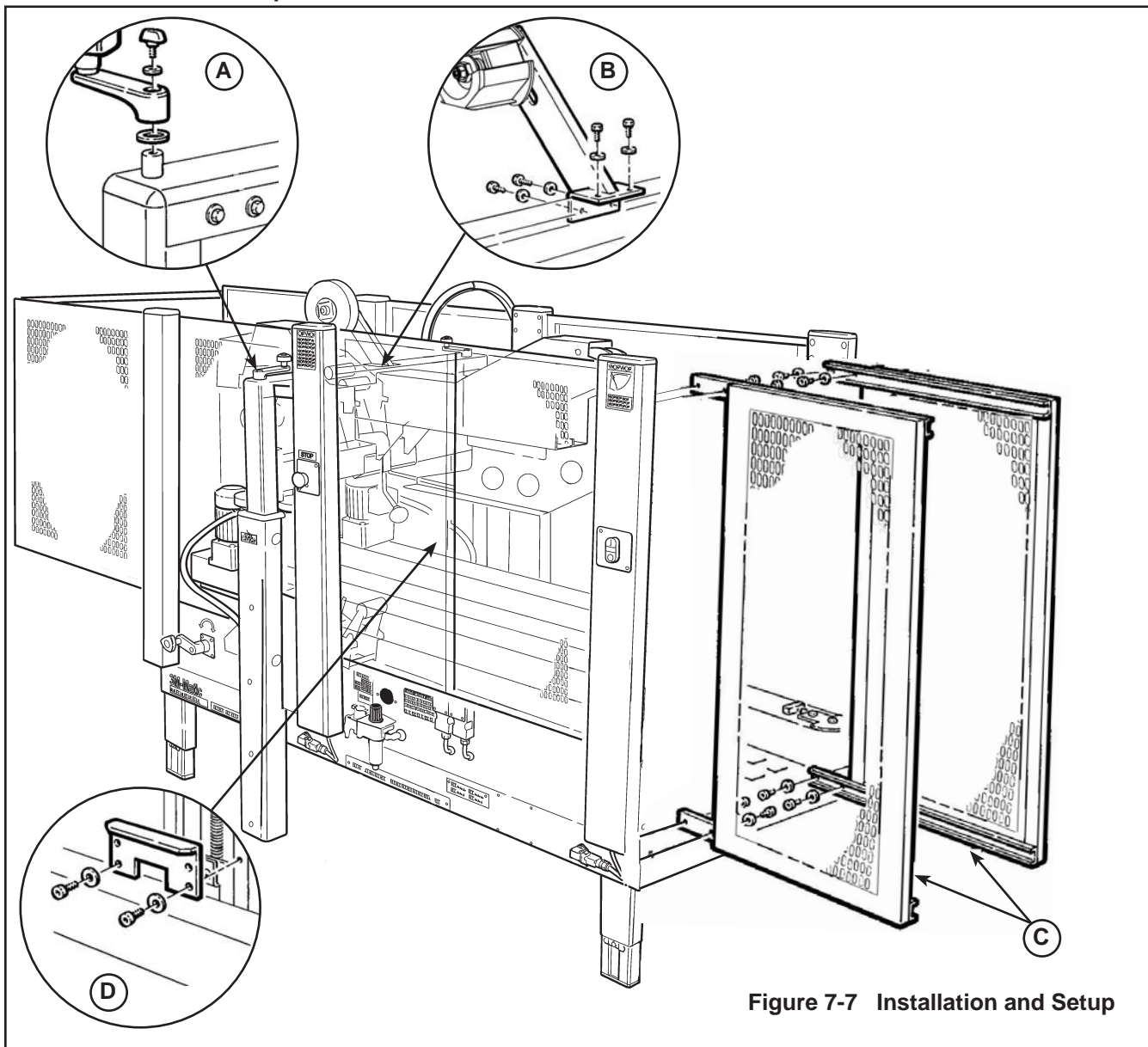
Cut the plastic ties holding the lower taping head in position (**Figure 7-6**).



7.6 Assembly Completion

- 1 Crank - Install the crank handle on the top of the left column as shown (**Figure 7-7A**).
- 2 Tape Drum Bracket - Install the upper tape drum bracket on the top cross bar as shown (**Figure 7-7B**).
- 3 Stop Bracket - Raise upper head assembly (turn crank handle counterclockwise) and install the two stop brackets (provided in the parts bag). Use lower set of holes as shown in **Figure 7-7D**. The upper set of holes should only be used when both taping heads are adjusted to apply 50mm tape legs.

7.7 Installation and Setup



7.8 Completion of Taping Heads

See Manual 2 for Complete Instructions:

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

7.9 Outboard Tape Roll Holder

If you intend to use the outboard tape roll holder, proceed as follows:

- 1 - Remove the lower taping head from the machine.
- 2 - Remove the tape drum bracket assembly, stud spacer, and fasteners from the lower taping head.
- 3 - Install alternative wrap roller and bracket on the head in place of tape bracket. Replace lower head into machine.
- 4 - Install and secure tape drum bracket assembly on the entry end of the lower frame (as shown in **Figure 7-8**).

7.10 Preliminary Electric Inspection

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

- 7.10.1** 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.
- 7.10.2** Check that the connection of the machine to the mains meets the safety regulations in your country.
- 7.10.3** 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.

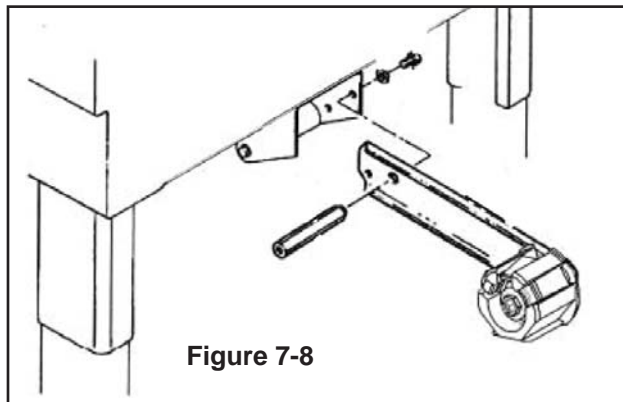


Figure 7-8

7.11 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 (O).

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

7.12 Inspection of Phases (For Three-Main Phases Only)

N/A.

8-THEORY OF OPERATION

8.1 Description of the Working Cycle

After having closed the top flaps of the carton, the operator pushes it under the top infeed end in order to avoid the opening of the top flaps. Further pushing causes the two bottom side belts to drive the box through the taping heads which automatically seal the top and bottom seams. The carton is then expelled on the exit conveyor.

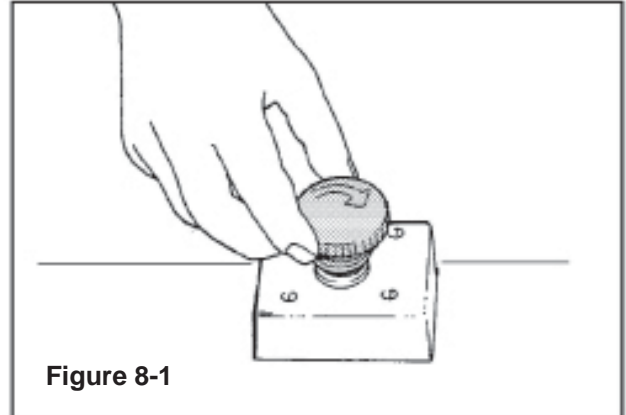


Figure 8-1

8.2 Definition of Running Mode

The case sealer **800af** has two (automatic) operating modes with:

- The EMERGENCY STOP BUTTON unlocked
(**Figure 8-1**)
- The Main Start Switch "ON" (I)
(**Figure 8-2**)
- The Energy Saver Control
(**Figure 8-3**)

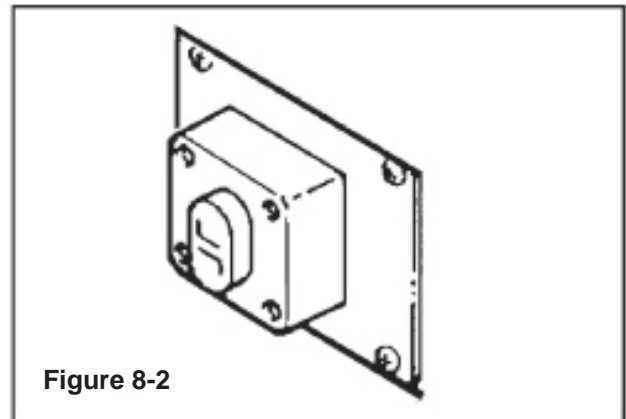


Figure 8-2

8.2.1 Normal Stop Procedure

When the main switch is OFF (O), 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.

8.2.2 Emergency Stop

The LATCHING EMERGENCY STOP and ENERGY SAVING BUTTONS are located on the top center of the machine (**Figure 8-4**).

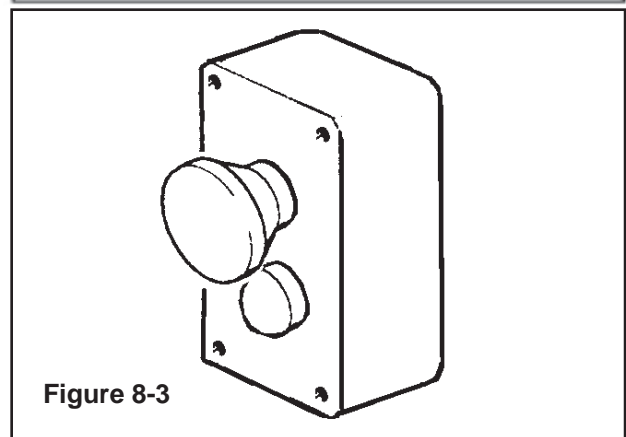


Figure 8-3

8.2.3 Energy Saving Control

The Energy Saving Control Button is located on the column below the Emergency Stop Button on the Operator side of the machine. Pressing the lighted Energy Saving Control Button engages/disengages this feature. When engaged, the drive belts will stop if there is not a continuous flow of boxes through the machine. Inserting a box will re-start the machine (**Figure 8-4**).

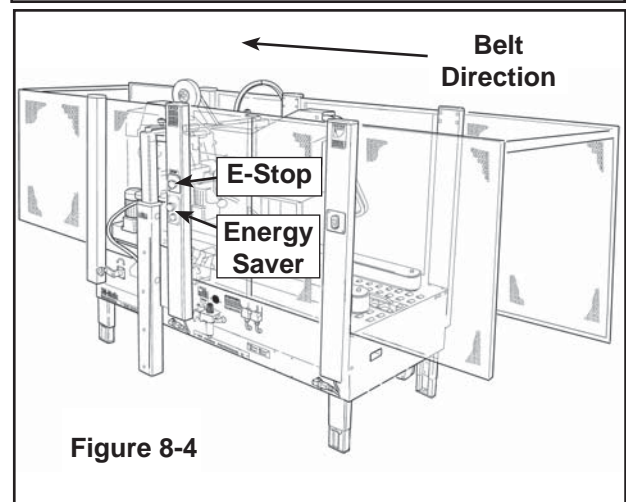
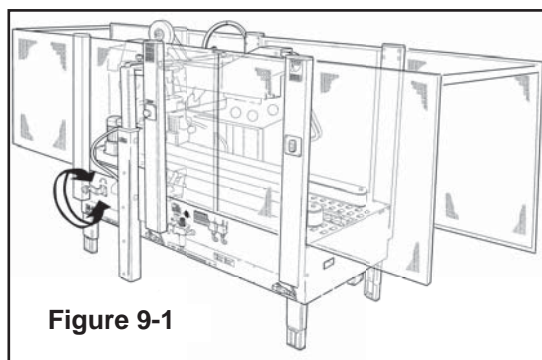
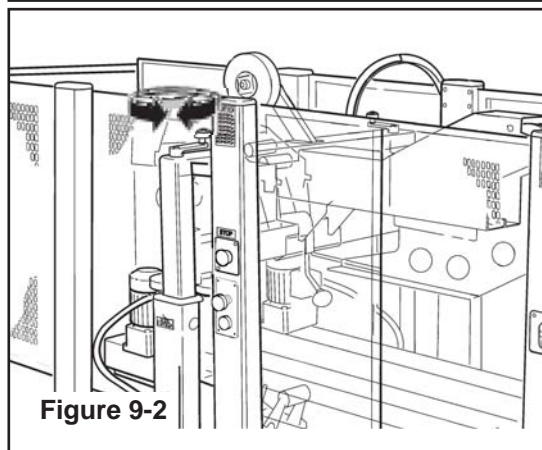


Figure 8-4

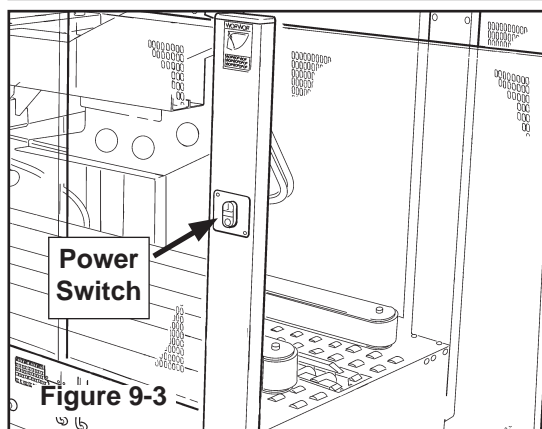
9.1 Box Width Adjusting Knob



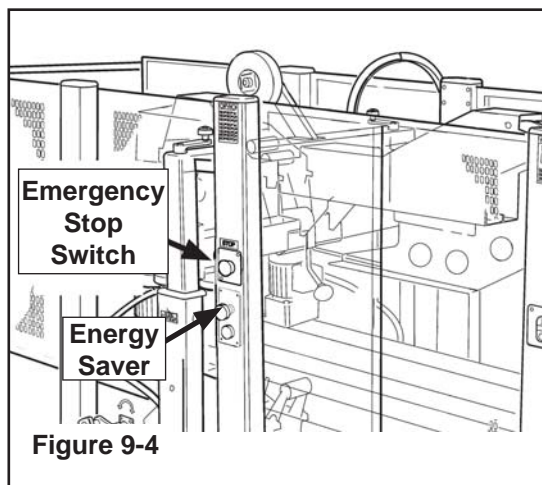
9.2 Box Height Adjusting Knob



9.3 Start/Stop Button



9.4 Latching Emergency Stop and Energy Saving 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™ 3 Taping Heads - 2 Inch).



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).

Energy Saving Control

The Energy Saving Control Button is located on the column below the Emergency Stop Button on the Operator side of the machine. Pressing the lighted Energy Saving Control Button engages/disengages this feature. When engaged, the drive belts will stop if there is not a continuous flow of boxes through the machine. Inserting a box will re-start the machine.

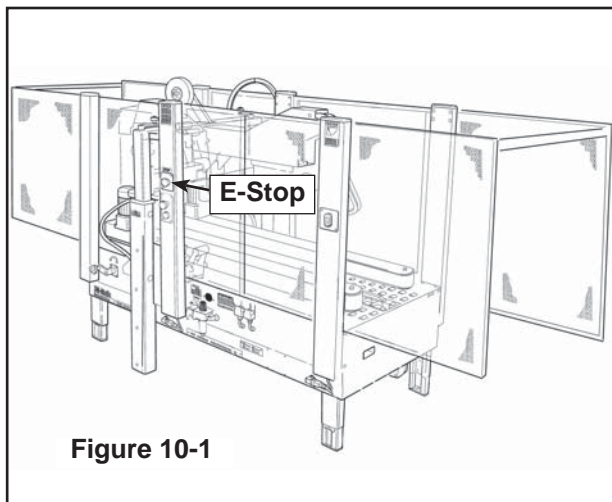


Figure 10-1



WARNING

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

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.
3. Plug in machine.
4. Press machine "On" (I) 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.

11.1 Case Sealer Components

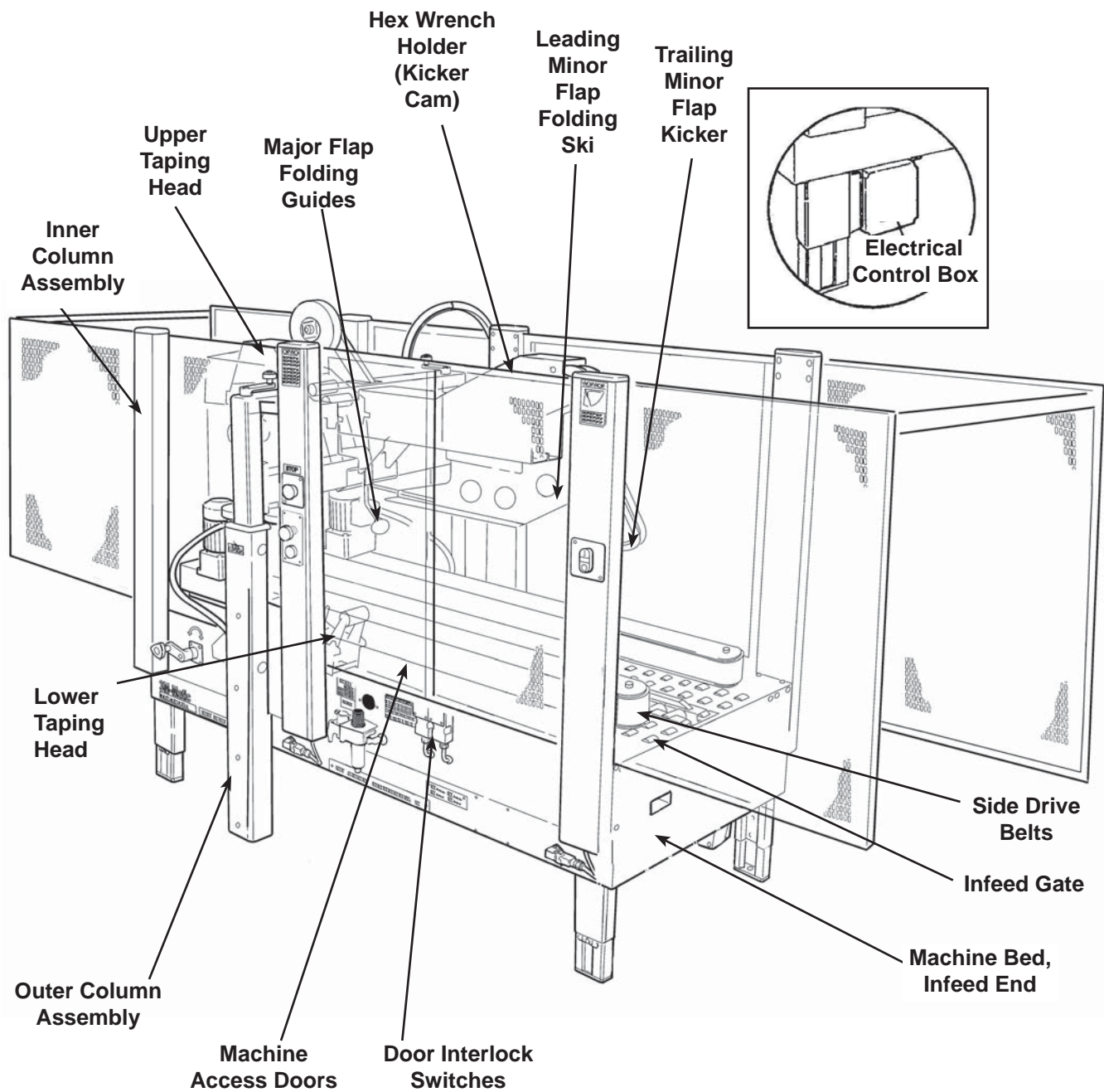


Figure 11-1 Component Locations

(continued on next page)

11.1 Component Locations (continued)

Note: See next page for the function of these controls

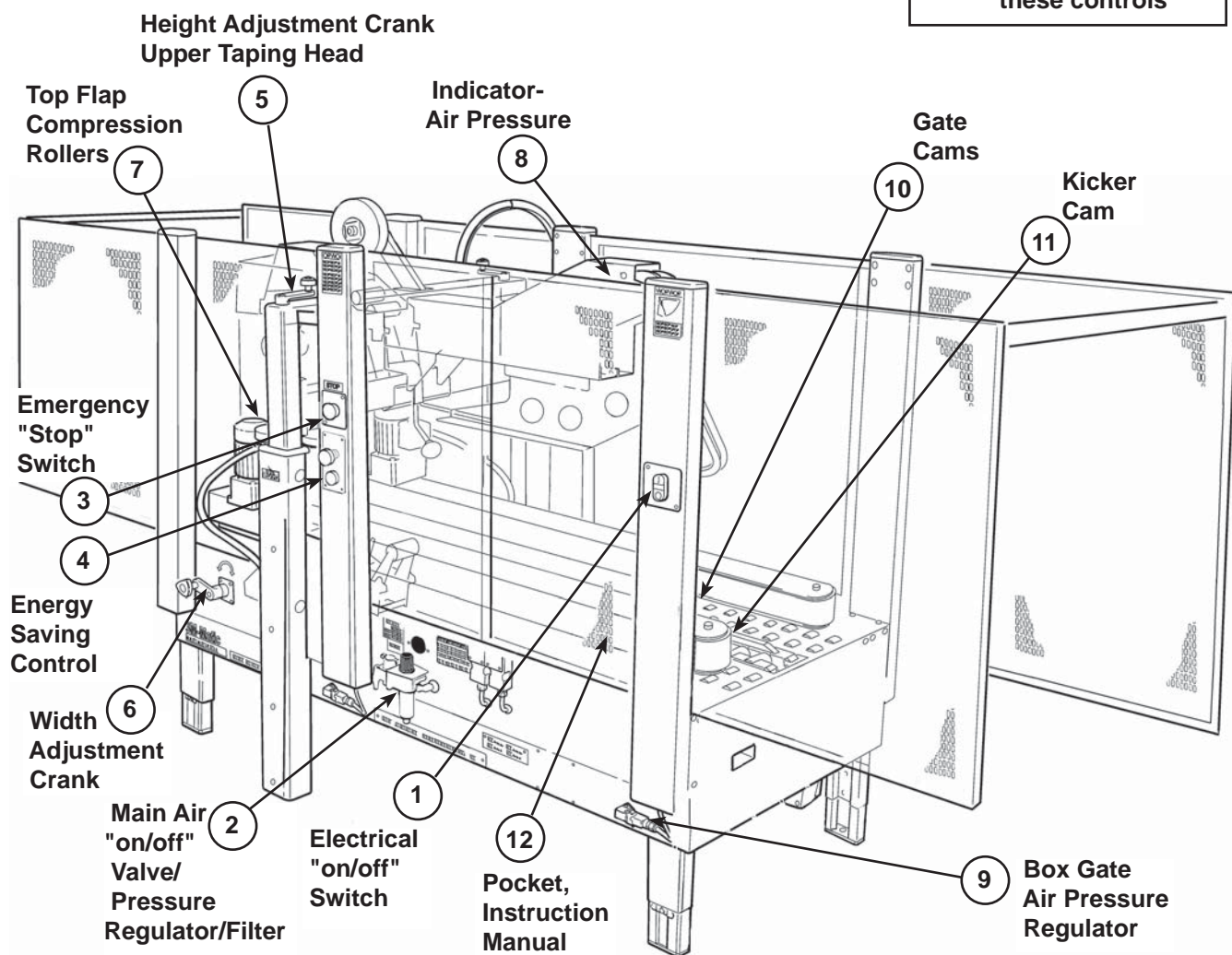


Figure 11-2 Controls

(continued on next page)

11.1 Component Locations (continued)

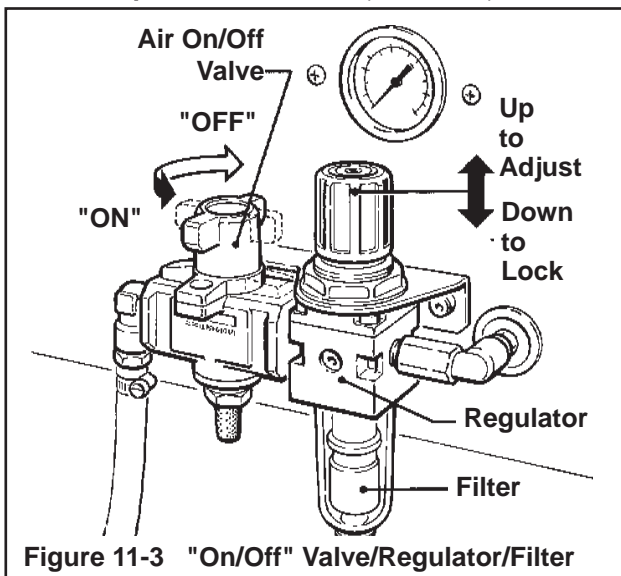


Figure 11-3 "On/Off" Valve/Regulator/Filter

- ① **Electrical "On/Off" Switch**
The box drive belts are turned on and off (off button is red) with the electrical switch on the side of the machine guard at the infeed end.
- ② **Main Air "On/Off" Valve/Pressure Regulator/Filter – Figure 11-3.** This set of pneumatic components controls, regulates and filters plant air supply to the two separate control circuits of the case sealer.

"On/Off" Valve – "On" turn to "SUP" – "Off" turn to "EXH"

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.

- 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 pressing green (On) button on side guard.
- ④ **Energy Saving Control**
The Energy Saving Control Button is located on the column below the Emergency Stop Button on the Operator side of the machine. Pressing the lighted Energy Saving Control Button engages/disengages this feature. When engaged, the drive belts will stop if there is not a continuous flow of boxes through the machine. Inserting a box will re-start the machine.

- ⑤ **Height Adjustment Crank, Upper Taping Head**
Raises and lowers upper taping head/flap folders to accommodate box height.
- ⑥ **Width Adjustment Crank**
Adjusts distance between side drive belts to accommodate box width.
- ⑦ **Top Flap Compression Rollers**
Rollers adjust to properly maintain box width/top flap center seam for tape seal. **Indicator, Air Pressure**
- ⑧ **Air Pressure**
The optical warning indicator, located on the upper flap folder frame, indicates "Red" when compressed air circuit is on.
- ⑨ **Box Gate Air Pressure Regulator**
Adjusts lifting force of the box gate depending on the weight of boxes being sealed.
- ⑩ **Gate Cams - Figure 11-4**
The gate cams (A) (B) control the rate of box entry into the case sealer. Depending on box size, gate cams can be adjusted to increase production rate. See "Adjustments – Gate Operation".
- ⑪ **Kicker Cam - Figure 11-4**
The minor flap folder, controlled by the kicker cam (C), closes the trailing minor flap on the box. The kicker cam must be adjusted according to the length of the box being sealed. See "Operation".
- ⑫ **Pocket, Instruction Manual**
A pocket is provided inside the right door for storage of the machine instruction manual. Keep the manual in this pocket for the convenience of machine operators.

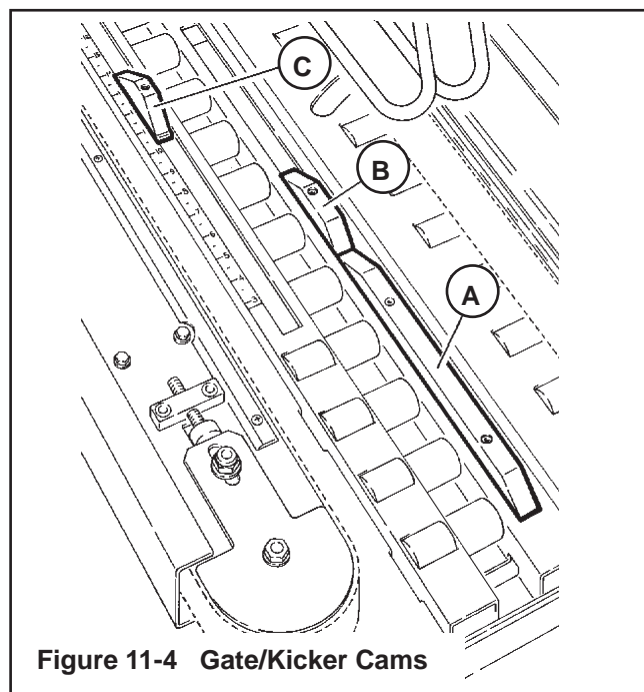


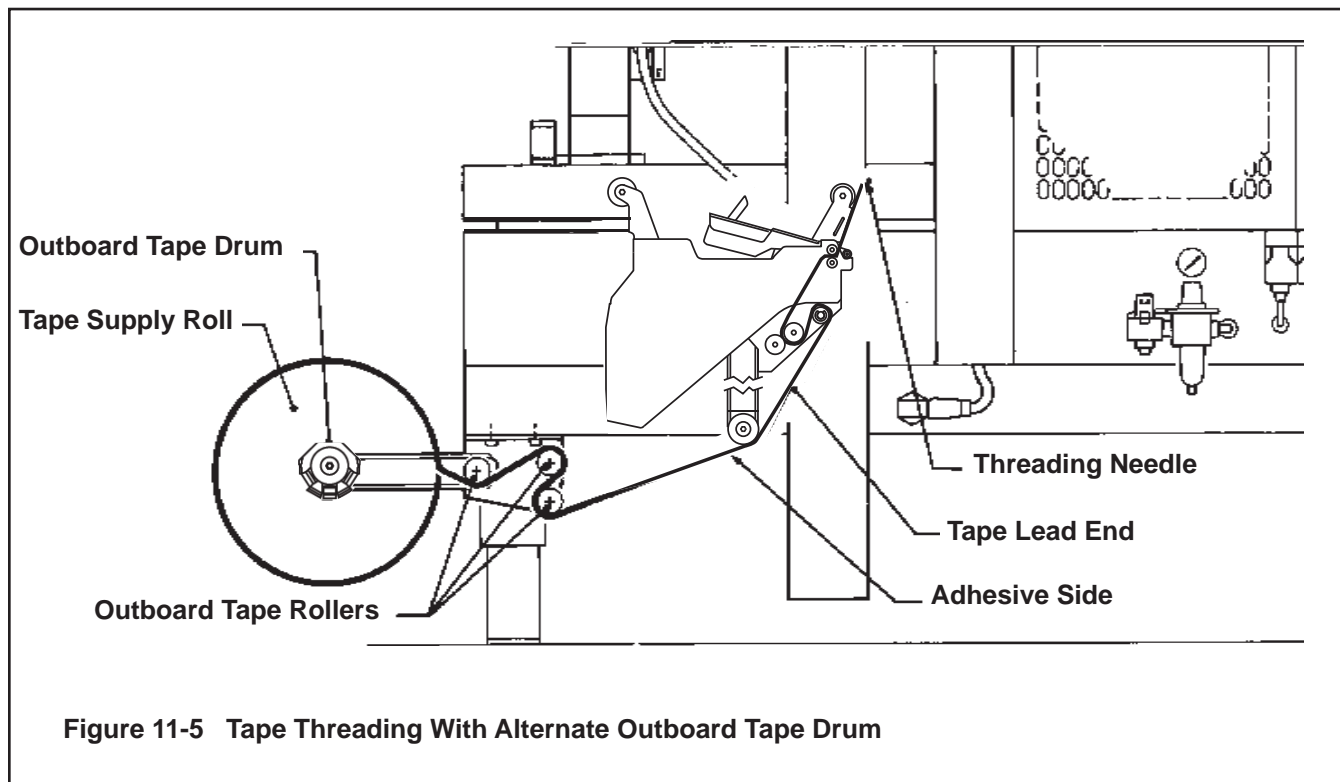
Figure 11-4 Gate/Kicker Cams

11.2 Operation Warnings



WARNING

1. Turn electrical and air supply off and disconnect before servicing taping heads or performing any adjustments or maintenance on the machine. Turn electrical and air supplies off when machine is not in use.
2. Do not leave machine running unattended.
3. Before turning drive belts on, be sure no tools or other objects are on the machine bed.
4. Keep hands and loose clothing away from moving belts and flap kicker.
5. Keep away from flap kicker. Flap kicker is controlled by air and can be activated (if air supply is "On") by depressing flap kicker cam. Be sure flap kicker is in the down position before servicing.
6. Never attempt to remove jammed boxes from the machine while machine is running.
7. Machine access door must be closed when drive belts are running. Do not attempt to override door interlock switch.
8. Keep hands and clothing away from taping heads when machine is running. A box traveling through the machine causes taping head rollers to retract when box enters and extend as box leaves taping head.
9. Both the upper and lower taping heads utilize extremely sharp tape cut-off knives. The knife is located under the orange knife guard which has the "WARNING – SHARP KNIFE" label. Before loading tape, refer to Manual 2 to identify the knife location. Keep hands out of these areas except as necessary to service the taping heads.
10. Failure to comply with these warnings could result in severe personal injury and/or equipment damage.



11.3 Box Size Setup

Figure 11-6

Open the side drive belts and raise the upper head assembly to accommodate the desired box width and height.

Move the compression rolls as wide as possible.

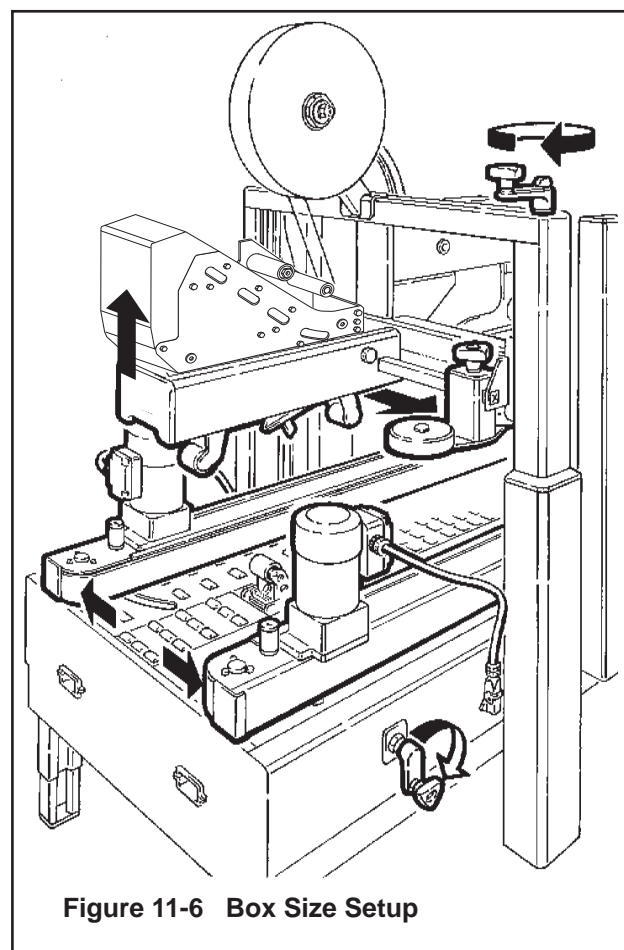


Figure 11-7

Place a product filled box 55 to 65mm [2-1/4 to 2-1/2 inches] into the exit end of the machine with the top flaps folded as shown.

Crank the upper head down until it just contacts the top of the box.

Crank the side drive belts in until the belts firmly grip the box.

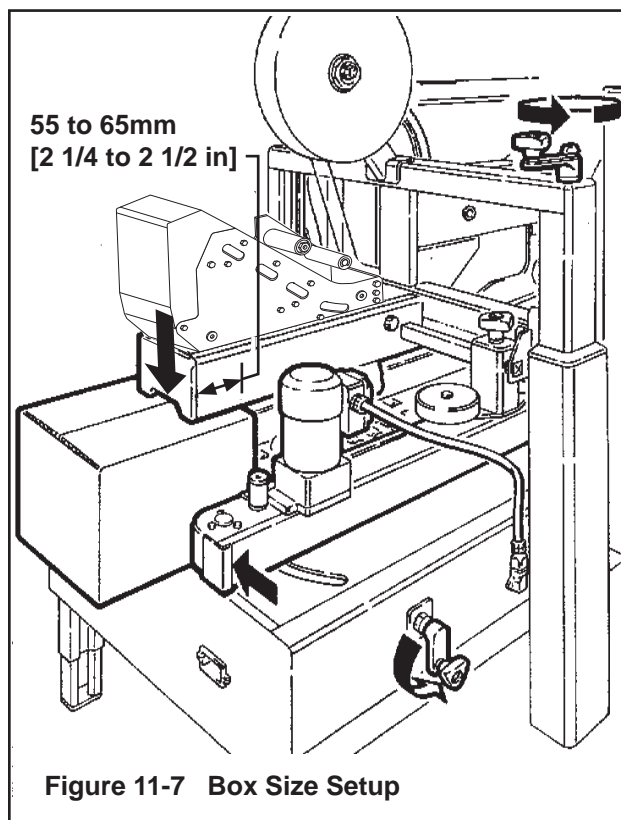


Figure 11-7 Box Size Setup

Figure 11-8

Set Kicker cam relative to length of box being sealed. Measure the distance "X" as shown and set the cam to the same dimension measured on the box (this dimension provides a good starting point for setting the kicker cam).

Note: 5mm hex key wrench is supplied with machine and should be kept in wrench holder on side of upper frame.

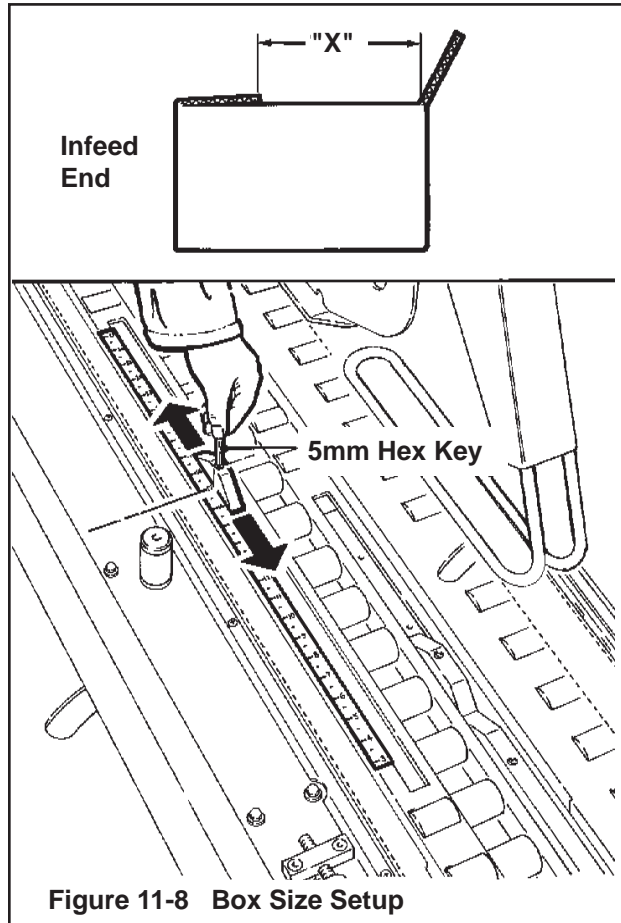


Figure 11-8 Box Size Setup

Figure 11-9

Important – Be sure all packaging materials and tools are removed from the machine before operating.

Turn air On/Off valve to the "On" (SUP) position.

Press electrical "On" button to start drive belts.

Place box at infeed end of machine and push into machine until it is taken away by 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.

Figure 11-10

Adjust compression rollers. Run box through machine and stop when adjacent to compression rollers. Move compression rollers in to press box top flaps firmly together. Restart machine to exit box.

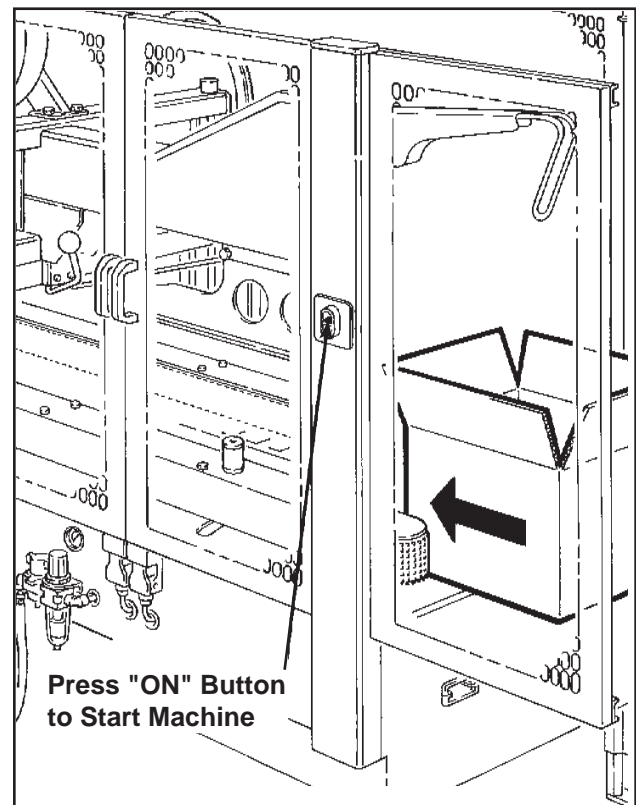


Figure 11-9 Box Size Setup

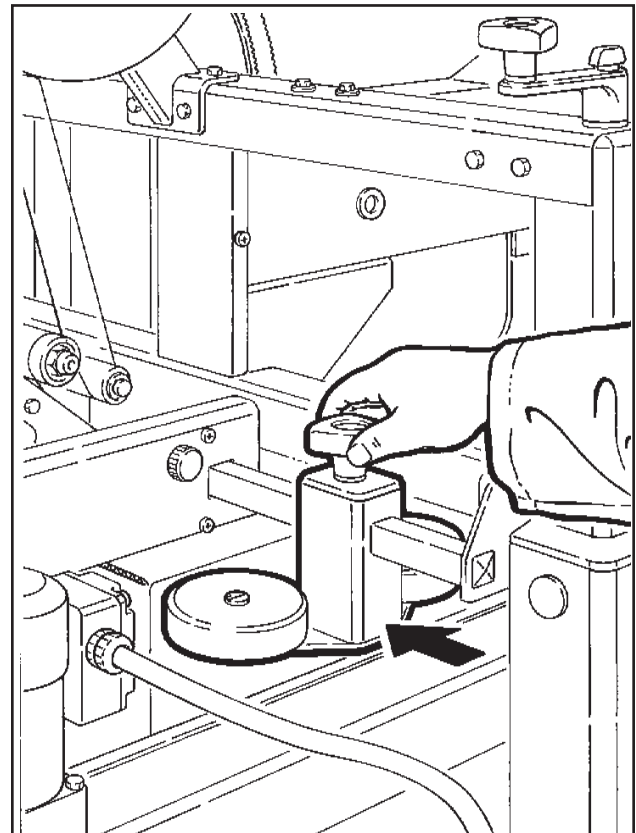


Figure 11-10 Box Size Setup

Figure 11-11

Run several test boxes through the machine, and observe the flap kicking action. Adjust the kicker cam so the kicker "kicks" earlier or later as required (**refer to figure 11-11**). 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.



WARNING

- To reduce the risk associated with impact hazards:
 - Always use appropriate supporting means when working under the upper drive assembly

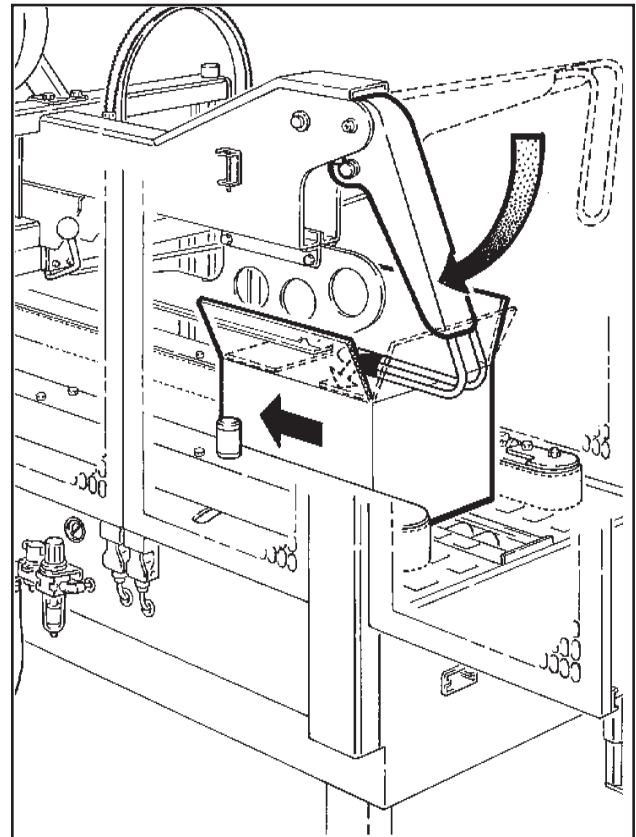


Figure 11-11 Box Size Setup

Figure 11-12

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.

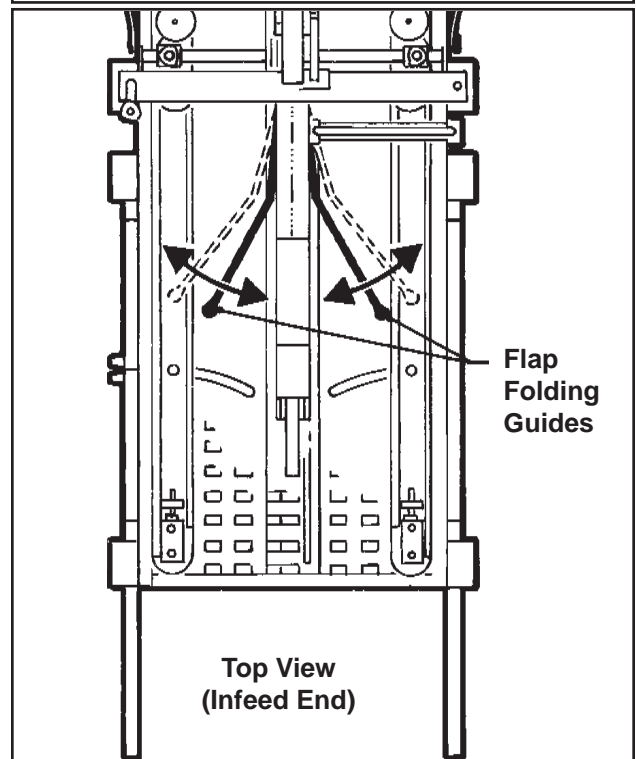


Figure 11-12 Box Size Setup

Figure 11-13

If the box is hard to move under the top head or is crushed, raise the top head slightly.

If the box movement is jerky or stops under the top head, move the side drive belts in slightly to add more pressure between the box and drive belts.

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

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

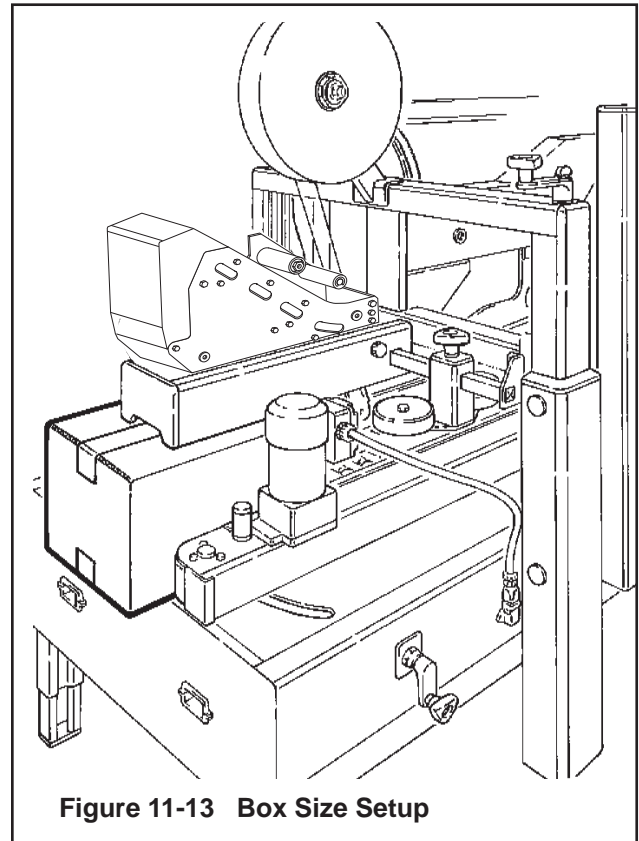


Figure 11-13 Box Size Setup

11.4 Box Sealing



WARNING

- **To reduce the risk associated with pinches and entanglement hazards:**
 - 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.

1. Connect electrical and air supplies.
2. Turn main air valve "On" and adjust air regulator if pressure does not read 5 bar gauge pressure [70 PSIG].
3. Press electrical "On" button to start drive belts.
4. Continually feed boxes to case sealer, case sealer will automatically space entrance of boxes to machine.
5. Turn electrical and air supplies "Off" when machine is not in use.
6. Reload and thread tape as necessary.
7. Be sure machine is cleaned and lubricated according to recommendations in "Maintenance" section of this manual.

Notes:

1. Box drive motors are designed to run at a moderate temperature of 40° C [104° F]. In some cases they may feel hot to the touch.
2. Adjustment of the machine or taping heads are described in the "Adjustment" section of this manual.

11 - OPERATION (continued)

11.5 Box Jams

If a box is improperly fabricated or filled, if the machine is improperly adjusted for the box being run, or if boxes enter the machine incorrectly, a box jam may occur. To clear a box jam, follow these steps:

1. Determine cause of box jam so corrective action can be taken to prevent reoccurrence.

Important - be sure to wait for the flap kicker to reach down position to avoid being hit or startled by its movement.

2. Turn off machine.



WARNING

- **To reduce the risk associated with pinches and entanglement hazards:**
 - 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.

3. Crank upper head up and/or drive belts out until box is free.

4. Carefully pull box out of machine.



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.

5. Readjust upper head and drive belts according to "Machine Adjustment for Box Size" instructions.

6. Connect air and electrical supplies.

7. Turn machine "On" (I).

12 - MAINTENANCE

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



WARNING

- **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.

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

Note – Wipe off excess Silicone. It will attract } dust and dirt 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.

12.1 Cleaning

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

12.2 Lubrication

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

Figure 12-1 illustrates the areas of the case sealer that require lubrication. Lubricate points indicated by arrows with Synthetic Silicone.

TAPING HEAD LUBRICATION – See Manual 2 "Maintenance – Lubrication".

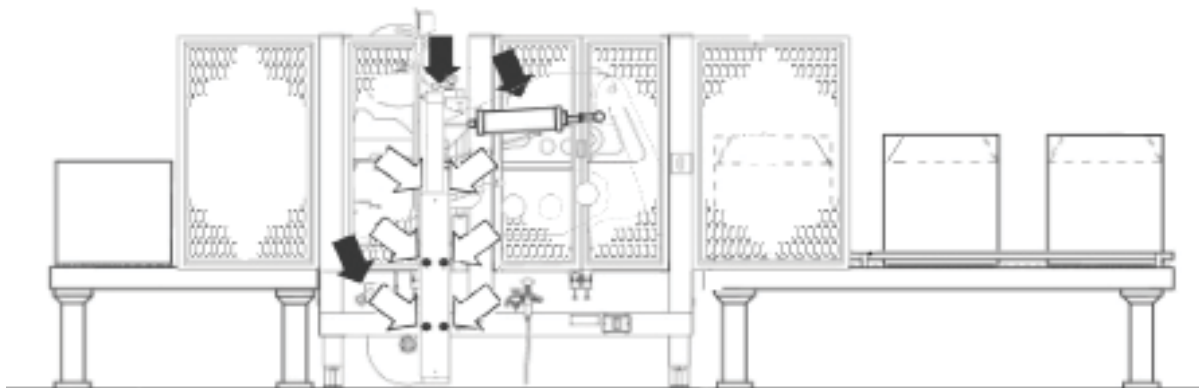


Figure 12-1 Lubrication Points



WARNING

- **To reduce the risk associated with pinches and entanglement hazards:**
 - 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.

12.3 Drive Belt Replacement/Tension Adjustment

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

REPLACEMENT – STEPS 1-11

TENSION ADJUSTMENT – STEPS 1, 2, 4-6, 10 & 11

Figure 12-2

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).
4. Remove and retain screws (D), cap washers (E) and spacers (F) from the front and rear arm assembly pivots.
5. Lift belt assembly (G) up and off arm assembly pivots.

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

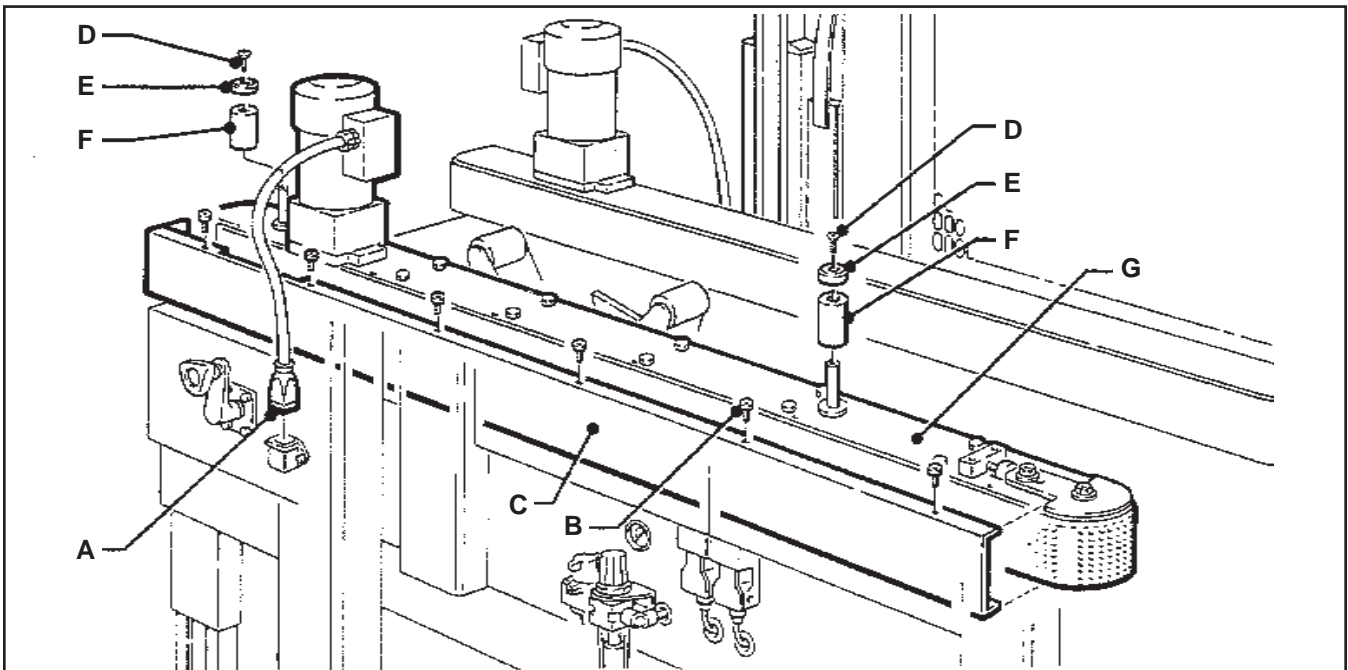


Figure 12-2 Drive Belt Replacement

Figure 12-3

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

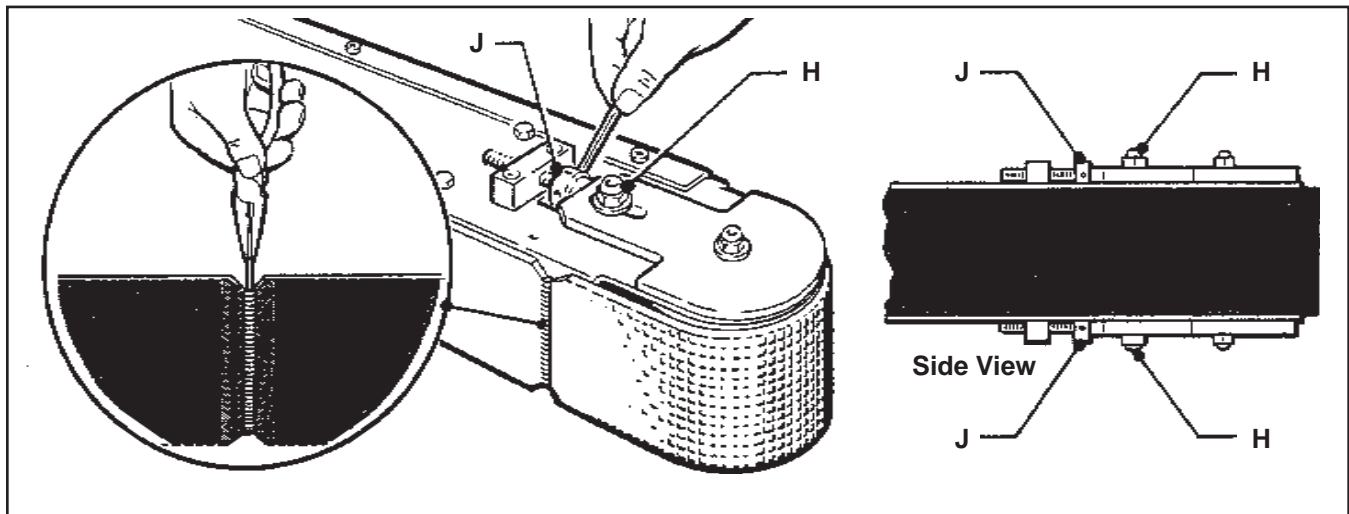


Figure 12-3 Drive Belt Replacement/Tension Adjustment

9. **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.

10. Set drive belt tension – turn adjustment screws (J) 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 12-4**, with a moderate pulling force of 7 lbs. [3.5 kg]. Tighten lock nuts (H) on both tension assemblies to secure tension setting.

11. Assembly is reverse of disassembly.

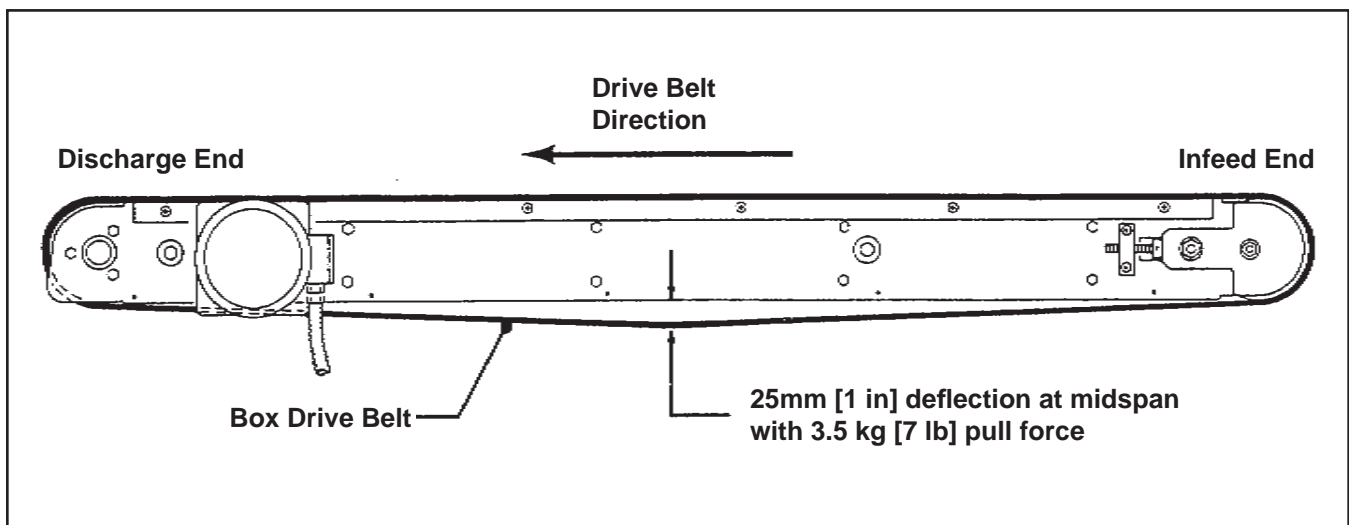


Figure 12-4 Drive Belt Tension Adjustment (Top View)



WARNING

- **To reduce the risk associated with pinches and entanglement hazards:**
 - 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.

12.4 Air Line Filter (Figure 12-5)

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

12.5 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 preset and requires no further maintenance.



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.

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. Press machine "On" (I) button, on the side guard, to resume case sealing.

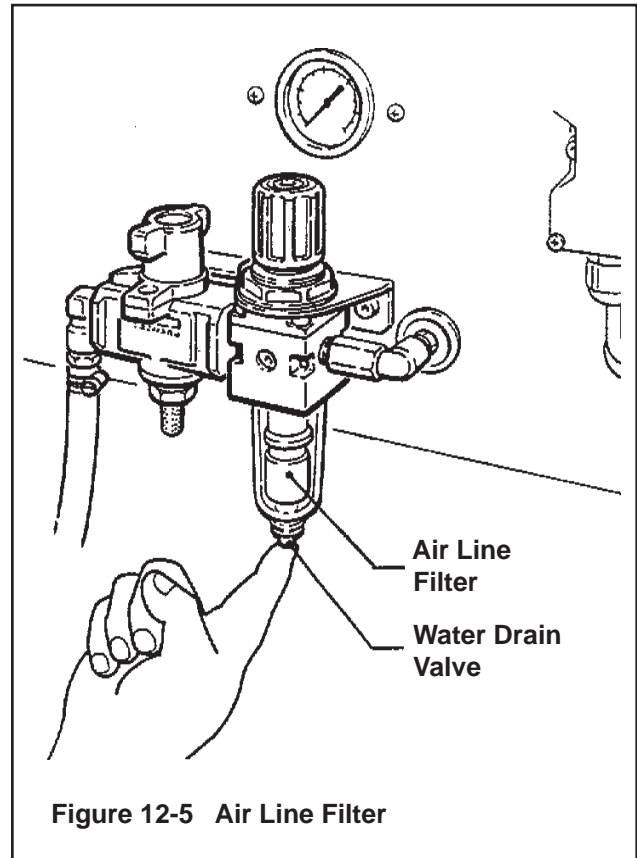


Figure 12-5 Air Line Filter

12.6 Knife Replacement, Taping Head

See Manual 2, "Maintenance – Blade (Knife) Replacement".



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 - ADJUSTMENTS



WARNING

- **To reduce the risk associated with pinches and entanglement hazards:**
 - 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.

13.1 Gate Operation

Figure 13-1

- A – Permanent gate cam
B – Removable gate cam
C – Kicker cam

The **800af** is shipped with both gate cams **A** and **B** installed. With both cams the entire range of box lengths can be run (150-760mm [6-30 inches]). However if only boxes longer than 305mm [12 inches] will be run, cam **B** can be removed to increase the production rate. Refer to the box rate chart in specification section.

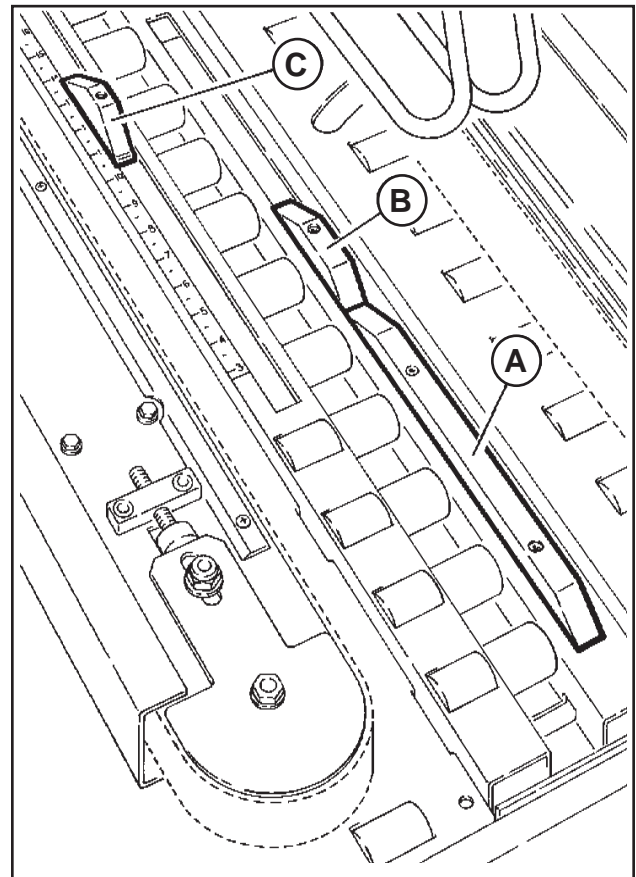


Figure 13-1 Gate Cams

13.2 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 "Maintenance – Drive Belt Replacement/Tension Adjustment".

13.3 Taping Head Adjustments – Refer to Manual 2

TAPE WEB ALIGNMENT – Manual 2

TAPE DRUM FRICTION BRAKE – Manual 2,

APPLYING MECHANISM SPRING – Manual 2,

ONE-WAY TENSION ROLLER – Manual 2,

TAPE LEG LENGTH ADJUSTMENT – Manual 2.



WARNING

- **To reduce the risk associated with pinches and entanglement hazards:**
 - 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.

13.4 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 (5) bolts on each side of crossbar shown in **Figure 13-2A**.
2. Remove access cover as shown in **Figure 13-2B** and (using M13 hex key wrench) tighten or loosen M8 self-locking nut until upper head is level.
3. Take measurement from exit end of upper head assembly and front of flap folding ski to machine bed, as shown in **Figure 13-2**. Upper assembly must be level $\pm 1.5\text{mm}$ [$\pm 1/16$ inch].
4. Retighten five (5) bolts on each side of crossbar to secure adjustment.

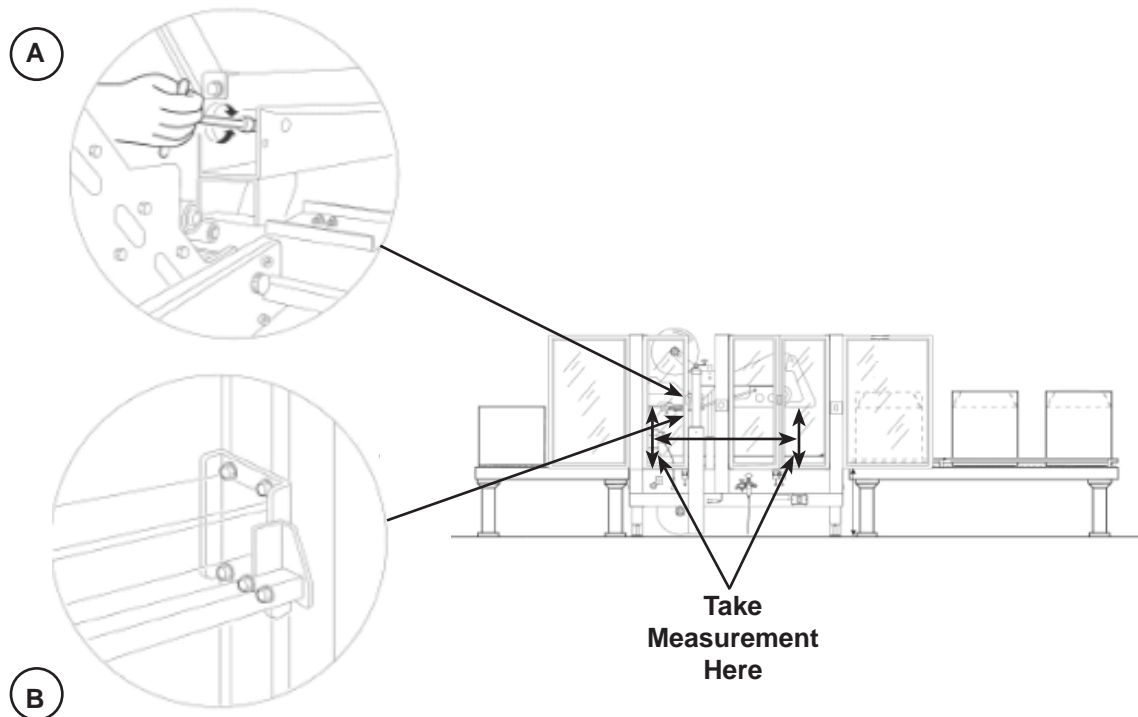


Figure 13-2 Upper Taping Head Leveling



WARNING

- **To reduce the risk associated with pinches and entanglement hazards:**
 - 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.

13.5 Gate Pressure Regulator (Figure 13-3)

The gate air pressure is controlled by a regulator mounted under the machine frame. This provides adjustment of the gate lifting force. When lightweight boxes are being run, the gate pressure can be reduced to minimize lifting of the box.

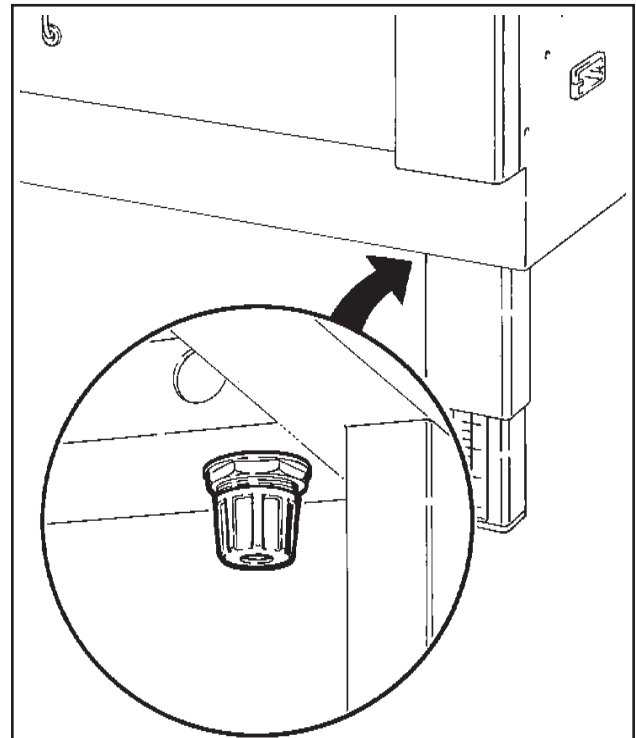


Figure 13-3 Gate Pressure Regulator

13.6 Gate Stroke Setting (Figure 13-4)

The machine is initially set at the maximum gate lift of 25mm [1 inch]. This can be reduced if needed for special situations. To do this, remove the center roller section and turn the stop nuts clockwise until the desired lift is achieved.

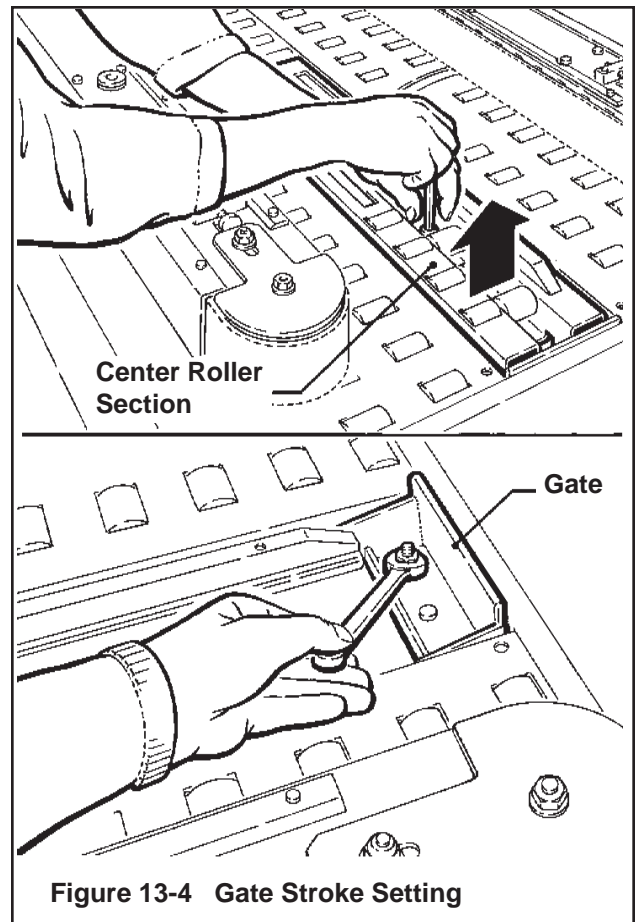


Figure 13-4 Gate Stroke Setting



WARNING

- **To reduce the risk associated with pinches and entanglement hazards:**
 - 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.

14.1 Changing Drive Belt Height

The drive belt assemblies can be raised 50mm [2 inches] to provide better conveying of tall boxes. This change increase the minimum box height that can be taped to 190mm [7-1/4 inches].

Disassembly – Figure 14-1

1. Using the height adjustment crank, raise the upper taping head to its fully raised position.
2. Remove and retain the M6 x 16 flat head cap screw (A), special washer (B) and spacer (C) from the front and rear arm assembly pivots.
3. Lift drive belt assembly (D) up off the arm assembly pivots.

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

Reassembly – Figure 14-2

4. Reassemble the spacer (C) onto the front and rear arm assembly pivots first.
5. Install the belt drive assembly (D) onto the pivots and secure with special washers (B) and M6 x 16 flat head cap screws (A).

Note – Both drive belt assemblies must be installed at the same operating height.

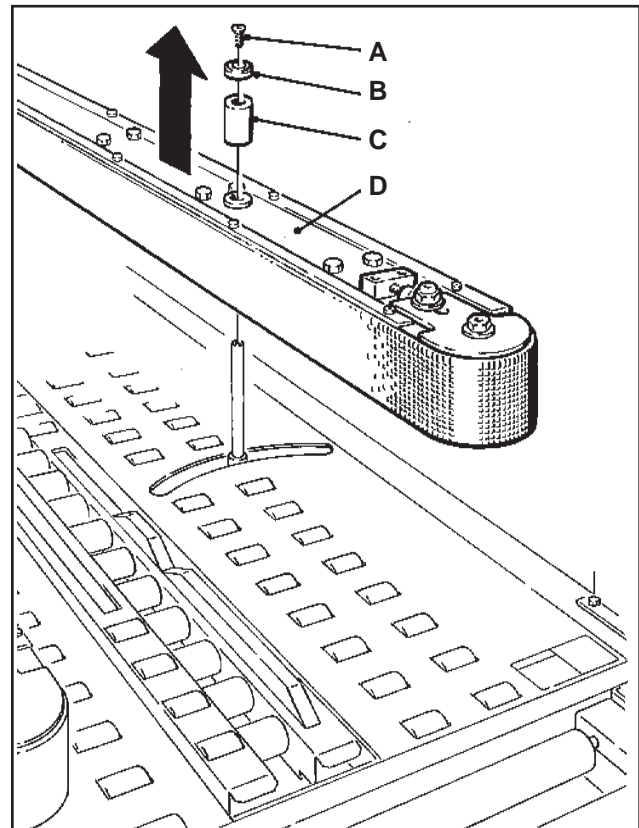


Figure 14-1 Drive Belt Height, Disassembly

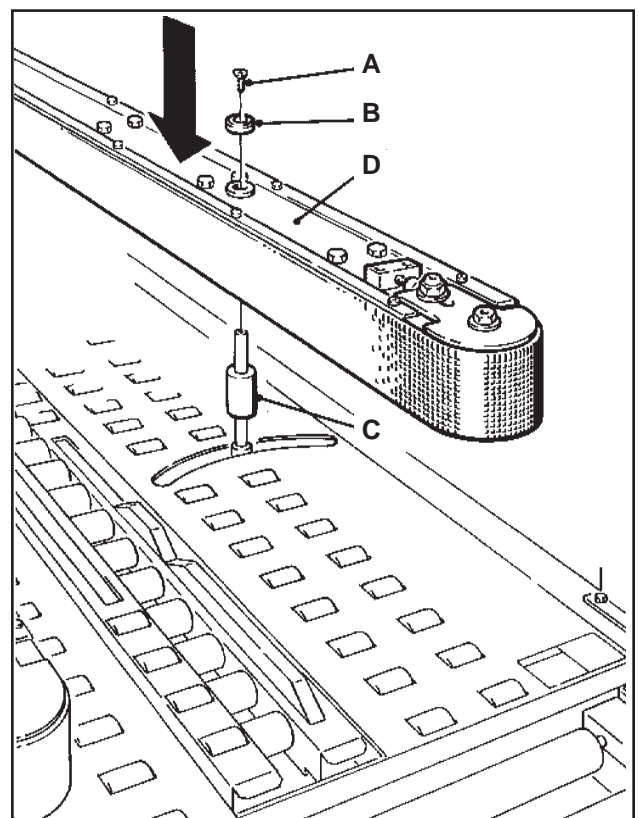


Figure 14-2 Drive Belt Height, Reassembly

14 - SPECIAL SETUP PROCEDURE (continued)

14.2 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

1. Crank upper taping head frame up high enough to allow clearance for removal of lower taping heads.
2. Remove the stop bracket (**Figure 14-3C**) from normal position "A" and fasten in lower position "A-A". Relocate stop brackets on both columns.

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.

Important – Taping heads weigh approximately 7.2 kg [16 lbs]. Use proper body mechanics when lifting or holding taping head.

3. Lift the lower taping head, shown in **Figure 14-3B**, 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.

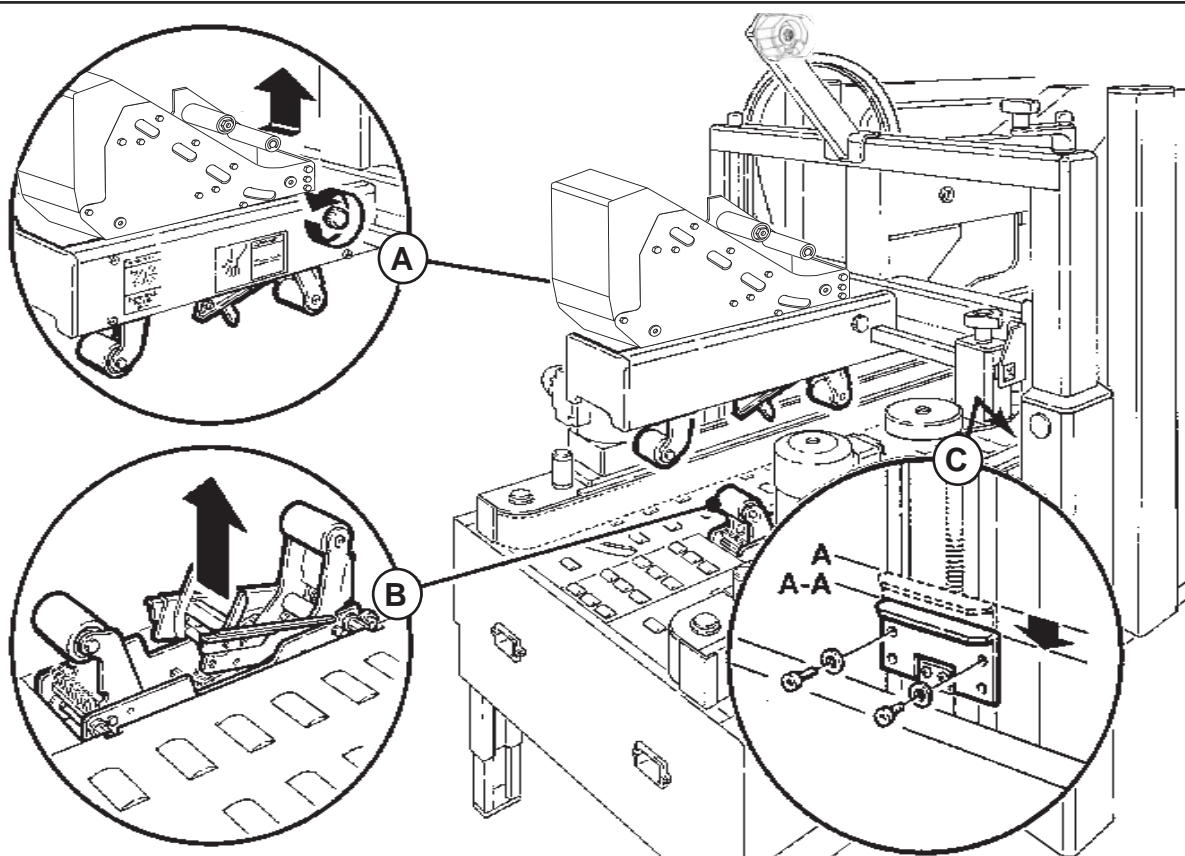


Figure 14-3 Removing Taping Heads from Case Sealer

14.3 Outer Column Re-Positioning (Refer to Figure 14-4)

Moving the outer columns up one set of mounting holes increases the maximum box size handled by the case sealer from 620mm [24-1/2 inches] to 725mm [28-1/2 inches].

Important – It is recommended that no less than two people assist on this setup or severe injury or equipment damage could result.

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

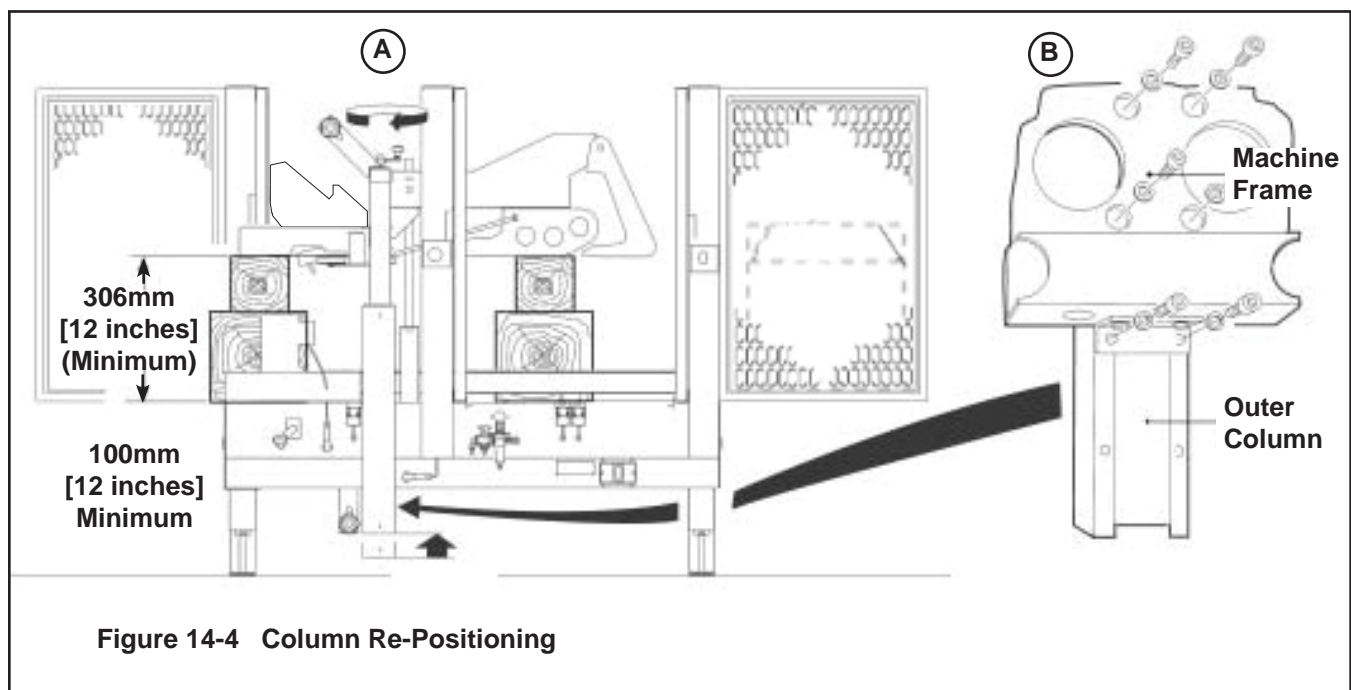
1. Crank side drive belts to full open position.
2. Crank upper taping head frame assembly up approximately 330mm [13 inches] from machine bed.
3. Place solid blocks approximately 305mm [12 inches] high beneath upper taping head frame at rear of taping head and under front flap folding ski (**Figure 14-4A**).

Note – Blocks (front and rear) must be the same height in order to keep upper frame level.

4. Crank upper taping head frame down until weight of upper frame is fully on blocks.
5. Remove and retain six mounting screws in each outer column assembly (**Figure 13-4B**).

Important - A second person should assist with this part of setup to hold (steady) upper frame until columns are re-positioned and column screws are installed and tightened.

6. Crank outer column up 100mm [4 inches] and re-install six (6) screws in each column. Tighten screws.
7. Crank upper taping head up and remove blocks.
8. Check horizontal alignment of upper taping head frame and adjust as described in "Adjustments – Upper Taping Head Leveling".



15 - TROUBLESHOOTING

The Troubleshooting Guide lists some possible machine problems, causes and corrections. Also see Manual 2 "Troubleshooting" pages for taping head problems.

Note – Adjustment of the machine or taping heads are described in "Adjustments".

15.1 Troubleshooting Guide

Problem	Cause	Correction
Drive belts do not convey boxes	Worn drive belts	Replace drive belts
	Top taping head does not apply enough pressure	Adjust the box height adjustment with the crank
	Taping head applying spring holder missing	Replace spring holder
	Taping head applying spring set too high	Reduce spring pressure
Drive belts do not turn	Worn or missing friction rings	Replace friction rings
	Drive belt tension too low	Adjust belt tension
	Electrical disconnect	Check power and electrical plug
	Motor not turning	Evaluate problem and correct
	Energy Stop Button engaged	Insert box in machine to re-start
Drive belts break		Replace belt
Squeaking noise as boxes pass through machine	Worn belt	Lubricate compression bearings
	Dry compression bearings	Lubricate column bearings
Tape not centered on box seam	Dry column bearings	Adjust centering guides
	Centering guides not centered	Check box specifications
	Box flaps not of equal length	

(continued)

15 - TROUBLESHOOTING (continued)

Troubleshooting Guide

Problem	Cause	Correction
Flap kicker kicks at wrong time	Kicker cam improperly set	Reposition kicker cam
	Air cylinder flow controls out of adjustment	Readjust flow controls
Gate does not raise to stop next box	Too much air pressure on gate cylinder lifts box off of gate cam	Reduce gate air pressure using regulator
	Incoming boxes not low enough and therefore not actuating cam	
Gate retracts too soon/kicker does not kick	The removable portion of the gate cam has been removed and boxes shorter than 12 inches are being run	Reinstall removable gate cam portion
Two boxes are taped together		

16.1 Information for Disposal of Machine (ELV)

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.

16.2 Emergency Procedures

In case of danger/fire:

Disconnect plug of power cable from power supply.
(Figure 16-1)

IN CASE OF FIRE

Use a fire extinguisher that is rated for electrical fires
(Figure 16-2).

17.1 Statement of Conformity

Not Applicable.

17.2 Emission of Hazardous Substances

Nothing to report

17.3 List of Safety Features

List of components/assemblies with safety functions

- LATCHING EMERGENCY STOP BUTTON
- Thermal cut-out relay
- Fixed guards upper drive belts
- Blade guard assemblies on both taping heads

Important: Earth wire protection of 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

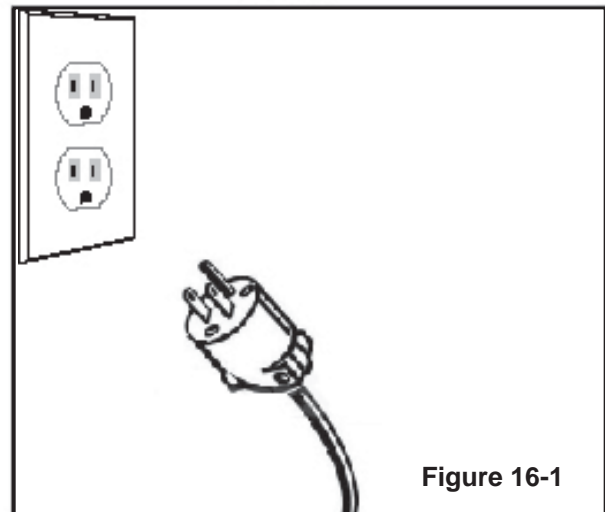


Figure 16-1

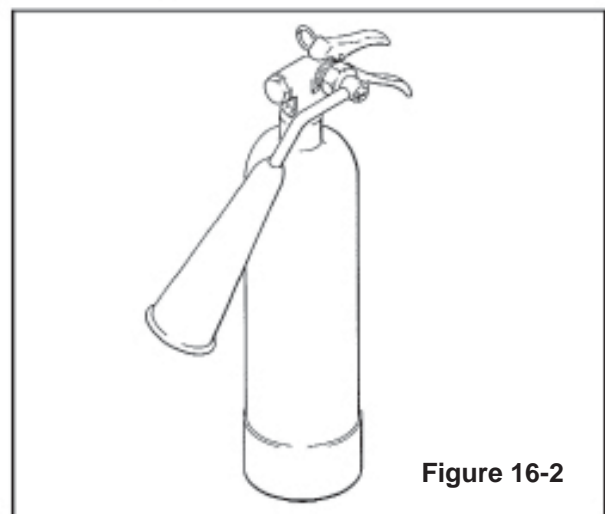


Figure 16-2

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

N/A

18-TECHNICAL DIAGRAMS

18.1 Electric Diagram - 1 Phase



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.

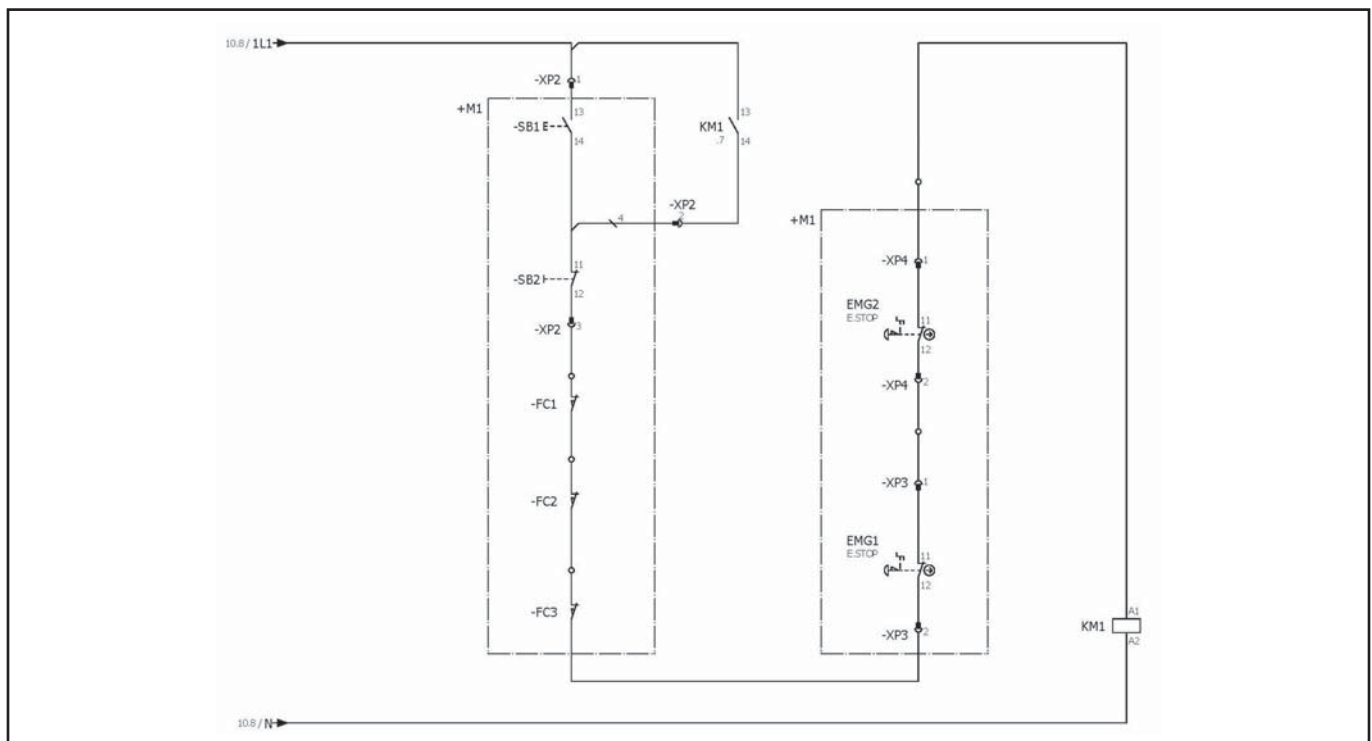
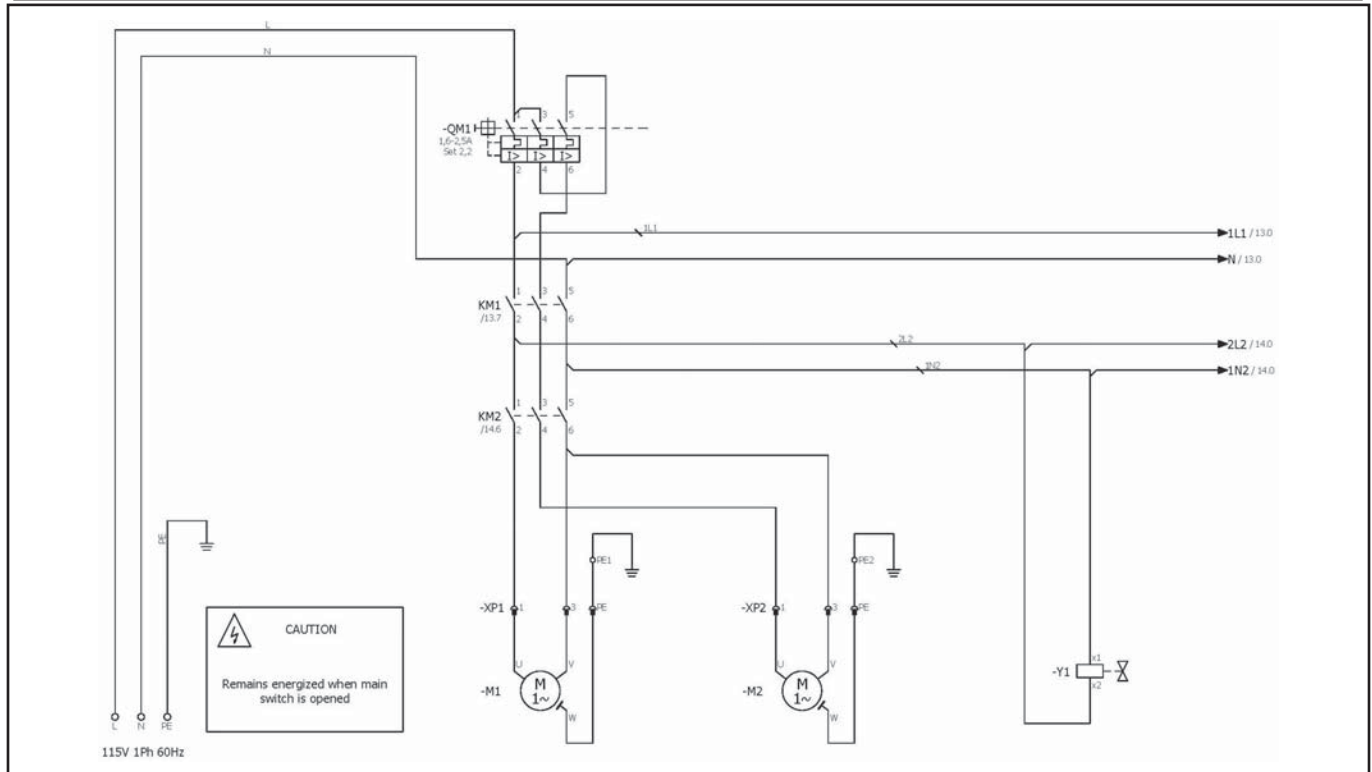


Figure 18-1 Electrical Diagram

18-TECHNICAL DIAGRAMS

18.1 ELECTRICAL DIAGRAM (continued)

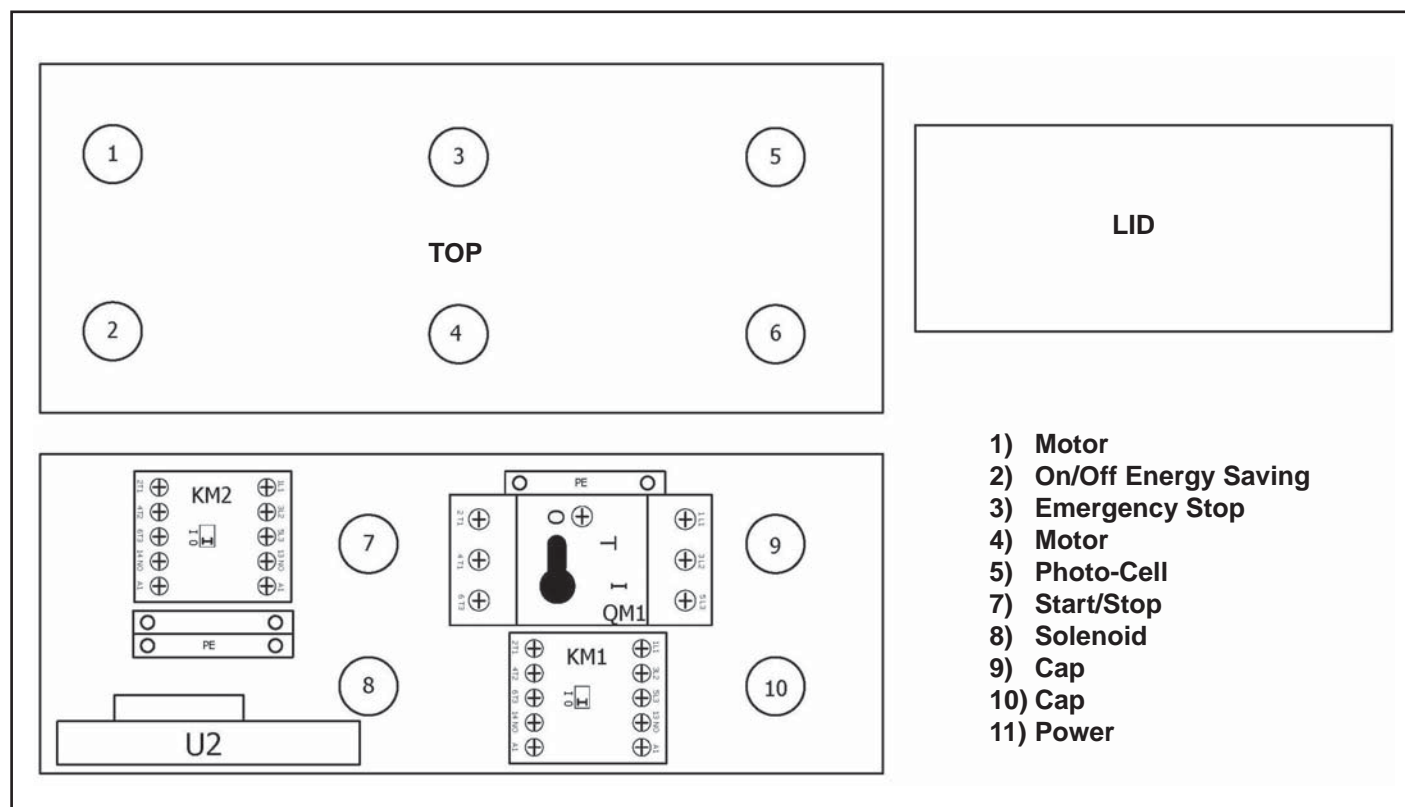
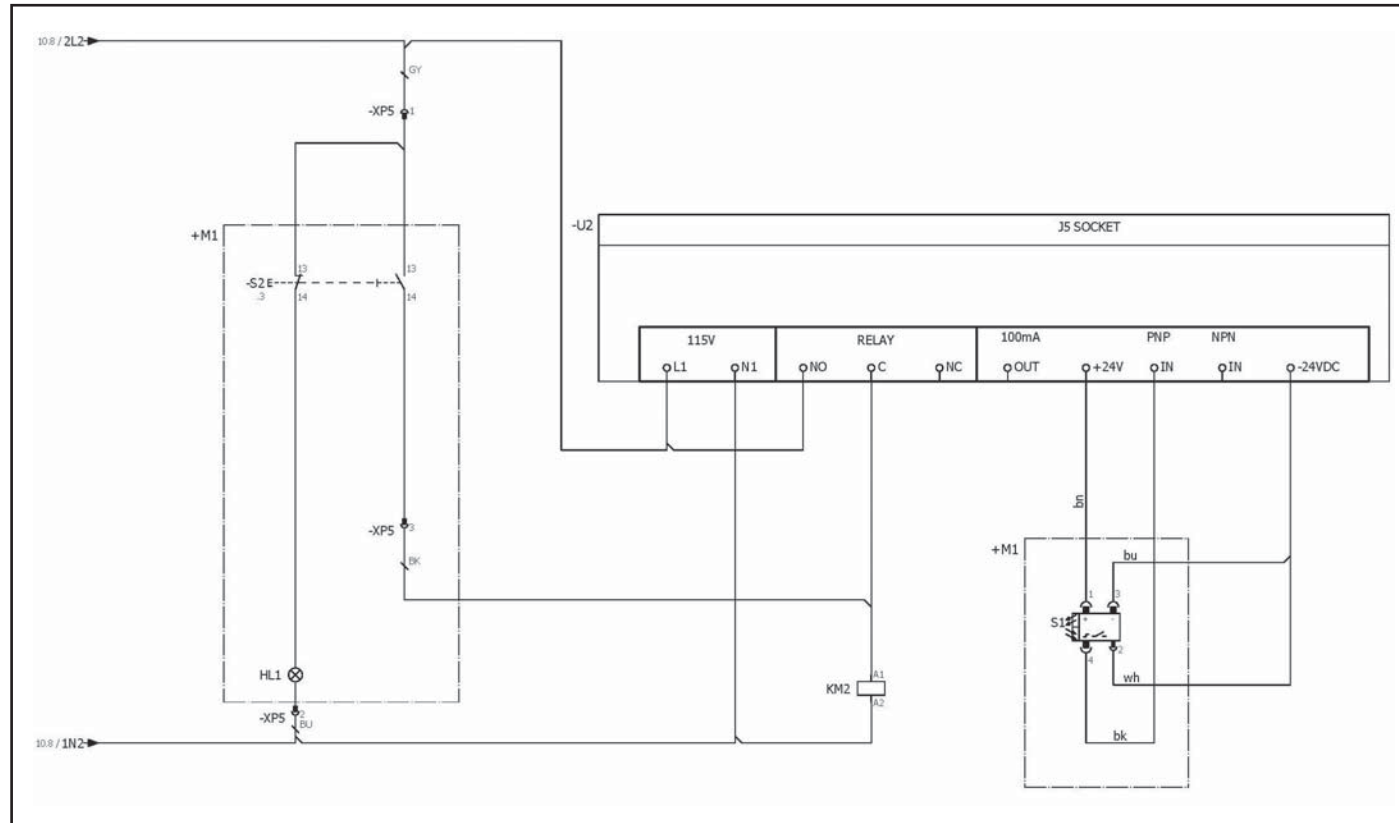


Figure 18-2 Electrical Diagram

WARNING

- 800af-NA



2013 February

19 - SPARE AND MISCELLANEOUS PARTS

19.1 Spare Parts

The following parts are normal wear items and should be ordered and kept on hand as used.

Qty.	Part Number	Description
2	78-8076-4865-0	Belt – Drive W/Pin

All the above listed parts can be ordered separately and when used should be ordered and kept on hand for spares.

Also see Manual 2 for recommended taping head spare parts.

19.2 Labels

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

19.3 Tool and Parts Kit

A tool kit, part number TBA, 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.

19.4 Replacement Parts Ordering Information and Service

Refer to first page of this manual "Replacement Parts and Service Information" for parts ordering information.

20 - OPTIONS/ACCESSORIES

20.1 Options/Accessories

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

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

Part Number	Option/Accessory
78-8069-3983-7	Caster Kit Attachment
78-8069-3926-6	Low Tape Sensor Kit
70-0064-4963-4	AccuGlide™ 3 Upper Taping Head - 2 inch, Type 10800
70-0064-4962-6	AccuGlide™ 3 Lower Taping Head - 2 inch, Type 10800
70-0064-1097-4	Tape Application Monitor Kit (TAM)
78-8095-4854-4	2 Inch Tape Edge Fold Attachment – Top
78-8095-4855-1	2 Inch Tape Edge Fold Attachment – Bottom

Replacement Parts – Illustrations and Parts Lists

800af Adjustable Case Sealer, Type 41100 (2 Inch Width Taping Heads)

Frame Assemblies

1. Refer to **Frame 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.

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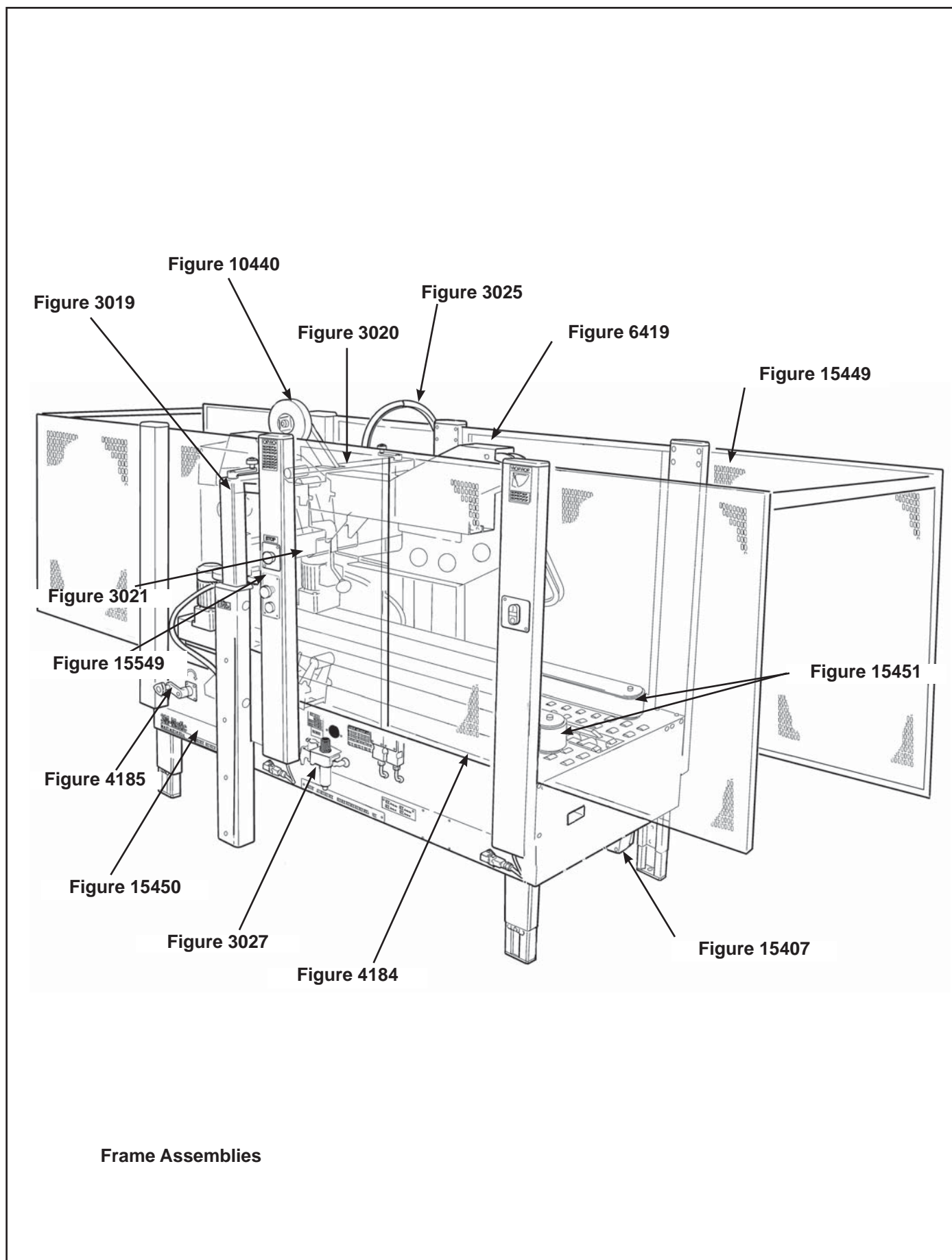


Figure 10440

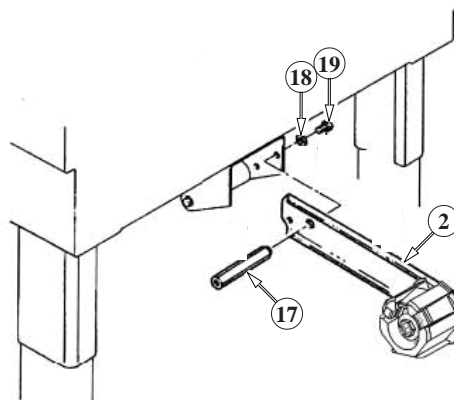
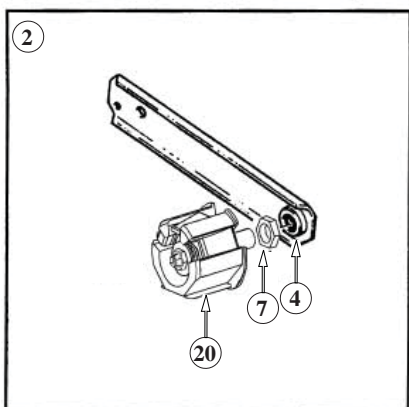
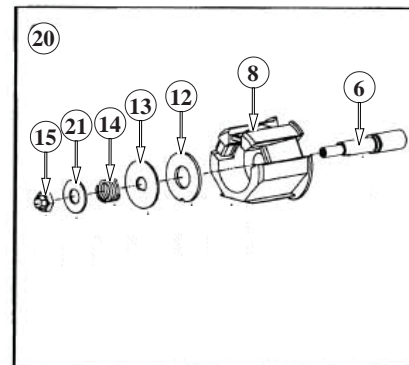
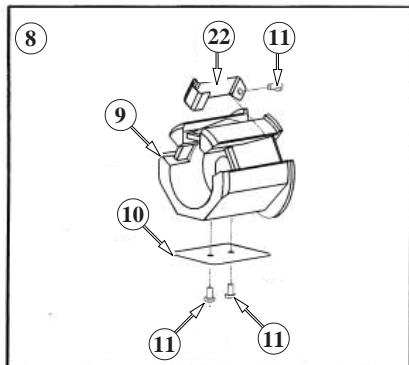
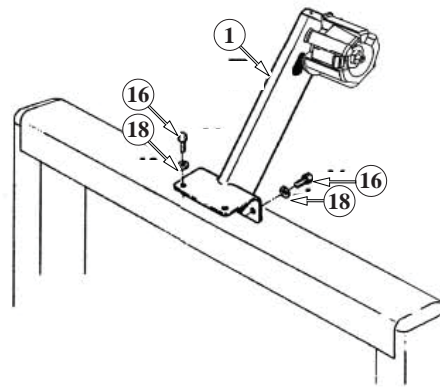
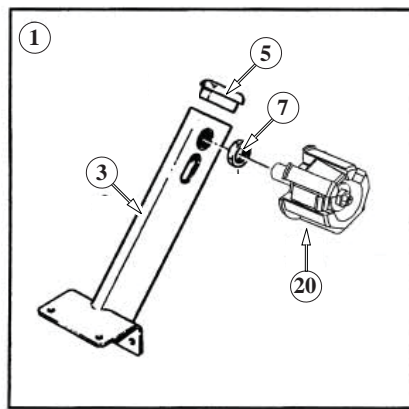


Figure 15407
(Lower)

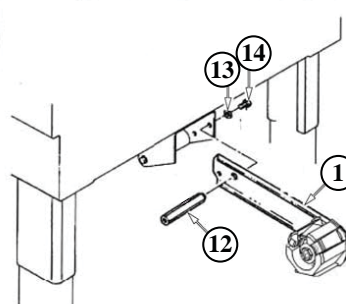
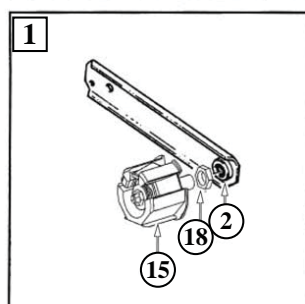
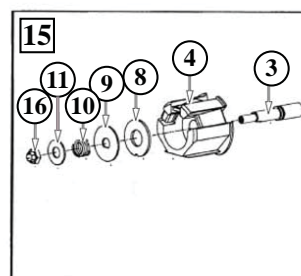
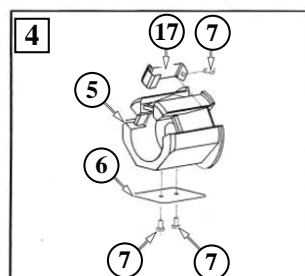


Figure 10440

Ref. No.	3M Part No.	Description
10440-1	78-8076-4633-2	Upper Tape Roll Bracket Assembly
10440-2	78-8070-1565-2	Upper Tape Drum Bracket Assembly
10440-3	78-8070-1566-0	Bracket – Upper Tape Drum
10440-4	78-8070-1395-4	Bracket – Bushing Assembly
10440-5	78-8070-1568-6	Cap – Bracket
10440-6	78-8076-4519-3	Shaft – Tape Drum
10440-7	78-8017-9169-6	Nut – M18 x 1
10440-8	78-8098-8827-0	Upper Tape Drum Sub-Assembly - 2 Inch
10440-9	78-8098-8749-6	Upper Tape Drum
10440-10	78-8098-8817-1	Leaf Spring
10440-11	26-1002-5753-9	Screw – Self Tapping
10440-12	78-8060-8172-1	Washer – Friction
10440-13	78-8052-6271-0	Washer – Tape Drum
10440-14	78-8100-1048-4	Spring – Core Holder
10440-15	78-8017-9077-1	Nut – Self Locking, M10 x 1
10440-16	78-8032-0375-7	Screw – Hex Hd, M6 x 16
10440-17	78-8070-1215-4	Spacer – Stud
10440-18	26-1000-0010-3	Washer – Flat, M6
10440-19	78-8010-7169-3	Screw – Hex Hd, M6 x 12
10440-20	78-8060-8474-1	Upper Tape Drum Assembly – 2 Inch Head
10440-21	26-1004-5510-9	Washer - Plain, M10
10440-22	78-8098-8816-3	Latch - Upper Tape Drum

Figure 15407

Ref. No.	3M Part No.	Description
15407-1	78-8070-1565-2	Lower Tape Drum Bracket Assembly
15407-2	78-8070-1395-4	Lower Bracket – Bushing Assembly
15407-3	78-8076-4519-3	Shaft – Lower Tape Drum
15407-4	78-8098-8827-0	Lower Tape Drum Sub-Assembly - 2 Inch
15407-5	78-8098-8749-6	Lower Tape Drum
15407-6	78-8098-8817-1	Leaf Spring
15407-7	26-1002-5753-9	Screw – Self Tapping
15407-8	78-8060-8172-1	Washer – Friction
15407-9	78-8052-6271-0	Washer – Tape Drum
15407-10	78-8100-1048-4	Spring – Core Holder
15407-11	78-8017-9077-1	Nut – Self Locking, M10 x 1
15407-12	78-8070-1215-4	Spacer – Stud
15407-13	26-1000-0010-3	Washer – Flat, M6
15407-14	78-8010-7169-3	Screw – Hex Hd, M6 x 12
15407-15	78-8060-8474-1	Lower Tape Drum Assembly- 2 inch Head
15407-16	26-1004-5510-9	Washer - Plain, M10
15407-17	78-8098-8816-3	Latch - Lower Tape Drum
15407-18	78-8017-9169-5	Nut - M18 x 1

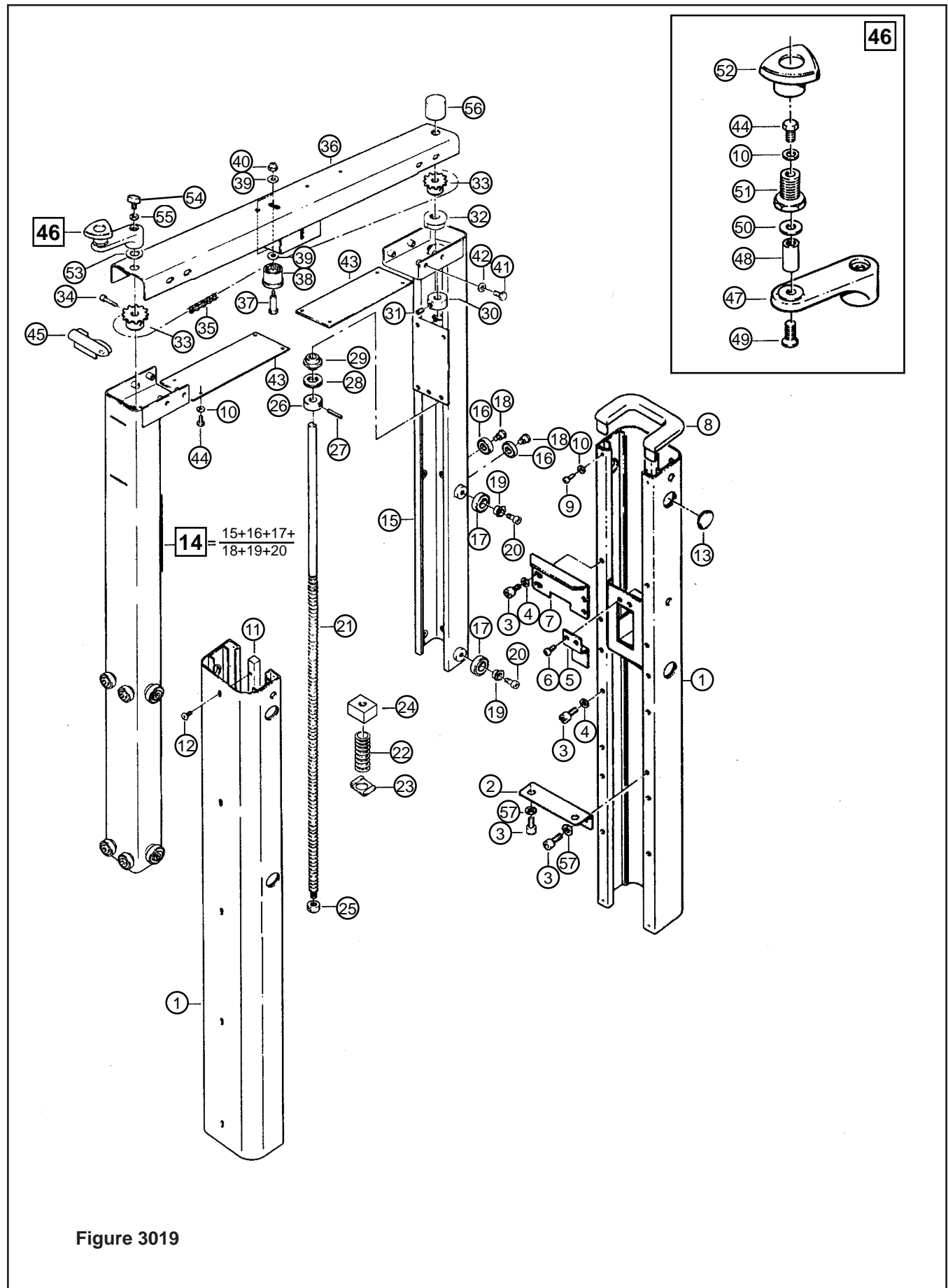


Figure 3019

Figure 3019

Ref. No.	3M Part No.	Description
3019-1	78-8076-4810-6	Column – Outer
3019-2	78-8060-8490-7	Plate – Column Mounting
3019-3	26-1003-7963-0	Screw – Soc Hd, M8 x 16
3019-4	78-8017-9318-9	Washer – Plain 8 mm
3019-5	78-8060-8493-1	Plate – Nut Stop
3019-6	78-8060-8087-1	Screw – M5 x 10
3019-7	78-8060-8492-3	Stop – Height
3019-8	78-8060-8491-5	Cap – Column
3019-9	26-1002-4955-1	Screw – Self Tap 8P x 13
3019-10	78-8005-5740-3	Washer – Plain 4 mm
3019-11	78-8076-4811-4	Guide – Outer Column
3019-12	78-8076-4503-7	Screw – M6 x 12
3019-13	78-8076-4812-2	Plug – Outer Column
3019-14	78-8076-4813-0	Column Assembly – Inner
3019-15	78-8076-4814-8	Column – Inner
3019-16	78-8059-5625-3	Bearing
3019-17	26-1000-4350-9	Bearing – 6002-2RS
3019-18	78-8076-4815-5	Screw – Bearing
3019-19	78-8076-4816-3	Bushing – Eccentric
3019-20	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
3019-21	78-8076-4817-1	Lead Screw
3019-22	78-8054-8997-4	Spring
3019-23	78-8054-8970-1	Bed Plate For Spring
3019-24	78-8091-0551-9	Nut – Lead Screw
3019-25	78-8054-8968-5	Special Nut
3019-26	78-8054-8585-7	Collar
3019-27	78-8054-8586-5	Pin
3019-28	78-8054-8584-0	Spacer
3019-29	78-8054-8583-2	Bushing
3019-30	78-8060-8497-2	Bushing – Lead Screw
3019-31	78-8059-5617-0	Set Screw – M6 x 8
3019-32	78-8060-8498-0	Bushing – Inner Column
3019-33	78-8060-8499-8	Sprocket – 3/8 Inch Z=13
3019-34	26-1003-7946-5	Screw – Soc Hd, M4 x 25
3019-35	78-8076-4818-9	Chain – 3/8 Inch Pitch 197 Pitch
3019-36	78-8076-4819-7	Crossmember – Chain
3019-37	78-8060-7878-4	Idler Screw
3019-38	78-8070-1503-3	Roller – Chain Tensioning
3019-39	78-8042-2919-9	Washer – Triple, M6
3019-40	26-1003-6916-9	Nut – Locking Plastic Insert M6
3019-41	26-1003-5829-5	Screw – Hex Hd. M6 x 12
3019-42	26-1000-0010-3	Washer – Flat M6
3019-43	78-8076-4820-5	Cover – Chain
3019-44	78-8010-7157-8	Screw – Hex Hd, M4 x 10
3019-45	78-8070-1505-8	Cap – Inner Column
3019-46	78-8076-4807-2	Crank Assembly
3019-47	78-8076-5422-9	Crank
3019-48	78-8070-1509-0	Shaft – Crank
3019-49	26-1005-5316-8	Screw – Flat Hd Hex Dr, M5 x 16
3019-50	78-8070-1510-8	Washer – Nylon, / 7 x 15 x 1
3019-51	78-8070-1511-6	Bushing
3019-52	78-8070-1512-4	Knob – VTR-B-M12
3019-53	78-8076-4800-7	Washer – Crank
3019-54	78-8076-4821-3	Key – Stop
3019-55	78-8076-4809-8	Washer – Crank
3019-56	78-8070-1506-6	Cover – Screw
3019-57	26-1004-5507-5	Washer – M8

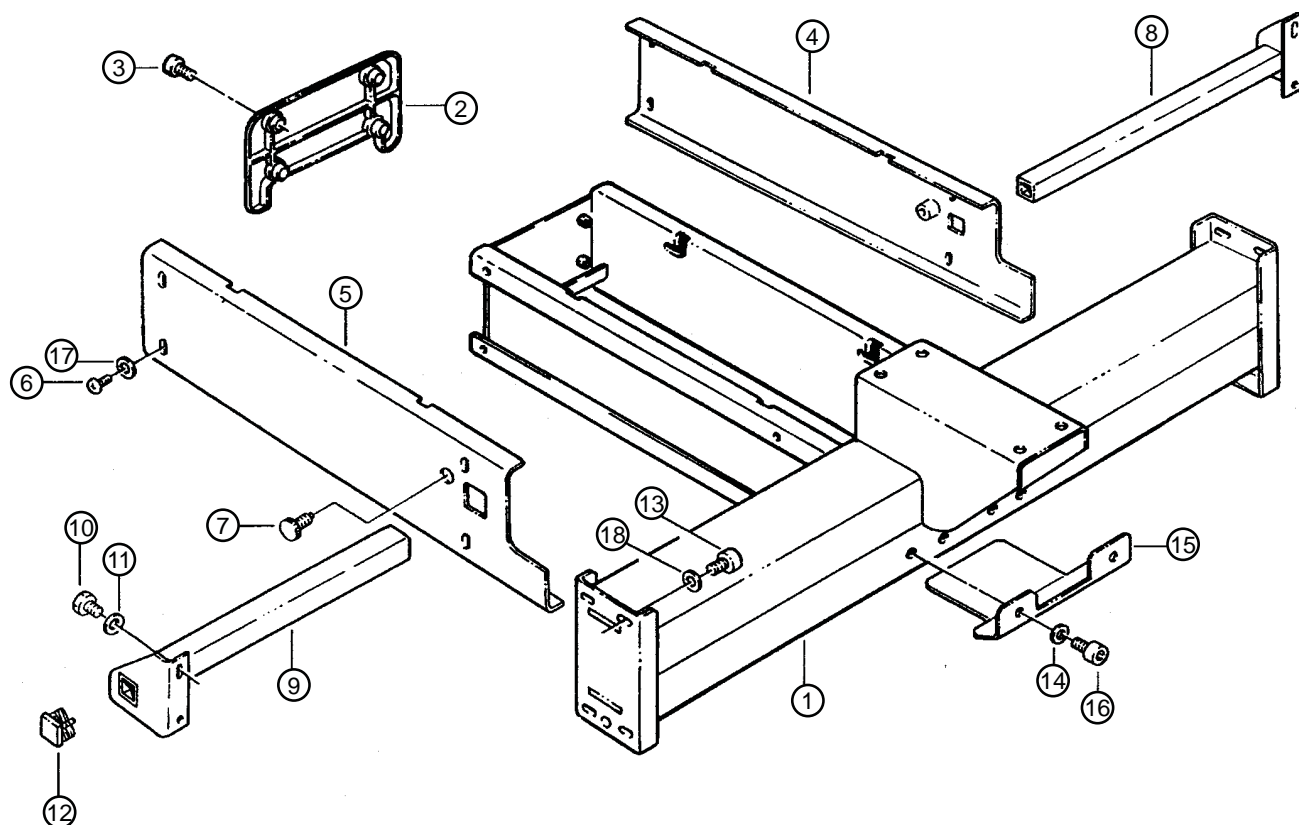


Figure 3020

Figure 3020

Ref. No.	3M Part No.	Description
3020-1	78-8076-4822-1	Support – Upper Head
3020-2	78-8076-4823-9	Cover – Rear
3020-3	26-1003-7951-5	Screw – Soc Hd Hex Soc, M5 x 20
3020-4	78-8113-6898-0	Frame Assembly – Upper, R/H (W/English Language Label)
3020-5	78-8113-6897-2	Frame Assembly – Upper, L/H (W/English Language Label)
3020-6	78-8060-8087-1	Screw – M5 x 10
3020-7	78-8070-1555-3	Block – Upper Head
3020-8	78-8076-4826-2	Support – Right Roller
3020-9	78-8076-4827-0	Support – Left Roller
3020-10	78-8032-0375-7	Screw – Hex Hd, M6 x 16
3020-11	78-8042-2919-9	Washer – Triple, M6
3020-12	78-8052-6652-1	Cap – End
3020-13	26-1003-7964-8	Screw – Soc Hd Hex Soc Dr, M8 x 20
3020-14	78-8017-9318-9	Washer – Plain 8 mm
3020-15	78-8114-4786-7	Slide
3020-16	26-1003-7963-0	Screw – Soc Hd, M8 x 16
3020-17	78-8100-1036-9	Washer

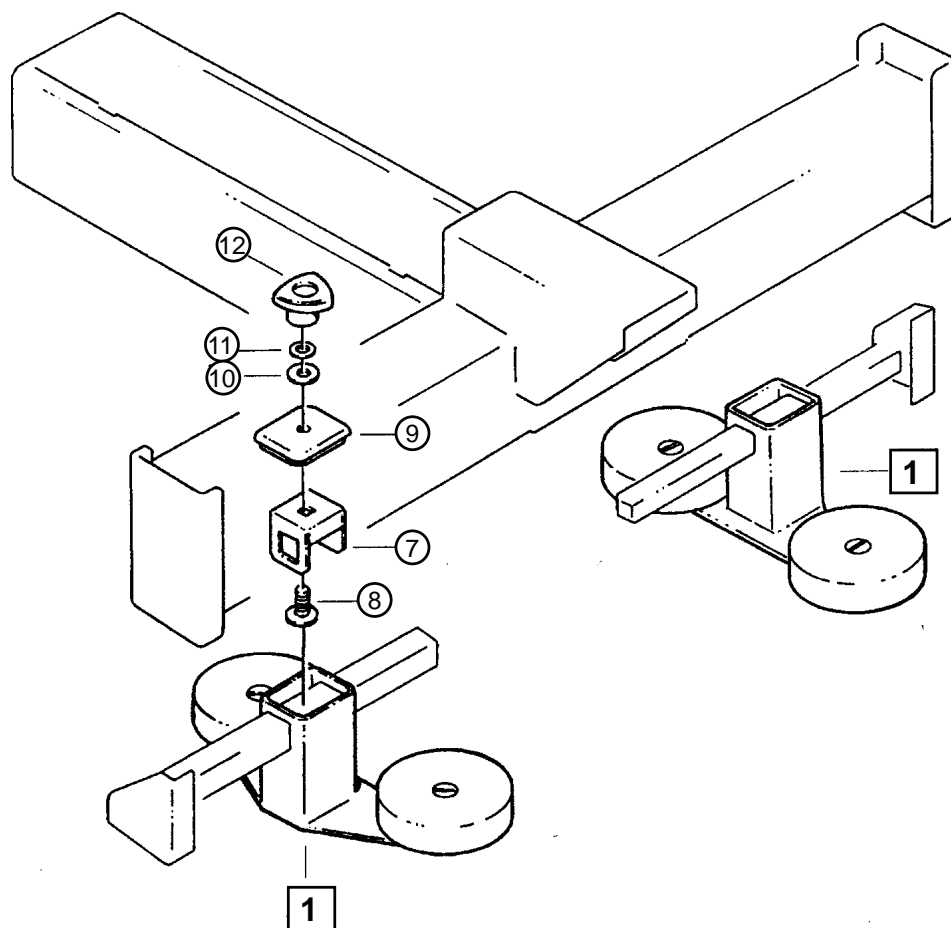
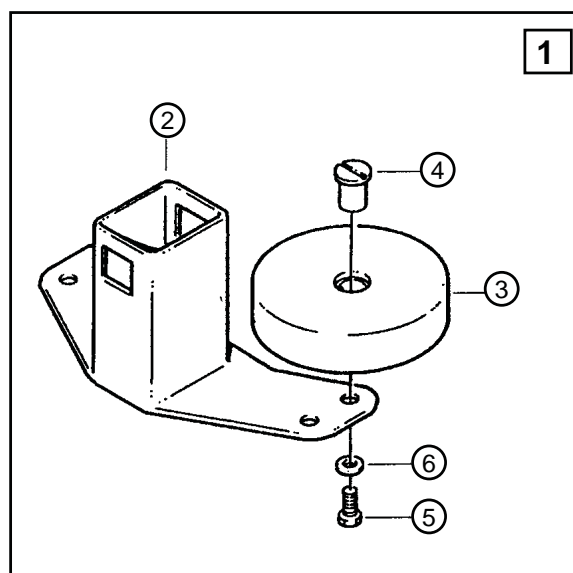


Figure 3021



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Figure 3021

Ref. No.	3M Part No.	Description
3021-1	78-8076-4626-6	Compression Roller Assembly
3021-2	78-8113-6899-8	Compression Roller Support Assembly (W/English Language Label)
3021-3	78-8076-4628-2	Roller – Compression
3021-4	78-8076-4629-0	Shaft – Roller
3021-5	26-1003-5841-0	Screw – M8 x 16
3021-6	78-8017-9318-9	Washer – Plain 8 mm
3021-7	78-8076-4630-8	Plate – Tube, Roller
3021-8	78-8076-4631-6	Screw – M10 x 35
3021-9	78-8076-4632-4	Cap – Support
3021-10	78-8017-9074-8	Washer – Nylon 15 mm
3021-11	78-8052-6566-3	Washer – Friction
3021-12	78-8070-1549-6	Knob – VTR-B-M10

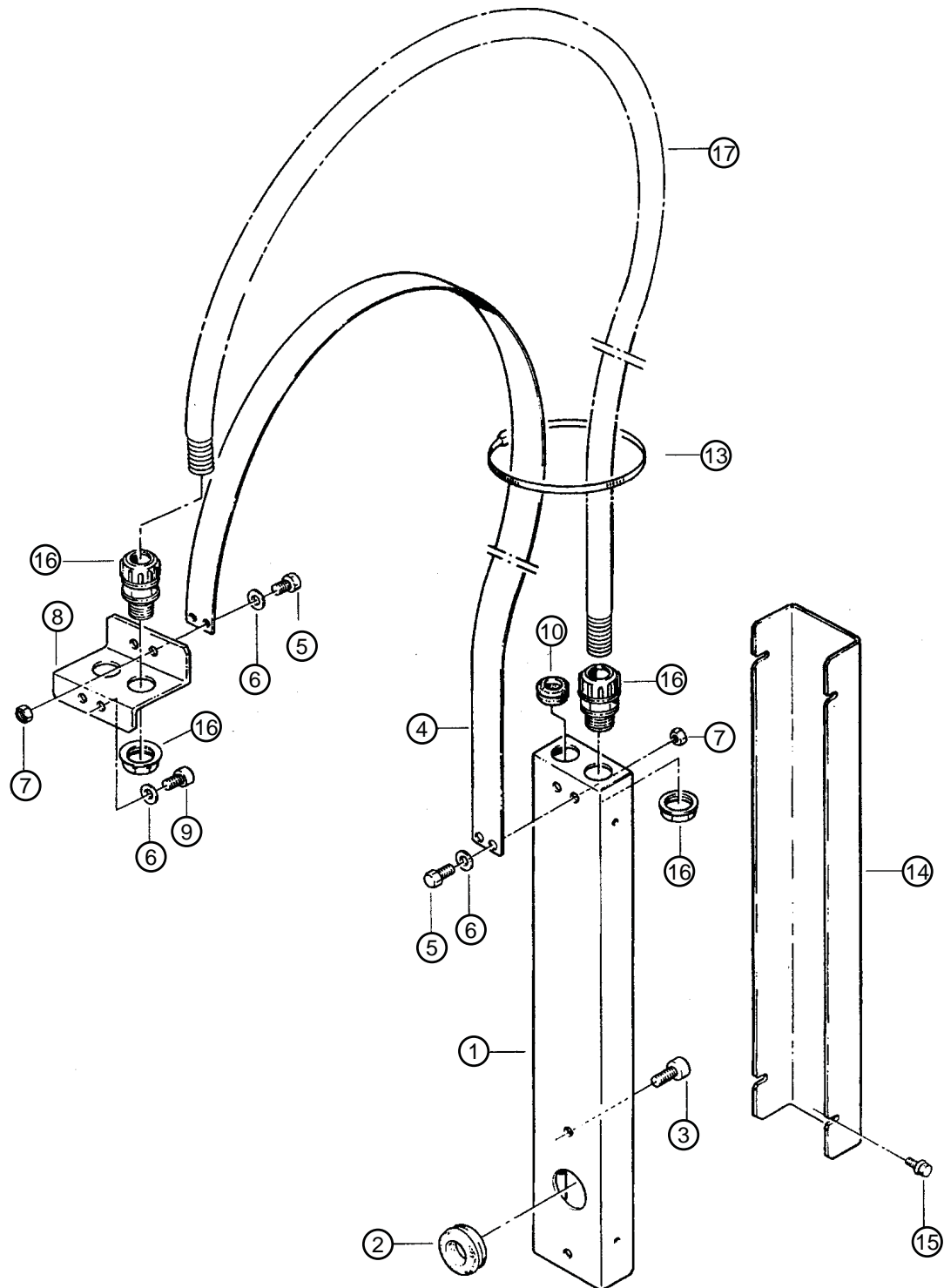


Figure 3025

Figure 3025

Ref. No.	3M Part No.	Description
3025-1	78-8091-0660-8	Housing – Wire
3025-2	78-8076-4702-5	Grommet /28
3025-3	26-1003-7963-0	Screw – Soc Hd, M8 x 16
3025-4	78-8076-4872-6	Strap – Wire
3025-5	78-8010-7163-6	Screw – Hex Hd, M5 x 10
3025-6	78-8005-5741-1	Washer – Plain, M5
3025-7	78-8010-7417-6	Nut – Hex, M5
3025-8	78-8076-4873-4	Plate – Strap
3025-9	26-1003-7949-9	Screw – Soc Hd Hex Soc, M5 x 12
3025-10	78-8060-7758-8	Fairlead /20
3025-13	78-8060-8029-3	Clamp – 140X3,5
3025-14	78-8076-4641-5	Cover
3025-15	78-8076-4875-9	Screw – Hex Hd, M4 x 8 W/Ext.
3025-16	78-8076-4520-1	Union PG13 – Sleeve /16
3025-17	78-8076-5229-8	Sleeving – /16, 1180mm

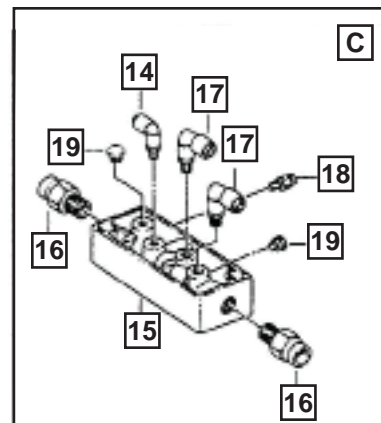
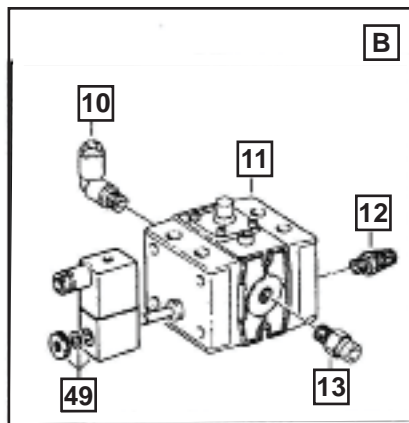
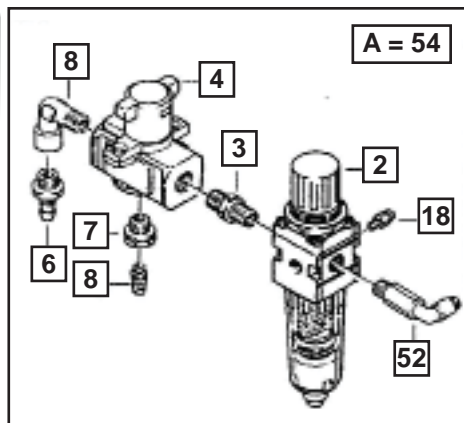
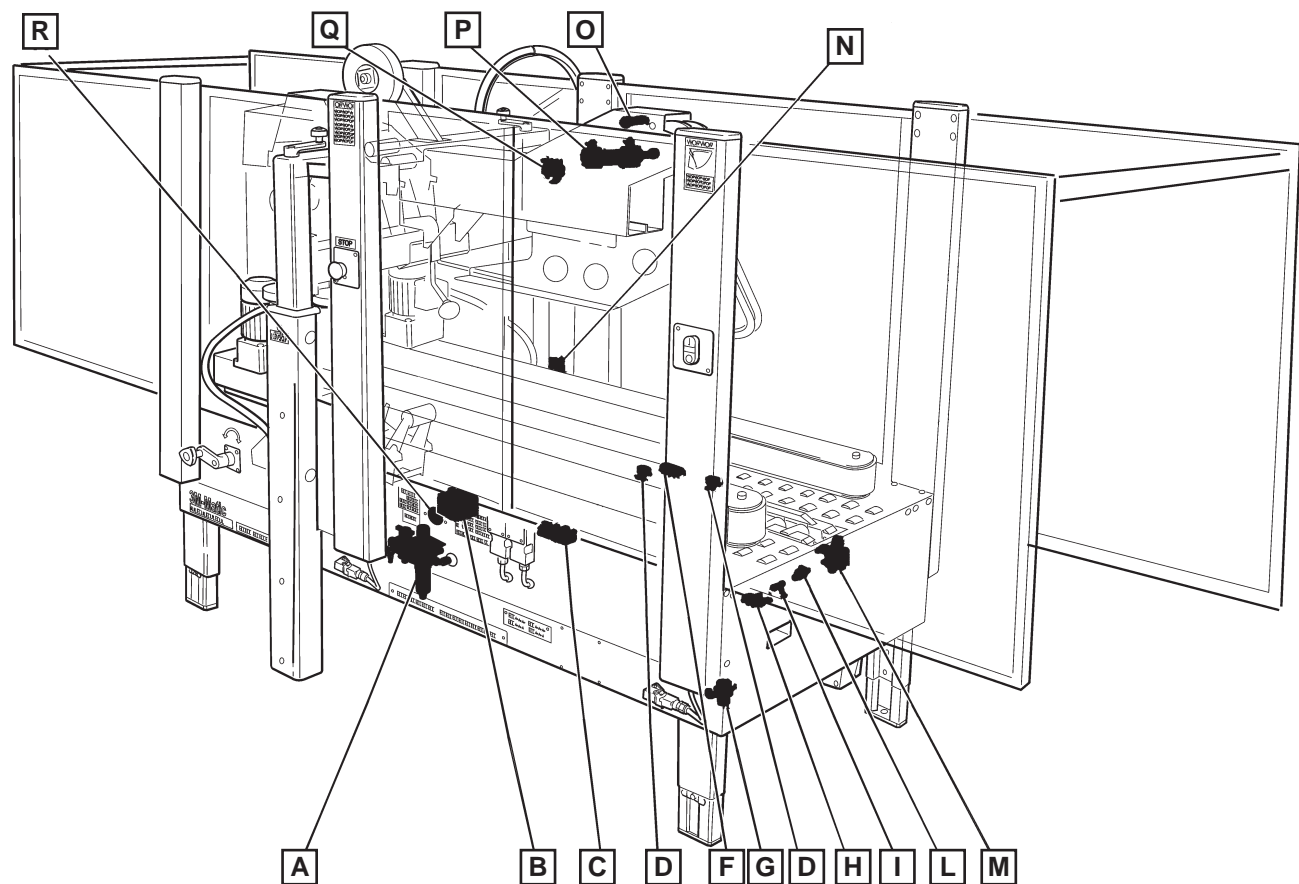


Figure 3027 / 1

Figure 3027 / 1

Ref. No.	3M Part No.	Description
3027-2	78-8076-4668-8	Filter – Pressure Regulator
3027-3	78-8060-7899-0	Nipple – RA 012, 1/4 Inch - 1/4 Inch
3027-4	78-8091-0715-0	Valve – SMC EVHS-4500 FO2-X116
3027-5	78-8060-7900-6	Union – RA 022, 1/4 Inch - 1/4 Inch
3027-6	26-1005-6897-6	Hose Connector
3027-7	78-8076-4670-4	Reduction – 3/8 Inch - 1/8 Inch
3027-8	26-1005-6890-1	Muffler
3027-9	78-8054-8838-0	Gauge – Air
3027-10	78-8076-4885-8	Elbow – KQL08-02S
3027-11	78-8091-0419-9	Valve – MFHE-3-1/4 Inch
3027-12	78-8076-4886-6	Muffler – 1/4 Inch
3027-13	78-8076-4887-4	Union – Straight KQH08-02S
3027-14	78-8076-4888-2	Elbow – KQL04-01S
3027-15	78-8060-7651-5	Union – FR-8-1/8 Inch
3027-16	78-8076-4889-0	Union – Straight KHQ08-03S
3027-17	78-8076-4890-8	Elbow – KQL06-01S
3027-18	78-8076-4891-6	Union – Straight KQH04-01S
3027-19	78-8060-7690-3	Cap – B-1/8 Inch
3027-20	26-1005-6358-9	3-Way – 2 Position Valve
3027-21	78-8076-4892-4	Elbow – KQL04-M5
3027-23	78-8060-7656-4	Valve – VLK3-PK3
3027-24	78-8076-4894-0	Pressure Regulator – EAR111
3027-25	78-8076-4895-7	Elbow – KQL06-02S
3027-26	78-8076-4896-5	Union – Straight KQH06-02S
3027-27	78-8076-4677-9	Valve – V2A 5120-01
3027-28	78-8076-4897-3	Union – Straight KQH06-01S
3027-29	78-8076-4898-1	Union – KQT06-00

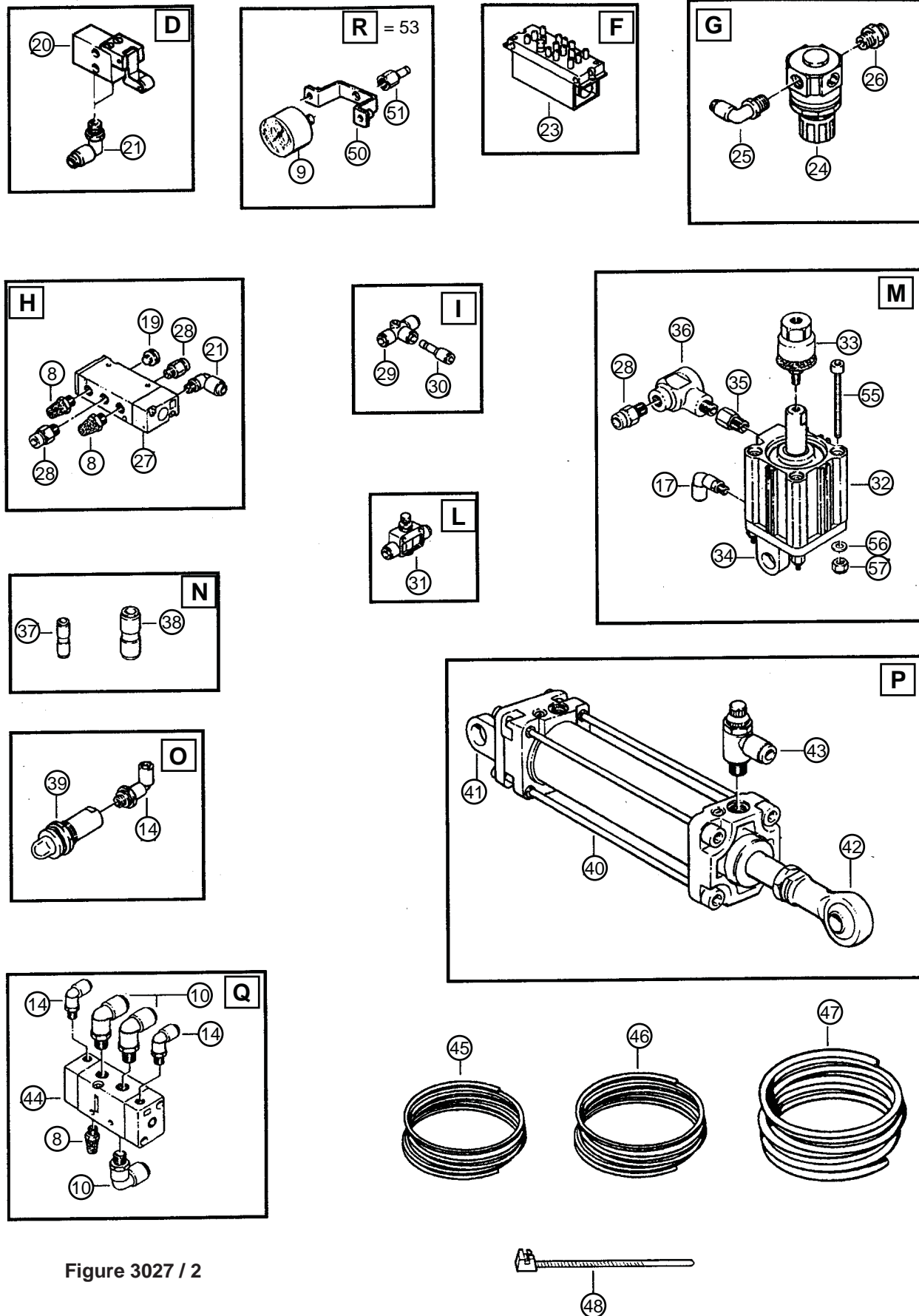


Figure 3027 / 2

Figure 3027 / 2

Ref. No.	3M Part No.	Description
3027-30	78-8076-4899-9	Union – Straight KQR04-06
3027-31	78-8076-4900-5	Flow Regulator – AS2000F-06
3027-32	78-8076-4901-3	Air Cylinder – SMC ECQ 2B 40-25
3027-33	78-8076-4902-1	Ball Joint – CQ2
3027-34	78-8076-4903-9	Hinge – Cylinder /40
3027-35	78-8076-4904-7	Extension
3027-36	78-8013-9935-9	Valve – Quick Exhaust
3027-37	78-8076-4905-4	Union – KQH04-00
3027-38	78-8076-4906-2	Union – KQH08-00
3027-39	78-8076-4665-4	Indicator – Visual
3027-40	78-8076-4907-0	Air Cylinder – C92SB40-125
3027-41	78-8076-4908-8	Hinge
3027-42	78-8057-5747-9	Mount – Cylinder Rod End
3027-43	78-8076-4909-6	Flow Regulator – EAS2200F02-085
3027-44	78-8076-4910-4	Valve – EVFA 3230-02F
3027-45	78-8060-8033-5	Tubing – D4/3
3027-46	78-8060-8034-3	Tubing – D6/4
3027-47	78-8076-4911-2	Tubing – D8X6, 5MT
3027-48	78-8076-5228-0	Clamp – 95X2.4
3027-49	78-8091-0420-7	Coil – Magnetic, MSFW 110V, 50/60HZ
3027-50	78-8076-4535-9	Bracket
3027-51	78-8076-4672-0	Union – Straight, Female
3027-52	78-8091-0422-3	Elbow – KQW08-02S
3027-53	78-8091-0423-1	Gauge – W/Support
3027-54	78-8091-0424-9	Filter/Regulator Assembly
3027-55	78-8060-7582-2	Screw – Soc Hd Hex Soc, M5 x 70
3027-56	78-8005-5741-1	Washer – Plain, M5
3027-57	26-1005-6859-6	Nut – Self-Locking, M5

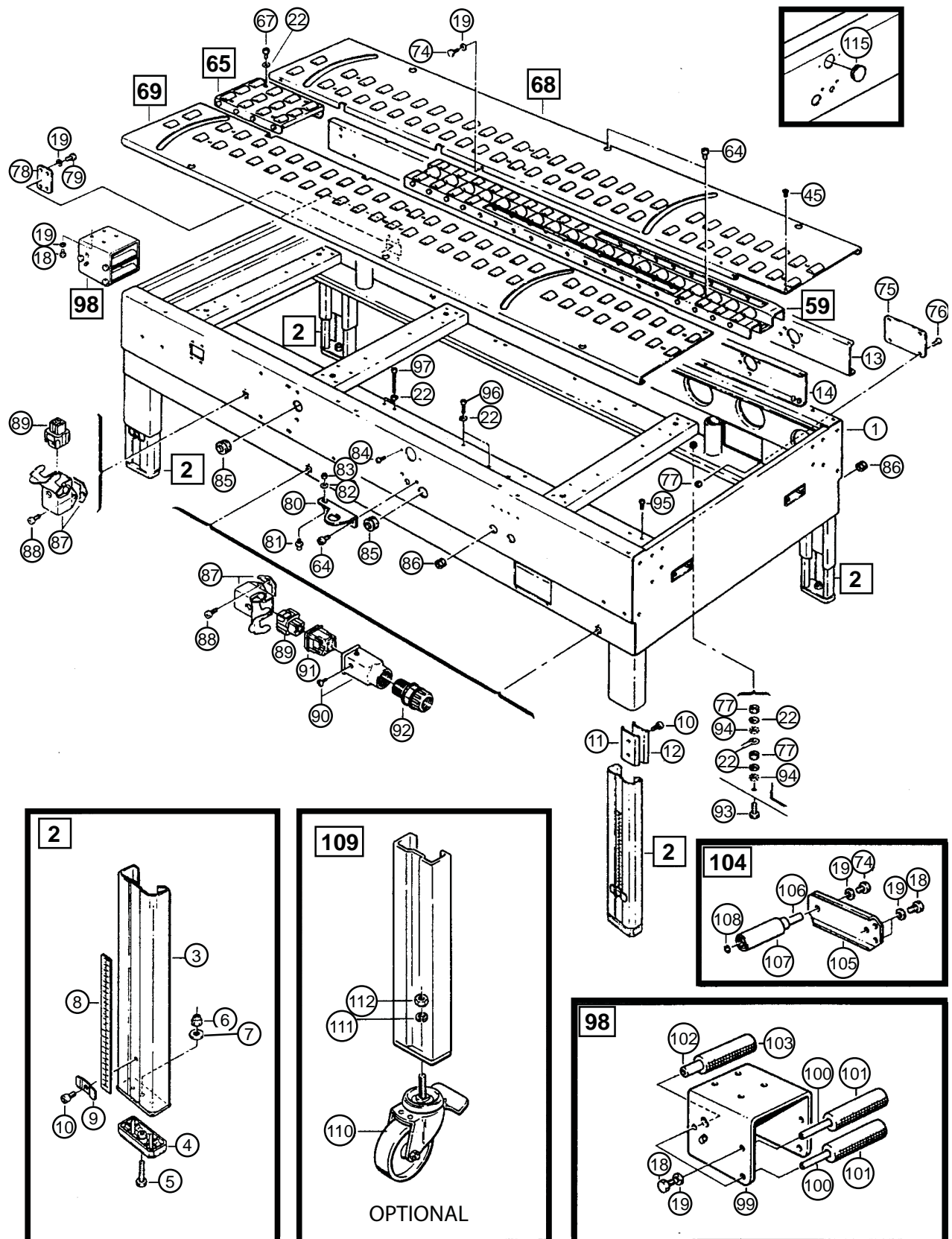


Figure 4184 / 1

Figure 4184 / 1

Ref. No.	3M Part No.	Description
4184-1	78-8076-4747-0	Bed Conveyor
4184-2	78-8076-5381-7	Leg Assembly – Inner, W/Stop
4184-3	78-8076-5382-5	Leg – Inner
4184-4	78-8060-8480-8	Pad – Foot
4184-5	78-8055-0867-4	Screw
4184-6	78-8017-9313-0	Nut – Self-Locking, M8
4184-7	78-8017-9318-9	Washer – Plain, 8 mm
4184-8	78-8060-8481-6	Label – Height
4184-9	78-8076-5383-3	Stop – Leg
4184-10	26-1003-7963-0	Screw – Soc Hd, M8 x 16
4184-11	78-8052-6677-8	Clamp – Inner
4184-12	78-8052-6676-0	Clamp – Outer
4184-13	78-8076-4748-8	Center Frame – Right
4184-14	78-8076-4749-6	Center Frame – Left
4184-15	26-1003-7964-8	Screw – Soc Hd Hex Soc Dr, M8 x 20
4184-16	78-8060-7722-4	Spacer – L=144
4184-17	78-8091-0696-2	Spacer
4184-18	78-8032-0375-7	Screw – Hex Hd, M6 x 16
4184-19	26-1000-0010-3	Washer – Flat, M6
4184-20	78-8076-4751-2	Bearing Support – Gate
4184-21	78-8032-0382-3	Screw – Soc Hex Hd, M5 x 16
4184-22	78-8005-5741-1	Washer – Plain, M5
4184-23	78-8076-4752-0	Gate
4184-24	78-8076-4753-8	Spacer – Gate
4184-25	78-8076-4754-6	Washer – Special, Gate
4184-26	78-8076-4755-3	Support – Cylinder, Gate
4184-27	78-8076-4756-1	Shaft – Cylinder, Gate
4184-28	78-8056-3965-1	Ring – 8 DIN 6799
4184-29	78-8076-4757-9	Bumper

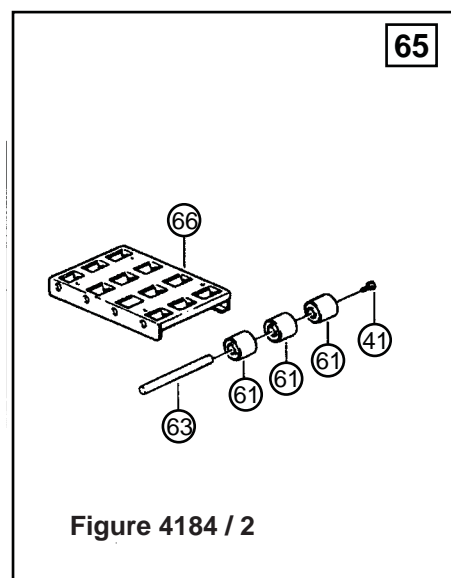
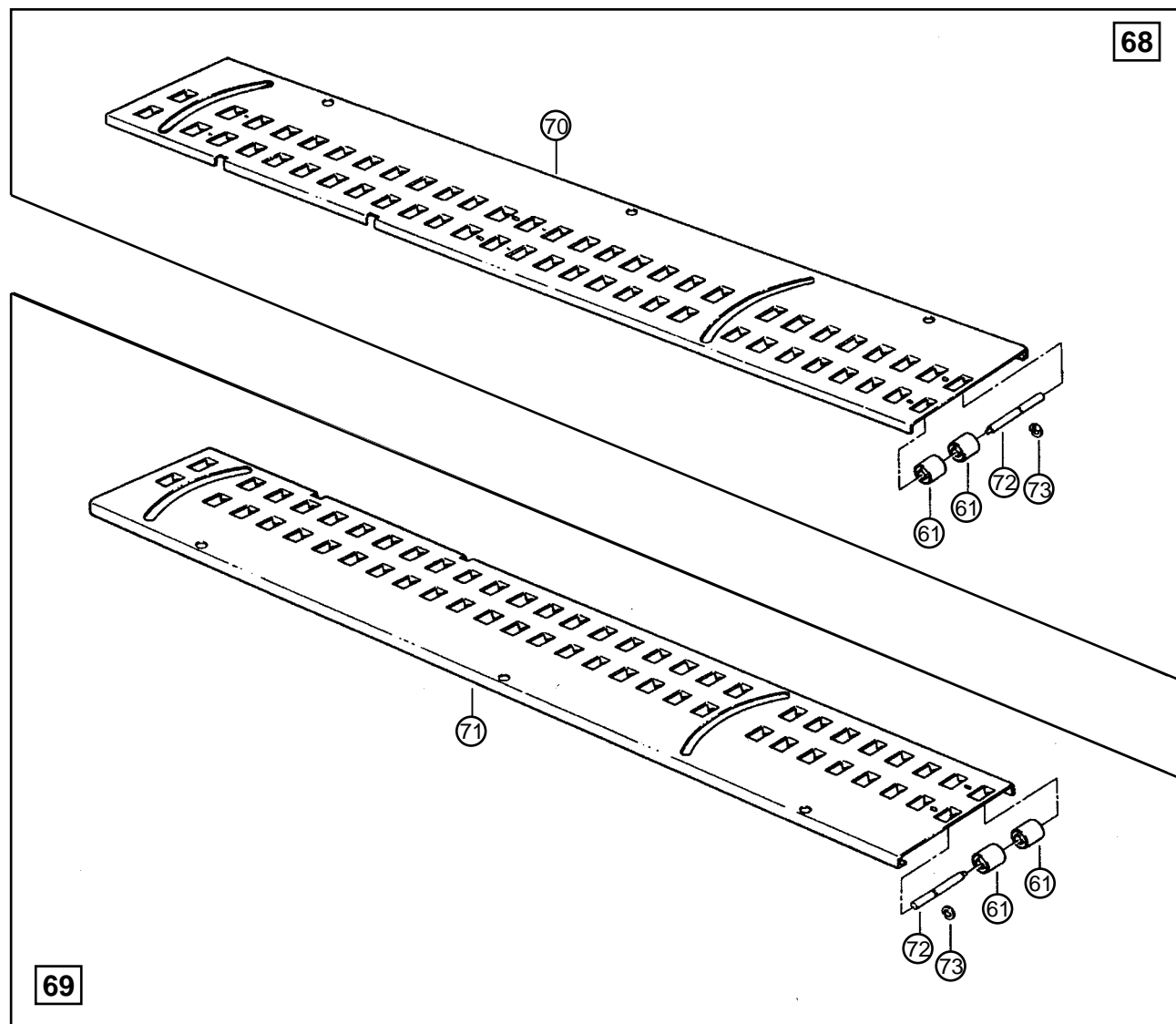


Figure 4184 / 2

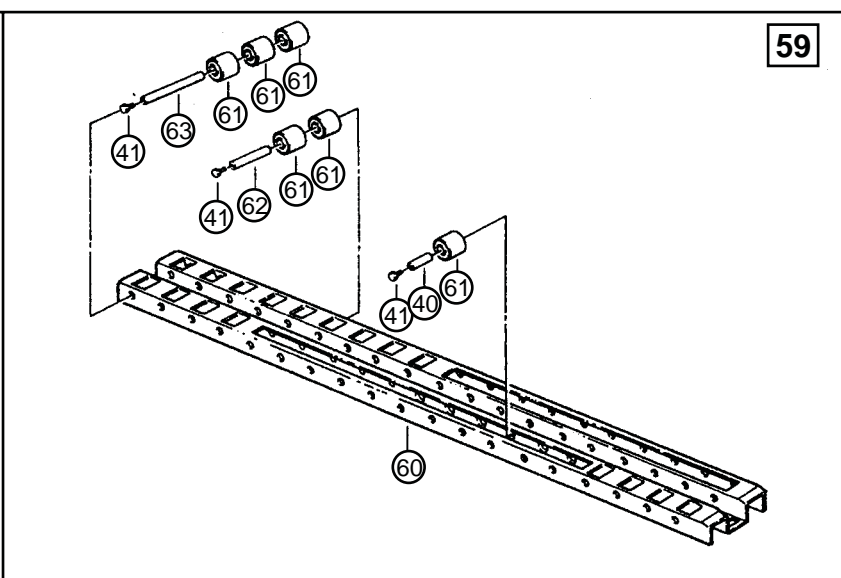


Figure 4184 / 2

Ref. No.	3M Part No.	Description
4184-30	78-8076-4772-8	Support Assembly W/Cam – Gate
4184-31	78-8076-4773-6	Support Assembly – Cam, Gate
4184-32	26-1003-7947-3	Screw – Soc Hd Hex Soc, M4 x 35
4184-33	78-8054-8758-0	Spacer – Valve Holder
4184-34	78-8059-5607-1	Plate – Threaded
4184-35	78-8054-8757-2	Pin – Spring Holder
4184-36	26-1005-6859-6	Nut – Self-Locking, M5
4184-37	78-8076-4774-4	Spring
4184-38	78-8055-0746-0	Link – Front Actuator, 12AF Black
4184-39	78-8055-0747-8	Link – Rear Actuator, 12AF Black
4184-40	78-8054-8857-0	Shaft – 8 x 43 mm
4184-41	78-8010-7163-6	Screw — Hex Hd, M5 x 10
4184-42	26-1002-4955-1	Screw – Self-Tap, 8P x 13
4184-43	78-8076-4775-1	Support Assembly– Cam
4184-44	78-8054-8858-8	Spacer – 8 x 26,5 mm
4184-45	26-1002-3866-1	Screw – Flat Hd Hx Dr, M5 x 10
4184-46	78-8076-4776-9	Cam – Long
4184-47	78-8076-4777-7	Cam – Short
4184-48	26-1003-7953-1	Screw – Soc Hd, M5 x 30
4184-49	78-8023-2334-1	Screw – Soc Hd, Hex Soc, M6 x 25
4184-50	78-8076-4778-5	Actuator Assembly
4184-51	78-8076-4779-3	Support – Actuator
4184-52	26-1003-6914-4	Nut – Plastic Insert, M4
4184-53	78-8005-5740-3	Washer – Plain, 4 mm
4184-54	78-8076-4780-1	Guide – Right, Actuator
4184-55	78-8076-4781-9	Guide – Left, Actuator
4184-56	78-8076-4782-7	Actuator – Flap Folder
4184-57	78-8076-4784-3	Screw – Soc Hd Hex Hd, M6 x 35

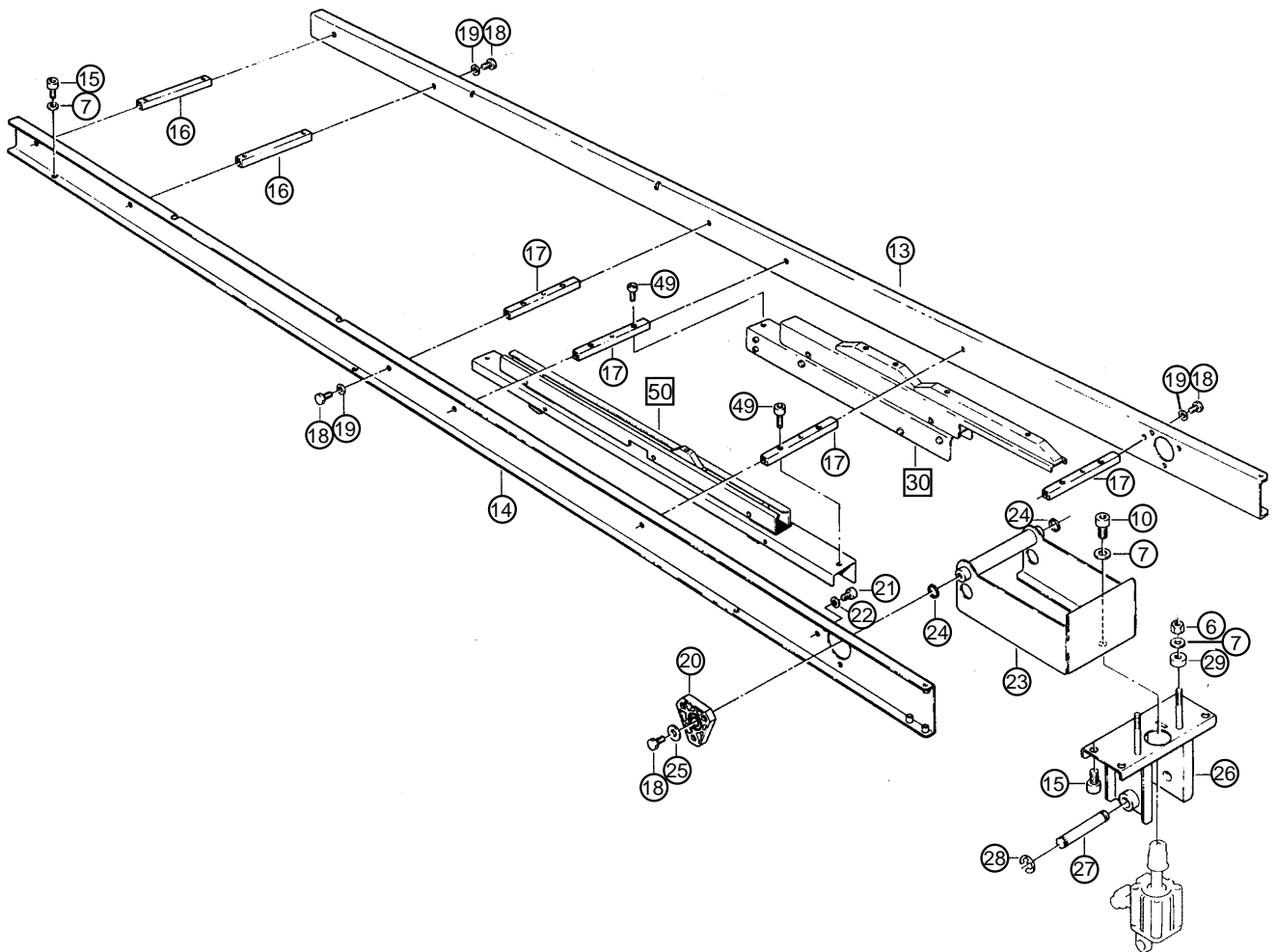


Figure 4184 / 3

Figure 4184 / 3

Ref. No.	3M Part No.	Description
4184-58	78-8076-4783-5	Plate – Actuator
4184-59	78-8076-4764-5	Conveyor Assembly – Center
4184-60	78-8091-0356-3	Conveyor – Center
4184-61	78-8060-7693-7	Roller – 32 x 38
4184-62	78-8076-4766-0	Shaft – /8 x 83
4184-63	78-8052-6694-3	Shaft – /8 x 128
4184-64	78-8010-7209-7	Screw – Soc Hd, M6 x 12
4184-65	78-8076-4762-9	Conveyor Assembly – Rear
4184-66	78-8076-4763-7	Conveyor – Rear
4184-67	26-1003-7948-1	Screw – Soc Hd Hex Soc, M5 x 10
4184-68	78-8076-4767-8	Conveyor Assembly – Right
4184-69	78-8076-4768-6	Conveyor Assembly – Left
4184-70	78-8113-6901-2	R/H Conveyor Label Assembly (W/English Language Label)
4184-71	78-8113-6902-0	L/H Conveyor Label Assembly (W/English Language Label)
4184-72	78-8076-4771-0	Shaft – Roller
4184-73	78-8060-8035-0	E-Ring – 7DIN6799
4184-74	78-8010-7169-3	Screw – Hex Hd, M6 x 12
4184-75	78-8060-8487-3	Cover – Switch
4184-76	78-8060-8087-1	Screw – M5 x 10
4184-77	78-8010-7417-6	Nut – Hex, M5
4184-78	78-8076-4761-1	Plate
4184-79	26-1003-5829-5	Screw – Hex Hd, M6 x 12
4184-80	78-8091-0612-9	Plate – L/H
4184-81	78-8091-0613-7	Shaft – Valve
4184-82	78-8042-2919-9	Washer – Triple, M6
4184-83	26-1003-6916-9	Nut – Locking Plastic Insert, M6
4184-84	78-8076-4625-8	Screw – Special, M5 x 16
4184-85	78-8076-4702-5	Grommet – /28
4184-86	78-8060-7758-8	Fairlead /20

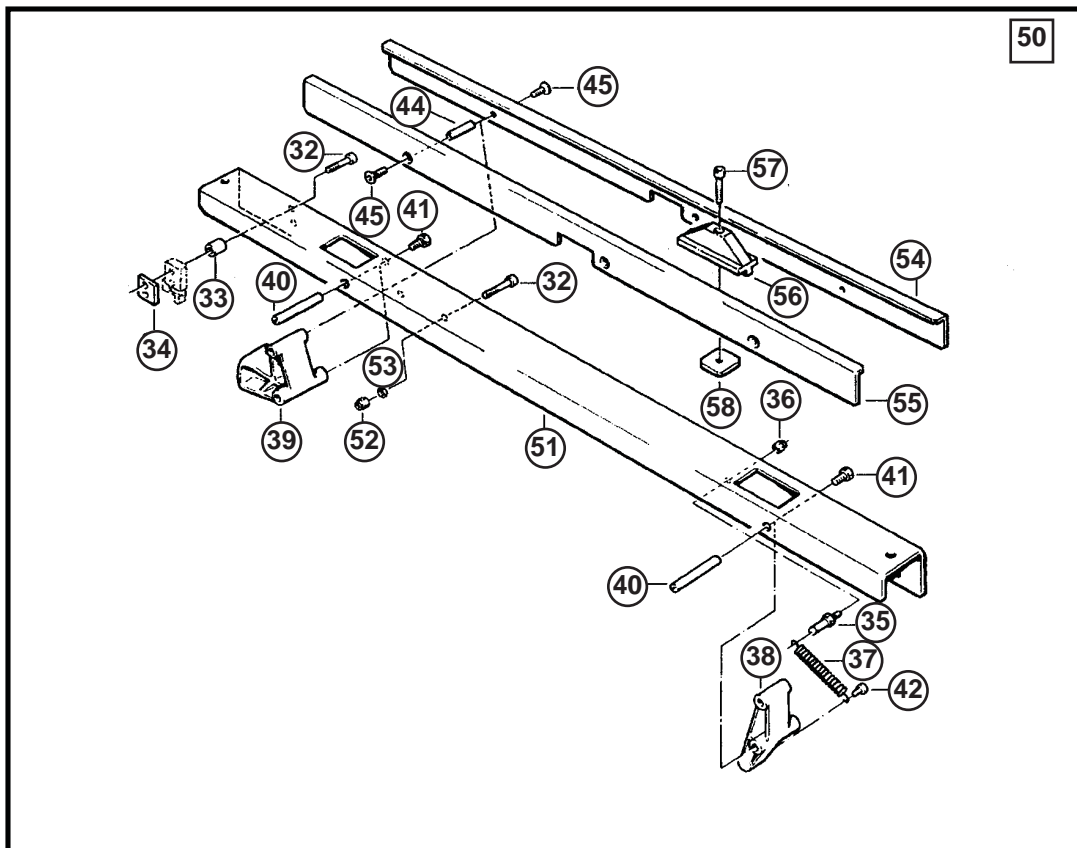
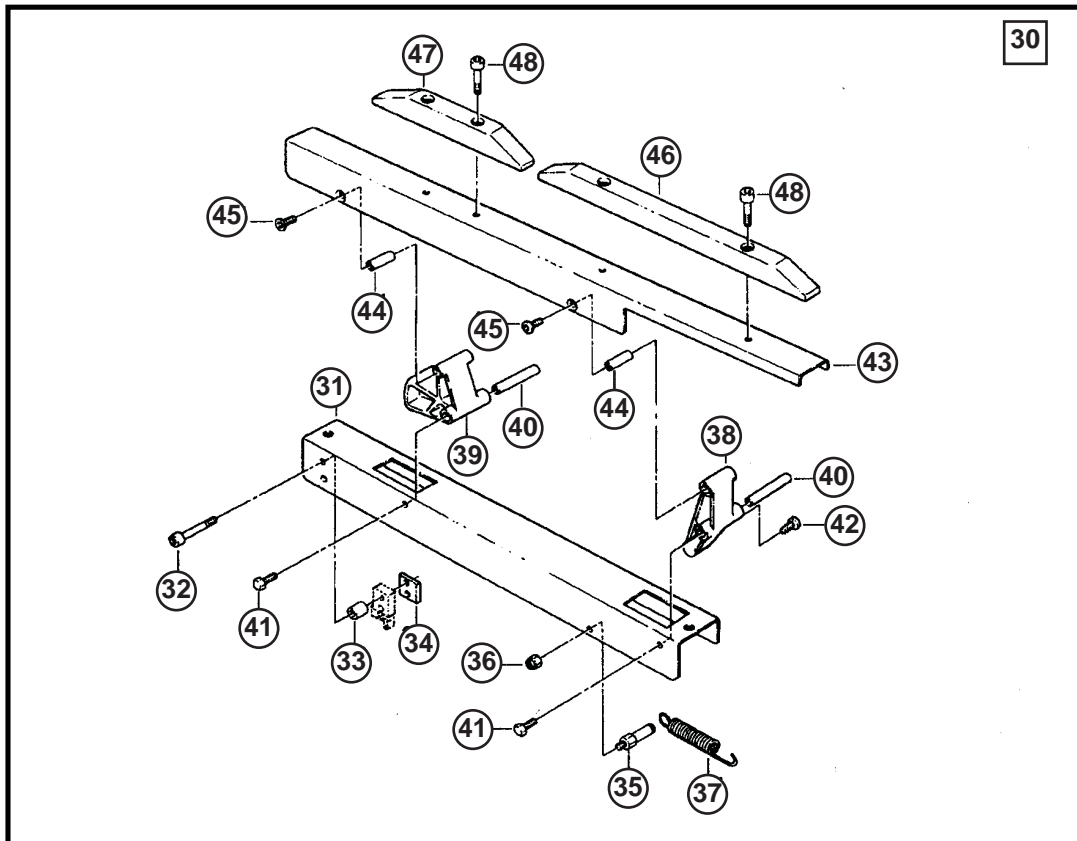


Figure 4184 / 4

Figure 4184 / 4

Ref. No.	3M Part No.	Description
4184-87	78-8060-7876-8	Cover Plug – Lateral
4184-88	78-8028-8208-0	Screw – 6P x 9,5
4184-89	78-8060-7873-5	Plug – Female
4184-90	78-8060-7877-6	Plug Housing – Vertical
4184-91	78-8060-7875-0	Plug – Male
4184-92	78-8076-4532-6	Union
4184-93	78-8060-8488-1	Screw – Hex Hd, M5 x 20
4184-94	78-8046-8217-3	Washer – Special
4184-95	78-8094-6479-1	Screw – Self-Tapping. 6P x 30
4184-96	26-1003-7954-9	Screw - Soc Hd, M5 x 35
4184-97	78-8060-7582-2	Screw – Soc Hd Hex Soc, M5 x 70
4184-98	78-8076-5025-0	Support Assembly – Tape Roll Bracket
4184-99	78-8076-5027-6	Support – Tape Roll Bracket
4184-100	78-8076-5028-4	Shaft – Roller
4184-101	78-8076-5030-0	Roller – Knurled, 114 mm
4184-102	78-8076-5031-8	Shaft – Roller
4184-103	78-8076-5032-6	Roller – Knurled, 110,5 mm
4184-104	78-8114-4717-2	Bracket Assembly
4184-105	78-8076-5033-4	Bracket
4184-106	78-8114-4718-0	Shaft
4184-107	78-8114-4719-8	Roller
4184-108	26-1000-1613-3	Ring – Retaining 10DIN6799
4184-109	78-8098-9076-3	Caster Assembly
4184-110	26-1009-9096-4	Caster – Dual Locking
4184-111	26-1009-9094-9	Washer – Spring, Helical, M12
4184-112	26-1009-9095-6	Nut – M12
4184-115	78-8076-4536-7	Cap – /45X1.5

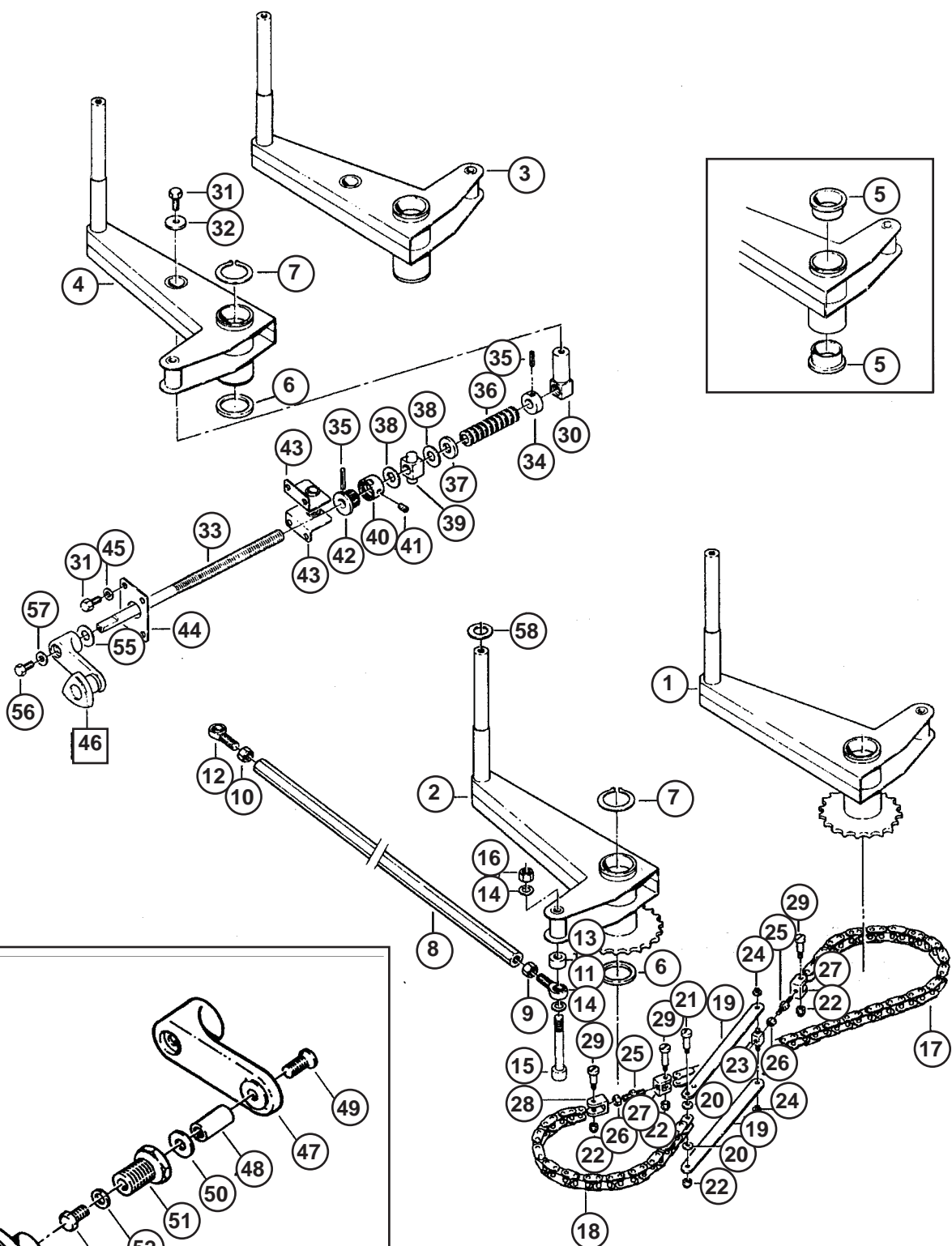


Figure 4185

Figure 4185

Ref. No.	3M Part No.	Description
4185-1	78-8091-0741-6	Arm Assembly – Front, R/H
4185-2	78-8091-0742-4	Arm Assembly – Front, L/H
4185-3	78-8091-0743-2	Arm Assembly – Rear, R/H
4185-4	78-8091-0744-0	Arm Assembly – Rear, L/H
4185-5	78-8076-4791-8	Bushing
4185-6	78-8060-7534-3	Washer
4185-7	78-8060-7521-0	Lock Ring
4185-8	78-8076-4792-6	Bar – Coupling
4185-9	78-8060-7525-1	Nut – Right Flat, M10
4185-10	78-8060-7546-7	Nut – Left Flat, M10
4185-11	78-8076-4793-4	Ball Joint – KA 10 D
4185-12	78-8076-4794-2	Ball Joint – KAL 10 D
4185-13	78-8076-4795-9	Spacer
4185-14	78-8052-6566-3	Washer – Friction
4185-15	78-8076-4796-7	Screw – Soc Hd Hex Hd, M10 x 80
4185-16	26-1003-6918-5	Nut – Plastic Insert, M10 Hex Flange
4185-17	78-8076-4797-5	Chain – Metric #35, 59 Links
4185-18	78-8076-4798-3	Chain – Metric #35, 47 Links
4185-19	78-8054-8787-9	Chain Link
4185-20	78-8054-8783-8	Washer – Special
4185-21	78-8060-7519-4	Screw – M3 x 25
4185-22	78-8059-5517-2	Nut – Self-Locking, M3
4185-23	78-8054-8784-6	Block – Chain
4185-24	78-8056-3945-3	E-Ring – M4
4185-25	78-8054-8785-3	Rod – Threaded Right/ Left
4185-26	78-8010-7418-4	Nut – Hex, M6
4185-27	78-8054-8786-1	Chain Connector
4185-28	78-8054-8788-7	Chain Connector
4185-29	78-8060-7520-2	Screw – M3 x 20
4185-30	78-8076-4799-1	Nut – Arm
4185-31	78-8060-7886-7	Screw – Special Hex Hd, M6 x 16
4185-32	78-8076-4754-6	Washer – Special, Gate
4185-33	78-8076-4801-5	Screw – Centering
4185-34	78-8060-7981-6	Bushing – Dowel
4185-35	78-8054-8586-5	Pin
4185-36	78-8060-7984-0	Washer – Belleville
4185-37	78-8060-7983-2	Washer
4185-38	78-8060-8036-8	Washer – Nylon
4185-39	78-8060-8436-0	Plastic Nut
4185-40	78-8076-4802-3	Ring Nut
4185-41	78-8076-4803-1	Set Screw – M5 x 8
4185-42	78-8076-4804-9	Bushing – Threaded
4185-43	78-8076-4805-6	Plate – W/Bushing
4185-44	78-8076-4806-4	Plate
4185-45	26-1000-0010-3	Washer – Flat, M6
4185-46	78-8076-4807-2	Crank Assembly
4185-47	78-8076-5422-9	Crank
4185-48	78-8070-1509-0	Shaft – Crank
4185-49	26-1005-5316-8	Screw – Flat Hd Hex Dr, M5 x 16
4185-50	78-8070-1510-8	Washer – Nylon, /7 x 15 x 1
4185-51	78-8070-1511-6	Bushing
4185-52	78-8005-5740-3	Washer – Plain 4 mm
4185-53	78-8010-7157-8	Screw – Hex Hd, M4 x 10
4185-54	78-8070-1512-4	Knob – VTR-B-M12
4185-55	78-8070-1548-8	Washer – Nylon 20 x 12, 5 x 1
4185-56	78-8032-0375-7	Screw – Hex Hd, M6 x 16
4185-57	78-8076-4809-8	Washer – Crank
4185-58	78-8060-7541-8	Washer

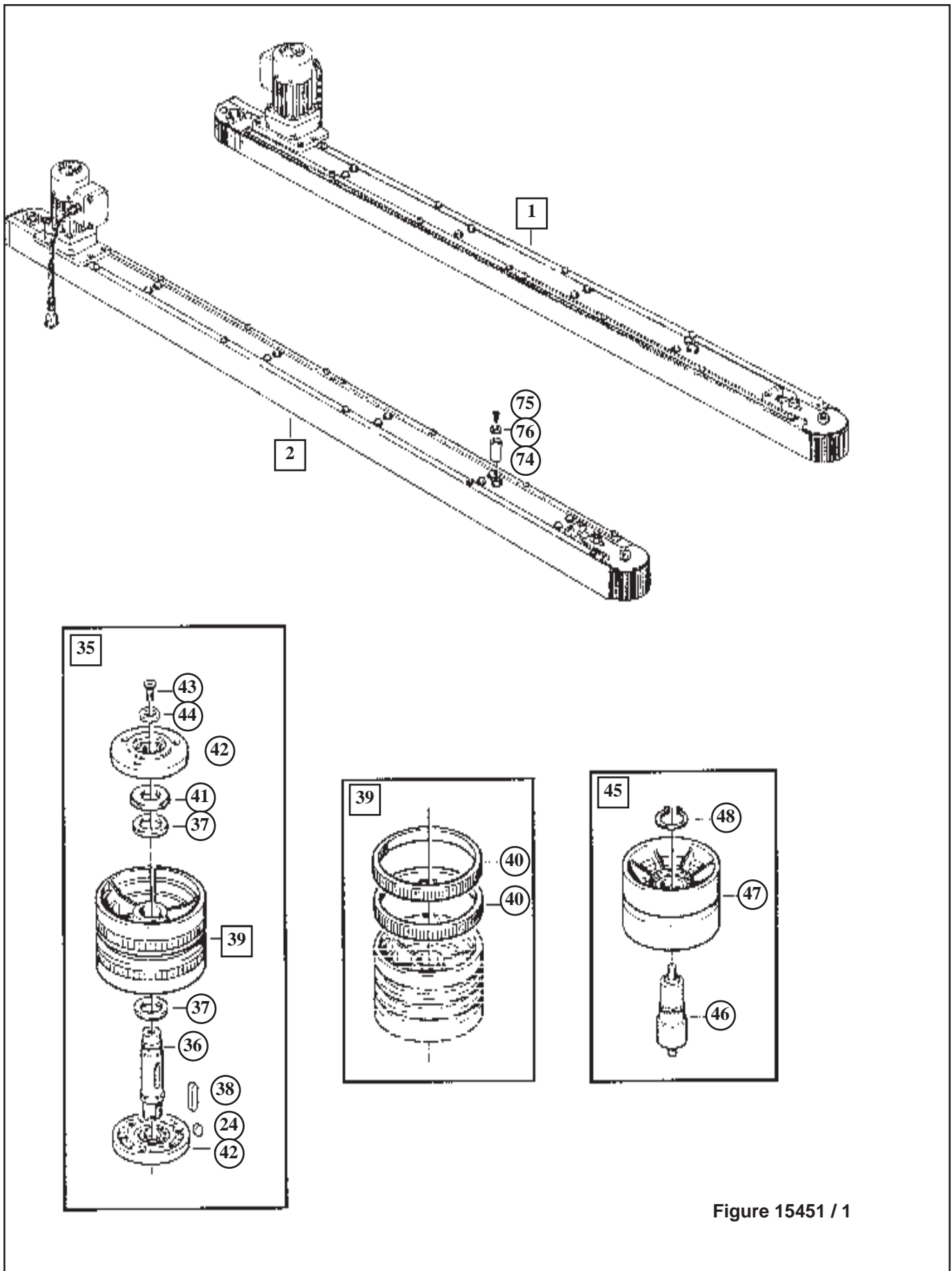


Figure 15451 / 1

Figure 15451 / 1

Ref. No.	3M Part No.	Description
15451-1	78-8091-0745-7	Side Drive Assembly – R/H, W/O Motor
	78-8098-8956-7	Side Drive Assembly – R/H, With Motor
15451-2	78-8091-0746-5	Side Drive Assembly – L/H, W/O Motor
	78-8098-8957-5	Side Drive Assembly – L/H, With Motor
15451-3	78-8091-0747-3	Guide – Lower, R/H
15451-4	78-8091-0748-1	Guide – Lower, L/H
15451-5	78-8091-0749-9	Guide – Upper, R/H
15451-6	78-8091-0750-7	Guide – Upper, L/H
15451-7	78-8091-0500-6	Bushing – Side Drive
15451-8	78-8060-7995-6	Pin – Roller
15451-9	78-8060-7996-4	Roller
15451-10	78-8091-0751-5	Plate – Roller Stop, Right
15451-11	78-8091-0752-3	Plate – Roller Stop, Left
15451-12	78-8091-0753-1	Plate – Roller Stop, Right, R/H Drive
15451-13	78-8091-0754-9	Plate – Roller Stop, Left, R/H Drive
15451-14	78-8091-0755-6	Plate – Roller Stop, Right, L/H Drive
15451-15	78-8091-0756-4	Plate – Roller Stop, Left, L/H Drive
15451-16	78-8076-5255-3	Screw – Phillips Hd, M4 x 12
15451-17	78-8005-5740-3	Washer – Plain, 4 mm
15451-18	78-8076-4855-1	Washer – Special
15451-19	78-8054-8910-7	Spacer – Hexagonal
15451-20	26-1003-5829-5	Screw – Hex Hd, M6 x 12
15451-21	26-1000-0010-3	Washer – Flat, M6
15451-22	78-8076-5439-3	Flange Assembly
15451-23	78-8091-0757-2	Extension – Gearmotor
15451-24	78-8046-8135-7	Key – 5 x 5, 12 mm
15451-25	78-8137-0934-8	Sprocket 3/8" Z17
15451-26	78-8057-5834-5	Tab Washer
15451-27	78-8057-5835-2	Centering Washer
15451-28	78-8137-0935-5	Sprocket 3/8" Z20
15451-29	78-8076-4933-6	Chain 3/8" Pitch L-52
15451-30	78-8094-6109-4	Support – Gearmotor
15451-31	78-8010-7210-5	Screw – Soc Hd Hex Soc, M6 x 20
15451-32	78-8070-1522-3	Gearmotor – 115V, 60HZ, Bodine 42R5BFC1-E2
15451-33	78-8070-1523-1	Screw – 1/4-28 x 1/2 SHCS
15451-34	26-1011-8828-7	Capacitor – 115V Gearmotor
15451-35	78-8076-4862-7	Pulley – Drive
15451-36	78-8054-8878-6	Shaft – Pulley Keyed
15451-37	78-8054-8879-4	Washer – /20, mm
15451-38	78-8057-5739-6	Key – M5 x 5 x 30mm

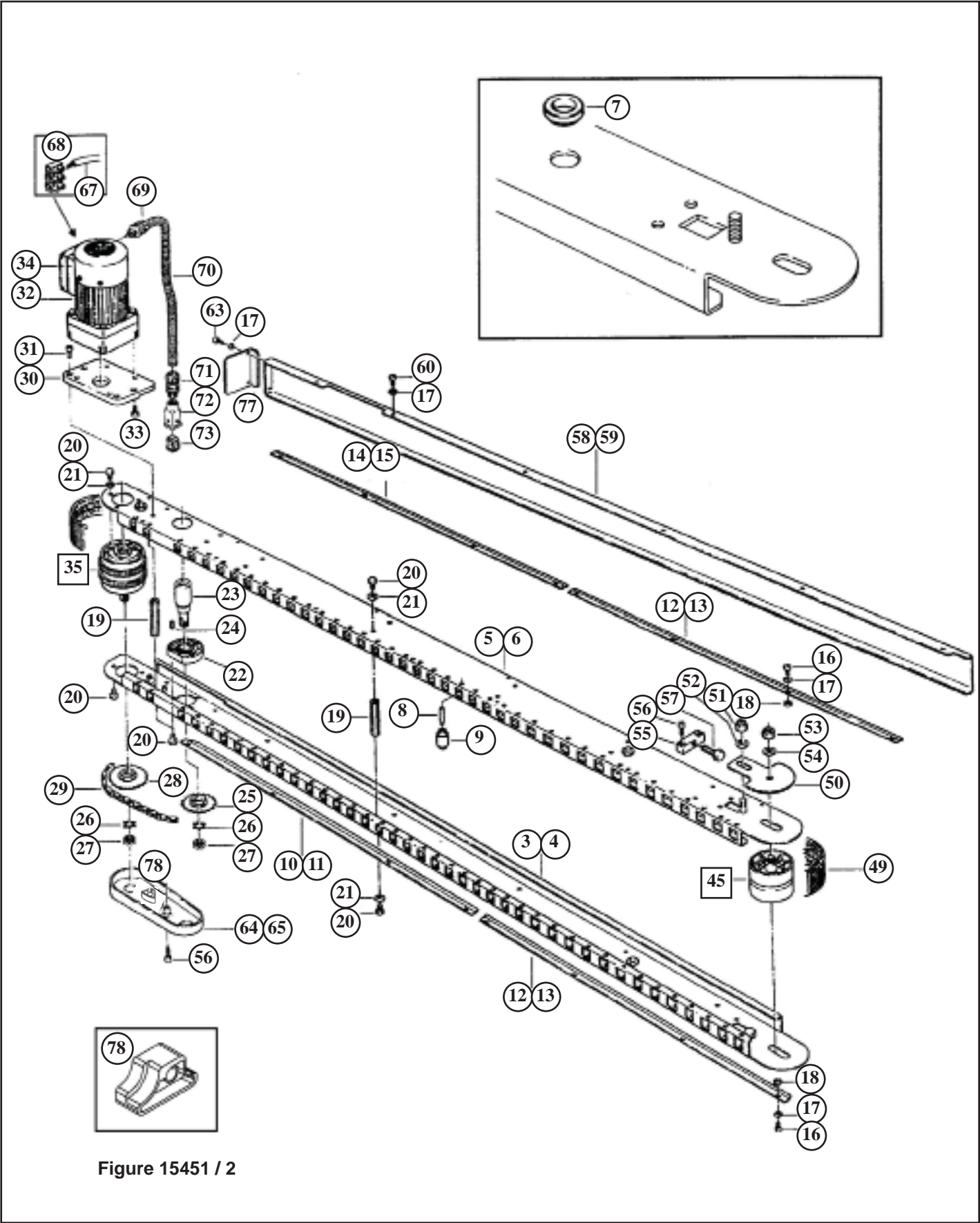


Figure 15451 / 2

Ref. No.	3M Part No.	Description
15451-39	78-8076-5105-0	Pulley Assembly – Drive
15451-40	78-8052-6713-1	Ring – Polyurethane
15451-41	78-8017-9096-1	Nut – Special, M18 x 1
15451-42	78-8076-5442-7	Flange Assembly
15451-43	26-0001-5862-1	Screw – Flat Hd Soc, M5 x 12
15451-44	78-8054-8877-8	Washer – 5.5/20 x 4
15451-45	78-8060-8014-5	Idler Roller Assembly
15451-46	78-8054-8913-1	Shaft – Roller
15451-47	78-8052-6710-7	Roller – Idler
15451-48	12-7997-0272-0	E-Ring – M-25
15451-49	78-8076-4865-0	Belt – Box Drive
15451-50	78-8091-0761-4	Plate – Belt Tensioning
15451-51	26-1003-6918-5	Nut – Plastic Insert, M10 Hex Flange
15451-52	78-8052-6566-3	Washer – Friction
15451-53	26-1000-1347-8	Nut – Hex, M8
15451-54	78-8017-9318-9	Washer – Plain, 8 mm
15451-55	78-8054-8903-2	Block – Belt
15451-56	78-8010-7210-5	Screw – Soc Hd Hex Soc, M6 x 20
15451-57	78-8054-8904-0	Screw – Belt Adjustment
15451-58	78-8091-0762-2	Cover – Drive, Right
15451-59	78-8091-0763-0	Cover – Drive, Left
15451-60	26-1002-5753-9	Screw – Self-Tapping
15451-63	26-1002-4955-1	Screw – Self-Tap, 8P x 13
15451-64	78-8091-0764-8	Cover – Chain, Right
15451-65	78-8091-0765-5	Cover – Chain, Left
15451-66	78-8010-7165-1	Screw – Flat Hd Soc, M5 x 25
15451-67	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
15451-68	78-8076-4968-2	Terminal
15451-69	78-8060-7631-7	Connector – 3/8 Inch
15451-70	78-8076-4871-8	Sleeving – /12, 600 mm
15451-71	78-8060-7626-7	Connector – PG 11/12
15451-72	78-8060-7877-6	Plug – Housing Vertical
15451-73	78-8060-7875-0	Plug – Male
15451-74	78-8091-0766-3	Spacer – Drive
15451-75	26-1001-9843-6	Screw – Flat Soc Hd, M6 x 16
15451-76	78-8054-8577-4	Washer – Special
15451-77	78-8114-4787-5	Guard – Belt
15451-78	78-8137-0932-2	Tensioner - Pulley R/H
	78-8137-0933-0	Tensioner - Pulley L/H

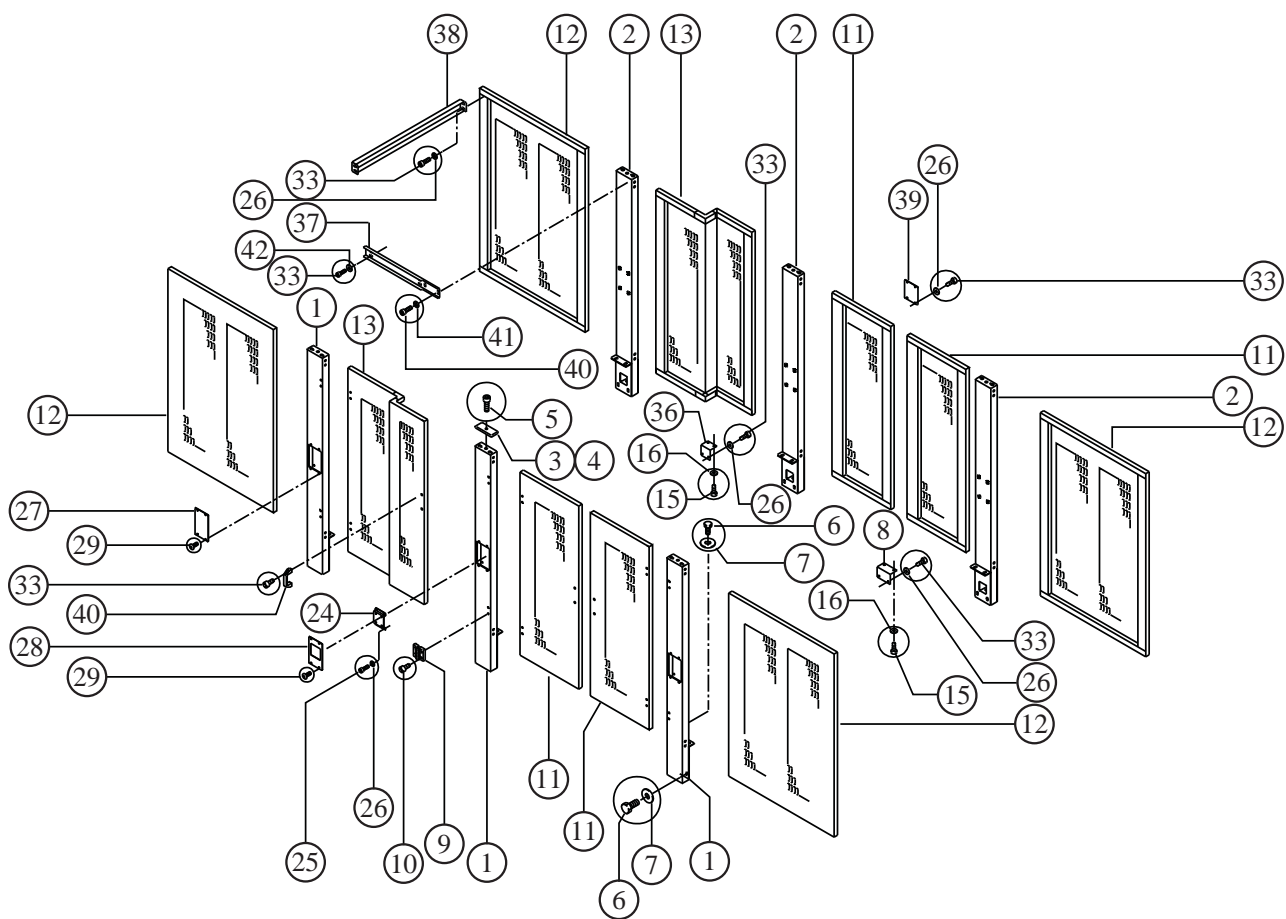


Figure 15449 / 1

Figure 15449 / 1

Ref. No.	3M Part No.	Description
15449-1	78-8137-0806-8	Jamb - Left
15449-2	78-8137-0807-6	Jamb - Right.
15449-3	78-8076-4512-8	Cap - Left
15449-4	78-8076-4511-0	Cap - Right
15449-5	78-8129-6293-0	Screw - Soc. Hd, M6 x 20
15449-6	26-1003-5842-8	Screw - Hex. Hd, M8 x 20
15449-7	78-8017-9318-9	Washer - Flat, M8
15449-8	78-8137-0808-4	Hinge
15449-9	78-8129-6293-0	Cern -Elesa - CFA.65 CH-6 COD.422232 SM1
15449-10	26-1003-7957-2	Hinge
15449-11	78-8137-0809-2	Panel - Front Door
15449-12	78-8137-0810-0	Panel - Fix
15449-13	78-8137-0811-8	Panel - Rear Door
15449-14	78-8076-4992-2	Bracket Switch
15449-15	26-1003-7949-9	Screw - Hex. Hd, M5 x 12
15449-16	78-8005-5741-1	Washer - Flat. M5
15449-17	26-0001-5862-1	Screw - Soc M5 x 12 Zinc
15449-18	26-1005-6859-6	Nut - Self Locking, M5
15449-19	78-8137-0812-6	Screw - Flat Hd, M5 x 30
15449-20	78-8054-8972-7	Spacer
15449-21	78-8076-4929-4	Security Switch
15449-22	26-1003-7951-5	Screw - Soc. hd, M5 x 20
15449-23	26-1005-5316-8	Screw -Flat Hd, M5 x 16
15449-25	78-8010-7210-5	Screw - Soc. Hd, M6 x 20
15449-26	26-1000-0010-3	Washer - Flat. M6
15449-27	78-8137-0814-2	Cover

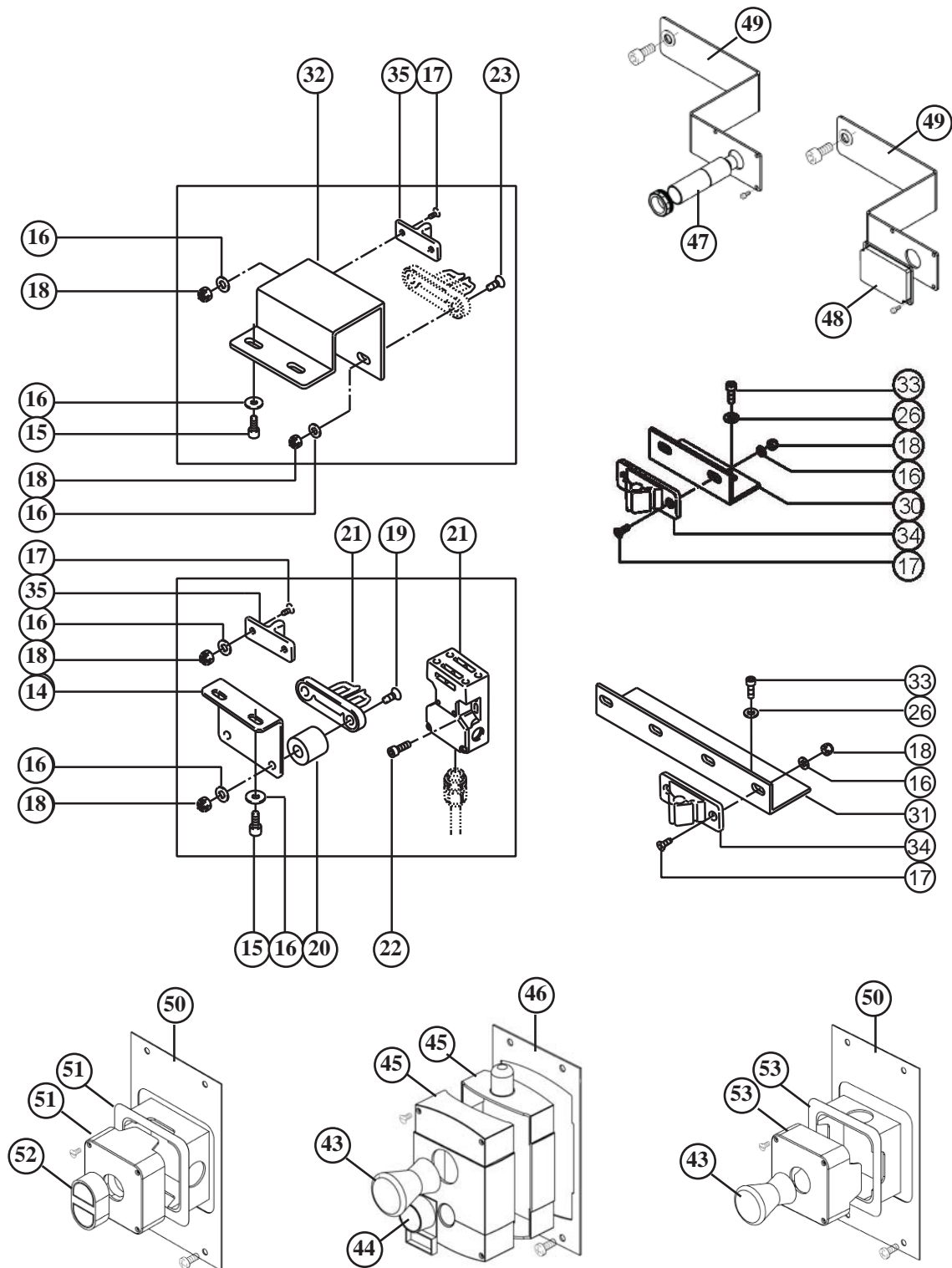


Figure 15449 / 2

Figure 15449 / 2

Ref. No.	3M Part No.	Description
15449-30	78-8137-0816-5	Bracket - Rear
15449-31	78-8137-0817-3	Bracket
15449-32	78-8137-0818-3	Bracket - Switch
15449-33	26-1003-7957-2	Screw - Soc. Hd, M6 x 16
15449-34	78-8076-4932-8	Stop - Door
15449-35	78-8076-4931-0	Stop - Door
15449-36	78-8137-0819-1	Stop - Door
15449-37	78-8137-0820-9	Cross - Bar
15449-38	78-8137-0821-7	Cross - Bar
15449-39	78-8137-0822-5	Bracket
15449-40	26-1003-7963-0	Screw - Hex. Hd, M8 x 16
15449-41	78-8017-9318-9	Washer - Flat. M8
15449-42	78-8042-2919-9	Washer - Triple M8
15449-43	78-8137-0609-6	Emergency Stop Button
15449-44	78-8137-6069-7	White Button
15449-45	78-8137-6070-5	Box Cover - Two Holes
15449-46	78-8137-6071-3	Cover - Double Button
	78-8137-0797-9	Latch + Contact
15449-47	78-8114-4824-6	Sensor
15449-48	78-8076-5057-3	Reflector
15449-49	78-8137-6074-7	Energy Saving Electric Eye Bracket
15449-50	78-8137-0815-9	Cover
15449-51	78-8114-4896-4	Grey Plastic Cover Start/Stop
15449-52	78-8137-0823-3	Red/Green Multifunction Button
	78-8137-0824-1	Latch+ Contact ON/OFF Switch
15449-53	78-8076-5194-4	Yellow Plastic Cover E-stop

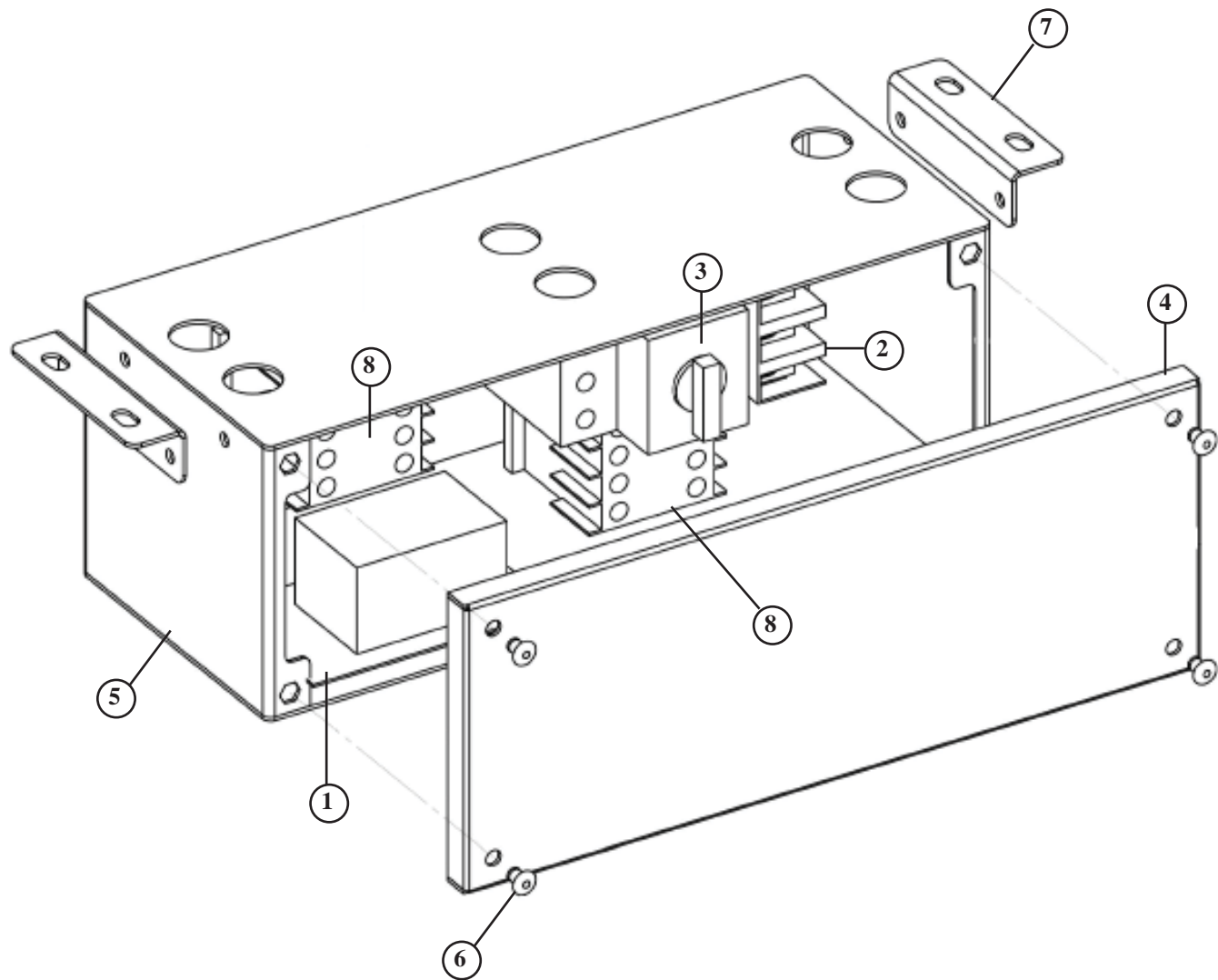


Figure 15450

Figure 15450

Ref. No.	3M Part No.	Description
15450-1	78-8137-6073-9	Saving Card
15450-2	78-8137-0782-1	Phases Spacer
15450-3	78-8076-5378-3	Thermo Switch
15450-4	78-8137-6077-0	Electrical Cover Box
15450-5	78-8137-6078-8	Electrical Box
15450-6	78-8137-6079-6	Iron Rivet
15450-7	78-8137-6080-4	Electrical Box Fixing Bracket
15450-8	78-8137-6081-2	Contactor

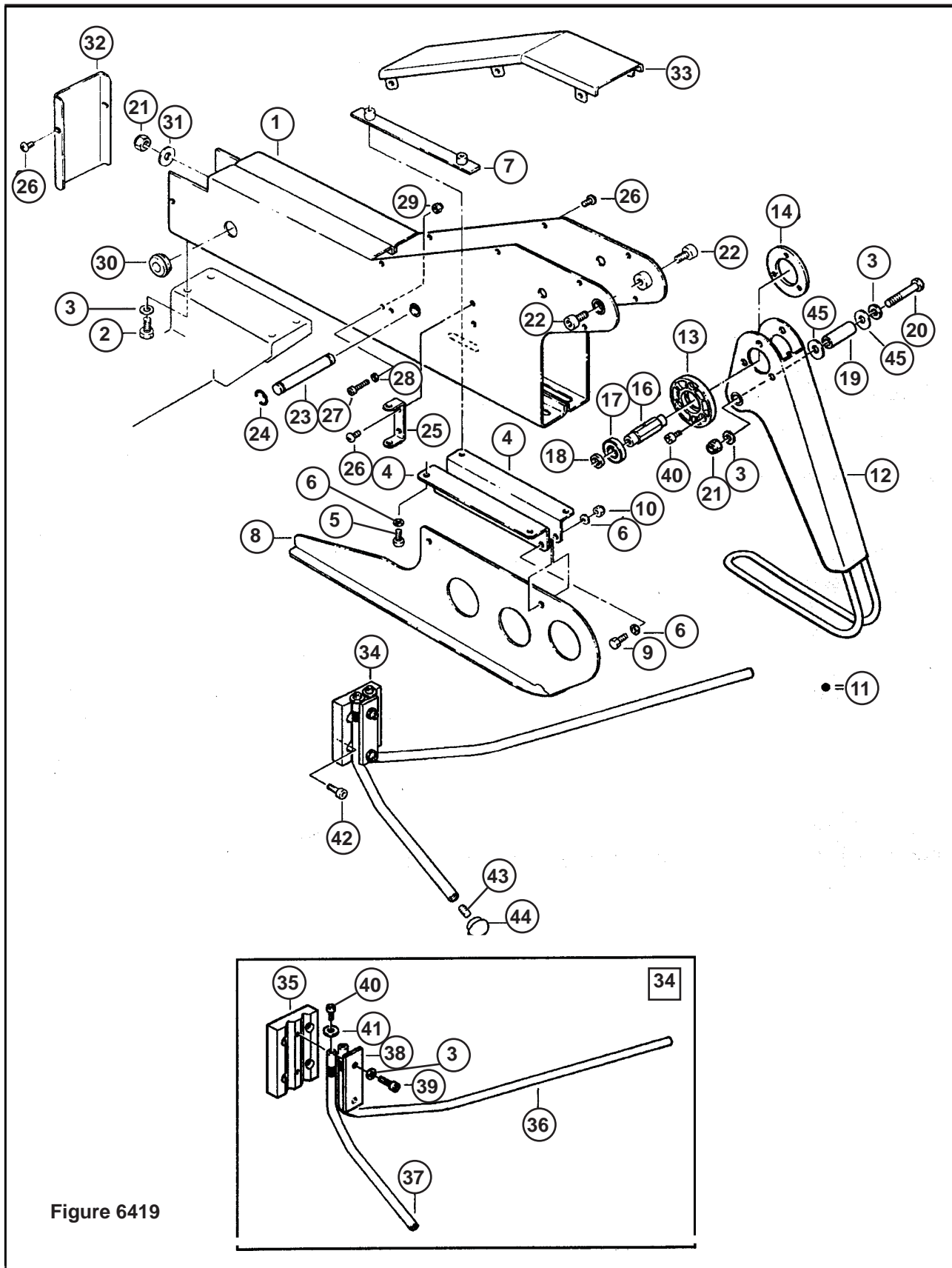


Figure 6419

Figure 6419

Ref. No.	3M Part No.	Description
6419-1	78-8091-0739-0	Support – Front Flap Folder
6419-2	78-8017-9301-5	Screw – Hex Hd, M8 x 25
6419-3	78-8017-9318-9	Washer – Plain, 8 mm
6419-4	78-8076-4832-0	Plate – Box Guide
6419-5	78-8010-7210-5	Screw – Soc Hd Hex Soc, M6 x 20
6419-6	26-1000-0010-3	Washer – Flat, M6
6419-7	78-8076-4833-8	Strap
6419-8	78-8114-4706-5	Flap Folder – Front
6419-9	78-8032-0375-7	Screw – Hex Hd, M6 x 16
6419-10	26-1003-6916-9	Nut – Locking, Plastic Insert, M6
6419-11	78-8114-4707-3	Flap Folder Assembly – Rear
6419-12	78-8114-4708-1	Flap Folder – Rear
6419-13	78-8114-4709-9	Support – Bearing
6419-14	78-8114-4710-7	Washer – Support
6419-16	78-8114-4711-5	Shaft – Support, Hex
6419-17	26-1000-4350-9	Bearing – 6002-2RS
6419-18	78-8114-4712-3	Spacer – Bearing
6419-19	78-8114-4695-0	Spacer – Cylinder
6419-20	26-1002-5949-3	Screw – Hex Hd, M8 x 60
6419-21	78-8017-9313-0	Nut – Self-Locking, M8
6419-22	26-1003-7964-8	Screw – Soc Hd Hex Soc Dr, M8 x 20
6419-23	78-8076-4831-2	Pin – Air Cylinder
6419-24	78-8056-3965-1	Ring – 8 DIN 6799
6419-25	78-8091-0740-8	Holder – Hex Wrench
6419-26	78-8060-8087-1	Screw – M5 x 10
6419-27	26-1003-7947-3	Screw – Soc Hd Hex Soc, M4 x 35
6419-28	78-8005-5740-3	Washer – Plain, 4 mm
6419-29	26-1003-6914-4	Nut – Plastic Insert, M4
6419-30	78-8060-7785-1	Fairlead – /22
6419-31	26-1004-5507-5	Washer – M8
6419-32	78-8076-4830-4	Cover – Flap Folder Support
6419-33	78-8076-4840-3	Cover
6419-34	78-8114-4713-1	Flap Folder Assembly – Side
6419-35	78-8114-4791-7	Block – Side Flap Folder
6419-36	78-8114-4714-9	Side Flap Folder – R/H
6419-37	78-8114-4715-6	Side Flap Folder – L/H
6419-38	78-8114-4792-5	Plate – Side Flap Folder
6419-39	78-8060-7895-8	Screw – M8 x 35
6419-40	78-8010-7209-7	Screw – Soc Hd, M6 x 12
6419-41	78-8042-2919-9	Washer – Triple, M6
6419-42	26-1003-7965-5	Screw – Soc Hd Hex Soc, M8 x 25
6419-43	78-8060-7863-6	Grain – M6 x 20
6419-44	78-8076-4546-6	Knob
6419-45	78-8017-9059-9	Washer – Flat For M12 Screw

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Instructions and Parts List

3M-MaticTM

AccuglideTM 3
Upper and
Lower
High Speed
Taping Heads
2 Inch

Type 10800

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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3M, St. Paul, MN 55144-1000
Printed in U.S.A.

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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 3 - 2 inch - Type 10800 - 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		3M-Matic™		
Model	Part Number	Year	Ampere	Watt
<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Type	Serial Number	Volt	Hertz	Phase
<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>

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
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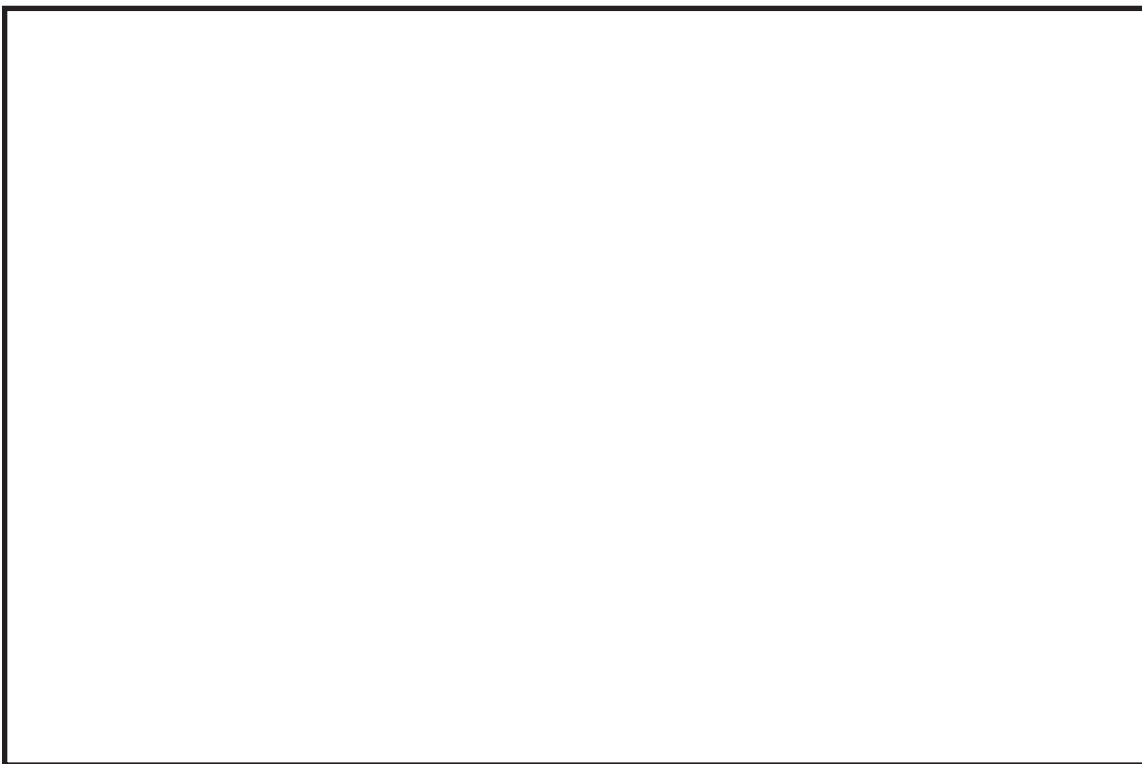
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To Our Customers:

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™ 3 High Speed 2 Inch Upper and Lower Taping Heads Type 10800

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Warranty

Equipment Warranty and Limited Remedy:

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™ 3 High Speed 2 Inch Upper and Lower Taping Heads, Type 10800** 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.

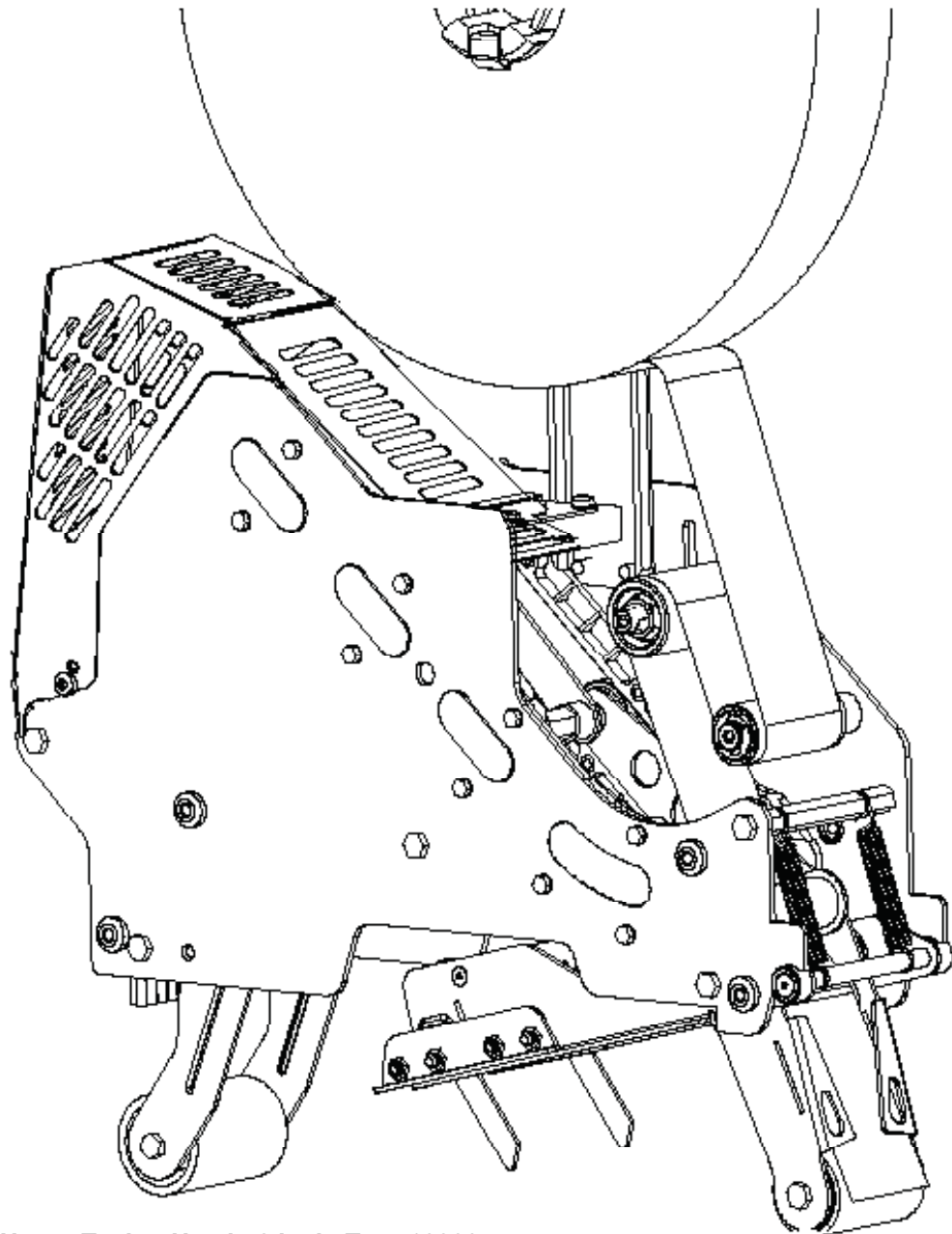
AccuGlide™, Scotch™, and 3M-Matic™ are Trademarks of 3M, St. Paul, Minnesota 55144-1000

Intended Use

The intended use of the AccuGlide™ 3 Upper and Lower Taping Heads - 2 Inch 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™ 3 Upper and Lower Taping Heads - 2 Inch have been designed and tested for use with Scotch® pressure-sensitive film box sealing tape.



AccuGlide™ 3 Upper Taping Head - 2 inch, Type 10800

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Taping Head Contents

AccuGlide™ 3 High Speed 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 3 (2 inch) 3M Industrial Adhesives and Tapes Division 3M Center, Bldg. 220-5E-06 St. Paul, MN 55144-1000 (USA) Edition February 2012/Copyright 3M 2012. 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: Model 200a - Accuglide 3 - 2" - Type 10800 - 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.

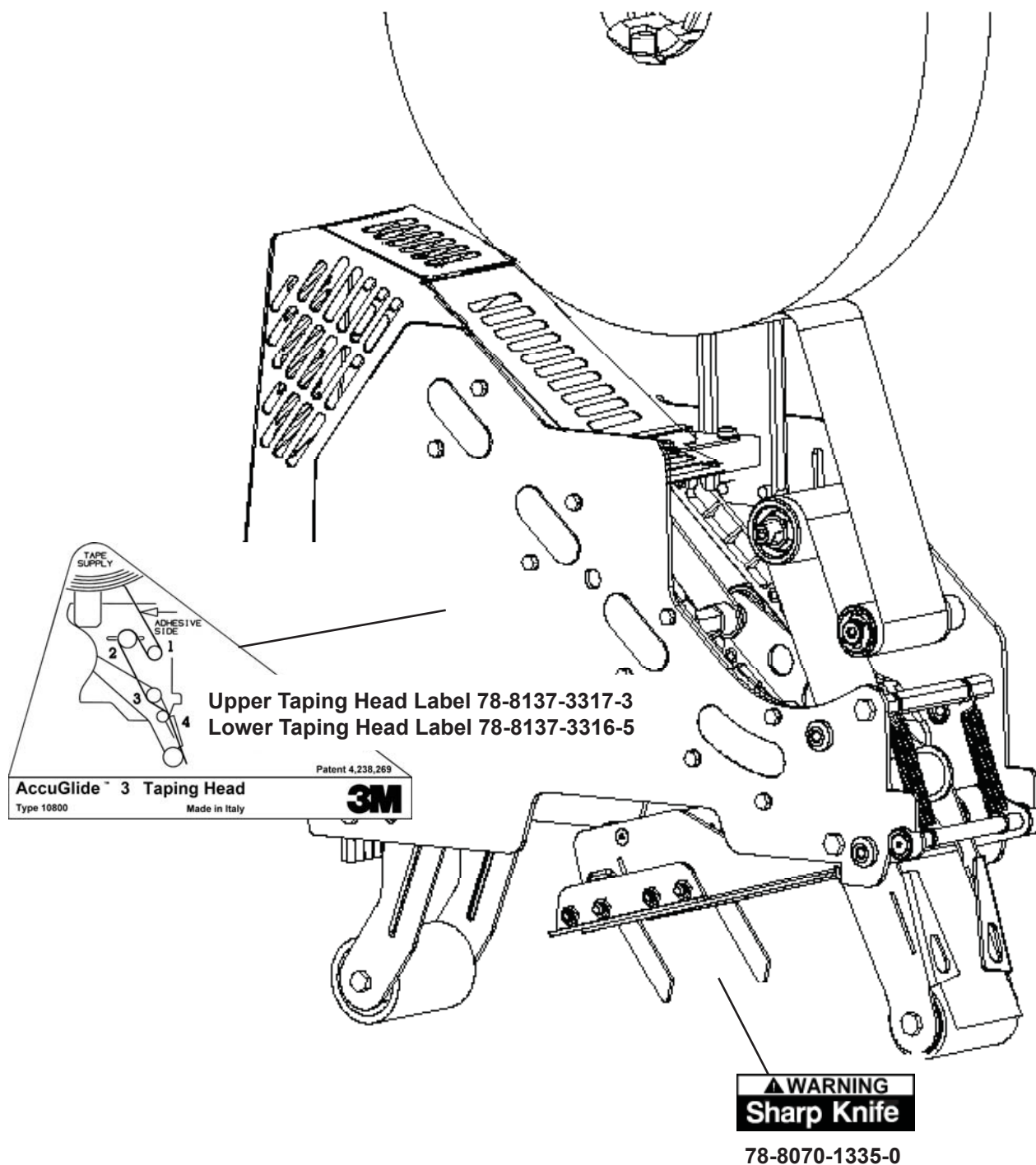


Figure 1-1 Replacement Labels/3M Part Numbers

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.

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 0.5 m/s [100 feet per minute].

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	–	442mm [17 3/8 inches]
Height	–	648mm [25 1/2 inches] (with tape drum)
Width	–	105mm [4-1/8 inches] (without mounting spacers)
Weight	–	Packaged: 8.6kg [19 lbs.] Unpackaged: 7.7kg [17 lbs.]

(Specifications continued on next page.)

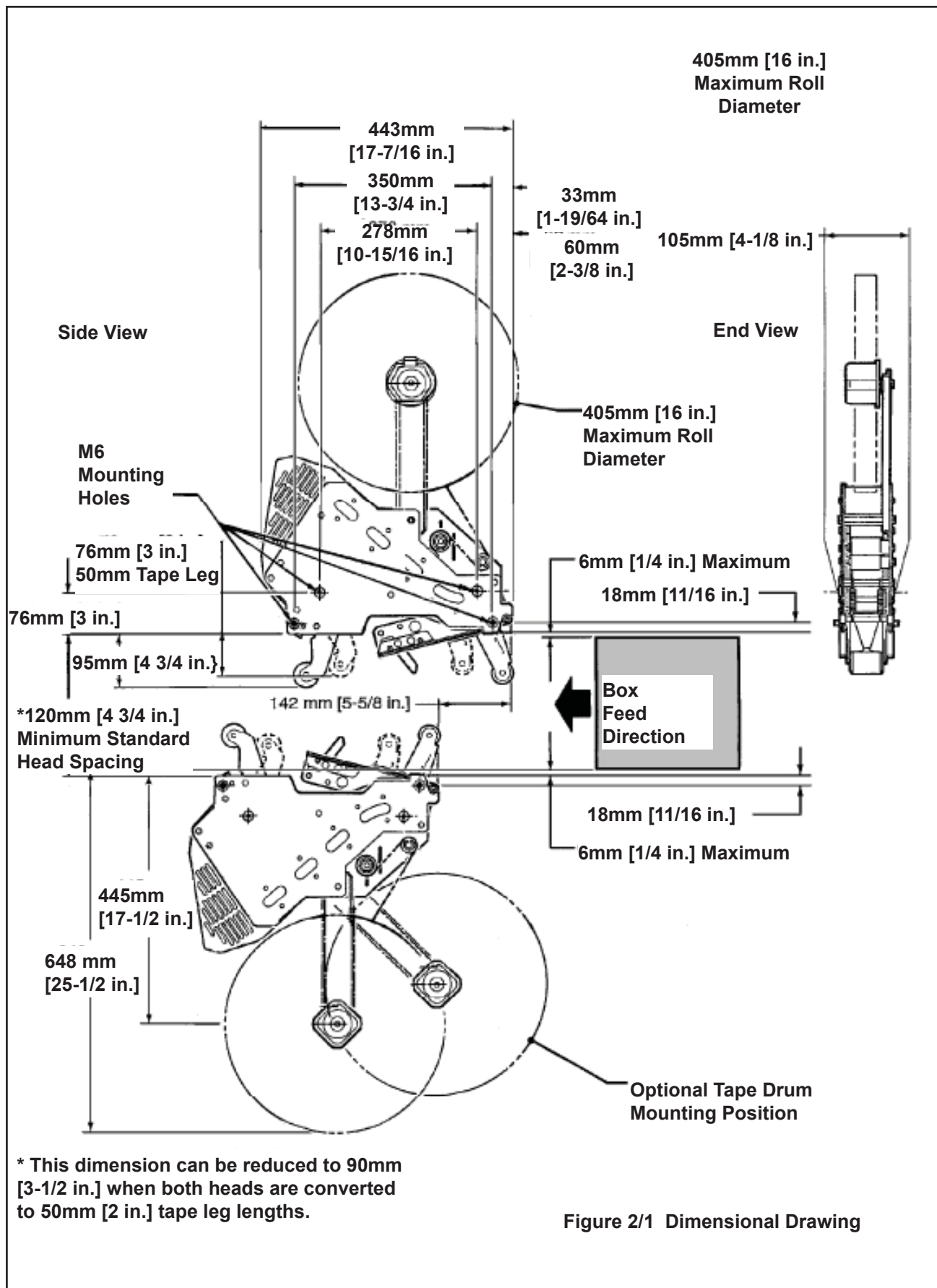


Figure 2/1 Dimensional Drawing

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™ 3 High Speed 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

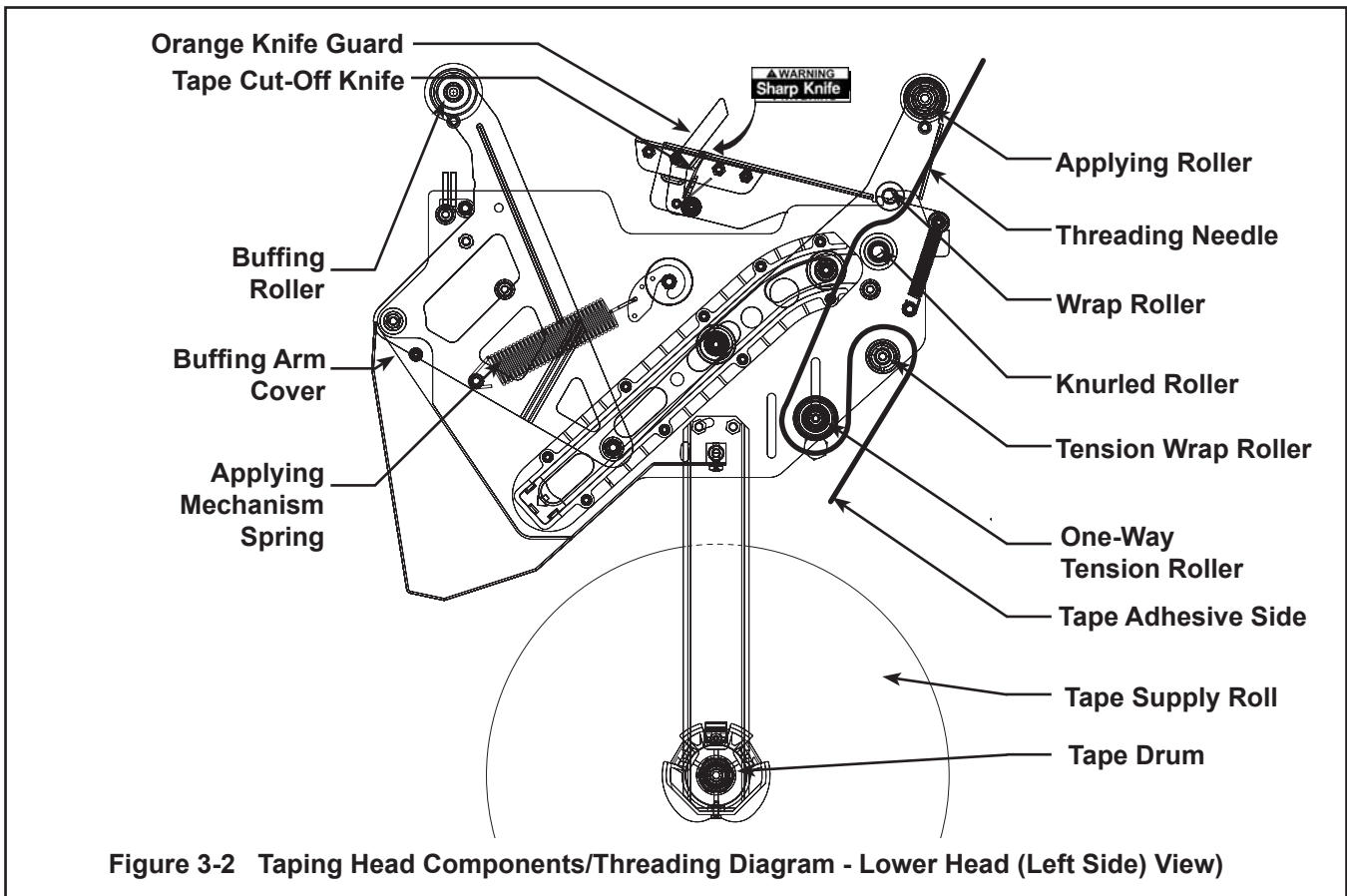
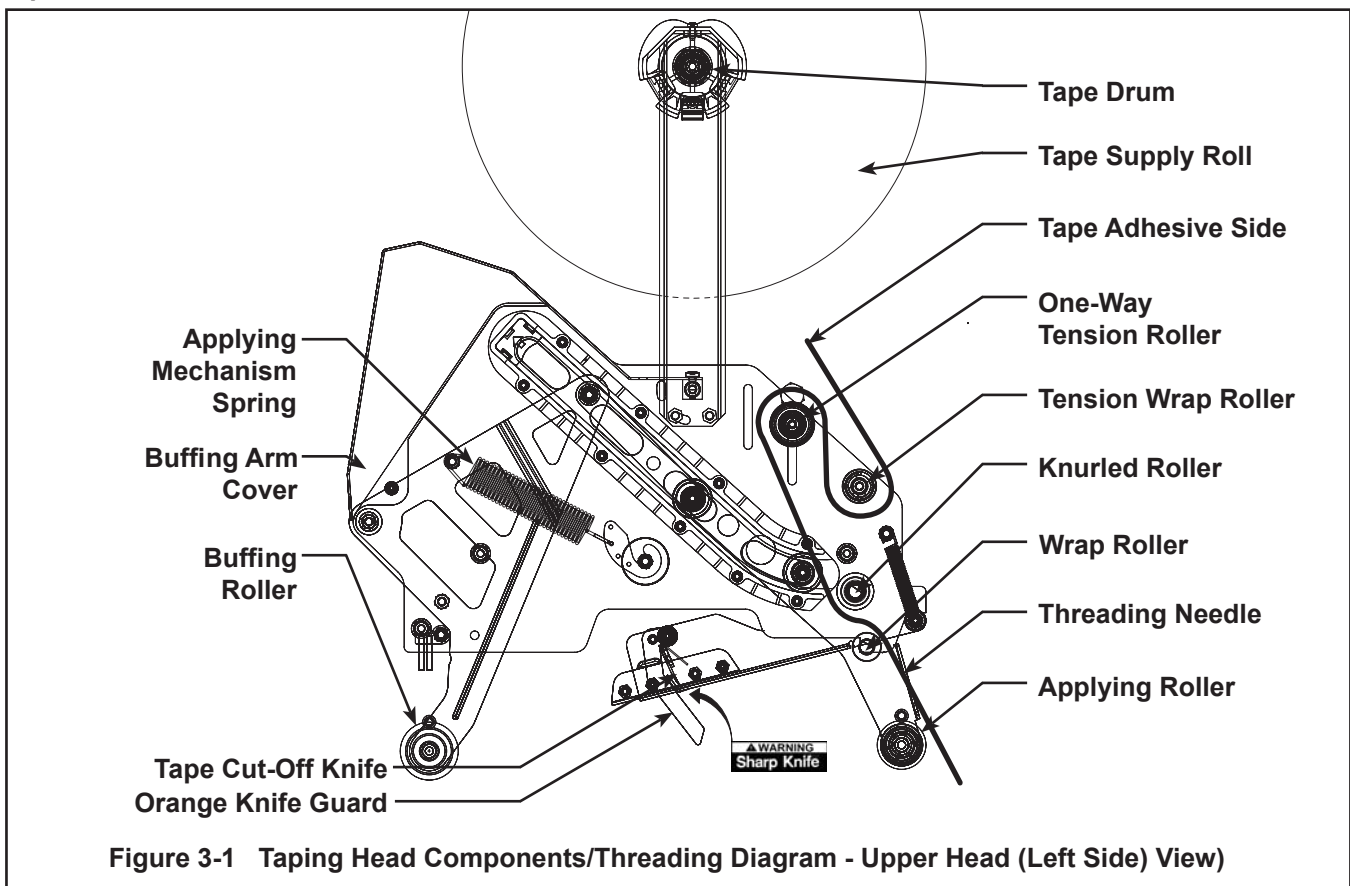
Taping heads are factory set to apply standard 70mm [2-3/4 inch] tape legs. The heads can be converted to apply 50mm [2 inch] tape legs if desired but both upper and lower heads must be set to apply the same tape leg length. See "Adjustments – Changing Tape Leg Length From 70 to 50mm [2-3/4 to 2 Inches]."

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





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.

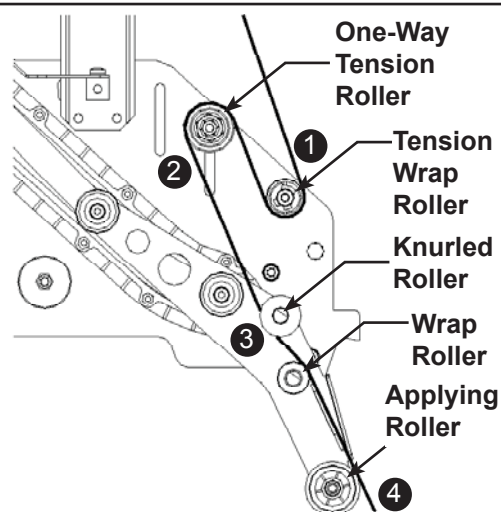


Figure 3-3 Tape Loading/Threading

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.

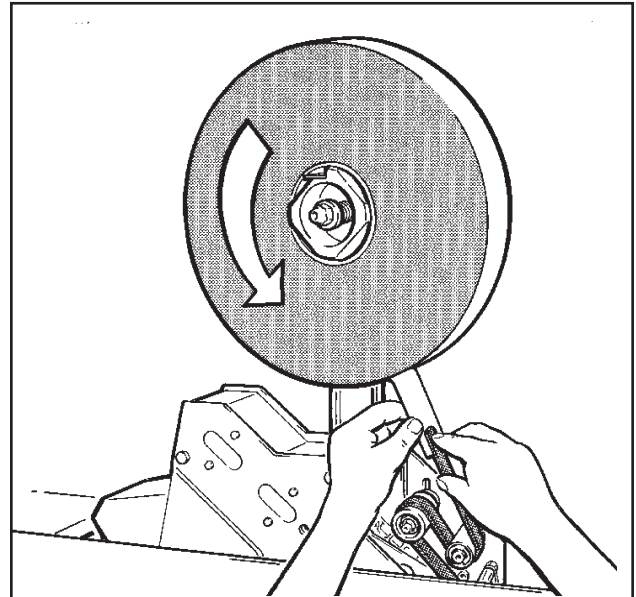


Figure 3-4 Tape Loading/Threading



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.

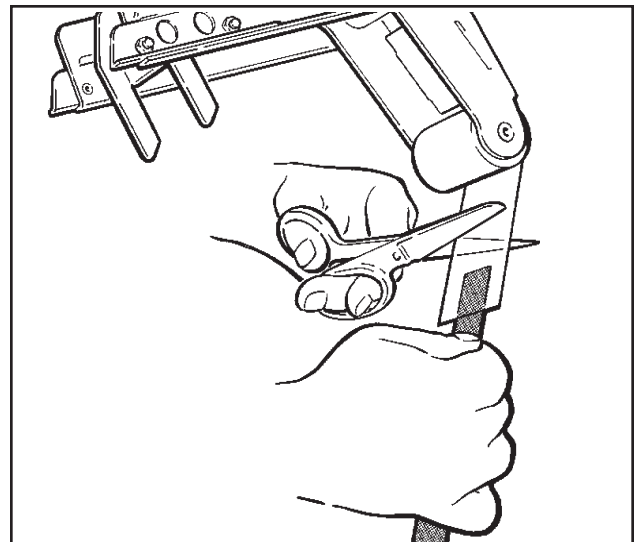


Figure 3-5 Tape Loading/Threading



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™ 3 High Speed 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.

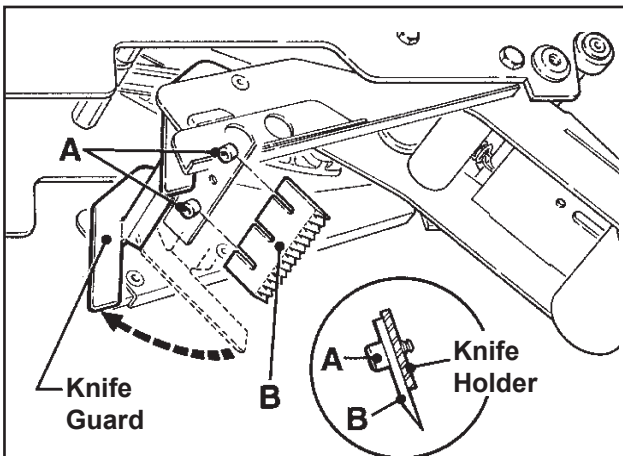


Figure 4-1 Blade Replacement

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 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 5mm 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. See **Figure 4-2**.

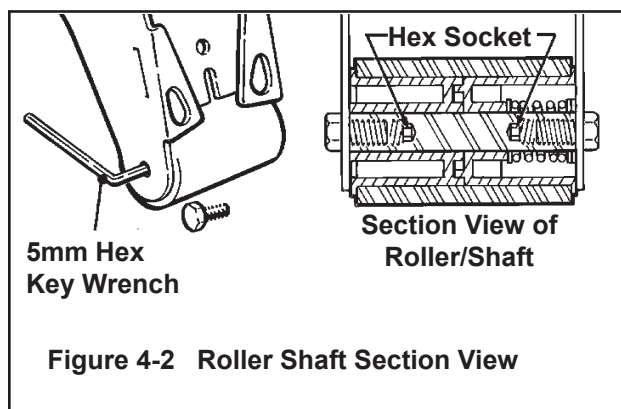


Figure 4-2 Roller Shaft Section View



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 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.

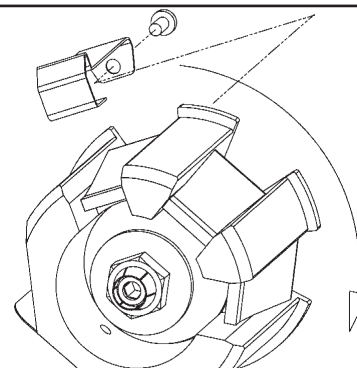


Figure 5-1 Tape Latch Alignment

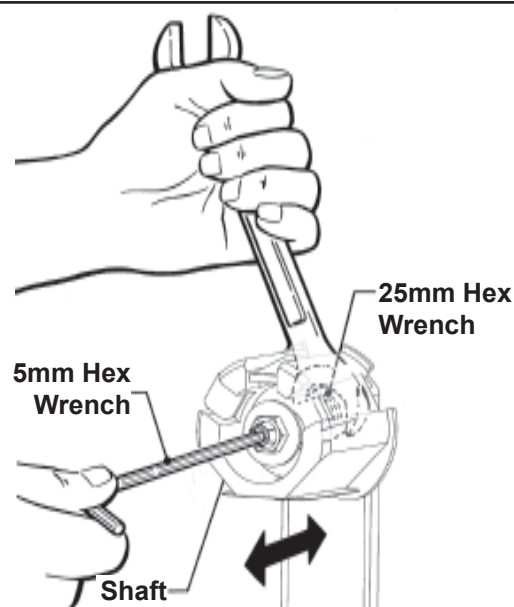


Figure 5-2 Tape Web Alignment

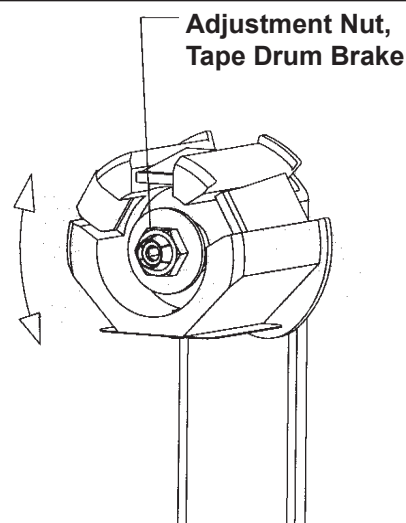


Figure 5-3 Tape Drum Friction Brake

(Adjustments continued on next page.)



WARNING

- **To reduce 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

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.

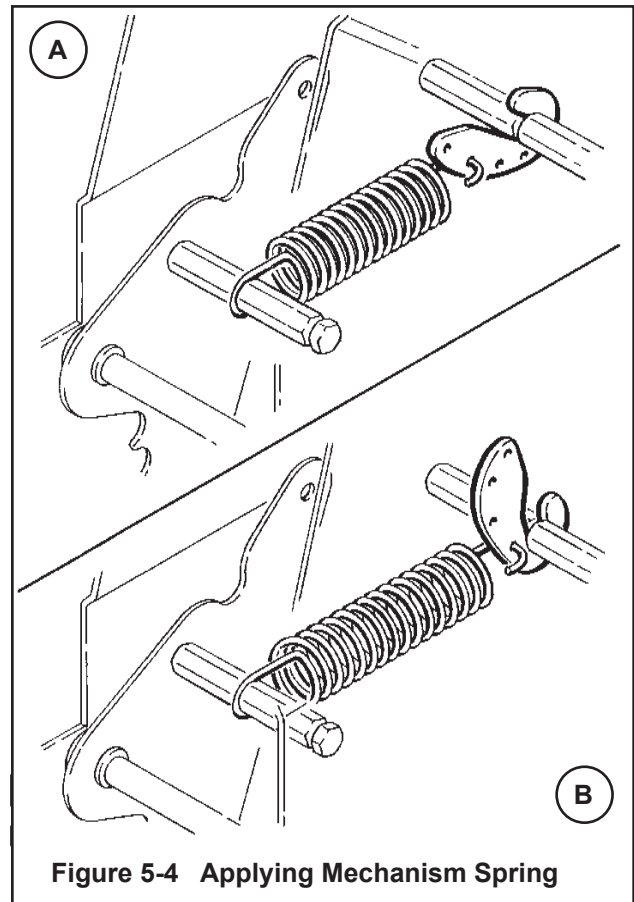


Figure 5-4 Applying Mechanism Spring

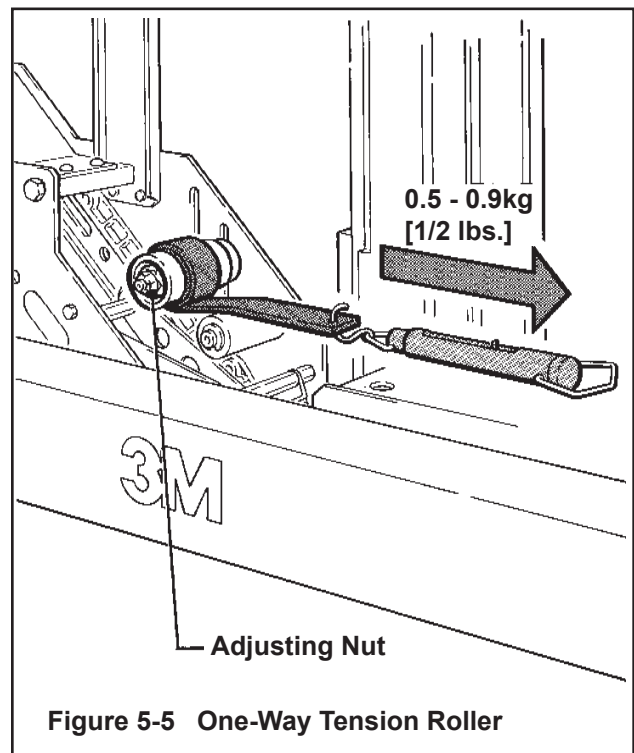


Figure 5-5 One-Way Tension Roller

(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.

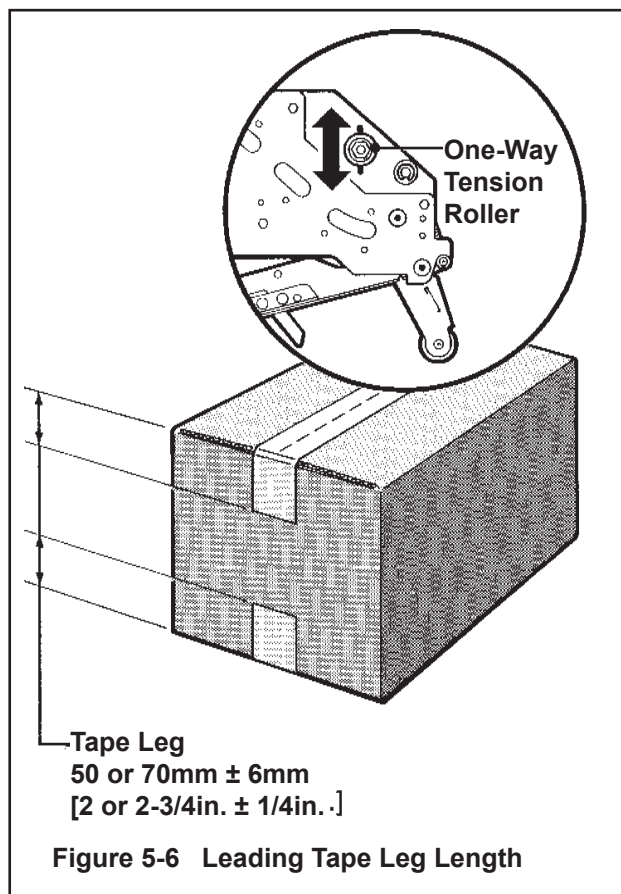


Figure 5-6 Leading Tape Leg Length

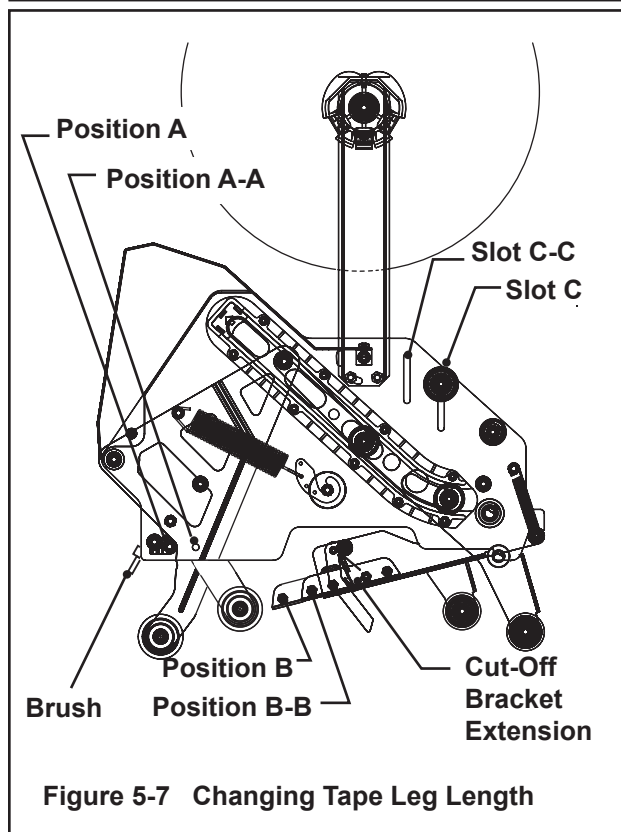


Figure 5-7 Changing Tape Leg Length

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™ 3 Upper Taping Head - 2 inch

Qty.	Part Number	Description
4	78-8076-4500-3	Stud – Mounting
1	78-8137-3311-6	Spring – Upper Extension
1	78-8017-9173-8	Blade – 65mm/2.56 Inch
2	78-8052-6602-6	Spring – Cutter
1	78-8076-4726-4	Tool – Tape Threading

AccuGlide™ 3 Lower Taping Head - 2 inch

Qty.	Part Number	Description
1	78-8017-9173-8	Blade – 65mm/2.56 Inch
2	78-8052-6602-6	Spring – Cutter
4	78-8076-4500-3	Stud – Mounting
1	78-8137-3312-4	Spring – Lower Extension
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™ 3 High Speed 2 Inch Upper Taping Head, Type 10800

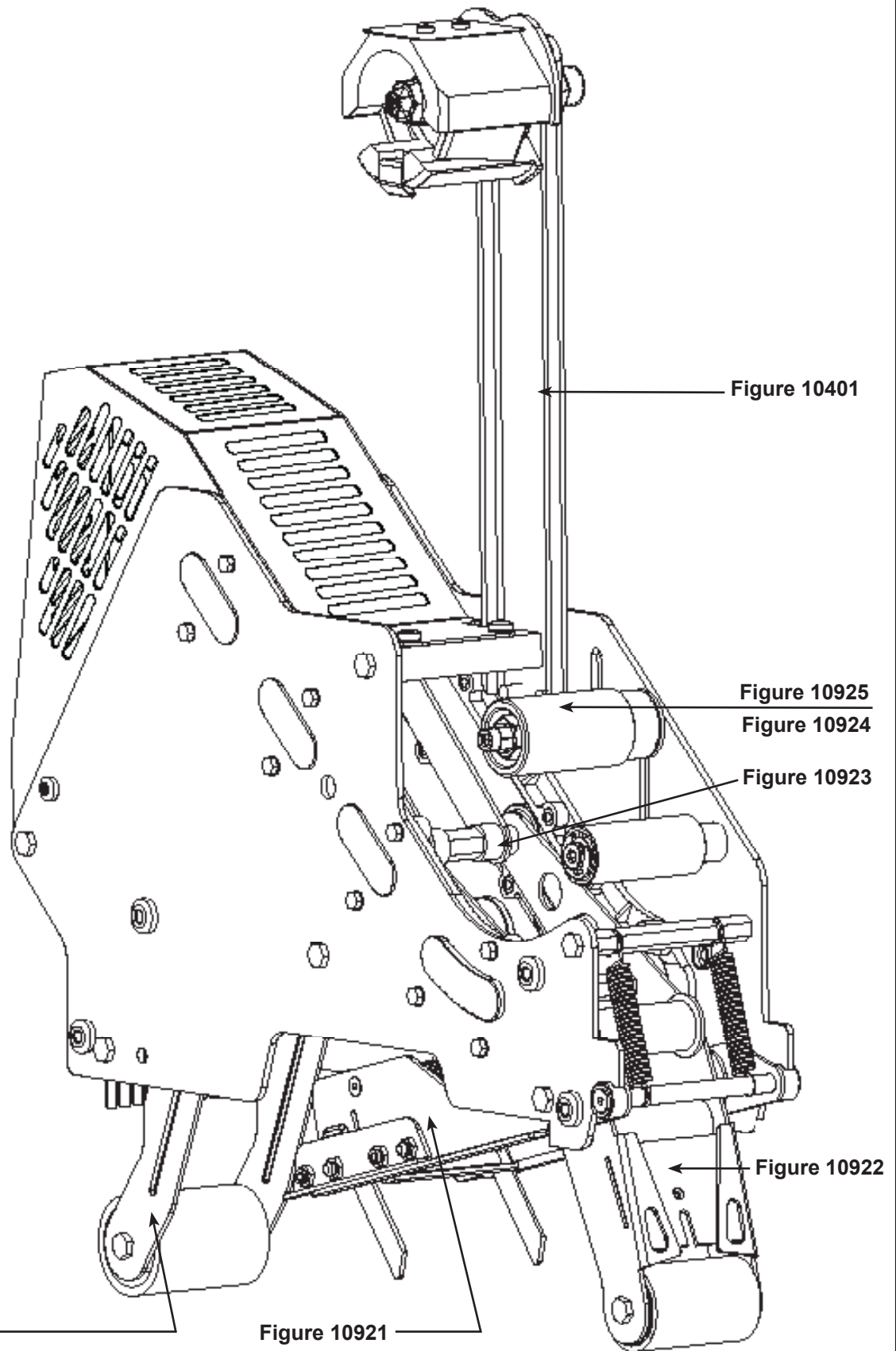
AccuGlide™ 3 High Speed 2 Inch Lower Taping Head, Type 10800

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.



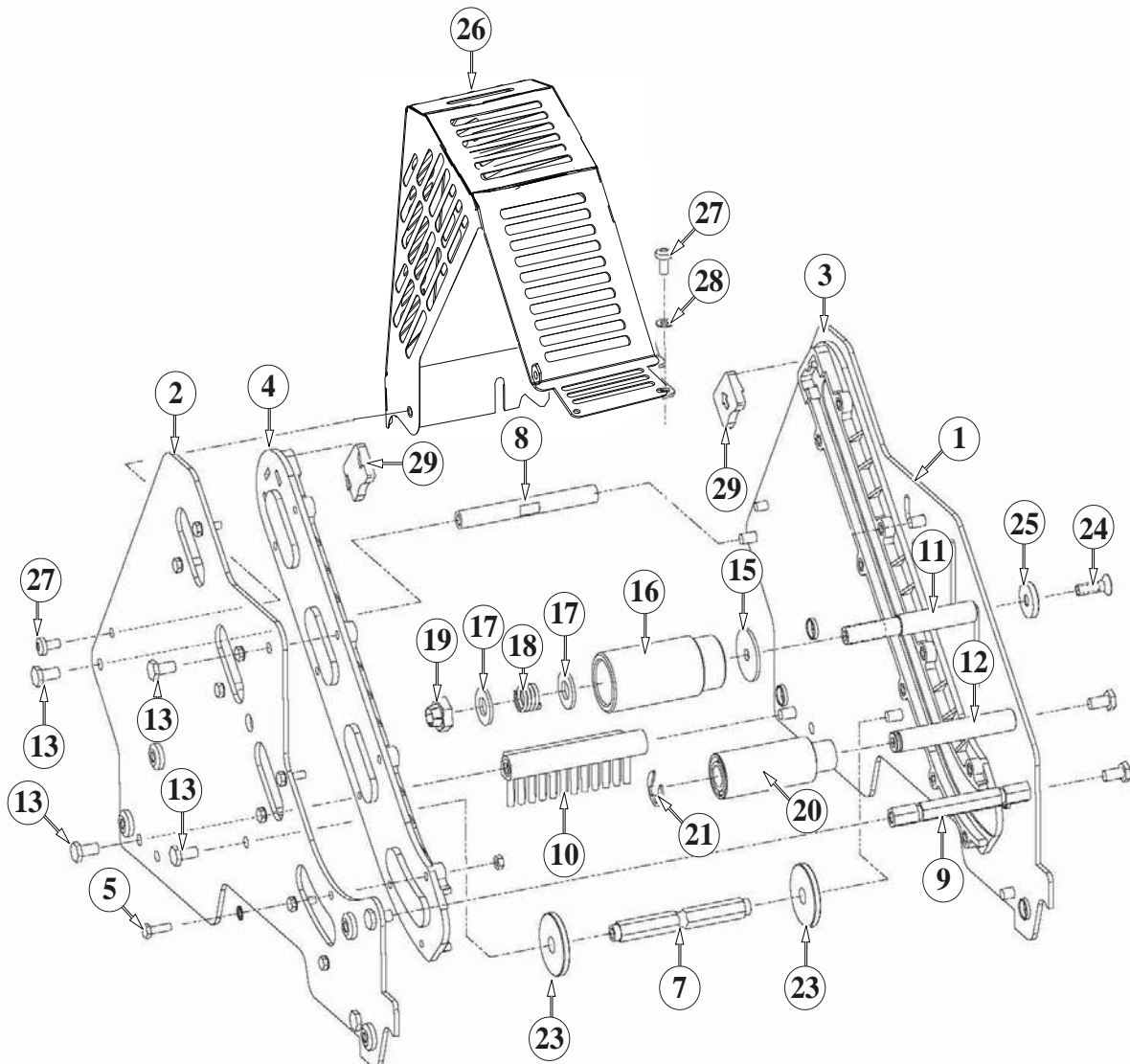


Figure 10925 – Upper Head

AccuGlide™ 3 - 2"

Figure 10925 – 2" Upper Head

Ref. No.	3M Part No.	Description
10925-1	78-8137-3294-4	Frame – Tape Mount Upper Assembly
10925-2	78-8137-3295-1	Frame – Front Upper Assembly
10925-3	78-8068-4143-9	Guide – #1
10925-4	78-8068-4144-7	Guide – #2
10925-5	78-8060-7818-0	Screw – Hex Hd, M4 x 12
10925-6	78-8010-7416-8	Nut – Hex Jam, M4
10925-7	78-8070-1251-9	Spacer – Spring
10925-8	78-8137-3298-5	Shaft - Pivot 90mm
10925-9	78-8052-6560-6	Spacer – Front
10925-10	78-8060-7936-0	Brush Assembly
10925-11	78-8052-6564-8	Shaft – Tension Roller
10925-12	78-8052-6568-9	Shaft – Wrap Roller
10925-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10925-15	78-8100-1009-6	Washer – Special
10925-16	78-8052-6565-5	Roller – Top Tension
10925-17	26-1004-5510-9	Washer – Plain, M10
10925-18	78-8052-6567-1	Spring – Compression
10925-19	78-8017-9077-1	Nut – Self Locking, M10 x 1
10925-20	78-8052-6569-7	Roller – Wrap
10925-21	26-1000-1613-3	Ring – Retaining, Tru-Arc #1-420-0120-100
10925-22	78-8076-4500-3	Stud – Mounting (not shown)
10925-23	78-8076-5242-1	Stop – Cut-Off Frame
10925-24	78-8060-8179-6	Screw – Flat Hd Hex, M6 x 20
10925-25	78-8076-5477-3	Washer – Special /6.5 x 20 x 4
10925-26	78-8137-3299-3	Guard – Head
10925-27	78-8060-8087-1	Screw – M5 x 10
10925-28	78-8005-5741-1	Washer – Flat, M5
10925-29	78-8133-9615-3	Bumper
10925-30	78-8133-9605-4	Label – Threading, English Language
10925-31	78-8076-4716-5	Star Washer 4mm

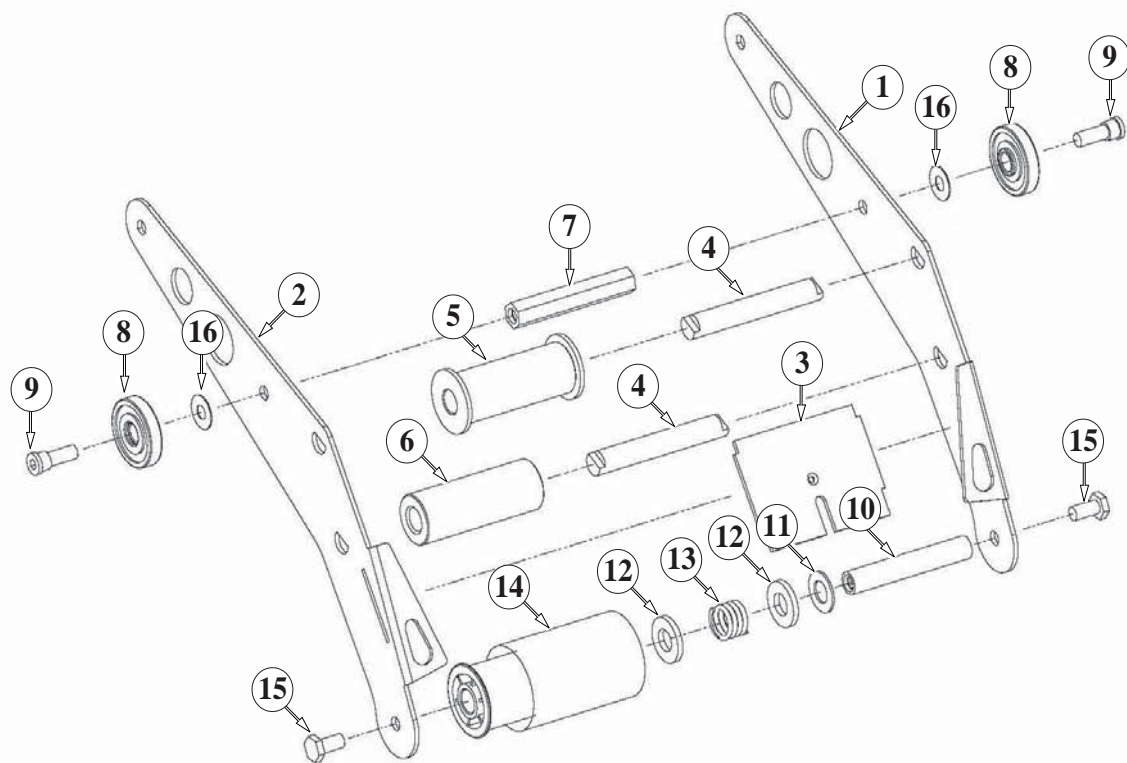


Figure 10922 – Upper and Lower Heads

AccuGlide™ 3 - 2"

Figure 10922 – 2" Upper and Lower Heads

Ref. No.	3M Part No.	Description
10922-1	78-8133-9509-8	Applying Arm #1
10922-2	78-8133-9510-6	Applying Arm #2
10922-3	78-8070-1221-2	Plate – Tape
10922-4	78-8070-1309-5	Shaft Roller
10922-5	78-8070-1367-3	Roller – Knurled Assembly
10922-6	78-8070-1266-7	Roller – Wrap
10922-7	78-8052-6580-4	Spacer
10922-8	78-8017-9082-1	Bearing – Special, 30 mm
10922-9	78-8017-9106-8	Screw – Bearing Shoulder
10922-10	78-8052-6575-4	Shaft – Roller
10922-11	78-8017-9074-8	Washer – Nylon, 15 mm
10922-12	26-1004-5510-9	Washer – Friction
10922-13	78-8052-6567-1	Spring – Compression
10922-14	78-8137-1438-9	Assembly– Applying Roller
10922-15	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10922-16	78-8094-6151-6	Washer - Flat, 6.5 ID x 15 OD x 0.5 Thk

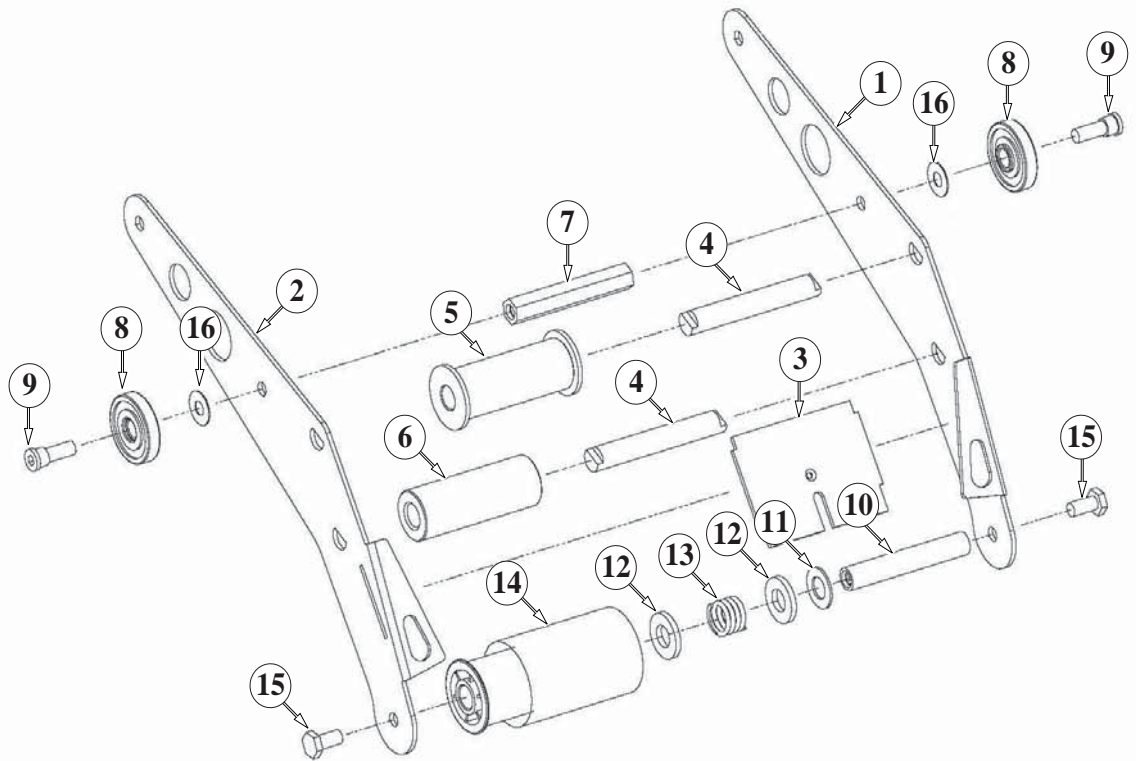


Figure 10919 – Upper Head

AccuGlide™ 3 - 2"

Figure 10919 – 2" Upper Head

Ref. No.	3M Part No.	Description
10919-1	78-8137-3300-9	Buffing Arm – Sub Assembly
10919-2	78-8137-3301-7	Buffing Arm – Sub Assembly
10919-3	78-8052-6575-4	Shaft – Roller
10919-4	78-8137-1398-5	Roller - Buffing Assembly
10919-5	78-8070-1220-4	Spacer – Spring
10919-6	78-8052-6580-4	Spacer
10919-7	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10919-8	78-8137-3311-6	Spring – Upper (100 fpm)
10919-9	78-8070-1244-4	Holder – Spring

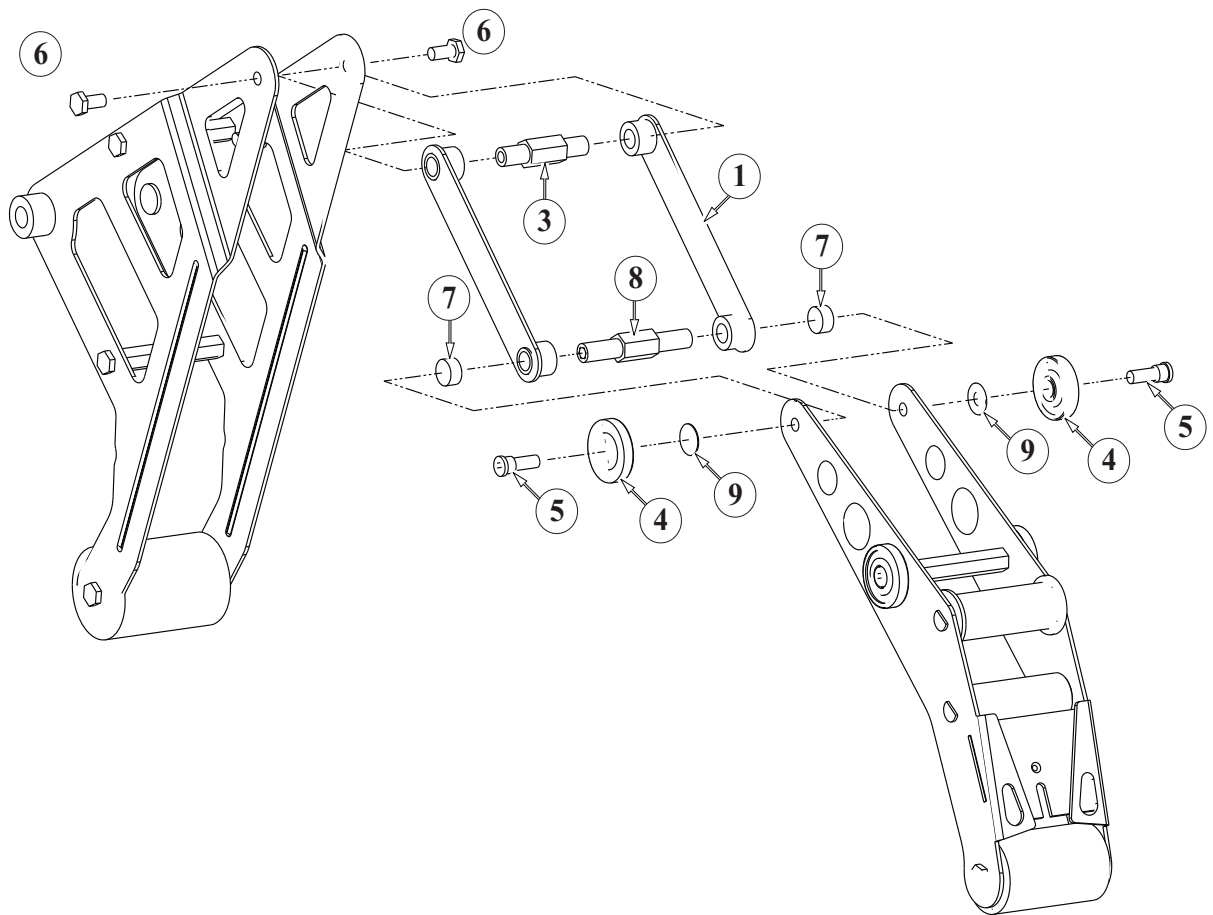


Figure 10923 – Upper and Lower Heads

AccuGlide™ 3 - 2"

Figure 10923 – 2" Upper and Lower Heads

Ref. No.	3M Part No.	Description
10923-1	78-8137-3302-5	Link – Assembly
10923-3	78-8137-3304-1	Shaft – Pivot, Buffing
10923-4	78-8017-9082-1	Bearing – Special 30 mm
10923-5	78-8017-9106-8	Screw – Bearing Shoulder
10923-6	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10923-7	78-8137-3305-8	Spacer – Applying Pivot
10923-8	78-8137-3306-6	Shaft – Pivot, Applying
10923-9	78-8094-6151-6	Washer - Flat, 6.5 ID x 15 OD x 0.5 Thk

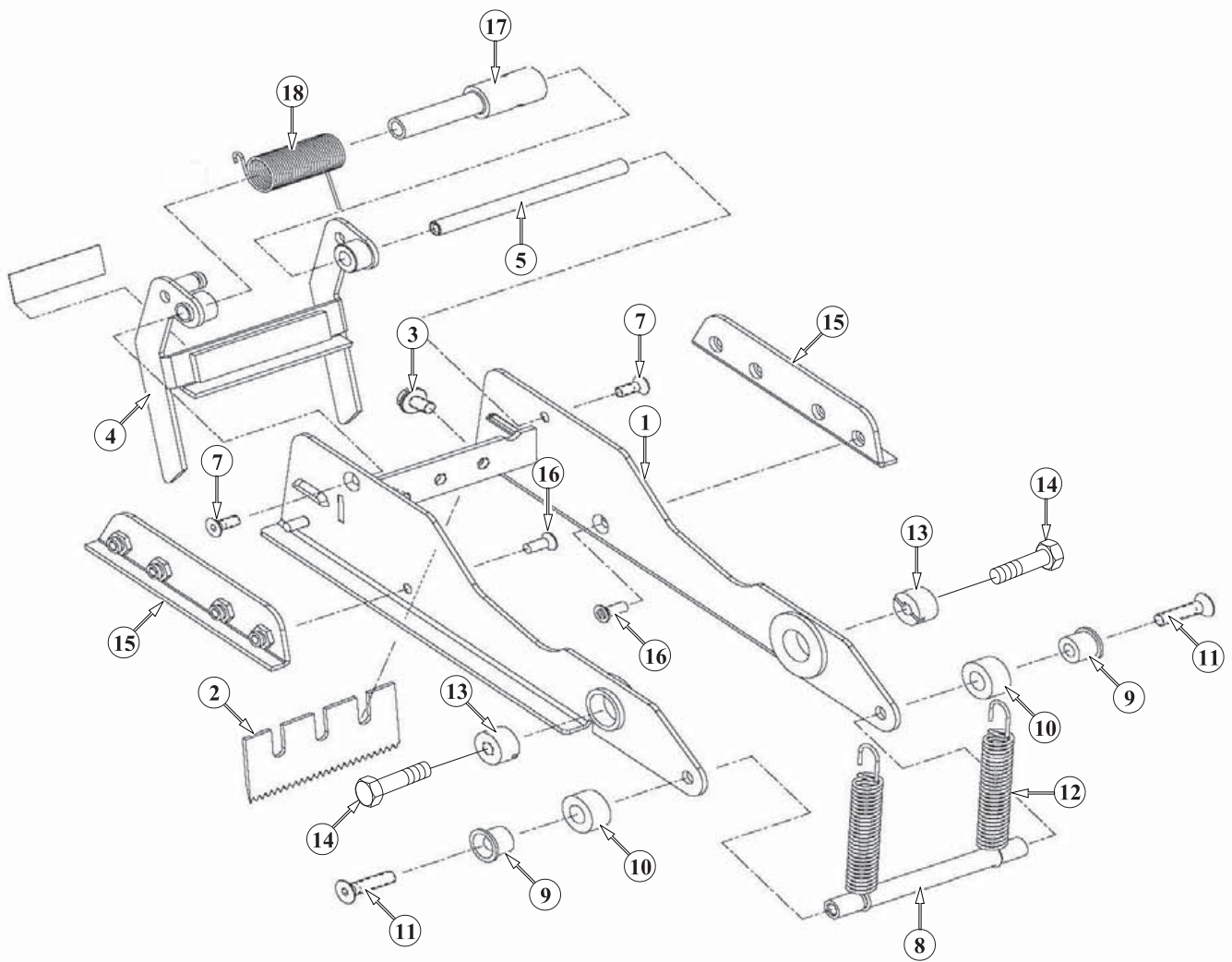


Figure 10921 – Upper and Lower Heads

AccuGlide™ 3 - 2"

Figure 10921 – 2" Upper and Lower Heads

Ref. No.	3M Part No.	Description
10921-1	78-8137-3307-4	Frame – Cut-Off Weldment
10921-2	78-8017-9173-8	Blade – 65 mm/2.56 Inch
10921-3	26-1003-8596-7	Screw - Hex Hd M5 x 8 w/ Ext. Tooth Lockwasher
10921-4	78-8070-1371-5	Blade Guard Assembly – W/English Language Label
10921-5	78-8052-6597-8	Shaft – Blade Guard
10921-7	26-1005-4758-2	Screw – Flat Hd, Soc Dr, M4 x 10
10921-8	78-8017-9135-7	Shaft – Spacer
10921-9	78-8052-6600-0	Spacer
10921-10	78-8070-1269-1	Bumper
10921-11	26-1005-4757-4	Screw – Flat Hd, Soc Dr, M5 x 20
10921-12	78-8052-6602-6	Spring – Cutter
10921-13	78-8017-9132-4	Pivot – Cutter Lever
10921-14	26-1003-5828-7	Screw – Spec, Hex Hd, M6 x 10
10921-15	78-8137-3308-2	Slide – Extension
10921-16	26-1008-6574-5	Screw – Flat Hd, Phil Dr, M4 x 10
10921-17	78-8113-7031-7	Bushing – 58.5mm Long
10921-18	78-8113-7030-9	Spring – Torsion
10921-19	78-8070-1335-0	Label – Warning, English

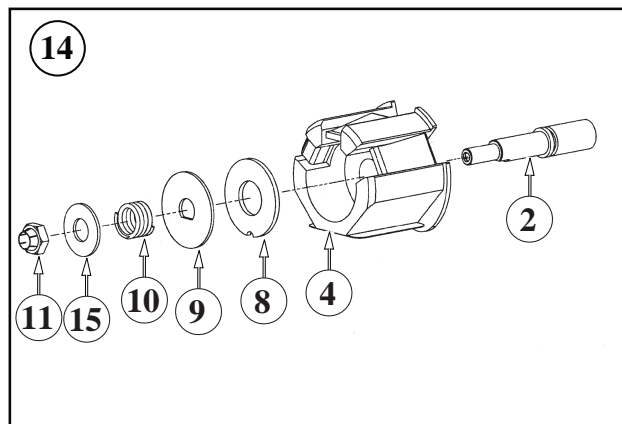
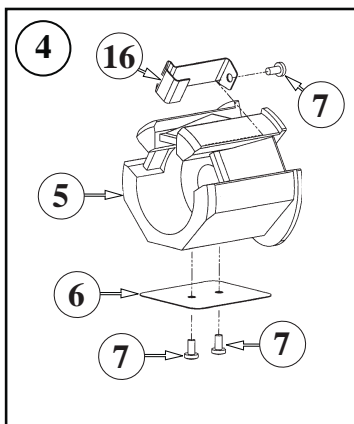
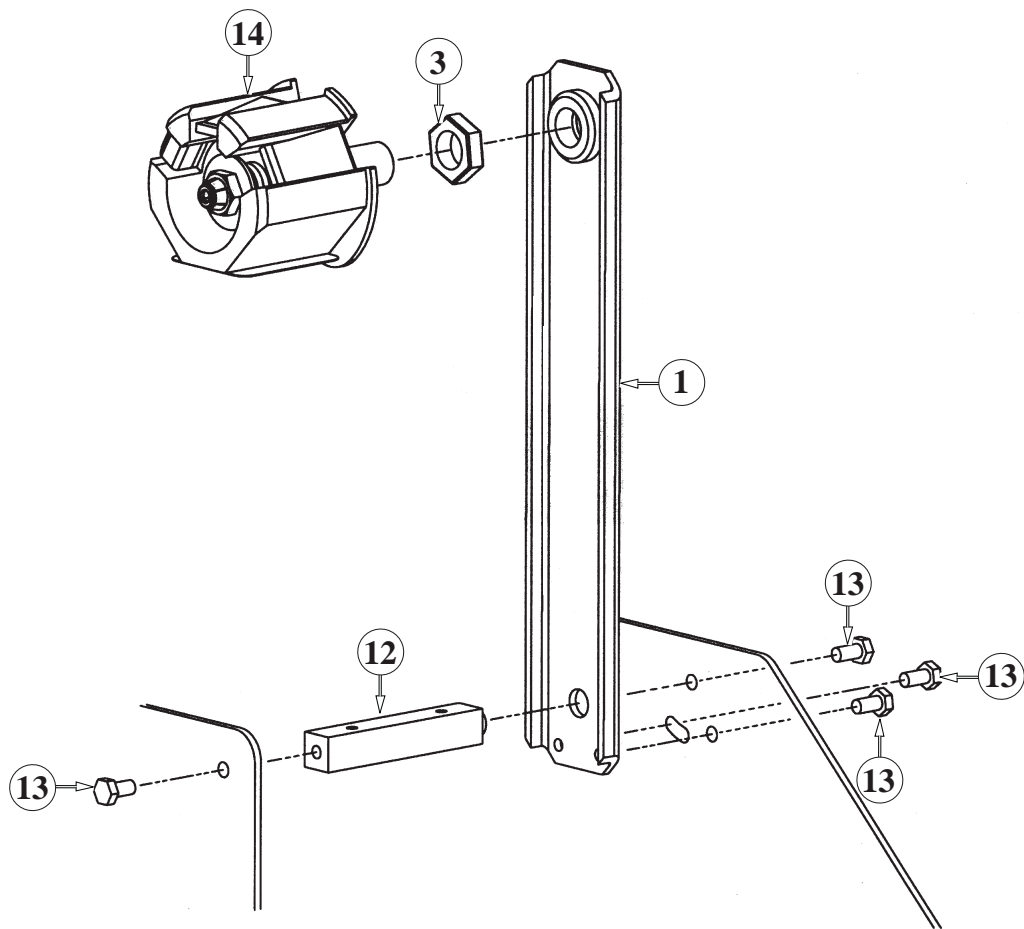


Figure 10401 – Upper and Lower Heads

AccuGlide™ 3 - 2"

Figure 10401 – 2" Latch Upper and Lower Heads

Ref. No.	3M Part No.	Description
10401-1	78-8070-1395-4	Bracket – Bushing Assembly
10401-2	78-8076-4519-3	Shaft – Tape Drum, 50mm
10401-3	78-8017-9169-6	Nut – M18 x 1
10401-4	78-8098-8827-0	Tape Drum Sub Assembly – 2 Inch Wide
10401-5	78-8098-8749-6	Tape Drum
10401-6	78-8098-8817-1	Leaf Spring
10401-7	26-1002-5753-9	Screw – Self Tapping
10401-8	78-8060-8172-1	Washer – Friction
10401-9	78-8052-6271-0	Washer – Tape Drum
10401-10	78-8100-1048-4	Spring – Core Holder
10401-11	78-8017-9077-1	Nut – Self Locking, M10 x 1
10401-12	78-8100-1046-8	Spacer – Bracket
10401-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10401-14	78-8098-8814-8	Tape Drum Assembly – 2 Inch Head
10401-15	26-1004-5510-9	Washer – Plain, M10
10401-16	78-8098-8816-3	Latch – Tape Drum

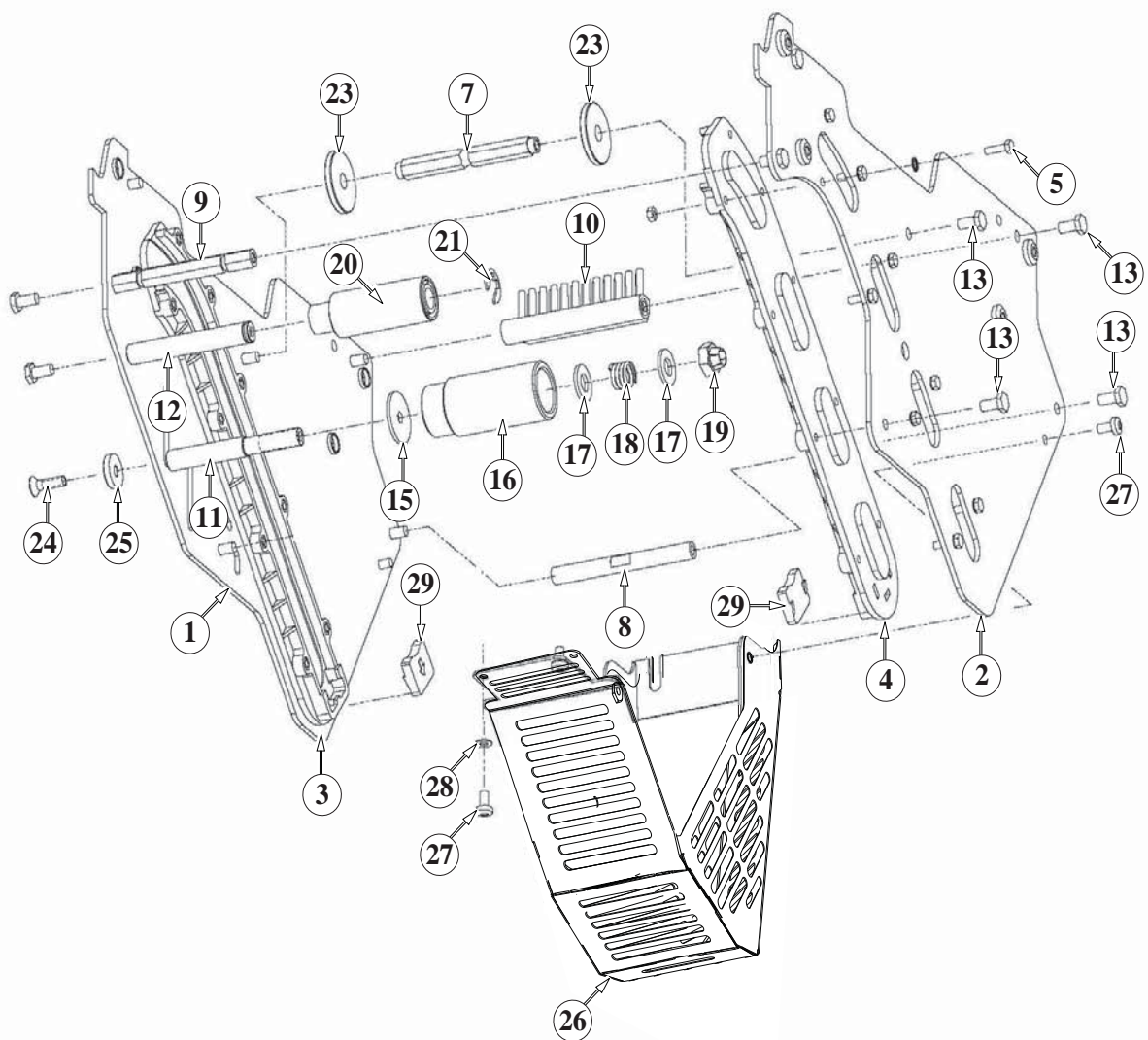


Figure 10924 – Lower Head

Figure 10924 – 2" Lower Head

Ref. No.	3M Part No.	Description
10924-1	78-8137-3296-9	Frame – Tape Mount Lower Assembly
10924-2	78-8137-3297-7	Frame – Front Lower Assembly
10924-3	78-8068-4144-7	Guide – #2
10924-4	78-8068-4143-9	Guide – #1
10924-5	78-8060-7818-0	Screw – Hex Hd, M4 x 12
10924-6	78-8010-7416-8	Nut – Hex, M4
10924-7	78-8070-1251-9	Spacer – Spring
10924-8	78-8054-3298-5	Spacer – 10 x 10 x 90 mm
10924-9	78-8052-6560-6	Spacer – Front
10924-10	78-8060-7936-0	Brush Assembly
10924-11	78-8052-6564-8	Shaft – Tension Roller
10924-12	78-8052-6568-9	Shaft – Wrap Roller
10924-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10924-15	78-8100-1009-6	Washer – Special
10924-16	78-8052-6606-7	Roller – Tension Bottom
10924-17	26-1004-5510-9	Washer – Plain, M10
10924-18	78-8052-6567-1	Spring – Compression
10924-19	78-8017-9077-1	Nut – Self Locking, M10 x 1
10924-20	78-8052-6569-7	Roller – Wrap
10924-21	26-1000-1613-3	Ring – Retaining, Tru-Arc #1-420-0120-100
10924-22	78-8076-4500-3	Stud – Mounting (not shown)
10924-23	78-8076-5242-1	Stop – Cut-Off Frame
10924-24	78-8060-8179-6	Screw – Flat Hd Hex, M6 x 20
10924-25	78-8076-5477-3	Washer – Special /6.5 x 20 x 4
10924-26	78-8137-3299-3	Guard – Head
10924-27	78-8060-8087-1	Screw – M5 x 10
10924-28	78-8005-5741-1	Washer – Flat, M5
10924-29	78-8076-4734-8	Bumper
10924-30	78-8133-9606-2	Label – Threading, English Language
10924-31	78-8076-4716-5	Star Washer 4mm

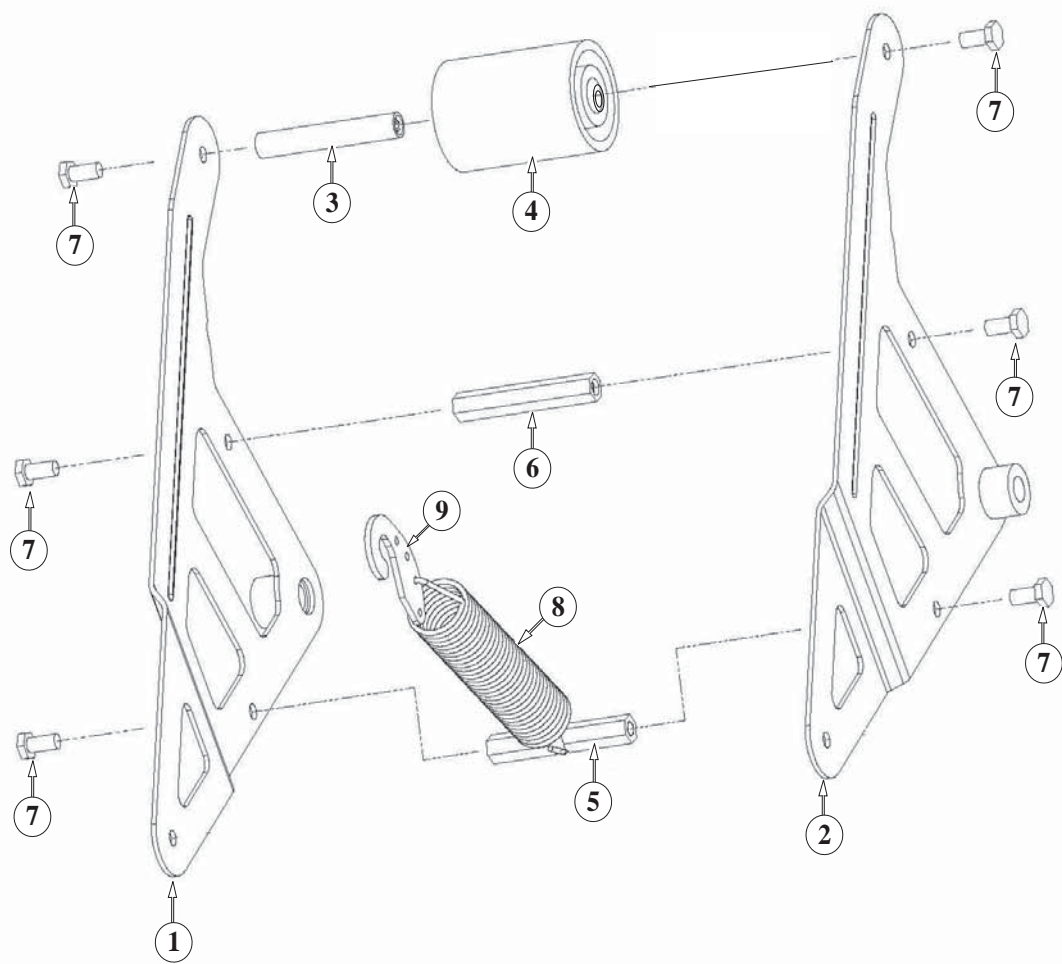


Figure 10920 – Lower Head

AccuGlide™ 3 - 2"

Figure 10920– Lower Head

Ref. No.	3M Part No.	Description
10920-1	78-8137-3300-9	Buffing Arm – Sub Assembly
10920-2	78-8137-3301-7	Buffing Arm – Sub Assembly
10920-3	78-8052-6575-4	Shaft – Roller
10920-4	78-8137-1398-5	Roller - Buffing Assembly
10920-5	78-8070-1220-4	Spacer – Spring
10920-6	78-8052-6580-4	Spacer
10920-7	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10920-8	78-8137-3312-4	Spring – Lower (100 fpm)
10920-9	78-8070-1244-4	Holder – Spring

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