



Instructions and Parts List

3M-MaticTM

800r Type 40800

Random

Case Sealer

with

AccuGlideTM **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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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 800r** Random case sealer.

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

Edition June 2015

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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.

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

Technical Assistance / Replacement Parts and Additional Manuals:

For technical assistance, contact our 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 800r - Type 40800 - Serial Number 13282).


To order replacement parts, contact us:

CSPD division of Combi Packaging Systems LLC.

5365 East Center Dr. N.E.
Canton, OH 44721

1-800-344-9883
e-mail: CSPD-CSR@combi.com
www.combi.com

Identification Plate

3M 3M Company St. Paul, MN 55144 USA	Part Number	3M-Matic™ For Commercial use only			 4000588
	Model	Year	Ampere	Watt	
Type	Serial Number	Volt	Hertz	Phase	

3M

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

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TABLE OF CONTENTS - MANUAL 1: 800r Random Case Sealer
(For Taping Head Information - See MANUAL 2: AccuGlide™ 3 Taping Heads - 2 inch)

800r Random Case Sealer	Page
Cover Page	
Replacement Parts and Service Information	i-ii
Table of Contents	iii-iv
Acronyms and Abbreviations	v
1. Introduction	
1.1 Manufacturing Specifications / Description / Intended Use	1 - 2
1.2 How to Read and Use the Manual	2
1.2.1 Importance of the Manual	2
1.2.2 Manual Maintenance	2
1.2.3 Consulting the Manual	2
1.2.4 How to Update the Manual in Case of Modifications	2
2. General Information	
2.1 Identification Data	3
2.2 Warranty / Contents	4
3. Safety	
3.1 General Safety Information	5
3.2 Signal Words Explanation	5
3.3 Table of Warnings	6 - 7
3.4 Operator's Qualifications Definition	8
3.5 Number of Operators	8
3.6 Safe Use of the Machine Instructions	8
3.7 Residual Hazards	8
3.8 Prevent Other Hazards - Recommendations and Measures	8
3.9 Personal Safety Measures	8
3.10 Incorrect / Predictable Actions Not Allowed	8
3.11 Operator's Required Skill Levels	9
3.12 Component Locations	10
3.13 Table of Warnings and Replacement Labels	11 - 12
4. Technical Specifications	
4.1 Power Requirements	13
4.2 Operating Rate	13
4.3 Operating Conditions	13
4.4 Tape	13
4.5 Tape Width	13
4.6 Tape Roll Diameter	14
4.7 Tape Application Leg Length - Standard	14
Tape Application Leg Length - Optional	
4.8 Box Board	14
4.9 Box Weight and Size Capacities	14
4.10 Machine Noise Levels	15
4.11 Machine Dimensions	15
4.12 Setup Recommendations	15

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TABLE OF CONTENTS (continued)

5. Shipment, Handling, and Storage

5.1 Packed Machine Shipment and Handling 16
5.2 Overseas Shipment Packaging (Optional) 16
5.3 Handling and Transportation of Uncrated Machine 16
5.4 Machine Storage 16

6. Unpacking

6.1 Uncrating 17
6.2 Packaging Materials Disposal 17

7. Installation

7.1 Operating Conditions 18
7.2 Space Requirements for Machine Operation and Maintenance 18
7.3 Tool Kit Supplied with the Machine 18
7.4 Machine Positioning / Machine Setup 18
7.5 Plastic Ties Removal 19
7.6 Assembly Completion 19
7.7 Taping Heads Completion 20
7.8 Outboard Tape Roll Holder 20
7.9 Preliminary Electric Inspection 20
7.10 Main Power Machine Connection and Inspection 20
7.11 Phases Inspection 20

8. Theory of Operation

8.1 Working Cycle Description 21
8.2 Running Mode Definition 21
 8.3.1 Normal Stop Procedure 21
 8.3.2 Emergency Stop 21

9. Controls

9.1 Start / Stop Main Switch 22
9.2 Emergency Stop Button (Latching) 22

10. Safety devices

10.1 Blade Guards 23
10.2 Emergency Stop Button 23
10.3 Electric System / Circuit Breaker 23

11. Special Setup Procedure

11.1 Changing Tape Leg Length 24
11.2 Box Height Range 25

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TABLE OF CONTENTS (continued)

12. Operation

12.1	Operator's Correct Working Position	26
12.2	Starting the Machine	26
12.3	Starting Production	26
12.4	Tape Replacement	26
12.5	Box Size Adjustment	26
12.6	Cleaning	26
12.7	Table of Adjustments	26
12.8	Safety Devices Inspection	26
12.9	Troubleshooting	27 - 28

13. Maintenance

13.1	Safety Measures (see section 3)	29
13.2	Tools and Spare Parts Supplied with Machine	29
13.3	Maintenance Operations - Recommended Inspections and Frequency	29
13.4	Inspections to be Performed Before and After Every Maintenance Operation	29
13.5	Safety Features (Inspection Efficiency)	29
13.6	Machine Cleaning	29
13.7	Cutter Blade Cleaning	29
13.8	Drive Belt Replacement	30
13.9	Drive Pulley Ring	31
13.10	Drive Belt Tension	32
13.11	Special Setup Procedures	32 - 36
	13.11.1 Case Sealer Frame	32
	13.11.2 Taping Heads	33
	13.11.3 Drive Belt Assembly Height	33
13.12	Maintenance Work Log	35

14. Additional Instructions

14.1	Machine Disposal Information	37
14.2	Fire emergency	37

15. Enclosures and Special Information

15.1	Statement of Conformity	37
15.2	Hazardous Substances Emission	37
15.3	List of Safety Features	37
15.4	Copies of Test Reports, Certifications	37

16. Technical Documentation and Information

16.1	Electric / Pneumatic Diagrams	38 - 40
16.2	Spare Parts / Ordering	41 - 43

Drawings and Parts Lists	45 - End of Manual
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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

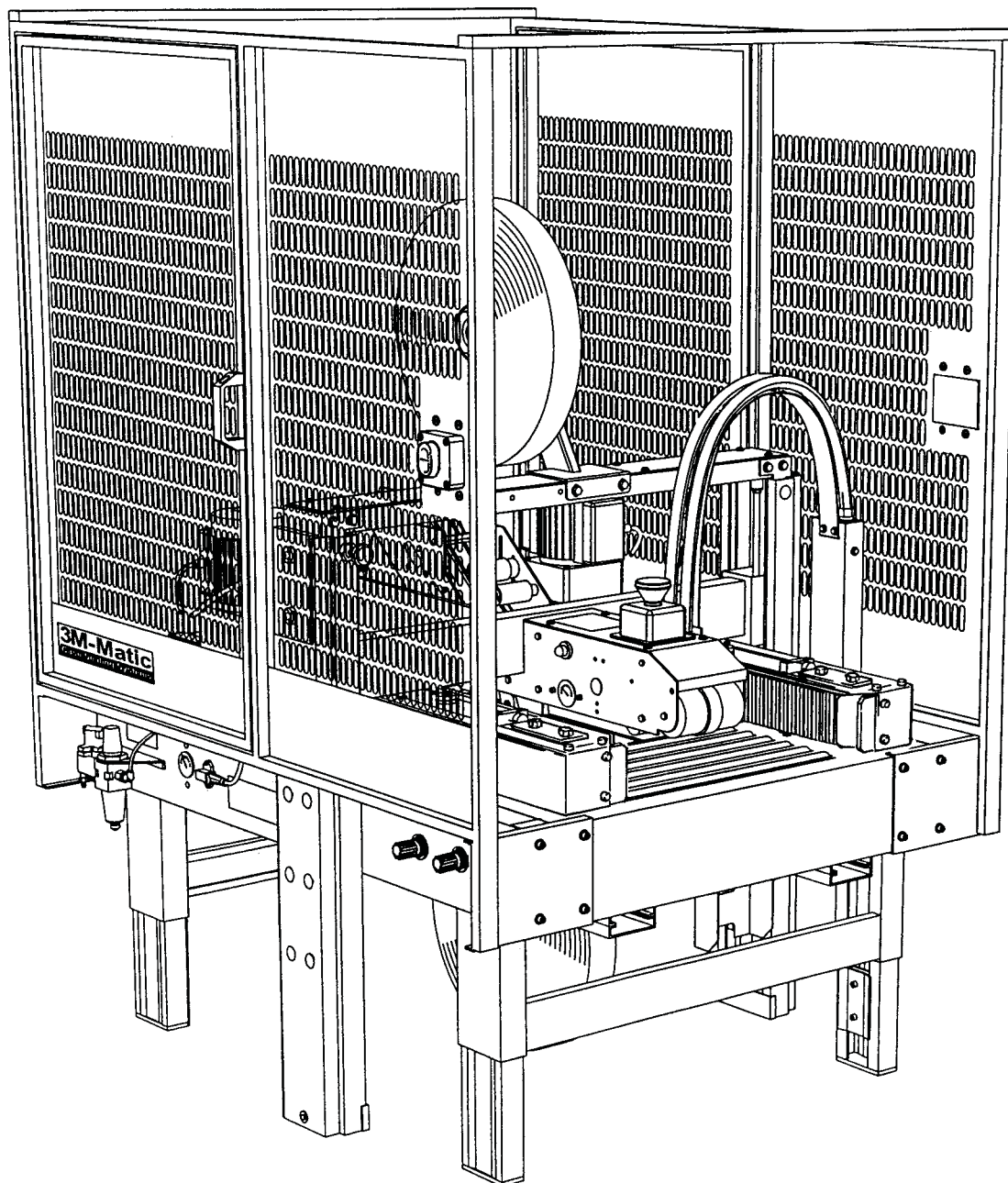
LIST OF ABBREVIATIONS AND ACRONYMS

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-INTRODUCTION

1.1 Manufacturing Specifications / Description / Intended Use

The **3M-Matic™ 800r Random Case Sealer with AccuGlide™ Taping Heads** is designed to apply a “C” clip of **Scotch®** pressure-sensitive film box sealing tape to the top and bottom center seam of regular slotted containers. The **800r** automatically adjusts to a wide range of box sizes (see "Specifications Section – Box Weight and Size Capacities").



3M-Matic™ 800r Random Case Sealer, Type 40800

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™ **800r** Adjustable case sealer 3M Industrial Adhesives and Tapes Division 3M Center, Bldg. 220-5E-06 St. Paul, MN 55144-1000 (USA) Edition June 2015 Copyright 3M 2010 All rights reserved. The manufacturer reserves the right to change the product at any time without notice. Publication © **3M 2015 44-0009-2088-2**.

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:



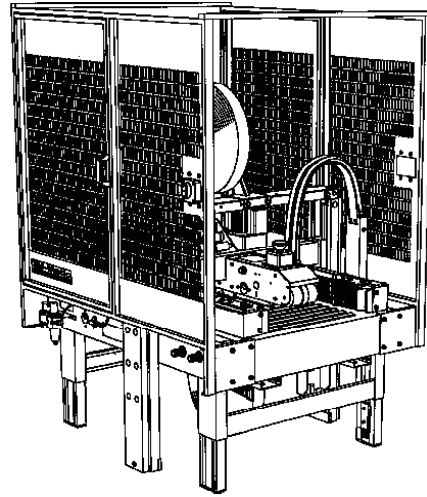
1.2.4 How to Update the Manual in Case of Modifications to the Machine


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)



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

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™ 800r Adjustable Case Sealer, Type 40800** 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.

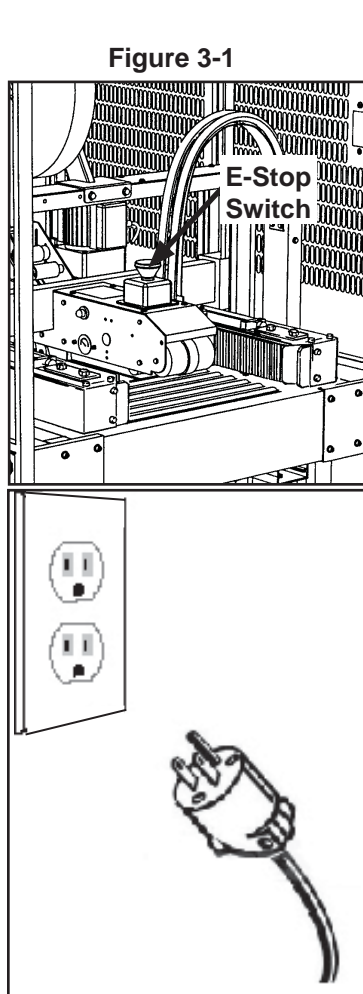
Contents — 800r Random Case Sealer

- (1) **800r Random Case Sealer, Type 40800**
- (1) Tool and Spare Parts Kit
- (1) Instruction and Parts Manual

3-SAFETY

3.1 General Safety Information

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



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.


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.


3.3 Table of Warnings

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

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

 WARNING
<ul style="list-style-type: none"> • To reduce the risk associated with pinches, entanglement and hazardous voltage: <ul style="list-style-type: none"> – Turn electrical and air supplies 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.

	<p>SAFETY INSTRUCTIONS</p> <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
<p>Figure 3-2</p>	

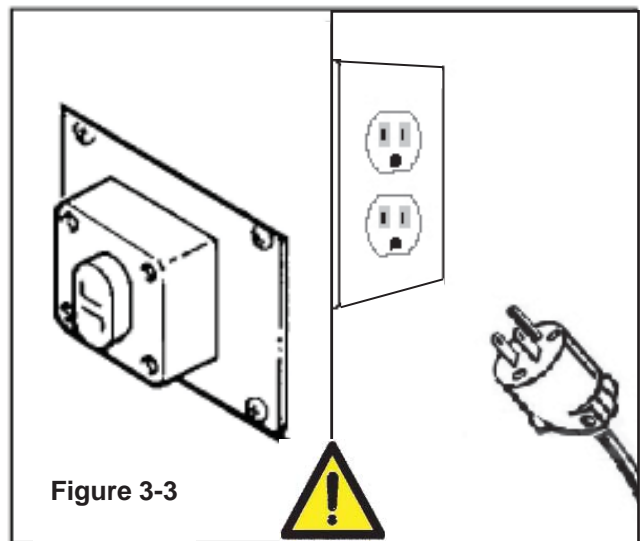


Figure 3-3

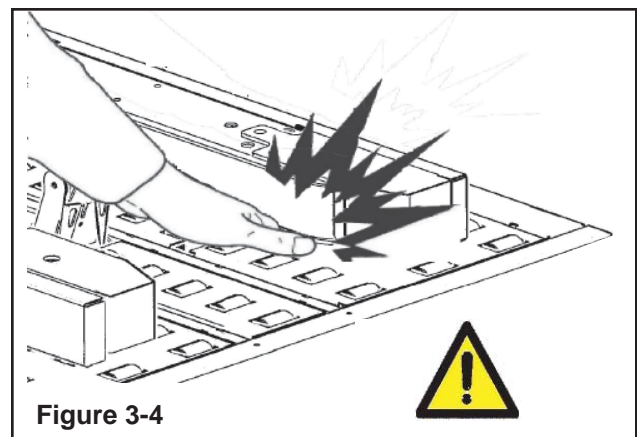


Figure 3-4

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**).

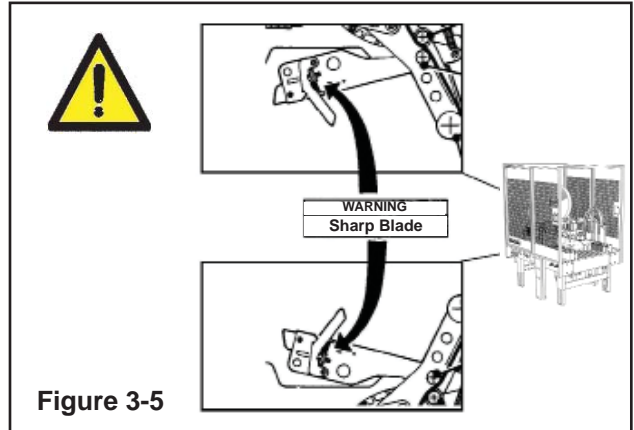


Figure 3-5



WARNING

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

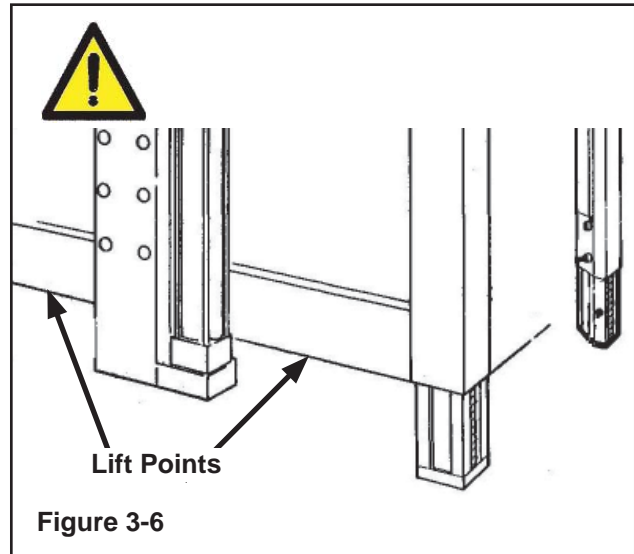


Figure 3-6



WARNING

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

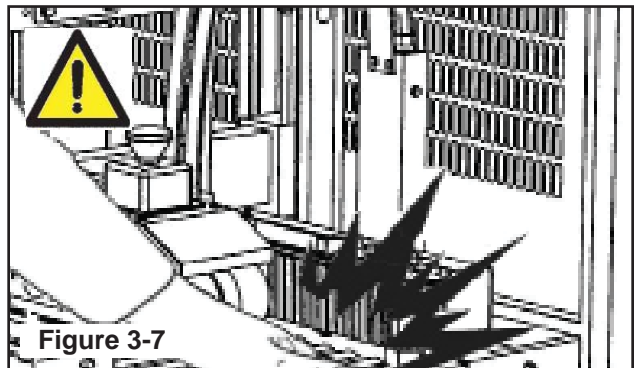


Figure 3-7



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.

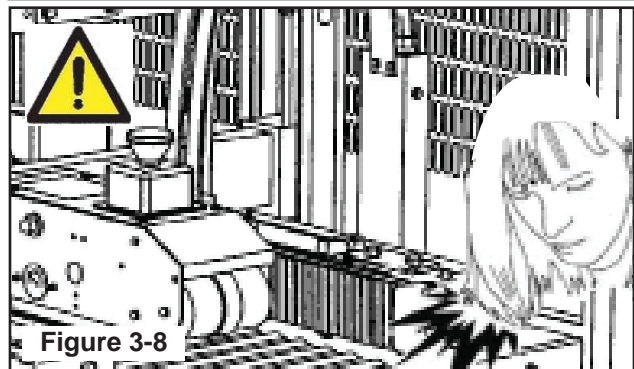


Figure 3-8

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 **800r** has been designed and incorporates various safety protections which should never be removed or disabled. Notwithstanding the safety precautions conceived by the designers of this machine, 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 - only use the EMERGENCY STOP BUTTON.
- 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).

 <b style="font-size: 1.2em; margin-left: 10px;">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

3.12 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.

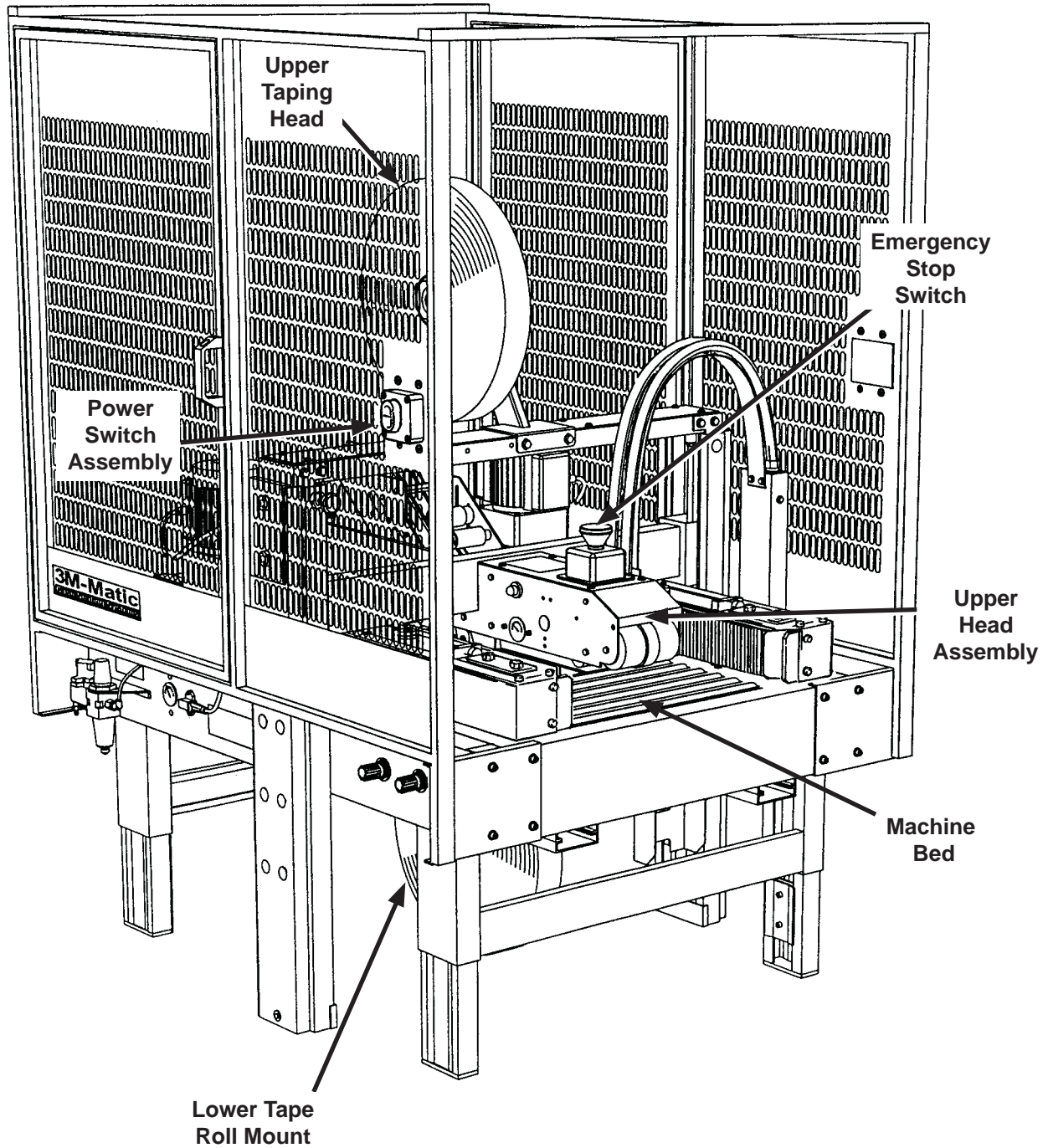


Figure 3-9 800r Case Sealer Components (Left Front View)

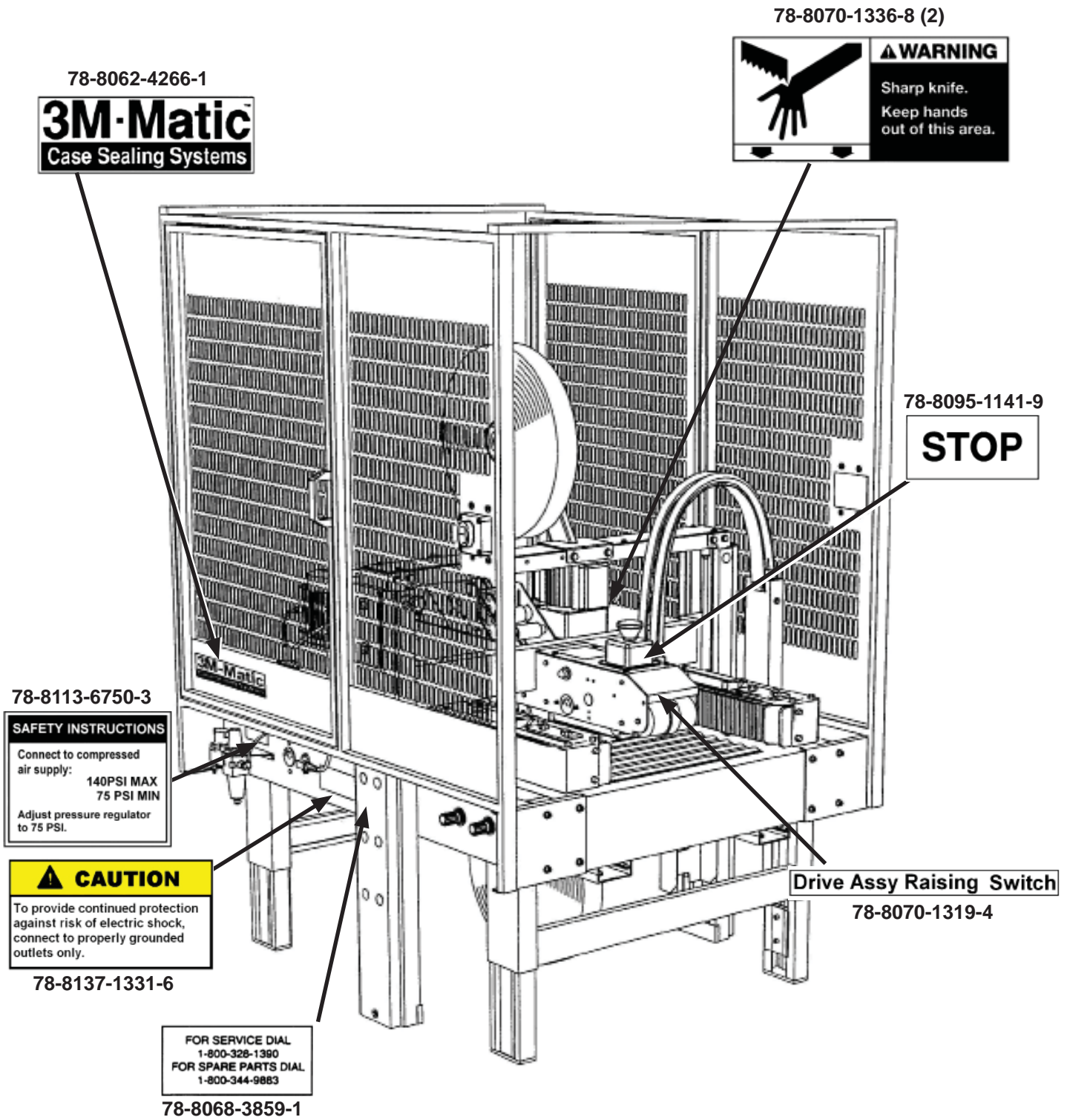


Figure 3-10 Replacement Labels/3M Part Numbers

78-8070-1332-7

SAFETY INSTRUCTIONS

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

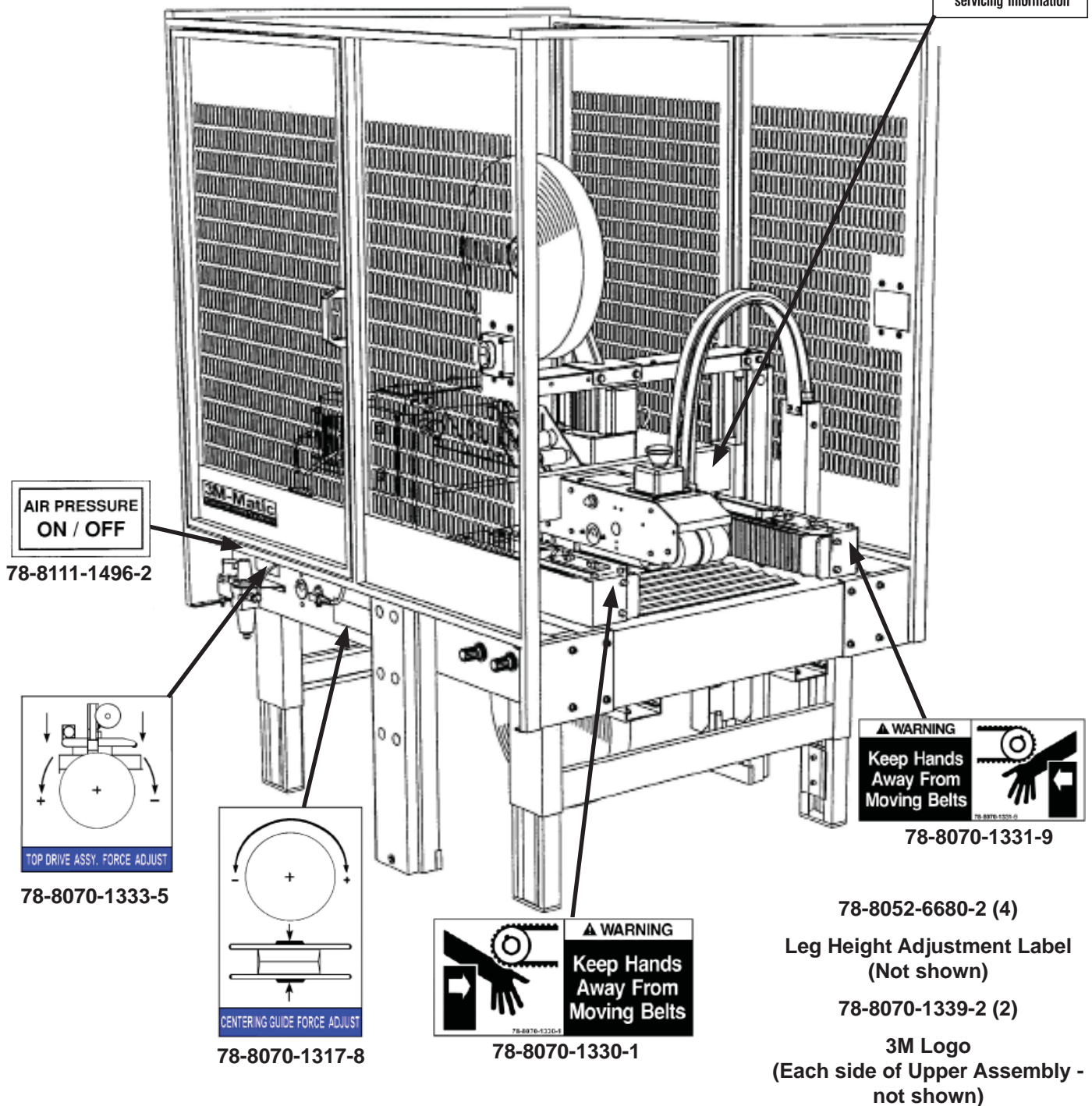


Figure 3-10 Replacement Labels/3M Part Numbers

4-SPECIFICATIONS

4.1 Power Requirements

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

Pneumatic - 5 bar gauge pressure [70 PSIG] 110 litre/min @ 21 C, 1.01 bar [3.75 SCFM]

A pressure regulator is included.

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

4.2 Operating Rate

Box drive belt speed is approximately 0.5 m/s [100 feet per minute]. Up to 24 boxes per minute.

Note: Actual production rate is dependent on box height/length, box size mix, and operator dexterity.

4.3 Operating Conditions

Use in dry, relatively clean environments at 5° C to 50° C [40° F to 120° F] with clean, dry boxes.

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



WARNING

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

4.4 Tape

Scotch[®] pressure-sensitive film box sealing tapes.

4.5 Tape Width

36mm [1 1/2 inch] minimum to 50mm [2 inch] maximum

4-SPECIFICATIONS (continued)

Specifications

4.6 Tape Roll Diameter

Up to 405mm [16 inch] maximum on a 76mm [3 inch] diameter core.

(Accommodates all system roll lengths of **Scotch**® film tapes.)

4.7 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 "Removing Taping Heads Procedure – Changing the Tape Leg Length")

4.8 Box Board

Style – regular slotted containers – RSC

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

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

4.9 Box Weight and Size Capacities

A. Box Weight, filled: 5 lbs.– 85 lbs. [2.3 kg–38.6 kg]. Contents must support flaps.

B. Box Size:	Minimum	Maximum
Length –	205mm [8.0 inch]	Unlimited
Width –	133mm [5.25 inch]	508mm [20.0 inch]
Height –	127mm [5.0 inch]	533mm [21.0 inch]

Outer Columns in Optional Raised Position

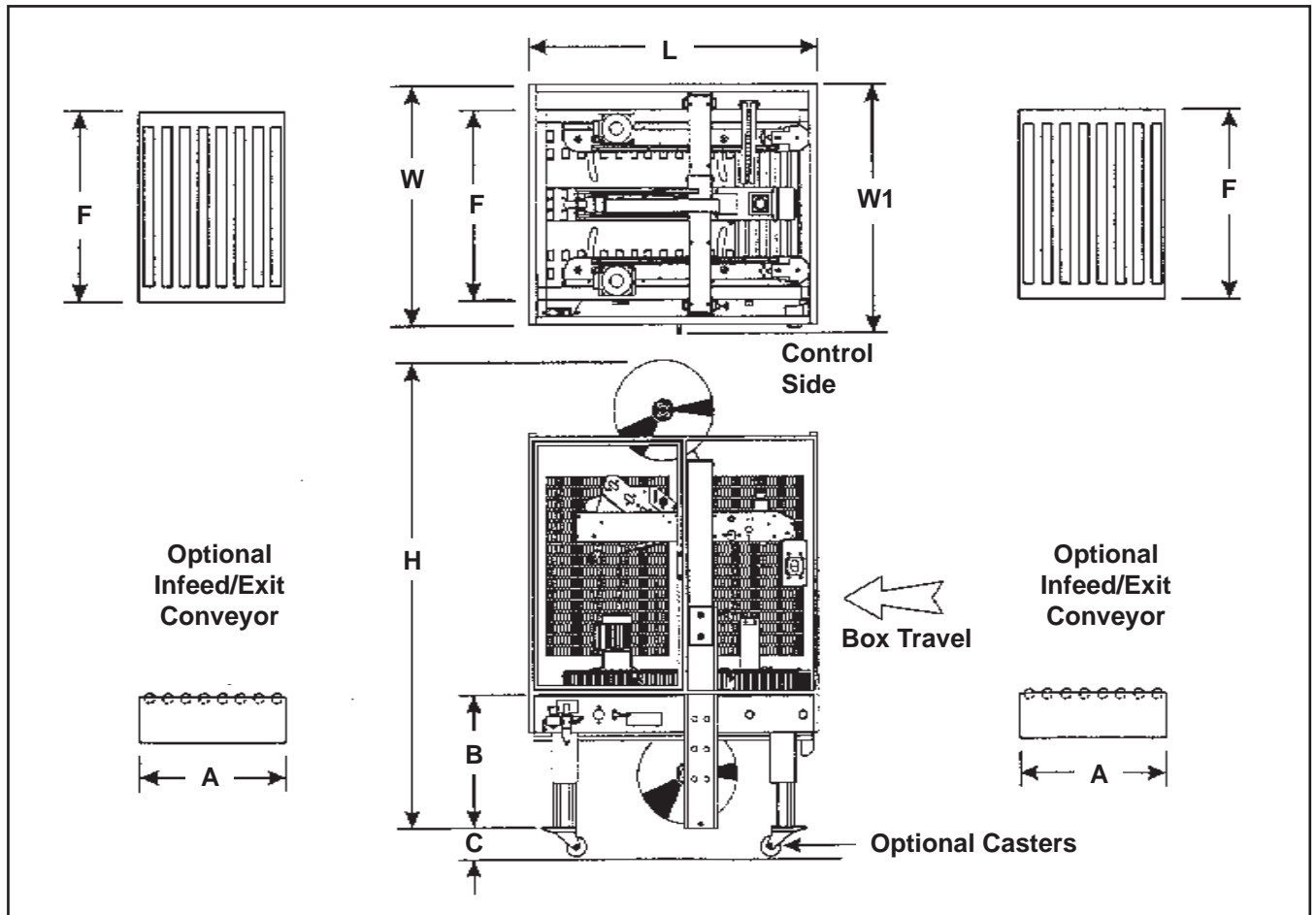
	Minimum	Maximum
Length –	150mm [6.0 inch]	Unlimited
Width –	95mm [3.75 inch]	508mm [20.0 inch]
Height –	232mm [9.12 inch]	644mm [25.4 inch]

Note: The case sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is 0.6 or less, test run several boxes to ensure proper machine performance.

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

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

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



4.10 Machine Dimensions:

	W	W1	L	H	A*	B	C**	F
Minimum millimeters [Inches]	970 [38.25]	1010 [39.75]	1180 [46.50]	1675 [66.00]	460 [18.00]	510 [20.00]	108 [4.25]	770 [30.38]
Maximum millimeters [Inches]	--	--	--	1955 [77.00]***	--	690 [27.25]	--	--

* Exit conveyor is optional

** Casters are optional

*** When columns are adjusted to upper position, "H" maximum dimension is 2062mm [81.19 inches].

(See

"Special Setup Procedure – Outer Column Re-Positioning")

Weight – 225kg [500 pounds] crated (approximate)

208kg [460 pounds] uncrated (approximate)

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).

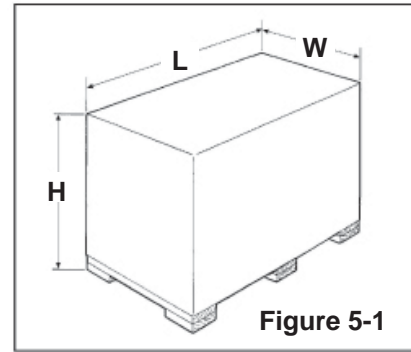


Figure 5-1

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.

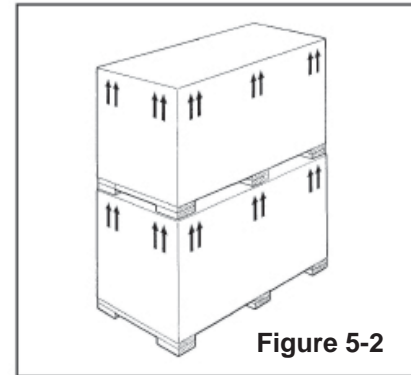


Figure 5-2

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).

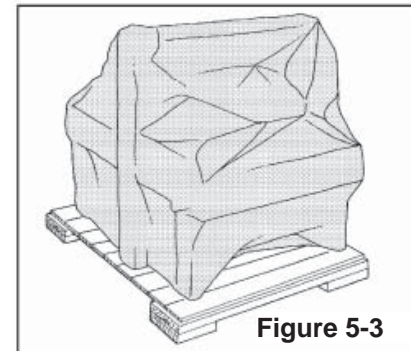


Figure 5-3

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).

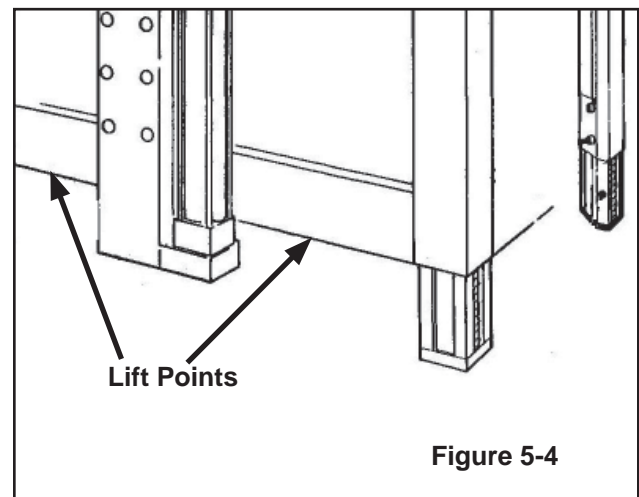
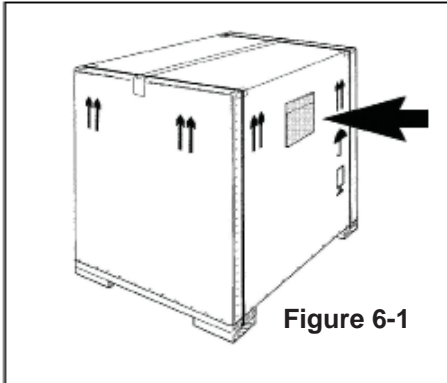


Figure 5-4

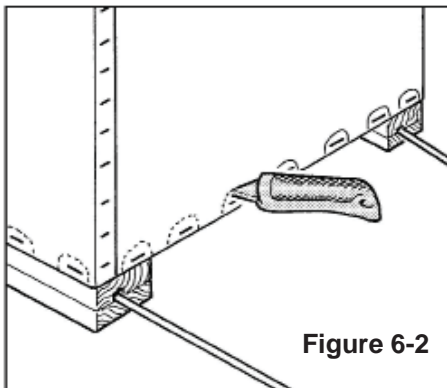
6-UNPACKING

6.1 Uncrating

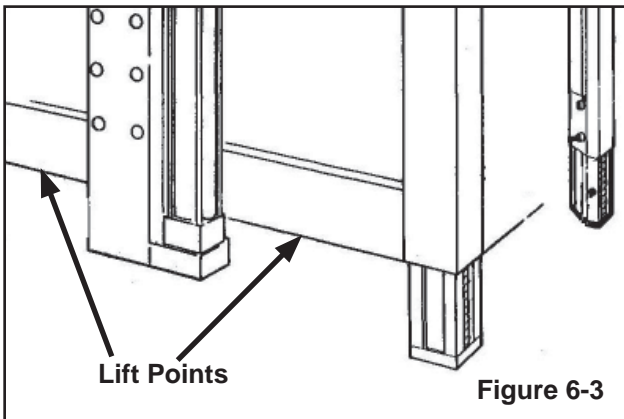
The envelope attached to the shipping box contains the uncrating instructions of the machine (**Figure 6-1**).



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



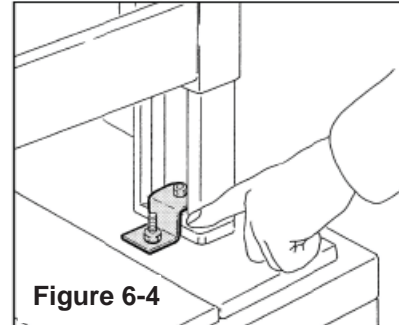
After cutting out or removing the staples, lift the shipping box in order to clear the machine (two persons required).



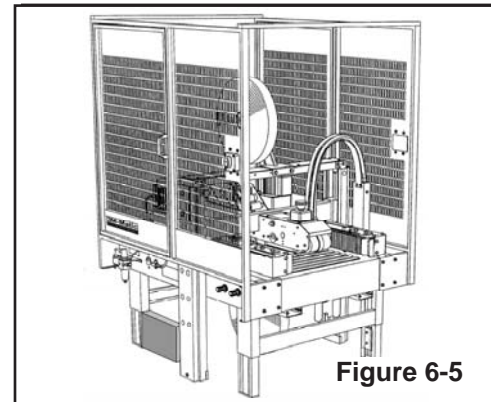
Transport the machine with a fork-lift truck to the operating position. Lift the pallet at the point indicated in **Figure 6-3** (weight of machine + pallet = See **Section 4 - Specifications**).

Removal of Pallet

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



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



6.2 Disposal of Packaging Materials

The **800r** 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.

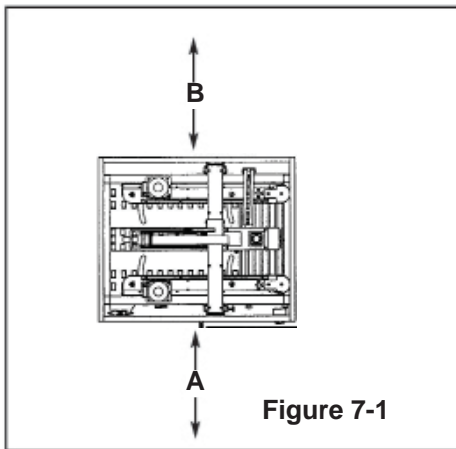


Figure 7-1

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.

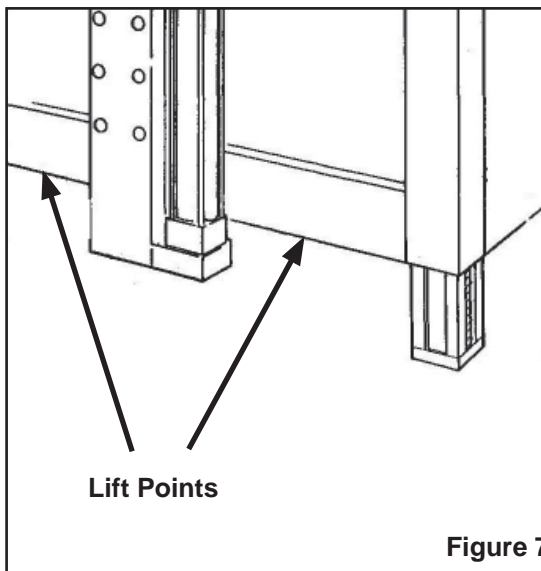



Figure 7-2

	WARNING
<ul style="list-style-type: none">• To reduce the risk associated with muscle strain:<ul style="list-style-type: none">– Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment.– Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift.	

7.4 Machine Positioning / Bed Height

1. Lift the machine with belts or ropes paying attention to place the belts in the points (**Figure 7-2**). To set the machine bed height, do the following:

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 inch] minimum to 890mm [35 inch] maximum - See Specifications.

Note – Minimum machine bed height can be reduced to 570mm [22.5 inch] by moving outer columns up one set of mountingholes. However, this change also increases minimum box height of 120mm [4.8 inch] to 170mm [6.8 inch].

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

2. Loosen, but do not remove, two (2) M8 x 1.25 socket head screws in one leg (use M6 hex wrench). Adjust the leg length for the desired machine bed height. Retighten the two (2) screws to secure the leg. Adjust all four (4) legs equally.

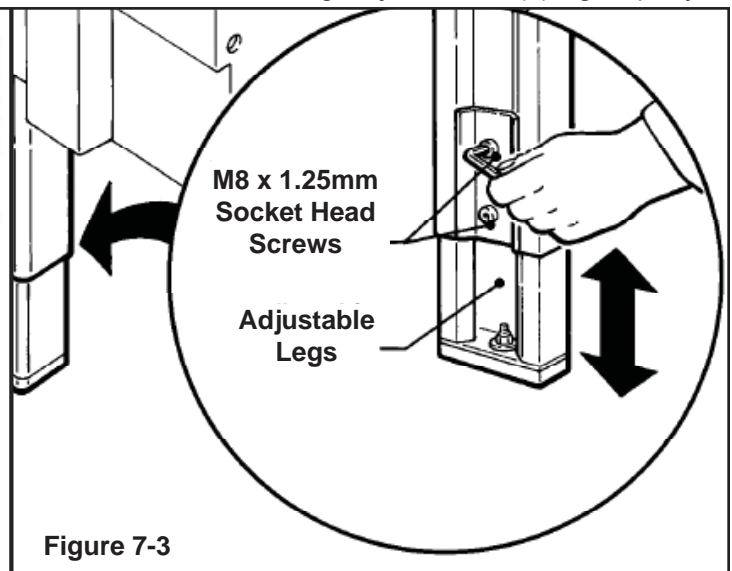


Figure 7-3

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).

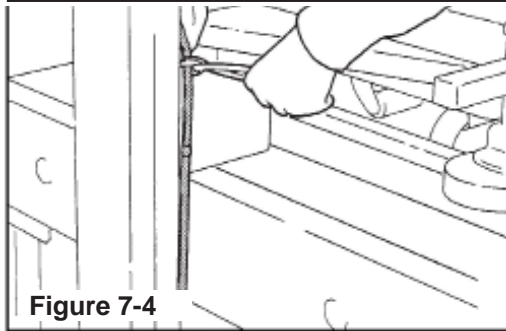


Figure 7-4

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

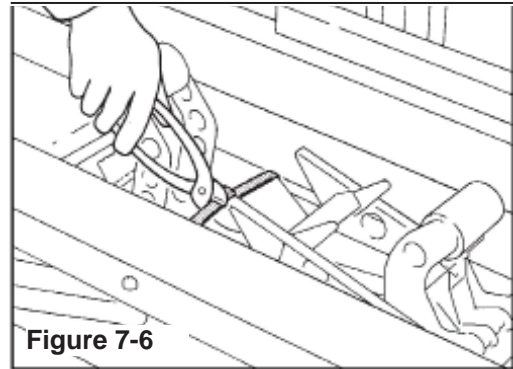


Figure 7-6

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

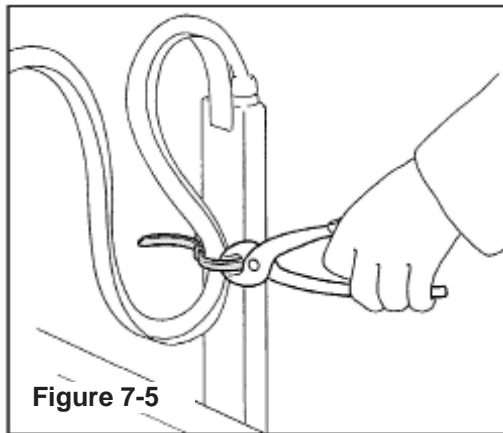


Figure 7-5

7.6 Assembly Completion

Tape Drum Bracket - Install the upper tape drum bracket on the top cross bar as shown (Figure 7-7).

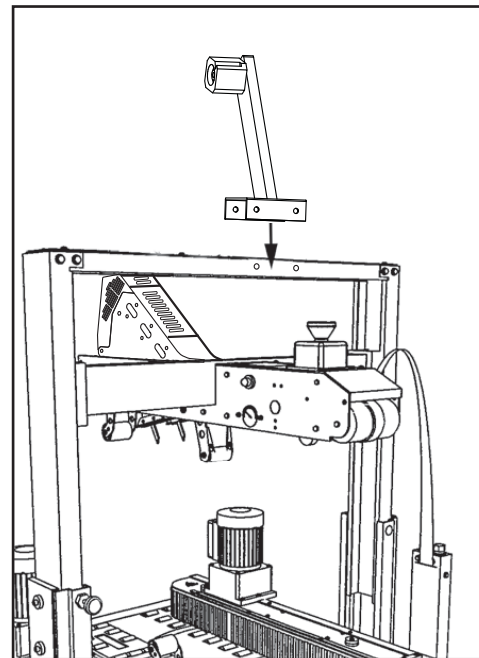


Figure 7-7

7-INSTALLATION (continued)

7.7 Completion of Taping Heads

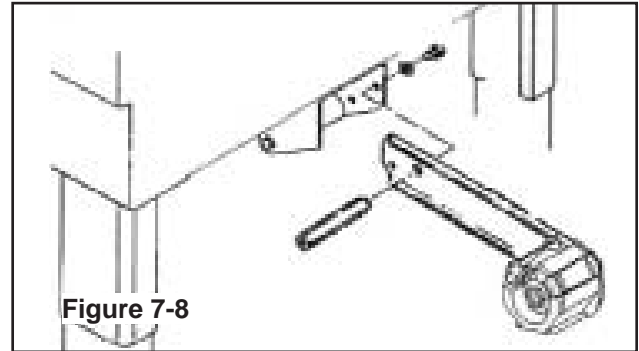
See Manual 2 for Complete Instructions:

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

7.8 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 Machine Connection to the Mains

- 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.

7.9 Preliminary Electric Inspection

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

- 7.9.1** 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.
- 7.9.2** Check that the connection of the machine to the mains meets the safety regulations in your country.
- 7.9.3** The machine is fitted with a main switch. The user will be responsible for testing the short-circuit current in its facility and should check that the short-circuit amperage setting of the machine is compatible with all the components of the mains system.

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

NA for this machine.

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 top and bottom 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.

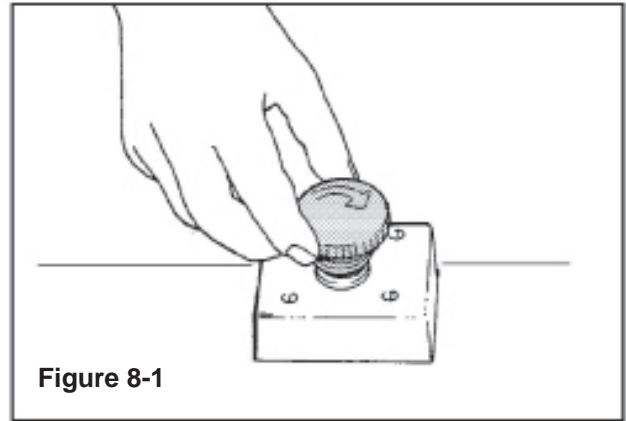


Figure 8-1

8.2 Definition of Running Mode

The case sealer **800r** has only one (automatic) operating mode with:

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

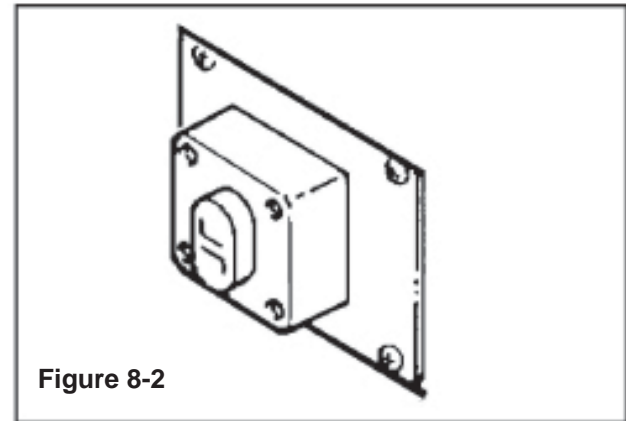


Figure 8-2

8.3.1 Normal Stop Procedure

When the main switch is turned 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.

8.3.2 Emergency Stop

The LATCHING EMERGENCY STOP BUTTON is located on the top center of the machine (**Figure 8-1**).

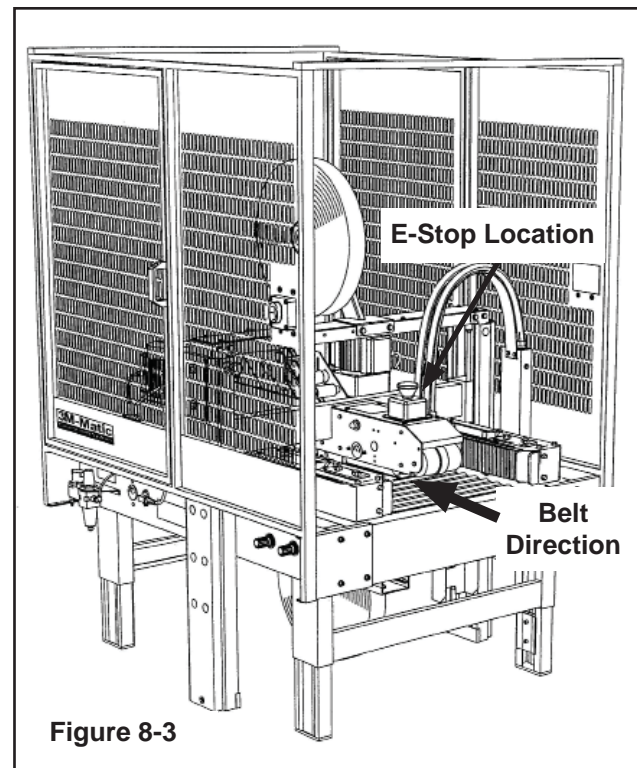
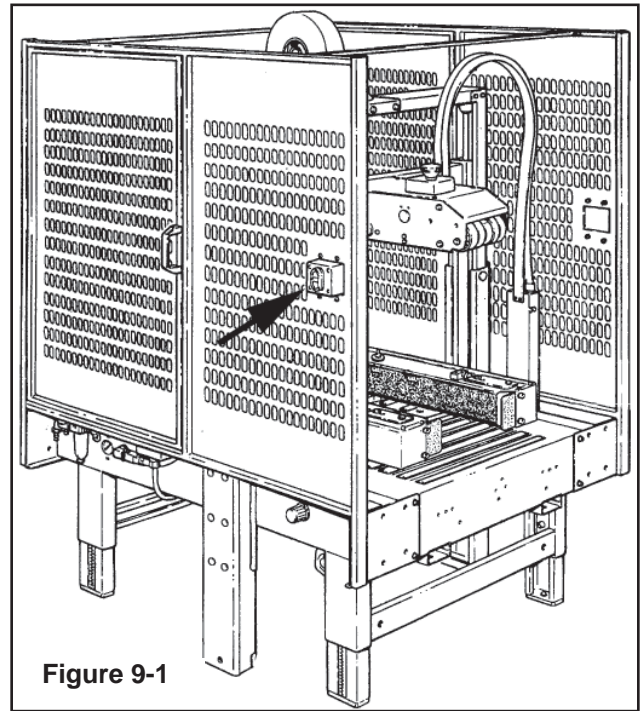


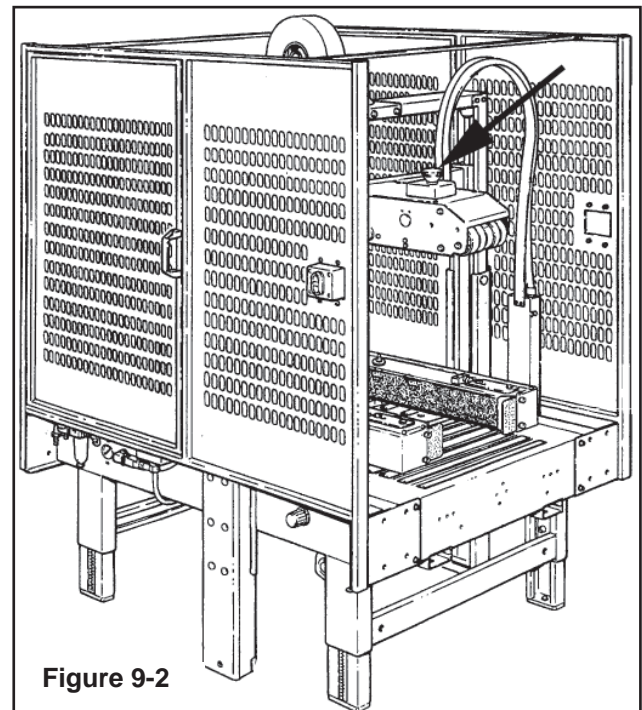
Figure 8-3

9-CONTROLS

9.1 Start/Stop Buttons



9.2 Lockable Emergency Stop Button



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 (**Figure 10-1**).

Restart machine by pushing the Start button (I).



WARNING

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

Figure 10-1

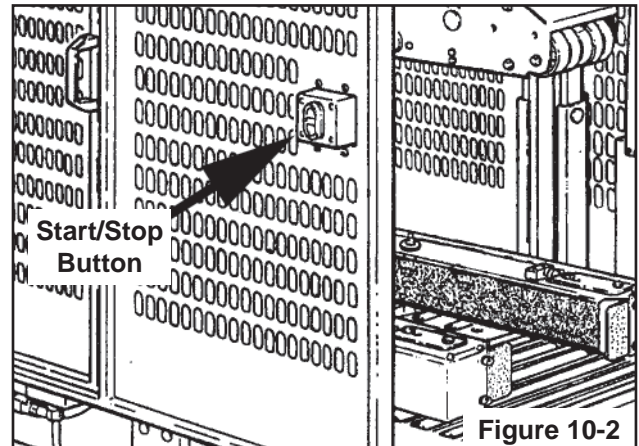
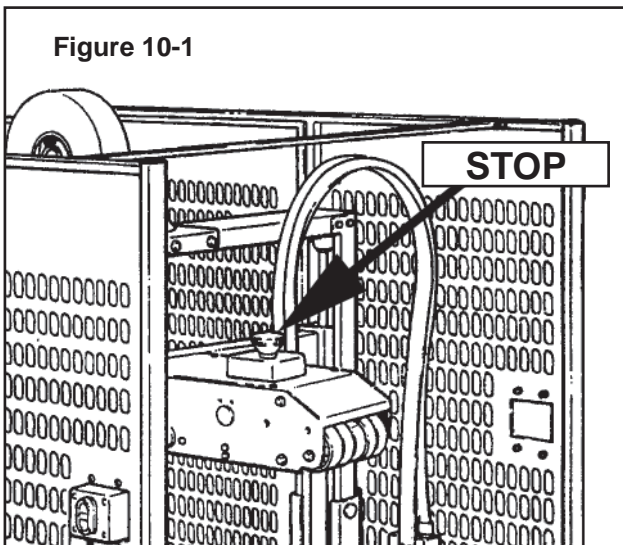


Figure 10-2

10.3 Electric System / Circuit Breaker

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

Circuit Breaker

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



WARNING

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

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

1. Determine cause of overload and correct.
2. Plug in machine.
3. Press machine "On" (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.



WARNING

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

11.1 Changing the Tape Leg Length
(From 70 to 50mm [2.75 to 2.00 in])

Changing tape leg length to 50mm [2 in] allows taping of smaller boxes. Refer to "Specifications – Box Weight and Size Capacities", for box sizes.

Taping Heads

Important! Turn off Electric Power.
Blades are SHARP!



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp
- **To reduce the risk associated with muscle strain:**
 - Use proper body mechanics when removing or installing drive assemblies or taping heads that are moderately heavy or may be considered awkward to lift

1. Remove upper taping head. Loosen and remove four (each) M6 x 25 flat head screws (A), special washers (B) and spacers (C) that fasten head to upper assembly as shown in **Figure 11-1**.

Note: Support or hold taping head to keep it from falling when screws are removed).

2. Turn air supply on and raise and latch upper assembly in full up position. Turn air supply off.



WARNING

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

3. Remove lower taping head by pulling straight up.

4. Refer to Manual 2 "Adjustments – Changing Tape Leg Length".

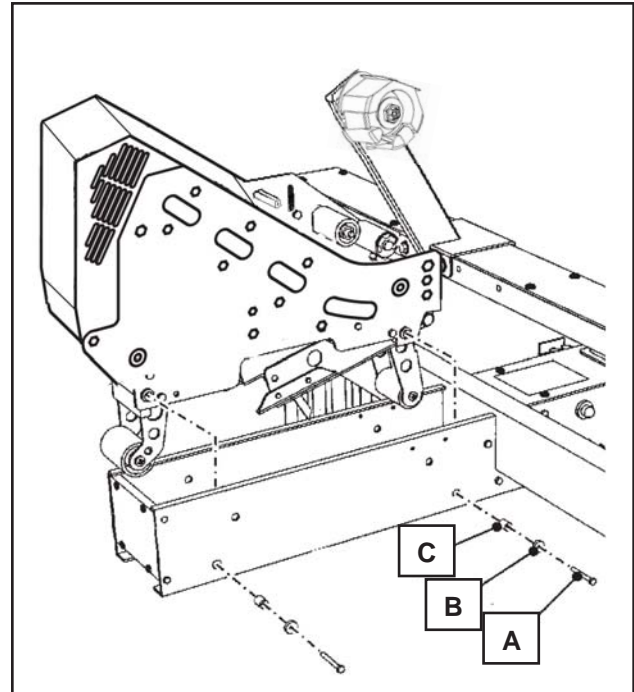


Figure 11-1 Upper Taping Head Mounting

11.2 Box Height Range



WARNING

- **To reduce the risk associated with muscle strain**
 - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment

Moving the outer columns to the upper set of mounting holes increases the maximum box size (height) handled by the case sealer from 533mm [21.00 in] to 644mm [25.38 in] (Dimensions given are with lift cylinders mounted in standard position) - See Specifications

Note – This also increases the minimum box height from 127mm [5.00 in] to 232mm [9.12 in].

Refer to **Figure 11-2**

1. With air on, raise and latch upper assembly in full raised position.
Be sure electrical supply is disconnected.
2. Place solid blocks 495 to 535mm [19.5 to 21.0 in] high under front and back of upper assembly as shown in **Figure 11-2A**.



WARNING

- **To reduce the risk associated with mechanical and electrical hazards:**
 - Turn electrical and air supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads
- **To reduce the risk associated with impact hazards:**
 - Always use appropriate supporting means when working under the upper drive assembly
- **To reduce the risk associated with muscle strain:**
 - Use proper body mechanics when removing or installing drive assemblies or taping heads that are moderately heavy or may be considered awkward to lift

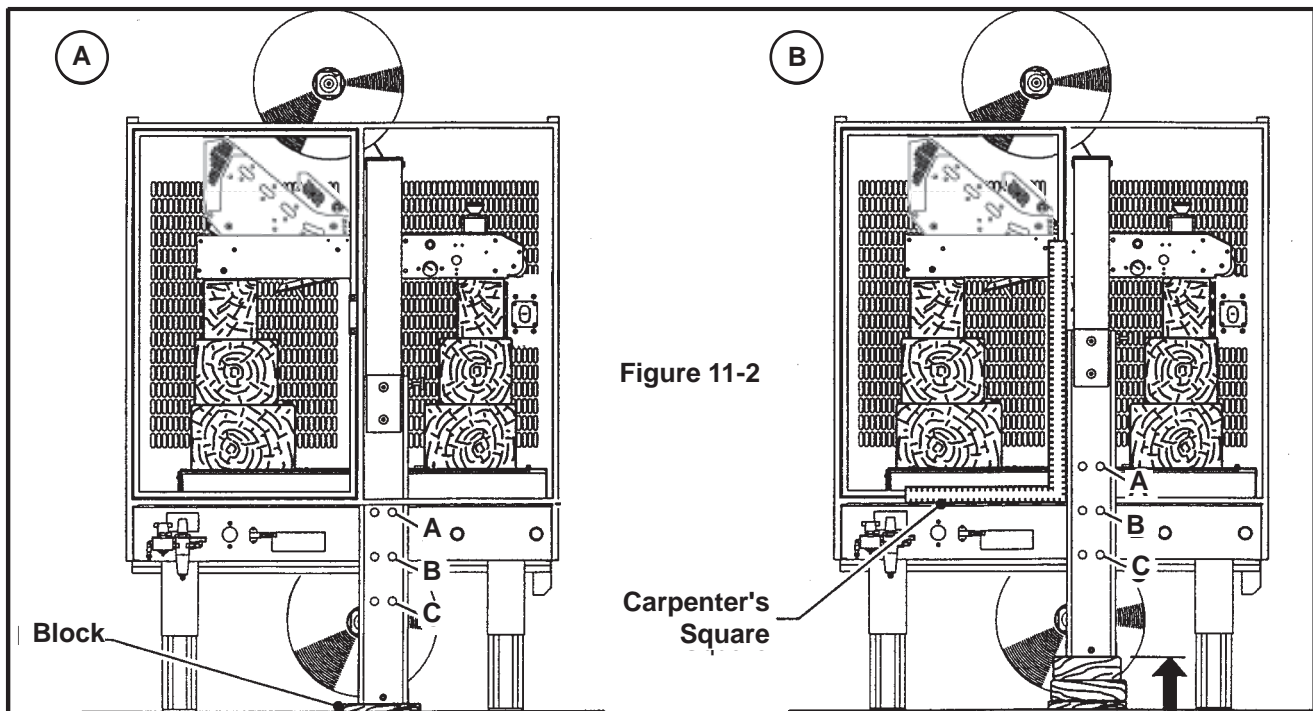


Figure 11-2

Figure 11-2 Box Height Range

3. Actuate raising switch to release upper assembly latch (Upper assembly will rest on blocks).
Turn off and disconnect air supply.
4. Remove plastic plugs and M8 x 20 socket head capscrews from (A) and (B) in one side column (4 each). Slide side column up approximately 110mm [4.25 in] and re-install capscrews in (B) and (C). **DO NOT TIGHTEN SCREWS.**
Repeat procedure for other side column.
5. Using carpenter's square, line up column perpendicular to machine bed as shown in **Figure 11-2B**. Tighten capscrews and install plastic plugs. Repeat this procedure for both columns.
6. Connect and turn on air supply, actuate raising switch and latch upper assembly in full up position.
7. Remove blocking, unlatch and lower upper assembly.

12-OPERATION

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

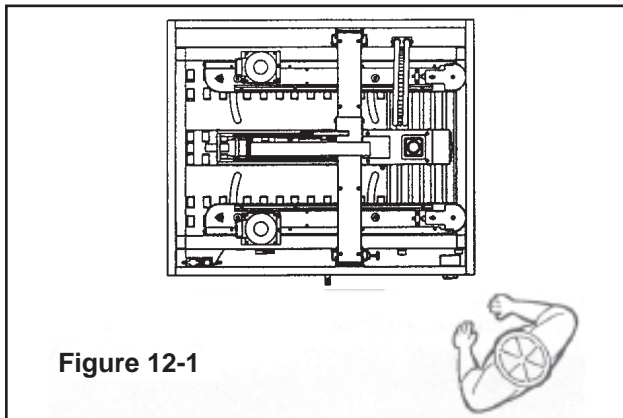


Figure 12-1

Once the box has been filled, close its top flaps and push it between the top and bottom drive belts. Always keep hands in position as shown in **Figure 12-2**.

Hand Position



Figure 12-2

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

12.2 Starting the Machine

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

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

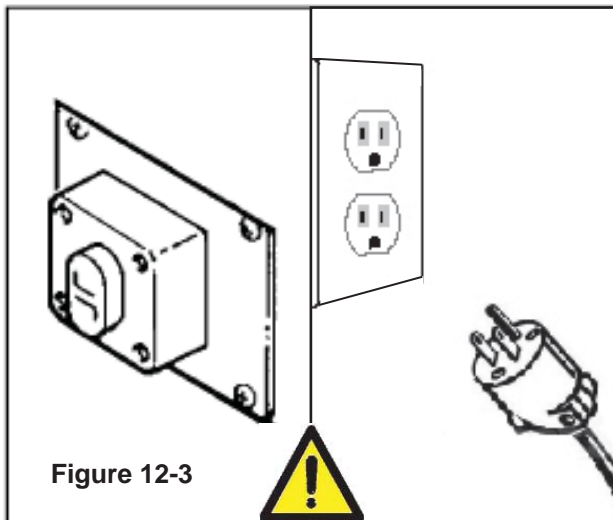


Figure 12-3

12.3 Starting Production

Let the machine run without cartons and check its safety devices. Then start the working cycle.

12.4 Tape Replacement and Threading

Skill 1 - Operator

See Manual 2:

AccuGlide™ 3 Taping Heads - 2 inch.

Press the
LATCHING EMERGENCY STOP BUTTON.



WARNING

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

12.5 Box Size Adjustment

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

12.6 Cleaning

Before carrying out any cleaning or maintenance operation, stop the machine by turning the OFF (O) switch on the main and disconnect the electric power (**Figure 12-3**).

12.7 Table of Operation Adjustments - Operator Qualifications

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

12.8 Safety Devices Inspection

- 1 Taping units blade guard
- 2 Latching emergency stop button
- 3 STOP (OFF) (O) main switch

Troubleshooting

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

Troubleshooting Guide

Problem	Cause	Correction
Drive belts do not convey boxes	Narrow boxes	Check machine specifications. Boxes are narrower than recommended, causing slippage and premature belt wear.
	Worn drive belts	Replace drive belts
	Top taping head does not apply enough pressure	Adjust the upper drive assembly force adjust regulator to increase the force against the top of the box. Turn air regulator counterclockwise.
	Taping head applying spring holder missing	Replace spring holder
Drive belts do not turn	Taping head applying spring set too high	Reduce spring pressure
	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
Drive belts break	Worn belt	Replace belt
Squeaking noise as boxes pass through machine	Dry compression rollers	Lubricate compression rollers
	Dry column bearings	Lubricate column bearings
	Defective column bearings	Replace column bearings
Tape not centered on box seam	Tape drum not centered	Reposition tape drum
	Drive belts not centered	Adjust centering guides
	Box flaps not of equal length	Check box specifications

(continued)

Troubleshooting (continued)

Troubleshooting Guide

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

13-MAINTENANCE AND REPAIRS

13.1 Safety Measures (see section 3)

Carrying out maintenance and repairs may imply the necessity to work in dangerous situations.

13.2 Tools and Spare Parts Supplied with the Machine

See Spare Parts Order Section.

13.3 Recommended Frequency of Inspection and Maintenance Operations

Operation	Frequency	Qualification	Sections
Inspection safety features	daily	1	13.4
Cleaning of machine	weekly	1	13.5
Cleaning of cutter blade	weekly	2	13.6
Oiling of felt pad	weekly	2	13.7
Lubrication	monthly	2	13.7-13.8
Blade replacement	when worn	2	See Manual 2
Drive belt replacement	when worn	2	13.10

13.4 Inspections to be Performed Before and After Every Maintenance Operation

Before every maintenance operation, Push the main switch OFF (O) and disconnect. During the maintenance operation, only properly trained and qualified personnel must work on the machine. At the end of every maintenance operation check the safety devices.

13.5 Check Efficiency of Safety Features

1. Blade guard assembly upper taping head
2. Blade guard assembly lower taping head
3. Latching Emergency stop button with mechanical lock (interrupt supply of electrical power)
4. Push the main switch STOP/OFF (O)
5. Safety guards top drive belts

13.6 Cleaning of Machine

Qualification 1

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

13.7 Cleaning of Cutter Blade

Qualification 2

Should tape adhesive buildup occur, carefully wipe clean with oily cloth or brush. Oil prevents the build-up of tape adhesive.

(See Manual 2.)



WARNING

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



WARNING

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

13.8 Drive Belt Replacement

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

Replacement - See Steps 1 thru 8

Tension Adjustment - See Steps 3, 7 and 9.

1. Crank the upper taping head to its fully raised position.
2. Remove and retain the three (3) screws (A), three (3) washers (B) and side cover (C). **See Figure 13-1.**
3. Remove and retain the screw (D), washer (E) and belt tensioner cover (F).
4. Turn belt adjustment screws (G) counterclockwise on both the upper and lower tension assemblies until belt is loose. **See Figure 13-2.**
5. Locate the belt lacing (joint) by turning the belt manually. Remove the pin with pliers. Remove and discard old belt.



WARNING

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

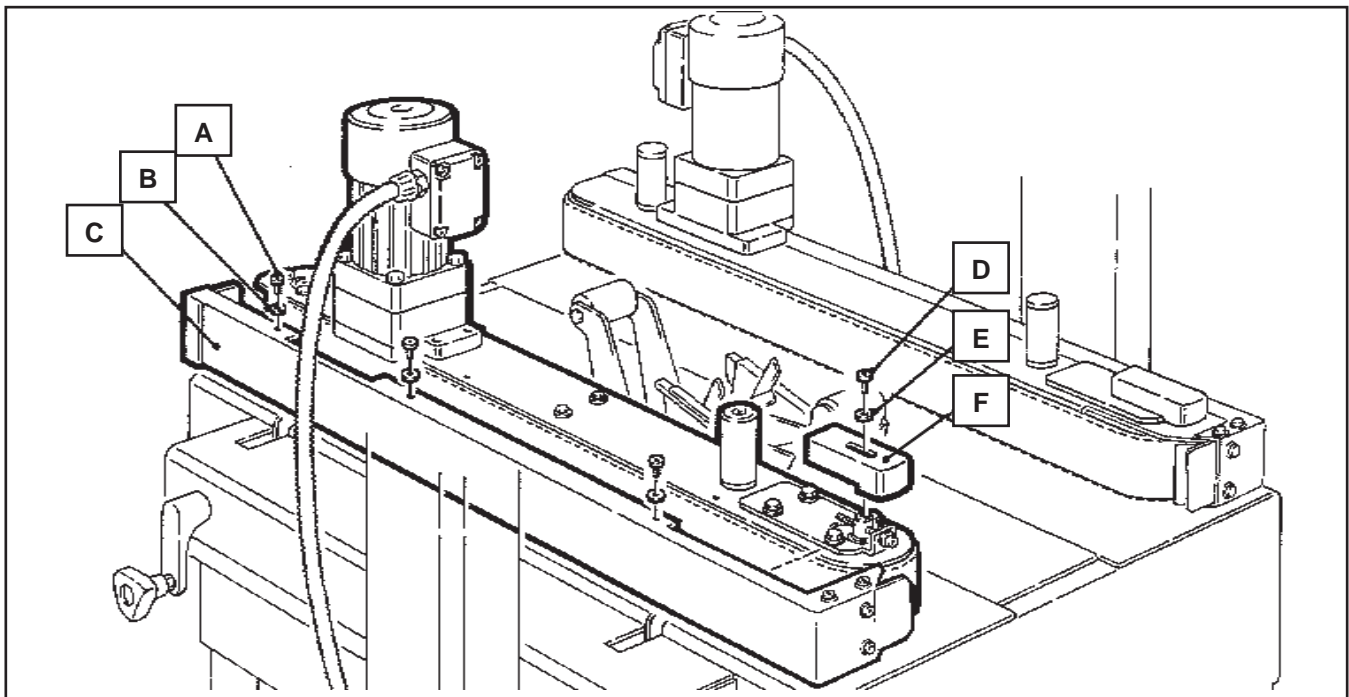


Figure 13-1 Box Drive Belt (Left Side View – Infeed End)



WARNING

- To reduce the risk associated with pinch, entanglement and hazardous voltage:
 - Turn electrical and air supplies off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads

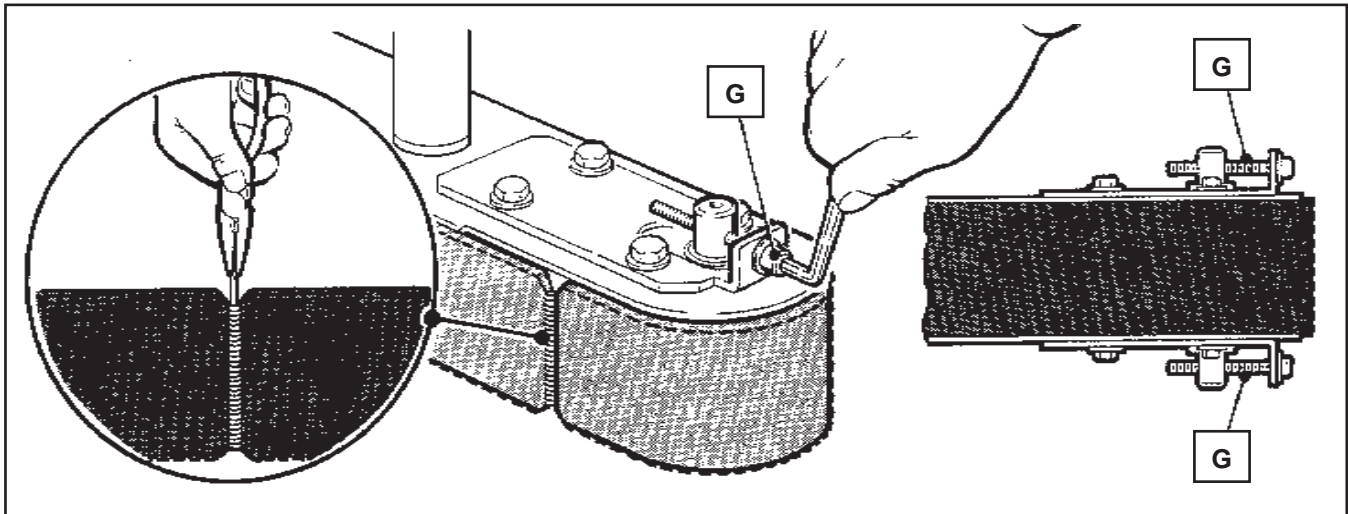


Figure 13-2 Box Drive Assembly, Infeed End

6. Install the new belt around drive rollers and insert new pin. Pin must not extend beyond edge of belt.
7. To set drive belt tension, turn adjustment screws (G) equally on both the upper and lower tension assemblies. Turn the screws clockwise to increase tension or counterclockwise to decrease tension. **See Figure 13-2.**
Use a force gauge to pull the belt outward 25mm [1 inch] at mid-span, as shown with a moderate pulling force of 3.5 kg [7 lbs].
8. Reverse procedures in Steps 1-3 (**Figure 13-1**) to reassemble the drive belt assembly.

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

13.9 Drive Pulley Rings

Before installing a new belt, check the orange plastic drive pulley rings for wear. If torn, broken, or worn smooth, replace the rings (**Figure 13-3**).

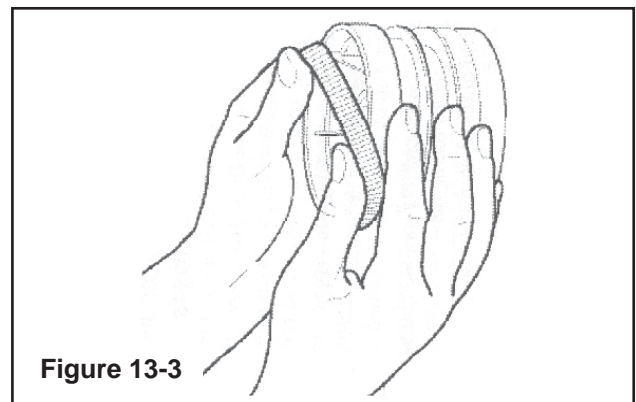
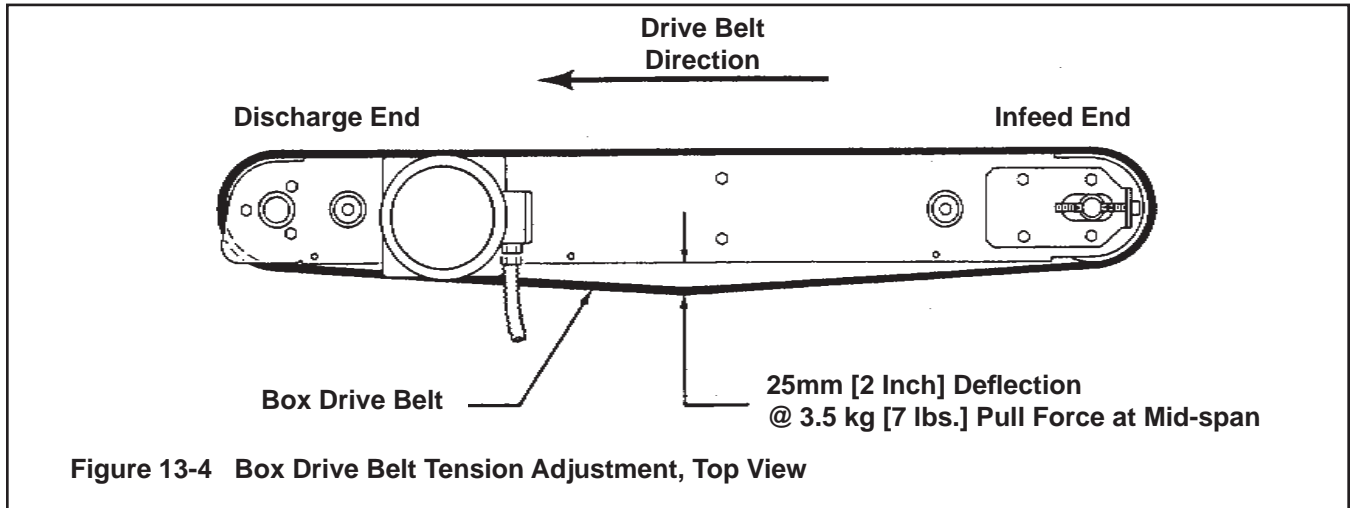


Figure 13-3



 **WARNING**

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

13.10 Drive Belt Tension

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

Belt tension is obtained by tightening the adjustment screw so that a moderate pulling force of 3.5 kg [7 lbs] applied at the mid span, as shown in **Figure 13-4**, will deflect the belt 25mm [1 inch]. This will assure positive contact between the belt and the drive pulley on the discharge end of the taping head.

To adjust belts, see "Maintenance – Drive Belts", steps 3 and 7.

13.11 Special Setup Procedure

 **WARNING**

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

The following changes to the case sealer will allow taping boxes 90mm [3-1/2 inches] minimum height.

13.11.1 Case Sealer Frame
(Refer to **Figure 13-5A**)

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

13.11.2 Taping Heads
(Refer to Figure 13-5A and Figure 13-5B)

Taping Head Adjustments



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.

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

Leading Tape Leg Length Adjustment – Manual 2

Changing Tape Leg Length from 70 to 48mm [2-3/4 to 2 inches] – Manual 2

Note – Changing tape leg to 48mm [2 inches] requires machine adjustment also.
See Manual 2 "Special Setup Procedure – Changing Tape Leg Length".

1. Loosen, but do not remove, the two (2) retaining screws that secure the upper taping head shown - **Figure 13-5A**.

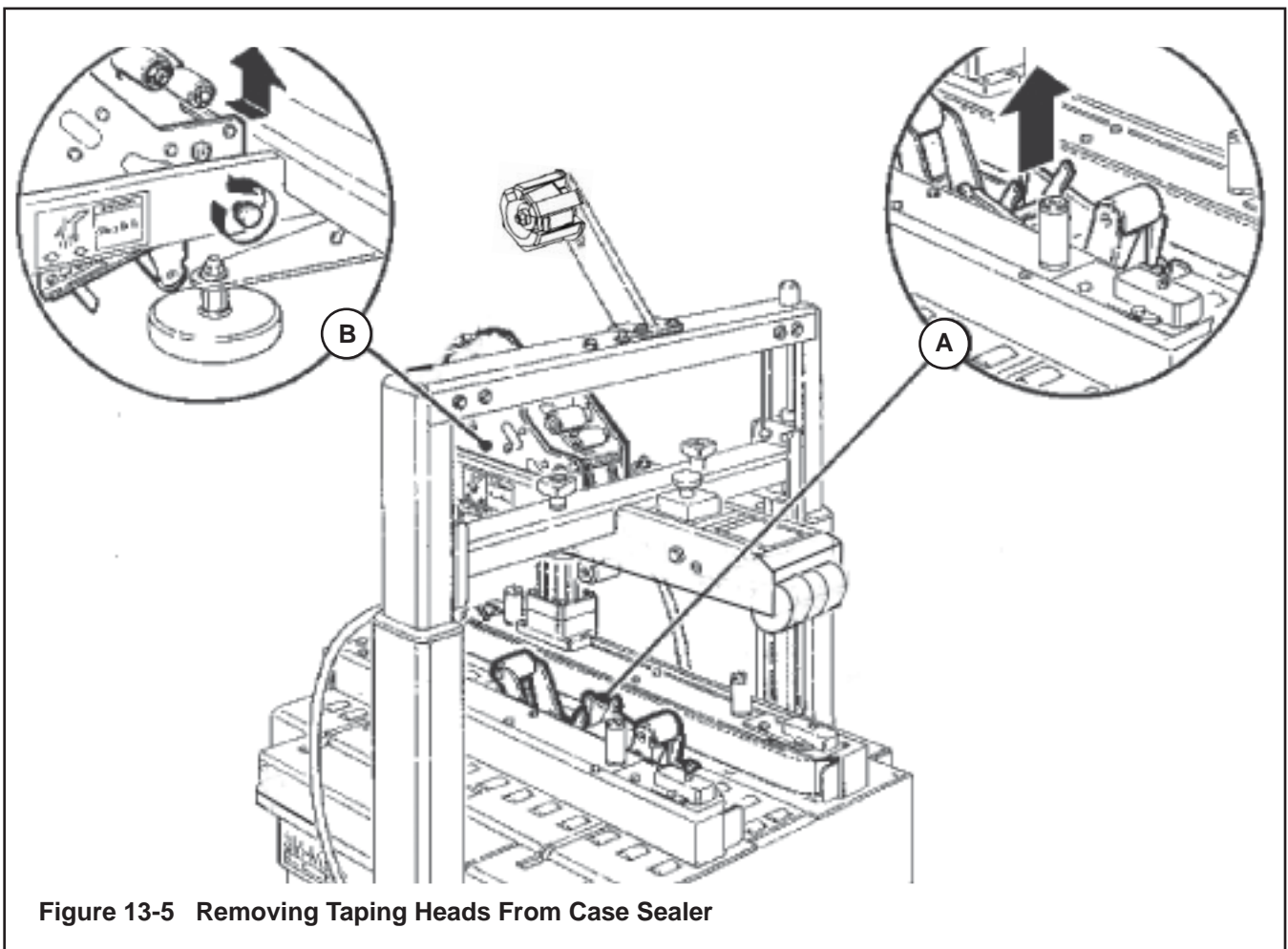


Figure 13-5 Removing Taping Heads From Case Sealer

13.11.2 Special Setup Procedure (continued)



WARNING

- 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

2. Slide the head forward and lift straight up to remove it from the case sealer.
3. Lift the lower taping head, shown in **Figure 13-5A**, straight up to remove it from the case sealer bed.
4. Refer to Manual 2 (Taping Head), See "Adjustments – Changing Tape Leg Length" for taping head setup.

13.11.3 Drive Belt Assembly Height

The drive belt assemblies can be raised 48mm [2 inches] to provide better conveying of tall boxes. This change increases the minimum box height that can be taped to 190mm [7-1/4 inches].

Disassemble – Figure 13-6

1. It is first necessary to raise the top taping head. Utilize the height adjustment crank and move the upper taping head to the fully raised position.
2. Remove and retain the screw (A), cap washer (B) and spacer (C) from the front and rear arm assembly pivots.
3. Lift belt drive assembly (D) up off the arm assembly pivots.

Reassemble – Figure 13-7

4. Reassemble the spacer (C) onto the front and rear arm assembly pivots.
5. Install the belt drive assembly (D) onto the pivots and secure with the cap washers (B) and screws (A).

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

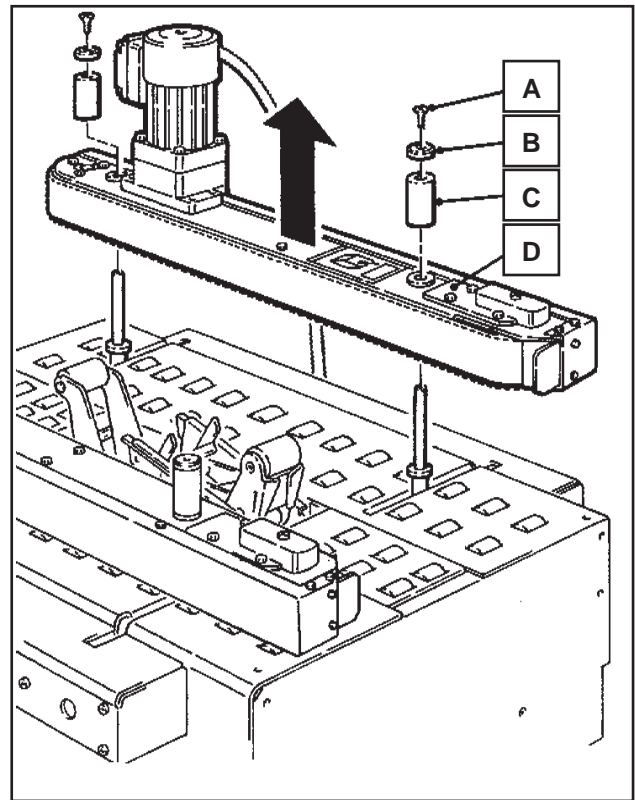


Figure 13-6 Drive Belt Assembly, Disassembly

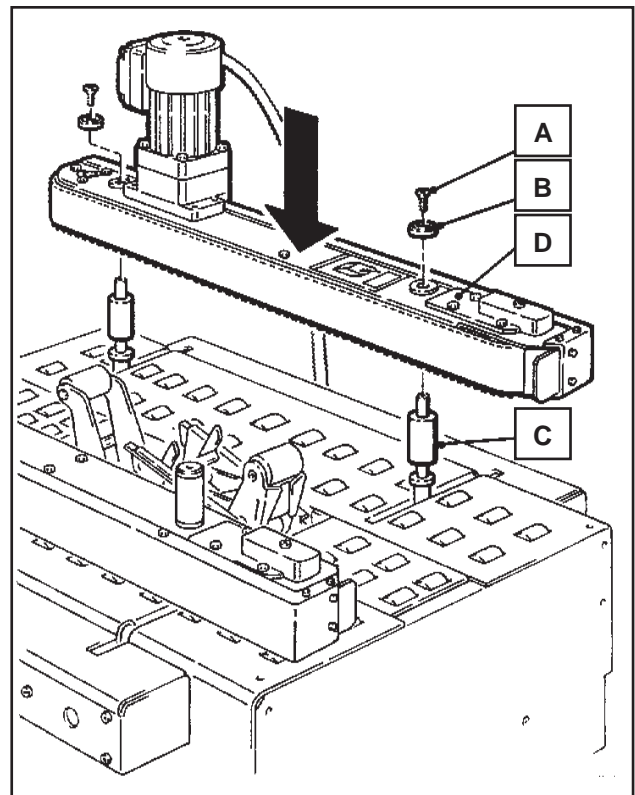


Figure 13-7 Drive Belt Assembly, Reassembly

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14-ADDITIONAL INSTRUCTIONS

14.1 Information for Disposal of Machine

The machine is composed of the following materials:

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

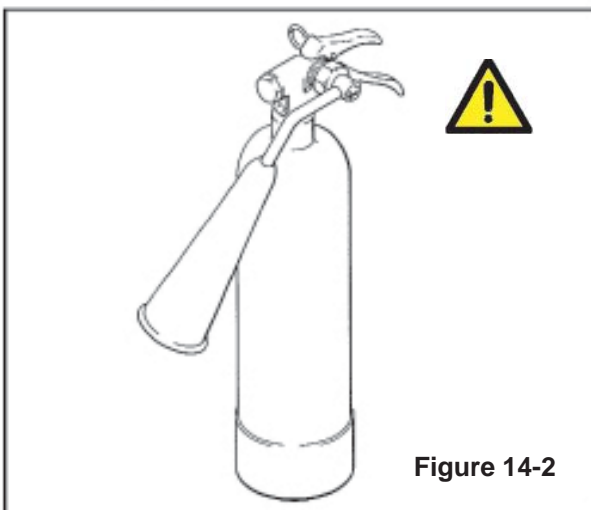
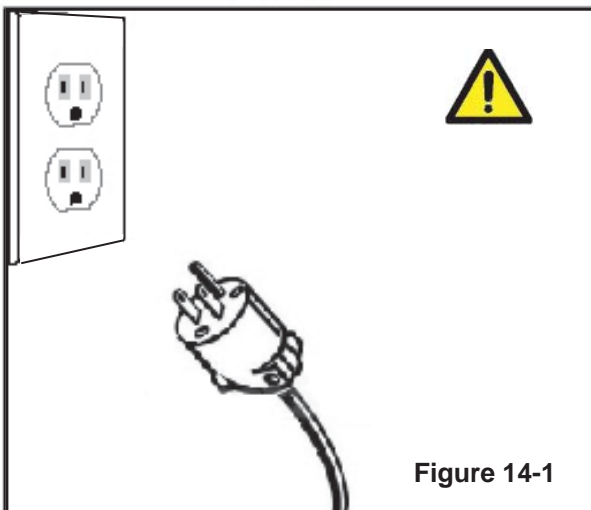
For machine disposal, follow the regulations published in each country.

14.2 Emergency Procedures

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

IN CASE OF FIRE

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



15-ENCLOSURES / SPECIAL INFO.

15.1 Statement of Conformity

See Section 1.1.

15.2 Emission of Hazardous Substances

Nothing to report

15.3 List of Safety Features

List of components/assemblies with safety functions

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

Important: Install earth wire protection on electrical installation.

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

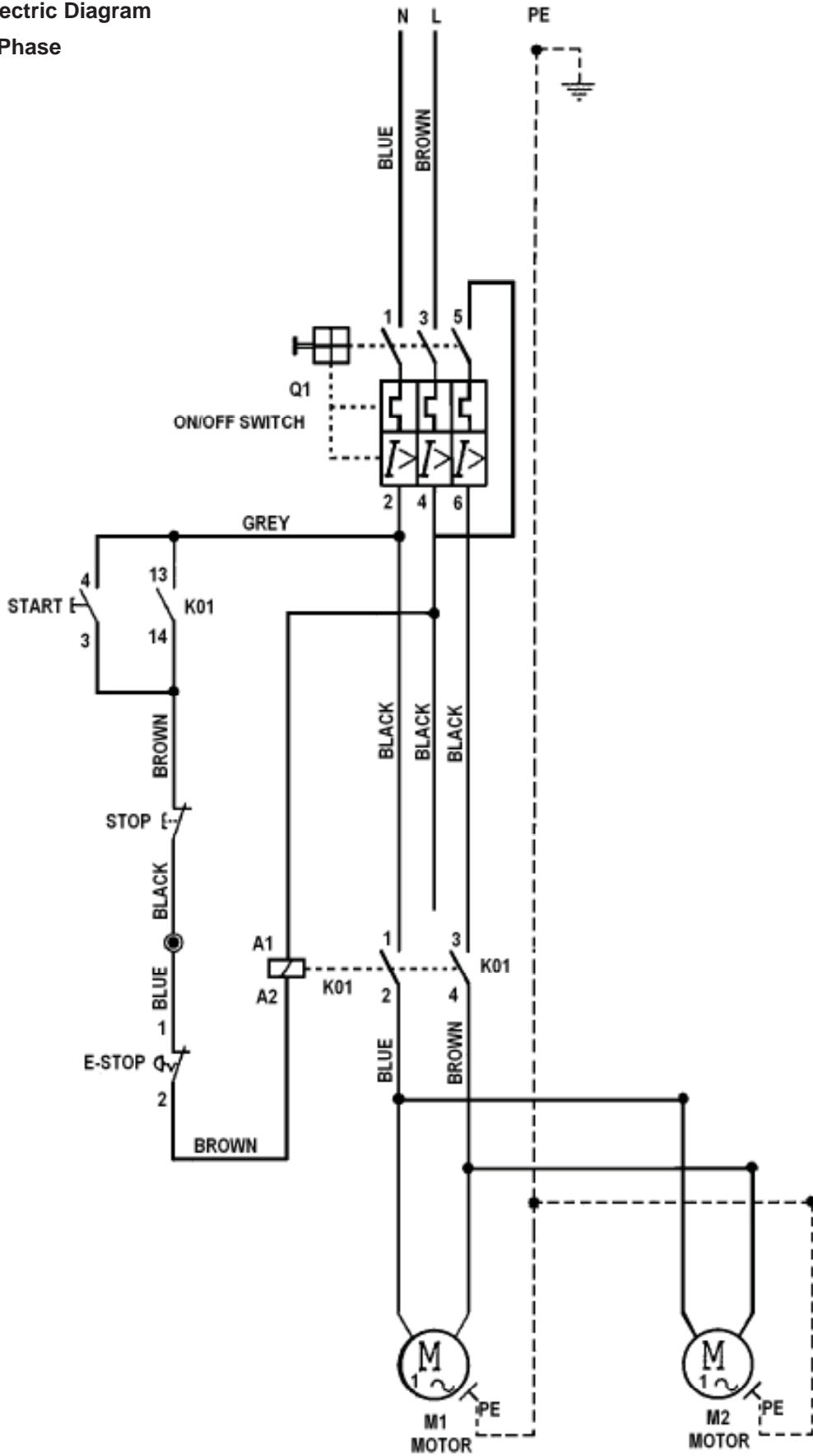
ONLY USE ORIGINAL REPLACEMENT PARTS

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

NA

16-TECHNICAL DIAGRAMS

16.1 Electric Diagram 1 Phase

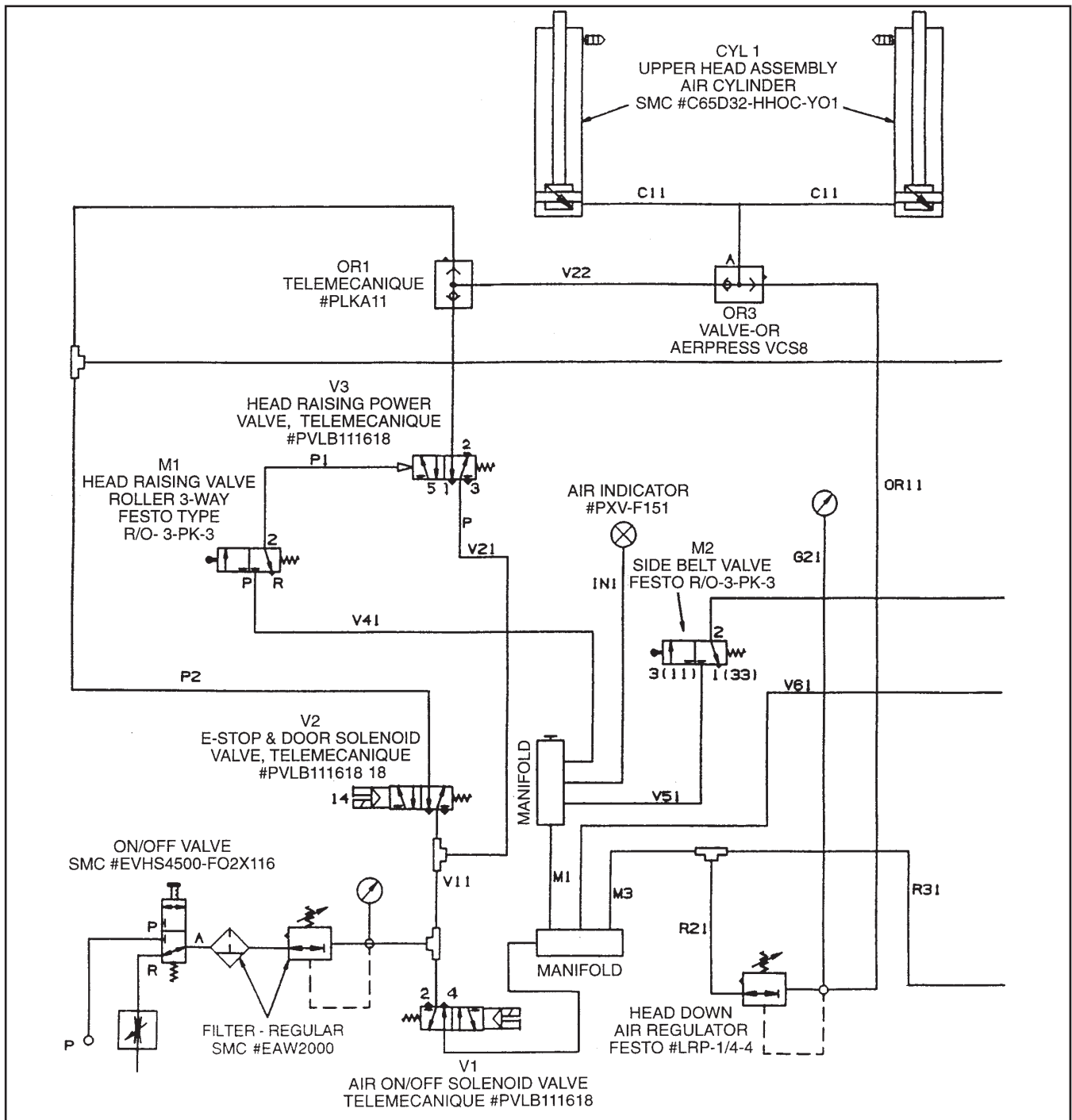




WARNING

- To reduce the risk associated with mechanical and electrical hazards:
- Turn electrical and air supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads
- Allow only properly trained and qualified personnel to operate and/or service this equipment

Figure 16-2 Pneumatic Diagram



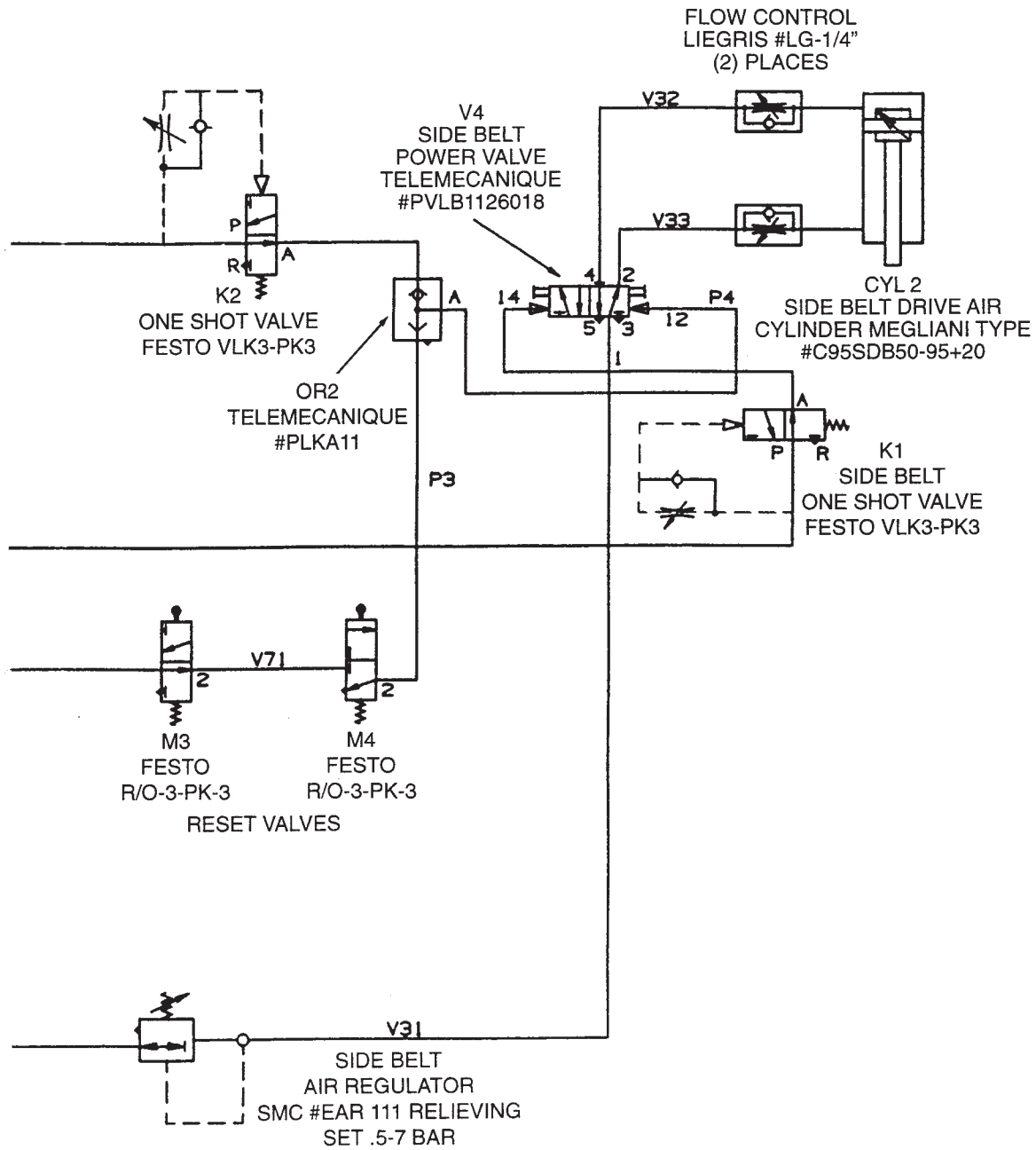


Figure 16-2 Pneumatic Diagram

16.2 Spare Parts Order

Replacement Parts Ordering Information and Service

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

Order parts by quoting the following information:

(Refer to the Identification Plate on the Machine)

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

Refer to Manual 2 for recommended taping head spare parts.

Important!

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

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

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

800r

Qty.	3M-Part Number	Description
2	78-8076-5452-6	Belt-Drive W/Hook

Tool 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.

Labels

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

800r

To Order Parts:

1. Refer to first illustration, **Frame Assemblies**, for the **Figure Number** that identifies a specific portion of the machine.
2. Refer to the appropriate **Figure or Figures** to determine the parts required and the parts reference number.
3. The Parts List that follows each illustration, includes the **Reference Number, Part Number** and **Part Description** for the parts on that illustration.

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

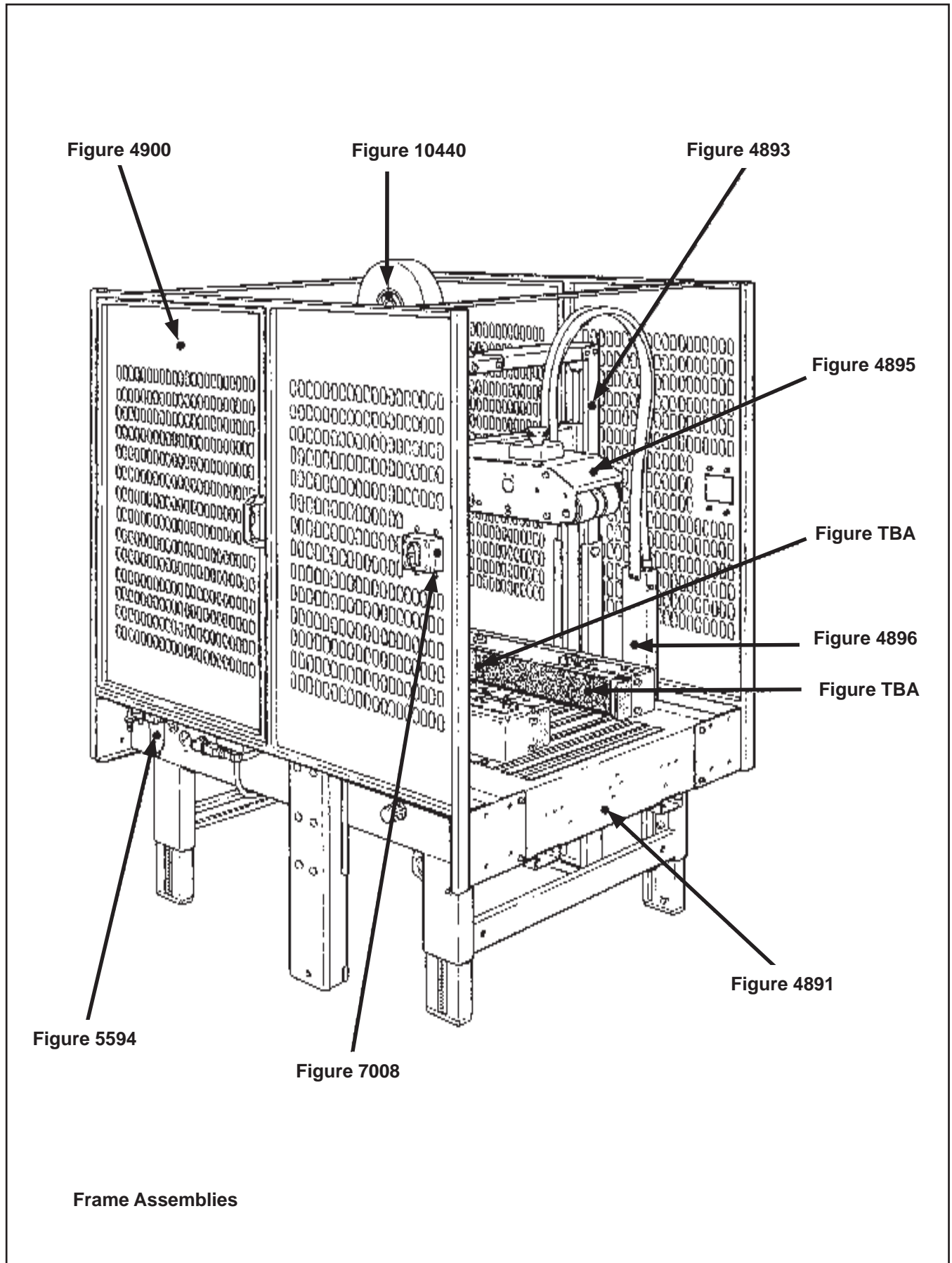
4. Order parts by Part Number, Part Description and Quantity required. Also include the model/machine name, machine type, and serial number that are located on the identification plate.
5. Refer to the first page of this instruction manual “**Replacement Parts and Service Information**” for replacement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

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

Options and Accessories

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

Part Number	Option/Accessory
78-8095-4862-7	Infeed/Exit Conveyor 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
78-8069-3983-7	Caster Kit



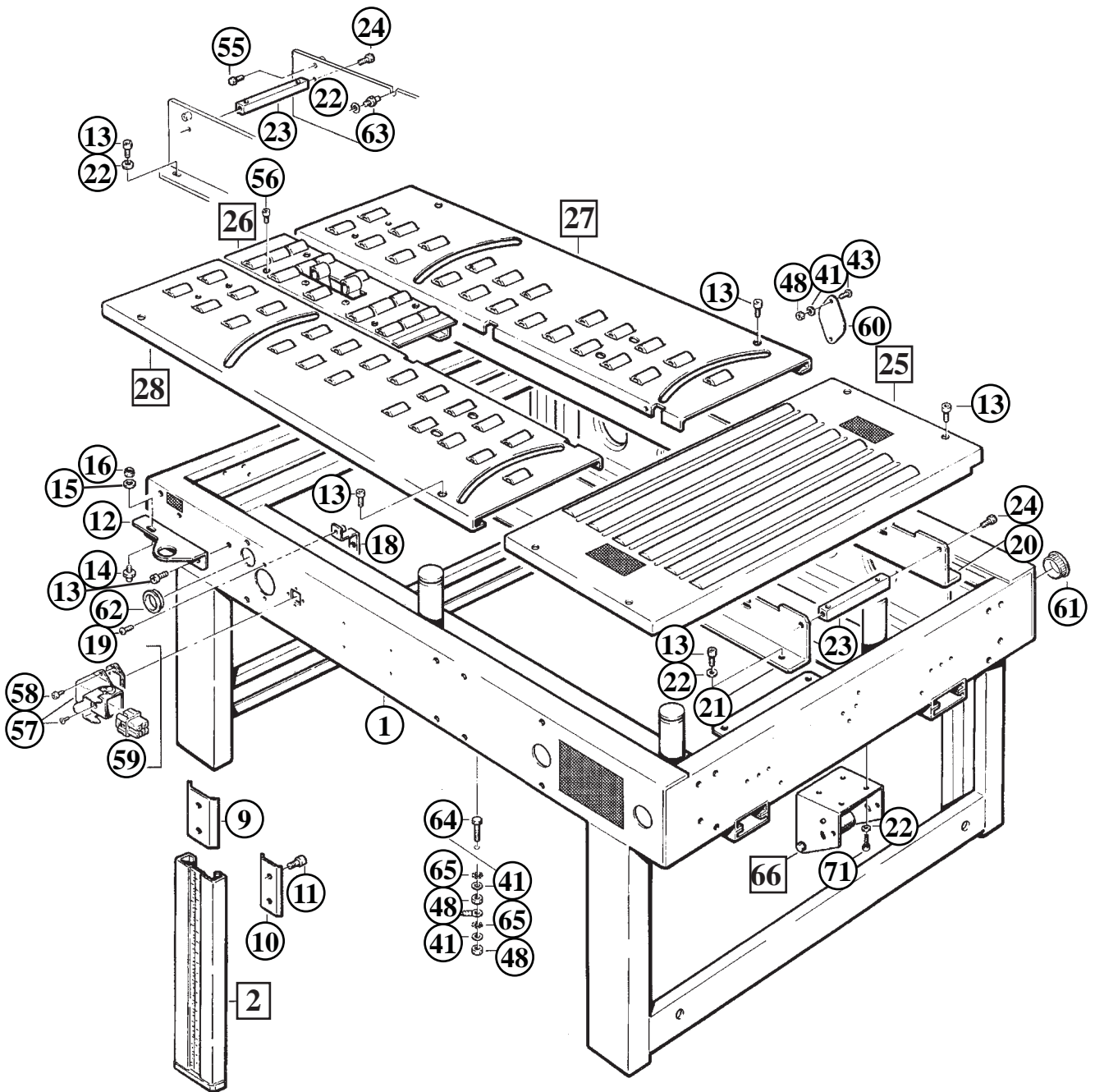


Figure 4891 / 1

Figure 4891 / 1

Ref. No.	3M Part No.	Description
4891-1	78-8113-6827-9	Bed Assembly – Conveyor, W/English Language Label
4891-2	78-8094-6486-6	Leg Assembly – Inner
4891-3	78-8100-1246-4	Leg – Inner
4891-4	78-8060-8480-8	Pad – Foot
4891-5	78-8055-0867-4	Screw – Hex Hd, M8 x 30
4891-6	26-1004-5507-5	Washer – M8
4891-7	78-8017-9313-0	Nut – Self-Locking, M8
4891-8	78-8094-6487-4	Label – Leg
4891-9	78-8052-6677-8	Clamp – Inner
4891-10	78-8052-6676-0	Clamp – Outer
4891-11	26-1003-7963-0	Screw – Soc Hd, M8 x 16
4891-12	78-8094-6392-6	Bracket
4891-13	78-8010-7209-7	Screw – Soc Hd, M6 x 12
4891-14	78-8091-0613-7	Shaft – Valve
4891-15	78-8042-2919-9	Washer – Triple, M6
4891-16	26-1003-6916-9	Nut – Locking Plastic Insert, M6
4891-18	78-8076-4535-9	Bracket
4891-19	78-8076-4625-8	Screw – Special, M5 x 16
4891-20	78-8094-6393-4	Frame – BTM, R/H
4891-21	78-8094-6394-2	Frame – BTM, L/H
4891-22	26-1000-0010-3	Washer – Flat, M6
4891-23	78-8060-7955-0	Spacer – Center Frame
4891-24	78-8010-7169-3	Screw – Hex Hd, M6 x 12
4891-25	78-8094-6395-9	Conveyor Assembly – Front
4891-26	78-8094-6396-7	Conveyor Assembly – Rear
4891-27	78-8094-6397-5	Conveyor Assembly – R/H
4891-28	78-8094-6398-3	Conveyor Assembly – L/H
4891-29	78-8113-6826-1	Conveyor – Front, W/English Language Label
4891-30	78-8094-6400-7	Conveyor – Rear
4891-31	78-8094-6401-5	Conveyor – R/H
4891-32	78-8094-6402-3	Conveyor – L/H
4891-33	78-8094-6403-1	Shaft – Roller
4891-34	78-8059-5596-6	Roller
4891-35	78-8052-6694-3	Shaft – /8 x 128
4891-36	78-8060-7693-7	Roller – 32 x 38
4891-37	78-8060-7965-9	Shaft – Hex Hd, /8 x 120
4891-38	78-8054-8857-0	Shaft – 8 x 43mm

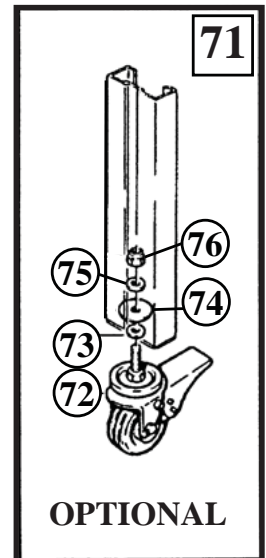
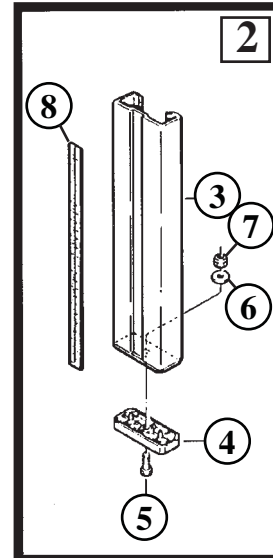
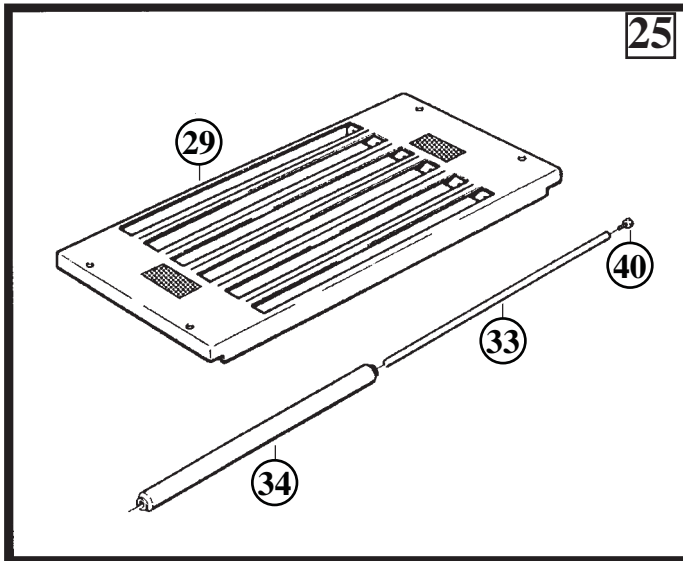
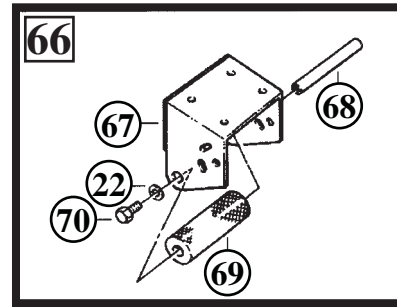
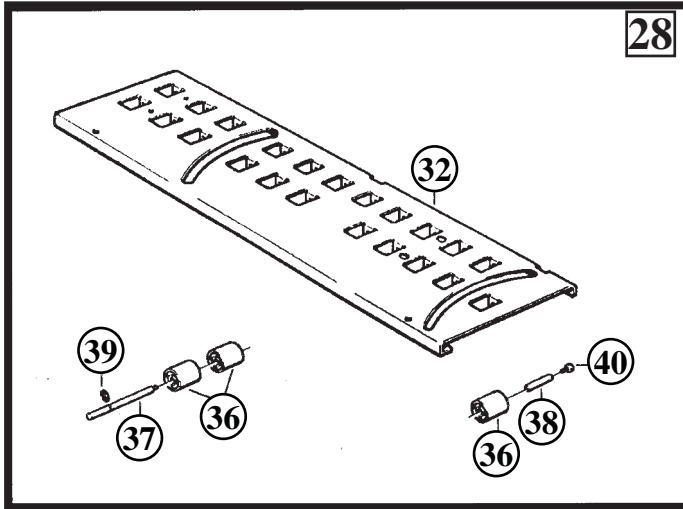
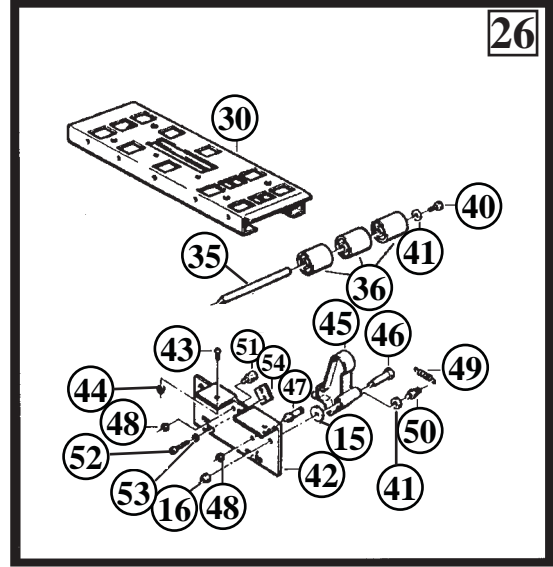
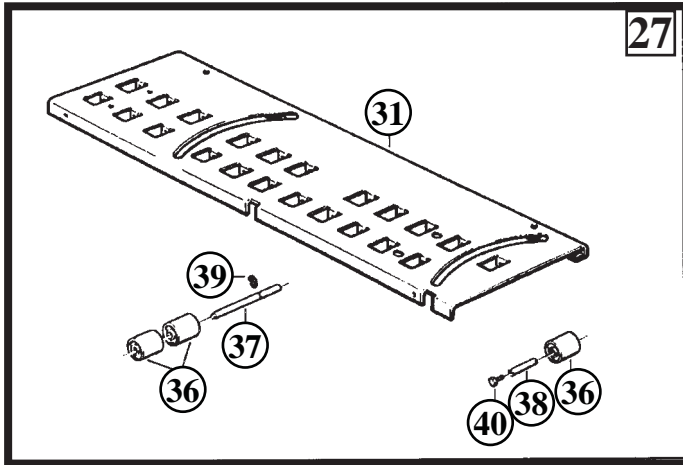


Figure 4891 / 2

Figure 4891 / 2

Ref. No.	3M Part No.	Description
4891-39	78-8060-8035-0	E-Ring – 7DIN6799
4891-40	78-8010-7163-6	Screw – Hex Hd, M5 x 10
4891-41	78-8005-5741-1	Washer – Plain, M5
4891-42	78-8060-8086-3	Support – Valve
4891-43	78-8060-8087-1	Screw – M5 x 10
4891-44	26-1005-6859-6	Nut – Self-Locking, M5
4891-45	78-8060-7775-2	Cam – Rear
4891-46	78-8060-8088-9	Shaft – Cam
4891-47	78-8054-8757-2	Pin – Spring Holder
4891-48	78-8010-7417-6	Nut – Hex, M5
4891-49	78-8094-6404-9	Spring
4891-50	78-8060-7777-8	Spring – Tensioner
4891-51	78-8060-8080-6	Guard – Stop
4891-52	26-1003-7946-5	Screw – Soc Hd, M4 x 25
4891-53	78-8017-9018-5	Washer – Plain, SPEC, M4
4891-54	78-8059-5607-1	Plate – Threaded
4891-55	26-1003-5829-5	Screw – Hex Hd, M6 x 12
4891-56	26-1003-7948-1	Screw – Soc Hd, Hex Soc, M5 x 10
4891-57	78-8060-7876-8	Cover Plug – Lateral
4891-58	78-8028-8208-0	Screw – 6PX9,5
4891-59	78-8060-7873-5	Plug – Female
4891-60	78-8094-6305-8	Plate – Gauge
4891-61	78-8094-6177-1	Cap
4891-62	78-8094-6489-0	Snap Bushing
4891-63	78-8070-1456-4	Stud – Hex
4891-64	78-8060-8488-1	Screw – Hex Hd, M5 x 20
4891-65	78-8046-8217-3	Washer – Special
4891-66	78-8076-5392-4	Support – Tape Drum
4891-67	78-8060-8483-2	Support – Outboard Roll Mount
4891-68	78-8060-8484-0	Shaft – Roller
4891-69	78-8060-8485-7	Roller
4891-70	78-8032-0375-7	Screw – Hex Hd, M6 x 16
4891-71	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
4891-72	78-8060-8060-8	Caster Assy/80
4891-73	78-8060-8061-6	Caster /80
4891-74	78-8060-8124-2	Spacer – Caster
4891-75	78-8060-7699-4	Washer /12-45 5x4
4891-76	78-8017-9059-9	Washer – Flat for M12 Screw
4891-77	78-8060-7532-7	Nut M12 Self-locking

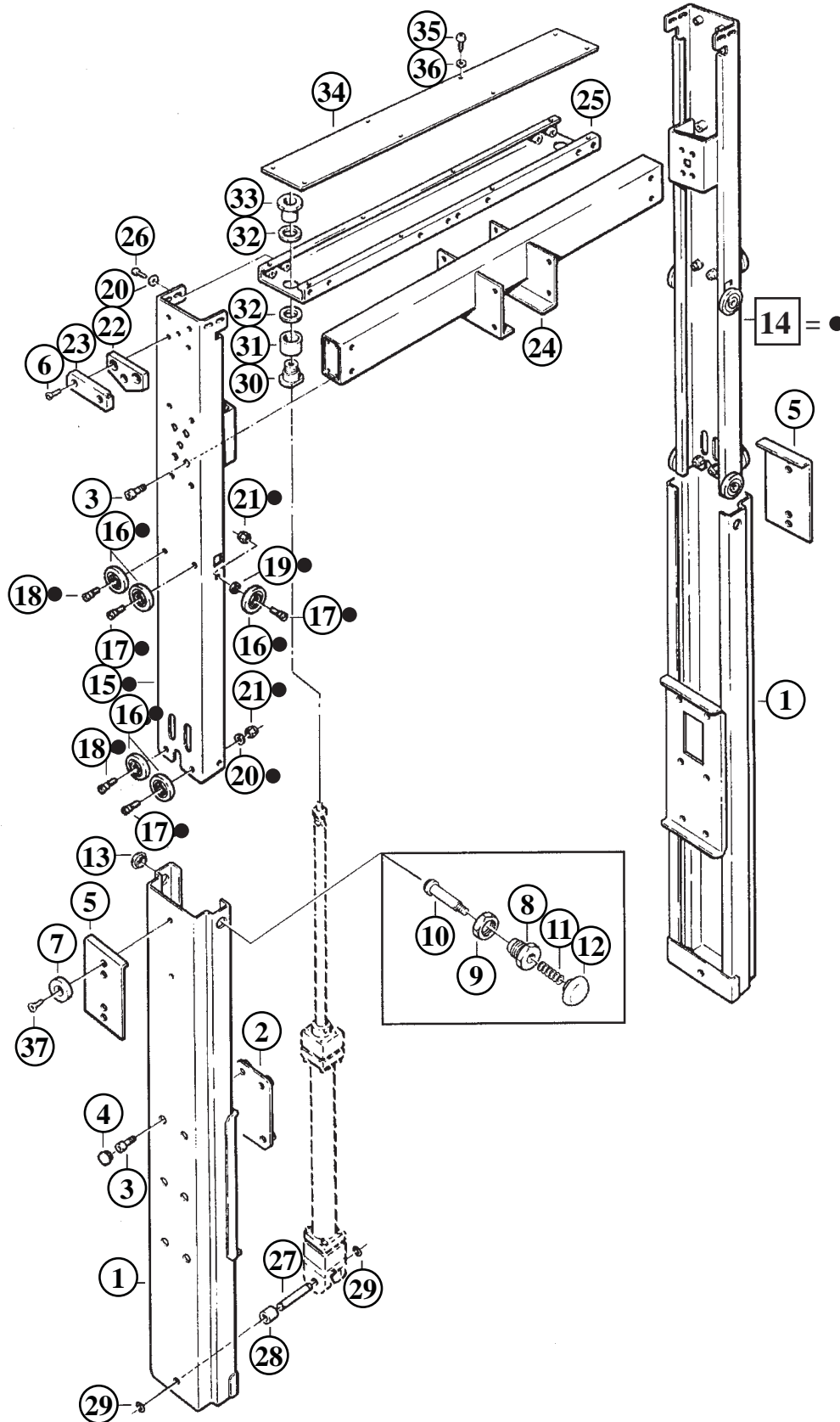


Figure 4893

Figure 4893

Ref. No.	3M Part No.	Description
4893-1	78-8094-6408-0	Column Assembly – Outer
4893-2	78-8076-5474-0	Plate Assembly – Column Mount
4893-3	26-1003-7964-8	Screw – Soc Hd, Hex Soc Dr, M8 x 20
4893-4	78-8054-8821-6	End – Cap
4893-5	78-8091-0621-0	Plate – Outer Column
4893-6	78-8060-7918-8	Screw – Flat, Soc Hd, M6 x 25
4893-7	78-8054-8577-4	Washer – Special
4893-8	78-8091-0615-2	Bushing – Stop
4893-9	78-8017-9169-6	Nut – M18 x 1
4893-10	78-8076-4544-1	Stud – Height Stop
4893-11	78-8076-4545-8	Spring
4893-12	78-8100-0954-4	Knob
4893-13	78-8076-4547-4	Cap – /18
4893-14	78-8094-6410-6	Column Assembly – Inner
4893-15	78-8094-6411-4	Column – Inner
4893-16	78-8054-8617-8	Bearing – Special
4893-17	78-8017-9106-8	Screw – Bearing Shoulder
4893-18	78-8054-8589-9	Screw – Special
4893-19	78-8054-8576-6	Spacer
4893-20	26-1000-0010-3	Washer – Flat, M6
4893-21	26-1003-6916-9	Nut – Locking Plastic Insert, M6
4893-22	78-8060-7916-2	Bumper
4893-23	78-8091-0617-8	Plate – Support Bumper
4893-24	78-8094-6412-2	Bar
4893-25	78-8094-6413-0	Cross Member
4893-26	78-8032-0375-7	Screw – Hex Hd, M6 x 16
4893-27	78-8054-8966-9	Pin – Air Cylinder Clevis
4893-28	78-8054-8828-1	Spacer – 10,5/16X14, 5MM
4893-29	78-8060-8035-0	E-Ring – 7DIN6799
4893-30	78-8054-8824-0	Rod End
4893-31	78-8094-6416-3	Spacer
4893-32	78-8054-8823-2	Washer – Bumper
4893-33	78-8094-6417-1	Ring Nut
4893-34	78-8094-6418-9	Cover
4893-35	78-8076-5255-3	Screw – Phillips Hd, M4 x 12
4893-36	78-8005-5740-3	Washer – Plain, 4MM
4893-37	26-1001-9843-6	Screw – Flat, Soc Hd, M6 x 16

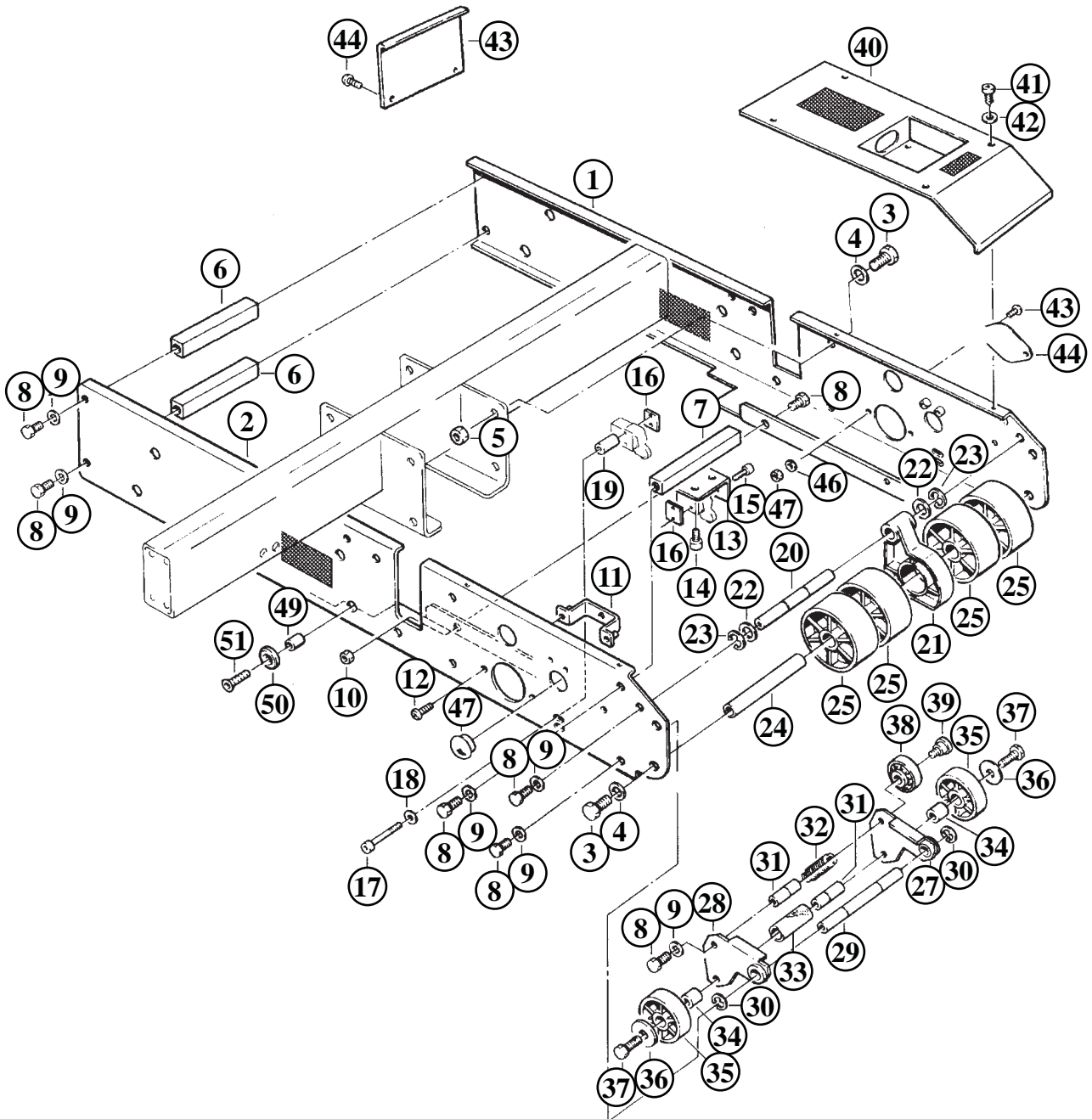


Figure 4895

Figure 4895

Ref. No.	3M Part No.	Description
4895-1	78-8113-6832-9	Frame Assembly – R/H, W/English Language Label
4895-2	78-8113-6830-3	Frame Assembly – L/H, W/English Language Label
4895-3	26-1003-5841-0	Screw – M8 x 16
4895-4	78-8017-9318-9	Washer – Plain, 8MM
4895-5	26-1000-1347-8	Nut – Hex, M8
4895-6	78-8094-6432-0	Spacer
4895-7	78-8094-6433-8	Spacer
4895-8	78-8010-7169-3	Screw – Hex Hd, M6 x 12
4895-9	26-1000-0010-3	Washer – Flat, M6
4895-10	78-8010-7418-4	Nut – Hex, M6
4895-11	78-8076-4535-9	Bracket
4895-12	78-8076-4625-8	Screw – Special, M5 x 16
4895-13	78-8054-8832-3	Support – Valve
4895-14	26-1003-7949-9	Screw – Soc Hd, Hex Soc, M5 x 12
4895-15	26-1003-7946-5	Screw – Soc Hd, M4 x 25
4895-16	78-8059-5607-1	Plate – Threaded
4895-17	78-8094-6434-6	Screw – Soc Hd, Hex Hd, M4 x 50
4895-18	78-8017-9018-5	Washer – Plain, M4 SPEC.
4895-19	78-8094-6435-3	Spacer
4895-20	78-8094-6436-1	Shaft – Lever
4895-21	78-8076-4657-1	Link – Actuator, Valve
4895-22	78-8052-6566-3	Washer – Friction
4895-23	78-8016-5855-6	E-Ring – 10MM
4895-24	78-8094-6437-9	Shaft – Roller
4895-25	78-8094-6438-7	Roller
4895-27	78-8094-6439-5	Frame – R/H
4895-28	78-8094-6440-3	Frame – L/H
4895-29	78-8094-6441-1	Shaft – 10 x 125
4895-30	78-8060-8035-0	E-Ring – 7DIN6799
4895-31	78-8094-6255-5	Shaft – 10 x 46
4895-32	78-8076-4774-4	Spring
4895-33	78-8094-6256-3	Sleeve
4895-34	78-8094-6258-9	Bushing
4895-35	78-8060-7798-4	Wheel – /50
4895-36	78-8042-2919-9	Washer – Triple, M6
4895-37	26-1003-5832-9	Screw – Hex Hd, M6 x 25
4895-38	78-8054-8617-8	Bearing – Special
4895-39	78-8017-9106-8	Screw – Bearing Shoulder
4895-40	78-8113-6829-5	Upper Cover Assembly – W/English Language Label
4895-41	26-1002-5753-9	Screw – Self-Tapping
4895-42	78-8005-5740-3	Washer – Plain, 4 MM
4895-43	78-8094-6444-5	Cover – Rear
4895-44	78-8060-8087-1	Screw – M5 x 10
4895-46	78-8005-5741-1	Washer – Plain, M5
4895-47	78-8010-7417-6	Nut – Hex, M5
4895-48	78-8060-7885-9	End Cap – /25X1,2
4895-49	78-8052-6700-8	Spacer – Taping Head Mtg.
4895-50	78-8076-5477-3	Washer – Taping Head Mtg., 6.5 x 20 x 4
4895-51	78-8060-7918-8	Screw – Flat, Soc Hd, M6 x 25

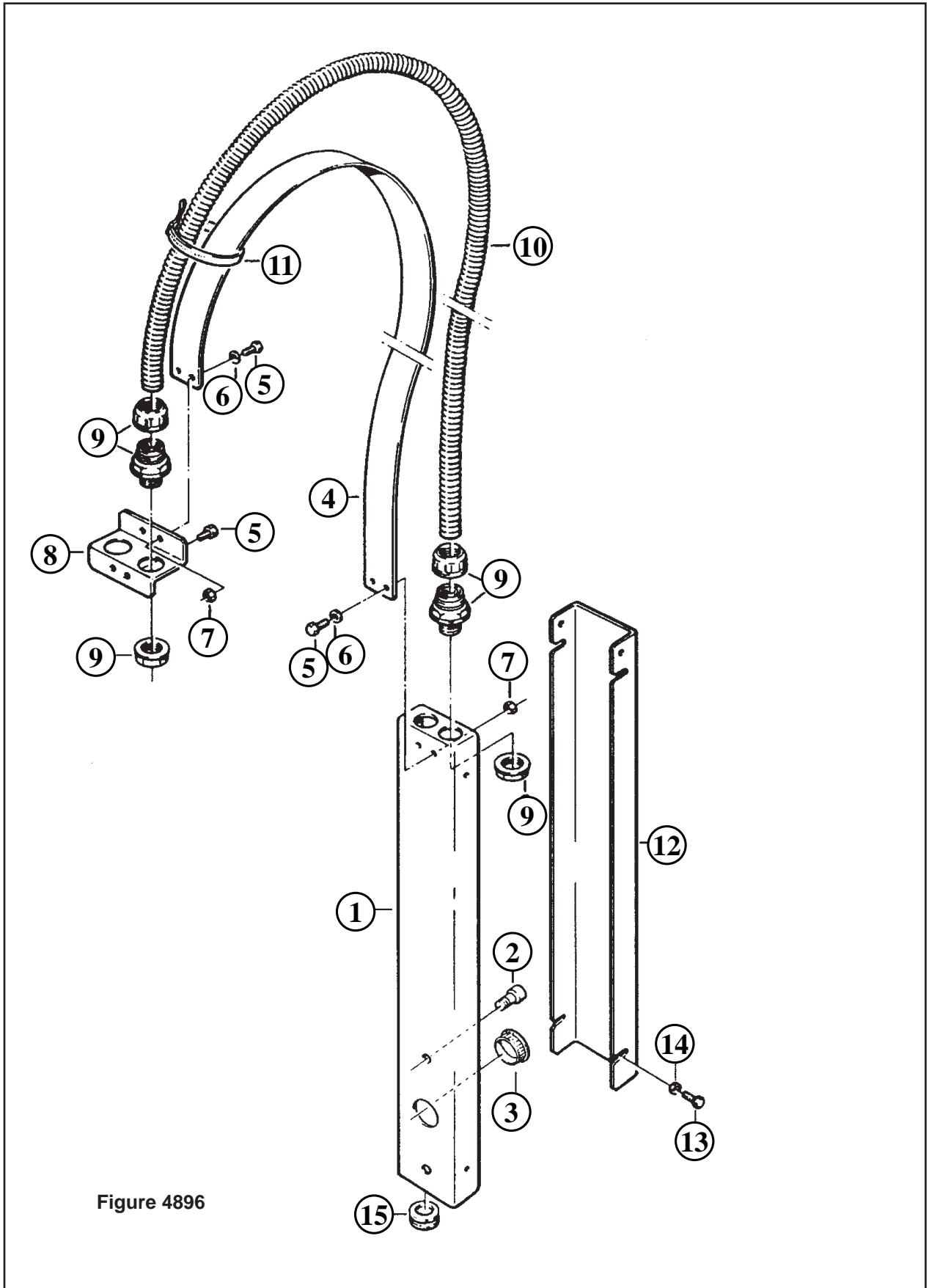


Figure 4896

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Figure 4896

Ref. No.	3M Part No.	Description
4896-1	78-8091-0600-4	Housing – Wire
4896-2	26-1003-7963-0	Screw – Soc Hd, M8 x 16
4896-3	78-8094-6489-0	Snap Bushing – SB 1250-15
4896-4	78-8076-4636-5	Strap – Wire
4896-5	78-8010-7163-6	Screw – Hex Hd, M5 x 10
4896-6	78-8005-5741-1	Washer – Plain, M5
4896-7	78-8010-7417-6	Nut – Hex, M5
4896-8	78-8076-4873-4	Plate – Strap
4896-9	78-8076-4638-1	Union PG13.5 – Sleeve / 14
4896-10	78-8094-6445-2	Sleeve – /14, 980 MM
4896-11	78-8060-8029-3	Clamp – 140 x 3,5
4896-12	78-8076-5118-3	Cover – Channel
4896-13	26-1003-5810-5	Screw – Hex Hd, M4 x 8
4896-14	78-8017-9018-5	Washer – Plain, M4 SPEC.
4896-15	78-8060-7785-1	Fairlead – /22

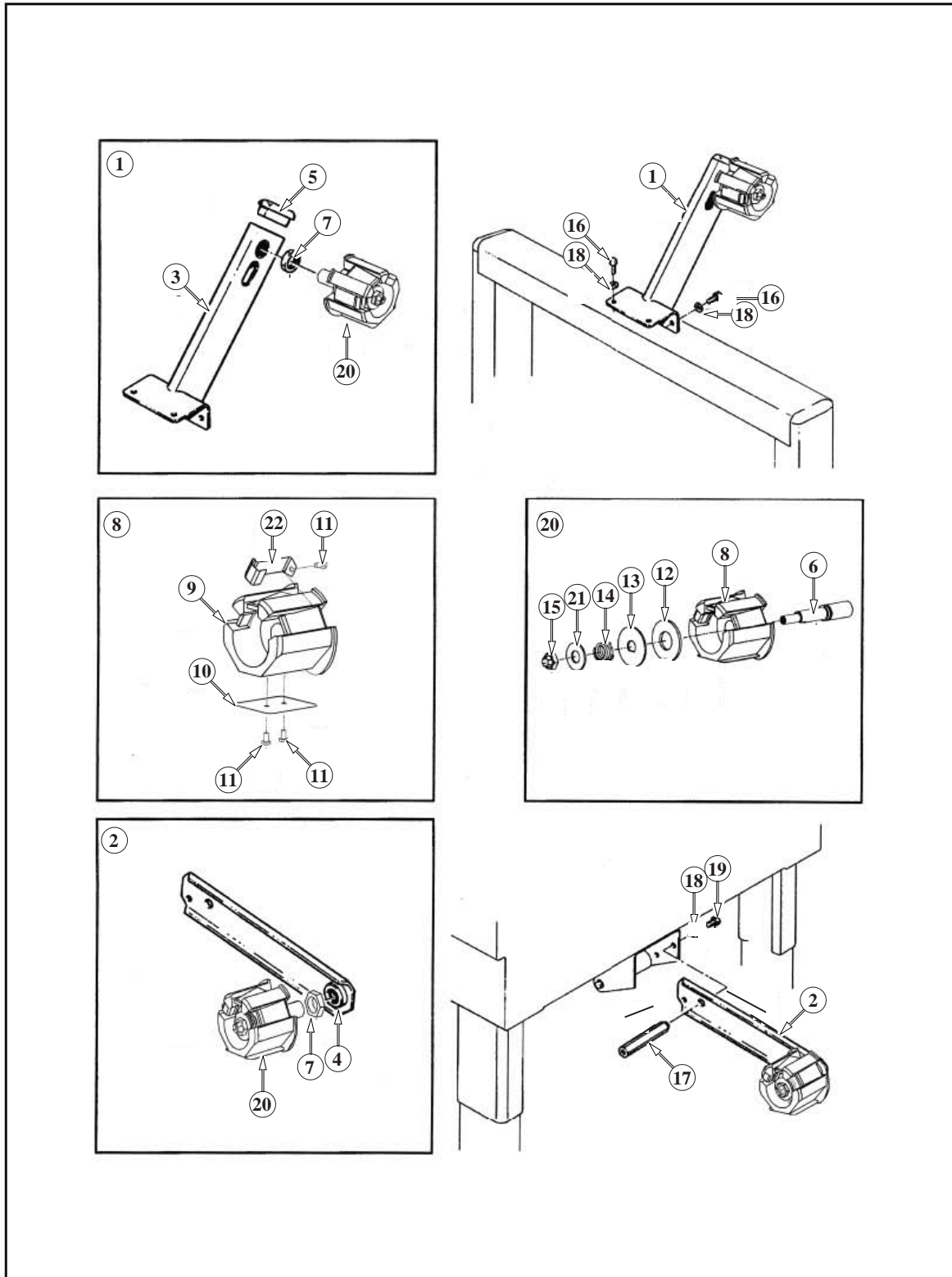


Figure 10440

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Figure 10440

Ref. No.	3M Part No.	Description
10440-1	78-8076-4633-2	Tape Roll Bracket Assembly
10440-2	78-8070-1565-2	Tape Drum Bracket Assembly
10440-3	78-8070-1566-0	Bracket – 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	Tape Drum Sub-Assembly - 2 Inch
10440-9	78-8098-8749-6	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	Tape Drum Assembly – 2 Inch Head
10440-21	26-1004-5510-9	Washer - Plain, M10
10440-22	78-8098-8816-3	Latch - Tape Drum

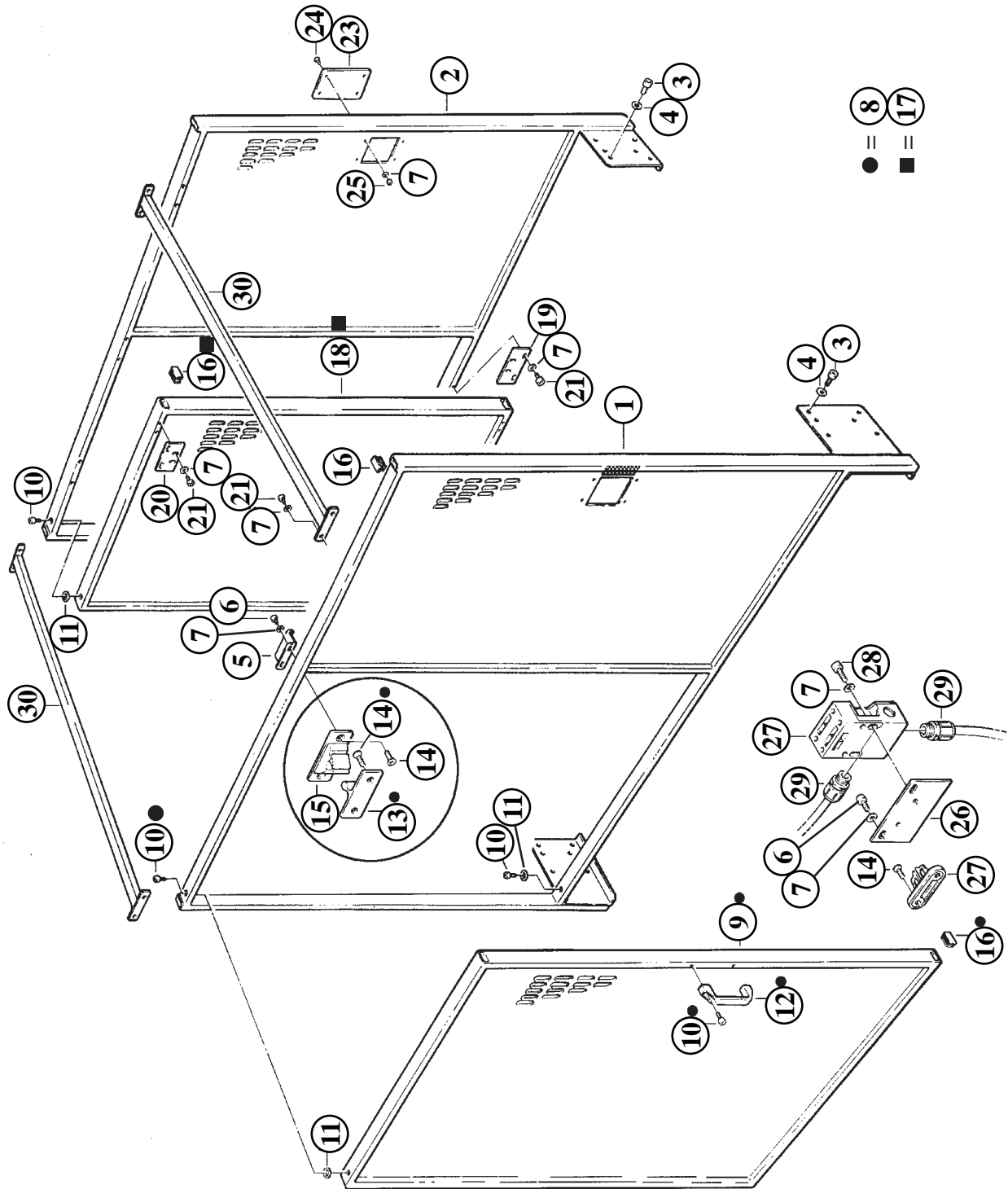
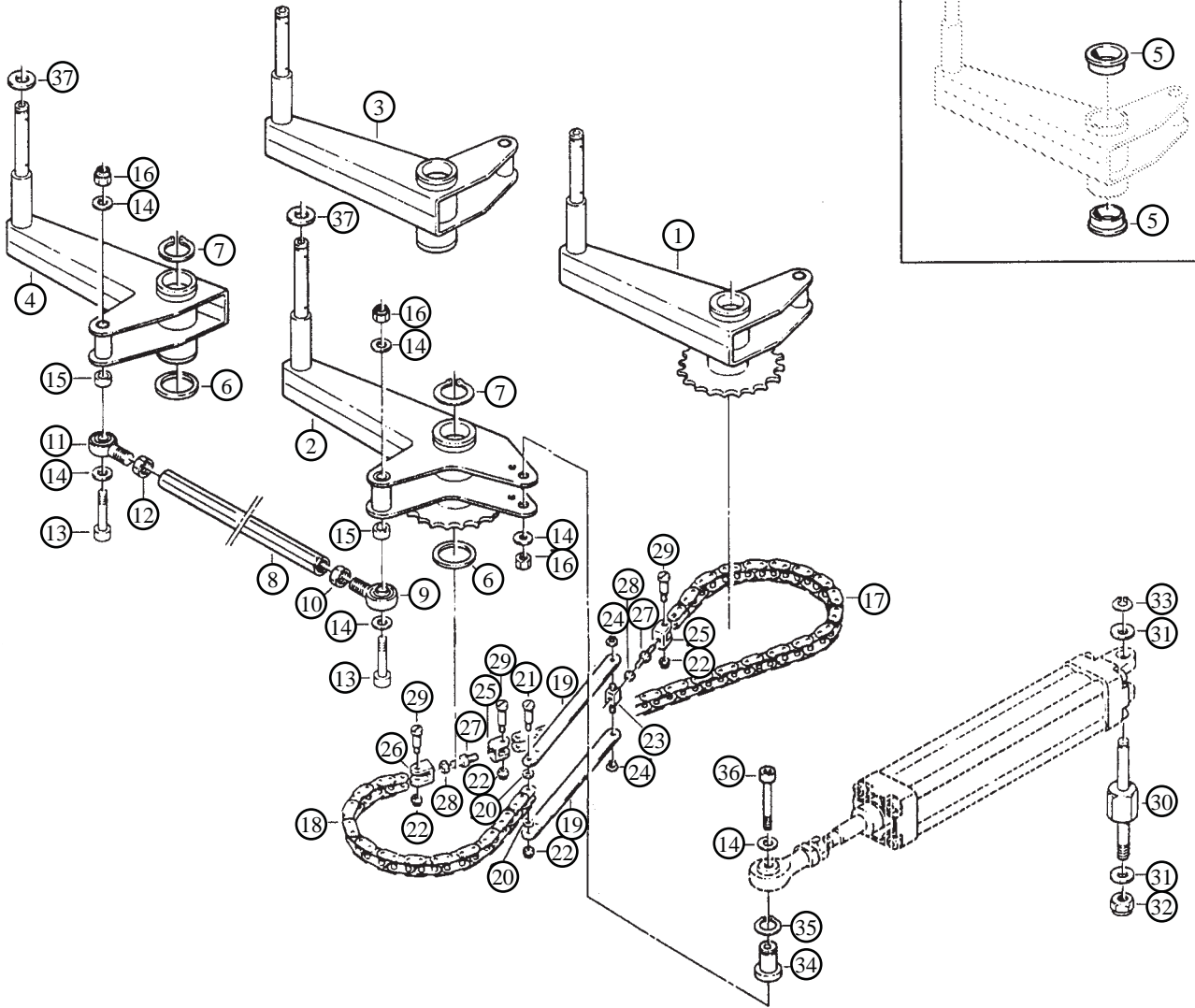


Figure 4900

Figure 4900

Ref. No.	3M Part No.	Description
4900-1	78-8113-6835-2	Guard Assembly – L/H, W/English Language Label
4900-2	78-8094-6460-1	Guard – R/H
4900-3	26-1003-7964-8	Screw – Soc Hd, Hex Hd, Soc Dr, M8 x 20
4900-4	78-8017-9318-9	Washer – Plain, 8 MM
4900-5	78-8094-6461-9	Bracket
4900-6	78-8032-0382-3	Screw – Soc Hex Hd, M5 x 16
4900-7	78-8005-5741-1	Washer – Plain, M5
4900-8	78-8094-6462-7	Door Assembly – L/H
4900-9	78-8094-6463-5	Door – L/H
4900-10	26-1003-7957-2	Screw – Soc Hd, Hex Hd, M6 x 16
4900-11	78-8094-6464-3	Spacer
4900-12	78-8060-7807-3	Handle
4900-13	78-8076-4931-0	Drawbar – Lock
4900-14	26-0001-5862-1	Screw – Flat Hd Soc , M5 x 12
4900-15	78-8076-4932-8	Lock – Wing
4900-16	78-8094-6195-3	Cap
4900-17	78-8094-6465-0	Door Assembly – R/H
4900-18	78-8094-6466-8	Door – R/H
4900-19	78-8094-6467-6	Plate – Lower
4900-20	78-8094-6468-4	Plate – Upper
4900-21	26-1003-7949-9	Screw – Soc Hd, Hex Soc, M5 x 12
4900-23	78-8094-6470-0	Plate
4900-24	78-8060-8087-1	Screw – M5 x 10
4900-25	78-8010-7417-6	Nut – Hex, M5
4900-26	78-8094-6471-8	Plate – Switch Mounting
4900-27	78-8114-5024-2	Security Switch – SK-U1ZM
4900-28	26-1003-7951-5	Screw – Soc Hd, Hex Soc, M5 x 20
4900-29	78-8076-4532-6	Union
4900-30	78-8094-6469-2	Cross Bar



Dessin 7005

Figure 7005

Ref. No.	3M Part No.	Description
7005-1	78-8114-4867-5	Arm Assembly – Front, Right
7005-2	78-8114-4868-3	Arm Assembly – Front, Left
7005-3	78-8114-4869-1	Arm Assembly – Rear Right
7005-4	78-8114-4870-9	Arm Assembly – Rear, Left
7005-5	78-8076-4791-8	Bushing
7005-6	78-8060-7534-3	Washer
7005-7	78-8060-7521-0	Lock Ring
7005-8	78-8094-6407-2	Rod
7005-9	78-8076-4793-4	Ball Joint – KA 10 D
7005-10	78-8060-7525-1	Nut – Right Flat, M10
7005-11	78-8076-4794-2	Ball Joint – KAL 10 D
7005-12	78-8060-7546-7	Nut – Left Flat, M10
7005-13	78-8076-4796-7	Screw – Soc Hd, M10 x 80
7005-14	78-8052-6566-3	Washer– Friction
7005-15	78-8076-4795-9	Spacer
7005-16	26-1003-6918-5	Nut – Plastic Insert, Hex Flange, M10
7005-17	78-8060-7518-6	Chain – 3/8 Inch, 60 Pitch Long
7005-18	78-8054-8777-0	Chain – 3/8 Inch Pitch, 41 Links Long
7005-19	78-8054-8787-9	Chain Link
7005-20	78-8054-8783-8	Washer – Special
7005-21	78-8060-7519-4	Screw – M3 x 25
7005-22	78-8059-5517-2	Nut – Self-Locking, M3
7005-23	78-8054-8784-6	Block – Chain
7005-24	78-8056-3945-3	E-Ring – M4
7005-25	78-8054-8786-1	Chain Connector
7005-26	78-8054-8788-7	Chain Connector
7005-27	78-8054-8785-3	Rod – Threaded Right/Left
7005-28	78-8010-7418-4	Nut – Hex, M6
7005-29	78-8060-7520-2	Screw - M3 x 20
7005-30	78-8060-7531-9	Stud – Cylinder
7005-31	78-8017-9059-9	Washer – Flat For M12 Screw
7005-32	78-8060-7532-7	Nut – Self-Locking
7005-33	78-8056-3965-1	E-Ring – M8
7005-34	78-8060-7538-4	Bushing – Cylinder
7005-35	78-8060-7533-5	Lock-Ring
7005-36	78-8060-7535-0	Screw – Soc Hd, Hex Soc
7005-37	78-8060-7541-8	Washer
7005-38	78-8114-4871-7	Grease Nipple

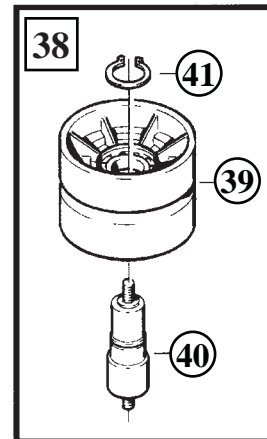
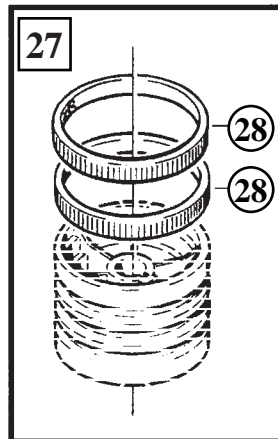
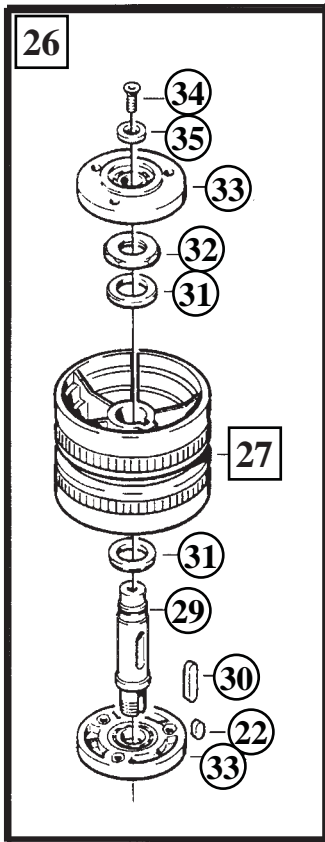
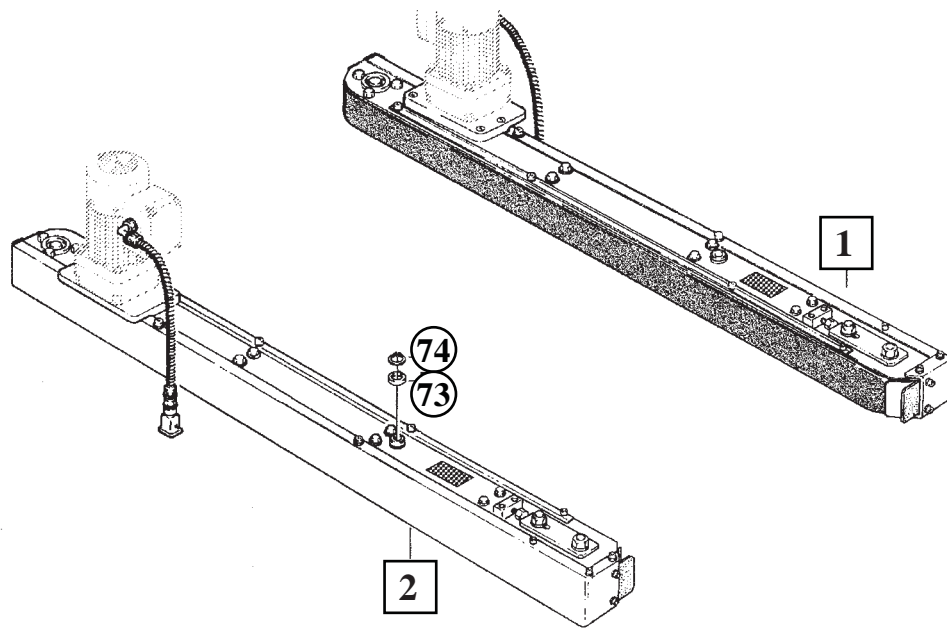


Figure TBA / 1

Figure TBA / 1

Ref. No.	3M Part No.	Description
TBA-1	TBA 78-8114-4872-5	Side Drive – R/H, W/O Motor
TBA-2	TBA 78-8114-4873-3	Side Drive – L/H, W/O Motor
TBA-3	78-8114-4874-1	Guide – Lower, R/H
TBA-4	78-8114-4875-8	Guide – Lower, L/H
TBA-5	78-8113-6833-7	Guide – Upper, R/H
TBA-6	78-8113-6834-5	Guide – Upper, L/H
TBA-7	78-8114-4878-2	Bushing
TBA-8	78-8060-7995-6	Pin – Roller
TBA-9	78-8060-7996-4	Roller
TBA-10	78-8094-6424-7	Plate – Lower, R/H
TBA-11	78-8094-6425-4	Plate – Lower, L/H
TBA-12	78-8094-6426-2	Plate – Upper, R/H
TBA-13	78-8094-6427-0	Plate – Upper, L/H
TBA-14	78-8076-5255-3	Screw – Phillips Dr, M4 x 12
TBA-15	78-8005-5740-3	Washer – Plain, 4 MM
TBA-16	78-8076-4855-1	Washer – Special, /4.5-9X1.5
TBA-17	78-8054-8910-7	Spacer – Hexagonal
TBA-18	26-1003-5829-5	Screw – Hex Hd, M6 x 12
TBA-19	26-1000-0010-3	Washer – Flat, M6
TBA-20	78-8076-5439-3	Flange Assembly
TBA-21	78-8091-0757-2	Extension – Gearmotor
TBA-22	78-8046-8135-7	Key – 5 x 5, 12MM
TBA-23	TBA 78-8137-0934-8	Sprocket – 3/8 Inch, Z=17
TBA-24	78-8057-5834-5	Tab Washer
TBA-25	78-8057-5835-2	Centering Washer
TBA-26	78-8076-4862-7	Pulley – Drive
TBA-27	78-8076-5105-0	Pulley Assembly – Drive
TBA-28	78-8052-6713-1	Ring – Polyurethane
TBA-29	78-8054-8878-6	Shaft – Pulley Keyed
TBA-30	78-8057-5739-6	Key – M5 x 5 x 30MM
TBA-31	78-8054-8879-4	Washer – /20, 5MM
TBA-32	78-8017-9096-1	Nut – Special, M18 x 1
TBA-33	78-8076-5442-7	Flange Assembly
TBA-34	26-0001-5862-1	Screw – Flat Hd Soc, M5 x 12
TBA-35	78-8054-8877-8	Washer – 5,5/20X4
TBA-36	TBA 78-8137-0935-5	Sprocket – 3/8 Inch, Z=20
TBA-37	TBA 78-8076-4933-6	Chain – 3/8 Inch Pitch, 52 Pitch

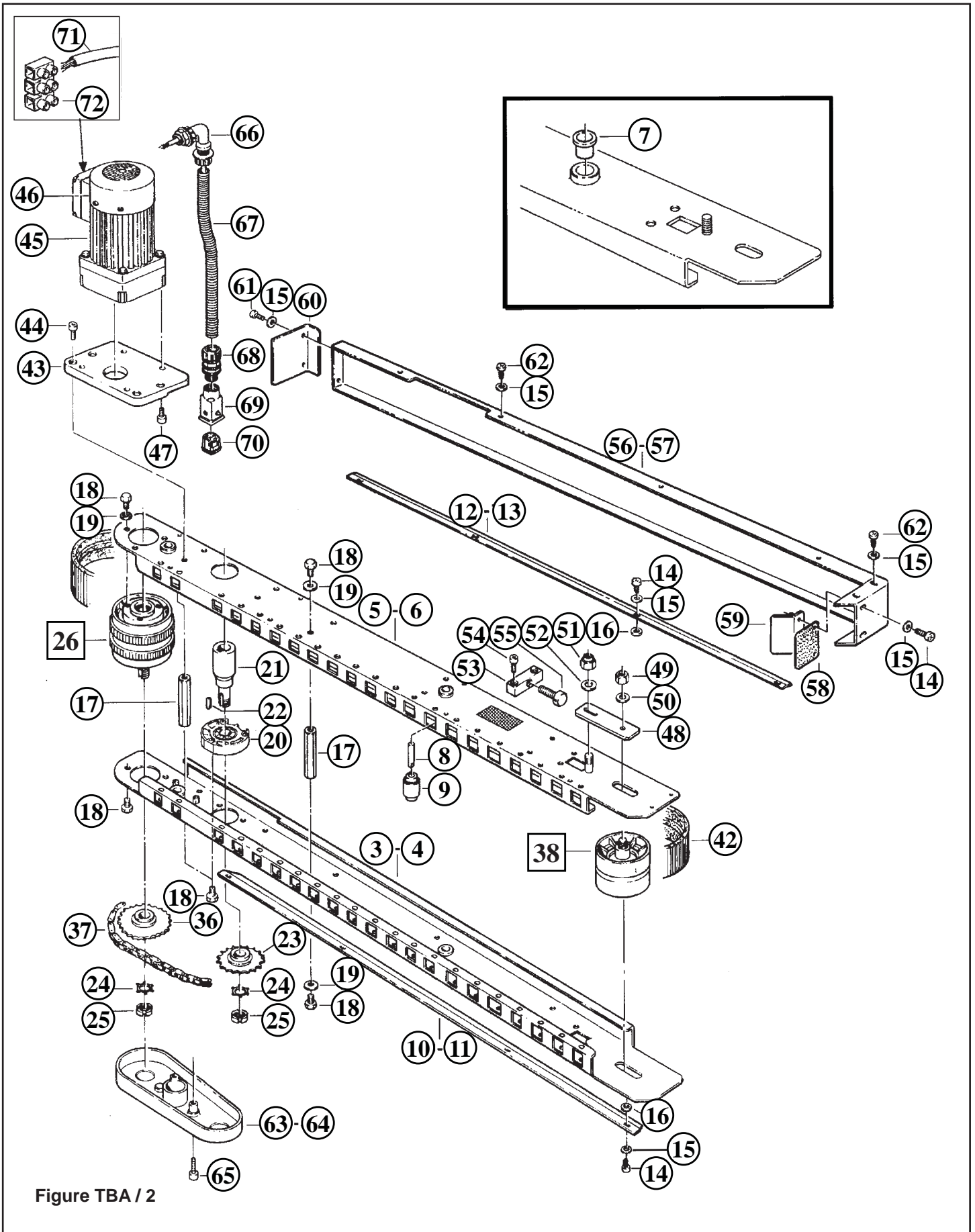


Figure TBA / 2

Figure TBA / 2

Ref. No.	3M Part No.	Description
TBA-38	78-8060-8014-5	Idler Roller Assembly
TBA-39	78-8052-6710-7	Roller – Idler
TBA-40	78-8054-8913-1	Shaft – Roller
TBA-41	12-7997-0272-0	E-Ring – M25
TBA-42	78-8094-6447-8	Belt – Drive
TBA-43	78-8094-6109-4	Support – Gearmotor
TBA-44	78-8010-7210-5	Screw – Soc Hd, Hex Soc, M6 x 20
TBA-45	78-8070-1522-3	Gearmotor – 115V, 60HZ
TBA-46	26-1011-8828-7	Capacitor – 115V Gearmotor
TBA-47	78-8070-1523-1	Screw – 1/4-28X1/2 SHCS
TBA-48	78-8076-4864-3	Plate – Belt Tensioning
TBA-49	26-1003-6904-5	Nut – M8
TBA-50	78-8017-9318-9	Washer – Plain, 8MM
TBA-51	26-1003-6918-5	Nut – Plastic Insert, Hex, M10
TBA-52	78-8052-6566-3	Washer – Friction
TBA-53	78-8054-8903-2	Block – Belt
TBA-54	78-8010-7210-5	Screw – Soc Hd, Hex Soc, M6 x 20
TBA-55	78-8054-8904-0	Screw – Belt Adjustment
TBA-56	78-8114-4879-0	Cover – R/H
TBA-57	78-8114-4880-8	Cover – L/H
TBA-58	78-8114-4881-6	Guard – Drive
TBA-59	78-8114-4882-4	Cover
TBA-60	78-8114-4787-5	Guard – Belt
TBA-61	26-1002-4955-1	Screw – Self-Tap, 8PX13
TBA-62	26-1002-5753-9	Screw – Self-Tapping
TBA-63	78-8091-0764-8	Cover – Chain, Right
TBA-64	78-8091-0765-5	Cover – Chain, Left
TBA-65	78-8010-7165-1	Screw – Flat Hd, Soc, M5 x 25
TBA-67	78-8076-4871-8	Sleeving
TBA-68	78-8060-7626-7	Connector
TBA-69	78-8060-7877-6	Plug – Housing, Vertical
TBA-70	78-8060-7875-0	Plug – Male
TBA-71	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
TBA-72	78-8076-4968-2	Terminal
TBA-73	78-8060-7541-8	Washer
TBA-74	78-8060-7533-5	Lock Ring

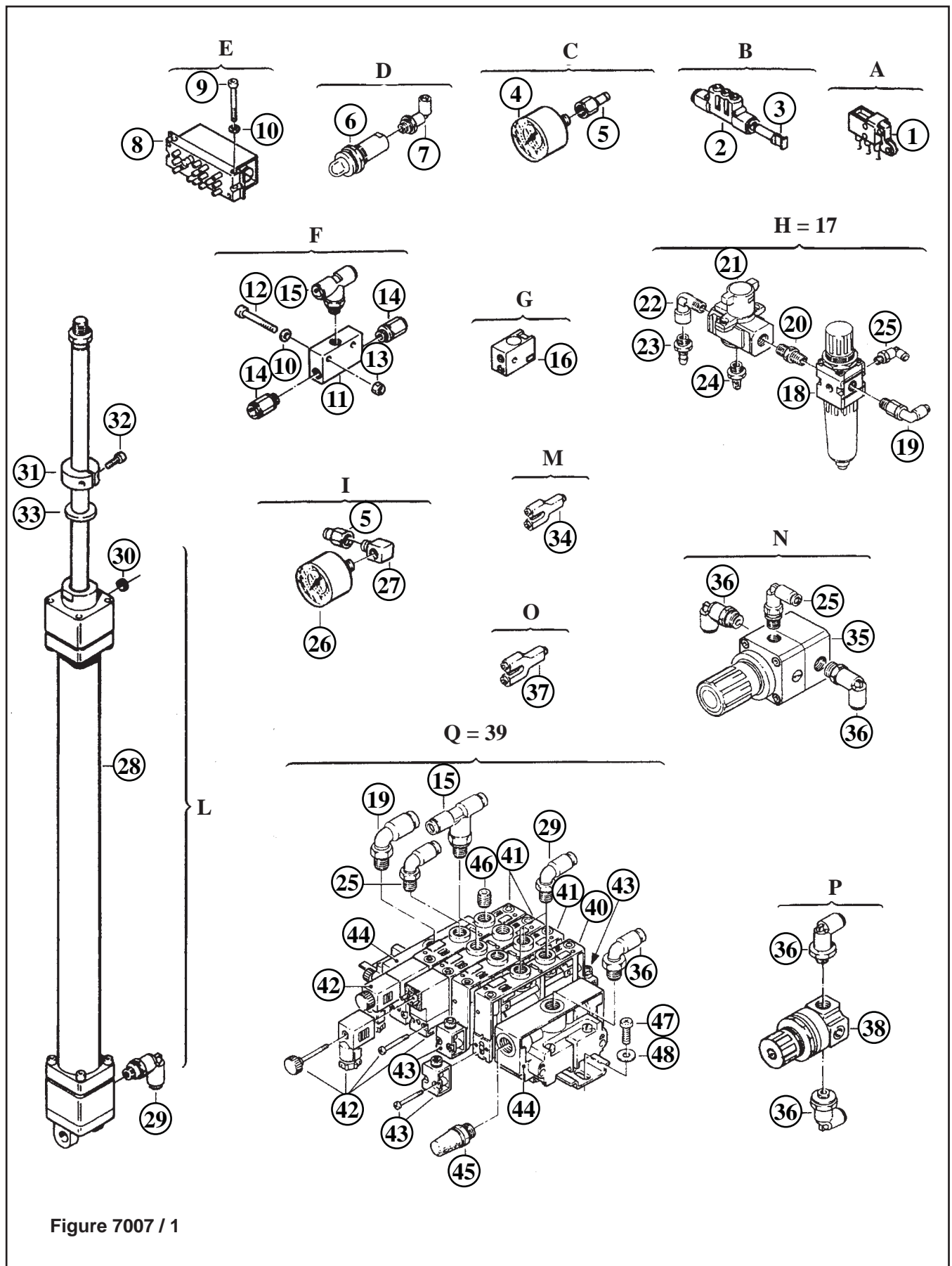


Figure 7007 / 1

Figure 7007 / 1

Ref. No.	3M Part No.	Description
7007-1	78-8060-8091-3	Valve – FESTO R/O-3-PK-3
7007-2	78-8094-6448-6	Union – TE 33040604
7007-3	78-8114-4883-2	Cap
7007-4	78-8076-4671-2	Gauge – Pressure
7007-5	78-8076-4672-0	Union – Straight, Female
7007-6	78-8076-4665-4	Indicator – Visual
7007-7	78-8076-4888-2	Elbow
7007-8	78-8060-7656-4	Valve – One-Shot, FESTO VLK-3-PK-3
7007-9	78-8060-7711-7	Screw – Soc Hd, Hex Soc, M4 x 30
7007-10	78-8005-5740-3	Washer – Plain, 4 MM
7007-11	26-1005-6904-0	Valve – OR Aerpress VCS8
7007-12	26-1003-7946-5	Screw – Soc Hd, M4 x 25
7007-13	26-1003-6914-4	Nut – Plastic Insert, M4
7007-14	26-1005-6910-7	Union – Straight
7007-15	78-8060-8183-8	Union – Rotating
7007-16	78-8094-6451-0	Valve – Selector, Parker PLK-A11
7007-17	78-8114-4884-0	Filter/Regulator Assembly
7007-18	26-1014-4558-8	Filter/Regulator – W/Metal Bowl, SMC EAW2000-FO2D-2
7007-19	78-8091-0315-9	Elbow
7007-20	78-8060-7899-0	Nipple – 1/4 Inch
7007-21	78-8091-0715-0	Valve – SMC EVHS-4500 FO2-X116
7007-22	78-8060-7900-6	Union
7007-23	26-1005-6897-6	Hose Connector
7007-24	78-8114-4885-7	Muffler
7007-25	26-1005-5909-0	Elbow
7007-26	78-8054-8838-0	Gauge – Air
7007-27	78-8091-0638-4	Elbow

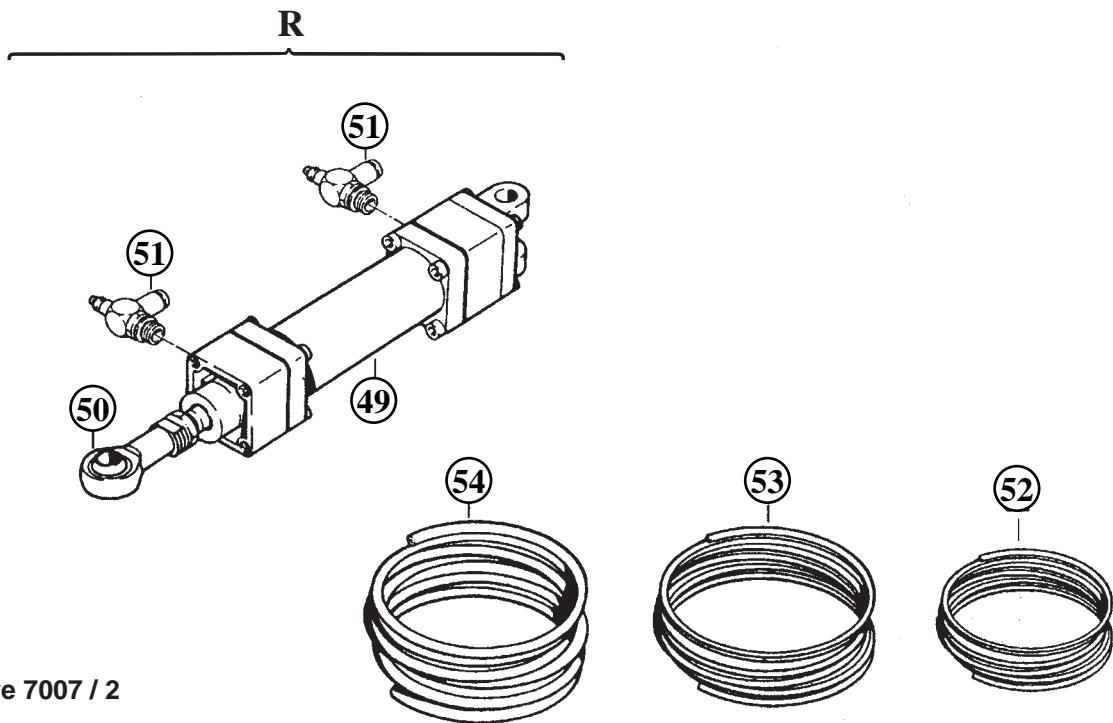
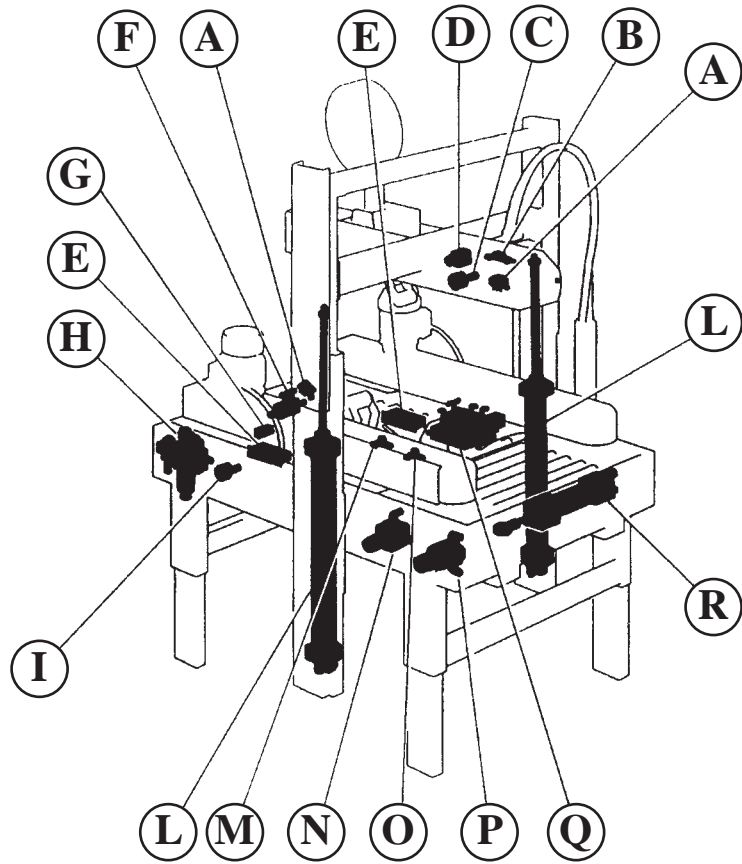


Figure 7007 / 2

Figure 7007 / 2

Ref. No.	3M Part No.	Description
7007-28	78-8054-8827-3	Cylinder – Air, C65D32-440CY01
7007-29	26-1005-6893-5	90 Degree Elbow
7007-30	78-8094-6457-7	Cap – 1/8 Inch
7007-31	78-8100-1153-2	Collar – Height Locking
7007-32	78-8010-7210-5	Screw – Soc Hd Hex Soc, M6 x 20
7007-33	78-8100-1154-0	Washer
7007-34	78-8076-4664-7	Union – Female
7007-35	78-8094-6458-5	Reducer
7007-36	78-8055-0756-9	Union – Rotating
7007-37	78-8094-6079-9	Union – Y, Female
7007-38	78-8076-4675-3	Regulator – 0.5-7 Bar, SMC EAR111-F02
7007-39	78-8114-4886-5	Valve Assembly
7007-40	78-8114-4887-3	Distributor – SMC PVL-B122618
7007-41	78-8114-4888-1	Distributor – SCM PVL B121618
7007-42	78-8094-6456-9	Actuator – SMC PVA H2491F, 100/115V, 50/50 HZ
7007-43	78-8094-6450-2	Connector – SMC PVA-P111
7007-44	78-8114-4889-9	Feeding End – SMC PVL-B1729
7007-45	78-8076-4886-6	Muffler – 1/4 Inch
7007-46	78-8060-7690-3	Cap
7007-47	78-8094-6145-8	Screw – Phillis, M5 x 12
7007-48	78-8028-8214-8	Washer
7007-49	78-8100-0757-1	Cylinder – SCM C95SDB50-95+20
7007-50	78-8060-7539-2	Head Joint
7007-51	78-8091-0510-5	Regulator – Speed
7007-52	78-8119-8666-6	Tube – Air, 4 mm O.D. x 2.5 mm I.D.
7007-53	78-8119-8667-4	Tube – Air, 6 mm O.D. x 4 mm I.D.
7007-54	78-8119-8668-2	Tube – Air, 8 mm O.D. x 5 mm I.D.
	78-8060-8175-4	Seal Kit – Cylinder, Megliani/32
	78-8100-0758-9	Seal Kit – Cylinder, SMC /32
	78-8100-0759-7	Seal Kit – Cylinder, SMC /50

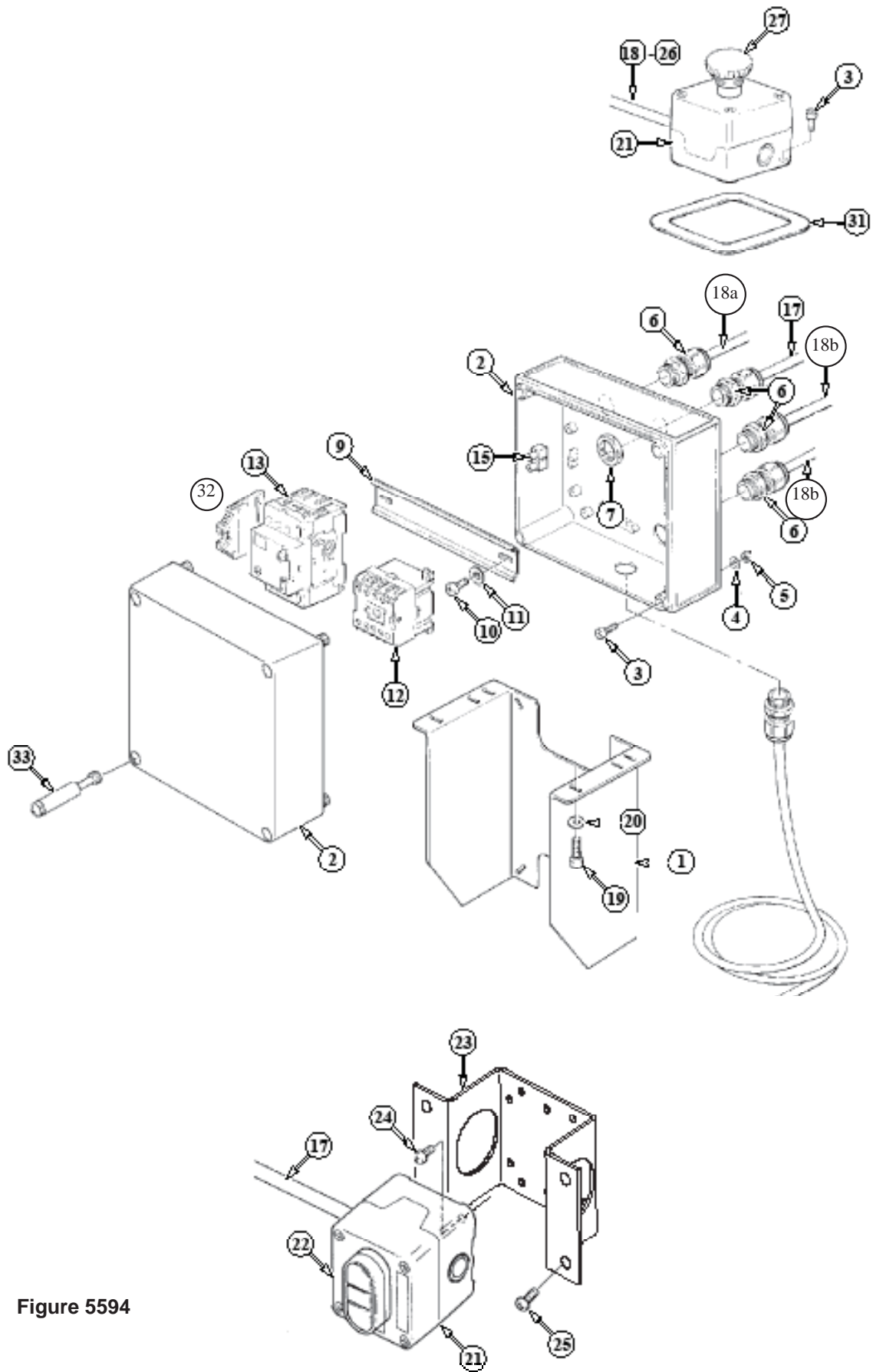


Figure 5594

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Figure 5594

Ref. No.	3M Part No.	Description
5594-1	78-8094-6379-3	Support – Box
5594-2	78-8113-6759-4	Box – W/English Language Label
5594-3	78-8094-6381-9	Screw – Soc Hd, Hex Hd, M4 x 15
5594-4	78-8005-5740-3	Washer – Plain, 4 mm
5594-5	26-1003-6914-4	Nut – Plastic Insert, M4
5594-6	78-8076-4715-7	Cord Grip
5594-7	78-8076-5211-6	Set Nut – GMP 13.5
5594-9	78-8094-6382-7	Guide – Mounting
5594-10	78-8028-8208-0	Screw – 6P x 9,5
5594-11	78-8017-9018-5	Washer – Plain, M4
5594-12	78-8100-0830-6	Contactor – Allen Bradley 220V, 50HZ
	78-8100-0831-4	Contactor – Allen Bradley 380V, 50HZ
	78-8094-6383-5	Contactor – Allen Bradley 110V, 60HZ
	78-8137-3650-7	Contactor – Allen Bradley 230V, 50/60HZ
5594-13	78-8076-5223-1	Circuit Breaker-Allen Bradley 1.0 – 1.6A
	78-8076-5378-3	Circuit Breaker-Allen Bradley 1.6 – 2.5A
	78-8100-0755-5	Circuit Breaker-Allen Bradley 2.5 – 4.0A
	78-8119-8965-2	Circuit Breaker-Allen Bradley 4.0 – 6.3A
	78-8114-4600-0	Circuit Breaker-Allen Bradley 6.3 – 10A
5594-14	78-8094-6384-3	Ground Clamp – VGPE 4/6
5594-15	78-8076-4968-2	Terminal
5594-17	78-8076-5176-1	Cable – FROR 07 3X0.75, 5 Mt
5594-18	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
5594-18A	78-8076-5273-6	Cable – 3X1, 5Mt
5594-18B	78-8060-8052-5	Cable – 4X1.5 5Mt 3 Ph
	78-8091-0433-0	Cable – 3X1.5 1 Ph, 5 Mt
5594-19	26-1003-7957-2	Screw – Soc Hex Hd, M6 x 16
5594-20	26-1000-0010-3	Washer – Flat, M6
5594-21	78-8076-5194-4	Box – E-Stop, Yellow
5594-22	78-8137-0823-3	Switch - ON/Off
5594-23	78-8100-1039-3	Support – On/Off Switch
5594-24	78-8017-9257-9	Screw – Phillips Head, M4 x 10
5594-25	78-8017-9066-4	Screw - Metric, M5X12
5594-26	78-8060-7758-8	Grommet
5594-27	78-8137-0609-6	E-Stop
5594-28	78-8091-0538-6	Screw - Hex. Hd. M4X20
5594-29	78-8076-4716-5	Star Washer – M4
5594-30	78-8010-7416-8	Nut – Hex, M4
5594-31	78-8100-1234-0	Collar
5594-32	78-8094-6384-3	Clamp
5594-33	78-8114-4896-4	Box – On/Off, Grey

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Instructions and Parts List

3M-Matic[™]

Accuglide[™] **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
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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:

Contact your local service provider 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: Accuglide 3 - 2 inch - Type 10800 - Serial Number 13282).

To order replacement parts, contact us:



CSPD division of Combi Packaging Systems LLC.

**5365 East Center Dr. N.E.
Canton, OH 44721**

1-800-344-9883

**e-mail: CSPD-CSR@combi.com
www.combi.com**

Identification Plate

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



3M Industrial Adhesives and Tapes

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St. Paul, MN 55144-1000

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Replacement Parts And Service Information

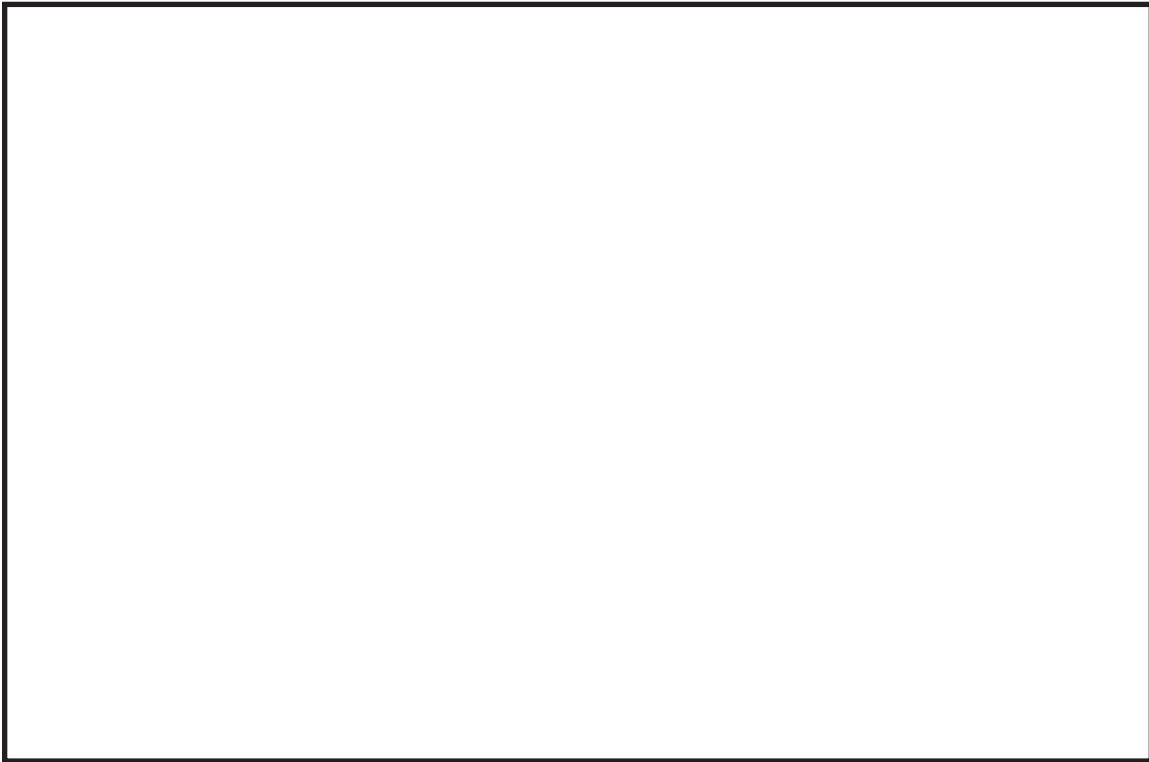
To Our Customers:

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

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

SERVICE, REPLACEMENT PARTS, AND ADDITIONAL MANUALS

AVAILABLE DIRECT FROM:



Order parts by part number, part description, and quantity required. Also, when ordering parts or additional manuals, include model/machine name, machine type, and serial number that are located on the identification plate.



3M Industrial Adhesives and Tapes

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

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Instruction Manual

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

Table of Contents	Page
Replacement Parts and Service Information	i - ii
Table of Contents.....	iii
Equipment Warranty and Limited Remedy.....	iv
Intended Use	1
Taping Head Contents / How to Use Manual.....	3
Important Safeguards.....	4 - 5
Specifications	6 - 7
Dimensional Drawing	7
Installation	8
Receiving and Handling	8
Installation Guidelines	8
Tape Leg Length	8
Tape Width Adjustment	8
Operation.....	9 - 11
Tape Loading – Upper Taping Head.....	10
Tape Loading – Lower Taping Head.....	10 - 11
Maintenance	12 - 13
Blade Replacement.....	12
Blade Guard	12
Blade Oiler Pad	12
Cleaning	13
Applying/Buffering Roller Replacement.....	13
Adjustments.....	14 - 16
Tape Latch Alignment.....	14
Tape Drum Friction Brake	14
Applying Mechanism Spring.....	15
One-Way Tension Roller	15
Tape Leg Length	16
Leading Tape Leg Length Adjustment	16
Changing Tape Leg Length From 70 to 50 mm [2-3/4 to 2 Inch]	16
Troubleshooting Guide	17 - 18
Spare Parts/Service Information.....	19
Recommended Spare Parts.....	19
Replacement Parts and Service.....	19 - 20
Replacement Parts Illustrations and Parts List.	21 - End of Manual

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.

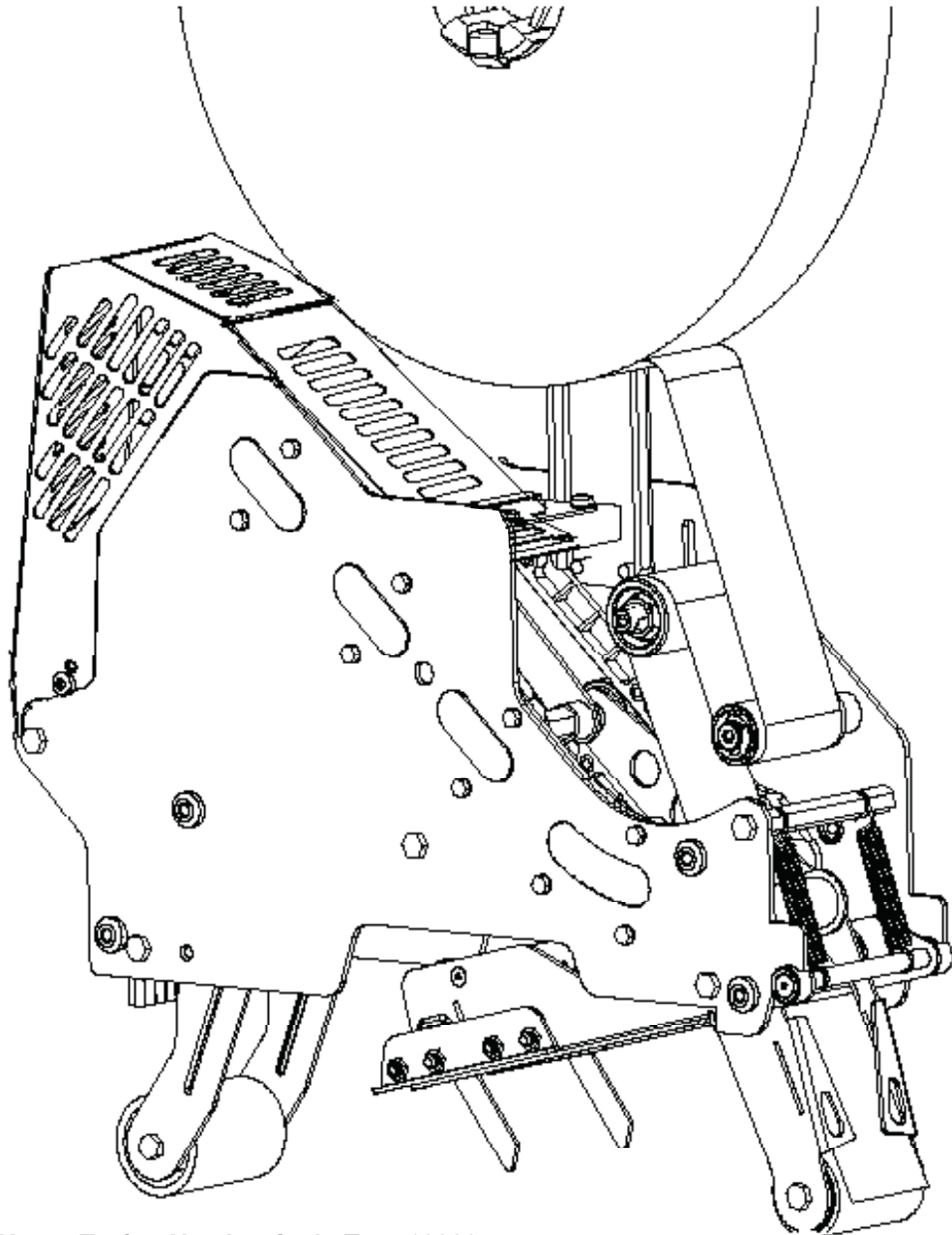
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Intended Use

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 April 2013/Copyright 3M 2013. 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 - 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.

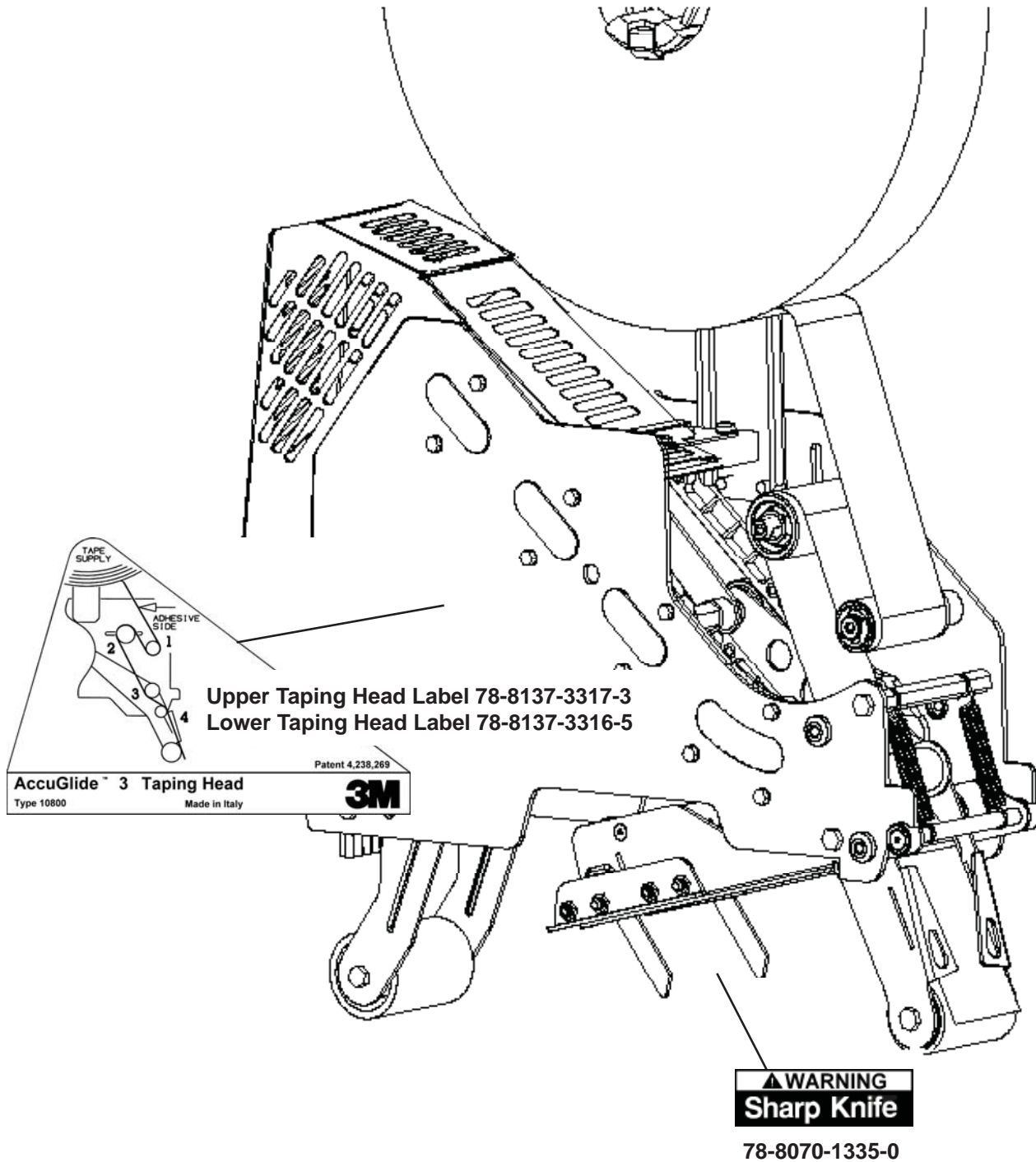


Figure 1-1 Replacement Labels/3M Part Numbers

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.)

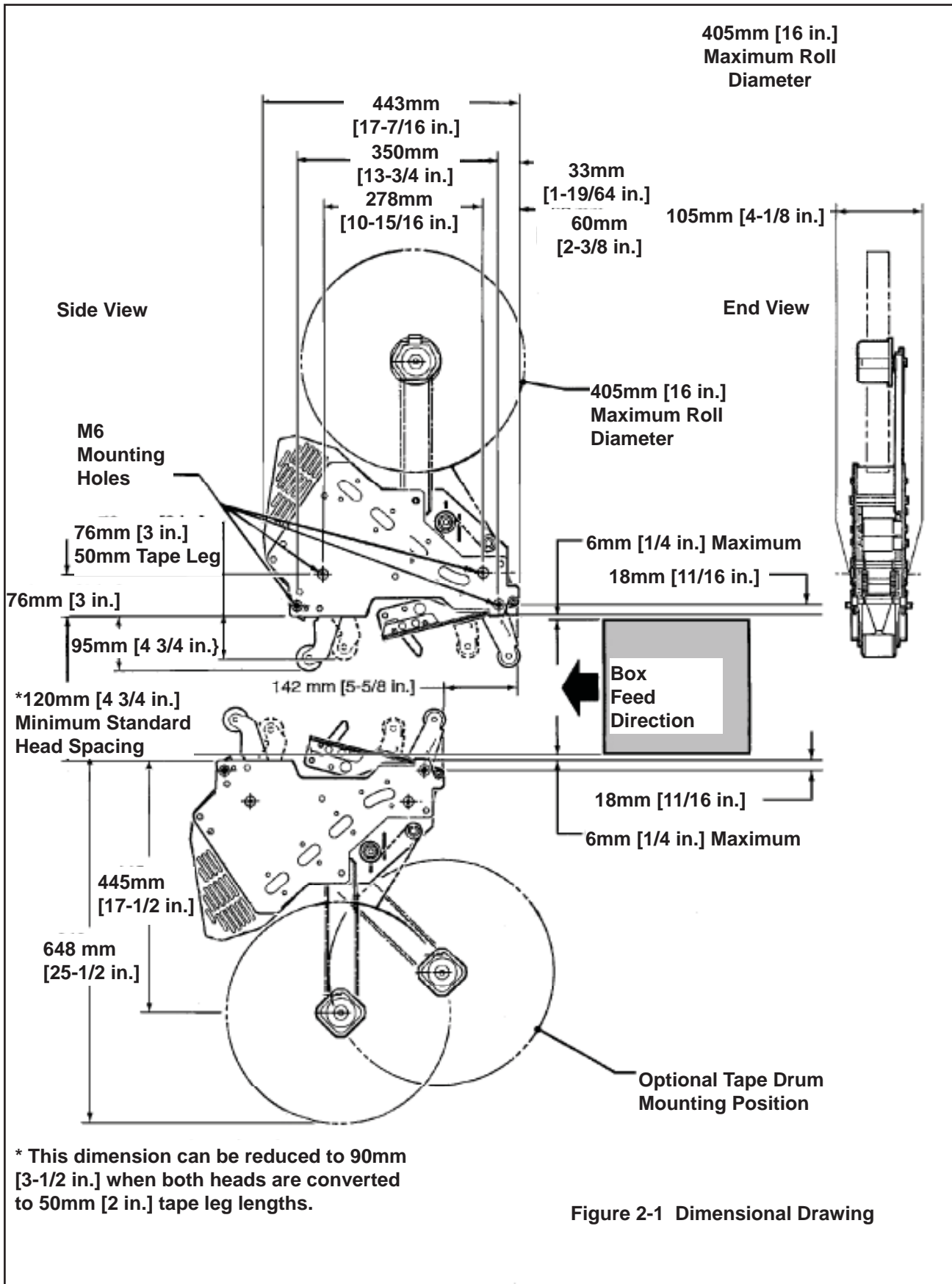


Figure 2-1 Dimensional Drawing

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

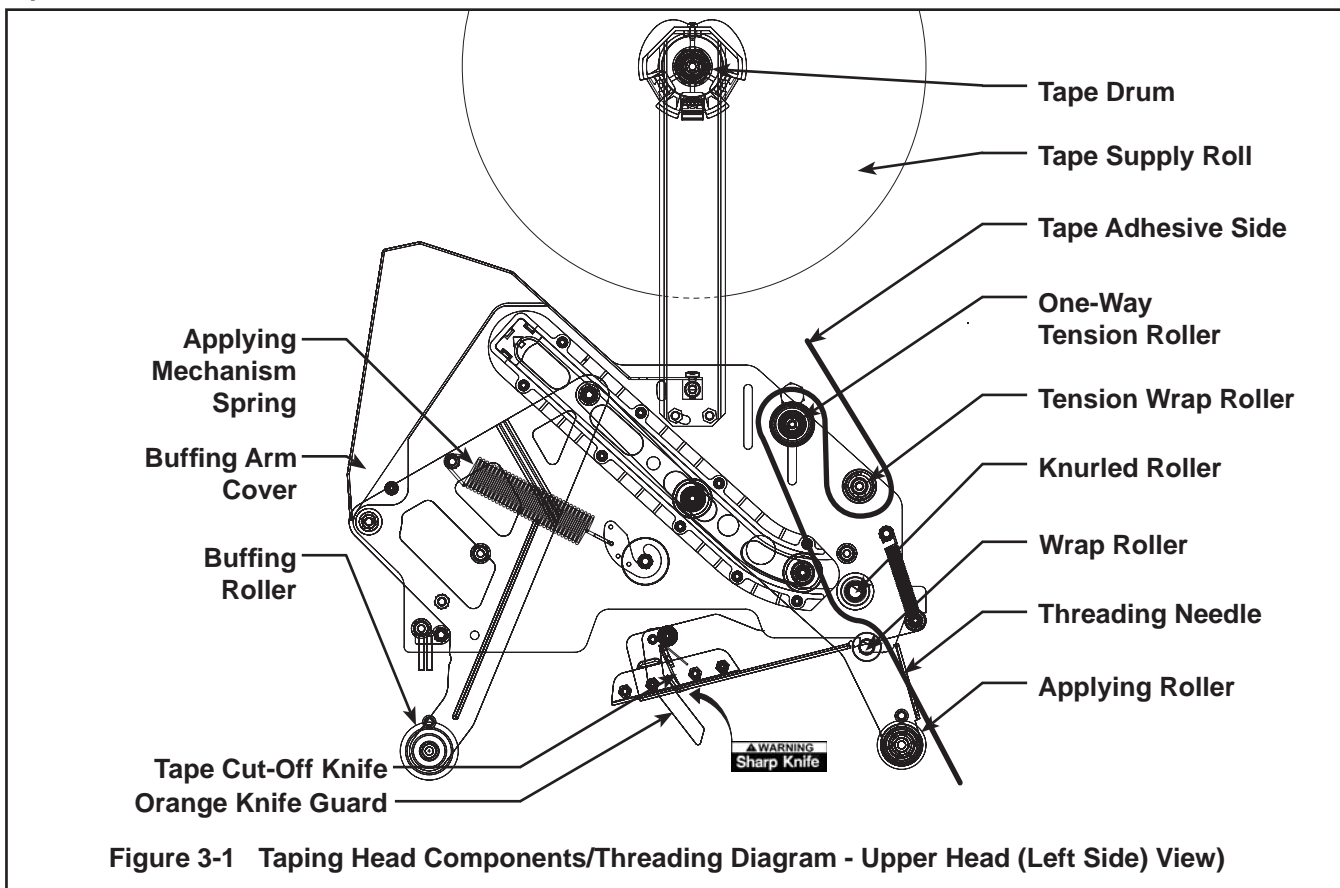


Figure 3-1 Taping Head Components/Threading Diagram - Upper Head (Left Side) View

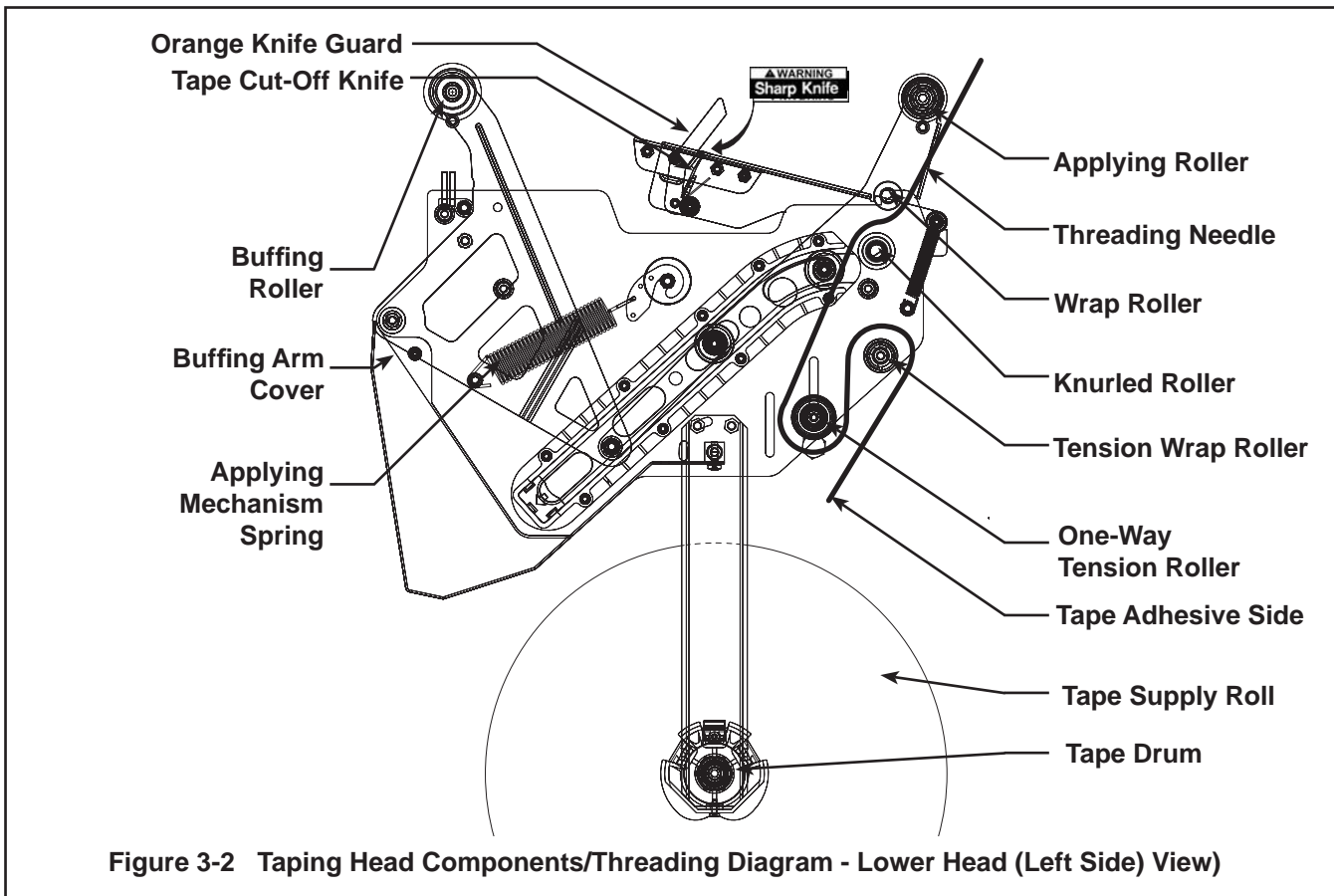


Figure 3-2 Taping Head Components/Threading Diagram - Lower Head (Left Side) View



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.

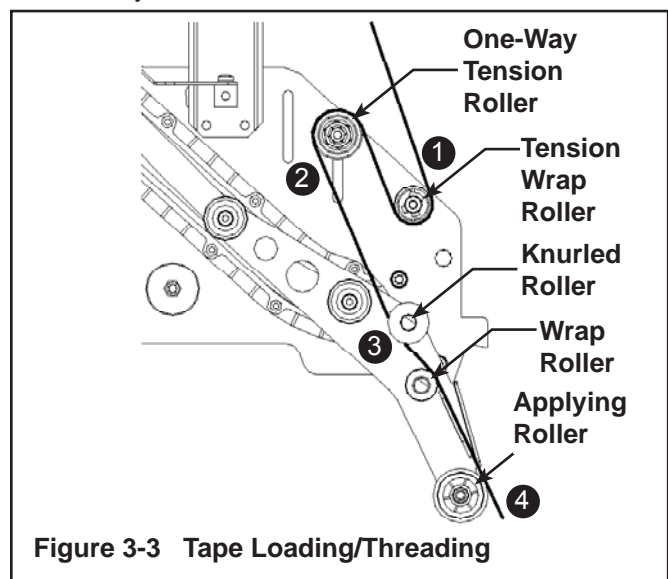


Figure 3-3 Tape Loading/Threading

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.

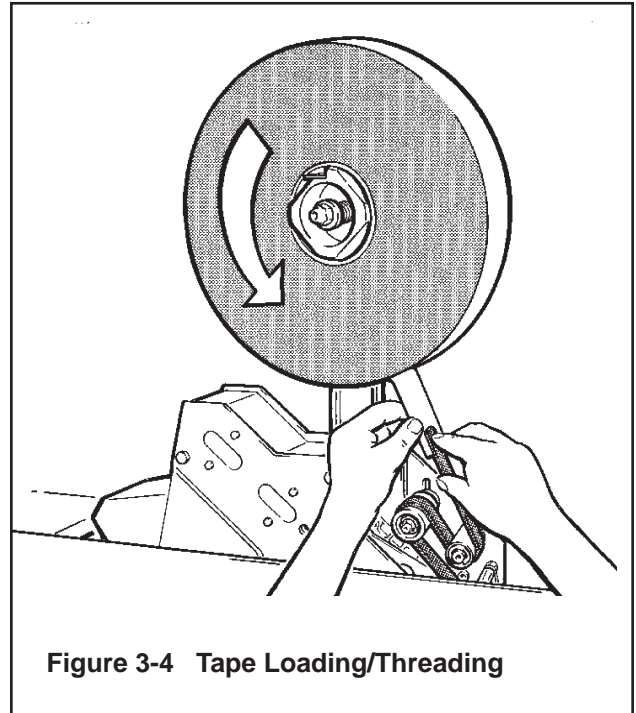


Figure 3-4 Tape Loading/Threading



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.

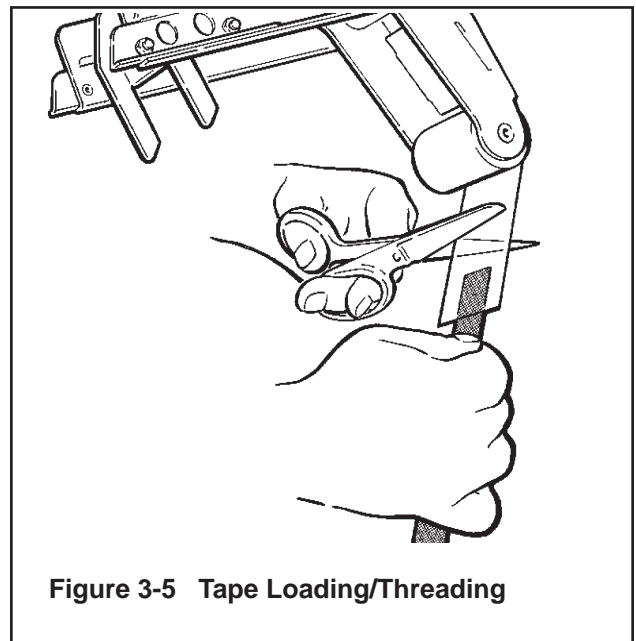


Figure 3-5 Tape Loading/Threading



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.

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

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.



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.

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 Silicone.

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

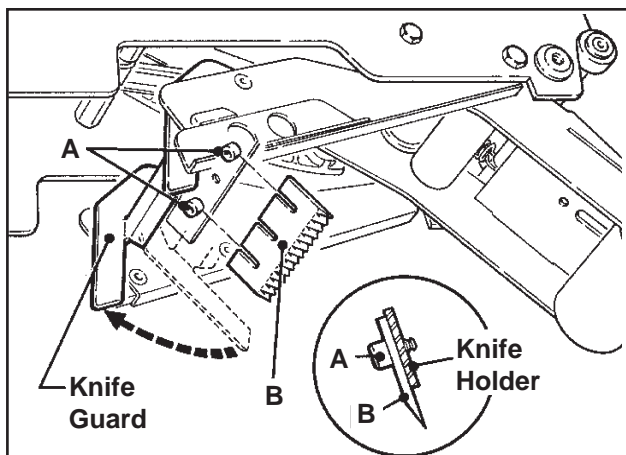


Figure 4-1 Blade Replacement

(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

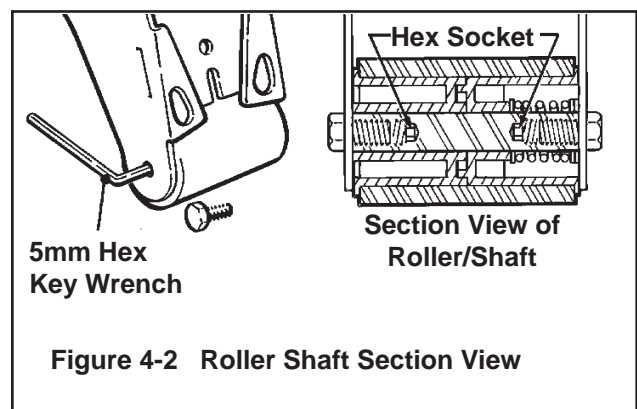
Regular slotted containers produce a great deal of dust and paper chips when conveyed through taping heads. If this dust is allowed to build-up on the heads, it can cause wear on the moving parts. Excessive dirt build-up should be wiped off with a damp cloth. Cleaning should be done once per month, depending 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**.





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 to 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.

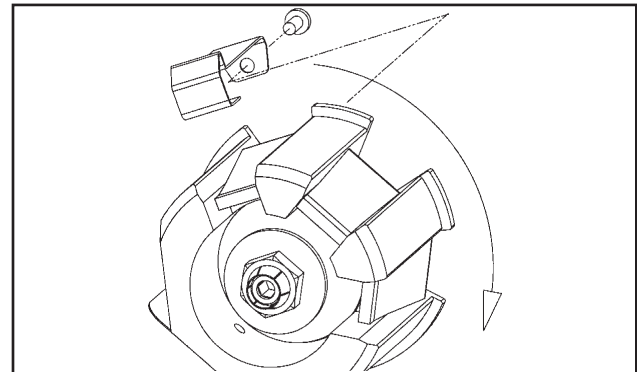


Figure 5-1 Tape Latch Alignment

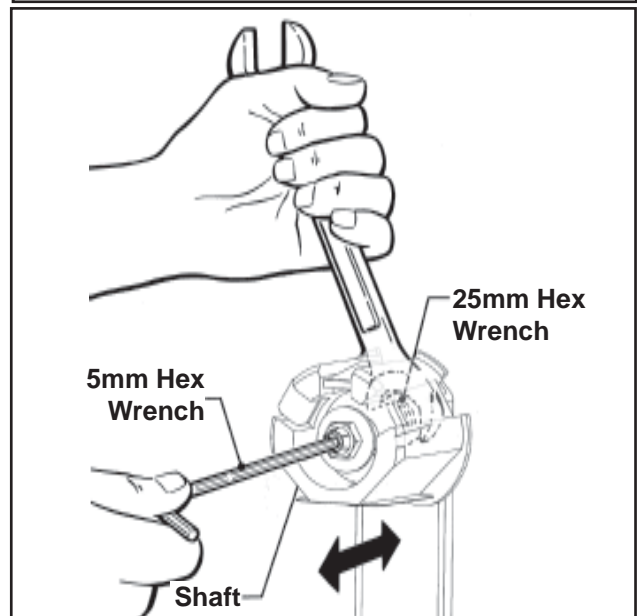


Figure 5-2 Tape Web Alignment

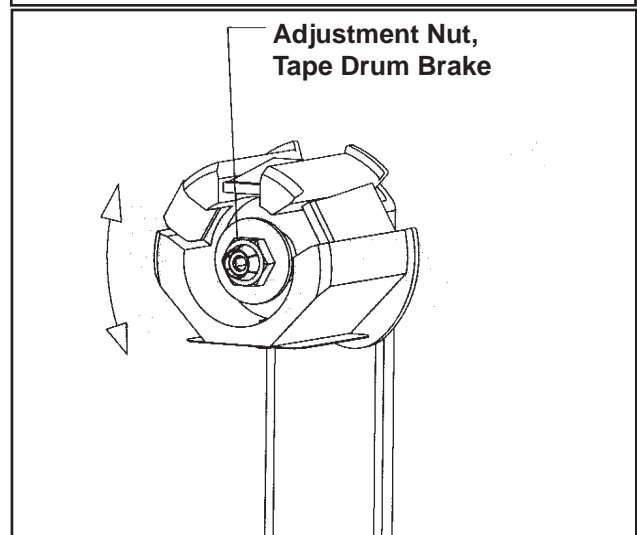


Figure 5-3 Tape Drum Friction Brake

(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.

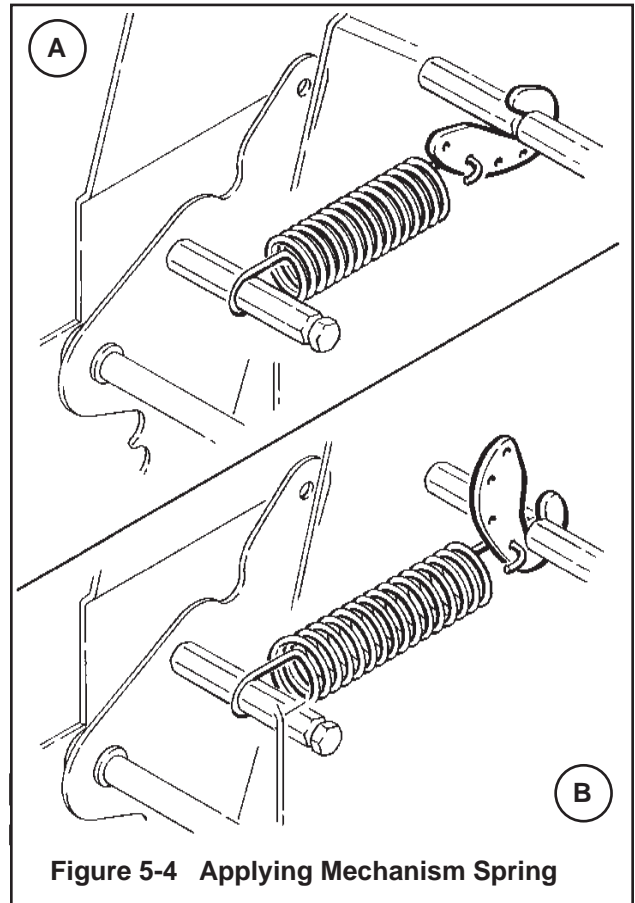


Figure 5-4 Applying Mechanism Spring

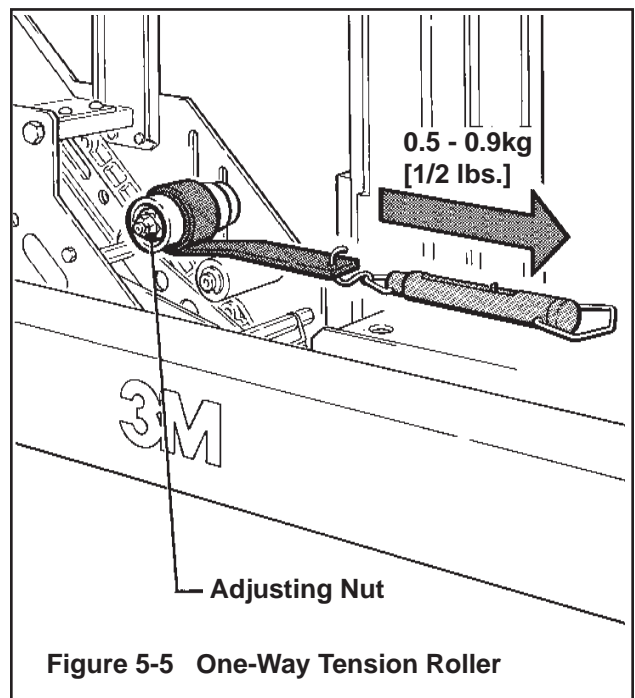


Figure 5-5 One-Way Tension Roller

(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

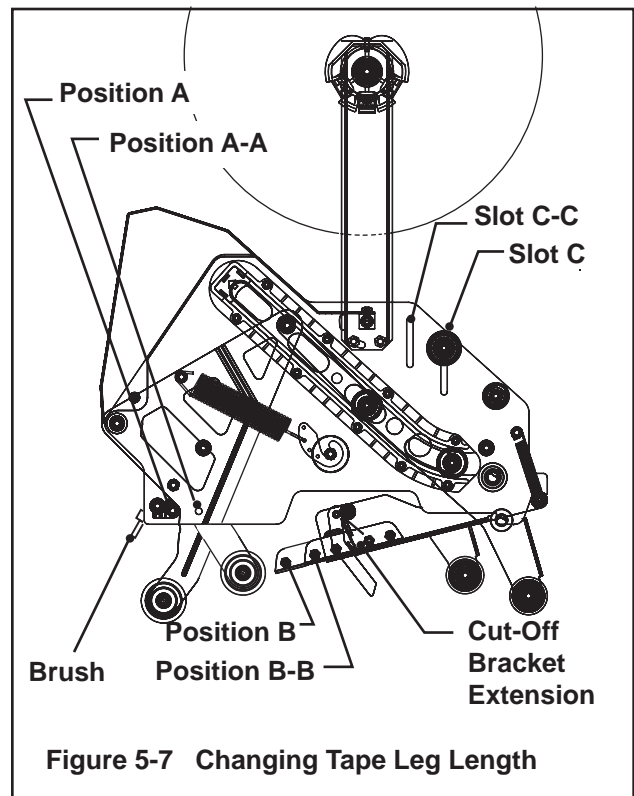
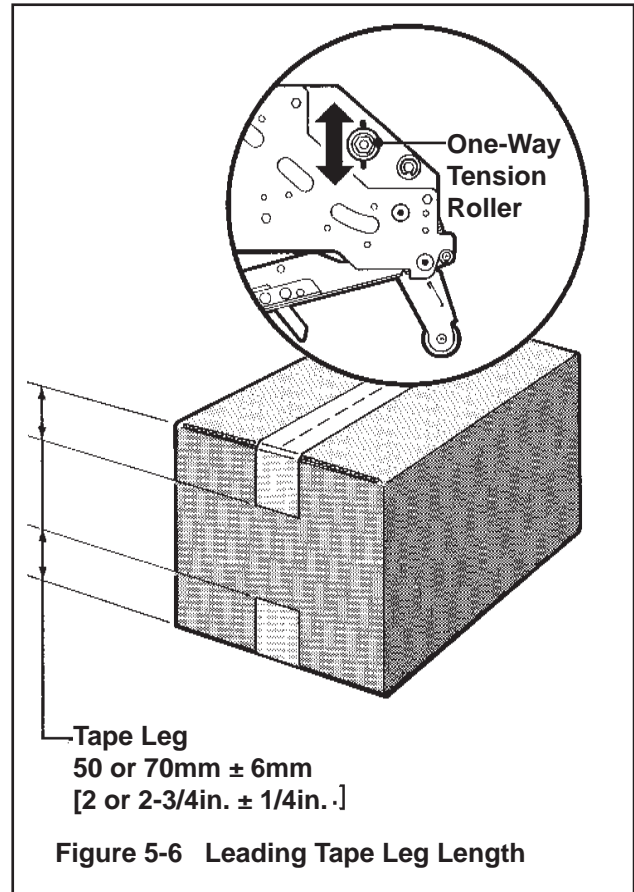
The one-way tension roller position is adjustable to control the leading tape leg length.

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.



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
The tape end does not stay in application position in front of the applying roller	Applying mechanism spring has too little tension	Move spring hook to next tighter hole
	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
Tape not centered on box seam	The one-way tension roller is defective	Replace the one-way tension roller
	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

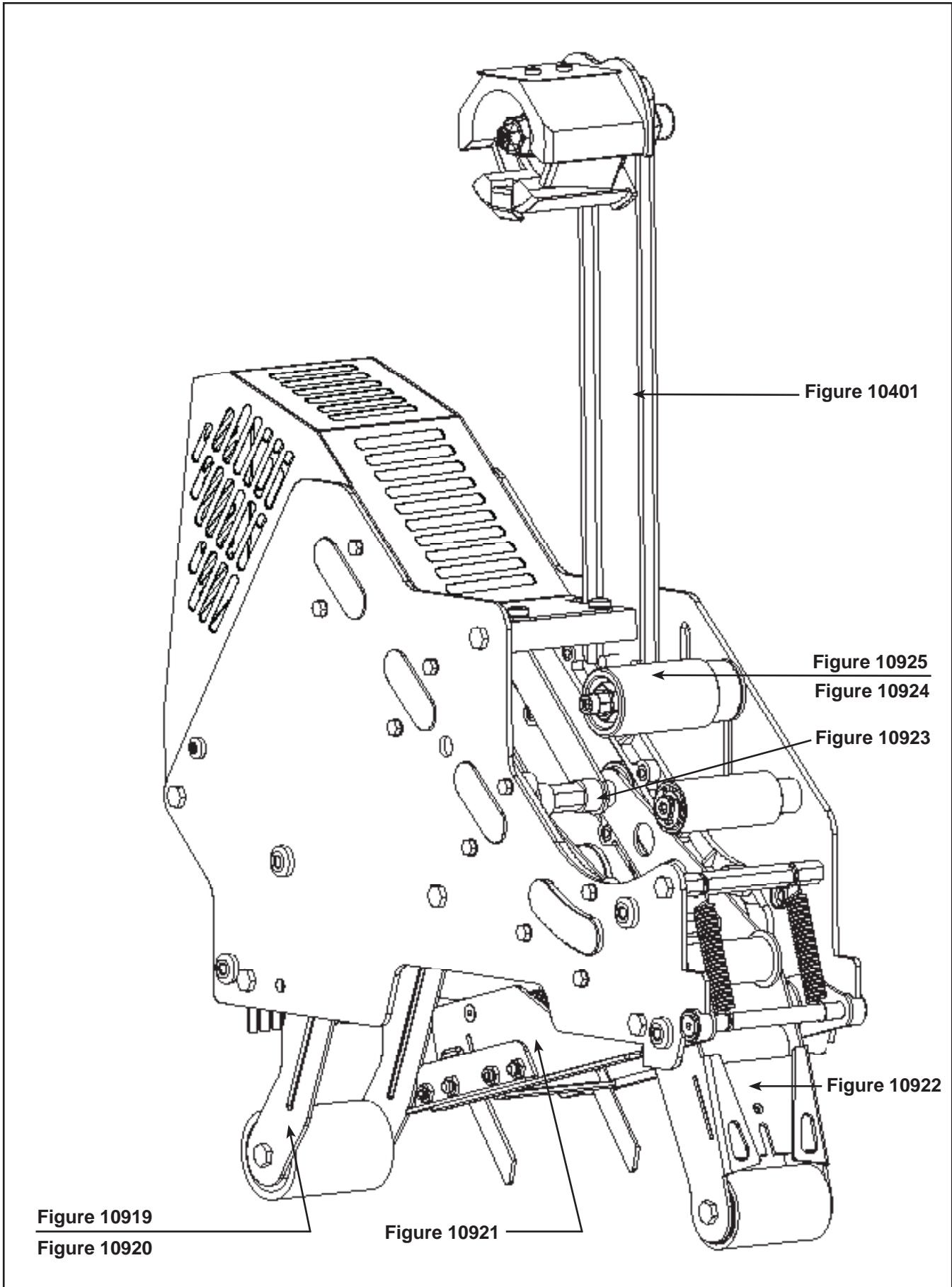
AccuGlide™ 3 High Speed 2 Inch Lower Taping Head, Type 10800

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.



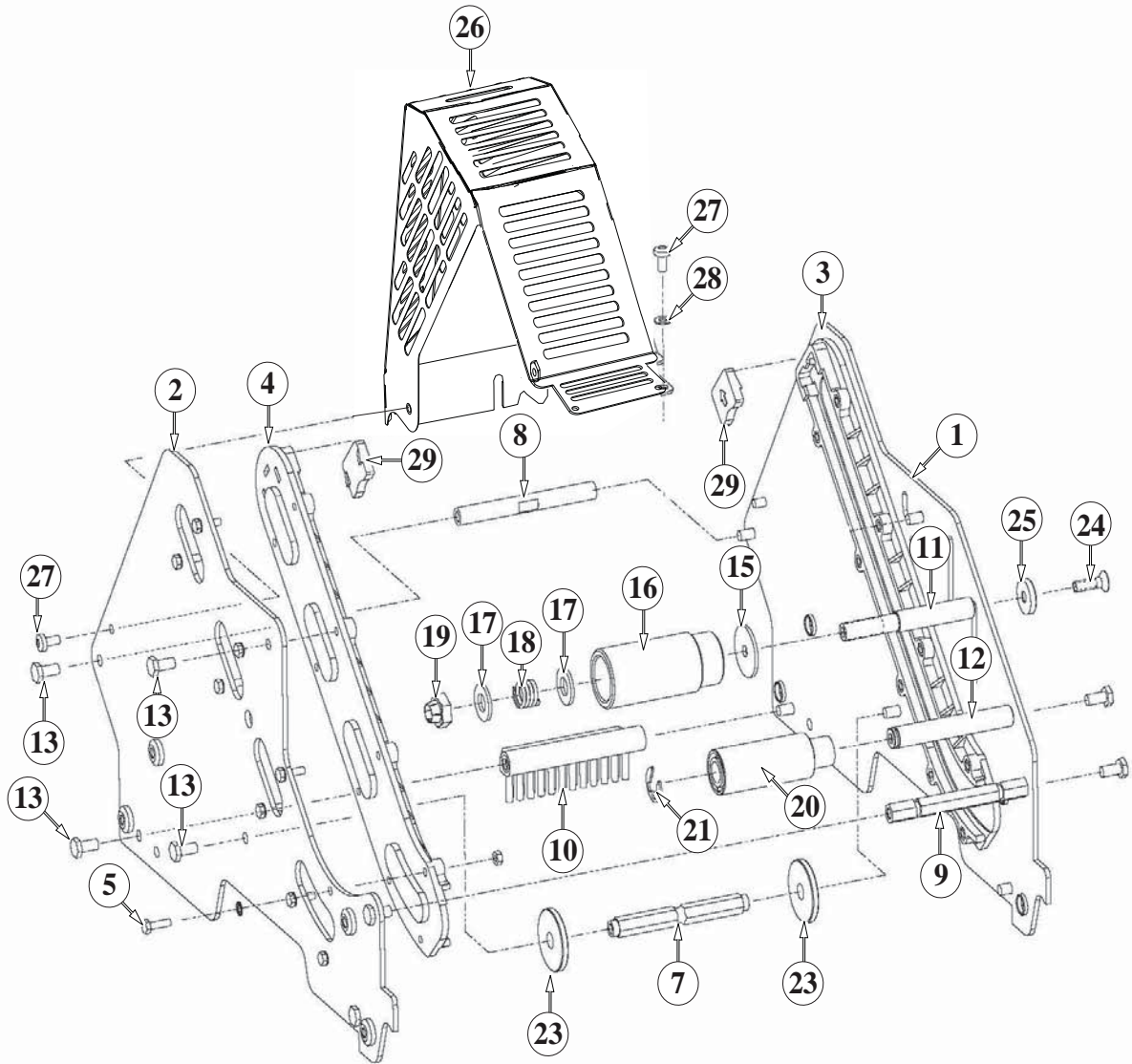


Figure 10925 – Upper Head

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

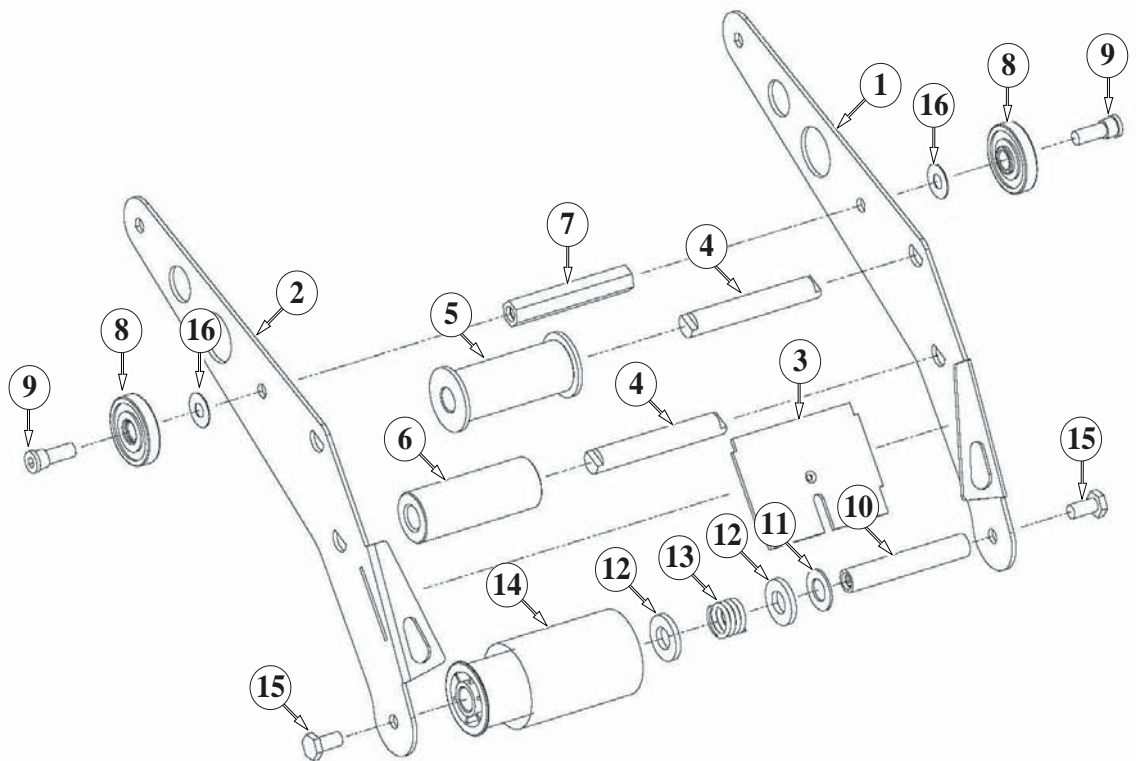


Figure 10922 – Upper and Lower Heads

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

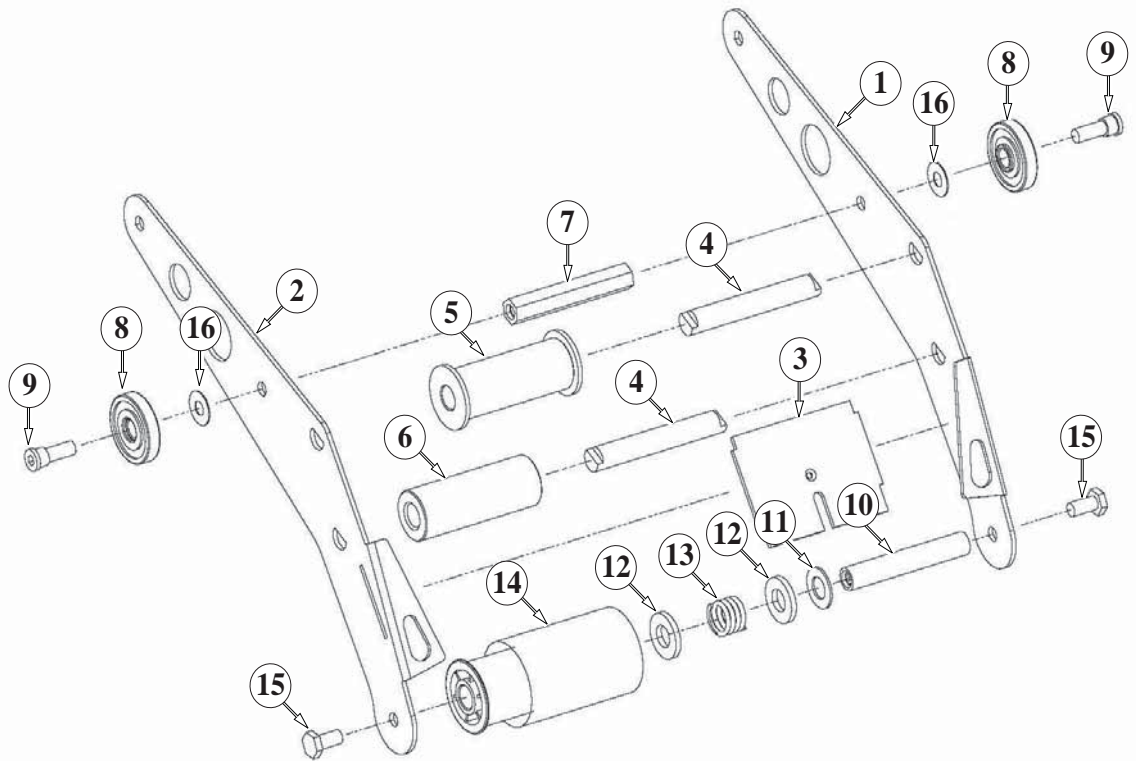


Figure 10919 – Upper Head

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

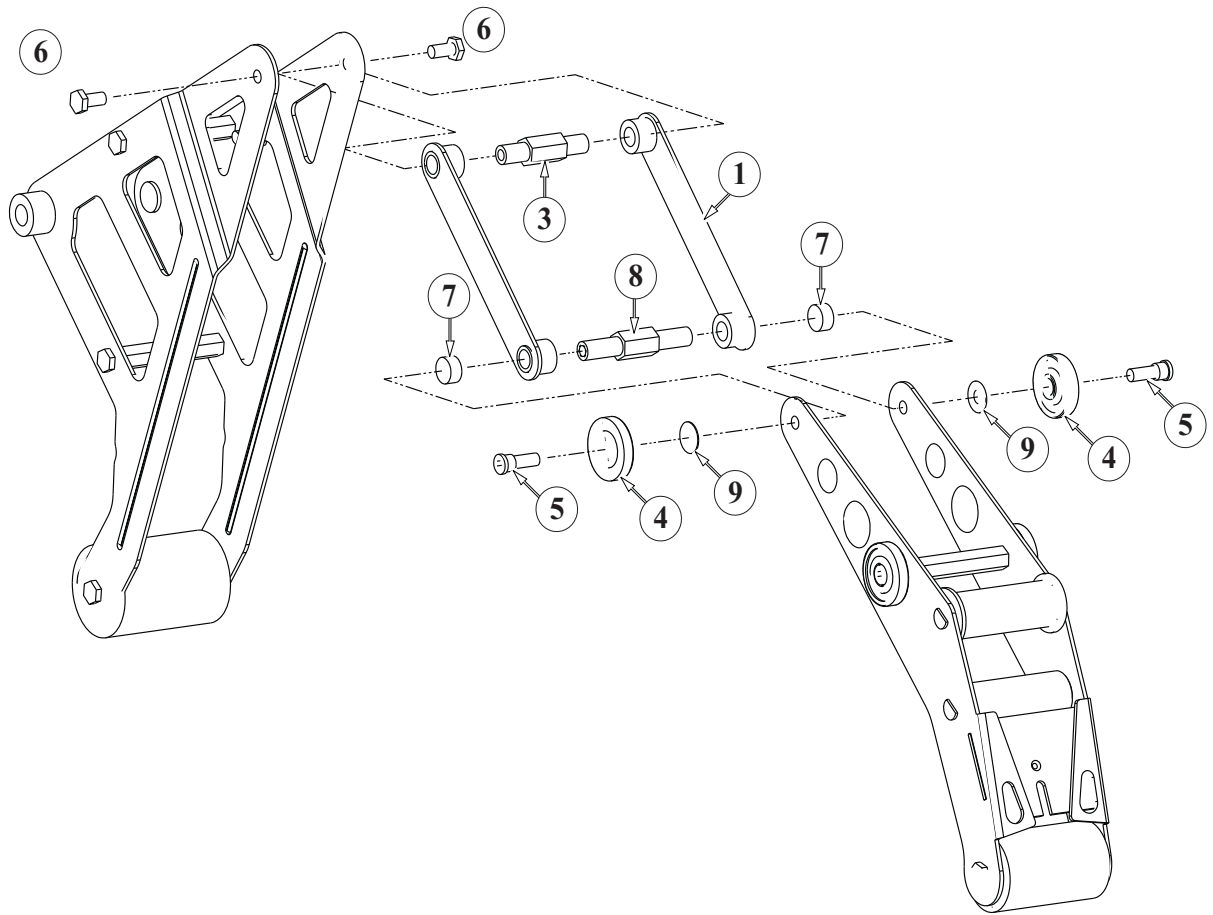


Figure 10923 – Upper and Lower Heads

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

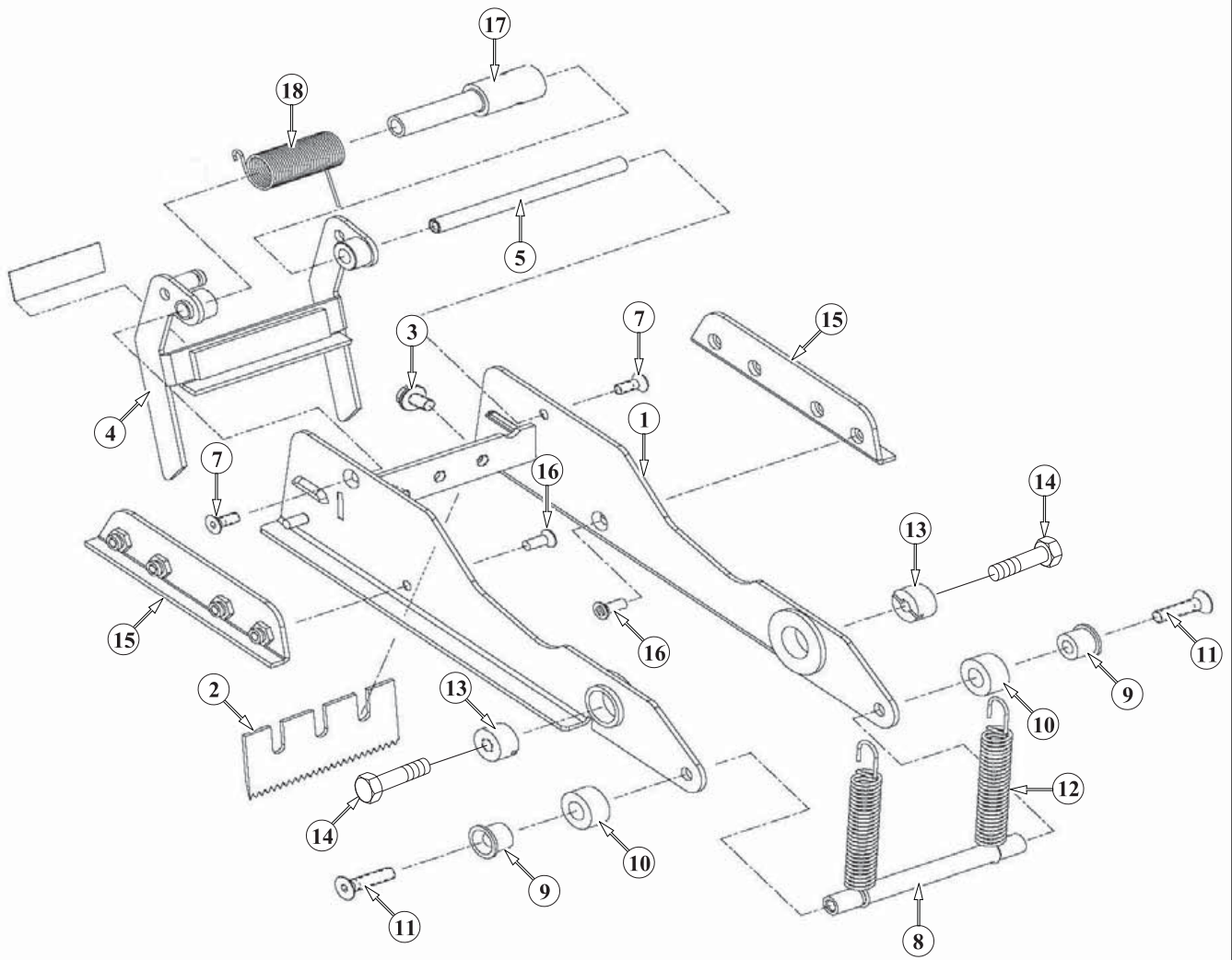


Figure 10921 – Upper and Lower Heads

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

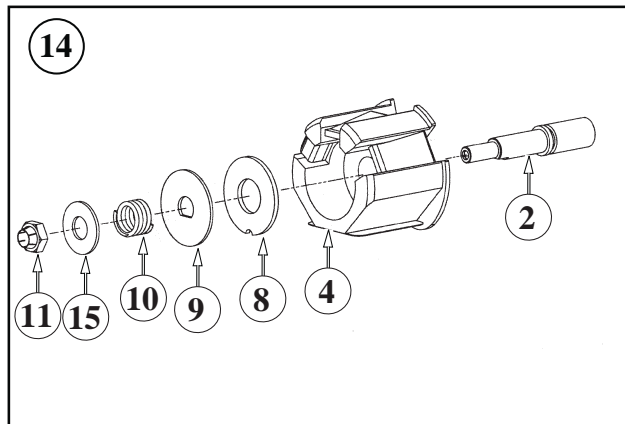
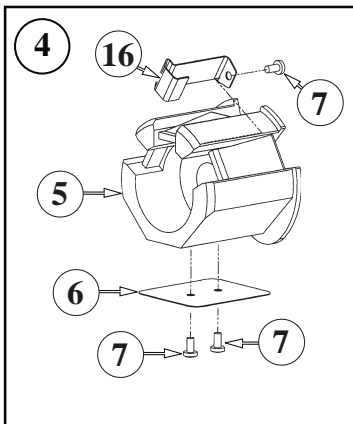
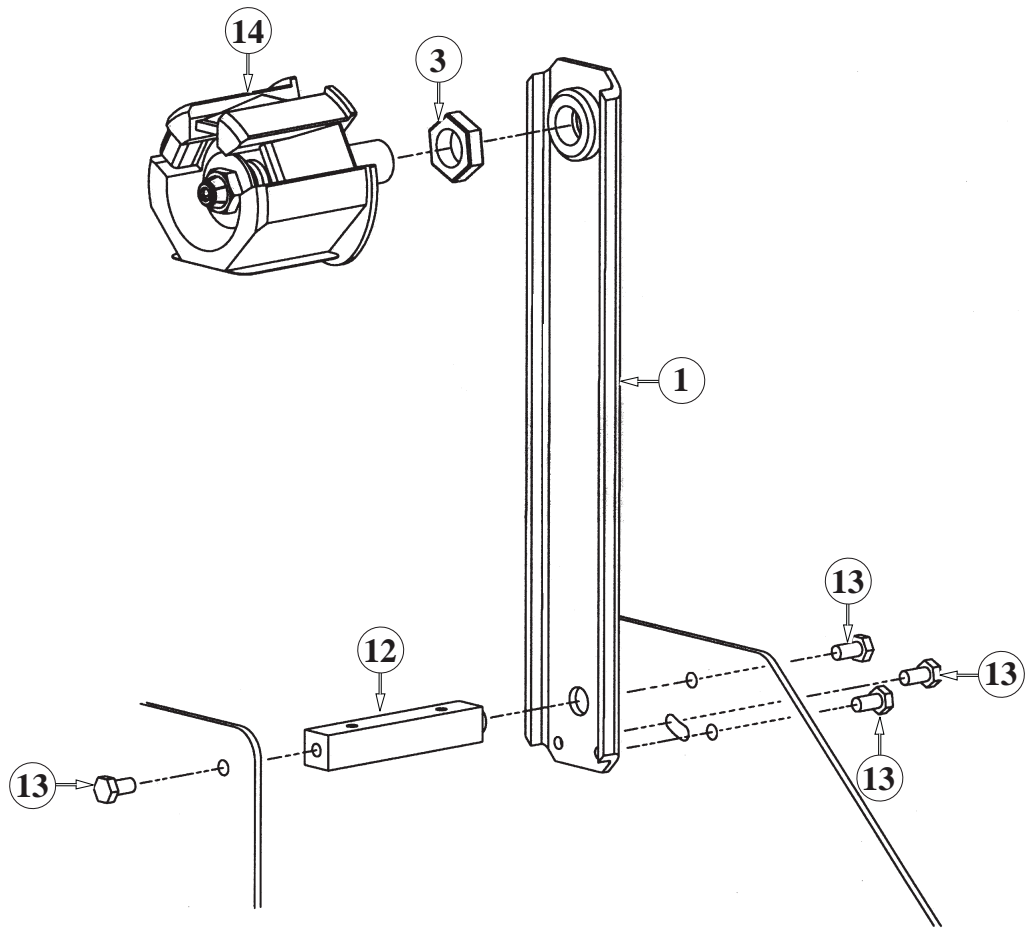


Figure 10401 – Upper and Lower Heads

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

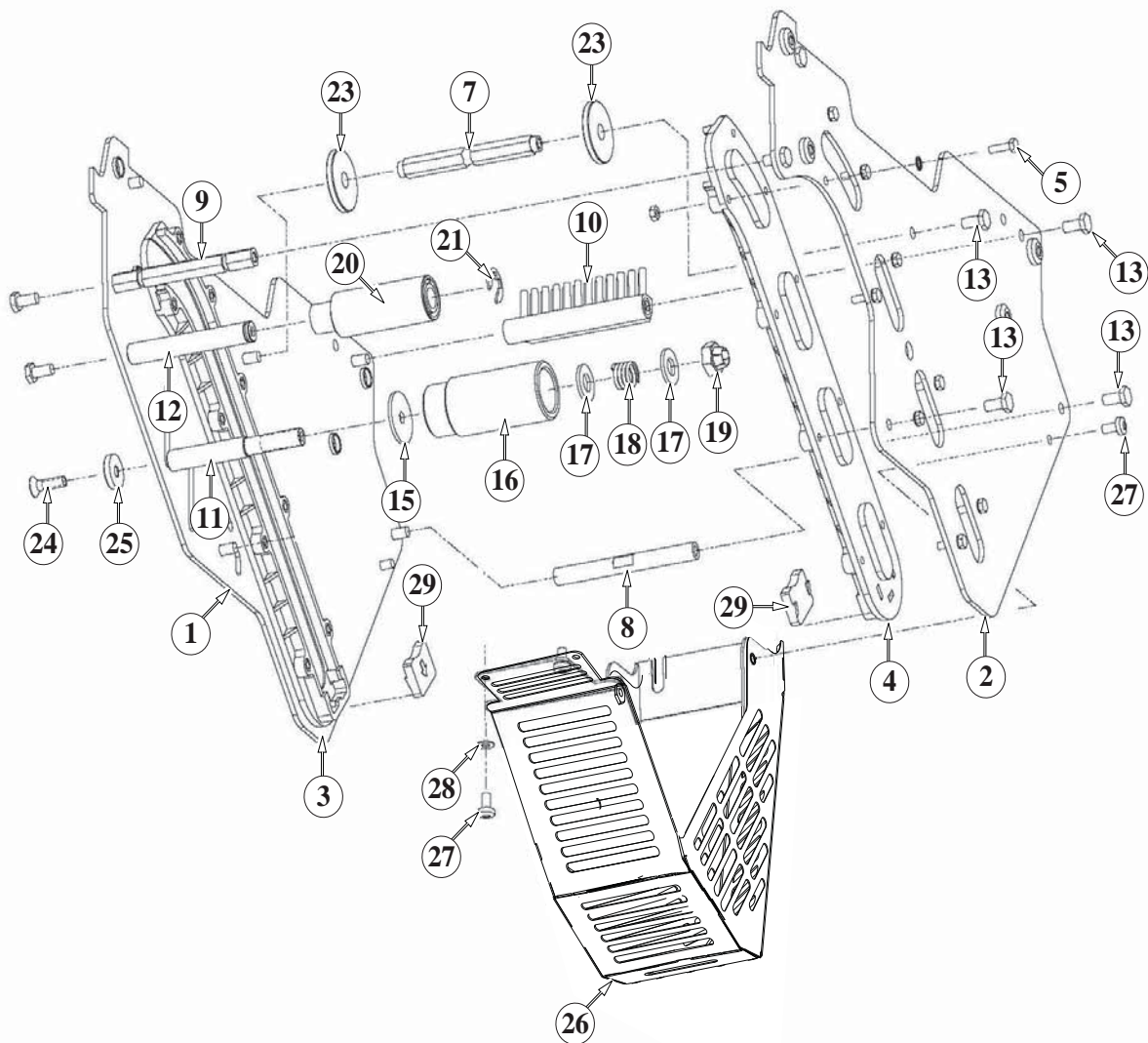


Figure 10924 – Lower Head

AccuGlide™ 3 - 2"

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

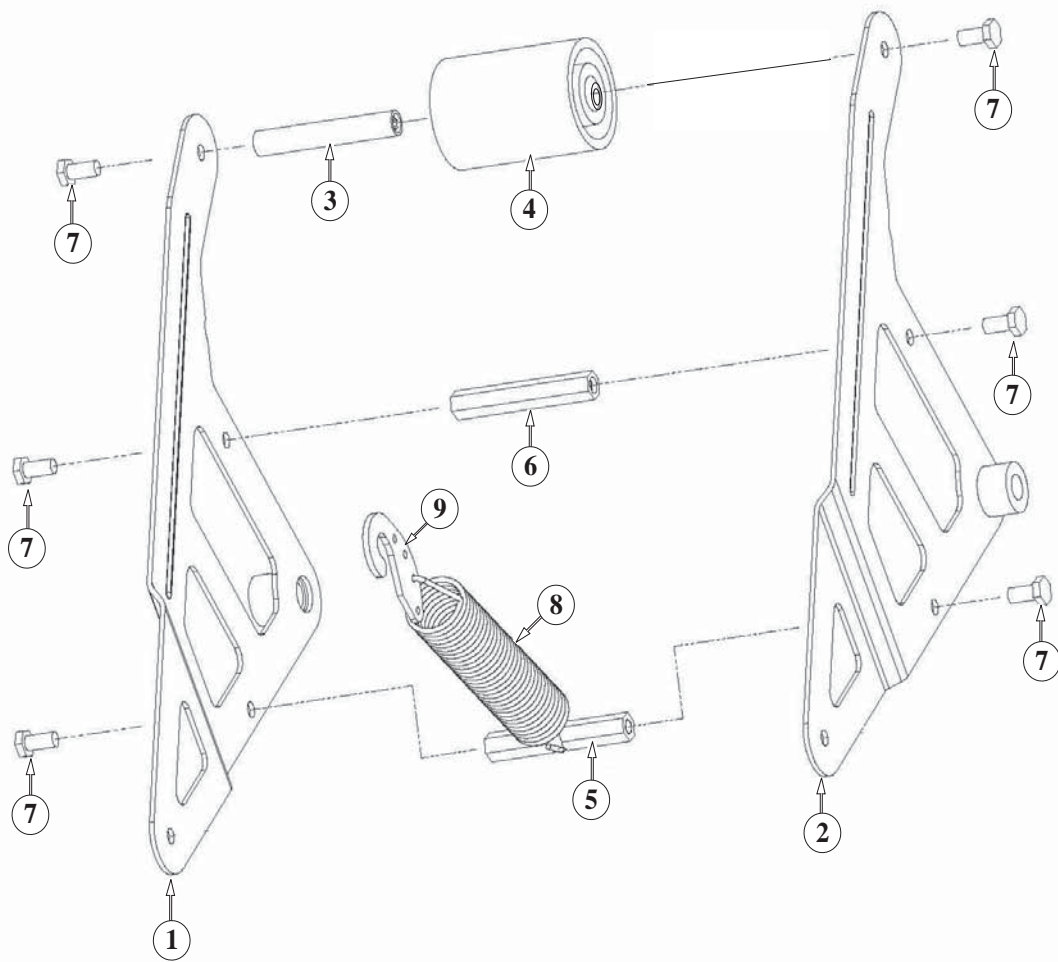


Figure 10920 – Lower Head

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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