

Instructions and Parts List

3M-Matic™

12A

Model 18600

12A3

Model 18900

Adjustable Case Sealers

with

AccuGlide

Taping Heads

Model 18500

Important
It is recommended you immediately order the spare parts listed on page 18. These parts are expected to wear through normal use, and should be kept on hand to minimize production delays.

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3M Masking and Packaging Systems Division

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

3M

To Our Customers:

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

Technical Assistance

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

Replacement Parts

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

3M/Tape Dispenser Parts

241 Venture Drive
Amery, WI 54001-1325

1-800/344 9883
FAX# 715/268 8153

Minimum billing on parts orders will be \$25.00. Replacement part prices available on request.

\$10.00 restocking charge per invoice on returned parts.

Note : Outside the U.S., contact the local 3M subsidiary for parts ordering information.



3M Packaging Systems Division

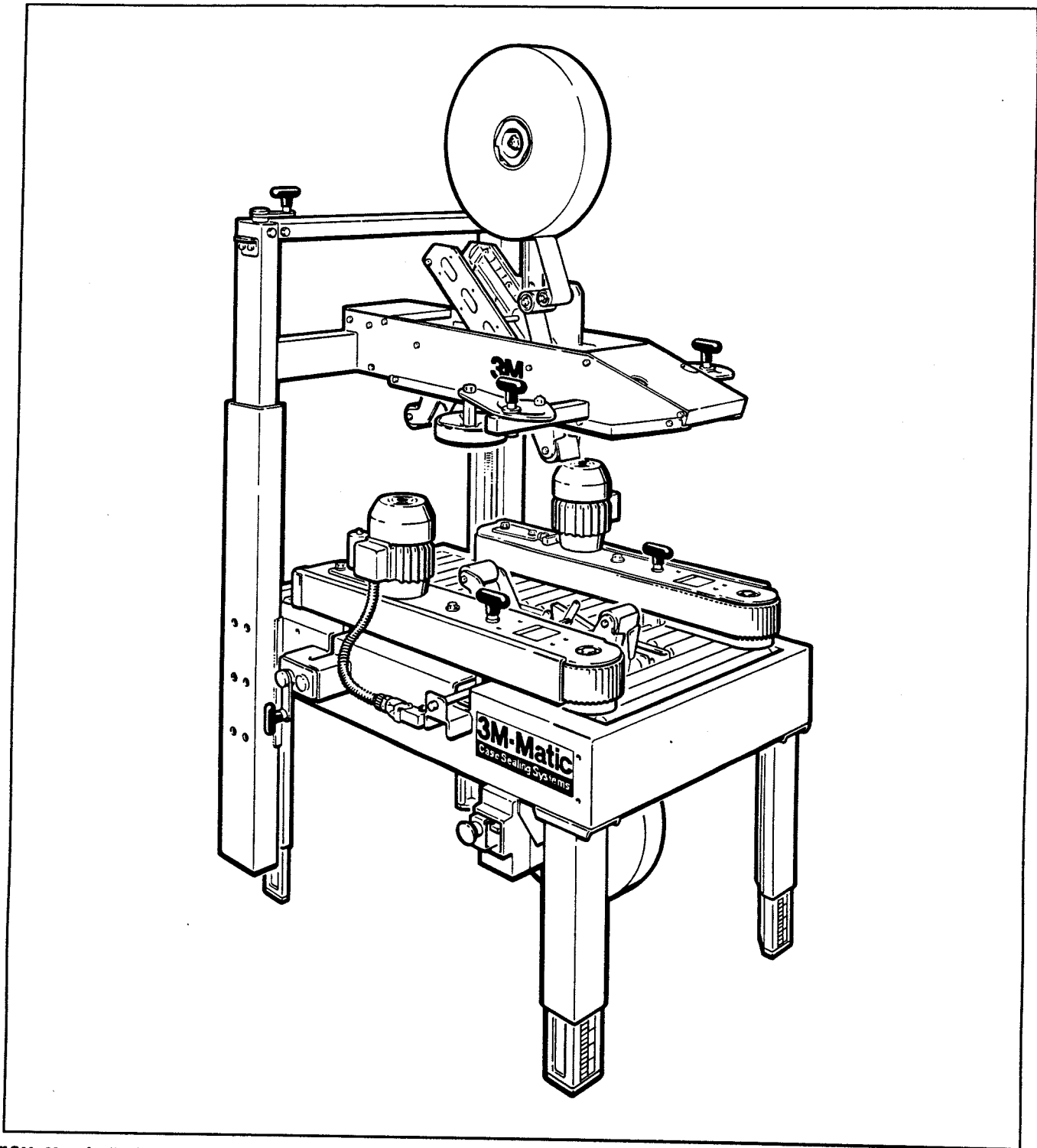
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Instruction Manual
12A Adjustable Case Sealer - Model 18600
12A3 Adjustable Case Sealer - Model 18900

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"3M-Matic" 12A Adjustable Case Sealer - Model 18600 (Shown Above)
"3M-Matic" 12A3 Adjustable Case Sealer - Model 18900

Description

The "3M-Matic" 12A Series Adjustable Case Sealers with "AccuGlide" Taping Heads are designed to apply a "C" clip of "Scotch" brand Pressure-sensitive Film Box Sealing Tape to the top and bottom center seam of regular slotted containers. The Case Sealers are manually adjustable to a wide range of box sizes (see box size specifications).

Receiving And Handling

After the machine has been uncrated, examine the case sealer for damage that might have occurred during transit. If damage is evident, file a damage claim immediately with the transportation company and also your 3M Representative. Several machine components are tied down to prevent damage during transit. Remove these before proceeding with following set-up instructions.

Equipment Warranty and Limited Remedy: THE FOLLOWING WARRANTIES ARE 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™ 12A and 12A3 Adjustable Case Sealer, Models 18600 and 18900 with the following warranties:

1. The Taping Head knife blades, 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. The motor and transmission will be free from all defects for one (1) year after delivery.
4. All other parts will be free from all defects for ninety (90) days 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.

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

Specifications

1. Power Requirements:

Electrical - 115 VAC, 60 Hz, 3,6A

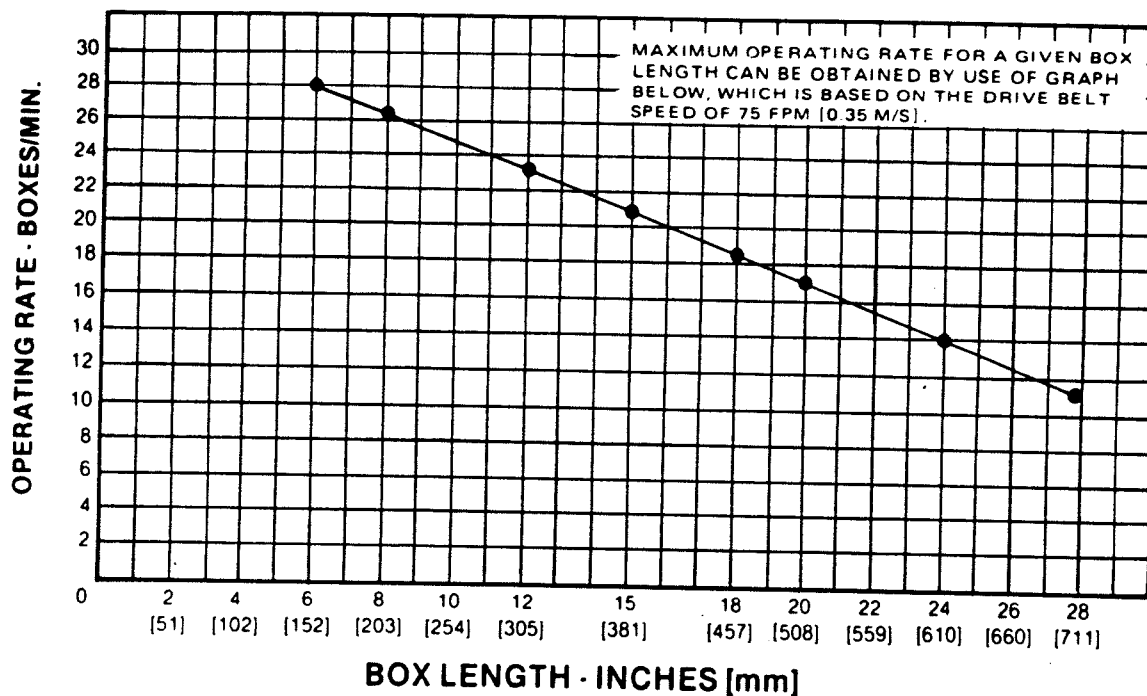
The machine is equipped with a standard neoprene covered power cord and a grounded plug. Contact your 3M Representative for power requirements not listed above.

2. Machine Dimensions:

Overall Dimensions

Length	-	36 inches [915 mm]
Width	-	30 1/2 inches [775 mm]
Height	-	51 1/2 inches [1310 mm]
Weight	-	290 pounds [130 kg] crated 250 pounds [115 kg] uncrated

3. Operating Rate:



4. Operating Conditions:

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

IMPORTANT SAFEGUARD

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

(Specifications continued on next page.)

Specifications (Continued)

5. Tape:

"Scotch" brand pressure-sensitive film box sealing tapes.

6. Tape Width:

12A - 1-1/2 inches or 36 mm minimum to 2 inches [50 mm] maximum.

12A3 - 1-1/2 inches or 36 mm minimum to 3 inches or 72 mm maximum.

7. Tape Roll Diameter:

Up to 15 inches [380 mm] maximum on a 3 inch [76,2 mm] diameter core.
(Accommodates all system roll lengths of "Scotch" brand film tapes.)

8. Tape Application Leg Length:

2-3/4 inches \pm 1/4 inch [70 mm \pm 6 mm]

9. Box Board:

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

10. Box Weight and Size Capacities:

A. Box weight, filled - up to 5 lbs. [2,3 kg] minimum, 85 lbs. [37 kg] maximum

B. Box Size:	Minimum	Maximum
Length -	6.0 inches or 150 mm	unlimited
Width -	* 4 1/2 inches or 115 mm	20 inches or 500 mm
Height -	4 3/4 inches or 120 mm	20 inches or 500 mm

* A four inch minimum width can be obtained by modifying cutter lever assembly.

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

Note: The case sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is .6 or less, then several boxes should be test run to assure proper machine performance.

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

$$\frac{\text{BOX LENGTH IN DIRECTION OF SEAL}}{\text{BOX HEIGHT}} \quad \text{MUST BE GREATER THAN } .6$$

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

Set-Up Procedure

It is recommended that the case sealer be set-up and tried before placing it in the production line. This approach will allow your thorough review and familiarization with the case sealer before subjecting it and operating personnel to a production situation where time for set-up, adjustments, and operator training usually becomes limited.

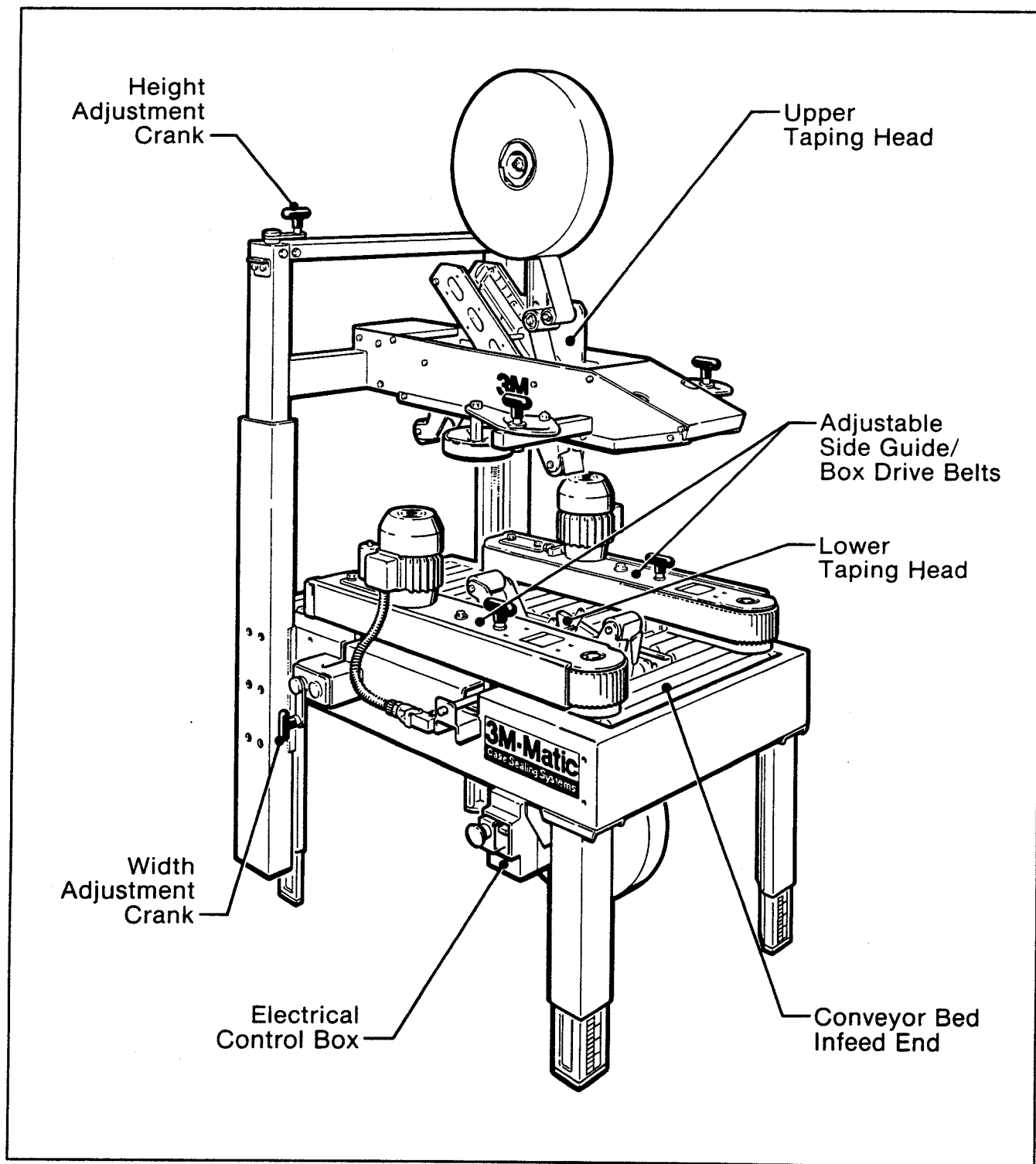


Figure 1 - Set-Up Instructions - Case Sealer Components - Left Front View

Set-Up Procedure (Continued)

Height Adjustment Crank

The height adjustment crank handle is located at the top of the frame columns as shown in Figure 1. The crank handle can be installed at the top of either frame column for customer operating convenience.

Conveyor Bed Height:

The case sealer is equipped with four adjustable legs that are located at the corners of the frame. The legs can be adjusted to obtain different machine conveyor bed heights from 21-1/2 inches [545 mm] minimum to 30 inches [760 mm] maximum.

The recommended minimum machine conveyor bed height (measured from floor) is 24 inches [610 mm].

Refer to Figure 2A and set the conveyor bed height as follows:

1. Block up the machine frame to allow adequate leg adjustment.
2. Loosen, but do not remove, two M8 x 16 mm socket head screws in one leg. Adjust the leg length for the desired conveyor bed height. Retighten the two screws to secure the leg. Adjust all four legs as noted.

The tape drum bracket assembly, located on the bottom taping head, has two mounting positions to allow maximum tape roll capacity through the machine conveyor bed height range.

For conveyor bed heights 24 inches and above, use mounting position shown in Figure 2B.

For conveyor bed heights below 24 inches, use mounting position shown in Figure 2C.

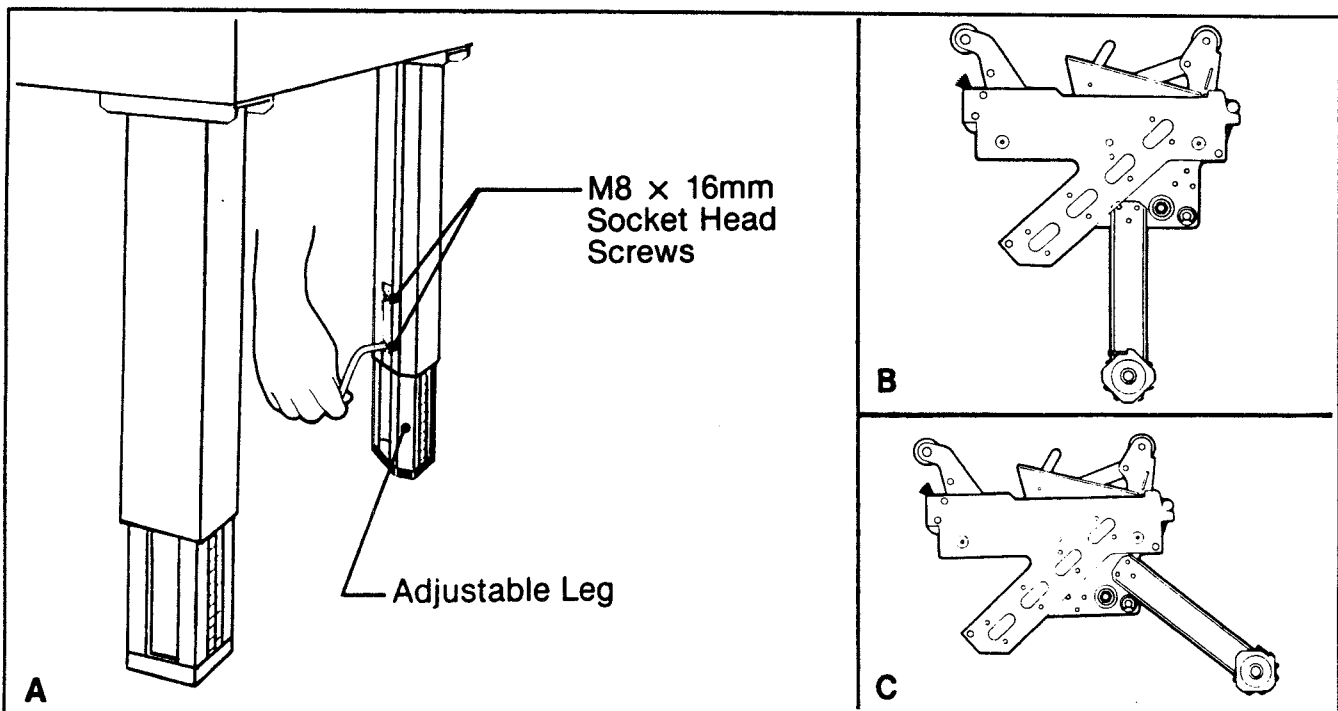


Figure 2 - Conveyor Bed Height Adjustment

Set-Up Procedure (Continued)

Electrical Connection

The electrical control box, shown in Figure 1, contains the "On-Off" switch with pre-set circuit breaker and can be located on either side of the main conveyor for customer operating convenience. A standard three conductor power cord with plug is provided at the back of the electrical control box for 115 Volt, 60 Hz electrical service. The receptacle providing this service shall be properly grounded. Before the power cord is plugged into 115 Volt, 60 Hz outlet, make sure the switch is "Off" and that all packaging materials and tools are removed from the machine.

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

IMPORTANT SAFEGUARDS

1. BOTH THE TOP AND BOTTOM TAPING HEADS UTILIZE EXTREMELY SHARP KNIFE BLADES ON THE ORANGE CUTTER LEVER ASSEMBLY AND WHICH ARE LOCATED UNDER THE BLADE GUARD WHICH HAS THE "WARNING - SHARP KNIFE" LABEL. BEFORE WORKING WITH THE TAPING HEADS OR ATTEMPTING TO LOAD THE TAPE, REFER TO FIGURES 3 and 3A AND IDENTIFY THE BLADE LOCATION. KEEP HANDS OUT OF THESE AREAS EXCEPT AS NECESSARY TO SERVICE THE TAPING HEADS.
2. NEVER ATTEMPT TO WORK ON THE TAPING HEADS OR LOAD TAPE WHEN THE BOX DRIVE BELTS ARE RUNNING.
3. BOX DRIVE MOTORS ARE DESIGNED TO RUN AT A MODERATE TEMPERATURE OF 120° F [49° C]. IN SOME CASES THEY MAY FEEL WARM TO THE TOUCH.

Tape Loading

The taping heads have been pre-set to accommodate 2 inch [50 mm] wide tape rolls. 12A - to apply 1-1/2 inch or 36 mm or 1-3/4 inch or 42 mm wide tapes; 12A3 - to apply 1-1/2 inch or 36 mm, 1-3/4 inch or 42 mm, 3 inch or 72 mm, refer to "Adjustments" Section for set-up information. Two temporary threading needles are shipped in threaded position for initial tape loading convenience.

Retain the threading needles for continued use in the tape loading operation. For operator assistance, a threading diagram has been applied to the taping heads. However, it is recommended that the more detailed instructions and sketches in this manual be referred to the first few times the unit is loaded until the operator becomes thoroughly familiar with the tape loading operation. The bottom taping head can be removed from unit by lifting out for convenience in tape loading.

Tape Loading - Top Taping Head

⚠ WARNING - NEVER WORK ON THE TAPING HEADS OR LOAD TAPE WHEN THE BOX DRIVE BELTS ARE RUNNING. PERSONNEL INJURY OR EQUIPMENT DAMAGE CAN POTENTIALLY RESULT.

1. It is first necessary to raise the top taping head. Utilize the height adjustment crank and move the top taping head to the fully raised position.
2. With the temporary threading needle already in position, as shown in Figure 3, follow the tape loading procedure from Figure 3C to complete the tape threading.

Set-Up Procedure (Continued)

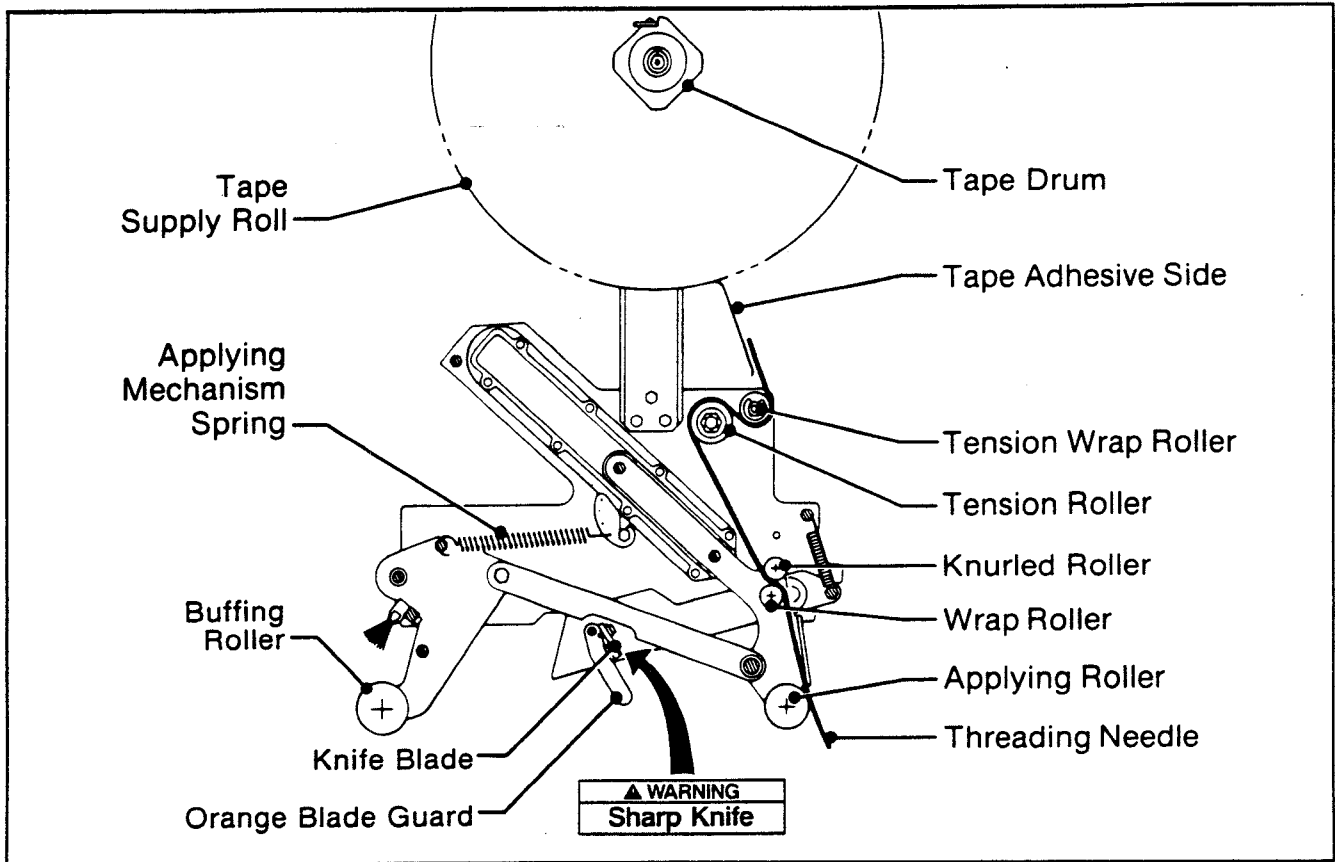


Figure 3 - Tape Threading Diagram - Top Taping Head - Left Side View

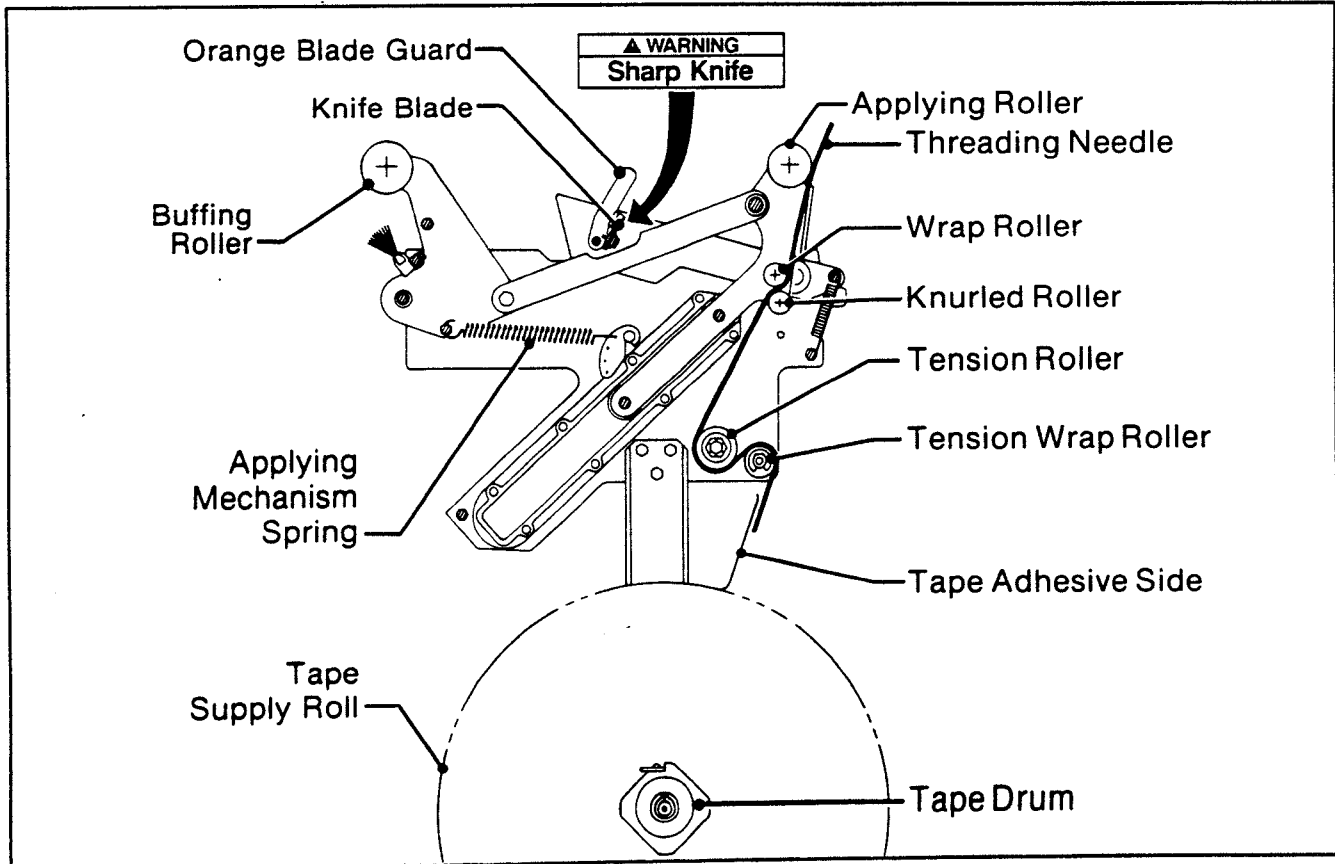


Figure 3A - Tape Threading Diagram - Bottom Taping Head - Left Side View

Set-Up Procedure (Continued)

3. For subsequent tape loading operations, use the red plastic threading needle and follow the loading procedures from Figure 3B to complete the tape threading.

Tape Loading - Bottom Taping Head Refer to Figure 3A

The bottom taping head is loaded and threaded in the same manner as the top taping head.

For ease in loading, first remove the bottom taping head from the conveyor bed and follow the top taping head tape loading procedure.

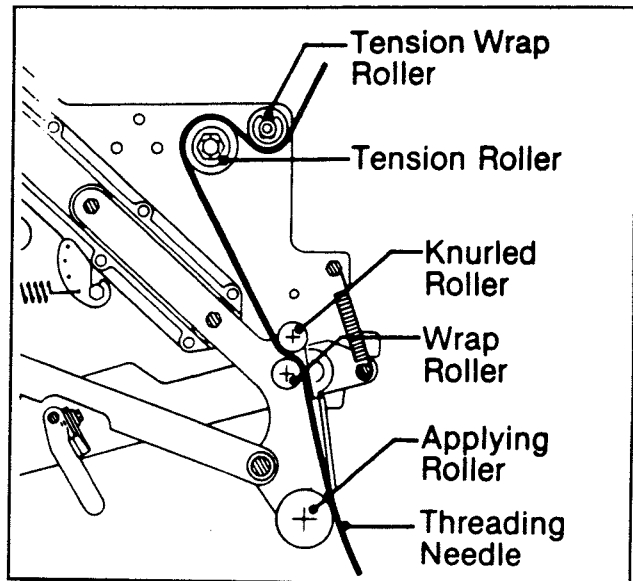


Figure 3B

Figure 3B

Insert the red plastic needle downward around rollers as illustrated.

Figures 3B and 3C

Place tape roll on drum to dispense tape from bottom of roll toward tension wrap roller with tape adhesive side in. Seat tape roll fully against back flange of drum. Adhere tape lead end to upper end of threading needle as shown.

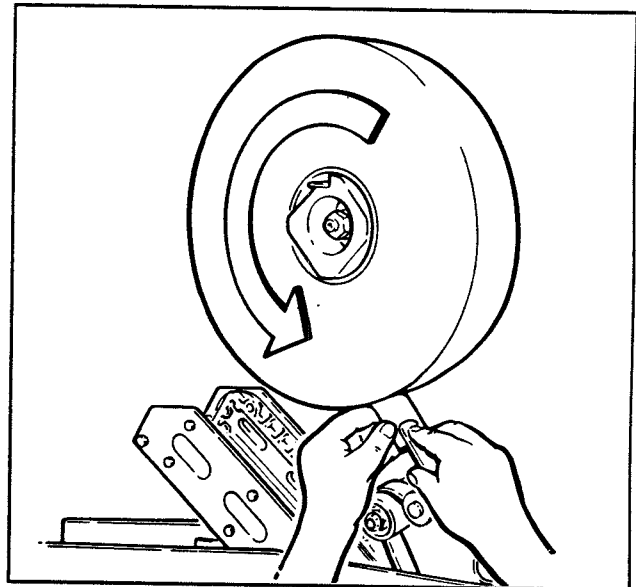


Figure 3C

Figure 3D

⚠ WARNING - USE CARE WHEN WORKING NEAR BLADES AS BLADES ARE EXTREMELY SHARP. IF CARE IS NOT TAKEN, SEVERE INJURY TO PERSONNEL COULD RESULT.

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 or knife at applying roller.

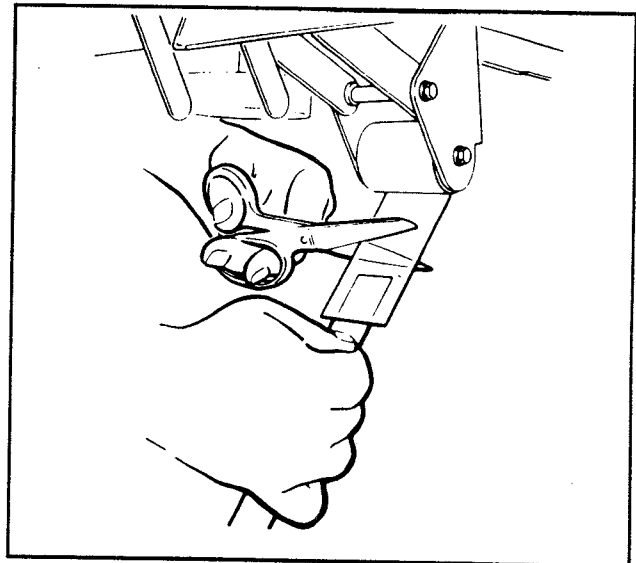


Figure 3D

Set-Up Procedure (Continued)

Box Set-Up

Figure 4

Place a product filled box on infeed conveyor bed with top flaps folded as shown and manually move box forward to contact bottom taping head applying roller.

Turn hand adjustment crank to position both side drive belts against sides of box. Tighten knobs located on top of both side drive belts to secure in operating position.

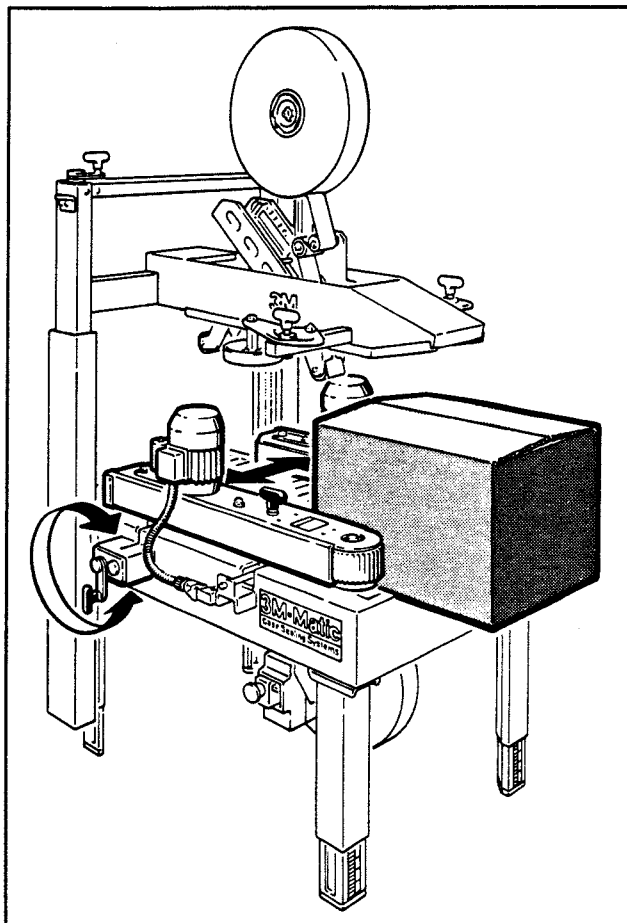


Figure 4 -Side Drive Belts

Figure 5

Turn height adjustment crank to position top taping head assembly onto box. Top taping head must contact and hold top box flaps fully closed.

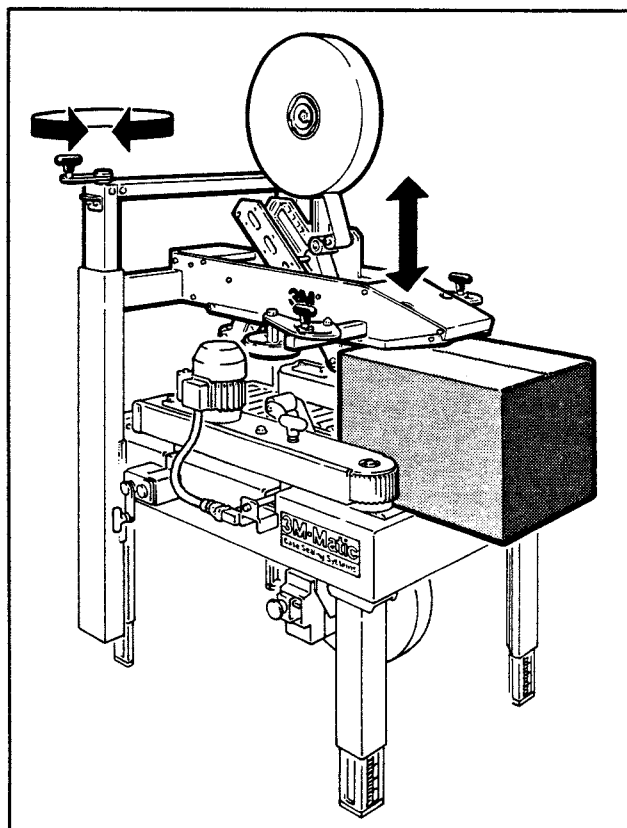


Figure 5 - Top Taping Head

Set-Up Procedure (Continued)

Figure 6

The top flap compression rollers have an adjustable slide mounting to provide side compression through the full range of box widths.

Manually move box forward so front of box is aligned with top flap compression rollers.

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

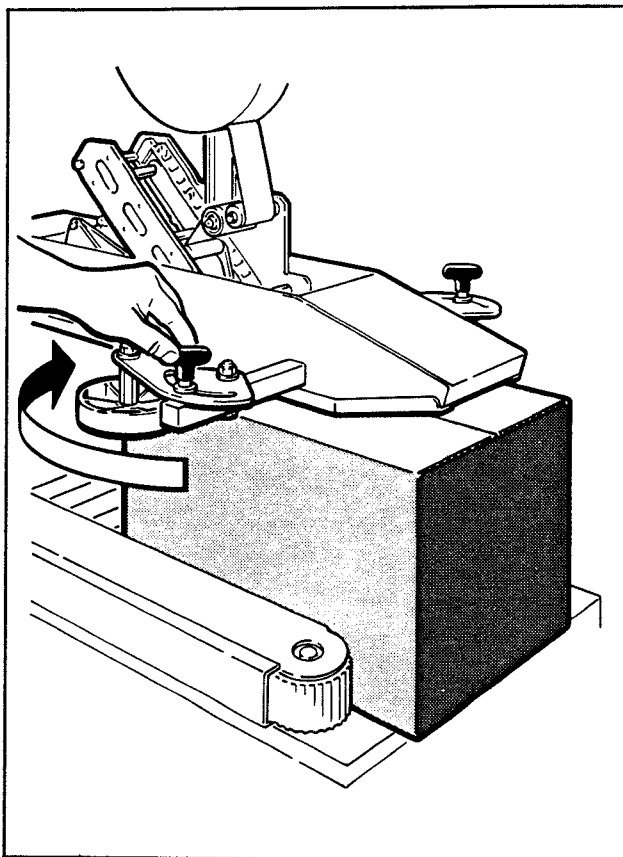


Figure 6 - Top Flap Compression Rollers

Figure 7

⚠ WARNING - BE SURE ALL PACKAGING MATERIALS AND TOOLS ARE REMOVED FROM THE MACHINE BEFORE OPERATING.

Turn electrical switch to "ON" to start belts. If box is hard to move under head or is crushed, raise top head slightly. If box movement is jerky or stops under top head, increase belt pressure on side of box slightly.

⚠ CAUTION - IF DRIVE BELTS ARE ALLOWED TO SLIP ON BOX, EXCESSIVE BELT WEAR WILL OCCUR.

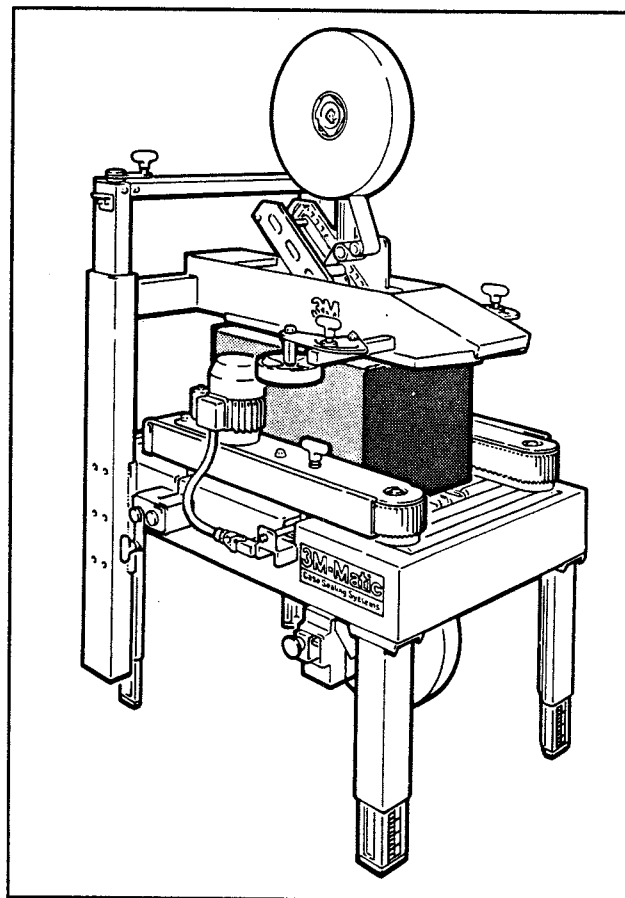


Figure 7

Adjustments

Tape Web Alignment

Refer to Figure 8

The tape drum assembly on each taping head is pre-set to accommodate 2 inch [50 mm] wide tape, but is adjustable to provide alignment of narrower tapes. If adjustment is necessary to center the tape width on the centerline of the taping head, (and therefore box center seam), make adjustment as follows:

1. Loosen hand knob behind tape drum on tape drum shaft.
2. Turn tape drum shaft in or out to center the tape web.
3. Tighten hand knob to secure the adjustment.

No other components require adjustment for tape web alignment.

Applying Mechanism Spring

The applying mechanism spring, shown in Figures 3 and 3A, controls applying and buffing roller pressure on the box and returns the mechanism to the reset position. The spring pressure is preset, as shown in Figure 9A, for normal operation but is adjustable.

Removing the spring end loop from the spring holder and placing loop in other holes provided, as shown in Figure 9B, will decrease the spring pressure.

One-Way Tension Roller Assembly

The one-way tension roller is factory set. When replacing this assembly, the roller must have 1 lb. [0,5 kg] tangential force when turning. See Figure 10.

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 until a force of approximately 1 lb. [0,5 kg] is required to turn the roller by pulling on the spring scale.

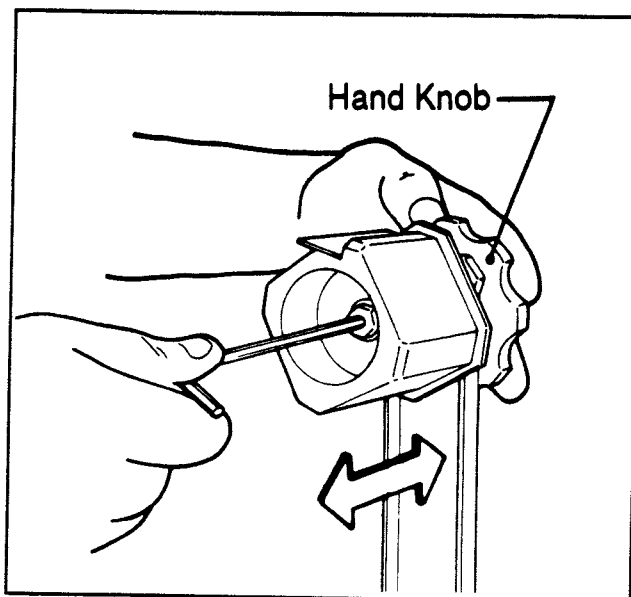


Figure 8

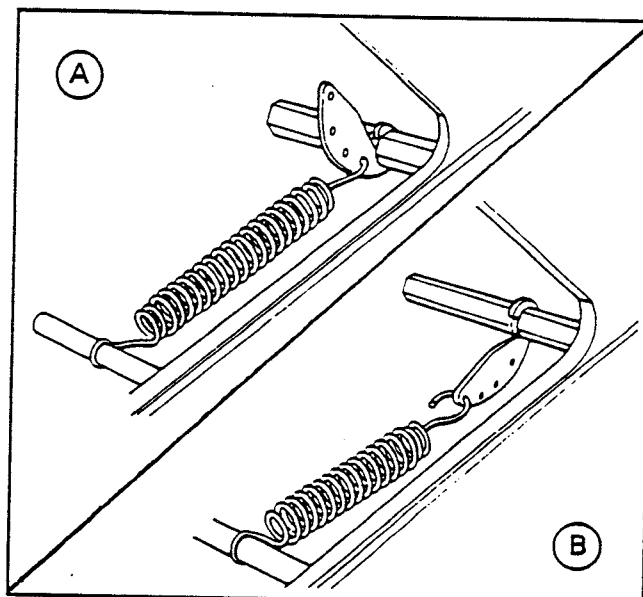


Figure 9

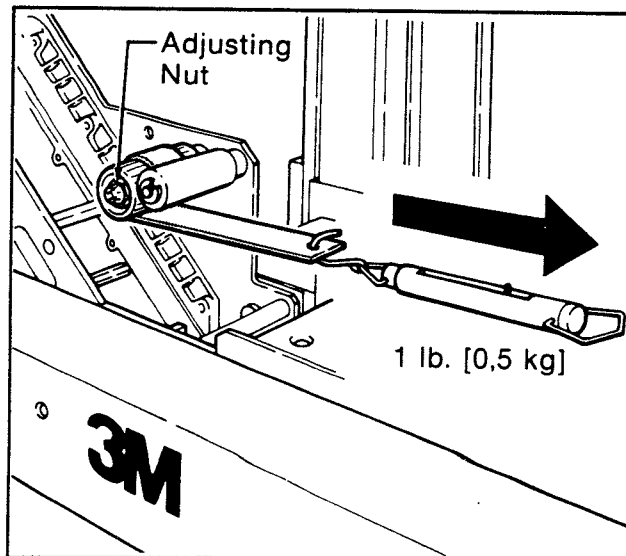


Figure 10

Maintenance

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

Tool Kit

Since the case sealer utilizes metric fasteners, a tool kit consisting of open end and hex socket wrenches is provided with the machine.

! WARNING - TURN OFF ELECTRICAL POWER SUPPLY AND DISCONNECT POWER CORD FROM ELECTRICAL SUPPLY BEFORE BEGINNING MAINTENANCE. IF POWER CORD IS NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT. USE CARE WHEN REPLACING BLADES AS BLADES ARE EXTREMELY SHARP. IF CARE IS NOT TAKEN, SEVERE INJURY TO PERSONNEL COULD RESULT.

Blade Replacement - Refer to Figure 11

1. Loosen, but do not remove, the blade screws (A). Remove and discard the old blade.
2. Mount the new blade (B) with the beveled side toward the blade holder.
3. Position the blade at an angle so all the teeth are as close as possible to the blade guard without contacting it. Tighten the blade screws to secure the blade.

NOTE - check the blade position to insure proper clearance by slowly pivoting the blade guard back.

The same steps are followed on the top and bottom taping heads. Connect the main power supply.

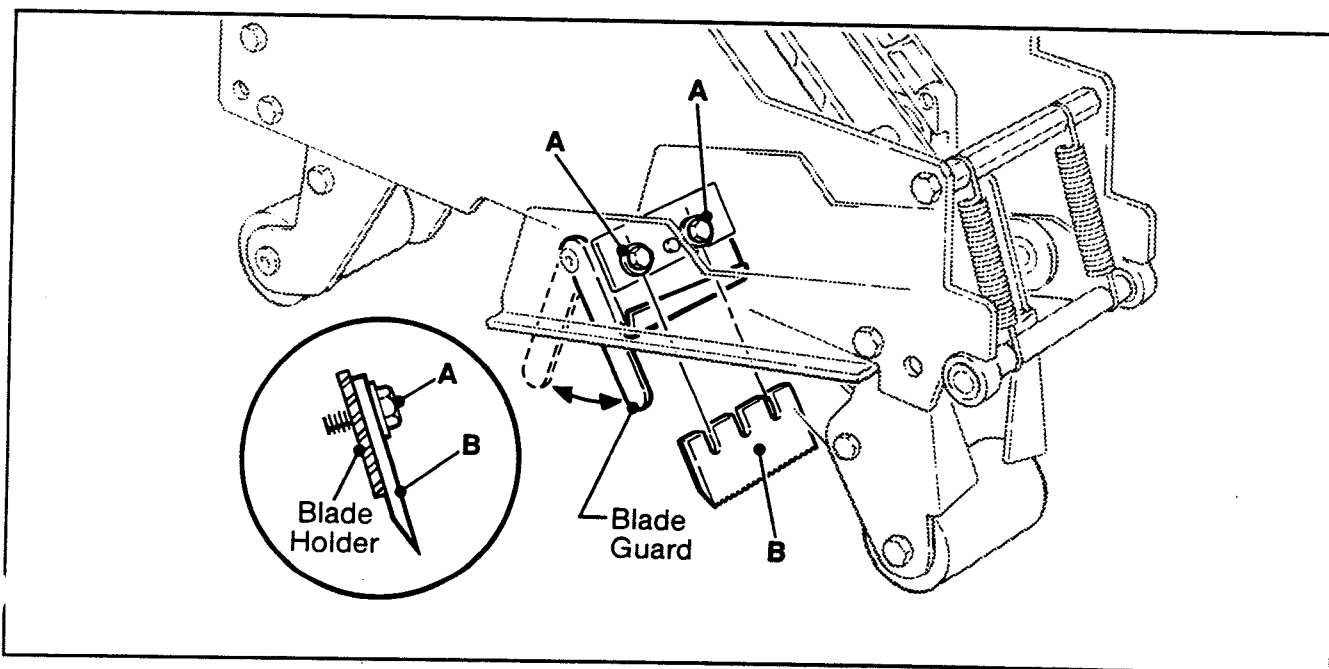


Figure 11 - Blade Replacement

Maintenance (Continued)

Box Drive Belt Replacement

⚠ WARNING - DISCONNECT ELECTRICAL POWER AND ANY SUPPLEMENTAL AIR SUPPLY BEFORE REMOVING ANY COMPONENTS.

Figure 12A

1. It is first necessary to raise the top taping head. Utilize the height adjustment crank and move the top taping head to the fully raised position.
2. Disconnect the motor plug (A).
3. Turn the side drive belt hand adjustment crank to position the belts to the maximum width position.
4. Remove and retain the three screws (B) and side cover (C).

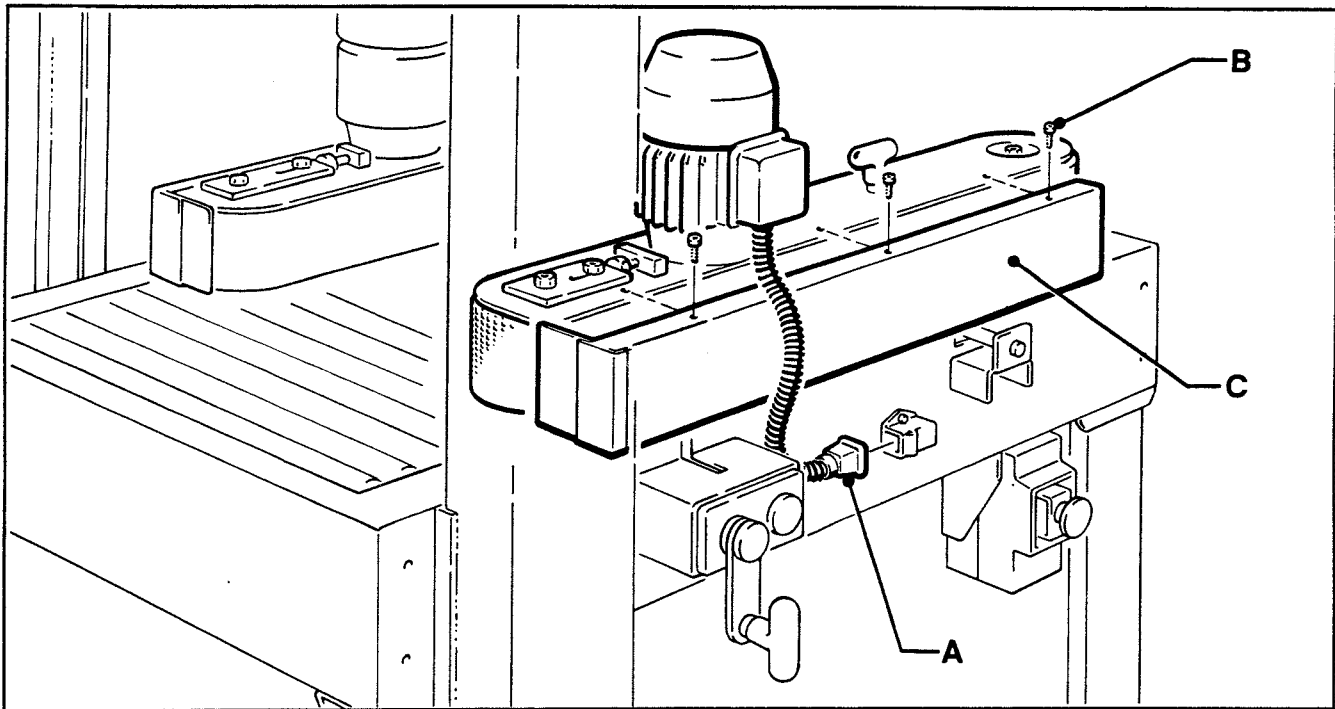


Figure 12A - Box Drive Belt - Case Sealer Left Side View Infeed End

Figure 12B

5. Loosen, but do not remove the lock nut (D) on the upper belt tension assembly.
6. Loosen, but do not remove the belt pulley shaft fasteners (E).
7. Turn the belt adjustment screws (F) clockwise and (G) counterclockwise to relieve tension on the drive belt.
8. Remove and discard old drive belt.

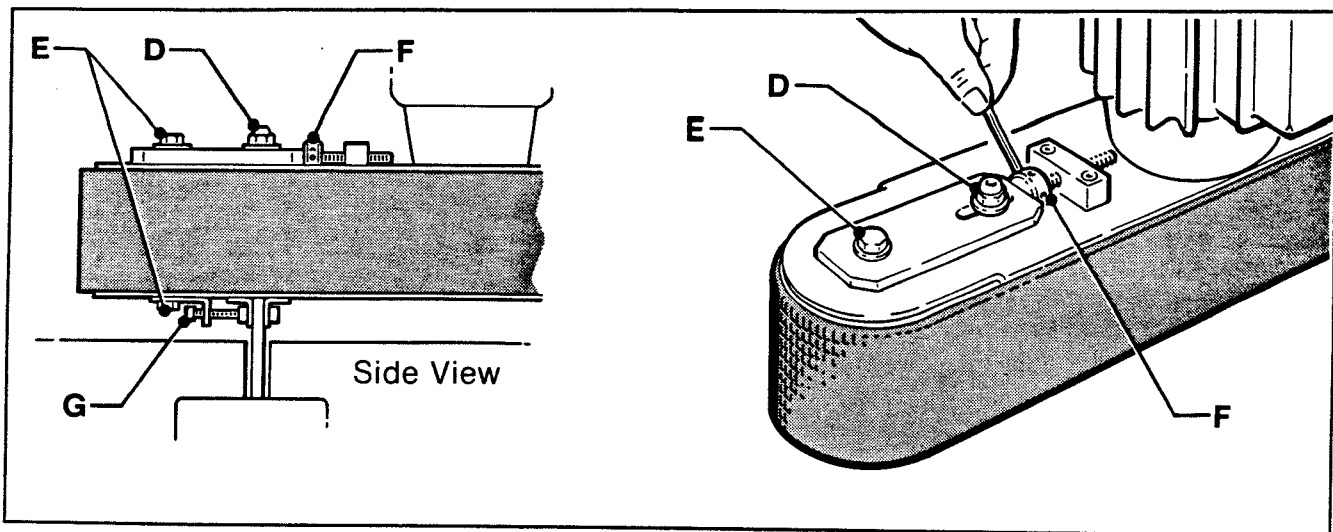


Figure 12B - Box Drive Assembly - Output End

Figure 12B and 12C

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

To Set Drive Belt Tension - Turn the adjustment screws (F) and (G) to provide equal force on both the upper and lower tension assemblies. Turn the screws clockwise to reduce belt tension, counterclockwise to increase belt tension on upper. Reverse for lower.

Note - If you decrease belt tension, be sure to push the idler pulley inward, toward the adjustment screw before tightening lock nut (D) and pulley shaft fasteners (E).

Use a force gauge to pull the belt outward one inch [25 mm] at the midspan, as shown with a pulling force of 7 lbs. [3,5 kg]. Tighten the lock nut (D) and retaining screws (E) on both tension assemblies to secure the tension setting.

10. Reverse procedures in items 1-4 above to reassemble the drive belt assembly.

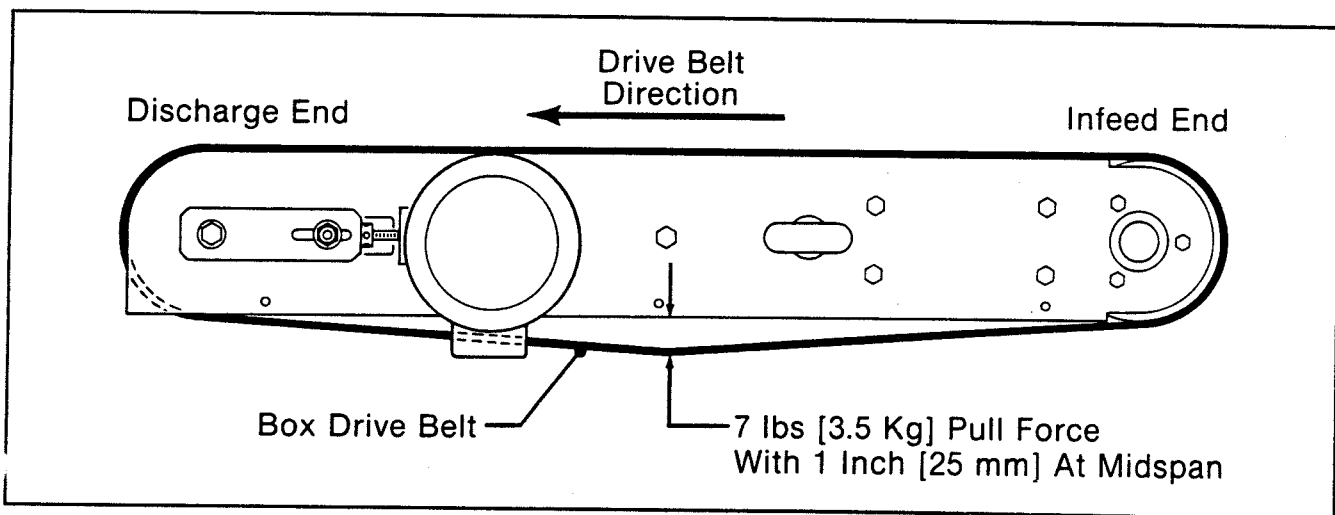


Figure 12C - Box Drive Belt Tension Adjustment - Top View

Maintenance (Continued)

Cleaning Of The Machine

⚠ CAUTION - NEVER ATTEMPT TO REMOVE DIRT BY BLOWING IT OUT WITH COMPRESSED AIR. THIS CAN CAUSE THE DIRT TO BE BLOWN INSIDE THE MOTOR, AND SLIDING SURFACES. GRITTY DIRT IN THESE AREAS CAN CAUSE SERIOUS EQUIPMENT DAMAGE. NEVER WASH DOWN OR SUBJECT EQUIPMENT TO CONDITIONS CAUSING MOISTURE CONDENSATION ON COMPONENTS. SERIOUS EQUIPMENT DAMAGE COULD RESULT.

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

Cut-Off Blade:

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

Electrical Schematic

⚠ WARNING - TURN OFF ELECTRICAL POWER SUPPLY AND DISCONNECT POWER CORD FROM ELECTRICAL SUPPLY BEFORE BEGINNING MAINTENANCE. IF POWER CORD IS NOT DISCONNECTED, PERSONNEL COULD BE EXPOSED TO DANGEROUS VOLTAGES. SEVERE INJURY OR EQUIPMENT DAMAGE COULD RESULT.

Figure 13 illustrates the electrical system of the case sealer. No adjustments to the electrical systems are required.

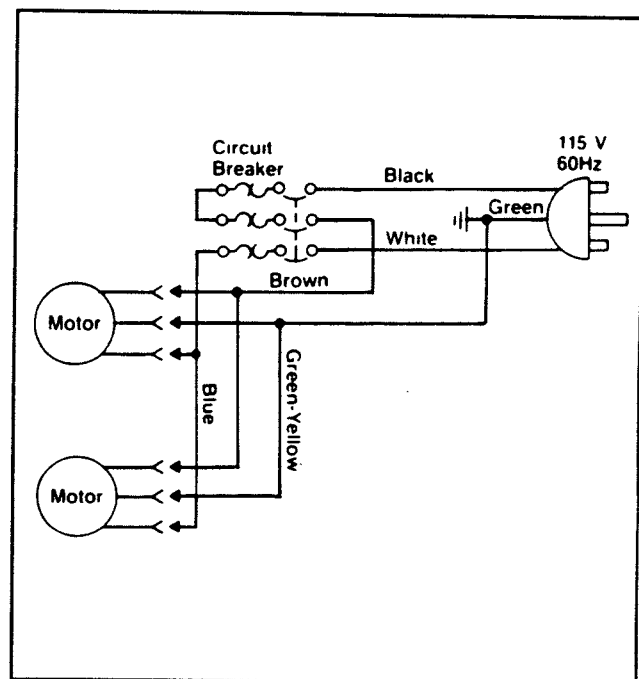


Figure 13

Circuit Breaker

The case sealer is equipped with a circuit breaker which trips the "On-Off" switch to tripped position. If circuit is **overloaded** and circuit breaker trips, wait 2 minutes, move to "Off", then turn "On". Located inside the electrical control box on the side of the main frame just below the conveyor bed, the circuit breaker has been **pre-set** and requires no further maintenance.

Maintenance (Continued)

Lubrication - Mechanical

Like most other equipment, the case sealer must be properly lubricated to insure long, trouble/free service. Most of the machine bearings are permanently lubricated and sealed and do not need to be greased. The drive motor is also permanently lubricated and should not require additional lubrication.

Figure 14 and 15 illustrate the taping head and frame points which should be lubricated every 250 hours of operation. Lubricate the rotating and pivoting points noted by the arrows with SAE #30 non-detergent oil. At the same time, a small amount of multipurpose grease should be applied to the end of each spring where the loop is secured at an eyelet, post, or hole.

▲ CAUTION - WIPE OFF EXCESS OIL AND GREASE; IT WILL ATTRACT DUST AND DIRT WHICH CAN CAUSE PREMATURE EQUIPMENT WEAR AND JAMMING. TAKE CARE THAT OIL AND GREASE ARE NOT LEFT ON THE SURFACE OF ROLLERS AROUND WHICH TAPE IS THREADED, AS IT CAN CONTAMINATE THE TAPE'S ADHESIVE.

Blade Oiler Pad

The taping heads are equipped with a blade oiler pad that has been pre-lubricated at the factory to provide a film of oil on the cut-off blade to reduce adhesive build-up. Apply SAE #30 non-detergent oil as needed. Do not saturate.

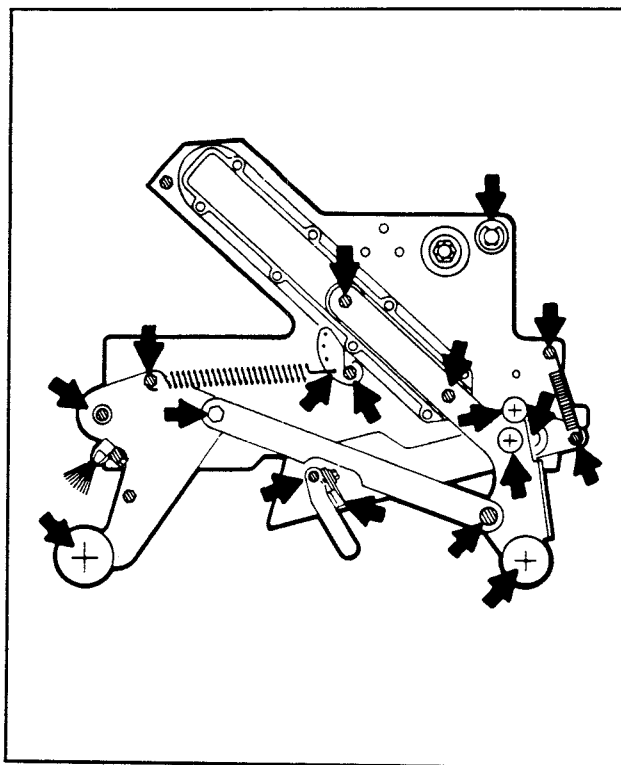


Figure 14 - Lubrication Points - Top And Bottom Taping Heads

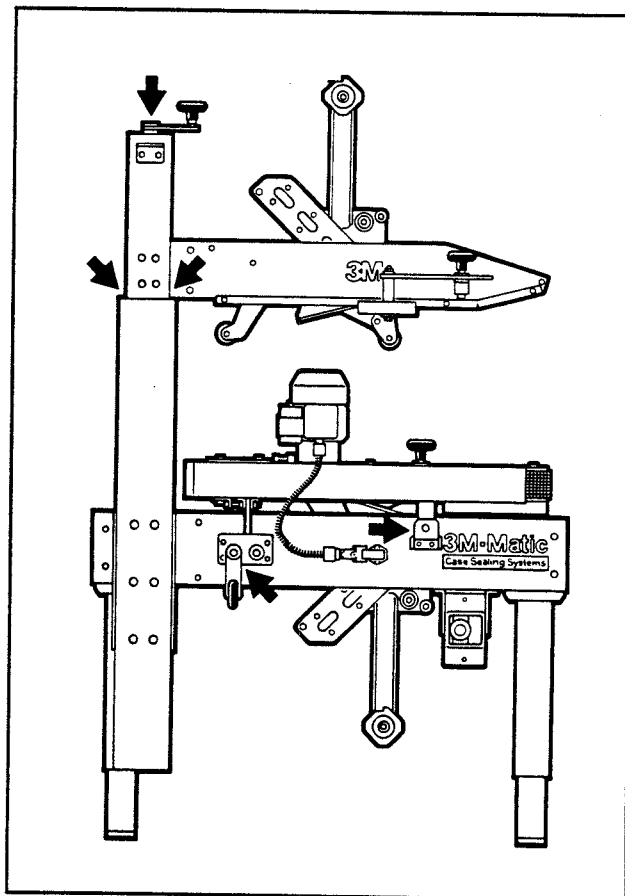


Figure 15 - Lubrication Points - Frame

Parts Order Form

— Shaded Areas To Be Filled In By 3M —

Mail To: Dispenser Parts
241 Venture Drive
Amery, WI 54001

Fax or Call: 715-268-8126 (Wisc.)
800-344-9883 (Outside Wisc.)
FAX# 715-268-8153



P.O. No.		Date		Catalog No.	Phone No. (including Area Code)	Customer Name	
Attn.		Model No.	Serial No.		Sales Rep No.	Invoice No.	
Ship To				Charge To			
Account No.		Account No.		Special Instructions		SIC	
Charge Back	Do Not Charge Back	Via	Tax Exempt No.				

FAX Your Order For Faster Service FAX No. (1-800-411-8153)

Qty.	Part Number		Description	Price
1.				
2.				
3.				
4.				
5.				
6.				
7.				
8.				
9.				

Please Print

Signature

Form 26989 - 3 - B \$10.00 Minimum Order ☐ Ship Via Air At Customer Expense



Replacement Parts And Service Information

Spare Parts - 12A

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

Qty.	Ref. No.	3M Part Number	Description
1	1145-6	78-8057-6179-4	Roller - Applying
1	1146-5	78-8057-6178-6	Roller - Buffing
1	1146-10	78-8052-6589-5	Spring - Extension Top
2	1148-2	78-8017-9173-8	Blade - 2.56 inch/65 mm
2	1148-10	78-8052-6602-6	Spring - Cutter
1	1198-11	78-8054-8550-1	Spring - Extension Bottom
2	2403-91	78-8055-0654-6	Belt - Drive

Spare Parts - 12A3

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

Qty.	Ref. No.	3M Part Number	Description
2	1329-6	78-8057-6181-0	Roller - Applying
2	1330-5	78-8057-6180-2	Roller - Buffing
2	1330-10	78-8052-6589-5	Spring - Extension Top
1	1332-2	78-8028-7899-7	Blade - 3.50 in./89 mm
2	1332-10	78-8052-6602-6	Spring - Cutter
	1335-11	78-8054-8550-1	Spring - Extension Bottom
2	2403-91	78-8055-0654-6	Belt - Drive

Tool Kit

A tool kit, P/N 78-8054-8732-5, 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 No. 78-8017-9433-6, contained in above kit is also available as a replacement stock item. Refer to "How To Order Replacement Parts" for ordering information.

How To Order Replacement Parts

Be Sure You Order From the Correct Parts List

1. Order parts by part number, part name, machine catalog number, model number and part quantity required.

**Minimum billing on parts orders will be \$10.00.
Replacement part prices available on request.**

2. Replacement parts and part prices available direct from:

**3M/Tape Dispenser Parts
241 Venture Drive
Amery, WI 54001-1325**

Note - Outside the U.S. contact the local 3M subsidiary for parts order information.

3. Refer to the front of the instruction manual for 3M equipment service information.

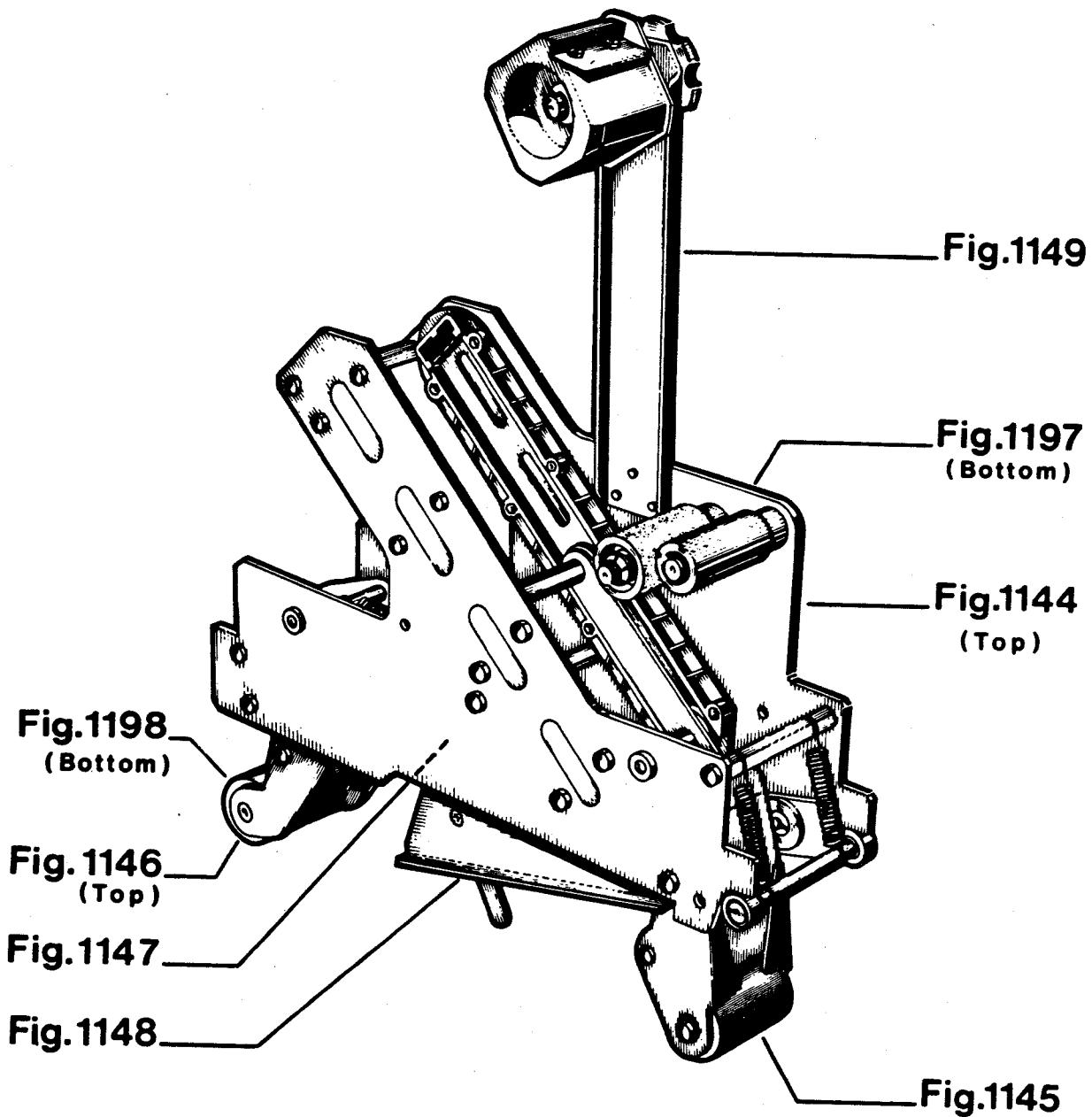
Attachments

For additional information on the attachments listed below, contact your 3M Representative.

Part Number	Attachment Name
78-8052-6553-1	Box Hold Down Attachment, Model 18500
78-8060-7405-6	Caster Kit Attachment, Model 28700
78-8052-6555-6	Conveyor Extension Attachment, Model 18500

Replacement Parts Illustrations and Parts Lists
12A Adjustable Case Sealer, Model 18600
Taping Head Assemblies

1. Refer to 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 pages 18 and 19 - "Replacement Parts and Service Information" of this manual for replacement parts ordering information.



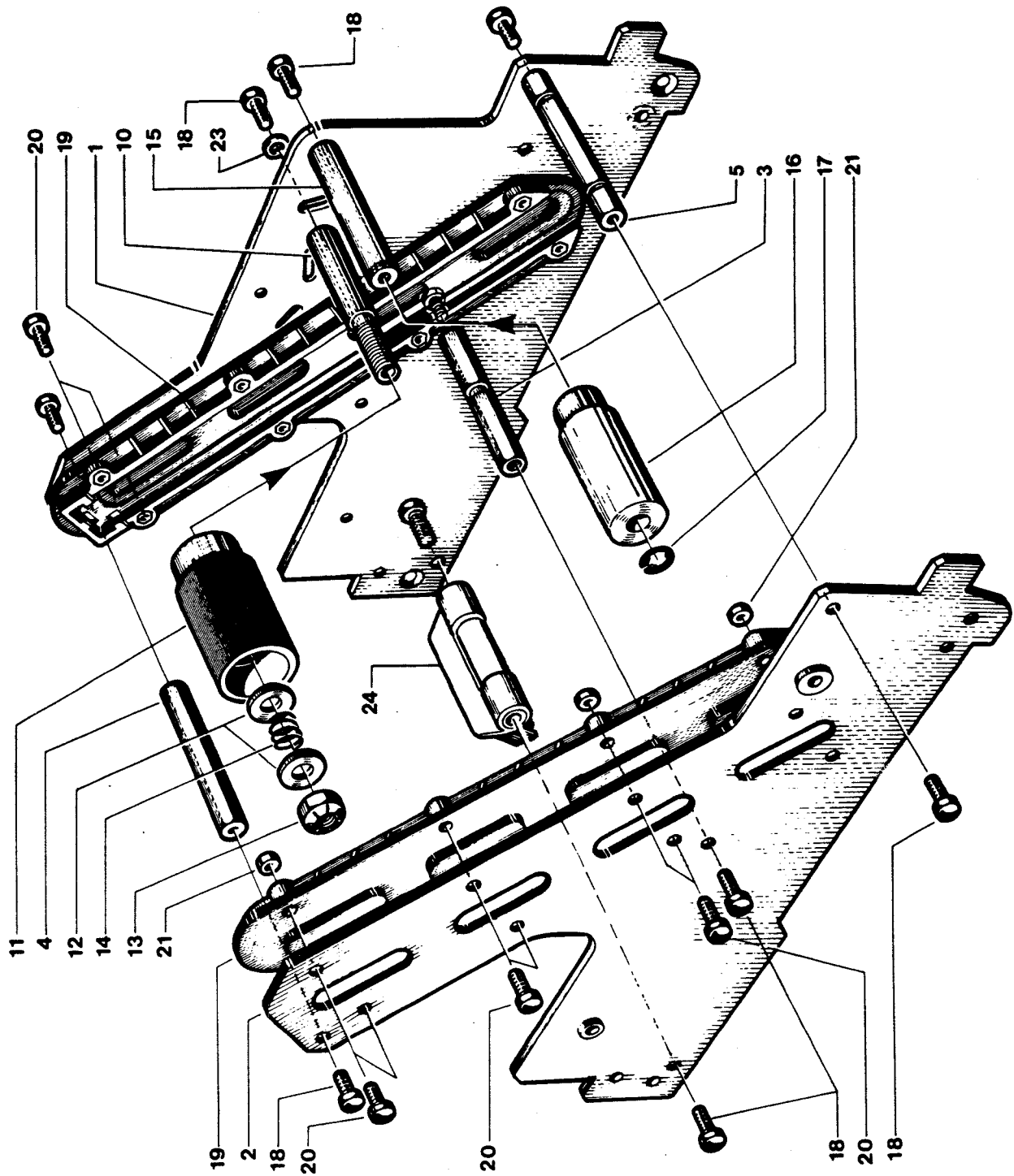


Figure 1144 Top

(12A)

Figure 1144

Ref. No.	3M Part No.	Description
1144-1	78-8052-6556-4	Frame - Right Hand Top
1144-2	78-8052-6557-2	Frame - Left Hand Top
1144-3	78-8052-6558-0	Spacer - Spring Hook
1144-4	78-8052-6559-8	Spacer - Upper
1144-5	78-8052-6560-6	Spacer - Front
1144-10	78-8052-6564-8	Shaft - Tension Roller
1144-11	78-8052-6565-5	Roller - Top Tension
1144-12	78-8052-6566-3	Washer - Friction
1144-13	78-8017-9077-1	Nut - Hex M10 x 1
1144-14	78-8052-6567-1	Spring - Compression
1144-15	78-8052-6568-9	Shaft - Wrap Roller
1144-16	78-8052-6569-7	Roller - Wrap
1144-17	26-1000-1613-3	Ring - Retaining, No. 10
1144-18	26-1003-5828-7	Screw - Hex Hd M6 x 10 Zinc Pl.
1144-19	78-8052-6570-5	Guide
1144-20	83-0002-7336-3	Screw - Hex Hd M4 x 14 Zinc Pl.
1144-21	78-8010-7416-8	Nut - Hex M4 Zinc Pl.
1144-23	26-1000-0010-3	Washer - Flat M6
1144-24	78-8060-7936-0	Brush Assy.

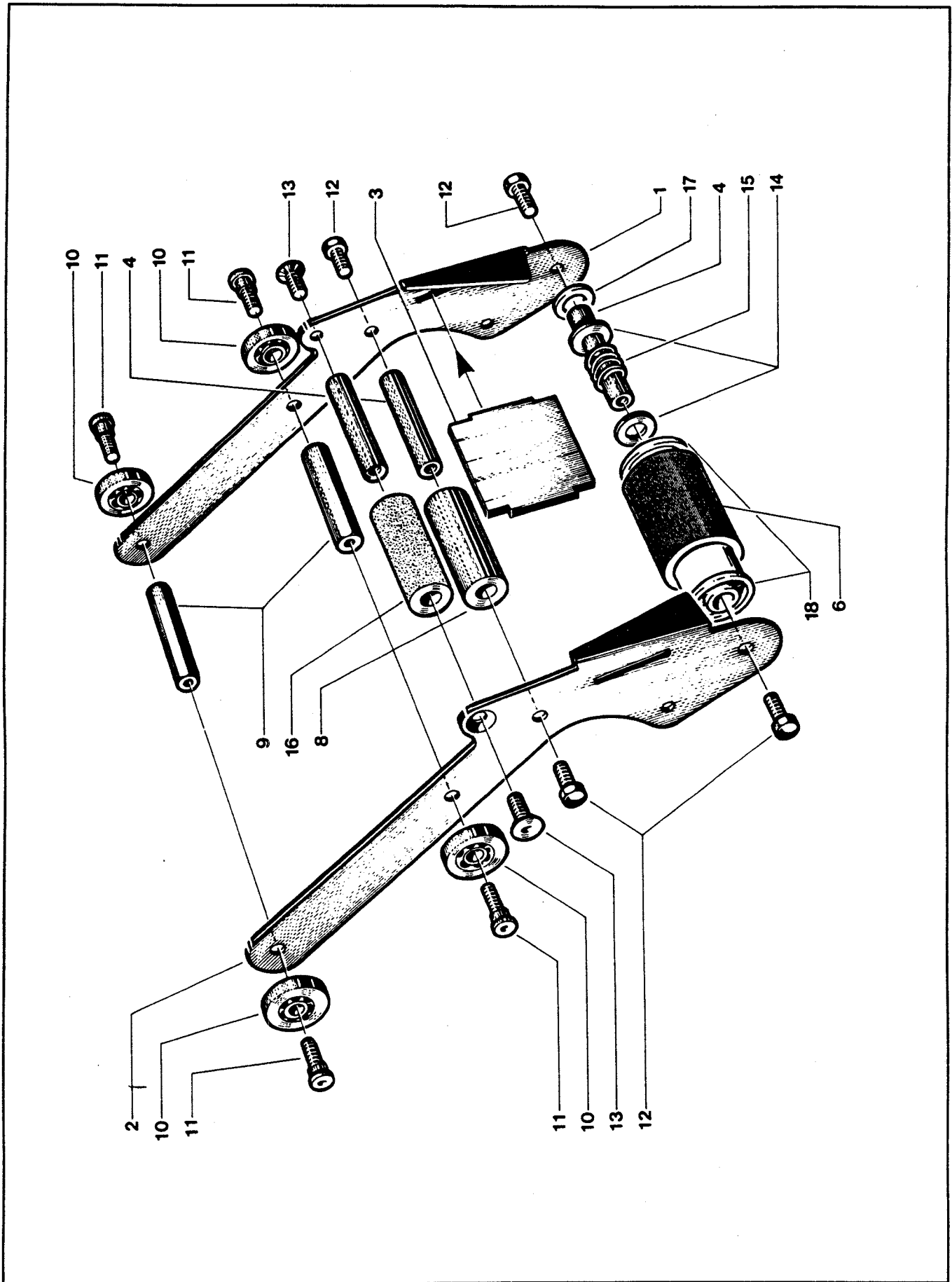


Figure 1145

(12A)

Figure 1145

Ref. No.	3M Part No.	Description
1145-1	78-8052-6572-1	Frame - Applying Right Hand
1145-2	78-8052-6573-9	Frame - Applying Left Hand
1145-3	78-8052-6574-7	Plate - Back Up
1145-4	78-8052-6575-4	Shaft - Roller
1145-6	78-8057-6179-4	Roller - Applying
1145-8	78-8052-6579-6	Roller - Wrap
1145-9	78-8052-6580-4	Spacer
1145-10	78-8017-9082-1	Bearing - Special 30 mm
1145-11	78-8017-9106-8	Screw - Bearing Shoulder
1145-12	26-1003-5828-7	Screw - Hex Hd M6 x 12
1145-13	26-1005-4759-0	Screw - Flat Hd M6 x 12
1145-14	78-8052-6566-3	Washer - Friction
1145-15	78-8052-6567-1	Spring - Compression
1145-16	78-8060-7942-8	Roller - Knurled
1145-17	78-8017-9074-8	Washer - Nylon 15 mm
1145-18	78-8060-8395-8	Bushing - Applying Roller

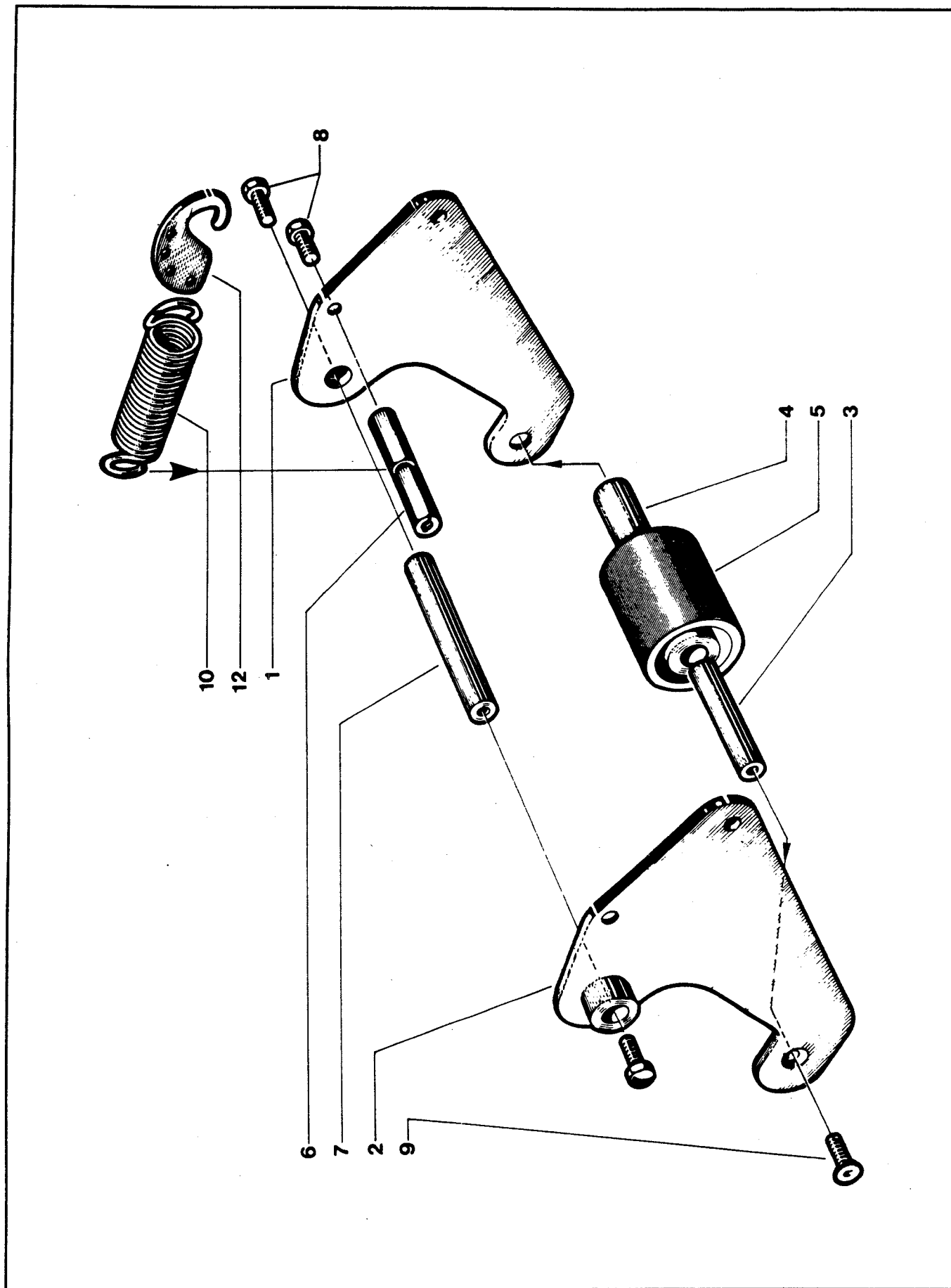


Figure 1146 Top

(12A)

Figure 1146

Ref. No.	3M Part No.	Description
1146-1	78-8052-6583-8	Frame - Right Hand
1146-2	78-8052-6584-6	Frame - Left Hand
1146-3	78-8052-6575-4	Shaft - Buffing Roller
1146-4	78-8052-6586-1	Bushing - Buffing Roller
1146-5	78-8057-6178-6	Roller - Buffing
1146-6	78-8052-6587-9	Spacer - Spring
1146-7	78-8017-9109-2	Shaft - Buffing Assy.
1146-8	26-1003-5828-7	Screw - Hex Hd M6 x 12 Zinc Pl.
1146-9	26-1005-4759-0	Screw - Flat Hd M6 x 12
1146-10	78-8052-6589-5	Spring - Top Extension
1146-12	78-8052-6590-3	Holder - Spring

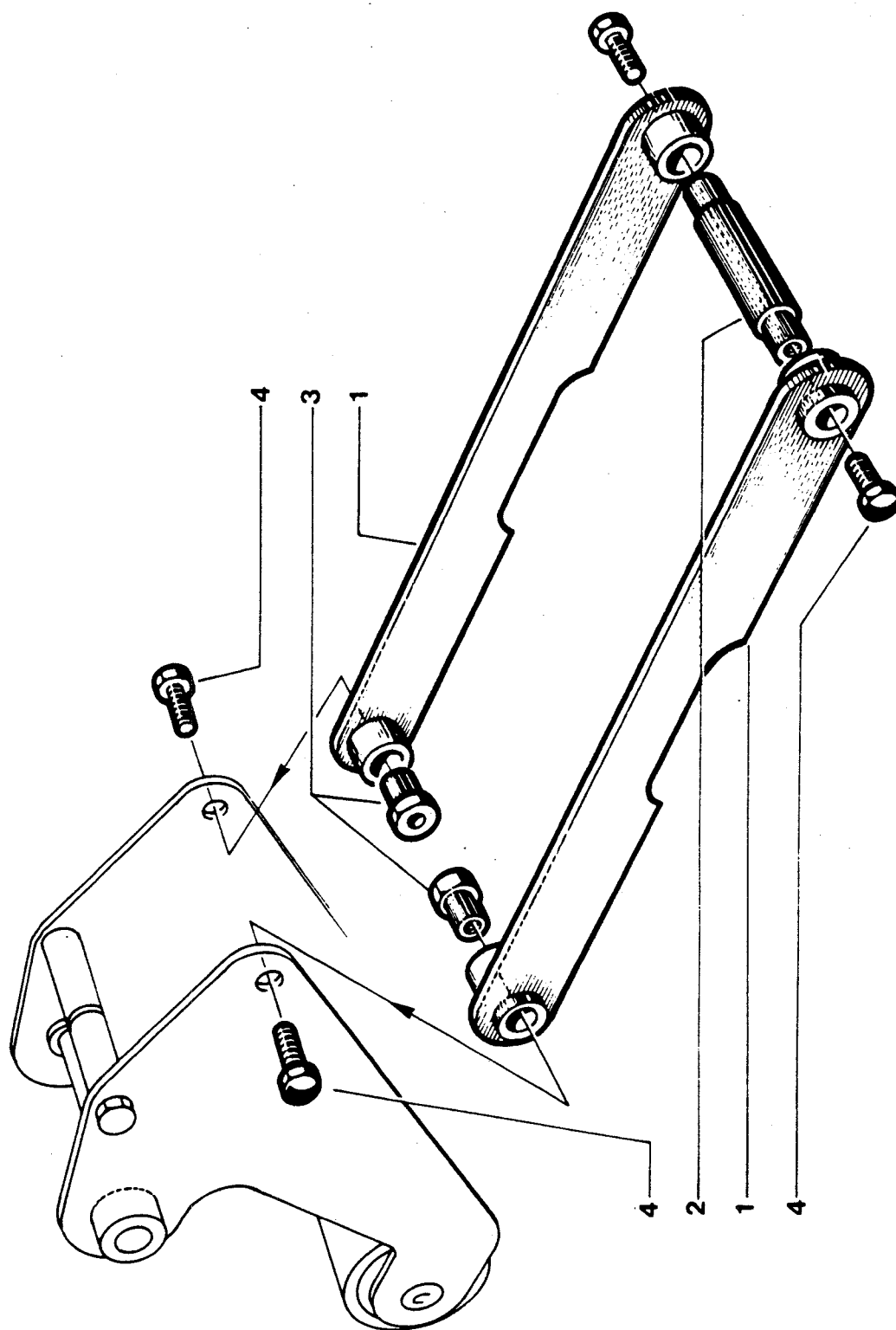


Figure 1147

(12A)

Figure 1147

Ref. No.	3M Part No.	Description
1147-1	78-8052-6592-9	Arm - Link
1147-2	78-8052-6593-7	Shaft - Pivot
1147-3	78-8052-6594-5	Bushing - Pivot
1147-4	78-8010-7163-6	Screw - Hex Hd M5 x 10 Zinc Pl.

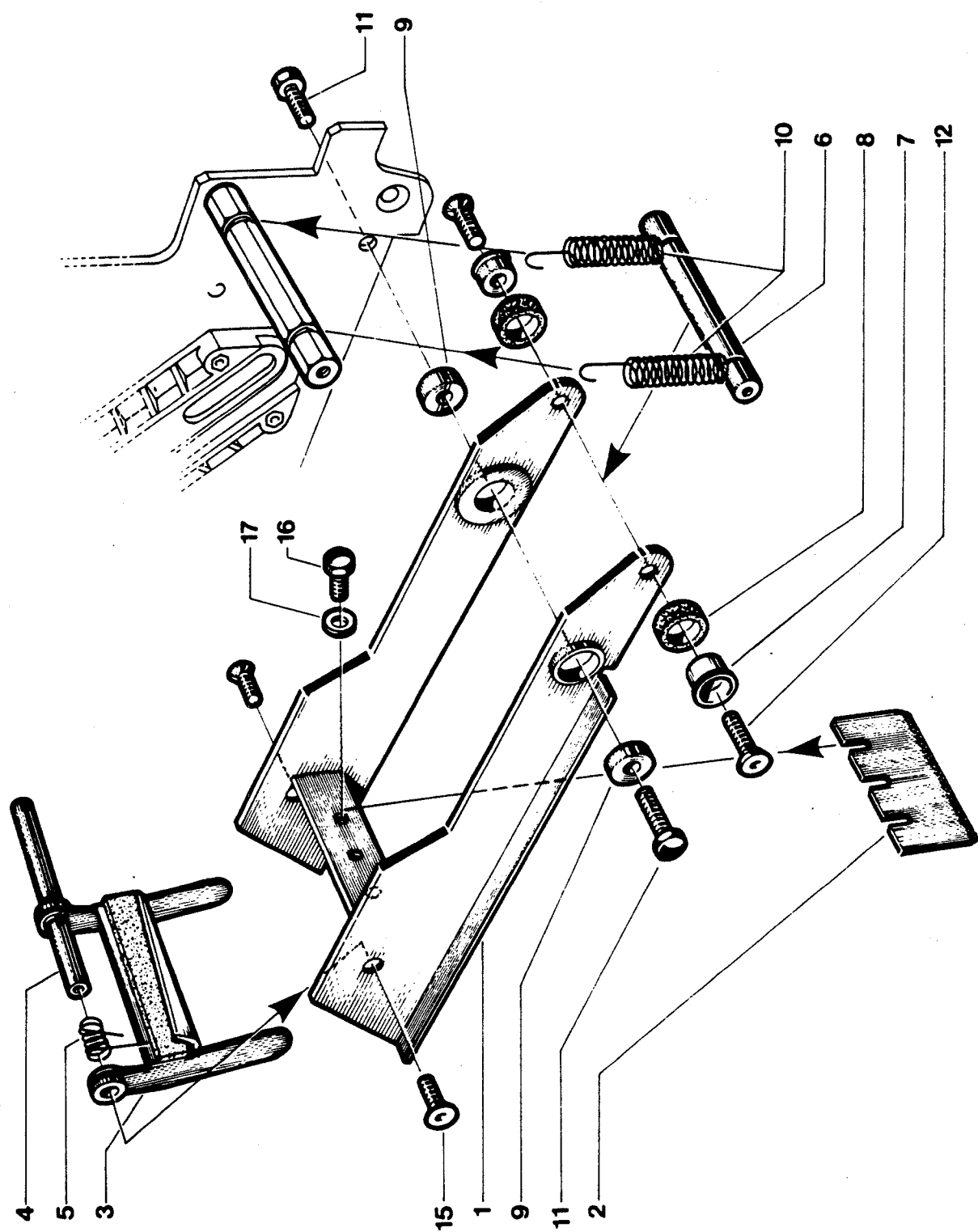


Figure 1148

(12A)

Figure 1148

Ref. No.	3M Part No.	Description
1148-1	78-8060-8167-1	Bracket - Cut-off
1148-2	78-8017-9173-8	Blade - 2.56 Inch/65 mm
1148-3	78-8052-6596-0	Guard - Blade
1148-4	78-8052-6597-8	Shaft - Blade Guard
1148-5	78-8052-6598-6	Spring - Tension
1148-6	78-8017-9135-7	Shaft - Spacer
1148-7	78-8052-6600-0	Spacer
1148-8	78-8017-9133-2	Bumper
1148-9	78-8017-9132-4	Pivot - Cutter Lever
1148-10	78-8052-6602-6	Spring - Cutter
1148-11	26-1002-5829-7	Screw - Hex Hd M6 x 10 Zinc Pl.
1148-12	26-1005-4757-4	Screw - Flat Hd M5 x 20 Zinc Pl.
1148-15	26-1005-4758-2	Screw - Flat Hd M4 x 10 Zinc Pl.
1148-16	26-1002-5817-2	Screw - Hex Hd M5 x 8 Zinc Pl.
1148-17	78-8005-5741-1	Washer - Plain M5 Metric

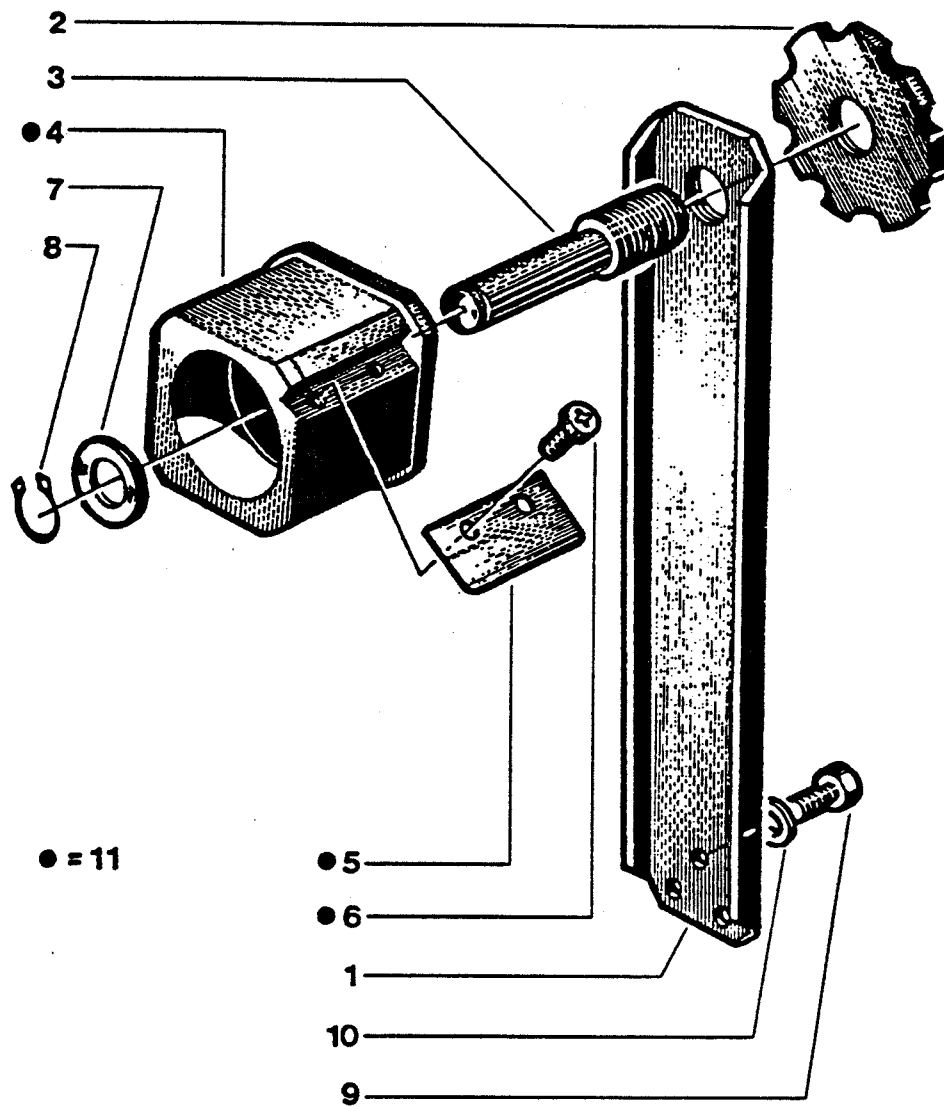


Figure 1149

(12A)

Figure 1149

Ref. No.	3M Part No.	Description
1149-1	78-8052-6544-0	Bracket - Tape Drum
1149-2	78-8017-9091-2	Plate - Locking, Tape Drum Shaft
1149-3	78-8052-6603-4	Shaft - Tape Drum
1149-4	78-8052-6749-5	Drum - Tape
1149-5	78-8052-6268-6	Leaf - Spring
1149-6	26-1002-5753-9	Screw - Self Tapping 7SP x 8
1149-7	78-8052-6541-6	Washer - Special
1149-8	26-1002-6110-1	Ring - Retaining No. 14
1149-9	26-1003-5829-5	Screw - Hex Hd M6 x 12
1149-10	26-1000-0010-3	Washer - Flat M6
1149-11	78-8070-1569-4	Tape Drum Assembly 2 Inch Wide

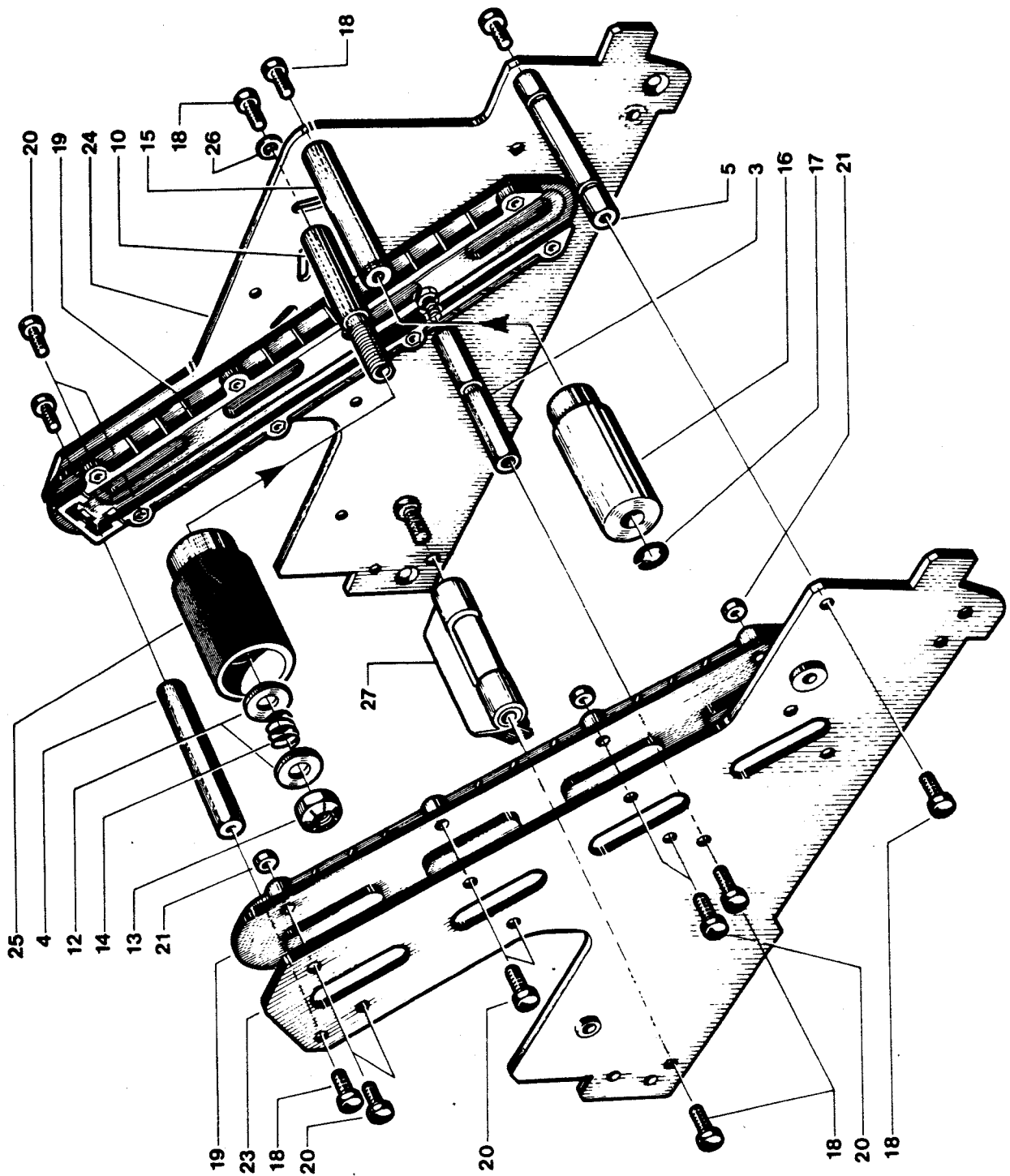


Figure 1197 Bottom

(12A)

Figure 1197

Ref. No.	3M Part No.	Description
1197-3	78-8052-6558-0	Spacer - Spring Hook
1197-4	78-8052-6559-8	Spacer - Upper
1197-5	78-8052-6560-6	Spacer - Front
1197-10	78-8052-6564-8	Shaft - Tension Roller
1197-12	78-8052-6566-3	Washer - Friction
1197-13	78-8017-9077-1	Nut - Hex
1197-14	78-8052-6567-1	Spring - Compression
1197-15	78-8052-6568-9	Shaft - Wrap Roller
1197-16	78-8052-6569-7	Roller Wrap
1197-17	26-1000-1613-3	Ring - Retaining
1197-18	26-1003-5828-7	Screw - Hex Hd M-6 x 10 Zinc Pl.
1197-19	78-8052-6570-5	Guide
1197-20	83-0002-7336-3	Screw - Hex Hd M4 x 14 Zinc. Pl.
1197-21	78-8010-7416-8	Nut - Hex M4 Zinc Pl.
1197-23	78-8052-6604-2	Frame - L/H Bottom
1197-24	78-8052-6605-9	Frame - R/H Bottom
1197-25	78-8052-6606-7	Roller - Tension Bottom
1197-26	26-1000-0010-3	Washer - Flat M6
1197-27	78-8060-7936-0	Brush Assy.

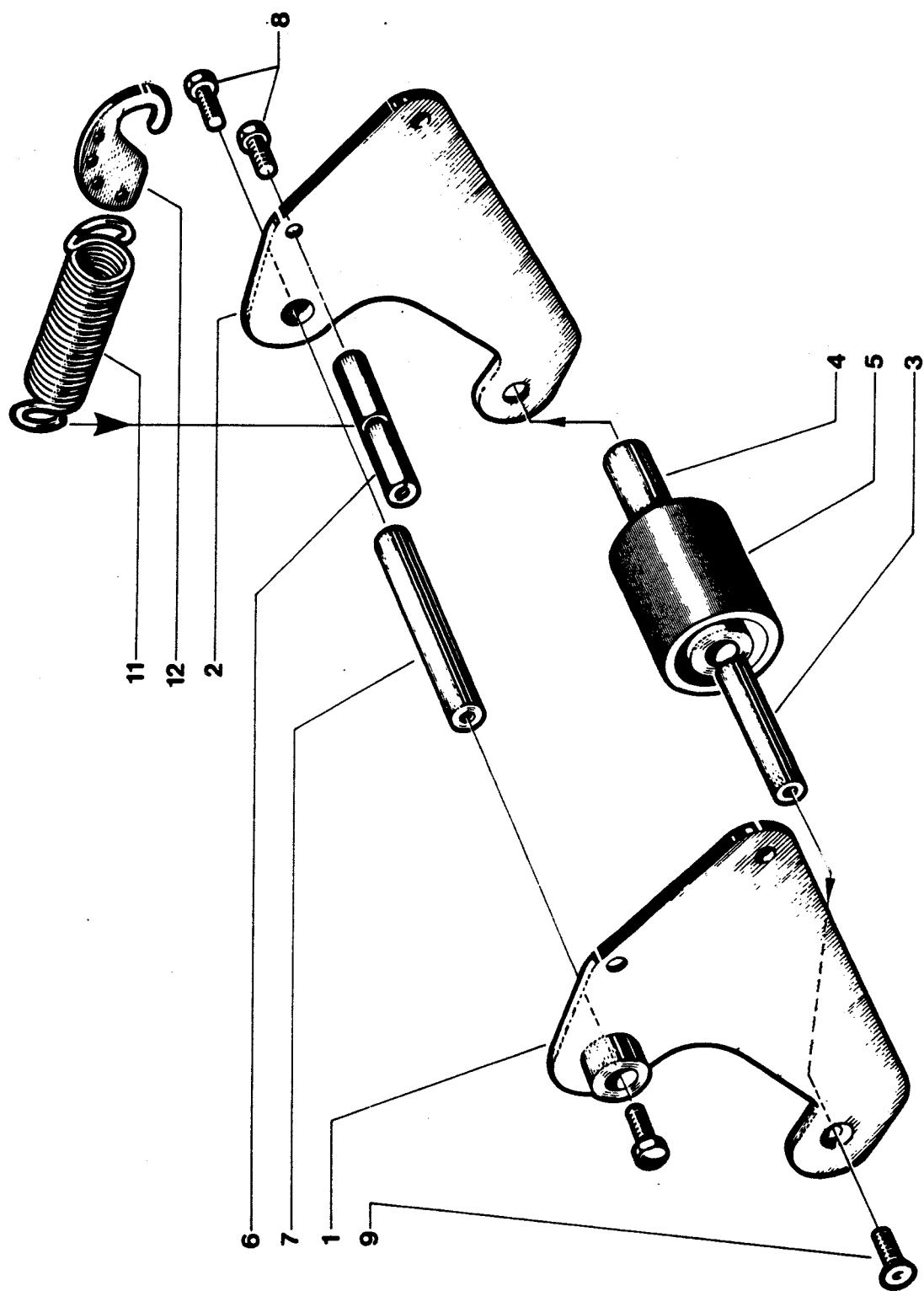


Figure 1198 Bottom

(12A)

Figure 1198

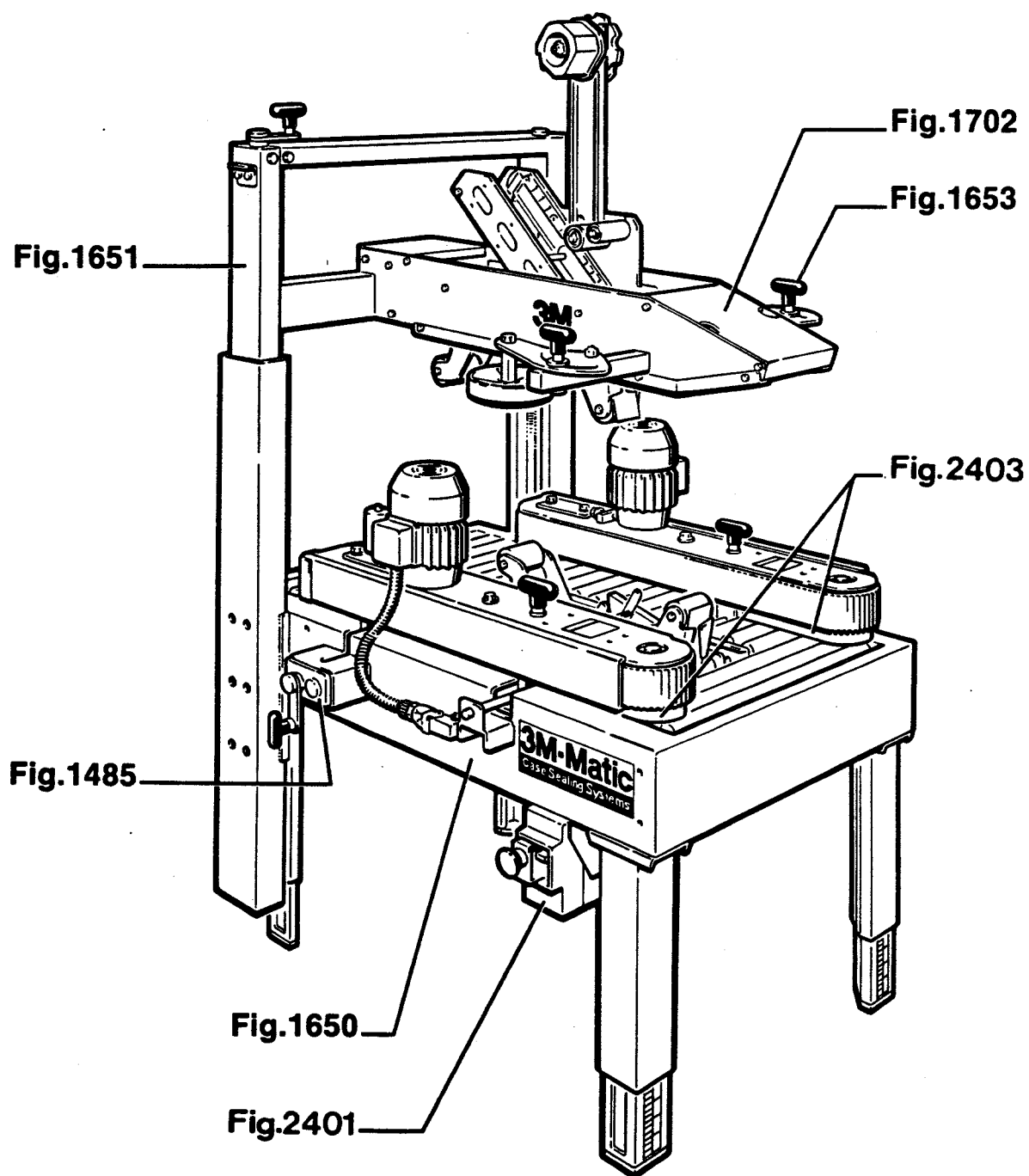
Ref. No.	3M Part No.	Description
1198-1	78-8052-6583-8	Frame - Right Hand
1198-2	78-8052-6584-6	Frame - Left Hand
1198-3	78-8052-6575-4	Shaft - Buffing Roller
1198-4	78-8052-6586-1	Bushing - Buffing Roller
1198-5	78-8057-6178-6	Roller - Buffing
1198-6	78-8052-6587-9	Spacer - Spring
1198-7	78-8017-9109-2	Shaft - Buffing Assy.
1198-8	26-1003-5828-7	Screw - Hex Hd M6 x 12 Zinc Pl.
1198-9	26-1005-4759-0	Screw - Flat Hd M6 x 12
1198-11	78-8054-8550-1	Spring - Bottom Extension
1198-12	78-8052-6590-3	Holder - Spring

Replacement Parts Illustrations and Parts Lists
12A Adjustable Case Sealer, Model 18600
12A3 Adjustable Case Sealer, Model 18900
Frame Assemblies

1. Refer to **Frame Assemblies** figure to find all 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 the 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 pages 18 and 19 - **"Replacement Parts and Service Information"** of this manual for replacement parts ordering information.



Frame Assemblies

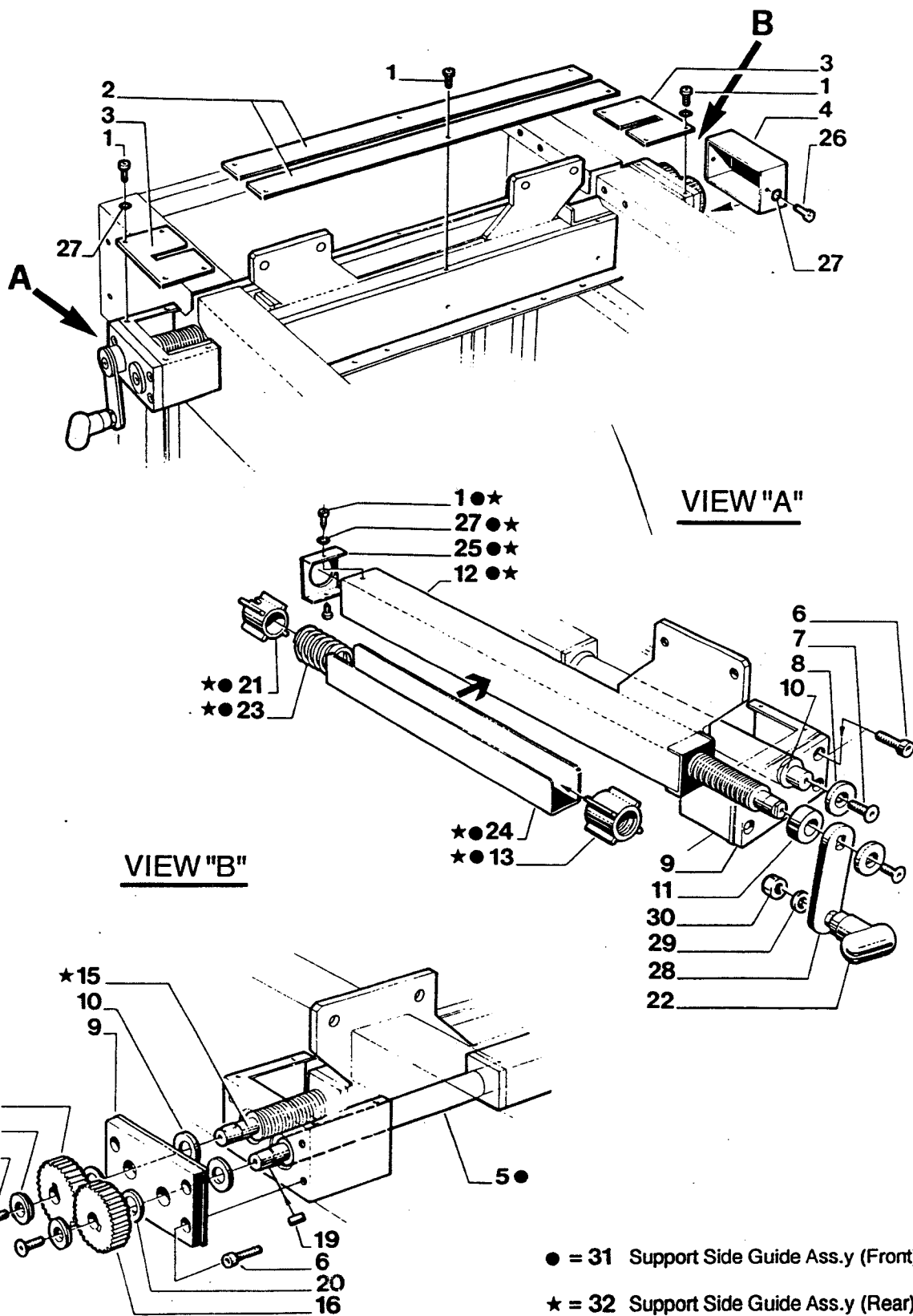


Figure 1485

Figure 1485

Ref. No.	3M Part No.	Description
1485-1	26-1002-5753-9	Screw - Self Tapping
1485-2	78-8054-8914-9	Rear Guide Guard
1485-3	78-8054-8915-6	Screw - Adjustment Guard
1485-4	78-8054-8916-4	Guard - Gear
1485-5	78-8054-8917-2	Conductor Screw
1485-6	26-1003-7951-5	Screw - Soc Hd M5 x 20
1485-7	78-8057-5726-3	Screw - Flat Hd Soc M6 x 15
1485-8	78-8054-8577-4	Washer - Special
1485-9	78-8054-8918-0	Plate
1485-10	78-8054-8919-8	Washer - 15 x 25 x 5 mm
1485-11	78-8054-8920-6	Spacer - 15,5 x 30 x 10 mm
1485-12	78-8054-8921-4	Support - Side Guide
1485-13	78-8054-8922-2	Nut - Plastic
1485-15	78-8054-8923-0	Screw - Side Guide
1485-16	78-8054-8924-8	Gear - 28 Teeth, 1,5 mm Pitch
1485-17	78-8054-8877-8	Washer - 5,5 x 20 x 4
1485-18	26-0001-5862-1	Screw - Flat Hd Soc M5 x 12
1485-19	78-8028-8244-5	Key - 4 x 4 x 10 mm
1485-20	78-8054-8925-5	Washer - 12 x 25 x 3 mm
1485-21	78-8054-8926-3	Collar
1485-22	78-8054-8578-2	Crank Assy.
1485-23	78-8055-0623-1	Spring
1485-24	78-8055-0624-9	Spacer
1485-25	78-8055-0625-6	End Cap
1485-26	26-1002-4955-1	Screw - Self Tap 8P x 13
1485-27	78-8005-5740-3	Washer - Plain 4 mm Metric
1485-28	78-8060-8065-7	Lever - Knob
1485-29	78-8010-7435-8	Washer - Lock M6 Metric
1485-30	78-8010-7418-4	Nut - Hex Stl. M6 Metric
1485-31	78-8060-8119-2	Support - Side Guide Assy. (Front)
1485-32	78-8060-8120-0	Support - Side Guide Assy. (Rear)

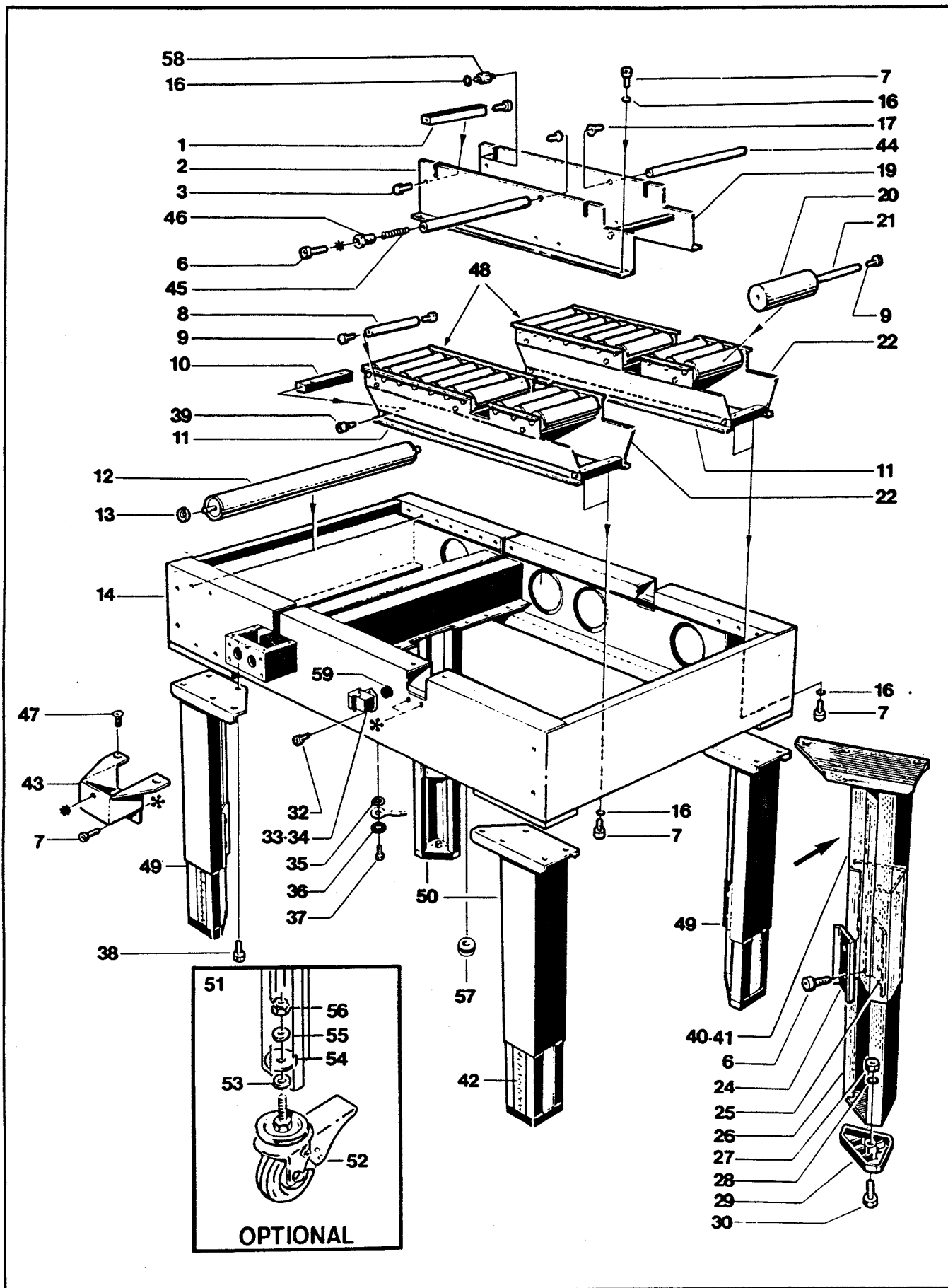


Figure 1650

Figure 1650

Ref. No.	3M Part No.	Description
1650-1	78-8054-8862-0	Spacer - 12 x 12 x 140 mm
1650-2	78-8055-0626-4	Frame - Upper Main Left
1650-3	78-8010-7169-3	Screw - Hex Hd M6 x 12 Metric
1650-6	26-1003-7963-0	Screw - Soc Hd M8 x 16
1650-7	26-1003-7957-2	Screw - Soc Hd Hex Hd M6 x 16
1650-8	78-8054-8865-3	Shaft - 8 x 139 mm
1650-9	78-8010-7163-6	Screw - Hex Hd M5 x 10 Metric
1650-10	78-8054-8870-3	Spacer - 15 x 15 x 95 mm
1650-11	78-8055-0628-0	Roller Bed - Left
1650-12	78-8052-6669-5	Roller - Conveyor
1650-13	78-8052-6668-7	Snap - Roller
1650-14	78-8055-0629-8	Bed - Conveyor
1650-16	26-1000-0010-3	Washer - Flat M6
1650-17	78-8057-5716-4	Screw - Flat Hd Soc M8 x 15
1650-19	78-8055-0630-6	Frame - Upper Main Right
1650-20	78-8055-0631-4	Roller - Conveyor 32 x 138 mm
1650-21	78-8054-8874-5	Shaft - 8 x 148 mm
1650-22	78-8055-0632-2	Roller Bed - Right
1650-24	78-8052-6676-0	Clamp - Outer
1650-25	78-8052-6677-8	Clamp - Inner
1650-26	78-8052-6678-6	Leg - Inner
1650-27	78-8017-9313-0	Nut - Self Locking M8 Nick. Pl.
1650-28	26-1004-5507-5	Washer M8
1650-29	78-8052-6679-4	Pad - Foot
1650-30	26-1003-5842-8	Screw - Hex Hd M8 x 20
1650-32	78-8028-8208-0	Screw - 6P x 9.5
1650-33	78-8060-7876-8	Cover - Plug
1650-34	78-8060-7873-5	Plug - Female
1650-35	78-8046-8217-3	Washer - Special
1650-36	78-8005-5741-1	Washer - Plain M5 Metric
1650-37	26-1003-5820-4	Screw - Hex Hd M5 x 12
1650-38	26-1003-7964-8	Screw - Soc Hd Hex Soc Dr M8 x 20
1650-39	78-8010-7209-7	Screw - Soc Hd M6 x 12
1650-40	78-8060-7948-5	Leg - Left
1650-41	78-8060-7947-7	Leg - Right
1650-42	78-8052-6680-2	Label - Height
1650-43	78-8055-0620-7	Mount - Side Guide
1650-44	78-8054-8831-5	Shaft - 14 x 255 mm
1650-45	78-8054-8999-0	Spring
1650-46	78-8054-8998-2	Bushing
1650-47	26-1001-9843-6	Screw - Flat Soc Hd M6 x 16
1650-48	78-8060-8121-8	Conveyor Assy.
1650-49	78-8060-8122-6	Leg Assy. - Right
1650-50	78-8060-8123-4	Leg Assy. - Left
1650-51	78-8060-8060-8	Caster Assy. - 80
1650-52	78-8060-8061-6	Caster - 80
1650-53	78-8060-8124-2	Spacer - Caster
1650-54	78-8060-7699-4	Washer - 12-45, 5 x 4
1650-55	78-8017-9059-9	Washer - Flat For M12 Screw
1650-56	78-8060-7532-7	Nut - Self Locking M12
1650-57	78-8060-7758-8	Fairlead 20
1650-58	78-8060-8460-0	Spacer - SM
1650-59	78-8052-6659-6	Grommet

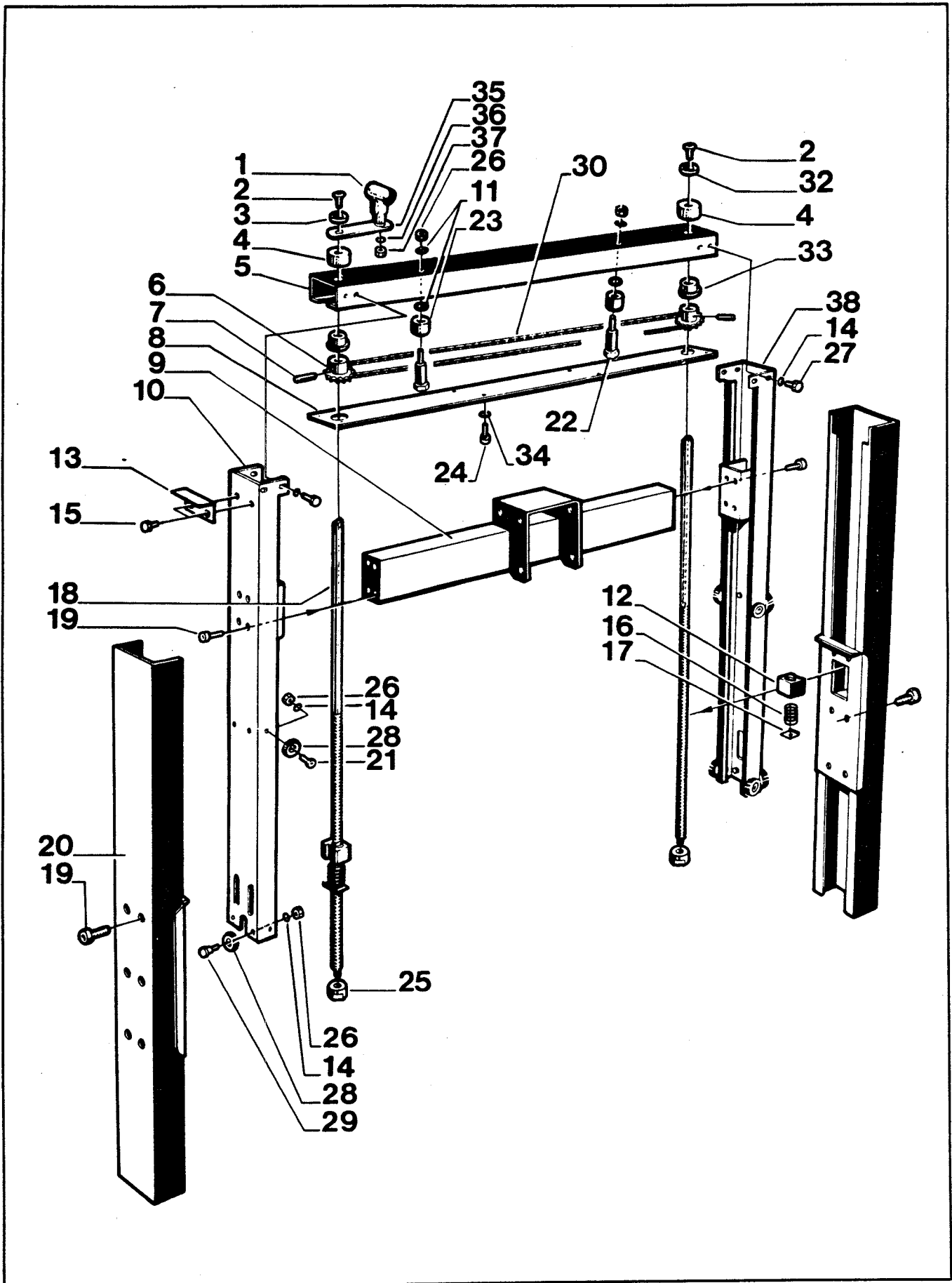


Figure 1651

Figure 1651

Ref. No.	3M Part No.	Description
1651-1	78-8054-8578-2	Crank
1651-2	26-1001-9843-6	Screw - Flat Soc Hd M6 x 16
1651-3	78-8054-8577-4	Washer - Special
1651-4	78-8054-8581-6	Spacer
1651-5	78-8055-0633-0	Crossmember
1651-6	78-8055-0731-2	Sprocket - 3/8 Pitch, 13 Teeth
1651-7	78-8054-8586-5	Pin
1651-8	78-8055-0726-2	Cover - Chain
1651-9	78-8055-0636-3	Support - Head
1651-10	78-8055-0634-8	Column - Inner
1651-11	78-8042-2919-9	Washer - M6 Nick. Pl.
1651-12	78-8054-8571-7	Nut - Plastic
1651-13	78-8055-0727-0	Bracket - Stop
1651-14	26-1000-0010-3	Washer - Flat M6
1651-15	78-8010-7169-3	Screw - Hex Hd M6 x 12 Metric
1651-16	78-8054-8969-3	Spring
1651-17	78-8054-8970-1	Bed Plate for Spring
1651-18	78-8054-8573-3	Lead Screw
1651-19	26-1003-7964-8	Screw - Soc Hd Hex Soc Dr M8 x 20
1651-20	78-8055-0635-5	Column
1651-21	78-8017-9106-8	Screw - Bearing Shoulder
1651-22	78-8060-7878-4	Idler Screw
1651-23	78-8054-8575-8	Idler Roller
1651-24	26-1002-5753-9	Screw - Self Tapping
1651-25	78-8054-8968-5	Nut - Special
1651-26	26-1003-6916-9	Nut - Locking Plastic Insert M6
1651-27	78-8032-0375-7	Screw - Hex Hd M6 x 16 Metric
1651-28	78-8055-0637-1	Caster
1651-29	78-8054-8589-9	Screw - Special
1651-30	78-8055-0728-8	Chain - 3/8 Pitch, 139 Pitch Lg.
1651-32	78-8055-0732-0	Washer - Special
1651-33	78-8060-8125-9	Bushing
1651-34	78-8005-5740-3	Washer - Plain 4 mm Nick. Metric
1651-35	78-8060-8065-7	Lever - Knob
1651-36	78-8010-7435-8	Washer - Lock M6 Metric
1651-37	78-8010-7418-4	Nut - Hex Stl. M6 Metric
1651-38	78-8060-8126-7	Column Assy. - Inner

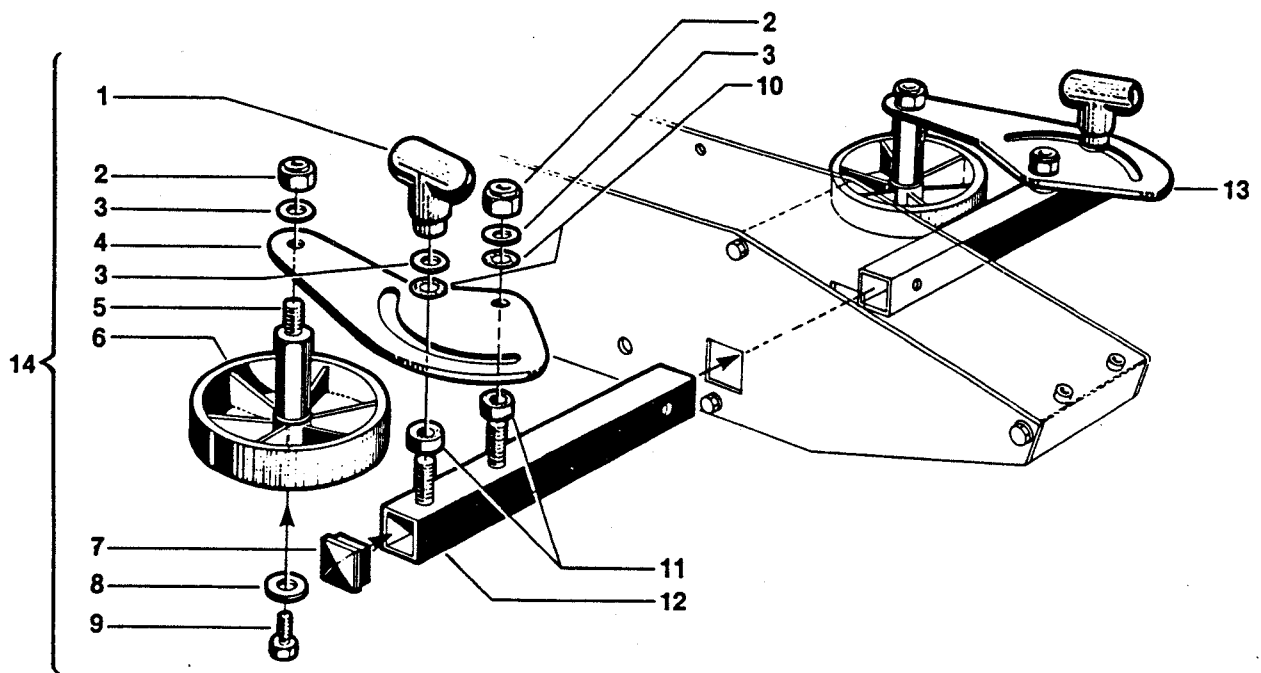


Figure 1653

Figure 1653

Ref. No.	3M Part No.	Description
1653-1	78-8060-8055-8	Knob
1653-2	26-1003-6918-5	Nut - Plastic Insert M10 Hex Flange
1653-3	78-8052-6566-3	Washer - Friction
1653-4	78-8052-6701-6	Plate - Mounting
1653-5	78-8052-6702-4	Stud - Mounting
1653-6	78-8054-8648-3	Pressure Roller
1653-7	78-8052-6652-1	Cap - End
1653-8	78-8052-6703-2	Washer - Special
1653-9	26-1003-5841-0	Screw - M8 x 16
1653-10	78-8017-9074-8	Washer - Nylon 15 mm
1653-11	78-8052-6651-3	Washer - Nylon
1653-12	78-8055-0649-6	Support - Roller
1653-13	78-8060-8127-5	Side Roller Assy. - Right
1653-14	78-8060-8128-3	Side Roller Assy. - Left

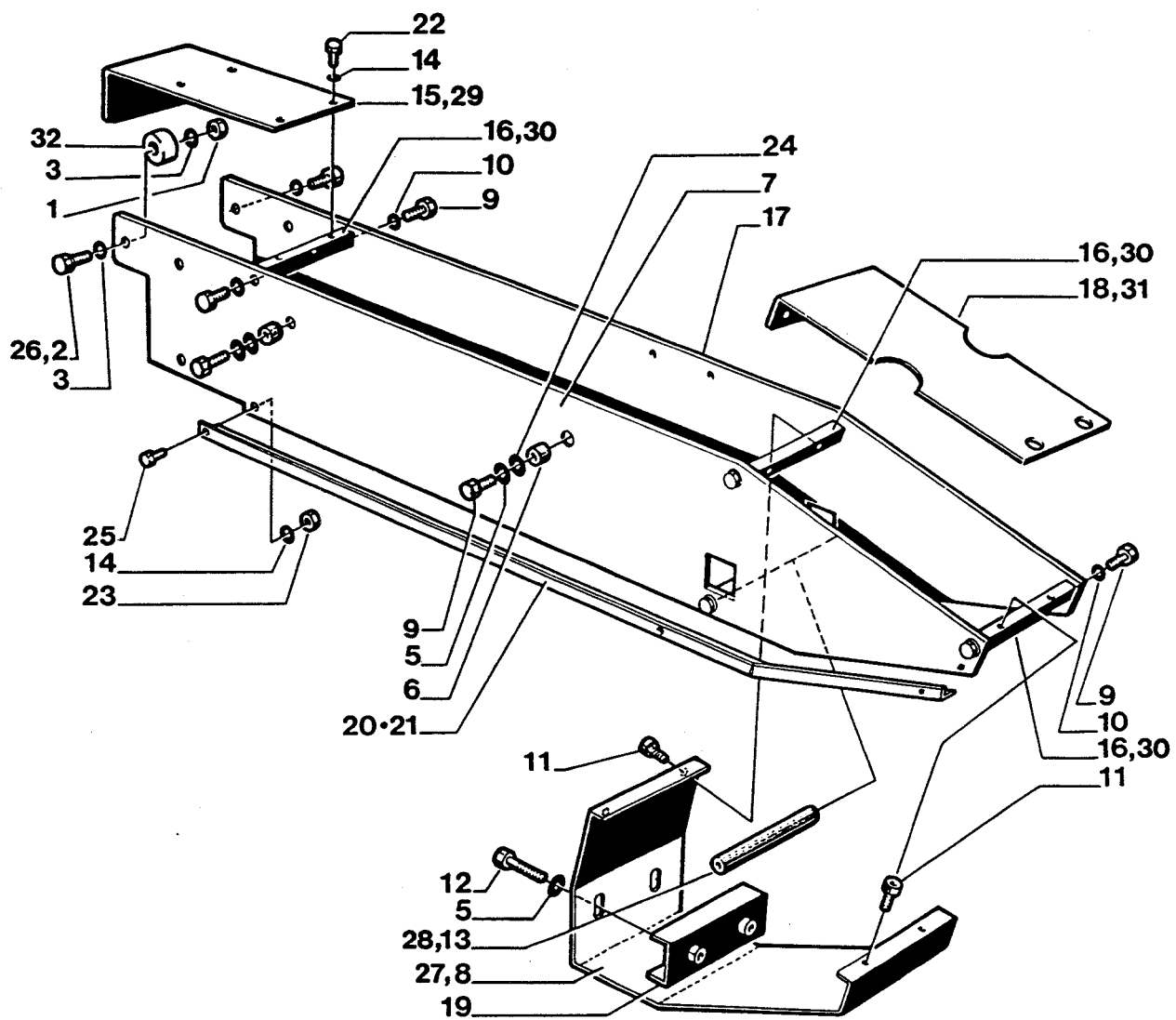


Figure 1702

Ref. No.	3M Part No.	Description	Machine
1702-1	26-1000-1347-8	Nut - Hex Stl. M8 Metric	
1702-2	26-1003-5842-8	Screw - Hex Hd M8 x 20	12A
1702-3	78-8017-9318-9	Washer - Plain 8 mm Metric	
1702-4	26-1003-7957-2	Screw - Soc Hd Hex Hd M6 x 16	
1702-5	78-8042-2919-9	Washer - M6 Nick. Pl.	
1702-6	78-8055-0640-5	Spacer	
1702-7	78-8055-0641-3	Frame - Center Left	
1702-8	78-8055-0736-1	Sheets Holder	12A
1702-9	78-8032-0375-7	Screw - Hex Hd M6 x 16 Metric	
1702-10	26-1000-0010-3	Washer - Flat M6	
1702-11	26-1003-7948-1	Screw - Soc Hd Hex Soc M5 x 10	
1702-12	26-1002-5836-2	Screw - Hex Hd M6 x 40	
1702-13	78-8055-0643-9	Spacer	12A
1702-14	78-8005-5741-1	Washer - Plain M5 Metric	
1702-15	78-8055-0737-9	Plate - Center Rear	12A
1702-16	78-8055-0645-4	Spacer	12A
1702-17	78-8055-0646-2	Frame - Center Right	
1702-18	78-8055-0738-7	Cover	12A
1702-19	78-8055-0648-8	Clamp - Tubing	
1702-20	78-8055-0729-6	Slide - Right	
1702-21	78-8055-0730-4	Slide - Left	
1702-22	78-8010-7163-6	Screw - Hex Hd M5 x 10 Metric	
1702-23	78-8010-7417-6	Nut - Hex Stl. M5 Metric	
1702-24	78-8017-9074-8	Washer - Nylon 15 mm	
1702-25	26-1003-5820-4	Screw - Hex Hd M5 x 12	
1702-26	26-1003-5845-1	Screw - Hex Hd M8 x 40	12A3
1702-27	78-8055-0642-1	Sheets Holder	12A3
1702-28	78-8054-8929-7	Spacer - 10 x 140 mm	12A3
1702-29	78-8055-0644-7	Plate - Center, Rear	12A3
1702-30	78-8054-8931-3	Spacer - 10 x 10 x 140 mm	12A3
1702-31	78-8055-0647-0	Cover	12A3
1702-32	78-8055-0733-8	Spacer	12A3

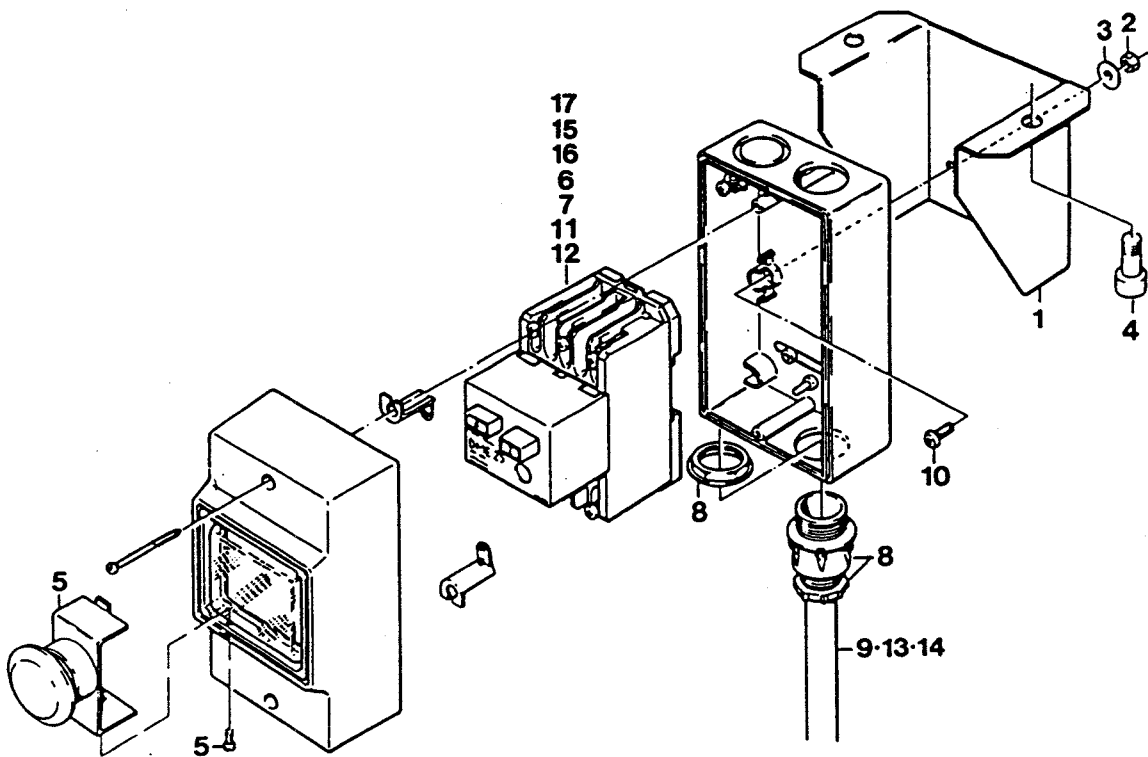


Figure 2401

Figure 2401

Ref. No.	3M Part No.	Description
2401-1	78-8052-6724-8	Switch - Bracket
2401-2	78-8010-7416-8	Nut - Hex M4 Metric
2401-3	78-8017-9018-5	Washer - Plain M4 Metric
2401-4	26-1003-7963-0	Screw - Soc Hd M8 x 16
2401-5	78-8052-6725-5	Emergency Stop
2401-6	78-8052-6727-1	Switch - On/Off 1 - 1,6 AMP
2401-7	78-8052-6728-9	Switch - On/Off 1,6 - 2,5 AMP
2401-8	78-8057-5807-1	Cord Grip
2401-9	78-8028-7909-4	Power Cord
2401-10	78-8017-9257-9	Screw - Phil. Hd M4 x 10
2401-11	78-8060-7637-4	Plug Terminal Wire 1,5
2401-12	78-8060-7881-8	Eyelet Terminal 5 Yellow
2401-13	78-8060-8052-5	Cable 4 x 1,5 5MT 3PH
2401-14	78-8060-8053-3	Cable 3 x 1,5 5MT 1PH
2401-15	78-8052-6729-7	Switch - On/Off 2,5 - 4 AMP
2401-16	78-8052-6660-4	Switch - On/Off 4 - 6,3 AMP
2401-17	78-8052-6661-2	Switch - On/Off 6,3 - 10 AMP

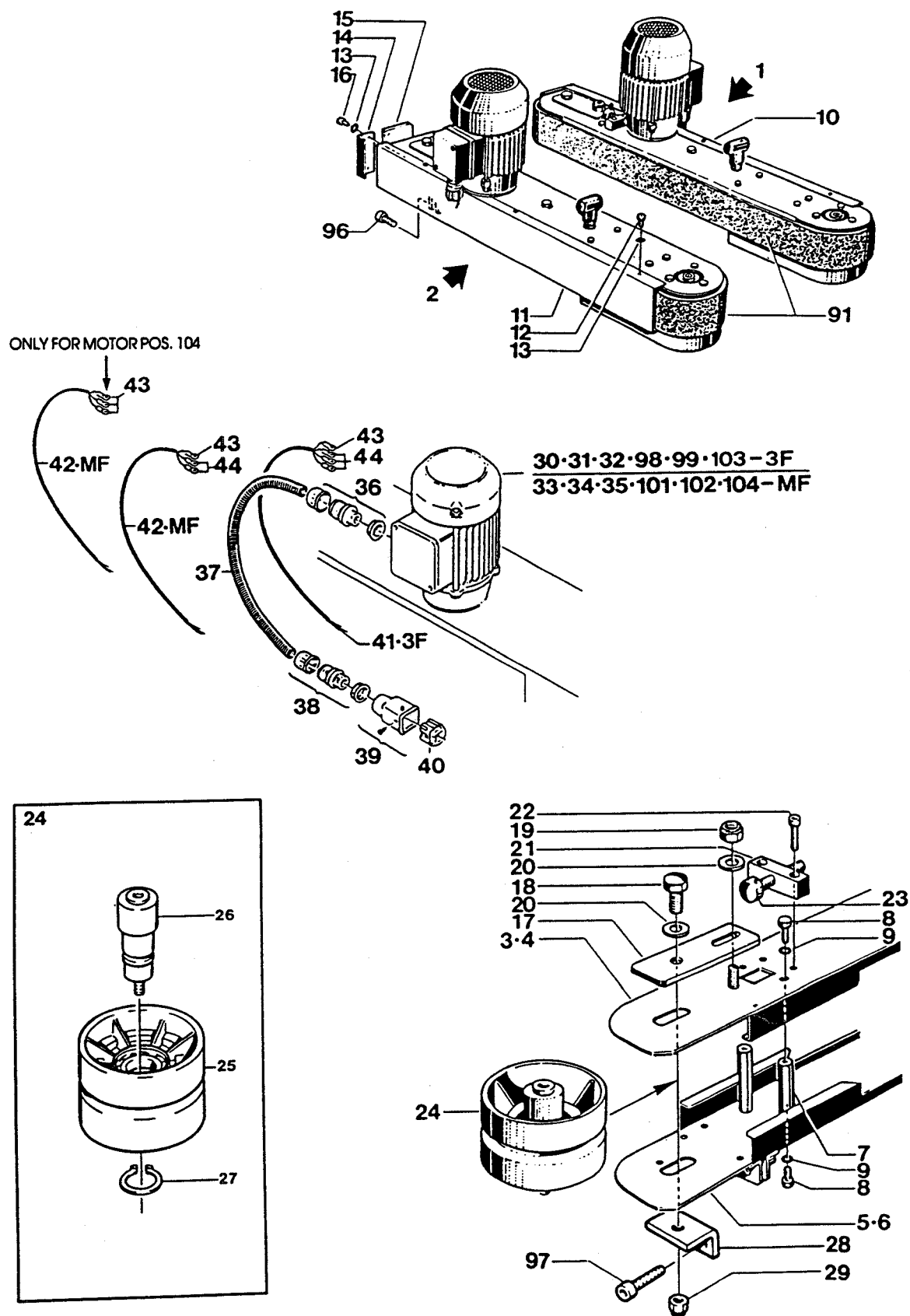


Figure 2403/1 of 2

Figure 2403 (Page 1 of 2)

Ref. No.	3M Part No.	Description
2403-1	78-8060-8129-1	Side Drive Assy. - Right
2403-2	78-8060-8130-9	Side Drive Assy. - Left
2403-3	78-8055-0657-9	Guide Plate - Up Right
2403-4	78-8055-0658-7	Guide Plate - Up Left
2403-5	78-8055-0662-9	Guide Plate - Low Right
2403-6	78-8055-0663-7	Guide Plate - Low Left
2403-7	78-8055-0661-1	Spacer
2403-8	78-8010-7169-3	Screw - Hex Hd M6 X 12 Metric
2403-9	26-1000-0010-3	Washer - Flat M6
2403-10	78-8055-0653-8	Guard - Right
2403-11	78-8055-0655-3	Guard - Left
2403-12	26-1002-5753-9	Screw - Self Tapping
2403-13	78-8005-5740-3	Washer - Plain 4 mm Metric
2403-14	78-8055-0651-2	Belt - Guard
2403-15	78-8055-0650-4	Guard - Belt
2403-16	26-1002-4955-1	Screw - Self Tap 8P x 13
2403-17	78-8055-0656-1	Plate - Belt Adjustment
2403-18	26-1002-4189-7	Screw - Hex Hd M10 x 20
2403-19	26-1003-6918-5	Nut - Hex M10 Plastic Insert
2403-20	78-8052-6566-3	Washer - Friction
2403-21	78-8054-8903-2	Block - Belt
2403-22	78-8010-7210-5	Screw - Soc Hd M6 x 20
2403-23	78-8054-8904-0	Screw - Belt Adjustment
2403-24	78-8060-8131-7	Roller Assy - Idler
2403-25	78-8055-0660-3	Roller - Idler
2403-26	78-8055-0659-5	Shaft - Roller
2403-27	12-7997-0272-0	E-Ring - M25
2403-28	78-8060-8139-0	Plate - Belt Adjust.
2403-29	78-8017-9313-0	Nut - Self Locking M8
2403-30	78-8057-5717-2	Coel Motor 220/380V, 50HZ, 3 PH - Europe
2403-31	78-8057-5719-8	Coel Motor 240/41V, 50HZ, 3 PH - Australia/N.Zealand
2403-32	78-8057-5718-0	Coel Motor 260/440V, 50HZ, 3 PH - U.K.
2403-33	78-8057-5720-6	Coel Motor 220V, 50HZ, Single PH - Ireland/H.Kong
2403-34	78-8057-5721-4	Coel Motor 240V, 50HZ, Single PH - U.K.
2403-35	78-8054-8842-2	Motor 0,12HP, 110V, 60HZ, Single PH - U.S.A.
2403-37	78-8060-8132-5	Sleeving 12-0,32 M
2403-38	78-8060-7626-7	Connector PG 11/12
2403-39	78-8060-7877-6	Plug - Housing Vertical
2403-40	78-8060-7875-0	Plug - Male
2403-41	78-8060-8052-5	Cable - 4 x 1,5 5MT 3PH
2403-42	78-8060-8053-3	Cable - 3 x 1,5 5MT 1PH
2403-43	78-8060-7880-0	Eyelet - Terminal 4 Red
2403-44	78-8060-8133-3	Eyelet - Terminal 3 Red
2403-45	78-8054-8883-6	Spacer - Motor
2403-46	78-8060-8073-1	Washer - Motor
2403-47	26-1005-4758-2	Screw - Flat Hd M5 x 20
2403-48	78-8054-8885-1	Pulley - Timing 14 Teeth For 60 HZ Motor

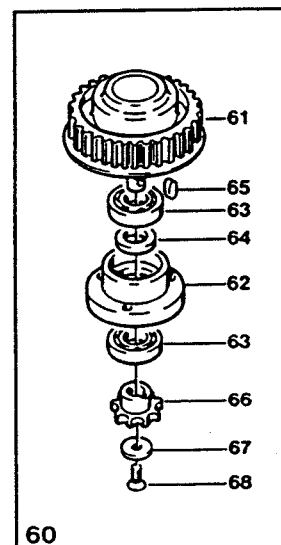
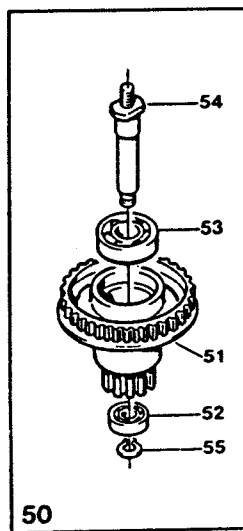
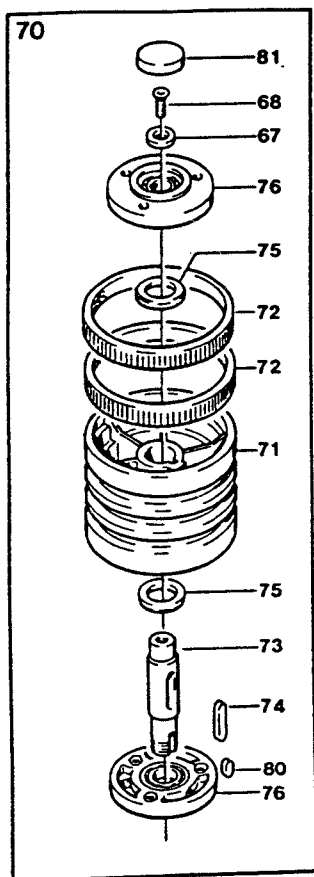
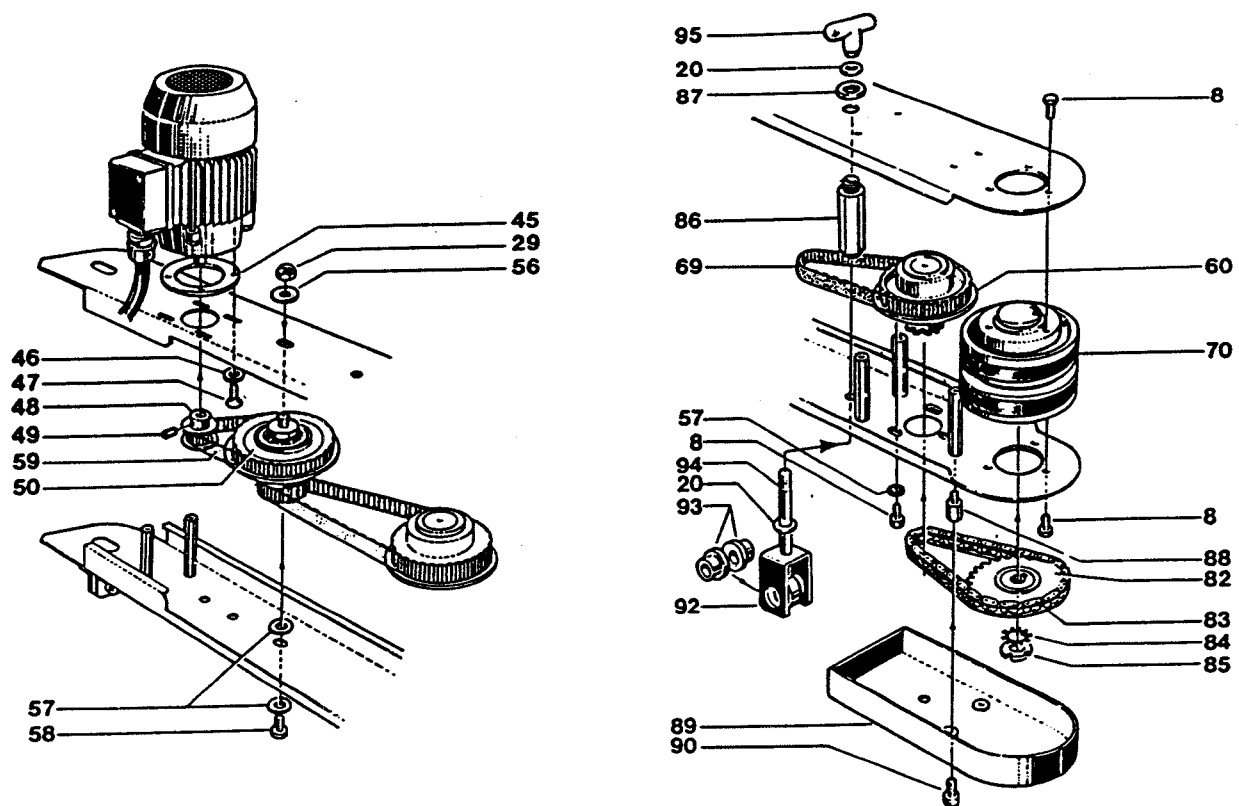


Figure 2403/2 of 2

Figure 2403 (Page 2 of 2)

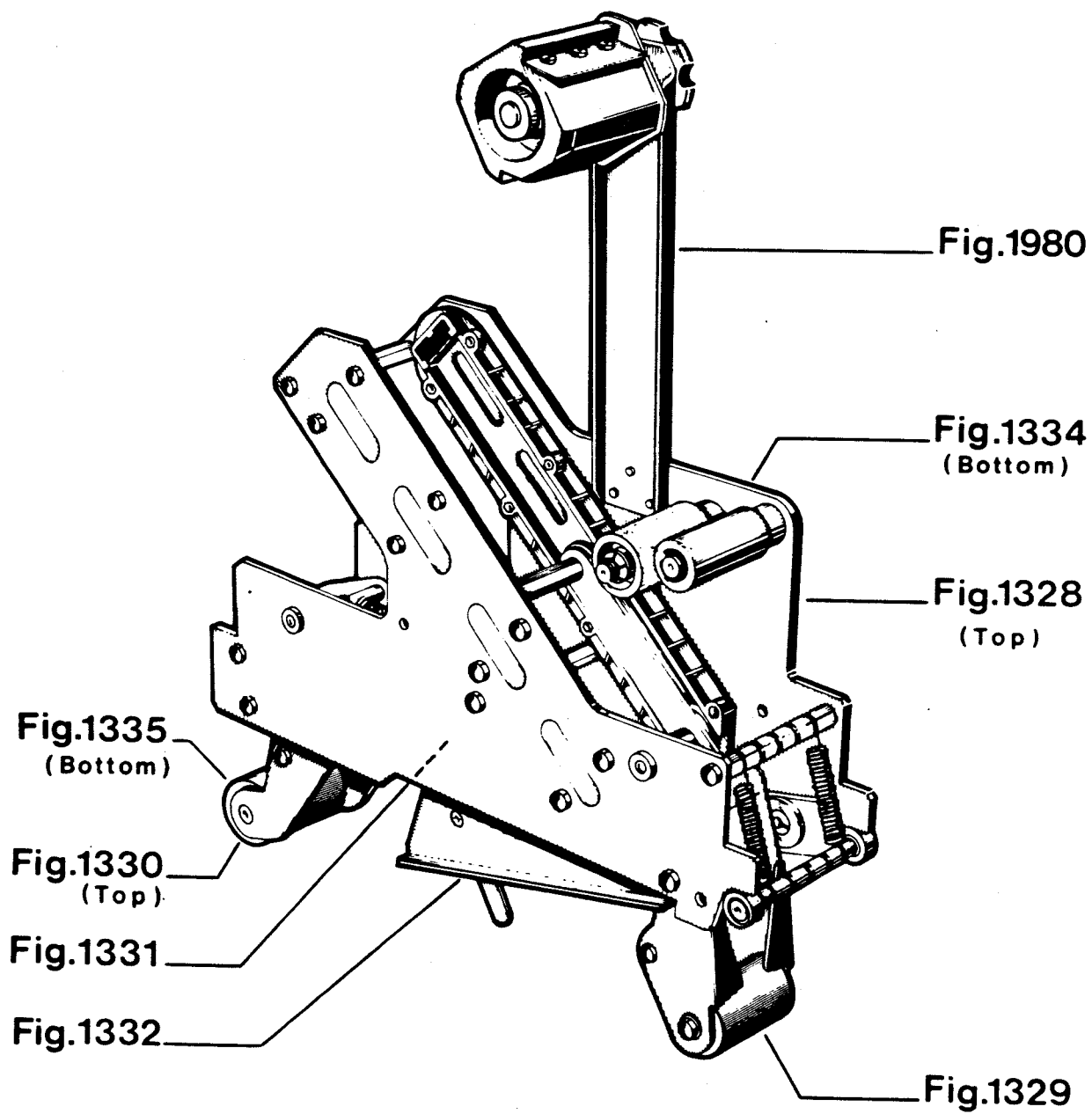
Ref. No.	3M Part No.	Description
2403-49	26-1003-8816-9	Screw - Set M5 x 6
2403-50	78-8060-8134-1	Wrap Pulley Assembly
2403-51	78-8060-8135-8	Pulley - Wrap
2403-52	78-8023-2410-9	Bearing - 6000-2RS
2403-53	78-8023-2544-5	Bearing - 6203-2RS
2403-54	78-8055-0665-2	Shaft - Pulley Wrap
2403-55	78-8016-5855-6	E-Ring - 10 mm
2403-56	26-1004-5507-5	Washer - M8
2403-57	78-8042-2919-9	Washer - M6
2403-58	78-8032-0375-7	Screw - Hex Hd M6 x 16 Metric
2403-59	78-8060-8140-8	Timing Belt 160XL050
2403-60	78-8060-8136-6	Drive Pulley Assembly - Keyed
2403-61	78-8054-8886-9	Pulley - Keyed
2403-62	78-8054-8889-3	Support - Pulley Keyed
2403-63	26-1000-6036-2	Bearing - 6003-2RS
2403-64	78-8060-7547-5	Spacer - Bearing
2403-65	78-8028-8244-5	Key - 4 x 4 x 10 mm
2403-66	78-8060-8005-3	Sprocket - 3/8, 11 Teeth
2403-67	78-8054-8877-8	Washer - 5,5/20X4
2403-68	26-0001-5862-1	Screw - Flat Hd Soc. M5 x 12
2403-69	78-8001-7176-7	Belt - Timing 225L050
2403-70	78-8060-8137-4	Drive Pulley Assembly
2403-71	78-8060-8138-2	Drive Pulley W/Ring
2403-72	78-8052-6713-1	Ring - Polyurethane
2403-73	78-8055-0669-4	Shaft - Pulley Keyed
2403-74	78-8057-5739-6	Key M5 x 5 x 30 mm
2403-75	78-8055-0668-6	Washer - 15/26 x 1
2403-76	78-8060-7648-1	Bearing - Flanged
2403-80	78-8046-8135-7	Key - 5 x 5 12 mm
2403-81	78-8060-7884-2	Protection Cover - Flange
2403-82	78-8054-8881-0	Sprocket - 3/8 Pitch, 28 Teeth
2403-83	78-8054-8882-8	Chain - 3/8 Pitch, 43 Pitch Long
2403-84	78-8057-5834-5	Tab Washer
2403-85	78-8057-5835-2	Centering Washer
2403-86	78-8060-8100-2	Bushing - Threaded
2403-87	78-8017-9096-1	Nut - M18 x 1 Special
2403-88	78-8054-8891-9	Screw - Special
2403-89	78-8055-0667-8	Cover - Chain Box
2403-90	26-1003-7948-1	Screw - Soc. Hd M5 x 10
2403-91	78-8055-0654-6	Drive Belt
2403-92	78-8054-8901-6	Bracket - Guide
2403-93	78-8054-8902-4	Bushing - Flanged
2403-94	78-8055-0666-0	Screw - Special
2403-95	78-8060-8055-8	Knob
2403-96	26-1003-7965-5	Screw - Soc Hd M8 x 25
2403-97	26-1003-7968-9	Screw Soc Hd M8 x 40
2403-98	78-8060-8161-4	Motor - 200V, 50/60HZ, 3 PH - Japan
2403-99	78-8060-8162-2	Motor - 220V, 60HZ, 3 PH - Korea
2403-100	78-8060-8163-0	Motor - 100V, 50/60HZ, Single PH - Japan
2403-101	78-8060-8164-8	Motor - 115V, 60HZ, Single PH - U.S.A.
2403-102	78-8060-8165-5	Motor - 230V, 50HZ, Single PH - Singapore
2403-103	78-8060-8432-9	Motor - 440V, 60HZ, 1 PH KWO.08 - Ireland
2403-104	78-8060-8074-9	Motor - 100V, 50/60HZ 1 PH

Replacement Parts Illustrations and Parts Lists
12A3 Adjustable Case Sealer, Model 18900
Taping Head Assemblies

1. Refer to 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 pages 18 and 19 - "Replacement Parts and Service Information" of this manual for replacement parts ordering information.



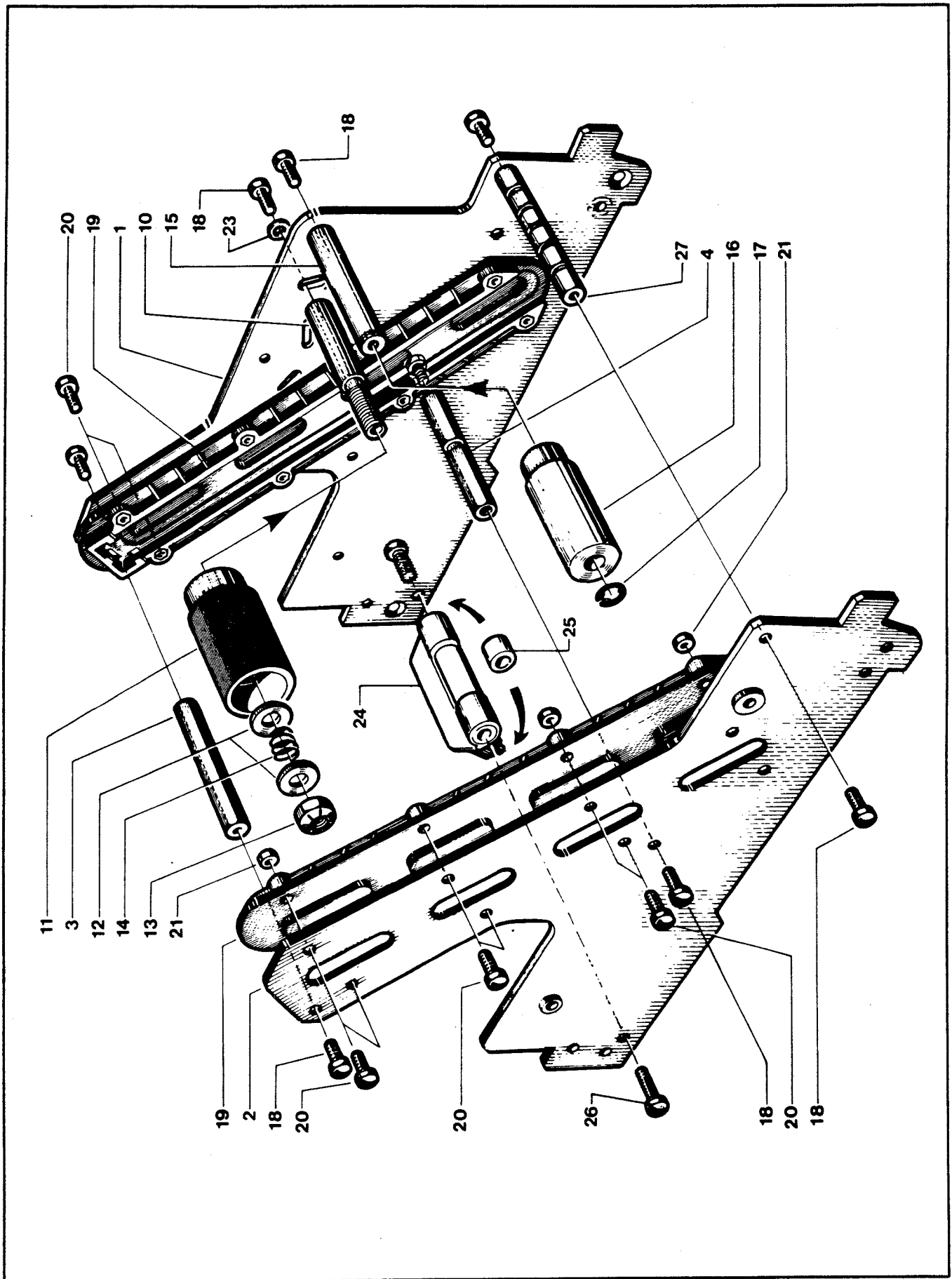


Figure 1328

(12A3)

Figure 1328

Ref. No.	3M Part No.	Description
1328-1	78-8052-6556-4	Frame - Right Hand Top
1328-2	78-8052-6557-2	Frame - Left Hand Top
1328-3	78-8054-8792-9	Spacer - Hex (Spring Hook)
1328-4	78-8054-8793-7	Spacer - Hex
1328-10	78-8054-8796-0	Shaft - Tension Roller
1328-11	78-8054-8797-8	Roller - Top Tension
1328-12	78-8052-6566-3	Washer - Friction
1328-13	78-8017-9077-1	Nut - Self-Locking, M10 x 1
1328-14	78-8052-6567-1	Spring - Compression
1328-15	78-8054-8798-6	Shaft - Wrap Roller
1328-16	78-8054-8799-4	Roller - Wrap
1328-17	26-1000-1613-3	Ring - Retaining 10DIN6799
1328-18	26-1003-5828-7	Screw - Hex Hd M6 x 12 Zinc Pl.
1328-19	78-8052-6570-5	Guide
1328-20	83-0002-7336-3	Screw - Hex Hd M4 x 14 Zinc Pl.
1328-21	78-8010-7416-8	Nut - Hex M4 Metric
1328-23	26-1000-0010-3	Washer - Flat M6
1328-24	78-8060-7936-0	Brush Assy
1328-25	78-8060-7937-8	Spacer - 6,5/14 x 12,5
1328-26	78-8060-7938-6	Screw - Special M6 x 25
1328-27	78-8060-7939-4	Spacer - 10 x 115 w/slots

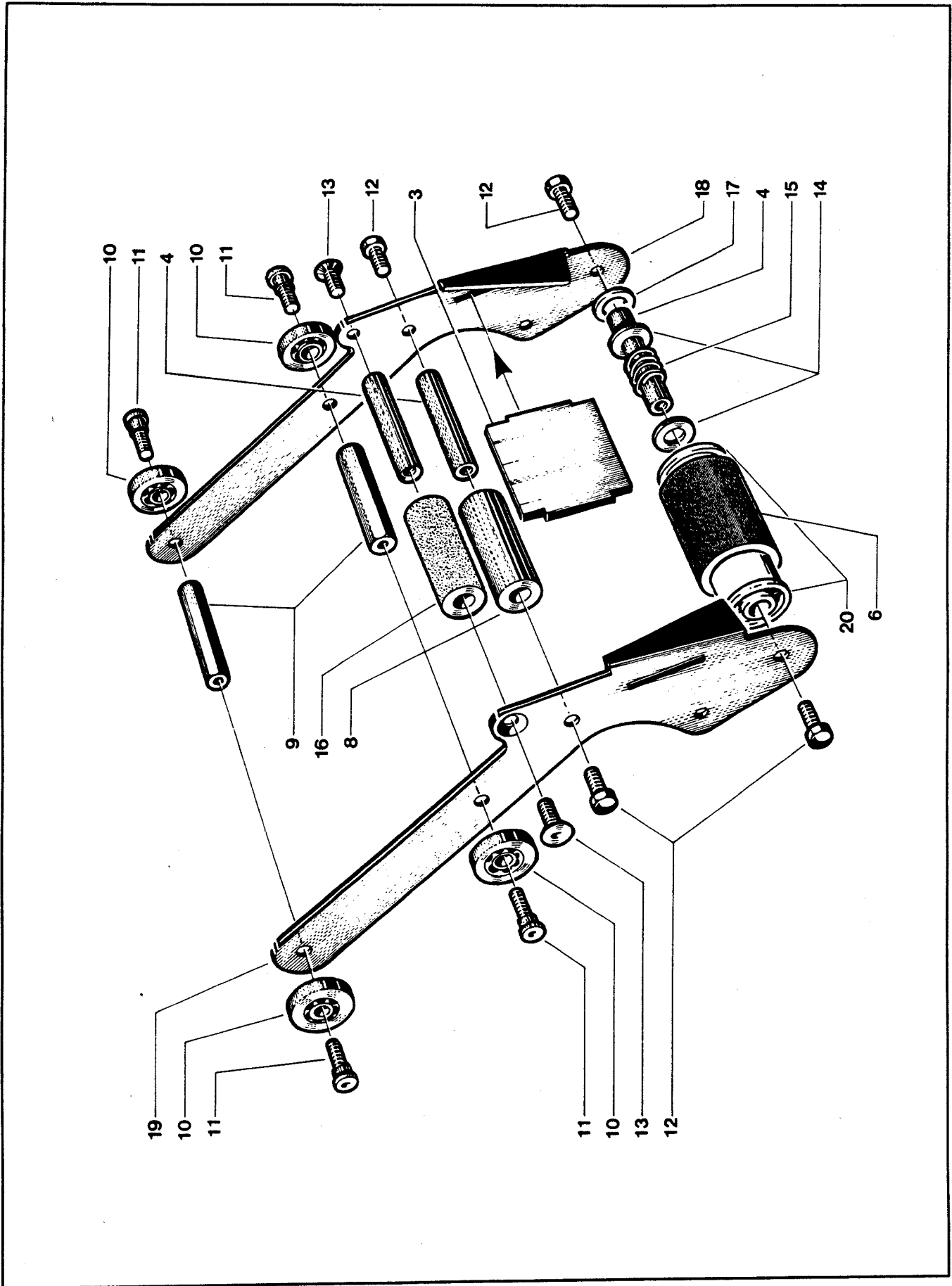


Figure 1329

(12A3)

Figure 1329

Ref. No.	3M Part No.	Description
1329-3	78-8054-8800-0	Plate - Back up
1329-4	78-8054-8801-8	Shaft - Roller
1329-6	78-8057-6181-0	Roller - Applying
1329-8	78-8054-8805-9	Roller - Wrap
1329-9	78-8054-8806-7	Spacer
1329-10	78-8017-9082-1	Bearing - Special 30 mm
1329-11	78-8017-9106-8	Screw - Bearing Shoulder
1329-12	26-1003-5828-7	Screw - Hex Hd M6 x 12 Zinc Pl.
1329-13	26-1005-4759-0	Screw - Flat Hd M6 x 12 Zinc Pl.
1329-14	78-8052-6566-3	Washer - Friction
1329-15	78-8052-6567-1	Spring - Compression
1329-16	78-8060-7940-2	Roller - Knurled
1329-17	78-8017-9074-8	Washer - Nylon 15 mm
1329-18	78-8060-8170-5	Frame - Applying, Right
1329-19	78-8060-8171-3	Frame - Applying, Left
1329-20	78-8060-8396-6	Bushing - Applying Roller

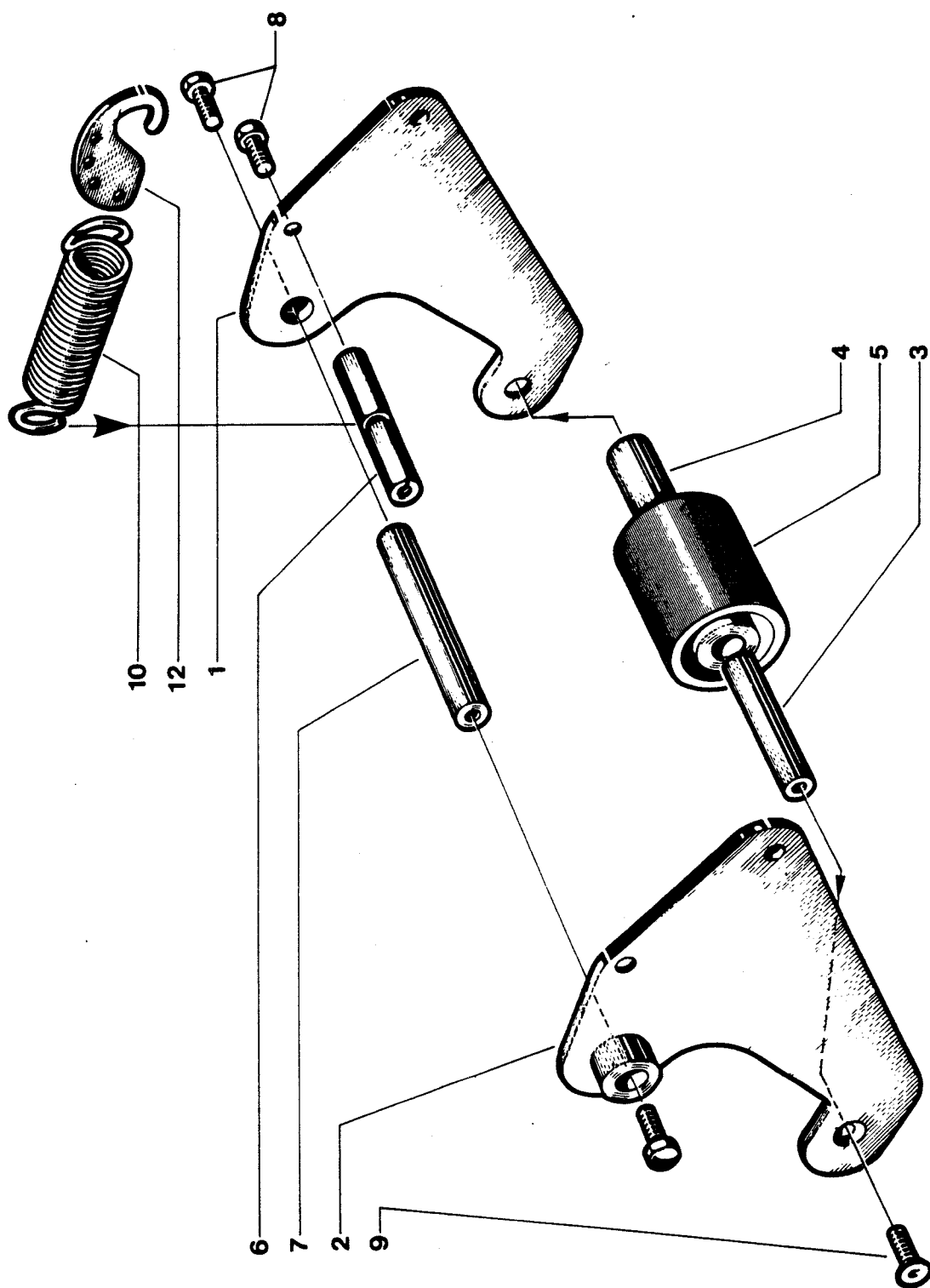


Figure 1330 Top

(12A3)

Figure 1330

Ref. No.	3M Part No.	Description
1330-1	78-8052-6583-8	Frame - Right Hand
1330-2	78-8052-6584-6	Frame - Left Hand
1330-3	78-8054-8801-8	Shaft - Rollre
1330-4	78-8054-8807-5	Bushing - Buffing Roller
1330-5	78-8054-8808-3	Roller - Buffing
1330-6	78-8054-8809-1	Spacer - Spring
1330-7	78-8028-7885-6	Shaft - 10 x 115 mm
1330-8	26-1003-5828-7	Screw - Hex Hd M6 x 10 Zinc Pl.
1330-10	78-8052-6589-5	Spring - Top Extension
1330-12	78-8052-6590-3	Holder - Spring

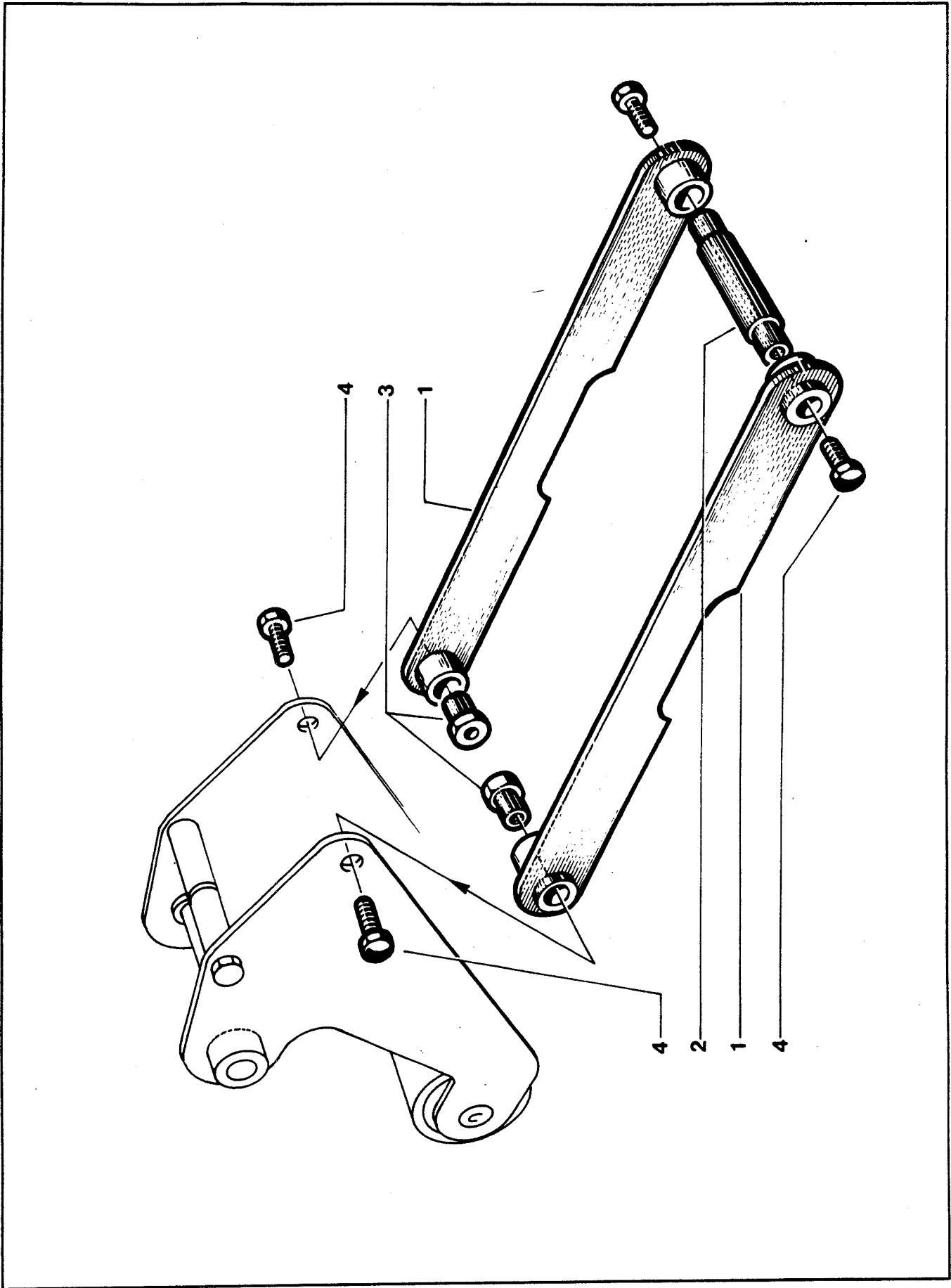


Figure 1331

(12A3)

Figure 1331

Ref. No.	3M Part No.	Description
1331-1	78-8052-6592-9	Arm - Link
1331-2	78-8054-8810-9	Shaft - Pivot
1331-3	78-8052-6594-5	Bushing - Pivot
1331-4	78-8010-7163-6	Screw - Hex Hd M5 x 10 Metric

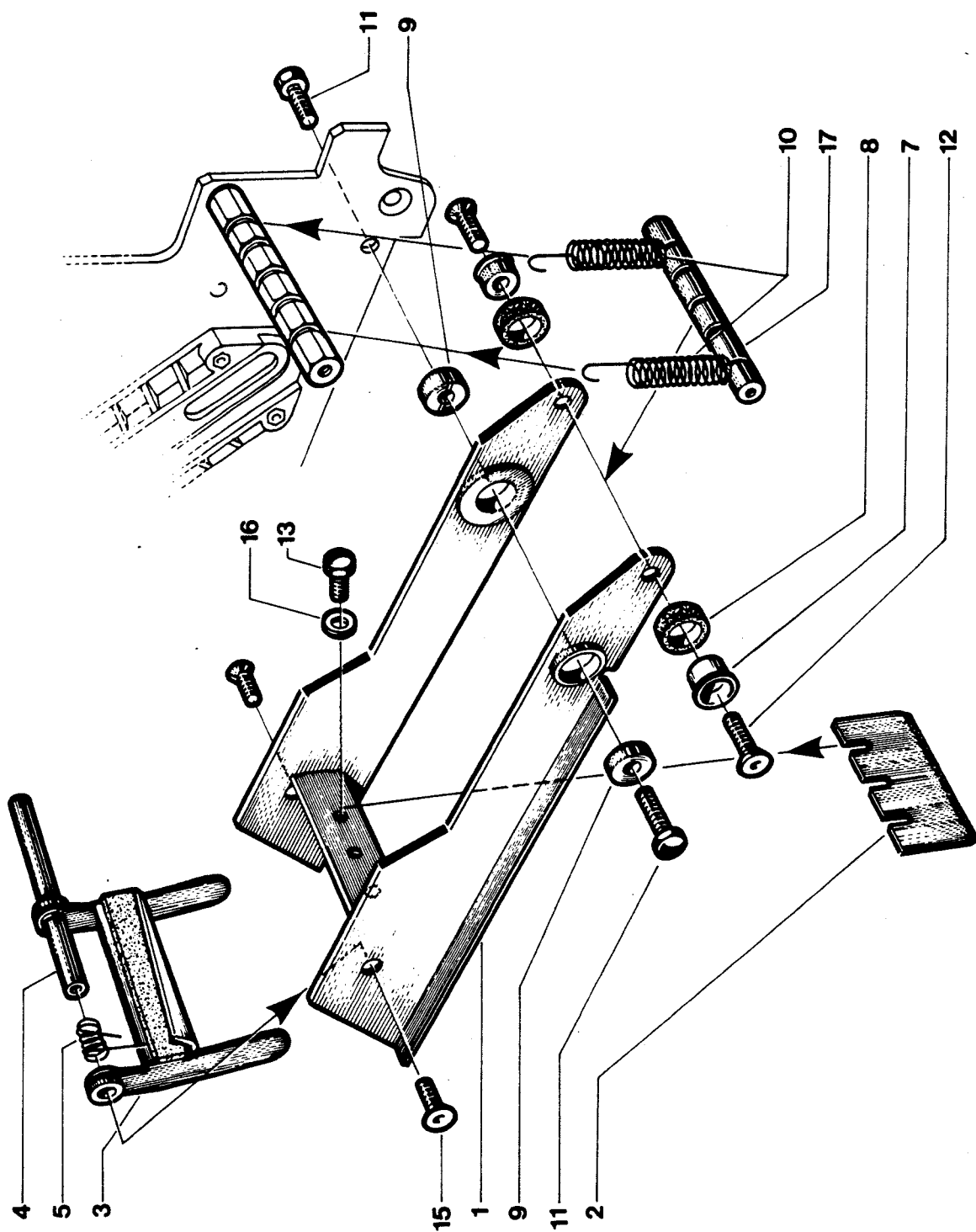


Figure 1332

(12A3)

Figure 1332

Ref. No.	3M Part No.	Description
1332-1	78-8054-8811-7	Bracket - Cut-Off
1332-2	78-8028-7899-7	Blade - 3.50 inch/89 mm
1332-3	78-8054-8812-5	Guard - Blade
1332-4	78-8054-8813-3	Shaft - Blade Guard
1332-5	78-8052-6598-6	Spring - Tension
1332-6	78-8028-7898-9	Pin - Spring Holder
1332-7	78-8052-6600-0	Sleeve - Bumper
1332-8	78-8017-9133-2	Bumper
1332-9	78-8017-9132-4	Pivot - Cutter Lever
1332-10	78-8052-6602-6	Spring - Cutter
1332-11	26-1003-5828-7	Screw - Hex Hd M6 x 10 Zinc Pl.
1332-12	26-1005-4758-2	Screw - Flat Hd M5 x 20 Zinc Pl.
1332-13	78-8052-6747-9	Screw - Collar M5 x 8 Zinc Pl
1332-15	26-1005-4757-4	Screw - Flat Hd M4 x 10 Zinc Pl.

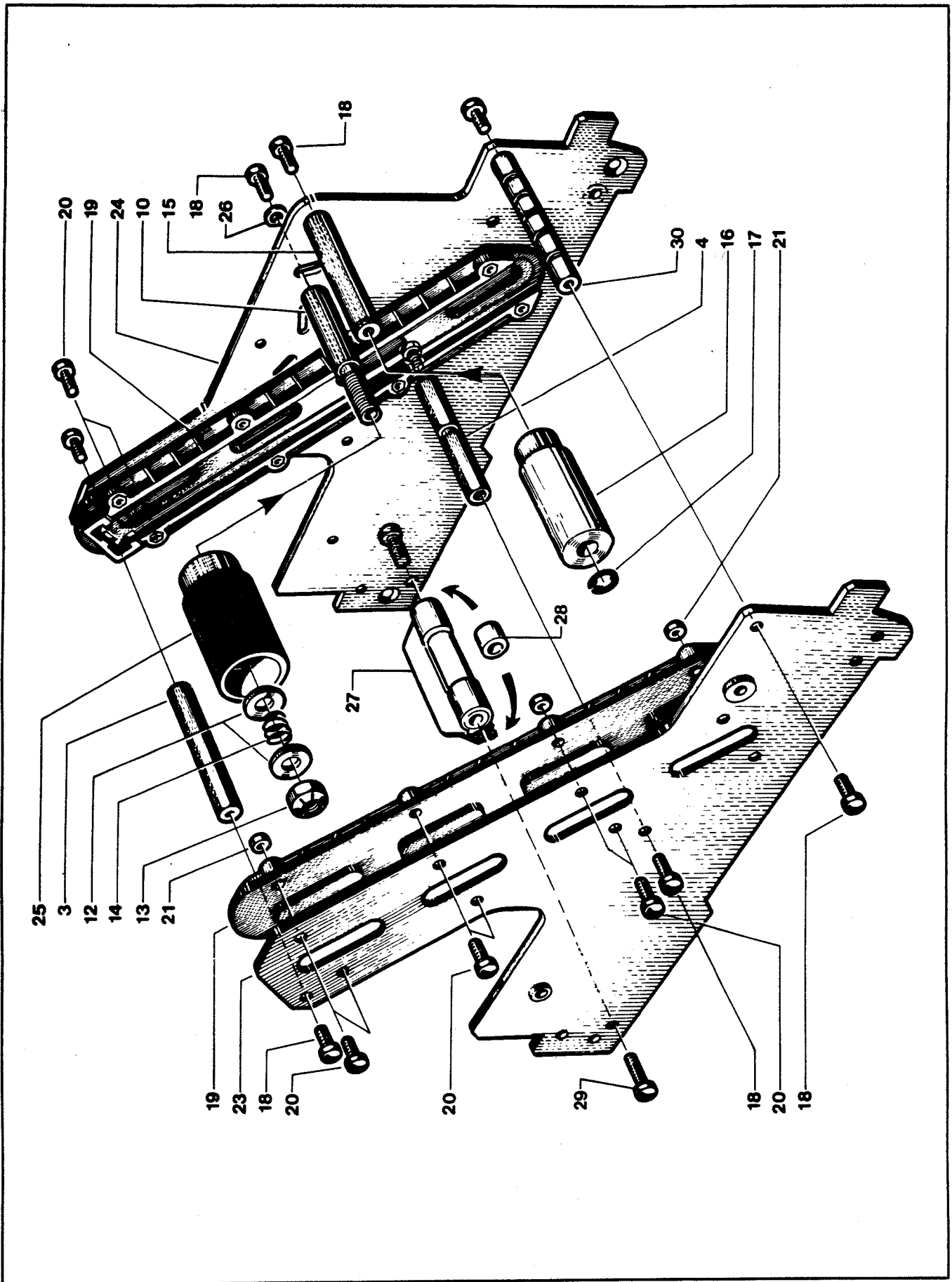


Figure 1334

(12A3)

Figure 1334

Ref. No.	3M Part No.	Description
1334-3	78-8054-8793-7	Spacer - Hex
1334-4	78-8054-8792-9	Spacer - Hex (Spring Hook)
1334-10	78-8054-8796-0	Shaft - Tension Roller
1334-12	78-8052-6566-3	Washer - Friction
1334-13	78-8017-9077-1	Nut - Self-Locking M10 x 1
1334-14	78-8052-6567-1	Spring - Compression
1334-15	78-8054-8798-6	Shaft - Wrap Roller
1334-16	78-8054-8799-4	Roller - Wrap
1334-17	26-1000-1613-3	Ring - Retaining 10DIN6799
1334-18	26-1003-5828-7	Screw - Hex Hd M6 x 12 Zinc Pl.
1334-19	78-8052-6570-5	Guide
1334-20	83-0002-7336-3	Screw - Hex Hd M4 x 14 Zinc Pl.
1334-21	78-8010-7416-8	Nut - Hex M4 Metric
1334-23	78-8052-6604-2	Frame - Left Hand Bottom
1334-24	78-8052-6605-9	Frame - Right Hand Bottom
1334-25	78-8054-8817-4	Roller - Tension Bottom
1334-26	26-1000-0010-3	Washer - Flat M6
1334-27	78-8060-7936-0	Brush Assy
1334-28	78-8060-7937-8	Spacer - 6,5/14 x 12,5
1334-29	78-8060-7938-6	Screw - Special M6 x 25
1334-30	78-8060-7939-4	Spacer - 10 x 115 w/slots

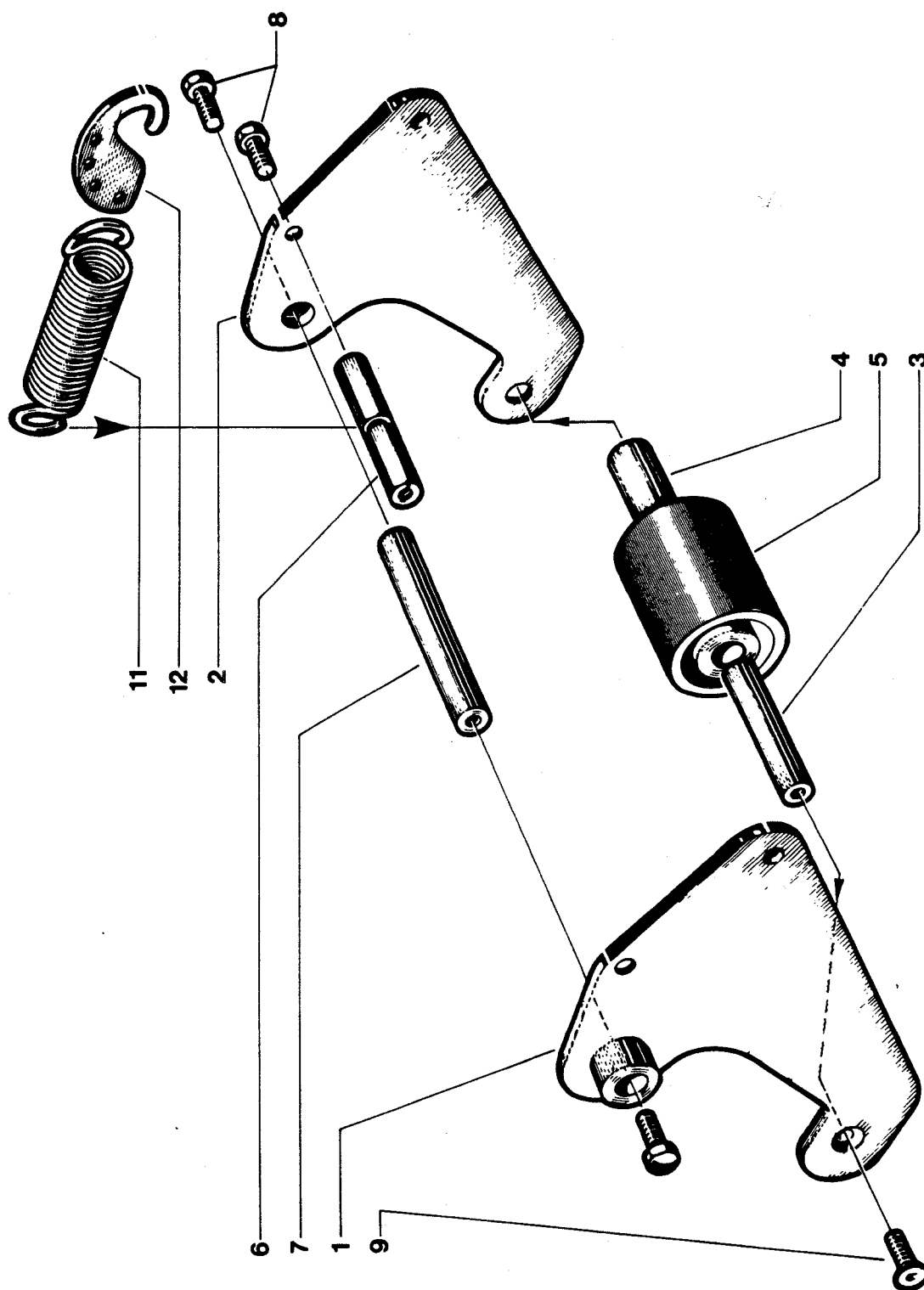


Figure 1335 Bottom

(12A3)

Figure 1335

Ref. No.	3M Part No.	Description
1335-1	78-8052-6583-8	Frame - Right Hand
1335-2	78-8052-6584-6	Frame - Left Hand
1335-3	78-8054-8801-8	Shaft - Roller
1335-4	78-8054-8807-5	Bushing - Buffing Roller
1335-5	78-8057-6180-2	Roller - Buffing
1335-6	78-8054-8809-1	Spacer - Spring
1335-7	78-8028-7885-6	Shaft - 10 x 115 mm
1335-8	26-1003-5828-7	Screw - Hex Hd M6 x 10 Zinc Pl.
1335-11	78-8054-8550-1	Main Spring - Bottom Head
1335-12	78-8052-6590-3	Holder - Spring

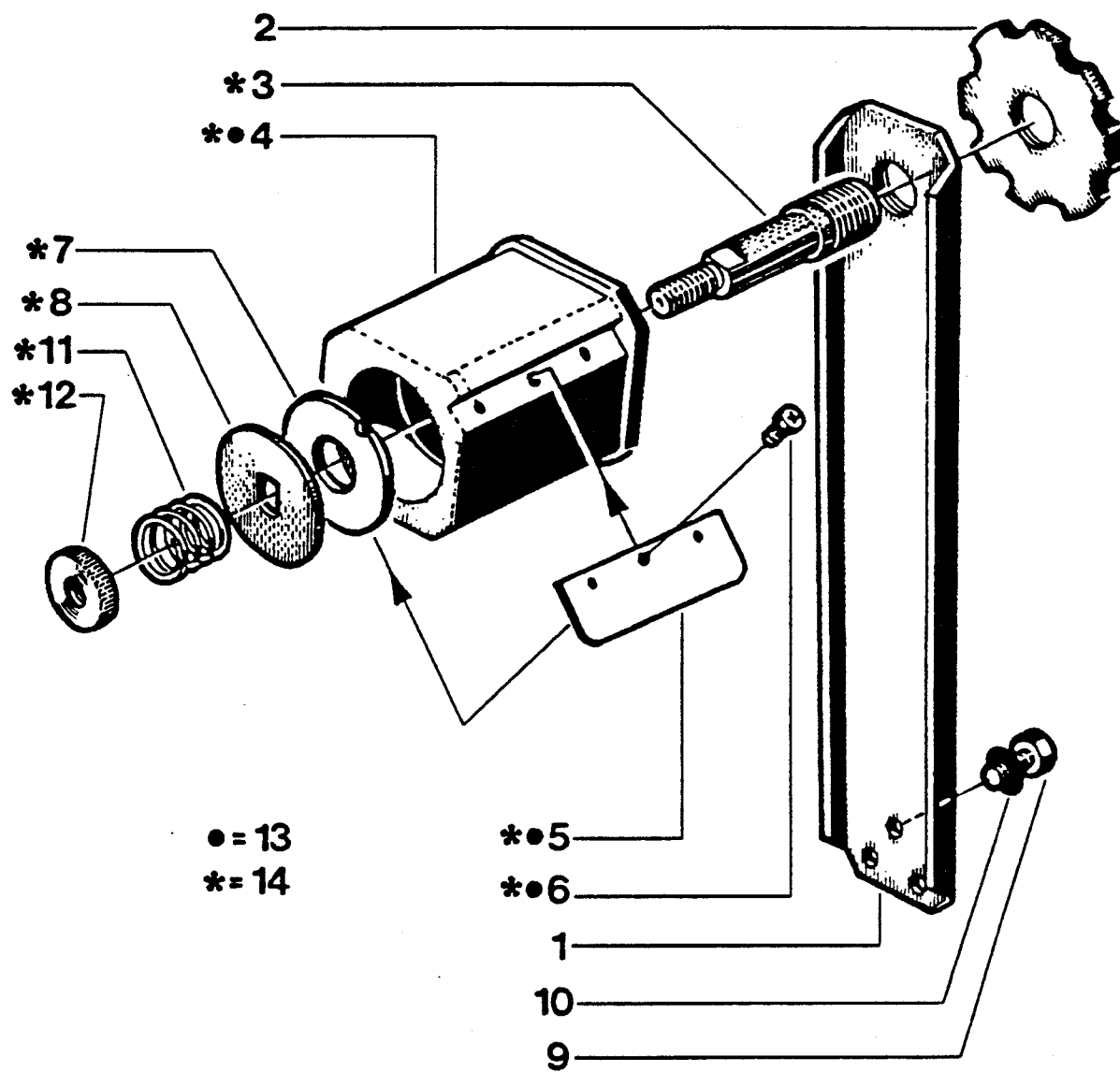


Figure 1980

(12A3)

Figure 1980

Ref. No.	3M Part No.	Description
1980-1	78-8052-6544-0	Bracket - Tape Drum
1980-2	78-8017-9091-2	Plate - Locking, Tape Drum Shaft
1980-3	78-8060-8462-6	Shaft - Tape Drum 3 Inch Head
1980-4	78-8054-8815-8	Tape Drum Assembly
1980-5	78-8054-8816-6	Leaf Spring
1980-6	26-1002-5753-9	Screw - Self Taping
1980-7	78-8060-8172-1	Washer - Friction
1980-8	78-8052-6271-0	Washer - Tape Drum
1980-9	26-1003-5829-5	Screw - Hex Hd M6 x 12
1980-10	26-1000-0010-3	Washer - Flat M6
1980-11	78-8054-8826-5	Spring
1980-12	78-8060-7851-1	Ring Nut - Adjusting
1980-13	78-8076-4731-4	Tape Drum Assembly 3 Inch Wide
1980-14	78-8076-4732-2	Tape Drum Assembly 3 Inch With Shaft

