

Instructions and Parts List

3M-Matic™ Accuglide™ 4 High Performance Taping Heads 2 and 3 Inch Type 11800

Serial #: _____
For reference, record machine serial number here.

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.

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 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 - Accuglide 4 (2 & 3 inch) Taping Head - Type 11800 - 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 <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"/>

Replacement Parts and Service Information *(continued)*

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 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.

Table of Contents - Manual 2: Accuglide 4 High Performance - 2 and 3 inch (Upper and Lower Taping Heads)

Accuglide 4 High Performance Taping Head Manual - 2 and 3 inch	Page
Cover Page.....	i
Replacement Parts and Service Information	iii– v
Table of Contents	vii
Equipment Warranty and Limited Remedy.....	viii
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
Taping Head Components.....	9
Tape Loading – Upper Taping Head.....	10-11
Tape Loading – Lower Taping Head	
Maintenance	12-13
Tools.....	12
Blade Replacement.....	12
Blade Guard	12
Cleaning	13
Adjustments.....	14-15
Tape Alignment and Tracking	14
Applying Mechanism Spring	15
One-Way Tension Roller.....	15
Tape Roll Brake.....	15
Tape Leg Length.....	16
Leading Tape Leg Length Adjustment.....	16
Troubleshooting Guide	17-18
Spare Parts/Service Information	19
Recommended Spare Parts	19
Replacement Parts and Service.....	19

Warranty

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™ Accuglide 4 Taping Head, Type 11800** with the following warranties:

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 (1) years after delivery.

If any part is defective within this warranty period, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to repair or replace the part. 3M must receive actual notice of any alleged defect within a reasonable time after it is discovered, but in no event shall 3M have any obligation under this warranty unless it receives such notice within five (5) business days after the expiration of the warranty period.

All notices required hereunder shall be given to 3M solely through the 3M-Matic™ Help line (800-328-1390). To be entitled to repair or replacement as provided under this warranty, the part must be returned as directed by 3M to its factory or other authorized service station designated by 3M. If 3M is unable to repair or replace the part within a reasonable time after receipt thereof, 3M, at its option, will replace the equipment or refund the purchase price. 3M shall have no obligation to provide or pay for the labor required to remove any part or equipment or to install the repaired or replacement part or equipment. 3M shall have no obligation to repair or replace those parts failing due to normal wear, inadequate or improper maintenance, inadequate cleaning, non-lubrication, improper operating environment, improper utilities, operator error or misuse, alteration or modification, mishandling, lack of reasonable care, or due to any accidental cause.

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

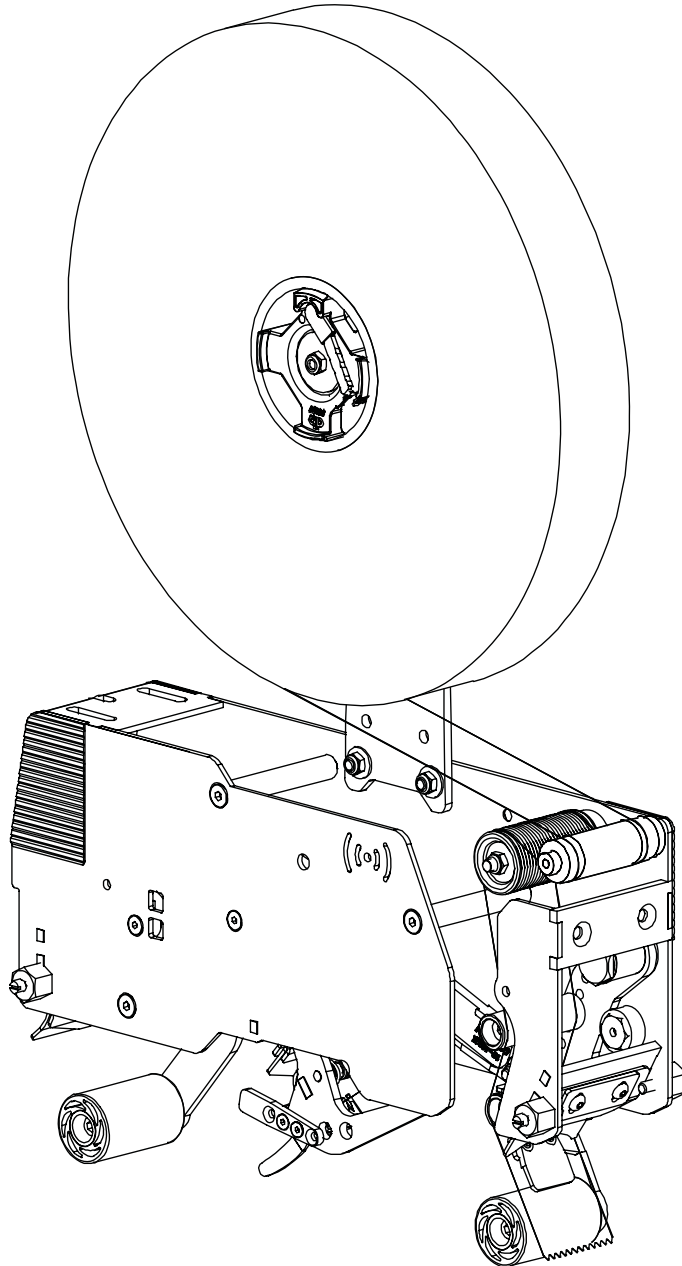
Note: The foregoing Equipment Warranty and Limited Remedy and Limitation of Liability may be changed only by a written agreement signed by authorized representatives of 3M and seller.

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

Intended Use

The intended use of the **AccuGlide™ 4 High Performance - 2 and 3 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.

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™ 4 High Performance Taping Heads - 2 and 3 Inch** have been designed and tested for use with Scotch® pressure-sensitive film box sealing tape.



AccuGlide™ 4 Upper Taping Head - 2 and 3 inch, Type 11800

Taping Head Contents

AccuGlide™ 4 High Performance - 2 and 3 Inch Upper and Lower Taping Heads consist of:

Qty.	Part Name
1	Taping Head Assembly
1	Tape Drum and Bracket Assembly

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 4 (2 and 3 inch)** 3M Industrial Adhesives and Tapes Division 3M Center, Bldg. 220-5E-06 St. Paul, MN 55144-1000 (USA) Edition April 2018 / Copyright 3M 2018. All rights reserved The manufacturer reserves the right to change the product at any time without notice.

Publication © 3M 2018. 44-0009-2146-8.

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.

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 4 - 2 and 3" - Type 11800 - 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

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.



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



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



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



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 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.

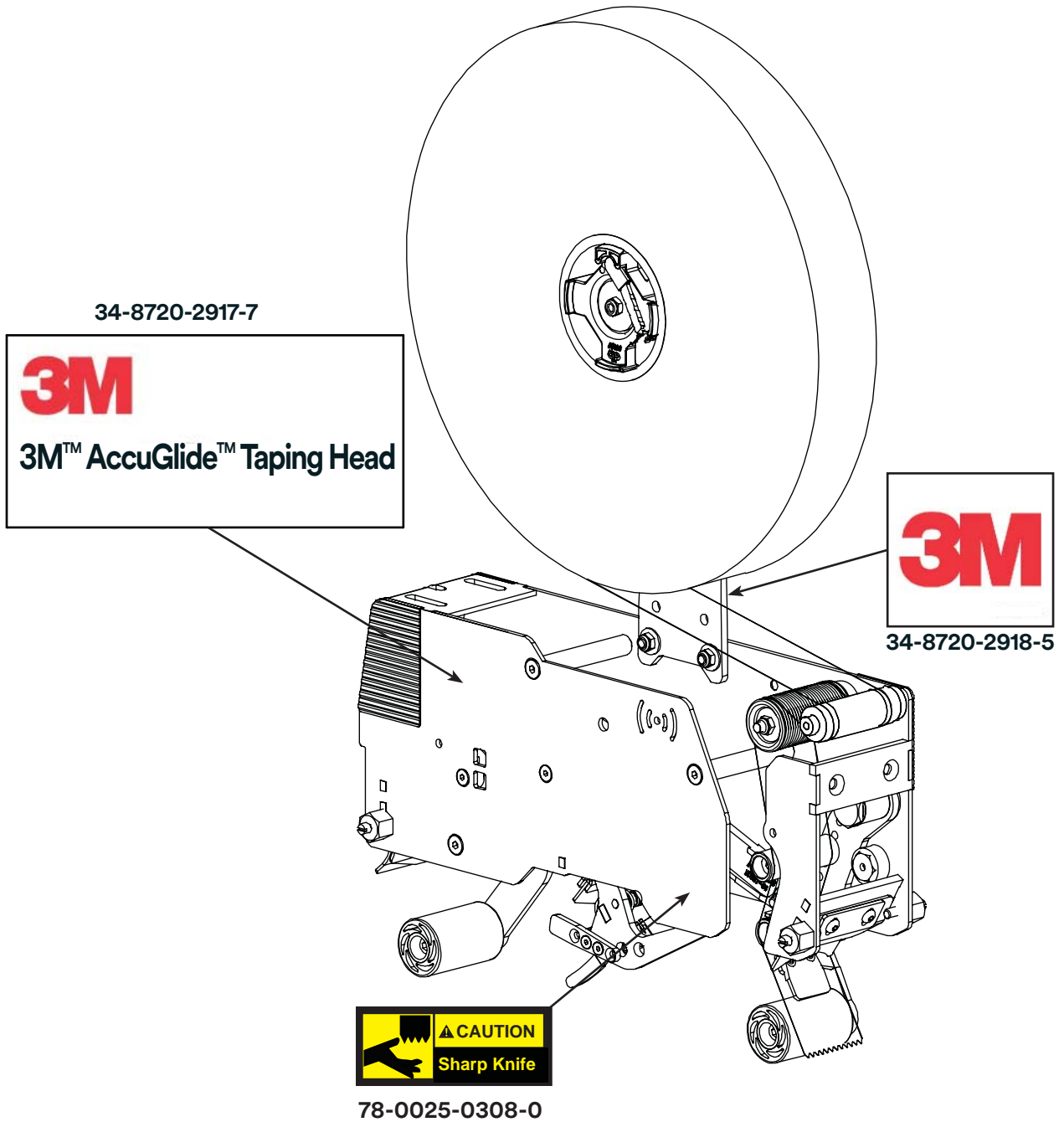


Figure 1-1 Replacement Labels/3M Part Numbers

Specifications

1. Tape:

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

2. Tape Width:

48mm [2 inches] to 72mm [3 inches].

3. Tape Roll Diameter:

Up to 390mm [15 1/2 inches] maximum on a 76.2mm [3 inch] diameter core.
(Accommodates all system roll lengths of Scotch® film tapes.)

4. Tape Application Leg Length -

1.25 inches [31mm] to 2.75 [70mm]inches.

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 0.76m/s [150fpm] maximum.

Note: Higher speeds require special taping head adjustment.

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 – 380mm [14.96 inches]

Height – 363mm [14.29 inches] (with tape)

Width – 2” Tape Head 3.15 inches [80mm] - 3” Tape Head 4 inch [101mm]

Weight – Packaged: 2” - 14.3 lbs. [6.49kg] 3” - 15.1 lbs. [6.85kg]

Unpackaged: 2” - 12.9 lbs [5.85kg] 3” - 13.9 lbs. [6.30kg]

(Specifications *continued* on next page.)

Specifications (continued)

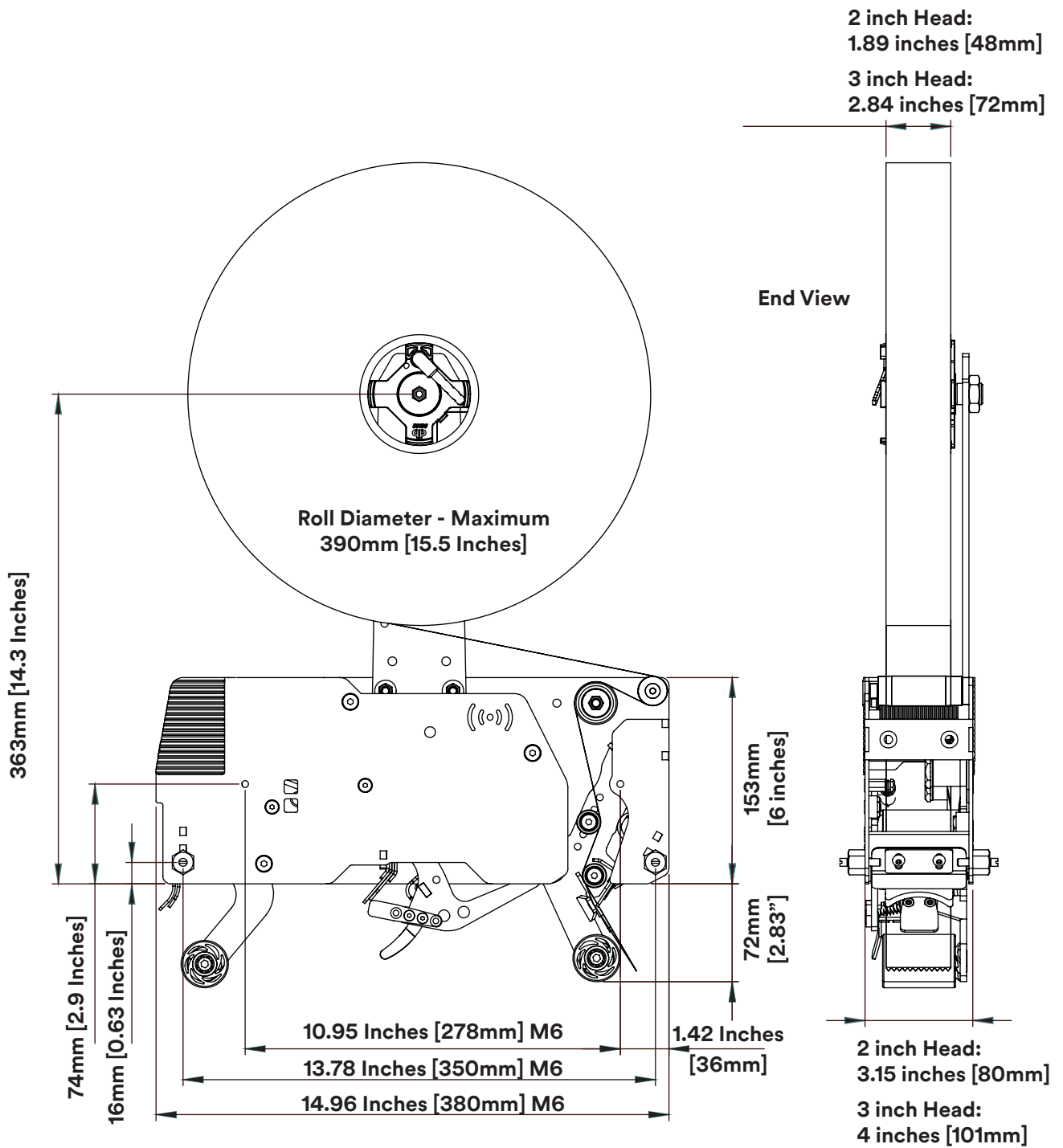


Figure 2-1 Dimensional Drawing

Installation



Warning

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

Receiving And Handling

After the taping head assembly has been unpackaged, examine the unit for damage that might have occurred during transit. If damage is evident, file a damage claim immediately with the transportation company and also notify your 3M Representative.

Installation Guidelines

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

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 0.81 m/s [160 feet per minute], past the taping head assembly since the box motion actuates the taping mechanism.



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.

2. If a dancer arm is present, pull the shaft until the latches stops it in place. This will prevent the dancer arm from interfering with the reloading process.
3. Information is provided for the physical dimensions and mounting locations for both the 2” and 3” Taping Heads in **Figure 2-1**.
4. Turn lock lever away from locking position. Remove spent core. Reload with a new roll (make sure the adhesive side of tape faces toward incoming cartons). Return lock lever to secure position after reloading tape. Also check and make sure the spring lock was not bent during this process.
Note: Make sure lock lever is in correct position during and after loading. Pushing or pulling a roll of tape while lock is engaged may bend spring lock. If lock is deformed, the lock must be bent back to a straight position.
5. Press release latch on dancer arm (if present) so dancer arm roller rests between new tape roll and tape thread.

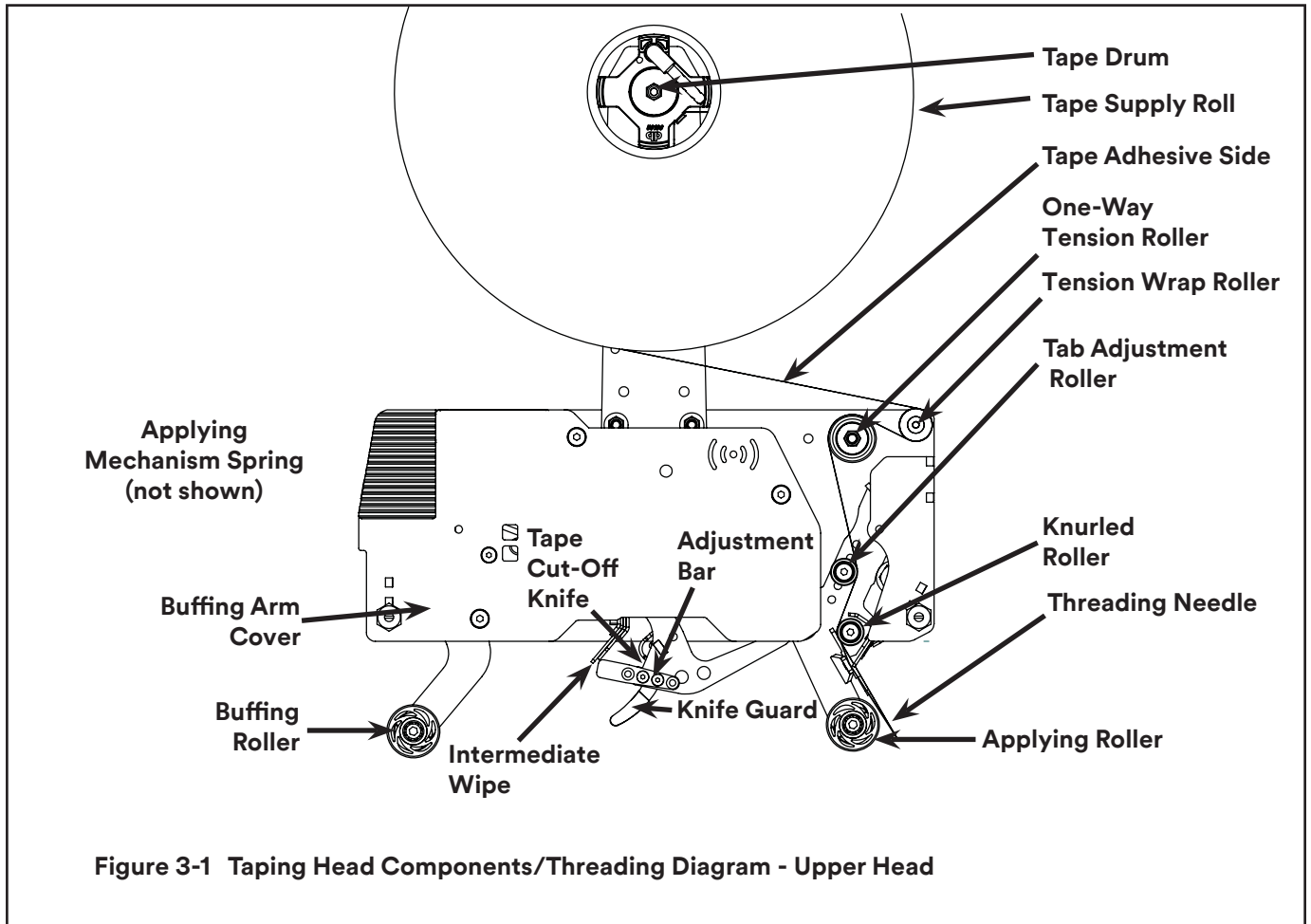
Tape Leg Length

Taping heads are factory set to apply tab length 2” (48mm) to tape leg. Both upper and lower heads must be set to apply the same tape leg length. Also, conveyor speed at which the product moves through 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” set-up procedure.

Operation



Operation *(continued)*



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.

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: If practical, remove tape roll before removing taping head from machine to minimize weight.

Note: Threading can usually be accomplished without removing the tape applicator from the case sealer, due to the open design. Arrow shaped stickers along the rollers should direct threading of tape.

Tape Loading – Upper Taping Head

1. Place the upper taping head in a convenient working position.
2. Using **Figures 3-2/3-3/3-4/3-5 and 3-6**. Position tape roll so adhesive side of tape faces front of taping head as it's pulled from supply roll.
3. Thread tape over dancer arm roller (if dancer arm used). Guide tape around tension wrap roller (**Position 1**) then around one-way tension roller (**Position 2**).
4. Pull it over knurled roller so adhesive side is in contact with this roller (**Position 3**).
5. Pull tape down over tab adjustment roller. Pull it under knurled roller and between crescent tape guide and support pad (**Position 4**) The tape should extend $\frac{1}{2}$ " - 13mm) past the applying/compression roller).
6. Cut away any excess tape.

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

Tape Loading – Lower Taping Head

See upper head instructions.



Warning

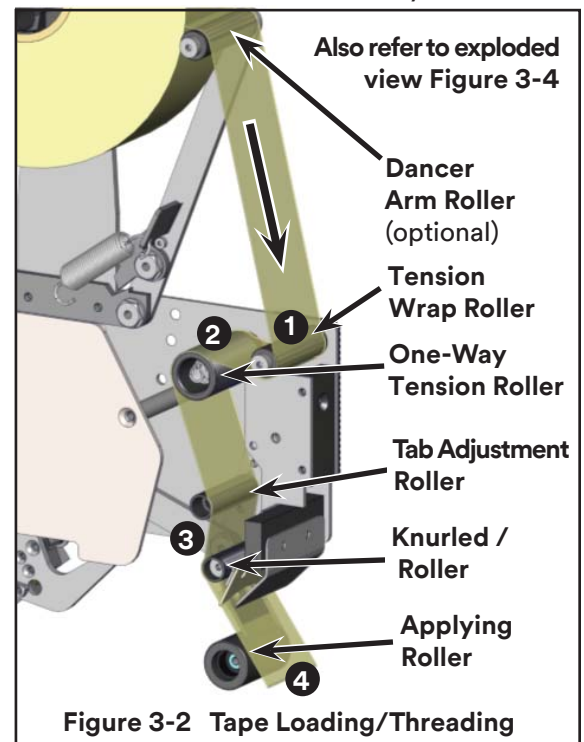
- **To reduce the risk associated with shear, pinch, and entanglement hazards**
 - Turn air and electrical supplies off on associated equipment before performing any adjustments, maintenance, or servicing the taping heads
 - Never attempt to work on the taping head or load tape while the box drive system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



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

Figure 3-3: Insert threading needle through rollers in direction indicated by arrows.



Operation *(continued)*

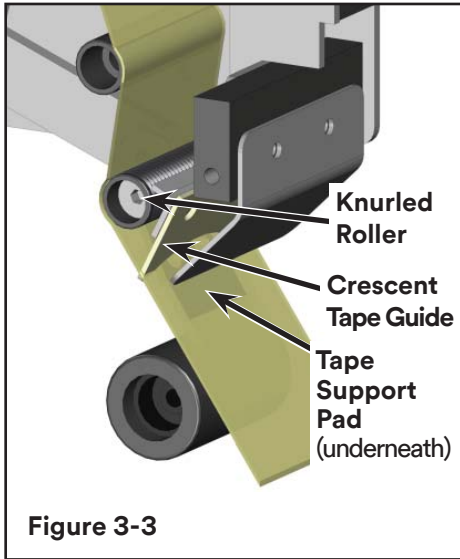


Figure 3-3

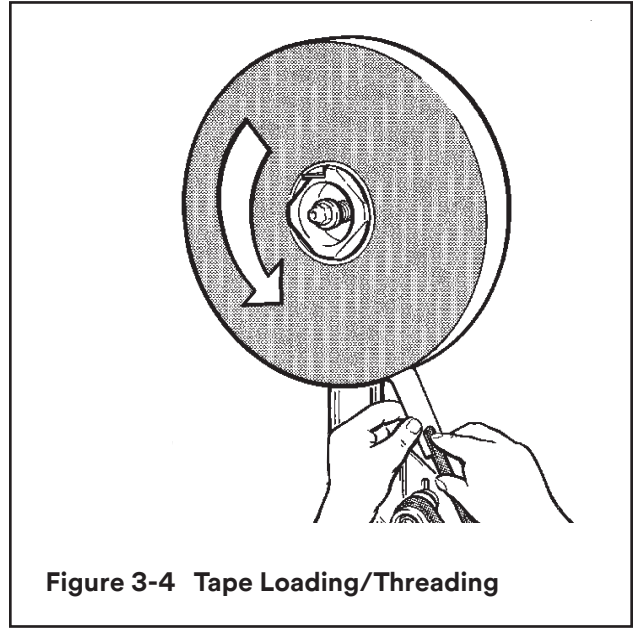


Figure 3-4 Tape Loading/Threading

Figure 3-4 and 3-5

Place tape roll on tape drum to dispense tape with adhesive side forward. Seat tape roll fully against back flange of drum.

Manually turn tape roll to create slack tape while pulling tape through tape applying mechanism until tape is through and tape is in alignment with applying roller. Excess tape can be cut with a scissors at 1/2 inch past the applying roller.

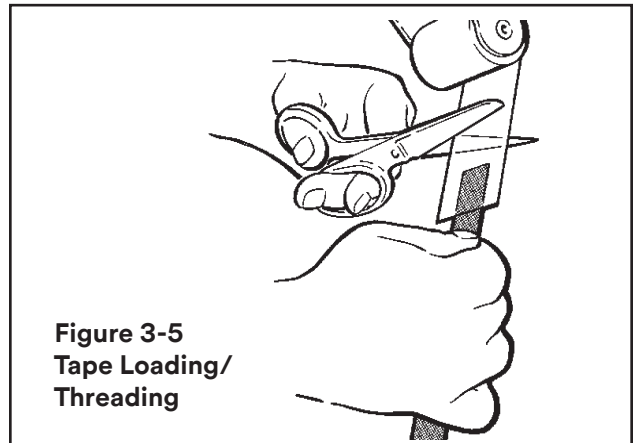


Figure 3-5
Tape Loading/
Threading

⚠ 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.

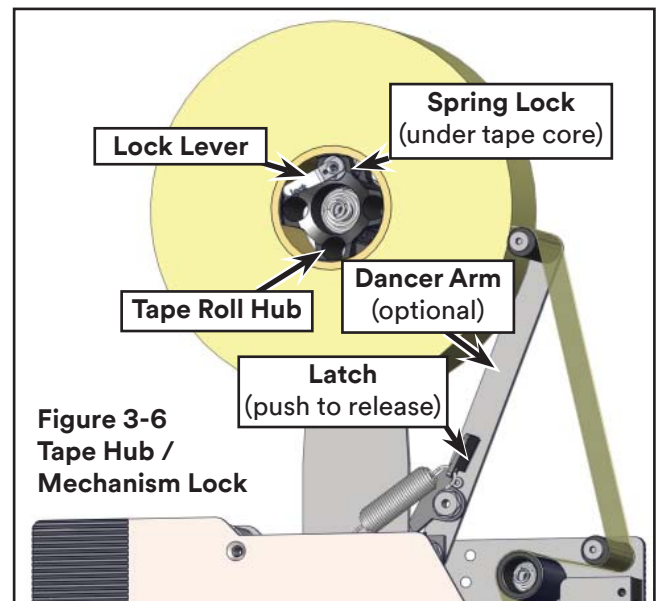


Figure 3-6
Tape Hub /
Mechanism Lock

Maintenance

The **AccuGlide™ 4 High Performance 2 and 3 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 product.

Tools

Metric Hex Keys - Ball end set recommended. 2mm, 2.5mm, 3mm, 4mm, 5mm, and 6mm.

Wrenches - 8mm, 10mm, 5/18 inch, 15/16 inch.

Thread Lock Compound/Fasteners - Critical fasteners may be secured with thread locking compound. To loosen and remove a difficult fastener, apply heat.

Blade Replacement

Upper and Lower Taping Heads – **Figure 4-1**

1. Remove Blade Screw (position 1).
2. Remove blade cover plate and blade (position 2).
3. Replace blade and cover plate.
4. Reinsert and tighten screw.

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

Blade Guard

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

Blade Grease Pad

To reduce adhesive build-up, the taping heads are equipped with a factory pre-lubricated felt grease pad that provides a film of grease on the cutting edge of the blade. Blade maintenance should include keeping felt pad saturated with grease. Should tape adhesive build-up occur on blade, carefully wipe clean with light solvent or grease soaked cloth.



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

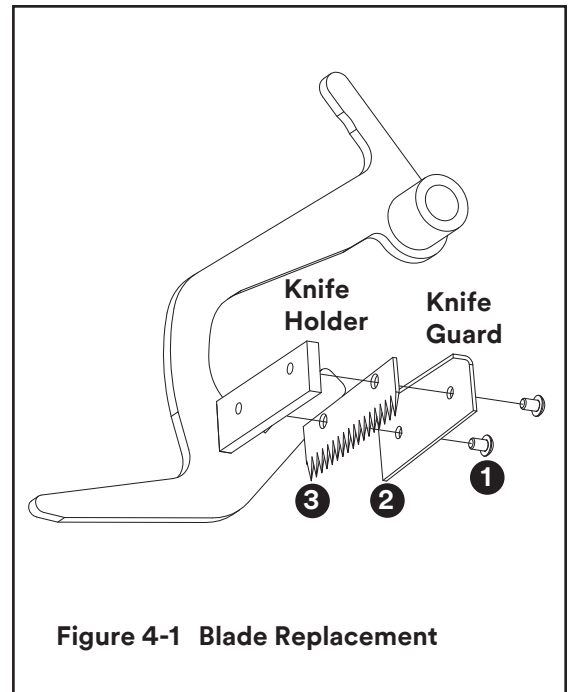


Figure 4-1 Blade Replacement



Warning

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

(maintenance *continued* on next page.)

Maintenance *(continued)*

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 components and 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 happen.

Replacing Applying/Buffering Roller

1. Remove socket head cap screw.
2. Remove roller and wave washer.
3. Mount roller replacement.
4. Replace wave washer and socket head cap screw.



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.



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.

Adjustments

Tape Alignment and Tracking – Figure 5-1

An adjustment system behind the tape roll hub is provided to center the tape as it moves along the tape applicator rollers and onto the case. Adjusting the position of the hub brake offsets the tape moving through the applicator.

To adjust tape tracking, loosen the nut behind the hub brake. Turn the screw clockwise to push out the hub brake, or counter-clockwise to move the hub brake closer to support arm. Retighten the nut to lock assembly in new position.

The tape should be applied directly over the center line of the case flaps and should not extend past the edge of the rollers (**Figure 5-2**).

Note: Only fine adjustments for tape alignment should be done on the tape applicator.



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.

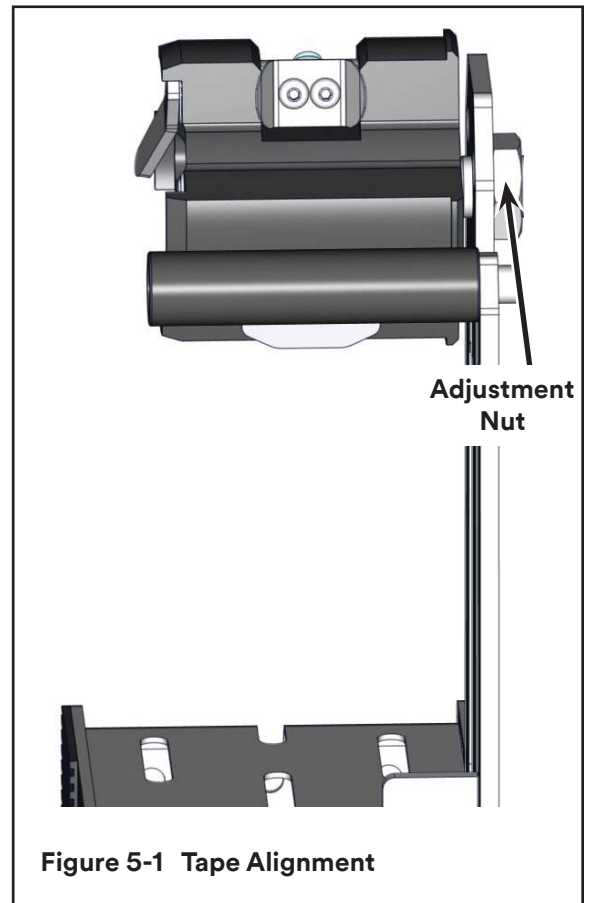


Figure 5-1 Tape Alignment

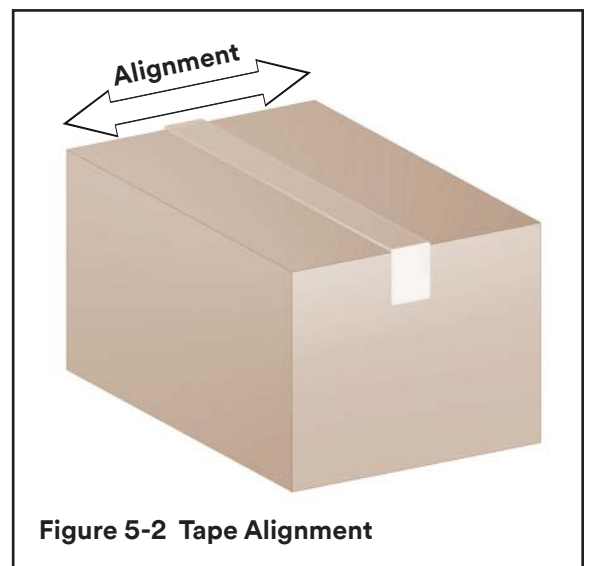


Figure 5-2 Tape Alignment

(adjustments *continued* on next page.)

Adjustments *(continued)*

Applying Mechanism Spring

The applying mechanism spring (Figure 5-3), controls applying/buffing roller pressure on box and returns the mechanism to reset position. The spring pressure is pre-set but is adjustable.

To determine Spring Tension Setting, See Figure 5-3.

One-Way Tension Roller - Figure 5-4

The main tape tension adjustment is made at the one-way tension roller. The one-way tension roller affects the amount of tension or force required to pull the tape. This adjustment will affect wipe-down and cut-off characteristics.

The trouble shooting section of this manual will help diagnose improperly adjusted tension. To increase tension, tighten the center nut clockwise and to decrease tension turn the nut counter-clockwise.

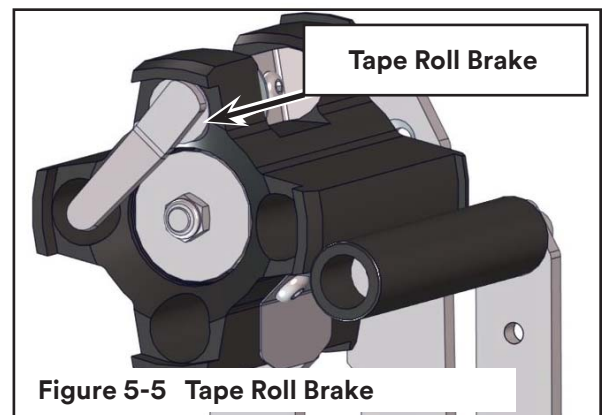
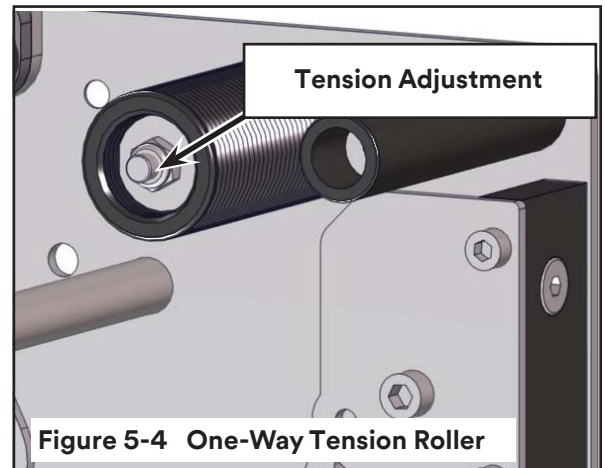
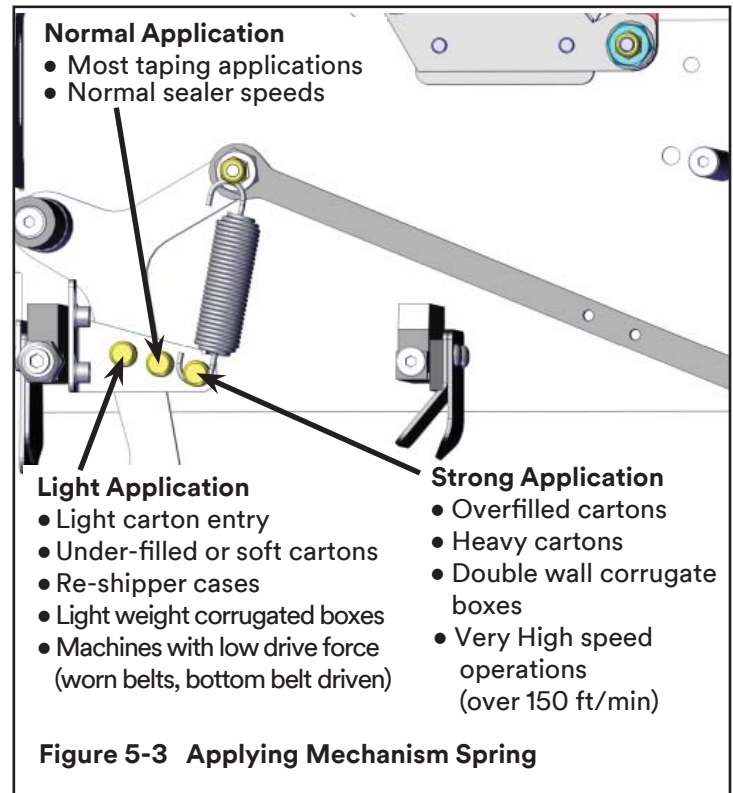
Tape Roll Brake - Figure 5-5

The nut and spring on the tape roll hub controls an adjustable friction brake that should be used to prevent over-spinning of the tape roll and adjusted to provide a minimum of resistance against tape pull. To increase tension, tighten the center nut clockwise and to decrease tension turn the nut counter-clockwise.

Figures 5-5 and 5-6 - A yellow sticker showing 3 indication levels can be used with circular plate below the center nut to determine tension levels.

0-1: Light / 1-2: Medium / 2-3: Strong

Important: Tape tension is affected by a variety of factors. Incorrectly set tension levels can result in poor tape application. The troubleshooting section of this manual describes potential tension problems and fixes.



(adjustments *continued* on next page.)

Adjustments *(continued)*

Tape Leg Length

Trailing Tape Leg Length Adjustment – Adjustment can range from 1/4" to 2 3/4" tabs.

The rear tab length can be adjusted by removing the adjustment bar and placing it along the two drill holes. The further the bar extends from the cutting arm, the longer the tab. The adjustment bar can be removed entirely for minimum tab length. Be sure the bar is firmly reattached after adjusting (Figures 5-6).

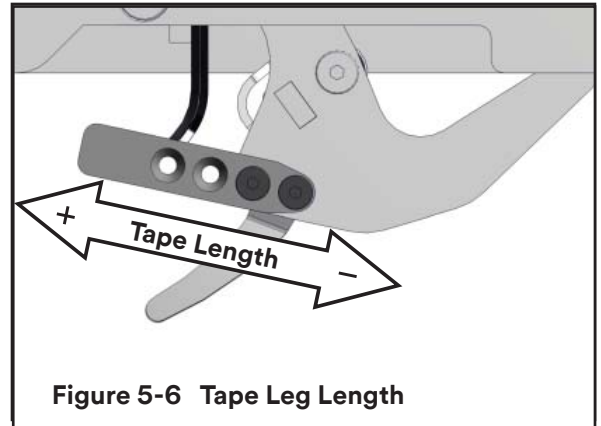


Figure 5-6 Tape Leg Length

Applying Leg Length

The front tab is adjusted by removing adjustment roller and securing it in one of five position holes.

Be sure roller is firmly reattached after adjusting (Figures 5-7).

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

Note - Tab lengths are sensitive to tension levels. Generally, lower tension settings are required to create longer tabs.

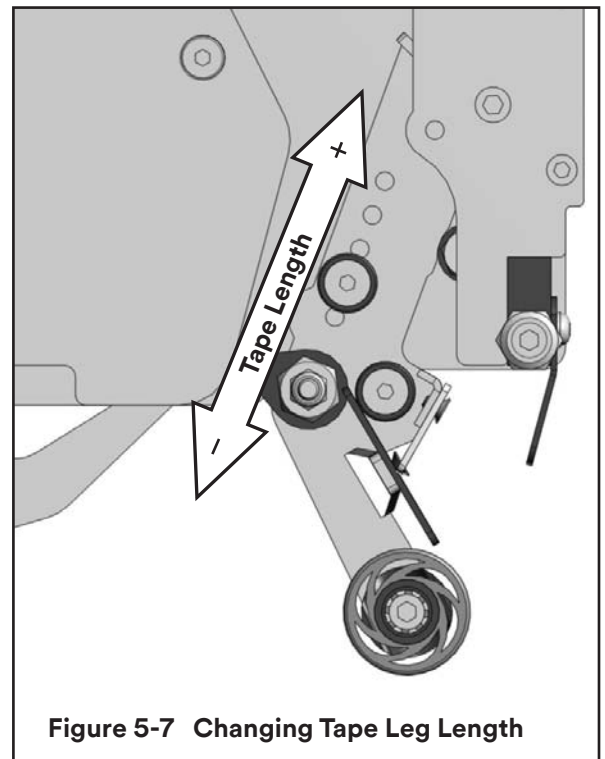


Figure 5-7 Changing Tape Leg Length



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.

Troubleshooting

Troubleshooting Guide

Problem	Cause	Correction
<p>The tape leg on the front of the case is too long</p>	<p>The tape is threaded incorrectly</p> <p>The tape tension is too low</p> <p>The knurled roller drags</p> <p>Tape tracks to one side or drags on the support tabs of applying frame</p> <p>Taping head is not set up properly</p>	<p>The tape must go around the wrap roller before going around the one-way tension roller</p> <p>Adjust the one-way tension roller</p> <p>Check for adhesive build-up between the knurled roller and its shaft. Clean and lubricate shaft. Remove all lubricant from roller surfaces.</p> <p>Adjust the tape web alignments Readjust the machine's center alignment setting</p> <p>Check the position of the tab adjustment roller and adjustment bar</p> <p>Re-adjust sealer so bottom of taping head is ¼" from top surface of carton.</p>
<p>The blade does not cut tape or tape end is jagged/shredded/stretching or wrinkling</p>	<p>The blade is dull and/or has broken teeth/adhesive build up/dry blade/blade in backwards</p> <p>Tape tension is insufficient or too high</p> <p>The blade is not positioned properly</p> <p>One or both cutter springs are missing or stretched</p> <p>Tension roller surface is not fully contacting the taping head frame</p>	<p>Clean and adjust / Grease blade grease pad /replace the blade</p> <p>Increase/decrease tape tension by adjusting the one-way tension roller</p> <p>Tighten or loosen hub adjustment nut</p> <p>Make sure the blade is correctly positioned. Mount the blade so that the beveled edge is away from the entrance of the head</p> <p>Replace the defective spring(s)</p> <p>Make sure one-way bearing is below the surface of the tension roller. If not, press bearing further into roller or replace roller</p>

(continued on next page)

Troubleshooting *(continued)*

Troubleshooting Guide

Problem	Cause	Correction
Tape is tabbing on the trailing leg on the back of the box	<p>There is excess tension on the tape drum assembly and/or the one-way tension roller assembly</p> <p>Rollers in the tape path do not rotate freely</p> <p>The blade is not cutting tape properly</p> <p>The tape is threaded incorrectly</p> <p>Applying mechanism spring has too little/much tension or damaged</p> <p>Rear tab too long</p> <p>Front and rear tab lengths shorten as tape roll diminishes</p>	<p>Adjust the one-way tension roller and/or the tape drum assembly/or tighten-loosen hub adjust nut</p> <p>Clean adhesive deposits from the surface, ends, and shafts of the rollers. Then lubricate roller shafts. Remove all lubricant from roller surfaces. See tape cutting problems.</p> <p>Re-thread the tape</p> <p>Move spring hook to next tighter or looser position or replace spring</p> <p>Reposition adjustment bar</p> <p>Tape hub or tension roller tension too high - lower tension</p>
The tape end does not stay in application position in front of the applying roller	<p>The tape is incorrectly threaded</p> <p>Applying roller overruns on return of applying mechanism to its rest position</p> <p>The one-way tension roller is defective</p> <p>The tape roll not correctly aligned</p> <p>The tape applicator off center</p>	<p>Re-thread the tape</p> <p>There should be a slight drag when rotating the applying roller. If not, check friction springs and/or friction pins - replace if necessary</p> <p>Replace the one-way tension roller</p> <p>Readjust the machine's center alignment.</p>
Tape not centered on box seam	<p>Centering guides not centered</p> <p>Box flaps not of equal length</p>	<p>Reposition tape drum</p> <p>Adjust centering guides/adjust centering alignment</p> <p>Check box specifications</p>

Spare Parts/Service Information

Replacement Parts Illustrations and Parts Lists

AccuGlide™ 4 High Performance 2 and 3 Inch Upper Taping Head, Type 11800
AccuGlide™ 4 High Performance 2 and 3 Inch Lower Taping Head, Type 11800

Recommended Spare Parts

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

AccuGlide™ 4 High Performance 2 Inch Taping Heads

Qty.	Part Number	Description
1	78-0025-0320-5	Blade
1	78-0025-0252-0	Spring Kit
1	78-0025-0250-4	Spare Parts Kit
1	78-0025-0253-8	Spare Wiper Kit
1	78-0025-0301-5	Roller Kit - Plasma Coated
1	78-0025-0305-6	Knife Retract Kit
1	78-0025-0272-8	Spring - Lower Tape Head
4	78-0025-0327-0	Stud - Mounting*

* Use of a stud is dependent on where taping head is mounted.
Contact your **3M** provider for more information.

AccuGlide™ 4 High Performance 3 Inch Taping Heads

Qty.	Part Number	Description
1	78-0025-0325-4	Blade
1	78-0025-0252-0	Spring Kit
1	78-0025-0251-2	Spare Parts Kit
1	78-0025-0254-6	Spare Wiper Kit
1	78-0025-0303-1	Roller Kit - Plasma Coated
1	78-0025-0305-6	Knife Retract Kit
1	78-0025-0272-8	Spring - Lower Tape Head
4	78-0025-0327-0	Stud - Mounting*

* Use of a stud is dependent on where taping head is mounted.
Contact your **3M** provider for more information.

AccuGlide™ 4 High Performance Options

In addition to the above set of spare parts, the following options are also available.

Qty.	Part Number	Description
1	70-0075-1012-9	Arm - Dancer (2")
1	70-0075-1013-7	Arm - Dancer (3")
1	70-0075-1014-5	Edge Folder (2")
1	70-0075-1015-2	Edge Folder (3")

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.
Contact 3M/Tape Dispenser Parts to confirm item availability.

Tape Head -
AccuGlide™ 4 - 2 and 3 inch

Figure 11808
Tape Roll Mast
Assembly

Figure 11801
Full Assembly

Figure 11809
Clutch Roller
Assembly

Figure 11802
Frame
Hardware

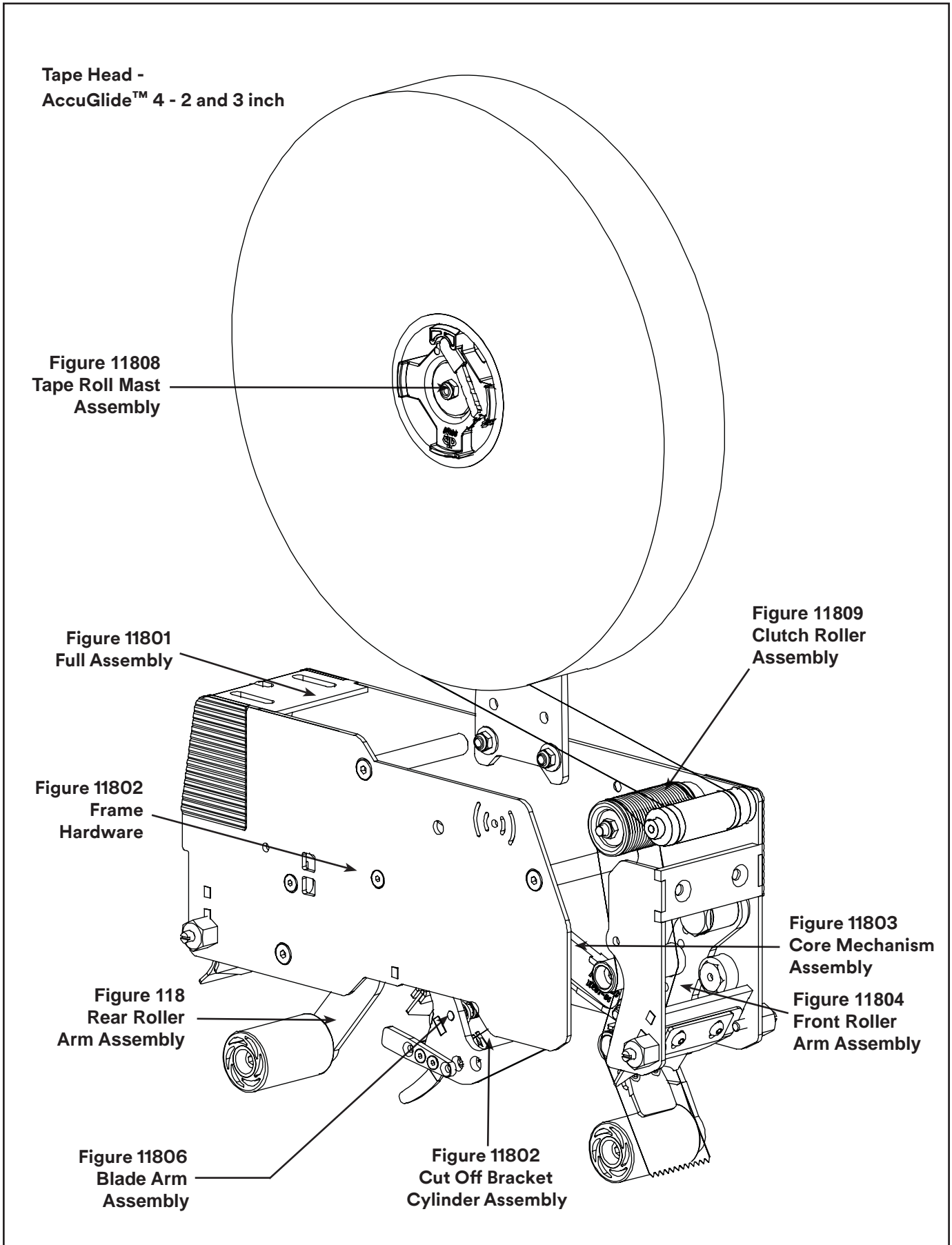
Figure 11803
Core Mechanism
Assembly

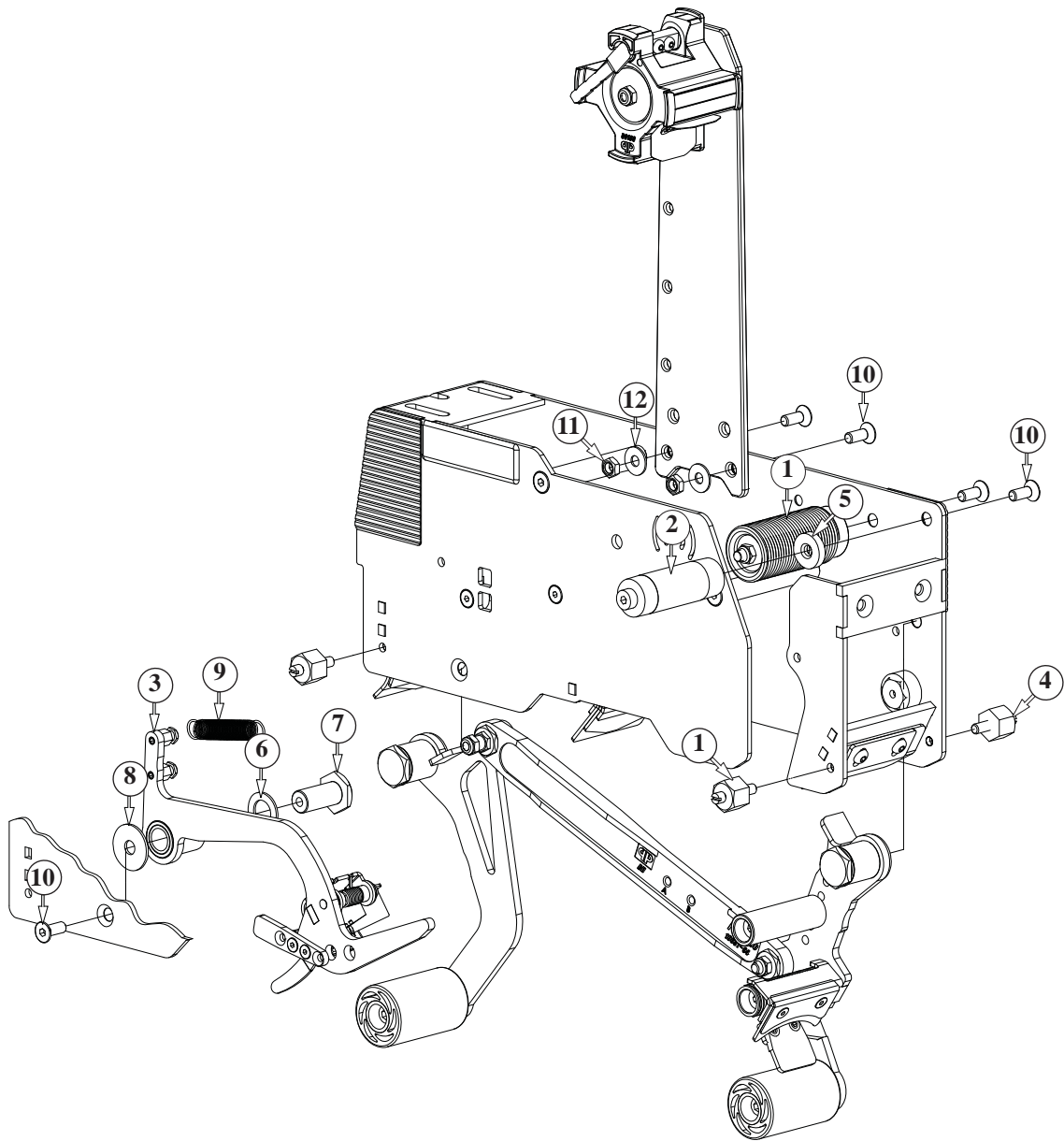
Figure 118
Rear Roller
Arm Assembly

Figure 11804
Front Roller
Arm Assembly

Figure 11806
Blade Arm
Assembly

Figure 11802
Cut Off Bracket
Cylinder Assembly



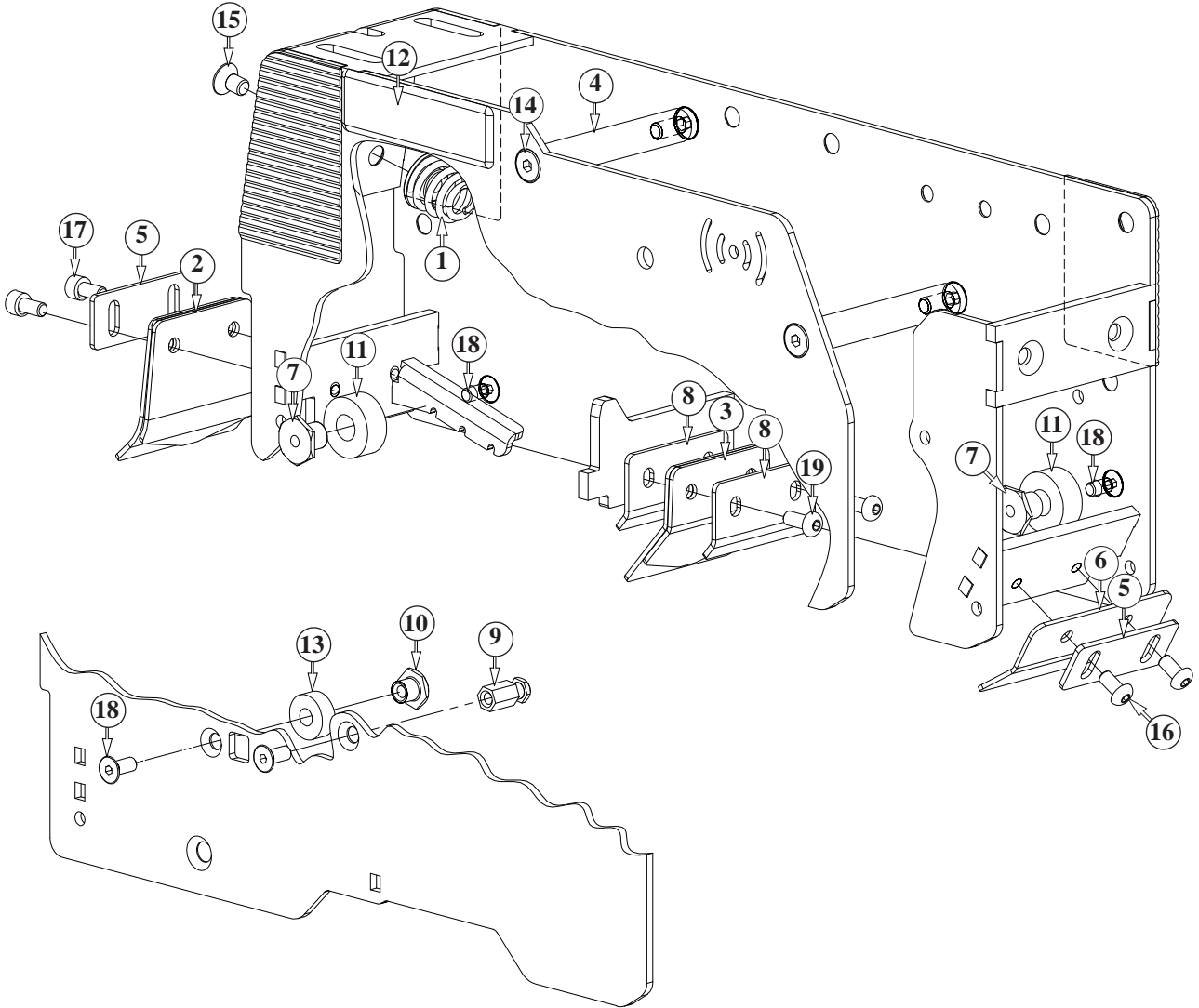


Note:
View Shown is for Right Hand Taping Head -
Left Hand View is Mirrored/Opposite View
Also see Parts List for all Right and
Left Hand View Information and for both
2" and 3" and Little David Taping Head Parts

Figure 11801- Full Assembly

Figure 11801– Full Assembly

Ref. No.	3M Part No.	Description
11801-1	78-0025-0282-7	Clutch Roller Assembly 2” RH
	78-0025-0473-2	Clutch Roller Assembly 2” LH
	78-0025-0292-6	Clutch Roller Assembly 3” RH
11801-2	78-0025-0286-8	Roller Assembly 2”
	78-0025-0298-3	Roller Assembly 3”
11801-3	78-0025-0310-6	Cutting Assembly 2” Full Blade RH
	78-0025-0311-4	Cutting Assembly 2” Full Blade LH
	78-0025-0312-2	Cutting Assembly 3” Full Blade RH
11801-4	78-0025-0326-2	Stud - 14.5mm Mounting
	78-0025-0327-0	Stud - 25mm Mounting
11801-5	78-0025-0422-9	Spacer - 4.7mm
11801-6	78-0025-0425-2	Washer
11801-7	78-0025-0424-5	Shaft – 12.70 x 31.0
11801-8	78-0025-0423-7	Washer - Stainless Steel
11801-9	78-0025-0273-6	Spring - Tension 11mm x 40.8
11801-10	26-1003-7957-2	Screw - Socket M6 x 16
11801-11	78-0025-0480-7	Nut - Jam M6 x 1.0
11801-12	78-0025-0479-9	Washer - M6 x 16mm



Note:
View Shown is for Right Hand Taping Head -
Left Hand View is Mirrored/Opposite View
Also see Parts List for all Right and
Left Hand View Information and for both
2” and 3” and Little David Taping Head Parts

Figure 11802 – Frame Hardware Assembly

Figure 11802 – Frame Hardware Assembly

Ref. No.	3M Part No.	Description
11802-1	78-0025-0270-2	Spring - Booster
11802-2	78-0025-0253-8	Wiper Set - Rear 2”
	78-0025-0254-6	Wiper Set - Rear 3”
11802-3	78-0025-0253-8	Wiper Set - Middle 2”
	78-0025-0254-6	Wiper Set - Middle 3”
11802-4	78-0025-0474-0	Spacer - Body 2”
	78-0025-0466-6	Spacer - Body 3”
11802-5	78-0025-0427-8	Plate - Clamp
	78-0025-0463-3	Plate - Clamp LD 2”
	78-0025-0455-9	Plate - Clamp LD 3”
11802-6	78-0025-0428-6	Plate - Skip
11802-7	78-0025-0431-0	Nut - Stop
	78-0025-0484-9	Nut - Stop LD
11802-8	78-0025-0426-0	Wiper - Clamping Plate
11802-9	78-0025-0430-2	Pin - Anchor
11802-10	78-0025-0429-4	Pin - Stop
11802-11	78-0025-0315-5	PU - Stop
	78-0025-0315-5	PU - Stop LD
11802-12	34-8720-2917-7	Label
11802-13	78-0025-0432-8	Stop
11802-14	26-1003-7957-2	Screw - CSK M6 x 16
11802-15	78-0025-0482-3	Screw - CSK M6 x 12
11802-16	78-0025-0511-9	Screw - HSBHCS M5 x 10 RH
	78-0025-0481-5	Screw - HSBHCS M5 x 8 LH
11802-17	26-1003-7948-1	Screw - Cap, Socket M5 x 10
11802-18	78-8137-7044-9	Screw – Socket M5 x 12
11802-19	78-0025-0483-1	Screw - HSBHCS M5 x 12

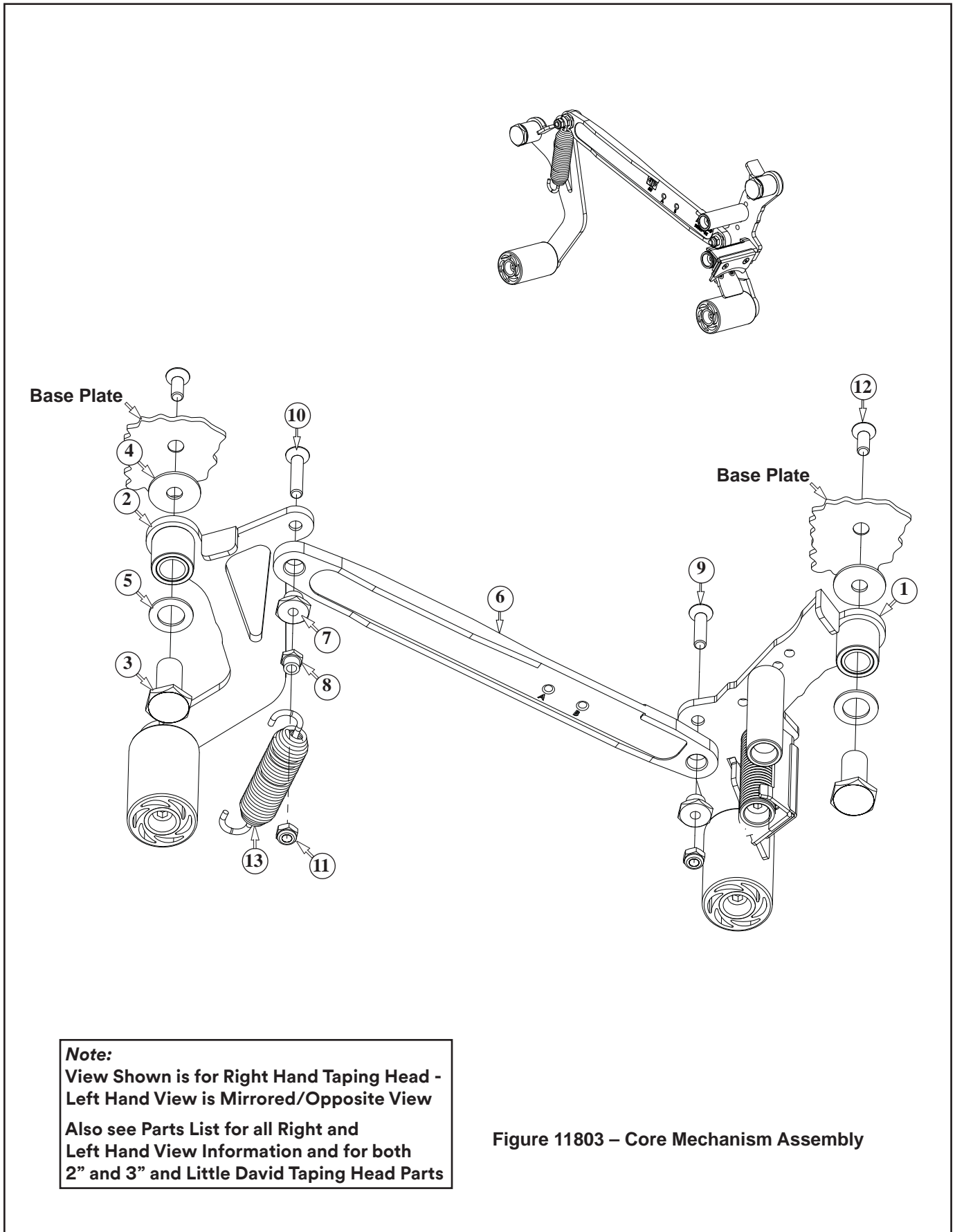
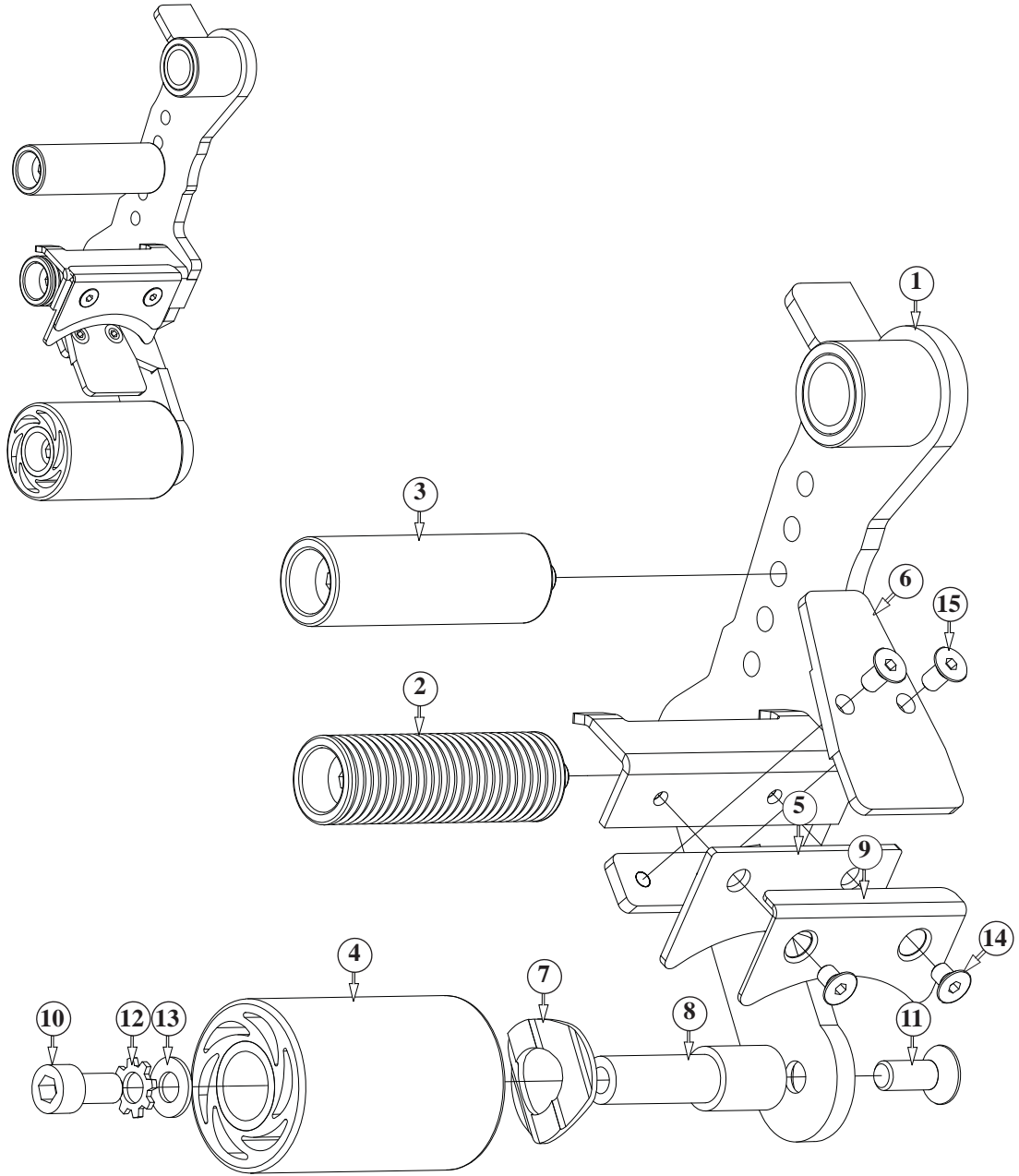


Figure 11803 – Core Mechanism Assembly

Ref. No.	3M Part No.	Description
11803-1	78-0025-0283-5	Roller Arm Assembly - Front 2” RH
	78-0025-0515-8	Roller Arm Assembly - Front 2” LH STD
	78-0025-0289-2	Roller Arm Assembly - Front 2” RH LD
	78-0025-0293-4	Roller Arm Assembly - Front 3” RH
	78-0025-0299-1	Roller Arm Assembly - Front 3” RH LD
11803-2	78-0025-0284-3	Roller Arm Assembly - Rear 2” RH
	78-0025-0516-8	Roller Arm Assembly - Rear 2” LH STD
	78-0025-0290-0	Roller Arm Assembly - Rear 2” RH LD
	78-0025-0294-2	Roller Arm Assembly - Rear 3” RH
	78-0025-0300-7	Roller Arm Assembly - Rear 3” RH LD
11803-3	78-0025-0424-5	Shaft – 12.70 x 31.0
11803-4	78-0025-0423-7	Washer - Stainless Steel
11803-5	78-0025-0425-2	Washer
11803-6	78-0025-0277-7	Push Bar (molded)
11803-7	78-0025-0433-6	Shaft - Hex
11803-8	78-0025-0434-4	Spring – Anchor
11803-9	78-8060-7918-8	Screw - Socket M6 x 25
11803-10	78-0025-0507-7	Screw - Socket M6 x 30
11803-11	78-0025-0504-4	Nut - Nylock M6 x 1.0
11803-12	26-1003-7957-2	Screw - Socket M6 x 16
11803-13	78-0025-0271-0	Spring - Tension Roller

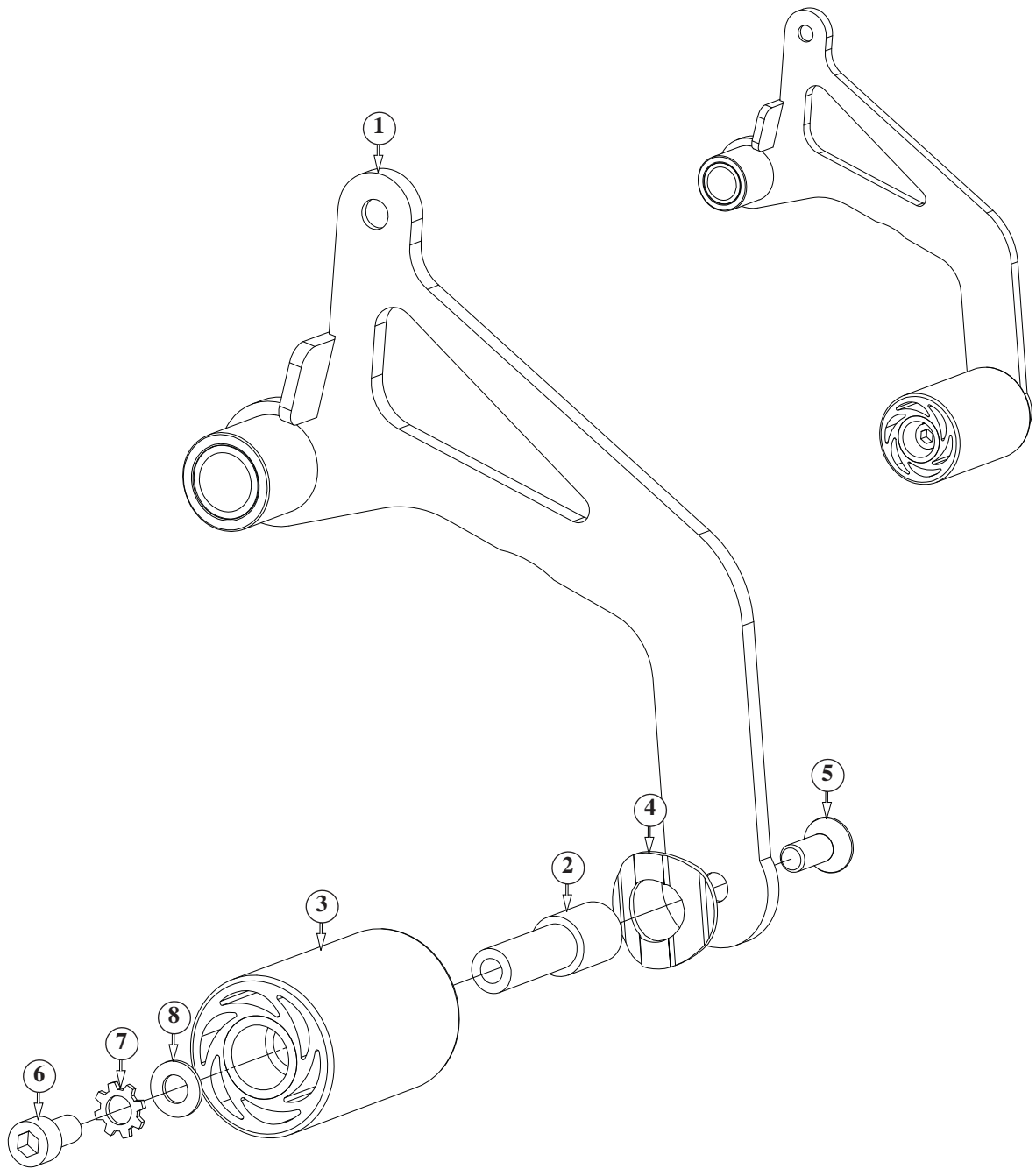


Note:
 View Shown is for Right Hand Taping Head -
 Left Hand View is Mirrored/Opposite View
 Also see Parts List for all Right and
 Left Hand View Information and for both
 2” and 3” and Little David Taping Head Parts

Figure 11804 – Front Roller Arm Assembly

Figure 11804 – Front Roller Arm Assembly

Ref. No.	3M Part No.	Description
11804-1	78-0025-0458-3	Roller Arm - 2” RH
	78-0025-0475-7	Roller Arm - 2” LH
	78-0025-0464-1	Roller Arm - 2” RH LD
	78-0025-0435-1	Roller Arm - Front 3” RH
	78-0025-0456-7	Roller Arm - 3” RH LD
11804-2	78-0025-0288-4	Roller Arm -- Knurled 2”
	78-0025-0297-5	Roller Arm -- Knurled 3”
11804-3	78-0025-0287-6	Roller - Assembly 57mm
	78-0025-0296-7	Roller - Assembly 77mm
11804-4	78-0025-0278-5	Roller - Spiral 2”
	78-0025-0279-3	Roller - Spiral 3”
11804-5	78-0025-0253-8	Guide - Tape Pre-Form 2”
	78-0025-0254-6	Guide - Tape Pre-Form 3”
11804-6	78-0025-0254-6	Support - Tape
11804-7	78-0025-0280-1	Washer - Drag
11804-8	78-0025-0459-1	Shaft – 2”
	78-0025-0436-9	Shaft – 3”
11804-9	78-0025-0460-9	Clamp - 2”
	78-0025-0437-7	Clamp - 3”
11804-10	78-8010-7209-7	Screw – Socket M6 x 12
11804-11	26-1003-7957-2	Screw – Socket M6 x 16
11804-12	78-0025-0508-5	Washer - Lock M6
11804-13	78-0025-0479-9	Washer - M6
11804-14	78-0025-0509-3	Screw - Socket M4 x 6
11804-15	78-0025-0396-5	Screw - Socket M4 x 8

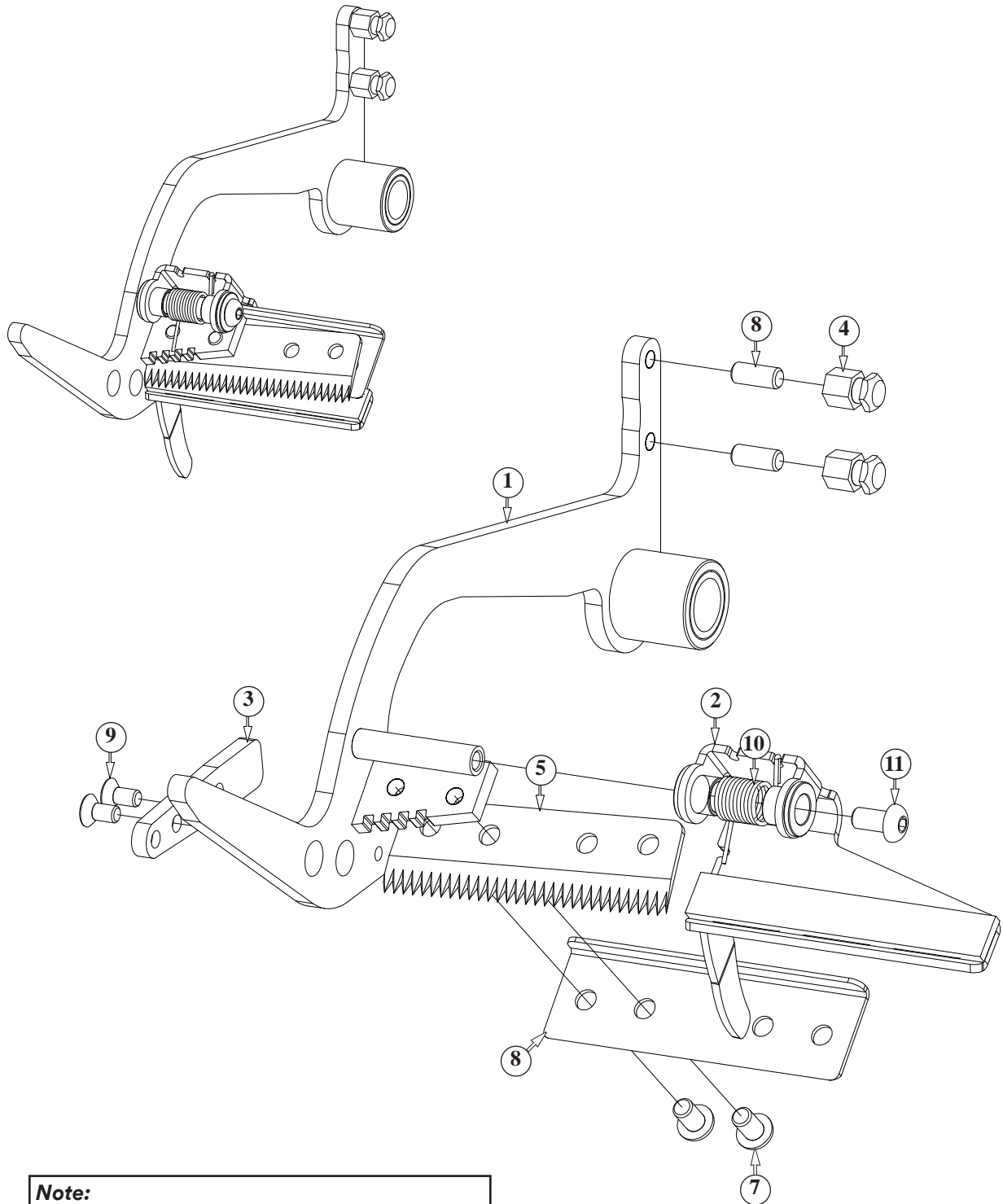


Note:
View Shown is for Right Hand Taping Head -
Left Hand View is Mirrored/Opposite View
Also see Parts List for all Right and
Left Hand View Information and for both
2” and 3” and Little David Taping Head Parts

Figure 11805 – Rear Roller Arm Assembly

Figure 11805 – Rear Roller Arm Assembly

Ref. No.	3M Part No.	Description
11805-1	78-0025-0438-5	Roller Arm - Rear RH
	78-0025-0468-2	Roller Arm - Rear LH
	78-0025-0457-5	Roller Arm - Rear RH LD
11805-2	78-0025-0459-1	Shaft - 2”
	78-0025-0436-9	Shaft - 3”
11805-3	78-0025-0278-5	Roller - Spiral 2”
	78-0025-0279-3	Roller - Spiral 3”
11805-4	78-0025-0280-1	Washer - Drag
11805-5	26-1001-9843-7	Screw - M6 x 16 Flat Socket Head
11805-6	78-8010-7209-7	Screw - M6 x 12 Socket Cap
11805-7	78-0025-0508-5	Washer - M6 Lock
11805-8	78-0025-0479-9	Washer - M6



Note:
View Shown is for Right Hand Taping Head -
Left Hand View is Mirrored/Opposite View
Also see Parts List for all Right and
Left Hand View Information and for both
2" and 3" and Little David Taping Head Parts

Figure 11806 – Blade Arm Assembly

Figure 11806 – Blade Arm Assembly

Ref. No.	3M Part No.	Description
11806-1	78-0025-0439-3	Cam - Cutting Assembly RH
11806-2	78-0025-0314-8	Guard Assembly - Blade 2” RH
	78-0025-0410-4	Guard Assembly - Blade 3” RH
11806-3	78-0025-0440-1	Bar - Adjusting
11806-4	78-0025-0441-9	Pin - Anchor
11806-5	78-0025-0320-5	Blade - 2”
	78-0025-0325-4	Blade - 3”
11806-6	78-0025-0319-7	Plate - Cutting Guide 3”
	78-0025-0476-5	Plate - Cutting Guide 3
11806-7	78-0025-0481-5	Screw - M5 X 8 HSBHCS
11806-8	78-0025-0510-1	Screw - M5x12 Set
11806-9	78-0025-0396-5	Screw - M4 X 8 Socket CSK
11806-10	78-0025-0274-4	Spring - Torsioin
11806-11	78-0025-0511-9	Screw - M5 X 10 HSBHCS

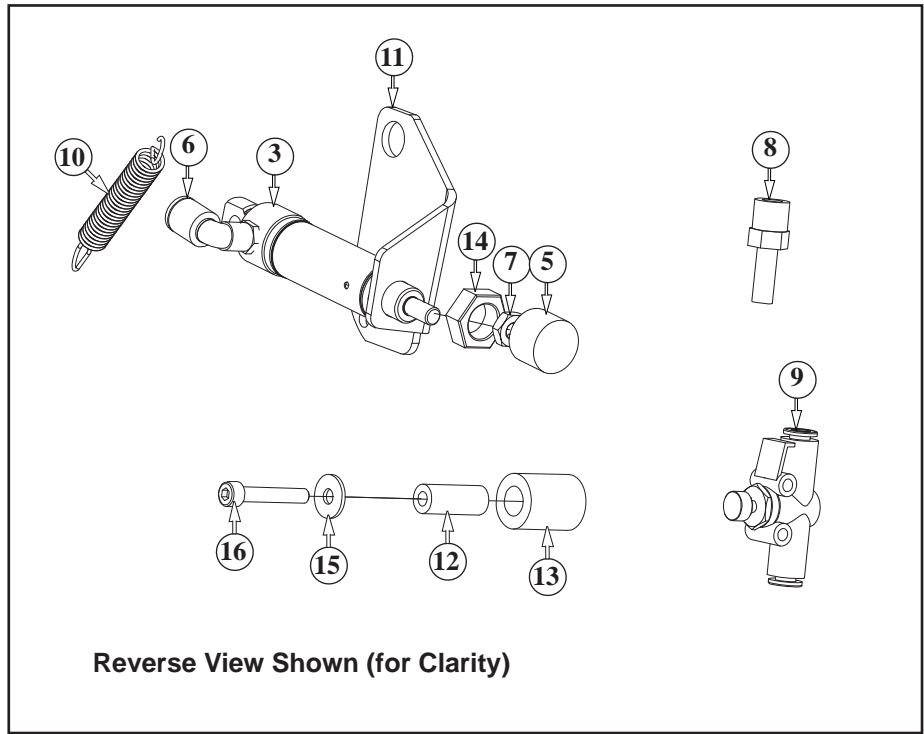
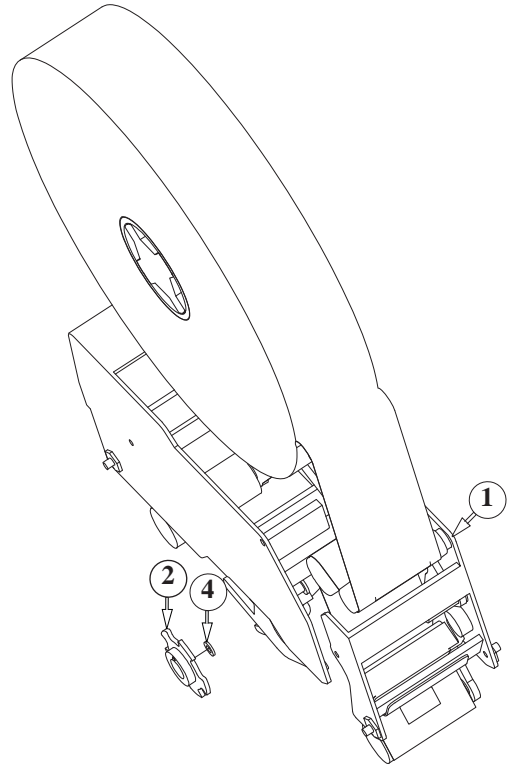
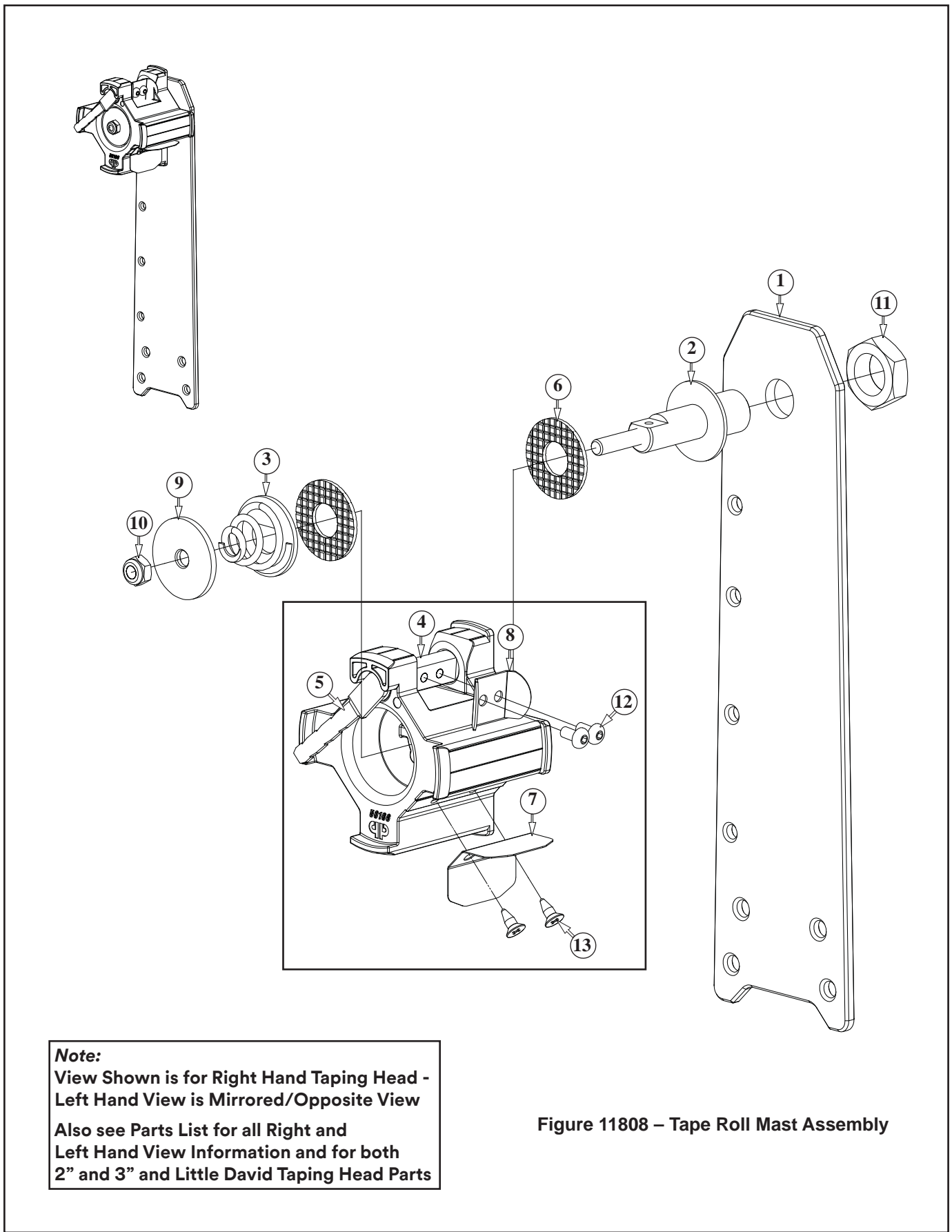


Figure 11807 – Cut Off Bracket / Cylinder Assembly

Figure 11807 – Cut Off Bracket / Cylinder Assembly

Ref. No.	3M Part No.	Description
11807-1	70-0075-0925-3	Tape Head - AccuGlide 4 - 2" RH
	70-0075-1169-7	Tape Head - AccuGlide 4 - 2" LH
	70-0075-0927-9	Tape Head - AccuGlide 4 - 3" RH
	70-0075-0928-7	Tape Head - AccuGlide 4 - 2" RH LD
	70-0075-0929-5	Tape Head - AccuGlide 4 - 3" RH LD
11807-2	78-0025-0413-8	Disk Assembly - TAM (5 Slot)
11807-3	78-0025-0496-3	Cylinder - 3/4"B x 0.75" Spring Return
11807-4	78-0025-0479-9	Washer - M7 Flat
11807-5	78-0025-0497-1	Bumper - 1/4-28 Female Round
11807-6	78-0025-0499-7	Fitting - 6mm x 1/8" 90 Elbow Male NPT
11807-7	78-0025-0498-9	Nut - 1/4-28 Hex Jam PLT
11807-8	78-8137-8500-9	Quick Disconnect - 6mm - Air Male Tube
11807-9	78-0025-0500-2	Control - 6mm Flow Union
11807-10	78-8052-6602-6	Spring - Cutter
11807-11	78-0025-0518-4	Bracket - Retract Cylinder
11807-12	78-0025-0519-2	Sleeve - Retract
11807-13	78-0025-0520-0	Roller - Retract
11807-14	70-8000-5374-9	Nut - 1/2-13 Hex Jam
11807-15	78-8028-8214-8	Washer - M5 Triple
11807-16	26-1003-7953-1	Screw - M5 x 30 Soc. Hd.

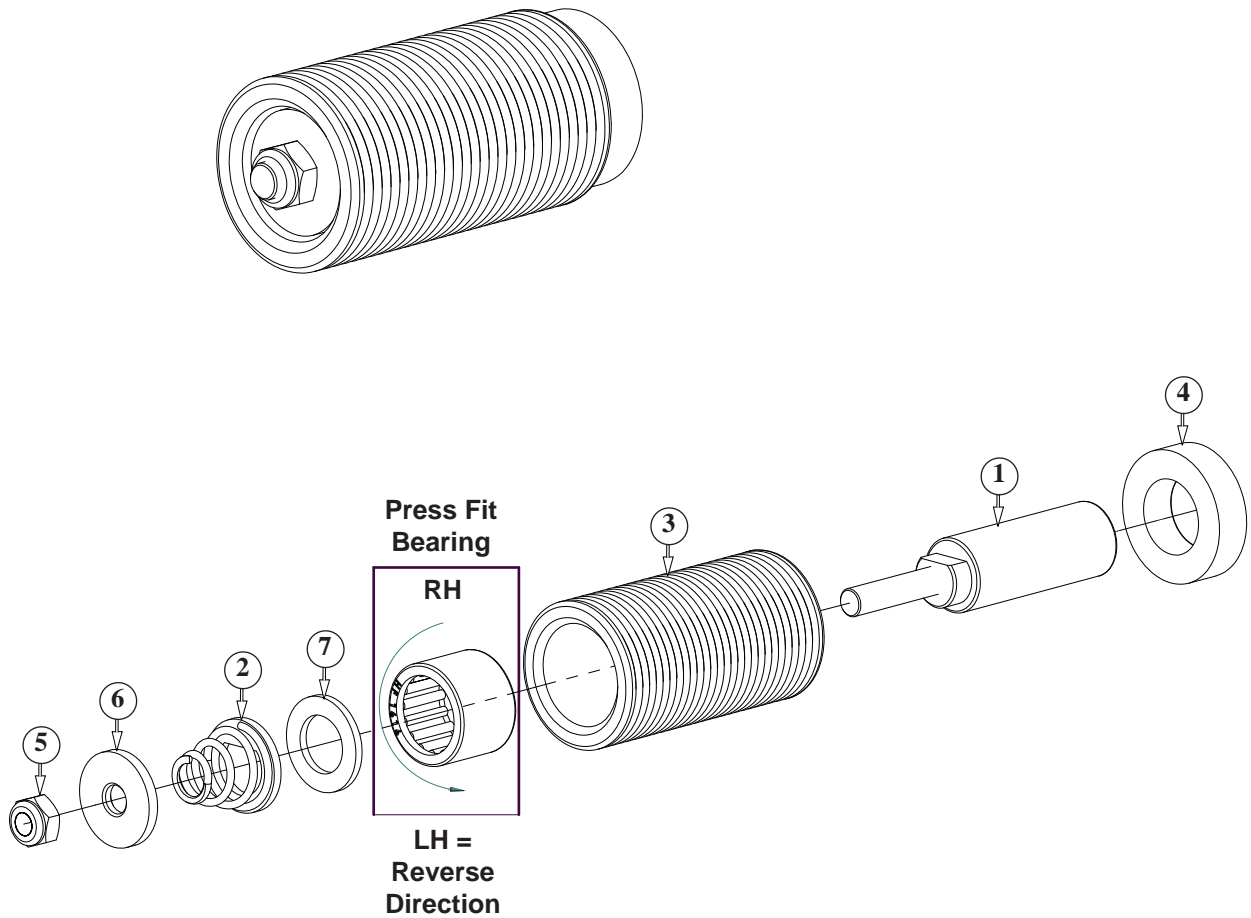


Note:
 View Shown is for Right Hand Taping Head -
 Left Hand View is Mirrored/Opposite View
 Also see Parts List for all Right and
 Left Hand View Information and for both
 2" and 3" and Little David Taping Head Parts

Figure 11808 – Tape Roll Mast Assembly

Figure 11808 – Tape Roll Mast Assembly

Ref. No.	3M Part No.	Description
11808-1	78-0025-0450-0	Mast - Support
11808-2	78-0025-0462-5	Screw - Adjustment
11808-3	78-0025-0275-1	Spring - Conical Hub
11808-4	78-0025-0285-0	Hub - Tape Roller 2”
	78-0025-0295-9	Hub - Tape Roller 3”
11808-5	78-0025-0448-4	Lever - Lock RH
	78-0025-0470-8	Lever - Lock RH
11808-6	78-0025-0449-2	Washer - Friction
11808-7	78-0025-0451-8	Plate (Fixed) - Spring
11808-8	78-0025-0452-6	Spring - Lock
11808-9	78-0025-0453-4	Plate - Tension Gauge
11808-10	78-0025-0504-4	Nut - Nylock M6 x 1.0
11808-11	78-0025-0454-2	Nut - Jam 5/8 - 15
11808-12	78-0025-0512-7	Screw - Adjustment 2”
	78-0025-0447-6	Screw - Adjustment 3”
11808-13	26-1002-5753-9	Screw – Plastic M4 x 8



Note:
View Shown is for Right Hand Taping Head -
Left Hand View is Mirrored/Opposite View
Also see Parts List for all Right and
Left Hand View Information and for both
2” and 3” and Little David Taping Head Parts

Figure 11809 – Clutch Roller Head

Figure 11809 – Clutch Roller Head

Ref. No.	3M Part No.	Description
11809-1	78-0025-0461-7	Shaft - One Way Clutch Roller 2”
	78-0025-0443-5	Shaft - One Way Clutch Roller 3”
11809-2	78-0025-0276-9	Spring - Conical Clutch
11809-3	78-0025-0306-4	Roller - Clutch 2” RH
	78-0025-0316-3	Roller - Clutch 2” LH
	78-0025-0307-2	Roller - Clutch 3” RH
11809-4	78-0025-0444-3	Spacer - Clutch Roller
11809-5	78-0025-0504-4	Nut - Nylock M6 x 1.0
11809-6	78-0025-0445-0	Plate - Tension Gauge
11809-7	78-0025-0446-8	Washer - Friction

