

INSTRUCTIONS AND PARTS LIST

**Scotch**<sup>®</sup> CAT. NO. 5A  
BRAND

BOX SEALER      MODEL 276

**Packaging Systems Division** **3m**  
COMPANY  
3M CENTER • ST. PAUL, MINNESOTA 55101

34-7004-7136-9E



# SUPPLEMENTAL INSTRUCTIONS AND PARTS LIST FOR "SCOTCH" BRAND CAT. NO. 5A, MODEL 276 BOX SEALER

This 5A Box Sealer is equipped with a new ON/OFF – EMERGENCY STOP SWITCH and related components.

The replacement parts listed below replace the standard ON/OFF SWITCH, EMERGENCY STOP SWITCH and related components shown and listed (pages 45 and 46) at the back of the instruction manual.

The following parts shown on these pages are not affected by the change. Reference numbers 38 - 52 - 53 - 57 - 60 - 96 - 100 - 293 - 312.

Refer to the "Parts Order and Service Information" section of the manual for order information.

The electrical schematic (figure 2) of this supplement replaces the standard schematics (figures 14 and 14A) shown on pages 20 and 21 of the manual.

## REPLACEMENT PARTS LIST

REF. NO.	PART NUMBER	PART NAME
* 14	26-1000-0663-9	Nut, Lt Hex, Full Ht 6-32
* 55	70-8000-4787-3	Screw, Machine Hex Hd, Trimmed 10-32 x 1/2 L
* 79	77-8001-0349-9	Connector, T & B #3302
* 88	78-8003-7829-7	Washer, Plain Type A, #10 Narrow
*309	78-8015-7241-9	Box, Switch
313	78-8015-7243-5	Cable Assy Motor to Switch Box
314	78-8015-7242-7	Cord, Electrical Power
*368	26-1000-3990-3	Spacer, H. H. Smith # 9214
369	78-8033-1633-6	Switch, Bulletin 800T, Oil Tight, Push-Pull Unit, 3 Pos.
		Allen-Bradley No. FXN6A7
*370	78-8003-8647-2	Screw, Machine, Hex Hd, Trimmed 6-32 x 1/2 L.
*371	18-3152-8203-0	Screw, Machine Hex Hd, Trimmed 8-32 x 1/2 L.
*372	18-9832-0803-6	Washer, Lock Hel Spg No. 8
*373	18-9851-0603-0	Washer, Lock Ext Tooth, Flat No. 6
*374	78-8015-7240-1	Bracket, Relay
375	78-8003-7832-1	Connector, Midtex No. 670-0009
		Relay Socket
376	78-8033-1634-4	Relay, Elec Industrial Control, General Purpose AC Enclosed Unit, 3 PDT, 120-VAC, 10 AMP, Midtex No. 157 23T200

**NOTE** — Parts identified by (\*) are available, but not a normal replacement stock item.

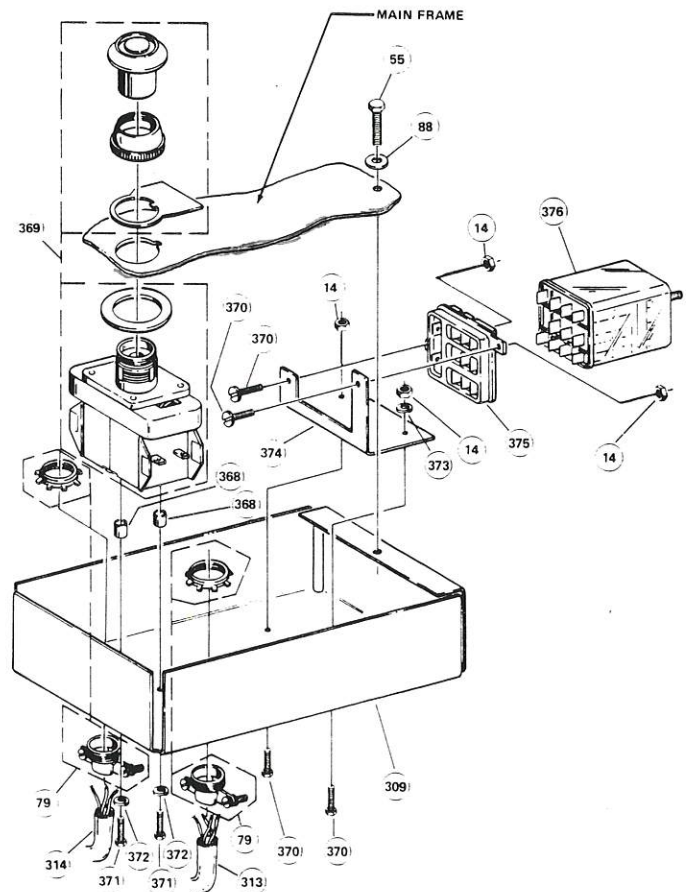


FIGURE 1 REPLACEMENT PARTS ILLUSTRATION

(Instructions Continued on Back)

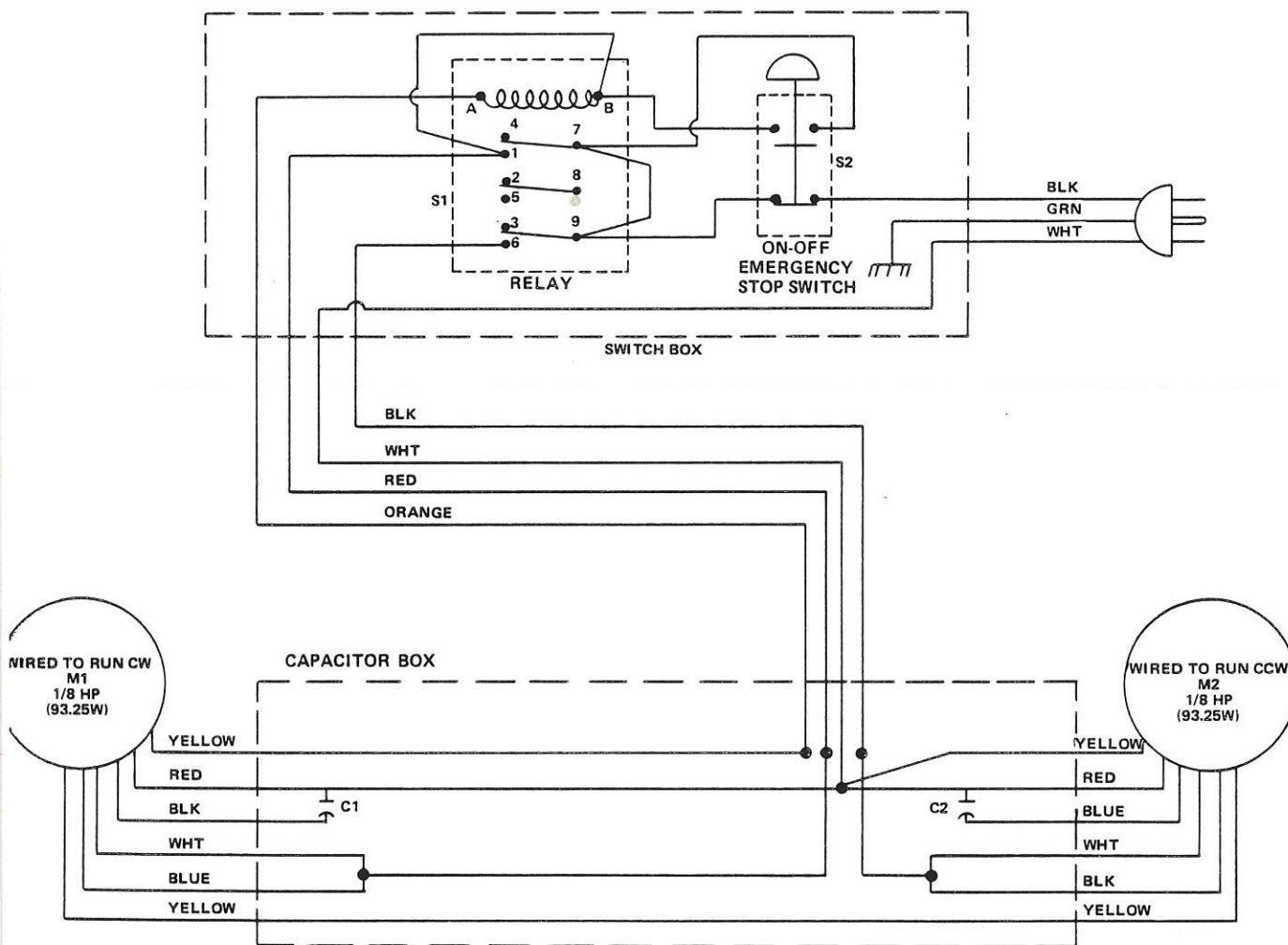


FIGURE 2 ELECTRICAL SCHEMATIC 5A, MODEL 276

**IMPORTANT NOTICE TO PURCHASER:** The following is made in lieu of all warranties, expressed or implied: The only obligation of the manufacturer and seller of "SCOTCH" Brand equipment shall be to repair or replace any mechanical part proved to be defective, provided the defect occurs within 90 days after date of purchase, and the so-purchased item is returned immediately to the 3M factory or to an authorized service station designated by the manufacturer. Neither manufacturer nor seller shall be liable for any loss or damage, direct or consequential, arising out of the use of or inability to use the "SCOTCH" Brand equipment. No statement or recommendation not contained herein shall have any force or effect unless in an agreement signed by officers of seller and manufacturer.

"SCOTCH" is a reg. T.M. of 3M Co., St. Paul, Minnesota 55101

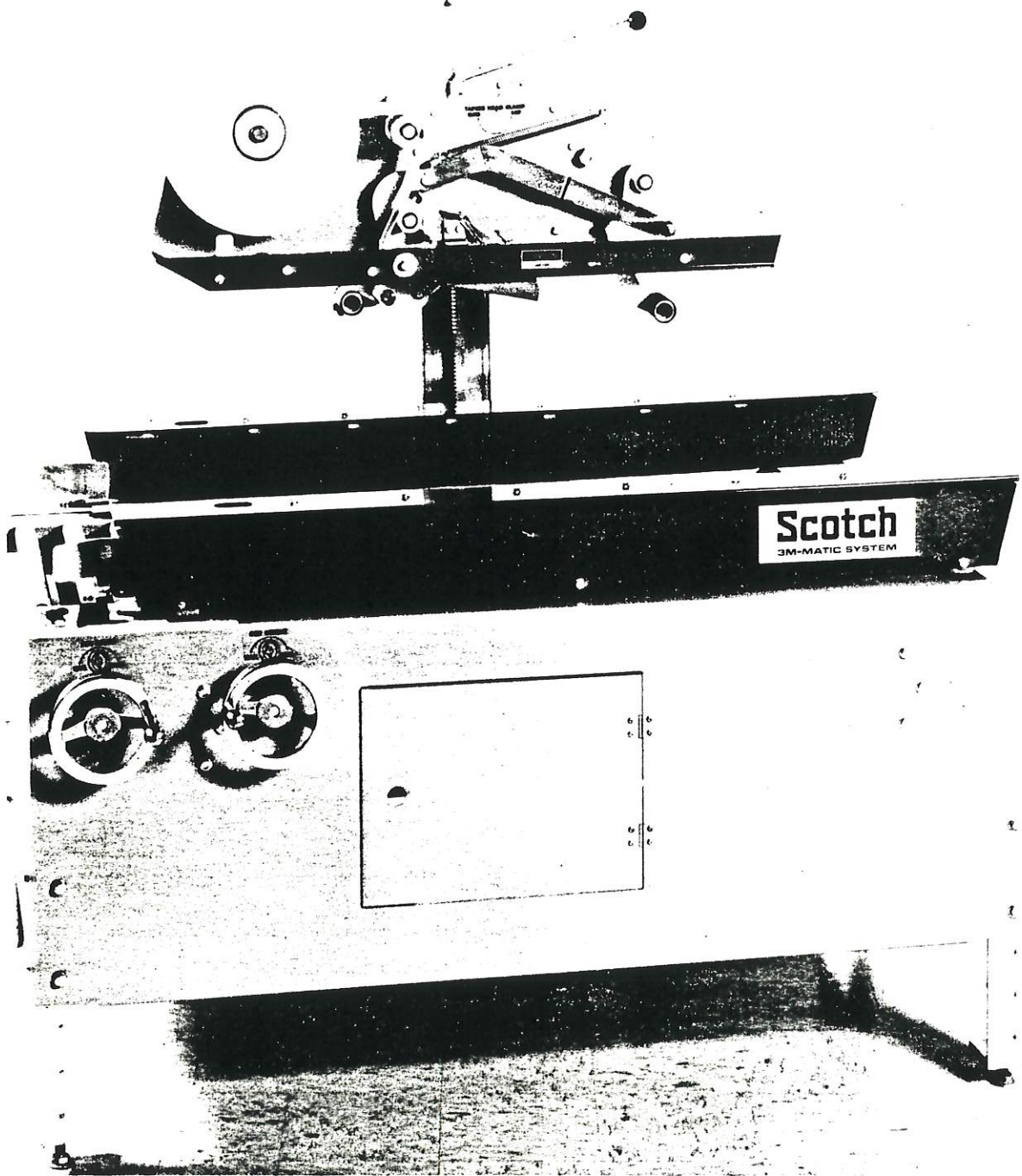
**Packaging Systems Division** **3M**  
COMPANY

# INSTRUCTION MANUAL

5A MODEL 276

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CAT. NO. 5A SEALER - MODEL 276

The 5A Box Sealer is designed to apply a "C" clip of pressure-sensitive tape to the top and bottom center seam of regular slotted containers.

The machine is manually adjustable to a wide range of box sizes (see box size specifications).

## RECEIVING AND HANDLING

After the machine has been uncrated, examine the 5A Box 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 Company representative.

IMPORTANT - Refer to installation section of this manual for instructions for transporting an uncrated machine.

## WARRANTY

IMPORTANT NOTICE TO PURCHASER - The following is made in lieu of all warranties, expressed or implied: The only obligation of the manufacturer and seller of "SCOTCH" Brand equipment shall be to repair or replace any mechanical part proved to be defective, provided the defect occurs within 90 days after date of purchase, and the so-purchased item is returned immediately to the 3M factory or to an authorized service station designated by the manufacturer. Neither manufacturer nor seller shall be liable for any loss or damage, direct or consequential, arising out of the use of or inability to use the "SCOTCH" Brand equipment. No statement or recommendation not contained herein shall have any force or effect unless in an agreement signed by officers of seller and manufacturer.

"SCOTCH" is a registered trademark for the pressure-sensitive tapes and dispensers of 3M Company, St. Paul, Minnesota 55101.

## SPECIFICATIONS

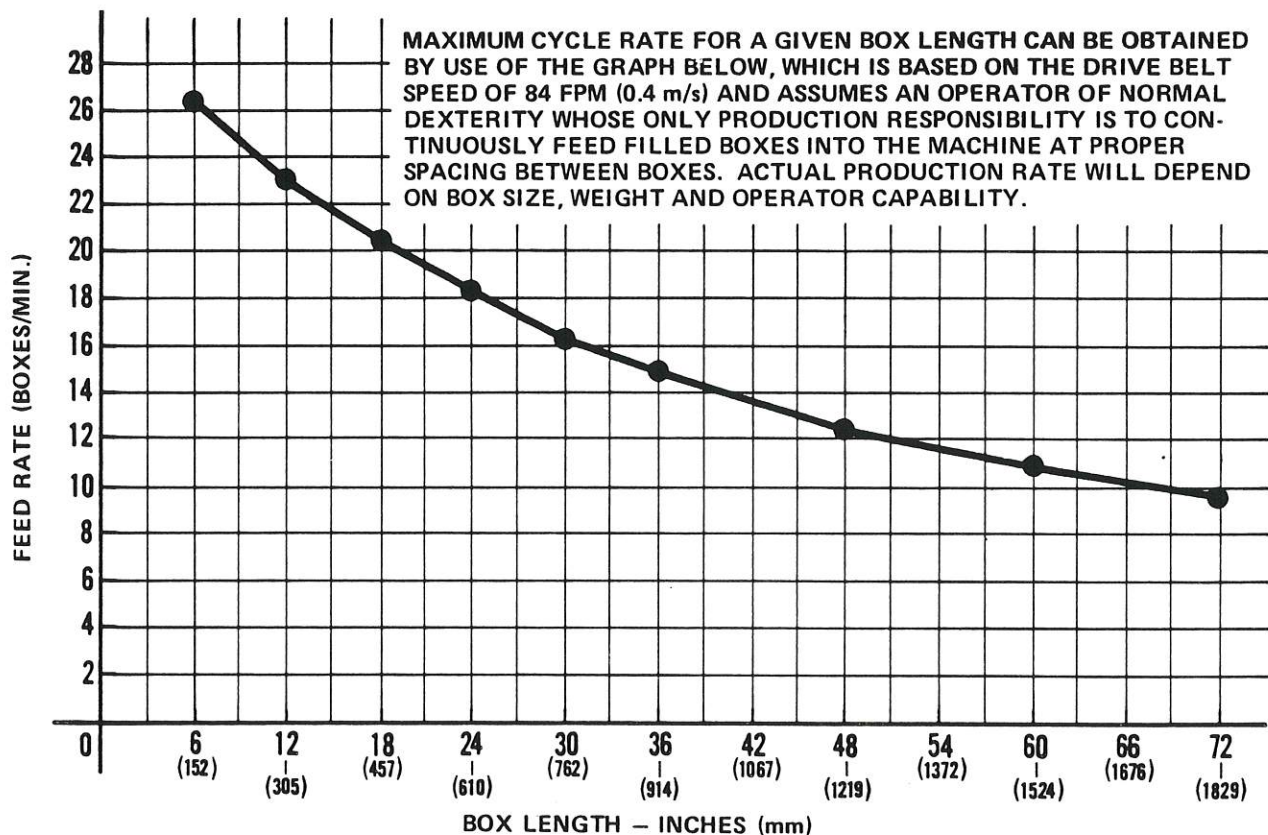
### 1) Power Requirements:

115 VAC, 60 Hz, 10 A electrical power. The machine is equipped with a standard neoprene covered power cord and a grounded plug.

### 2) Machine Dimensions:

	<u>Minimum</u>	<u>Maximum</u>
A. Length	- 60.5 inches (1.536 m)	60.5 inches (1.536 m)
B. Width	- 42 inches (1.066 m)	42 inches (1.066 m)
C. Overall Height	- 52.5 inches (1.334 m)	63.5 inches (1.612 m)
D. Bed Height	- Adjustable from 24 inches (610 mm) to 34 inches (863 mm) in 2.5 inch (63.5 mm) increments	
E. Shipping Weight	- 650 pounds (295 kg) uncrated, 800 pounds (363 kg) crated	

### 3) Operating Rate:



### 4) Operating Conditions:

Use in dry, relatively clean environments at 35° to 120° F (1.7° to 48.9° C) with clean, dry boxes.

Machine should not be washed down or subjected 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:

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

7) Tape Roll Diameter:

Up to 14 inches (355.6 mm) maximum on a 3 inch (76.2 mm) diameter core.  
(Accommodates "SCOTCH" Brand Film tapes - 1,000 yard rolls.)

8) Box Board:

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

9) Box Weight and Size Capacities:

A. Box weight, filled - up to 100 pounds (45 kg)

B. Box size:	<u>Minimum</u>	<u>Maximum</u>
1. Width -	6 inches (152 mm)	21 inches (533 mm)
2. Height -	5.5 inches (140 mm)	21 inches (533 mm)
3. Length -	6 inches (152 mm)	unlimited

NOTE: The 5A Box 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 less than .6, several boxes should be test run to assure proper machine performance.

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

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

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

## INSTALLATION INSTRUCTIONS

### RIGHT/LEFT HAND OPERATION - Refer to Figure 1.

The 5A Box Sealer can be operated from the right or left side of the machine. The box sealer is shipped with the crank handles and switch controls mounted for right hand operation.

#### FOR LEFT HAND OPERATION:

- 1) Transfer height crank to left side of machine as shown and secure with spring pin (A).
- 2) Remove and retain 2nd conveyor roller as noted for access into box sealer frame.
- 3) FOR UNITS SERIAL NOS. 1088 & ABOVE - Loosen box width holding brake located inside frame on right side, to allow shaft to turn freely.
- 4) Loosen and slide split collar to one side. Slide box coupling and box width shaft to right to allow installation of switch control box on left side.
- 5) Remove switch control knobs. Install switch control box on left side and cover plate on right side.
- 6) Reposition box width shaft with box coupling and secure split collar.
- 7) FOR UNITS SERIAL NOS. 1088 & ABOVE - Reposition and reset holding brake such that movement of side belts, while boxes are being moved thru machine, does not cause width crank to turn (34-40 in/lbs. [3.95 - 4.52 Nm] torque at box width shaft).
- 8) Transfer width crank to left side of machine as shown and secure with spring pin (AA).
- 9) Replace 2nd conveyor roller.

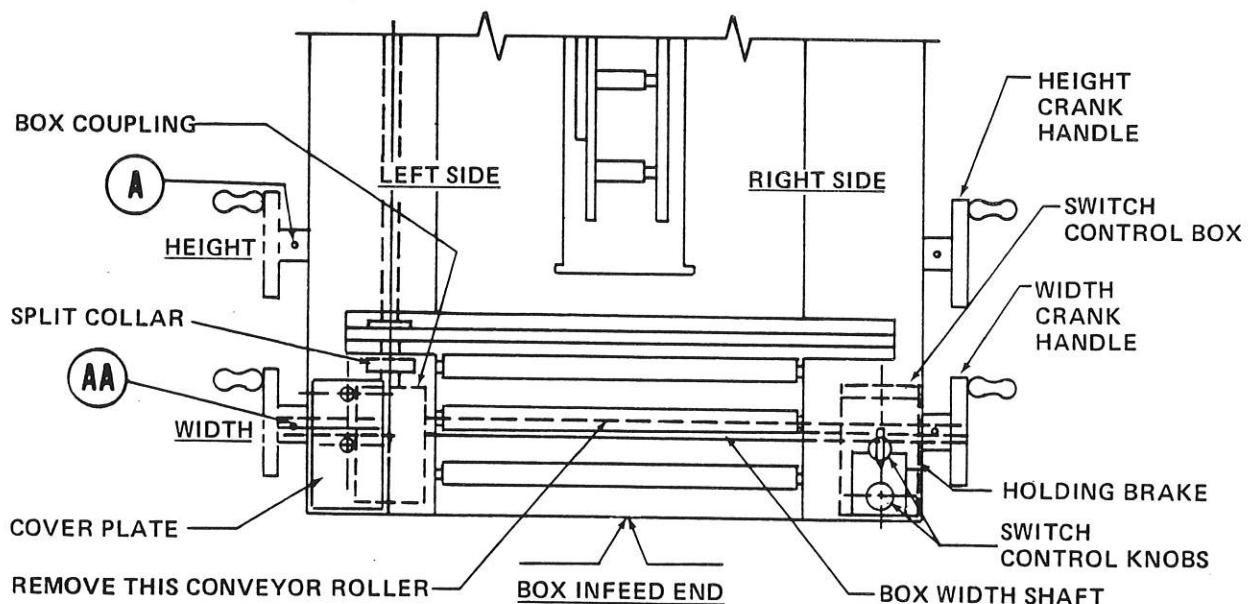


FIGURE 1 RIGHT - LEFT HAND OPERATION - TOP VIEW

## INSTALLATION INSTRUCTIONS

### Conveyor Bed Height:

The 5A Box Sealer is equipped with four adjustable legs that are located at the corners of the frame and can be set to achieve different machine conveyor bed heights. Four 3/8-16 hex head screws hold each leg in position on the machine frame. Leveling screws at the bottom of each leg are used to level the machine on uneven floor surfaces. The height of the bed of the 5A Box Sealer can be set in the following way.

- 1) Block up the machine to the desired height.
- 2) Remove and retain the four 3/8-16 hex head screws and washers in each leg, and locate the legs nearest the desired machine level where the holes in the legs (2.5 inch (63.5 mm) increments) and machine frame line up.
- 3) Reinstall and tighten the 3/8-16 hex head screws and washers. Loosen the lock nuts on the leveling screw at the bottom of each leg, and level the machine by extending or retracting each leveling screw. Retighten each of the lock nuts to secure the adjustment.

DO NOT set the leveling screws to protrude farther than is necessary to level the machine.

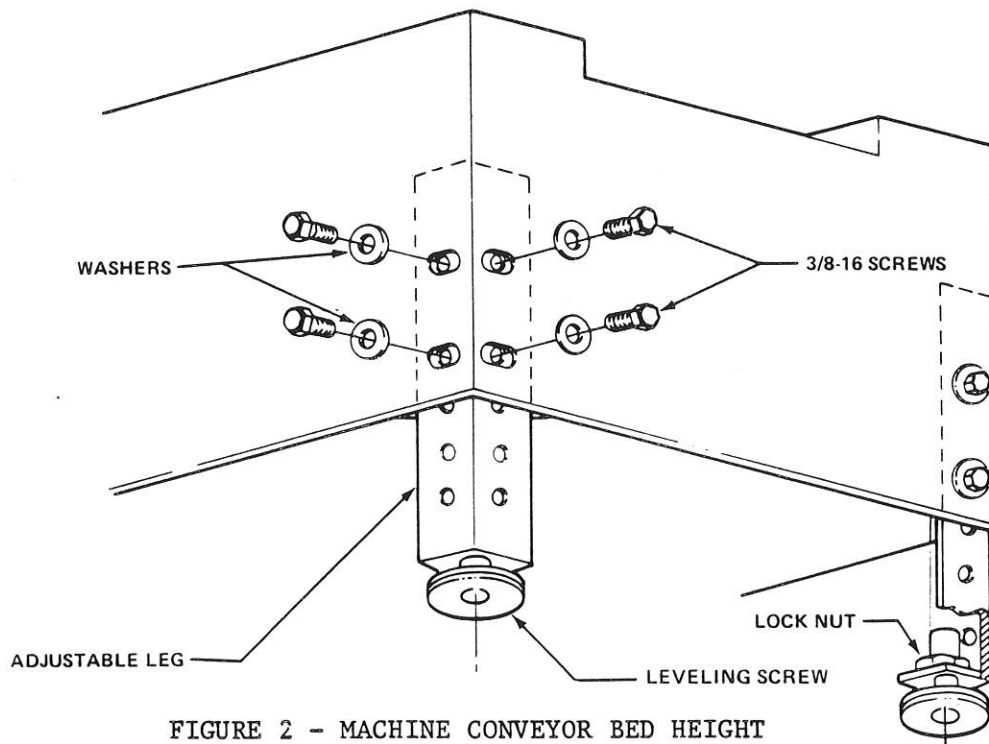


FIGURE 2 - MACHINE CONVEYOR BED HEIGHT

### ELECTRICAL CONNECTION:

The 5A Box Sealer requires 115 VAC 60 HZ electrical power only. A standard three conductor power cord and plug is provided with each machine. Do not attempt to operate the machine on 220 VAC power. Before the machine is plugged in, the main power switch on the control panel must be turned to its off position. All packaging and tools should also be removed from the roller bed, sides, and upper taping head portions of the machine. The machine power cord can now be plugged into a 115 VAC outlet.

## SET-UP INSTRUCTIONS

### Tape Loading

The 5A Box Sealer has two taping heads, each pre-set to accommodate a two inch or 48 mm wide tape roll. To dispense other tape widths, refer to the adjustment section of this manual.

Turn the power switch to "OFF" before starting the tape loading.

### IMPORTANT NOTES REGARDING SAFETY

NEVER ATTEMPT TO LOAD TAPE WHEN THE MACHINE IS RUNNING.

Both taping heads utilize sharp blades to cut the tape. These blades are mounted on a pivoting arm between the two tape applying rollers.

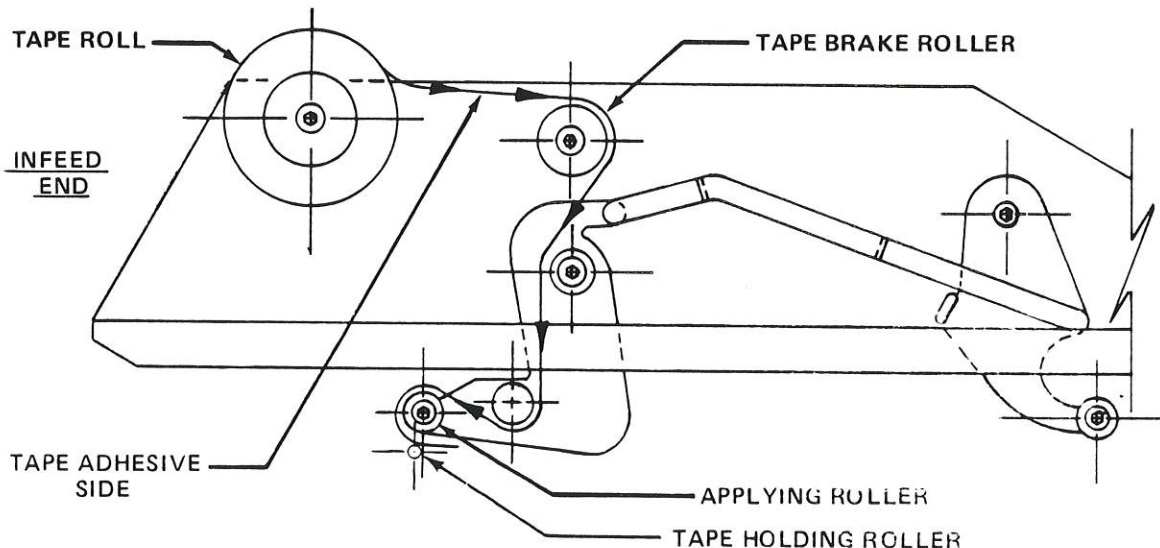
Before attempting to load the tape, identify the blade locations and keep hands out of those areas.

### Upper Taping Head - Refer to Figure 3.

Load the tape roll so the tape is dispensed toward the tape brake roller from the top of the roll with the adhesive side down.

Seat the tape roll fully against the back flange of the tape drum. Thread the tape as shown to the applying roller so the lead end extends approximately 1/2 inch (13 mm) beyond the tape holding roller in the position shown.

Rotate the tape brake roller 1/2 turn clockwise to provide the necessary tape web slack for satisfactory performance of the taping head.



UPPER TAPING HEAD

FIGURE 3 - TAPE THREADING DIAGRAM - RIGHT SIDE VIEW

## SET-UP INSTRUCTIONS (CONTINUED)

### Lower Taping Head - Refer to Figures 4A & 4B

To load the tape roll on the lower head, raise the upper head to maximum height. Pivot the lower head up until the grooved stop (B Fig. 4A), located behind the tape brake roller, can be hooked over the side conveyor bed as shown. Load the tape roll to dispense the tape toward the tape brake roller from the bottom of the roll with the adhesive side up.

Seat the tape roll fully against the back flange of the tape drum.

Thread the tape as shown to the applying roller so the lead end extends approximately 1/2 inch (13 mm) beyond the tape holding roller.

Rotate the tape brake roller 1/2 turn counter-clockwise to provide slack in the tape web.

Lower the taping head back into the roller bed.

The front location pins (C) on the head must be fully seated in the slots before starting up the machine.

NOTE - for reloading the tape supply roll on the lower taping head after the 5A Box Sealer has been set-up for desired box size, use side access door (Fig. 5) in cabinet. This will eliminate the need for resetting box height and width adjustment.

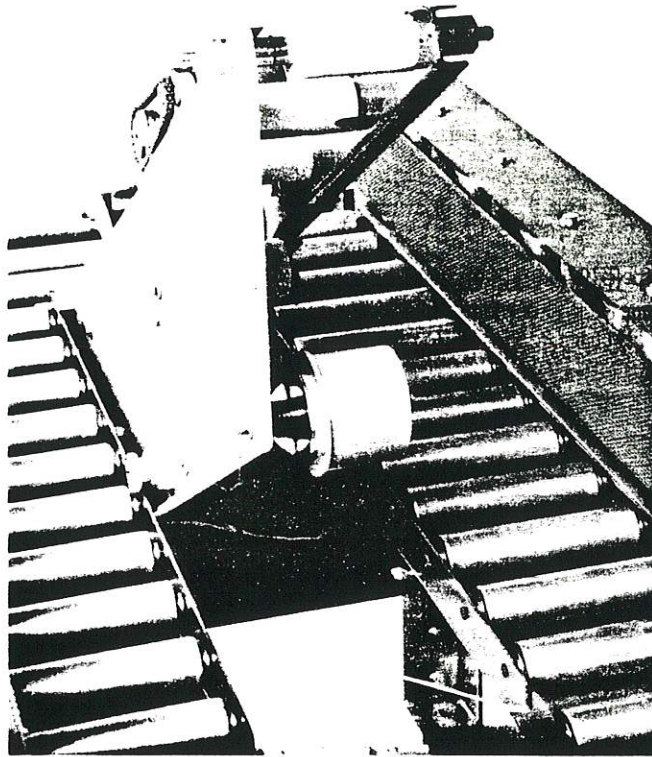


FIGURE 4A - TAPE LOADING - INFEEED END VIEW

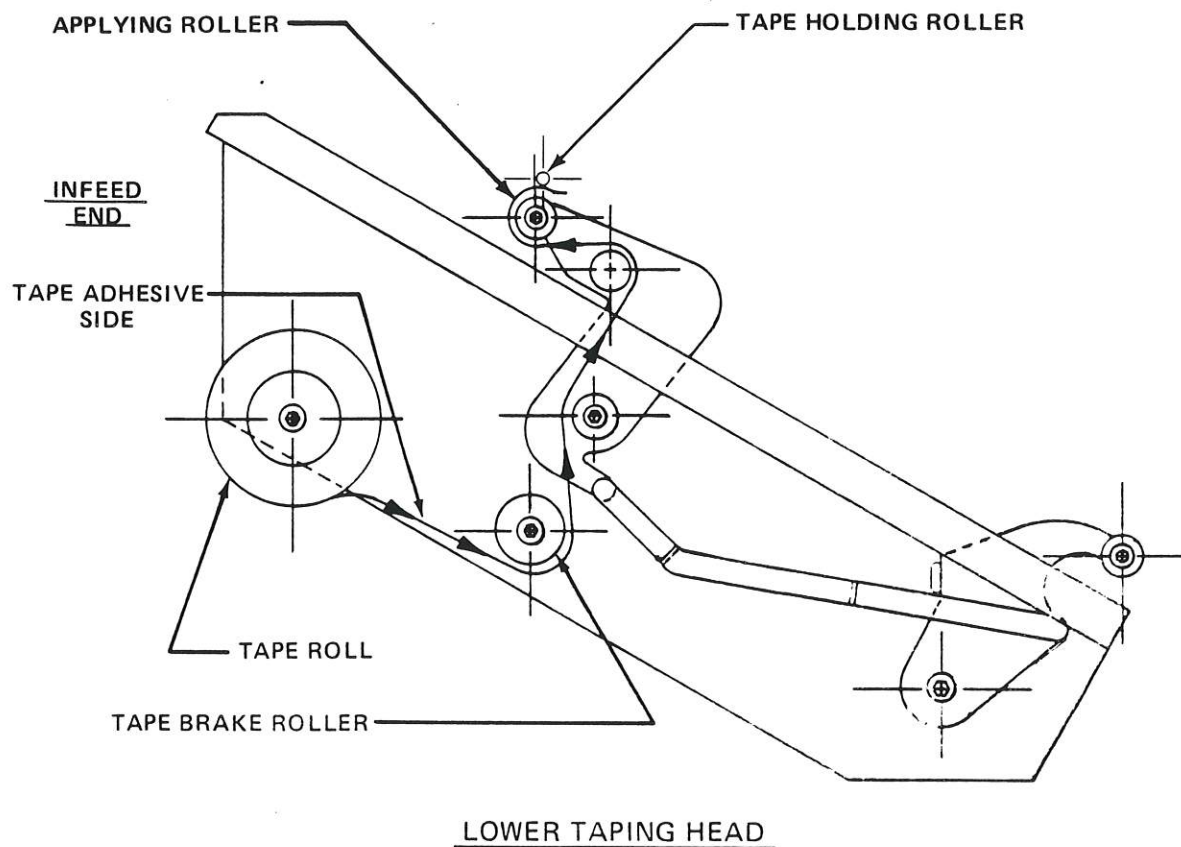


FIGURE 4B - TAPE THREADING DIAGRAM - RIGHT SIDE VIEW

## OPERATION

The 5A Box Sealer should only be operated by trained personnel and only after the machine set-up procedure has been completed. The location of the various machine elements and controls should be reviewed with the operator before the machine is started.

## POWER CONTROLS

The box sealer is equipped with a motor starter which serves as the on-off switch and provides both overload and undervoltage protection. In addition, an "emergency stop" push button switch is provided for the operator safety. These are located at the infeed end of the machine. If for any reason excessive current is required, or if either motor should overheat, causing its thermal protector to open, the starter will "trip" to the off position automatically. (If a thermal protector has opened, the machine cannot be restarted until the motor has cooled sufficiently to close the protector.) Any loss of power, including a momentary one, will "trip" the starter. Continued tripping of the starter is an indication of impending problems.

## BOX SET-UP:

The machine is sized to a box by the following procedure:

- 1) Turn machine off.
- 2) While holding top box flaps down, turn box height crank handle to lower upper taping head until it is just resting on the box.
- 3) Set lock clamp arm to secure upper head in position. (NOTE: Clearance between head and box should not exceed .06 inches (1.5 mm) with no excessive drag on the box).
- 4) Turn motor start switch to "ON" position to start the side drive belts moving.
- 5) Place box on infeed bed centered in front of lower taping head.
- 6) Turn box width crank handle slowly to close side drive belts until enough drive force is transmitted to the box to drive it through the taping heads. (Avoid closing side drive belts too much - causing pinched boxes.)

## CAUTION

When feeding the machine, a box must not be fed until the previous box has cleared the machine and the taping mechanisms have returned all the way to their starting positions. Failure to observe this precaution may cause improper taping and may damage the taping mechanism.

## BOX JAM

If it becomes necessary to clear a jammed box, the machine should be turned off and the head raised and/or belts opened as needed. Do not attempt to clear with machine running.

## BELT FORCE LIMITER

The machine is equipped with a spring coupling which provides for a slight variation in box width and limits the squeezing force which can be applied to the sides of a box to 50 lbs (22 kg).

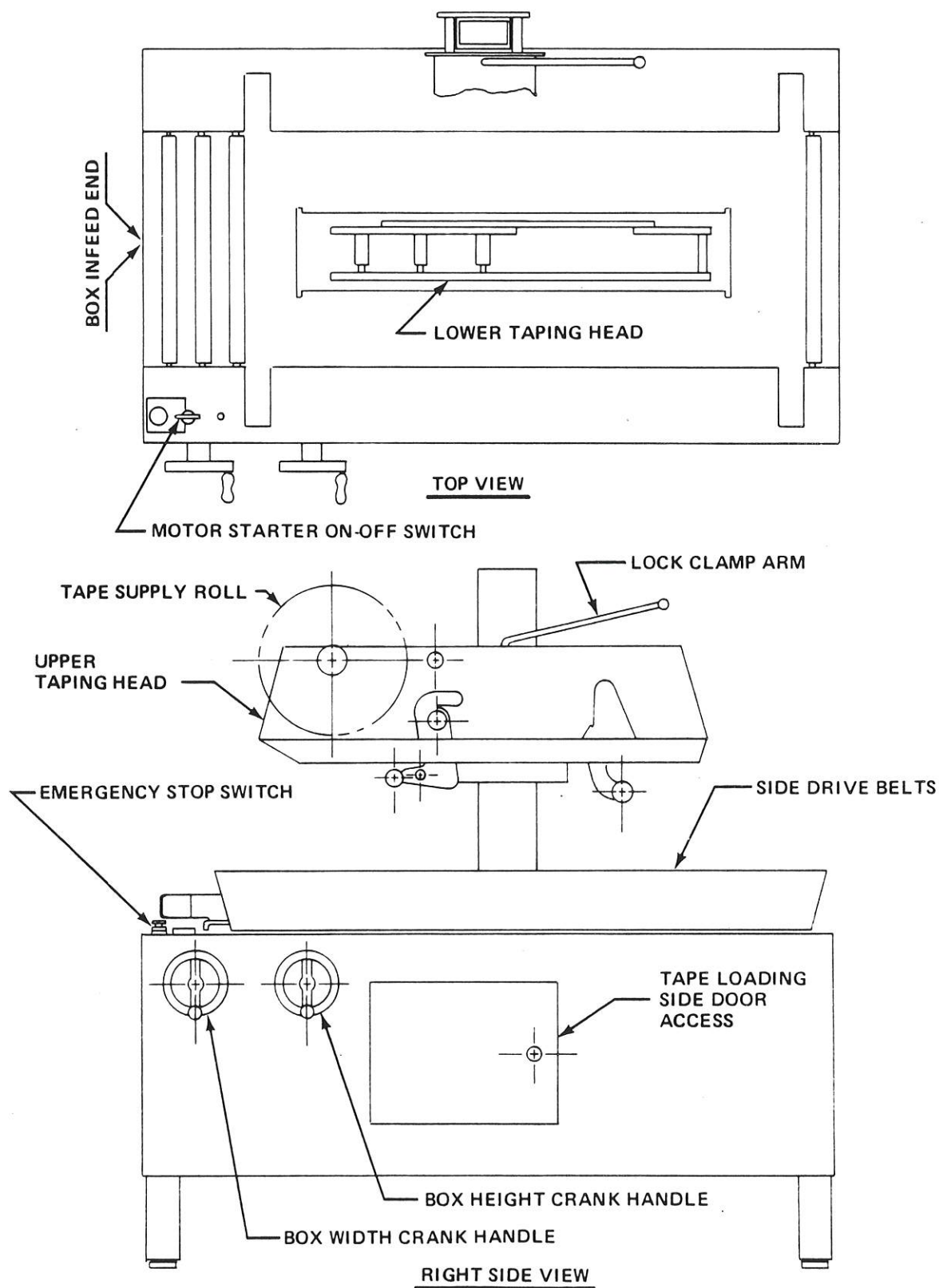


FIGURE 5 - CONTROL LOCATIONS



## ADJUSTMENTS

CAUTION: NEVER ATTEMPT TO MAKE ADJUSTMENTS WHEN THE MACHINE IS RUNNING.  
DISCONNECT MAIN POWER BEFORE STARTING ADJUSTMENTS.

Tape Width Alignment - Refer to Figure 6.

The tape drum assemblies on the upper and lower taping heads can accommodate 1 1/2 inch or 36 mm, 1 3/4 inch or 42 mm, 2 inch or 48 mm tape. The following adjustment is the only requirement to convert each tape drum assembly to assure the desired tape width is always centered on the box seam.

2 Inch or 48 mm Wide Tape - Locate two SPACERS between the tape drum and the shim washer.

1 3/4 Inch or 42 mm Wide Tape - Locate one SPACER between the tape drum and the shim washer and one SPACER between the friction brake plate and tape drum spring.

1 1/2 Inch or 36 mm Wide Tape - Locate two SPACERS between the friction brake plate and tape drum spring.

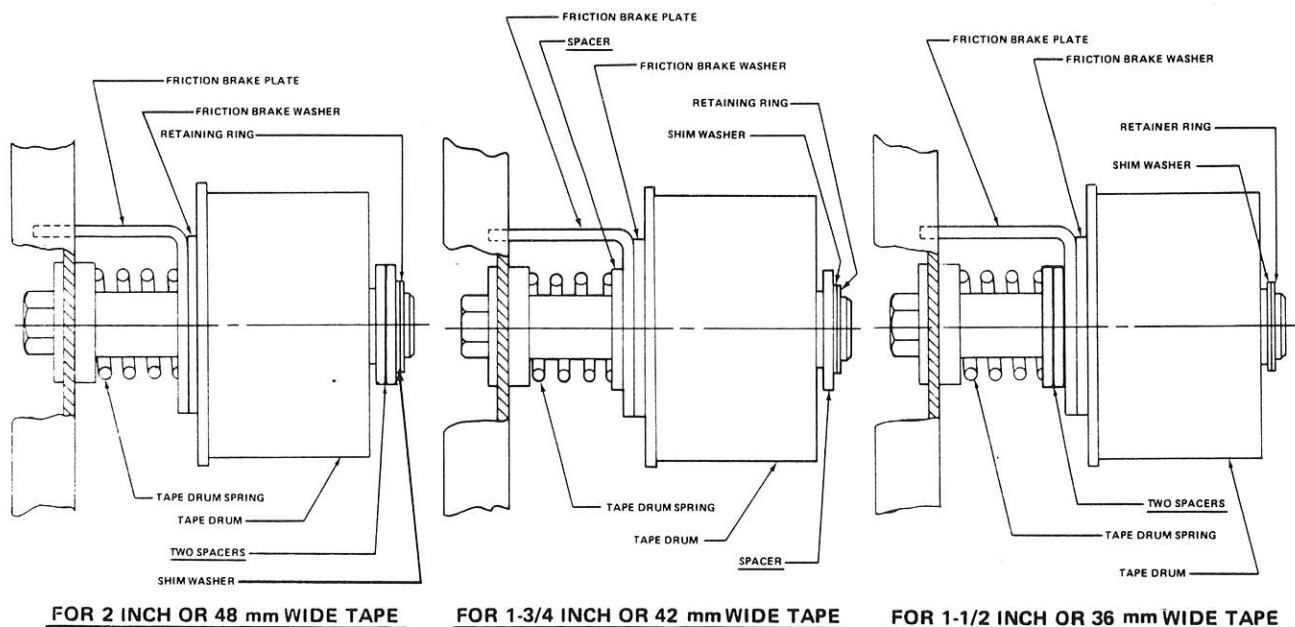


FIGURE 6 - TAPE WIDTH ALIGNMENT - TOP VIEW

CHAIN TENSION CHART

REF. NO.	CHAIN	WHERE LOCATED	QTY.	TOTAL LATERAL MOVEMENT INCH + .06 (1.5 mm)	HOW TO ADJUST
(1)	Tape holding roller	Taping heads	2	.38 (9.65 mm)	Loosen screw into center hub of large sprocket; move sprocket assembly to proper position in slot, retighten screw.
(2)	Width	On conveyor drive assemblies	4	.62 (15.75 mm)	Run conveyor belts open to maximum width; adjust eyebolts equally at both ends of chain.
(3)	Height	Left infeed corner of cabinet	1	.75 (19.05 mm)	Loosen screw in idler bar and rotate for proper tension.

ADJUSTMENTS (CONTINUED)

Chain Tension - Refer to Figures 7 & 8

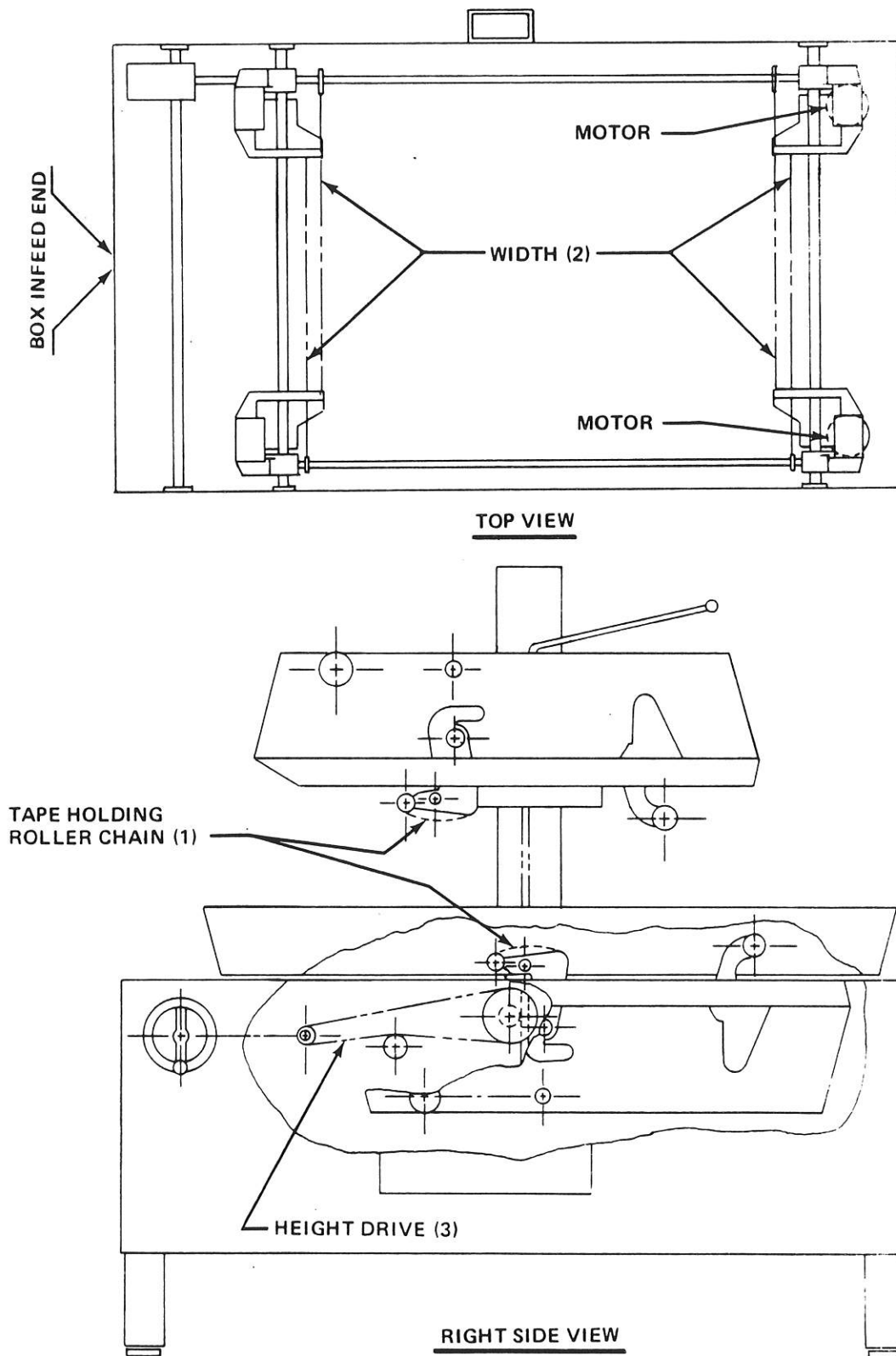


FIGURE 7 - CHAIN LOCATIONS

(For reference numbers shown in ( ) see chart on opposite page.

## ADJUSTMENTS (CONTINUED)

### How To Measure Chain Tension

Always measure the chain tension at mid-span and on the side opposite the idler when used.

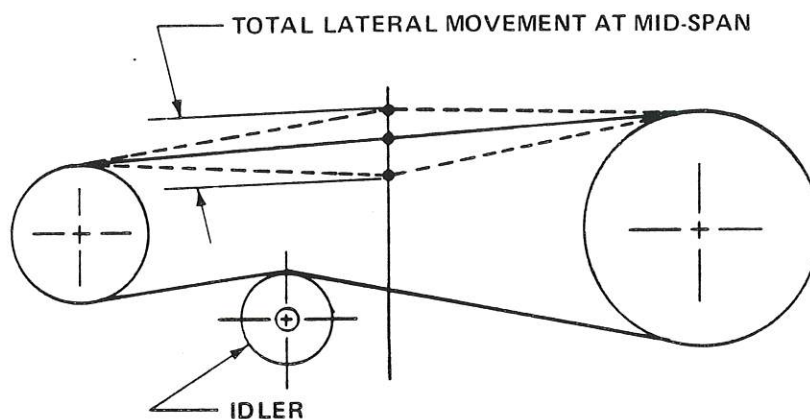


FIGURE 8 - TYPICAL CHAIN TENSION MEASUREMENT

### BOX DRIVE BELT TENSION

Adjust the drive belt tensioner as shown in figure 9 such that a 5 lb. (2.3 kg) outward force at midspan will deflect the belt  $1.00 \pm .125$  (25.40  $\pm$  3.18 mm).

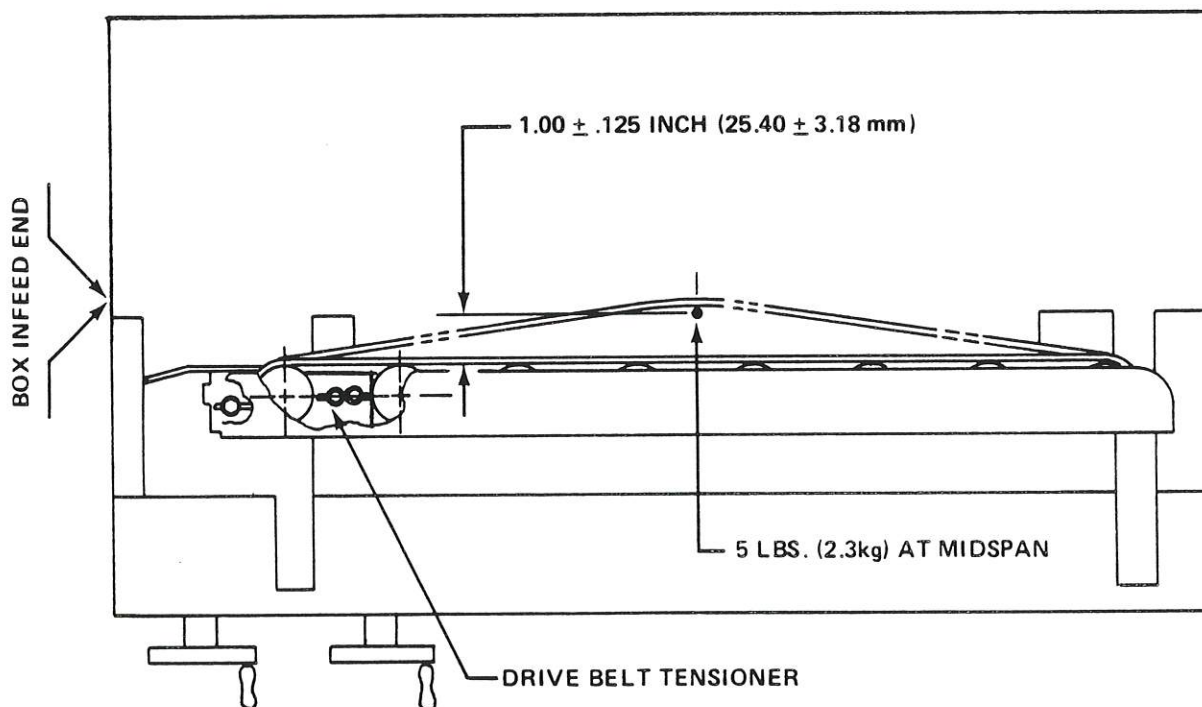


FIGURE 9 - BOX DRIVE BELT TENSION - (TOP VIEW)

ADJUSTMENTS (CONTINUED)

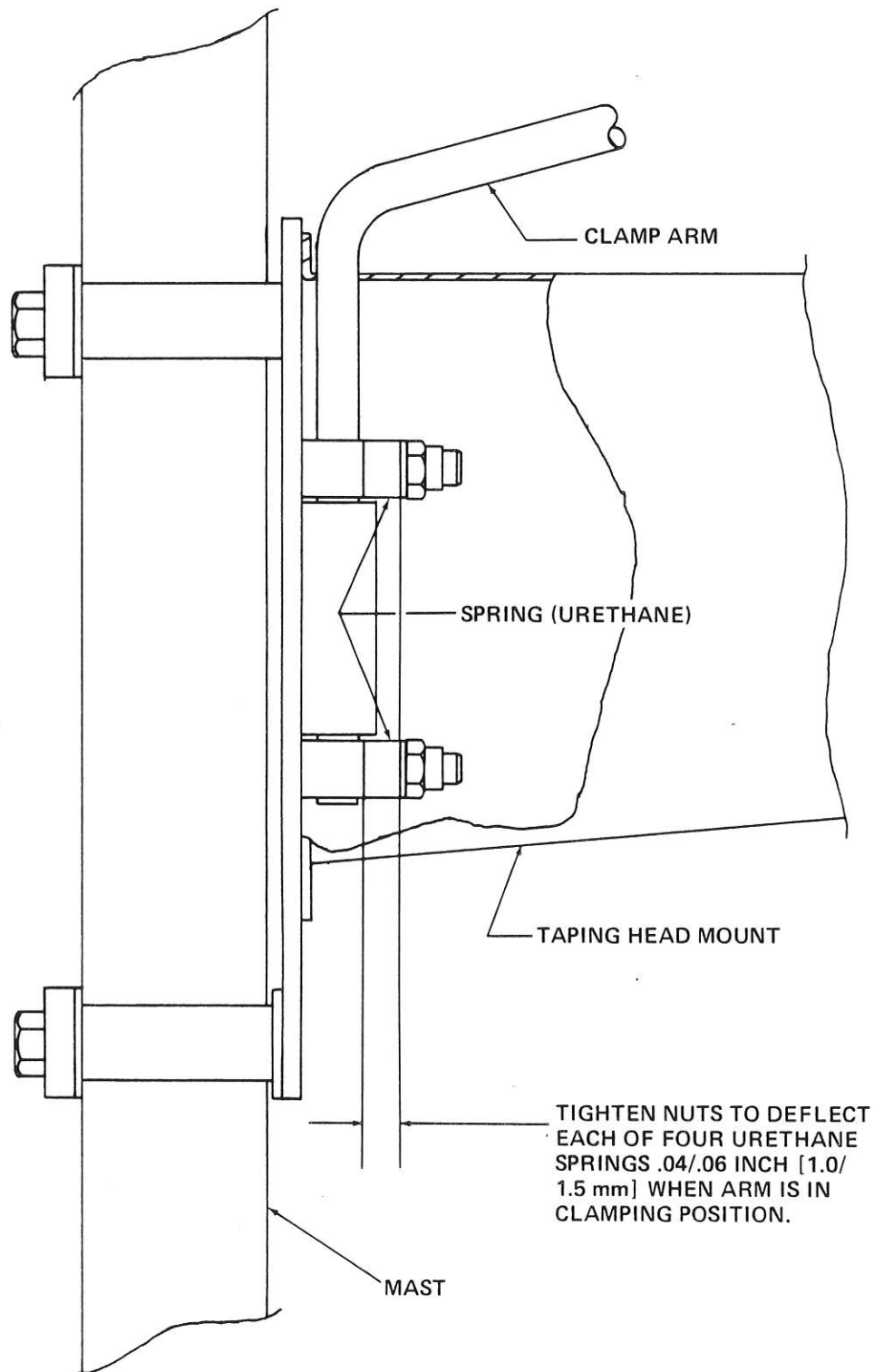


FIGURE 10 HEAD CLAMP (Infeed End View)

UPPER TAPING HEAD CLAMP

The upper tapping head clamp has been pre-set to provide sufficient holding force to secure the tapping head. If any clamp assembly parts are replaced, refer to Figure 10 and adjust the tension as noted.

## ADJUSTMENTS (CONTINUED)

### HEIGHT HOLDING BRAKE

The height brake has been pre-set to provide sufficient holding force to support the taping head when the clamp arm is in free position. If any height brake parts are replaced, refer to figure 11 and adjust the brake as noted.

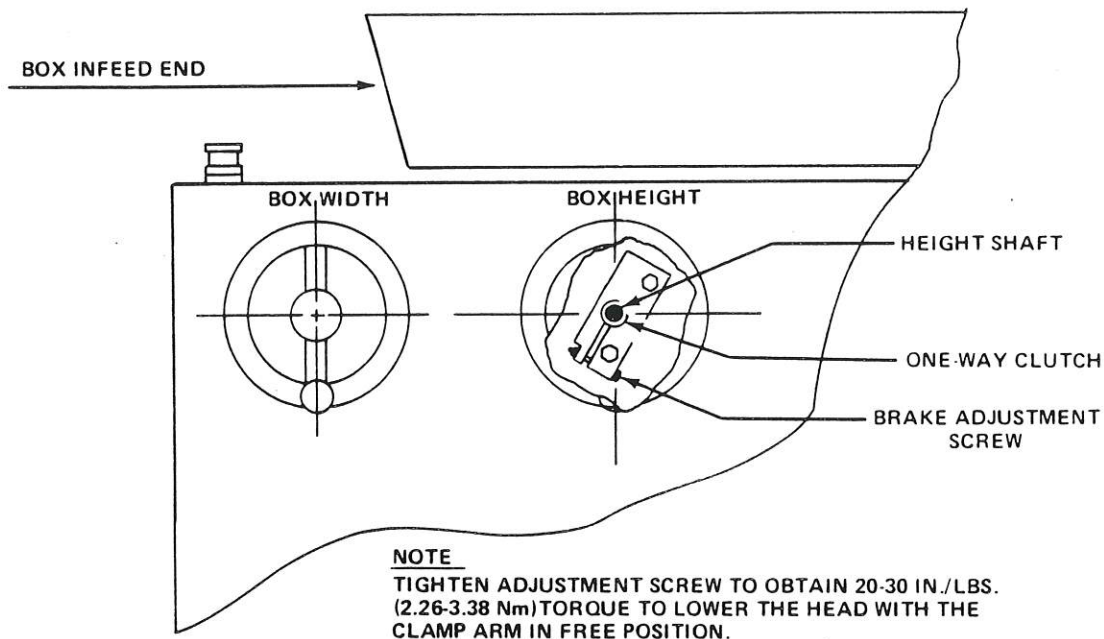


FIGURE 11 - HEIGHT BRAKE HOLDING FORCE (Right Side View)

### WIDTH HOLDING BRAKE - (For Serial Nos. 1101 & above)

The width brake has been pre-set to provide sufficient holding force. If any width brake parts are replaced, refer to figure 11A and adjust the brake as noted

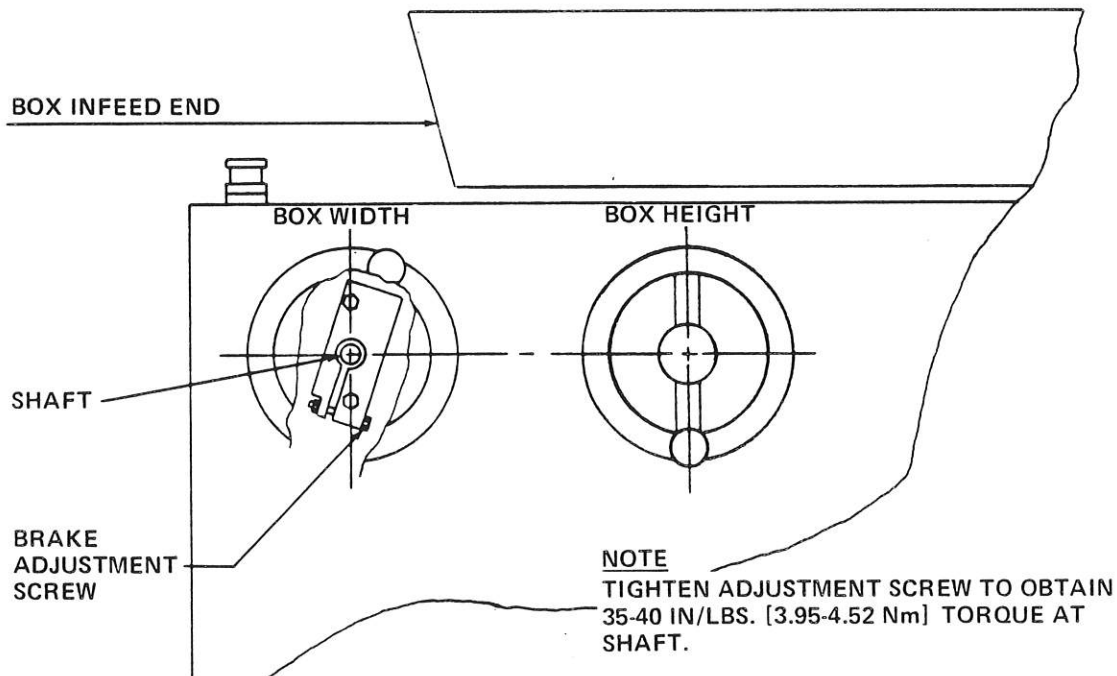


FIGURE 11A - WIDTH BRAKE HOLDING FORCE (Right Side View)  
(For Serial Nos. 1101 & Above)

## ADJUSTMENTS (CONTINUED)

### APPLYING ROLLER AND BUFFING ROLLER STOP POINT - Refer to Figure 12.

The applying and buffing rollers located on the upper and lower taping heads, must be within the dimensions shown for proper tape application.

- 1) Adjust stop - upper buffing arm eccentric to obtain .00/.03 inch [.00/.762 mm] dimension between lower edge of buffing roller and lower edge of holddown rail as shown.
- 2) When arms are in upper stop position (dotted line), adjust "bushing-buffing arm adjustment" to obtain .06/.12 inch [1.524/3.048 mm] dimension between lower edge of applying roller and lower edge of holddown rail.
- 3) Adjust lower stop - lower buffing arm eccentric to obtain 1.31/1.25 inch [33.274/31.75 mm] dimension when applying roller is in start position.

### Tape Holding Roller Latch Point - Refer to Figure 12A

The tape holding roller must be returned by the ratchet and pawl to the position shown in figure 12B after each tape application.

To adjust, refer to figure 12A and rotate the adjusting cam so that angle  $\alpha$  becomes  $0^\circ$  when the applying roller is at dimension shown.

### Tape Holding Roller Timing - Refer to Figure 12B.

The tape holding roller, located next to the tape applying roller on the upper and lower taping heads, must be within the dimension shown for proper tape application.

To adjust, loosen the two set screws in the ratchet ring, hold ratchet ring in contact with pawl and rotate large sprocket until tape holding roller is in the proper position. Tighten the two set screws to secure the ratchet ring.

### Sprocket Alignment

All sprockets for a specific chain must be in line within .028 inches [.711 mm].

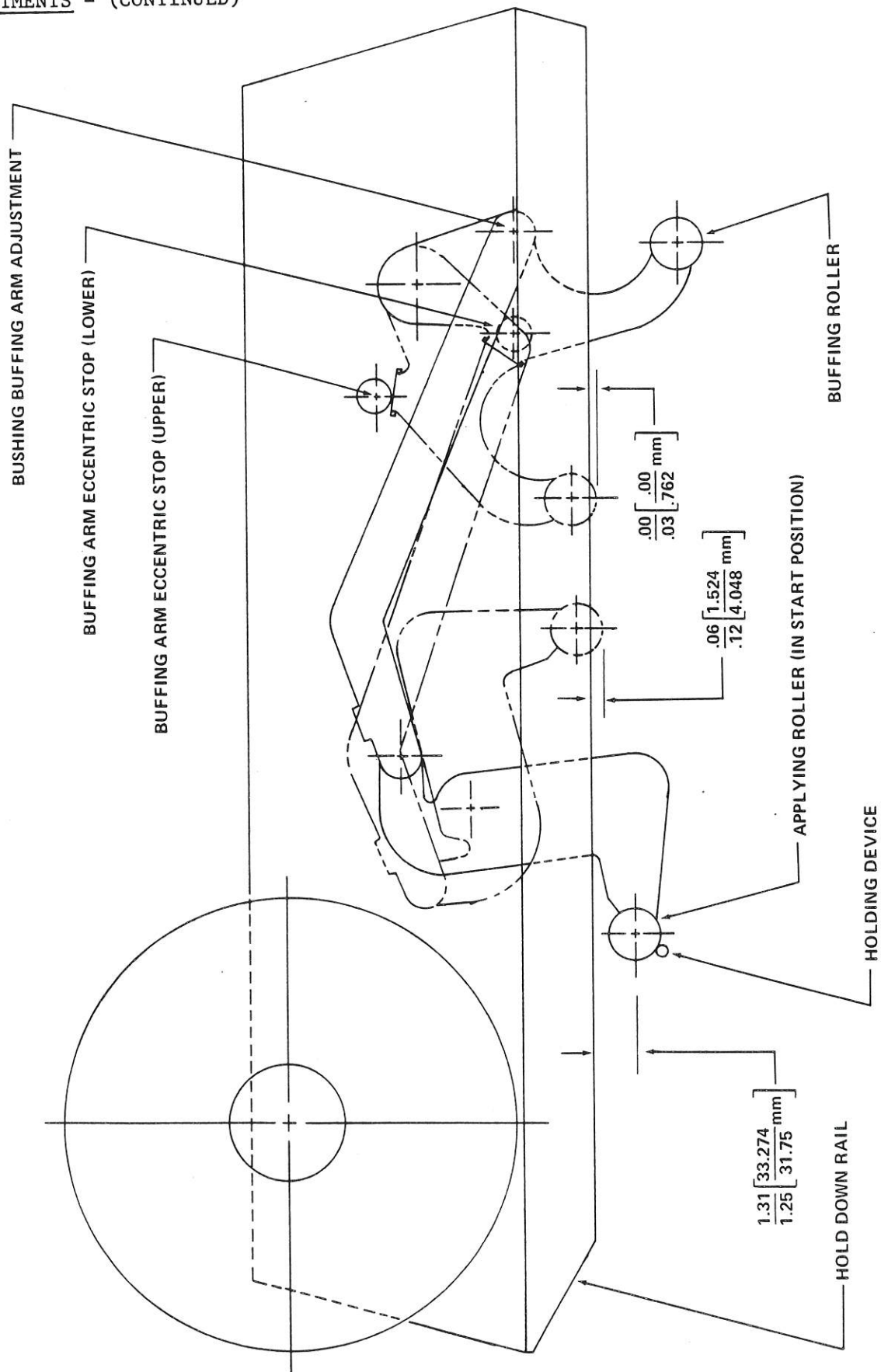


FIGURE 12 - APPLYING ROLLER AND BUFFING ROLLER STOP POINTS.  
(Upper taping head shown)

# ADJUSTMENTS (CONTINUED)

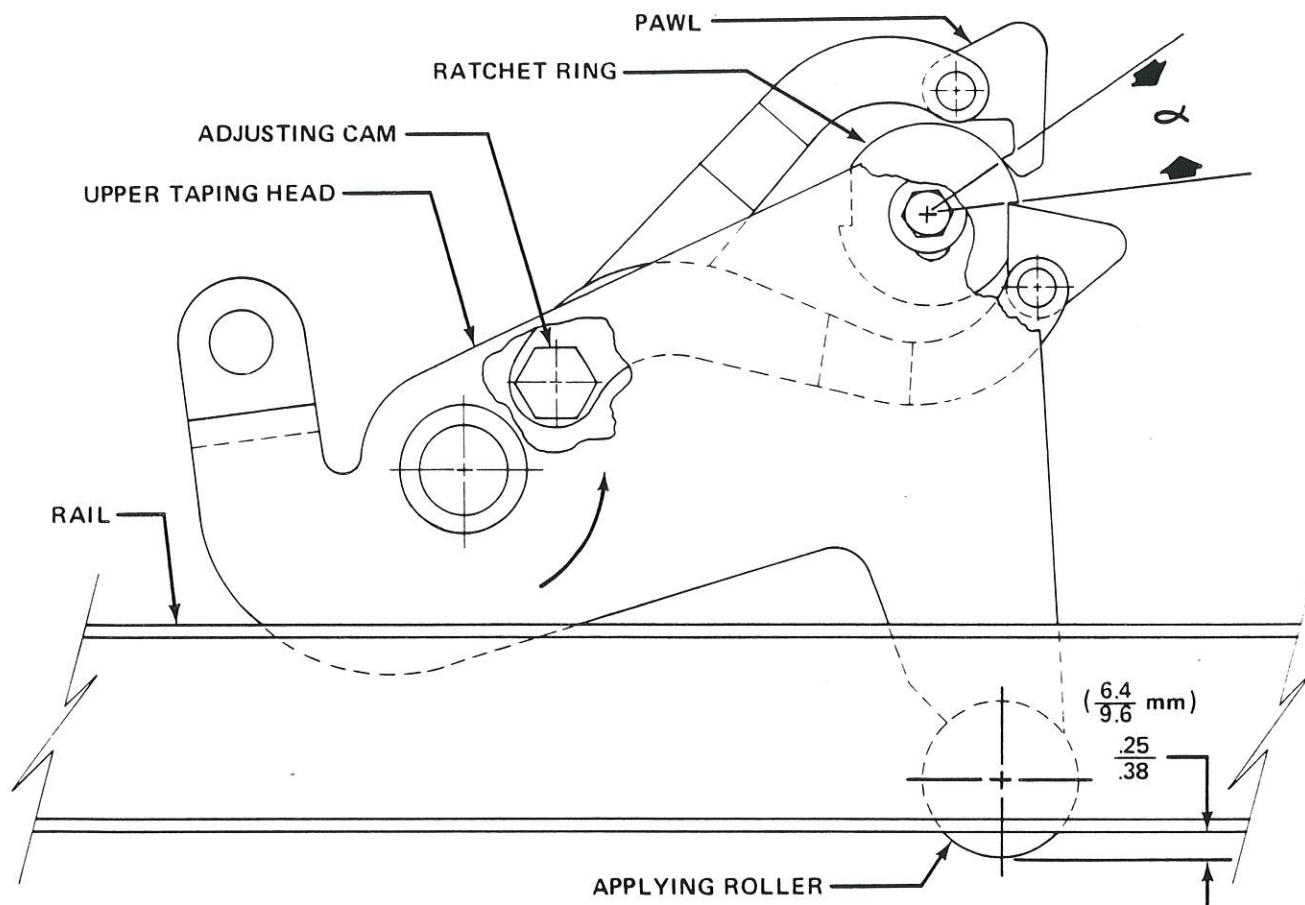


FIGURE 12A - TAPE HOLDING ROLLER LATCH POINT

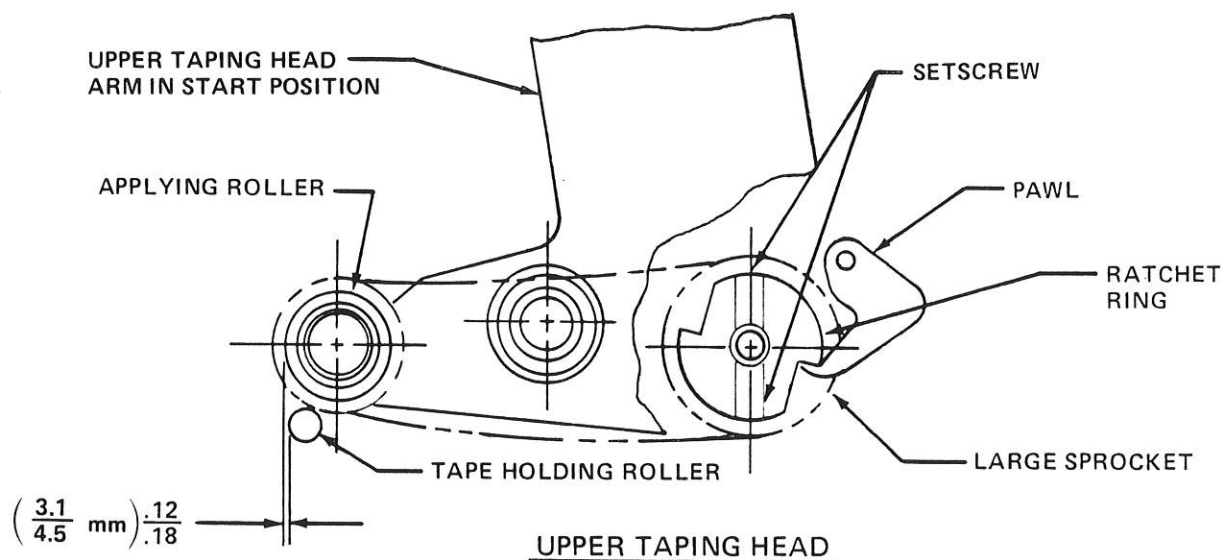


FIGURE 12B - TAPE HOLDING ROLLER TIMING

## ADJUSTMENTS (CONTINUED)

Taping Head Cut-off Adjustment - Refer to Figure 13.

CAUTION BOTH TAPING HEADS UTILIZE SHARP BLADES TO CUT THE TAPE.  
USE CARE IN THIS ADJUSTMENT.

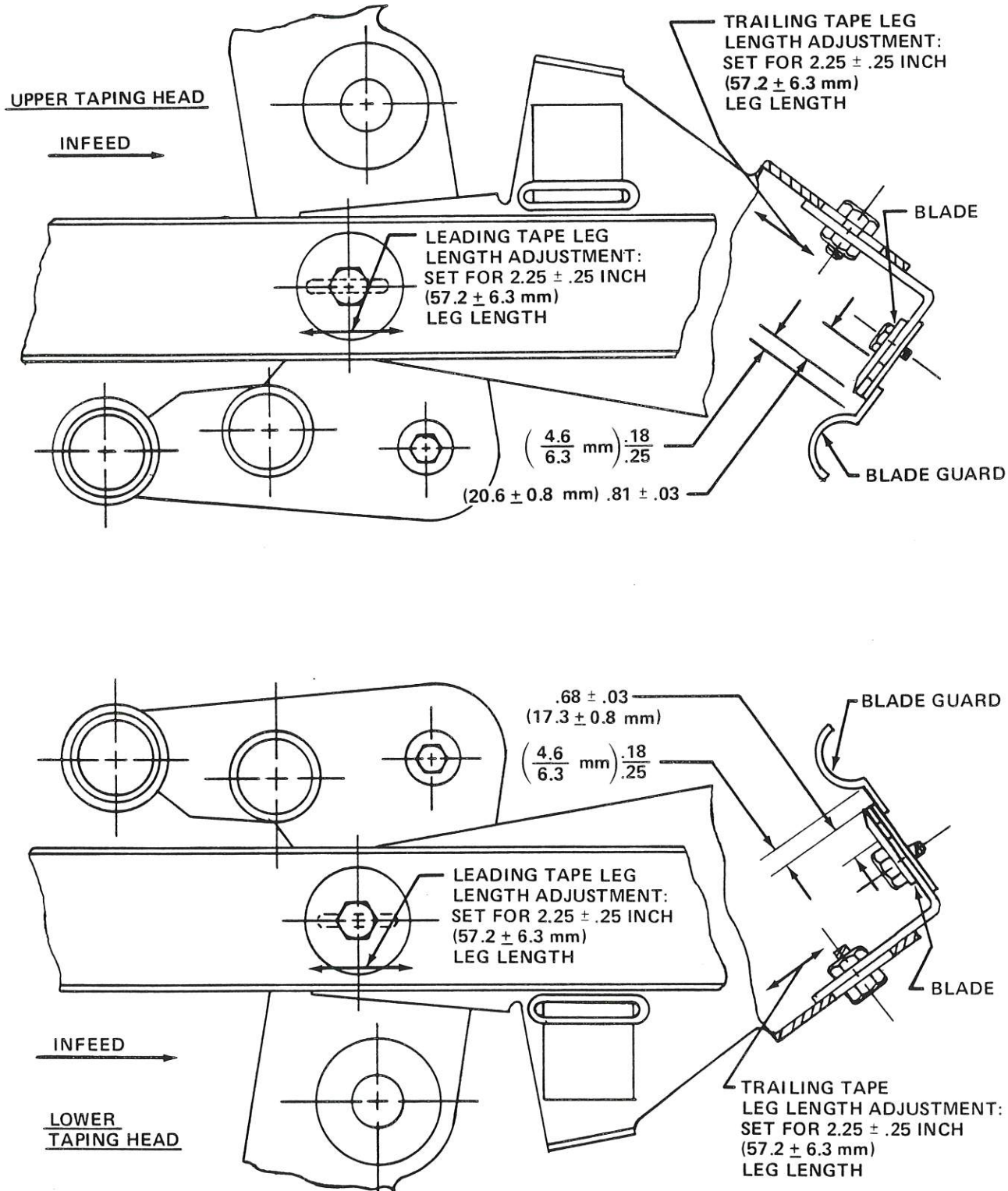


FIGURE 13 - UPPER AND LOWER CUT-OFF ADJUSTMENT - RIGHT SIDE VIEW

## MAINTENANCE

CAUTION - DISCONNECT MAIN POWER BEFORE STARTING MAINTENANCE.

### Cleaning Of The Machine

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 inside the machine, it can cause wear on the drive components and overheating in the motors. The dirt build-up can be easily removed from the machine roller bed and from inside the machine through the access panels by a shop vacuum. Cleaning the 5A Box Sealer 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 machine 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. Never attempt to remove dirt from the inside of the machine by blowing it out with compressed air. This will only cause the dirt to be blown inside the machine components and onto sliding surfaces. Gritty dirt in these areas can cause serious machine damage.

### Chain And Belt Inspection Intervals

Inspect conveyor chain and belt after 100 hours of operation and at 500 hour intervals thereafter. Refer to the adjustment section for proper chain tension adjustment procedure.

### Lubrication

The chart on the next page provides a guide to the lubrication areas and the type and frequency of the lubrication.

MAINTENANCE (CONTINUED)

MACHINE AREA & LOCATION	PART NAME & REF. NO.	LUBRICATION		INSTRUCTIONS
		FREQUENCY	REF. NO.	
Front & Rear Belt Drive Assy. (Fig. 17)	Chains Ref. Nos. 343 & 355	250 Hrs.	2	Apply light coat to surface.
	Shaft-Linear Bearing Ref. No. 265	250 Hrs.	1	Apply light coat to outside dia. of shaft.
Lower Applying Arm (Fig. 25)	Ring-Ratchet Ref. No. 152	6 Mos.	1	Apply light coat to outside diameter.
	Knurled Roller Assy. Ref. No. 210	6 Mos.	2	Apply light coat to inside dia. of roller clutch.
	Chain - Ref. No. 110	6 Mos.	2	Apply light coat to surface of chain.
Upper Applying Arm (Fig. 23)	Ring-Ratchet Ref. No. 145	6 Mos.	1	Apply light coat to outside diameter.
	Knurled Roller Assy. Ref. No. 233	6 Mos.	2	Apply light coat to inside dia. of roller clutch.
	Chain - Ref. No. 110	6 Mos.	2	Apply light coat to surface of chain.
Mast Assy. (Fig. 21)	Chain - Ref. No. 94	6 Mos.	2	Apply light coat to surface.
	Rack, Mast Ref. No. 244	6 Mos.	1	Apply light coat to teeth.

REF. NO.	3M PART NO.	LUBRICATION
1	78-8000-7816-0	Lubricant-Texaco Marfax Multi/Purpose No. 2
2	78-8005-8869-7	Lubricant, Oil Sta-vis Spindle Lightweight, Rated 100 SSU at 100° F.

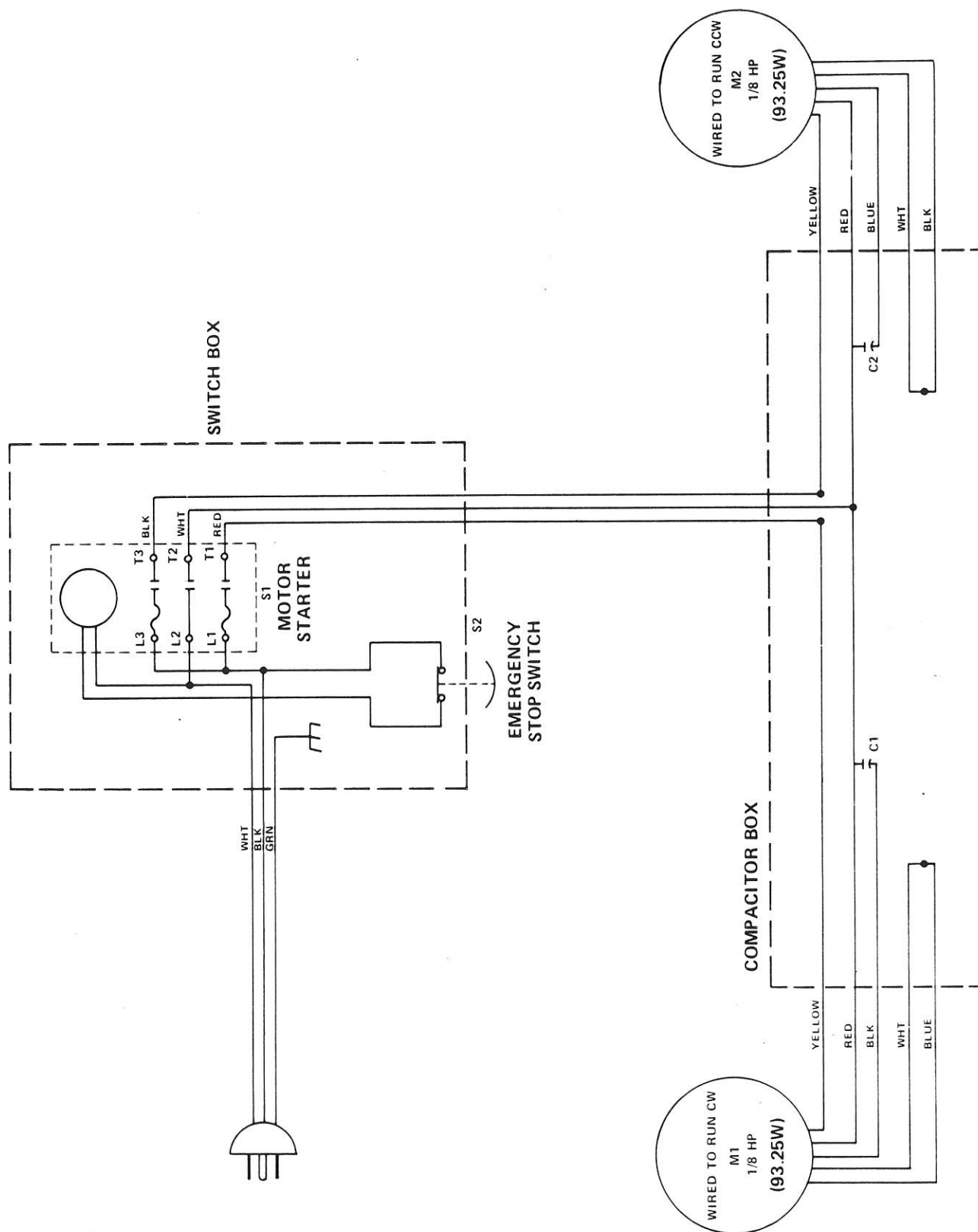


FIGURE 14 - ELECTRICAL SCHEMATIC - 5A, MODEL 276  
(Serial Nos. 1003 - 1100)

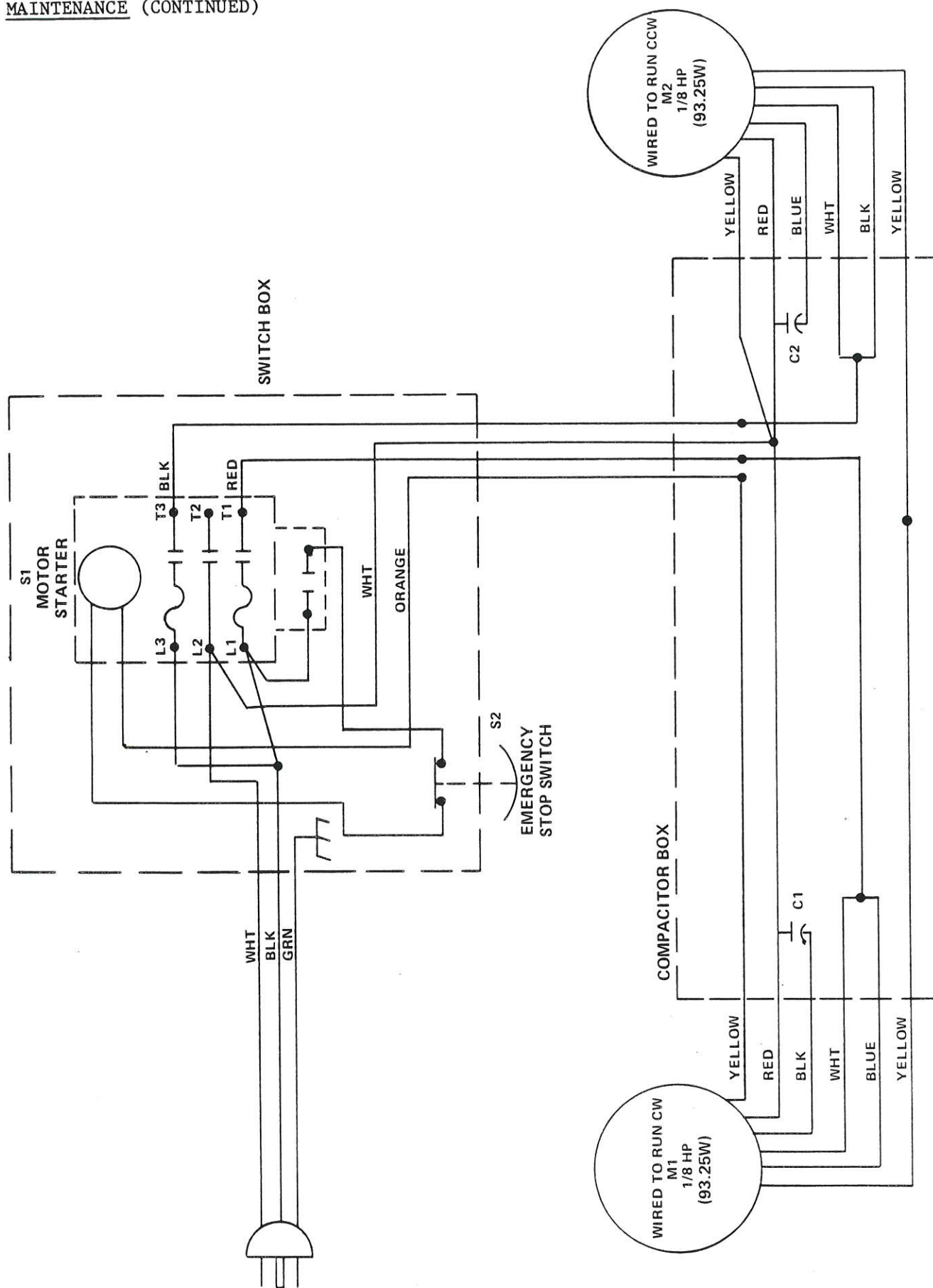


FIGURE 14A - ELECTRICAL SCHEMATIC 5A, MODEL 276  
(Serial Nos. 1101 & Above)

### SUGGESTED SPARE PARTS LIST

It is suggested that the following minimum list of spare parts be maintained;  
NOTE: Refer to replacement parts list for full part description.

<u>QTY.</u>	<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>DESCRIPTION</u>
1	81	78-8000-5935-0	Ring - Retaining
2	98	78-8005-4399-9	Ring - Retaining
2	153	78-8014-1199-8	Spring, Torsion
1	154	78-8014-1201-2	Spacer - Spring
1	155	78-8014-1203-8	Pin - Pivot
1	156	78-8014-1205-3	Roller - Knurled
2	157	78-8014-1220-2	Spring, Torsion
4	158	78-8014-1314-3	Spring - Pawl Extension
1	159	78-8014-1318-4	Spring, Extension
1	160	78-8014-1319-2	Spring, Extension
1	161	78-8014-1320-4	Spring, Extension
1	162	78-8014-1321-8	Spring, Extension
4	197	78-8014-1747-4	Buffing Roller
2	203	78-8014-1762-3	Shaft, Weldment
2	240	78-8015-6419-2	Belt, Drive
4	304	78-8015-6605-6	Blade, Crush Ground

NOTE: All above parts are replaceable stock items.

## HOW TO ORDER REPLACEMENT PARTS

- 1) Refer to figure 15 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 commercially available components. This has been done to allow obtaining these standard parts locally, should the customer elect to do so.

Reference numbers identified by (\*) indicate parts are available, but not a normal replacement stock item.

- 4) Order parts by part number, part name, machine catalog number, model number and part quantity required.  
(Order form attached to back cover of manual.)

Minimum billing on parts orders will be \$10.00.

Replacement part prices available on request.

- 5) Replacement parts and part prices available direct from:

Dispenser Parts  
Tape & Allied Products Group/3M  
P. O. Box 33900  
St. Paul, MN 55133

- 6) Repair service available direct from 3M Branch Offices.  
Refer to the front of the instruction manual for branch service information.

## CONSUMER BLADE DISCOUNT

Consumer orders for 100 - 199 blades (one blade per quantity) will receive a 10% discount. Consumer orders for 200 or more blades (one blade per quantity) will receive a 25% discount.

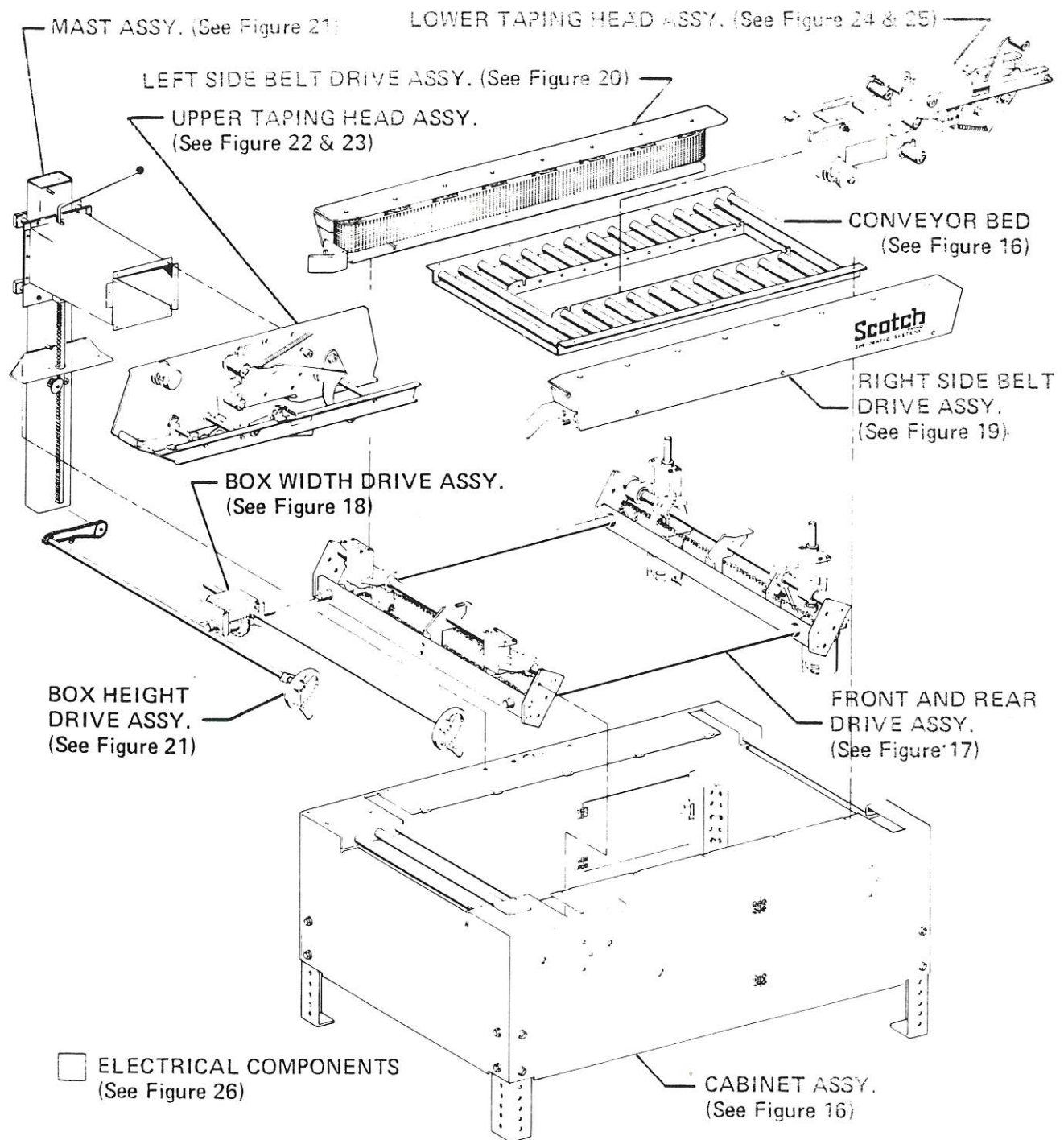


FIGURE 15 - 5A BOX SEALER, MODEL 276 COMPONENT ILLUSTRATIONS

Refer to the area of the machine for the figure number or numbers and refer to those figures for the part reference numbers.



REPLACEMENT PARTS LIST  
CAT. NO. 5A BOX SEALER, MODEL 276  
FIGURE 16 - CONVEYOR BED AND CABINET ASSEMBLY

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
* 12	26-0000-0203-5	Washer - Plain Type A, 3/8 Wide
* 18	26-1000-0925-2	Nut - Retainer, Tinnerman #C-7998-1420-3B
* 21	26-1000-1059-9	Screw-Cap, Hex Hd, 3/8-16 UNC x 3/4 L. "LOC-WEL"
* 42	70-8000-5034-9	Screw - Cap, Hex Hd. 1/4-20 UNC x 3/4 L.
* 53	70-8000-4191-8	Nut-Light Hex, Full Ht. 10-32 UNF, "FLEXLOC" #23-FC-1032
* 55	70-8000-4787-3	Screw-Mach. Hex Hd. Trmd. 10-32 UNF x 1/2 L.
* 57	70-8000-4795-6	Washer - Plain, Type A, 1/4 Narrow
* 70	70-8000-2513-5	Nut - Hex Jam, 5/8-11 UNC x 3/4 Finished
* 88	78-8003-7829-7	Washer - Plain, Type A, #10 Narrow
*188	78-8014-1686-4	Door - Back
*266	78-8015-6457-2	Frame Assy.
*267	78-8015-6460-6	Bed - Center
*284	78-8015-6497-8	Access Door - Left Side
*294	78-8015-6570-2	Label - Box Width Right
*295	78-8015-6571-0	Label - Box Width Left
*296	78-8015-6572-8	Label - Box Height Right
*297	78-8015-6573-6	Label - Tape Head Caution
*298	78-8015-6574-4	Label - Box Height Left
*305	78-8015-6606-4	Label - Emergency Stop
*306	78-8015-6607-2	Plate - Identification Label
*314	78-8015-6616-3	Cord - Electrical Power
*316	78-8015-6622-1	Leg - Support
317	78-8015-6624-7	Foot - Leveling Assy.
*330	78-8032-4117-9	Hinge- Stocker #4-5164-0190
*334	78-8032-4265-6	Roller-Conveyor, Light Duty, 1 3/8 Dia. x 18 Ga. Wall 5/16 Hex. Shaft Spring Loaded
*335	78-8032-4266-4	Roller - Conveyor, Light Duty, 1 3/8 Dia. x 18 Ga. Wall 5/16 Hex Shaft Spring Loaded
342	78-8032-4753-1	Magnetic Catch - "SOUTHCO" #02-10-102-10
*357	78-8003-9645-5	Bushing Heyco #5R-7W-2

NOTE - Parts identified by (\*) are available, but not a normal replacement stock item

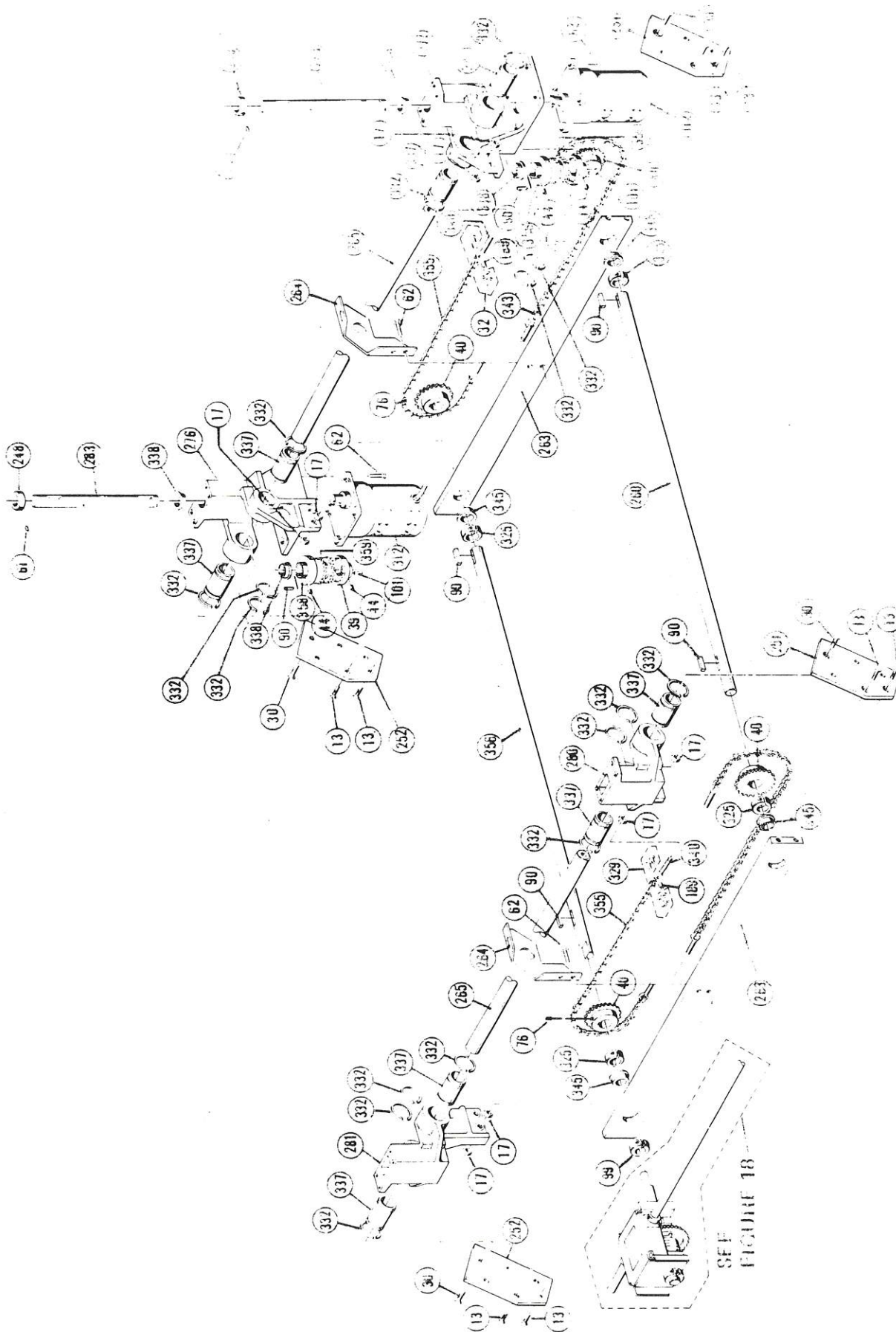


FIGURE 17 - FRONT & REAR DRIVE ASSEMBLY  
Refer to page 28 for front and rear assembly parts list.

REPLACEMENT PARTS LIST  
CAT. NO. 5A BOX SEALER, MODEL 276  
FIGURE 17 FRONT & REAR DRIVE ASSEMBLY

<u>REF.NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
* 13	26-1000-0159-8	Screw- Cap, Fl. Hd. Hex Soc. 5/16-18 UNC x 3/4 "LOC-WEL"
* 17	26-1000-0812-2	Nut-Hex, 5/16-18 UNC
* 30	26-1000-3976-2	Screw-Cap Fl. Hd. Hex Soc Dr. 1/2-15 UNC x 1 "LOC-WEL"
* 39	26-1000-3992-9	Coupling - TB Woods "SURE FLEX" No. 4J x 1/2 Bore
* 40	26-1000-5661-8	Sprocket - Chain S Strand Diamond 40B16F
* 44	70-7023-6850-0	Screw-Set, Hex Soc. Dr, Cup Pt. 1/4-20 UNC x 1/4 L. "LOC-WEL"
* 61	70-8000-5334-3	Screw - Set, Hex Soc., Cup Pt. 10-32 UNF x 1/4 "LOC-WEL"
* 62	70-8000-5339-2	Screw-Cap, Hex Hd. 1/4-20 x 3/4 L. "LOC-WEL"
* 76	70-8656-9650-7	Screw-Set, Hex Soc Dr. Cup Pt. 1/4-20 UNC x 5/16 L. "LOC-WEL"
* 90	78-8003-8225-7	Key - Stl, 1/4 Sq. x 1 Lg.
* 99	78-8005-4726-3	Collar - One Piece Split Maxwell 12 L
*101	78-8005-6576-0	Key - Stl. 1/8 Sq. x .55 Lg.
*189	78-8014-1689-8	Sleeve
248	78-8015-6434-1	Spacer - Drive Roller
*251	78-8015-6437-4	End Plate - Right Side
*252	78-8015-6438-2	End Plate - Left Side
*260	78-8015-6451-5	Shaft - Belt Centering
*263	78-8015-6454-9	Bar Belt Centering Shaft Support
*264	78-8015-6455-6	Support - Bed
*265	78-8015-6456-4	Shaft - Linear Bearing
*272	78-8015-6467-1	Post - Support, Right Drive Belt
*276	78-8015-6473-9	Post - Support, Left Drive Belt
*280	78-8015-6483-8	Post - Support, Right Drive Belt
*281	78-8015-6484-6	Post - Support, Left Drive Belt
*283	78-8015-6489-5	Shaft - Roller Drive
300	78-8015-6590-1	Coupling - Overstuffed Box Assy.
312	78-8015-6614-8	Motor - Gear (For Serial Nos. 1003 - 1100)
312	78-8015-7166-8	Motor Gear (For Serial Nos. 1101 & Above)
*325	78-8032-1531-4	Collar - One Piece Split Maxwell 16 L
329	70-8032-3921-5	Link - Connecting For #40LL Chain
332	78-8032-4119-5	Ring - Retaining - Heim No. OS-16
337	78-8032-4320-9	Bearing - Linear, Heim No. CLBB 1000 PP
*338	78-8032-4321-7	Bearing - Flange "OILITE" #FF-1207-7
340	78-8032-4408-2	Bolt - Jig Latch American No. ADB32855
343	78-8032-4873-7	Chain - Roller No. 40LL, Self Lub 55 Pitches
*345	78-8161-3111-0	Bearing - Flange "OILITE" #FF-1213-1
*355	78-8032-6223-3	Chain - Roller No. 40LL, 53 Pitches
356	78-8015-6623-9	Shaft - Belt Centering, Left Side
*358	26-1000-4482-0	Coupling - T.B. Woods "SUREFLEX" No. 4J x 1 Inch Bore
359	26-1000-4484-6	Sleeve - Coupling, T.B. Woods "SUREFLEX" No. 4JE

NOTE - Parts identified by (\*) are available, but not a normal replacement stock item.

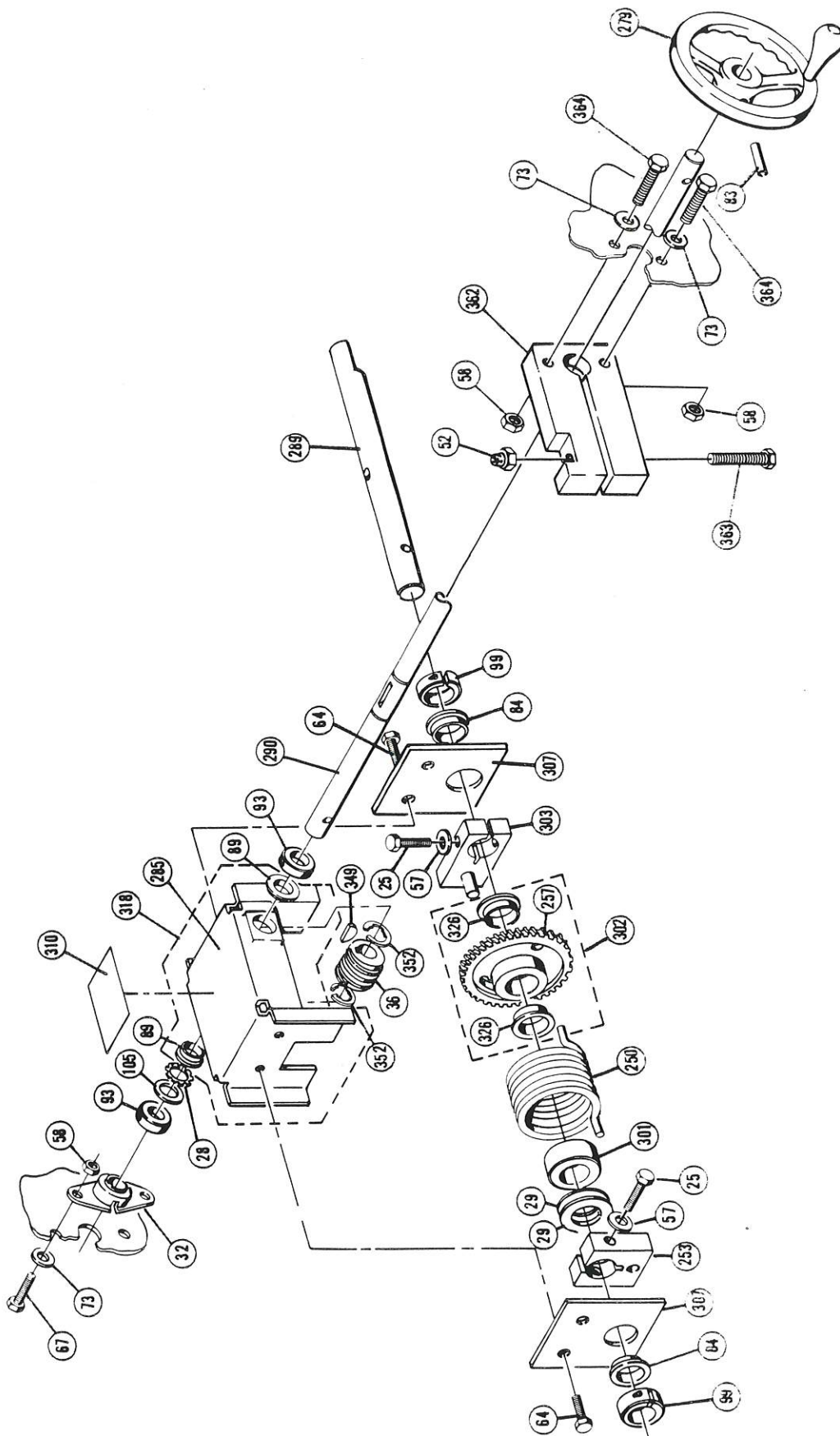


FIGURE 18 - BOX WIDTH DRIVE ASSEMBLY

Refer to page 30 for box width drive assembly parts list.

REPLACEMENT PARTS LIST  
5A BOX SEALER, MODEL 276  
FIGURE 18 BOX WIDTH DRIVE ASSEMBLY

<u>REF.NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
* 25	26-1000-3958-0	Screw-Cap, Hex Hd. 1/4-20 x 1 1/2 L "LOC-WEL"
* 28	26-1000-3969-7	Washer - Spring Finger ASC #F-1164-009
* 29	26-1000-3971-3	Washer - Shim 1.00 OD x .750 ID .015 Thk.
* 36	26-1000-3988-7	Worm - Unhardened Browning #W12A-4
* 52	70-8000-4188-4	Nut - Light Hex, Full Ht. 1/4-20 UNC "FLEXLOC" #23-FA-420
* 57	70-8000-4795-6	Washer - Plain Type A, 1/4 Narrow
* 58	70-8000-4803-8	Nut - Lt. Hex, Full Ht. 5/16-18 SPS #23FAF-516
* 64	70-8000-5354-1	Screw-Cap, Hex Hd. 1/4-20 UNC x 1/2 L. "LOC-WEL"
* 73	70-8000-5390-5	Washer - Plain, Type A, 5/16 Wide
* 83	78-8002-4838-3	Pin - Spring, Slot, 3/16 Dia. x 1 3/4 L.
* 84	78-8002-4894-6	Bearing "NYLINER" #12L2-FF Type 7
* 89	78-8003-7899-0	Bearing - Flange "OILITE" #FF-718-1
* 93	78-8003-8429-5	Collar - Maxwell 10L
* 99	78-8005-4726-3	Collar - Maxwell 12L
*105	78-8005-8493-6	Bearing - Thrust "OILITE" #TT-1508 1
*250	78-8015-6436-6	Spring - Overstuffed Bar
*253	78-8015-6440-8	Bar - Spring Retaining
*257	78-8015-6447-3	Gear - Worm
*279	78-8015-6481-2	Handle - Adjusting
*285	78-8015-6499-4	Frame
*289	78-8015-6539-7	Shaft - Output
*290	78-8015-6541-3	Shaft - Input
*301	78-8015-6591-8	Spacer - Spring
*302	78-8015-6594-2	Worm Gear Assy.
*303	78-8015-6596-7	Dowel Pin Bar Assy.
*307	78-8015-6609-8	Bracket - Bearing
*310	78-8015-6612-2	Label - Caution
*318	78-8015-6630-4	Frame Assy.
*326	78-8032-3550-2	Bearing - Flange "OILITE" #FF-1011-2
*349	78-8653-0116-8	Key - Woodruff #5 ANSI #405
*352	78-8656-4022-7	Ring Retaining "TRUARC" #5133-62
*362	78-8015-7124-7	Brake - Belts Side
*363	26-1000-8532-8	Screw - Cap, Hex Hd. 1/4-20 x 2 1/2 L.
*364	70-8000-5389-7	Screw - Cap, Hex Hd. 5/16-18 x 1 1/2 L.

NOTE - Parts identified by (\*) are available, but not a normal replacement stock item.

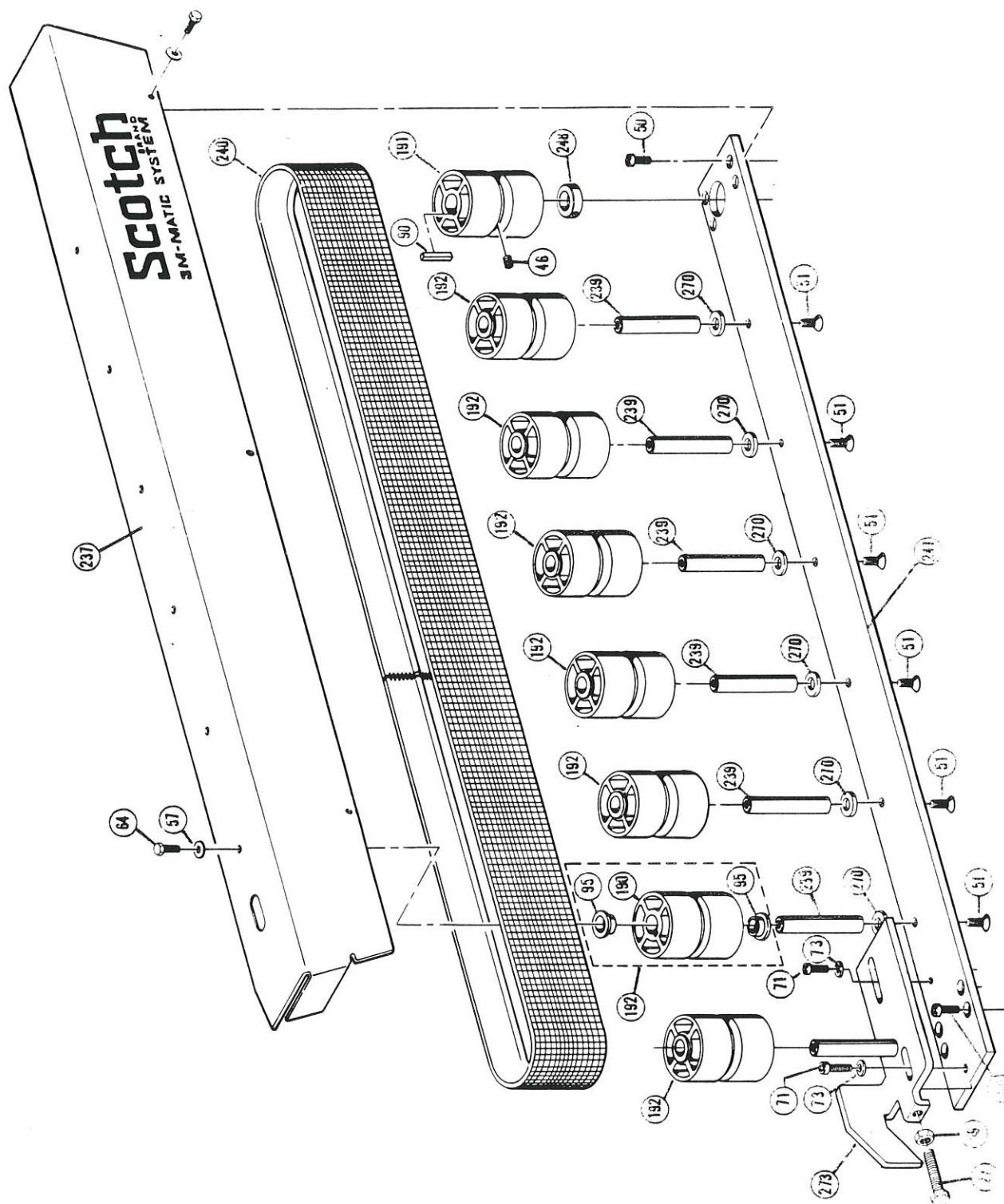


FIGURE 19 - RIGHT SIDE BELT DRIVE ASSEMBLY  
Refer to page 33 for right side belt drive assembly parts list.

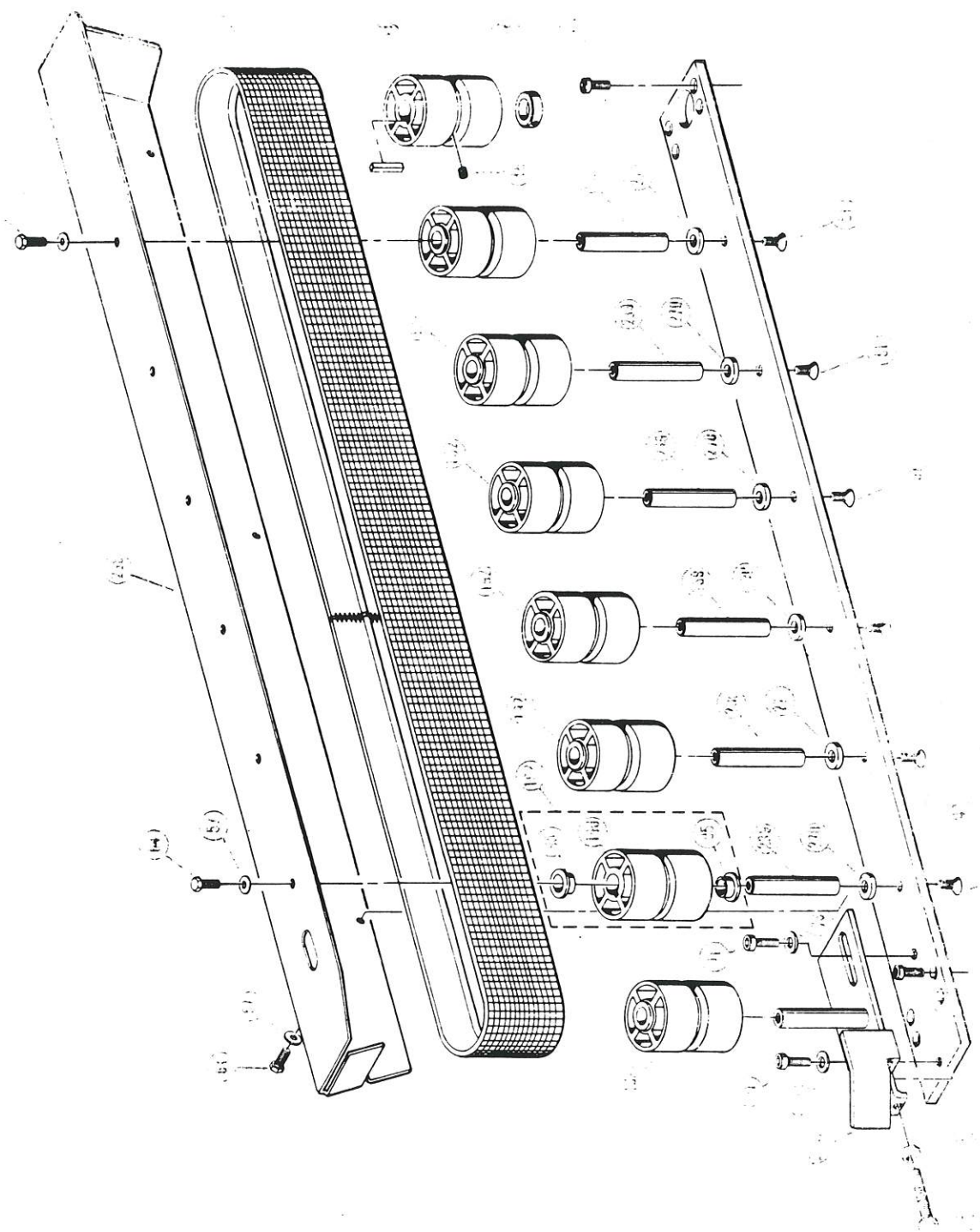


FIGURE 20 - LEFT SIDE BELT DRIVE ASSEMBLY  
 Refer to page 33 for left side belt drive assembly parts list.

REPLACEMENT PARTS LIST  
5A BOX SEALER, MODEL 276  
FIGURES 19 & 20 RIGHT AND LEFT SIDE BELT DRIVE ASSY.

<u>REF.NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
* 27	26-1000-3960-6	Screw - Set Sq. Hd. Cup Pt. 5/16-18 UNC x 2 1/2 Lg.
* 46	70-7024-0020-4	Screw-Set, Hex Soc Dr. Cup Pt. 1/4-20 UNC x 1/2 Lg. "LOC-WEL"
* 50	70-8000-2641-4	Screw-Cap, Soc. Hd. Hex Soc Dr. 1/4-20 UNC x 5/8 L. "LOC-WEL"
* 51	70-8000-2825-3	Screw-Cap Flat Hd., Hex Soc Dr. 3/8-16 x 1 1/2 Lg. "LOC-WEL"
* 57	70-8000-4795-6	Washer - Plain, Type A, 1/4 Narrow
* 59	70-8000-4828-5	Nut - Hex Jam, 5/16-18 Finished
* 64	70-8000-5354-1	Screw-Cap, Hex Hd. 1/4-20 UNC x 1/2 L. "LOC-WEL"
* 71	70-8000-5382-2	Screw-Cap, Hex Hd. 5/16-18 x 3/4 Lg. "LOC-WEL"
* 73	70-8000-5390-5	Washer - Plain, Type A 5/16 Wide
* 90	78-8003-8225-7	Key - Stl, 1/4 Sq. x 1 Lg.
* 95	78-8003-8769-4	Bearing - Flange "OILITE" #FF-1015-1
*190	78-8014-1696-3	Roller - Idler
*191	78-8014-1697-1	Roller - Drive
*192	78-8014-1698-9	Idler Roller Assy.
*237	78-8015-6403-6	Cover - Right Belt
*238	78-8015-6404-4	Cover - Left Belt
*239	78-8015-6417-6	Shaft - Idler Roller
240	78-8015-6419-2	Belt - Drive
*241	78-8015-6424-2	Bar - Idler Roller Support Right
*242	78-8015-6425-9	Bar - Idler Roller Support Left
*248	78-8015-6434-1	Spacer - Drive Roller
*270	78-8015-6465-5	Spacer - Idler Shaft
*273	78-8015-6470-5	Tensioner - Right Drive Belt
*274	78-8015-6471-3	Tensioner - Left Drive Belt

NOTE - Parts identified by (\*) are available, but not a normal replacement stock item.

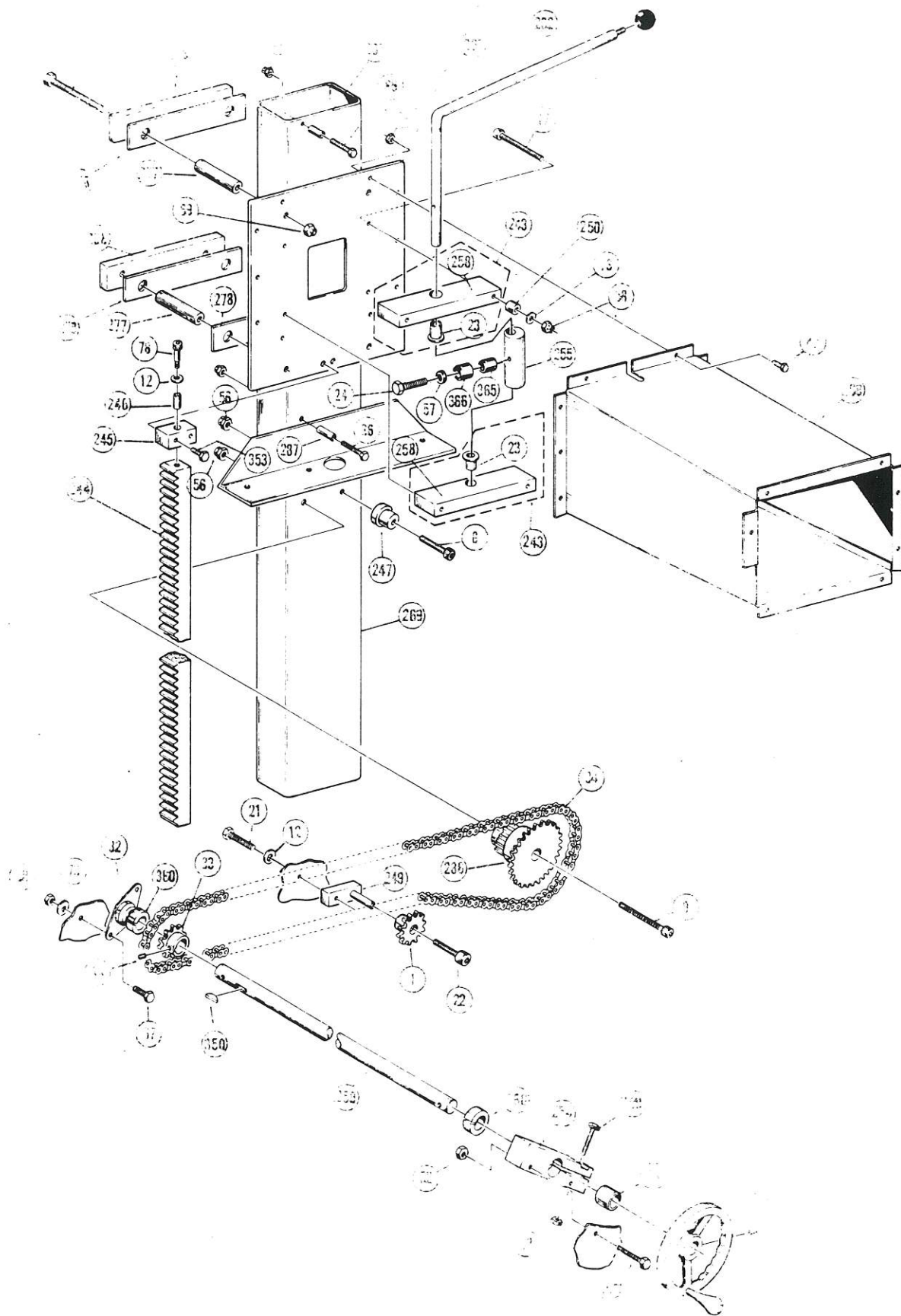


FIGURE 21 - MAST ASSEMBLY AND BOX HEIGHT DRIVE ASSEMBLY

Refer to page 35 & 36 for Mast Assembly and Box Height Drive Assembly Parts List.

REPLACEMENT PARTS LIST  
5A BOX SEALER MODEL 276  
FIGURE 21 - MAST ASSEMBLY AND BOX HEIGHT DRIVE ASSEMBLY

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
* 1	12-7994-4965-2	Sprocket Idler, Universal Drive Tensioner #35B13U
* 8	18-3825-8215-5	Screw-Shoulder, Hex Soc Dr, 1/2 Dia. x 1 1/2 Lg.
* 9	18-3825-9215-4	Screw-Shoulder, Hex Soc Dr, 1/2 Dia. x 2 1/2 Lg.
*12	26-0000-0203-5	Washer - Plain, Type A 3/8 Wide
*21	26-1000-1059-9	Screw-Cap, Hex Hd. 3/8-16 UNC x 3/4 L."LOC-WEL"
*22	26-1000-2429-3	Screw-Shoulder, Hex Soc Dr, 1/2 Dia. x 1 Lg. SPS "LOC-WEL"
*23	26-1000-3888-9	Bearing - Flange, "OILITE" #FF-718-3
*24	70-8000-1165-5	Screw-Cap, Soc Hd. 1/4-20 x 2 3/4 L."LOC-WEL"
*26	26-1000-3959-8	Screw-Cap Hex Hd. 1/2-13 UNC x 4 1/2 L.
*31	26-1000-3982-0	Knob-Plastic Ball, Mach. Tool Supply Inc. #8198
*32	26-1000-3983-8	Bearing - Side Flange Mtg. Triangle Bearings #FLB10
*33	26-1000-3985-3	Sprocket - S Strand Browning #3512
34	26-1000-3986-1	Clutch and Bearing Assy. Torrington No. RCB-1014-16
*43	70-8000-5357-4	Screw - Cap Hex Hd. 1/4-20 x 1 Lg.
*44	70-7023-6850-0	Screw - Set Hex Soc Dr. Cup Pt. 1/4-20 UNC x 1/4 L. "LOC-WEL"
*47	70-8000-0880-0	Screw - Cap, Flat Hd, Hex Soc. Dr, 5/16-18 UNC x 3 1/2 L.
*52	70-8000-4188-4	Nut - Light Hex, Full Ht. 1/4-20 UNC "FLEXLOC" #23-FA-420
*56	70-8000-4794-9	Nut - Lt Hex, Full Ht. 3/8-16 SPS #23FAF-616
*57	70-8000-4795-6	Washer - Plain, Type A, 1/4 Narrow
*58	70-8000-4803-8	Nut-Light Duty Hex, Zinc Pl., 5/16-18 UNC, "FLEXLOC" #23-FAF-518
*66	70-8000-5359-0	Screw - Cap, Hex Hd. 1/4-20 UNC x 1 1/2 L.
*67	70-8000-5361-6	Screw - Cap, Hex Hd. 5/16 x 3/4 L.
*69	70-8000-5369-9	Nut - Lt. Hex, Full Ht. 1/2-13 SPS #23FAF-813
*73	70-8000-5390-5	Washer - Plain Type A, 5/16 Wide
*78	70-8656-9704-2	Screw-Shoulder, Hex Soc Dr, 3/8 Dia. x 1 Lg. "LOC-WEL"
94	78-8003-8678-7	Chain #35 109 Pitches W/1 Connecting Link
*109	78-8005-9150-1	Screw-Cap, Hex Hd. 1/4-20 x 1 3/4 Lg.
*243	78-8015-6426-7	Support - Clamping Arm, Assy.
*244	78-8015-6427-5	Rack - Mast
*245	78-8015-6430-9	Block - Rack Mounting
*246	78-8015-6431-7	Cushion - Mayon
*247	78-8015-6432-5	Roller - Guide
*249	78-8015-6435-8	Bar-Idler

NOTE - Parts identified by (\*) are available, but not a normal replacement stock item.

REPLACEMENT PARTS LIST  
5A BOX SEALER MODEL 276  
FIGURE 21 - MAST ASSEMBLY AND BOX HEIGHT DRIVE ASSEMBLY

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
*254	78-8015-6442-4	Block - Brake
*255	78-8015-6445-7	Cam - Locking
*256	78-8015-6446-5	Bar - Clamping
*258	78-8015-6449-9	Support - Clamping Arm
*259	78-8015-6450-7	Shaft - Head Raising
*261	78-8015-6452-3	Plate - Head Mounting
*262	78-8015-6453-1	Arm - Clamping
268	78-8015-6463-0	Mount - Upper Taping Head
*269	78-8015-6464-8	Mast
*277	78-8015-6479-6	Post - Spacer
278	78-8015-6480-4	Bearing - Mast Slide
*279	78-8015-6481-2	Handle - Adjusting
*286	78-8015-6527-2	Rack Support Assy.
*287	78-8015-6535-5	Spacer - Stop
*350	78-8653-0122-6	Key Woodruff #9 ANSI 606
*353	83-9262-0204-1	Screw - Cap, Flat Hd. HEx Soc Dr. Cd. Pl. 1/4-20 UNC x 3/4 L.
*360	78-8121-4707-8	Collar - One Piece, S. S. Locking Boston #SC62
*365	78-8015-6953-0	Sleeve - Bumper
*366	78-8015-6952-2	Bumper
*367	78-8015-6536-3	Spring - Head Clamp

NOTE - Parts identified by (\*) are available, but not a normal replacement stock item.

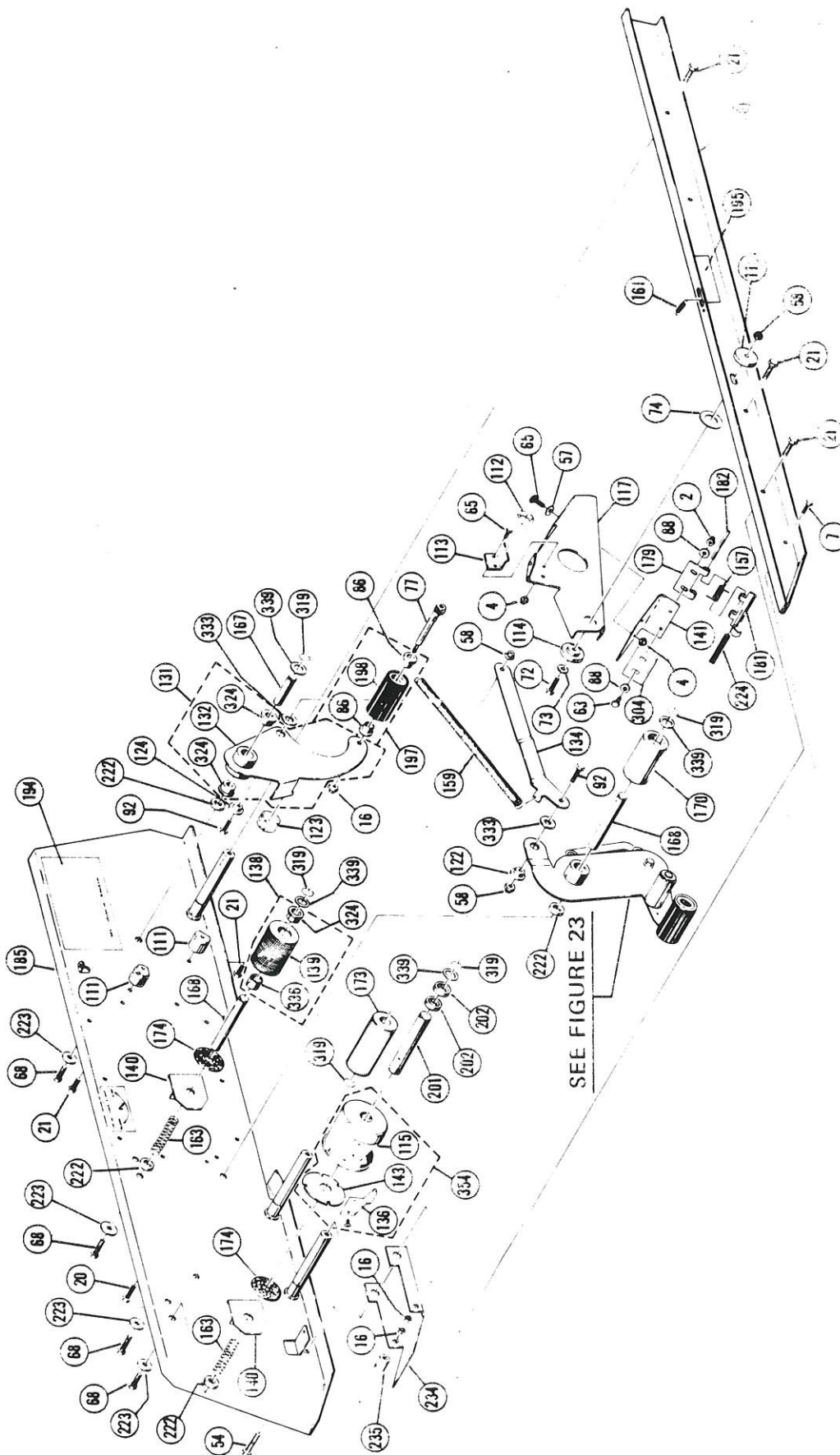


FIGURE 22 - UPPER TAPING HEAD ASSEMBLY

Refer to pages 41-44 for Upper Taping Head Assembly parts list.

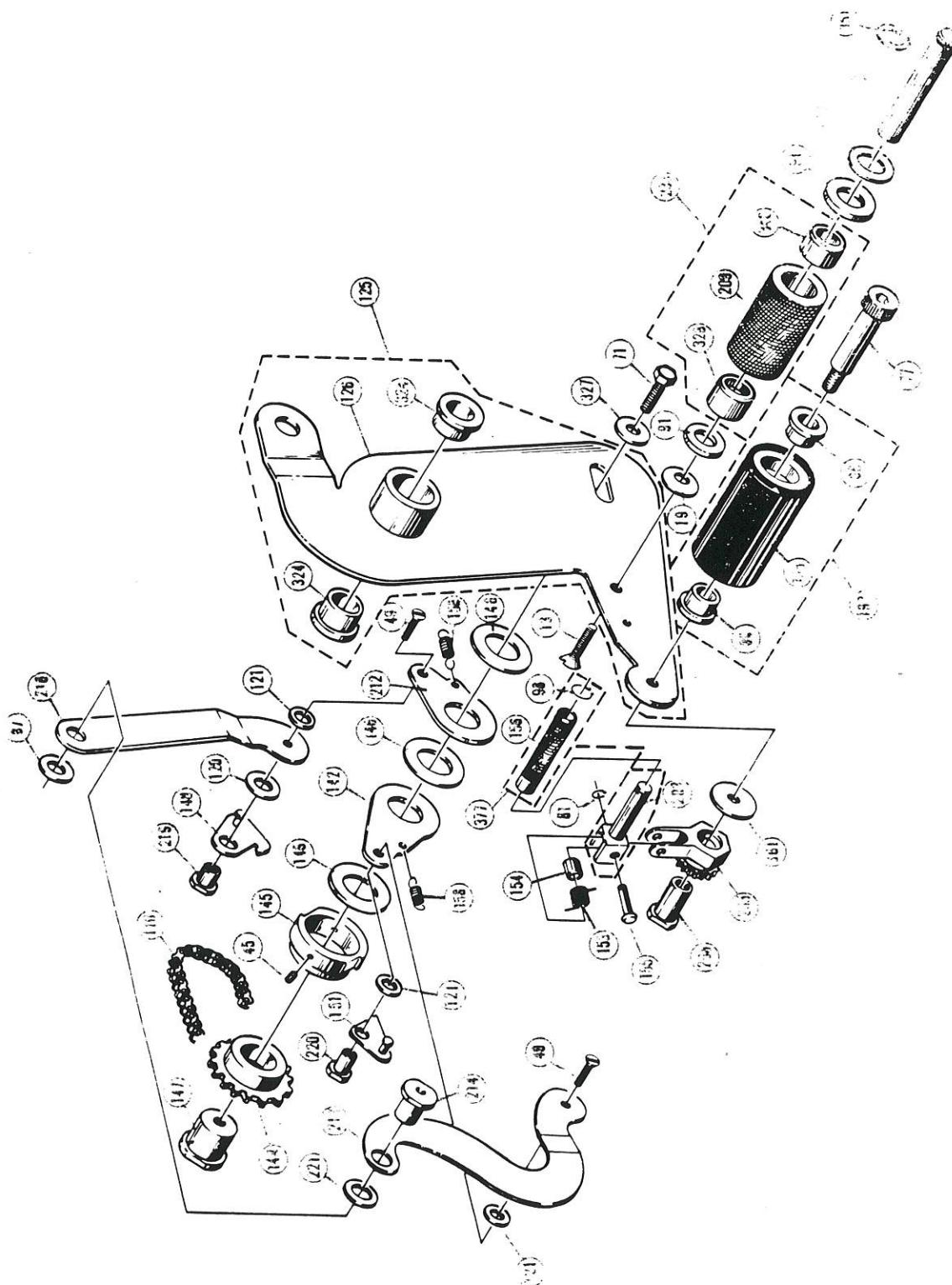


FIGURE 23 - APPLYING ARM ASSEMBLY - UPPER TAPING HEAD  
Refer to pages 43-44 for Applying Arm Assembly Parts List.

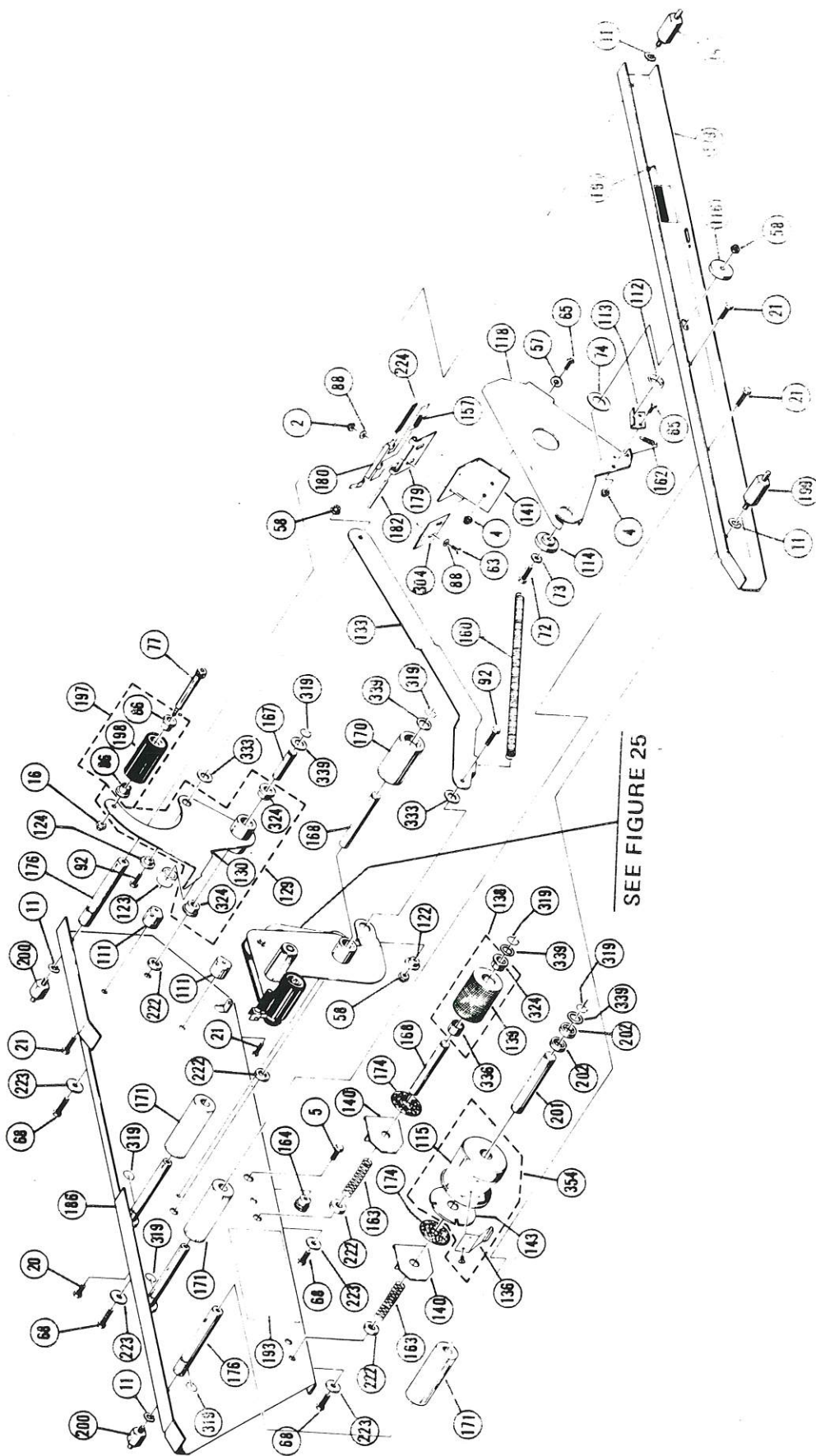


FIGURE 24 - LOWER TAPING HEAD ASSEMBLY  
Refer to pages 41-44 for Lower Taping Head Assembly Parts List.

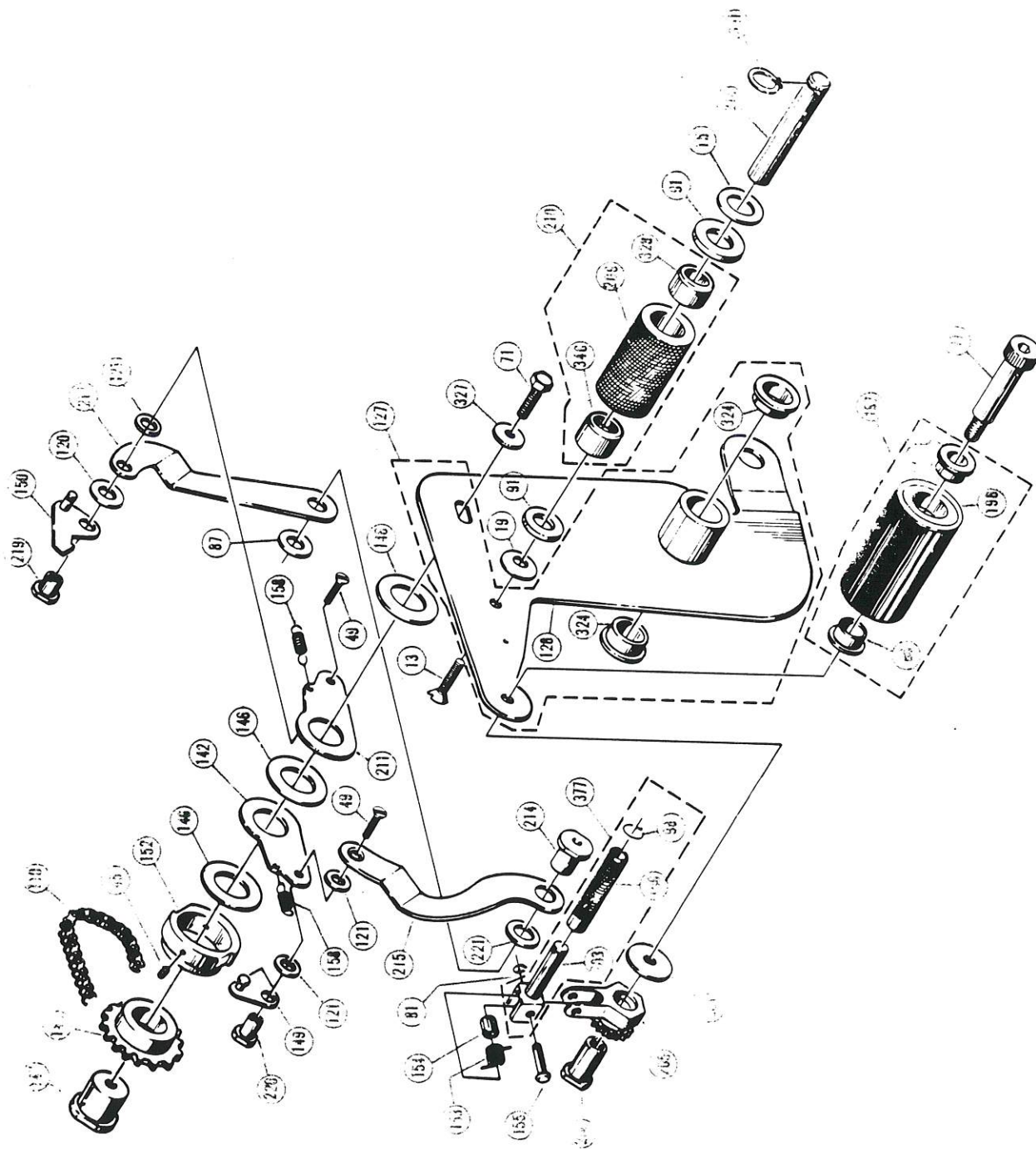


FIGURE 25 - APPLYING ARM ASSEMBLY - LOWER TAPING HEAD  
Refer to pages 43-44 for Applying Arm Assembly Parts List.

REPLACEMENT PARTS LIST  
5A BOX SEALER, MODEL 276  
FIGURES 22 & 24 UPPER & LOWER TAPING HEAD ASSEMBLIES

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
2	12-7994-9327-0	Nut-Light Hex, Cd. Pl, 10-32 UNF "FLEXLOC" #23-FK-1032
4	12-7995-8662-8	Nut-Hvy Duty Hex, Cad. Pl, 1/4-20 UNC "FLEXLOC"
* 5	12-7996-8746-7	Screw, Cap, Hex Hd., C/Stl, Zinc Pl. 5/8-11 UNC x 1 Lg.
7	18-3155-7003-8	Screw-Cap Hex Hd. 3/8-16 x 3/4 Lg.
* 11	18-9832-2403-3	Washer Lock Hel. Spg., C/Stl, Cd. Pl., Med Ser 3/8
16	26-1000-0668-8	Nut-Heavy Duty Hex, Zinc Pl, 3/8-16 UNC, "FLEXLOC" #23-FK-616
* 20	26-1000-1058-1	Screw-Cap, HEX Hd. Zinc Pl, 5/16-18 UNC x 1/2 Lg. SPS "LOC-WEL"
* 21	26-1000-1059-9	Screw-Cap, Hex Hd. Zinc Pl., 3/8-16 UNC x 3/4 Lg. SPS "LOC-WEL"
* 57	70-8000-4795-6	Washer - Plain, 1/4 Narrow, Zinc Plate
58	70-8000-4803-8	Nut-Light Duty Hex, Zinc Pl., 5/16-18 UNC, "FLEXLOC" #23-FAF-518
* 63	70-8000-5353-3	Screw-Mach. Hex Hd. Trmd, Zinc Plate, 10-32 UNF x 5/8 Lg.
* 65	70-8000-5355-8	Screw-Cap, Hex Hd. Zinc Pl., 1/4-20 UNC x 5/8 Lg.
* 68	70-8000-5362-4	Screw-Cap, Hex Hd. Zinc Pl., 3/8-16 UNC x 1 Lg. SPS "LOC-WEL"
* 72	70-8000-5383-0	Screw-Cap, Hex Hd, Zinc Pl., 5/16-18 UNC x 1 1/4 Lg.
* 73	70-8000-5390-5	Washer-Plain, Zinc Pl., 5/16 Narrow
* 74	70-8160-7525-6	Bearing Thrust "OILITE" #TT-1503-2
77	70-8656-9696-0	Screw-Shoulder, Hex Soc, Blk. Ox. 1/2 Dia. x 2 Lg. SPS "LOC-WEL"
* 86	78-8003-7739-8	Bearing, Flange, "OILITE" #FF-620
* 88	78-8003-7829-7	Washer - Plain, No. 10 Cad. Pl.
* 92	78-8003-8377-6	Screw-Cap, Hex Hd., Zinc Pl., 5/16-18 UNC x 1 Lg.
* 111	78-8014-0974-5	Stop - Buffing Arm Eccentric
* 112	78-8014-0978-6	Bumper - Cut Off Frame Stop
* 113	78-8014-0979-4	Stop - Tape Cut Off Frame
* 114	78-8014-0992-7	Bearing - Tape Cut Off Frame Pivot
* 115	78-8011-7376-2	Drum - Tape 2 Inch
* 116	78-8014-0994-3	Washer-Pivot Bearing Clamp
117	78-8014-0995-0	Frame - Upper Head Tape Cut Off
118	78-8014-0996-8	Frame - Lower Head Tape Cut Off
122	78-8014-1010-7	Bushing - Connecting Arm
* 123	78-8014-1012-3	Bumper - Buffing Arm
124	78-8014-1013-1	Bushing - Buffing Arm Adjustment
129	78-8014-1021-4	Arm Buffing Assy., Lower Head
* 130	78-8014-1022-2	Arm-Buffing
131	78-8014-1024-8	Arm-Buffing Assy., Upper Head

NOTE - Parts identified by (\*) are available, but not a normal replacement stock item.

REPLACEMENT PARTS LIST  
5A BOX SEALER MODEL 276  
FIGURES 22 & 24 UPPER & LOWER TAPING HEAD ASSEMBLIES

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
*132	78-8014-1025-5	Arm - Buffing
*133	78-8014-1027-1	Arm Connecting, Lower Head
*134	78-8014-1028-9	Arm Connecting, Upper Head
136	78-8014-1030-5	Spring - Tape Core Engagement
138	78-8014-1032-1	Roller - Tape Brake Assembly
*139	78-8014-1033-9	Roller, Tape Brake
*140	78-8014-1036-2	Plate - Friction Brake
141	78-8014-1037-0	Bracket - Knife Blade
*143	78-8015-6384-8	Disc - Brake
157	78-8014-1220-2	Spring - Torsion
159	78-8014-1318-4	Spring-Extension Tape Buffing Upper Head
160	78-8014-1319-2	Spring - Tape Buffing, Lower Head
161	78-8014-1320-0	Spring, Extension
162	78-8014-1321-8	Spring - Cut-off Arm
163	78-8014-1323-4	Spring - Tape Drum
164	78-8014-1443-0	Nut - Brake Roller
*166	78-8014-1593-2	Rail-Upper Taping Head Box Support
167	78-8014-1594-0	Post - Buffing Arm
168	78-8014-1595-7	Post - Tape & Applying
*170	78-8014-1613-8	Roller - Tape Idler
171	78-8014-1618-7	Roller - Taping Head Box Support
173	78-8014-1620-3	Roller - Knurled Taping Head Box Support
174	78-8014-1621-1	Washer - Friction Brake
*176	78-8014-1638-5	Shaft - Taping Head Roller Box Stop Spacer
*178	78-8014-1650-0	Rail - Lower Taping Head Box Support
*179	78-8014-1654-2	Guard-Blade, Fixed Side
180	78-8014-1657-5	Guard - Blade, Moving Side
181	78-8014-1658-3	Guard - Blade, Moving Side, Upper Head
*182	78-8014-1659-1	Pin - Blade Guard
*185	78-8014-1681-5	Head - Upper Taping Post Assy.
*186	78-8014-1682-3	Head - Lower Taping Post Assy.
*193	78-8014-1709-4	Label - Tape Threading
*194	78-8014-1710-2	Label - Tape Threading
*195	78-8014-1717-7	Label - Caution
197	78-8014-1747-4	Buffing Roller Assy.
*198	78-8014-1748-2	Roller - Buffing
*199	78-8014-1750-8	Stud - Lower Taping Head Support, Rail Side
*200	78-8014-1751-6	Stud - Lower Taping Head Support, Plate Side
*201	78-8014-1754-0	Post - Tape Drum
*202	78-8014-1755-7	Spacer
*222	78-8014-1792-0	Washer - Support Thick
*223	78-8014-1793-8	Washer - Support Thin
*224	78-8014-1815-9	Pad - Blade Guard
234	78-8015-6387-1	Plate - Ramp
235	78-8015-6388-9	Spacer - Ramp
304	78-8015-6605-6	Blade
319	78-8016-5841-6	Ring-Retaining "TRUARC" #5100-75
324	78-8032-1476-2	Bearing, Flange, "OILITE" #FF838-1

NOTE - Parts identified by (\*) are available, but not a normal replacement stock item.

REPLACEMENT PARTS LIST  
5A BOX SEALER MODEL 276  
FIGURES 22 & 24 UPPER & LOWER TAPING HEAD ASSEMBLIES

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
333	78-8032-4123-7	Bearing-Thrust "OILITE" #TT-1102-1
336	78-8032-4318-3	Bearing Sleeve, "OILITE" #AA-838-16
339	78-8032-4385-2	Washer - Shim, C/St1, DE-STA-CO, .751 ID x .995 OD x .015 Thk.
*354	78-8015-7140-3	Drum-Tape Assy.

REPLACEMENT PARTS LIST  
5A BOX SEALER MODEL 276  
FIGURES 23 & 25 APPLYING ARM ASSEMBLY - UPPER & LOWER TAPING HEADS.

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
*13	26-1000-0159-8	Screw, Flat Hd. Hex Soc. 5/16-18 UNC x 3/4 Blk. Ox. "LOC-WEL"
*15	26-1000-0664-7	Washer - Shim, 1/2 ID x 3/4 OD x .015 Thk. DE-STA-CO
*19	26-1000-1055-7	Washer-Spring, Associated Spring #U500-0140
*45	70-7024-0010-5	Screw-Set, Hex Soc. Cup Pt. Blk. Ox., 10-32 UNF x 3/16 Lg. SPS "LOC-WEL"
*49	70-8000-1289-3	Screw-Flat Hd. Hex Soc. 6-32 UNC x 1/2 Lg. Blk. Ox. SPS "LOC-WEL"
*71	70-8000-5382-2	Screw-Cap, Hex Hd, 5/16-18 UNC x 3/4 Lg. Zinc Pl. SPS "LOC-WEL"
*77	70-8656-9696-0	Screw, Hex Soc. Shoulder, 1/2 Dia. x 2 Lg. SPS "LOC-WEL"
*81	78-8000-5935-0	Ring - Retaining "TRUARC" No. 5144-18
*86	78-8003-7739-8	Bearing, Flange, "OILITE" #FF-620
*87	78-8163-0107-7	Bearing - Thrust "OILITE" #TT-706
*91	78-8003-8257-0	Bearing - Thrust "OILITE" #TT-1001
*98	78-8005-4399-9	Ring - Retaining, "TRUARC" No. 5560-25
110	78-8005-9980-1	Chain - ASA #25, 1/4 Pitch, 54 Pitches L. Including One Connecting Link
120	78-8014-1004-0	Spacer - Ratchet Arm
121	78-8014-1005-7	Spacer - Ratchet Arm
125	78-8014-1014-9	Arm-Applying Bearing Assy., Upper Head
*126	78-8014-1015-6	Arm - Applying Weldment

NOTE - Parts identified by (\*) are available, but not a normal replacement stock item

REPLACEMENT PARTS LIST  
5A BOX SEALER MODEL 276  
FIGURES 23 & 25 APPLYING ARM ASSEMBLY - UPPER & LOWER TAPING HEADS

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
127	78-8014-1018-0	Arm - Applying Bearing Assembly
*128	78-8014-1019-8	Arm - Applying, Weldment
142	78-8014-1088-3	Plate - Pivot
*144	78-8014-1089-1	Sprocket - Ratchet Arm
145	78-8014-1090-9	Ring - Ratchet Upper Head
146	78-8014-1092-5	Washer - Ratchet Arm
147	78-8014-1094-1	Hub - Sprocket Ratchet Arm
148	78-8014-1096-6	Pawl - Pull Weldment Upper Head
149	78-8014-1098-2	Pawl - Push Lower Head
150	78-8014-1100-6	Pawl - Pull Lower Head
151	78-8014-1102-2	Pawl - Push Weldment Upper Head
152	78-8014-1111-3	Ring - Ratchet Lower Head
153	78-8014-1199-8	Spring - Torsion
154	78-8014-1201-2	Spacer - Spring
155	78-8014-1203-8	Pin - Pivot
156	78-8014-1205-3	Roller - Knurled
158	78-8014-1314-3	Spring - Pawl
197	78-8014-1747-4	Buffing Roller Assembly
198	78-8014-1748-2	Roller - Buffing
203	78-8015-6925-8	Shaft
205	78-8014-1765-6	Sprocket
206	78-8014-1767-2	Hub - Sprocket
*209	78-8014-1771-4	Roller - Knurled
210	78-8014-1772-2	Knurled Roller Assembly - Lower
211	78-8014-1773-0	Plate - Pivot Lower Head
212	78-8014-1774-8	Plate - Pivot Upper Head
213	78-8014-1775-5	Arm, Upper Ratchet
214	78-8014-1776-3	Bearing - Ratchet Arm
215	78-8014-1777-1	Arm - Lower Ratchet
216	78-8014-1780-5	Arm - Upper
217	78-8014-1781-3	Arm - Lower
218	78-8014-1785-4	Shaft - Roller
219	78-8014-1789-6	Bushing - Pivot Plate
220	78-8014-1790-4	Bushing - Ratchet Arm
221	78-8014-1791-2	Spacer
233	78-8015-6307-9	Knurled Roller Assembly - Upper
*324	78-8032-1476-2	Bearing - Flange "OILITE" #FF-838-1
327	78-8032-3900-9	Washer-Flat 5/16 Bolt Size Northwestern #16002
*328	78-8032-3908-2	Bearing-Plain, Boston #B812-4 1/2 ID x 3/4 OD x 1/2 L
*346	78-8161-8492-9	Bearing & Clutch-Torrington #RCB-081214
*351	78-8656-3974-0	Ring - Retaining "TRUARC" #5100-50
*361	26-8092-8215-0	Bearing - Thrust "OILITE" #TT-1002
377	78-8018-7643-0	Roller - Capture Assembly

NOTE - Parts identified by (\*) are available, but not a normal replacement stock item.

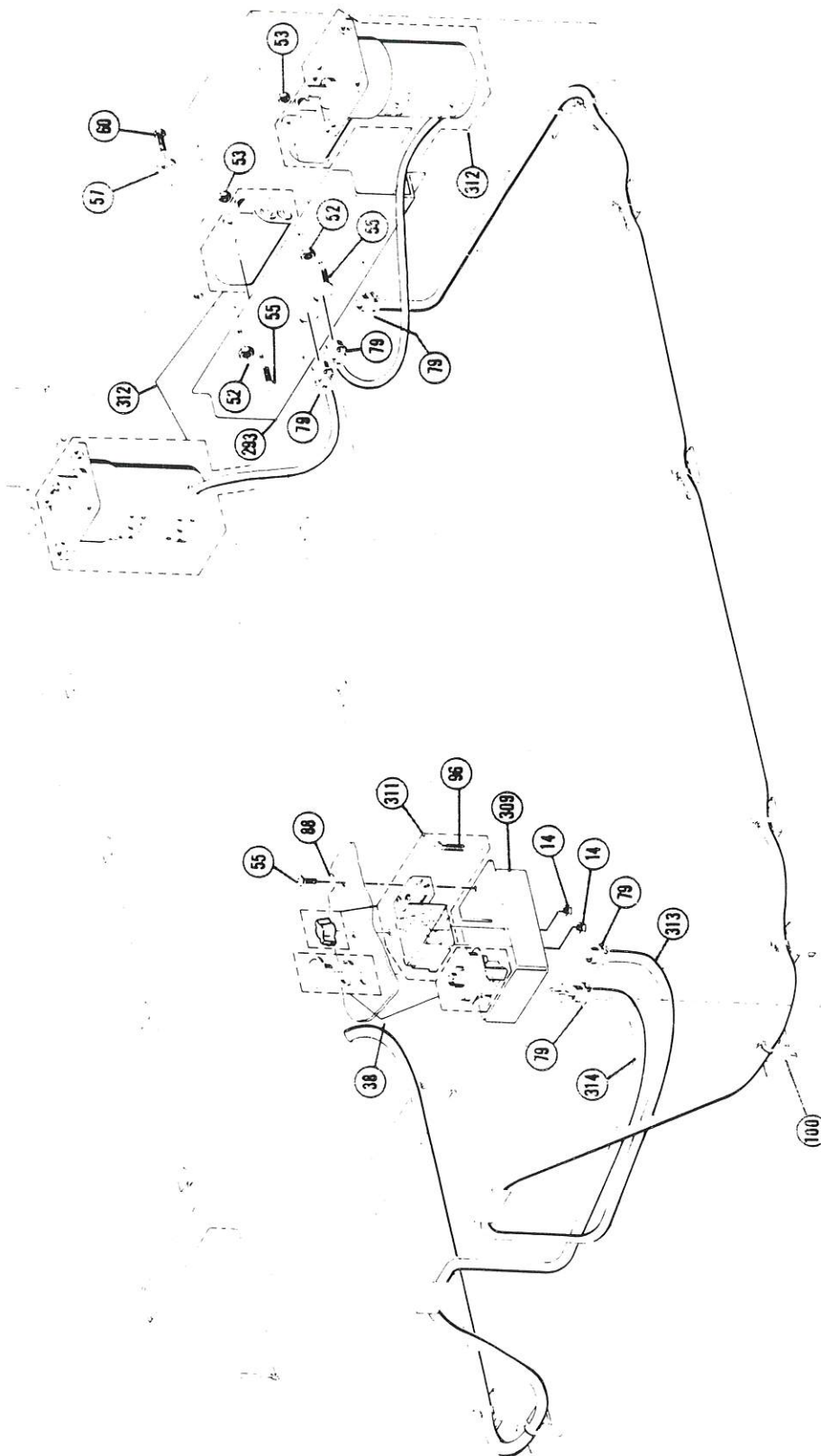


FIGURE 26 - ELECTRICAL COMPONENTS  
Refer to page 46 for electrical components parts list.

REPLACEMENT PARTS LIST  
5A BOX SEALER MODEL 276  
FIGURE 26 ELECTRICAL COMPONENTS

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
*14	26-1000-0663-9	Nut - Lt. Hex, Full Ht. 6-32
38	26-1000-3991-1	Switch-Push Button Unit
		Allen-Bradley #800T-D6D2
*52	70-8000-4188-4	Nut-Light Hex, Full Ht. 1/4-20 UNC
		"FLEXLOC" #25-FA-420
*53	70-8000-4191-8	Nut-Light Hex, Full Ht. 10-32 UNF
		"FLEXLOC" #23-FC-1032
*55	70-8000-4787-3	Screw-Mach. Hex Hd. Trmd.
		10-32 UNF x 1/2 L.
*57	70-8000-4795-6	Washer - Plain, Type A, 1/4 Narrow
*60	70-8000-5034-9	Screw-Cap Hex Hd. 1/4-20 x 3/4 L.
*79	77-8001-0349-9	Connector - T&B #3302
*88	78-8003-7829-7	Washer - Plain Type A, #10 Narrow
*96	78-8003-9792-5	Screw-Mach. Pan Hd. Slot Dr. 6-32 UNC x 1 L.
*100	78-8005-6087-8	Tie and Base Cable, "Scotchflex" 3M #790
*293	78-8015-6558-7	Bracket - Capacitor
*309	78-8015-6611-4	Box - Switch
311	78-8015-6613-0	Controller - Manual Motor
312	78-8015-6614-8	Motor - Gear
313	78-8015-6615-5	Cable Assy. - Motor to Switch Box
314	78-8015-6616-3	Cord - Electrical Power

NOTE - Parts identified by (\*) are available, but not a normal replacement stock item.

