

INSTRUCTIONS AND PARTS LIST

“SCOTCH” BRAND CAT. NO. 5A

BOX SEALER, MODEL 377

Packaging Systems Division  **3M**
COMPANY

3M CENTER • SAINT PAUL, MINNESOTA 55101

34-7004-7182-3

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This is the "SCOTCH" Brand Equipment you ordered. It has been set up and tested at the factory with "SCOTCH" Brand tapes. If any problems occur when operating this equipment, and you desire service, refer to the map on the reverse side of this sheet for the 3M Branch telephone number in your area. Call that number and ask for the Tape Sales Coordinator.

3M BRANCH OFFICES

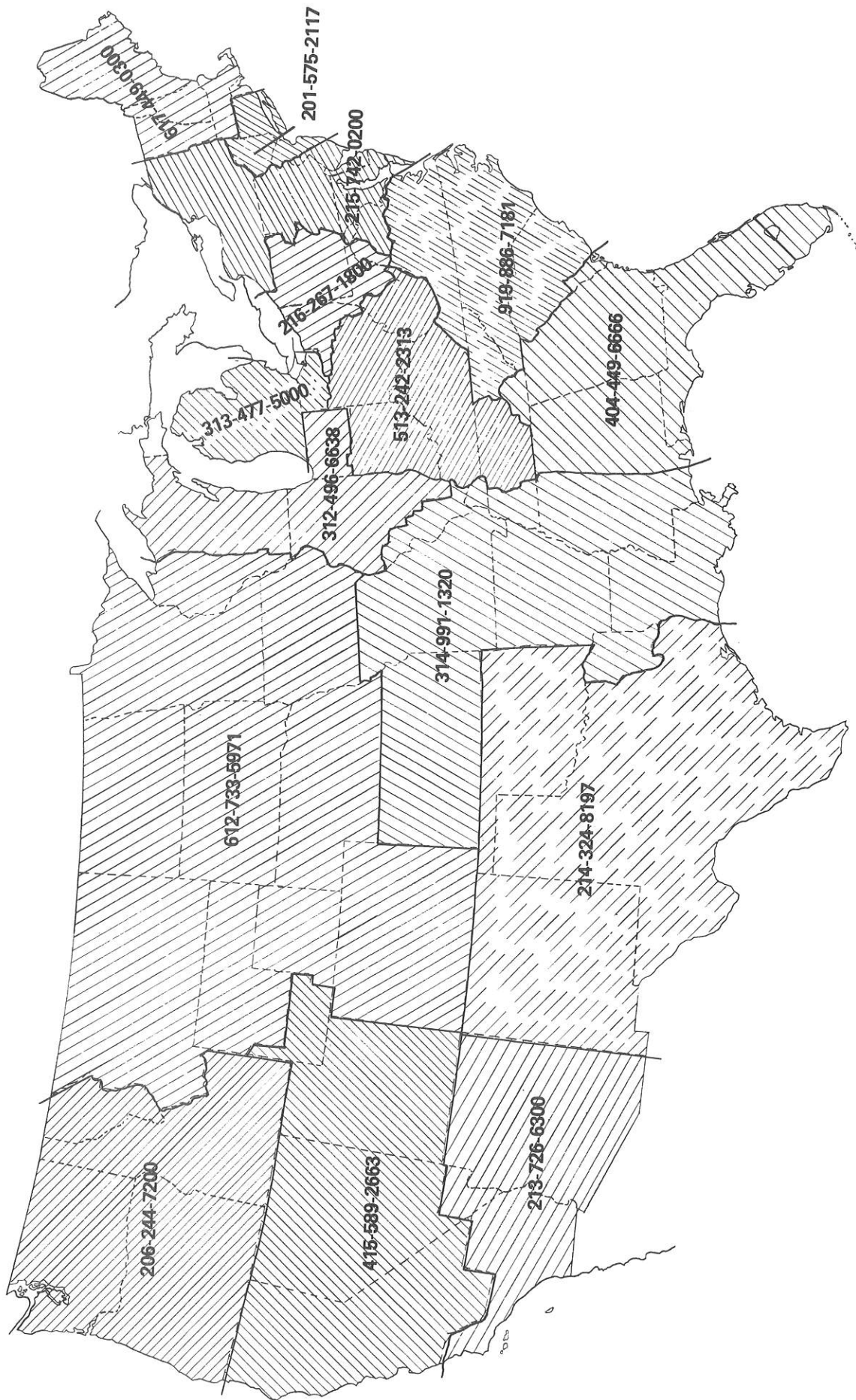
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IMPORTANT NOTICE TO PURCHASER: The following is made in lieu of all warranties, expressed or implied: The only obligation of the manufacturer and seller of "SCOTCH" Brand equipment shall be to repair or replace any mechanical part proved to be defective, 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 the 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, Minn. 55101

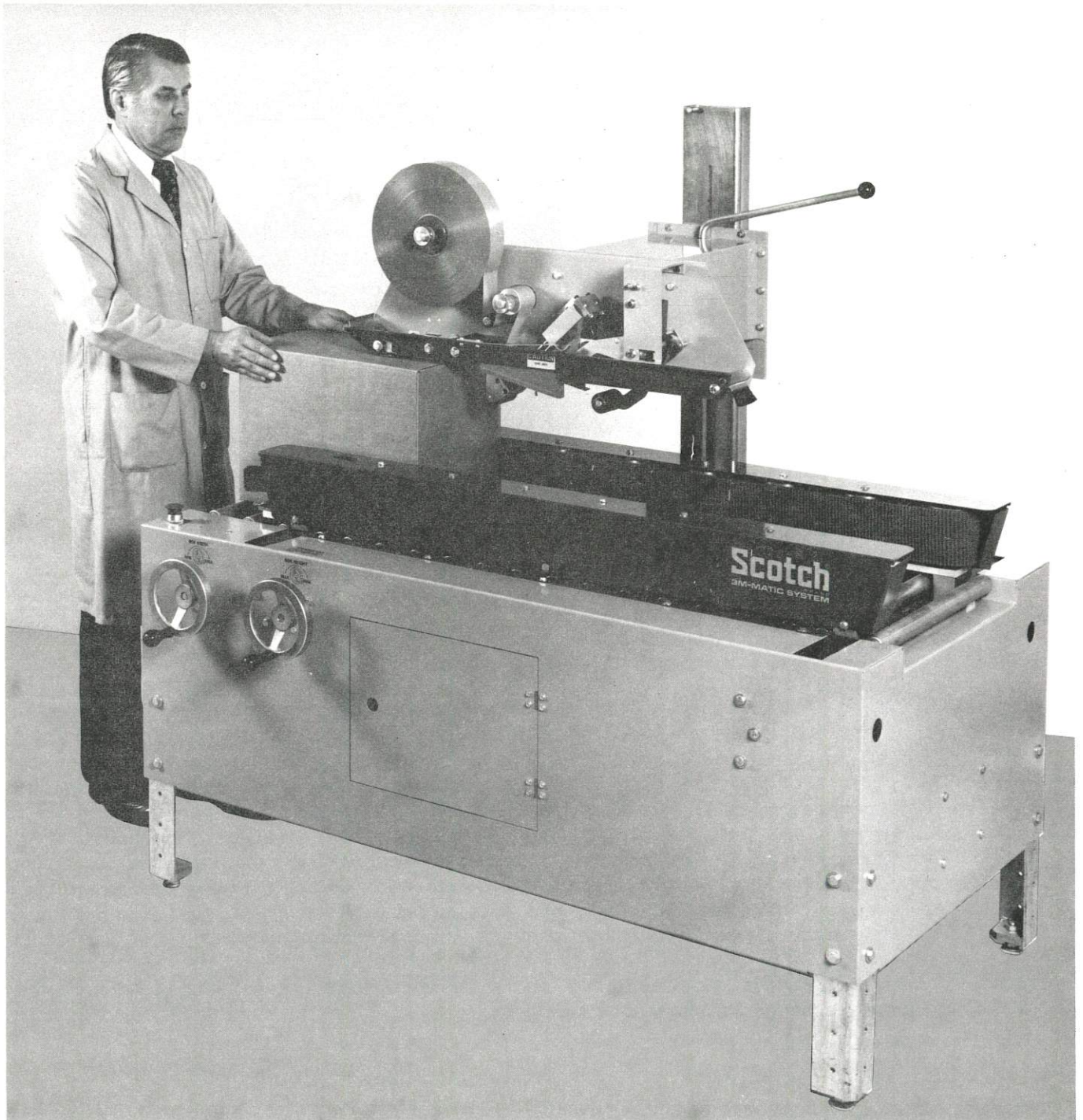
Packaging Systems Division 



INSTRUCTION MANUAL

5A MODEL 377

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CAT. NO. 5A SEALER - MODEL 377

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 the 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

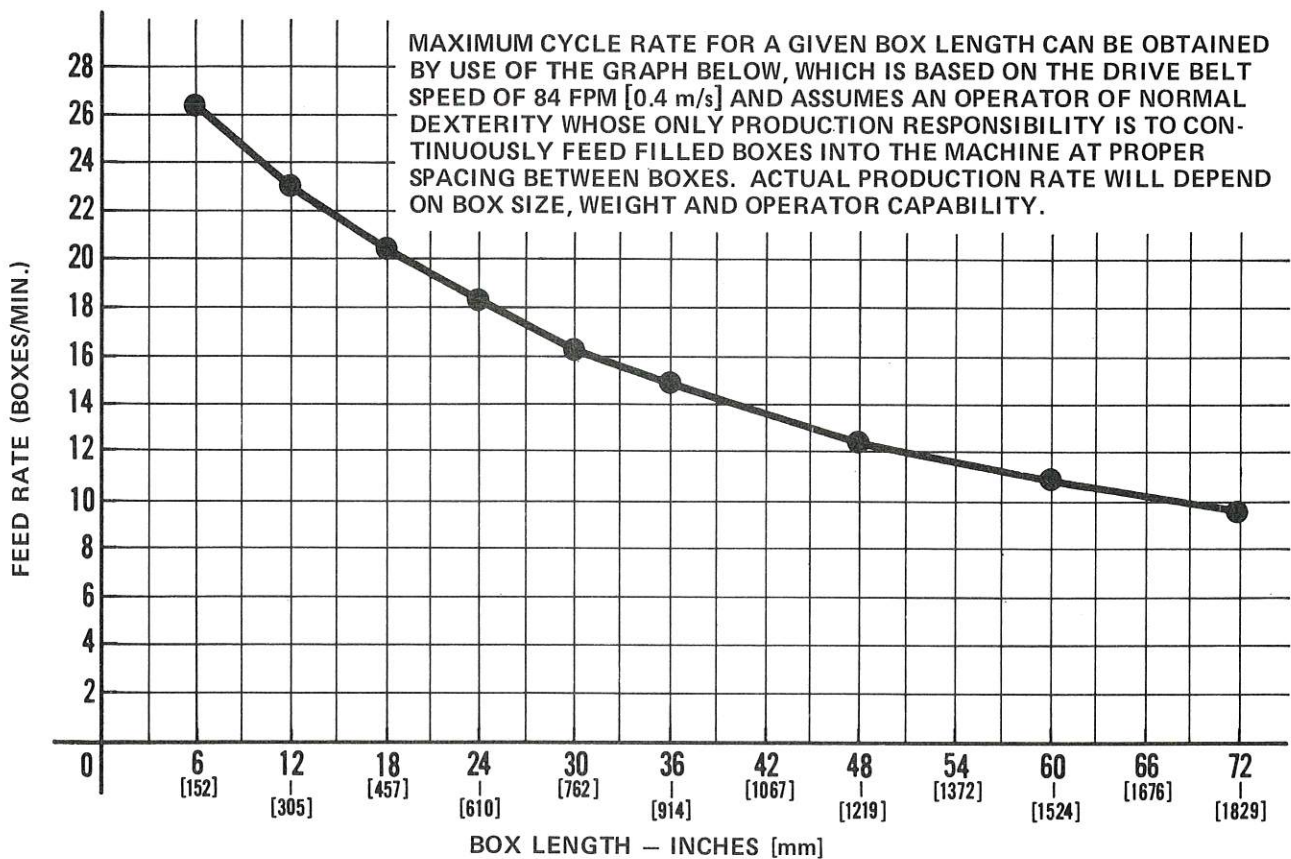
1) Power Requirements:

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.)

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:

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

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 a switch control 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) 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 knob. Install switch control box on left side and cap lug on right side.
- 6) Reposition box width shaft with box coupling and secure split collar.
- 7) 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.

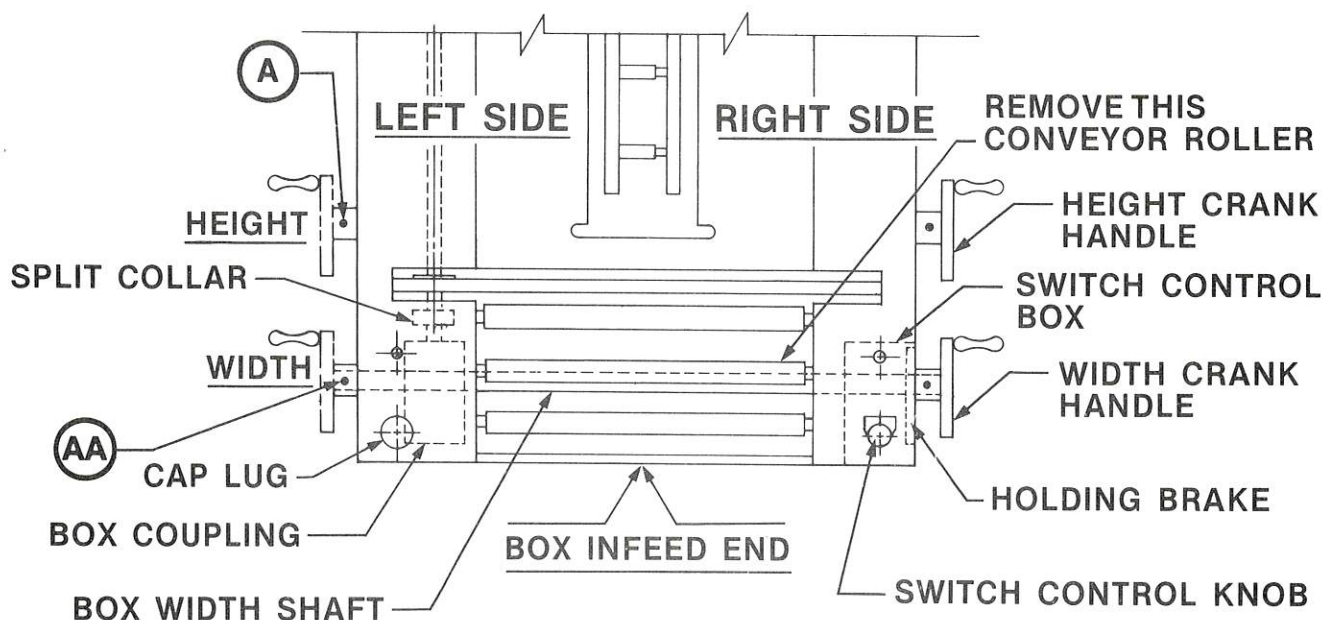


FIGURE 1 RIGHT - LEFT HAND OPERATION - TOP VIEW

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.

FOR MACHINE STABILITY - DO NOT set the leveling screws to extend farther than is necessary to level the machine. Allow a minimum of one screw thread to protrude from lock nut at maximum leveling screw adjustment.

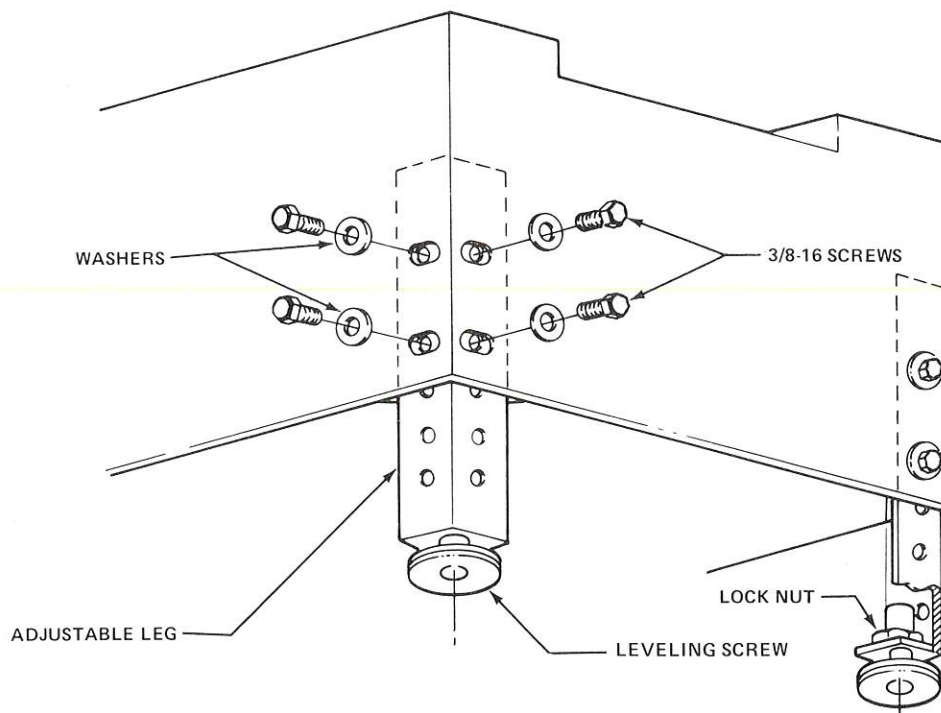


FIGURE 2 - MACHINE CONVEYOR BED HEIGHT

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, 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.

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 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 tension 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 1/2 inch [38.1 mm] beyond the vee bar in the position shown.

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

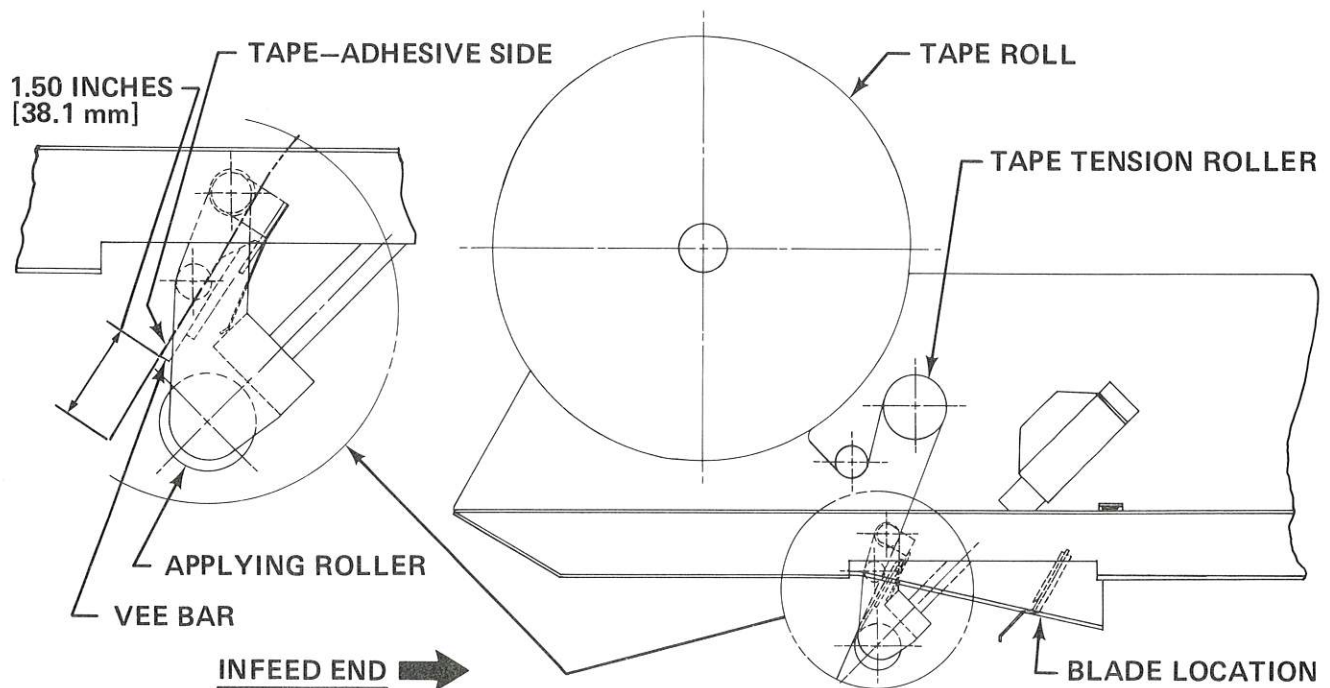


FIGURE 3 - TAPE THREADING DIAGRAM - UPPER TAPING HEAD RIGHT SIDE VIEW

SET-UP INSTRUCTIONS (CONTINUED)

Lower Taping Head - Refer to Figures 4 & 5

To load the tape roll on the lower head, raise the upper head to maximum height. Pivot the lower head up from the infeed end until the grooved stop (B Fig. 4), located behind the tape tension roller, can be hooked over the side conveyor bed as shown. Load the tape roll to dispenser the tape toward the tape tension 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 1/2 inch [38.1 mm] beyond the vee bar in the position shown.

Rotate the tape tension 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. 6) in cabinet. This will eliminate the need for resetting box height and width adjustment.

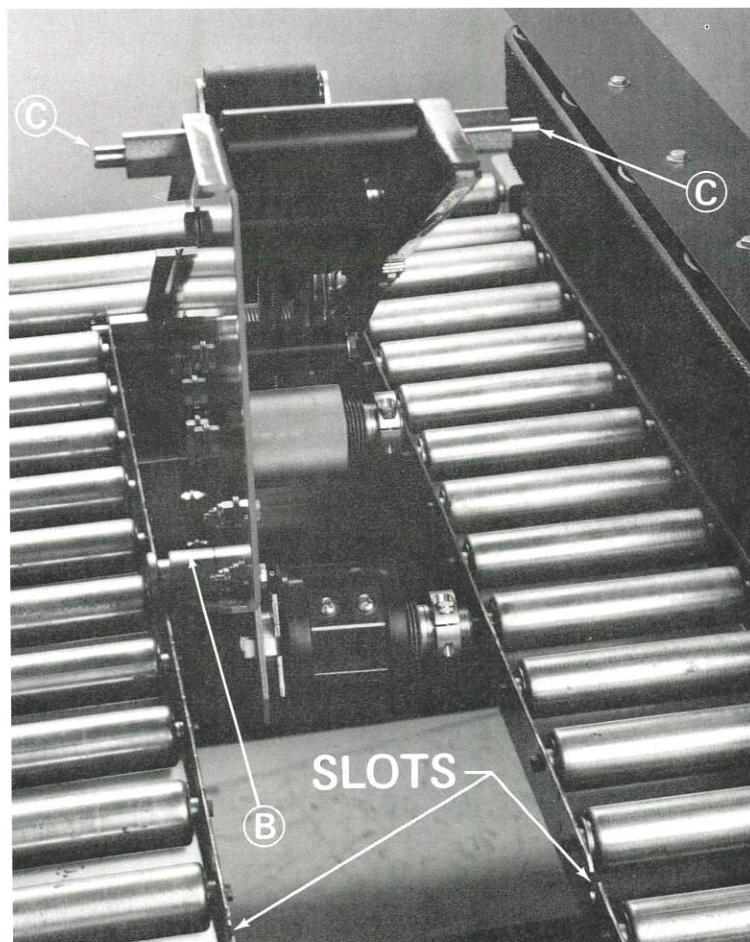


FIGURE 4 - TAPE LOADING - INFEED END VIEW

SET-UP INSTRUCTIONS (CONTINUED)

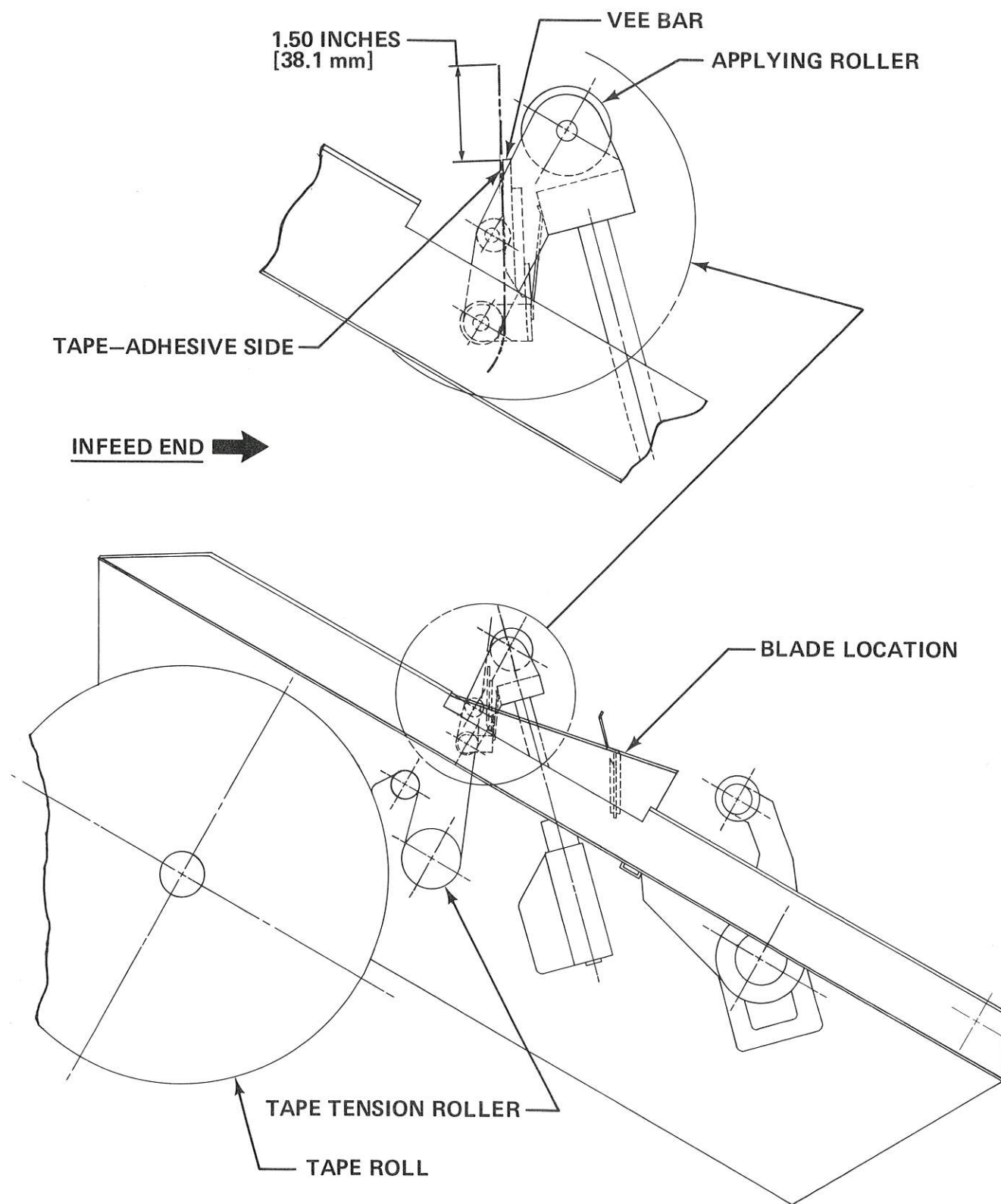


FIGURE 5 - TAPE THREADING DIAGRAM - LOWER TAPING HEAD RIGHT SIDE VIEW

SET-UP INSTRUCTIONS (CONTINUED)

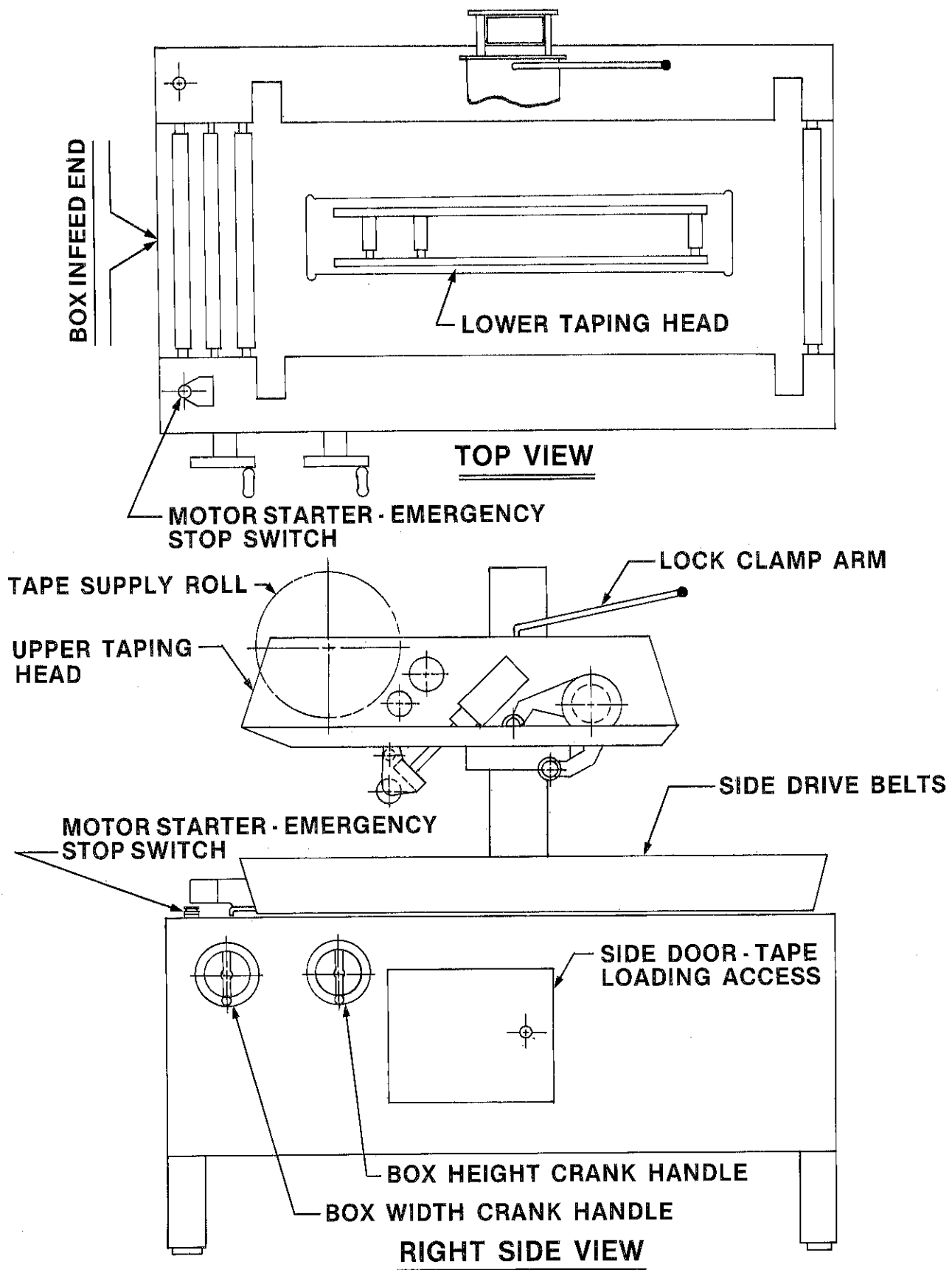


FIGURE 6 - CONTROL LOCATIONS

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 provides undervoltage protection. In addition, an "emergency stop" push button switch is provided for the operator safety. This is 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" off 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 and loosen lock clamp arm.
- 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) Pull up start button 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.

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].

ADJUSTMENTS

CAUTION: NEVER ATTEMPT TO MAKE ADJUSTMENTS WHEN THE MACHINE IS RUNNING.

DISCONNECT MAIN POWER BEFORE STARTING ADJUSTMENTS.

Tape Width Alignment - Refer to Figure 7.

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 required 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 locking collar and the spring washer.

1 3/4 Inch or 42 mm Wide Tape - Locate one SPACER between the locking collar and the spring washer and one SPACER between the friction brake plate and support washer.

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

Refer to the tape tension section and set the proper tension adjustment.

The upper and lower tension rollers require no tape alignment adjustment.

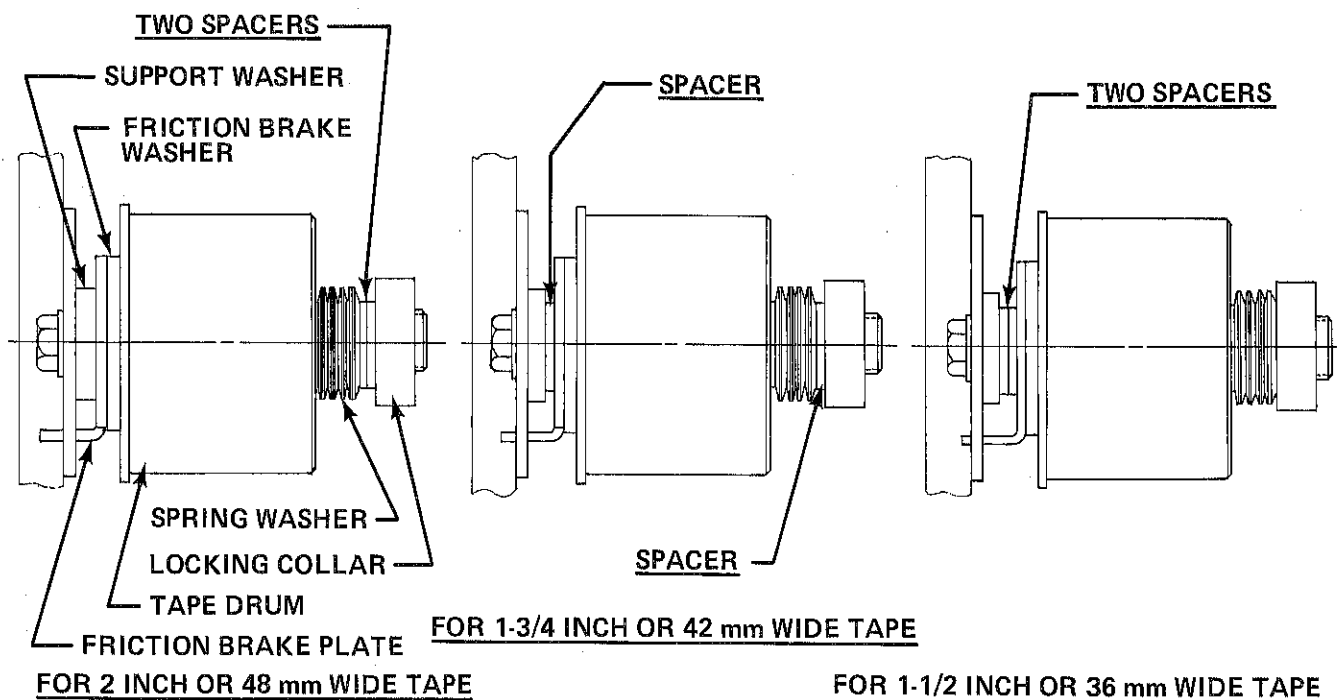


FIGURE 7 - TAPE WIDTH ALIGNMENT - TOP VIEW - UPPER HEAD

ADJUSTMENTS (CONTINUED)

Tape Tension - Refer to Figure 8

Tape tension is required for satisfactory tape applications and is controlled by the adjustment collars (E) on the tape drum assembly and tension roller assembly. However, if tape width alignment or part replacement is required, refer to Figure 8 and make the following adjustment to each assembly:

- 1) Assemble all parts in the proper sequence and turn the adjustment collar (E) to take up all the clearance between the parts.
- 2) Rotate the collar clockwise one full turn $\pm \frac{1}{8}$ turn. Tighten the cap screw to secure the adjustment collar position.
- 3) Test run several boxes and check the leading tape leg length to be $2.50 \pm .25$ inches [63.5 ± 6.3 mm].
If adjustment is required -
Turn collars clockwise to decrease leg length.
Turn collars counter-clockwise to increase leg length.

Rotate the two collars equally in $1/4$ turn increments as needed to obtain the nominal tape leg length. Tighten the cap screws to secure the adjustment collars position.

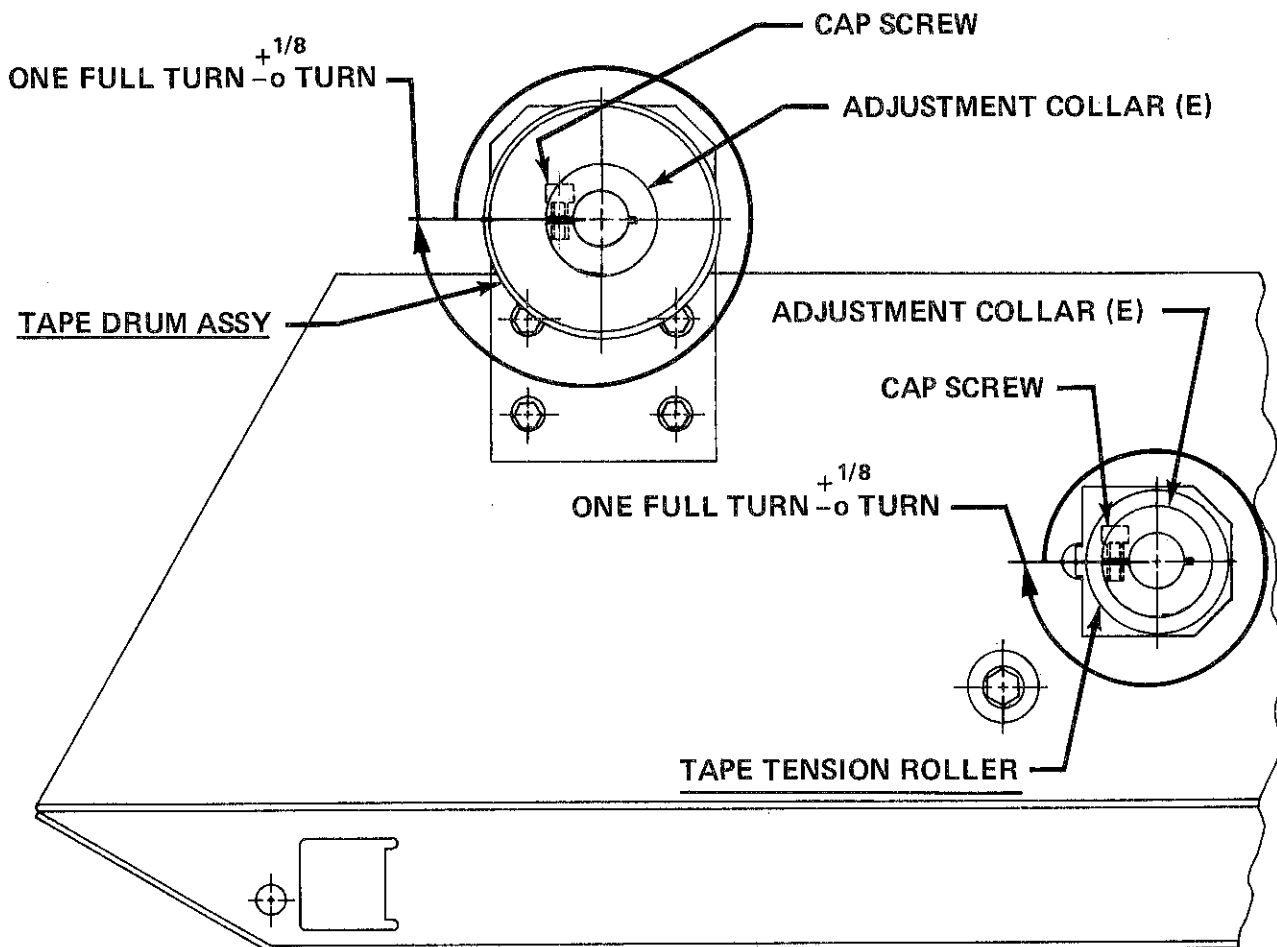


FIGURE 8 - TAPE TENSION ADJUSTMENT - RIGHT SIDE VIEW UPPER HEAD

ADJUSTMENTS (CONTINUED)

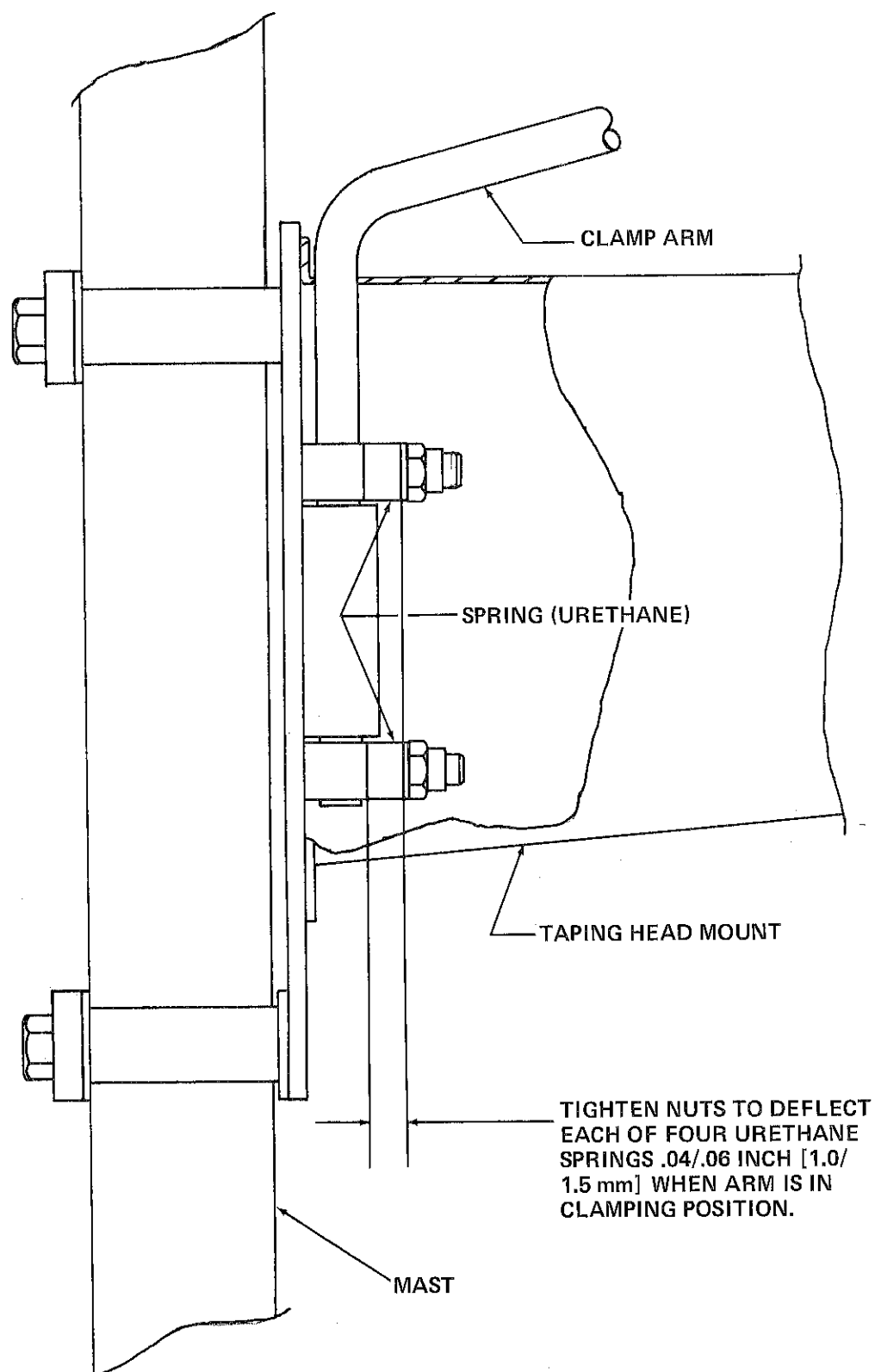


FIGURE 9 HEAD CLAMP (Infeed End View)

UPPER TAPING HEAD CLAMP

The upper taping head clamp has been pre-set to provide sufficient holding force to secure the taping head. If any clamp assembly parts are replaced, refer to Figure 9 and adjust the tension as noted.

ADJUSTMENTS (CONTINUED)

Sprocket Alignment

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

CHAIN TENSION CHART

REF. NO.	CHAIN	WHERE LOCATED	QTY.	TOTAL LATERAL MOVEMENT INCH \pm .06 [1.5 mm]	HOW TO ADJUST
(1)	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.
(2)	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 10 & 11

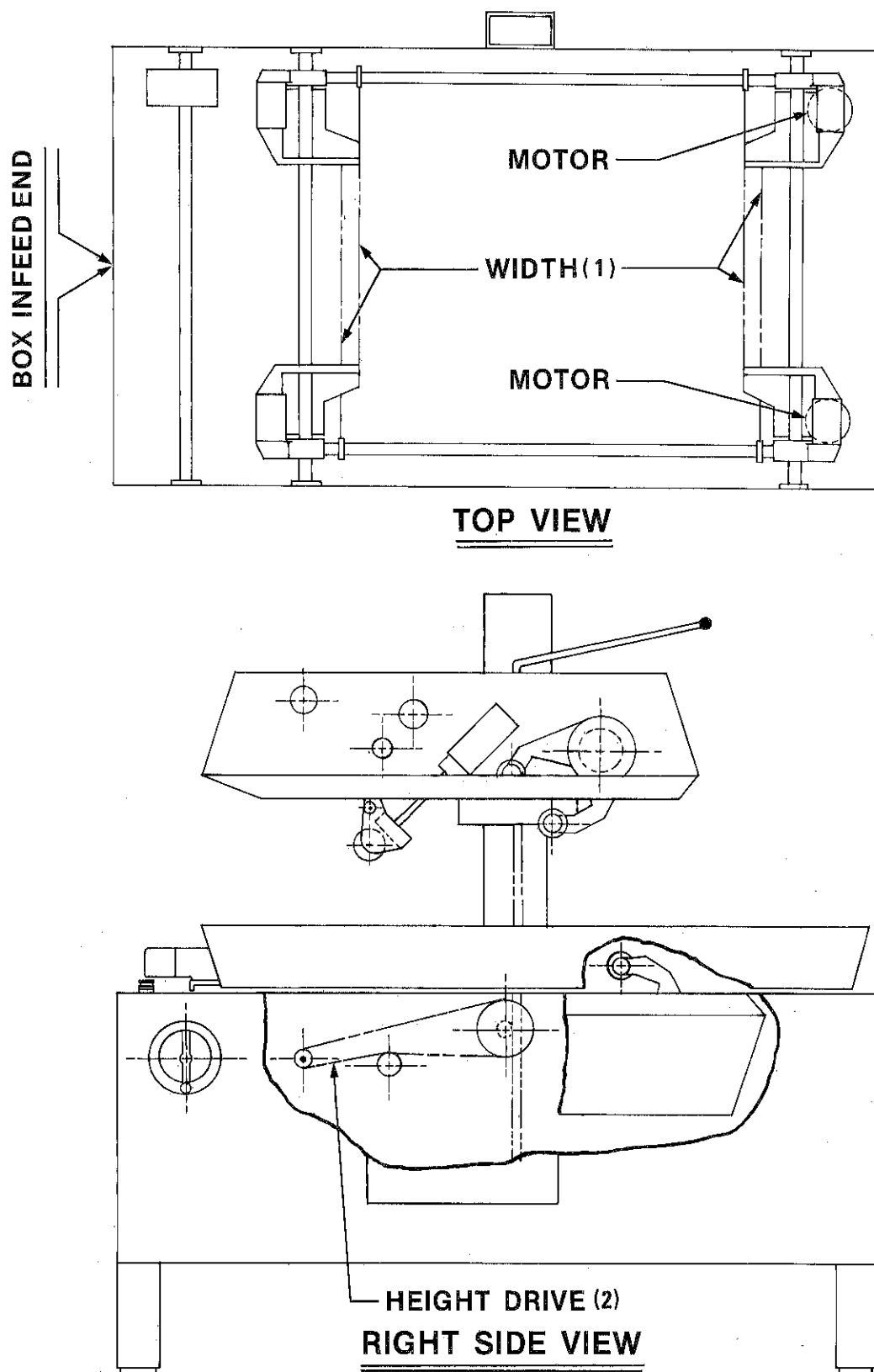


FIGURE 10 - CHAIN LOCATIONS

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.

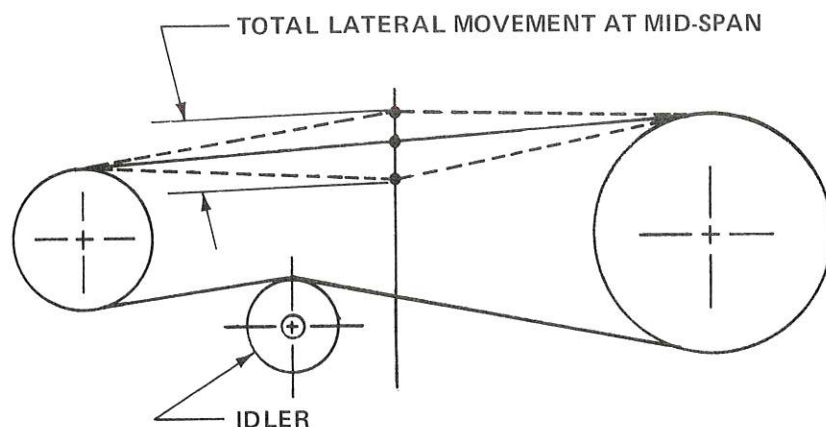


FIGURE 11 - TYPICAL CHAIN TENSION MEASUREMENT

BOX DRIVE BELT TENSION

Adjust the drive belt tensioner as shown in figure 12 such that a 5 lb. [2.3 kg] outward force at midspan will deflect the belt $1.00 \pm .125$ inches [25.40 ± 3.18 mm].

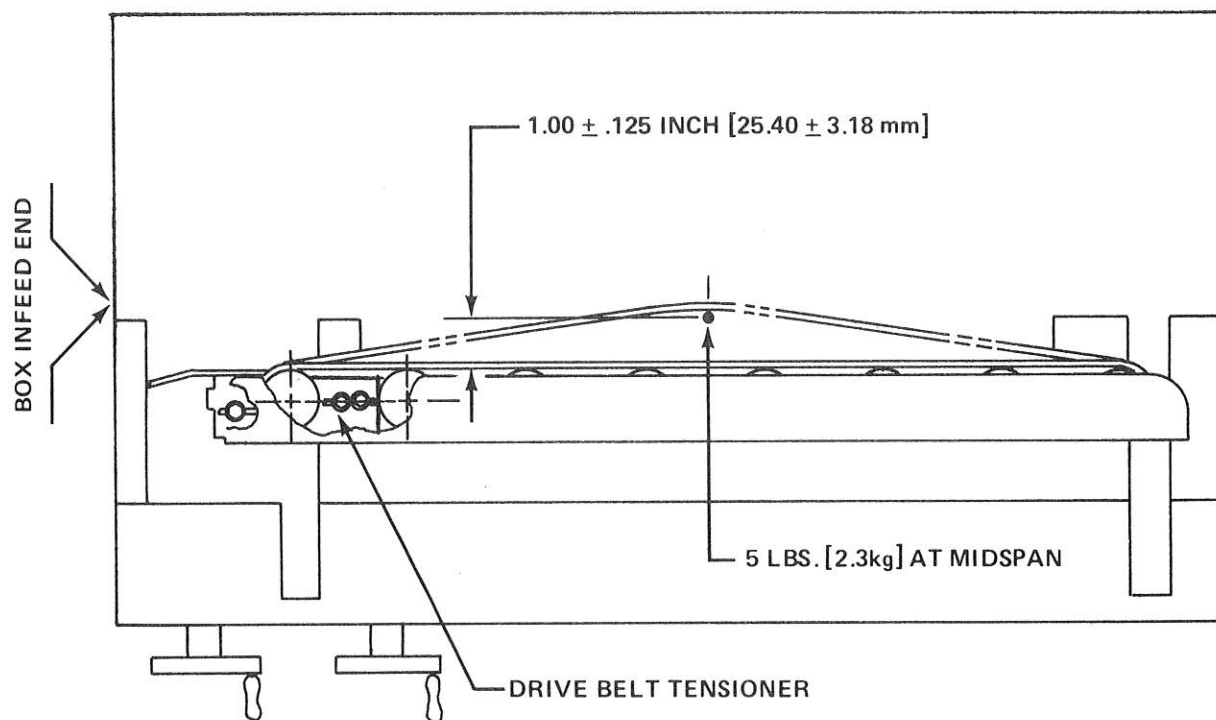


FIGURE 12 - BOX DRIVE BELT TENSION - (TOP VIEW)

HEIGHT HOLDING BRAKE

Diagram illustrating the rear of a box trailer, showing the height adjustment mechanism. The diagram includes labels for:

- BOX INFEED END (indicated by an arrow)
- BOX WIDTH
- BOX HEIGHT
- HEIGHT SHAFT
- ONE-WAY CLUTCH
- BRAKE ADJUSTMENT SCREW

NOTE
TIGHTEN ADJUSTMENT SCREW TO OBTAIN 20-30 IN./LBS. [2.26-3.38 Nm] TORQUE TO LOWER THE HEAD WITH THE CLAMP ARM IN FREE POSITION.

WIDTH HOLDING BRAKE

Diagram illustrating the components and adjustment of a box brake assembly:

- BOX INFEEED END**: Indicated by an arrow pointing to the left side of the assembly.
- BOX WIDTH**: Dimension across the top of the brake assembly.
- BOX HEIGHT**: Dimension across the top of the brake assembly.
- SHAFT**: Indicated by a line pointing to the central shaft of the brake assembly.
- BRAKE ADJUSTMENT SCREW**: Indicated by a line pointing to the adjustment screw on the brake assembly.

NOTE
TIGHTEN ADJUSTMENT SCREW TO OBTAIN
35-40 IN/LBS. [3.95-4.52 Nm] TORQUE AT
SHAFT.

- 18 -

ADJUSTMENTS (CONTINUED)

Taping Head Cut-off Adjustment - Refer to Figure 15.

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

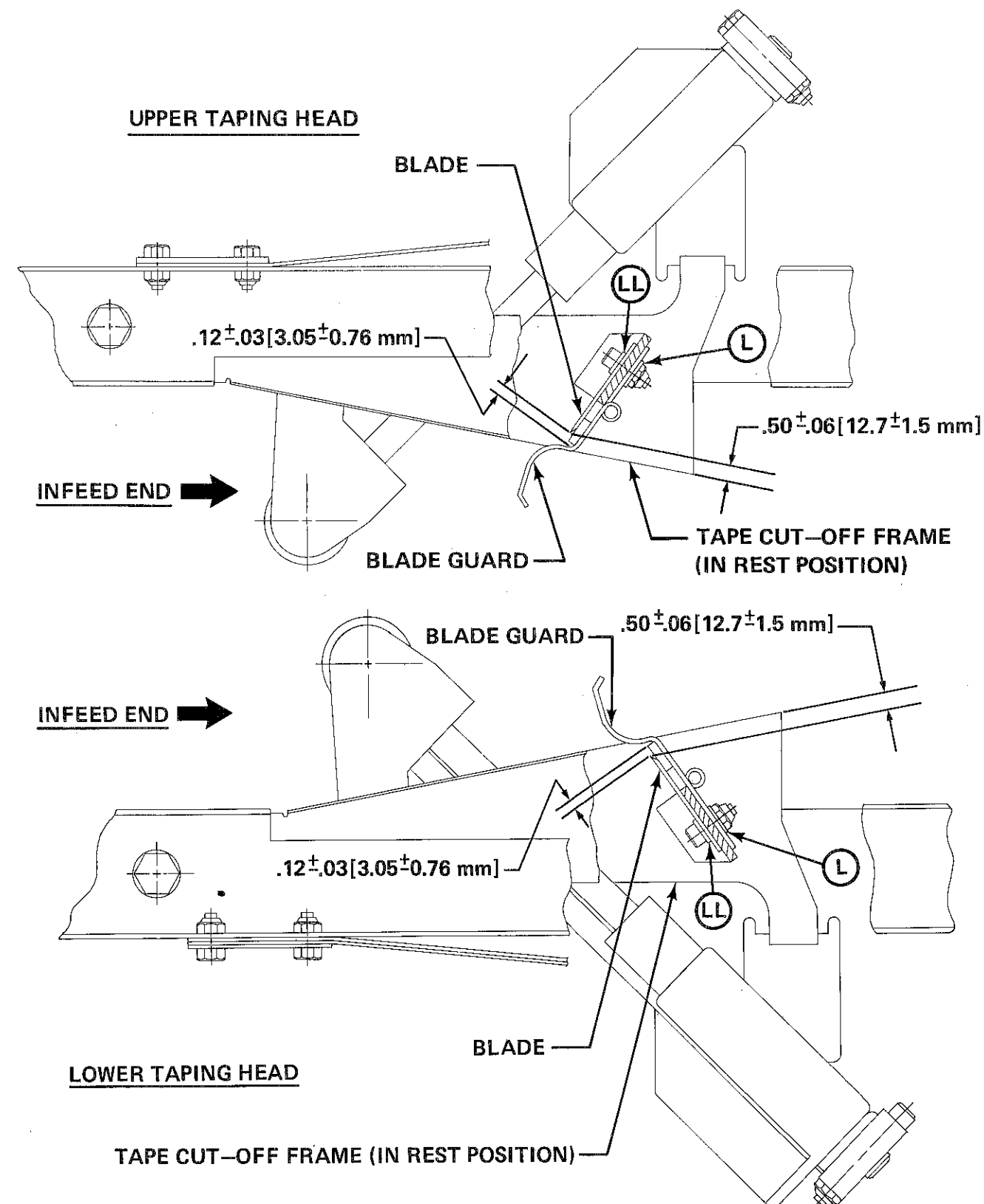


FIGURE 15 - UPPER AND LOWER CUT-OFF ADJUSTMENT - RIGHT SIDE VIEW

ADJUSTMENTS (CONTINUED)

CUT-OFF BLADE:

The cut-off blades used on all 5A Box Sealers normally clean themselves. Should tape adhesive build-up occur, carefully wipe clean with oily cloth.

C A U T I O N - Blades are extremely sharp.

BLADE REPLACEMENT: (Refer to Figure 15)

NOTE: The 5A, Model 377 is supplied with two extra cut-off blades (Item 471 Parts List).

Disconnect the main power supply to the 5A before starting the replacment.

1. Remove and retain the blade screws, nuts and washers holding the blade. Remove the old blade.
2. Position the new blade with the beveled side against the blade holder as shown in Figure 15. Assemble the blade screws with one washer (L) next to the nut and one washer (LL) next to the screw head as shown.

The same steps are followed in the upper and lower blade replacement. Connect the main power supply.

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 pages 21 & 22 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.	
Upper Taping Head Assy. (Fig. 24-26- 27-28)	Spring-Compression- Brake Ref. #461	250 Hrs.	1	Apply light coat to entire I.D.
	Spring-Tape Cut-off Ref. #429	250 Hrs.	1	Apply light coat to the outside diameter of the loop.
	Shaft-Linear Bearing Ref. #436	250 Hrs.	2	Wipe on light coat.
	Pad-Blade Guard Ref. #401	250 Hrs.	2	3 drops
	Spring-Torsion, Inner Ref. #458	250 Hrs.	1	Apply light coat to spring ends and entire O.D. & I.D.
Applying Arm Casting Assy. (Fig. 26)	Spring-Torsion, Outer Ref. #459	250 Hrs.	1	Apply light coat to spring ends
	Bearings Ref. #384	1,000 Hrs or 6 Mos.	1	Pack all bearings.
	Chains Ref. # 343 & 355	250 Hrs.	2	Apply light coat to surface.
Front & Rear Belt Assy. (Fig. 19)	Shaft-Linear Bearing Ref. #265	250	1	Apply light coat to outside dia. of shaft.
	Chain Ref. #94	6 Mos.	2	Apply light coat to surface.
	Rack, Mast Ref. #244	6 Mos.	1	Apply light coat to teeth.
Mast Assy. (Fig. 23)				

MAINTENANCE (CONTINUED)

MACHINE AREA & LOCATION	PART NAME & REF. NO.	LUBRICATION		INSTRUCTIONS
		FREQUENCY	REF. NO.	
Lower Taping Head Assy. (Fig. 29-31- 32-33)	Spring-Compression Brake Ref. #461	250 Hrs.	1	Apply light coat to entire I.D.
	Spring-Tape Cut-off Ref. #429	250 Hrs.	1	Apply light coat to outside diameter of the loop and entire bottom side.
	Shaft-Linear Bearing Ref. #436	250 Hrs.	2	Wipe on light coat.
	Pad-Blade Guard Ref. #401	250 Hrs.	2	3 drops
	Spring-Torsion, Inner Ref. #458	250 Hrs.	1	Apply light coat to spring ends and entire O.D. & I.D.
	Spring-Torsion, Outer Ref. #459	250 Hrs.	1	Apply light coat to spring ends and entire O.D.
	Spring-Compression Ref. #408	250 Hrs.	1	Apply light coat to entire I.D.
	Bearings Ref. #384	1,000 Hrs. or 6 Mos.	1	Pack all bearings.
Applying Arm Casting Assy. (Fig. 31)				

LUBRICATION		
REF. NO.	3M PART NO.	
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.

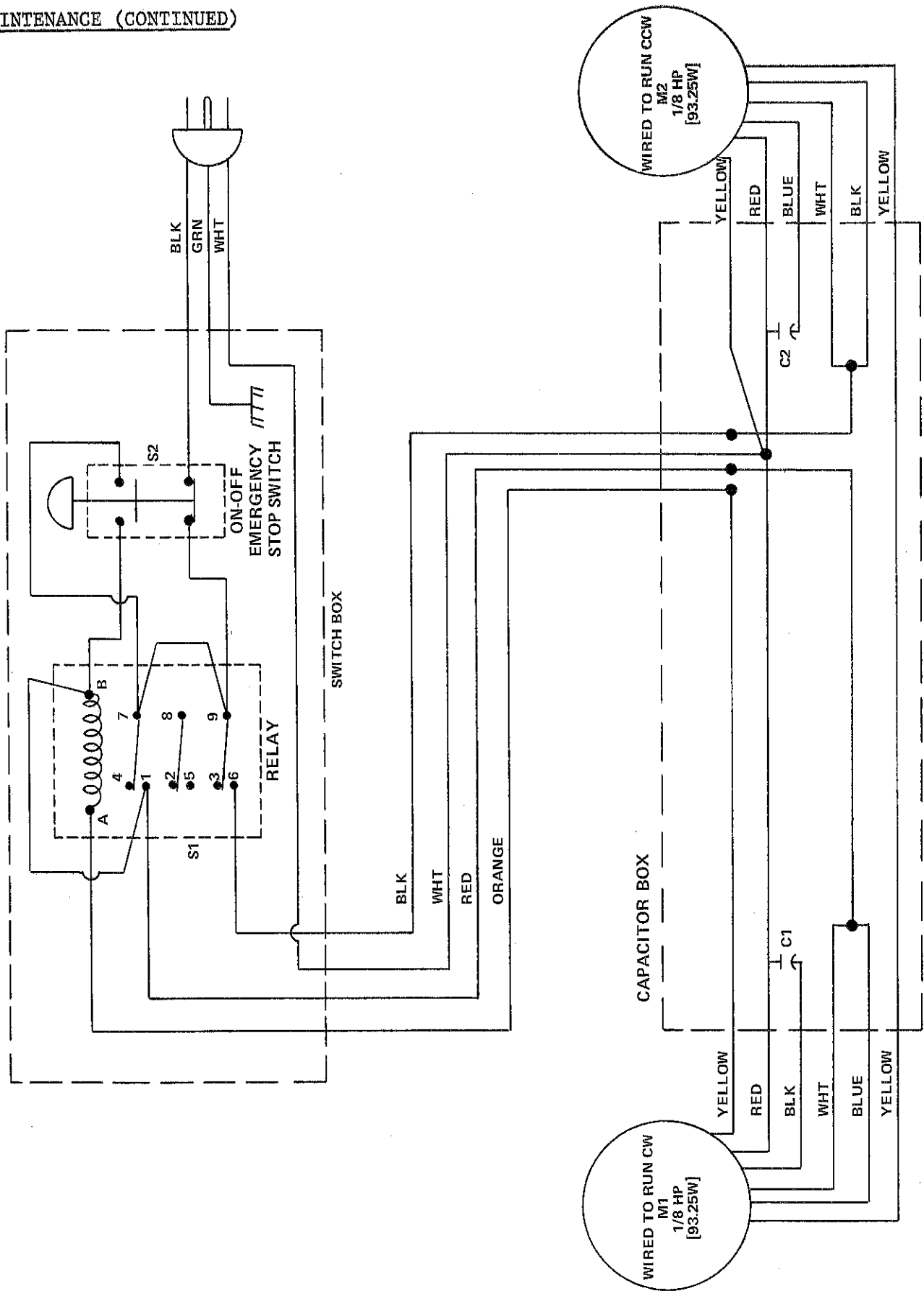


FIGURE 16 ELECTRICAL SCHEMATIC 5A, MODEL 377

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	400	78-8014-1220-2	Spring - Torsion
2	403	78-8015-7053-8	Roller - Buffing Assy.
1	408	78-8015-7244-3	Spring - Compression
2	423	78-8015-7160-1	Washer - Friction Brake
1	429	78-8015-7029-8	Spring - Tape Cut-off
1	437	78-8015-7158-5	Vee Roller
1	458	78-8015-7213-8	Spring - Torsion, Inner
1	459	78-8015-7214-6	Spring - Torsion, Outer
1	460	78-8015-7212-0	Spring - Lower Head
2	471	78-8015-6605-6	Blade - 2-1/2 Inch

NOTE: All above parts are replaceable stock items.

HOW TO ORDER REPLACEMENT PARTS

- 1) Refer to figure 17 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.)

\$2.00 handling charge for all parts orders under \$5.00.

Replacement part prices available on request.

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

3M Company, Tape Dispenser Parts
P. O. Box 33900, St. Paul, Minnesota 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.

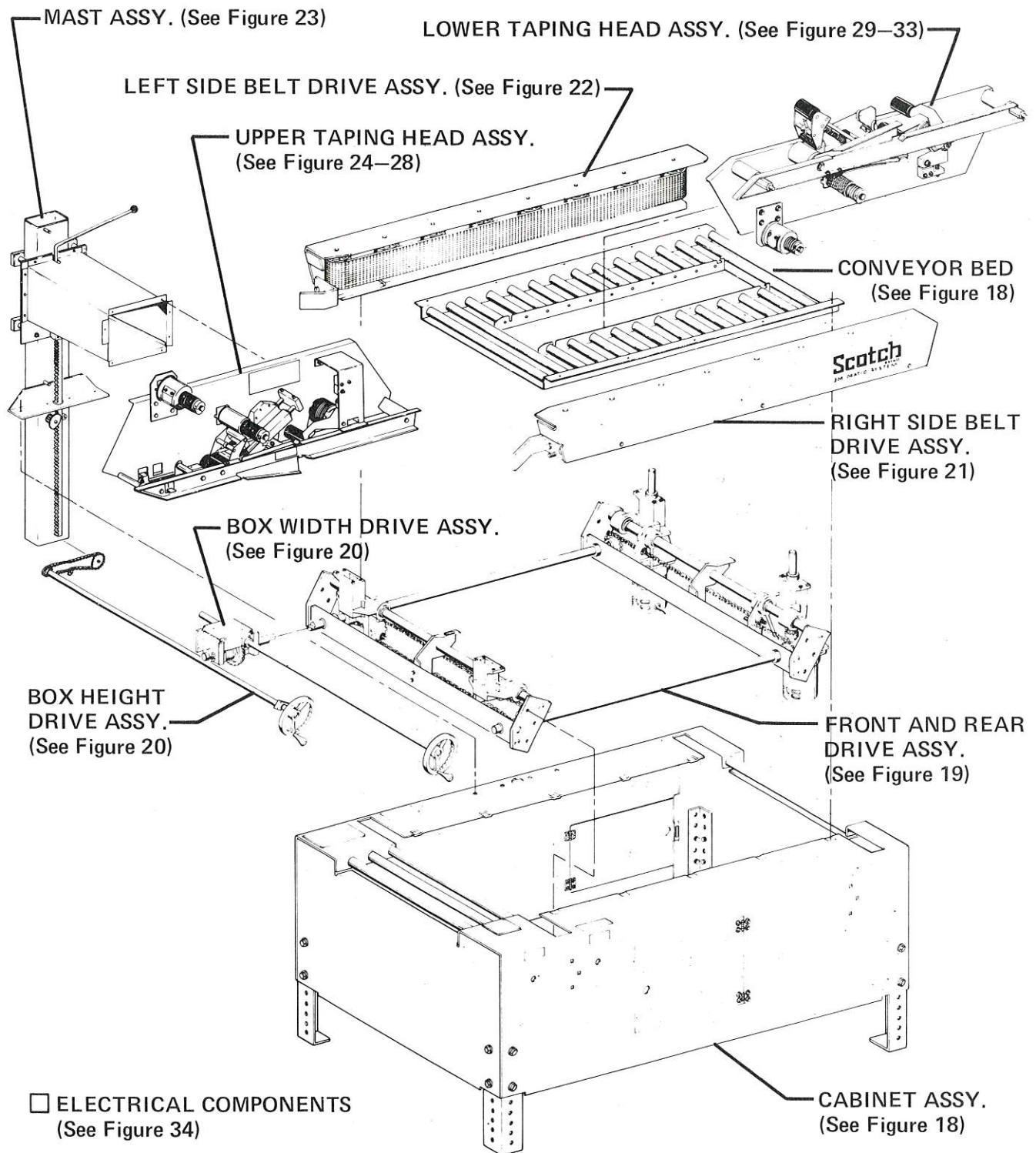


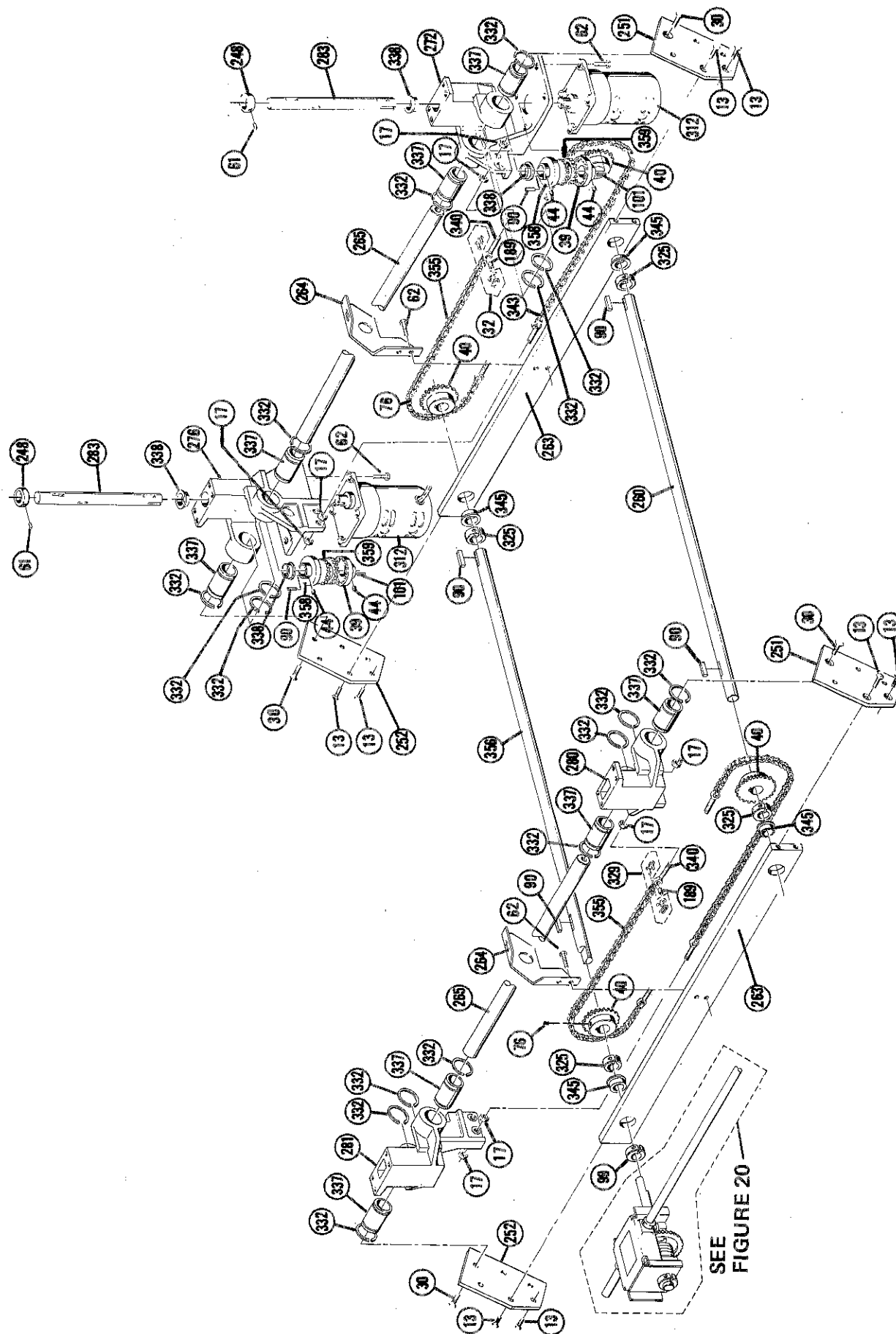
FIGURE 17 - 5A BOX SEALER, MODEL 377 COMPONENT ILLUSTRATIONS

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 377
FIGURE 18 - 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	26-1000-9785-1	Nut-Light Hex, Full Ht. 10-32 UNF ESNA #21NM-02
* 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	26-1001-9879-0	Button, Plug - O/T Metallic, 1 3/16 Dia. Mtg. Hole, Polyethylene Blk. Caplug #BPF- 1 3/16
*314	78-8015-7242-7	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.



SEE
FIGURE 20

FIGURE 19 - FRONT & REAR DRIVE ASSEMBLY
Refer to page 30 for front and rear assembly parts list.

REPLACEMENT PARTS LIST
CAT. NO. 5A BOX SEALER, MODEL 377
FIGURE 19 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 .58 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	78-8015-6590-0	Coupling - Overstuffed Box Assy.
312	78-8015-7166-8	Motor Gear
*325	78-8032-1531-4	Collar - One Piece Split Maxwell 16 L
329	78-8032-3921-5	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 "SURFLEX" 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.

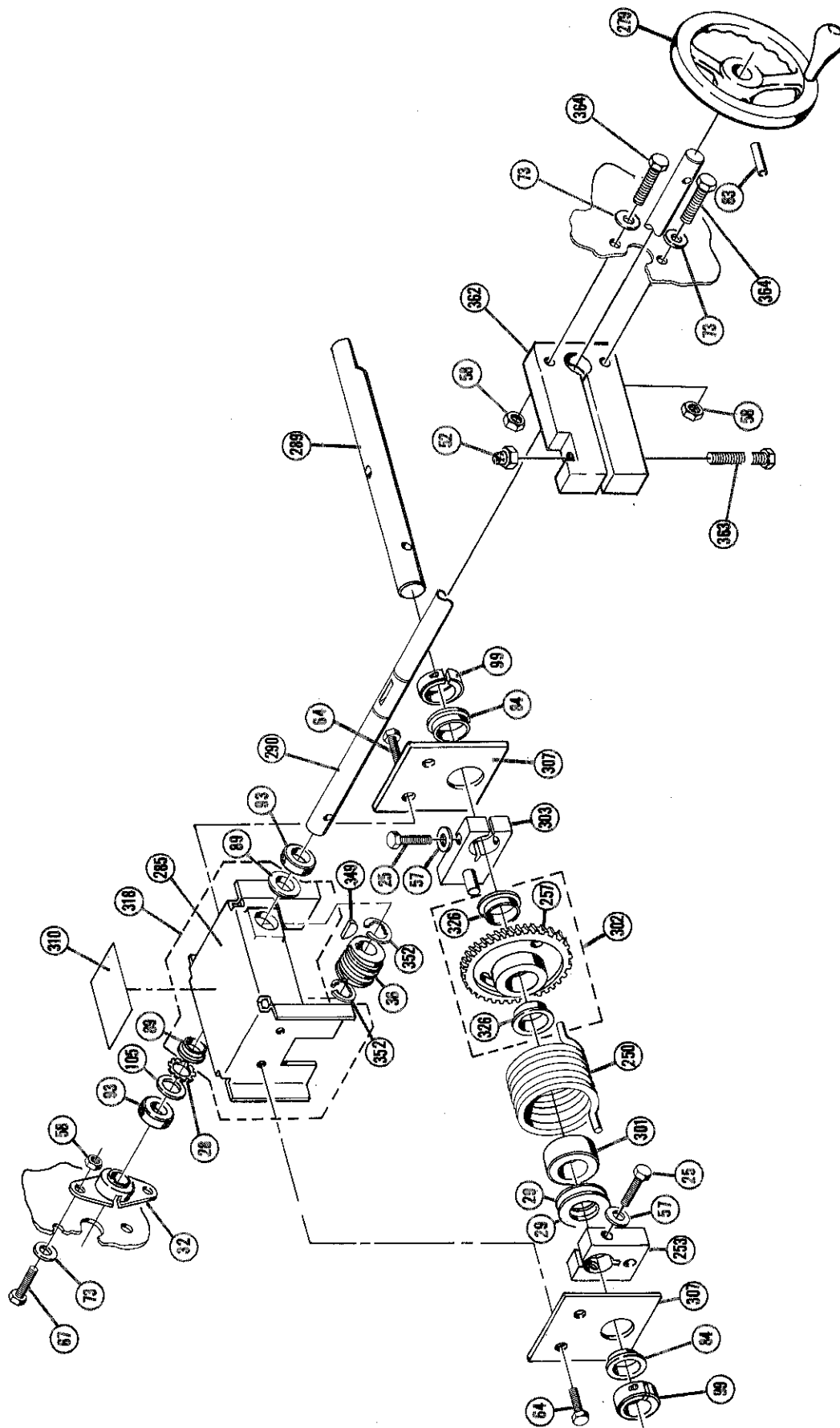


FIGURE 20 - BOX WIDTH DRIVE ASSEMBLY

Refer to page 32 for box width drive assembly parts list.

REPLACEMENT PARTS LIST
5A BOX SEALER, MODEL 377
FIGURE 20 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	26-1000-9786-9	Nut - Light Hex, Full Ht. 1/4-20 UNC ESNA #21NE-040
* 57	70-8000-4795-6	Washer - Plain Type A, 1/4 Narrow
* 58	26-1000-9787-7	Nut - Lt. Hex, Full Ht. 5/16-18 ESNA #21NE-058
* 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 12 L
*105	78-8005-8493-6	Bearing - Thrust "OILITE" #TT-1508-1
*250	78-8015-6436-6	Spring - Overstuffed Box
*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.

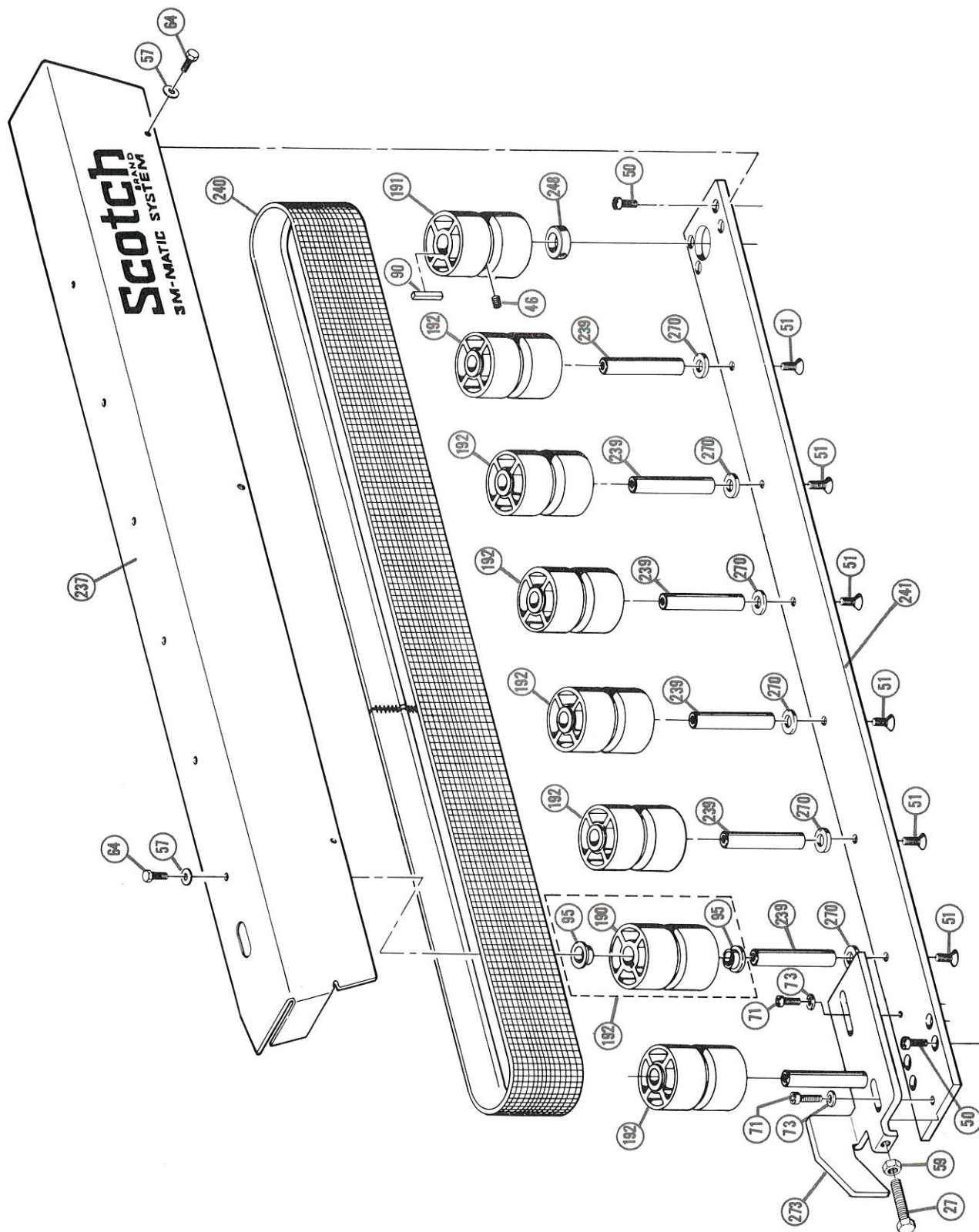


FIGURE 21 - RIGHT SIDE BELT DRIVE ASSEMBLY
 Refer to page 35 for right side belt drive assembly parts list.

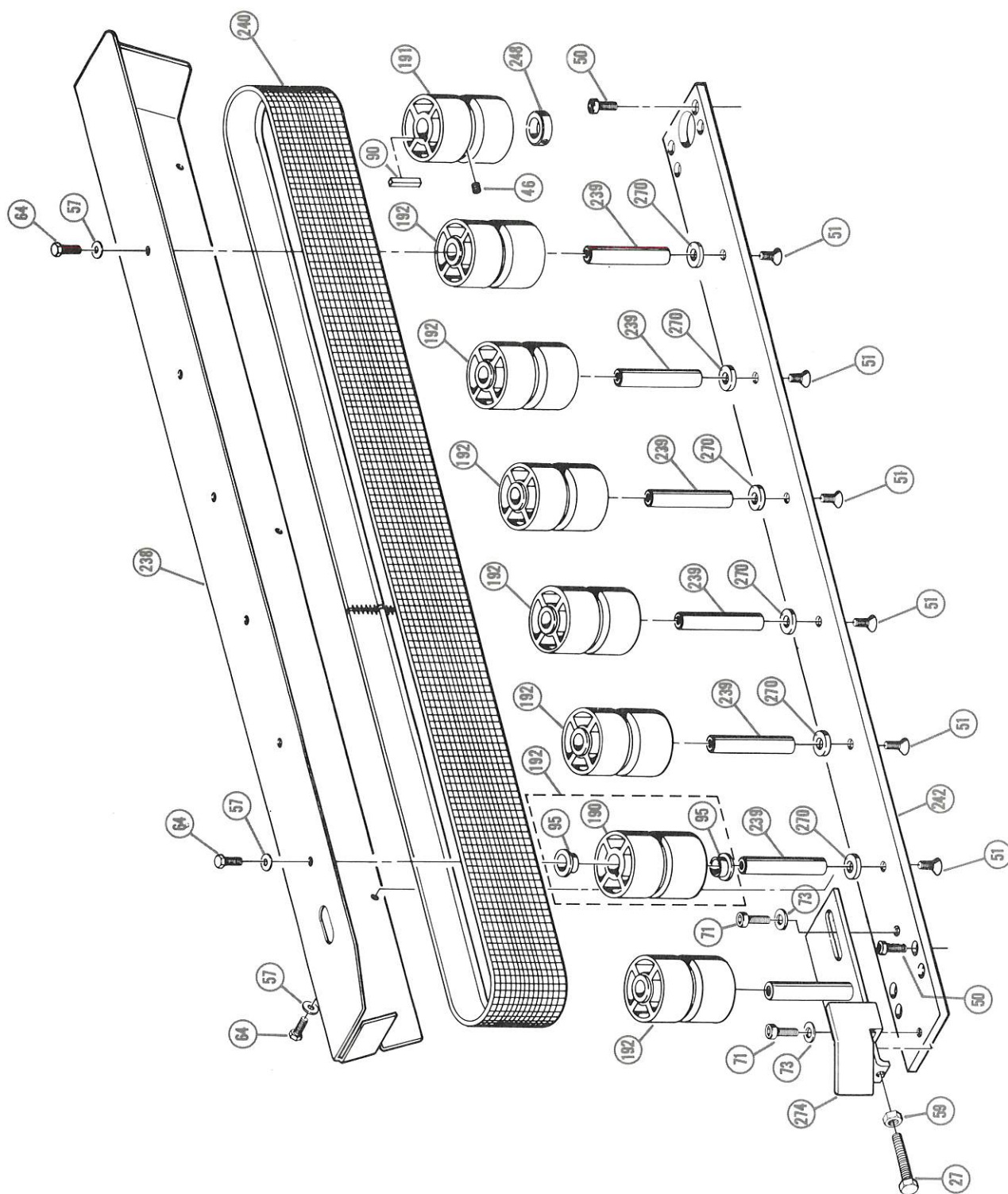


FIGURE 22 - LEFT SIDE BELT DRIVE ASSEMBLY
Refer to page 35 for left side belt drive assembly parts list.

REPLACEMENT PARTS LIST
5A BOX SEALER, MODEL 377
FIGURES 21 & 22 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.

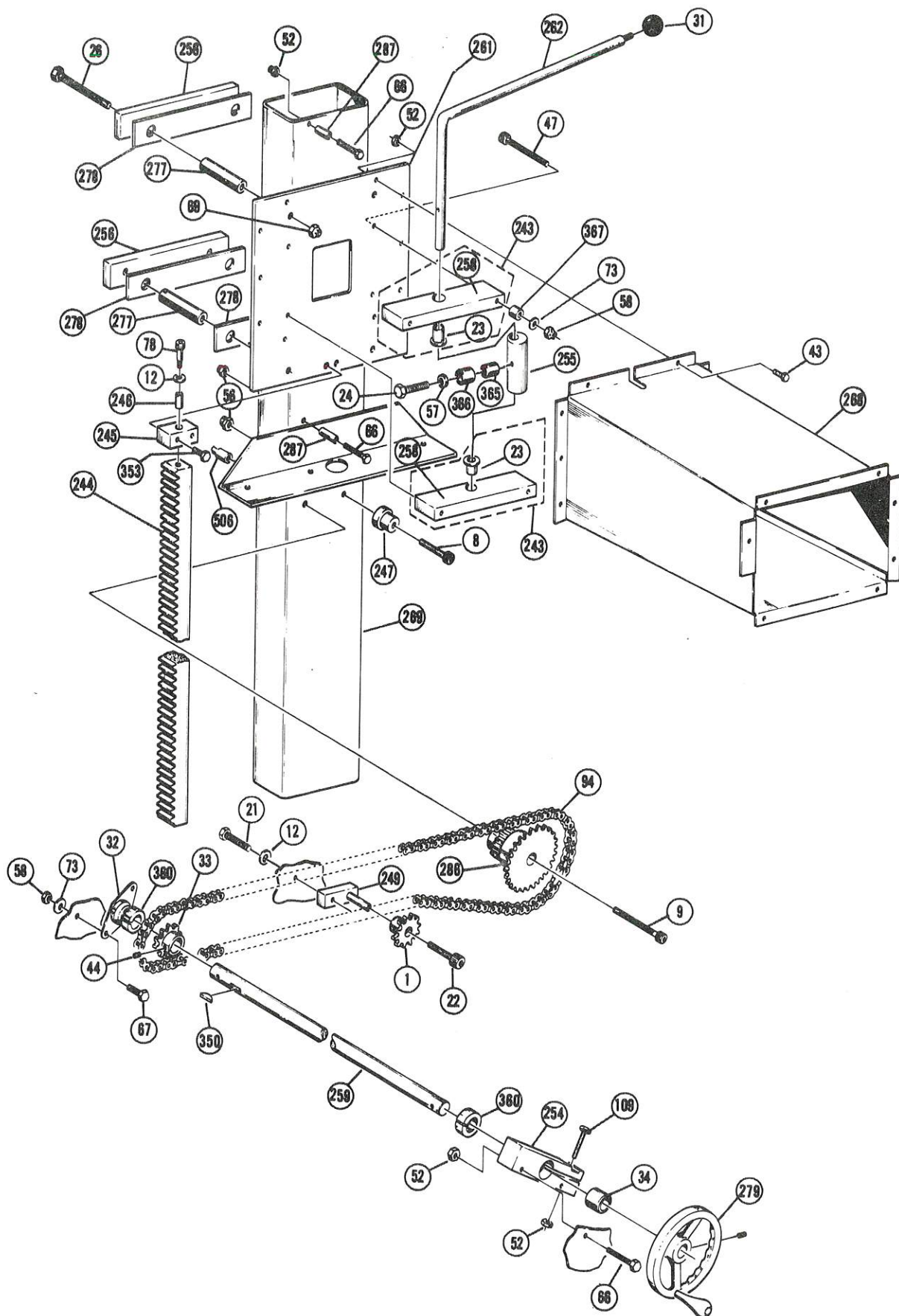


FIGURE 23 - MAST ASSEMBLY AND BOX HEIGHT DRIVE ASSEMBLY

Refer to page 37 & 38 for Mast Assembly and Box Height Drive Assembly
Parts List.

REPLACEMENT PARTS LIST
5A BOX SEALER MODEL 377
FIGURE 23 - 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	26-1001-2835-9	Screw - Cap, Flat Hd, Hex Soc. Dr, 5/16-18 UNC x 3 3/4 Lg.
* 52	26-1000-9786-9	Nut - Light Hex, Full Ht. 1/4-20 UNC ESNA #21NE-040
* 56	26-1000-9788-5	Nut-Lt Hex, Full Ht. 3/8-16 ESNA #21NE-066
* 57	70-8000-4795-6	Washer - Plain, Type A, 1/4 Narrow
* 58	26-1000-9787-7	Nut - Light Duty Hex, Zinc Pl. 5/16-18 UNC, ESNA #21NE-058
* 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 377
FIGURE 23 - 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	78-8015-7222-9	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. Dc. 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
506	78-8018-7528-3	Nut - Mast

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

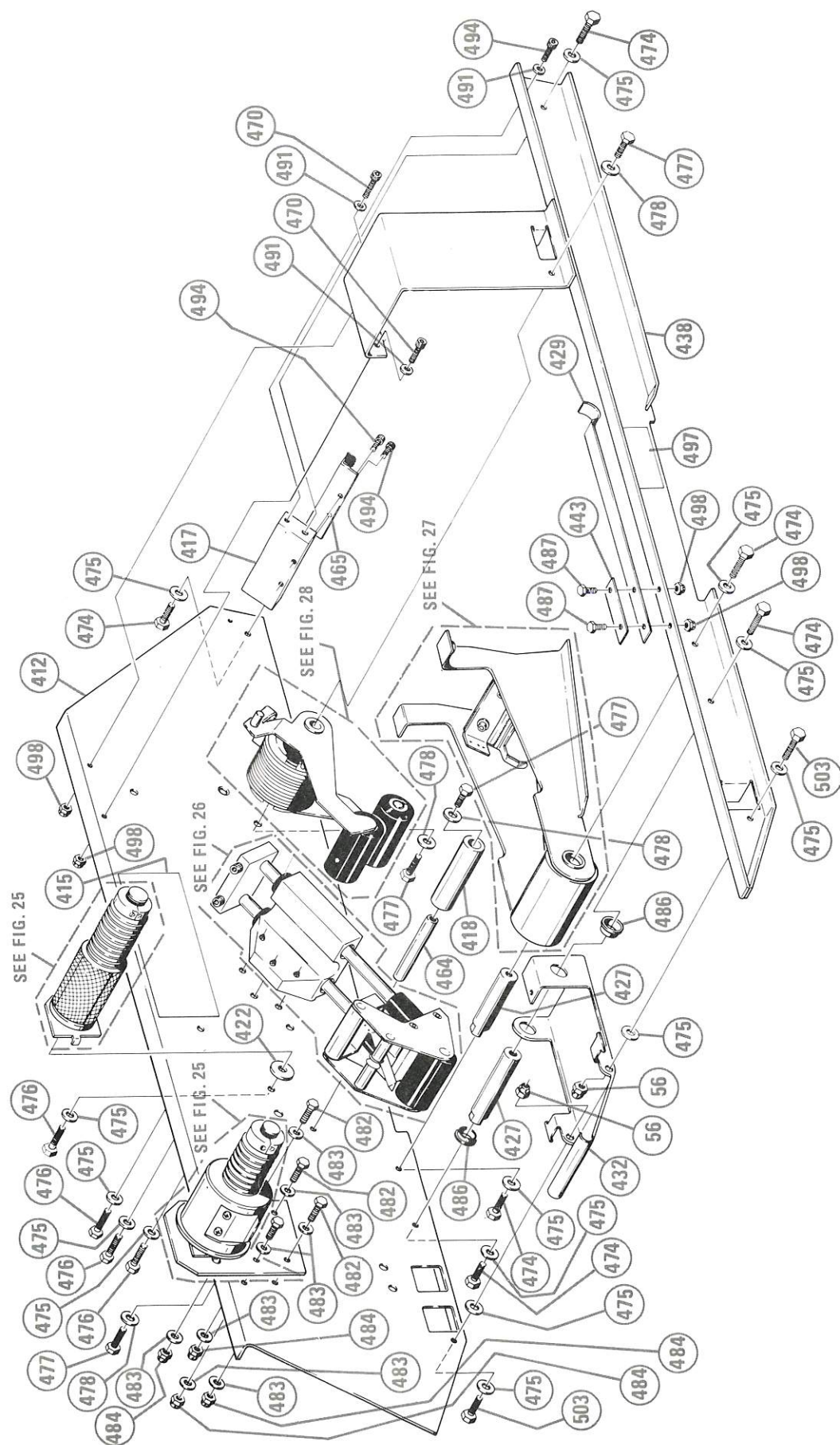


FIGURE 24 - UPPER TAPING HEAD ASSEMBLY

Refer to pages 47-50 for Upper Taping Head Assembly parts list.

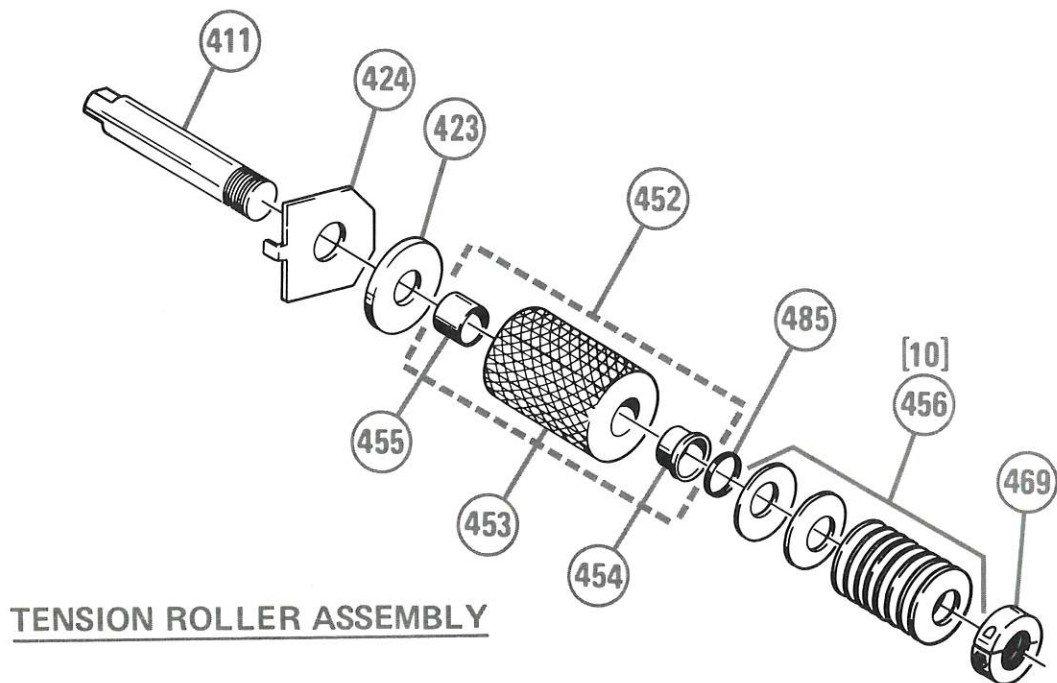
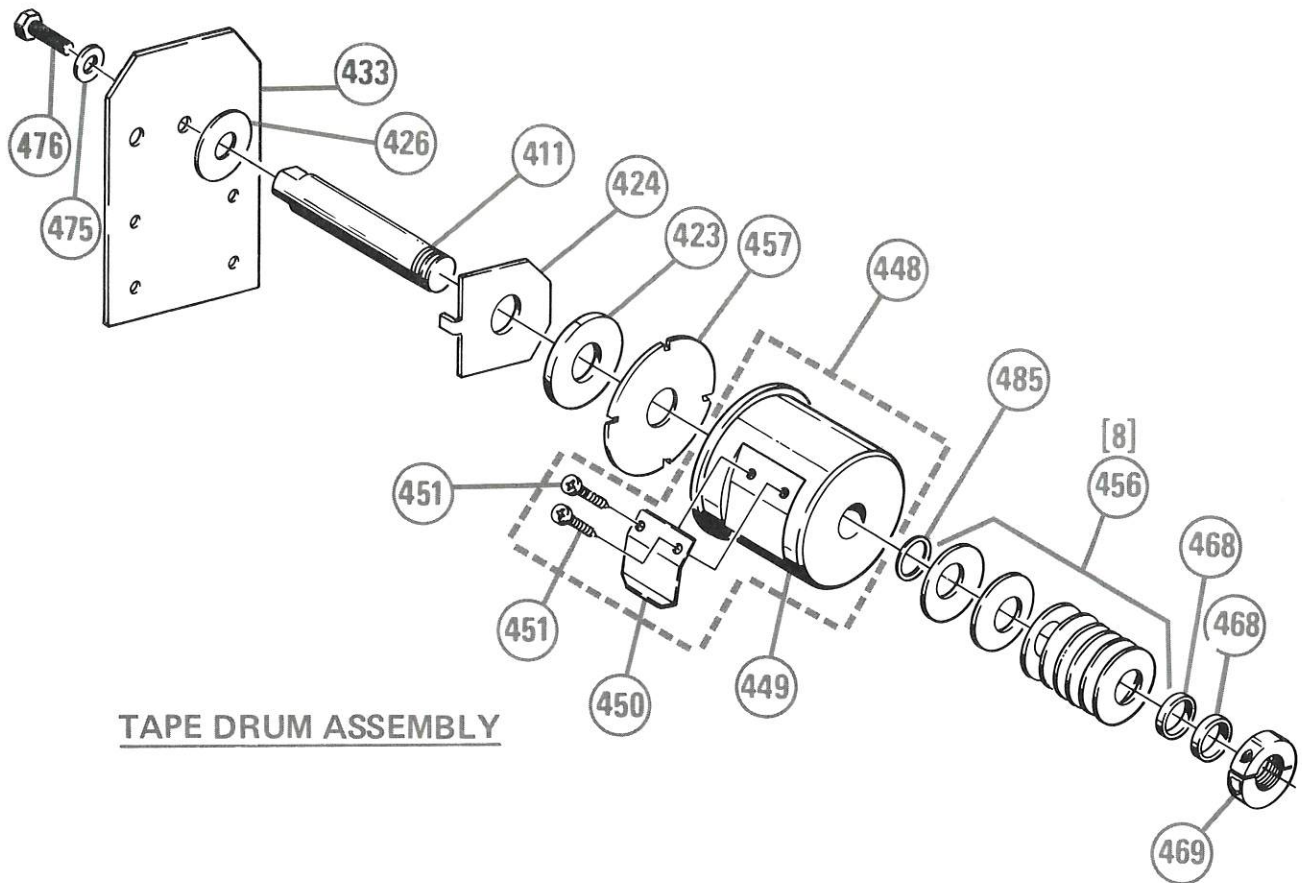


FIGURE 25 - TAPE DRUM ASSEMBLY AND TENSION ROLLER ASSEMBLY - UPPER HEAD
Refer to page 48 for tape drum and tension roller assembly parts list.

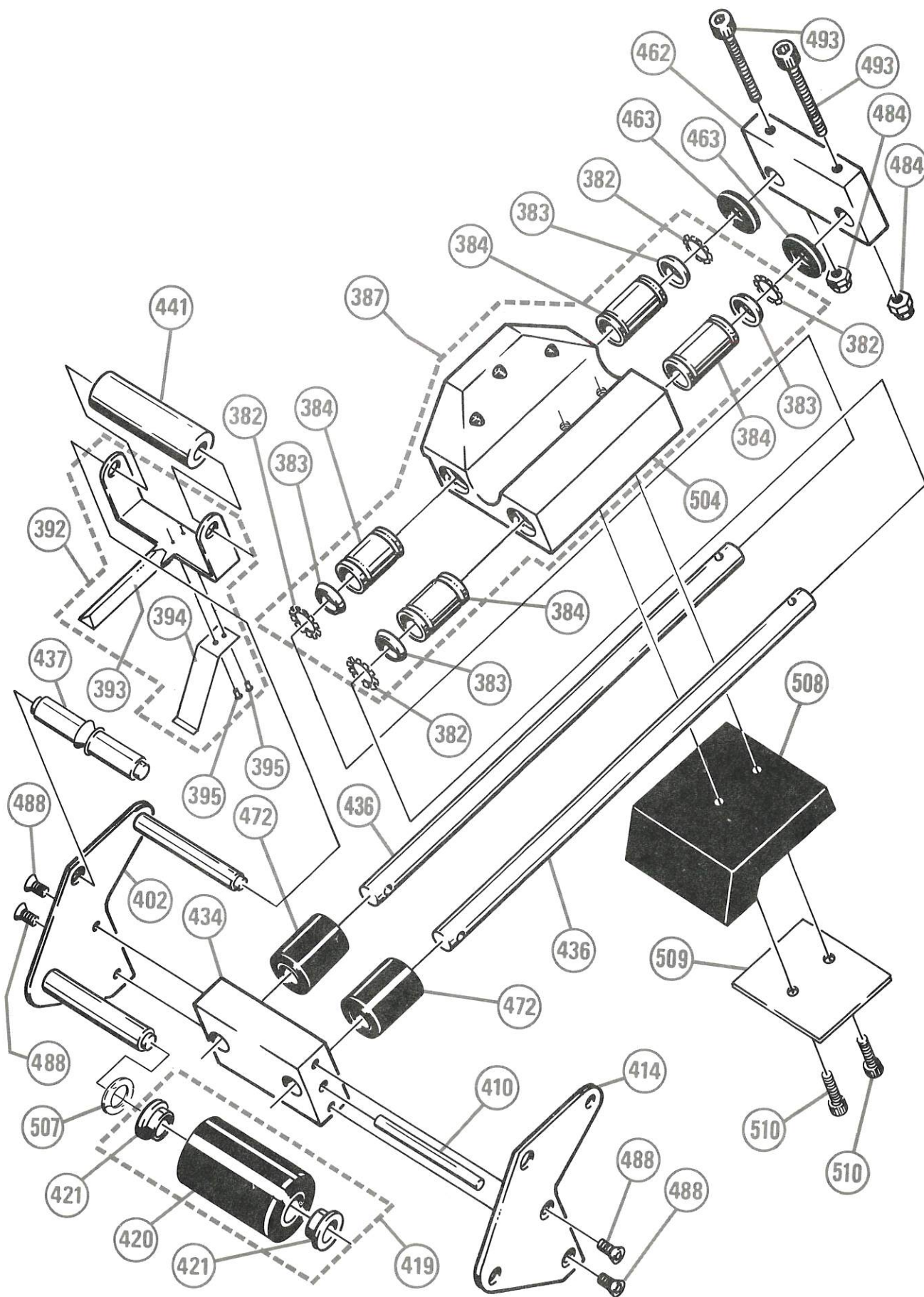
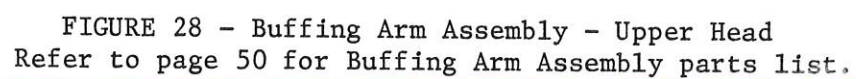
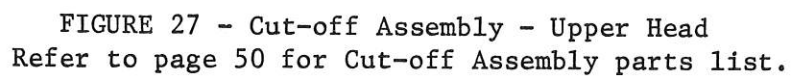


FIGURE 26 APPLYING ARM ASSEMBLY - UPPER HEAD
Refer to page 49 for Applying Arm Assembly Parts List.



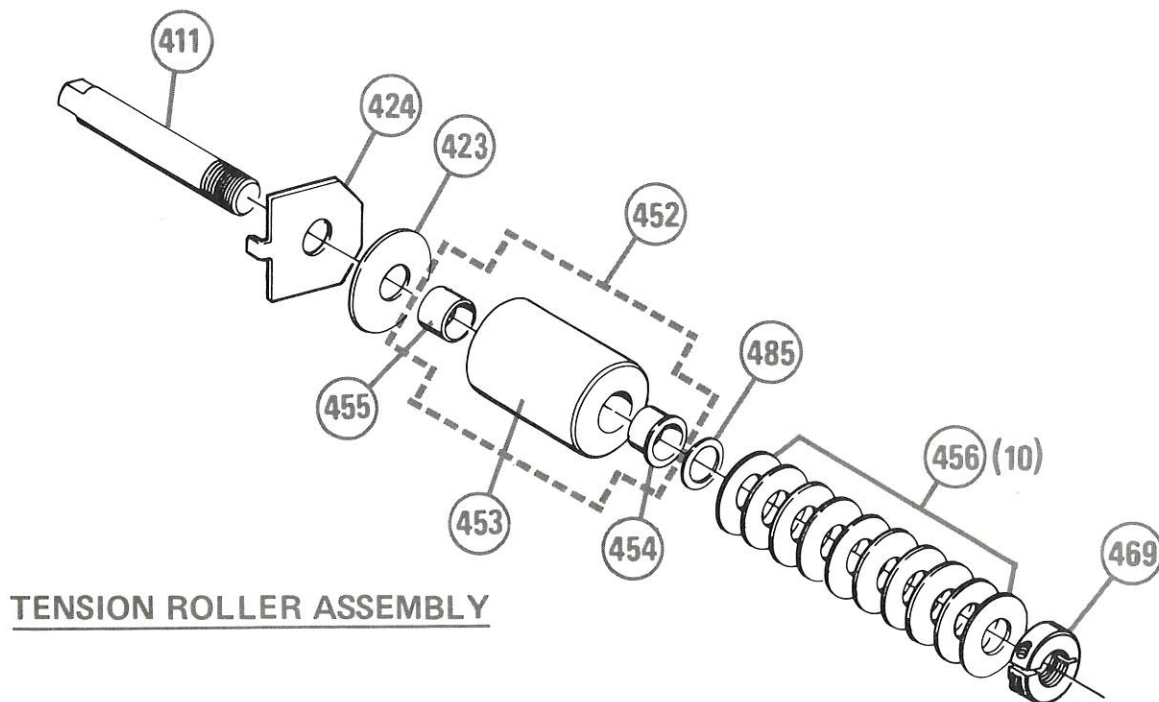
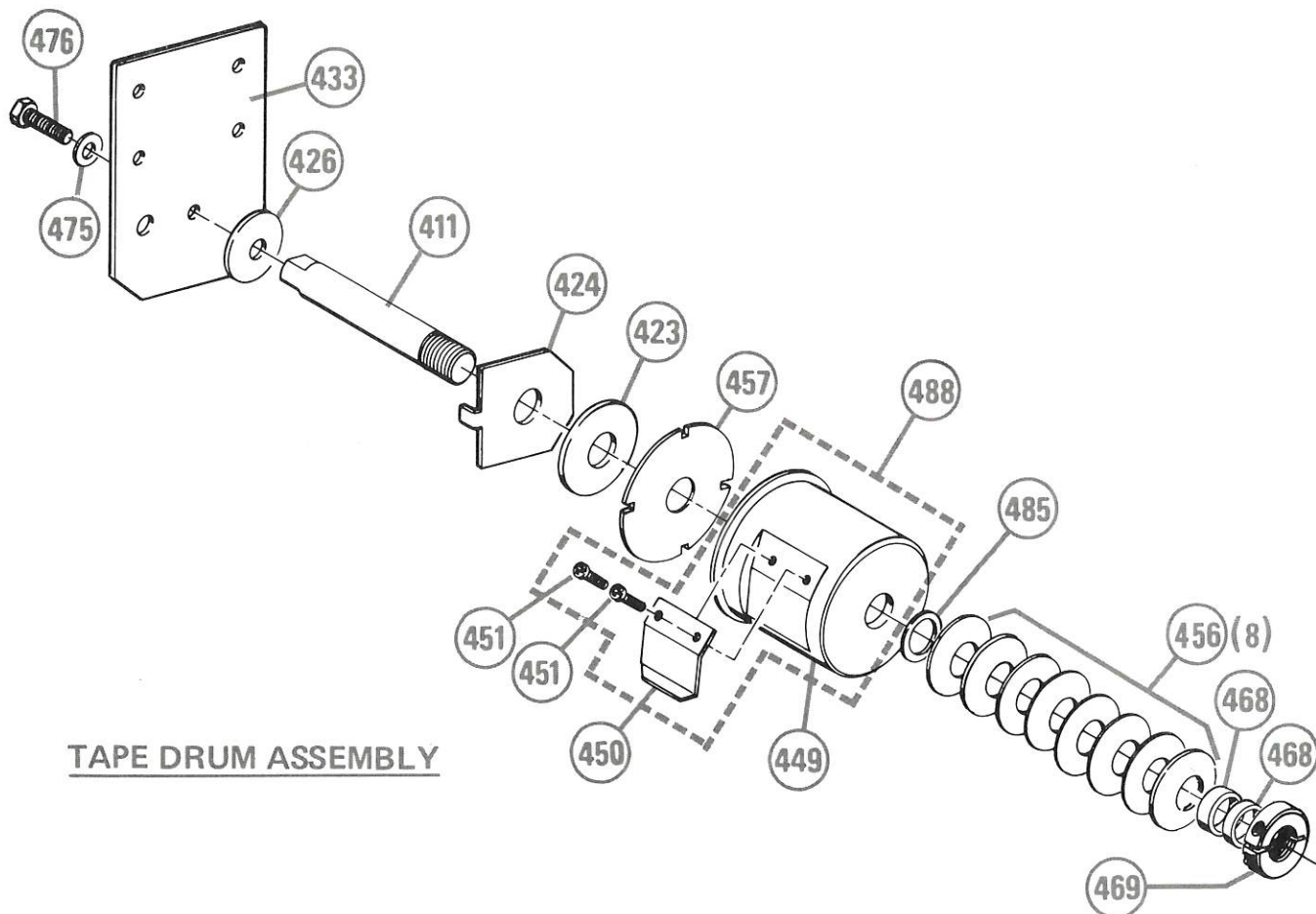


FIGURE 30 - TAPE DRUM ASSEMBLY AND TENSION ROLLER ASSEMBLY - LOWER HEAD
Refer to page 48 for Tape Drum and Tension Roller Assembly parts list.

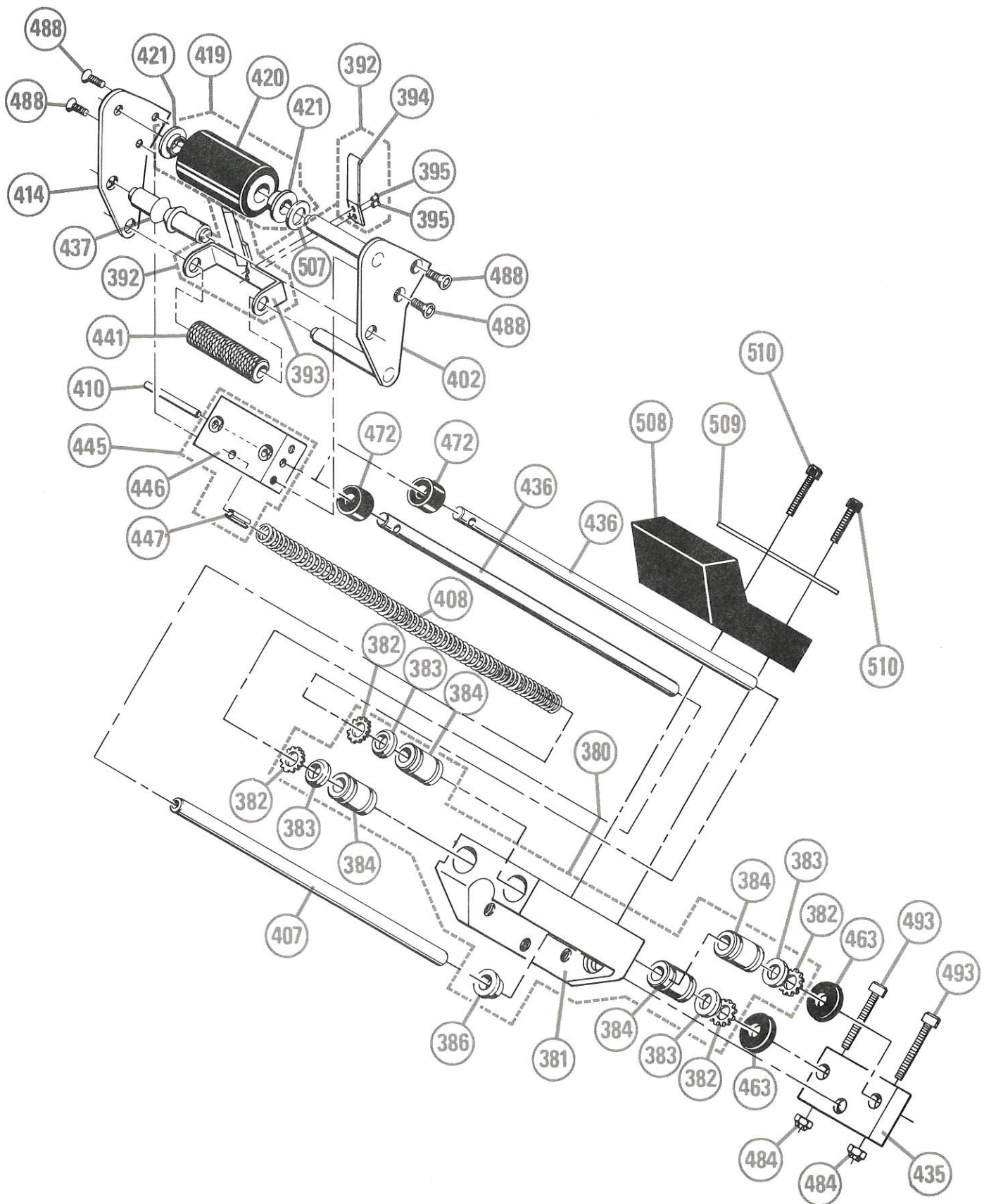


FIGURE 31 - APPLYING ARM ASSEMBLY - LOWER HEAD
Refer to page 49 for Applying Arm Assembly parts list.

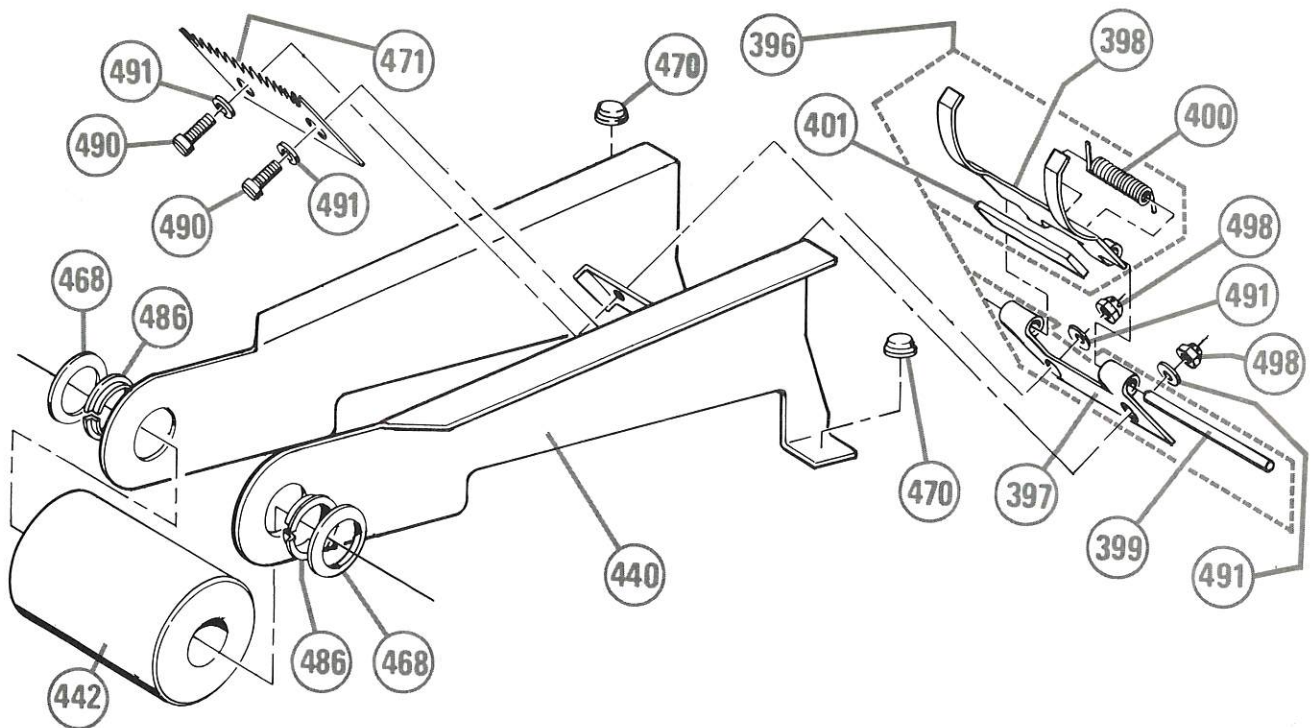


FIGURE 32 - CUT-OFF ASSEMBLY - LOWER HEAD
Refer to page 50 for Cut-off Assembly parts list.

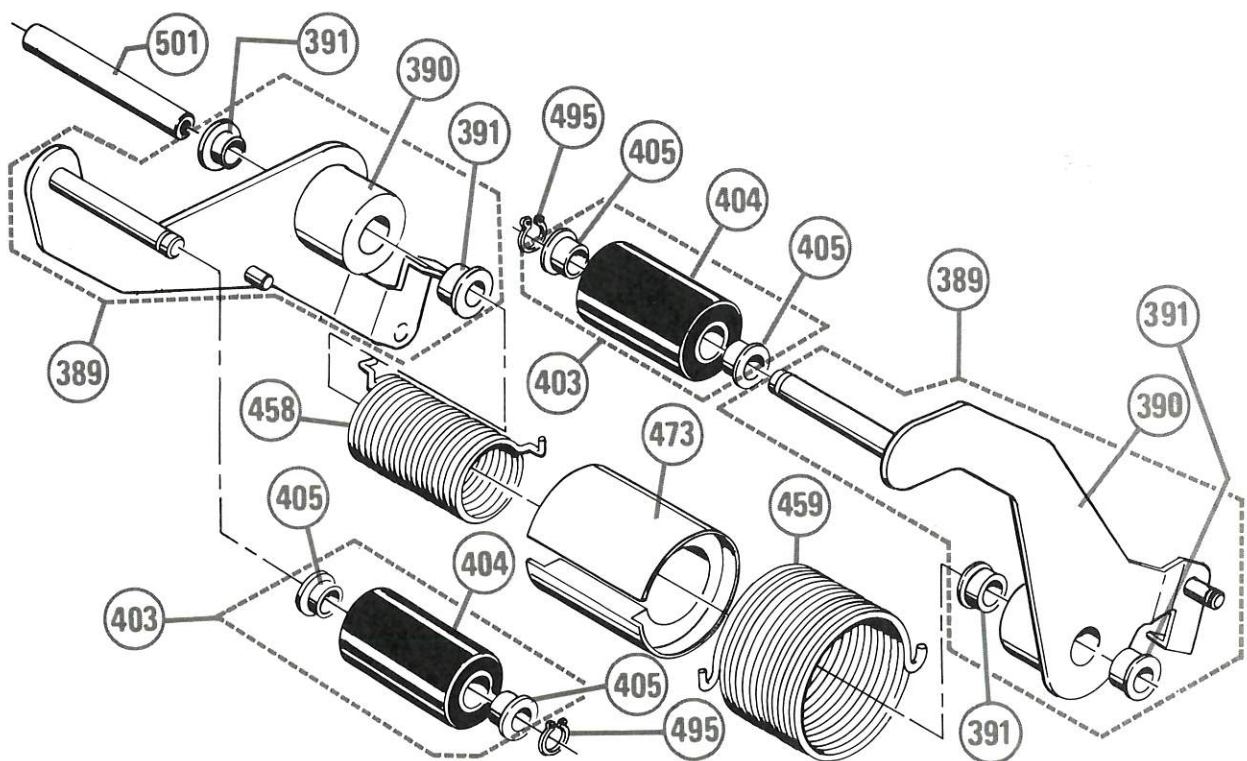


FIGURE 33 - BUFFING ARM ASSEMBLY - LOWER HEAD
Refer to page 50 for Buffing Arm Assembly parts list.

REPLACEMENT PARTS LIST
5A BOX SEALER MODEL 377
FIGURES 24 & 29 UPPER AND LOWER TAPING HEAD ASSEMBLIES

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
* 56	26-1000-9788-5	Nut-Lt. Hex, Full Ht. 3/8-16 ESNA #21NE-066
409	78-8017-9458-3	Spring - Compression, Brake
*412	78-8015-7038-9	Plate-Upper Taping Head Frame
*413	78-8015-7033-0	Plate - Lower Taping Head Frame
415	78-8015-7217-9	Label - Tape Threading, Upper
416	78-8015-7216-1	Label-Tape Threading, Lower
*417	78-8015-7203-9	Mount - Brush
*418	78-8015-7190-8	Roller - Wrap
422	78-8018-7506-9	Washer - Support, Thk.
*427	78-8015-7043-9	Spacer - Taping Head
429	78-8015-7029-8	Spring - Tape Cut-off
*432	78-8015-7036-3	Plate - Switch Actuator
*438	78-8018-7687-7	Rail - Upper Taping Head
*439	78-8015-7044-7	Rail - Lower Taping Head
*442	78-8015-7021-5	Roller - Taping Head Box Support No. 2
*443	78-8015-7030-6	Plate - Spring Retaining
*444	78-8015-7184-1	Stud-Lower Taping Head Support
460	78-8015-7212-0	Spring - Lower Head
*464	78-8015-7204-7	Shaft - Roller, Wrap
*465	70-8000-2843-6	Brush
*466	78-8015-7186-6	Roller - Taping Head Box Support
470	78-8005-5865-8	Bumper - 3M #SJ-5012, Black, Foot
*474	26-1000-1059-9	Screw - Cap, Hex Hd, 3/8-16 x 3/4 L SPS "LOC-WEL"
*475	78-8005-6119-9	Washer - Plain, Type A, 3/8 Narrow
*476	70-8000-5362-4	Screw-Cap, Hex Hd, 3/8-16 x 1 L SPS "LOC-WEL"
*477	70-8000-5382-2	Screw-Cap, Hex Hd, 5/16-18 x 3/4 L, SPS "LOC-WEL"
*478	70-8000-5390-5	Washer - Plain, Type A 5/16 Narrow
*482	70-7023-2000-6	Screw - Cap, Hex Hd, 1/4-20 x 7/8 L
*483	70-8000-4795-6	Washer - Plain, Type A, 1/4 Narrow
*484	26-1000-9786-9	Nut-Hex Lt, Full Ht, 1/4-20 ESNA 21NE-040
*486	78-8032-1469-7	Bearing-Plain, Flanged Nylon, Thomson No. 12L1-FF
*487	70-8000-5353-3	Screw-Mach, Hex Hd, Trim, 10-32 x 5/8 L
*491	78-8003-7829-7	Washer - Plain, Type A, #10 Narrow
*494	12-7995-9609-8	Screw-Cap, Soc Hd, 10-32 x 1/2 L SPS "LOC-WEL"
*497	78-8014-1717-7	Label-Caution
*498	26-1000-9785-1	Nut-Hex Lt. Full Ht, 10-32 ESNA No. 21NM-02

REPLACEMENT PARTS LIST
5A BOX SEALER MODEL 377
FIGURES 24 & 29 UPPER AND LOWER TAPING HEAD ASSEMBLIES
(Continued)

<u>REF. NO.</u>	<u>PART-NUMBER</u>	<u>PART NAME</u>
*499	77-8001-0390-3	Screw - Cap, Hex Hd, 1/2-13 UNC x 3/4 L
*500	18-9841-2803-5	Washer - Lock, Int. Tooth, Flat 1/2
*502	78-8015-7221-1	Nut Hanger
*503	70-8000-5409-3	Screw - Cap Hex Hd, 3/8-16 x 1 L

REPLACEMENT PARTS LIST
5A BOX SEALER MODEL 377
FIGURES 25 & 30 TAPE DRUM AND TENSION ROLLER - UPPER AND LOWER HEADS

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
*411	78-8015-7024-9	Shaft - Tape Drum and Tape Brake
423	78-8015-7160-1	Washer - Friction Brake
*424	78-8015-7034-8	Plate - Friction Brake
426	78-8015-7019-9	Washer - Support
*433	78-8015-7192-4	Bracket - Tape Drum Mounting
*448	78-8015-6672-6	Tape Drum Assy.
*449	78-8011-7376-2	Drum - Tape, 2 Inch
*450	78-8014-1030-5	Spring - Tape Core Engagement
*451	78-8005-5478-0	Screw - Self Tap, Phil Pan Hd, 10-14 x 1/2 L
*452	78-8014-1032-1	Roller - Tape Brake Assy.
*453	78-8014-1033-9	Roller, Tape Brake
*454	78-8032-1476-2	Bearing, Flange, "OILITE" #FF-838-1
*455	78-8032-4318-3	Bearing Sleeve, "OILITE" #AA-838-16
456	78-8033-0736-8	Washer - Spring, Belleville 1050 H/C St1. Metal Craft No. BEL-3201-140, .045 ± .010, 1.220 ± .010 x .800 ± .010 x .017 Thk.
*457	78-8015-6384-8	Disc - Brake
*468	78-8014-1755-7	Spacer
469	78-8033-0737-6	Collar-Threaded, Holokrome Clamp - Tite No. 15230 W/3/4-16 Thread
*475	78-8005-6119-9	Washer - Plain Type A, 3/8 Narrow
*476	70-8000-5362-4	Screw- Cap, Hex Hd, 3/8-16 x 1 L SPS "LOC-WEL"
*485	78-8032-4385-2	Washer - Shim, DE-STA-CO, .751 ID x .995 OD x .015 Thk.

REPLACEMENT PARTS LIST
5A BOX SEALER MODEL 377
FIGURES 26 & 31 APPLY ARM ASSEMBLY-UPPER AND LOWER HEADS

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
*380	78-8015-7112-2	Applying Arm Casting Assy.
*381	78-8015-7187-4	Applying Arm Casting - Lower
382	12-7997-0306-6	Ring - Tetaining, Push-On "TRUARC" No. 5005-87
383	78-8032-0215-5	Seal-Thomson No. S-500 Ball Bearing
384	26-1000-7542-8	Bearing-Ball Bush, Heim No. CLBB-500
*386	78-8015-7245-0	Bearing - Modified
*387	78-8015-7249-2	Applying Arm Casting Assy.
392	78-8015-7198-1	Vee Bar Assy.
*393	78-8015-7196-5	Bar - Vee
394	78-8015-7197-3	Spring - Vee Bar
395	78-8656-9001-6	Rivet, Tubular Semi .218 Dia. x .034 Ht. Oval Hd. 1/8 Dia. x 3/16 Lg. Stl. Cad. Pl.
*402	78-8015-7116-3	Roller Shaft Plate
407	78-8015-7194-0	Guide - Spring
408	78-8015-7244-3	Spring - Compression
410	78-8015-7110-6	Pin - Linear Bearing Shaft
*414	78-8015-7040-5	Plate - Roller Mounting Lt.
*419	78-8018-7508-5	Roller - Applying Assy.
*420	78-8018-7507-7	Roller - Applying
*421	78-8161-4231-5	Bearing-Flange "OILITE" No. FF-620-1
434	78-8015-7206-2	Block - Upper Head
435	78-8015-7219-5	Block - Stop, Lower Head
436	78-8015-7085-0	Shaft - Linear Bearing
437	78-8015-7158-5	Vee Roller
*441	78-8015-7051-2	Roller - Knurled
445	78-8015-7220-3	Applying Arm Block Assy.
*446	78-8015-7097-5	Block - Applying Arm
*447	70-8000-4194-2	Pin-Spring, 1/4 Dia. x 1 1/4 L.
462	78-8015-7191-6	Block - Stop, Upper Head
463	78-8015-7188-2	Washer - Rubber
472	78-8015-7060-3	Bumper - Casting
*484	26-1000-9786-9	Nut-Hex Lt, Full Ht, 1/4-20 ESNA 2INE-040
*488	70-8000-1598-7	Screw Hex Soc Flat Hd, #10-32 x 3/4 L SPS "LOC-WEL"
*493	70-8000-4988-7	Screw - Cap, Soc Hd, 1/4-20 x 2 L
*504	78-8015-7248-4	Applying Arm Casting - Upper
507	26-1000-0664-7	Washer, Spring Associated Spring #U500-0140
508	78-8018-7647-1	Stop - Buffing Arm
509	78-8018-7683-6	Stop Plate
510	70-8656-5956-2	Screw, Cap Soc. Hd. Hex, 10 - 32 x 1 1/2 L "LOC-WEL"

REPLACEMENT PARTS LIST
5A BOX SEALER MODEL 377
FIGURES 27 & 32 CUT-OFF ASSEMBLY - UPPER AND LOWER HEADS

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
*396	78-8015-7115-5	Guard - Blade Assy.
*397	78-8015-6969-6	Guard - Blade, Fixed Side
398	78-8015-7096-7	Guard - Blade, Moving Side
399	78-8014-1659-1	Pin - Blade Guard
400	78-8014-1220-2	Spring - Torsion
401	78-8015-7114-8	Pad - Blade Guard
440	78-8015-7072-8	Frame - Cut-Off
*442	78-8015-7021-5	Roller - Taping Head Box Support No. 2
*468	78-8014-1755-7	Spacer
470	78-8005-5865-8	Bumper - 3M #SJ-5012, Black Foot
471	78-8015-6605-6	Blade - 2 1/2 Inch
*486	78-8032-1469-7	Bearing - Plain, Flanged Nylon, Thomson No. 12L1-FF
*490	70-7023-3440-3	Screw - Cap, Soc Hd, 10-32 x 3/4 L
*491	78-8003-7829-7	Washer - Plain, Type A, #10 Narrow
*498	26-1000-9785-1	Nut - Hex Lt. Full Ht, 10-32 ESNA No. 21NM-02

REPLACEMENT PARTS LIST
5A BOX SEALER MODEL 377
FIGURES 28 & 33 BUFFING ARM ASSEMBLY - UPPER AND LOWER HEADS

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
*389	78-8015-7111-4	Arm - Buffing Assembly
*390	78-8015-7108-0	Arm - Buffing
*391	12-7996-1711-8	Bearing-Flange "OILITE" #FF 707-2
403	78-8015-7053-8	Roller - Buffing Assy.
*404	78-8015-7052-0	Roller - Buffing
*405	78-8161-4231-5	Bearing - Flange "OILITE" #FF-620-1
458	78-8015-7213-8	Spring - Torsion, Inner
459	78-8015-7214-6	Spring - Torsion, Outer
473	78-8015-7209-6	Sleeve - Torsion Spring
*495	78-8656-3974-0	Ring - Retaining, "TRUARC" #5100-50
*501	78-8015-7042-1	Shaft - Buffing Arm

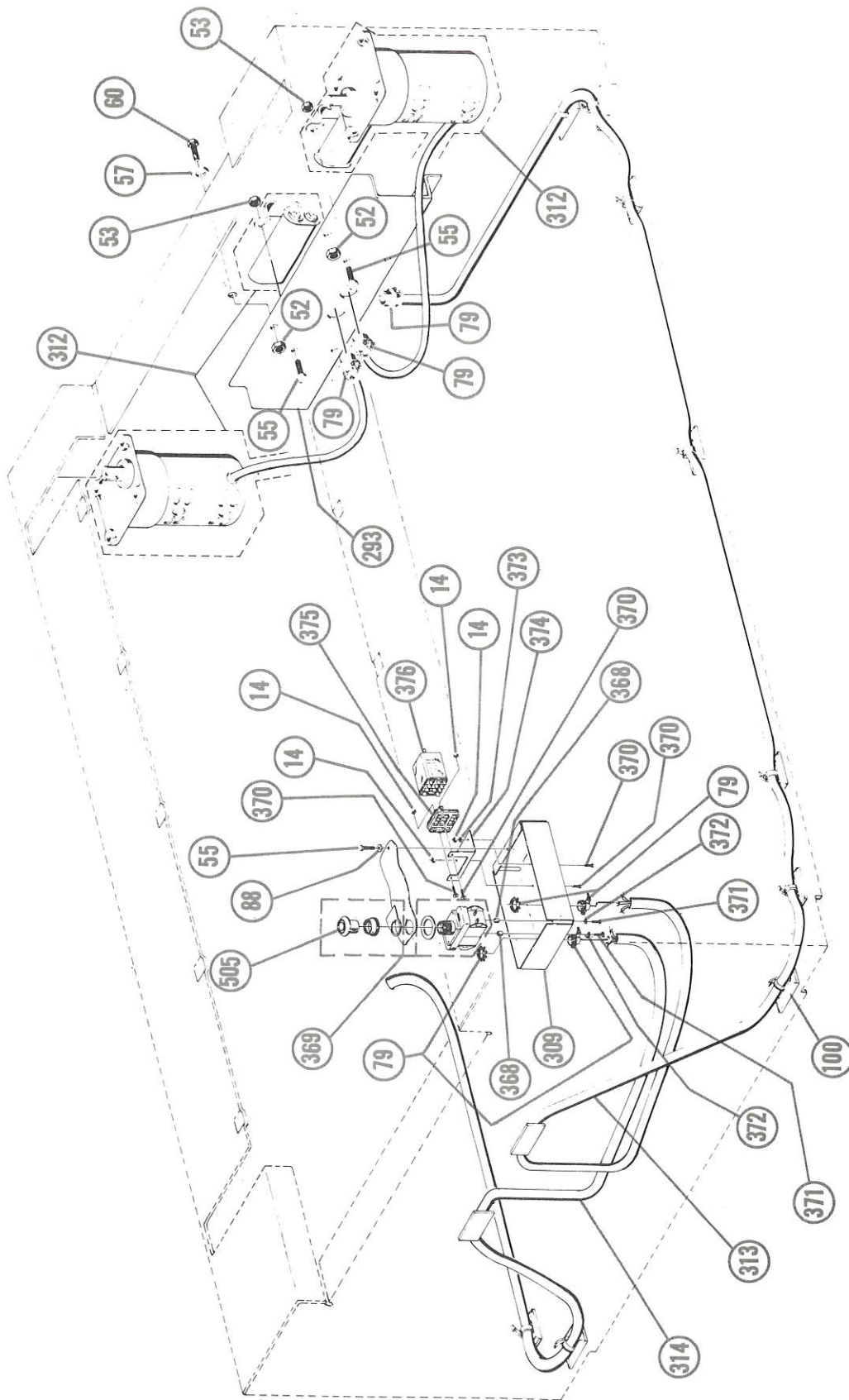


FIGURE 34 - ELECTRICAL COMPONENTS
Refer to page 54 for Electrical Components parts list.

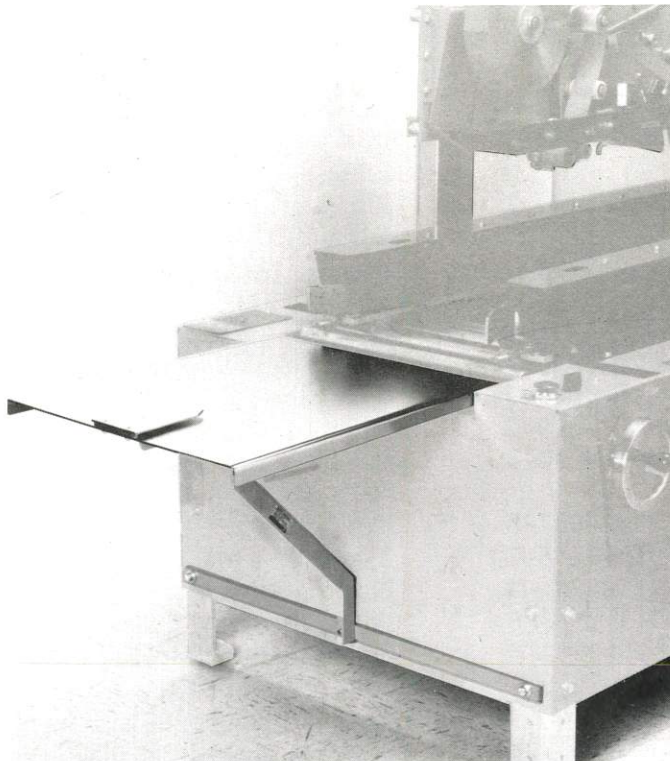
REPLACEMENT PARTS LIST
5A BOX SEALER MODEL 377
FIGURE 34 ELECTRICAL COMPONENTS

<u>REF. NO.</u>	<u>PART NUMBER</u>	<u>PART NAME</u>
* 14	26-1000-0663-9	Nut, Lt Hex, Full Ht. 6-32
* 52	26-1000-9786-9	Nut-Light Hex, Full Ht. 1/4-20 UNC ESNA #21NE-040
* 53	26-1000-9785-1	Nut-Light Hex, Full Ht. 10-32 UNF ESNA #21NM-02
* 55	70-8000-4787-3	Screw, Machine Hex Hd. Trimmed 10-32 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	78-8015-7241-9	Box, Switch
312	78-8015-7166-8	Motor - Gear
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
505	26-0001-7950-2	Cap - Mushroom, Color Cap Red, Allen-Bradley #800T-N160A

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

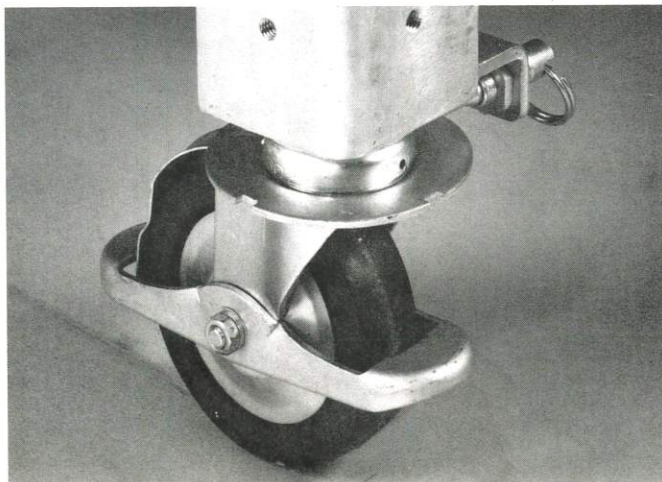
ATTACHMENTS

NOTE: The attachments listed below, when ordered with the standard 5A, are not assembled to the unit for shipping purposes.



P/N 78-8015-6965-4 PACKAGING PLATFORM ATTACHMENT
(Shown installed on 5A Box Sealer)

PURPOSE OF ATTACHMENT: The Packaging Platform Attachment with box holder, when installed on the 5A Box Sealer, provides an easy and convenient means for filling regular slotted containers prior to the sealing operation. The box holding feature frees the operator to use both hands for box filling.



P/N 78-8011-7023-0 Caster Attachment - Model 174

PURPOSE OF ATTACHMENT: The caster attachment, when installed on the Box Sealer, provides an easy and convenient means for moving the machine from one product packaging location to another.

FOR MORE INFORMATION ON THESE ATTACHMENTS, CONTACT YOUR 3M PACKAGING SYSTEMS REPRESENTATIVE.