

3M-Matic[™]

700a

Type 19000

Adjustable

Case Sealer

with

AccuGlide[™] II

Taping Heads

Important Safeguards

Turn to page three
for operating
safety information.

Important

It is recommended you immediately order the spare parts listed on page 33. These parts are expected to wear through normal use, and should be kept on hand to minimize production delays.

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3M Packaging Systems Division

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



Replacement Parts and Service Information

To Our Customers:

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

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

Technical Assistance:

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

Replacement Parts and Additional Manuals

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

3M/Tape Dispenser Parts

241 Venture Drive

Amery, WI 54001-1325

1-800/344 9883

FAX# 715/268 8153

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

\$10.00 restocking charge per invoice on returned parts.

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



3M Packaging Systems Division

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

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Instruction Manual
700a Adjustable Case Sealer
Type 19000

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Equipment Warranty and Limited Remedy: THE FOLLOWING WARRANTIES ARE MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, THE IMPLIED WARRANTY OF MERCHANTABILITY, THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE AND ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, A CUSTOM OR USAGE OF TRADE:

3M Sells its 3M-Matic™ 700a Adjustable Case Sealer, Type 19000 with the following warranties:

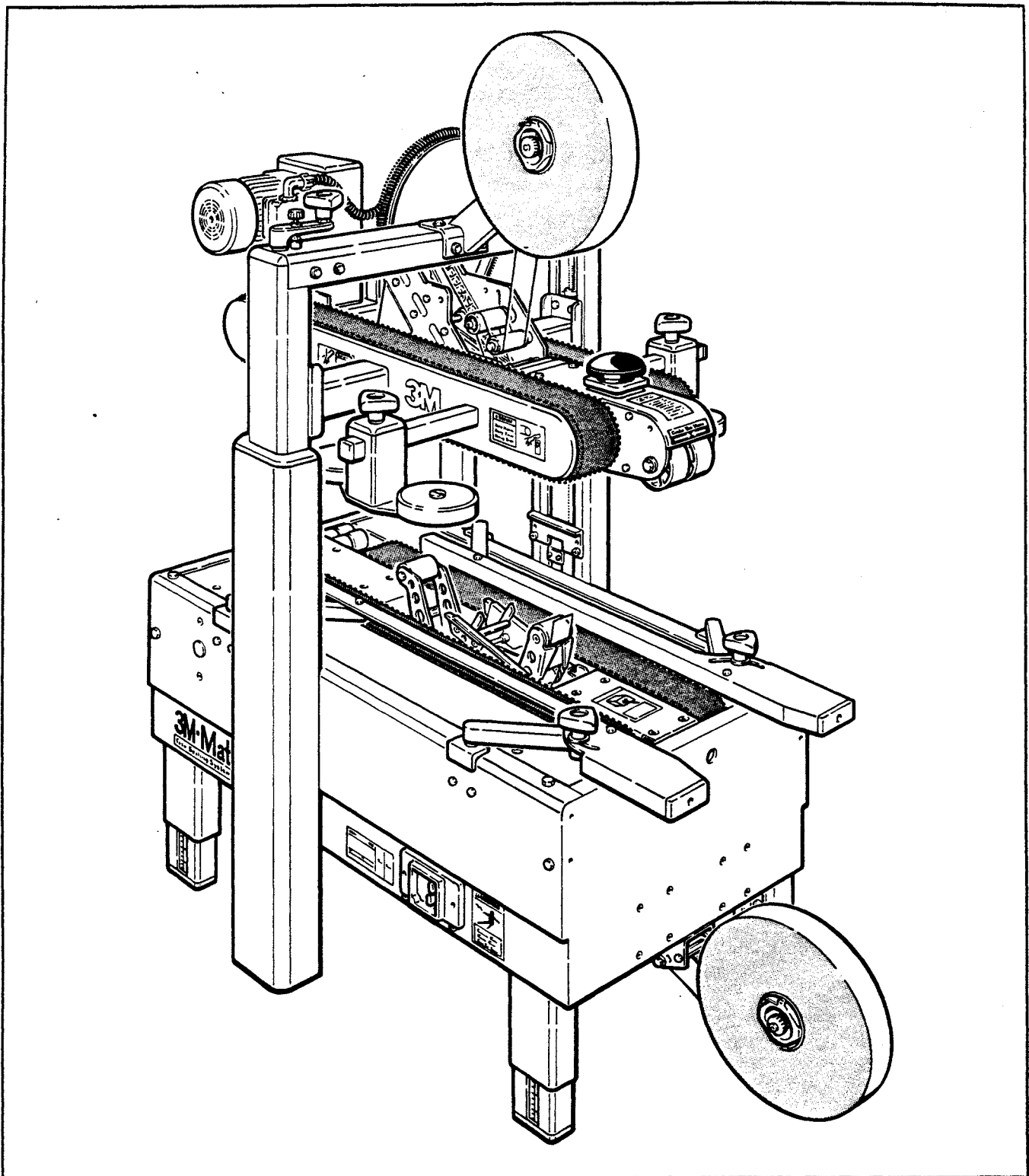
1. The Taping Head knife blades, springs and rollers will be free from all defects for ninety (90) days after delivery.
2. All other Taping Head parts will be free from all defects for three (3) years after delivery.
3. a. (for 200a, 700a, and 700r) The gearmotor will be free from all defects for one (1) year after delivery.
3. b. (for all other case sealers listed) The motor and transmission will be free from all defects for one (1) year after delivery.
4. All other parts will be free from all defects for ninety (90) days after delivery.

If any part is proved to be defective within its warranty period, then the exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to repair or replace the part, provided the defective part is returned immediately to 3M's factory or an authorized service station designated by 3M. A part will be presumed to have become defective after its warranty period unless the part is received or 3M is notified of the problem no later than five (5) calendar days after the warranty period. If 3M is unable to repair or replace the part within a reasonable time, then 3M, at its option, will replace the equipment or refund the purchase price. 3M shall have no obligation to provide or pay for the labor required to install the repaired or replacement part. 3M shall have no obligation to repair or replace (1) those parts failing due to operator misuse, carelessness, or due to any accidental cause other than equipment failure, or (2) parts failing due to non-lubrication, inadequate cleaning, improper operating environment, improper utilities, or operator error.

Limitation of Liability: 3M and seller shall not be liable for direct, indirect, special, incidental or consequential damages based upon breach of warranty, breach of contract, negligence, strict liability or any other legal theory.

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

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



"3M-Matic" 700a Adjustable Case Sealer - Type 19000 (Note - lower tape supply roll and bracket assembly are shown in the alternate location)

Description

The "3M-Matic" 700a Adjustable Case Sealer with "AccuGlide" II Taping Heads is designed to apply a "C" clip of "Scotch" brand Pressure-sensitive Film Box Sealing Tape to the top and bottom center seam of regular slotted containers. The 700a is manually adjustable to a wide range of box sizes (see box size specifications).

IMPORTANT SAFEGUARDS

There are four kinds of warning labels used on the case sealers.

The two illustrated labels (A-B), "Warning Sharp Knife" shown in figure 1-1, are attached to the sides of the upper frame at the location of the cut-off blade on the upper taping head. Two of the same labels are attached to the bed frame at the location of the cut-off blade on the lower taping head. The labels warn operators and service personnel of the very sharp knife used to cut the tape at the end of the tape application.

The "Warning - Sharp Knife" label (C), shown in figure 1-1, is attached to the orange cut-off blade guard on both taping heads. The label warns the operator and service personnel of the very sharp knife located behind the guard and to keep hands out of this area except for tape loading and/or servicing the taping heads.

The taping heads are equipped with a orange blade guard that covers the blade. The taping heads should never be operated with the blade guards removed.

Turn air and electrical supplies off before servicing the taping heads.

The taping heads should not be washed down or subject to conditions causing moisture condensation on components.

The "Warning - Hazardous Voltage" label, shown in figure 1-2, is attached to the frame next to the on/off switch control box. The label warns service personnel to unplug the power supply before attempting any service work on the case sealer.

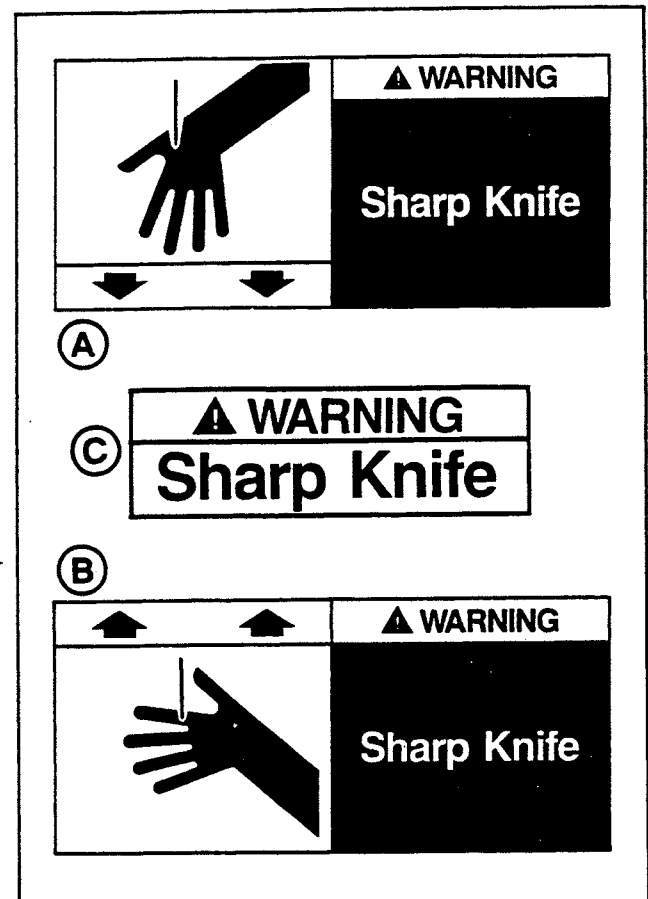


Figure 1-1 - Knife Warning Labels

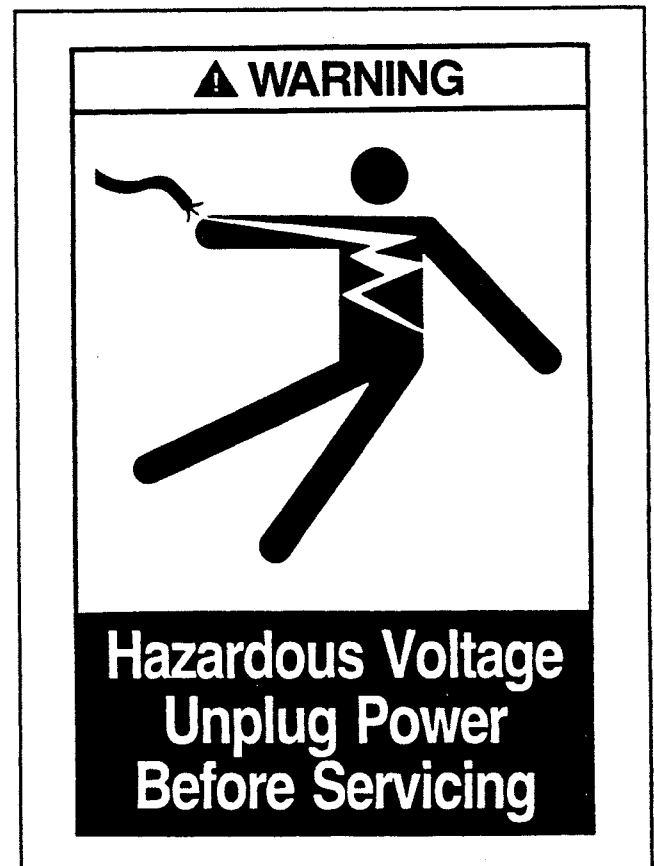


Figure 1-2 - Electrical Supply Warning Label

IMPORTANT SAFEGUARDS (Continued)

The two "Warning - Keep Hands Away From Moving Belts" labels, as shown in figure 1-3, are located on the right and left side panel of the upper head frame - infeed end. The labels warn operators and service personnel to keep hands away from this area when the drive belts are running.

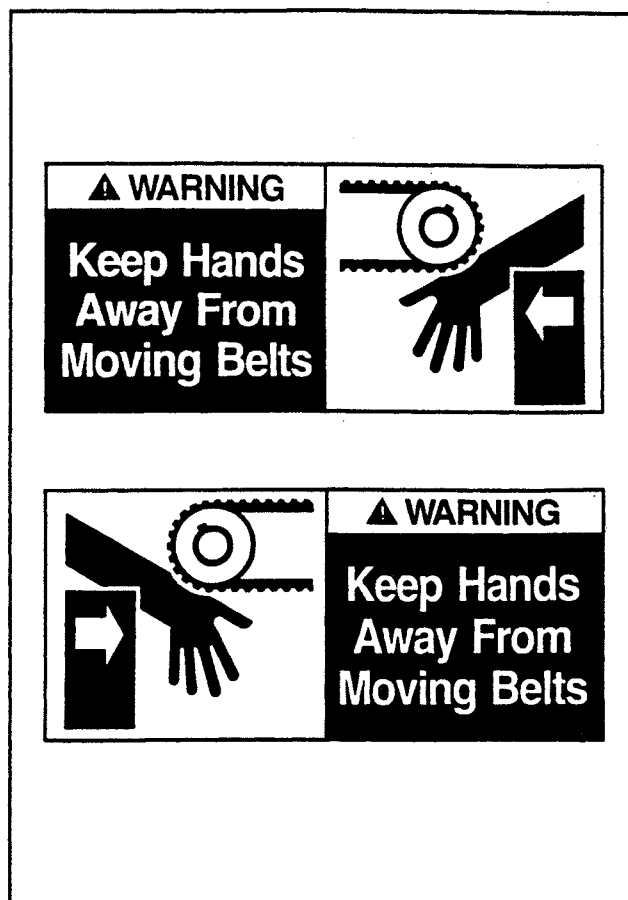


Figure 1-3 - Hands Warning Label

The "Caution - Keep Hands Out Of This Area" label, shown in figure 1-4, is attached to the center plate at the exit end of the bed frame. The label warns the operator to keep hands out of this area when the drive belts are running.

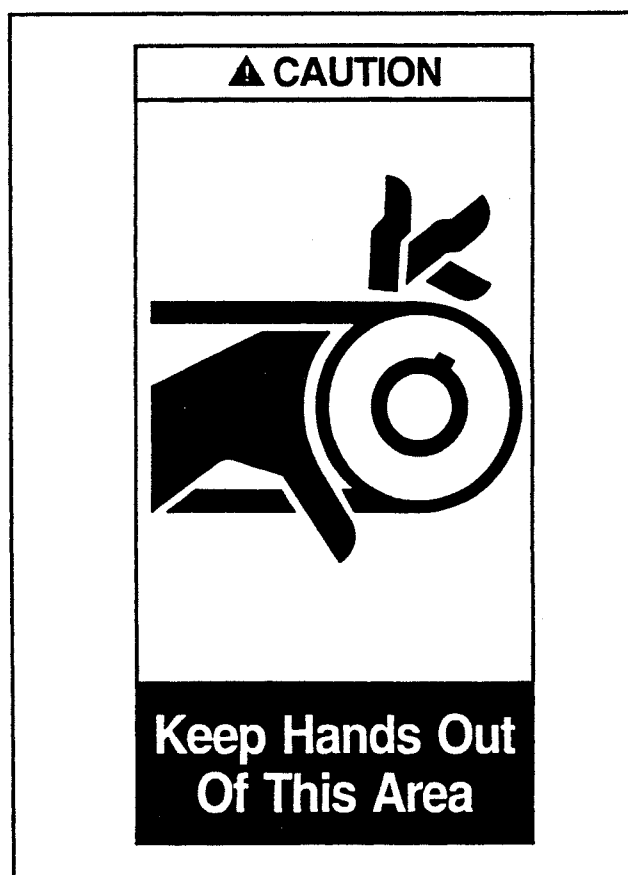


Figure 1-4 - Hands Caution Label

IMPORTANT SAFEGUARDS (Continued)

The second "Caution - Keep Hands Out Of This Area" label, shown in figure 1-5, is attached to the gear motor at the rear of the upper frame. It warns the operator to keep hands out of this area when the upper taping head mechanism is in operation.



Figure 1-5 - Hands Caution Label

The "Safety Instructions" label, shown in figure 1-6, is attached to the top front of the left hand adjustable side guide. The label provides convenient safeguard instructions for the operator and service personnel.

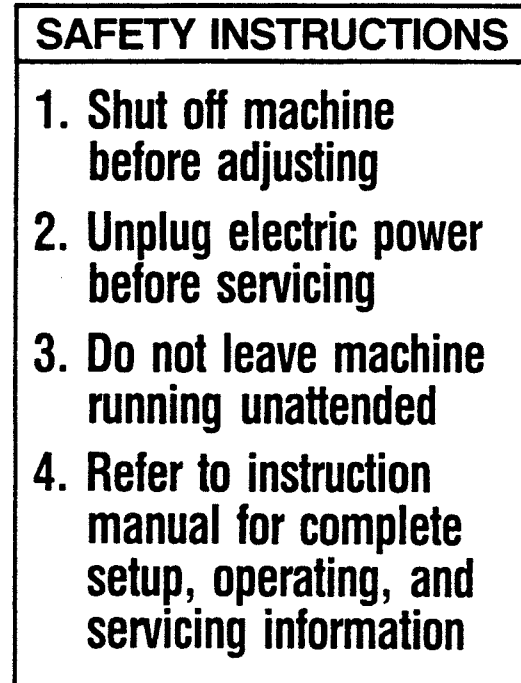


Figure 1-6 - Safety Instructions Label

IMPORTANT SAFEGUARDS (Continued)

There are three operating note labels on the case sealer to remind the operator of important operating procedures.

The "Center Box Here" label, shown in figure 1-7, is attached to the front of the upper frame to remind the operator of the proper placement procedure.

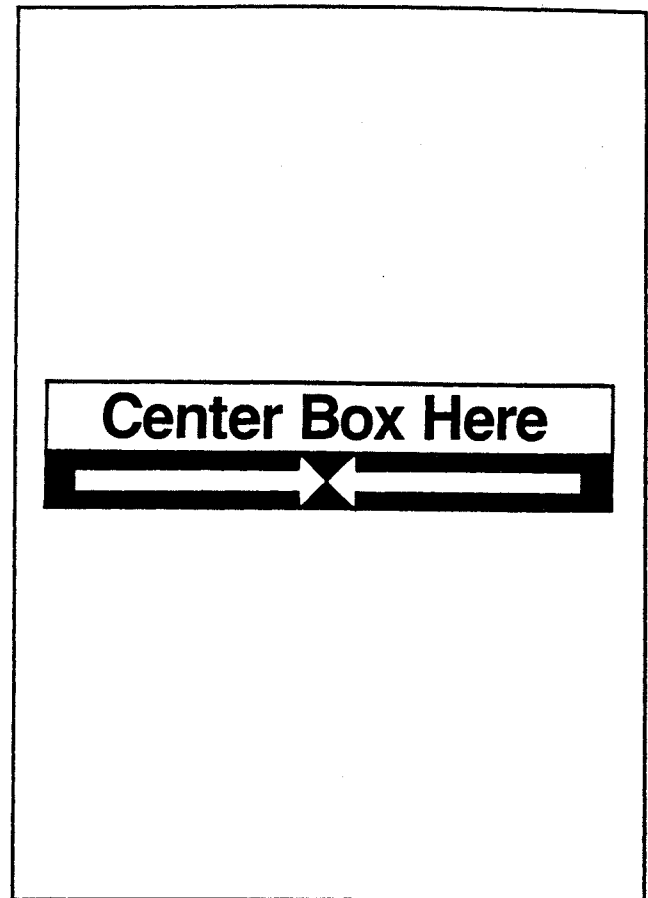


Figure 1-7 - Center Box Label

The "Notice - Feed Box From This End" label, shown in figure 1-8, is attached to the center plate at the infeed end of the bed frame. It alerts the operator that this is the infeed end of the case sealer.



Figure 1-8 - Box Feed Label

IMPORTANT SAFEGUARDS (Continued)

The "Tape Threading Label", shown in figure 1-9, is attached to the left side of both the upper and lower taping heads. This label provides a convenient tape threading diagram. More detailed tape loading and threading information is provided in this manual in the set-up procedure section.

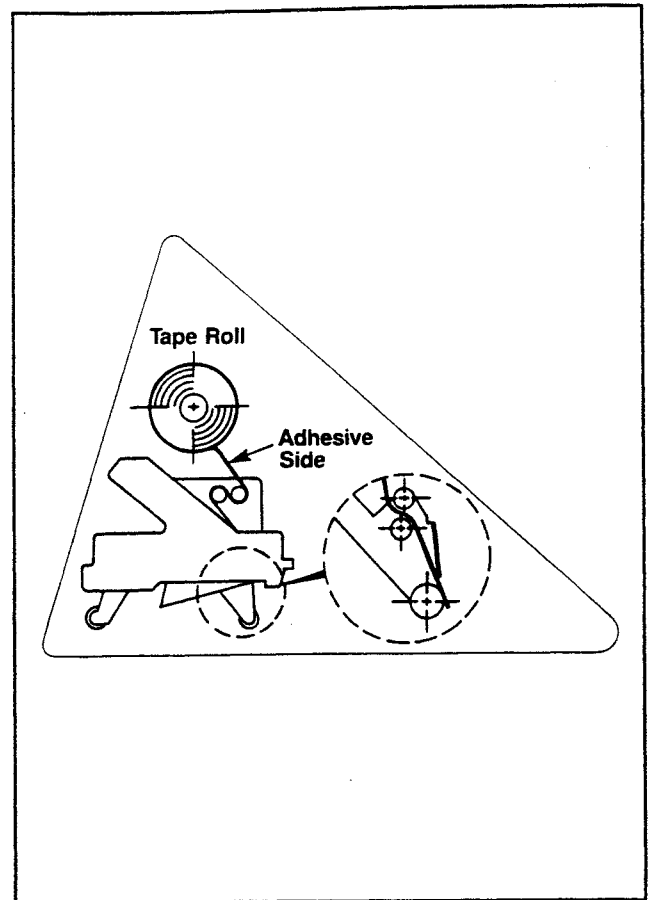


Figure 1-9 - Tape Threading Label

The 700a is equipped with a centrally located stop switch, shown in figure 1-10. This pushbutton switch is accessible from either side of the machine for operator convenience.

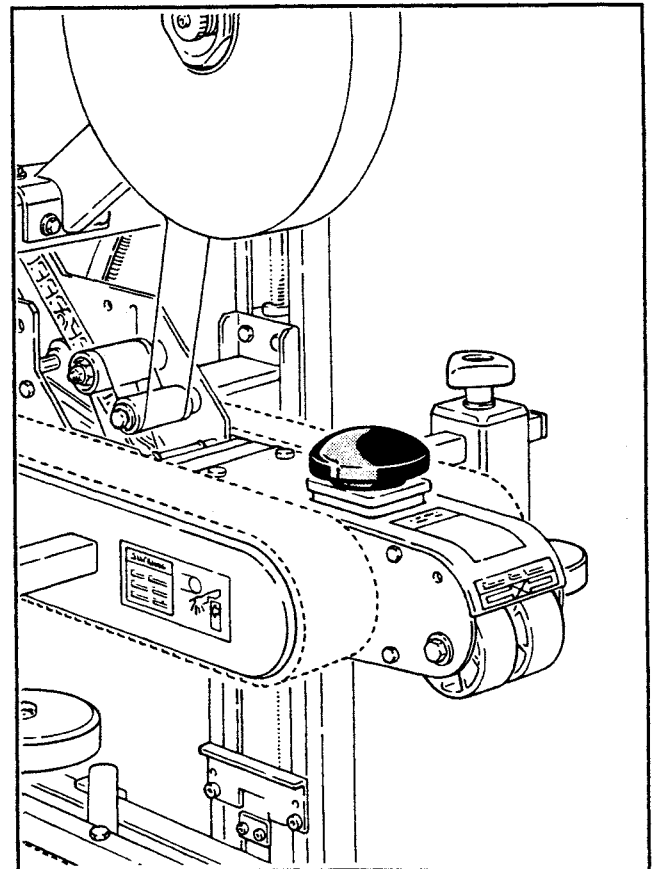


Figure 1-10 - Centrally Located Stop Switch

Specifications

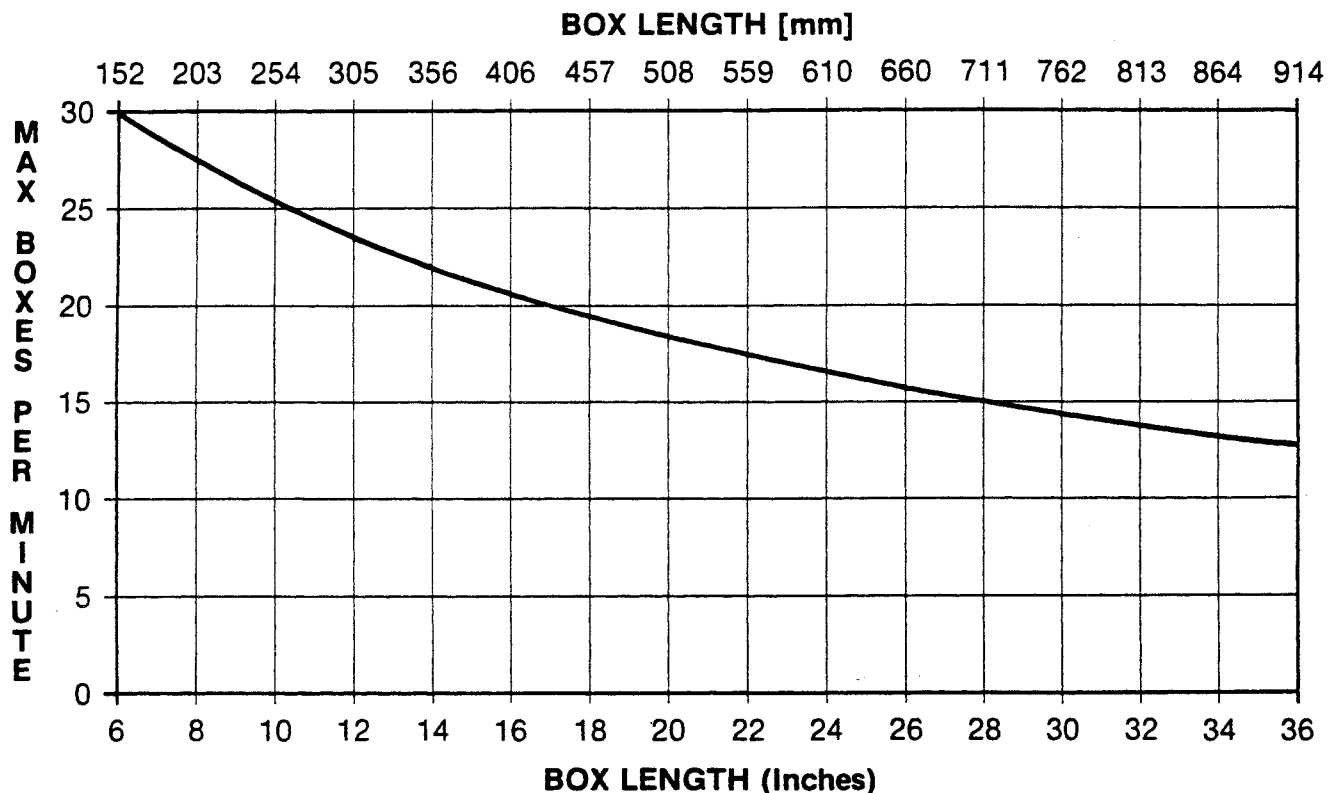
1. Power Requirements:

Electrical - 115 VAC, 60 Hz, 3.8A

The machine is equipped with an 8 foot [2,4 m] standard neoprene covered power cord and a grounded plug. Contact your 3M Representative for power requirements not listed above.

2. Operating Rate:

BOXES PER MINUTE VS. BOX LENGTH



Actual production rate is dependent on operator's dexterity.

Boxes must be 18 inches [455mm] apart minimum.

3. Operating Conditions:

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

IMPORTANT SAFEGUARD

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

(Specifications continued on next page.)

Specifications (Continued)

4. Tape:

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

5. Tape Width:

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

6. Tape Roll Diameter:

Up to 16 inches [405 mm] maximum on a 3 inch [76,2 mm] diameter core.
(Accommodates all system roll lengths of "Scotch" brand film tapes.)

7. Tape Application Leg Length - Standard:

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

Tape Application Leg Length - Optional:

2 inches \pm 1/4 inch [50 mm \pm 6 mm]

8. Box Board:

Style - regular slotted container - RSC
125 to 275 P.S.I. bursting test, single wall or double wall B or C flute.

9. Box Weight and Size Capacities:

A. Box weight, up to 85 lbs. [38,6 kg] **maximum** - contents must support flaps.

B. Box size:	Minimum	Maximum
Length -	6.0 inches [150 mm]	unlimited
Width -	5.5 inches [140 mm]*	21.5 inches [550 mm]
Height -	4.8 inches [120 mm]**	24.5 inches [620 mm]

* **Note:** Cartons narrower than 10 inches [250 mm] in width may require more frequent belt replacement because of limited contact area.

** 3.5 inches [90 mm] height with heads adjusted to apply 2 inch [50 mm] tape legs lengths.

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

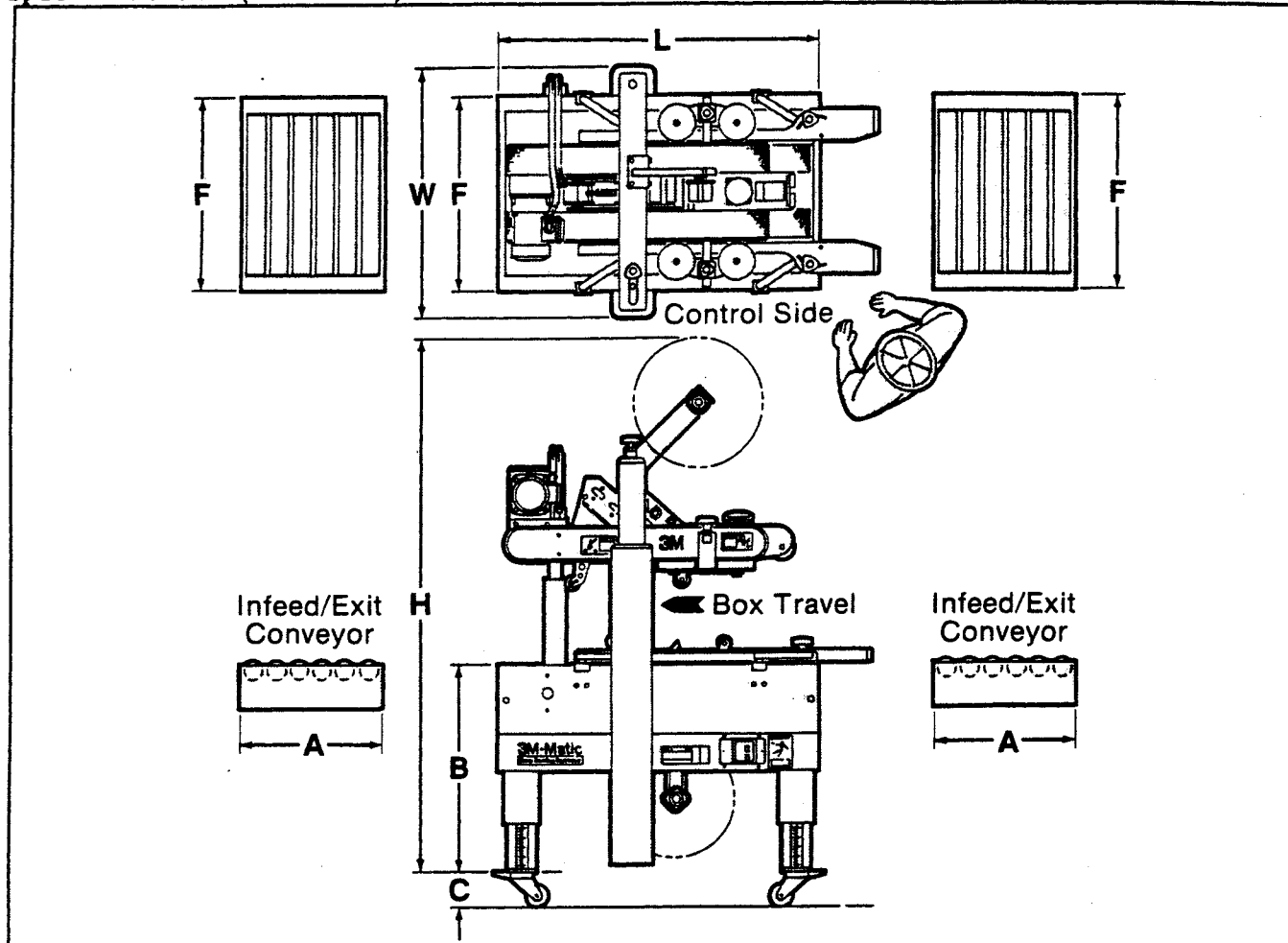
Note: The 3M-Matic 700a Adjustable Case Sealer can accommodate most boxes within the size range listed above. However, if

BOX LENGTH IN DIRECTION OF SEAL **IS LESS THAN .5**
BOX HEIGHT

boxes should be test run to assure proper machine performance.

(Specifications continued on next page.)

Specifications (Continued)



10. Machine Dimensions:

	W	L	H	A*	B	C**	F
Minimum							
inches [mm]	31 [790]	40 1/2 [1030]	53 [1350]	18 [455]	24 [610]	4 [100]	24 1/2 [625]
Maximum							
inches [mm]	--	--	86 [2185]	--	35 [890]	--	--

* Infeed/Exit conveyors are optional

** Casters are optional

Weight - approximate 400 pounds [180 kg] crated
 approximate 350 pounds [160 kg] uncrated

11. Set-Up Recommendations:

- > Machine must be level.
- > Customer supplied infeed and exit conveyors (if used) should provide straight and level box entry and exit.
- > Exit conveyors (powered or gravity) must convey sealed boxes away from machine.

Set-Up Procedure

It is recommended that the 700a Case Sealer be set-up and operated with product before placing it in the production line. This approach will allow your thorough review and familiarization with the 700a before subjecting it and operating personnel to a production situation where time for set-up, adjustments, and operator training usually becomes limited.

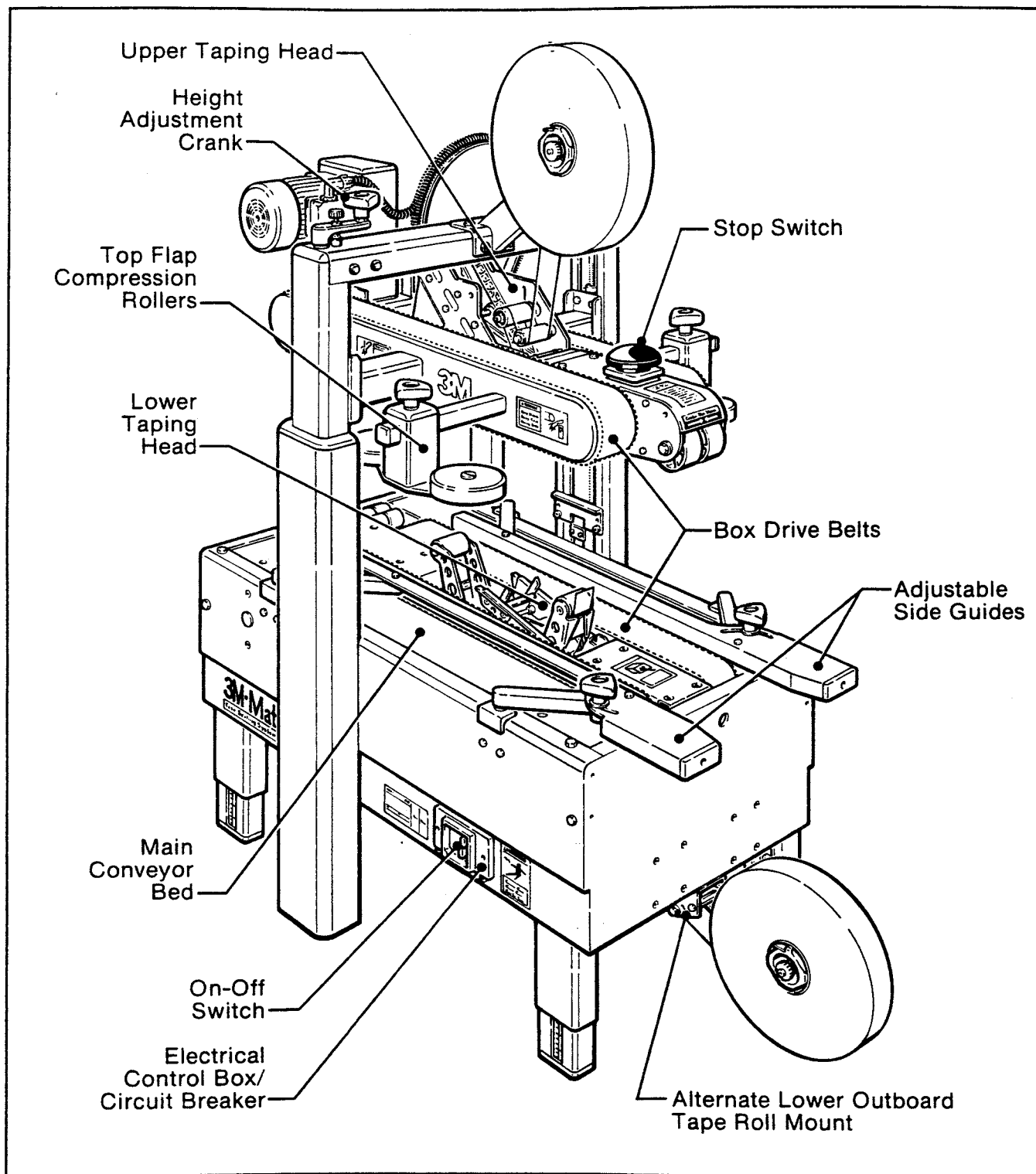


Figure 2-1 - Set-Up Instructions - Case Sealer Components - Left Front View

Set-Up Procedure (Continued)

Receiving And Handling

After the machine has been uncrated, examine the Case Sealer for damage that might have occurred during transit. If damage is evident, file a damage claim immediately with the transportation company and also your 3M Representative.

The following instructions are presented in the order recommended for setting up and installing the case sealer, as well as for learning the operating functions and adjustments. Following them step by step will result in your thorough understanding of the machine and an installation in your production line that best utilizes the many features built into the case sealer.

1. Lift off fiberboard cover from pallet after removing staples at bottom.
2. Remove the two "U" shaped hold down clamps from lower cross bar. These are sheet metal brackets that prevent the upper head assembly from bouncing during shipping.
3. Install the crank handle on the top of the left column, as shown in figure 2-2A.
4. Install the upper tape drum bracket on the top cross bar as shown in figure 2-2B.
5. Raise upper head assembly (turn crank handle counterclockwise). Remove the two lower brackets and discard. Install the two stop brackets (provided in the parts bag). Use the lower set of holes as shown in figure 2-2C. The upper set of holes should only be used when both taping heads are adjusted to apply 2 inch tape legs.
6. Ensure that the tape drum bracket assembly, located on the lower taping head, is mounted straight down, as shown in figure 2-3A. The tape drum bracket assembly can be pivoted to provide clearance or for retrofit in certain cases.

Lower Outboard Tape Roll Mount - Alternate:

Remove the tape drum bracket assembly, stud spacer and fasteners from the lower taping head. Install and secure on the infeed end of the lower frame, as shown in figure 2-3B.

Conveyor Bed Height:

The case sealer is equipped with four adjustable legs that are located at the corners of the frame. The legs can be adjusted to obtain different machine conveyor bed heights from 24 inches [610 mm] minimum to 35 inches [890 mm] maximum.

Refer to Figure 2-3C and set the conveyor bed height as follows:

1. Block up the machine frame to allow adequate leg adjustment.
2. Loosen, but do not remove, two M8 x 1,25 mm socket head screws in one leg (use M6 hex wrench). Adjust the leg length for the desired conveyor bed height. Retighten the two screws to secure the leg. Adjust all four legs as noted.

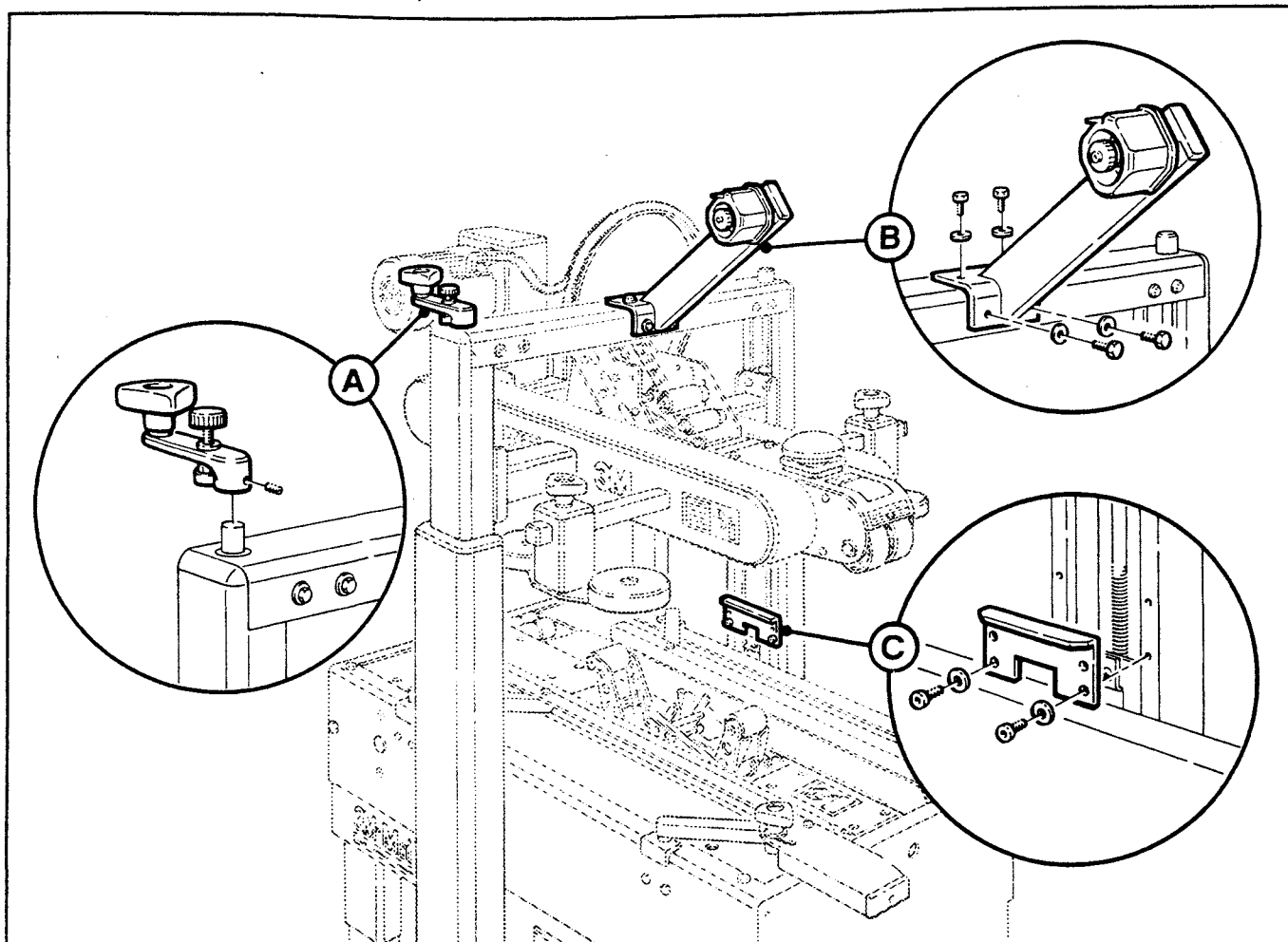


Figure 2-2 - Set-Up and Installation

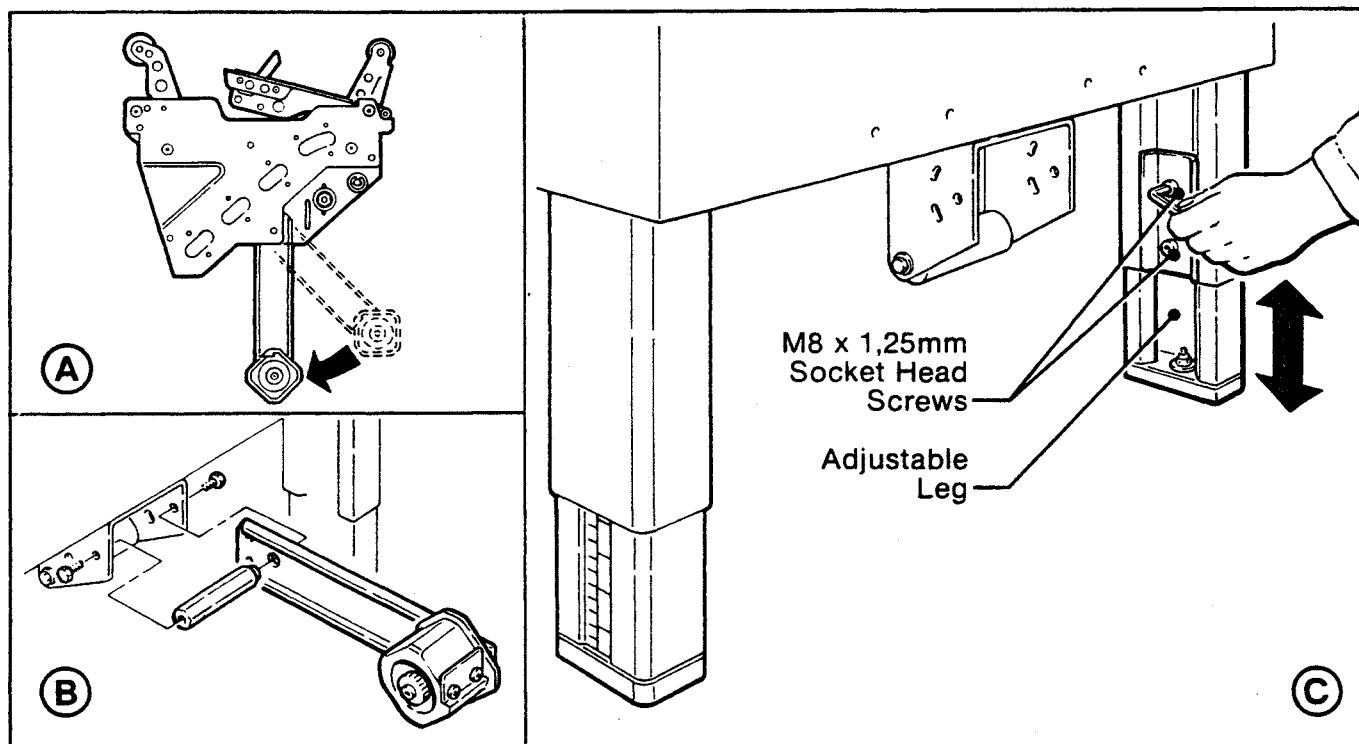


Figure 2-3 - Conveyor Bed Height Adjustment and Lower Tape Drum Bracket Position

IMPORTANT SAFEGUARDS

1. BOTH THE UPPER AND LOWER TAPING HEADS UTILIZE EXTREMELY SHARP KNIFE BLADES. THESE BLADES ARE LOCATED UNDER THE ORANGE BLADE GUARD WHICH HAS THE "WARNING - SHARP KNIFE" LABEL. BEFORE WORKING WITH THE TAPING HEADS OR ATTEMPTING TO LOAD THE TAPE, REFER TO FIGURES 2-4 AND 2-5 AND IDENTIFY THE BLADE LOCATION. KEEP HANDS OUT OF THESE AREAS EXCEPT AS NECESSARY TO SERVICE THE TAPING HEADS.
2. NEVER ATTEMPT TO WORK ON THE TAPING HEADS OR LOAD TAPE WHEN THE BOX DRIVE BELTS ARE RUNNING.
3. BOX DRIVE MOTORS ARE DESIGNED TO RUN AT A MODERATE TEMPERATURE OF 120° F [50° C]. IN SOME CASES THEY MAY FEEL WARM TO THE TOUCH.

Tape Loading:

The taping head accommodates up to 2 inch [50 mm] wide tape rolls. To apply 1 1/2 inch or 36 mm or 1 3/4 inch or 42 mm wide tapes, refer to "Adjustments Section" for set-up information.

A plastic threading needle is provided with each machine and it is recommended that the detailed instructions and sketches in this manual be referred to the first few times the unit is loaded and until the operator becomes thoroughly familiar with the tape loading operation.

Tape Loading - Upper Taping Head



WARNING - TURN OFF ELECTRICAL POWER SUPPLY AND DISCONNECT POWER CORD FROM ELECTRICAL SUPPLY BEFORE BEGINNING WORK ON THE TAPING HEADS OR TO LOAD TAPE IF POWER CORD IS NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.
--

1. It is first necessary to raise the upper taping head frame to a convenient working position.
2. For tape loading operations, use the plastic threading needle and follow the loading procedures (figures 2-6 to 2-8) to complete the tape threading.

Tape Loading - Lower Taping Head

1. For ease in set-up loading, first remove the lower taping head from the conveyor bed. Lift the head straight up from the conveyor bed.
2. The lower taping head is loaded and threaded in the same manner as the upper taping head. Follow the upper taping head tape loading procedure.
3. Replace the lower taping head.

Set-Up Procedure (Continued)

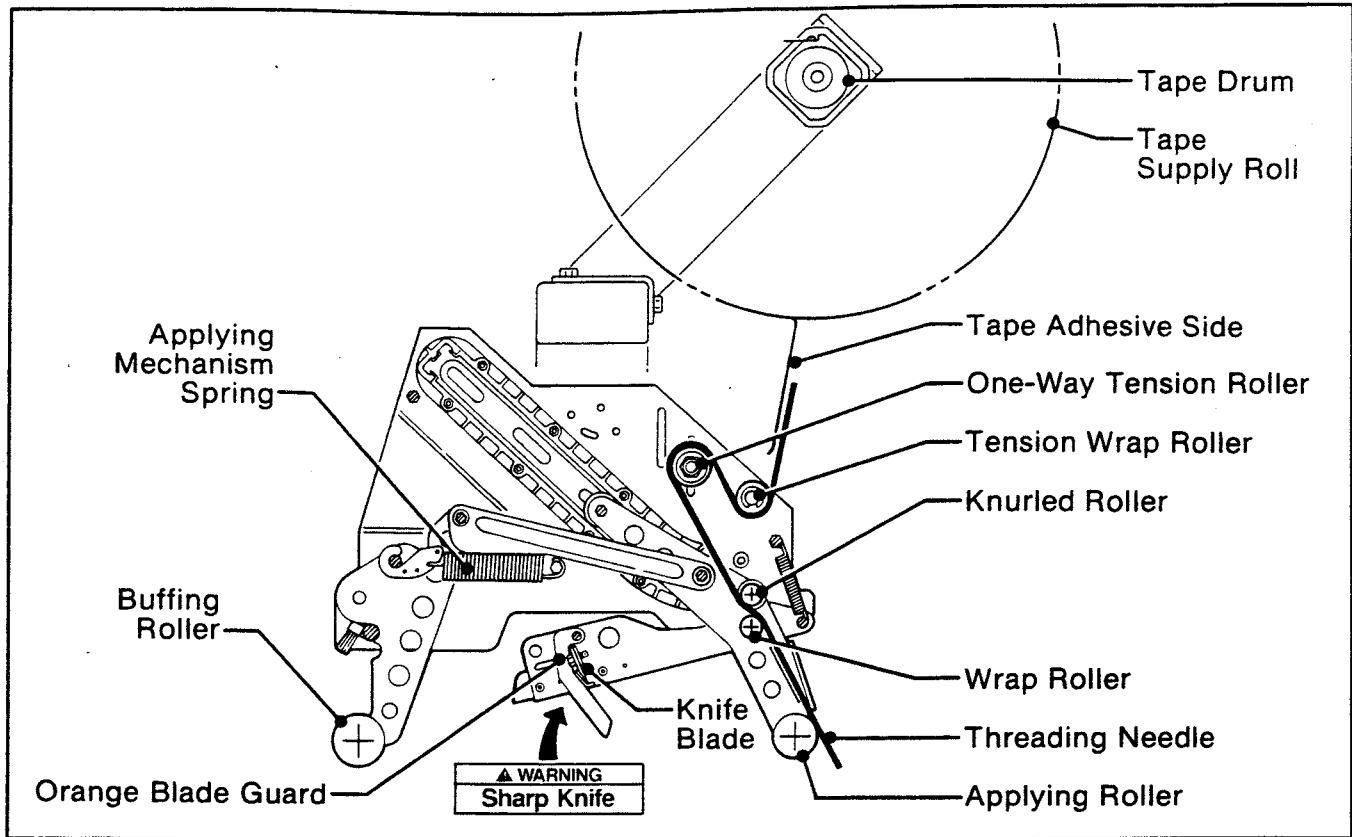


Figure 2-4 - Tape Threading Diagram - Upper Taping Head - Left Side View

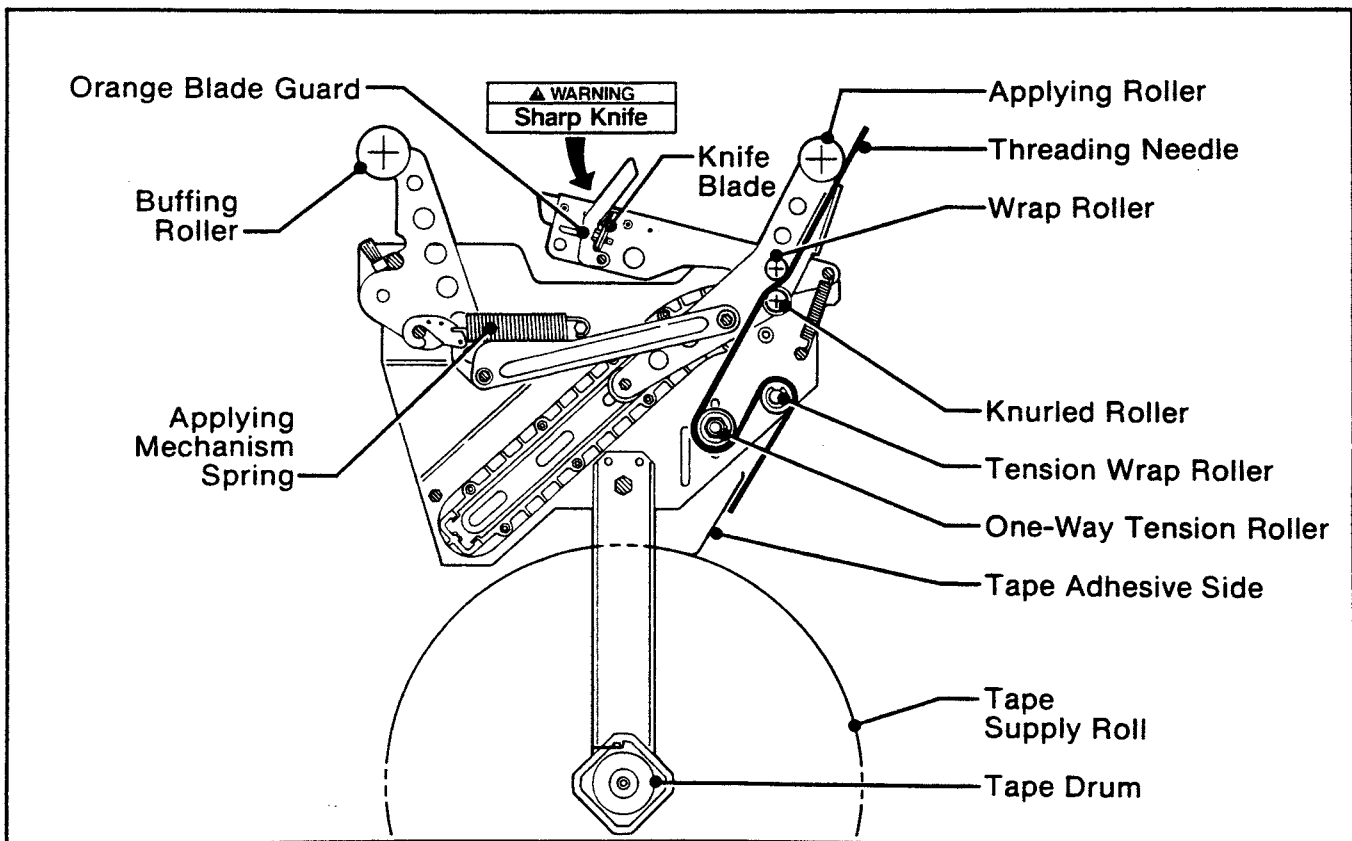


Figure 2-5 - Tape Threading Diagram - Lower Taping Head - Left Side View

Set-Up Procedure (Continued)

Figure 2-6

Insert the plastic needle downward around rollers as illustrated.

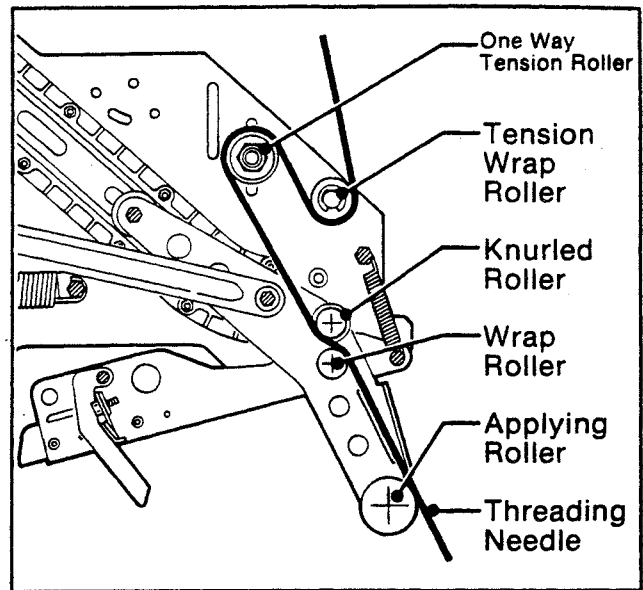


Figure 2-6

Figure 2-7

Place tape roll on drum to dispense tape from bottom of roll adhesive side forward. Seat tape roll fully against back flange of drum. Adhere tape lead end to upper end of threading needle as shown.

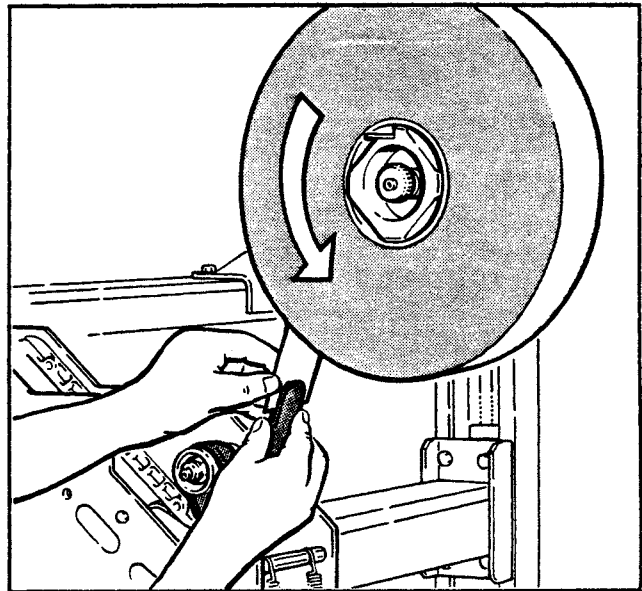


Figure 2-7

Figure 2-8

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

Manually turn tape roll to create slack tape while pulling threading needle through tape applying mechanism until needle is through and tape is in alignment with applying roller.

Excess tape should be cut with a scissors at applying roller.

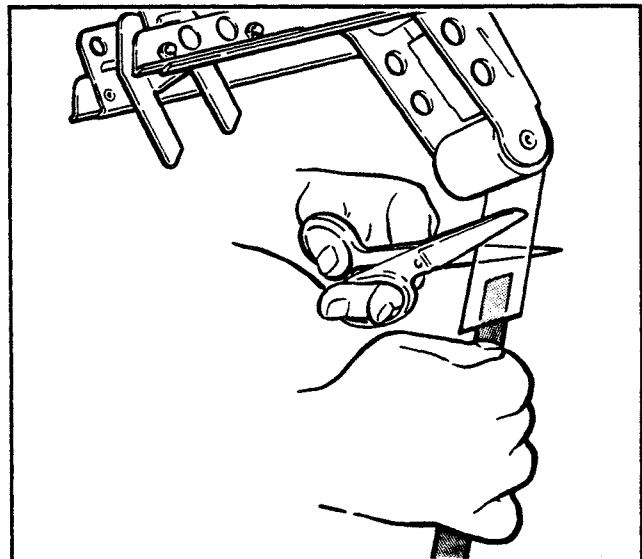


Figure 2-8

Set-Up Procedure (Continued)

Electrical Connection

The electrical control box, shown in Figure 2-1, contains the "On-Off" switch with pre-set circuit breaker and can be located on either side of the main conveyor for customer operating convenience. An 8 foot [2,4 m] standard three conductor power cord with plug is provided at the back of the electrical control box for 115 Volt, 60 Hz electrical service. The receptacle providing this service shall be properly grounded. Before the power cord is plugged into 115 Volt, 60 Hz outlet, make sure the switch is "Off" and that all packaging materials and tools are removed from the machine.

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

Box Size Set-Up and Operation

Figure 2-9

Once both taping heads are loaded with tape, the upper taping head can be positioned for the box height being sealed by means of the height adjustment crank. Turn clockwise to lower head, counterclockwise to raise head.

Move the top flap compression rollers to a position wider than the box.

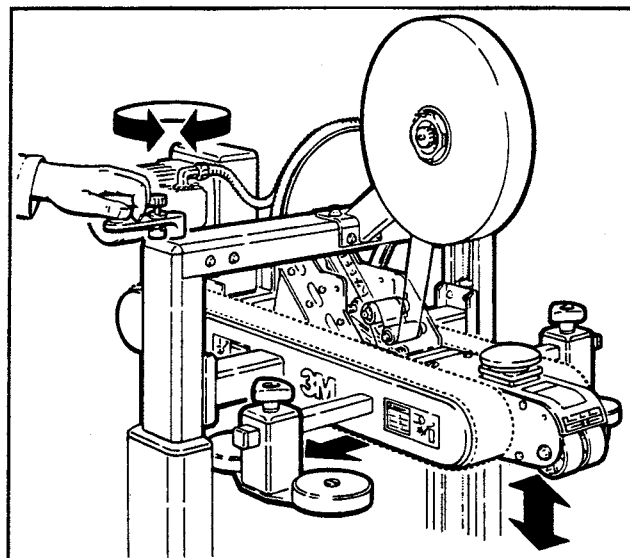


Figure 2-9

Figure 5

Place box on infeed end of frame bed with both top and bottom flaps folded and insert under upper head frame approximately 6 inches [50 mm]. Lower the head frame until all flaps are fully closed. Align box top flap center seam with arrows on front of upper frame.

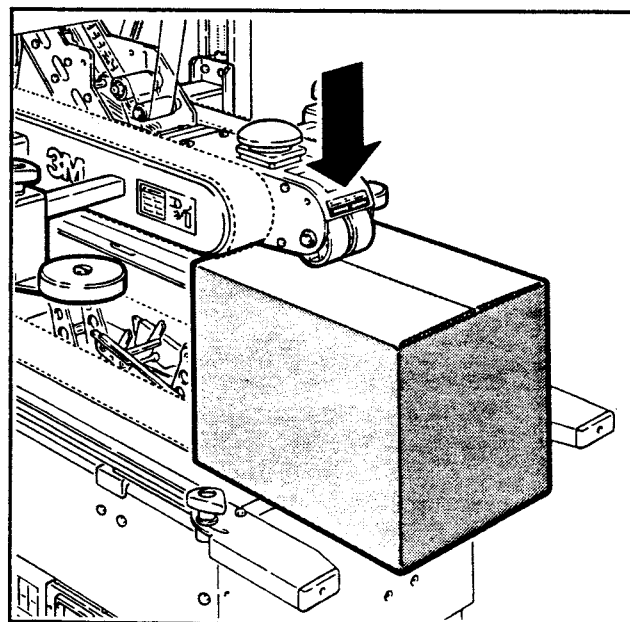


Figure 2-10

Set-Up Procedure (Continued)

Figure 2-11

Move side guides against each side of box to hold box in position, centered on arrows on front of ski. Tighten hand knobs to secure side guides.

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

Figure 2-12

Turn electrical switch to "On" to start drive belts. Move box forward under upper taping head until it is taken away by drive belts. If box is hard to move under head or is crushed, raise upper head slightly. If box movement is jerky or stops under upper head, lower head frame slightly to add more pressure between box and drive belts.

Note: Upper head has unique feature for overstuffed boxes. The head will raise up to 1/2 inch [13 mm] to compensate for this type of condition.

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

Top Flap Compression Rollers

Figure 2-13

The top flap compression rollers, have two mounting positions to provide side compression through the full range of box widths.

The rollers have been pre-assembled in position B to accommodate box widths from 8 inches [200 mm] to 21 1/2 inches [545 mm] maximum. To accommodate box widths less than 8 inches [200 mm] to 5 1/2 inches [140 mm] minimum, move all four rollers to position A.

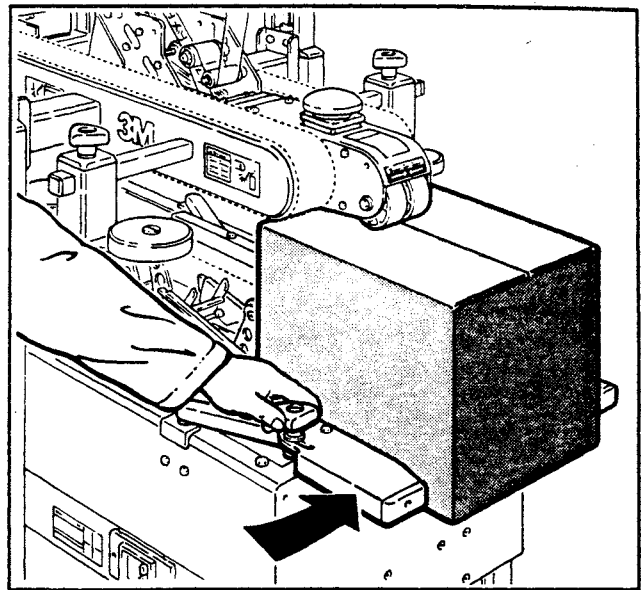


Figure 2-11

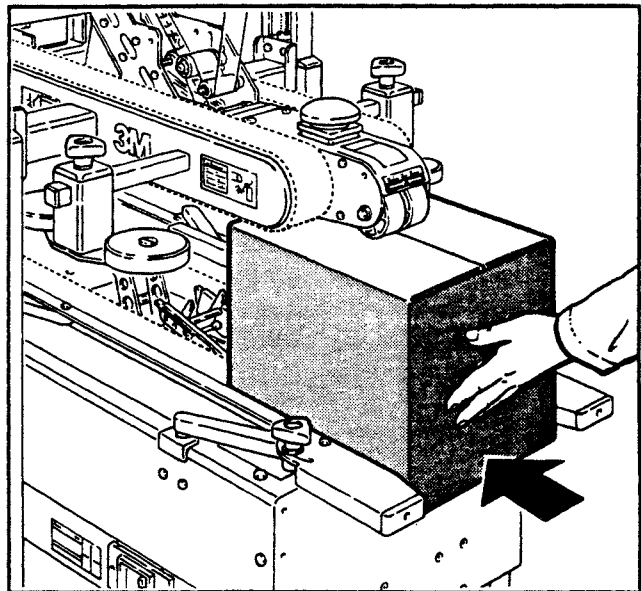


Figure 2-12

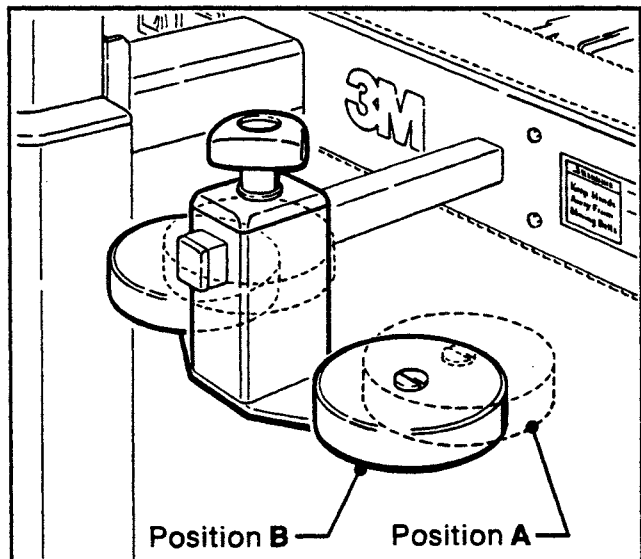


Figure 2-13

Set-Up Procedure (Continued)

Figure 2-14

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

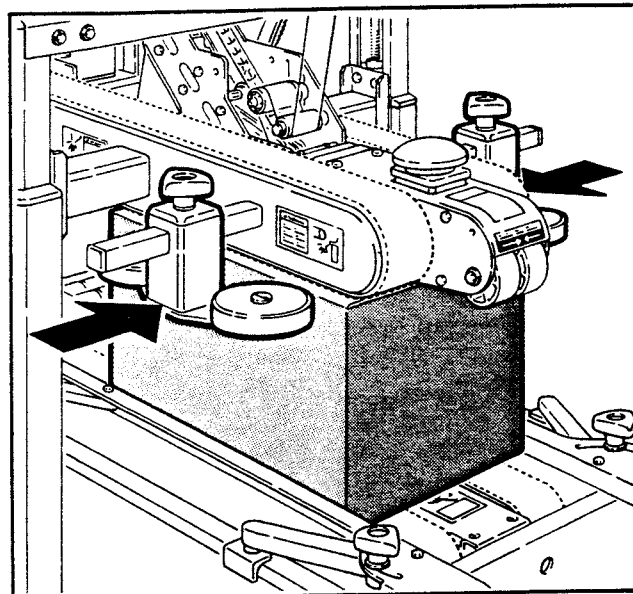


Figure 2-14

Adjustments

Tape Web Alignment

Figure 3-1

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

1. Loosen the locking hex nut behind tape drum on tape drum shaft. Use an adjustable wrench or 25 mm open end wrench.
2. Turn tape drum shaft in or out to center the tape web (use 5 mm hex wrench).
3. Tighten hex nut to secure the adjustment.

No other components require adjustment for tape web alignment.

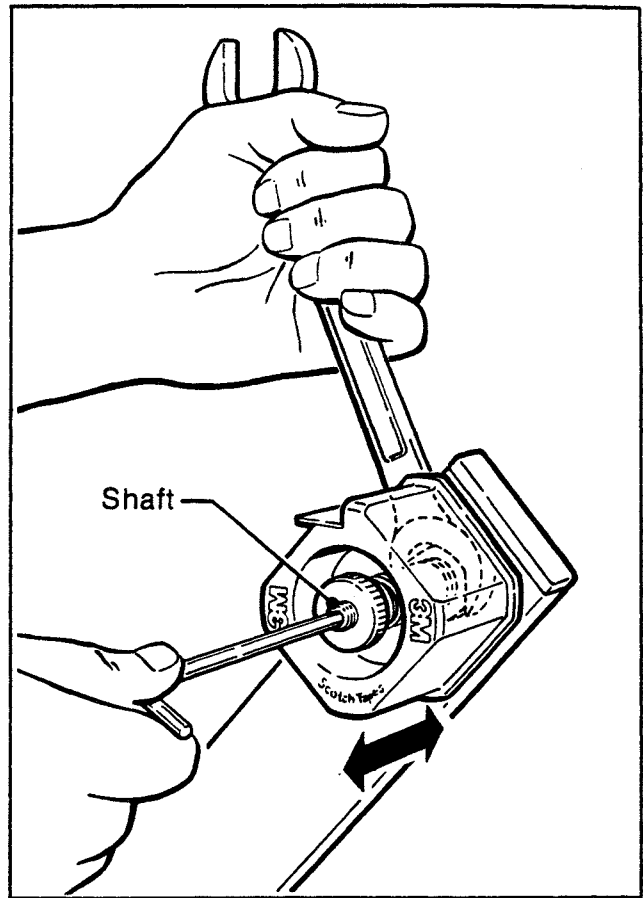


Figure 3-1

Tape Drum Friction Brake

Figure 3-2

The tape drum friction brake on each taping head is pre-set for normal operation to prevent tape roll over travel. Should tension adjustment be required, turn the thumbwheel on the shaft to vary compression of the spring. Turn thumbwheel clockwise to increase the braking force, and counterclockwise to decrease the braking force. Adjust to minimum tension that prevents excessive tape roll over travel.

Notice - excess braking force will cause poor tape application and may lead to tape tabbing on the trailing tape leg.

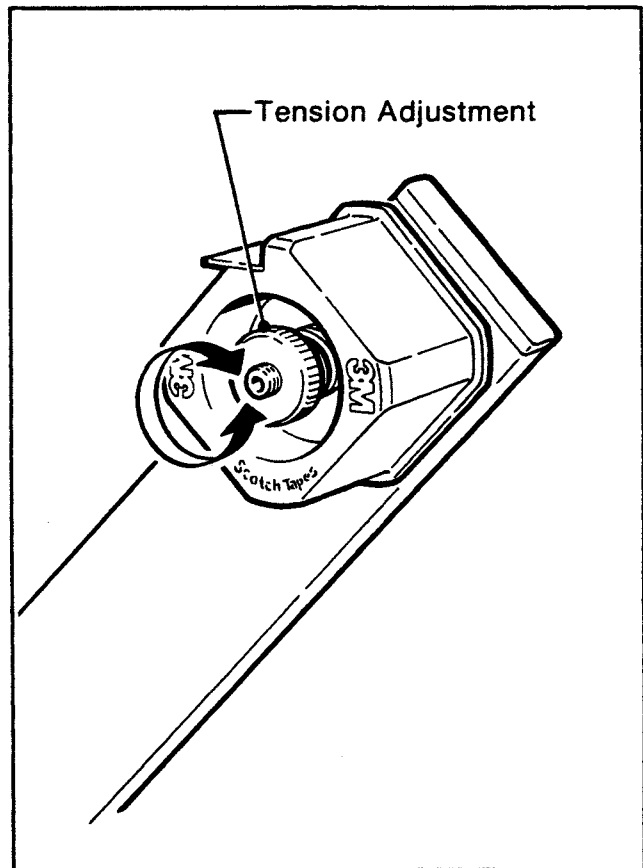


Figure 3-2

Set-Up Procedure (Continued)

Figure 2-14

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

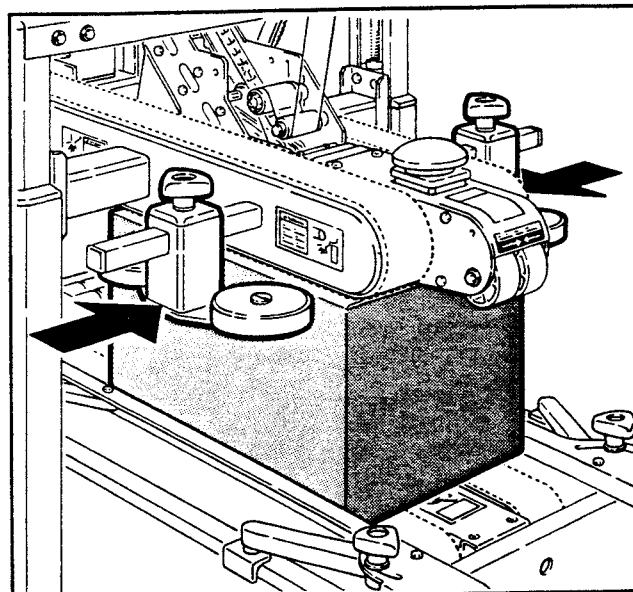


Figure 2-14

Adjustments

Tape Web Alignment

Figure 3-1

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

1. Loosen the locking hex nut behind tape drum on tape drum shaft. Use an adjustable wrench or 25 mm open end wrench.
2. Turn tape drum shaft in or out to center the tape web (use 5 mm hex wrench).
3. Tighten hex nut to secure the adjustment.

No other components require adjustment for tape web alignment.

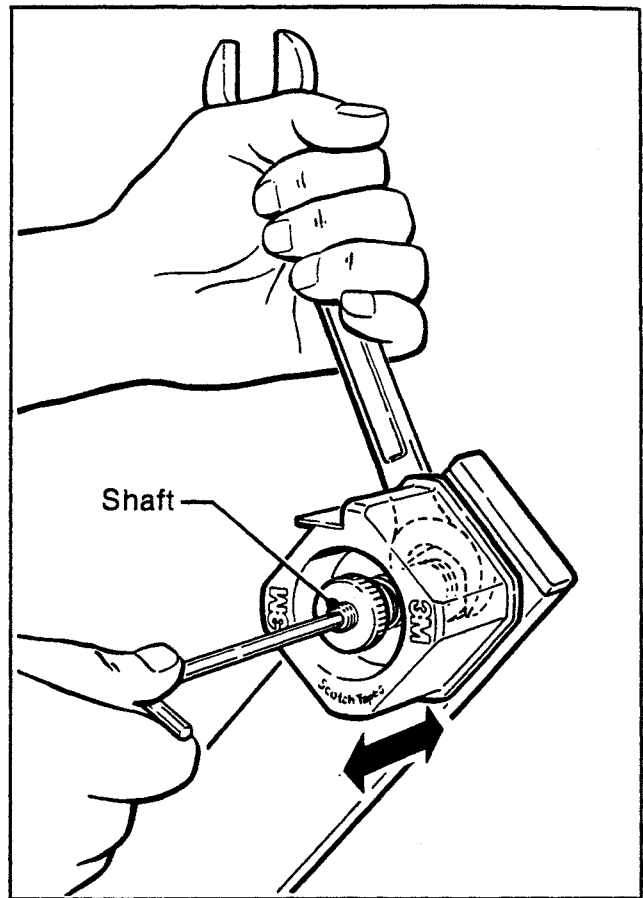


Figure 3-1

Tape Drum Friction Brake

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The tape drum friction brake on each taping head is pre-set for normal operation to prevent tape roll over travel. Should tension adjustment be required, turn the thumbwheel on the shaft to vary compression of the spring. Turn thumbwheel clockwise to increase the braking force, and counterclockwise to decrease the braking force. Adjust to minimum tension that prevents excessive tape roll over travel.

Notice - excess braking force will cause poor tape application and may lead to tape tabbing on the trailing tape leg.

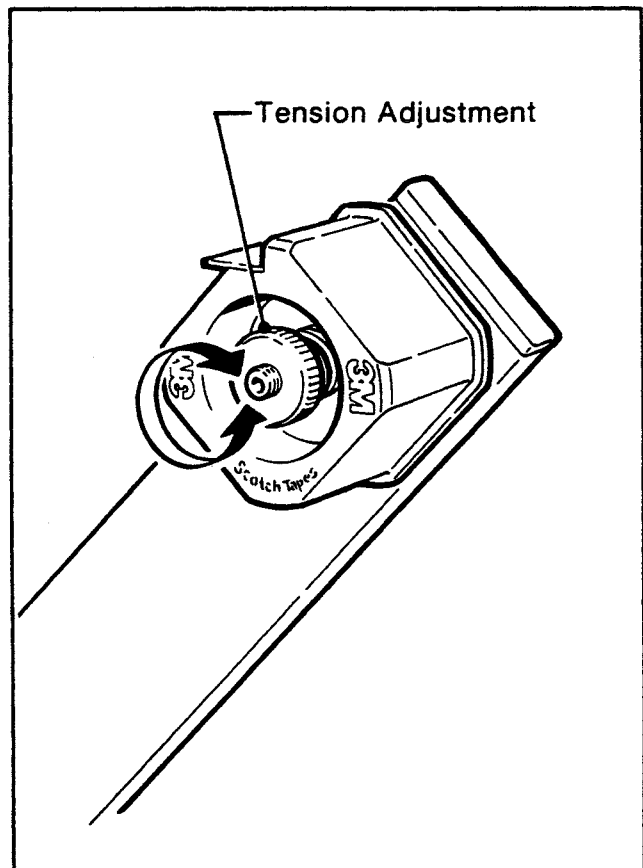


Figure 3-2

Adjustments (Continued)

Applying Mechanism Spring Figure 3-3

The applying mechanism spring, shown in figures 2-4 and 2-5, controls applying and buffing roller pressure on the box and returns the mechanism to the reset position. The spring pressure is setting, as shown in figure 3-3A, is for normal operation but is adjustable.

Removing the spring end loop from the spring holder and placing loop in other holes provided, as shown in Figure 3-3B, will adjust the spring pressure.

The spring pressure should be set to the minimum possible while maintaining good tape application.

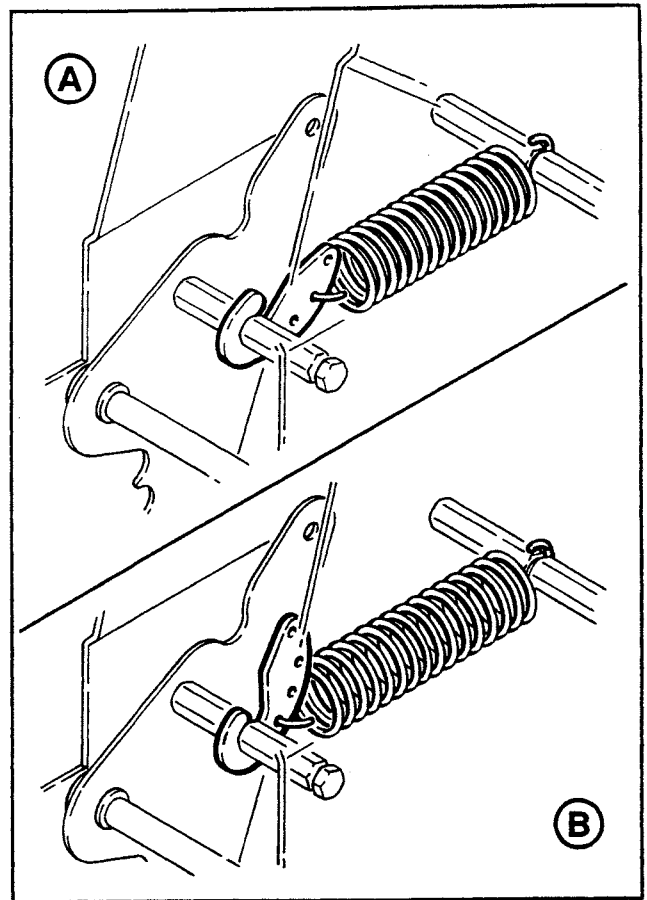


Figure 3-3

One Way Tension Roller Assembly Figure 3-4

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

To Set Tension:

1. Wrap a cord or small strap (non-adhesive) 4-6 turns around the tension roller.
2. Attach a spring scale to the end of the cord or strap.
3. Turn the adjusting nut until a force of approximately 1-2 lbs. [0,5 kg to 0,9 kg] is required to turn the roller by pulling on the spring scale.

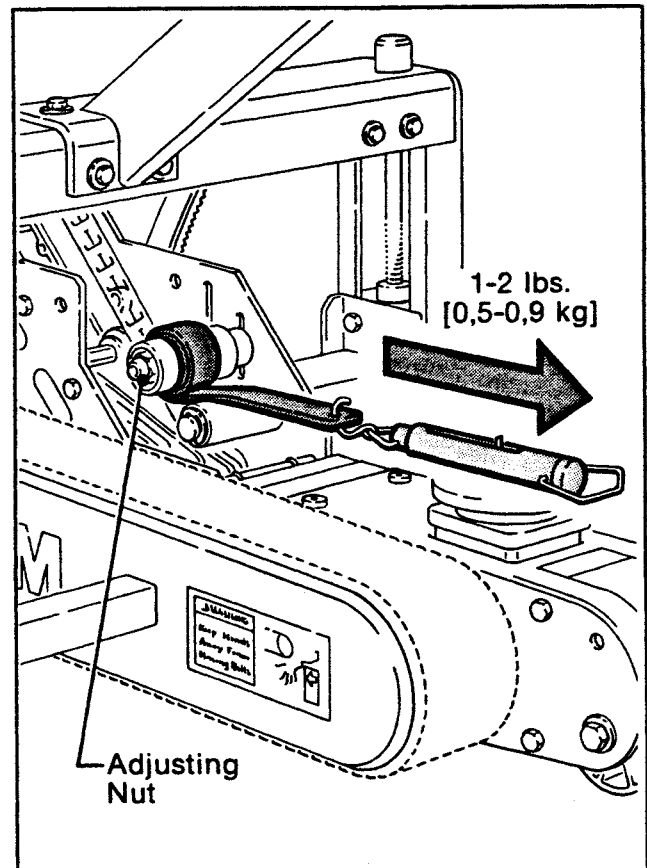


Figure 3-4

Adjustments (Continued)

Box Drive Belts

The four continuously moving box drive belts convey boxes through the tape applying mechanism. The box drive belts are powered by electric gear motors.

Tension adjustment of these belts may be required during normal operation. Belt tension must be adequate to positively move the box through the machine and they should run fully on the surface of the pulleys at each end of the frame. The idler pulleys on the infeed end are positioned by adjustment screws. Adjustment of these screws can be made by using the following steps to provide proper tension. Each belt is adjusted separately.



WARNING - TURN OFF ELECTRICAL POWER SUPPLY AND DISCONNECT POWER CORD FROM ELECTRICAL SUPPLY BEFORE BEGINNING ADJUSTMENTS. IF POWER CORD IS NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.

Box Drive Belt Tension

Belt tension is obtained by tightening the adjustment screw so that a moderate pulling force of 7 lbs. [3,5 kg] applied at the midspan, as shown in figure 3-5, will deflect the belt 1 inch [25 mm].

This will assure positive contact between the belt and the drive pulley on the discharge end of the drive assembly.

Refer to figures 3-6 and 3-7

- Step 1. Remove and retain center plate/front cover and four screws.
- Step 2. Loosen, but do not remove, lock nut M10 with a 17 mm open end wrench.
- Step 3. Reset the tension on the drive belt as needed. Adjust the M8 screw, out to increase - in to decrease. Tighten lock nut to secure tension setting.
- Step 4. Replace center plate/front cover and secure with original screws.

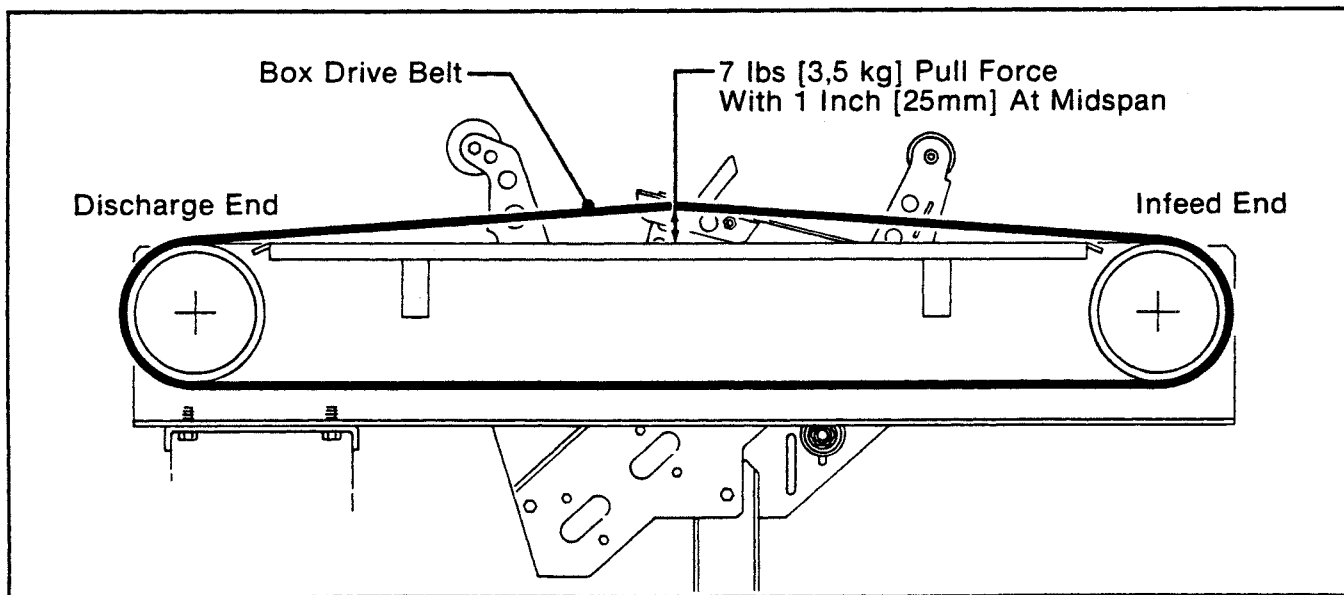


Figure 3-5 - Box Drive Belt Tension Adjustment - Left Side View

Adjustments (Continued)

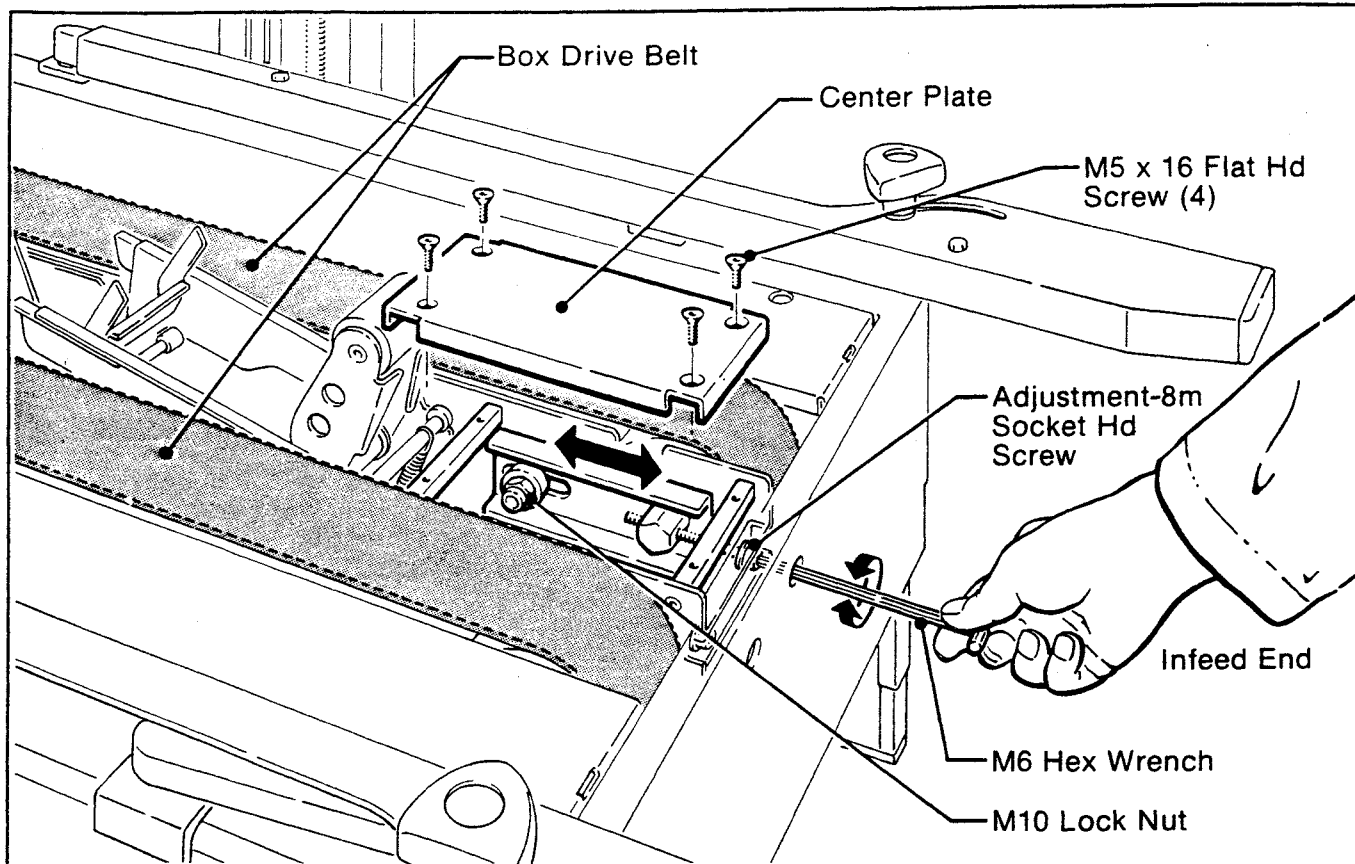


Figure 3-6 - Box Drive Belt Tension Adjustment - Frame Bed Infeed End

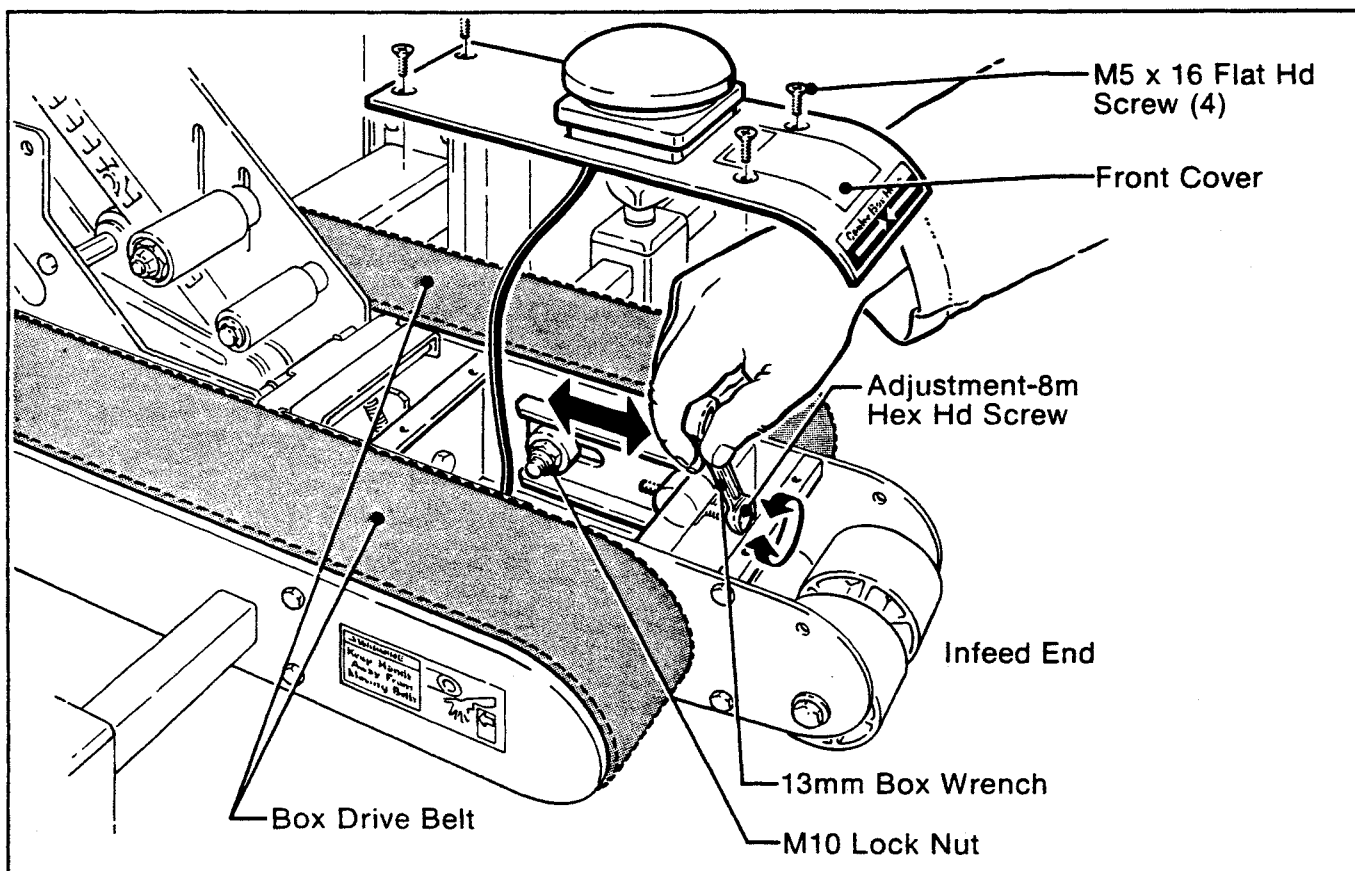


Figure 3-7 - Box Drive Belt Tension Adjustment - Upper Drive Assembly

Adjustments (Continued)

Tape Application Leg Length

Figure 3-8

For best tape application performance, the taping heads should maintain tape leg lengths of $2 \frac{3}{4}$ inch \pm $\frac{1}{4}$ inch [$70 \text{ mm} \pm 6 \text{ mm}$].

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

Refer to Figure 2-6

Moving this roller in the slot farther away from the box surface will decrease the leading leg length. Moving it closer to the box surface will increase the leading leg length.

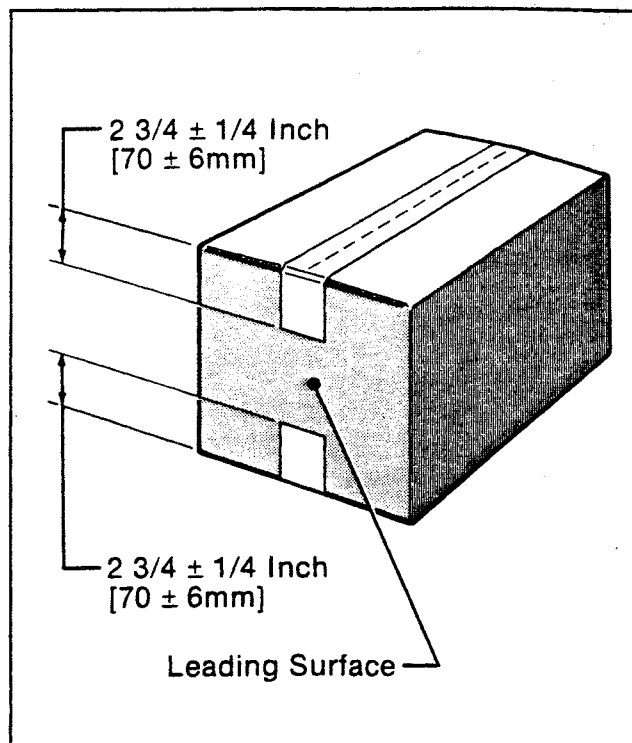


Figure 3-8 - Adjusting Tape Leg Length

Maintenance

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

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

Blade Replacement

Figure 4-1

1. Loosen, but do not remove, the blade screws (A). Remove and discard the old blade.
2. Mount the new blade (B) with the beveled side away from the blade holder.
3. Bottom the blade slots against the screws. This will position the blade at the correct angle. Tighten the blade screws to secure the blade.

The same steps are followed on the upper and lower taping heads. Connect the main power supply.

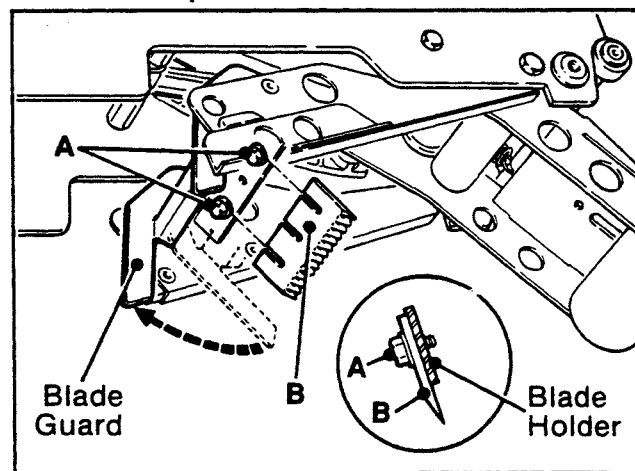


Figure 4-1 - Blade Replacement

Maintenance (Continued)

Replacing Box Drive Belts

Case sealers are supplied with continuous belts. However, replacement belts are spliced (laced splice) for easy installation.

Lower Drive Belts

Figure 4-2

To Remove Old Drive Belt:

IT IS NOT NECESSARY TO REMOVE LOWER TAPING HEAD

1. Remove and retain center plate (A) and four screws.
2. Loosen, but do not remove lock nut (B).
3. Loosen tension screw (C) until all tension is removed.
4. Remove and retain side cover (D) and fasteners.
5. Cut thru old belt to remove and discard.
6. Place new belt over pulleys with laced splice at top. Insert splicing pin. Pin must not extend beyond edge of belt.
7. Refer to the adjustment section - "Box Drive Belts" and reset the belt tension as noted.
8. Replace the side cover and center plate, and secure with original fasteners.

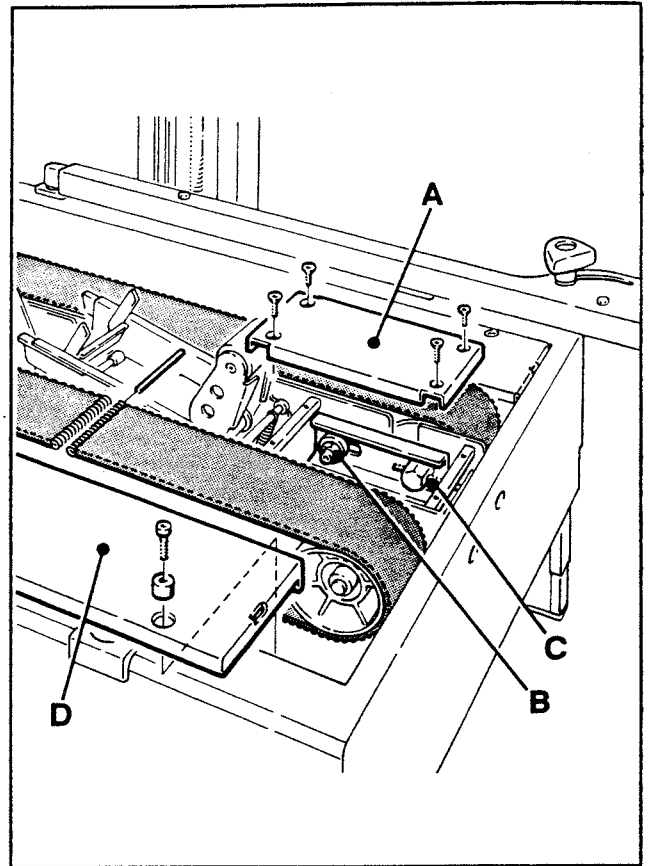


Figure 4-2 - Lower Drive Belt Replacement

Upper Drive Belts

Figure 4-3

To Remove Old Drive Belt:

IT IS NOT NECESSARY TO REMOVE UPPER TAPING HEAD

1. Remove and retain front cover (A) and four screws.
2. Loosen, but do not remove lock nut (B).
3. Loosen tension screw (C) until all tension is removed.
4. Cut thru old belt to remove and discard.
5. Place new belt over pulleys with laced splice at top. Insert splicing pin. Pin must not extend beyond edge of belt.
6. Refer to the adjustment section - "Box Drive Belts" and reset the belt tension as noted.

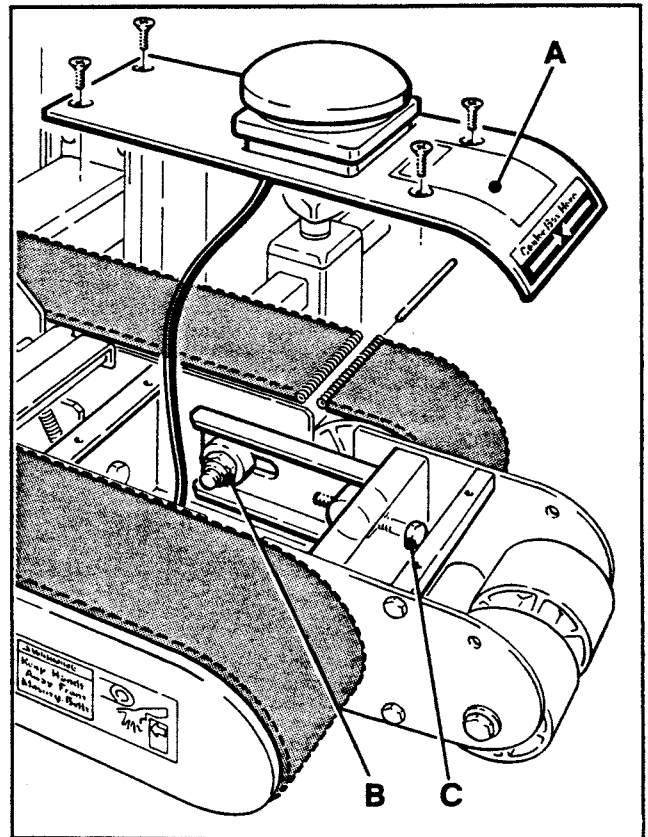


Figure 4-3 - Upper Drive Belt Replacement

Cleaning of the Machine

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

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

Cut-Off Blade:

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

Electrical Schematic

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

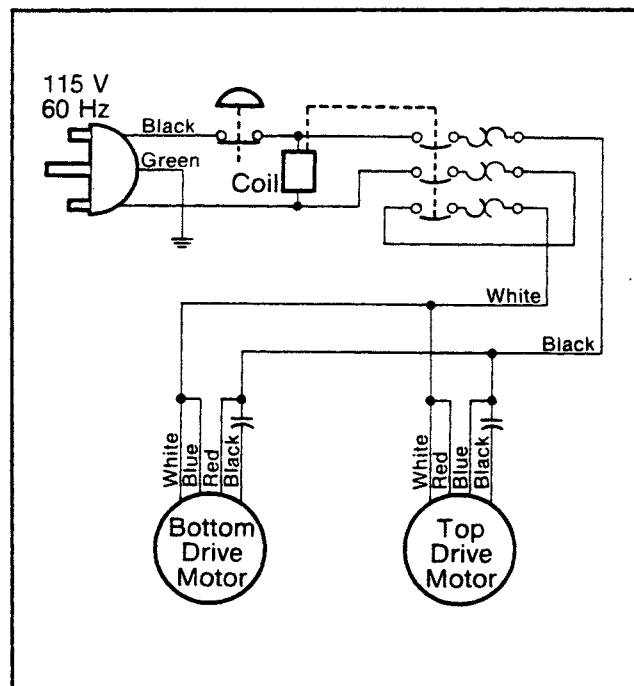


Figure 4-4

Figure 4-4 illustrates the electrical system of the case sealer. No adjustments to the electrical systems are required.

Circuit Breaker

The case sealer is equipped with a circuit breaker which trips the "On-Off" switch to tripped position. If circuit is overloaded and circuit breaker trips, wait 2 minutes, move to "Off", then turn "On". Located inside the electrical control box on the side of the main frame just below the conveyor bed, the circuit breaker has been pre-set at 4.5 amps and requires no further maintenance.

Maintenance (Continued)

Lubrication - Mechanical

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

Figures 4-5 and 4-6 illustrate the taping head and frame points which should be lubricated every 250 hours of operation. Lubricate the rotating and pivoting points noted by the arrows (➡) with SAE #30 non-detergent oil. At the same time, a small amount of multipurpose grease should be applied to the end of each spring where the loop is secured at an eyelet, post, or hole noted by the arrows (➡).

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

Blade Oiler Pad

The taping heads are equipped with a felt blade oiler pad that has been pre-lubricated at the factory to provide a film of oil on the cut-off blade to reduce adhesive build-up. Apply SAE #30 non-detergent oil as needed. **SATURATE FELT OILER PAD.**

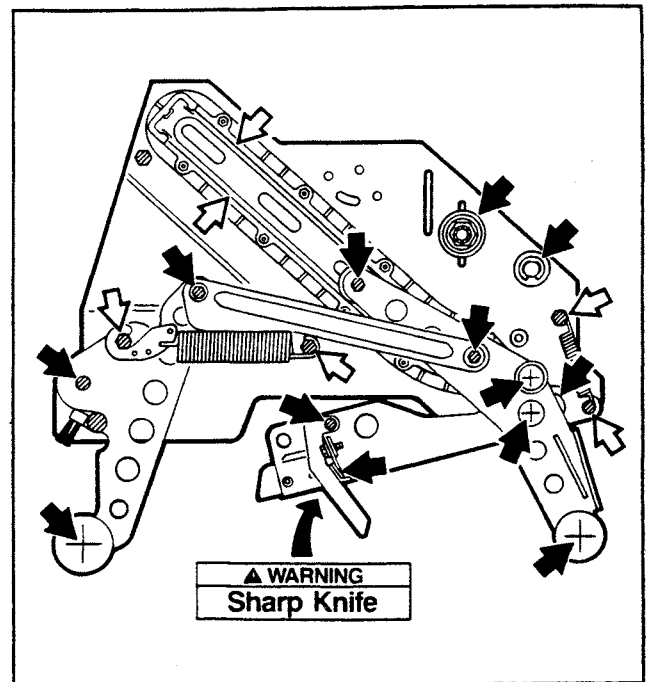


Figure 4-5 - Lubrication Points - Upper and Lower Taping Heads

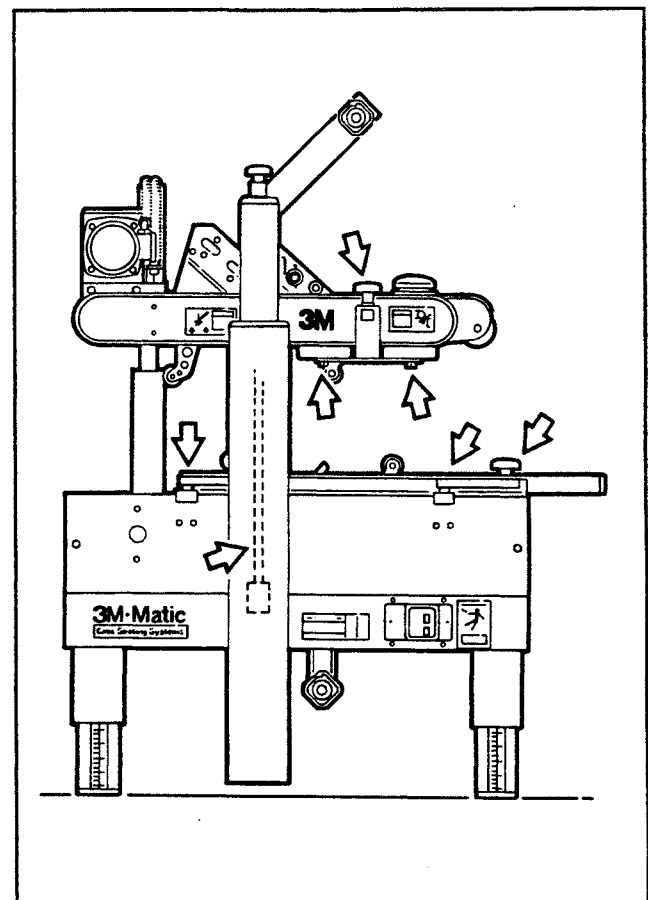


Figure 4-6 - Lubrication Points - Frame

Special Set-Up Procedure

Changing the Tape Leg Length From 2 3/4 to 2 Inches



WARNING - TURN OFF ELECTRICAL POWER SUPPLY AND DISCONNECT POWER CORD FROM ELECTRICAL SUPPLY BEFORE BEGINNING WORK ON THE CASE SEALER OR TAPING HEADS. IF POWER CORD IS NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.

The following changes to the case sealer will allow the taping of boxes of 3.50 inches [90 mm] minimum height.

Case Sealer

Figure 5-1

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



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

Taping Heads

1. Pivot up the clamp that secures the upper taping head as shown in figure 5-1B.
2. Slide the head forward and straight down to remove it from the case sealer.
3. Lift the lower taping head, shown in figure 5-1C, straight up to remove it from the case sealer bed.

Figure 5-2

1. Remove and retain the two hex screws to remove the brush from the normal position "A" on the taping head frame.
2. Remount and secure the brush in position "A-A" (forward of the normal location) using the original fasteners.
3. Remove and retain the two flat head screws to remove the blade cut-off bracket extension in normal position "B".
4. Remount and secure the bracket extension in the forward position "B-B" using the original fasteners. Relocate both the right and left extensions..
5. Remove and retain the hex head screw and washer to remove the one-way tension roller assembly from slot "C" in the head frame.
6. Remount and secure tension roller assembly near top of slot "C-C" in frame using original fasteners.

Figure 5-3

The one way tension roller position is adjustable to control the leading tape leg length. Moving this roller farther away from the box top surface will decrease the leading leg length. Moving it closer to the box top surface will increase the leading leg length.

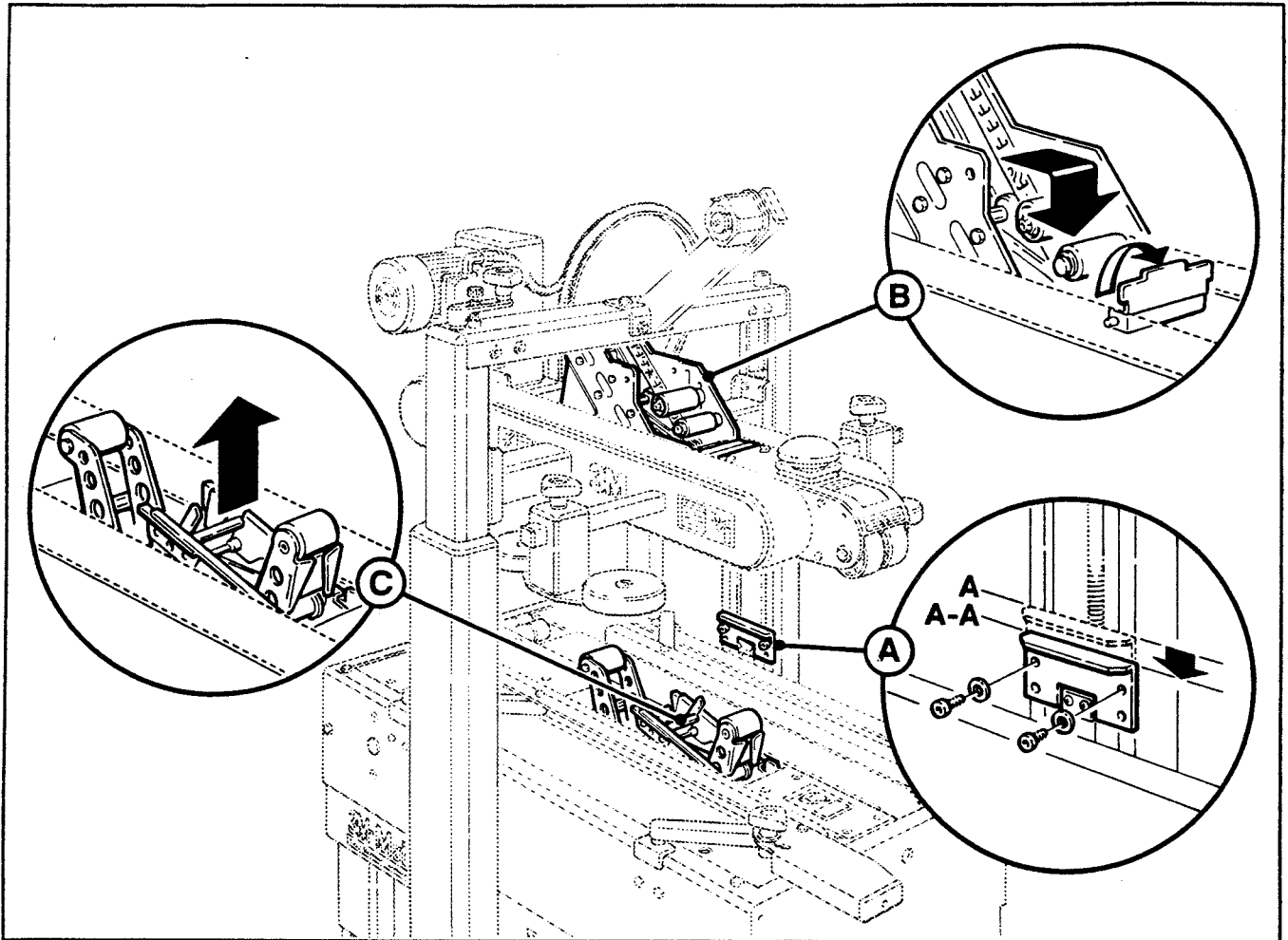


Figure 5-1 - Changes to Case Sealer

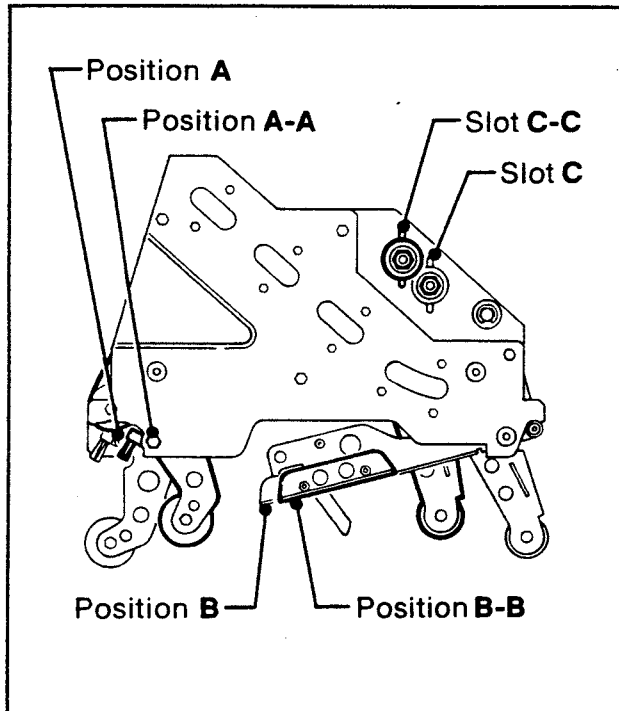


Figure 5-2 - Changes to Taping Head

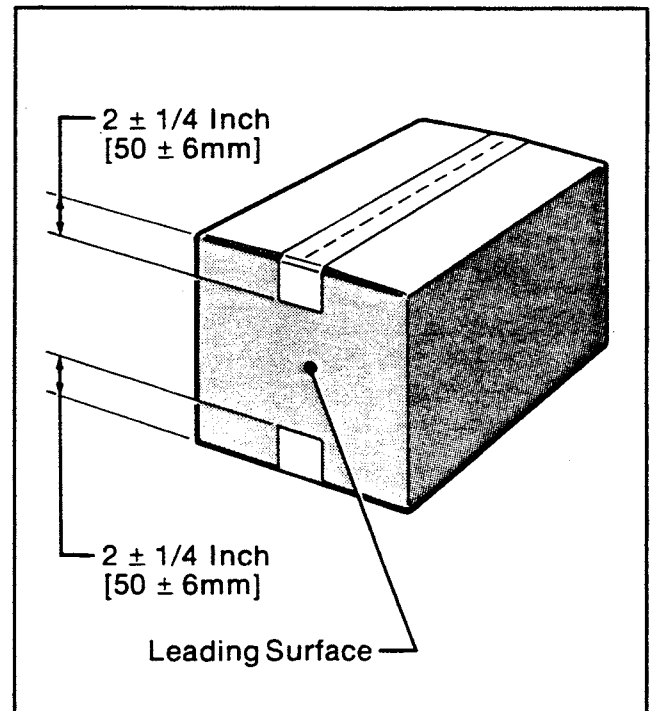


Figure 5-3 - Adjusting Tape Leg Length

Troubleshooting

Review the Set-Up Procedure Section so that the operational components of the machine are understood. The Troubleshooting Guide lists some possible machine problems, causes and corrections.

TROUBLESHOOTING GUIDE

Problem	Cause	Correction
Drive belts do not convey boxes	Narrow boxes	Check machine specifications Boxes are narrower than recommended, causing slippage and premature belt wear
	Worn drive belts	Replace drive belts
	Top taping head does not apply enough pressure	Adjust the box height adjustment with the crank
	Top flap compression rollers in too tight	Readjust compression rollers
	Taping head applying spring holder missing	Replace spring holder
	Taping head applying spring set too high	Reduce spring pressure
Drive belts do not turn	Worn or missing friction rings	Replace friction rings
	Drive belt tension too low	Adjust belt tension
	Electrical disconnect	Check power and electrical plug
	Circuit breaker not at correct setting	Set to correct current value
	Motor not turning	Evaluate problem and correct
Upper and lower applying mechanisms interfere with each other	Machine's minimum height stop does not match tape head leg length setting	Check manual to make sure taping heads match machine setting
Drive belts break	Worn belt	Replace belt
Light boxes tip back on exit	Upper ski down too far	Carefully adjust upper ski
Squeaking noise as boxes pass through machine	Dry compression rollers	Lubricate compression rollers
	Dry column bearings	Lubricate column bearings
	Defective column bearings	Replace column bearings
Tape not centered on box seam	Tape drum not centered	Reposition tape drum
	Centering guides not centered	Adjust centering guides
	Box flaps not of equal length	Check box specifications

(continued)

Troubleshooting (continued)

Troubleshooting Guide

Problem	Cause	Correction
The tape leg on the front of the case is too long	The tape is threaded incorrectly	The tape must go around the wrap roller before going around the one-way tension roller
	The tape tension is too low	Adjust the one-way tension roller
	The knurled roller drags	Check for adhesive build-up between the knurled roller and its shaft. Clean and lubricate shaft. Remove all lubricant from roller surfaces.
	Tape tracks to one side or drags on the support tabs of applying frame	Adjust the tape web alignment
	The one-way tension roller is not correctly positioned	Position the roller in its mounting slot so that the tape extends just beyond the center line of the applying roller
	Taping head is not set up properly	Check leg length adjustments
The blade does not cut tape or the tape end is jagged or shredded	The blade is dull and/or has broken teeth	Replace the blade
	Tape tension is insufficient	Increase tape tension by adjusting the one-way tension roller
	Adhesive has build up on the blade	Clean and adjust the blade
	The blade is not positioned properly	Make sure the blade is bottomed out against the mounting bolts
	The blade is dry	Lubricate the blade oiler pad on the blade guard
	The blade is in backwards	Mount the blade so that the beveled edge is away from the entrance end of the head
	One or both cutter springs are missing or stretched	Replace the defective springs
	Tension roller surface is not fully contacting the taping head frame	Make sure one-way bearing is below the surface of the tension roller. If not, press bearing further into roller or replace roller.

(continued)

Troubleshooting (continued)

Troubleshooting Guide

Problem	Cause	Correction
Tape is tabbing on the trailing leg on the back of the box	There is excess tension on the tape drum assembly and/or the one-way tension roller assembly	Adjust the one-way tension roller and/or the tape drum assembly
	Rollers in the tape path do not rotate freely	Clean adhesive deposits from the surface, ends and shafts of the rollers. Then lubricate roller shafts. Remove all lubricant from roller surfaces.
	The blade is not cutting tape properly	Refer to tape cutting problems
	The tape is threaded incorrectly	Rethread the tape
	Applying mechanism spring has too little tension	Move spring hook to next tighter hole
The tape end does not stay in the application position in front of the applying roller	The tape is incorrectly threaded	Rethread the tape
	Flanged knurled roller overruns on return of applying mechanism to its rest position	Adjust tension roller position in mounting slot to lengthen tape leg
	Applying roller overruns on return of applying mechanism to its rest position	There should be a slight drag when rotating the applying roller. If not, check friction springs and/or friction pins and replace if necessary.
	The one-way tension roller is not correctly positioned	Position roller in its mounting slot so that tape end extends beyond center line of applying roller
	The one-way tension roller is defective	Replace the one-way tension roller

Replacement Parts And Service Information

Spare Parts

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

Qty.	Ref. No.	Part Number	Description
1	2880-15	78-8057-6179-4	Roller - Applying
1	2881-5	78-8057-6178-6	Roller - Buffing
1	2881-10	78-8070-1274-1	Spring - Upper Extension
1	2883-2	78-8017-9173-8	Blade - 2.56 Inch/65 mm
2	2883-12	78-8052-6602-6	Spring - Cutter
1	2886-10	78-8070-1273-3	Spring - Lower Extension
2	2812-38	78-8070-1531-4	Belt - Drive W/Hook

The threading tool, part number 78-8017-9433-6, is also available as a replacement stock item. Refer to "How To Order Replacement Parts" for ordering information.

How To Order Replacement Parts

1. Order parts by part number, part name, machine catalog number, type number and part quantity required. A parts order form is provided at the back of the manual.

<p>Minimum billing on parts orders will be \$10.00. Replacement part prices available on request.</p>

2. Replacement parts and part prices available direct from:

Dispenser Parts
Route 4, Box 5B
Amery, WI 54001

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

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

Attachments

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

<u>Part Number</u>	<u>Attachment Name</u>
78-8052-6553-1	Box Hold Down Attachment, Model 18500
78-8060-7405-6	Caster Kit Attachment
78-8069-3924-1	Conveyor Extension Attachment
78-8069-3926-6	Low Tape Sensor Kit

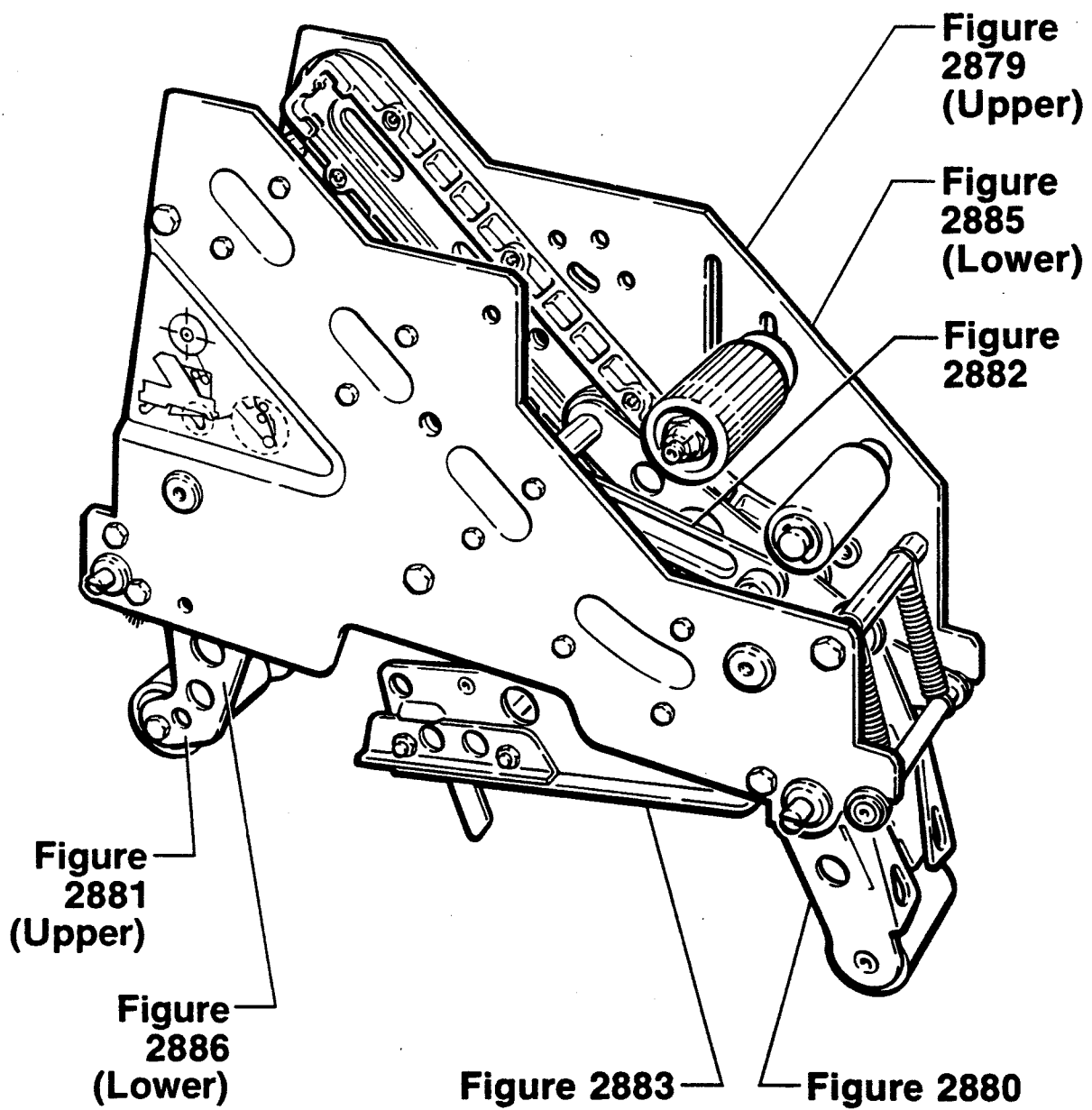
Replacement Parts Illustrations and Parts Lists
700a Adjustable Case Sealer, Type 19000
Taping Head Assemblies

1. Refer to Taping Head Assemblies figure to find all the parts illustrations identified by figure numbers.
2. Refer to the figure or figures to determine the individual parts required and the parts reference number.
- 3 . The replacement parts list, that follows each illustration, includes the part number and part description for the parts in that illustration.

Note - The complete description has been included for standard fasteners and some commercially available components. This has been done to allow obtaining these standard parts locally, should the customer elect to do so.

4. Refer to page 33 - "Replacement Parts and Service Information" of this manual for replacement parts ordering information.

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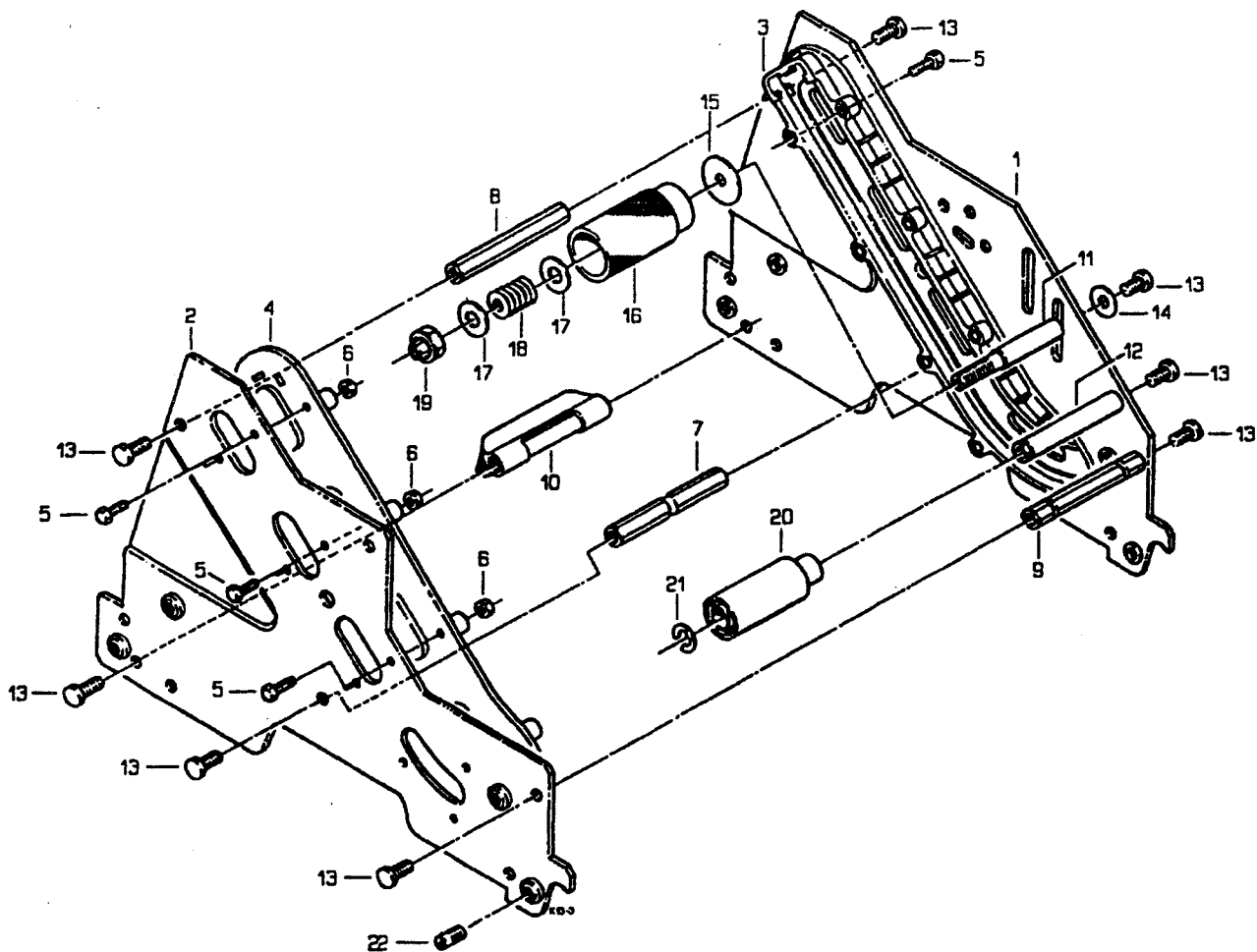


Figure 2879 Upper

Figure 2879 Upper

Ref. No.	3M Part No.	Description
2879-1	78-8070-1386-3	Frame - Tape Mount Upper Assembly
2879-2	78-8070-1387-1	Frame - Front Upper Assembly
2879-3	78-8068-4143-9	Guide - R/H
2879-4	78-8060-8414-7	Guide - L/H
2879-5	83-0002-7336-3	Screw - Hex Hd M4 x 14
2879-6	78-8010-7416-8	Nut - Hex M4
2879-7	78-8070-1251-9	Spacer - Spring
2879-8	78-8052-6559-8	Spacer - Upper
2879-9	78-8052-6560-6	Spacer - Front
2879-10	78-8060-7936-0	Brush Assembly
2879-11	78-8052-6564-8	Shaft - Tension Roller
2879-12	78-8052-6568-9	Shaft - Wrap Roller
2879-13	26-1003-5828-7	Screw - Hex Hd M6 x 12
2879-14	78-8042-2919-9	Washer - Triple, M6
2879-15	78-8070-1268-3	Washer - Roll Back Up
2879-16	78-8052-6565-5	Roller - Top Tension
2879-17	78-8052-6566-3	Washer - Friction
2879-18	78-8052-6567-1	Spring - Compression
2879-19	78-8017-9077-1	Nut - Self Locking M10 x 1
2879-20	78-8052-6569-7	Roller - Wrap
2879-21	26-1000-1613-3	Ring - Retaining 10DIN6799
2879-22	78-8076-4500-3	Stud - Mounting

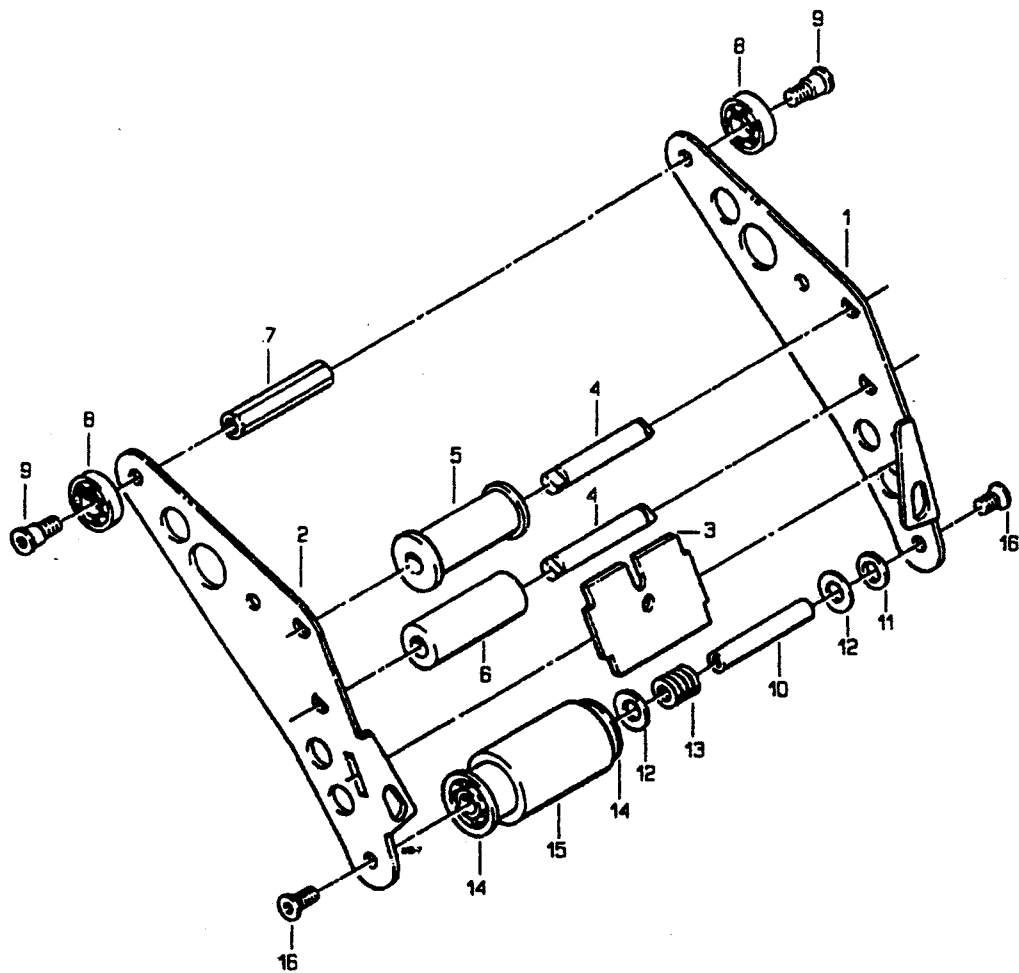


Figure 2880

Figure 2880

Ref. No.	3M Part No.	Description
2880-1	78-8070-1206-3	Arm - Applying R/H
2880-2	78-8070-1207-1	Arm - Applying L/H
2880-3	78-8070-1221-2	Plate - Tape
2880-4	78-8070-1309-5	Shaft - Roller
2880-5	78-8070-1367-3	Roller - Knurled Assembly
2880-6	78-8070-1266-7	Roller - Wrap
2880-7	78-8052-6580-4	Spacer - Rear
2880-8	78-8017-9082-1	Bearing - Special 30 mm
2880-9	78-8017-9106-8	Screw - Bearing Shoulder
2880-10	78-8052-6575-4	Shaft - Roller
2880-11	78-8017-9074-8	Washer - Nylon 15 mm
2880-12	78-8052-6566-3	Washer - Friction
2880-13	78-8052-6567-1	Spring - Compression
2880-14	78-8060-8395-8	Bushing - Applying Roller
2880-15	78-8057-6179-4	Roller - Applying NM
2880-16	26-1005-4759-0	Screw - Flat Hd M6 x 12

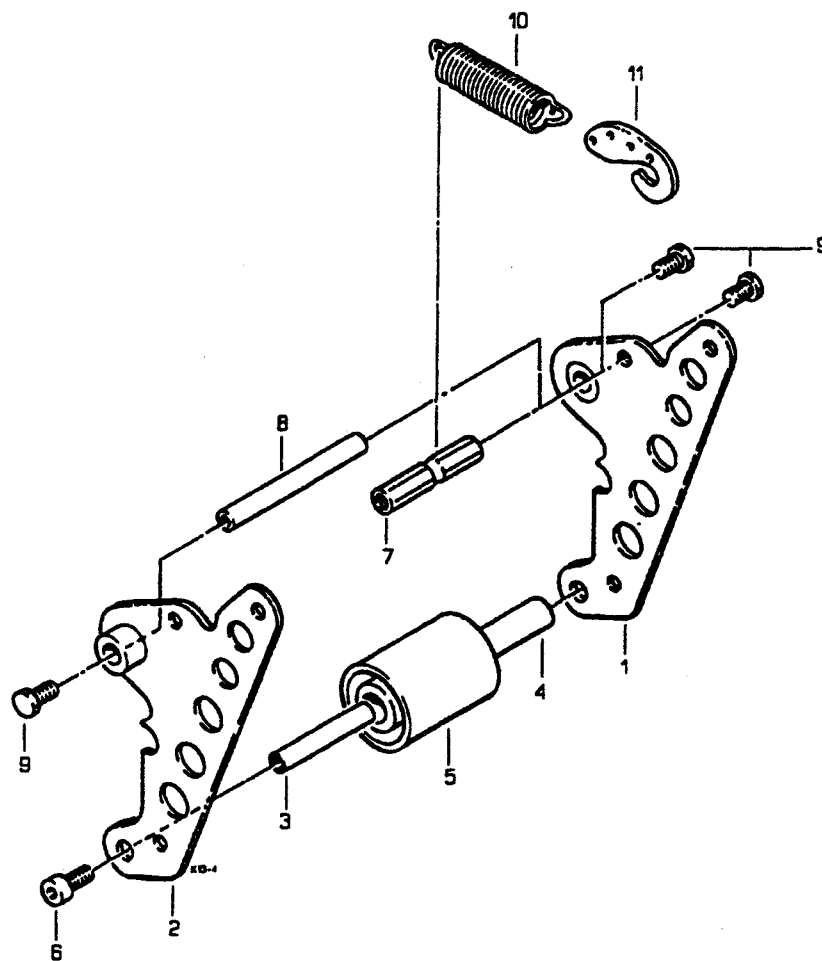


Figure 2881 Upper

Figure 2881 Upper

Ref. No.	3M Part No.	Description
2881-1	78-8070-1392-1	Buffing Arm Sub Assembly
2881-2	78-8070-1391-3	Buffing Arm Sub Assembly
2881-3	78-8052-6575-4	Shaft - Roller
2881-4	78-8052-6586-1	Bushing - Buffing Roller
2881-5	78-8057-6178-6	Roller - Buffing NM
2881-6	78-8076-4503-7	Screw - M6 x 12
2881-7	78-8070-1220-4	Spacer - Spring
2881-8	78-8017-9109-2	Shaft - 10 x 90 mm
2881-9	26-1003-5828-7	Screw - Hex Hd M6 x 12
2881-10	78-8070-1274-1	Spring - Upper
2881-11	78-8070-1244-4	Holder - Spring

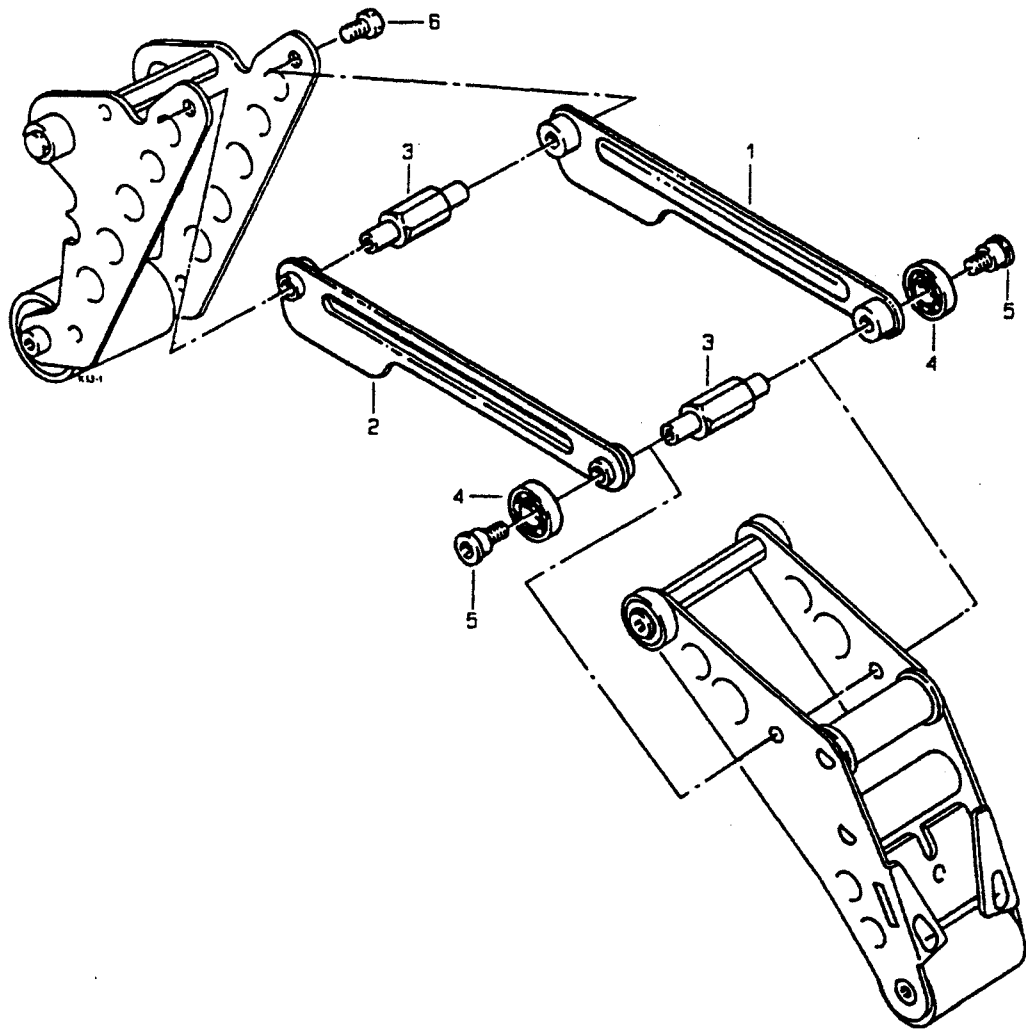


Figure 2882

Figure 2882

Ref. No.	3M Part No.	Description
2882-1	78-8070-1388-9	Link - Arm Bushing Assembly
2882-2	78-8070-1389-7	Link - Arm Bushing Assembly
2882-3	78-8070-1271-7	Shaft - Pivot
2882-4	78-8017-9082-1	Bearing - Special 30 mm
2882-5	78-8017-9106-8	Screw - Bearing Shoulder
2882-6	78-8010-7163-6	Screw - Hex Hd M5 x 10

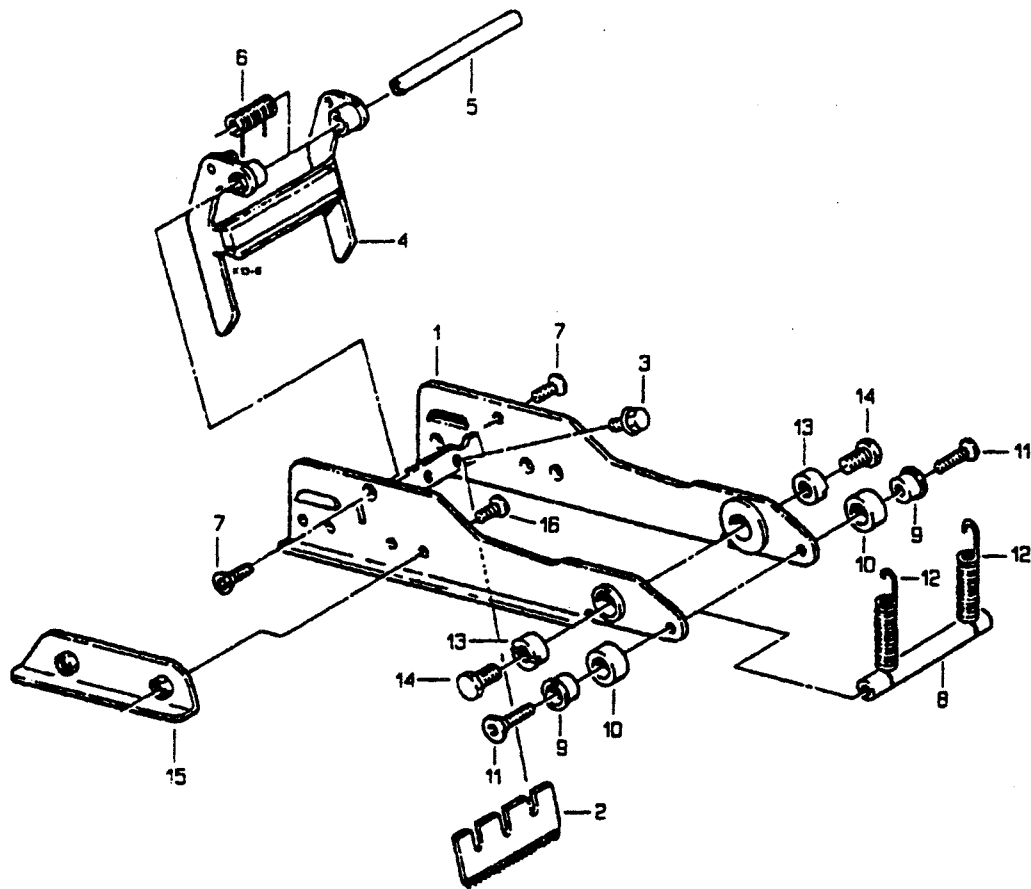


Figure 2883

Figure 2883

Part No.	3M Part No.	Description
2883-1	78-8070-1217-0	Frame - Cut-Off Weldment
2883-2	78-8017-9173-8	Blade - 2.56 Inch/65 mm
2883-3	26-1003-8596-7	Screw - Hex Hd M5 x 8 W/Ext. Tooth Washer
2883-4	78-8070-1371-5	Guard - Blade Assembly
2883-5	78-8052-6597-8	Shaft - Blade Guard
2883-6	78-8070-1390-5	Spring - Tension
2883-7	26-1005-4757-4	Screw - Flat Hd M4 x 10
2883-8	78-8017-9135-7	Shaft - Spacer
2883-9	78-8052-6600-0	Spacer
2883-10	78-8070-1269-1	Bumper
2883-11	26-1005-4758-2	Screw - Flat Hd M5 x 20
2883-12	78-8052-6602-6	Spring - Cutter
2883-13	78-8017-9132-4	Pivot - Cutter Lever
2883-14	26-1003-5828-7	Screw - Hex Hd M6 x 10
2883-15	78-8070-1216-2	Slide - Extension
2883-16	26-1008-6574-5	Screw - Phillips FH M4 x 10

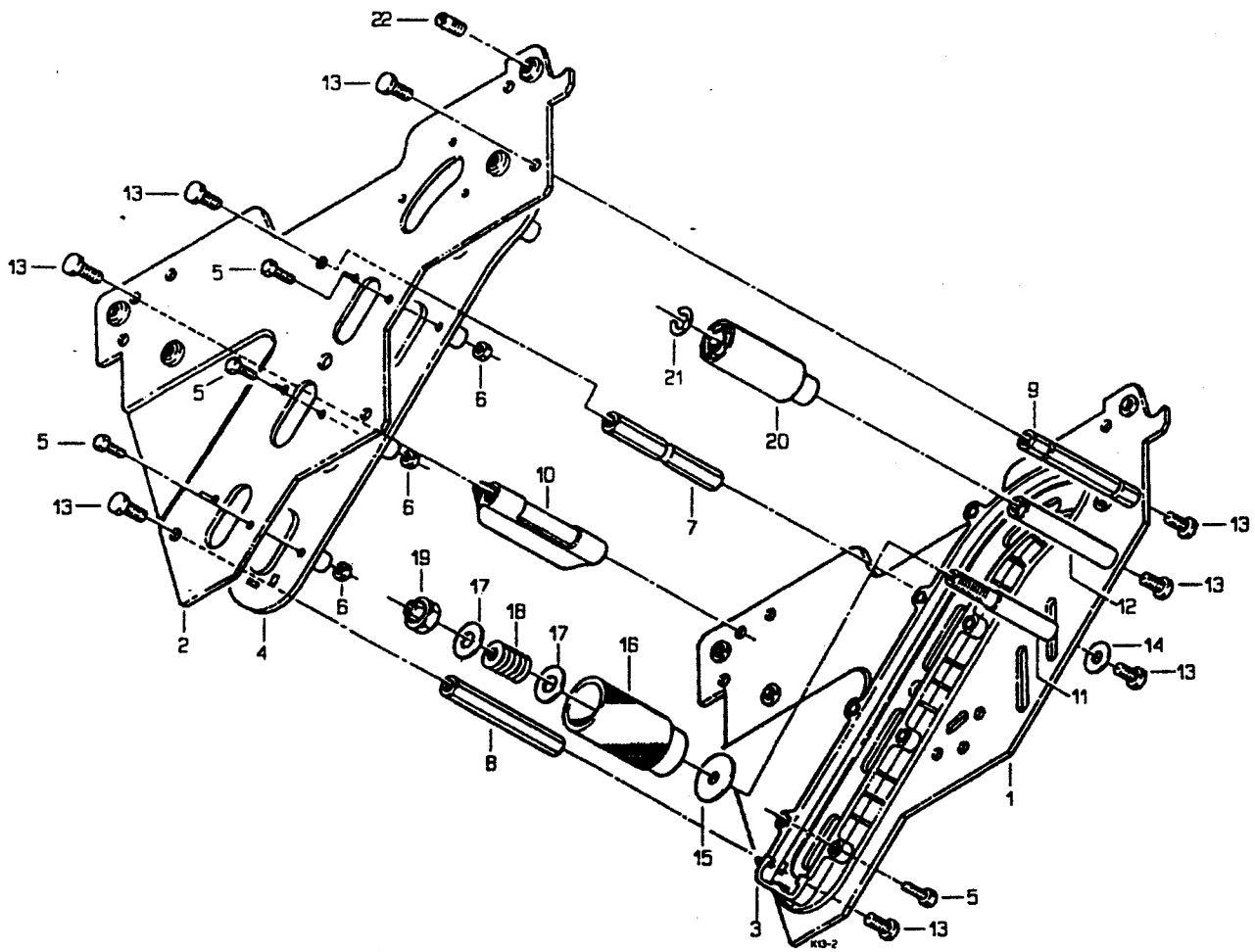


Figure 2885 Lower

Figure 2885 Lower

Ref. No.	3M Part No.	Description
2885-1	78-8070-1370-7	Frame - Front Lower Assembly
2885-2	78-8070-1369-9	Frame - Tape Mount Lower Assembly
2885-3	78-8068-4143-9	Guide - R/H
2885-4	78-8068-4144-7	Guide - L/H
2885-5	83-0002-7336-3	Screw - Hex Hd M4 x 14
2885-6	78-8010-7416-8	Nut - Hex M4
2885-7	78-8070-1251-9	Spacer - Spring
2885-8	78-8052-6559-8	Spacer - Upper
2885-9	78-8052-6560-6	Spacer - Front
2885-10	78-8060-7936-0	Brush Assembly
2885-11	78-8052-6564-8	Shaft - Tension Roller
2885-12	78-8052-6568-9	Shaft - Wrap Roller
2885-13	26-1003-5828-7	Screw - Hex Hd M6 x 12
2885-14	78-8042-2919-9	Washer - Triple M6
2885-15	78-8070-1268-3	Washer - Roll Back Up
2885-16	78-8052-6606-7	Roller - Tension Bottom
2885-17	78-8052-6566-3	Washer - Friction
2885-18	78-8052-6567-1	Spring - Compression
2885-19	78-8017-9077-1	Nut - Self Locking M10 x 1
2885-20	78-8052-6569-7	Roller - Wrap
2885-21	26-1000-1613-3	Ring - Retaining 1DIN6799
2885-22	78-8076-4500-3	Stud - Mounting

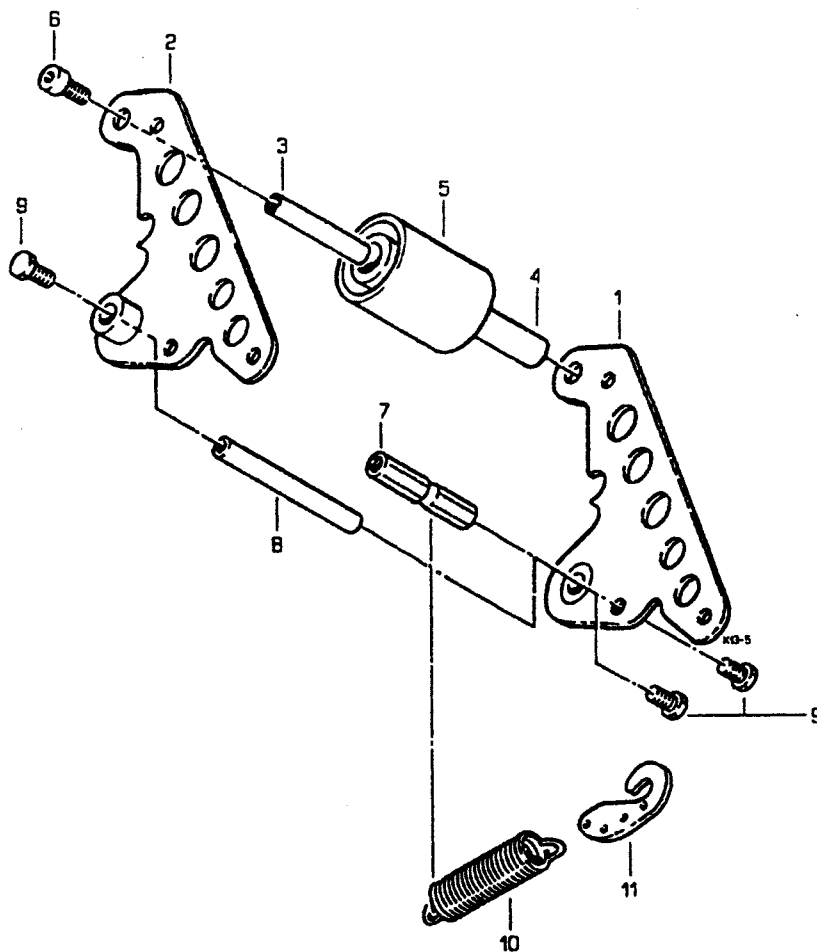


Figure 2886 Lower

Figure 2886 Lower

Ref. No.	3M Part No.	Description
2886-1	78-8070-1391-3	Buffing Arm Sub Assembly
2886-2	78-8070-1392-1	Buffing Arm Sub Assembly
2886-3	78-8052-6575-4	Shaft - Roller
2886-4	78-8052-6586-1	Bushing - Buffing Roller
2886-5	78-8057-6178-6	Roller - Buffing NM
2886-6	78-8076-4503-7	Screw - M6 x 12
2886-7	78-8070-1220-4	Spacer - Spring
2886-8	78-8017-9109-2	Shaft - 10 x 90 mm
2886-9	26-1003-5828-7	Screw - Hex Hd M6 x 12
2886-10	78-8070-1273-3	Spring - Lower
2886-11	78-8070-1244-4	Holder - Spring

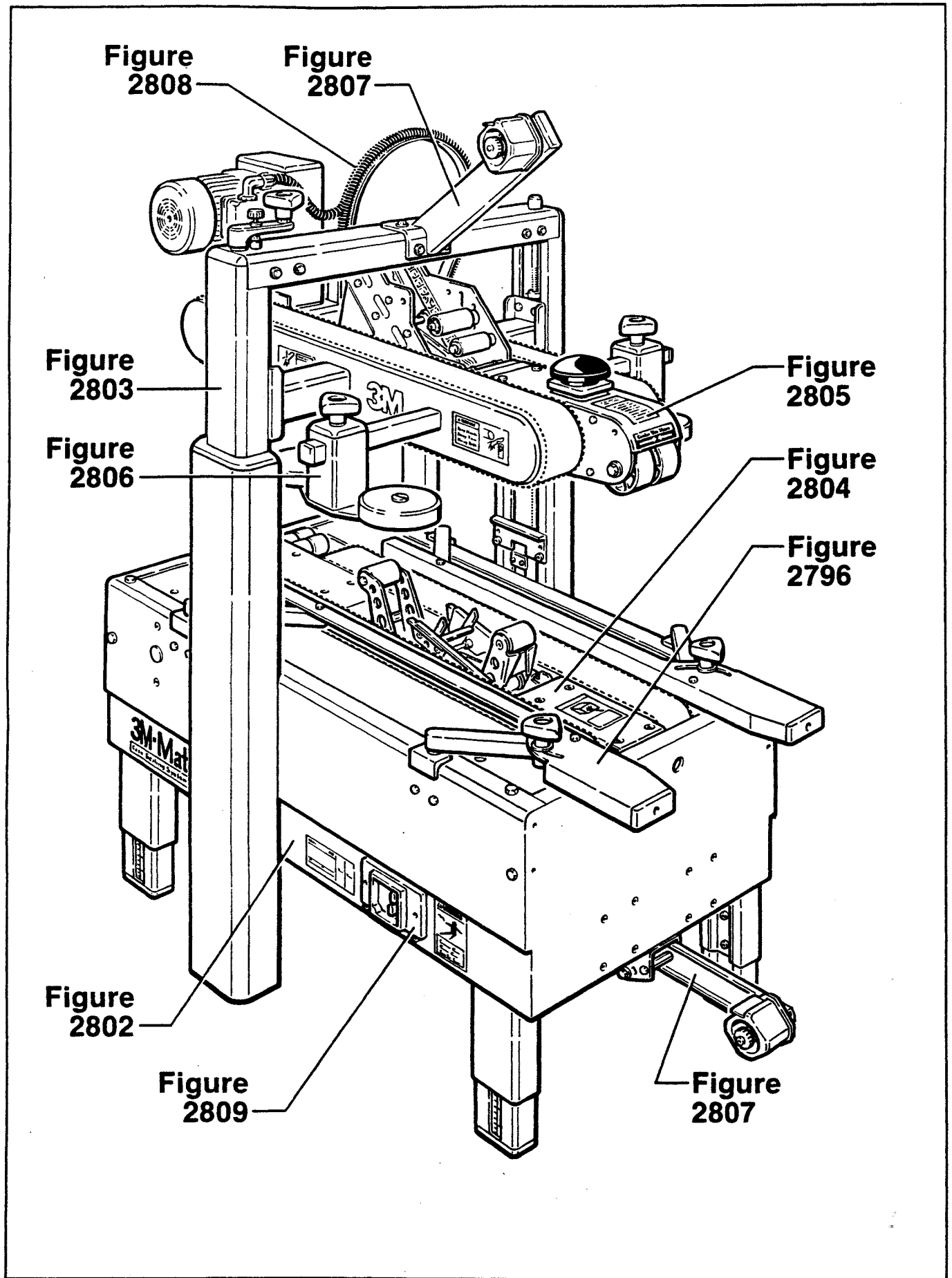
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1. Refer to Frame Assemblies figure to find all parts illustrations identified by figure numbers.
2. Refer to the figure or figures to determine the individual parts required and the parts reference number.
3. The replacement parts list, that follows each illustration, includes the part number and part description for the parts in the illustration.

Note - The complete description has been included for standard fasteners and some commercially available components. This has been done to allow obtaining these standard parts locally, should the customer elect to do so.

4. Refer to page 33 - "Replacement Parts and Service Information" of this manual for replacement parts ordering information.

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Frame Assemblies

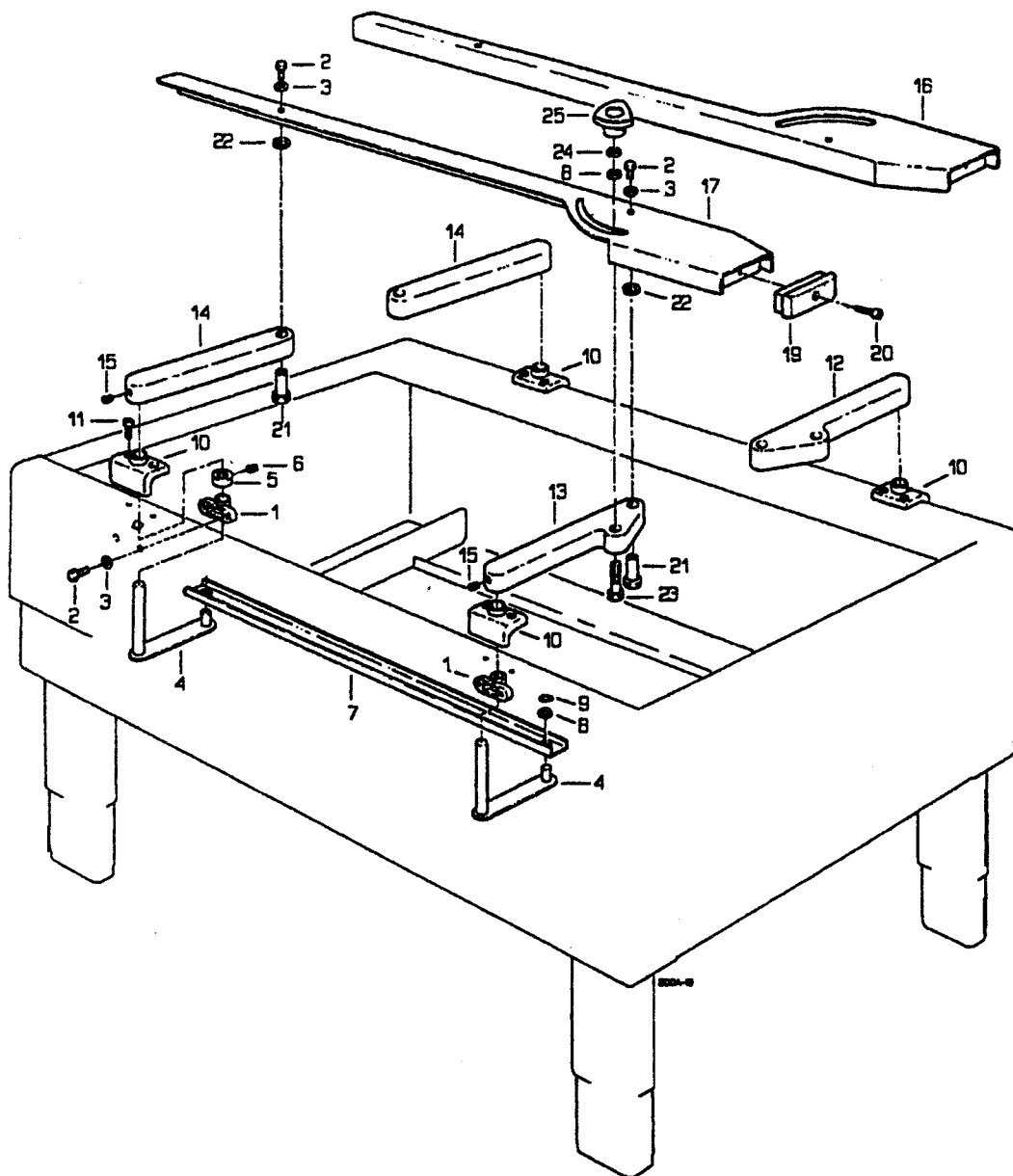


Figure 2796

Figure 2796

Ref. No.	3M Part No.	Description
2796-1	78-8070-1536-3	Support - Guide Arm
2796-2	78-8010-7169-3	Screw - Hex Hd M6 X 12, Metric
2796-3	26-1000-0010-3	Washer - Flat M6
2796-4	78-8070-1537-1	Lever With Pivot
2796-5	78-8070-1538-9	Bushing
2796-6	26-1003-8816-9	Screw - Set M5 X 6
2796-7	78-8070-1539-7	Link - Guide
2796-8	78-8017-9074-8	Washer - 15 mm Nylon
2796-9	78-8052-6733-9	Ring - M10 Special
2796-10	78-8070-1540-5	Support - Lever
2796-11	26-1003-7951-5	Screw - Soc Hd Hex Soc M5 X 20
2796-12	78-8070-1541-3	Guide Arm - Front, Right
2796-13	78-8070-1542-1	Guide Arm - Front, Left
2796-14	78-8070-1543-9	Guide Arm - Rear
2796-15	78-8076-4505-2	Screw - Set M6 X 8
2796-16	78-8070-1544-7	Guide - Right
2796-17	78-8070-1545-4	Guide - Left
2796-19	78-8070-1546-2	Cap - Guide
2796-20	26-1003-7953-1	Screw - Soc Hd M5 X 30
2796-21	78-8070-1547-0	Shaft - Guide
2796-22	78-8070-1548-8	Washer - 20 X 12, 5 X 1 Nylon
2796-23	26-1003-5852-7	Screw - Hex Hd M10 X 40
2796-24	78-8052-6566-3	Washer - Friction
2796-25	78-8070-1549-6	Knob - VIR-B-M10

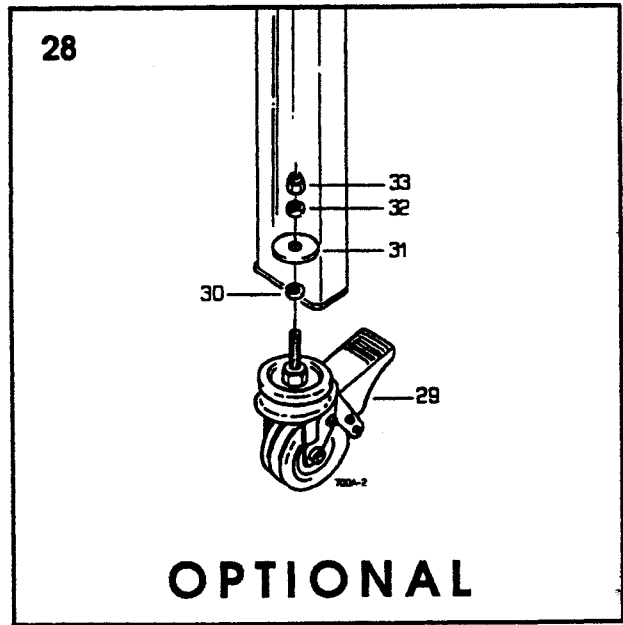
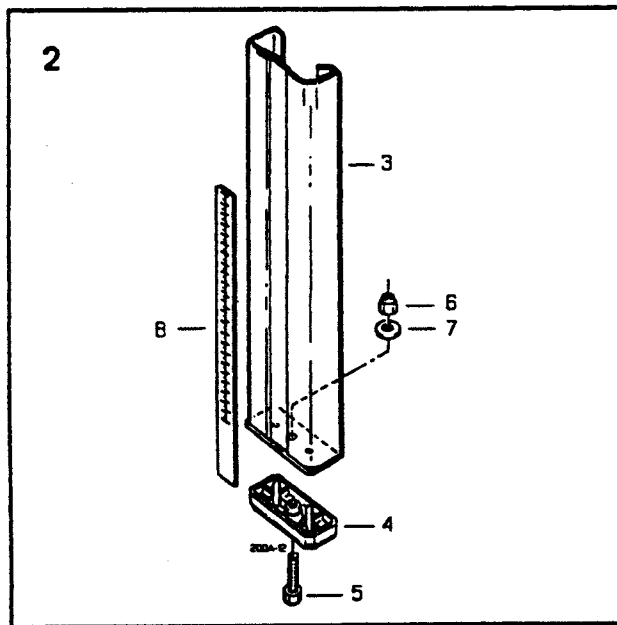
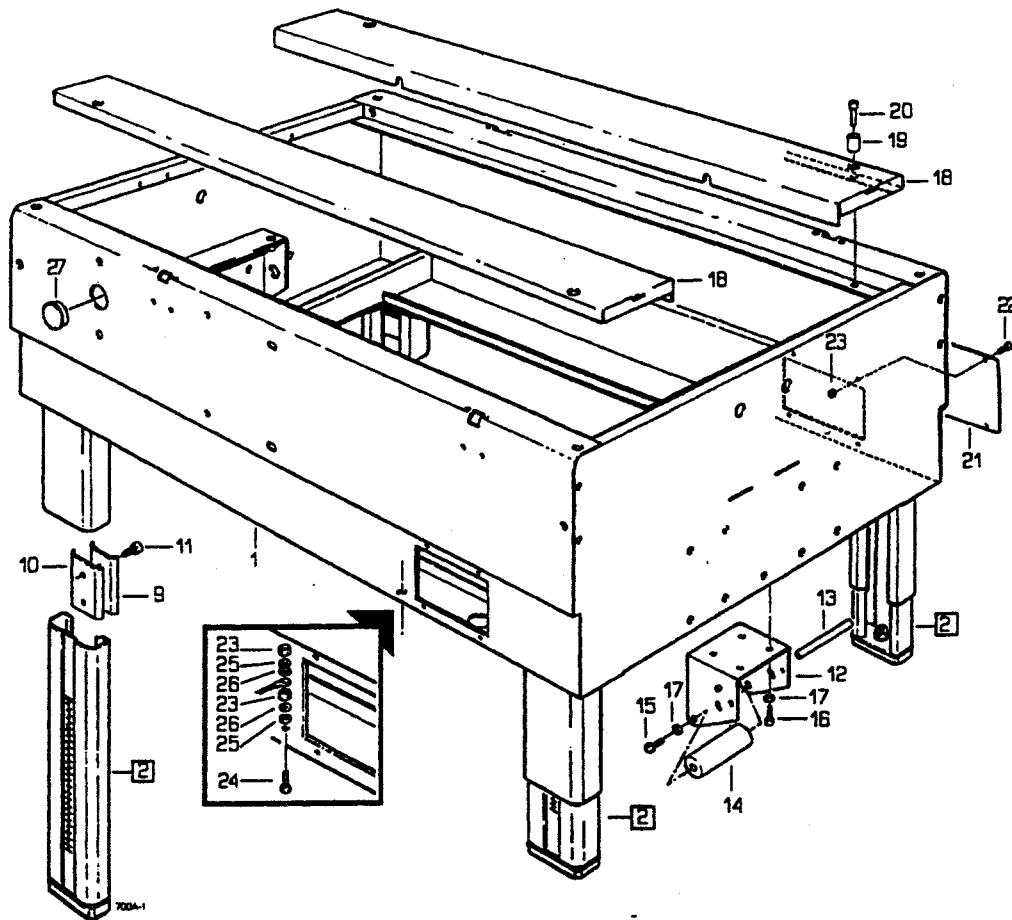


Figure 2802

Figure 2802

Ref. No.	3M Part No.	Description
2802-1	78-8070-1578-5	Bed - Conveyor
2802-2	78-8060-8478-2	Leg Assembly - Inner
2802-3	78-8060-8479-0	Leg - Inner
2802-4	78-8060-8480-8	Pad - Foot
2802-5	78-8055-0867-4	Screw - Hex Hd M8 x 30
2802-6	78-8017-9313-0	Nut - Self Locking M8
2802-7	26-1004-5507-5	Washer - M8
2802-8	78-8060-8481-6	Label - Height
2802-9	78-8052-6676-0	Clamp - Outer
2802-10	78-8052-6677-8	Clamp - Inner
2802-11	26-1003-7963-0	Screw - Soc Hd M8 x 16
2802-12	78-8060-8483-2	Support - Outboard Roll Mount
2802-13	78-8060-8484-0	Shaft - Roller
2802-14	78-8060-8485-7	Roller
2802-15	78-8032-0375-7	Screw - Hex Hd M6 x 16
2802-16	26-1003-7957-2	Screw - Soc Hd Hex Hd M6 x 16
2802-17	26-1000-0010-3	Washer - Flat M6
2802-18	78-8076-4620-9	Plane - Conveyor Bed
2802-19	78-8060-8486-5	Bushing
2802-20	78-8010-7211-3	Screw - Soc Hd M6 x 25
2802-21	78-8060-8487-3	Cover - Switch
2802-22	78-8060-8087-1	Screw - M5 x 10
2802-23	78-8010-7417-6	Nut - Hex M5
2802-24	78-8060-8488-1	Screw - Hex Hd M5 x 20
2802-25	78-8046-8217-3	Washer - Special
2802-26	78-8005-5741-1	Washer - Plain M5
2802-27	78-8076-4701-7	Cap /28
2802-28	78-8060-8060-8	Caster Assembly - /80
2802-29	78-8060-8061-6	Caster - /80
2802-30	78-8060-8124-2	Spacer - Caster
2802-31	78-8060-7699-4	Washer - /12-45,5X4
2802-32	78-8017-9059-9	Washer - Flat For M12 Screw
2802-33	78-8060-7532-7	Nut - Self Locking M12

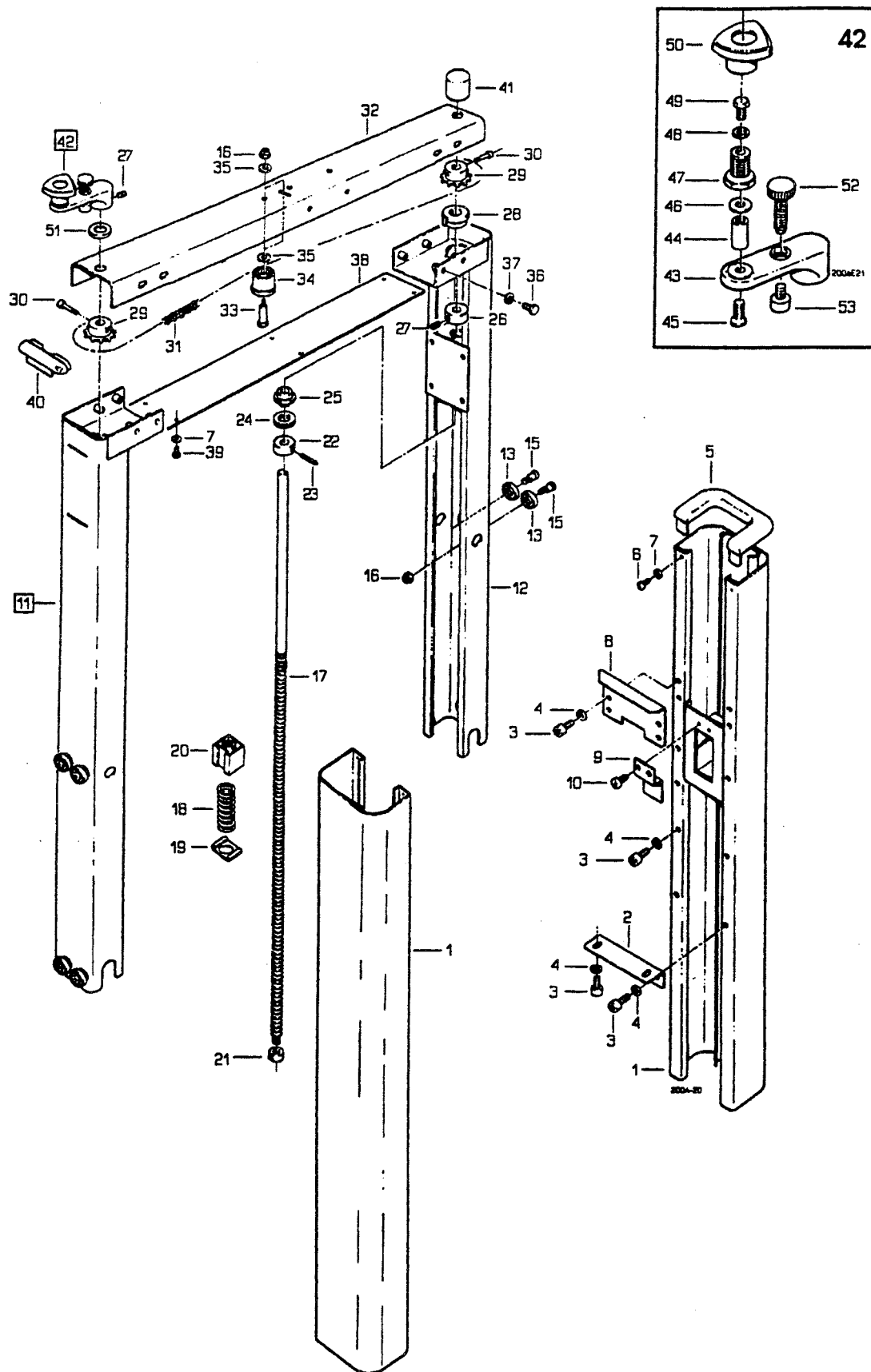


Figure 2803

Figure 2803

Ref. No.	3M Part No.	Description
2803-1	78-8060-8489-9	Column - Outer
2803-2	78-8060-8490-7	Plate - Column Mounting
2803-3	26-1003-7963-0	Screw - Soc Hd M8 x 16
2803-4	78-8017-9318-9	Washer - Plain 8 mm
2803-5	78-8060-8491-5	Cap - Column
2803-6	26-1002-4955-1	Screw - Self Tap 8P x 13
2803-7	78-8005-5740-3	Washer - Plain 4 mm
2803-8	78-8060-8492-3	Stop - Height
2803-9	78-8060-8493-1	Plate - Nut Stop
2803-10	78-8060-8087-1	Screw - M5 x 10
2803-11	78-8060-8494-9	Column Assembly - Inner
2803-12	78-8060-8495-6	Column - Inner
2803-13	78-8054-8617-8	Bearing - Special
2803-15	78-8054-8589-9	Screw - Special
2803-16	26-1003-6916-9	Nut - Locking Plastic Insert M6
2803-17	78-8060-8496-4	Lead Screw
2803-18	78-8054-8997-4	Spring
2803-19	78-8054-8970-1	Bed Plate For Spring
2803-20	78-8054-8571-7	Plastic Nut
2803-21	78-8054-8968-5	Special Nut
2803-22	78-8054-8585-7	Collar
2803-23	78-8054-8586-5	Pin
2803-24	78-8054-8584-0	Spacer
2803-25	78-8054-8583-2	Bushing
2803-26	78-8060-8497-2	Bushing - Lead Screw
2803-27	78-8059-5617-0	Set Screw - M6 x 8
2803-28	78-8060-8498-0	Bushing - Inner Column
2803-29	78-8060-8499-8	Sprocket - 3/8" Z=13
2803-30	78-8070-1500-9	Screw - Soc Hd Hex Hd M4 x 25
2803-31	78-8070-1501-7	Chain - 3/8" P=156
2803-32	78-8070-1502-5	Housing - Chain
2803-33	78-8060-7878-4	Idler Screw
2803-34	78-8070-1503-3	Roller - Chain Tensioning
2803-35	78-8042-2919-9	Washer - M6
2803-36	26-1003-5828-7	Screw - Hex Hd M6 x 12
2803-37	26-1000-0010-3	Washer - Flat M6
2803-38	78-8070-1504-1	Cover
2803-39	26-1002-5753-9	Screw - Self Tapping
2803-40	78-8070-1505-8	Cap - Inner Column
2803-41	78-8070-1506-6	Cover - Screw
2803-42	78-8076-4705-8	Crank Assembly W/Block
2803-43	78-8070-1508-2	Crank
2803-44	78-8070-1509-0	Shaft - Crank
2803-45	26-1005-5316-8	Screw - Flat Hd Hex Dr M5 x 16
2803-46	78-8070-1510-8	Washer - Nylon /7X15X1
2803-47	78-8070-1511-6	Bushing
2803-48	78-8005-5740-3	Washer - Plain 4 mm
2803-49	78-8010-7157-8	Screw - Hex Hd M4 x 10
2803-50	78-8070-1512-4	Knob - VTR-B-M12
2803-51	78-8070-1548-8	Washer - Nylon 20X12, 5X1
2803-52	78-8076-4703-3	Block - Crank
2803-53	78-8060-8080-6	Guard - Stop

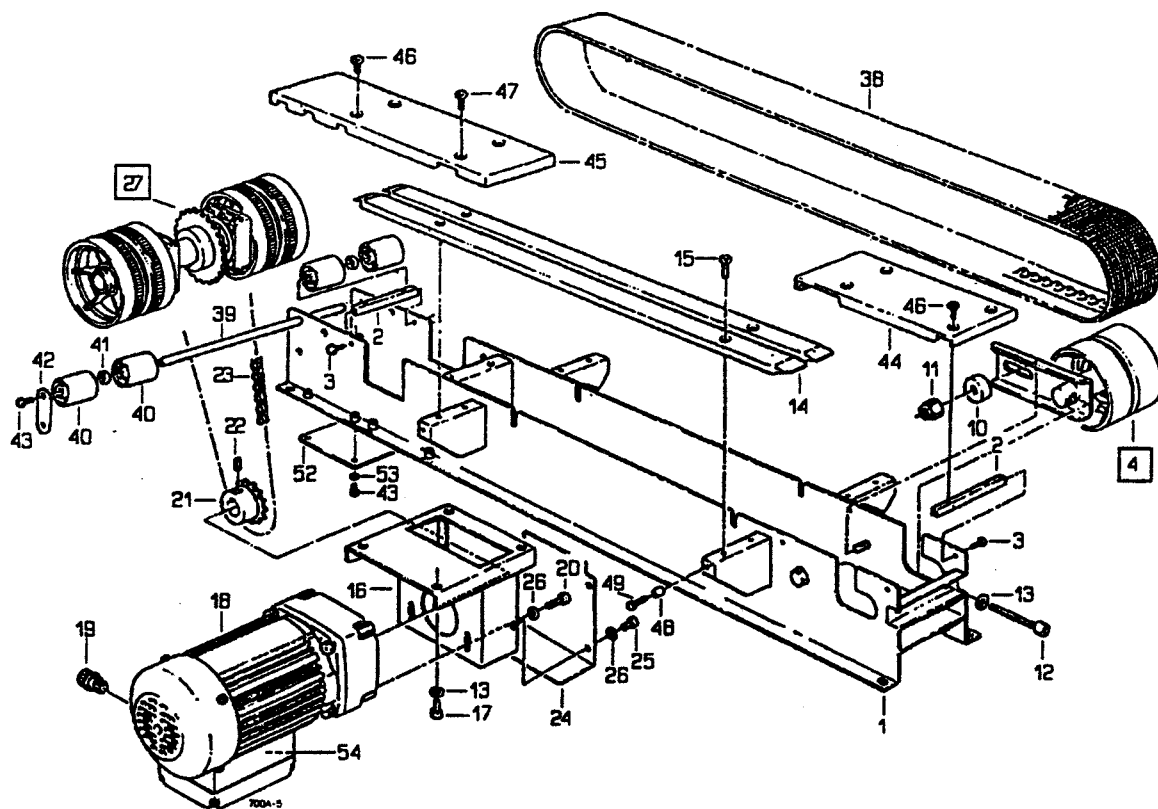


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Figure 2804 (Page 1 of 2)

Ref. No.	3M Part No.	Description
2804-1	78-8070-1580-1	Frame - Drive
2804-2	78-8070-1514-0	Spacer
2804-3	26-1003-5828-7	Screw - Hex Hd M6 x 12
2804-4	78-8070-1516-5	Belt - Tensioning Assembly
2804-5	78-8070-1517-3	Belt - Tensioning
2804-6	78-8052-6710-7	Roller - Idler
2804-7	78-8052-6709-9	Washer - Special
2804-8	78-8010-7435-8	Washer - Lock M6
2804-9	26-1003-7957-2	Screw - Soc Hd Hex Hd M6 x 16
2804-10	78-8070-1518-1	Spacer - Shaft
2804-11	26-1003-6918-5	Nut - Plastic Insert Hex Flange M10
2804-12	78-8070-1519-9	Screw - Soc Hd Hex Hd M8 x 70
2804-13	78-8017-9318-9	Washer - Plain 8 mm
2804-14	78-8070-1520-7	Guide - Drive Belt
2804-15	26-1005-4758-2	Screw - Flat Hd M5 x 20
2804-16	78-8070-1521-5	Support - Gearbox
2804-17	26-1003-7963-0	Screw - Soc Hd M8 x 16
2804-18	78-8070-1522-3	Gearmotor - 115V, 60HZ
2804-19	78-8057-5807-1	Cord Grip
2804-20	78-8070-1523-1	Screw - 1/4 - 28X1/2 SHCS
2804-21	78-8070-1524-9	Sprocket - 3/8" Z=17
2804-22	78-8023-2479-4	Screw - Set W/End Cup M6 x 10
2804-23	78-8070-1525-6	Chain - 3/8" P=54
2804-24	78-8070-1526-4	Cover - Chain

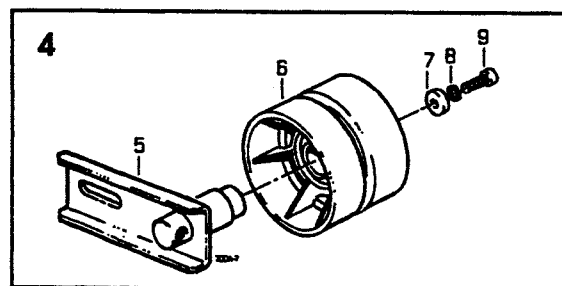
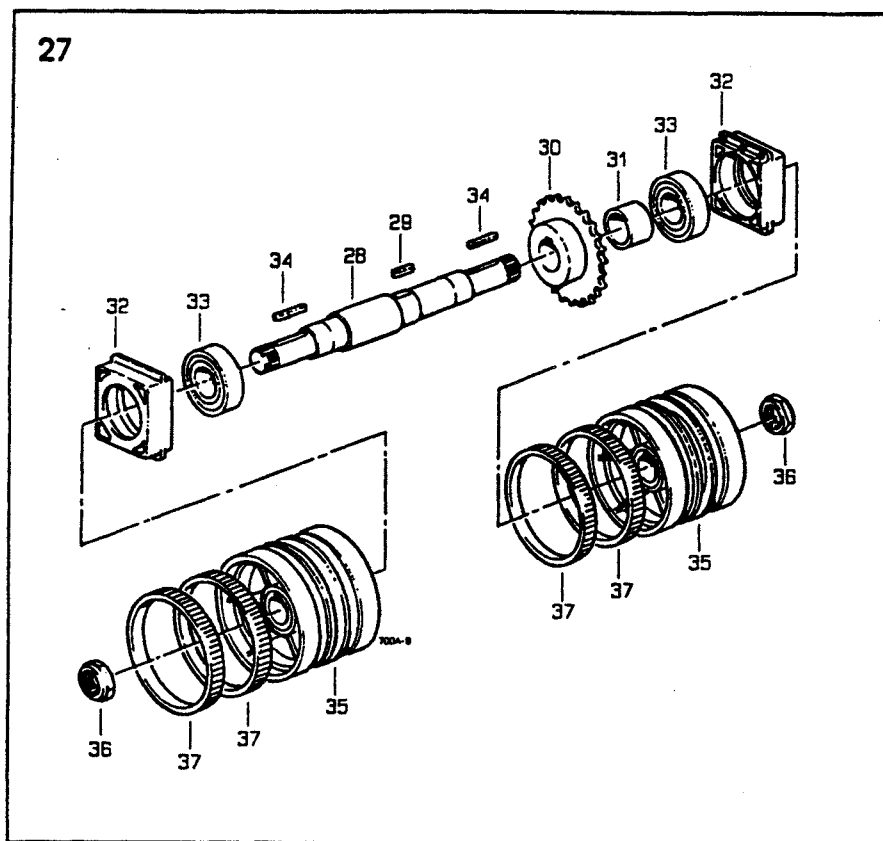
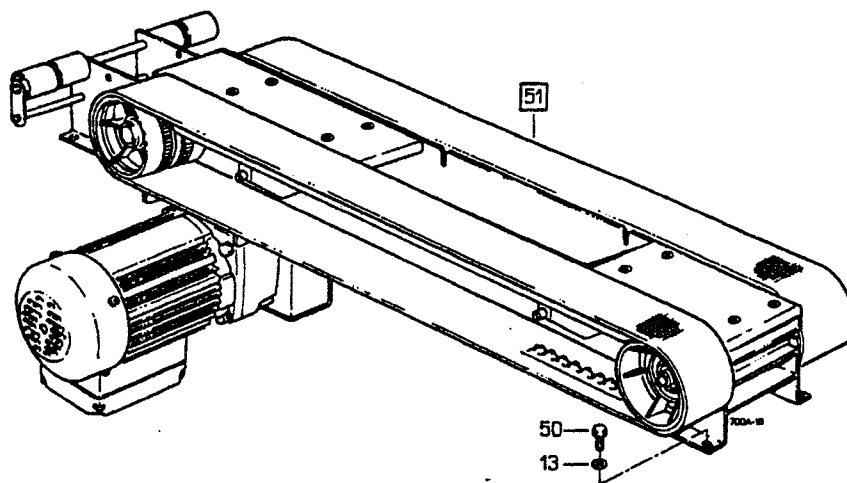


Figure 2804/2 of 2

Figure 2804 (Page 2 of 2)

Ref. No.	3M Part No.	Description
2804-25	78-8010-7209-7	Screw - Soc Hd M6 x 12
2804-26	26-1000-0010-3	Washer - Flat M6
2804-27	78-8070-1527-2	Shaft With Drive Pulleys
2804-28	78-8070-1528-0	Shaft - Gearbox
2804-29	78-8057-5811-3	Key - 6 x 6 x 20 mm
2804-30	78-8054-8986-7	Sprocket - 3/8" Pitch, 28 Teeth
2804-31	78-8054-8984-2	Bushing
2804-32	78-8070-1529-8	Support - Shaft
2804-33	78-8070-1530-6	Bearing - 6206-2RS
2804-34	78-8057-5739-6	Key - M5 x 5 x 30 mm
2804-35	78-8060-8072-3	Roller - Drive
2804-36	78-8060-8416-2	Nut - Special M20 x 1
2804-37	78-8052-6713-1	Ring - Polyurethane
2804-38	78-8070-1531-4	Belt - Drive With Hook
2804-39	78-8070-1581-9	Shaft - Roller
2804-40	78-8060-7693-7	Roller - 32 x 38
2804-41	78-8070-1582-7	Spacer - Roller
2804-42	78-8070-1583-5	Plate - Drive
2804-43	26-1003-5820-4	Screw - Hex Hd M5 x 12
2804-44	78-8070-1584-3	Cover - Drive, Front
2804-45	78-8070-1585-0	Cover - Drive, Rear
2804-46	26-0001-5862-1	Screw - Flat Hd Soc M5 x 12
2804-47	26-1005-5316-8	Screw - Flat Hd Hex Dr M5 x 16
2804-48	78-8070-1534-8	Stud - Side Plate
2804-49	78-8060-8488-1	Screw - Hex Hd M5 x 20
2804-50	26-1003-5841-0	Screw - M8 x 16
2804-51	78-8070-1586-8	Bottom Drive Assembly
2804-52	78-8076-4562-3	Cover - Bottom
2804-53	78-8005-5741-1	Washer - Plain M5
2804-54	78-8076-4515-1	Capacitor - 115V Gearmotor

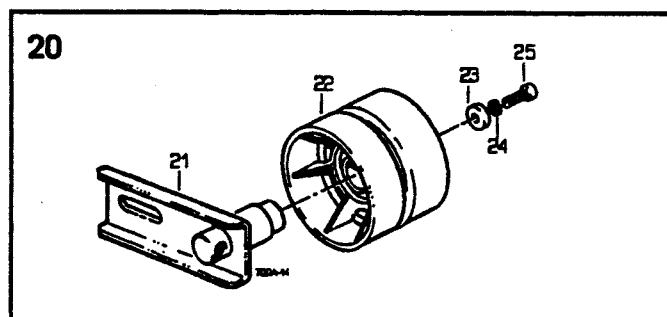


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Ref. No.	3M Part No.	Description
2805-1	78-8070-1587-6	Upper Drive Assembly
2805-2	78-8070-1588-4	Frame - Drive, Upper
2805-3	78-8070-1520-7	Guide - Drive Belt
2805-4	26-1005-4758-2	Screw - Flat Hd M5 x 20
2805-5	78-8070-1589-2	Clamp - Upper Head
2805-6	78-8070-1590-0	Shaft - Roller
2805-7	78-8060-8087-1	Screw - M5 x 10
2805-8	78-8070-1514-0	Spacer
2805-9	78-8010-7169-3	Screw - Hex Hd M6 x 12
2805-10	26-1000-0010-3	Washer - Flat M6
2805-11	78-8070-1591-8	Shaft - Roller /15X106
2805-12	78-8052-6641-4	Roller
2805-13	78-8070-1592-6	Spacer - Roller
2805-14	26-1003-5841-0	Screw - M8 x 16
2805-15	78-8017-9318-9	Washer - Plain 8 mm
2805-16	78-8060-7693-7	Roller - 32 x 38
2805-17	78-8070-1593-4	Spacer - Roller
2805-18	26-1003-5820-4	Screw - Hex Hd M5 x 12
2805-19	78-8005-5741-1	Washer - Plain M5
2805-20	78-8070-1516-5	Belt Tensioning Assembly
2805-21	78-8070-1517-3	Belt Tensioning
2805-22	78-8052-6710-7	Roller - Idler
2805-23	78-8052-6709-9	Washer - Special
2805-24	78-8010-7435-8	Washer - Lock M6
2805-25	26-1003-7957-2	Screw - Soc Hd Hex Hd M6 x 16
2805-26	78-8070-1518-1	Spacer - Shaft
2805-27	26-1003-6918-5	Nut - Plastic Insert Hex Flange M10
2805-28	78-8070-1594-2	Screw - Hex Hd M8 x 60
2805-29	78-8070-1527-2	Shaft With Drive Pulleys

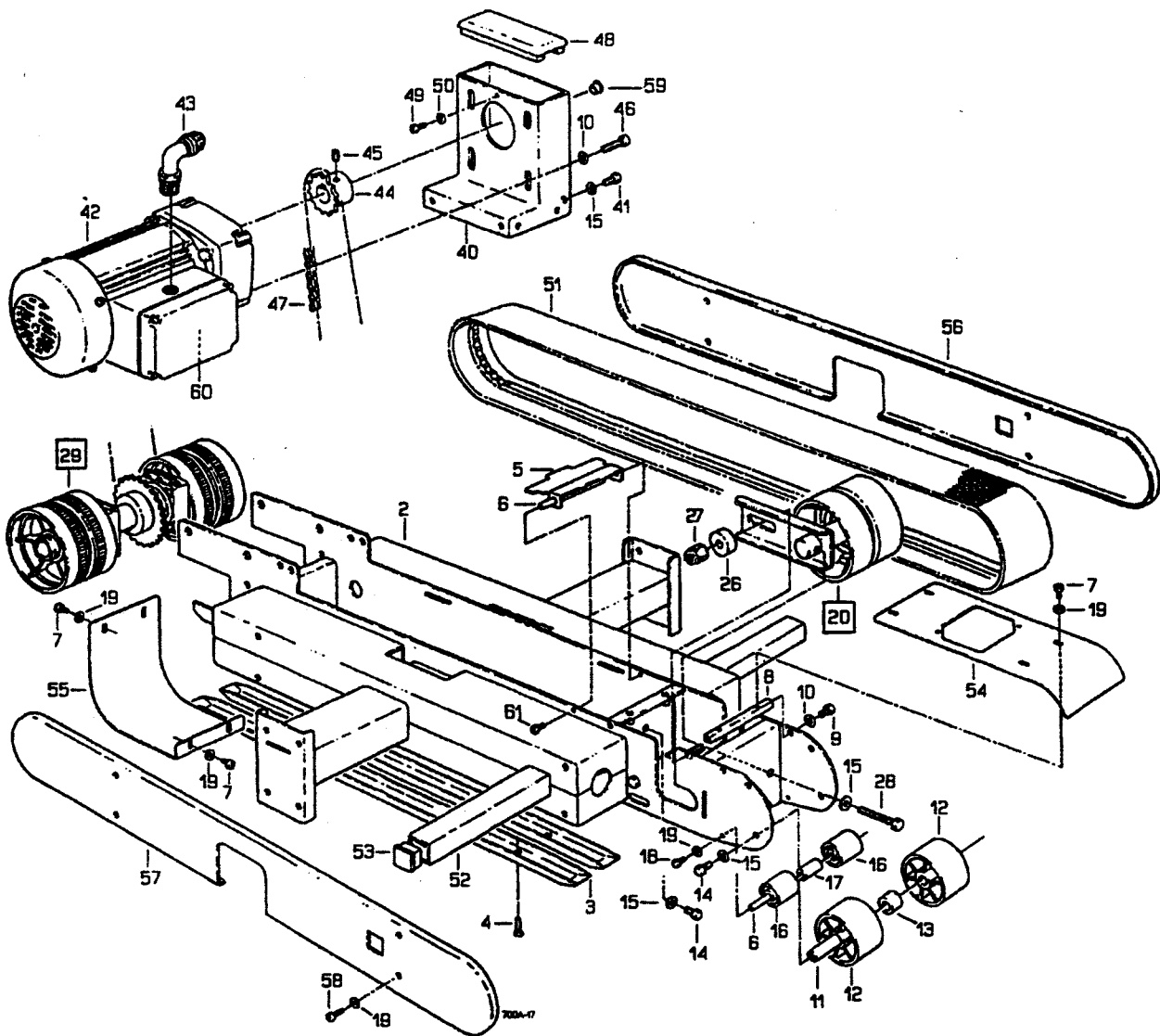


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Figure 2805 (Page 2 of 2)

Ref. No.	3M Part No.	Description
2805-30	78-8070-1528-0	Shaft - Gearbox
2805-31	78-8057-5811-3	Key - 6 x 6 x 20
2805-32	78-8054-8986-7	Sprocket - 3/8" Pitch, 28 Teeth
2805-33	78-8054-8984-2	Bushing
2805-34	78-8070-1529-8	Support - Shaft
2805-35	78-8070-1530-6	Bearing - 6205 - 2RS
2805-36	78-8057-5739-6	Key - M5 x 5 x 30 mm
2805-37	78-8060-8072-3	Roller - Drive
2805-38	78-8060-8416-2	Nut - Special M20 x 1
2805-39	78-8052-6713-1	Ring - Polyurethane
2805-40	78-8070-1595-9	Support - Drive
2805-41	26-1003-5842-8	Screw - Hex Hd M8 x 20
2805-42	78-8070-1522-3	Gearmotor - 115V, 60HZ
2805-43	78-8070-1596-7	Union - Elbow PG 13,5
2805-44	78-8070-1524-9	Sprocket - 3/8" Z=17
2805-45	78-8023-2479-4	Screw - Set W/End Cup, M6 x 10
2805-46	78-8070-1523-1	Screw - 1/4-28 x 1/2 SHCS
2805-47	78-8070-1597-5	Chain - 3/8" P=62
2805-48	78-8070-1598-3	Cover
2805-49	26-1002-4955-1	Screw - Self Tap 8P x 13
2805-50	78-8005-5740-3	Washer - Plain 4 mm
2805-51	78-8070-1531-4	Belt - Drive, With Hook
2805-52	78-8070-1599-1	Tube - Compression Roller
2805-53	78-8052-6652-1	Cap - End
2805-54	78-8076-4621-7	Cover - Front, Upper
2805-55	78-8076-4622-5	Cover - Rear, Upper
2805-56	78-8076-4623-3	Cover - Upper, Right
2805-57	78-8076-4624-1	Cover - Upper , Left
2805-58	78-8076-4625-8	Screw - Special M5 x 16
2805-59	78-8054-8821-6	End - Cap
2805-60	78-8076-4515-1	Capacitor - 115V Gearmotor
2805-61	26-1003-7948-1	Screw - Soc Hd Hex Soc M5 x 10

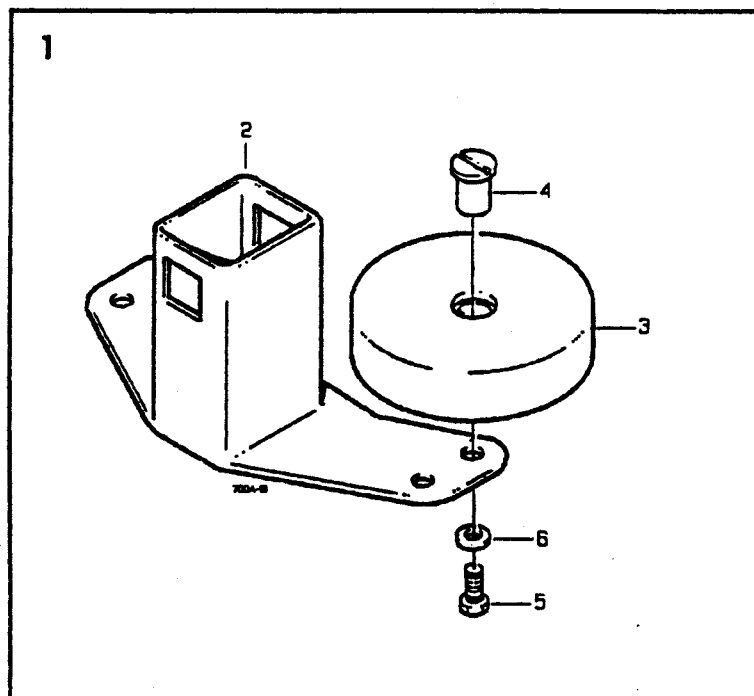
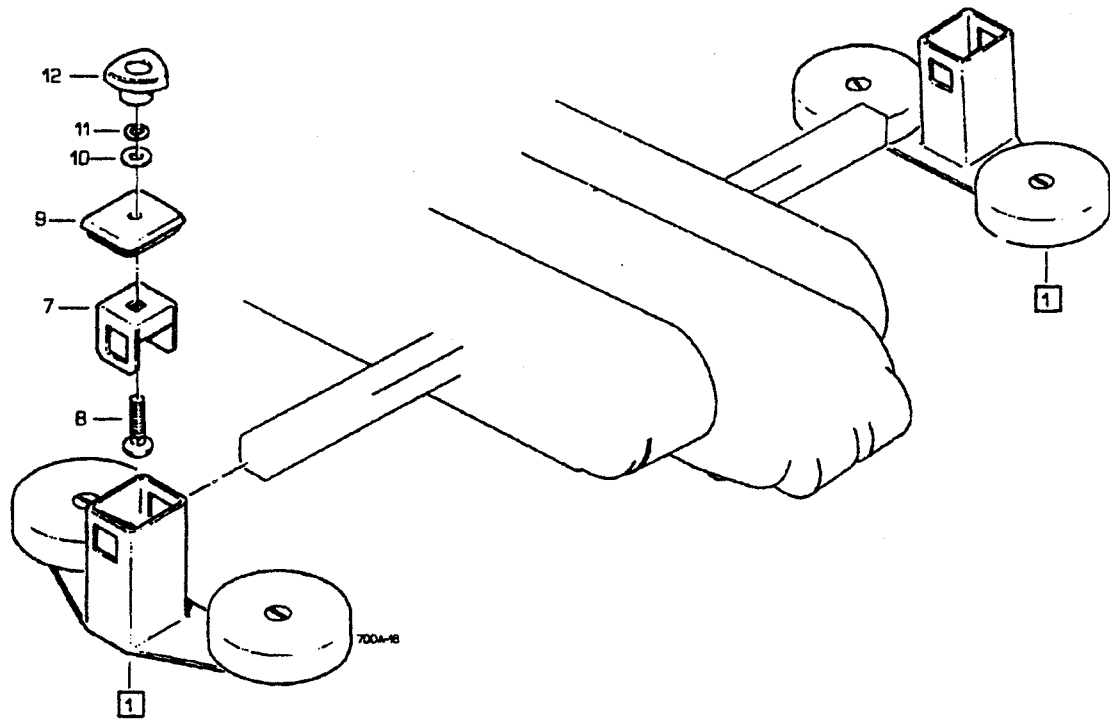


Figure 2806

Figure 2806

Ref. No.	3M Part No.	Description
2806-1	78-8076-4626-6	Compression Roller Assembly
2806-2	78-8076-4627-4	Support - Compression Roller
2806-3	78-8076-4628-2	Roller - Compression
2806-4	78-8076-4629-0	Shaft - Roller
2806-5	26-1003-5841-0	Screw - M8 x 16
2806-6	78-8017-9318-9	Washer - Plain 8 mm
2806-7	78-8076-4630-8	Plate - Tube, Roller
2806-8	78-8076-4631-6	Screw - M10 x 35
2806-9	78-8076-4632-4	Cap - Support
2806-10	78-8017-9074-8	Washer - Nylon 15 mm
2806-11	78-8052-6566-3	Washer - Friction
2806-12	78-8070-1549-6	Knob - VTR-B-M10

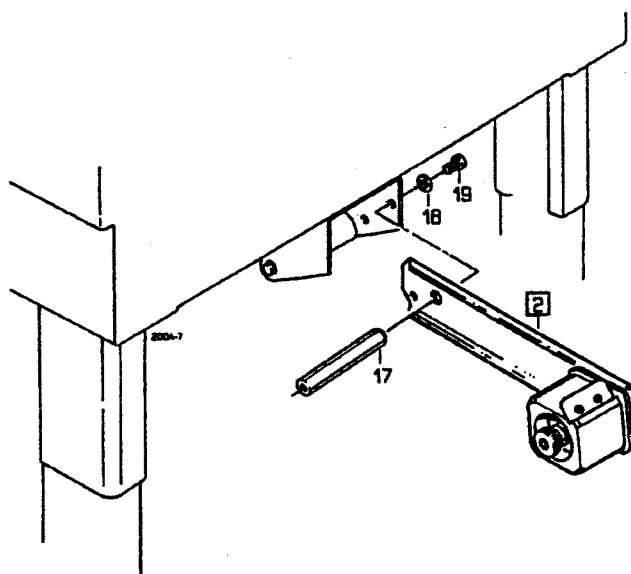
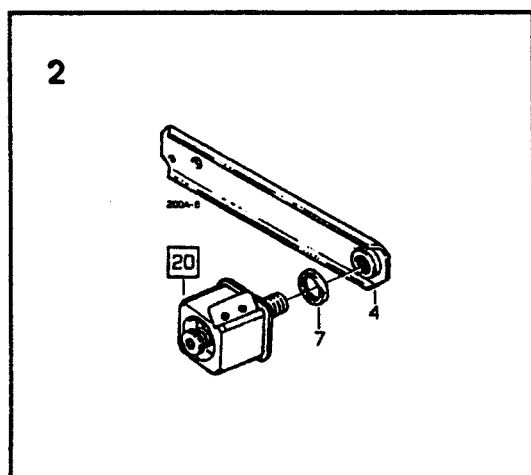
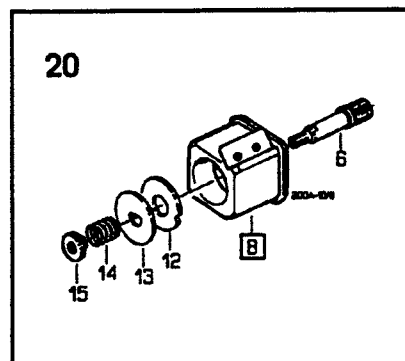
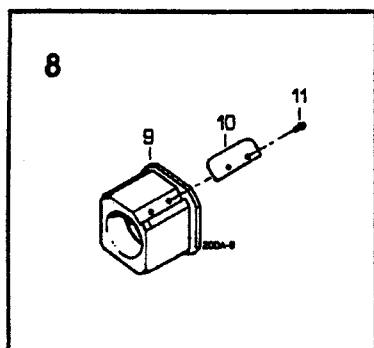
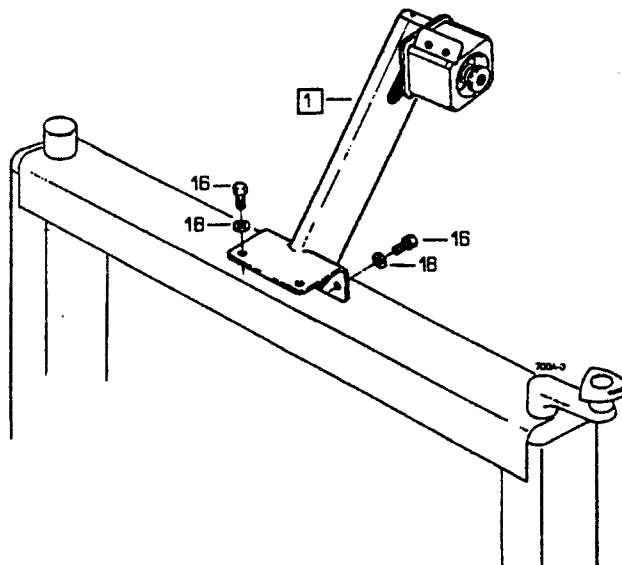
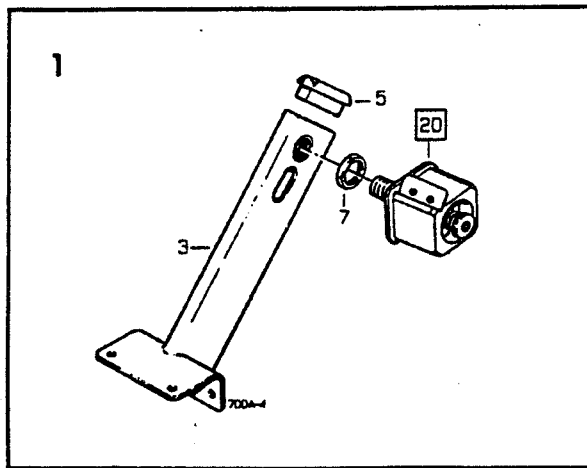


Figure 2807

Figure 2807

Ref. No.	3M Part No.	Description
2807-1	78-8076-4633-2	Tape Roll Bracket Assembly
2807-2	78-8070-1565-2	Tape Drum Bracket Assembly
2807-3	78-8070-1566-0	Bracket - Tape Drum
2807-4	78-8070-1395-4	Bracket - Bushing Assembly
2807-5	78-8070-1568-6	Cap - Bracket
2807-6	78-8076-4519-3	Shaft - Tape Drum
2807-7	78-8017-9169-6	Nut - M18 x 1
2807-8	78-8070-1569-4	Tape Drum Assembly
2807-9	78-8052-6749-5	Tape Drum Assembly
2807-10	78-8052-6268-6	Leaf Spring
2807-11	26-1002-5753-9	Screw - Self Tapping
2807-12	78-8060-8172-1	Washer - Friction
2807-13	78-8052-6271-0	Washer - Tape Drum
2807-14	78-8054-8826-5	Spring
2807-15	78-8060-7851-1	Ring Nut - Adjusting
2807-16	78-8060-7886-7	Screw - Hex Hd M6 x 16
2807-17	78-8070-1215-4	Spacer - Stud
2807-18	26-1000-0010-3	Washer - Flat M6
2807-19	78-8010-7169-3	Screw - Hex Hd M6 x 12
2807-20	78-8060-8474-1	Tape Drum Assembly - 2 Inch Head

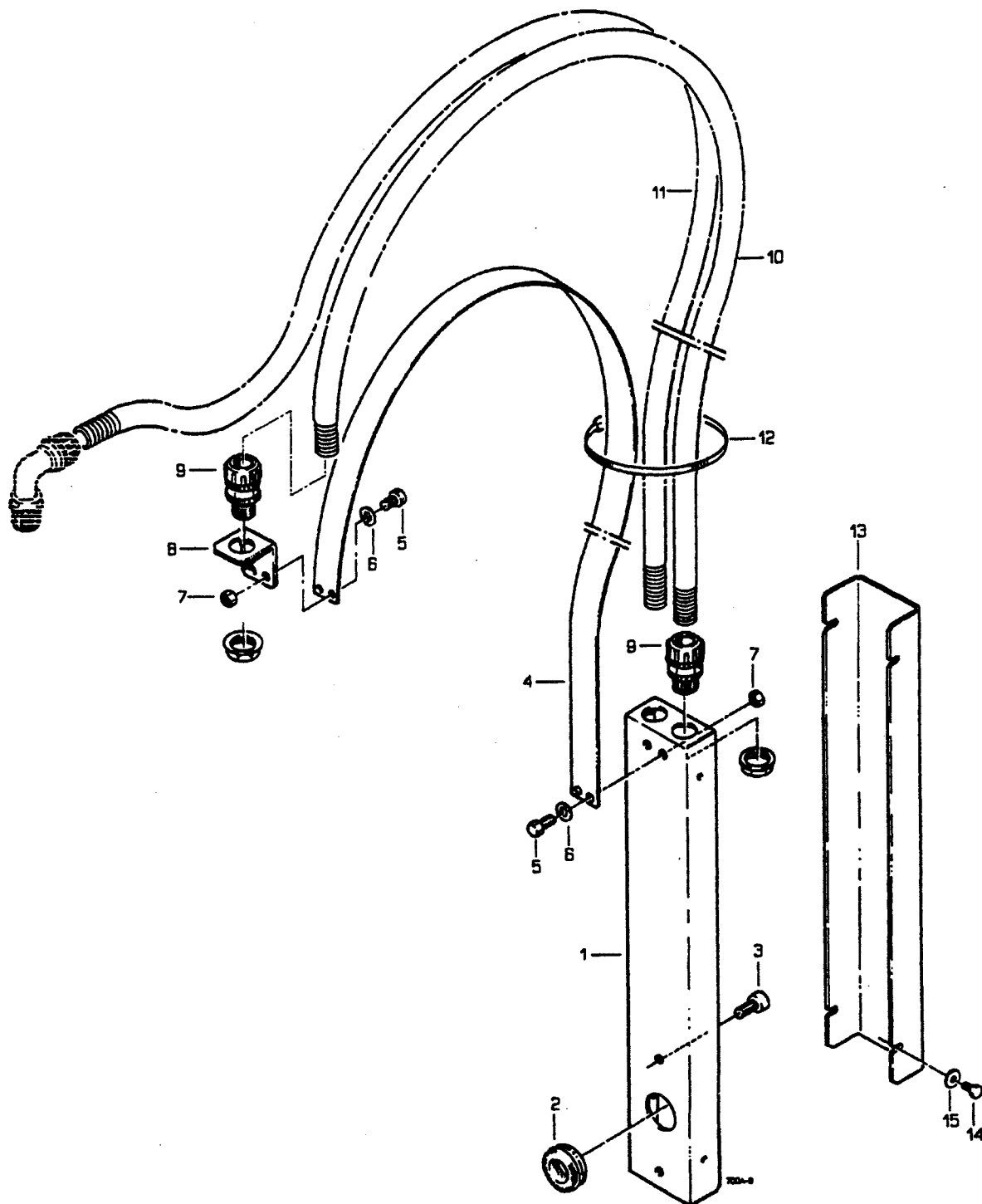


Figure 2808

Figure 2808

Ref. No.	3M Part No.	Description
2808-1	78-8076-4634-0	Housing - Wire
2808-2	78-8076-4702-5	Grommet - /28
2808-3	26-1003-7963-0	Screw - Soc Hd M8 x 16
2808-4	78-8076-4636-5	Strap - Wire
2808-5	78-8010-7163-6	Screw - Hex Hd M5 x 10
2808-6	78-8005-5741-1	Washer - Plain M5
2808-7	78-8010-7417-6	Nut - Hex M5
2808-8	78-8076-4637-3	Plate - Strap
2808-9	78-8076-4638-1	Union - PG13,5
2808-10	78-8076-4639-9	Sleeving - Wire
2808-11	78-8076-4640-7	Sleeving - Wire
2808-12	78-8060-8029-3	Clamp - 140 x 3,5
2808-13	78-8076-4641-5	Cover
2808-14	26-1003-5810-5	Screw - Hex Hd M4 x 8
2808-15	78-8017-9018-5	Washer - Plain, Spec. M4

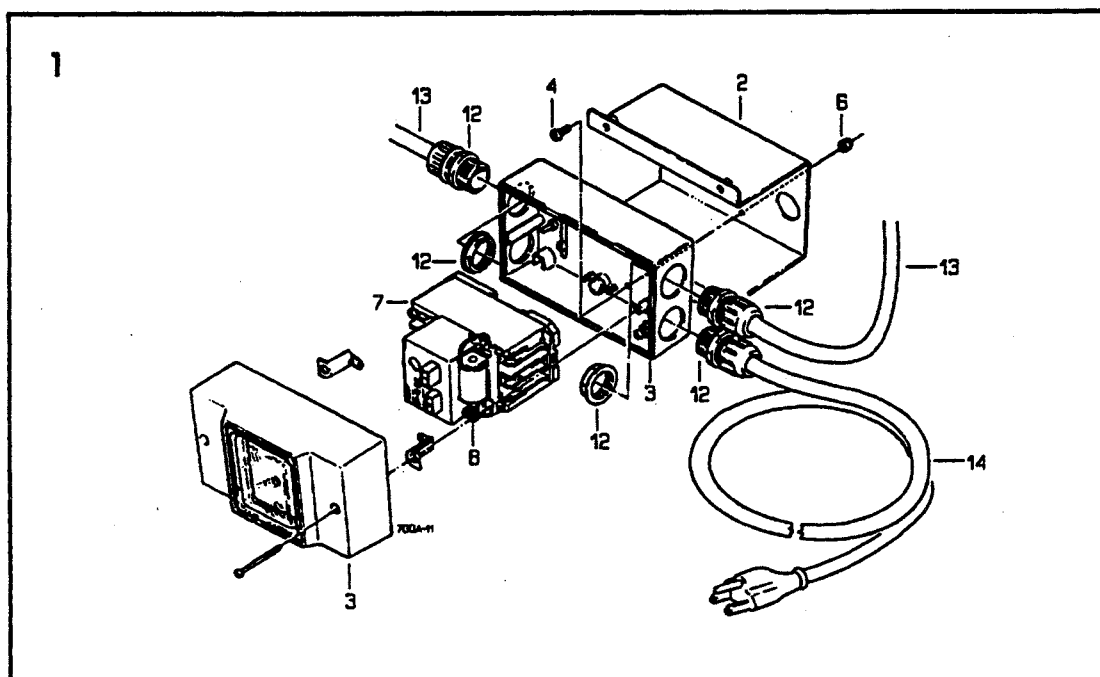
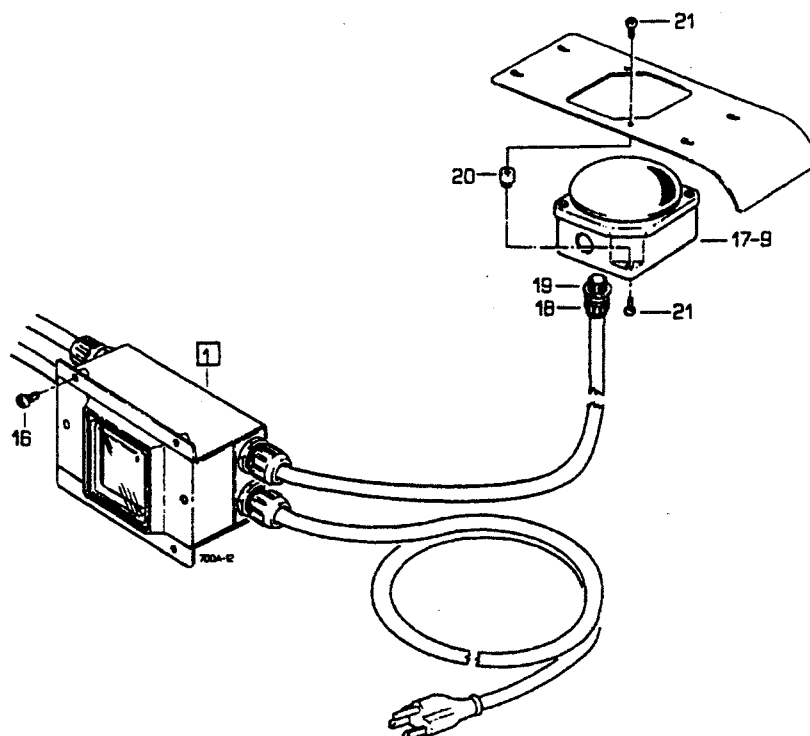


Figure 2809

Figure 2809

Ref. No.	3M Part No.	Description
2809-1	78-8076-4642-3	On/Off Switch W/Coil
2809-2	78-8070-1572-8	Support - Switch
2809-3	78-8070-1573-6	Box - On/Off Switch
2809-4	78-8017-9257-9	Screw - M4 X 10
2809-6	26-1003-6914-4	Nut - Plastic Insert M4
2809-7	78-8076-4506-0	Switch - On/Off W/Coil 4-6 (set at 4.5 Amps)
2809-8	78-8076-4643-1	Coil - Low Tension, 110V
2809-12	78-8057-5807-1	Cord Grip
2809-13	78-8060-8053-3	Cable - 3X1,5 5MT 1PH
2809-14	78-8028-7909-4	Power Cord U.S.A.
2809-16	78-8060-8087-1	Screw - M5 X 10
2809-17	78-8060-7633-3	Safety Button
2809-18	78-8076-4532-6	Union
2809-19	78-8076-4645-6	Lock Nut - GMP11
2809-20	78-8076-4646-4	Bushing
2809-21	78-8060-7815-6	Screw - M4 X 8

3M Parts Order Form

Form 26989 - 3 - D

- Shaded Areas To Be Filled In By 3M -

Mail To: Dispenser Parts
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Amery, WI 54001

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800-344-9883 (Outside Wisc.)
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\$25.00 Minimum Order

