



Instructions and Parts List

3M-MaticTM

700rks Type 19300

**Random
Case Sealer**

with

AccuGlideTM II

Taping Heads



Important Safeguards

Turn to page two
for operating
safety information.

Important

It is recommended you immediately order the spare parts listed on page 49. These parts are expected to wear through normal use, and should be kept on hand to minimize production delays.

3M Packaging Systems Division

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

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Litho in U.S.A.

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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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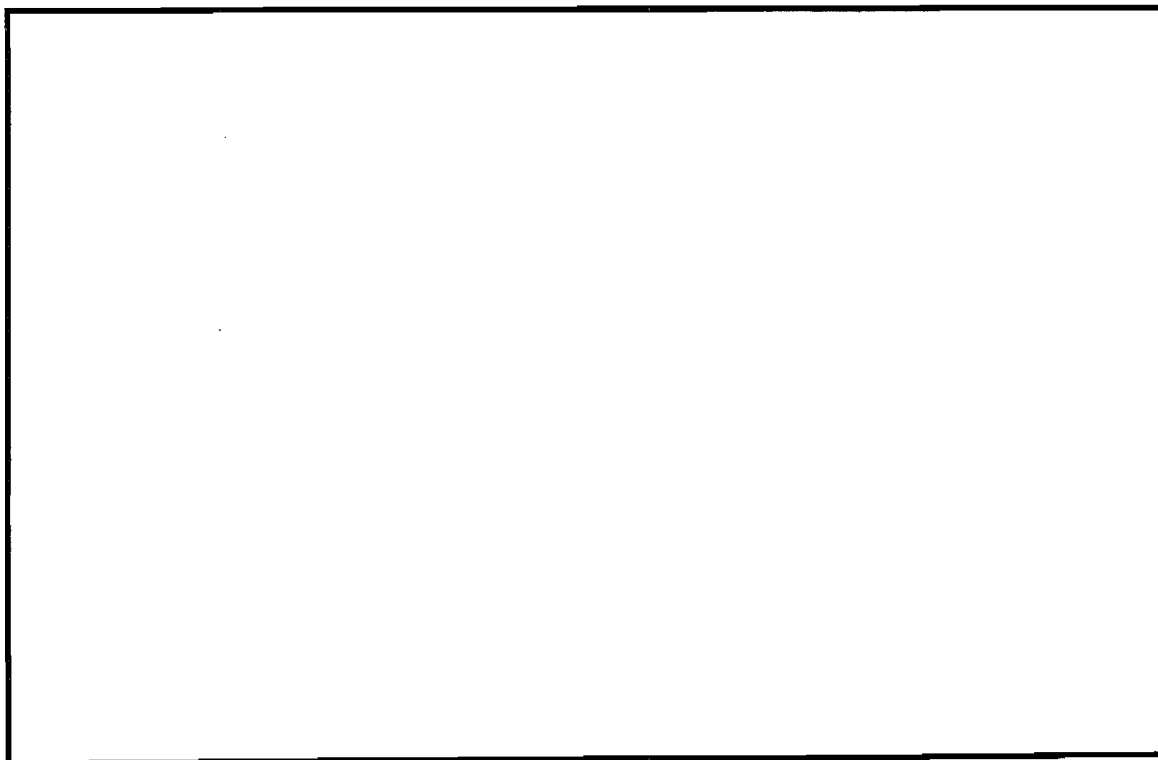
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To Our Customers:

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 any problems occur when operating this equipment, and you desire a service call, or phone consultation, call, write or Fax the appropriate number listed below.

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

**SERVICE, REPLACEMENT PARTS AND ADDITIONAL MANUALS
AVAILABLE DIRECT FROM:**



Order parts by part number, part description and quantity required. Also, when ordering parts and/or additional manuals, include machine name, number and type.



3M Packaging Systems Division

3M Center, Building 220-8W-01
St. Paul, MN 55144-1000
1-800/328 1390

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Instruction Manual

700rks Random Case Sealer
Type 19300

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

3M sells its **3M-Matic™ 700rks Random Case Sealer, Type 19300** with the following warranties:

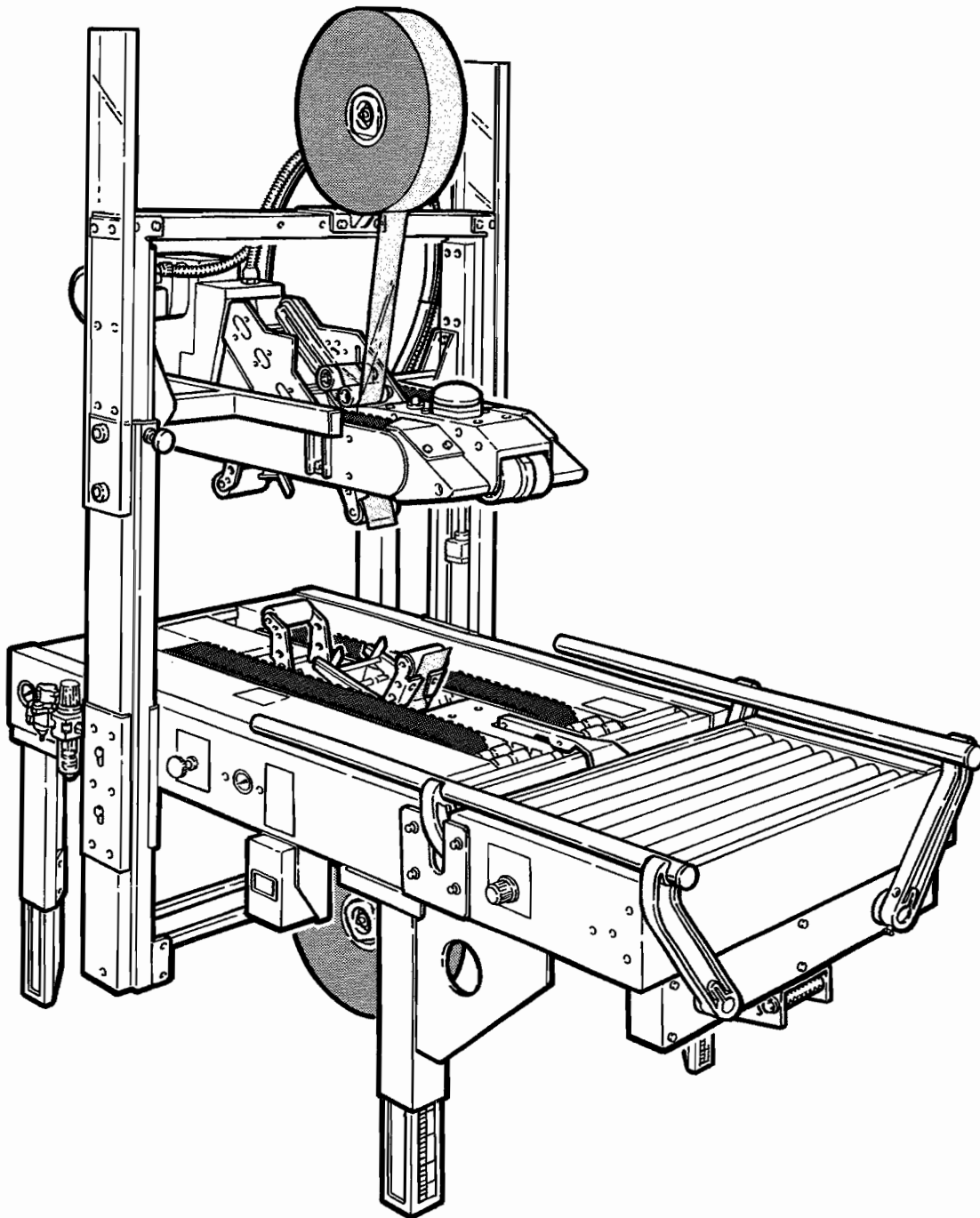
1. The drive belts and the taping head knives, springs and rollers will be free from all defects for ninety (90) days after delivery.
2. All other taping head parts will be free from all defects for three (3) years after delivery.
3. All other parts will be free from all defects for two (2) years after 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.

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3M-Matic™ 700rks Random Case Sealer, Type 19300

Description

The **3M-Matic™ 700rks Random 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 700rks will automatically adjust to a wide range of random box sizes (see "Specifications - Box Weight and Size Capacities", page 10).

Important Safeguards

There are three 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 taping head frame at the location of the cut-off blade on the upper taping head. Two of the same labels are attached to the machine bed at the location of the cut-off blade on the lower tape 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 colored 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 should never be operated with the blade guards removed.

Turn electrical supply off and disconnect before servicing the taping heads.

The "Warning – Hazardous Voltage" label, shown in Figure 1-2, is attached to the machine 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.

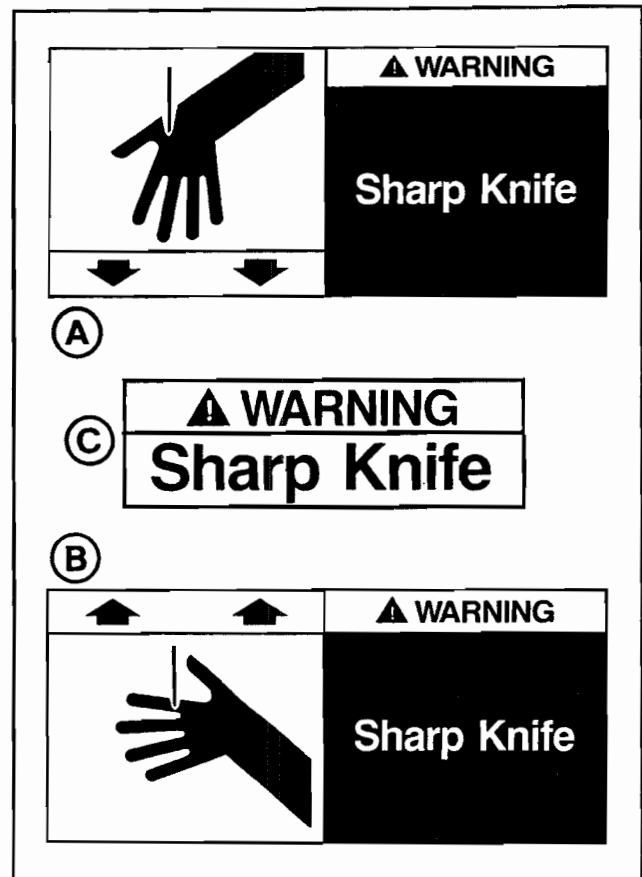


Figure 1-1 – Knife Warning Labels

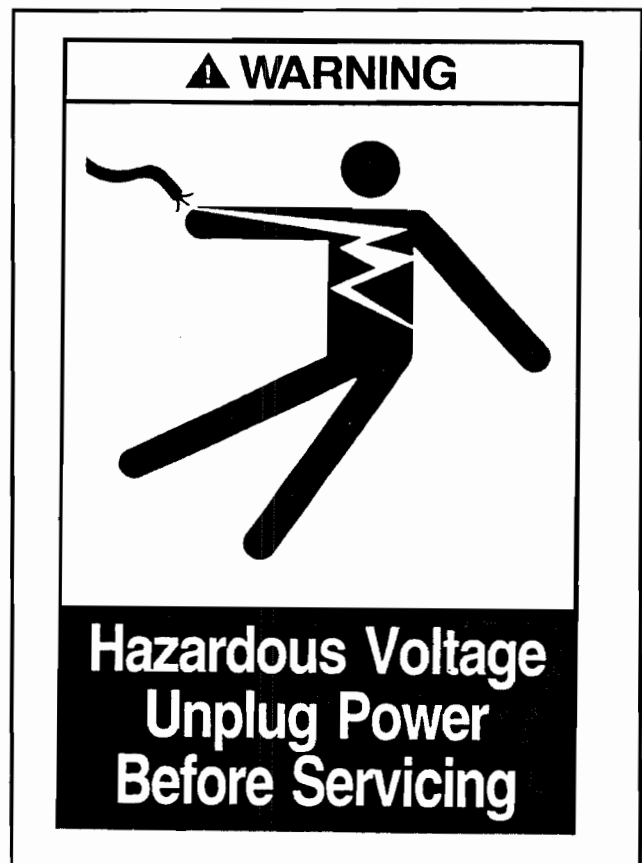


Figure 1-2 – Electrical Warning Label

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 taping head frame – infeed end. The labels warn operators and service personnel to keep hands away from this area when the drive belts are running.

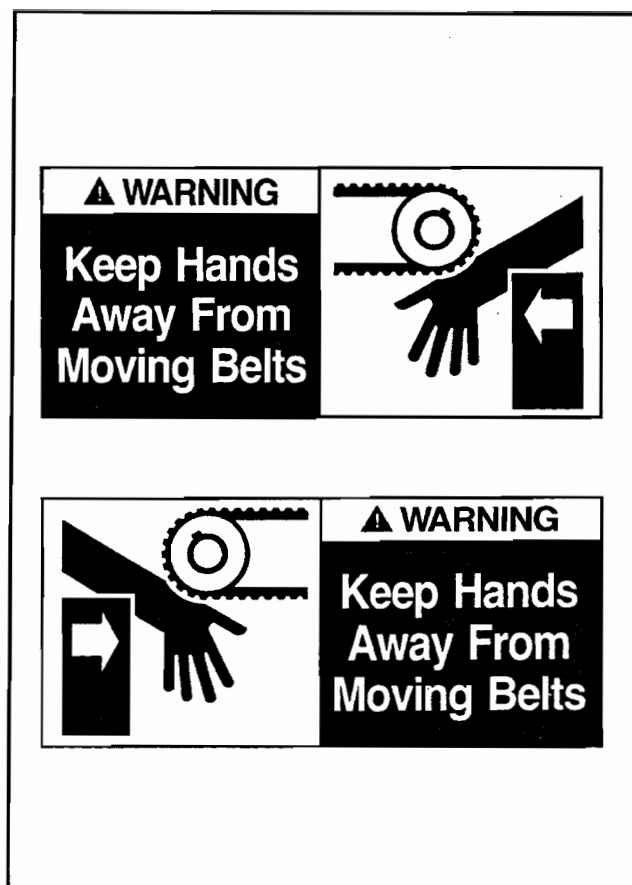


Figure 1-3 – Hands Warning Label

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 machine bed. The label warns the operator to keep hands out of this area when the drive belts are running.

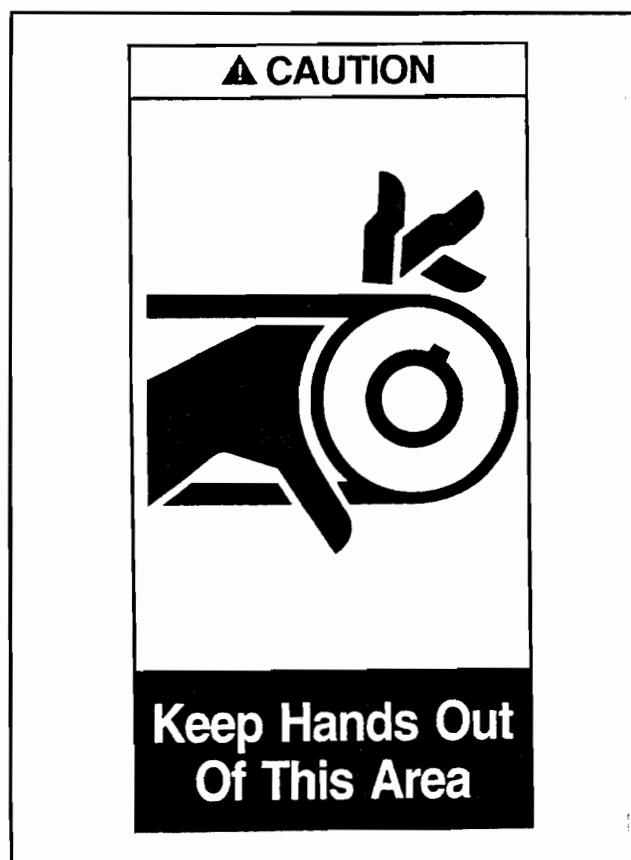


Figure 1-4 – Hands Caution Label

Important Safeguards (Continued)

The "Caution – Keep Hands Out Of This Area" label, shown in Figure 1-5 is attached to the upper end of both plastic column guards. It warns the operator to keep hands away from this area when machine is operating.



Figure 1-5 – Hands Caution Label

The "Safety Instructions" label, shown in Figure 1-6, is attached to the top front of the left outer column assembly. The label provides convenient safeguard instructions for the operator and service personnel.

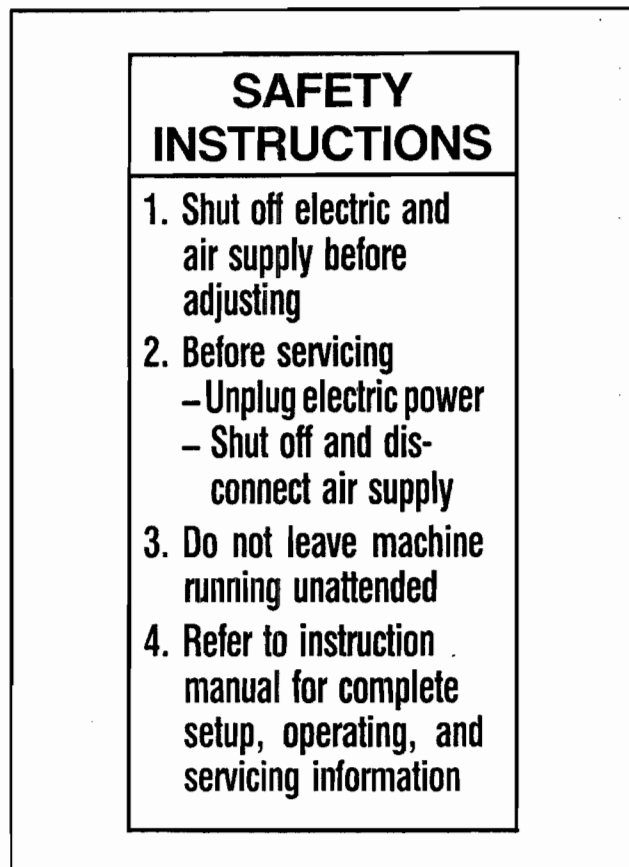


Figure 1-6 – Safety Instructions Label

Important Safeguards (Continued)

The "Safety Instructions" label shown in Figure 1-7, is attached to the left side of the machine frame next to the main air regulator. It alerts the operator of minimum/maximum air pressure required to operate the case sealer.

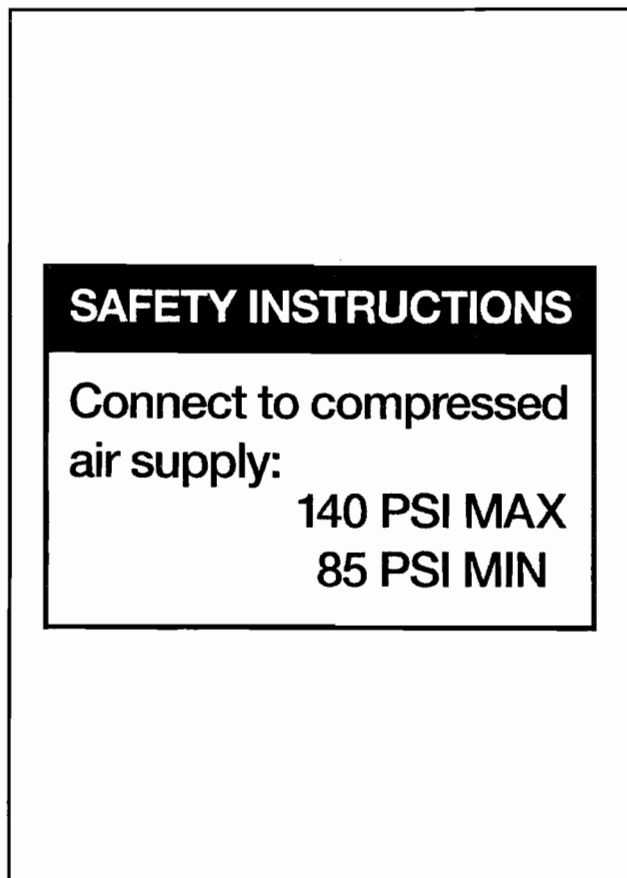


Figure 1-7 – Safety Instructions Label

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

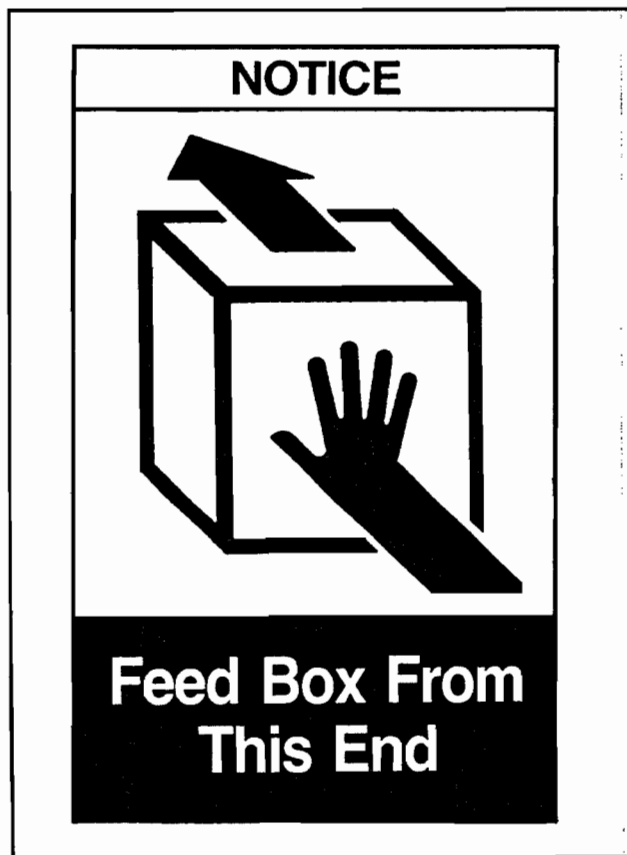


Figure 1-8 – Box Feed Label

Important Safeguards (Continued)

The "Notice – Raise and Lower Upper Drive Assembly" label, shown in Figure 1-9, is attached to the left plastic column guard. The label provides instructions on raising and lowering the upper drive assembly.

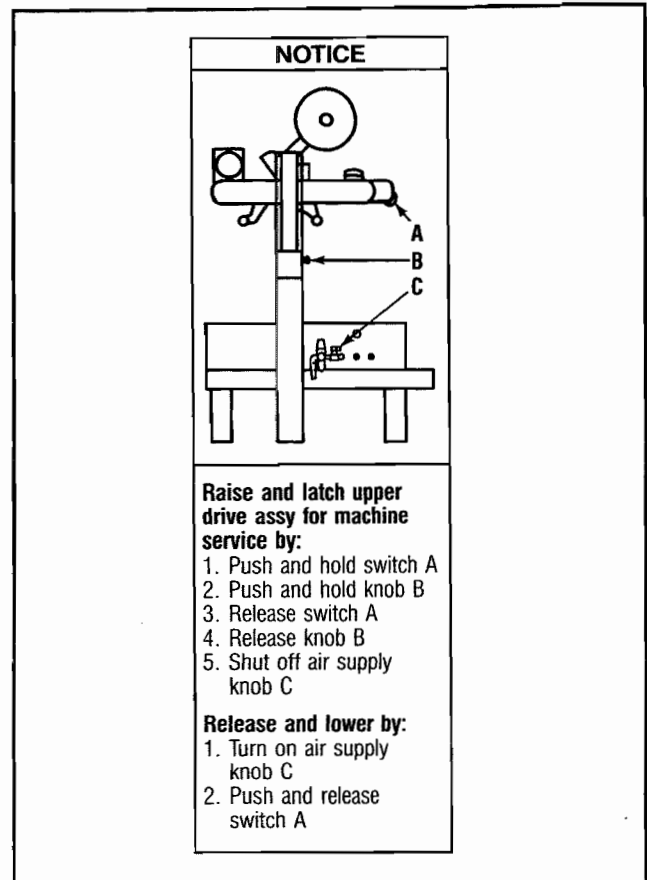


Figure 1-9 – Upper Drive Assembly Label

The "Centering Guide Force Adjust" label, shown in Figure 1-10, is attached to the left side of the machine frame over the centering guide control knob. The label provides increase/decrease force information to the operator.

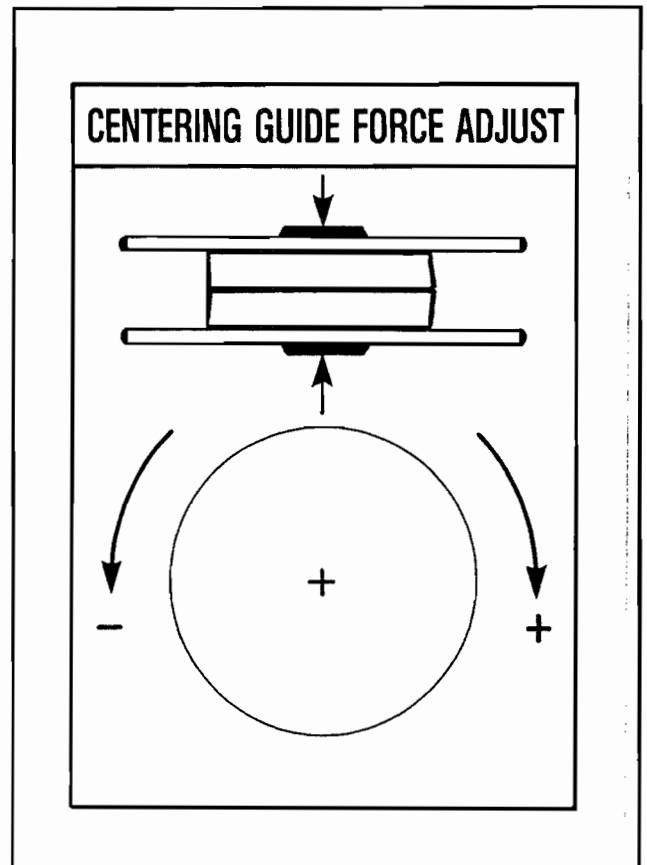


Figure 1-10 – Centering Guide Force Adjust Label

Important Safeguards (Continued)

The "Top Drive Assembly Force Adjust" label, shown in Figure 1-11, is attached to the left side of the machine frame over the top drive assembly control knob. The label provides increase/decrease force information to the operator.

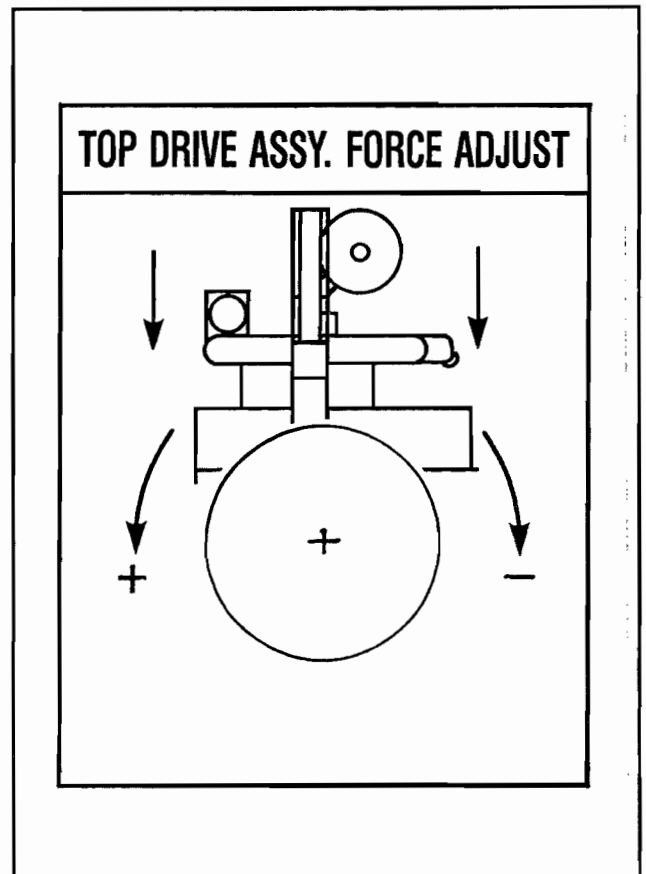


Figure 1-11 – Top Drive Assembly Force Adjust Label

The "Box Centering Switch" label, (A) shown in Figure 1-12, is attached to the center plate on the machine bed at the infeed end. The label identifies the box centering switch.

The "Drive Assembly Raising Switch", label (B) shown in Figure 1-12, is located above the switch which is at the front of the upper taping head frame. The label identifies the drive assembly raising switch.

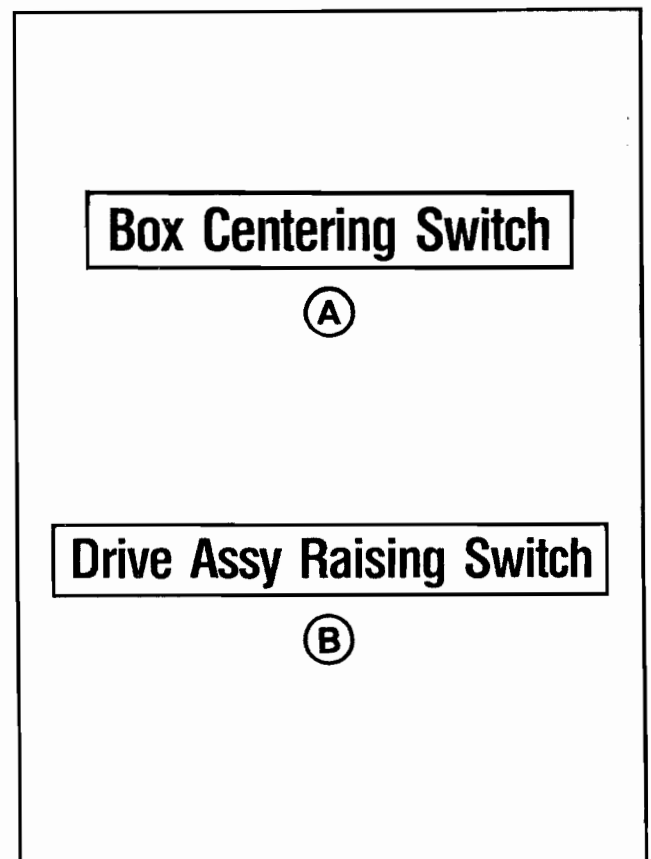


Figure 1-12 – Box Centering Switch/Drive Assembly Raising Switch

Important Safeguards (Continued)

The 700rks is equipped with a centrally located stop switch, shown in Figure 1-13. This push-button switch located on the upper taping head frame, is accessible from either side of the machine for operator convenience.

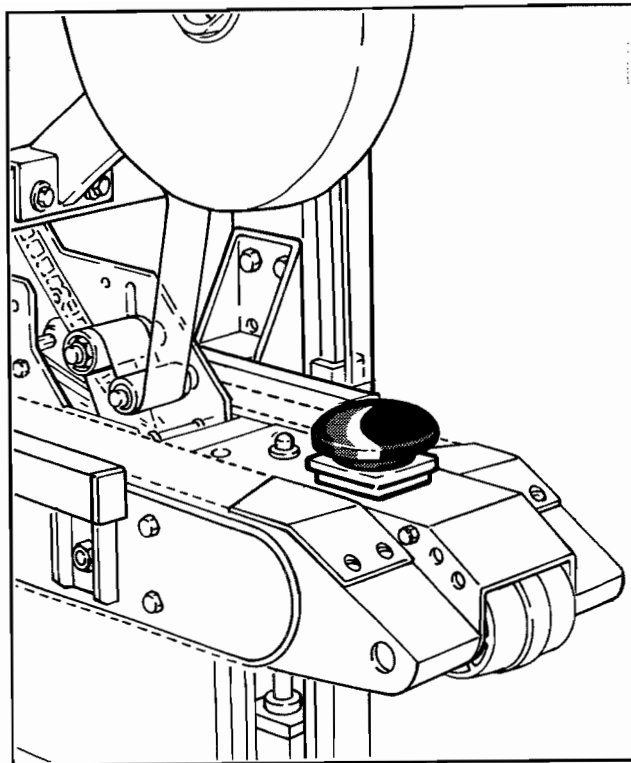


Figure 1-13 – Centrally Located Stop Switch

The "**Tape Threading Label**", shown in Figure 1-14, 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 the operation section of this manual.

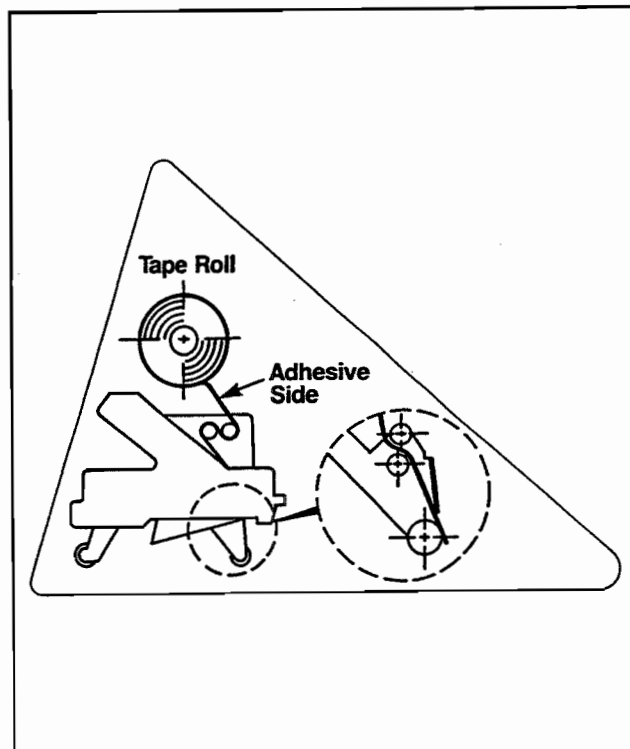


Figure 1-14 – Tape Threading Label

IMPORTANT – Read "Warnings" on page 21 before set-up, operation, maintenance or adjustments of case sealer.



THIS SAFETY ALERT SYMBOL IDENTIFIES IMPORTANT SAFETY MESSAGES IN THIS MANUAL. READ AND UNDERSTAND THEM BEFORE INSTALLING OR OPERATING THIS EQUIPMENT.

Specifications

1. Power Requirements:

Electrical – 115 VAC, 60 Hz, 6.4 A (675 watts)

Pneumatic – 85 PSIG [6 bar gauge pressure], 2.5 SCFM

[70 liter/minute @ 2PC, 1.01 bar] maximum at maximum random cycle rate.

A pressure regulator/filter is included.

The machine is equipped with two 1/4 HP gearmotors and comes 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:

Up to 15 boxes per minute. Actual production rate is dependent on box size, box size mix, and operator dexterity.

Box drive belt speed is 78 FPM [24 mpm]

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.

4. Tape:

Scotch™ brand pressure-sensitive film box sealing tapes.

5. Tape Width:

2 inches [50 mm] minimum to 3 inches [72 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 ± 6 mm]

Tape Application Leg Length – Optional:

2 inches $\pm 1/4$ inch [50 mm ± 6 mm] (See "Special Set-Up Procedure", page 38.)

8. Box Board:

Style – regular slotted containers – RSC

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

(Specifications continued on next page.)

Specifications (Continued)

9. Box Weight and Size Capacities:

A. Box Weight, filled – 5 lbs. [2.3 kg] minimum, 85 lbs. [38.6 kg] maximum – contents must support flaps.

B. Box Size:	Minimum	Maximum
Length –	6 inches [150 mm]	Unlimited
* Width –	7 inches [175 mm]	25-1/2 inches [645 mm]
** Height –	4-3/4 inches [120 mm]	25-1/2 inches [645 mm]

* Boxes narrower than 8 inches [200 mm] may require more frequent belt replacement because of limited contact area

** Minimum/maximum box height dimensions are with machine at factory setting. To accommodate smaller or larger boxes, machine upper taping head frame and/or outer column assemblies can be re-positioned as described in "Special Set-Up Procedure", pages 40 - 42 of this manual. Refer to chart below for box height range desired and then to illustration indicated for machine adjustments necessary.

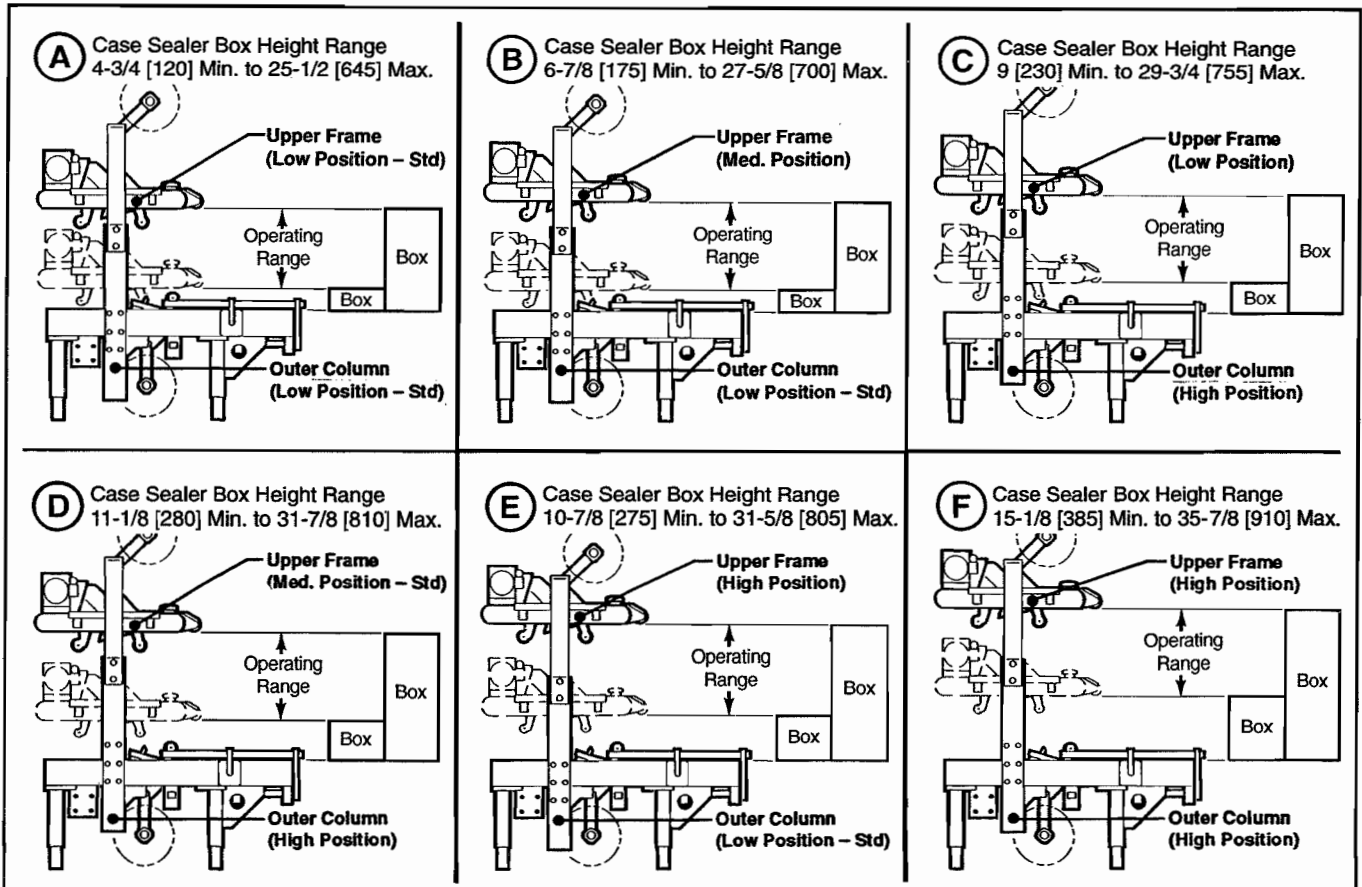
Minimum/Maximum Box Height Combinations

Minimum Inches [mm]	Maximum Inches [mm]	Refer To Illustration	Minimum Inches [mm]	Maximum Inches [mm]	Refer To Illustration
4-3/4 [120]	25-1/2 [645]	A	11-1/8 [280]	31-7/8 [810]	D
6-7/8 [175]	27-5/8 [700]	B	10-7/8 [275]	31-5/8 [805]	E
9 [230]	29-3/4 [755]	C	15-1/8 [385]	35-7/8 [910]	F

Note: Factory setting is position "A".

Specifications (Continued)

Minimum/Maximum Box Height Combinations



Note: Length of boxes in illustrations above are not to scale.

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

Note: The case sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is .5 or less, then several boxes should be test run to assure proper machine performance.

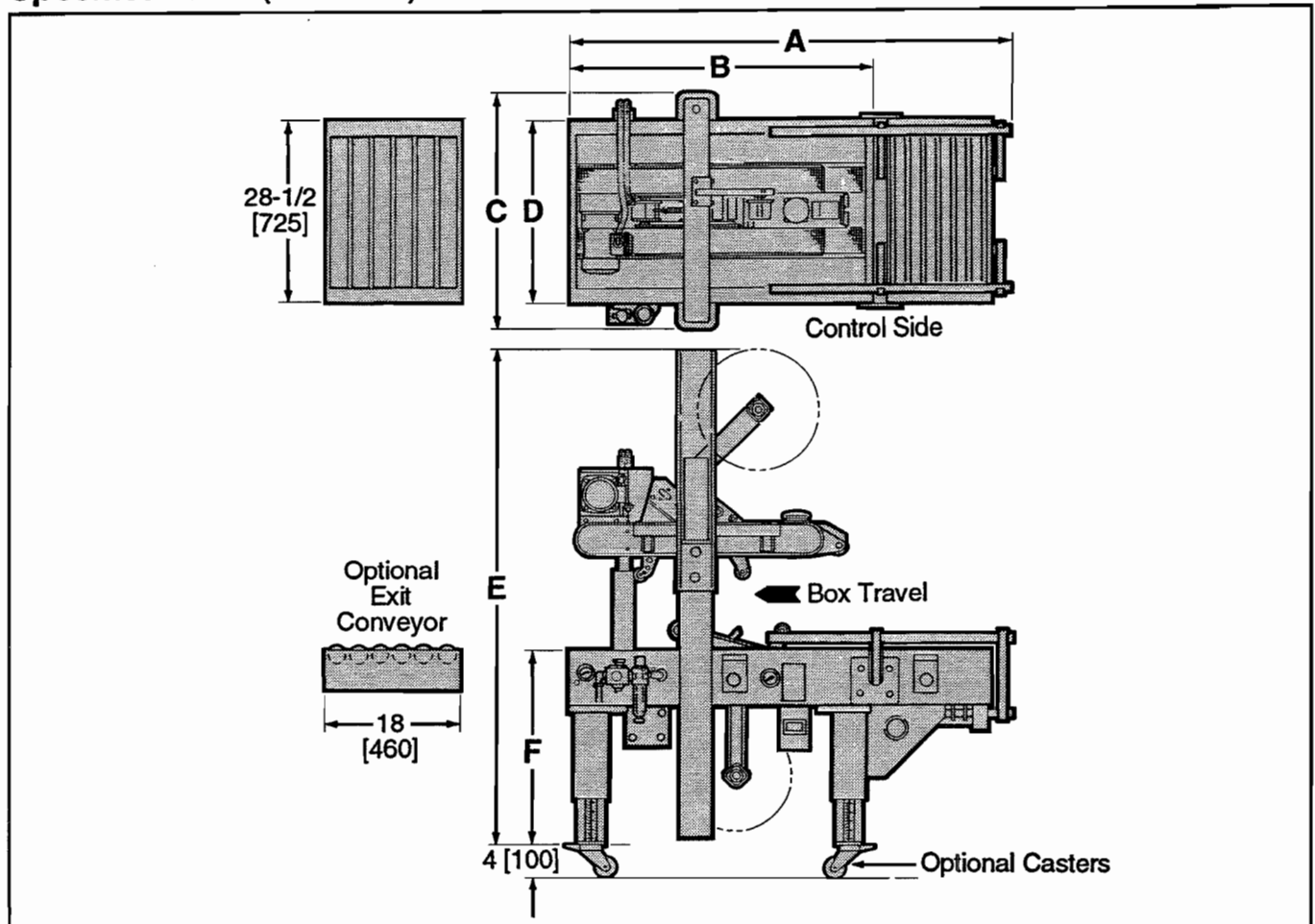
DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

BOX LENGTH IN DIRECTION OF SEAL SHOULD BE GREATER THAN .5
BOX HEIGHT

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

(Specifications continued on next page.)

Specifications (Continued)



10. Machine Dimensions:

	A	B	C	D	E	F
Minimum						
Inches	60-1/4	42-1/2	33-3/4	28-1/2	62-3/4	20-1/2
[mm]	[1530]	[1080]	[855]	[725]	[1595]	[520]
Maximum						
Inches	--	--	--	--	87-1/4	31
[mm]					[2215]	[785]

Note - Dimension "E" is with outer columns in standard (lower) position. If columns are moved to upper position, dimension "E" (min/max) increases by 4-1/4 inches [108 mm].

Weight - 500 pounds [225 kg] crated (approximate)
430 pounds [200 kg] uncrated (approximate)

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

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 notify your 3M Representative.**

Machine Set-Up

It is recommended that the 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 700rks before subjecting it and operating personnel to a production situation where time for set-up, adjustments, and operator training usually becomes limited.

The following instructions are presented in the order recommended for setting up and installing the case sealer. Following them step by step will result in an installation in your production line that best utilizes the many features built into the case sealer. Refer to Figure 3-1 and 3-2 to identify the various components of the machine.

IMPORTANT – Read "Warnings" on page 21 before attempting to set-up the case sealer for operation.

1. Follow "Unpacking Instructions" label attached to corrugated packing cover.
2. Remove the four angle brackets that secure the machine legs to the shipping pallet.
3. Remove tie down straps on either side of the upper taping head frame assembly.
4. Install upper tape drum bracket on the inner column assembly crossbar as shown in Figure 2-1.
5. The plastic column guards have been shipped loose with the machine. Remove the protective plastic film from the guards and install the guards on the outer columns as shown in Figure 2-1 using the screws, washers and bumper stops plates installed in the outer columns.

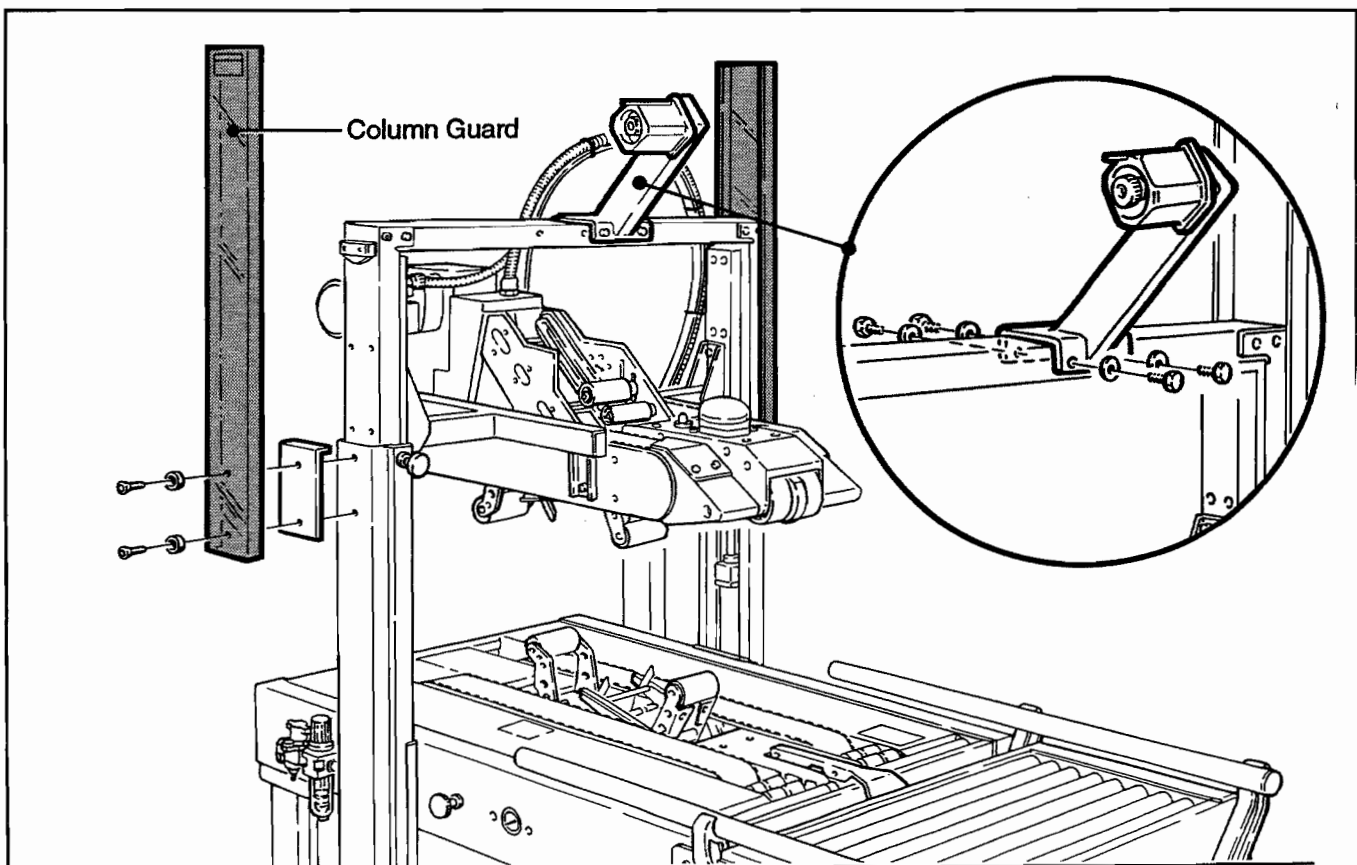


Figure 2-1 – 700rks Frame Set-Up

Set-Up Procedure (Continued)

6. Remove the plastic ties that secure the lower taping head in place.
7. Adjust case sealer bed height. The case sealer is equipped with four adjustable legs that are located at the corners of the machine frame. The legs can be adjusted to obtain different machine bed heights from 20-1/2 [520 mm] minimum to 31 inches [785 mm] maximum.

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

- a.. Block up the machine frame to allow adequate leg adjustment.
 - b. Loosen, but do not remove, two socket head screws in one leg (use M6 hex wrench). Adjust the leg length for the desired machine bed height. Retighten the two screws to secure the leg. Adjust all four legs equally.
8. Lower tape drum bracket. The tape drum bracket may be mounted in either of two positions on the taping head or an alternate outboard position. These positions allow maximum tape roll capacity at a particular machine bed height.

For machine bed heights 25 inches [635 mm] and above, bracket should be straight down as shown in Figure 2-2B.

For machine bed heights from 22-1/2 to 25 inches [570 to 635 mm] loosen hex spacer, remove screws (2) and pivot bracket forward as shown in Figure 2-2B. Replace and tighten screws and hex spacer.

For machine bed heights below 22-1/2 inches [570 mm], remove hex spacer and screws that secure the tape drum bracket to the taping head. Install tape drum bracket on the infeed end of the machine frame with the hex spacer and screws as shown in Figure 2-2C.

9. Tape width – the taping heads have been pre-set to accommodate 2 inch [50 mm] wide tape rolls. To apply 3 inch or 72 mm wide tape refer to "Adjustments – Tape Web Alignment", page 33 for set-up information.

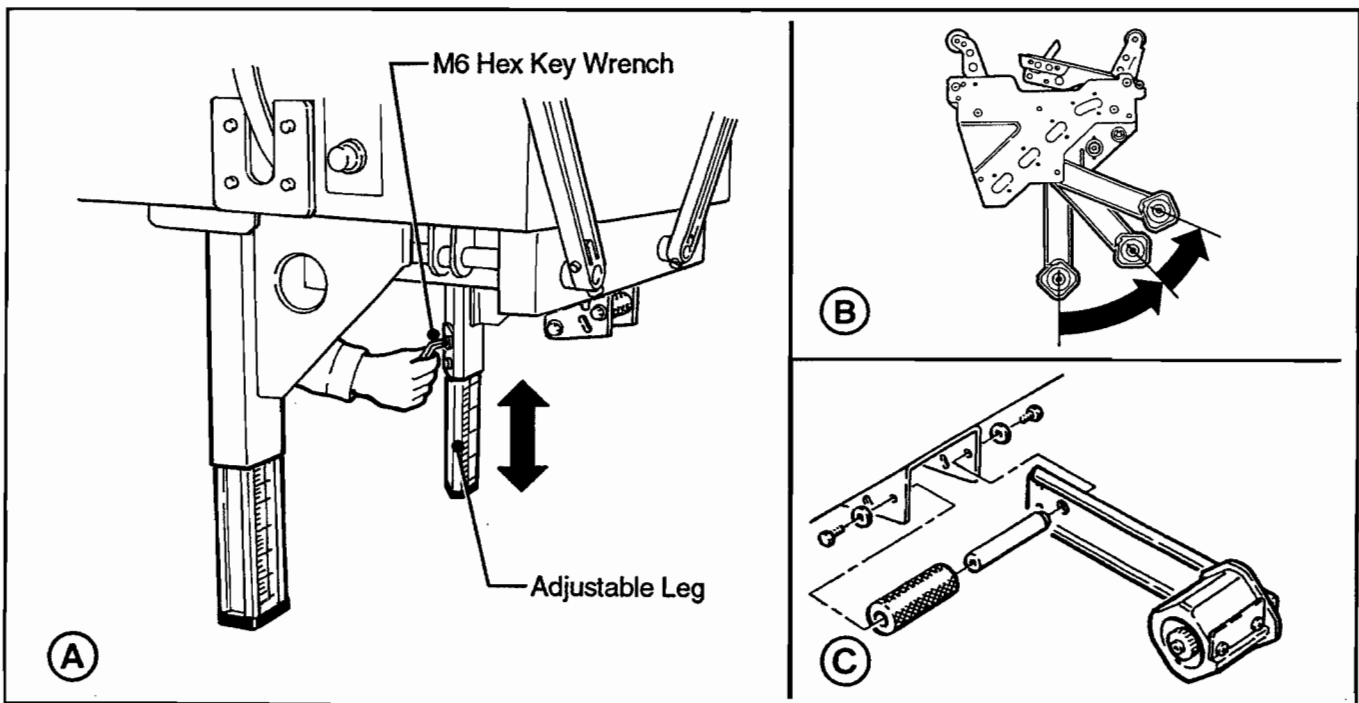


Figure 2-2 – Machine Bed Height Adjustment and Lower Tape Drum Bracket Position

Set-Up Procedure (Continued)

10. Box size capacity (height) – at its factory setting, the 700rks case sealer handles box sizes up to 25-1/2 inches [650 mm] maximum height. If larger capacity is needed, the machine can be adjusted to accommodate up to 36 inch [915 mm] high boxes. Refer to chart, "Minimum/Maximum Box Height Combinations Available", page 10 and "Special Set-Up Procedure", pages 40-42.
11. Upper taping head frame – operating range.
The operating speed of the 700rks case sealer can be increased by re-positioning the upper column stop bumpers within the range of boxes being sealed. This re-positioning reduces the downward movement of the upper frame thereby increasing operating speed.

To adjust the stop bumpers, see "Special Set-Up Procedure – Upper Taping Head Frame, Operating Range", page 37.

12. Pneumatic connection.

WARNING – USE CARE WHEN WORKING WITH COMPRESSED AIR.

The case sealer requires an 85 PSIG [6,5 bar gauge pressure] 2.5 SCFM [75 liter/min @21°C, 1,01 bar] compressed air supply.

Using customer supplied air hose (5/16 inch [8 mm] I.D.) and clamp provided with machine, connect plant air to barbed fitting on inlet side of "On/Off" valve. See Figure 2-3. **Note: If another type of connector is desired, the barbed fitting can be replaced with the desired 1/4-18 NPT connector.**

Note – The air valve has provisions for lockout/tagout according to plant regulations.

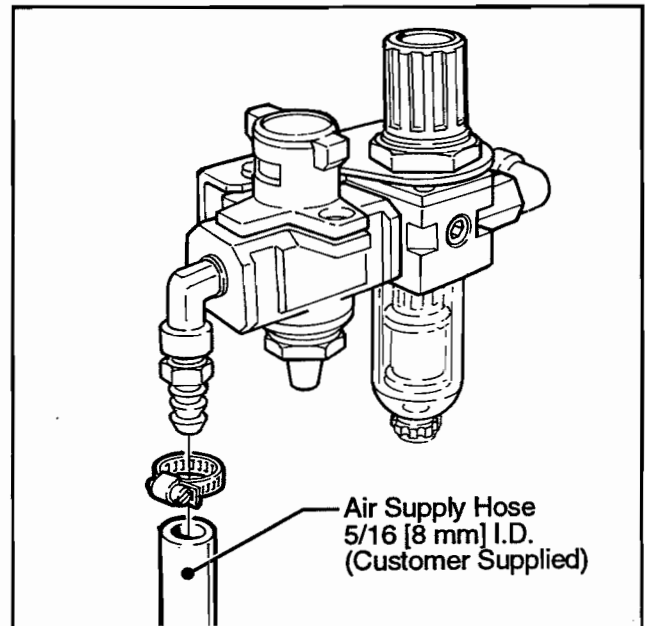


Figure 2-3 – Pneumatic Connection

13. Electrical connection and controls.
The electrical control box, shown in Figure 3-1 contains the "On/Off" switch with pre-set breaker and can be located on either side of the machine frame for customer operating convenience. A standard three conductor power cord with plug is provided at the back of the electrical control box for 115 Volt, 60 Hz, 6.4 Amp 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 red "Off" button is depressed and that all packaging materials and tools are removed from the machine. **Do not plug electrical cord into outlet until ready to run 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.

Initial Start-Up of Case Sealer

After completing the "Set-Up" procedure, continue through "Operation", pages 17-26 to be sure case sealer is properly adjusted to run product.

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Operation

IMPORTANT - Before operating the case sealer, read all the "Important Safeguards", pages 2-8 and "Warnings" on page 21 as well as all of the "Operation" instructions.

Refer to Figure 3-1 and 3-2 to acquaint yourself with the various components and controls of the 700rks case sealer. Also see Figures 3-7 and 3-8 for taping head components.

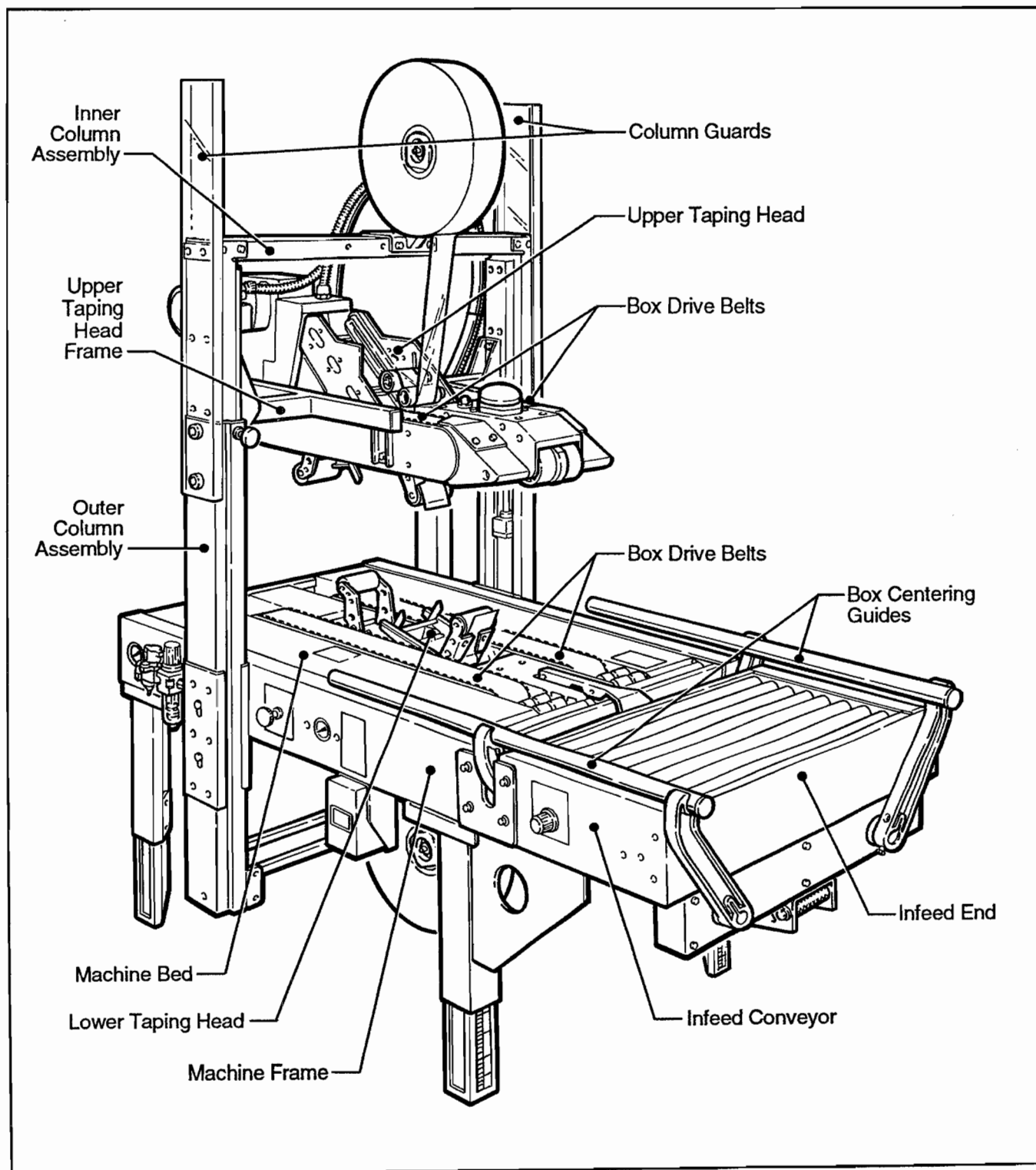


Figure 3-1 – Case Sealer Components

Operation (Continued)

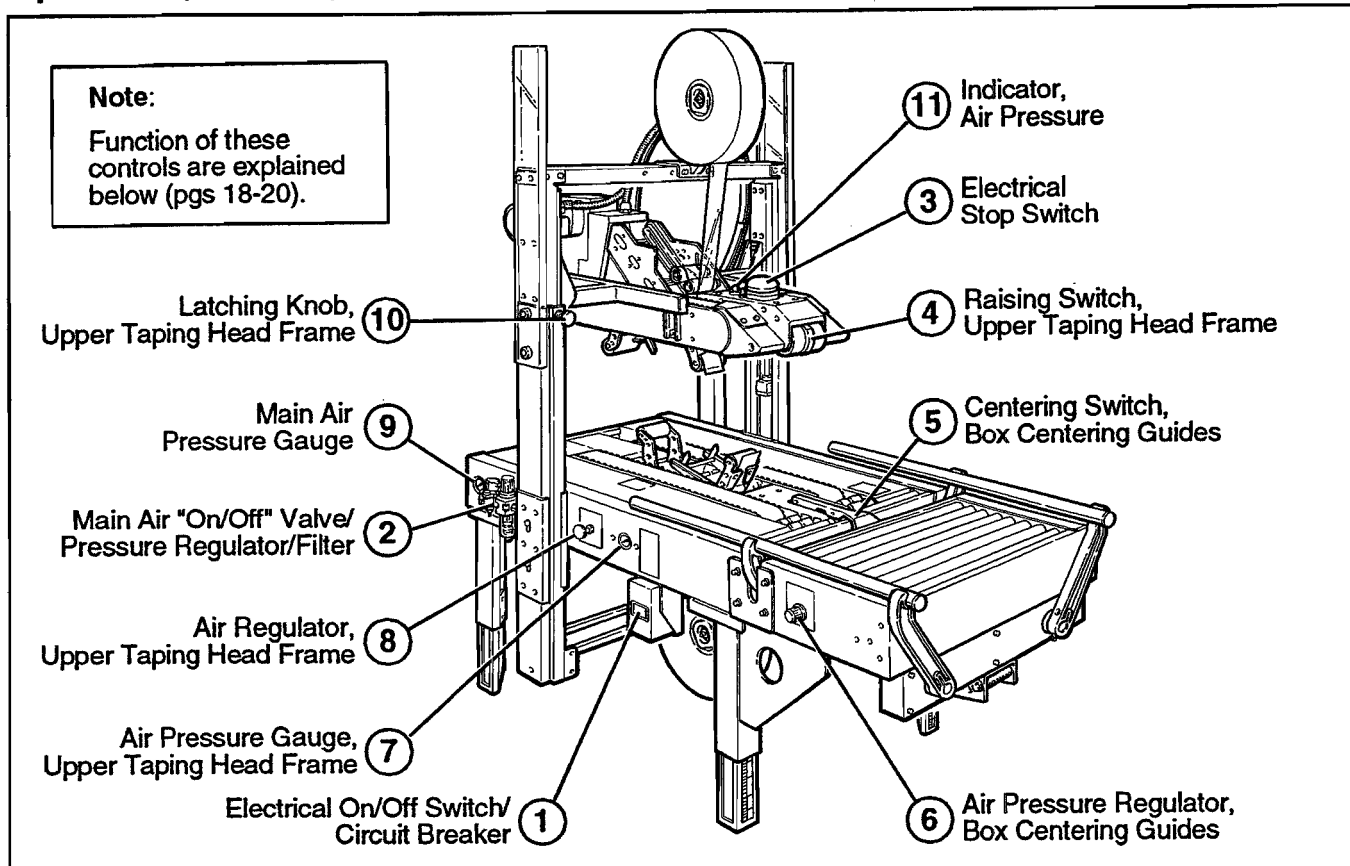


Figure 3-2 – Controls, Valves and Switches

- ① **Electrical "On/Off" Switch/Circuit Breaker**
The box drive belts are turned on and off (off button is red) with the electrical switch on the side of the machine frame.

Note – A circuit breaker is incorporated into the "On/Off" switch. If circuit becomes overloaded and circuit breaker trips, determine cause of overload (wait two minutes), then push "On" button to reset breaker/start machine.

- ② **Main Air "On/Off" Valve/Pressure Regulator/Filter – Figure 3-3**
This set of pneumatic components controls, regulates and filters plant air supply to the two separate control circuits of the case sealer.

"On/Off" Valve – "On" turn to "SUP" – "Off" turn to "EXH". **Note –** Turning air supply "Off" automatically bleeds air pressure from the case sealer air circuits.

Always turn the air "Off" when machine is not in use, when servicing the machine, or when connecting or disconnecting air supply line.

Note – The air valve has provisions for lockout/tagout according to plant regulations.

Pressure Regulator regulates main air pressure to the machine. To adjust pressure, pull knob up and turn – push down to lock setting.

Filter removes dirt and moisture from plant air before it enters the case sealer pneumatic circuits. If water collects in bottom of bowl, lift up on the valve on the bottom of bowl to drain.

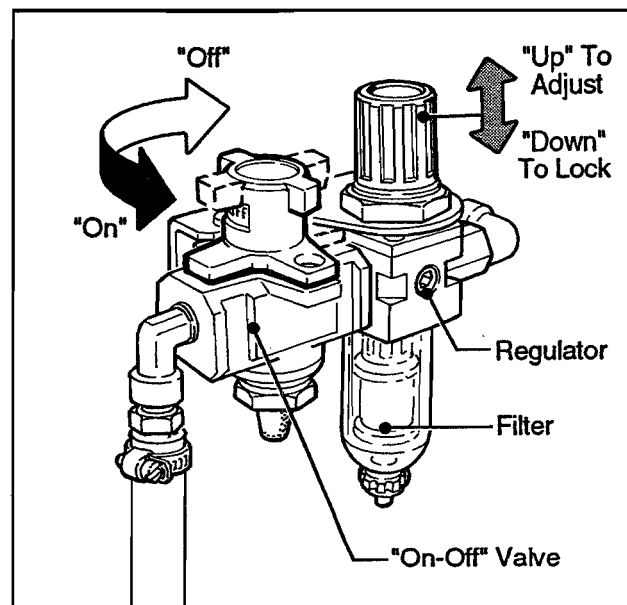


Figure 3-3 – "On/Off" Valve/Regulator/Filter

Operation (Continued)

③ Electrical "Stop" Switch

This centrally located "Stop" switch stops the drive motors/belts. It is accessible from either side of the machine for operator convenience.

④ Raising Switch, Upper Taping Head Frame

This switch, when touched by the leading edge of a box, pneumatically raises the upper frame to allow insertion of the box under the drive belts. As the box moves under the switch, releasing it, the upper frame descends on the box and the drive belts convey the box through the machine. When switch is actuated by hand, the upper frame rises to its maximum height. Released, the upper frame descends to its rest position.

⑤ Centering Switch, Box Centering Guide

This pneumatic switch controls the box centering guides. When switch is activated by a box entering the case sealer, the centering guides close (centering the box), and released (after box passes over switch), the guides open.

⑥ Air Pressure Regulator, Box Centering Guides Figure 3-4

This regulator is used to adjust centering guides according to weight of boxes. Pressure should be adequate to center boxes, but low enough to allow easy pushing of boxes under taping head. The regulator setting can be locked by tightening the phillips screw as shown.

⑦ Air Pressure Gauge, Upper Taping Head Frame

This gauge, used in conjunction with the upper frame air regulator, provides operator with a reference pressure setting for various size/weight boxes.

⑧ Air Pressure Regulator, Upper Taping Head Frame Figure 3-5

Set nominally to control "down" movement of upper frame (drive belts) and the pressure exerted against the box. The regulator setting is changed as necessary for the boxes being sealed to provide adequate drive belt pressure against the box to positively convey the boxes through the machine. If the boxes stop or hesitate while being conveyed, decrease the regulator pressure which will increase the drive belt force on the box for more friction between the box and drive belts. Adjust setting as necessary to get continuous movement of boxes through machine.

For boxes which are fully packed with products that support the top flaps, the adjustment of this regulator is not critical since the boxes can support the pressure of the upper frame (drive belts) at a wide range of regulator settings. However, if under-filled or fragile boxes are sealed, this regulator can be used to set the upper frame pressure to a minimum that is still adequate to positively convey the box and to prevent damage of boxes. The regulator setting can be locked by securing the lock nut on the regulator shaft as shown in Figure 3-5.

Note – A precision regulator is used to balance the upper taping head frame. Due to the self relieving feature of this regulator a small amount of air will continually vent to the atmosphere. This is normal and amounts to approximately 0.1 SCFM [3 liter/min].

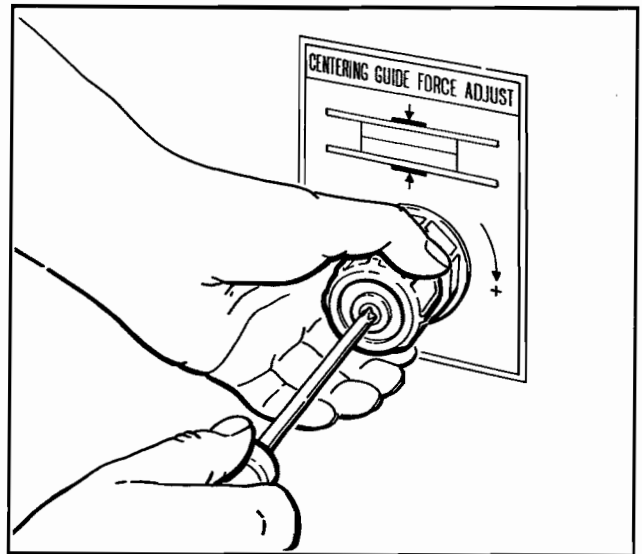


Figure 3-4— Air Regulator, Centering Guides

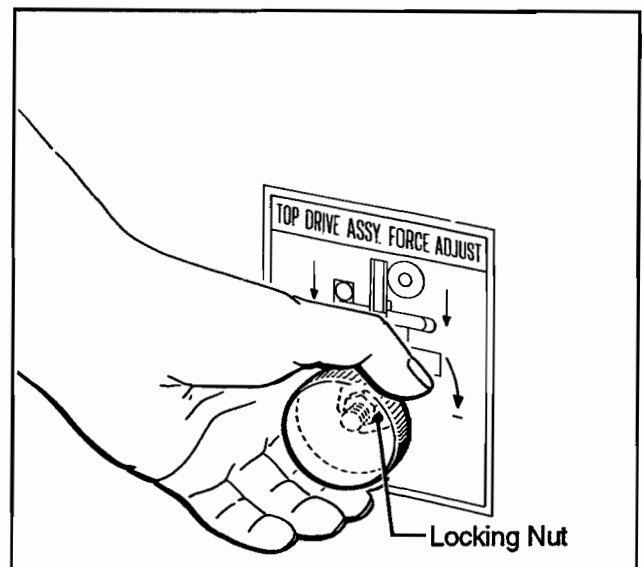


Figure 3-5 – Air Regulator, Upper Taping Head Frame

Operation (Continued)

- ⑨ **Main Air Pressure Gauge**
Indicates main air regulator pressure setting. Air regulator should be adjusted so gauge reads 85 PSIG [6,5 bar gauge pressure].

- ⑩ **Latching Knob, Upper Taping Head Frame**
The mechanical latch is provided to hold the upper frame at the fully raised position for tape threading and maintenance.

To raise and latch the upper frame:

1. Push and hold the upper frame raising switch "A".
2. Push and hold latching knob "B".
3. Release switch "A".
4. Release knob "B".
5. Shut off air supply.

To release and lower the upper frame:

1. Turn on air supply.
2. Push and release switch "A".

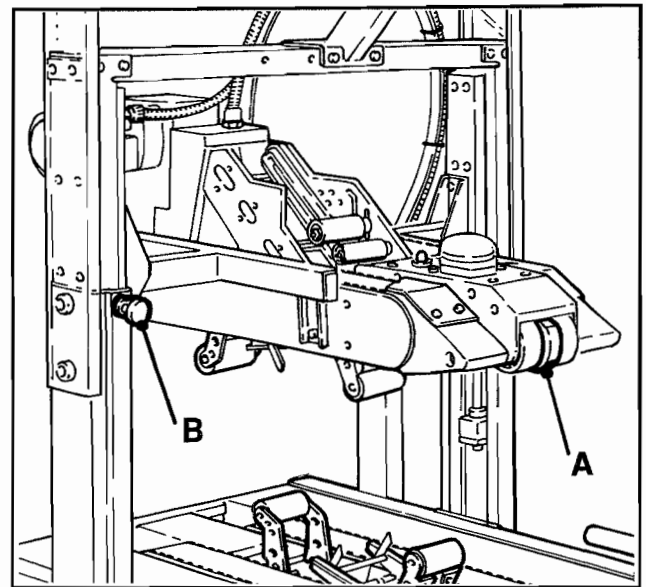


Figure 3-6 – Latching Knob, Upper Taping Head Frame



WARNING – DO NOT PUT HANDS BENEATH UPPER TAPING HEAD FRAME WHEN UPPER FRAME LOWERS TO ITS REST POSITION. SEVERE PERSONAL INJURY COULD RESULT.

- ⑪ **Indicator, Air Pressure**
An "Optical Warning Indicator" for the compressed air circuit of the machine is located on the upper taping head frame just behind the red "Stop" button. When indicator is "Red", air circuit is on.

Operation (Continued)



WARNINGS

1. Turn electrical and air supply off and disconnect before servicing taping heads or performing any adjustments or maintenance on the machine.
2. Turn electrical and air supply off when machine is not in use.
3. Before turning drive belts on, be sure no tools or other objects are on the conveyor bed.
4. Keep hands and loose clothing away from moving belts.
5. Never attempt to remove jammed boxes from the machine while machine is running.
6. Be aware of the pneumatically controlled movement of the upper frame and box centering guides. Keep away from these components when air and electrical supplies are on.
7. When feeding boxes to the machine by hand, push box in from end only – DO NOT PUSH WITH HANDS ON ANY CORNER OF THE BOX.
8. Both the upper and lower taping heads utilize extremely sharp knife blades. The blades are located under the orange blade guard which has the "WARNING – SHARP KNIFE" label. Before loading tape, refer to Figures 3-7 and 3-8 to identify the blade location. Keep hands out of these areas except as necessary to service the taping heads.
9. Failure to comply with these warnings can result in severe personal injury and/or equipment damage.

Taping Heads

A threading diagram is attached to each taping head for operator reference. However, it is recommended that the more detailed instructions and sketches in this manual be referred to the first few times the unit is loaded until the operator becomes thoroughly familiar with the tape loading operation.

A plastic threading needle is provided with each taping head – retain the needle for continued use in the tape loading procedure.

Refer to Figures 3-7 and 3-8 to identify the various components of the taping heads, especially the cut-off blade location.

Operation (Continued)

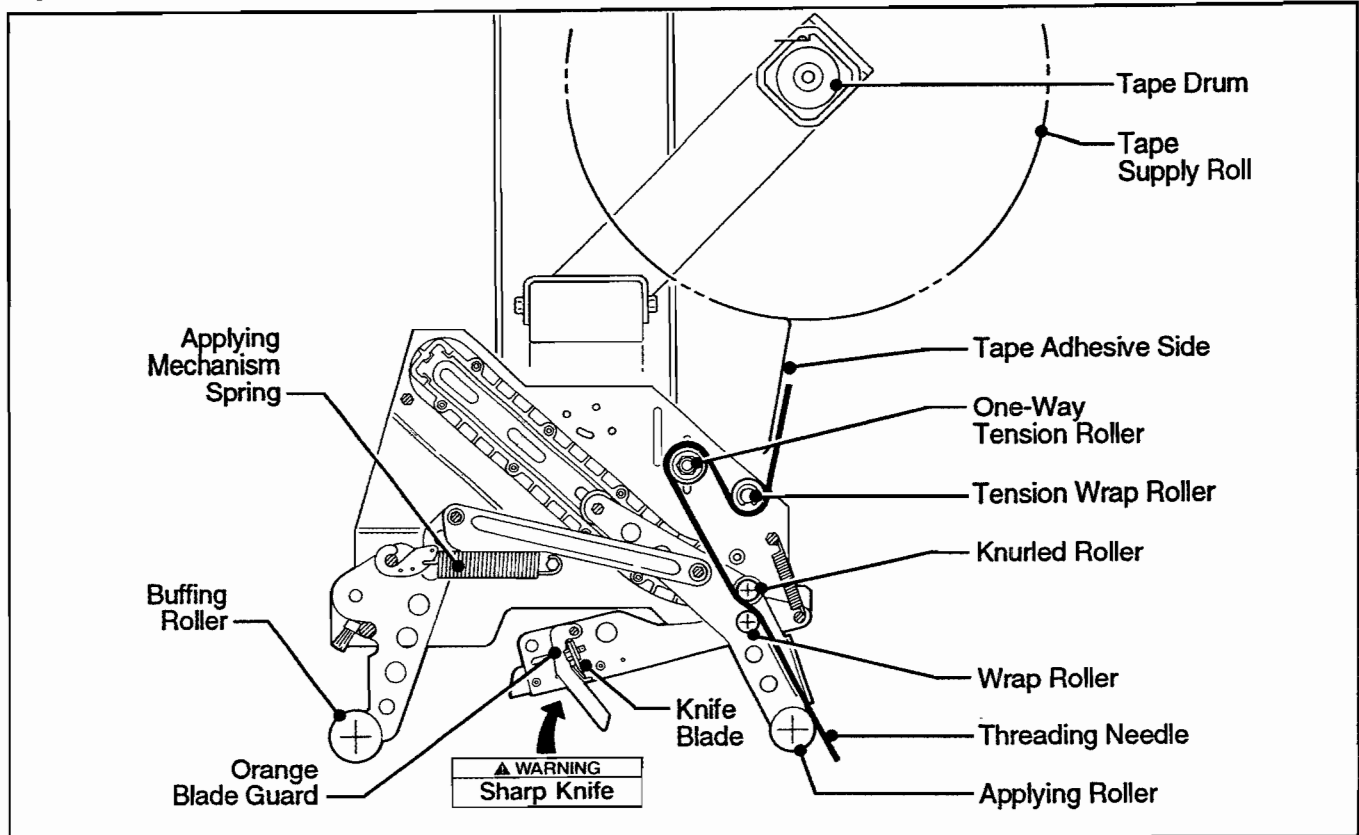


Figure 3-7 – Taping Head Components/Threading Diagram, Upper Head

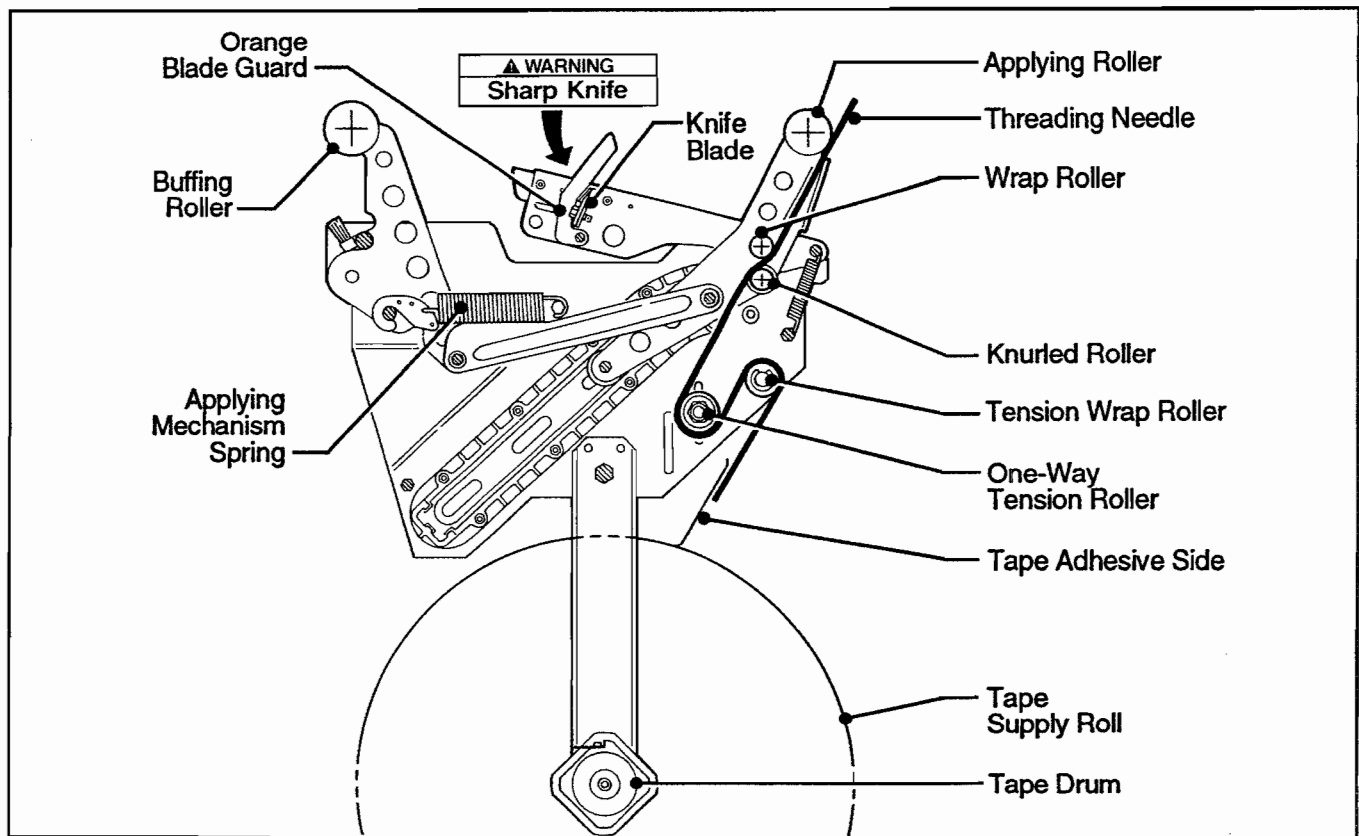


Figure 3-8 – Taping Head Components/Threading Diagram, Lower Head

Operation (Continued)

Tape Loading/Threading



WARNING - TURN OFF AND DISCONNECT ELECTRICAL AND AIR SUPPLIES BEFORE LOADING/THREADING TAPE. IF ELECTRICAL AND AIR SUPPLIES ARE NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.

Tape Loading/Threading – Upper Taping Head

1. Raise and latch upper taping head frame in fully raised position.
2. Follow **Steps 1, 2 and 3** on page 24, and also refer to Figure 3-7.

Tape Loading/Threading – Lower Taping Head With Tape Drum On Taping Head

1. Raise and latch upper taping head frame in fully raised position.
2. Remove lower taping head from the machine bed by lifting the head straight up.
3. The lower taping head is loaded and threaded in the same manner as the upper taping head. Follow **Steps 1, 2 and 3** on page 24 and also refer to Figure 3-8.
4. Replace the lower taping head into machine bed.

Tape Loading/Threading – Lower Taping Head With Alternate Outboard Tape Drum

1. Raise and latch upper taping head frame in fully raised position.
2. Remove lower taping head from conveyor bed and install threading needle as in **Step 1**, page 24. Replace taping head back into conveyor bed.
3. Place tape roll on outboard tape drum with adhesive up on lead end of tape. Seat tape roll fully against back flange of tape drum. Thread tape through outboard tape rollers as shown in Figure 3-9 and adhere tape lead end to lower end of threading needle.
4. Complete tape threading as explained in **Step 3**, page 24.

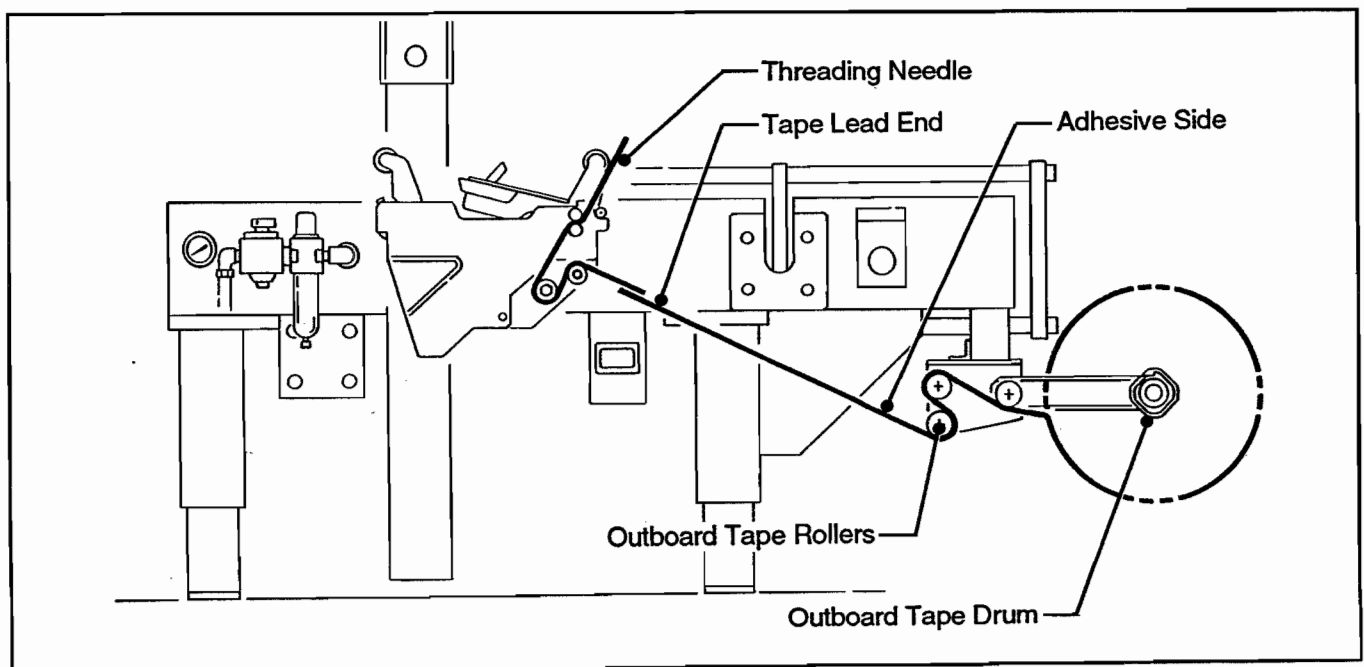


Figure 3-9 – Tape Threading With Alternate Outboard Tape Drum

Operation (Continued)

Step 1 – Figure 3-10

Insert the threading needle **downward** (upper head) or **upward** (lower head) around rollers as illustrated.

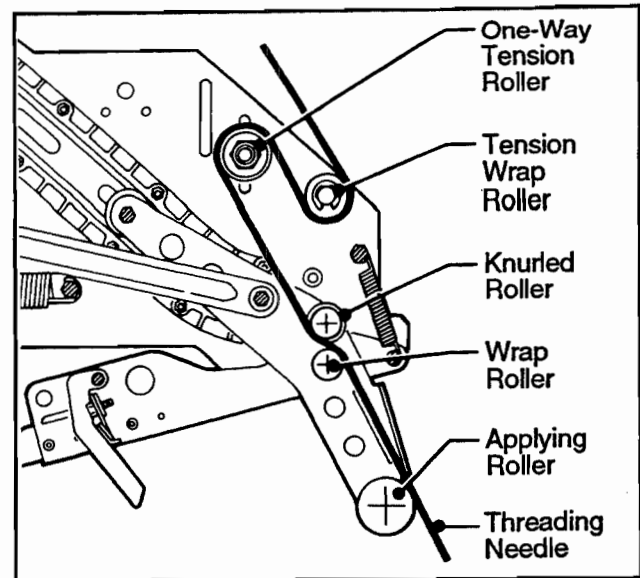


Figure 3-10 – Tape Loading

Step 2 – Figure 3-11

Place tape roll on drum to dispense tape from bottom of roll (upper head) or top of roll (lower head), **adhesive side forward**. Seat tape roll fully against back flange of drum. Adhere tape lead end to end of threading needle as shown.

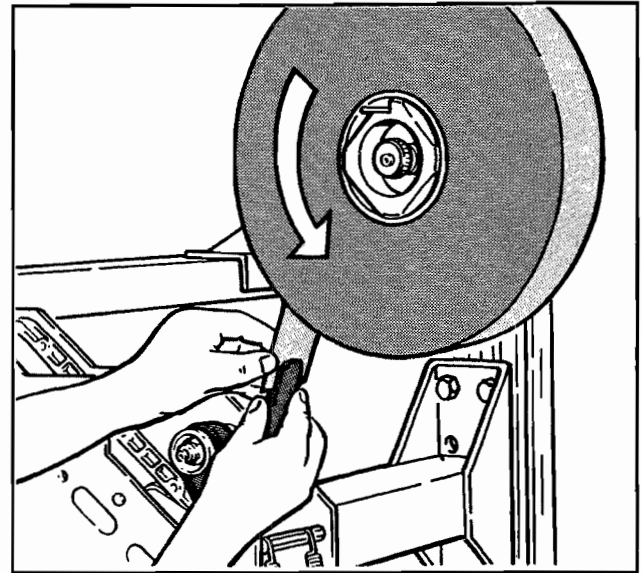


Figure 3-11 – Tape Loading

Step 3 – Figure 3-12

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

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

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

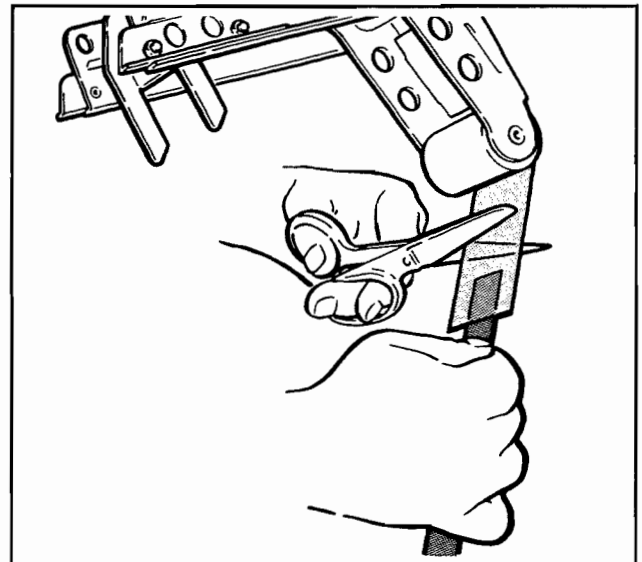


Figure 3-12 – Tape Loading

Operation (Continued)

Box Sealing

WARNINGS

1. Remove tools or other objects from machine bed before starting machine.
2. Keep hands and loose clothing away from moving belts.
3. When feeding boxes to the machine by hand, push box in from end only – **DO NOT PUSH WITH HANDS ON ANY CORNER OF THE BOX.**
4. Be aware of the pneumatically controlled movement of the upper frame and box centering guides. Keep away from these components when air and electrical supplies are on.
5. Never attempt to remove jammed boxes from the machine while machine is running.
6. Turn electrical and air supplies "Off" when machine is not in use.

Important – If operator is not familiar with operation of this machine, it is recommended that the box centering and upper frame switches be manually actuated to understand their function. Connect and turn air supply "On". Depressing the box centering switch causes the box centering guides to close, releasing the switch causes the centering guide to open. Depressing the upper frame raising switch causes the upper frame to rise, releasing the switch causes the upper frame to descend.

1. Connect air and electrical supply.
2. Turn main air valve "On" (SUP) to energize pneumatic circuit.
3. Turn electrical switch "On" to start drive belts.
4. Feed boxes to machine:

Figure 3-13 Operator pushes a box onto the infeed conveyor where box depresses box centering switch. This causes the pneumatically powered centering guides to move inward, centering the box. **Note – centering force is adjusted with "Centering Guide Force Adjust" air regulator.**

Figure 3-14 Once the box is centered by the centering guides, operator continues to push box against the upper taping head frame raising switch. This switch pneumatically raises the upper frame above the box height so operator can further push the box under the upper drive belts.

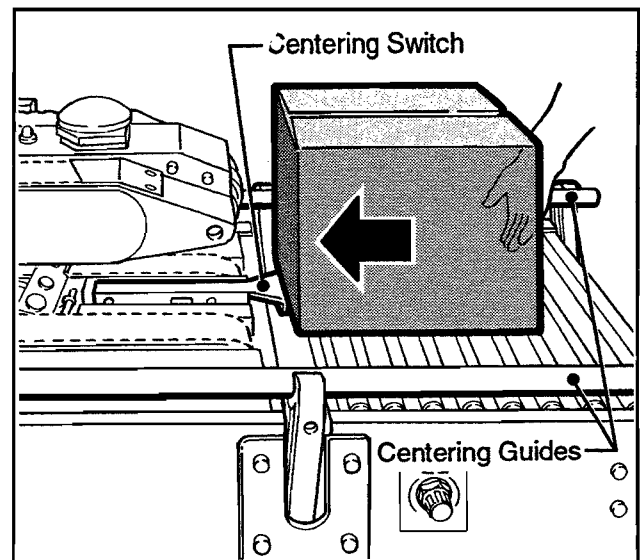


Figure 3-13 – Box Centering Guides

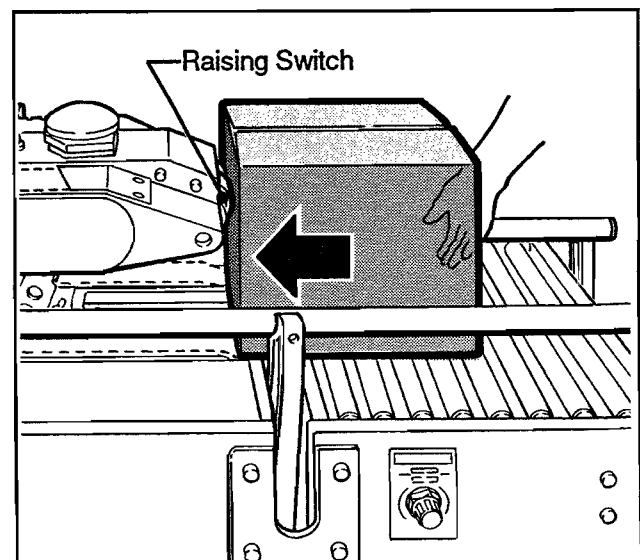


Figure 3-14 – Upper Frame Raising Switch

Operation (Continued)

Figure 3-15 Once the box is pushed under the upper frame, the upper frame raising switch is released, allowing the upper frame (drive belts/ tapping head) to descend on the box. The drive belts convey the box through the upper and lower tapping heads for application of the tape seals.

Note – downforce of the upper frame is adjusted with "Top Drive Assembly Force Adjust" air regulator.

As the box is conveyed through the machine, the centering switch is released, causing the centering guides to return to their full open position.

Once the box is conveyed from under the upper frame, the upper frame descends to its rest position, ready for insertion of the next box.

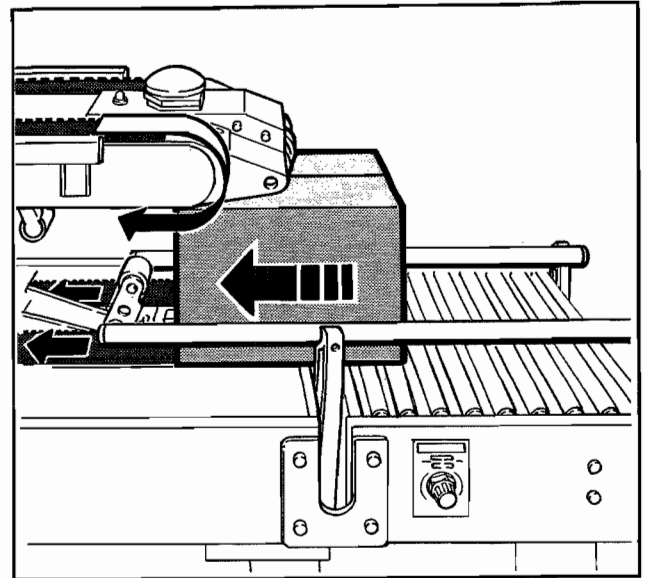


Figure 3-15 – Applying Tape Seals

5. Turn electrical and air supplies "Off" when machine is not in use.
6. Reload and thread tape as necessary.
7. Be sure machine is cleaned and lubricated according to recommendations in "Maintenance" section of this manual.

Note – Box drive motors are designed to run at a moderate temperature of 104°F [40°C]. In some cases, they may feel hot to the touch.

Note – Adjustment of the machine or tapping heads are described in the "Adjustment" section of this manual.

Maintenance

The case sealer 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 AIR AND ELECTRICAL SUPPLIES OFF AND DISCONNECT BEFORE BEGINNING MAINTENANCE. FAILURE TO COMPLY WITH THIS WARNING COULD RESULT IN SEVERE PERSONAL INJURY OR EQUIPMENT DAMAGE.

Blade Replacement (Upper and Lower Taping Heads)

Figure 4-1

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

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.

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

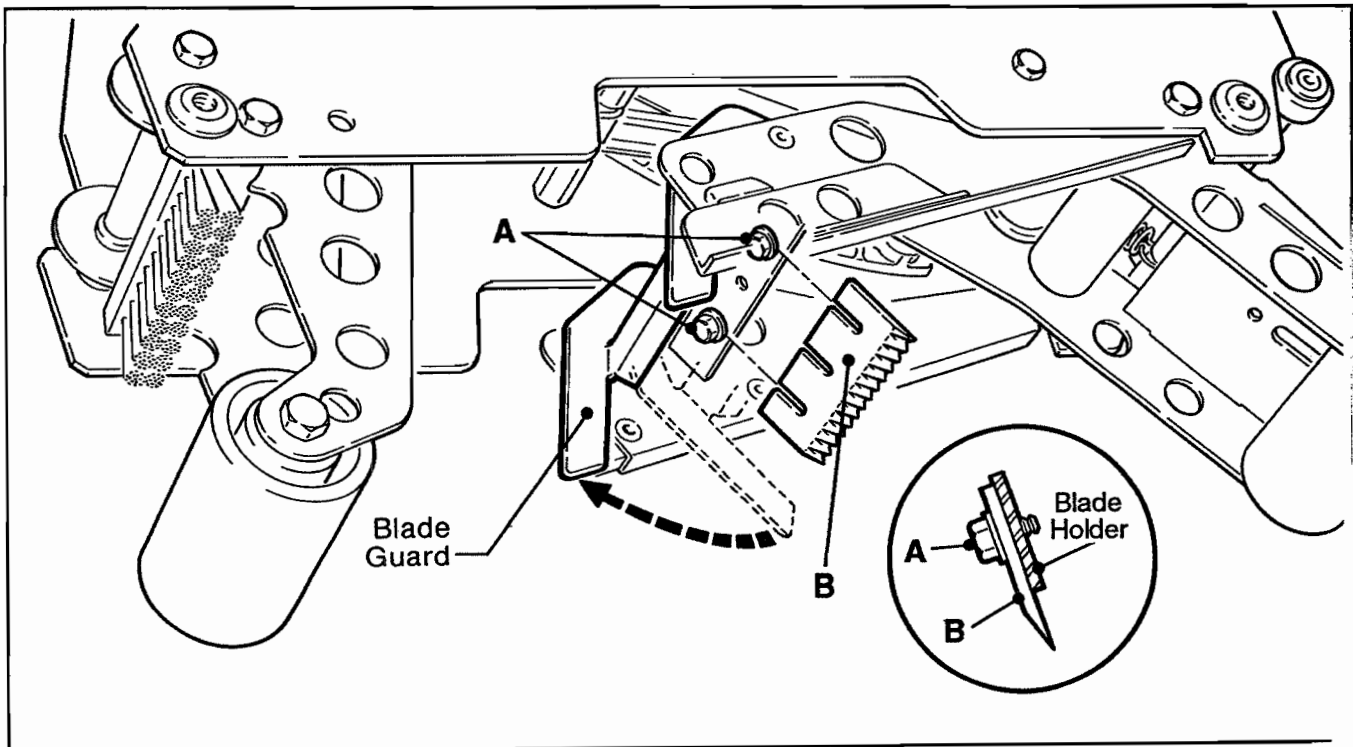


Figure 4-1 – Blade Replacement

Maintenance (Continued)



WARNING - TURN AIR AND ELECTRICAL SUPPLIES OFF AND DISCONNECT BEFORE BEGINNING MAINTENANCE. FAILURE TO COMPLY WITH THIS WARNING COULD RESULT IN SEVERE PERSONAL INJURY OR EQUIPMENT DAMAGE.

Drive Belt Replacement/Tension Adjustment

Note – 3M recommends the replacement of drive belts in pairs, especially if belts are unevenly worn.

Upper Drive Belts

REPLACEMENT – STEPS 1-8

TENSION ADJUSTMENT – STEPS 1-3 & 6-8

Figure 4-2

1. Remove (4) M5 flat head screws (A) with 3 mm hex key wrench that secure upper frame center cover (B), turn cover sideways and move to back of opening.
2. Loosen hex head M8 tension screw (C) with 13 mm wrench.
3. Hold or block upper drive belt back and loosen M10 lock nut (D) with 17 mm wrench.
4. Pull belt splicing pin (E) out and remove old belt.
5. Thread new belt **up** around front pulley (between pulley and belt guard) and around rear drive pulley with laced splice at top. Insert splicing pin.
Note: Pin must not extend beyond edge of belt.

Figure 4-3

6. Adjust belt tension. Turn hex head M8 tension screw (C) out to tighten belt. Use a force gauge to pull the belt out 1 inch [25 mm] at midspan with a pulling force of 7 lbs [3,5 kg].

Figure 4-2

7. Tighten M10 lock nut (D) to secure tension setting.
8. Replace upper frame cover with (4) M5 flat head screws.

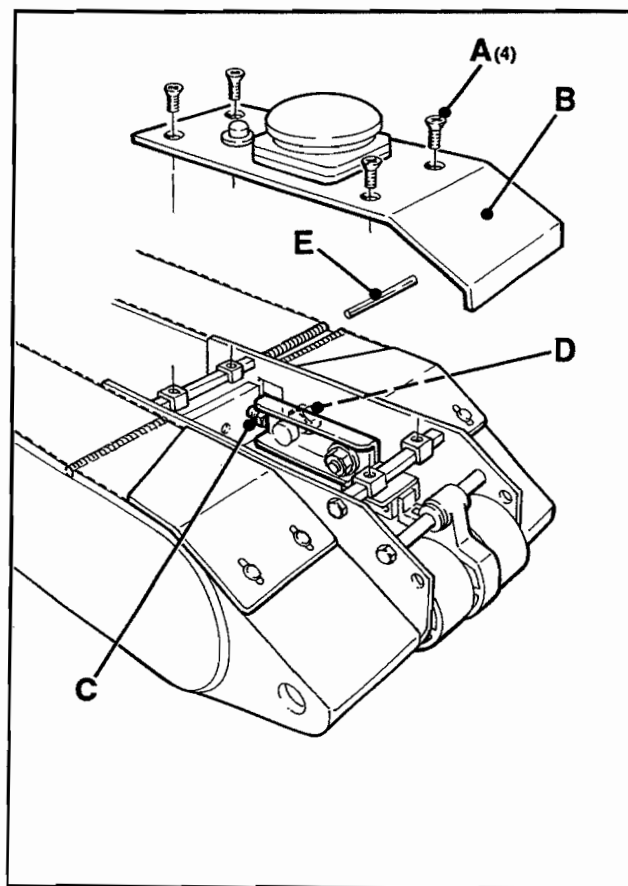


Figure 4-2 – Upper Drive Belt Replacement

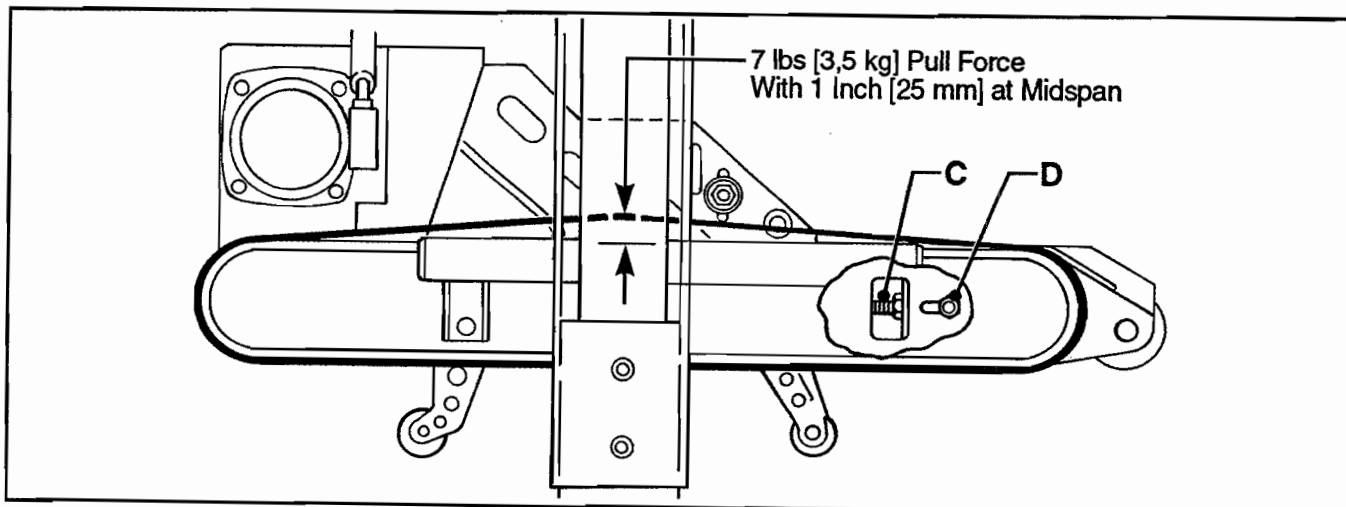


Figure 4-3 – Belt Tension Adjustment, Upper Belt(s)

Maintenance (Continued)



WARNING - TURN AIR AND ELECTRICAL SUPPLIES OFF AND DISCONNECT BEFORE BEGINNING MAINTENANCE. FAILURE TO COMPLY WITH THIS WARNING COULD RESULT IN SEVERE PERSONAL INJURY OR EQUIPMENT DAMAGE.

Lower Drive Belt(s)

REPLACEMENT – STEPS 1-9

TENSION ADJUSTMENT – STEPS 1-4 & 7-9

Figure 4-4

1. Remove (4) M5 flat head screws (A) (3 mm hex key wrench) that secure center plate (B) and remove center plate.
2. Remove (4) M6 socket head screws (C) (5 mm hex key wrench) from side plate (D) and remove side plate.
3. Loosen hex head M8 tension screw (E).
4. Loosen, but do not remove, M20 lock nut (F) on side of belt pulley frame with 19 mm wrench.
5. Pull belt splicing pin out and remove old belt.
6. Place new belt over pulleys with laced splice at top. Insert splicing pin. **Note: Pin must not extend beyond edge of belt.**

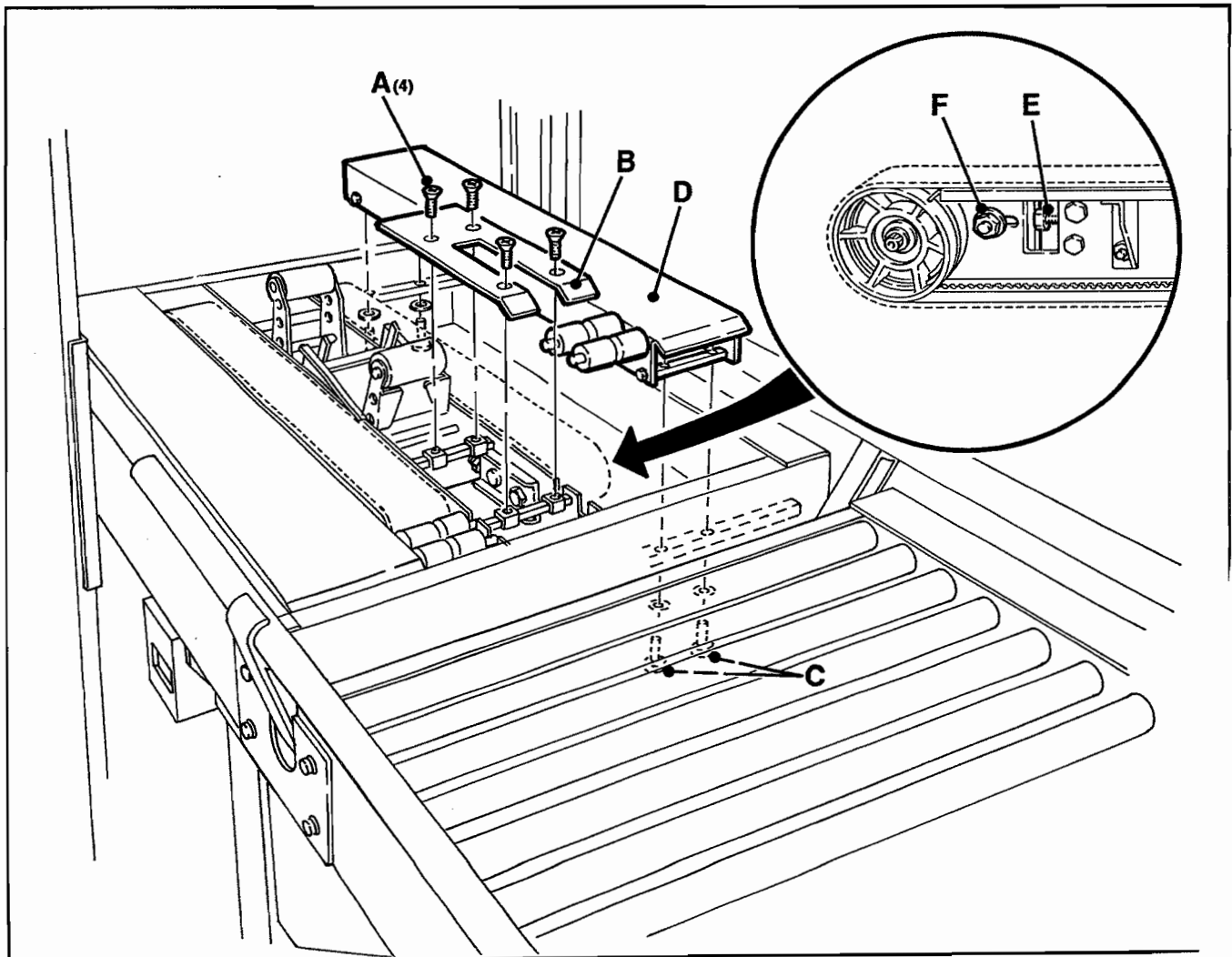


Figure 4-4 – Lower Drive Belt Replacement

Maintenance (Continued)



WARNING - TURN AIR AND ELECTRICAL SUPPLIES OFF AND DISCONNECT BEFORE BEGINNING MAINTENANCE. FAILURE TO COMPLY WITH THIS WARNING COULD RESULT IN SEVERE PERSONAL INJURY OR EQUIPMENT DAMAGE.

Figure 4-5

7. Adjust drive belt tension. Turn M8 tension screw (E) out to increase belt tension. Use a force gauge to pull the belt outward 1 inch [25 mm] at midspan with a pulling force of 7 lbs [3,5 kg].

Tighten M20 lock nut (F) to secure tension setting.

Figure 4-4

8. Install side plate with (4) M6 socket head screws.
9. Replace center plate with (4) M5 flat head screws.

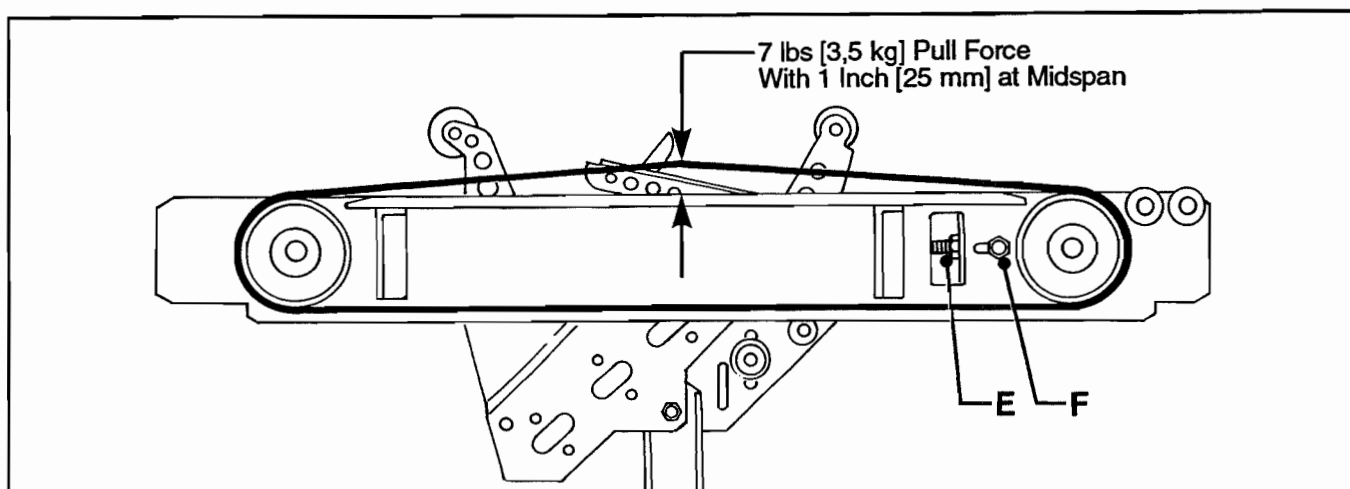


Figure 4-5 – Belt Tension Adjustment, Lower Belt(s)

Cleaning Of The Machine

Note - Never attempt to remove dirt by blowing it out with compressed air. This can cause the dirt to be blown inside the motor and onto sliding surfaces which may cause premature equipment wear. 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



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

Should tape adhesive build-up occur on cut-off blade carefully wipe blade clean with oily cloth.

Maintenance (Continued)



WARNING - TURN AIR AND ELECTRICAL SUPPLIES OFF AND DISCONNECT BEFORE BEGINNING MAINTENANCE. FAILURE TO COMPLY WITH THIS WARNING COULD RESULT IN SEVERE PERSONAL INJURY OR EQUIPMENT DAMAGE.

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, determine cause and correct (wait two minutes), then turn "On". Located inside the electrical control box on the side of the machine frame, the circuit breaker has been pre-set at 3.2 Amps and requires no further maintenance.

Air Line Filter

Periodically check the air filter and clean as necessary. Also, drain water from bowl by pushing drain valve up on bottom of bowl. **Do not allow water to accumulate above filter element.**

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 4-6 and 4-7 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 arrows (⇨).

Note - Wipe off excess oil and grease. It will attract dust and dirt which can cause premature equipment wear and jamming. Take care that oil and grease are not left on the surface of rollers around which tape is threaded, as it can contaminate the tape's adhesive.

Blade Oiler Pad

The taping heads are equipped with a 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.**

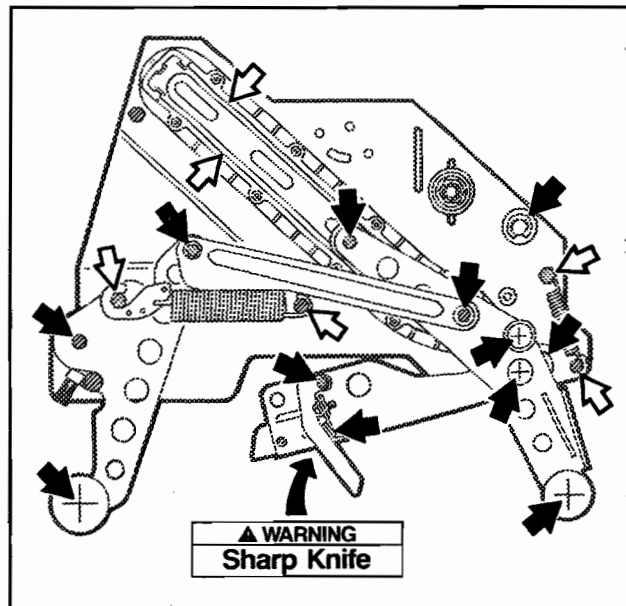


Figure 4-6 – Lubrication Points, Upper and Lower Taping Heads

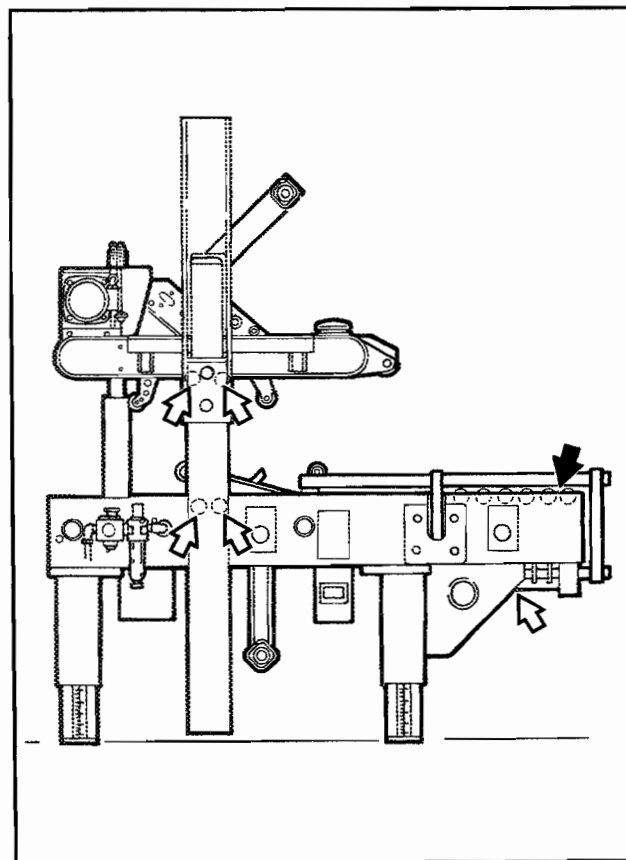


Figure 4-7 – Lubrication Points, Frame

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Adjustments

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

Tape Web Alignment

Figure 5-1

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 wider 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 locking hex nut behind tape drum on tape drum shaft. Use an adjustable wrench or 25 mm open end wrench.

Note – To set up tape drum for 3 inch tape, disassemble tape drum from bracket and install lock nut on outside of bracket as shown in inset, Figure 5-2.

2. Turn tape drum shaft in or out to center the tape web with 5 mm hex wrench.
3. Tighten locking hex nut to secure the adjustment.

No other components require adjustment for tape web alignment.

Tape Drum Friction Brake

Figure 5-2

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.

Note – Excessive braking force will cause poor tape application and lead to tape tabbing on the trailing tape leg.

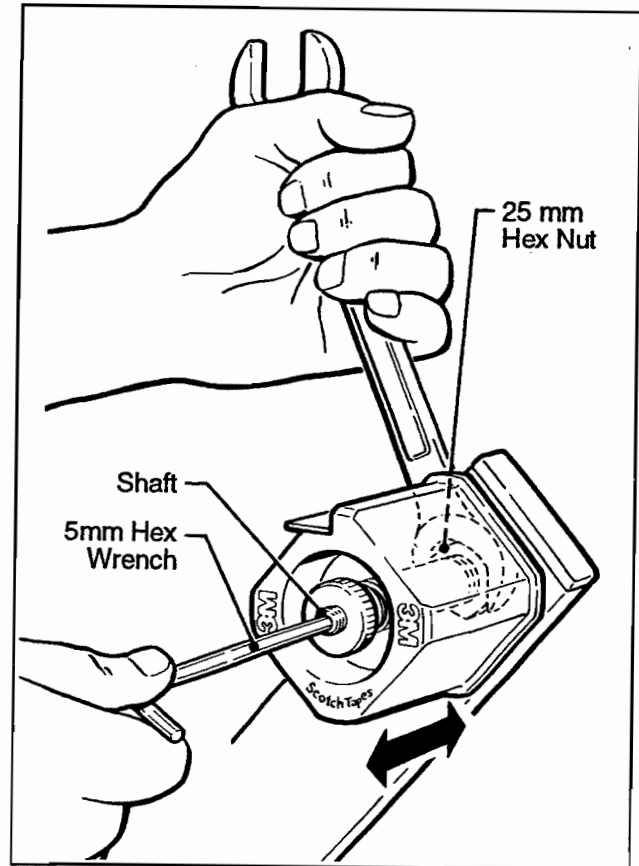


Figure 5-1 – Tape Web Alignment

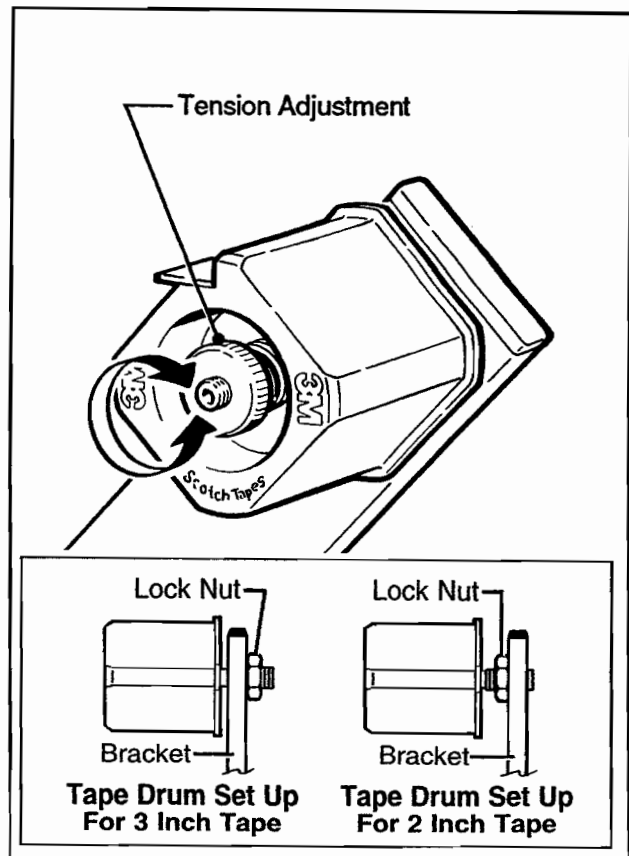


Figure 5-2 – Tape Drum Friction Brake

Adjustments (Continued)

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

Applying Mechanism Spring

Figure 5-3

The applying mechanism spring, shown in Figures 3-7 and 3-8, controls applying and buffing roller pressure on the box and returns the mechanism to the reset position. The spring pressure setting, as shown in Figure 5-3A, 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 5-3B, will adjust the spring pressure.

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

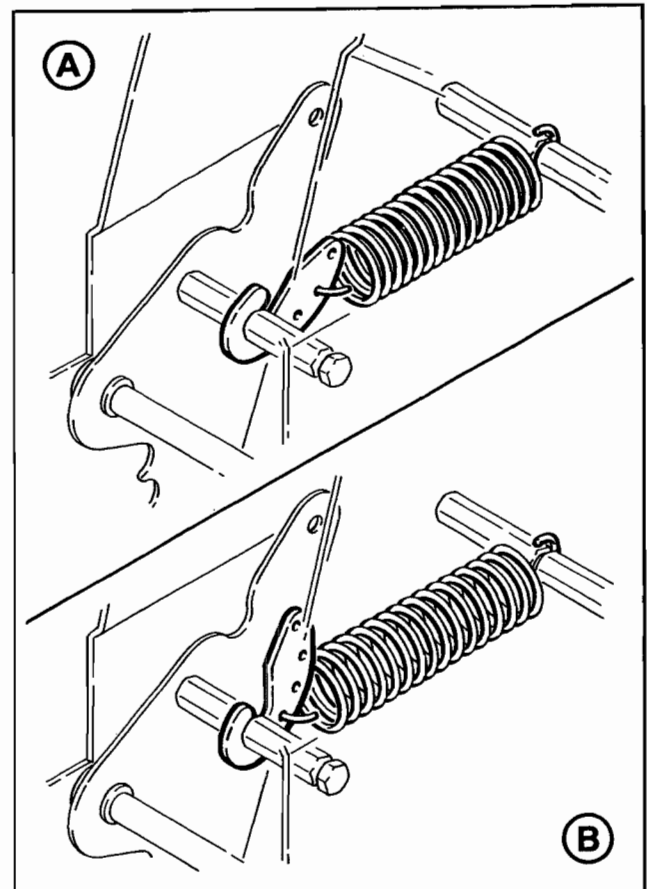


Figure 5-3 – Applying Mechanism Spring

One Way Tension Roller

Figure 5-4

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.

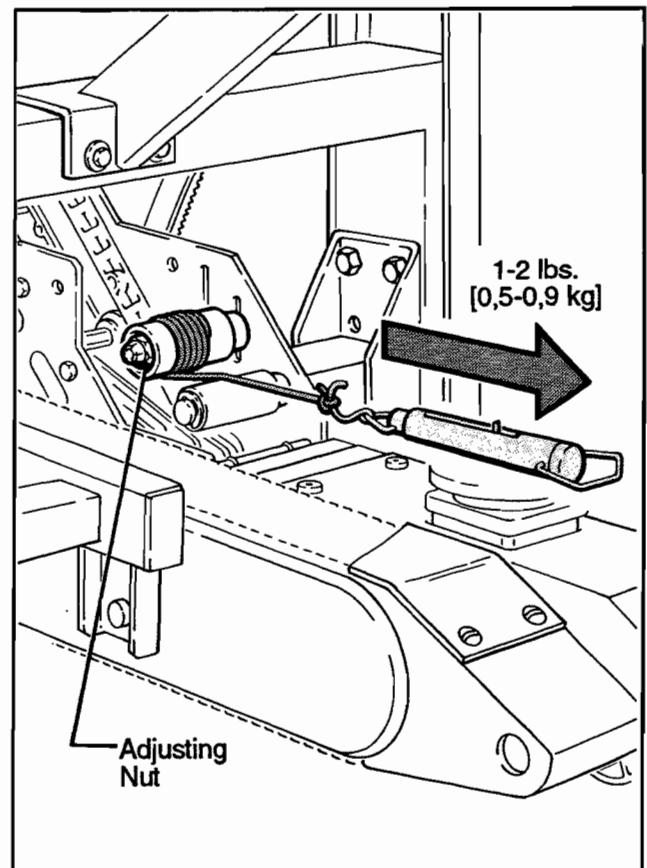


Figure 5-4 – One-Way Tension Roller

Adjustments (Continued)



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

Tape Application Leg Length

Figure 5-5

For best tape application performance, the taping heads should maintain tape leg lengths of 2-3/4 inch \pm 1/4 inch [70 mm \pm 6 mm].

The one-way tension roller position on the taping heads (Figure 3-7 and 3-8) is adjustable to control the leading tape leg length.

Moving this roller farther away from the box top or bottom surface will decrease the leading leg length. Moving it closer to the box top or bottom surface will increase the leading leg length.

Drive Belt Tension

To adjust drive belt tension, refer to "Maintenance – Drive Belt Replacement", page 28 (upper belts) or page 29 (lower belts).

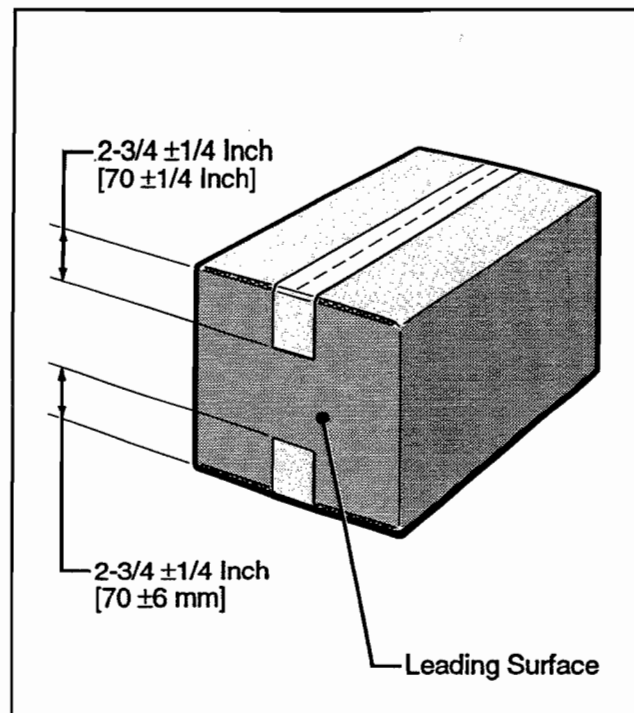


Figure 5-5 – Tape Application Leg Length

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Special Set-Up Procedure



WARNING – TURN OFF ELECTRICAL POWER AND AIR SUPPLY AND DISCONNECT POWER CORD FROM ELECTRICAL SUPPLY BEFORE BEGINNING SPECIAL SET-UP PROCEDURE. IF POWER CORD IS NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.

Upper Taping Head Frame – Operating Range Figure 6-1

The operating range of the upper taping head frame can be adjusted to minimize its movement to the range of box heights being sealed. Therefore, the operating speed can be increased. The range is established by limiting the lowest (rest) position of the upper frame through positioning the column stop bumpers at different levels on the inner column assembly. After establishing the minimum box height to be sealed, position the stop bumpers as follows:

1. Feed the **minimum** height box into the case sealer and shut off the electrical power so the box is stopped under the upper taping head frame. Figure 6-1A.
2. Remove and retain the screws, washers, plastic guards and bumper stop plate on both outer columns. Figure 6-1B.
3. Remove and relocate the stop bumper assembly to the next available mounting position on both sides of the inner column assembly. Figure 6-1C. Be sure that the stop bumpers are reassembled as shown and secure.
4. Install the two stop bumper plates and column guards as shown and secure with the washers and screws.
5. Turn on the electrical power to complete conveying of the box through the case sealer. The upper taping head frame will then descend to the lowest position necessary to accommodate your range of box sizes.

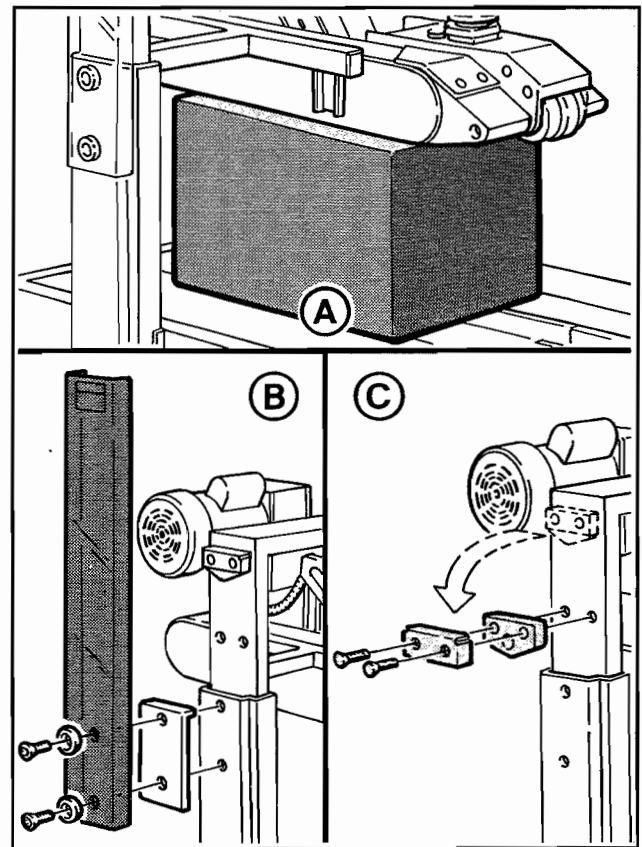


Figure 6-1 – Upper Frame Stop Bumpers

Special Set-Up Procedure (Continued)

⚠ WARNING - TURN OFF ELECTRICAL POWER AND AIR SUPPLY AND DISCONNECT POWER CORD FROM ELECTRICAL SUPPLY BEFORE BEGINNING SPECIAL SET-UP PROCEDURE. IF POWER CORD IS NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.

Tape Application Leg Length – Optional

(Changing tape leg length from 2-3/4 to 2 inches [70 to 50 mm])

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

1. Remove taping heads from machine.

⚠ WARNING – SUPPORT OR HOLD UPPER TAPING HEAD WHEN REMOVING TO PREVENT TAPING HEAD FROM FALLING.

Upper Taping Head – remove and retain four mounting screws as shown in Figure 6-2 and remove taping head.

Lower Taping Head – raise and latch upper taping head frame in its full "Up" position. Lift lower taping head straight up to remove from machine.

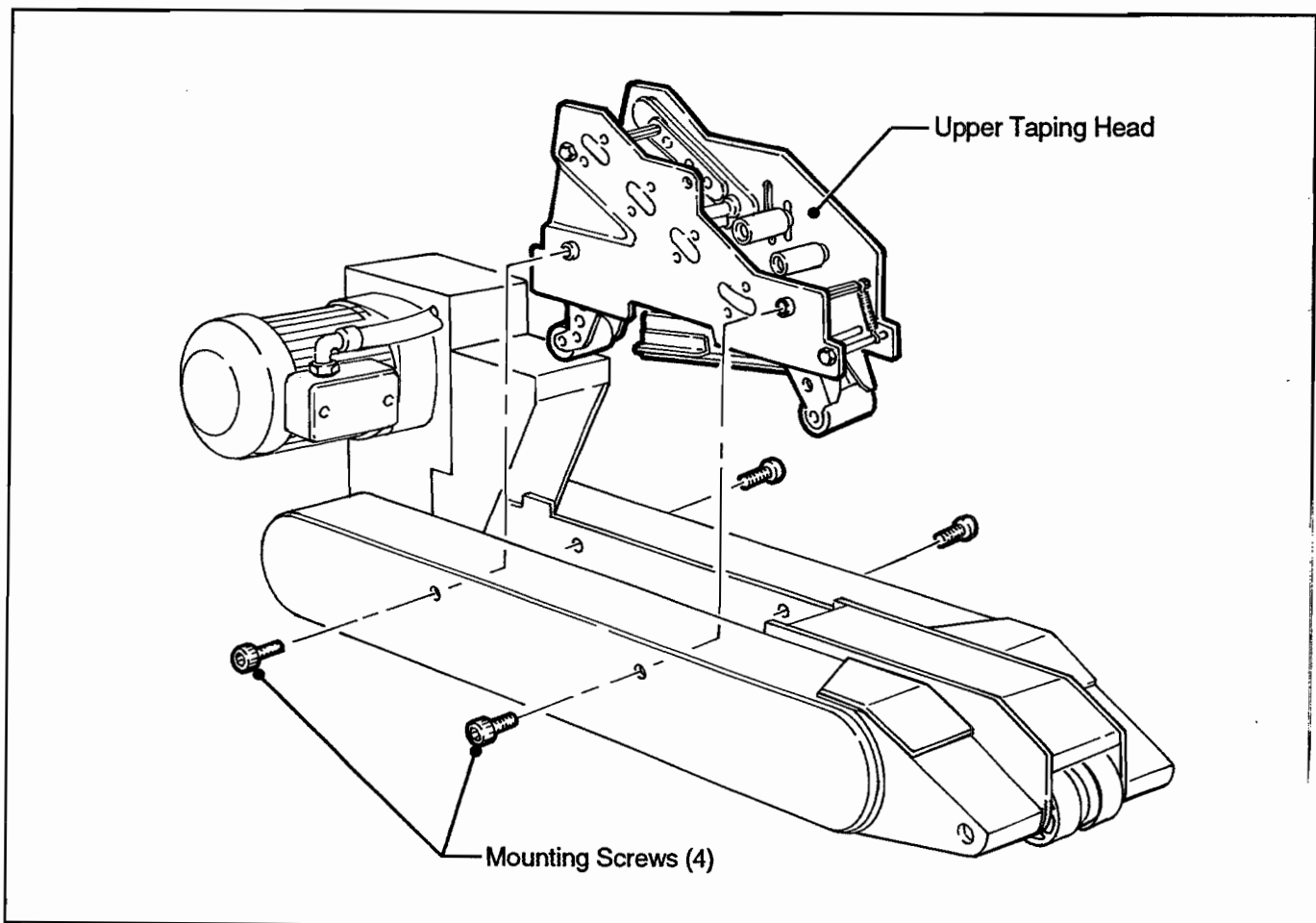


Figure 6-2 – Upper Taping Head, Removal

Special Set-Up Procedure (Continued)



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

Figure 6-3

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

Note - The one-way tension roller position is adjustable to control the leading tape leg length. Moving this roller farther away from the box top (upper taping head) or bottom (lower taping head) surface, will decrease the leading leg length. Moving it closer to the box top or bottom surface will increase the leading leg length.

Figure 6-4

Illustrates a taped box after case sealer has been converted to 2 inch [50 mm] tape leg length.

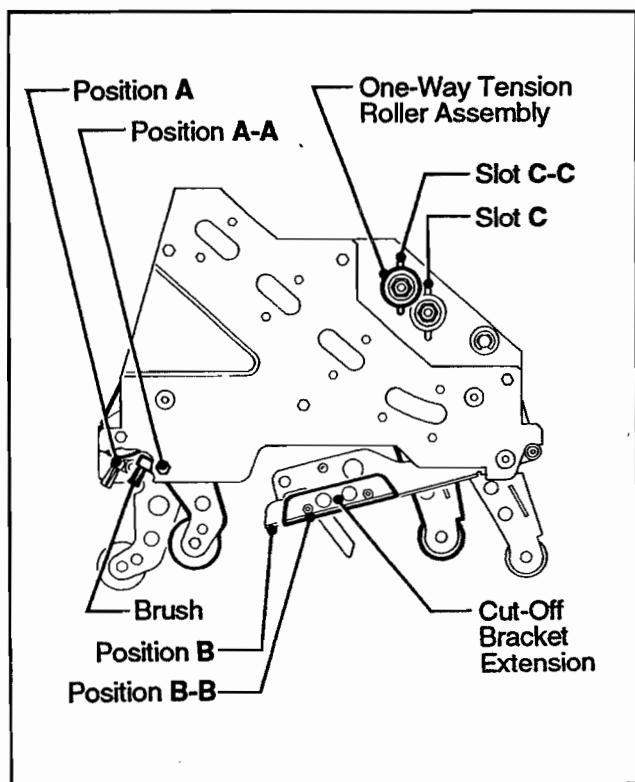


Figure 6-3 – Taping Head Changes, Upper/Lower

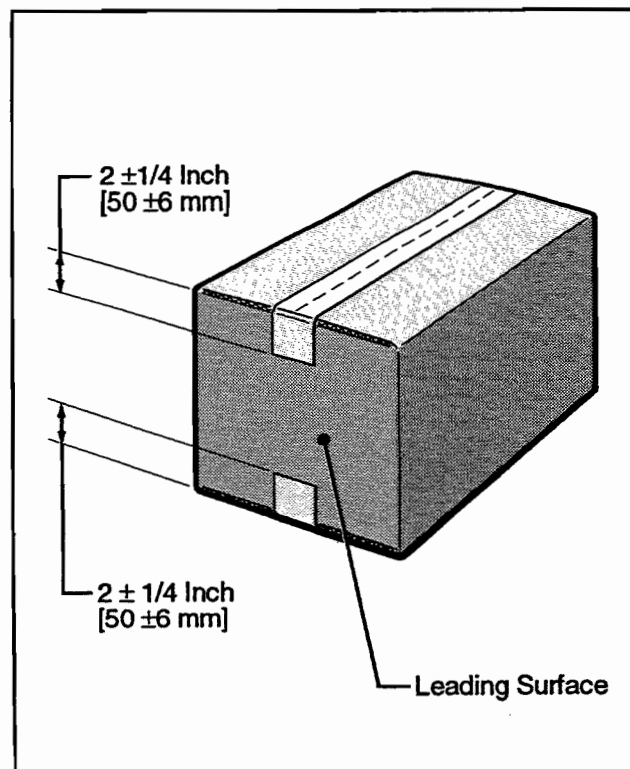


Figure 6-4 – 2 Inch [50 mm] Tape Leg Applied to Box

Special Set-Up Procedure (Continued)

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

Upper Taping Head Frame – Re-positioning

Figure 6-5

⚠ WARNING – IT IS RECOMMENDED THAT NO LESS THAN TWO PEOPLE ASSIST ON THIS SET-UP OR SEVERE INJURY OR EQUIPMENT DAMAGE COULD RESULT.

1. Raise and latch the upper taping head frame in its full "Up" position.
2. Place solid blocks (minimum 12 inches [305 mm] high) beneath upper frame in front of upper taping head applying roller and behind taping head buffing roller. **Important – blocks must be the same height in order to keep drive belts parallel with machine bed.**
3. Unlatch upper frame and allow it to come to rest on blocks.
4. **Turn off and disconnect air supply to machine.**
5. Remove the four M8 socket head capscrews with 6 mm hex key wrench from each side of the upper frame crossbar.
6. Move inner column assembly up/down until the desired hole location is achieved. **Note: When adjusting frame to lowest position on columns (small boxes), the four mounting holes ABOVE the upper frame crossbar are used.**
7. Install four M8 socket head capscrews on each side of upper frame crossbar. **Do not tighten.**
8. Check to be sure upper drive belts are parallel to machine bed. Measure from machine bed to upper belts, front and rear and adjust upper frame as necessary to make it parallel with machine bed. Tighten belts installed in step 8.
9. Connect/turn on air supply to machine and raise upper frame, latch in place, remove blocks and unlatch upper frame allowing it to return to its rest position

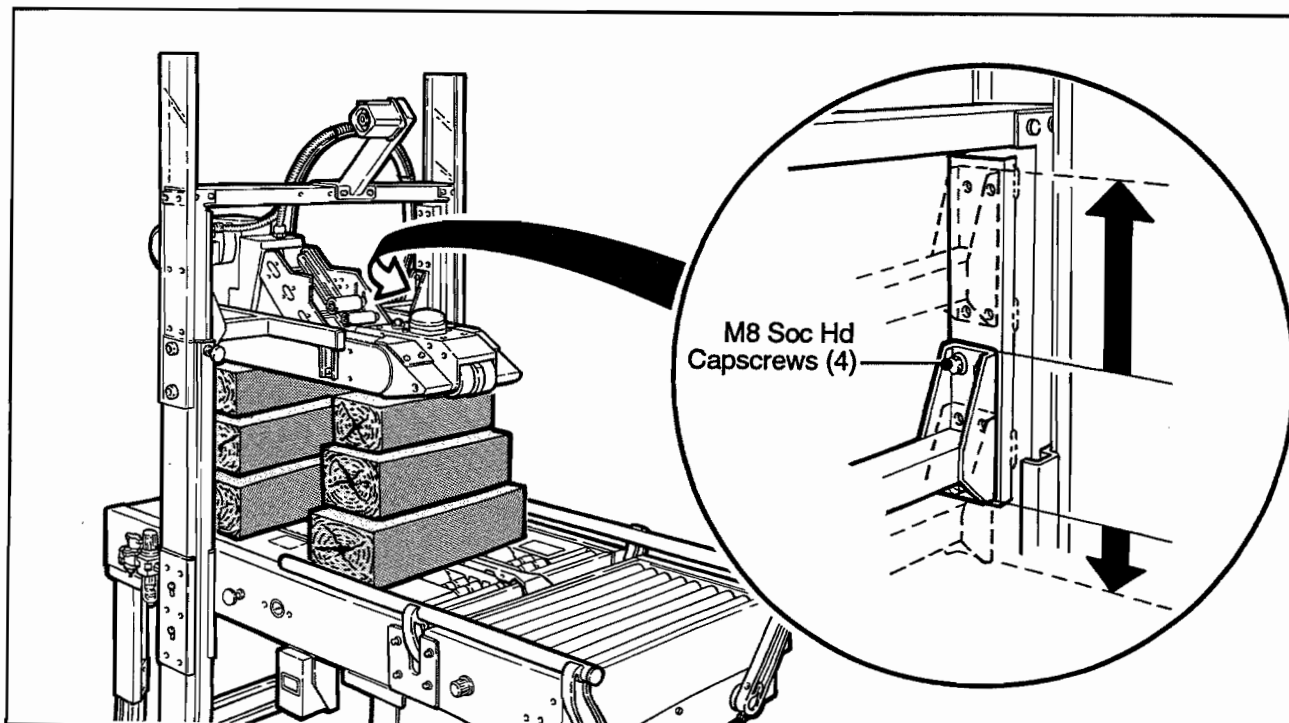


Figure 6-5 – Upper Taping Head Frame, Re-Positioning

Special Set-Up Procedure (Continued)

⚠ WARNING – TURN OFF ELECTRICAL POWER AND DISCONNECT POWER CORD FROM ELECTRICAL SUPPLY BEFORE BEGINNING SPECIAL SET-UP PROCEDURE. IF POWER CORD IS NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.

Outer Column Assembly – Re-Positioning

⚠ WARNING – IT IS RECOMMENDED THAT NO LESS THAN TWO PEOPLE ASSIST ON THIS SET-UP OR SEVERE INJURY OR EQUIPMENT DAMAGE COULD RESULT.

Figure 6-6

1. Raise and latch upper taping head frame. Turn air valve "Off".
2. Remove four M5 flat head screws with 3 mm hex key wrench that secure front center cover and remove cover.
3. Remove four M6 socket head capscrews (each side cover) with 5 mm hex key wrench that secure side covers and remove side covers.

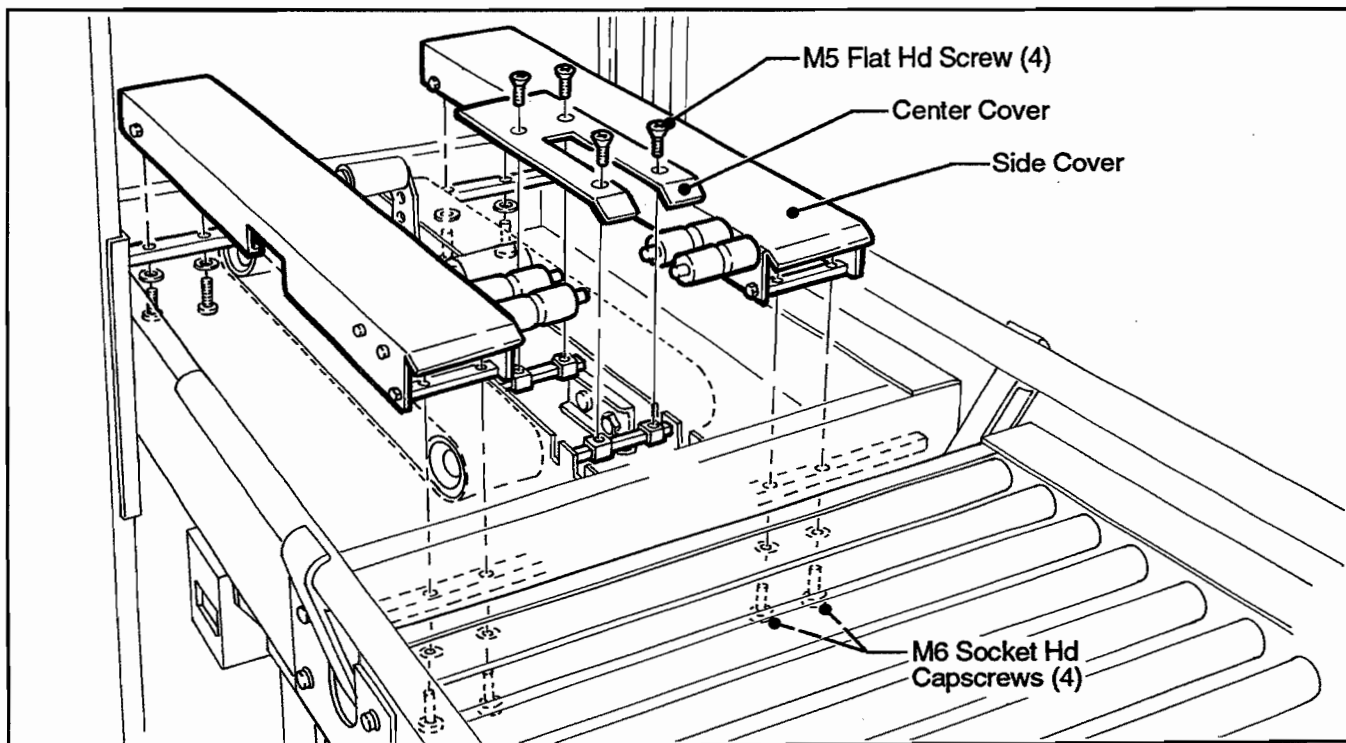


Figure 6-6 – Center/Side Cover

Figure 6-7A

4. Place solid blocks 19-1/2 to 21 inches [495 to 535 mm] high beneath upper frame in front of upper taping head applying roller and behind taping head buffing roller.
5. Turn air valve "On". Unlatch upper frame and allow it to come to rest on blocks.
6. Turn off and disconnect air supply to machine.

Special Set-Up Procedure (Continued)

⚠ WARNING – TURN OFF ELECTRICAL POWER AND DISCONNECT POWER CORD FROM ELECTRICAL SUPPLY BEFORE BEGINNING SPECIAL SET-UP PROCEDURE. IF POWER CORD IS NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.

⚠ WARNING – IT IS RECOMMENDED THAT NO LESS THAN TWO PEOPLE ASSIST ON THIS SET-UP OR SEVERE INJURY OR EQUIPMENT DAMAGE COULD RESULT.

7. Place blocks or floor jack under crossbar that connects lower columns together at bottom.
8. Slide bolt hole cover plate on outer column up and remove four M8 socket head capscrews (each column) with 6 mm hex key wrench from "A" and "B" positions on lower column assemblies and nut plates.

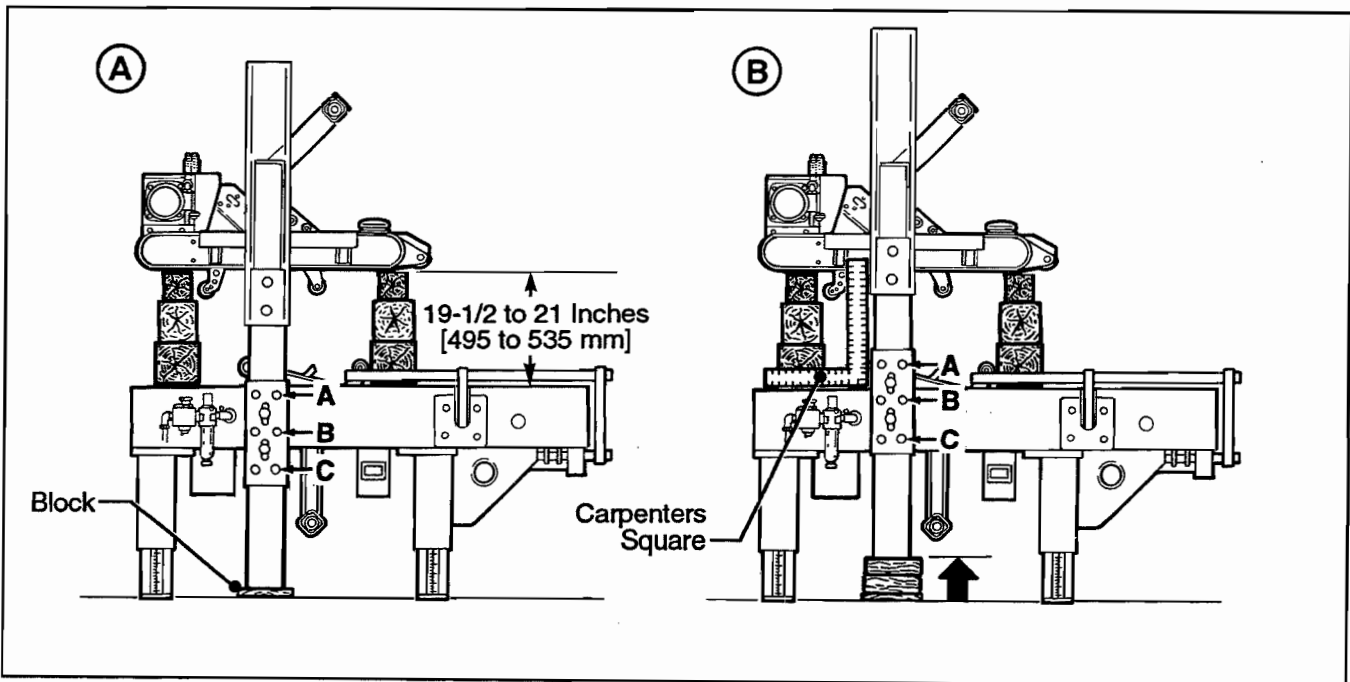


Figure 6-7 – Column Re-Positioning

Figure 6-7B

9. Raise outer columns approximately 4-1/4 inches [110 mm] (jack or block up). Line up holes "B" and "C" with holes on the side of machine frame and install four M8 capscrews through column, machine frame and into nut plate. **Do not tighten. Note – if columns are difficult to move, remove two bolts at one end of outer column lower crossbar.**
10. Using carpenters square, line up column perpendicular to machine bed. Tighten M8 capscrews at "B" and "C" positions. Repeat this procedure for both columns.
11. Connect/turn on air supply to machine and raise and latch upper frame. Turn air supply **"Off"** and remove blocking used to support upper frame.
12. Install center cover and side covers removed in Steps 2 and 3.
13. Turn air supply **"On"**, unlatch upper frame and allow frame to return to its rest position.

Troubleshooting

Review 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.

Note – Adjustment of the machine or taping heads are described in the "Adjustment" section of this manual.

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
	Taping head applying spring holder missing	Replace spring holder
Drive belts do not turn	Taping head applying spring set too high	Reduce spring pressure
	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
Upper and lower applying mechanisms interfere with each other	Motor not turning	Evaluate problem and correct
	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
Squeaking noise as boxes pass through machine	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
	Box flaps not of equal length	Check box specifications

(Continued)

Troubleshooting (Continued)

Troubleshooting Guide

Problem	Cause	Correction
Upper drive assembly does not move up or moves up slowly	Lower air pressure	Disconnect the air supply. Make sure main pressure regulator reads zero. Reconnect air supply and adjust regulator to read 70 PSIG [5 bar].
	Defective head raising valve	Clean or replace head raising valve
	Worn head raising valve actuator	Replace valve
	Clogged or damaged exhaust mufflers on the upper ends of the head raising cylinders	Clean or replace exhaust mufflers
	Defective head power valve	Clean or replace the head power valve
Upper taping head does not move down at the end of the taping cycle	Upper drive assembly force adjust regulator set too light	Adjust the upper drive assembly force adjust regulator to increase the force against the top of the box. Turn air regulator counterclockwise.
	Defective top drive assembly force adjust regulator	Replace regulator
	Defective one-way valve	Clean or replace valve
	Defective head power valve	Clean or replace valve
Upper drive assembly comes down too fast or too hard	Upper drive assembly force adjust regulator set too heavy	Adjust upper drive assembly force adjust regulator to decrease force against top of box. Turn regulator clockwise.
	Defective upper drive assembly force adjust regulator	Replace regulator
	Cushion screw misadjusted	Adjust cushion screw at base of cylinder
	Cushion screw missing	Replace screw
Centering guides move slower than normal	Centering guide force adjust regulator set too low	Adjust regulator
	Centering guide cylinder speed control not in correct adjustment	Adjust speed controls mounted on centering guide cylinder
	Defective centering guide power valve	Clean or replace valve

(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 centerline 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 built 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 spring(s)
	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 centerline of applying roller
	The one-way tension roller is defective	Replace the one-way tension roller

Electrical Diagram

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

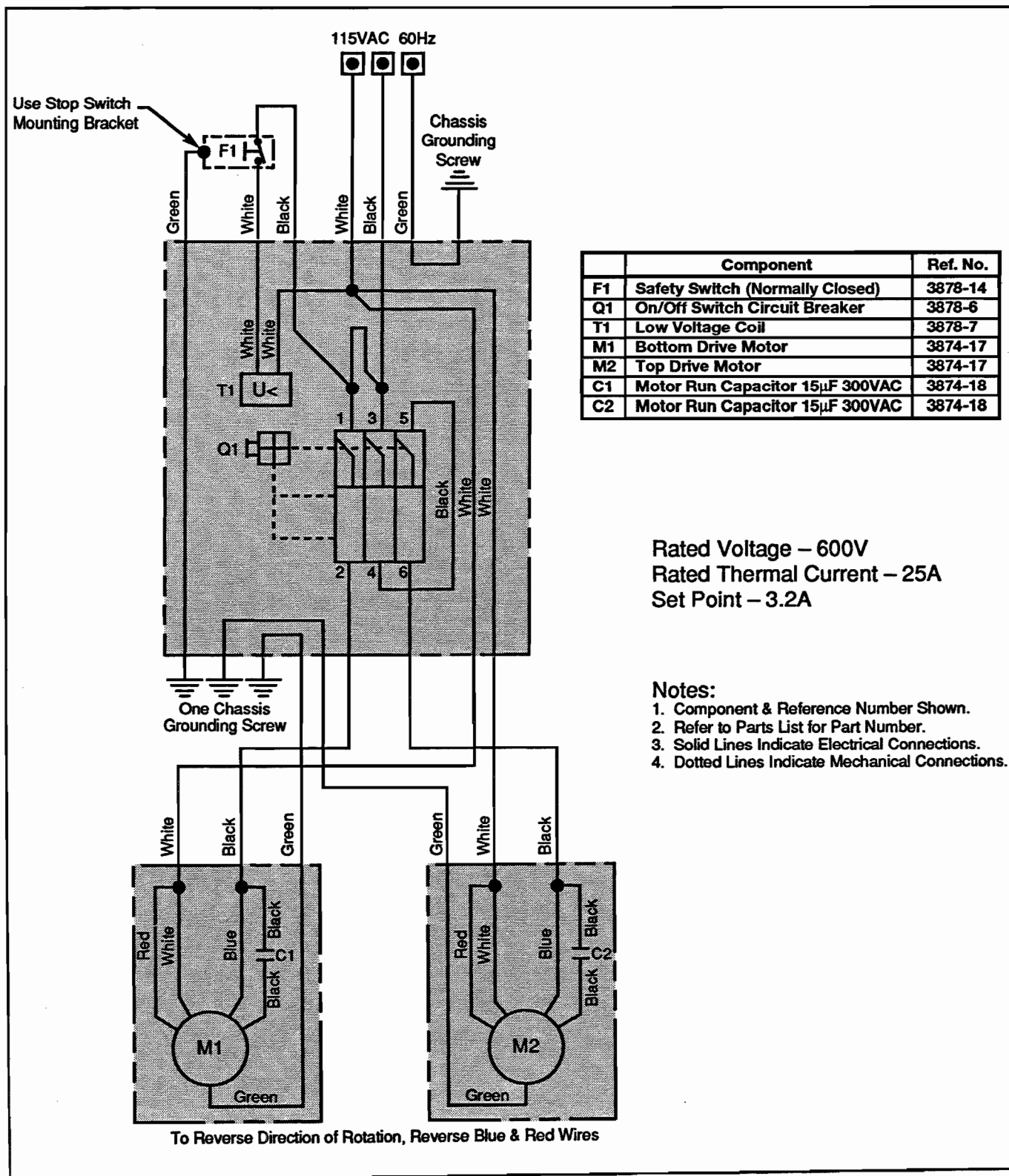


Figure 7-1 – Electrical Diagram

Pneumatic Diagram

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

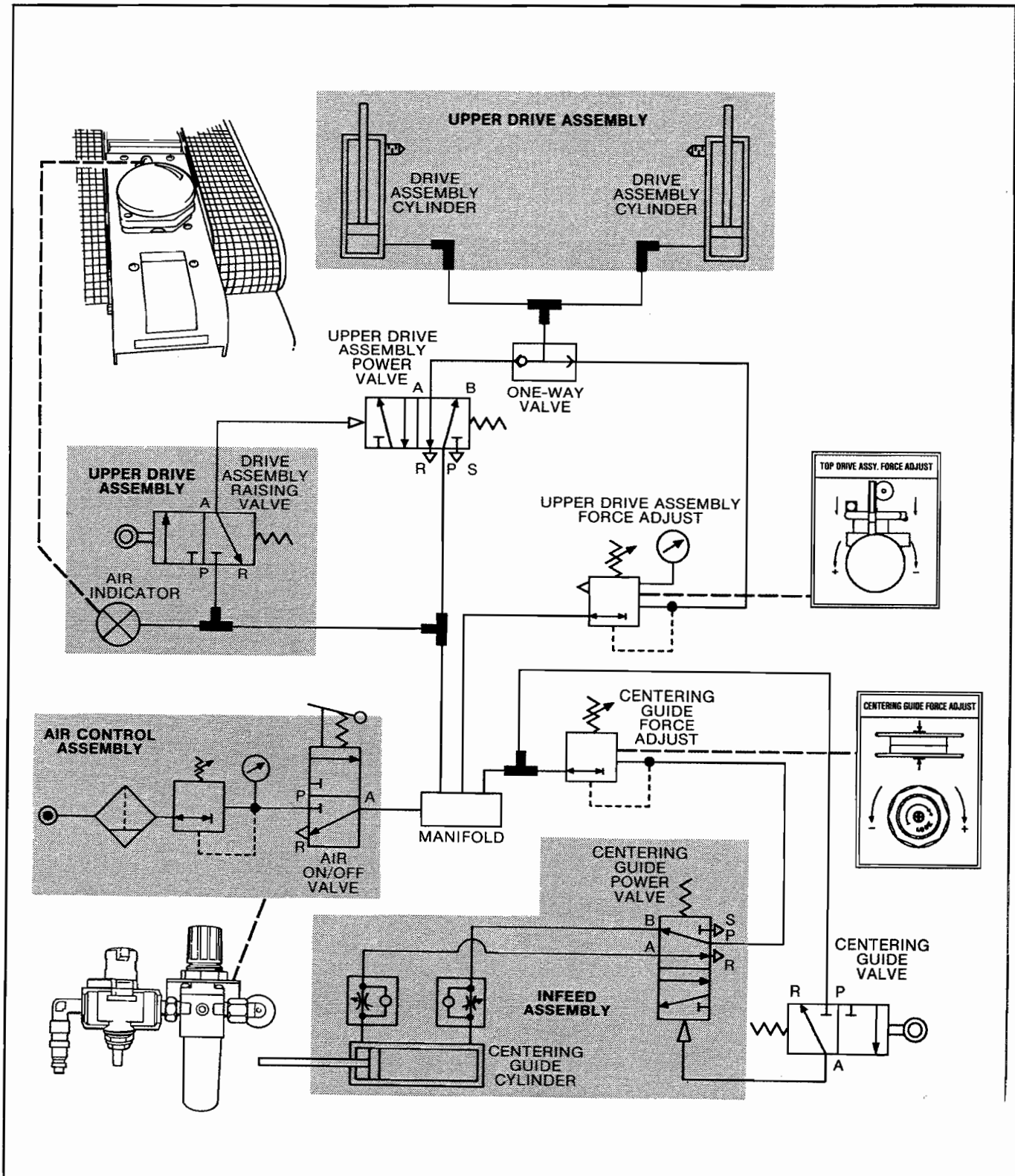


Figure 7-2 – Pneumatic Diagram

Replacement Parts And Service Information

Spare Parts – 700rks Adjustable Case Sealer

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

Qty.	Ref. No.	Part Number	Description
1	2950-10	78-8070-1274-1	Spring – Upper Extension (Silver)
1	2955-10	78-8070-1273-3	Spring – Lower Extension (Black)
2	2952-2	78-8028-7899-7	Blade – 3.5 Inch/89 mm
2	2952-12	78-8052-6602-6	Spring – Cutter
2	2949-15	78-8057-6181-0	Roller – Applying
2	2955-5	78-8057-6180-2	Roller – Buffing
4	3895-34, 3896-35	78-8052-6722-2	Belt – Drive

Label Kit

A label kit, part number 78-8098-9035-9 is available as a stock item. The kit contains all the safety labels used on the 700rks Random Case Sealer.

Tool Kit

A tool kit, part number 78-8098-8868-4, is available as a stock item. The kit contains the necessary wrenches for use with the metric fasteners on the case sealer. The threading needle, part number 78-8076-4726-4 contained in above kit is also available as a replacement stock item. Refer to "How To Order Replacement Parts" for ordering information.

(Continued on next page)

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.

Minimum billing on parts orders will be \$25.00
Replacement part prices available on request.
\$10.00 restocking charge per invoice on returned parts.

2. Replacement parts and part prices available direct from:

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

800/344 9883
FAX # 715/268 8153

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

Repair Service

Refer to the first page of this instruction manual "Service Instructions", for information on repair service.

Options/Accessories

For additional information on the options/accessories listed below, contact your 3M Representative.

Part Number	Option/Accessory
78-8069-3983-7	Caster Kit Attachment
78-8079-5574-1	KS Conveyor Extension Attachment, Type 19300 (exit end only)
78-8069-3926-6	Low Tape Sensor Kit
78-8079-5581-6	Bracket, Low Tape Sensor
78-8079-5560-0	Tape Application Sensor Kit
78-8095-4852-8	Tape Edge Fold Attachment – 3 Inch, Upper
78-8095-4853-6	Tape Edge Fold Attachment – 3 Inch, Lower
78-8069-3924-1	Conveyor Extension Attachment

Replacement Parts - Illustrations and Parts Lists

700rks Random Case Sealer, Type 19300

Frame Assemblies

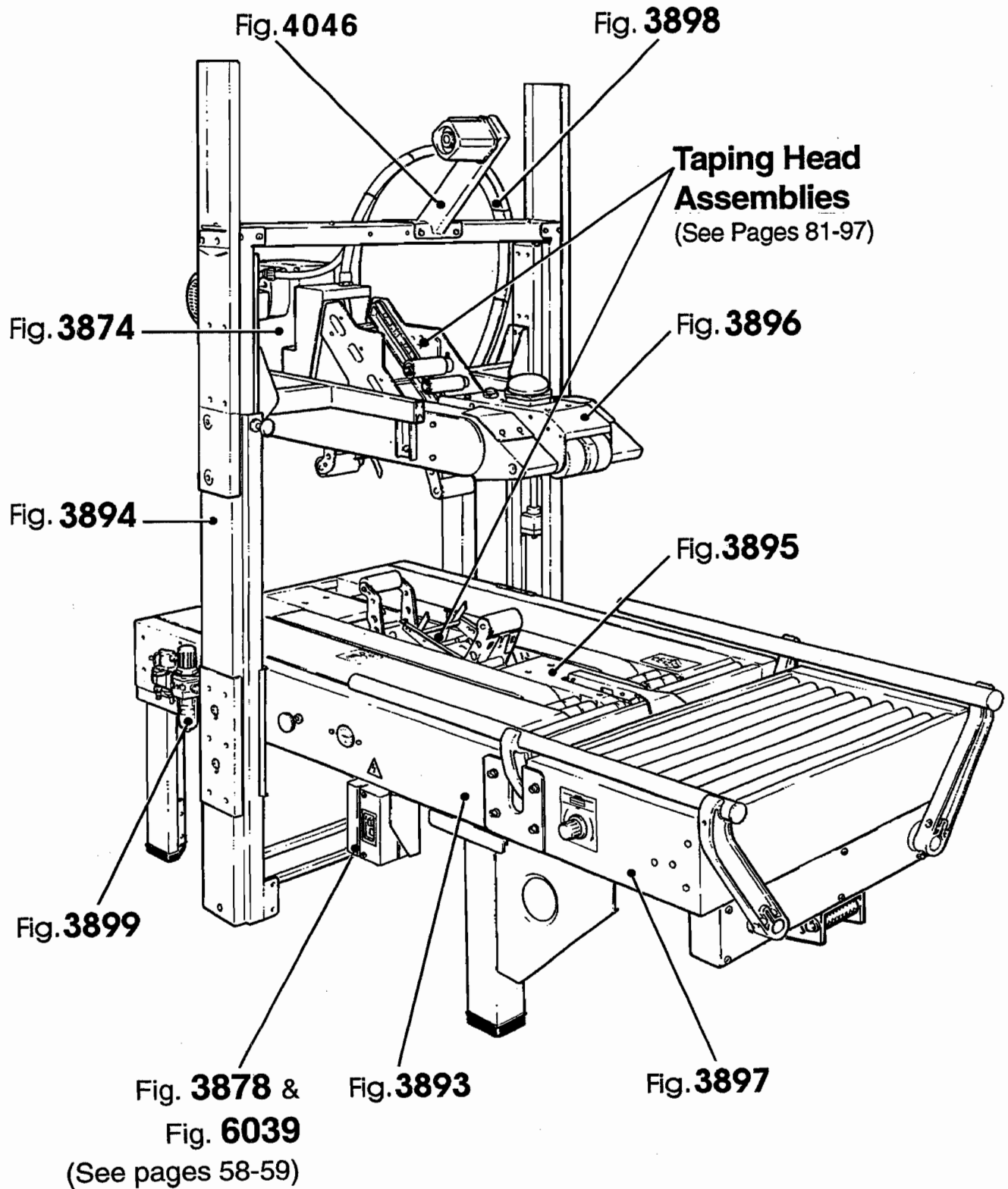
1. Refer to **Frame Assemblies** Figure to find all the parts illustrations identified by **figure numbers**.
2. Refer to the **Figure or Figures** to determine the **individual parts** required and the **parts reference number**.
3. The **replacement parts list**, that follows each illustration, includes 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 49 - "**Replacement Parts and Service Information**" of this manual for replacement parts ordering information.

IMPORTANT – Not all the parts listed are normally stocked items. Some parts or assemblies shown are available only on special order. Contact 3M/Tape Dispenser Parts to confirm item availability.

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700rks Random Case Sealer

Note:
Motor shown in mounting
position for lower drive.
Upper drive – motor must
be rotated 180°.

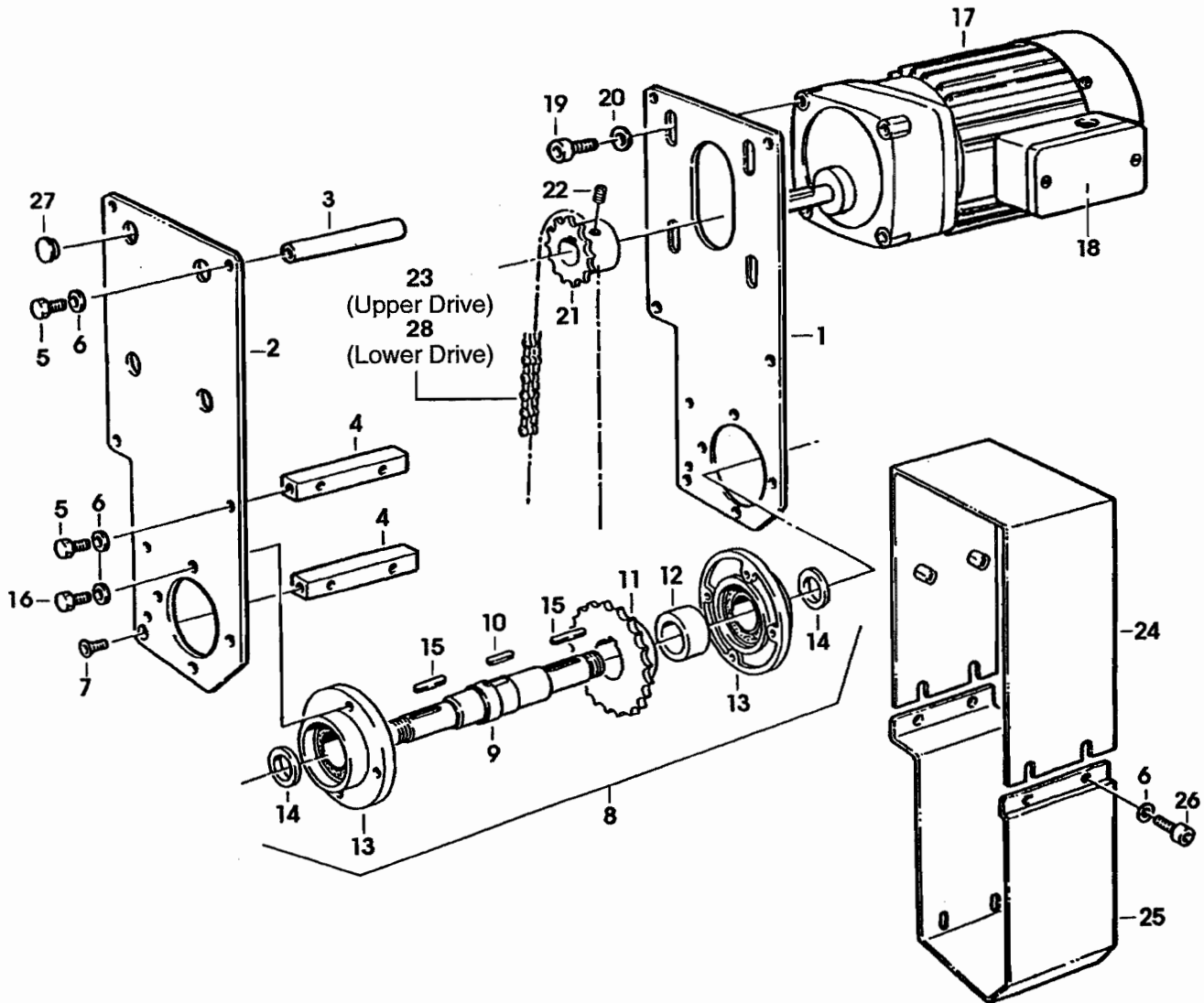


Figure 3874

Figure 3874

Ref. No.	3M Part No.	Description
3874-1	78-8091-0594-9	Frame – Lower, R/H
3874-2	78-8091-0595-6	Frame – Lower, L/H
3874-3	78-8054-8975-0	Spacer
3874-4	78-8054-8977-6	Spacer
3874-5	26-1003-5820-4	Screw – Hex Hd, M5 x 12
3874-6	78-8005-5741-1	Washer – Plain M5
3874-7	26-0001-5862-1	Screw – Flat Hd Soc, M5 x 12
3874-8	78-8060-8424-6	Drive Shaft Assembly
3874-9	78-8060-8423-8	Shaft – /30X267
3874-10	78-8057-5811-3	Key – 6 x 6 x 20 mm
3874-11	78-8054-8986-7	Sprocket – 3/8 Inch Pitch, 28 Teeth
3874-12	78-8054-8984-2	Bushing
3874-13	78-8054-8983-4	Housing – Bearing
3874-14	78-8054-8879-4	Washer – /20, 5 mm
3874-15	78-8057-5739-6	Key – M5 x 5 x 30 mm
3874-16	26-1002-5820-6	Screw – Hex Hd, M5 x 16
3874-17	78-8091-0596-4	Gearmotor – Bodine
3874-18	26-1011-8828-7	Capacitor
3874-19	78-8070-1523-1	Screw – 1/4-28 x 1/2 SHCS
3874-20	26-1000-0010-3	Washer – Flat M6
3874-21	78-8070-1524-9	Sprocket – 3/8 Inch Z=17
3874-22	78-8023-2479-4	Screw – Set W/End Cup, M6 x 10
3874-23	78-8095-1175-7	Chain – 3/8 Inch, 72 Links (Upper Drive)
3874-24	78-8091-0713-5	Cover – Upper
3874-25	78-8091-0598-0	Cover – Gearbox
3874-26	26-1003-7949-9	Screw – Soc Hd Hex Soc, M5 x 12
3874-27	78-8054-8821-6	End – Cap
3874-28	78-8070-1597-5	Chain – 3/8 Inch, 62 Links (Lower Drive)

700rks Random Case Sealer

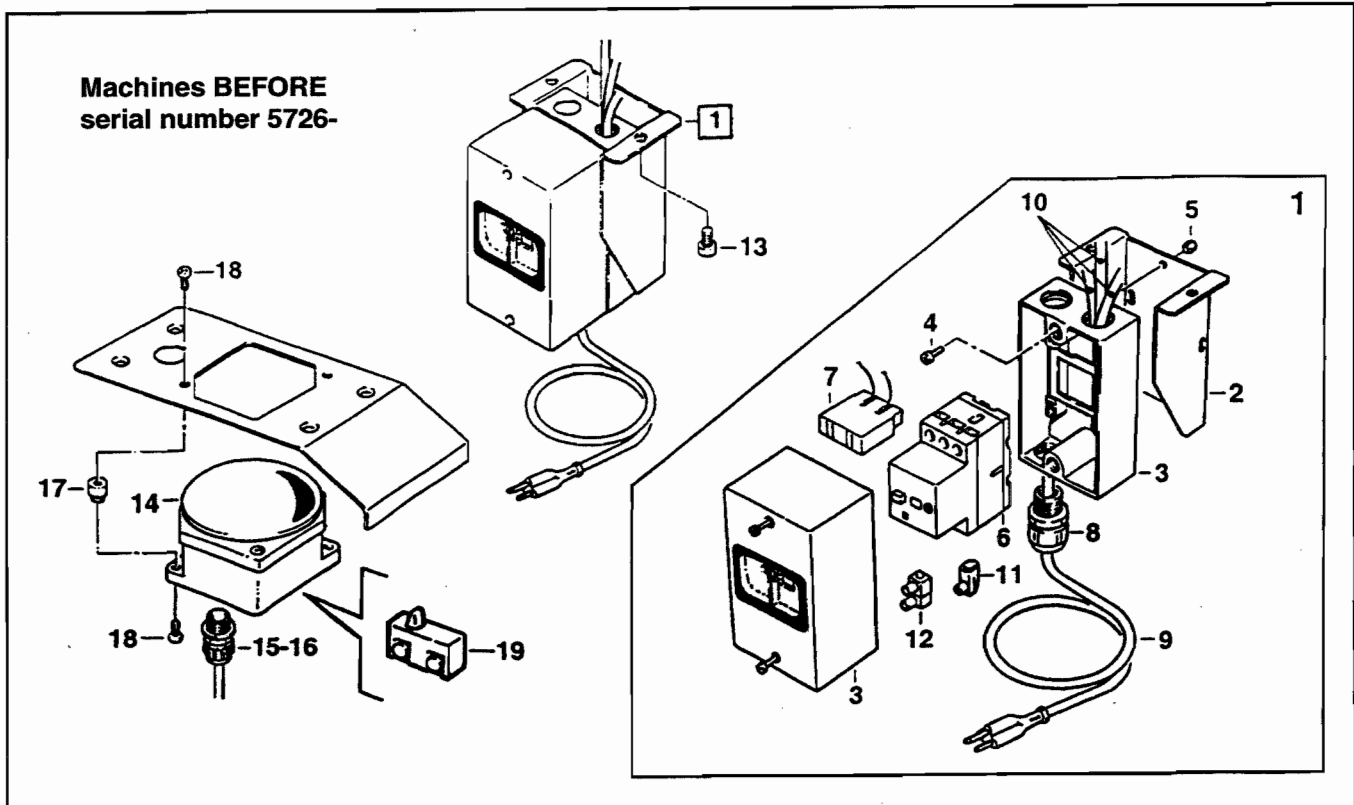


Figure 3878

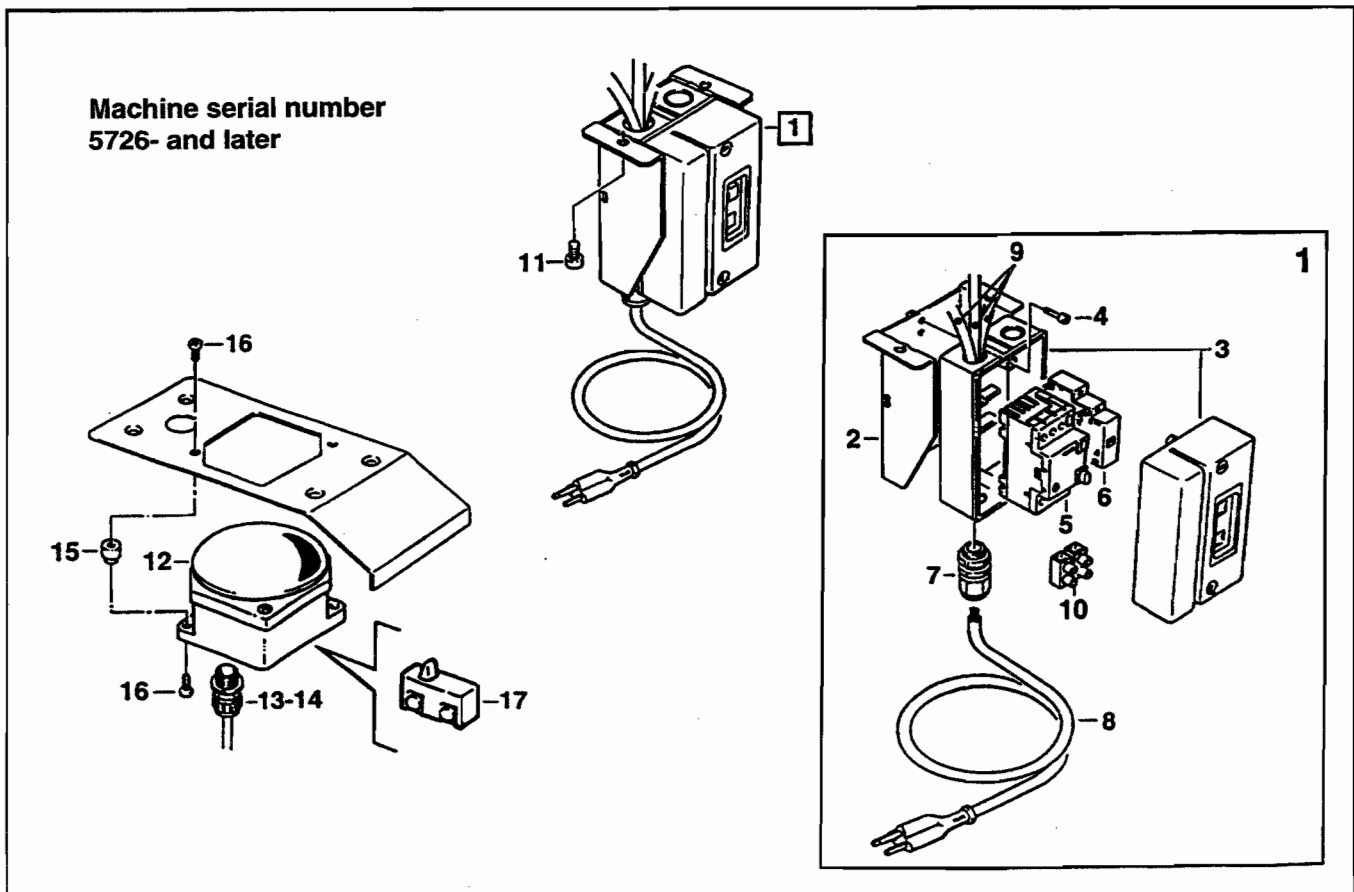


Figure 6039

Figure 3878

Ref. No.	3M Part No.	Description
3878-1	78-8091-0606-1	Switch Assembly W/Support
3878-2	78-8052-6724-8	Switch – Bracket
3878-3	78-8076-4879-1	Box – On/Off Switch
3878-4	26-1003-5707-3	Screw – Phillips Dr, M4 x 16
3878-5	26-1003-6914-4	Nut – Plastic Insert M4
3878-6	78-8076-4877-5	Switch – On/Off 2,5-4,0
3878-7	78-8076-4878-3	Coil – Low Tension 110-120-127V
3878-8	78-8057-5807-1	Cord Grip
3878-9	78-8028-7909-4	Power Cord U.S.A.
3878-10	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
3878-11	78-8076-4602-7	Terminal
3878-12	78-8076-4968-2	Terminal
3878-13	26-1003-7963-0	Screw – Soc Hd, M8 x 16
3878-14	78-8060-7633-3	Safety Button
3878-15	78-8076-4532-6	Union
3878-16	78-8076-4645-6	Lock Nut – GMP11
3878-17	78-8076-4646-4	Bushing
3878-18	78-8060-7815-6	Screw – M4 x 8
3878-19	26-1011-8527-5	Contact Block – E-Stop, Normally Closed, S&S V-40

Figure 6039

Ref. No.	3M Part No.	Description
6039-1	78-8100-1172-2	Switch Assembly – 115V, 60HZ, 1-PH
6039-2	78-8111-1434-3	Support – Switch
6039-3	78-8100-1173-0	Box – Switch, KT3-25-KAZ
6039-4	26-1003-7945-7	Screw – Soc Hd, M4 x 20
6039-5	78-8100-0755-5	Switch – KTA 3-25, 2.5-4A
6039-6	78-8100-1175-5	Coil – Low Tension, 110V
6039-7	78-8028-7909-4	Power Cord – U.S.A.
6039-8	26-1009-8724-2	Power Cord W/Plug – Type SO
6039-9	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
6039-10	78-8076-4968-2	Terminal
6039-11	26-1003-7963-0	Screw – Soc Hd, M8 x 16
6039-12	78-8060-7633-3	Safety Button
6039-13	78-8076-4532-6	Union
6039-14	78-8076-4645-6	Lock Nut – GMP 11
6039-15	78-8076-4646-4	Bushing
6039-16	78-8060-7815-6	Screw – M4 x 8
6039-17	26-1011-8527-5	Contact Block – Normally Closed for E-Stop, S & S V-40

700rks Random Case Sealer

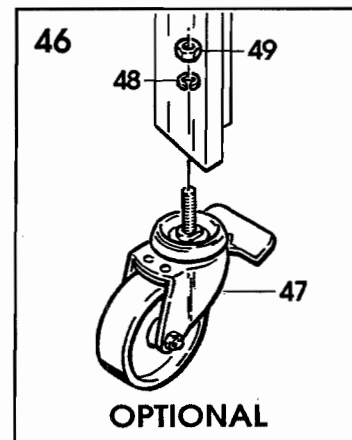
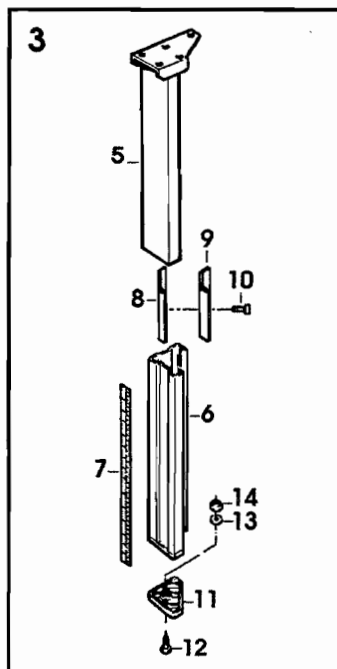
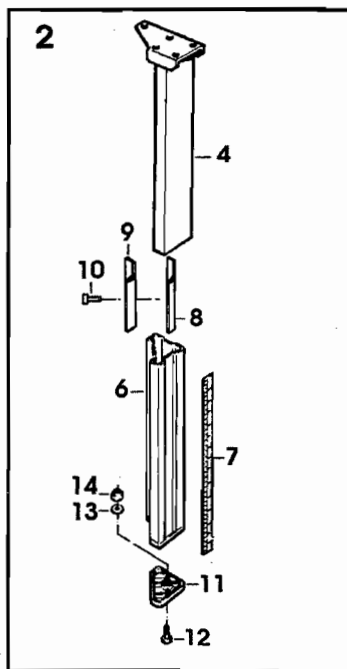
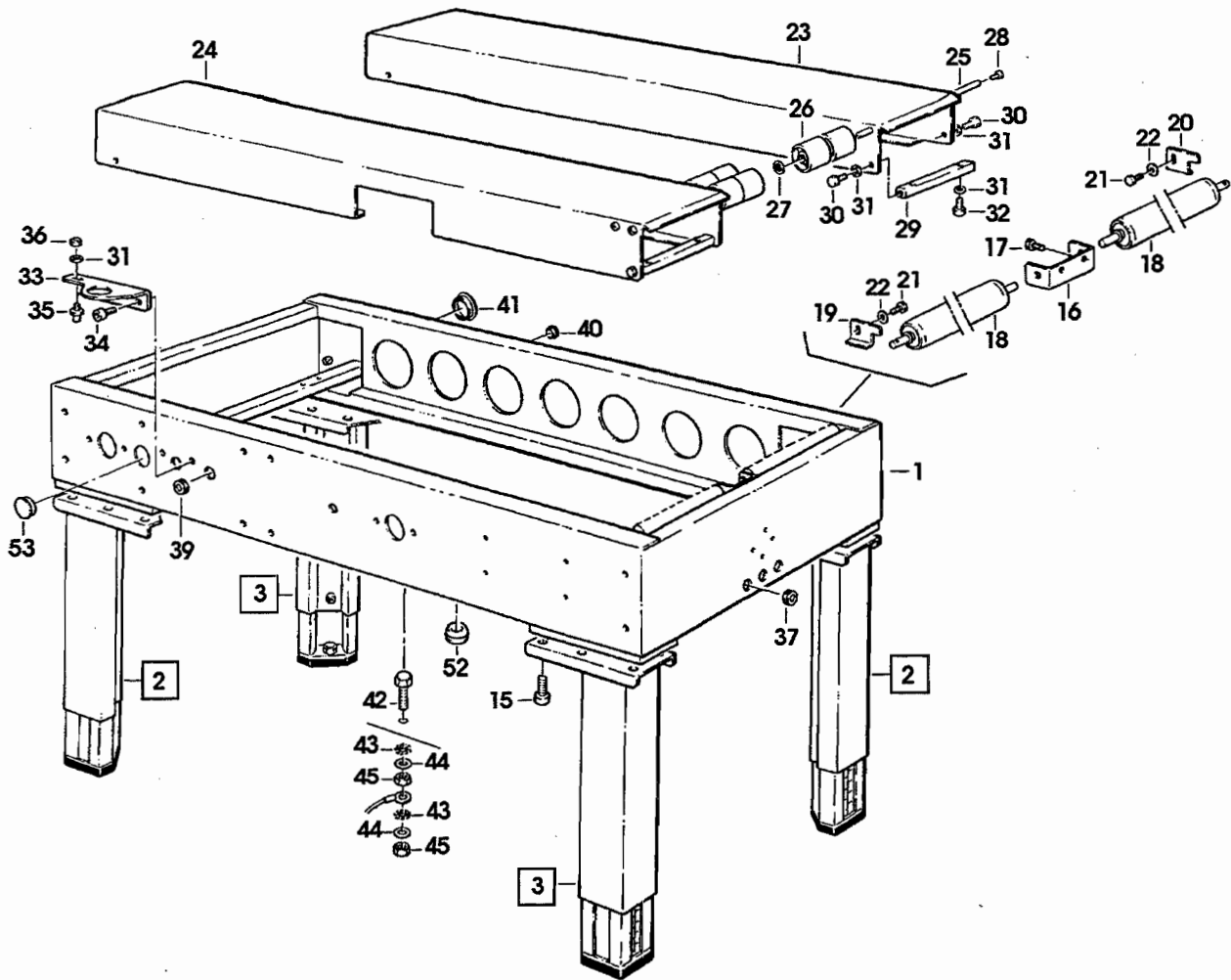


Figure 3893

Figure 3893

Ref. No.	3M Part No.	Description
3893-1	78-8091-0609-5	Bed – Conveyor
3893-2	78-8091-0557-6	Leg Assembly – R/H
3893-3	78-8091-0558-4	Leg Assembly – L/H
3893-4	78-8076-5040-9	Leg – Right
3893-5	78-8076-5041-7	Leg – Left
3893-6	78-8052-6678-6	Leg – Inner
3893-7	78-8052-6680-2	Label – Height
3893-8	78-8052-6677-8	Clamp – Inner
3893-9	78-8052-6676-0	Clamp – Outer
3893-10	26-1003-7963-0	Screw – Soc Hd, M8 x 16
3893-11	78-8052-6679-4	Pad – Foot
3893-12	26-1003-5842-8	Screw – Hex Hd, M8 x 20
3893-13	26-1004-5507-5	Washer – M8
3893-14	78-8017-9313-0	Nut – Self-Locking M8
3893-15	26-1003-7964-8	Screw – Soc Hd Soc Dr, M8 x 20
3893-16	78-8091-0610-3	Support Roller
3893-17	26-1003-5820-4	Screw – Hex Hd, M5 x 12
3893-18	78-8091-0611-1	Roller – Conveyor
3893-19	78-8091-0560-0	Plate – Roller
3893-20	78-8076-4647-2	Plate – Infeed
3893-21	78-8010-7157-8	Screw – Hex Hd, M4 x 10
3893-22	78-8005-5740-3	Washer – Plain 4 mm
3893-23	78-8091-0561-8	Plane – Conveyor, R/H
3893-24	78-8091-0562-6	Plane – Conveyor, L/H
3893-25	78-8091-0563-4	Shaft – Plane
3893-26	78-8060-7693-7	Roller – 32 x 38
3893-27	78-8052-6732-1	Ring – Special M8
3893-28	78-8060-8087-1	Screw – M5 x 10
3893-29	78-8091-0564-2	Spacer
3893-30	26-1003-5829-5	Screw – Hex Hd, M6 x 12
3893-31	26-1000-0010-3	Washer – Flat M6
3893-32	26-1003-7957-2	Screw – Soc Hd , M6 x 12
3893-33	78-8091-0612-9	Plate – L/H
3893-34	78-8010-7209-7	Screw – Hex Hd, M5 x 20
3893-35	78-8091-0613-7	Shaft – Valve
3893-36	78-8010-7418-4	Nut – Hex, M6
3893-37	78-8052-6659-6	Grommet
3893-39	78-8060-7785-1	Fairlead – /22
3893-40	78-8060-7885-9	End Cap – /25X1,2
3893-41	78-8076-4536-7	Cap – /45X1,5
3893-42	78-8060-8488-1	Screw – Hex Hd, M5 X 20
3893-43	78-8046-8217-3	Washer – Special
3893-44	78-8005-5741-1	Washer – Plain M5
3893-45	78-8010-7417-6	Nut – Hex M5
3893-46	78-8060-8060-8	Caster Assembly – /80
3893-47	78-8060-8061-6	Caster – /80
3893-48	78-8060-8124-2	Spacer – Caster
3893-49	78-8060-7699-4	Washer – 12-45, 5X4
3893-50	78-8017-9059-9	Washer – Flat For M12 Screw
3894-51	78-8060-7532-7	Nut – Self-Locking, M12
3893-52	78-8076-4702-5	Grommet – /28
3893-53	78-8076-4701-7	Cap – /28

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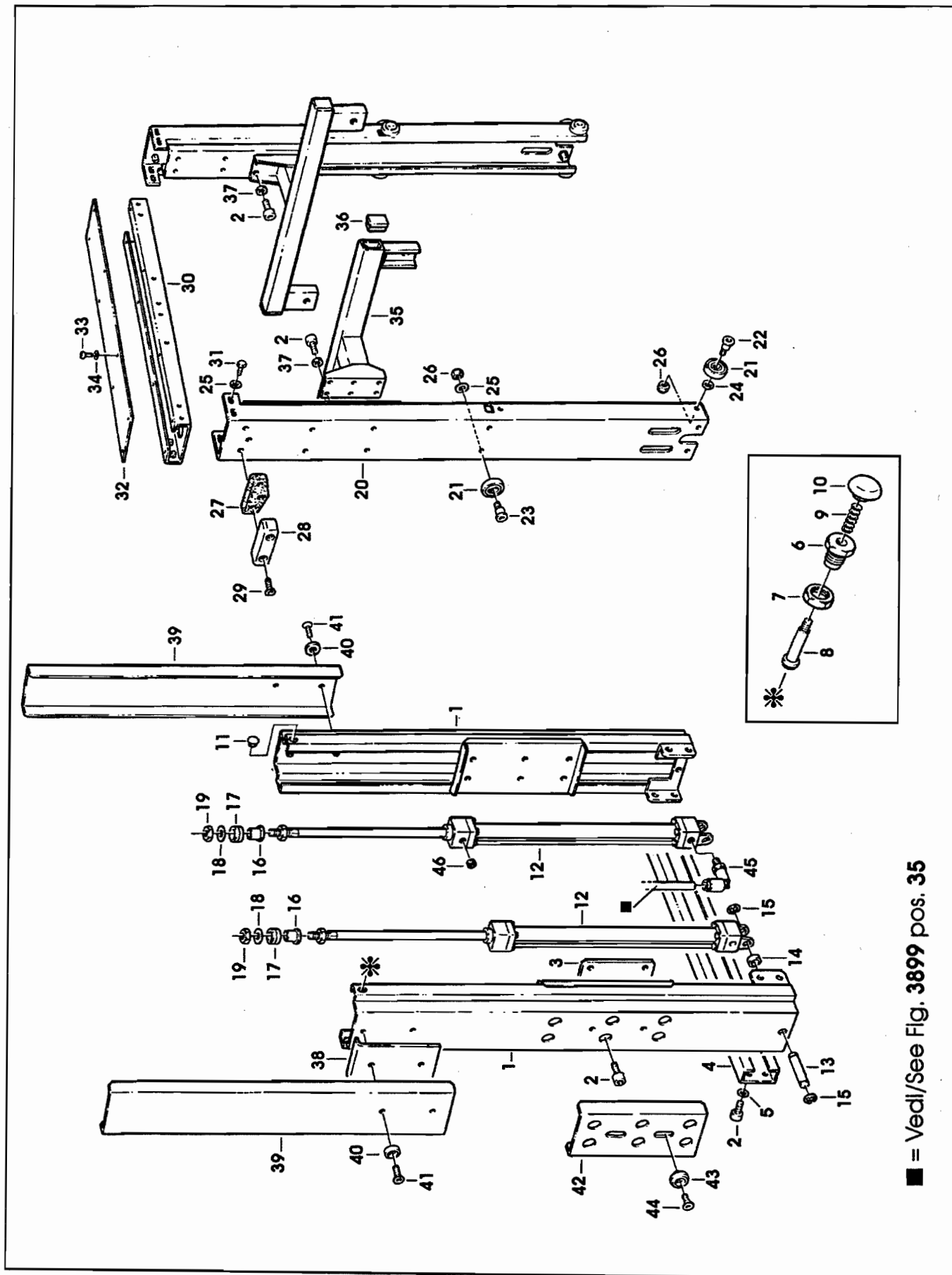


Figure 3894

Figure 3894

Ref. No.	3M Part No.	Description
3894-1	78-8091-0614-5	Column – Outer
3894-2	26-1003-7964-8	Screw – Soc Hd Soc Dr, M8 x 20
3894-3	78-8076-5474-0	Plate Assembly – Column Mount
3894-4	78-8091-0571-7	Crossbar – Lower
3894-5	78-8017-9318-9	Washer – Plain 8 mm
3894-6	78-8091-0615-2	Bushing – Stop
3894-7	78-8017-9169-6	Nut – M18 x 1
3894-8	78-8076-4544-1	Stud – Height Stop
3894-9	78-8076-4545-8	Spring
3894-10	78-8100-0954-4	Knob
3894-11	78-8076-4547-4	Cap – /18
3894-12	78-8055-0711-4	Cylinder – Air, 32 X550L MM
3894-13	78-8054-8966-9	Pin – Air Cylinder Clevis
3894-14	78-8054-8828-1	Spacer – 10,5/16X14, 5mm
3894-15	78-8060-8035-0	E-Ring – 7DIN6799
3894-16	78-8054-8824-0	Rod – End
3894-17	78-8054-8823-2	Washer – Bumper
3894-18	78-8054-8822-4	Washer – 18,2/35X2
3894-19	78-8017-9169-6	Nut – M18 X 1
3894-20	78-8091-0616-0	Column – Inner
3894-21	78-8054-8617-8	Bearing – Special
3894-22	78-8017-9106-8	Screw – Bearing Shoulder
3894-23	78-8054-8589-9	Screw – Special
3894-24	78-8054-8576-6	Spacer
3894-25	26-1000-0010-3	Washer – Flat M6
3894-26	26-1003-6916-9	Nut – Locking Plastic Insert, M6
3894-27	78-8060-7916-2	Bumper
3894-28	78-8091-0617-8	Plate – Support, Bumper
3894-29	78-8060-7918-8	Screw – Flat Soc Hd, M6 x 25
3894-30	78-8091-0618-6	Crossbar – Column
3894-31	78-8032-0375-7	Screw – Hex Hd, M6 x 16
3894-32	78-8091-0619-4	Cover – Crossbar
3894-33	78-8010-7157-8	Screw – Hex Hd, M4 x 10
3894-34	78-8005-5740-3	Washer – Plain 4 mm
3894-35	78-8091-0620-2	Support – Upper Assembly
3894-36	78-8054-8593-1	End – Cap
3894-37	78-8005-5736-1	Lockwasher – For M8 Screw
3894-38	78-8091-0621-0	Plate – Outer Column
3894-39	78-8091-0622-8	Guard
3894-40	78-8054-8577-4	Washer – Special
3894-41	78-8060-8179-6	Screw – Flat Hd Hex, M6 x 20
3894-42	78-8091-0580-8	Plate – Protection
3894-43	78-8091-0581-6	Stop – Protection
3894-44	78-8057-5726-3	Screw – F.H. Soc Hd, M6 x 15
3894-45	78-8091-0313-4	Elbow – 3199.08.10
3894-46	78-8094-6457-7	Cap – 1/8 Inch
3894-47	78-8060-8175-4	Repair Kit For Cylinder /32

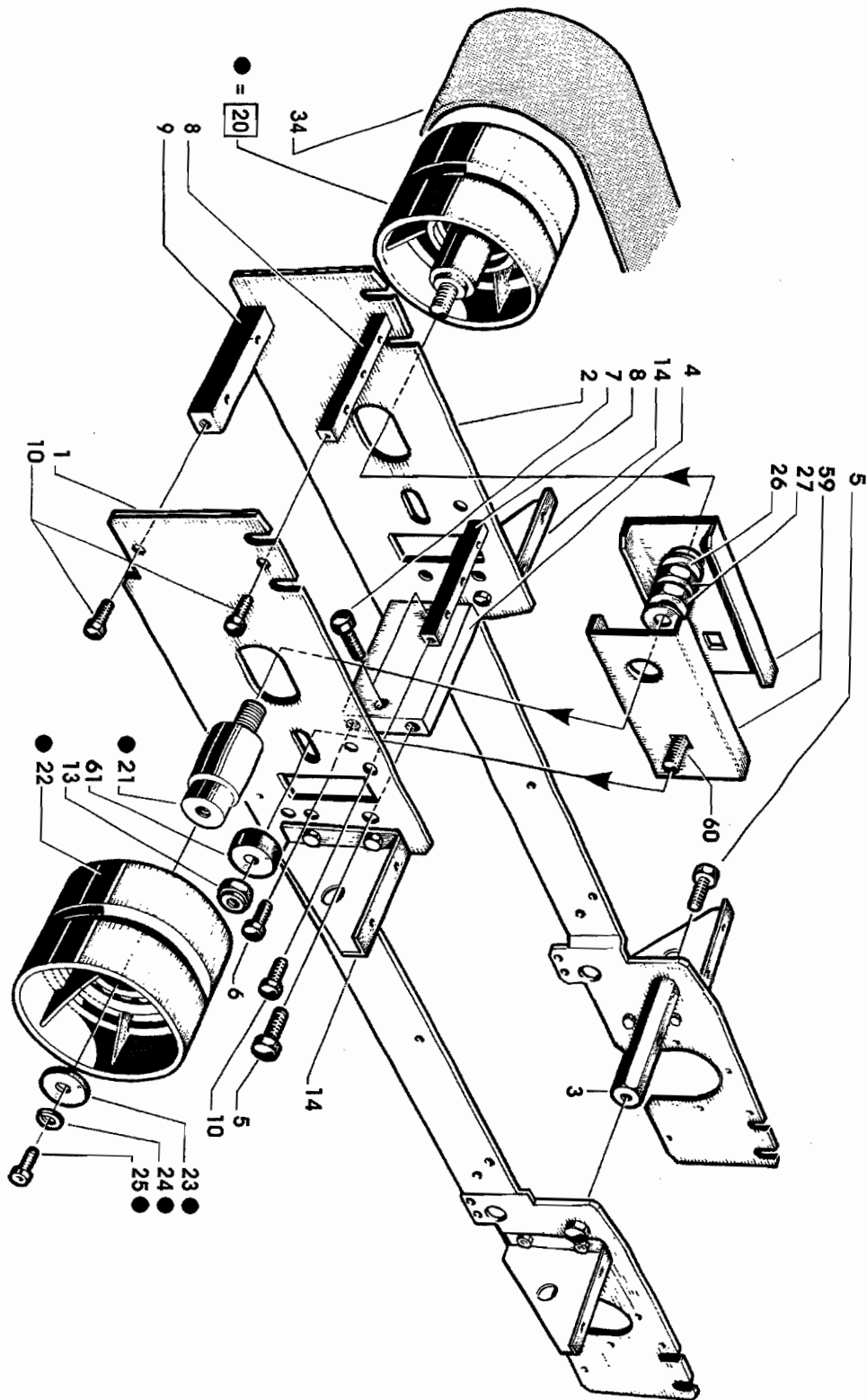


Figure 3895/1 of 2

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Ref. No.	3M Part No.	Description
3895-1	78-8052-6708-1	Side Plate
3895-2	78-8054-8649-1	Lower Main Plate Left
3895-3	78-8055-0695-9	Spacer – Hexagonal
3895-4	78-8055-0697-5	Block – Spacer
3895-5	26-1003-5849-3	Screw – Hex Hd, M10 x 16
3895-6	78-8032-0375-7	Screw – Hex Hd, M6 x 16
3895-7	26-1003-5845-1	Screw – Hex Hd, M8 x 40
3895-8	78-8055-0694-2	Spacer – 10 x 10 x 115 mm
3895-9	78-8055-0703-1	Spacer – 15 x 15 x 115 mm
3895-10	78-8010-7169-3	Screw – Hex Hd, M6 x 12
3895-13	26-1003-6918-5	Nut – Plastic Insert, Hex M10
3895-14	78-8052-6706-5	Bracket
3895-15	26-1003-5820-4	Screw – Hex Hd, M5 x 12
3895-16	78-8010-7417-6	Nut – Hex, M5
3895-17	78-8052-6714-9	Guide – Drive Belt
3895-18	26-1005-5316-8	Screw – Flat Hd Hex Dr, M5 x 16
3895-19	78-8052-6715-6	Bracket
3895-20	78-8060-8151-5	Idler Roller Assembly
3895-21	78-8052-6711-5	Shaft – Roller
3895-22	78-8052-6710-7	Roller – Idler
3895-23	78-8052-6709-9	Washer – Special
3895-24	78-8010-7435-8	Washer – Lock M6
3895-25	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
3895-26	26-1004-5511-7	Washer
3895-27	26-1003-6906-0	Nut – M12
3895-28	78-8091-0582-4	Gearbox Assembly W/O Motor (Lower)
3895-29	78-8055-0705-6	Spacer – Gearbox
3895-30	26-1003-5824-6	Screw – Hex Hd, M5 x 30
3895-31	78-8076-5105-0	Pulley Assembly – Drive
3895-32	78-8052-6713-1	Ring – Polyurethane

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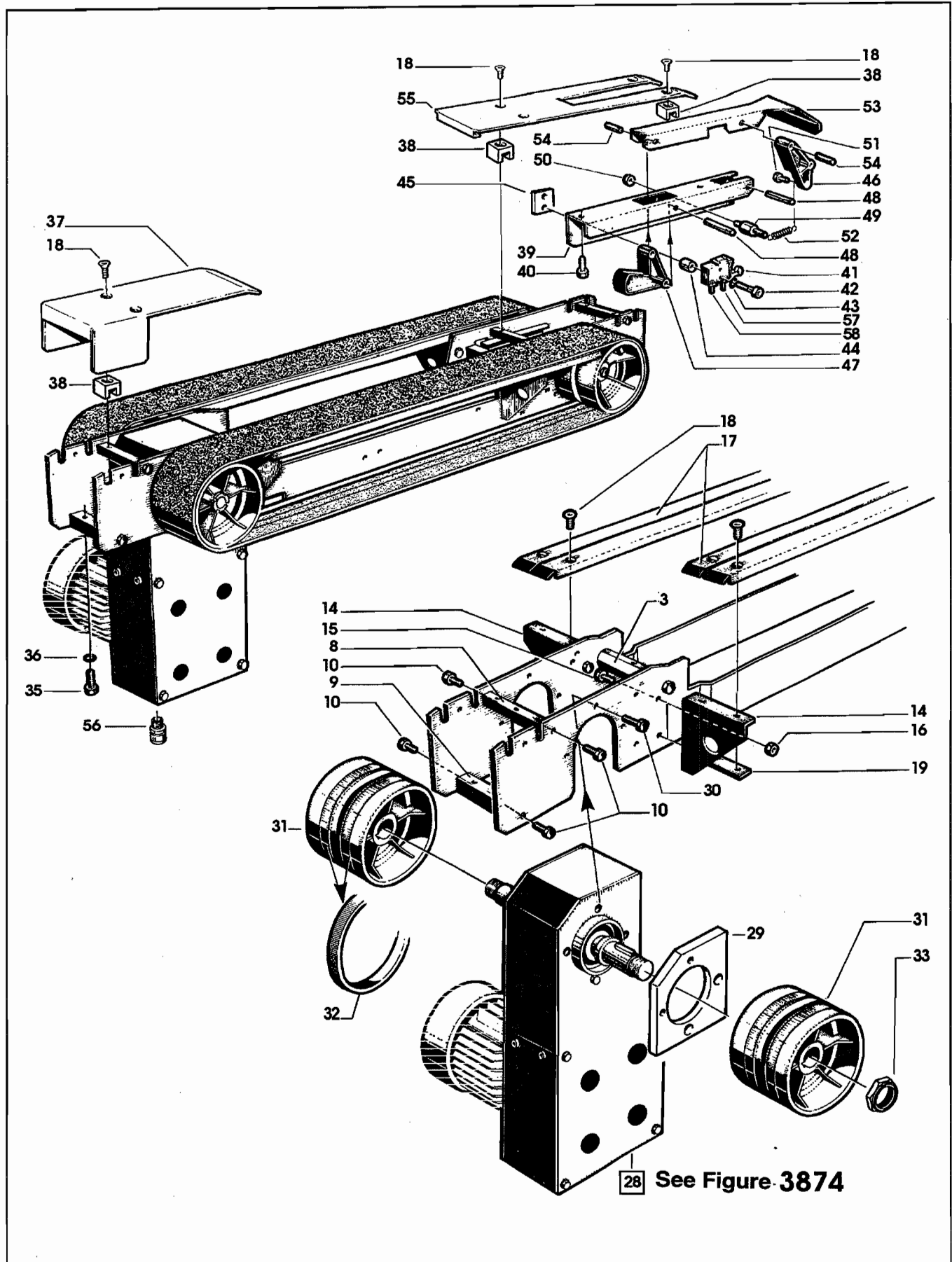


Figure 3895/2 of 2

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Ref. No.	3M Part No.	Description
3895-33	78-8060-8416-2	Nut – Special, M20 x 1
3895-34	78-8052-6722-2	Belt – Box Drive
3895-35	78-8010-7209-7	Screw – Soc Hd, M6 x 12
3895-36	26-1000-0010-3	Washer – Flat M6
3895-37	78-8091-0585-7	Cover – Rear
3895-38	78-8091-0655-8	Spacer – Cover
3895-39	78-8054-8753-1	Support – Valve
3895-40	26-1002-5817-2	Screw – Hex Hd, M5 x 8
3895-41	26-1005-6358-9	Valve – 3-Way, 2-Position
3895-42	26-1003-7947-3	Screw – Soc Hd Hex Soc, M4 x 35
3895-43	78-8005-5740-3	Washer – Plain 4 mm
3895-44	78-8054-8758-0	Spacer – Valve Holder
3895-45	78-8059-5607-1	Plate – Threaded
3895-46	78-8076-4557-3	Lever – Front
3895-47	78-8091-0623-6	Link – Actuator, Cam
3895-48	78-8091-0624-4	Pin – Roll, 6X50
3895-49	78-8054-8757-2	Pin – Spring Holder
3895-50	26-1005-6859-6	Nut – Self-Locking M5
3895-51	26-1002-4955-1	Screw – Self-Tapping, 8PX13
3895-52	78-8076-4774-4	Spring
3895-53	78-8091-0625-1	Actuator – Side Guide
3895-54	78-8091-0626-9	Pin – Roll, 6X35
3895-55	78-8091-0627-7	Cover – Front
3895-56	78-8057-5807-1	Cord Grip
3895-57	26-1005-6359-7	Fitting – Barb N-M5-PK3
3895-58	26-1005-6880-2	Fitting – Barb N-M5-PK4
3895-59	78-8114-4911-1	Belt Tensioning
3895-60	78-8076-4631-6	Screw – M10X35
3895-61	78-8070-1518-1	Spacer – Shaft

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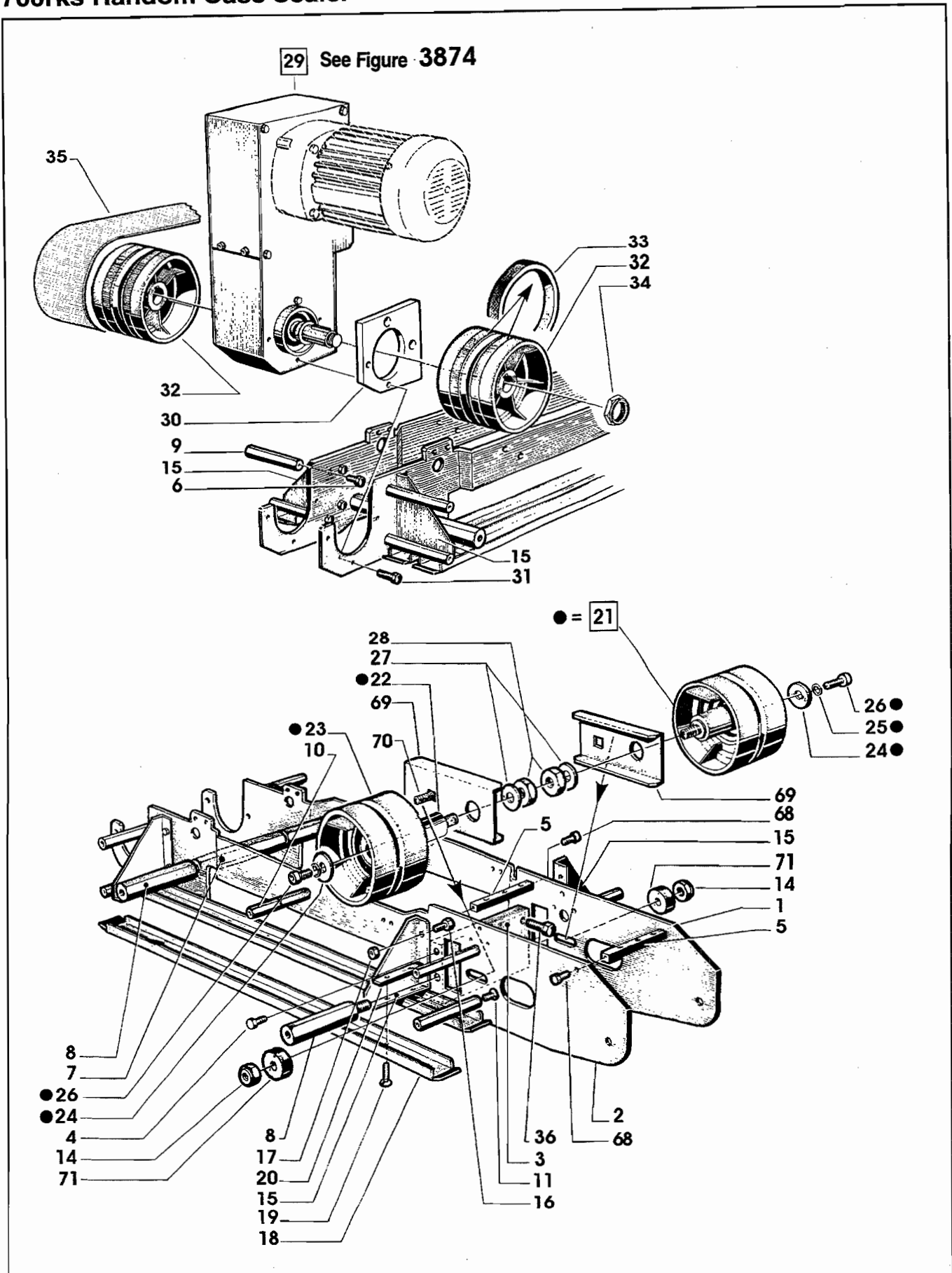


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Ref. No.	3M Part No.	Description
3896-1	78-8100-0879-3	Side Frame – Right Hand
3896-2	78-8100-0880-1	Side Frame – Left Hand
3896-3	78-8055-0697-5	Block – Spacer
3896-4	78-8032-0375-7	Screw – Hex Hd, M6 x 16
3896-5	78-8055-0694-2	Spacer – 10 x 10 x 115 mm
3896-6	78-8010-7169-3	Screw – Hex Hd, M6 x 12
3896-7	78-8055-0695-9	Spacer – Hexagonal
3896-8	78-8054-8843-0	Spacer
3896-9	78-8052-6559-8	Spacer – Upper
3896-10	78-8052-6643-0	Spacer
3896-11	26-1002-5830-5	Screw – Hex Hd, M6 x 12
3896-13	78-8052-6566-3	Washer – Friction
3896-14	26-1003-6918-5	Nut – Plastic Insert, Hex Flange, M10
3896-15	78-8052-6706-5	Bracket
3896-16	26-1003-5820-4	Screw – Hex Hd, M5 x 12
3896-17	78-8010-7417-6	Nut – Hex, M5
3896-18	78-8052-6714-9	Guide – Drive Belt
3896-19	26-1005-5316-8	Screw – Flat Hd Hex Dr, M5 x 16
3896-20	78-8052-6715-6	Bracket
3896-21	78-8060-8151-5	Idler Roller Assembly
3896-22	78-8052-6711-5	Shaft – Roller
3896-23	78-8052-6710-7	Roller – Idler
3896-24	78-8052-6709-9	Washer – Special
3896-25	78-8010-7435-8	Washer
3896-26	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
3896-27	26-1004-5511-7	Washer
3896-28	26-1003-6906-0	Nut – M12
3896-29	78-8091-0719-2	Gearbox Assembly W/O Motor (Upper)
3896-30	78-8055-0705-6	Spacer – Gearbox
3896-31	26-1003-5824-6	Screw – Hex Hd, M5 x 30
3896-32	78-8076-5105-0	Pulley Assembly – Drive
3896-33	78-8052-6713-1	Ring – Polyurethane
3896-34	78-8060-8416-2	Nut – Special M20 x 1
3896-35	78-8052-6722-2	Belt – Box Drive
3896-36	26-1003-5845-1	Screw – Hex Hd, M8 x 40

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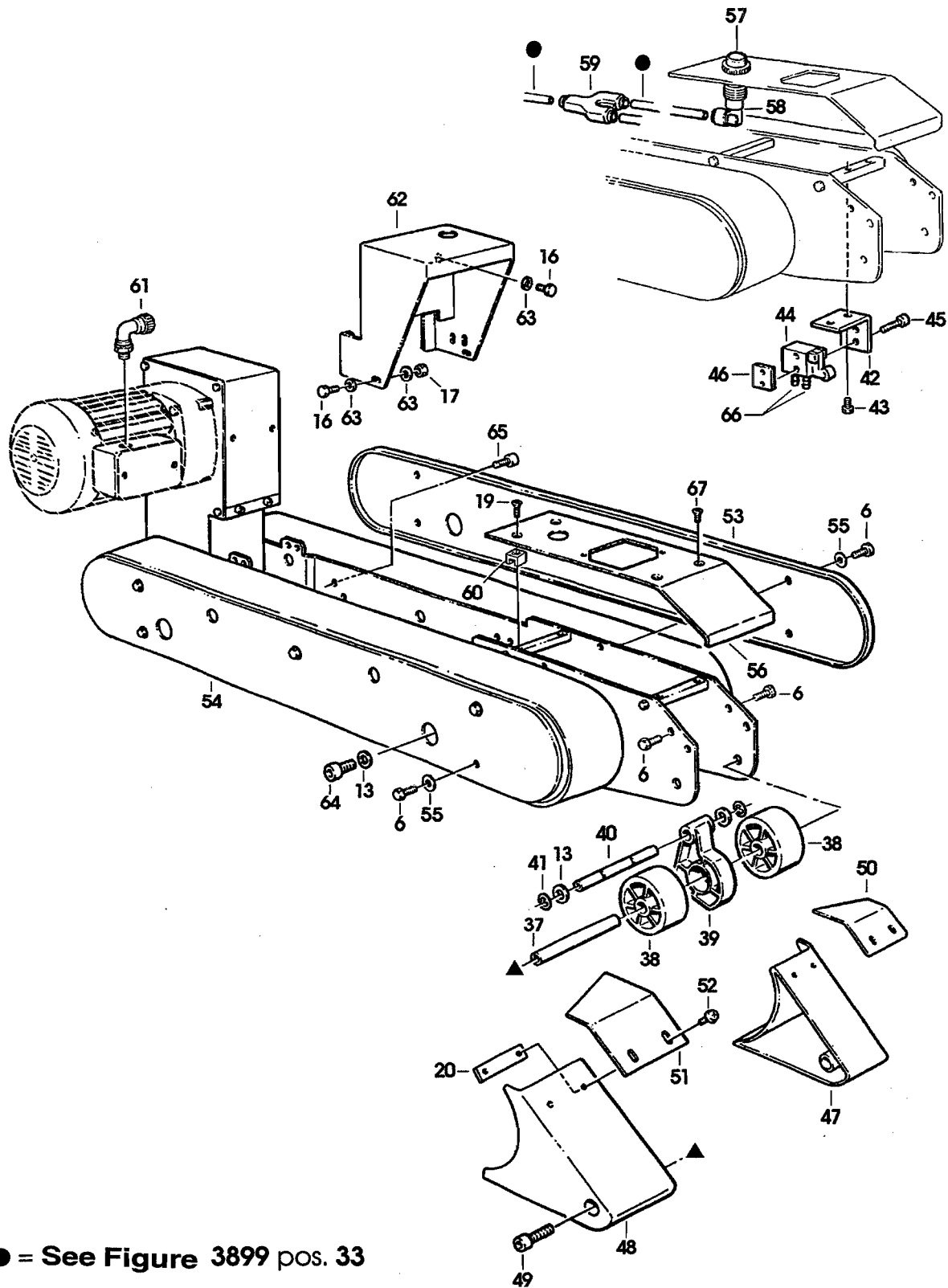


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Ref. No.	3M Part No.	Description
3896-37	78-8100-0878-5	Shaft – Roller
3896-38	78-8094-6438-7	Roller
3896-39	78-8076-4657-1	Link – Actuator, Valve
3896-40	78-8055-0721-3	Shaft – 10X115 MM
3896-41	78-8016-5855-6	E-Ring – 10 mm
3896-42	78-8054-8832-3	Support Valve
3896-43	26-1002-5817-2	Screw – Hex Hd, M5 x 8
3896-44	26-1005-6358-9	Valve – 3-Way, 2-Position
3896-45	26-1003-7946-5	Screw – Soc Hd, M4 x 25
3896-46	78-8059-5607-1	Plate – Threaded
3896-47	78-8091-0586-5	Guard – R/H
3896-48	78-8091-0587-3	Guard – L/H
3896-49	78-8060-7895-8	Screw – M8 x 35
3896-50	78-8091-0591-5	Guard – Drive
3896-51	78-8091-0592-3	Guard – Drive
3896-52	78-8060-8087-1	Screw – M5 x 10
3896-53	78-8091-0588-1	Cover – Side R/H
3896-54	78-8091-0589-9	Cover – Side, L/H
3896-55	26-1000-0010-3	Washer – Flat M6
3896-56	78-8091-0590-7	Cover – Drive, Upper
3896-57	78-8076-4665-4	Indicator – Visual
3896-58	26-1005-5909-0	Elbow
3896-59	78-8076-4664-7	Union – Female
3896-60	78-8091-0655-8	Spacer – Cover
3896-61	26-1009-8726-7	Connector – 90°
3896-62	78-8091-0593-1	Guard –Upper
3896-63	78-8005-5741-1	Washer – Plain M5
3896-64	26-1003-7973-9	Screw – Soc Hd, M10 x 16
3896-65	78-8010-7209-7	Screw – Soc Hd, M6 x 12
3896-66	26-1005-6359-7	Fitting – Barb N-M5-PK
3896-67	26-1002-3866-1	Screw – Flat Hd, M6 x 12
3896-68	26-1003-5829-5	Screw – Hex Hd, M6 x 12
3896-69	78-8114-4911-1	Belt Tensioning
3896-70	78-8076-4631-6	Screw – M10X35
3896-71	78-8070-1518-1	Spacer – Shaft

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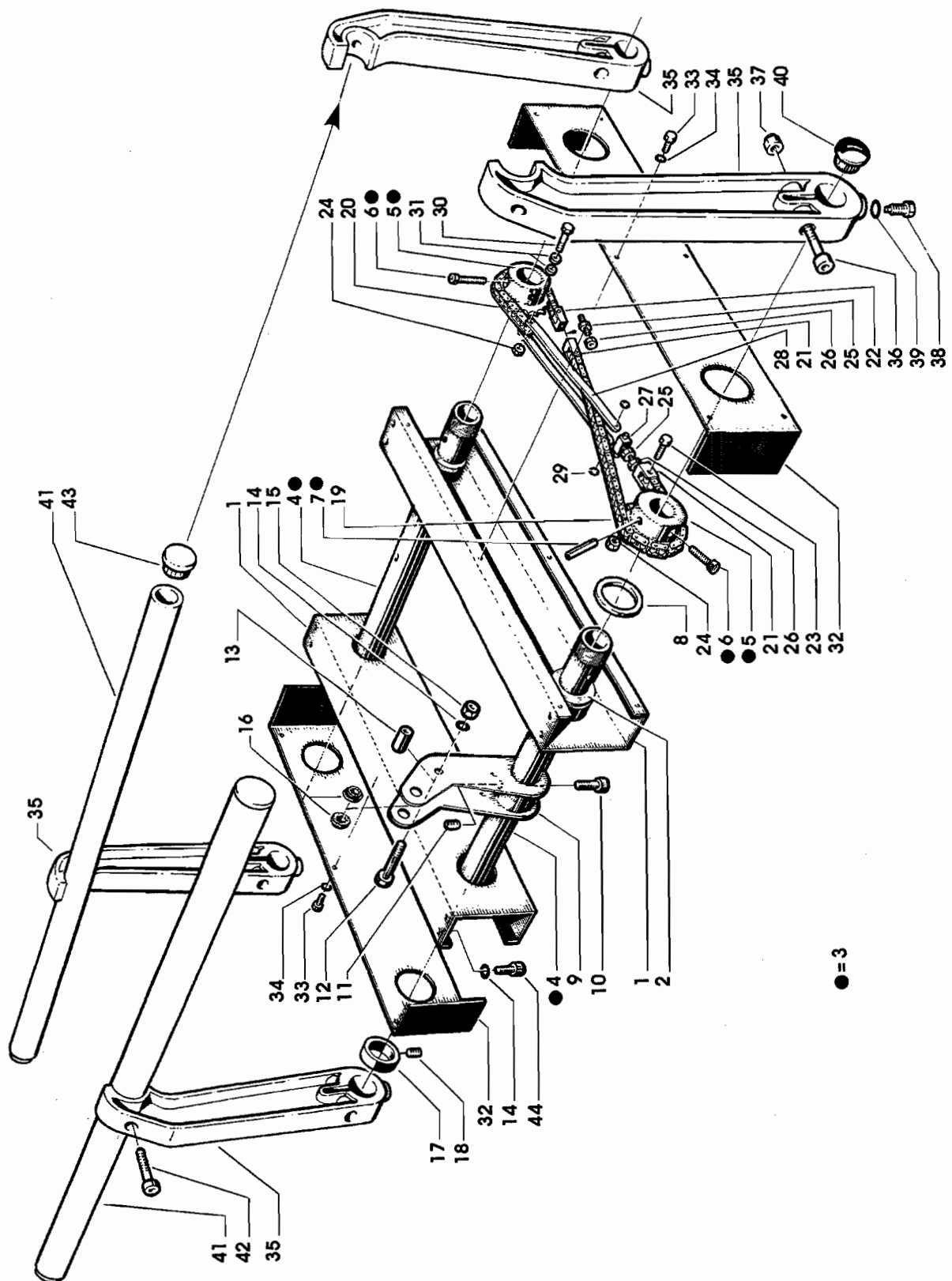


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Ref. No.	3M Part No.	Description
3897-1	78-8114-4913-7	Crossbar
3897-2	78-8054-8791-1	Rod Bushing
3897-3	78-8060-8182-0	Guide Centering Rod Assembly
3897-4	78-8054-8775-4	Guide Centering Rod
3897-5	78-8054-8778-8	Sprocket – 20 Teeth, 3/8 Inch
3897-6	26-1003-7949-9	Screw – Soc Hd Soc, M5 x 12
3897-7	78-8060-7890-9	Spring Pin – /6X45
3897-8	78-8060-8463-4	Washer – Guide Rod
3897-9	78-8054-8776-2	Lever – Flanged
3897-10	26-1003-7963-0	Screw – Soc Hd, M8 x 16
3897-11	78-8060-7889-1	Set Screw – M8 X 10
3897-12	26-1002-5836-2	Screw – Hex Hd, M6 x 40
3897-13	78-8054-8781-2	Spacer – 6,5/12 x 28 mm
3897-14	26-1000-0010-3	Washer – Flat M6
3897-15	26-1003-6916-9	Nut – Locking Plastic Insert M6
3897-16	78-8054-8780-4	Bushing – 10 x 14 mm
3897-17	78-8054-8789-5	Spacer – 30/43 x 28 mm
3897-18	26-1003-8816-9	Screw – Set M5 x 6
3897-19	78-8055-0718-9	Chain – 3/8 Inch Pitch, 55 Pitch Long
3897-20	78-8055-0719-7	Chain – 3/8 Inch Pitch, 27 Pitch Long
3897-21	78-8054-8786-1	Chain Connector
3897-22	78-8054-8788-7	Chain Connector
3897-23	78-8060-7520-2	Screw – M3 x 20
3897-24	78-8059-5517-2	Nut – Self-Locking, M3
3897-25	78-8054-8785-3	Rod – Threaded Right/Left
3897-26	78-8010-7418-4	Nut – Hex, M6
3897-27	78-8054-8784-6	Block – Chain
3897-28	78-8054-8787-9	Chain Link
3897-29	78-8056-3945-3	E-Ring – M4
3897-30	78-8060-7519-4	Screw – M3 x 25
3897-31	78-8054-8783-8	Washer – Special
3897-32	78-8091-0629-3	Cover – Infeed Conveyor
3897-33	78-8060-7818-0	Screw – Hex Hd, M4X12
3897-34	78-8005-5740-3	Washer – Plain 4 mm
3897-35	78-8060-7894-1	Clamp – Guide
3897-36	78-8060-7895-8	Screw – M8 x 35
3897-37	78-8017-9313-0	Nut – Self-Locking, M8
3897-38	78-8060-7888-3	Screw – Special, M8
3897-39	78-8017-9318-9	Washer – Plain, 8 mm
3897-40	78-8054-8790-3	End – Cap
3897-41	78-8100-0881-9	Guide – Centering
3897-42	78-8023-2334-1	Screw – Soc Hd, Hex Soc, M6 x 25
3897-43	78-8054-8779-6	End – Cap
3897-44	25-1003-7957-2	Screw – Soc Hd, Hex Hd, M6X16
3897-45	78-8091-0630-1	Frame – Infeed Conveyor
3897-46	78-8091-0631-9	Bracket

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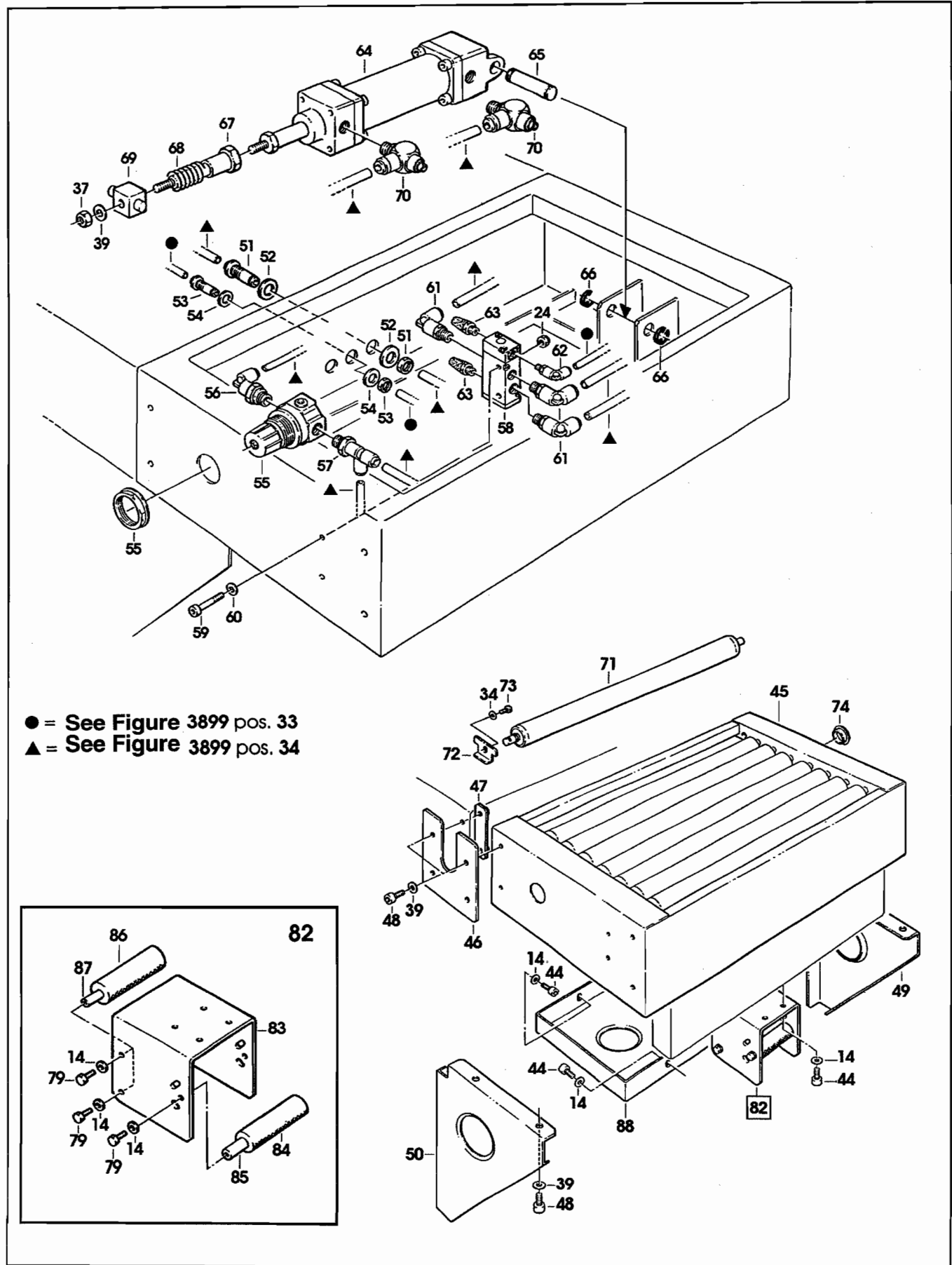


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Ref. No.	3M Part No.	Description
3897-43	78-8054-8779-6	End – Cap
3897-44	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
3897-45	78-8091-0630-1	Frame – Infeed Conveyor
3897-46	78-8091-0631-9	Bracket
3897-47	78-8091-0632-7	Plate – Mounting
3897-48	26-1003-7964-8	Screw – Soc Hd Hex Soc Dr, M8 x 20
3897-49	78-8091-0633-5	Reinforcement – R/H
3897-50	78-8091-0634-3	Reinforcement – L/H
3897-51	26-1005-6883-6	Bulk Head Fitting
3897-52	12-7991-1752-3	Washer – Plain M14
3897-53	26-1005-6887-7	Bulk Head Fitting
3897-54	78-8017-9059-9	Washer – Flat For M12 Screw
3897-55	78-8076-4675-3	Regulator – 0.5-7 Bar
3897-56	78-8055-0756-9	Union Rotating MR41-06-14
3897-57	78-8060-7858-6	Union – MR44-06-14
3897-58	78-8076-4677-9	Valve – V2A-5120-01
3897-59	78-8076-4537-5	Screw – Soc Hd Hex Hd, M3 x 25
3897-60	78-8076-4538-3	Washer – Flat, M3
3897-61	26-1005-6893-5	Elbow – 90 Degree
3897-62	78-8057-5732-1	Fitting – Elbow MR41-04-05
3897-63	26-1005-6890-1	Muffler
3897-64	78-8055-0714-8	Cylinder – Air, 40 x 120 mm
3897-65	78-8054-8996-6	Pin-Air Cylinder Clevis
3897-66	78-8056-3965-1	E-Ring – M8
3897-67	78-8054-8766-3	Bushing
3897-68	78-8054-8767-1	Spring
3897-69	78-8054-8768-9	Block – Pivot
3897-70	78-8091-0510-5	Regulator – Speed
3897-71	78-8091-0559-2	Roller
3897-72	78-8091-0635-0	Plate – Roller
3897-73	78-8010-7157-8	Screw – Hex Hd, M4 x 10
3897-74	78-8060-8184-6	Cap – /35X1,5
3897-79	78-8032-0375-7	Screw – Hex Hd, M6 x 16
3897-82	78-8076-5025-0	Support Assembly – Tape Roll Bracket
3897-83	78-8076-5027-6	Support – Tape Roll Bracket
3897-84	78-8076-5032-6	Roller – Knurled, 110,5 mm
3897-85	78-8076-5031-8	Shaft – Roller
3897-86	78-8076-5030-0	Roller – Knurled, 114 mm
3897-87	78-8076-5028-4	Shaft – Roller
3897-88	78-8091-0712-7	Plate – Reinforce
	78-8060-8435-2	Repair Kit – Cylinder /40

700rks Random Case Sealer

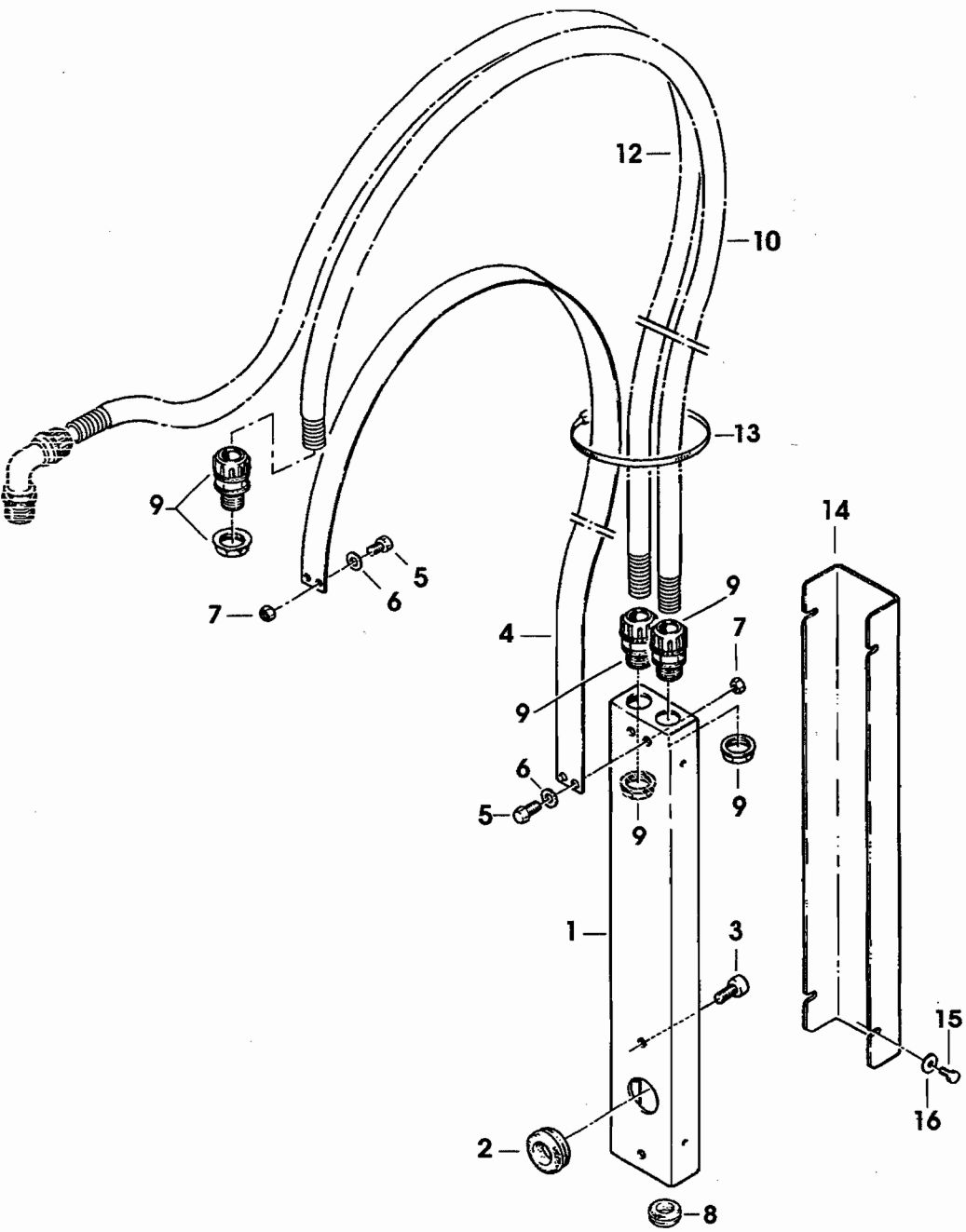


Figure 3898

Figure 3898

Ref. No.	3M Part No.	Description
3898-1	78-8091-0600-4	Housing – Wire
3898-2	78-8076-4702-5	Grommet – /28
3898-3	26-1003-7963-0	Screw – Soc Hd, M8 x 16
3898-4	78-8114-4912-9	Strap – Wire
3898-5	78-8010-7163-6	Screw – Hex Hd, M5 x 10
3898-6	78-8005-5741-1	Washer – Plain M5
3898-7	78-8010-7417-6	Nut – Hex, M5
3898-8	78-8052-6659-6	Grommet
3898-9	26-1009-8725-9	Connector – Straight
3898-10	26-1007-5508-6	Conduit – Flexible, 1/2
3898-12	26-1007-5508-6	Conduit – Flexible, 1/2
3898-13	78-8060-8029-3	Clamp – 140 x 3,5
3898-14	78-8076-5118-3	Cover – Channel
3898-15	78-8010-7157-8	Screw – Hex Hd, M4 x 10
3898-16	78-8017-9018-5	Washer – Plain, M4 SPEC.

700rks Random Case Sealer

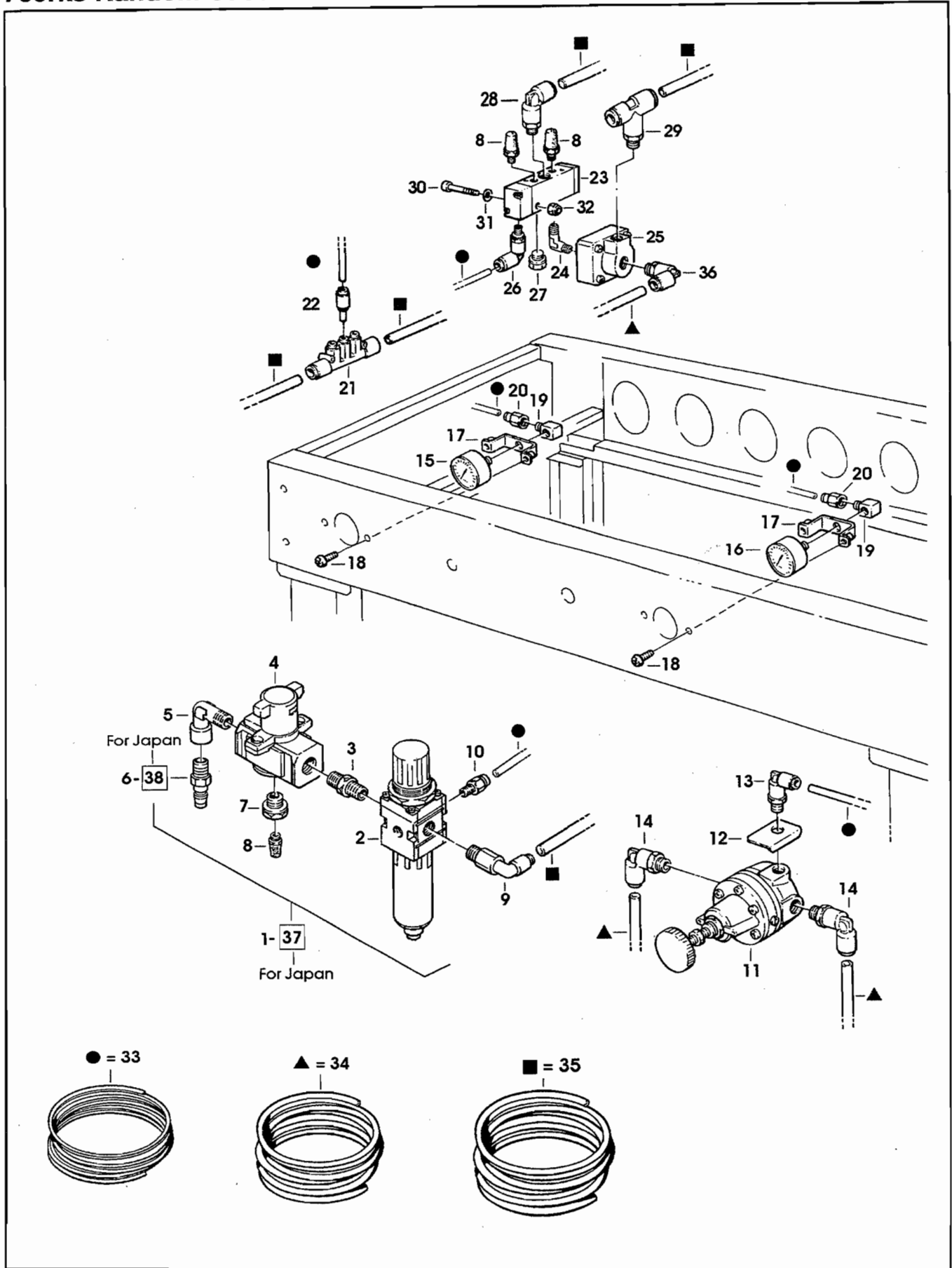


Figure 3899

Figure 3899

Ref. No.	3M Part No.	Description
3899-1	78-8091-0424-9	Filter/Regulator Assembly
3899-2	26-1014-4558-8	Filter – Regulator, W/Metal Bowl
3899-3	78-8060-7899-0	Nipple – RA 012 1/4 Inch - 1/4 Inch
3899-4	78-8091-0715-0	Valve – EVHS-4500, F02-X116
3899-5	78-8060-7900-6	Union – RA 022 1/4 Inch - 1/4 Inch
3899-6	26-1005-6897-6	Hose Connector
3899-7	78-8076-4670-4	Reduction – 3/8 Inch - 1/8 Inch
3899-8	26-1005-6890-1	Muffler
3899-9	78-8091-0422-3	Elbow – KQW08-02S
3899-10	78-8076-4891-6	Union – Straight KQH04-01S
3899-11	78-8076-4673-8	Regulator – Pressure
3899-12	78-8091-0637-6	Plate – Regulator
3899-13	26-1005-5909-0	Elbow
3899-14	78-8055-0756-9	Union – Rotating, MR41-06-14
3899-15	78-8054-8838-0	Gauge – Air
3899-16	78-8076-4671-2	Gauge – Pressure
3899-17	78-8076-4535-9	Bracket
3899-18	78-8076-4625-8	Screw – Special M5 x 16
3899-19	78-8091-0638-4	Elbow – G-1/8-A/I
3899-20	78-8076-4672-0	Union – Straight, Female
3899-21	78-8091-0639-2	Union – TE 33040806
3899-22	78-8057-5735-4	Fitting – Reducer MR25-04-06
3899-23	78-8076-4677-9	Valve – V2A 5120-01
3899-24	78-8017-9426-0	Elbow – 90 Degree, 1/8 Inch Male x 1/8 Inch Male
3899-25	78-8076-4678-7	Valve – Quick Exhaust
3899-26	78-8057-5732-1	Fitting – Elbow MR41-04-05
3899-27	78-8060-7690-3	Cap – B-1/8 Inch
3899-28	78-8091-0313-4	Elbow – 3199.08.10
3899-29	78-8091-0317-5	Union – Tee, 3198.08.10
3899-30	78-8076-4537-5	Screw – Soc Hd Hex Hd, M3 x 25
3899-31	78-8076-4538-3	Washer – Flat, M3
3899-32	78-8059-5517-2	Nut – Self-Locking, M3
3899-33	78-8060-8033-5	Skein Tubing – 5M, D4/3
3899-34	78-8060-8034-3	Skein Tubing – 5M, D6/4
3899-35	78-8076-4911-2	Tubing – D8X6, 5 MT
3899-36	26-1005-6893-5	Elbow – 90 Degree

700rks Random Case Sealer

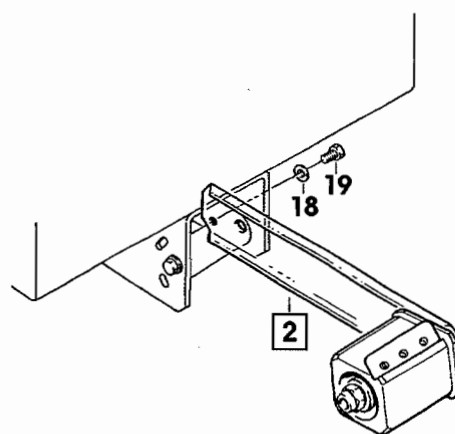
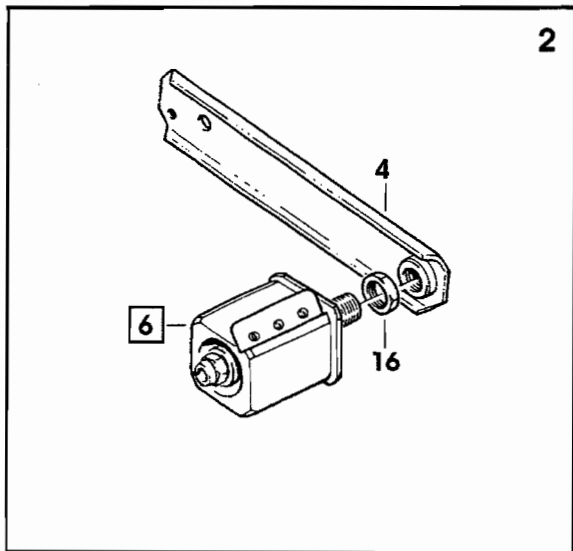
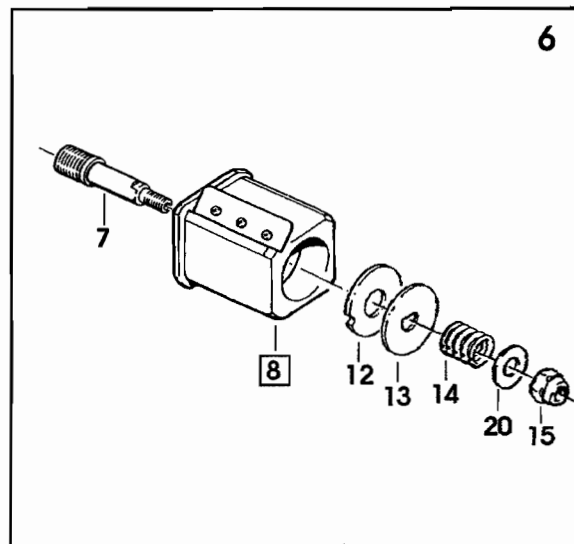
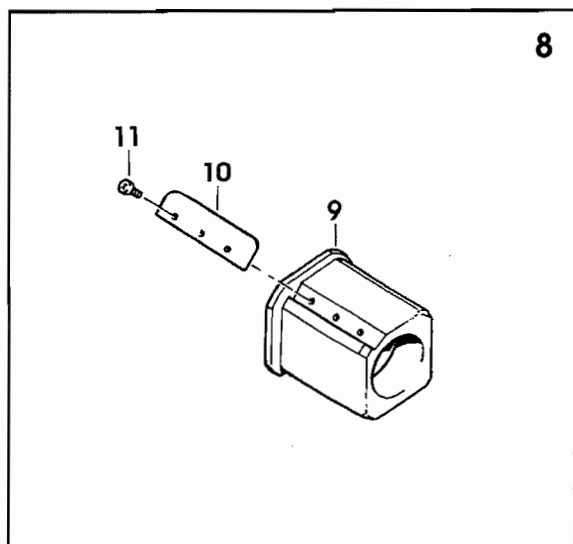
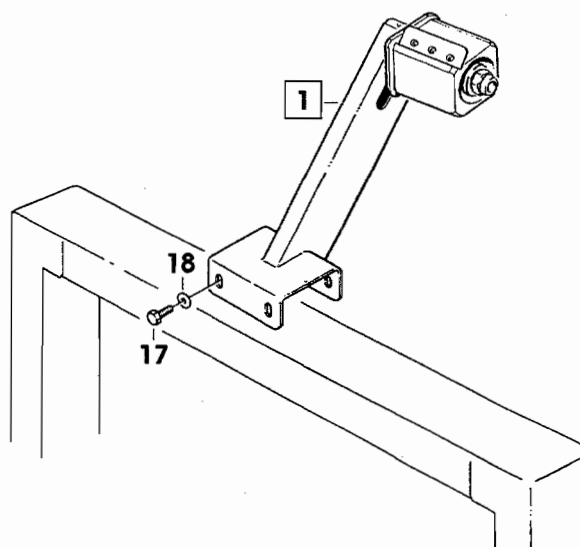
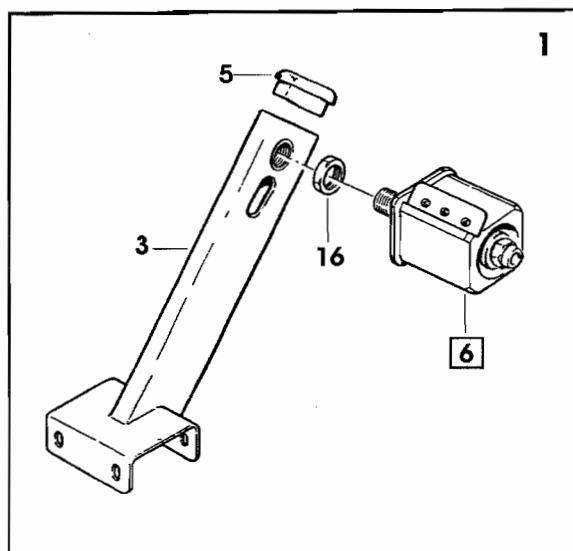


Figure 4046

Figure 4046

Ref. No.	3M Part No.	Description
4046-1	78-8091-0604-6	Bracket Assembly – Core Holder
4046-2	78-8076-4935-1	Tape Drum Bracket Assembly
4046-3	78-8091-0605-3	Bracket – Core Holder
4046-4	78-8070-1395-4	Bracket – Bushing Assembly
4046-5	78-8070-1568-6	Cap – Bracket
4046-6	78-8076-4732-2	Tape Drum Assembly - W/O Bracket/Lock/Plate
4046-7	78-8060-8462-6	Shaft – Tape Drum, 3 Inch Head
4046-8	78-8076-4731-4	Tape Drum Assembly – 3 Inch Wide
4046-9	78-8054-8815-8	Tape Drum Assembly
4046-10	78-8054-8816-6	Leaf Spring
4046-11	26-1002-5753-9	Screw – Self-Tapping
4046-12	78-8060-8172-1	Washer – Friction
4046-13	78-8052-6271-0	Washer – Tape Drum
4046-14	78-8100-1048-4	Spring – Core Holder
4046-15	78-8017-9077-1	Nut – Self-Locking, M10 x 1
4046-16	78-8017-9169-6	Nut – M18 x 1
4046-17	78-8032-0375-7	Screw – Hex Hd, M6 x 16
4046-18	26-1000-0010-3	Washer – Flat, M6
4046-19	78-8010-7169-3	Screw – Hex Hd, M6 x 12
4046-20	78-8052-6566-3	Washer – Friction

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Replacement Parts - Illustrations and Parts Lists

AccuGlide™ II STD 3-Inch, Upper and Lower

Taping Head Assemblies

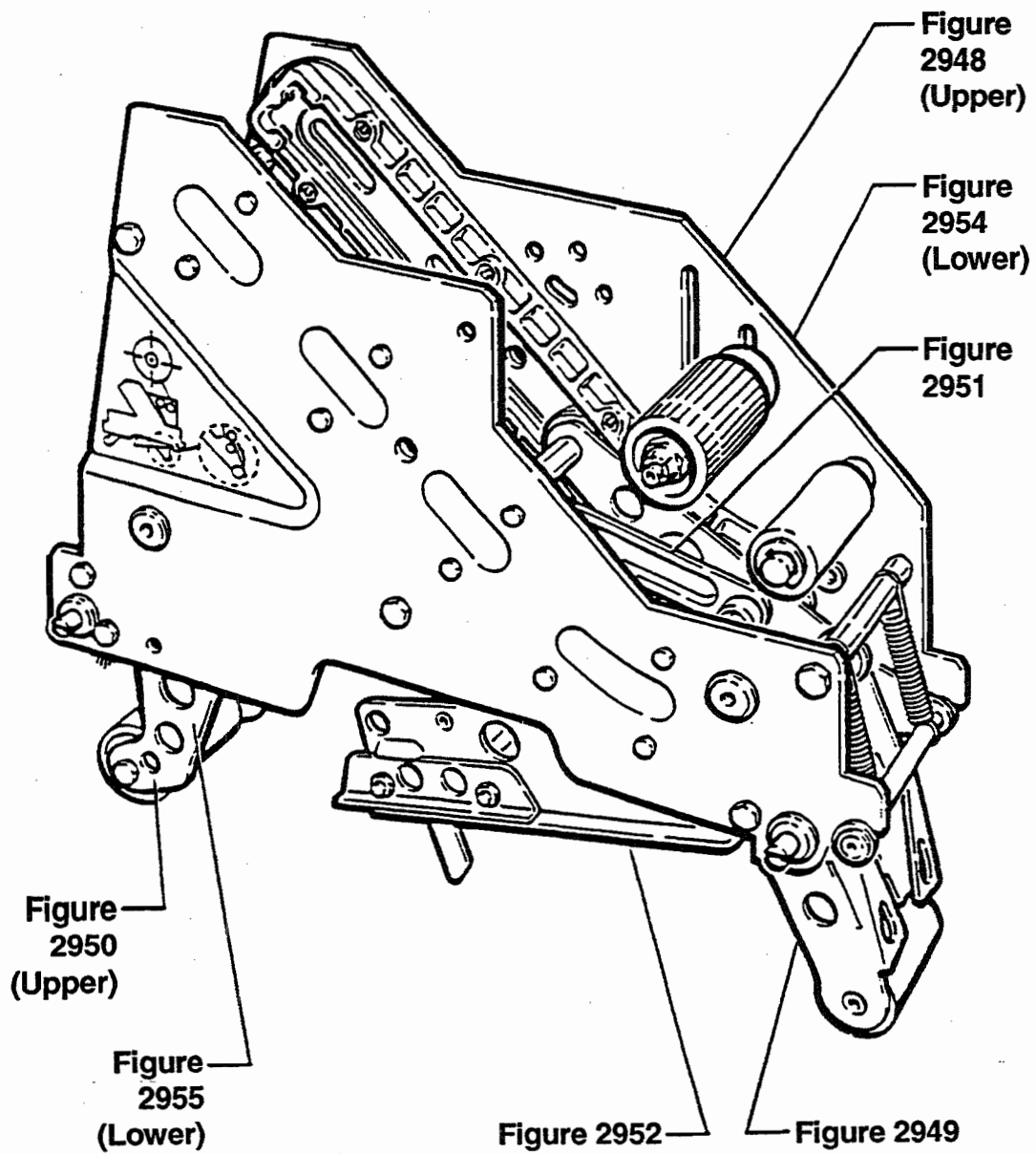
1. Refer to **Taping Head Assemblies Figure** to find all the parts illustrations identified by **figure numbers**.
2. Refer to the **Figure or Figures** to determine the **individual parts** required and the **parts reference number**.
3. The **replacement parts list**, that follows each illustration, 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 49 - "**Replacement Parts and Service Information**" of this manual for replacement parts ordering information.

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Taping Heads - 3 Inch, Upper and Lower



Taping Head - 3 Inch

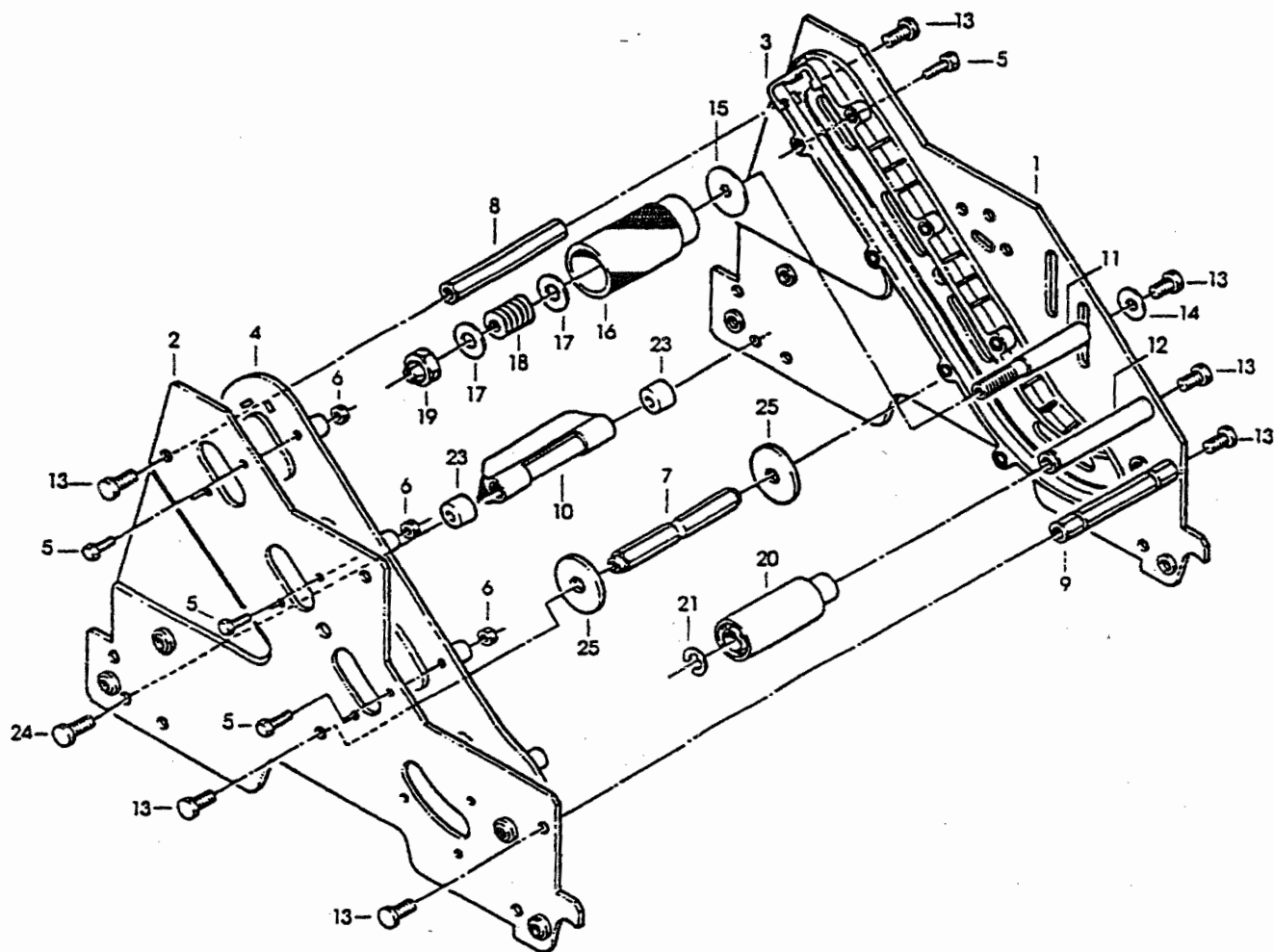


Figure 2948 (Upper)

Figure 2948 (Upper)

Ref. No.	3M Part No.	Description
2948-1	78-8070-1386-3	Frame – Tape Mount Upper Assembly
2948-2	78-8070-1387-1	Frame – Front Upper Assembly
2948-3	78-8068-4143-9	Guide – R/H
2948-4	78-8068-4144-7	Guide – L/H
2948-5	83-0002-7336-3	Screw – Hex Hd, M4 x 14
2948-6	78-8010-7416-8	Nut – Hex M4
2948-7	78-8076-4735-5	Spacer – L=115
2948-8	78-8054-8793-7	Spacer – Hexagonal
2948-9	78-8060-7939-4	Spacer – 10 x 115 W/Slots
2948-10	78-8060-7936-0	Brush Assembly
2948-11	78-8054-8796-0	Shaft – Tension Roller
2948-12	78-8054-8798-6	Shaft – Wrap Roller
2948-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
2948-14	78-8042-2919-9	Washer – Triple, M6
2948-15	78-8070-1268-3	Washer – Roll Back Up
2948-16	78-8054-8797-8	Roller – Top Tension
2948-17	78-8052-6566-3	Washer – Friction
2948-18	78-8052-6567-1	Spring – Compression
2948-19	78-8017-9077-1	Nut – Self Locking, M10 x 1
2948-20	78-8054-8799-4	Roller – Wrap
2948-21	26-1000-1613-3	Ring – Retaining No. 10DIN6799
2948-23	78-8060-7937-8	Spacer – /6,5/14 x 12,5
2948-24	78-8060-7938-6	Screw – Special, M6 x 25
2948-25	78-8076-5242-1	Stop – Cut-Off Frame

Taping Head - 3 Inch

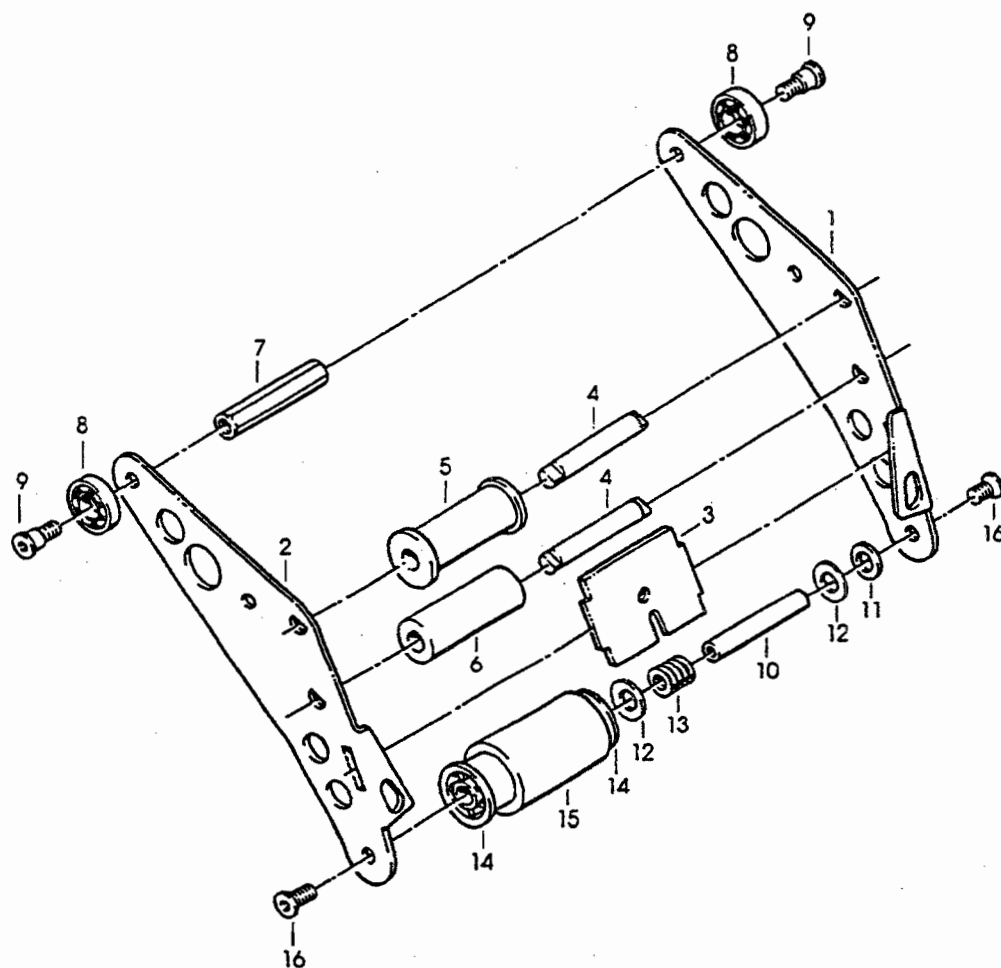


Figure 2949

Figure 2949

Ref. No.	3M Part No.	Description
2949-1	78-8070-1278-2	Applying Arm – Left
2949-2	78-8070-1279-0	Applying Arm – Right
2949-3	78-8070-1292-3	Plate – Back-Up
2949-4	78-8076-4736-3	Shaft – Roller
2949-5	78-8076-4737-1	Roller Assembly – Knurled
2949-6	78-8076-4738-9	Roller – Wrap
2949-7	78-8054-8806-7	Spacer
2949-8	78-8017-9082-1	Bearing – Special, 30 mm
2949-9	78-8017-9106-8	Screw – Bearing Shoulder
2949-10	78-8054-8801-8	Shaft – Roller
2949-11	78-8017-9074-8	Washer – Nylon 15 mm
2949-12	78-8052-6566-3	Washer – Friction
2949-13	78-8052-6567-1	Spring – Compression
2949-14	78-8060-8396-6	Bushing – Applying Roller
2949-15	78-8057-6181-0	Roller – Applying NM
2949-16	26-1005-4759-0	Screw – Flat Hd, M6 x 12

Taping Head – 3 Inch

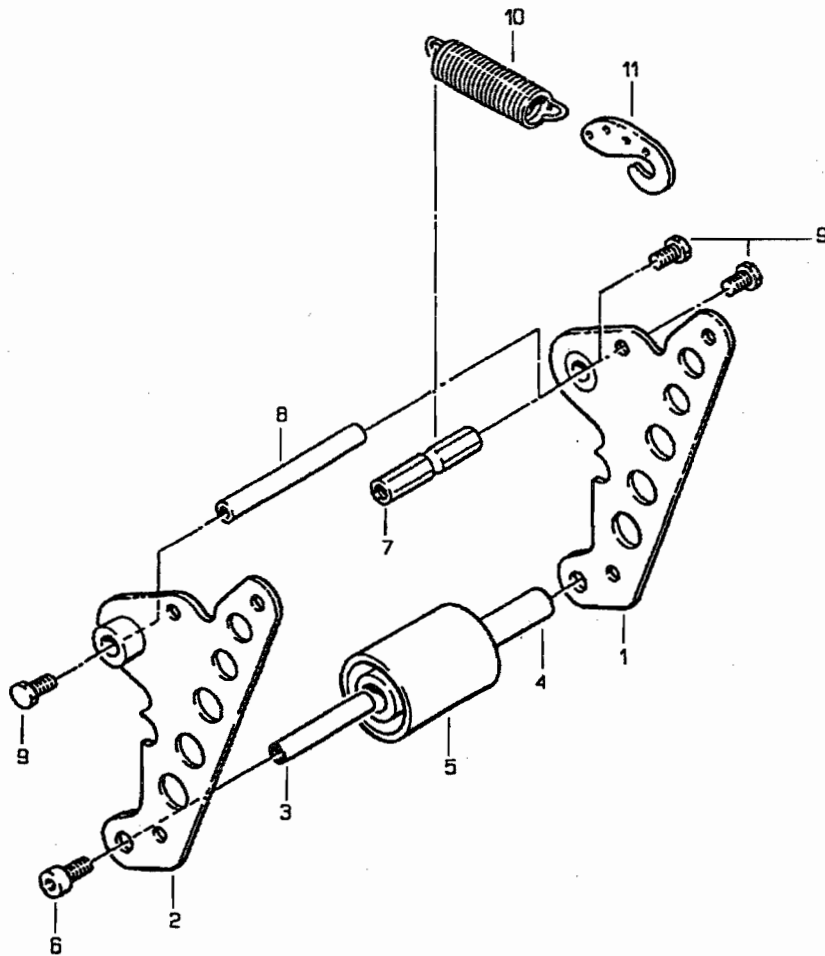


Figure 2950 (Upper)

Figure 2950 (Upper)

Ref. No.	3M Part No.	Description
2950-1	78-8070-1392-1	Buffing Arm – Sub Assembly
2950-2	78-8070-1391-3	Buffing Arm – Sub Assembly
2950-3	78-8054-8801-8	Shaft – Roller
2950-4	78-8054-8807-5	Bushing – Buffing Roller
2950-5	78-8057-6180-2	Roller – Buffing NM
2950-6	78-8076-4503-7	Screw – M6 x 12
2950-7	78-8076-4739-7	Spacer – Spring
2950-8	78-8028-7885-6	Shaft – 10 x 115 mm
2950-9	26-1003-5829-5	Screw – Hex Hd, M6 x 12
2950-10	78-8070-1274-1	Spring – Upper (Silver)
2950-11	78-8070-1244-4	Holder – Spring

Taping Head – 3 Inch

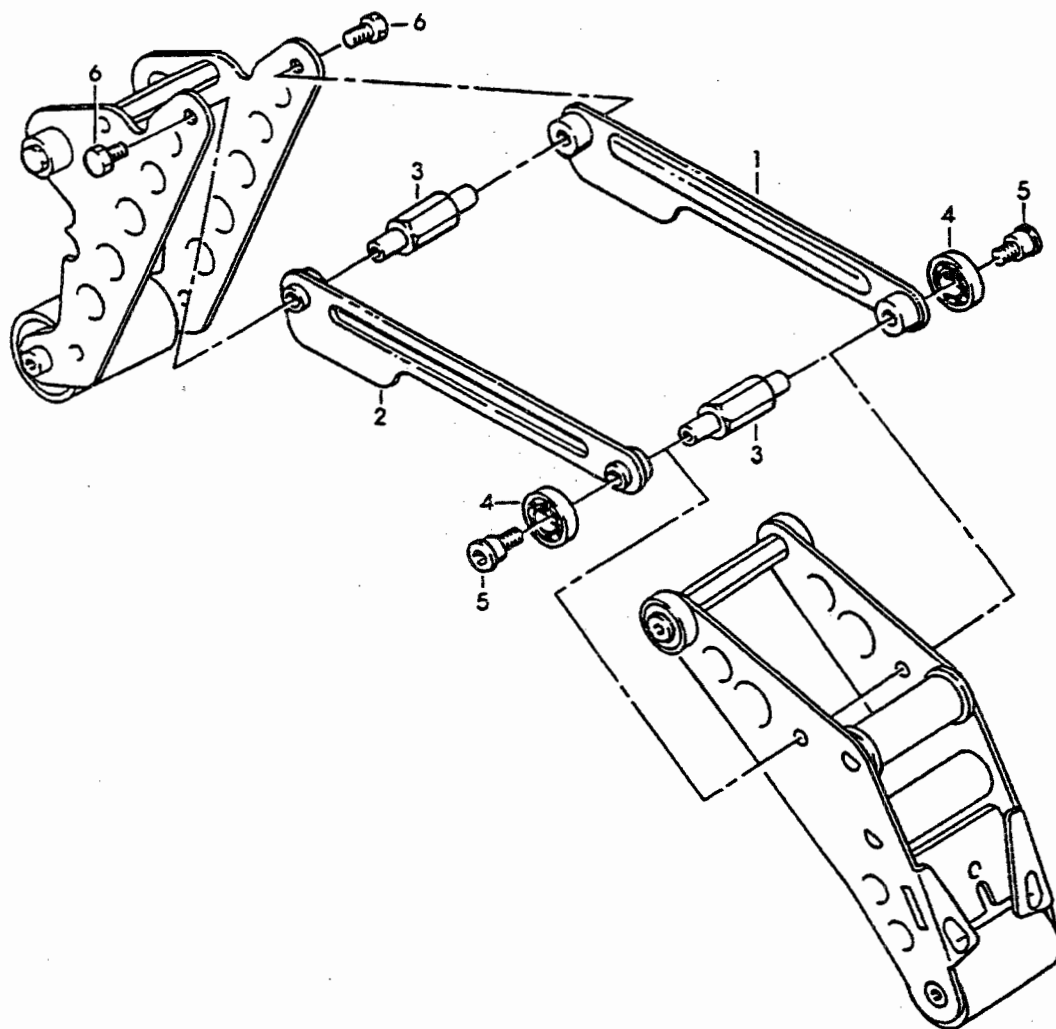


Figure 2951

Figure 2951

Ref. No.	3M Part No.	Description
2951-1	78-8070-1388-9	Link – Arm Bushing Assembly
2951-2	78-8070-1389-7	Link – Arm Bushing Assembly
2951-3	78-8076-4740-5	Shaft – Pivot
2951-4	78-8017-9082-1	Bearing – Special 30 mm
2951-5	78-8017-9106-8	Screw – Bearing Shoulder
2951-6	26-1003-5828-7	Screw – Hex Hd, M6 x 10

Taping Head – 3 Inch

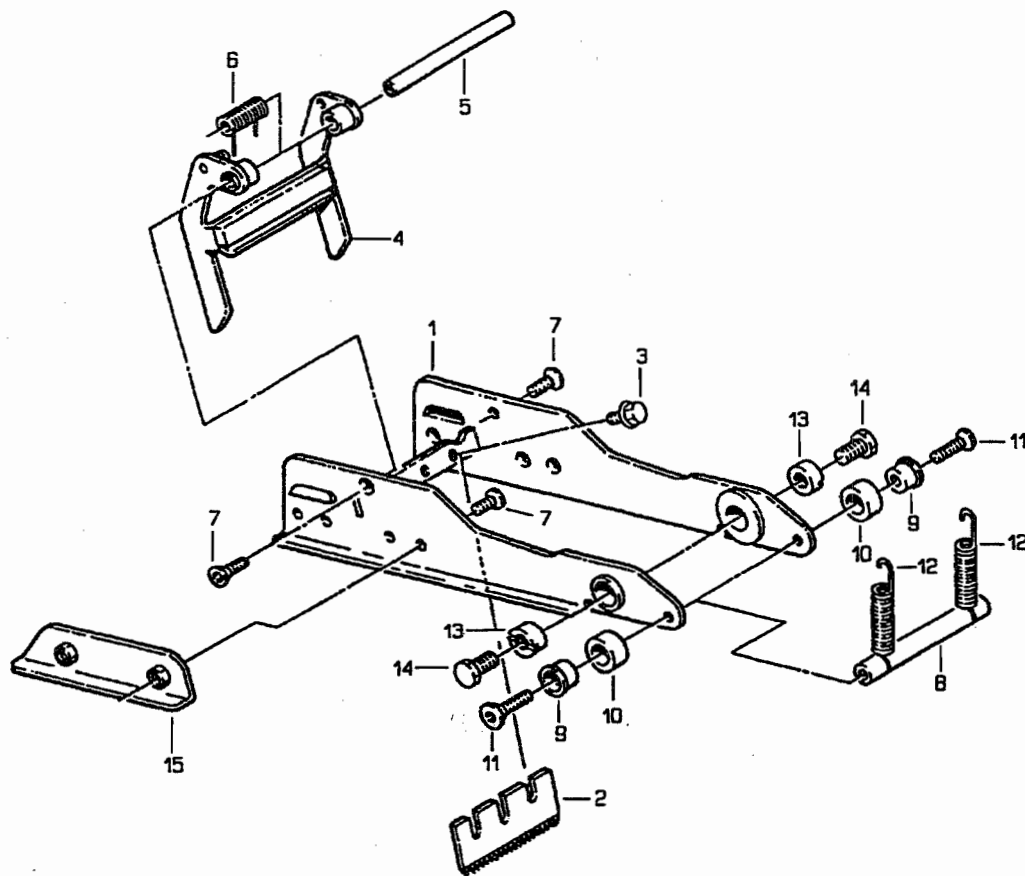


Figure 2952

Figure 2952

Ref. No.	3M Part No.	Description
2952-1	78-8070-1283-2	Frame – Cut-Off
2952-2	78-8028-7899-7	Blade – 3.5 Inch/89 mm
2952-3	26-1003-8596-7	Screw – Hex Hd, M5 x 8 W/Ext
2952-4	78-8076-4741-3	Guard Assembly – Blade
2952-5	78-8054-8813-3	Shaft – Blade Guard
2952-6	78-8070-1390-5	Spring – Tension
2952-7	78-8017-9170-4	Screw – Flat Hd, M4 x 8
2952-8	78-8060-7941-0	Pin – Spring Holder W/Slots
2952-9	78-8052-6600-0	Spacer
2952-10	78-8070-1269-1	Bumper
2952-11	26-1005-4757-4	Screw – Flat Hd, M5 x 20
2952-12	78-8052-6602-6	Spring – Cutter
2952-13	78-8017-9132-4	Pivot – Cutter Lever
2952-14	26-1003-5828-7	Screw – Hex Hd, M6 x 10
2952-15	78-8070-1216-2	Slide – Extension

Taping Head - 3 Inch

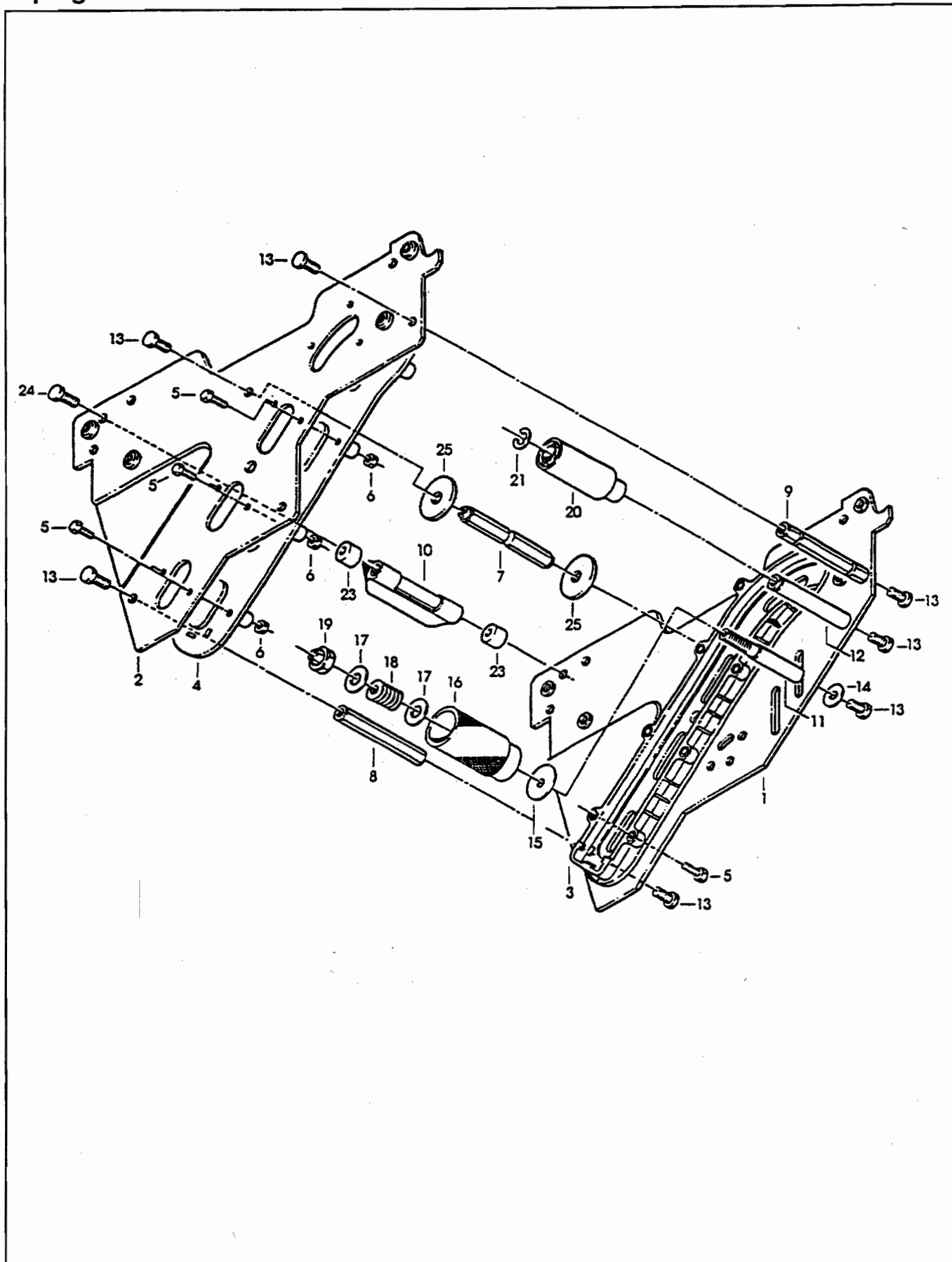


Figure 2954 (Lower)

Figure 2954 (Lower)

Ref. No.	3M Part No.	Description
2954-1	78-8070-1369-9	Frame – Tape Mount Lower Assembly
2954-2	78-8070-1370-7	Frame – Front Lower Assembly
2954-3	78-8068-4143-9	Guide – R/H
2954-4	78-8068-4144-7	Guide – L/H
2954-5	83-0002-7336-3	Screw – Hex Hd, M4 x 14
2954-6	78-8010-7416-8	Nut – Hex M4
2954-7	78-8076-4735-5	Spacer – L=115
2954-8	78-8054-8793-7	Spacer – Hexagonal
2954-9	78-8060-7939-4	Spacer – 10 x 115 W/Slots
2954-10	78-8060-7936-0	Brush Assembly
2954-11	78-8054-8796-0	Shaft – Tension Roller
2954-12	78-8054-8798-6	Shaft – Wrap Roller
2954-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
2954-14	78-8042-2919-9	Washer – Triple M6
2954-15	78-8070-1268-3	Washer – Roll Back-Up
2954-16	78-8054-8817-4	Roller – Tension Bottom
2954-17	78-8052-6566-3	Washer – Friction
2954-18	78-8052-6567-1	Spring – Compression
2954-19	78-8017-9077-1	Nut – Self Locking M10 x 1
2954-20	78-8054-8799-4	Roller – Wrap
2954-21	26-1000-1613-3	Ring – Retaining 1DIN6799
2954-23	78-8060-7937-8	Spacer – /6,5 x 14 x 12,5
2954-24	78-8060-7938-6	Screw – Special, M6 x 25
2954-25	78-8076-5242-1	Stop – Cut-Off Frame

Taping Head – 3 Inch

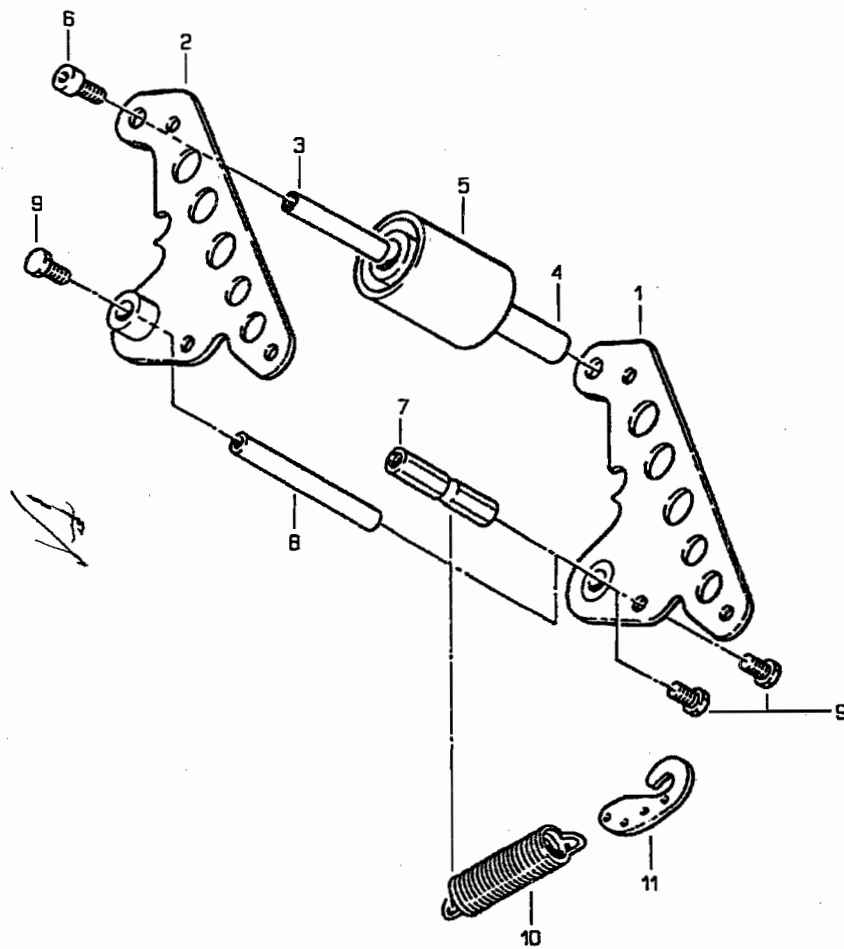


Figure 2955 (Lower)

Figure 2955 (Lower)

Ref. No.	3M Part No.	Description
2955-1	78-8070-1391-3	Buffing Arm Sub Assembly
2955-2	78-8070-1392-1	Buffing Arm Sub Assembly
2955-3	78-8054-8801-8	Shaft – Roller
2955-4	78-8054-8807-5	Bushing – Buffing Roller
2955-5	78-8057-6180-2	Roller – Buffing NM
2955-6	78-8076-4503-7	Screw – M6 x 12
2955-7	78-8076-4739-7	Spacer – Spring
2955-8	78-8028-7885-6	Shaft – 10 x 115 mm
2955-9	26-1003-5829-5	Screw – Hex Hd, M6 x 12
2955-10	78-8070-1273-3	Spring – Lower (Black)
2955-11	78-8070-1244-4	Holder – Spring

3M Parts Order Form

Form 26989 - 3 - D

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

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

– Shaded Areas To Be Filled In By 3M –

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

Ship To

Charge To

FAX Your Order For Faster Service FAX No. 715-268-8153

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

Please Print

\$25.00 Minimum Order <input type="checkbox"/> Ship Via Air At Customer Expense		Signature
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