Instructions and Parts List

3M-Matic™

77A-KS

Model 18600

Adjustable Case Sealer

with

AccuGlide™

Taping Heads

Model 18600

It is recommended you immediately order the spare parts listed on page 19. These parts are expected to wear through normal use and should be kept on hand to minimize production delays.
Service Instructions

To Our Customers:

This is the "3M-Matic"/"AccuGlide"/"Scotch"/"Opta-Pak" 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 the 3M National Service Center on 1-800/328 1390 (Twin Cities Metro Area call 731 6507). Please provide the customer support coordinator with the machine number and serial number. If you have a technical question that does not require an immediate response, you may Fax it to 612/731 6650.

Replacement Parts

Order parts by part number, part name, quantity required, machine name, number and type number.

Replacement parts and parts prices available from:

Dispenser Parts
Route 4, Box 5B
Amery, WI 54001
715/268 8126 (WI)
800/344 9833 (Outside WI)
FAX# 715/268 8153
# Instruction Manual
## 77A-KS Adjustable Case Sealer
### Model 18600

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Equipment Warranty and Limited Remedy: THE FOLLOWING WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OF 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™ 77A-KS Adjustable Case Sealer, Model 18600 with the following warranties:

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

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

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

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

"AccuGlide", "Scotch", and "3M-Matic" are Trademarks of 3M, St. Paul, Minnesota 55144-1000
"3M-Matic" 77A-KS Adjustable Case Sealer - Model 18600

Description

The "3M-Matic" 77A-KS Adjustable Case Sealer with "AccuGlide" 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 77A-KS is manually adjustable to a wide range of box sizes (see box size specifications).
Receiving And Handling

After the machine has been uncrated, examine the 77A-KS Case Sealer for damage that might have occurred during transit. If damage is evident, file a damage claim immediately with the transportation company and also your 3M Representative. Several machine components are tied down to prevent damage during transit. Remove these before proceeding with following set-up instructions.

Specifications

1. Power Requirements:

   Electrical - 115 VAC, 60 Hz, 5.6 A
   The machine is equipped with a standard neoprene covered power cord and a grounded plug. Contact your 3M Representative for power requirements not listed above.


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<table>
<thead>
<tr>
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<tbody>
<tr>
<td>Length</td>
<td>42 1/2 inches [1,080 m]</td>
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<tr>
<td>Width</td>
<td>34 1/2 inches [0,875 m]</td>
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<tr>
<td>Height</td>
<td>70 inches [1,780 m]</td>
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<tr>
<td>Conveyor Bed Height</td>
<td>Adjustable up from factory set height of 20 1/2 inches [520 mm]</td>
</tr>
<tr>
<td>Weight</td>
<td>400 pounds [180 kg] crated</td>
</tr>
<tr>
<td></td>
<td>350 pounds [160 kg] uncrated</td>
</tr>
</tbody>
</table>

(Specifications continued on next page.)
Specifications (Continued)

3. Operating Rate:

4. 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.

5. Tape:

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

6. Tape Width:

2 inches or 50 mm minimum to 3 inches or 72 mm maximum.

7. Tape Roll Diameter:

Up to 15-1/2 inches [395 mm] maximum on a 3 inch [76,2 mm] diameter core. (Accommodates all system roll lengths "Scotch" brand film tapes.)

8. Tape Application Leg Length:

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

(Specifications continued on next page.)
Specifications (Continued)

9. Box Board:

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

10. Box Weight and Size Capacities

A. Box weight, filled – 5 lbs. [2.3 kg] minimum, 80 lbs. [37 kg] maximum

B. Box size: Minimum Maximum

<table>
<thead>
<tr>
<th>Length</th>
<th>6.0 inches or 150 mm</th>
<th>unlimited</th>
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<tbody>
<tr>
<td>Width</td>
<td>* 7.0 inches or 175 mm</td>
<td>26 inches or 660 mm</td>
</tr>
<tr>
<td>Height</td>
<td>4 3/4 inches or 120 mm</td>
<td>** 36 inches or 915 mm</td>
</tr>
</tbody>
</table>

* Cartons smaller than 8 inches or 200 mm in width may require more frequent belt replacement because of limited contact area.

** Some set up required. See page 10.

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

Note: The 77A-KS 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, several boxes should be test run to assure proper machine performance.

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

\[
\frac{\text{BOX LENGTH IN DIRECTION OF SEAL}}{\text{BOX HEIGHT}} \text{ SHOULD BE GREATER THAN .5}
\]

Any box ratio approaching this limitation should be test run to assure performance.
Set-Up Procedure

It is recommended that the 77A-KS 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 77A-KS before subjecting it and operating personnel to a production situation where time for set-up, adjustments, and operator training usually becomes limited.

Figure 1 - Set-Up Instructions - Case Sealer Components - Left Front View
Set-Up Procedure (Continued)

The following instructions are presented in the order recommended for setting up and installing the 77A-KS Case Sealer, as well as for learning the operating functions and adjustments. Following them step by step will result in your thorough understanding of the machine and an installation in your production line that best utilizes the many features built into the 77A-KS Case Sealer.

Conveyor Bed Height:

The 77A-KS Case Sealer is equipped with four adjustable legs that are located at the corners of the frame. The legs can be adjusted to obtain different machine conveyor bed heights from 20 1/2 inches [520 mm] minimum to 31 1/2 inches [800 mm] maximum.

The recommended minimum machine conveyor bed height (measured from floor) is 24 inches [610 mm].

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

1. Block up the machine frame to allow adequate leg adjustment.

2. Loosen, but do not remove, two M8 x 16 mm socket head screws in one leg. Adjust the leg length for the desired conveyor bed height. Retighten the two screws to secure the leg. Adjust all four legs as noted.

The tape drum bracket assembly, located on the bottom taping head, has two mounting positions to allow maximum tape roll capacity through the machine conveyor bed height range.

For conveyor bed heights 24 inches and above, use mounting position shown in Figure 2B.

For conveyor bed heights below 24 inches, use mounting position shown in Figure 2C.

![Figure 2 - Conveyor Bed Height Adjustment](image-url)
Set-Up Procedure (Continued)

Electrical Connection

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

Note: Machines outside the U.S. may be equipped with 220/440 Volt, 50 Hz systems, or other electrical requirements compatible with local practice.

IMPORTANT SAFEGUARDS

1. BOTH THE TOP AND BOTTOM TAPING HEADS UTILIZE EXTREMELY SHARP KNIFE BLADES ON THE ORANGE CUTTER LEVER ASSEMBLY AND WHICH ARE LOCATED UNDER THE BLADE GUARD WHICH HAS THE "WARNING - SHARP KNIFE" LABEL. BEFORE WORKING WITH THE TAPING HEADS OR ATTEMPTING TO LOAD THE TAPE, REFER TO FIGURES 3 AND 3A AND IDENTIFY THE BLADE LOCATION. KEEP HANDS OUT OF THESE AREAS EXCEPT AS NECESSARY TO SERVICE THE TAPING HEADS.

2. NEVER ATTEMPT TO WORK ON THE TAPING HEADS OR LOAD TAPE WHEN THE BOX DRIVE BELTS ARE RUNNING.

3. BOX DRIVE MOTORS ARE DESIGNED TO RUN AT A MODERATE TEMPERATURE OF 105° F [40° C]. IN SOME CASES THEY MAY FEEL WARM TO THE TOUCH.

Tape Loading

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" Section for set-up information.

Two temporary threading needles are shipped in threaded position for initial tape loading convenience. Retain these for continued use in the tape loading operation. For operator assistance, a threading diagram has been applied to the taping heads. 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. The bottom taping head can be removed from unit by lifting out for convenience in tape loading.

Tape Loading - Top Taping Head

WARNING - NEVER ATTEMPT TO WORK ON THE TAPING HEADS OR LOAD TAPE WHEN THE BOX DRIVE BELTS ARE RUNNING. PERSONNEL INJURY OR EQUIPMENT DAMAGE CAN POTENTIALLY RESULT.

1. It is first necessary to raise the top taping head. Utilize the height adjustment crank and move the top taping head to the fully raised position.

2. With the temporary threading needle already in position, as shown in Figure 3, follow the tape loading procedure from Figure 3C to complete the tape threading.
Figure 3 - Tape Threading Diagram - Top Taping Head - Left Side View

Figure 3A - Tape Threading Diagram - Bottom Taping Head - Left Side View
Set-Up Procedure (Continued)

3. For subsequent tape loading operations, use the red plastic threading needle and follow the loading procedures from Figure 3B to complete the tape threading.

Tape Loading – Bottom Taping Head
Refer to Figure 3A

The bottom taping head is loaded and threaded in the same manner as the top taping head. For ease in loading, first remove the bottom taping head from the conveyor bed and follow the top taping head tape loading procedure.

Figure 3B

Insert the red plastic needle downward around rollers as illustrated.

Figures 3B and 3C

Place tape roll on drum to dispense tape from bottom of roll toward tension wrap roller with tape adhesive side in. Seat tape roll fully against back flange of drum. Adhere tape lead end to upper end of threading needle as shown.

Figure 3D

! 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 or knife at applying roller.
Set-Up Procedure (Continued)

Box Size Set-Up and Operation

The 77A-KS Case Sealer has been pre-assembled, for shipping purposes, to accommodate a box height up to 25 1/2 inches or 650 mm (4 3/4 inches or 120 mm minimum). Box heights up to 32 inches or 815 mm (11 1/4 inches or 285 mm minimum) are obtained by raising the top taping head frame. In addition, the maximum box height of 36 inches or 915 mm (15 1/4 inches or 390 mm minimum) is obtained by also raising the top taping head frame columns. Determine the box height needed and follow the procedures as noted below.

⚠️ WARNING — IT IS RECOMMENDED THAT NO LESS THAN TWO PEOPLE ASSIST ON THESE SET-UPS OR SEVERE INJURY OR EQUIPMENT DAMAGE COULD RESULT.

To Raise Top Taping Head Frame — Refer to Figure 4

Place a box or blocks under the top taping head to provide adequate support. Use the height adjustment crank to lower taping head until its full weight is supported. Remove and retain the four screws on both sides of the head frame. Mount the frame support to the upper set of holes in the inner column, as shown, and secure with the four screws on each side of the frame.

To Raise Top Taping Head Frame Columns—Refer to Figure 5.

Use the height adjustment crank to fully raise top taping head. Place boxes or blocks under the taping head to provide adequate support. Remove and retain the four column screws on both sides of the bed frame. Raise the column to the upper position, as shown, and secure with the four screws on each side of the bed frame.
Set-Up Procedure (Continued)

Figure 6

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

Figure 7

Place box on infeed conveyor with both top and bottom flaps folded and insert under top head skis approximately 2 inches or 50 mm. Lower top head until all flaps are fully closed. Align box top flap center seam with groove in top head front roller.

Figure 8

Move side guides against each side of box to hold box in position, centered on groove in roller. Tighten hand knobs to secure side guides.
Set-Up Procedure (Continued)

Figure 9

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

Note: Top head has unique feature for overstuffed boxes. Top head will raise automatically for this type of condition.

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

Figure 10

Adjust Top Flap Compression rollers against top edge of box and tighten knobs to secure rollers in operating position.
Adjustments

Tape Drum Assembly - Friction Brake

The tape drum assembly provides adjustable friction brake to prevent tape roll over travel.

The friction brake is pre-set for normal operation. If it should be necessary to change the braking force, adjust the knurled nut shown in Figure 11A. Clockwise to increase braking force, counterclockwise to decrease braking force.

Tape Web Alignment—
Refer to Figure 11A

The tape drum assembly on each taping head is pre-set to accommodate 2 inch [50 mm] wide tape. The tape drum assembly provides adjustment to align other tape widths on the centerline of the taping head, (and therefore box center seam). Make adjustment as follows:

1. Loosen hand knob behind tape drum.
2. Turn tape drum shaft in or out to center the tape web.
3. Tighten hand knob to secure the adjustment.

3 Inch or 72 mm Wide Tape
(Upper Taping Head)
Refer to Figure 11B

(Lower Taping Head)
Refer to Figure 11C

1. Remove and retain three screws and washers that hold tape drum bracket to taping head frame.
2. Rotate bracket 180° as shown and mount to frame with existing fasteners.
3. Remove and reassemble tape drum assembly to bracket as shown.
4. Make alignment adjustment as noted above.
Adjustments (Continued)

Applying Mechanism Spring

The applying mechanism spring, shown in Figures 3 and 3A, controls applying and buffing roller pressure on the box and returns the mechanism to the reset position. The spring pressure is pre-set, as shown in Figure 12, 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 13, will decrease the spring pressure.

One Way Tension Roller Assembly

The one way tension roller, is factory set. When replacing this assembly, the roller must have 1 lb. [0.5 kg] tangential force when turning. See Figure 14.

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 lb. [0.5 kg] is required to turn the roller by pulling on the spring scale.
Adjustments (Continued)

Box Drive Belts

The four continuously moving box drive belts convey boxes through the tape applying mechanism. The box drive belts are powered by the electric motor through a transmission.

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

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

Box Drive Belts - Bottom Taping Head

Refer to Figure 15

Step 1. Remove and retain center plates and 4 screws.

Step 2. Remove and retain eight M6 x 12 mm socket head screws to remove conveyor tops from housing.

Belt tension is obtained by uniform tightening of the adjustment screws so that a moderate pulling force of 7 lbs. [3.5 kg] applied at the midspan, as shown in Figure 16, will deflect the belt 1 inch [25 mm].

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

Refer to Figure 17

Step 3. Loosen, but do not remove, lock nut M20 x 16 with socket wrench provided.

Step 4. Reset the tension on the drive belt as needed. Adjust the M8 x 40 mm hex head screws, (out to increase - in to decrease). Tighten lock nut to secure tension setting.

Step 5. Reverse procedure in steps 1 and 2 above to reassemble the unit.
Adjustments (Continued)

Figure 15 - Box Drive Belt Adjustment - Frame Bed Infeed End

Figure 16 - Box Drive Belt Tension Adjustment - Left Side View

Figure 17 - Tension Adjustment - Left Side View
Maintenance

The 77A-KS Case Sealer has been designed for long, trouble free service. The machine will perform best when it receives routine maintenance and cleaning. Machine components that fail or wear excessively should be promptly repaired or replaced to prevent damage to other portions of the machine or to the product.

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

Blade Replacement:

Refer to Parts Illustrations, yellow pages, Figure 1332.

1. Loosen, but do not remove, the blade screws (13) holding the blade. Remove the old blade.

2. Position the new blade with the beveled side toward the blade holder. Tighten the blade screws to secure the blade.

The same steps are followed on the Top and Bottom Taping Heads. Connect the main power supply.

Replacements Box Drive Belts

1. Top taping head must be removed to replace top box drive belts.

2. Remove top taping head from frame assembly. Remove top flap compression rollers and loosen four mounting screws.

   Note: Make sure taping head has adequate support before screws are removed.

3. Install new belts and adjust belt tension as noted in Step 4 under adjustments.

4. DO NOT REMOVE BOTTOM TAPING HEAD.
   Install new belts and adjust belt tension as noted in Step 4 under adjustments.
Cleaning Of The Machine

CAUTION – NEVER ATTEMPT TO REMOVE DIRT BY BLOWING IT OUT WITH COMPRESSED AIR. THIS CAN CAUSE THE DIRT TO BE BLOWN INSIDE THE MOTOR, AND SLIDING SURFACES. Gritty dirt in these areas can cause serious equipment damage. NEVER WASH DOWN OR SUBJECT EQUIPMENT TO CONDITIONS CAUSING MOISTURE CONDENSATION ON COMPONENTS. SERIOUS EQUIPMENT DAMAGE COULD RESULT.

Regular slotted containers produce a great deal of dust and paper chips when processed or handled in equipment. If this dust is allowed to build up on machine components, it can cause component wear and overheating of drive motor. The dust build up can best be removed from the machine by a shop vacuum. Depending on the number and type of boxes sealed in the 77A-KS Case Sealer, this cleaning should be done approximately once per month. If the boxes sealed are dirty, or if the environment in which the machine operates is dusty, cleaning on a more frequent basis may be necessary. Excessive dirt build up that cannot be removed by vacuuming should be wiped off with a damp cloth.

Cut-Off Blade:

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

Electrical Schematic

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

Figure 18 illustrates the electrical system of the 77A-KS Case Sealer. No adjustments to the electrical systems are required.

Circuit Breaker

The 77A-KS Case Sealer is equipped with a circuit breaker which trips the "On-Off" switch to tripped position. If circuit is overloaded and circuit breaker trips, wait 2 minutes, move to "Off", then turn "On". Located inside the electrical control box on the side of the main frame just below the conveyor bed, the circuit breaker has been pre-set and requires no further maintenance.
Maintenance (Continued)

Lubrication – Mechanical

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

Figure 19 and 20 illustrate the taping head and frame points which should be lubricated every 3 months or 150,000 machine cycles, which ever comes first. The oil can supplied with the Case Sealer can be utilized to 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.

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

Blade Oiler Pad

The taping heads are equipped with a 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. Do not saturate.
Replacement Parts And Service Information

Spare Parts

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

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<td>Blade - 3.50 inch/89 mm</td>
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<td>78-8052-6722-2</td>
<td>Belt - Drive</td>
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</table>

Tool Kit

A tool kit, P/N 78-8054-8732-5, is available as a stock item. The kit contains the necessary wrenches and an oil can. The threading tool, Part No. 78-8017-9433-6, contained in above kit is also available as a replacement stock item. Refer to "How To Order Replacement Parts" for ordering information.

How To Order Replacement Parts

1. Order parts by part number, part name, machine catalog number, model number and part quantity required.

   Minimum billing on parts orders will be $10.00.
   Replacement part prices available on request.

2. Replacement parts and part prices available direct from:

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

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

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

Additional information on the attachments listed below is included with the manual except where noted:

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Attachment Name</th>
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<tbody>
<tr>
<td>78-8052-6553-1</td>
<td>Box Hold Down Attachment, Model 18500</td>
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<tr>
<td>78-8052-6554-9</td>
<td>Caster Kit Attachment, Model 18500</td>
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<tr>
<td>78-8055-0951-6</td>
<td>Conveyor Extension Attachment, Model 18600</td>
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77A-KS Case Sealer, Model 18600
Replacement Parts Illustrations and Parts Lists
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 20 - "Replacement Parts and Service Information" of this manual for replacement parts ordering information.
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<thead>
<tr>
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<th>3M Part No.</th>
<th>Description</th>
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<td>Washer - Friction</td>
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<td>78-8017-9077-1</td>
<td>Nut - Self Locking, Hex M10 x 1</td>
</tr>
<tr>
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<td>Spring - Compression</td>
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<td>Shaft - Wrap Roller</td>
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<td>26-1000-1613-3</td>
<td>Ring - Retaining</td>
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<td>Spacer /6,5/14 x 12,5</td>
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<td>Screw - M6 x 25, Special</td>
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<td>Brush Assembly</td>
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Figure 1335 (Bottom)
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1. Refer to Frame Assemblies figure to find all parts illustrations identified by figure numbers.

2. Refer to the figure or figures to determine the individual parts required and the parts reference number.

3. The replacement parts list, that follows each illustration, includes the part number and part description for the parts in the illustration.

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

4. Refer to page 20 - "Replacement Parts and Service Information" of this manual for replacement parts ordering information.
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<td>Screw - Hex Hd. M6 x 16 Metric</td>
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### Figure 1448

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### Figure 1449

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