

3M-Matic™

800a Type 19200

800a3 Type 19200

800ab Type 19200

Adjustable Case Sealer

with

AccuGlide™ 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 38. These parts are expected to wear through normal use and should be kept on hand to minimize production delays.

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44-0009-1805-0(F125.020)

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3M Masking and Packaging Systems Division

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

3M

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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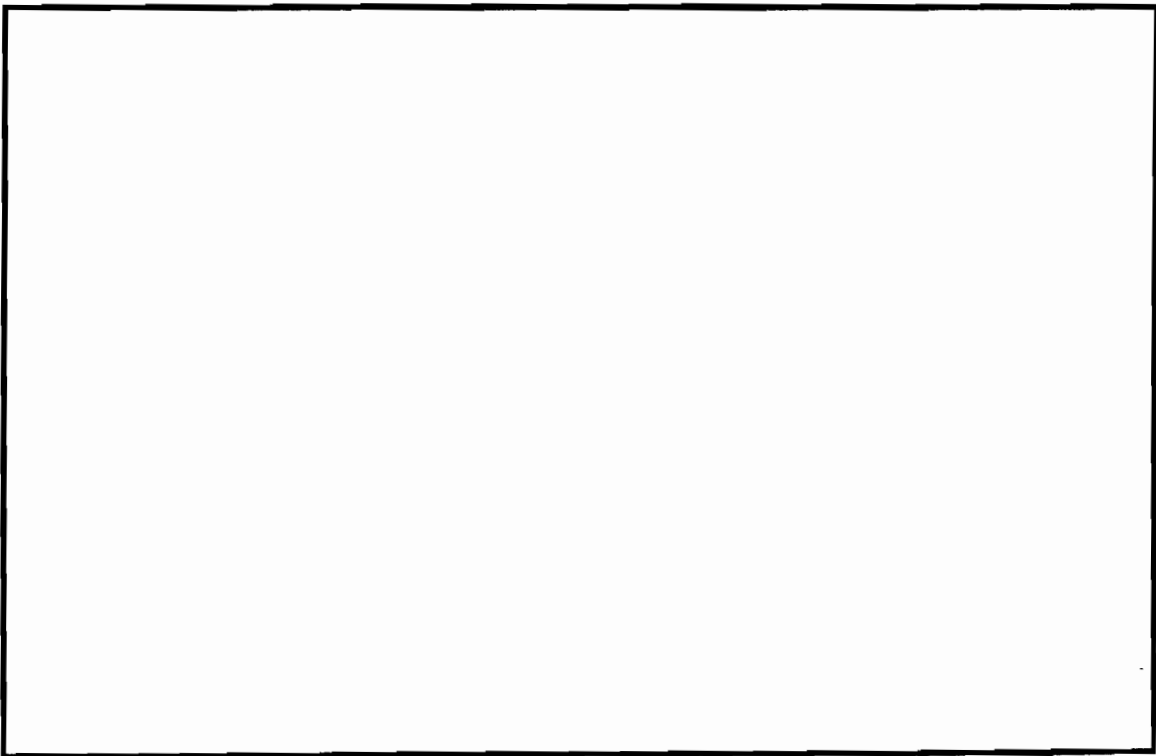
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To Our Customers:

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

800a , Type 19200
800a3, Type 19200
800ab, Type 19200
Adjustable Case Sealers

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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™ 800a/800a3/800ab Adjustable Case Sealers, Type 19200 with the following warranties:

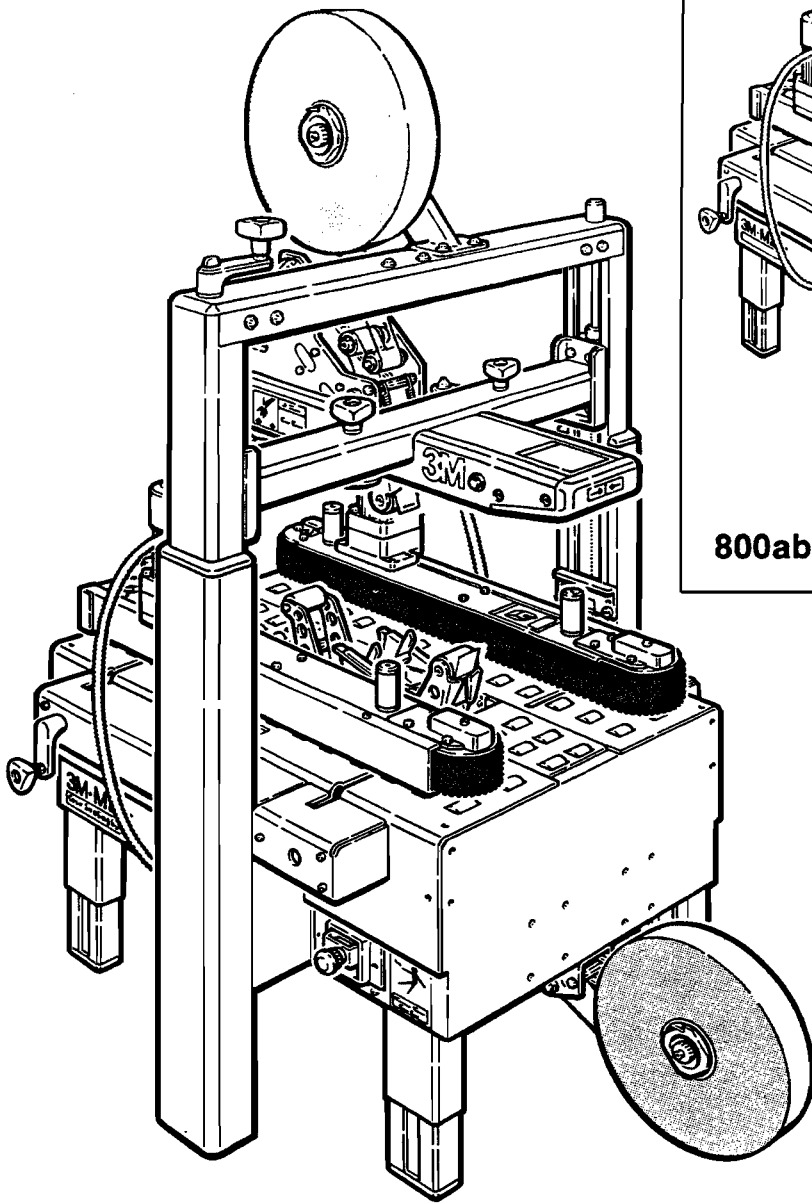
1. The Taping Head knife blades, springs and rollers will be free from all defects for ninety (90) days after delivery.
2. All other Taping Head parts will be free from all defects for three (3) years after delivery.
3. The gearmotor will be free from all defects for one (1) year after delivery.
4. All 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.

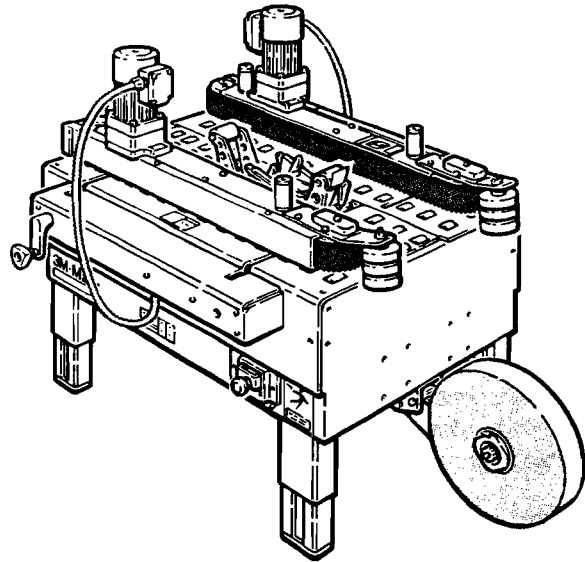
Limitation of Liability: 3M and seller shall not be liable for direct, indirect, special, incidental or consequential damages based upon breach of warranty, breach of contract, negligence, strict liability or any other legal theory.

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.

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800a/800a3 (800a Shown)



800ab

3M-Matic™ 800a Adjustable Case Sealer, Type 19200

3M-Matic™ 800a3 Adjustable Case Sealer, Type 19200

3M-Matic™ 800ab Adjustable Case Sealer, Type 19200 (Inset)

Description

The 3M-Matic™ 800a Series Adjustable Case Sealers with AccuGlide™ II Taping Heads are designed to apply a "C" clip of Scotch™ brand pressure-sensitive film box sealing tape to the top and bottom (800ab - bottom only) center seam of regular slotted containers. The case sealers are manually adjustable to a wide range of box sizes (see box size specifications).

Important Safeguards

IN THE EVENT THESE SAFETY LABELS SHOWN ON PAGES 2-5 ARE DAMAGED OR DESTROYED, REPLACEMENTS ARE AVAILABLE. SEE PAGE 37.

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 frame at the location of the cut-off blade on the upper taping head. The labels warn operators and service personnel of the very sharp knife used to cut the tape at the end of the tape application.

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

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

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

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

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

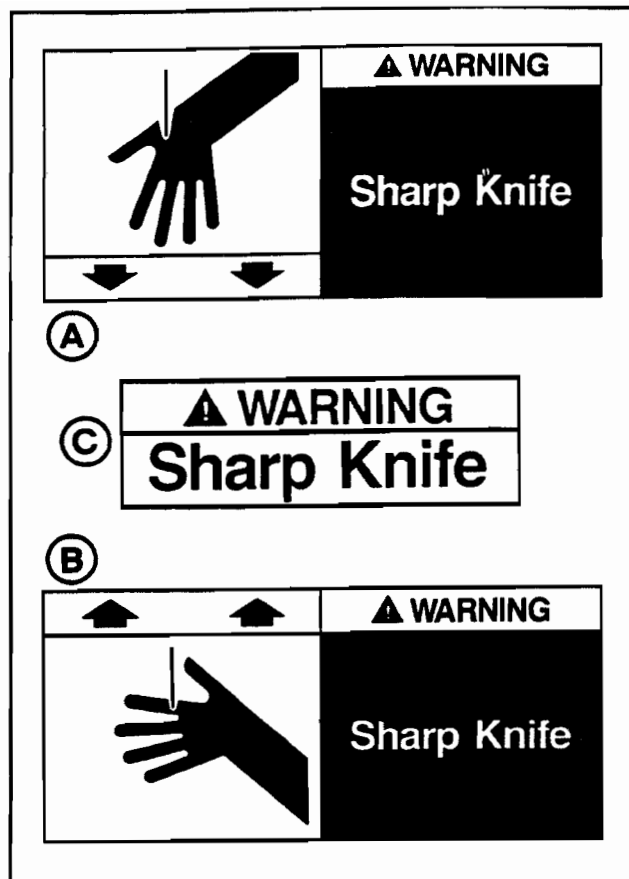


Figure 1-1 Knife Warning Label



Figure 1-2 Electrical Warning Label

Important Safeguards (Continued)

The "Caution - Keep Hands Out Of This Area" label, shown in **Figure 1-3**, is attached to the rear of the upper frame. It warns the operator to keep hands out of this area when the upper taping head mechanism is in operation.



Figure 1-3 Hands Caution Label

The "Safety Instructions" label, shown in **Figure 1-4**, is attached to the front of the upper frame. The label provides convenient safeguard instructions for the operator and service personnel.

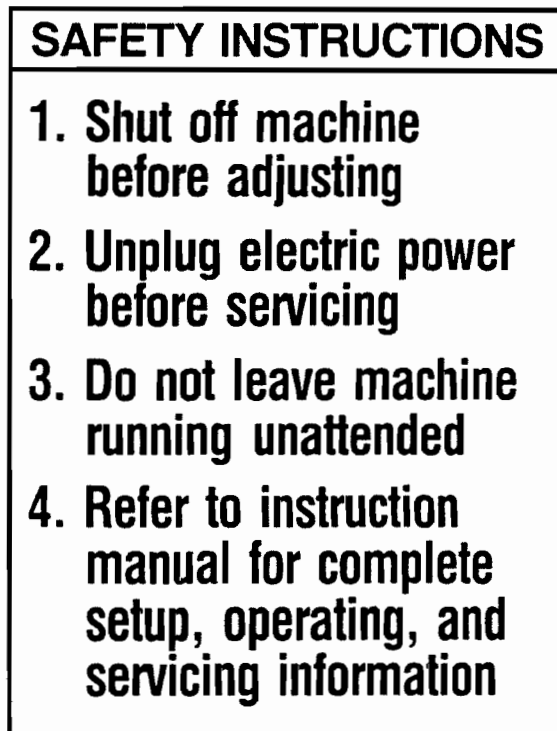


Figure 1-4 Safety Instructions Label

Important Safeguards (Continued)

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

The two **"Warning - Keep Away From Moving Belts"** labels, as shown in Figure 1-5, are located on the right and left side panel of the conveyor bed. The labels warn operators and service personnel to keep hands away from this area when the drive belts are running.

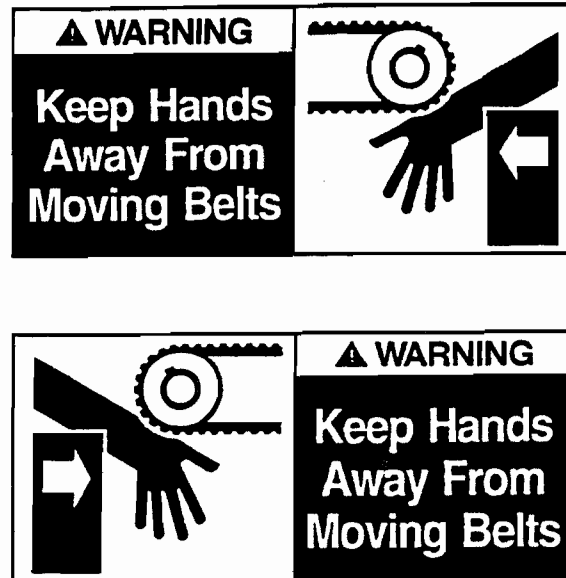


Figure 1-5 Hands Warning Label

The **"Center Box Here"** label, shown in Figure 1-6, is attached to the front of the upper frame to remind the operator of the proper box placement procedure.



Figure 1-6 Center Box Label

Important Safeguards (Continued)

The "Operating Notice" label, shown in Figure 1-7, is located on the top of the drive belt assemblies to remind operators on belt adjustment procedures.

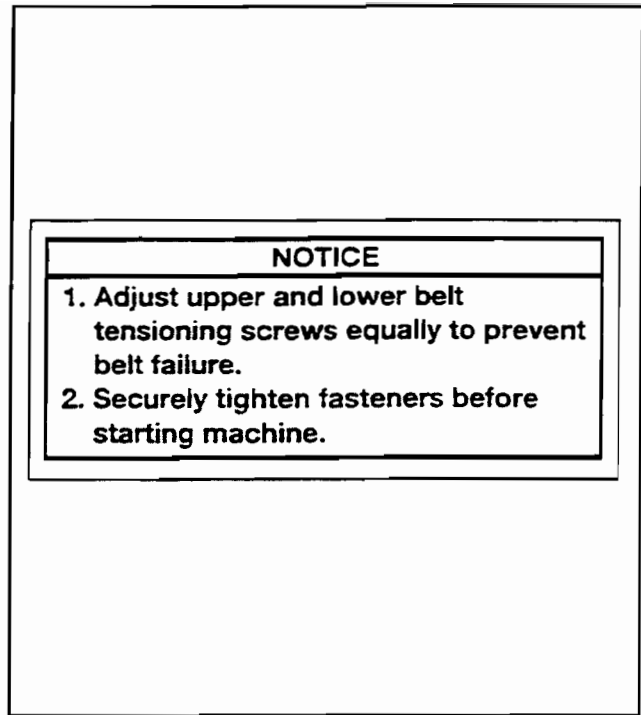


Figure 1-7 Operating Notice Label

The "Tape Threading Label" shown in Figure 1-8, is attached to the left side of both the upper and lower taping heads. This label provides a convenient tape threading diagram. More detailed tape loading and threading information is provided in this manual in the set-up procedure section.

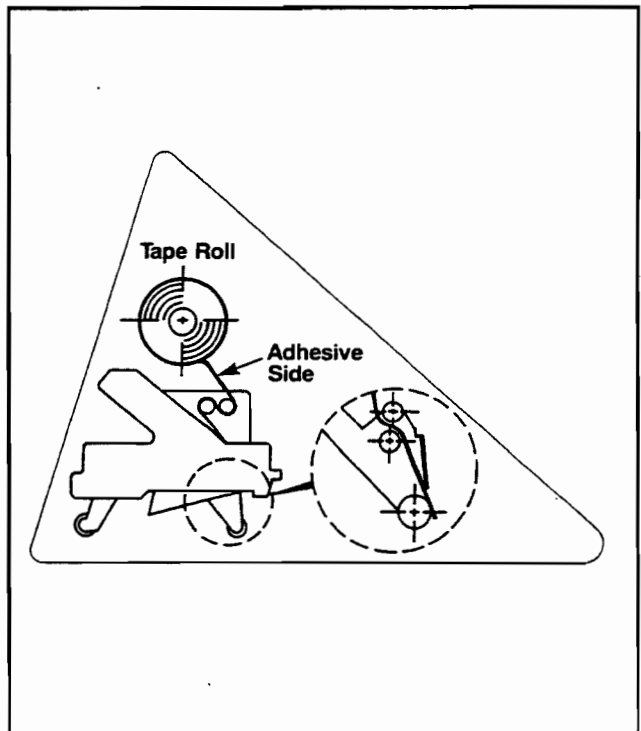
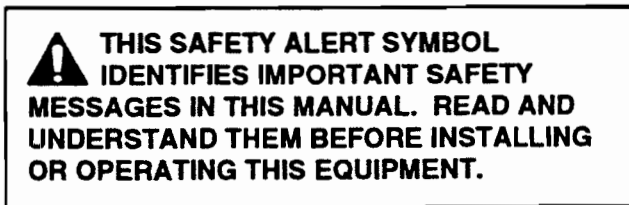


Figure 1-8 Tape Threading Label



Specifications

1. Power Requirements:

800a/800a3/800ab

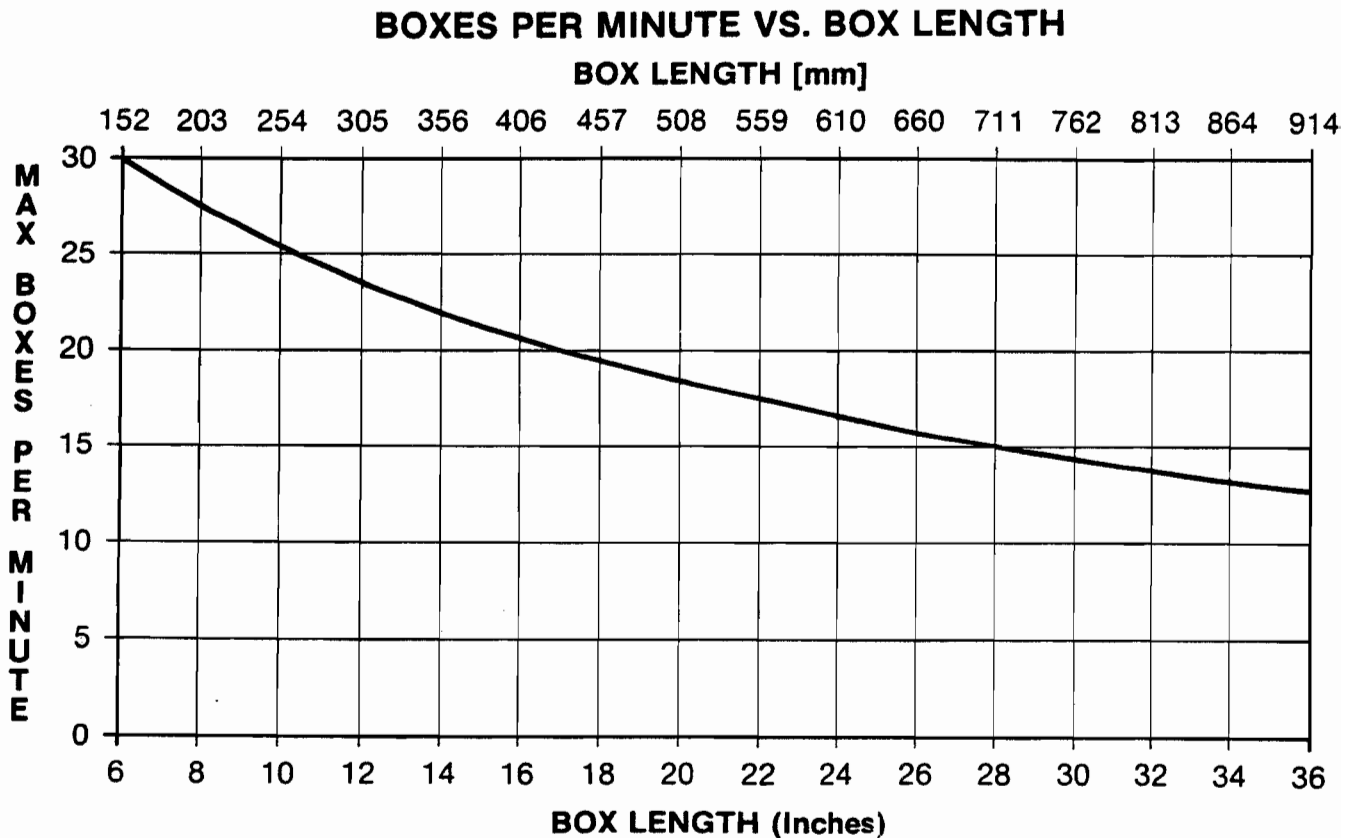
Electrical - 115 VAC, 60 Hz, 2.8 A

These machines are equipped with an 8 foot [2,4 m] standard neoprene covered power cord and a grounded plug.

Contact your 3M Representative for power requirements not listed above.

2. Operating Rate:

Belt speed is 78 ft/min [0,40 m/s]



Actual production rate is dependent on operator's dexterity.

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

3. Operating Conditions:

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

IMPORTANT SAFEGUARD

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

(Specifications continued on next page)

Specifications (Continued)

4. Tape:

Scotch™ brand pressure-sensitive film box sealing tapes.

5. Tape Width:

	800a/800ab	800a3
Minimum –	1-1/2 inches or 36 mm	2 inches [50 mm]
Maximum –	2 inches [50 mm]	3 inches or 72 mm

6. Tape Roll Diameter:

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

7. Tape Application Leg Length – Standard:

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

Tape Application Leg Length – Optional:

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

8. Box Board:

Style – regular slotted containers – RSC

Bursting test –125 to 275 P.S.I. single wall or double wall B or C flute.

9. Box Weight and Size Capacities:

A. Box Weight, filled – contents must support flaps.

Minimum – weight must be sufficient to hold carton on the conveyor bed with bottom flaps fully closed.

Maximum – 85 lbs. [40 kg]

B. Box Size:

	800a/800ab	800a3
Minimum		
Length –	6 inches [150 mm]	6 inches [150 mm]
Width –	4-1/2 inches [115 mm]	5-1/2 inches [140 mm]
Height –	4-3/4 inches [120 mm] *	4-3/4 inches [120 mm]
Maximum		
Length –	unlimited	unlimited
Width –	21-1/2 inches [545 mm]	21-1/2 inches [545 mm]
Height –	24-1/2 inches [620 mm]	24-1/2 inches [620 mm]

* Minimum box height is 4-1/4 inches [110 mm] with removal of compression rollers.

With outer columns relocated to upper position, minimum box height is 6-1/2 inches [165 mm] and maximum box height is 28-1/2 inches [725 mm]. (See Special Set-Up Procedure, page 33.)

Specifications (Continued)

Note: The case sealer is designed to accommodate most boxes complying with the 1976 FBA and PMMI* voluntary standard "Tolerances for Top Opening" regular slotted corrugated containers (RSC). Two of the requirements of the standard are the following:

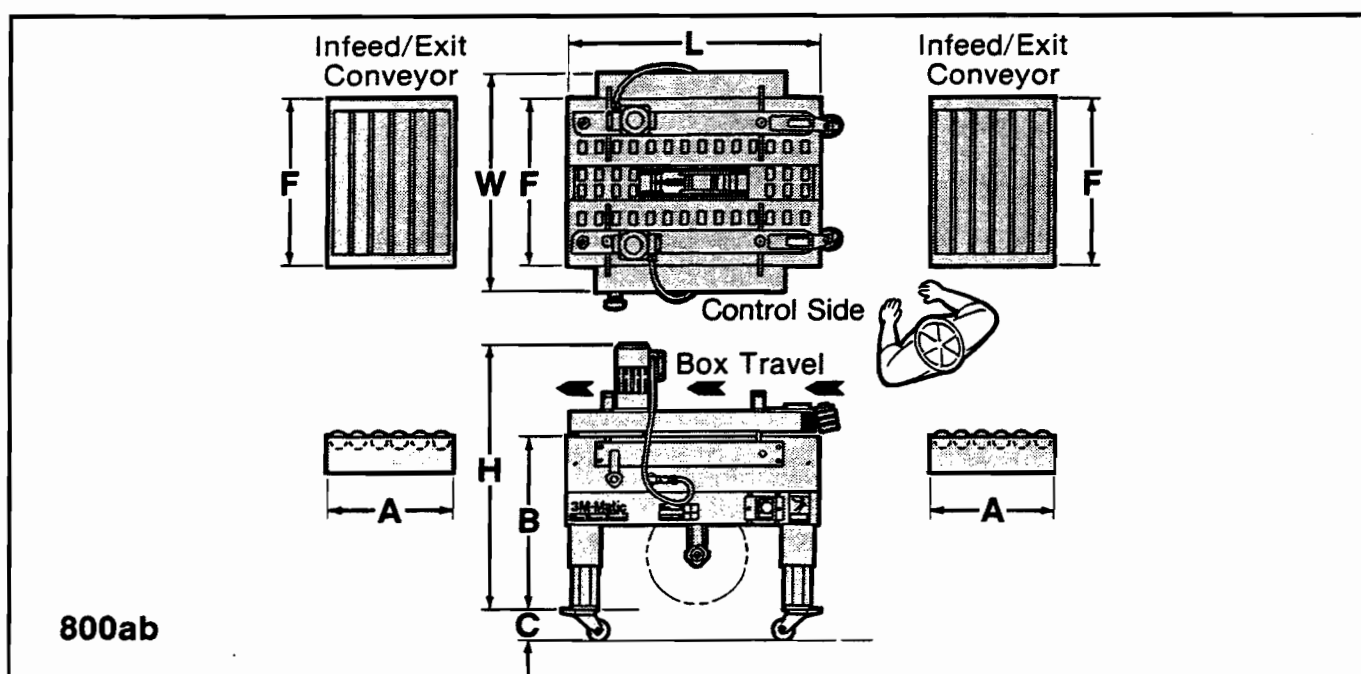
- the box length is not more than twice the box width
- the box length is not more than four times the box depth.

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

BOX LENGTH IN DIRECTION OF SEAL MUST BE GREATER THAN .6
BOX HEIGHT

If any of the above criteria are not met boxes should be test run to assure proper machine performance.

*Fibre Box Association, Packaging Machinery Manufacturer's Association



10. Machine Dimensions: (800ab)

	W	L	H	A*	B	C**	F
Minimum							
Inches [mm]	36-1/4 [920]	36-1/4 [920]	33-3/4 [855]	18 [460]	24 [610]	4 [100]	24-1/2 [620]
Maximum							
Inches [mm]	--	--	44-3/4 [1135]† 47-1/4 [1200]††	--	35 [890]	--	--

* Infeed/Exit conveyors are optional

** Casters are optional

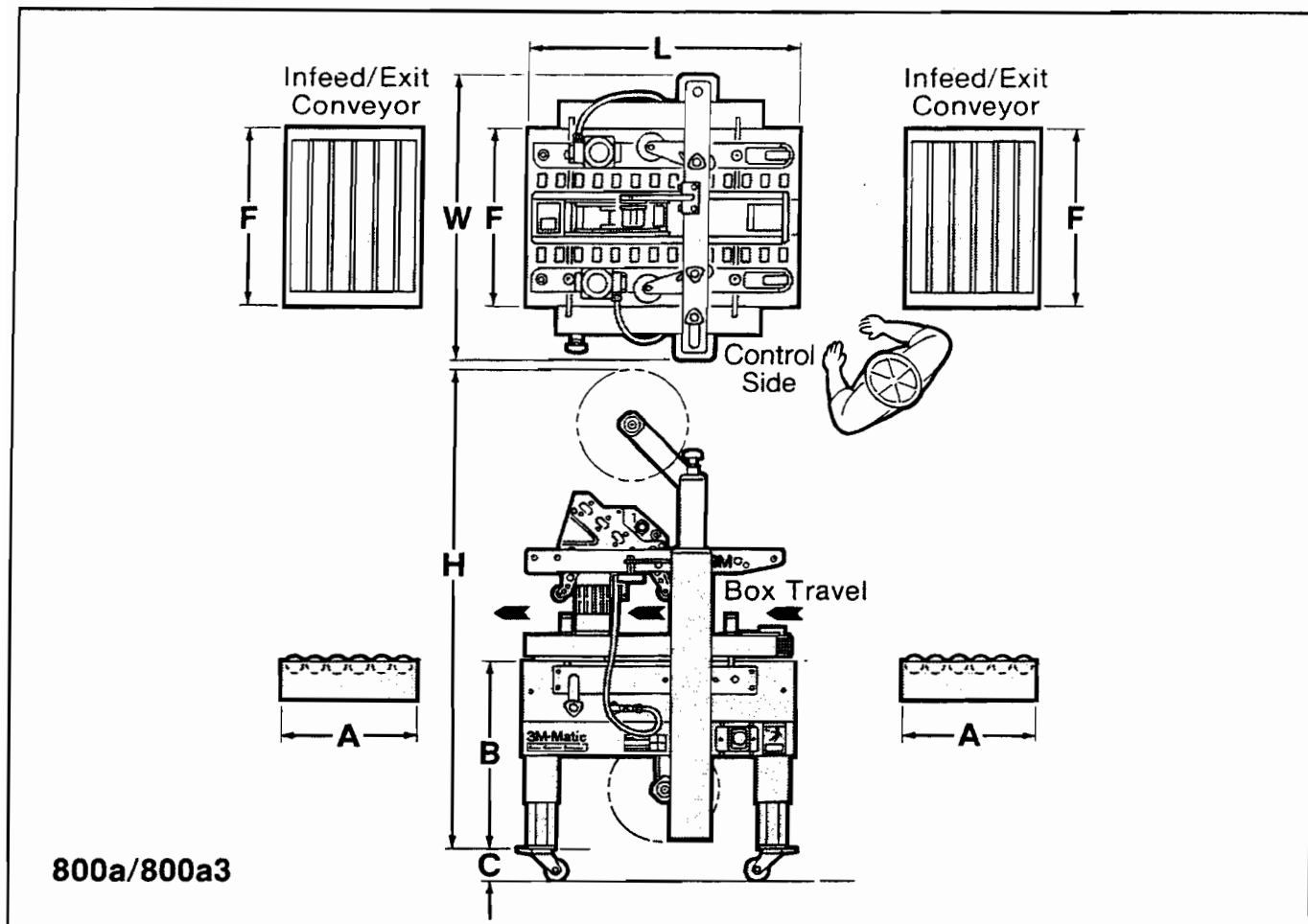
† with drive belt assembly in normal position

†† with drive belt assembly in upper position

Weight - approximate 290 pounds [132 kg] crated
 approximate 250 pounds [114 kg] uncrated

Specifications continued on next page.)

Specifications (Continued)



Machine Dimensions: (800a/800a3)

	W	L	H	A*	B	C**	F
Minimum							
Inches [mm]	38-1/2 [980]	36-1/4 [920]	55[1395]	18 [460]	24 [610] ***	4 [100]	24-1/2 [620]
Maximum							
Inches [mm]	--	--	86 [2184] ***	--	35 [890] ***	--	--

* Infeed/Exit conveyors are optional

** Casters are optional

*** With outer columns relocated to upper position, "H" maximum dimension increases 4 inches [100 mm] and "B" minimum/maximum dimension decreases by 4 inches [100 mm]. (See Special Set-Up Procedure, page 33.)

Weight -- approximate 390 pounds [176,9 kg] crated
 approximate 350 pounds [158,8 kg] uncrated

11. Set-Up Recommendations:

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

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Set-Up Procedure

It is recommended that the 800a Series 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 case sealer before subjecting it and operating personnel to a production situation where time for set-up, adjustments, and operator training usually becomes limited.

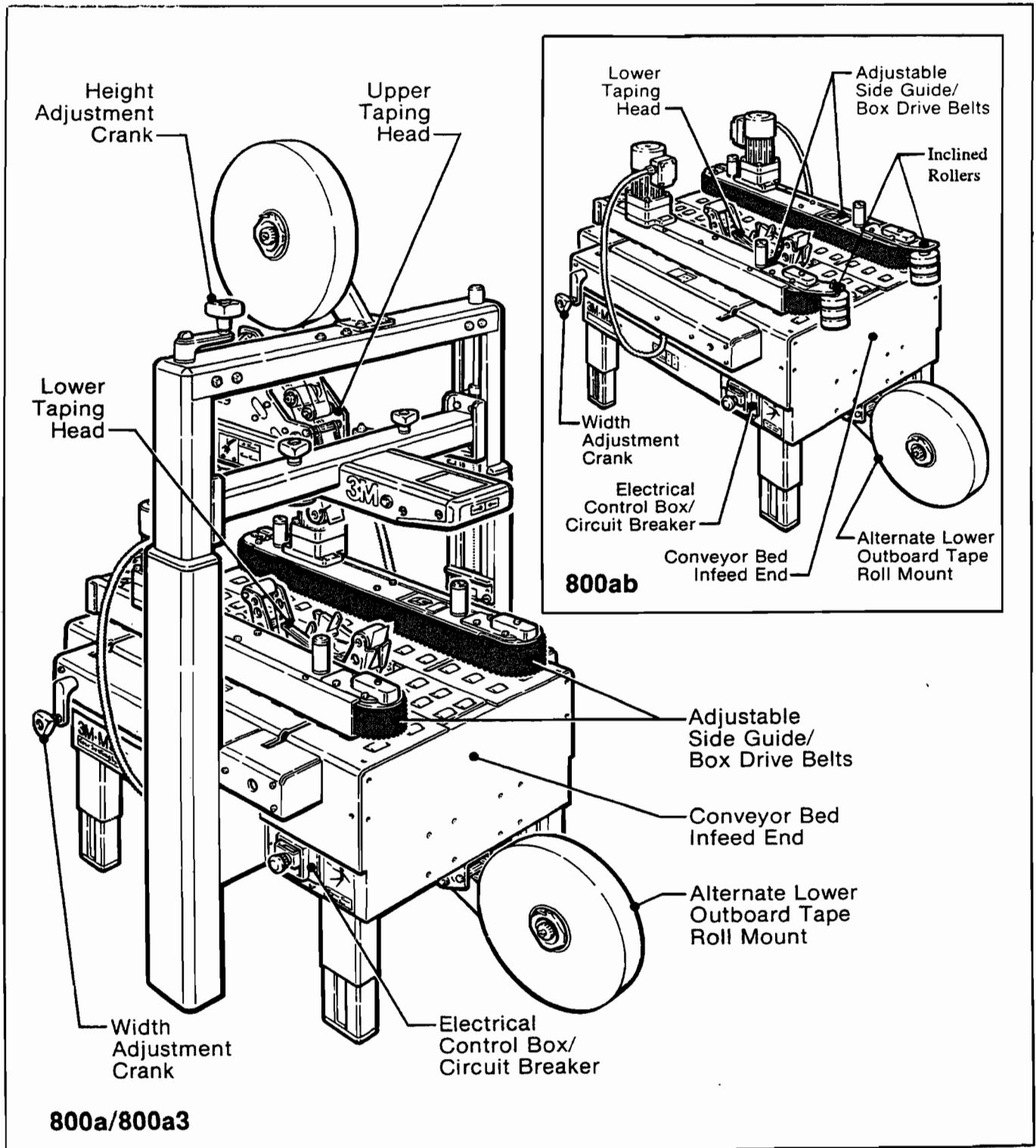


Figure 2-1 - Set-Up Instructions - Case Sealer Components - Left Front View

Set-Up Procedure (Continued)

Receiving And Handling

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

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

1. Lift off fiberboard cover from pallet after removing staples at bottom.
2. Remove the two "U" shaped hold down clamps from lower cross bar. These are sheet metal brackets that prevent the upper head assembly from bouncing during shipping.
3. Install the crank handle on the top of the left column, as shown in Figure 2-2A.
4. Install the upper tape drum bracket on the top cross bar, as shown in Figure 2-2B.
5. Raise upper head assembly (turn crank handle counterclockwise). Remove the two shipping stop angle brackets and discard. Install the machine stops (from parts bag). Mount these stops as shown in figure 2-2C. Use the lowest hole position and bolt into the lowest threaded insert on the column. The upper hole position in the stops should only be used when the heads are adjusted to apply 2 inch tape legs.
6. Ensure that the tape drum bracket assembly, located on the lower taping head, is mounted straight down, as shown in Figure 2-3A. The tape drum bracket assembly **can be pivoted to provide clearance or for retrofit in certain cases.**
7. **For 800ab only** - Install inclined rollers onto infeed end on drive assemblies, shown in Figure 2-1. Remove four bolts, position inclined roller assembly, replace four bolts.

Lower Outboard Tape Roll Mount - Alternate

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

Conveyor Bed Height

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

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

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

Set-Up Procedure (Continued)

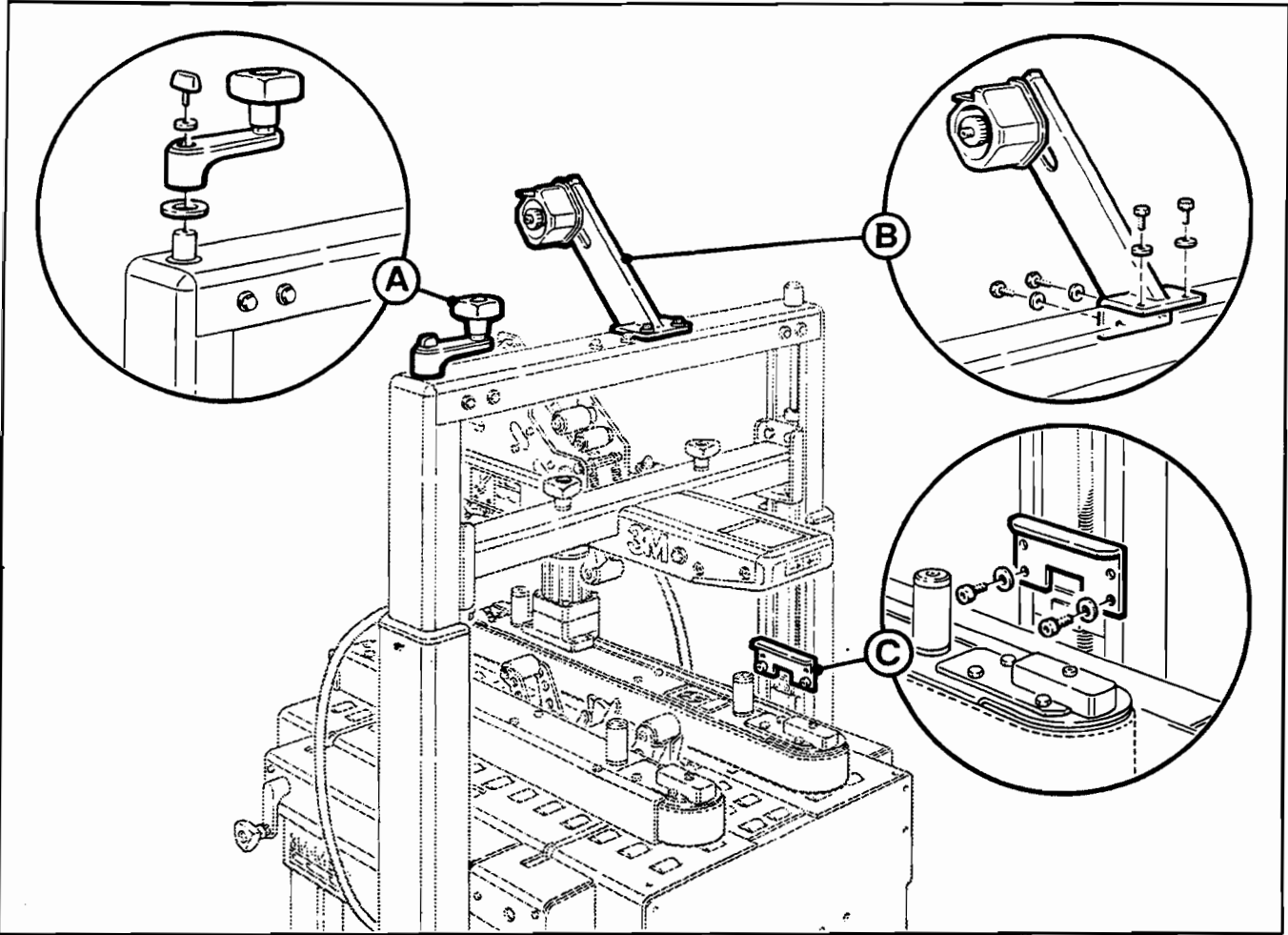


Figure 2-2 - Set-Up and Installation

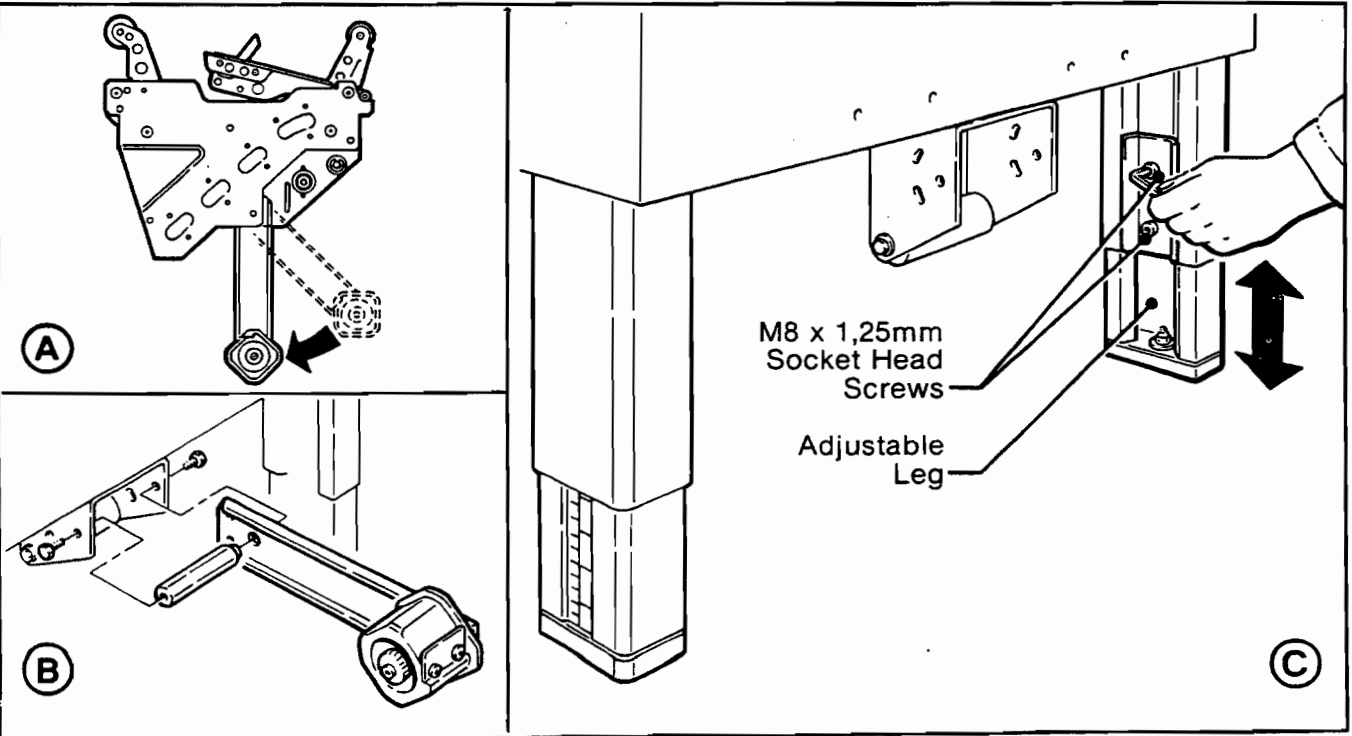


Figure 2-3 - Conveyor Bed Height Adjustment and Lower Tape Drum Bracket Position

Set-Up Procedure (Continued)

IMPORTANT SAFEGUARDS

1. 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 WORKING WITH THE TAPING HEADS OR ATTEMPTING TO LOAD THE TAPE, REFER TO FIGURES 2-4 AND 2-5 AND IDENTIFY THE BLADE LOCATION. KEEP HANDS OUT OF THESE AREAS EXCEPT AS NECESSARY TO SERVICE THE TAPING HEADS.
2. NEVER ATTEMPT TO WORK ON THE TAPING HEADS OR LOAD TAPE WHEN THE BOX DRIVE BELTS ARE RUNNING.
3. BOX DRIVE MOTORS ARE DESIGNED TO RUN AT A MODERATE TEMPERATURE OF 120°F [50° C].
4. NEVER ATTEMPT TO REMOVE BOXES FROM THE EXIT END OF MACHINE WHILE MACHINE IS RUNNING.

Tape Loading (800a/800ab)


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

Tape Loading (800a3)

The taping heads have been pre-set to accommodate 3 inch [72 mm] wide tape rolls. To apply 2 inch or 50 mm wide tapes, refer to "Adjustments Section" for set-up information.

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

Tape Loading - Upper Taping Head (800a/800a3)

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

1. It is first necessary to raise the upper taping head frame to a convenient working position.
2. For tape loading operations, use the plastic threading leader and follow the loading procedures (Figures 2-6, 2-8, 2-10) to complete the tape threading.

Tape Loading - Lower Taping Head (800a/800a3/800ab)

1. For ease in set-up loading, first remove the lower taping head from the conveyor bed. Lift the head straight up from the conveyor bed.
2. The lower taping head is loaded and threaded in the same manner as the upper taping head. Follow the tape loading procedures (Figures 2-7, 2-9, & 2-11) to complete the tape threading.
3. Replace the lower taping head.

Set-Up Procedure (Continued)

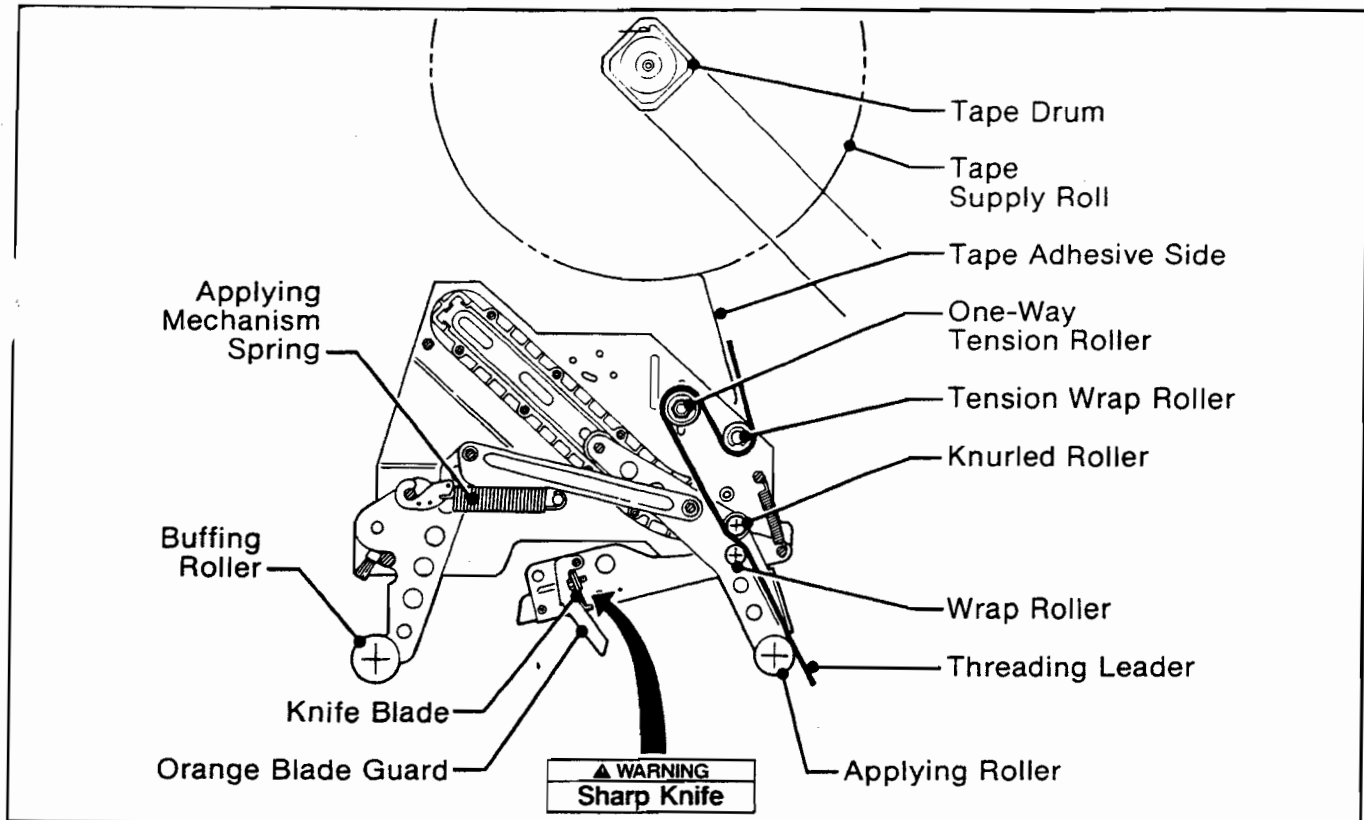


Figure 2-4 - Tape Threading Diagram 800a/800a3 - Upper Taping Head - Left Side View

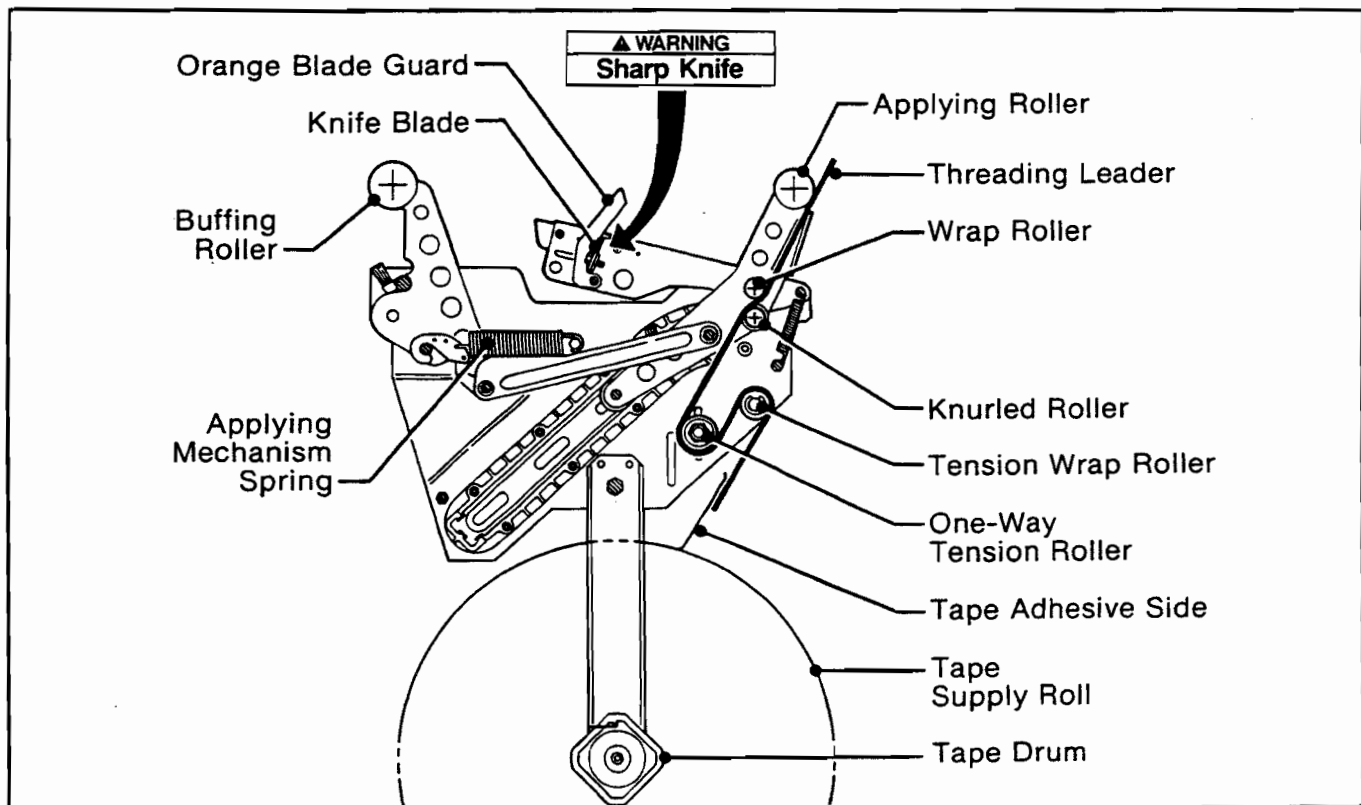


Figure 2-5 - Tape Threading Diagram 800a/800a3/800ab - Lower Taping Head - Left Side View

Set-Up Procedure (Continued)

Figure 2-6 (800a/800a3)

Insert the plastic leader **downward** around rollers as illustrated.

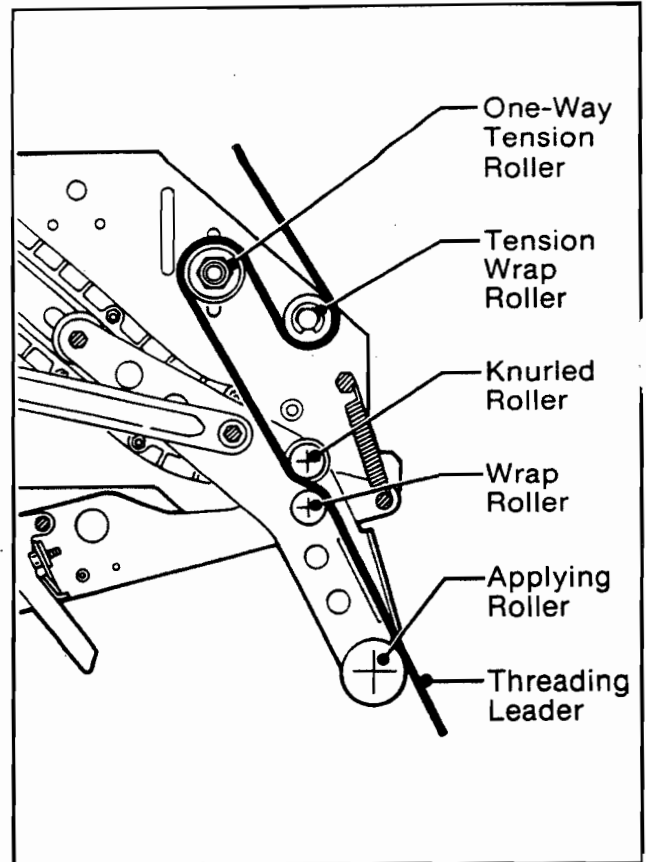


Figure 2-6 - 800a/800a3 - Upper Taping Head

Figure 2-7 (800a/800a3/800ab)

Insert the plastic leader **upward** around rollers as illustrated.

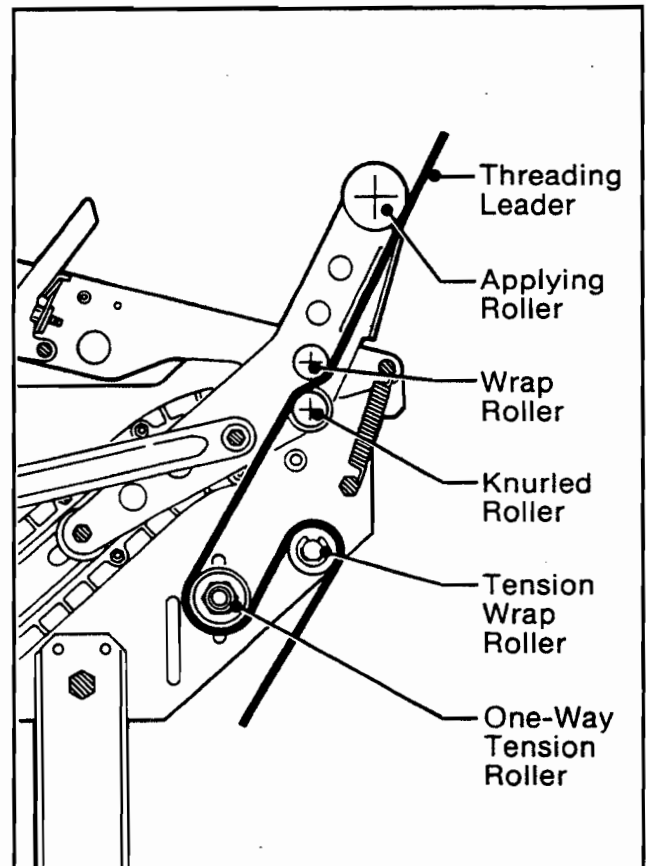


Figure 2-7 - 800a/800a3/800ab - Lower Taping Head

Set-Up Procedure (Continued)

Figure 2-8 (800a/800a3)

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

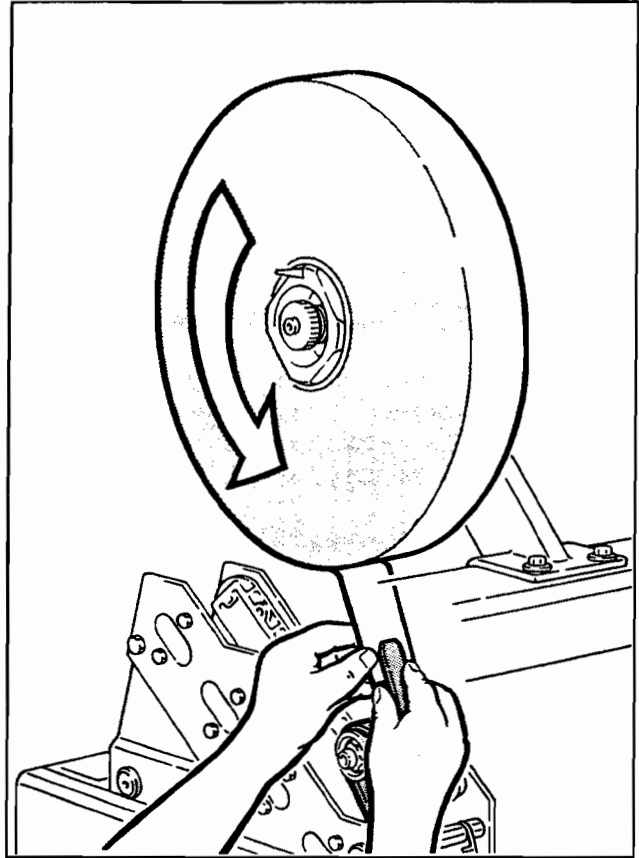


Figure 2-8 - 800a/800a3 - Upper Taping Head

Figures 2-9 (800a/800a3/800ab)

Place tape roll on drum to **dispense tape from top of roll toward tension wrap roller with tape adhesive side out**. Seat tape roll fully against back flange of drum. Adhere tape lead end to lower end of threading leader as shown.

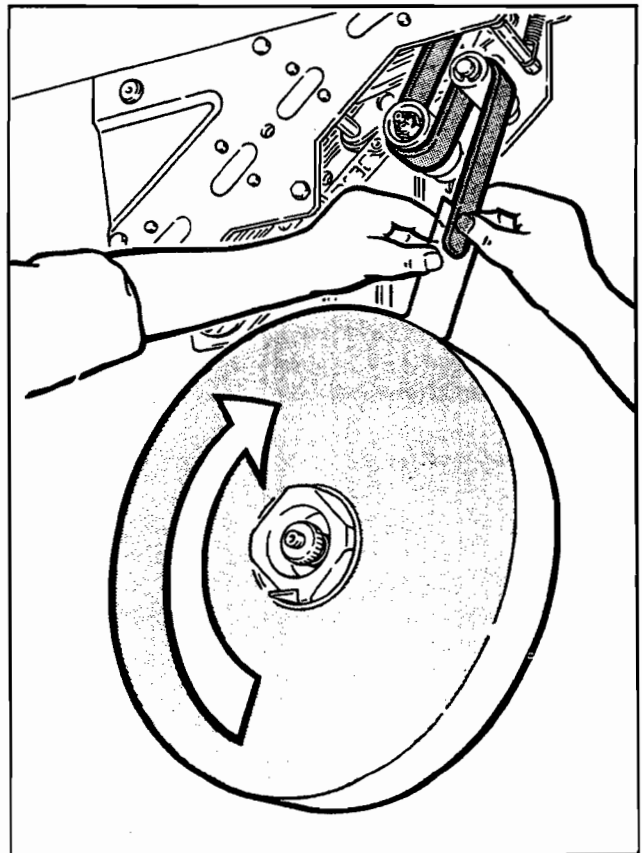


Figure 2-9 - 800a/800a3/800ab - Lower Taping Head

Set-Up Procedure (Continued)

Figure 2-10 (800a/800a3)

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 leader through tape applying mechanism until leader is through and tape is in alignment with applying roller.

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

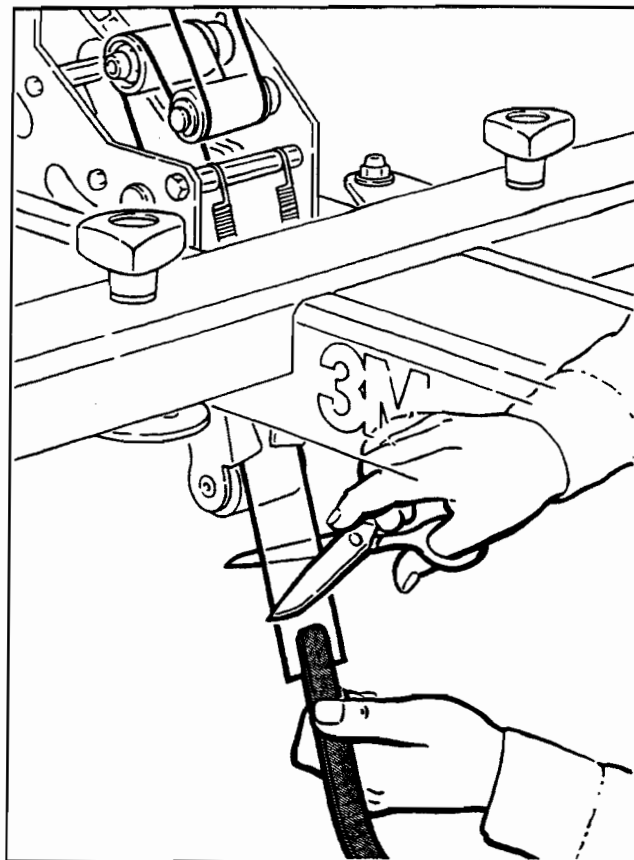


Figure 2-10 - 800a/800a3 - Upper Taping Head

Figure 2-11 (800a/800a3/800ab)

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

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

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

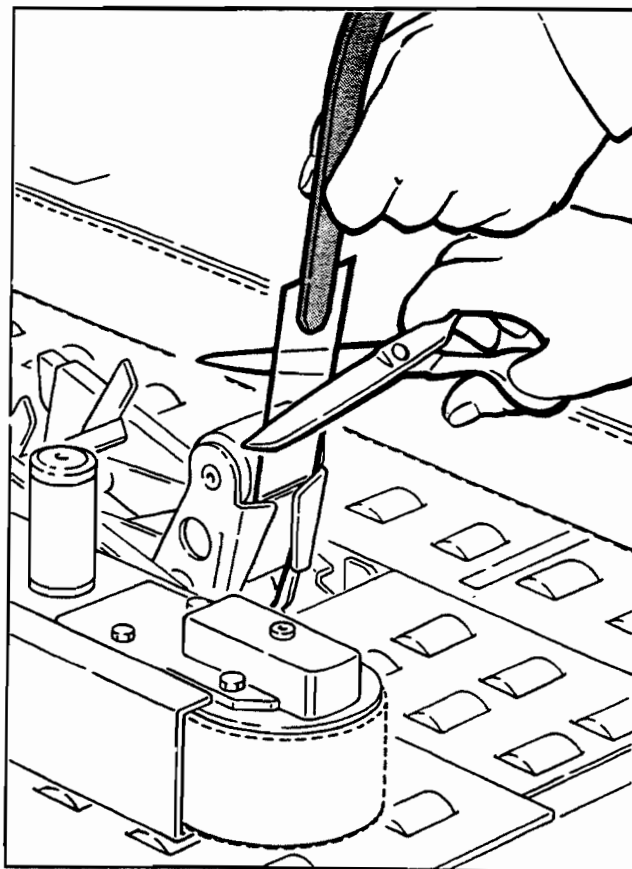


Figure 2-11 - 800a/800a3/800ab - Lower Taping Head

Set-Up Procedure (Continued)

Electrical Connection

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

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

Box Size Set-Up and Operation

Figure 2-12 (800a/800a3)

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

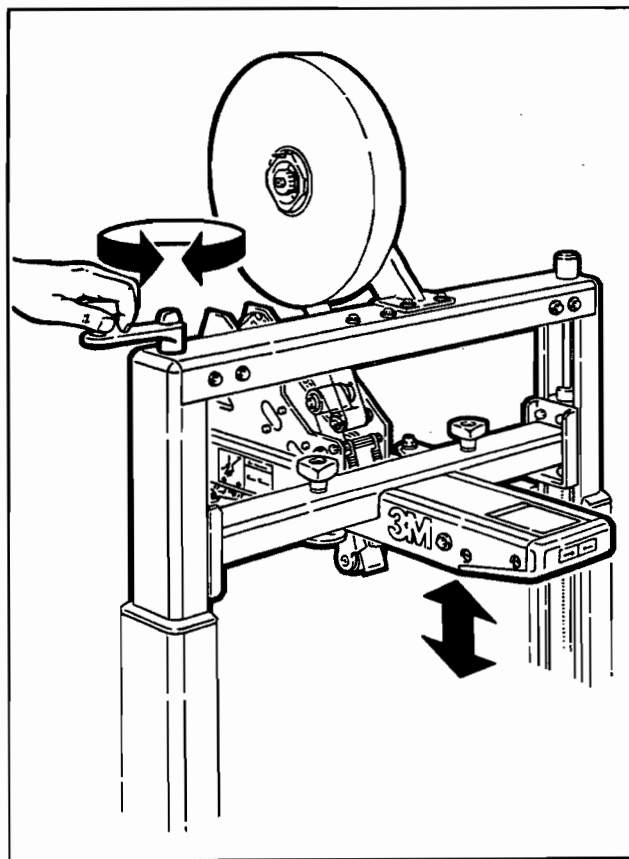


Figure 2-12 - Box Set-Up

Set-Up Procedure (Continued)

Box Set-Up (800a/800a3/800ab)

Figure 2-13

Place a product filled box on infeed conveyor bed with top flaps folded as shown and manually move box forward to contact bottom taping head applying roller.

Turn hand adjustment crank to position both side drive belts against sides of box.

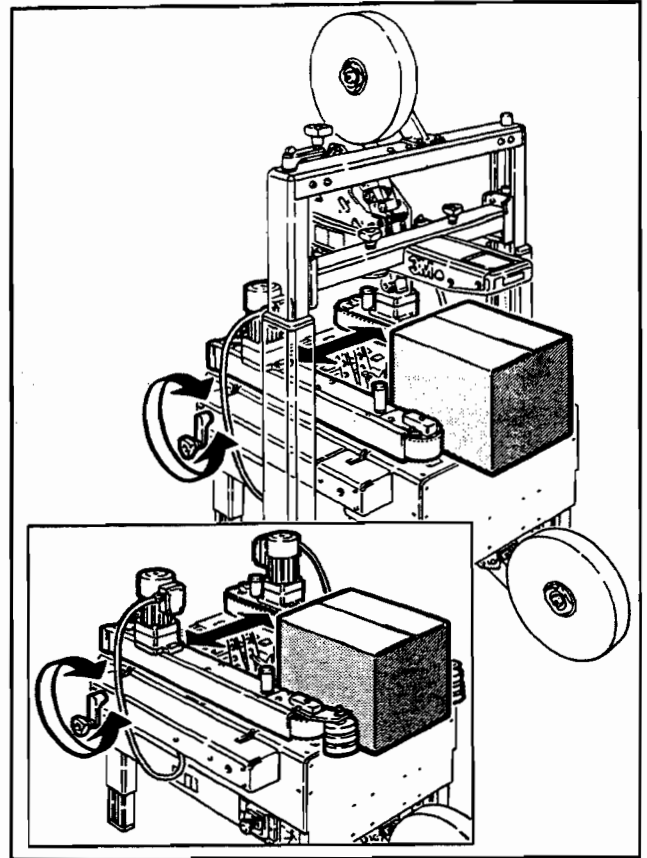


Figure 2-13 - Side Drive Belts

Figure 2-14 (800a/800a3)

Turn height adjustment crank to position top taping head assembly onto box. Top taping head must contact and hold top box flaps fully closed.

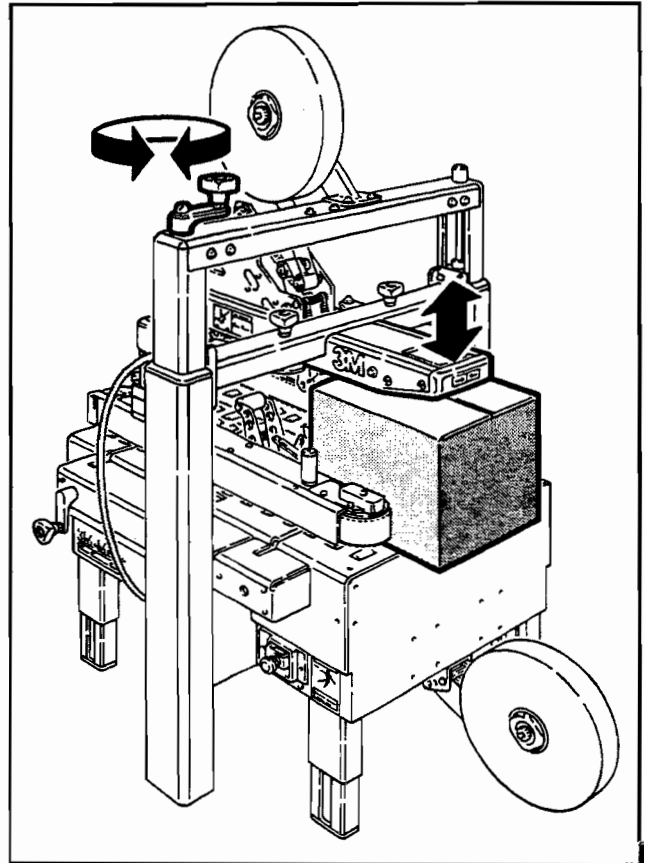


Figure 2-14 - Top Taping Head

Set-Up Procedure (Continued)

Figure 2-15 (800a/800a3)

The top flap compression rollers have an **adjustable slide mounting** to provide side compression through the full range of box widths.

Manually move box forward so front of box is aligned with top flap compression rollers.

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

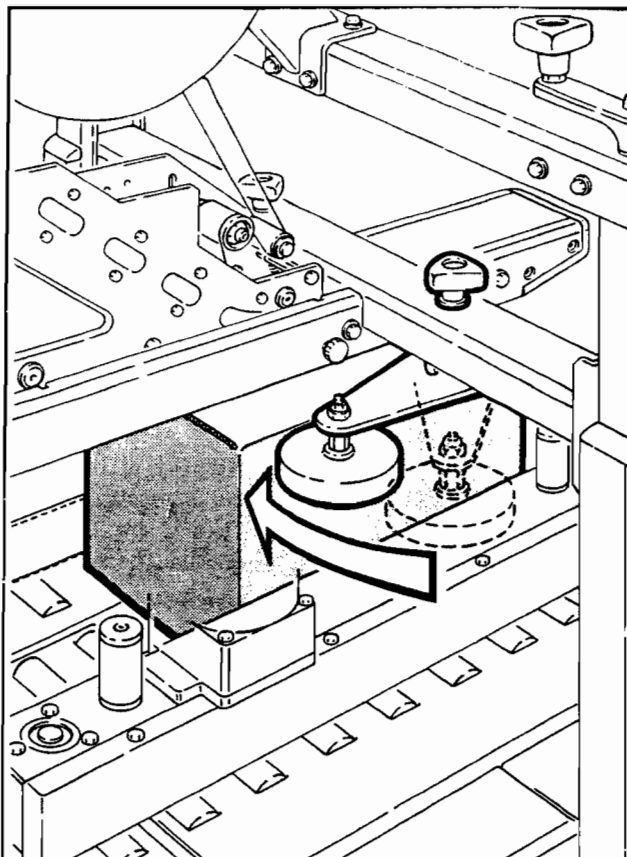


Figure 2-15 - Top Flap Compression Rollers

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

800a/800a3

Turn electrical switch to "On" to start drive belts.

Move box forward under upper taping head until it is taken away by drive belts. If box is hard to move under head or is crushed, raise head slightly.

If the box movement is jerky or stops under the upper head, move the side drive belts in slightly to add more pressure between the box and drive belts.

800ab

Turn electrical switch to "On" to start drive belts.

With box pushed down against case sealer bed, move box forward until it is taken away by drive belts.

If the box movement is jerky, move the side drive belts in slightly to add more pressure between the box and drive belts.

800a/800a3/800ab

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

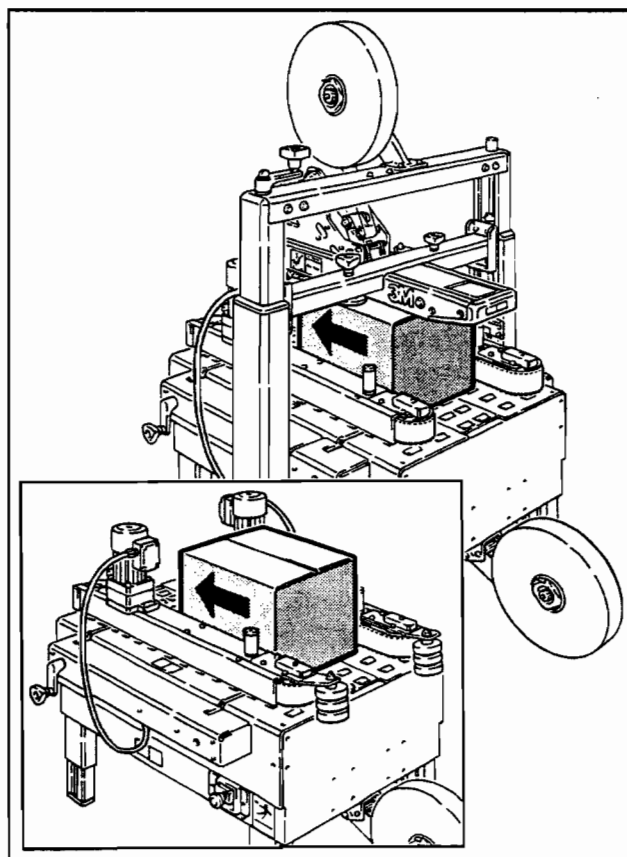


Figure 2-16

Adjustments



WARNING - TURN OFF ELECTRICAL POWER 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 3-1 (800a/800a3/800ab)

The tape drum assembly on each taping head is pre-set to accommodate 2 inch [50 mm] wide tape but is adjustable to provide alignment of narrower (800/800ab) or wider (800a3) 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.
2. **Turn tape drum shaft** in or out to center the tape web (use 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 3-2 (800a/800a3/800ab)

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 knurled nut on the shaft to vary compression of the spring. Turn knurled nut 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.

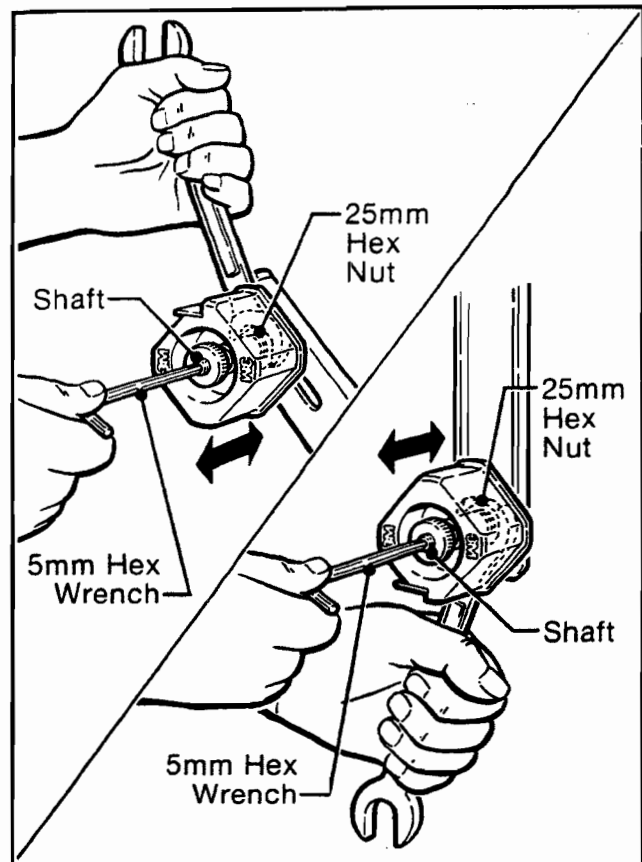


Figure 3-1 – Tape Web Alignment

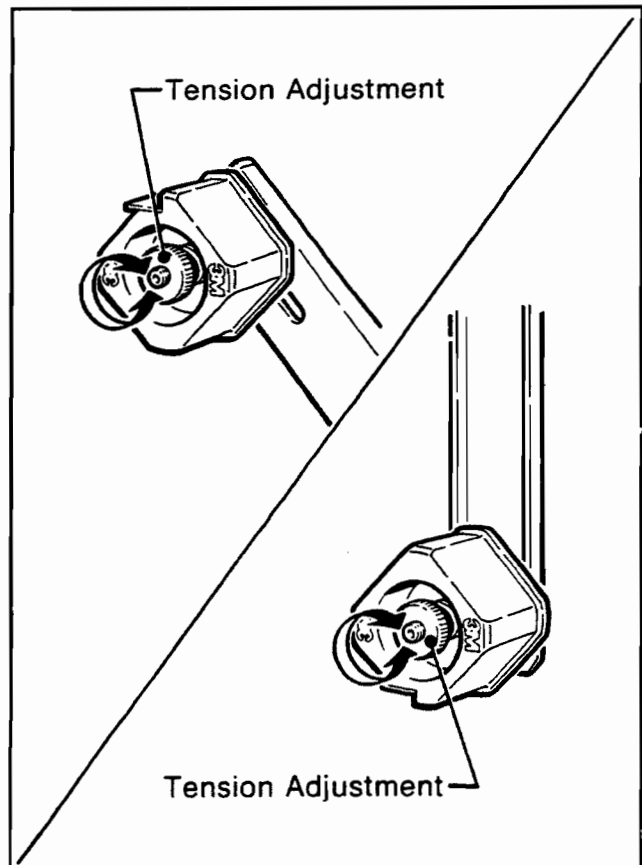


Figure 3-2 – Tape Drum Friction Brake

Adjustments (Continued)



WARNING – TURN OFF ELECTRICAL POWER 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 3-3 (800a/800a3/800ab)

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

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

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

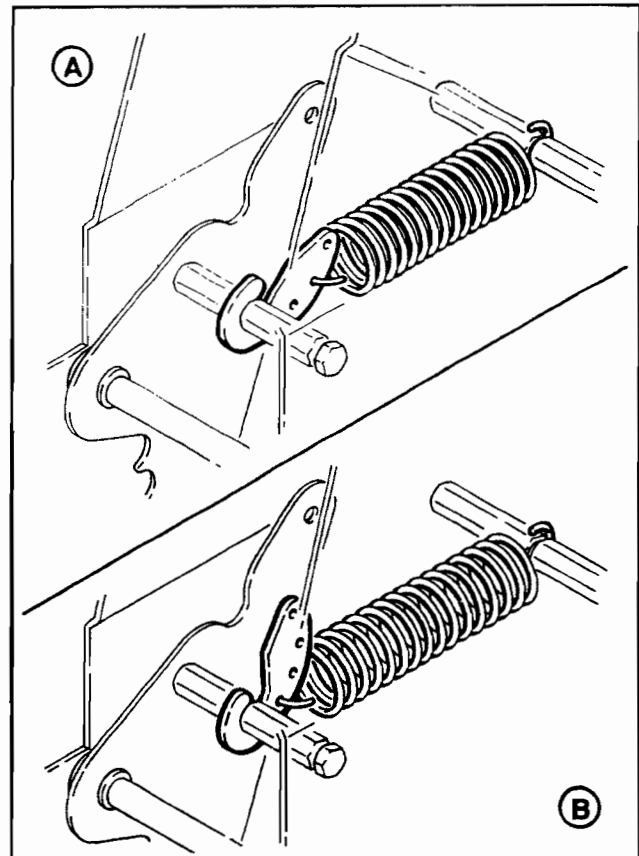


Figure 3-3 – Applying Mechanism Spring

One Way Tension Roller Assembly

Figure 3-4 (800a/800a3/800ab)

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

To Set Tension:

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

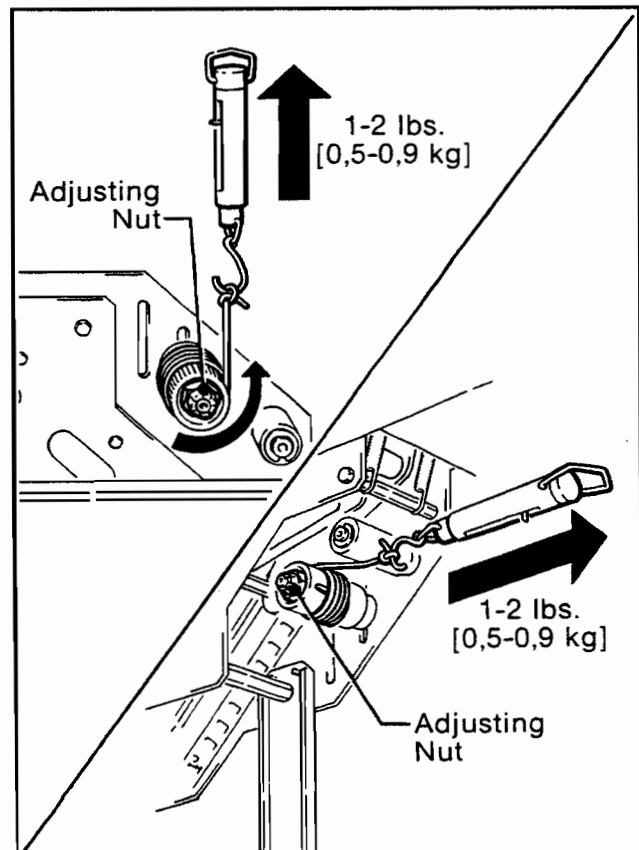


Figure 3-4 – One-Way Tension Roller

Adjustments (Continued)



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 (800a/800a3/800ab)

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

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

To Set Box Drive Belt Tension (Refer to Figures 4-2, 4-3 and 4-4)

- Step 1. Remove and retain screw (D), washer (E) and belt tensioner cover (F).
- Step 2. Turn belt adjustment screws (G) equally on both upper and lower tension assemblies. Turn screws **clockwise to reduce** belt tension, **counterclockwise to increase** belt tension.
- Step 3. Use force gauge to pull the belt outward one inch (25 mm) at the midspan, as shown in Figure 4-4, with a moderate pulling force of 7 lbs. [3,5 kg].
- Step 4. Reassemble and secure screw (D), washer (E) and cover (F).

Tape Application Leg Length (800a/800a3/800ab)

Figure 3-5

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

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

(Use Figure 2-4 or 2-5 for reference)

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

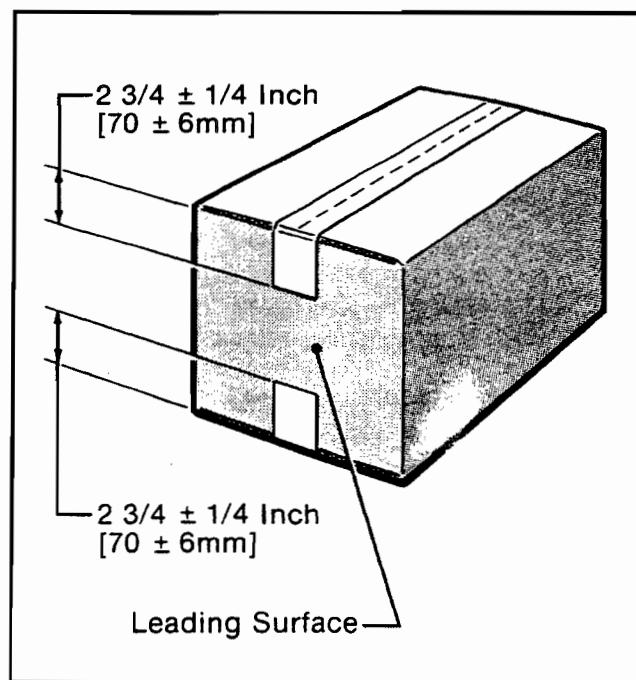


Figure 3-5 – Adjusting Tape Leg Length

Maintenance

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

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

Tool Kit

Since the case sealer utilizes metric fasteners, a tool kit consisting of open end and hex socket wrenches is provided with the machine. These tools should be adequate to set up the machine. Other tools supplied by the customer will be required for maintenance.

Blade Replacement (800a/800a3/800ab)

Figure 4-1

⚠ USE CARE WHEN REPLACING 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.

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

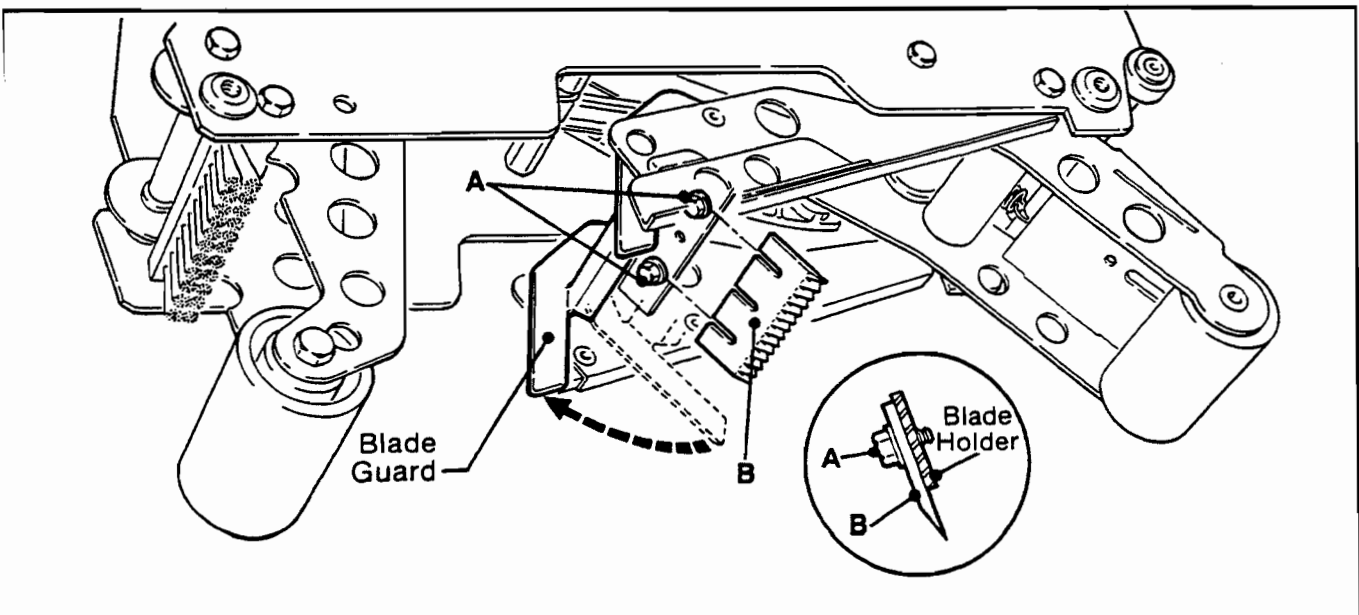


Figure 4-1 – Blade Replacement

Maintenance (Continued)



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

Box Drive Belt Replacement (800a/800a3/800ab)

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

Figure 4-2

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. Remove and retain the three screws (A), three washers (B) and side cover (C).
3. Remove and retain the screw (D), washer (E) and belt tensioner cover (F).

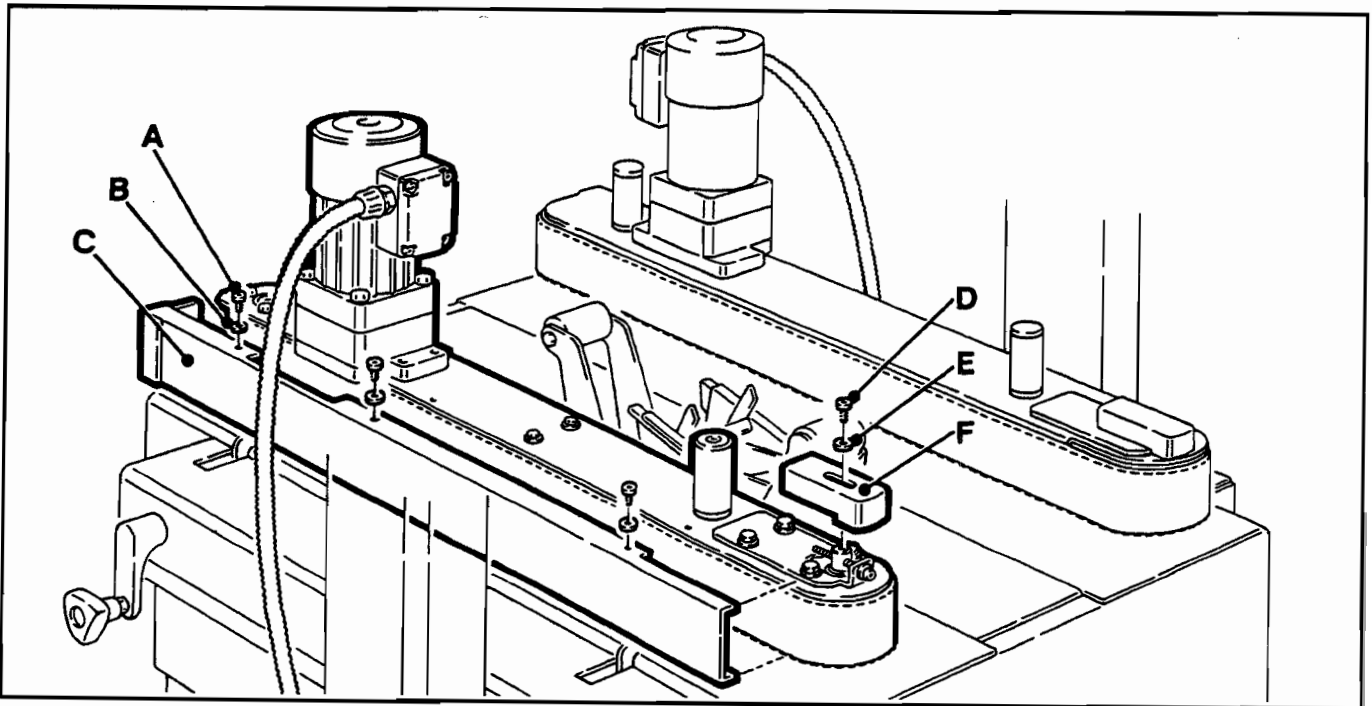


Figure 4-2 – Box Drive Belt (Left Side View - Infeed End)

Figure 4-3

4. Turn the belt adjustment screws (G) clockwise to end of adjustment on both the upper and lower tension assemblies.
5. Locate the belt lacing (joint) by turning the belt manually. Remove the pin with pliers. Remove and discard belt.

Maintenance (Continued)

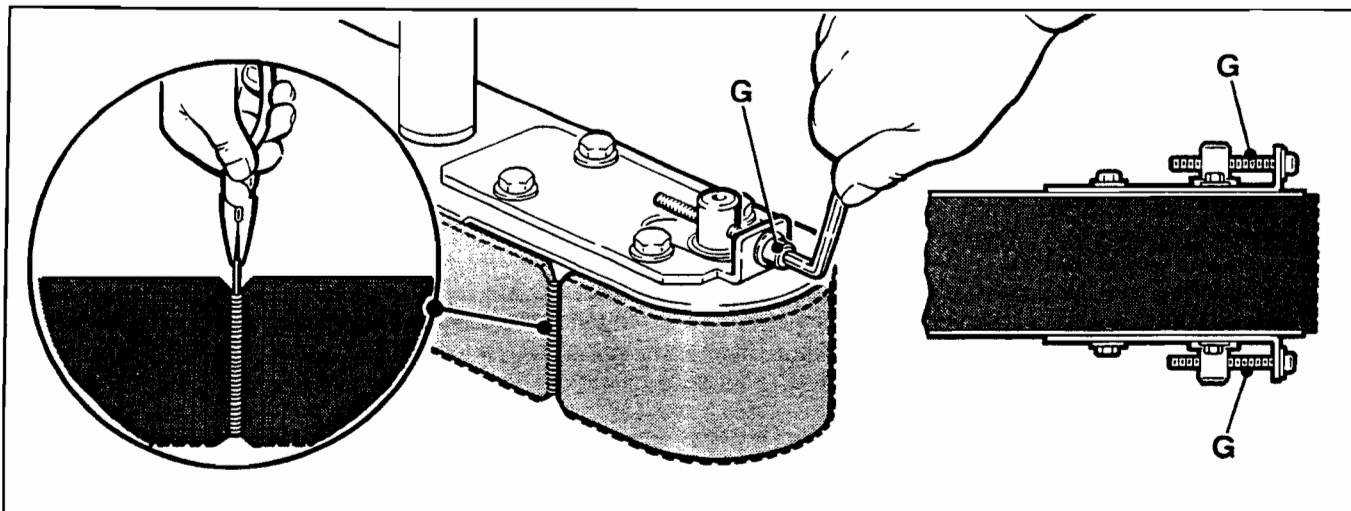


Figure 4-3 – Box Drive Assembly – Infeed End

Figure 4-4

Important – before installing the new drive belt – check the belt inside surface for drive direction arrows and install the belt accordingly. If no arrows are shown, the belt may be installed either way.

6. Install the new belt around drive rollers and insert new pin. Pin must not extend beyond edge of belt.
7. **To set drive belt tension** – turn the adjustment screws (G) equally on both the upper and lower tension assemblies. Turn the screws clockwise to reduce belt tension, counterclockwise to increase belt tension.

Use a force gauge to pull the belt outward one inch [25 mm] at the midspan, as shown, with a moderate pulling force of 7 lbs. [3,5 kg].

- 8.. Reverse procedures in items 1–3 (Figure 4-2) to reassemble the drive belt assembly.

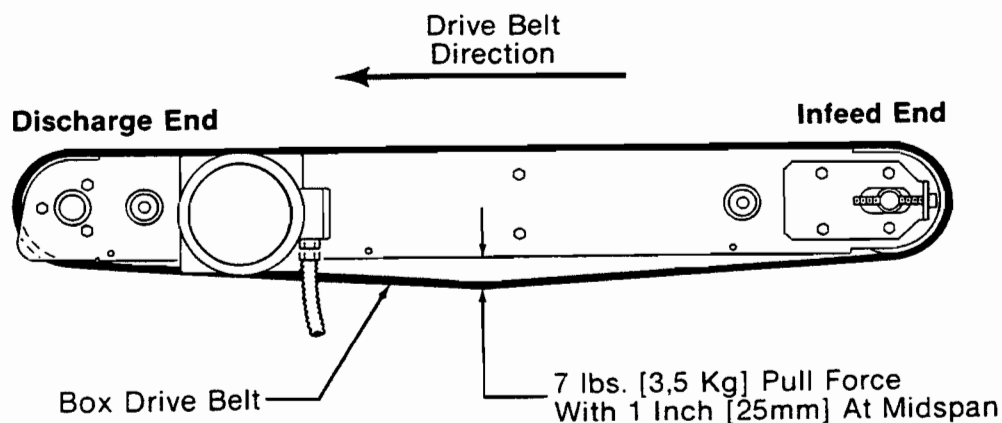


Figure 4-4 – Box Drive Belt Tension Adjustment - Top View

Maintenance (Continued)



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

Cleaning Of The Machine (800a/800a3/800ab)

Note – Never attempt to remove dirt from taping heads 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 (800a/800a3/800ab).



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

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

Circuit Breaker (800a/800a3/800ab)

The case sealer is equipped with a circuit breaker which trips the "On/Off" switch to tripped position. If circuit is **overloaded** and circuit breaker trips, **wait 2 minutes**, move to "Off", and turn "On". Located inside the electrical control box on the side of the main frame just below the conveyor bed, the circuit breaker has been **pre-set at 2.8 Amps** and requires no further maintenance.

Maintenance (Continued)

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

Lubrication - Mechanical (800a/800a3/800ab)

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

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

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

Note – Wipe off excess oil and grease. It will attract dust and 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 (800a/800a3/800ab)

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. **SATURATE FELT OILER PAD.**

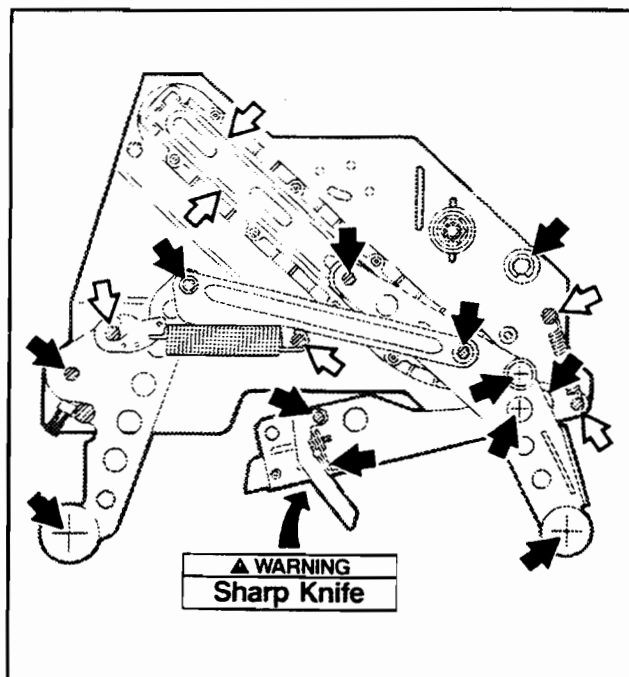


Figure 4-5 – Lubrication Points – Upper and Lower Taping Heads

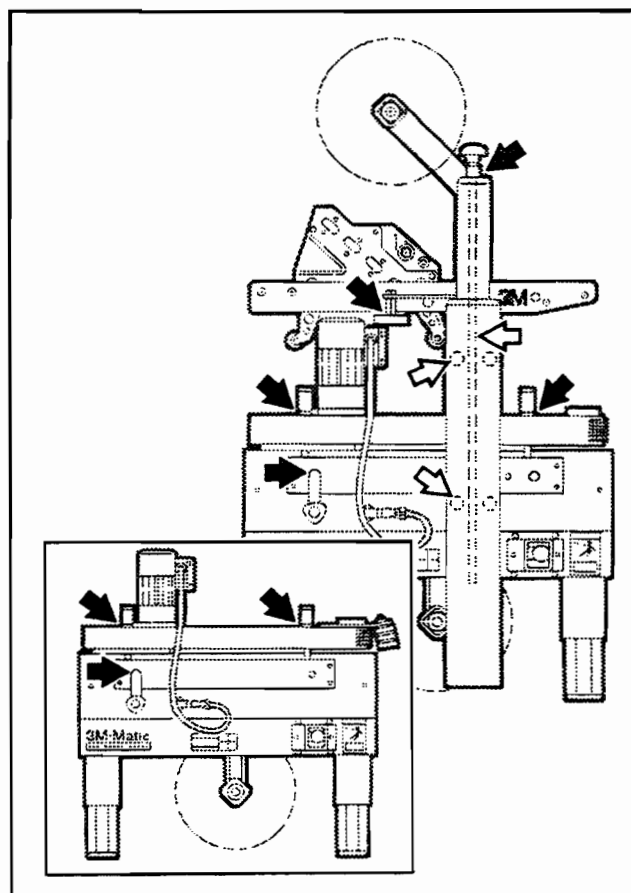


Figure 4-6 – Lubrication Points – Frame

Special Set-Up Procedure



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.

Changing the Tape Leg Length (From 2-3/4 to 2 Inches [70 to 50 mm]) (800a/800a3/800ab)

The following changes to the case sealer will allow the taping of boxes of 4-3/4 inches [120 mm] minimum height.

Case Sealer Frame (Refer to Figure 5-1A)

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

Taping Heads



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

(Refer to Figures 5-1B and 5-1C)

1. Loosen, but do not remove, the two retaining screws that secure the upper taping head shown in **Figure 5-1B**.
2. Slide the head forward and lift straight up to remove it from the case sealer.
3. Lift the lower taping head, shown in **Figure 5-1C**, straight up to remove it from the case sealer bed.

(Refer to Figure 5-2)

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

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 or bottom surface will decrease the leading leg length. Moving it closer to the box top surface will increase the leading leg length.

Figure 5-3

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

Special Set-Up Procedure (Continued)

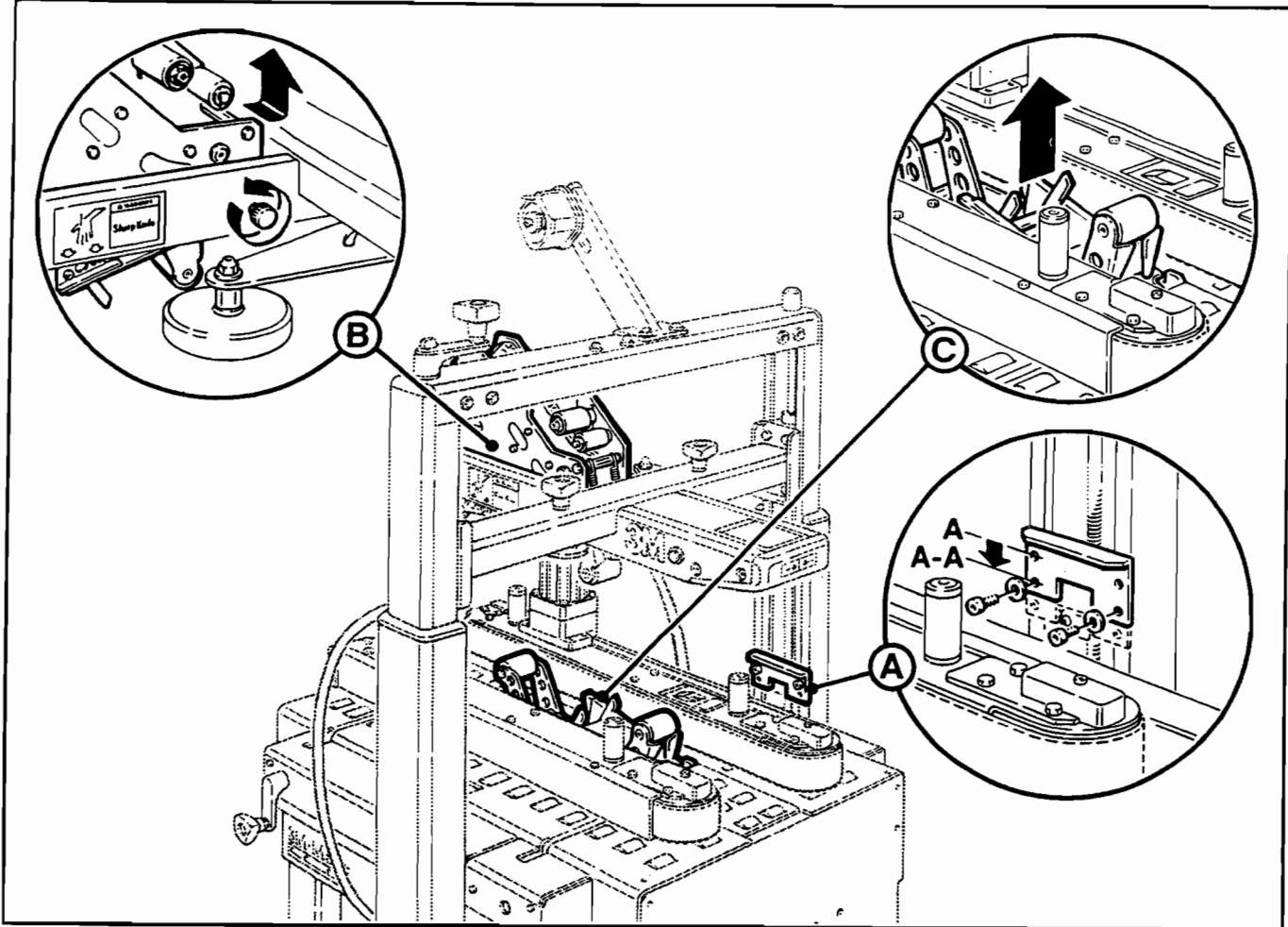


Figure 5-1 – Removing Taping Heads From Case Sealer

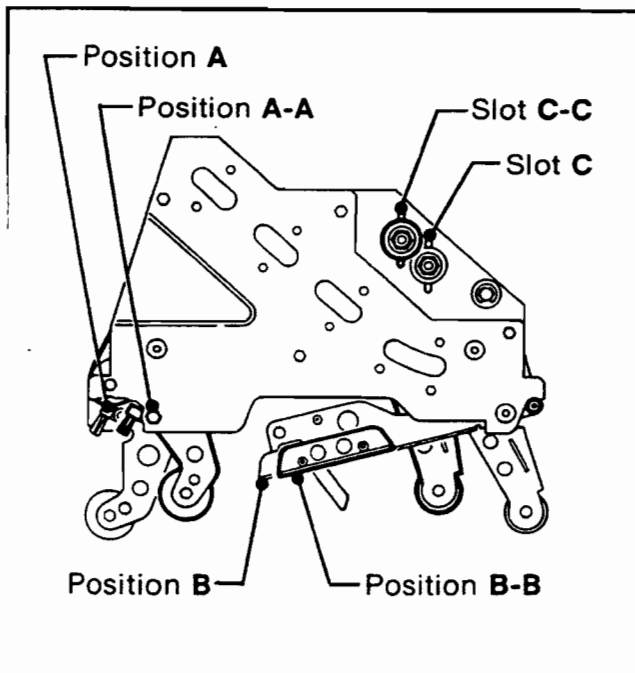


Figure 5-2 – Changes to Taping Head

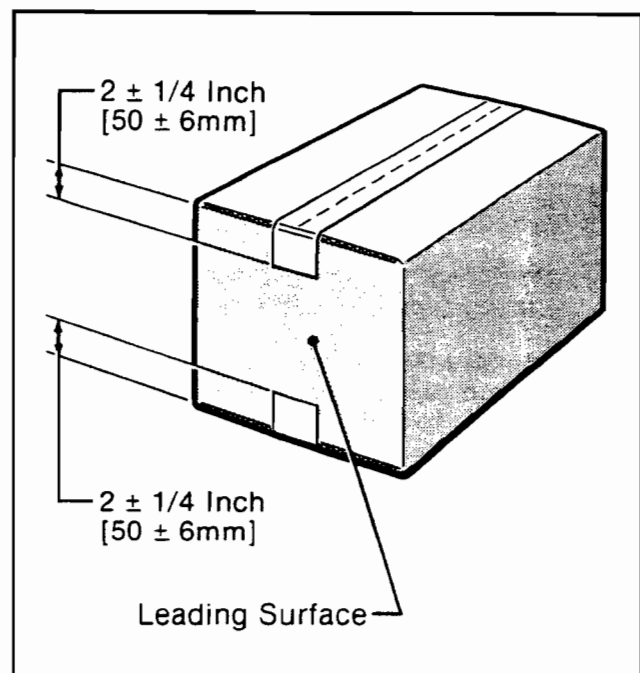


Figure 5-3 – Adjusting Tape Leg Length

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.

Changing Drive Belt Assembly Height (800a/800a3/800ab)

The drive belt assemblies can be raised 2 inches [50 mm] to provide better conveying of tall boxes. **This change increases the minimum box height that can be taped to 7-1/4 inches [190 mm].**

Figure 5-4 - Disassemble

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. Remove and retain the screw (A), cap washer (B) and spacer (C) from the front and rear arm assembly pivots.
3. Lift belt drive assembly (D) up off the arm assembly pivots.

Note - keep motor in vertical position to prevent gear oil from leaking out of motor.

Figure 5-5 - Reassemble

4. Reassemble the spacer (C) onto the front and rear arm assembly pivots first.
5. Install the belt drive assembly (D) onto the pivots and secure with the cap washers (B) and screws (A).

Note - Both drive belt assemblies are to be installed at the same operating height.

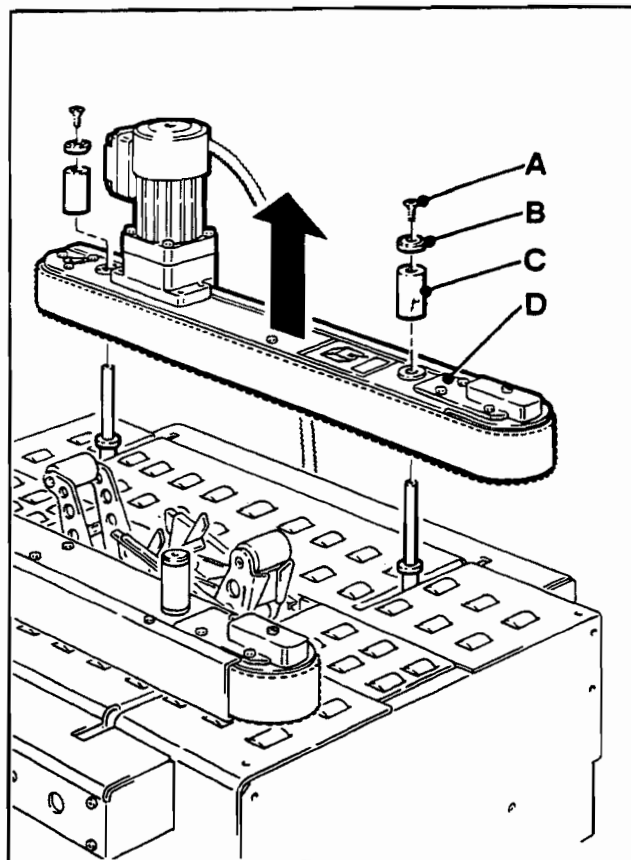


Figure 5-4 – Drive Belt Assembly – Case Sealer Disassembly

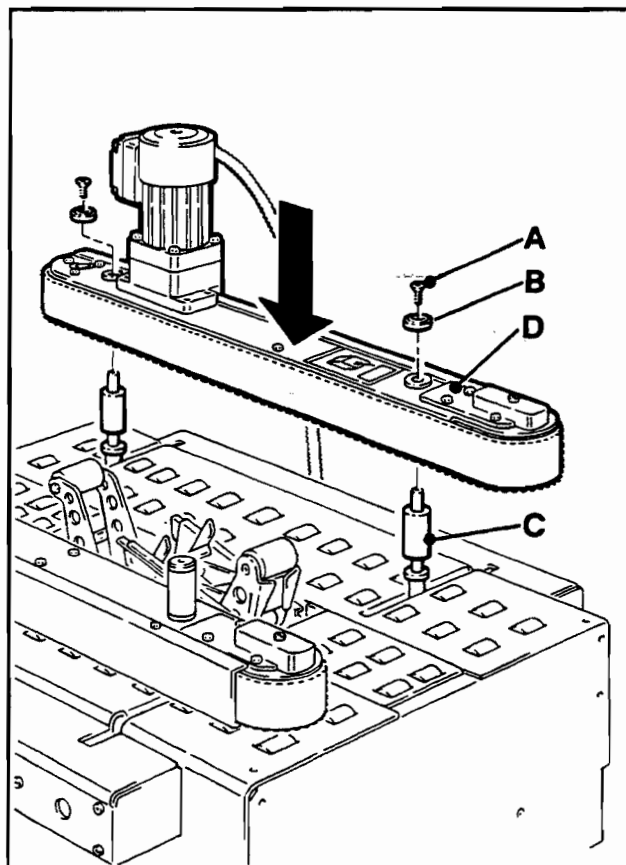


Figure 5-5 – Drive Belt Assembly – Case Sealer Reassembly

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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.

Troubleshooting Guide

Problem	Cause	Correction
Drive belts do not convey boxes	Narrow boxes	Check machine specifications. Boxes are narrower than recommended, causing slippage and premature belt wear.
	Worn drive belts	Replace drive belts
	Top taping head does not apply enough pressure	Adjust the box height adjustment with the crank
	Top flap compression rollers in too tight	Readjust compression rollers
	Taping head applying spring holder missing	Replace spring holder
	Taping head applying spring set too high	Reduce spring pressure
Drive belts do not turn	Worn or missing friction rings	Replace friction rings
	Drive belt tension too low	Adjust belt tension
	Electrical disconnect	Check power and electrical plug
	Circuit breaker not at correct setting	Set to correct current value
	Motor not turning	Evaluate problem and correct
Upper and lower applying mechanisms interfere with each other	Machine adjusted below minimum	Set taping heads to apply 2 inch leg lengths
Drive belt break	Worn belt	Replace belt
	Excessive belt tension	Tension to 7 lbs. per adjustment section
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
	Centering guides not centered	Adjust centering guides
	Box flaps not of equal length	Check box specifications

(Continued)

Troubleshooting (Continued)

Troubleshooting Guide

Problem	Cause	Correction
The tape leg on the front of the case is too long	The tape is threaded incorrectly	The tape must go around the wrap roller before going around the one-way tension roller
	The tape tension is too low	Adjust the one-way tension roller
	The knurled roller drags	Check for adhesive build-up between the knurled roller and its shaft. Clean and lubricate shaft. Remove all lubricant from roller surfaces.
	Tape tracks to one side or drags on the support tabs of applying frame	Adjust the tape web alignment
	The one-way tension roller is not correctly positioned	Position the roller in its mounting slot so that the tape extends just beyond the center line of the applying roller
	Taping head is not set up properly	Check leg length adjustments
The blade does not cut tape or the tape end is jagged or shredded	The blade is dull and/or has broken teeth	Replace the blade
	Tape tension is insufficient	Increase tape tension by adjusting the one-way roller
	Adhesive has build up on the blade	Clean and adjust the blade
	The blade is not positioned properly	Make sure the blade is bottomed out against the mounting bolts
	The blade is dry	Lubricate the blade oiler pad on the blade guard
	The blade is in backwards	Mount the blade so that the beveled edge is away from the entrance end of the head
	One or both cutter springs are missing or stretched	Replace the defective spring(s)
	Cut off force is insufficient.	Install an additional cutter spring.
	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 tailing leg on the back of the box	There is excess tension on the tape drum assembly and/or the one-way tension roller assembly	Adjust the one-way tension roller and/or the tape drum assembly
	Rollers in the tape path do not rotate freely	Clean adhesive deposits from the surface, ends, and shafts of the rollers. Then lubricate roller shafts. Remove all lubricant from roller surfaces.
	The blade is not cutting tape properly	Refer to tape cutting problems
	The tape is threaded incorrectly	Rethread the tape
	Applying mechanism spring has too little tension	Move spring hook to next tighter hole
The tape end does not stay in the application position in front of the applying roller	The tape is incorrectly threaded	Rethread the tape
	Flanged knurled roller overruns on return of applying mechanism to its rest position	Adjust tension roller position in mounting slot to lengthen tape leg
	Applying roller overruns on return of applying mechanism to its rest position	There should be a slight drag when rotating the applying roller. If not, check friction springs and/or friction pins and replace if necessary
	The one-way tension roller is not correctly positioned	Position roller in its mounting slot so that tape end extends beyond center line of applying roller
	The one-way tension roller is defective	Replace the one-way tension roller

ELECTRICAL DIAGRAM

(800a/800a3/800ab)



WARNING – TURN OFF ELECTRICAL POWER 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.

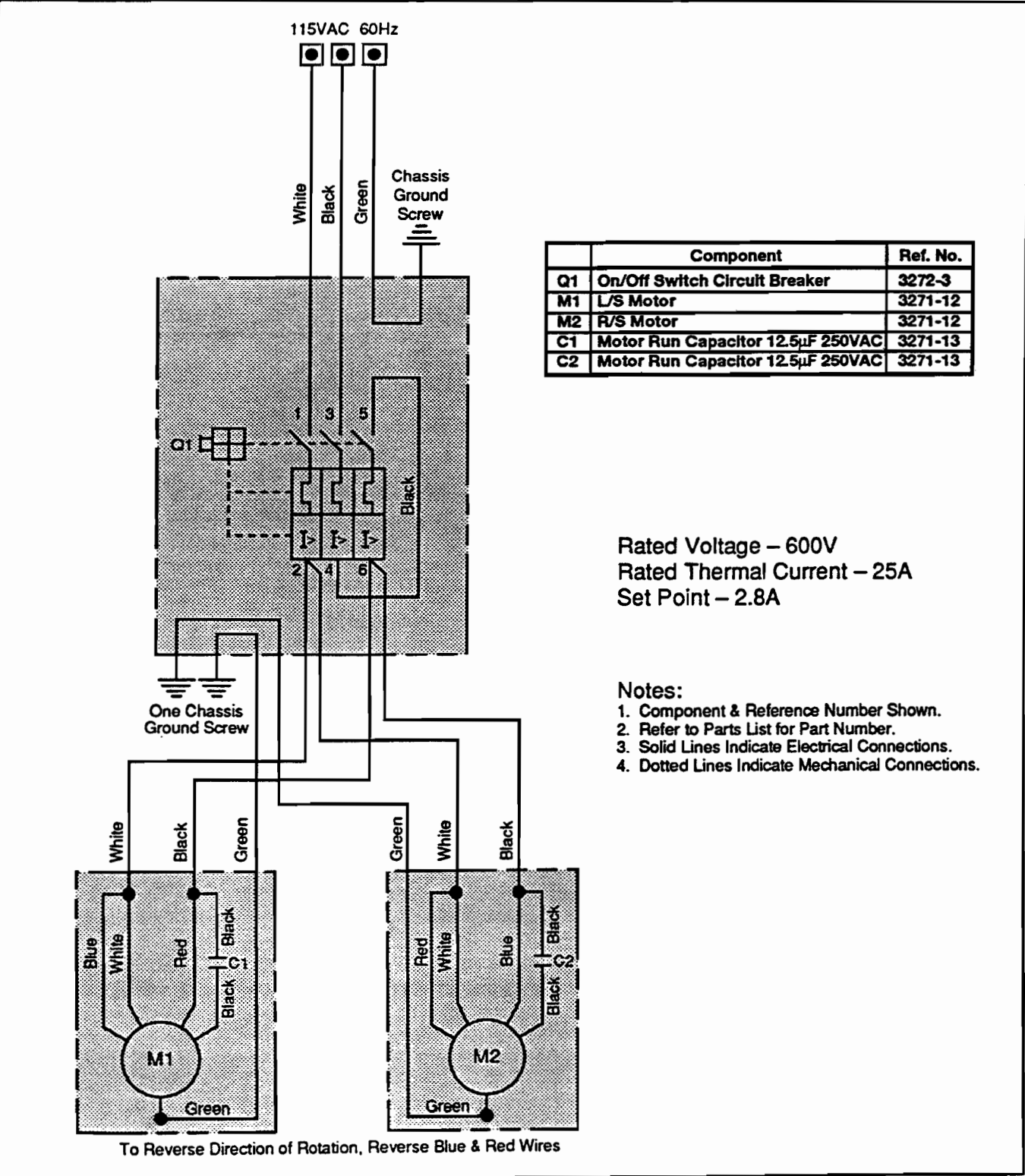


Figure 7 – Electrical Diagram

Replacement Parts And Service Information

Spare Parts – 800a

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

Qty.	Ref. No.	Part Number	Description
1	2880-15	78-8057-6179-4	Roller – Applying
1	2881-5	78-8057-6178-6	Roller – Buffing
1	2881-10	78-8070-1274-1	Spring – Upper Extension
1	2883-2	78-8017-9173-8	Blade – 2.56 Inch/65 mm
2	2883-6	78-8070-1390-5	Spring – Tension
2	2883-12	78-8052-6602-6	Spring – Cutter
1	2886-10	78-8070-1273-3	Spring – Lower Extension
2	3271-54	78-8076-5452-6	Belt – Drive W/Hook

Spare Parts – 800a3

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

Qty.	Ref. No.	Part Number	Description
1	2949-15	78-8057-6181-0	Roller – Applying
1	2955-5	78-8057-6180-2	Roller – Buffing
1	2881-10	78-8070-1274-1	Spring – Upper Extension
1	2952-2	78-8028-7899-7	Blade – 3.5 Inch/89 mm
2	2952-6	78-8070-1390-5	Spring – Tension
2	2883-12	78-8052-6602-6	Spring – Cutter
1	2886-10	78-8070-1273-3	Spring – Lower Extension
2	3271-54	78-8076-5452-6	Belt – Drive W/Hook

Spare Parts – 800ab

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

Qty.	Ref. No.	Part Number	Description
1	1145-6	78-8017-9101-9	Roller – Applying
1	1146-5	78-8017-9140-7	Roller – Buffing
2	1148-2	78-8017-9173-8	Blade – 2.56 Inch/65 mm
2	1148-10	78-8052-6602-6	Spring – Cutter
1	1198-11	78-8054-8550-1	Spring – Extension Bottom
1	2883-6	78-8070-1390-5	Spring – Tension
2	3417-54	78-8076-5452-6	Belt – Drive

A label kit, part number 78-8070-1666-8, is available as a stock item. It contains all the safety labels used on the 800a/800a3/800ab Adjustable Case Sealers.

A tool kit, part number 78-8060-8476-6, is also available as a stock item. The kit contains the necessary open end and hex socket wrenches for use with the metric fasteners on the case sealer. The threading tool, 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 \$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**

**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.

For Use On	Part Number	Option/Accessory
800a/800a3/800ab	78-8052-6553-1	Box Hold Down Attachment, Model 18500
800a/800a3/800ab	78-8060-7405-6	Caster Kit Attachment
800a/800a3/800ab	78-8069-3924-1	Conveyor Extension Attachment
800a	78-8059-3911-8	AccuGlide II STD Taping Head (Upper)
800a/800ab	78-8069-3912-6	AccuGlide II STD Taping Head (Lower)
800a3	78-8069-3913-4	AccuGlide II 3-Inch Taping Head (Upper)
800a3/800ab	78-8069-3914-2	AccuGlide II 3-Inch Taping Head (Lower)
800a/800a3	78-8079-5505-5	Three Flap Folder Kit

Replacement Parts – Illustrations and Parts Lists

800a Adjustable Case Sealer, Type 19200 (2 Inch Width Taping Head)

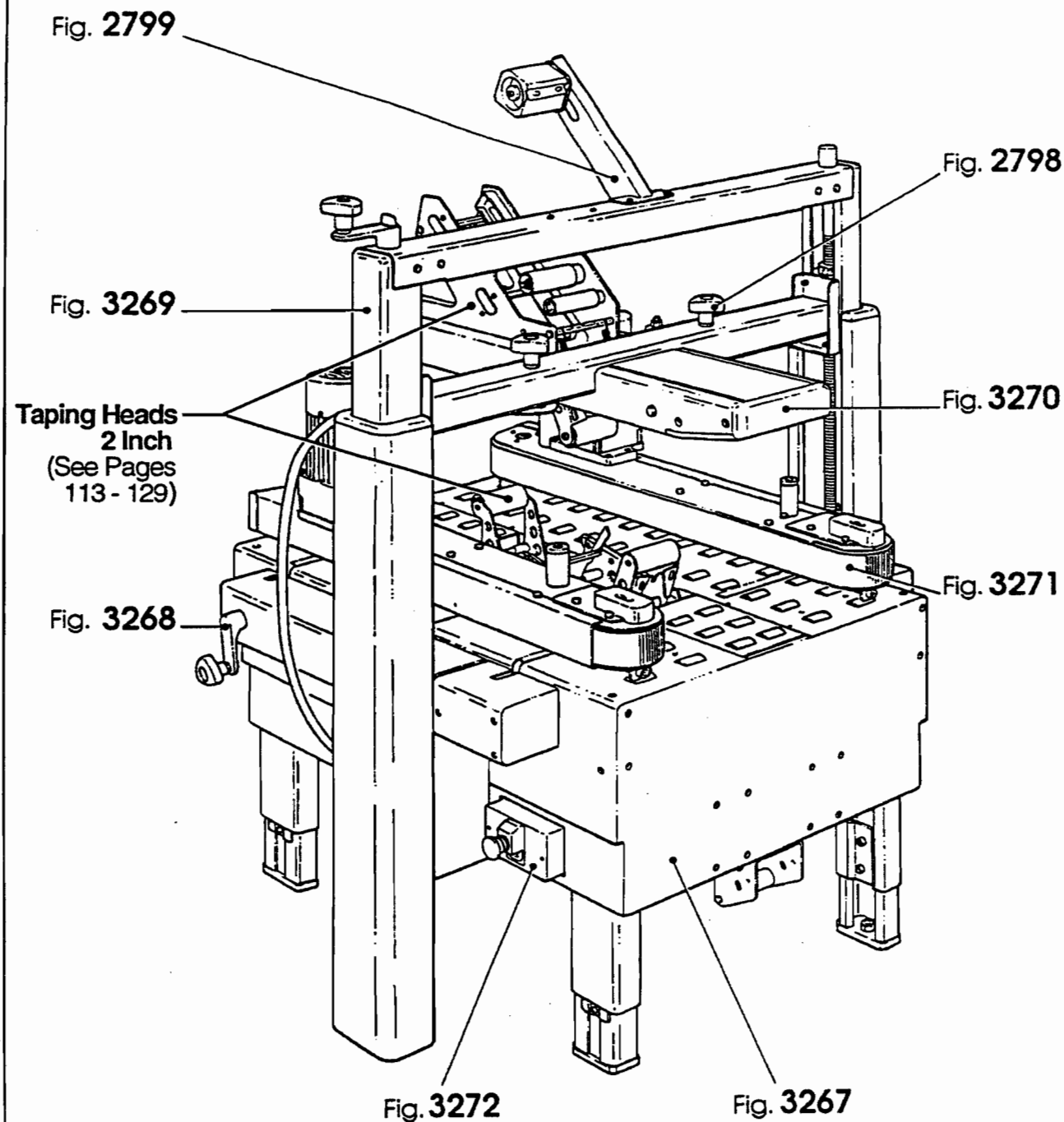
Frame Assemblies

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 38 – “**Replacement Parts and Service Information**” of this manual for replacement parts ordering information.

800a Adjustable Case Sealer (2 Inch Width Taping Heads)



Frame Assemblies

800a Adjustable Case Sealer

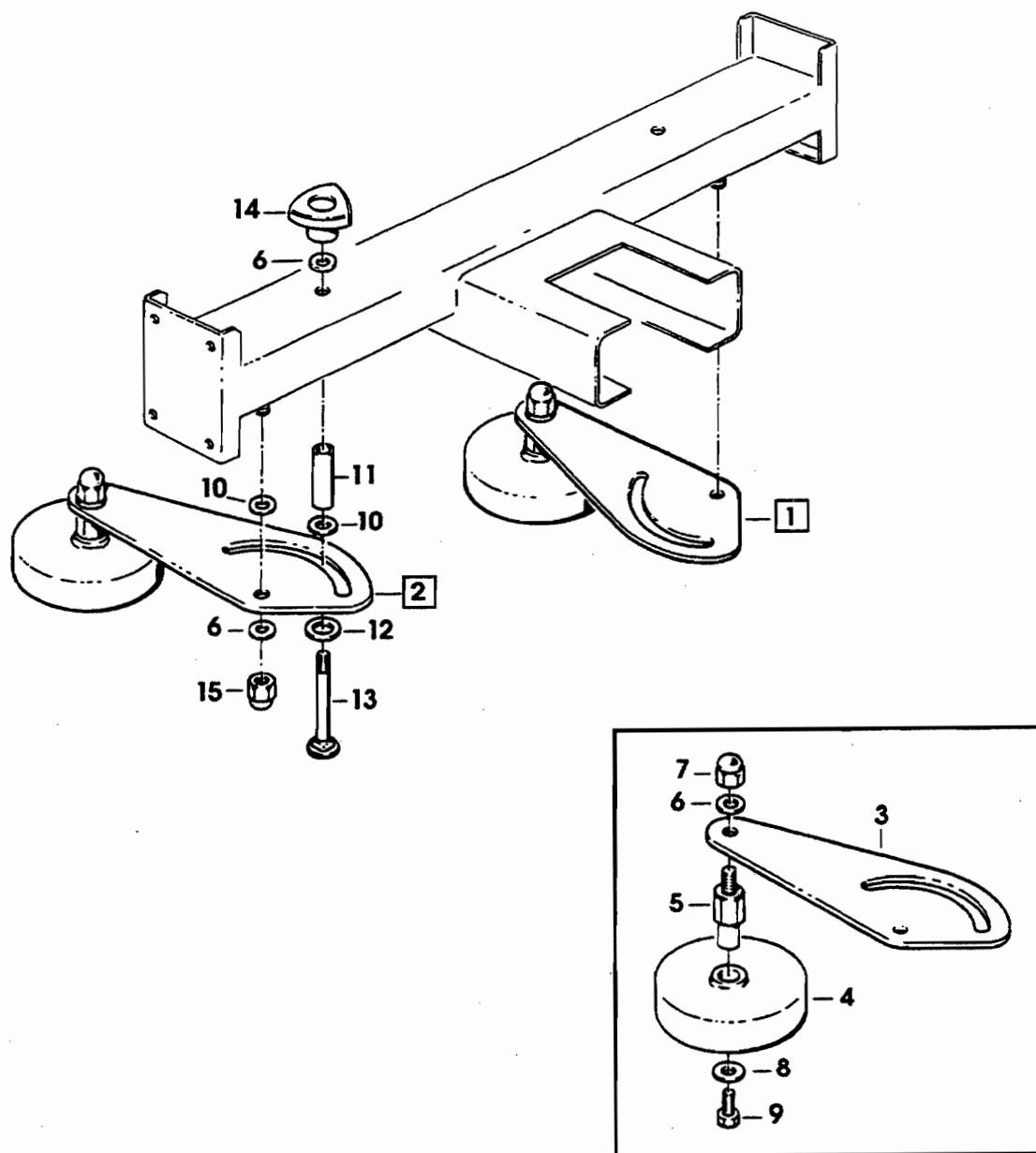


Figure 2798

Figure 2798

Ref. No.	3M Part No.	Description
2798-1	78-8070-1557-9	Compression Roller Assembly - Right
2798-2	78-8070-1558-7	Compression Roller Assembly - Left
2798-3	78-8070-1559-5	Support - Compression Roller
2798-4	78-8054-8648-3	Pressure Roller
2798-5	78-8070-1560-3	Stud - Roller Mounting
2798-6	78-8052-6566-3	Washer - Friction
2798-7	78-8070-1561-1	Nut - M10
2798-8	26-1004-5507-5	Washer - M8
2798-9	26-1003-5841-0	Screw - M8 x 16
2798-10	78-8017-9074-8	Washer - Nylon 15 mm
2798-11	78-8070-1562-9	Tube - Roller Support
2798-12	12-7991-1752-3	Washer - Plain M14
2798-13	78-8070-1563-7	Screw - M10 x 80
2798-14	78-8070-1549-6	Knob - VTR-B-M10
2798-15	26-1003-6918-5	Nut - Plastic Insert Hex M10

800a Adjustable Case Sealer

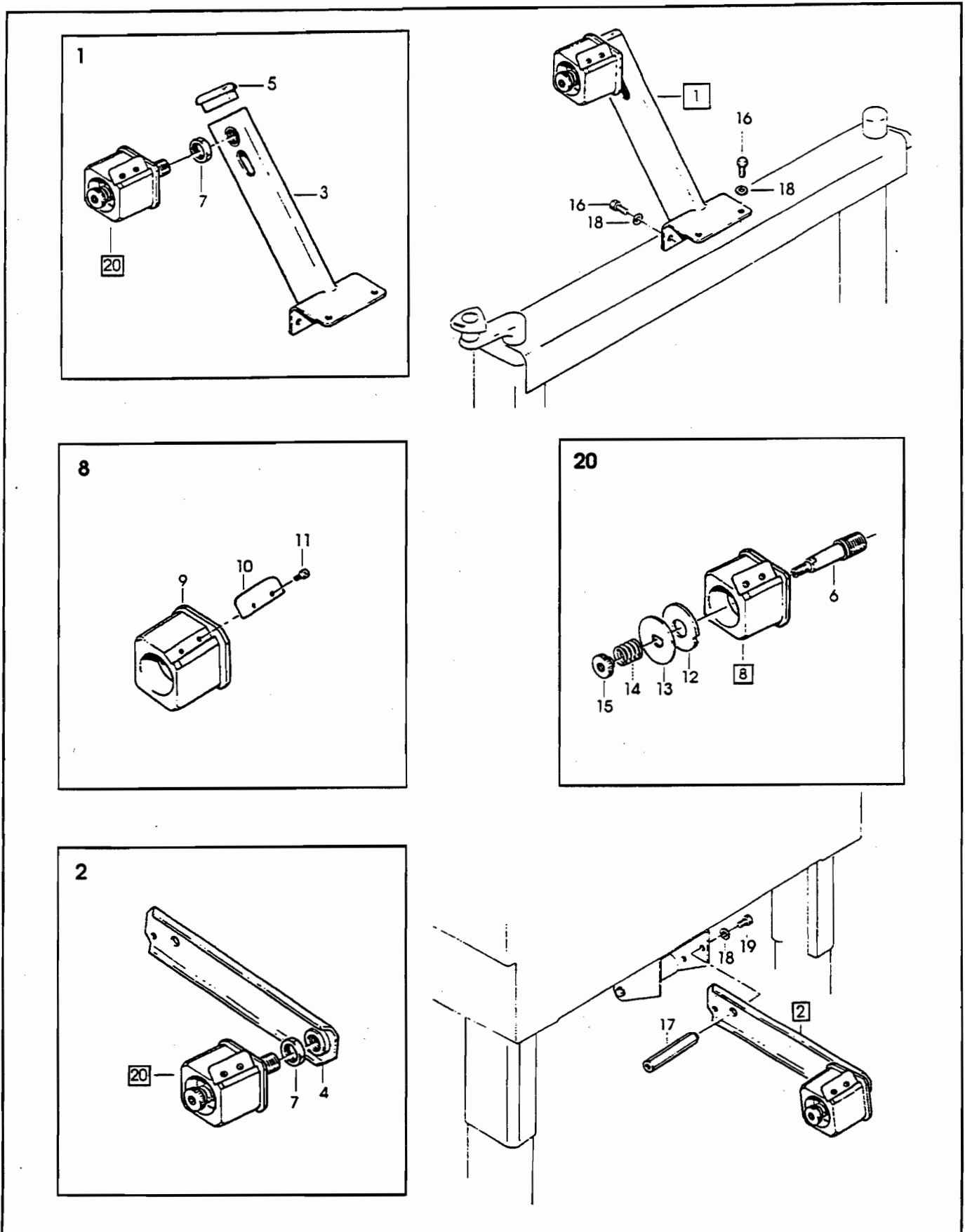


Figure 2799

Figure 2799

Ref. No.	3M Part No.	Description
2799-1	78-8070-1564-5	Tape Drum Bracket Assembly
2799-2	78-8070-1565-2	Tape Drum Bracket Assembly
2799-3	78-8070-1566-0	Bracket - Tape Drum
2799-4	78-8070-1395-4	Bracket - Bushing Assembly
2799-5	78-8070-1568-6	Cap - Bracket
2799-6	78-8076-4519-3	Shaft - Tape Drum
2799-7	78-8017-9169-6	Nut - M18 x 1
2799-8	78-8070-1569-4	Tape Drum Assembly - 2 Inch Wide
2799-9	78-8052-6749-5	Tape Drum Assembly
2799-10	78-8052-6268-6	Leaf Spring
2799-11	26-1002-5753-9	Screw - Self-Tapping
2799-12	78-8060-8172-1	Washer - Friction
2799-13	78-8052-6271-0	Washer - Tape Drum
2799-14	78-8054-8826-5	Spring
2799-15	78-8060-7851-1	Ring Nut - Adjusting
2799-16	78-8032-0375-7	Screw - Hex Hd, M6 x 16, Metric
2799-17	78-8070-1215-4	Spacer - Stud
2799-18	26-1000-0010-3	Washer - Flat M6
2799-19	78-8010-7169-3	Screw - Hex Hd, M6 x 12, Metric
2799-20	78-8060-8474-1	Tape Drum Assembly - 2 Inch Head

800a Adjustable Case Sealer

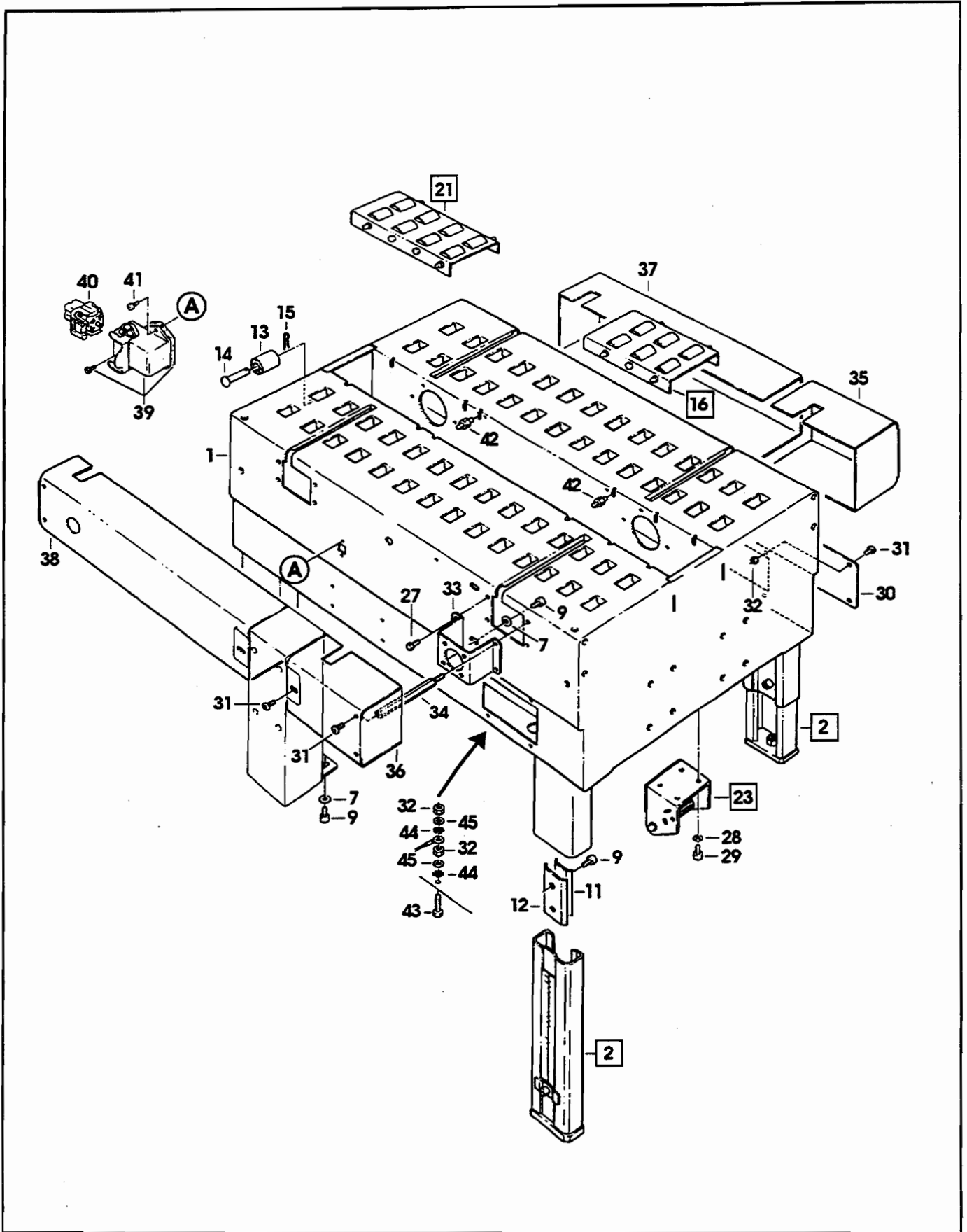


Figure 3267/1 of 2

Figure 3267 (page 1 of 2)

Ref. No.	3M Part No.	Description
3267-1	78-8076-5380-9	Bed - Conveyor
3267-2	78-8076-5381-7	Leg Assembly - Inner, W/Stop
3267-3	78-8076-5382-5	Leg - Inner
3267-4	78-8060-8480-8	Pad - Foot
3267-5	78-8055-0867-4	Screw - Hex Hd, M8 x 30
3267-6	78-8017-9313-0	Nut - Self-Locking, M8
3267-7	78-8017-9318-9	Washer - Plain 8 mm, Metric
3267-8	78-8076-5383-3	Stop - Leg
3267-9	26-1003-7963-0	Screw - Soc Hd, M8 x 16
3267-10	78-8060-8481-6	Label - Height
3267-11	78-8052-6676-0	Clamp - Outer
3267-12	78-8052-6677-8	Clamp - Inner
3267-13	78-8060-7693-7	Roller - 32 x 38
3267-14	78-8076-5384-1	Shaft - Roller
3267-15	78-8076-5385-8	Spring
3267-16	78-8076-5386-6	Conveyor Assembly - Front
3267-17	78-8076-5387-4	Conveyor - Front
3267-18	78-8076-5388-2	Shaft - Conveyor
3267-19	26-1003-5828-7	Screw - Hex Hd, M6 x 10
3267-20	78-8076-5389-0	Mounting - Conveyor
3267-21	78-8076-5390-8	Conveyor Assembly - Rear
3267-22	78-8076-5391-6	Conveyor - Rear
3267-23	78-8076-5392-4	Support - Tape Drum
3267-24	78-8060-8483-2	Support - Outboard Roll Mount
3267-25	78-8060-8484-0	Shaft - Roller
3267-26	78-8060-8485-7	Roller

800a Adjustable Case Sealer

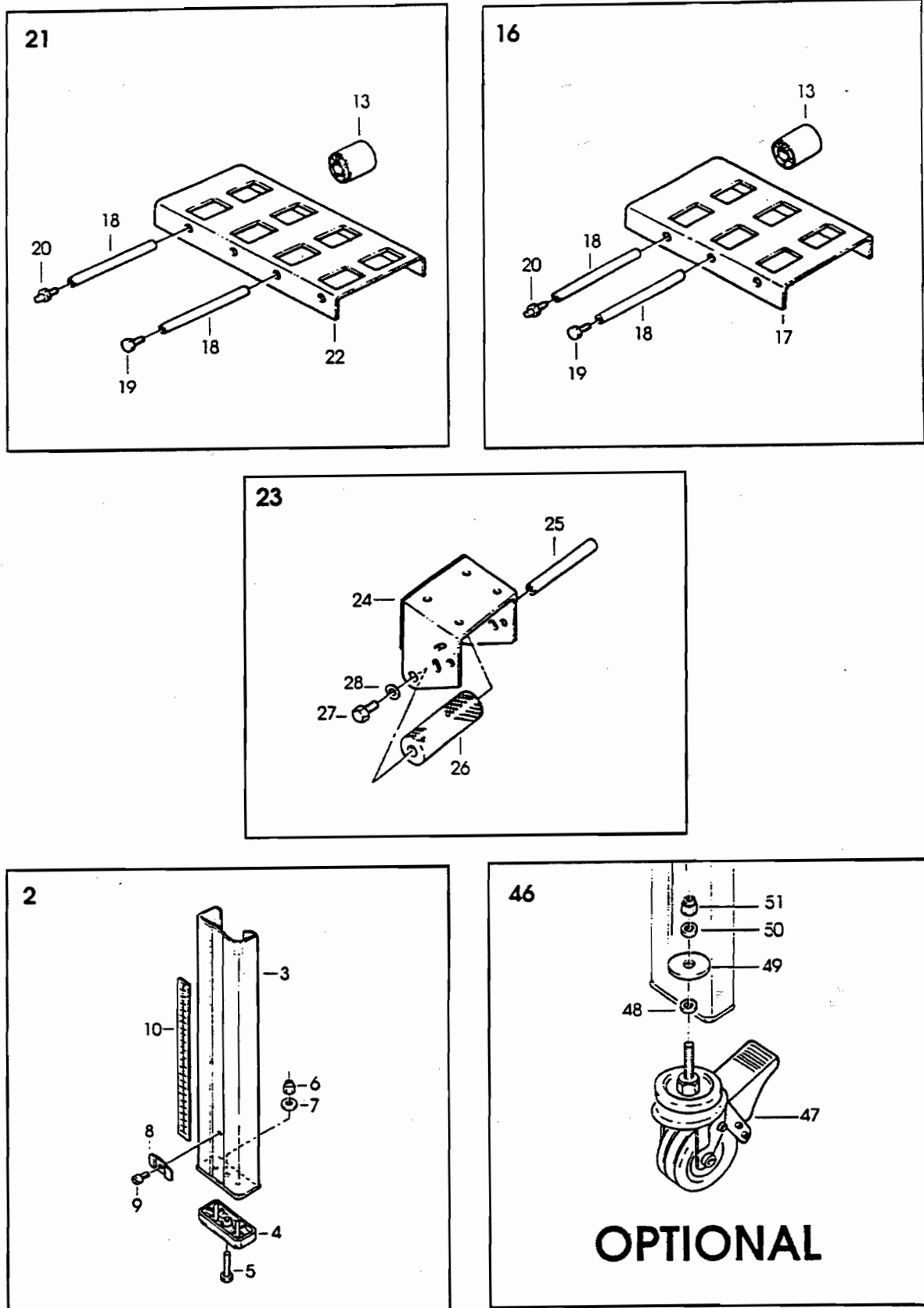


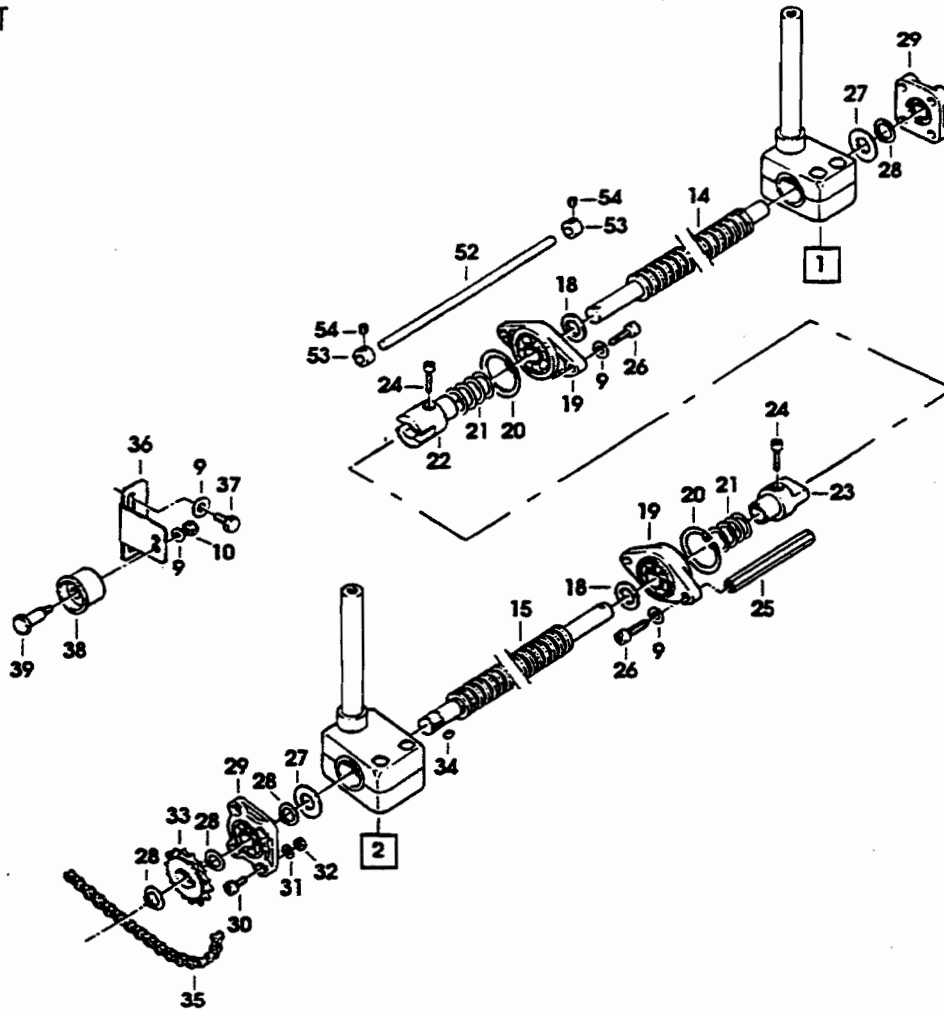
Figure 3267/2 of 2

Figure 3267 (page 2 of 2)

Ref. No.	3M Part No.	Description
3267-27	78-8032-0375-7	Screw - Hex Hd, M6 x 16, Metric
3267-28	26-1000-0010-3	Washer - Flat M6
3267-29	26-1003-7957-2	Screw - Soc Hd Hex Hd, M6 x 16
3267-30	78-8060-8487-3	Cover - Switch
3267-31	78-8060-8087-1	Screw - M5 x 10, Metric
3267-32	78-8010-7417-6	Nut - Hex M5, Metric
3267-33	78-8076-5393-2	Plate - Tape Bracket Support
3267-34	78-8076-5394-0	Spacer
3267-35	78-8076-5395-7	Cover - Side, Front, R/H
3267-36	78-8076-5396-5	Cover - Side, Front, L/H
3267-37	78-8076-5397-3	Cover - Side, Rear, R/H
3267-38	78-8076-5398-1	Cover - Side, Rear, L/H
3267-39	78-8060-7876-8	Cover - Plug Lateral
3267-40	78-8060-7873-5	Plug - Female
3267-41	78-8028-8208-0	Screw - 6P x 9,5
3267-42	78-8076-4991-4	Spacer
3267-43	78-8060-8488-1	Screw - Hex Hd, M5 x 20
3267-44	78-8046-8217-3	Washer - Special
3267-45	78-8005-5741-1	Washer - Plain M5, Metric
3267-46	78-8060-8060-8	Caster Assembly - /80
3267-47	78-8060-8061-6	Caster - /80
3267-48	78-8060-8124-2	Spacer - Caster
3267-49	78-8060-7699-4	Washer - /12-45, 5 x 4
3267-50	78-8017-9059-9	Washer - Flat For M12 Screw
3267-51	78-8060-7532-7	Nut - M12, Self-Locking

800a Adjustable Case Sealer

FRONT



• = Pos.3 and 4
to be ordered
always together

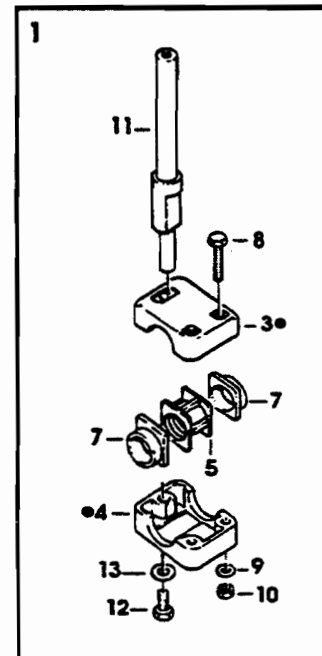
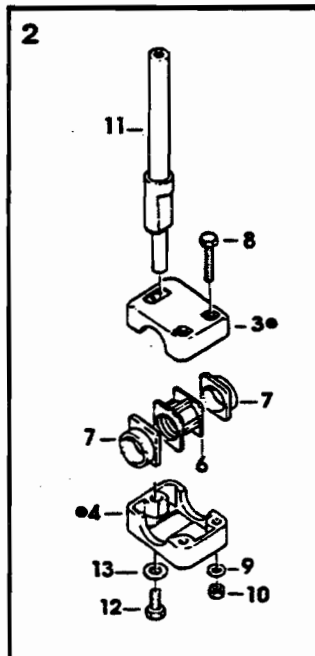


Figure 3268/1 of 2

Figure 3268 (page 1 of 2)

Ref. No.	3M Part No.	Description
3268-1	78-8076-5399-9	Block Assembly – R/H
3268-2	78-8076-5400-5	Block Assembly – L/H
3268-3	78-8076-5401-3	Block – Upper
3268-4	78-8076-5402-1	Block – Lower
3268-5	78-8076-5403-9	Nut – Block, R/H
3268-6	78-8076-5404-7	Nut – Block, L/H
3268-7	78-8076-5405-4	Bushing – Block
3268-8	78-8076-5239-7	Screw – Hex Hd, M6 x 50
3268-9	26-1000-0010-3	Washer – Flat M6
3268-10	26-1003-6916-9	Nut – Locking, Plastic Insert M6
3268-11	78-8076-5406-2	Shaft – Drive Mount
3268-12	26-1003-5842-8	Screw – Hex Hd, M8 x 20
3268-13	78-8017-9318-9	Washer – Plain 8 mm, Metric
3268-14	78-8076-5407-0	Screw – R/H
3268-15	78-8076-5408-8	Screw – L/H
3268-16	78-8076-5409-6	Screw – Handle, R/H
3268-17	78-8076-5410-4	Screw – Handle, L/H
3268-18	78-8076-5411-2	Spacer – Screw
3268-19	78-8076-5412-0	Flange – W/Bearing
3268-20	78-8060-8010-3	Snap Ring – 42 mm Shaft
3268-21	78-8076-5413-8	Spring
3268-22	78-8076-5414-6	Coupling – Screw
3268-23	78-8076-5415-3	Coupling – Female, Screw
3268-24	26-1003-7946-5	Screw – Soc Hd, M4 x 25
3268-25	78-8076-5416-1	Spacer – Hex, 10 x 107
3268-26	78-8010-7211-3	Screw – Soc Hd, M6 x 25
3268-27	78-8076-5417-9	Spacer

800a Adjustable Case Sealer

REAR

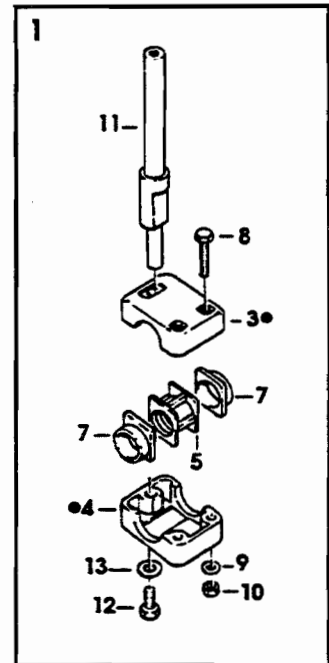
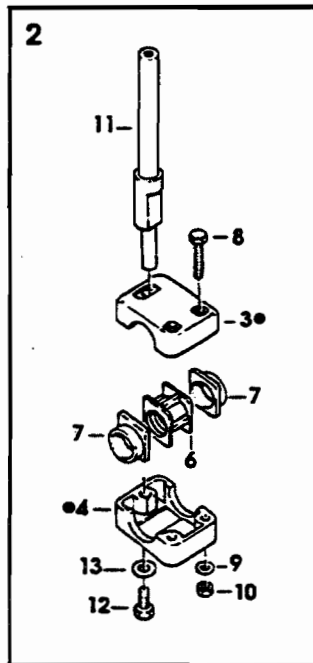
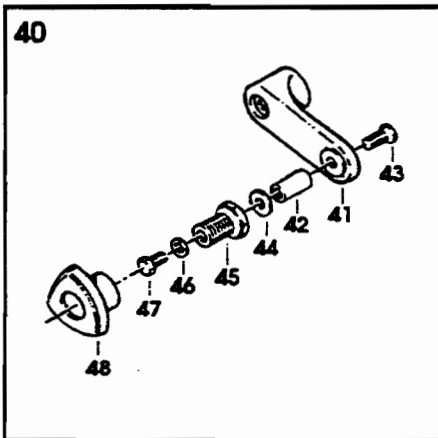
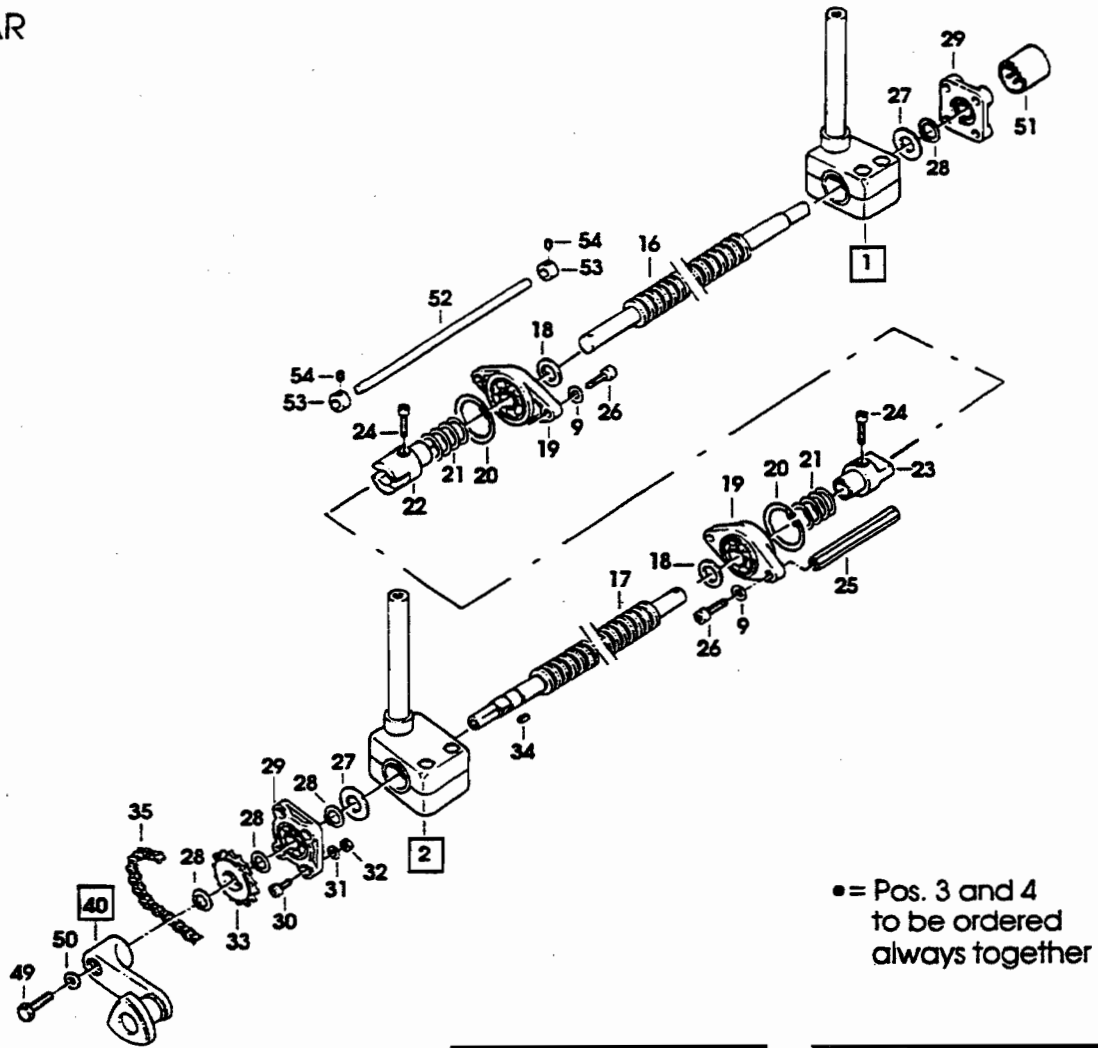


Figure 3268/2 of 2

Figure 3268 (page 2 of 2)

Ref. No.	3M Part No.	Description
3268-28	78-8017-9079-7	Ring - Snap For 15 mm Shaft
3268-29	78-8076-5418-7	Support - Screw
3268-30	26-1003-7949-9	Screw - Soc Hd Hex Soc, M5 x 12
3268-31	78-8005-5741-1	Washer - Plain M5, Metric
3268-32	78-8010-7417-6	Nut - Hex M5, Metric
3268-33	78-8076-5419-5	Sprocket - 3/8 Inch Z=16
3268-34	78-8046-8135-7	Key - 5 x 5, 12 mm
3268-35	78-8076-5420-3	Chain - 3/8 Inch, 133 Pitch
3268-36	78-8076-5421-1	Support - Tension Roller
3268-37	78-8010-7169-3	Screw - Hex Hd, M6 x 12, Metric
3268-38	78-8070-1503-3	Roller - Chain Tensioning
3268-39	78-8060-7878-4	Idler Screw
3268-40	78-8076-4807-2	Crank Assembly
3268-41	78-8076-5422-9	Crank Assembly
3268-42	78-8070-1509-0	Shaft - Crank
3268-43	26-1005-5316-8	Screw - Flat Hd Hex Dr, M5 x 16
3268-44	78-8070-1510-8	Washer - Nylon, 7 x 15 x 1
3268-45	78-8070-1511-6	Bushing
3268-46	78-8005-5740-3	Washer - Plain 4 mm, Metric
3268-47	78-8010-7157-8	Screw - Hex Hd, M4 x 10
3268-48	78-8070-1512-4	Knob - VTR-B-M12
3268-49	78-8032-0375-7	Screw - Hex Hd, M6 x 16, Metric
3268-50	78-8076-4809-8	Washer - Crank
3268-51	78-8070-1506-6	Cover - Screw
3268-52	78-8076-5423-7	Shaft
3268-53	78-8076-5424-5	Block
3268-54	78-8076-5425-2	Set Screw - M4 x 3

800a Adjustable Case Sealer

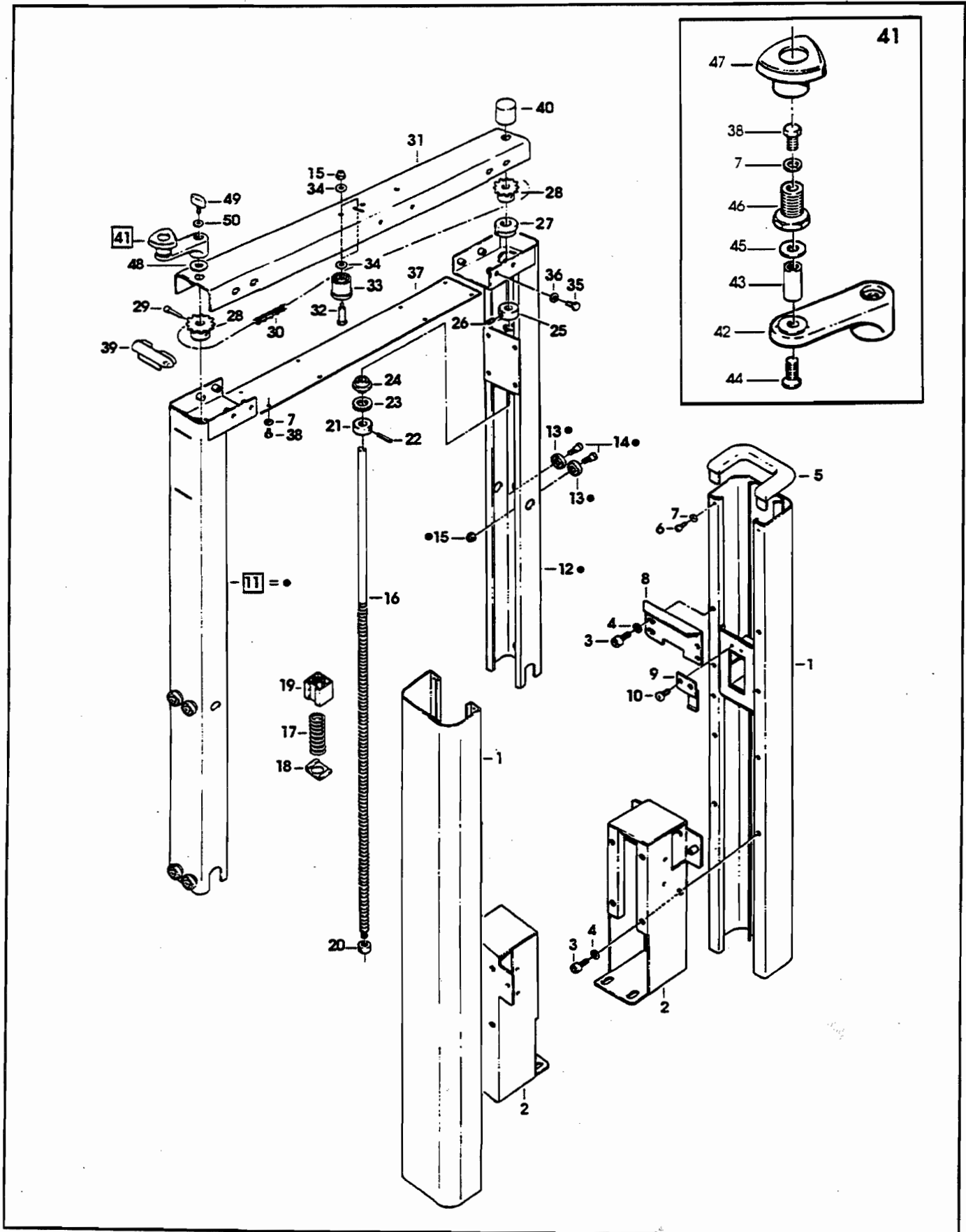


Figure 3269

Figure 3269

Ref. No.	3M Part No.	Description
3269-1	78-8060-8489-9	Column - Outer
3269-2	78-8076-5426-0	Plate
3269-3	26-1003-7964-8	Screw - Soc Hd, M8 x 20
3269-4	78-8017-9318-9	Washer - Plain 8 mm, Metric
3269-5	78-8060-8491-5	Cap - Column
3269-6	26-1002-4955-1	Screw - Self-Tap, 8P x 13
3269-7	78-8005-5740-3	Washer - Plain 4 mm, Metric
3269-8	78-8060-8492-3	Stop - Height
3269-9	78-8076-5482-3	Plate - Nut Stop
3269-10	78-8060-8087-1	Screw - M5 x 10, Metric
3269-11	78-8060-8494-9	Column Assembly - Inner
3269-12	78-8060-8495-6	Column - Inner
3269-13	78-8054-8617-8	Bearing - Special
3269-14	78-8054-8589-9	Screw - Special
3269-15	26-1003-6916-9	Nut - Locking, M6, Plastic Insert
3269-16	78-8060-8496-4	Lead Screw
3269-17	78-8054-8969-3	Spring
3269-18	78-8054-8970-1	Bed Plate For Spring
3269-19	78-8054-8571-7	Nut - Plastic
3269-20	78-8054-8968-5	Nut - Special
3269-21	78-8054-8585-7	Collar
3269-22	78-8054-8586-5	Pin
3269-23	78-8054-8584-0	Spacer
3269-24	78-8054-8583-2	Bushing
3269-25	78-8060-8497-2	Bushing - Lead Screw
3269-26	78-8059-5617-0	Set Screw - M6 x 8
3269-27	78-8060-8498-0	Bushing - Inner Column
3269-28	78-8060-8499-8	Sprocket - 3/8 Inch, Z=13
3269-29	78-8070-1500-9	Screw - Soc Hd Hex Hd, M4 x 25
3269-30	78-8076-4818-9	Chain - 3/8 Inch, Pitch 197
3269-31	78-8076-5427-8	Housing - Chain
3269-32	78-8060-7878-4	Idler Screw
3269-33	78-8070-1503-3	Roller - Chain Tensioning
3269-34	78-8042-2919-9	Washer - Triple, M6
3269-35	26-1003-5829-5	Screw - Hex Hd, M6 x 12
3269-36	26-1000-0010-3	Washer - Flat M6
3269-37	78-8076-5428-6	Cover
3269-38	78-8010-7157-8	Screw - Hex Hd, M4 x 10
3269-39	78-8070-1505-8	Cap - Inner Column
3269-40	78-8070-1506-6	Cover - Screw
3269-41	78-8076-4807-2	Crank Assembly
3269-42	78-8076-5422-9	Crank Assembly
3269-43	78-8070-1509-0	Shaft - Crank
3269-44	26-1005-5316-8	Screw - Flat Hd Hex Dr, M5 x 16
3269-45	78-8070-1510-8	Washer - Nylon, 7 x 15 x 1
3269-46	78-8070-1511-6	Bushing
3269-47	78-8070-1512-4	Knob - VTR-B-M12
3269-48	78-8076-4800-7	Washer - Crank
3269-49	78-8076-4821-3	Key - Stop
3269-50	78-8076-4809-8	Washer - Crank

[illegible]

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Figure 3270

Ref. No.	3M Part No.	Description
3270-1	78-8091-0664-0	Cross Bar – Lower
3270-2	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
3270-3	26-1000-0010-3	Washer – Flat M6
3270-4	78-8076-5430-2	Frame – R/H
3270-5	78-8076-5431-0	Frame – L/H
3270-6	26-1003-5842-8	Screw – Hex Hd, M8 x 20
3270-7	78-8017-9318-9	Washer – Plain, 8mm, Metric
3270-8	26-1000-1347-8	Nut – Hex, M8, Metric
3270-9	78-8070-1574-4	Slide – Front, Right
3270-10	78-8070-1575-1	Slide – Front, Left
3270-11	78-8070-1576-9	Slide – Rear, Right
3270-12	78-8070-1577-7	Slide – Rear, Left
3270-13	78-8070-1553-8	Spacer
3270-14	78-8070-1554-6	Stud
3270-15	78-8060-7693-7	Roller – 32 x 38
3270-16	26-1005-5316-8	Screw – Flat Hex Hd Dr, M5 x 16
3270-17	78-8070-1555-3	Block – Upper Head
3270-18	78-8076-4517-7	End Cap – 22 x 1
3270-19	78-8070-1556-1	Cover
3270-20	78-8076-4991-4	Spacer
3270-21	78-8076-4978-1	Cover – Lower

This diagram is an exploded view of a mechanical assembly, likely a motor-driven actuator or pump. The main components are shown in their relative positions as they would be assembled. The parts are numbered as follows:

- Motor/Actuator:** 12-13 (main body), 55 (top cap), 57 (flexible cable), 56 (cable connector), 60 (base connector), 61 (terminal block).
- Mounting and Structural Components:** 47 (bracket), 49 (plate), 48 (flange), 50 (screw), 11 (screw), 8 (screw), 9 (screw), 10 (plate), 14 (screw), 16 (pin), 46 (screw), 43 (screw), 47 (screw), 44-45 (long structural rail), 42 (block), 39 (screw), 38 (plate), 41 (screw), 40 (screw).
- Gears and Shafts:** 23 (gear assembly), 7 (shaft), 15 (pin), 17 (gear), 19 (pin), 32 (gear), 33 (gear), 21 (gear), 22 (gear), 18 (gear), 20 (gear), 21 (gear), 22 (gear), 51-52 (base plate), 53 (screw).
- Other Components:** 59 (connector), 58 (cable), 65 (nut), 54 (cylindrical component), 34 (cylindrical component), 3-4 (base plate).

The diagram includes two inset boxes: one showing a close-up of the cable connection (58, 59) and another showing a detail of a mounting plate (65) with a hole.

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Figure 3271 (page 1 of 2)

Ref. No.	3M Part No.	Description
3271-1	78-8076-5432-8	Drive Assembly – R/H, W/O Motor
3271-2	78-8076-5433-6	Drive Assembly – L/H, W/O Motor
3271-3	78-8076-5434-4	Guide – Lower, R/H
3271-4	78-8076-5435-1	Guide – Lower, L/H
3271-5	78-8076-5436-9	Guide – Upper, R/H
3271-6	78-8076-5437-7	Guide – Upper, L/H
3271-7	78-8055-0661-1	Spacer
3271-8	26-1003-5829-5	Screw – Hex Hd, M6 x 12
3271-9	26-1000-0010-3	Washer – Flat M6
3271-10	78-8076-4856-9	Support – Bodine Gearmotor
3271-11	78-8010-7211-3	Screw – Soc Hd, M6 x 25
3271-12	78-8076-4857-7	Gearmotor – Bodine 481 <i>5/8</i>
3271-13	26-1006-7631-6	Capacitor 12.5 – 250V
3271-14	78-8070-1523-1	Screw – 1/4 - 28 x 1/2 SHCS
3271-15	78-8076-5438-5	Extension <i>5/8 Bore</i>
3271-16	78-8057-5739-6	Key – M5 x 5 x 30 mm
3271-17	78-8076-5439-3	Flange Assembly
3271-18	78-8060-7886-7	Screw – Hex Hd, M6 x 16, Special
3271-19	78-8046-8135-7	Key – 5 x 5, 12 mm
3271-20	78-8076-4860-1	Sprocket – 3/8 Inch Z=17
3271-21	78-8057-5834-5	Tab Washer
3271-22	78-8057-5835-2	Centering Washer
3271-23	78-8076-5440-1	Pulley Assembly – Drive
3271-24	78-8091-0716-8	Roller – Drive
3271-25	78-8052-6713-1	Ring – Polyurethane
3271-26	78-8055-0669-4	Shaft – Pulley Keyed
3271-27	78-8057-5739-6	Key – M5 x 5 x 30 mm
3271-28	78-8055-0668-6	Washer – 15/26 x 1
3271-29	78-8076-5442-7	Flange Assembly
3271-30	26-0001-5862-1	Screw – Flat Hd Soc, M5 x 12
3271-31	78-8054-8877-8	Washer – 5,5/20 x 4
3271-32	78-8076-4861-9	Sprocket – 3/8 Inch Z=20
3271-33	78-8076-4933-6	Chain – 3/8 Inch Pitch, 52 Pitch

800a Adjustable Case Sealer

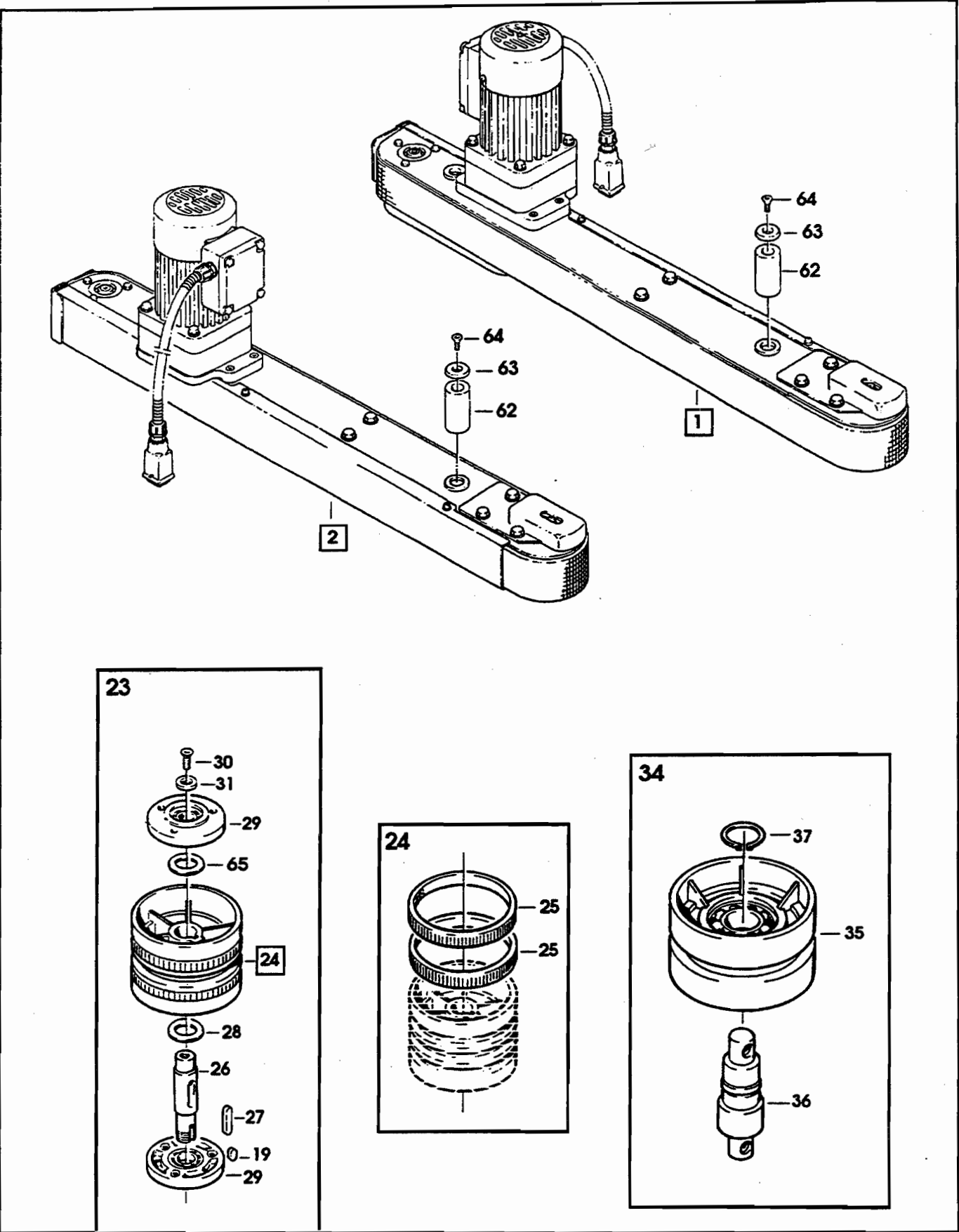


Figure 3271/2 of 2

Figure 3271 (page 2 of 2)

Ref. No.	3M Part No.	Description
3271-34	78-8076-5443-5	Pulley Assembly – Idler
3271-35	78-8055-0660-3	Roller – Idler
3271-36	78-8076-5444-3	Shaft – Idler Pulley
3271-37	12-7997-0272-0	E-Ring – M-25
3271-38	78-8076-5445-0	Tensioning – Belt
3271-39	78-8076-5446-8	Washer – Shaft
3271-40	78-8076-5447-6	Screw – Special, M8 x 70
3271-41	78-8017-9318-9	Washer – Plain 8mm, Metric
3271-42	78-8076-5448-4	Cover – Belt Tensioner
3271-43	78-8055-0850-0	Screw – Cap, M4 x 6
3271-44	78-8076-5449-2	Cover – Drive, R/H
3271-45	78-8076-5450-0	Cover – Drive, L/H
3271-46	26-1002-5753-9	Screw – Self-Tapping
3271-47	78-8005-5740-3	Washer – Plain 4 mm, Metric
3271-48	78-8055-0650-4	Guard – Belt
3271-49	78-8076-5451-8	Guard – Belt
3271-50	26-1002-4955-1	Screw – Self-Tap 8P x 13
3271-51	78-8076-4866-8	Cover – Right
3271-52	78-8076-4867-6	Cover – Left
3271-53	78-8010-7165-1	Screw – Flat Hd Soc, M5 x 25
3271-54	78-8076-5452-6	Belt – Box Drive
3271-55	78-8076-4954-2	Union – PG 13.5
3271-56	78-8060-7626-7	Connector – PG 11/12
3271-57	78-8076-5197-7	Sleeving – /12, 800 mm
3271-58	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
3271-59	78-8076-4602-7	Terminal
3271-60	78-8060-7877-6	Plug Housing – Vertical
3271-61	78-8060-7875-0	Plug – Male
3271-62	78-8076-5453-4	Roller
3271-63	78-8054-8577-4	Washer – Special
3271-64	26-1001-9843-6	Screw – Flat Soc Hd, M6 x 16
3271-65	78-8091-0500-6	Bushing – Side Drive
3271-66	78-8091-0382-9	Washer – Belleville /16

This diagram illustrates the assembly of a power supply unit. The components are numbered as follows:

- 1**: The main power supply unit housing, featuring a cooling fan on the left side.
- 2**: A metal mounting bracket with multiple screw holes for securing the unit.
- 3**: A terminal block used for connecting the power and ground wires.
- 4**: Screws used to secure the terminal block and other components to the mounting bracket.
- 5**: A cable strain relief or connector that fits into the back of the power supply unit.
- 6**: A cable passing through the strain relief.
- 7**: A power cord with a standard three-prong AC plug.
- 8**: A metal plate or cover that fits over the top of the power supply unit.
- 9**: Screws used to secure the top cover plate.
- 10**: A small screw or pin used for additional mounting or alignment.
- 11**: A screw used to secure the side of the power supply unit.

The diagram shows the power supply unit (1) being mounted onto the bracket (2) using screws (4). The terminal block (3) is also mounted to the bracket. The cable strain relief (5) is inserted into the back of the unit, and the power cord (7) is attached. The top cover plate (8) is then secured with screws (9). The side of the unit is secured with screw (11). The cable (6) is shown passing through the strain relief (5).

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Figure 3272

Ref. No.	3M Part No.	Description
3272-1	78-8076-5454-2	On/Off Switch Assembly - 2.5/4 A.
3272-2	78-8076-4879-1	Box - On/Off Switch
3272-3	78-8076-4877-5	Switch - On/Off 2,5-4 A.
3272-4	78-8076-5455-9	E-Stop Button
3272-5	78-8057-5807-1	Cord Grip
3272-6	78-8060-8053-3	Wire - 3-Pole, 5 Meters Length
3272-7	78-8028-7909-4	Power Cord U.S.A.
3272-8	78-8076-5456-7	Support - Switch
3272-9	26-1003-5707-3	Screw - Phillips Dr, M4 x 16
3272-10	26-1003-6914-4	Nut - Plastic Inset, M4
3272-11	78-8060-8087-1	Screw - M5 x 10, Metric

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Replacement Parts - Illustrations and Parts Lists

800a3 Adjustable Case Sealer, Type 19200 (3 Inch Width Taping Head)

Frame Assemblies

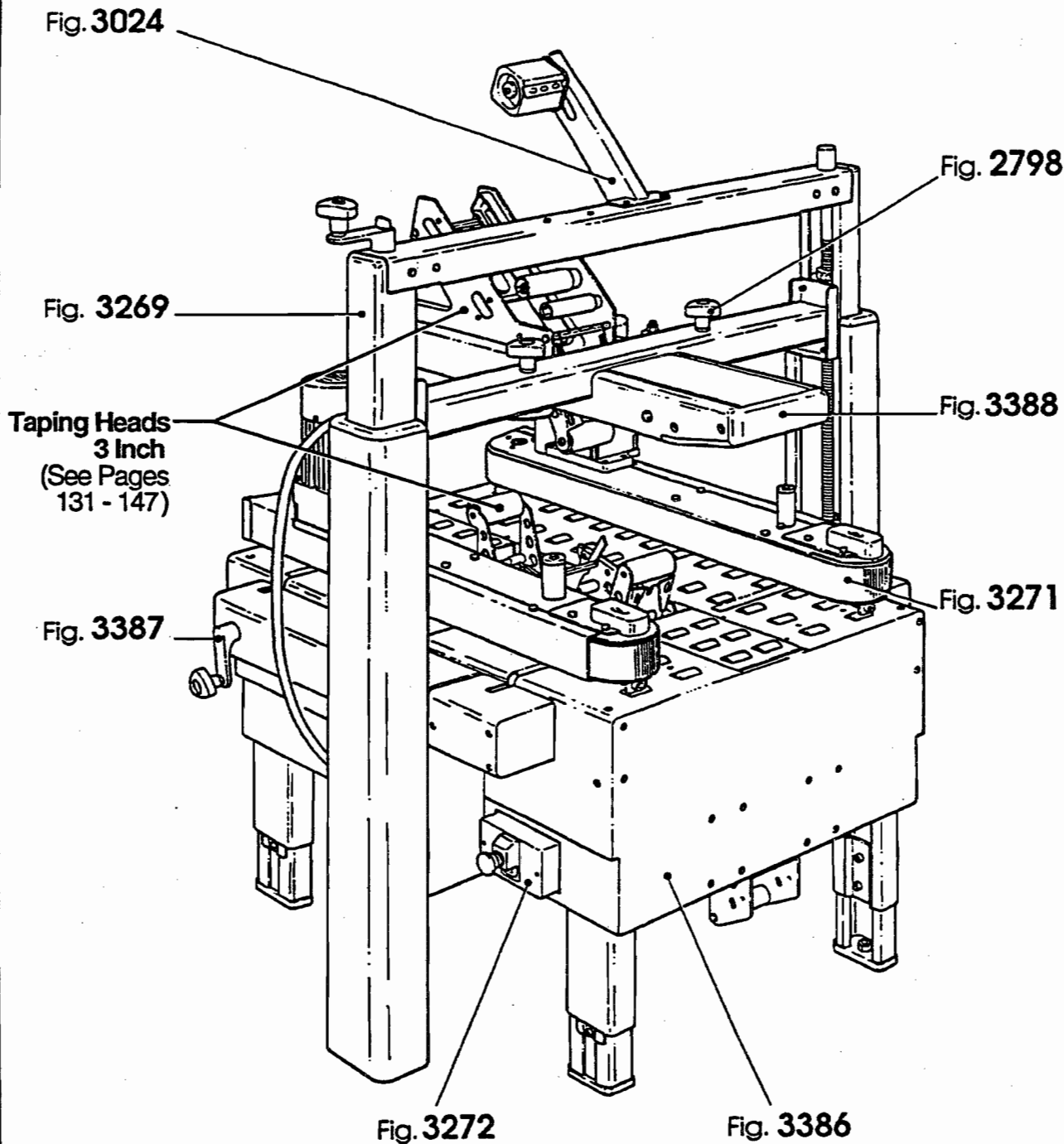
1. Refer to **Frame Assemblies** figure to find all the parts illustrations identified by **figure numbers**.
2. Refer to the figure or figures to determine the **individual parts** required and the **parts reference number**.
3. The **replacement parts list**, that follows each illustration, includes 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 38 - "**Replacement Parts and Service Information**" of this manual for replacement parts ordering information.

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800a3 Adjustable Case Sealer (3 Inch Taping Heads)



800a3 Adjustable Case Sealer

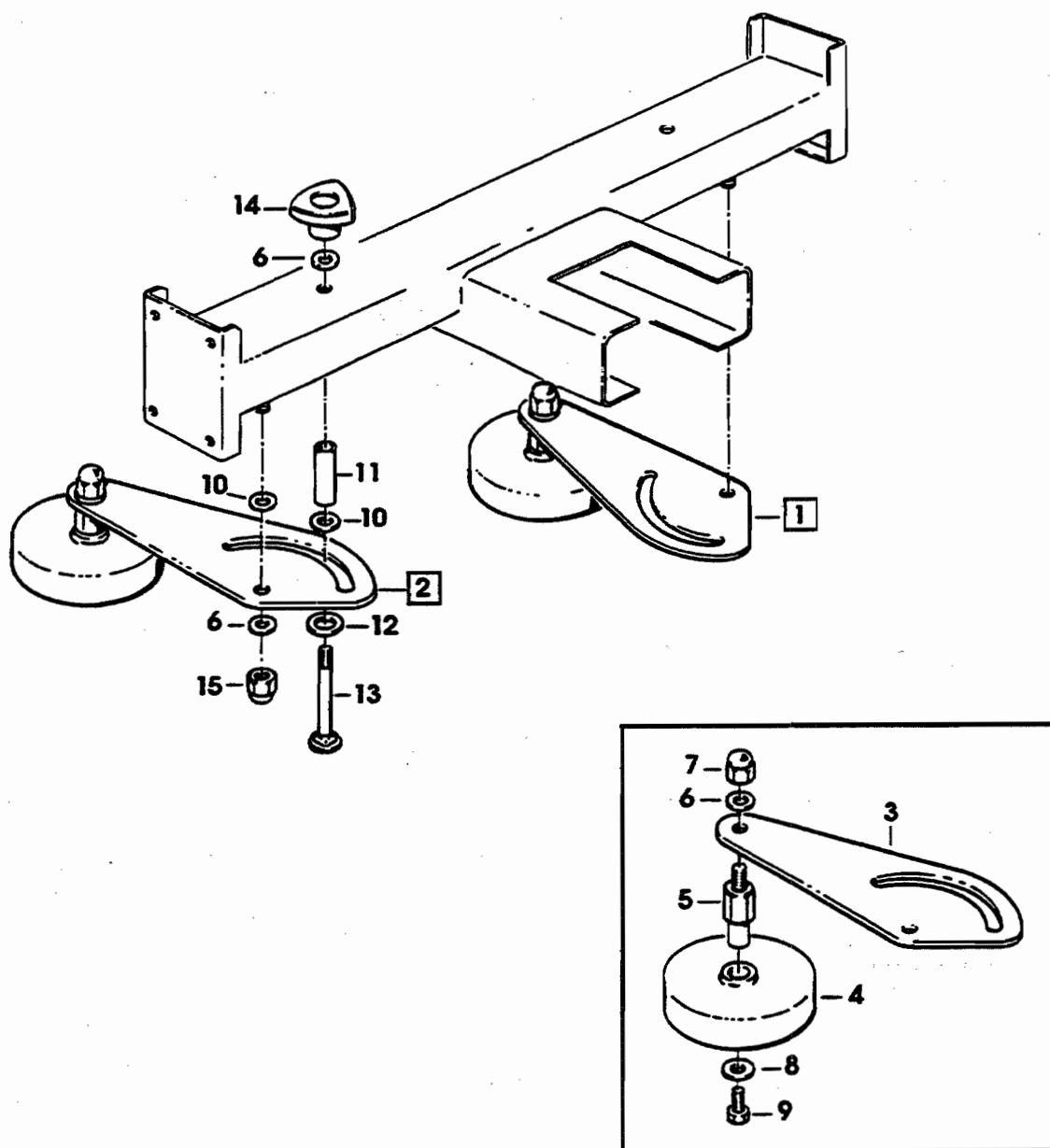


Figure 2798

Figure 2798

Ref. No.	3M Part No.	Description
2798-1	78-8070-1557-9	Compression Roller Assembly - Right
2798-2	78-8070-1558-7	Compression Roller Assembly - Left
2798-3	78-8070-1559-5	Support - Compression Roller
2798-4	78-8070-1560-3 016	Pressure Roller
2798-5	78-8070-1560-3	Stud - Roller Mounting
2798-6	78-8052-6566-3	Washer - Friction
2798-7	78-8070-1561-1	Nut - M10
2798-8	26-1004-5507-5	Washer - M8
2798-9	26-1003-5841-0	Screw - M8 x 16
2798-10	78-8017-9074-8	Washer - Nylon 15 mm
2798-11	78-8070-1562-9	Tube - Roller Support
2798-12	12-7991-1752-3	Washer - Plain M14
2798-13	78-8070-1563-7	Screw - M10 x 80
2798-14	78-8070-1549-6	Knob - VTR-B-M10
2798-15	26-1003-6918-5	Nut - Hex Flange, M10, Plastic Insert

800a3 Adjustable Case Sealer

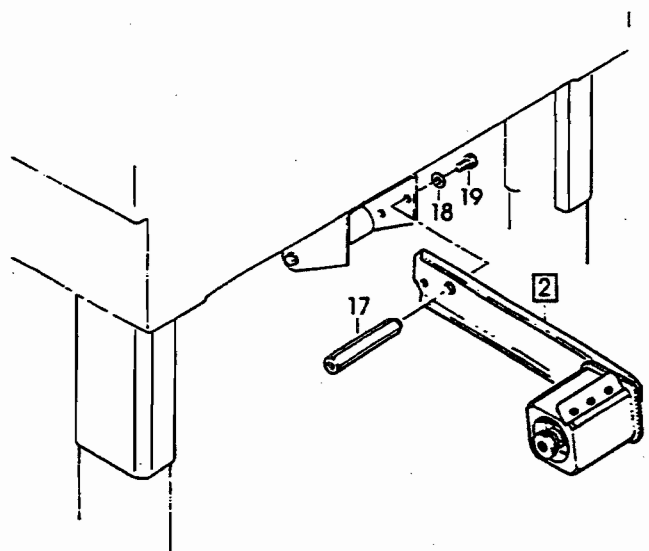
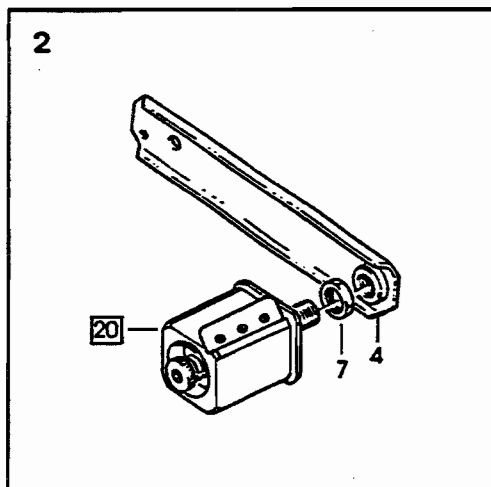
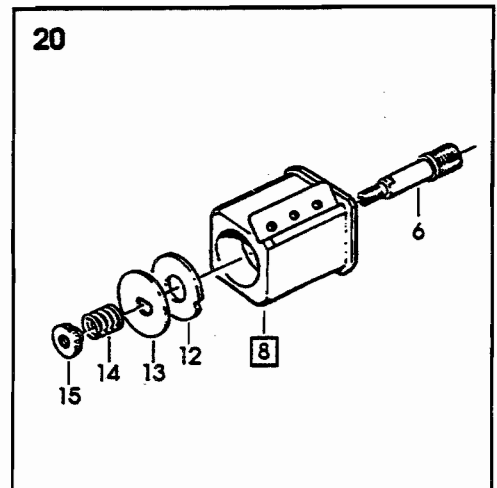
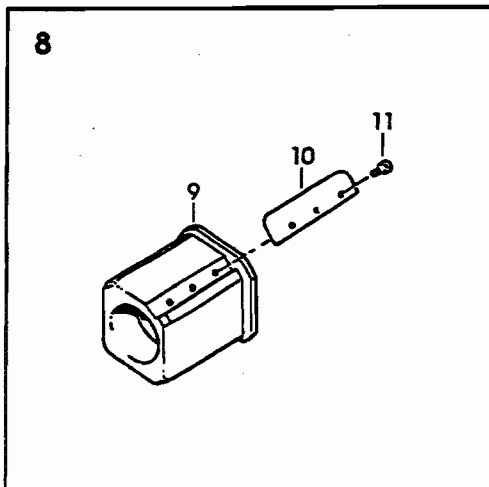
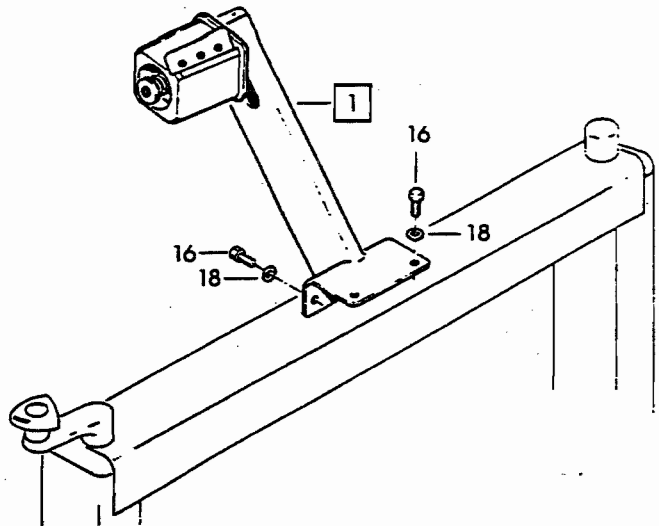
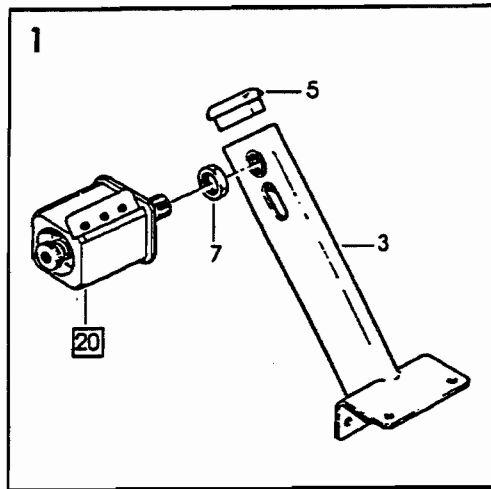


Figure 3024

Figure 3024

Ref. No.	3M Part No.	Description
3024-1	78-8076-4934-4	Tape Drum Bracket Assembly
3024-2	78-8076-4935-1	Tape Drum Bracket Assembly
3024-3	78-8070-1566-0	Bracket - Tape Drum
3024-4	78-8070-1395-4	Bracket - Bushing Assembly
3024-5	78-8070-1568-6	Cap - Bracket
3024-6	78-8060-8462-6	Shaft - Tape Drum 3 Inch Head
3024-7	78-8017-9169-6	Nut - M18 x 1
3024-8	78-8076-4731-4	Tape Drum Assembly - 3 Inch Wide
3024-9	78-8054-8815-8	Tape Drum Assembly
3024-10	78-8054-8816-6	Leaf Spring
3024-11	26-1002-5753-9	Screw - Self-Tapping
3024-12	78-8060-8172-1	Washer - Friction
3024-13	78-8052-6271-0	Washer - Tape Drum
3024-14	78-8054-8826-5	Spring
3024-15	78-8060-7851-1	Ring Nut - Adjusting
3024-16	78-8032-0375-7	Screw - Hex Hd, M6 x 16, Metric
3024-17	78-8076-4742-1	Spacer - Tape Drum Bracket
3024-18	26-1000-0010-3	Washer - M6, Flat
3024-19	78-8010-7169-3	Screw - Hex Hd, M6 x 12, Metric
3024-20	78-8076-4732-2	Tape Drum Assembly - 3 Inch Head, W/O Bracket/Lock/Plate

800a3 Adjustable Case Sealer

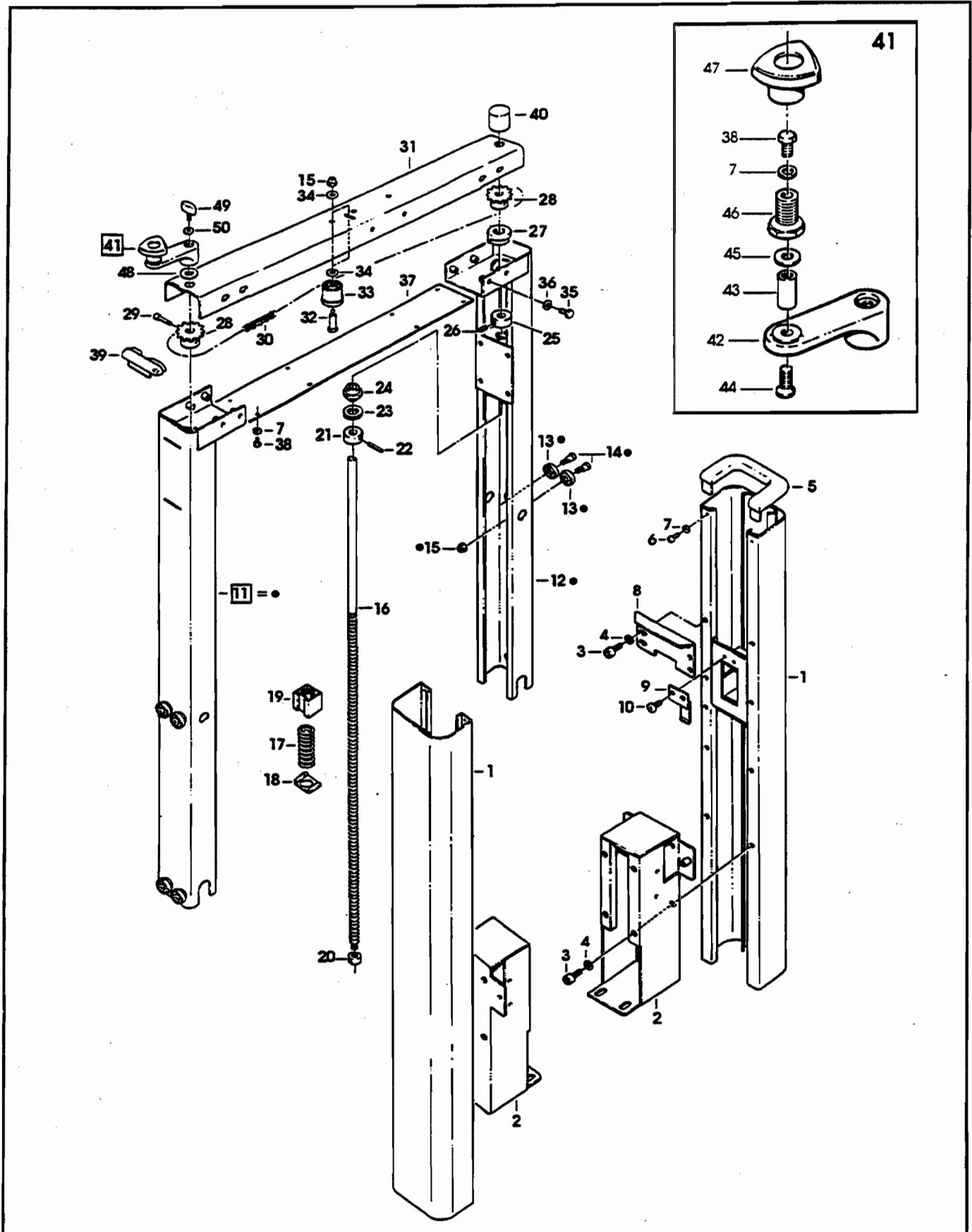


Figure 3269

Figure 3269

Ref. No.	3M Part No.	Description
3269-1	78-8060-8489-9	Column - Outer
3269-2	78-8076-5426-0	Plate
3269-3	26-1003-7964-8	Screw - Soc Hd, M8 x 20
3269-4	78-8017-9318-9	Washer - Plain 8 mm, Metric
3269-5	78-8060-8491-5	Cap - Column
3269-6	26-1002-4955-1	Screw - Self-Tap, 8P x 13
3269-7	78-8005-5740-3	Washer - Plain 4 mm, Metric
3269-8	78-8060-8492-3	Stop - Height
3269-9	78-8076-5482-3	Plate - Nut Stop
3269-10	78-8060-8087-1	Screw - M5 x 10, Metric
3269-11	78-8060-8494-9	Column Assembly - Inner
3269-12	78-8060-8495-6	Column - Inner
3269-13	78-8054-8617-8	Bearing - Special
3269-14	78-8054-8589-9	Screw - Special
3269-15	26-1003-6916-9	Nut - Locking M6, Plastic Insert
3269-16	78-8060-8496-4	Lead Screw
3269-17	78-8054-8969-3	Spring
3269-18	78-8054-8970-1	Bed Plate For Spring
3269-19	78-8054-8571-7	Nut - Plastic
3269-20	78-8054-8968-5	Nut - Special
3269-21	78-8054-8585-7	Collar
3269-22	78-8054-8586-5	Pin
3269-23	78-8054-8584-0	Spacer
3269-24	78-8054-8583-2	Bushing
3269-25	78-8060-8497-2	Bushing - Lead Screw
3269-26	78-8059-5617-0	Set Screw - M6 x 8
3269-27	78-8060-8498-0	Bushing - Inner Column
3269-28	78-8060-8499-8	Sprocket - 3/8 Inch Z=13
3269-29	78-8070-1500-9	Screw - Soc Hd Hex Hd, M4 x 25
3269-30	78-8076-4818-9	Chain - 3/8 Inch Pitch, 197 Pitch
3269-31	78-8076-5427-8	Housing - Chain
3269-32	78-8060-7878-4	Idler Screw
3269-33	78-8070-1503-3	Roller - Chain Tensioning
3269-34	78-8042-2919-9	Washer - Triple, M6
3269-35	26-1003-5829-5	Screw - Hex Hd, M6 x 12
3269-36	26-1000-0010-3	Washer - Flat M6
3269-37	78-8076-5428-6	Cover
3269-38	78-8010-7157-8	Screw - Hex Hd, M4 x 10
3269-39	78-8070-1505-8	Cap - Inner Column
3269-40	78-8070-1506-6	Cover - Screw
3269-41	78-8076-4807-2	Crank Assembly
3269-42	78-8076-5422-9	Crank Assembly
3269-43	78-8070-1509-0	Shaft - Crank
3269-44	26-1005-5316-8	Screw - Flat Hd Hex Dr, M5 x 16
3269-45	78-8070-1510-8	Washer - Nylon, 7 x 15 x 1
3269-46	78-8070-1511-6	Bushing
3269-47	78-8070-1512-4	Knob - VTR-B-M12
3269-48	78-8076-4800-7	Washer - Crank
3269-49	78-8076-4821-3	Key - Stop
3269-50	78-8076-4809-8	Washer - Crank

800a3 Adjustable Case Sealer

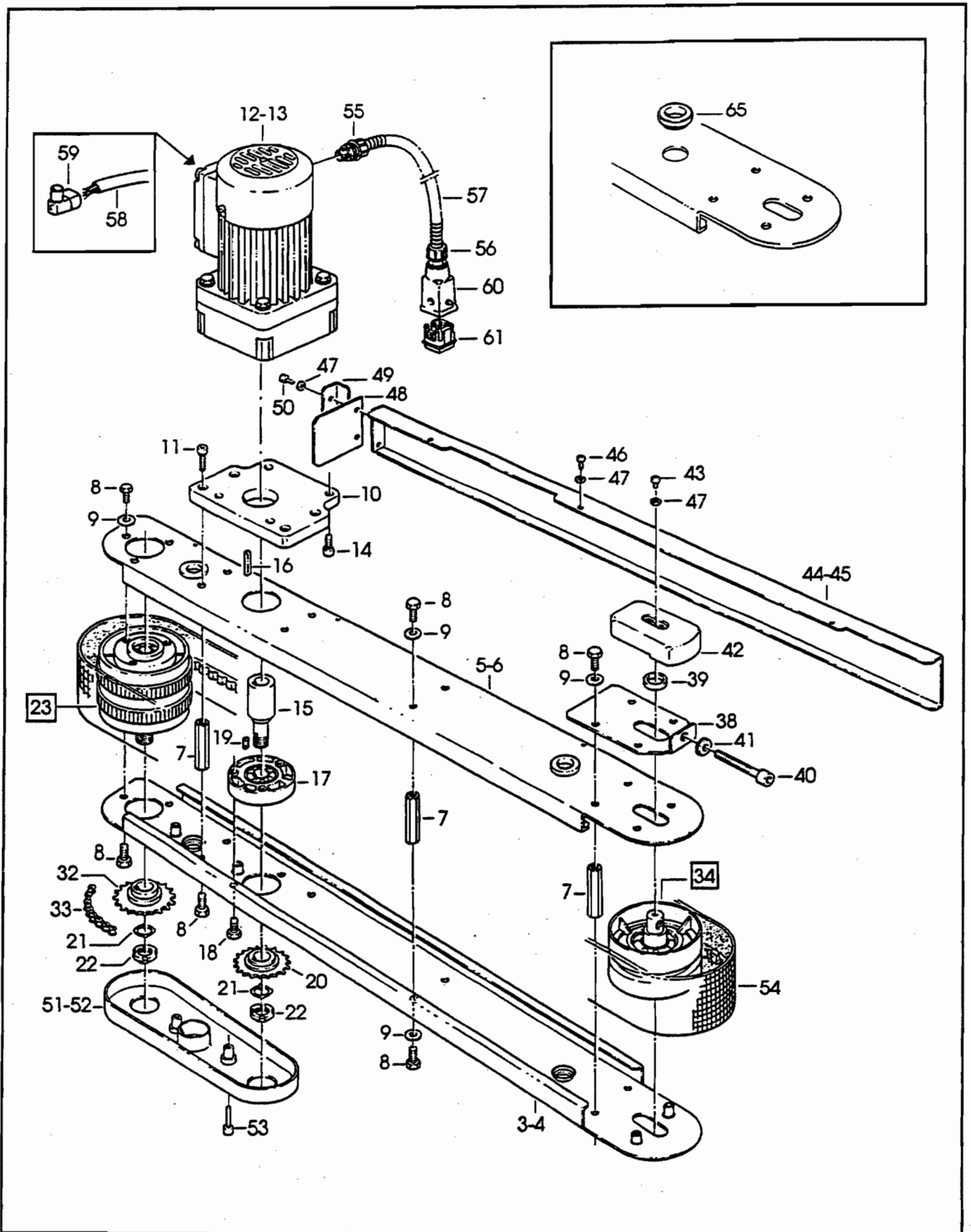
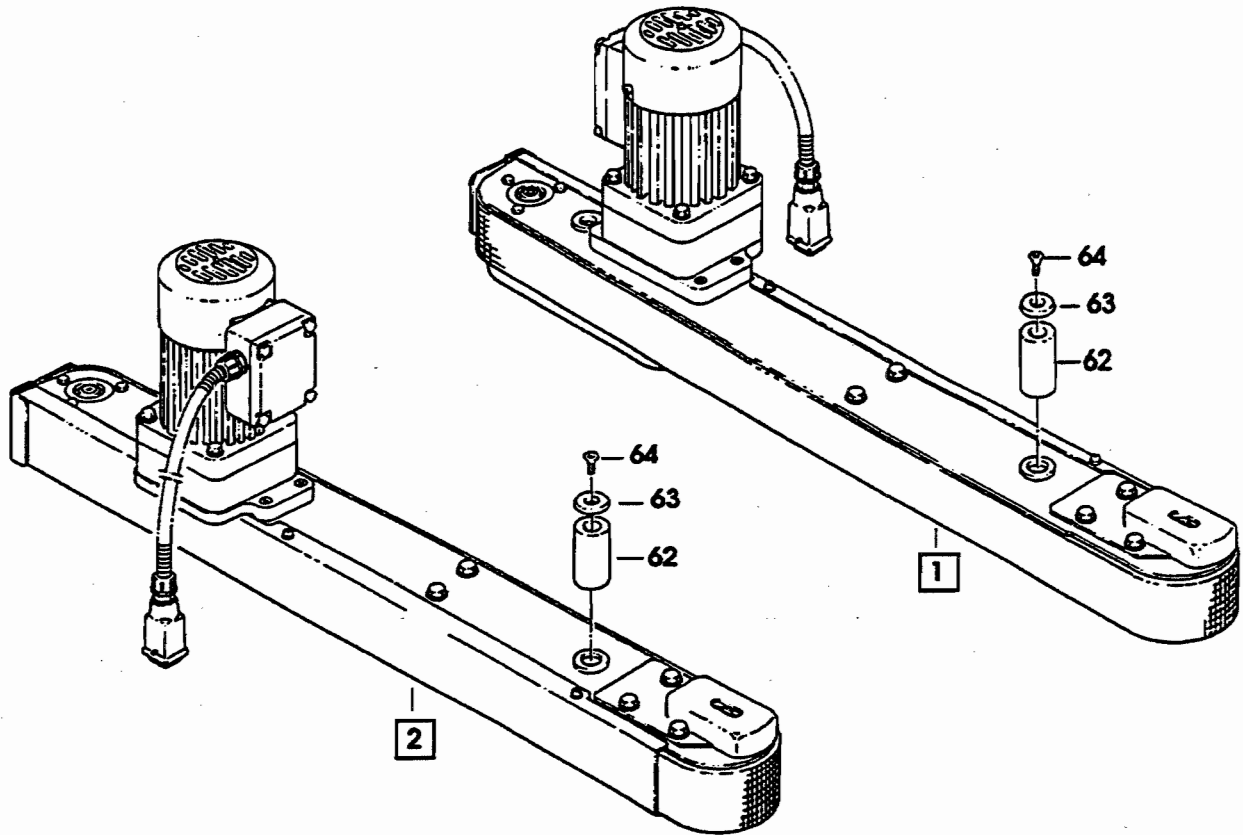


Figure 3271/1 of 2

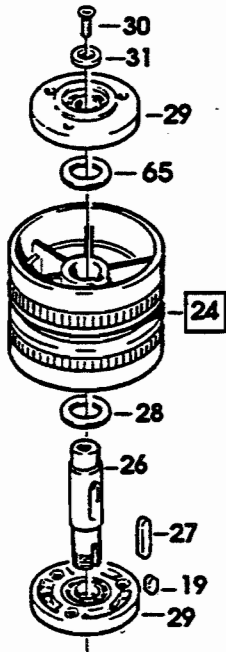
Figure 3271 (Page 1 of 2)

Ref. No.	3M Part No.	Description
3271-1	78-8076-5432-8	Drive Assembly - R/H, W/O Motor
3271-2	78-8076-5433-6	Drive Assembly - L/H, W/O Motor
3271-3	78-8076-5434-4	Guide - Lower, R/H
3271-4	78-8076-5435-1	Guide - Lower, L/H
3271-5	78-8076-5436-9	Guide - Upper, R/H
3271-6	78-8076-5437-7	Guide - Upper, L/H
3271-7	78-8055-0661-1	Spacer
3271-8	26-1003-5829-5	Screw - Hex Hd, M6 x 12
3271-9	26-1000-0010-3	Washer - Flat M6
3271-10	78-8076-4856-9	Support - Bodine Gearmotor
3271-11	78-8010-7211-3	Screw - Soc Hd, M6 x 25
3271-12	78-8076-4857-7	Gearmotor - Bodine 481
3271-13	26-1006-7631-6	Capacitor - 12.5 - 250V With 3.75 Inch Leads
3271-14	78-8070-1523-1	Screw - 1/4 - 28 x 1/2 SHCS
3271-15	78-8076-5438-5	Extension
3271-16	78-8057-5739-6	Key - M5 x 5 x 30 mm
3271-17	78-8076-5439-3	Flange Assembly
3271-18	78-8060-7886-7	Screw - Hex Hd, M6 x 16, Special
3271-19	78-8046-8135-7	Key - 5 x 5 - 12 mm
3271-20	78-8076-4860-1	Sprocket - 3/8 Inch Z=17
3271-21	78-8057-5834-5	Tab Washer
3271-22	78-8057-5835-2	Centering Washer
3271-23	78-8076-5440-1	Pulley Assembly - Drive
3271-24	78-8091-0716-8	Roller - Drive
3271-25	78-8052-6713-1	Ring - Polyurethane
3271-26	78-8055-0669-4	Shaft - Pulley Keyed
3271-27	78-8057-5739-6	Key - M5 x 5 x 30 mm
3271-28	78-8055-0668-6	Washer - 15/26 x 1
3271-29	78-8076-5442-7	Flange Assembly
3271-30	26-0001-5862-1	Screw - Flat Hd Soc - M5 x 12
3271-31	78-8054-8877-8	Washer - 5,5/20 x 4
3271-32	78-8076-4861-9	Sprocket - 3/8 Inch Z=20

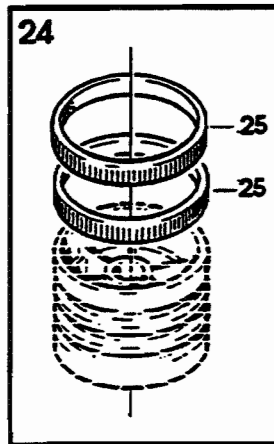
800a3 Adjustable Case Sealer



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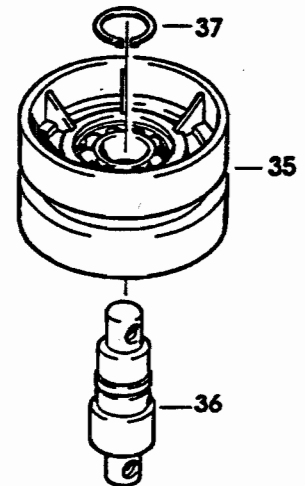


Figure 3271/2 of 2

Figure 3271 (Page 2 of 2)

Ref. No.	3M Part No.	Description
3271-33	78-8076-4933-6	Chain – 3/8 Inch Pitch, 52 Pitch
3271-34	78-8076-5443-5	Pulley Assembly – Idler
3271-35	78-8055-0660-3	Roller – Idler
3271-36	78-8076-5444-3	Shaft – Idler Pulley
3271-37	12-7997-0272-0	E-Ring – M-25
3271-38	78-8076-5445-0	Tensioning – Belt
3271-39	78-8076-5446-8	Washer – Shaft
3271-40	78-8076-5447-6	Screw – M8 x 70, Special
3271-41	78-8017-9318-9	Washer – Plain 8 mm, Metric
3271-42	78-8076-5448-4	Cover – Belt Tensioner
3271-43	78-8055-0850-0	Screw – Cap M4 x 6
3271-44	78-8076-5449-2	Cover – Drive, R/H
3271-45	78-8076-5450-0	Cover – Drive, L/H
3271-46	26-1002-5753-9	Screw – Self-Tapping
3271-47	78-8005-5740-3	Washer – Plain 4 mm, Metric
3271-48	78-8055-0650-4	Guard – Belt
3271-49	78-8076-5451-8	Guard – Belt
3271-50	26-1002-4955-1	Screw – Self-Tap, 8P x 13
3271-51	78-8076-4866-8	Cover – Right
3271-52	78-8076-4867-6	Cover – Left
3271-53	78-8010-7165-1	Screw – Flat Hd Soc, M5 x 25
3271-54	78-8076-5452-6	Belt – Box Drive
3271-55	78-8076-4954-2	Union – PG 13.5
3271-56	78-8060-7626-7	Connector – PG 11/12
3271-57	78-8076-5197-7	Sleeving – /12, 800 mm
3271-58	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
3271-59	78-8076-4602-7	Terminal
3271-60	78-8060-7877-6	Plug Housing Vertical
3271-61	78-8060-7875-0	Plug – Male
3271-62	78-8076-5453-4	Roller
3271-63	78-8054-8577-4	Washer – Special
3271-64	26-1001-9843-6	Screw – Flat Soc Hd, M6 x 16
3271-65	78-8091-0500-6	Bushing – Side Drive
3271-66	78-8091-0382-9	Wqsher – Belleville /16

800a3 Adjustable Case Sealer

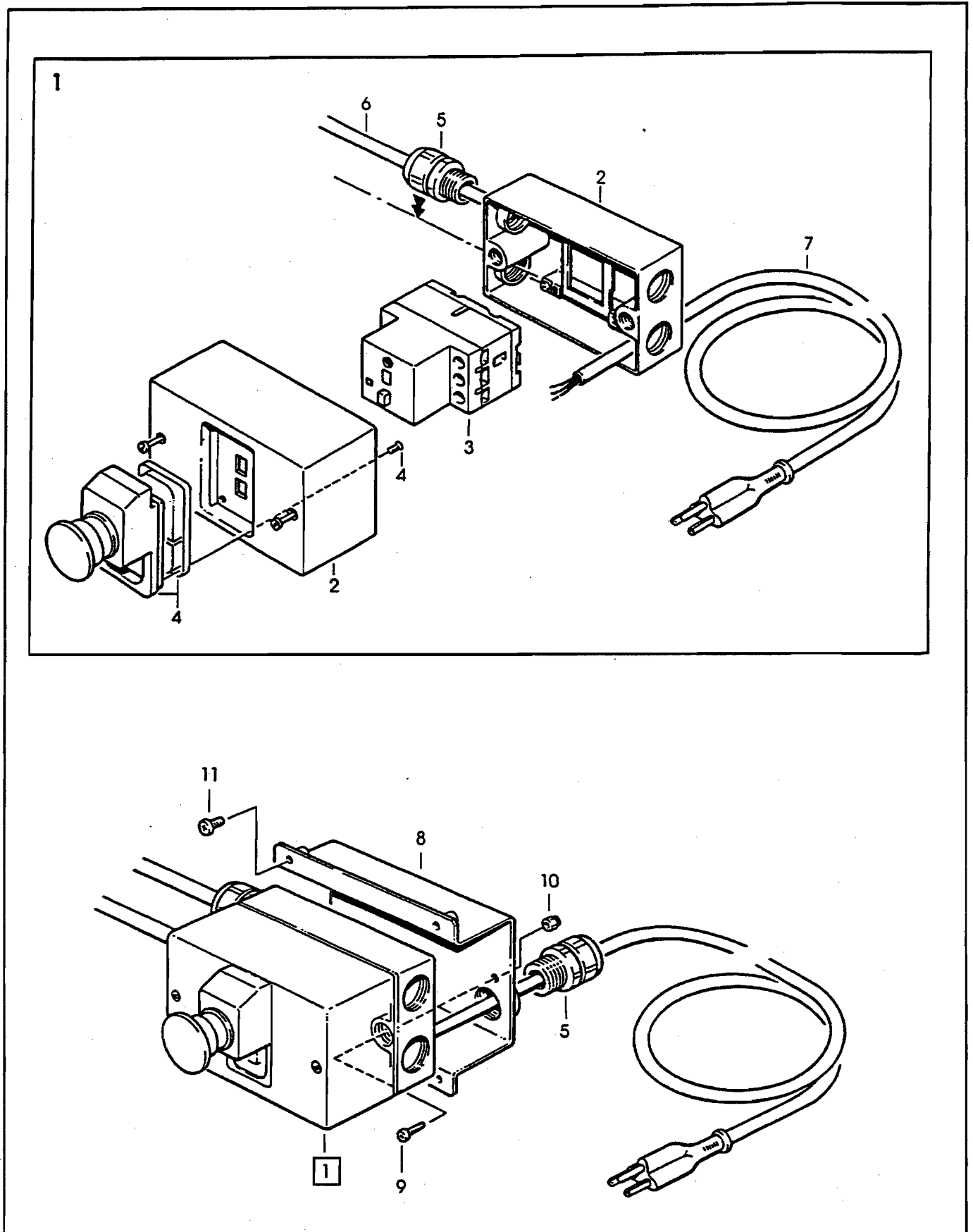


Figure 3272

Figure 3272

Ref. No.	3M Part No.	Description
3272-1	78-8076-5454-2	On/Off Switch Assembly - 2,5-4 A.
3272-2	78-8076-4879-1	Box - On/Off Switch
3272-3	78-8076-4877-5	Switch - On/Off, 2,5-4 A.
3272-4	78-8076-5455-9	E-Stop Button
3272-5	78-8057-5807-1	Cord Grip
3272-6	78-8060-8053-3	Wire - 3-Pole, 5 Meters Length
3272-7	78-8028-7909-4	Power Cord - U.S.A.
3272-8	78-8076-5456-7	Support - Switch
3272-9	26-1003-5707-3	Screw - Phillips Dr, M4 x 16
3272-10	26-1003-6914-4	Nut - Plastic Insert M4
3272-11	78-8060-8087-1	Screw - M5 x 10, Metric

800a3 Adjustable Case Sealer

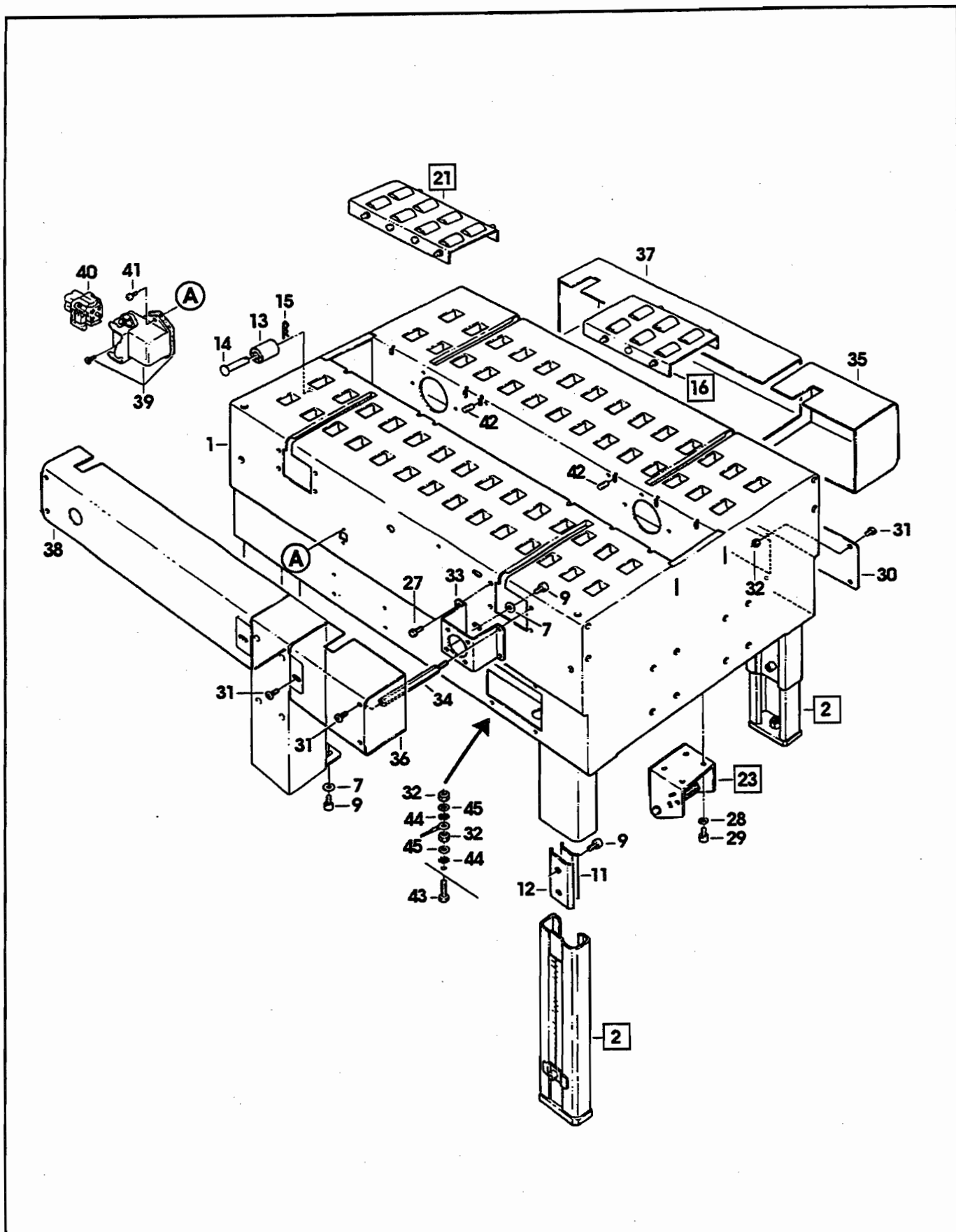


Figure 3386/1 of 2

Figure 3386 (page 1 of 2)

Ref. No.	3M Part No.	Description
3386-1	78-8076-5380-9	Bed - Conveyor
3386-2	78-8076-5381-7	Leg Assembly - Inner, W/Stop
3386-3	78-8076-5382-5	Leg - Inner
3386-4	78-8060-8480-8	Pad - Foot
3386-5	78-8055-0867-4	Screw - Hex Hd, M8 x 30
3386-6	78-8017-9313-0	Nut - Self-Locking, M8
3386-7	78-8017-9318-9	Washer - Plain 8 mm, Metric
3386-8	78-8076-5383-3	Stop - Leg
3386-9	26-1003-7963-0	Screw - Soc Hd, M8 x 16
3386-10	78-8060-8481-6	Label - Height
3386-11	78-8052-6676-0	Clamp - Outer
3386-12	78-8052-6677-8	Clamp - Inner
3386-13	78-8060-7693-7	Roller - 32 x 38
3386-14	78-8076-5384-1	Shaft - Roller
3386-15	78-8076-5385-8	Spring
3386-16	78-8076-5386-6	Conveyor Assembly - Front
3386-17	78-8076-5387-4	Conveyor - Front
3386-18	78-8076-5388-2	Shaft - Conveyor
3386-19	26-1003-5828-7	Screw - Hex Hd, M6 x 10
3386-20	78-8076-5389-0	Mounting - Conveyor
3386-21	78-8076-5390-8	Conveyor Assembly - Rear
3386-22	78-8076-5391-6	Conveyor - Rear
3386-23	78-8076-5462-5	Support - Tape Drum
3386-24	78-8076-4758-7	Support - Tape Bracket
3386-25	78-8076-4759-5	Shaft - Roller
3386-26	78-8076-5030-0	Roller

800a3 Adjustable Case Sealer

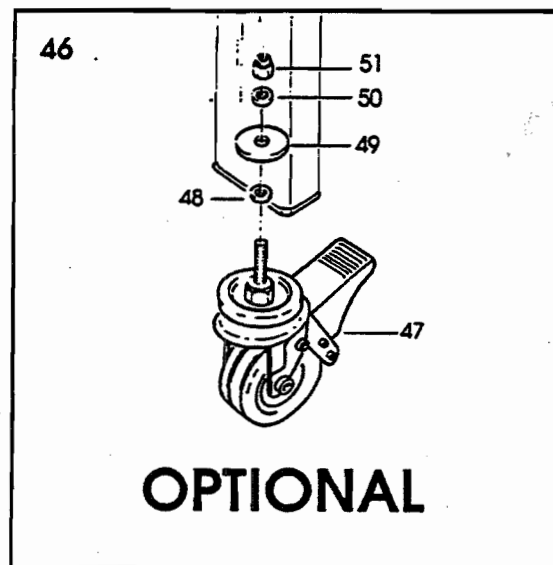
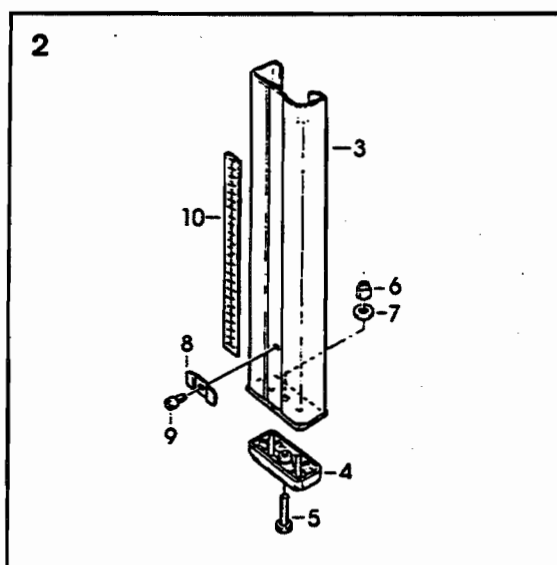
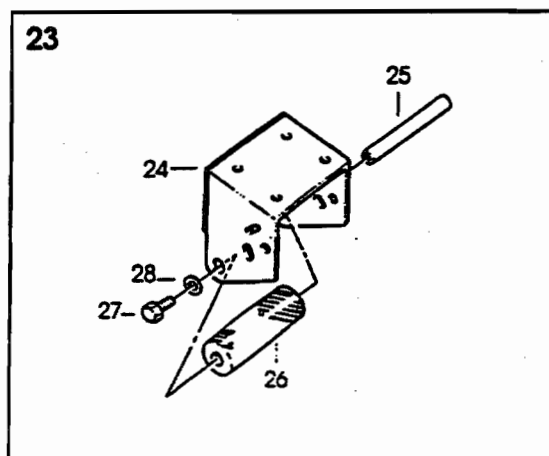
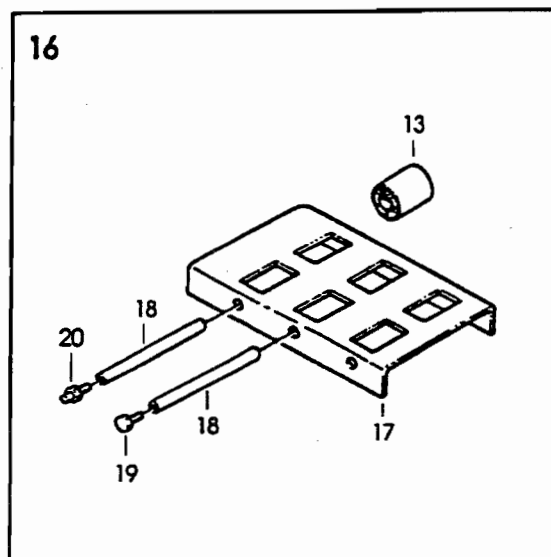
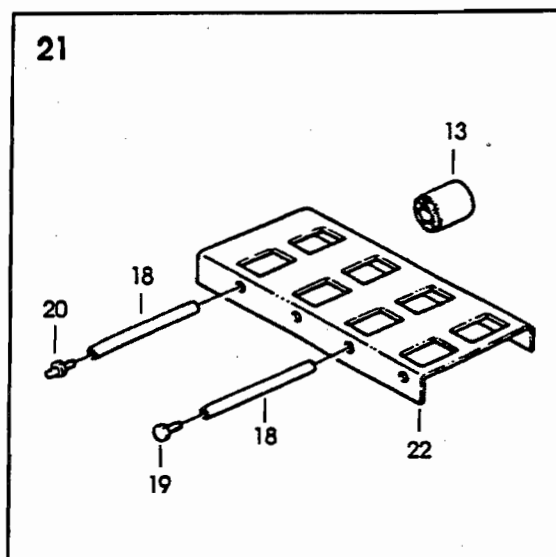


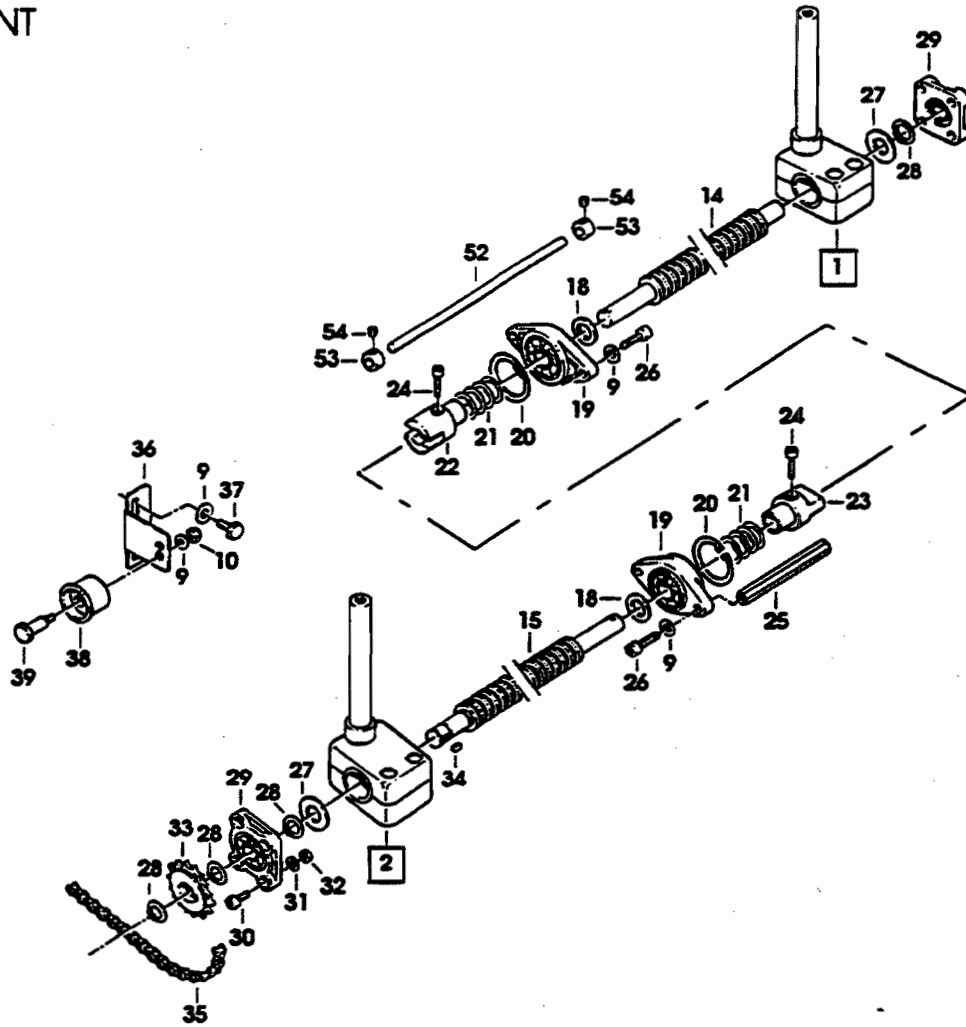
Figure 3386/2 of 2

Figure 3386 (page 2 of 2)

Ref. No.	3M Part No.	Description
3386-27	78-8032-0375-7	Screw - Hex Hd, M6 x 16, Metric
3386-28	26-1000-0010-3	Washer - Flat M6
3386-29	26-1003-7957-2	Screw - Soc Hd Hex Hd, M6 x 16
3386-30	78-8060-8487-3	Cover - Switch
3386-31	78-8060-8087-1	Screw - M5 x 10, Metric
3386-32	78-8010-7417-6	Nut - Hex M5, Metric
3386-33	78-8076-5393-2	Plate - Tape Bracket Support
3386-34	78-8076-5394-0	Spacer
3386-35	78-8076-5395-7	Cover - Side, Front, R/H
3386-36	78-8076-5396-5	Cover - Side, Front, L/H
3386-37	78-8076-5397-3	Cover - Side, Rear, R/H
3386-38	78-8076-5398-1	Cover - Side, Rear, L/H
3386-39	78-8060-7876-8	Cover Plug - Lateral
3386-40	78-8060-7873-5	Plug - Female
3386-41	78-8028-8208-0	Screw - 6P x 9,5
3386-42	78-8076-4500-3	Stud - Mounting
3386-43	78-8060-8488-1	Screw - Hex Hd, M5 x 20
3386-44	78-8046-8217-3	Washer - Special
3386-45	78-8005-5741-1	Washer - Plain M5, Metric
3386-46	78-8060-8060-8	Caster Assembly - /80
3386-47	78-8060-8061-6	Caster - /80
3386-48	78-8060-8124-2	Spacer - Caster
3386-49	78-8060-7699-4	Washer - 12 - 45, 5 x 4
3386-50	78-8017-9059-9	Washer - Flat For M12 Screw
3386-51	78-8060-7532-7	Nut - Self-Locking, M12

800a3 Adjustable Case Sealer

FRONT



• = Pos.3 and 4
to be ordered
always together

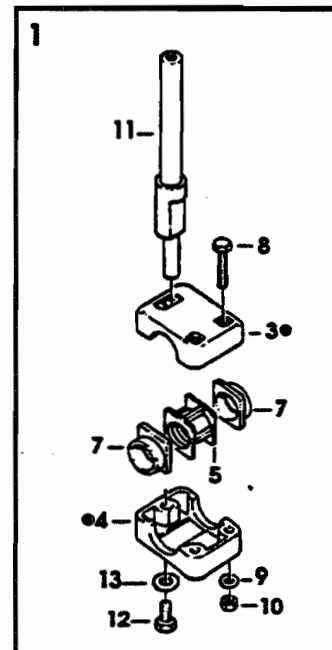
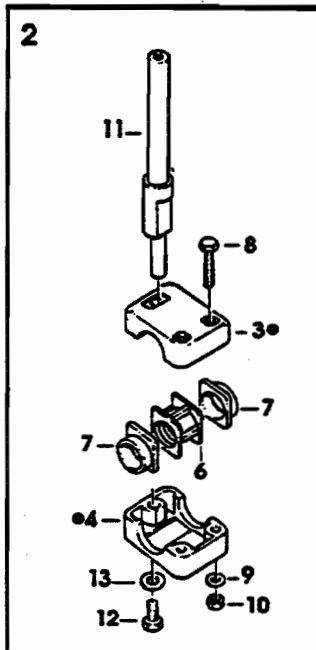


Figure 3387/1 of 2

Figure 3387 (page 1 of 2)

Ref. No.	3M Part No.	Description
3387-1	78-8076-5399-9	Block Assembly - R/H
3387-2	78-8076-5400-5	Block Assembly - L/H
3387-3	78-8076-5401-3	Block - Upper
3387-4	78-8076-5402-1	Block - Lower
3387-5	78-8076-5403-9	Nut - Block, R/H
3387-6	78-8076-5404-7	Nut - Block, L/H
3387-7	78-8076-5405-4	Bushing - Block
3387-8	78-8076-5239-7	Screw - Hex Hd, M6 x 50
3387-9	26-1000-0010-3	Washer - Flat M6
3387-10	26-1003-6916-9	Nut - Locking M6, Plastic Insert
3387-11	78-8076-5406-2	Shaft - Drive Mount
3387-12	26-1003-5842-8	Screw - Hex Hd, M8 x 20
3387-13	78-8017-9318-9	Washer - Plain 8 mm, Metric
3387-14	78-8076-5407-0	Screw - R/H
3387-15	78-8076-5408-8	Screw - L/H
3387-16	78-8076-5409-6	Screw - Handle, R/H
3387-17	78-8076-5410-4	Screw - Handle, L/H
3387-18	78-8076-5411-2	Spacer - Screw
3387-19	78-8076-5412-0	Flange - W/Bearing
3387-20	78-8060-8010-3	Snap Ring - 42 mm Shaft
3387-21	78-8076-5413-8	Spring
3387-22	78-8076-5414-6	Coupling - Screw
3387-23	78-8076-5415-3	Coupling - Female, Screw
3387-24	26-1003-7946-5	Screw - Soc Hd, M4 x 25
3387-25	78-8076-5416-1	Spacer - Hex, 10 x 107
3387-26	78-8010-7211-3	Screw - Soc Hd, M6 x 25
3387-27	78-8076-5417-9	Spacer

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Figure 3387/2 of 2

Figure 3387 (page 2 of 2)

Ref. No.	3M Part No.	Description
3387-28	78-8017-9079-7	Ring - Snap For 15 mm Shaft
3387-29	78-8076-5418-7	Support - Screw
3387-30	26-1003-7949-9	Screw - Soc Hd Hex Soc, M5 x 12
3387-31	78-8005-5741-1	Washer - Plain M5, Metric
3387-32	78-8010-7417-6	Nut - Hex M5, Metric
3387-33	78-8076-5419-5	Sprocket - 3/8 Inch Z=16
3387-34	78-8046-8135-7	Key - 5 x 5, 12 mm
3387-35	78-8076-5420-3	Chain - 3/8 Inch, 133 Pitch
3387-36	78-8076-5421-1	Support - Tension Roller
3387-37	78-8010-7169-3	Screw - Hex Hd, M6 x 12, Metric
3387-38	78-8070-1503-3	Roller - Chain Tensioning
3387-39	78-8060-7878-4	Idler Screw
3387-40	78-8076-4807-2	Crank Assembly
3387-41	78-8076-5422-9	Crank Assembly
3387-42	78-8070-1509-0	Shaft - Crank
3387-43	26-1005-5316-8	Screw - Flat Hd Hex Dr, M5 x 16
3387-44	78-8070-1510-8	Washer - Nylon, 7 x 15 x 1
3387-45	78-8070-1511-6	Bushing
3387-46	78-8005-5740-3	Washer - Plain 4 mm, Metric
3387-47	78-8010-7157-8	Screw - Hex Hd, M4 x 10
3387-48	78-8070-1512-4	Knob - VTR-B-M12
3387-49	78-8032-0375-7	Screw - Hex HD, M6 x 16, Metric
3387-50	78-8076-4809-8	Washer - Crank
3387-51	78-8070-1506-6	Cover - Screw
3387-52	78-8076-5463-3	Shaft
3387-53	78-8076-5424-5	Block
3387-54	78-8076-5425-2	Set Screw - M4 x 3

800a3 Adjustable Case Sealer

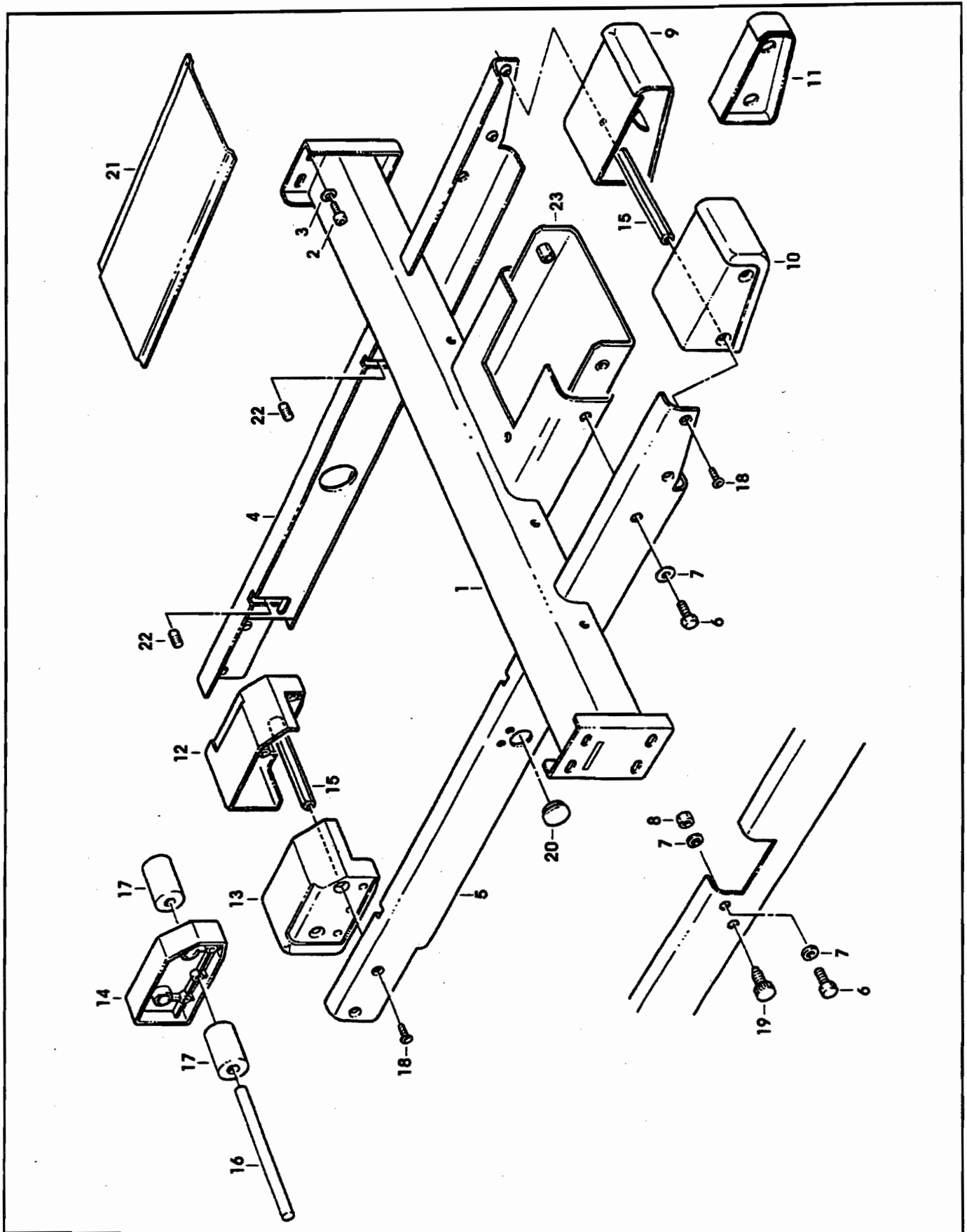


Figure 3388

Figure 3388

Ref. No.	3M Part No.	Description
3388-1	78-8091-0507-1	Bar - Supporting
3388-2	26-1003-7957-2	Screw - Soc Hd Hex Hd, M6 x 16
3388-3	26-1000-0010-3	Washer - Flat M6
3388-4	78-8076-5430-2	Frame - R/H
3388-5	78-8076-5431-0	Frame - L/H
3388-6	26-1003-5842-8	Screw - Hex Hd, M8 x 20
3388-7	78-8017-9318-9	Washer - Plain 8 mm, Metric
3388-8	26-1000-1347-8	Nut - Hex, M8, Metric
3388-9	78-8070-1574-4	Slide - Front, Right
3388-10	78-8070-1575-1	Slide - Front, Left
3388-11	78-8076-5465-8	Spacer - Front Slide
3388-12	78-8070-1576-9	Slide - Rear, Right
3388-13	78-8070-1577-7	Slide - Rear, Left
3388-14	78-8076-5466-6	Spacer
3388-15	78-8076-5467-4	Spacer - Head Straight
3388-16	78-8076-5468-2	Stud - Head Support
3388-17	78-8076-5469-0	Roller - 32 x 55
3388-18	26-1005-5316-8	Screw - Flat Hd Hex Dr, M5 x 16
3388-19	78-8070-1555-3	Block - Upper Head
3388-20	78-8076-4517-7	End Cap - 22 x 1
3388-21	78-8076-5470-8	Cover - Front, Upper
3388-22	78-8076-4500-3	Stud - Mounting
3388-23	78-8076-5471-6	Cover - Lower

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Replacement Parts – Illustrations and Parts Lists

800ab Adjustable Case Sealer, Type 19200 (2 Inch Width Taping Head)

Frame Assemblies

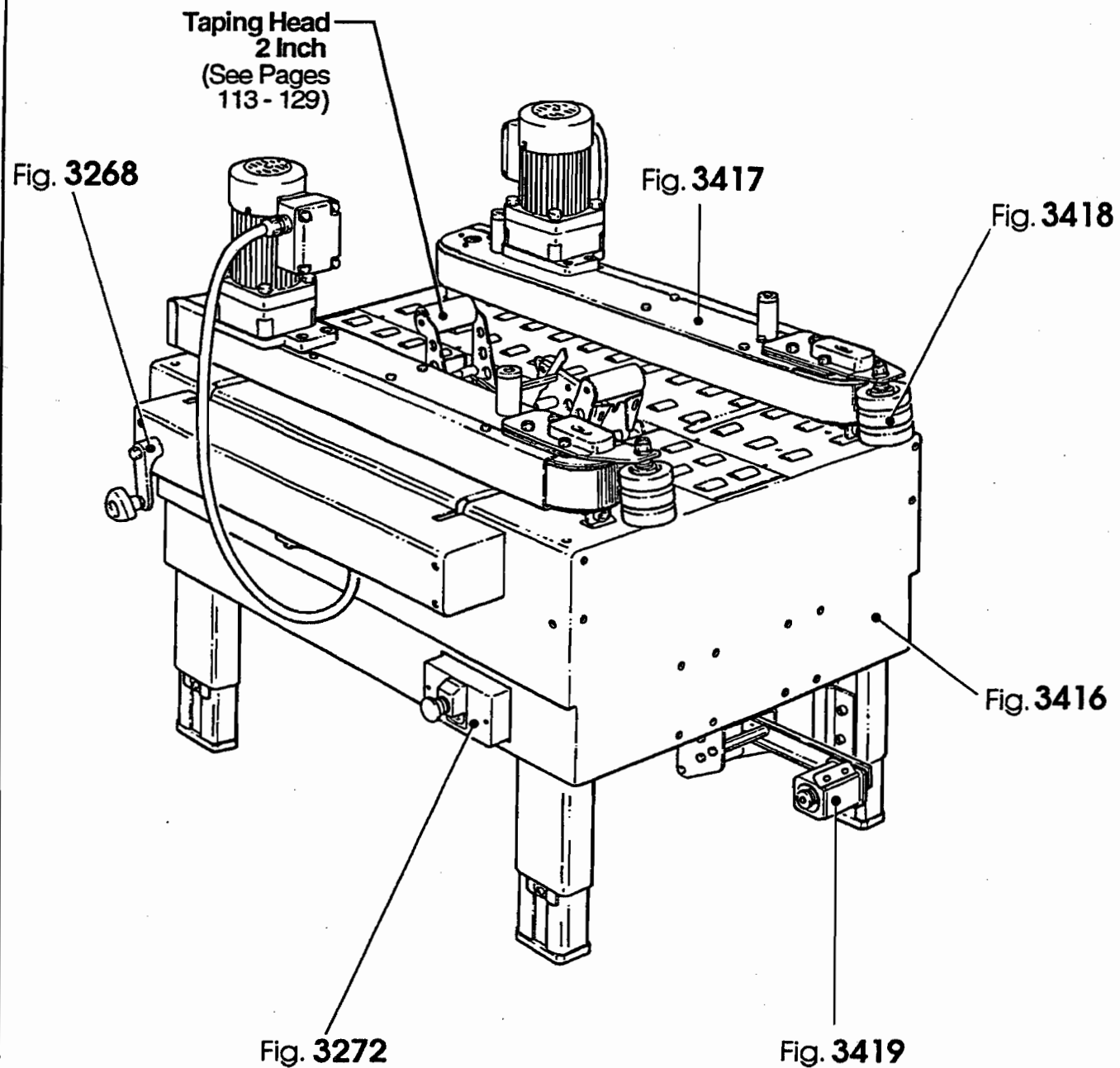
1. Refer to **Frame Assemblies** figure to find all the parts illustrations identified by **figure numbers**.
2. Refer to the figure or figures to determine the **individual parts** required and the **parts reference number**.
3. The **replacement parts list**, that follows each illustration, includes 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 38 – “**Replacement Parts and Service Information**” of this manual for replacement parts ordering information.

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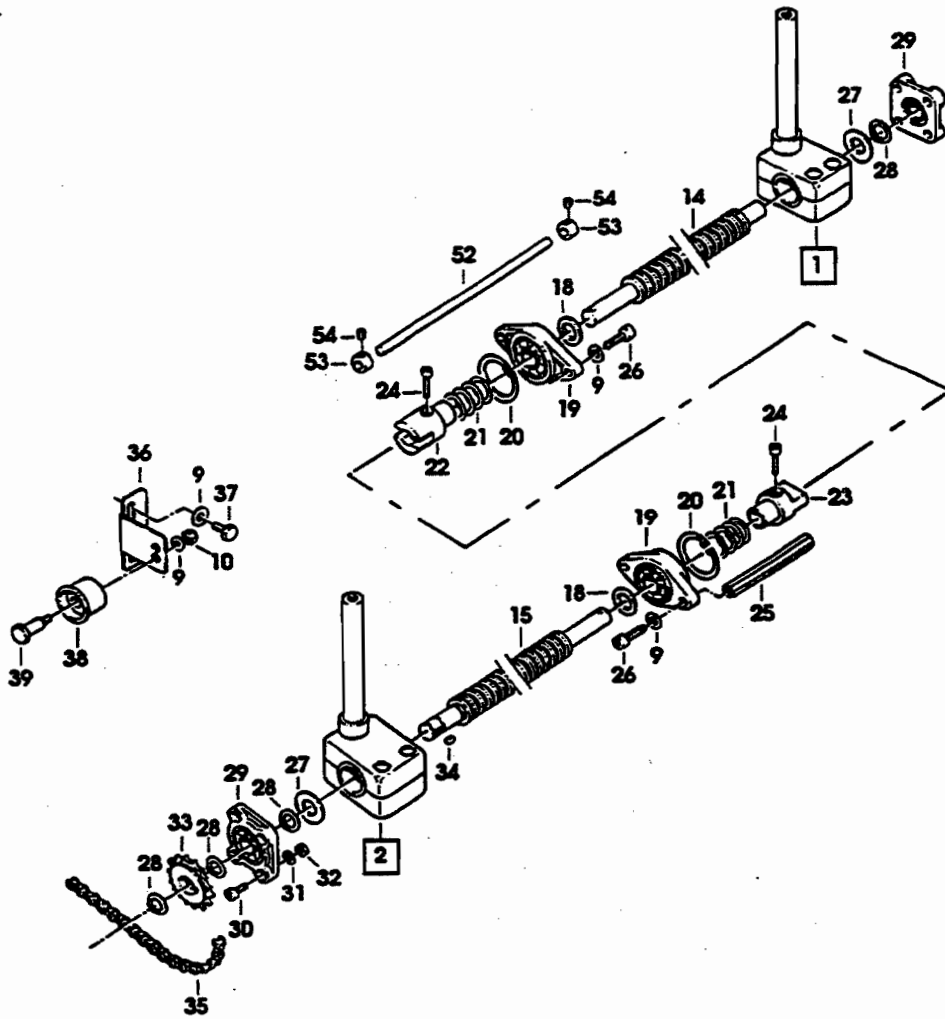
800ab Adjustable Case Sealer



Frame Assemblies

800ab Adjustable Case Sealer

FRONT



• = Pos.3 and 4
to be ordered
always together

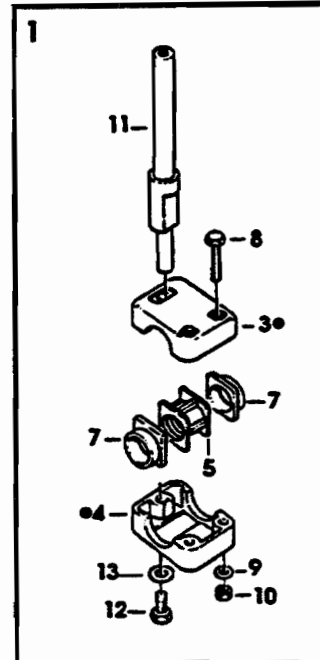
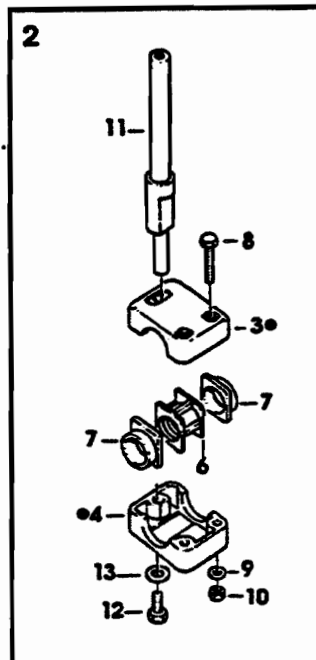


Figure 3268/1 of 2

Figure 3268 (page 1 of 2)

Ref. No.	3M Part No.	Description
3268-1	78-8076-5399-9	Block Assembly – R/H
3268-2	78-8076-5400-5	Block Assembly – L/H
3268-3	78-8076-5401-3	Block – Upper
3268-4	78-8076-5402-1	Block – Lower
3268-5	78-8076-5403-9	Nut – Block, R/H
3268-6	78-8076-5404-7	Nut – Block, L/H
3268-7	78-8076-5405-4	Bushing – Block
3268-8	78-8076-5239-7	Screw – Hex Hd, M6 x 50
3268-9	26-1000-0010-3	Washer – Flat M6
3268-10	26-1003-6916-9	Nut – Locking, Plastic Insert M6
3268-11	78-8076-5406-2	Shaft – Drive Mount
3268-12	26-1003-5842-8	Screw – Hex Hd, M8 x 20
3268-13	78-8017-9318-9	Washer – Plain 8 mm, Metric
3268-14	78-8076-5407-0	Screw – R/H
3268-15	78-8076-5408-8	Screw – L/H
3268-16	78-8076-5409-6	Screw – Handle, R/H
3268-17	78-8076-5410-4	Screw – Handle, L/H
3268-18	78-8076-5411-2	Spacer – Screw
3268-19	78-8076-5412-0	Flange – W/Bearing
3268-20	78-8060-8010-3	Snap Ring – 42 mm Shaft
3268-21	78-8076-5413-8	Spring
3268-22	78-8076-5414-6	Coupling – Screw
3268-23	78-8076-5415-3	Coupling – Female, Screw
3268-24	26-1003-7946-5	Screw – Soc Hd, M4 x 25
3268-25	78-8076-5416-1	Spacer – Hex, 10 x 107
3268-26	78-8010-7211-3	Screw – Soc Hd, M6 x 25
3268-27	78-8076-5417-9	Spacer

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REAR

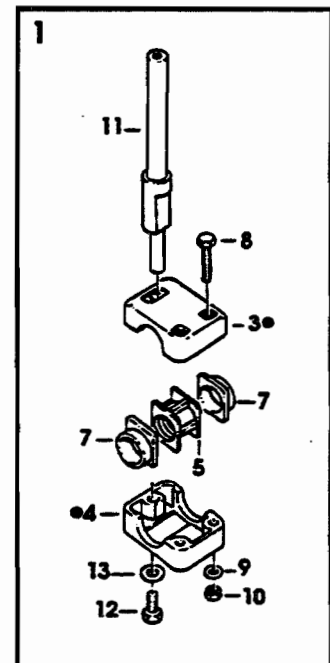
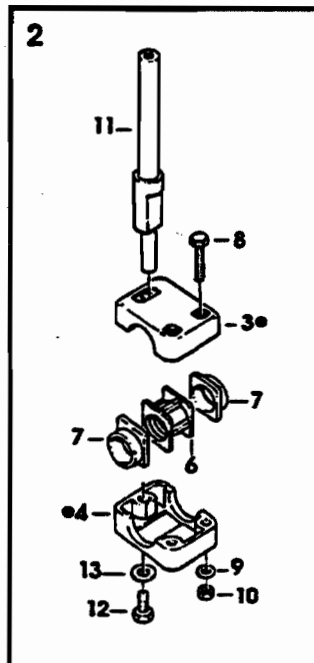
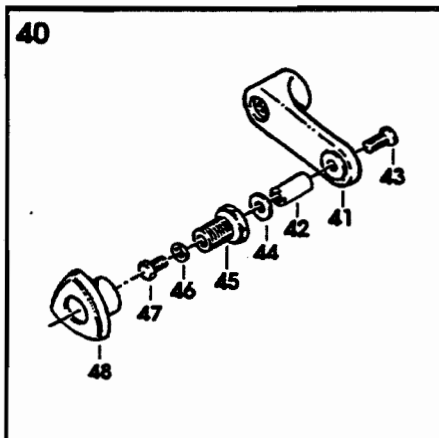
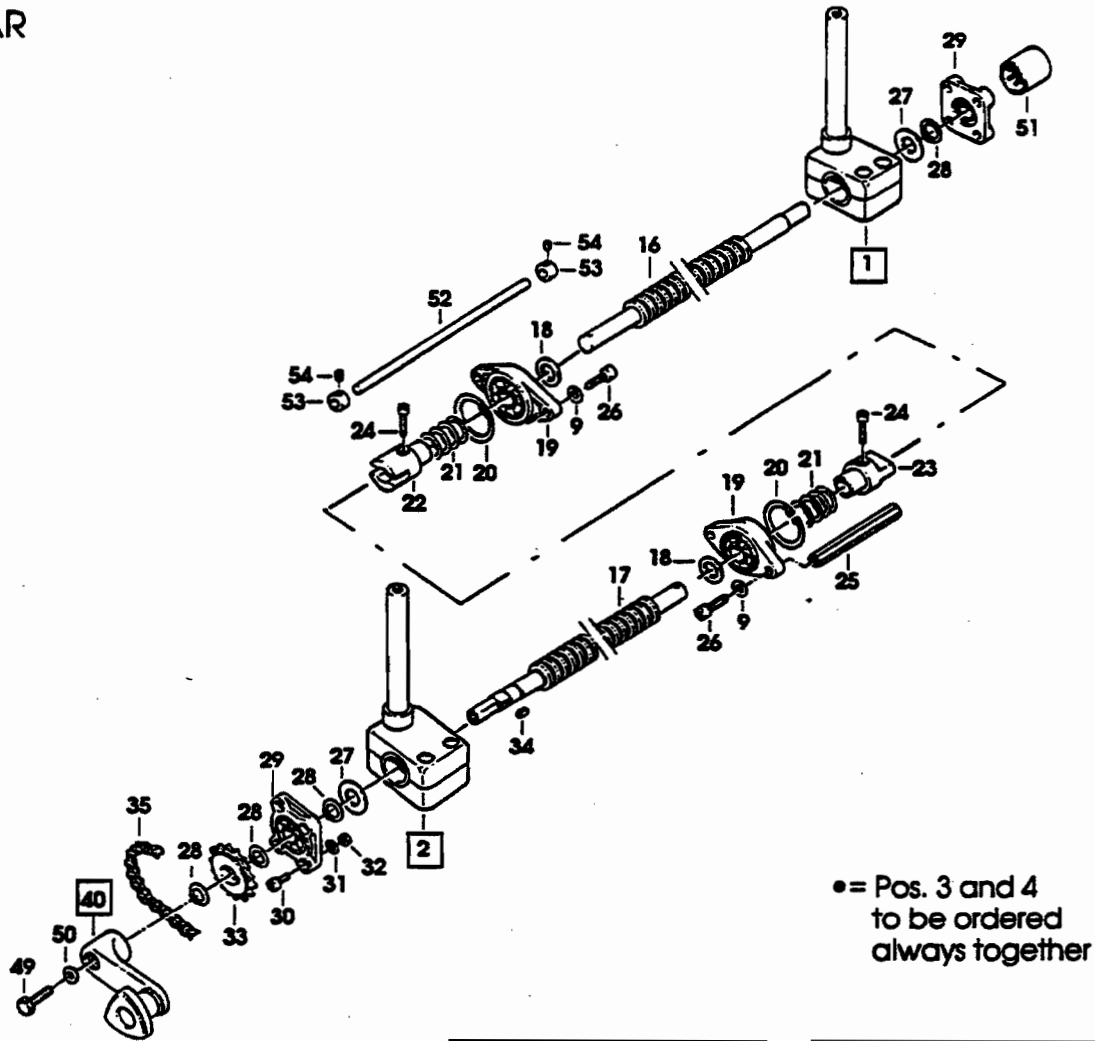


Figure 3268/2 of 2

Figure 3268 (page 2 of 2)

Ref. No.	3M Part No.	Description
3268-28	78-8017-9079-7	Ring - Snap For 15 mm Shaft
3268-29	78-8076-5418-7	Support - Screw
3268-30	26-1003-7949-9	Screw - Soc Hd Hex Soc, M5 x 12
3268-31	78-8005-5741-1	Washer - Plain M5, Metric
3268-32	78-8010-7417-6	Nut - Hex M5, Metric
3268-33	78-8076-5419-5	Sprocket - 3/8 Inch Z=16
3268-34	78-8046-8135-7	Key - 5 x 5, 12 mm
3268-35	78-8076-5420-3	Chain - 3/8 Inch, 133 Pitch
3268-36	78-8076-5421-1	Support - Tension Roller
3268-37	78-8010-7169-3	Screw - Hex Hd, M6 x 12, Metric
3268-38	78-8070-1503-3	Roller - Chain Tensioning
3268-39	78-8060-7878-4	Idler Screw
3268-40	78-8076-4807-2	Crank Assembly
3268-41	78-8076-5422-9	Crank Assembly
3268-42	78-8070-1509-0	Shaft - Crank
3268-43	26-1005-5316-8	Screw - Flat Hd Hex Dr, M5 x 16
3268-44	78-8070-1510-8	Washer - Nylon, 7 x 15 x 1
3268-45	78-8070-1511-6	Bushing
3268-46	78-8005-5740-3	Washer - Plain 4 mm, Metric
3268-47	78-8010-7157-8	Screw - Hex Hd, M4 x 10
3268-48	78-8070-1512-4	Knob - VTR-B-M12
3268-49	78-8032-0375-7	Screw - Hex Hd, M6 x 16, Metric
3268-50	78-8076-4809-8	Washer - Crank
3268-51	78-8070-1506-6	Cover - Screw
3268-52	78-8076-5423-7	Shaft
3268-53	78-8076-5424-5	Block
3268-54	78-8076-5425-2	Set Screw - M4 x 3

800ab Adjustable Case Sealer

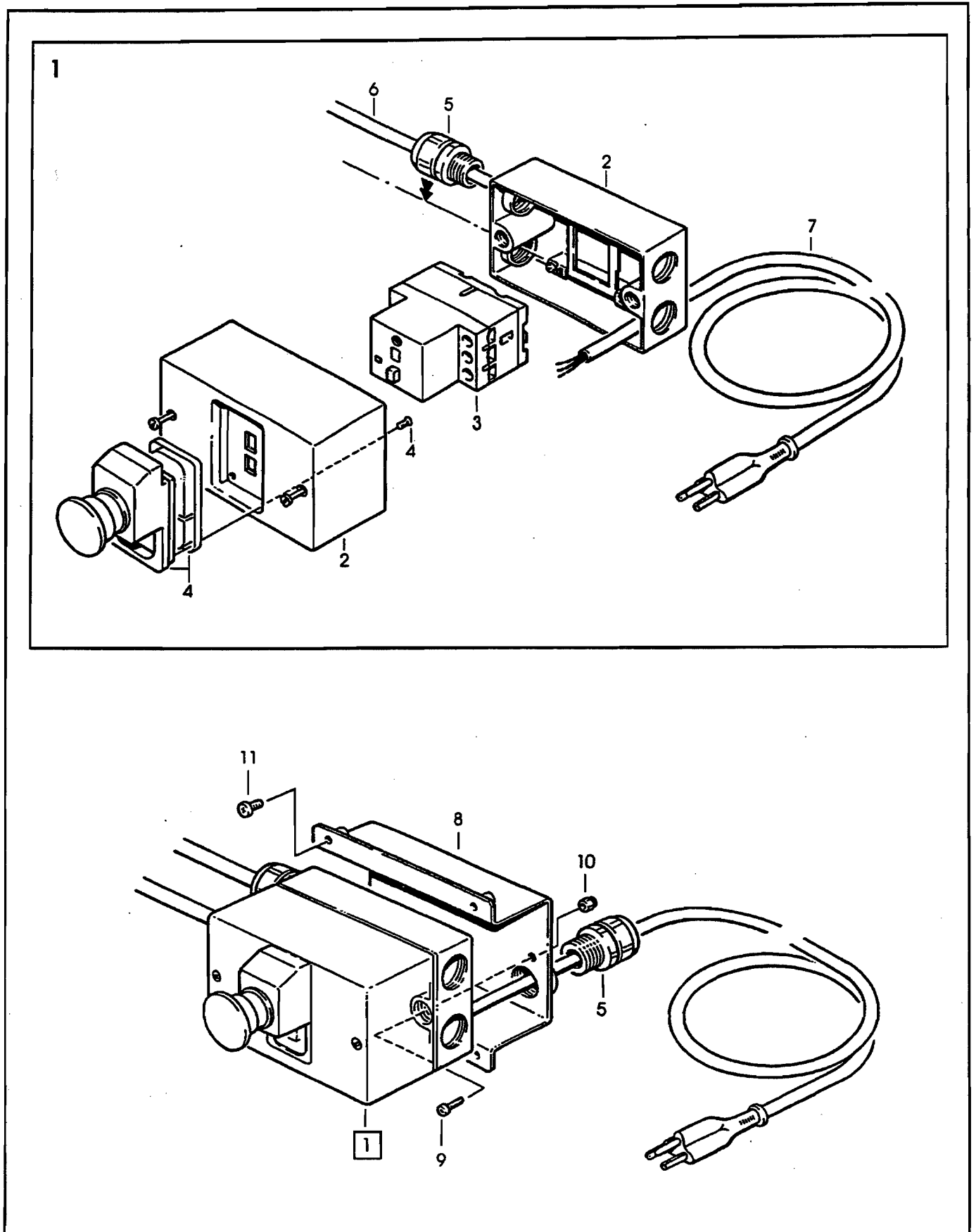


Figure 3272

Figure 3272

Ref. No.	3M Part No.	Description
3272-1	78-8076-5454-2	On/Off Switch Assembly - 2.5/4 A.
3272-2	78-8076-4879-1	Box - On/Off Switch
3272-3	78-8076-4877-5	Switch - On/Off 2,5-4 A.
3272-4	78-8076-5455-9	E-Stop Button
3272-5	78-8057-5807-1	Cord Grip
3272-6	78-8060-8053-3	Wire - 3-Pole, 5 Meters Length
3272-7	78-8028-7909-4	Power Cord U.S.A.
3272-8	78-8076-5456-7	Support - Switch
3272-9	26-1003-5707-3	Screw - Phillips Dr, M4 x 16
3272-10	26-1003-6914-4	Nut - Plastic Inset, M4
3272-11	78-8060-8087-1	Screw - M5 x 10, Metric

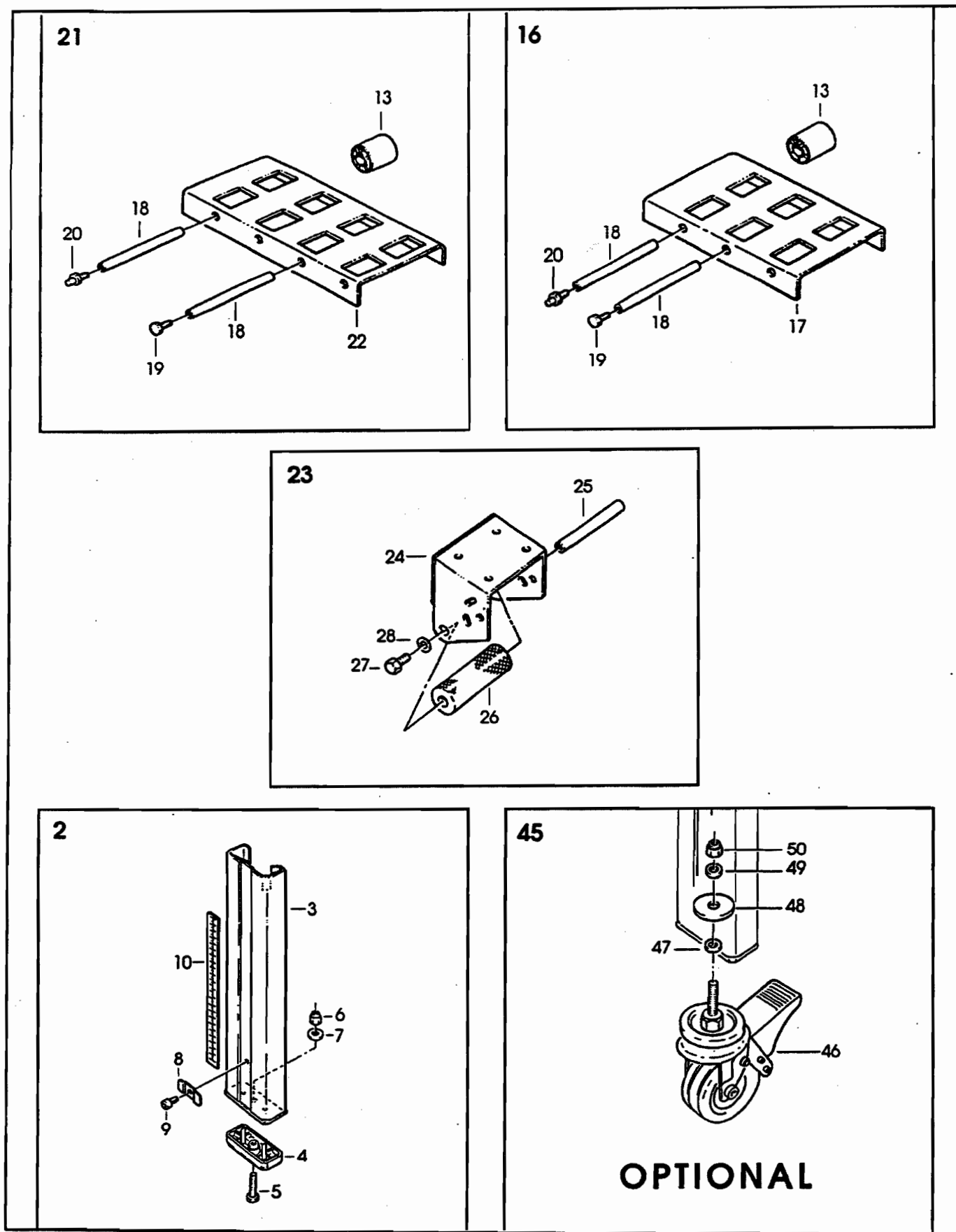
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Figure 3416 (Page 1 of 2)

Ref. No.	3M Part No.	Description
3416-1	78-8076-5380-9	Bed - Conveyor
3416-2	78-8076-5381-7	Leg Assembly - Inner, W/Stop
3416-3	78-8076-5382-5	Leg - Inner
3416-4	78-8060-8480-8	Pad - Foot
3416-5	78-8055-0867-4	Screw - Hex Hd, M8 x 30
3416-6	78-8017-9313-0	Nut - Self-Locking, M8
3416-7	78-8017-9318-9	Washer - Plain 8mm, Metric
3416-8	78-8076-5383-3	Stop - Leg
3416-9	26-1003-7963-0	Screw - Soc Hd, M8 x 16
3416-10	78-8060-8481-6	Label - Height
3416-11	78-8052-6676-0	Clamp - Outer
3416-12	78-8052-6677-8	Clamp - Inner
3416-13	78-8060-7693-7	Roller - 32 x 38
3416-14	78-8076-5384-1	Shaft - Roller
3416-15	78-8076-5385-8	Spring
3416-16	78-8076-5386-6	Conveyor Assembly - Front
3416-17	78-8076-5387-4	Conveyor - Front
3416-18	78-8076-5388-2	Shaft - Conveyor
3416-19	26-1003-5828-7	Screw - Hex Hd, M6 x 10
3416-20	78-8076-5389-0	Mounting - Conveyor
3416-21	78-8076-5390-8	Conveyor Assembly - Rear
3416-22	78-8076-5391-6	Conveyor - Rear
3416-23	78-8076-5392-4	Support - Tape Drum
3416-24	78-8060-8483-2	Support - Outboard Roll
3416-25	78-8060-8484-0	Shaft - Roller

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OPTIONAL

Figure 3416/2 of 2

Figure 3416 (Page 2 of 2)

Ref. No.	3M Part No.	Description
3416-26	78-8060-8485-7	Roller
3416-27	78-8032-0375-7	Screw - Hex Hd M6 x 16, Metric
3416-28	26-1000-0010-3	Washer - Flat M6
3416-29	26-1003-7957-2	Screw - Soc Hd Hex Hd M6 x 16
3416-30	78-8060-8487-3	Cover - Switch
3416-31	78-8060-8087-1	Screw - M5 x 10, Metric
3416-32	78-8010-7417-6	Nut - Hex M5, Metric
3416-33	78-8076-5393-2	Plate - Tape Bracket Support
3416-34	78-8076-5394-0	Spacer
3416-35	78-8076-5483-1	Support - Roller, Chain Tensioning
3416-36	78-8076-5484-9	Cover - R/H
3416-37	78-8076-5485-6	Cover - L/H
3416-38	78-8060-7876-8	Cover - Plug, Lateral
3416-39	78-8060-7873-5	Plug - Female
3416-40	78-8028-8208-0	Screw - 6P x 9,5
3416-41	78-8076-4991-4	Spacer
3416-42	78-8060-8488-1	Screw - Hex Hd M5 x 20
3416-43	78-8046-8217-3	Washer - Special
3416-44	78-8005-5741-1	Washer - Plain M5, Metric
3416-45	78-8060-8060-8	Caster Assembly - Y/80
3416-46	78-8060-8061-6	Caster - /80
3416-47	78-8060-8124-2	Spacer - Caster
3416-48	78-8060-7699-4	Washer - /12-45, 5 x 4
3416-49	78-8017-9059-9	Washer - Flat For M12 Screw
3416-50	78-8060-7532-7	Nut - M12 Self-Locking

800ab Adjustable Case Sealer

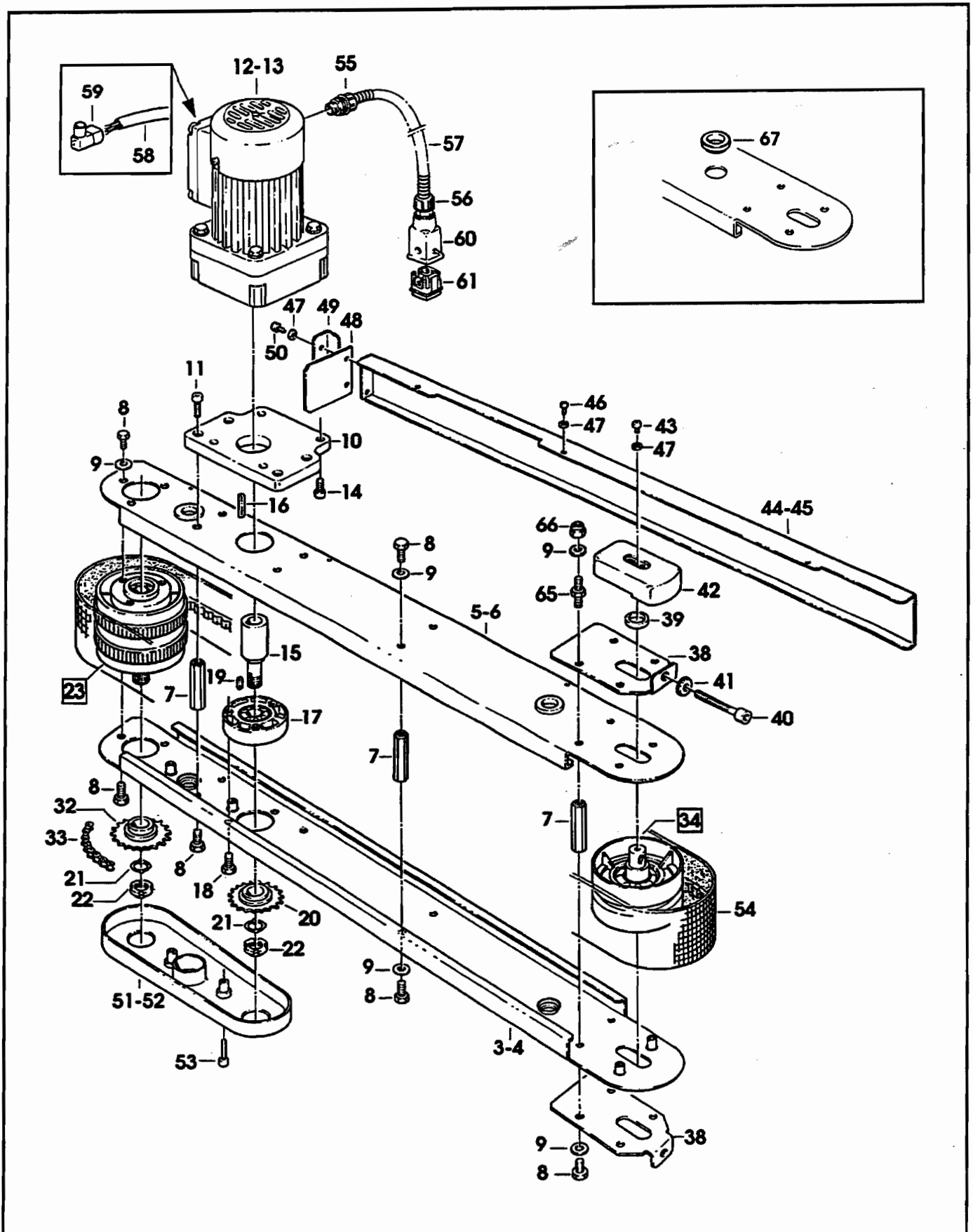


Figure 3417/1 of 2

Figure 3417 (Page 1 of 2)

Ref. No.	3M Part No.	Description
3417-1	78-8091-0661-6	Side Drive Assembly - R/H, W/O Motor
3417-2	78-8091-0662-4	Side Drive Assembly - L/H, W/O Motor
3417-3	78-8076-5434-4	Guide - Lower, R/H
3417-4	78-8076-5435-1	Guide - Lower, L/H
3417-5	78-8076-5436-9	Guide - Upper, R/H
3417-6	78-8076-5437-7	Guide - Upper, L/H
3417-7	78-8055-0661-1	Spacer
3417-8	26-1003-5829-5	Screw - Hex Hd M6 x 12
3417-9	26-1000-0010-3	Washer - Flat M6
3417-10	78-8076-4856-9	Support - Bodine Gearmotor
3417-11	78-8010-7211-3	Screw - Soc Hd M6 x 25
3417-12	78-8076-4857-7	Gearmotor - Bodine 481, 115V, 60Hz, W/Capacitor
3417-13	26-1006-7631-6	Capacitor - 12.5 - 250V, W/3.75 Inch Leads
3417-14	78-8070-1523-1	Screw - 1/4 - 28 x 1/2 SHCS
3417-15	78-8076-5438-5	Extension
3417-16	78-8057-5739-6	Key - M5 x 5 x 30 mm
3417-17	78-8076-5439-3	Flange Assembly
3417-18	78-8060-7886-7	Screw - Hex Hd M6 x 16, Special
3417-19	78-8046-8135-7	Key - 5 x 5 x 12 mm
3417-20	78-8076-4860-1	Sprocket - 3/8 Inch, Z=17
3417-21	78-8057-5834-5	Tab Washer
3417-22	78-8057-5835-2	Centering Washer
3417-23	78-8076-5440-1	Pulley Assembly - Drive
3417-24	78-8091-0716-8	Roller - Drive
3417-25	78-8052-6713-1	Ring - Polyurethane
3417-26	78-8055-0669-4	Shaft - Pulley Keyed
3417-27	78-8057-5739-6	Key - M5 x 5 x 30 mm
3417-28	78-8055-0668-6	Washer - 15/26 x 1
3417-29	78-8076-5442-7	Flange Assembly
3417-30	26-0001-5862-1	Screw - Flat Hd Soc M5 x 12
3417-31	78-8054-8877-8	Washer - 5,5/20 x 4
3417-32	78-8076-4861-9	Sprocket - 3/8 Inch, Z=20
3417-33	78-8076-4933-6	Chain - 3/8 Inch Pitch, 52 Pitch
3417-34	78-8076-5443-5	Pulley Assembly - Idler

800ab Adjustable Case Sealer

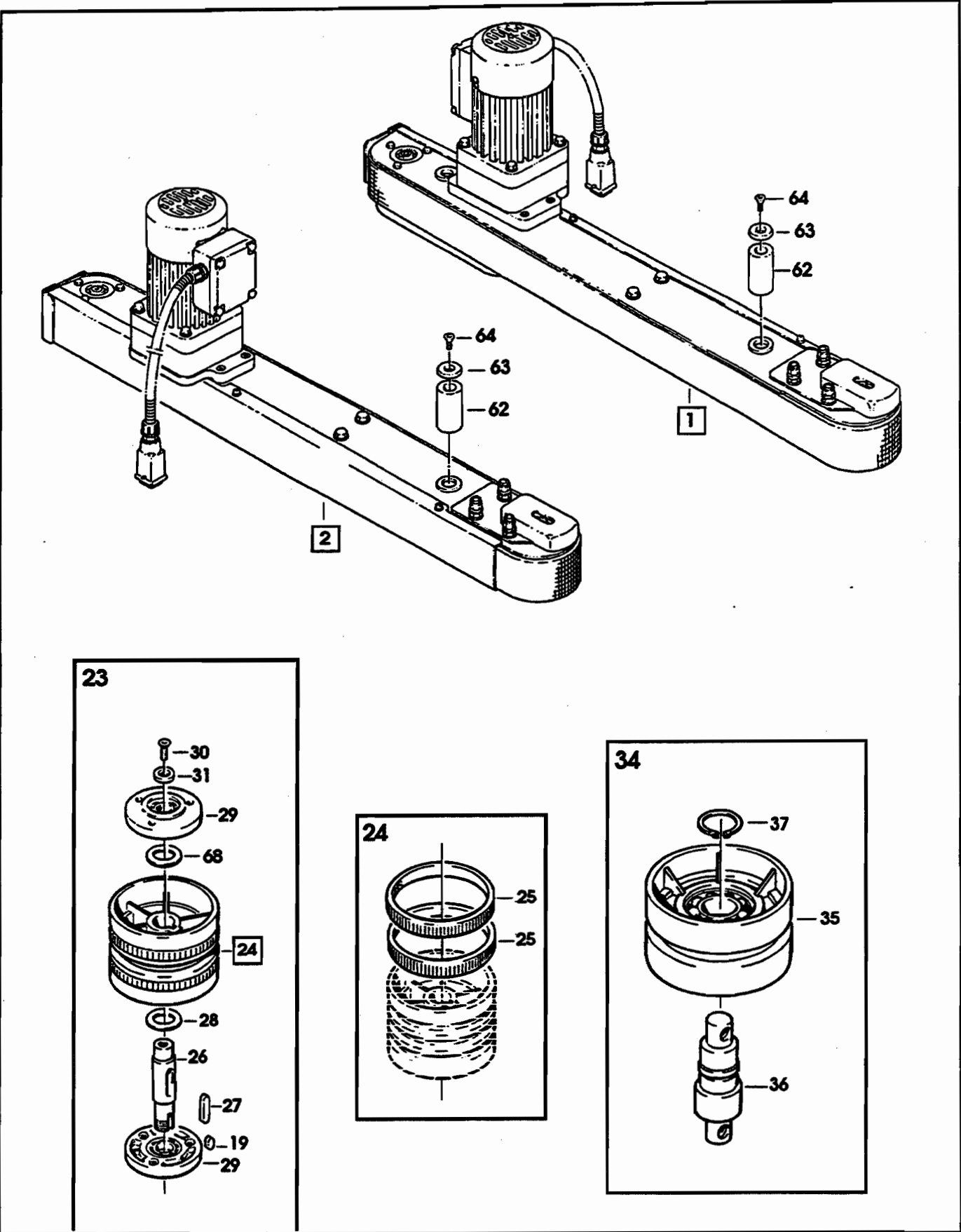


Figure 3417/2 of 2

Figure 3417 (Page 2 of 2)

Ref. No.	3M Part No.	Description
3417-35	78-8055-0660-3	Roller - Idler
3417-36	78-8076-5444-3	Shaft - Idler Pulley
3417-37	12-7997-0272-0	E-Ring - M-25
3417-38	78-8076-5445-0	Tensioning Belt
3417-39	78-8076-5446-8	Washer - Shaft
3417-40	78-8076-5447-6	Screw - Special, M8 x 70
3417-41	78-8017-9318-9	Washer - Plain 8 mm, Metric
3417-42	78-8076-5448-4	Cover - Belt Tensioner
3417-43	78-8055-0850-0	Screw - Cap M4 x 6
3417-44	78-8076-5449-2	Cover - Drive, R/H
3417-45	78-8076-5450-0	Cover - Drive, L/H
3417-46	26-1002-5753-9	Screw - Self-Tapping
3417-47	78-8005-5740-3	Washer - Plain 4 mm, Metric
3417-48	78-8055-0650-4	Guard - Belt
3417-49	78-8076-5451-8	Guard - Belt
3417-50	26-1002-4955-1	Screw - Self-Tap 8P x 13
3417-51	78-8076-4866-8	Cover - Right
3417-52	78-8076-4867-6	Cover - Left
3417-53	78-8010-7165-1	Screw - Flat Hd Soc M5 x 25
3417-54	78-8076-5452-6	Belt - Box Drive
3417-55	78-8060-7631-7	Connector - 3/8 Inch
3417-56	78-8060-7626-7	Connector - PG 11/12
3417-57	78-8076-5197-7	Sleeving - /12, 800 mm
3417-58	78-8060-8053-3	Wire - 3-Pole, 5 Meters Length
3417-59	78-8076-4602-7	Terminal
3417-60	78-8060-7877-6	Plug Housing - Vertical
3417-61	78-8060-7875-0	Plug - Female
3417-62	78-8076-5453-4	Roller
3417-63	78-8054-8577-4	Washer - Special
3417-64	26-1001-9843-6	Screw - Flat Soc Hd M6 x 16
3417-65	78-8076-5486-4	Screw - Special M6
3417-66	26-1003-6916-9	Nut - Locking M6, Plastic Insert
3417-67	78-8091-0500-6	Bushing - Side Drive
3417-68	78-8091-0382-9	Washer - Belleville /16

800ab Adjustable Case Sealer

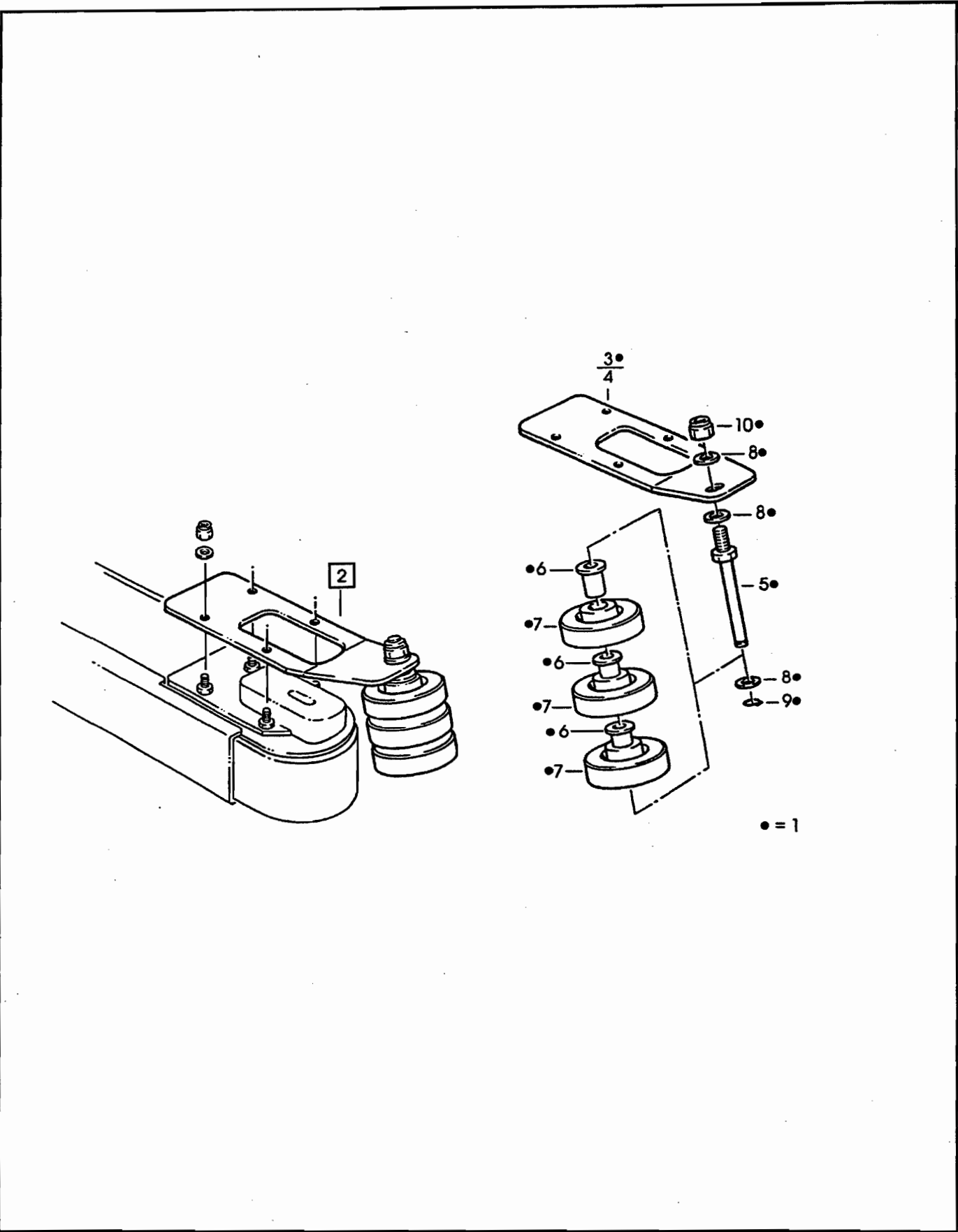


Figure 3418

Figure 3418

Ref. No.	3M Part No.	Description
3418-1	78-8076-5487-2	Roller Assembly - R/H
3418-2	78-8076-5488-0	Roller Assembly - L/H
3418-3	78-8076-5489-8	Bracket - R/H
3418-4	78-8076-5490-6	Bracket - L/H
3418-5	78-8076-5491-4	Shaft - Roller
3418-6	78-8060-8106-9	Bushing - Nylon
3418-7	78-8055-0821-1	Rubber Roller
3418-8	78-8052-6566-3	Washer - Friction
3418-9	78-8016-5855-6	E-Ring - 10 mm
3418-10	26-1003-6918-5	Nut - Hex Flange M10, Plastic Insert

800ab Adjustable Case Sealer

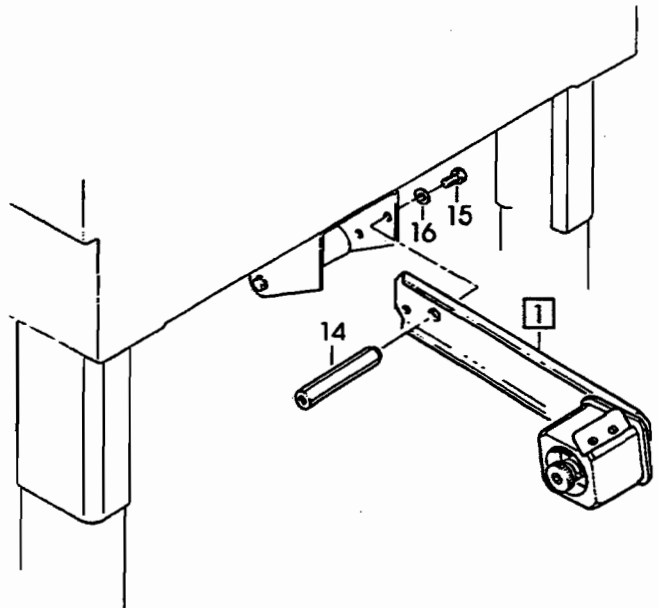
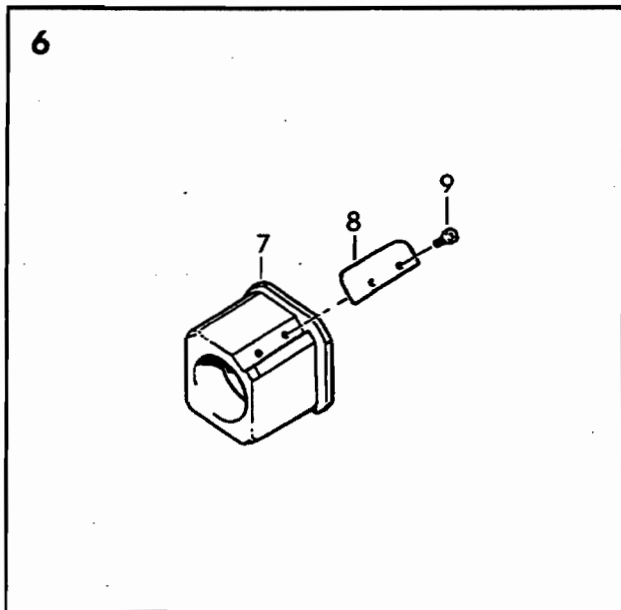
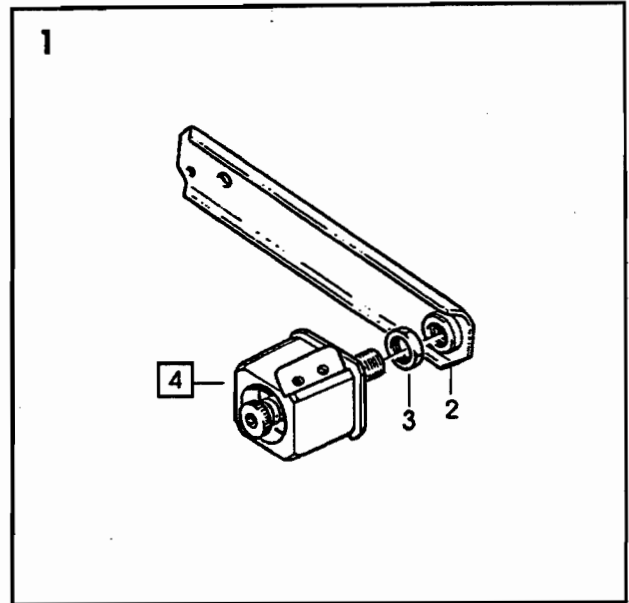
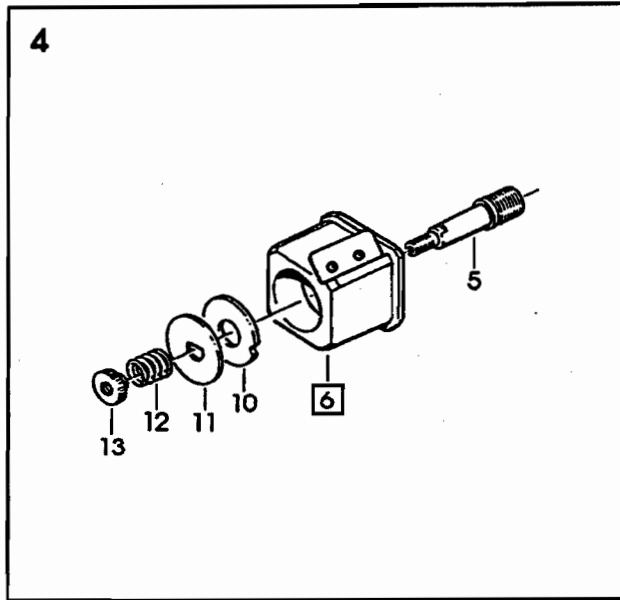


Figure 3419

Figure 3419

Ref. No.	3M Part No.	Description
3419-1	78-8070-1565-2	Tape Drum Bracket Assembly
3419-2	78-8070-1395-4	Bracket - Bushing Assembly
3419-3	78-8017-9169-6	Nut - M18 x 1
3419-4	78-8060-8474-1	Tape Drum Assembly - 2 Inch Head
3419-5	78-8076-4519-3	Shaft - Tape Drum
3419-6	78-8070-1569-4	Tape Drum Assembly - 2 Inch Wide
3419-7	78-8052-6749-5	Tape Drum Assembly
3419-8	78-8052-6268-6	Leaf Spring
3419-9	26-1002-5753-9	Screw - Self-Tapping
3419-10	78-8060-8172-1	Washer - Friction
3419-11	78-8052-6271-0	Washer - Tape Drum
3419-12	78-8054-8826-5	Spring
3419-13	78-8060-7851-1	Ring Nut - Adjusting
3419-14	78-8070-1215-4	Spacer - Stud
3419-15	78-8010-7169-3	Screw - Hex Hd M6 x 12, Metric
3419-16	26-1000-0010-3	Washer - Flat M6

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Replacement Parts - Illustrations and Parts Lists

Taping Head Assemblies - 2 Inch, Upper and Lower

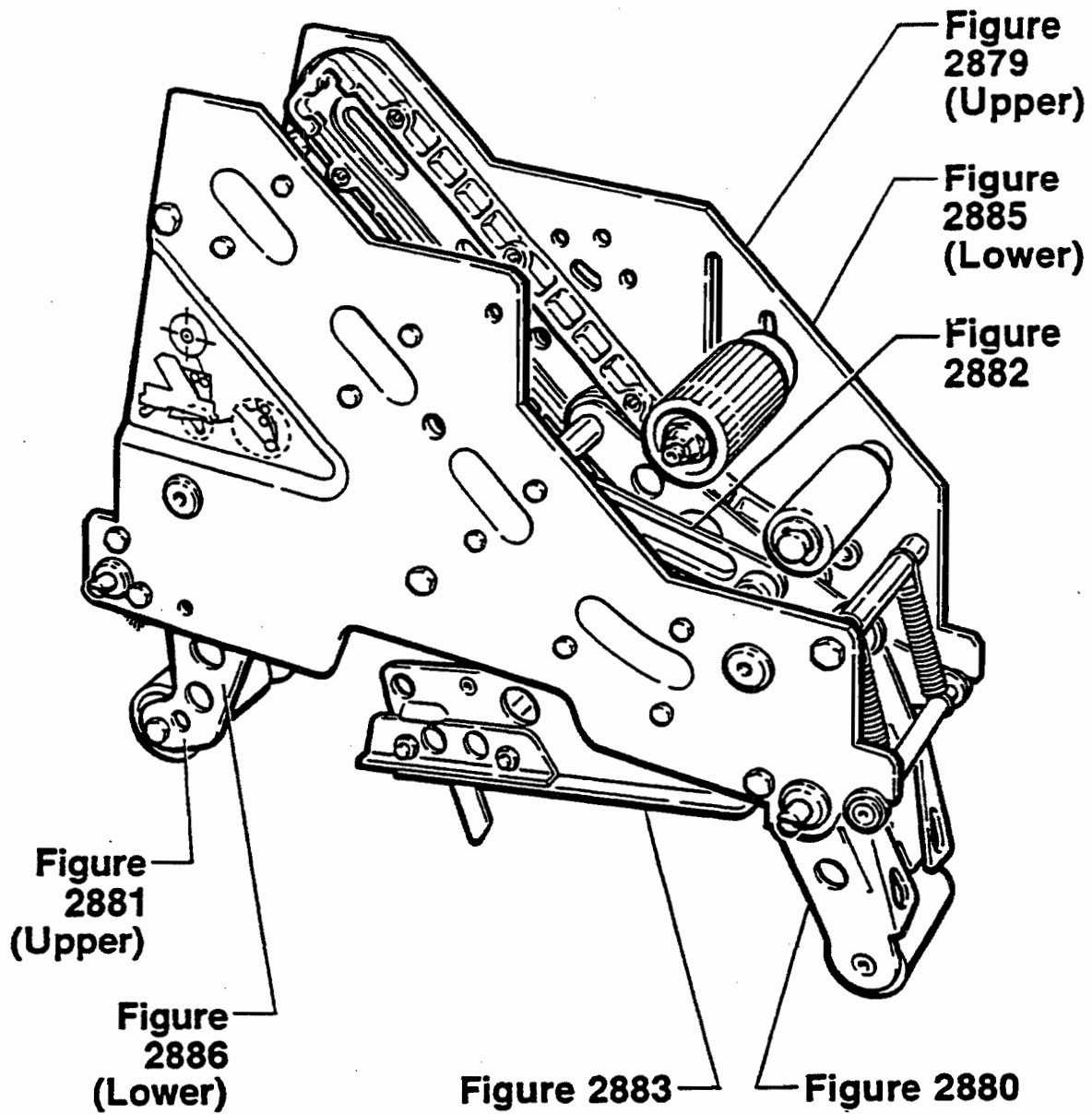
1. Refer to **Taping Head Assemblies** figure to find all the parts illustrations identified by **figure numbers**.
2. Refer to the figure or figures to determine the **individual parts** required and the **parts reference number**.
3. The **replacement parts list**, that follows each illustration, includes 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 38 - "**Replacement Parts and Service Information**" of this manual for replacement parts ordering information.

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Taping Heads - 2 Inch (800a/800ab)



Taping Head - 2 Inch (800a)

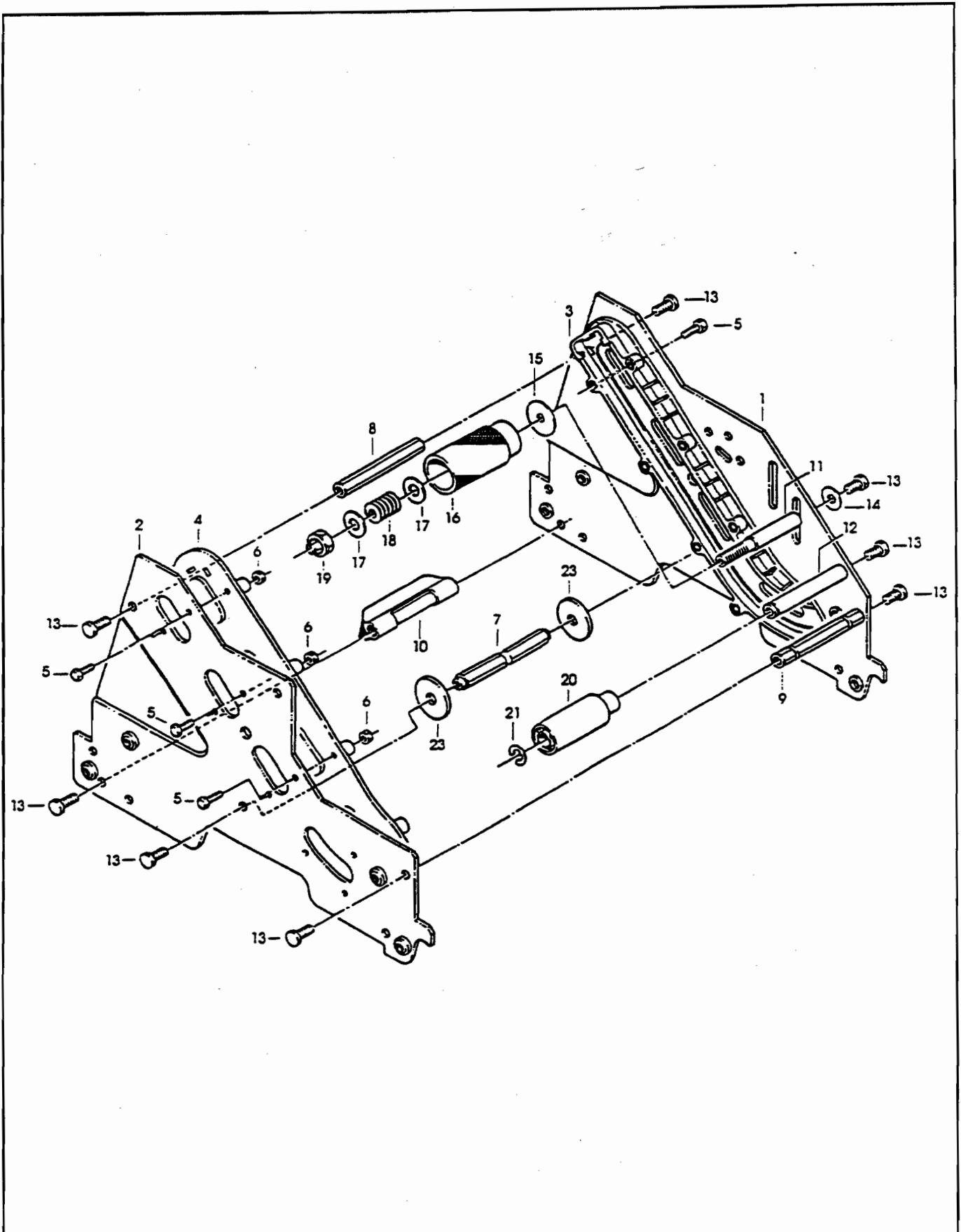


Figure 2879 Upper

Figure 2879 Upper

Ref. No.	3M Part No.	Description
2879-1	78-8070-1386-3	Frame - Tape Mount Upper Assembly
2879-2	78-8070-1387-1	Frame - Front Upper Assembly
2879-3	78-8068-4143-9	Guide - R/H
2879-4	78-8068-4144-7	Guide - L/H
2879-5	83-0002-7336-3	Screw - Hex Hd M4 X 14
2879-6	78-8010-7416-8	Nut - Hex M4
2879-7	78-8070-1251-9	Spacer - Spring
2879-8	78-8052-6559-8	Spacer - Upper
2879-9	78-8052-6560-6	Spacer - Front
2879-10	78-8060-7936-0	Brush Assembly
2879-11	78-8052-6564-8	Shaft - Tension Roller
2879-12	78-8052-6568-9	Shaft - Wrap Roller
2879-13	26-1003-5828-7	Screw - Hex Hd M6 x 12
2879-14	78-8042-2919-9	Washer - Triple M6
2879-15	78-8070-1268-3	Washer - Roll Back Up
2879-16	78-8052-6565-5	Roller - Top Tension
2879-17	78-8052-6566-3	Washer - Friction
2879-18	78-8052-6567-1	Spring - Compression
2879-19	78-8017-9077-1	Nut - Self Locking M10 x 1
2879-20	78-8052-6569-7	Roller - Wrap
2879-21	26-1000-1613-3	Ring - Retaining, No. 10DIN6799
2879-23	78-8076-5242-1	Stop - Cut-Off Frame

Taping Head - 2 Inch (800a/800ab)

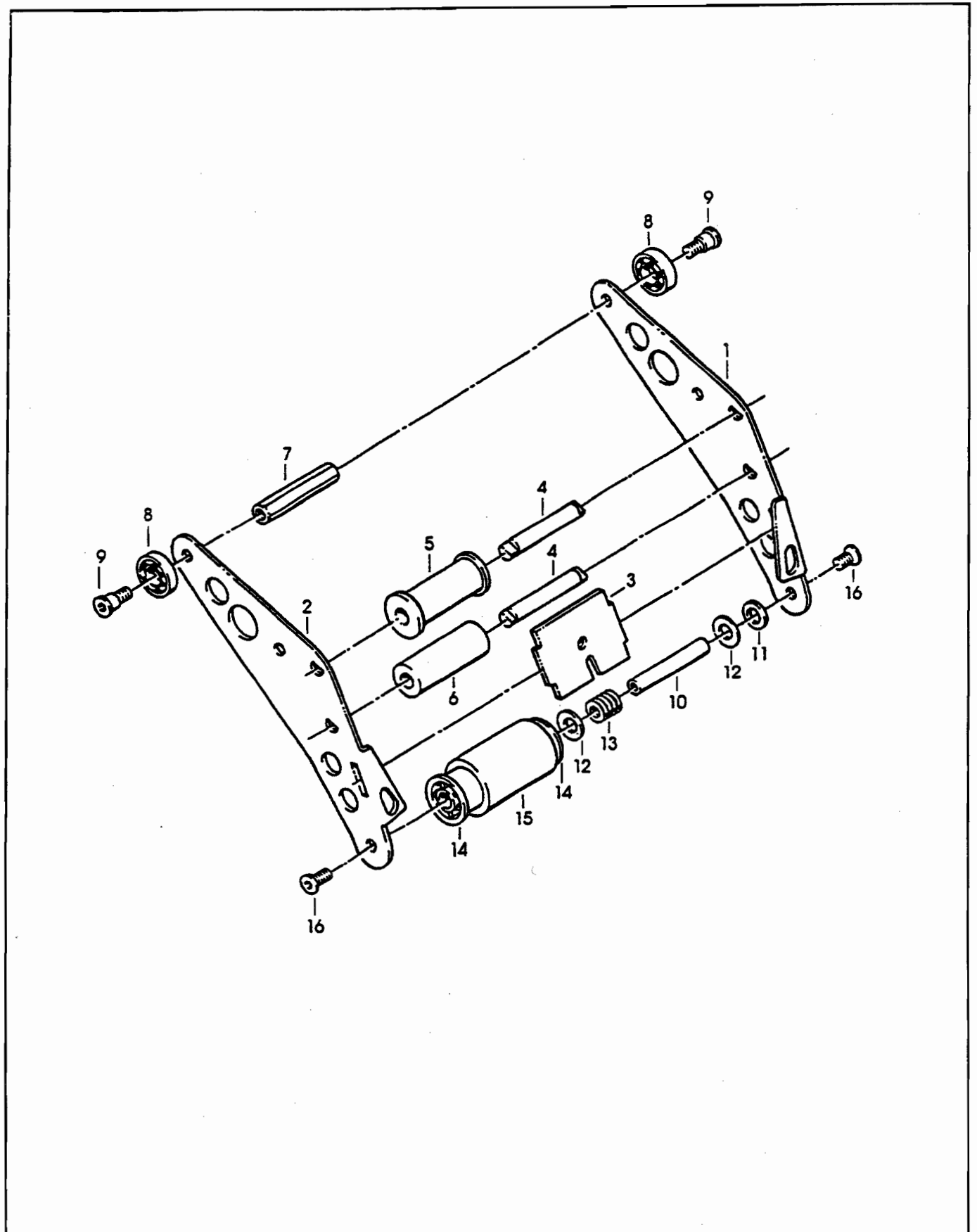


Figure 2880

Figure 2880

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

Taping Head - 2 Inch (800a)

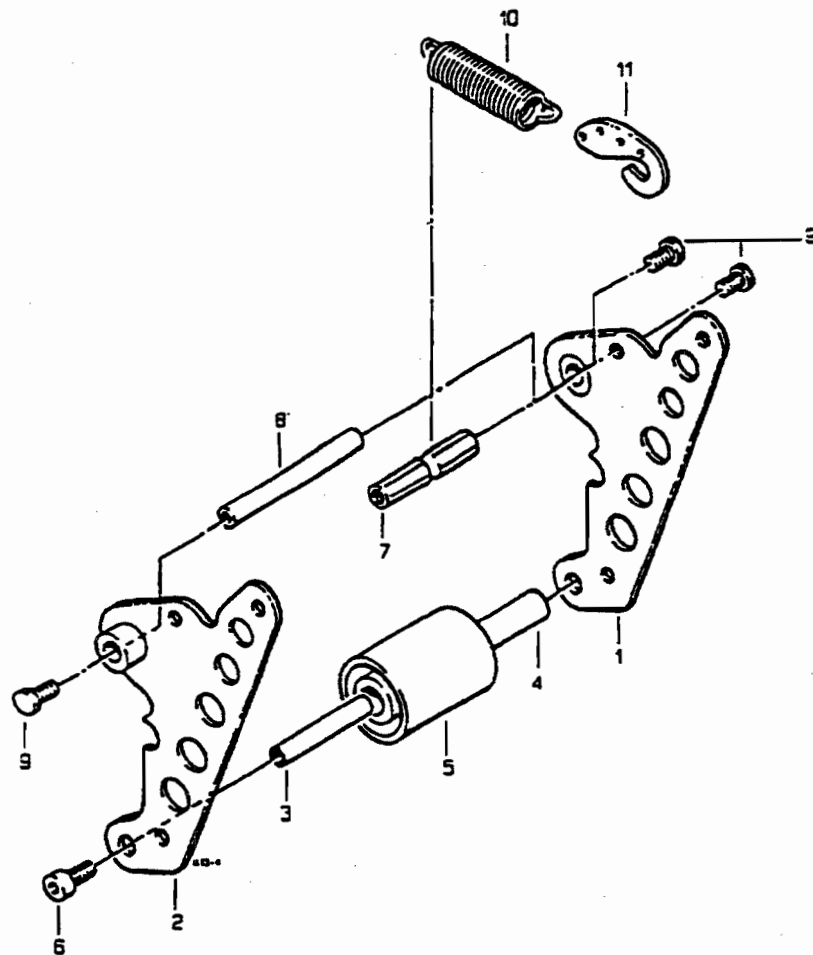


Figure 2881 Upper

Figure 2881 Upper

Ref. No.	3M Part No.	Description
2881-1	78-8070-1392-1	Buffing Arm - Sub Assembly
2881-2	78-8070-1391-3	Buffing Arm - Sub Assembly
2881-3	78-8052-6575-4	Shaft - Roller
2881-4	78-8052-6586-1	Bushing - Buffing Roller
2881-5	78-8057-6178-6	Roller - Buffing NM
2881-6	78-8076-4503-7	Screw - M6 x 12
2881-7	78-8070-1220-4	Spacer - Spring
2881-8	78-8017-9109-2	Shaft - 110 x 90 mm
2881-9	26-1003-5828-7	Screw - Hex Hd M6 x 12
2881-10	78-8070-1274-1	Spring - Upper
2881-11	78-8070-1244-4	Holder - Spring

Taping Head - 2 Inch (800a/800ab)

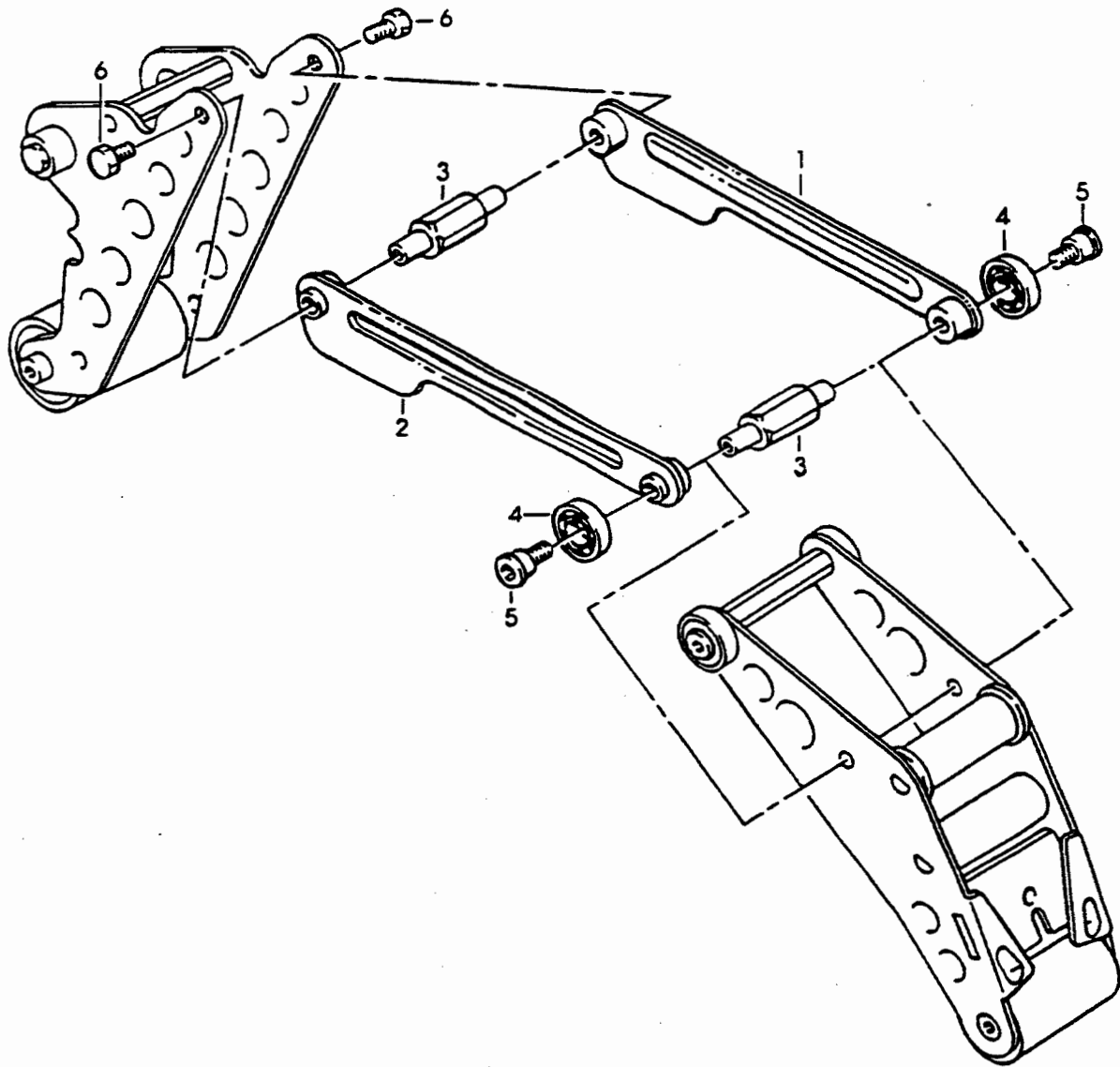


Figure 2882

Figure 2882

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

Taping Head - 2 Inch (800a/800ab)

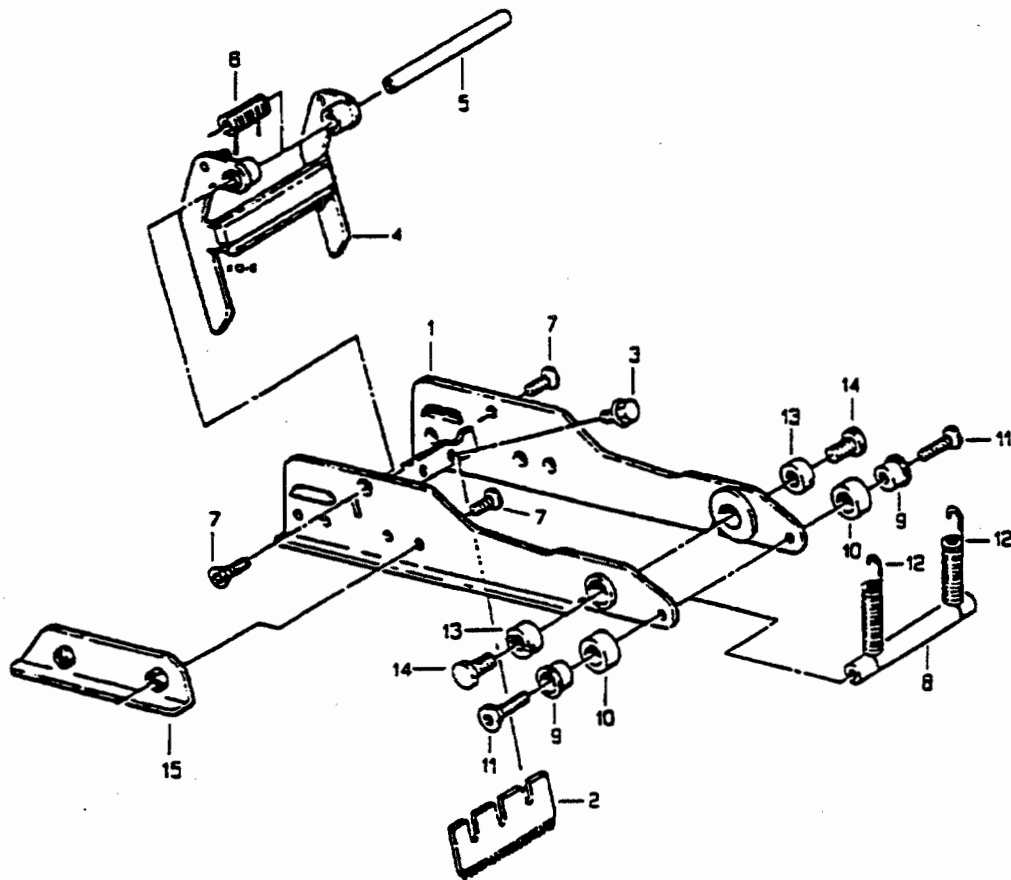


Figure 2883

Figure 2883

Ref. No.	3M Part No.	Description
2883-1	78-8070-1217-0	Frame - Cut-Off Weldment
2883-2	78-8017-9173-8	Blade - 2.56 Inch/65 mm
2883-3	26-1003-8596-7	Screw - Hex Hd M5 x 8 W/Ext. Tooth Washer
2883-4	78-8070-1371-5	Guard - Blade Assembly
2883-5	78-8052-6597-8	Shaft - Blade Guard
2883-6	78-8070-1390-5	Spring - Tension
2883-7	26-1005-4757-4	Screw - Flat Hd M4 x 100
2883-8	78-8017-9135-7	Shaft - Spacer
2883-9	78-8052-6600-0	Spacer
2883-10	78-8070-1269-1	Bumper
2883-11	26-1005-4758-2	Screw - Flat Hd M5 x 20
2883-12	78-8052-6602-6	Spring - Cutter
2883-13	78-8017-9132-4	Pivot - Cutter Lever
2883-14	26-1003-5828-7	Screw - Hex Hd M6 x 10
2883-15	78-8070-1216-2	Slide - Extension

This technical drawing is an exploded view of a mechanical assembly, likely a door latch or lock mechanism. The diagram shows the following components and their assembly sequence:

- Part 1:** The main rectangular base plate.
- Part 2:** A curved metal bracket that fits into the top of the base plate.
- Part 3:** A small pin or screw used to secure the bracket to the base plate.
- Part 4:** A small circular component, possibly a washer or spacer, located between the bracket and the base plate.
- Part 5:** A small screw or pin used for additional fastening.
- Part 6:** A small circular component, similar to part 4, located further along the bracket.
- Part 7:** A long, thin cylindrical rod or pin.
- Part 8:** A small cylindrical component, possibly a bush or spacer.
- Part 9:** A small cylindrical component, possibly a bush or spacer.
- Part 10:** A small cylindrical component, possibly a bush or spacer.
- Part 11:** A small cylindrical component, possibly a bush or spacer.
- Part 12:** A small cylindrical component, possibly a bush or spacer.
- Part 13:** A small cylindrical component, possibly a bush or spacer.
- Part 14:** A small cylindrical component, possibly a bush or spacer.
- Part 15:** A small cylindrical component, possibly a bush or spacer.
- Part 16:** A small cylindrical component, possibly a bush or spacer.
- Part 17:** A small cylindrical component, possibly a bush or spacer.
- Part 18:** A small cylindrical component, possibly a bush or spacer.
- Part 19:** A small cylindrical component, possibly a bush or spacer.
- Part 20:** A small cylindrical component, possibly a bush or spacer.
- Part 21:** A small cylindrical component, possibly a bush or spacer.
- Part 23:** A small cylindrical component, possibly a bush or spacer.

The diagram uses dashed lines to indicate the alignment and assembly path of the various components. The parts are numbered 1 through 23, with some numbers appearing multiple times to indicate identical parts.

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Figure 2885 Lower

Ref. No.	3M Part No.	Description
2885-1	78-8070-1369-9	Frame - Tape Mount Lower Assembly
2885-2	78-8070-1370-7	Frame - Front Lower Assembly
2885-3	78-8068-4144-7	Guide - R/H
2885-4	78-8068-4143-9	Guide - L/H
2885-5	83-0002-7336-3	Screw - Hex Hd M4 x 14
2885-6	78-8010-7416-8	Nut - Hex M4
2885-7	78-8070-1251-9	Spacer - Spring
2885-8	78-8052-6559-8	Spacer - Upper
2885-9	78-8052-6560-6	Spacer - Front
2885-10	78-8060-7936-0	Brush Assembly
2885-11	78-8052-6564-8	Shaft - Tension Roller
2885-12	78-8052-6568-9	Shaft - Wrap Roller
2885-13	26-1003-5828-7	Screw - Hex Hd M6 x 12
2885-14	78-8042-2919-9	Washer - Triple M6
2885-15	78-8070-1268-3	Washer - Roll Back Up
2885-16	78-8052-6606-7	Roller - Tension Bottom
2885-17	78-8052-6566-3	Washer - Friction
2885-18	78-8052-6567-1	Spring - Compression
2885-19	78-8017-9077-1	Nut - Self Locking M10 x 1
2885-20	78-8052-6569-7	Roller - Wrap
2885-21	26-1000-1613-3	Ring - Retaining 1DIN6799
2885-23	78-8076-5242-1	Stop - Cut-Off Frame

Taping Head - 2 Inch (800a/800ab)

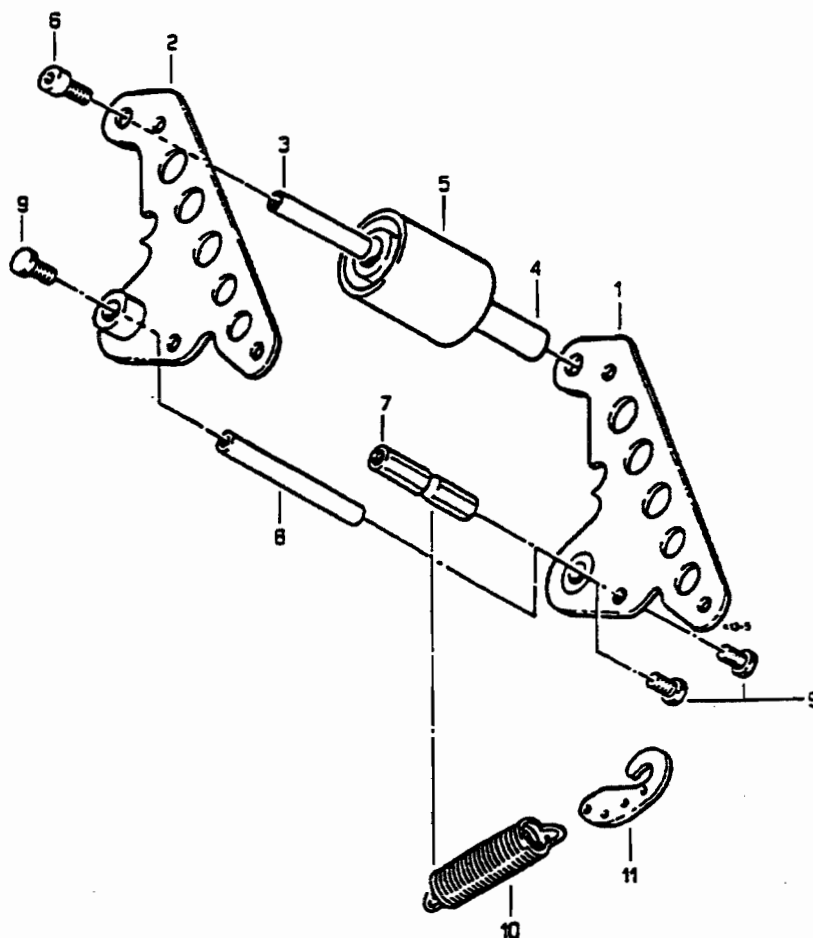


Figure 2886 Lower

Figure 2886 Lower

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

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Replacement Parts - Illustrations and Parts Lists

Taping Head Assemblies - 3 Inch, Upper and Lower

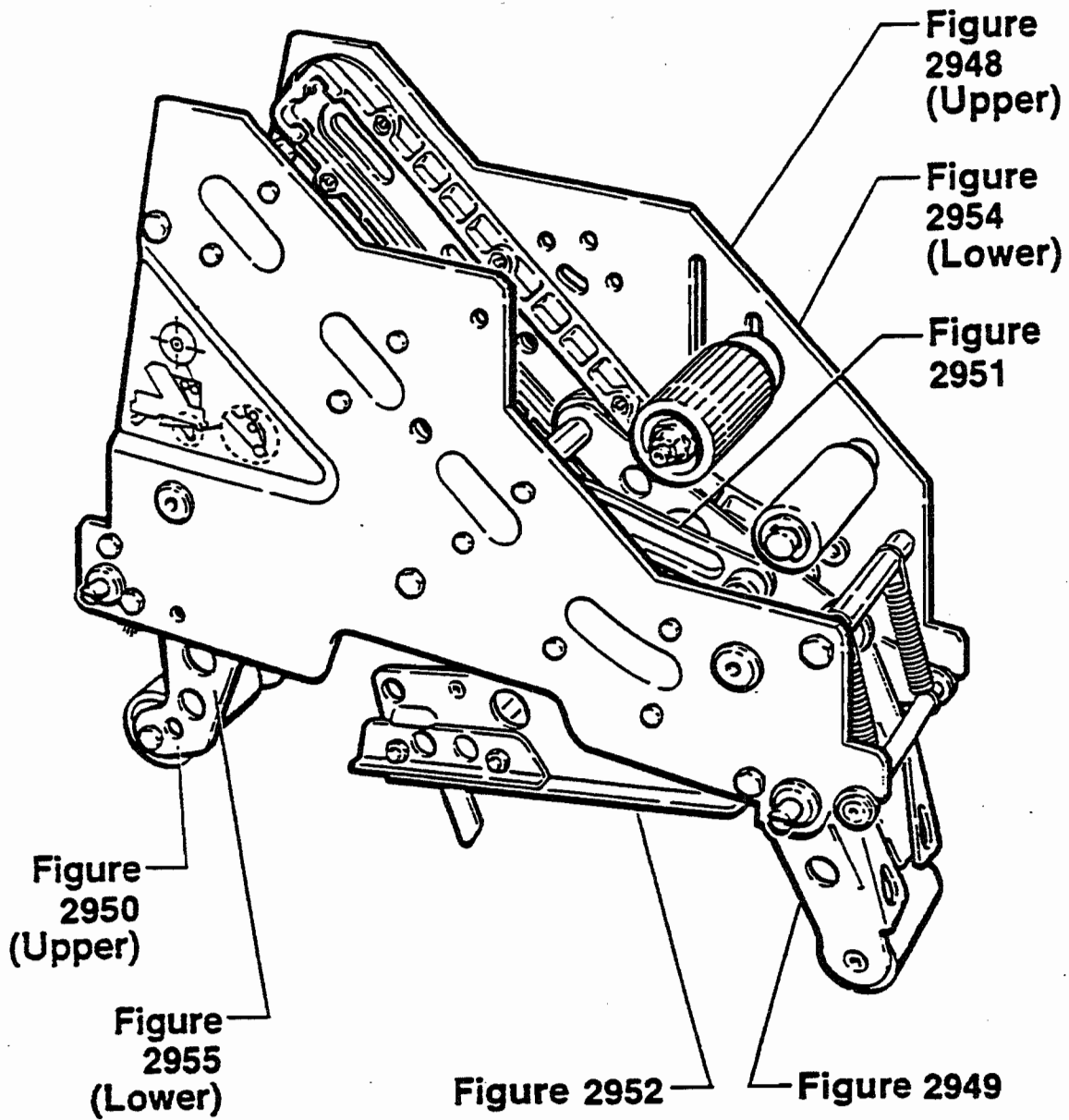
1. Refer to **Taping Head Assemblies** figure to find all the parts illustrations identified by **figure numbers**.
2. Refer to the figure or figures to determine the **individual parts** required and the **parts reference number**.
3. The **replacement parts list**, that follows each illustration, includes 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 38 - "**Replacement Parts and Service Information**" of this manual for replacement parts ordering information.

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Taping Heads - 3 Inch (800a3)



This technical drawing is an exploded view of a mechanical assembly, likely a hinge or a latch mechanism. It shows the following components and their assembly relationships:

- Part 1:** The main housing or frame, shown in two orientations to illustrate how other parts fit into it.
- Part 2:** A bracket or plate that fits into the housing.
- Part 3:** A small pin or roller that fits into a slot in the housing.
- Part 4:** A curved plate or lever arm.
- Part 5:** Small screws or fasteners used to secure various plates and the housing.
- Part 6:** Small spacers or washers used between plates.
- Part 7:** A long, thin rod or pin.
- Part 8:** A long, thin rod or pin, similar to part 7 but with a different end profile.
- Part 9:** A small pin or roller.
- Part 10:** A cylindrical component, possibly a bush or a small cylinder.
- Part 11:** A small pin or roller.
- Part 12:** A small pin or roller.
- Part 13:** Small screws or fasteners, used in multiple locations.
- Part 14:** A small pin or roller.
- Part 15:** A small pin or roller.
- Part 16:** A cylindrical component, possibly a bush or a small cylinder.
- Part 17:** A small pin or roller.
- Part 18:** A small pin or roller.
- Part 19:** A small pin or roller.
- Part 20:** A cylindrical component, possibly a bush or a small cylinder.
- Part 21:** A small pin or roller.
- Part 23:** A small pin or roller.
- Part 24:** A small pin or roller.
- Part 25:** A small pin or roller.

The diagram uses dashed lines to indicate the assembly path and alignment of the components. The parts are numbered 1 through 25, with some numbers (like 5, 6, 13, 25) appearing multiple times to indicate identical parts used in different locations.

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Figure 2948 (Upper)

Ref. No.	3M Part No.	Description
2948-1	78-8070-1386-3	Frame - Tape Mount Upper Assembly
2848-2	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, Metric
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 10DING6799
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 (800a3)

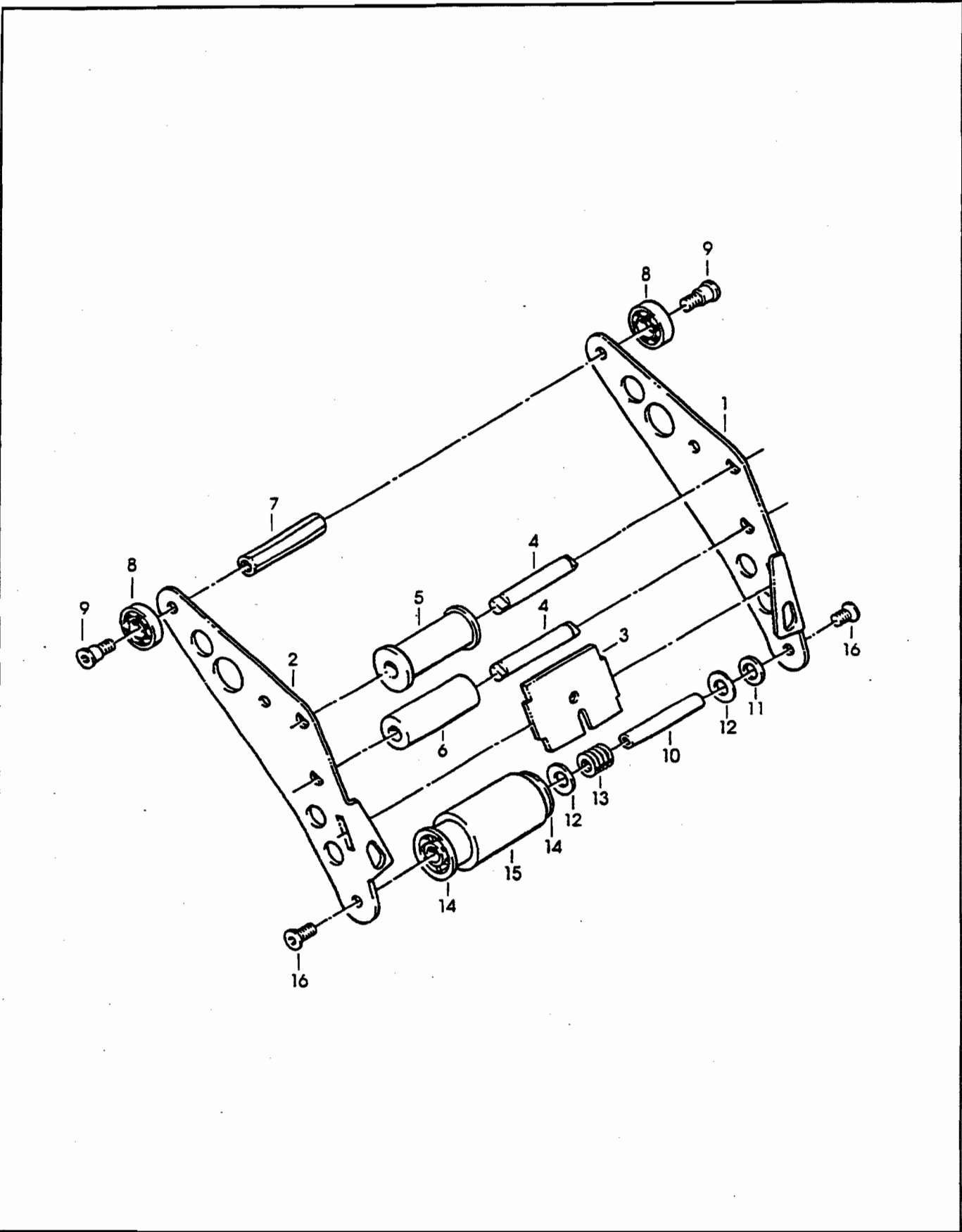


Figure 2949

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
2493-5	78-8076-4737-1	Roller Assembly - Knurled
2949-6	78-8076-4738-9	Roller - Wrap
2949-7	78-8054-8806-7	Spacer
2494-8	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 (800a3)

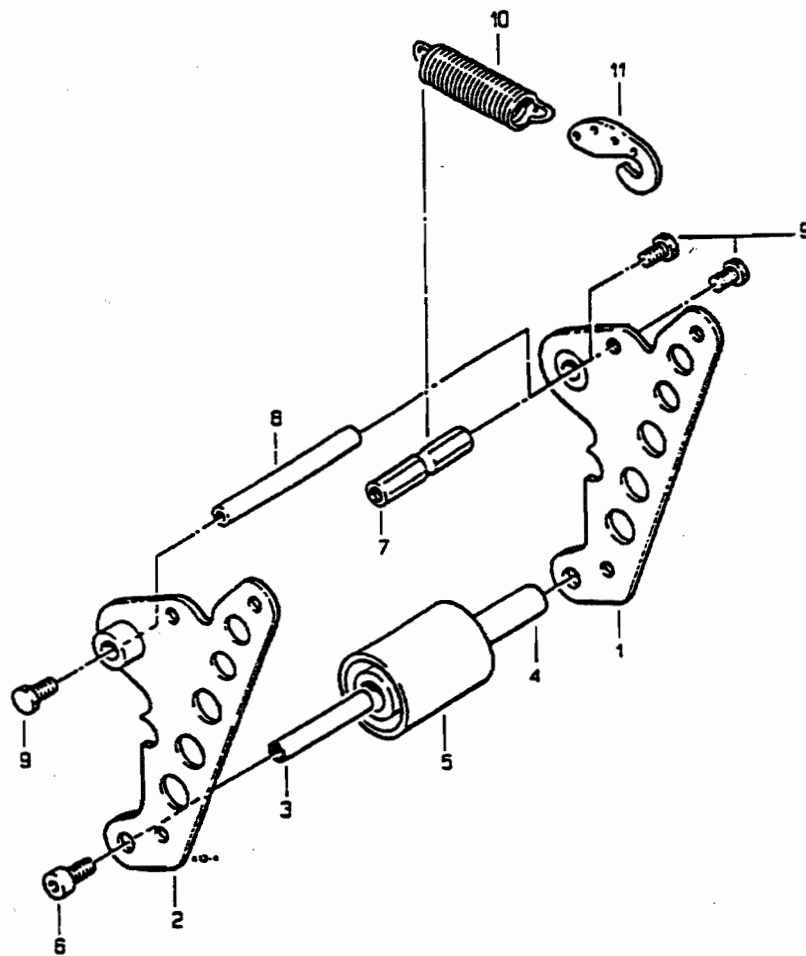


Figure 2950 Upper

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 (800a3)

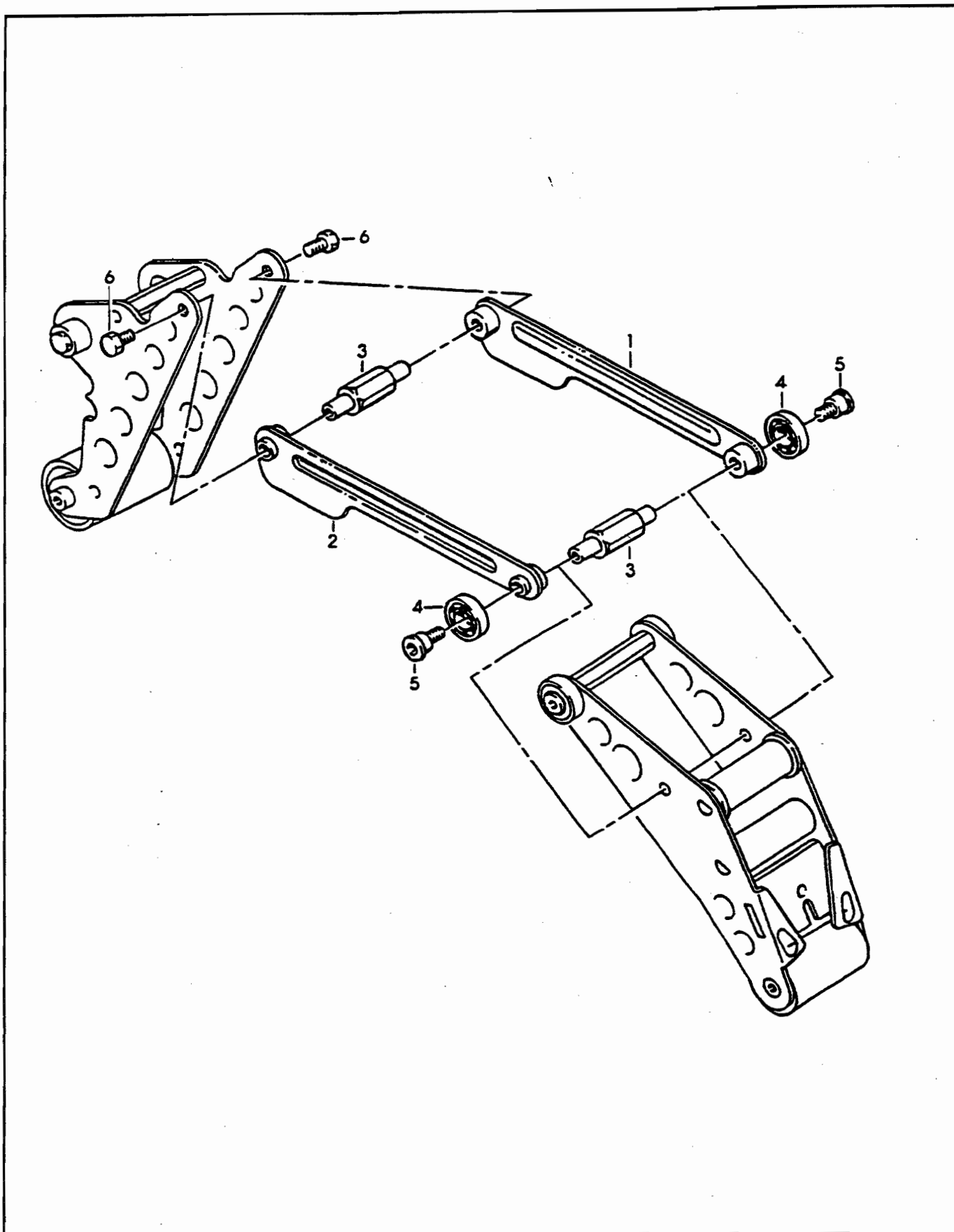


Figure 2951

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 (800a3)

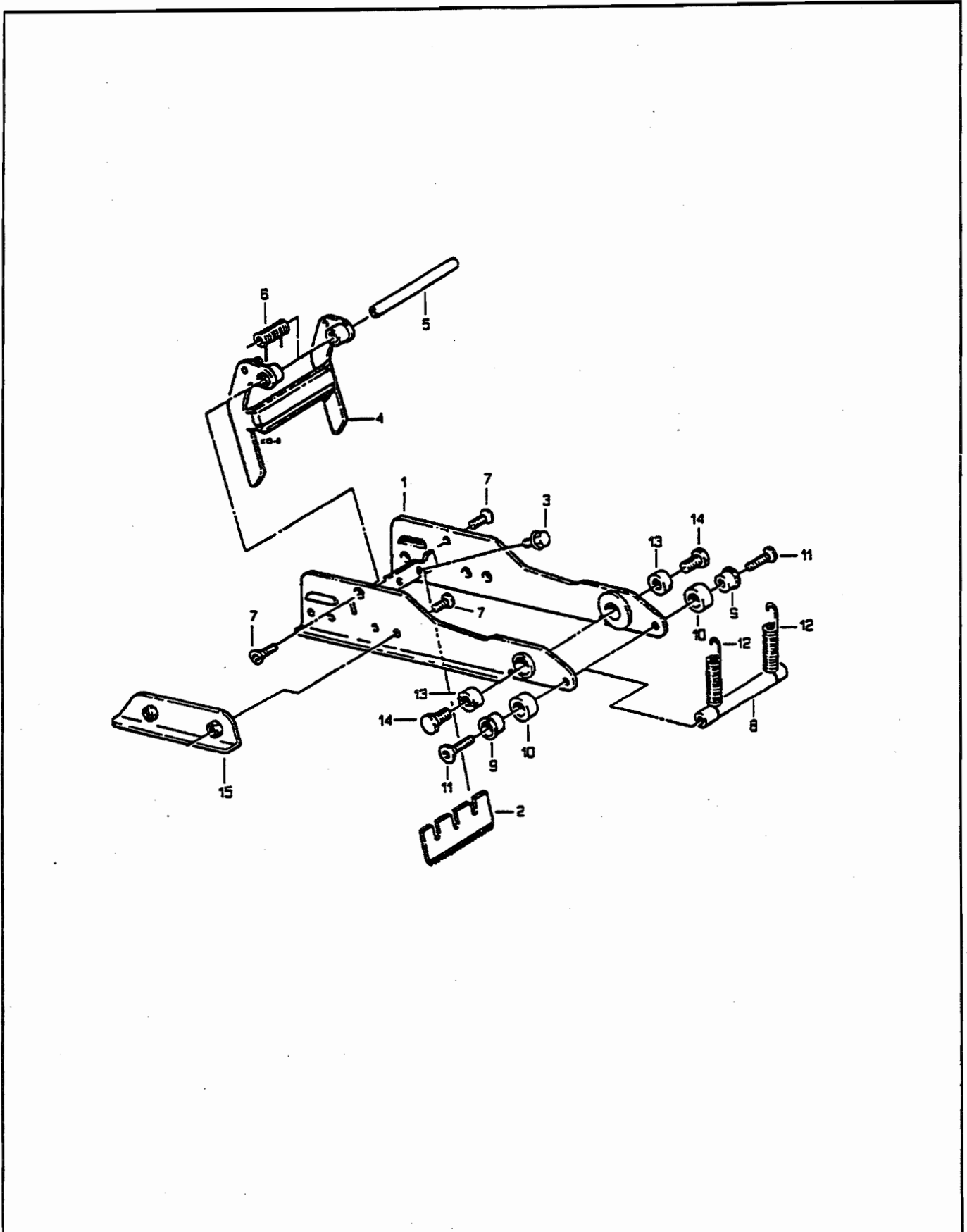


Figure 2952

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 - Torsion
2952-7	26-1005-4757-4	Screw - Flat Hd M4 x 10
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	26-1005-4758-2	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 (800a3)

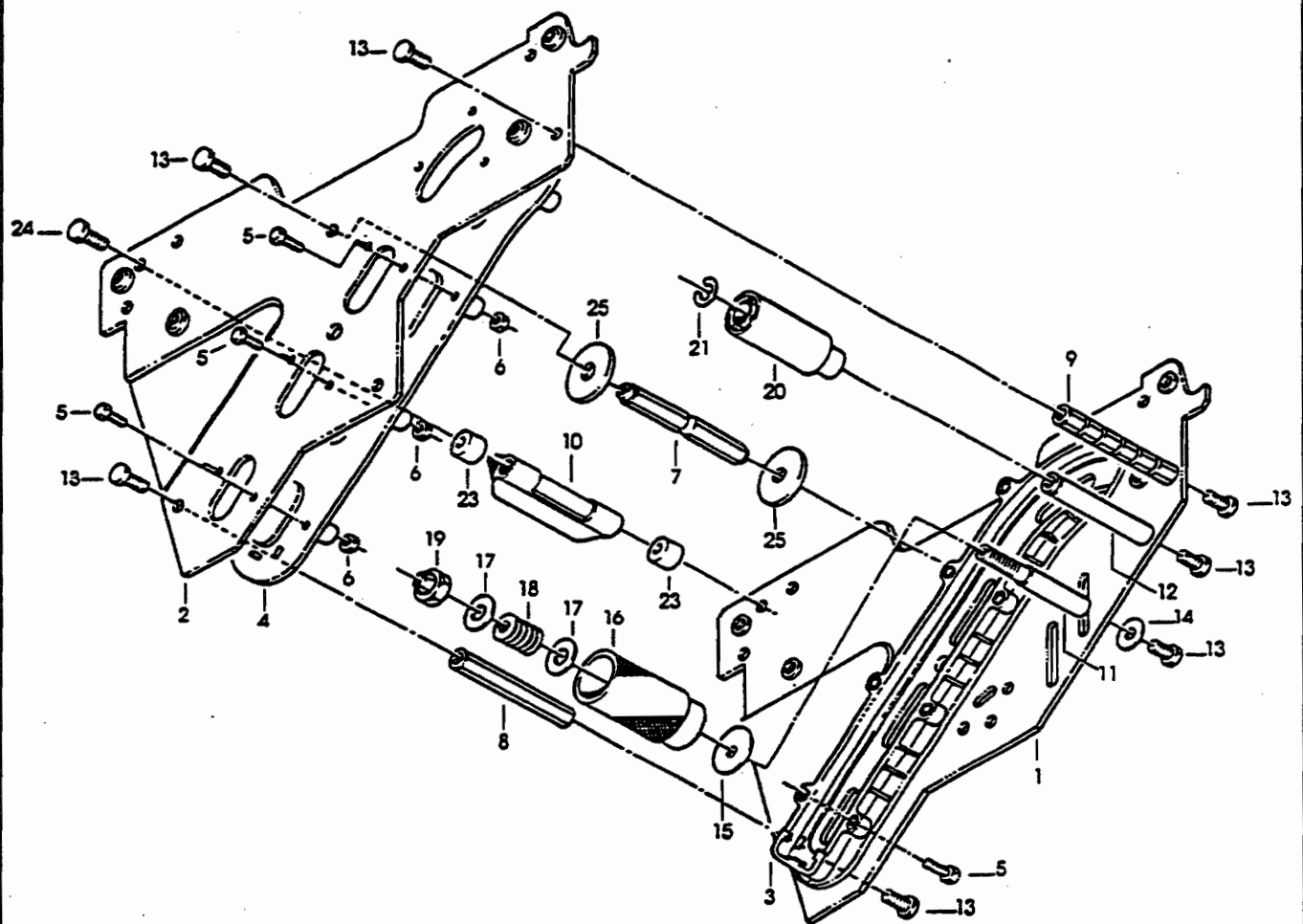


Figure 2954 Lower

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	78-8068-4144-7	Guide - R/H
2954-4	78-8068-4143-9	Guide - L/H
2954-5	83-0002-7336-3	Screw - Hex Hd M4 x 14
2954-6	78-8010-7416-8	Nut - Hex M4, Metric
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 M
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 10DING6799
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 (800a3)

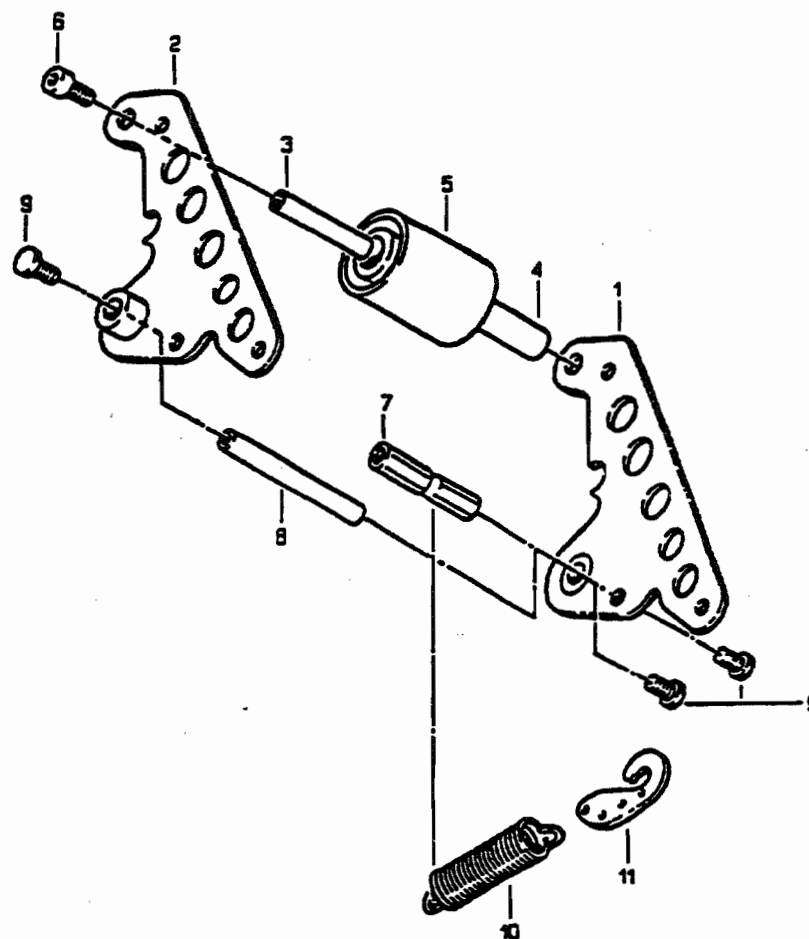


Figure 2955 Lower

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

- Shaded Areas To Be Filled In By 3M -

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

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800-344-9883 (Outside Wisc.)
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