



Instructions and Parts List

3M-Matic™

800ab

Type 29400

**Adjustable
Case Sealer
with
AccuGlide™ II
Taping Heads**

Serial No. _____

For reference, record machine serial number here.



Important Safety Information

Read "Safety Labels",
pages 3-5 and also
operating "Warnings",
page 13 BEFORE
INSTALLING OR
OPERATING THIS
EQUIPMENT.

Spare Parts

It is recommended you
immediately order the
spare parts listed on
page 29. These
parts are expected to
wear through normal use
and should be kept on
hand to minimize
production delays.

3M Masking and Packaging Systems Division

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

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of 3M, St. Paul, MN 55144-1000

Litho in U.S.A.

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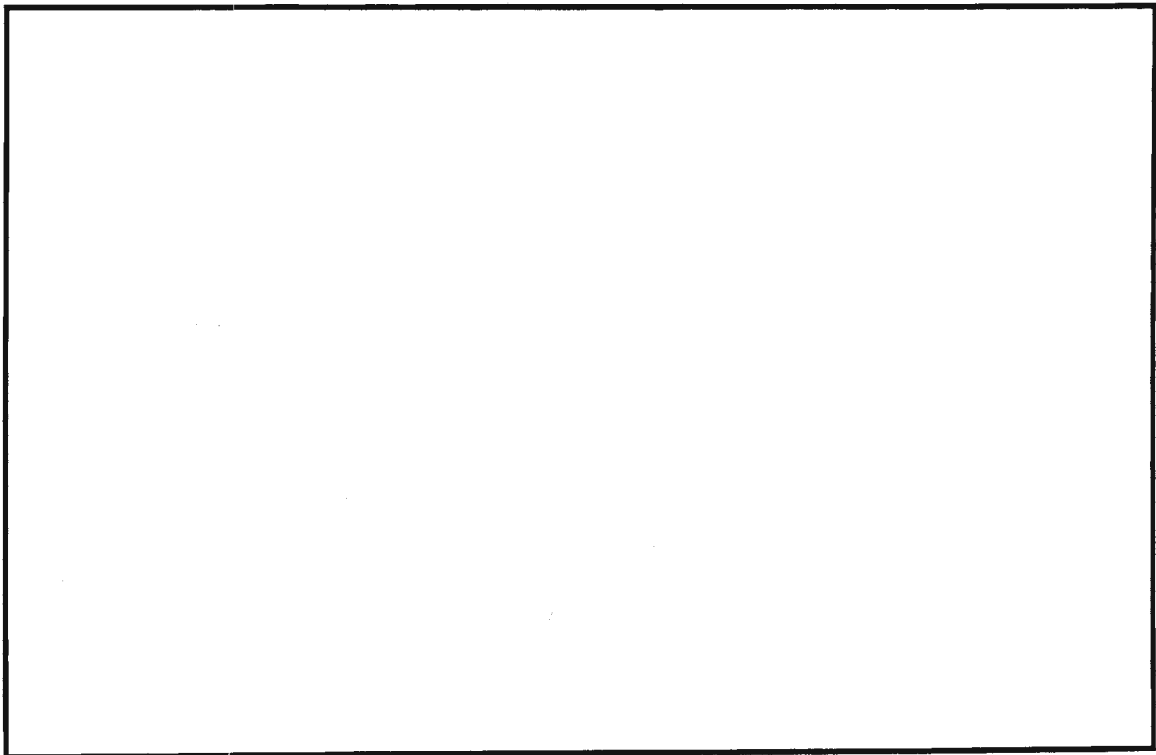
Replacement Parts And Service Information

To Our Customers:

This is the 3M-Matic™/AccuGlide™/Scotch™ brand equipment you ordered. It has been set up and tested in the factory with "Scotch" brand tapes. If 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

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Instruction Manual

800ab, Type 29400
Adjustable Case Sealer

This instruction manual is divided into two sections as follows:

- Section I** Includes all information related to installation, operation and parts for the case sealer.
Section II Includes specific information regarding the AccuGlide™ II STD 2 Inch Taping Head.

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Section I – 800ab Adjustable Case Sealer

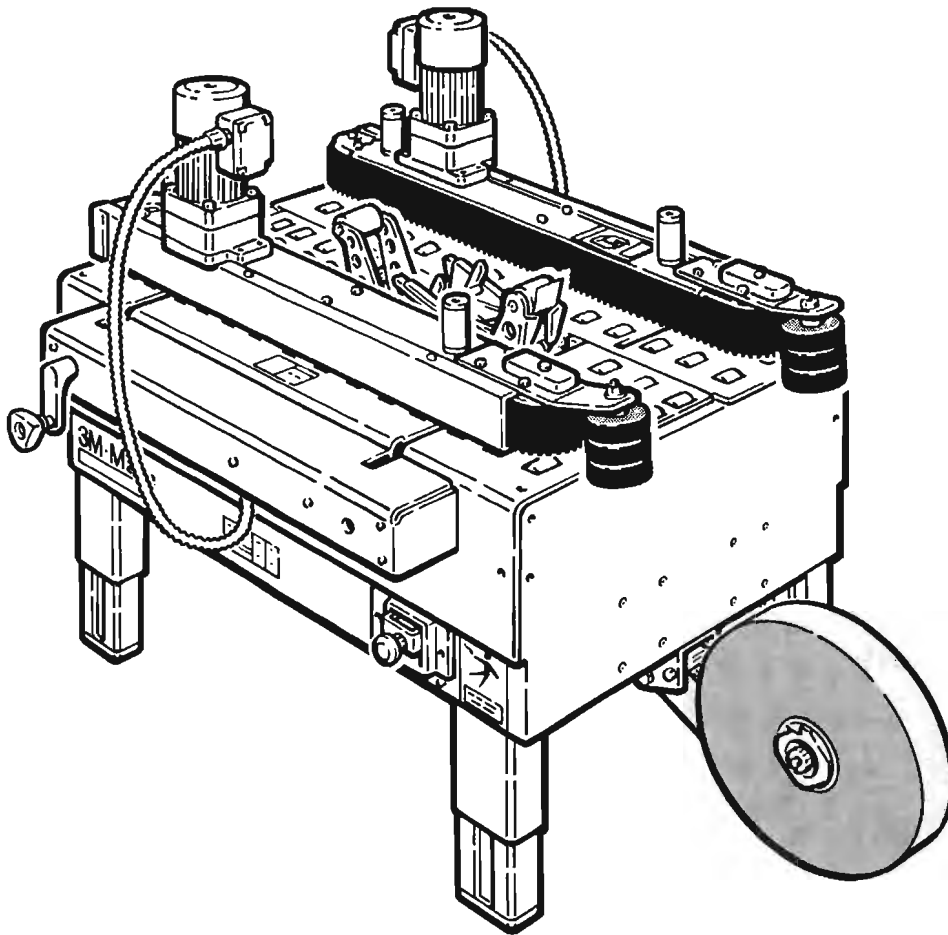
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Section II – AccuGlide™ II STD 2 Inch Taping Head

Description

The **3M-Matic™** 800ab Adjustable Case Sealer with **AccuGlide™ II** Taping Head is designed to apply a “C” clip of **Scotch™** brand pressure-sensitive film box sealing tape to the bottom center seam of regular slotted containers. The case sealer is manually adjustable to a wide range of box sizes (see Box Weight and Size Capacities, page 6).



3M-Matic™ 800ab Adjustable Case Sealer, Type 29400

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™ 800ab Adjustable Case Sealer, Type 29400** 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.

800ab Contents

- (1) 800ab Adjustable Case Sealer, Type 29400
- (1) Tool Kit
- (1) Instruction Manual

Safety Labels

Important – In the event the following safety labels are damaged or destroyed, they must be replaced to ensure operator safety. For safety and information replacement labels, see Parts Illustrations/Lists, Section I, pages 52 and 53.

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



Figure 1-2 – Electrical Warning Label

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

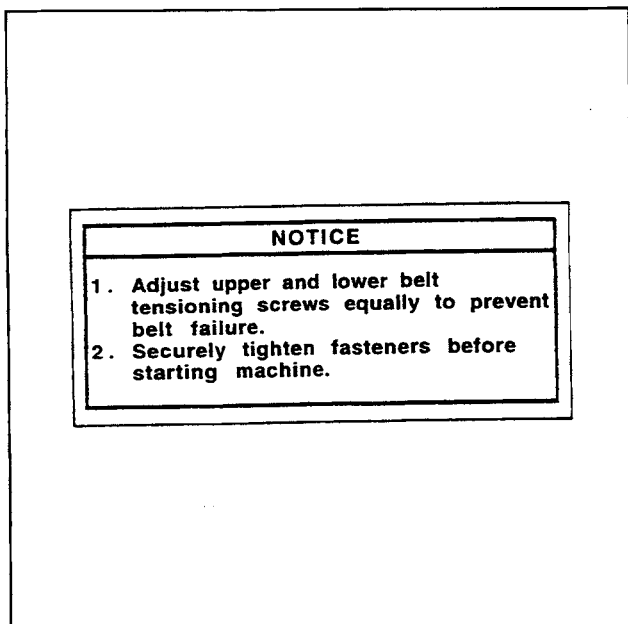


Figure 1-1 – Operating Notice Label

The two "**Warning – Keep Away From Moving Belts**" labels, shown in **Figure 1-3**, 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.

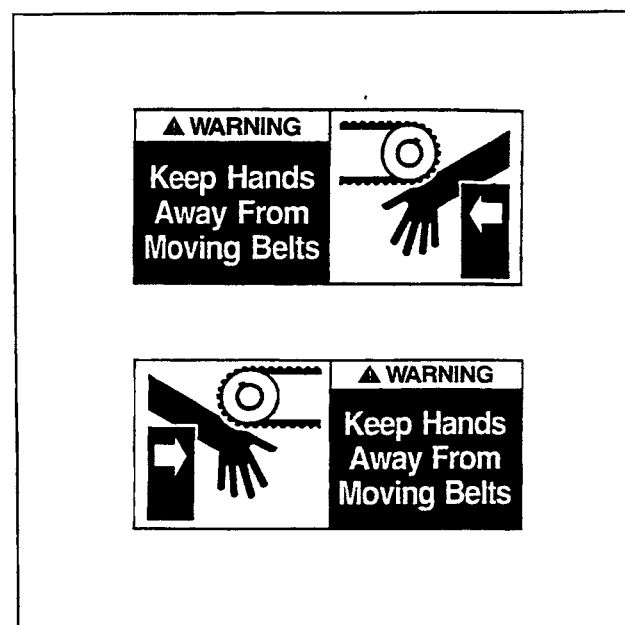


Figure 1-3 – Hands Warning Label

Safety Labels (Continued)

The following two labels are located on the lower taping head. Replacement part numbers for these two labels are listed below each label.

The "**Warning-Sharp Knife**" label warns operators and service personnel of the extremely sharp knife used to cut the tape at the end of the box sealing operation. The label, shown in **Figure 1-4**, is located on the orange blade guard between the applying roller assembly and the buffing roller assembly. **Never operate taping head with blade guard removed.**

Before working with the taping head or loading/threading tape, refer to Figures 3-1 and 3-2, in Section II, to identify the knife blade location. **Keep hands out of these areas except as necessary to service the taping head or to load/thread tape.**

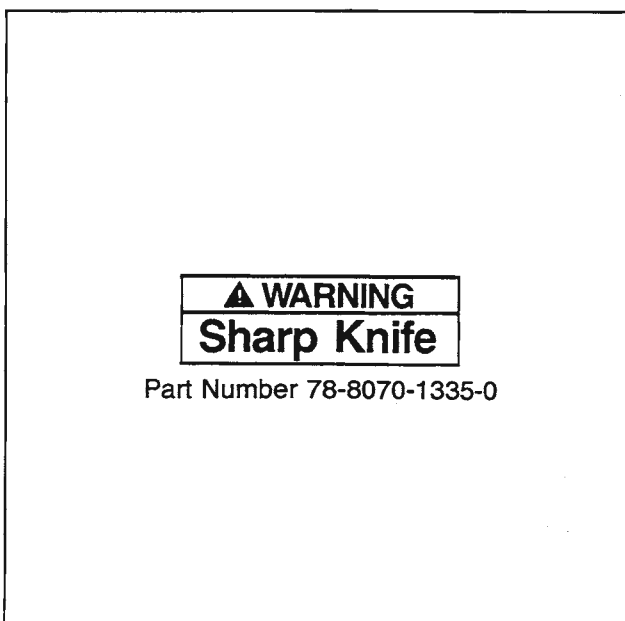


Figure 1-4 – Knife Warning Label

The "**Tape Threading Label**", shown in **Figure 1-5**, is attached to the left side of lower taping head. 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.

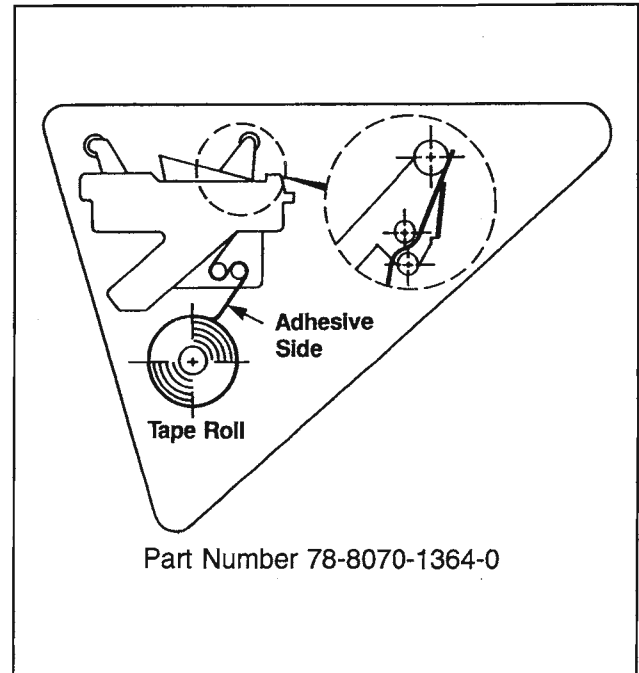
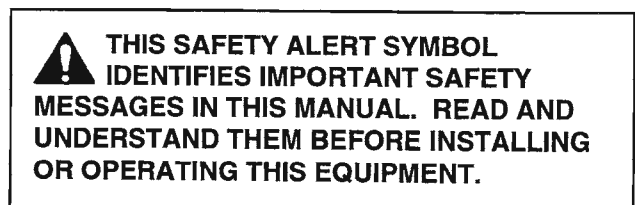


Figure 1-5 – Tape Threading Label



Specifications

1. Power Requirements:

Electrical – 115 VAC, 60 Hz, 3.8 A

These machines are equipped with an 2.4 m [8 foot] 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 0.40 m/s [78 ft/min]

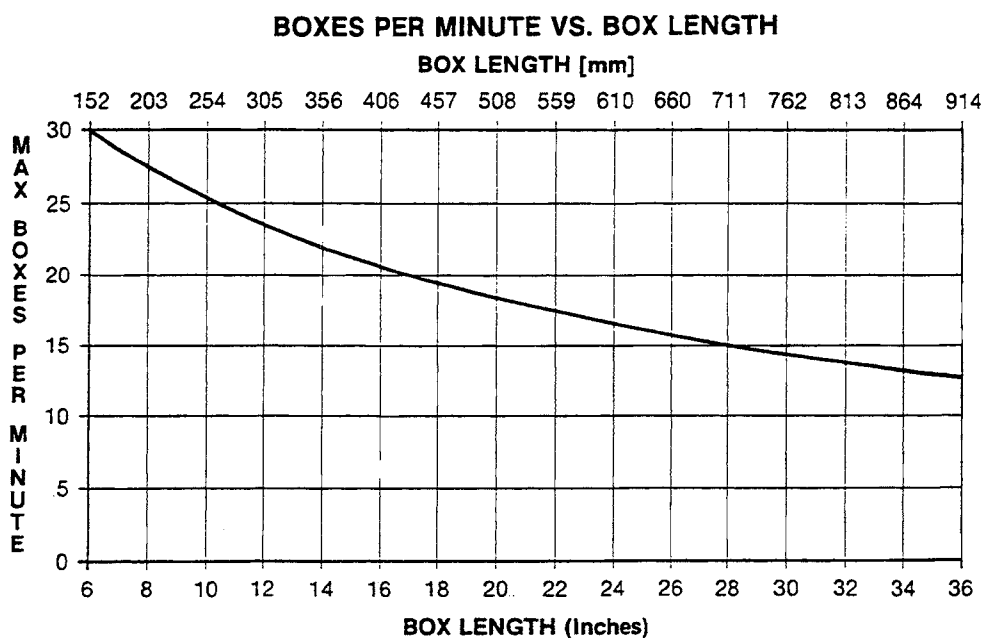
5. Tape Width:

Minimum – 36 mm [1-1/2 inches]

Maximum – 48 mm [2 inches]

6. Tape Roll Diameter:

Up to 405 mm [16 inches] maximum on a 76.2 mm [3 inches] diameter core. (Accommodates all system roll lengths of **Scotch™** brand film tapes.)



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 5° to 40° C [40° to 105° F] with clean, dry boxes.

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

4. Tape:

Scotch™ brand pressure-sensitive film box sealing tapes.

7. Tape Leg Length (Standard):

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

Tape Leg Length (Optional):

48 mm ± 6 mm [2 inches ± 1/4 inch]

(To change tape leg length to 48 mm [2 inches], see "Special Set-Up Procedures", page 23.)

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.

(Specifications continued on next page)

Specifications (Continued)

9. Box Weight and Size Capacities:

Weight

Maximum – up to 38.6 kg [85 pounds]

Minimum – contents must support top flaps and weight must be sufficient to hold bottom flaps fully closed.

Box Size

MINIMUM

- Length – 150 mm [6 inches]
- Width – 115 mm [4-1/2 inches]
- Height – 120 mm [4-3/4 inches]

MAXIMUM

- Length – unlimited
- Width – 545 mm [21-1/2 inches]
- Height – Limited by stability of box through case sealer

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:

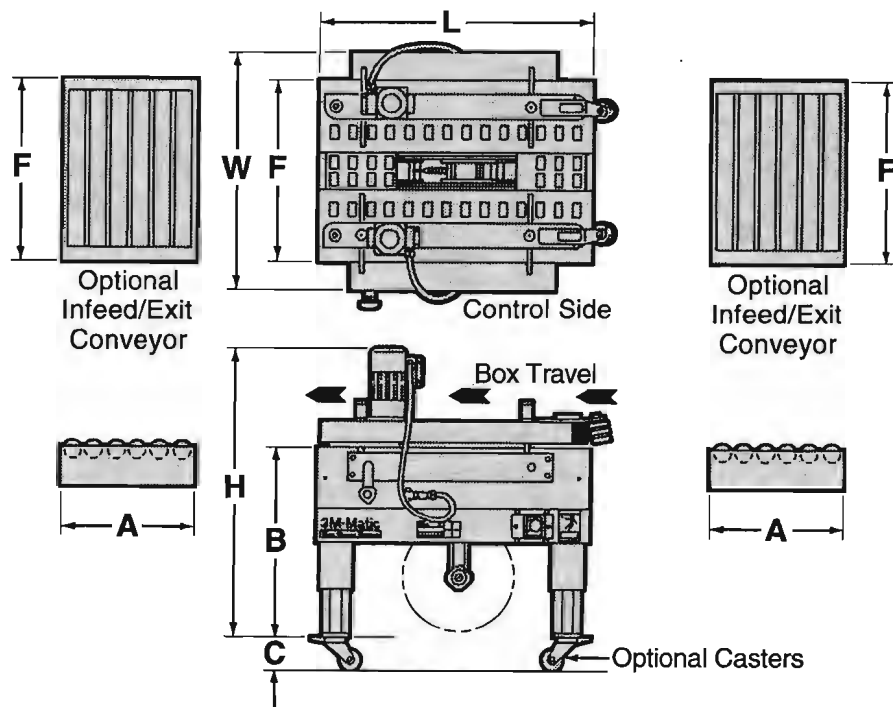
**Box Length In
Direction Of Seal Must Be Greater Than .6
Box Height**

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

(Specifications continued on next page.)

Specifications (Continued)



Machine Dimensions

	W	L	H	A	B	C	F
Minimum							
mm [Inches]	825 [32-1/2]	920 [36-1/4]	940 [37]	460 [18]	610 [24] *	105 [4-3/16]	620 [24-1/2]
Maximum							
mm [Inches]	--	--	1220 [48] *	--	890 [35] *	--	--
			1270 [50]**				

* With drive belt assembly in normal position

** With drive belt assembly in upper position
(See "Special Set-Up Procedure", page 24)

Weight -- approximate 132 kg [290 pounds] crated
approximate 114 kg [250 pounds] 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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Installation and Set-Up

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.

Machine Set-Up

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

Note – A tool kit consisting of metric open end and hex socket wrenches is provided with the machine. These tools should be adequate to set-up the machine, however, other tools supplied by the customer will be required for machine maintenance.

Important – Read "Warnings" on page 13 before attempting to set-up the case sealer for operation.

Installation and Set-Up (Continued)

PACKAGING AND SEPARATE PARTS

1. Lift fiberboard cover off pallet after removing staples at bottom.
2. Install inclined rollers onto infeed end of each drive belt assembly. Remove M6 lock nuts (4) and M6 plain washers (4) from each drive assembly, position inclined roller on each drive assembly and fasten with M6 plain washers and M6 locking nuts. See Figure 2-1.

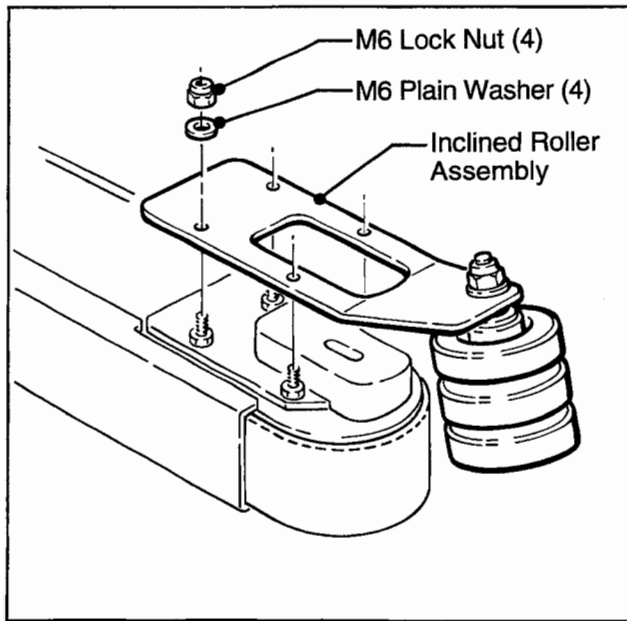


Figure 2-1 – Roller Installation

TAPE DRUM BRACKET (Lower Taping Head)

Ensure that the tape drum bracket assembly is mounted straight down, as shown in Figure 2-2A. The tape drum bracket assembly can be pivoted to provide clearance or for retrofit in certain cases.

Outboard tape roll mounting (Alternate Position) – Remove the tape drum bracket assembly, stud spacer and fasteners from the taping head. Install and secure on the infeed end of the lower frame, as shown in Figure 2-2B.

CONVEYOR BED HEIGHT

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

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

1. Raise and block up the machine frame to allow adequate leg adjustment.
2. Loosen, but do not remove, two M8 x 16 socket head screws in one leg (use M6 hex wrench). Adjust the leg length for the desired machine bed height. Retighten the two screws to secure the leg. Adjust all four legs equally.

TAPE WIDTH

The taping head has been pre-set to accommodate 48 mm [2 inch] wide tape rolls. To adjust heads for narrower tape, refer to Section II, "Adjustments – Tape Web Alignment", page 11.

TAPE LEG LENGTH

Taping heads are pre-set to apply 70 mm [2-3/4 inch] long tape legs. To change tape legs to 48 mm [2 inch], see "Special Set-Up Procedure – Changing Tape Leg Length", page 23.

Installation and Set-Up (Continued)

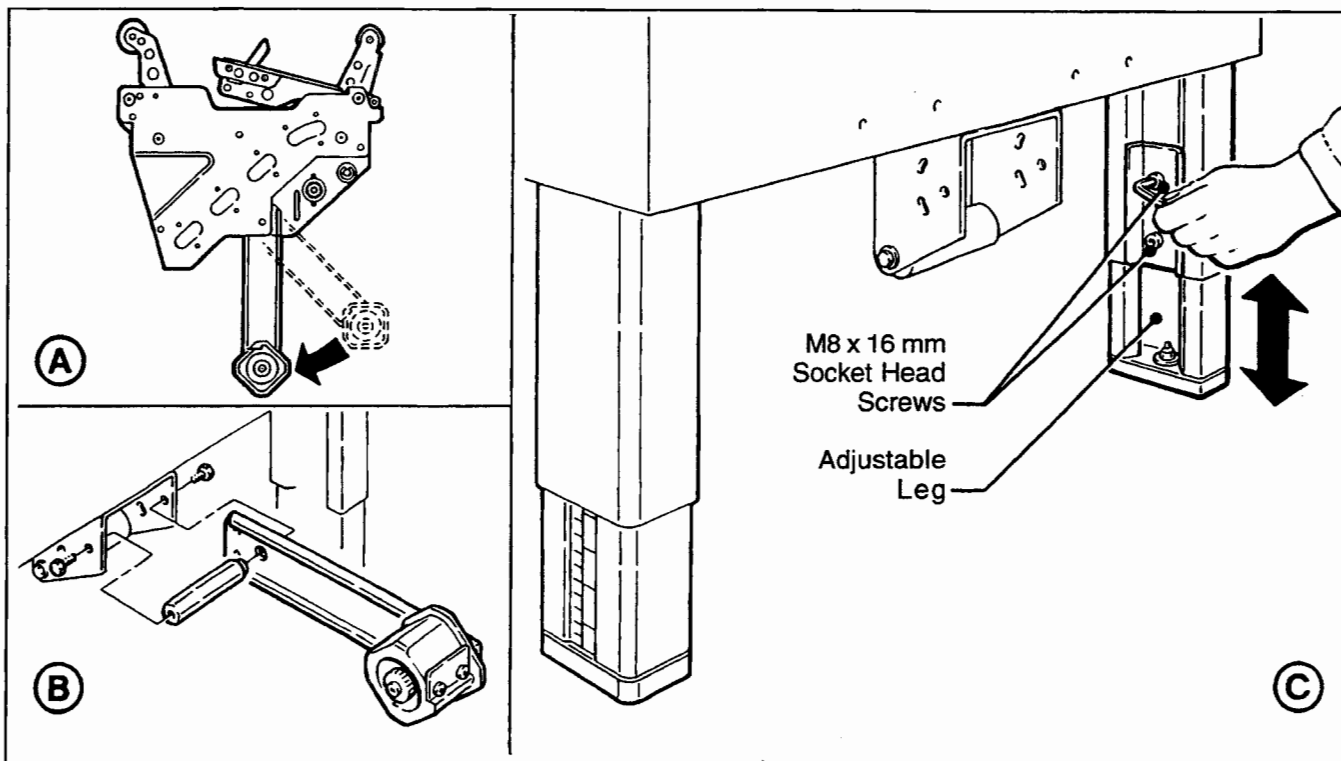


Figure 2-2 – Conveyor Bed Height Adjustment and Lower Tape Drum Bracket Position

DRIVE BELT HEIGHT

The drive belt assemblies can be raised 50 mm [2 inches] to provide better conveying of tall boxes. Refer to page 24, "Special Set-Up Procedures – Drive Belt Assembly Height", for set-up procedure. **Note – Raising drive belts increases the minimum box height that can be taped to 190 mm [7-1/4 inches].**

service shall be properly grounded. Before the power cord is plugged into 115 Volt, 60 Hz outlet, make sure the red "Off" button is depressed and that all packaging materials and tools are removed from the machine. **Do not plug electrical cord into outlet until ready to run machine.**

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

ELECTRICAL CONNECTION AND CONTROLS

The electrical control box, shown in Figure 3-1, contains the "On/Off" switch with pre-set circuit breaker and can be located on either side of the machine frame for customer operating convenience. A standard three conductor power cord with plug is provided at the back of the electrical control box for 115 Volt, 60 Hz, 6.4 Amp electrical service. The receptacle providing this

INITIAL START-UP OF CASE SEALER

After completing the "Installation and Set-Up" procedure, continue through "Operation" for tape loading and start-up to be sure case sealer is properly adjusted to run boxes.

Operation

IMPORTANT – Before operating the case sealer read all the "Warning/Information Labels", pages 3-5 and "Warnings", on page 13 as well as all of the "Operation" instructions.

Refer to Figure 3-1 to acquaint yourself with the various components of the case sealer and also see Section II, page 6, for taping head components.

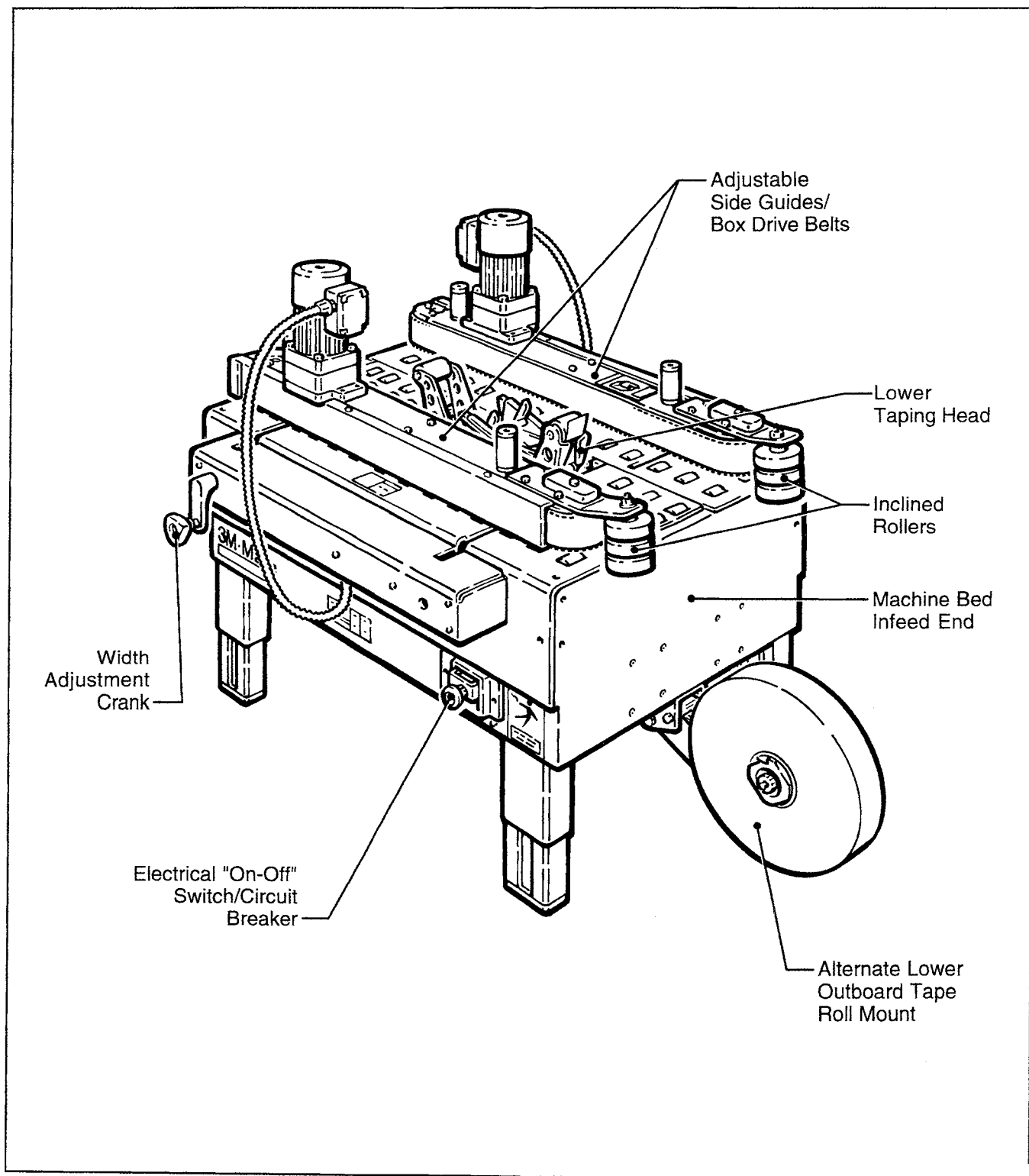


Figure 3-1 – Case Sealer Components, Left Front View

Operation (Continued)



WARNINGS

1. Turn electrical supply off and disconnect before servicing taping head or performing any adjustments or maintenance on the machine.
2. Turn electrical supply off when machine is not in use.
3. Before turning drive belts on, be sure no tools or other objects are on the machine bed.
4. Keep hands and loose clothing away from moving belts.
5. Never attempt to work on any part of the machine, load tape or remove jammed boxes from the machine while machine is running.
6. When feeding boxes to the machine by hand, push box in from end only – DO NOT PUSH WITH HANDS ON ANY CORNER OF THE BOX.
7. Taping head utilizes an extremely sharp knife blade. The blade is located under the orange blade guard that has the 'WARNING – SHARP KNIFE' label. Before loading tape, refer to Section II, page 6, Figure 3-2 to identify the blade location. Keep hands out of this area except as necessary to service the taping head.
8. Turn drive belts "Off" when machine is not in use.
9. Failure to comply with these warnings could result in severe personal injury and/or equipment damage.

Electrical "On/Off" Switch

The box drive belts are turned on and off ("Off" button is red) with the electrical switch on the side of the machine frame.

Note – The case sealer has a circuit breaker incorporated into the "On/Off" switch. If circuit becomes overloaded and circuit breaker trips, determine cause of overload (wait two minutes), then push "On" button to re-set breaker/start machine.

Tape Loading/Threading

See Section II, pages 7 and 8

Note – If lower tape drum is mounted in lower outboard position, remove taping head from machine bed by pulling straight up, insert threading needle in taping head and replace taping head. Install tape roll on drum (adhesive on tape leg up), thread tape leg under knurled roller on outboard mount, then attach tape leg to threading needle and pull tape through taping head with threading needle.

Operation (Continued)

Box Size Set-Up

1. ADJUST DRIVE BELTS (Figure 3-2)

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

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

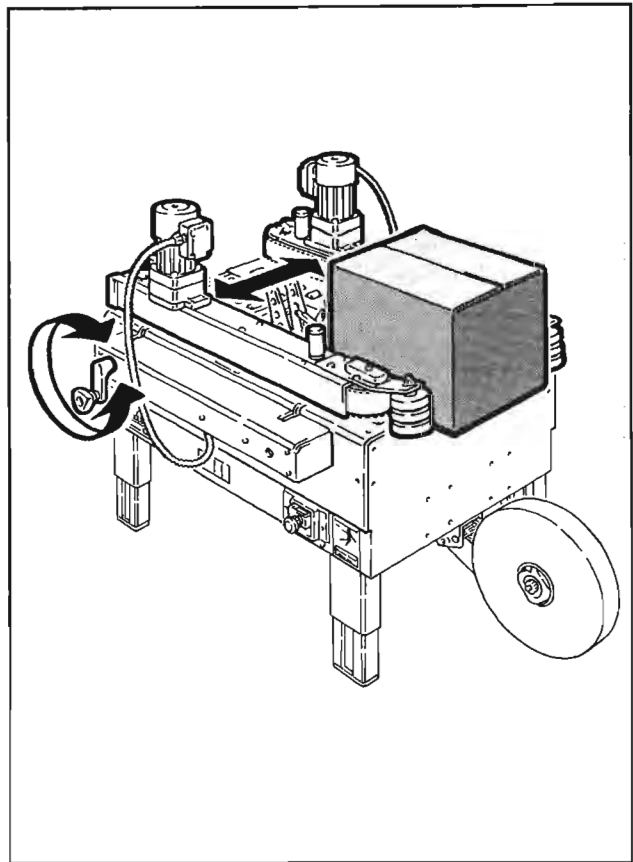


Figure 3-2 – Side Drive Belts

2. RUN BOXES TO CHECK ADJUSTMENT (Figure 3-3)

WARNING – Be sure all packaging materials and tools are removed from the machine before operating.

Push electrical switch "On" to start drive belts.

Move box forward until it is taken away by drive belts.

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

CAUTION – If drive belts are allowed to slip on box, excessive belt wear will occur.

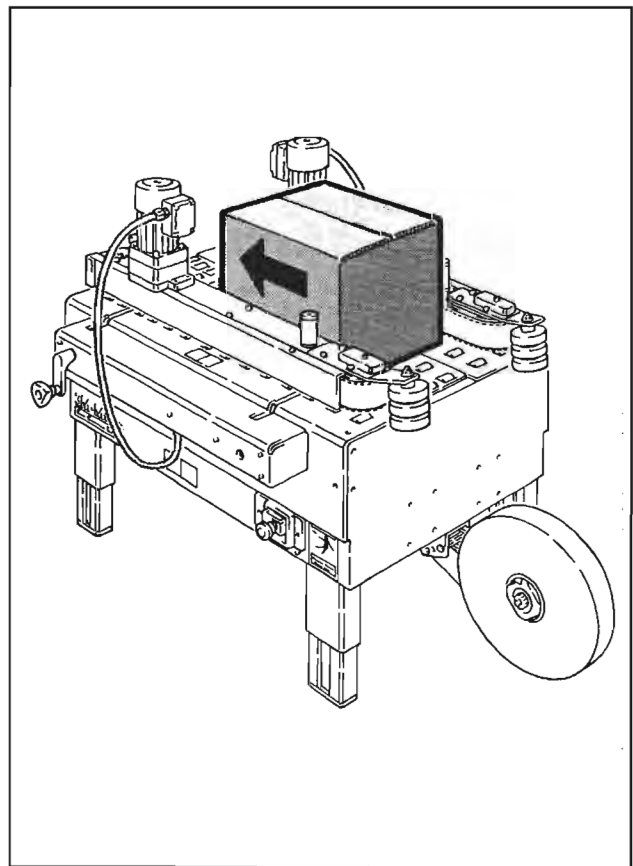


Figure 3-3 – Check Adjustment

Operation (Continued)

Box Sealing

1. Feed boxes to machine at minimum 455 mm [18 inch] intervals.
2. Turn electrical supply "Off" when machine is not in use.
3. Reload and thread tape as necessary.
4. Be sure machine is cleaned and lubricated according to recommendations in "Maintenance" section of this manual.

Notes

1. Machine or taping head adjustments are described in "Adjustments", Section I for machine or Section II for taping heads.
2. Box drive motors are designed to run at a moderate temperature of 40°C [104°F]. In some cases, they may feel hot to the touch.

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Maintenance

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



WARNING – Turn off electrical power supply and disconnect power cord from electrical supply before beginning maintenance. If electrical power is not disconnected, severe injury to personnel could result.

Cleaning

Note – Never attempt to remove dirt from taping head 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.

Lubrication

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 does not require additional lubrication.

Figure 4-1 illustrates the 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.

Note – Wipe off excess oil and grease. It will attract dust 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.

Taping Head Lubrication – See Section II, "Maintenance – Lubrication", page 10.

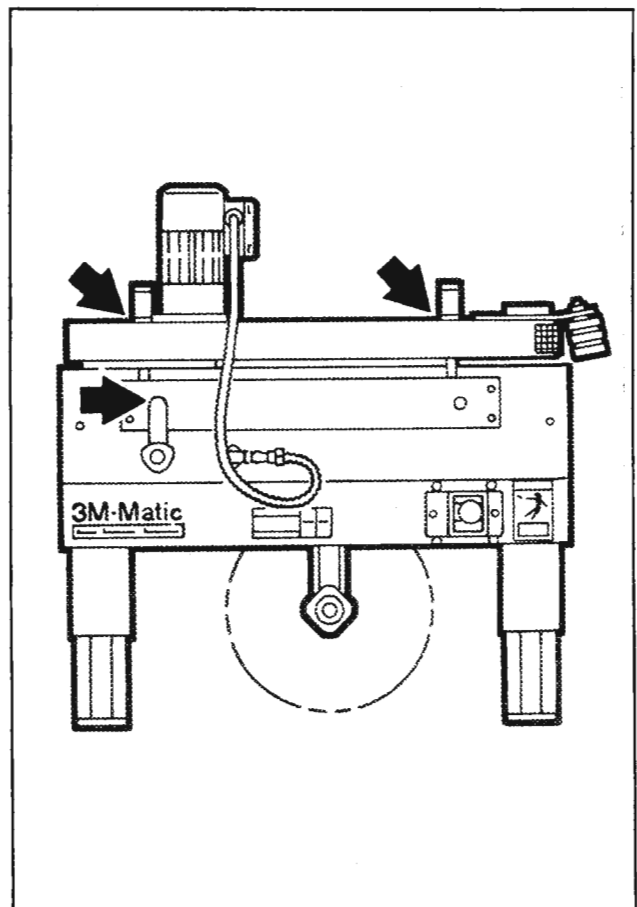


Figure 4-1 – Frame Lubrication Points

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.

Circuit Breaker

The case sealer is equipped with a circuit breaker which trips the "On/Off" switch to tripped position. If circuit is overloaded and circuit breaker trips, determine cause and correct (wait two minutes), then turn "On". Located inside the electrical control box on the side of the machine frame, the circuit breaker has been pre-set at 2.3 Amps and requires no further maintenance.

Blade Replacement, Taping Head

See Section II, "Maintenance - Blade Replacement", page 9.

Drive Belts

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

REPLACEMENT – SEE STEPS 1 THRU 7

TENSION ADJUSTMENT – SEE STEPS 2, 6 AND 7

1. Remove and retain the three screws (A), three washers (B) and side cover (C). See Figure 4-2.
2. Remove and retain the screw (D), washer (E) and belt tensioner cover (F).
3. Turn belt adjustment screws (G) counterclockwise on both the upper and lower tension assemblies until belt is loose. See Figure 4-3.
4. Locate the belt lacing (joint) by turning the belt manually. Remove the pin with pliers. Remove and discard old belt.

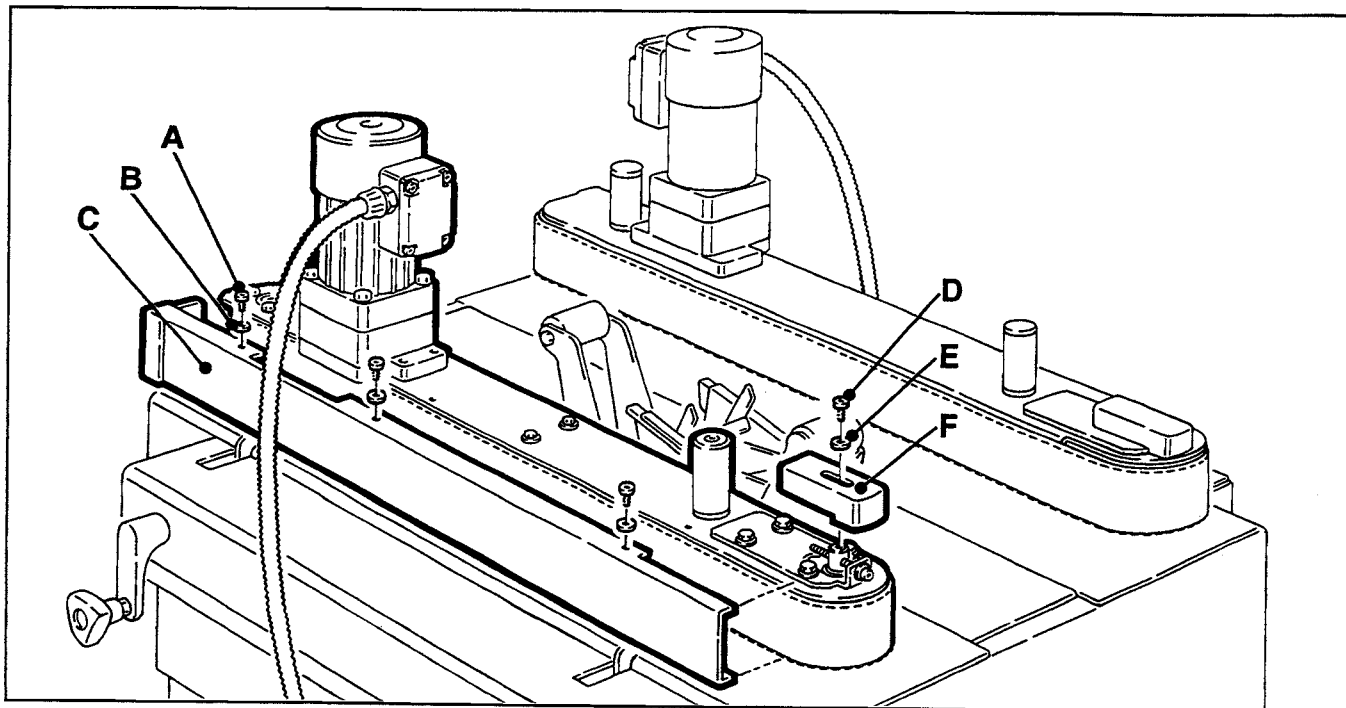


Figure 4-2 – Box Drive Belt (Left Side View – Infeed End)

Maintenance (Continued)

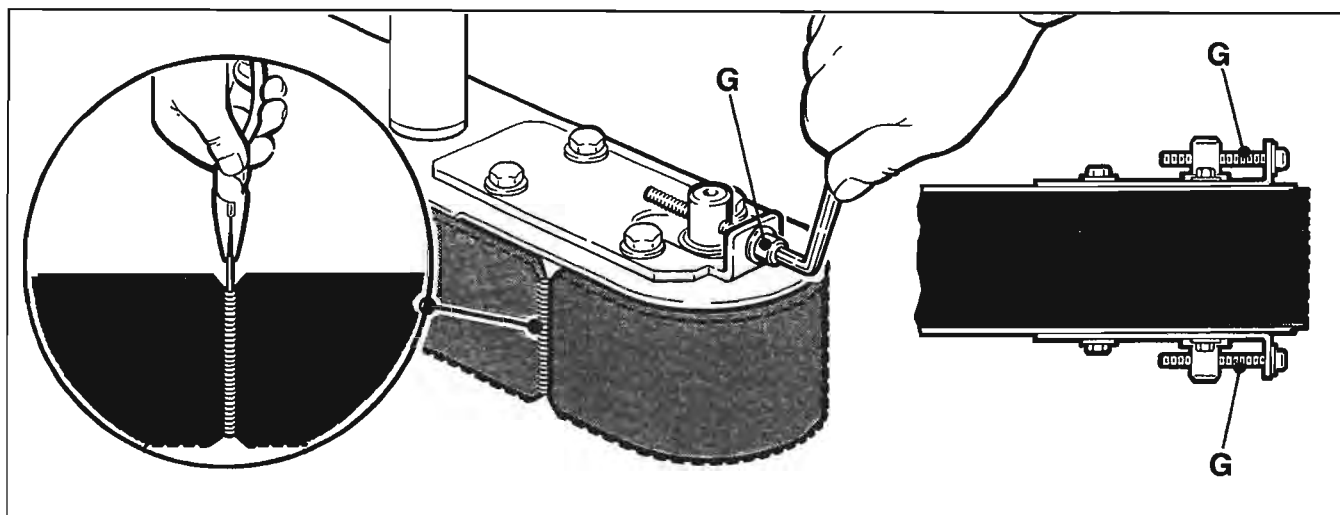


Figure 4-3 – Box Drive Assembly, Infeed End

5. Install the new belt around drive rollers and insert new pin. Pin must not extend beyond edge of belt.

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

6. To set drive belt tension, turn adjustment screws (G) equally on both the upper and lower tension assemblies. Turn the screws clockwise to increase tension or counterclockwise to decrease tension. See Figure 4-3.

Use a force gauge to pull the belt outward 25 mm [1 inch] at midspan, as shown with a moderate pulling force of 3.5 kg [7 lbs].

7. Reverse procedures to reassemble the drive belt assembly.

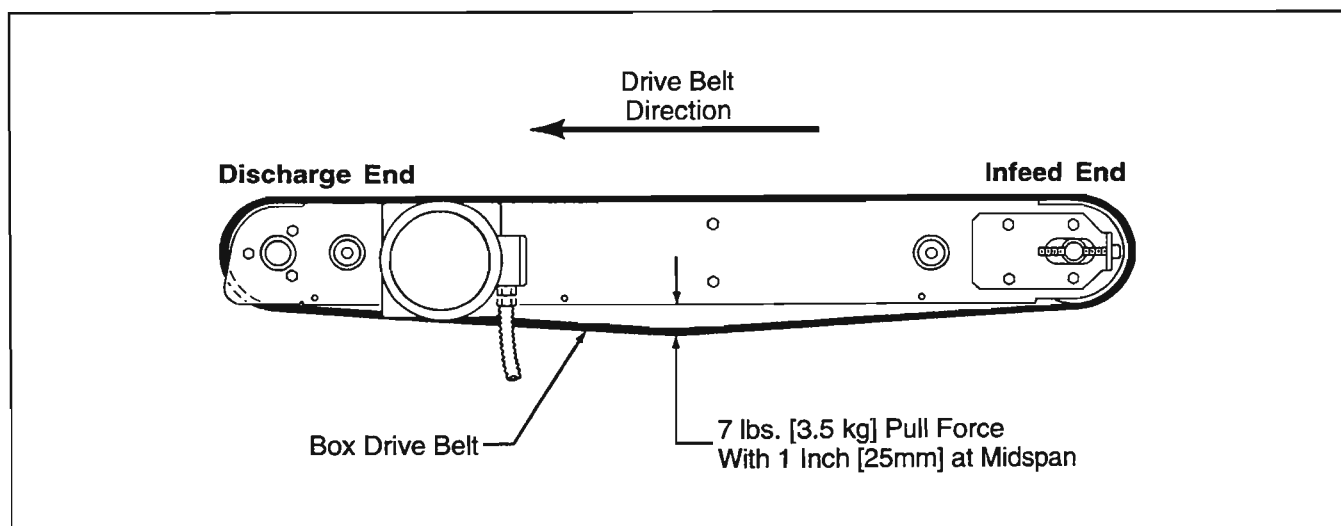


Figure 4-4 – Box Drive Belt Tension Adjustment, Top View

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Adjustments



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.

Drive Belt Tension

Tension adjustment of the drive 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 adjusted in or out to provide proper belt tension. Each belt is adjusted separately.

Belt tension is obtained by tightening the adjustment screw so that a moderate pulling force of 3.5 kg [7 lbs] applied at the midspan, as shown in Figure 4-4, will deflect the belt 25 mm [1 inch]. This will assure positive contact between the belt and the drive pulley on the discharge end of the taping head.

To adjust belts, see "Maintenance – Drive Belts", page 18.

Taping Head Adjustments



WARNING – Use care when working near tape cut-off blade on taping head as blade is extremely sharp. If care is not taken, severe injury to personnel could result.

TAPE WEB ALIGNMENT – Section II, page 11

TAPE DRUM FRICTION BRAKE – Section II, page 11

APPLYING MECHANISM SPRING – Section II, page 11

ONE-WAY TENSION ROLLER – Section II, page 12

TAPE LEG LENGTH

Leading Tape Leg Length Adjustment – Section II, page 13

Changing Tape Leg Length from 70 to 48 mm [2-3/4 to 2 Inches] – Section II, page 13.

Note – Changing tape leg to 48 mm [2 inches] requires machine adjustment also. See Section I, "Special Set-Up Procedure – Changing Tape Leg Length", page 23.

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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.

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.

Changing Tape Leg Length

(From 70 to 48 mm [2-3/4 to 2 Inches])

The following changes to the case sealer will allow taping boxes 90 mm [3-1/2 inches] minimum height.

1. Lift the lower taping head straight up to remove it from the case sealer bed.
2. Refer to Section II, Adjustments – Changing Tape Leg Length", page 13 for taping head set-up.

CASE SEALER FRAME

1. No changes to case sealer frame are required.

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.

Drive Belt Assembly Height

The drive belt assemblies can be raised 48 mm [2 inches] to provide better conveying of tall boxes. **This change increases the minimum box height that can be taped to 190 mm [7-1/4 inches].**

DISASSEMBLE – Figure 5-1

1. Remove and retain the screw (A), cap washer (B) and spacer (C) from the front and rear arm assembly pivots.
2. 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.

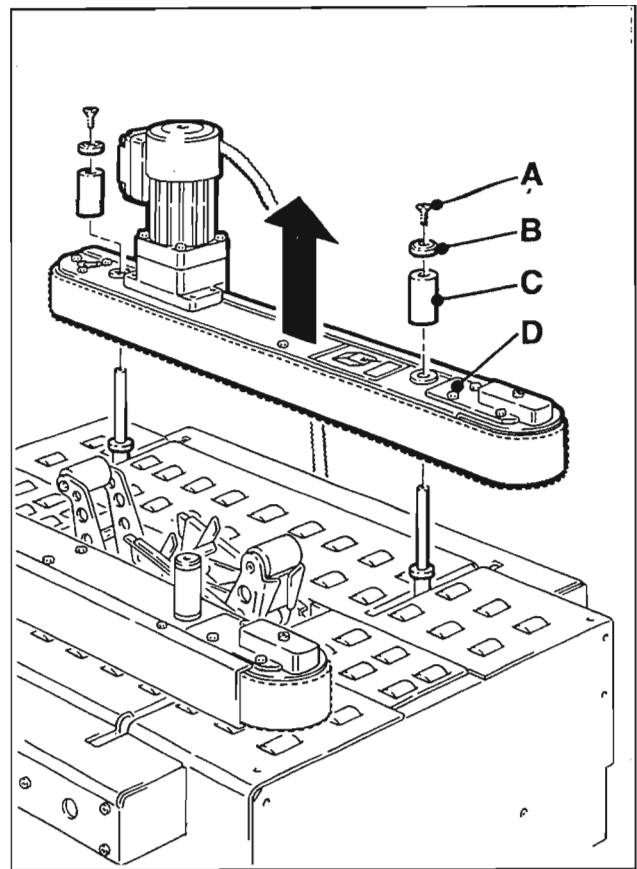


Figure 5-1 – Drive Belt Assembly, Disassembly

REASSEMBLE – Figure 5-2

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 must be installed at the same operating height.

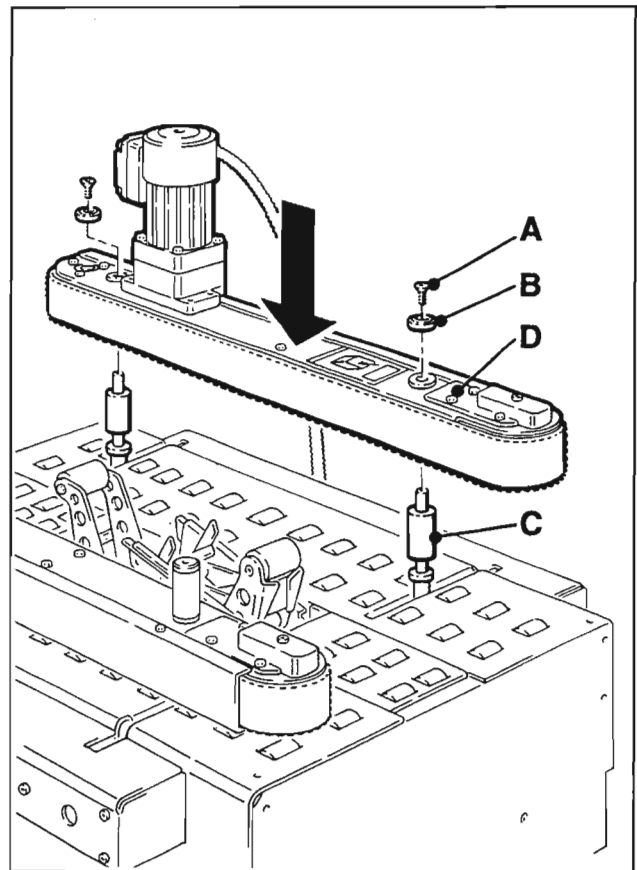


Figure 5-2 – Drive Belt Assembly, Reassembly

Troubleshooting

The Troubleshooting Guide lists some possible machine problems, causes and corrections. Also see Section II, "Troubleshooting", pages 15 and 16 for taping head problems.

Troubleshooting Guide

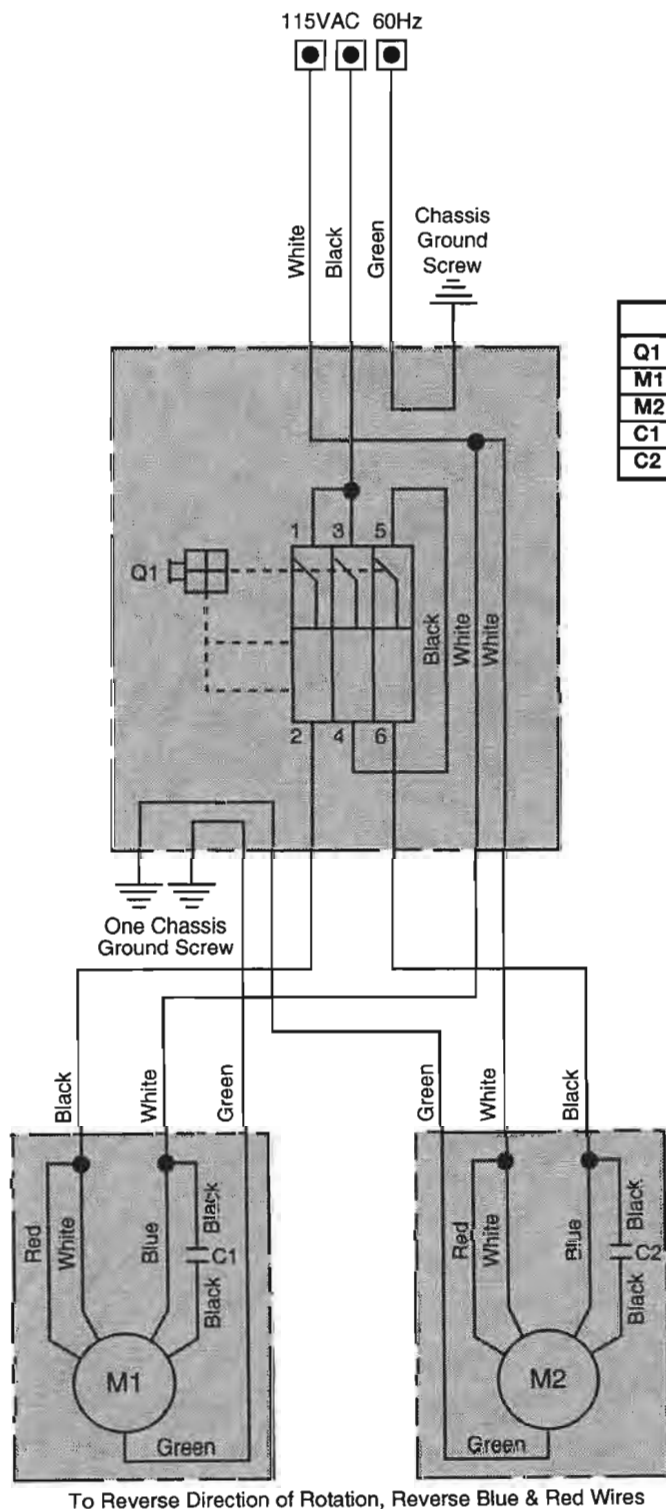
Problem	Cause	Correction
Drive belts do not convey boxes	Narrow boxes	Check machine specifications. Boxes are narrower than recommended, causing slippage and premature belt wear.
	Worn drive belts	Replace drive belts
	Taping head applying spring holder missing	Replace spring holder
	Taping head applying 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
Drive belt break	Worn belt	Replace belt
	Excessive belt tension	Tension to 3.5 kg [7 lbs] per adjustment section
Tape not centered on box seam	Tape drum not centered	Reposition tape drum
	Box flaps not of equal length	Check box specifications

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Electrical Diagram



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.



	Component	Ref. No.
Q1	On/Off Switch Circuit Breaker	4760-3
M1	L/S Motor	4763-13
M2	R/S Motor	4763-13
C1	Motor Run Capacitor 15 μ F 300VAC	4763-14
C2	Motor Run Capacitor 15 μ F 300VAC	4763-14

Rated Voltage – 600V
 Rated Thermal Current – 25A
 Set Point – 2.2A

Notes:

1. Component & Reference Number Shown.
2. Refer to Parts List for Part Number.
3. Solid Lines Indicate Electrical Connections.
4. Dotted Lines Indicate Mechanical Connections.

Figure 7 – Electrical Diagram

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Spare Parts/Tools

Spare Parts

The following parts periodically require replacement due to normal wear. They should be ordered immediately and kept on hand to keep the case sealer in production.

800ab Adjustable Case Sealer, Type 29400

Qty	Section/Ref. No.	Part Number	Description
1	II/2880-15	78-8057-6179-4	Roller – Applying
1	II/2886-5	78-8057-6178-6	Roller – Buffing
1	II/2883-2	78-8017-9173-8	* Blade – 2.56 Inch [65 mm]
2	II/2883-12	78-8052-6602-6	* Spring – Cutter
1	II/2886-10	78-8070-1273-3	* Spring – Lower Extension (Black)
2	I/4763-57	78-8076-5452-6	Belt – Drive, W/Hook
2	II/2883-6	78-8070-1390-5	Spring – Torsion

* Note – These spare parts are supplied with the tool kit that comes with your machine and should also be ordered separately as used, to keep the case sealer in production.

Tool Kit

A tool kit, packaged separately and included with your machine, contains the necessary wrenches for use with the metric fasteners on the case sealer. The threading tool, part number 78-8076-4726-4, contained in the tool kit is available as a stock replacement item and can be ordered separately.

Label Kit

A label kit, part number 78-8098-8799-1 is available as a stock item and contains all the safety and information labels used on the case sealer or separate labels can be ordered from the parts list, page 53.

Options/Accessories

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

Part Number	Option/Accessory
78-8052-6553-1	Box Hold Down Attachment, Model 18500
78-8069-3983-7	Caster Kit Attachment
78-8069-3924-1	Conveyor Extension Attachment
78-8069-3926-6	Low Tape Sensor Kit
78-8079-5560-0	Tape Application Sensor Kit
78-8095-4855-1	2 Inch Tape Edge Fold Kit (Lower)

Replacement Parts Illustrations and Parts List

800ab Adjustable Case Sealer, Type 29400 With AccuGlide™ II STD (2 Inch) Taping Head

1. Refer to first illustration, **800ab Assembly**, for the **Figure Number** that identifies a specific portion of the machine.
2. Refer to the Figure or Figures to determine the individual parts required and the part reference number.
3. The parts list that follows each illustration, includes the part number and part description for the parts in that illustration.

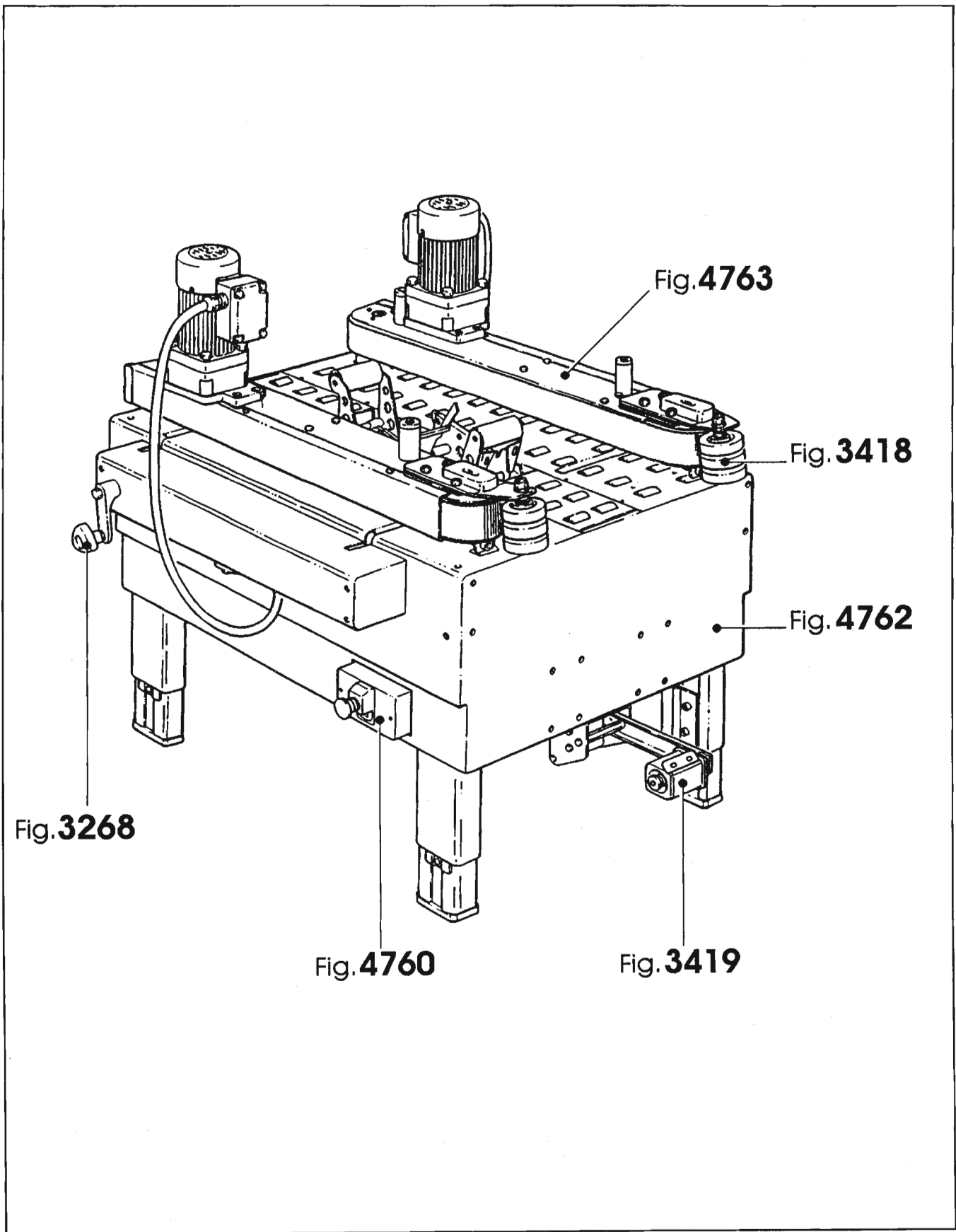
Note – The complete description has been included for standard fasteners and some commercially available components. This has been done to allow obtaining these standard parts locally should the customer elect to do so.

4. Refer to the first page of this instruction manual for replacement parts ordering information.

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

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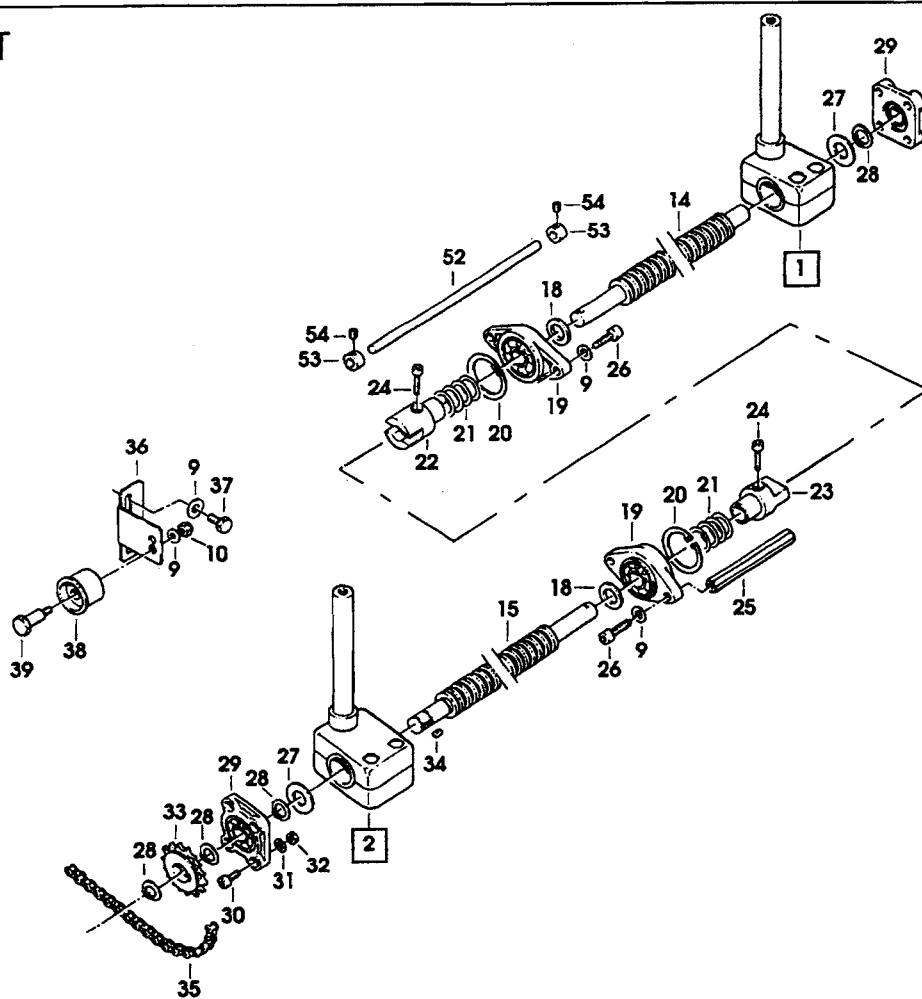
800ab Adjustable Case Sealer W/AccuGlide™ II STD (2 Inch) Taping Head



800ab Assembly

800ab Adjustable Case Sealer

FRONT



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

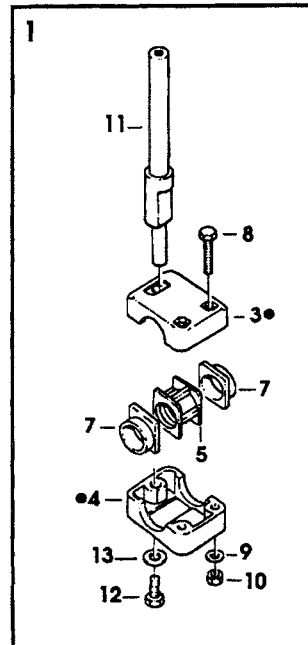
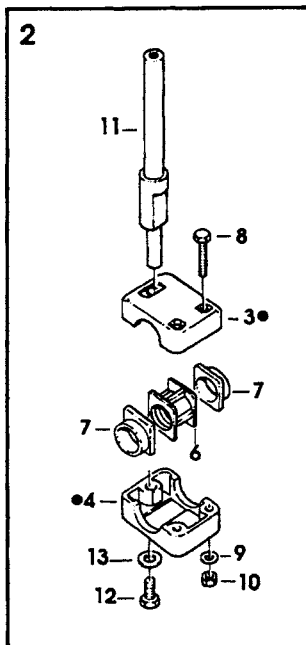


Figure 3268/1 of 2

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
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, Female
3268-23	78-8076-5415-3	Coupling – Screw, Male
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

800ab Adjustable Case Sealer

REAR

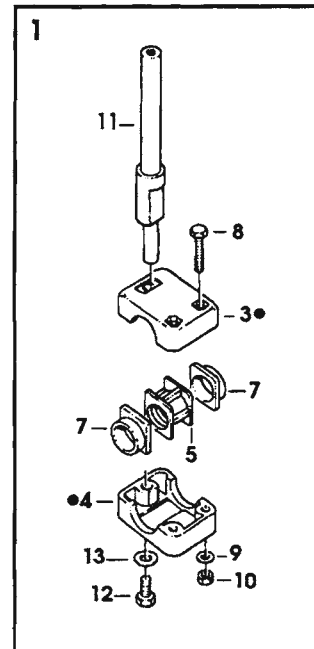
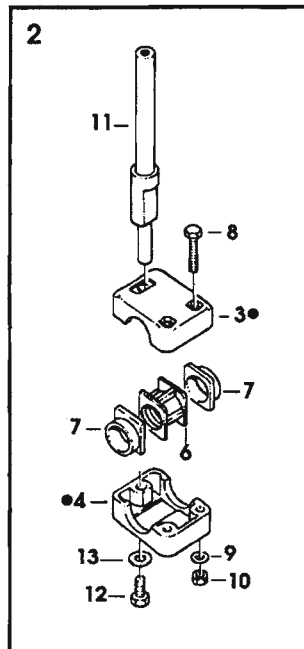
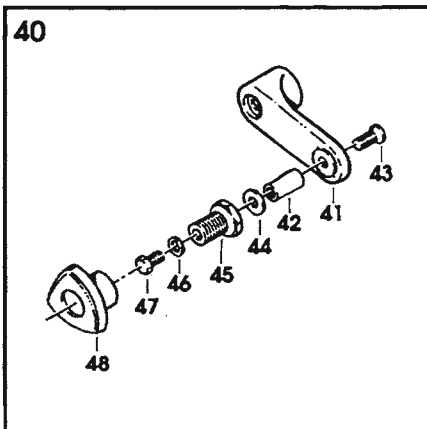
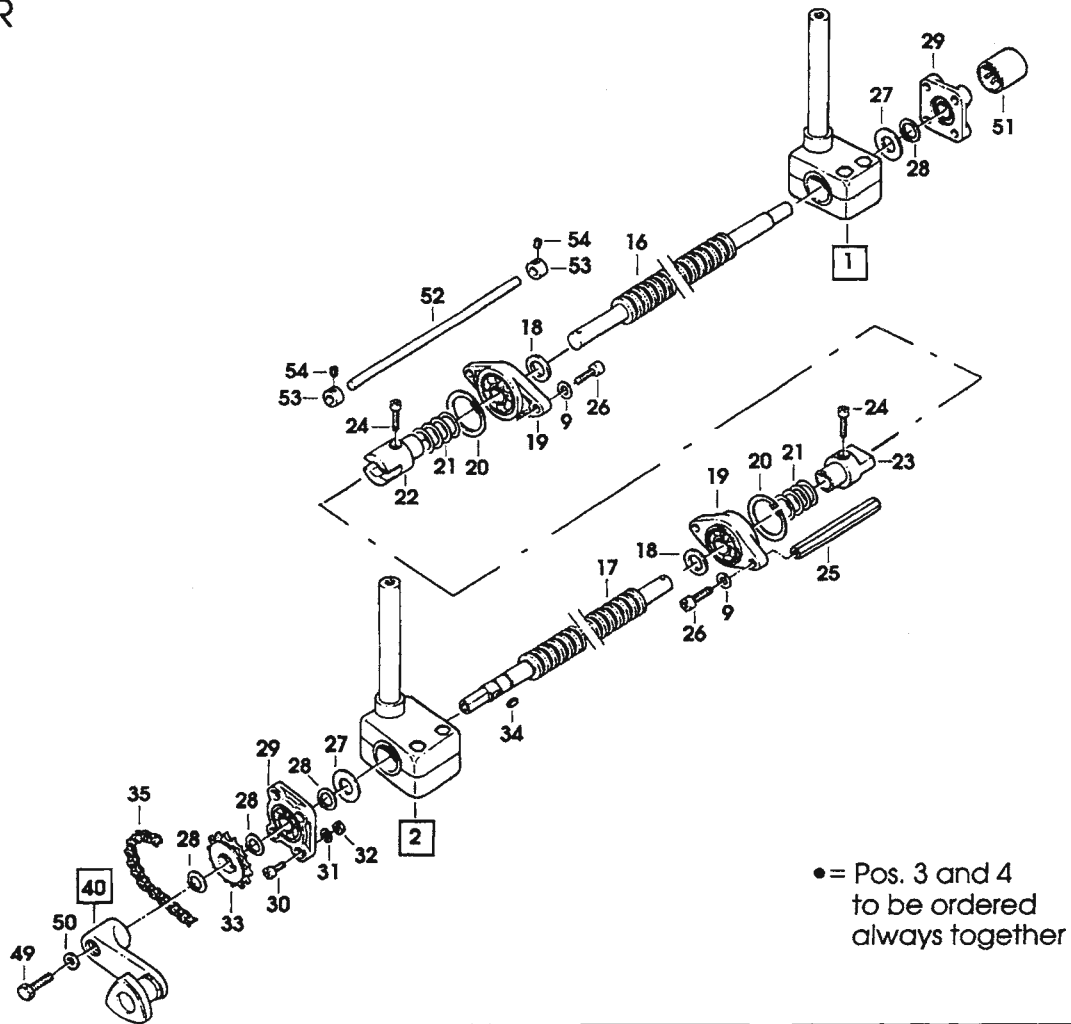


Figure 3268/2 of 2

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
3268-32	78-8010-7417-6	Nut – Hex M5
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 Links
3268-36	78-8076-5421-1	Support – Tension Roller
3268-37	78-8010-7169-3	Screw – Hex Hd, M6 x 12
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
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
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
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

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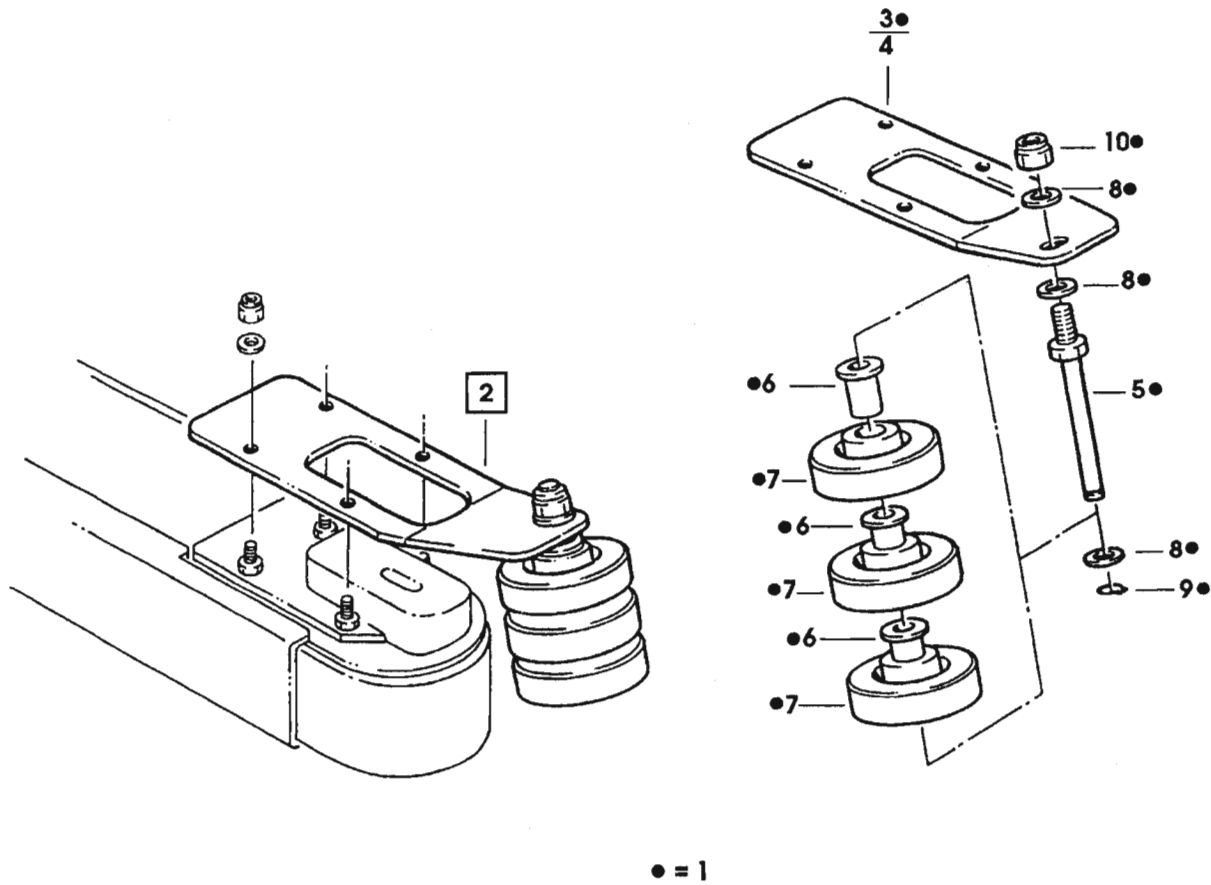


Figure 3418

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

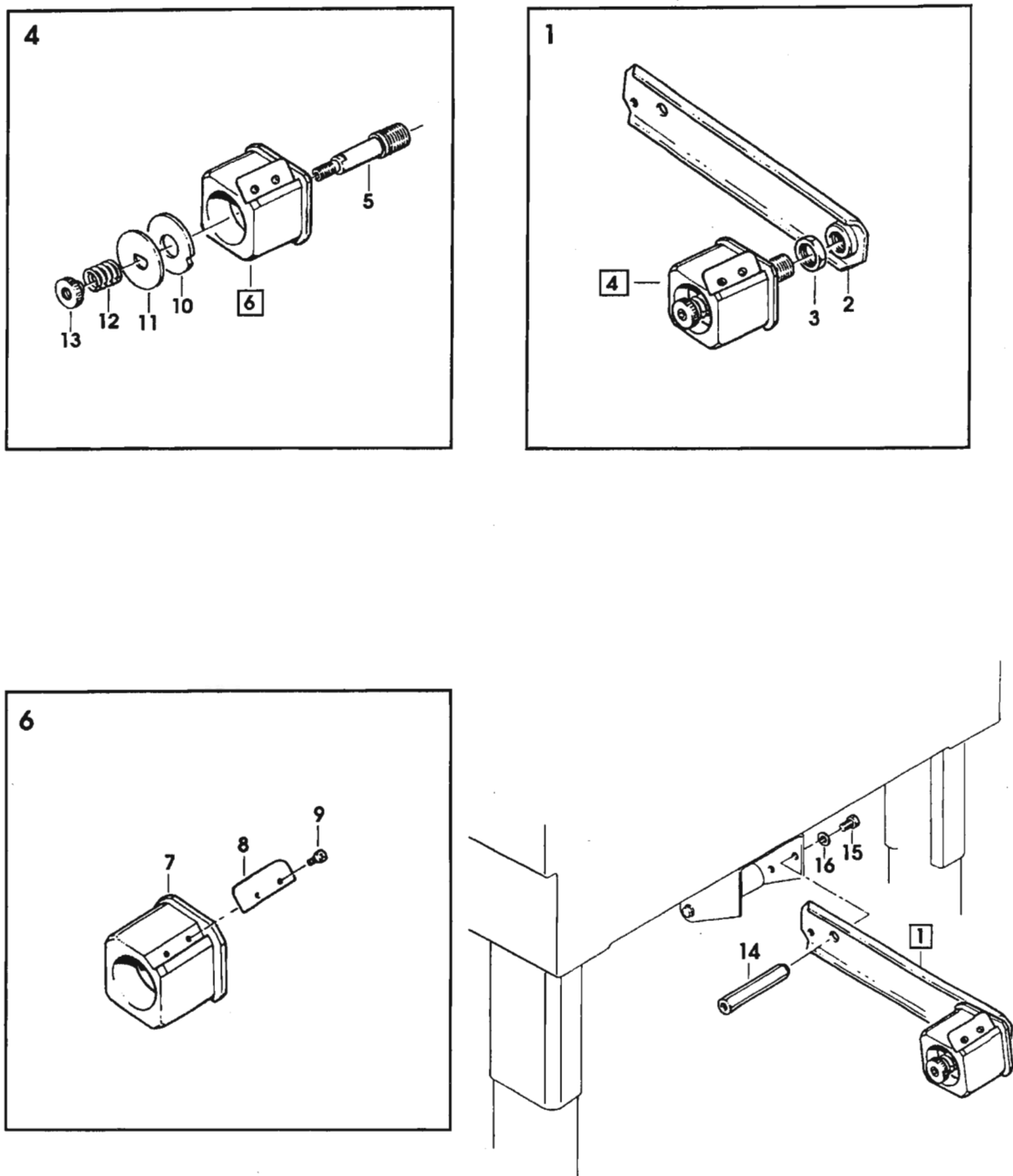


Figure 3419

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
3419-16	26-1000-0010-3	Washer – Flat M6

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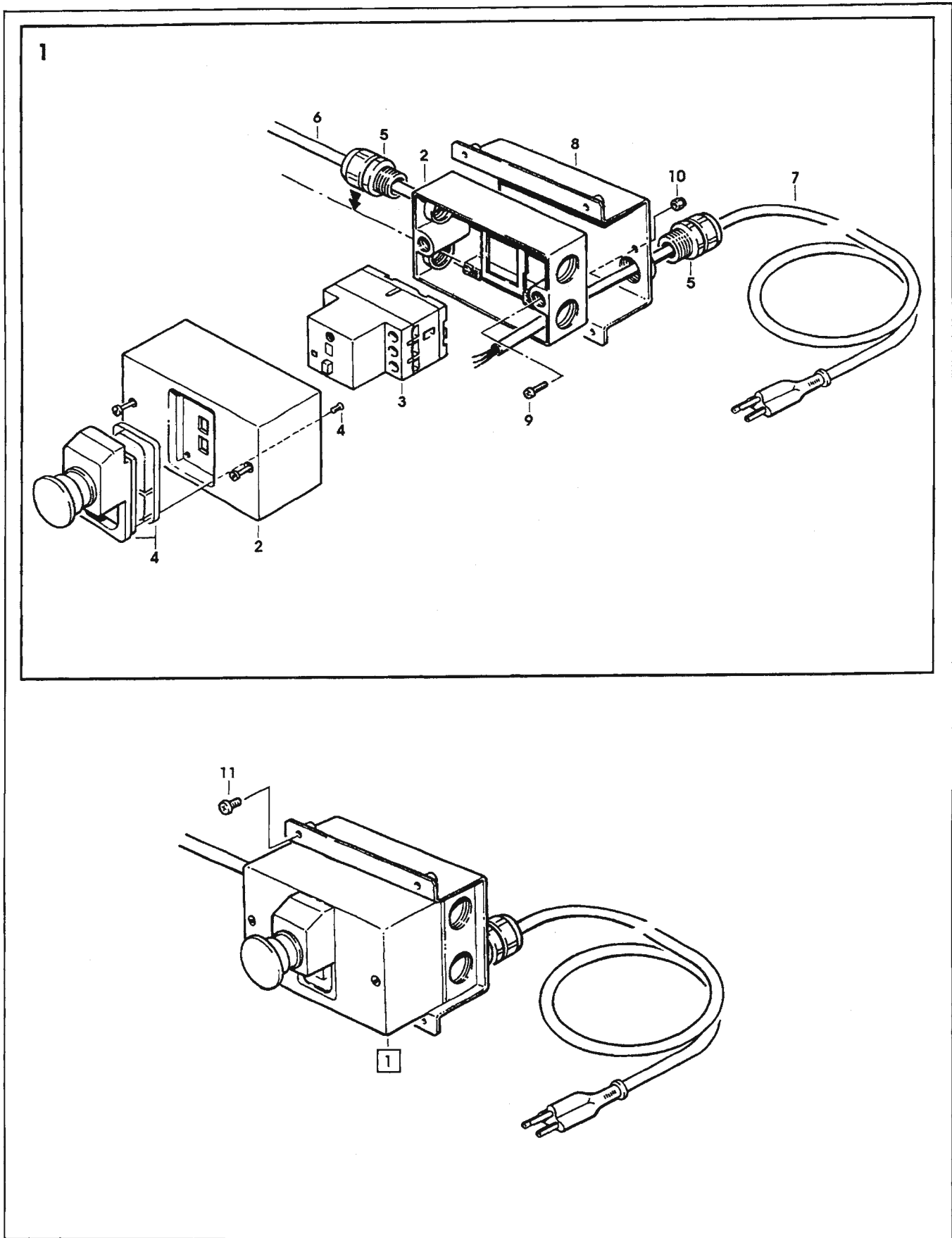


Figure 4760

Figure 4760

Ref. No.	3M Part No.	Description
4760-1	78-8094-6112-8	On/Off Switch Assembly – 1.6-2.5 A
4760-2	78-8076-4879-1	Box – On/Off Switch
4760-3	78-8076-5267-8	Switch – On/Off, 1.6-2.5 A
4760-4	78-8076-5455-9	E-Stop Button
4760-5	78-8057-5807-1	Cord Grip
4760-6	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
4760-7	26-1009-8724-2	Power Cord W/Plug – Type SO
4760-8	78-8076-5456-7	Support – Switch
4760-9	26-1003-5707-3	Screw – Phillips Dr, M4 x 16
4760-10	26-1003-6914-4	Nut – M4, Plastic Insert
4760-11	78-8060-8087-1	Screw – M5 x 10

800ab Adjustable Case Sealer

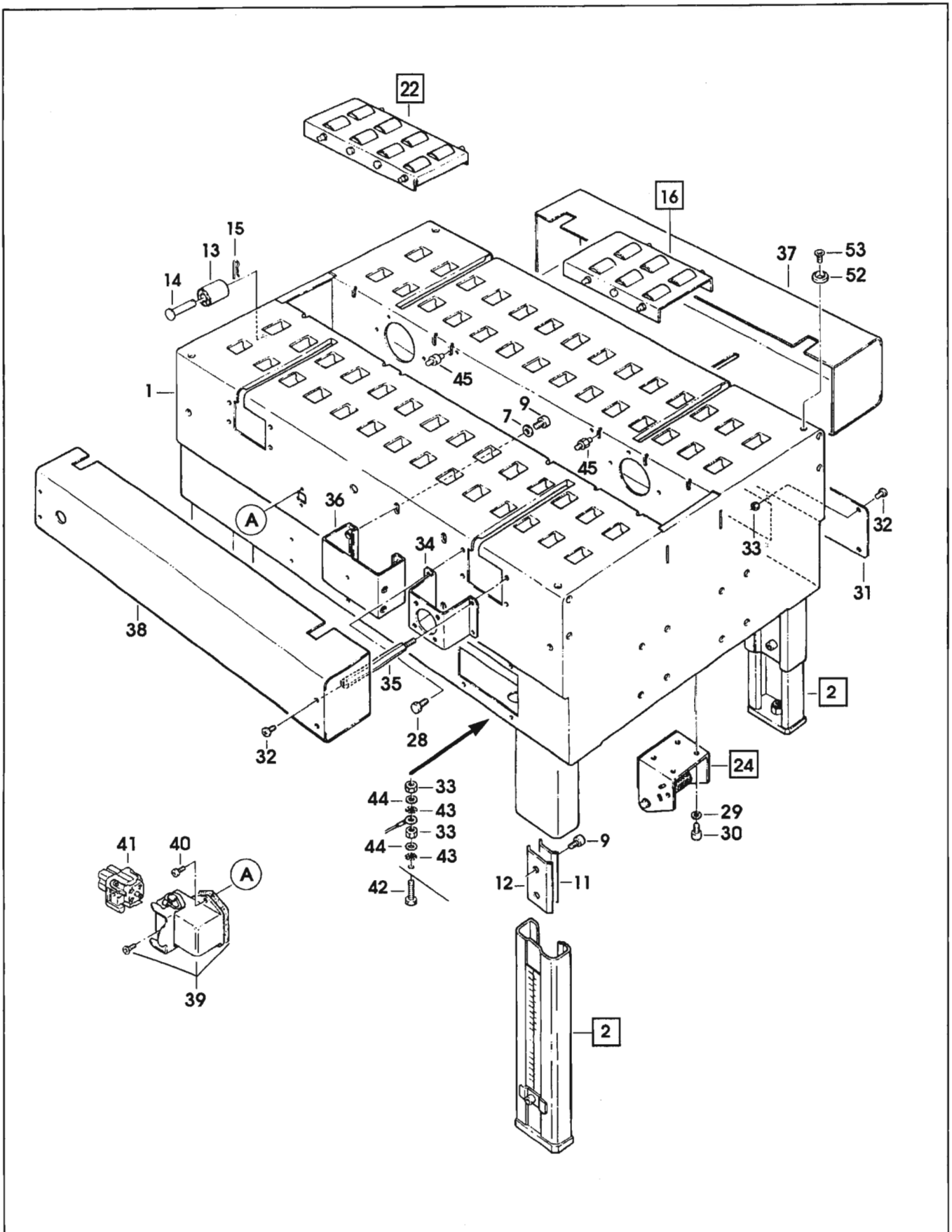


Figure 4762/1 of 2

Figure 4762 (Page 1 of 2)

Ref. No.	3M Part No.	Description
4762-1	78-8076-5380-9	Bed – Conveyor
4762-2	78-8076-5381-7	Leg Assembly – Inner, W/Stop
4762-3	78-8076-5382-5	Leg – Inner
4762-4	78-8060-8480-8	Pad – Foot
4762-5	78-8055-0867-4	Screw – Hex Hd, M8 x 30
4762-6	78-8017-9313-0	Nut –Self-Locking, M8
4762-7	78-8017-9318-9	Washer – Plain 8 mm
4762-8	78-8076-5383-3	Stop – Leg
4762-9	26-1003-7963-0	Screw – Soc Hd, M8 x 16
4762-10	78-8060-8481-6	Label – Height
4762-11	78-8052-6676-0	Clamp – Outer
4762-12	78-8052-6677-8	Clamp – Inner
4762-13	78-8060-7693-7	Roller – 32 x 38
4762-14	78-8076-5384-1	Shaft – Roller
4762-15	78-8076-5385-8	Spring
4762-16	78-8094-6100-3	Conveyor Assembly – Front
4762-17	78-8076-5387-4	Conveyor – Front
4762-18	78-8091-0780-4	Shaft – Central Roller
4762-19	78-8091-0781-2	Shaft – Side Roller
4762-20	78-8060-7852-9	Screw – Hex Hd, M6 x 10 Special
4762-21	78-8076-5389-0	Mounting – Conveyor
4762-22	78-8094-6101-1	Conveyor Assembly – Rear
4762-23	78-8076-5391-6	Conveyor – Rear
4762-24	78-8076-5392-4	Support – Tape Drum
4762-25	78-8060-8483-2	Support – Outboard Roll
4762-26	78-8060-8484-0	Shaft – Roller

800ab Adjustable Case Sealer

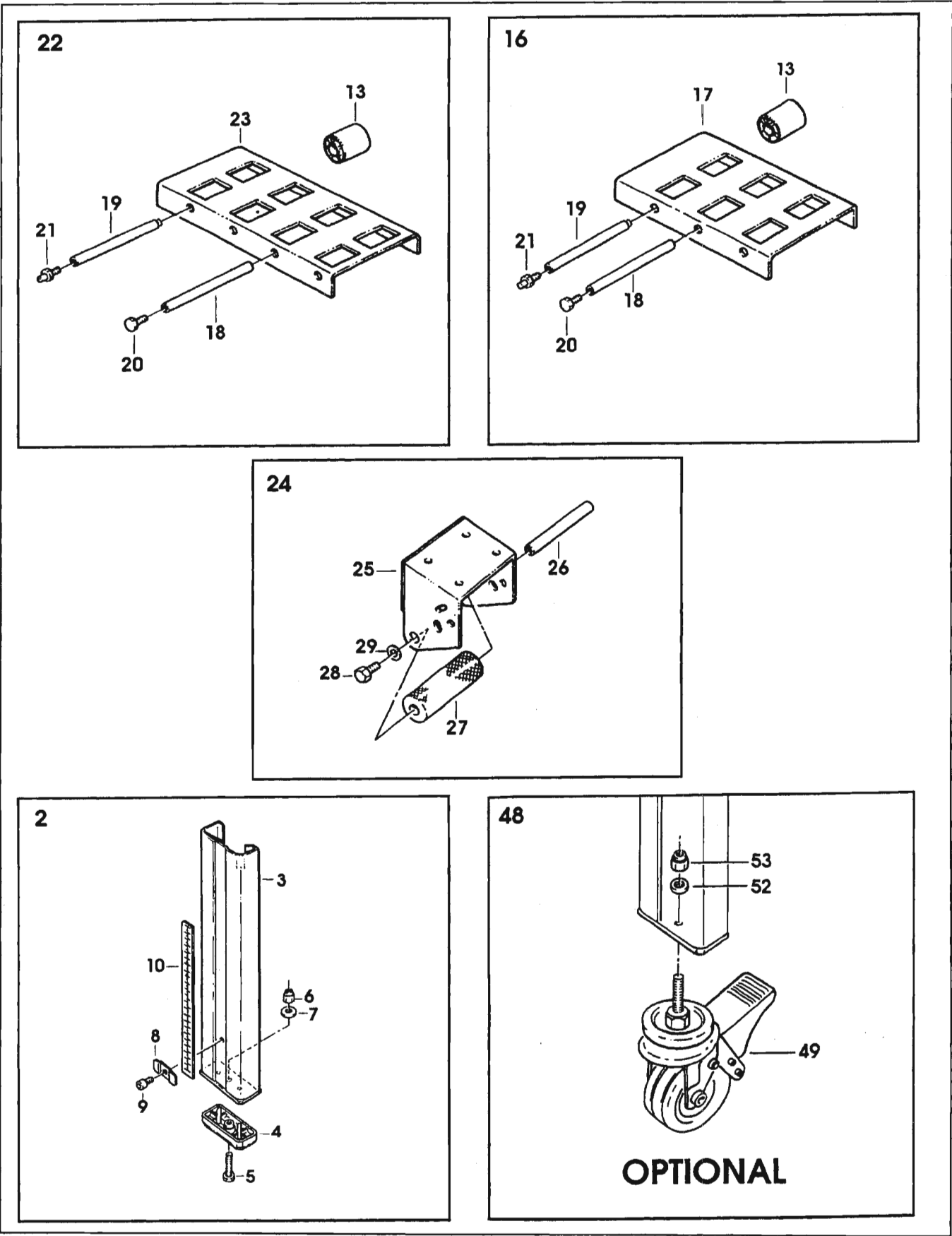


Figure 4762/2 of 2

Figure 4762 (Page 2 of 2)

Ref. No.	3M Part No.	Description
4762-26	78-8060-8484-0	Shaft – Roller
4762-27	78-8060-8485-7	Roller
4762-28	78-8032-0375-7	Screw – Hex Hd M6 x 16
4762-29	26-1000-0010-3	Washer – Flat M6
4762-30	26-1003-7957-2	Screw – Soc Hd Hex Hd M6 x 16
4762-31	78-8060-8487-3	Cover – Switch
4762-32	78-8060-8087-1	Screw – M5 x 10
4762-33	78-8010-7417-6	Nut – Hex M5
4762-34	78-8076-5393-2	Plate – Tape Bracket Support
4762-35	78-8076-5394-0	Spacer
4762-36	78-8076-5483-1	Support – Roller, Chain Tensioning
4762-37	78-8076-5484-9	Cover – R/H
4762-38	78-8076-5485-6	Cover – L/H
4762-39	78-8060-7876-8	Cover – Plug, Lateral
4762-40	78-8028-8208-0	Screw – 6P x 9,5
4762-41	78-8060-7873-5	Plug Female
4762-42	78-8060-8488-1	Screw – Hex Hd M5 x 20
4762-43	78-8046-8217-3	Washer – Special
4762-44	78-8005-5741-1	Washer – Plain M5
4762-45	78-8076-4991-4	Spacer
4762-46	78-8098-9076-3	Caster Assembly
4762-47	26-1009-9096-4	Caster – Dual Locking
4762-50	26-1009-9094-9	Washer – Spring, Helical, M12
4762-51	26-1009-9095-6	Nut – M12
4762-52	78-8100-0763-9	Washer – Special, /25
4762-53	78-8057-5716-4	Screw – Flat Hd Soc, M8 x 15

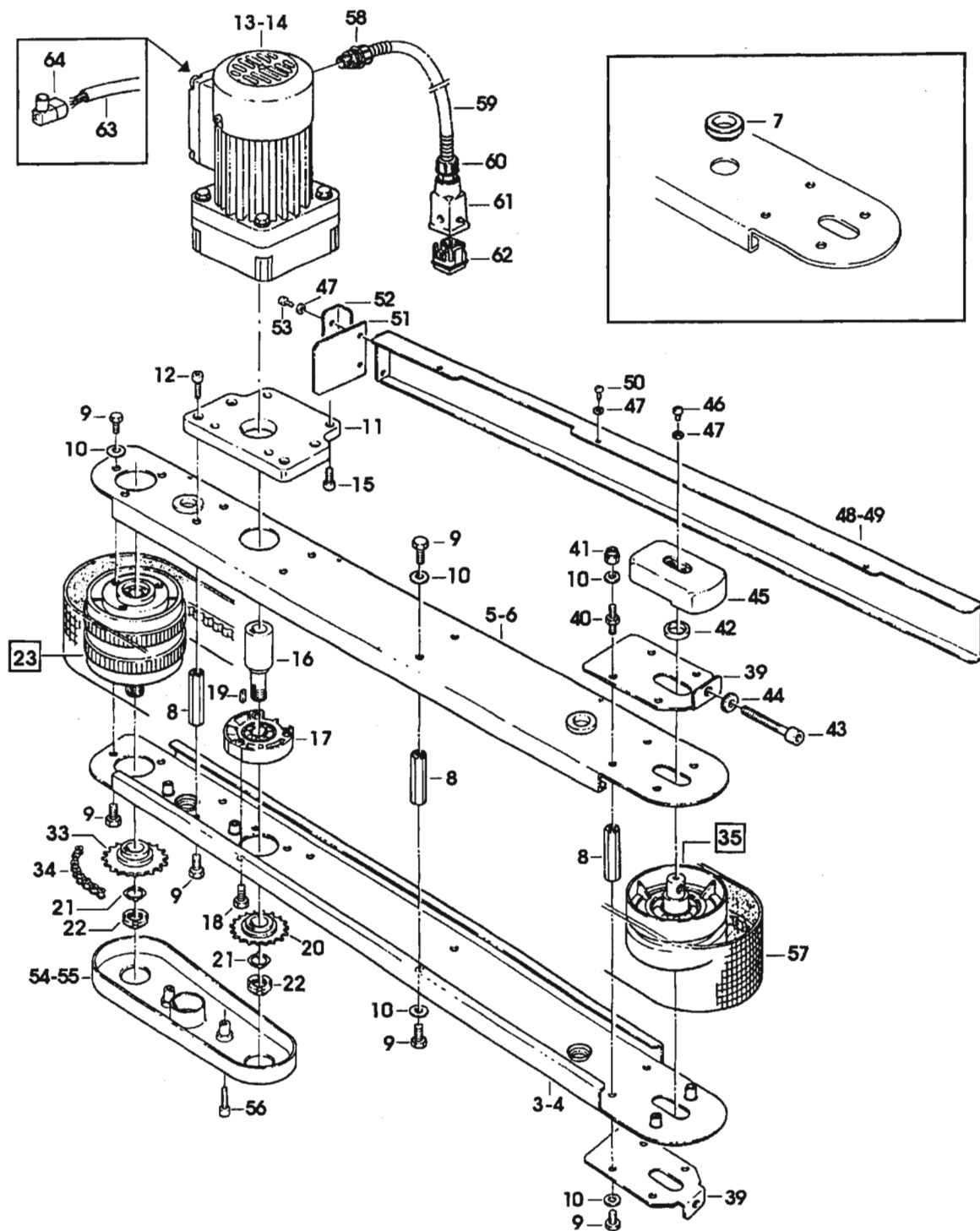


Figure 4763/1 of 2

Figure 4763 (page 1 of 2)

Ref. No.	3M Part No.	Description
4763-1	78-8094-6113-6	Drive Assembly – R/H W/O Motor
	78-8098-8961-7	Drive Assembly – R/H, With Motor
4763-2	78-8094-6114-4	Drive Assembly – L/H W/O Motor
	78-8098-8962-5	Drive Assembly – L/H, With Motor
4763-3	78-8094-6105-2	Guide – Lower, R/H
4763-4	78-8094-6106-0	Guide – Lower, L/H
4763-5	78-8094-6107-8	Guide – Upper, R/H
4763-6	78-8094-6108-6	Guide – Upper, L/H
4763-7	78-8091-0500-6	Bushing – Side Drive
4763-8	78-8055-0661-1	Spacer
4763-9	26-1003-5828-7	Screw – Hex Hd, M6 x 12
4763-10	26-1000-0010-3	Washer – Flat M6
4763-11	78-8094-6109-4	Support – Gearmotor
4763-12	78-8010-7211-3	Screw – Soc Hd, M6 x 25
4763-13	78-8070-1522-3	Gearmotor – 115V, 60 Hz
4763-14	26-1011-8828-7	Capacitor – 115V Gearmotor
4763-15	78-8070-1523-1	Screw – 1/4 - 28 x 1/2 SHCS
4763-16	78-8094-6174-8	Extension – Gearmotor
4763-17	78-8076-5439-3	Flange Assembly
4763-18	78-8060-7886-7	Screw – Hex Hd, M6 x 16, Special
4763-19	78-8046-8135-7	Key – 5 x 5, 12 mm
4763-20	78-8091-0758-0	Sprocket – 3/8 Inch, Z=14
4763-21	78-8057-5834-5	Tab Washer
4763-22	78-8057-5835-2	Centering Washer
4763-23	78-8076-5440-1	Pulley Assembly – Drive
4763-24	78-8091-0716-8	Roller – Drive
4763-25	78-8052-6713-1	Ring – Polyurethane
4763-26	78-8055-0669-4	Shaft – Pulley Keyed
4763-27	78-8057-5739-6	Key – M5 x 5 x 30 mm
4763-28	78-8055-0668-6	Washer – 15/26 x 1
4763-29	78-8091-0382-9	Belleville Washer – /16
4763-30	78-8076-5442-7	Flange Assembly
4763-31	26-0001-5862-1	Screw – Flat Hd Soc, M5 x 12
4763-32	78-8054-8877-8	Washer – 5,5/20 x 4
4763-33	78-8091-0759-8	Sprocket – 3/8 Inch Z=23
4763-34	78-8076-4933-6	Chain – 3/8 Inch Pitch, 52 Pitch

800ab Adjustable Case Sealer

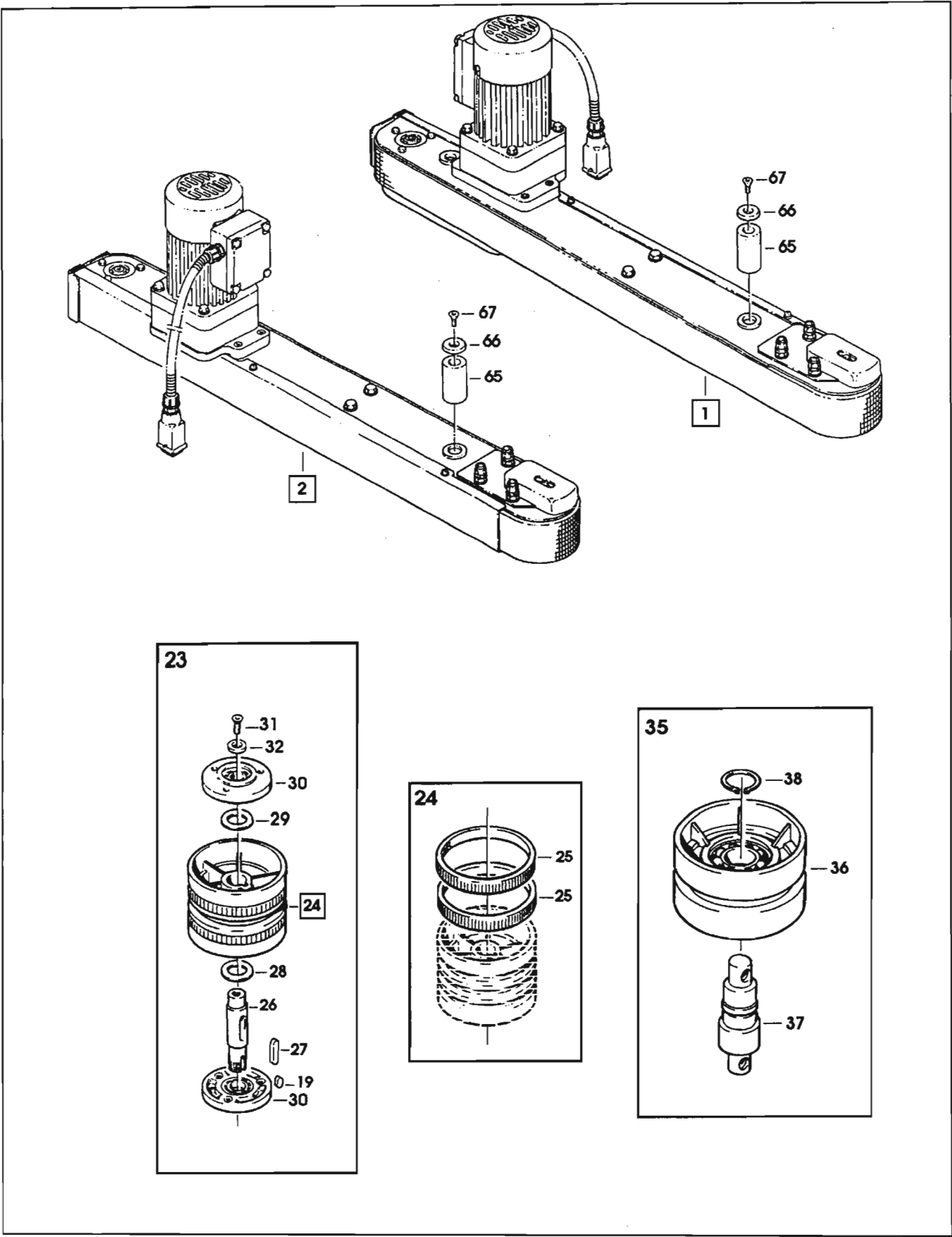
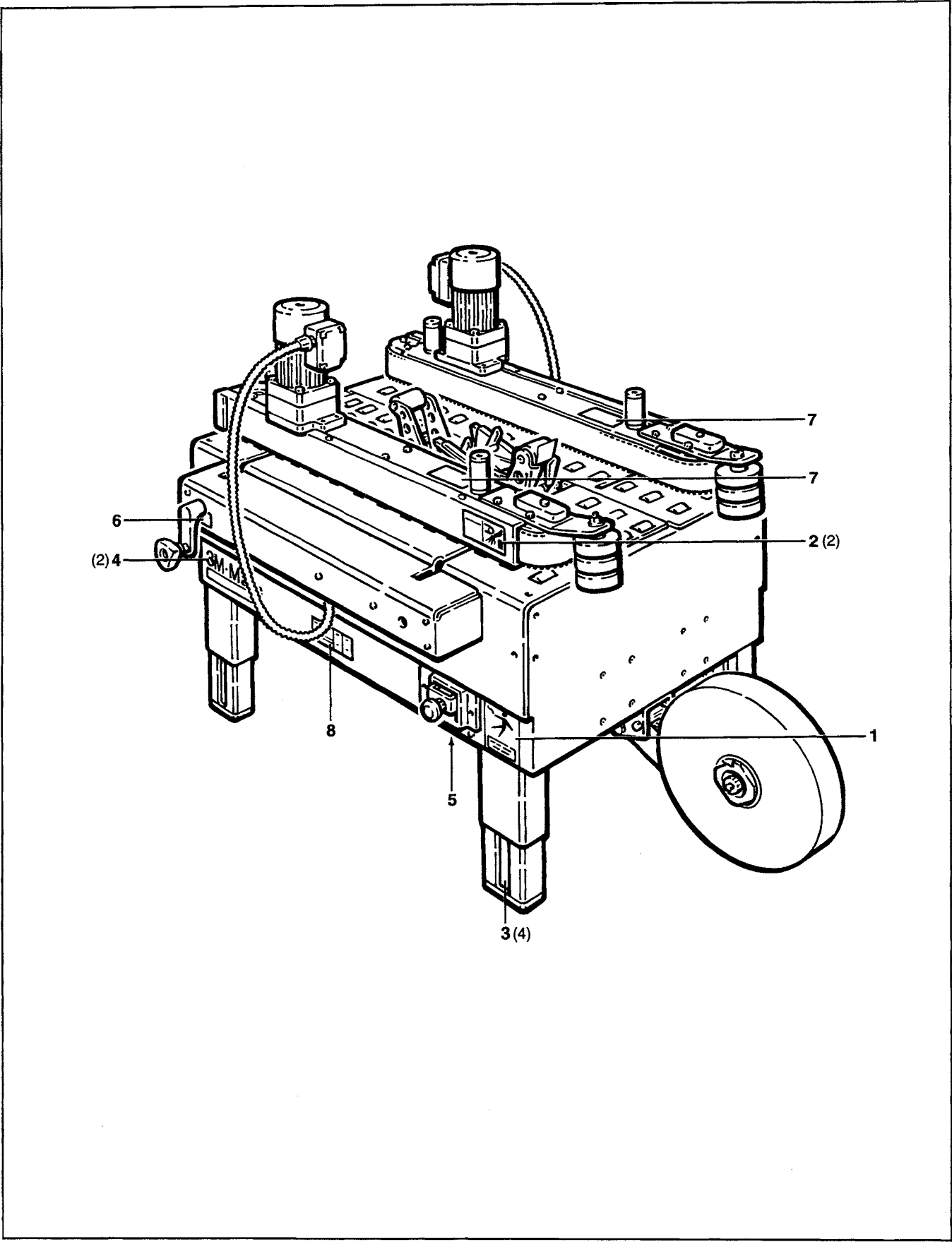


Figure 4763/2 of 2

Figure 4763 (page 2 of 2)

Ref. No.	3M Part No.	Description
4763-35	78-8076-5443-5	Pulley Assembly – Idler
4763-36	78-8055-0660-3	Roller – Idler
4763-37	78-8076-5444-3	Shaft – Idler Pulley
4763-38	12-7997-0272-0	E-Ring – M-25
4763-39	78-8076-5445-0	Tensioning – Belt
4763-40	78-8076-5486-4	Screw – M6, Special
4763-41	26-1003-6916-9	Nut – Locking, M6 Plastic Insert
4763-42	78-8076-5446-8	Washer – Shaft
4763-43	78-8076-5447-6	Screw – Special, M8 x 70
4763-44	78-8017-9318-9	Washer – Plain 8 mm
4763-45	78-8076-5448-4	Cover – Belt Tensioner
4763-46	78-8055-0850-0	Screw – Cap, M4 x 6
4763-47	78-8005-5740-3	Washer – Plain 4 mm
4763-48	78-8094-6110-2	Cover – Drive, R/H
4763-49	78-8094-6111-0	Cover – Drive, L/H
4763-50	26-1002-5753-9	Screw – Self-Tapping
4763-51	78-8055-0650-4	Guard – Belt
4763-52	78-8076-5451-8	Guard – Belt
4763-53	26-1002-4955-1	Screw – Self-Tap 8P x 13
4763-54	78-8091-0764-8	Cover – Chain, Right
4763-55	78-8091-0765-5	Cover – Chain, Left
4763-56	78-8010-7165-1	Screw – Flat Hd Soc, M5 x 25
4763-57	78-8076-5452-6	Belt – Box Drive
4763-58	78-8060-7631-7	Connector – 3/8 Inch
4763-59	78-8076-5197-7	Sleeving – /12, 800 mm
4763-60	78-8060-7626-7	Connector – PG 11/12
4763-61	78-8060-7877-6	Plug Housing – Vertical
4763-62	78-8060-7875-0	Plug Male
4763-63	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
4763-64	78-8076-4602-7	Terminal
4763-65	78-8076-5434-4	Roller
4763-66	78-8054-8577-4	Washer – Special
4763-67	26-1001-9843-6	Screw – Flat Soc Hd, M6 x 16

800ab Adjustable Case Sealer



Safety and Information Labels

800ab Safety and Information Labels

A label kit, part number 78-8098-9034-2, is available as a stock item. It contains all the safety and information labels used on the case sealer, or labels can be ordered separately from the following list.

Ref. No.	3M Part No.	Description	Qty.
	78-8098-8799-1	Label Kit (Includes items 1 - 8)	
1	78-8070-1329-3	Warning – Hazardous Voltage	1
2	78-8070-1331-9	Warning – Keep Hands Away From Moving Belts	2
3	78-8060-8481-6	Information – Leg Height	4
4	78-8062-4266-1	Information – 3M-Matic	2
5	78-8068-3852-6	Information – Ground	1
6	78-8098-8955-9	Information – In/Out, Belt Adjustment	1
7	78-8070-1629-6	Information – Belt tensioning	2
8	78-8098-8800-7	Nameplate – Type 29400	1

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

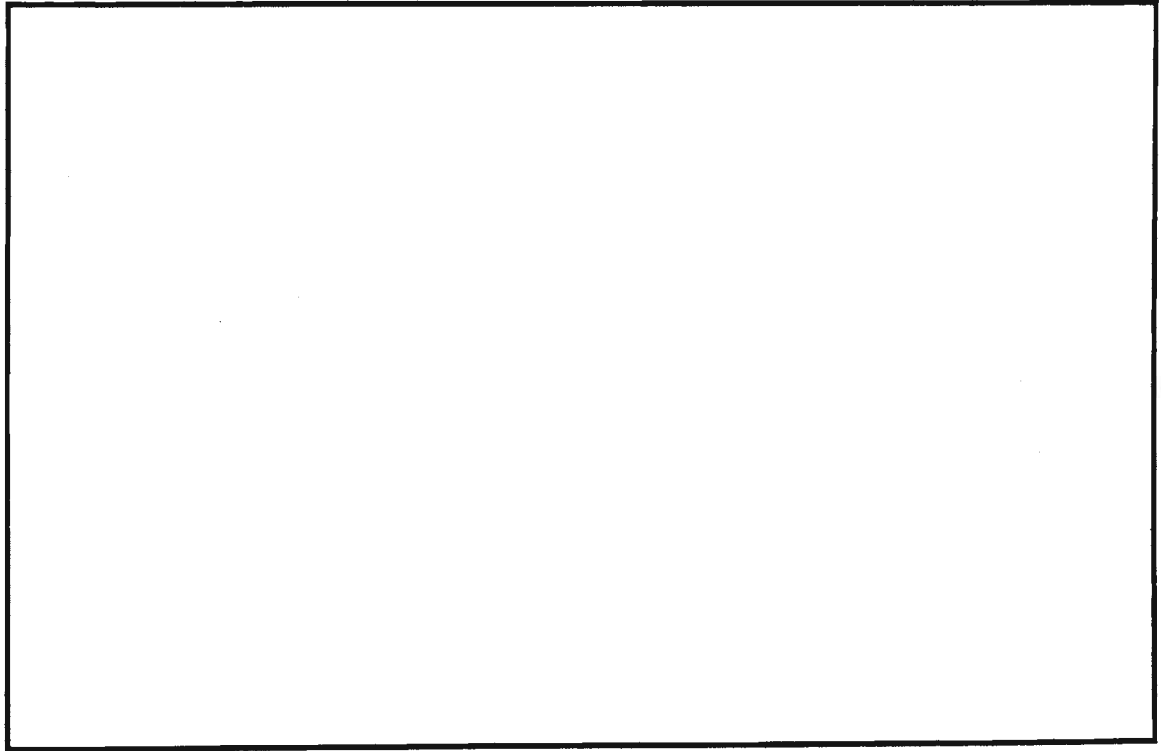
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To Our Customers:

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

AccuGlide™ II STD 2 Inch
Upper and Lower Taping Heads
Type 29000

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

3M sells its **AccuGlide™ II STD 2 Inch Upper and Lower Taping Heads, Type 29000** 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.

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 the 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.

Taping Head Contents

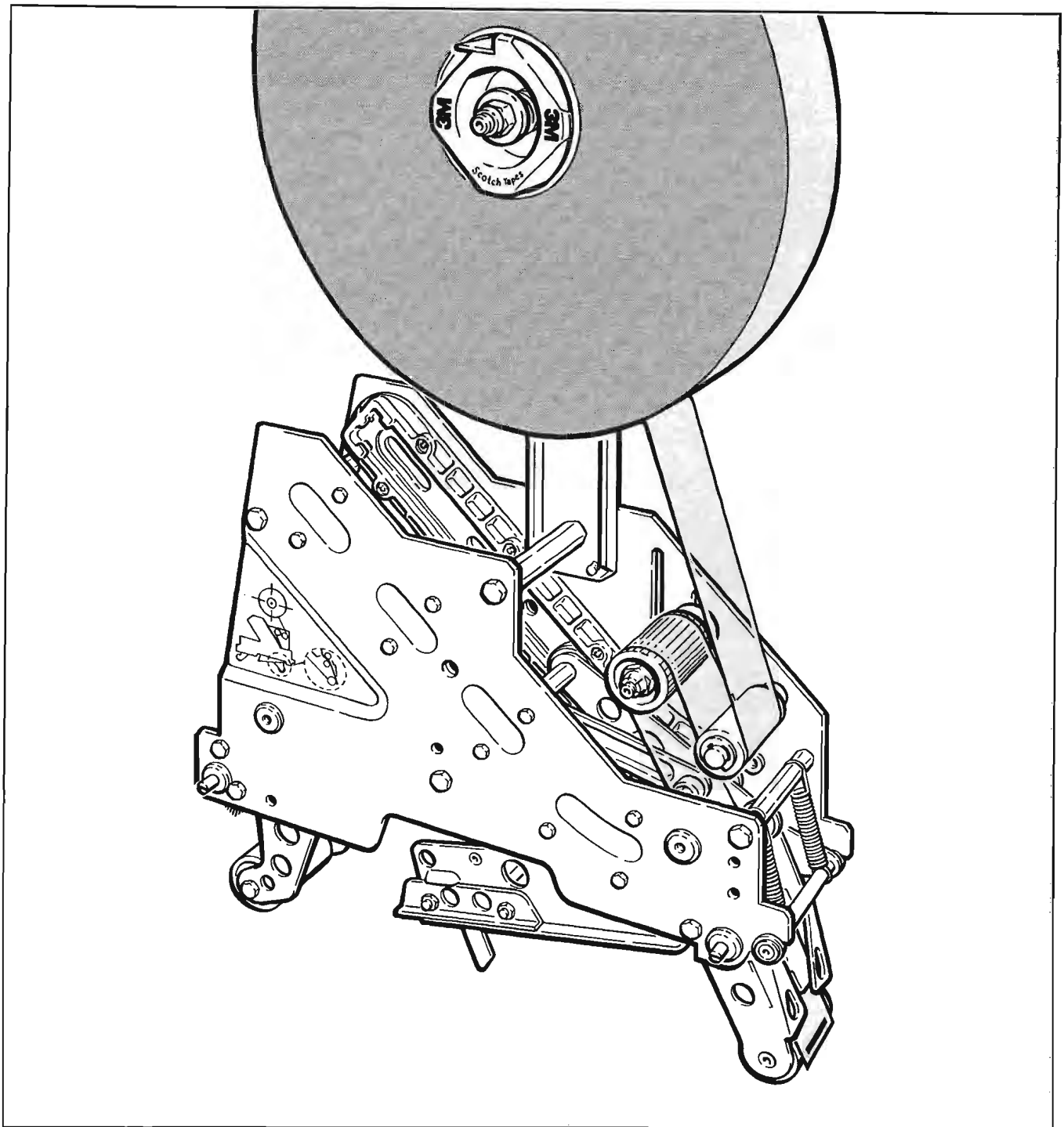
AccuGlide™II STD 2 Inch Upper Taping Head consists of:

Qty.	Part Name
1	Taping Head Assembly
1	Tape Drum and Bracket Assembly
1	Hardware and Spare Parts Kit
1	Threading Tool

AccuGlide™II STD 2 Inch Lower Taping Head consists of:

Qty.	Part Name
1	Taping Head Assembly
1	Tape Drum and Bracket Assembly
1	Hardware and Spare Parts Kit
1	Threading Tool

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AccuGlide™ II STD 2 Inch Upper Taping Head, Type 29000

Description

The **AccuGlide™ II STD 2 Inch Upper and Lower Taping Heads**, were designed for installation on **3M-Matic™** case sealers. The taping heads apply a "C" clip of "**Scotch**" brand pressure-sensitive film box sealing tape to the top and bottom center seam of regular slotted containers.

The compact size and simplicity of the taping head also makes it suitable for mounting into other box conveying systems to tape cartons. This includes replacement of other types of taping, gluing or stapling heads in existing case sealing machines.

Warning and Information Labels

The “**Warning-Sharp Knife**” label warns operators and service personnel of the extremely sharp knife used to cut the tape at the end of the box sealing operation. The label shown in Figure 1-1 is located on the orange blade guard between the applying roller assembly and the buffing roller assembly. **Never operate taping heads with blade guard removed.**

Before working with the taping heads or loading/threading tape, refer to Figures 3-1 and 3-2 to identify the knife blade location. **Keep hands out of these areas except as necessary to service the taping heads or to load/thread tape.**

The “**Tape Threading Label**”, shown in Figure 1-2, is attached to the left side of both the upper and lower taping heads. This label provides a convenient tape threading diagram. More detailed tape loading and threading information is provided in the “Operation” section this manual.

Turn air and electrical supplies “Off” before servicing the taping heads.

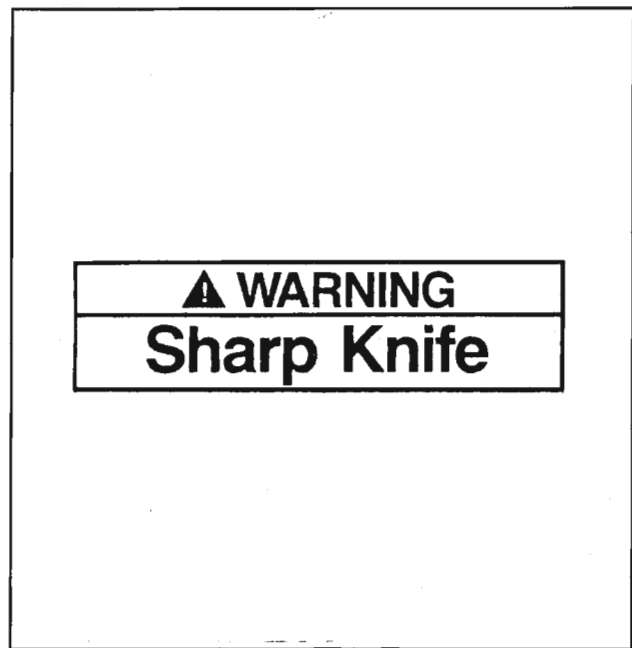


Figure 1-1 – Knife Warning Label

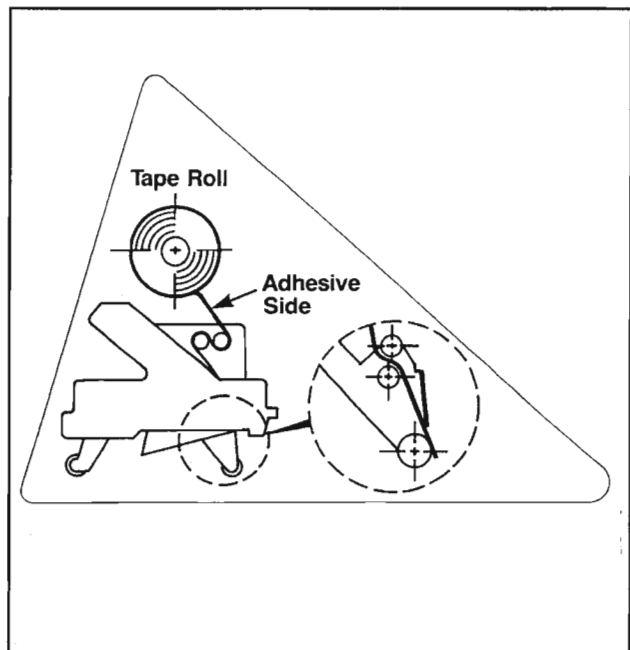


Figure 1-2 – Tape Threading Label



This safety alert symbol identifies important safety messages in this manual. **READ AND UNDERSTAND THEM BEFORE INSTALLING OR OPERATING THIS EQUIPMENT.**

Specifications

1. Tape:

For use with “**Scotch**” brand pressure-sensitive film box sealing tapes.

2. Tape Width:

36 mm or 1-1/2 inches minimum to 48 mm [2 inches] maximum.

3. Tape Roll Diameter:

Up to 405 mm [16 inches] maximum on a 76.2 mm [3 inch] diameter core.
(Accommodates all system roll lengths of “**Scotch**” brand film tapes.)

4. Tape Application Leg Length - Standard:


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

Tape Application Leg Length - Optional:

50 mm \pm 6 mm [2 inches \pm 1/4 inch] (See "Adjustments – Tape Leg Length", page 13.)

5. Box Size Capacities:

For use with center seam regular slotted containers.

Minimum		Maximum	
Length –	150 mm [6 inches]		Unlimited
Height –	120 mm [4-3/4 inches] (most “3M-Matic” Case Sealers) 90 mm [3-1/2 inches] (with optional 2 inch leg length)		Limited by Case Sealer
Width –	150 mm [6 inches]		

When upper and lower taping heads are used on “**3M-Matic**” case sealers, refer to the respective instruction manual specifications for box weight and size capacities.

6. Operating Rate:

Conveyor speeds up to 0.40 m/s [80 FPM] maximum.

7. Operating Conditions:

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

Important – Taping heads should not be washed down or subjected to conditions causing moisture condensation on components.

7. Taping Head Dimensions:

Length	–	400 mm [15-3/4 inches]
Height	–	560 mm [22 inches] (with tape drum)
Width	–	105 mm [4-1/8 inches] (without mounting spacers)
Weight	–	Packaged: 8.2 kg [18 lbs.] Unpackaged: 7.2 kg [16 lbs.]

Specifications

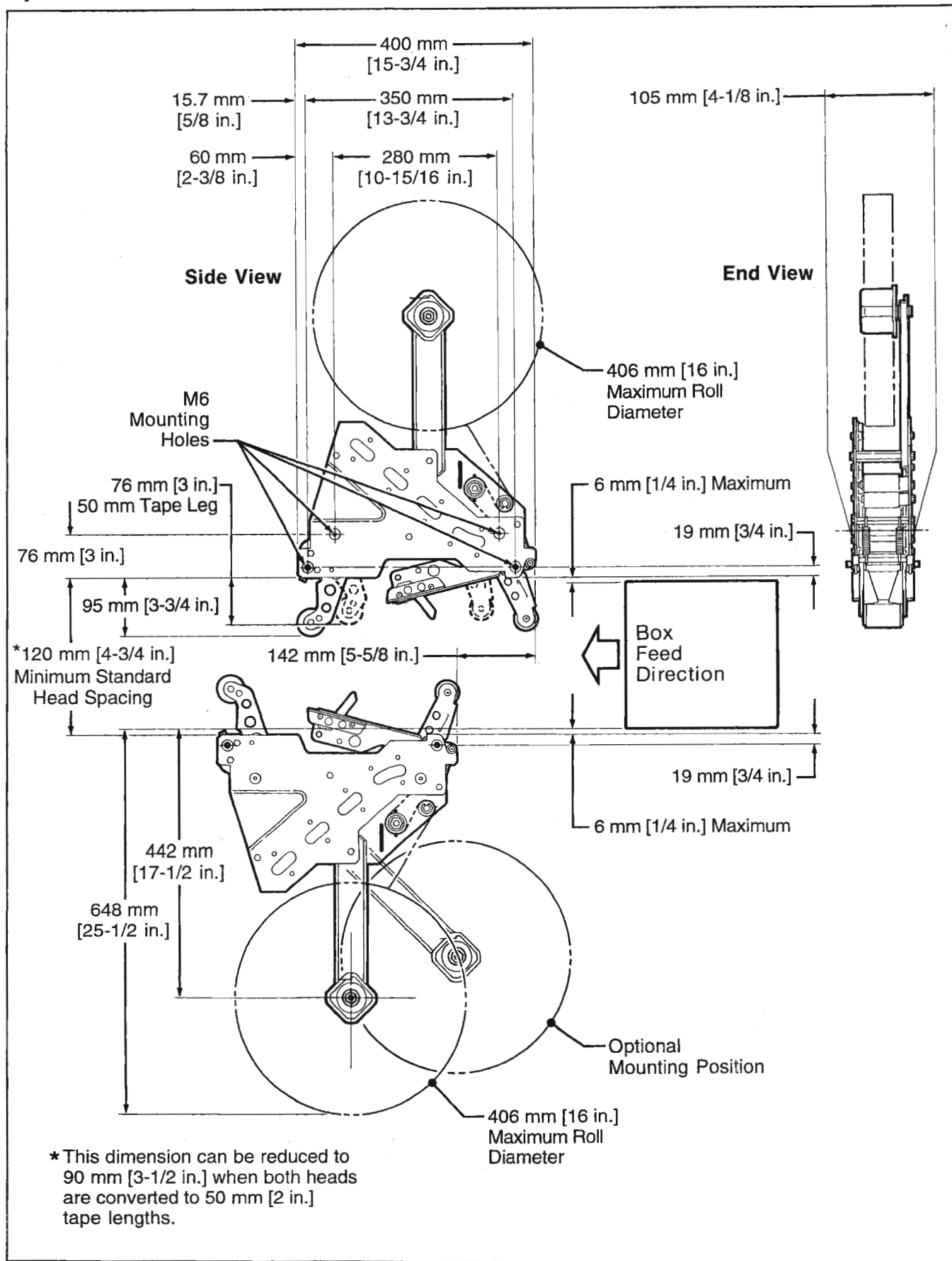


Figure 2-1 – Dimensional Drawing

Installation (Continued)



WARNING – 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 loading tape, refer to Figures 3-1 and 3-2 on page 6 and identify the blade location. Keep hands out of these areas except as necessary to service the taping heads.

Receiving And Handling

After the taping head assembly has been unpackaged, examine the unit for damage that might have occurred during transit. **If damage is evident, file a damage claim immediately** with the transportation company and also notify your 3M Representative.

Installation Guidelines

The taping head assembly can be used in converting existing or in custom made machinery. It can be mounted for top taping or bottom taping. Refer to box size specifications on page 3, and Figure 2-1 on page 4, for the following points in making such installations:

1. The box conveying system must positively propel the box in a continuous motion, **not exceeding 0.40 m/s [80 feet per minute]**, past the taping head assembly since the box motion actuates the taping mechanism.
2. If a pusher or cleated conveyor is being used, steps should be taken in the conveyor design to **prevent the pusher from contacting the applying or buffing roller arms resulting in damage to the taping head.**
3. Figure 2-1 illustrates the typical mounting relationship for opposing taping head assemblies to allow taping of box heights down to 90 mm [3-1/2 inches]. **To tape box heights down to 70 mm [2-3/4 inches], the taping heads must be completely staggered so only one tape seal is being applied at one time.**

4. Mounting studs are provided with the taping head, but special installations may require alternate means for mounting.
5. Box hold-down or guide skis should be provided and the taping head mounted so that the side plates are 6 mm [1/4 inch] maximum away from the ski surface on which the box rides.

Tape Leg Length

Taping heads are factory set to apply standard 70 mm [2-3/4 inch] tape legs. The heads can be converted to apply 50 mm [2 inch] tape legs if desired but both upper and lower heads must be set to apply the same tape leg length. See "Adjustments – Changing Tape Leg Length From 70 to 50 mm [2-3/4 to 2 Inches]", page 13.

Also, the conveyor speed at which the product moves through the taping heads, affects the leading and trailing tape leg length. See, "Adjustments – Leading Tape Leg Length Adjustment", page 13.

Tape Width

Taping heads are factory set to apply 48 mm [2 inch] wide tape. To apply narrower tapes, refer to "Adjustments – Tape Web Alignment", page 11 for set-up procedure.

Operation

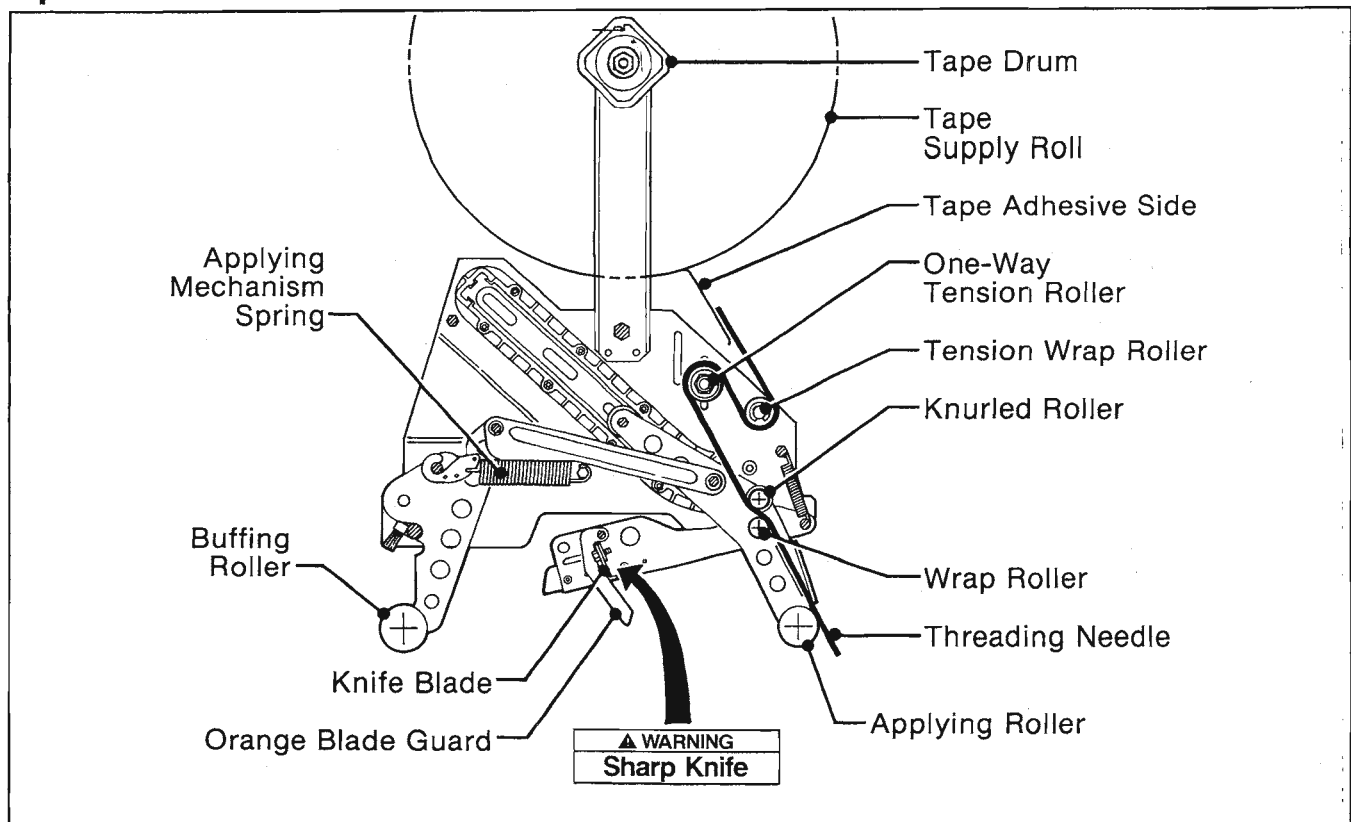


Figure 3-1 – Taping Head Components/Threading Diagram, Upper Head (Left Side View)

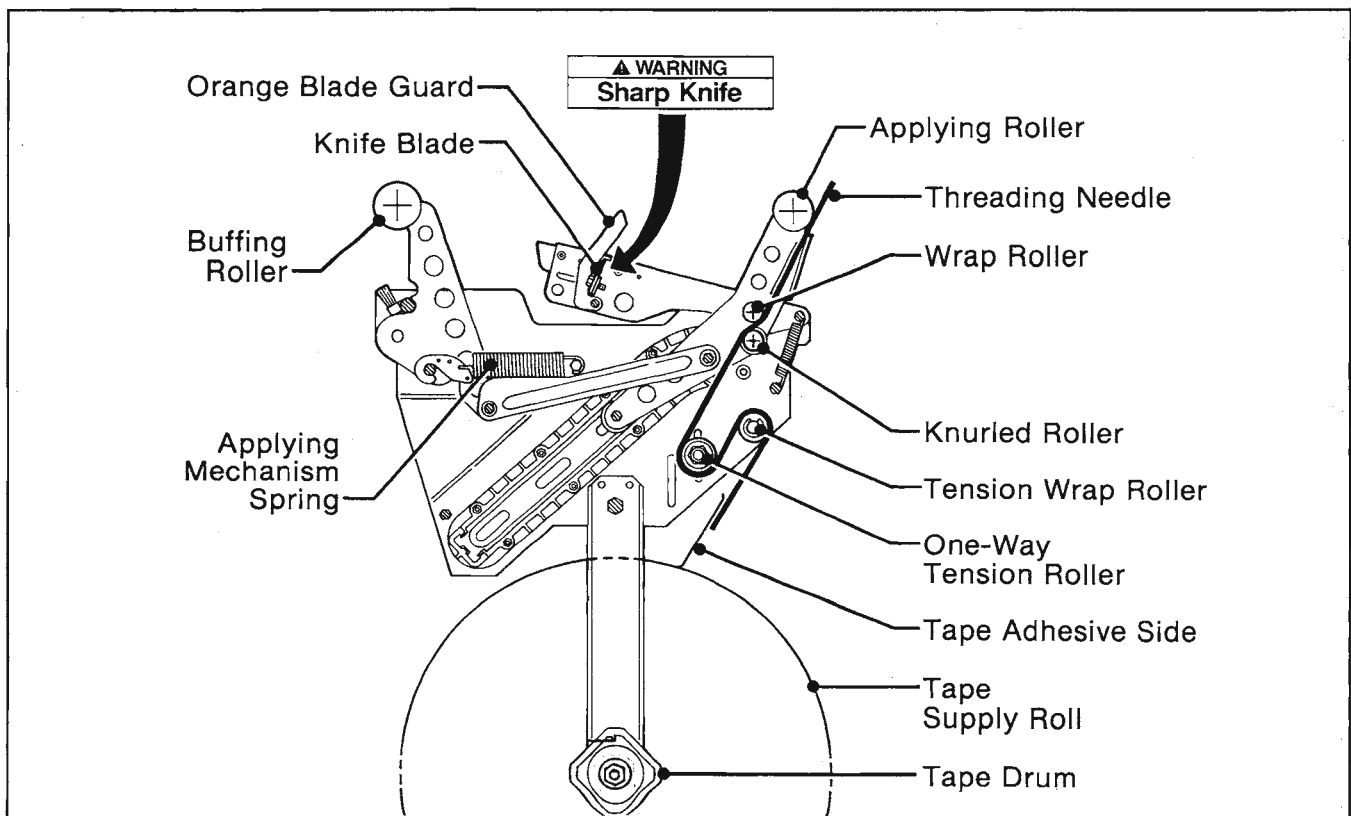


Figure 3-2 – Taping Head Components/Threading Diagram – Lower Head (Left Side View)

Operation (Continued)



WARNINGS

1. Turn air and electrical supplies off and disconnect before servicing taping heads.
2. Never attempt to work on the taping heads or load tape when the box drive system is running.
3. The taping heads use extremely sharp knife blades. Before working with the taping heads or attempting to load/thread tape, refer to Figures 3-1 and 3-2 and identify the blade location. Keep hands out of these areas except as necessary to service the taping heads.
4. Failure to comply with these warnings can result in severe personal injury and/or equipment damage.

It is recommended that the detailed instructions and sketches in this manual be referred to the first few times the taping head is loaded/threaded until the operator becomes thoroughly familiar with the tape loading operation.

Tape Loading – Upper Taping Head

1. Raise the upper taping head to a convenient working position.
2. Use the plastic threading needle (provided) and follow the loading procedures (Figures 3-3 to 3-5) to complete the tape threading.

Tape Loading – Lower Taping Head

1. For ease in loading, first remove the lower taping head from the conveyor bed.
2. The lower taping head is loaded and threaded in the same manner as the upper head. Follow the upper taping head tape loading/threading procedure.

Figure 3-3

Insert threading needle through rollers in direction indicated by arrows.

Figure 3-4

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

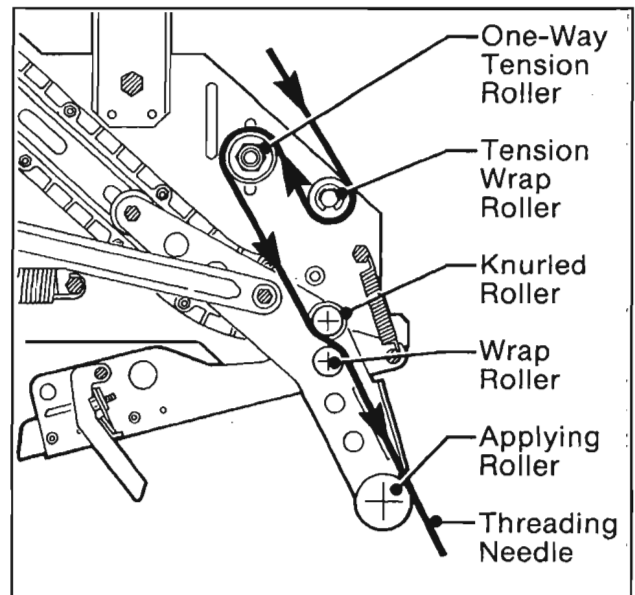


Figure 3-3 – Tape Loading/Threading

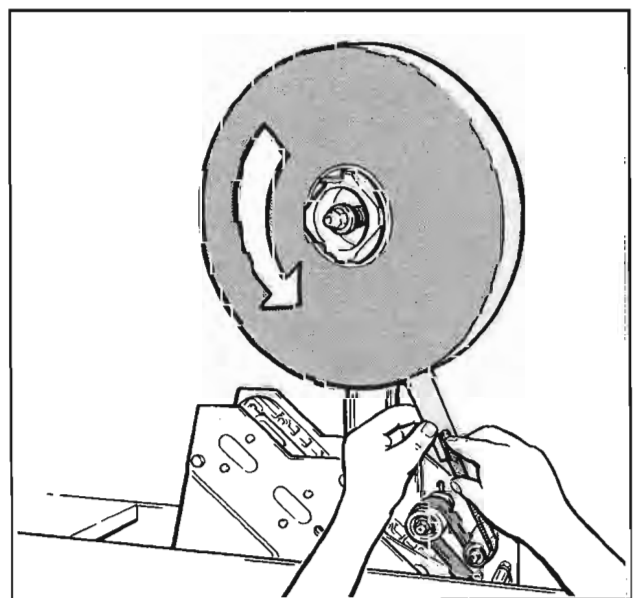


Figure 3-4 – Tape Loading/Threading

Operation (Continued)

Figure 3-5



WARNING – Use care when working near cut-off blade as blade is extremely sharp. If care is not taken, severe personal injury could result.

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

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

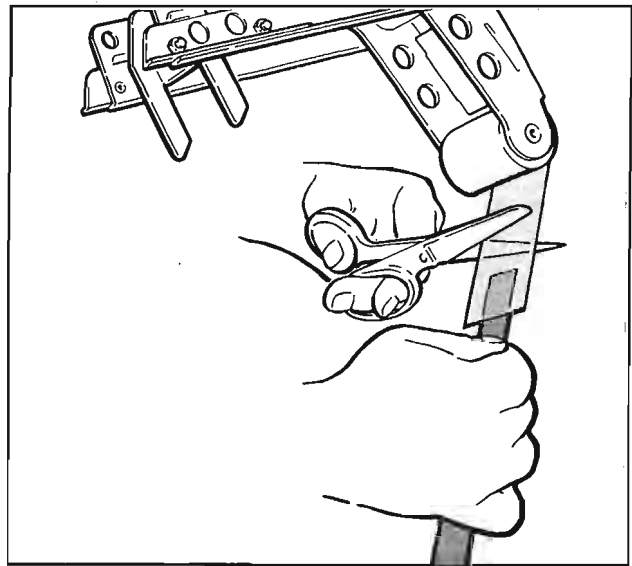


Figure 3-5 – Tape Loading/Threading

Maintenance



WARNINGS

1. Turn air and electrical supplies off and disconnect before beginning maintenance.
2. Use care when working near tape cut-off blade as blade is extremely sharp.
3. Failure to comply with these warnings could result in severe personal injury or equipment damage.

The **AccuGlide™ STD II 2 Inch Taping Head** has been designed for long, trouble free service. The taping head will perform best when it receives routine maintenance and cleaning. Taping head components that fail or wear excessively should be promptly repaired or replaced to prevent damage to other portions of the head or to the product.

Blade Replacement, Upper and Lower Taping Heads – Figure 4-1

1. Loosen, but do not remove, the blade screws (A). Remove and discard 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 between blade and guard by slowly pivoting the blade guard back.

Blade Oiler Pad

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

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

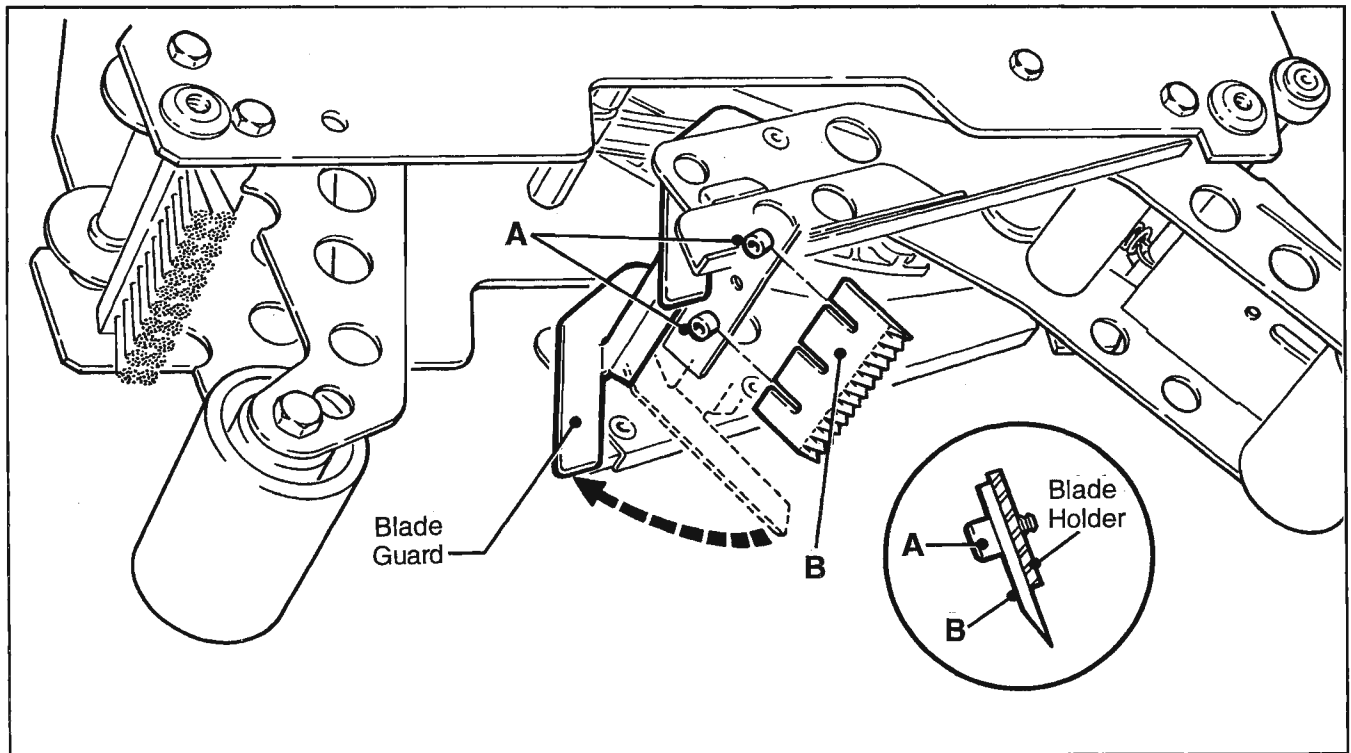


Figure 4-1 – Blade Replacement



WARNINGS

1. Turn air and electrical supplies off and disconnect before beginning maintenance.
2. Use care when working near tape cut-off blade as blade is extremely sharp.
3. Failure to comply with these warnings could result in severe personal injury or equipment damage.

Cleaning

Regular slotted containers produce a great deal of dust and paper chips when conveyed through taping heads. If this dust is allowed to build-up on the heads, it can cause wear on the moving parts. Excessive dirt build-up should be wiped off with a damp cloth. Cleaning should be done **once per month**, depending on the number and type of boxes used. If the boxes used are dirty, or if the environment in which the heads operate is dusty, cleaning on a more frequent basis may be necessary.

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 components onto sliding surfaces. Dirt in these areas can cause serious equipment damage. Never wash down or subject taping heads to conditions causing moisture condensation on components. Serious equipment damage could result.

Lubrication

Like most other equipment, the taping head must be properly lubricated to insure long, trouble free service.

Figure 4-2 illustrates points which should be lubricated **every 3 months or 150,000 machine cycles**, whichever comes first. 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 guides and to the end of each spring where the loop is secured at an eyelet, post, or hole noted by arrows (⇨).

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

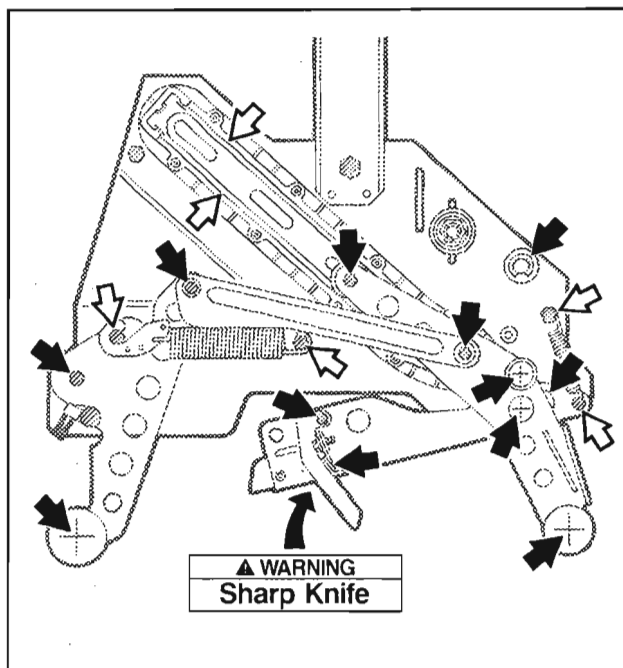


Figure 4-2 – Lubrication Points, Upper and Lower Taping Heads

Applying/Buffering Roller Replacement

Replacing roller requires removal of shaft and mounting screws. With no area on the shaft to grip, the shaft often turns when attempting to remove the second screw.

To ease removal of second screw, a 4 mm hex socket has been provided at the bottom of the threads in both ends of the shaft. Insert a 4 mm hex key wrench into this socket after removing one screw to hold the shaft for removal of the second screw. See Figure 4-3.

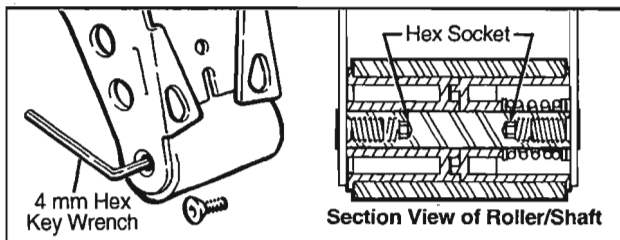


Figure 4-3 – Section View of Roller Shaft

Adjustments



WARNING – Turn air and electrical supplies off and disconnect before beginning adjustments. Failure to comply with this warning could result in severe personal injury and/or equipment damage.

Tape Web Alignment – Figure 5-1

The STD tape drum assembly is pre-set to accommodate 48 mm [2 inch] wide tape. The tape drum assembly is adjustable to provide alignment of narrower tapes. If adjustment is necessary to center the tape width on the centerline of the taping head, (and therefore box center seam), make adjustment as follows:

1. Loosen the locking hex nut behind tape drum bracket 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.

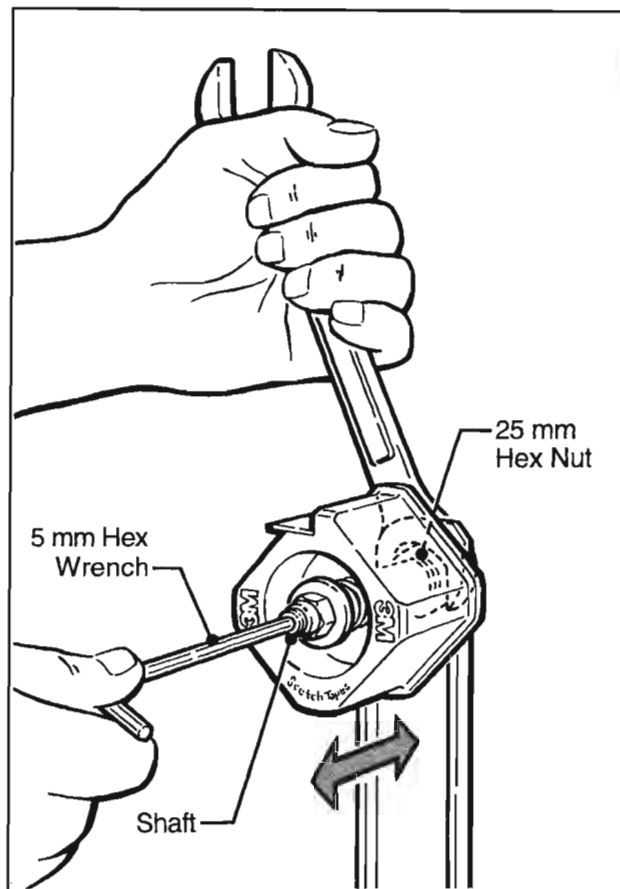


Figure 5-1 – Tape Web Alignment

Tape Drum Friction Brake – Figure 5-2

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

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

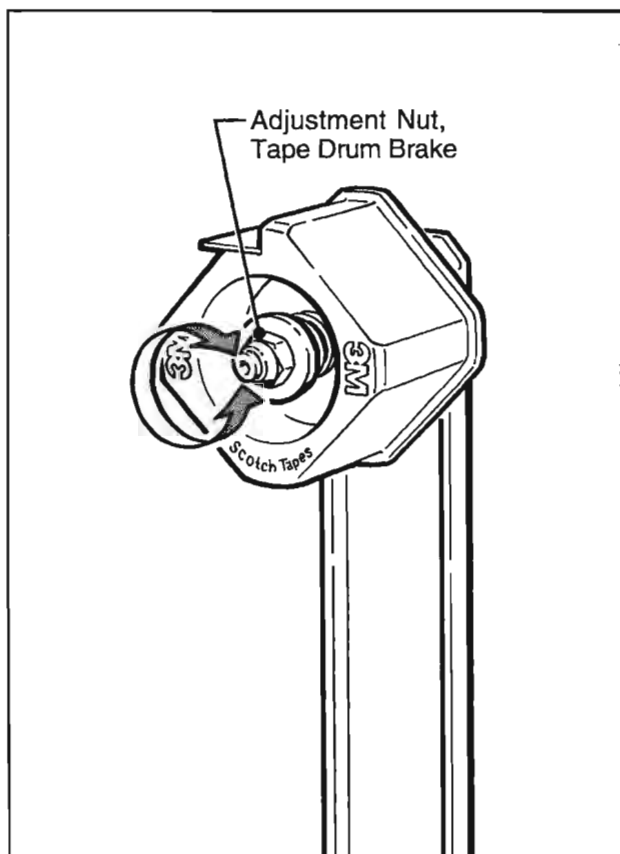


Figure 5-2 – Tape Drum Friction Brake

Adjustments (Continued)



WARNING – Turn air and electrical supplies off and disconnect before beginning adjustments. Failure to comply with this warning could result in severe personal injury and/or equipment damage.

Applying Mechanism Spring

The applying mechanism spring, shown in Figures 3-1 and 3-2, controls applying and buffing roller pressure on the box and returns the mechanism to the reset position. The spring pressure is pre-set, as shown in Figure 5-3A for normal operation, but is adjustable.

If a tape gap appears on the trailing surface of the box increase spring pressure. If the front of the box is being crushed by the applying roller decrease spring pressure.

Removing the spring end loop from the spring holder and placing loop in other holes provided, as shown in Figure 5-3B, will adjust the spring pressure.

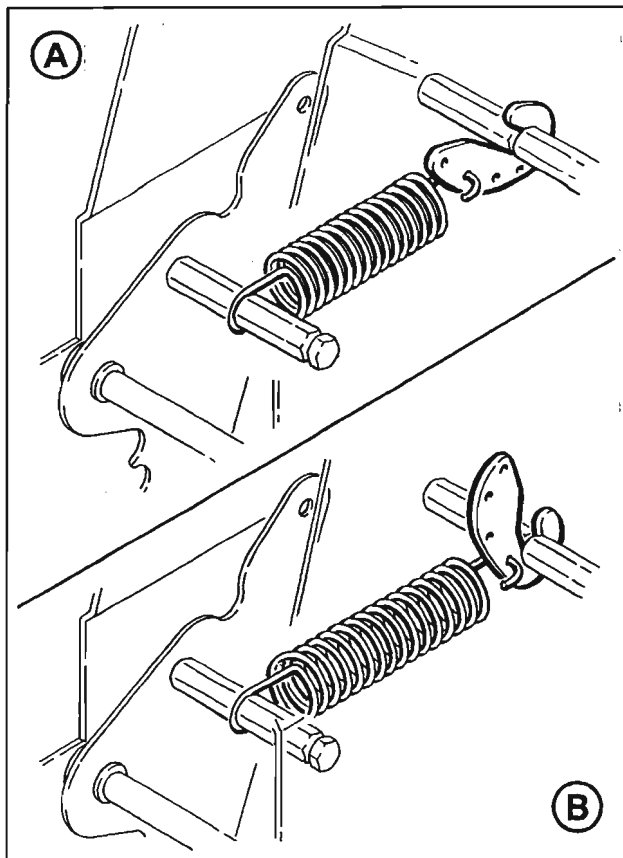


Figure 5-3 – Applying Mechanism Spring

One-Way Tension Roller

Figure 5-4

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

To Adjust 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 with the socket wrench provided, until a force of approximately 0,5 kg to 0,9 kg [1 to 2 lbs.] is required to turn the roller by pulling on the spring scale.

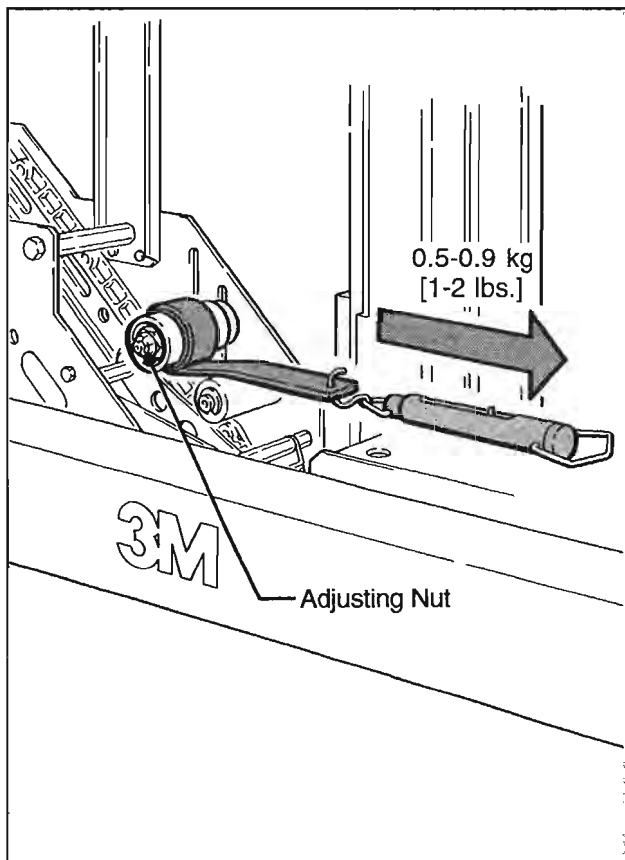


Figure 5-4 – One-Way Tension Roller

Adjustments (Continued)



WARNING – Turn air and electrical supplies off and disconnect before beginning adjustments. Failure to comply with this warning could result in severe personal injury and/or equipment damage.

Tape Leg Length



WARNING – Use care when working near cut-off blade as blade is extremely sharp. If care is not taken, severe injury could result.

LEADING TAPE LEG LENGTH ADJUSTMENT – Figure 5-5

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 or bottom surface will increase the leading leg length.

CHANGING TAPE LEG LENGTH FROM 70 to 50 mm [2-3/4 TO 2 INCHES] – Figure 5-6

Note – When changing tape leg length, both upper and lower heads must be adjusted to apply the same leg lengths.

1. Remove and retain two hex head screws and remove the brush from normal position "A" on side frame.
2. Remount and secure brush in position "A-A" on side frame forward of normal location using original fasteners.
3. Remove cut-off bracket extensions from position "B".
4. Remount cut-off bracket extensions in forward position "B-B".
5. Remove and retain the one-way tension roller assembly from slot "C" in frame.
6. Remount tension roller assembly near top of slot "C-C" in frame using original fasteners.
7. Adjust tension roller according to "Leading Tape Leg Length Adjustment" above.

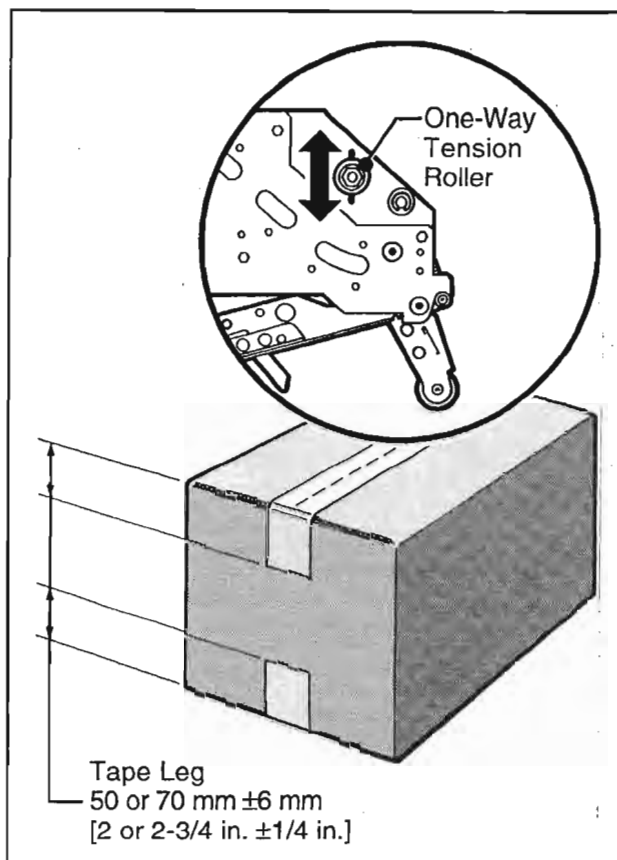


Figure 5-5 – Leading Tape Leg Length

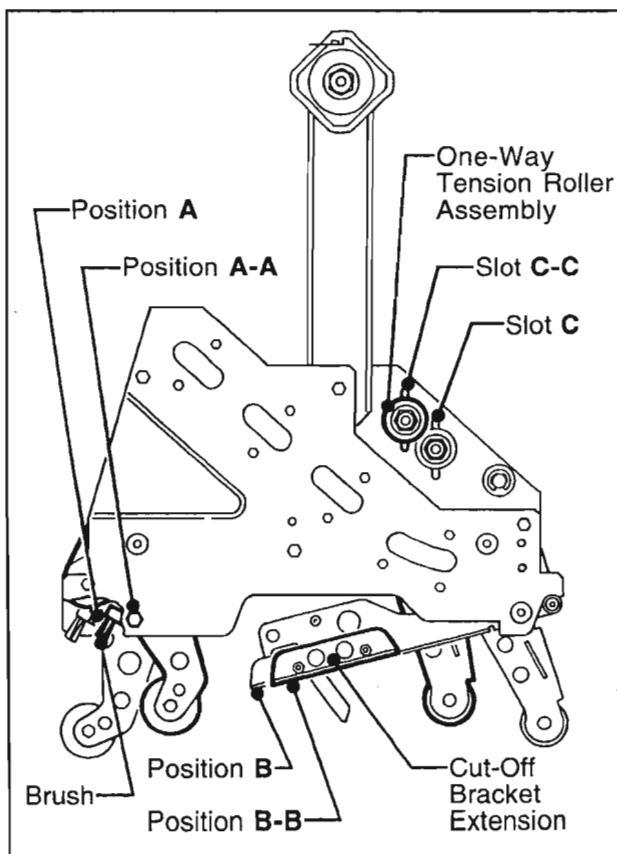


Figure 5-6 – Changing Tape Leg Length

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Troubleshooting

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 alignments
	The one-way tension roller is not correctly positioned	Position the roller in its mounting slot so that the tape extends just beyond the centerline of the applying roller
	Taping head is not set up properly	Check leg length adjustments
The blade does not cut tape or the tape end is jagged or shredded	The blade is dull and/or has broken teeth	Replace the blade
	Tape tension is insufficient	Increase tape tension by adjusting the one-way tension roller
	Adhesive has built up on the blade	Clean and adjust the blade
	The blade is not positioned properly	Make sure the blade is bottomed out against the mounting bolts
	The blade is dry	Lubricate the blade oiler pad on the blade guard
	The blade is in backwards	Mount the blade so that the beveled edge is away from the entrance of the head
	One or both cutter springs are missing or stretched	Replace the defective spring(s)
	Tension roller surface is not fully contacting the taping head frame	Make sure one-way bearing is below the surface of the tension roller. If not, press bearing further into roller or replace roller.

(Continued)

Troubleshooting (Continued)

Troubleshooting Guide

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

Spare Parts/Service Information

Recommended Spare Parts

A set of spare parts that will periodically require replacement due to normal wear is supplied with the taping heads. The set includes the following which should be reordered when used to keep the taping heads in production:

AccuGlide™ II STD 2 Inch Upper Taping Head

Qty.	Ref. No.	Part Number	Description
------	----------	-------------	-------------

4	2879-22	78-8076-4500-3	Stud – Mounting
1	2881-10	78-8070-1274-1	Spring – Upper Extension (Silver)
1	2883-2	78-8017-9173-8	Blade – 65 mm/2.56 Inch
2	2883-12	78-8052-6602-6	Spring – Cutter
1	–	78-8017-9433-6	Tool – Tape Threading

AccuGlide™ II STD 2 Inch Lower Taping Head

Qty.	Ref. No.	Part Number	Description
------	----------	-------------	-------------

1	2883-2	78-8017-9173-8	Blade – 65 mm/2.56 Inch
2	2883-12	78-8052-6602-6	Spring – Cutter
4	2885-22	78-8076-4500-3	Stud – Mounting
4	2885-24	78-8076-4991-4	Spacer – Mounting
1	2886-10	78-8070-1273-3	Spring – Lower Extension (Black)
1	–	78-8017-9433-6	Tool – Tape Threading

In addition to the above set of spare parts supplied with the taping head, it is suggested that the following spare parts be maintained which will require replacement under normal wear of the taping head.

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	2883-6	78-8070-1390-5	Spring – Torsion

Replacement Parts and Service

Refer to the first page of this instruction manual “**Replacement Parts and Service Information**”.

Replacement Parts Illustrations and Parts Lists

AccuGlide II STD 2 Inch Upper Taping Head, Type 29000

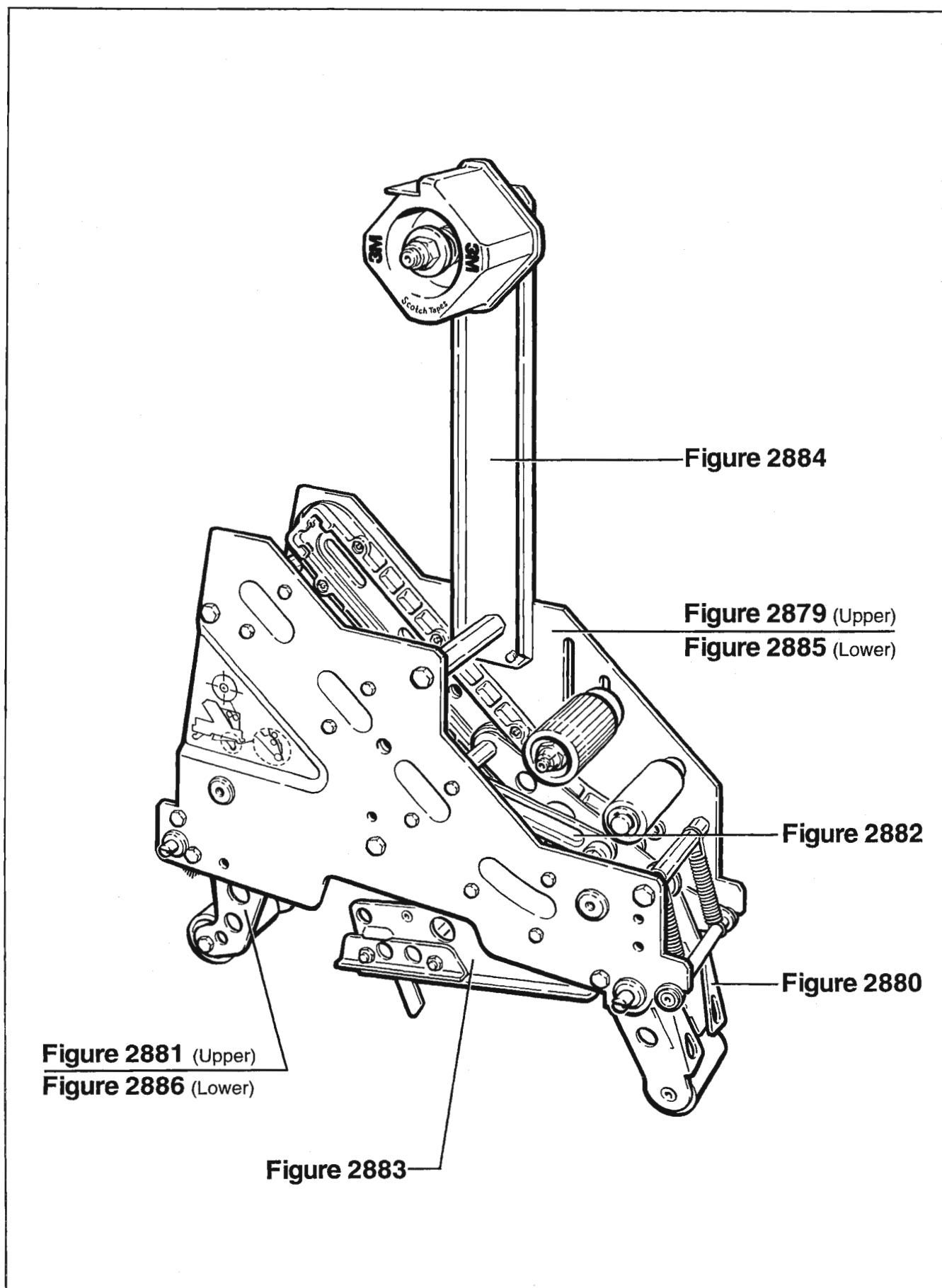
AccuGlide II STD 2 Inch Lower Taping Head, Type 29000

1. Refer to **Taping Head Assemblies** Figure, page 19 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 the first page of this instruction manual "**Replacement Parts and Service Information**" for replacement parts ordering information.

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



Taping Head Assemblies – AccuGlide™ II STD 2 Inch

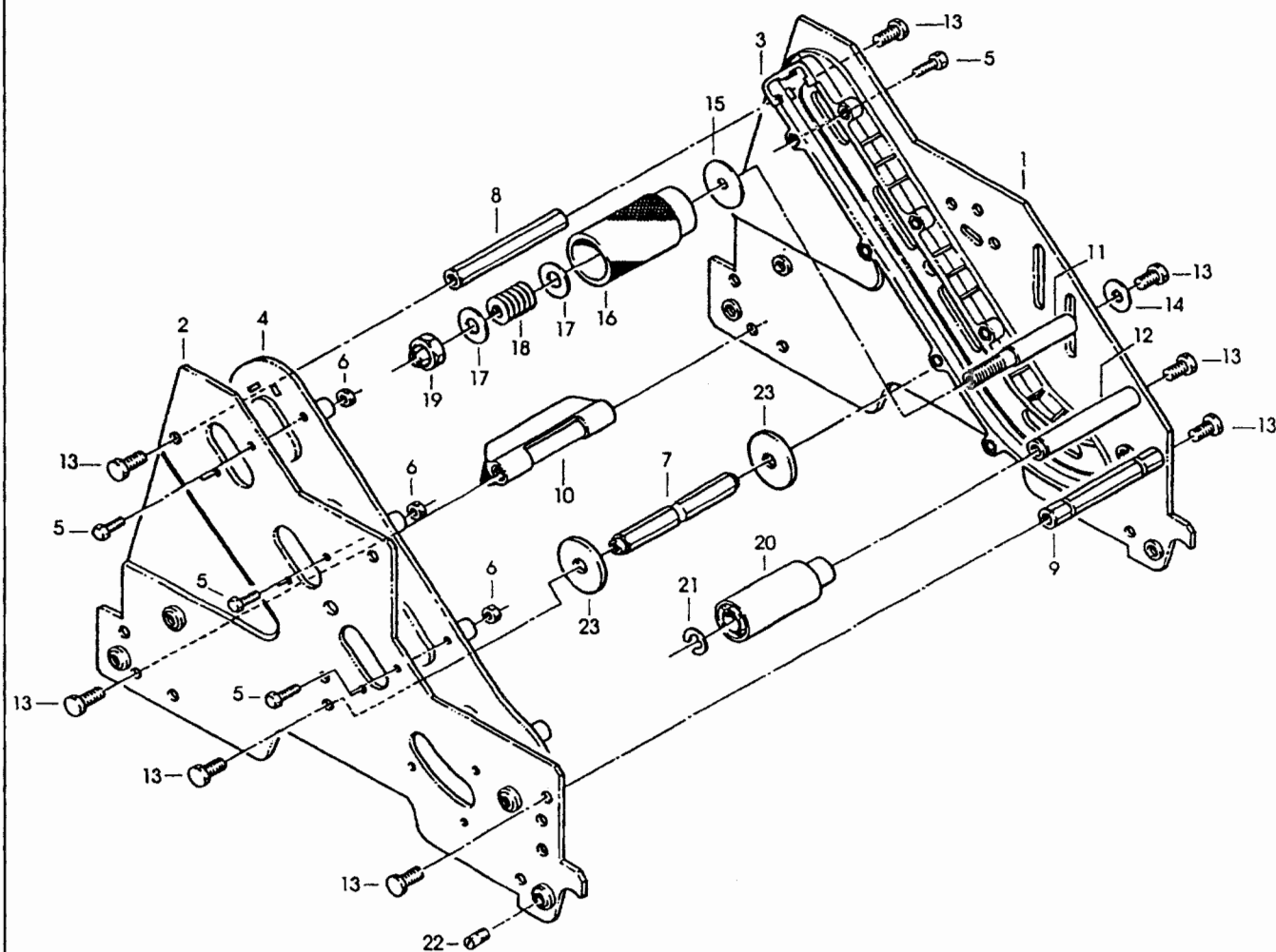


Figure 2879 – Upper Head

Figure 2879 – Upper Head

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 – #1
2879-4	78-8068-4144-7	Guide – #2
2879-5	83-0002-7336-3	Screw – Hex Hd, M4 x 14
2879-6	78-8010-7416-8	Nut – Hex Jam, 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	26-1003-5829-5	Screw – Hex Hd, M6 x 12
2879-14	26-1000-0010-3	Washer – Plain, 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, Tru-Arc #1-420-0120-100
2879-22	78-8076-4500-3	Stud – Mounting
2879-23	78-8076-5242-1	Stop – Cut-Off Frame

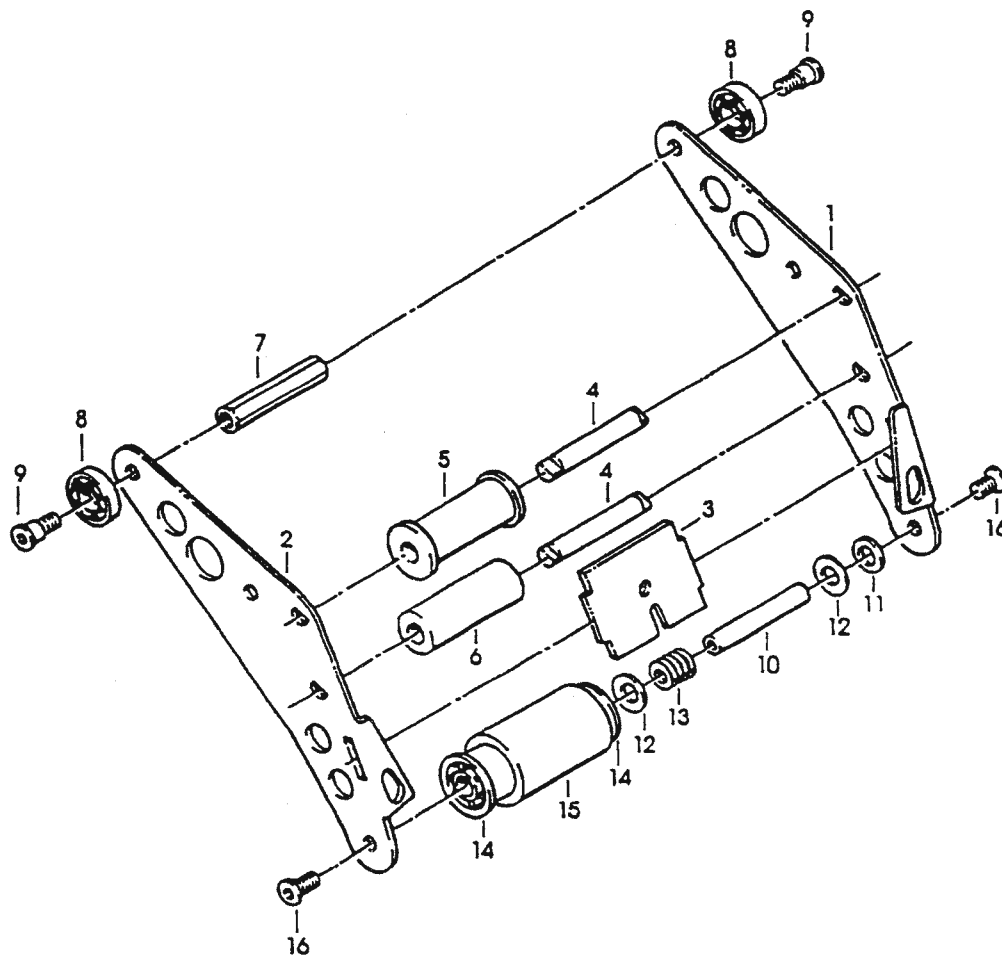


Figure 2880 – Upper and Lower Heads

Figure 2880 – Upper and Lower Heads

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
2880-16	26-1005-4759-0	Screw – Flat Hd, M6 x 12

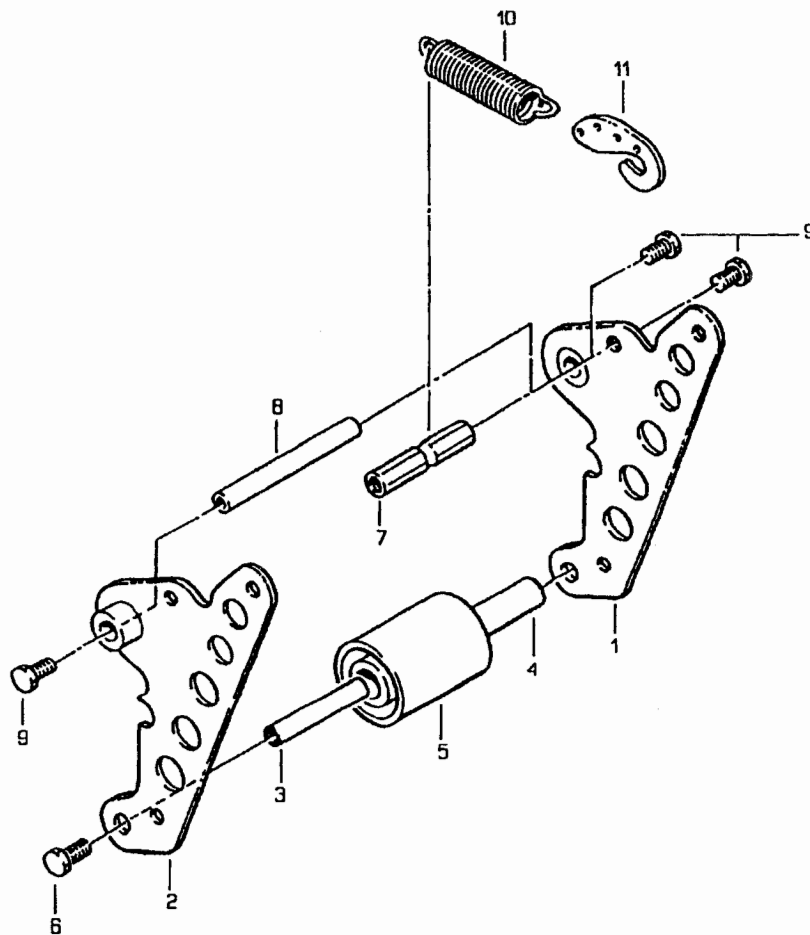


Figure 2881 – Upper Head

Figure 2881 – Upper Head

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
2881-6	26-1003-5828-7	Screw – Hex Hd, M6 x 10
2881-7	78-8070-1220-4	Spacer – Spring
2881-8	78-8017-9109-2	Shaft – 10 x 90 mm
2881-9	26-1003-5829-5	Screw – Hex Hd, M6 x 12
2881-10	78-8070-1274-1	Spring – Upper (Silver)
2881-11	78-8070-1244-4	Holder – Spring

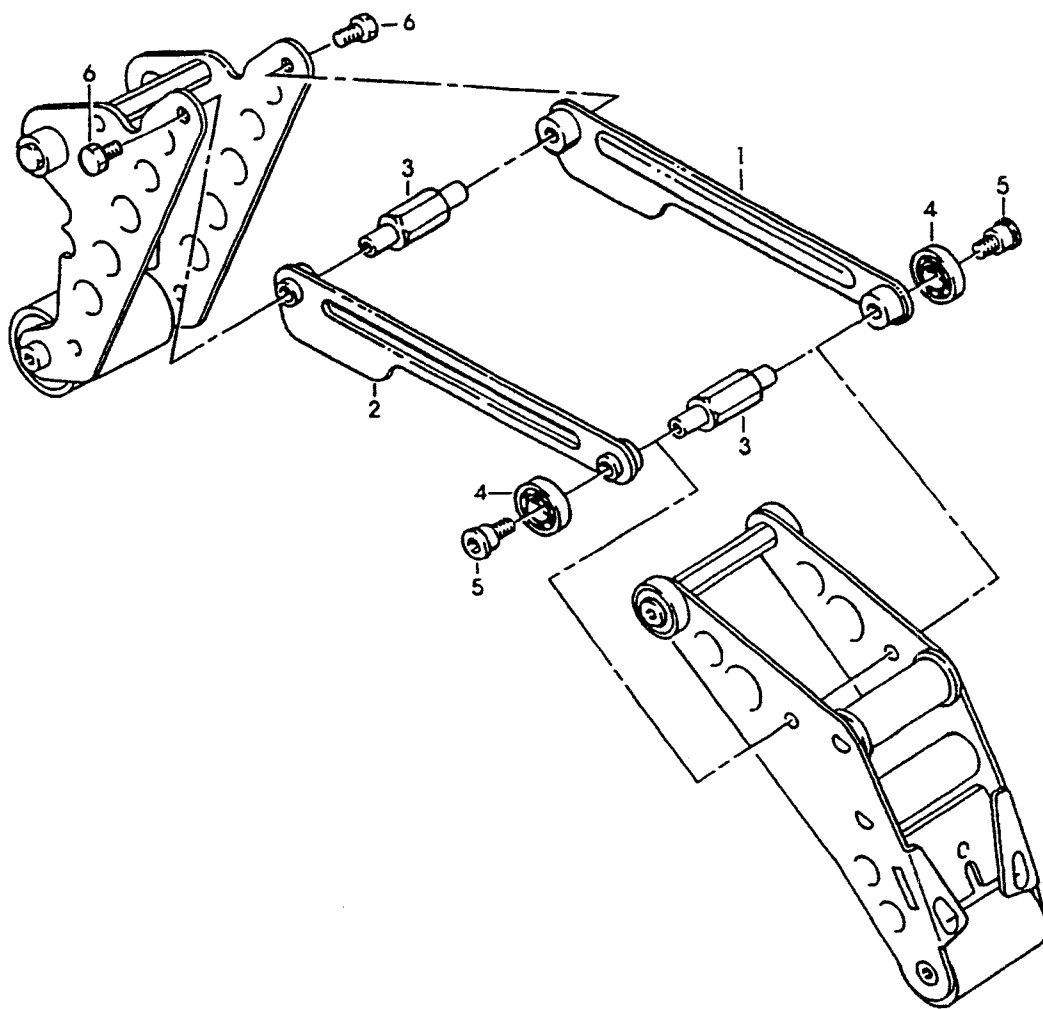


Figure 2882 – Upper and Lower Heads

Figure 2882 – Upper and Lower Heads

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	26-1003-5829-5	Screw – Hex Hd, M6 x 12

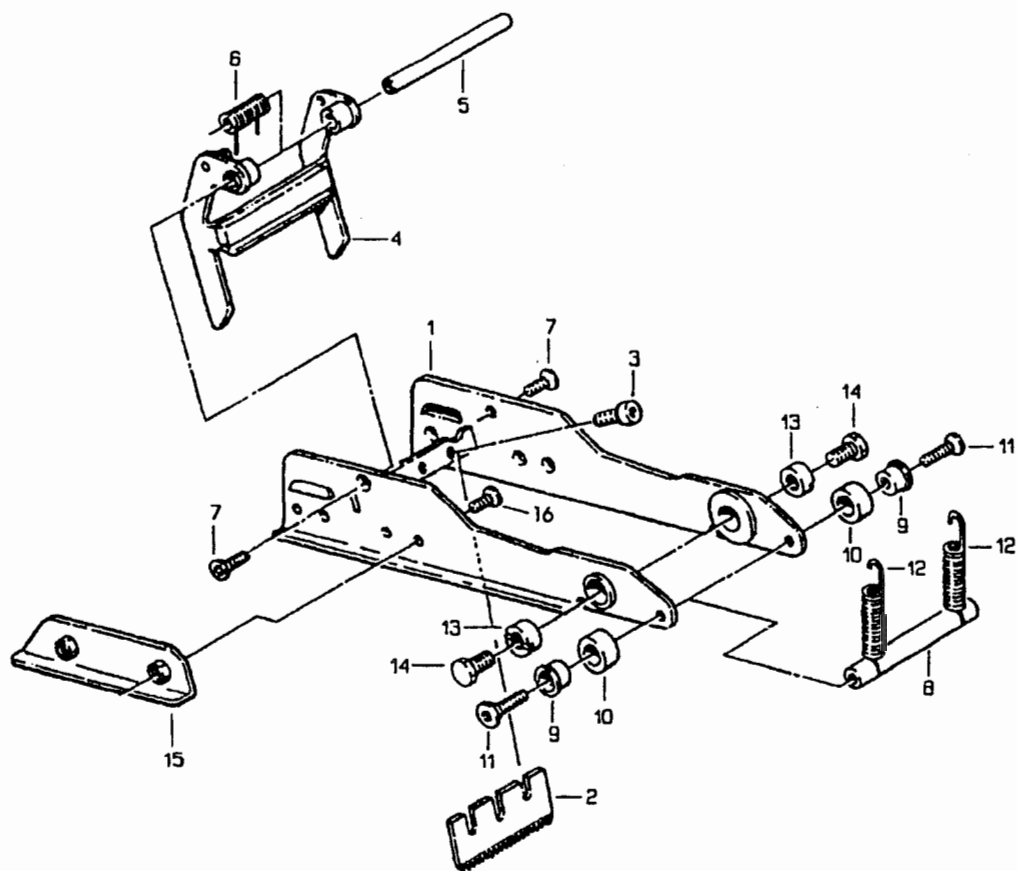


Figure 2883 – Upper and Lower Heads

Figure 2883 – Upper and Lower Heads

Ref. No.	3M Part No.	Description
2883-1	78-8070-1217-0	Frame – Cut-Off Weldment
2883-2	78-8017-9173-8	Blade – 65 mm/2.56 Inch
2883-3	26-1002-5817-2	Screw – Hex Hd, M5 x 8
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 – Torsion
2883-7	26-1005-4758-2	Screw – Flat Hd, Soc Dr, M4 x 10
2883-8	78-8017-9135-7	Shaft – Spacer
2883-9	78-8052-6600-0	Spacer
2883-10	78-8070-1269-1	Bumper
2883-11	26-1005-4757-4	Screw – Flat Hd, Soc Dr, 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 – Spec, Hex Hd, M6 x 10
2883-15	78-8070-1216-2	Slide – Extension
2883-16	26-1008-6574-5	Screw – Flat Hd, Phil Dr, M4 x 10

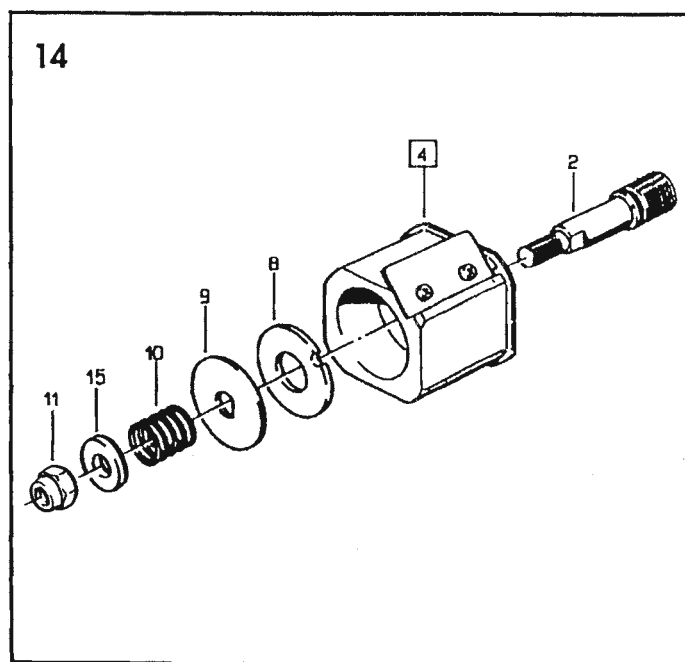
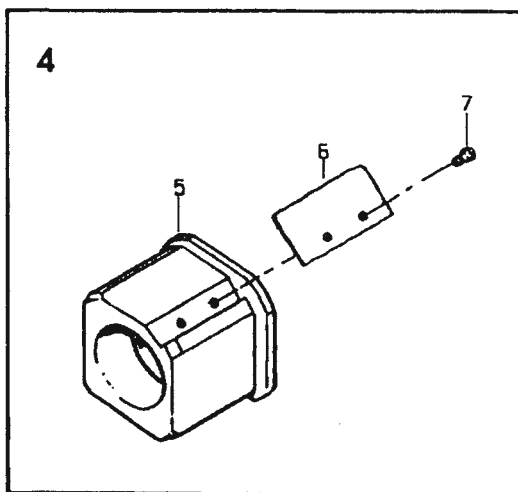
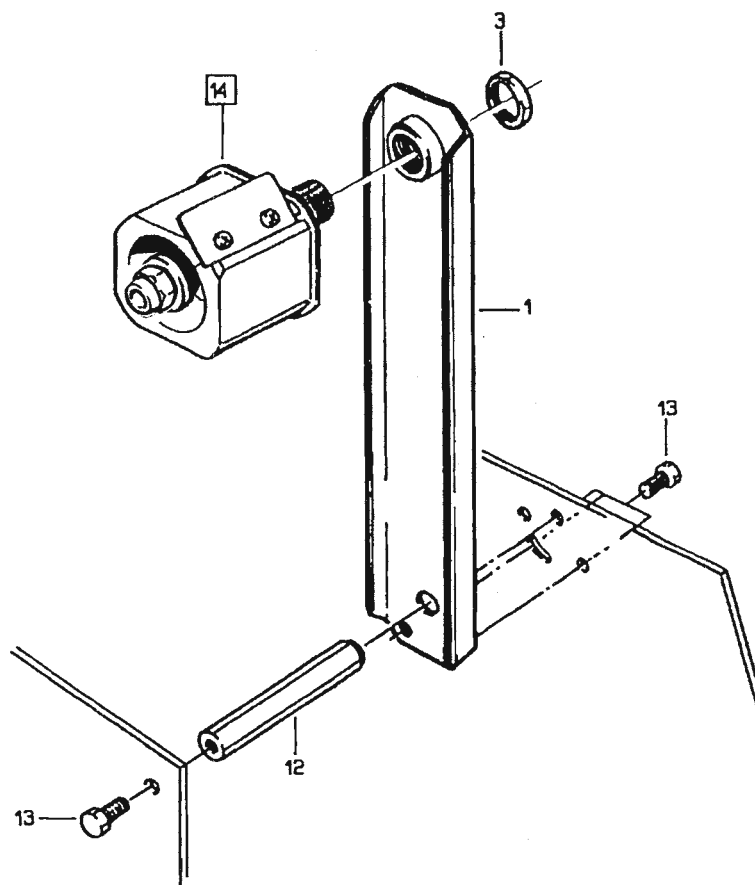


Figure 2884 – Upper and Lower Heads

Figure 2884 – Upper and Lower Heads

Ref. No.	3M Part No.	Description
2884-1	78-8070-1395-4	Bracket – Bushing Assembly
2884-2	78-8076-4519-3	Shaft – Tape Drum, 50 mm
2884-3	78-8017-9169-6	Nut – M18 x 1
2884-4	78-8070-1569-4	Tape Drum Sub Assembly
2884-5	78-8052-6749-5	Tape Drum
2884-6	78-8052-6268-6	Leaf Spring
2884-7	26-1002-5753-9	Screw – Self Tapping
2884-8	78-8060-8172-1	Washer – Friction
2884-9	78-8052-6271-0	Washer – Tape Drum
2884-10	78-8054-8826-5	Spring
2884-11	78-8017-9077-1	Nut – Self Locking, M10 x 1
2884-12	78-8070-1215-4	Spacer – Stud
2884-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
2884-14	78-8060-8474-1	Tape Drum Assembly
2884-15	26-1004-5510-9	Washer – Plain, M10

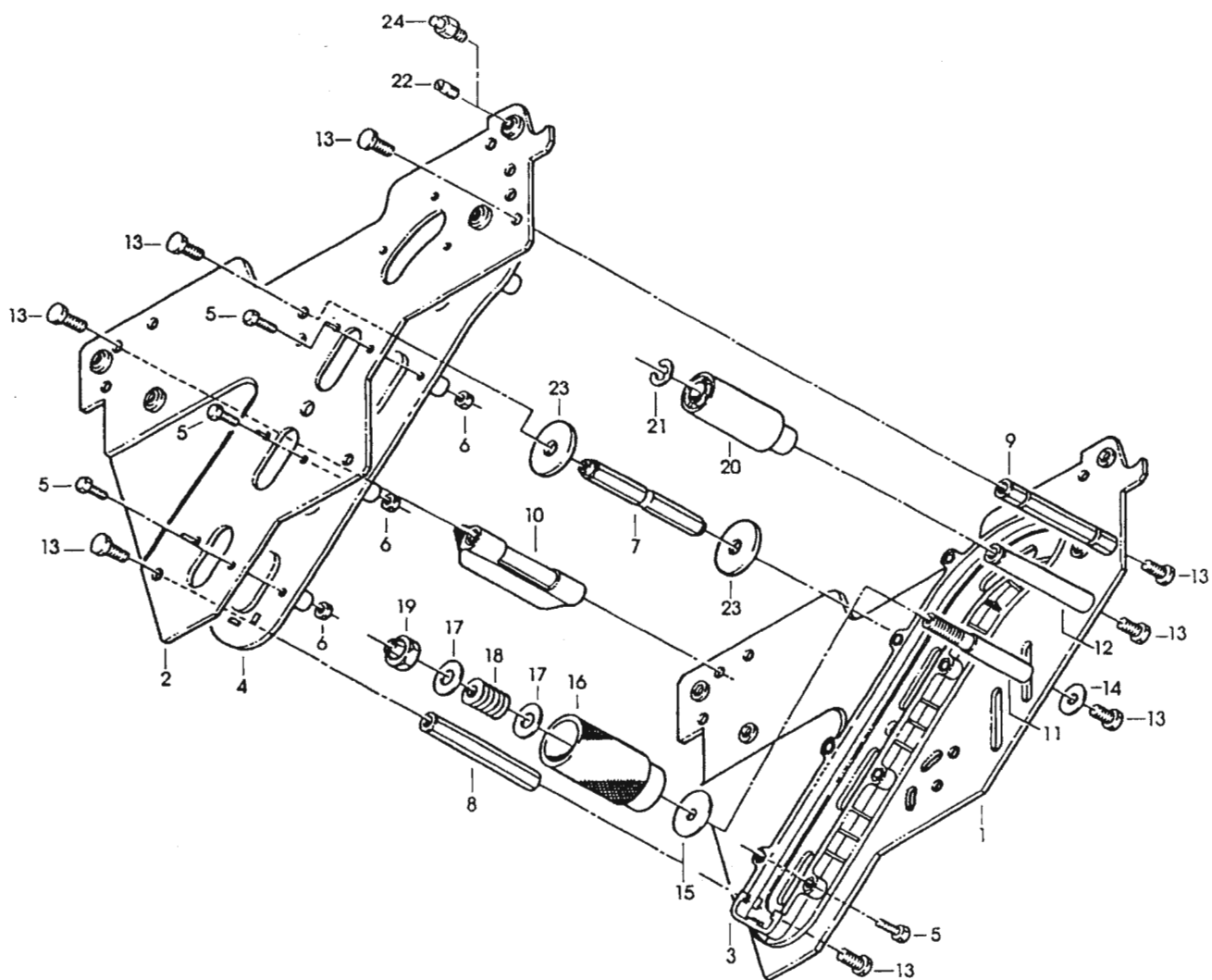


Figure 2885 – Lower Head

Figure 2885 – Lower Head

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 – #2
2885-4	78-8068-4143-9	Guide – #1
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	26-1003-5829-5	Screw – Hex Hd, M6 x 12
2885-14	26-1000-0010-3	Washer – Plain, 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, Tru-Arc #1-420-0120-100
2885-22	78-8076-4500-3	Stud – Mounting
2885-23	78-8076-5242-1	Stop – Cut-Off Frame
2885-24	78-8076-4991-4	Spacer

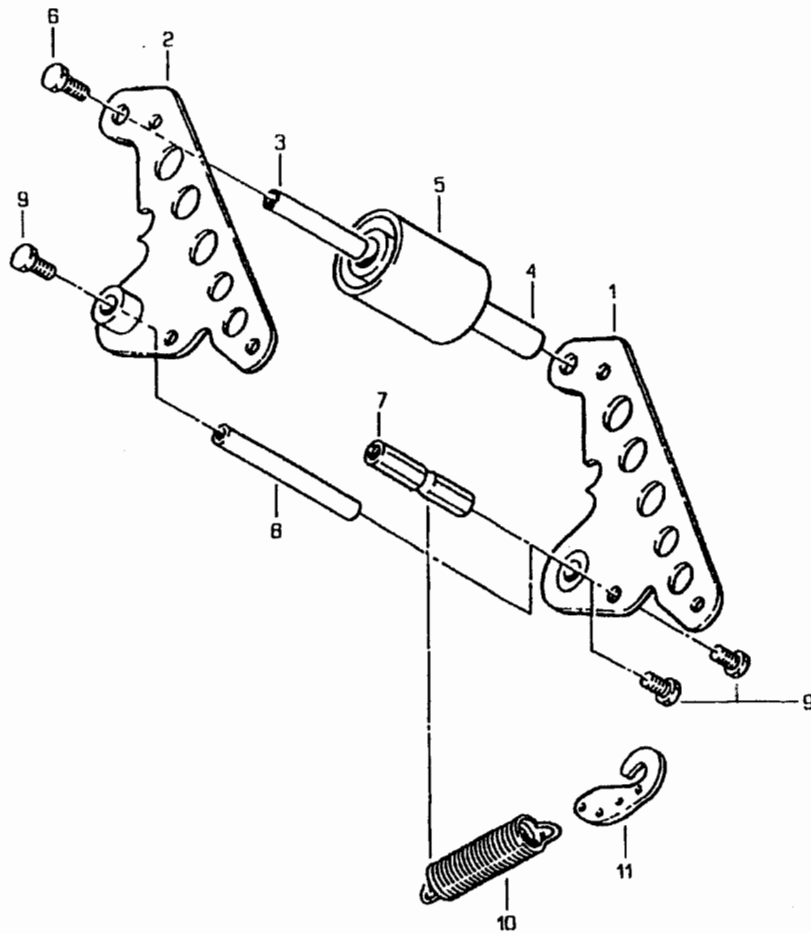


Figure 2886 – Lower Head

Figure 2886 – Lower Head

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
2886-6	26-1003-5828-7	Screw – Hex Hd, M6 x 12
2886-7	78-8070-1220-4	Spacer – Spring
2886-8	78-8017-9109-2	Shaft – 10 x 90 mm
2886-9	26-1003-5829-5	Screw – Hex Hd, M6 x 12
2886-10	78-8070-1273-3	Spring – Lower (Black)
2886-11	78-8070-1244-4	Holder – Spring

