



Instructions and Parts List

AccuGlide™

HST (Upper)

HST (Lower)

Taping Heads

Type 39100



Important Safeguards

Turn to page four for operating safety information.

Important

It is recommended you immediately order the spare parts listed on page 21. These parts are expected to wear through normal use, and should be kept on hand to minimize production delays.

Rev # is F106.05 here, but it is E79.0 on the following page, and it is D79.0 on the page after that.

3M Masking and Packaging Systems Division

3M Center Bldg. 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 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.

is this page and the following page
redundant? they seem very similar



3M Packaging Systems Division

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St. Paul, MN 55144-1000

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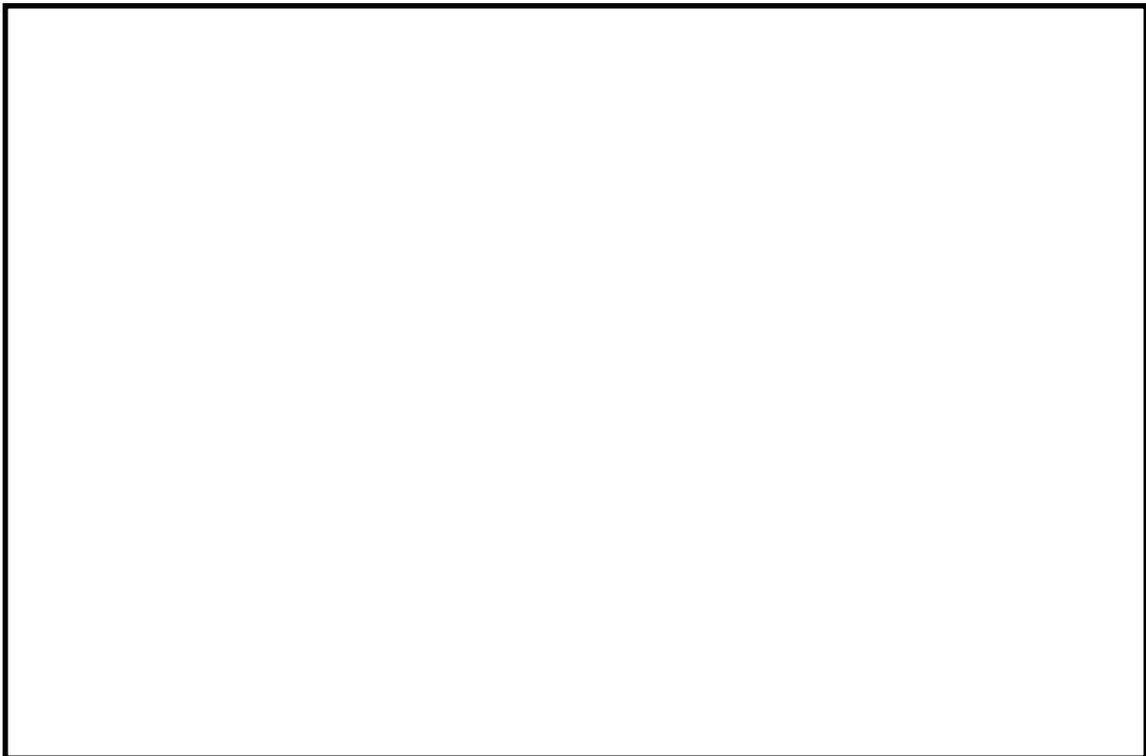
To Our Customers:

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.



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Instruction Manual

HST Taping Head (Upper)
HST Taping Head (Lower)
Type 39100

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Taping Head Contents

HST Taping Head (Upper)

Consists Of:

Qty.	Part Name
1	Taping Head Assembly
1	Tape Drum and Bracket Assembly
1	Blade – 2.5 inch [64,5 mm] Lg. (Spare)
1	Compression Spring (Upper taping head for side mounting – see page 9)

HST Taping Head (Lower)

Consists Of:

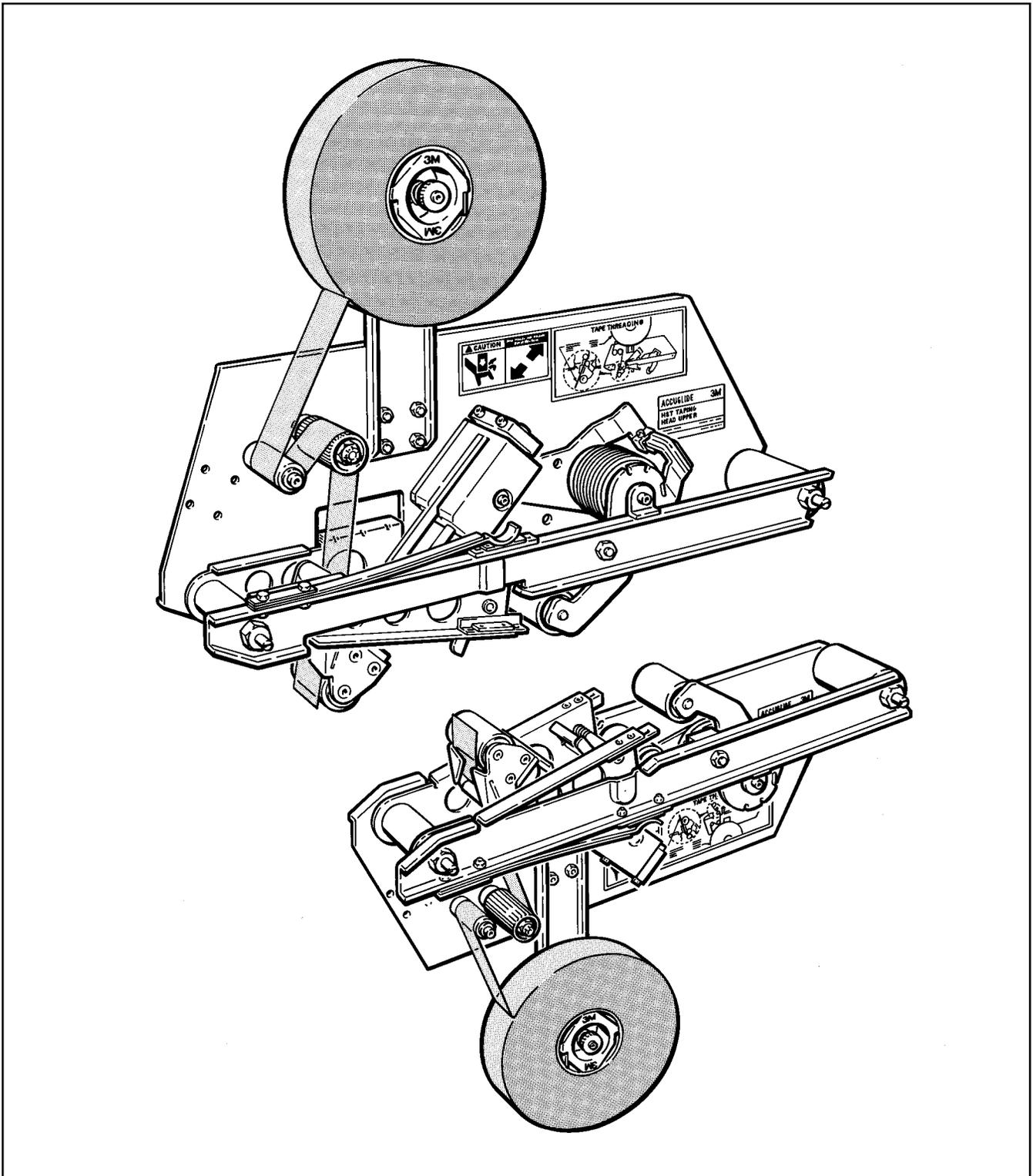
Qty.	Part Name
1	Taping Head Assembly
1	Tape Drum and Bracket Assembly
1	Blade – 2.5 inch [64,5 mm] Lg. (Spare)

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 warrants that its **AccuGlide™ HST Taping Heads, (Upper and Lower), Type 39100** will be free from defects for ninety (90) days after delivery. If any part is proved to be defective within the 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 parts 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.



AccuGlide™ HST Taping Heads (Upper and Lower), Type 39100

Description

The **AccuGlide™** HST Taping Heads (Upper and Lower) were designed to replace taping, gluing, and stapling heads in existing Case Sealing Machines.

These high-speed heavy duty heads apply a “C” clip of **Scotch™** brand pressure-sensitive film box sealing tape to the top and/or bottom center seam of regular slotted containers at speeds up to 150 ft./min. [45,7 m/min.].

Important Safeguards

Both the upper and lower taping heads have important safeguards listed below, that every person who operates and/or maintains the heads should be familiar with.

1-1 The “**Warning – Sharp Knife**” label is used on each head to warn operators and service personnel of the extremely sharp blades used to cut the tape at the end of the box sealing operation. The label shown in Figure 1-1 is located on the blade guard assembly between the applying roller assembly and the buffing roller assembly. Before working with the tape heads or attempting to load the tape, refer to Figures 4-1 and 4-2 and identify the knife blade location. Keeps hands out of these areas except as necessary to service the taping heads.



Figure 1-1 – Knife Warning Label

1-2 The “**Caution – Keep Hands Out of This Area**” labels, shown in Figure 1-2 is attached to the frame and located behind the slide mechanism. The top label is for the upper head, and the bottom label is for the lower head. This warns operators to keep hands and objects out of this area when the taping head mechanism is in operation.

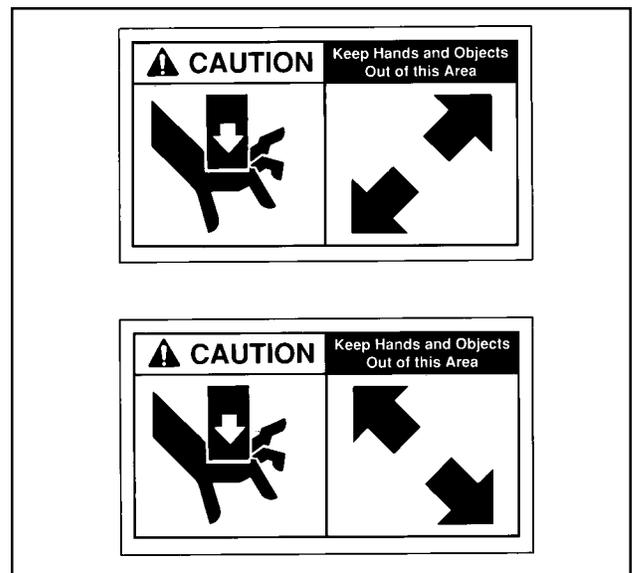


Figure 1-2 – Hand Caution Label

1-3 The “**Tape Threading**” labels, shown in Figure 1-3, are attached to the right side of the frame on both the upper and lower taping heads. The top label is for the upper head, and the bottom label is for the lower head. These labels provide a convenient tape threading diagram. More detailed tape loading and threading information is provided in this manual in the set-up procedure section.

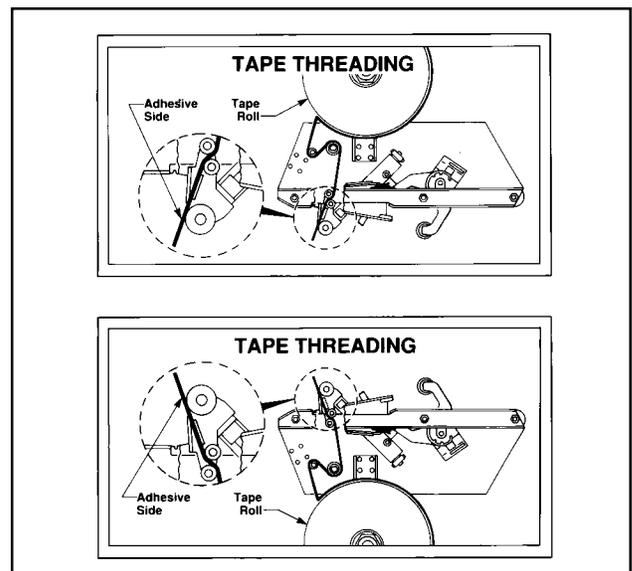


Figure 1-3 – Tape Threading Label

1-4 The taping heads are equipped with an orange blade guard that covers the blade. The taping head should never be operated with the blade guard removed.

1-5 Turn air and electrical supplies off before servicing the taping heads.

1-6 The taping heads should not be washed down or subjected to conditions causing moisture condensation on components.

Specifications

These specifications apply to all **HST Upper** and **Lower** taping heads except where noted.

1. **Tape:**

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

2. **Tape Width:**

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

3. **Tape Roll Diameter:**

Position A – 15 inches [380 mm] maximum on a 3 inch [76,2 mm] diameter core.

Position B – 18 inches [460 mm] maximum on a 3 inch [76,2 mm] diameter core.

(Accommodates all system roll lengths of **Scotch™** brand film tapes.)

NOTE: The tape roll diameter capacity may be less on some equipment installations due to space limitations.

4. **Tape Application Leg Length:**

2 3/4 inches ±1/4 inch [70 mm ± 6 mm]

5. **Box Size Capacities:**

For use with center seam regular slotted containers.

	Minimum	Maximum
Length	– 6 inches [150 mm]	Unlimited
Height	– 4 inches [100 mm]	Unlimited
Width	– 5 inches [130 mm]	Unlimited

6. **Operating Conditions:**

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

IMPORTANT SAFEGUARD

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

7. **Taping Head Dimensions:**

Length	– 25.3 inches [645 mm]
Height	– 18.5 inches [470 mm]
Width	– 5.90 inches [150 mm]
Weight	– Packaged: 33 lbs. [14,8 kg] Unpackaged: 28 lbs. [12,6 kg]

Installation

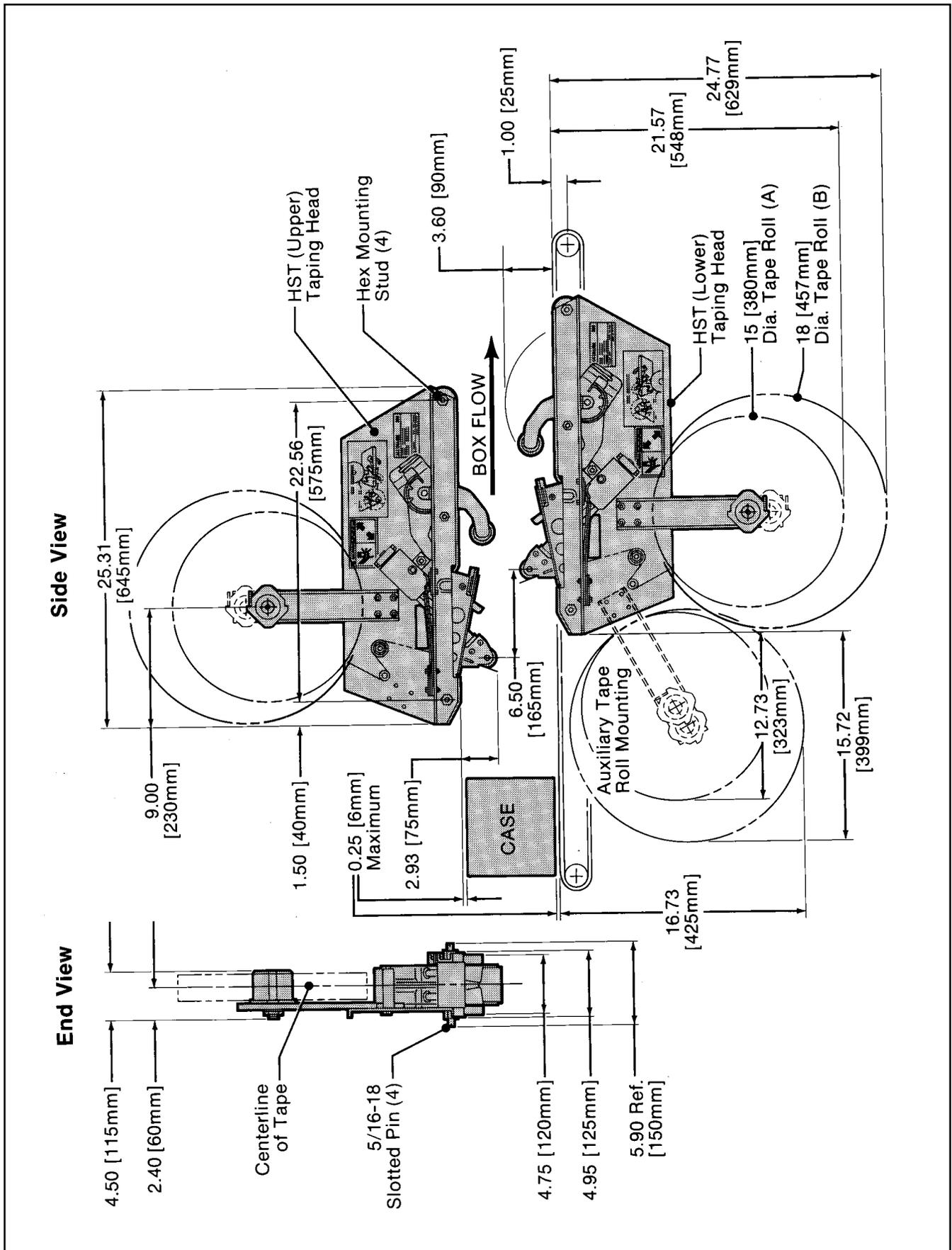


Figure 2-1 – Taping Head Assemblies – Typical Mounting Dimensions

Installation (Continued)

IMPORTANT SAFEGUARDS

BOTH THE UPPER AND LOWER TAPING HEADS UTILIZE EXTREMELY SHARP KNIFE BLADES. THE BLADES ARE LOCATED UNDER THE ORANGE BLADE GUARD WHICH HAS THE “WARNING - SHARP KNIFE” LABEL. BEFORE WORKING WITH THE TAPING HEADS OR ATTEMPTING TO LOAD THE TAPE, REFER TO FIGURES 4-1 AND 4-2 AND IDENTIFY THE BLADE LOCATION. KEEP HANDS OUT OF THESE AREAS EXCEPT AS NECESSARY TO SERVICE THE TAPING HEADS.

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 your 3M Representative.

The taping heads can be used to replace existing or custom made machinery. It can be mounted for top taping or bottom taping. Refer to box size specifications on page 5 and Figure 2-1 on page 6, for the following points in making such installations:

1. The case conveying system must positively propel the case in a continuous motion, **not exceeding 150 feet per minute** [45,7 m/min.], past the taping head assembly since the case 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 which may result in damage to the taping head**. If this is not possible, contact 3M for assistance or suggested modifications that will provide adequate operating clearance to the taping head assembly.
3. Figure 2-1 illustrates the typical mounting relationship for opposing taping head assemblies to allow taping of case heights down to 5.4 inches [135 mm]. **To tape case heights down to 4 inches [100 mm], the taping head assemblies must be completely staggered so only one tape seal is being applied at one time.**
4. Four (4) mounting studs are provided on the taping head side plates but special installations may require alternate means for mounting.
5. The taping head assembly is provided with mounting holes **for mounting the tape drum bracket in two different locations**. Normal installation is in the center of the frame. For clearance problems, the front or axillary mounting can be used.

Upper Taping Head

Refer to Figure 2-1 for mounting dimensions.

1. Remove the (4) 5/16 - 18 slotted pins from the hex mounting studs.
2. Install and secure the taping head using the (4) 5/16 - 18 tapped holes available in the hex mounting studs.

Lower Taping Head

1. Install the taping head by lowering mounting pins into bed frame slots, or remove (4) 5/16 - 18 slotted pins and use 5/16 - 18 tapped holes in the hex mounting studs.

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Special Use Set-Up Instructions

HST Upper Taping Head – Compression Spring

Refer to Figure 3-1

⚠ WARNING – UPPER TAPING HEAD UTILIZES AN EXTREMELY SHARP KNIFE BLADE LOCATED UNDER THE ORANGE BLADE GUARD WHICH HAS THE “WARNING - SHARP KNIFE” LABEL. USE CARE WHEN WORKING NEAR BLADE. IF CARE IS NOT TAKEN, SEVERE INJURY TO PERSONNEL COULD RESULT.

A compression spring is packed in with the HST Upper Taping Head for use if the head is to be side mounted. Remove and retain stop block, bumper and fasteners. Remove applying roller assembly. Place compression spring on shaft and reassemble applying roller assembly and stop block.

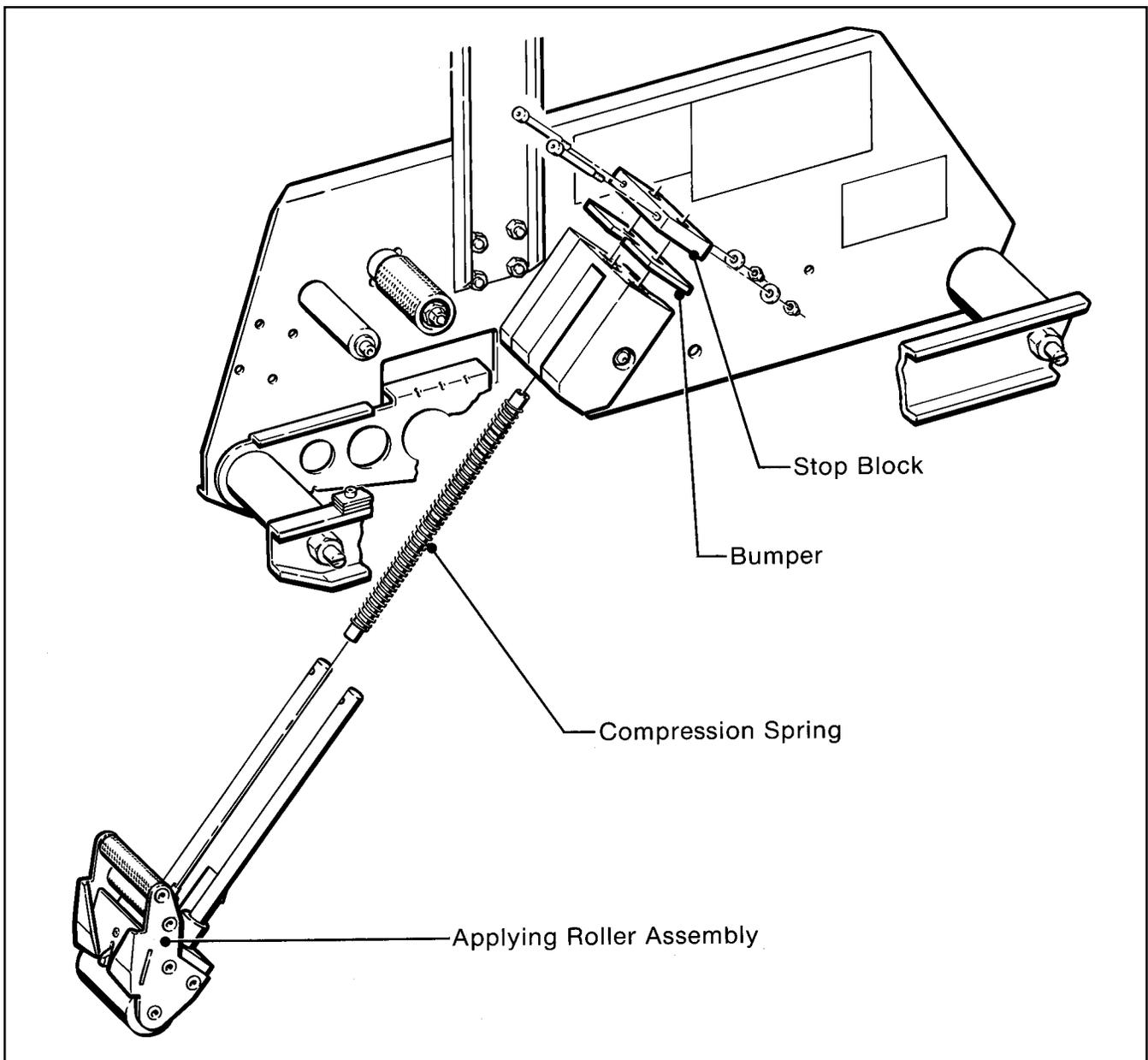


Figure 3-1 – Compression Spring Installation

Set-Up Procedure

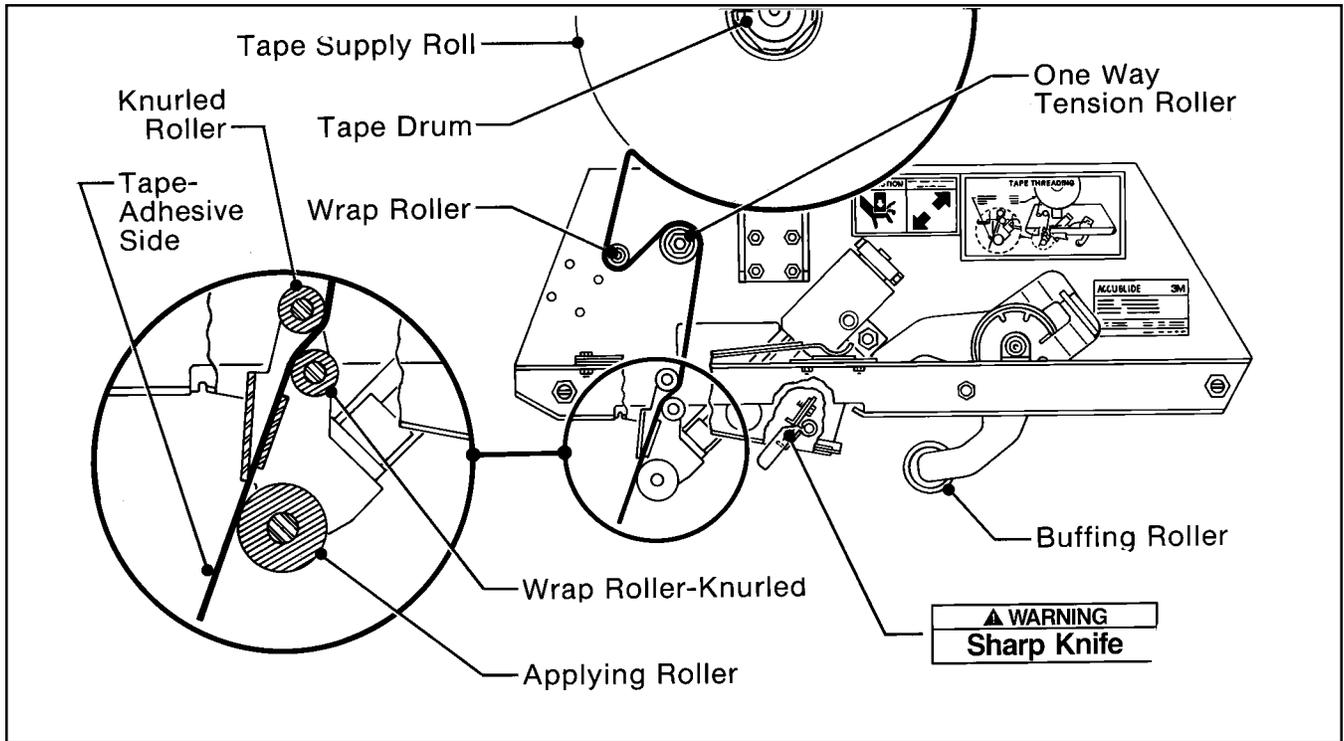


Figure 4-1 – Tape Threading Diagram – Upper Taping Head

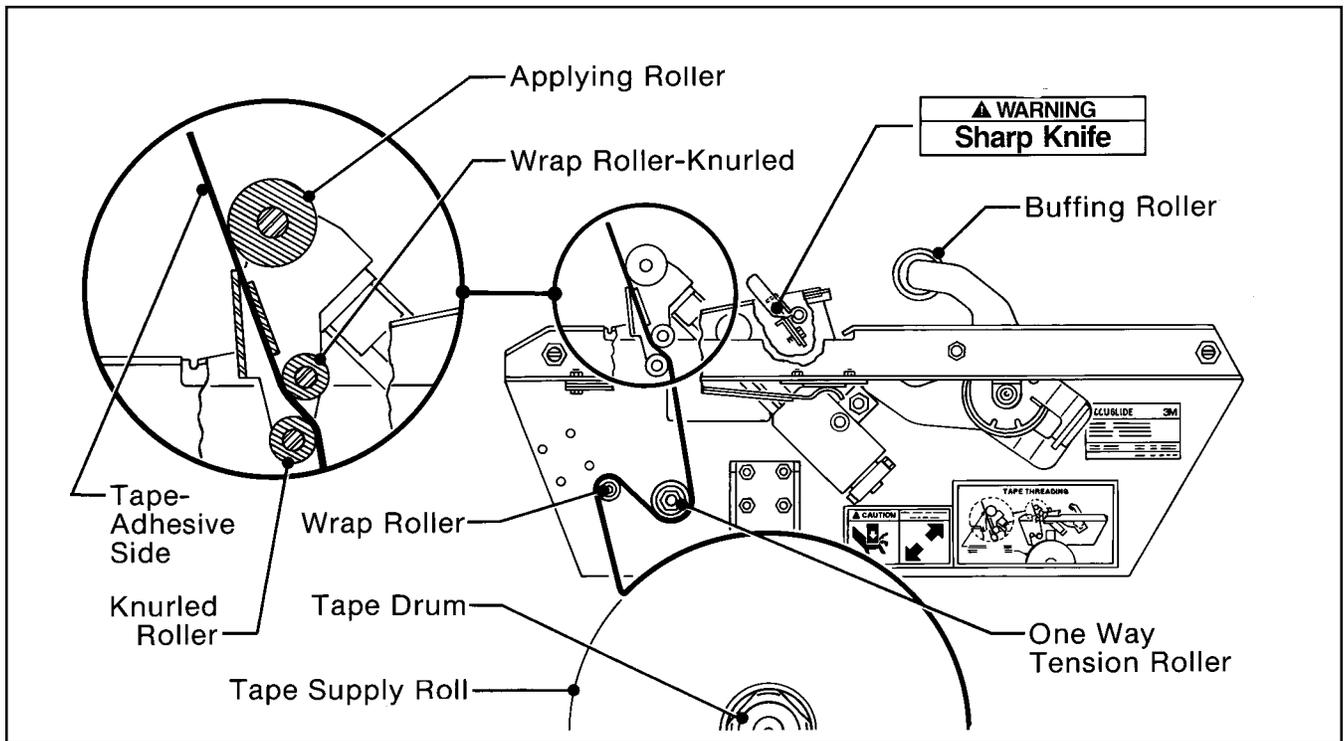


Figure 4-2 – Tape Threading Diagram – Lower Taping Head

Set-Up Procedure (Continued)

Tape Loading

The HST taping head accommodates up to 2 inch [50 mm] wide tape rolls.



WARNING

1. BOTH THE UPPER AND LOWER TAPING HEADS UTILIZE EXTREMELY SHARP KNIFE BLADES WHICH ARE LOCATED UNDER THE ORANGE BLADE GUARD WITH THE “WARNING –w SHARP KNIFE” LABEL. REFER TO FIGURE 4-1 AND 4-2 AND IDENTIFY THE BLADE LOCATIONS KEEP HANDS OUT OF THIS AREA EXCEPT AS NECESSARY TO SERVICE THE TAPING HEADS.
2. REFRAIN FROM MANUALLY PUSHING THE APPLYING ROLLER ARM INWARD AS THIS WILL PUT YOUR HAND IN MOTION TOWARDS THE TEETH OF THE SHARP KNIFE BLADE. WHEN NECESSARY TO MANUALLY ACTUATE THE TAPE APPLYING MECHANISM, TAKE CARE TO MAKE SURE THE BLADE GUARD STAYS IN PLACE TO PROVIDE MAXIMUM PROTECTION FOR YOUR HANDS FROM THE KNIFE BLADE TEETH.
3. NEVER ATTEMPT TO WORK ON THE TAPING HEADS OR LOAD TAPE WHEN THE CONVEYING SYSTEM IS RUNNING. PERSONNEL INJURY OR EQUIPMENT DAMAGE CAN POTENTIALLY RESULT.

Upper Taping Head

Refer to Figures 4-1 and 4-3

For tape loading operations, follow the loading procedures to complete the tape threading.

1. Place tape roll on drum to dispense tape from bottom of roll around one-way tension roller with tape adhesive side in as shown. Seat tape roll fully against back flange of drum.
2. Manually turn tape roll to create slack tape while threading tape through applying mechanism. Pull tape through until it is in alignment with applying roller.



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

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

Lower Taping Head

Refer to Figures 4-2 and 4-3

The lower taping head is loaded in the same manner as the upper taping head. Follow the upper taping head tape loading procedure to complete the tape threading.

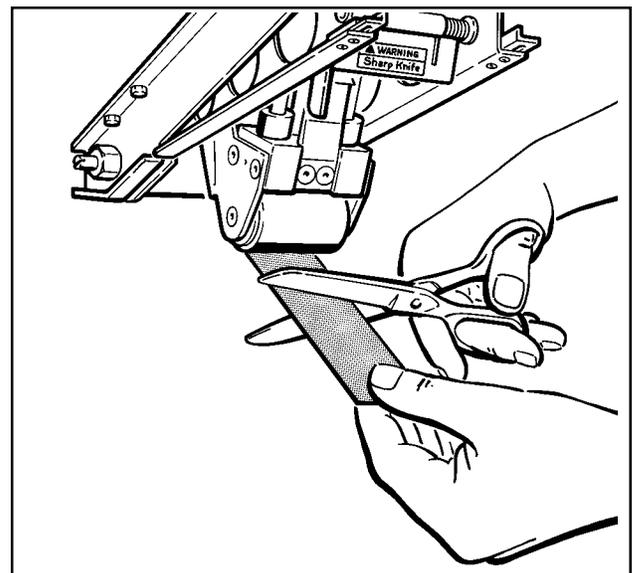


Figure 4-3 – Upper Taping Head – Left Rear View

Adjustments



WARNING – NEVER ATTEMPT TO WORK ON THE TAPING HEADS WHEN THE BOX DRIVE SYSTEM IS RUNNING. INJURY TO PERSONNEL OR EQUIPMENT DAMAGE CAN POTENTIALLY RESULT.

Tape Web Alignment

Refer to Figure 5-1

The HST tape drum assembly is pre-set to accommodate 2 inch [50 mm] 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 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.

Friction Brake

Refer to 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 knurled 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 to minimum tension that prevents excessive tape roll over travel.

NOTICE

Excess braking force will cause poor tape applications and lead to tape tabbing on the trailing tape leg.

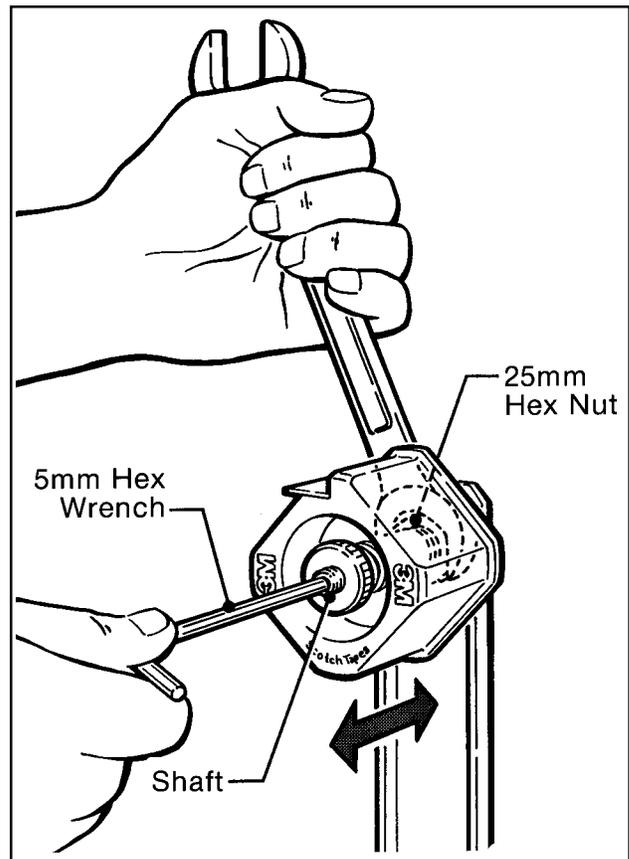


Figure 5-1 – Tape Drum Alignment

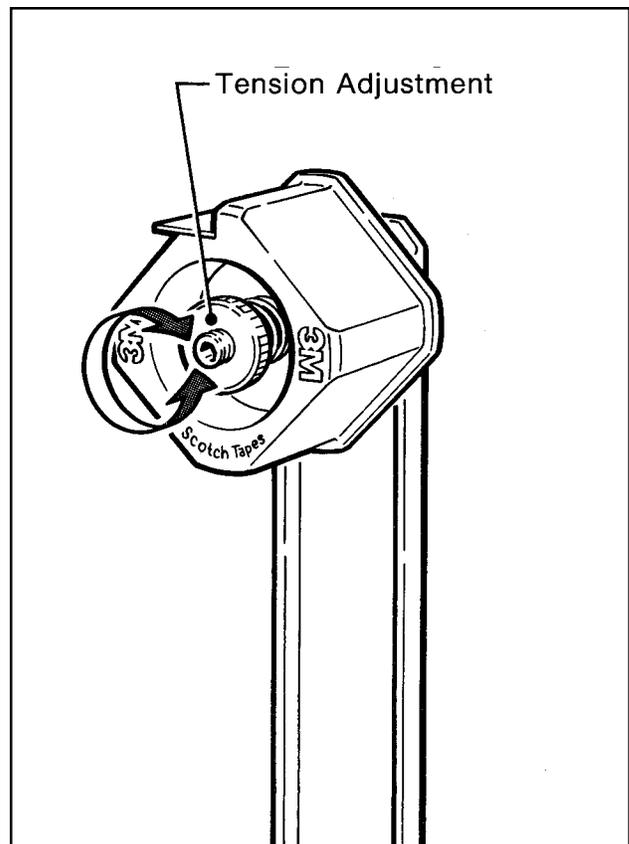


Figure 5-2 – Friction Brake

Adjustments (Continued)

Buffing Roller Spring Tension

Refer to Figures 5-3 and 5-4

WARNING – USE CARE WHEN WORKING ON BUFFING ROLLER ASSEMBLY AS SPRING IS UNDER TENSION. IF CARE IS NOT TAKEN PERSONNEL INJURY COULD RESULT.

The buffing roller spring controls the buffing roller pressure on the box and returns the assembly to the reset position. The spring tension is pre-set with the spring end loop in slot "C" for normal operation but is adjustable.

Should a tape loop appear on the trailing tape leg application, buffing roller pressure can be increased. With the buffing roller assembly in reset position, remove the spring end loop from slot "C" and place the loop in slot "B" or "A" to increase the spring tension. (Slot "A" will provide the greatest buffing roller pressure.)

Should lower buffing forces be required, remove the spring end loop from slot "C" and place in hole "D", "E" or "F" to lower the spring tension. (Hole "F" will provide the least buffing roller pressure.)

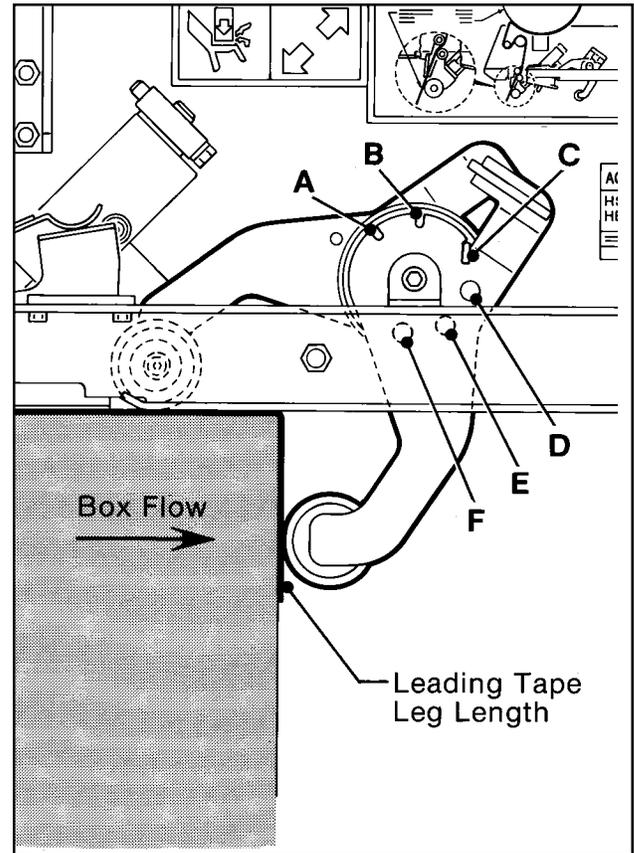


Figure 5-3 – Leading Buffing Roller

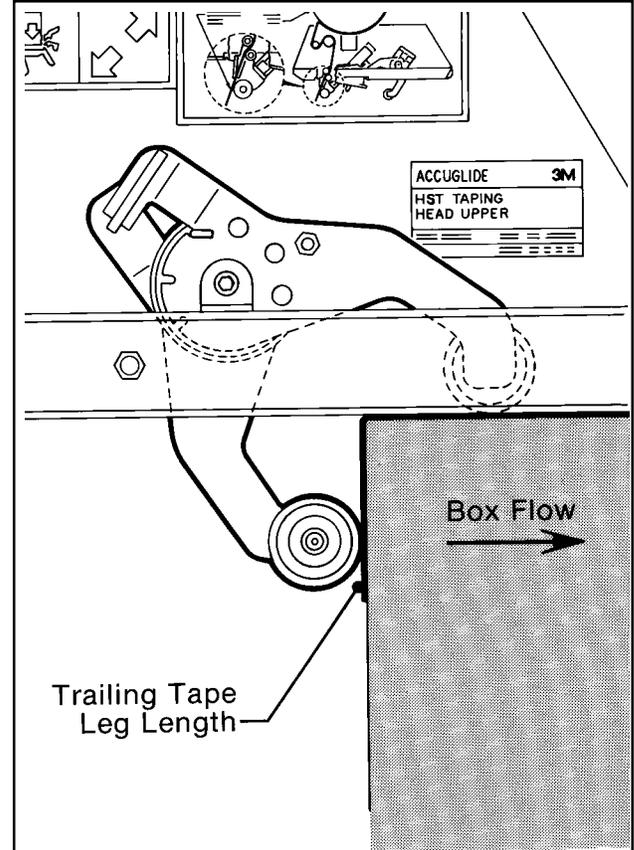


Figure 5-4 – Trailing Buffing Roller

Adjustments (Continued)

Tape Application Leg Length

Refer to Figure 5-5

The **conveyor speed**, at which the product moves through the taping heads, **affect** the leading and trailing **tape application leg length**.

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

The **one-way tension roller** position is adjustable to control the **leading tape leg length** and the “**L**” **brackets** adjustment **control** the **trailing tape leg length**.



WARNING – USE CARE WHEN WORKING ON BUFFING ROLLER ASSEMBLY AS SPRING IS UNDER TENSION. IF CARE IS NOT TAKEN PERSONNEL INJURY COULD RESULT.

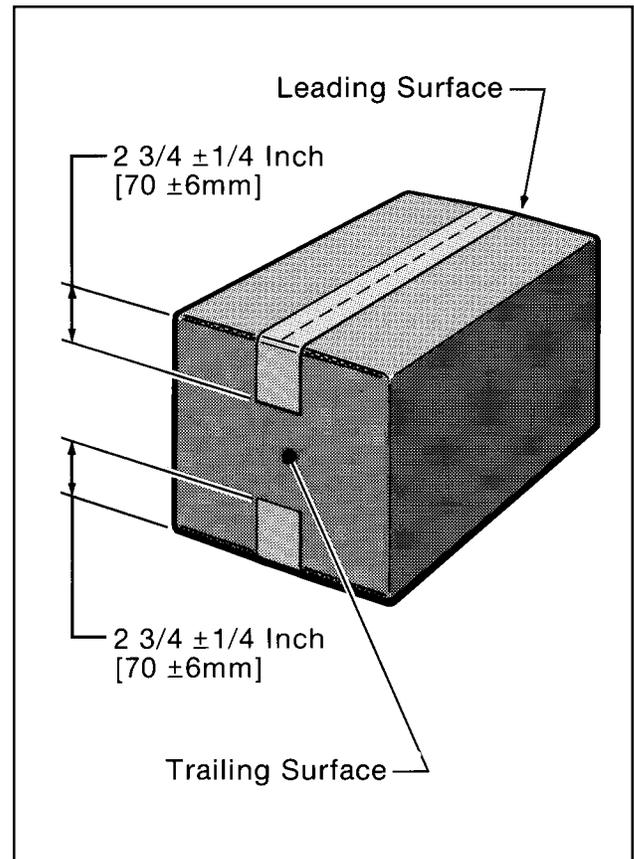


Figure 5-5 – Tape Application Leg Length

Leading Tape Leg Length

Refer to Figure 5-6

Adjust the **one-way tension roller** as needed to obtain the proper leading tape leg length.

Trailing Tape Leg Length

Refer to Figure 5-6

Adjust the “**L**” **brackets** as needed to obtain the proper trailing tape leg length.

The **lower** taping head adjustments are the **same** as the **upper** taping head adjustments.

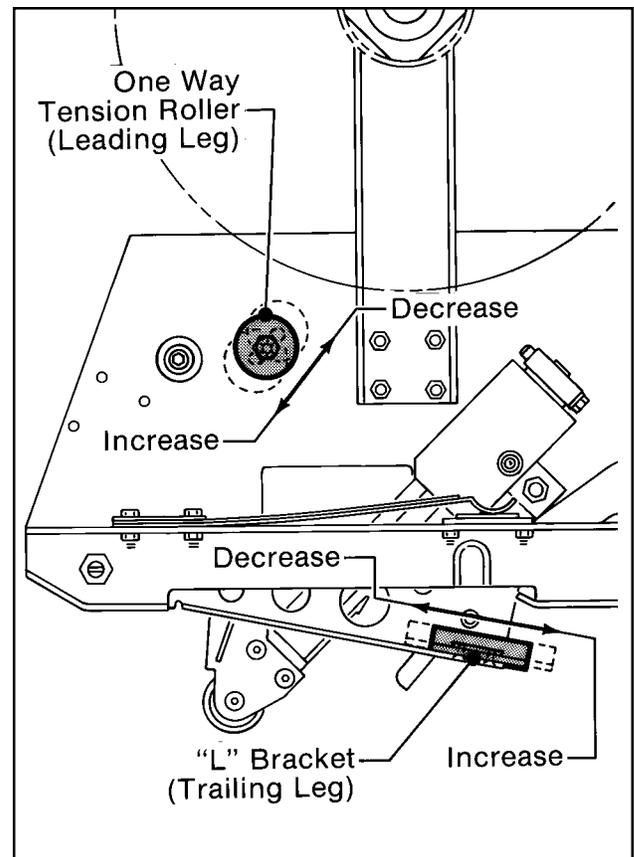


Figure 5-6 – Adjusting Tape Leg Length

Adjustments (Continued)

One Way Tension Roller Assembly

Refer to Figure 5-7

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

To Set Tension

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

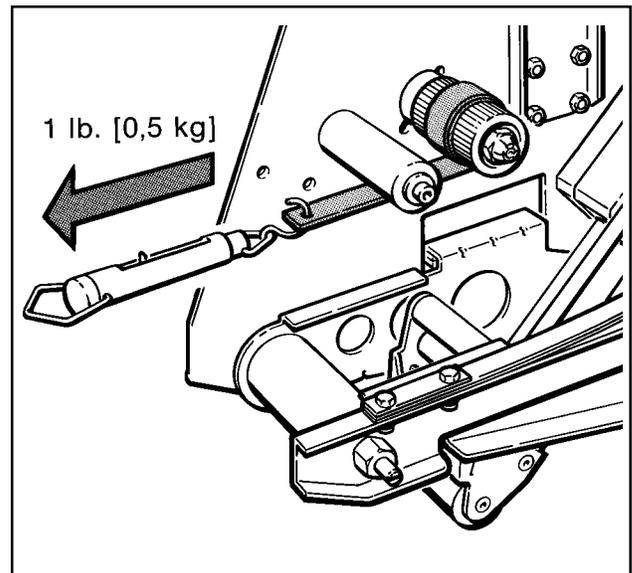


Figure 5-7 – One Way Tension Roller

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Maintenance

The taping heads have 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.



WARNING – TURN OFF CONVEYING SYSTEM ELECTRICAL POWER SUPPLY BEFORE BEGINNING MAINTENANCE. IF ELECTRICAL POWER IS NOT TURNED OFF, SEVERE INJURY TO PERSONNEL COULD RESULT. USE CARE WHEN REPLACING BLADES AS BLADES ARE EXTREMELY SHARP. IF CARE IS NOT TAKEN, SEVERE INJURY TO PERSONNEL COULD RESULT.

Cleaning Of The Taping Heads



CAUTION – 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, AND 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.

Regular slotted containers produce a great deal of dust and paper chips when conveyed through the taping heads. If this dust is allowed to build-up on the heads, it can cause wear on the moving components. 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.

Cut-Off Blade

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

Blade Oiler Pad

The taping heads are equipped with a blade oiler pad to provide a film of oil on the cut-off blade to reduce adhesive build-up. **Saturate oiler pad with SAE #30 non-detergent oil.** The blade oiler pad will become worn during normal operation. Replace the blade oiler pad when the felt is worn.

Maintenance (Continued)

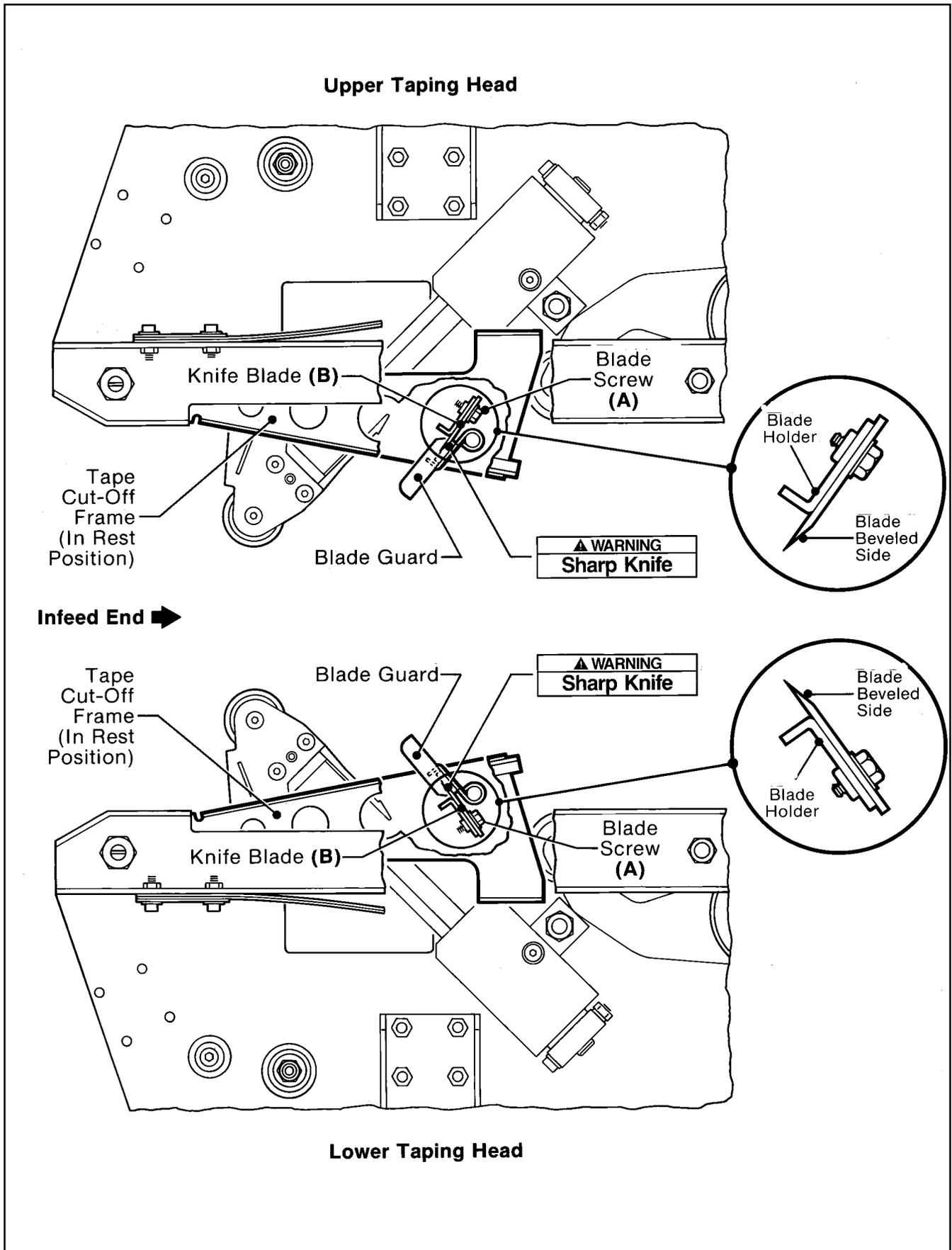


Figure 6-1 – Blade Replacement

Maintenance (Continued)



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

Blade Replacement

Refer to Figure 6-1

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

NOTICE

1. **Check the blade position to insure proper clearance by slowly pivoting the blade guard back.**
2. **If tape does not cut or has ragged cut re-adjust blade position away from blade holder.**

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

Maintenance (Continued)

Lubrication

Refer to Figure 6-2

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

Figure 6-2 illustrates points which **should be lubricated every 250 hours of operation**. Lubricate the rotating and pivoting points noted by the arrows (→) with **SAE #30 non-detergent oil**. At the same time, a small amount of multipurpose grease should be applied to the guides and to the end of each spring where the loop is secured at an eyelet, post, or hole noted by arrows (⇨).

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

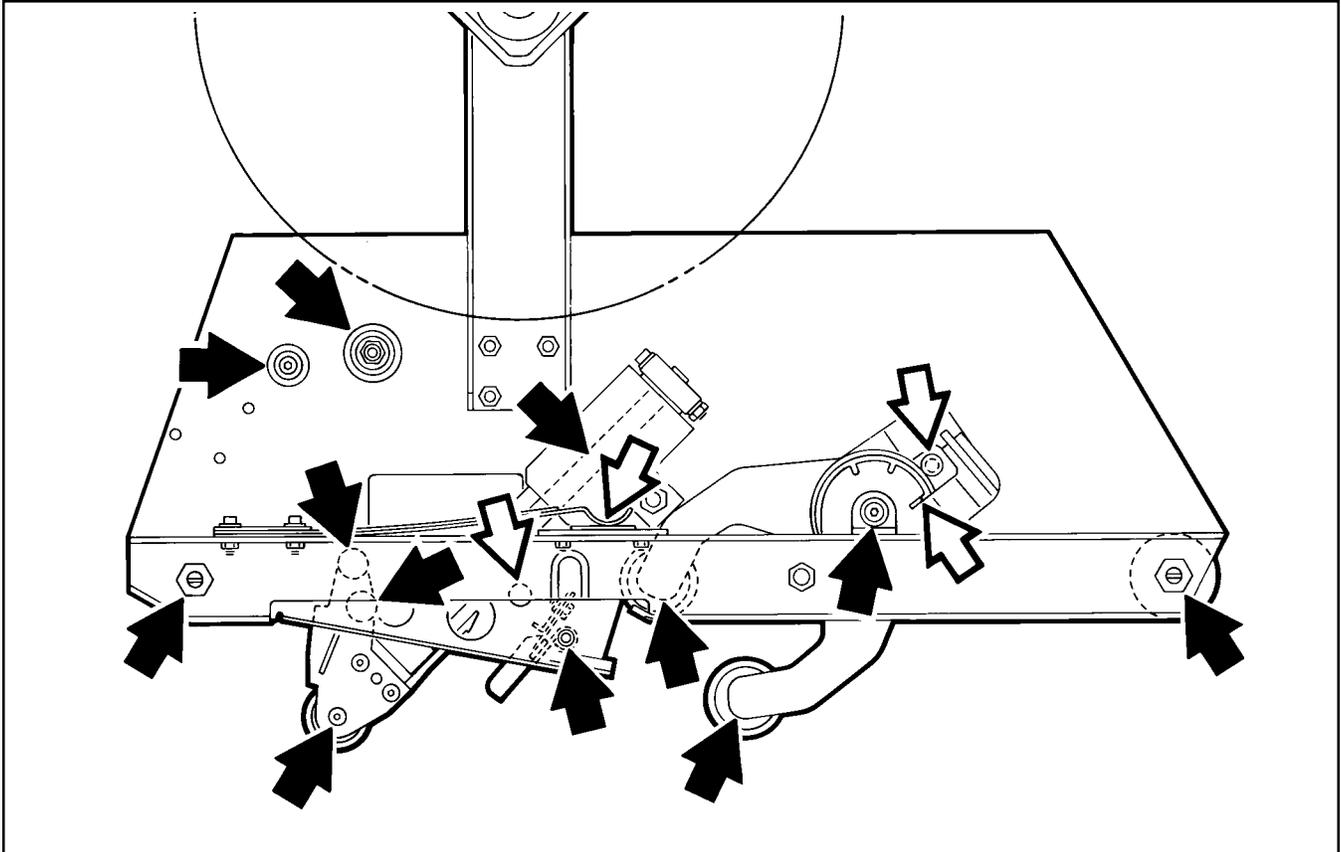


Figure 6-2 – Lubrication

Replacement Parts And Service Information

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 as consumed to keep the taping heads in production:

HST Taping Heads (Upper and Lower)

Qty.	Fig./Ref. No.	Part Number	Description
1	9/10	78-8070-1431-7	Blade - 2.50 Inch [64,5 mm]

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

HST Taping Head (Upper and Lower)

Qty.	Fig./Ref. No.	Part Number	Description
1	8/11	78-8057-5703-2	Spring - Latch
1	10/5	78-8015-7213-8	Spring - Torsion Inner Lower
1	10/5	78-8068-3940-9	Spring - Torsion Inner Upper
1	10/6	78-8015-7214-6	Spring - Torsion Outer Lower
1	10/6	78-8068-3941-7	Spring - Torsion Outer Upper
1	8/14	78-8062-3802-4	Finger - Tape Support
1	9/9	78-8015-7029-8	Spring - Tape Cut-off
1	8/19	78-8070-1615-5	Roller - Applying
2	10/8	78-8062-3987-3	Roller - Buffing
1	9/12	78-8070-1451-3	Felt Pad

Replacement Parts And Service

Refer to the first page of this instruction manual "**Replacement Parts And Service Information**".

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Replacement Parts – Illustrations and Parts Lists

HST Taping Head Assemblies, Type 39100

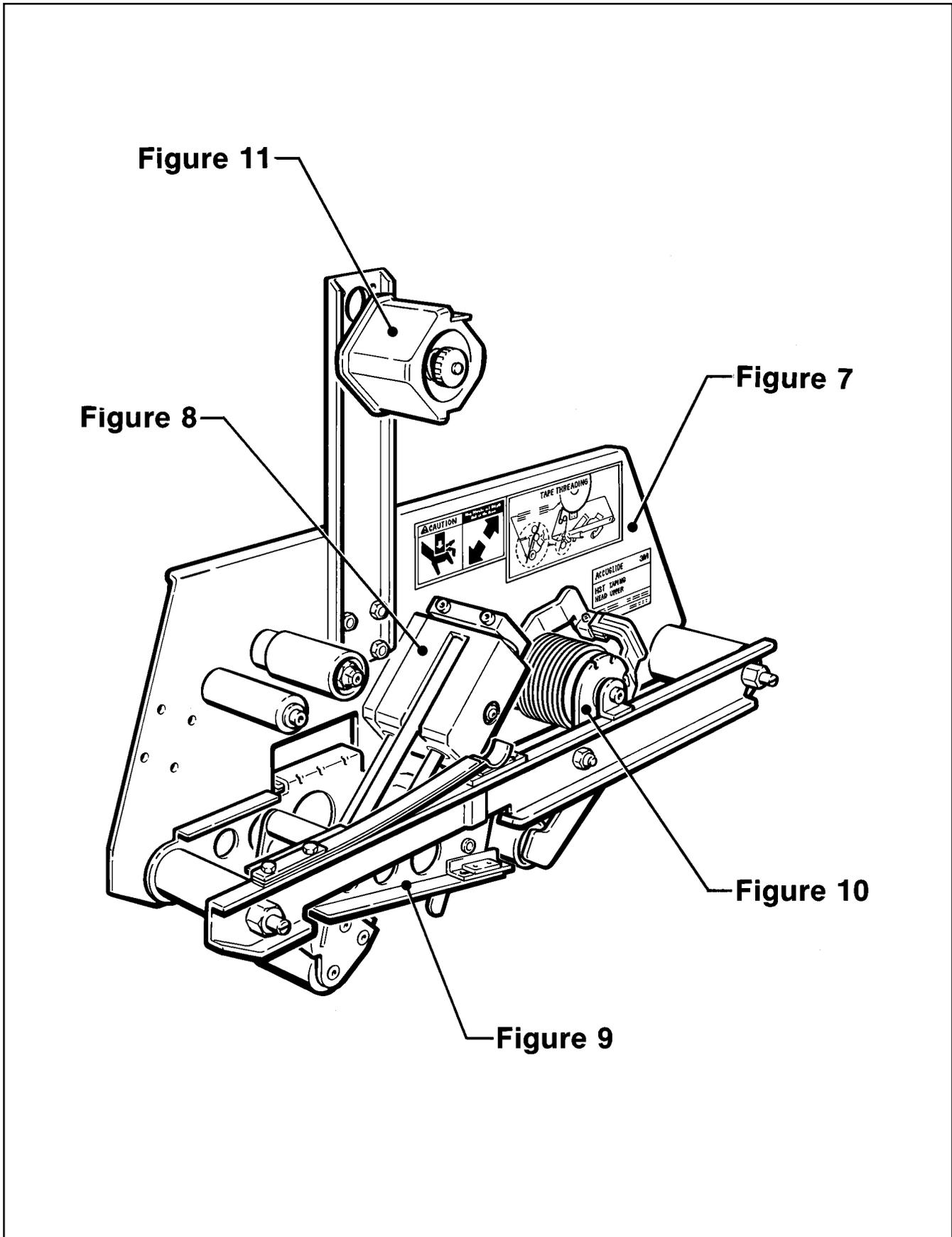
1. Refer to **Taping Head Assemblies** figure to find all the parts illustrations identified by **figure numbers**.
2. Refer to the figure or figures to determine the **individual parts** required and the **parts reference number**.
3. The **replacement parts list**, that follows each illustration, includes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

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

4. Refer to first page of this instruction manual for parts ordering address and/or phone/fax number.

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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Taping Head Assemblies

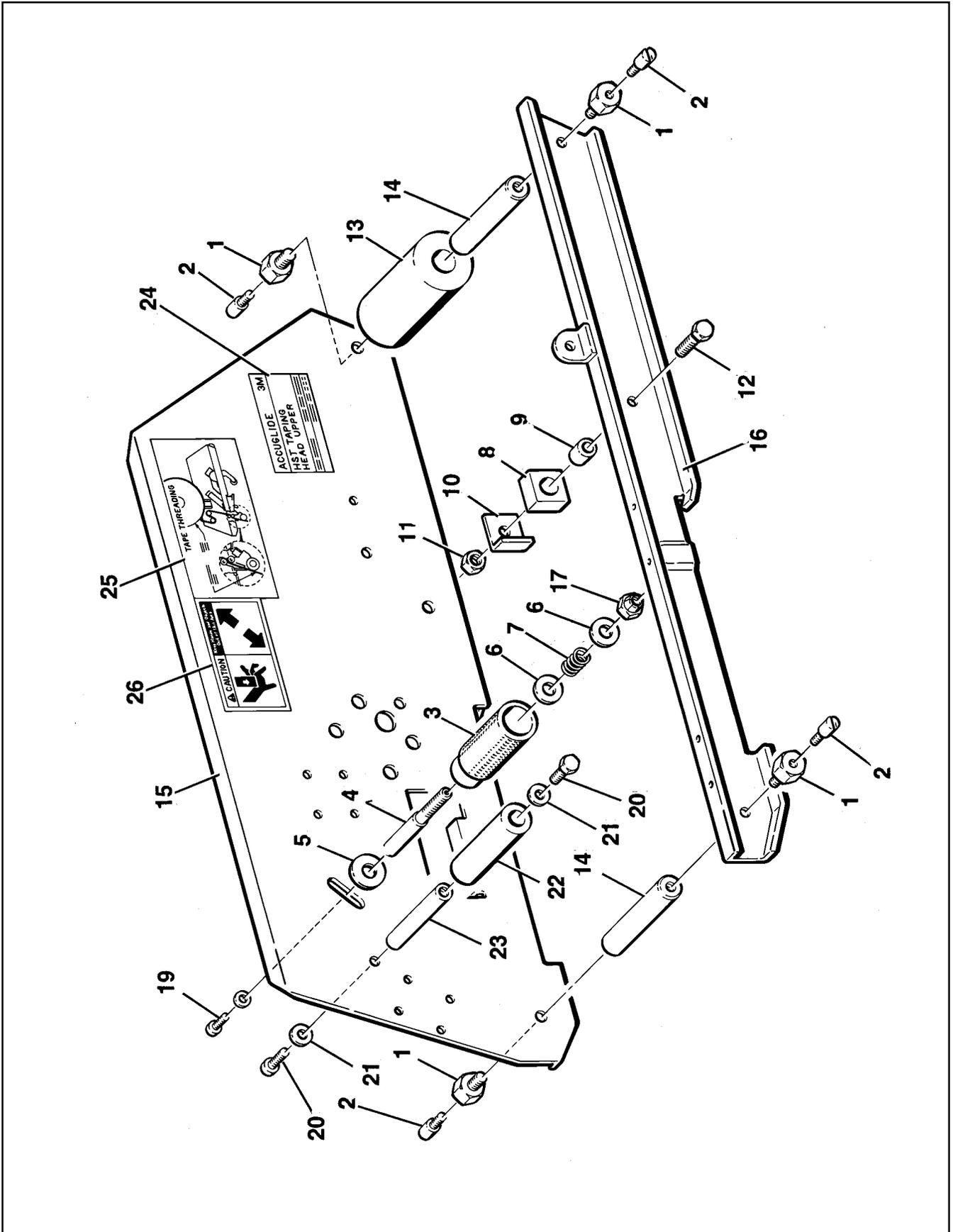


Figure 7

Figure 7 – HST, Type 39100

Ref. No.	3M Part No.	Description
1	78-8057-5701-6	Stud – Mounting
2	78-8057-5702-4	Pin – Mounting
3	78-8062-3810-7	Roller – Tension, Lower Head
3	78-8070-1401-0	Roller – Tension, Upper Head
4	78-8062-3840-4	Shaft – Tension Roller
5	78-8070-1268-3	Washer – Tension Roll Back-Up
6	78-8005-6119-9	Washer – Plain
7	78-8062-3811-5	Spring – Compression
8	78-8062-3814-9	Bumper – Buffing
9	78-8062-3813-1	Hub – Bumper
10	78-8062-3815-6	Clip Bumper
11	26-1000-9788-5	Nut – Self-Locking, 3/8-16
12	70-8000-5400-2	Screw – Hex Hd, 3/8-16 X 1-1/4 Lg.
13	78-8055-0999-5	Roller – Out-Going
14	78-8015-7043-9	Spacer
15	78-8070-1470-5	Frame – Upper Head
15	78-8070-1473-9	Frame – Lower Head
16	78-8070-1476-2	Rail – Upper Head
16	78-8070-1471-3	Rail – Lower Head
17	26-1009-4995-2	Nut – Self-Locking, 3/8-24
18	26-1009-4814-5	Washer – Plain, Hardened 1/4
19	70-8000-2641-4	Screw – Cap, Hex Soc Dr, 1/4-20 X 5/8 Lg.
20	70-8000-0885-9	Screw – Cap, Hex Soc Dr, 5/16-18 X 3/4 Lg.
21	70-8000-5390-5	Washer – Plain 5/16
22	78-8015-7190-8	Roller – Wrap
23	78-8057-5707-3	Shaft – Roller Wrap
24	78-8070-1495-2	Label – ID, Upper Head
24	78-8070-1494-5	Label – ID, Lower Head
25	78-8079-5020-5	Label – Tape Threading, Upper Head
25	78-8079-5021-3	Label – Tape Threading, Lower Head
26	78-8079-5019-7	Label – Caution, Upper Head
26	78-8079-5018-9	Label – Caution, Lower Head

HST, Type 39100

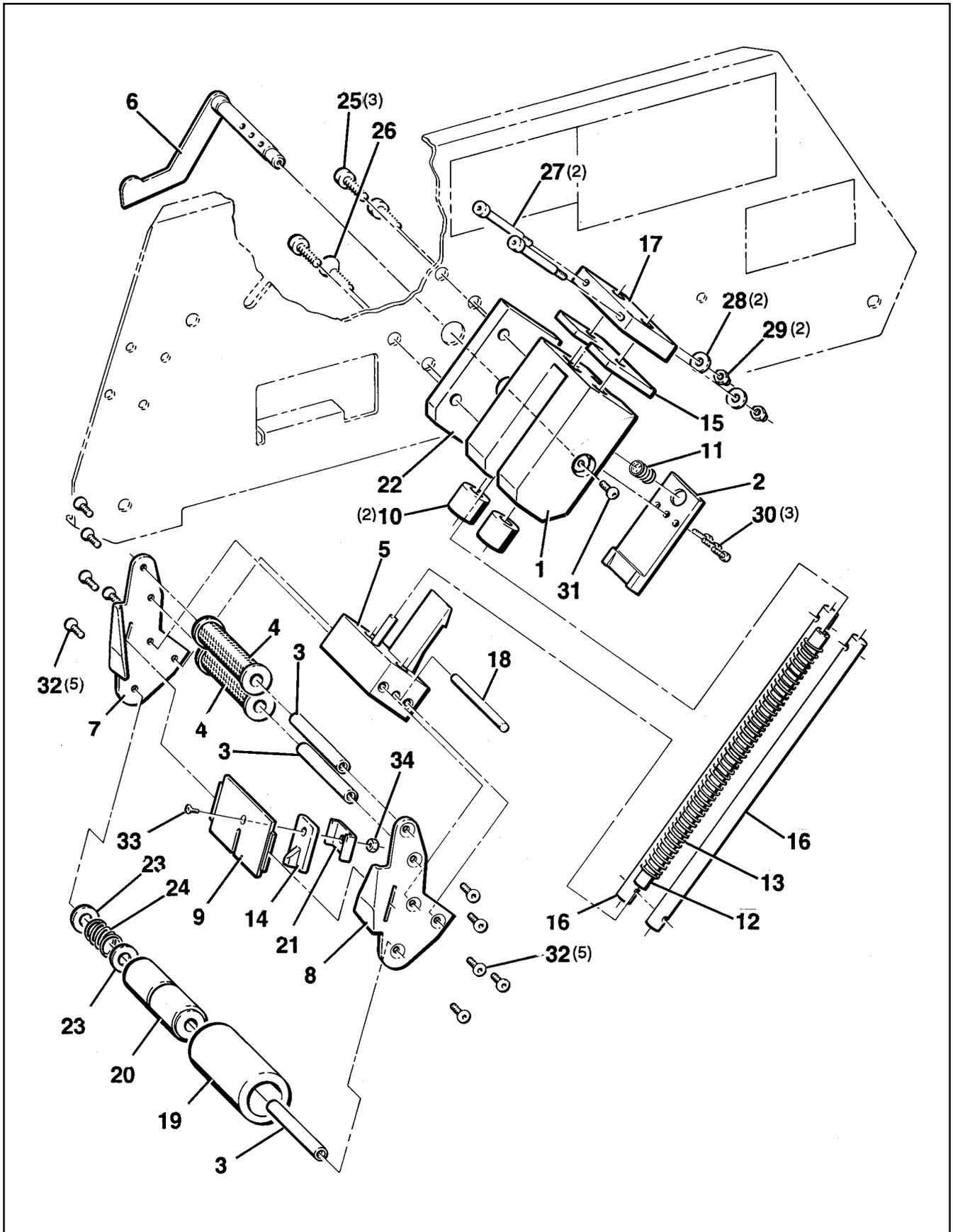


Figure 8

Figure 8 – HST, Type 39100

Ref. No.	3M Part No.	Description
1	78-8062-4155-6	Bearing Block Assembly, Lower Head
1	78-8062-4156-4	Bearing Block Assembly, Upper Head
2	78-8055-0976-3	Catch – Latch
3	78-8070-1614-8	Shaft – Roller, Knurled
4	78-8070-1402-8	Roller – Knurled
5	78-8055-0983-9	Applying Arm Block Assembly
6	78-8055-0978-9	Lever Latch Assembly, Lower
6	78-8070-1498-6	Lever Latch Assembly, Upper
7	78-8055-0992-0	Bracket – Roller Applying, Left Hand
8	78-8055-0993-8	Bracket – Roller Applying, Right Hand
9	78-8055-0995-3	Support – Tape
10	78-8057-5700-8	Bumper – Casting
11	78-8057-5703-2	Spring – Latch
12	78-8057-5706-5	Guide Spring
13	78-8015-7244-3	Spring – Compression (Installed Lower Head Only)
14	78-8062-3802-4	Finger – Tape Support
15	78-8062-4035-0	Bumper – Applying Assembly
16	78-8015-7085-0	Shaft – Linear Bearing
17	78-8015-7219-5	Block – Stop Lower Head
18	78-8015-7110-6	Pin – Linear Bearing Shaft
19	78-8070-1615-5	Roller – Applying
20	78-8070-1616-3	Bushing – Roller Applying
21	78-8062-3812-3	Clip – Tape Support
22	78-8068-3744-5	Spacer – Bearing Block
23	78-8005-6119-9	Washer – Friction
24	78-8062-4166-3	Spring – Compression
25	70-7023-4430-3	Screw – Cap Soc Hd, 3/8-16 X 1 Lg.
26	26-1009-4745-1	Screw – Cap Flat Head Soc Dr, 3/8-16 X 1 Lg.
27	70-8000-0247-2	Screw – Shoulder Soc Dr – 1/4 X 1-1/2 Lg.
28	26-1000-4442-4	Washer – Plain #10
29	26-1005-8126-8	Nut – Plastic Insert, 10-24
30	70-7023-8470-5	Screw – Cap Soc Hd, 10-32 X 3/8 Lg.
31	18-3104-5815-5	Screw – Cap Button Hd, Hex Soc, 1/4-20 X 3/8 Lg.
32	70-7023-8780-7	Screw – Cap, Flat Hd, Soc Dr, 10-32 X 1/2 Lg.
33	26-1002-7052-4	Screw – Cap Flat Hd, Soc Dr, 4-40 X 1/2 Lg.
34	26-1006-4508-9	Nut – Nylon Insert, 4-40

HST, Type 39100

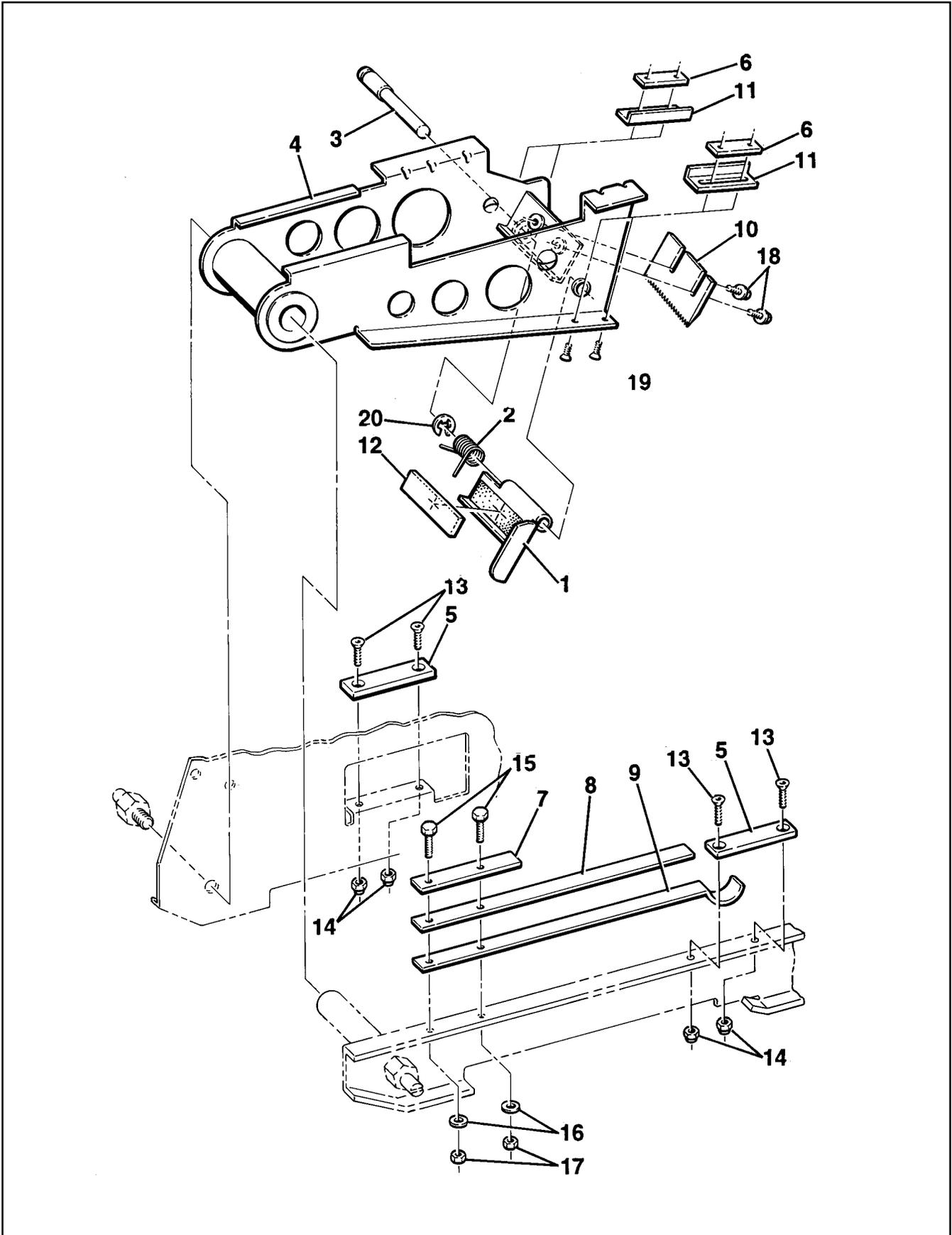


Figure 9

Figure 9 – HST, Type 39100

Ref. No.	3M Part No.	Description
1	78-8070-1450-7	Blade Guard Assembly, Lower
1	78-8070-1602-3	Blade Guard Assembly, Upper
2	78-8070-1430-9	Spring – Torsion, Lower
2	78-8079-5381-1	Spring – Torsion, Upper
3	78-8070-1436-6	Shaft
4	78-8070-1449-9	Frame – Cut-off Weldment, Lower
4	78-8070-1601-5	Frame – Cut-off Weldment, Upper
5	78-8057-5704-0	Bumper – Cut-off Long
6	78-8003-8772-8	Nut
7	78-8015-7030-6	Plate – Spring Retaining
8	78-8015-7212-0	Spring – Lower Head
9	78-8015-7029-8	Spring – Tape Cut-off
10	78-8070-1431-7	Blade
11	78-8057-5800-6	Bracket – Leg Length
12	78-8070-1451-5	Felt Pad
13	18-3142-3403-2	Screw – Flat Hd, Soc Dr, 6-32 X 1/2 Lg.
14	26-1006-4532-9	Nut – Nylon Insert, 6-32
15	70-8000-5338-4	Screw – Hex Hd, 10-32 X 3/4 Lg.
16	26-1000-4442-4	Washer – Plain #10
17	26-1000-9785-1	Nut – 10-32
18	26-1009-4564-6	Screw – Soc Hd, 10-32 X 1/4 Lg.
19	70-7023-8770-8	Screw – Flat Hd Soc Dr, 6-32 X 3/8 Lg.
20	26-1008-9275-6	E-Ring – Waldes #5133-3

Figure 10 – HST, Type 39100

Ref. No.	3M Part No.	Description
1	78-8062-3992-3	Buffing Arm Assembly, Lower
1	78-8079-5221-9	Buffing Arm Assembly, Upper
2	78-8070-1499-4	Bumper – Buffing
3	78-8055-0970-6	Pin – Buffing
4	78-8055-0969-8	Shaft – Buffing Arm
5	78-8015-7213-8	Spring – Torsion Inner, Lower
5	78-8068-3940-9	Spring – Torsion Inner, Upper
6	78-8015-7214-6	Spring – Torsion Outer, Lower
6	78-8068-3941-7	Spring – Torsion Outer, Upper
7	78-8055-0965-6	Sleeve – Torsion Spring
8	78-8062-3987-3	Roller – Buffing
9	78-8017-9139-9	Bushing – Buffing Roller
10	78-8062-3813-1	Hub – Bumper, Buffing
11	78-8062-3988-1	Bumper – Arm
12	78-8062-3989-9	Clip – Arm
13	70-8000-5400-2	Screw – Hex Hd, 3/8-16 X 1-1/4 Lg.
14	78-8005-6119-9	Washer – Plain 3/8
15	26-1000-9788-5	Nut – Nylon Insert, 3/8-16
16	70-8656-5901-8	Screw – Soc Dr, 6-32 X 3/8 Lg.
17	70-8000-0885-9	Screw – Soc Dr, 5/16-18 X 3/4 Lg.
18	70-8656-5938-0	Screw – Soc Dr, 1/4-20 X 1/2 Lg.
19	26-1000-4442-4	Washer – Plain #10
20	70-7023-4370-1	Screw – Button Hd Soc Dr, 10-32 X 1/2 Lg.
21	26-1005-8127-6	Screw – Shoulder Soc Dr, 5/16 x 3/8 Lg.
22	70-8000-5372-3	Nut – Jam, 1/4-20

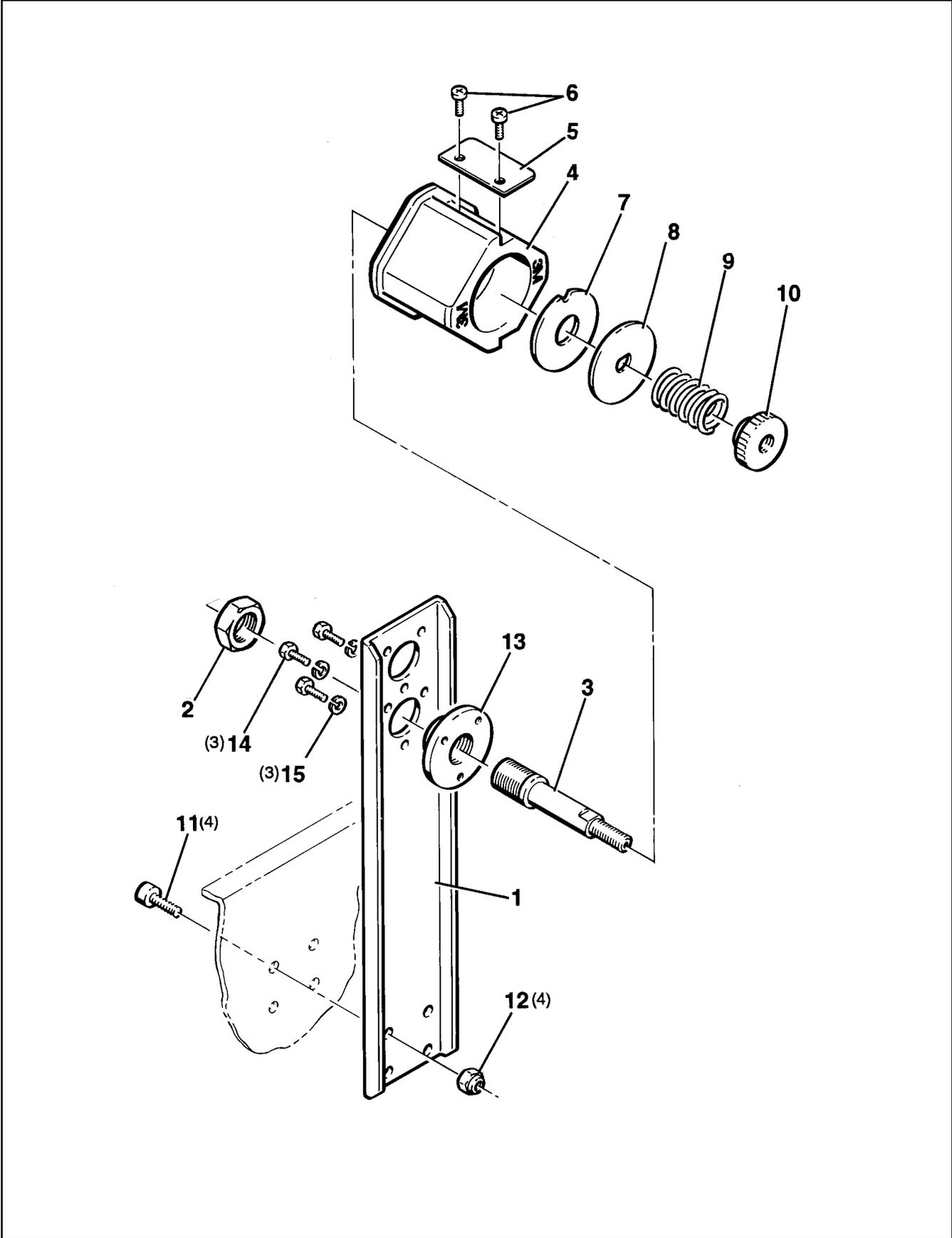


Figure 11

Figure 11 – HST, Type 39100

Ref. No.	3M Part No.	Description
1	78-8070-1618-9	Bracket – Tape Drum
2	78-8017-9169-6	Nut – Hex M18 x 1
3	78-8076-4519-3	Shaft – Tape Drum
4	78-8052-6749-5	Tape Drum Assembly
5	78-8052-6268-6	Leaf Spring
6	26-1002-5753-9	Screw – Self Tapping
7	78-8060-8172-1	Washer – Friction
8	78-8052-6271-0	Washer – Tape Drum
9	78-8054-8826-5	Spring
10	78-8060-7851-1	Ring Nut – Adjusting
11	70-7023-4290-1	Screw – Cap, Hex Soc Dr 1/4-20 x 5/8 Lg.
12	26-1000-9786-9	Nut – Hex 1/4 - 20
13	78-8017-9090-4	Flange – Tape Holder Shaft
14	26-1003-5811-3	Screw – Hex Hd, M4 X 10
15	26-1010-0320-5	Washer – Lock, M4