



# Instructions and Parts List

## AccuGlide™ II STD 1-1/2 Inch Lower Taping Head

Type 29600



### Important Safety Information

Read "Important Safeguards",  
page 2 and also operating  
"Warnings", page 7 BEFORE  
INSTALLING OR  
OPERATING THIS  
EQUIPMENT

### Spare Parts

It is recommended you  
immediately order the  
spare parts listed on  
page 17. These parts are  
expected to wear through  
normal use, and should  
be kept on hand to minimize  
production  
delays.

Serial No. \_\_\_\_\_

For reference, record taping head serial number here.

Rev # is B28.0 here,  
but it is E79.0 on the  
following page, and it  
is D79.0 on the page  
after that.

**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 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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# Replacement Parts And Service Information

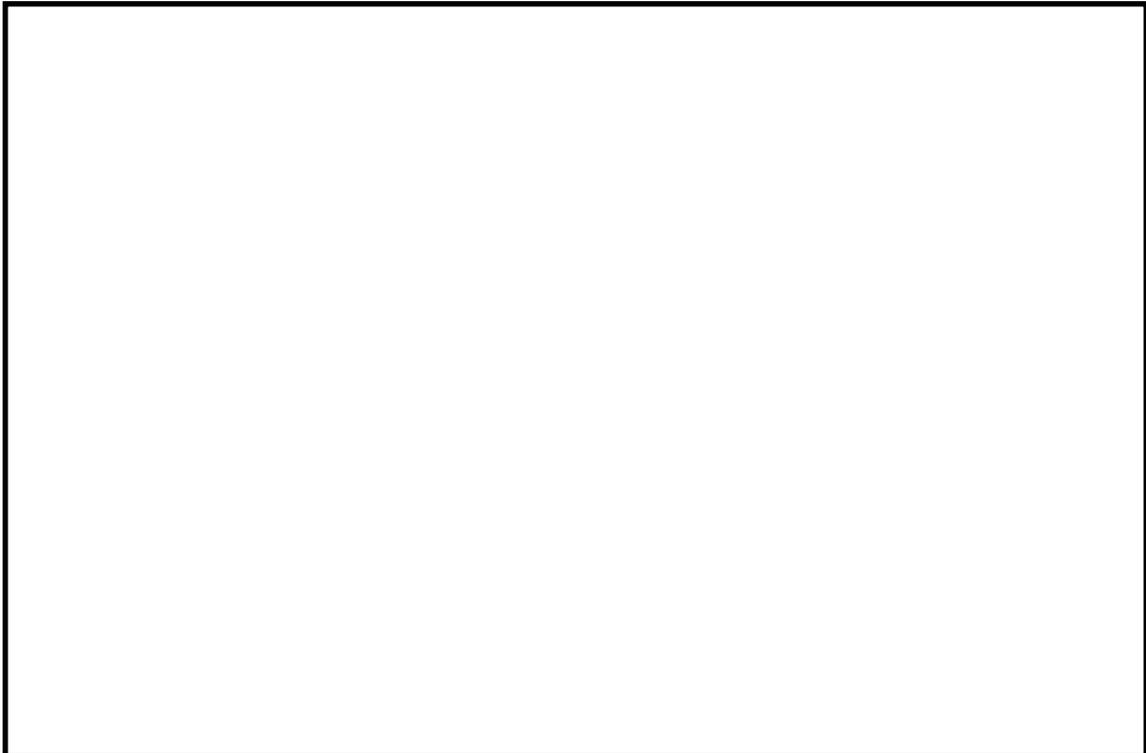
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## To Our Customers:

**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**

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1-800/328 1390

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# Instruction Manual

AccuGlide™ II STD 1-1/2 Inch  
Lower Taping Head  
Type 29600

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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 1-1/2 Inch Lower Taping Head, Type 29600** with the following warranties:

1. The Taping Head knife, 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.

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## Taping Head Contents

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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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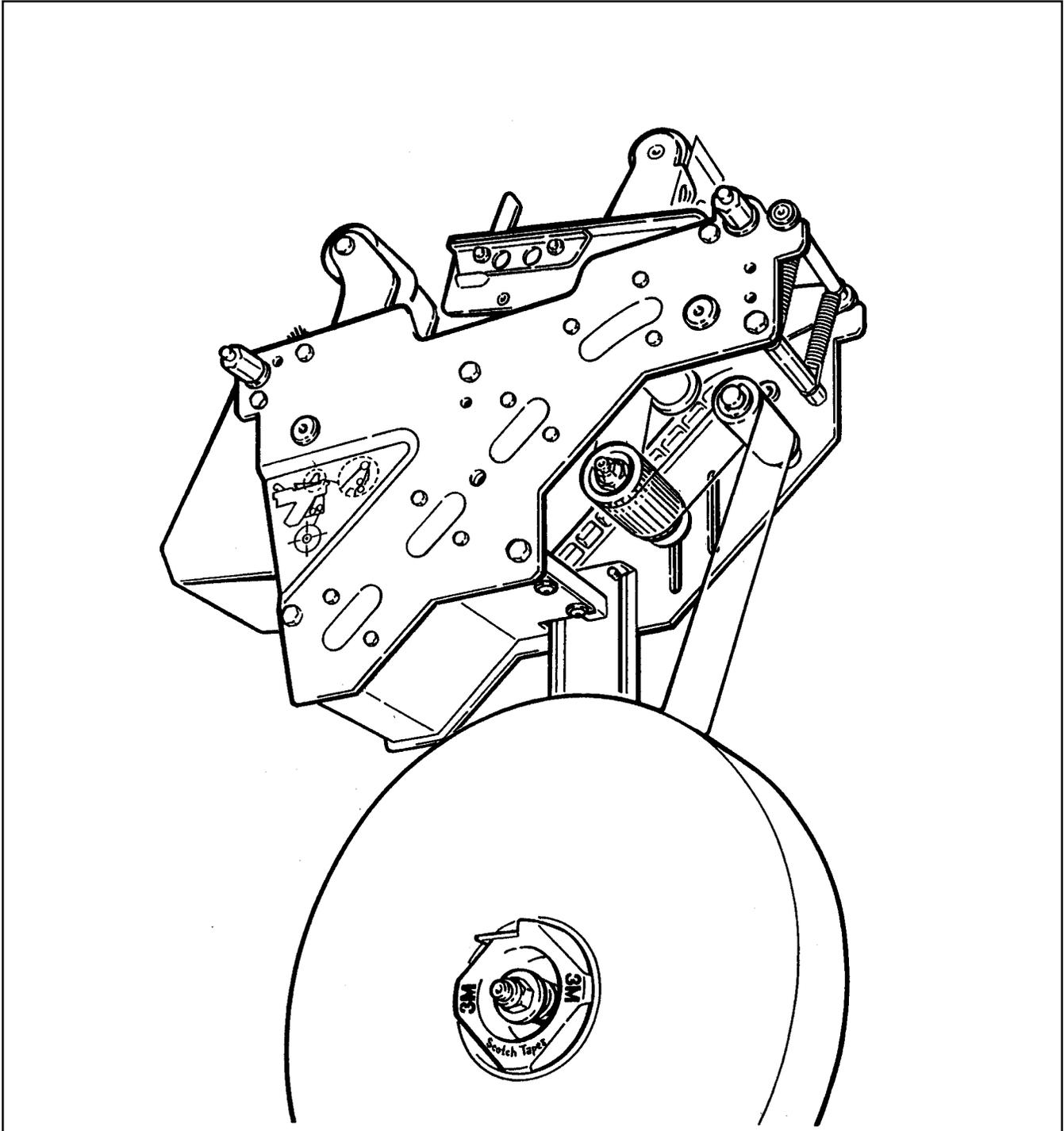
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## Description

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The **AccuGlide™ II STD 1-1/2 Inch Lower Taping Head**, was designed to be used in the 800asb Case Sealer. The taping head applies a “C” clip of **Scotch™** brand pressure-sensitive film box sealing tape to the bottom center seam of regular slotted containers.

The design of this taping head allows it to be mounted in the upper or lower taping locations. 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.



**AccuGlide™ II STD 1-1/2 Inch Lower Taping Head, Type 29600**

## Important Safeguards



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

**Important** – In the event the following safety labels are damaged or destroyed, they must be replaced to ensure operator safety. See Parts Drawing/Lists, pages 18-31 for label part numbers.

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 knife guard between the applying roller assembly and the buffing roller assembly. **Never operate taping head with knife guard removed.**

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

The “**Tape Threading Label**”, shown in Figure 1-2, is attached to the left side of the taping head. 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 taping head.**



Figure 1-1 – Knife Warning Label

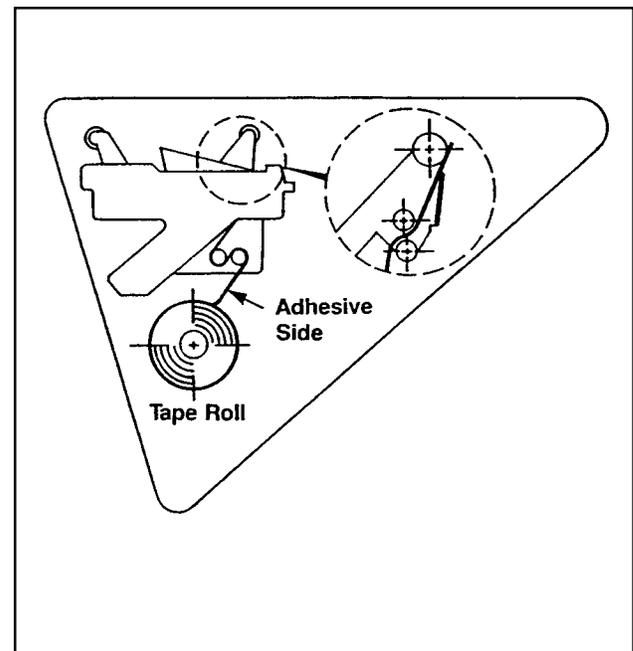


Figure 1-2 – Tape Threading Label

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# Specifications

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1. **Tape:**

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

2. **Tape Width:**

36 mm [1.50 inch] maximum

3. **Tape Roll Diameter:**

Up to 405 mm [16 inch] 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:**

50 mm ± 6 mm [2 inch ± 0.25 inch]

**Tape Application Leg Length – Optional:**

70 mm ± 6 mm [2.75 inch ± 0.25 inch] (See "Adjustments – Tape Leg Length", page 13.)

5. **Box Size Capacities:**

For use with center seam regular slotted containers.

	<b>Minimum</b>		<b>Maximum</b>
Length –	150 mm [6 inch]		Unlimited
Height –	120 mm [4.75 inch] (most “3M-Matic” case sealers) 70 mm [2.75 inch] (with 2 inch leg length)		Limited by case sealer
Width –	Limited by case sealer		Limited by case sealer

When lower taping head is 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	–	457 mm [18.00 inch]
Height	–	560 mm [22 inch] (with tape drum)
Width	–	91 mm [3.62 inch] (without mounting spacers)
Weight	–	Packaged: 8.2 kg [18 lbs.] Unpackaged: 7.2 kg [16 lbs.]

# Specifications

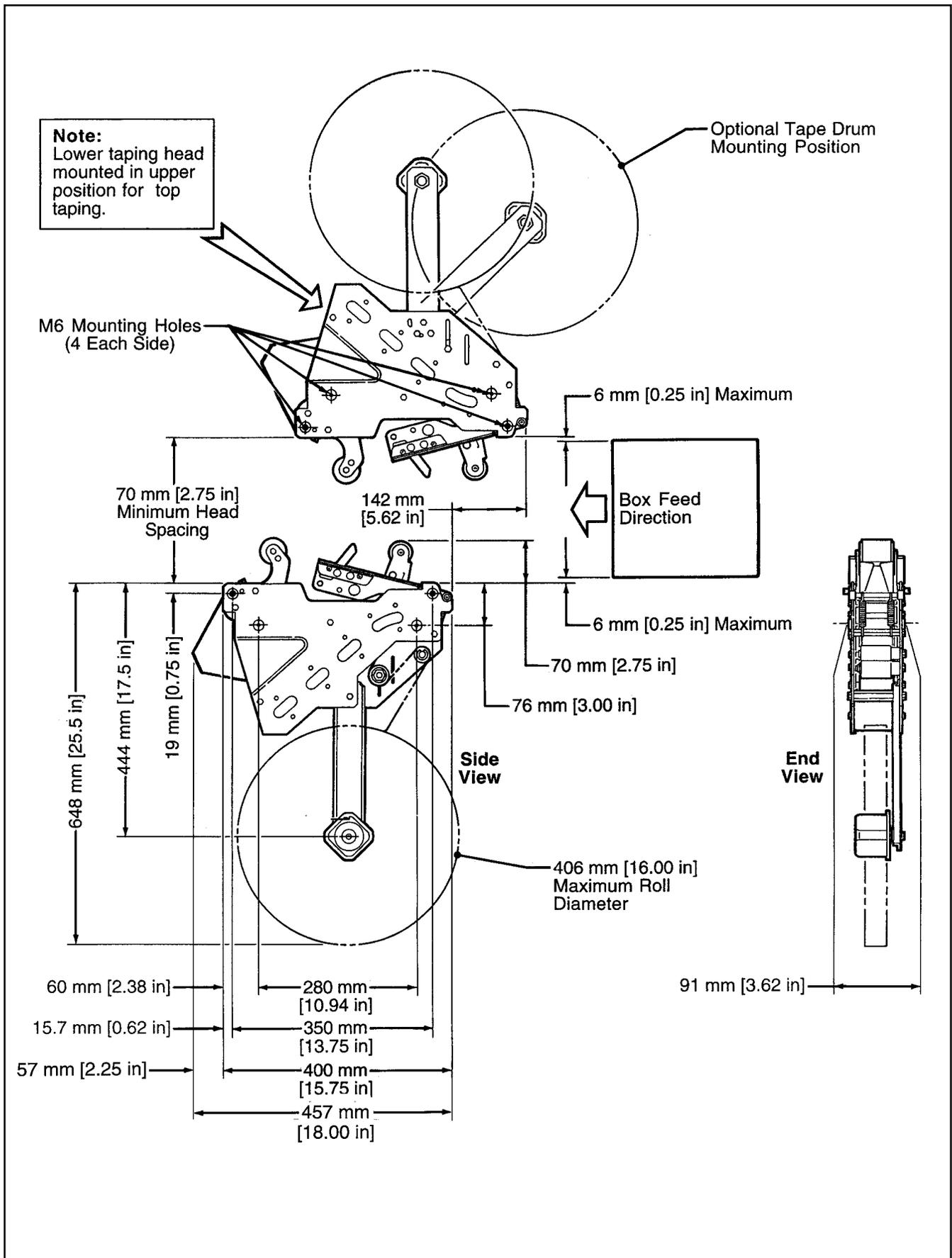


Figure 2-1 – Dimensional Drawing

## Installation



**WARNING** – Taping head utilizes an extremely sharp tape cut-off knife. The knife is located under the orange knife guard which has the "Warning – Sharp Knife" label. Before working with the taping head or loading tape, refer to Figures 3-1 and 3-2 on page 6 and identify the knife location. Keep hands out of these areas except as necessary to service the taping head.

### 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 AccuGlide™ II STD 1-1/2 Inch Lower Taping Head is designed for bottom taping of boxes, however, with slight modification, it can easily be adapted to top taping. See "Adjustments – Converting Lower Head to Upper Head", page 14. Refer to box size specifications on page 3, and Figure 2-1 on page 4, for the following points in making such installations:



**CAUTION** – Taping head weighs approximately 7.7 kg [17 lbs] without tape. Remove tape roll before removing taping head from machine to minimize weight. Use proper body mechanics when installing or removing taping head.

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.**

**Note** – AccuGlide™ II STD taping Heads are supplied with a buffing arm guard. This guard may have to be removed to install the taping head into some older design 3M-Matic™ case sealers. If this is the case, remove the four guard mounting screws, remove the guard and then install the taping head.

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 [0.25 inch] maximum away from the ski surface on which the box rides.

### Tape Leg Length

Taping head is factory set to apply standard 50 mm [2 inch] tape legs. The head can be converted to apply 70 mm [2.75 inch] tape legs if desired. See "Adjustments – Changing Tape Leg Length From 50 to 70 mm [2 to 2.75 Inch]", page 13.

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

### Tape Width Adjustment

Taping head is factory set to apply 36 mm [1.50 inch] wide tape. If it is necessary to align the tape, refer to "Adjustments – Tape Web Alignment", page 12 for set-up procedure.

# Operation

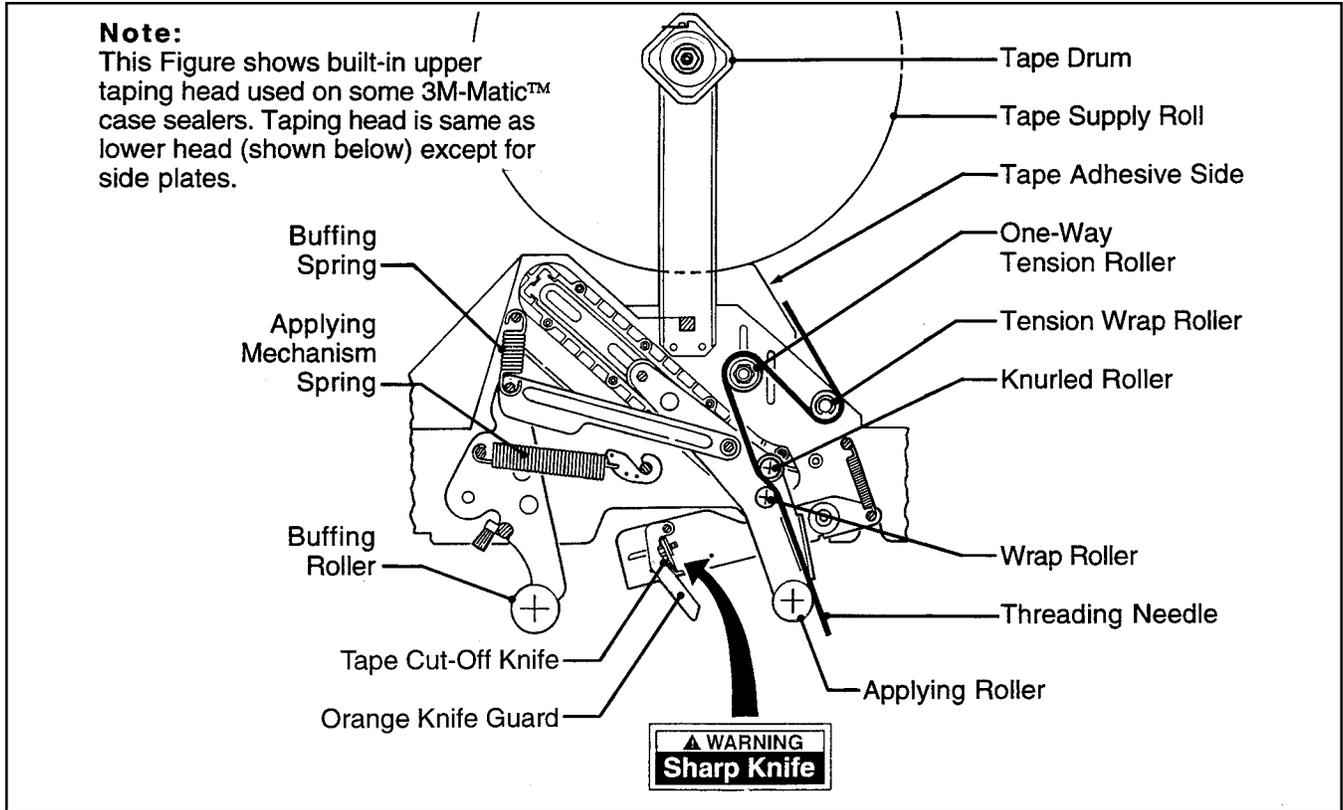


Figure 3-1 – Taping Head Components/Threading Diagram – Upper Head (Left Side View)

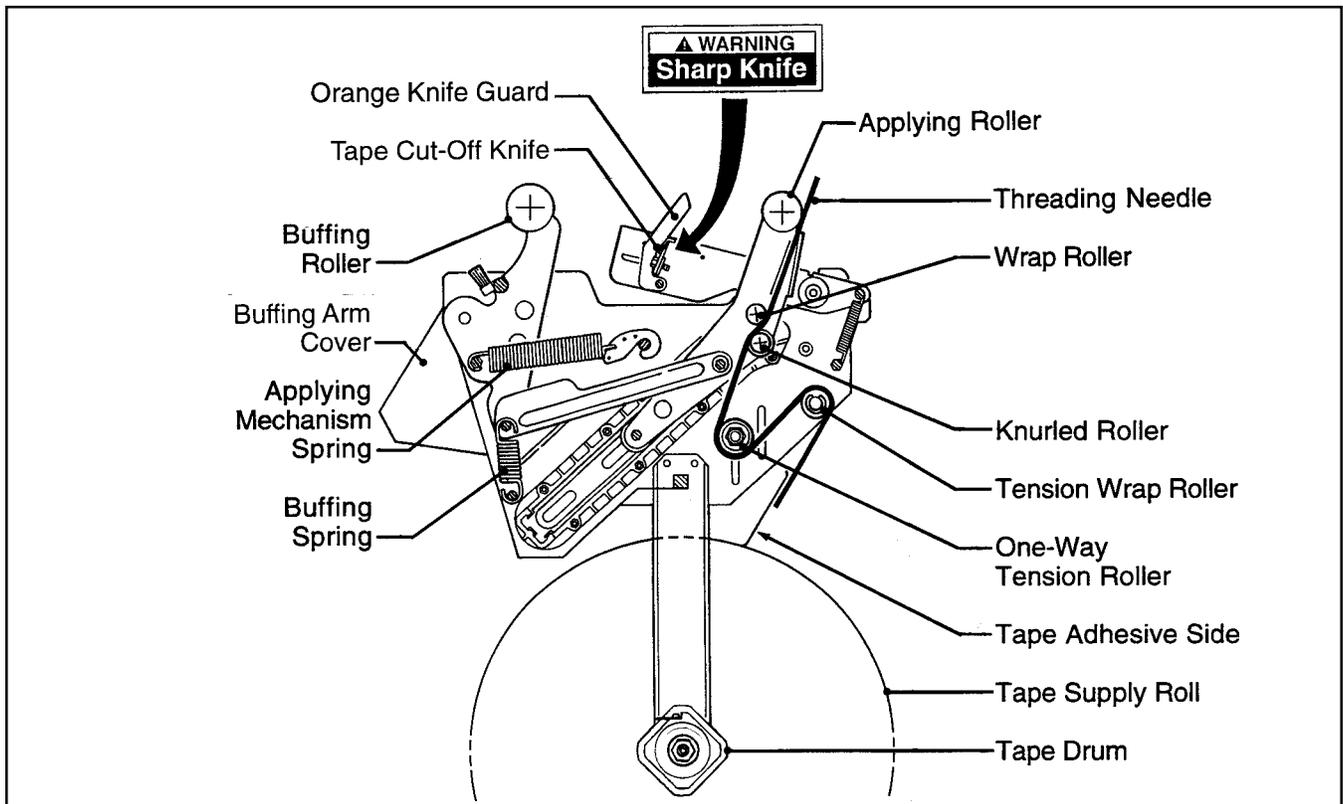


Figure 3-2 – Taping Head Components/Threading Diagram – Lower Head (Left Side View)

## Operation (Continued)



### WARNINGS

1. Turn air and electrical supplies off and disconnect before servicing taping head.
2. Never attempt to work on the taping head or load tape when the box drive system is running.
3. The taping head uses an extremely sharp tape cut-off knife. Before working with the taping head or attempting to load/thread tape, refer to Figures 3-1 and 3-2 and identify the knife location. Keep hands out of these areas except as necessary to service the taping head.
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 – Lower Taping Head

1. For ease in loading, first remove the lower taping head from the conveyor bed.
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 – Upper Taping Head

(AccuGlide™ II STD 1-1/2 Inch Lower Taping Head optionally mounted for top taping.)

1. Raise the upper taping head to a convenient working position.
2. The upper taping head is loaded and threaded in the same manner as the lower head. Follow the lower 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.

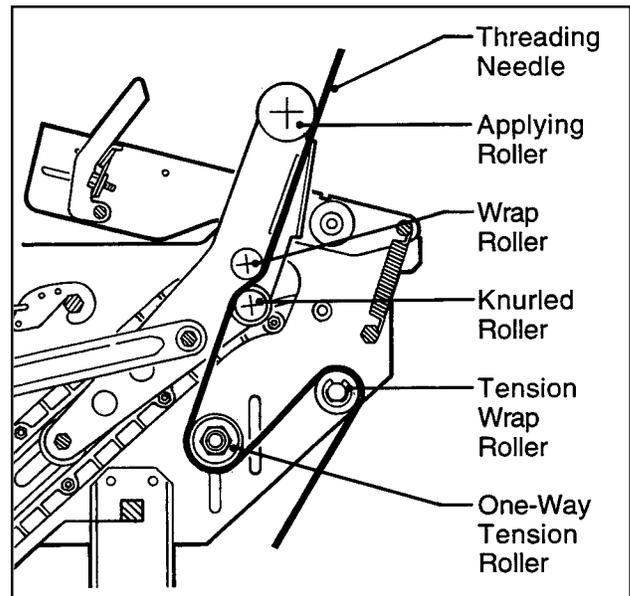


Figure 3-3 – Tape Loading

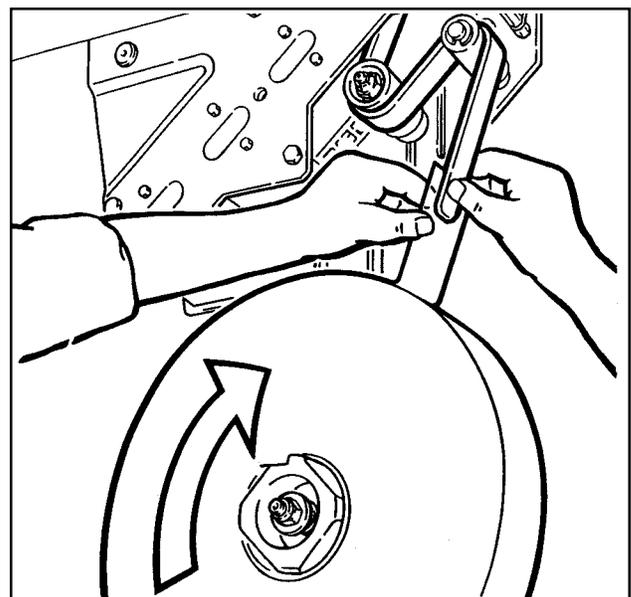


Figure 3-4 – Tape Loading

## Operation (Continued)

Figure 3-5



**WARNING** – Use care when working near cut-off knife as knife 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.

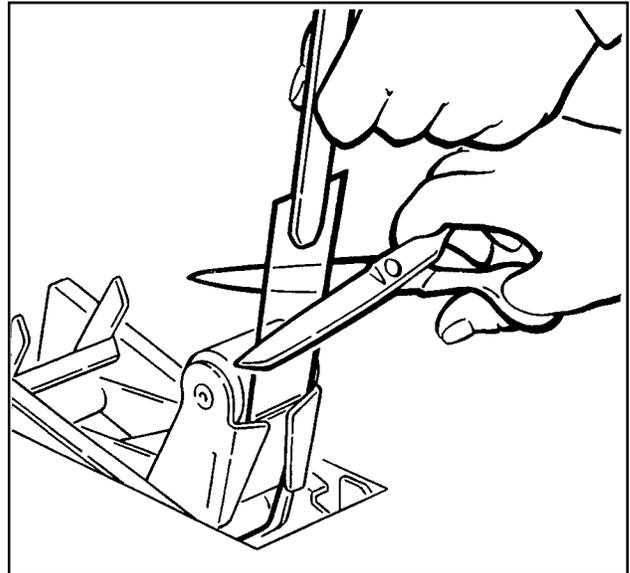


Figure 3-5 – Tape Loading

### Buffing Roller Pressure Adjustment

Buffing roller pressure is critical especially on lightly filled boxes. To adjust pressure, see "Adjustments – Applying Mechanism/Buffering Extension Springs", page 11.

## Maintenance



### WARNINGS

1. Turn air and electrical supplies off and disconnect before beginning maintenance.
2. Use care when working near tape cut-off knife as knife 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.

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

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

**Note** – Check the knife position to insure proper clearance between knife and guard by slowly pivoting the knife guard back.

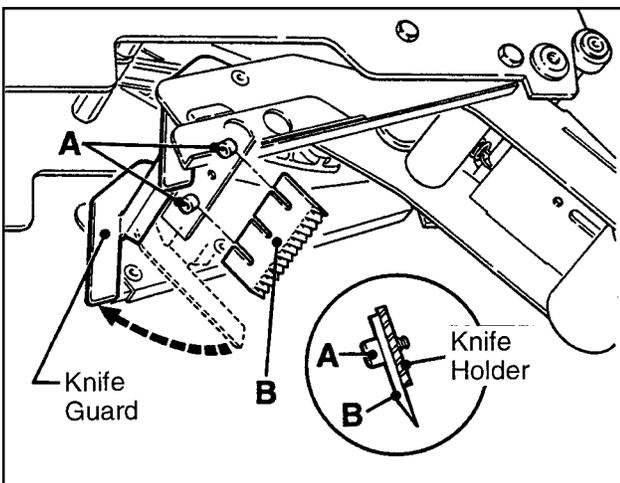


Figure 4-1 – Knife Replacement

#### Knife Guard

The knife guard covers the knife whenever a box is not being taped. Periodically check to be sure the knife guard is functioning properly and returning to cover the knife. Replace any defective parts.

#### Knife 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 knife to reduce adhesive build-up. Apply SAE #30 non-detergent oil as needed. **Saturate felt oiler pad.**

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

#### 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.

## Maintenance (Continued)



### WARNINGS

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

### 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.

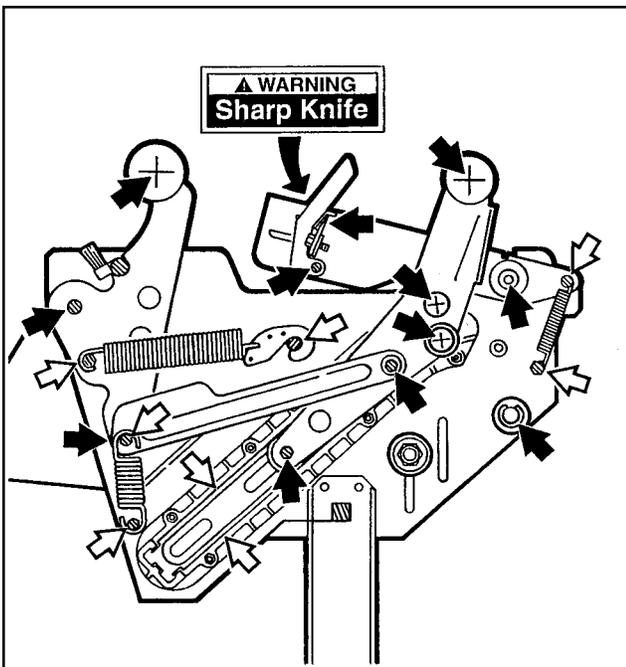


Figure 4-2 – Lubrication Points

### 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.

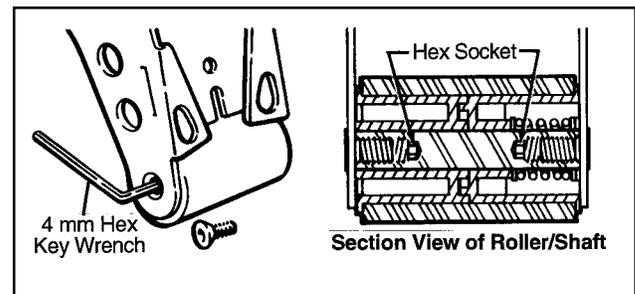


Figure 4-3 – Section View of Roller Shaft

## 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.

### Applying Mechanism/Buffering Extension Springs

To obtain access to the spring, remove the taping head cover (four mounting screws). Replace cover when finished.

Boxes must be properly filled to support the flaps for the buffering roller pressure. Buffering roller pressure is adjusted with the applying mechanism and buffering extension springs.

#### APPLYING MECHANISM SPRING

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

If a tape gap appears on the trailing surface of the box, increase spring pressure. If the front or rear of the box is being crushed by the applying roller, decrease the spring pressure or remove buffering extension spring from buffering arm assembly. See "Buffering Extension Spring", below.

Removing the spring end loop from the spring holder and placing in other holes provided, as shown in Figure 5-1B, will adjust the spring pressure. Spring pressure should be set to the minimum possible while maintaining good tape application.

#### BUFFING EXTENSION SPRING

If buffering roller force cannot be reduced enough by adjusting the applying mechanism spring, the buffering extension spring shown in Figure 3-1, 3-2 and 5-2 can be removed to reduce pressure. In this case, the applying mechanism spring will have to be re-adjusted to provide sufficient buffering roller pressure to adequately buff the tape seal.

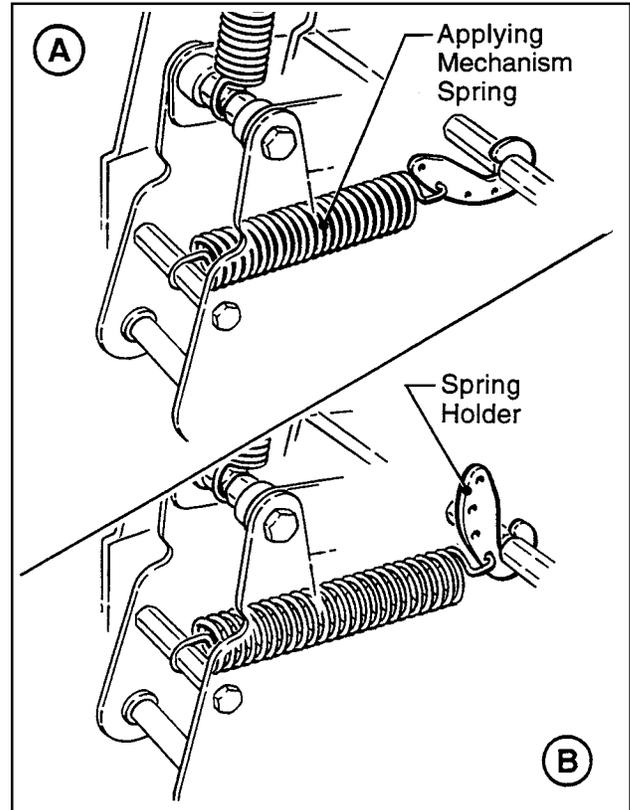


Figure 5-1 – Applying Mechanism Spring

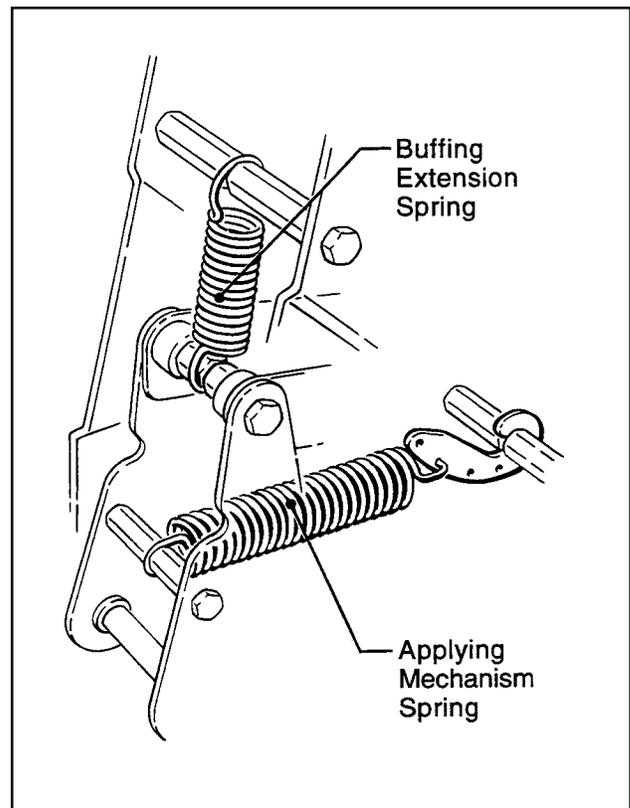


Figure 5-2 – Buffering Extension Spring

## 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 Web Alignment – Figure 5-3

The STD tape drum assembly is pre-set to accommodate 36 mm [1.50 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.

### Tape Drum Friction Brake – Figure 5-4

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.

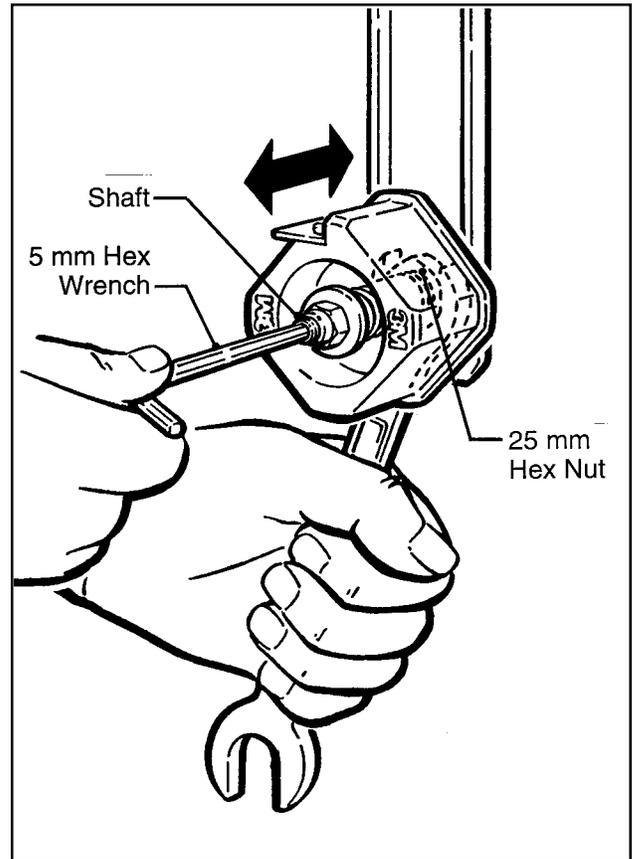


Figure 5-3 – Tape Web Alignment

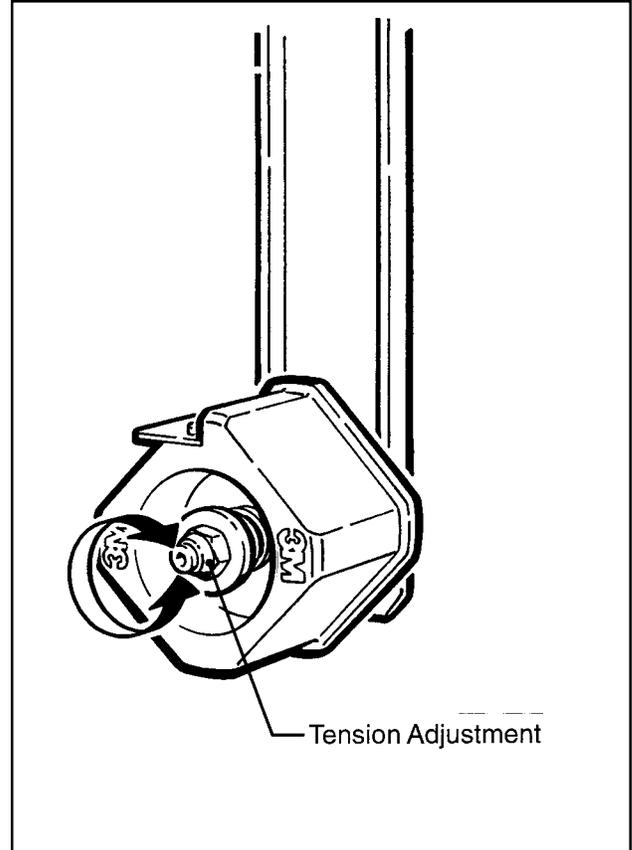


Figure 5-4 – Tape Drum Friction Brake

## 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.

### Tape Leg Length

**WARNING** – Use care when working near cut-off knife as knife 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 50 to 70 mm [2 to 2.75 INCH] – 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.

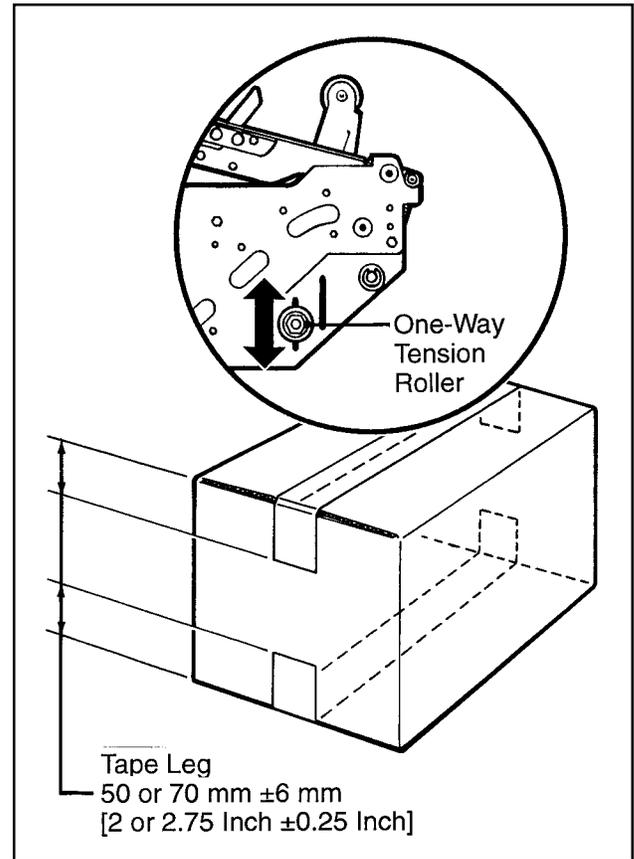


Figure 5-5 – Leading Tape Leg Length

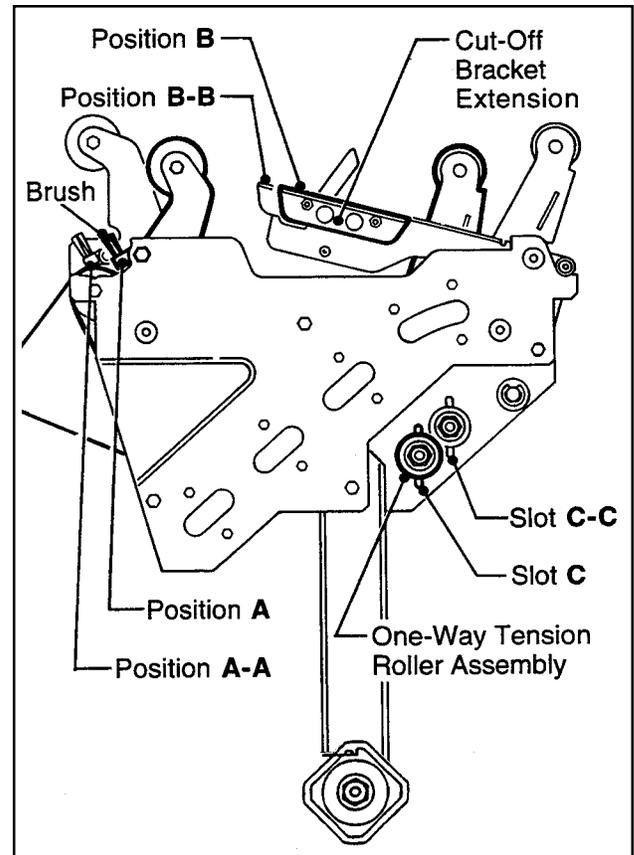


Figure 5-6 – Changing Tape Leg Length

## 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.

### One-Way Tension Roller

Figure 5-7

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 [1-2 lbs. ] is required to turn the roller by pulling on the spring scale.

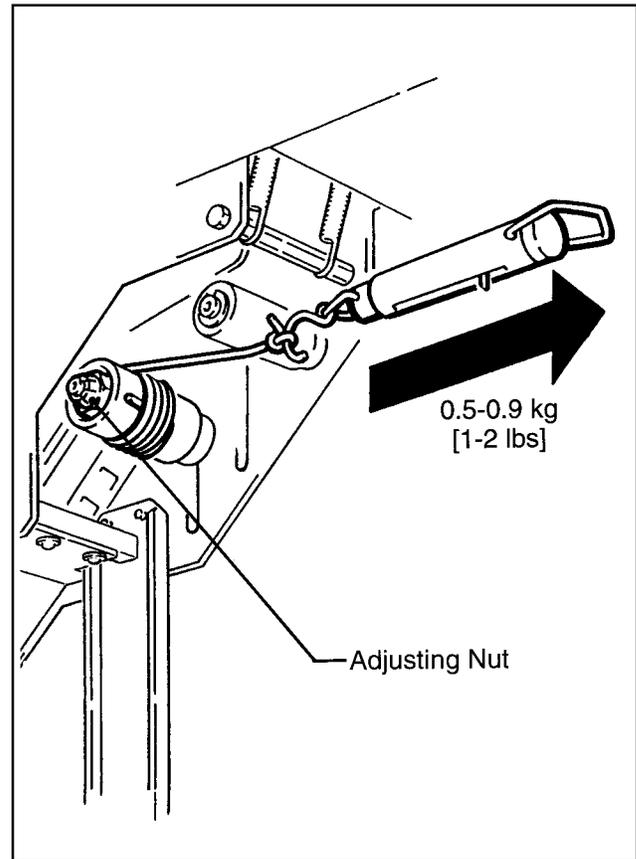


Figure 5-7 – One-Way Tension Roller

### Converting Lower Head to Upper Head

The **AccuGlide™ II STD 1-1/2 Inch Lower Taping Head** can be used as an upper head to tape the top of boxes by making the following modification:

1. Remove the (black) applying mechanism spring P/N 78-8070-1273-3 (Figure 4798-10), and replace it with the (silver) applying mechanism spring P/N 78-8070-1274-1, available in spare parts.
2. Mount the taping head per installation guidelines on page 5 of this manual.

**Note** – Tape loading/threading on upper head will be from the opposite side of machine.

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## Troubleshooting

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<b>Problem</b>	<b>Cause</b>	<b>Correction</b>
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 tape cut-off knife does not cut tape or the tape end is jagged or shredded	The knife is dull and/or has broken teeth	Replace the knife
	Tape tension is insufficient	Increase tape tension by adjusting the one-way tension roller
	Adhesive has built up on the knife	Clean and adjust the knife
	The knife is not positioned properly	Make sure the knife is bottomed out against the mounting bolts
	The knife is dry	Lubricate the knife oiler pad on the blade guard
	The knife is in backwards	Mount the knife 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.

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(Continued)

## Troubleshooting (Continued)

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 knife 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

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## Spare Parts/Service Information

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### 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 1-1/2 Inch Lower Taping Head

Qty.	Ref. No.	Part Number	Description
1	4795-2	78-8017-9173-8	Knife – 2.56 Inch/65 mm
2	4795-12	78-8052-6602-6	Spring – Cutter
4	4797-23	78-8094-6168-0	Stud – Mounting
1	4798-10	78-8070-1273-3	Spring – Lower Extension (Black)
1	–	78-8017-9433-6	Tool – Tape Threading
1	4794-8	78-8098-9095-3	Spring – Extension

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	4792-16	78-8094-6153-2	Roller – Applying
1	4798-5	78-8094-6155-7	Roller – Buffing
1	4795-18	78-8113-7030-9	Spring – Torsion

### 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

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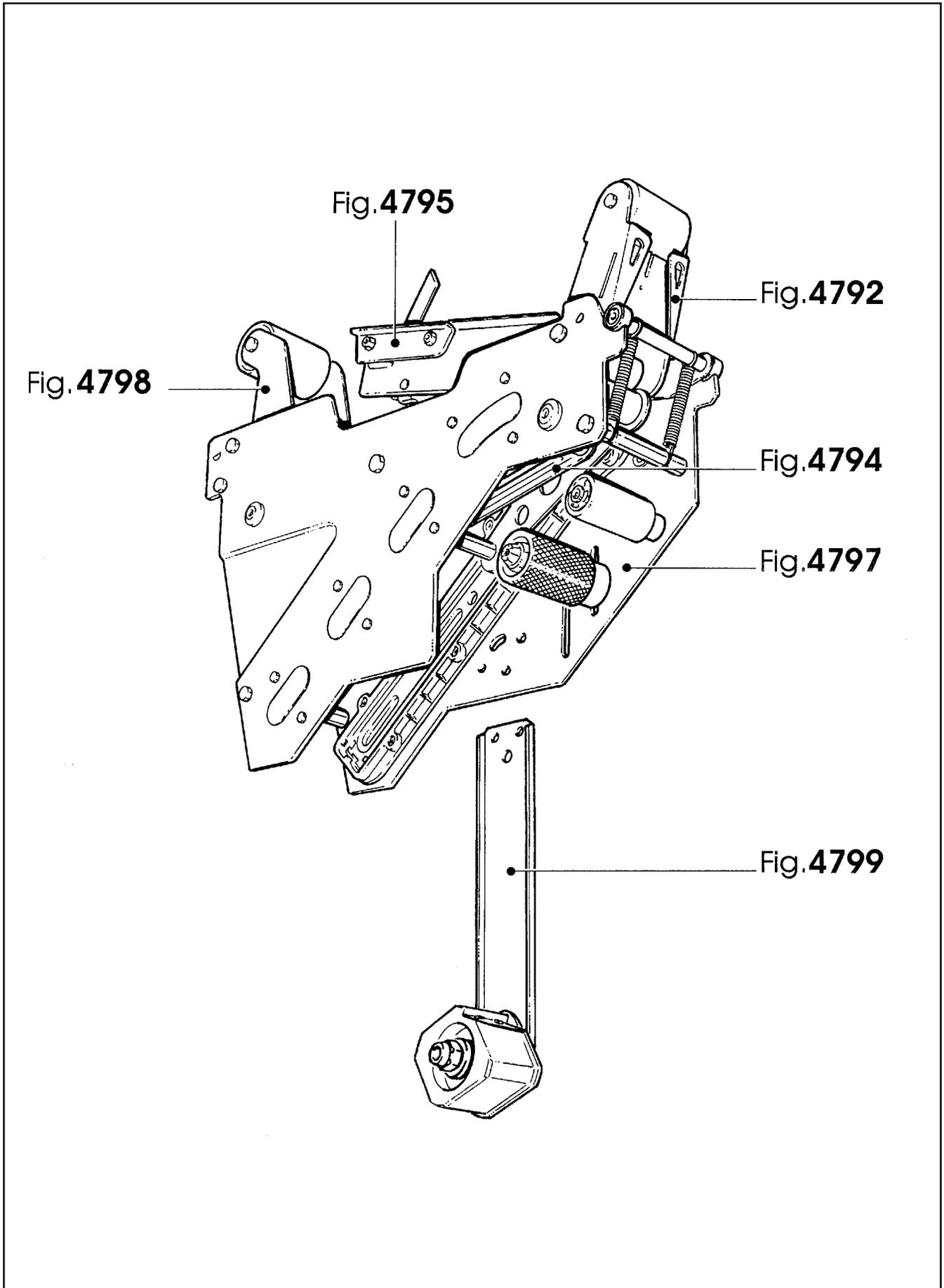
### AccuGlide II STD 1-1/2 Inch Lower Taping Head, Type 29600

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 1-1/2 Inch

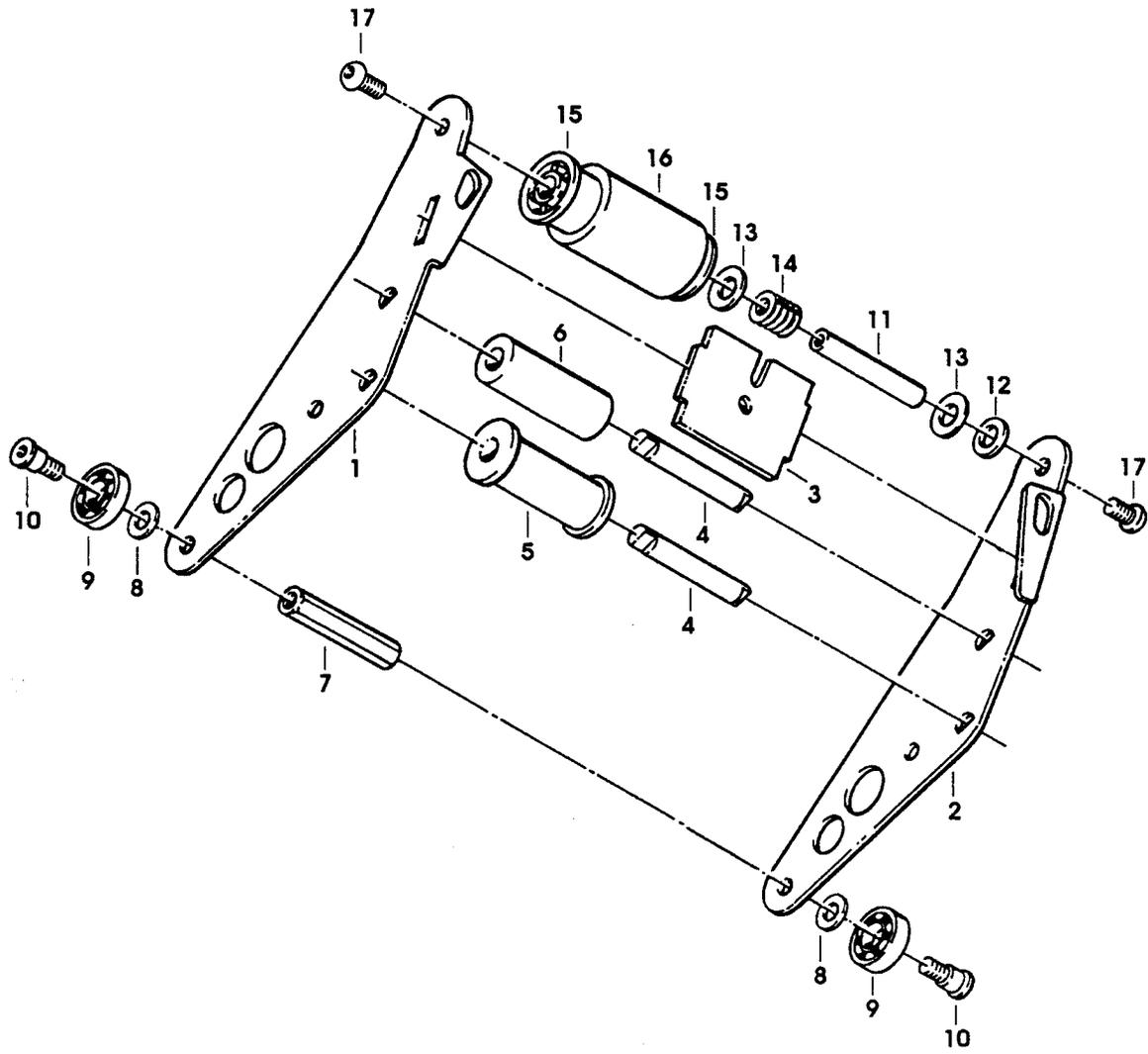


Figure 4792 – Lower Head

## Figure 4792 – Lower Head

Ref. No.	3M Part No.	Description
4792-1	78-8070-1206-3	Arm – Applying, R/H
4792-2	78-8070-1207-1	Arm – Applying, L/H
4792-3	78-8094-6146-6	Plate
4792-4	78-8094-6147-4	Shaft – /10
4792-5	78-8094-6148-2	Roller – Knurled
4792-6	78-8094-6149-0	Roller
4792-7	78-8094-6150-8	Spacer – Hex
4792-8	78-8094-6151-6	Washer
4792-9	78-8017-9082-1	Bearing – Special, 30 mm
4792-10	78-8017-9106-8	Screw – Bearing Shoulder
4792-11	78-8094-6152-4	Shaft
4792-12	78-8017-9074-8	Washer – Nylon, 15 mm
4792-13	78-8052-6566-3	Washer – Friction
4792-14	78-8052-6567-1	Spring – Compression
4792-15	78-8094-6370-2	Bushing – Applying Roller
4792-16	78-8094-6153-2	Roller – Applying
4792-17	26-1003-5829-5	Screw – Hex Hd, M6 x 12

replaced by 78-8137-1393-6 -  
apply roller w/ bushing  
included

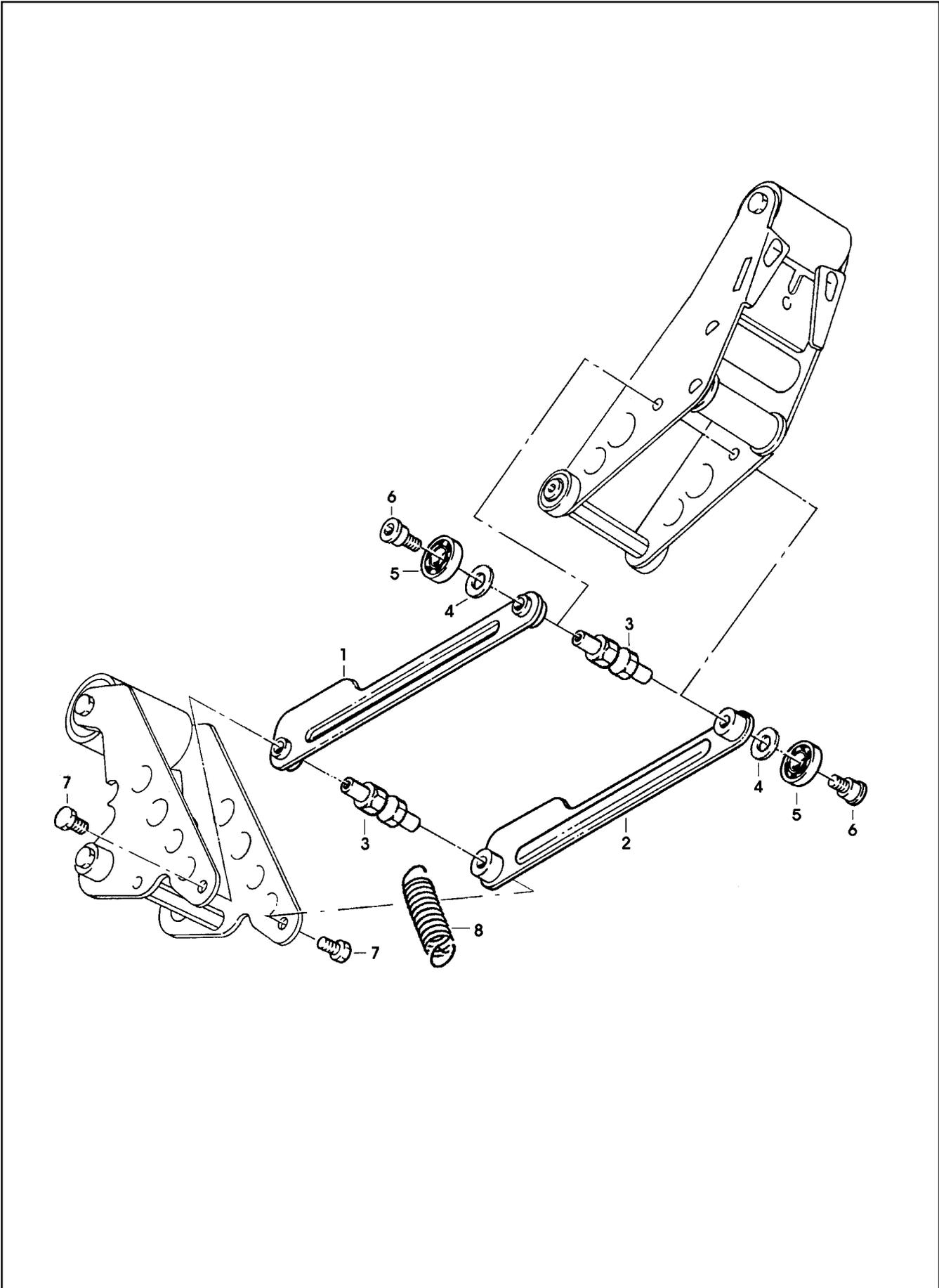


Figure 4794 – Lower Head

## Figure 4794 – Lower Head

Ref. No.	3M Part No.	Description
4794-1	78-8070-1388-9	Link – Arm Bushing Assembly
4794-2	78-8070-1389-7	Link – Arm Bushing Assembly
4794-3	78-8094-6158-1	Shaft - Pivot
4794-4	78-8094-6151-6	Washer
4794-5	78-8017-9082-1	Bearing – Special, 30 mm
4794-6	78-8017-9106-8	Screw – Bearing Shoulder
4794-7	26-1003-5828-7	Screw – Hex Hd, Special, M6 x 10
4794-8	78-8098-9095-3	Spring – Extension

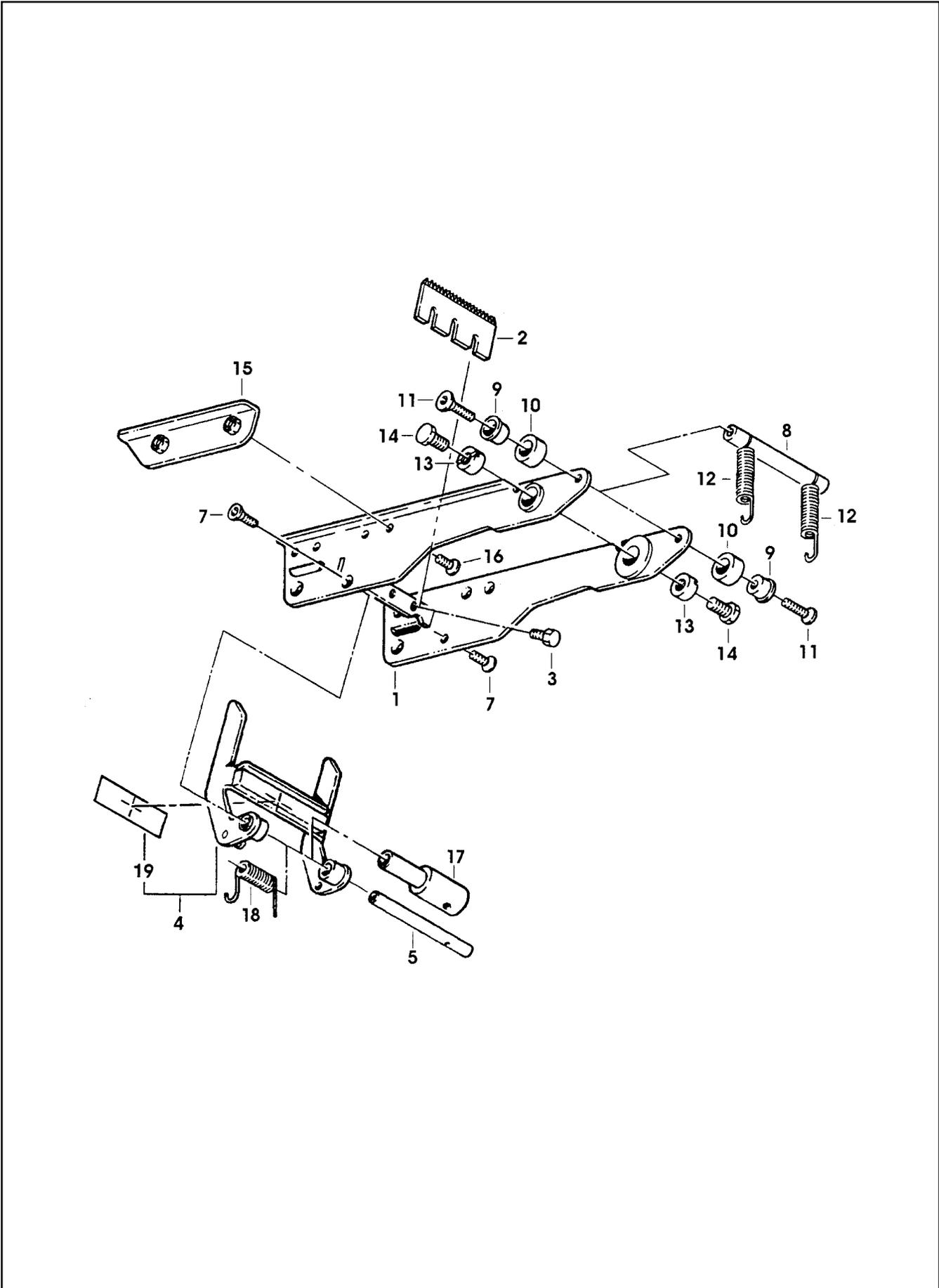


Figure 4795 – Lower Head

## Figure 4795 – Lower Head

Ref. No.	3M Part No.	Description
4795-1	78-8094-6159-9	Frame – Cut-Off Weldment
4795-2	78-8017-9173-8	Knife – 2.56 Inch (65 mm)
4795-3	26-1002-5817-2	Screw – Hex Hd, M5 x 8
4795-4	78-8113-6821-2	Guard – Blade, W/English Language Label
4795-5	78-8094-6161-5	Shaft – Knife Guard
4795-7	26-1005-4758-2	Screw – Flat Hd, M4 x 10
4795-8	78-8094-6162-3	Shaft – Spring
4795-9	78-8052-6600-0	Spacer
4795-10	78-8070-1269-1	Bumper
4795-11	26-1005-4757-4	Screw – Flat Hd, M5 x 20
4795-12	78-8052-6602-6	Spring – Cutter
4795-13	78-8017-9132-4	Pivot – Cutter Lever
4795-14	26-1003-5828-7	Screw – Hex Hd, M6 x 10
4795-15	78-8070-1216-2	Slide – Extension
4795-16	26-1008-6574-5	Screw – Flat Hd, Phillips Dr, M4 x 10
4795-17	78-8113-7067-1	Bushing – 47.7 mm Long
4795-18	78-8113-7030-9	Spring – Torsion
4795-19	78-8070-1335-0	Label – Warning, English

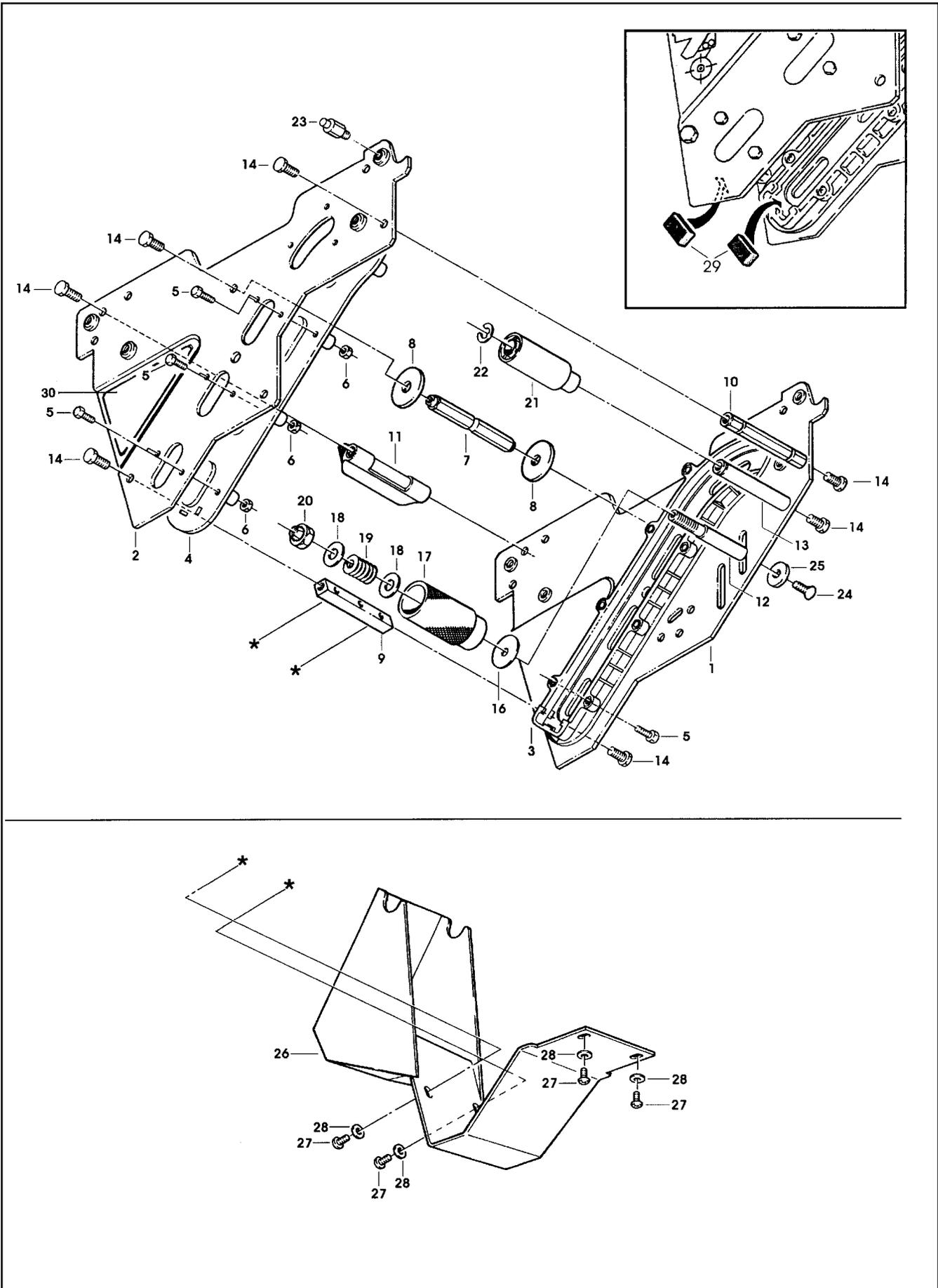


Figure 4797 – Lower Head

## Figure 4797 – Lower Head

Ref. No.	3M Part No.	Description
4797-1	78-8070-1369-9	Frame – Tape Mount Lower Assembly
4797-2	78-8070-1370-7	Frame – Front Lower Assembly
4797-3	78-8068-4144-7	Guide – #2
4797-4	78-8068-4143-9	Guide – #1
4797-5	83-0002-7336-3	Screw – Hex Hd, M4 x 14
4797-6	78-8010-7416-8	Nut – Hex, M4
4797-7	78-8094-6132-6	Spacer – Spring
4797-8	78-8076-5242-1	Stop – Cut-Off Frame
4797-9	78-8094-6140-9	Spacer
4797-10	78-8094-6134-2	Spacer – Hex
4797-11	78-8094-6135-9	Brush Assembly
4797-12	78-8094-6136-7	Shaft
4797-13	78-8094-6137-5	Shaft – Roller
4797-14	26-1003-5829-5	Screw – Hex Hd, M6 x 12
4797-15	78-8042-2919-9	Washer – Triple, M6
4797-16	78-8100-1009-6	Washer – Special
4797-17	78-8100-0858-7	Roller – Tension
4797-18	78-8052-6566-3	Washer – Friction
4797-19	78-8052-6567-1	Spring – Compression
4797-20	78-8017-9077-1	Nut – Self-Locking, M10 x 1
4797-21	78-8094-6139-1	Roller – Wrap
4797-22	26-1000-1613-3	Ring – Retaining, 10DIN6779
4797-23	78-8094-6168-0	Stud – Mounting
4797-24	78-8060-8179-6	Screw – Flat Hd Hex, M6 x 20
4797-25	78-8076-5477-3	Washer – Special, 6.5 x 20 x 4
4797-26	78-8100-1126-8	Cover – Lower
4797-27	78-8060-8087-1	Screw – M5 x 10
4797-28	78-8005-5741-1	Washer – Flat, M5
4797-29	78-8076-4734-8	Bumper
4797-30	78-8070-1364-0	Label – Threading

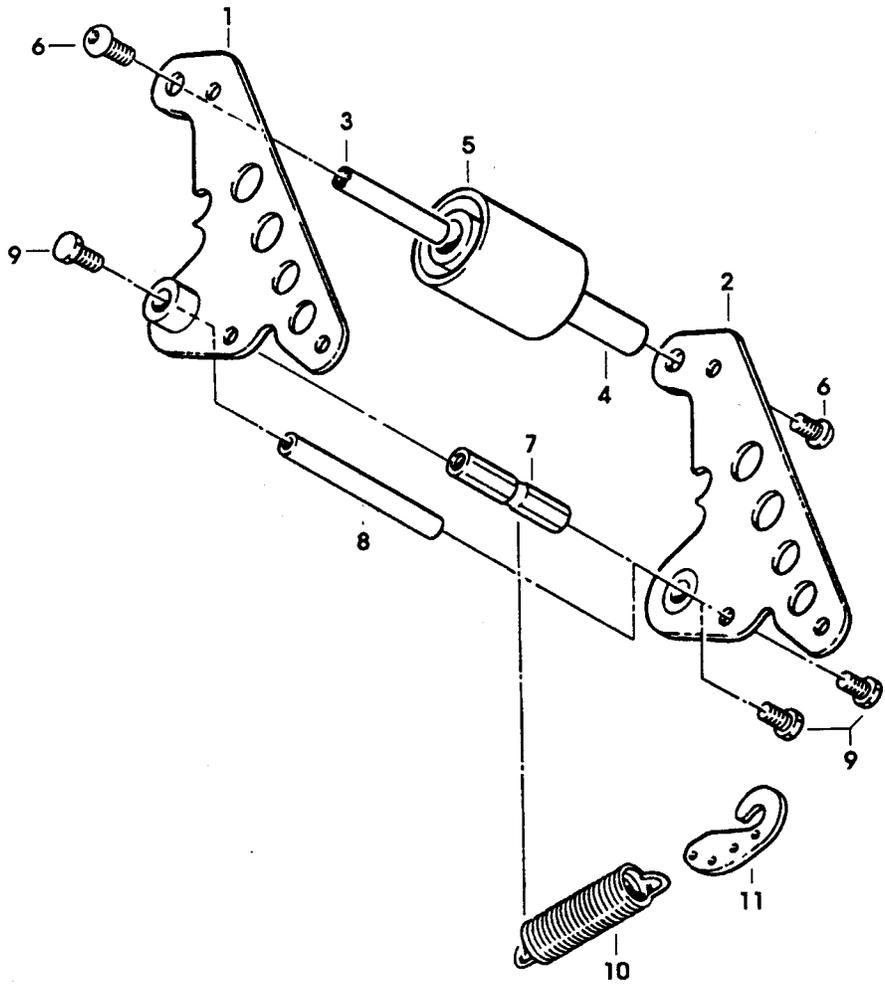


Figure 4798 – Lower Head

## Figure 4798 – Lower Head

Ref. No.	3M Part No.	Description
4798-1	78-8070-1392-1	Buffing Arm Sub Assembly
4798-2	78-8070-1391-3	Buffing Arm Sub Assembly
4798-3	78-8094-6152-4	Shaft – /10 x 48
4798-4	78-8094-6154-0	Bushing – Buffing Roller
4798-5	78-8094-6155-7	Roller – Buffing
4798-6	78-8076-4503-7	Screw – M6 x 12
4798-7	78-8094-6156-5	Spacer – Spring
4798-8	78-8094-6157-3	Shaft – /10 x 78
4798-9	26-1003-5828-7	Screw – Hex Hd, M6 x 12
4798-10	78-8070-1273-3	Spring – Lower (Black)
4798-11	78-8070-1244-4	Holder – Spring

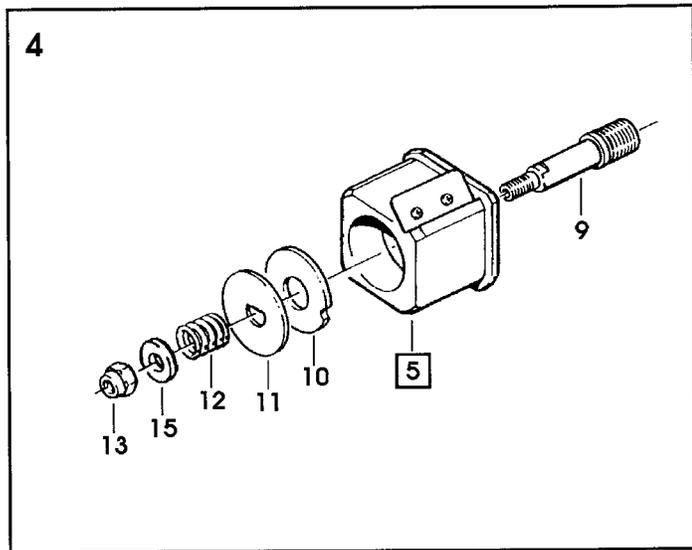
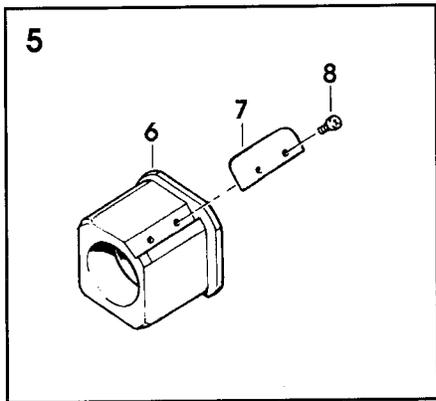
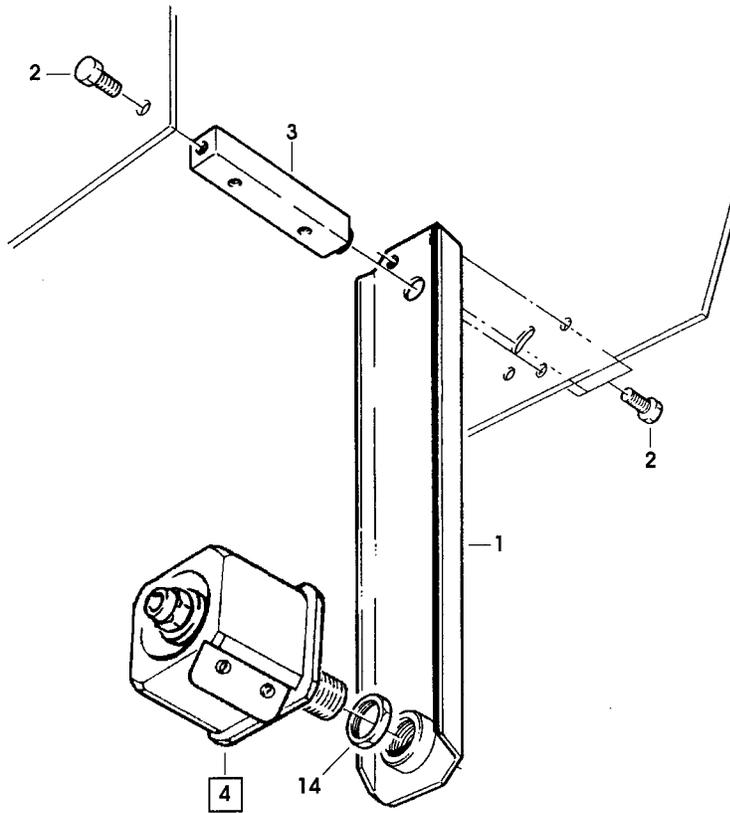


Figure 4799 – Lower Head

## Figure 4799 – Lower Head

Ref. No.	3M Part No.	Description
4799-1	78-8070-1395-4	Bracket – Bushing Assembly
4799-2	26-1003-5829-5	Screw – Hex Hd, M6 x 12
4799-3	78-8100-1051-8	Spacer – Guard
4799-4	78-8060-8474-1	Tape Drum Assembly – 2 Inch Head
4799-5	78-8070-1569-4	Tape Drum Sub Assembly – 2 Inch Wide
4799-6	78-8052-6749-5	Tape Drum
4799-7	78-8052-6268-6	Leaf Spring
4799-8	26-1002-5753-9	Screw – Self-Tapping
4799-9	78-8076-4519-3	Shaft – Tape Drum
4799-10	78-8060-8172-1	Washer – Friction
4799-11	78-8052-6271-0	Washer – Tape Drum
4799-12	78-8100-1048-4	Spring – Core Holder
4799-13	78-8017-9077-1	Nut – Self-Locking, M10 x 1
4799-14	78-8017-9169-6	Nut – M18 x 1
4799-15	26-1004-5510-9	Washer – Plain, M10