



## Instructions and Parts List

# AccuGlide™ II

## STD 3 Inch

## Upper and Lower

## Taping Heads

Type 29000

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

For reference, record taping head(s) serial number(s) here.

**3M Masking and Packaging Systems Division**

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



### Important Safety Information

Read "Warning and Information Labels", 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.

"AccuGlide" is a Trademark of 3M, St. Paul, MN 55144-1000

Li-ho in U.S.A

© 3M 1996 44-0009-1856-3(E46.05)

# 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**

"3M-Matic", "AccuGlide" and "Scotch" are trademarks of 3M, St. Paul, Minnesota 55144-1000

Printed in U.S.A.

© 3M 1999 44-0009-1851-4(E79.0)

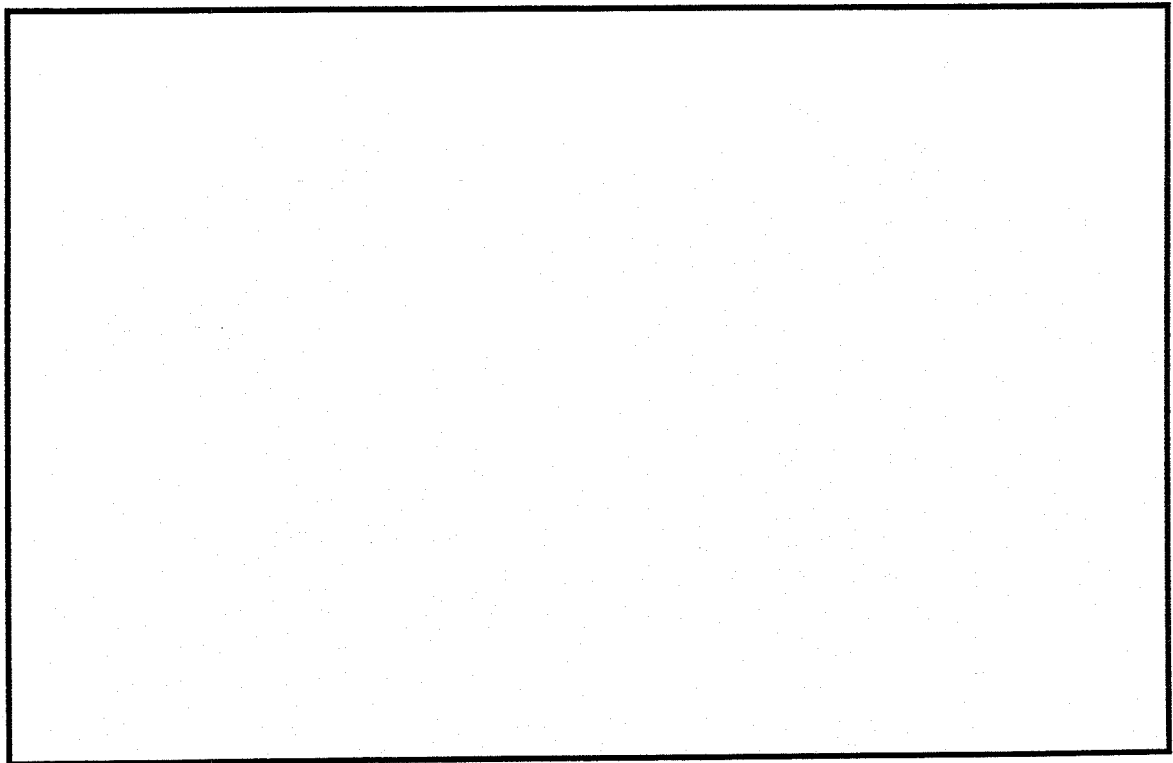


## To Our Customers:

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

"3M-Matic", "AccuGlide" and "Scotch" are trademarks  
of 3M, St. Paul, Minnesota 55144-1000

Printed in U.S.A.

© 3M 1999 44-0009-1852-2(D79.0)



# Instruction Manual

AccuGlide™ II STD 3 Inch  
Upper and Lower Taping Heads  
Type 29000

| Table of Contents  | Page                   |
|--|------------------------|
| Equipment Warranty and Limited Remedy .....                      | ii                     |
| Taping Head Contents .....                                       | ii                     |
| Description .....  | 1                      |
| Warning and Information Labels .....                             | 2                      |
| Specifications .....   | 3 - 4                  |
| Dimensional Drawing .....  | 4                      |
| Installation .....   | 5                      |
| Receiving and Handling .....                                     | 5                      |
| Installation Guidelines .....                                    | 5                      |
| Tape Leg Length .....  | 5                      |
| Tape Width .....   | 5                      |
| Operation .....  | 6 - 8                  |
| Tape Loading – Upper Taping Head .....                           | 7 - 8                  |
| Tape Loading – Lower Taping Head .....                           | 7 - 8                  |
| Maintenance .....  | 9 - 10                 |
| Blade Replacement .....  | 9                      |
| Blade Oiler Pad .....  | 9                      |
| Cleaning .....   | 10                     |
| Lubrication .....  | 10                     |
| Adjustments .....  | 11 - 13                |
| Tape Web Alignment .....   | 11                     |
| Tape Drum Friction Brake .....                                   | 11                     |
| Applying Mechanism Spring .....                                  | 12                     |
| One-Way Tension Roller .....                                     | 12                     |
| Tape Leg Length .....  | 13                     |
| Leading Tape Leg Length Adjustment .....                         | 13                     |
| Changing Tape Leg Length From 70 to 50 mm [2.75 to 2 Inch] ..... | 13                     |
| Troubleshooting .....  | 15 - 16                |
| Troubleshooting Guide .....                                      | 15 - 16                |
| Spare Parts/Service Information .....                            | 17                     |
| Recommended Spare Parts .....                                    | 17                     |
| Replacement Parts and Service .....                              | 17                     |
| Replacement Parts Illustrations and Parts List .....             | Yellow Section 18 - 35 |

**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 3 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

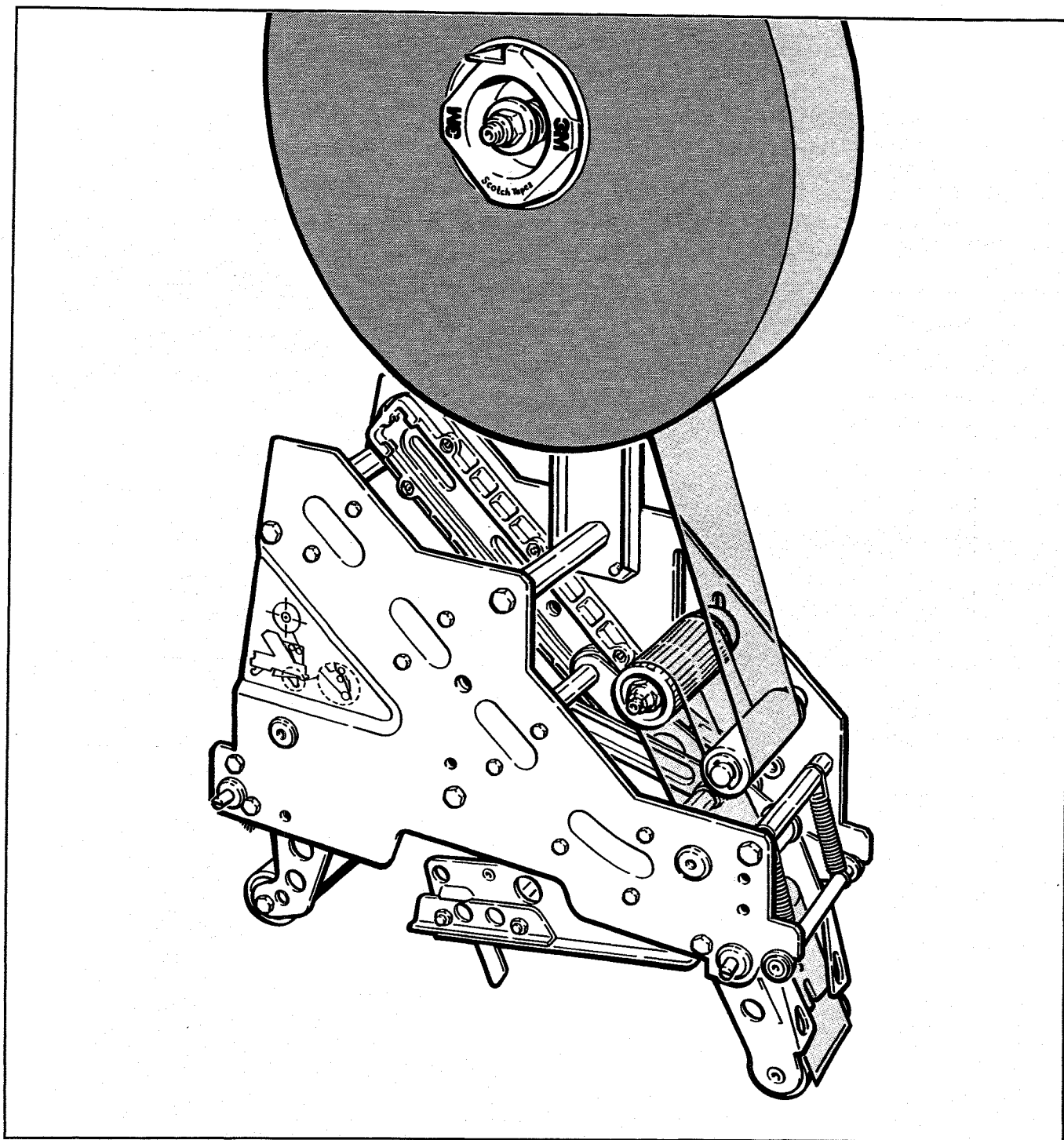
**AccuGlide™II STD 3 Inch Upper Taping Head consists of:**

| 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 3 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                 |

AccuGlide™, Scotch™, and 3M-Matic™ are Trademarks of 3M, St. Paul, Minnesota 55144-1000



**AccuGlide™ II STD 3 Inch Upper Taping Head, Type 29000**

## **Description**

The **AccuGlide™ II STD 3 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.**

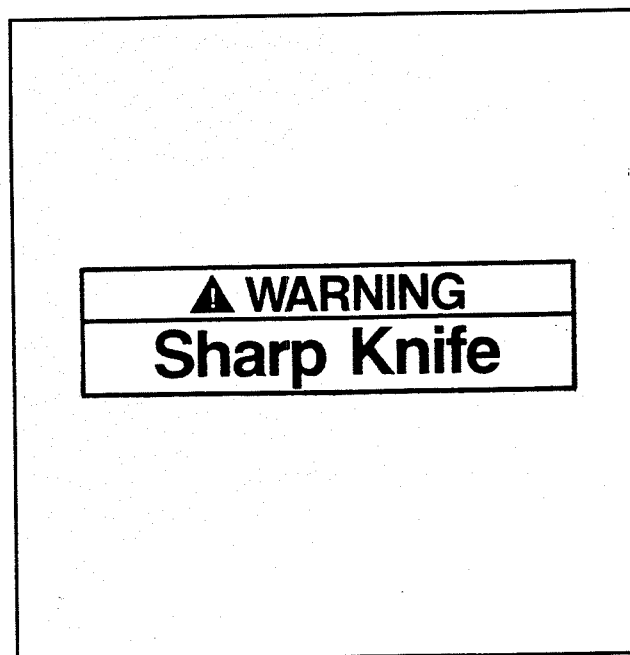


Figure 1-1 – Knife Warning Label

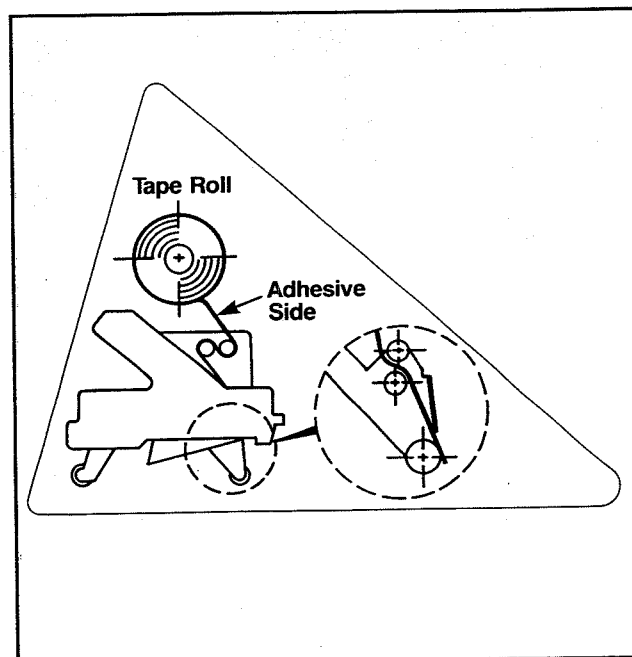


Figure 1-2 – Tape Threading Label



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:

48 mm [2 inches] minimum to 72 mm (3 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 [2.75 inches  $\pm$  .25 inch]

### Tape Application Leg Length - Optional:

50 mm  $\pm$  6 mm [2 inches  $\pm$  .25 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 [4.75 inches] (most “3M-Matic” Case Sealers)<br>90 mm [3.50 inches] (with optional 2 inch leg length) |  | Limited by<br>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 [15.75 inches]                                   |
| Height | – | 560 mm [22 inches] (with tape drum)                     |
| Width  | – | 130 mm [5.18 inches] (without mounting spacers)         |
| Weight | – | Packaged: 8.6 kg [19 lbs.] Unpackaged: 7.7 kg [17 lbs.] |

## Specifications

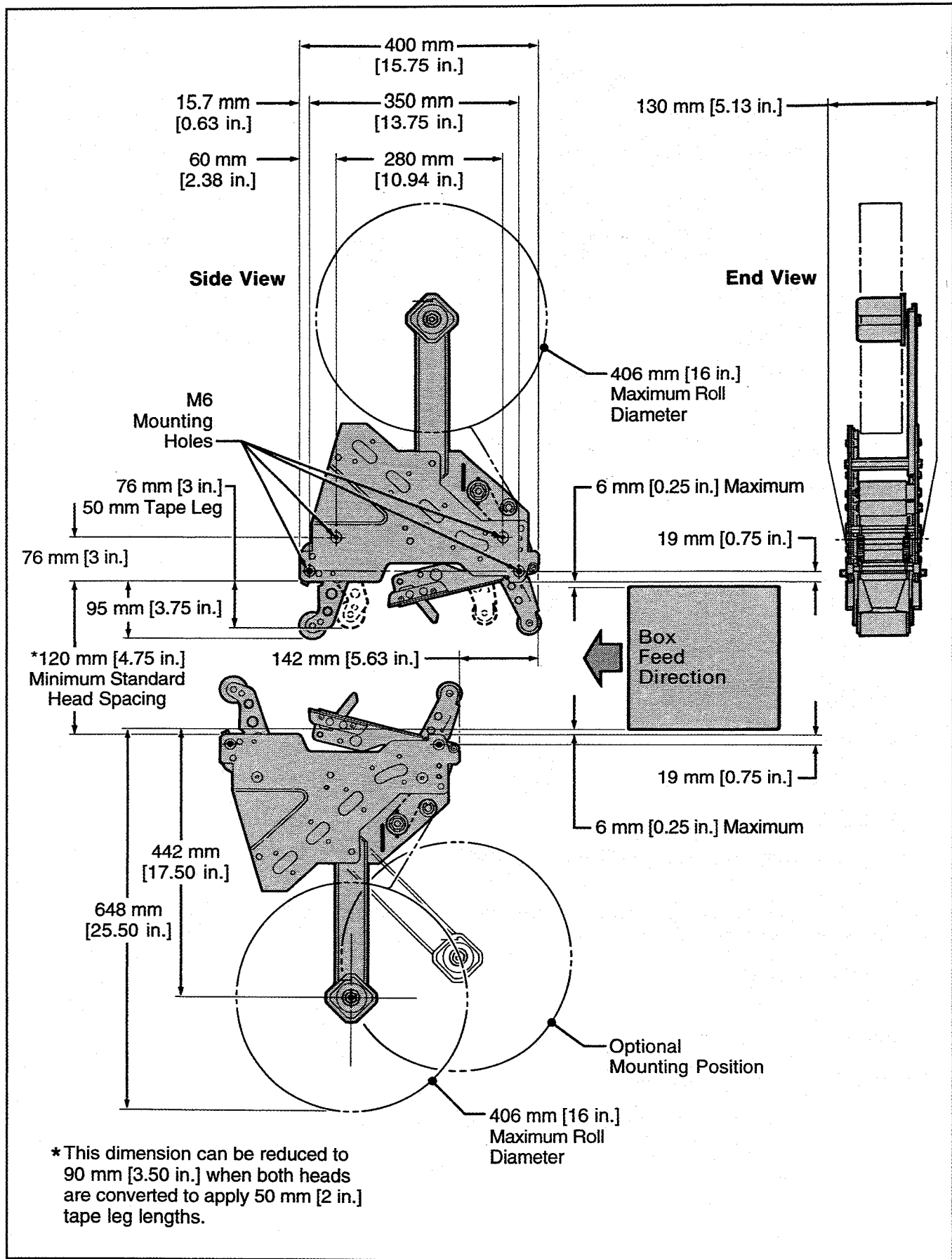


Figure 2-1 – Dimensional Drawing

# Installation



**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 [3.50 inches]. **To tape box heights down to 70 mm [2.75 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 [.25 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 [2.75 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 [2.75 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 72 mm (3 inch) wide tape. To apply narrower tapes, refer to "Adjustments – Tape Web Alignment", page 11 for set-up procedure.

## Operation

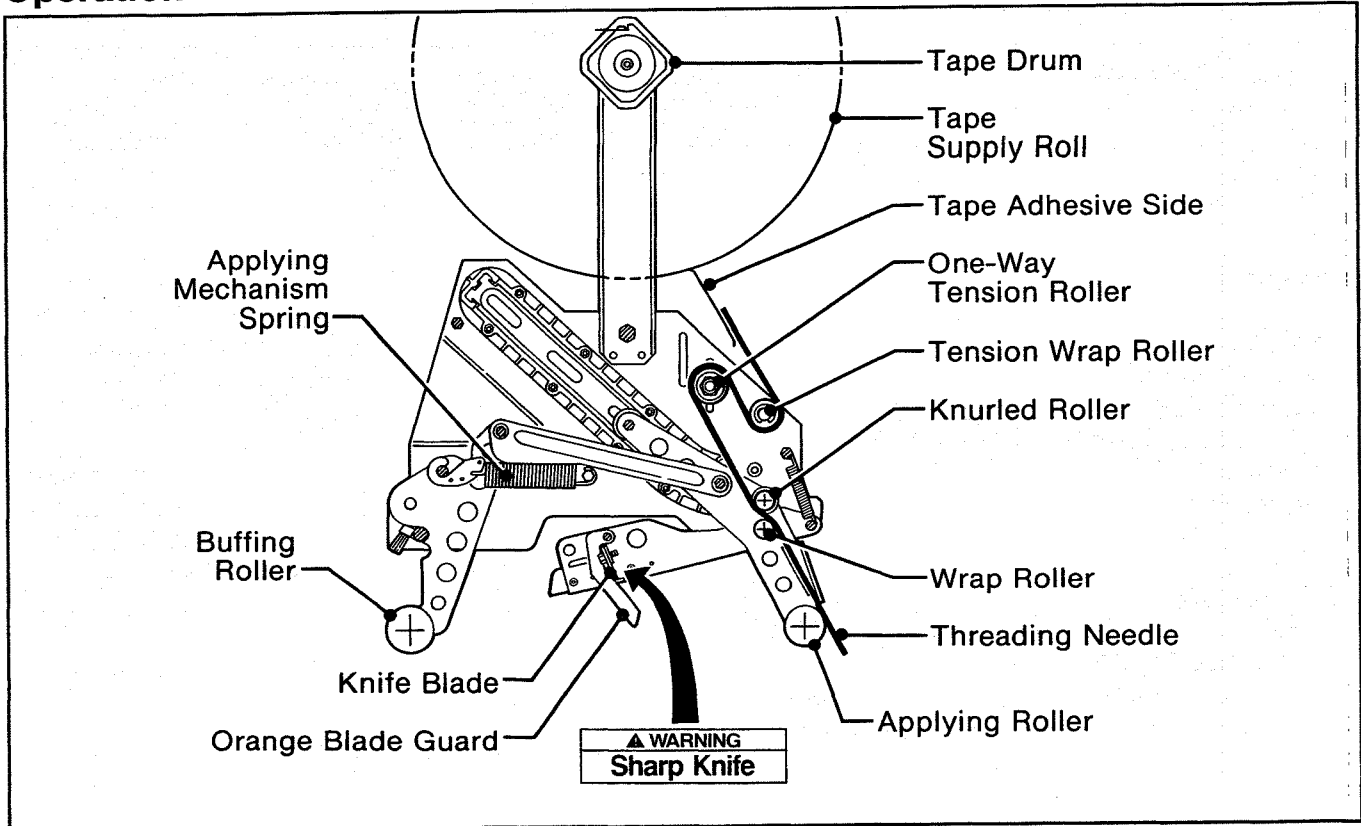


Figure 3-1 – Taping Head Components/Threading Diagram, Upper Head (Left Side View)

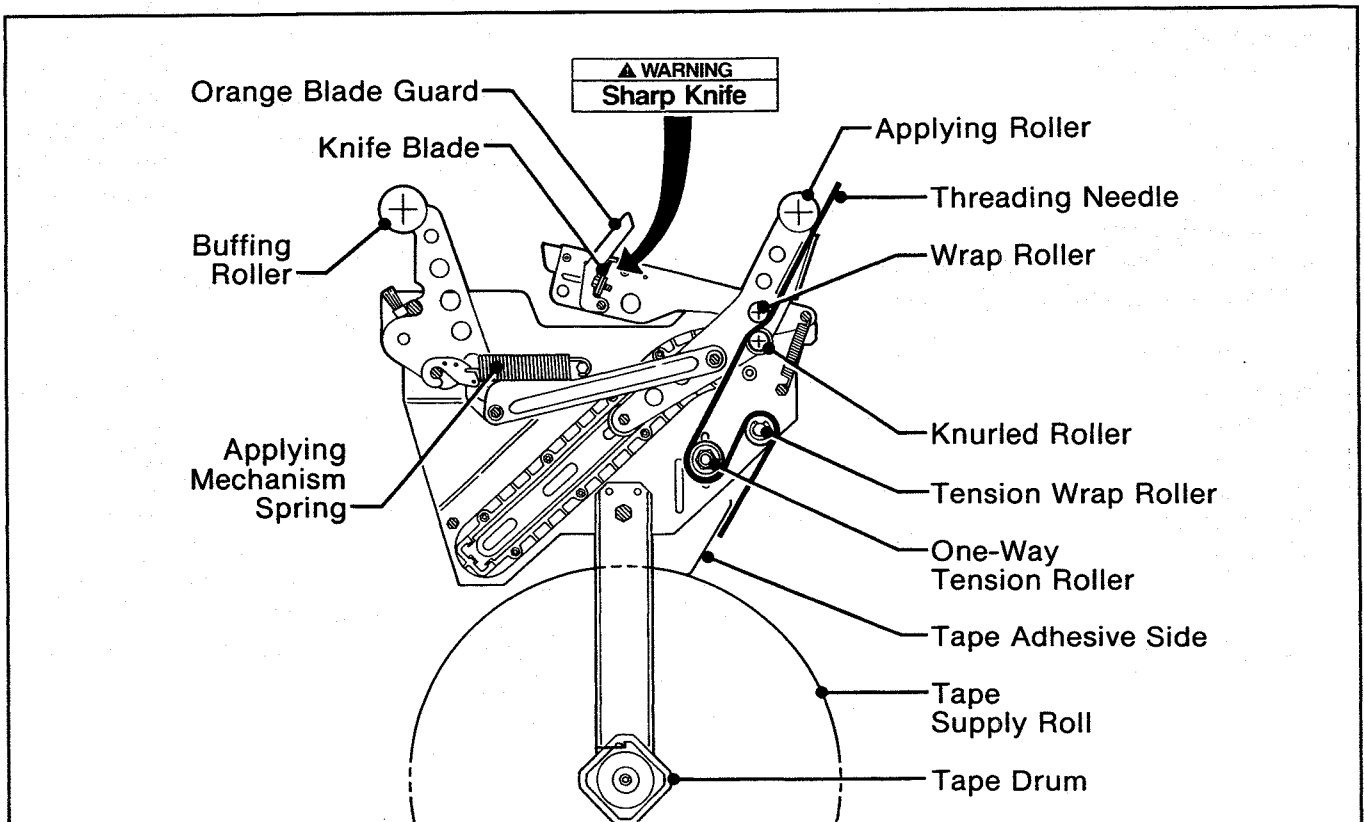


Figure 3-2 – Taping Head Components/Threading Diagram – Lower Head (Left Side View)

## 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

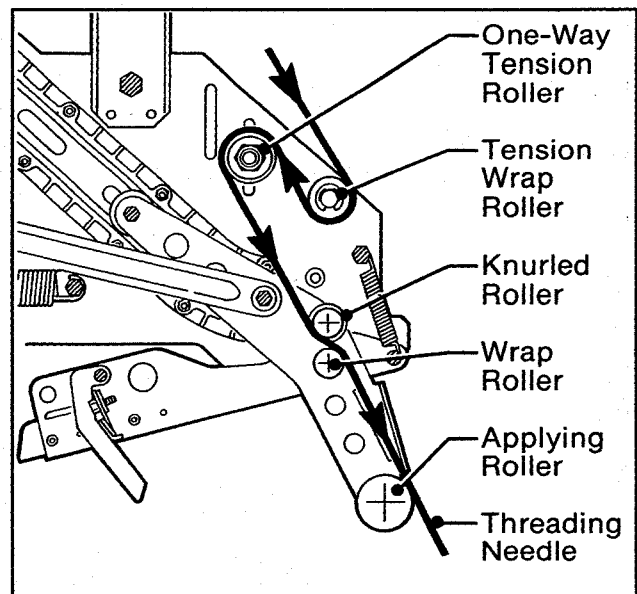
1. For ease in loading, first remove the lower taping head from the conveyor bed.
2. The lower taping head is loaded and threaded in the same manner as the upper head. Follow the upper taping head tape loading/threading procedure.

**Figure 3-3**

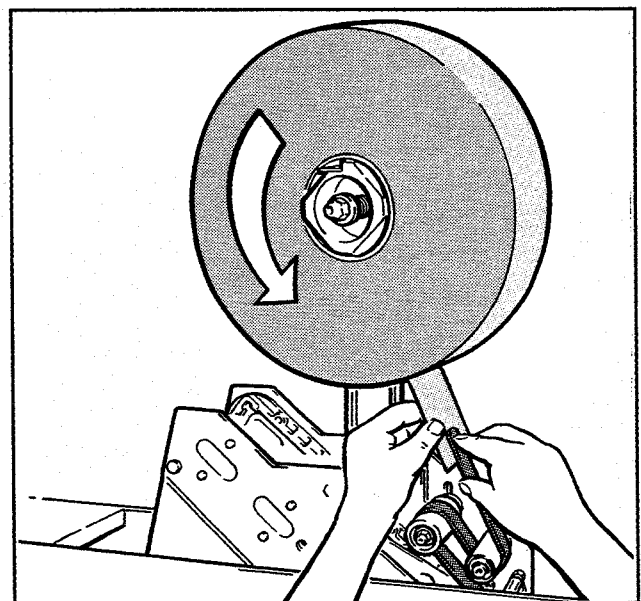
Insert threading needle through rollers in direction indicated by arrows.

**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.

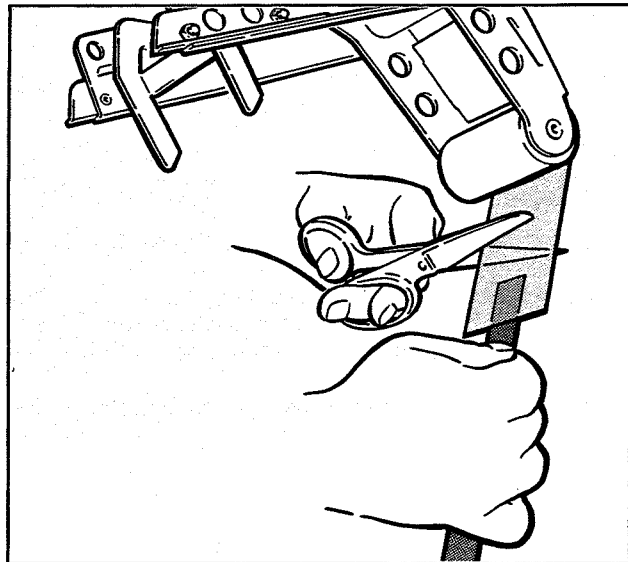


Figure 3-5 – Tape Loading/Threading

## 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 3 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.

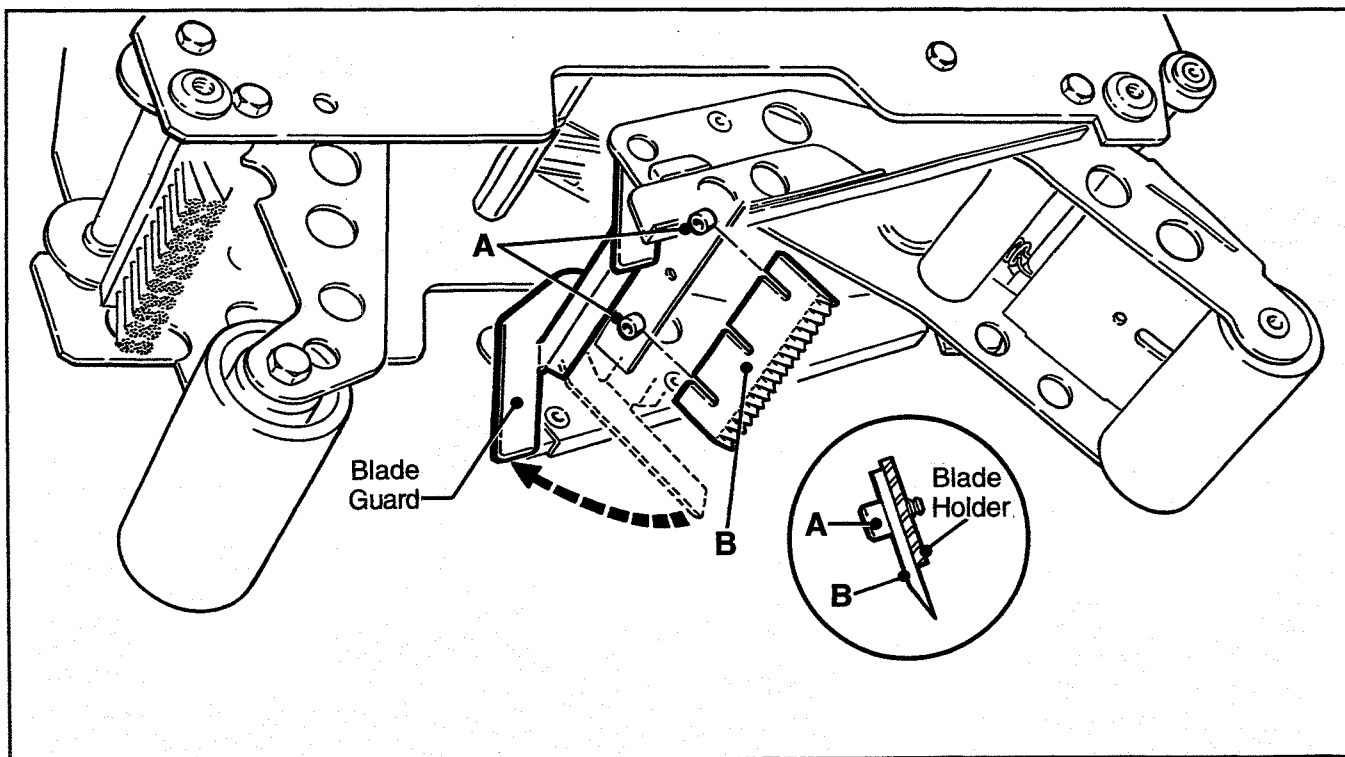


Figure 4-1 – Blade Replacement





### 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.

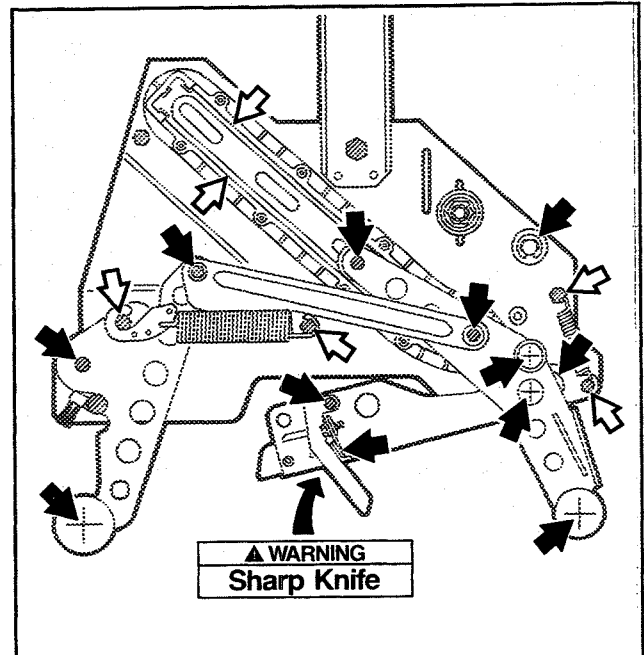


Figure 4-2 – Lubrication Points, Upper and Lower Taping Heads

### 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.

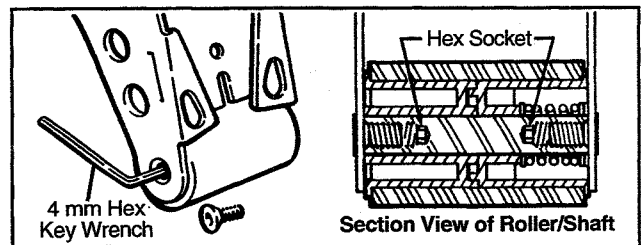


Figure 4-3 – Section View of Roller Shaft

## 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 72 mm [3 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.

**Note** – To set up 72 mm tape drum for 48 mm tape, disassemble tape drum from bracket and install lock nut between tape drum and bracket as shown in inset, Figure 5-2.

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 5-2

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.

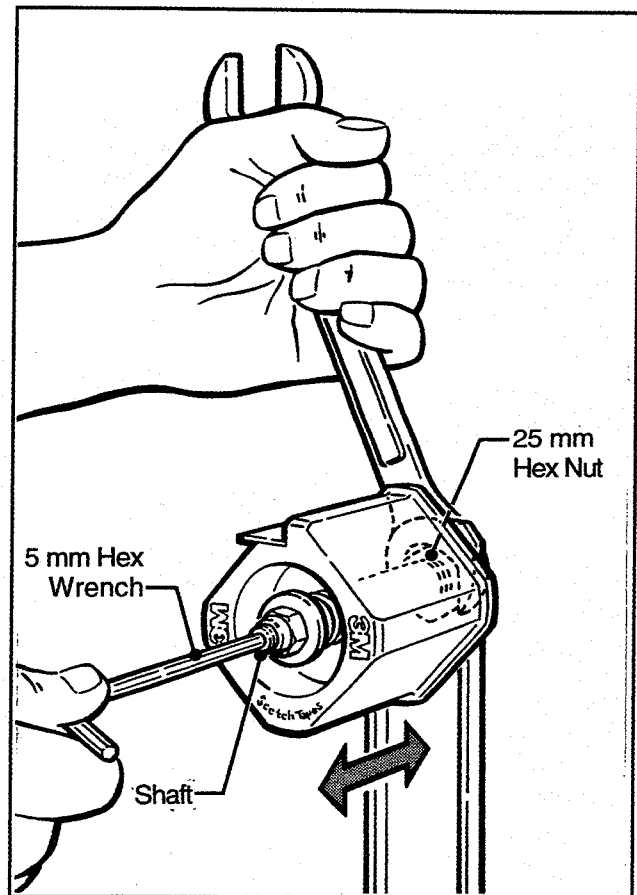


Figure 5-1 – Tape Web Alignment

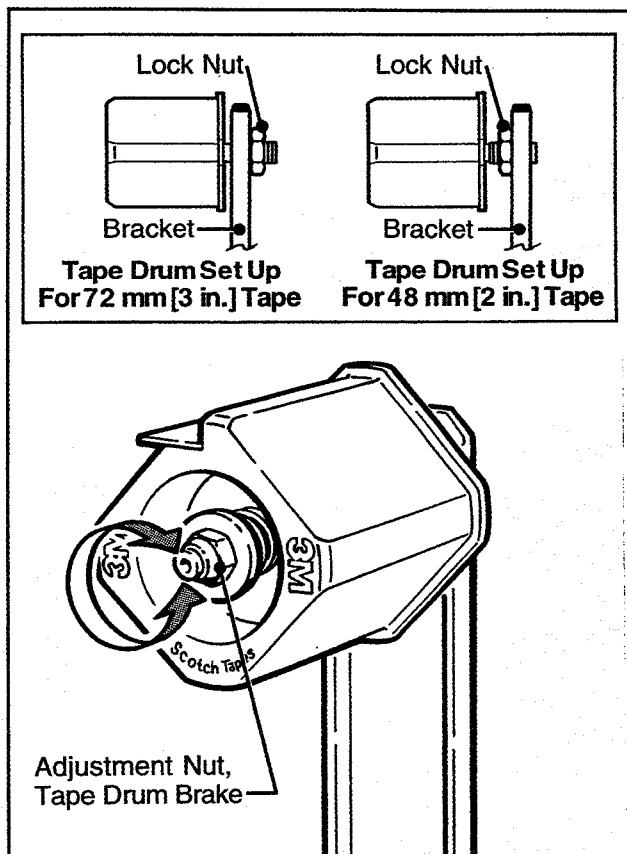


Figure 5-2 – Tape Drum Friction Brake

## Adjustments (Continued)



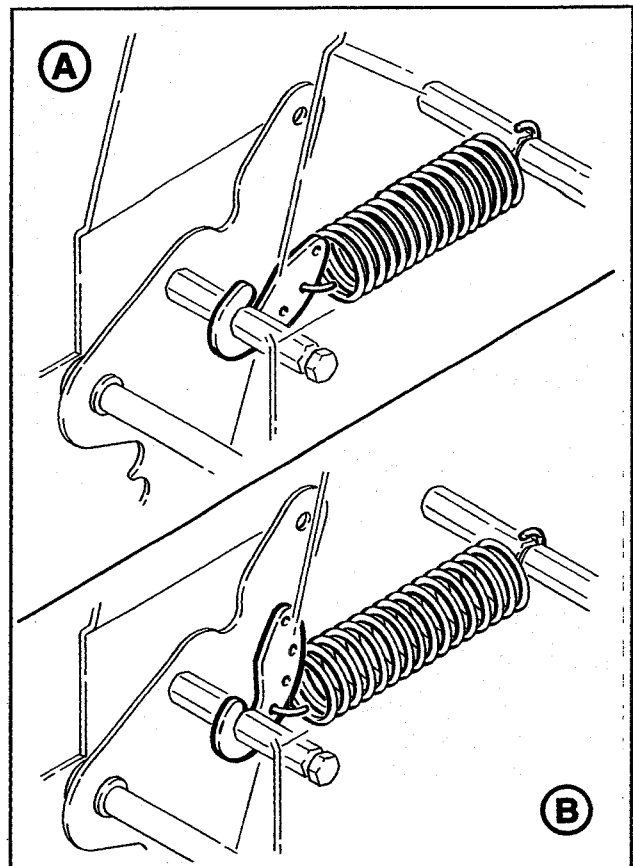
**WARNING** – Turn air and electrical supplies off and disconnect before beginning adjustments. Failure to comply with this warning could result in severe personal injury and/or equipment damage.

### 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**

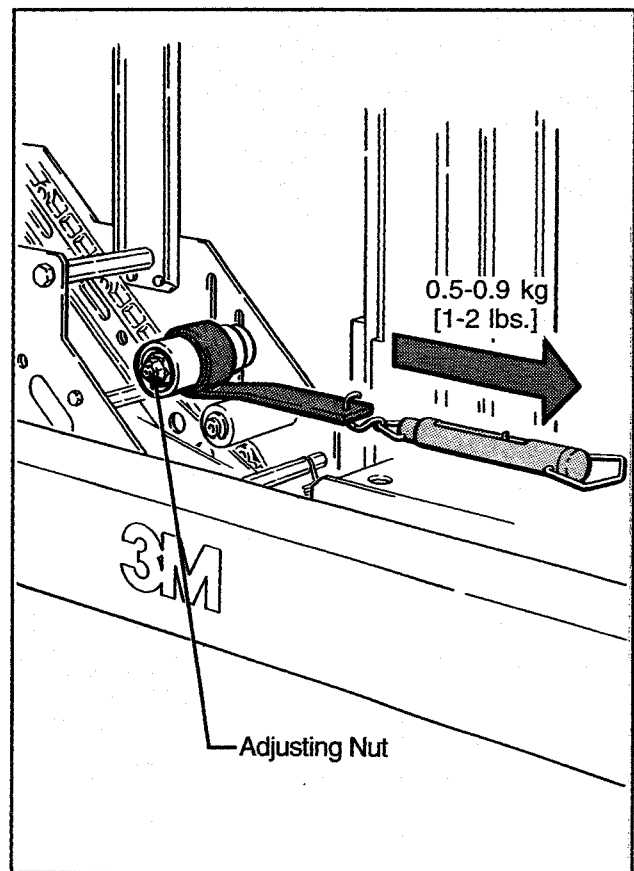
### One-Way Tension Roller

**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

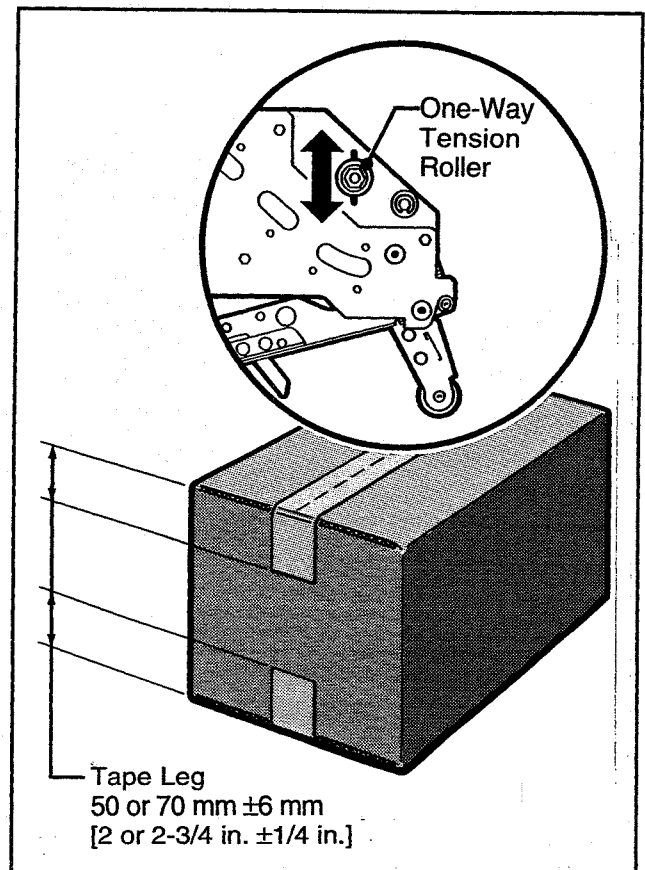
The one-way tension roller position is adjustable to control the leading tape leg length.

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.

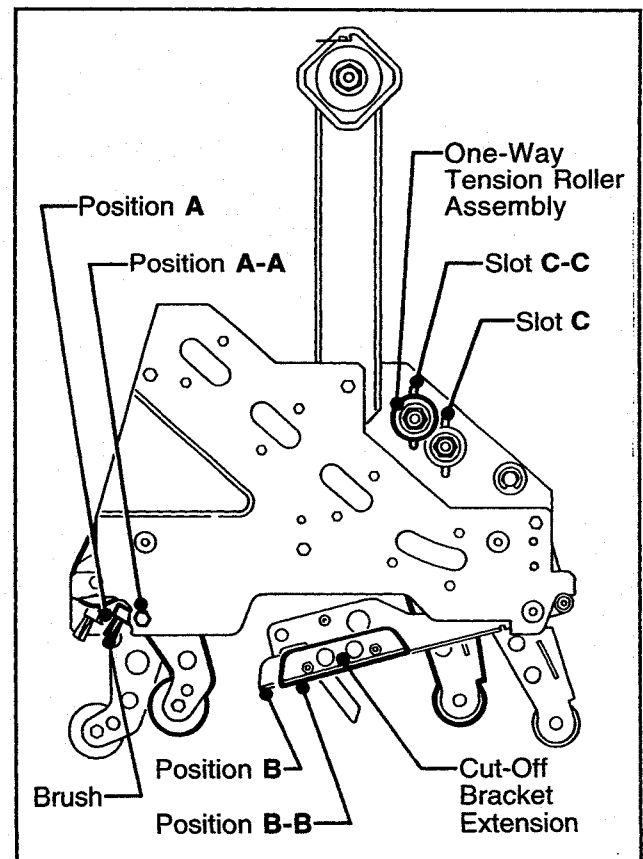
#### CHANGING TAPE LEG LENGTH FROM 70 to 50 mm [2.75 TO 2 INCHES] – Figure 5-6

**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**

**THIS PAGE IS BLANK**

# 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 3 Inch Upper Taping Head

| Qty. | Ref. No. | Part Number    | Description                       |
|------|----------|----------------|-----------------------------------|
| 4    | 2948-22  | 78-8076-4500-3 | Stud – Mounting                   |
| 1    | 2950-10  | 78-8070-1274-1 | Spring – Upper Extension (Silver) |
| 1    | 2952-2   | 78-8028-7899-7 | Blade – 89 mm/3.5 Inch            |
| 2    | 2952-12  | 78-8052-6602-6 | Spring – Cutter                   |
| 1    | –        | 78-8017-9433-6 | Tool – Tape Threading             |

#### AccuGlide™ II STD 3 Inch Lower Taping Head

| Qty. | Ref. No. | Part Number    | Description                      |
|------|----------|----------------|----------------------------------|
| 1    | 2952-2   | 78-8028-7899-7 | Blade – 89 mm/3.5 Inch           |
| 2    | 2952-12  | 78-8052-6602-6 | Spring – Cutter                  |
| 4    | 2952-22  | 78-8076-4500-3 | Stud – Mounting                  |
| 1    | 2955-10  | 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    | 2949-15  | 78-8057-6181-0 | Roller – Applying |
| 1    | 2952-6   | 78-8070-1390-5 | Spring – Torsion  |
| 1    | 2955-5   | 78-8057-6180-2 | Roller – Buffing  |

### 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 3 Inch Upper Taping Head, Type 29000**

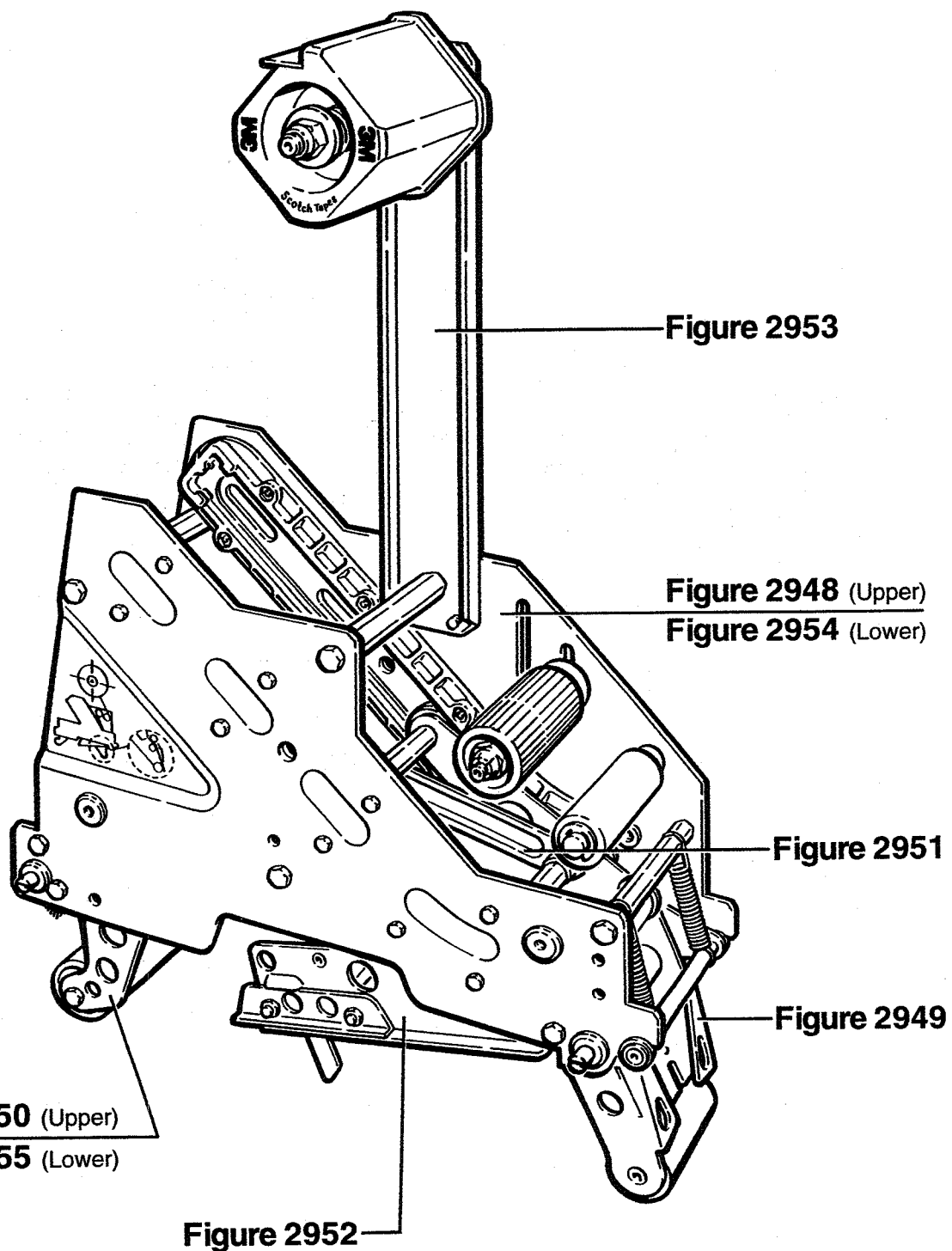
### **AccuGlide II STD 3 Inch Lower Taping Head, Type 29000**

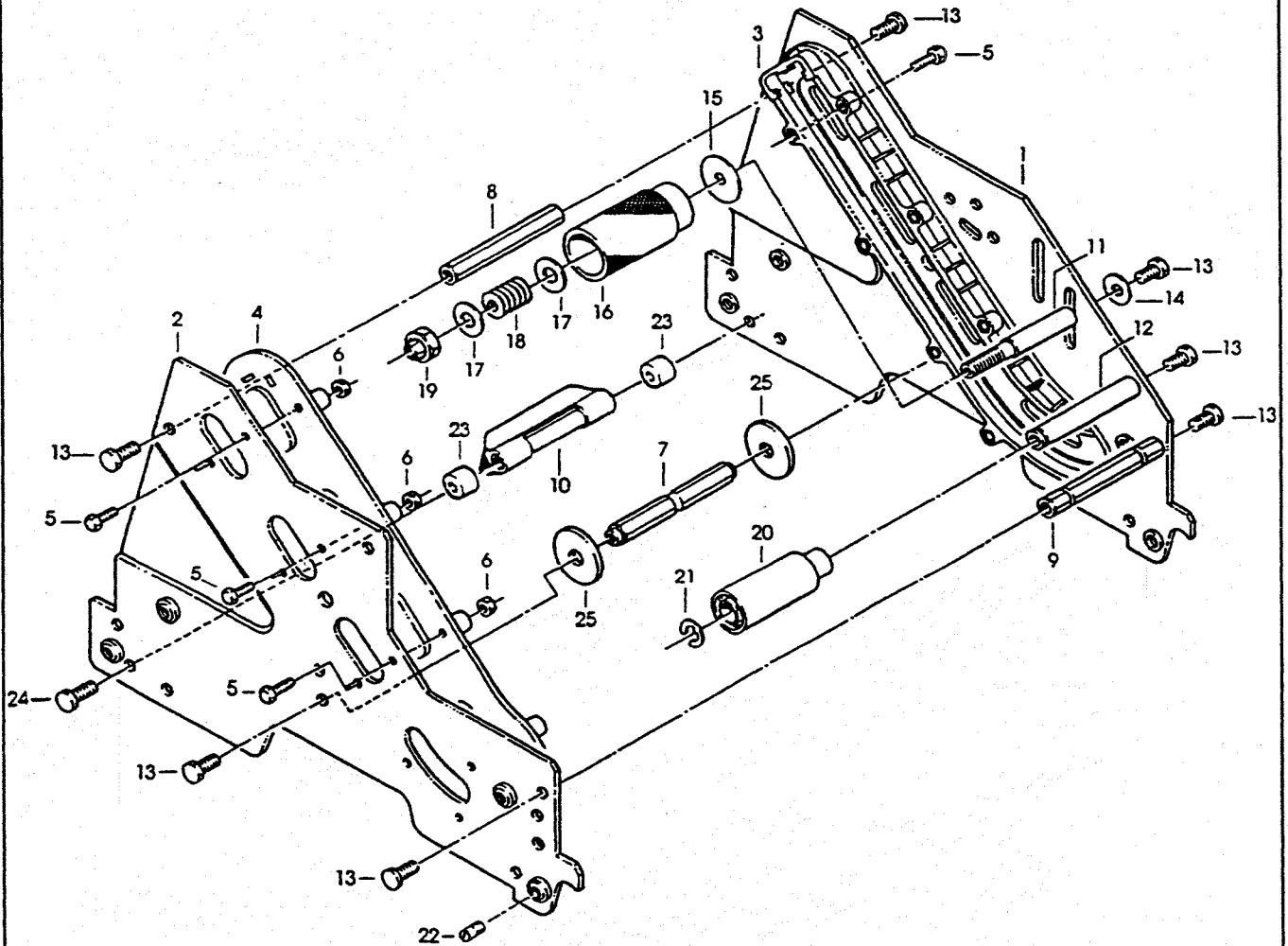
1. Refer to **Taping Head Assemblies** Figure, page 19 to find all the parts illustrations identified by **figure numbers**.
2. Refer to the figure or figures to determine the **individual parts** required and the **parts reference number**.
3. The **replacement parts list**, that follows each illustration, 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. Order parts by part number, part description and quantity required. Also include machine name, number and type.
5. 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.





**Figure 2948 – Upper Head**

## Figure 2948 – Upper Head

---

|         |                |                                   |
|---------|----------------|-----------------------------------|
| 2948-1  | 78-8070-1386-3 | Frame – Tape Mount Upper Assembly |
| 2948-2  | 78-8070-1387-1 | Frame – Front Upper Assembly      |
| 2948-3  | 78-8068-4143-9 | Guide – R/H                       |
| 2948-4  | 78-8068-4144-7 | Guide – L/H                       |
| 2948-5  | 83-0002-7336-3 | Screw – Hex Hd, M4 x 14           |
| 2948-6  | 78-8010-7416-8 | Nut – Hex M4, Metric              |
| 2948-7  | 78-8076-4735-5 | Spacer – L=115                    |
| 2948-8  | 78-8054-8793-7 | Spacer – Hexagonal                |
| 2948-9  | 78-8060-7939-4 | Spacer – 10 x 115, W/Slots        |
| 2948-10 | 78-8060-7936-0 | Brush Assembly                    |
| 2948-11 | 78-8054-8796-0 | Shaft – Tension Roller            |
| 2948-12 | 78-8054-8798-6 | Shaft – Wrap Roller               |
| 2948-13 | 26-1003-5829-5 | Screw – Hex Hd, M6 x 12           |
| 2948-14 | 78-8042-2919-9 | Washer – Triple, M6               |
| 2948-15 | 78-8070-1268-3 | Washer – Roll Back Up             |
| 2948-16 | 78-8054-8797-8 | Roller – Top Tension              |
| 2948-17 | 78-8052-6566-3 | Washer – Friction                 |
| 2948-18 | 78-8052-6567-1 | Spring – Compression              |
| 2948-19 | 78-8017-9077-1 | Nut – Self Locking, M10 x 1       |
| 2948-20 | 78-8054-8799-4 | Roller – Wrap                     |
| 2948-21 | 26-1000-1613-3 | Ring – Retaining, 10DIN6799       |
| 2948-22 | 78-8076-4500-3 | Stud – Mounting                   |
| 2948-23 | 78-8060-7937-8 | Spacer – /6,5/14 x 12,5           |
| 2948-24 | 78-8060-7938-6 | Screw – Special, M6 x 25          |
| 2948-25 | 78-8076-5242-1 | Stop – Cut-Off Frame              |

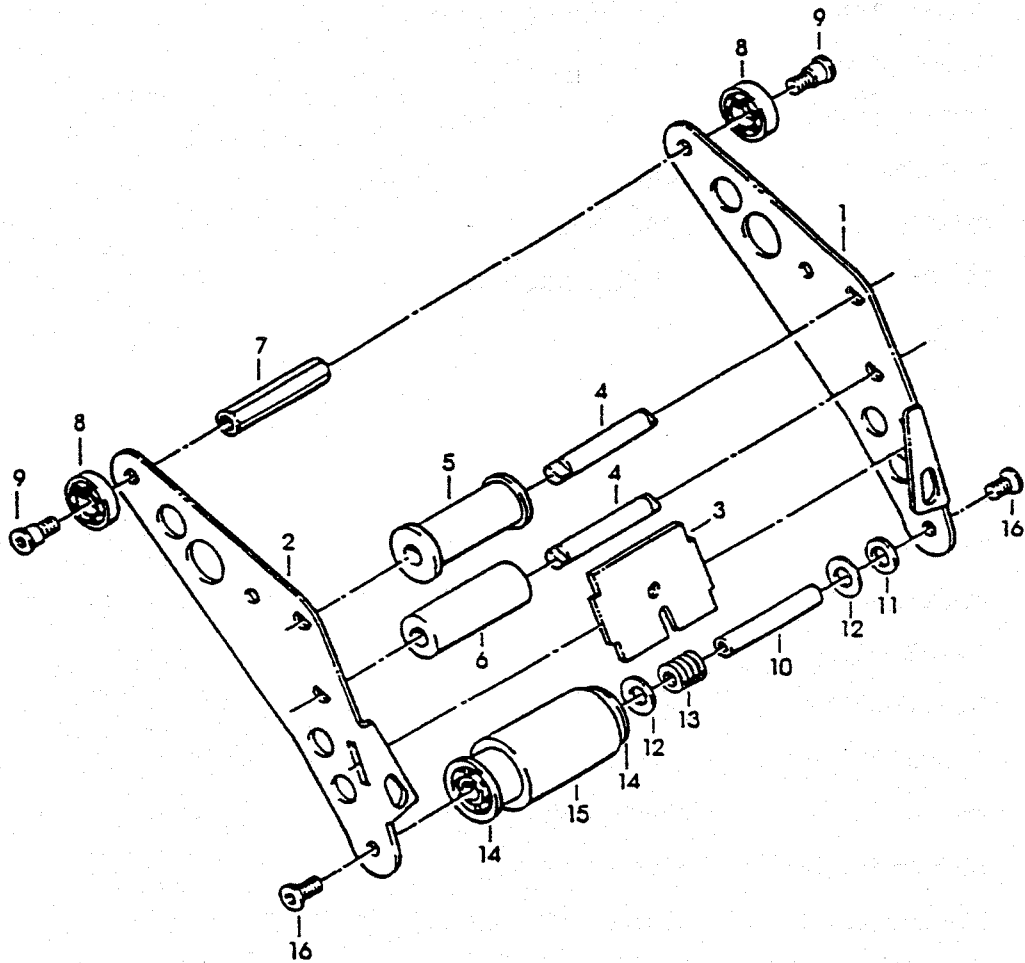
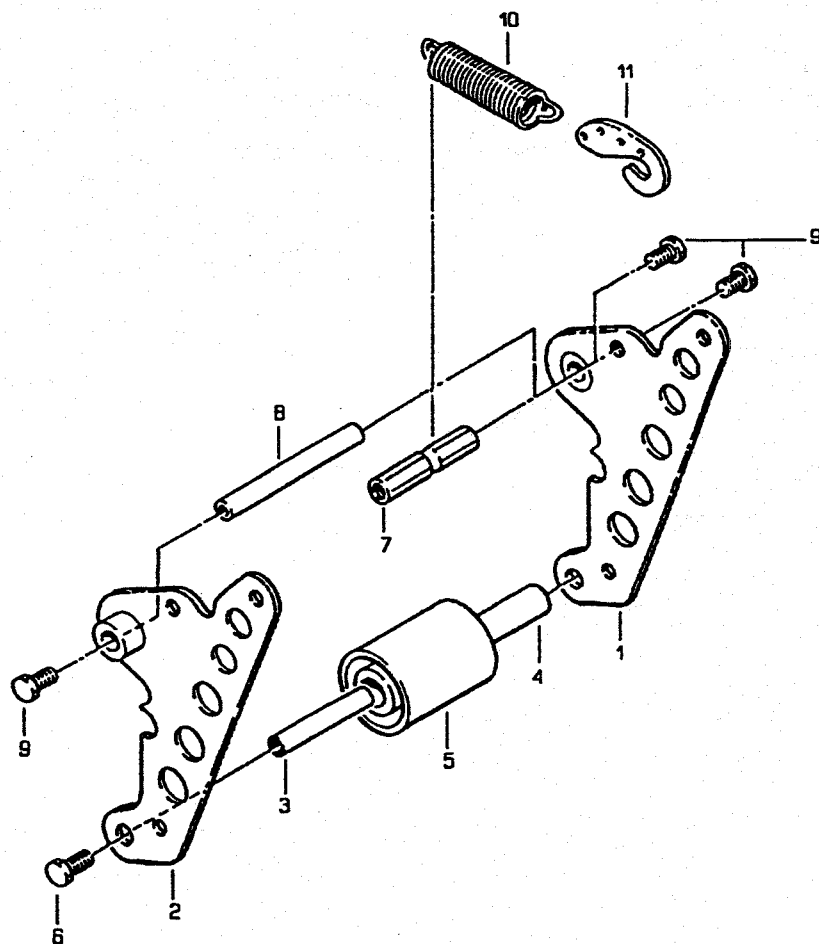


Figure 2949 – Upper and Lower Heads

## Figure 2949 – Upper and Lower Heads

| Ref. No. | 3M Part No.    | Description               |
|----------|----------------|---------------------------|
| 2949-1   | 78-8070-1278-2 | Applying Arm – Left       |
| 2949-2   | 78-8070-1279-0 | Applying Arm – Right      |
| 2949-3   | 78-8070-1292-3 | Plate – Back up           |
| 2949-4   | 78-8076-4736-3 | Shaft – Roller            |
| 2949-5   | 78-8076-4737-1 | Roller Assembly – Knurled |
| 2949-6   | 78-8076-4738-9 | Roller – Wrap             |
| 2949-7   | 78-8054-8806-7 | Spacer                    |
| 2949-8   | 78-8017-9082-1 | Bearing – Special 30 mm   |
| 2949-9   | 78-8017-9106-8 | Screw – Bearing Shoulder  |
| 2949-10  | 78-8091-0799-4 | Shaft – Roller            |
| 2949-11  | 78-8017-9074-8 | Washer – Nylon 15 mm      |
| 2949-12  | 78-8052-6566-3 | Washer – Friction         |
| 2949-13  | 78-8052-6567-1 | Spring – Compression      |
| 2949-14  | 78-8060-8396-6 | Bushing – Applying Roller |
| 2949-15  | 78-8057-6181-0 | Roller – Applying NM      |
| 2949-16  | 26-1005-4759-0 | Screw – Flat Hd, M6 x 12  |

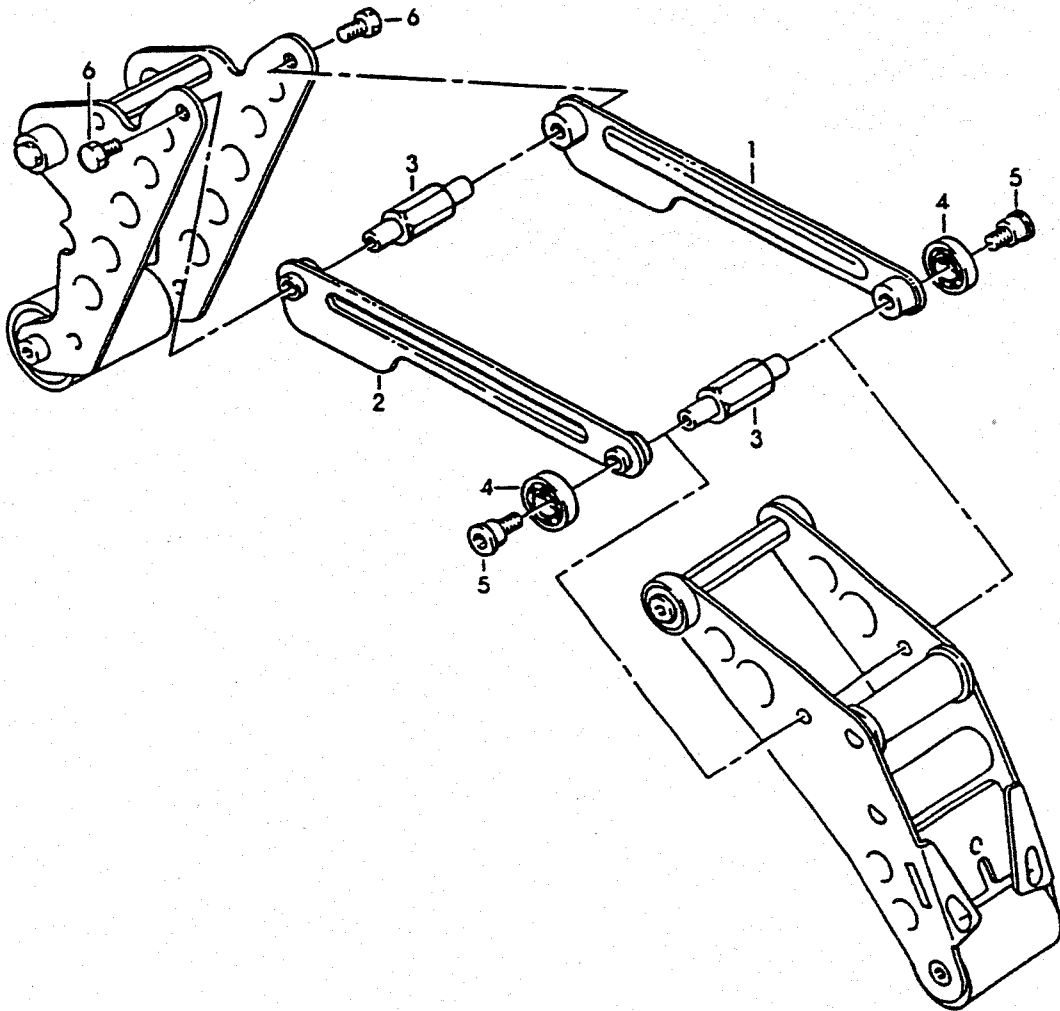


**Figure 2950 – Upper Head**

## Figure 2950 – Upper Head

| Ref. No. | 3M Part No.    | Description                |
|----------|----------------|----------------------------|
| 2950-1   | 78-8070-1392-1 | Buffing Arm – Sub Assembly |
| 2950-2   | 78-8070-1391-3 | Buffing Arm – Sub Assembly |
| 2950-3   | 78-8091-0799-4 | Shaft – Roller             |
| 2950-4   | 78-8054-8807-5 | Bushing – Buffing Roller   |
| 2950-5   | 78-8057-6180-2 | Roller – Buffing NM        |
| 2950-6   | 26-1003-5828-7 | Screw – Hex Hd, M6 x 12    |
| 2950-7   | 78-8076-4739-7 | Spacer – Spring            |
| 2950-8   | 78-8028-7885-6 | Shaft – 10 x 115 mm        |
| 2950-9   | 26-1003-5829-5 | Screw – Hex Hd, M6 x 12    |
| 2950-10  | 78-8070-1274-1 | Spring – Upper (Silver)    |
| 2950-11  | 78-8070-1244-4 | Holder – Spring            |

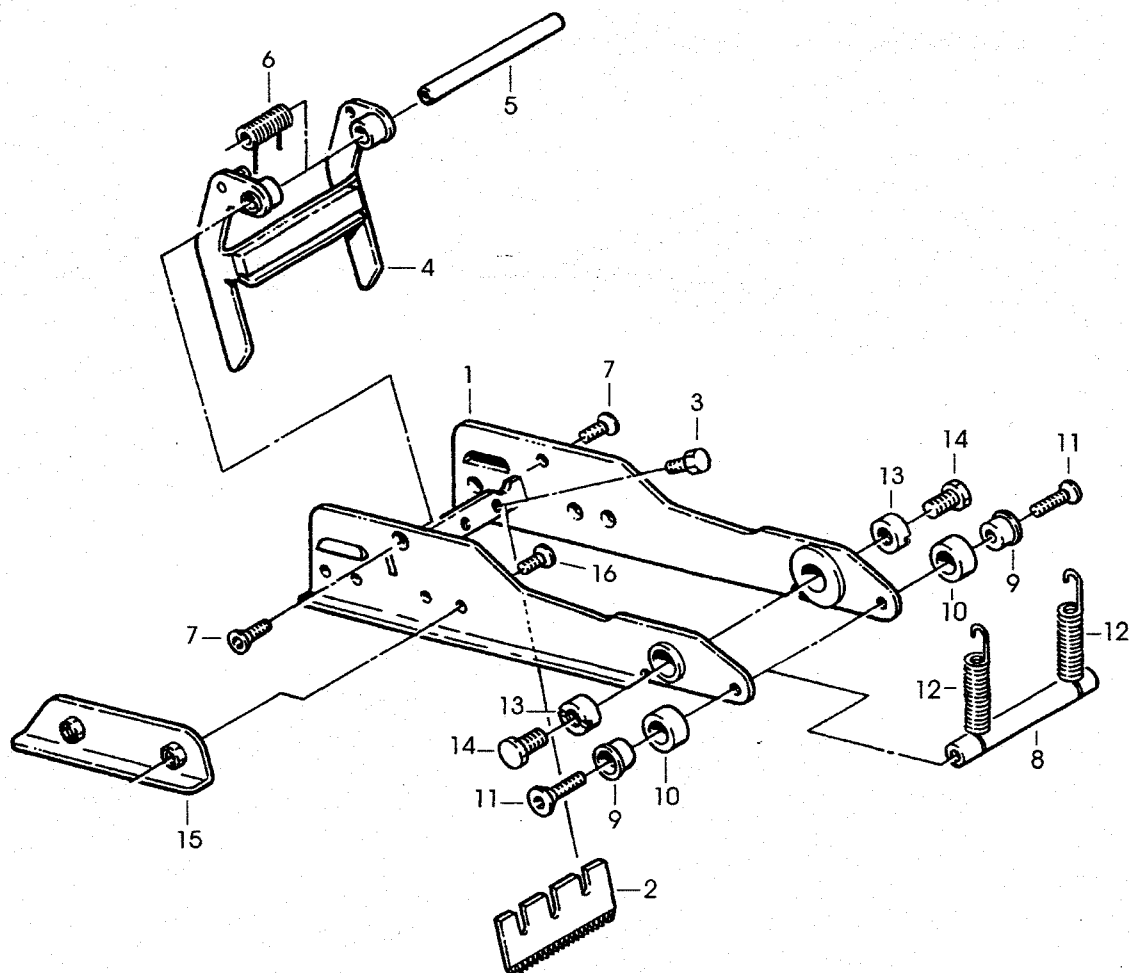




**Figure 2951 – Upper and Lower Heads**

## Figure 2951 – Upper and Lower Heads

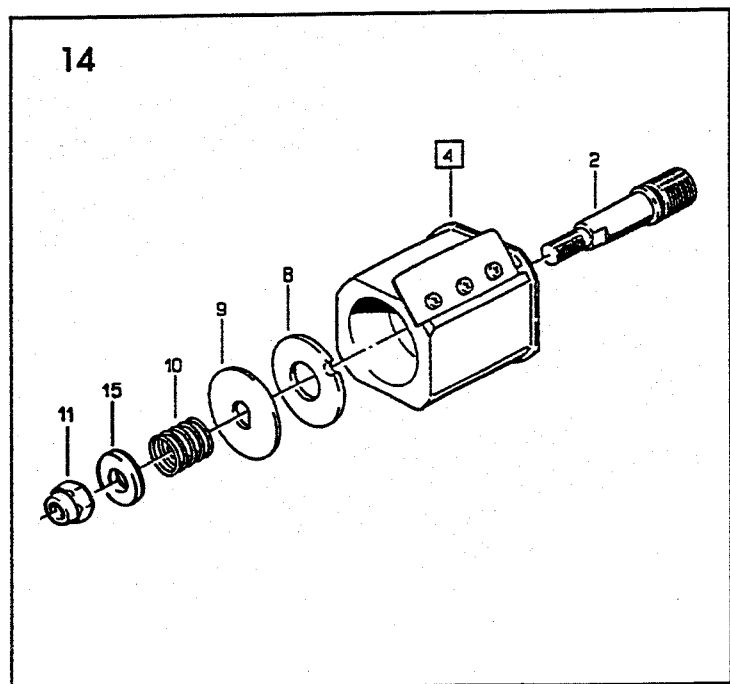
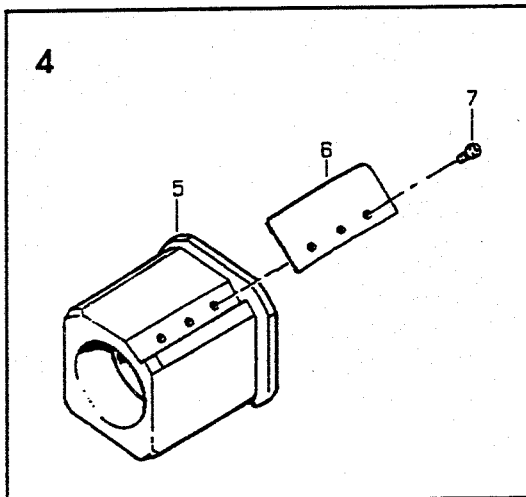
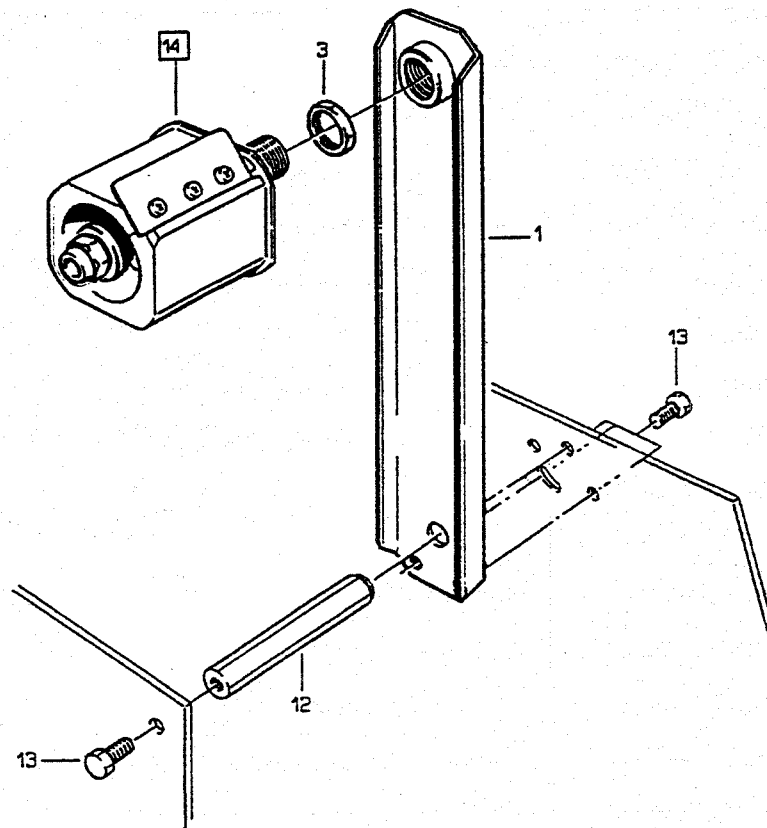
| Ref. No. | 3M Part No.    | Description                 |
|----------|----------------|-----------------------------|
| 2951-1   | 78-8070-1388-9 | Link – Arm Bushing Assembly |
| 2951-2   | 78-8070-1389-7 | Link – Arm Bushing Assembly |
| 2951-3   | 78-8076-4740-5 | Shaft – Pivot               |
| 2951-4   | 78-8017-9082-1 | Bearing – Special, 30 mm    |
| 2951-5   | 78-8017-9106-8 | Screw – Bearing Shoulder    |
| 2951-6   | 26-1003-5828-7 | Screw – Hex Hd, M6 x 10     |



**Figure 2952 – Upper and Lower Heads**

## Figure 2952 – Upper and Lower Heads

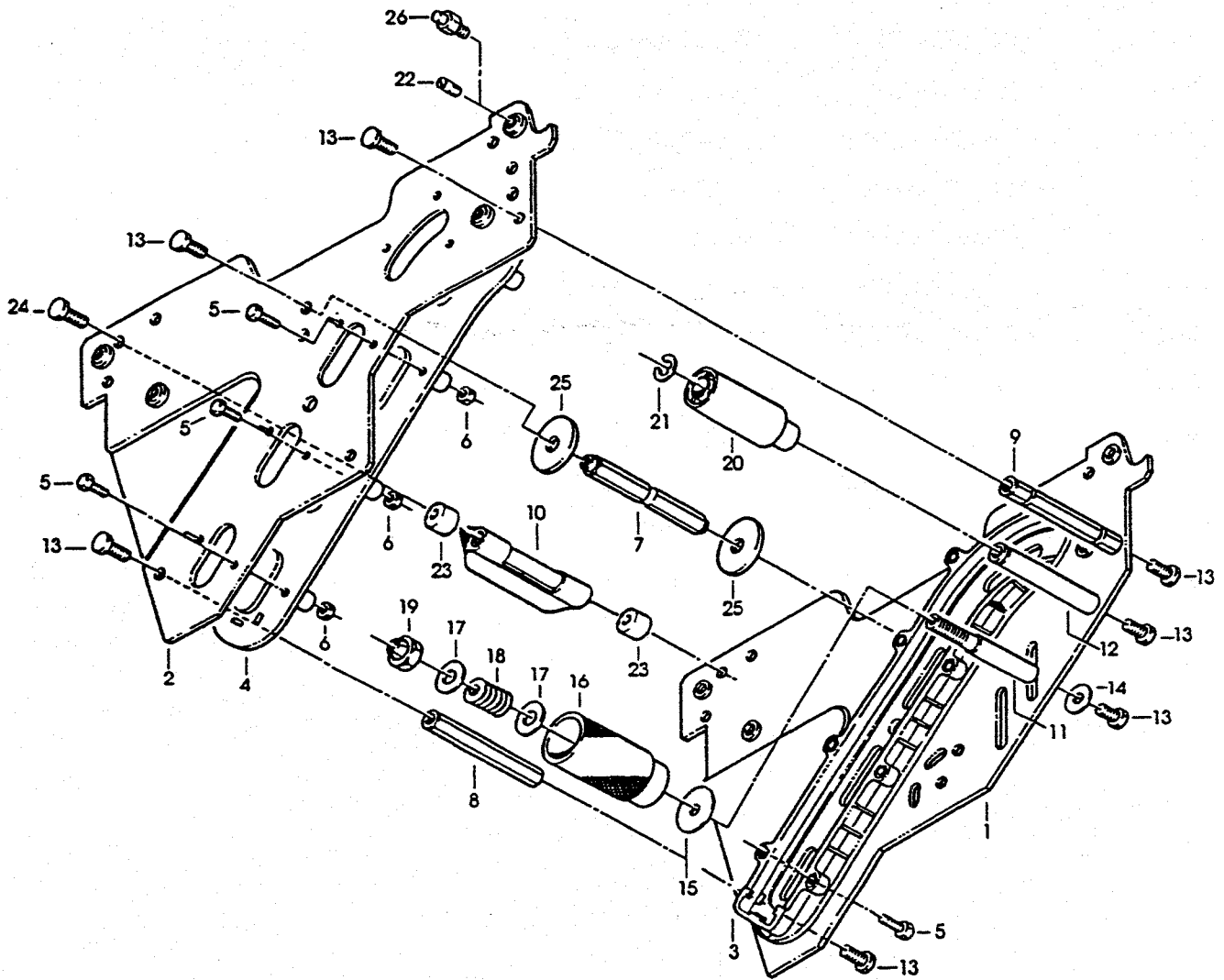
| Ref. No. | 3M Part No.    | Description                       |
|----------|----------------|-----------------------------------|
| 2952-1   | 78-8070-1283-2 | Frame – Cut-Off                   |
| 2952-2   | 78-8028-7899-7 | Blade – 89 mm/3.5 Inch            |
| 2952-3   | 26-1002-5817-2 | Screw – Hex Hd, M5 x 8            |
| 2952-4   | 78-8076-4741-3 | Guard – Blade Assembly            |
| 2952-5   | 78-8054-8813-3 | Shaft – Blade Guard               |
| 2952-6   | 78-8070-1390-5 | Spring – Torsion                  |
| 2952-7   | 26-1005-4758-2 | Screw – Flat Hd, Soc Dr, M4 x 10  |
| 2952-8   | 78-8060-7941-0 | Pin – Spring Holder, W/Slots      |
| 2952-9   | 78-8052-6600-0 | Spacer                            |
| 2952-10  | 78-8070-1269-1 | Bumper                            |
| 2952-11  | 26-1005-4757-4 | Screw – Flat Hd, Soc Dr, M5 x 20  |
| 2952-12  | 78-8052-6602-6 | Spring – Cutter                   |
| 2952-13  | 78-8017-9132-4 | Pivot – Cutter Lever              |
| 2952-14  | 26-1003-5828-7 | Screw – Special, Hex Hd, M6 x 10  |
| 2952-15  | 78-8070-1216-2 | Slide – Extension                 |
| 2952-16  | 26-1008-6574-5 | Screw – Flat Hd, Phil Dr, M4 x 10 |



**Figure 2953 – Upper and Lower Heads**

## Figure 2953 – Upper and Lower Heads

| Ref. No. | 3M Part No.    | Description                   |
|----------|----------------|-------------------------------|
| 2953-1   | 78-8070-1395-4 | Bracket – Bushing Assembly    |
| 2953-2   | 78-8060-8462-6 | Shaft – Tape Drum, 72 mm Head |
| 2953-3   | 78-8017-9169-6 | Nut – M18 x 1                 |
| 2953-4   | 78-8076-4731-4 | Tape Drum Sub Assembly        |
| 2953-5   | 78-8054-8815-8 | Tape Drum                     |
| 2953-6   | 78-8054-8816-6 | Leaf Spring                   |
| 2953-7   | 26-1002-5753-9 | Screw – Self Tapping          |
| 2953-8   | 78-8060-8172-1 | Washer – Friction             |
| 2953-9   | 78-8052-6271-0 | Washer – Tape Drum            |
| 2953-10  | 78-8054-8826-5 | Spring                        |
| 2953-11  | 78-8017-9077-1 | Nut – Self Locking, M10 x 1   |
| 2953-12  | 78-8076-4742-1 | Spacer – Tape Drum Bracket    |
| 2953-13  | 26-1003-5829-5 | Screw – Hex Hd, M6 x 12       |
| 2953-14  | 78-8076-4732-2 | Tape Drum Assembly            |
| 2953-15  | 26-1004-5510-9 | Washer – Plain, M10           |

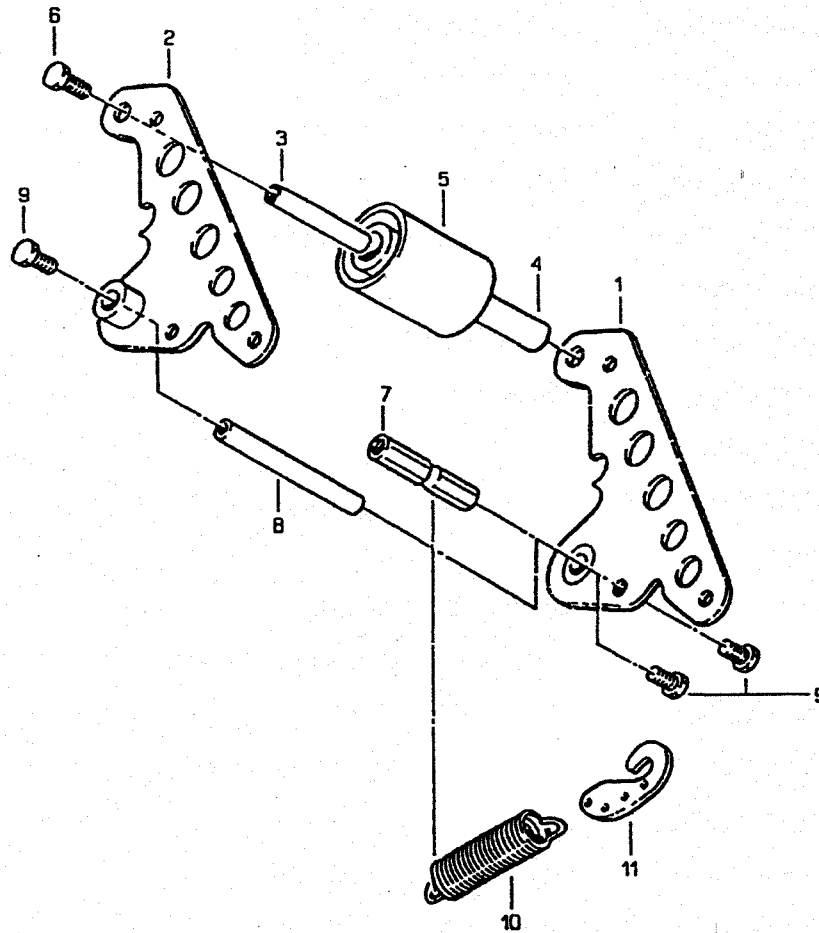


**Figure 2954 – Lower Head**

**Figure 2954 – Lower Head**

| <b>Ref. No.</b> | <b>3M Part No.</b> | <b>Description</b>                        |
|-----------------|--------------------|---|
| 2954-1          | 78-8070-1369-9     | Frame – Tape Mount Lower Assembly         |
| 2954-2          | 78-8070-1370-7     | Frame – Front Lower Assembly              |
| 2954-3          | 78-8068-4144-7     | Guide – #2                                |
| 2954-4          | 78-8068-4143-9     | Guide – #1                                |
| 2954-5          | 83-0002-7336-3     | Screw – Hex Hd, M4 x 14                   |
| 2954-6          | 78-8010-7416-8     | Nut – Hex, M4                             |
| 2954-7          | 78-8076-4735-5     | Spacer – Spring                           |
| 2954-8          | 78-8054-8793-7     | Spacer – Hexagonal                        |
| 2954-9          | 78-8060-7939-4     | Spacer – 10 x 115, W/Slots                |
| 2954-10         | 78-8060-7936-0     | Brush Assembly                            |
| 2954-11         | 78-8054-8796-0     | Shaft – Tension Roller                    |
| 2954-12         | 78-8054-8798-6     | Shaft – Wrap Roller                       |
| 2954-13         | 26-1003-5829-5     | Screw – Hex Hd, M6 x 12                   |
| 2954-14         | 78-8042-2919-9     | Washer – Triple, M6                       |
| 2954-15         | 78-8070-1268-3     | Washer – Roll Back Up                     |
| 2954-16         | 78-8054-8817-4     | Roller – Tension Bottom                   |
| 2954-17         | 78-8052-6566-3     | Washer – Friction                         |
| 2954-18         | 78-8052-6567-1     | Spring – Compression                      |
| 2954-19         | 78-8017-9077-1     | Nut – Self Locking, M10 x 1               |
| 2954-20         | 78-8054-8799-4     | Roller – Wrap                             |
| 2954-21         | 26-1000-1613-3     | Ring – Retaining, Tru-Arc #1-420-0120-100 |
| 2954-22         | 78-8076-4500-3     | Stud – Mounting                           |
| 2954-23         | 78-8060-7937-8     | Spacer – /6.5 x 14 x 12.5                 |
| 2954-24         | 78-8060-7938-6     | Screw – Special, M6 x 25                  |
| 2954-25         | 78-8076-5242-1     | Stop – Cut-Off Frame                      |





**Figure 2955 – Lower Head**

**Figure 2955 – Lower Head**

| <b>Ref. No.</b> | <b>3M Part No.</b> | <b>Description</b>       |
|-----------------|--------------------|--------------------------|
| 2955-1          | 78-8070-1391-3     | Buffing Arm Sub Assembly |
| 2955-2          | 78-8070-1392-1     | Buffing Arm Sub Assembly |
| 2955-3          | 78-8091-0799-4     | Shaft – Roller           |
| 2955-4          | 78-8054-8807-5     | Bushing – Buffing Roller |
| 2955-5          | 78-8057-6180-2     | Roller – Buffing         |
| 2955-6          | 26-1003-5828-7     | Screw – Hex Hd, M6 x 12  |
| 2955-7          | 78-8076-4739-7     | Spacer – Spring          |
| 2955-8          | 78-8028-7885-6     | Shaft – 10 x 115 mm      |
| 2955-9          | 26-1003-5829-5     | Screw – Hex Hd, M6 x 12  |
| 2955-10         | 78-8070-1273-3     | Spring – Lower (Black)   |
| 2955-11         | 78-8070-1244-4     | Holder – Spring          |



# 3M Parts Order Form

Form 26999 - 3 - D

**Mall To: Dispenser Parts**  
**241 Venture Drive**  
**Amery, WI 54001**

**Fax or Call: 715-268-8126 (Wisc.)**  
**800-344-9883 (Outside Wisc.)**  
**FAX# 715-268-8153**

**- Shaded Areas To Be Filled In By 3M -**

|                |  |                      |  |             |  |                                 |  |               |  |
|----------------|--|----------------------|--|-------------|--|---------------------------------|--|---------------|--|
| P.O. No.       |  | Date                 |  | Catalog No. |  | Phone No. (Including Area Code) |  | Customer Name |  |
| Attn.          |  | Model No.            |  | Serial No.  |  | Sales Rep No.                   |  | Invoice No.   |  |
| Charge Back    |  | Do Not Charge Back   |  | Via         |  | Account No.                     |  | Account No.   |  |
| Tax Exempt No. |  | Special Instructions |  | SIC         |  |                                 |  |               |  |

**Ship To**

**Charge To**

**FAX Your Order For Faster Service FAX No. 715-268-8153**

| Qty. | Part Number | Description | Price |
|------|-------------|-------------|-------|
| 1.   |             |             |       |
| 2.   |             |             |       |
| 3.   |             |             |       |
| 4.   |             |             |       |
| 5.   |             |             |       |
| 6.   |             |             |       |
| 7.   |             |             |       |
| 8.   |             |             |       |
| 9.   |             |             |       |

Signature

\$25.00 Minimum Order ☐ Ship Via Air At Customer Expense



Please Print

