



Instructions and Parts List

3M-Matic[™]

Accuglide[™]

NPH

SST 2 Inch

Taping Heads

Type 11200

Serial No. _____
For reference, record taping head(s) serial number(s) here.



3M Industrial Adhesives and Tapes
3M Center, Building 220-5E-06
St. Paul, MN 55144-1000



Important Safety Information

BEFORE INSTALLING
OR OPERATING THIS
EQUIPMENT

Read, understand, and
follow all safety and
operating instructions.

Spare Parts

It is recommended you
immediately order the
spare parts listed in the
"Spare Parts/Service
Information" section.
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
Printed in U.S.A.

© 3M 2014 44-0009-2128-6 (B122714-NA)

Replacement Parts and Service Information

To Our Customers:

This is the 3M-Matic™/Scotch® equipment you ordered. It has been set up and tested in the factory with Scotch® 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 / Replacement Parts and Additional Manuals:

Call the 3M-Matic™ Help line at 1-800 328-1390. Provide the customer support coordinator with the model / machine name, machine type, and serial number that are located on the identification plate (For example: NPH SST 2 inch - Type 11200 - Serial Number 13282).

United States -

3M Tape Dispenser Parts

241 Venture Drive

1-800-344-9883

Amery, WI 54001-1325

Fax: 1-715-268-8153

Identification Plate

3M 3M Company St. Paul, MN 55144 USA	Part Number	3M-Matic™ For Industrial Use Only			
	Model	Year	Ampere	Watt	
Type	Serial Number	Volt	Hertz	Phase	

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 Industrial Adhesives and Tapes

3M Center, Building 220-5E-06
St. Paul, MN 55144-1000

3M-Matic™ and Scotch™
are Trademarks of
3M St. Paul, MN 55144-1000
Printed in U.S.A.

THIS PAGE IS BLANK

Replacement Parts And Service Information

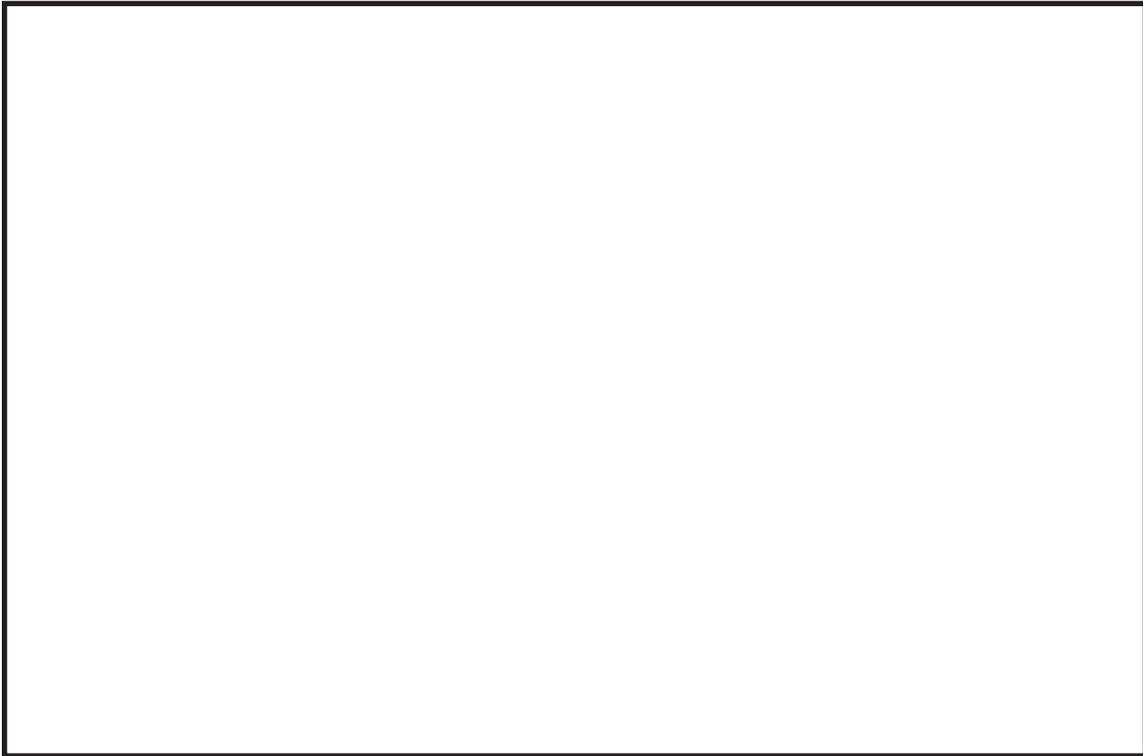
To Our Customers:

This is the 3M-Matic™/Scotch® equipment you ordered. It has been set up and tested in the factory with Scotch® 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 or additional manuals, include model/machine name, machine type, and serial number that are located on the identification plate.



3M Industrial Adhesives and Tapes
3M Center, Building 220-5E-06
St. Paul, MN 55144-1000

3M-Matic™ and Scotch™
are Trademarks of
3M, St. Paul, MN 55144-1000
Printed in U.S.A.

THIS PAGE IS BLANK

Instruction Manual

NPH SST 2 Inch Upper and Lower Taping Heads Type 11200

Table of Contents	Page
Replacement Parts and Service Information	i - ii
Table of Contents.....	iii
Equipment Warranty and Limited Remedy.....	iv
Intended Use	1
Taping Head Contents / How to Use Manual.....	3
Important Safeguards.....	4 - 5
Specifications	6 - 7
Dimensional Drawing	7
Installation	8
Receiving and Handling	8
Installation Guidelines	8
Tape Leg Length	8
Tape Width Adjustment	8
Operation.....	9 - 11
Tape Loading – Upper Taping Head.....	10
Tape Loading – Lower Taping Head.....	10 - 11
Maintenance.....	12 - 13
Blade Replacement.....	12
Blade Guard	12
Blade Oiler Pad	12
Cleaning.....	13
Applying/Buffering Roller Replacement.....	13
Adjustments.....	14 - 15
Tape Latch Alignment.....	14
Tape Drum Friction Brake	14
Applying Mechanism Spring.....	15
One-Way Tension Roller	15
Troubleshooting Guide	16 - 17
Spare Parts/Service Information.....	18 - 19
Recommended Spare Parts.....	18
Replacement Parts and Service.....	19
Replacement Parts Illustrations and Parts List.....	Yellow Section 21 - 34

General Information - Warranty

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

3M sells its AccuGlide™ NPH SST 2 Inch Upper and Lower Taping Heads, Type 11200 with the following warranty:

1. The Taping Head blade, springs and rollers will be free from defects in material and manufacture for ninety (90) days after delivery.
2. All other Taping Head parts will be free from defects in material and manufacture for one (1) year after delivery.

If any part is defective within this warranty period, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to repair or replace the part. 3M must receive actual notice of any alleged defect within a reasonable time after it is discovered, but in no event shall 3M have any obligation under this warranty unless it receives such notice within five (5) business days after the expiration of the warranty period. All notices required hereunder shall be given to 3M solely through the 3M-Matic™ Help line (800-328-1390). To be entitled to repair or replacement as provided under this warranty, the part must be returned as directed by 3M to its factory or other authorized service station designated by 3M. If 3M is unable to repair or replace the part within a reasonable time after receipt thereof, 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 remove any part or equipment or to install the repaired or replacement part or equipment. 3M shall have no obligation to repair or replace those parts failing due to normal wear, inadequate or improper maintenance, inadequate cleaning, non-lubrication, improper operating environment, improper utilities, operator error or misuse, alteration or modification, mishandling, lack of reasonable care, or due to any accidental cause.

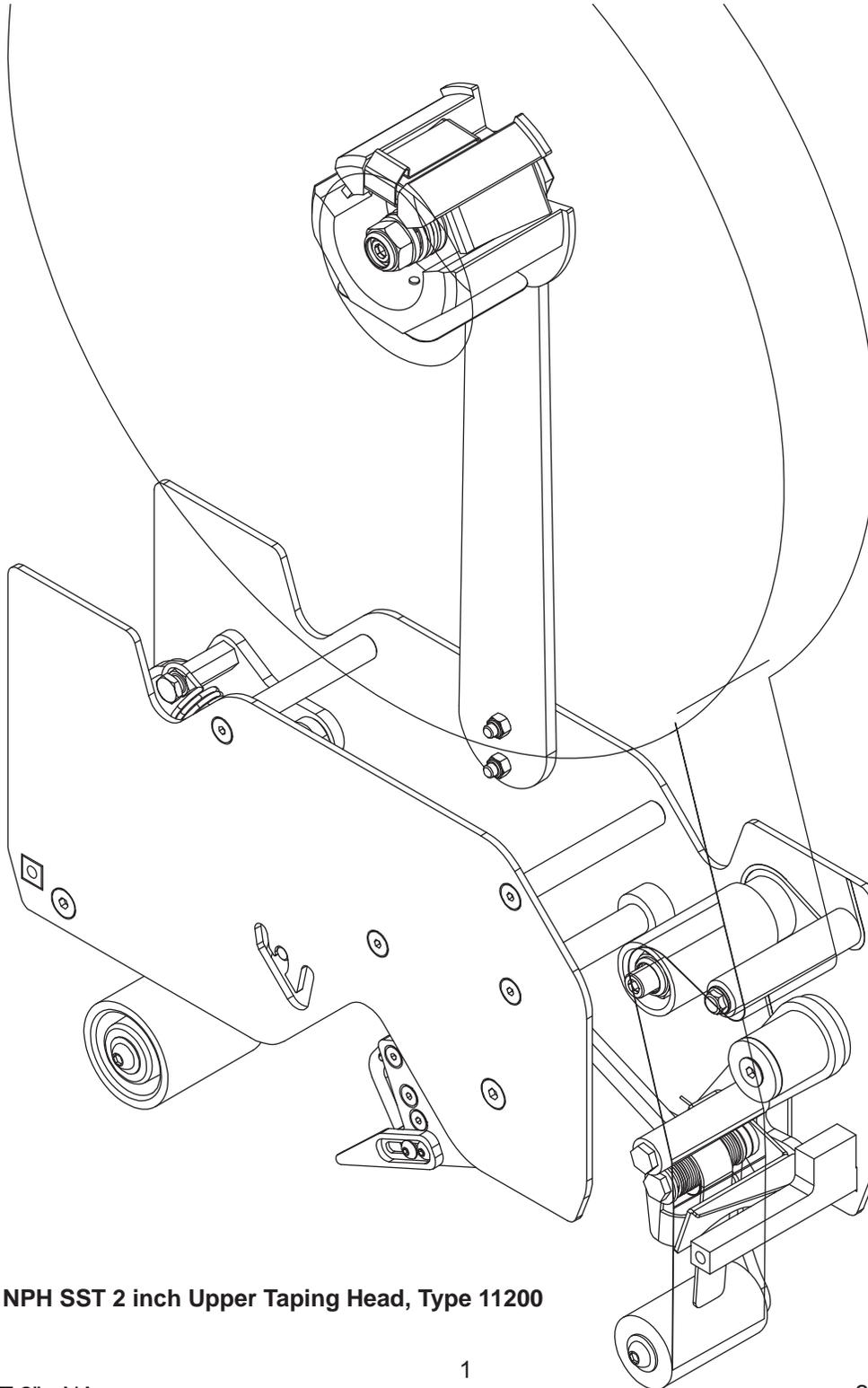
Limitation of Liability: Except where prohibited by law, 3M and seller will not be liable for any loss or damage arising from this 3M equipment, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including breach of warranty, breach of contract, negligence, or strict liability.

Note: The foregoing Equipment Warranty and Limited Remedy and Limitation of Liability may be changed only by a written agreement signed by authorized representatives of 3M and seller.

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

Intended Use

The intended use of the **NPH SST 2 inch Upper and Lower Taping Heads** is to apply a "C" clip of Scotch® pressure-sensitive film box sealing tape to the top and/or bottom center seam of regular slotted containers. The compact size and simplicity of the taping head makes it suitable for mounting in box conveying systems other than **3M-Matic™** case sealers. This includes replacement of other types of taping, gluing or stapling heads in existing case sealing machines. The **NPH SST 2 inch Upper and Lower Taping Heads** have been designed and tested for use with Scotch® pressure-sensitive film box sealing tape.



NPH SST 2 inch Upper Taping Head, Type 11200

THIS PAGE IS BLANK

Taping Head Contents

NPH SST 2 Inch Upper and Lower Taping Heads consist of:

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

General Information

This instruction manual covers safety aspects, handling and transport, storage, unpacking, preparation, installation, operation, set-up and adjustments, technical and manufacturing specifications, maintenance, troubleshooting, repair work and servicing, electric diagrams, warranty information, disposal (ELV), a glossary with a definition of symbols, plus a parts list of the 3M-Matic™ **NPH SST 2 inch** 3M Industrial Adhesives and Tapes Division 3M Center, Bldg. 220-5E-06 St. Paul, MN 55144-1000 (USA) Edition December 2014 / Copyright 3M 2014. All rights reserved. The manufacturer reserves the right to change the product at any time without notice.

How to Use this Manual

The manual is an important part of the machine; all information contained herein is intended to enable the equipment to be maintained in perfect condition and operated safely. Ensure that the manual is available to all operators of this equipment and the manual is kept up to date with all subsequent amendments. Should the equipment be sold or disposed of, please ensure that the manual is passed on with the machine.

Electrical and pneumatic diagrams are included in the manual. Equipment using PLC controls and/or electronic components will include relevant schematics or programs in the enclosure (or will be delivered separately as needed)

Keep the manual in a clean and dry place near the machine. Do not remove, tear or rewrite parts of the manual for any reason. Use the manual without damaging it. However, if the manual has been lost or damaged, ask your after sale service for a new copy (if it is possible, please have the manual name, part number, and revision information and/or model/machine name, machine type, and serial number) that are located on the identification plate (**For example: NPH SST 2" - Type 11200 - Serial Number 13282**).

Note:

All the important warning notes related to the operation of the machine are identified by the symbol:



Updating the Manual

Modifications to the machine are subject to manufacturer's internal procedures. The user may receive pages or parts of the manual which contain amendment made after its first publication. The user must use them to update this manual.

Important Safeguards



This safety alert symbol identifies important safety messages in this manual.

READ AND UNDERSTAND THEM BEFORE INSTALLING OR OPERATING THIS EQUIPMENT.

Explanation of Signal Word Consequences



Caution: Indicates a potentially hazardous situation, which, if not avoided, may result in minor or moderate injury and/or property damage.



Warning: Indicates a potentially hazardous situation, which, if not avoided, could result in death or serious injury and/or property damage.



CAUTION

- **To reduce the risk associated with muscle strain:**
 - Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift.
- **To reduce the risk associated with impact hazards:**
 - Place the taping head on a smooth level surface when maintaining or servicing this equipment.



WARNING

- **To reduce the risk associated with mechanical hazards:**
 - Read, understand and follow all safety and operating instructions before operating or servicing the case sealer.
 - Allow only properly trained and qualified personnel to operate and/or service this equipment.
- **To reduce the risk associated with shear, pinch, and entanglement hazards:**
 - Turn air and electrical supplies off on associated equipment before performing any adjustments, maintenance, or servicing the taping heads.
 - Never attempt to work on the taping head or load tape while the box drive system is running.
- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under Yellow blade guards. The blades are extremely sharp.

(Important Safeguards continued on next page)

Important Safeguards (continued)

Important - In the event the following safety labels are damaged or destroyed, they must be replaced to ensure operator safety. See "Replacement Parts Illustrations and Parts Lists" for label part numbers.

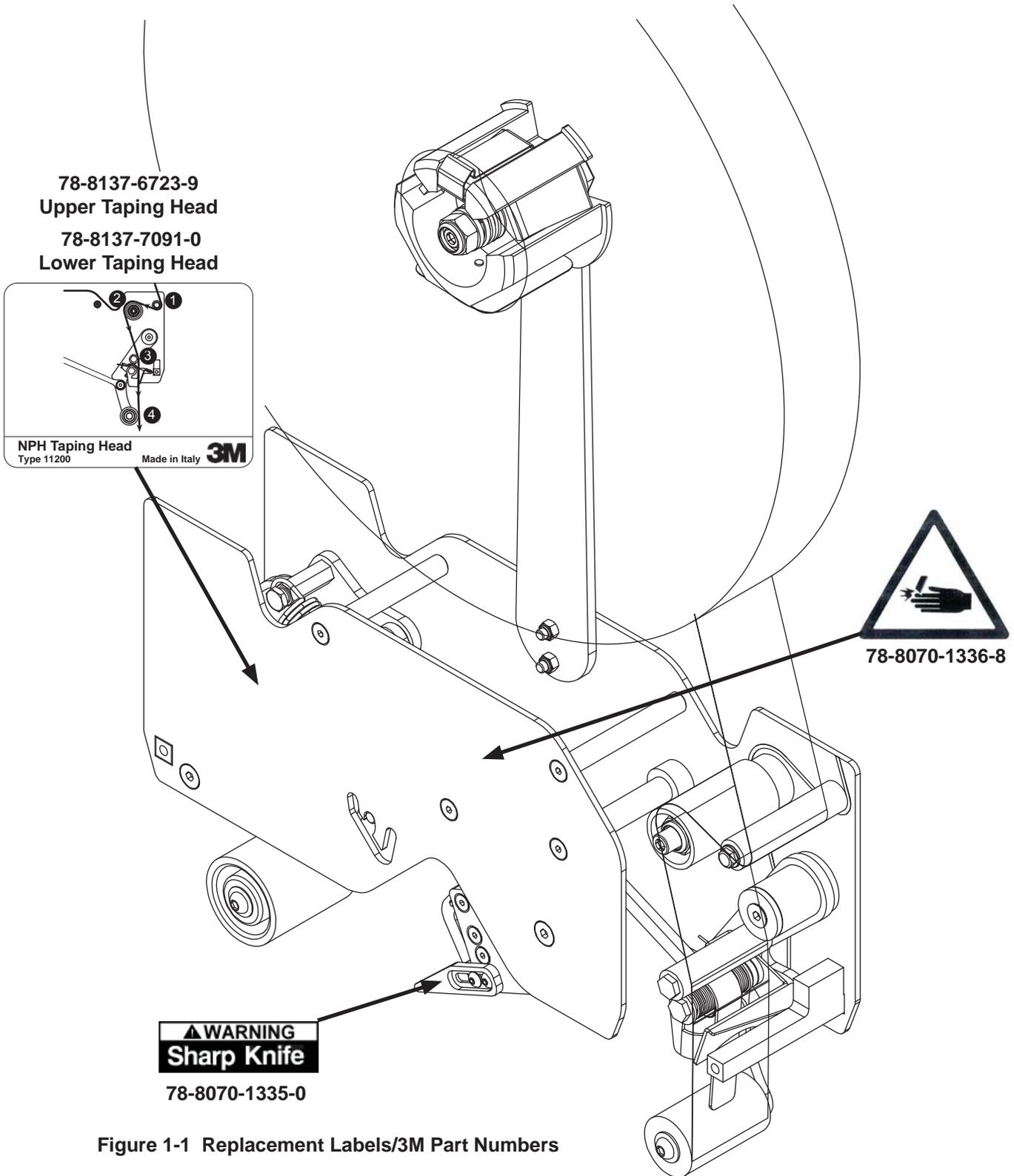


Figure 1-1 Replacement Labels/3M Part Numbers

Specifications

1. Tape:

For use with Scotch® pressure-sensitive film box sealing tapes.

2. Tape Width:

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

3. Tape Roll Diameter:

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

4. Tape Application Leg Length:

58mm ± 6mm [2 1/4 inches ± 1/4 inch]

5. Minimum Box Size Capacities:

For use with center seam regular slotted containers.

Length * – 150mm [6 inches] w/ Guard

Height * – 101mm [4 inches] w/ Guard

Width * – 150mm [6 inches]

* **Note:** Box size capacities may also be determined by the case conveying system used.

6. 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	–	375mm [14 3/4 inches]
Height	–	502mm [19 3/4 inches] (with tape drum)
Width	–	79.5mm [3 1/8 inches] (without mounting spacers)
Weight	–	Packaged: 5.9kg [13.0 lbs.] Unpackaged: 4.8kg [10.5 lbs.]

(Specifications continued on next page.)

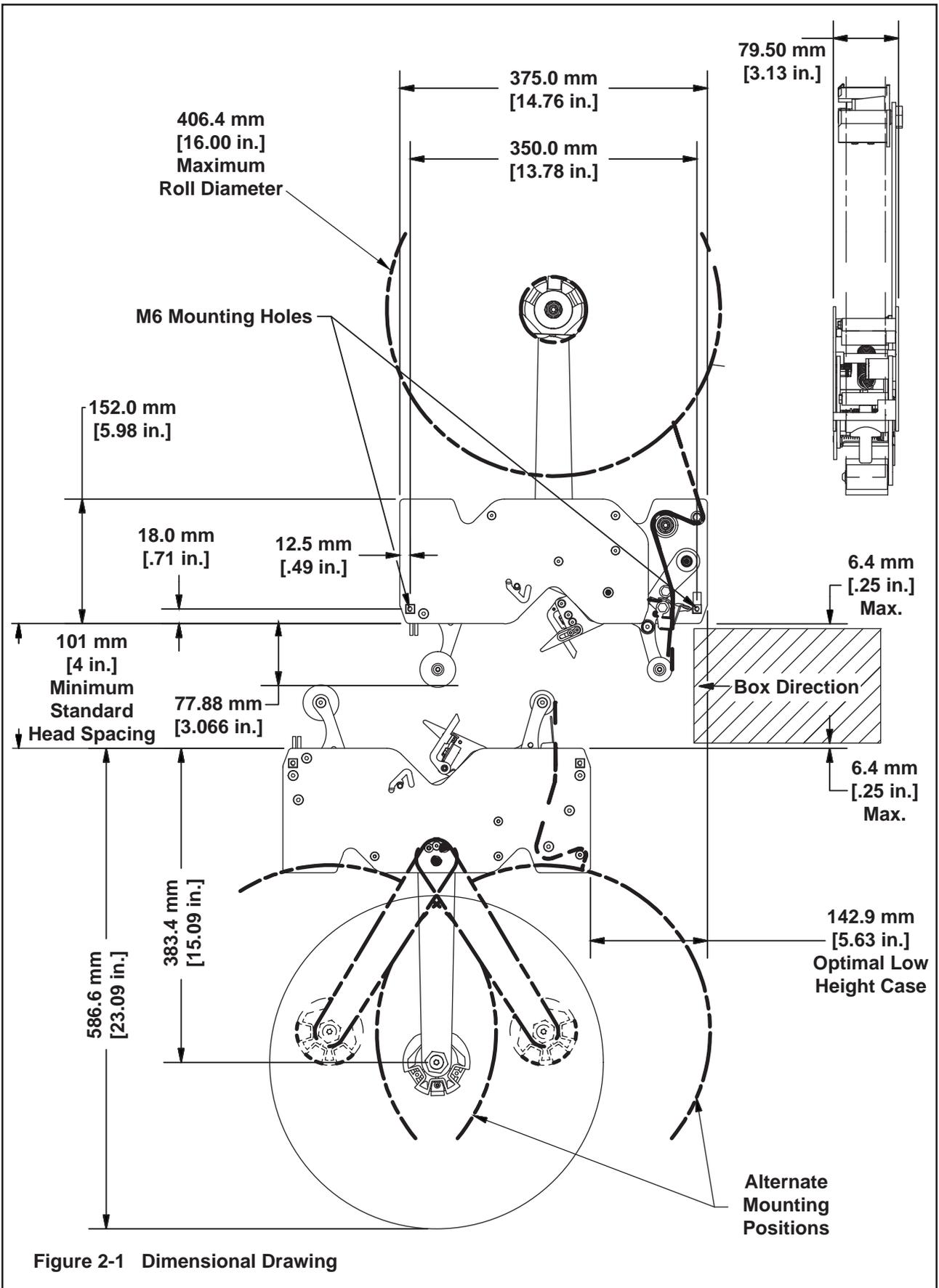


Figure 2-1 Dimensional Drawing

Installation



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under Yellow blade guards.
The blades are extremely sharp.

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 can be used for tape head conversions and/or custom machines. It can be mounted for top taping or bottom taping.

Refer to "Box Size Capacities," as well as **Figure 2-1** in the Specifications section for installation and conversion guidelines.



CAUTION

- **To reduce risk associated with muscle strain:**
 - Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift.

Important – Always conduct a hazard review to determine appropriate guarding requirements when the installation is in an application other than 3M-Matic™ equipment.

1. The box conveying system must positively propel the box in a continuous motion (see specifications) 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 (see specifications). 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 6mm [1/4 inch] maximum away from the ski surface on which the box rides.

Tape Leg Length

Taping heads are factory set to apply 58mm [2 1/4 inches] tape legs.

Tape Width Adjustment

Taping heads are factory set to apply 48mm [2 inch] wide tape. If it is necessary to align the tape or to apply narrower tapes, refer to "Adjustments – Tape Web Alignment" for set-up procedure.

Operation

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

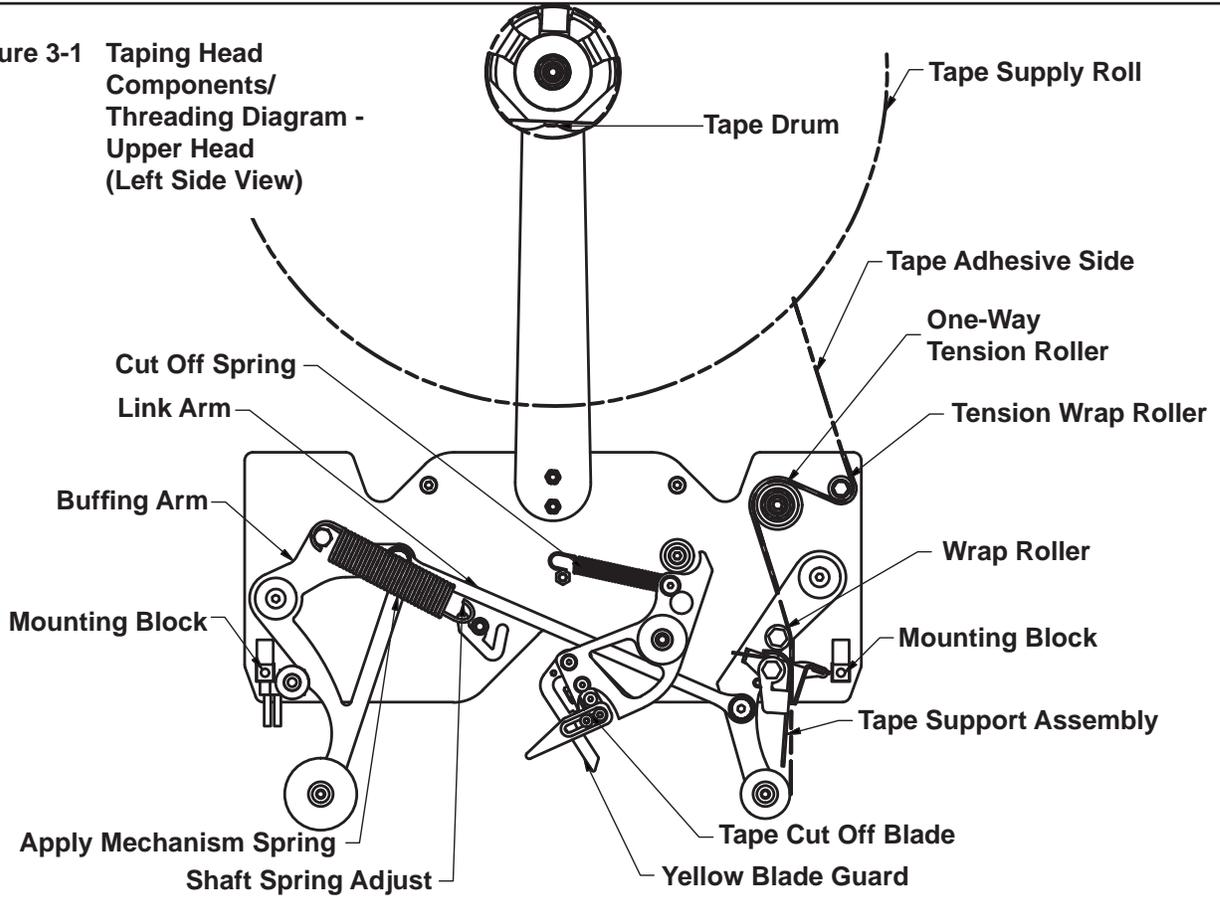
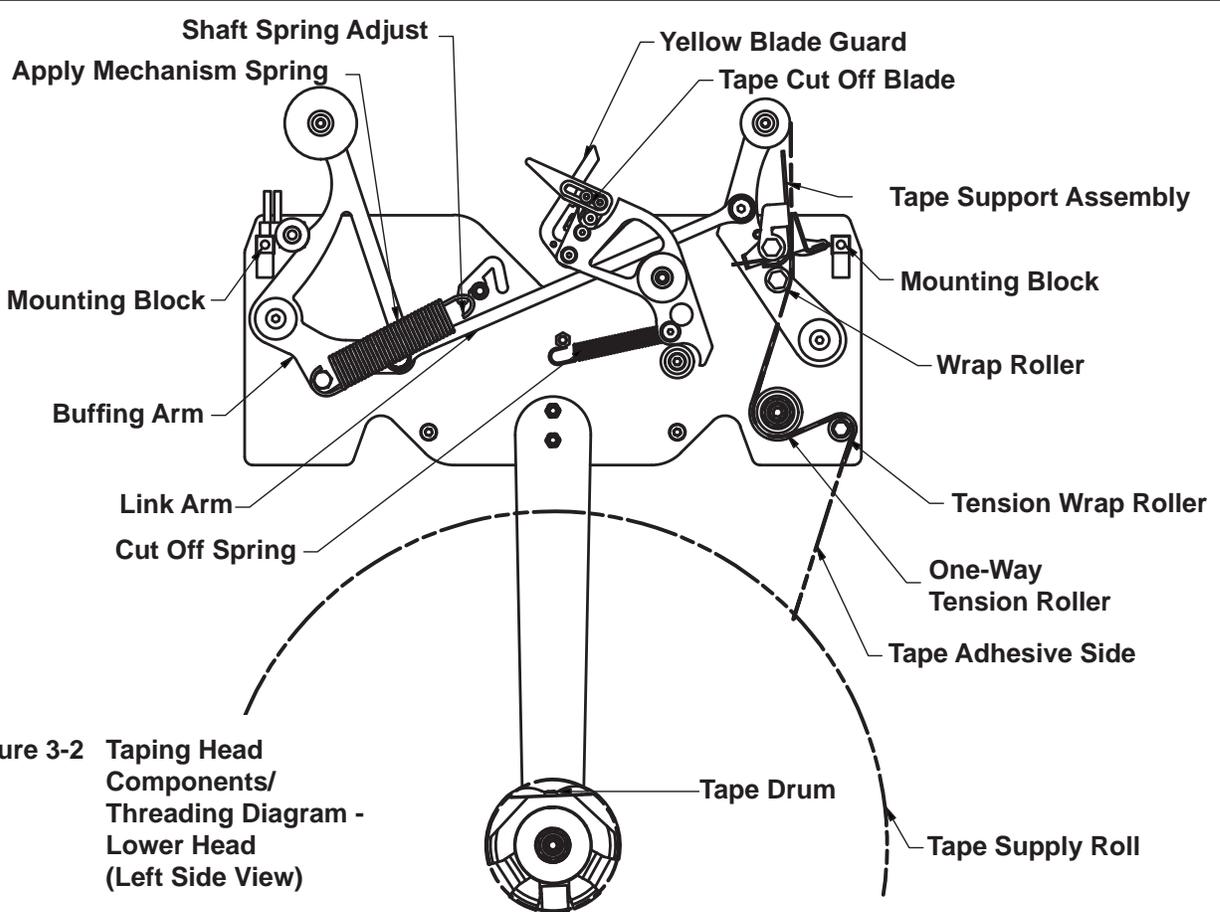


Figure 3-2 Taping Head Components/ Threading Diagram - Lower Head (Left Side View)





WARNING

- **To reduce the risk associated with shear, pinch, and entanglement hazards:**
 - Turn air and electrical supplies off on associated equipment before performing any adjustments, maintenance, or servicing the machine or taping heads.
 - Never attempt to work on the taping heads or load tape when the box drive system is running.
- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under Yellow blade guards.
The blades are extremely sharp.

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.

Note – Remove tape roll before removing taping head from machine to minimize weight.



CAUTION

- **To reduce the risk associated with muscle strain:**
 - Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift.
- **To reduce the risk associated with impact hazards:**
 - Place the taping head on a smooth level surface when maintaining or servicing this equipment.

Tape Loading – Upper Taping Head

1. Place the upper taping head in a convenient working position.
2. Use **Figures 3-3 to 3-5** and tapel label. Position the tape supply roll so the adhesive side of tape is facing the front of the taping head as it is pulled from the supply roll.
3. Guide the tape around the tension wrap roller (Position 1) then back around the one-way tension roller (Position 2).
4. Continue pulling the tape down and past the wrap roller (Position 3) and through the Tape Support Assembly.

5. Pull the tape down past the applying roller (Position 4). When properly threaded the adhesive side of the tape should be facing the tension roller at position 2 and away from the guide roller at position 3.
6. Cut away any excess tape.

Important – Do not cut against the apply roller - roller damage could occur.

Tape Loading – Lower Taping Head

1. Remove the lower taping head from the conveyor bed or associated equipment and place it a convenient working position.
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 tape through rollers in direction indicated by arrows.

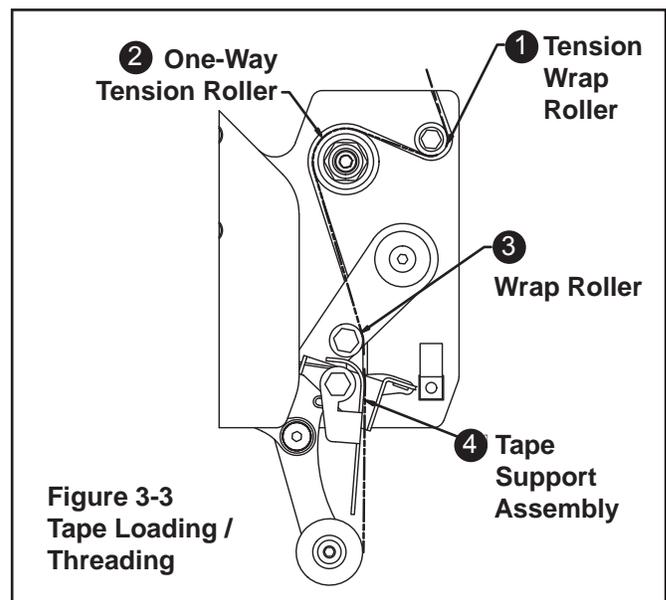


Figure 3-4

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 tape as shown.



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under Yellow blade guards. The blades are extremely sharp.

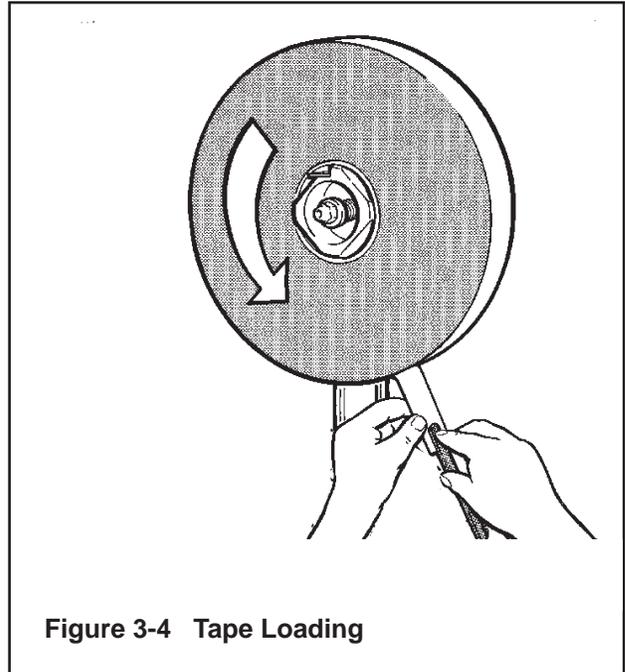


Figure 3-4 Tape Loading

Manually turn tape roll to create slack tape while pulling tape 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.

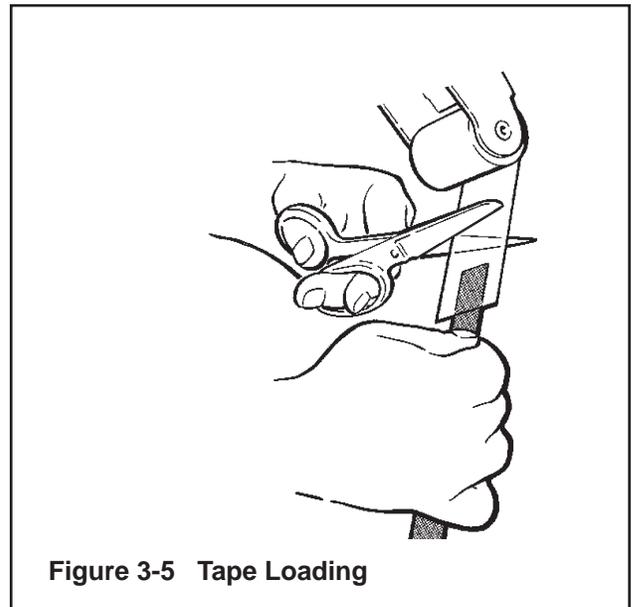


Figure 3-5 Tape Loading



WARNING

- **To reduce the risk associated with shear, pinch, and entanglement hazards:**
 - Turn air and electrical supplies off on associated equipment before performing any adjustments, maintenance, or servicing the taping heads
 - Never attempt to work on the taping head or load tape while the box drive system is running
- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp

The **NPH SST 2 Inch 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.

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

Blade Replacement, Upper and Lower Taping Heads (Figure 4-1).



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp

1. Loosen, but do not remove, the blade screws (A). Remove and discard old blade.
2. Mount the new blade (B) in the same position as the blade that was removed.
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.

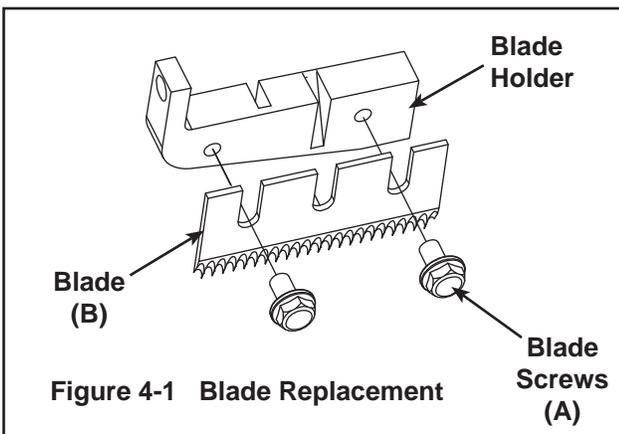


Figure 4-1 Blade Replacement

Blade Guard

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

Blade Oiler Pad



WARNING

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp

To reduce adhesive build-up, the taping heads are equipped with a factory pre-lubricated felt oiler pad that provides a film of oil on the cutting edge of the blade. Blade maintenance should include keeping the felt oiler pad saturated with SAE #30 non-detergent oil.

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

(Maintenance continued on next page.)



WARNING

- **Pour réduire le risque associé aux dangers de cisaillement, pinçage, et enchevêtrement:**
 - Arrêter l'électricité et l'alimentation en air sur l'équipements associés avant d'effectuer tout réglages, maintenance ou entretien courant des applicateurs
 - Ne tentez jamais de travailler sur les applicateurs de ruban ou de charger le ruban pendant que le système de convoyage de boîtes en carton fonctionne
- **Pour réduire le risque associé aux dangers de lame aiguisée:**
 - Tenez les mains et les doigts loin des parties des lames de coupe de ruban sous les gardes oranges de lame. Les lames sont extrêmement tranchantes

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 moving parts. Dirt in these areas can cause serious equipment damage. Never wash or subject taping heads to conditions that cause moisture condensation on components. Serious equipment damage could result.

Applying / Buffing Roller Replacement

Replacing roller requires removal of the mounting screw (**Figure 4-2 - also see Parts List**).

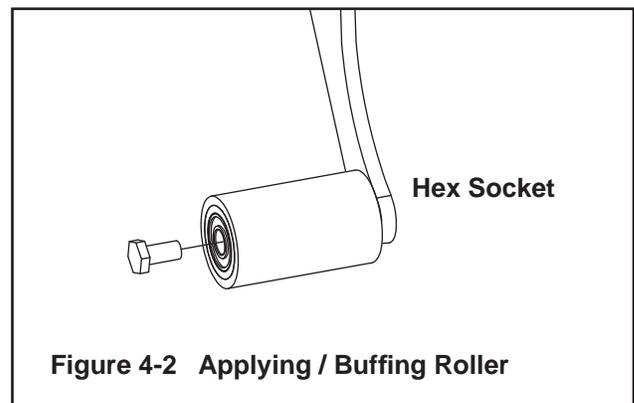


Figure 4-2 Applying / Buffing Roller

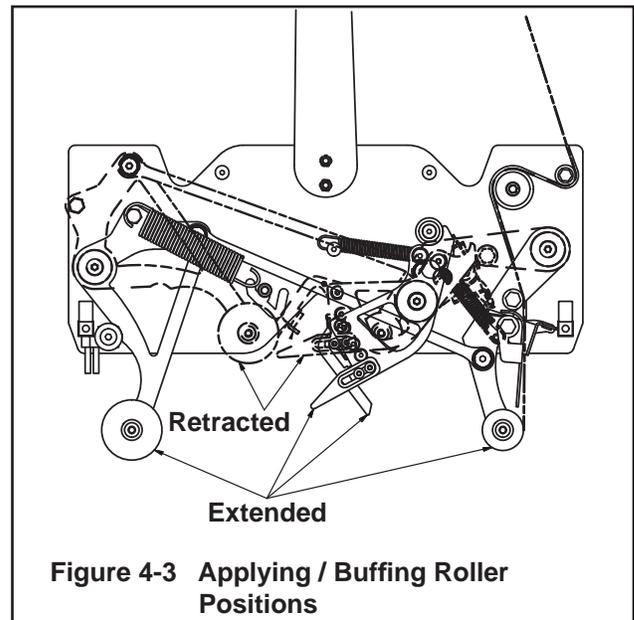


Figure 4-3 Applying / Buffing Roller Positions



WARNING

- To reduce the risk associated with shear, pinch, and entanglement hazards:
- Turn air and electrical supplies off associated equipment before performing any adjustments, maintenance, or servicing the machine or taping heads.
- Never attempt to work on the taping head or load tape while the box drive system is running.

Tape Latch Alignment – Figure 5-1

The Latching tape drum assembly is pre-set to accommodate 48mm [2 inch] wide tape. The tape drum assembly is adjustable to provide alignment of narrower tapes.

To move the latch to a position that corresponds to a new tape core width (**Figure 5-1**):

1. Remove screw from the latch.
2. Move to the latch to the position that corresponds to the tape core width.
3. Replace screw in the new latch location.

To adjust or center the tape width on the centerline of the taping head (box center seam) (**Figure 5-2**):

1. Loosen the locking hex nut behind tape drum bracket on tape drum shaft. Use an adjustable wrench or 25mm open end wrench.
2. Turn tape drum shaft in or out to center the tape web (use 5mm 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 5-3

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.

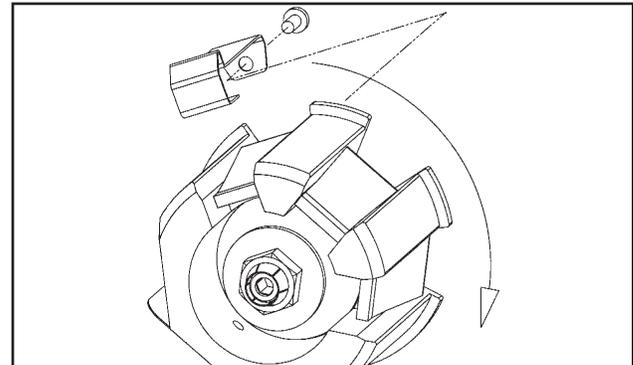


Figure 5-1 Tape Latch Alignment

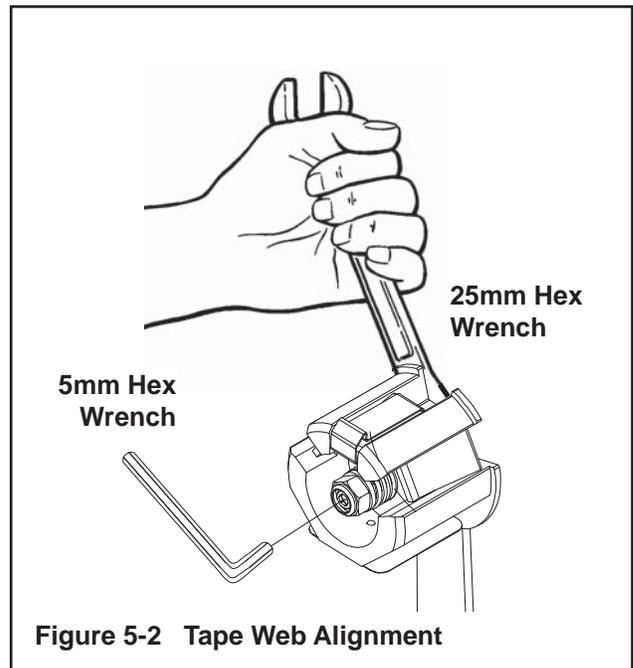


Figure 5-2 Tape Web Alignment

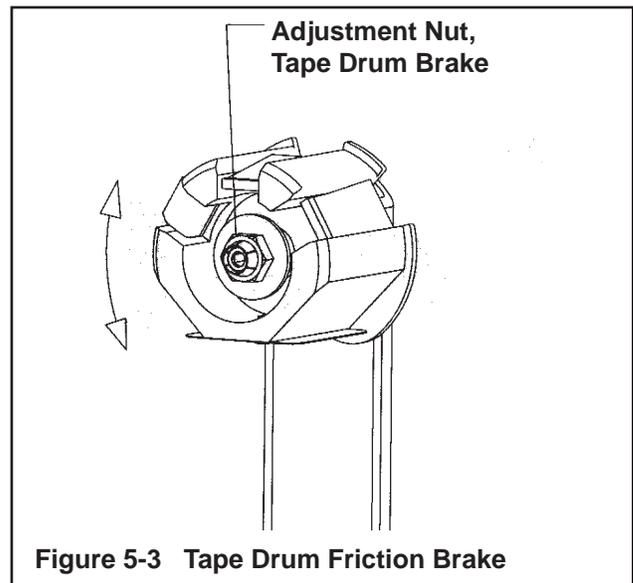


Figure 5-3 Tape Drum Friction Brake

(Adjustments continued on next page.)



WARNING

- **To reduce risk associated with shear, pinch, and entanglement hazards:**
 - Turn air and electrical supplies off associated equipment before performing any adjustments, maintenance, or servicing the machine or taping heads.
 - Never attempt to work on the taping head or load tape while the box drive system is running.

Applying Mechanism Spring

The applying mechanism spring, shown in **Figures 5-4**, controls applying and buffing roller pressure on the box and returns the mechanism to the reset position. The spring pressure is pre-set for normal operation.

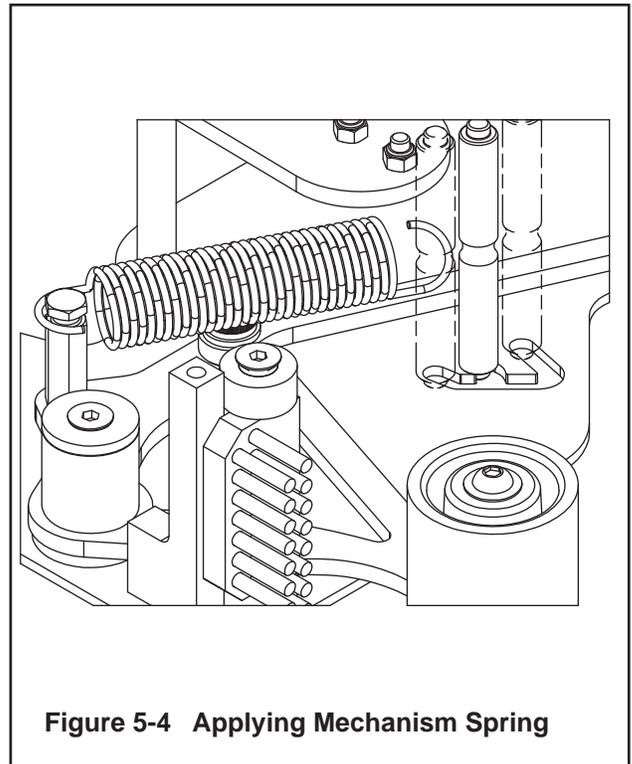


Figure 5-4 Applying Mechanism Spring

One-Way Tension Roller Figure 5-5

The one-way tension roller is factory set. When replacing this assembly, the roller must have approximately 0.5 kg to 0.9 kg [1 to 2 lbs.] 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.

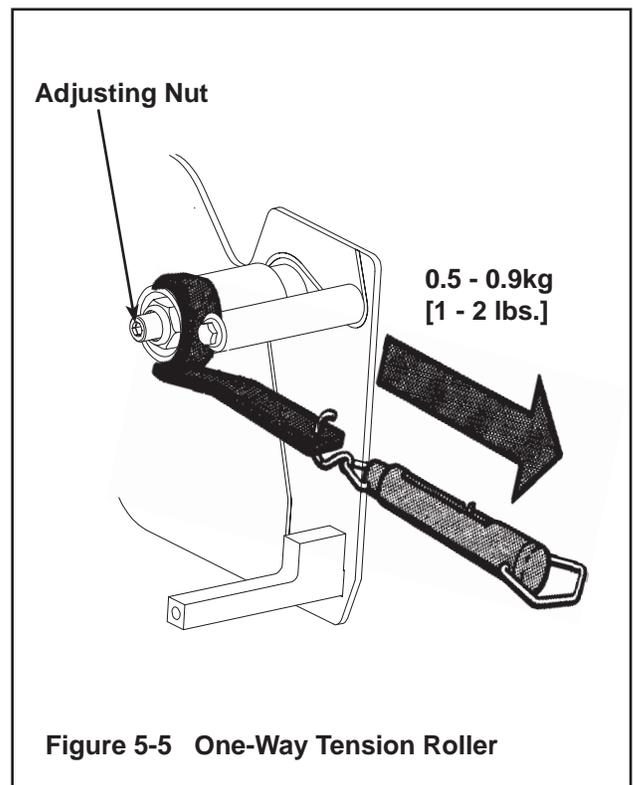


Figure 5-5 One-Way Tension Roller

(Adjustments continued on next page)

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
	Tape tracks to one side or drags on the support tabs of applying frame	Adjust the tape web alignments
	The blade is dull and/or has broken teeth	Replace the blade
The blade does not cut tape or the tape end is jagged or shredded	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
	Cutter Spring is missing or stretched	Replace the defective spring
	Tension roller surface is not fully contacting the taping head frame	Make sure one-way bearing is below the surface of the tension roller. If not, press bearing further into roller or replace roller.
Taping Head not positioned properly	Adjust Taping Head so there is less than 1/8" gap between case and upper assembly	

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	Re-thread the tape
	Taping Head not positioned properly	Adjust Taping Head so there is less than 1/8" gap between case and upper assembly
The tape end does not stay in application position in front of the applying roller	The tape is incorrectly threaded	Re-thread the tape
	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 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

Listed below are tools that are included with tape head. These parts should be kept in a convenient location to assist in routine maintenance and set-up of the tape head.

NPH SST 2" Upper Taping Head

Qty.	Part Number	Description
1	78-8176-4522-7	Tube Wrench (17mm)
1	78-8091-0405-8	Wrench - Open End 19/25

NPH SST 2" Lower Taping Head

Qty.	Part Number	Description
1	78-8176-4522-7	Tube Wrench (17mm)
1	78-8091-0405-8	Wrench - Open End 19/25

In addition to the tools included with the taping head are a list of suggested spare parts that should be ordered and kept on hand. These parts will require replacement under normal wear of the tape head.

Qty.	Part Number	Description
1	78-8137-5694-3	Roller – Applying (Upper)
1	78-8137-5694-3	Roller – Applying (Lower)
1	78-8137-5899-8	Roller - Buffing Assembly (Upper)
1	78-8137-5899-8	Roller - Buffing Assembly (Lower)
1	78-8134-2370-0	Spring - Upper
1	78-8134-2388-2	Spring - Lower
1	78-8134-2345-2	Spring - Torsion Blade Guard (Upper)
1	78-8137-7094-4	Spring - Torsion Blade Guard (Lower)
1	78-8062-3993-1	Blade
1	78-8134-2344-5	Spring - Cutter
4	78-8137-5753-7	Washer - Friction Plastic

Replacement Parts and Service

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

Replacement Parts Illustrations and Parts Lists

NPH SST 2 Inch Upper Taping Head, Type 11200 / Part Number 70-0067-5068-4

NPH SST 2 Inch Lower Taping Head, Type 11200 / Part Number 70-0067-5067-6

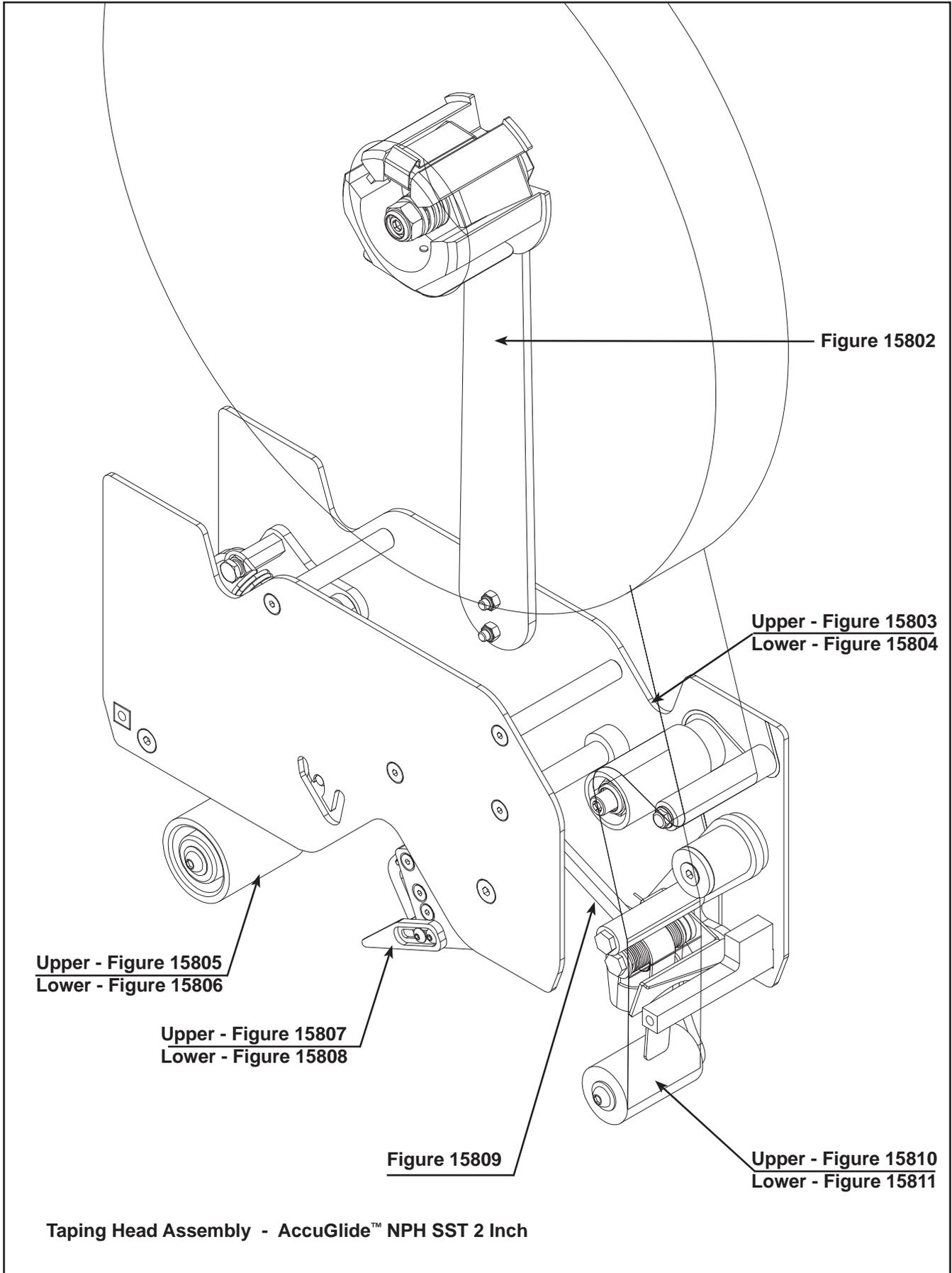
1. Refer to the Taping Head Assemblies Figure to find all the parts illustrations identified by figure numbers.
2. Refer to the figure or figures to determine the individual parts required and the parts reference number.
3. The replacement parts list, that follows each illustration, includes the part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

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

4. Refer to 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.

THIS PAGE IS BLANK



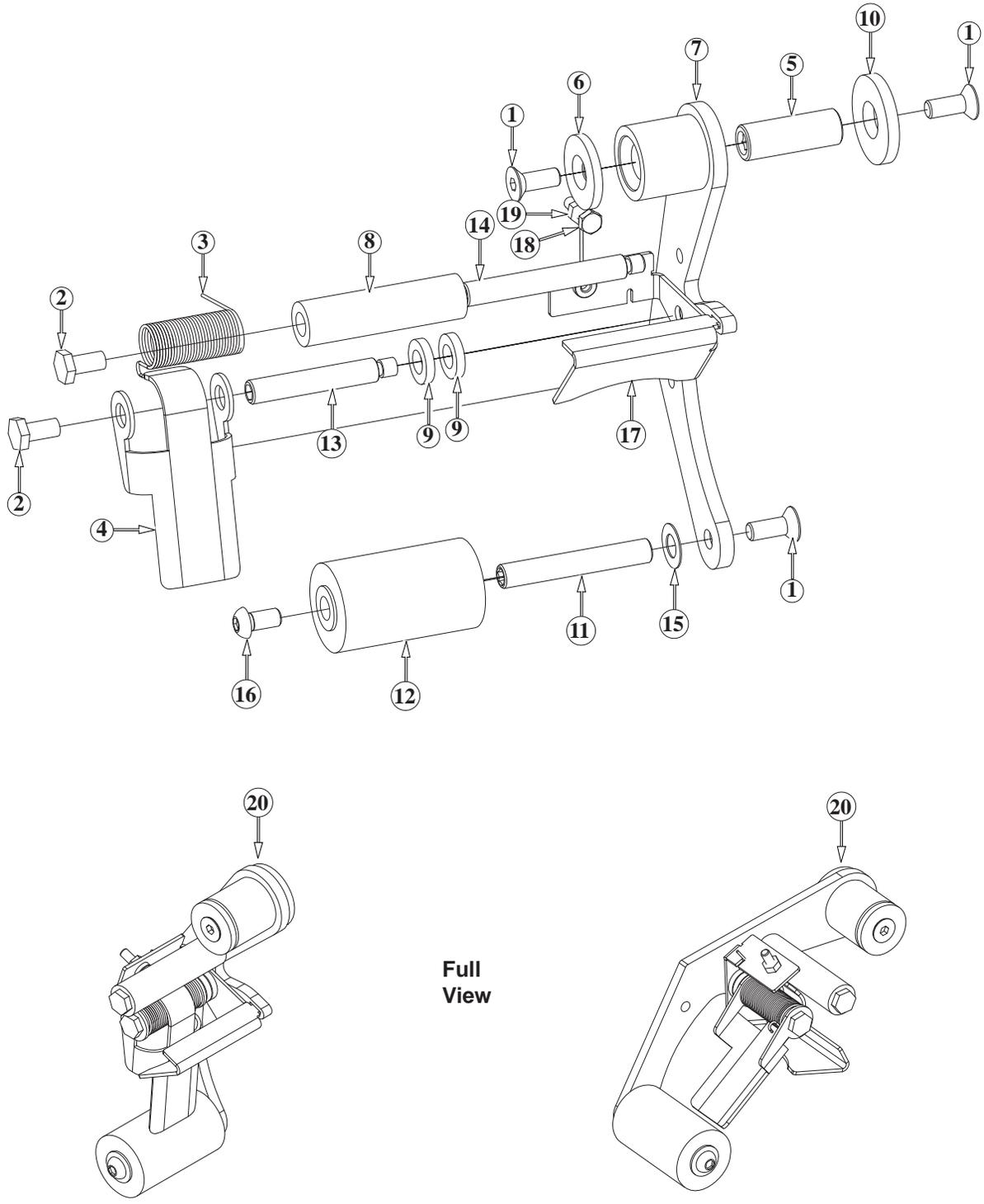


Figure 15810 - Upper Taping Head / Applying Assembly

NPH SST 2"

Figure 15810 - Upper Taping Head / Applying Assembly

Ref. No.	3M Part No.	Description
15810-1	78-8137-7041-5	Screw - Flat Soc Hd, M6 X 16 (SST)
15810-2	78-8060-8204-2	Screw - Hex Hd, M6 X 12 (SST)
15810-3	78-8134-2345-2	Spring - Torsion (SST)
15810-4	78-8137-6990-4	Assembly - Tape Support (SST)
15810-5	78-8137-6992-0	Shaft - Pivot (SST)
15810-6	78-8137-5684-4	Cap - Pivot
15810-7	78-8137-6993-8	Apply Arm Assembly (Upper) (SST)
15810-8	78-8137-5690-1	Roller - Wrap Swivel
15810-9	78-8137-5691-9	Spacer - Roller
15810-10	78-8137-5692-7	Washer - Thrust Plastic
15810-11	78-8137-6996-1	Shaft - Roller Apply (SST)
15810-12	78-8137-5694-3	Roller - Apply Assembly
15810-13	78-8137-6997-9	Shaft - Tape Support Pivot (SST)
15810-14	78-8137-6998-7	Shaft - Wrap Swivel (SST)
15810-15	78-8137-5753-7	Washer - Friction Plastic
15810-16	78-8137-7042-3	Screw - M6-1 X 12mm (SST)
15810-17	78-8137-7063-9	Fork - Formed 2" Reverse Bend (SST)
15810-18	78-8137-7058-9	Fastener - M4 X 5/8" (16mm) HHC (SST)
15810-19	78-8137-7059-7	Nut - Hex M4 (SST)
15810-20	78-8137-6989-6	Apply Roller Assembly (Upper) (SST)

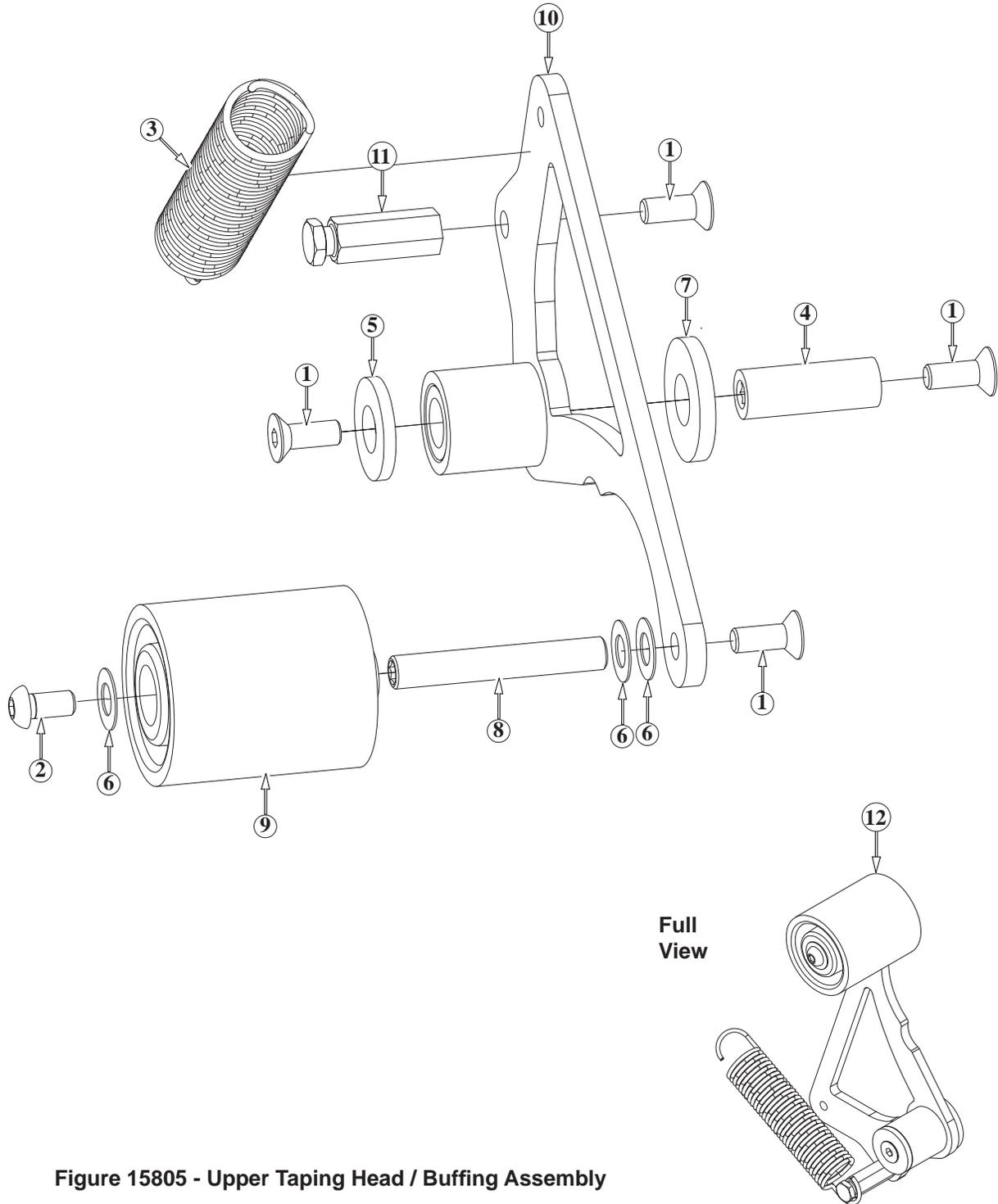


Figure 15805 - Upper Taping Head / Buffing Assembly

NPH SST 2"

Figure 15805 - Upper Taping Head / Buffing Assembly

Ref. No.	3M Part No.	Description
15805-1	78-8137-7041-5	Screw - Flat Soc Hd, M6 X 16 (SST)
15805-2	78-8137-7042-3	Screw - Hex Hd, M6-1.00 X 12mm (SST)
15805-3	78-8134-2370-0	Spring - Upper (Silver) (SST)
15805-4	78-8137-6992-0	Shaft - Pivot (SST)
15805-5	78-8137-5684-4	Cap - Pivot
15805-6	78-8137-5753-7	Washer - Friction Plastic
15805-7	78-8137-5692-7	Washer - Thrust Plastic
15805-8	78-8137-6996-1	Shaft - Roller Apply (SST)
15805-9	78-8137-5899-8	Roller - Buffing Assembly
15805-10	78-8137-7001-9	Buffing Arm Assembly (Upper) (SST)
15805-11	78-8137-7004-3	Post - Spring Buffing (SST)
15805-12	78-8137-7000-1	Buffing Roller Assembly (Upper) (SST)

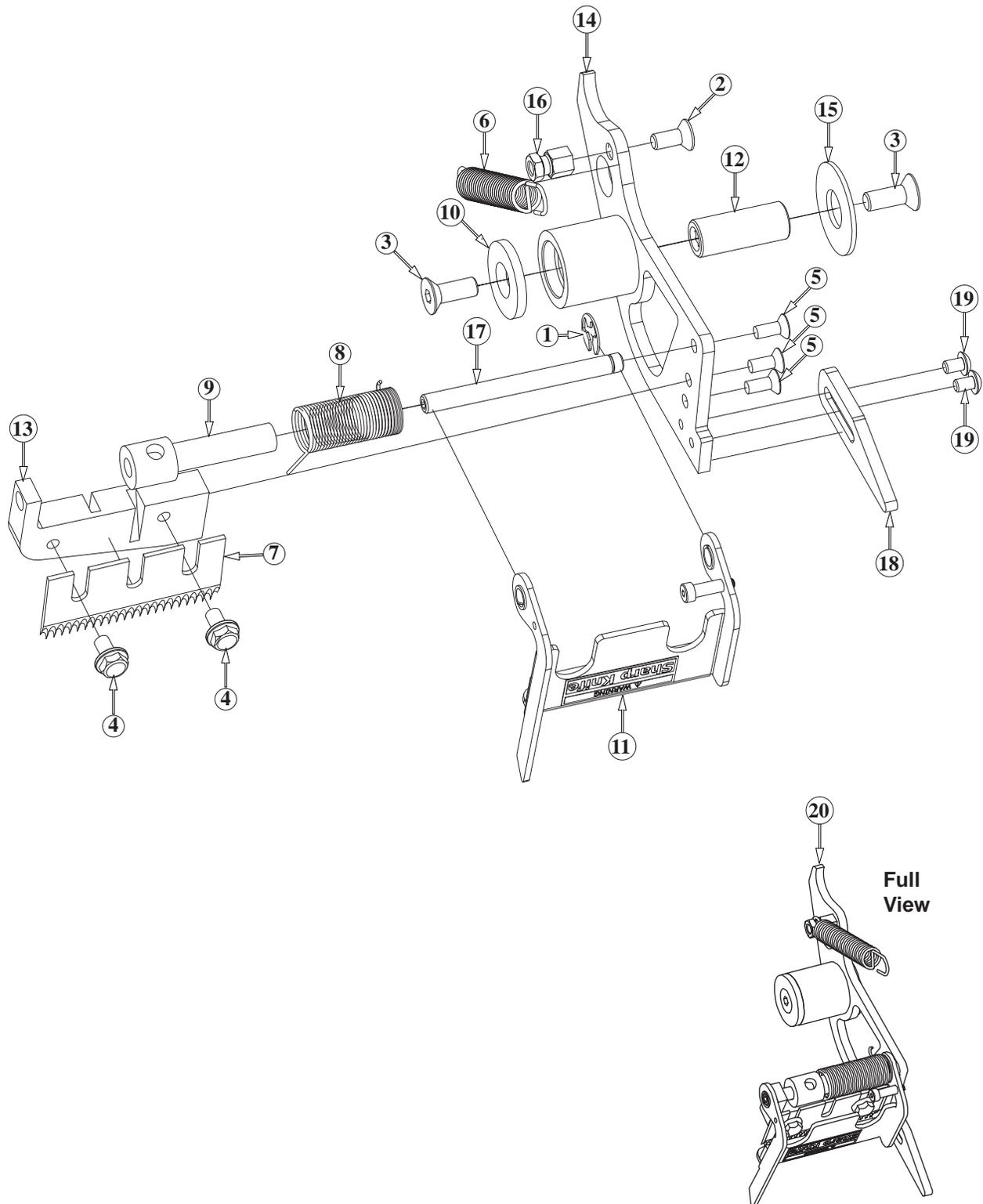


Figure 15807 - Upper Taping Head / Blade Guard Assembly

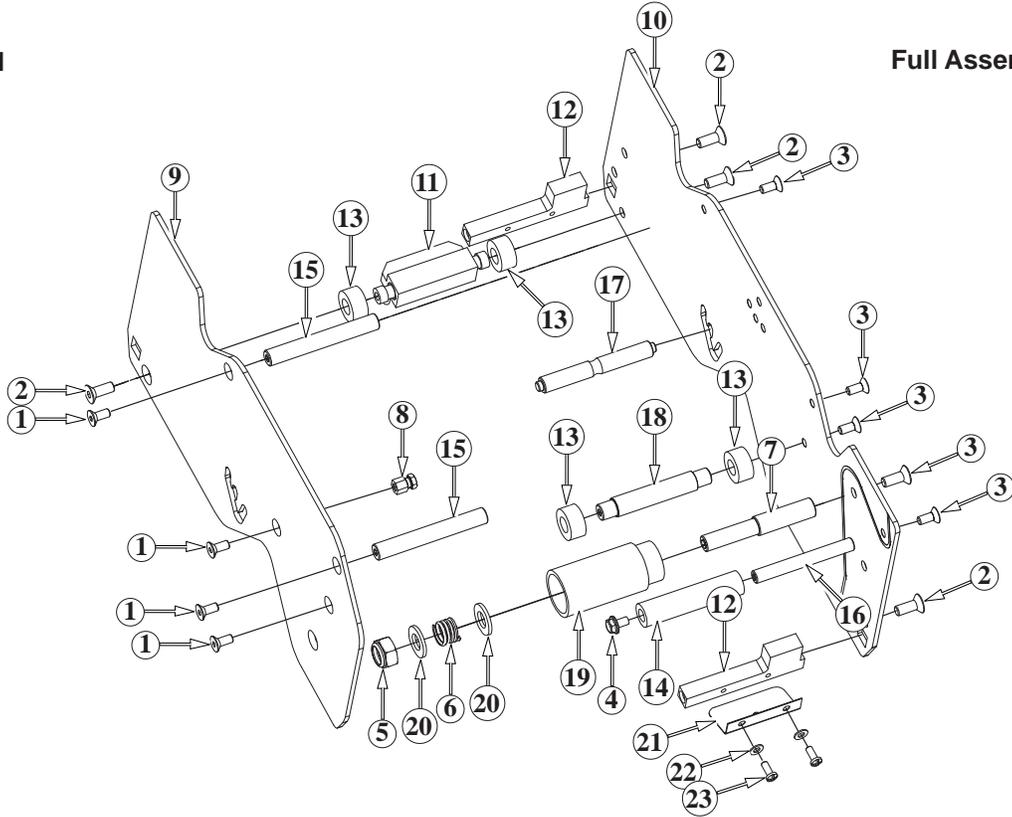
NPH SST 2"

Figure 15807 - Upper Taping Head / Blade Guard Assembly

Ref. No.	3M Part No.	Description
15807-1	78-8137-7043-1	Ring - Retaining 5mm (SST)
15807-2	78-8137-7044-9	Screw - Flat Soc Hd, M5 X 12 (SST)
15807-3	78-8137-7041-5	Screw - Flat Soc Hd, M6 X 16 (SST)
15807-4	78-8060-8342-0	Screw - Hex Hd M5 X 8 w/ Ext Lock Washer (SST)
15807-5	78-8137-7045-6	Screw - Flat Hd, Soc Dr, M4 X 10 (SST)
15807-6	78-8134-2344-5	Spring - Cutter
15807-7	78-8062-3993-1	Blade (2")
15807-8	78-8134-2345-2	Spring - Torsion Blade Guard (SST)
15807-9	78-8113-7067-1	Bushing - 47.7mm Long
15807-10	78-8137-5684-4	Cap - Pivot
15807-11	78-8137-7007-6	Blade Guard Assembly (Upper) (SST)
15807-12	78-8137-7009-2	Shaft - Pivot Cutoff (SST)
15807-13	78-8137-7010-0	Block - Knife Mount (SST)
15807-14	78-8137-7011-8	Cutoff Arm Assembly (Upper) (SST)
15807-15	78-8137-5712-3	Bearing - Thrust
15807-16	78-8137-7014-2	Post - Cutoff Spring (SST)
15807-17	78-8137-7015-9	Shaft - Guard Pivot (SST)
15807-18	78-8137-7016-7	Extension - Cutoff
15807-19	78-8137-7046-4	Fastener M4 X 1/4" (6mm) (SST)
15807-20	78-8137-7005-0	Cut Off Guard Assembly (Upper) (SST)

Version 1

Full Assembly = 24



Version 2

Full Assembly = 35
"Little David"

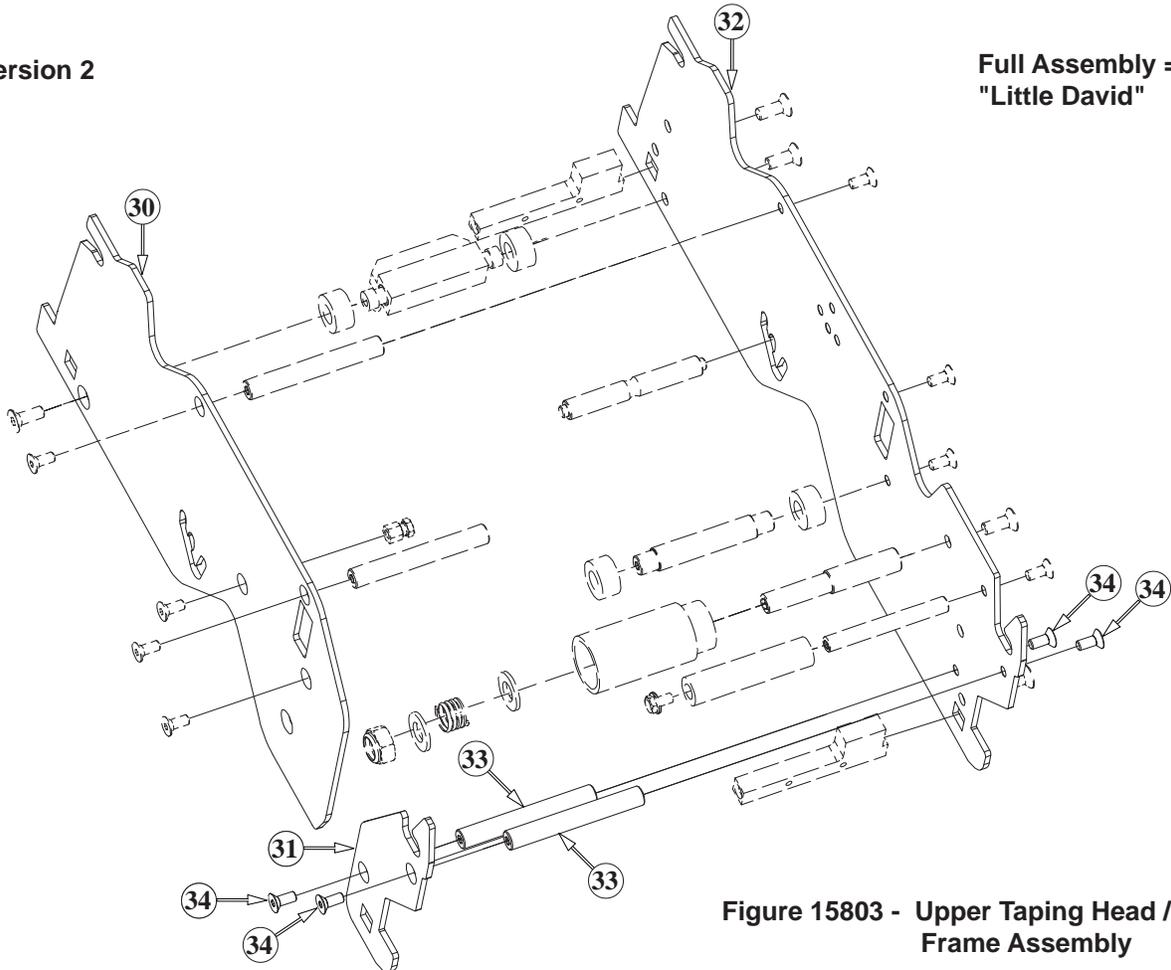


Figure 15803 - Upper Taping Head /
Frame Assembly

NPH SST 2"

Figure 15803 - Upper Taping Head / Frame Assembly

Ref. No.	3M Part No.	Description
Version 1 and Version 2:		
15803-1	78-8137-7044-9	Screw - Flat Soc Hd, M5 X 12 (SST)
15803-2	78-8137-7041-5	Screw - Flat Soc Hd, M6 X 16 (SST)
15803-3	78-8137-7047-2	Screw - Flat Hd, Hex Dr, M5 X 10 (SST)
15803-4	78-8060-8342-0	Screw - Hex Hd M5 X 8 w/ Ext Th Lock Washer (SST)
15803-5	78-8060-8201-8	Nut - Self Locking, M10 X 1
15803-6	78-8060-8354-5	Spring - Compression
15803-7	78-8137-7018-3	Shaft - Tension Roller 1 1/2" Th (SST)
15803-8	78-8137-7014-2	Post - Cutoff Spring (SST)
15803-9	78-8137-7019-1	Frame - Front (Upper) (SST)
15803-10	78-8137-7020-9	Frame - Tape Mount (Upper w/ Path) (SST)
15803-11	78-8137-7021-7	Brush Assembly (SST)
15803-12	78-8137-7022-5	Spacer - Mounting Block (SST)
15803-13	78-8137-5724-8	Bumper - Stop 10 X 20 X 10L
15803-14	78-8137-5725-5	Roller - Wrap
15803-15	78-8137-7023-3	Shaft - Spacer (SST)
15803-16	78-8137-7024-1	Shaft - Roller Wrap (SST)
15803-17	78-8137-7025-8	Shaft - Spring Adjust (SST)
15803-18	78-8137-7026-6	Shaft - Bumper (SST)
15803-19	78-8137-5719-8	Roller - Tension 2 inch CCW
15803-20	78-8060-8315-6	Washer - Flat, M10
15803-21	78-8137-7055-5	Plate - Front Flap Guide
15803-22	78-8060-8297-6	Washer - Flat, M4 (SST)
15803-23	78-8137-7061-3	Screw - Phillips Hd, M4 X 14 (SST)
15803-24	78-8137-7017-5	Frame Assembly (Upper) (SST)
Version 2 Only (see illustration):		
15803-30	78-8137-7036-5	Frame - Front Exit (Upper) (SST)
15803-31	78-8137-7035-7	Frame - Front Entry (Upper) (SST)
15803-32	78-8137-7034-0	Frame - Tape Mount (Upper) (SST)
15803-33	78-8137-7023-3	Shaft - Spacer (SST)
15803-34	78-8137-7047-2	Screw - Flat Hd., Hex Dr, M5 X 10 (SST)
15803-35	78-8137-6983-9	Frame Assembly - Little David (Upper) (SST)

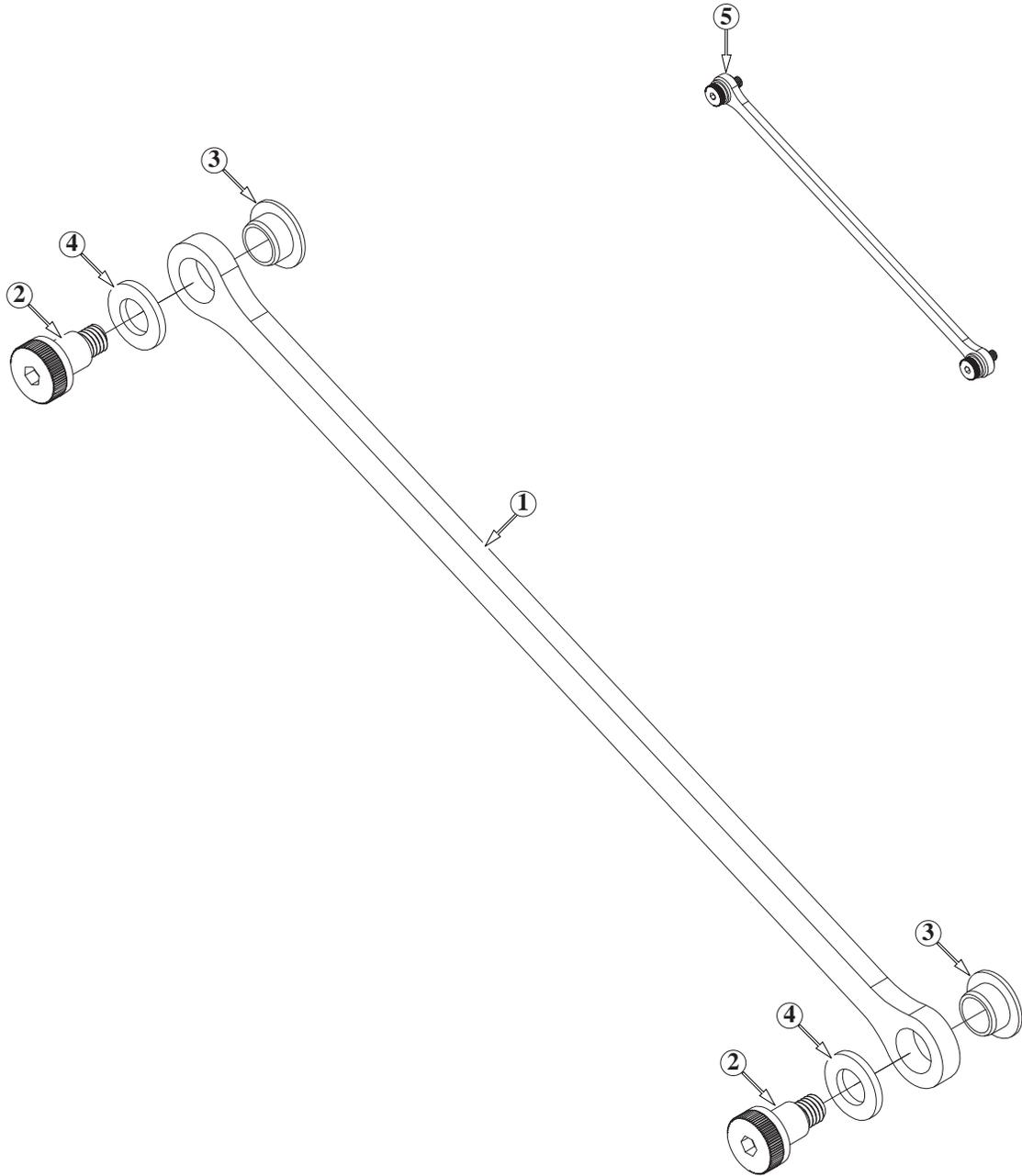


Figure 15809 - Upper and Lower Taping Head / Arm Assembly

NPH SST 2"

Figure 15809 - Upper and Lower Taping Head / Arm Assembly

Ref. No.	3M Part No.	Description
15809-1	78-8137-7028-2	Arm - Link (SST)
15809-2	78-8137-7060-5	Bolt - Shoulder M6 - 8 Dia X 10L (SST)
15809-3	78-8137-5733-9	Bearing - Flanged Acetal 8 X 10 X 5L
15809-4	78-8137-5734-7	Bearing - Thrust
15809-5	78-8137-7027-4	Link Arm Assembly (SST)

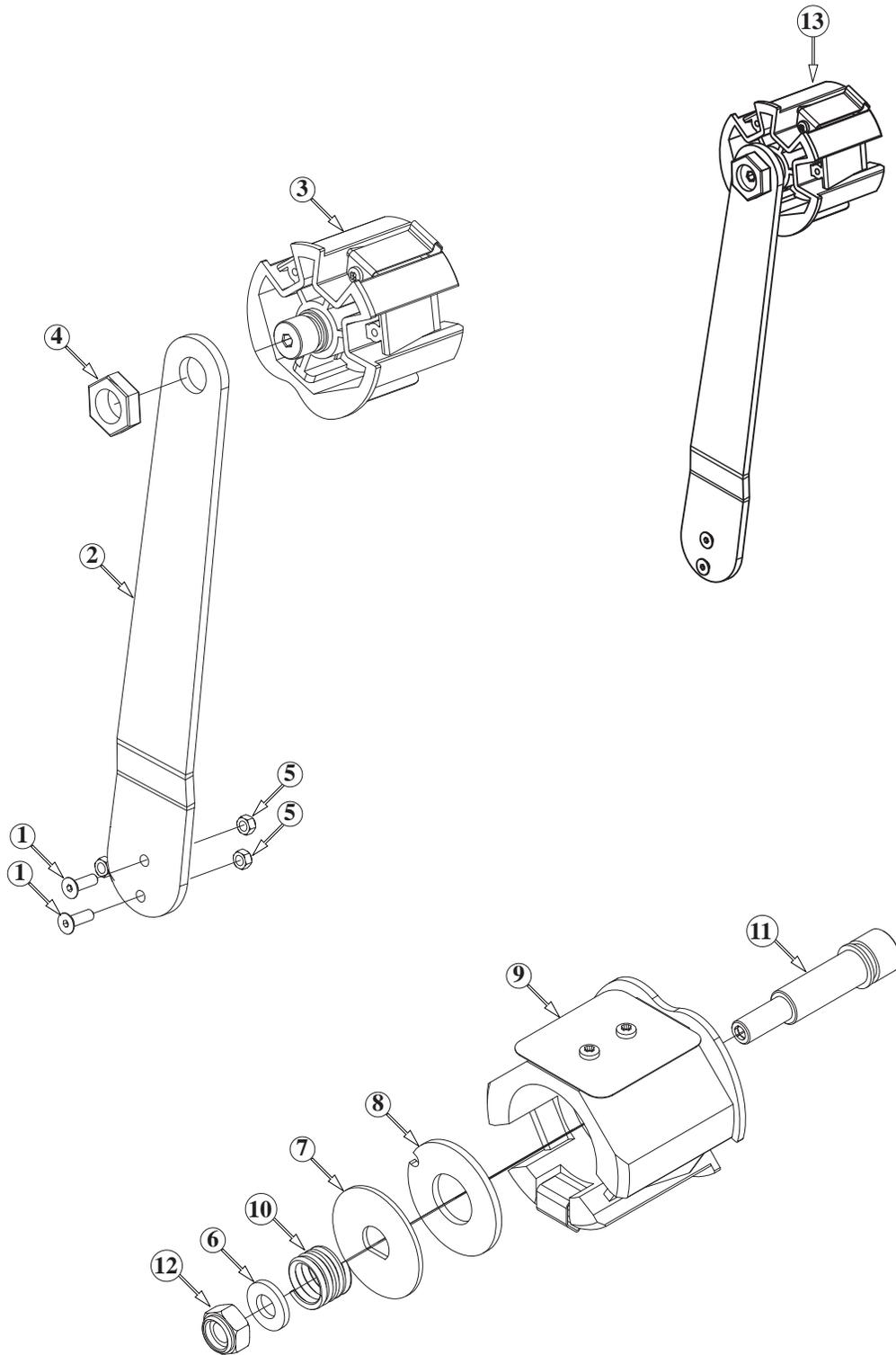
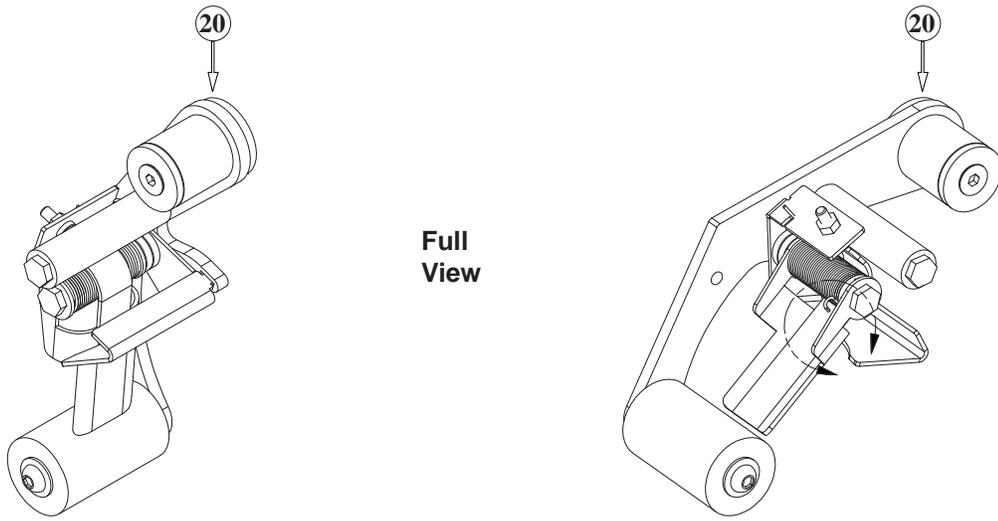


Figure 15802 - Upper and Lower Taping Head / Taping Head Assembly

NPH SST 2"

Figure 15802 - Upper and Lower Taping Head / Taping Head Assembly

Ref. No.	3M Part No.	Description
15802-1	78-8137-7050-6	Screw - Flat Hd Hex Dr, M5 X 16 (SST)
15802-2	78-8137-7062-1	Arm - Tape Drum (SST)
15802-3	78-8137-7031-6	Tape Drum Assembly - 2 Inch (SST)
15802-4	78-8134-1938-5	Nut - M18 X 1
15802-5	78-8137-7048-0	Nut - Self Locking, M5 (SST)
15802-6	78-8060-8315-6	Washer - Flat, M10
15802-7	78-8134-1939-3	Washer - Tape Drum
15802-8	78-8060-8172-1	Washer - Friction
15802-9	78-8134-2381-7	Tape Drum Sub-Assembly - 2 Inch (SST)
15802-10	78-8134-1940-1	Spring - Core Holder
15802-11	78-8137-7032-4	Shaft - Drum (SST)
15802-12	78-8060-8201-8	Nut - Self Locking, M10 X 1
15802-13	78-8137-7029-0	Tape Roll Mount Assembly (Lower) (SST)



Full View

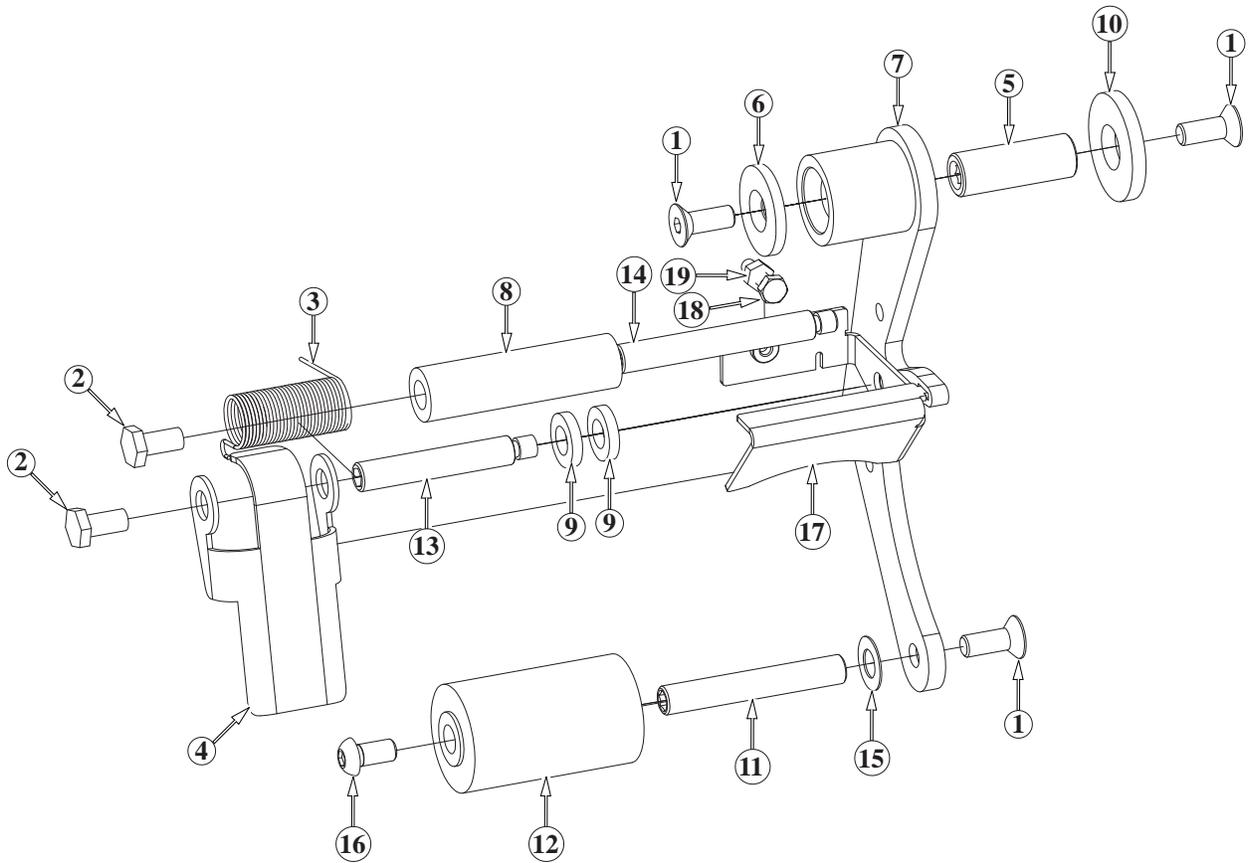


Figure 15811 - Lower Taping Head / Applying Arm Assembly

NPH SST 2"

Figure 15811 - Lower Taping Head / Applying Arm Assembly

Ref. No.	3M Part No.	Description
15811-1	78-8137-7041-5	Screw - Flat Soc Hd, M6 X 16 (SST)
15811-2	78-8060-8204-2	Screw - Hex Hd, M6 X 12 (SST)
15811-3	78-8137-7094-4	Spring - Torsion Blade Guard
15811-4	78-8137-6990-4	Assembly - Tape Support (SST)
15811-5	78-8137-6992-0	Shaft - Pivot (SST)
15811-6	78-8137-5684-4	Cap - Pivot
15811-7	78-8137-7070-4	Apply Arm Assembly - (Lower) (SST)
15811-8	78-8137-5690-1	Roller - Wrap Swivel
15811-9	78-8137-5691-9	Spacer - Roller
15811-10	78-8137-5692-7	Washer - Thrust Plastic
15811-11	78-8137-6996-1	Shaft - Roller Apply (SST)
15811-12	78-8137-5694-3	Roller - Apply Assembly
15811-13	78-8137-6997-9	Shaft - Tape Support Pivot (SST)
15811-14	78-8137-6998-7	Shaft - Wrap Swivel (SST)
15811-15	78-8137-5753-7	Washer - Friction Plastic
15811-16	78-8137-7042-3	Screw - Butt. Soc. Hd, M6-1 X 12mm (SST)
15811-17	78-8137-7064-7	Fork - Formed 2" Reverse Bend (Lower) (SST)
15811-18	78-8137-7058-9	Fastener - M4 X 5/8" (16mm) HHC (SST)
15811-19	78-8137-7059-7	Nut - Hex M4 (SST)
15811-20	78-8137-7068-8	Apply Roller Assembly (Lower) (SST)

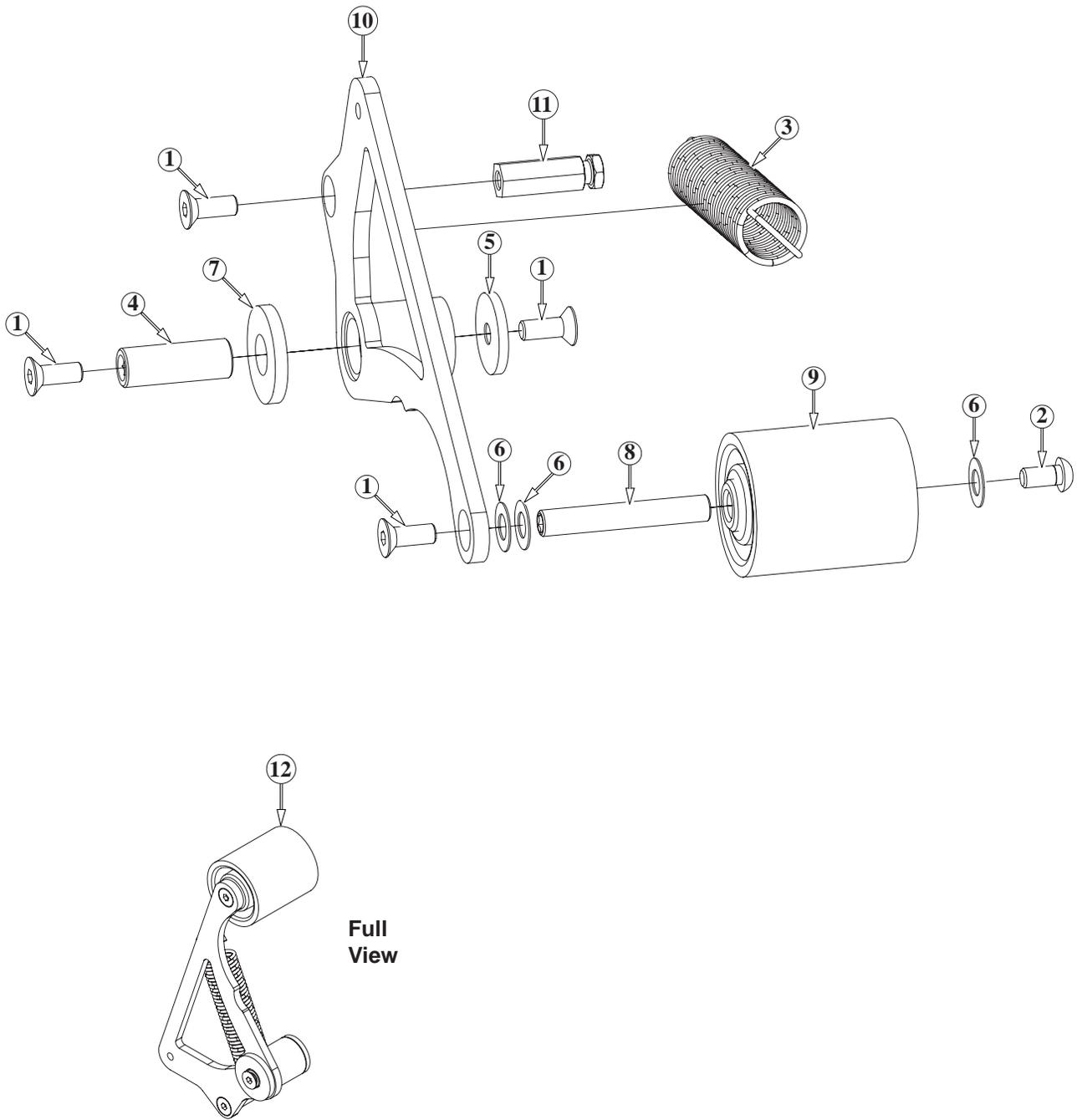


Figure 15806 - Lower Taping Head / Buffing Arm Assembly

NPH SST 2"

Figure 15806 - Lower Taping Head / Buffing Arm Assembly

Ref. No.	3M Part No.	Description
15806-1	78-8137-7041-5	Screw - Flat Soc Hd, M6 X 16 (SST)
15806-2	78-8137-7042-3	Screw - Hex Hd, M6-1.00 X 12mm Lg., Zinc Plated (SST)
15806-3	78-8134-2388-2	Spring - Lower (Silver) (SST)
15806-4	78-8137-6992-0	Shaft - Pivot (SST)
15806-5	78-8137-5684-4	Cap - Pivot
15806-6	78-8137-5753-7	Washer - Friction Plastic
15806-7	78-8137-5692-7	Washer - Thrust Plastic
15806-8	78-8137-6996-1	Shaft - Roller Apply (SST)
15806-9	78-8137-5899-8	Roller - Buffing Assembly
15806-10	78-8137-7074-6	Buffing Arm Assembly (Lower) (SST)
15806-11	78-8137-7004-3	Post - Spring Buffing (SST)
15806-12	78-8137-7073-8	Buffing Roller Assembly (Lower) (SST)

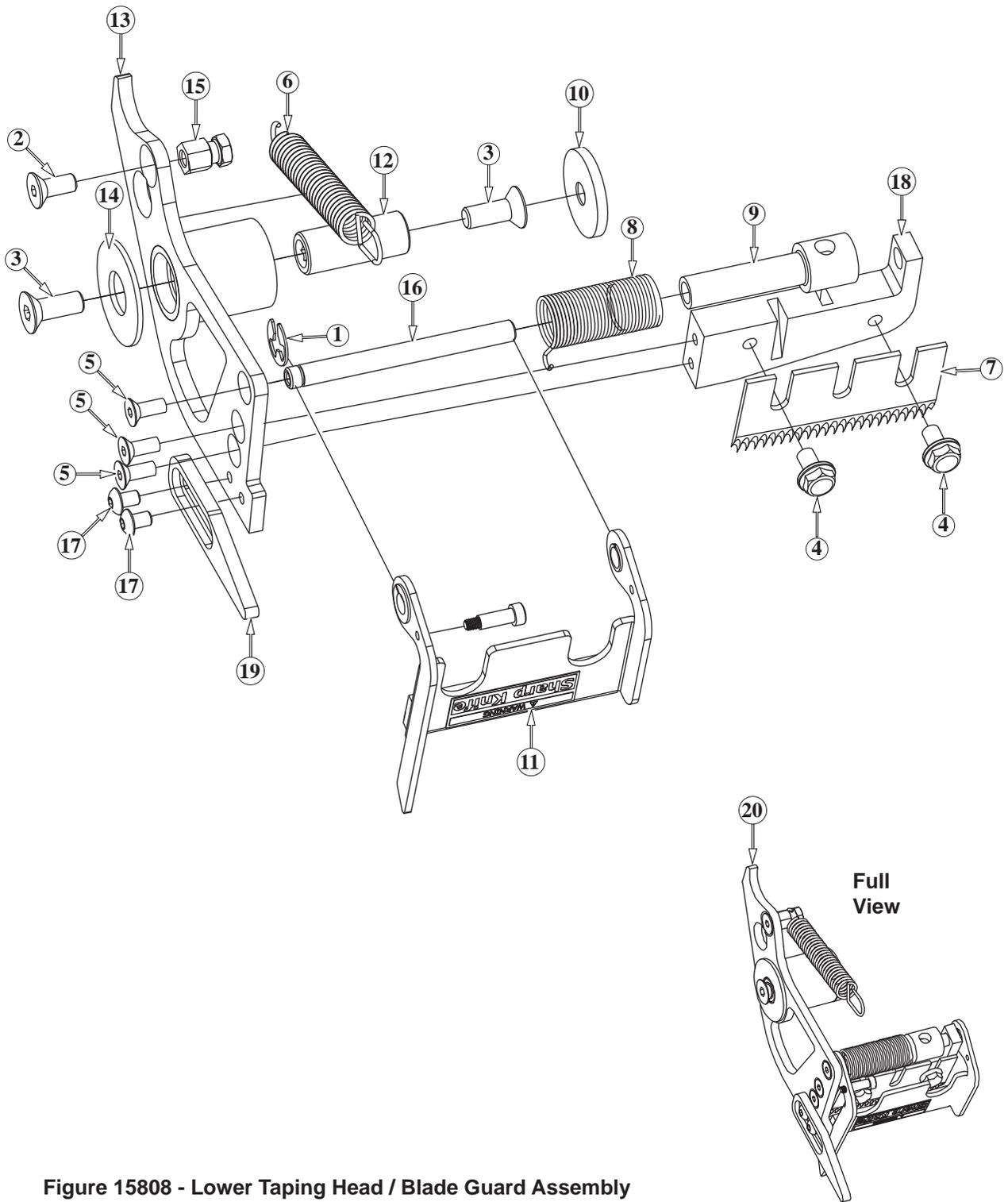


Figure 15808 - Lower Taping Head / Blade Guard Assembly

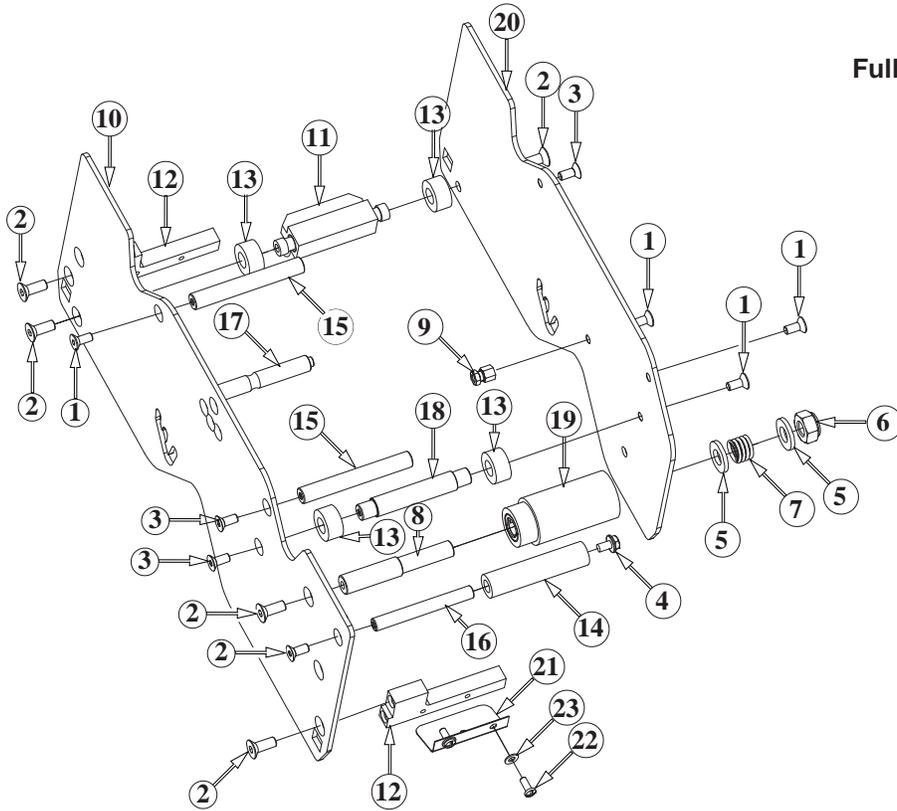
NPH SST 2"

Figure 15808 - Lower Taping Head / Blade Guard Assembly

Ref. No.	3M Part No.	Description
15808-1	78-8137-7043-1	Ring - Retaining 5mm (SST)
15808-2	78-8137-7044-9	Screw - Flat Soc Hd, M5 X 12 (SST)
15808-3	78-8137-7041-5	Screw - Flat Soc Hd, M6 X 16 (SST)
15808-4	78-8060-8342-0	Screw - Hex Hd M5 X 8 w/ Ext Lock Washer (SST)
15808-5	78-8137-7045-6	Screw - Flat Hd, Soc Dr, M4 X 10 (SST)
15808-6	78-8134-2344-5	Spring - Cutter
15808-7	78-8062-3993-1	Blade (2")
15808-8	78-8137-7094-4	Spring - Torsion Blade Guard
15808-9	78-8113-7067-1	Bushing - 47.7mm Long
15808-10	78-8137-5684-4	Cap - Pivot
15808-11	78-8137-7078-7	Blade Guard Assembly (Lower) (SST)
15808-12	78-8137-7009-2	Shaft - Pivot Cutoff (SST)
15808-13	78-8137-7079-5	Cutoff Arm Assembly (Lower) (SST)
15808-14	78-8137-5712-3	Bearing - Thrust
15808-15	78-8137-7014-2	Post - Cutoff Spring (SST)
15808-16	78-8137-7015-9	Shaft - Guard Pivot (SST)
15808-17	78-8137-7046-4	Fastener - M4 X 1/4" (6mm) (SST)
15808-18	78-8137-7082-9	Block - Knife Mount (Lower) (SST)
15808-19	78-8137-7083-7	Extension - Cutoff (Lower) (SST)
15808-20	78-8137-7077-9	Cut Off Guard Assembly (Lower) (SST)

Version 1

Full Assembly = 24



Version 2

Full Assembly = 35
"Little David"

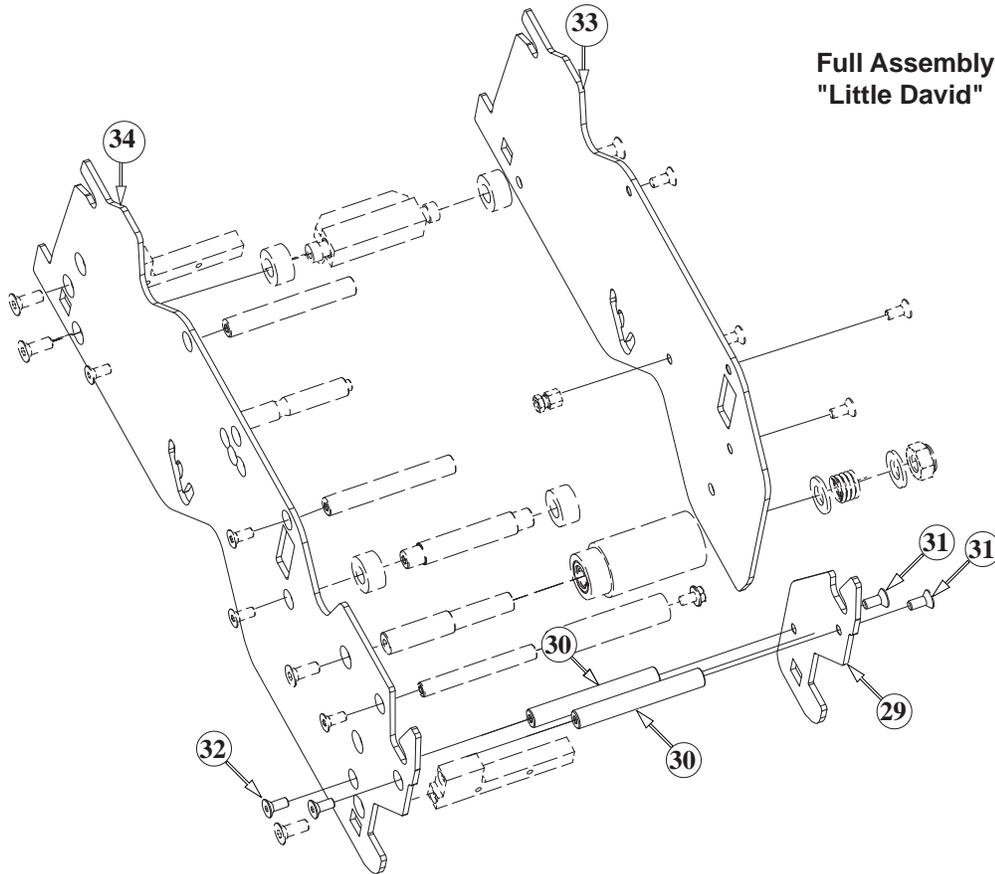


Figure 15804 - Lower Taping Head / Frame Assembly

NPH SST 2"

Figure 15804 - Lower Taping Head / Frame Assembly

Ref. No.	3M Part No.	Description
Version 1 and Version 2:		
15804-1	78-8137-7044-9	Screw - Flat Soc Hd, M5 X 12 (SST)
15804-2	78-8137-7041-5	Screw - Flat Soc Hd, M6 X 16 (SST)
15804-3	78-8137-7047-2	Screw - Flat Hd, Hex Dr, M5 X 10 (SST)
15804-4	78-8060-8342-0	Screw - Hex Hd M5 X 8 w/ Ext Th Lock Washer (SST)
15804-5	78-8060-8201-8	Nut - Self Locking, M10 X 1
15804-6	78-8060-8354-5	Spring - Compression
15804-7	78-8137-7018-3	Shaft - Tension Roller 1 1/2" Th (SST)
15804-8	78-8137-7014-2	Post - Cutoff Spring (SST)
15804-9	78-8137-7085-2	Frame - Tape Mount (Lower w/path) (SST)
15804-10	78-8137-7021-7	Brush Assembly (SST)
15804-11	78-8137-7022-5	Spacer - Mounting Block (SST)
15804-12	78-8137-5724-8	Bumper - Stop 10 X 20 X 10L
15804-13	78-8137-5725-5	Roller - Wrap
15804-14	78-8137-7023-3	Shaft - Spacer (SST)
15804-15	78-8137-7024-1	Shaft - Roller Wrap (SST)
15804-16	78-8137-7025-8	Shaft - Spring Adjust (SST)
15804-17	78-8137-7026-6	Shaft - Bumper (SST)
15804-18	78-8137-6927-6	Roller - Tension 2 inch
15804-19	78-8137-7086-0	Frame - Front (Lower) (SST)
15804-20	78-8060-8315-6	Washer - Flat, M10
15804-21	78-8137-7055-5	Plate - Front Flap Guide
15804-22	78-8060-8297-6	Washer - Flat M4 (SST)
15804-23	78-8137-7061-3	Screw - Pan Hd., M4 X 14mm (SST)
15804-24	78-8137-7090-2	Frame Assembly (Lower) (SST)
Version 2 Only (see illustration):		
15804-30	78-8137-7023-3	Shaft - Spacer (SST)
15804-31	78-8137-7044-9	Screw - Flat Hd., Soc, M5 X 12 (SST)
15804-32	78-8137-7087-8	Frame - Front Exit (Lower) (SST)
15804-33	78-8137-7089-4	Frame - Tape Mount (Lower) (SST)
15804-34	78-8137-7088-6	Frame - Front Entry (Lower) (SST)
15804-35	78-8137-7090-2	Frame Assembly - "Little David" (Lower) (SST)

THIS PAGE IS BLANK

