

Instructions and Parts List

3M-Matic™

Accuglide™

NPH Taping Heads

2 Inch

Type 21700

Serial #: _____

For reference, record machine serial number here.

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.

Replacement Parts and Service Information

To Our Customers:

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

Included with each machine is an Instructions manual.

Technical Assistance / Replacement Parts and Additional Manuals:

For technical assistance, contact our 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: Model - Accuglide NPH (2 inch) Taping Head - Type 21700 - Serial Number 13282).

To order replacement parts, contact us:

CSPD division of Combi Packaging Systems LLC.

5365 East Center Dr. N.E.

Canton, OH 44721

1-800-344-9883

e-mail: CSPD-CSR@combi.com

www.combi.com

Identification Plate

3M 3M Company St. Paul, MN 55144 USA	Part Number	3M-Matic™ For Commercial Use Only			
	Model	Year	Ampere	Watt	4000 563
Type	Serial Number	Volt	Hertz	Phase	

Replacement Parts and Service Information *(continued)*

To Our Customers:

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

Included with each machine is an Instructions 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.

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(Upper and Lower Taping Heads)

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Warranty

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, THE IMPLIED WARRANTY OF MERCHANTABILITY, THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE AND ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, A CUSTOM OR USAGE OF TRADE:

3M sells its **3M-Matic™ Accuglide NPH Taping Head, Type 21700** with the following warranties:

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 three (1) years 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 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.

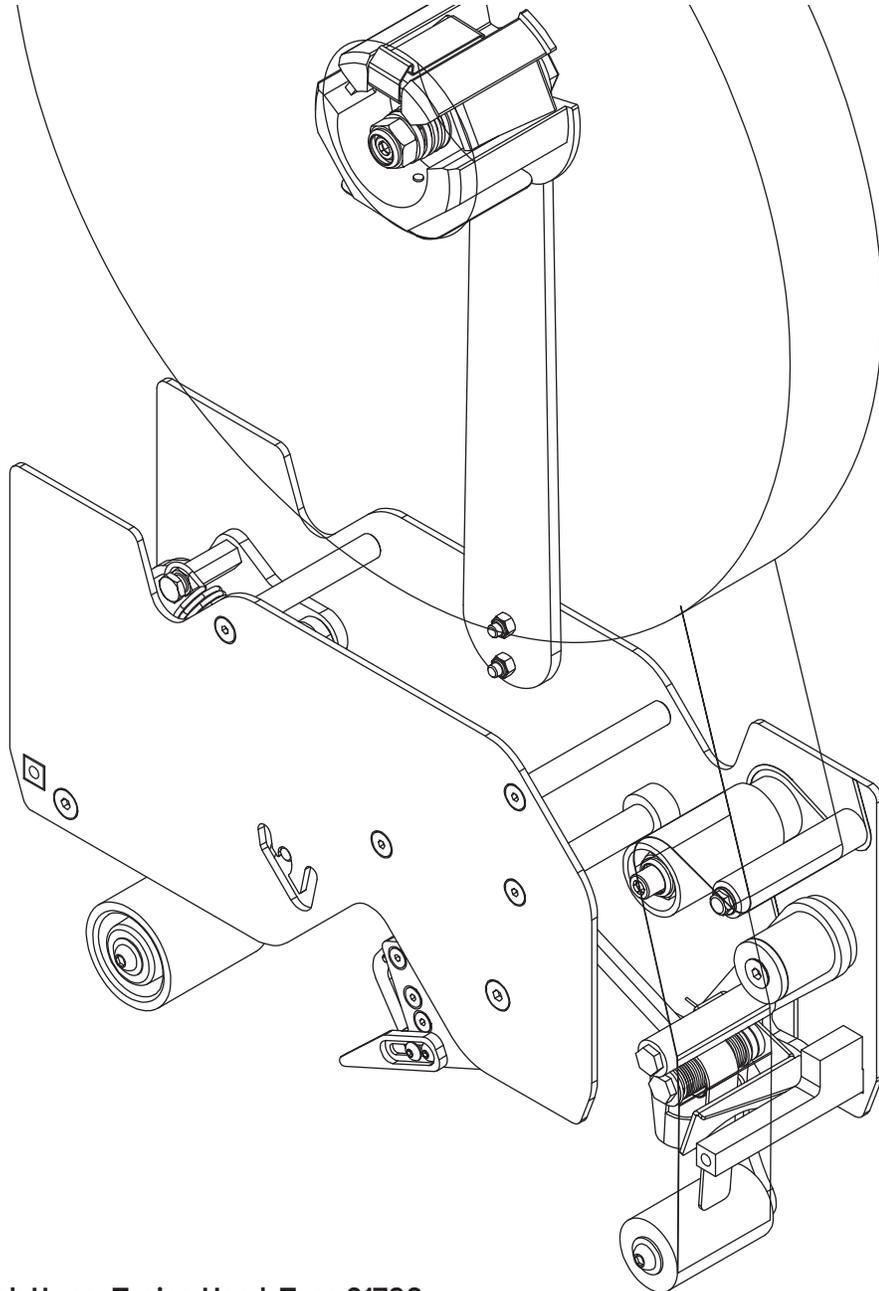
Note: The foregoing Equipment Warranty and Limited Remedy and Limitation of Liability may be changed only by a written agreement signed by authorized representatives of 3M and seller.

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

Intended Use

The intended use of the **AccuGlide™ NPH - 2 Inch** 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 also 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 **AccuGlide™ NPH Taping Heads - 2 Inch** has been designed and tested for use with Scotch® pressure-sensitive film box sealing tape.



NPH 2 inch Upper Taping Head, Type 21700

Taping Head Contents

AccuGlide™ NPH - 2 Inch Upper and Lower Taping Heads consist of:

Qty.	Part Name
1	Taping Head Assembly
1	Tape Drum and Bracket Assembly

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 **Accuglide NPH (2 inch)** 3M Industrial Adhesives and Tapes Division 3M Center, Bldg. 220-5E-06 St. Paul, MN 55144-1000 (USA) Edition June 2017/ Copyright 3M 2017. All rights reserved. The manufacturer reserves the right to change the product at any time without notice.

Publication © 3M 2017. 44-0009-2151-8.

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.

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: Model - Accuglide NPH - 2" - Type 21700).

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

Explanation of Signal Word and Possible Consequences



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



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.



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



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 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



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.

(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.

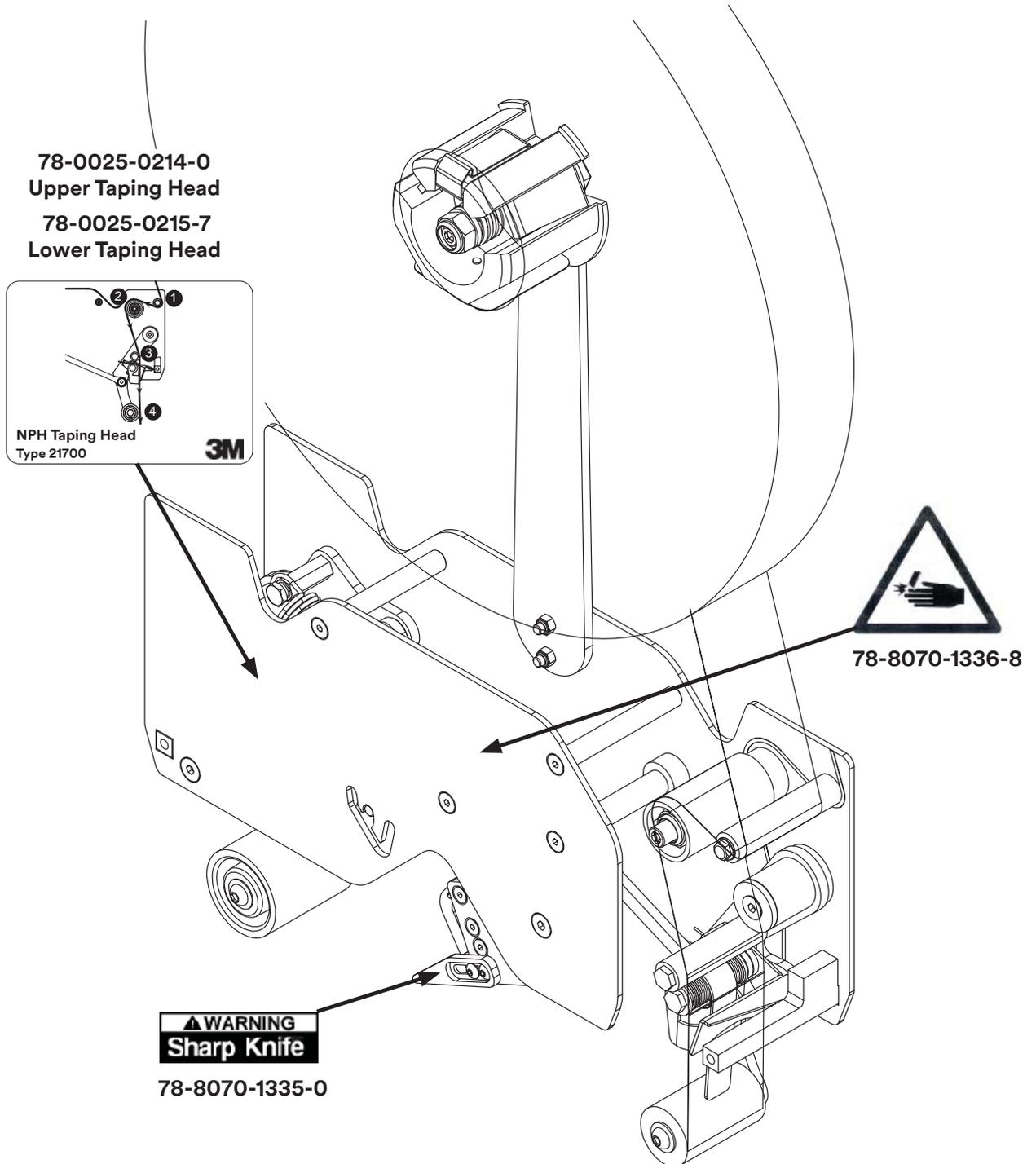


Figure 1-1 Replacement Labels/3M Part Numbers

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]

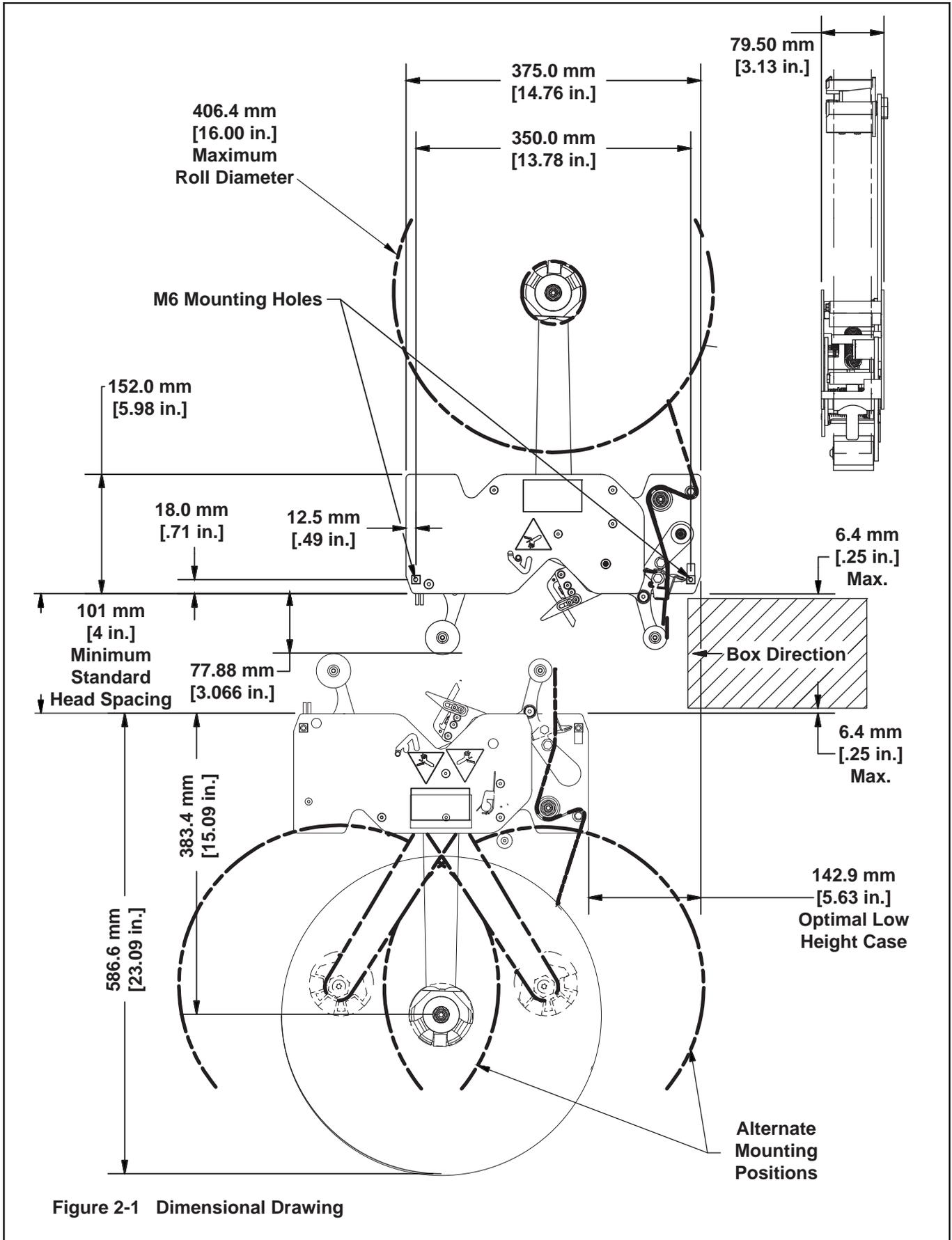
* **Note:** Box size capacities may also be determined by the case conveying system used.

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.)

Specifications (continued)



Installation



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.

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 Capacities,” as well as **Figure 2-1** in the Specifications section, for following points making installations:

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.



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.

2. If a pusher or cleated conveyor is being used, steps should be taken in 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” set-up procedure.

Operation

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

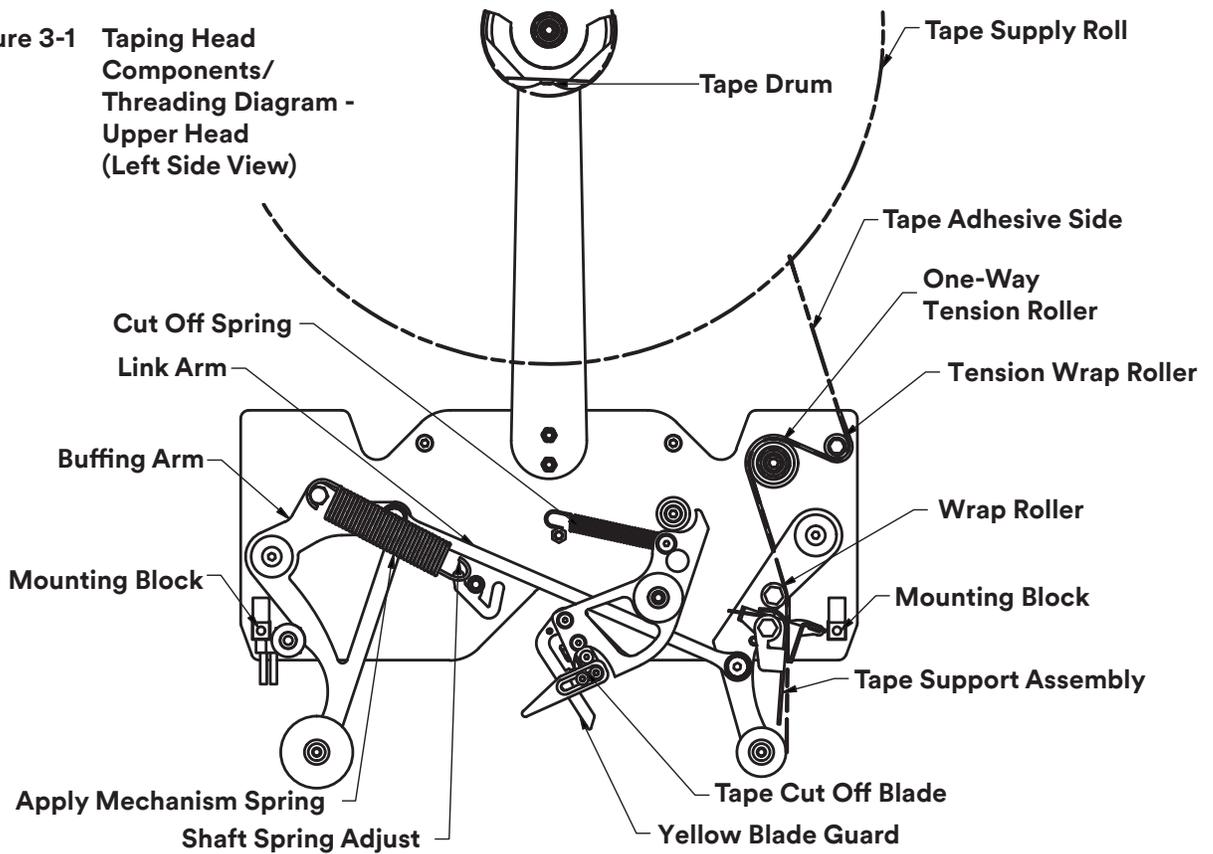
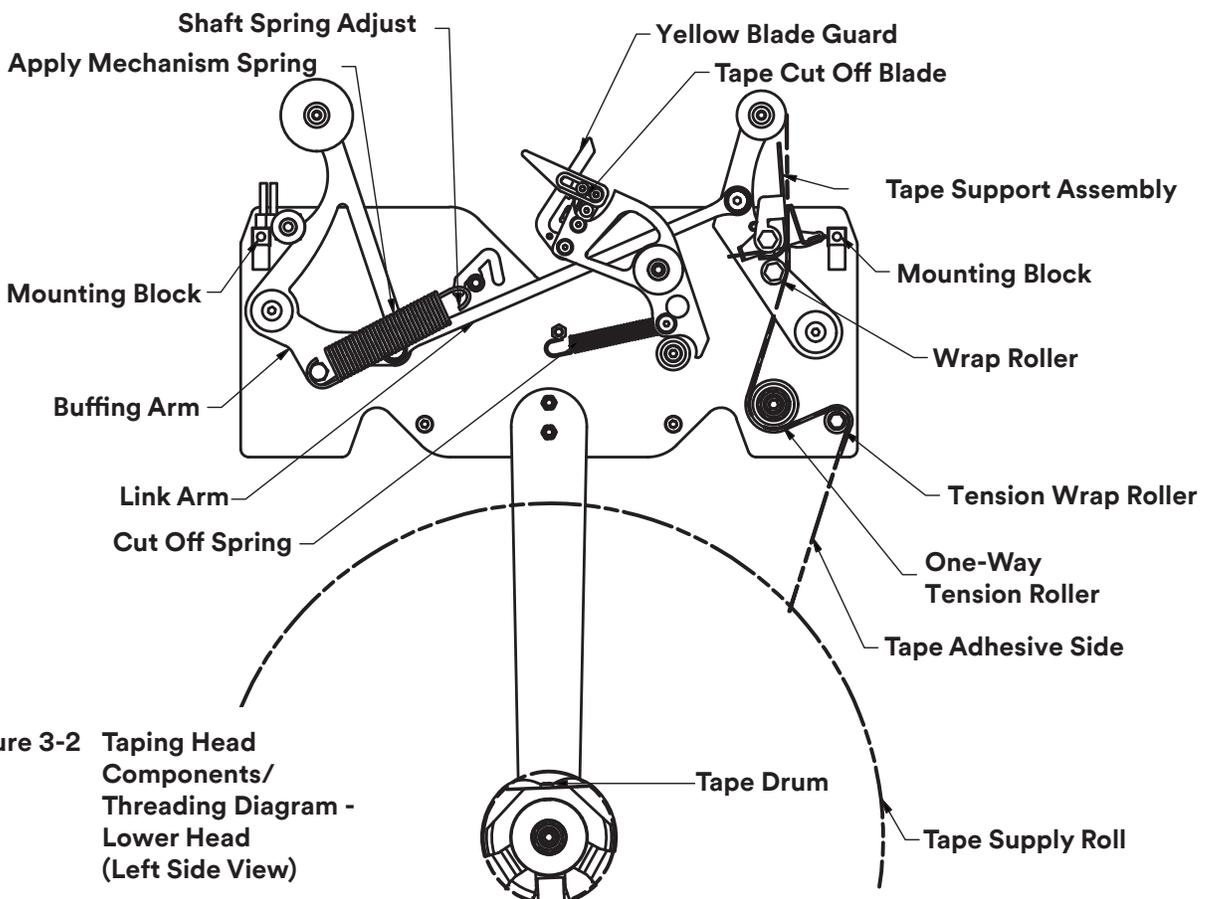


Figure 3-2 Taping Head Components/
Threading Diagram -
Lower Head
(Left Side View)





Warning

- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange 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: If practical, remove tape roll before removing taping head from machine to minimize weight.

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 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.



Warning

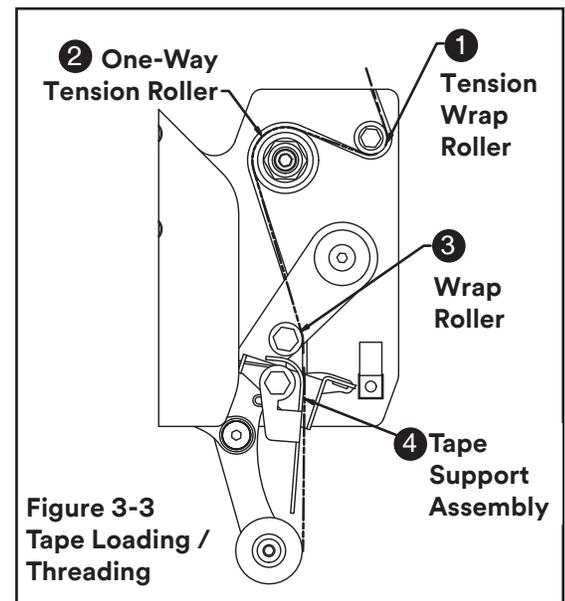
- **To reduce the risk associated with shear, pinch, and entanglement hazards**
 - Turn air and electrical supplies off on associated equipment before performing any adjustments, maintenance, or servicing the taping heads
 - Never attempt to work on the taping head or load tape while the box drive system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



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

Figure 3-2: Insert threading needle through rollers in direction indicated by arrows.



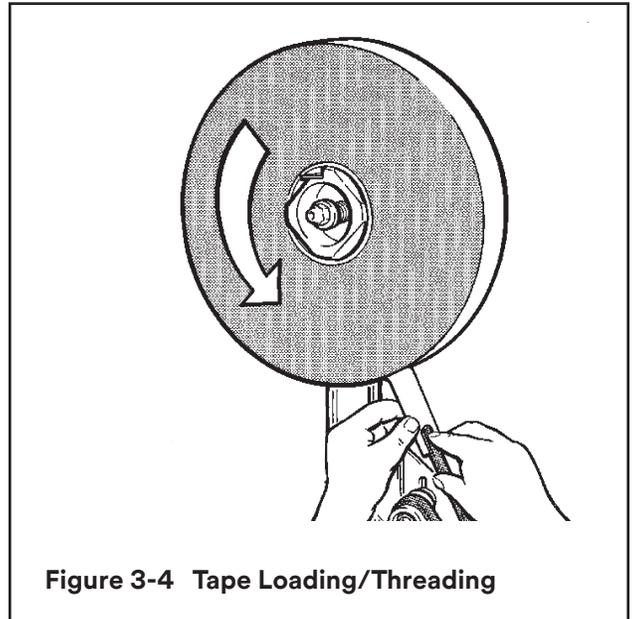
Operation *(continued)*

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.

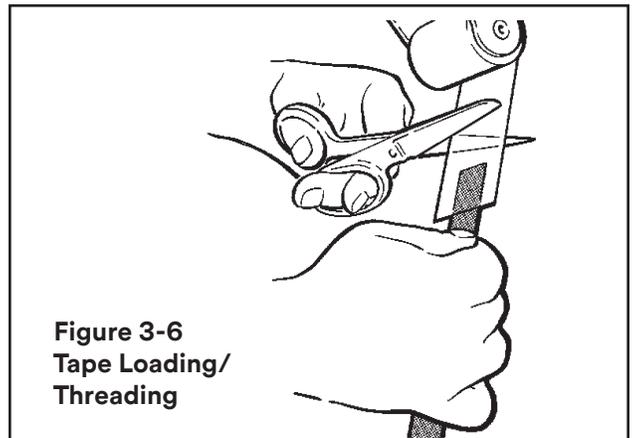
Manually turn tape roll to create slack tape while pulling tape through tape applying mechanism until needle is through and tape is in alignment with applying roller.

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



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.



Maintenance

The **NPH 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.

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) 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.

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

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

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.



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

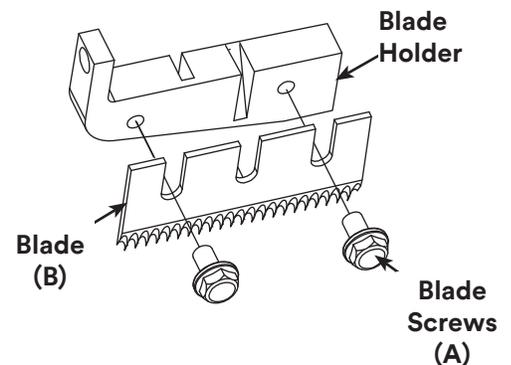


Figure 4-1 Blade Replacement



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.

(maintenance *continued* on next page.)

Maintenance (continued)

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 components and onto sliding surfaces. Dirt in these areas can cause serious equipment damage.

Never wash down or subject taping heads to conditions causing moisture condensation on components. Serious equipment damage happen.

Applying/Buffering Roller Replacement

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

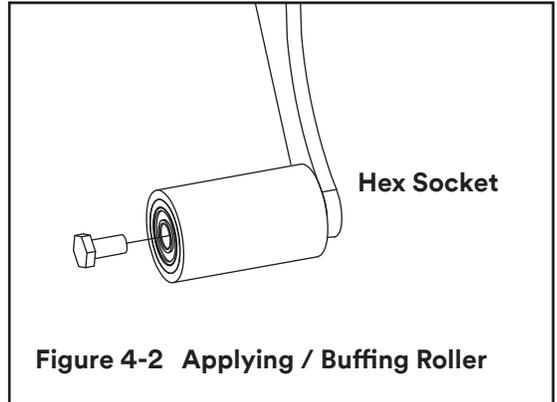


Figure 4-2 Applying / Buffering Roller

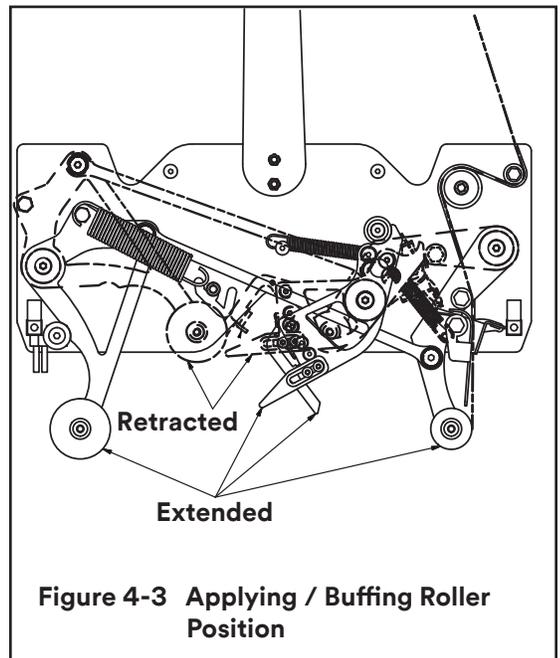


Figure 4-3 Applying / Buffering Roller Position

	Warning
<ul style="list-style-type: none">• To reduce the risk associated with sharp blade hazards:<ul style="list-style-type: none">- Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp.	

	Warning
<ul style="list-style-type: none">• To reduce the risk associated with shear, pinch, and entanglement hazards<ul style="list-style-type: none">- 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.	

Adjustments

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 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.



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.

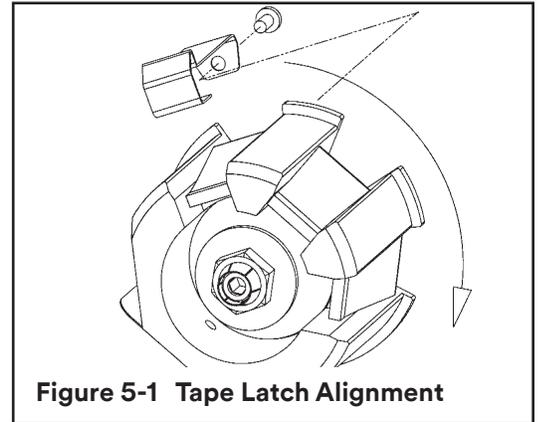


Figure 5-1 Tape Latch Alignment

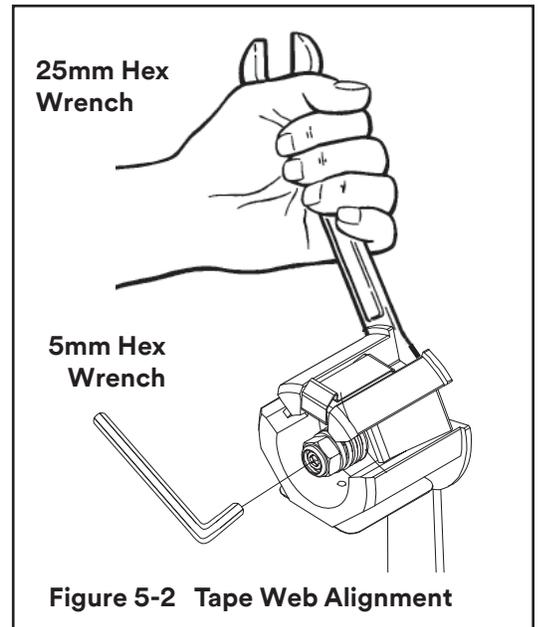


Figure 5-2 Tape Web Alignment

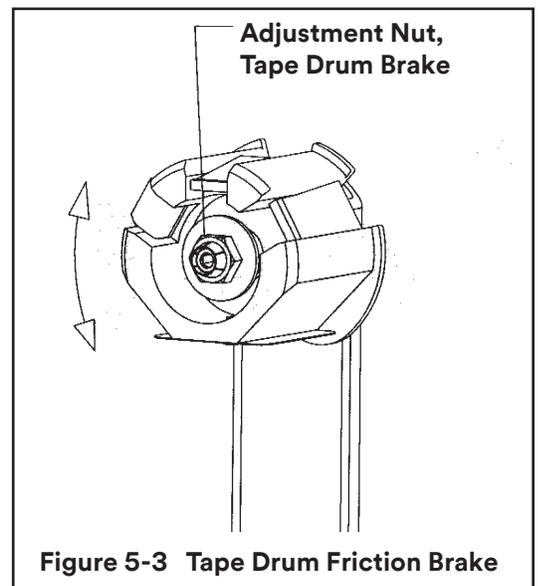


Figure 5-3 Tape Drum Friction Brake

(adjustments *continued* on next page.)

Adjustments *(continued)*

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.

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.

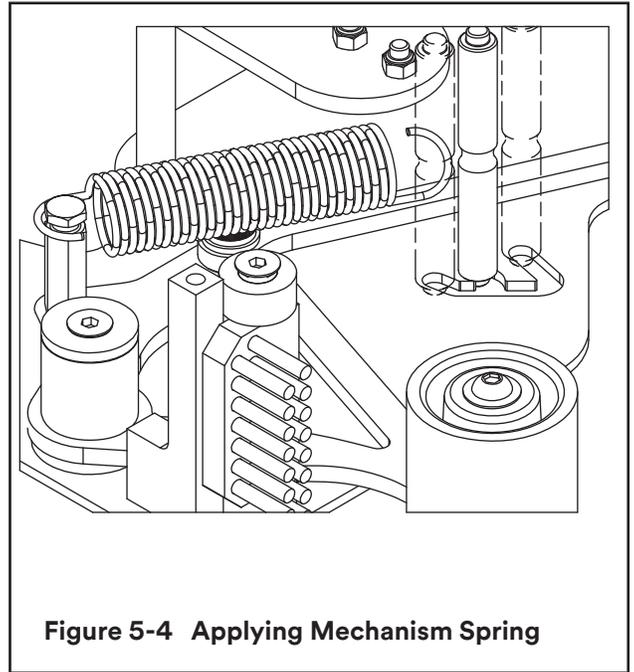


Figure 5-4 Applying Mechanism Spring

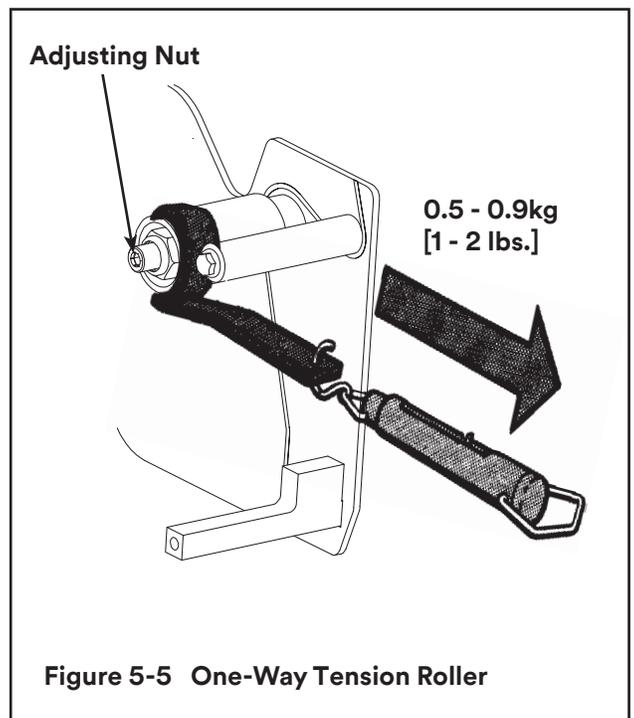


Figure 5-5 One-Way Tension Roller

(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

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
The tape end does not stay in application position in front of the applying roller	Taping Head not positioned properly	Adjust Taping Head so there is less than 1/8" gap between case and upper assembly
	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
Tape not centered on box seam	The one-way tension roller is defective	Replace the one-way tension roller
	Tape drum not centered	Reposition tape drum
	Centering guides not centered	Adjust centering guides
	Box flaps not of equal length	Check box specifications

(continued on next page)

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 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 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	78-0025-0102-7	Spring - Cutter
1	78-0025-0105-0	Blade (2")
1	78-0025-0106-8	Spring - Upper (Black)
1	78-0025-0116-7	Spring - Torsion Blade Guard (Upper)
1	78-0025-0128-2	Roller - Apply Assembly
4	78-0025-0164-7	Washer - Friction Plastic
1	78-0025-0170-4	Roller - Buffing Assembly
1	78-0025-0196-9	Spring - Torsion Blade Guard (Lower)
1	78-0025-0211-6	Spring - Lower (Black)

Replacement Parts and Service

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

Spare Parts/Service Information

Replacement Parts Illustrations and Parts Lists

NPH 2 Inch Upper Taping Head, Type 21700

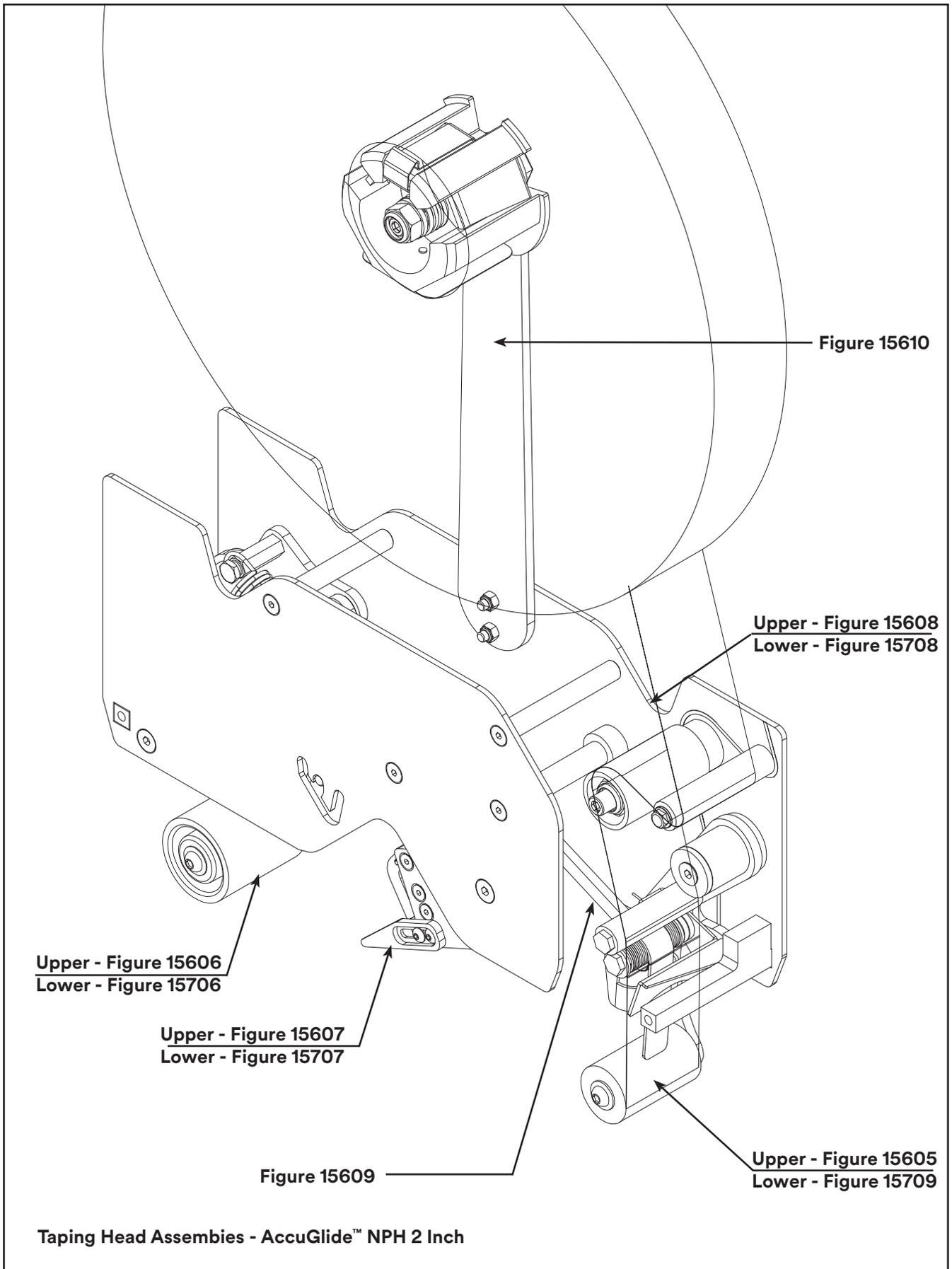
NPH 2 Inch Lower Taping Head, Type 21700

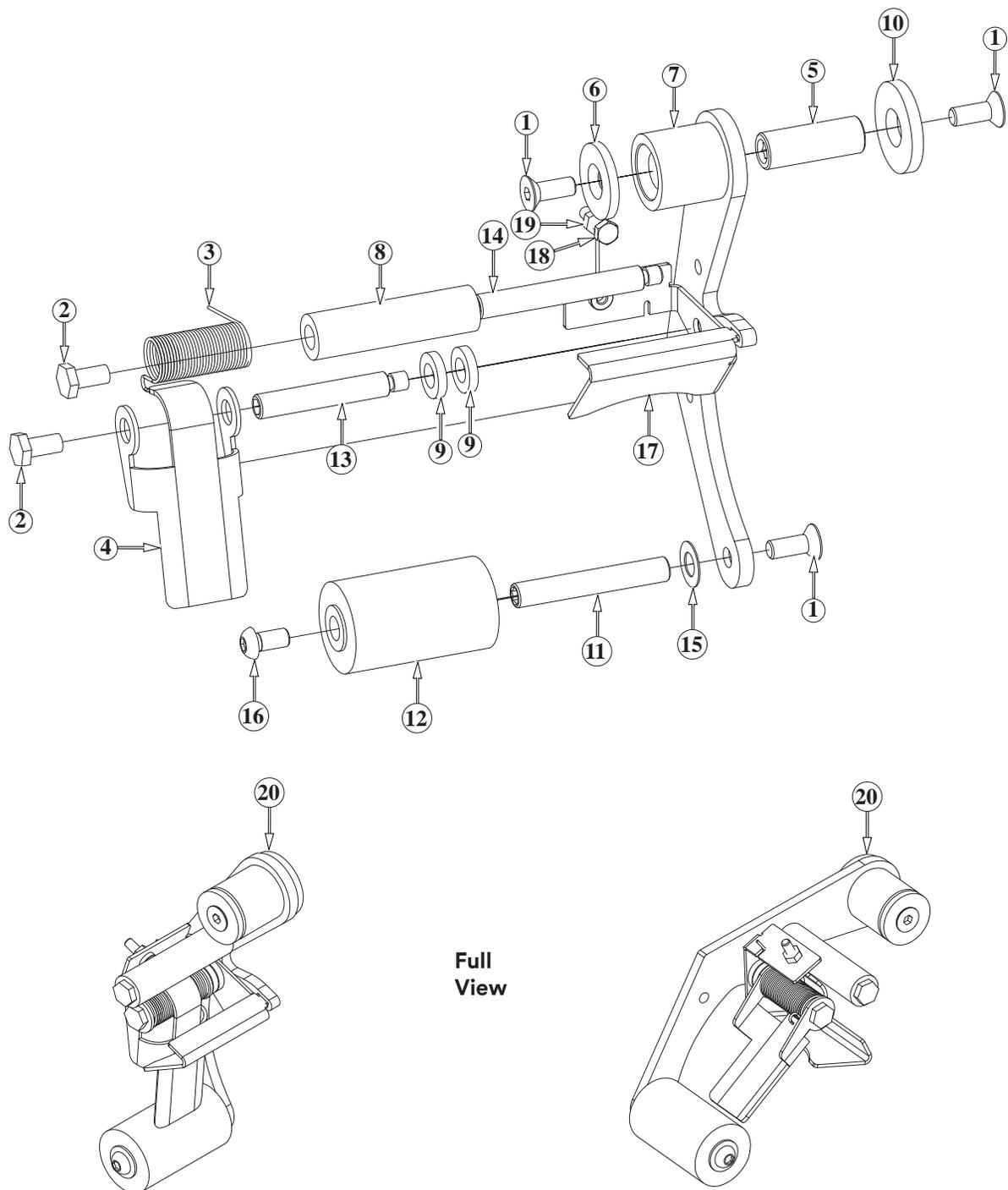
1. Refer to the Taping Head Assemblies Figure to find all the parts illustrations identified by figure numbers.
2. Refer to the figure or figures to determine the individual parts required and the parts reference number.
3. The replacement parts list, that follows each illustration, includes the part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





Full
View

Figure 15605 - Upper Taping Head / Applying Assembly

Figure 15605 - Upper Taping Head / Applying Assembly

Ref. No.	3M Part No.	Description
15605-1	26-1001-9843-6	Screw - Flat Soc Hd, M6 X 16
15605-2	26-1003-5829-5	Screw - Hex Hd, M6 X 12
15605-3	78-0025-0116-7	Spring - Torsion Blade Guard
15605-4	78-0025-0194-4	Assembly - Tape Support
15605-5	78-0025-0118-3	Shaft - Pivot
15605-6	78-0025-0119-1	Cap - Pivot
15605-7	78-0025-0120-9	Apply Arm Assembly (Upper)
15605-8	78-0025-0124-1	Roller - Wrap Swivel
15605-9	78-0025-0125-8	Spacer - Roller
15605-10	78-0025-0126-6	Washer - Thrust Plastic
15605-11	78-0025-0127-4	Shaft - Roller Apply
15605-12	78-0025-0128-2	Roller - Apply Assembly
15605-13	78-0025-0129-0	Shaft - Tape Support Pivot
15605-14	78-0025-0130-8	Shaft - Wrap Swivel
15605-15	78-0025-0164-7	Washer - Friction Plastic
15605-16	78-8076-4503-7	Screw - Butt. Soc. Hd, M6-1 X 12, Zinc Plated
15605-17	78-0025-0190-2	Fork - Formed 2" Reverse Bend - Upper
15605-18	26-1003-5707-3	Screw - M4 X 16
15605-19	78-8010-7416-8	Nut - Metric, Hex, Steel M4
15605-20	78-0025-0199-3	Apply Roller Assembly (Upper)

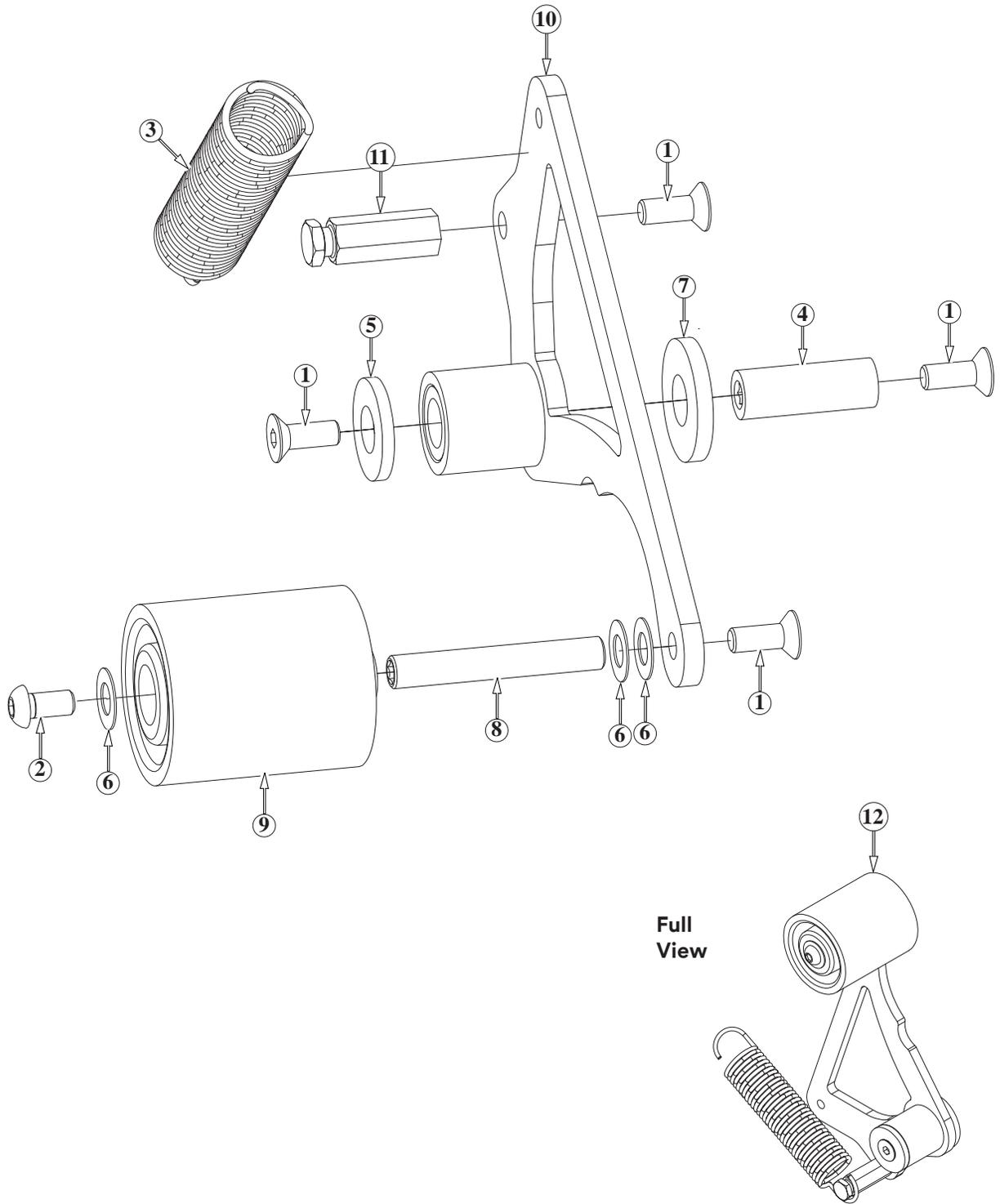


Figure 15606 - Upper Taping Head / Buffing Assembly

Figure 15606 - Upper Taping Head / Buffing Assembly

Ref. No.	3M Part No.	Description
15606-1	26-1001-9843-6	Screw - Flat Soc Hd, M6 X 16
15606-2	78-8076-4503-7	Screw - Hex Hd, M6-1.00 X 12mm Lg., Zinc Plated
15606-3	78-0025-0106-8	Spring - Upper (Black)
15606-4	78-0025-0118-3	Shaft - Pivot
15606-5	78-0025-0119-1	Cap - Pivot
15606-6	78-0025-0164-7	Washer - Friction Plastic
15606-7	78-0025-0126-6	Washer - Thrust Plastic
15606-8	78-0025-0127-4	Shaft - Roller Apply
15606-9	78-0025-0170-4	Roller - Buffing Assembly
15606-10	78-0025-0131-6	Buffing Arm Assembly (Upper)
15606-11	78-0025-0134-0	Post - Spring Buffing
15606-12	78-0025-0200-9	Buffing Roller Assembly (Upper)

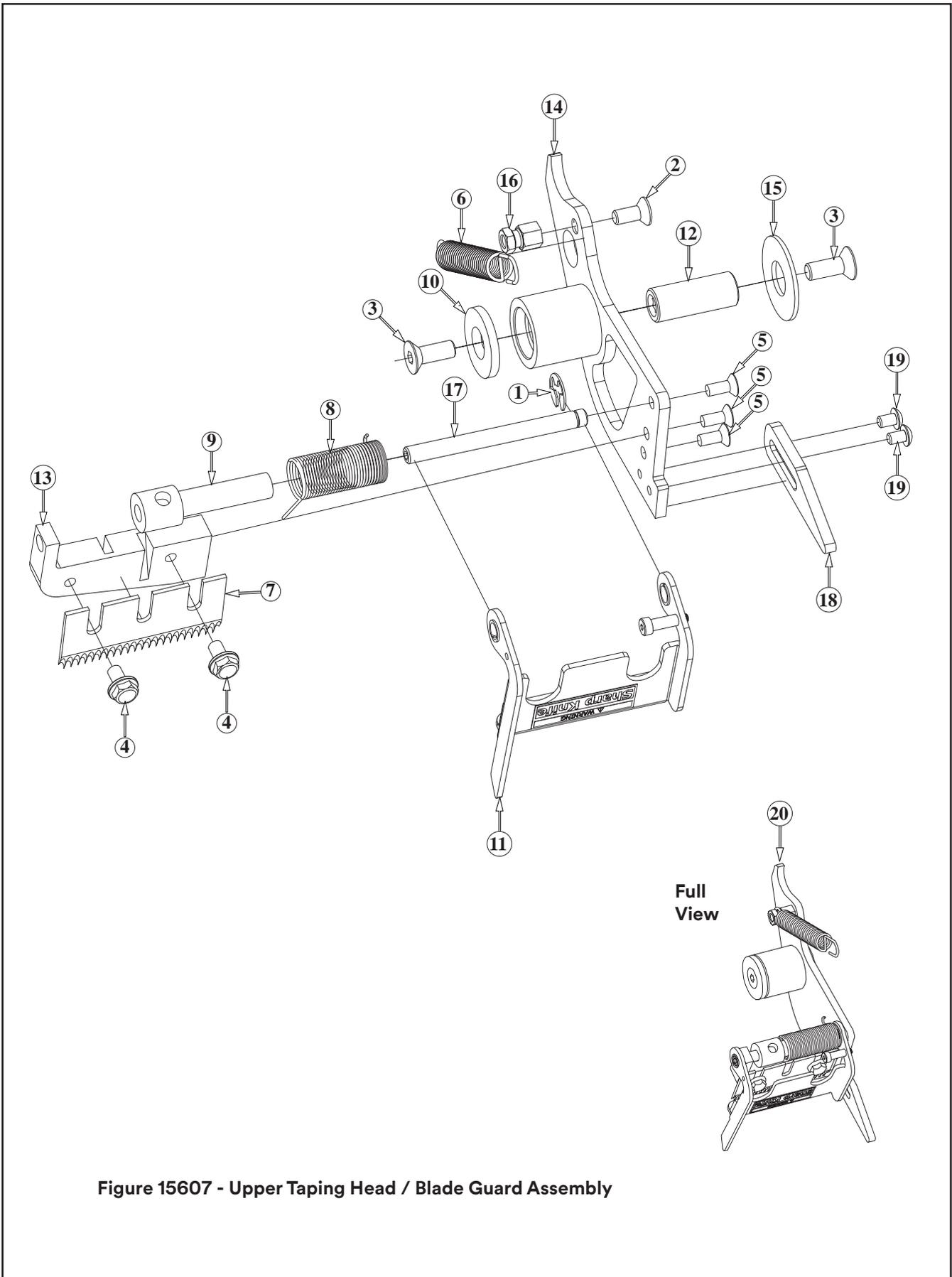
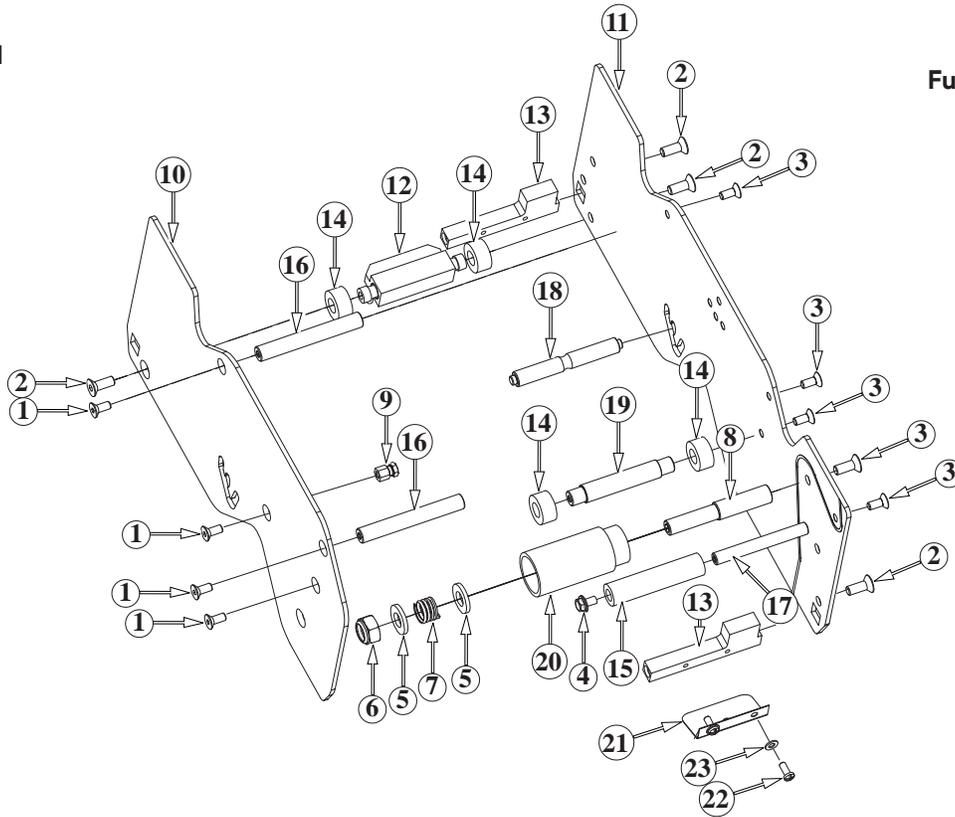


Figure 15607 - Upper Taping Head / Blade Guard Assembly

Ref. No.	3M Part No.	Description
15607-1	78-8656-4005-2	Ring - Retaining 5mm, Waldes Tru-Arc #5133-25
15607-2	26-0001-5862-1	Screw - Flat Soc Hd, M5 X 12
15607-3	26-1001-9843-6	Screw - Flat Soc Hd, M6 X 16
15607-4	26-1003-8596-7	Screw - Hex Hd M5 X 8 w/ Ext Lock Washer
15607-5	26-1005-4758-2	Screw - Flat Hd, Soc Dr, M4 X 10
15607-6	78-0025-0102-7	Spring - Cutter
15607-7	78-0025-0105-0	Blade (2")
15607-8	78-0025-0116-7	Spring - Torsion Blade Guard
15607-9	78-0025-0117-5	Bushing - 47.7mm Long
15607-10	78-0025-0119-1	Cap - Pivot
15607-11	78-0025-0135-7	Blade Guard Assembly (Upper)
15607-12	78-0025-0137-3	Shaft - Pivot Cutoff
15607-13	78-0025-0138-1	Block - Knife Mount
15607-14	78-0025-0139-9	Cutoff Arm Assembly (Upper)
15607-15	78-0025-0143-1	Bearing - Thrust
15607-16	78-0025-0144-9	Post - Cutoff Spring
15607-17	78-0025-0145-6	Shaft - Guard Pivot
15607-18	78-0025-0169-6	Extension - Cutoff
15607-19	78-8137-7093-6	Screw Butt Soc.Hd M4 x .07 X 6mm, Zinc Plated
15607-20	78-0025-0201-7	Cut-Off Assembly (Upper)

Version 1

Full Assembly



Version 2

Full Assembly
"Little David"

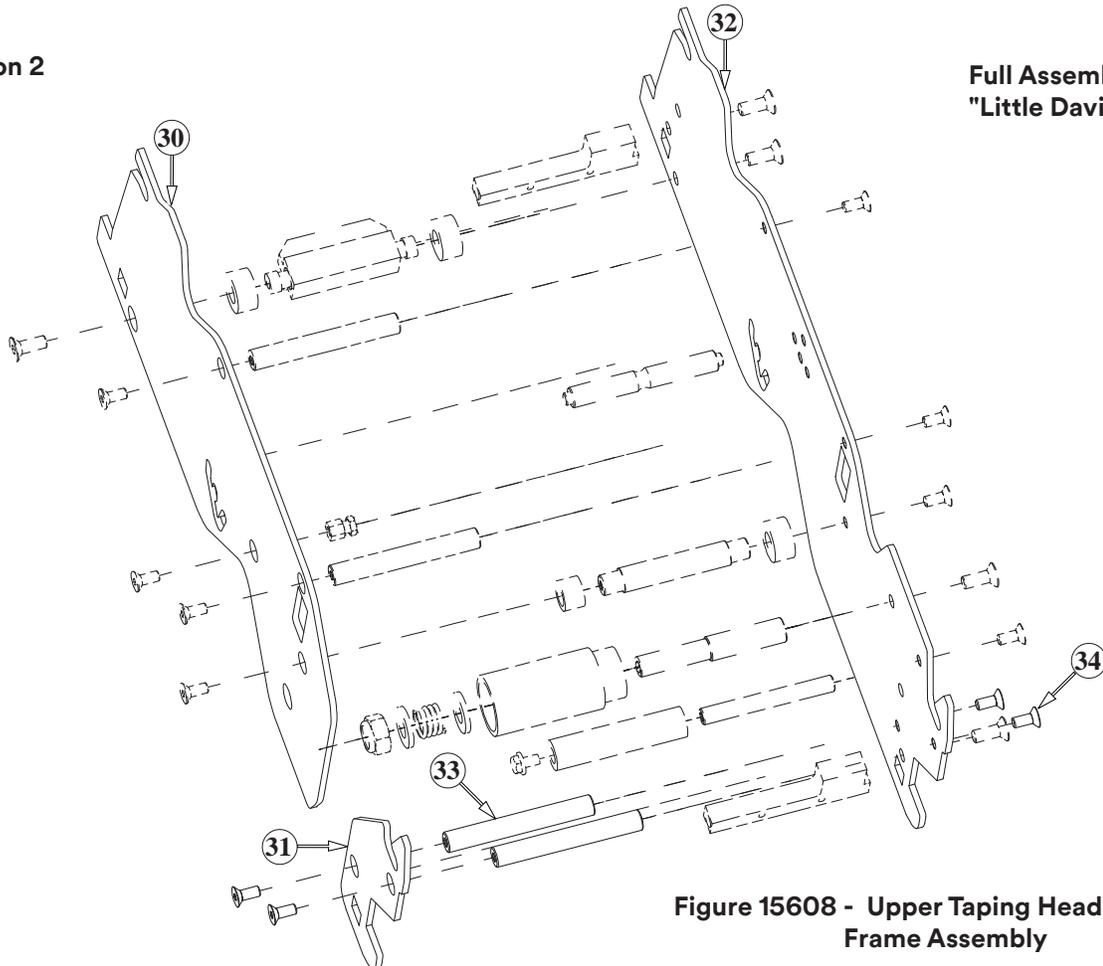


Figure 15608 - Upper Taping Head /
Frame Assembly

Figure 15608 - Upper Taping Head / Frame Assembly

Ref. No.	3M Part No.	Description
Version 1 and Version 2:		
15608-1	26-0001-5862-1	Screw - Flat Soc Hd, M5 X 12
15608-2	26-1001-9843-6	Screw - Flat Soc Hd, M6 X 16
15608-3	26-1002-3866-1	Screw - Flat Hd, Hex Dr, M5 X 10
15608-4	26-1003-8596-7	Screw - Hex Hd M5 X 8 w/ Ext Th Lock Washer
15608-5	26-1004-5510-9	Washer - Plain, M10 X 20 X 2.5
15608-6	78-8017-9077-1	Nut - Self Locking, M10 X 1
15608-7	78-0025-0101-9	Spring - Compression
15608-8	78-0025-0109-2	Shaft - Tension Roller 1 1/2" Th
15608-9	78-0025-0144-9	Post - Cutoff Spring
15608-10	78-0025-0146-4	Frame - Front (Upper)
15608-11	78-0025-0147-2	Frame - Tape Mount (Upper w/ Path)
15608-12	78-0025-0148-0	Brush Assembly
15608-13	78-0025-0152-2	Spacer - Mounting Block
15608-14	78-0025-0153-0	Bumper - Stop 10 X 20 X 10L
15608-15	78-0025-0154-8	Roller - Wrap
15608-16	78-0025-0156-3	Shaft - Spacer
15608-17	78-0025-0157-1	Shaft - Roller Wrap
15608-18	78-0025-0158-9	Shaft - Spring Adjust
15608-19	78-0025-0159-7	Shaft - Bumper
15608-20	78-0025-0149-8	Roller - Tension 2 inch CCW
15608-21	78-0025-0192-8	Plate - Front Flap Guide
15608-22	78-8017-9257-9	Screw - Phillips Hd, M4 X 14
15608-23	78-8005-5740-3	Washer - Plain 4mm
Version 2 Only (see illustration):		
15608-30	78-0025-0163-9	Frame - Front Exit (Upper)
15608-31	78-0025-0162-1	Frame - Front Entry (Upper)
15608-32	78-0025-0161-3	Frame - Tape Mount (Upper)
15608-33	78-0025-0156-3	Shaft - Spacer
15608-34	26-1002-3866-1	Screw - Flat Hd., Hex Dr, M5 X 10

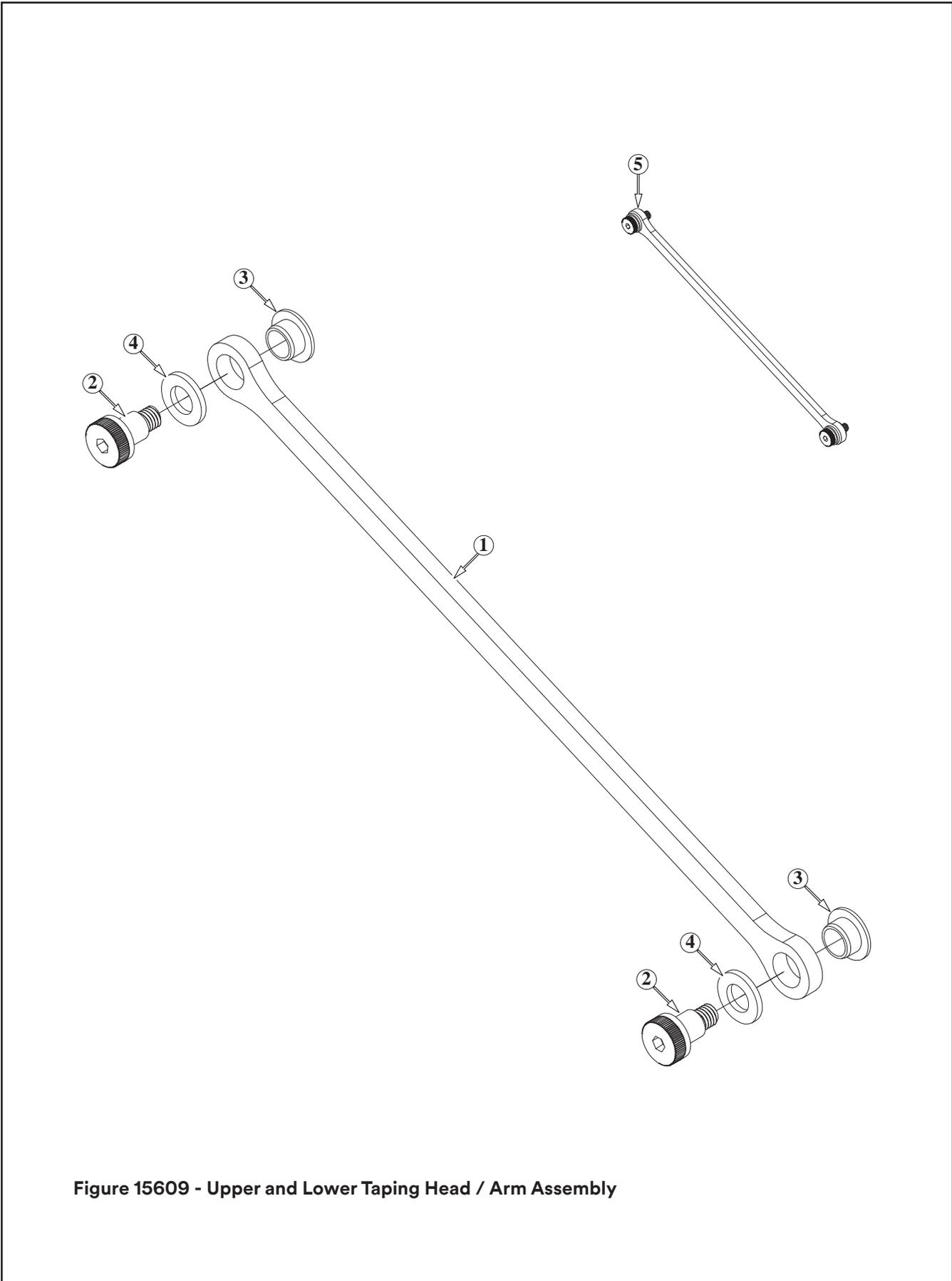


Figure 15609 - Upper and Lower Taping Head / Arm Assembly

Figure 15609 - Upper and Lower Taping Head / Arm Assembly

Ref. No.	3M Part No.	Description
15609-1	78-0025-0160-5	Arm - Link
15609-2	78-8137-7054-8	Bolt - Shoulder M6 - 8 Dia X 10L
15609-3	78-0025-0197-7	Bearing - Flanged Acetal 8 X 10 X 5L
15609-4	78-0025-0198-5	Bearing - Thrust
15609-5	78-0025-0203-3	Arm Assembly

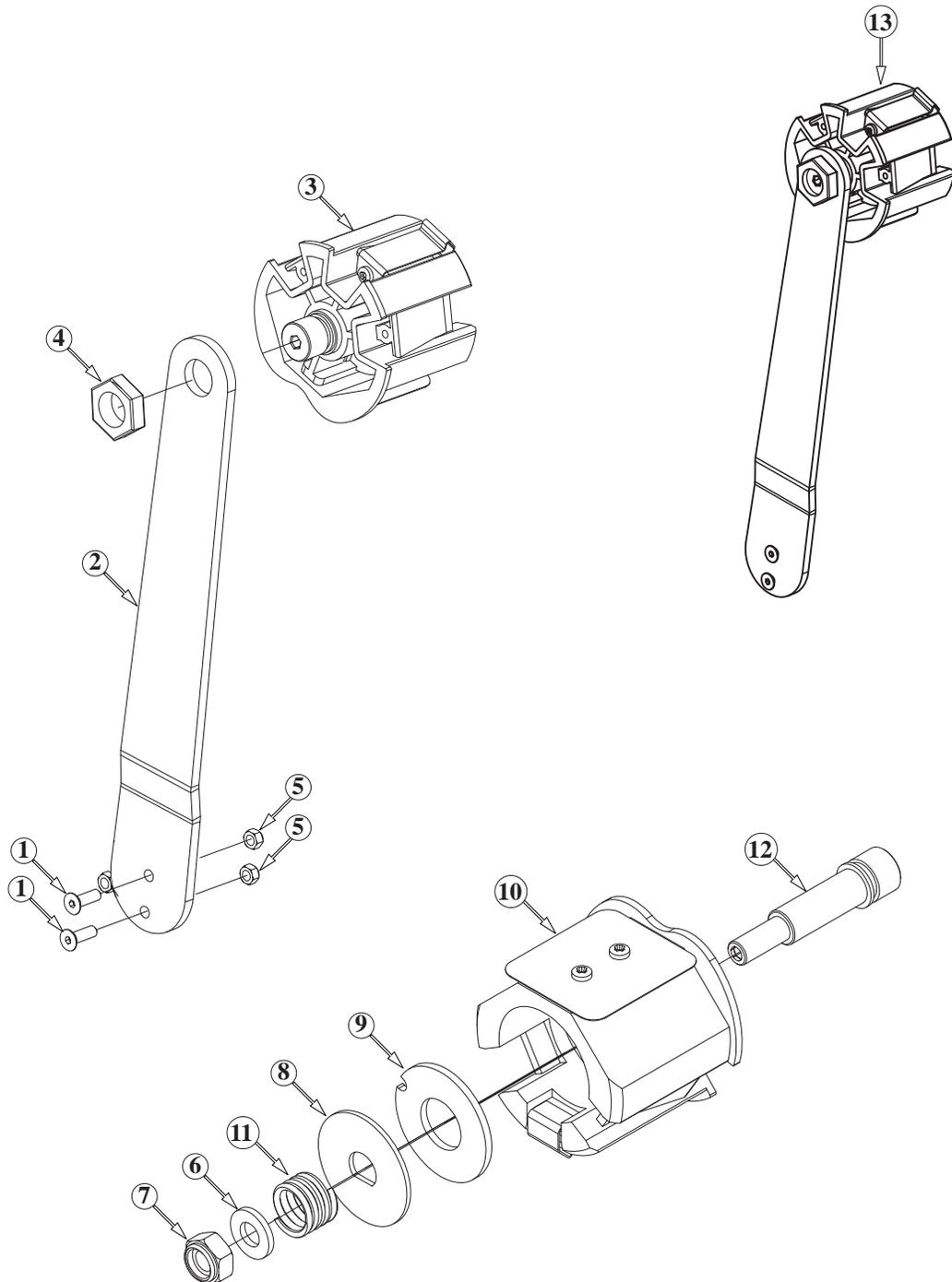
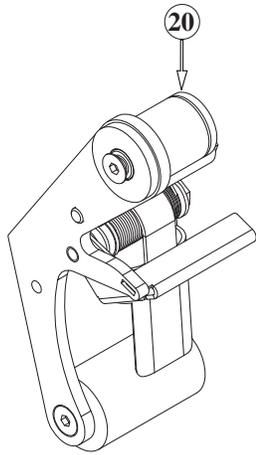


Figure 15610 - Upper and Lower Taping Head / Taping Head Assembly

Figure 15610 - Upper and Lower Taping Head / Taping Head Assembly

Ref. No.	3M Part No.	Description
15610-1	26-1005-5316-8	Screw - Flat Hd Hex Dr, M5 X 16
15610-2	78-0025-0193-6	Arm - Tape Drum
15610-3	78-0025-0216-5	Tape Drum Assembly - 2 Inch
15610-4	78-8017-9169-6	Nut - M18 X 1
15610-5	26-1005-6859-6	Nut - Self Locking, M5
15610-6	26-1004-5510-9	Washer - Plain, M10 X 20 X 2.5
15610-7	78-0025-0172-0	Nut - Self Locking, M10 X 1
15610-8	78-0025-0100-1	Washer - Tape Drum
15610-9	78-0025-0103-5	Washer - Friction
15610-10	78-0025-0213-2	Tape Drum Sub-Assembly - 2 Inch
15610-11	78-0025-0114-2	Spring - Core Holder
15610-12	78-0025-0123-3	Shaft - Drum
15610-13	78-0025-0217-3	Tape Roll Mount Assembly



Full View

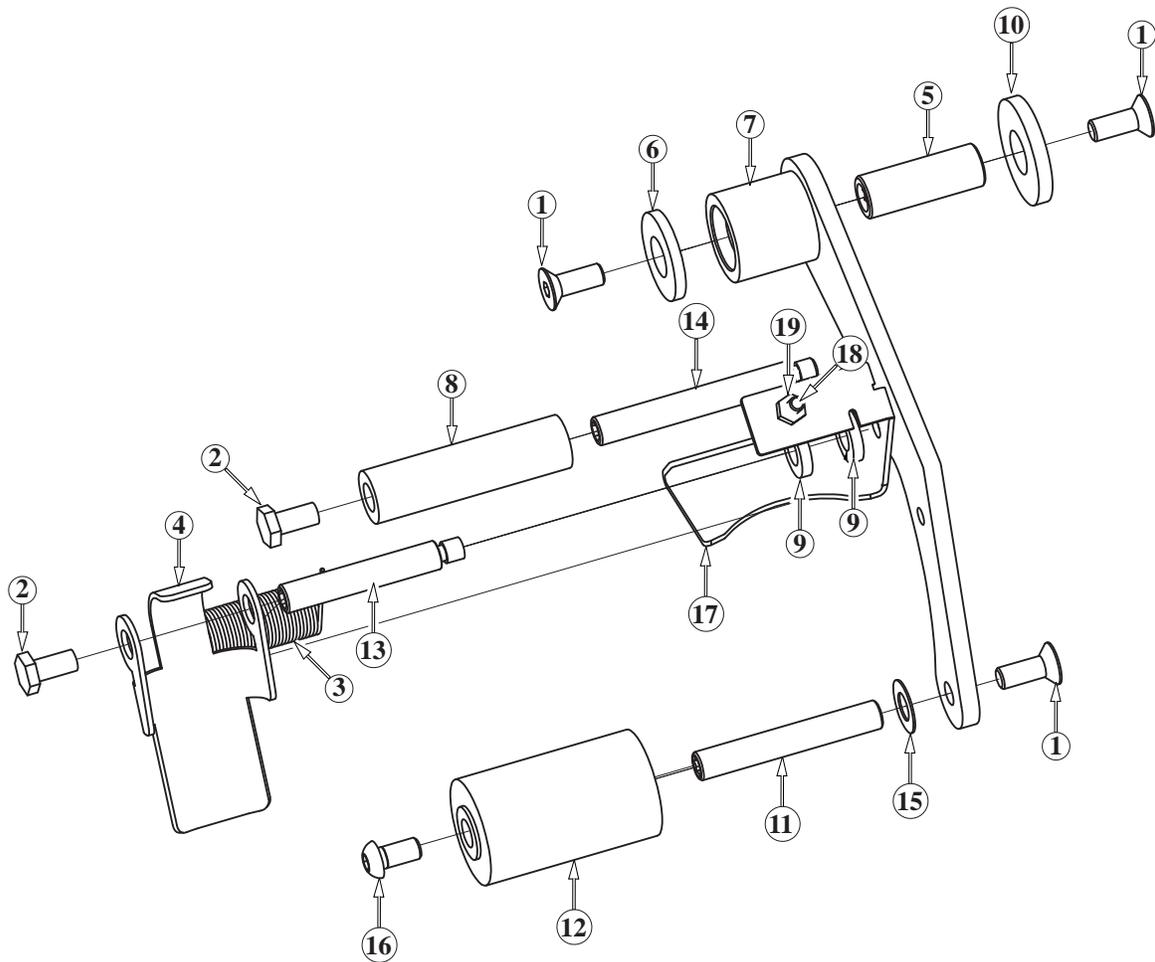
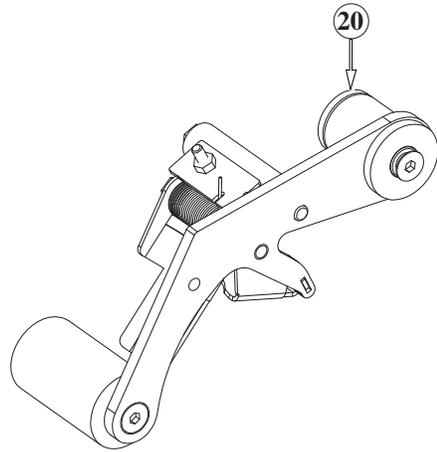


Figure 15709 - Lower Taping Head / Applying Arm Assembly

Figure 15709 - Lower Taping Head / Applying Arm Assembly

Ref. No.	3M Part No.	Description
15709-1	26-1001-9843-6	Screw - Flat Soc Hd, M6 X 16
15709-2	26-1003-5829-5	Screw - Hex Hd, M6 X 12
15709-3	78-0025-0196-9	Spring - Torsion Blade Guard
15709-4	78-0025-0194-4	Assembly - Tape Support
15709-5	78-0025-0118-3	Shaft - Pivot
15709-6	78-0025-0119-1	Cap - Pivot
15709-7	78-0025-0176-1	Apply Arm Assembly - (Lower)
15709-8	78-0025-0124-1	Roller - Wrap Swivel
15709-9	78-0025-0125-8	Spacer - Roller
15709-10	78-0025-0126-6	Washer - Thrust Plastic
15709-11	78-0025-0127-4	Shaft - Roller Apply
15709-12	78-0025-0128-2	Roller - Apply Assembly
15709-13	78-0025-0129-0	Shaft - Tape Support Pivot
15709-14	78-0025-0130-8	Shaft - Wrap Swivel
15709-15	78-0025-0164-7	Washer - Friction Plastic
15709-16	78-8076-4503-7	Screw - Butt. Soc. Hd, M6-1 X 12, Zinc Plated
15709-17	78-0025-0191-0	Fork - Formed 2" Reverse Bend (Lower)
15709-18	26-1003-5707-3	Screw - M4 X 16
15709-19	78-8010-7416-8	Nut - Metric, Hex, Steel M4
15709-20	78-0025-0205-8	Apply Roller Assembly

Figure 15706 - Lower Taping Head / Buffing Arm Assembly

Ref. No.	3M Part No.	Description
15706-1	26-1001-9843-6	Screw - Flat Soc Hd, M6 X 16
15706-2	78-8076-4503-7	Screw - Hex Hd, M6-1.00 X 12mm Lg., Zinc Plated
15706-3	78-0025-0211-6	Spring - Lower (Black)
15706-4	78-0025-0118-3	Shaft - Pivot
15706-5	78-0025-0119-1	Cap - Pivot
15706-6	78-0025-0164-7	Washer - Friction Plastic
15706-7	78-0025-0126-6	Washer - Thrust Plastic
15706-8	78-0025-0127-4	Shaft - Roller Apply
15706-9	78-0025-0170-4	Roller - Buffing Assembly
15706-10	78-0025-0179-5	Buffing Arm Assembly (Lower)
15706-11	78-0025-0134-0	Post - Spring Buffing
15706-12	78-0025-0206-6	Buffing Roller Assembly

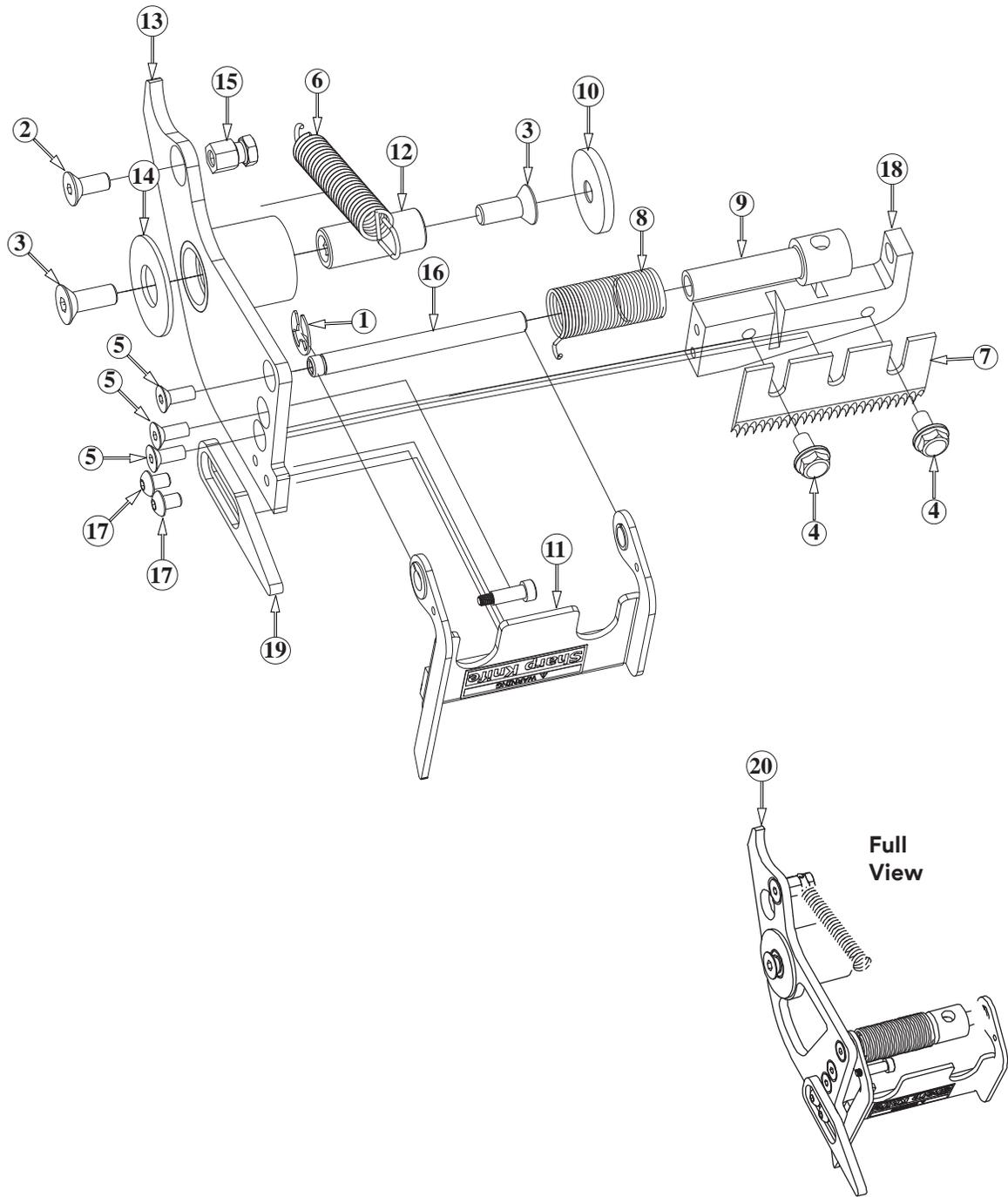


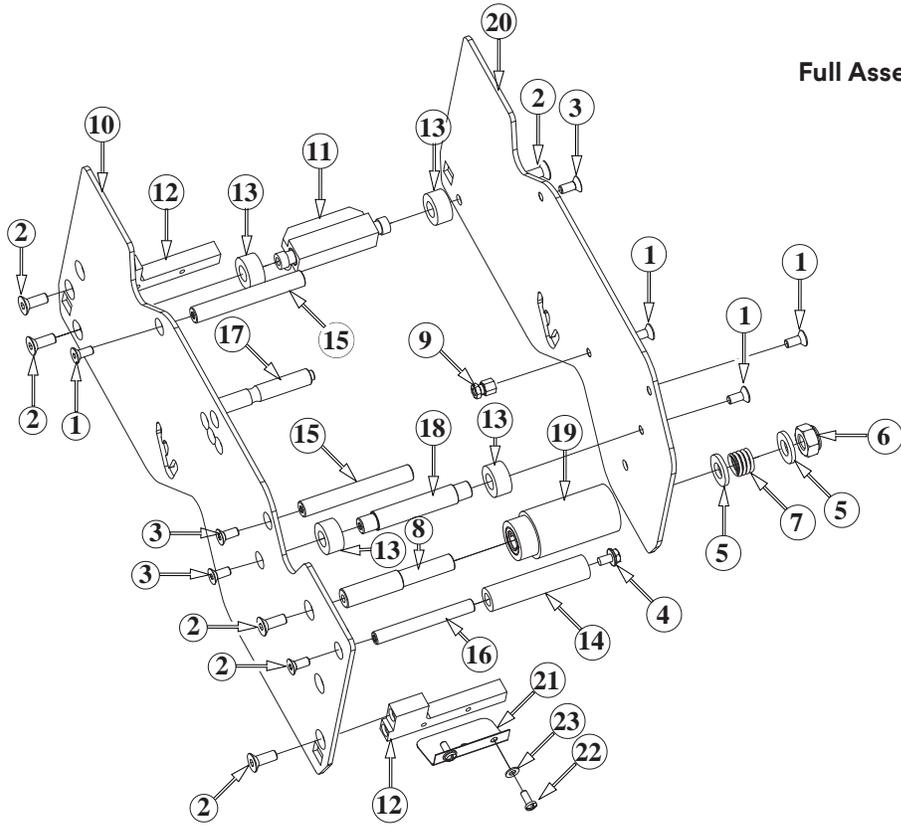
Figure 15707 - Lower Taping Head / Blade Guard Assembly

Figure 15707 - Lower Taping Head / Blade Guard Assembly

Ref. No.	3M Part No.	Description
15707-1	78-8656-4005-2	Ring - Retaining 5mm, Waldes Tru-Arc #5133-25
15707-2	26-0001-5862-1	Screw - Flat Soc Hd, M5 X 12
15707-3	26-1001-9843-6	Screw - Flat Soc Hd, M6 X 16
15707-4	26-1003-8596-7	Screw - Hex Hd M5 X 8 w/ Ext Lock Washer
15707-5	26-1005-4758-2	Screw - Flat Hd, Soc Dr, M4 X 10
15707-6	78-0025-0102-7	Spring - Cutter
15707-7	78-0025-0105-0	Blade (2")
15707-8	78-0025-0196-9	Spring - Torsion Blade Guard
15707-9	78-0025-0117-5	Bushing - 47.7mm Long
15707-10	78-0025-0119-1	Cap - Pivot
15707-11	78-0025-0180-3	Blade Guard Assembly (Lower)
15707-12	78-0025-0137-3	Shaft - Pivot Cutoff
15707-13	78-0025-0183-7	Cutoff Arm Assembly (Lower)
15707-14	78-0025-0143-1	Bearing - Thrust
15707-15	78-0025-0144-9	Post - Cutoff Spring
15707-16	78-0025-0145-6	Shaft - Guard Pivot
15707-17	78-8137-7093-6	Screw Butt Soc. Hd, M4 X .07 X 6mm lg., Zinc Plated
15707-18	78-0025-0181-1	Block - Knife Mount (Lower)
15707-19	78-0025-0184-5	Extension - Cutoff (Lower)
15707-20	78-0025-0207-4	Cut Off Guard Assembly (Lower)

Version 1

Full Assembly



Version 2

Full Assembly "Little David"

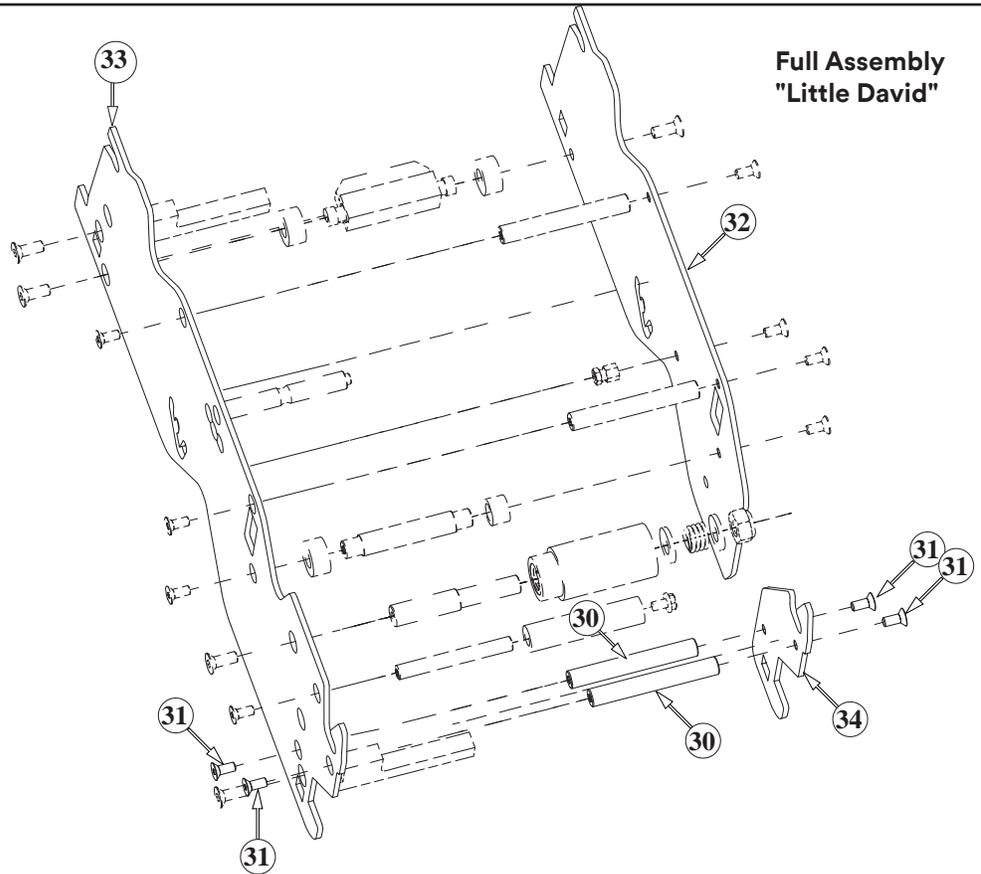


Figure 15708 - Lower Taping Head / Frame Assembly

Figure 15708 - Lower Taping Head / Frame Assembly

Ref. No.	3M Part No.	Description
Version 1 and Version 2:		
15708-1	26-1001-5862-1	Screw - Flat Soc Hd, M5 X 12
15708-2	26-1001-9843-6	Screw - Flat Soc Hd, M6 X 16
15708-3	26-1002-3866-1	Screw - Flat Hd, Hex Dr, M5 X 10
15708-4	26-1003-8596-7	Screw - Hex Hd M5 X 8 w/ Ext Th Lock Washer
15708-5	26-1004-5510-9	Washer - Plain, M10 X 20 X 2.5
15708-6	78-8017-9077-1	Nut - Self Locking, M10 X 1
15708-7	78-0025-0101-9	Spring - Compression
15708-8	78-0025-0109-2	Shaft - Tension Roller 1 1/2" Th
15708-9	78-0025-0144-9	Post - Cutoff Spring
15708-10	78-0025-0185-2	Frame - Tape Mount (Lower w/path)
15708-11	78-0025-0148-0	Brush Assembly
15708-12	78-0025-0152-2	Spacer - Mounting Block
15708-13	78-0025-0153-0	Bumper - Stop 10 X 20 X 10L
15708-14	78-0025-0154-8	Roller - Wrap
15708-15	78-0025-0156-3	Shaft - Spacer
15708-16	78-0025-0157-1	Shaft - Roller Wrap
15708-17	78-0025-0158-9	Shaft - Spring Adjust
15708-18	78-0025-0159-7	Shaft - Bumper
15708-19	78-0025-0186-0	Roller - Tension 2 inch
15708-20	78-0025-0202-5	Frame - Front (Lower)
15708-21	78-0025-0192-8	Plate - Front Flap Guide
15708-22	78-8017-9257-9	Screw - Phillips Hd, M4 X 14
15708-23	78-8005-5740-3	Washer - Plain 4mm
Version 2 Only (see illustration):		
15708-30	78-0025-0156-3	Shaft - Spacer
15708-31	26-1002-3866-1	Screw - Flat Hd., Soc, M5 X 10
15708-32	78-0025-0189-4	Frame - Front Exit (Lower)
15708-33	78-0025-0187-8	Frame - Tape Mount (Lower)
15708-34	78-0025-0188-6	Frame - Front Entry (Lower)

