

Instructions and Parts List

3M-Matic™

S-847

“L” Clip Applicator

Model 28400

Important
It is recommended you immediately order the spare parts listed on page 15. These parts are expected to wear through normal use, and should be kept on hand to minimize production delays.

3M Packaging Systems Division

Building 220-8W-01, 3M Center
St. Paul, Minnesota 55144-1000



Service Instructions

To Our Customers:

This is the "AccuGlide"/"3M-Matic"/"Scotch" brand Equipment you ordered. It has been set up and tested in the factory with "Scotch" brand tapes. If any problems occur when operating this equipment, and you desire a service call, or phone consultation, call the 3M National Service Center on 1-800/328 1390 (Twin Cities Metro Area call 731 6507). Please provide the customer support coordinator with the machine catalog number and serial number.

Replacement Parts

Order parts by **part number**, **part name**, **quantity required**, **machine name**, **number** and **model number**.

Replacement parts and parts prices available from:

Dispenser Parts
Route 4, Box 5B
Amery, WI 54001
715/268 8126

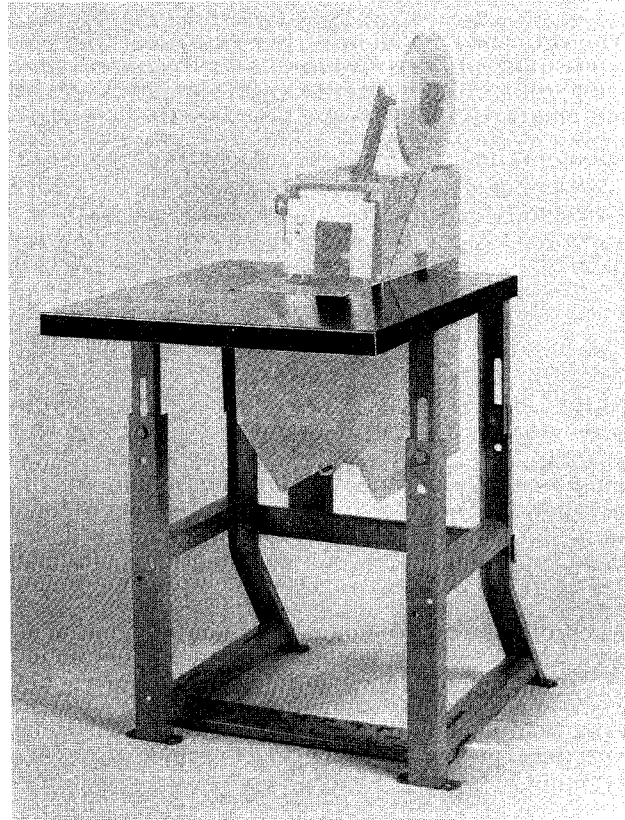
Typical Mounting Set-Up

3M-Matic™ S-847 “L” Clip Applicator

Models 18300 and 28400

Standard “3M-Matic” Mounting Equipment

The P/N 78-8052-6267-8 Single Head Stand provides a self-contained system for supporting the S-847 “L” Clip Applicator in the bottom taping position for automatically applying “L” clips of “Scotch” Brand Filament Tape to box corners. The single head stand allows vertical adjustability of the top work surface and can be adapted to most conveyor or off line systems.



P/N 78-8052-6267-8 Single Head Stand
Model 18400 (Shown with S-847 Model 18300)

Suggested Customer Mounting Set-Ups

- The S-847 is designed for use with most conveyor or off-line systems.
- The following illustrations show several typical mounting set-ups of the S-847 in bottom taping or top taping positions.
- Refer to the S-847 instruction and parts list manual for installation and set-up information

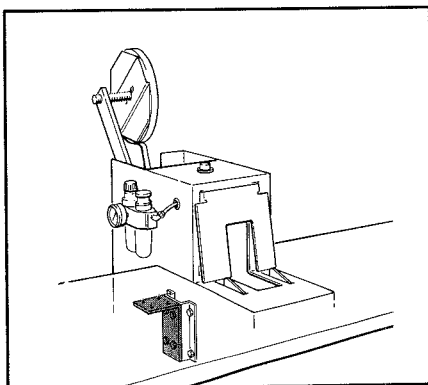


Figure 1 — S-847 (Bottom Taping)
mounting direct to work surface.

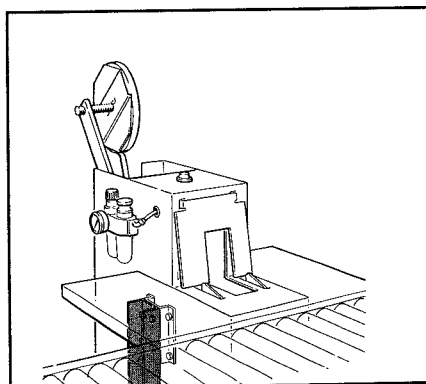


Figure 2 — S-847 (Bottom Taping)
attached to conveyor.

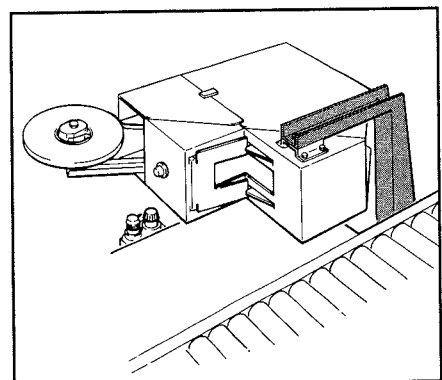


Figure 3 — S-847 (Side Taping)
mounted adjacent to conveyor.

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Multiple S-847 Installations

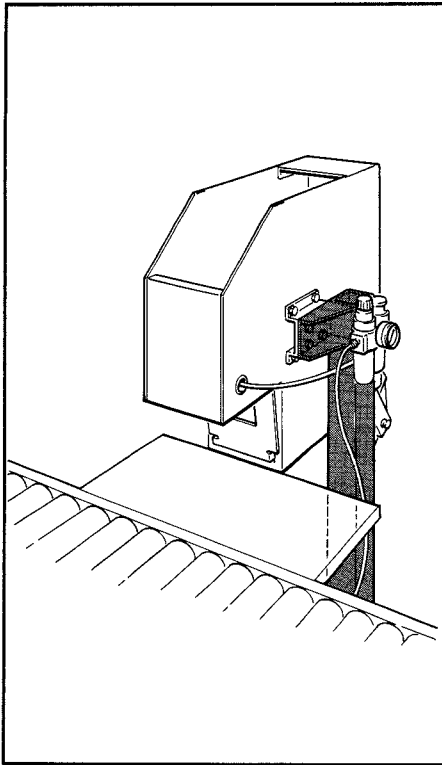


Figure 4 — S-847 (Top Taping) mounted adjacent to work surface.

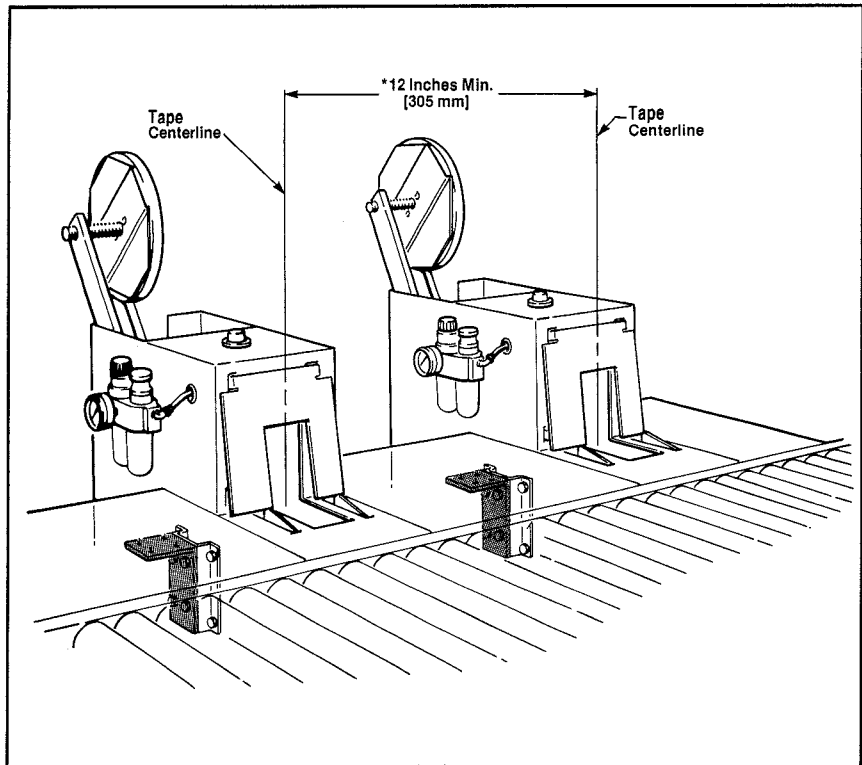


Figure 5 — Two S-847 Applicators (Bottom Taping) mounted adjacent to work surface.

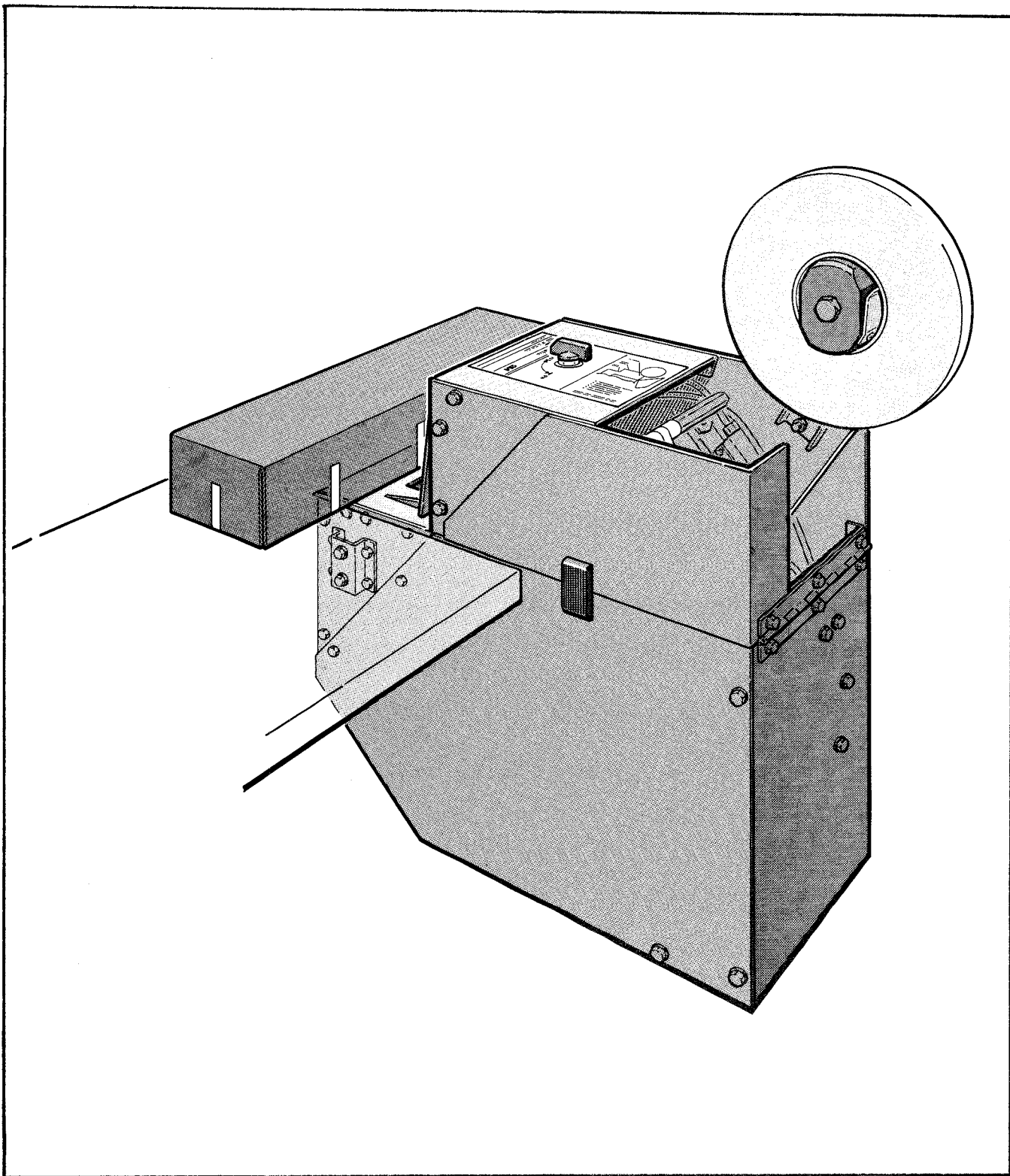
**The 12-inch [305 mm] dimension is the minimum distance between applied tape "L" clips when using two standard S-847 Applicators. For applications requiring less than 12-inch [305 mm] spacing, contact your 3M Representative.*

Applications, where more than one S-847 will be used, require special attention to alignment of machines so boxes enter all machines squarely. For customer installations of more than two S-847's, engineering assistance is recommended through your 3M Representative.

Important Notice to Purchaser: The following is made in lieu of all warranties, expressed or implied, including the implied warranties of merchantability and fitness for purpose: Seller and manufacturer warrant that the "3M Matic" equipment is free from defects in material and workmanship on the date the machine is shipped by the seller and for the time periods stated below. Seller's and manufacturer's only obligation hereunder shall be to repair or replace, at its option, any mechanical part proved to be defective, provided the defect occurs within ninety (90) days after the date of delivery and the said part is returned immediately to the 3M factory or to an authorized service station designated by the manufacturer. **Neither seller nor manufacturer shall be liable either in tort or in contract for any loss or damage, direct, incidental, or consequential, arising out of the use of or the inability to use the "3M-Matic" equipment.** No statement or recommendation not contained herein shall have any force or effect unless in an agreement signed by officers of seller and manufacturer.

Instruction Manual
S-847 "L" Clip Applicator
Model 28400

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"3M-Matic" S-847 "L" Clip Applicator, Model 28400

Description - The **3M-Matic** S-847 "L" Clip Applicator is a semi-automatic taping head for applying "**Scotch**" Brand Filament Tape in an "L" shaped clip to most box corners. Designed for installation adjacent to a conveyor system or on a stand for off-line systems, the S-847 allows an operator to quickly apply the "L" clip box closure. When a box is inserted into the nest, depressing the product paddle lever, to actuate the air operated mechanism which applies the "L" clip tape closure to secure the flaps on the box.

Receiving And Handling

Examine the "L" Clip Applicator for damage that might have occurred during transit. **If damage is evident, file a damage claim immediately** with the transportation company and also your 3M Representative.

Warranty

IMPORTANT NOTICE TO PURCHASER: The following is made in lieu of all warranties, expressed or implied, including the implied warranties of merchantability and fitness for purpose: Seller and manufacturer warrant that the **"3M-Matic"** equipment is free from defects in material and workmanship on the date the machine is shipped by the seller and for the time periods stated below. Seller's and manufacturer's only obligation hereunder shall be to repair or replace, at its option, any mechanical part proved to be defective, provided the defect occurs within ninety (90) days after the date of delivery and the said part is returned immediately to the 3M factory or to an authorized service station designated by the manufacturer. **Neither seller nor manufacturer shall be liable either in tort or in contract for any loss or damage, direct, incidental, or consequential, arising out of the use of or the inability to use the "3M-Matic" equipment.** No statement or recommendation not contained herein shall have any force or effect unless in an agreement signed by officers of seller and manufacturer.

"Scotch" and **"3M-Matic"** are trademarks for the pressure-sensitive tapes and dispensers of 3M, St. Paul, Minnesota 55144-1000.

Specifications

Tape Specifications:

Tape: Most **"Scotch"** brand filament tapes.

2. **Tape Width:** 3/8 or 9 mm, 1/2 or 12 mm, and 5/8 or 15 mm inch.
3. **Tape Roll Diameter:** Up to 15 inches [380 mm] maximum on a 3 inch [76.2 mm] diameter core.
4. **Applied Tape Length:** 4 1/2 inches [115 mm] (nominal). Tape legs are 2 1/4 \pm 1/8 inches [55 mm \pm 3.2 mm].

Specifications (Continued)

Box Size Capacity:

1. Bottom Taping Position:

- a) Height: 2-1/4 inches [60 mm] minimum to unlimited maximum
- b) Width: 5 inches [130 mm] minimum to unlimited maximum
- c) Depth: 2-1/4 inches [60 mm] minimum to unlimited maximum

2. Top Taping Position:

- a) Height: 2-1/4 inches [60 mm] minimum to unlimited maximum
- b) Width: 5 inches [130 mm] minimum to unlimited maximum
- c) Depth: 2-1/4 inches [60 mm] minimum to unlimited maximum

3. **Note:** Operator capability will determine maximum height, width, and depth. Smaller heights and widths are sometimes possible and it is recommended that your 3M Representative be contacted for testing of these applications.

Cycle Time:

1.2 seconds per cycle

The cycle time is sufficient to satisfy the majority of applications. Flow controls (see page 13 - "Air Flow Controls") control the application rate and return stroke rate of the air cylinder. While these flow controls can be adjusted for increased speed, this practice may result in higher maintenance costs and shorten machine life.

Air Power Requirements:

55 to 60 PSIG [480 kPa - 515 kPa gauge pressure], 2.16 SCFM [3.65 m³/h 21°C, 101 kPa] at 50 cycles/min.

Operating Conditions:

Use in dry, relatively clean environments at 40° to 120°F [5° to 49°C] with clean, dry boxes.

IMPORTANT SAFEGUARD

Machine **should not be washed down** or **subjected to conditions causing moisture condensation** on components.

Machine Dimensions:

- 1. Length: 30 inches [760 mm] (includes 360 yard [330 m] tape roll)
- 2. Height: 34 inches [865 mm] (includes 360 yard [330 m] tape roll)
- 3. Width: 11 inches [280 mm]
- 4. Weight:
 - Packaged 75 lb. [35.3 kg]
 - Unpackaged 63 lb. [28.5 kg]

Installation And Set-Up

Read the installation instructions through completely before performing the set-up procedure.
Refer to the front of this manual for literature on "**Typical Mounting Set-up**" for the S-847 Applicator.

Mounting - The S-847 can be set up in either of three taping positions:

Bottom Taping Position - Shown in Figure 1.

For application of "L" Clip tape seal to the bottom corner of a box.

Top Taping Position - Shown in Figure 2.

For application of a tape seal to the top corner of a box.

Side Taping Position - Shown in Figure 3.

For application of a tape seal to the end of a box.

- A. Mounting brackets have been provided in two of three different mounting areas on the machine. It is suggested that the S-847 be **mounted securely by any of two** of these mounting locations.

Note: When mounting the unit, always align the top surface of the **nest parallel** with the work surface. When mounting the unit for side taping align the **nest perpendicular** to the work surface.

- B. It is suggested that a secondary height adjustment be provided for head adjustments as referred to in the top taping operation section.

- C. The air flow control unit **must be remounted** in a **vertical position** when operating the S-847 in the **top** or **side** taping position. All additional brackets, fittings and air lines are to be supplied by the customer.

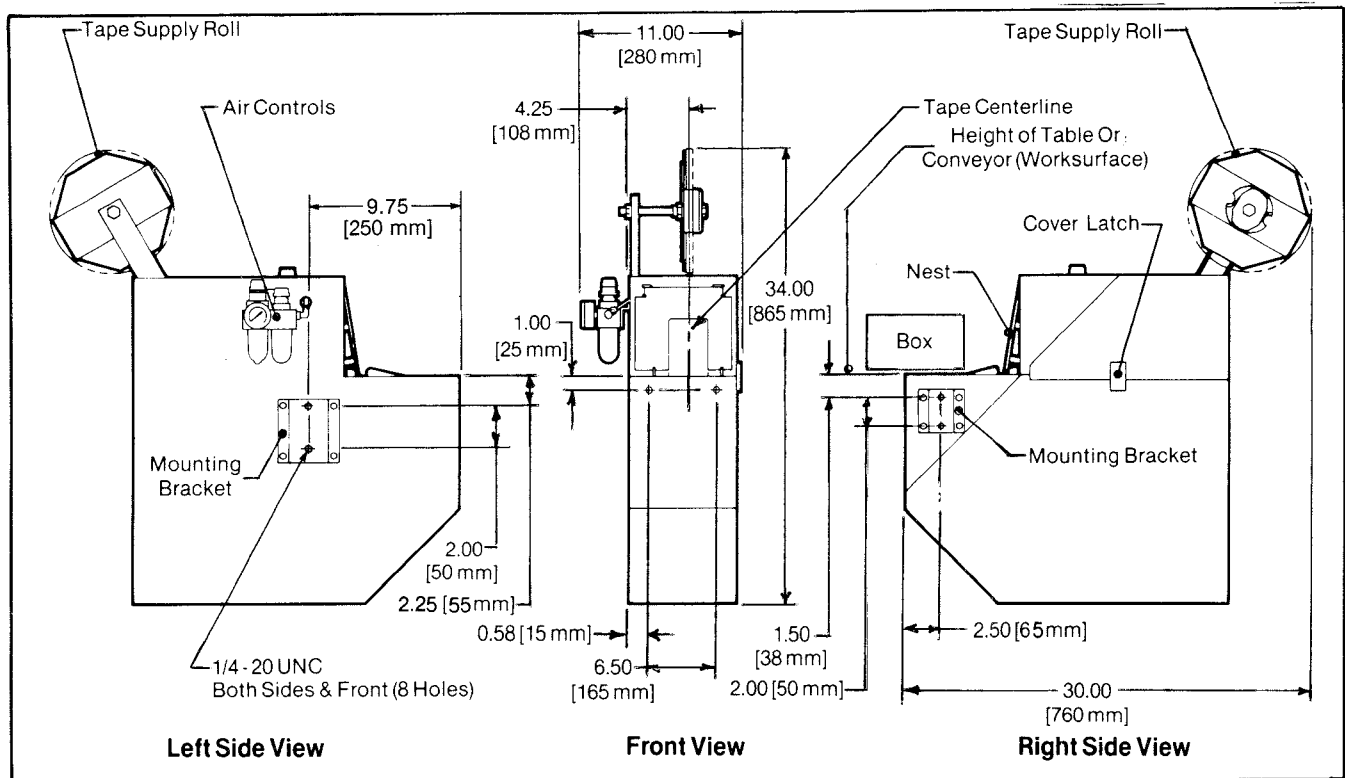


Figure 1 - Mounting - Bottom Taping Position

Installation And Set-Up (Continued)

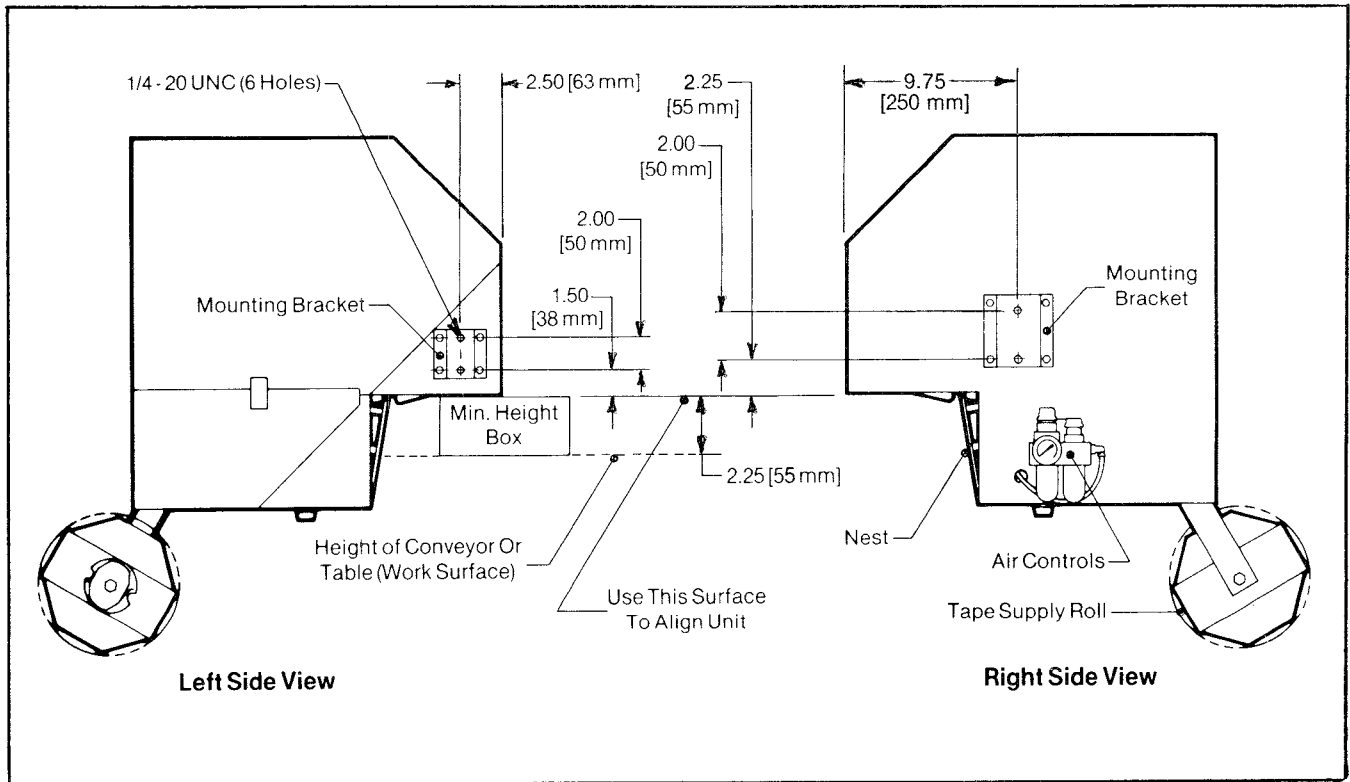


Figure 2 - Mounting Top Taping Position - Left Side View

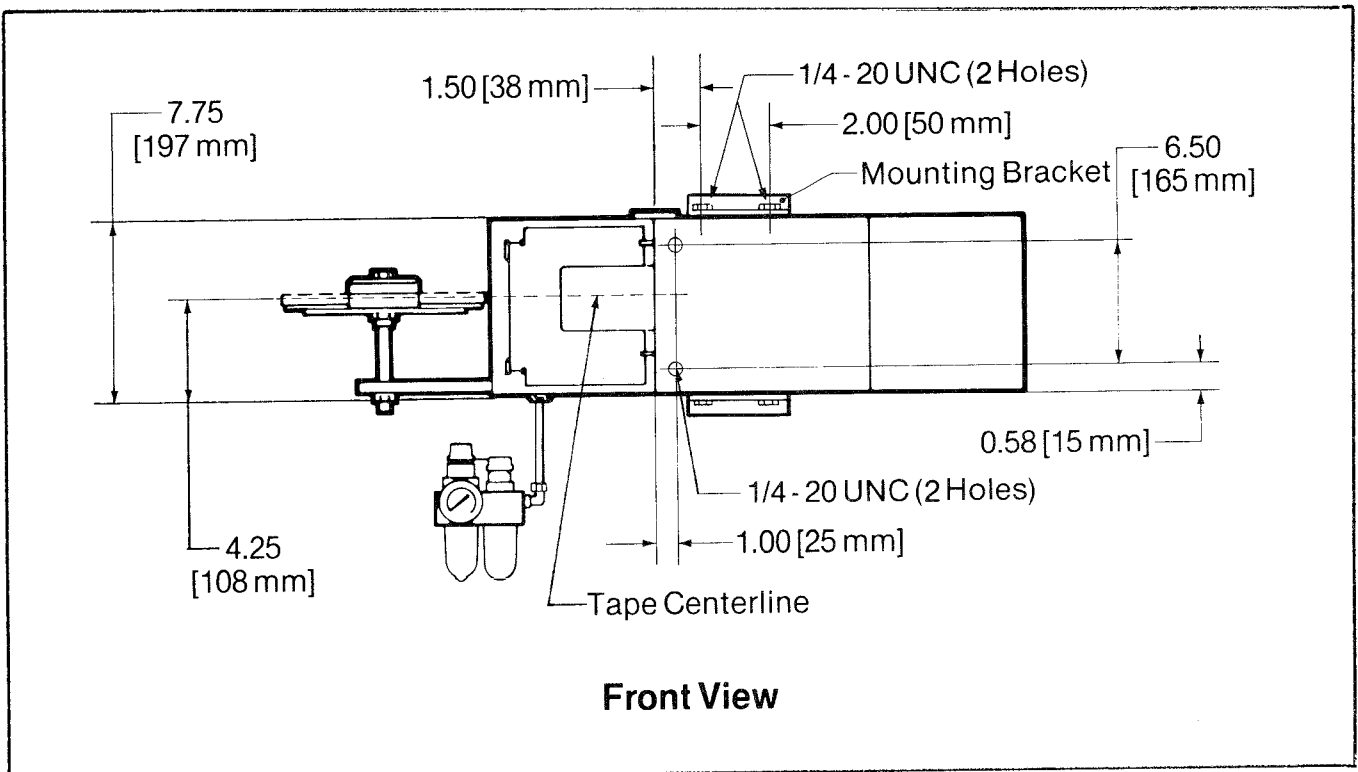


Figure 3 - Mounting Side Taping Position - Front View

Installation And Set-Up (Continued)

Air Regulator-Filter-Lubricator - The air control unit is supplied with two mounting screws and lock nuts. Install the unit on the main plate, **left rear side**, in the mounting holes provided.

- A. Refer to Figure 4A and locate the air control unit (A) in a **vertical position** for proper operation. **Assemble and secure** the two 8-32 x 1/2 lg. screws, internal lock washers, and flat washers.
- B. Refer to Figure 4B and push the air line (B) onto the male elbow (C) on the right side of the air lubricator as shown.
- C. The main air line and all other fittings are to be supplied by the customer. Complete the set-up instructions before connecting the main air supply.
- D. Set the **on/off valve knob**, shown in Figure 4A, in "**off**" position and be sure the **main air supply is disconnected** before filling air lubricator with oil.
- E. Remove oil filler plug, shown in Figure 4B, and add oil to the lubricator reservoir, fill with oil to the full line indicated on the lubricator bowl.

Note: Use U.S.P. heavy mineral oil or SAE #5 or #10 non-detergent oil.

- F. Replace and secure the filler plug.

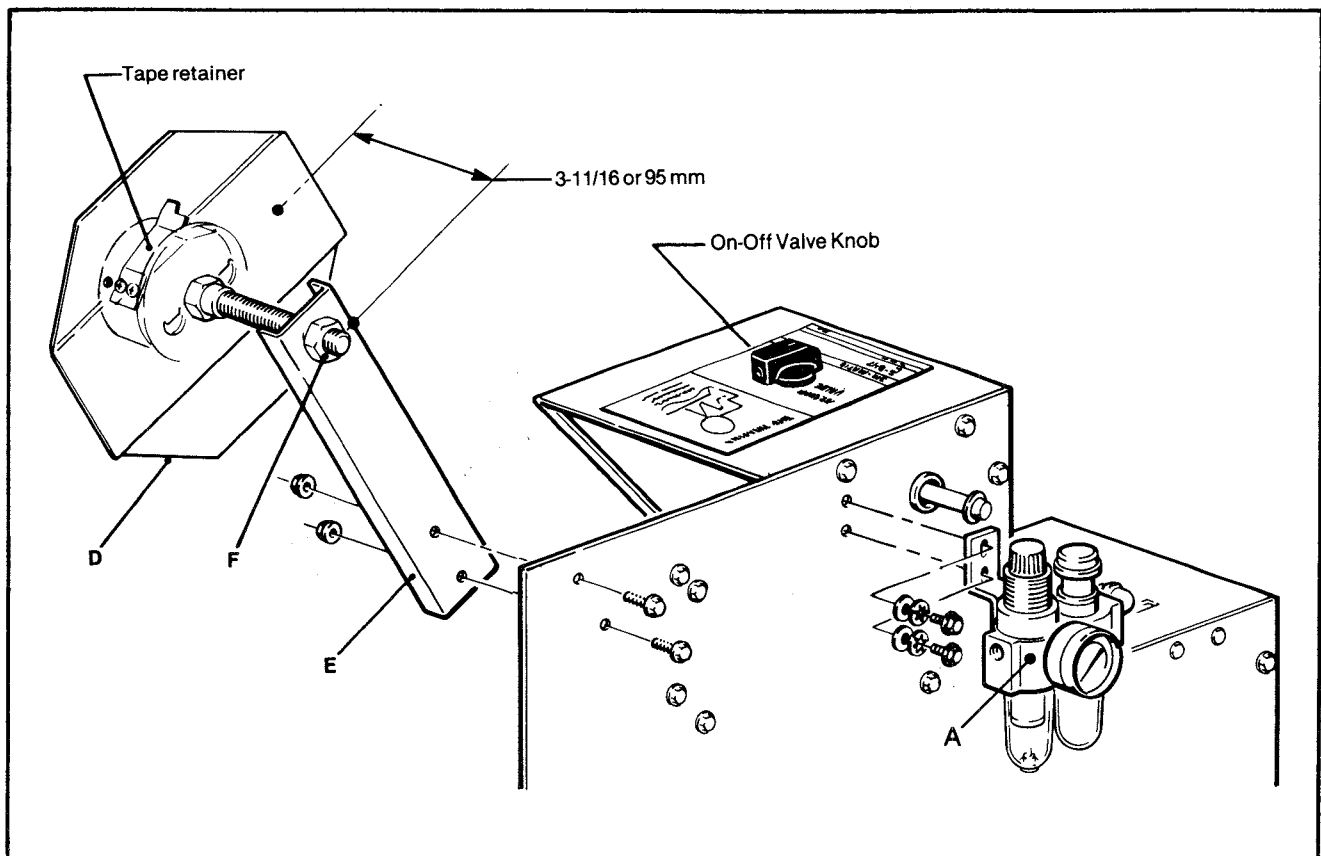


Figure 4A - Installation - Air Control - Left Side View

Installation And Set-Up (Continued)

- G. The lubricator oil metering adjustment knob, shown in Figure 4B, has been **preset open 1/4 turn**. If excessive oil becomes visible at the exhaust mufflers, **close** adjustment knob **clockwise 1/8 turn** or until one drop/60 cycles is visible in the sight-feed dome, shown in Figure 4B. If lubricator does not use oil, **open** adjustment knob **counterclockwise 1/8 turn** or until the drop rate of one drop/60 cycles is visible.
- H. The air regulator has been **preset at 60 PSIG (515 kPa gauge pressure)**. Connect the main air supply.

Tape Drum - Bracket Assembly

The tape drum bracket is supplied with two mounting screws and jam nuts. **Assemble** the tape drum to the bracket and **install** the bracket to the main plate, **left rear side**, in the mounting holes provided.

- A. Refer to Figure 4A and **assemble** the tape drum (D) to the bracket (E) to be positioned at the dimension 3 11/16 inches or 95 mm as shown. **Secure** the setting with the 1/2-13 jam nut (F).
- B. **Install and secure** the tape drum - bracket assembly with two 1/4-20 x 3/4 lg. screws and jam nuts.

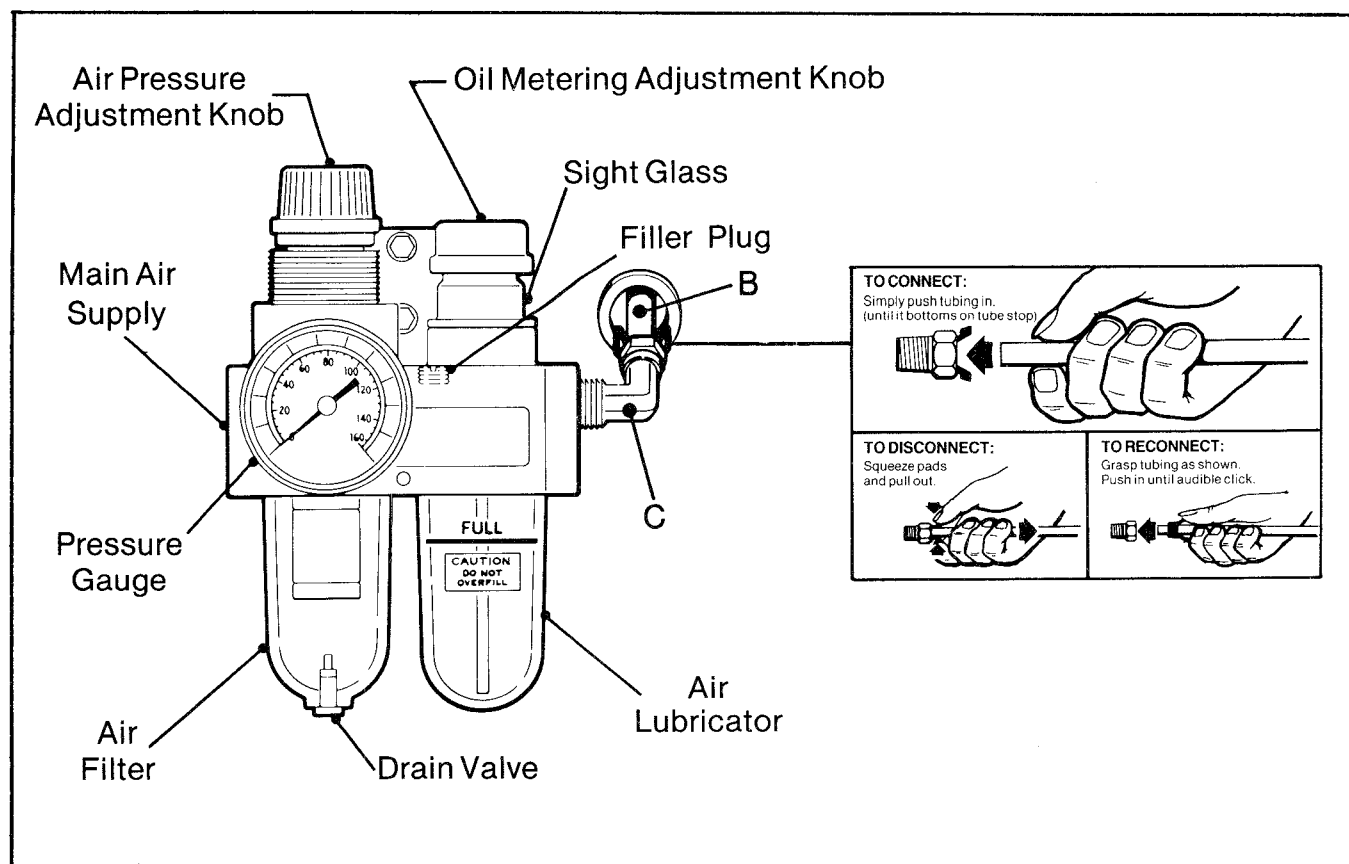


Figure 4B - Air Control Unit - Set-Up

Installation And Set-Up (Continued)

Tape Loading and Threading - The tape drum assembly is set up for dispensing **1/2 inch or 12 mm wide tape**. For dispensing other tape widths, refer to the **tape width adjustment section**. A tape threading diagram is located outside the applicator on the top of the nest for quick reference.

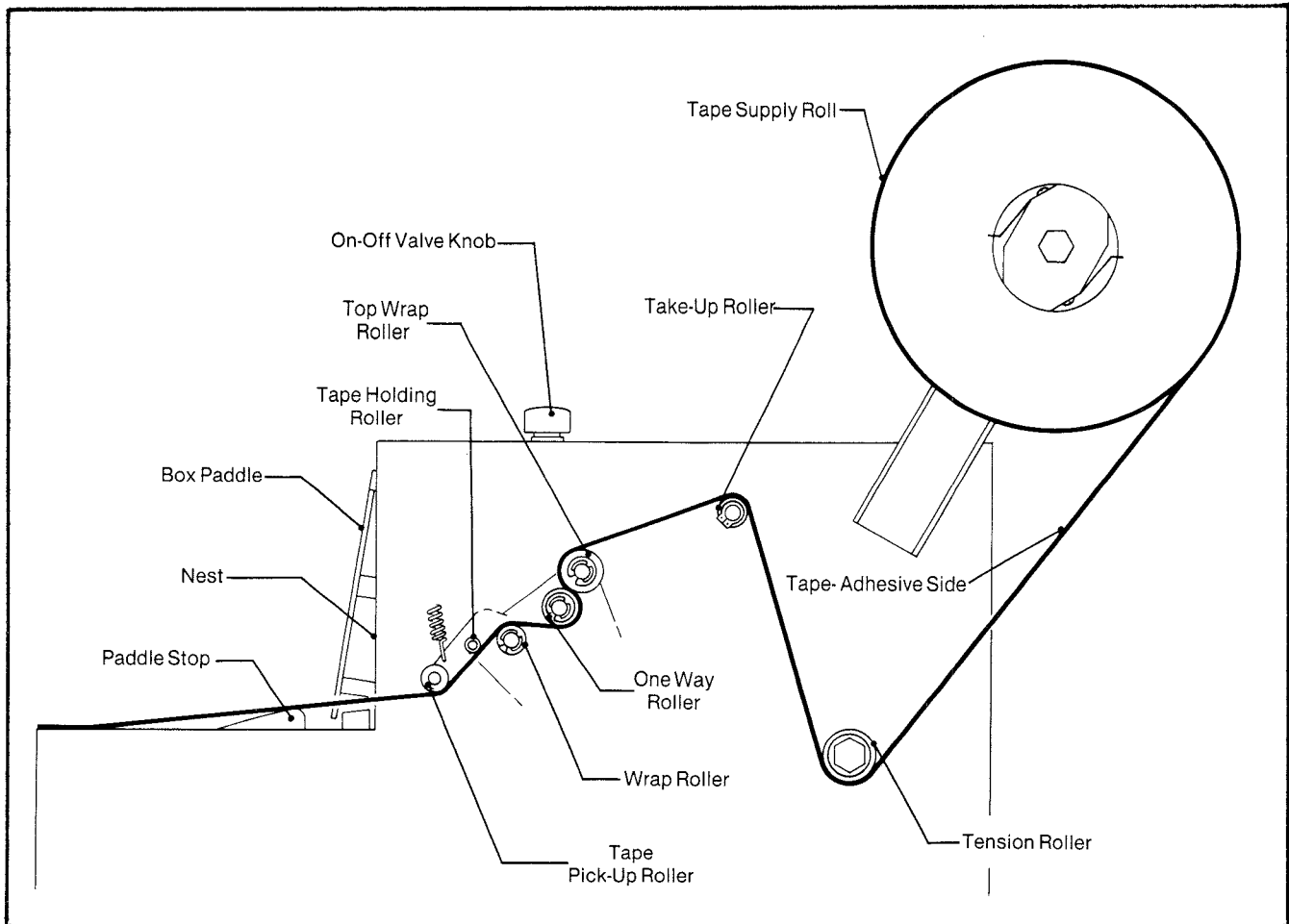


Figure 5 - Tape Loading & Threading - Right Side View

WARNING - TURN "OFF" MAIN AIR SUPPLY AT ON/OFF VALVE BEFORE THREADING TAPE. PERSONNEL INJURY OR EQUIPMENT DAMAGE CAN POTENTIALLY RESULT.

For easy access to tape loading and threading, **open the cover** located on the right side of the S-847. **Release the cover latch**, shown in Figure 1, **pull outward** on the upper part of the latch, **unhook the latch** and pivot open the cover.

Refer to Figure 5 and thread the tape as follows:

- A. Place the tape roll on the tape drum so the **tape is dispensed downward, adhesive side forward**. The tape roll **must be** fully against the drum flange.
- B. Pull approximately **12 inches or 300 mm** of tape from the roll and thread the tape under the tension roller, **adhesive side up**.

Installation And Set-Up (Continued)

- C. Bring the tape up over the take-up roller, **adhesive side up**.

WARNING - USE CARE WHEN WORKING NEAR KNIFE BLADE AS BLADE IS EXTREMELY SHARP. IF CARE IS NOT TAKEN, SEVERE INJURY TO PERSONNEL COULD RESULT.

- D. Thread the tape over the top wrap roller, around the one way roller assembly, over the wrap roller, **adhesive side toward the nest**, begin tape down behind the tape holding roller and also the tape pick-up roll.

Note: To simplify the tape threading at the next reloading, replace with a new roll of "**Scotch**" brand filament tape, and splice the tape web together at the tension roller.

- E. Pull out enough tape to tack it to the top of the nest as shown.

Note: Remove all work tools, etc. from inside S-847 case before closing cover.

- F. Close the cover and **secure** the latch.

WARNING - BE CAREFUL NOT TO PUT FINGERS IN AREA OF CUT OUT OPENING IN NEST. SEVERE INJURY TO PERSONNEL COULD RESULT.

- G. Turn "**on**" the main air supply at the **on/off valve**.
- H. To clear the tape which has been tacked to the nest, manually holding the paddle stop **down** and **push** the box paddle **in** to cycle the unit. The applicator is ready to operate.

Operating Sequence

- A. **Move the box forward** over the paddle stops, depressing the box paddle and hold it **firmly** and **squarely** against the nest vertical surface to apply the tape.
- B. The application only takes **1/4 second** to apply the tape, then the box can be removed from the nest while the machine continues to complete the cycle.

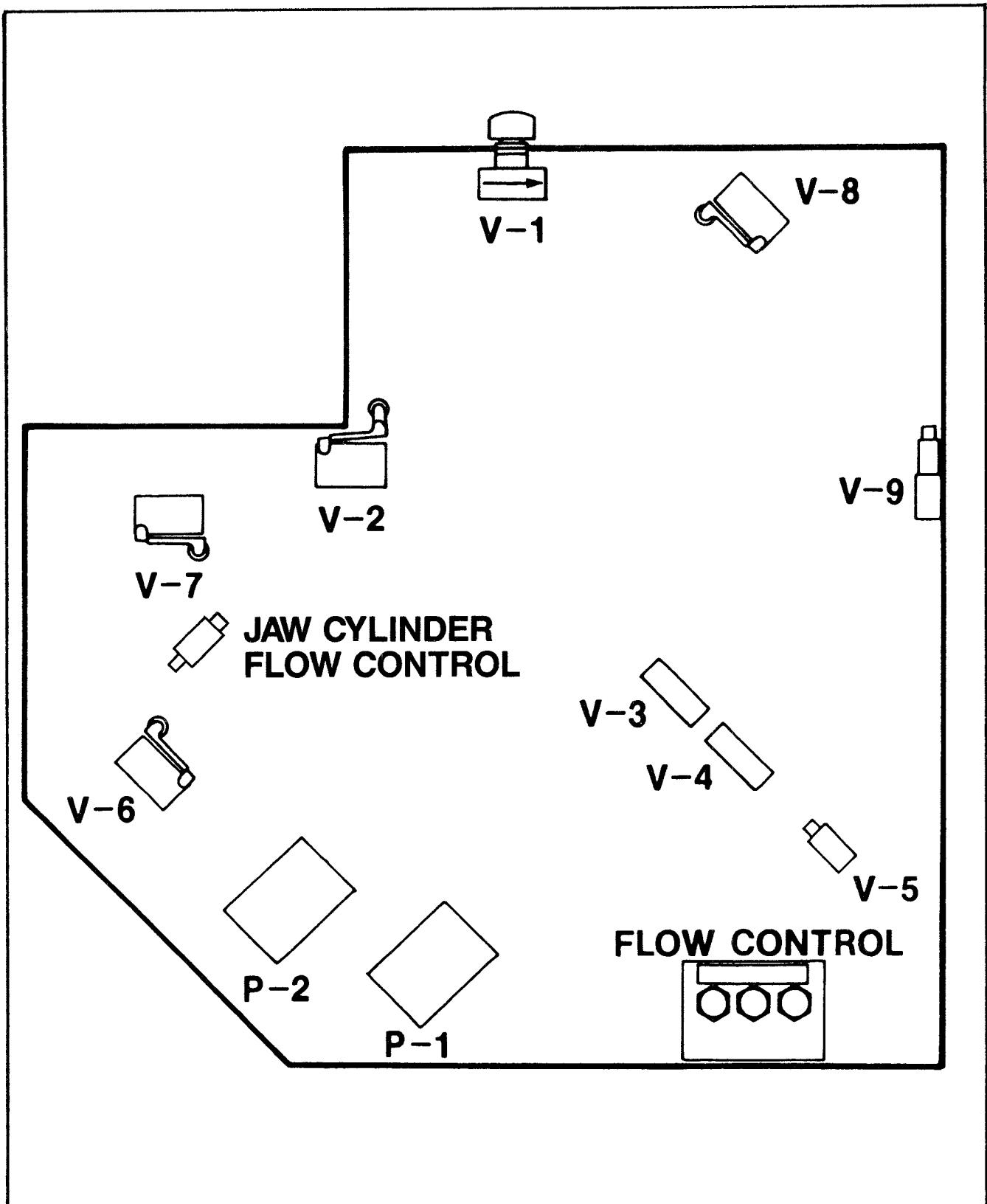


Figure 6 - Trouble Shooting Valve Locations - S-847 Right Side View

Operation (Continued) Trouble Shooting In Sequence of Operation

Problem	Possible Cause	Correction
Unit does not cycle.	<ol style="list-style-type: none"> 1. Air supply shut off or not connected to unit. 2. Cover open. 3. Valve V-8 out of adjustment or defective. 4. Valve V-9 out of adjustment or defective. 5. Valve V-2 out of adjustment or defective. 6. Power valve P-1 defective. 	<ol style="list-style-type: none"> 1. Check main air supply line and turn on unit. 2. Close cover. 3. Adjust or replace valve V-8. 4. Adjust or replace valve V-9. 5. Adjust or replace valve V-2. 6. Replace valve.
Cut-off Assy and/or Buffing Assy do not retract.	<ol style="list-style-type: none"> 1. Valve V-3 out of adjustment or defective. 2. Flow control closed. 	<ol style="list-style-type: none"> 1. Adjust or replace valve V-3. 2. Adjust retract flow control for buff cylinder.
Cut-off Assy and Buffing Assy cycle extend and retract and unit stops.	<ol style="list-style-type: none"> 1. Valve V-4 out of adjustment or defective. 2. Flow control closed. 3. Power valve P-2 defective. 	<ol style="list-style-type: none"> 1. Adjust or replace valve V-4. 2. Adjust extend flow control for feed cylinder. 3. Replace valve.
Feed Assy retracts and stops.	<ol style="list-style-type: none"> 1. Valve V-6 out of adjustment or defective. 2. Valve V-5 out of adjustment or defective. 	<ol style="list-style-type: none"> 1. Adjust or replace valve V-6. 2. Adjust or replace valve V-5.
Feed cylinder extends but does not actuate V-8 valve.	<ol style="list-style-type: none"> 1. Valve V-7 out of adjustment or defective. 2. Valve V-5 out of adjustment or defective. 	<ol style="list-style-type: none"> 1. Adjust or replace valve V-7. 2. Adjust or replace valve V-5.
Tape not cutting or tape end shredding or buffing rollers stop in mid stroke and do not apply the tape.	<ol style="list-style-type: none"> 1. Dull blade. 2. Blade out of adjustment. 	<ol style="list-style-type: none"> 1. Replace blade. 2. Readjust blade and tighten screw.
Buffing arm/cut-off blade do not return. Oscillate back and forth.	<ol style="list-style-type: none"> 1. Air circuit out of sequence. 2. Power valve P-1 defective 	<ol style="list-style-type: none"> 1. Hold actuator arm closed on V-3 valve. 2. Replace valve.

Adjustments

WARNING - TURN "OFF" MAIN AIR SUPPLY AT ON/OFF VALVE BEFORE MAKING ANY ADJUSTMENT.

Tape Width - The tape drum is assembled at the factory for 3/8 inch or 9 mm and 1/2 inch or 12 mm wide tapes. For 5/8 inch or 15 mm tapes the retainers must be moved to the secondary position on the tape drum. This is done by removing the two screws and relocating the retainer, shown in Figure 4A, then replacing and securing the screws.

Tape Web Alignment - The tape drum assembly controls tape web alignment in the applicator. Adjust the tape drum assembly so the tape web is dispensed, centered on the buffing rollers.

Tape Drum Tension - The tape drum assembly provides a preset tape roll tension to control overtravel. The tape drum tension requires no further adjustment.

Tape Tension Roller - The tension roller assembly, shown in Figure 5, provides a preset tension to the tape web. No further adjustment is required. If the tension roller assembly is replaced or comes out of adjustment, make adjustment as follows to obtain tension to the tape web: turn the lock nut, located behind the tension roller assembly, counterclockwise to increase tension, clockwise to decrease tension.

Air Flow Controls

FEED EXTEND: 3/4 TO 1 TURN OPEN
FEED RETRACT: 1/2 TO 5/8 TURN OPEN
BUFF RETRACT: 3/8 to 1/2 TURN OPEN

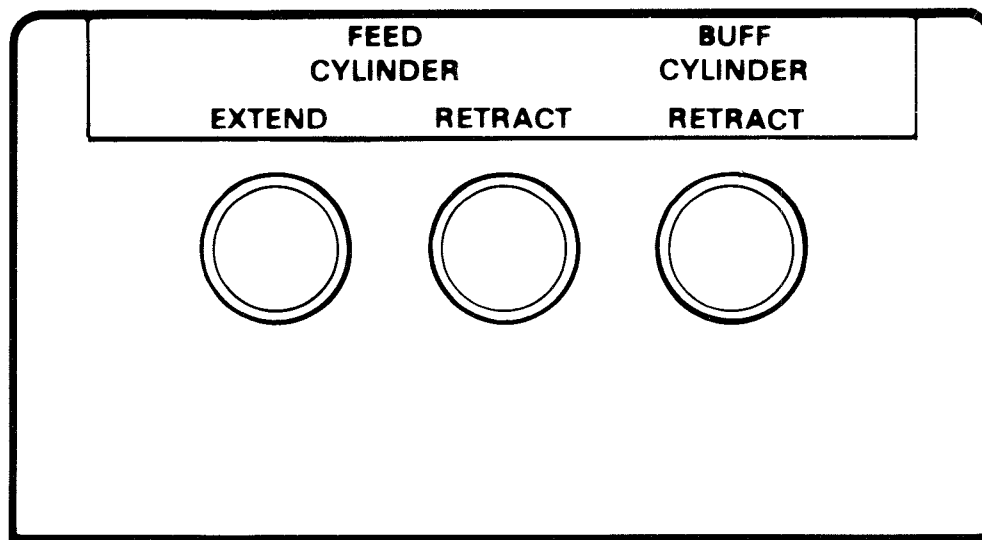


Figure 7 - Air Flow Controls

Adjustments (Continued)

Air Flow Controls - The flow controls for the tape feed air cylinder and tape buff air cylinder are **preset at the factory**. The controls are located on a bracket at the bottom inside the S-847. Should adjustment be necessary, turn knob **counterclockwise to increase cylinder speed** and **clockwise to decrease cylinder speed**. Factory adjustment was set as shown in Figure 7. The flow control, mounted on the jaw cylinder to control speed, has been **pre-set three turns open at the factory**.

Maintenance

WARNING - TURN "OFF" MAIN AIR SUPPLY AT ON/OFF VALVE BEFORE BEGINNING ANY MAINTENANCE.

Blade Replacement - Refer to Figure 8.

WARNING - USE CARE WHEN WORKING NEAR KNIFE BLADE AS BLADE IS EXTREMELY SHARP. IF CARE IS NOT TAKEN, SEVERE INJURY TO PERSONNEL COULD RESULT.

- A. Release latch and open cover on right side of S-847.
- B. Remove and retain two screw (A), lock washers (AA) and blade guard (B).
- C. Wrap old blade cutting teeth with tape to help prevent injury.
- D. Remove and retain blade screw (C), lock washer (CC), blade clamp (D) and **discard** old blade.
- E. Wrap tape around replacement blade teeth and install blade with beveled side up as shown.
- F. Remove tape and **secure** blade at dimension $\frac{3}{4} \pm \frac{1}{16}$ inch or 15-17 mm as shown.
- G. **Install and secure** all parts in reverse order.
- H. **Close and secure** cover and turn on main air supply.

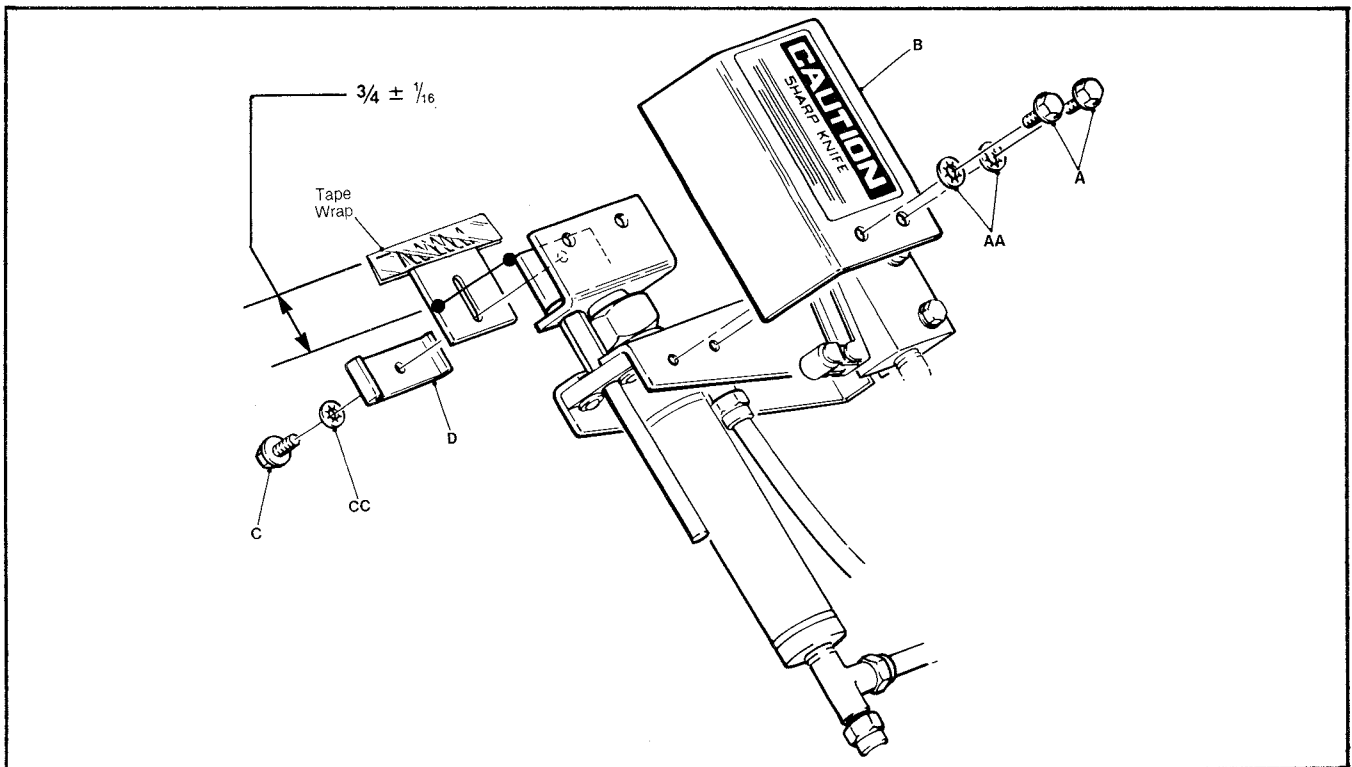


Figure 8 - Blade Replacement - Right Side View.

Maintenance (Continued)

Air Line Filter - Refer to Figure 4B. The air filter supplied with the S-847 is equipped with an automatic drain. **No further maintenance is required.**

Lubrication

WARNING - TURN "OFF" MAIN AIR SUPPLY AT ON/OFF VALVE BEFORE BEGINNING ANY MAINTENANCE.

A. Air Line Lubricator - Refer to Figure 4B. **Maintain proper level** in lubricator.

Note: Use U.S.P. heavy mineral or SAE #5 or #10 non-detergent oil.

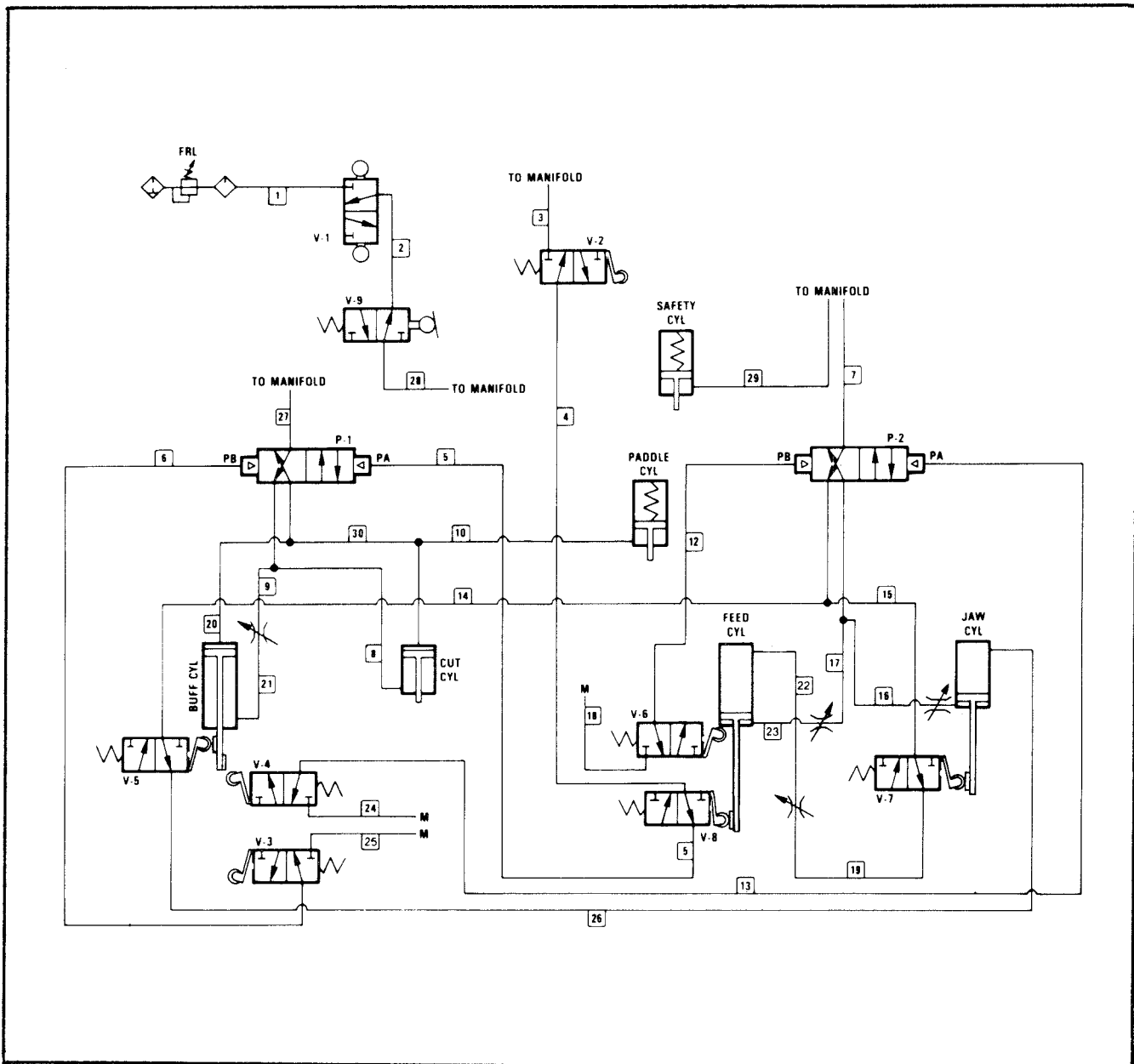


Figure 9 - Pneumatic Circuit Diagram - S-847, Model 28400

Spare Parts List

It is suggested that the following minimum list of spare parts be maintained.

Note: Refer to "How To Order Replacement Parts" for order information.

Qty.	Ref. No.	Part Number	Description
2	10	78-8046-8594-5	Roller - Buffing
1	77	70-8601-0016-6	Blade - Serrated

How To Order Replacement Parts

1. Refer to Figures 10 thru 18 to determine individual part and reference number. Refer to replacement parts list for the part number and part name.

Note: The complete description has been included for most common fasteners and commercially available components. This has been done to allow the customer to obtain these standard parts locally, should they elect to do so.

2. Order parts by part number, description, catalog number, model number and part quantity required. Order form attached to back section of manual.

Minimum billing on parts orders will be \$10.00.
Replacement part prices available on request.

3. Replacement parts and part prices available direct from:

Dispenser Parts
241 Venture Drive
Amery, WI 54001

4. For machine repair service, ship direct to:

Tape Equipment Repair Services
241 Venture Drive
Amery, WI 54001

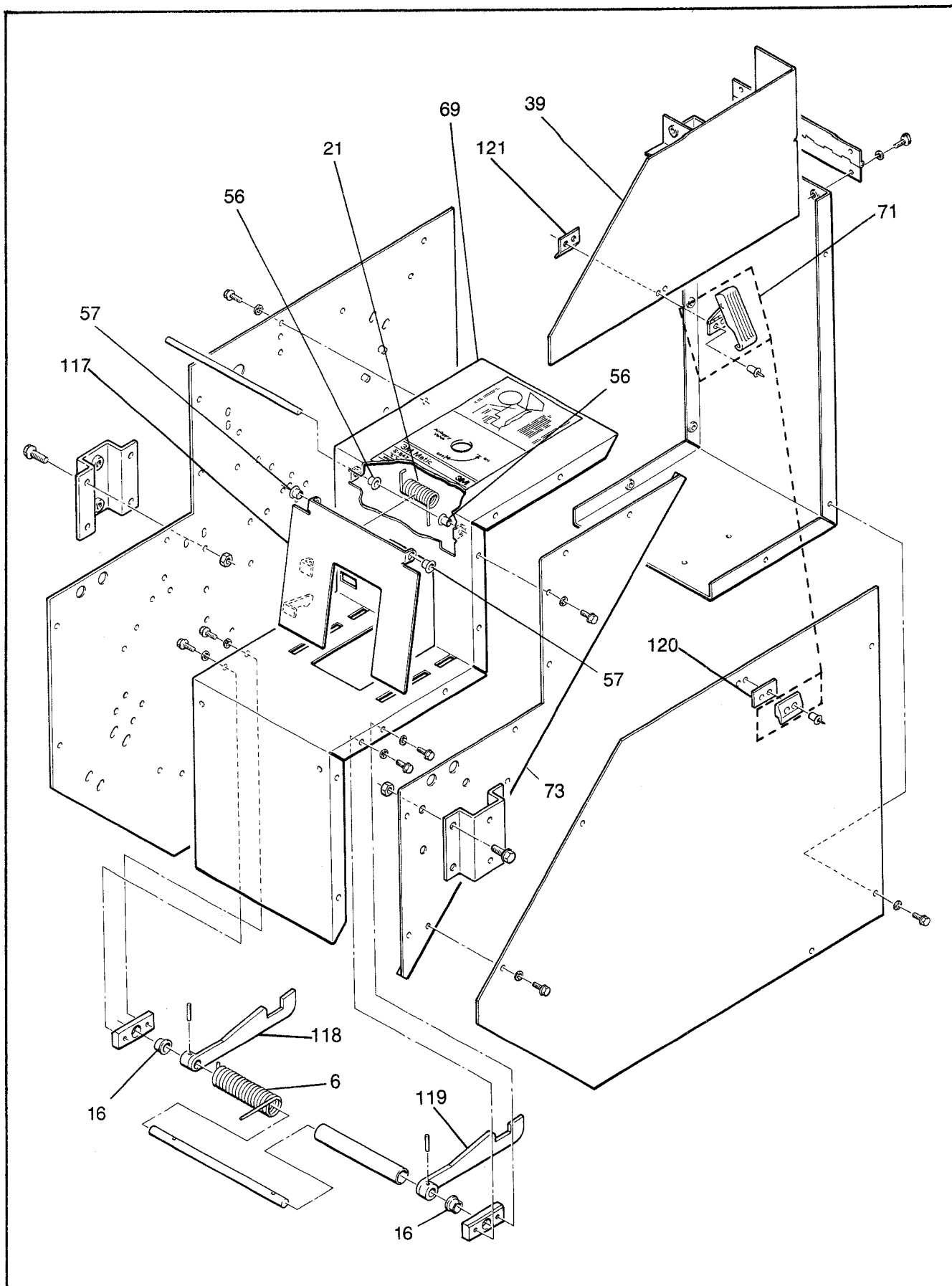


Figure 10 - Main Frame - Nest - Covers

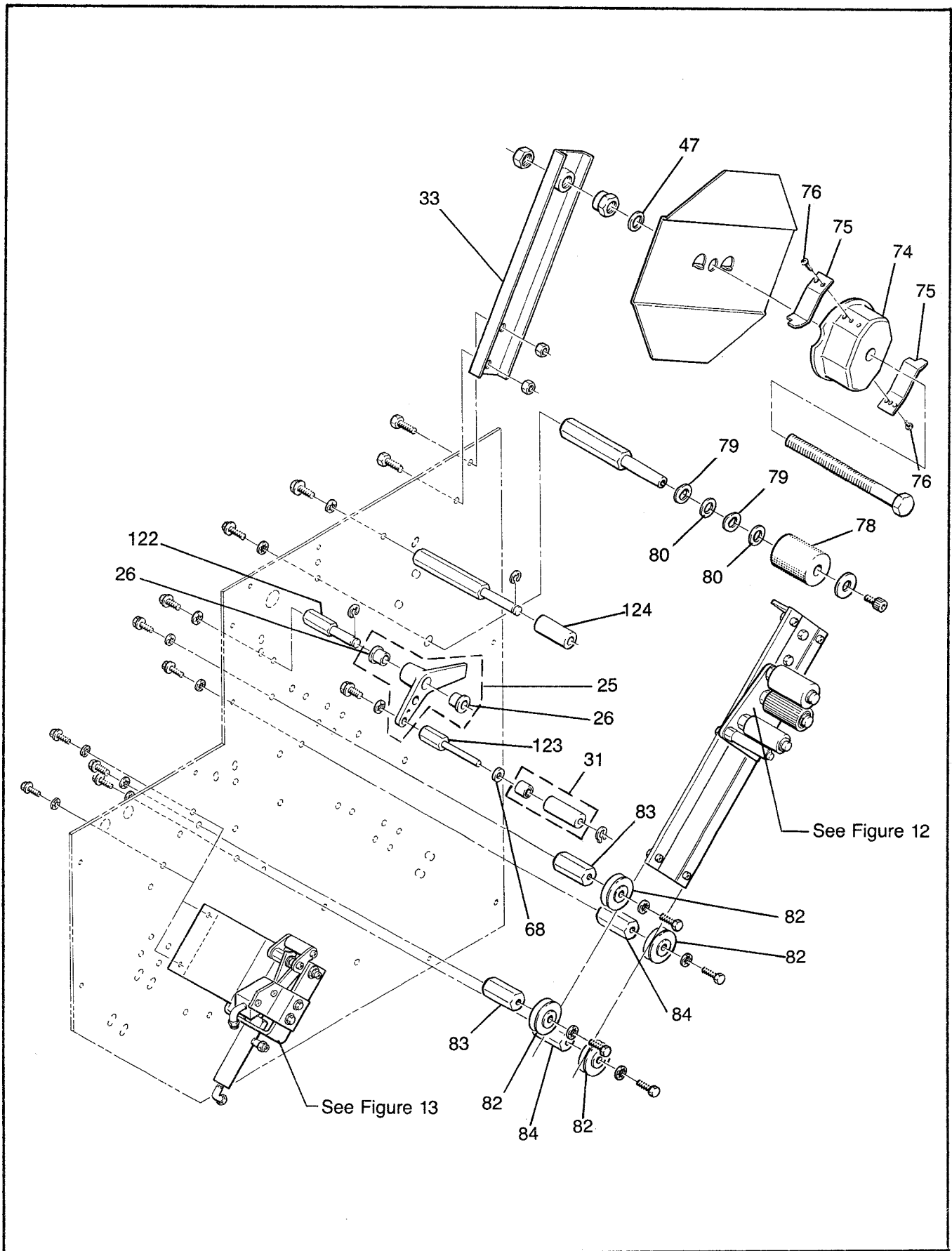


Figure 11 - Tape Drum Assembly - Tension Roller Assembly

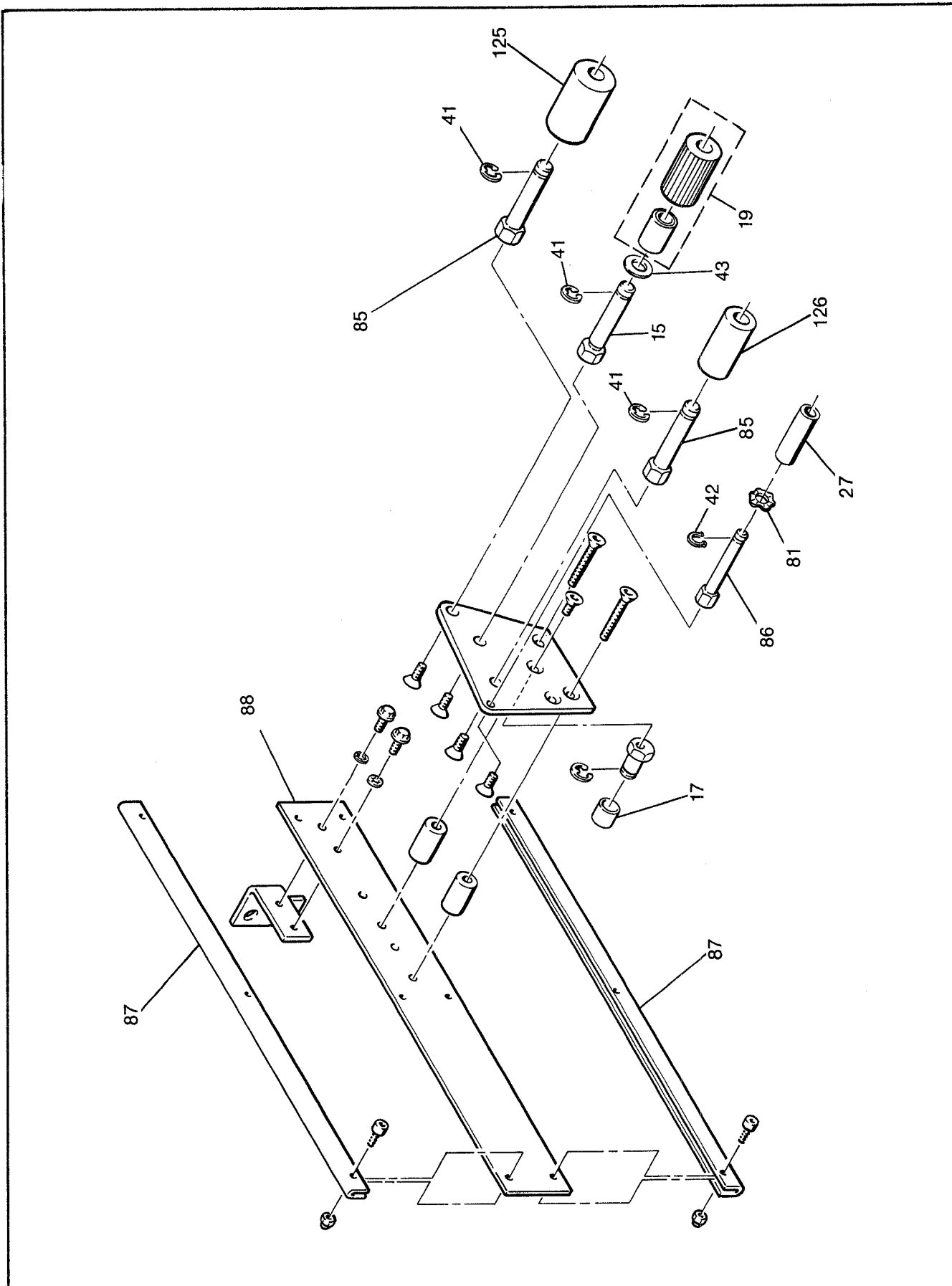


Figure 12 - Feed Assembly

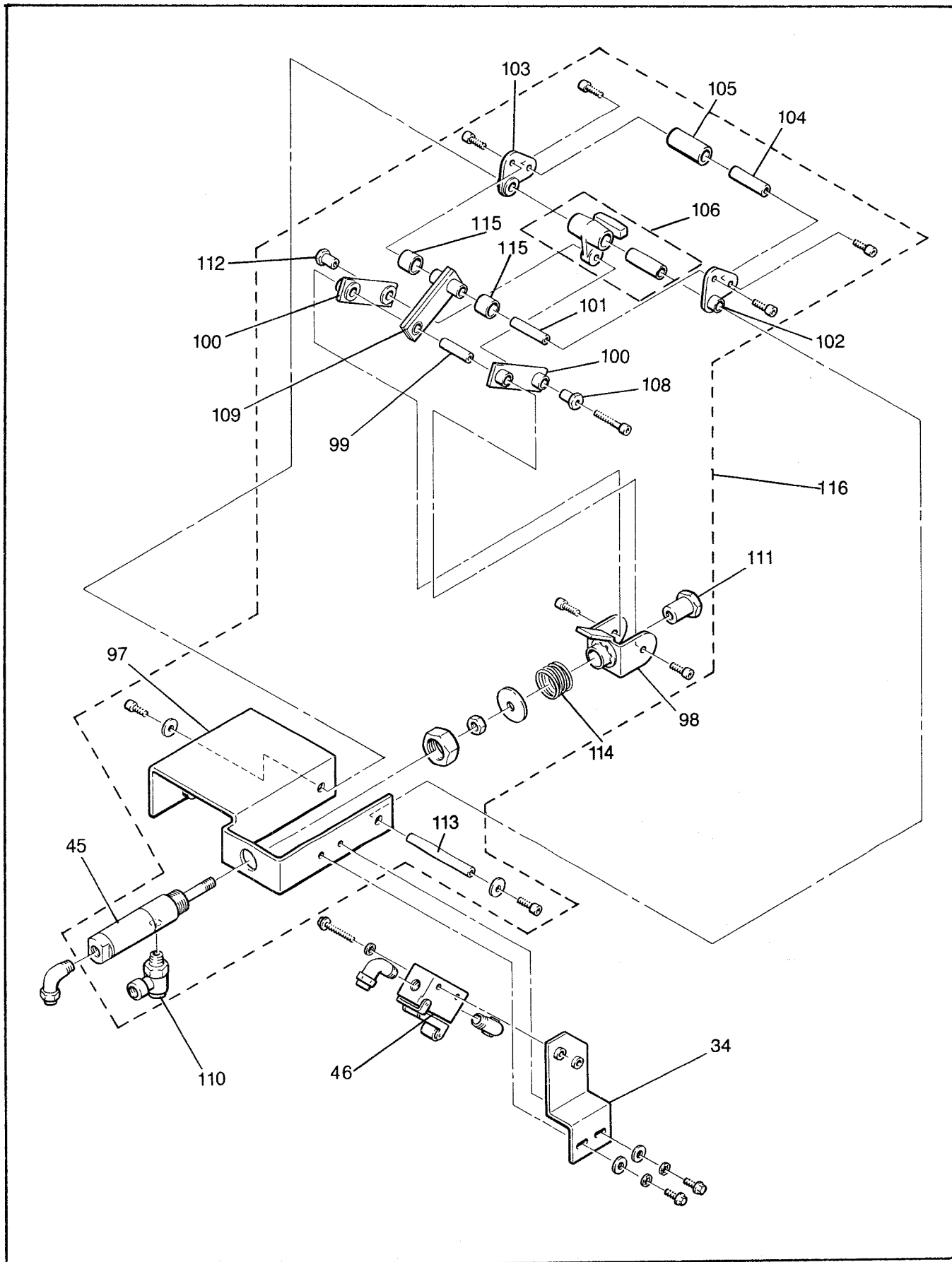


Figure 13 - Jaw Assembly

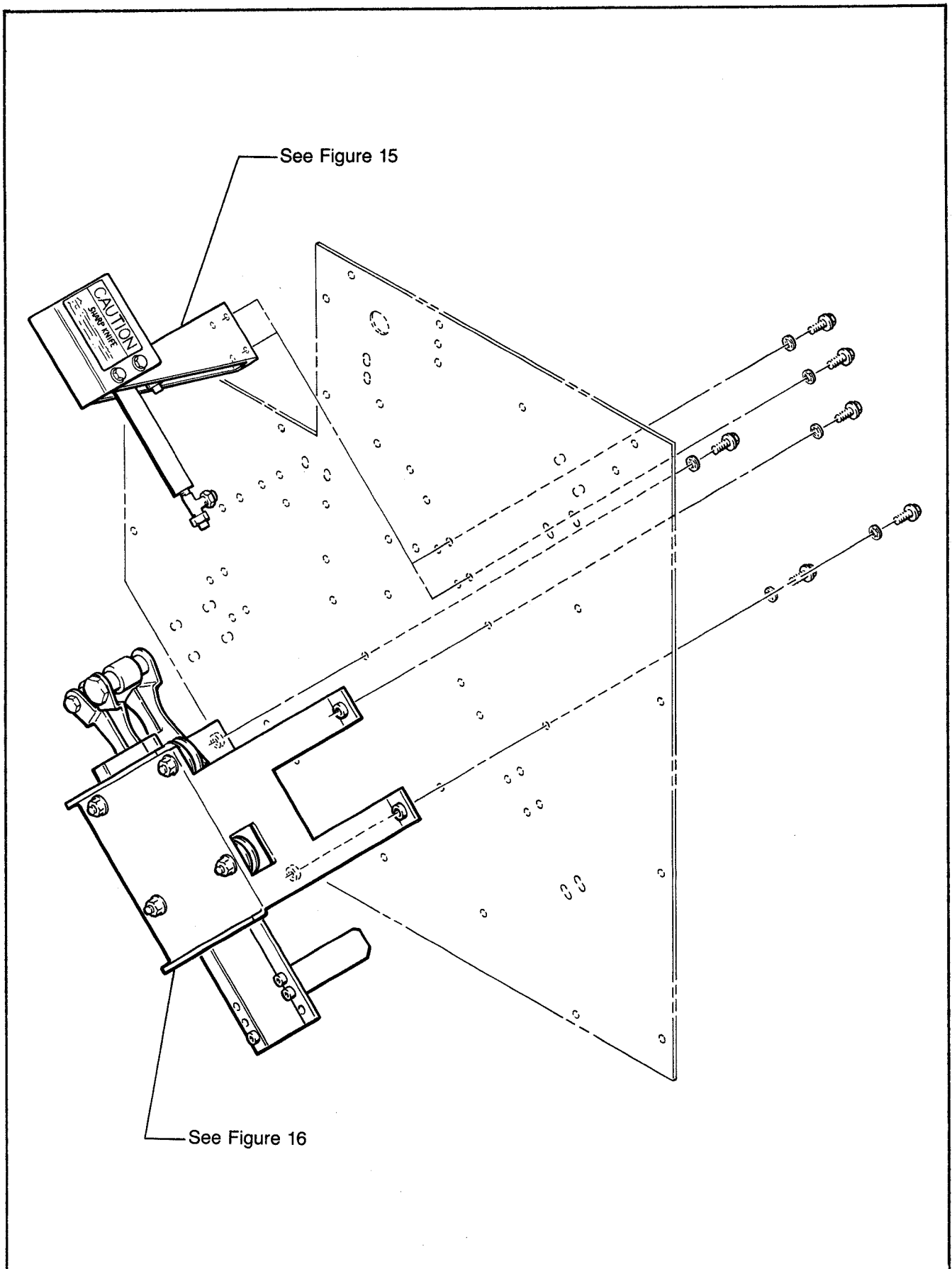


Figure 14 - Cut Assembly - Buff Assembly

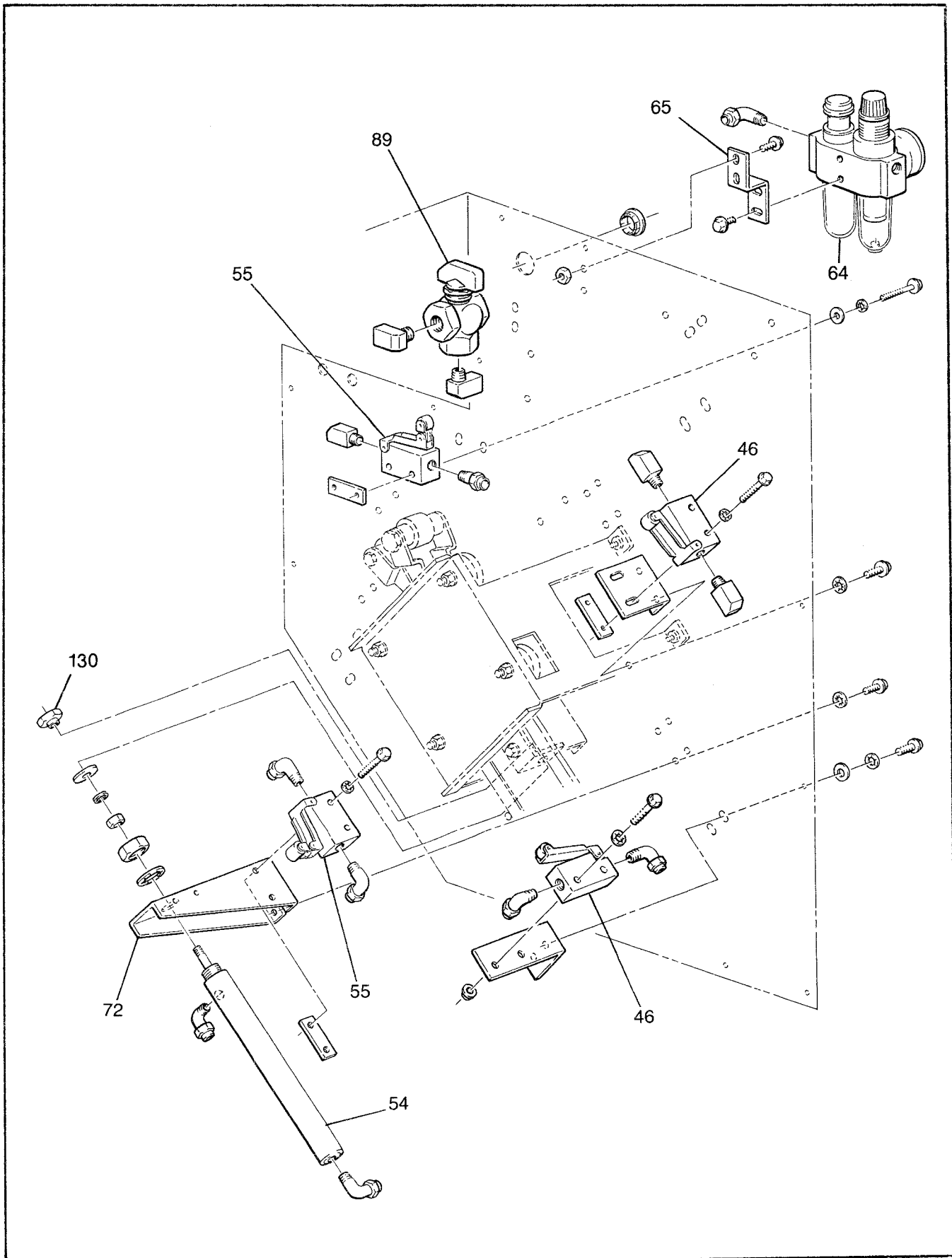


Figure 17 - Pneumatic Components

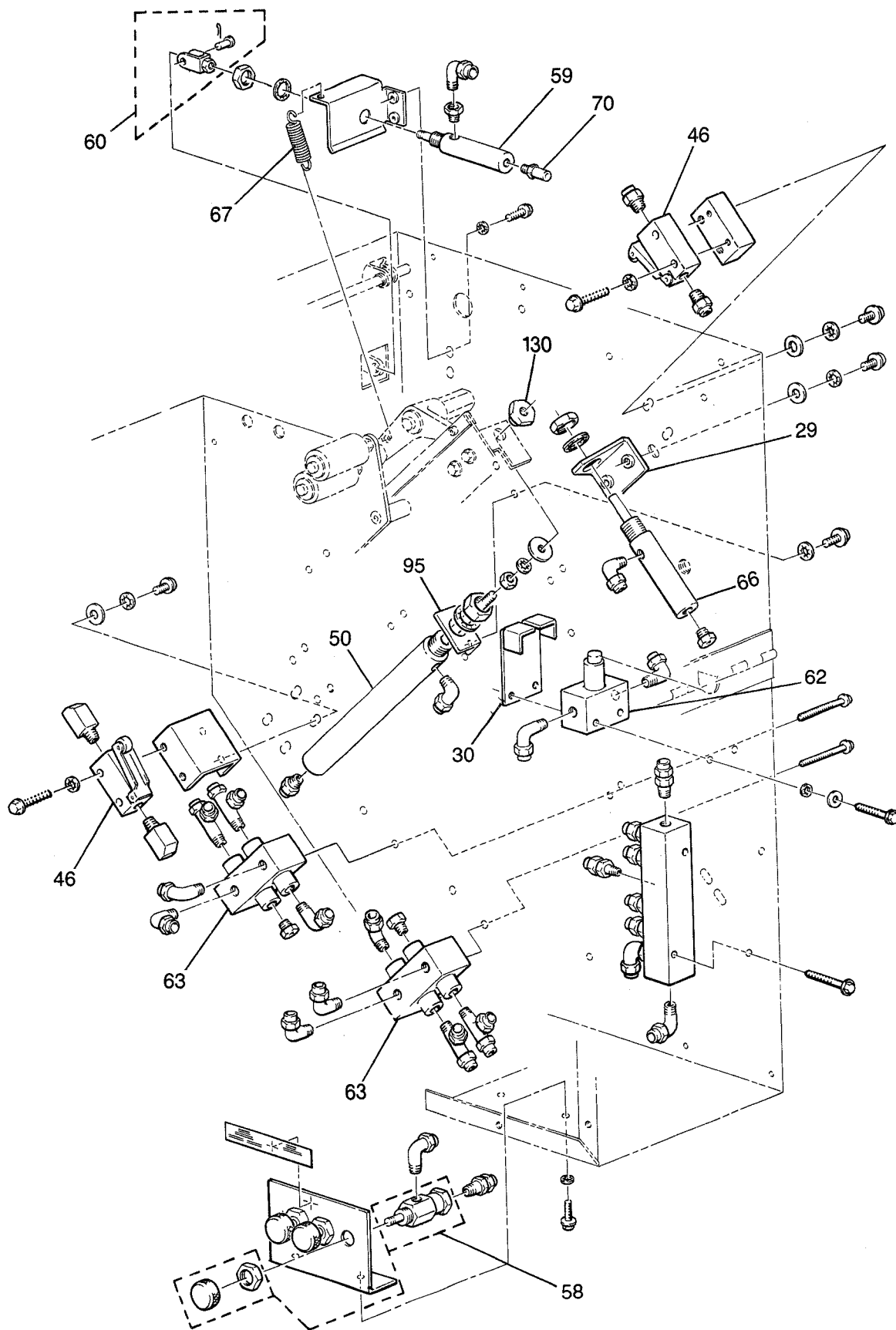


Figure 18 - Pneumatic Components

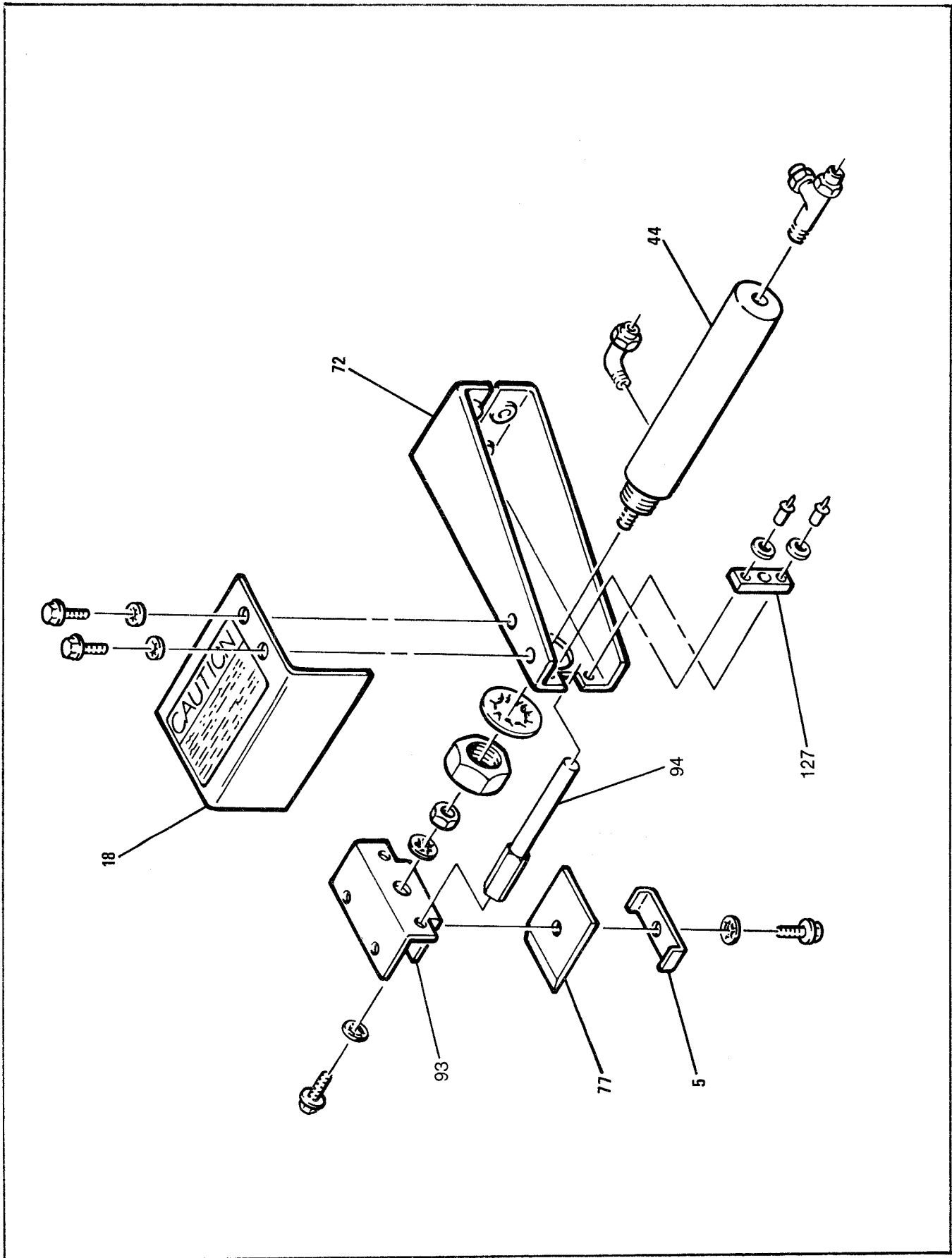


Figure 15 - Cut Assembly

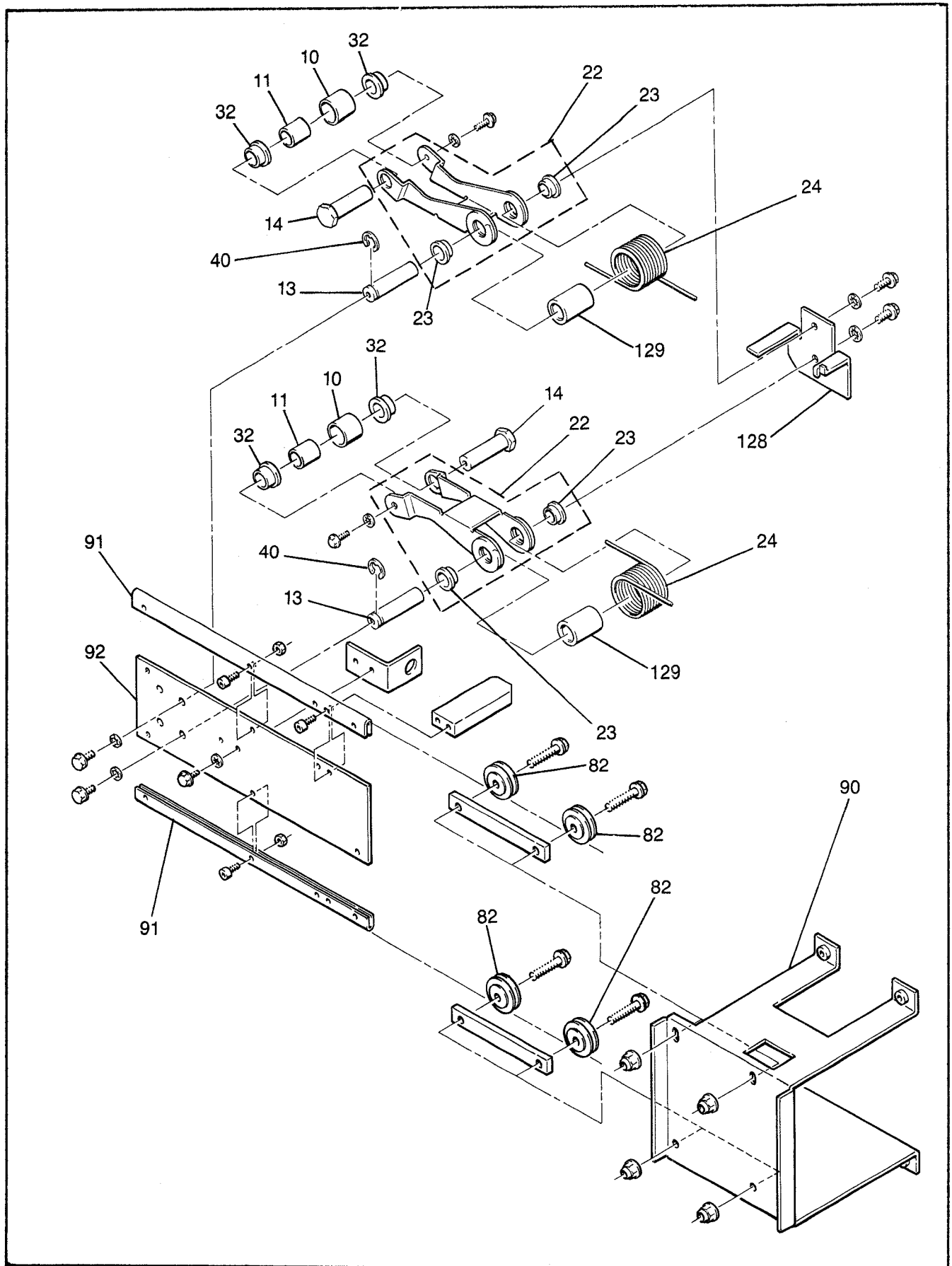


Figure 16 - Buff Assembly

Replacement Parts List

S-847 "L" Clip Applicator, Model 28400

Ref. No.	Part Number	Description
5	78-8046-8574-7	Clamp - Blade
6	78-8046-8606-7	Spring - Torsion
10	78-8046-8594-5	Roller - Buffing
11	78-8046-8592-9	Sleeve - Roller
13	78-8046-8586-1	Shaft - Buff Arm
14	78-8046-8595-2	Shaft - Buffing
15	78-8046-8564-8	Shaft - Roller
16	78-8161-4222-4	Bearing - Flanged "OILITE" #FF-520-10
17	78-8046-8570-5	Bumper - Cam
18	78-8046-8575-4	Blade Guard Assy.
19	78-8046-8565-5	Roller - One Way Assy.
21	78-8046-8510-1	Spring - Paddle
22	78-8046-8587-9	Buffing Arm Assy.
23	78-8032-1206-3	Bearing - Flanged "OILITE" #FF-636-3
24	78-8046-8590-3	Spring - Buffing Roller
25	78-8046-8511-9	Tape Arm Pick-up Assy.
26	78-8161-4227-3	Bearing - Flanged "OILITE" #FF-520-5
27	78-8046-8568-9	Roller - Tape Holding
29	78-8052-6333-8	Mount - Safety
30	78-8046-8509-3	Cover - Switch
31	78-8046-8545-7	Pick-up Roller Assy.
32	78-8046-8593-7	Spacer - Buffing Roller
33	78-8046-8550-7	Support - Tape Drum
34	78-8046-8541-6	Bracket - Valve
39	78-8052-6265-2	Cover - Safety
40	78-8656-4012-8	Ring - Retaining E-Ring "WALDES" #5133-50
41	78-8656-4003-7	Ring - Retaining E-Ring "WALDES" #5133-37
42	78-8656-5004-4	Ring - Retaining Gripping "WALDES" #5555-25
43	78-8163-0112-7	Bearing - Thrust "OILITE" #TT-710-1
44	78-8057-5759-4	Cylinder - Cut
45	78-8057-5757-8	Cylinder - Jaw
46	26-1004-7410-0	Valve - Air 3 Way Roller Actuator SMC No. VM-131-01-01
47	78-8014-1001-6	Bearing - Thrust "OILITE" #TT-706
50	78-8057-5758-6	Cylinder - Feed
54	78-8057-5753-7	Cylinder - Buffing
55	26-1004-7411-8	Valve - Air 3 Way, One Way Roller SMC No. VM-131-01-02-X6
56	78-8161-8389-7	Bearing - "NYLINER" THOMSON #4L1-FF
57	78-8002-4778-1	Bearing - "NYLINER" THOMSON #4L2-FF
58	26-1004-7415-9	Flow Control - Flairline No. RFC-1/8 PK
59	78-8057-5755-2	Cylinder - Paddle
60	78-8057-5760-2	Clevis - Rod
62	26-1004-7412-6	Valve - Air 3 Way, Plunger SMC No. VM130-01-05B
63	26-1004-7414-2	Valve - Air 4 Way Pilot Operated Mac No. 921 ARA
64	26-1004-9750-7	Filter-Regulator-Lubricator Norgren No. PSH-200-A1AA
65	26-1004-9751-5	Bracket - Mtg. Norgren No. 5939-10
66	78-8057-5754-5	Cylinder - Safety
67	78-8003-9416-1	Spring - Ext. Lee No. LE-041D-6MW
68	78-8163-0100-2	Bearing - Thrust "OILITE" #TT-504

Parts List

S-847 "L" Clip Applicator, Model 28400

Ref. No.	Part Number	Description
69	78-8052-6253-8	Nest
71	26-1004-0699-5	Latch - Draw Southco No. 07-10-201-12
72	78-8046-8572-1	Bracket - Air Cylinder
73	78-8052-6254-6	Plate - Front
74	78-8023-2190-7	Drum - Tape
75	78-8023-2191-5	Retainer - Tape
76	26-1002-4949-4	Screw - Self Tap. Thd. Form 6-19 x 3/8 Lg.
77	70-8601-0016-6	Blade - Serrated
78	78-8052-6334-6	Roller Tension
79	26-1002-6708-2	Washer - Wave Associated Spring No. U500-0170
80	26-1000-0664-7	Washer - Shim .500 ID x .75 OD x .015 Thk
81	26-1000-0922-9	Washer - Wave
82	26-1005-1157-0	Bearing - Ball Concave O.D. General Bearing No. 22030-01-020-A with Seals
83	78-8052-6336-6	Stand-off - Wheel
84	78-8052-6337-9	Stand-off - Wheel (Eccentric)
85	78-8046-8561-4	Shaft - Wrap Roller
86	78-8046-8567-1	Shaft - Tape Roller
87	78-8052-6348-6	Rail - Stripper
88	78-8052-6349-4	Plate - Stripper Mtg.
89	26-1005-5410-9	Valve - 3 Way, Brass Ball, Manual Actuator 1/8 NPTF, SMC No. 701-2F2F2F-BT
90	78-8052-6370-0	Bracket - Mtg.
91	78-8052-6368-4	Rail - Feed
92	78-8052-6366-8	Plate - Arm Mtg.
93	78-8046-8573-9	Bracket - Blade Mtg.
94	78-8046-8578-8	Rod - Slide
95	78-8052-6338-7	Mount - Cylinder
97	78-8054-8685-5	Jaw - Mounting Bracket
98	78-8054-8687-1	Clevis - Air Cylinder Assy.
99	78-8054-8671-5	Shaft - Clevis
100	78-8054-8672-3	Jaw Link Assy. - Outer
101	78-8054-8673-1	Shaft - Link
102	78-8054-8680-6	Plate - Roller Assy. R/H
103	78-8054-8681-4	Plate - Roller Assy. L/H
104	78-8054-8682-2	Shaft - Roller
105	78-8054-8683-0	Roller - Jaws
106	78-8054-8684-8	Clamp - Tape Assy.
108	78-8054-8675-6	Pin - Link Thru
109	78-8054-8676-4	Jaw - Link Assy. Inner
110	26-1005-5412-5	Swivel - Flow Control
111	78-8054-8690-5	Adapter - Air Cylinder
112	78-8054-8674-9	Pin - Link Tap
113	78-8054-8677-2	Shaft - Jaws
114	78-8054-8691-3	Spring - Jaw
115	78-8054-8719-2	Spacer
116	78-8057-5752-9	Jaw Assembly
117	78-8052-6250-4	Paddle - Box
118	78-8046-8603-4	Stop - Paddle L/H
119	78-8046-8604-2	Stop - Paddle R/H

Replacement Parts List

S-847 "L" Clip Applicator, Model 28400

Ref. No.	Part Number	Description
120	78-8046-8505-1	Spacer - Latch
121	78-8046-8504-4	Guide - Cover
122	78-8046-8542-4	Shaft - Tape - Arm
123	78-8052-6371-8	Shaft - Pickup
124	78-8046-8552-3	Roller - Takeup
125	78-8046-8562-2	Roller - Top Wrap
126	78-8046-8563-0	Roller - Wrap
127	78-8046-8577-0	Bracket - Slide
128	78-8046-8591-1	Plate - Buff Mtg.
129	78-8046-8589-5	Mandrel - Spring
130	78-8046-8553-1	Mount - Cycle Rod

