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.

Serial No.

For reference, record machine serial number here.

3M-Matic™
a80b  Type 10800
Adjustable Case Sealer
with AccuGlide™ 2+ Taping Heads

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

"3M-Matic" and "AccuGlide" are Trademarks of, 3M St. Paul, MN 55144-1000
Printed in U.S.A.
© 3M 2011 44-0009-2069-2 (C060311-NA)
This instruction manual covers safety aspects, handling and transport, storage, unpacking, preparation, installation, operation, adjustments, maintenance, troubleshooting, repair work and servicing plus parts list of the 3M-Matic™ a80b Adjustable case sealer.

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

Edition April 2011

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The manufacturer reserves the right to change the product at any time without notice.
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. If technical assistance or replacement parts are needed, call or fax the appropriate number.

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: Model a80b - Type 10800 - Serial Number 13282).

Identification Plate

![Identification Plate Image]

3M-Matic™, AccuGlide™ and Scotch™ are Trademarks of 3M St. Paul, MN 55144-1000
Printed in U.S.A.
TABLE OF CONTENTS - MANUAL 1: a80b Adjustable Case Sealer
(For Taping Head Information - See MANUAL 2: AccuGlide™ 2+ STD 2 Inch Taping Head)

a80b Adjustable Case Sealer

Cover Page
Replacement Parts and Service Information ............................................................... i - ii
Table of Contents ........................................................................................................ i - ii
Acronyms and Abbreviations ....................................................................................... vi

1. Introduction

1.1 Manufacturing Specifications / Description / Intended Use ................................. 1
1.2 How to Read and Use the Manual / Reference Documents ............................... 2
  1.2.1 Importance of the Manual ........................................................................... 2
  1.2.2 Manual Maintenance .................................................................................. 2
  1.2.3 Consulting the Manual ............................................................................... 2
  1.2.4 How to Update the Manual in Case of Modifications .................................. 2

2. General Information

2.1 Identification Data .............................................................................................. 3
2.2 Warranty / Contents ........................................................................................... 4

3. Safety

3.1 General Safety Information ................................................................................... 5
3.2 Signal Words Explanation .................................................................................... 5
3.3 Table of Warnings .............................................................................................. 6 - 7
3.4 Operator’s Qualifications .................................................................................... 8
3.5 Number of Operators ......................................................................................... 8
3.6 Safe Use of the Machine Instructions ................................................................ 8
3.7 Residual Hazards ............................................................................................... 8
3.8 Prevent Other Hazards - Recommendations and Measures ............................. 8
3.9 Personal Safety Measures ................................................................................... 8
3.10 Incorrect / Predictable Actions Not Allowed .................................................... 8
3.11 Operator’s Required Skill Levels ....................................................................... 9
3.12 Component Locations ....................................................................................... 10
3.13 Table of Warnings and Replacement Labels ..................................................... 11

4. Technical Specifications

4.1 Power Requirements ......................................................................................... 12
4.2 Operating Rate ................................................................................................. 12
4.3 Operating Conditions ....................................................................................... 12
4.4 Tape .................................................................................................................. 12
4.5 Tape Width ........................................................................................................ 12
4.6 Tape Roll Diameter ........................................................................................... 13
4.7 Tape Application Leg Length - Standard .......................................................... 13
  Tape Application Leg Length - Optional ................................................................. 13
4.8 Box Board ......................................................................................................... 13
4.9 Box Weight and Size Capacities ....................................................................... 13
4.10 Machine Dimensions ....................................................................................... 14
4.11 Machine Noise Levels ..................................................................................... 14
4.12 Buildup Recommendations ............................................................................. 14

a80b-NA

2011 April

iii
TABLE OF CONTENTS (continued)

5. Shipment, Handling, and Storage
   5.1 Packed Machine Shipment and Handling ................................................................. 15
   5.2 Overseas Shipment Packaging (Optional) ................................................................. 15
   5.3 Handling and Transportation of Uncrated Machine ................................................... 15
   5.4 Machine Storage ................................................................. 15

6. Unpacking
   6.1 Uncrating and Removal of Pallet .............................................................................. 16
   6.2 Packaging Materials Disposal ................................................................................. 16

7. Installation
   7.1 Operating Conditions .............................................................................................. 17
   7.2 Space Requirements for Machine Operation and Maintenance .................................. 17
   7.3 Tool Kit Supplied with the Machine ........................................................................ 17
   7.4 Machine Positioning ............................................................................................... 17
   7.5 Plastic Ties Removal .............................................................................................. 18
   7.6 Assembly Completion ............................................................................................. 18
   7.7 Taping Heads Completion ...................................................................................... 19
   7.8 Preliminary Electric Inspection ............................................................................... 19
   7.9 Main Power Machine Connection and Inspection ..................................................... 19
   7.10 Inspection of Phases ............................................................................................ 19

8. Theory of Operation
   8.1 Working Cycle Description ..................................................................................... 20
   8.2 Running Mode Definition ...................................................................................... 20
     8.3.1 Normal Stop Procedure ................................................................................... 20
     8.3.2 Emergency Stop ............................................................................................. 20

9. Controls
   9.1 Box Width Adjusting Knobs ................................................................................... 21
   9.2 On / Off Switch ..................................................................................................... 21
   9.3 Emergency Stop Button (Latching) ....................................................................... 21

10. Safety devices
    10.1 Blade Guards ...................................................................................................... 22
    10.2 Emergency Stop Button ...................................................................................... 22
    10.3 Electric System .................................................................................................. 22

11. Buildup and Adjustments
    11.1 Box Width Adjustment ....................................................................................... 23
    11.2 Changing the Tape Leg Length ........................................................................... 23
    11.3 Run Boxes to Check Adjustment ......................................................................... 23
# TABLE OF CONTENTS (continued)

## 12. Operation

12.1 Operator’s Correct Working Position ................................................................. 24  
12.2 Starting the Machine ......................................................................................... 24  
12.3 Starting Production ......................................................................................... 24  
12.4 Tape Replacement ............................................................................................. 24  
12.5 Box Size Adjustment ....................................................................................... 24  
12.6 Cleaning ........................................................................................................... 24  
12.7 Table of Adjustments ...................................................................................... 24  
12.8 Safety Devices Inspection ............................................................................... 24  
12.9 Troubleshooting ............................................................................................. 25

## 13. Maintenance

13.1 Safety Measures (see section 3) ....................................................................... 26  
13.2 Tools and Spare Parts Supplied with Machine .................................................. 26  
13.3 Maintenance Operations - Recommended Inspections and Frequency ............. 26  
13.4 Inspections to be Performed Before and After Every Maintenance Operation ... 26  
13.5 Safety Features (Inspection Efficiency) ............................................................. 26  
13.6 Machine Cleaning ............................................................................................ 27  
13.7 Cutter Blade Cleaning ...................................................................................... 27  
13.8 Lubrication ...................................................................................................... 27  
13.9 Lubrication Products ....................................................................................... 27  
13.10 Drive Belt Replacement .................................................................................. 28  
13.11 Box Drive Belt Tension and Drive Pulley Ring ................................................. 29  
13.12 Maintenance Work Log ................................................................................. 30

## 14. Additional Instructions

14.1 Machine Disposal Information ......................................................................... 31  
14.2 Fire emergency .............................................................................................. 31

## 15. Special Information

15.1 Statement of Conformity ................................................................................. 31  
15.2 Hazardous Substances Emission .................................................................... 31  
15.3 Safety Features List ....................................................................................... 31  
15.4 Copies of Test Reports, Certifications (etc.)Required by User ......................... 31

## 16. Technical Documentation and Information

16.1 Electric Diagrams ............................................................................................ 33  
16.2 Spare Parts / Ordering .................................................................................... 34 - 35

Drawings and Parts Lists ......................................................................................... 37 - End of Manual

TAPING HEAD INFORMATION -
MANUAL 2: AccuGlide™ 2+ STD 2 Inch Taping Head (See MANUAL 2 for Table of Contents)

A80b-NA V 2011 April
LIST OF ABBREVIATIONS, ACRONYMS

3M-Matic - Trademark of 3M St. Paul, MN 55144-1000
AccuGlide - Trademark of 3M St. Paul, MN 55144-1000
Scotch - Trademark of 3M St. Paul, MN 55144-1000
Drw. - drawing
Ex. - for example
Figure - exploded view figure no. (spare parts)
Figure - Illustration
Max. - maximum
Min. - minimum
Nr. - number
N/A - not applicable
OFF - machine not operating
ON - machine operating
PLC - Programmable Logic Control
PP - Polypropylene
PU/PU Foam - Polyurethane Foam
PTFE - Polytetrafluorethelene
PVC - Poly-vinyl chloride
W - Width
H - Height
L - Length
1-INTRODUCTION

1.1 Manufacturing Specifications / Description / Intended Use

The 3M-Matic™ a80b Adjustable Case Sealer with AccuGlide™ 2+ Taping Heads is designed to apply a “C” clip of Scotch® pressure-sensitive film box sealing tape to the bottom center seam of regular slotted containers. The a80b is manually adjustable for a wide range of box sizes. See “Specifications Section—Box Weight and Size Capacities”.

3M-Matic™ a80b Adjustable Case Sealer, Type 10800
1.2 How to Read and Use the Instruction Manual

This instruction manual covers safety aspects, handling and transport, storage, unpacking, preparation, installation, operation, buildup and adjustments, technical and manufacturing specifications, maintenance, troubleshooting, repair work and servicing, electric diagrams, warranty information, disposal (ELV), a definition of symbols, plus a parts list of the 3M-Matic™ a80b Adjustable case sealer. 3M Industrial Adhesives and Tapes Division 3M Center, Bldg. 220-5E-06 St. Paul, MN 55144-1000 (USA) / Edition April 2011 / Copyright 3M 2011 / All rights reserved. The manufacturer reserves the right to change the product at any time without notice. Publication © 3M 2011 44-0009-2069-2.

1.2.1 Importance of the 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 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. 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 and in addition, the relevant documentation will be delivered separately.

1.2.2 Manual Maintenance

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. If the manual has been lost or damaged, ask your after-sale service for a new copy.

1.2.3 Consulting the Manual

The manual is composed of:

- Pages which identify the document and the machine
- Index of the subjects
- Instructions and notes on the machine
- Enclosures, drawings and diagrams
- Spare parts (last section)

All pages and diagrams are numbered. The spare parts lists are identified by the figure identification number. All the notes on safety measures or possible dangers are identified by the symbol:

1.2.4 How to Update the Manual in Case of Modifications to the Machine

Modifications to the machine are subject to manufacturer’s internal procedures. The user receives a complete and up-to-date copy of the manual together with the machine. Afterwards the user may receive pages or parts of the manual which contain amendments or improvements made after its first publication. The user must use them to update this manual.
2.1 Data Identifying Manufacturer and Machine

3M
3M Industrial Adhesives
and Tapes
3M Center Bldg. 220-5E-06
St. Paul, MN 55144-1000 (USA)

For Industrial Use Only
2.2 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™ a80b Adjustable Case Sealer, Type 10800 with the following warranties:
1. The drive belts and the taping head knives, springs and rollers will be free from all defects for ninety (90) days after delivery.
2. All other taping head parts will be free from all defects for three (3) years after delivery.
3. All other parts will be free from all defects for two (2) years after delivery.

If any part is proved to be defective within its warranty period, then the exclusive remedy and 3M’s and seller’s sole obligation shall be, at 3M’s option, to repair or replace the part, provided the defective part is returned immediately to 3M’s factory or an authorized service station designated by 3M. A part will be presumed to have become defective after its warranty period unless the part is received or 3M is notified of the problem no later than five (5) calendar days after the warranty period. If 3M is unable to repair or replace the part within a reasonable time, then 3M at its option, will replace the equipment or refund the purchase price. 3M shall have no obligation to provide or pay for the labor required to install the repaired or replacement part. 3M shall have no obligation to repair or replace (1) those parts failing due to operator misuse, carelessness, or due to any accidental cause other than equipment failure, or (2) parts failing due to non-lubrication, inadequate cleaning, improper operating environment, improper utilities or operator error.

Limitation of Liability: 3M and seller shall not be liable for direct, indirect, special, incidental or consequential damages based upon breach of warranty, breach of contract, negligence, strict liability or any other legal theory.

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

Contents – a80b Adjustable Case Sealer

(1) a80b Adjustable Case Sealer, Type 10800
(1) Side Belt Assembly Width Adjustment Crank/Hardware
(1) Tool/Spare Parts Kit
(1) Instruction and Parts Manual
3.1 General Safety Information

Read all the instructions carefully before starting work with the machine; please pay particular attention to sections marked by the symbol:

The machine is provided with a LATCHING EMERGENCY STOP BUTTON (Figure 3-1); when this button is pressed, it stops the machine at any point in the working cycle. Maintain clear access to power cord while machine is operating. Disconnect plug from power source before machine maintenance (Figure 3-1). Also disconnect air if the machine has a pneumatic system. Keep this manual in a handy place near the machine. This manual contains information that will help you to maintain the machine in a good and safe working condition.

Figure 3-1

3.2 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.
3.3 Table of Warnings

**WARNING**

- To reduce the risk associated with mechanical and electrical 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 service this equipment.

**WARNING**

- To reduce the risk associated with hazardous voltage:
  - Position electrical cord away from foot and vehicle traffic.

**WARNING**

- To reduce the risk associated with pinches, entanglement and hazardous voltage:
  - Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.

**WARNING**

- To reduce the risk associated with pinches and entanglement hazards:
  - Do not leave the machine running while unattended.
  - Turn the machine off when not in use.
  - Never attempt to work on any part of the machine, load tape, or remove jammed boxes from the machine while the machine is running.
- **Important**: Never remove the safety device which covers the blade on the taping unit. Any error may cause serious injuries (Figure 3-5).

- **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.

- **WARNING**: To reduce the risk associated with fire and explosion hazards:
  - Do not operate this equipment in potentially flammable/explosive environments.

- **WARNING**: To reduce the risk associated with muscle strain:
  - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment.
  - Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift.

- **CAUTION**: To reduce the risk associated with pinch hazards:
  - Keep hands clear of the upper head support assembly as boxes are transported through the machine.
  - Keep hands, hair, loose clothing, and jewelry away from box compression rollers.
  - Always feed boxes into the machine by pushing only from the end of the box.
  - Keep hands, hair, loose clothing, and jewelry away from moving belts and taping heads.
3.4 Operator's Qualifications

- Machine Operator
- Mechanical Maintenance Technician
- Electrical Maintenance Technician
- Manufacturer’s Technician/Specialist

3.5 Number of Operators

The operations described below have been analyzed by the manufacturer; the recommended number of operators for each operation provides the best and safest work performance.

**Note:** A smaller or greater number of operators could be unsafe.

3.6 Instructions for a Safe Use of the Machine / Definition of Operator's Qualifications

Only persons who have the skills described in the skill levels section should be allowed to work on the machine. It is the responsibility of the user to appoint the operators having the appropriate skill level and the appropriate training for each category of job.

3.7 Residual Hazards

The case sealer has been designed and incorporates various safety protections which should never be removed or disabled. Notwithstanding the safety precautions conceived by the designers of the machine, it is essential that the operator and service personnel be warned that the residual hazards exist which cannot be eliminated.

3.8 Recommendations and Measures to Prevent Other Hazards which Cannot be Eliminated

- The operator must stay on the working position shown in the Operation Section (Figure 12-1).
- The operator must never touch the running driving belts or put his hands inside any cavity.
- The operator must pay attention to the blades during the tape replacement.

**WARNING**

- To reduce the risk associated with mechanical and electrical 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 service this equipment.

3.9 Personal Safety Measures

Safety glasses, safety gloves, safety helmet, safety shoes, air filters, ear muffs - None is required except when recommended by the user.

3.10 Predictable Actions which are Incorrect and Not Allowed

- Never try to stop/hold the box while being driven by the belts. Only use the EMERGENCY STOP BUTTON.
- Never work without the safety protections.
- Never remove or disable the safety devices.
- Only authorized personnel should be allowed to carry out the adjustments, repairs or maintenance which require operation with reduced safety protections. During such operations, access to the machine must be restricted. When the work is finished, the safety protections must immediately be reactivated.
- The cleaning and maintenance operations must be performed after disconnecting the electric power.
- Do not modify the machine or any part of it. The manufacturer will not be responsible for any modifications.
- Clean the machine using only dry cloths or light detergents. Do not use solvents, petrols, etc.
- Install the machine following the suggested layouts and drawings. The manufacturer will not be responsible for damages caused by improper installation.
3.11 Operator’s Skill Levels Required to Perform the Main Operations on the Machine

The Table shows the minimum operator's skill for each machine operation.

**Important:** The factory manager must ensure that the operator has been properly trained on all the machine functions before starting work.

**Skill 1: Machine Operator**
This operator is trained to use the machine with the machine controls, to feed cases into the machine, make adjustments for different case sizes, to change the tape and to start, stop and restart production.

**Skill 2: Mechanical Maintenance Technician**
This operator is trained to use the machine as the MACHINE OPERATOR and in addition is able to:
- Work with the safety protection disconnected
- Check and adjust mechanical parts
- Carry out machine maintenance operations / repairs / adjustments / repair electrical components
He is not allowed to work on live electrical components

**Skill 2a: Electrical Maintenance Technician**
This operator is trained to use the machine as the MACHINE OPERATOR and in addition is able to:
- Work with the safety protection disconnected
- Check and adjust mechanical parts
- Carry out machine maintenance operations / repairs / adjustments / repair electrical components
He is allowed to work on live electrical panels, connector blocks, control equipment, etc.

**Skill 3: Specialist from the Manufacturer**
Skilled operator sent by the manufacturer or its agent to perform complex repairs or modifications (on agreement with the customer).

---

**WARNING**

- To reduce the risk associated with mechanical and electrical hazards:
  - Allow only properly trained and qualified personnel to operate and service this machine

---

### Operator’s Skill Levels Required to Perform the Main Operations on Machine

<table>
<thead>
<tr>
<th>Operation</th>
<th>Machine Status</th>
<th>Required Operator Skill</th>
<th>Number of Operators</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machine installation and setup</td>
<td>Running with safety protections disabled</td>
<td>2 and 2a</td>
<td>2</td>
</tr>
<tr>
<td>Adjusting box size</td>
<td>Stopped by pressing the EMERGENCY STOP button</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>Tape replacement</td>
<td>Stopped by pressing the EMERGENCY STOP button</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>Blade replacement</td>
<td>Electric power disconnected</td>
<td>2</td>
<td>1</td>
</tr>
<tr>
<td>Drive belt replacement</td>
<td>Electric power disconnected</td>
<td>2</td>
<td>1</td>
</tr>
<tr>
<td>Ordinary maintenance</td>
<td>Electric power disconnected</td>
<td>2</td>
<td>1</td>
</tr>
<tr>
<td>Extraordinary mechanical</td>
<td>Running with safety protections disabled</td>
<td>3</td>
<td>1</td>
</tr>
<tr>
<td>maintenance</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Extraordinary electrical</td>
<td>Running with safety protections disabled</td>
<td>2a</td>
<td>1</td>
</tr>
<tr>
<td>maintenance</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
3.12 Component Locations

Refer to Figure 3-8 below to acquaint yourself with the various components and controls of the case sealer. Also refer to Manual 2 for taping head components.

Figure 3-8—a80b Case Sealer Components (Left Front View)
3.13 Warnings and Replacements Labels

Figure 3-10 - Replacement Labels / 3M Part Numbers

- 78-8137-1331-6
- 78-8137-1330-8
- 78-8137-0886-0
- 78-8060-8481-6
- 78-8070-1329-3
- 78-8070-1339-2
- 78-8070-1330-8
- 78-8070-1331-6
- 78-8070-1332-4

- CAUTION
- Moving belts. Keep hands, hair, loose clothing and jewelry away from this area

- WARNING
- Hazardous Voltage Unplug Power Before Servicing

- 78-8137-1331-6
- 78-8137-1330-8
- 78-8060-8481-6
- 78-8070-1339-2
- 3M Logo

Leg Height Adjustment Label (not shown)
4.1 Power Requirements:

Electrical – 115 VAC, 60 Hz, 3.6 A

These machines are equipped with a 2.4m [8 foot] standard neoprene covered power cord and a grounded plug.

Contact your 3M Representative for power requirements not listed above.

4.2 Operating Rate:

Belt speed is 0.40 m/s [78 ft/min]

![Graph showing boxes per minute vs. box length](image)

Actual production rate is dependent on operator's dexterity.

Boxes must be 18 inches (455mm) apart minimum.

4.3 Operating Conditions

Use in dry, relatively clean environments at 4.4°C to 48.9°C [40°F to 120°F] with clean, dry boxes.

Note: Machine should not be washed or subjected to conditions causing moisture condensation on components.

![WARNING]

- To reduce the risk associated with fire and explosion hazards:
  - Do not operate this equipment in potentially flammable or explosive environments.

4.4 Tape

Scotch® pressure-sensitive film box sealing tapes.

4.5 Tape Width:

Minimum – 36mm [1-1/2 inches]  
Maximum – 48mm [2 inches]
4-SPECIFICATIONS (continued)

4.6 Tape Roll Diameter

Up to 405mm [16 inch] maximum on a 76mm [3 inch] diameter core.
(Accommodates all system roll lengths of Scotch® film tapes.)

4.7 Tape Application Leg Length – Standard

70mm ± 6mm [2.75 inch ±. 25 inch]

Tape Application Leg Length – Optional
50mm ± 6mm [2 inch ±. 25 inch]
(See “Removing Taping Heads Procedure – Changing the Tape Leg Length”.)

4.8 Box Board

Style – regular slotted containers – RSC
125 to 275 P.S.I. bursting test, single wall or double wall B or C flute.
23-44 lbs. per inch of width Edge Crush Test (ECT)

4.9 Box Weight and Size Capacities

A. Box Weight, filled: 5 lbs.– 65 lbs. [2.3kg–29.5kg]. Contents must support flaps.

B. Box Size:

<table>
<thead>
<tr>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>Length: 152mm [6.0 inch]</td>
<td>Unlimited</td>
</tr>
<tr>
<td>Width: 121mm [4.75 inch]*</td>
<td>546mm [21.5 inch]</td>
</tr>
<tr>
<td>Height: 70mm [2.75 inch]**</td>
<td>570mm [22.5 inch]</td>
</tr>
</tbody>
</table>

* Cartons narrower than 250mm [10 inches] in width may require more frequent belt replacement because of limited contact area.

** 90mm [3.5 inches] height with heads adjusted to apply 50mm [2 inches] tape leg lengths.
See “Removing Taping Heads Procedure—Changing the Tape Leg Length”.

Note: The case sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is 0.6 or less, test run several boxes to ensure proper machine performance.

Determine the Box Limitations by Completing this Formula:

\[
\frac{\text{Box Length in Direction of Seal}}{\text{Box Height}} = \text{Should Be Greater Than 0.6}
\]

Any box ratio approaching this limitation should be test run to ensure performance.
4.10 Machine Dimensions

<table>
<thead>
<tr>
<th>W</th>
<th>L</th>
<th>H</th>
<th>A*</th>
<th>B</th>
<th>C**</th>
<th>F</th>
<th>G</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Minimum</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>mm</td>
<td>1005</td>
<td>1005</td>
<td>1335</td>
<td>460</td>
<td>546</td>
<td>--</td>
<td>620</td>
</tr>
<tr>
<td>[Inches]</td>
<td>[39.6]</td>
<td>[39.4]</td>
<td>[52.50]</td>
<td>[18]</td>
<td>[31.5]</td>
<td>--</td>
<td>[24.4]</td>
</tr>
<tr>
<td><strong>Maximum</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>mm</td>
<td>--</td>
<td>--</td>
<td>2184</td>
<td>--</td>
<td>800</td>
<td>--</td>
<td>--</td>
</tr>
</tbody>
</table>

* Infeed/Exit conveyors are optional
** Casters are optional

Weight — 170 kg [375 lbs] crated (approximate)
152 kg [335 lbs] uncrated (approximate)

4.11 Machine Noise Level: Acoustic pressure measured at a distance of 1m. from machine with Scotch PVC adhesive tape in operation; 78dB Acoustic radiation pressure at 1.6m. height with Scotch PVC adhesive tape in operation; 73dB Measurement taken with appropriate instrument: (Type SPYRI-MICROPHON 11).

4.12 Buildup Recommendations:

- Machine must be level.
- Customer supplied infeed and exit conveyors (if used) should provide straight and level box entry and exit.
- Exit conveyors (powered or gravity) must convey sealed boxes away from machine.
5.1 Shipment and Handling of Packed Machine

- The machine is fixed on the pallet with four (4) bolts and can be lifted by using a fork truck.
- The package is suitable to travel by land and by air.
- Optional sea freight package is available.

**Packaging Overall Dimensions (Figure 5-1)**

See Specifications.

During the shipment it is possible to stack a maximum of two (2) machines *(Figure 5-2).*

5.2 Packaging for Overseas Shipment *(Optional - Figure 5-3)*

The machines shipped by sea freight are covered by an aluminum/polyester/polythene bag which contains dehydrating salts.

5.3 Handling and Transportation of Uncrated Machine

The uncrated machine should not be moved except for short distances and indoors ONLY. Without the supporting pallet, the machine is exposed to damage and may cause injuries. To move the machine use belts or ropes, paying attention to place them in the points indicated using care to not interfere with the lower taping head *(Figure 5-4).*

5.4 Storage of the Packed or Unpacked Machine

If the machine is not used for a long period, please take the following precautions:

- Store the machine in a dry and clean place.
- If the machine is unpacked it is necessary to protect it from dust.
- Do not stack anything over the machine.
- It is possible to stack a maximum of two (2) machines (if they are in their original packing).
6.1 Uncrating

Cut straps. Cut out staple positions along the bottom of the shipping box or remove staples with an appropriate tool (Figure 6-1).

After cutting out or removing the staples, lift the shipping box in order to clear the machine. **Note:** Two (2) persons required.

Transport the machine with a fork-lift truck to the operating position. Lift the pallet at the point indicated in Figure 6-2 (weight of machine + pallet = see Section 4).

Removal of Pallet

Using a 10mm combination wrench, remove the fasteners that secure the case sealer legs to pallet at each leg (as shown in Figure 6-3).

Remove the leg height adjustment cap screws and replace with the cap screws from the tool kit. Loosen both cap screws. Remove and replace them one at a time to keep the inner threaded plate in position.

Locate on the machine (or in the spare parts box) the Drive Belt Adjustment handle. Using a 3mm hex wrench, install the handle on the side of the machine pointing outward (as shown in Figure 6-4).

6.2 Disposal of Packaging Materials

The a80b package is composed of:

- Wooden pallet
- Cardboard shipping box
- Wooden supports
- Metal fixing brackets
- PU foam protection
- PP plastic straps
- Dehydrating salts in bag
- Special bag of laminated polyester/aluminium/Polyethylene (sea freight package only)
- Polyethylene protective material

For the disposal of the above materials, please follow the environmental directives or the law in your country.
7.1 Operating Conditions

(see Section 4).

7.2 Space Requirements for Machine Operation and Maintenance Work

Minimum distance from wall (Figure 7-1):

\[ \begin{align*}
A &= 1.0 \text{m. (39.4 inches)} \\
B &= 0.7 \text{m. (27.6 inches)} \\
\text{Minimum height} &= 2.7 \text{m. (106.3 inches)}
\end{align*} \]

7.3 Tool Kit Supplied with the Machine

A tool kit containing some tools are supplied with the machine. These tools should be adequate to set-up the machine, however, other tools supplied by the customer will be required for machine maintenance.

7.4 Machine Positioning / Bed Height

1 - Lift the machine with belts or ropes paying attention to place the belts in the points (Figure 7-2).

To set the machine bed height, do the following:

2 - Adjust machine bed height. The case sealer is equipped with four adjustable legs. Using a 6mm hex wrench, loosen the socket head screws that hold the inner leg assembly to the machine as shown (Figure 7-3). Also refer to the "Specifications" section.

3 - Lock/tighten screws.

4 - Repeat the operation adjusting all legs equally.

(It is not necessary to fix or anchor the machine to the floor.)
7.5 Removal of Plastic Ties

Cut any existing plastic ties (where applicable - Figure 7-4).

7.6 Assembly Completion

1. Cut the plastic ties holding the lower taping head in position. Hold taping head buffing roller while cutting the plastic tie. Allow buffing/applying arms to extend slowly (Figure 7-5).
2. Verify that the taping heads moves freely by pushing the buffing roller into the taping head.
3. Ensure that the tape drum bracket assembly (located on the taping head) is mounted vertically (as shown in Figure 7-6).

Note: The tape drum bracket assembly may be pivoted to provide tape roll clearance if necessary.

7.7 Completion of Taping Heads

See Manual 2 for Complete Instructions:

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

---

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.
7.8 Preliminary Electric Inspection

Before connecting the machine to the mains please carry out the following operations:

7.8.1 Make sure that the socket is provided with an earth protection circuit and that both the mains voltage and the frequency match the specifications on the name plate.

7.8.2 Check that the connection of the machine to the mains meets the safety regulations in your country.

7.9 Machine Connection to the Mains

- Push the LATCHING EMERGENCY STOP BUTTON.
- The main switch is normally turned OFF.

Connect the power cord supplied with the machine to a wall socket using a plug which complies with the safety regulations of your country.

7.10 Inspection of Phases (For Three-Main Phases Only)

N/A for this machine.

7.8.3 The machine is fitted with a main switch. The user will be responsible for testing the short-circuit current in its facility and should check that the short-circuit amperage setting of the machine is compatible with all the components of the mains system.
8.1 Description of the Working Cycle

After having closed the top flaps of the carton (if applicable), the operator then pushes the box between the two side belts to drive it over the taping head which automatically seals the bottom seam. The carton is then expelled on the exit conveyor.

8.2 Definition of Running Mode

The case sealer a80b has only one (automatic) operating mode with:

- The EMERGENCY STOP BUTTON unlocked (Figure 8-1)
- The main rotary switch “ON” (Figure 8-2)

8.3.1 Normal Stop Procedure

When the rotary main switch is turned OFF, the machine stops immediately at any point of the working cycle. The same thing happens in case of electrical failure or when the machine is disconnected from the mains.

8.3.2 Emergency Stop

The latching EMERGENCY STOP BUTTON is located on the operator side of the machine.
9.1 Box Width Adjusting Knobs

9.2 On / Off Power Switch

9.3 Latching Emergency Stop Button
10.1 Blade Guards

The taping unit has a blade guard (See Manual 2: AccuGlide™ 2+ STD 2 Inch Taping Heads).

**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.

10.2 Emergency Stop Button

The box drive belts are turned on and off with the electrical switch on the side of the machine frame.

The machine electrical supply can be turned off by pressing the latching emergency stop switch. To restart machine, rotate the emergency stop switch clockwise to release the switch latch. Restart machine by pushing the Start button (Figure 10-1).

**WARNING**

- To reduce the risk associated with pinches, entanglement and hazardous voltage:
  - Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.

10.3 Electric System / Circuit Breaker

The electric system is protected by a ground wire whose continuity has been tested during the final inspection. The system is also subject to insulation and dielectric strength tests.

**Circuit Breaker**

The case sealer is equipped with a circuit breaker which trips if the motors are overloaded. Located inside the electrical enclosure on the side of the machine frame just below the machine bed, the circuit breaker has been pre-set and requires no further maintenance.

**WARNING**

- To reduce the risk associated with mechanical and electrical hazards:
  - Allow only properly trained and qualified personnel to operate and service this equipment.

If circuit is overloaded and circuit breaker trips, unplug machine from electrical power:

1. Determine cause of overload and correct.
2. Plug in machine.
3. Press machine "On" button to resume case sealing.

**Important:** The use of an extension cord is not recommended. However, if one is needed for temporary use, it must:

- Have a wire size of 1.5mm diameter [AWG 16]
- Have a maximum length of 30.5m [100 ft]
- Be properly grounded.
11 - SET UP AND ADJUSTMENTS

11.1 Box Width Adjustment

Place the box on the infeed end of frame bed and visually align. Then, using the hand crank on the side of the machine, move the side belts inward until they come in contact with the side of the box to be sealed (Figure 11-1).

11.2 Changing the Tape Leg Length

Taping heads are preset to apply 70mm [2.75 inches] long tape legs. To change tape leg length to 50mm [2.0 inches], refer to Instructions below and also to Manual 2, "Removing Taping Heads Procedure - Changing the Tape Leg Length".

1. Lift the lower taping head straight up to remove it from the case sealer bed (Figure 11-2).
3. Replace taping heads in the reverse order of disassembly.

11.3 Run Boxes to Inspect Adjustment (Figure 11-3)

Important: Before starting the machine, verify that no tools or other objects are on the conveyor bed.

Turn electrical switch to On to start drive belts. Move box forward until it is taken away by the side drive belts. Always push at the end of the box.

\[ \text{CAUTION} \]

- To reduce the risk associated with pinches hazards:
  - Keep hands clear of the upper head support assembly as boxes are transported through the machine.
  - Keep hands, hair, loose clothing, and jewelry away from box compression rollers.
  - Always feed boxes into the machine by pushing only from the end of the box.
  - Keep hands, hair, loose clothing, and jewelry away from moving belts and taping heads.

Important – If drive belts are allowed to slip on box, excessive belt wear will occur.

Refer to Figure 11-4 and adjust belt tension as follows (for belt replacement and tension specifications - refer to Section 13 / Maintenance and Repairs):

1. Using a 17mm open-end wrench, loosen, but do not remove, the M10 lock nut.
2. Reset the tension on the drive belts as needed. Adjust the M8 tension screws in (clockwise) to increase tension or out (counterclockwise) to decrease tension. Tighten lock nut to secure tension setting.
12.1 Operator's Correct Working Position and Operational Flow (Figure 12-1).

Once the box has been filled, close its top flaps and push it between the side drive belts. Always keep hands in position (as shown in Figure 12-2).

The box will be automatically sealed with adhesive tape on the bottom box seam.

12.2 Starting the Machine

Important: Before starting the machine, verify that no tools or other objects are on the conveyor bed.

Turn the main rotary switch ON after the EMERGENCY BUTTON is released (Figure 12-3).

12.3 Starting Production

After having adjusted the machine according to the box dimensions (height-width), let the machine run without cartons and check its safety devices. Then start the working cycle.

12.4 Tape Replacement and Threading

Skill 1 - Operator

See MANUAL 2: AccuGlide™ 2+
STD 2 inch or 3 Inch Taping Heads.
Press the LATCHING EMERGENCY STOP BUTTON.

12.5 Box Size Adjustment

Repeat all the operations shown in Section 11 - Buildup and Adjustments.

12.6 Cleaning

Before carrying out any cleaning or maintenance operation stop the machine by turning the main rotary switch to OFF and disconnect the electric power (Figure 12-3).

12.7 Table of Operation Adjustments - Operator Qualifications

<table>
<thead>
<tr>
<th>Skill</th>
<th>Description</th>
<th>Qualification</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Tape loading and threading</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>Tape web alignment</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>Adjustment of one way tension roller</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>Adjustment to box size (H and W)</td>
<td>1</td>
</tr>
<tr>
<td>5</td>
<td>Adjustment of tape applying spring</td>
<td>1</td>
</tr>
<tr>
<td>6</td>
<td>Conveyor bed height adjustment</td>
<td>1</td>
</tr>
<tr>
<td>7</td>
<td>Special Adjustment-Changing tape leg length</td>
<td>2</td>
</tr>
<tr>
<td>8</td>
<td>Special Adjustment-Column re-positioning</td>
<td>2</td>
</tr>
</tbody>
</table>

12.8 Safety Devices Inspection

1. Taping units blade guard
2. Latching emergency stop button
3. STOP (OFF) turn rotary switch on main power.

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.
## 12.9 Troubleshooting Guide

<table>
<thead>
<tr>
<th>PROBLEM</th>
<th>CAUSE</th>
<th>CORRECTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>Drive belts do not convey boxes</td>
<td>Narrow boxes&lt;br&gt;Worn drive belts or friction rings&lt;br&gt;Taping head applying spring holder missing&lt;br&gt;Taping head applying spring set too high</td>
<td>Check machine specifications. Boxes are narrower than recommended causing slippage and premature belt wear&lt;br&gt;Replace drive belts or friction rings&lt;br&gt;Replace spring holder&lt;br&gt;Reduce spring pressure</td>
</tr>
<tr>
<td>Drive belts do not turn</td>
<td>Worn or missing friction rings&lt;br&gt;Drive belt tension too low&lt;br&gt;Electrical disconnect&lt;br&gt;Motor not turning&lt;br&gt;Circuit breaker&lt;br&gt;Motor capacitor&lt;br&gt;Motor fan cover dented</td>
<td>Replace friction rings&lt;br&gt;Adjust belt tension&lt;br&gt;Check power and electrical plug&lt;br&gt;Evaluate and correct</td>
</tr>
<tr>
<td>Drive belts break</td>
<td>Worn belt&lt;br&gt;Improper setup causing boxes to jam</td>
<td>Replace belt</td>
</tr>
</tbody>
</table>
13-MAINTENANCE AND REPAIRS

13.1 Safety Measures (see section 3)

Carrying out maintenance and repairs may imply the necessity to work in dangerous situations. (See Section 3)

13.2 Tools and Spare Parts Supplied with the Machine

See Spare Parts Order Section.

13.3 Recommended Frequency of Inspection and Maintenance Operations

<table>
<thead>
<tr>
<th>Operation</th>
<th>Frequency</th>
<th>Qualification</th>
<th>Sections</th>
</tr>
</thead>
<tbody>
<tr>
<td>Inspection safety features</td>
<td>daily</td>
<td>1</td>
<td>13.4</td>
</tr>
<tr>
<td>Cleaning of machine</td>
<td>weekly</td>
<td>1</td>
<td>13.6</td>
</tr>
<tr>
<td>Cleaning of cutter blade</td>
<td>weekly</td>
<td>2</td>
<td>13.7</td>
</tr>
<tr>
<td>Oiling of felt pad</td>
<td>weekly</td>
<td>2</td>
<td>13.7</td>
</tr>
<tr>
<td>Lubrication</td>
<td>monthly</td>
<td>2</td>
<td>13.8-13.9</td>
</tr>
<tr>
<td>Blade replacement</td>
<td>when worn</td>
<td>2</td>
<td>See Manual 2</td>
</tr>
<tr>
<td>Drive belt replacement</td>
<td>when worn</td>
<td>2</td>
<td>13.10</td>
</tr>
</tbody>
</table>

13.4 Inspections to be Performed Before and After Every Maintenance Operation

Before every maintenance operation turn the rotary switch to OFF on the main power and disconnect the plug from the control panel. During the maintenance operation only the operator responsible for this duty must work on the machine. At the end of every maintenance operation check the safety devices.

13.5 Check Efficiency of Safety Features

1. Blade guard assembly upper taping head
2. Blade guard assembly lower taping head
3. Emergency stop button with mechanical lock (interrupt supply of electrical power)
4. Turn rotary switch STOP/OFF on main power
5. Drive Belt safety guards

WARNING

- To reduce the risk associated with mechanical and electrical 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 service this equipment.
- To reduce the risk associated with pinches, entanglement and hazardous voltage:
  - Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.
13.6 Cleaning of Machine

Qualification / Skill 1
A weekly cleaning with dry rags or diluted detergents is necessary. Cardboard boxes produce a significant quantity of dust and paper chips when processed or handled in case sealing equipment. If this dust is allowed to build up on machine components, it can cause component wear and over-heating of drive motors. The dust buildup is best removed from the machine with a vacuum cleaner. Depending on the number of cartons processed, this cleaning should be done weekly. Excessive buildup that cannot be removed by vacuuming should be removed with a damp cloth.

13.7 Cleaning of Cutter Blade

Qualification / Skill 2
- Should tape adhesive buildup occur, carefully wipe clean with oily cloth or brush. Oil prevents the buildup of tape adhesive (Figure 13-1).
- Worn or damaged cutter blades must be replaced promptly in order to guarantee a perfect cut of the tape. Lubricate the felt pad on the blade guard without saturating it.

13.8 Lubrication

Most of the machine bearings, including the drive motor, are permanently lubricated and sealed and do not require additional lubricant.

Note: Wipe off excess silicone. It will attract dust which can cause premature equipment wear and jamming. Take care that silicone is not left on the surface of rollers around which tape is threaded, as it can contaminate the tape’s adhesive.

13.9 Lubrication Products

• Synthetic Silicone Spray may be used on Adjustment Handle (Figure 13-2).
13.10 Drive Belt Replacement

Drive Belts

1. Using a 17mm hex wrench, loosen (counter-clockwise) but do not remove the bolt as shown in Figure 13-3.

2. Using a 6mm allen wrench, loosen (counter-clockwise) tension screw until all belt tension is removed (as shown in Figure 13-4).

3. Pull out belt splicing pin.

**Tip:** The old belt may be used to install the new belt. Attach the new belt to the old belt and pull the new belt into the position while simultaneously removing the old belt.

4. If using the old belt, continue with the next step. If the old belt cannot be used to install a new belt, remove the Belt Drive Cover with a Phillips Screwdriver (Figure 13-5).

5. Place new belt over pulleys with laced splice at top.

6. Insert splicing pin.

**Important:** Pin must not extend beyond edge of belt.

7. Reverse procedure to set belt tension (as explained in "Adjustments-Box Drive Belt Tension") and to secure belt in position.

**Important:** Be sure there is a 4mm gap at the exit end of the Drive Belt which allows the belt to move freely.
13.11 Box Drive Belt Tension and Drive Pulley Rings

Before installing a new belt, check the orange plastic drive pulley rings for wear. If torn, broken, or worn smooth, replace the rings (Figure 13-6).

---

**WARNING**

- To reduce the risk associated with mechanical and electrical hazards:
  - Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.

**Box Drive Belt Tension**

The two (2) continuously moving drive belts convey boxes through the tape applying mechanism. The box drive belts are powered by an electric gear motor.

Tension adjustment of these belts may be required during normal operation (for Belt Tension Adjustment - refer to Section 11 / Buildup and Adjustments). Belt tension must be adequate to positively move the box through the machine and the belts should run fully on the surface of the pulleys at each end of the frame. The idler pulleys on the infeed end are adjusted in or out to provide proper belt tension. Each belt is adjusted separately.

Belt tension is obtained by tightening the adjustment screw so that a moderate pulling force of 3.5kg [7 lbs.] applied at the mid span, as shown in Figure 13-7, will deflect the belt 25mm [1 inch]. This will assure positive contact between the belt and the drive pulley on the discharge end of the drive assembly.

---

![Figure 13-6](image)

---

![Figure 13-7](image)
13.12 List of the Maintenance Operations

<table>
<thead>
<tr>
<th>Date:</th>
<th>Description of Operation</th>
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<tbody>
<tr>
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</table>
14-ADDITIONAL INSTRUCTIONS

14.1 Information for Disposal of Machine (ELV)

The machine is composed of the following materials:

- Steel structure
- Nylon rollers
- Drive belts in PVC
- Nylon pulleys

For machine disposal, follow the regulations published in each country.

14.2 Emergency Procedures

In case of danger/fire:
Disconnect plug of power cable from power supply.  
(Figure 14-1)

IN CASE OF FIRE

Use a fire extinguisher containing CO₂ (Figure 14-2).

Figure 14-1

Figure 14-2

15-SPECIAL INFO.

15.1 Statement of Conformity

See Section 1.1.

15.2 Emission of Hazardous Substances

Nothing to report

15.3 List of Safety Features

List of components/assemblies with safety functions

- Emergency Stop Button with Mechanical Lock
- Thermal cut-out relay
- Fixed guards upper drive belts
- Blade guard assemblies on both taping heads

- Important: Install earth wire protection on electrical installation.

All safety features/components must be explained and highlighted to all operators and to the person responsible for spare parts in order to ensure that these components are always on hand or ordered as a priority procedure.

ONLY USE ORIGINAL REPLACEMENT PARTS

15.4 Copies of Test Reports, Certifications (etc.) Required by User

N/A
16.1 Electric Diagram
16.2 Spare Parts Order

Replacement Parts Ordering Information and Service

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

Order parts by quoting the following information:
(Refer to the Identification Plate on the Machine)

- MACHINE MODEL
- SERIAL NUMBER
- FIGURE NO.
- POSITION
- 3M PART NO. (11 DIGITS)
- DESCRIPTION
- QUANTITY

Refer to Manual 2 for recommended taping head spare parts.

Important:
The machine is constantly revised and improved by our designers. The spare parts catalogue is also periodically updated. It is very important that all the orders of spare parts make reference to the serial number of the machine (located on the identification plate on the machine).

The manufacturer reserves the right to modify the machine at any time without notice.

It is suggested that the following spare parts be ordered and kept on hand.

<table>
<thead>
<tr>
<th>Qty.</th>
<th>3M-Part Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>2</td>
<td>78-8076-5452-6</td>
<td>Belt, Drive with Pin</td>
</tr>
</tbody>
</table>

Tool Kit

A tool kit, part number 78-8060-8476-6, is available as a stock item. The kit contains the necessary open-end and hex socket wrenches for use with the metric fasteners on the case sealer. The threading tool, part number 78-8076-4726-4, contained in above kit is also available as a replacement stock item.

Label Kit

In the event that any labels are damaged or destroyed, they must be replaced to ensure operator safety. See Section 3-Safety.
a80b Adjustable Case Sealer, Type 10800
Frame Assemblies

To Order Parts:

1. Refer to first illustration, Frame Assemblies, for the Figure Number that identifies a specific portion of the machine.

2. Refer to the appropriate Figure or Figures to determine the parts required and the parts reference number.

3. The Parts List that follows each illustration, includes the Reference Number, Part Number and Part Description for the parts on 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, if desired.

4. Order parts by Part Number, Part Description and Quantity required. Also include the model/machine name, machine type, and serial number that are located on the identification plate.

5. Refer to the first page of this instruction manual “Replacement Parts and Service Information” for replacement parts ordering information.

Important – Not all the parts listed are normally stocked items. Some parts or assemblies shown are available only on special order. Contact 3M/Tape Dispenser Parts to confirm item availability.

Options and Accessories

For additional information on the options and accessories listed below, contact your 3M Representative.

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Option/Accessory</th>
</tr>
</thead>
<tbody>
<tr>
<td>70-0064-2997-4</td>
<td>Box Hold Down Attachment, Model 10800</td>
</tr>
<tr>
<td>70-0064-2998-2</td>
<td>Caster Kit Attachment</td>
</tr>
<tr>
<td>70-0064-2999-0</td>
<td>Conveyor Extension Attachment</td>
</tr>
<tr>
<td>70-0064-0354-0</td>
<td>AccuGlide™ 2+ STD 2 Inch Lower Taping Head, Type 10500</td>
</tr>
<tr>
<td>78-8060-8476-6</td>
<td>Tool and Parts Kit</td>
</tr>
</tbody>
</table>
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### Figure 10865

<table>
<thead>
<tr>
<th>Ref. No.</th>
<th>3M Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>10865-1</td>
<td>78-8054-8567-3</td>
<td>Screw Soc.Hd.SpecialL</td>
</tr>
<tr>
<td>10865-2</td>
<td>78-8054-8588-1</td>
<td>Washer - 8,5/40X6</td>
</tr>
<tr>
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**Detail - Parts 84 & 85**

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## Figure 10915

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<td>Plate With Insert - Assy.</td>
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<td>78-8137-0856-3</td>
<td>Spacer</td>
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<td>Clamp</td>
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Figure 10916
Figure 10916

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<th>Ref. No.</th>
<th>3M Part No.</th>
<th>Description</th>
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<tr>
<td>10916-1</td>
<td>78-8129-6469-6</td>
<td>Nut - Special, M20</td>
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<td>78-8137-0607-0</td>
<td>Grip - Cord, Skintop St 20</td>
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<td>78-8137-0606-2</td>
<td>Lockable - Twist - Knob -, Allen Bradley</td>
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<td>10916-4</td>
<td>78-8137-0602-1</td>
<td>Cover</td>
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<td>78-8094-6145-8</td>
<td>Screw - Phillips M5</td>
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<td>Switch - Terminal - Allen Bradley</td>
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<td>78-8137-0604-7</td>
<td>Coil - Under Voltage 120V 60 Hz</td>
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<td>78-8094-6384-3</td>
<td>Terminal</td>
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<td>78-8137-0896-9</td>
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<td>Power Cord.</td>
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<td>78-8060-8053-3</td>
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<td>26-1000-0010-3</td>
<td>Washer - Flat M6</td>
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