

## Instructions and Parts List

# 3M-Matic™ 8000a-8000a3

Type 11600

# Adjustable Case Sealer with AccuGlide™ 3 Taping Heads

Serial #: \_\_\_\_\_  
*For reference, record machine serial number here.*

## Important Safety Information

BEFORE INSTALLING OR OPERATING THIS EQUIPMENT  
Read, understand and follow all safety and operating instructions.

## Spare Parts

It is recommended you immediately order the spare parts listed in the “Spare Parts/Service Information” section. These parts are expected to wear through normal use, and should be kept on hand to minimize production delays.



# Replacement Parts and Service Information

## To Our Customers:

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

Included with each machine is an Instructions and Parts List Manual.

## Technical Assistance / Replacement Parts and Additional Manuals:

For technical assistance, contact our help line at 1-800-328-1390.

Provide the customer support coordinator with the model/machine name, machine type, and serial number that are located on the identification plate (For example: Model 8000a - Type 11600 - Serial Number 13282).

## To order replacement parts, contact us:

CSPD division of Combi Packaging Systems LLC.

5365 East Center Dr. N.E.

Canton, OH 44721

1-800-344-9883

e-mail: CSPD-CSR@combi.com

www.combi.com

## Identification Plate

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



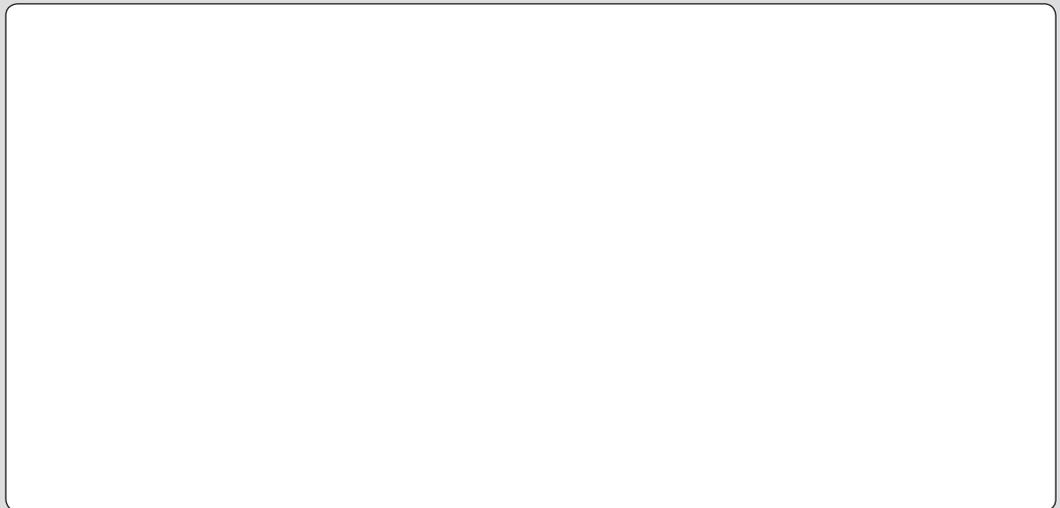
# Replacement Parts and Service Information

## To Our Customers:

This is the 3M-Matic™/AccuGlide™/Scotch® equipment you ordered. It has been set up and tested in the factory with Scotch® tapes. If any problems occur when operating this equipment and you desire a service call or phone consultation, call, write, or fax the appropriate number listed below.

Included with each machine is an Instructions and Parts List Manual.

**Service, replacement parts, and additional manuals available direct from:**



Order parts by part number, part description, and quantity required. Also, when ordering parts or additional manuals, include model/machine name, machine type, and serial number that are located on the identification plate.



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## Taping Head Information

Manual 2: AccuGlide™ 3 Taping Heads — 2 Inch or 3 Inch  
(See Manual 2 or 3 for Table of Contents)

# Abbreviations and Acronyms

## List of Abbreviations/Acronyms

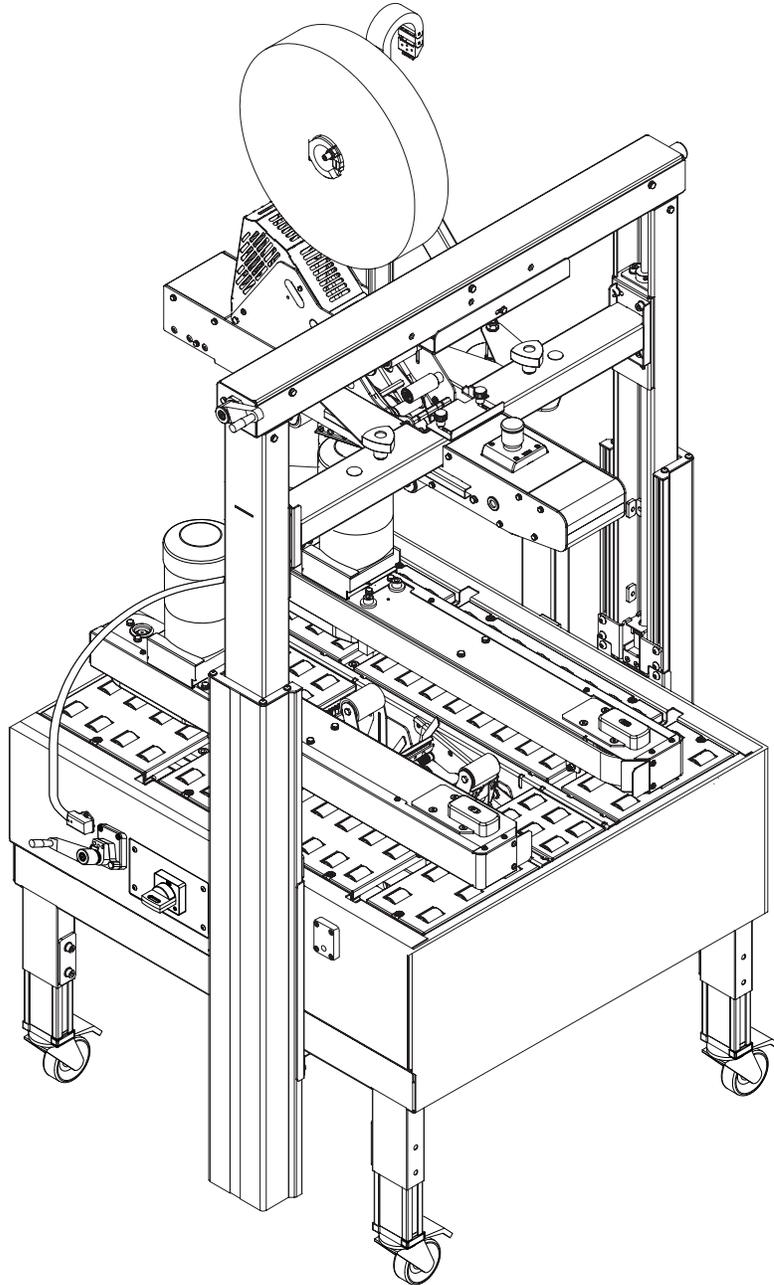
3M-Matic . . . . .	Trademark of 3M St. Paul, MN 55144-1000
AccuGlide . . . . .	Trademark of 3M St. Paul, MN 55144-1000
Scotch . . . . .	Trademark of 3M St. Paul, MN 55144-1000
Drw. . . . .	Drawing
Ex. . . . .	For Example
Fig. . . . .	Exploded View Figure no. (spare parts)
Figure. . . . .	Illustration
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™ 8000a-8000a3 Adjustable Case Sealer with AccuGlide™ 3 Taping Heads** is designed to apply a “C” clip of Scotch® pressure-sensitive film box sealing tape to the top and bottom center seam of regular slotted containers. The **8000a-8000a3** is manually adjustable to a wide range of box sizes (see “Specifications Section – Box Weight and Size Capacities”).

The 3M-Matic™ case sealing machines have been designed and manufactured in compliance with the legal requirements at the date of inception.



**3M-Matic™ 8000a-8000a3 Adjustable Case Sealer, Type 11600**

# 1. Introduction *(continued)*

## 1.2 How to Read and Use the Instruction Manual

This instruction manual covers safety aspects, handling and transport, storage, unpacking, preparation, installation, operation, set-up and adjustments, technical and manufacturing specifications, maintenance, troubleshooting, repair work and servicing, electric diagrams, warranty information, disposal (ELV), a definition of symbols, plus a parts list of the 3M-Matic™ 8000a-8000a3 Adjustable Case Sealer.

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

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The manufacturer reserves the right to change the product at any time without notice.

Publication © 3M 2016 44-0009-2134-4.

### 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. In case 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:



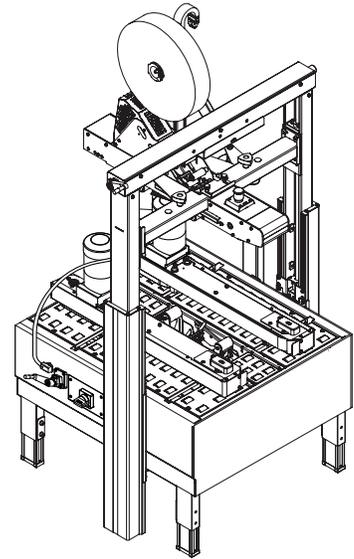
### 1.2.4 How to Update the Manual in Case of Modifications to the Machine

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. General Information

### 2.1 Data Identifying Manufacturer and Machine

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



<b>3M</b>	3M Company St. Paul, MN 55144 USA	Part Number <input type="text"/>	<b>3M-Matic™</b>		
Model <input type="text"/>		Serial Number <input type="text"/>	For Commercial Use Only		
Type <input type="text"/>			Year <input type="text"/>	Ampere <input type="text"/>	Watt <input type="text"/>
			Volt <input type="text"/>	Hertz <input type="text"/>	Phase <input type="text"/>

### 2.2 Data for Technical Assistance and Service

Agent/Distributor or Local After Sale Service:
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## 2. General Information *(continued)*

### 2.3 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™ 8000a-8000a3 Adjustable Case Sealer, Type 11600** 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: 8000a-8000a3 Adjustable Case Sealer**

- (1) 8000a-8000a3 Adjustable Case Sealer, Type 11600
- (1) Tool and Spare Parts Kit
- (1) Instruction and Parts Manual

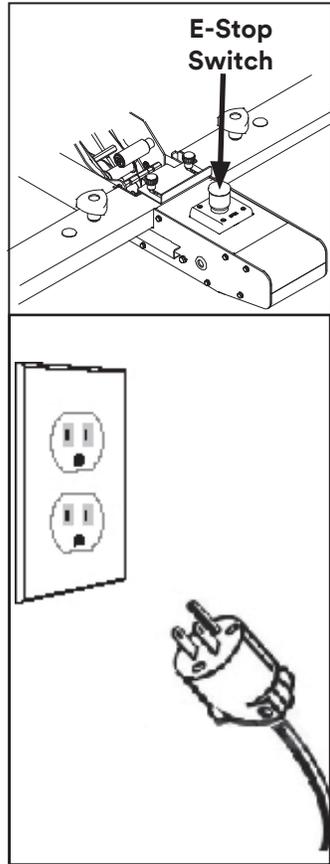
# 3. Safety

## 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:



Figure 3-1



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.

## 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. Safety (continued)

### 3.3 Table of Warnings

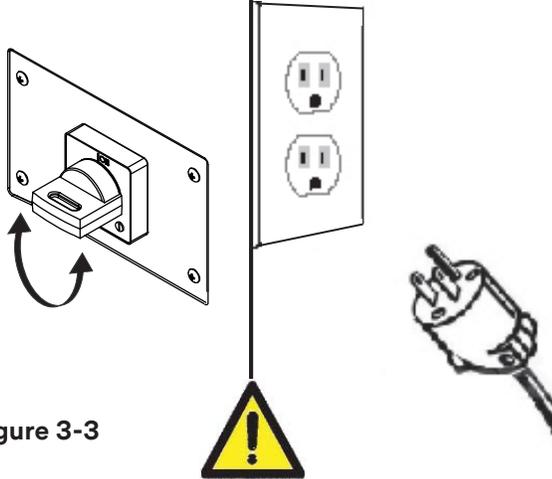
 <b>WARNING</b>
<ul style="list-style-type: none"><li>• To reduce the risk associated with mechanical and electrical hazards:<ul style="list-style-type: none"><li>- Read, understand, and follow all safety and operating instructions before operating or servicing the case sealer.</li><li>- Allow only properly trained and qualified personnel to operate and service this equipment.</li></ul></li></ul>

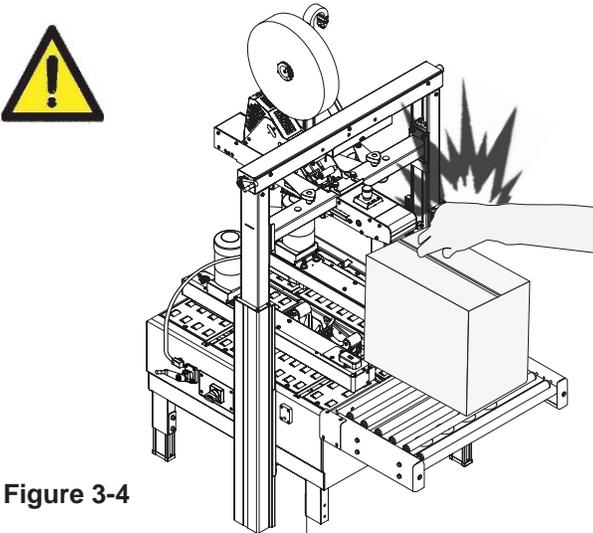
 <b>WARNING</b>
<ul style="list-style-type: none"><li>• To reduce the risk associated with hazardous voltage:<ul style="list-style-type: none"><li>- Position electrical cord away from foot and vehicle traffic.</li></ul></li></ul>

 <b>WARNING</b>
<ul style="list-style-type: none"><li>• To reduce the risk associated with pinches, entanglement and hazardous voltage:<ul style="list-style-type: none"><li>- Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.</li></ul></li></ul>

 <b>WARNING</b>
<ul style="list-style-type: none"><li>• To reduce the risk associated with pinches and entanglement hazards:<ul style="list-style-type: none"><li>- Do not leave the machine running while unattended.</li><li>- Turn the machine off when not in use.</li><li>- Never attempt to work on any part of the machine, load tape, or remove jammed boxes from the machine while the machine is running.</li></ul></li></ul>

	<b>SAFETY INSTRUCTIONS</b> <ol style="list-style-type: none"><li>1. Shut off machine before adjusting</li><li>2. Unplug electric power before servicing</li><li>3. Do not leave machine running unattended</li><li>4. Refer to instruction manual for complete setup, operating, and servicing information</li></ol>
<b>Figure 3-2</b>	


<b>Figure 3-3</b>


<b>Figure 3-4</b>

**IMPORTANT!** Cavity in the conveyor bed. Never put your hands inside any part of the machine while it is working. Serious injury may occur (**Figure 3-4**).

### 3. Safety (continued)

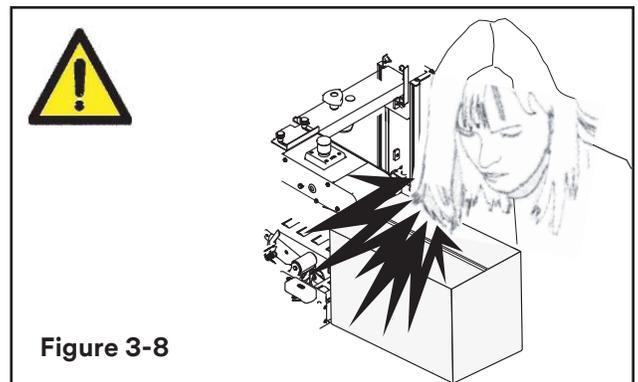
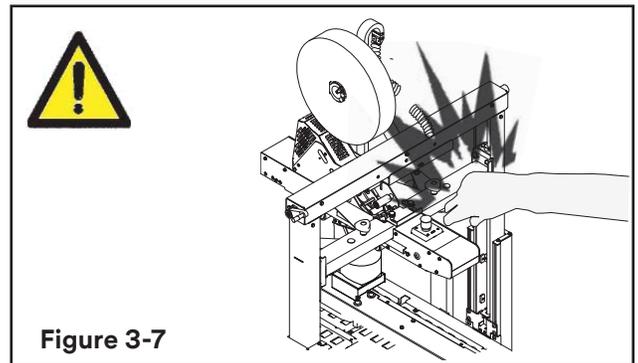
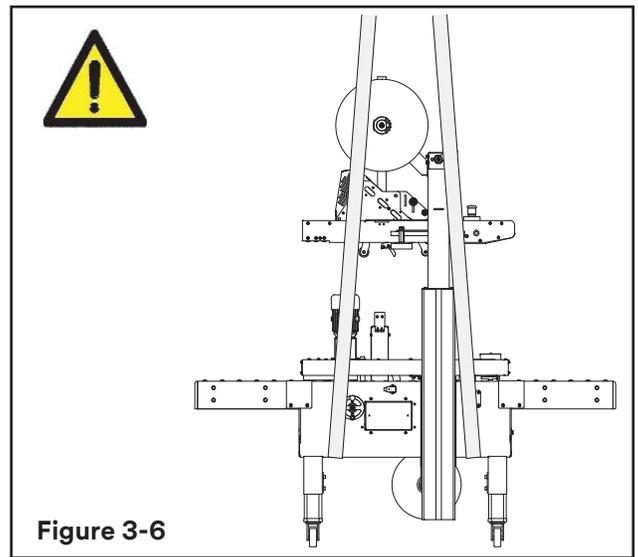
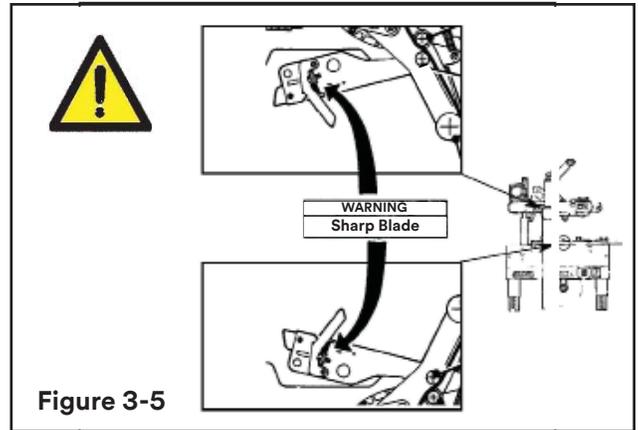
 <b>WARNING</b>
<ul style="list-style-type: none"><li>• To reduce the risk associated with sharp blade hazards:<ul style="list-style-type: none"><li>- Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp.</li></ul></li></ul>

**Important!** Tape cutting blade. Never remove safety device which covers blade on top and bottom taping units. Blades are extremely sharp. Any error may cause serious injuries (**Figure 3-5**).

 <b>WARNING</b>
<ul style="list-style-type: none"><li>• To reduce the risk associated with fire and explosion hazards:<ul style="list-style-type: none"><li>- Do not operate this equipment in potentially flammable / explosive environments.</li></ul></li></ul>

 <b>WARNING</b>
<ul style="list-style-type: none"><li>• To reduce the risk associated with muscle strain:<ul style="list-style-type: none"><li>- Use appropriate rigging and material handling equipment when lifting or repositioning this equipment.</li><li>- Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift.</li></ul></li></ul>

 <b>CAUTION</b>
<ul style="list-style-type: none"><li>• To reduce the risk associated with pinch hazards:<ul style="list-style-type: none"><li>- Keep hands clear of the upper head support assembly as boxes are transported through the machine.</li><li>- Keep hands, hair, loose clothing, and jewelry away from box compression rollers.</li><li>- Always feed boxes into the machine by pushing only from the end of box.</li></ul></li></ul>



## 3. Safety (continued)

### 3.4 Operator's Qualifications

- Machine Operator
- Mechanical Maintenance Technician
- Electrical Maintenance Technician
- Manufacturer's Technician/Specialist  
(See Section 3)

### 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 **8000a-8000a3** incorporates various safety protections which should never be removed or disabled. It is essential that the operator and service personnel be warned that 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. He 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.

### 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.
- 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.
- 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.



## 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. Safety (continued)

### 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

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).

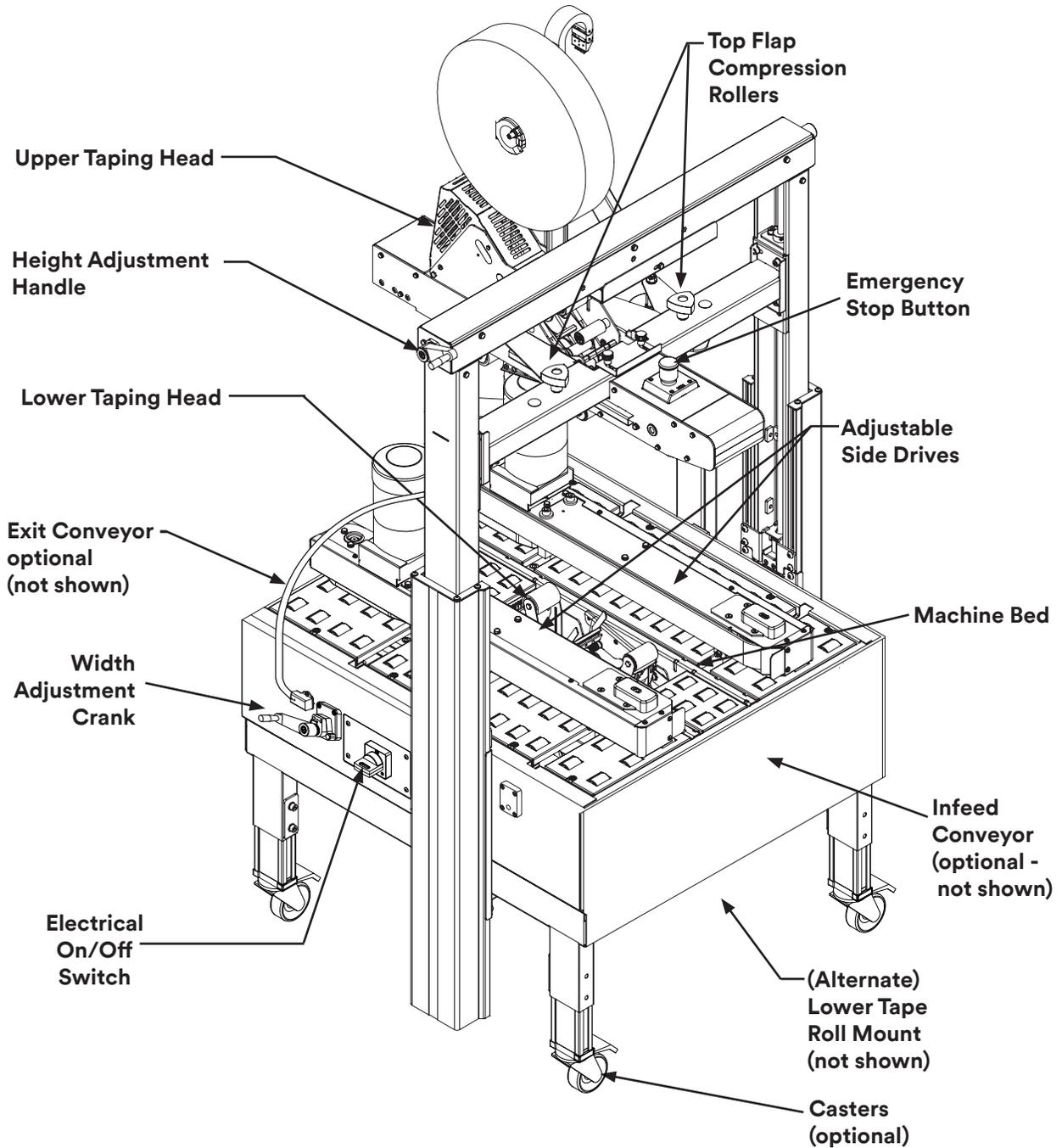
#### Operator's Skill Levels Required to Perform the Main Operations on Machine

Operation	Machine Status	Required Operator Skill	Number of Operators
Machine installation and setup	Running with safety protections disabled	2 and 2a	2
Extraordinary mechanical maintenance		3	1
Extraordinary electrical maintenance		2a	1
Adjusting box size	Stopped by pressing the EMERGENCY STOP button	1	1
Tape replacement		1	1
Blade replacement	Electric power disconnected	2	1
Drive belt replacement		2	1
Ordinary maintenance		2	1

### 3. Safety (continued)

#### 3.12 Component Locations

Refer to **Figure 3-9** below to acquaint yourself with the various components and controls of the case sealer. Also refer to Manual 2 for taping head components.



**Figure 3-9 8000a-8000a3 Case Sealer Components (Left Front View)**

### 3. Safety (continued)

#### 3.13 Table of Warnings and Replacements Labels (continued)

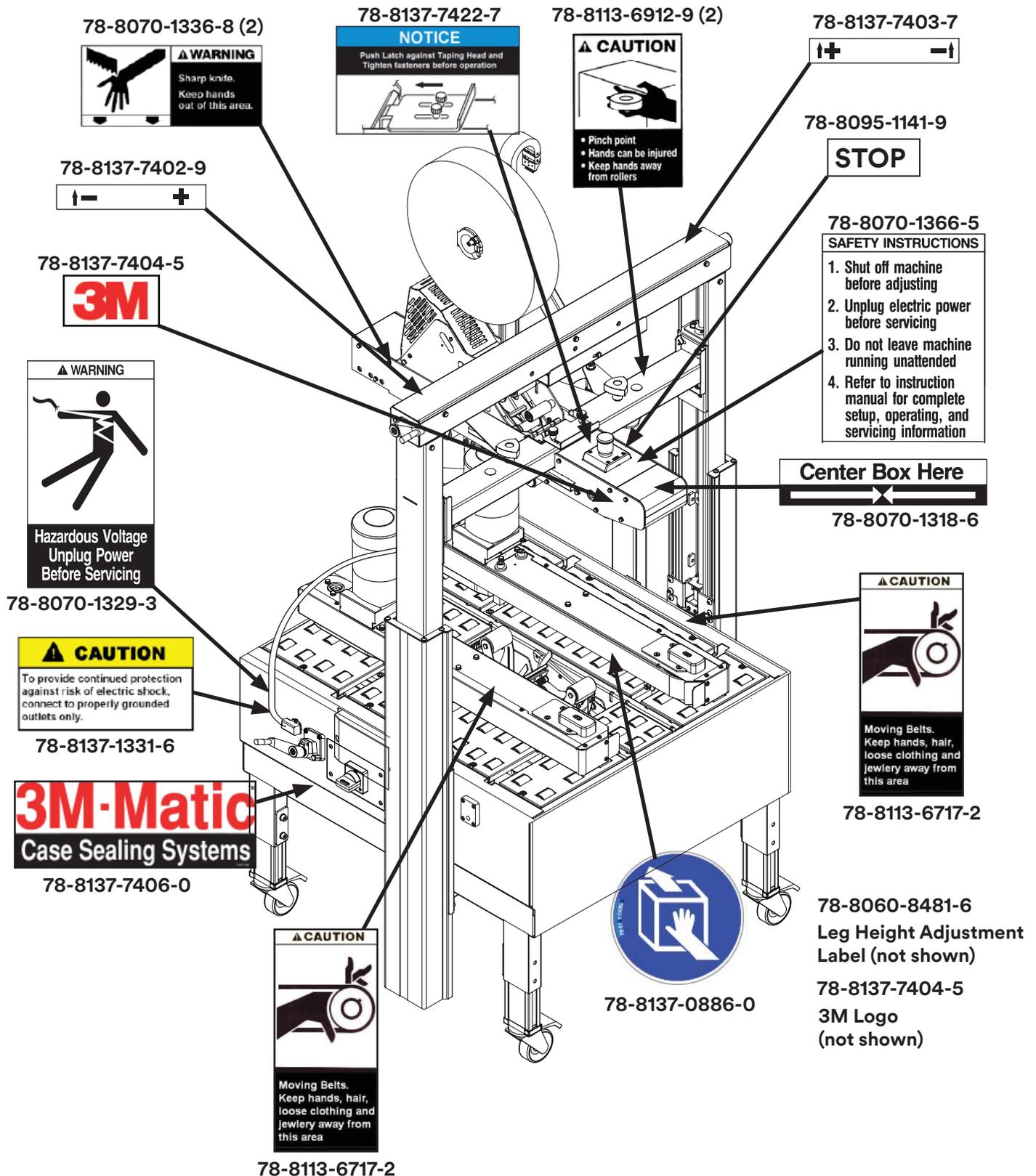


Figure 3-10 Replacement Labels / 3M Part Numbers

## 4. Specifications

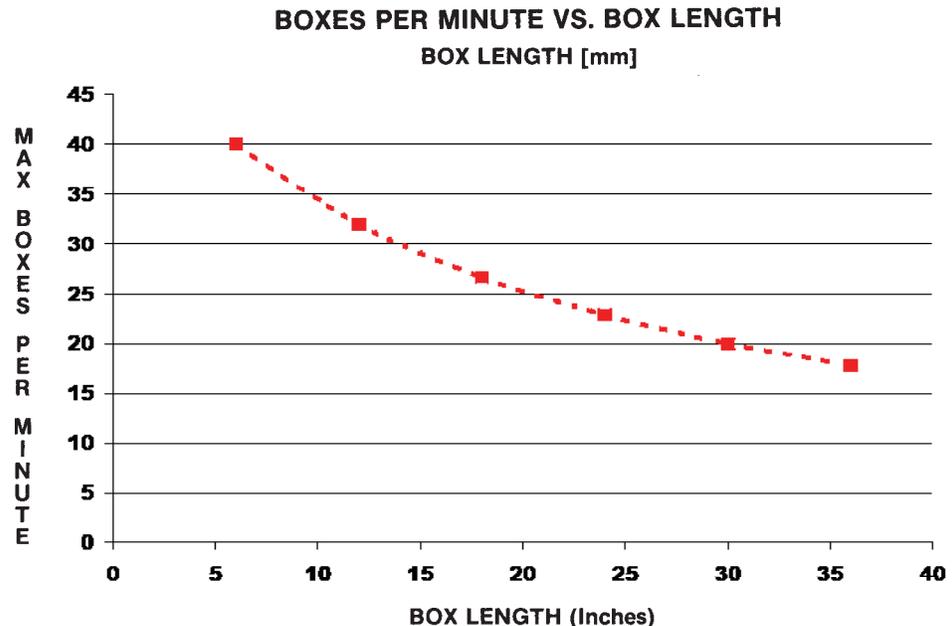
### 4.1 Power Requirements:

Electrical – 120 VAC, 60 Hz, 3.25A, 390 Watt

The machine is equipped with two 1/6 HP gearmotors and comes 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 0.5m/s [100 F.P.M.]



Actual production rate is dependent on operator's dexterity.  
Boxes must be 18 inches (457mm) apart minimum.

### 4.3 Operating Conditions

Use in dry, relatively clean environments at 5° C to 50° 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 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. Specifications *(continued)*

### 4.5 Set-Up Recommendations:

- Machine must be level.
- Customer supplied optional infeed and exit conveyors (if used) should provide straight and level box entry/exit.
- Optional exit conveyor (powered or gravity) can help move sealed boxes away from machine. Powered exit conveyor should match belt speed of case sealer (100 feet per minute).

### 4.6 Tape

Scotch® pressure-sensitive film box sealing tapes.

### 4.7 Tape Width

50mm [2 inch] minimum to 72mm [3 inch] maximum

### 4.8 Tape Roll Diameter

Up to 406.4mm [16 inch] maximum on a 76.2mm [3 inch] diameter core.  
(Accommodates all system roll lengths of **Scotch®** film tapes.)

### 4.9 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”)

### 4.10 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)

### 4.11 Box Weight and Size Capacities

- A. Box Weight, filled: 5 lbs.– 85 lbs. [2.3 kg–38.6 kg]. Contents must support flaps.  
B. Box Dimensions for 8000a and 8000a3 Machines: Inches [mm]

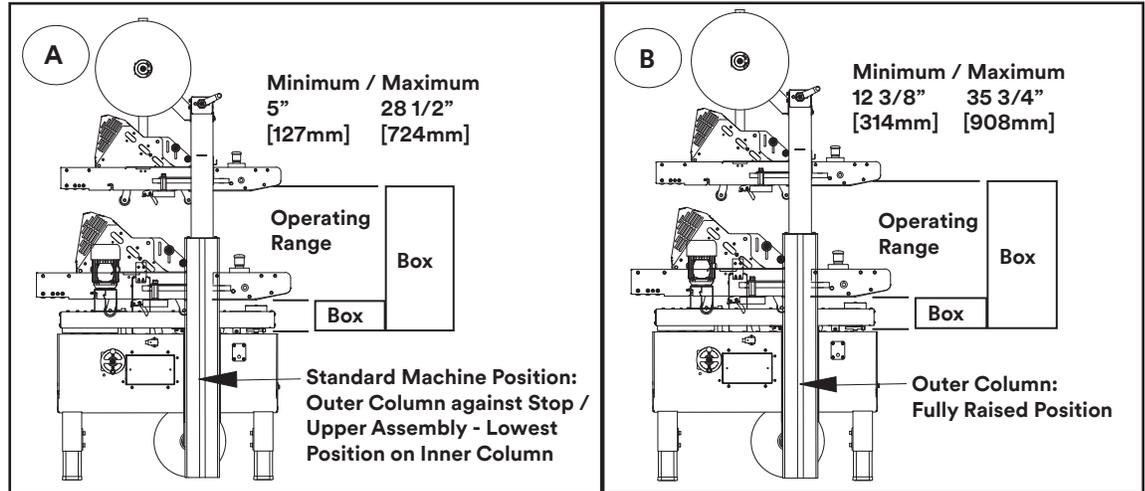
	Length	8000a Width	8000a3 Width	(A) Standard Pos. AG 3 Tape Leg (i.e. 2 3/4" [70])	(B) Fully Raised Pos.
Mínimum	6" [152]	4 1/2" [114]	5 1/2" [140]	5" [127]	12 3/8" [314]
Máximum		21 1/2" [546]	21 1/2" [546]	28 1/2" [724]	35 3/4" [908]

To accommodate smaller or larger boxes, machine upper taping head frame and/or outer column assemblies can be repositioned as described in “Special Set-Up Procedure” section of this manual. Refer to illustration/chart for box height range possibilities by adjusting machine upper frame and/or outer column positioning.

## 4. Specifications *(continued)*

### Minimum/Maximum Box Height Combinations

(To relocate upper frame or outer columns, see "Special Set-Up Procedure")



**Note:** Length of boxes in illustrations above are not to scale.

#### Case Height Range Illustration:

- A. Standard Machine Position:** Outer Columns positioned against Stop with Upper Drive Assembly set to Lowest Position on Inner Columns. Tape Leg Length - 2 3/4" [70mm].
- B. Raised Machine Position:** Maximum Box Height (i.e. Outer Columns and Upper Drive Assembly in Highest Position - See Special Set-Up Procedure). Tape Leg Length - 2 3/4" [70mm]

**Note:** Possible Case Range alternatives depend on column position and any resulting interference with taping heads.

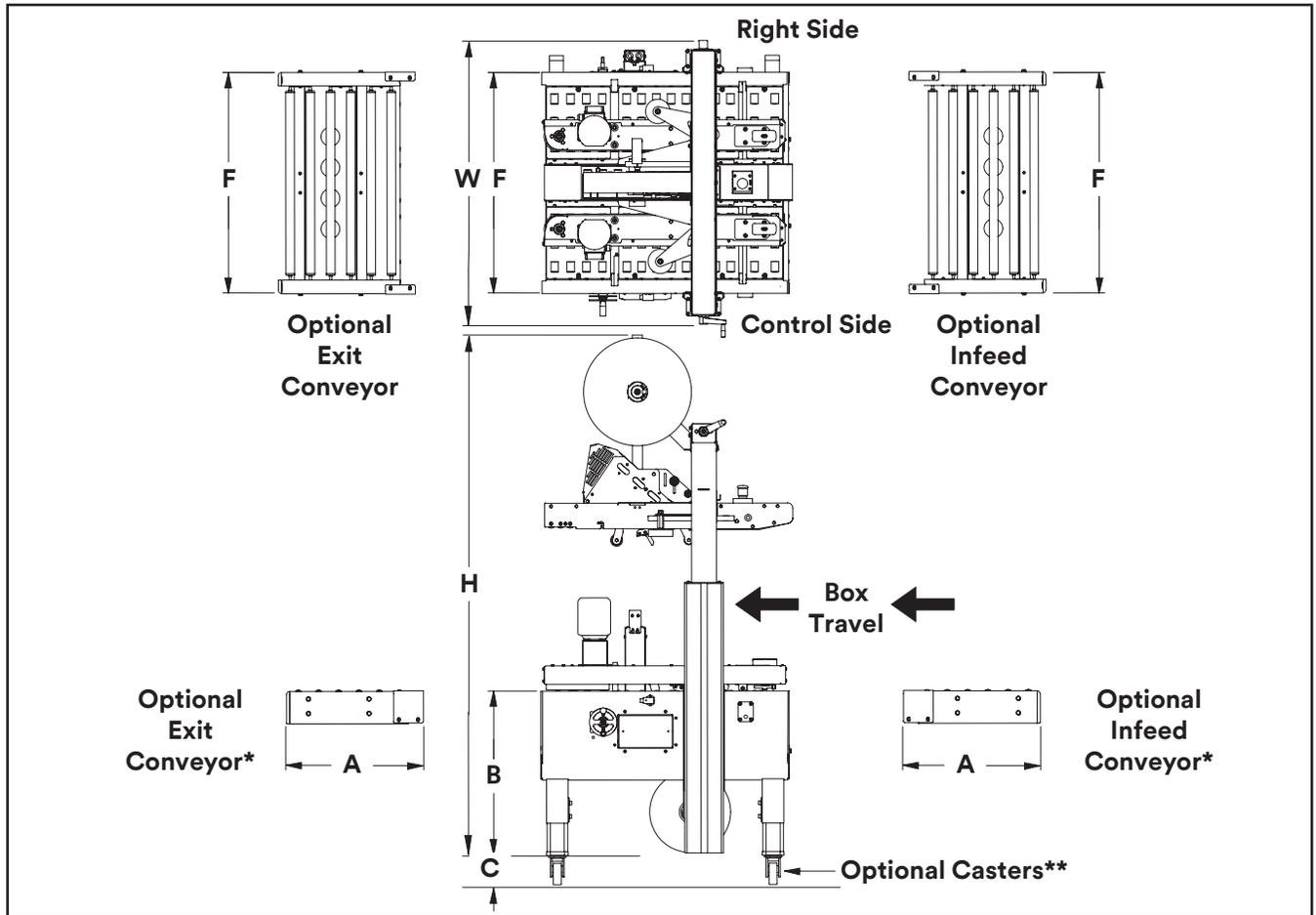
**Special modifications may be available for carton sizes not listed on previous page. Contact your 3M Representative for information.**

**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 .6 or less, several boxes should be test run to assure proper machine performance. Any box ratio approaching this limitation should be test run to assure performance.

**DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:**

$$\frac{\text{BOX LENGTH IN DIRECTION OF SEAL}}{\text{BOX HEIGHT}} = \text{SHOULD BE GREATER THAN } .6$$

## 4. Specifications *(continued)*



### 4.12 Machine Dimensions

	W	L	H	A*	B	C**	F
<b>Minimum</b>							
mm	980	920	1395	460*	610	105**	620
[Inches]	[38 1/2]	[36 1/4]	[55]	[18]	[24]*	[4 3/16]	[24.5]
<b>Maximum</b>							
mm	--	--	2185	--	890	--	--
[Inches]	--	--	[86]*	--	[35]*	--	--

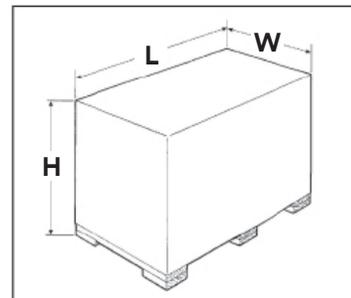
- \* Infeed/Exit conveyors are optional
- \*\* Casters and Conveyors are optional

#### Packaged Machine Dimensions:

Height (H) - 49 1/2" [1257]  
 Length (L) - 51" [1295]  
 Width (W) - 42" [1067]

#### Weight:

Crated Weight - 190 kg [425 pounds] (approximate)  
 Uncrated Weight - 170 kg [375 pounds] (approximate)



## 5. Shipment-Handling-Storage-Transport

### 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 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 2 machines (if they are in their original packing).

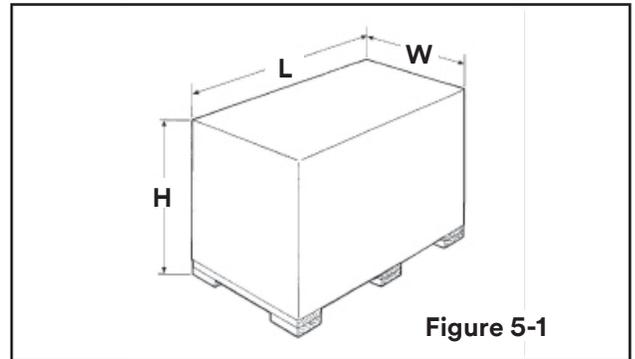


Figure 5-1

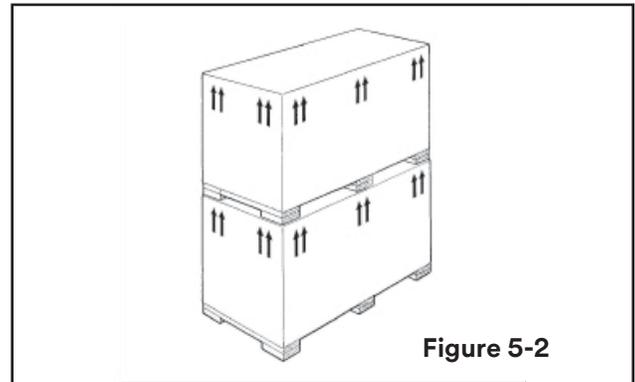


Figure 5-2

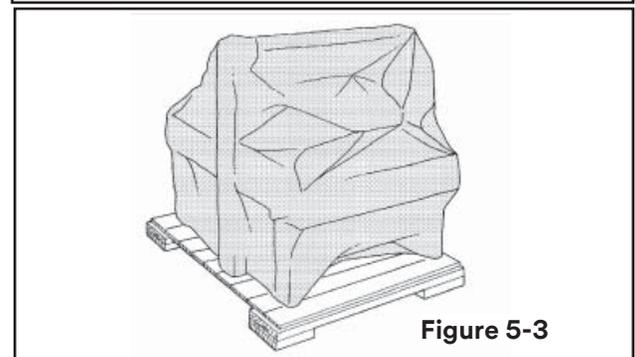


Figure 5-3

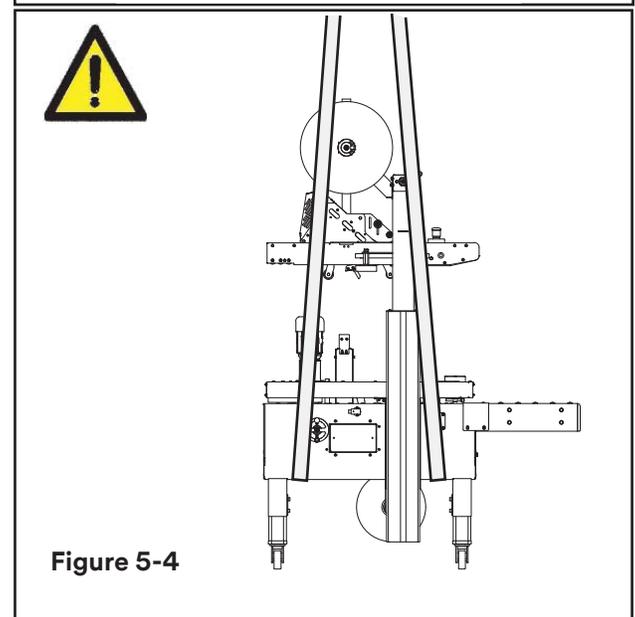


Figure 5-4

## 6. Unpacking

### 6.1 Uncrating

The envelope attached to shipping box contains the uncrating instructions of the machine (**Figure 6-1**).

Cut straps. Cut out staple positions along the bottom of the shipping box (or remove staples with an appropriate tool - **Figure 6-2**). After cutting out or removing the staples, lift the shipping box in order to clear the machine (two persons required).

Transport the machine with a forklift truck to the operating position. Lift the pallet at the point indicated in **Figure 6-3** (weight of machine + pallet = See Specifications).

#### Removal of Pallet

Loosen and remove nuts and brackets using the open end spanner supplied in the tool box (**Figure 6-4**).

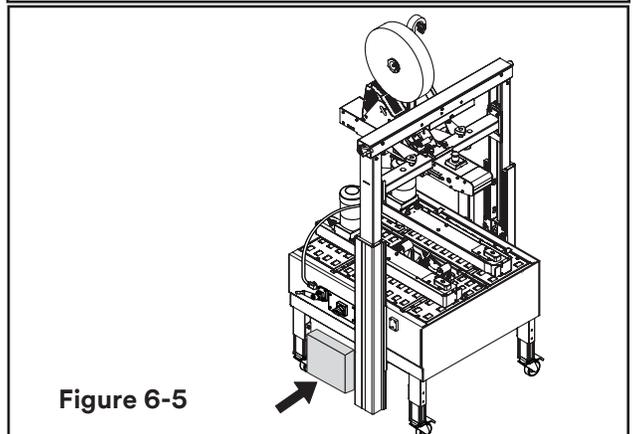
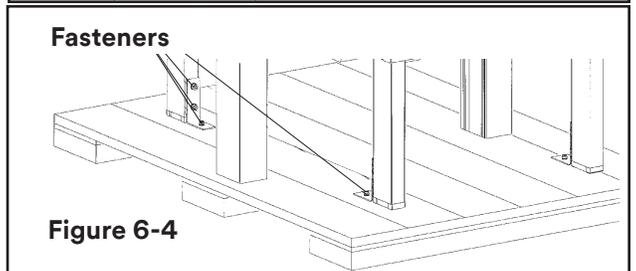
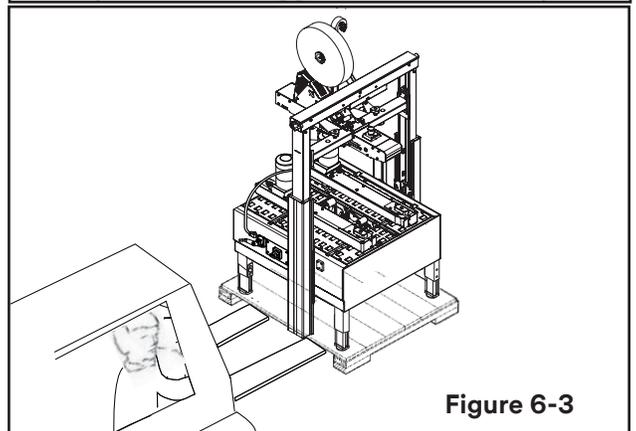
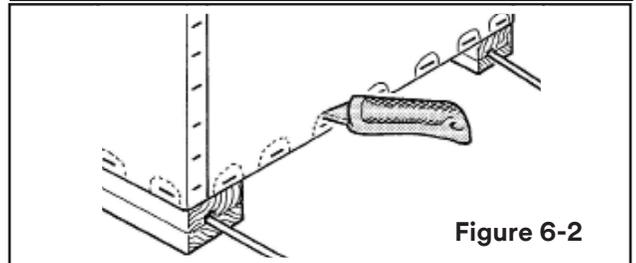
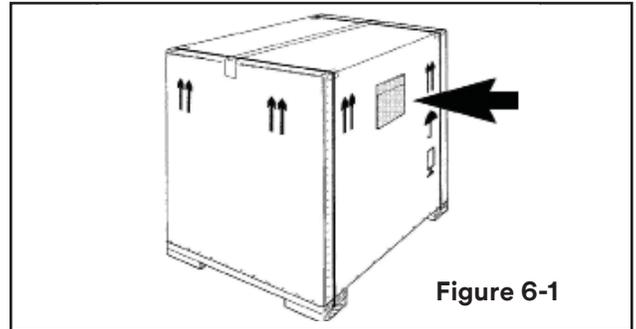
A cardboard box is located under the machine body. Retrieve instruction manual for additional set-up procedures. The box also contains parts removed for shipping, spare parts and tools (**Figure 6-5**).

### 6.2 Disposal of Packaging Materials

The 8000a-8000a3 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. Installation

### 7.1 Operating Conditions

The machine should operate in a dry and relatively clean environment (See Specifications).

### 7.2 Space Requirements for Machine Operation and Maintenance Work

Minimum distance from wall (Figure 7-1):

A = 1000mm.

B = 700mm.

Minimum height = 2700mm.

### 7.3 Tool Kit Supplied with 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 Set-Up / Bed Height

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

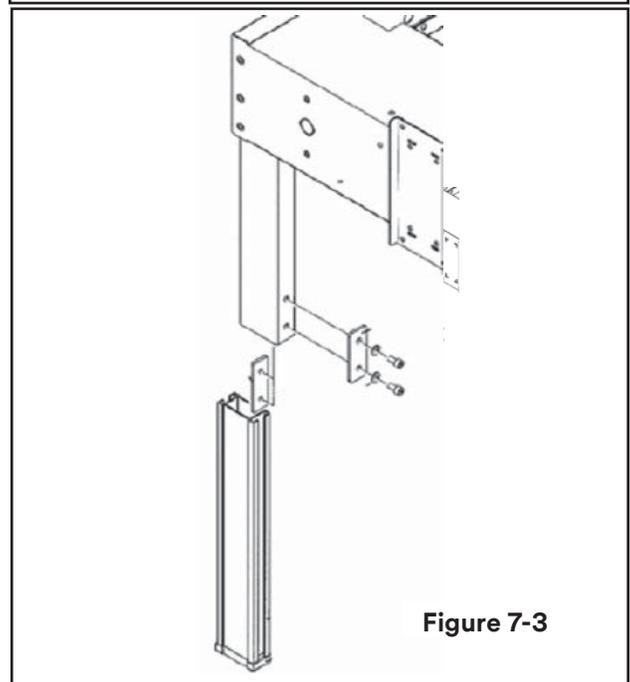
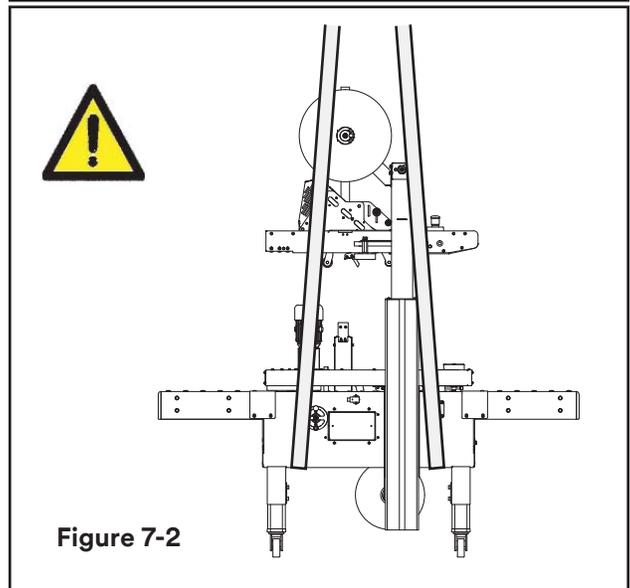
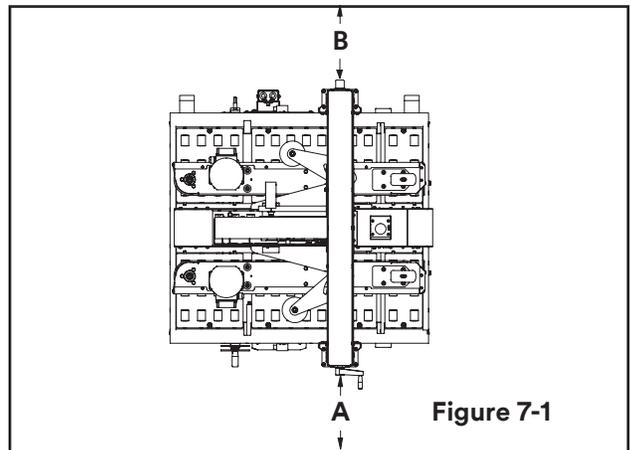
To set the machine bed height, do the following:

- 2 - Adjust machine bed height.  
The case sealer is equipped with four (4) adjustable legs that are located at the corners of the machine frame.  
The legs can be adjusted to obtain different machine bed heights (Figure 7-3).

Also refer to "Specifications"

- 3 - Lock the screws.
- 4 - Repeat the operation for all legs.  
(It is not necessary to fix or anchor the machine to the floor).
- 5 - For Outer Column Positioning -  
The columns are shipped in a lower position.

To Adjust Columns - See Special Set-up Procedure (Section 11) .



## 7. Installation *(continued)*

### 7.5 Removal of Plastic Ties

Cut the plastic which attaches the top head to the frame and remove the polystyrene blocks (**Figure 7-4**).

Cut the plastic strap which attaches the strip and the EMERGENCY STOP cable to the frame (**Figure 7-5**). Cut the plastic ties holding the lower taping head in position (**Figure 7-6**).

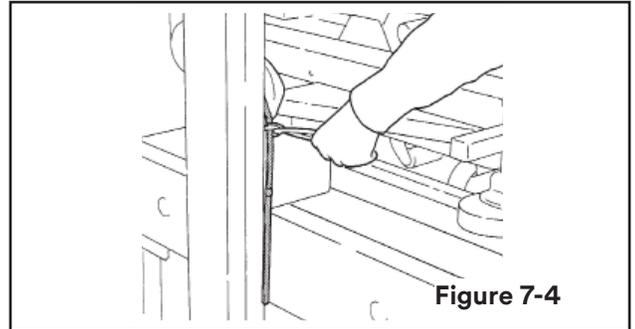


Figure 7-4

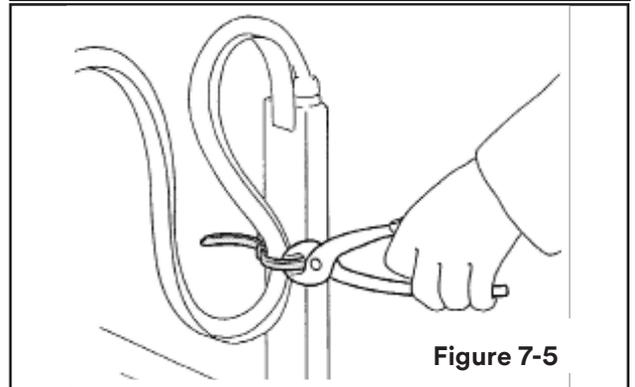


Figure 7-5

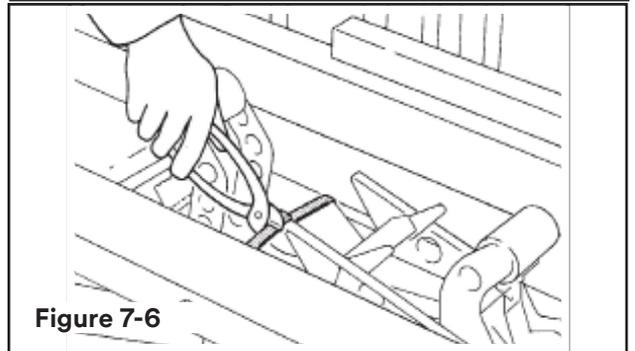


Figure 7-6

### 7.6 Assembly Completion

1. Handle - Remove handle from shipping position and reinstall in operational position - (**Figure 7-7A**).
2. Tape Drum Bracket - Install upper tape drum bracket on top cross bar as shown (**Figure 7-7B**).

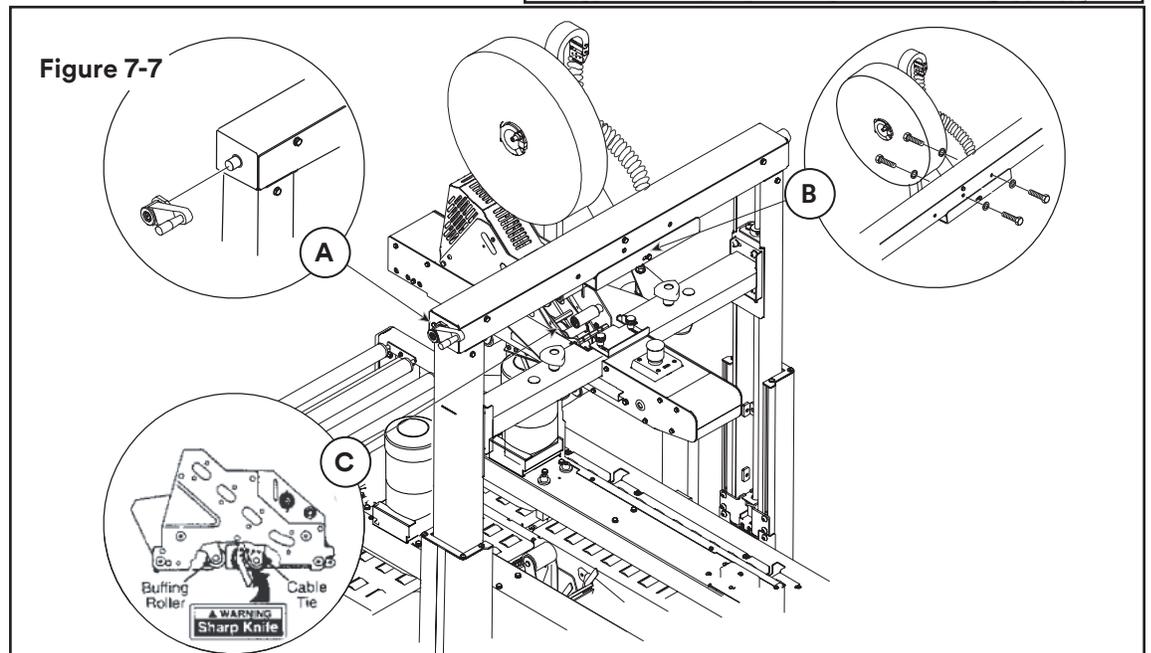


Figure 7-7

## 7. Installation *(continued)*

### 7.7 Completion of Taping Heads

See Manual 2 or 3 for Complete Instructions:

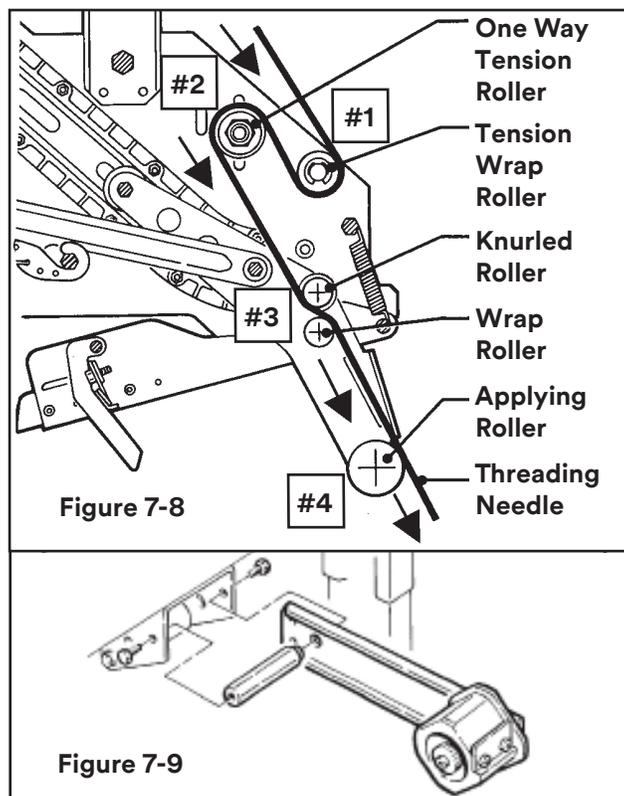
1. Place the Upper Taping Head in a convenient working position
2. Use **Figure 7-8** and tape threading label. Position the tape supply roll so the adhesive side of tape is facing the front of the taping head as it is pulled from the supply roll.
3. Attach the threading needle to the end of the roll. Guide the threading needle around the wrap roller (**Position 1**) then back around the one-way tension roller (**Position 2**).
4. Continue pulling the threading needle down and guide it between the two (2) rollers on the apply arm (**Position 3**).
5. Pull the threading needle down until the tape travels between the apply plate and the ears of the apply arm (**Position 4**) until it extends past the applying roller. When properly threaded the adhesive side of the tape should be facing the knurled rollers at position 2 and also position 3.
6. Cut away any excess tape and repeat steps for Lower Taping Head.

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

### 7.8 Outboard Tape Roll Holder

If you intend to use the outboard tape roll holder, proceed as follows:

1. Remove the lower taping head from the machine.
2. Remove the tape drum bracket assembly, stud spacer, and fasteners from the lower taping head.
3. Install alternative wrap roller and bracket on the head in place of tape bracket. Replace lower head into machine.
4. Install and secure tape drum bracket assembly on the entry end of the lower frame (as shown in **Figure 7-9**).



### 7.9 Preliminary Electric Inspection

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

- 7.9.1 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.
- 7.9.2 Check that the connection of the machine to the mains meets the safety regulations in your country.
- 7.9.3 The machine is fitted with a main switch and a circuit breaker. The user should check that the electrical settings of the machine are compatible with all the components of the mains system.

### 7.10 Machine Connection to the Mains

For technical specifications:

#### See Section 4 - Specifications

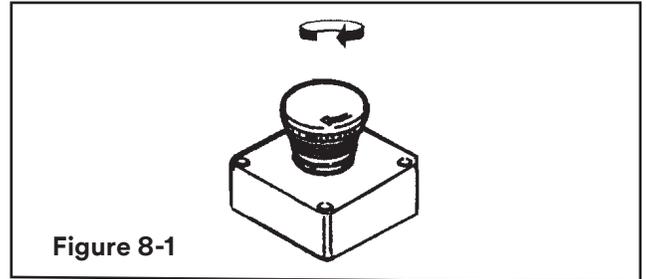
- Push the LATCHING EMERGENCY STOP BUTTON.
- The main switch turned OFF (O).

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

## 8. Theory of Operation

### 8.1 Description of the Working Cycle

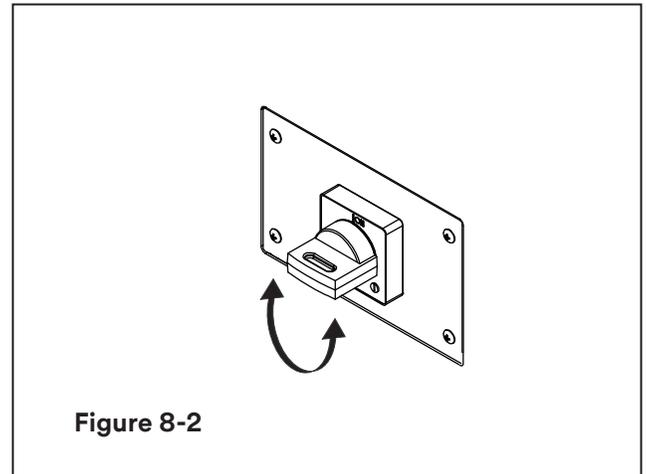
After having closed the top flaps of the carton, the operator pushes it under the top infeed end in order to avoid the opening of the top flaps. Further pushing causes the two top and bottom belts to drive the box through the taping heads which automatically seal the top and bottom seams. The carton is then expelled on the exit conveyor.



### 8.2 Definition of Running Mode

The case sealer 8000a-8000a3 has only one (automatic) operating mode with:

- The EMERGENCY STOP BUTTON unlocked (Figure 8-1)
- The main switch On/Off "ON" (I) (Figure 8-2)

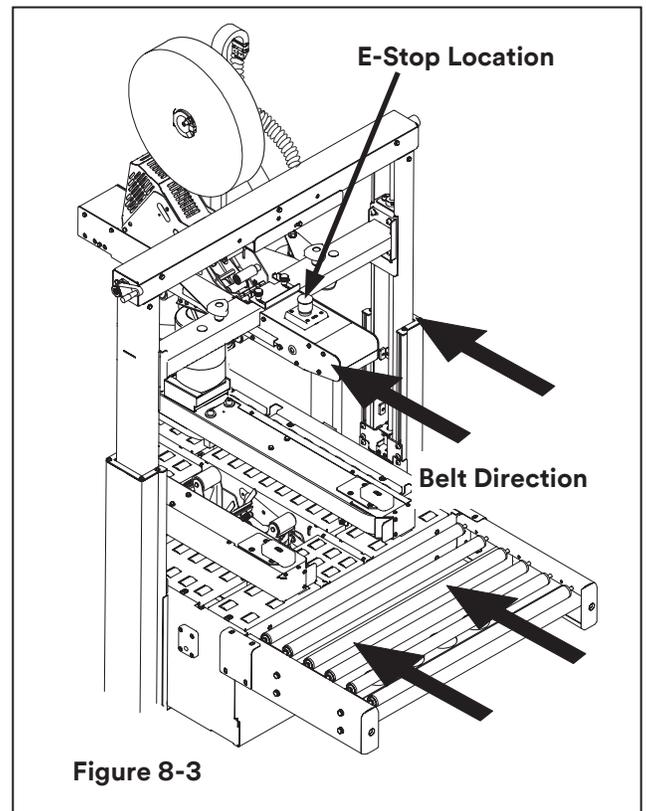


### 8.3.1 Normal Stop Procedure

When the main switch is turned OFF (O), 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.

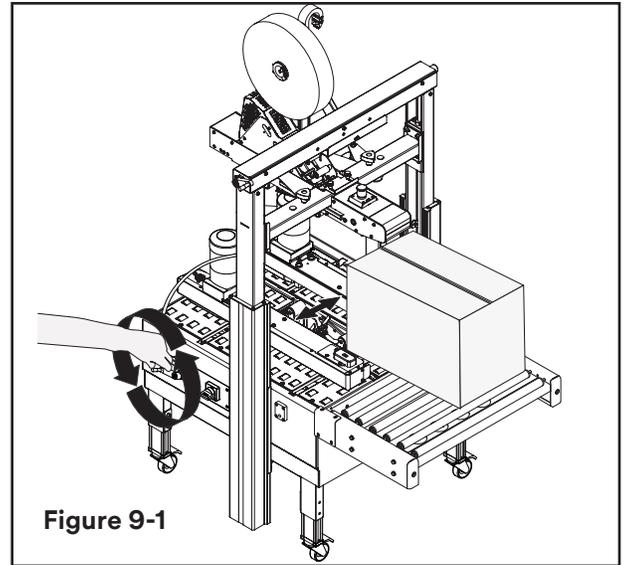
### 8.3.2 Emergency Stop

The LATCHING EMERGENCY STOP BUTTON is located on the top center of the machine (Figure 8-3).

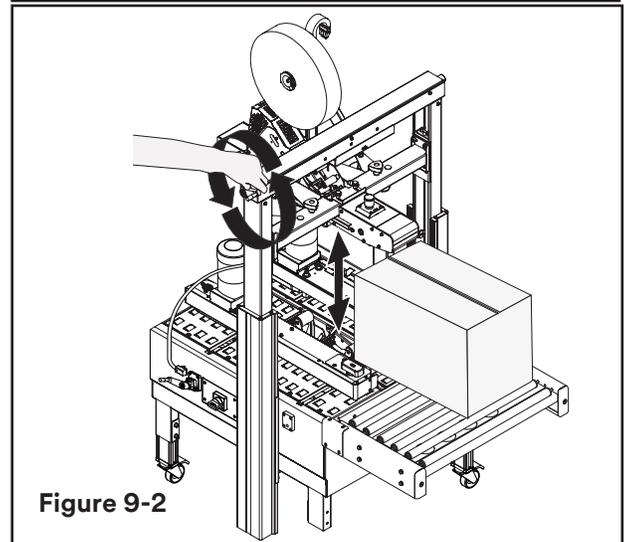


# 9. Controls

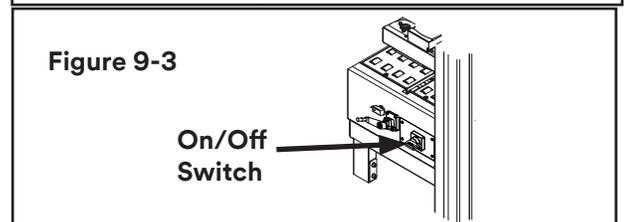
## 9.1 Box Width Adjusting Knobs



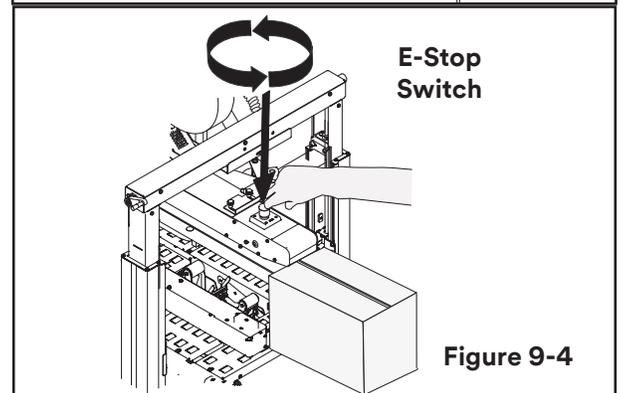
## 9.2 Box Height Adjusting Crank



## 9.3 On/Off Switch



## 9.4 Latching Emergency Stop Button



# 10. Safety Devices of the Machine

## 10.1 Blade Guards

Both top and bottom taping units have a blade guard (See Manual 2 or 3: AccuGlide™ 3 Taping Heads - 2” or 3”.

## 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 (Figure 10-1).

Restart machine by turning the On/Off switch to the Off (O) position and then to the On (I) position (Figure 10-2)

## 10.3 Electric System / Circuit Breaker

The electric system is protected by a ground wire whose continuity has been tested during 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. 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. Turn machine switch “On” (I) 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 wire size 1.5mm dia. [AWG 16]
- Have a max. length 30.5m [100 ft]
- Be properly grounded.

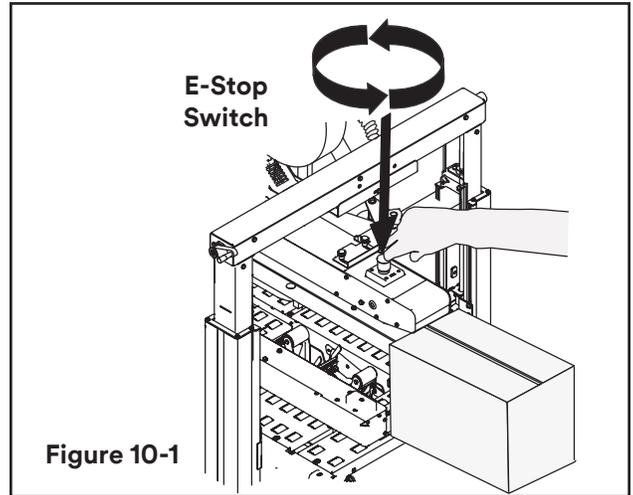


Figure 10-1

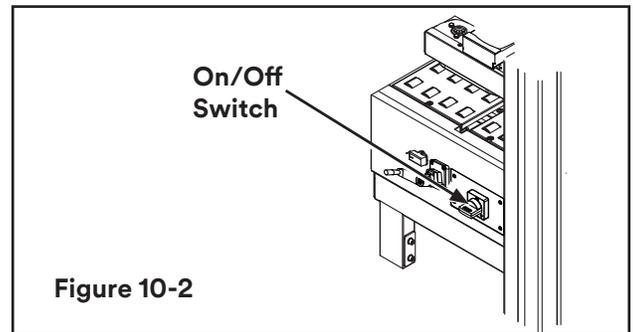


Figure 10-2



## 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 hazardous voltage:
  - Position electrical cord away from foot and vehicle traffic.



## WARNING

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

# 11. Set-Up and Adjustments

## 11.1 Box Width Adjustment

Place a product filled box on infeed end of machine bed with top flaps folded as shown and manually move box forward to contact lower taping head applying roller.

Turn drive belt adjustment crank to position both side drive belts against sides of box (**Figure 11-1**).

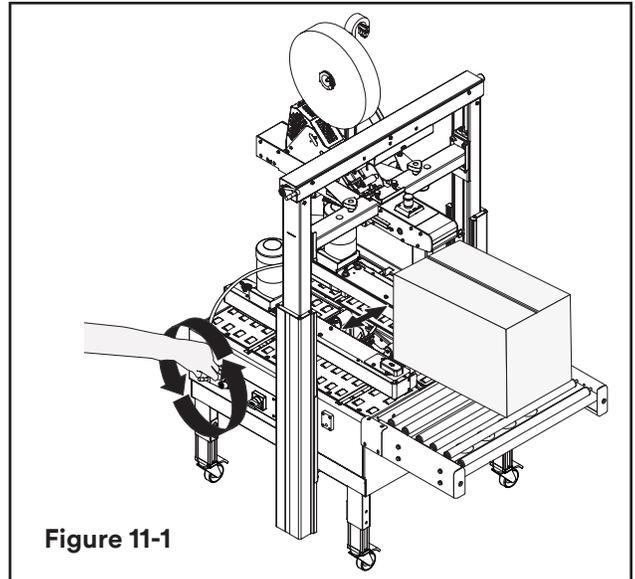


Figure 11-1

## 11.2 Box Height Adjustment

Turn height adjustment crank to position upper taping head onto box. Turn clockwise to lower head, counterclockwise to raise head. Upper taping head must contact and hold top box flaps closed (**Figure 11-2**).

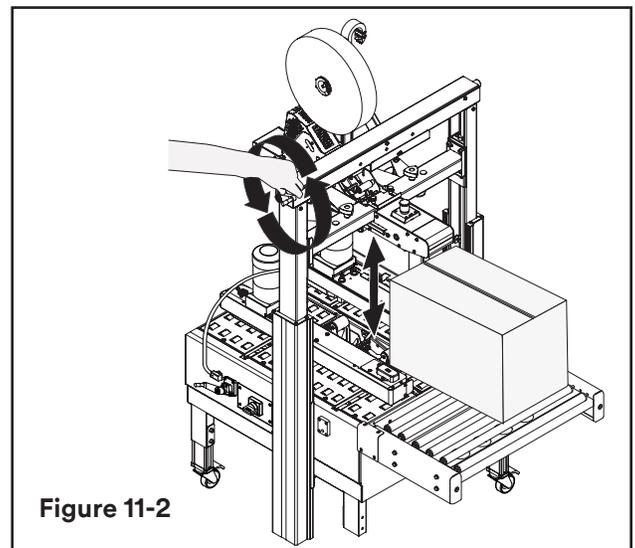


Figure 11-2

## 11.3 Adjustment of Top Flap Compression Rollers

The top flap compression rollers have an adjustable slide mounting to provide side compression through the full range of box widths.

Manually move box forward so front of box is aligned with top flap compression rollers.

Adjust the compression rollers against top edge of box and tighten knobs to secure rollers in operating position (**Figure 11-3**).

## 11.4 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".

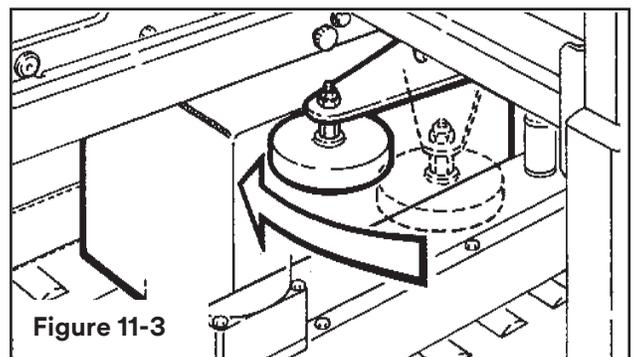
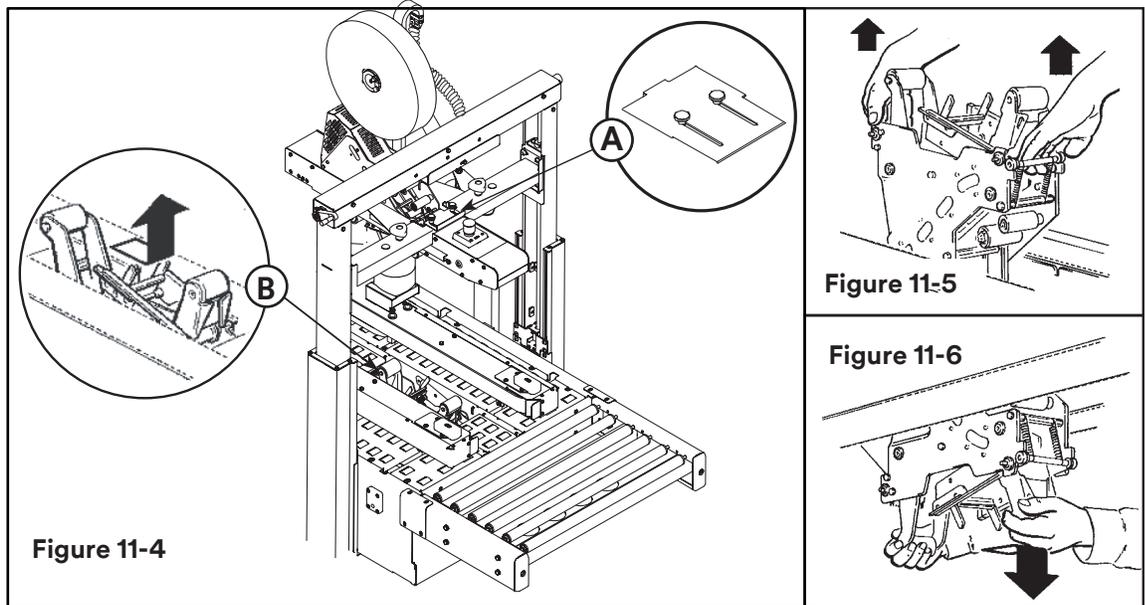


Figure 11-3

## 11. Set-Up and Adjustments *(continued)*



### 11.5 Special Set-Up Procedure for Outer Column Re-Positioning *(continued on next page)*

Moving the outer columns will increase/decrease the maximum box height capacity of the 8000a-8000a3 case sealer.

1. Place solid blocks approximately 12" [305mm] high at front and rear of upper tapping head assembly as shown in **Figure 11-7A**.
2. Crank the upper tapping head assembly down until it touches these blocks.
3. Loosen (but do not remove) the eight (8) screws and washers that fasten each column to the frame (**Figure 11-7B**).

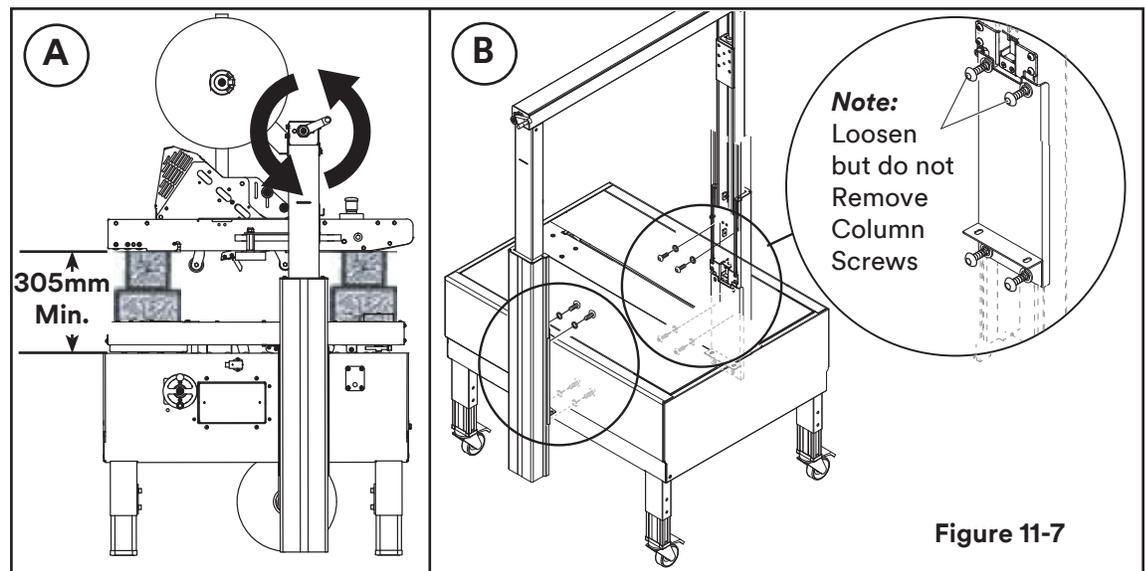
**Note:** You will also need to loosen the two (2) set screws in the nut plate bracket (located above bottom two column screws).

4. Turn height adjustment crank clockwise to raise outer columns until they reach the stop.

**Note:** Instructions are indicated for the Standard Column Position (Also see specifications). If Alternate Column positions are needed, loosen and re-position the column stop.

5. Tighten the eight (8) screws and washers in each column.

Also tighten two Set Screws (if applicable) *(continued on next page)*



## 11. Set-Up and Adjustments *(continued)*

### 11.5 Special Set-Up Procedure for Outer Column Re-Positioning *(continued)*

Moving the outer columns will increase or decrease the box height handled by the 8000a-8000a3 case sealer.

#### **Maximum Height:**

An additional adjustment can be made to reach Maximum Height. This additional height adjustment can be made by moving the Upper Assembly Crossbar up to top holes - (Figure 11-8).

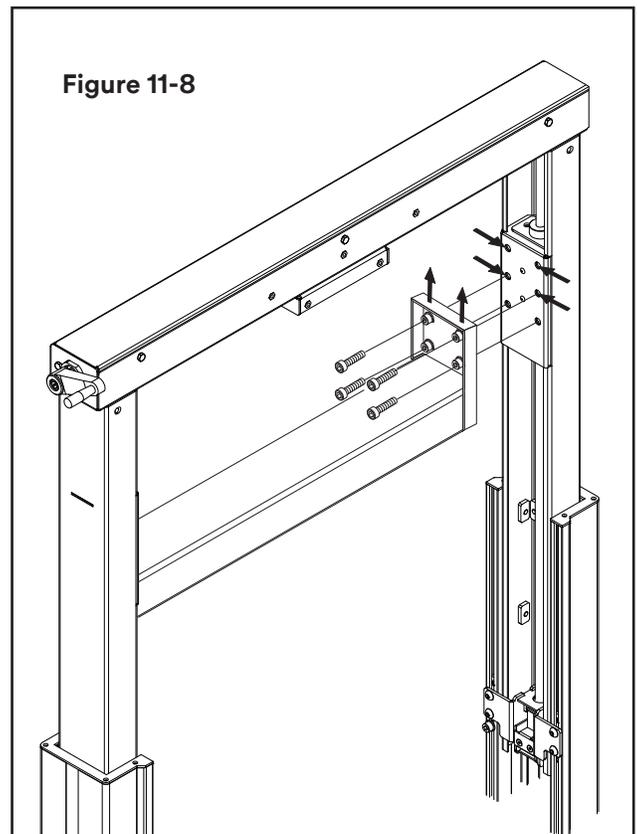
### 11.6 Run Boxes to Check Adjustment

Turn electrical switch "On" (I) to start drive belts.

Move box forward under upper taping head until it is taken away by drive belts. If box is hard to move under head or is crushed, raise head slightly.

If the box movement is jerky or stops under the upper head, move the side drive belts in slightly to add more pressure between the box and drive belts.

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



# 12. Operation

## 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 top and bottom drive belts. Always keep hands in position as shown in **Figure 12-2**.

The box will be automatically sealed with adhesive tape on the top and bottom box seams. Then the box will be expelled on the exit conveyor.

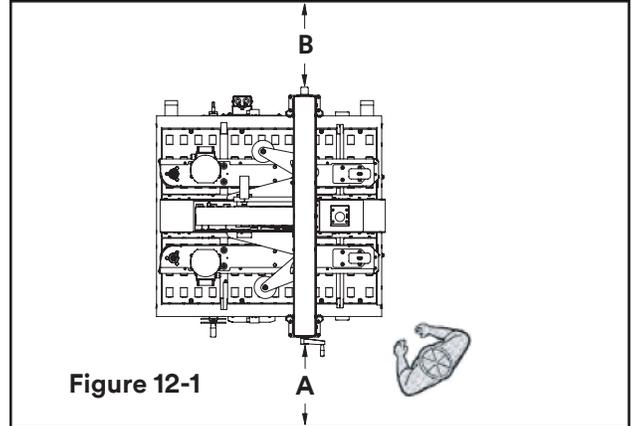


Figure 12-1

## 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 switch ON (I) after the EMERGENCY BUTTON is released (**Figure 12-3**).

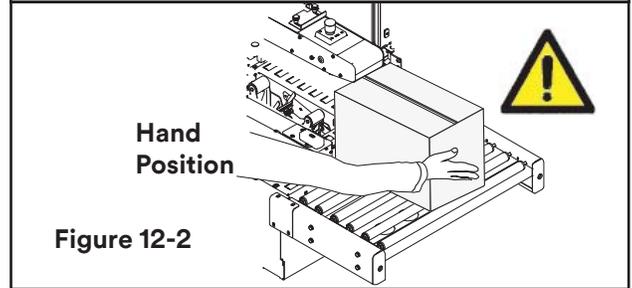


Figure 12-2

## 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 or 3: AccuGlide™ 3 High Speed 2 Inch or 3 Inch Taping Heads.

Press the LATCHING EMERGENCY STOP BUTTON.

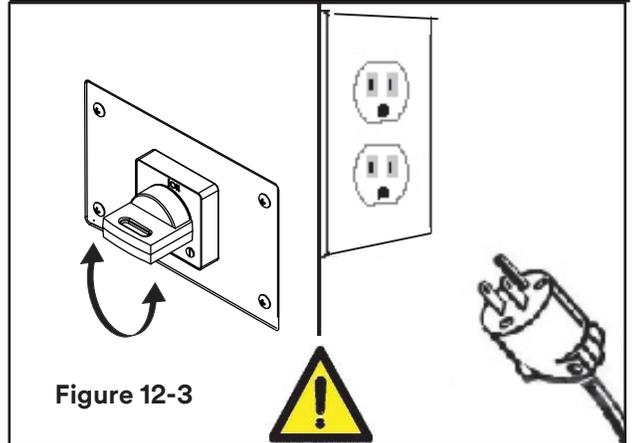


Figure 12-3

## 12.5 Box Size Adjustment

Repeat all the operations shown in **Section 11 - Set-Up and Adjustments**.

## 12.6 Cleaning

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

## 12.7 Table of Operation Adjustments - Operator Qualifications

1	Tape loading and threading	1
2	Tape web alignment	1
3	Adjustment of one way tension roller	1
4	Adjustment to box size (H and W)	1
5	Top flap compression rollers	1
6	Adjustment of tape applying spring	1
7	Conveyor bed height adjustment	1
8	Special Adjustment-Changing tape leg length	2
9	Special Adjustment-Column re-positioning	2

## 12.8 Safety Devices Inspection

1. Taping units blade guard
2. Latching emergency stop button
3. STOP (OFF) (O) main switch

## 12. Operation *(continued)*

### 12.9 Trouble Shooting Guide

PROBLEM	CAUSE	CORRECTION
After turning the ON/OFF switch to the On position, machine does not start	The lockable emergency stop button is pressed	Release the emergency stop button  Check the electrical system
The magnetothermic protection opens the main switch	Motor under stress  Thermal cut-out not at correct amperage setting	Check that the drive belts are not blocked  Set the correct amperage
Drive belts do not convey boxes	Narrow boxes  Worn drive belts  Taping head applying spring holder missing  Taping head applying spring set too high	Check machine specifications Boxes are narrower than recommended, causing slippage and premature belt wear  Replace drive belts  Adjust the box height adjustment with the crank  Reduce spring pressure
Drive belts do not turn	Worn or missing friction rings  Drive belt tension too low  Electrical disconnect  Motor not turning	Replace friction rings  Adjust belt tension  Check power and electrical plug  Evaluate problem and correct

*(continued on next page)*

## 12. Operation *(continued)*

### 12.9 Trouble Shooting Guide *(continued)*

PROBLEM	CAUSE	CORRECTION
<p>The blade does not cut tape or the tape end is jagged or shredded</p>	<p>The blade is dull and/or has broken teeth</p> <p>Tape tension is insufficient</p> <p>Adhesive has built up on the blade</p> <p>The blade is in backwards</p> <p>One or both cutter springs are missing or stretched</p>	<p>Replace the blade</p> <p>Increase tape tension by adjusting the one-way roller</p> <p>Clean and adjust the blade</p> <p>Make sure the blade is bottomed out against the mounting bolts</p> <p>Lubricate the blade oiler pad on the blade guard</p> <p>Mount the blade so that the beveled edge is away from the entrance end of the head</p> <p>Replace the defective spring(s)</p>
<p>Tape is tabbing on the trailing leg on the back of the box</p>	<p>There is excess tension on tape drum assembly and/or the on-way tension roller assembly</p> <p>Rollers in the tape path do not rotate freely</p> <p>The blade is not cutting tape properly</p> <p>The tape is threaded incorrect</p> <p>Applying mechanism spring has too little tension</p>	<p>Adjust the one-way tension roller and/or tape drum assembly</p> <p>Clean adhesive deposits from the surface ends and shafts of the rollers. Remove all lubricant from roller surfaces</p> <p>Refer to tape cutting problems</p> <p>Rethread tape</p> <p>Move spring hook to next tighter hole</p>



# 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.

## 13.2 Tools and Spare Parts Supplied with the Machine

See Spare Parts Order Section.

component wear and over-heating of drive motors. The dust build up is best removed from the machine with a vacuum cleaner. Depending on the number of cartons processed, this cleaning should be done weekly. Excessive build-up that cannot be removed by vacuuming should be removed with a damp cloth.

## 13.3 Recommended Frequency of Inspection and Maintenance Operations

Operation	Frequency	Qualification	Sections
Inspection safety features	daily	1	13.4
Cleaning of machine	weekly	1	13.5
Cleaning of cutter blade	weekly	2	13.6
Oiling of felt pad	weekly	2	13.7
Lubrication	monthly	2	13.7-13.8
Blade replacement	when worn	2	See Manual 2 or 3
Drive belt replacement	when worn	2	13.10

## 13.4 Inspections to be Performed Before and after every Maintenance Operation

Before every maintenance operation, Turn the main switch OFF (O) and disconnect. During the maintenance operation, only properly trained and qualified personnel must work on the machine. At the end of every maintenance operation check the safety devices.

## 13.7 Cleaning of Cutter Blade Qualification 2

Should tape adhesive build-up occur, carefully wipe clean with oily cloth or brush. Oil prevents the build-up of tape adhesive (See Manual 2 or 3)

## 13.5 Check Efficiency of Safety Features

1. Blade guard assembly upper taping head
2. Blade guard assembly lower taping head
3. Latching Emergency stop button with mechanical lock (interrupt supply of electrical power)
4. Turn main switch STOP/OFF (O)
5. Safety guards top drive belts

## 13.6 Cleaning of Machine

### Qualification 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


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. Maintenance and Repairs *(continued)*

### 13.8 Box Drive Belt Replacement

**Note** – 3M recommends the replacement of drive belts in pairs, especially if belts are unevenly worn.

1. Crank the upper taping head to its fully raised position.
2. Remove and retain the five (5) screws (A), five (5) washers (B) and side cover (C) - **See Figure 13-1.**
3. Remove and retain the screw (D), washer (E) and belt tensioner cover (F).
4. Turn belt adjustment screws (G) counterclockwise on both the upper and lower tension assemblies until belt is loose - **See Figure 13-2.**
5. Locate the belt lacing (joint) by turning the belt manually. Remove the pin with pliers. Remove and discard old belt.

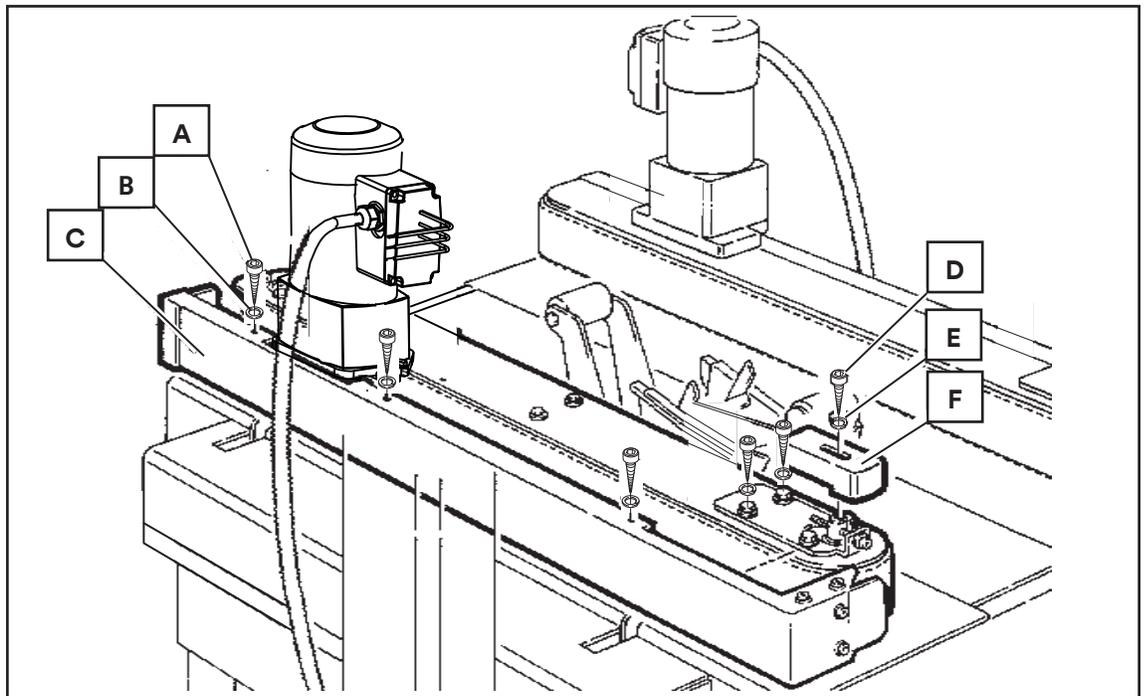
*(continued on next page)*

### **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 pinches, entanglement and hazardous voltage:
  - Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.



**Figure 13-1** Box Drive Belt (Left Side View – Infeed End)

## 13. Maintenance and Repairs *(continued)*

6. Install the new belt around drive rollers and insert new pin. Pin must not extend beyond edge of belt.

7. To set drive belt tension, turn adjustment screws (G) equally on both the upper and lower tension assemblies. Turn the screws clockwise to increase tension or counterclockwise to decrease tension - See **Figure 13-2**.

Use a force gauge to pull the belt outward 25mm [1 inch] at mid span, as shown with a moderate pulling force of 3.5 kg [7 lbs].

8. Reverse procedures in Steps 1-3 (**Figure 13-1**) to reassemble the drive belt assembly.

### 13.9 Box 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 13-3**).

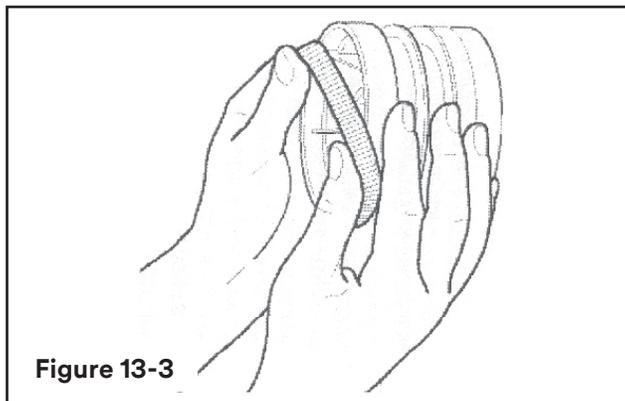


Figure 13-3

### **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.

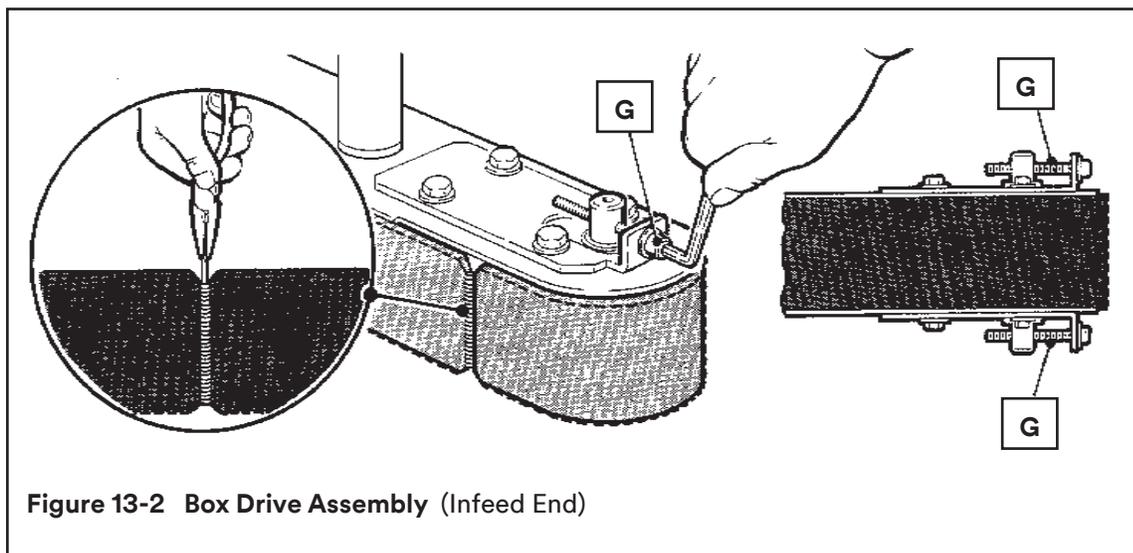
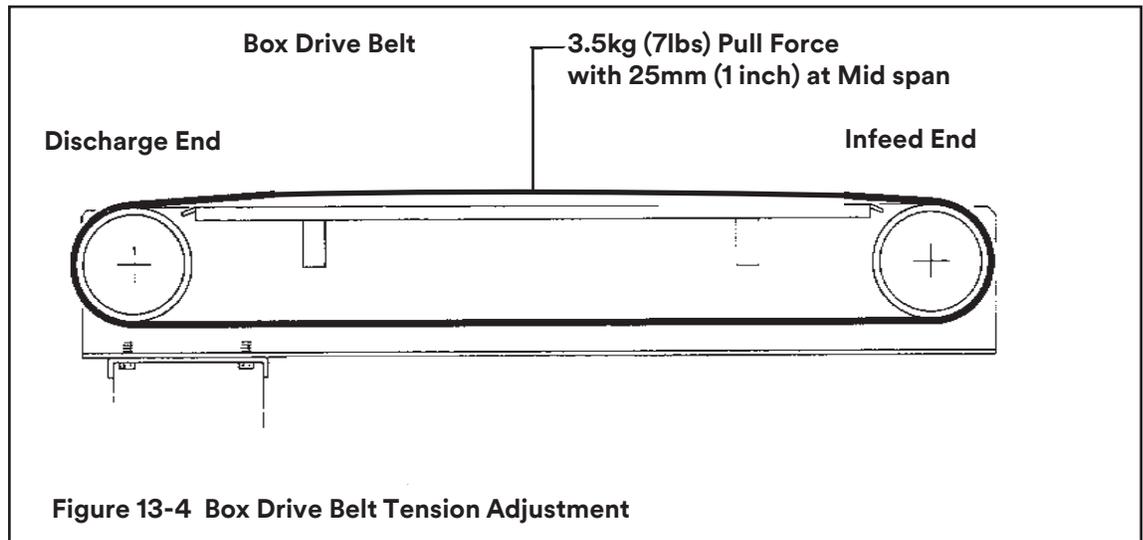


Figure 13-2 Box Drive Assembly (Infeed End)

## 13. Maintenance and Repairs *(continued)*



### 13.10 Drive Belt Tension

Tension adjustment of the drive belts may be required during normal operation. Belt tension must be adequate to positively move the box through the machine and they 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 3.5 kg [7 lbs] applied at the mid span, as shown in **Figure 13-4**, 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 taping head. To adjust belts, see “Maintenance – Drive Belts”, steps 3 and 7.



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

## 13. Maintenance and Repairs *(continued)*

### 13.11 Taping Heads (Refer to Figure 13-5A, 13-5B, and 13-5C)

**Note** – Changing tape leg to 48mm [2 inches] requires machine adjustment also. See Manual 2 or 3 “Special Set-Up Procedure Changing ape Leg Length”.

1. Loosen, but do not remove, the two retaining screws that secure upper taping head shown - **Figure 13-5A**.
2. Hold upper taping head applying and buffing arms from under upper assembly, slide head forward and down to remove **Figure 13-5B**.
3. Lift the lower taping head, shown in **Figure 13-5C**, straight up to remove it from the case sealer bed.
4. Refer to Manual 2 (Taping Head), See “Adjustments – Changing Tape Leg Length” for taping head set-up.



## 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.

### Taping Head Adjustments

Tape Web Alignment	– Manual 2
Tape Drum Friction Brake	– Manual 2
Applying Mechanism Spring	– Manual 2
One Way Tension Roller	– Manual 2
Tape Leg Length	– Manual 2
Leading Tape Leg Length Adjust	– Manual 2
Changing Tape Leg Length from 70 to 48mm [2-3/4 to 2 inches]	– Manual 2

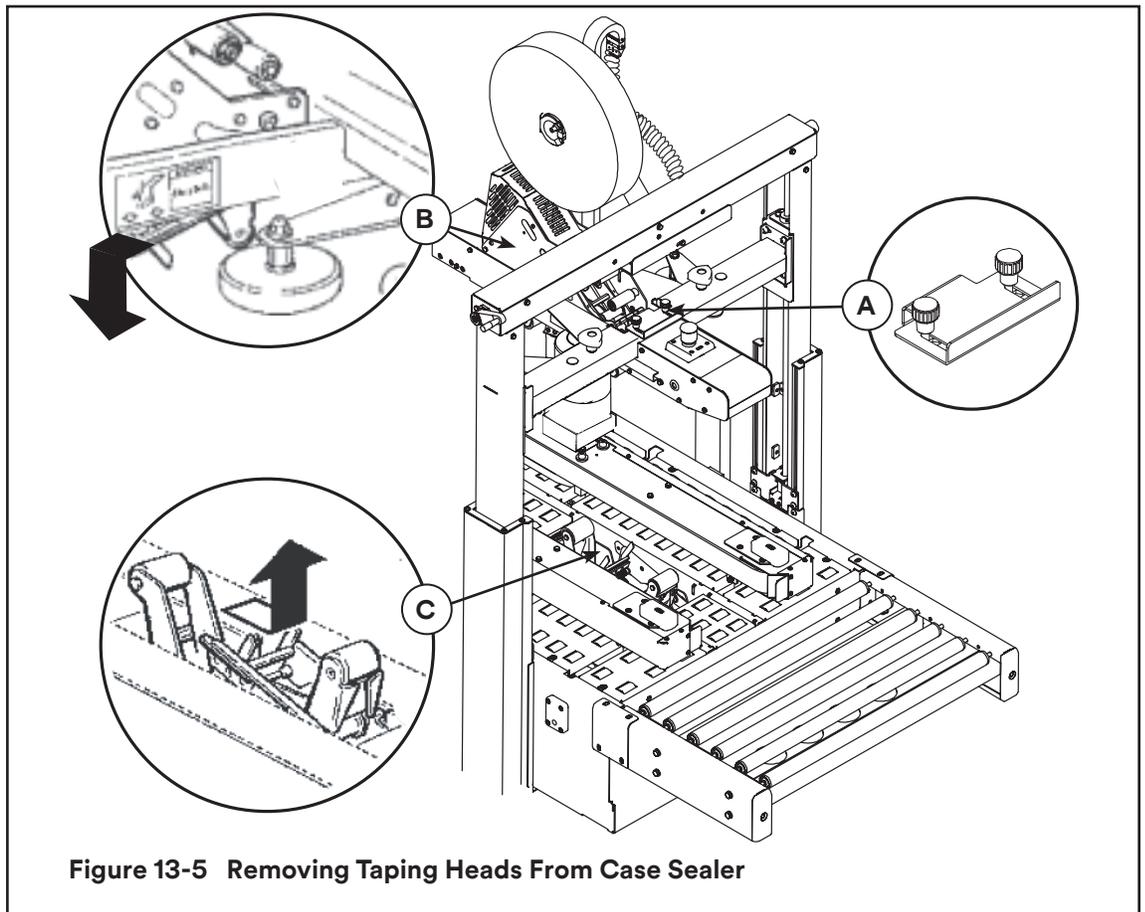


Figure 13-5 Removing Taping Heads From Case Sealer





## 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 that is rated for electrical fires (**Figure 14-2**).

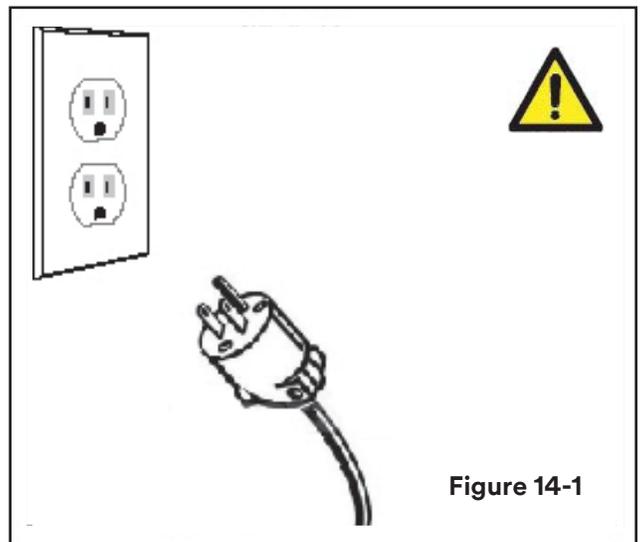


Figure 14-1

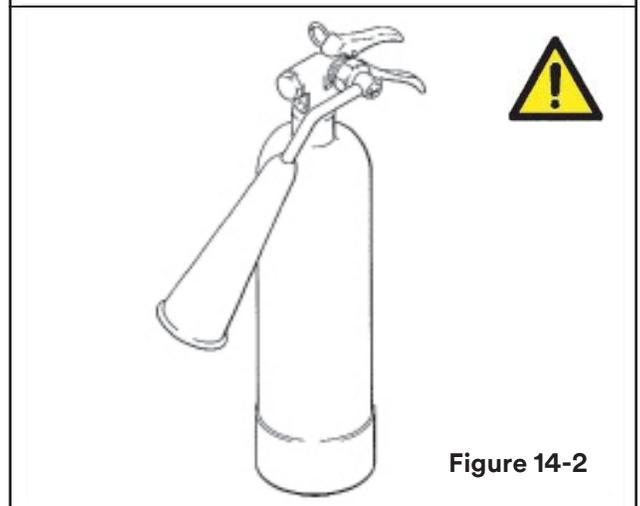


Figure 14-2

## 15. Additional Information

### 15.1 Statement of Conformity

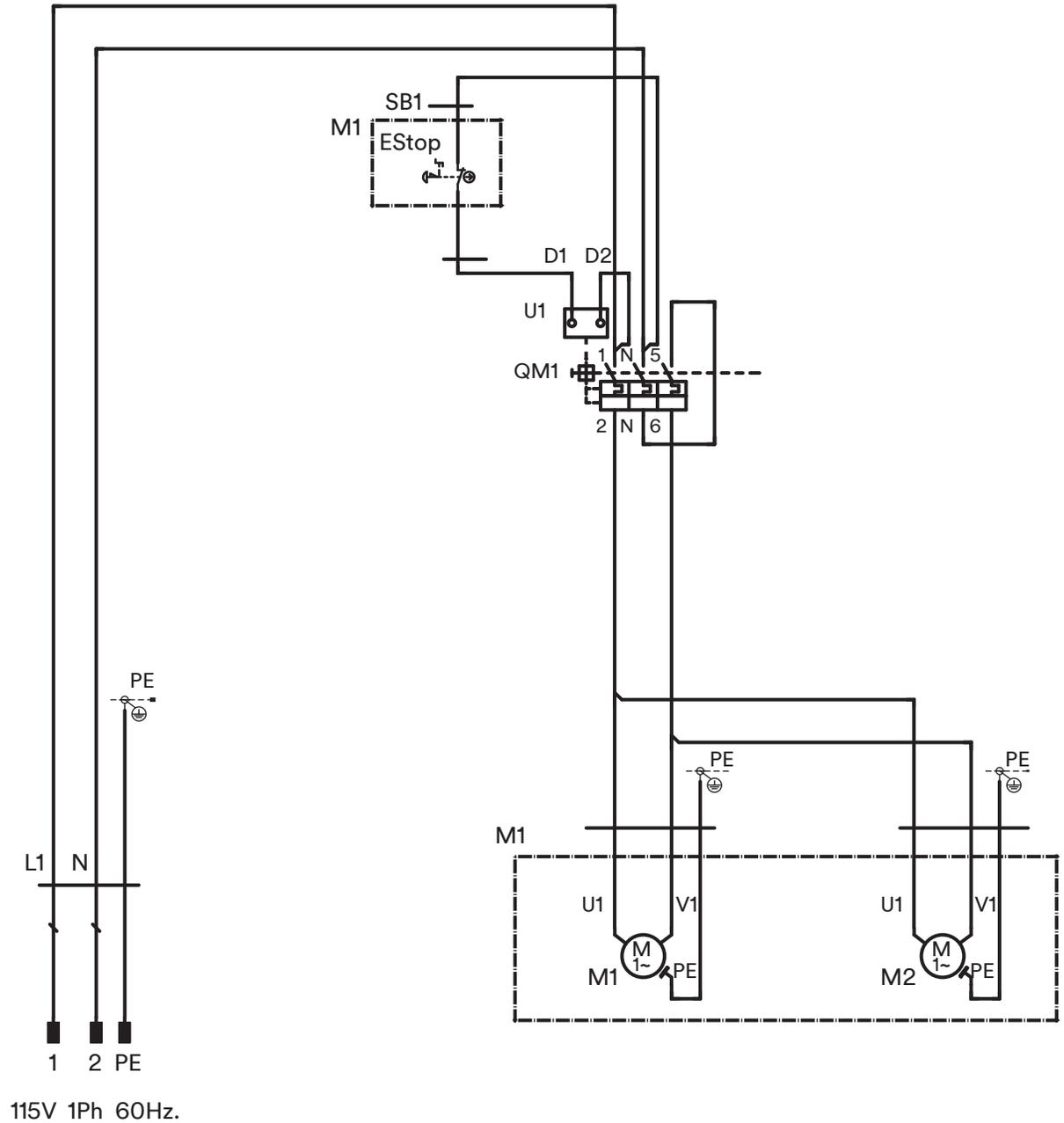
N/A

### 15.2 Emission of Hazardous Substances

Nothing to report

# 16. Technical Documentation and Information

## 16.1 Technical Diagrams - Electric



# 16. Technical Documentation and Information *(continued)*

## 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 Number
- Position
- 3M Part Number (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.

### Spare Parts – 8000a-8000a3 Adjustable Case Sealer

It is suggested that the following spare parts be ordered and kept on hand: *(continued)*

## 8000a-8000a3

Qty.	3M-Part Number	Description
------	----------------	-------------

2	78-8076-5452-6	Belt-Drive w/Hook
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### Spare Parts Kit

8000a - Part Number 78-8137-8730-2

8000a3 - Part Number 78-8137-8731-0

### Label Kit

In the event that any labels are damaged or destroyed, they must be replaced to ensure operator safety. A label kit, part number 78-8137-7540-6, is available as a stock item. It contains all the safety labels used on the **8000a-8000a3** Adjustable Case Sealer.

### Tool Kit

A tool kit, part number 78-8137-7543-0, is supplied with the machine 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.

### Replacement Parts Ordering Information and Service

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

## 16. Technical Documentation and Information *(continued)*

### 8000a-8000a3 Adjustable Case Sealer, Type 11600 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.

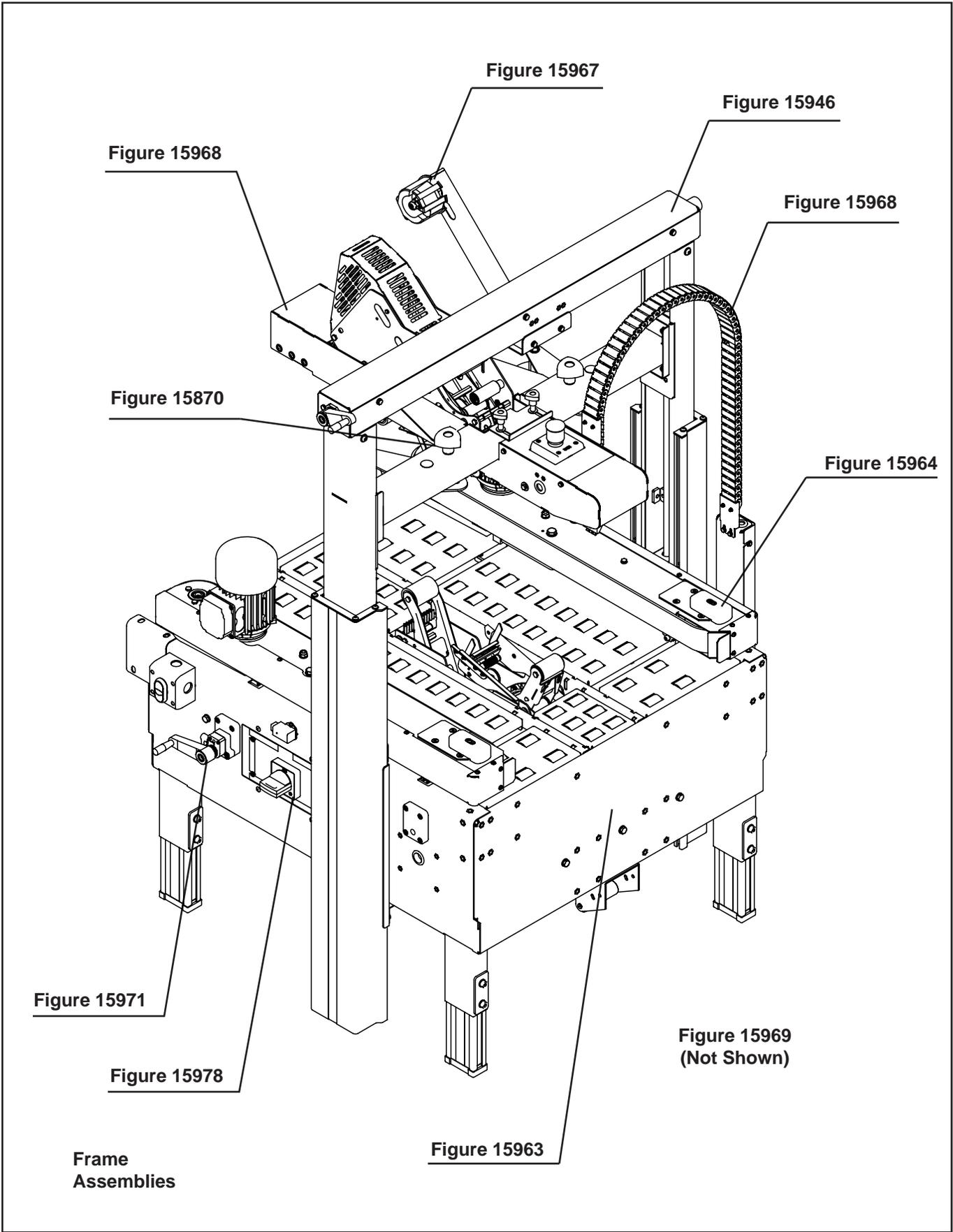
**Important** – Not all the parts listed are normally stocked items. Some parts or assemblies shown are available only on special order. Contact 3M/ Tape Dispenser Parts to confirm item availability

#### Options and Accessories

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

Part Number	Option / Accessory
78-8052-6553-1	Box Hold Down Attachment
70-0064-2998-2	Caster Kit Attachment
78-0067-5967-7	Conveyor Extension Attachment
70-0064-4963-4	AccuGlide™ 3 Upper Taping Head - 2 inch, Type 10800
70-0064-4962-6	AccuGlide™ 3 Lower Taping Head - 2 inch, Type 10800
70-0064-4965-9	AccuGlide™ 3 Upper Taping Head - 3 inch, Type 10800
70-0064-4964-2	AccuGlide™ 3 Lower Taping Head - 3 inch, Type 10800
78-8069-3926-6	Low Tape Sensor Kit
78-8095-4854-4	2-Inch Tape Edge Fold Attachment, Upper Head
78-8095-4855-1	2-Inch Tape Edge Fold Attachment, Lower Head
78-8114-0940-4	3 Flap Folder Kit
70-0067-3769-9	Filler Plate - Lower
70-0067-6506-2	Drive Height Adjustment Kit





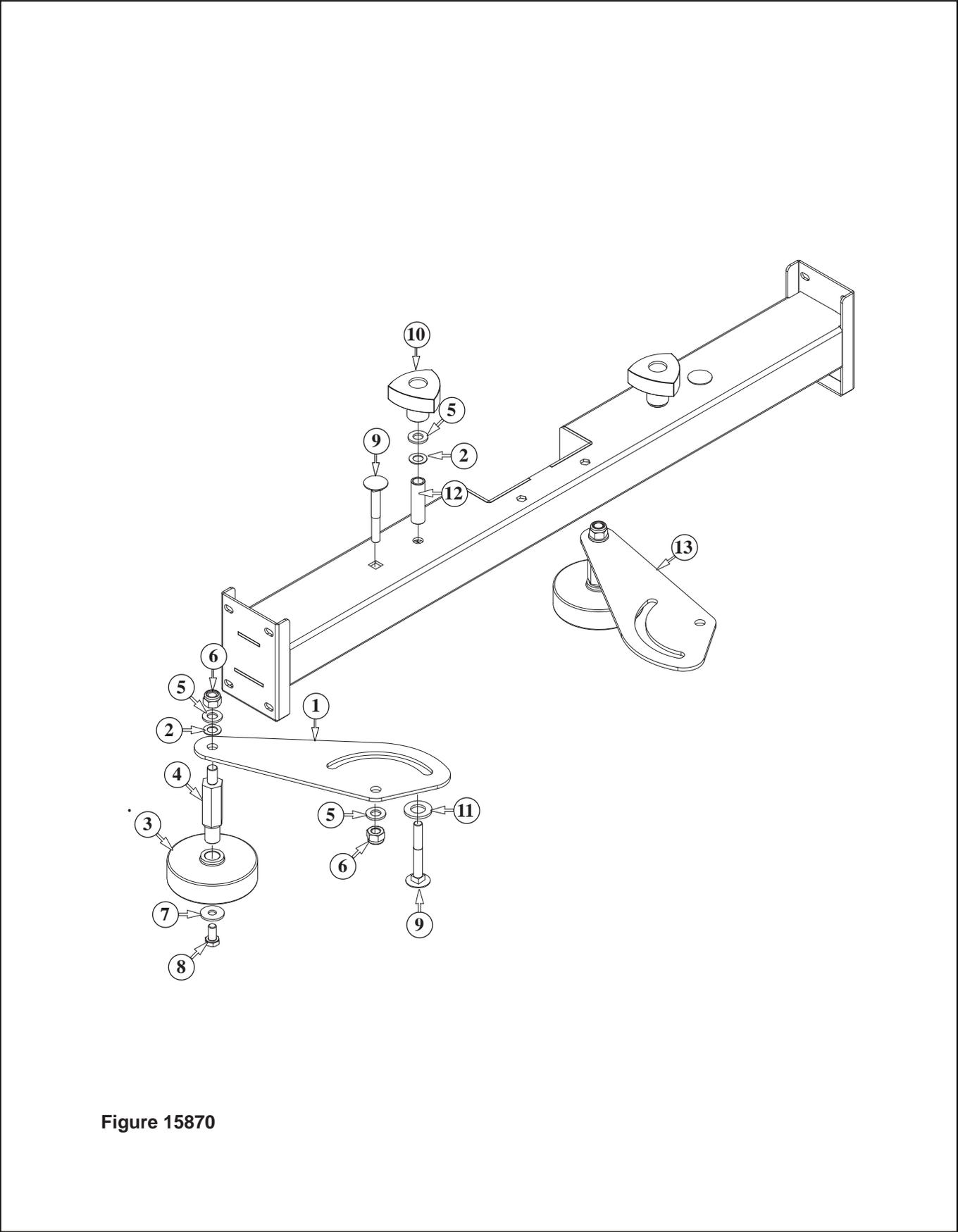
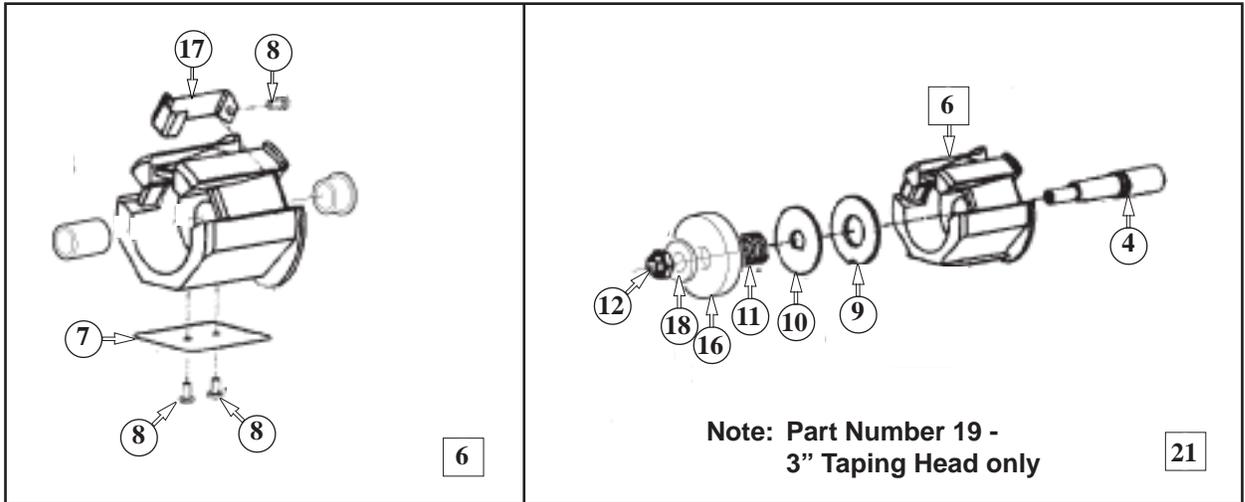


Figure 15870

Figure 15870

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
15870-1	78-8137-7878-0	Support - Compression Roller
15870-2	78-8017-9074-8	Washer - Nylon - 10,5/18X1
15870-3	78-8054-8974-3	Compression Roller
15870-4	78-8137-7881-4	Pin - Compression Roller
15870-5	26-1004-5510-9	Washer - M10 - Galvanized
15870-6	26-1003-6918-5	Nut - M10 Self-Locking
15870-7	26-1004-5507-5	Triple Washer - M8 - Galvanized
15870-8	26-1003-5841-0	Screw - M8X16 - Galvanized
15870-9	78-8137-7784-0	Screw - M10X70 - Galvanized
15870-10	78-8070-1549-6	Knob - "ELESA" VTR-B-M10
15870-11	78-8100-1154-0	Washer 30-15-05 - Galvanized
15870-12	78-8070-1562-9	Support - Knob
15870-13	78-8137-7789-9	Compression Roller Assembly



Note: See Parts List for Accuglide 2" and 3" information

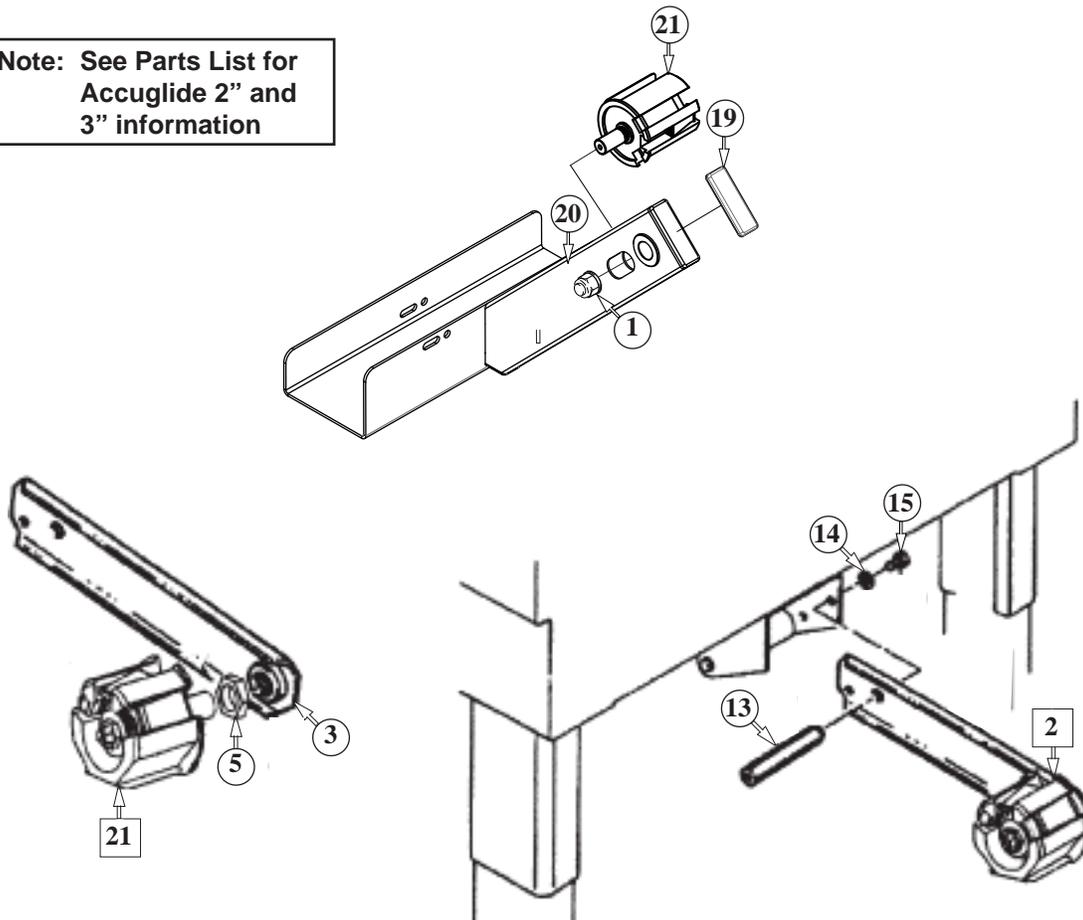


Figure 15967

Figure 15967

Ref. No.	3M Part No.	Description
15967-1	78-8017-9169-6	Nut - M18x1 - Galvanized
15967-2	78-8137-1158-3	Tape Drum Bracket Assembly
15967-3	78-8070-1395-4	Bracket - Bushing Assembly
15967-4	78-8076-4519-3	Shaft - Tape Drum 2"
	78-8060-8462-6	Shaft - Tape Drum 3"
15967-5	78-8017-9169-6	Nut - M18x1
15967-6	78-8098-8832-0	Latched Tape Drum Assy w/Shaft
15967-7	78-8098-8817-1	Leaf - Spring 2"
	78-8098-8830-4	Leaf - Spring 3"
15967-8	26-1002-5753-9	Screw - Self Tapping 7SPX8
15967-9	78-8060-8172-1	Washer - Friction
15967-10	78-8052-6271-0	Washer - Tape Drum
15967-11	78-8100-1048-4	Spring - Core Holder
15967-12	78-8017-9077-1	Nut - M10X1
15967-13	78-8076-4742-1	Spacer - Stud
15967-14	26-1000-0010-3	Washer - M6 Flat
15967-15	78-8010-7169-3	Screw - M6x12 Hex Hd.
15967-16	78-8052-6651-3	Washer - Nylon
15967-17	78-8098-8816-3	Lock - Core Holder
15967-18	26-1004-5510-9	Washer - M10 Plain
15967-19	78-8137-6346-9	Cap
15867-20	78-8137-6345-1	Bracket - Tape Head Arm
15967-21	78-8098-8814-8	Tape Drum Assembly w/Shaft 2"
	78-8098-8832-0	Tape Drum Assembly w/Shaft 3"

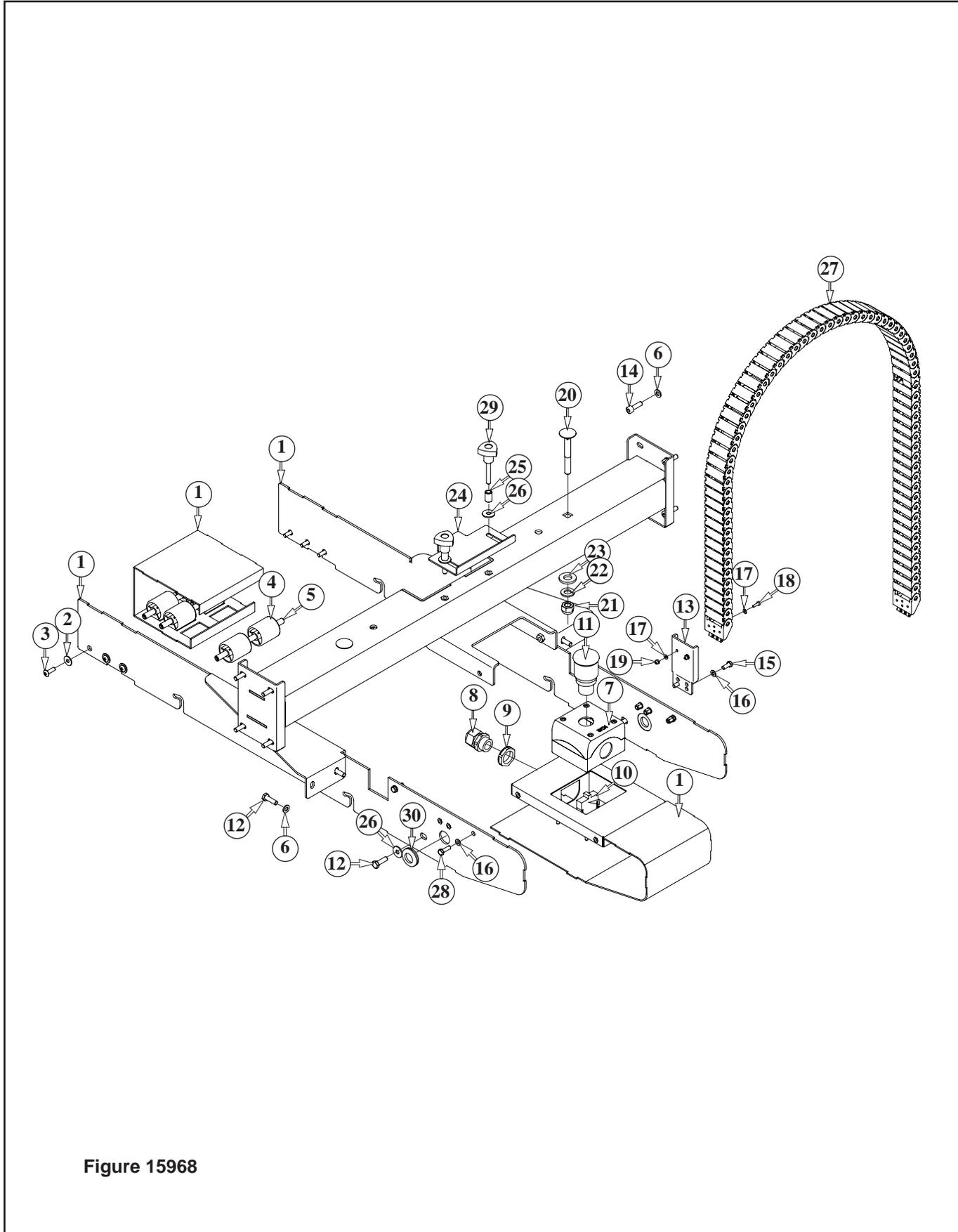


Figure 15968

Figure 15968

Ref. No.	3M Part No.	Description
15968-1	78-8137-8101-6	Frame
15968-2	78-8028-8214-8	Washer - M5
15968-3	78-8076-4625-8	Screw - M5X16
15968-4	78-8060-7693-7	Roller - 32X38
15968-5	78-8137-8102-4	Pin - 8X136
15968-6	78-8137-8103-2	Washer - M6
15968-7	78-8137-7893-9	Housing - M22-IY1
15968-8	78-8137-0607-0	Fitting - M20X1.5
15968-9	78-8129-6469-6	Nut - M20X1.5
15968-10	78-8137-6354-3	Contact - NC M22-K01
15968-11	78-8137-6353-5	Release - Emergency Button
15968-12	78-8010-7193-3	Screw - M6X20 Hex. Hd.
15968-13	78-8137-8064-6	Bracket - Cable Chain
15968-14	78-8010-7210-5	Screw - M6X20 Soc. Hd. Hex. Soc.
15968-15	78-8137-8104-0	Screw - M5X12
15968-16	78-8005-5741-1	Washer - M5 Flat
15968-17	78-8076-4538-3	Washer - M3 Flat
15968-18	78-8137-3716-6	Screw - M3X10 Soc. Hd. Hex
15968-19	78-8059-5517-2	Nut - M3 Self Locking Zinc. Pl.
15968-20	78-8137-7784-0	Screw - M10X70 Galvanized
15968-21	78-8137-8105-7	Nut - M10
15968-22	78-8137-8106-5	Washer - M10
15968-23	78-8137-8106-5	Washer - 25X12X3
15968-24	78-8137-7790-7	Bracket - w/Lock Lever
15968-25	78-8094-6264-7	Spacer
15968-26	78-8042-2919-9	Washer - M6 Triple
15968-27	78-8137-7824-4	Cable Chain 0182-30-037-990 MA/FI
15968-28	78-8137-8107-3	Screw - M5X16
15968-29	78-8137-8108-1	Handle
15968-30	78-8060-7785-1	Grommet

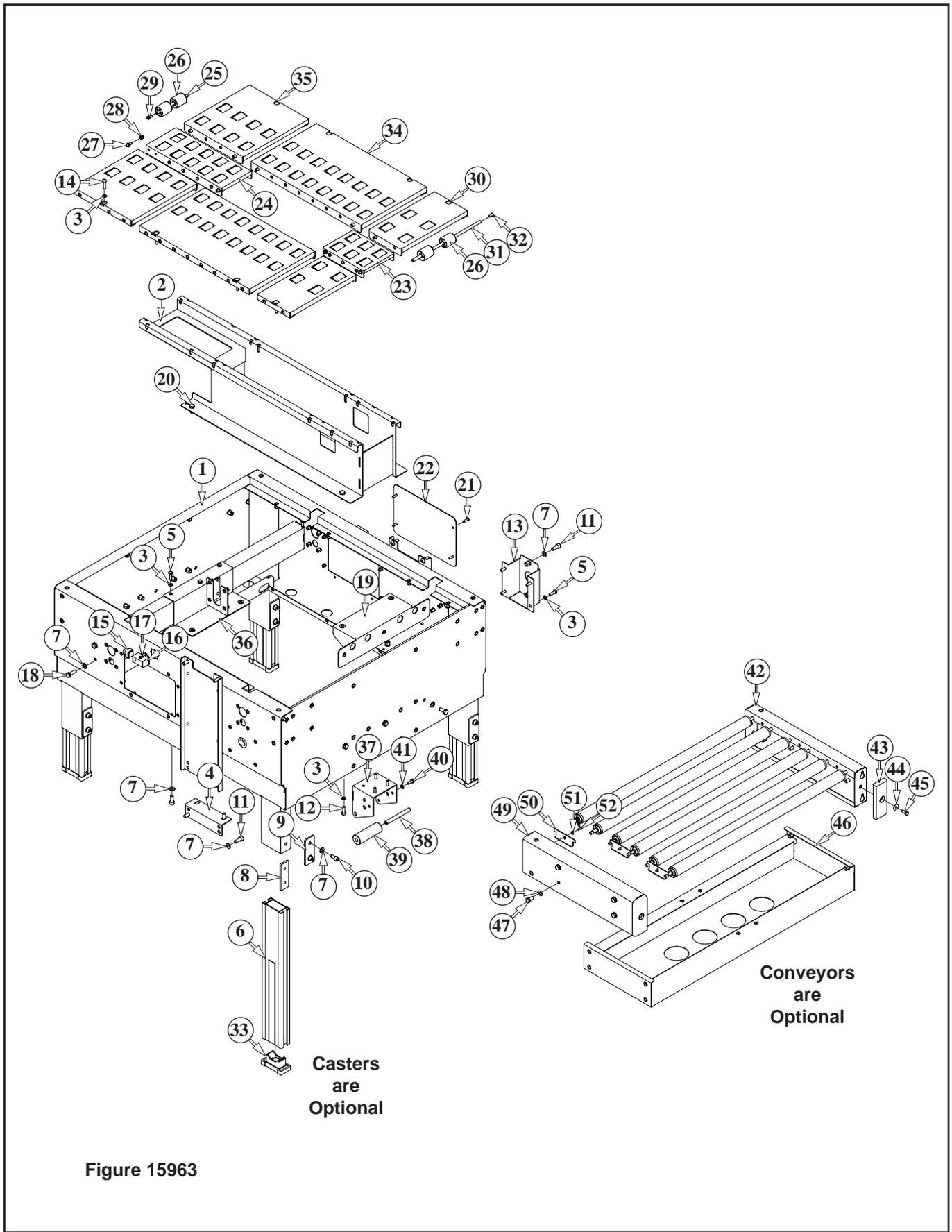


Figure 15963

Figure 15963

Ref. No.	3M Part No.	Description
15963-1	78-8137-8109-9	Bed Assy. w/Nutzers
15963-2	78-8137-8110-7	Support Assy. - Taping Unit
15963-3	26-1000-0010-3	Washer - M6 Flat
15963-4	78-8137-6295-8	Bracket - Fixed Column
15963-5	78-8010-7193-3	Screw - M6X20 Hex. Hd.
15963-6	78-8137-6287-5	Leg - Inner
15963-7	78-8017-9318-9	Washer - 8mm Plain
15963-8	78-8137-0635-1	Clamp - Leg
15963-9	78-8129-6100-7	Bracket
15963-10	26-1003-7963-0	Screw - M8X16 Soc. Hd.
15963-11	26-1003-7964-8	Screw - M8X20 Soc. Hd. Hex Soc. Dr.
15963-12	78-8010-7210-5	Screw - M6X20 Soc. Hd. Hex. Soc.
15963-13	78-8137-8111-5	Support - Housing
15963-14	78-8023-2334-1	Screw - M6X25 Soc. Hd. Hex. Soc.
15963-15	78-8060-7873-5	Plug - Female
15963-16	78-8060-7876-8	Cover - Plug
15963-17	78-8137-8026-5	Screw - 3, 9x8
15963-18	78-8017-9301-5	Screw - M8X25 Hex Hd.
15963-19	78-8137-7799-8	Shoulder Support - Lower Unit
15963-20	26-1003-5842-8	Screw - M8X20 Hex. Hd.
15963-21	78-8076-4625-8	Screw - M5X16 Special
15963-22	78-8137-6338-6	Support Plate - Housing
15963-23	78-8137-7775-8	Bed Plate - Rear Conveyor
15963-24	78-8137-7777-4	Bed Plate - Infeed Conveyor
15963-25	78-8137-7774-1	Pin - 8X124 Galvanized
15963-26	78-8060-7693-7	Roller - 32X38
15963-27	78-8076-5389-0	Mounting Hardware - Conveyor
15963-28	78-8091-0418-1	Nut - M6 Self-Locking
15963-29	26-1003-5820-4	Screw - M5X12 Hex Hd.
15963-30	78-8137-8044-8	Bed Plate - Infeed Right/Left Conveyor
15963-31	78-8137-7779-0	Pin - 8X271 Galvanized
15963-32	78-8017-9066-4	Screw - M5X12
15963-33	78-8137-0641-9	Pad - Foot
15963-34	78-8137-8045-5	Bed Plate - Infeed Conveyor Right/Left Roller
15963-35	78-8137-8046-3	Bed Plate - Rear Right/Left Roller
15963-36	78-8137-8113-1	Bracket - Support
15963-37	78-8137-8114-9	Bracket - Support
15963-38	78-8060-8484-0	Shaft - Roller
15963-39	78-8060-8485-7	Roller
15963-40	78-8032-0375-7	Screw - M6X16 Hex. Hd.
15963-41	26-1000-0010-3	Washer - M6Flat
15963-42	78-8137-7867-3	Frame - Infeed Right Shoulder w/Nutzers
15963-43	78-8076-4511-0	Cap - Front R/H
15963-44	78-8042-2919-9	Washer - Triple M6
15963-45	78-8032-0375-7	Screw - M6X16 Hex. Hd.
15963-46	78-8137-7855-8	Lower Plate - Roller Bed w/Nutzers
15963-47	26-1003-5841-0	Screw - M8X16
15963-48	78-8017-9318-9	Washer - 8mm Plain
15963-49	78-8137-7869-9	Frame - Infeed Left Shoulder w/Nutzers
15963-50	78-8076-4507-8	Bed Plate - Roller plane
15963-51	78-8005-5740-3	Washer - 4mm Plain Nick.
15963-52	78-8010-7157-8	Screw - M4X10 Hex. Hd.

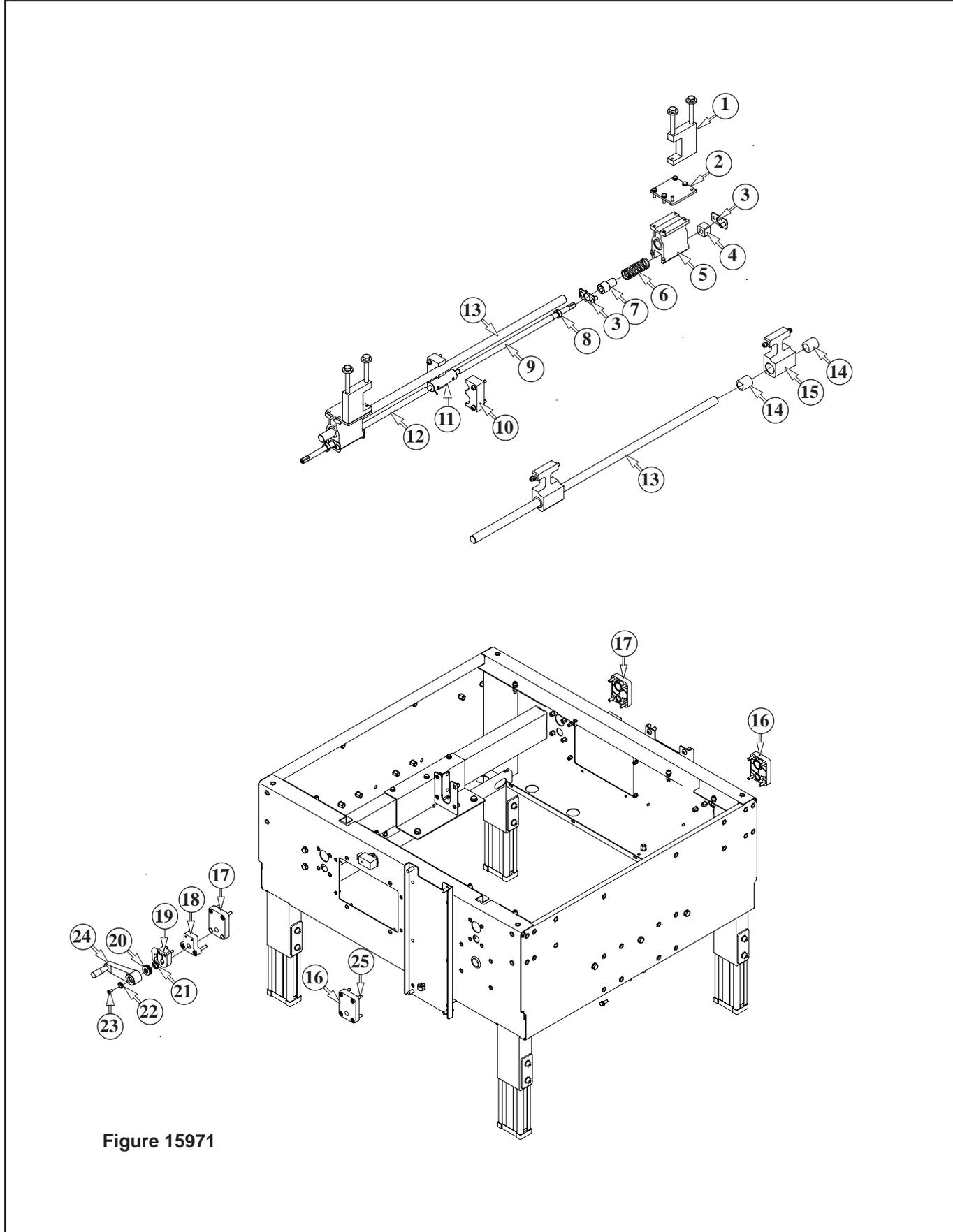


Figure 15971

Figure 15971

Ref. No.	3M Part No.	Description
15971-1	78-8137-8065-3	Block
15971-2	78-8137-8066-1	Plate
15971-3	78-8137-8067-9	Support Plate
15971-4	78-8137-8068-7	Nut
15971-5	78-8137-8069-5	Support
15971-6	78-8137-8070-3	Spring
15971-7	78-8137-8071-1	Support
15971-8	78-8129-6113-0	Bushing - 130CF-3M/S8 Centering Screw
15971-9	78-8137-8072-9	Screw - Right
15971-10	78-8137-8073-7	Block - Nylon
15971-11	78-8137-5915-2	Connection Sleeve - S8-CE 3"
15971-12	78-8137-8074-5	Screw - Left
15971-13	78-8137-7772-5	Rod - Guide
15971-14	78-8094-6230-8	Bearing Bushing - KH2030/P
15971-15	78-8137-8075-2	Support
15971-16	78-8137-8100-8	Rod Support - S11-T KYOWA S8
15971-17	78-8137-8076-0	Support
15971-18	78-8137-8077-8	Spacer
15971-19	78-8137-8078-6	Base - Locking Spindle BSA51-12 Elesä
15971-20	78-8060-7984-0	Spring - 12,2/25X0,9 Burnished
15971-21	78-8129-6116-3	Washer
15971-22	78-8060-8073-1	Washe - Motor
15971-23	26-0001-5862-1	Screw - M5X12 Flat Hd. Soc.
15971-24	78-8129-6118-9	Handle - "Elesä"
15971-25	78-8023-2334-1	Screw - M6X25 Soc. Hd. Hex Soc.

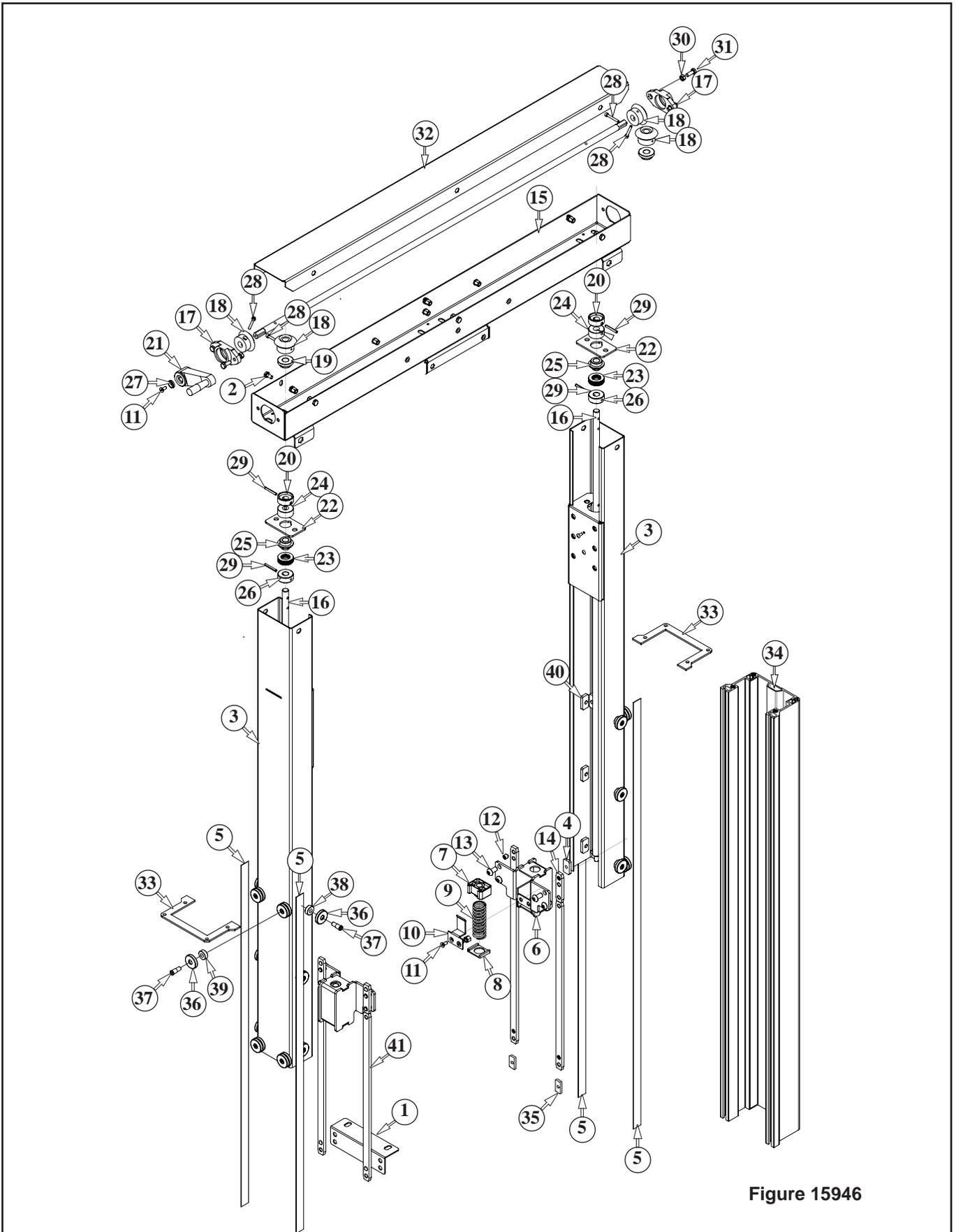


Figure 15946

Figure 15965

Ref. No.	3M Part No.	Description
15946-1	78-8137-7906-9	Bracket - Column
15946-2	78-8010-7169-3	Screw - M6X12 Hex Hd.
15946-3	78-8137-6335-2	Sliding Column Assembly
15946-4	78-8129-6311-0	Plate
15946-5	78-8137-6348-5	Label - Column
15946-6	78-8137-8038-0	Nut - Support Assembly
15946-7	78-8054-8571-7	Nut - Plastic
15946-8	78-8054-8970-1	Bed Plate - Spring
15946-9	78-8137-8037-2	Spring
15946-10	78-8137-6291-7	Plate - Nut
15946-11	26-0001-5862-1	Screw - M5X12 Flat Hd. Soc.
15946-12	78-8060-7889-1	Screw - M8X10 Set
15946-13	78-8129-6124-7	Screw - M8x16
15946-14	78-8137-6294-1	Plate - Nut Group
15946-15	78-8137-8039-8	Crossbar Cover w/Nutzers
15946-16	78-8137-7771-7	Screw - Lifting
15946-17	78-8129-6304-5	Support w/Bearing
15946-18	78-8137-5905-3	Pinion - Conic
15946-19	78-8060-8125-9	Bushing
15946-20	78-8129-6143-7	Bushing
15946-21	78-8129-6118-9	Handle
15946-22	78-8137-6333-7	Plate - Screw
15946-23	78-8054-8584-0	Bearing - Thrust O.D. 30mm
15946-24	78-8060-8497-2	Bushing - Lead Screw
15946-25	78-8054-8583-2	Bushing
15946-26	78-8054-8585-7	Collar
15946-27	78-8060-8073-1	Washer - Motor
15946-28	78-8060-7711-7	Screw - M4X30 Soc. Hd. Hex
15946-29	78-8054-8586-5	Pin
15946-30	78-8010-7418-4	Nut - M6 Metric Hex Steel
15946-31	78-8032-0375-7	Screw - M6X16 Hex Hd.
15946-32	78-8137-8040-6	Crossbar Cover w/Nutzers
15946-33	78-8137-6337-8	Cap - Column
15946-34	78-8137-6347-7	Column
15946-35	78-8137-0516-3	Plate
15946-36	78-8137-6388-1	Bearing - Polyamide Coated 33X6X7,5X8
15946-37	78-8129-6312-8	Screw - Bearing
15946-38	78-8129-6313-6	Washer - Galvanized
15946-39	78-8129-6314-4	Washer - Galvanized
15946-40	78-8129-6311-0	Plate - Tapped/Column Bearing
15946-41	78-8137-8139-6	Plate

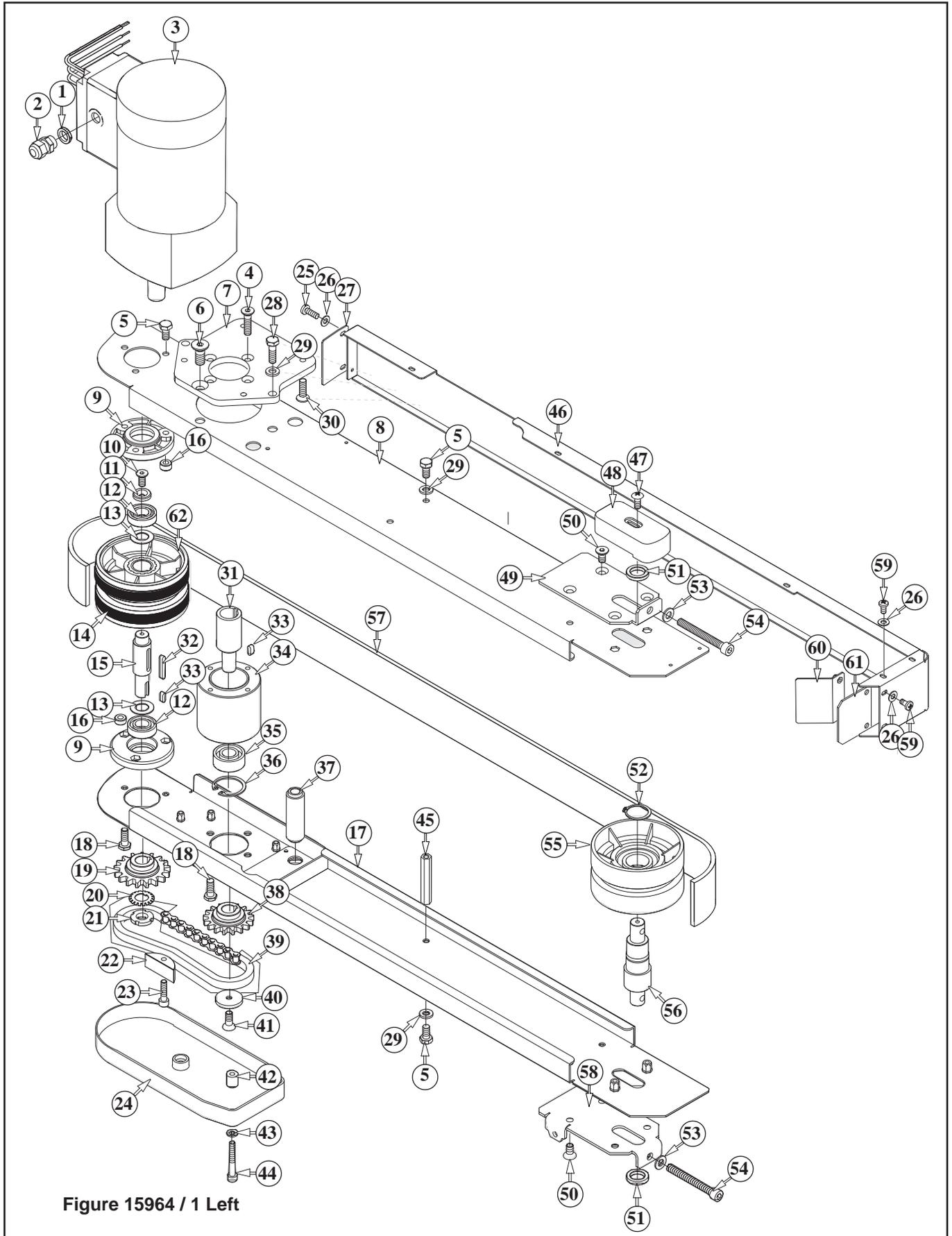


Figure 15964 / 1 Left

Figure 15964 / 1 Left

Ref. No.	3M Part No.	Description
15964-1	78-8129-6469-6	Nut
15964-2	78-8076-4532-6	Cord Grip
15964-3	78-8070-1522-3	Gearmotor 115V 60HZ
	26-1011-8828-7	Capacitor (only)
15964-4	78-8060-7918-8	Screw - Flat Soc. Hd. M6X25
15964-5	78-8060-7886-7	Screw - Hex Hd. M6X16 Special
15964-6	26-1003-5842-8	Screw - Hex Hd. M8X20
15964-7	78-8137-7996-0	Plate - Gearmotor
15964-8	78-8137-7997-8	Upper Guide - Right
15964-9	78-8114-4709-9	Support - Bearing
15964-10	26-0001-5862-1	Screw - Flat Hd. Soc. M5X12
15964-11	78-8054-8877-8	Washer - 5 5/20X4
15964-12	26-1000-4350-9	Radial Ball Bearing - 6002-2RS O.D. 32
15964-13	78-8055-0668-6	Washer - 15/26X1
15964-14	78-8052-6713-1	Ring - Polyurethane
15964-15	78-8055-0669-4	Shaft - Pulley Keyed
15964-16	78-8137-7936-6	Nutsert - M6 Galvanized
15964-17	78-8137-8004-2	Lower Guide - Right
15964-18	78-8060-7886-7	Screw - Hex Hd. M6X16 Special
15964-19	78-8137-0935-5	Sprocket 3/8" Z=20
15964-20	78-8057-5834-5	Tab - Washer
15964-21	78-8057-5835-2	Washer - Centering
15964-22	78-8137-3796-8	Tensioning - Belt
15964-23	26-1003-7951-5	Screw - Soc Hd. Hex Soc M5X20
15964-24	78-8137-0870-4	Cover - Left
15964-25	78-8017-9425-2	Screw - Self-Tapping 8X13mm
15964-26	78-8005-5740-3	Washer Plain - 4mm Nick.
15964-27	78-8137-8023-2	Cover
15964-28	78-8010-7193-3	Screw - M6X20 Hex Hd.
15964-29	26-1000-0010-3	Washer - Flat M6
15964-30	78-8137-8021-6	Screw - TSVEI 1/4 - 28 UNF X 3/4" - 10.9
15964-31	78-8137-8003-4	Shaft
15964-32	78-8057-5739-6	Key - M5X5X30mm
15964-33	78-8046-8135-7	Key - 5 X 5 12mm
15964-34	78-8137-8024-0	Support
15964-35	78-8137-7946-5	Adjustable Bearing 2202-2RS
15964-36	78-8137-7999-4	E-Ring D35
15964-37	78-8137-7761-8	Spacer - Drive Belt
15964-38	78-8137-0934-8	Pinion - Motor
15964-39	78-8137-7748-5	Chain - Closed Ring 3\8" 46 Pitch
15964-40	78-8054-8577-4	Washer - Special
15964-41	26-1001-9843-6	Screw - Flat Soc. Hd. M6X16
15964-42	78-8137-7760-0	Cover Bushing - Drive Belt S8-CE
15964-43	78-8005-5741-1	Washer - Flat M5
15964-44	26-1003-7954-9	Screw - Soc. Hd M5X35
15964-45	78-8055-0661-1	Spacer
15964-46	78-8137-8025-7	Right Cover
15964-47	78-8017-9066-4	Screw - M5X12
15964-48	78-8076-5448-4	Cover - Belt Tensioner
15964-49	78-8137-7756-8	Carriage - Belt Tensioner
15964-50	26-1002-5830-5	Screw - Hex Hd. M6X12
15964-51	78-8076-5446-8	Washer - Shaft
15964-52	12-7997-0272-0	E-Ring M-25
15964-53	78-8017-9318-9	Washer - Plain 8mm
15964-54	78-8070-1519-9	Screw - Soc. Hd. Hex Hd. M8X70
15964-55	78-8055-0660-3	Idler Pulley
15964-56	78-8076-5444-3	Shaft - Idler Pulley
15964-57	78-8076-5452-6	Belt - Box Drive
15964-58	78-8137-7757-6	Carriage - Belt Tensioner
15964-59	78-8137-8026-5	Screw - 3 9X8
15964-60	78-8137-8022-4	Plate - Motor Cover
15964-61	78-8100-1214-2	Guard - Rubber
15964-62	78-8076-5441-9	Motor Pulley

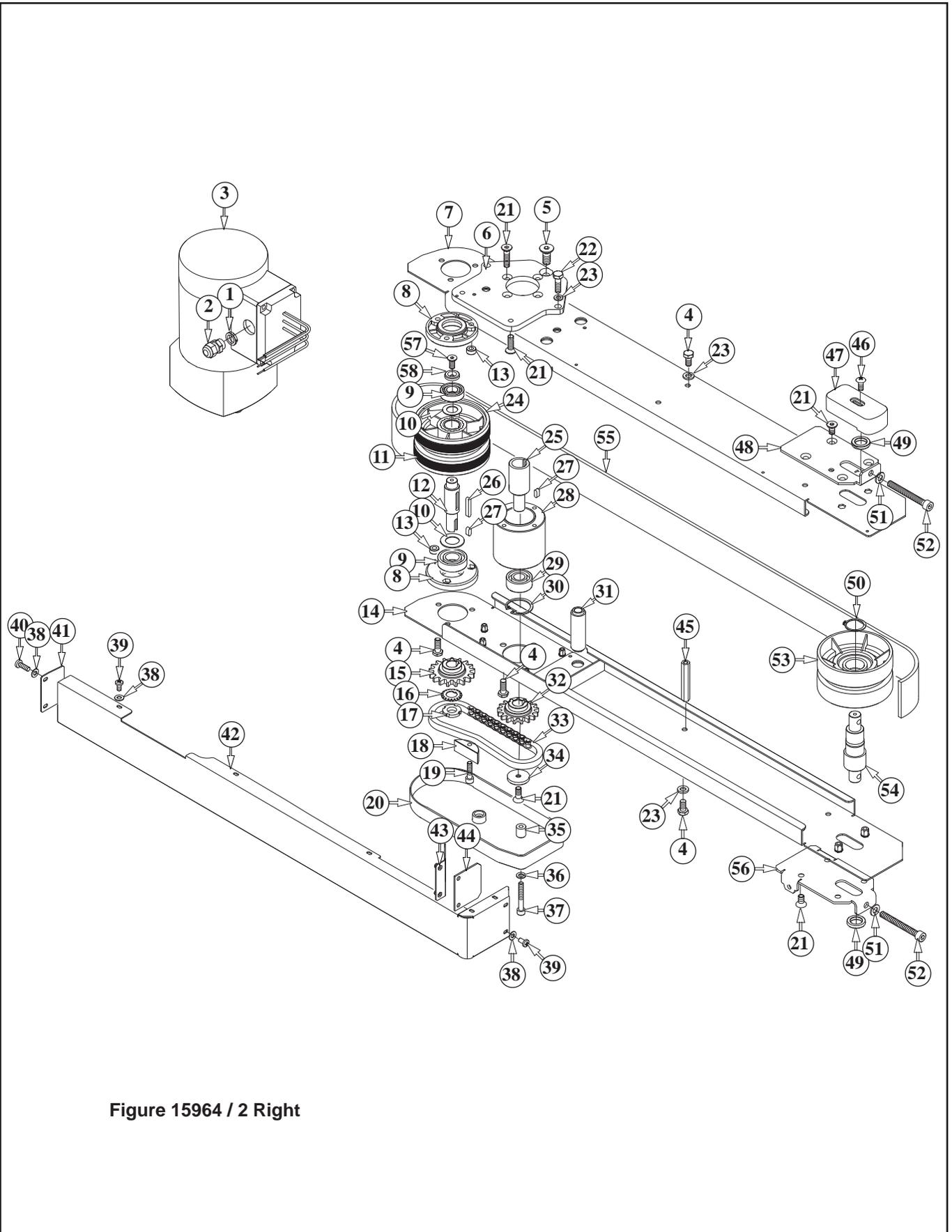


Figure 15964 / 2 Right

Figure 15964 / 2 Right

Ref. No.	3M Part No.	Description
15964-1	78-8129-6469-6	Nut
15964-2	78-8076-4532-6	Cord Grip
15964-3	78-8070-1522-3	Gearmotor 115V 60HZ
	26-1011-8828-7	Capacitor (only)
15964-4	78-8060-7886-7	Screw - Hex Hd. M6X16 Special
15964-5	26-1003-5842-8	Screw - Hex Hd. M8X20
15964-6	78-8137-7996-0	Plate - Gearmotor
15964-7	78-8137-7998-6	Upper Guide - Left
15964-8	78-8114-4709-9	Support - Bearing
15964-9	26-1000-4350-9	Radial Ball Bearing - 6002-2RS, O.D. 32
15964-10	78-8055-0668-6	Washer - 15/26X1
15964-11	78-8052-6713-1	Ring - Polyurethane
15964-12	78-8055-0669-4	Shaft - Keyed Pulley
15964-13	78-8137-7936-6	Nutsert - M6 Galvanized
15964-14	78-8137-8005-9	Lower Guide - Left
15964-15	78-8137-0935-5	Sprocket 3/8" Z=20
15964-16	78-8057-5834-5	Washer - Tab
15964-17	78-8057-5835-2	Washer - Centering
15964-18	78-8137-3796-8	Tensioning - Belt
15964-19	26-1003-7951-5	Screw - Soc. Hd. Hex Soc. M5X20
15964-20	78-8137-0870-4	Cover - Right
15964-21	78-8137-8021-6	Screw - TSVEI 1/4 - 28 UNF X 3/4" - 10.9
15964-22	78-8010-7193-3	Screw - M6X20 Hex Hd.
15964-23	26-1000-0010-3	Washer - Flat M6
15964-24	78-8076-5441-9	Motor Pulley
15964-25	78-8137-8003-4	Shaft
15964-26	78-8057-5739-6	Key - M5X5X30mm
15964-27	78-8046-8135-7	Key - 5 X 5 12mm
15964-28	78-8137-8024-0	Support
15964-29	78-8137-7946-5	Adjustable Bearing 2202-2RS
15964-30	78-8137-7999-4	E-Ring D35
15964-31	78-8137-7761-8	Spacer - Drive Belt
15964-32	78-8137-0934-8	Pinion - Motor
15964-33	78-8137-7748-5	Chain - Closed Ring 3\8" 46 Pitch
15964-34	78-8054-8577-4	Washer - Special
15964-35	78-8137-7760-0	Cover Bushing - Drive Belt S8-CE
15964-36	78-8005-5741-1	Washer - Flat M5
15964-37	26-1003-7954-9	Screw - Soc. Hd. M5X35
15964-38	78-8005-5740-3	Washer - Plain 4mm Nick.
15964-39	78-8137-8026-5	Screw - 3 9X8
15964-40	78-8017-9425-2	Screw - Self-Tapping 8X13Mm
15964-41	78-8137-8023-2	Cover
15964-42	78-8137-8027-3	Left Cover
15964-43	78-8137-8022-4	Plate - Motor Cover
15964-44	78-8100-1214-2	Guard - Rubber
15964-45	78-8055-0661-1	Spacer
15964-46	78-8017-9066-4	Screw - M5X12
15964-47	78-8076-5448-4	Cover - Belt Tensioner
15964-48	78-8137-7756-8	Carriage - Belt Tensioner
15964-49	78-8076-5446-8	Washer - Shaft
15964-50	12-7997-0272-0	E-Ring M-25
15964-51	78-8017-9318-9	Washer - Plain 8mm
15964-52	78-8070-1519-9	Screw - Soc. Hd. Hex Hd. M8X70
15964-53	78-8055-0660-3	Idler Pulley
15964-54	78-8076-5444-3	Shaft - Idler Pulley
15964-55	78-8076-5452-6	Belt - Box Drive
15964-56	78-8137-7757-6	Carriage - Belt Tensioner
15964-57	26-0001-5862-1	Screw - Flat Hd. Soc. M5X12
15964-58	78-8054-8877-8	Washer - 5 5/20X4

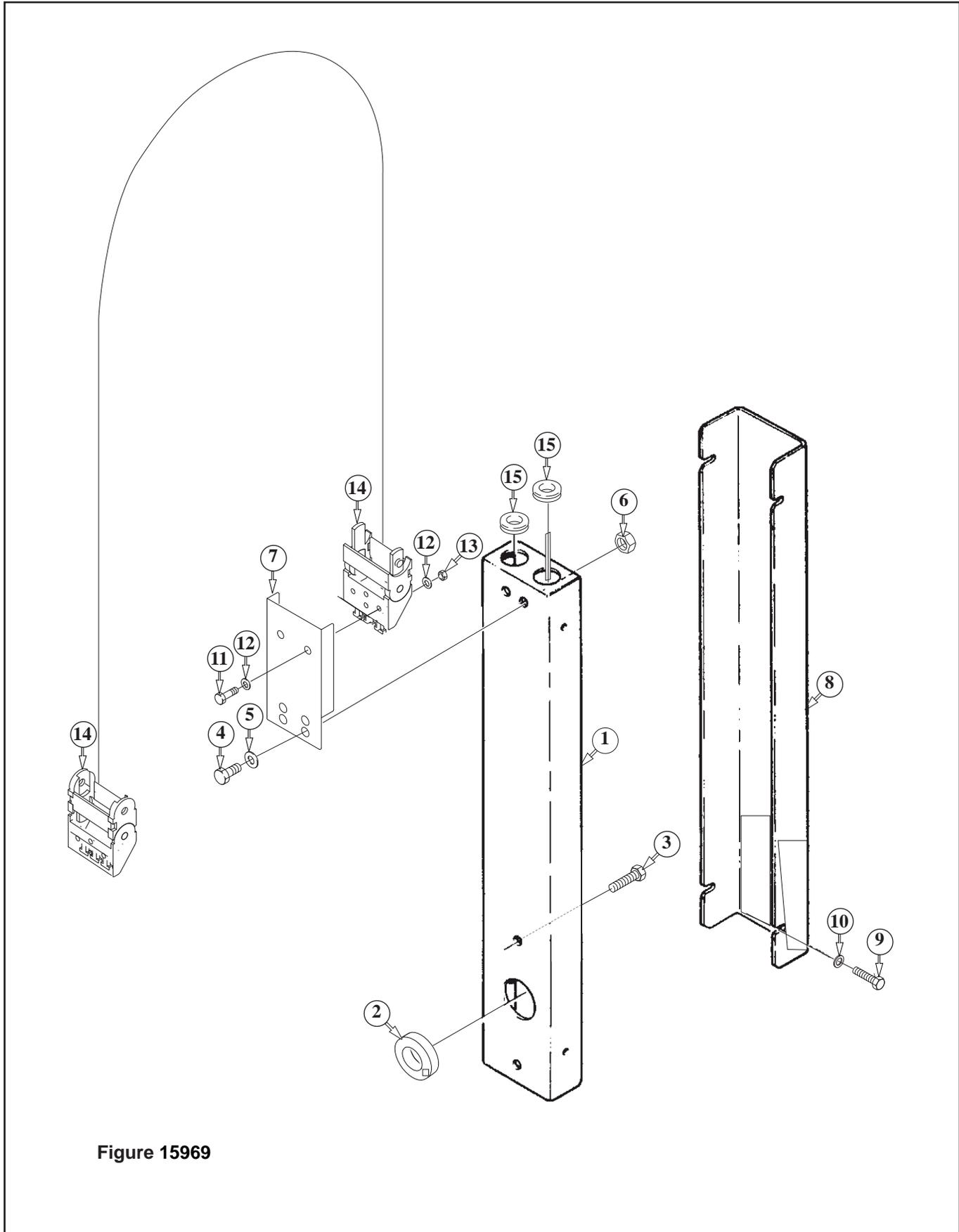


Figure 15969

Figure 15969

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
15969-1	78-8137-7805-3	Housing
15969-2	78-8076-4702-5	Grommet
15969-3	26-1003-7963-0	Screw - M8X16 Soc. Hd.
15969-4	78-8010-7163-6	Screw - M5X10 Hex Hd.
15969-5	78-8005-5741-1	Washer - M5 Flat
15969-6	78-8010-7417-6	Nut - M5 Hex Steel
15969-7	78-8137-7852-5	Bracket - Cable Chain
15969-8	78-8137-7853-3	Cover - Grey Housing
15969-9	78-8010-7157-8	Screw - M4X10 Hex Hd.
15969-10	78-8017-9018-5	Washer - M4 Special
15969-11	78-8060-7826-3	Screw - M4X16 Hex Hd.
15969-12	78-8005-5740-3	Washer Plain - 4mm Nickel
15969-13	78-8010-7416-8	Nut - M4 Hex/ Steel
15969-14	78-8137-7824-4	Chain
15969-15	78-8060-7758-8	Grommet

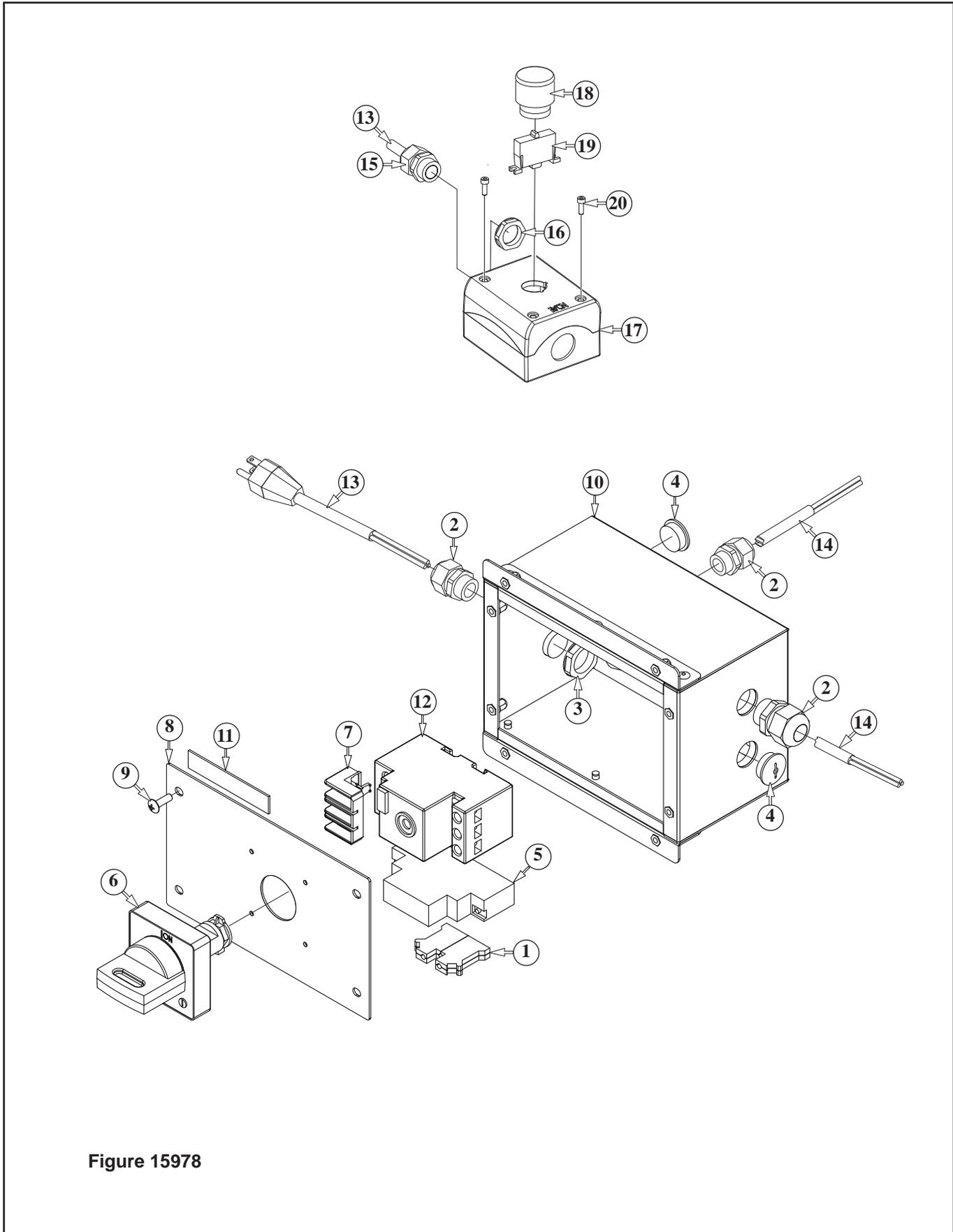


Figure 15978

## Figure 15978

Figure 15978

Ref. No.	3M Part No.	Description
15978-1	78-8094-6384-3	Clamp - 6 1492-WG6 - Ground
15978-2	78-8137-0607-0	Fitting - M20X1.5
15978-3	78-8129-6469-6	Nut - M20X1.5
15978-4	78-8137-0796-1	Plug
15978-5	78-8137-0604-7	Coil - Under Voltage
15978-6	78-8137-0606-2	Handle - Door Coupling
15978-7	78-8137-0782-1	Phases Spacer
15978-8	78-8137-8090-1	Cover - Electrical Box
15978-9	78-8137-7968-9	Screw - M5X16 - Galvanized
15978-10	78-8137-7976-1	Box - Electrical
15978-11	78-8119-8554-4	Adhesive Rubber Seal
15978-12	78-8137-0780-5	Motor Protection
15978-13	78-8028-7909-4	Power Cord Assembly
15978-14	78-8137-5956-6	Cable
15978-15	78-8060-7785-1	Fitting
15978-16	78-8129-6469-6	Nut - M20 x 1.5 - Special
15978-17	78-8137-7893-9	Housing - Black M22-IY1
15978-18	78-8137-6353-5	Emergency Button
15978-19	78-8137-0797-9	Terminal Switch
15978-20	78-8060-8413-9	Screw - M4 x 12 Soc. Hd.



## Instructions and Parts List

# 3M-Matic™ Accuglide™ 3

Type 11400

## Upper and Lower High Speed Taping Heads 2 Inch

Serial #: \_\_\_\_\_  
*For reference, record machine serial number here.*

### Important Safety Information

BEFORE INSTALLING OR OPERATING THIS EQUIPMENT  
Read, understand and follow all safety and operating instructions.

### Spare Parts

It is recommended you immediately order the spare parts listed in the “Spare Parts/Service Information” section. These parts are expected to wear through normal use, and should be kept on hand to minimize production delays.



# Replacement Parts and Service Information

## To Our Customers:

This is the 3M-Matic™/AccuGlide™/Scotch® equipment you ordered. It has been set up and tested in the factory with Scotch® Tapes. If technical assistance or replacement parts are needed, call or fax the appropriate number listed below.

Included with each machine is an Instructions and Parts List manual.

## Technical Assistance/Replacement Parts and Additional Manuals:

Contact your local service provider 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: Accuglide 3 - 2 inch - Type 11400 - Serial Number 13282).

**3M Tape Dispenser Parts**  
**241 Venture Drive**                      **1-800-344-9883**  
**Amery, WI 54001-1325**                      **Fax: 1-715-268-8153**

### Identification Plate

<b>3M</b> 3M Company St. Paul, MN 55144 USA	Part Number <input type="text"/>	<b>3M-Matic™</b> For Commercial Use Only			
Model <input type="text"/>	Serial Number <input type="text"/>	Year <input type="text"/>	Ampere <input type="text"/>	Watt <input type="text"/>	
Type <input type="text"/>		Volt <input type="text"/>	Hertz <input type="text"/>	Phase <input type="text"/>	

**Minimum billing on parts orders will be \$25.00.**  
**Replacement part prices available on request.**  
**\$10.00 restocking charge per invoice on returned parts.**



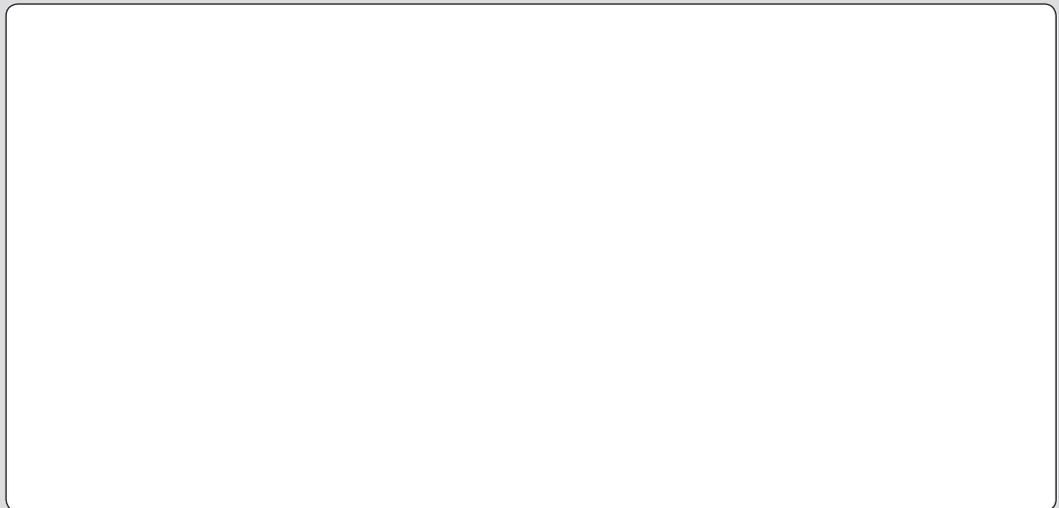
## Replacement Parts and Service Information *(continued)*

### **To Our Customers:**

This is the 3M-Matic™/AccuGlide™/Scotch® equipment you ordered. It has been set up and tested in the factory with Scotch® tapes. If any problems occur when operating this equipment and you desire a service call or phone consultation, call, write, or fax the appropriate number listed below.

Included with each machine is an Instructions and Parts List Manual.

**Service, replacement parts, and additional manuals available direct from:**



Order parts by part number, part description, and quantity required. Also, when ordering parts or additional manuals, include model/machine name, machine type, and serial number that are located on the identification plate.



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(Upper and Lower Taping Heads)

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# Warranty

## Warranty

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

3M sells its **3M-Matic™ Accuglide 3 Taping Head, Type 11400** with the following warranties:

1. The Taping Head blade, springs and rollers will be free from defects in material and manufacture for ninety (90) days after delivery.
2. All other Taping Head parts will be free from defects in material and manufacture for three (3) years after delivery.

If any part is defective within this warranty period, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to repair or replace the part. 3M must receive actual notice of any alleged defect within a reasonable time after it is discovered, but in no event shall 3M have any obligation under this warranty unless it receives such notice within five (5) business days after the expiration of the warranty period.

All notices required hereunder shall be given to 3M solely through the 3M-Matic™ Help line (800-328-1390). To be entitled to repair or replacement as provided under this warranty, the part must be returned as directed by 3M to its factory or other authorized service station designated by 3M. If 3M is unable to repair or replace the part within a reasonable time after receipt thereof, 3M, at its option, will replace the equipment or refund the purchase price. 3M shall have no obligation to provide or pay for the labor required to remove any part or equipment or to install the repaired or replacement part or equipment. 3M shall have no obligation to repair or replace those parts failing due to normal wear, inadequate or improper maintenance, inadequate cleaning, non-lubrication, improper operating environment, improper utilities, operator error or misuse, alteration or modification, mishandling, lack of reasonable care, or due to any accidental cause.

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

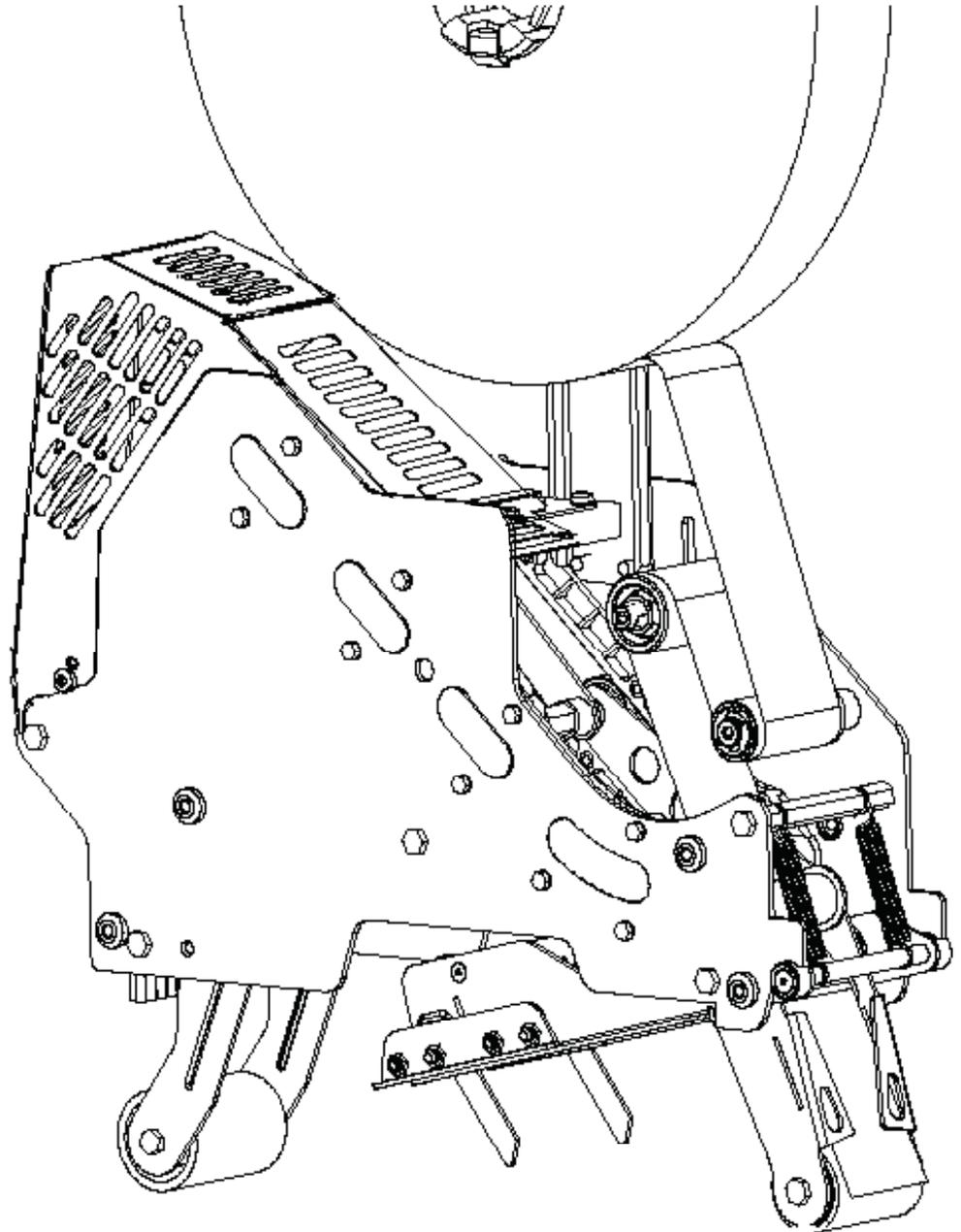
**Note:** The foregoing Equipment Warranty and Limited Remedy and Limitation of Liability may be changed only by a written agreement signed by authorized representatives of 3M and seller.

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

## Intended Use

The intended use of the AccuGlide™ 3 Upper and Lower Taping Heads - 2 Inch is to apply a “C” clip of Scotch® pressure-sensitive film box sealing tape to the top and/or bottom center seam of regular slotted containers.

These taping heads are incorporated into most standard 3M-Matic™ case sealers. The compact size and simplicity of the taping head also makes it suitable for mounting in box conveying systems other than 3M-Matic™ case sealers. This includes replacement of other types of taping, gluing or stapling heads in existing case sealing machines. The AccuGlide™ 3 Upper and Lower Taping Heads - 2 Inch have been designed and tested for use with Scotch® pressure-sensitive film box sealing tape.



**AccuGlide™ 3 Upper Taping Head - 2 inch, Type 11400**



# Taping Head Contents

**AccuGlide™ 3 High Speed - 2 Inch Upper and Lower Taping Heads consist of:**

<b>Qty.</b>	<b>Part Name</b>
1	Taping Head Assembly
1	Tape Drum and Bracket Assembly
1	Hardware and Spare Parts Kit
1	Threading Tool

## General Information

This instruction manual covers safety aspects, handling and transport, storage, unpacking, preparation, installation, operation, set-up and adjustments, technical and manufacturing specifications, maintenance, troubleshooting, repair work and servicing, electric diagrams, warranty information, disposal (ELV), a glossary with a definition of symbols, plus a parts list of the 3M-Matic™ AccuGlide 3 (2 inch) 3M Industrial Adhesives and Tapes Division 3M Center, Bldg. 220-5E-06 St. Paul, MN 55144-1000 (USA) Edition April 2016/ Copyright 3M 2016. All rights reserved The manufacturer reserves the right to change the product at any time without notice.

## How to use this Manual

The manual is an important part of the machine; all information contained herein is intended to enable the equipment to be maintained in perfect condition and operated safely. Ensure that the manual is available to all operators of this equipment and the manual is kept up to date with all subsequent amendments. Should the equipment be sold or disposed of, please ensure that the manual is passed on with the machine. Electrical and pneumatic diagrams are included in the manual. Equipment using PLC controls and/or electronic components will include relevant schematics or programs in the enclosure (or will be delivered separately as needed)

Keep the manual in a clean and dry place near the machine. Do not remove, tear or rewrite parts of the manual for any reason. Use the manual without damaging it. However, if the manual has been lost or damaged, ask your after sale service for a new copy (if it is possible, please have the manual name, part number, and revision information and/or model/machine name, machine type, and serial number) that are located on the identification plate (**For example: Model - AccuGlide 3 - 2" - Type 11400 - Serial Number 13282**).

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



## Updating the Manual

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

# Important Safeguards

## Explanation of Signal Word and Possible Consequences



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



**Caution**

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



**Warning**

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



### **WARNING**

- To reduce the risk associated with mechanical hazards
- Read, understand and follow all safety and operating instructions before operating or servicing the case sealer
- Allow only properly trained and qualified personnel to operate and or service this equipment



### **CAUTION**

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



### **WARNING**

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



### **WARNING**

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

(Important Safeguards *continued* on next page)

# Important Safeguards *(continued)*

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

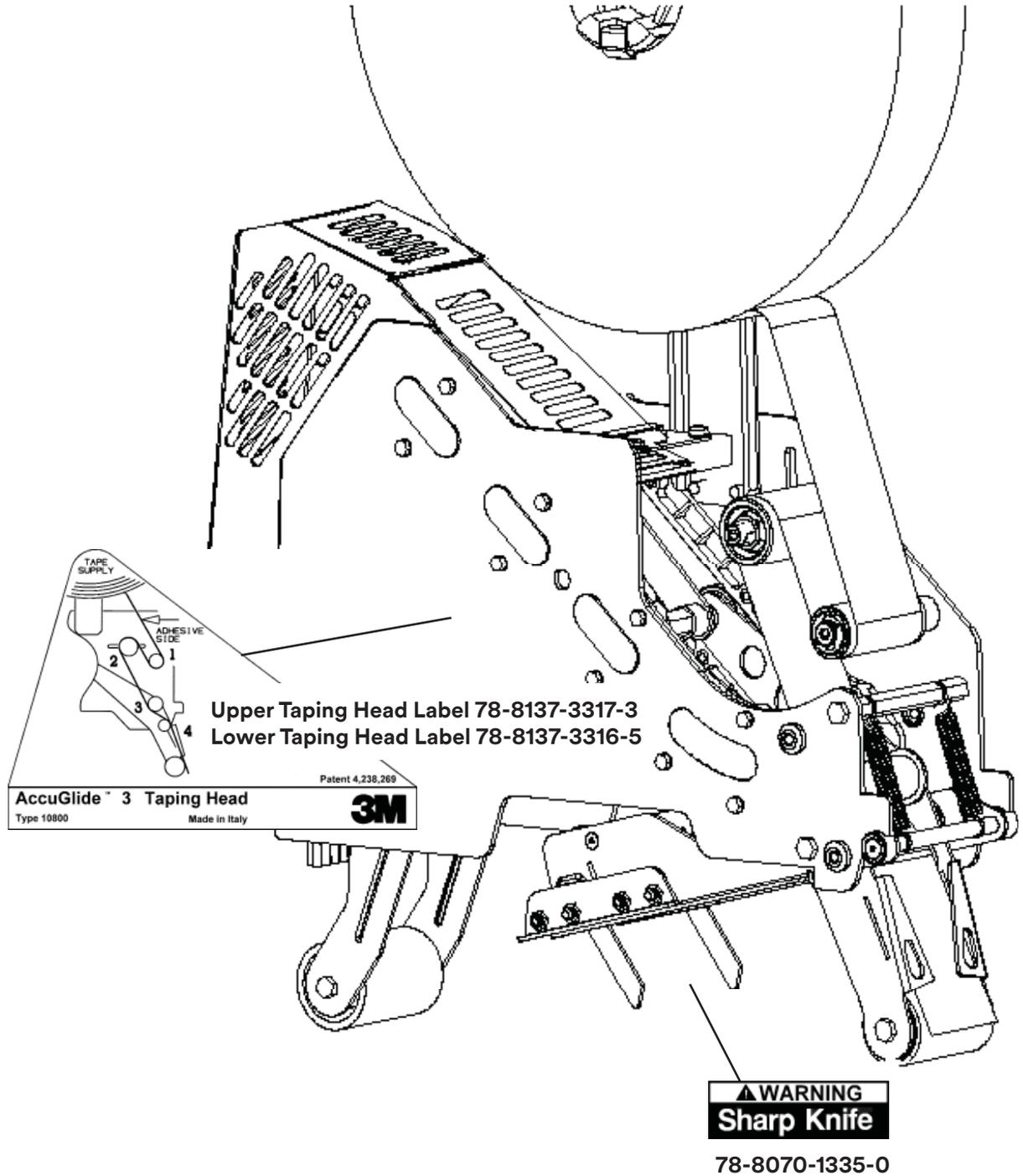


Figure 1-1 Replacement Labels/3M Part Numbers

# Specifications

**1. Tape:**

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

**2. Tape Width:**

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

**3. Tape Roll Diameter:**

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

**4. Tape Application Leg Length - Standard:**

70mm ± 6mm [2-3/4 inches ±1/4 inch]

**Tape Application Leg Length - Optional:**

50mm ± 6mm [2 inches ± 1/4 inch] (See “Adjustments – Tape Leg Length.”)

**5. Box Size Capacities:**

For use with center seam regular slotted containers.

When upper and lower taping heads are used on “**3M-Matic**” case sealers, refer to the respective instruction manual specifications for box weight and size capacities.

**6. Operating Rate:**

Conveyor speeds up to 0.5 m/s [100 feet per minute].

**7. Operating Conditions:**

Use in dry, relatively clean environments at 5° to 40°C [40° to 105°F] with clean dry boxes.

**Important** – Taping heads should not be washed down or subjected to conditions causing moisture condensation on components.

**8. Taping Head Dimensions:**

Length – 442mm [17 3/8 inches]

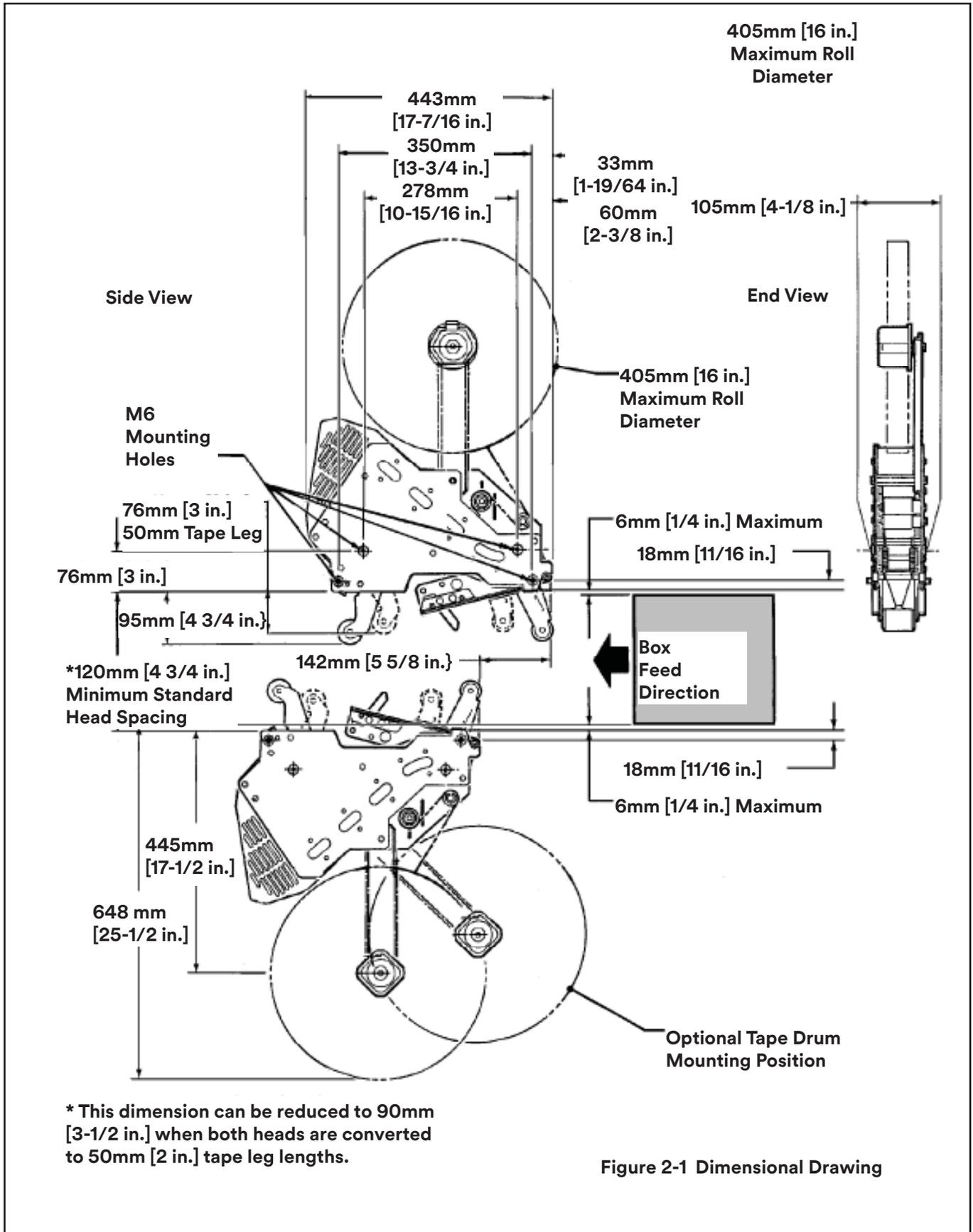
Height – 648mm [25 1/2 inches] (with tape drum)

Width – 105mm [4-1/8 inches] (without mounting spacers)

Weight – Packaged: 8.6kg [19 lbs.] Unpackaged: 7.7kg [17 lbs.]

(Specifications *continued* on next page.)

**Specifications** (continued)



**Figure 2-1 Dimensional Drawing**

# Installation



## WARNING

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

### Receiving And Handling

After the taping head assembly has been unpackaged, examine the unit for damage that might have occurred during transit. If damage is evident, file a damage claim immediately with the transportation company and also notify your 3M Representative.

### Installation Guidelines

The taping head assembly can be used in converting existing or in custom made machinery.

It can be mounted for top taping or bottom taping. Refer to “Box Size Capacities,” as well as **Figure 2-1** in the Specifications section, for following points making installations:

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

1. The box conveying system must positively propel the box in a continuous motion, not exceeding 0.40 m/s [80 feet per minute], past the taping head assembly since the box motion actuates the taping mechanism.



## CAUTION

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

2. If a pusher/cleated conveyor is used, steps should be taken in conveyor to prevent pusher from contacting applying or buffing roller arms (resulting in damage to taping head).
3. **Figure 2-1** illustrates the typical mounting relationship for opposing taping head assemblies to allow taping of box heights down to 90mm [3-1/2 inches]. To tape box heights down to 70mm [2-3/4 inches], the taping heads must be completely staggered so only one tape seal is being applied at one time.
4. Mounting studs are provided with the taping head, but special installations may require alternate mounting means.
5. Box hold-down/guide skis should be provided and taping head mounted so that side plates are 6mm [1/4 inch] maximum away from the ski surface on which the box rides.

**Note** – AccuGlide™ 3 High Speed Upper Taping Head is supplied with a buffing arm guard. Adjustments to guard may be required to install taping head into some older design case sealers.

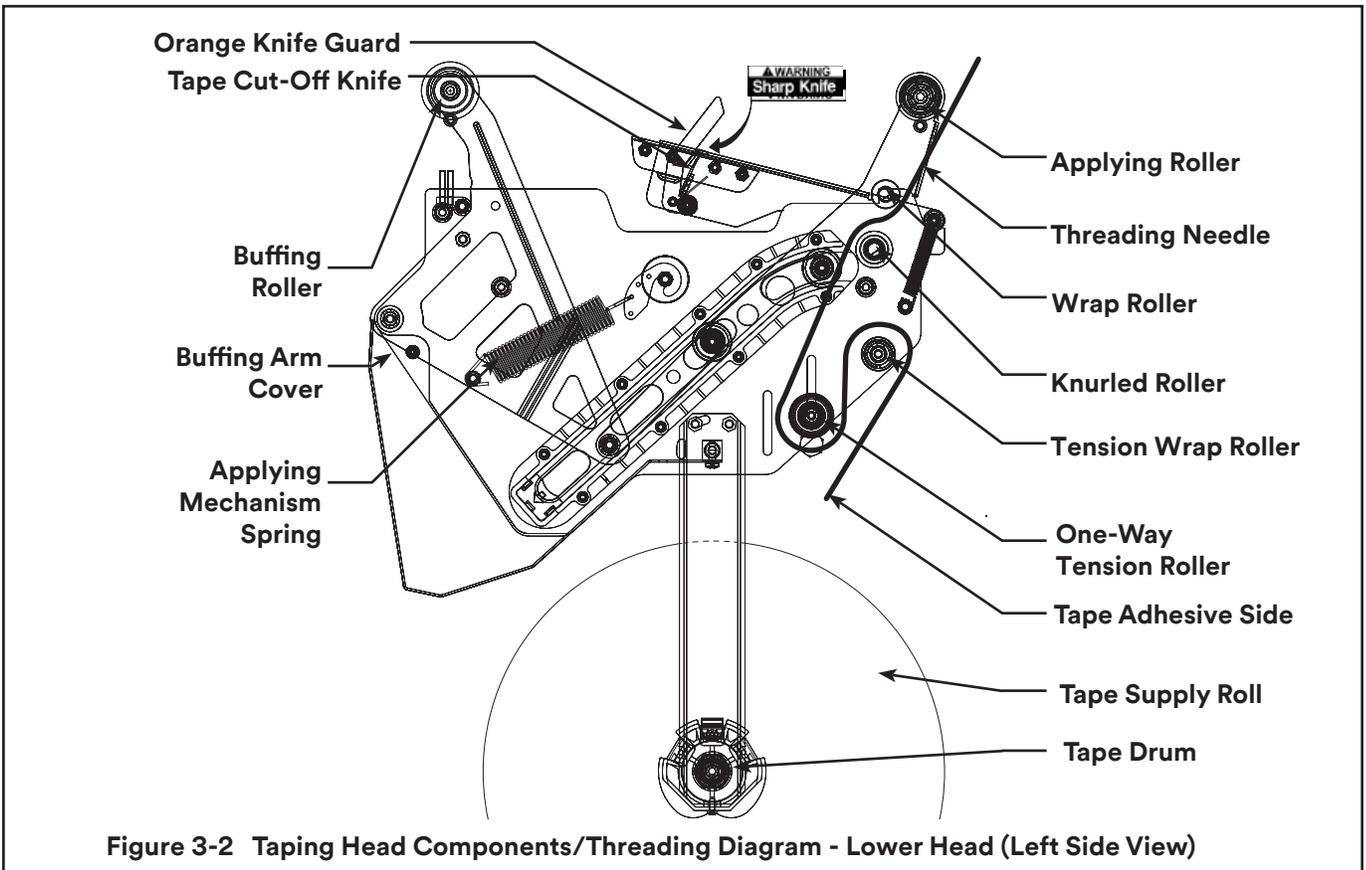
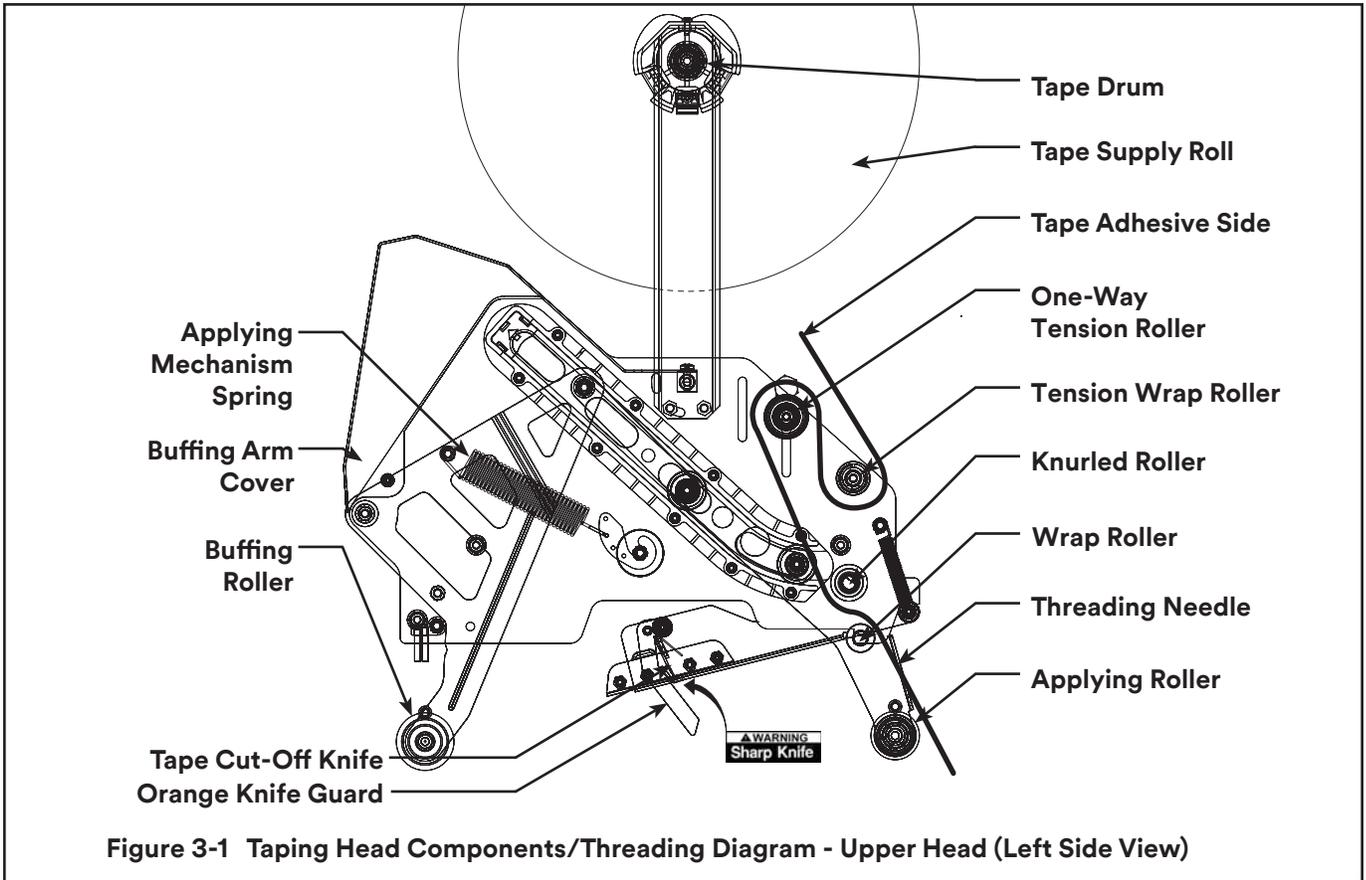
### Tape Leg Length

Taping heads are factory set to apply standard 70mm [2-3/4 inch] tape legs. The heads can be converted to apply 50mm [2 inch] tape legs if but both upper and lower heads must be set to apply the same tape leg length. See “Adjustments – Changing Tape Leg Length from 70 to 50mm [2-3/4 to 2 Inches].” Also, conveyor speed at which the product moves through taping heads affects the leading and trailing tape leg length. See “Adjustments section - Leading Tape Leg Length Adjustment.”

### Tape Width Adjustment

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

# Operation





## WARNING

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

It is recommended that the detailed instructions and sketches in this manual be referred to the first few times the taping head is loaded/threaded until the operator becomes thoroughly familiar with the tape loading operation.

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

### Tape Loading – Upper Taping Head

1. Place the upper taping head in a convenient working position.
2. Use **Figures 3-3/3-5** and tape threading label. Position tape roll so adhesive side of tape faces front of taping head as it's pulled from supply roll.
3. Attach the threading needle to the end of the roll. Guide the threading needle around the wrap roller (Position 1) then back around the one-way tension roller (Position 2).
4. Continue pulling the threading needle down and guide it between the two rollers on the apply arm (Position 3).
5. Pull threading needle down until tape travels between apply plate and ears of apply arm (Position 4) until extends past apply roller. When threaded adhesive side of tape should face knurled rollers at position 2 and also position 3.
6. Cut away any excess tape.

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

### Tape Loading – Lower Taping Head

1. Remove the lower taping head from the conveyor bed or associated equipment and place it a convenient working position.
2. Lower taping head is loaded and threaded in same manner as upper head.



## WARNING

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

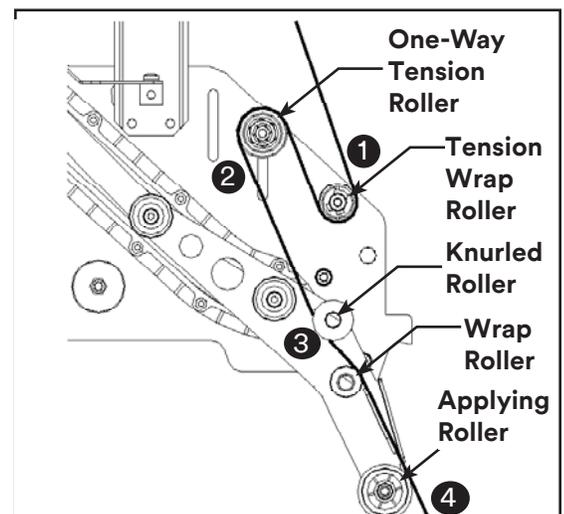


## CAUTION

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

**Figure 3-3**

Insert threading needle through rollers in direction indicated by arrows.



**Figure 3-3** Tape Loading/Threading

## Operation *(continued)*

**Figure 3-4**

Place tape roll on tape drum to dispense tape with adhesive side forward. Seat tape roll fully against back flange of drum. Adhere tape lead end to threading needle as shown.

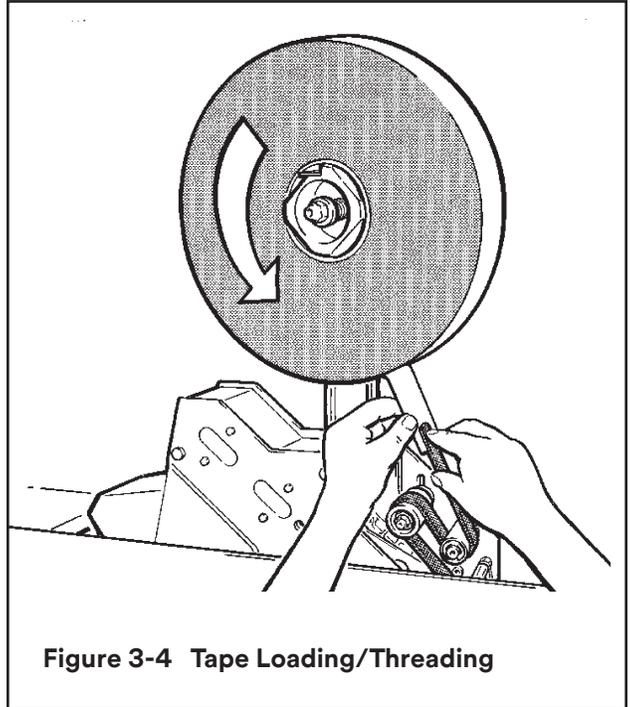
Manually turn tape roll to create slack tape while pulling threading needle through tape applying mechanism until needle is through and tape is in alignment with applying roller.

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

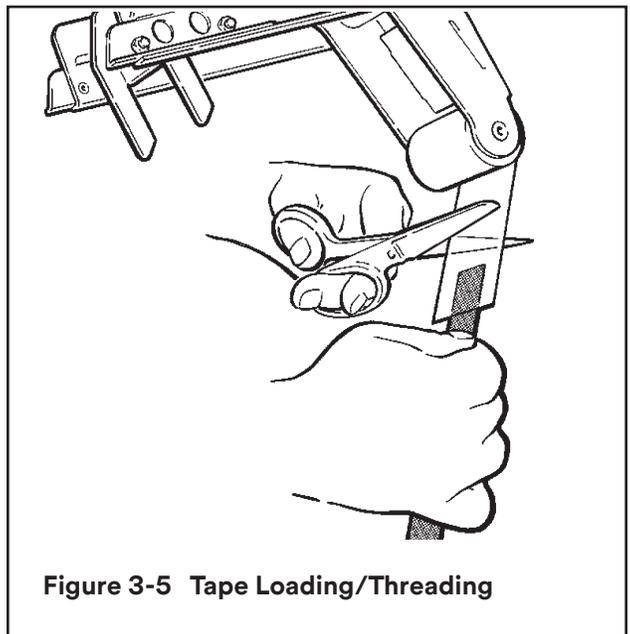


### **WARNING**

- 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.



**Figure 3-4** Tape Loading/Threading



**Figure 3-5** Tape Loading/Threading

# Maintenance

The AccuGlide™ 3 High Speed 2 Inch Taping Head has been designed for long, trouble free service. The taping head will perform best when it receives routine maintenance and cleaning. Taping head components that fail or wear excessively should be promptly repaired or replaced to prevent damage to other portions of the head or to the product.

## Blade Replacement, Upper and Lower Taping Heads – Figure 4-1

1. Loosen, but do not remove, the blade screws (A). Remove and discard old blade.
2. Mount the new blade (B) with the beveled side away from the blade holder.
3. Bottom the blade slots against the screws (this will position the blade at the correct angle.) Tighten the blade screws to secure the blade.

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

## Blade Guard

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

## Blade Oiler Pad

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

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



## WARNING

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

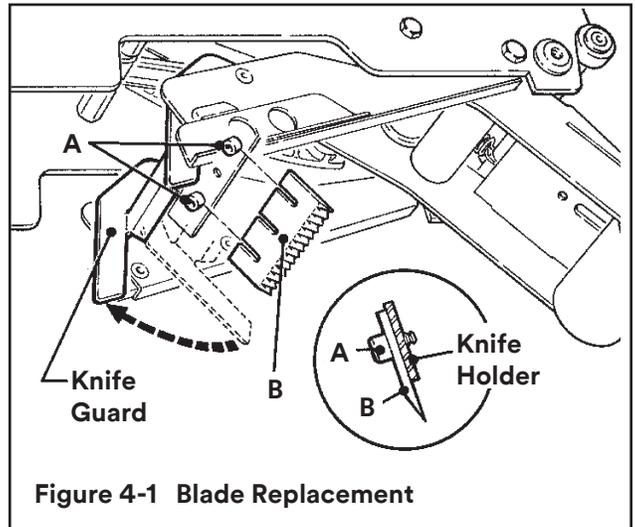


Figure 4-1 Blade Replacement



## WARNING

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

(Maintenance *continued* on next page.)

# Maintenance *(continued)*

## Cleaning

Regular slotted containers produce a great deal of dust and paper chips when conveyed through taping heads. If this dust is allowed to build-up on the heads, it can cause wear on the moving parts. Excessive dirt build-up should be wiped off with a damp cloth. Cleaning should be done once per month, depending on the number and type of boxes used. If the boxes used are dirty, or if the environment in which the heads operate is dusty, cleaning on a more frequent basis may be necessary.

**Note** – Never attempt to remove dirt from taping heads by blowing it out with compressed air. This can cause the dirt to be blown inside components onto sliding surfaces. Dirt in these areas can cause serious equipment damage. Never wash down or subject taping heads to conditions causing moisture condensation on components. Serious equipment damage could result.

## Applying/Buffering Roller Replacement

Replacing roller requires removal of shaft and mounting screws. With no area on the shaft to grip, the shaft often turns when attempting to remove the second screw. To ease removal of second screw, a 5mm hex socket has been provided at the bottom of the threads in both ends of the shaft. Insert a 4mm hex key wrench into this socket after removing one screw to hold the shaft for removal of the second screw. See **Figure 4-2**.



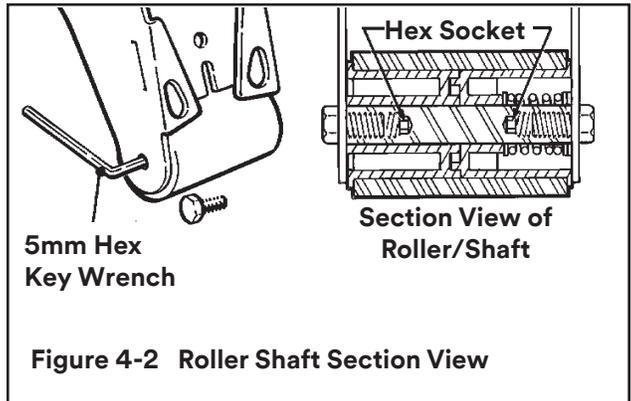
## WARNING

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



## WARNING

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



5mm Hex Key Wrench

Section View of Roller/Shaft

Figure 4-2 Roller Shaft Section View

# Adjustments

## Tape Latch Alignment – Figure 5-1

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

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

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

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

1. Loosen locking hex nut behind tape drum bracket on tape drum shaft. Use an adjustable wrench or 25mm open end wrench.
2. Using 5mm Hex Wrench, turn tape drum shaft in/out to center tape web.
3. Tighten locking hex nut to secure the adjustment.

No other components require adjustment for tape web alignment.

## Tape Drum Friction Brake – Figure 5-3

The tape drum friction brake on taping head is pre-set for normal operation to prevent tape roll over travel. Should tension adjustment be required, turn self-locking nut on shaft to vary spring compression. Turn nut clockwise to increase braking force, and counterclockwise to decrease braking force.

Adjust brake to minimum tension to prevent tape roll over travel.

**Note** – Excess braking force will cause poor tape application and may lead to tape tabbing on trailing tape leg.

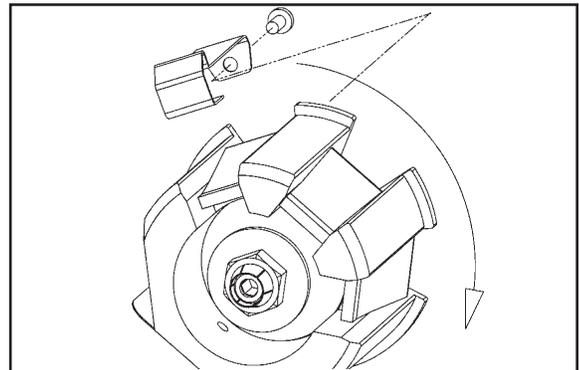


Figure 5-1 Tape Latch Alignment

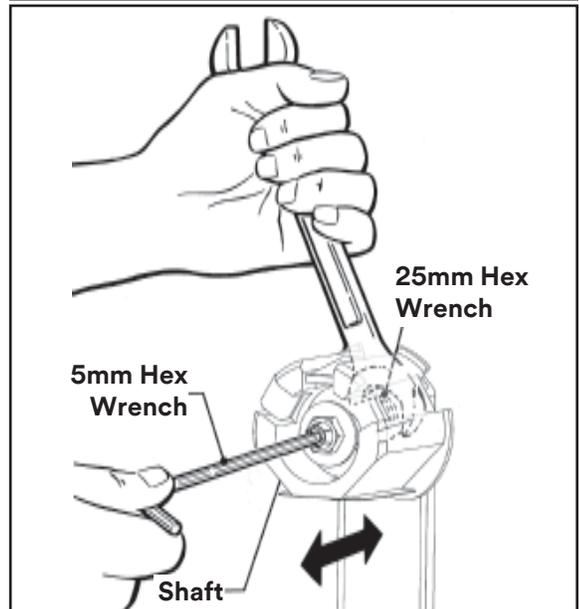


Figure 5-2 Tape Web Alignment

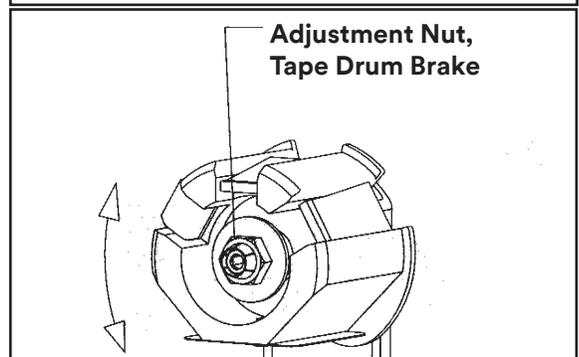


Figure 5-3 Tape Drum Friction Brake



## WARNING

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

(adjustments *continued* on next page.)

## Adjustments *(continued)*

### Applying Mechanism Spring

To obtain access to spring, remove taping head cover (four mounting screws). Replace cover to finish.

The applying mechanism spring, shown in **Figures 5-4A and 5-4B**, controls applying/buffing roller pressure on box and returns the mechanism to reset position. The spring pressure is pre-set, as shown in **Figure 5-4A** for normal operation, but is adjustable. If a tape gap appears on trailing surface of box increase spring pressure. If front of box is being crushed by applying roller decrease spring pressure. Removing spring end loop from spring holder and placing loop in other holes provided to adjust spring pressure (see **Figure 5-4B**).

### One-Way Tension Roller Figure 5-5

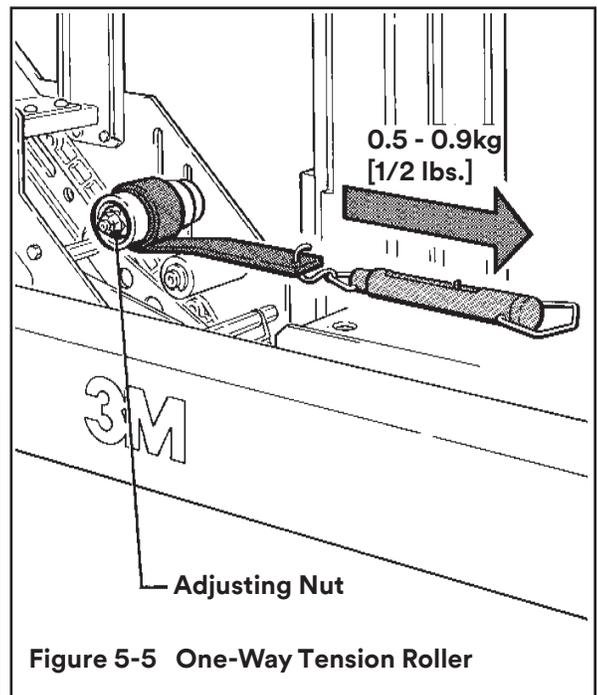
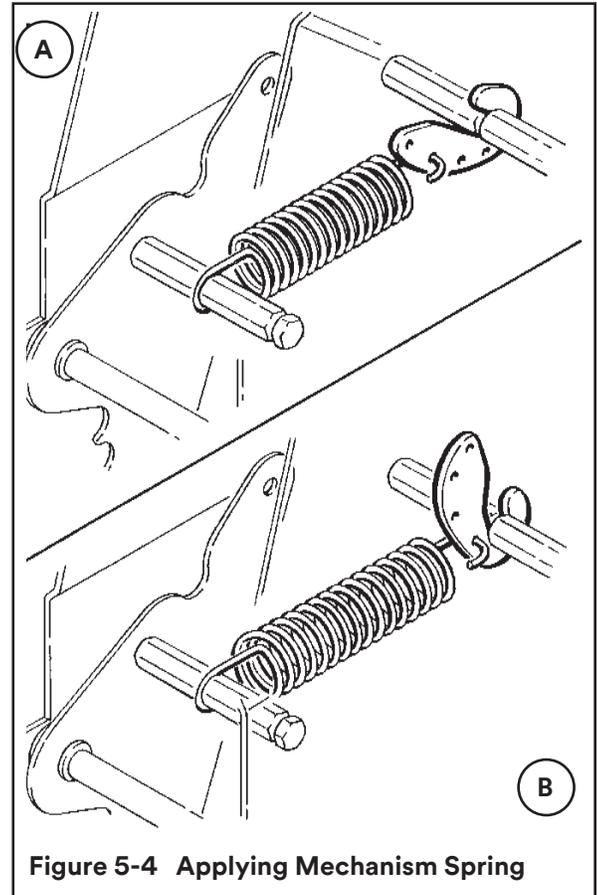
The one-way tension roller is factory set. When replacing this assembly, the roller must have 0,5 kg [1 lb.] min. tangential force when turning.

To Adjust Tension:

1. Wrap a cord or small strap (non-adhesive) 4-6 turns around the tension roller.
2. Attach a spring scale to the end of the cord or strap.
3. Turn adjusting nut (with socket wrench provided) until required force of approximately 0.5 kg to 0.9 kg [1 to 2 lbs.] is reached to turn roller pulling on spring scale.

### **WARNING**

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



(Adjustments *continued* on next page.)

# Adjustments *(continued)*

## Tape Leg Length

### Leading Tape Leg Length Adjustment – Figure 5-6

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

Moving this roller farther away from the box top or bottom surface will decrease the leading leg length.

Moving it closer to the box top or bottom surface will increase the leading leg length.

### Changing Tape Leg Length from 70 to 50mm [2 3/4-2 Inches] – Figure 5-7

**Note** – When changing tape leg length, both upper and lower heads must be adjusted to apply same leg lengths.

1. Remove and retain two hex head screws and remove the brush from normal position “A” on side frame.
2. Remount and secure brush in position “A-A” on side frame forward of normal location with original fasteners.
3. Remove cut-off bracket extensions from position “B”.
4. Remount cut-off bracket extensions in forward position “B-B”.
5. Remove/retain one-way tension roller assembly from slot “C” in frame.
6. Remount tension roller assembly near top of slot “C-C” in frame using original fasteners.
7. Adjust tension roller according to “Leading Tape Leg Length Adjustment” above.

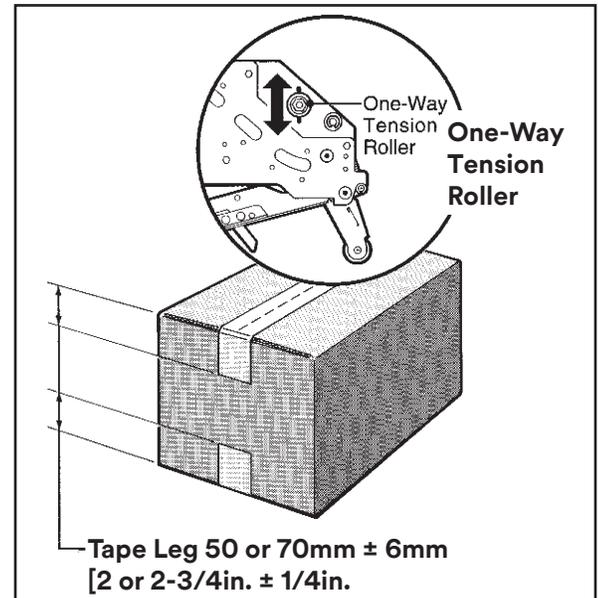


Figure 5-6 Leading Tape Leg Length

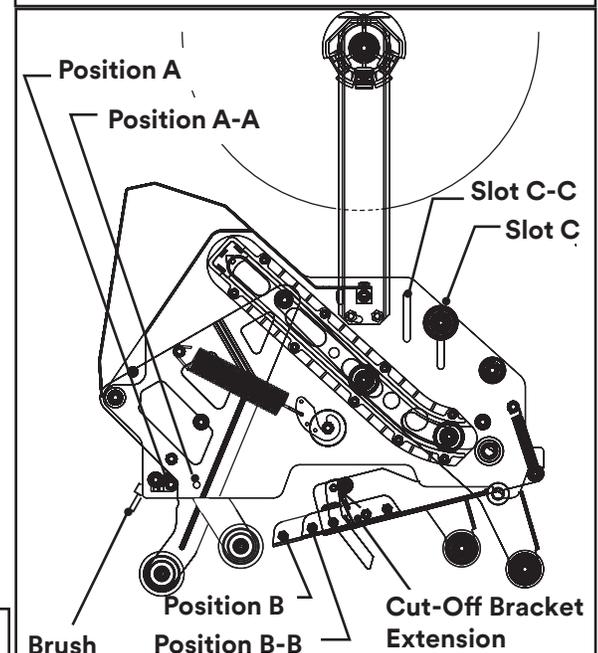


Figure 5-7 Changing Tape Leg Length



## WARNING

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



## WARNING

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

# Troubleshooting

## Troubleshooting Guide

Problem	Cause	Correction
The tape leg on the front of the case is too long	The tape is threaded incorrectly	The tape must go around the wrap roller before going around the one-way tension roller
	The tape tension is too low	Adjust the one-way tension roller
	The knurled roller drags	Check for adhesive build-up between the knurled roller and its shaft. Clean and lubricate shaft. Remove all lubricant from roller surfaces.
	Tape tracks to one side or drags on the support tabs of applying frame	Adjust the tape web alignments
	The one-way tension roller is not correctly positioned	Position the roller in its mounting slot so that the tape extends just beyond the centerline of the applying roller
	Taping head is not set up properly	Check leg length adjustments
The blade does not cut tape or tape end is jagged/shredded	The blade is dull and/or has broken teeth	Replace the blade
	Tape tension is insufficient	Increase tape tension by adjusting the one-way tension roller
	Adhesive has built up on blade	Clean and adjust the blade
	The blade is not positioned properly	Make sure the blade is bottomed out against the mounting bolts
	The blade is dry	Lubricate the blade oiler pad on the blade guard
	The blade is in backwards	Mount the blade so that the beveled edge is away from the entrance of the head
	One or both cutter springs are missing or stretched	Replace the defective spring(s)
	Tension roller surface is not fully contacting the taping head frame	Make sure one-way bearing is below the surface of the tension roller. If not, press bearing further into roller or replace roller.

# Troubleshooting *(continued)*

## Troubleshooting Guide

Problem	Cause	Correction
Tape is tabbing on the trailing leg on the back of the box	There is excess tension on the tape drum assembly and/or the one-way tension roller assembly	Adjust the one-way tension roller and/or the tape drum assembly
	Rollers in the tape path do not rotate freely	Clean adhesive deposits from the surface, ends, and shafts of the rollers. Then lubricate roller shafts. Remove all lubricant from roller surfaces.
	The blade is not cutting tape properly	Refer to tape cutting problems
	The tape is threaded incorrectly	Re thread the tape
The tape end does not stay in application position in front of the applying roller	Applying mechanism spring has too little tension	Move spring hook to next tighter hole
	The tape is incorrectly threaded	Re-thread the tape
	Flanged knurled roller overruns on return of applying mechanism to its rest position	Adjust tension roller position in mounting slot to lengthen tape leg
	Applying roller overruns on return of applying mechanism to its rest position	There should be a slight drag when rotating the applying roller. If not, check friction springs and/or friction pins and replace if necessary
Tape not centered on box seam	The one-way tension roller is not correctly positioned	Position roller in its mounting slot so that tape end extends beyond centerline of applying roller
	The one-way tension roller is defective	Replace the one-way tension roller
Tape not centered on box seam	Tape drum not centered	Reposition tape drum
	Centering guides not centered	Adjust centering guides
	Box flaps not of equal length	Check box specifications

# Spare Parts/Service Information

## Recommended Spare Parts

Listed are a set of spare parts that will periodically require replacement due to normal wear. These parts should be ordered to keep the taping heads in production:

### AccuGlide™ 3 Upper Taping Head - 2 inch

Qty.	Part Number	Description
4	78-8076-4500-3	Stud – Mounting
1	78-8137-3311-6	Spring – Upper Extension
1	78-8017-9173-8	Blade – 65mm/2.56 Inch
2	78-8052-6602-6	Spring – Cutter
1	78-8076-4726-4	Tool – Tape Threading

### AccuGlide™ 3 Lower Taping Head - 2 inch

Qty.	Part Number	Description
1	78-8017-9173-8	Blade – 65mm/2.56 Inch
2	78-8052-6602-6	Spring – Cutter
4	78-8076-4500-3	Stud – Mounting
1	78-8137-3312-4	Spring – Lower Extension
1	78-8076-4726-4	Tool – Tape Threading

In addition to the above set of spare parts supplied with the taping head, it is suggested that the following spare parts be maintained which will require replacement under normal wear of the taping head.

Qty.	Part Number	Description
1	78-8057-6179-4	Roller – Applying
1	78-8057-6178-6	Roller – Buffing
1	78-8113-7030-9	Spring – Torsion

## Replacement Parts and Service

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



## Spare Parts/Service Information *(continued)*

### Replacement Parts Illustrations and Parts Lists

AccuGlide™ 3 High Speed 2 Inch Upper Taping Head, Type 11400

AccuGlide™ 3 High Speed 2 Inch Lower Taping Head, Type 11400

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

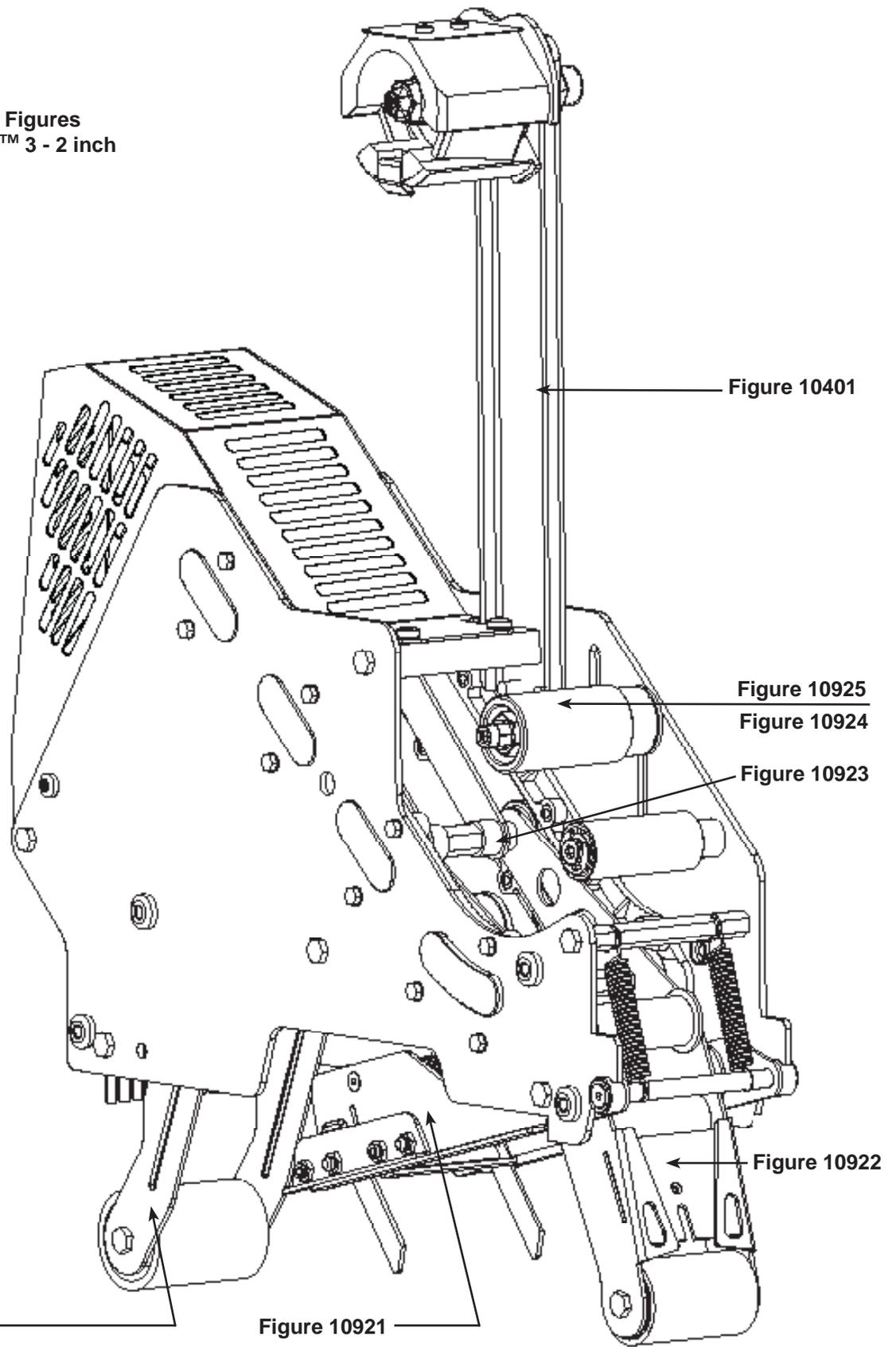
**Note** – The complete description has been included for standard fasteners and some commercially available components. This has been done to allow obtaining these standard parts locally, should the customer elect to do so.

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

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



Tape Head Figures  
AccuGlide™ 3 - 2 inch



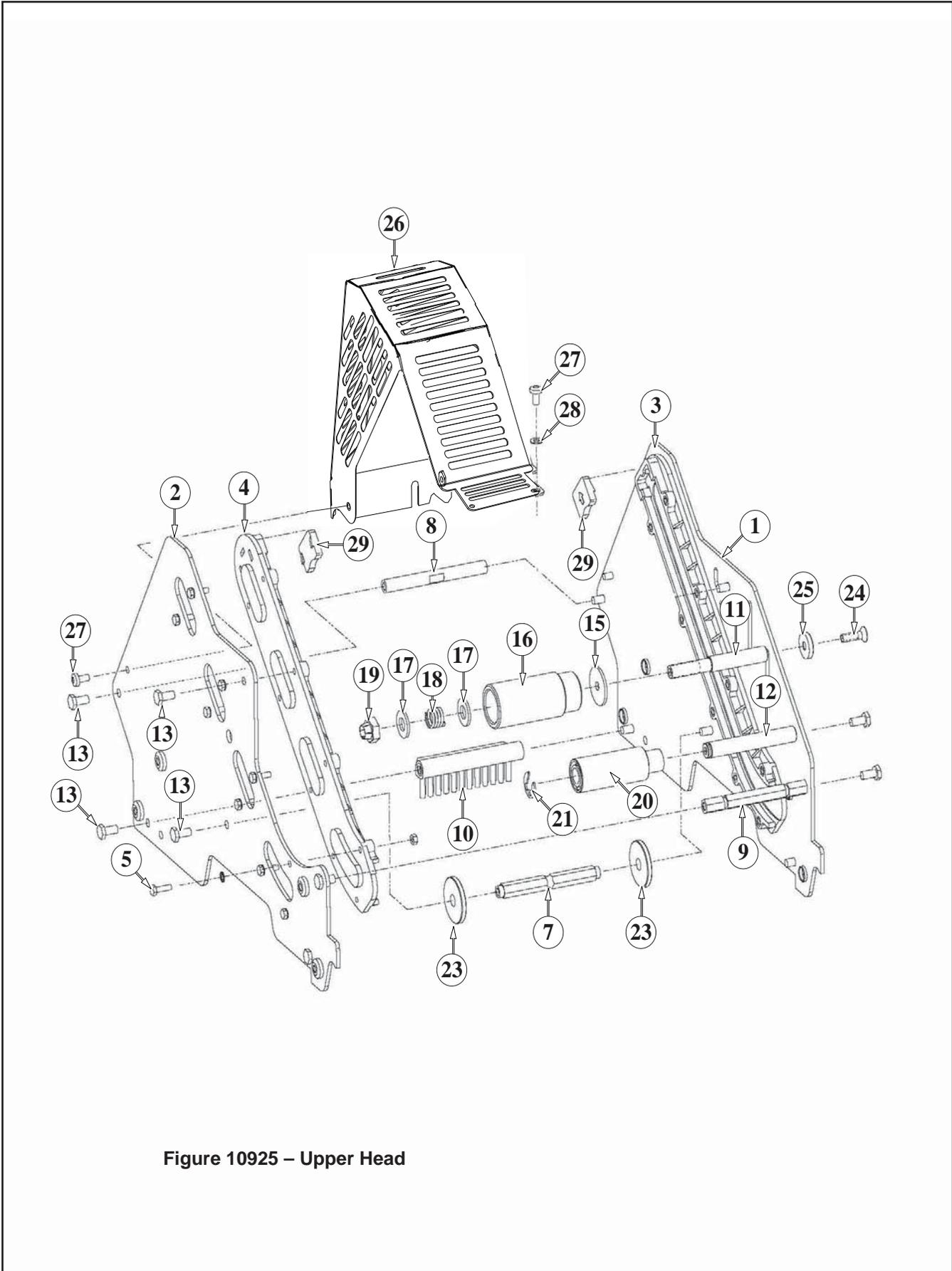


Figure 10925 – Upper Head

Figure 10925 – 2" Upper Head

Ref. No.	3M Part No.	Description
10925-1	78-8137-3294-4	Frame – Tape Mount Upper Assembly
10925-2	78-8137-3295-1	Frame – Front Upper Assembly
10925-3	78-8068-4143-9	Guide – #1
10925-4	78-8068-4144-7	Guide – #2
10925-5	78-8060-7818-0	Screw – Hex Hd, M4 x 12
10925-6	78-8010-7416-8	Nut – Hex Jam, M4
10925-7	78-8070-1251-9	Spacer – Spring
10925-8	78-8137-3298-5	Shaft - Pivot 90mm
10925-9	78-8052-6560-6	Spacer – Front
10925-10	78-8060-7936-0	Brush Assembly
10925-11	78-8052-6564-8	Shaft – Tension Roller
10925-12	78-8052-6568-9	Shaft – Wrap Roller
10925-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10925-15	78-8100-1009-6	Washer – Special
10925-16	78-8052-6565-5	Roller – Top Tension
10925-17	26-1004-5510-9	Washer – Plain, M10
10925-18	78-8052-6567-1	Spring – Compression
10925-19	78-8017-9077-1	Nut – Self Locking, M10 x 1
10925-20	78-8052-6569-7	Roller – Wrap
10925-21	26-1000-1613-3	Ring – Retaining, Tru-Arc #1-420-0120-100
10925-22	78-8076-4500-3	Stud – Mounting (not shown)
10925-23	78-8076-5242-1	Stop – Cut-Off Frame
10925-24	78-8060-8179-6	Screw – Flat Hd Hex, M6 x 20
10925-25	78-8076-5477-3	Washer – Special /6.5 x 20 x 4
10925-26	78-8137-3299-3	Guard – Head
10925-27	78-8060-8087-1	Screw – M5 x 10
10925-28	78-8005-5741-1	Washer – Flat, M5
10925-29	78-8133-9615-3	Bumper
10925-30	78-8133-9605-4	Label – Threading, English Language
10925-31	78-8076-4716-5	Star Washer 4mm

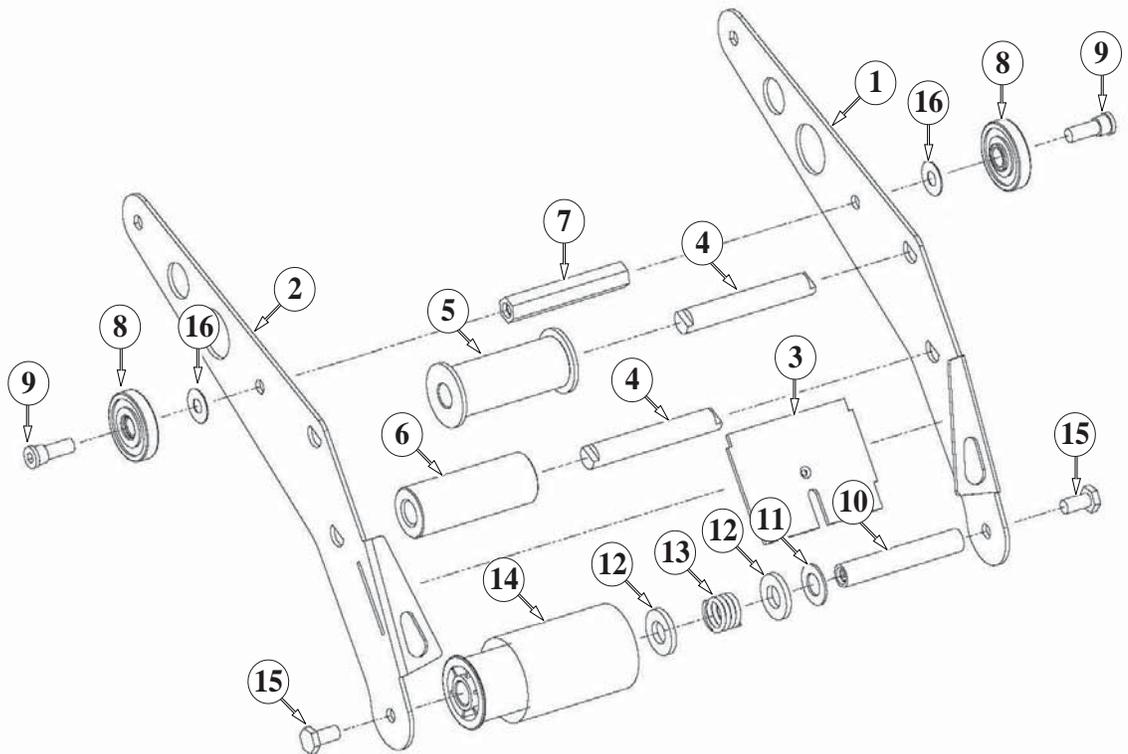


Figure 10922 – Upper and Lower Heads

Figure 10922 – 2" Upper and Lower Heads

Ref. No.	3M Part No.	Description
10922-1	78-8133-9509-8	Applying Arm #1
10922-2	78-8133-9510-6	Applying Arm #2
10922-3	78-8070-1221-2	Plate – Tape
10922-4	78-8070-1309-5	Shaft Roller
10922-5	78-8070-1367-3	Roller – Knurled Assembly
10922-6	78-8070-1266-7	Roller – Wrap
10922-7	78-8052-6580-4	Spacer
10922-8	78-8017-9082-1	Bearing – Special, 30 mm
10922-9	78-8017-9106-8	Screw – Bearing Shoulder
10922-10	78-8052-6575-4	Shaft – Roller
10922-11	78-8017-9074-8	Washer – Nylon, 15 mm
10922-12	26-1004-5510-9	Washer – Friction
10922-13	78-8052-6567-1	Spring – Compression
10922-14	78-8137-1438-9	Assembly– Applying Roller
10922-15	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10922-16	78-8094-6151-6	Washer - Flat, 6.5 ID x 15 OD x 0.5 Thk

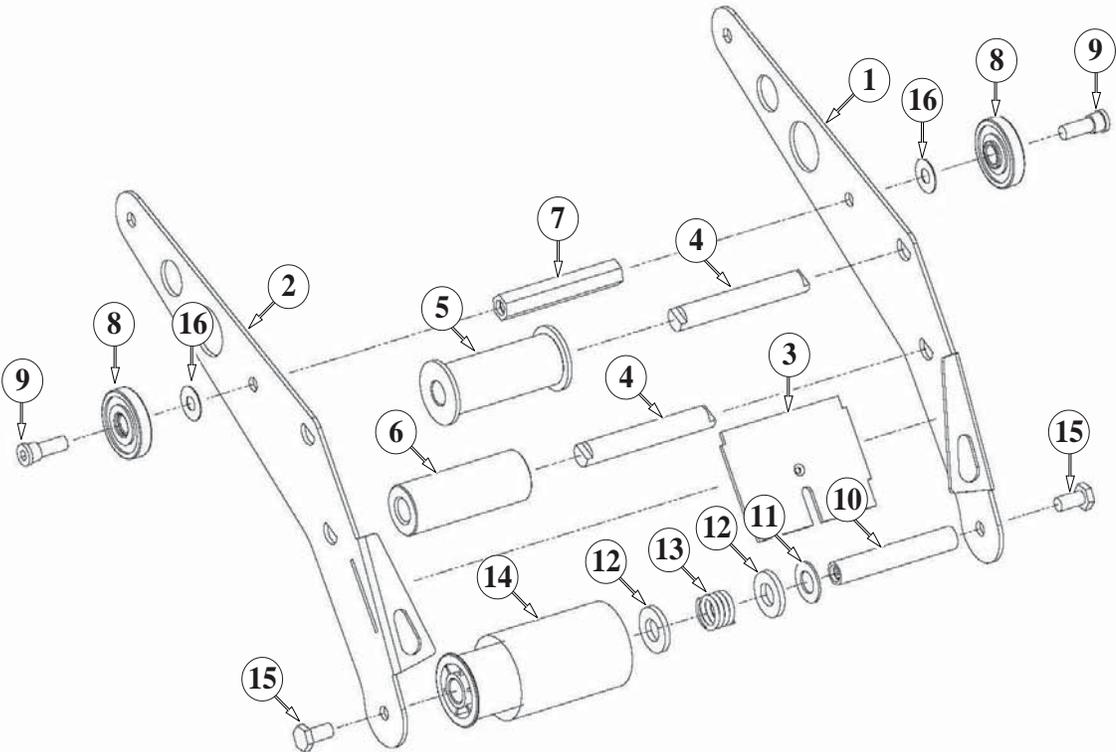


Figure 10919 – Upper Head

Figure 10919 – 2" Upper Head

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
10919-1	78-8137-3300-9	Buffing Arm – Sub Assembly
10919-2	78-8137-3301-7	Buffing Arm – Sub Assembly
10919-3	78-8052-6575-4	Shaft – Roller
10919-4	78-8137-1398-5	Roller - Buffing Assembly
10919-5	78-8070-1220-4	Spacer – Spring
10919-6	78-8052-6580-4	Spacer
10919-7	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10919-8	78-8137-3311-6	Spring – Upper (100 fpm)
10919-9	78-8070-1244-4	Holder – Spring



Figure 10923 – 2" Upper and Lower Heads

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
10923-1	78-8137-3302-5	Link – Assembly
10923-3	78-8137-3304-1	Shaft – Pivot, Buffing
10923-4	78-8017-9082-1	Bearing – Special 30 mm
10923-5	78-8017-9106-8	Screw – Bearing Shoulder
10923-6	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10923-7	78-8137-3305-8	Spacer – Applying Pivot
10923-8	78-8137-3306-6	Shaft – Pivot, Applying
10923-9	78-8094-6151-6	Washer - Flat, 6.5 ID x 15 OD x 0.5 Thk

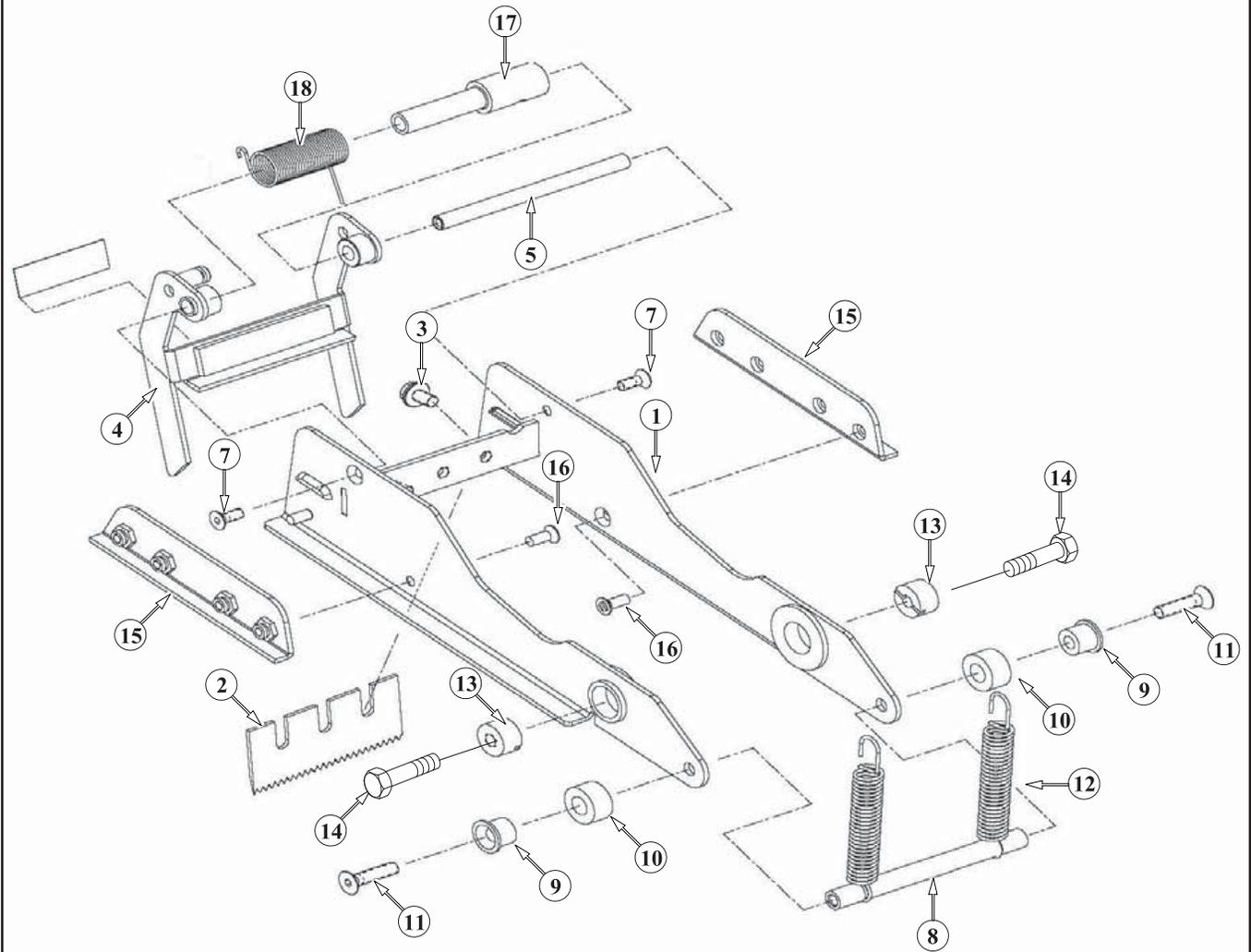


Figure 10921 – Upper and Lower Heads

Figure 10921 – 2" Upper and Lower Heads

Ref. No.	3M Part No.	Description
10921-1	78-8137-3307-4	Frame – Cut-Off Weldment
10921-2	78-8017-9173-8	Blade – 65 mm/2.56 Inch
10921-3	26-1003-8596-7	Screw - Hex Hd M5 x 8 w/ Ext. Tooth Lockwasher
10921-4	78-8070-1371-5	Blade Guard Assembly – W/English Language Label
10921-5	78-8052-6597-8	Shaft – Blade Guard
10921-7	26-1005-4758-2	Screw – Flat Hd, Soc Dr, M4 x 10
10921-8	78-8017-9135-7	Shaft – Spacer
10921-9	78-8052-6600-0	Spacer
10921-10	78-8070-1269-1	Bumper
10921-11	26-1005-4757-4	Screw – Flat Hd, Soc Dr, M5 x 20
10921-12	78-8052-6602-6	Spring – Cutter
10921-13	78-8017-9132-4	Pivot – Cutter Lever
10921-14	26-1003-5828-7	Screw – Spec, Hex Hd, M6 x 10
10921-15	78-8137-3308-2	Slide – Extension
10921-16	26-1008-6574-5	Screw – Flat Hd, Phil Dr, M4 x 10
10921-17	78-8113-7031-7	Bushing – 58.5mm Long
10921-18	78-8113-7030-9	Spring – Torsion
10921-19	78-8070-1335-0	Label – Warning, English

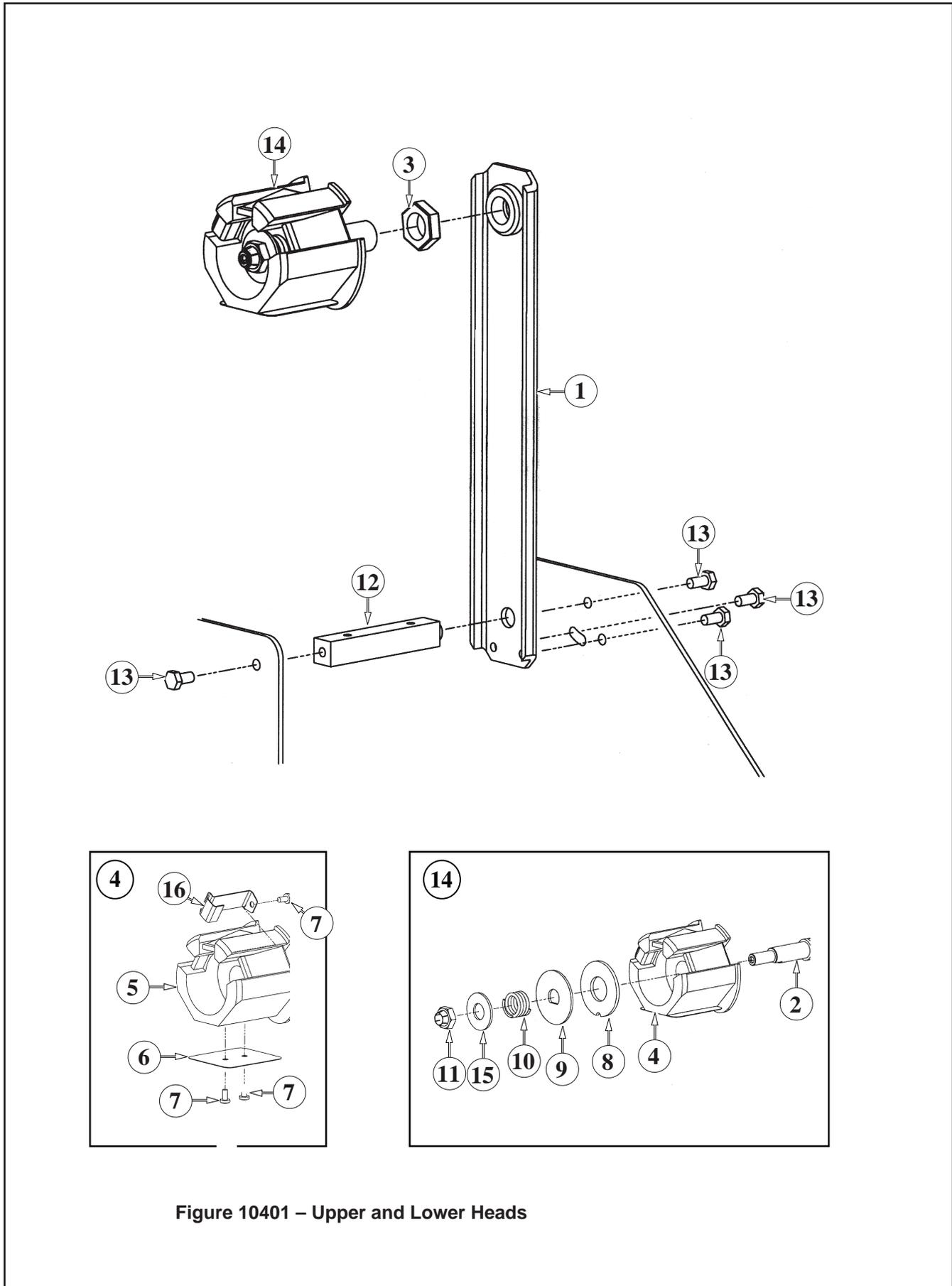


Figure 10401 – Upper and Lower Heads

Figure 10401 – 2" Latch Upper and Lower Heads

Ref. No.	3M Part No.	Description
10401-1	78-8070-1395-4	Bracket – Bushing Assembly
10401-2	78-8076-4519-3	Shaft – Tape Drum, 50mm
10401-3	78-8017-9169-6	Nut – M18 x 1
10401-4	78-8098-8827-0	Tape Drum Sub Assembly – 2 Inch Wide
10401-5	78-8098-8749-6	Tape Drum
10401-6	78-8098-8817-1	Leaf Spring
10401-7	26-1002-5753-9	Screw – Self Tapping
10401-8	78-8060-8172-1	Washer – Friction
10401-9	78-8052-6271-0	Washer – Tape Drum
10401-10	78-8100-1048-4	Spring – Core Holder
10401-11	78-8017-9077-1	Nut – Self Locking, M10 x 1
10401-12	78-8100-1046-8	Spacer – Bracket
10401-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10401-14	78-8098-8814-8	Tape Drum Assembly – 2 Inch Head
10401-15	26-1004-5510-9	Washer – Plain, M10
10401-16	78-8098-8816-3	Latch – Tape Drum

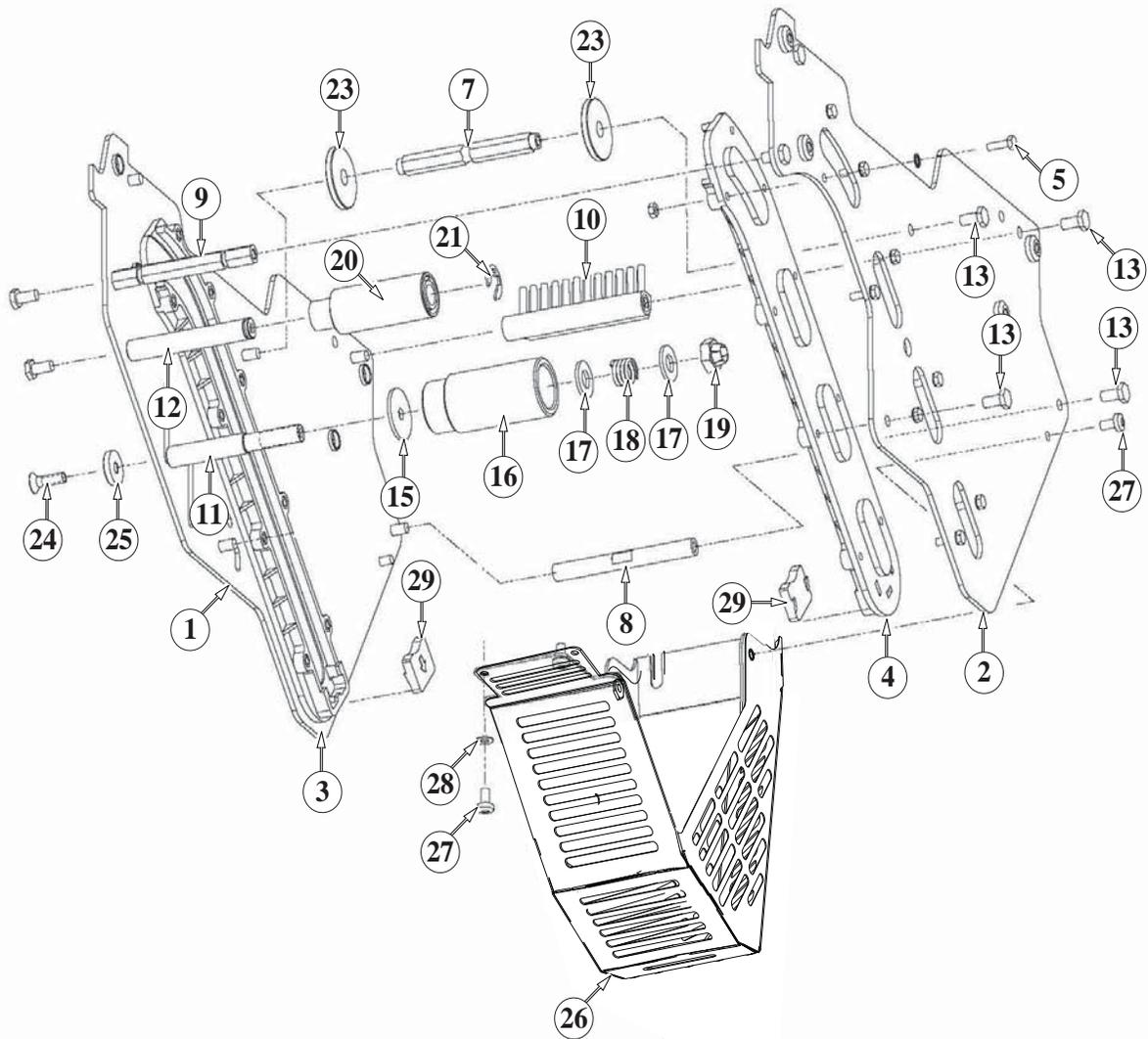


Figure 10924 – Lower Head

Figure 10924 – 2" Lower Head

Ref. No.	3M Part No.	Description
10924-1	78-8137-3296-9	Frame – Tape Mount Lower Assembly
10924-2	78-8137-3297-7	Frame – Front Lower Assembly
10924-3	78-8068-4144-7	Guide – #2
10924-4	78-8068-4143-9	Guide – #1
10924-5	78-8060-7818-0	Screw – Hex Hd, M4 x 12
10924-6	78-8010-7416-8	Nut – Hex, M4
10924-7	78-8070-1251-9	Spacer – Spring
10924-8	78-8054-3298-5	Spacer – 10 x 10 x 90 mm
10924-9	78-8052-6560-6	Spacer – Front
10924-10	78-8060-7936-0	Brush Assembly
10924-11	78-8052-6564-8	Shaft – Tension Roller
10924-12	78-8052-6568-9	Shaft – Wrap Roller
10924-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10924-15	78-8100-1009-6	Washer – Special
10924-16	78-8052-6606-7	Roller – Tension Bottom
10924-17	26-1004-5510-9	Washer – Plain, M10
10924-18	78-8052-6567-1	Spring – Compression
10924-19	78-8017-9077-1	Nut – Self Locking, M10 x 1
10924-20	78-8052-6569-7	Roller – Wrap
10924-21	26-1000-1613-3	Ring – Retaining, Tru-Arc #1-420-0120-100
10924-22	78-8076-4500-3	Stud – Mounting (not shown)
10924-23	78-8076-5242-1	Stop – Cut-Off Frame
10924-24	78-8060-8179-6	Screw – Flat Hd Hex, M6 x 20
10924-25	78-8076-5477-3	Washer – Special /6.5 x 20 x 4
10924-26	78-8137-3299-3	Guard – Head
10924-27	78-8060-8087-1	Screw – M5 x 10
10924-28	78-8005-5741-1	Washer – Flat, M5
10924-29	78-8076-4734-8	Bumper
10924-30	78-8133-9606-2	Label – Threading, English Language
10924-31	78-8076-4716-5	Star Washer 4mm

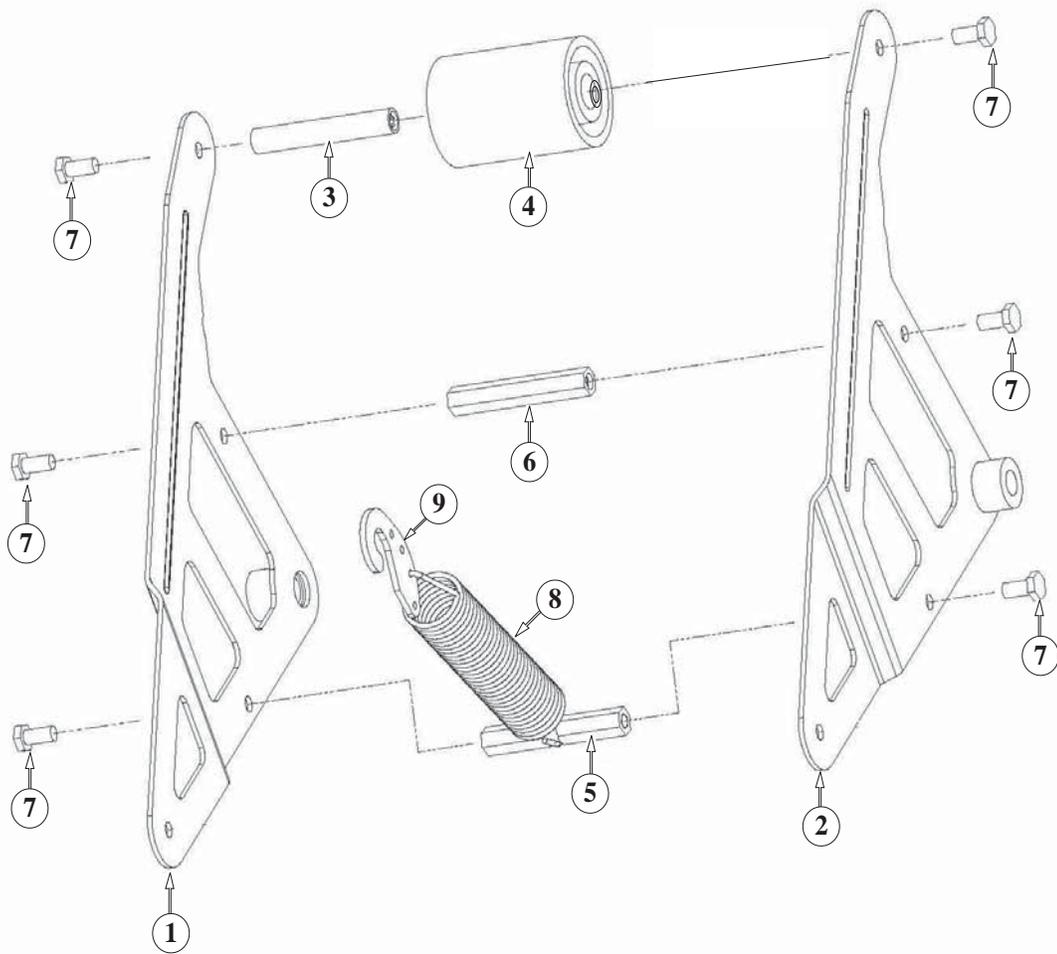


Figure 10920 – Lower Head

Figure 10920– Lower Head

Ref. No.	3M Part No.	Description
10920-1	78-8137-3300-9	Buffing Arm – Sub Assembly
10920-2	78-8137-3301-7	Buffing Arm – Sub Assembly
10920-3	78-8052-6575-4	Shaft – Roller
10920-4	78-8137-1398-5	Roller - Buffing Assembly
10920-5	78-8070-1220-4	Spacer – Spring
10920-6	78-8052-6580-4	Spacer
10920-7	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10920-8	78-8137-3312-4	Spring – Lower (100 fpm)
10920-9	78-8070-1244-4	Holder – Spring







## Instructions and Parts List

# 3M-Matic™ Accuglide™ 3

Type 11400

# Upper and Lower High Speed Taping Heads 3 Inch

Serial #: \_\_\_\_\_  
*For reference, record machine serial number here.*

## Important Safety Information

BEFORE INSTALLING OR OPERATING THIS EQUIPMENT  
Read, understand and follow all safety and operating instructions.

## Spare Parts

It is recommended you immediately order the spare parts listed in the “Spare Parts/Service Information” section. These parts are expected to wear through normal use, and should be kept on hand to minimize production delays.



# Replacement Parts and Service Information

## To Our Customers:

This is the 3M-Matic™/AccuGlide™/Scotch® equipment you ordered. It has been set up and tested in the factory with Scotch® Tapes. If technical assistance or replacement parts are needed, call or fax the appropriate number listed below.

Included with each machine is an Instructions and Parts List Manual.

## Technical Assistance/Replacement Parts and Additional Manuals:

Contact your local service provider 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: Accuglide 3 - 3 inch - Type 11400 - Serial Number 13282).

**3M Tape Dispenser Parts**  
**241 Venture Drive**                      **1-800-344-9883**  
**Amery, WI 54001-1325**                  **Fax: 1-715-268-8153**

### Identification Plate

<b>3M</b> 3M Company St. Paul, MN 55144 USA	Part Number	<b>3M-Matic™</b> For Commercial Use Only			 4000583
	Model	Year	Ampere	Watt	
	Serial Number				
Type		Volt	Hertz	Phase	

**Minimum billing on parts orders will be \$25.00.**  
**Replacement part prices available on request.**  
**\$10.00 restocking charge per invoice on returned parts.**



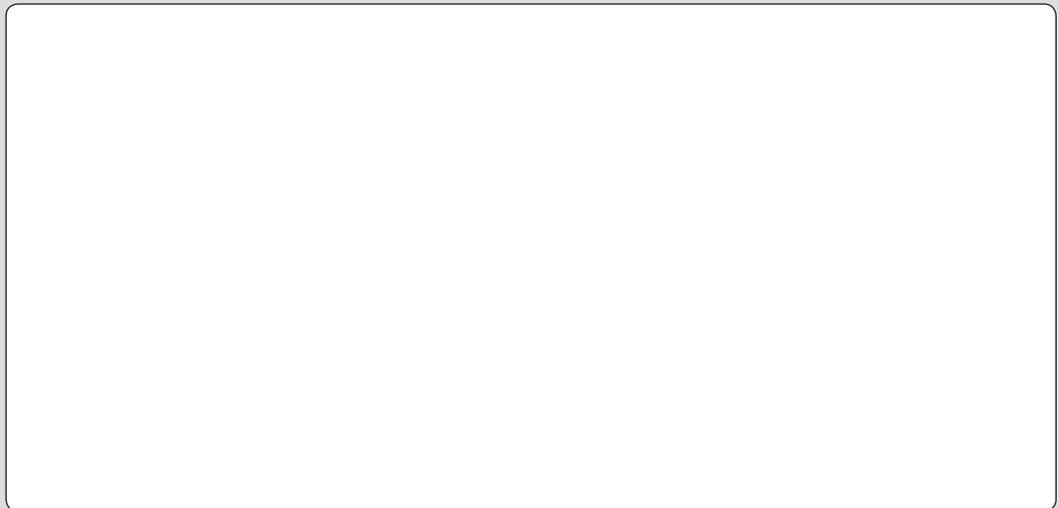
## Replacement Parts and Service Information *(continued)*

### **To Our Customers:**

This is the 3M-Matic™/AccuGlide™/Scotch® equipment you ordered. It has been set up and tested in the factory with Scotch® tapes. If any problems occur when operating this equipment and you desire a service call or phone consultation, call, write, or fax the appropriate number listed below.

Included with each machine is an Instructions and Parts List Manual.

**Service, replacement parts, and additional manuals available direct from:**



Order parts by part number, part description, and quantity required. Also, when ordering parts or additional manuals, include model/machine name, machine type, and serial number that are located on the identification plate.



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(Upper and Lower Taping Heads)

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# Warranty

## Warranty

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

3M sells its **3M-Matic™ Accuglide 3 Taping Head Type 11400** with the following warranties:

1. The Taping Head blade, springs and rollers will be free from defects in material and manufacture for ninety (90) days after delivery.
2. All other Taping Head parts will be free from defects in material and manufacture for three (3) years after delivery.

If any part is defective within this warranty period, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to repair or replace the part. 3M must receive actual notice of any alleged defect within a reasonable time after it is discovered, but in no event shall 3M have any obligation under this warranty unless it receives such notice within five (5) business days after the expiration of the warranty period.

All notices required hereunder shall be given to 3M solely through the 3M-Matic™ Help line (800-328-1390). To be entitled to repair or replacement as provided under this warranty, the part must be returned as directed by 3M to its factory or other authorized service station designated by 3M. If 3M is unable to repair or replace the part within a reasonable time after receipt thereof, 3M, at its option, will replace the equipment or refund the purchase price. 3M shall have no obligation to provide or pay for the labor required to remove any part or equipment or to install the repaired or replacement part or equipment. 3M shall have no obligation to repair or replace those parts failing due to normal wear, inadequate or improper maintenance, inadequate cleaning, non-lubrication, improper operating environment, improper utilities, operator error or misuse, alteration or modification, mishandling, lack of reasonable care, or due to any accidental cause.

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

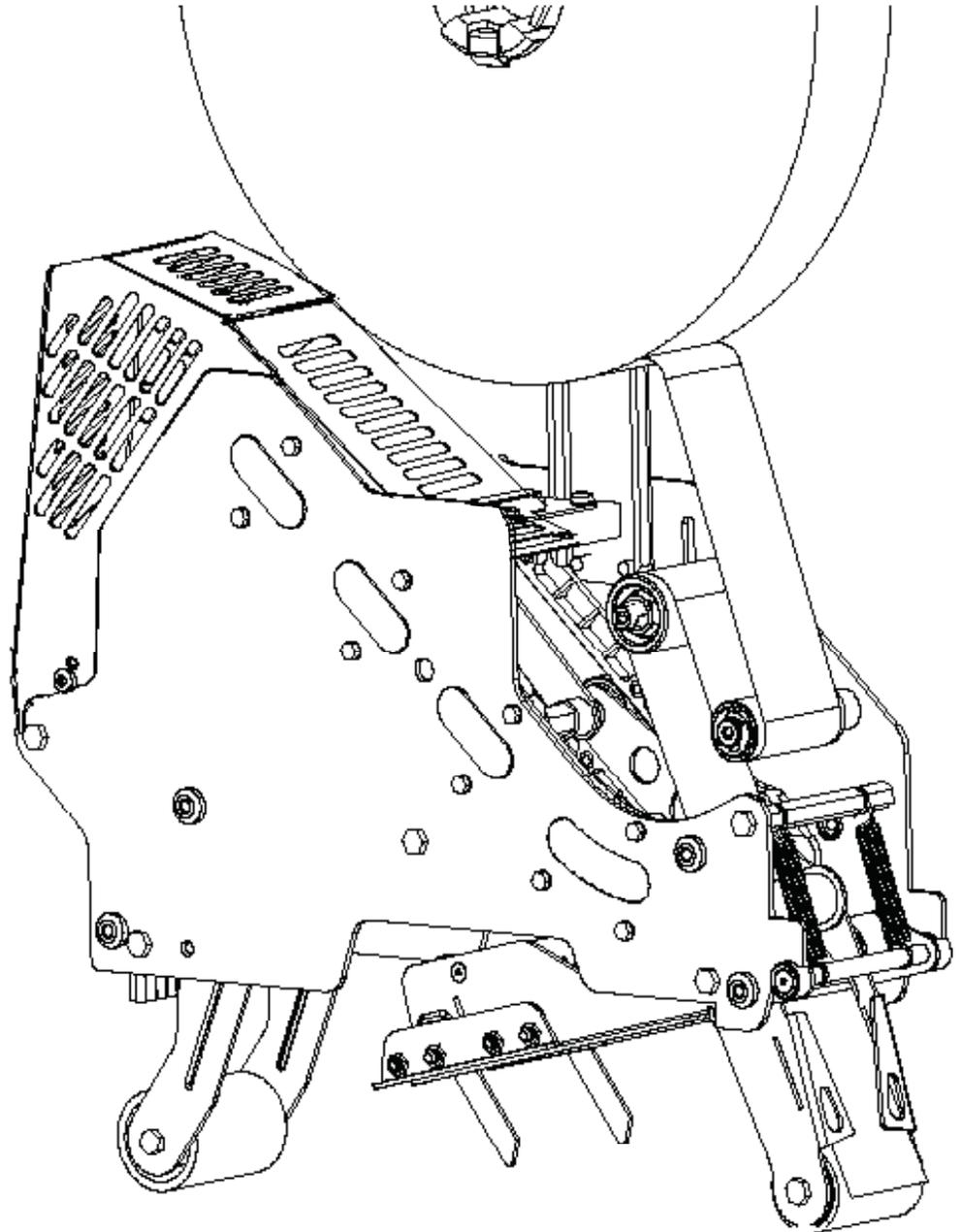
**Note:** The foregoing Equipment Warranty and Limited Remedy and Limitation of Liability may be changed only by a written agreement signed by authorized representatives of 3M and seller.

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

## Intended Use

The intended use of the AccuGlide™ 3 Upper and Lower Taping Heads - 3 inch is to apply a “C” clip of Scotch® pressure-sensitive film box sealing tape to the top and/or bottom center seam of regular slotted containers.

These taping heads are incorporated into most standard 3M-Matic™ case sealers. The compact size and simplicity of the taping head also makes it suitable for mounting in box conveying systems other than 3M-Matic™ case sealers. This includes replacement of other types of taping, gluing or stapling heads in existing case sealing machines. The AccuGlide™ 3 Upper and Lower Taping Heads - 3 inch have been designed and tested for use with Scotch® pressure-sensitive film box sealing tape.



**AccuGlide™ 3 Upper Taping Head - 3 inch, Type 11400**



# Taping Head Contents

## AccuGlide™ 3 High Speed - 3 inch Upper and Lower Taping Heads consist of:

<u>Qty.</u>	<u>Part Name</u>
1	Taping Head Assembly
1	Tape Drum and Bracket Assembly
1	Hardware and Spare Parts Kit
1	Threading Tool

### General Information

This instruction manual covers safety aspects, handling and transport, storage, unpacking, preparation, installation, operation, set-up and adjustments, technical and manufacturing specifications, maintenance, troubleshooting, repair work and servicing, electric diagrams, warranty information, disposal (ELV), a glossary with a definition of symbols, plus a parts list of the 3M-Matic™ AccuGlide 3 (3 inch) 3M Industrial Adhesives and Tapes Division 3M Center, Bldg. 220-5E-06 St. Paul, MN 55144-1000 (USA) Edition April 2016/ Copyright 3M 2016. All rights reserved The manufacturer reserves the right to change the product at any time without notice.

### How to use this Manual

The manual is an important part of the machine; all information contained herein is intended to enable the equipment to be maintained in perfect condition and operated safely. Ensure that the manual is available to all operators of this equipment and the manual is kept up to date with all subsequent amendments. Should the equipment be sold or disposed of, please ensure that the manual is passed on with the machine. Electrical and pneumatic diagrams are included in the manual. Equipment using PLC controls and/or electronic components will include relevant schematics or programs in the enclosure (or will be delivered separately as needed)

Keep the manual in a clean and dry place near the machine. Do not remove, tear or rewrite parts of the manual for any reason. Use the manual without damaging it. However, if the manual has been lost or damaged, ask your after sale service for a new copy (if it is possible, please have the manual name, part number, and revision information and/or model/machine name, machine type, and serial number) that are located on the identification plate (**For example: Model - AccuGlide 3 - 3" - Type 11400 - Serial Number 13282**).

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



### Updating the Manual

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

# Important Safeguards

## Explanation of Signal Word and Possible Consequences



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



**Caution**

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



**Warning**

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



### **WARNING**

- To reduce the risk associated with mechanical hazards
- Read, understand and follow all safety and operating instructions before operating or servicing the case sealer
- Allow only properly trained and qualified personnel to operate and or service this equipment



### **CAUTION**

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



### **WARNING**

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



### **WARNING**

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

(Important Safeguards *continued* on next page)

# Important Safeguards (continued)

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

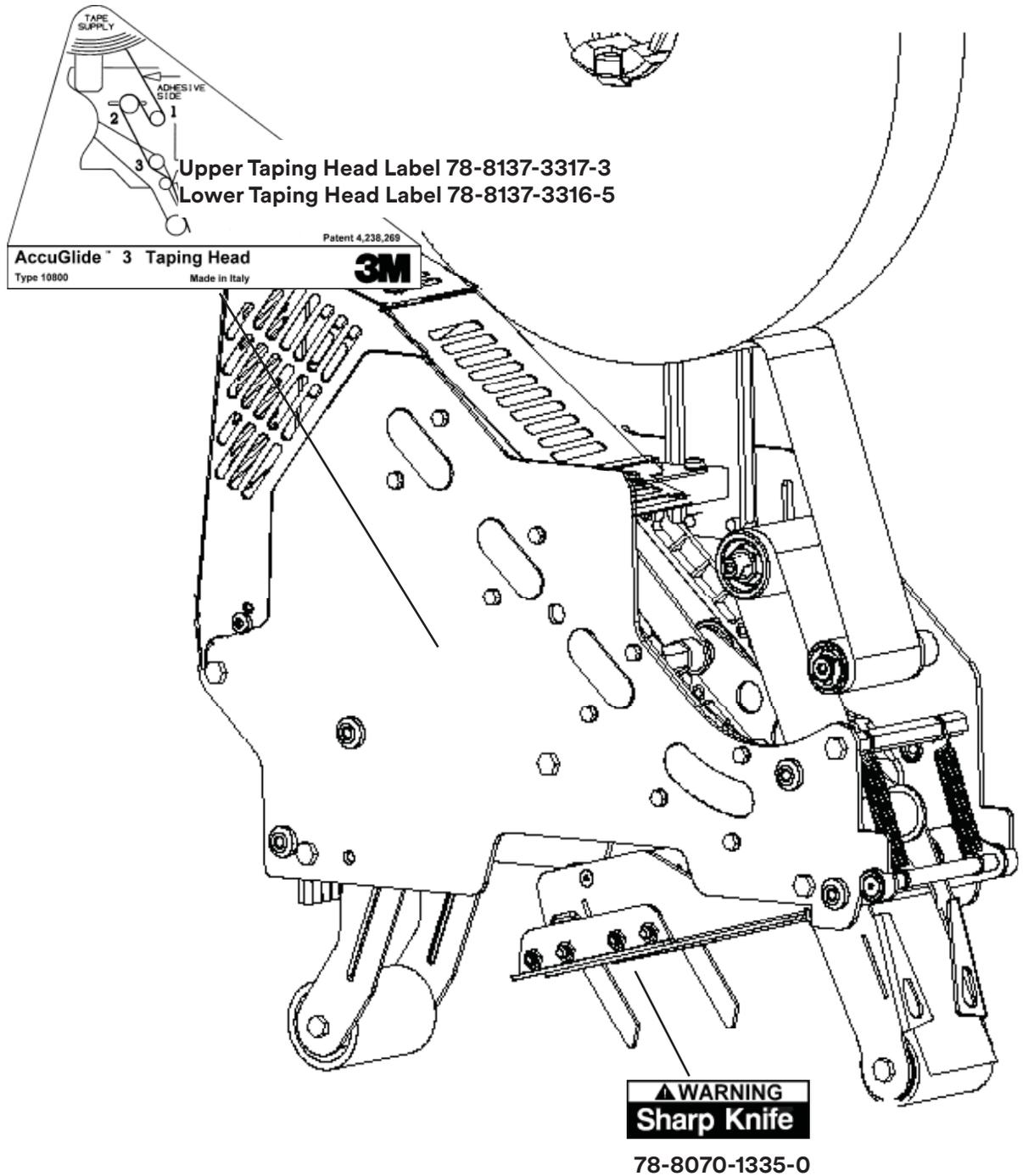


Figure 1-1 Replacement Labels/3M Part Numbers

# Specifications

**1. Tape:**

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

**2. Tape Width:**

48mm [2 inches] minimum to 72mm [3 inches] maximum.

**3. Tape Roll Diameter:**

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

**4. Tape Application Leg Length - Standard:**

70mm ± 6mm [2-3/4 inches ± 1/4 inch]

**Tape Application Leg Length - Optional:**

50mm ± 6mm [2 inches ± 1/4 inch] (See “Adjustments – Tape Leg Length.”)

**5. Box Size Capacities:**

For use with center seam regular slotted containers.

<u>Minimum</u>	<u>Maximum</u>	
Length – 150mm [6 inches]	Unlimited	
Height – 120mm [4-3/4 inches] (most “3M-Matic” Case Sealers)		] Limited by Case Sealer
90mm [3-1/2 inches] (with optional 2 inch leg length)		
Width – 150mm [6 inches]		

When upper and lower taping heads are used on “**3M-Matic**” case sealers, refer to the respective instruction manual specifications for box weight and size capacities.

**6. Operating Rate:**

Conveyor speeds up to 0.5 m/s [100 feet per minute].

**7. Operating Conditions:**

Use in dry, relatively clean environments at 5° to 40°C [40° to 105°F] with clean dry boxes.

**Important** – Taping heads should not be washed down or subjected to conditions causing moisture condensation on components.

**8. Taping Head Dimensions:**

Length – 442mm [17 3/8 inches]

Height – 648mm [25 1/2 inches] (with tape drum)

Width – 130mm [5-1/8 inches] (without mounting spacers)

Weight – Packaged: 8.2kg [18 lbs.] Unpackaged: 7.3kg [16 lbs.]

(Specifications *continued* on next page.)

# Specifications *(continued)*

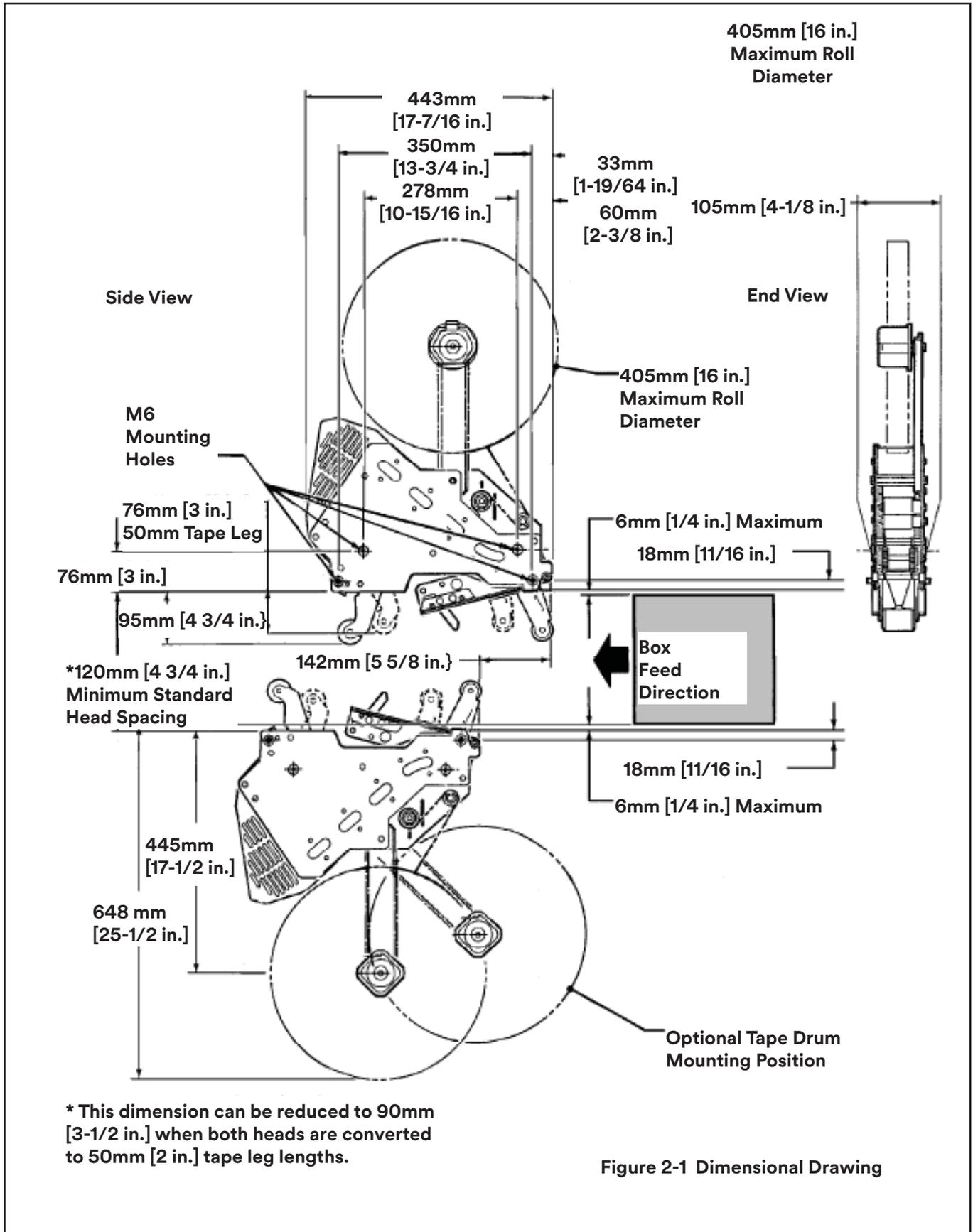


Figure 2-1 Dimensional Drawing

# Installation



## WARNING

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

### Receiving And Handling

After the taping head assembly has been unpackaged, examine the unit for damage that might have occurred during transit. If damage is evident, file a damage claim immediately with the transportation company and also notify your 3M Representative.

### Installation Guidelines

The taping head assembly can be used in converting existing or in custom made machinery.

It can be mounted for top taping or bottom taping. Refer to “Box Size Capacities,” as well as **Figure 2-1** in the Specifications section, for following points making installations:

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

1. The box conveying system must positively propel the box in a continuous motion, not exceeding 0.40 m/s [80 feet per minute], past the taping head assembly since the box motion actuates the taping mechanism.



## CAUTION

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

2. If a pusher/cleated conveyor is used, steps should be taken in conveyor to prevent pusher from contacting applying or buffing roller arms (resulting in damage to taping head).
3. **Figure 2-1** illustrates the typical mounting relationship for opposing taping head assemblies to allow taping of box heights down to 90mm [3-1/2 inches]. To tape box heights down to 70mm [2-3/4 inches], the taping heads must be completely staggered so only one tape seal is being applied at one time.
4. Mounting studs are provided with the taping head, but special installations may require alternate mounting means.
5. Box hold-down/guide skis should be provided and taping head mounted so that side plates are 6mm [1/4 inch] maximum away from the ski surface on which the box rides.

**Note** – AccuGlide™ 3 High Speed Upper Taping Head is supplied with a buffing arm guard. Adjustments to guard may be required to install taping head into some older design case sealers.

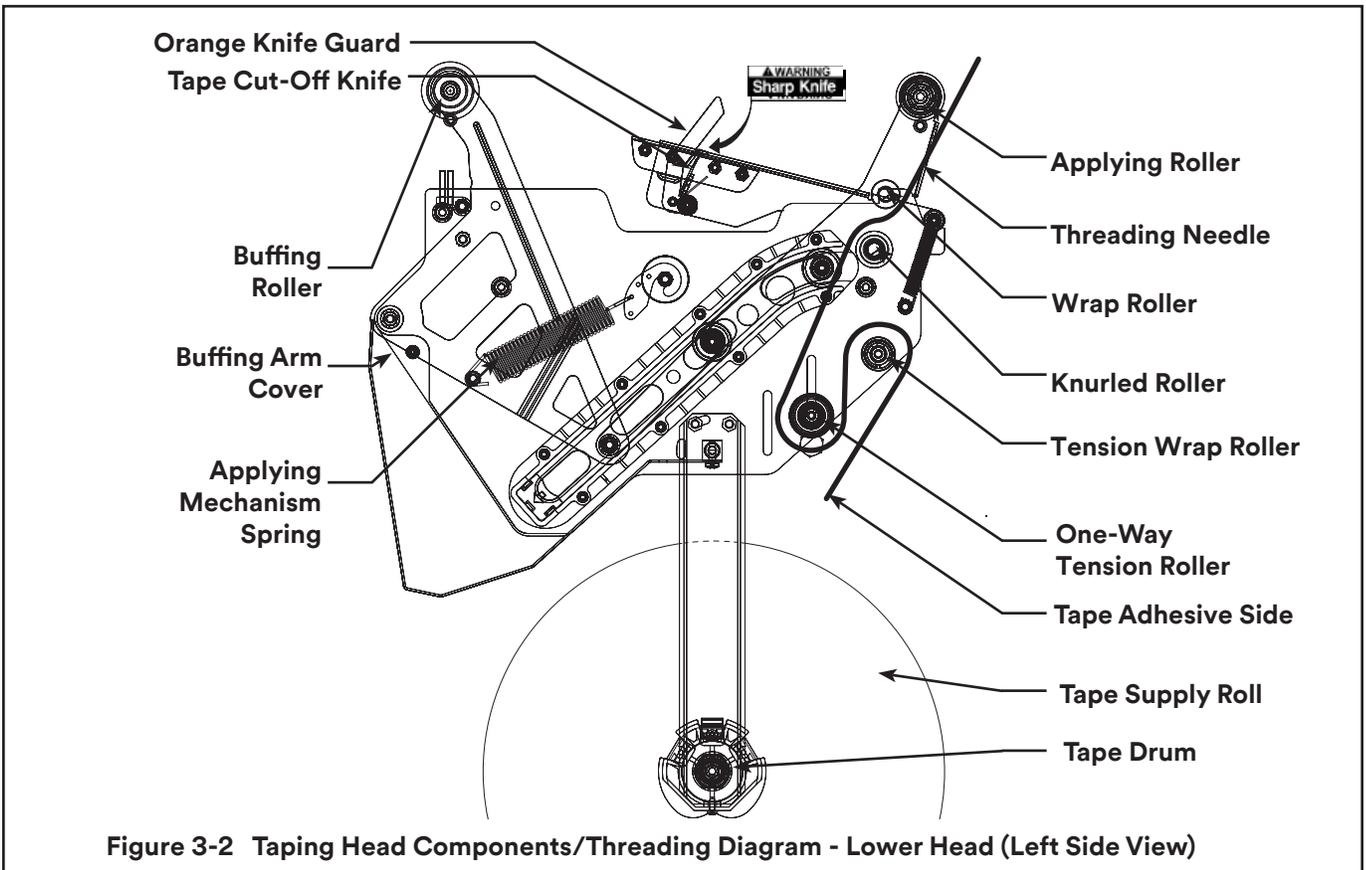
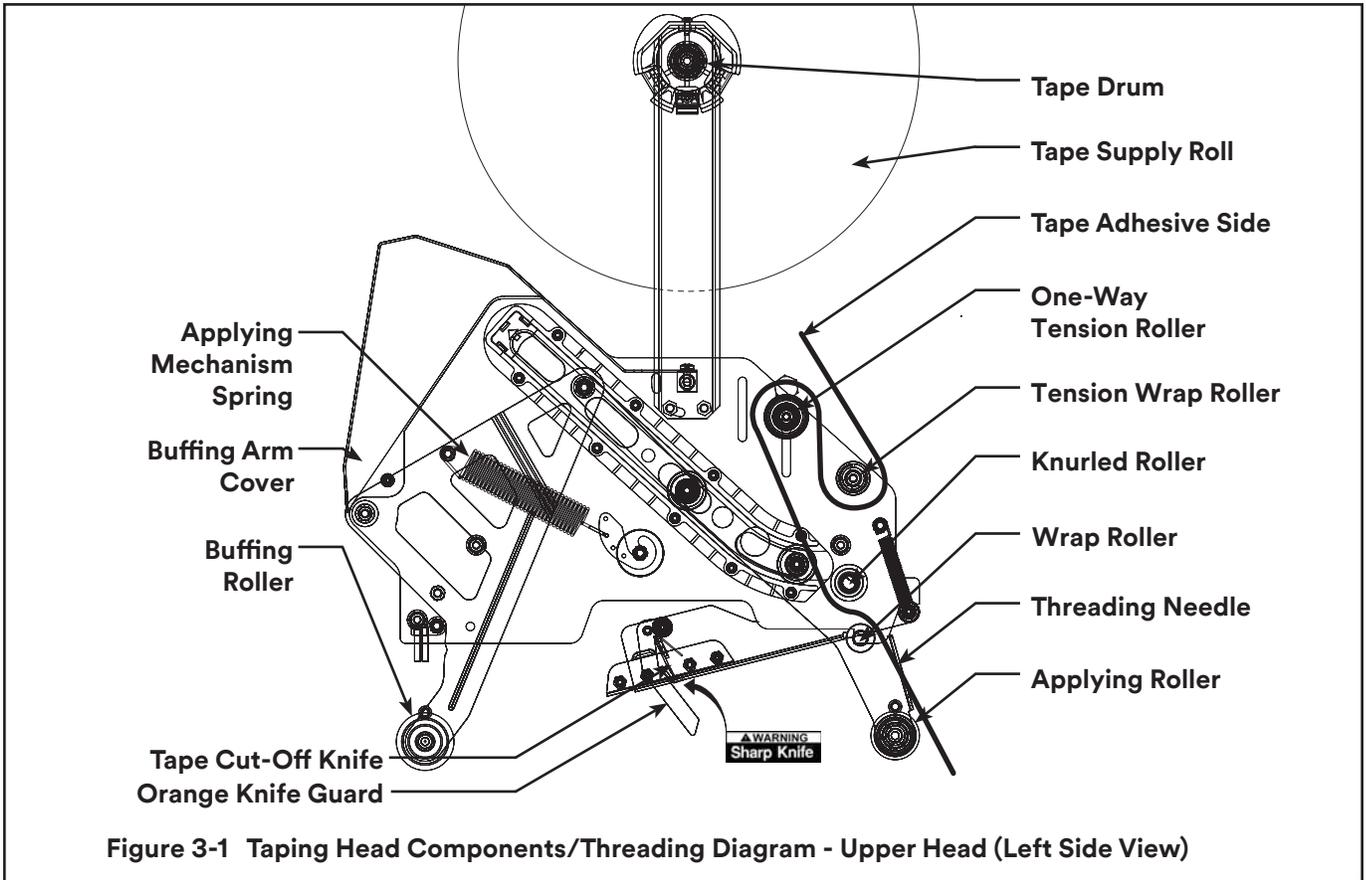
### Tape Leg Length

Taping heads are factory set to apply standard 70mm [2-3/4 inch] tape legs. The heads can be converted to apply 50mm [2 inch] tape legs if but both upper and lower heads must be set to apply the same tape leg length. See “Adjustments – Changing Tape Leg Length from 70 to 50mm [2-3/4 to 2 Inches].” Also, conveyor speed at which the product moves through taping heads affects the leading and trailing tape leg length. See “Adjustments section - Leading Tape Leg Length Adjustment.”

### Tape Width Adjustment

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

# Operation



## **WARNING**

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

It is recommended that the detailed instructions and sketches in this manual be referred to the first few times the taping head is loaded/threaded until the operator becomes thoroughly familiar with the tape loading operation.

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

### **Tape Loading – Upper Taping Head**

1. Place the upper taping head in a convenient working position.
2. Use **Figures 3-3/3-5** and tape threading label. Position tape roll so adhesive side of tape faces front of taping head as it's pulled from supply roll.
3. Attach the threading needle to the end of the roll. Guide the threading needle around the wrap roller (Position 1) then back around the one-way tension roller (Position 2).
4. Continue pulling the threading needle down and guide it between the two rollers on the apply arm (Position 3).
5. Pull threading needle down until tape travels between apply plate and ears of apply arm (Position 4) until extends past apply roller. When threaded adhesive side of tape should face knurled rollers at position 2 and also position 3.
6. Cut away any excess tape.

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

### **Tape Loading – Lower Taping Head**

1. Remove the lower taping head from the conveyor bed or associated equipment and place it a convenient working position.
2. Lower taping head is loaded and threaded in same manner as upper head.

## **WARNING**

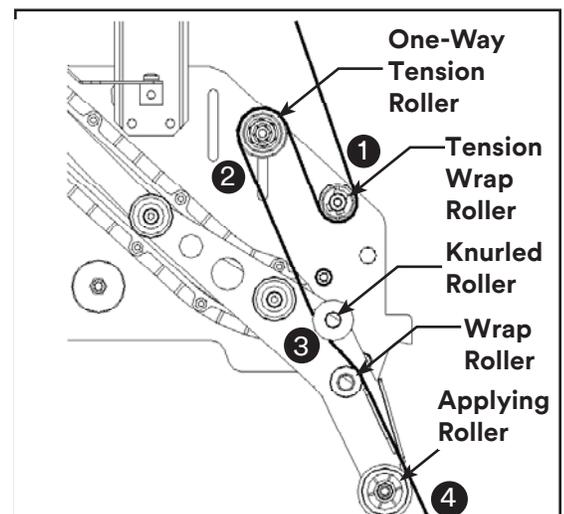
- To reduce the risk associated with shear, pinch, and entanglement hazards
  - Turn air and electrical supplies off on associated equipment before performing any adjustments, maintenance, or servicing the taping heads
  - Never attempt to work on the taping head or load tape while the box drive system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

## **CAUTION**

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

**Figure 3-3**

Insert threading needle through rollers in direction indicated by arrows.



**Figure 3-3** Tape Loading/Threading

## Operation *(continued)*

**Figure 3-4**

Place tape roll on tape drum to dispense tape with adhesive side forward. Seat tape roll fully against back flange of drum. Adhere tape lead end to threading needle as shown.

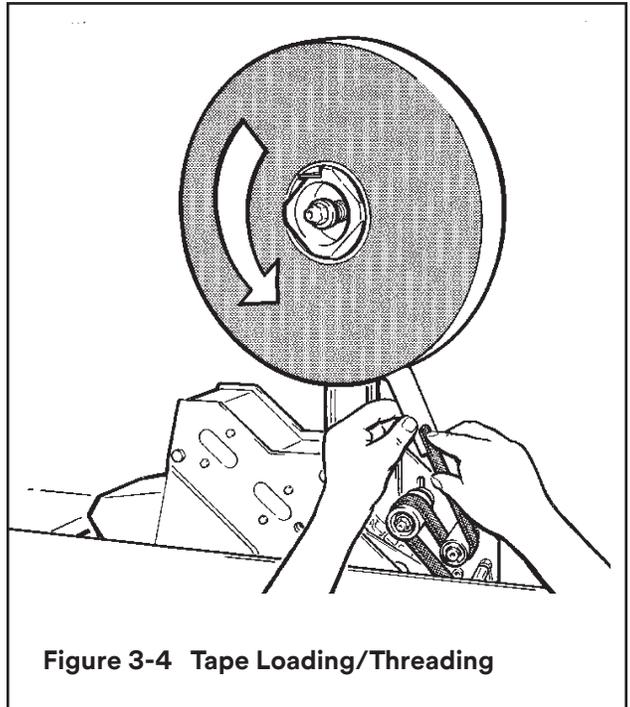
Manually turn tape roll to create slack tape while pulling threading needle through tape applying mechanism until needle is through and tape is in alignment with applying roller.

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

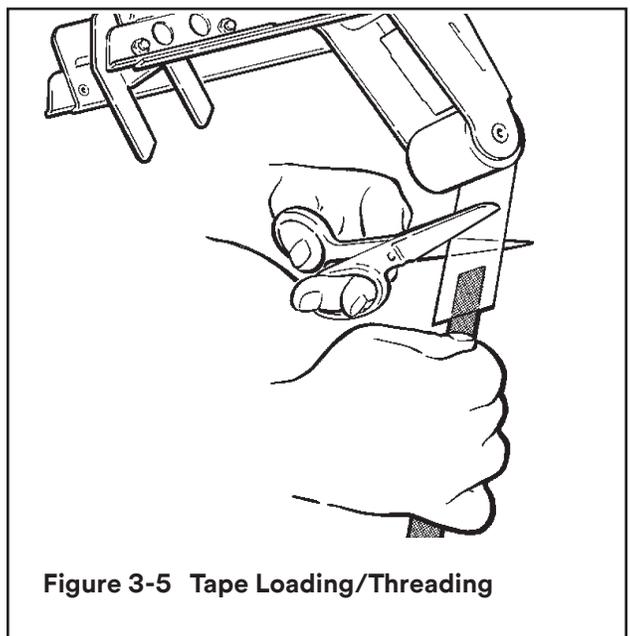


### **WARNING**

- 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.



**Figure 3-4** Tape Loading/Threading



**Figure 3-5** Tape Loading/Threading

# Maintenance

The AccuGlide™ 3 High Speed 3 inch Taping Head has been designed for long, trouble free service. The taping head will perform best when it receives routine maintenance and cleaning. Taping head components that fail or wear excessively should be promptly repaired or replaced to prevent damage to other portions of the head or to the product.

## Blade Replacement, Upper and Lower Taping Heads – Figure 4-1

1. Loosen, but do not remove, the blade screws (A). Remove and discard old blade.
2. Mount the new blade (B) with the beveled side away from the blade holder.
3. Bottom the blade slots against the screws (this will position the blade at the correct angle.) Tighten the blade screws to secure the blade.

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

## Blade Guard

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

## Blade Oiler Pad

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

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



## WARNING

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

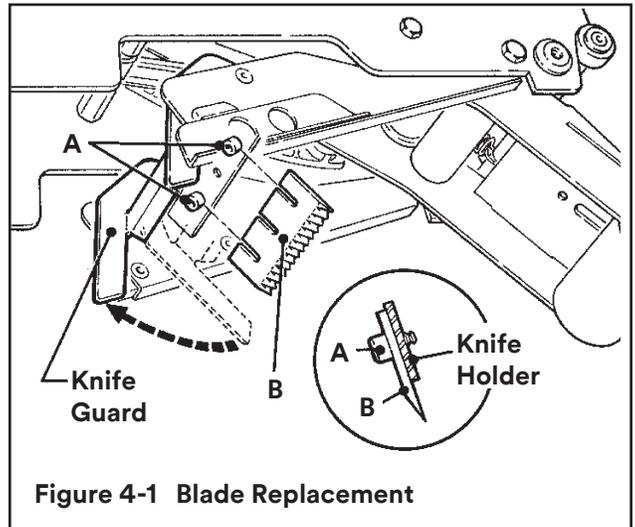


Figure 4-1 Blade Replacement



## WARNING

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

(Maintenance *continued* on next page.)

# Maintenance (continued)

## Cleaning

Regular slotted containers produce a great deal of dust and paper chips when conveyed through taping heads. If this dust is allowed to build-up on the heads, it can cause wear on the moving parts. Excessive dirt build-up should be wiped off with a damp cloth. Cleaning should be done once per month, depending on the number and type of boxes used. If the boxes used are dirty, or if the environment in which the heads operate is dusty, cleaning on a more frequent basis may be necessary.

**Note** – Never attempt to remove dirt from taping heads by blowing it out with compressed air. This can cause the dirt to be blown inside components onto sliding surfaces. Dirt in these areas can cause serious equipment damage. Never wash down or subject taping heads to conditions causing moisture condensation on components. Serious equipment damage could result.

## Applying/Buffering Roller Replacement

Replacing roller requires removal of shaft and mounting screws. With no area on the shaft to grip, the shaft often turns when attempting to remove the second screw. To ease removal of second screw, a 5mm hex socket has been provided at the bottom of the threads in both ends of the shaft. Insert a 4mm hex key wrench into this socket after removing one screw to hold the shaft for removal of the second screw. See **Figure 4-2**.



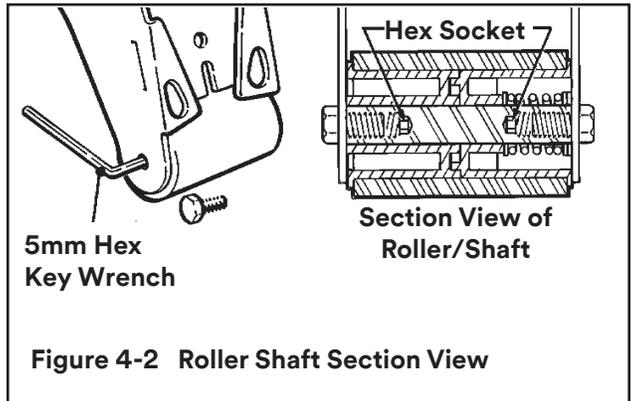
## WARNING

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



## WARNING

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



# Adjustments

## Tape Latch Alignment – Figure 5-1

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

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

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

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

1. Loosen locking hex nut behind tape drum bracket on tape drum shaft. Use an adjustable wrench or 25mm open end wrench.
2. Using 5mm Hex Wrench, turn tape drum shaft in/out to center tape web.
3. Tighten locking hex nut to secure the adjustment.

No other components require adjustment for tape web alignment.

## Tape Drum Friction Brake – Figure 5-3

The tape drum friction brake on taping head is pre-set for normal operation to prevent tape roll over travel. Should tension adjustment be required, turn self-locking nut on shaft to vary spring compression. Turn nut clockwise to increase braking force, and counterclockwise to decrease braking force.

Adjust brake to minimum tension to prevent tape roll over travel.

**Note** – Excess braking force will cause poor tape application and may lead to tape tabbing on trailing tape leg.

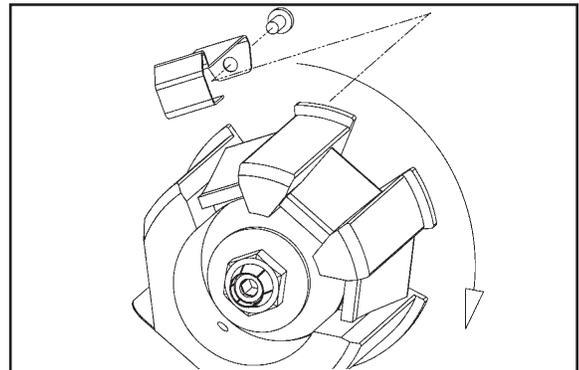


Figure 5-1 Tape Latch Alignment

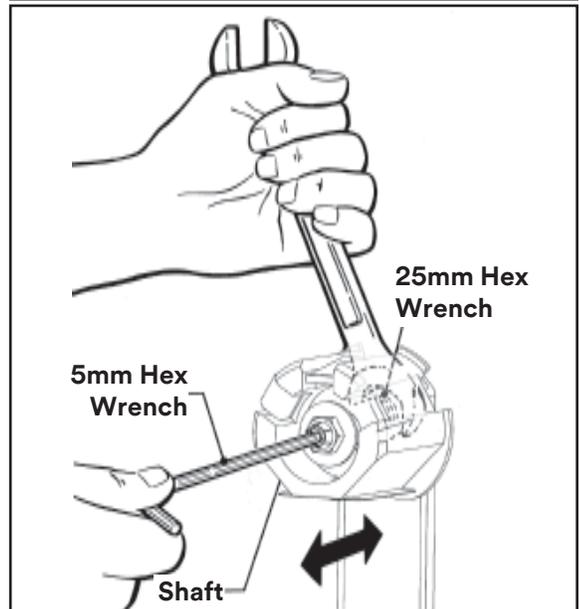


Figure 5-2 Tape Web Alignment

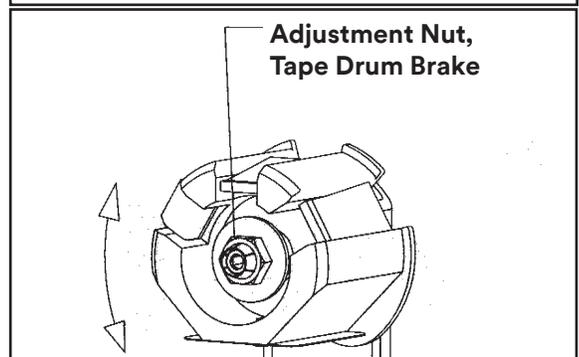


Figure 5-3 Tape Drum Friction Brake

### **WARNING**

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

(adjustments *continued* on next page.)

## Adjustments *(continued)*

### Applying Mechanism Spring

To obtain access to spring, remove taping head cover (four mounting screws). Replace cover to finish.

The applying mechanism spring, shown in **Figures 5-4A and 5-4B**, controls applying/buffing roller pressure on box and returns the mechanism to reset position. The spring pressure is pre-set, as shown in **Figure 5-4A** for normal operation, but is adjustable. If a tape gap appears on trailing surface of box increase spring pressure. If front of box is being crushed by applying roller decrease spring pressure. Removing spring end loop from spring holder and placing loop in other holes provided to adjust spring pressure (see **Figure 5-4B**).

### One-Way Tension Roller Figure 5-5

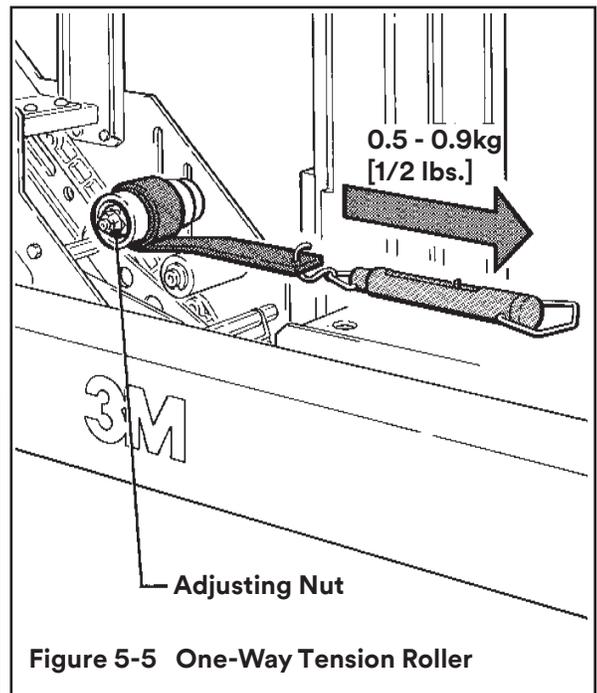
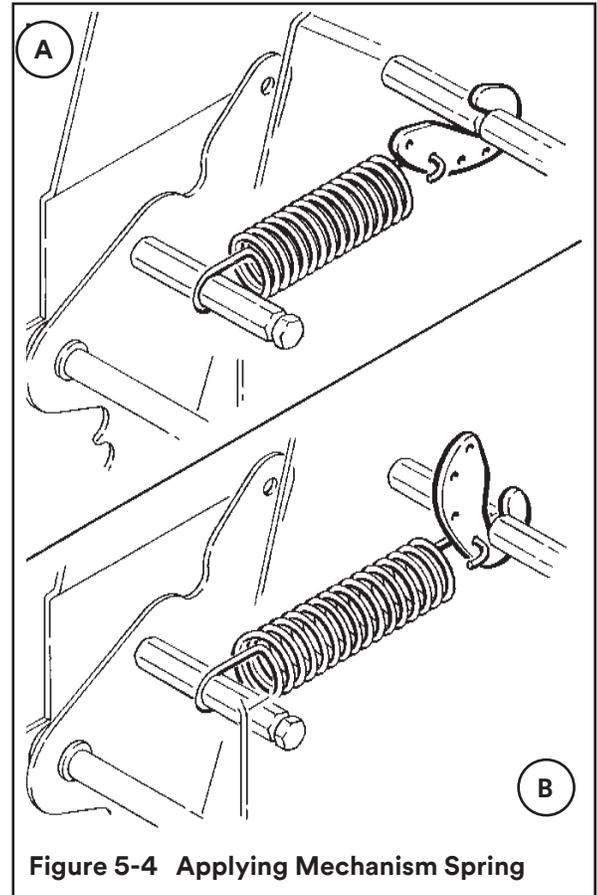
The one-way tension roller is factory set. When replacing this assembly, the roller must have 0,5 kg [1 lb.] min. tangential force when turning.

To Adjust Tension:

1. Wrap a cord or small strap (non-adhesive) 4-6 turns around the tension roller.
2. Attach a spring scale to the end of the cord or strap.
3. Turn adjusting nut (with socket wrench provided) until required force of approximately 0.5 kg to 0.9 kg [1 to 2 lbs.] is reached to turn roller pulling on spring scale.

### **WARNING**

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



(Adjustments *continued* on next page.)

# Adjustments *(continued)*

## Tape Leg Length

### Leading Tape Leg Length Adjustment – Figure 5-6

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

Moving this roller farther away from the box top or bottom surface will decrease the leading leg length.

Moving it closer to the box top or bottom surface will increase the leading leg length.

### Changing Tape Leg Length from 70 to 50mm [2 3/4-2 Inches] – Figure 5-7

**Note** – When changing tape leg length, both upper and lower heads must be adjusted to apply same leg lengths.

1. Remove and retain two hex head screws and remove the brush from normal position “A” on side frame.
2. Remount and secure brush in position “A-A” on side frame forward of normal location with original fasteners.
3. Remove cut-off bracket extensions from position “B”.
4. Remount cut-off bracket extensions in forward position “B-B”.
5. Remove/retain one-way tension roller assembly from slot “C” in frame.
6. Remount tension roller assembly near top of slot “C-C” in frame using original fasteners.
7. Adjust tension roller according to “Leading Tape Leg Length Adjustment” above.

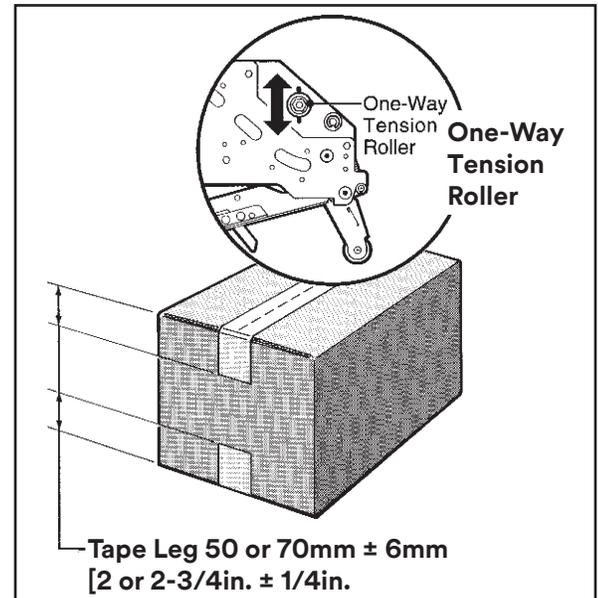


Figure 5-6 Leading Tape Leg Length

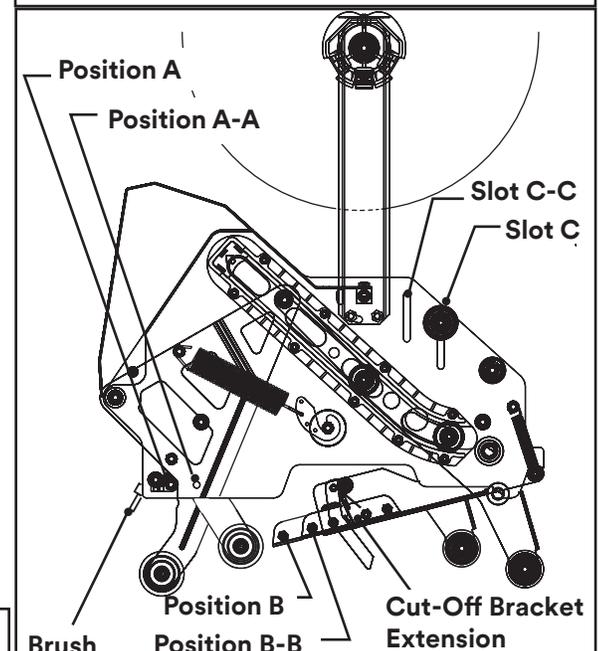


Figure 5-7 Changing Tape Leg Length

### **WARNING**

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

### **WARNING**

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

# Troubleshooting

## Troubleshooting Guide

Problem	Cause	Correction
The tape leg on the front of the case is too long	The tape is threaded incorrectly	The tape must go around the wrap roller before going around the one-way tension roller
	The tape tension is too low	Adjust the one-way tension roller
	The knurled roller drags	Check for adhesive build-up between the knurled roller and its shaft. Clean and lubricate shaft. Remove all lubricant from roller surfaces.
	Tape tracks to one side or drags on the support tabs of applying frame	Adjust the tape web alignments
	The one-way tension roller is not correctly positioned	Position the roller in its mounting slot so that the tape extends just beyond the centerline of the applying roller
	Taping head is not set up properly	Check leg length adjustments
The blade does not cut tape or the tape end is jagged/shredded	The blade is dull and/or has broken teeth	Replace the blade
	Tape tension is insufficient	Increase tape tension by adjusting the one-way tension roller
	Adhesive has built up on the blade	Clean and adjust the blade
	The blade not positioned properly	Make sure the blade is bottomed out against the mounting bolts
	The blade is dry	Lubricate the blade oiler pad on the blade guard
	The blade is in backwards	Mount the blade so that the beveled edge is away from the entrance of the head
	One or both cutter springs are missing or stretched	Replace the defective spring(s)
	Tension roller surface is not fully contacting the taping head frame	Make sure one-way bearing is below the surface of the tension roller. If not, press bearing further into roller or replace roller.

# Troubleshooting *(continued)*

## Troubleshooting Guide

Problem	Cause	Correction
Tape is tabbing on the trailing leg on the back of the box	<p>There is excess tension on the tape drum assembly and/or the one-way tension roller assembly</p> <p>Rollers in the tape path do not rotate freely</p> <p>The blade is not cutting tape properly</p> <p>The tape is threaded incorrectly</p> <p>Applying mechanism spring has too little tension</p>	<p>Adjust the one-way tension roller and/or the tape drum assembly</p> <p>Clean adhesive deposits from the surface, ends, and shafts of the rollers. Then lubricate roller shafts. Remove all lubricant from roller surfaces.</p> <p>Refer to tape cutting problems</p> <p>Re thread the tape</p> <p>Move spring hook to next tighter hole</p>
The tape end does not stay in application position in front of the applying roller	<p>The tape is incorrectly threaded</p> <p>Flanged knurled roller overruns on return of applying mechanism to its rest position</p> <p>Applying roller overruns on return of applying mechanism to its rest position</p> <p>The one-way tension roller is not correctly positioned</p> <p>The one-way tension roller is defective</p>	<p>Re-thread the tape</p> <p>Adjust tension roller position in mounting slot to lengthen tape leg</p> <p>There should be a slight drag when rotating the applying roller. If not, check friction springs and/or friction pins and replace if necessary</p> <p>Position roller in its mounting slot so that tape end extends beyond centerline of applying roller</p> <p>Replace the one-way tension roller</p>
Tape not centered on box seam	<p>Tape drum not centered</p> <p>Centering guides not centered</p> <p>Box flaps not of equal length</p>	<p>Reposition tape drum</p> <p>Adjust centering guides</p> <p>Check box specifications</p>

# Spare Parts/Service Information

## Recommended Spare Parts

Listed are a set of spare parts that will periodically require replacement due to normal wear. These parts should be ordered to keep the taping heads in production:

### AccuGlide™ 3 Upper Taping Head - 3 inch

Qty.	Part Number	Description
4	78-8076-4500-3	Stud – Mounting
1	78-8137-3311-6	Spring – Upper Extension
1	78-8028-7899-7	Blade – 89mm/3.5 Inch
2	78-8052-6602-6	Spring – Cutter
1	78-8076-4726-4	Tool – Tape Threading

### AccuGlide™ 3 Lower Taping Head - 3 inch

Qty.	Part Number	Description
1	78-8028-7899-7	Blade – 89mm/3.5 Inch
2	78-8052-6602-6	Spring – Cutter
4	78-8076-4500-3	Stud – Mounting
1	78-8137-3312-4	Spring – Lower Extension
1	78-8076-4726-4	Tool – Tape Threading

In addition to the above set of spare parts supplied with the taping head, it is suggested that the following spare parts be maintained which will require replacement under normal wear of the taping head.

Qty.	Part Number	Description
1	78-8057-6181-0	Roller – Applying
1	78-8057-6180-2	Roller – Buffing
1	78-8113-7030-9	Spring – Torsion

## Replacement Parts and Service

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



## Spare Parts/Service Information *(continued)*

### Replacement Parts Illustrations and Parts Lists

AccuGlide™ 3 High Speed 3 inch Upper Taping Head, Type 11400

AccuGlide™ 3 High Speed 3 inch Lower Taping Head, Type 11400

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

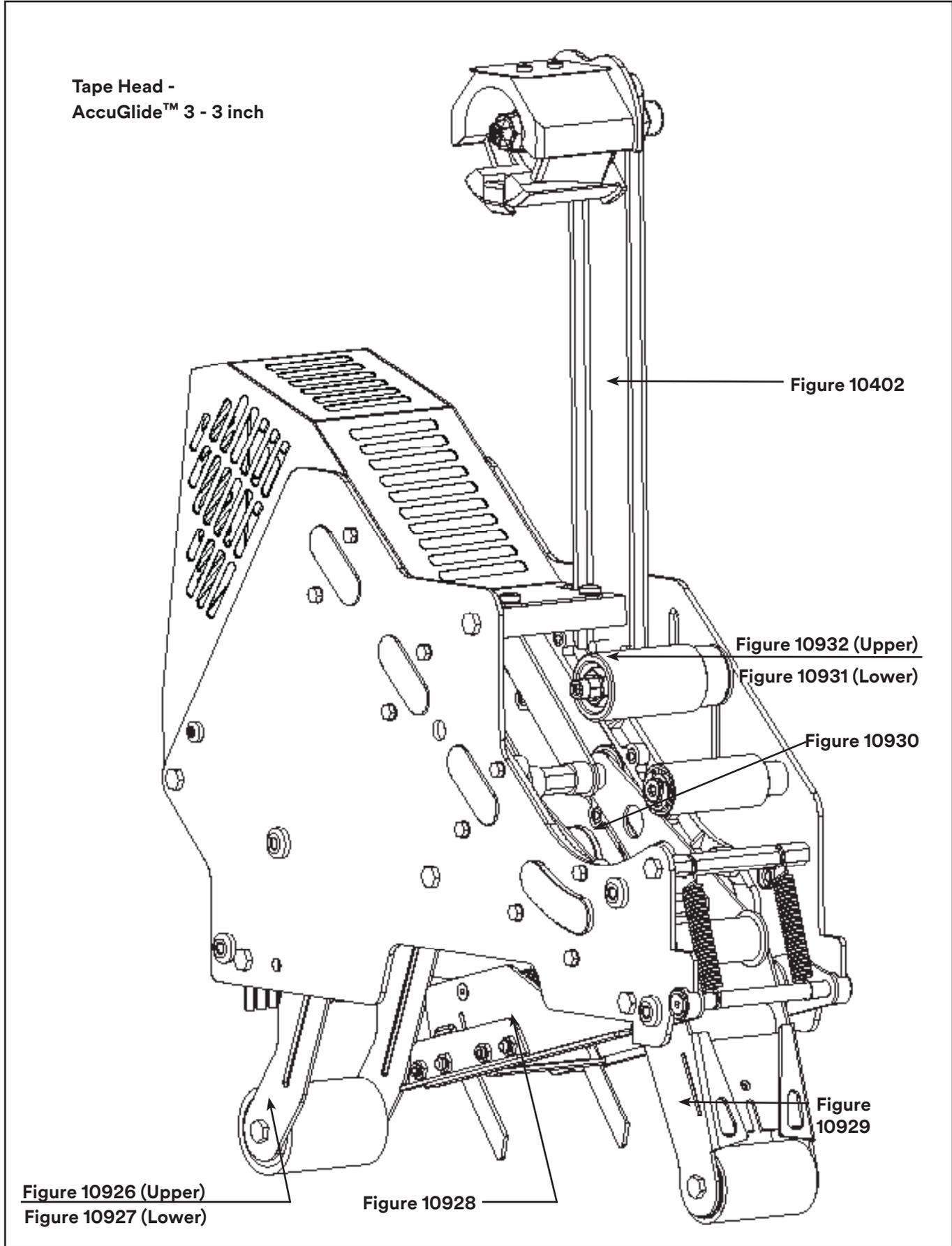
**Note** – The complete description has been included for standard fasteners and some commercially available components. This has been done to allow obtaining these standard parts locally, should the customer elect to do so.

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

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



Tape Head -  
AccuGlide™ 3 - 3 inch



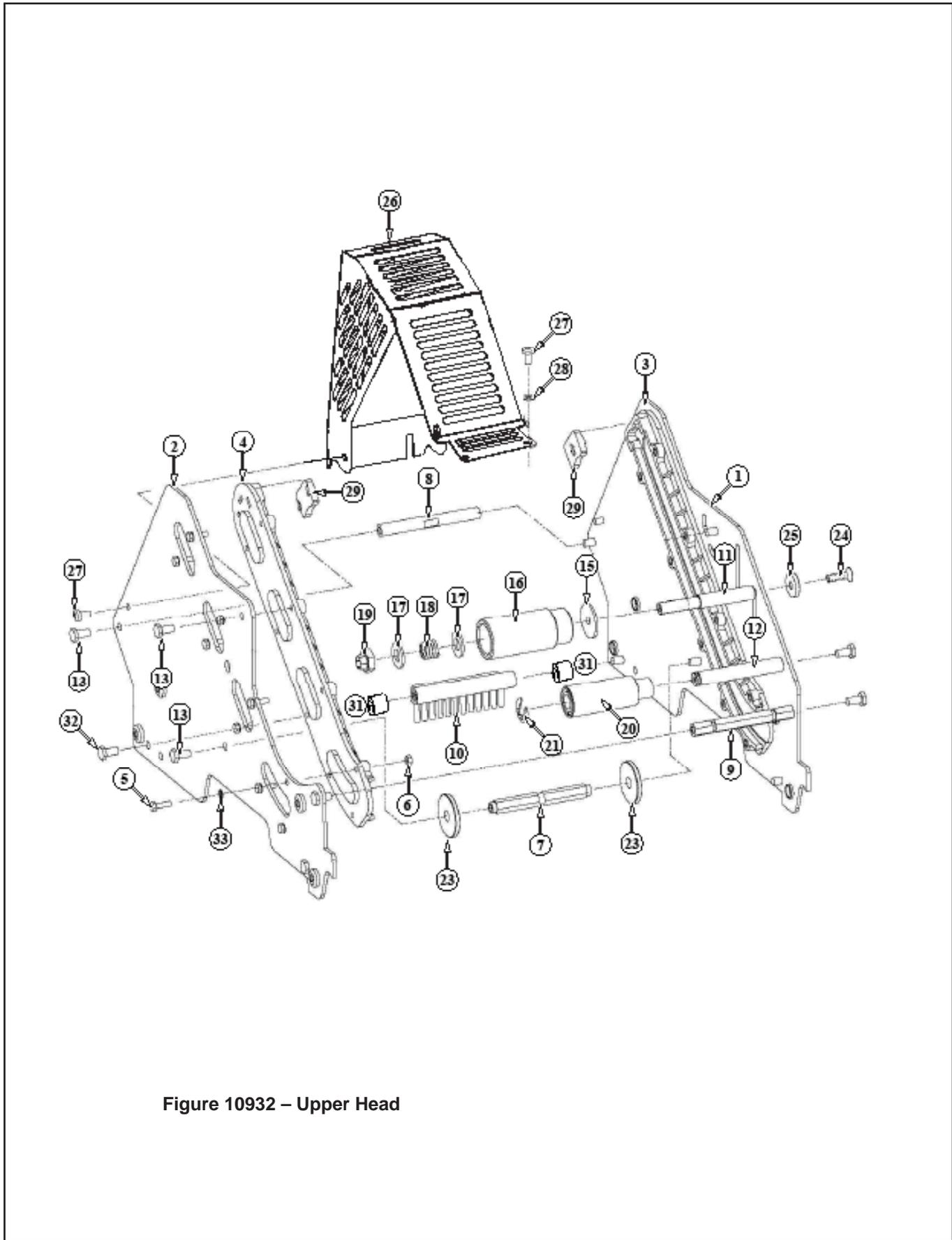


Figure 10932 – Upper Head

Figure 10932 – Upper Head

Ref. No.	3M Part No.	Description
10932-1	78-8137-3294-4	Frame – Tape Mount Upper Assembly
10932-2	78-8137-3295-1	Frame – Front Upper Assembly
10932-3	78-8068-4143-9	Guide – #1
10932-4	78-8068-4144-7	Guide – #2
10932-5	78-8060-7818-0	Screw – Hex Hd, M4 x 12
10932-6	78-8010-7416-8	Nut – Hex Jam, M4
10932-7	78-8076-4735-5	Spacer – Spring
10932-8	78-8137-3309-0	Shaft - Pivot 115mm
10932-9	78-8060-7939-4	Spacer – 10 x 115 W/Slots
10932-10	78-8060-7936-0	Brush Assembly
10932-11	78-8054-8796-0	Shaft – Tension Roller
10932-12	78-8054-8798-6	Shaft – Wrap Roller
10932-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10932-15	78-8100-1009-6	Washer – Special
10932-16	78-8054-8797-8	Roller – Top Tension
10932-17	26-1004-5510-9	Washer – Plain, M10
10932-18	78-8052-6567-1	Spring – Compression
10932-19	78-8017-9077-1	Nut – Self Locking, M10 x 1
10932-20	78-8054-8799-4	Roller – Wrap
10932-21	26-1000-1613-3	Ring – Retaining, Tru-Arc #1-420-0120-100
10932-22	78-8076-4500-3	Stud – Mounting (not shown)
10932-23	78-8076-5242-1	Stop – Cut-Off Frame
10932-24	78-8060-8179-6	Screw - Flat Head Hex, M6 x 20
10932-25	78-8076-5477-3	Washer – Special, 6.5 x 20 x 4
10932-26	78-8137-3310-8	Guard – Head
10932-27	78-8060-8087-1	Screw – M5 x 10
10932-28	78-8005-5741-1	Washer – Flat, M5
10932-29	78-8133-9615-3	Bumper
10932-30	78-8133-9605-4	Label – Threading, English Language
10932-31	78-8060-7937-8	Spacer 6.5 / 14 x 12.5
10932-32	78-8060-7938-6	Screw - Low Profile M6 x 25
10924-33	78-8076-4716-5	Star Washer 4mm

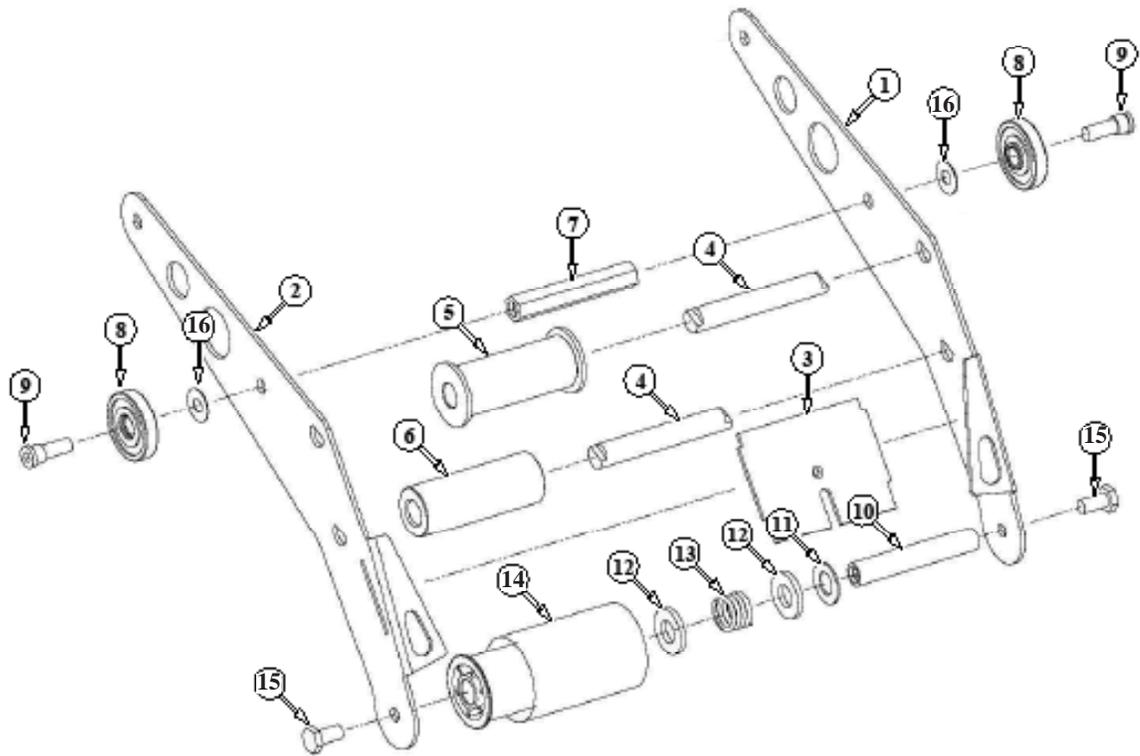


Figure 10929 – Upper and Lower Heads

Figure 10929 – Upper and Lower Heads

Ref. No.	3M Part No.	Description
10929-1	78-8133-9520-5	Arm – Applying, R/H
10929-2	78-8133-9521-3	Arm – Applying, L/H
10929-3	78-8070-1292-3	Plate – Back-Up
10929-4	78-8076-4736-3	Shaft Roller
10929-5	78-8076-4737-1	Roller Assembly – Knurled
10929-6	78-8076-4738-9	Roller – Wrap
10929-7	78-8054-8806-7	Spacer
10929-8	78-8017-9082-1	Bearing – Special, 30 mm
10929-9	78-8017-9106-8	Screw – Bearing Shoulder
10929-10	78-8054-8801-8	Shaft – 10 x 85, W/Hexagon
10929-11	78-8017-9074-8	Washer – Nylon, 15mm
10929-12	26-1004-5510-9	Washer – Friction
10929-13	78-8052-6567-1	Spring – Compression
10929-14	78-8137-1392-8	Assembly– Applying Roller
10929-15	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10929-16	78-8094-6151-6	Washer - Flat, 6.5 ID x 15 OD x 0.5 Thk

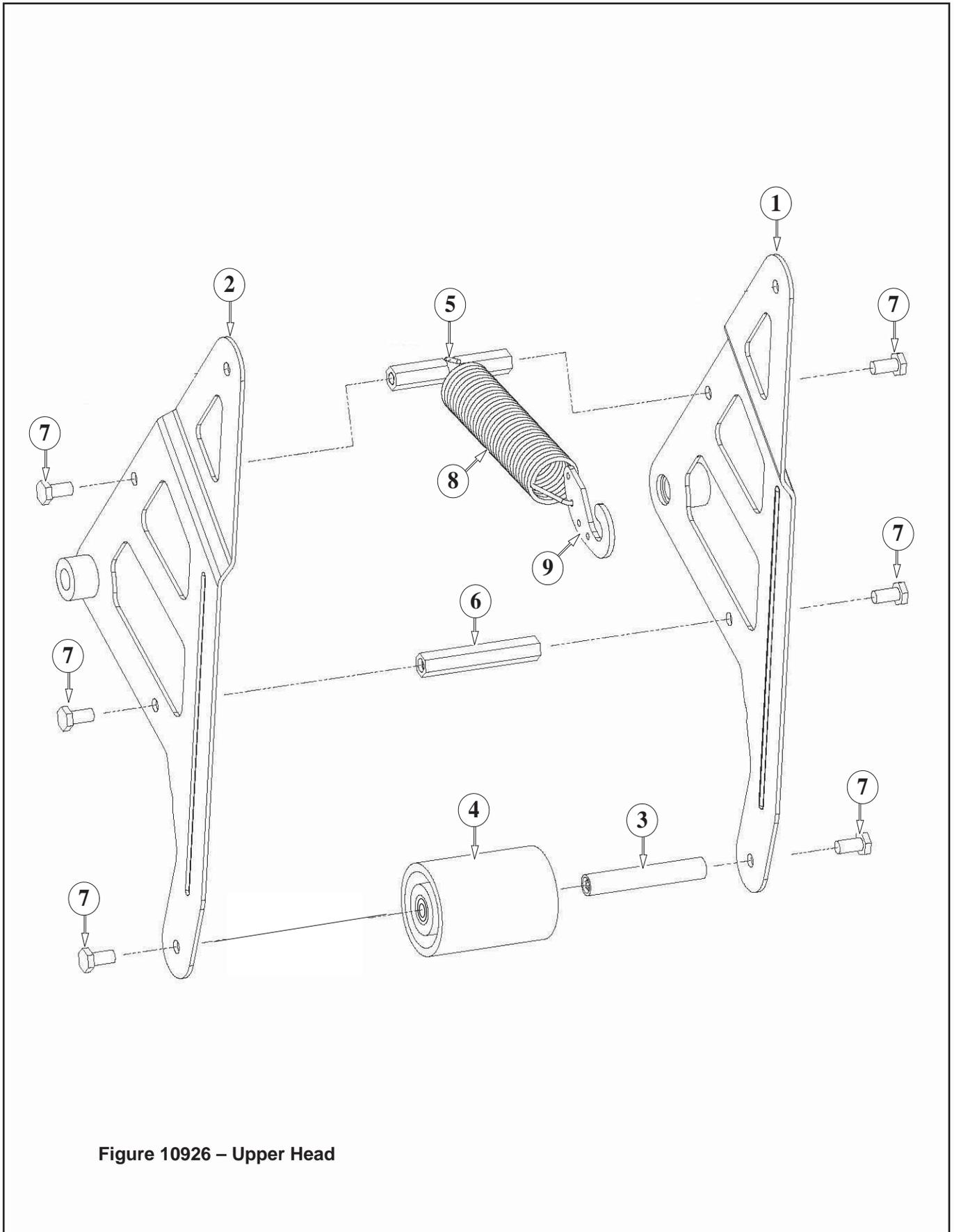


Figure 10926 – Upper Head

Figure 10926 – Upper Head

Ref. No.	3M Part No.	Description
10926-1	78-8137-3300-9	Buffing Arm – Sub Assembly
10926-2	78-8137-3301-7	Buffing Arm – Sub Assembly
10926-3	78-8091-0799-4	Shaft – 10 x 85, W/Hexagon
10926-4	78-8137-1397-7	Roller – Buffing Assembly
10926-5	78-8076-4739-7	Spacer – Spring
10926-6	78-8052-6580-4	Spacer
10926-7	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10926-8	78-8137-3311-6	Spring – Upper (100 fpm)
10926-9	78-8070-1244-4	Holder – Spring

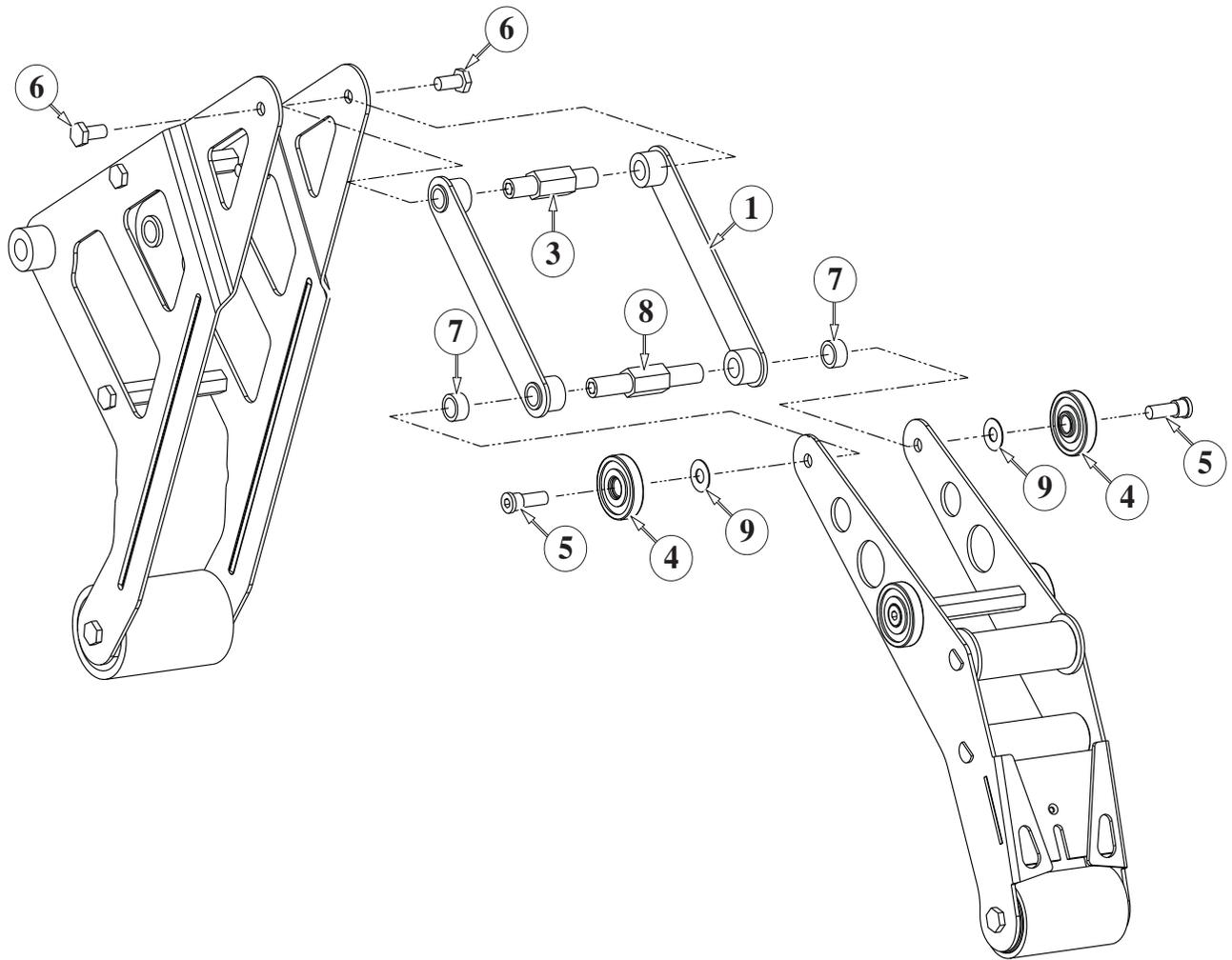


Figure 10930 – Upper and Lower Heads

Figure 10930 – Upper and Lower Heads

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
10930-1	78-8137-3302-5	Link – R/H Assembly
10930-3	78-8137-3314-0	Shaft – Pivot, Buffing
10930-4	78-8017-9082-1	Bearing – Special 30 mm
10930-5	78-8017-9106-8	Screw – Bearing Shoulder
10930-6	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10930-7	78-8137-3305-8	Spacer – Applying Pivot
10930-8	78-8137-3313-2	Shaft – Pivot, Applying
10930-9	78-8094-6151-6	Washer - Flat, 6.5 ID x 15 OD x 0.5 Thk

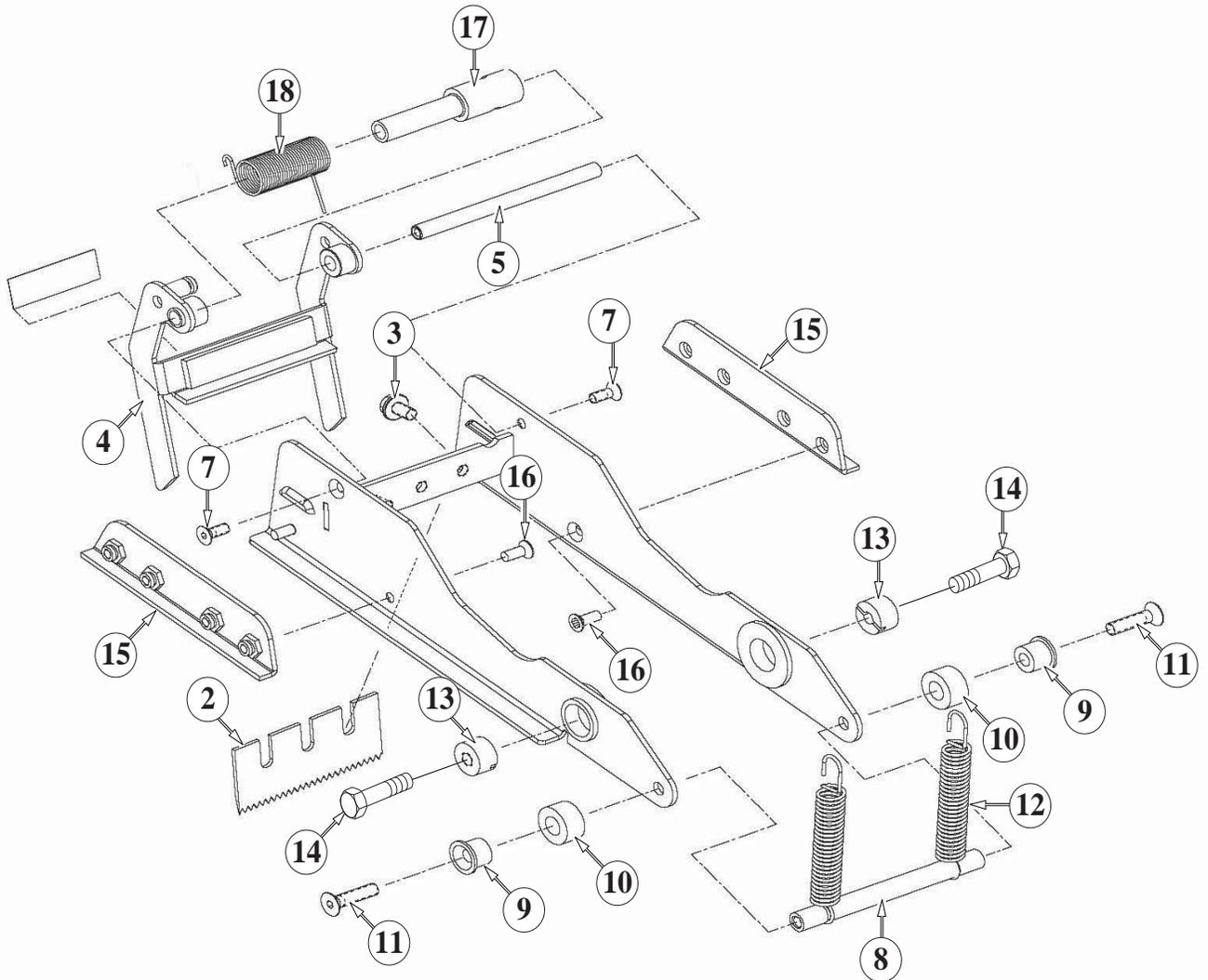


Figure 10928 – Upper and Lower Heads

Figure 10928 – 3" Upper and Lower Heads

Ref. No.	3M Part No.	Description
10928-1	78-8070-1283-2	Frame – Cut-Off
10928-2	78-8028-7899-7	Knife – 89 mm/3.5 Inch
10928-3	26-1002-5817-2	Screw – Hex Hd, M5 x 8
10928-4	78-8076-4741-3	Knife Guard Assembly – W/English Language Label
10928-5	78-8054-8813-3	Shaft – Knife Guard
10928-7	26-1005-4758-2	Screw – Flat Hd, Soc Dr, M4 x 10
10928-8	78-8060-7941-0	Pin – Spring Holder W/Slots
10928-9	78-8052-6600-0	Spacer
10928-10	78-8070-1269-1	Bumper
10928-11	26-1005-4757-4	Screw – Flat Hd, Soc Dr, M5 x 20
10928-12	78-8052-6602-6	Spring – Cutter
10928-13	78-8017-9132-4	Pivot – Cutter Lever
10928-14	26-1003-5828-7	Screw – Spec, Hex Hd, M6 x 10
10928-15	78-8070-1216-2	Slide – Extension
10928-16	26-1008-6574-5	Screw – Flat Hd, Phil Dr, M4 x 10
10928-17	78-8113-7060-6	Bushing – 83.7 mm Long
10928-18	78-8113-7030-9	Spring – Torsion
10928-19	78-8070-1335-0	Label – Warning, English

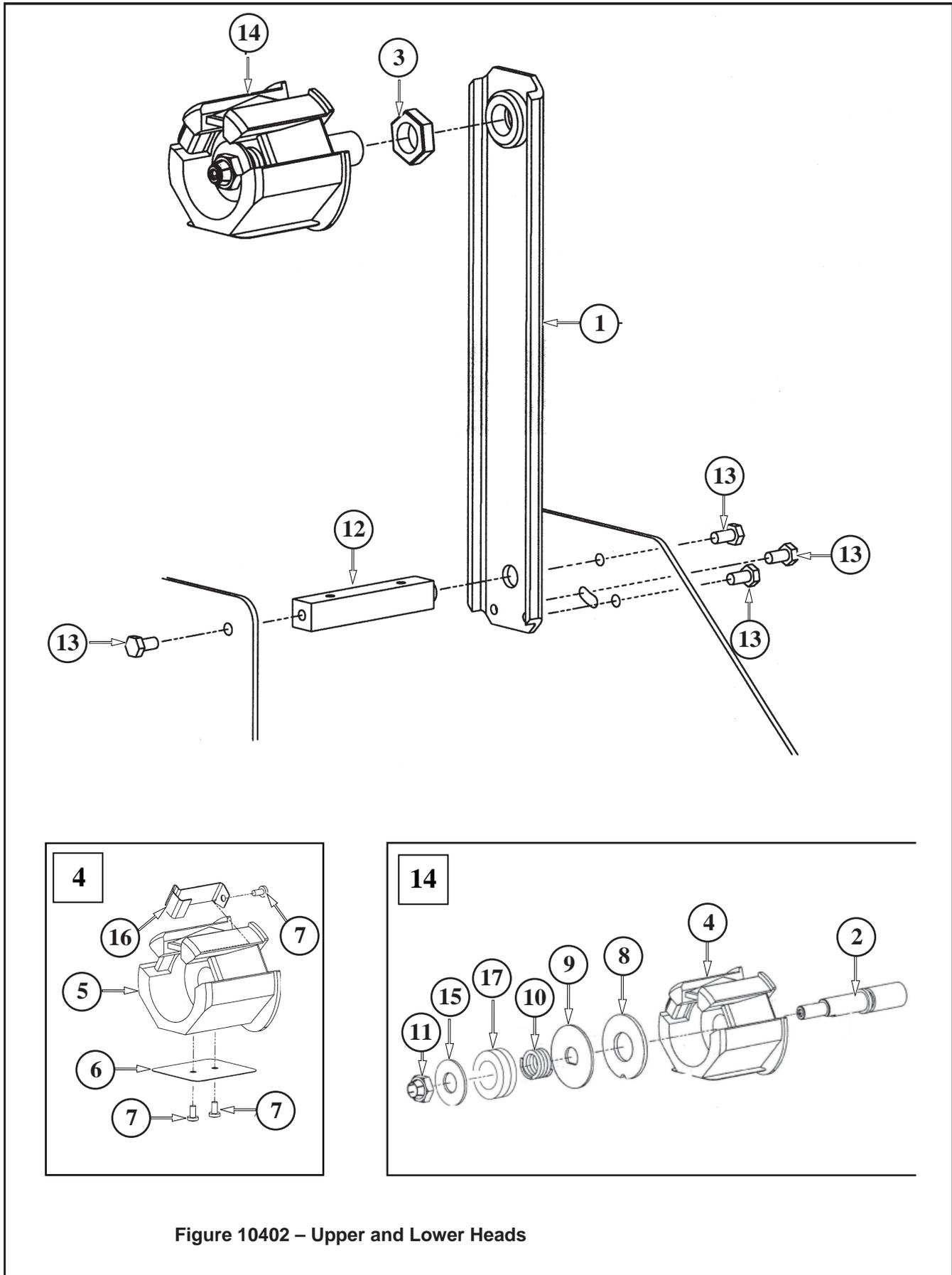


Figure 10402 – Upper and Lower Heads

Figure 10402 – 3" Latch Upper and Lower Heads

Ref. No.	3M Part No.	Description
10402-1	78-8070-1395-4	Bracket – Bushing Assembly
10402-2	78-8060-8462-6	Shaft – Tape Drum, 3 Inch Head
10402-3	78-8017-9169-6	Nut – M18 x 1
10402-4	78-8098-8829-6	Tape Drum Sub Assembly – 3 Inch Wide
10402-5	78-8098-8828-8	Tape Drum
10402-6	78-8098-8830-4	Leaf Spring
10402-7	26-1002-5753-9	Screw – Self Tapping
10402-8	78-8060-8172-1	Washer – Friction
10402-9	78-8052-6271-0	Washer – Tape Drum
10402-10	78-8100-1048-4	Spring – Core Holder
10402-11	78-8017-9077-1	Nut – Self Locking, M10 x 1
10402-12	78-8100-1050-0	Spacer – Bracket
10402-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10402-14	78-8133-9641-9	Tape Drum Assembly – 3 Inch Head
10402-15	26-1004-5510-9	Washer – Plain, M10
10402-16	78-8098-8816-3	Latch – Tape Drum
10402-17	78-8052-6651-3	Washer - Nylon

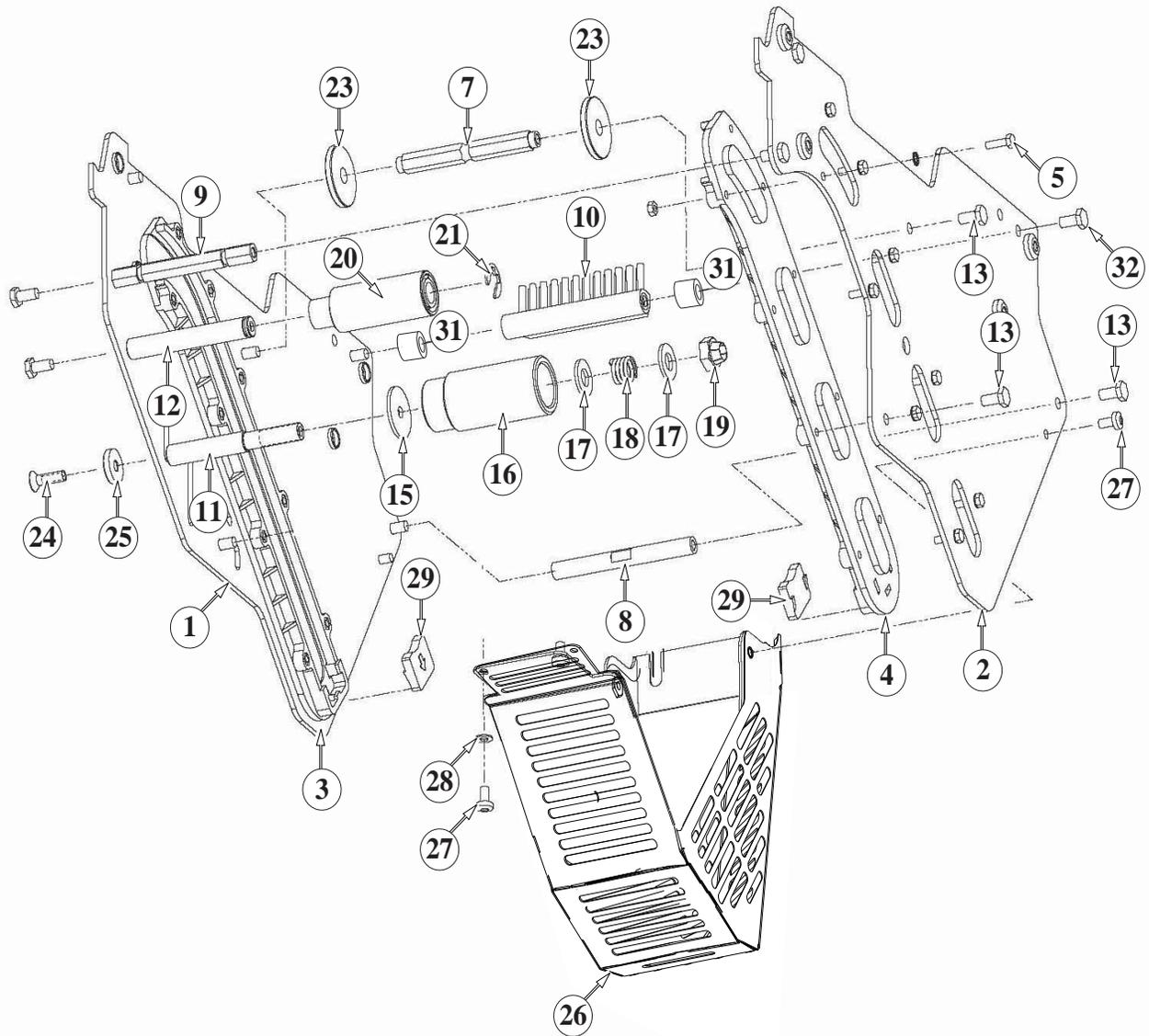


Figure 10931 – Lower Head

Figure 10931 – Lower Head

Ref. No.	3M Part No.	Description
10931-1	78-8137-3296-9	Frame – Tape Mount Lower Assembly
10931-2	78-8137-3297-7	Frame – Front Lower Assembly
10931-3	78-8068-4144-7	Guide – #2
10931-4	78-8068-4143-9	Guide – #1
10931-5	83-0002-7336-3	Screw – Hex Hd, M4 x 14
10931-6	78-8010-7416-8	Nut – Hex, M4
10931-7	78-8076-4735-5	Spacer – Spring
10931-8	78-8137-3309-0	Spacer – 10 x 10 x 115 mm
10931-9	78-8060-7939-4	Spacer – 10 x 115, W/Slots
10931-10	78-8060-7936-0	Brush Assembly
10931-11	78-8054-8796-0	Shaft – Tension Roller
10931-12	78-8054-8798-6	Shaft – Wrap Roller
10931-13	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10931-15	78-8100-1009-6	Washer – Special
10931-16	78-8054-8817-4	Roller – Tension Bottom
10931-17	26-1004-5510-9	Washer – Plain, M10
10931-18	78-8052-6567-1	Spring – Compression
10931-19	78-8017-9077-1	Nut – Self Locking, M10 x 1
10931-20	78-8054-8799-4	Roller – Wrap
10931-21	26-1000-1613-3	Ring – Retaining, Tru-Arc #1-420-0120-100
10931-22	78-8076-4500-3	Stud – Mounting (not shown)
10931-23	78-8076-5242-1	Stop – Cut-Off Frame
10931-24	78-8060-8179-6	Screw – Flat Head Hex, M6 x 20
10931-25	78-8076-5477-3	Washer – Special /6.5 x 20 x 4
10931-26	78-8137-3310-8	Guard – Head
10931-27	78-8060-8087-1	Screw – M5 x 10
10931-28	78-8005-5741-1	Washer – Flat, M5
10931-29	78-8133-9615-3	Bumper
10931-30	78-8133-9606-2	Label – Threading, English Language
10931-31	78-8060-7937-8	Spacer 6.5 / 14 x 12.5
10931-32	78-8060-7938-6	Screw - Low Profile M6 x 25
10924-33	78-8076-4716-5	Star Washer 4mm

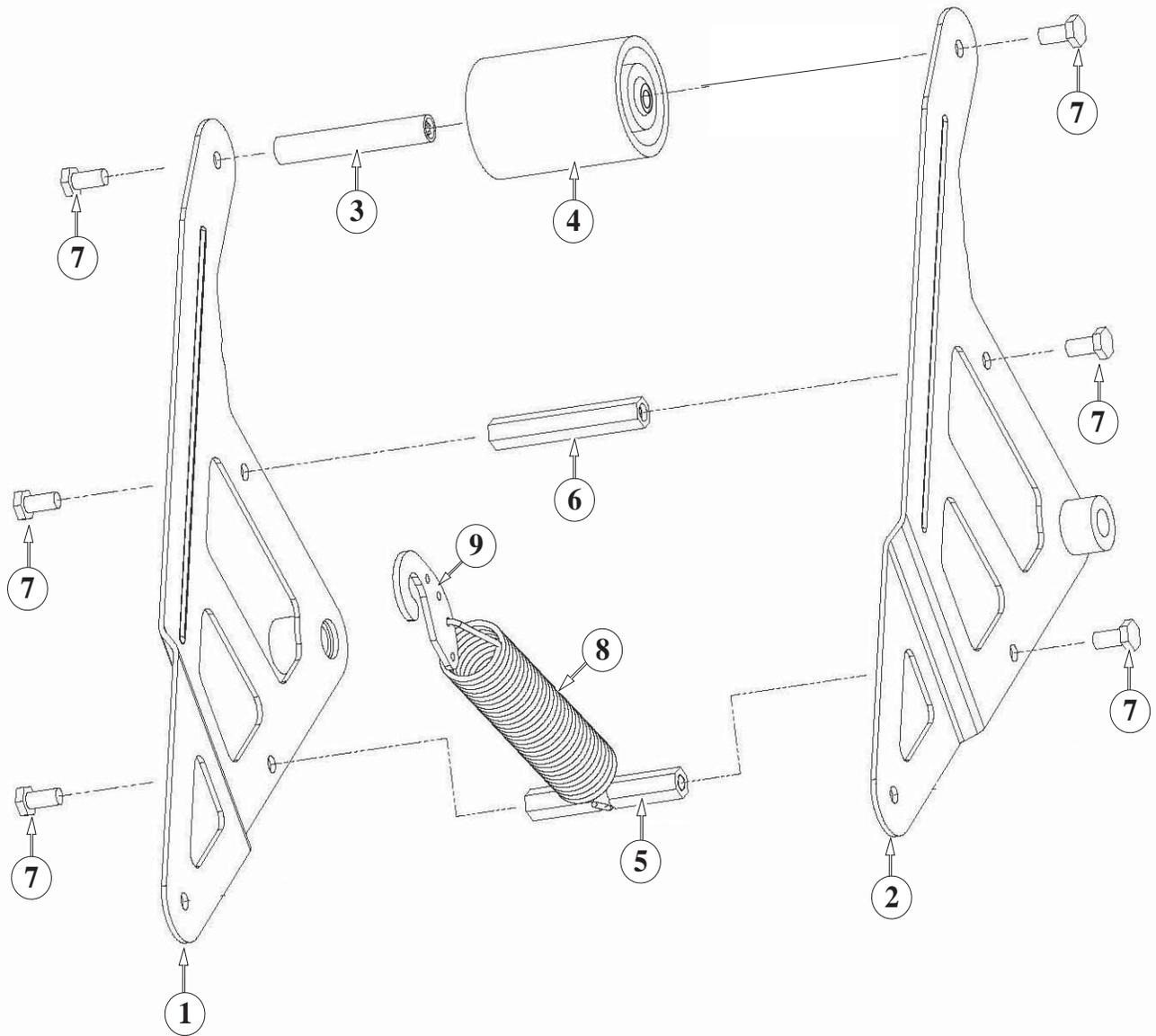


Figure 10927 – Lower Head

Figure 10927 – Lower Head

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
10927-1	78-8137-3300-9	Buffing Arm – Sub Assembly
10927-2	78-8137-3301-7	Buffing Arm – Sub Assembly
10927-3	78-8091-0799-4	Shaft – 10 x 85, W/Hexagon
10927-4	78-8137-1397-7	Roller – Buffing
10927-5	78-8076-4739-7	Spacer – Spring
10927-6	78-8052-6580-4	Spacer
10927-7	26-1003-5829-5	Screw – Hex Hd, M6 x 12
10927-8	78-8137-3312-4	Spring – Lower (100 fpm)
10927-9	78-8070-1244-4	Holder – Spring





