3M Science. Applied to Life.™

Instructions and Parts List

3M-Matic™ 8000r-8000r3

Type 12300

Random Case Sealer with AccuGlide™ V HSP 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.

North American - ENG
Date Released:
May 2023

This instruction manual covers safety aspects, handling and transport, storage, unpacking, preparation, installation, operation, adjustments, maintenance, troubleshooting, repair work and servicing plus parts list of the **3M-Matic™ 8000r-8000r3** Random case sealer.

Industrial Specialties Division
3M Center
St. Paul, MN 55144-1000

Edition May 2023

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

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:

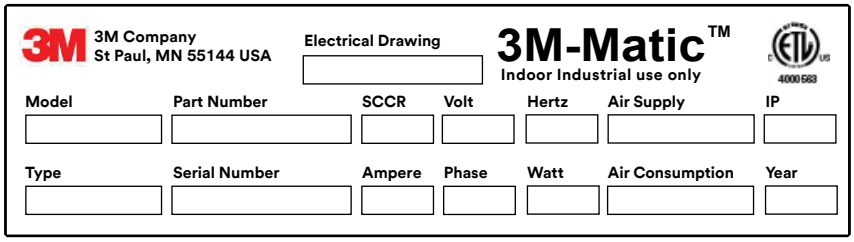
For technical assistance, contact our help line at 1-800-328-1390. Provide the customer support coordinator with the model/machine name, machine type, and serial number that are located on the identification plate (For example: Model 8000r-8000r3 - Type 12300 - Serial Number 13282).

To order replacement parts, contact us:

CSPD division of Combi Packaging Systems LLC.
6299 Dressler Road NW
North Canton, OH 44720

1-800-344-9883
e-mail: CSPD@combi.com

Identification Plate



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.

Table of Contents — Manual 1:
8000r-8000r3 Random Case Sealer

(For Taping Head information, see Manual 2: AccuGlide™ V Taping Heads)

Table of Contents — Manual 1: *(continued)*

Table of Contents — Manual 1: *(continued)*

TAPING HEAD INFORMATION -
MANUAL 2: AccuGlide™ V (See MANUAL 2 for Table of Contents)

Abbreviations and Acronyms

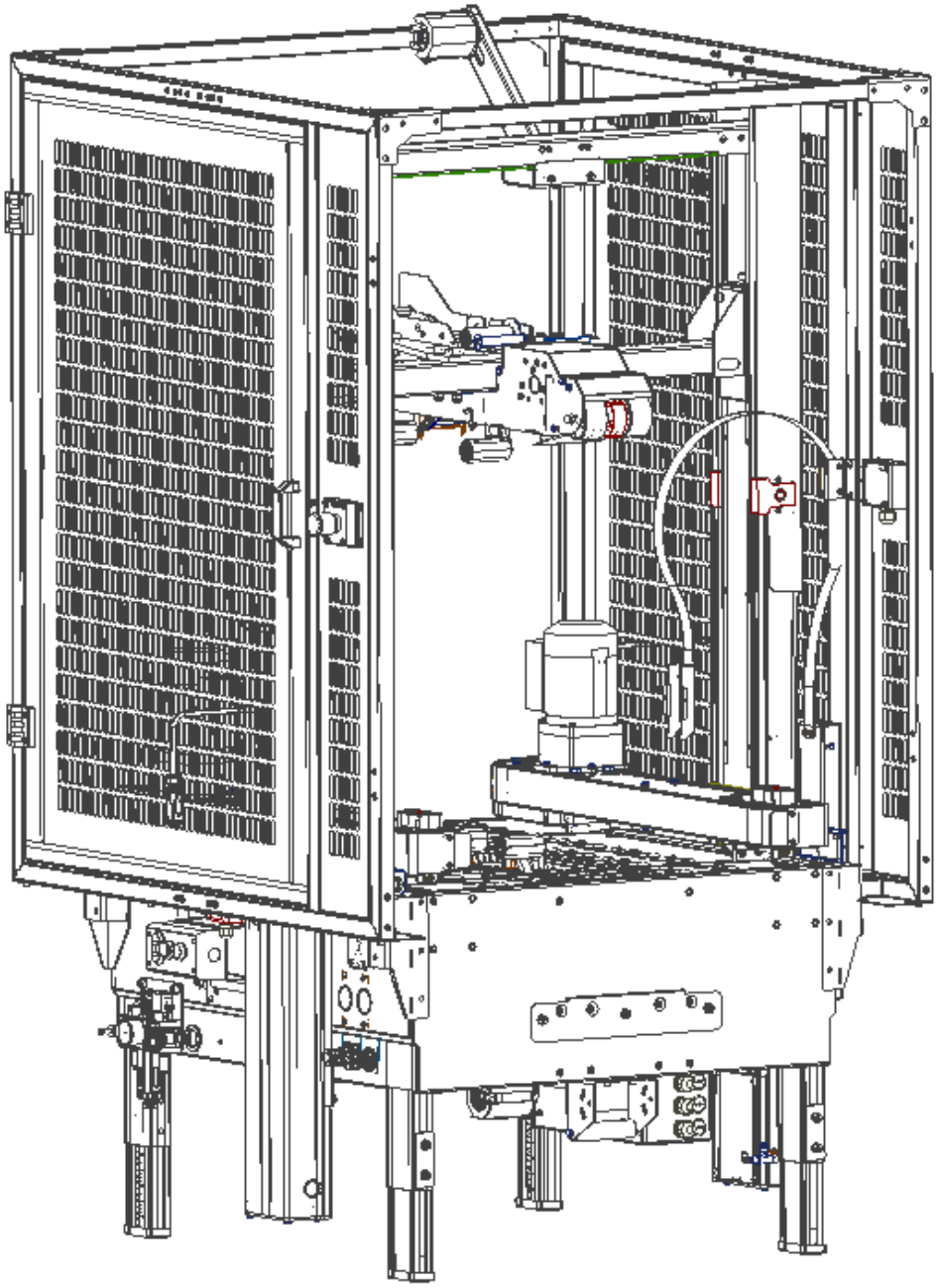
List of Abbreviations/Acronyms

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	Polytetrafluoroethylene
PVC	Polyvinyl Chloride
W	Width
H	Height
L	Length

1. Introduction

1.1 Manufacturing Specifications / Description / Intended Use

The **3M-Matic™ 8000r-8000r3 Random Case Sealer** with **AccuGlide™ V** 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 **8000r-8000r3** automatically adjusts 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™ 8000r-8000r3 Random Case Sealer, Type 12300

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 o symbols, plus a parts list of the 3M-Matic™ **8000r-8000r3** Random Case Sealer.

3M Industrial Specialties Division
3M Center
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 2023 44-0009-2xxx-x.

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

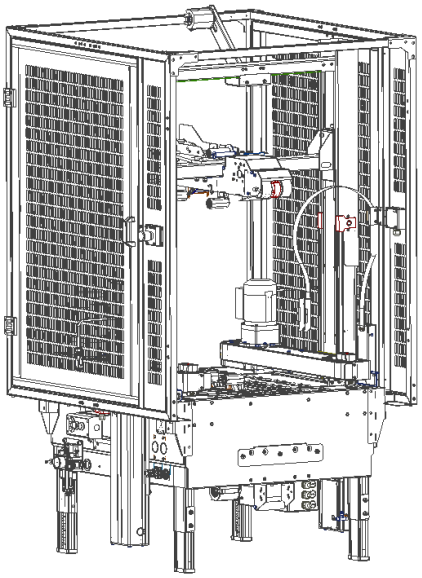
Modifications to the machine are subject to manufacturer's internal procedures. The user receives a complete and up-to-date copy of the manual together with the machine. Afterwards the user may receive pages or parts of the manual which contain amendments or improvements made after its first publication.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

2. General Information

2.1 Data Identifying Manufacturer and Machine

3M Industrial Specialties Division

3M Center
St. Paul, MN 55144-1000 (USA)



Identification Plate

3M Company
St Paul, MN 55144 USA

Electrical Drawing

3M-Matic™
Indoor Industrial use only

Model	Part Number	SCCR	Volt	Hertz	Air Supply	IP

Type	Serial Number	Ampere	Phase	Watt	Air Consumption	Year

2.2 Warranty

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

3M sells its **3M-Matic™ 8000r-8000r3 Random Case Sealer, Type 12300** 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: 8000r-8000r3 Random Case Sealer

(1) 8000r-8000r3 Random Case Sealer, Type 12300

(1) Tool and Spare Parts Kit

(1) Instruction and Parts Manual

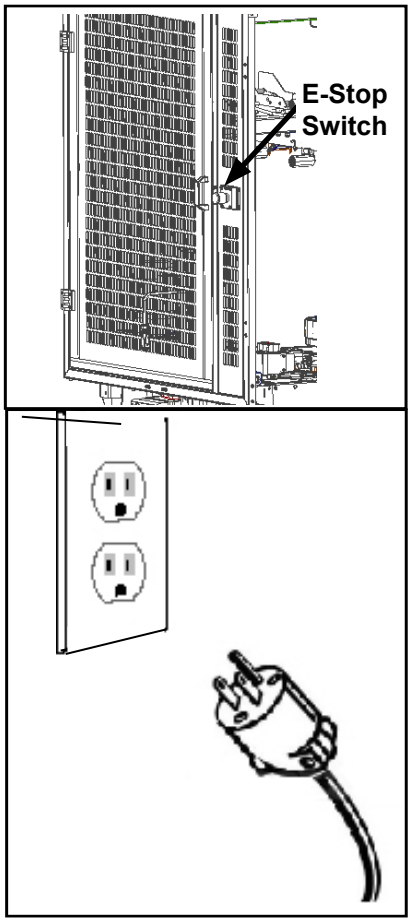
Scotch™, **AccuGlide™**, and **3M-Matic™** are Trademarks of 3M, St. Paul, Minnesota 55144-1000

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.

3.3 Table of Warnings

Warning

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

Warning

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

Warning

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

Warning

- **To reduce the risk associated with pinches and entanglement hazards:**
- Do not leave the machine running while unattended.
- Turn the machine off when not in use.
- Never attempt to work on any part of the machine, load tape, or remove jammed boxes from the machine while the machine is running.

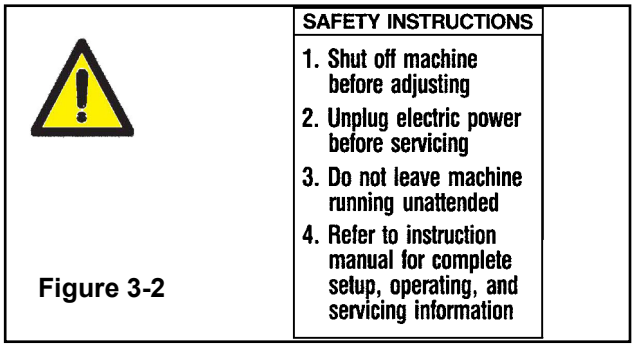


Figure 3-2

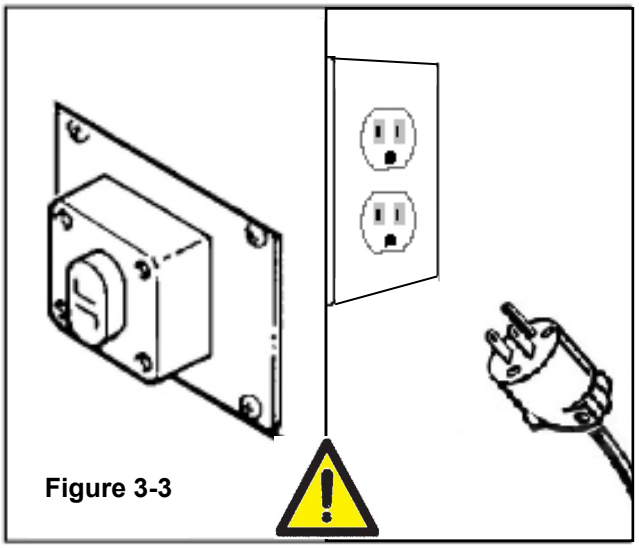


Figure 3-3

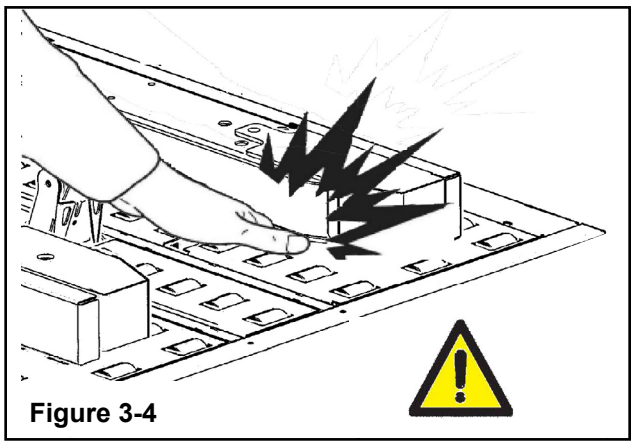


Figure 3-4

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)**.

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! 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).**

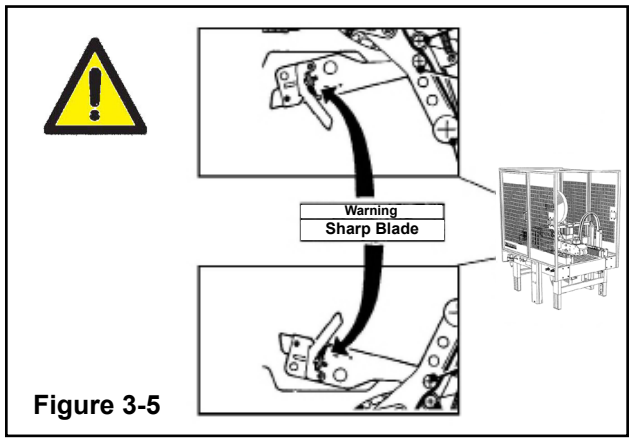


Figure 3-5

Warning

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

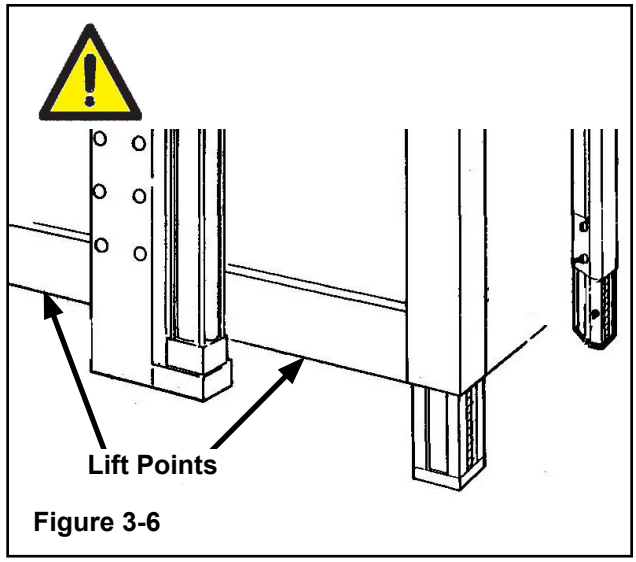


Figure 3-6

Warning

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

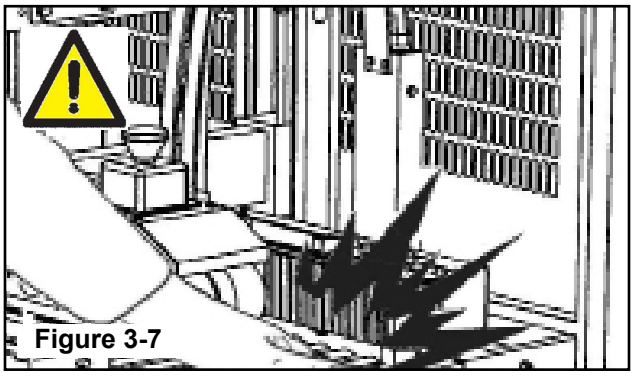


Figure 3-7

Caution

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

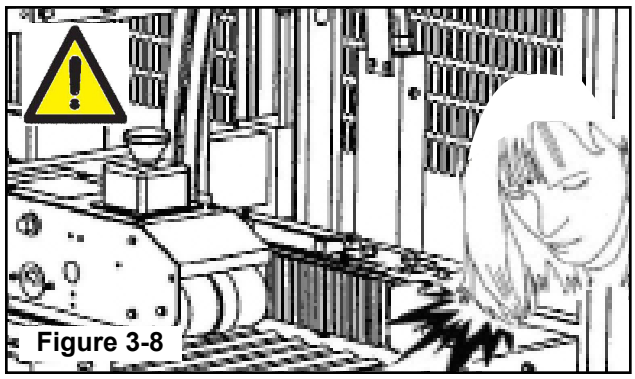


Figure 3-8

3.4 Operator's Qualifications

- Machine Operator
- Mechanical Maintenance Technician
- Electrical Maintenance Technician
- Manufacturer's Technician/Specialist **(See Section 3.11)**

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 **8000r-8000r3** 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. They 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.

3.11 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 they are

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

They are 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

3.12 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 or 3 for taping head components.

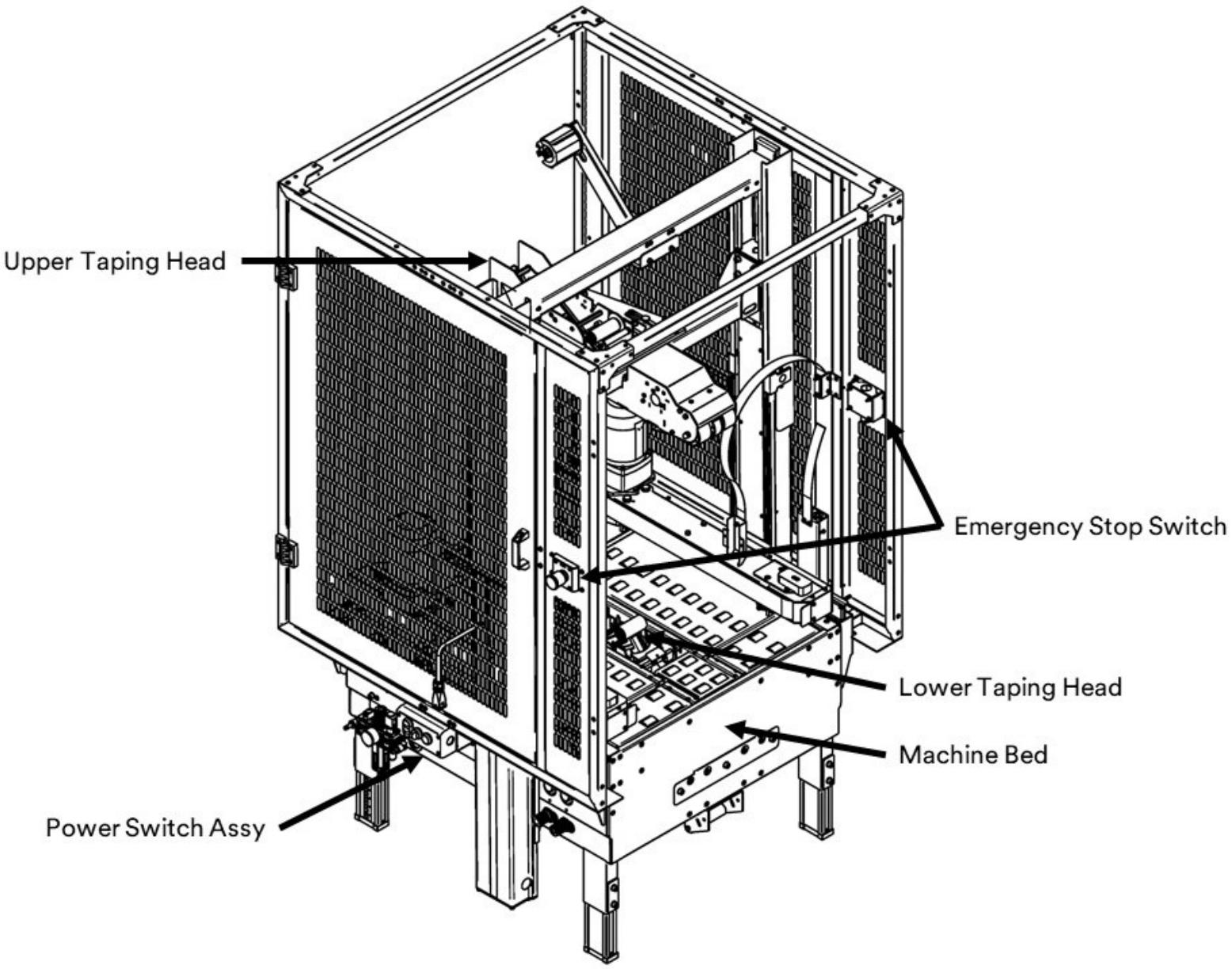


Figure 3-9 8000r-8000r3 Case Sealer Components (Left Front

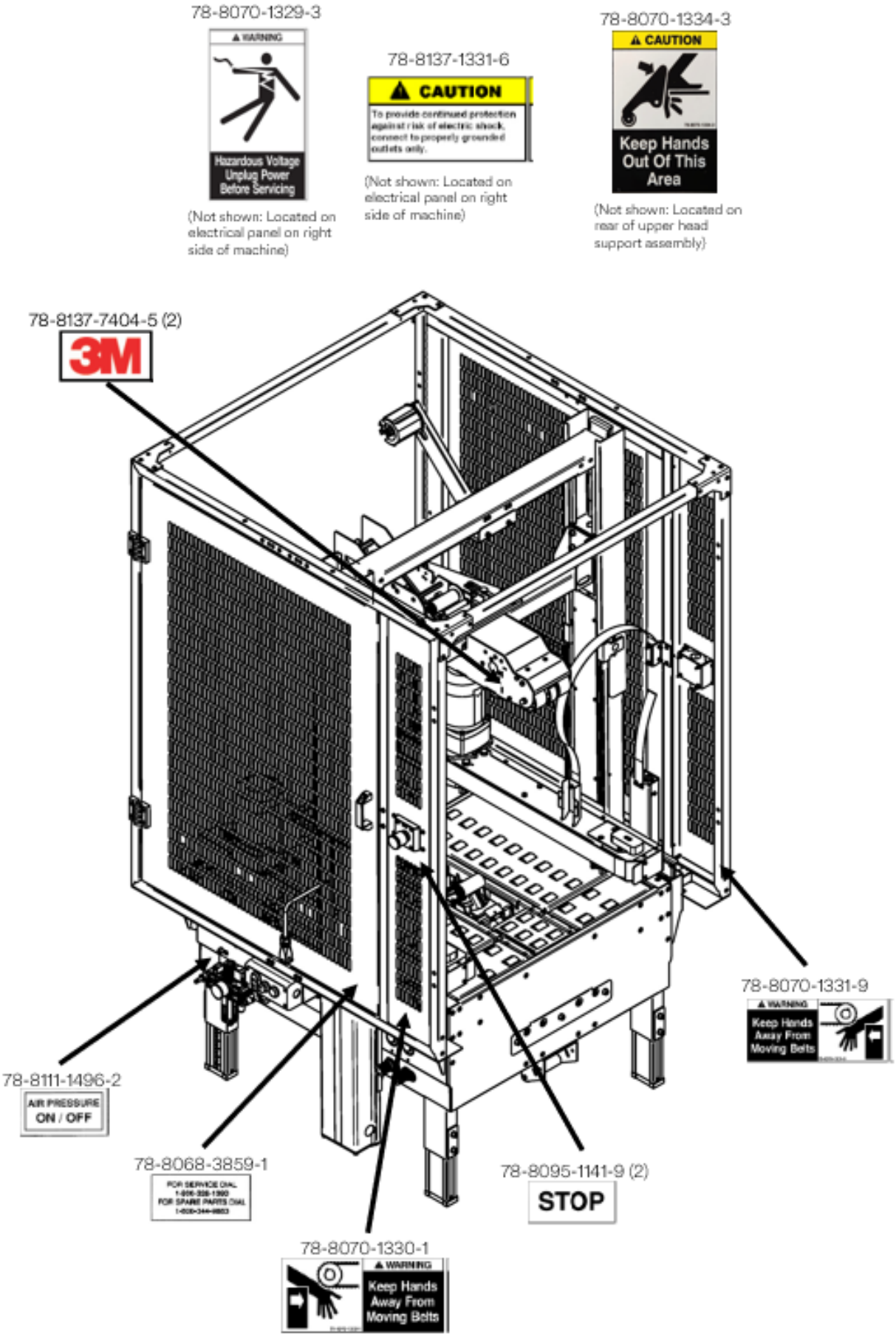


Figure 3-10 Replacement Labels / 3M Part Numbers

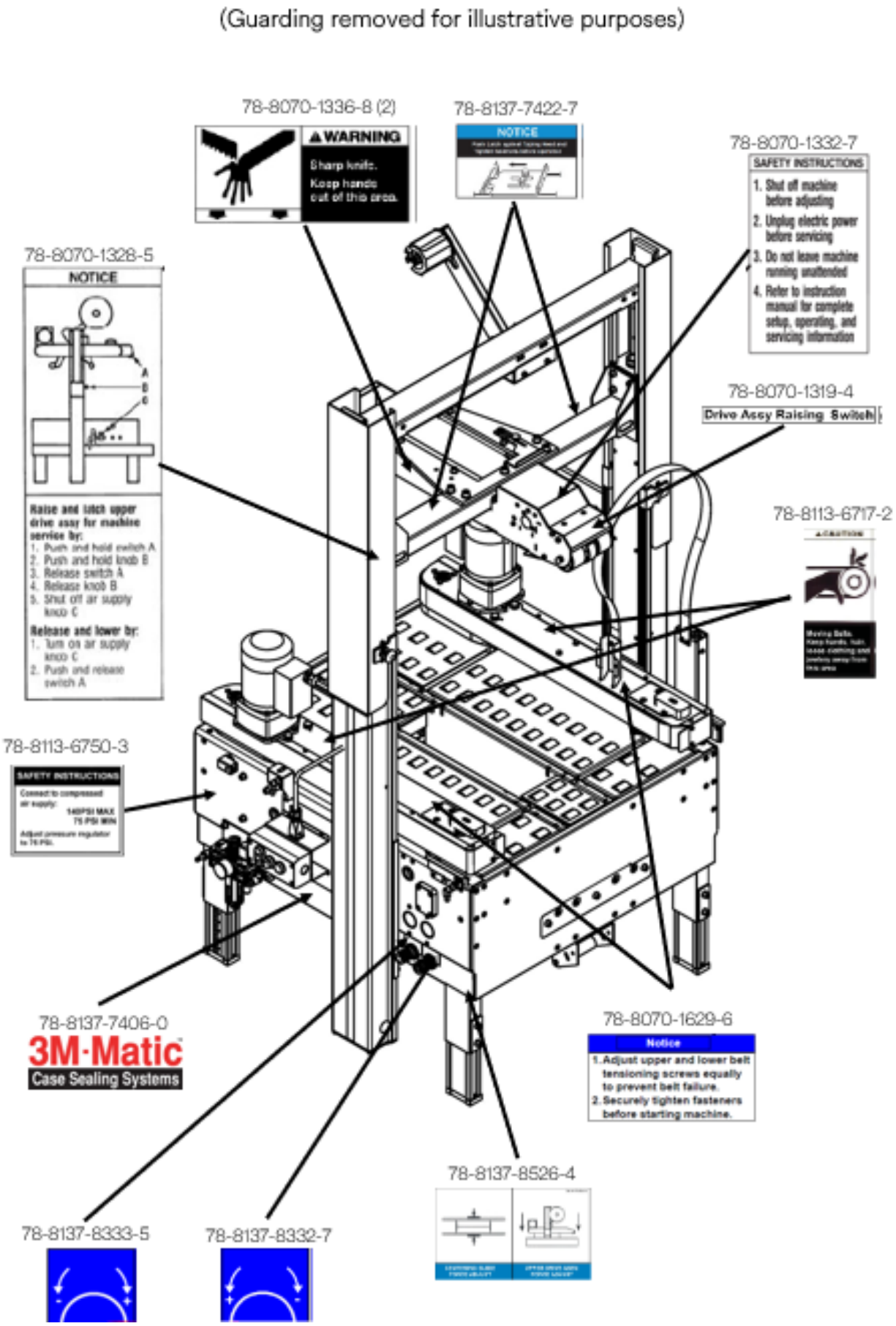


Figure 3-11 Replacement Labels / 3M Part Numbers

4. Specifications

4.1 Power Requirements

Electrical: - 120 Volt, 60Hz, 4.35A (522 watts)
Pneumatic - 6.25 bar gauge pressure [90 PSIG] 126 litre/min @ 21 C, 1.06 bar [4.46 SCFM]
A pressure regulator is included.

The machine is equipped with a 2.4m [8 foot] standard neoprene covered power cord and a grounded plug. Contact your 3M Representative for power requirements not listed above.

4.2 Operating Rate

Box drive belt speed is approximately 0.5 m/s [100 feet per minute]. Up to 20 boxes per minute.

Note: Actual production rate is dependent on box height/length, box size mix, and operator dexterity.

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 Tape

Scotch® pressure-sensitive film box sealing tapes.

4.5 Tape Width

36mm [1 1/2 inch] minimum to 50mm [2 inch] maximum (2" taping Heads)
50mm [2 inch] minimum to 72mm [3 inch] maximum (3" taping Heads)

Specifications

4.6 Tape Roll Diameter

Up to 405mm [16 inch] maximum on a 76mm [3 inch] diameter core.

(Accommodates all system roll lengths of **Scotch®** film tapes.)

4.7 Tape Application Leg Length – Standard

70mm ± 6mm [2 3/4 inch ±1/4 inch]

Tape Application Leg Length – Optional
50mm ± 6mm [2 inch ±. 1/4 inch]
(See "Removing Taping Heads Procedure – Changing the Tape Leg Length")

4.8 Box Board

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

4.9 Box Weight and Size Capacities

A. Box Weight, filled: 5 lbs.– 85 lbs. [2.3 kg–38.6 kg]. Contents must support flaps.

B.

Box Size:		Minimum	Maximum
Length	–	205mm [8.0 inch]	Unlimited
Width	–	114mm [4.5 inch]	572mm [22.5 inch]
Height	–	139mm [5.5 inch]	689mm [27.0 inch]

Note: For boxes outside of these dimensions please contact your 3M Sales Representative for possible modifications to the case sealer to meet your individual needs.

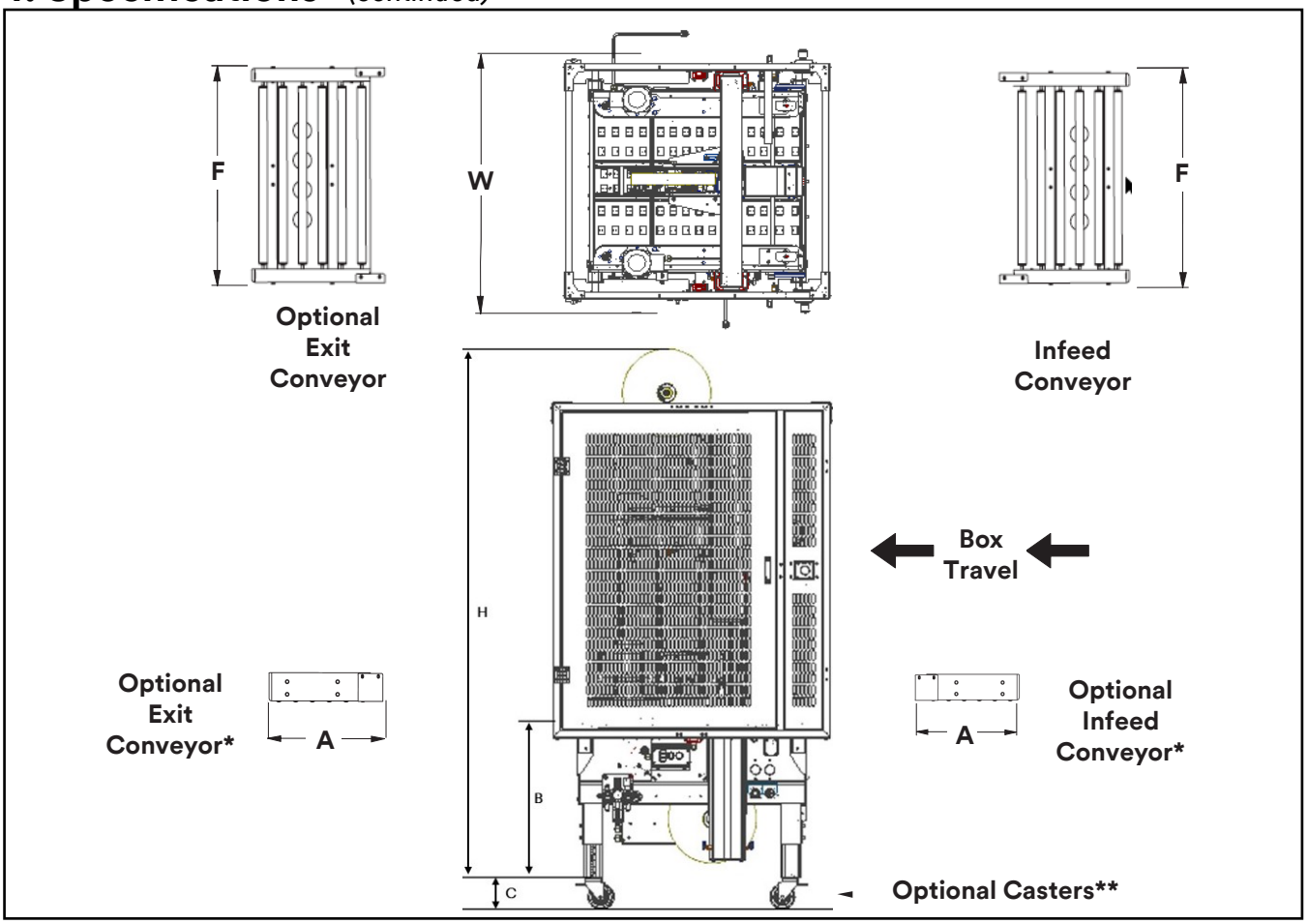
Note: The case sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is 0.6 or less, test run several boxes to ensure proper machine performance.

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

$$\frac{\text{BOX LENGTH IN DIRECTION OF SEAL}}{\text{BOX HEIGHT}} = \text{SHOULD BE GREATER THAN 0.6}$$

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

4. Specifications *(continued)*



4.10 Machine Dimensions:

	W	L	H	A*	B	C**	F
Minimum							
mm	1194	920	1395	460*	610	105**	825.5
[Inches]	[47]	[44.75]	[75.5]	[18]	[24]*	[4 3/16]	[32 1/2]
Maximum							
mm			2172		890		
[Inches]	- -	- -	[85.5]*	- -	[35]*	- -	- -

* Exit conveyor is optional
** Casters are optional
*** When columns are adjusted to upper position, "H" maximum dimension is 2062mm [81.19 inches]. (See "Special Setup Procedure – Outer Column Re-Positioning")
Weight – 281kg [620 pounds] crated (approximate)
263kg [580 pounds] uncrated (approximate)

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

4.12 Setup Recommendations:

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

5. 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).**

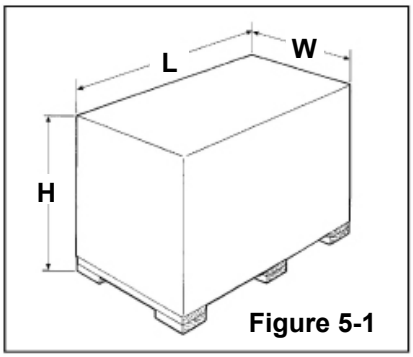


Figure 5-1

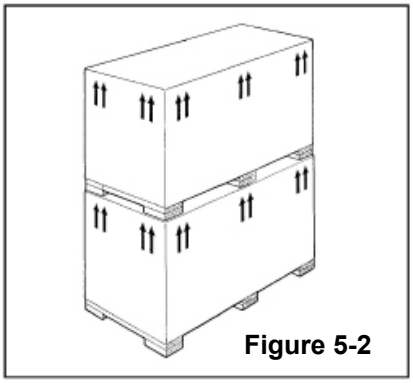


Figure 5-2

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).**

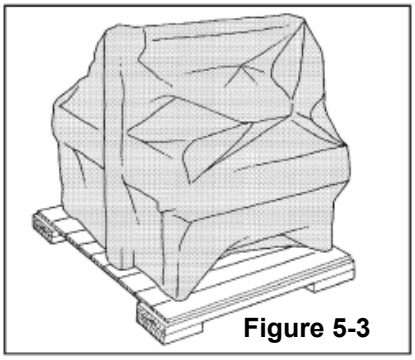


Figure 5-3

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).

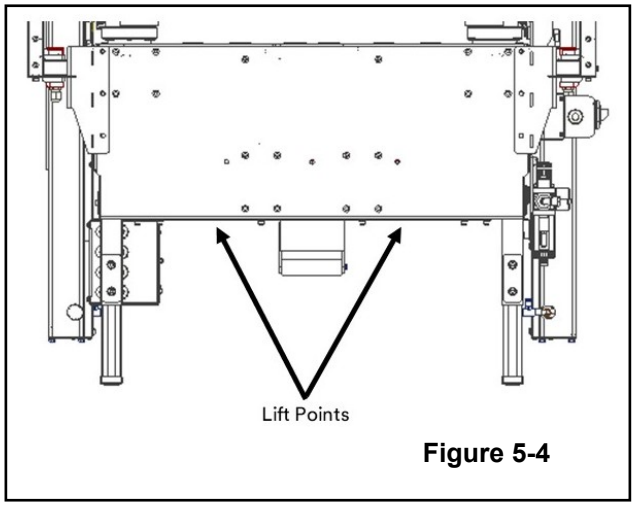


Figure 5-4

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).

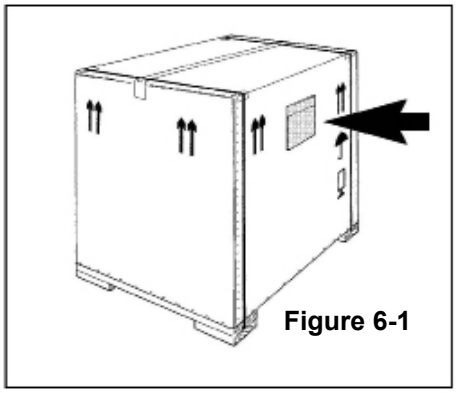


Figure 6-1

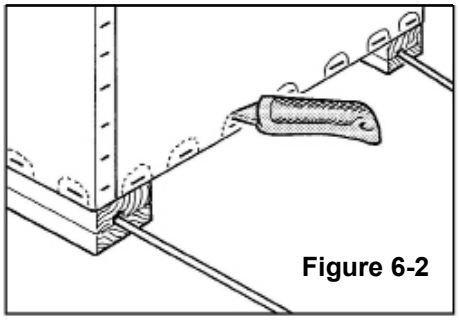


Figure 6-2

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)**

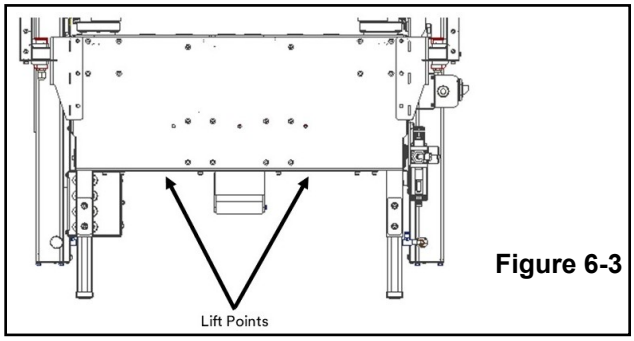


Figure 6-3

6.2 Disposal of Packaging Materials

The **8000r-8000r3** 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.•

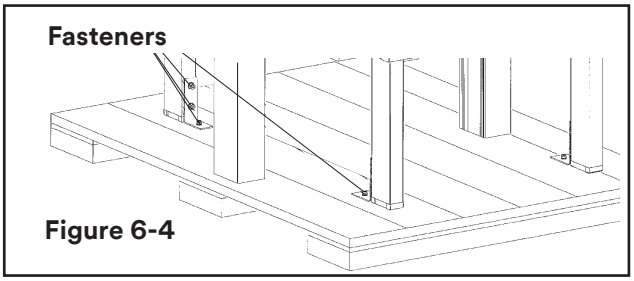


Figure 6-4

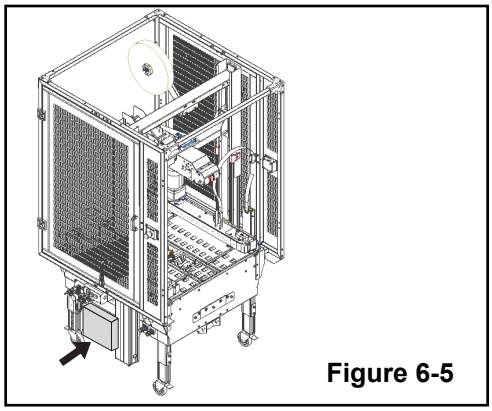


Figure 6-5

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 Positioning / Bed Height

1. Lift the machine with belts or ropes paying attention to place the belts in the points (**Figure 7-2).** To set the machine bed height, do the following:

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

Note – Minimum machine bed height can be reduced to 570mm [22.5 inch] by moving outer columns up one set of mounting holes. However, this change also increases minimum box height of 120mm [4.8 inch] to 170mm [6.8 inch].

Refer to **Figure 7-3** and set the machine bed height as follows:

2. Loosen, but do not remove, two (2) M8 × 1.25 socket head screws in one leg (use M6 hex wrench). Adjust leg length for the desired machine bed height. Retighten the two (2) screws to secure the leg. Adjust all four (4) legs equally.

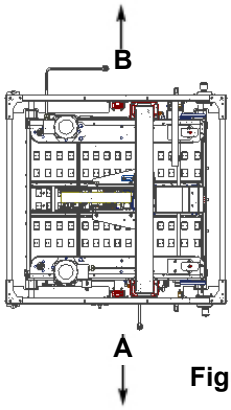


Figure 7-1

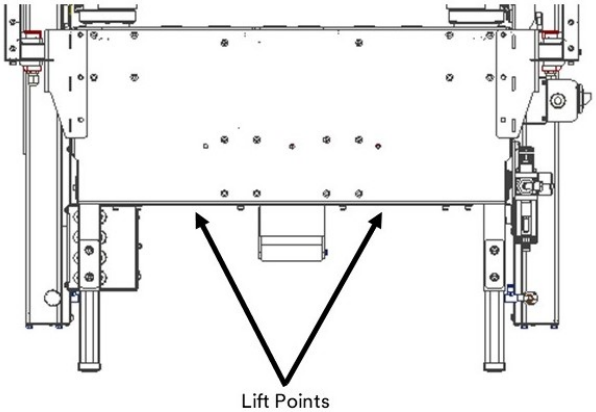


Figure 7-2

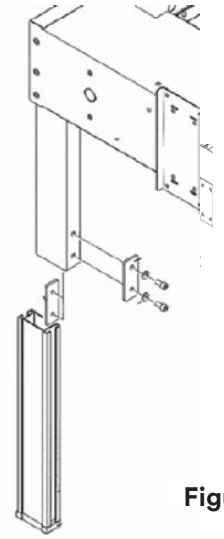


Figure 7-3

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).**

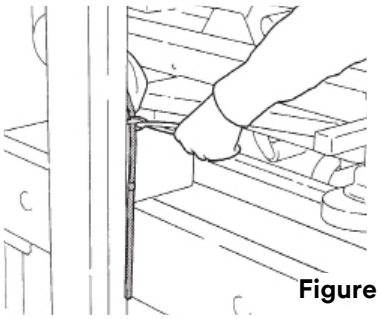


Figure 7-4

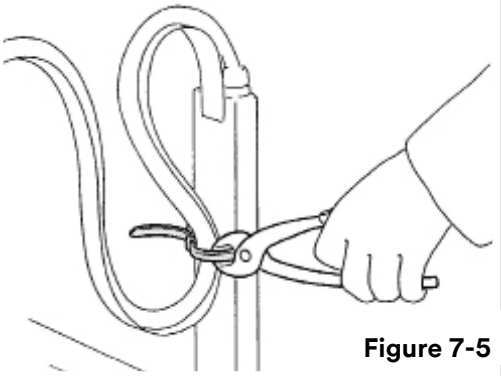


Figure 7-5

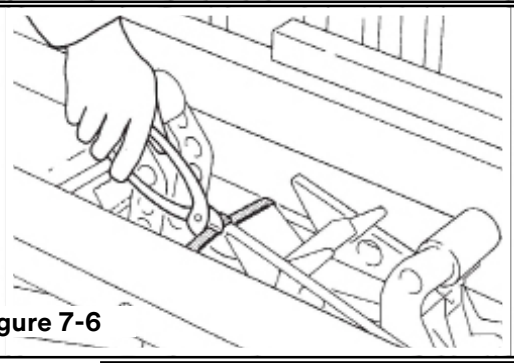
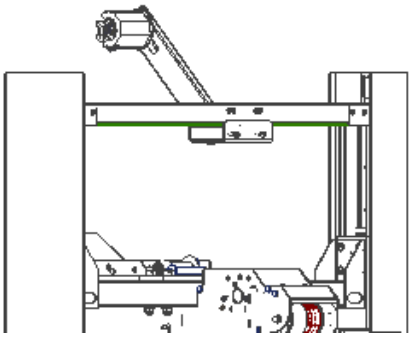


Figure 7-6

7.6 Assembly Completion

Tape Drum Bracket - Install the upper tape drum bracket on the top cross bar as shown **(Figure 7-7).**

Figure 7-7



(Guarding removed for illustration)

7.7 Completion of Taping Heads

See Taping Head Manual for complete instructions:

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

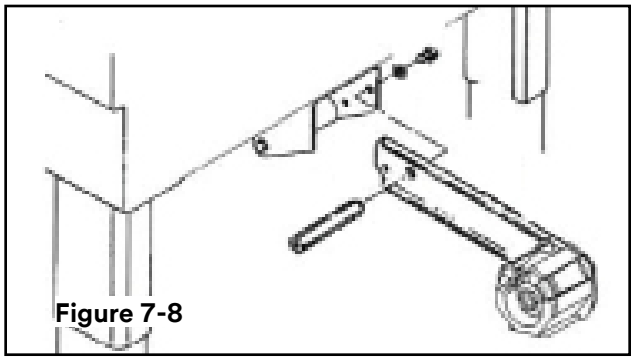


Figure 7-8

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

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.

7.11 Inspection of Phases

(For Three-Main Phases Only)

(N/A for this machine)

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.

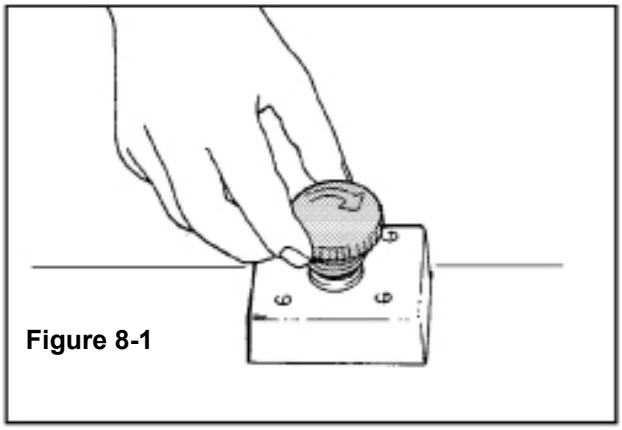


Figure 8-1

8.2 Definition of Running Modes

The case sealer **8000r-8000r3** has one (automatic) operating, and one (fixed) mode with:

Automatic

- Dial rotated to "Fixed Mode Off"
- The EMERGENCY STOP BUTTON unlocked **(Figure 8-1)**
- Depress Blue reset button once **(Figure 8-2)**
- The main On/Off switch “ON” (I) **(Figure 8-2)**

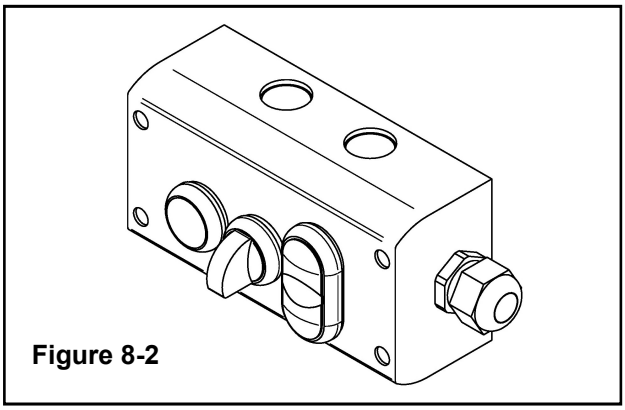


Figure 8-2

Fixed

- Dial rotated to "Fixed Mode On"
- The EMERGENCY STOP BUTTON unlocked **(Figure 8-1)**
- Depress Blue reset button once **(Figure 8-2)**
- The main On/Off switch “ON” (I) **(Figure 8-2)**
  (*Note* - *In fixed mode machine upper assembly will float at a "fixed" height)*

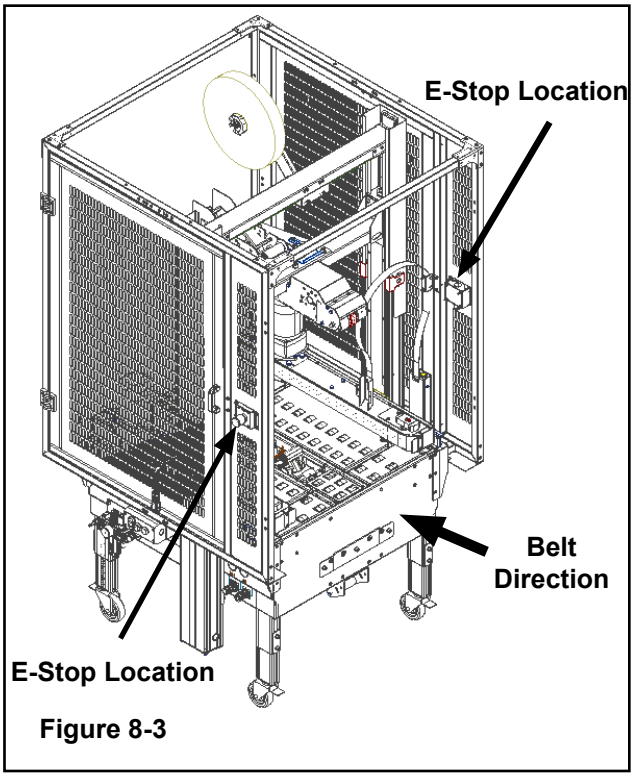


Figure 8-3

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 BUTTONS are located on the side of the guarding. **(Figure 8-3).**

9. Controls

9.1 Start/Stop Buttons

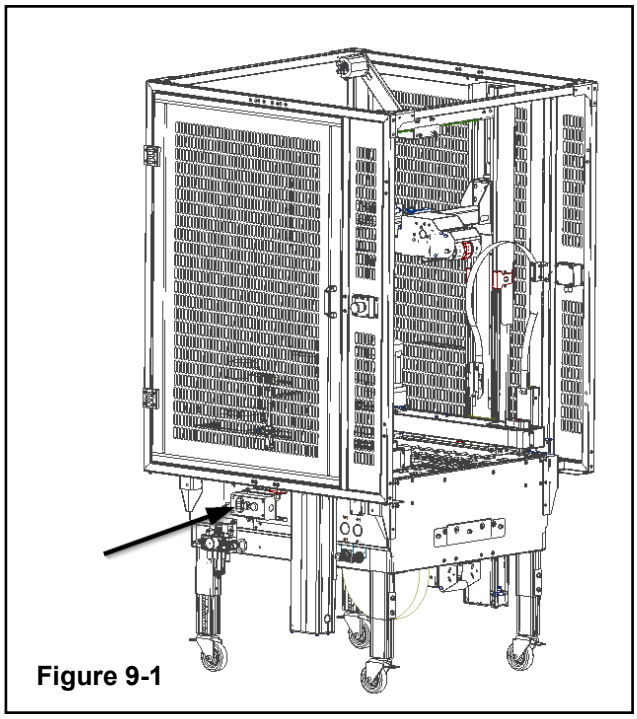


Figure 9-1

9.2 Lockable Emergency Stop Buttons

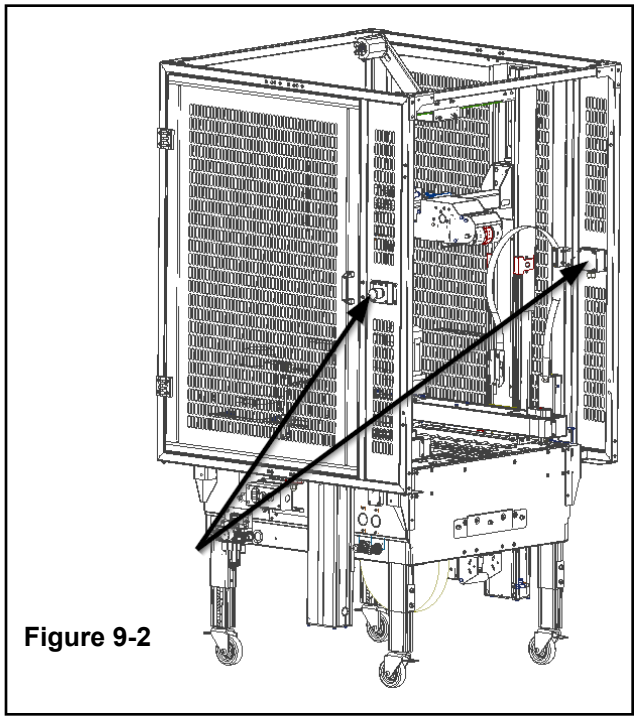


Figure 9-2

10. Safety Devices of the Machine

10.1 Blade Guards

Both top and bottom taping units have a blade guard (See Taping Heads Manual).

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 pressing the reset button and then pressing the on button **(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

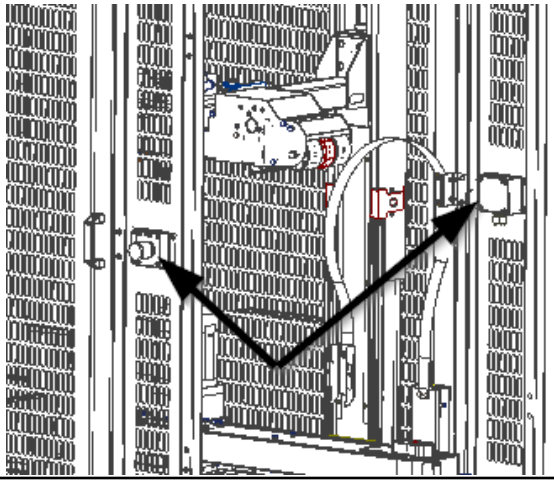
The case sealer is equipped with a circuit breaker which trips if the motors are overloaded. Located inside the electrical enclosure on the side of the machine frame just below the machine bed, the circuit breaker has been pre-set and requires no further maintenance. If circuit is overloaded and circuit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

1. Determine cause of overload and correct.
2. Plug in machine.
3. Depress blue reset button
4. 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



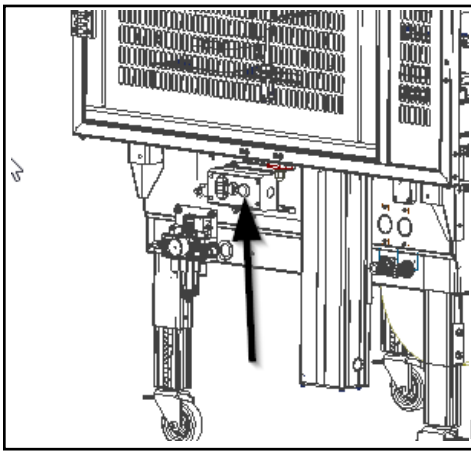


Figure 10-2

Warning

- **To reduce the risk associated with 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. Special Setup Procedure

11.1 Changing the Tape Leg Length

See taping head manual.

Taping Heads

***Important!* Turn off Electric Power.**
Blades are SHARP!

11.2 Special Set-Up Procedure for Outer Column Re-positioning

Moving the outer columns to the upper set of mounting holes increases the maximum box size (height) handled by the case sealer from 533mm [21.00 in] to 644mm [25.38 in] (Dimensions given are with lift cylinders mounted in standard position) - See Specifications

Note – This also increases the minimum box height from 127mm [5.00 in] to 232mm [9.12 in].

Refer to **Figure 11-2**

Warning

- **To reduce the risk associated with impact hazards:**
  - Always use appropriate supporting means when working under the upper drive assembly

Warning

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

Warning

- **To reduce the risk associated with sharp blade hazards:**
  - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp
- **To reduce the risk associated with muscle strain:**
  - Use proper body mechanics when removing or installing drive assemblies or taping heads that are moderately heavy or may be considered awkward to lift

Warning

- **To reduce the risk associated with mechanical and electrical hazards:**
  - Turn electrical and air supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads
- **To reduce the risk associated with impact hazards:**
  - Always use appropriate supporting means when working under the upper drive assembly
- **To reduce the risk associated with muscle strain:**
  - Use proper body mechanics when removing or installing drive assemblies or taping heads that are moderately heavy or may be considered awkward to lift
  - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment

11. Special Setup Procedure

11.2 Special Set-Up Procedure for Outer Column Re-Positioning

Moving the outer columns will increase/decrease the maximum box height capacity of the **8000r-8000r3** case sealer.

1. On both sides, place a solid spacer block (as needed to support column and to help line up new holes) between floor and bottom of outer column **(Figure 11-1A)**.
2. On both front and rear, place solid spacer blocks (14" [355mm]) and lower the upper taping head assembly until the upper assembly rests on blocks.
3. Remove eight (8) column screws **(Figure 11-1B)**.
4. Place second spacer block under column **(Figure 11-1A)**.
5. Re-attach/tighten the eight (8) screws and washers in each column **(Figure 11-1B)**.
6. Remove existing guard and attach inner guide plate using hardware provided **(Figure 11-1B).**

(*continued*)

Important! When the column is in the upper position, the Lower Column Guard must be installed **(Figure 11-1B).**

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 11-2).**

Figure 11-2

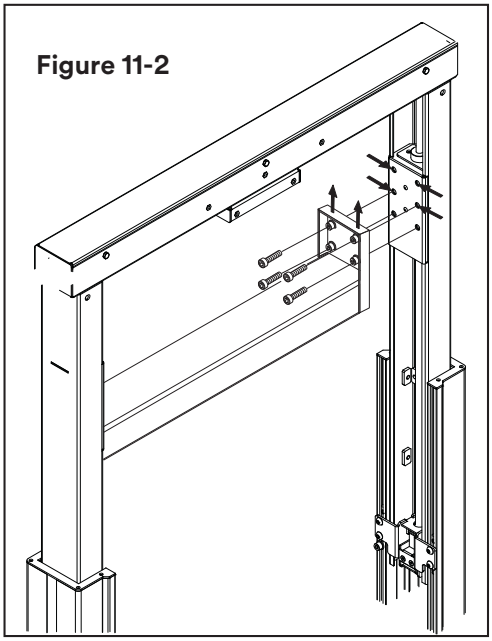
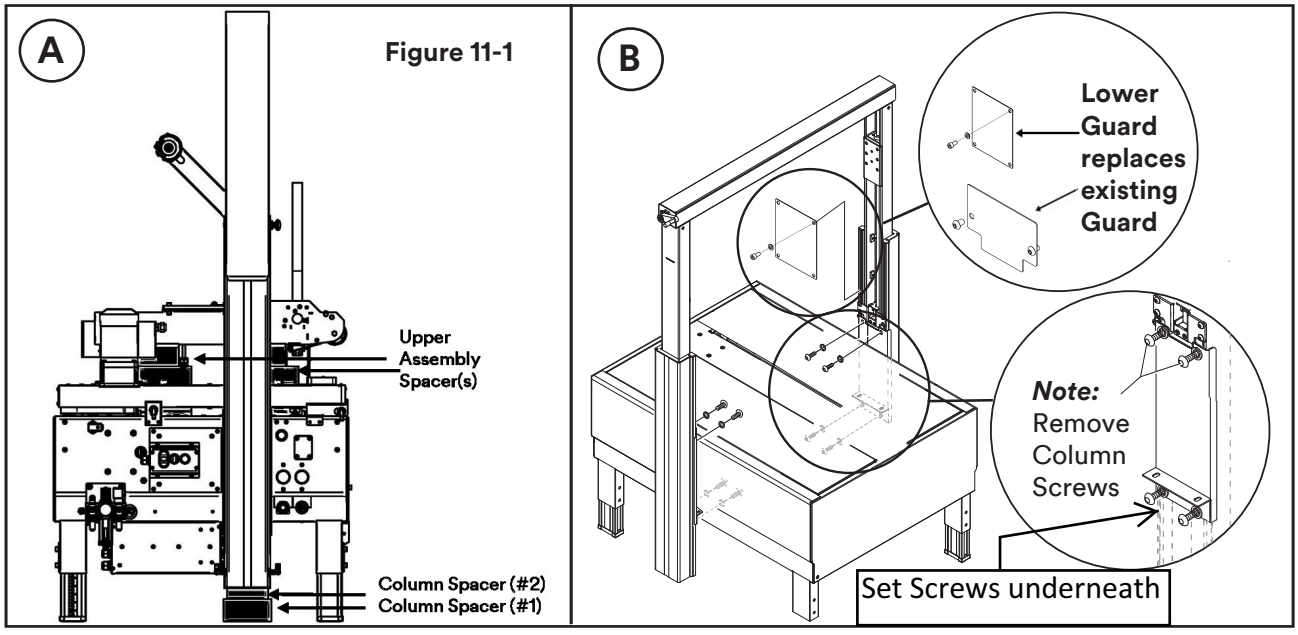


Figure 11-1



NOTE: Guarding removed for illustrations

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.

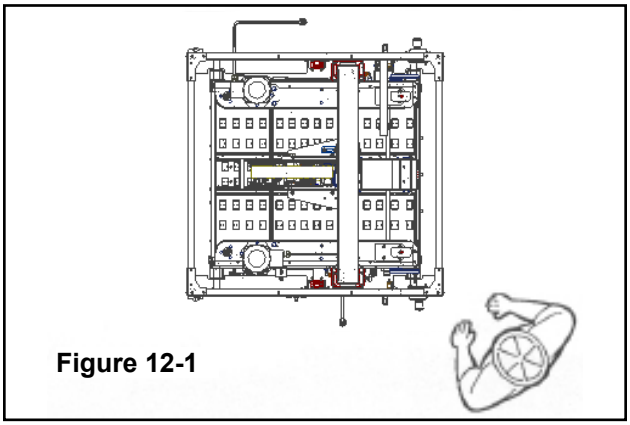
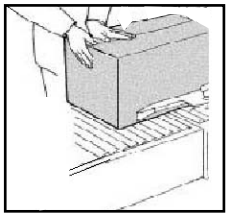


Figure 12-1

Figure 12-2

Hand Position



12.2 Starting the Machine

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

Turn the main switch ON (I) and depress the blue reset button after the EMERGENCY BUTTON is released **(Figure 12-3).**

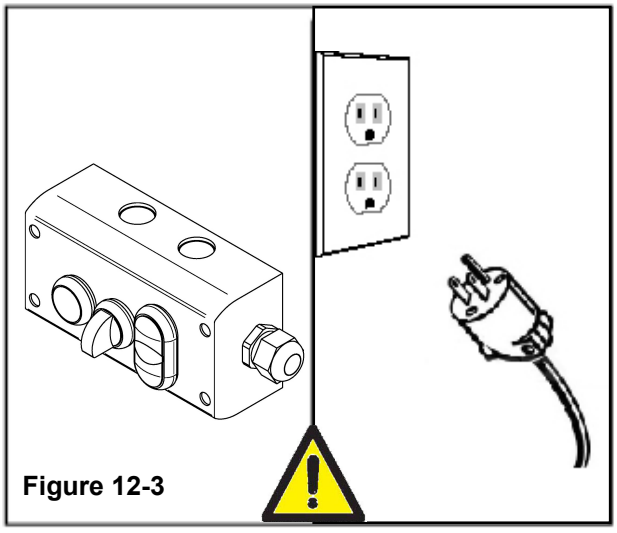


Figure 12-3

12.3 Starting Production

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

12.4 Tape Replacement and Threading

Skill 1 - Operator
See Taping Head Manual

Press the LATCHING EMERGENCY STOP BUTTON.

12.5 Box Size Adjustment

Repeat all operations shown in **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

12.9 Troubleshooting Guide

Problem	Cause	Correction
Drive belts do not convey boxes	Narrow boxes	Check machine specifications. Boxes are narrower than recommended, causing slippage and premature belt wear.
	Worn drive belts	Replace drive belts
	Top taping head does not apply enough pressure	Adjust the upper drive assembly force adjust regulator to increase the force against the top of the box. Turn air regulator counterclockwise.
	Taping head applying spring holder missing	Replace spring holder
	Taping head applying spring set too high	Reduce spring pressure
Drive belts do not turn	Worn or missing friction rings	Replace friction rings
	Drive belt tension too low	Adjust belt tension
	Electrical disconnect	Check power and electrical plug
	Motor not turning	Evaluate problem and correct
Drive belts break	Worn belt	Replace belt
Squeaking noise as boxes pass through machine	Dry compression rollers	Lubricate compression rollers
	Dry column bearings	Lubricate column bearings
	Defective column bearings	Replace column bearings
Tape not centered on box seam	Tape drum not centered	Reposition tape drum
(continued)	Drive belts not centered	Adjust centering guides
	Box flaps not of equal length	Check box specifications

12. Operation

12.9 Troubleshooting Guide

Problem	Cause	Correction
Upper drive assembly does not move up or moves up slowly	Lower air pressure	Disconnect the air supply. Make sure main pressure regulator reads zero. Reconnect air supply and adjust regulator to read 6.25 bar [90 PSIG].
	Defective head raising valve	Clean or replace head raising valve
	Worn head raising valve actuator	Replace valve
	Clogged or damaged exhaust mufflers on the upper ends of the head raising cylinders	Clean or replace exhaust mufflers
	Defective head power valve	Clean or replace the head power valve
Upper taping head does not move down at the end of the taping cycle	Upper drive assembly force adjust regulator set too light	Adjust the upper drive assembly force adjust regulator to increase the force against the top of the box. Turn air regulator counterclockwise.
	Defective top drive assembly force adjust regulator	Replace regulator
	Defective "OR" valve	Clean or replace valve
	Defective head power valve	Clean or replace valve
Upper head assembly comes down too fast or too hard	Upper drive assembly force adjust regulator set too heavy	Adjust upper drive assembly force adjust regulator to decrease force against top of box. Turn regulator clockwise.
	Defective upper drive assembly force adjust regulator	Replace regulator
	Cushion screw misadjusted	Adjust cushion screw at base of cylinder
	Cushion screw missing	Replace screw
Centering drive assemblies move slower than normal	Centering force adjust regulator set too low	Adjust regulator
	Centering guide cylinder speed controls not in correct adjustment	Adjust speed controls mounted on centering guide cylinder
	Defective centering guide power valve	Clean or replace valve

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.

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 Tape Head Manual
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 machine from power source. 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.

13.5 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 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.

13.7 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 Tape Head Manual)

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

13.8 Box Drive Belt Replacement

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

1. Raise 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.

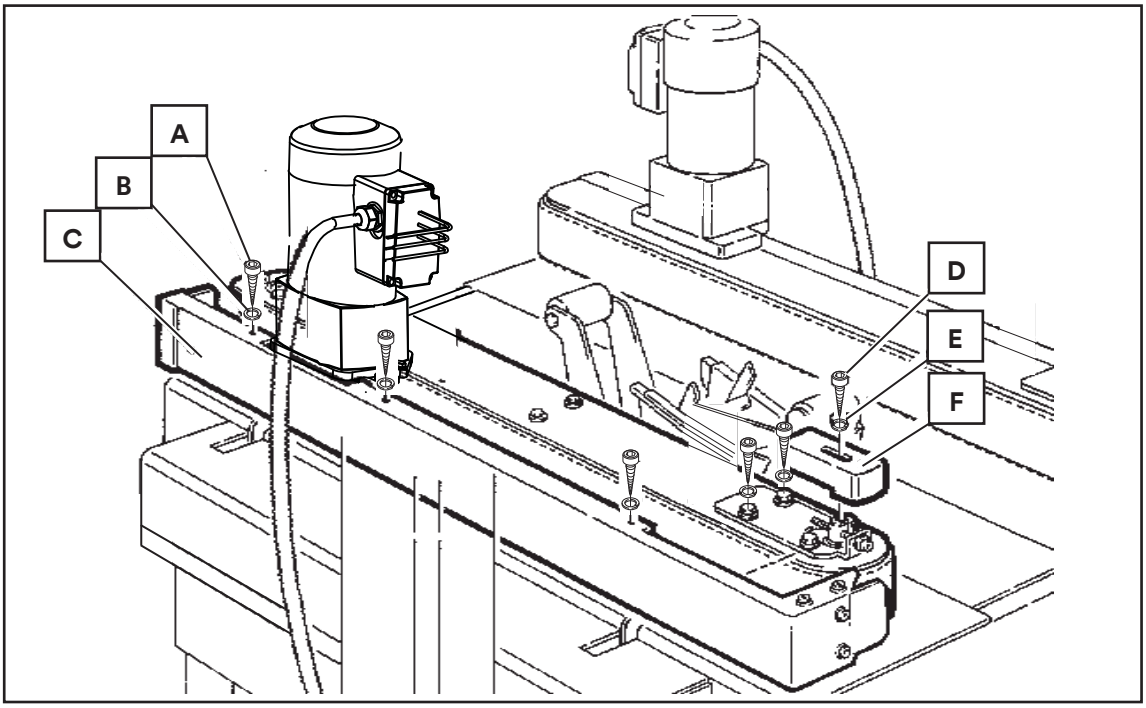


Figure 13-1 Box Drive Belt (Left Side View – Infeed End) (Guarding removed for illustration)

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.

Important – Before installing a new drive belt, check the belt inside surface for drive direction arrows and install belt accordingly. If no arrows are shown, the belt may be installed either way.

13.9 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).**

Warning

- **To reduce the risk associated with mechanical and electrical hazards:**

– 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.

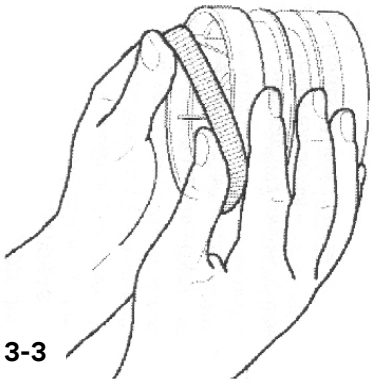


Figure 13-3

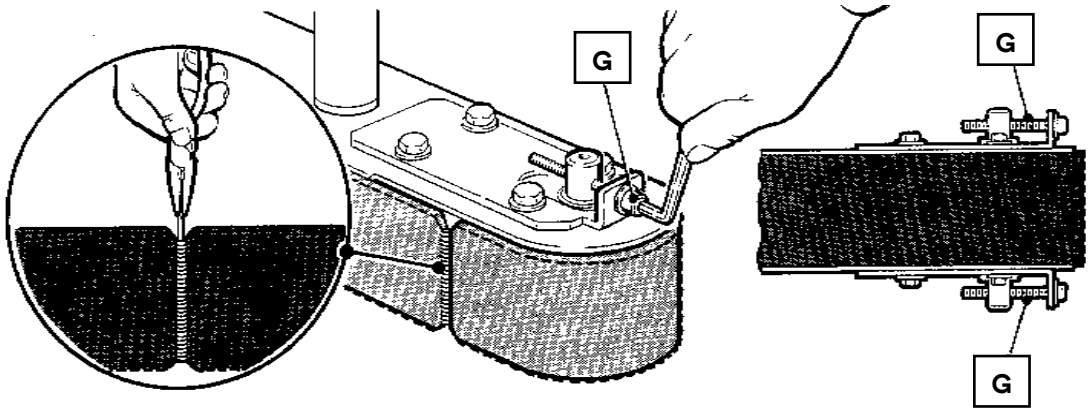


Figure 13-2 Box Drive Assembly, Infeed End

13.10 Drive Belt Tension

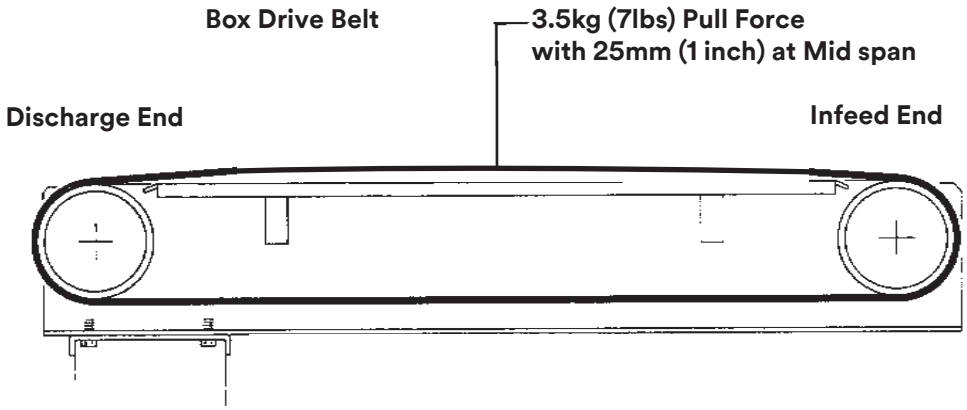


Figure 13-4 Box Drive Belt Tension Adjustment

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.

13.11 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 Tape Head Manual "Special Set-Up Procedure Changing Tape Leg Length".

1. Loosen, but do not remove, the retaining screw that secure upper taping head shown - **Figure 13-5A.**
2. Hold upper taping head applying and bufffng 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 Taping Head Manual 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

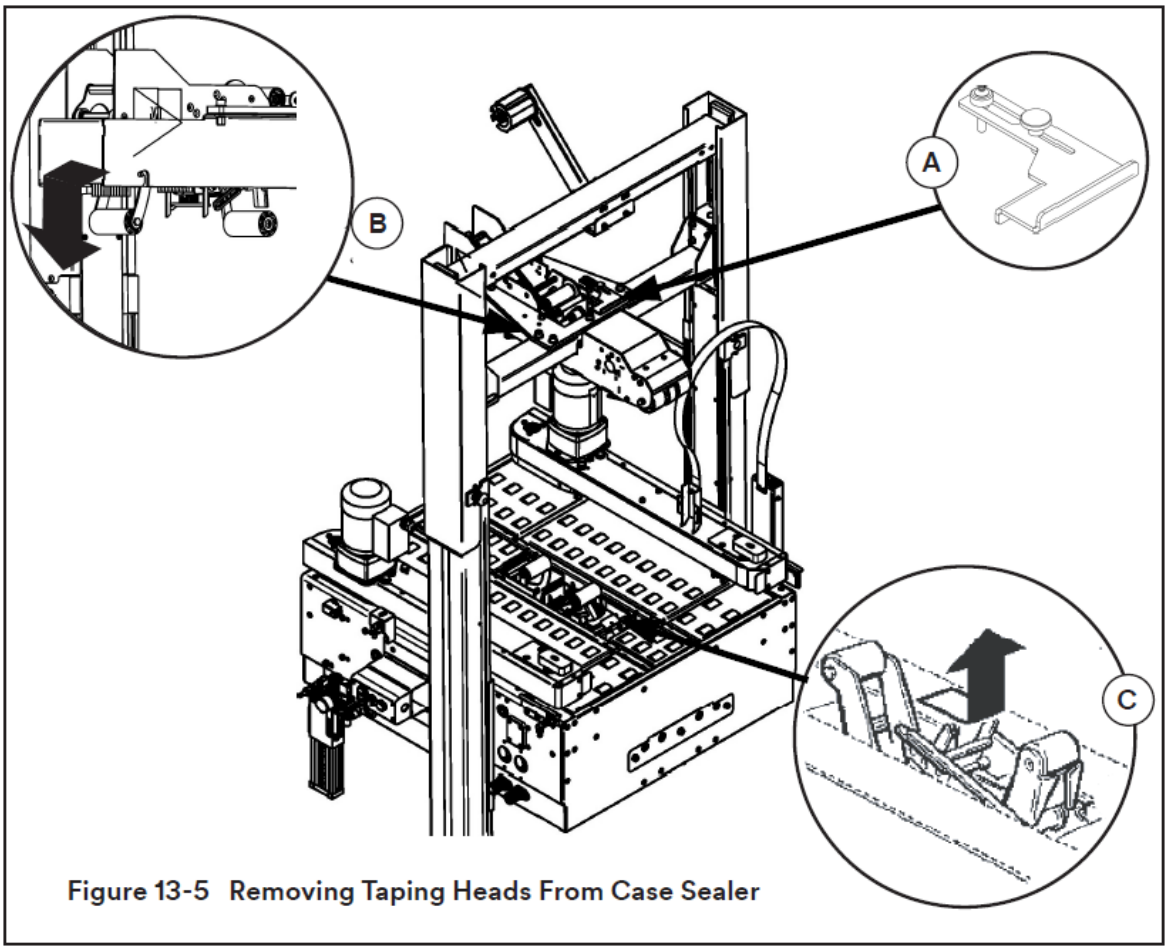


Figure 13-5 Removing Taping Heads From Case Sealer

13.12 List of the Maintenance Operations

Date:	Description of Operation

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).**

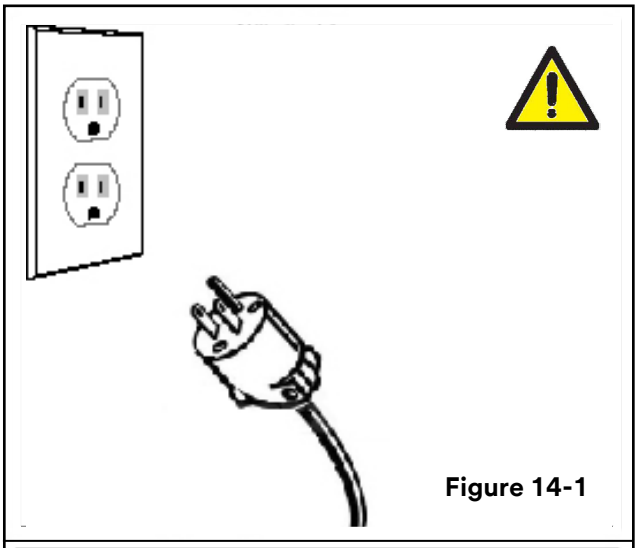


Figure 14-1

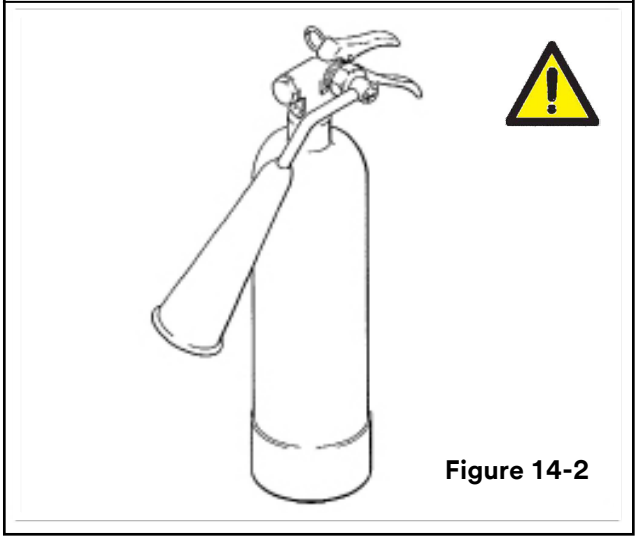


Figure 14-2

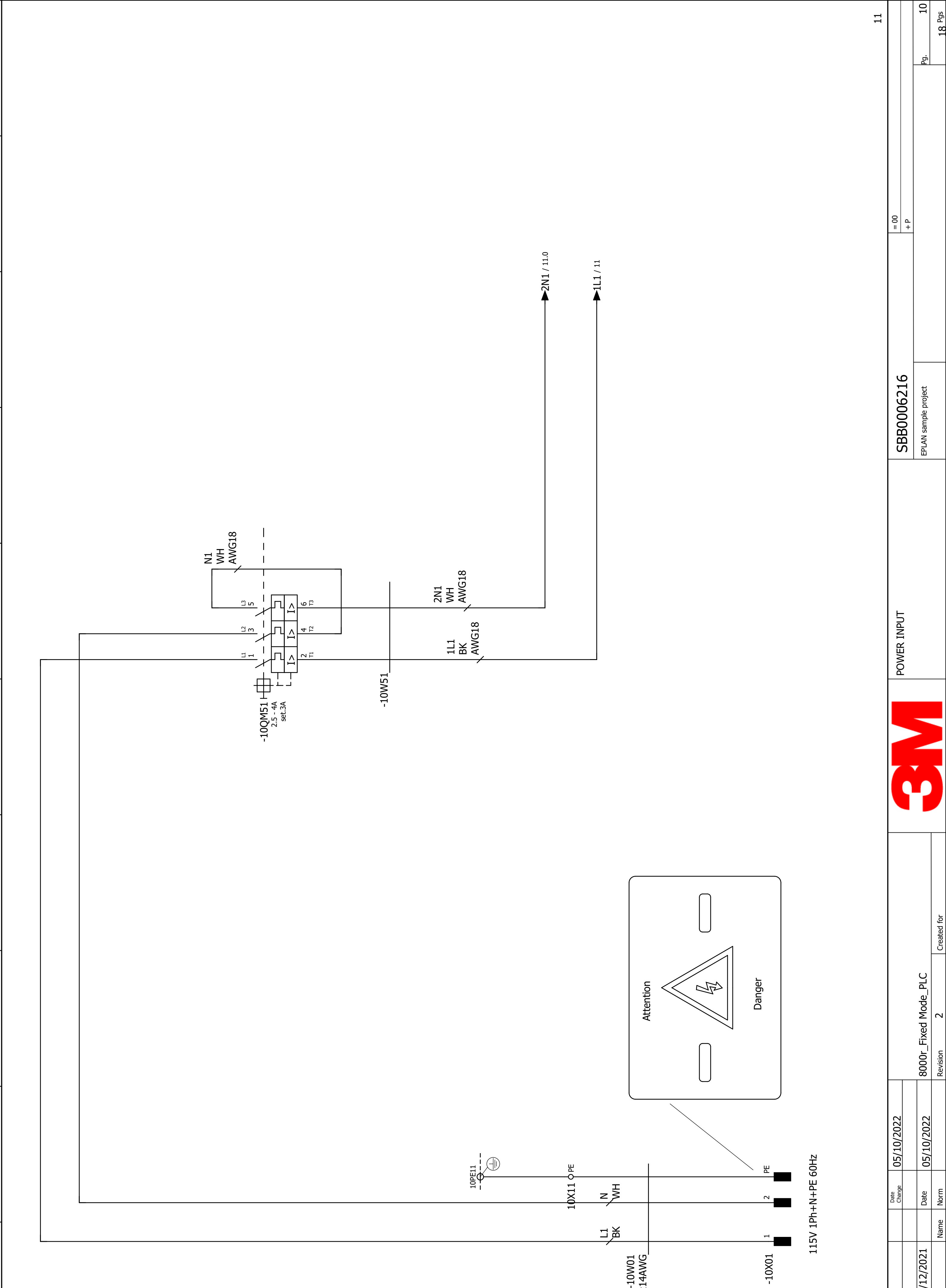
15. Additional Information

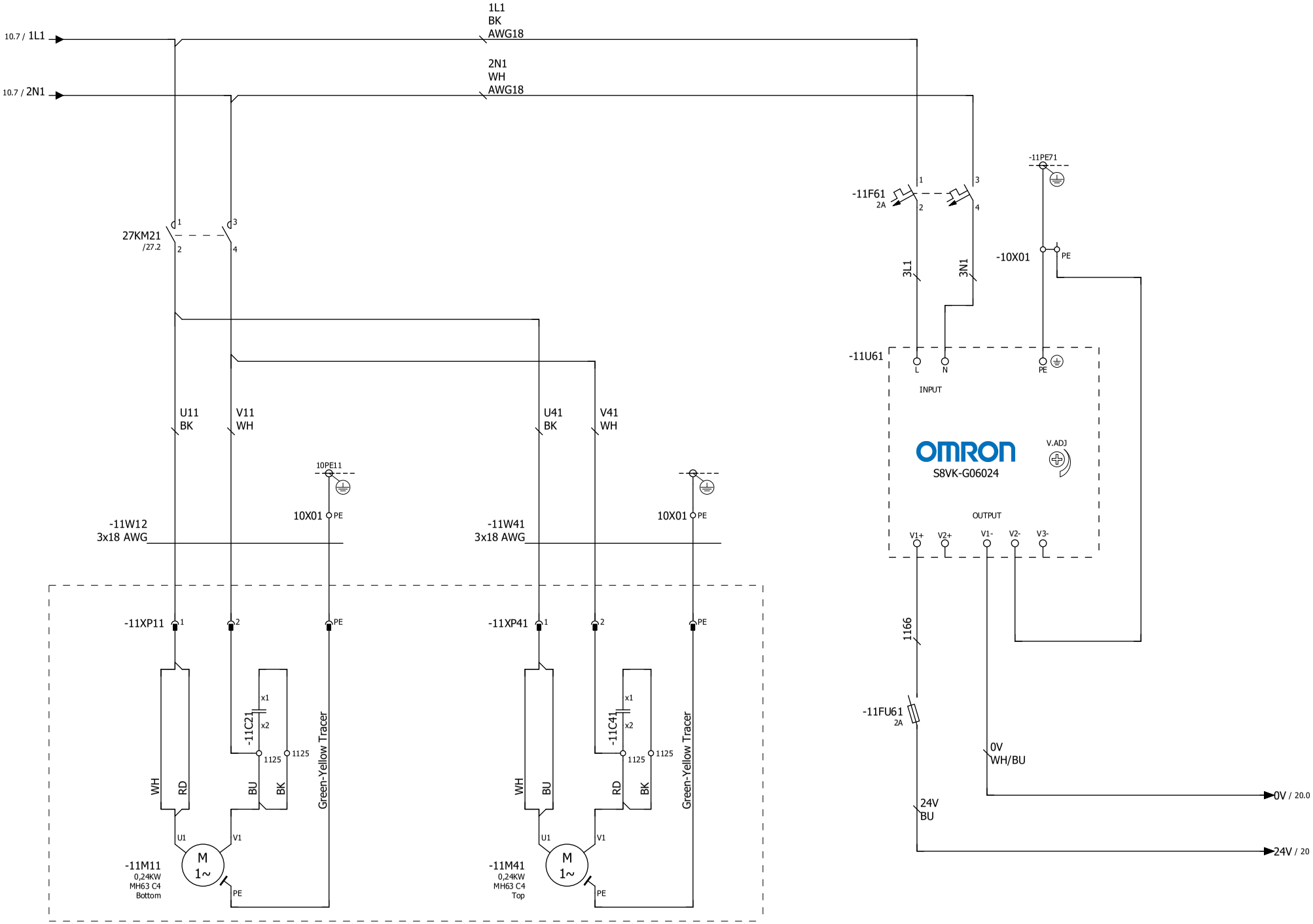
15.1 Statement of Conformity

N/A

15.2 Emission of Hazardous Substances

Nothing to report


2N1 / 11.0
1L1 / 11
N1
WH
AWG18
2N1
WH
AWG18
1L1
BK
AWG18
-10QM51
2.5 - 4A
set.3A
-10W51
Attention
Danger
10PE11
10X11
L1
BK
N
WH
-10W01
3x14AWG
-10X01
115V 1Ph+N+PE 60Hz
POWER INPUT
SBB0006216
EPLAN sample project
8000r_Fixed Mode_PLC
Revision
2
Created for
05/10/2022
05/10/2022
15/12/2021
Pg.
10
18 Pgs
11



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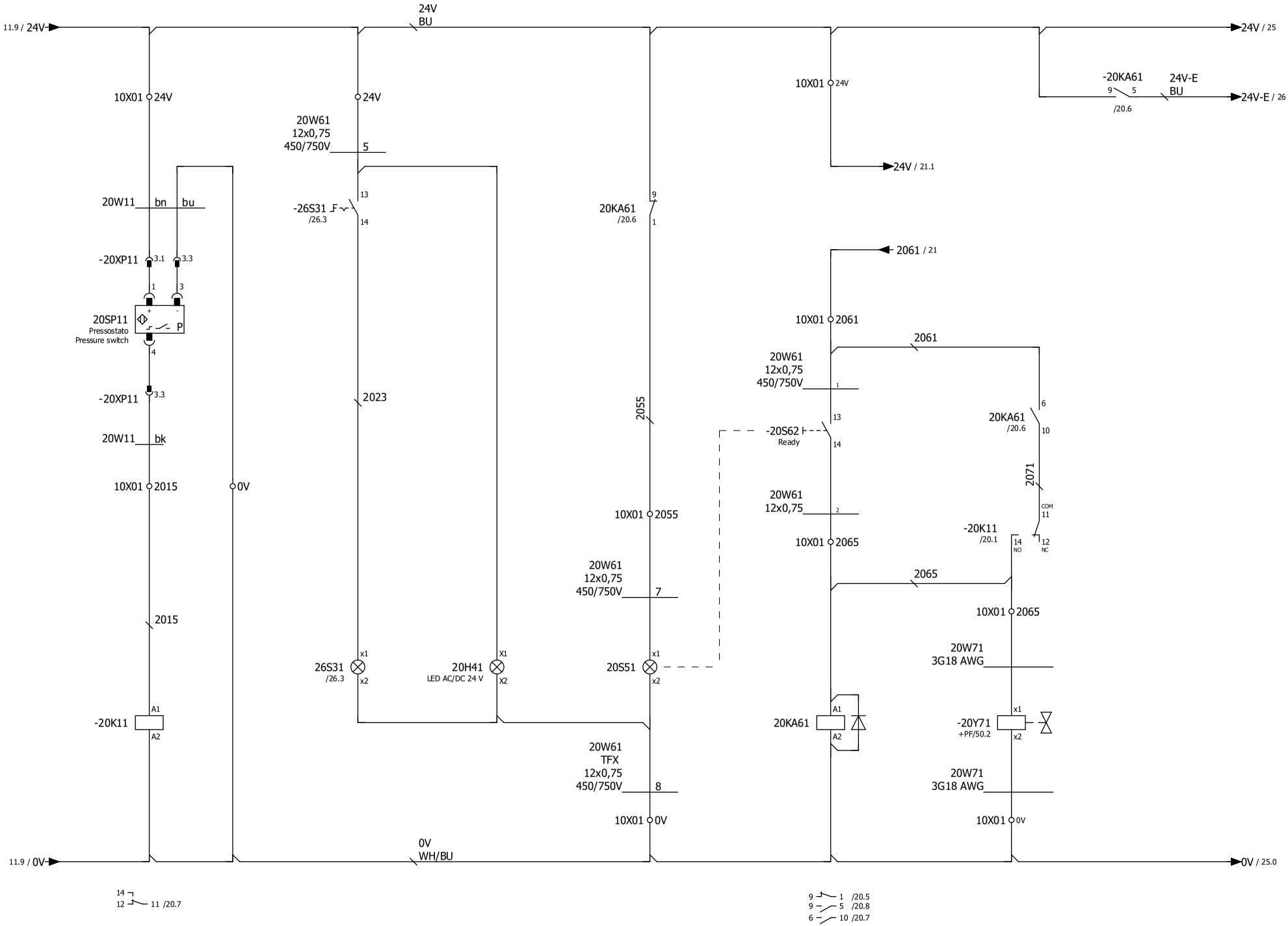
User.								+ P	
Date	15/12/2021		Date	05/10/2022	8000r_Fixed Mode_PLC		Transformer - motors	SBB0006216	
Check.		Name	Norm		Revision 2	Created for		EPLAN sample project	Pg. 11 / 18 Pgs



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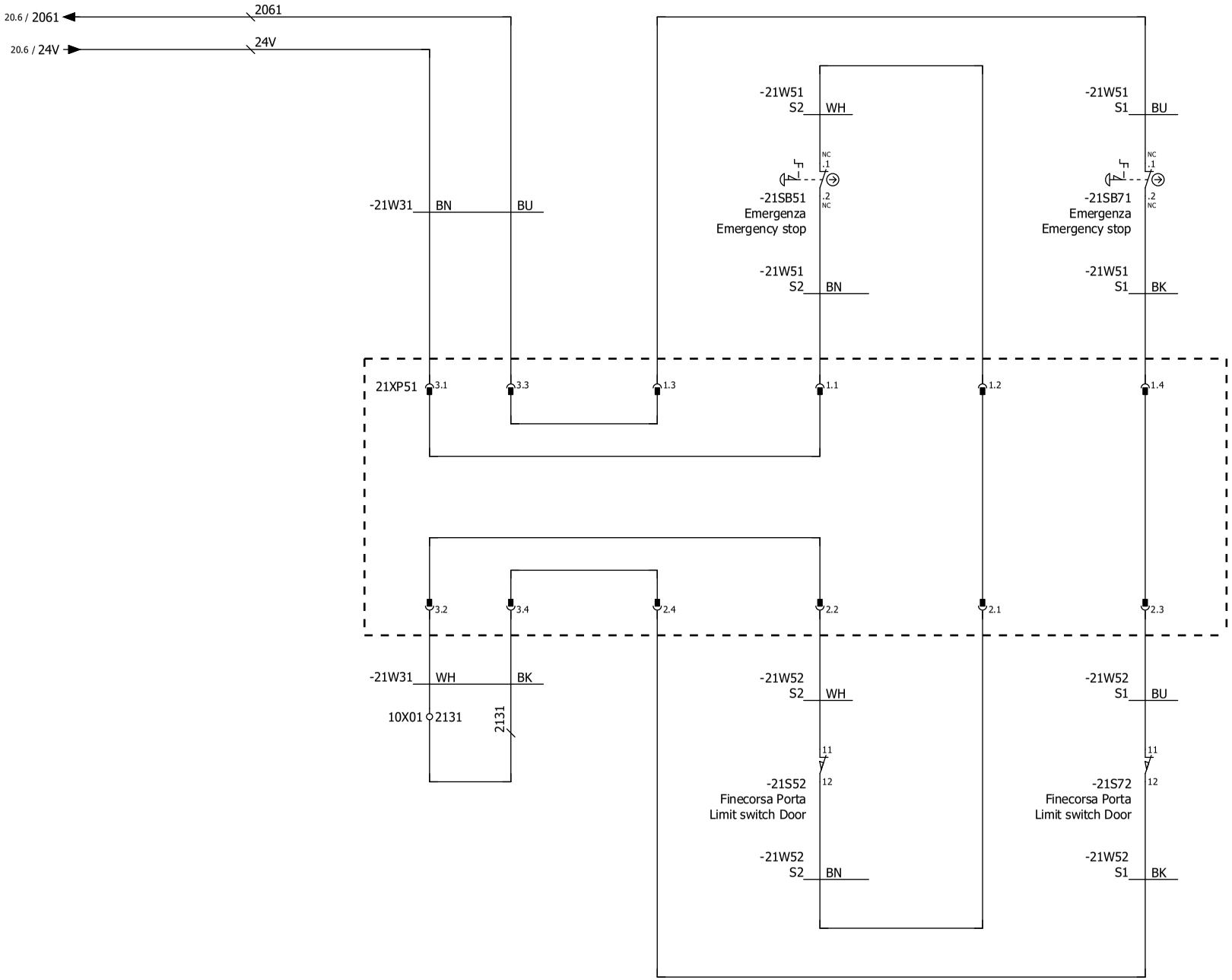

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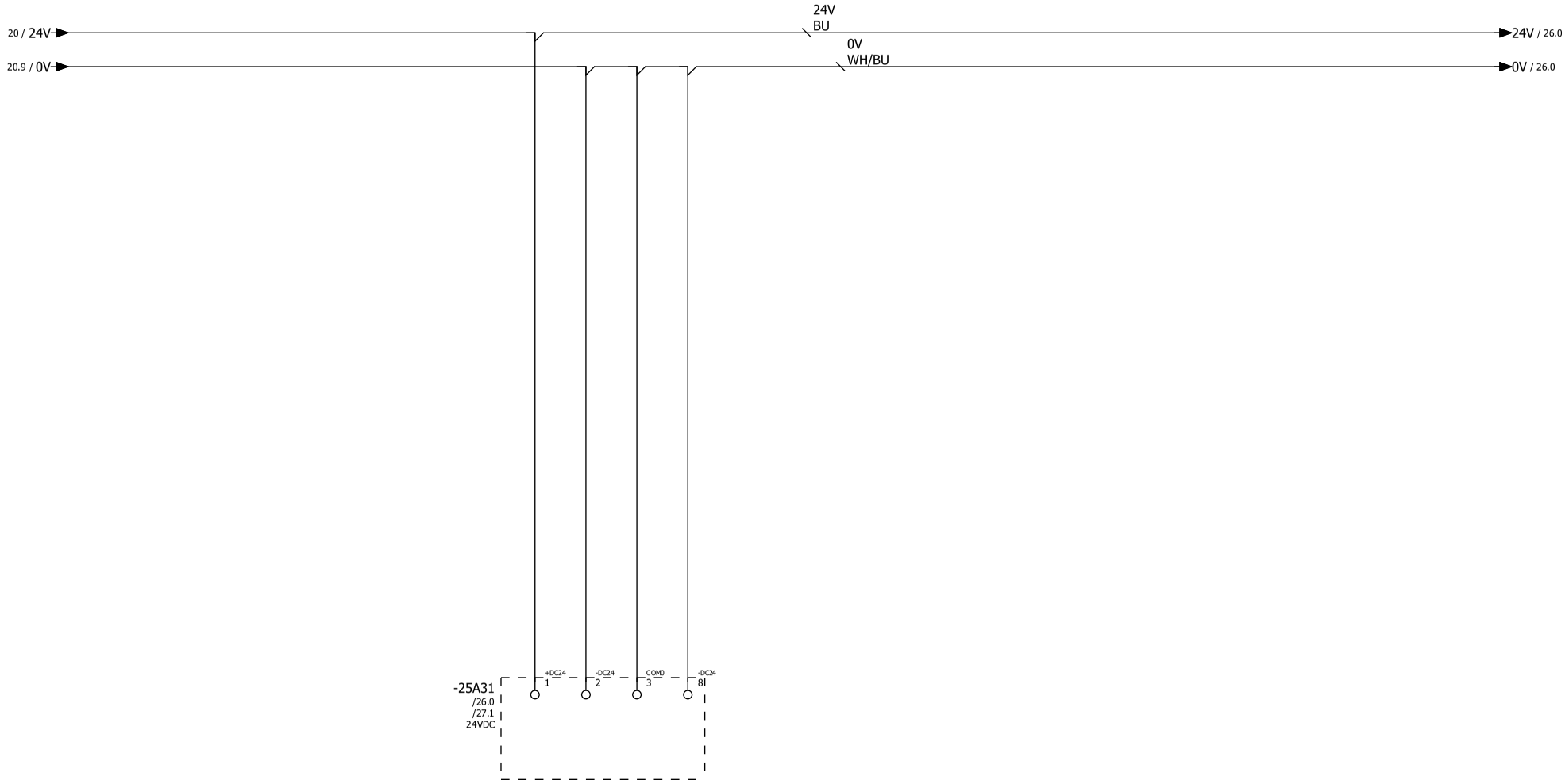

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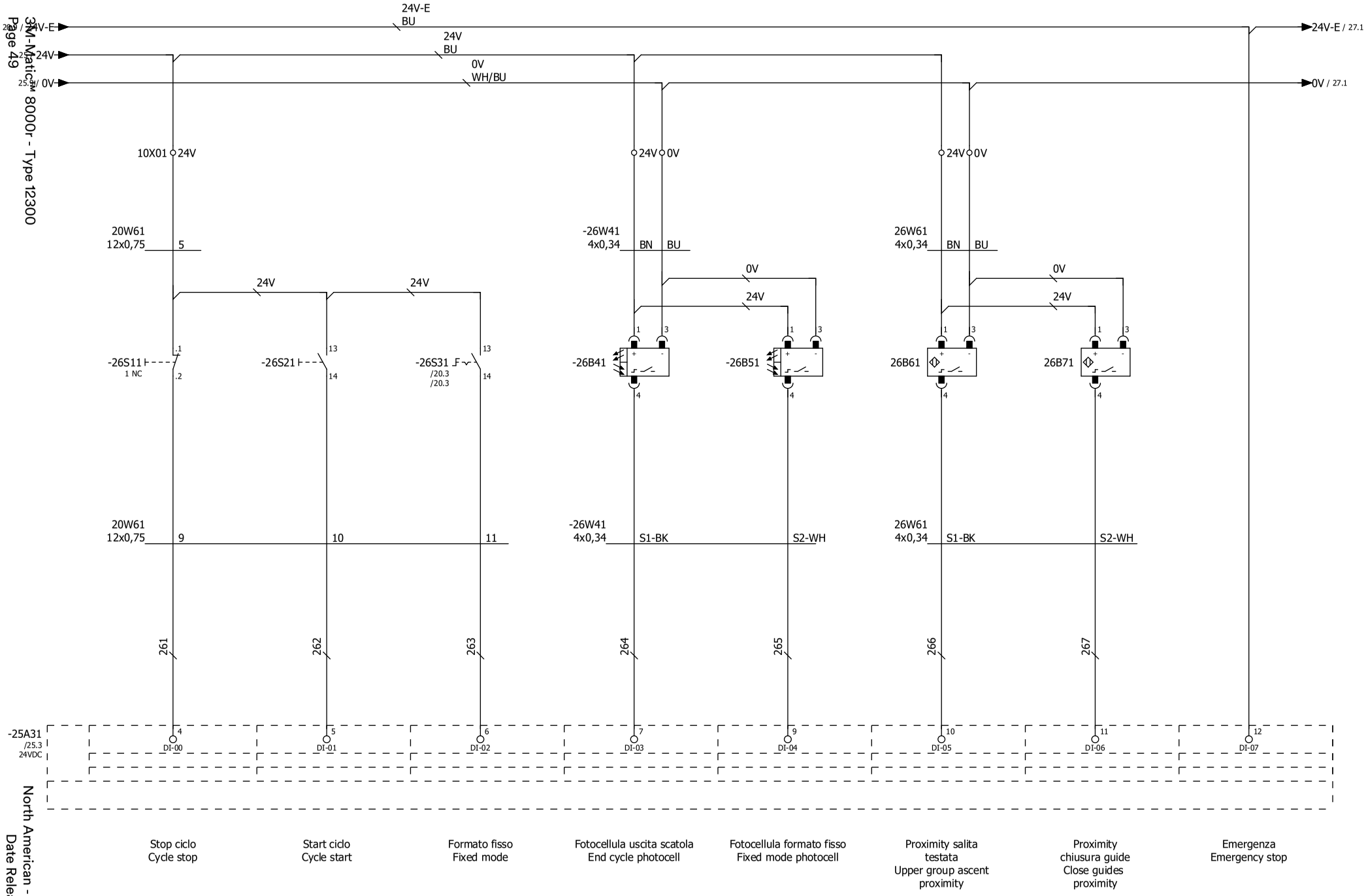

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								EPLAN sample project

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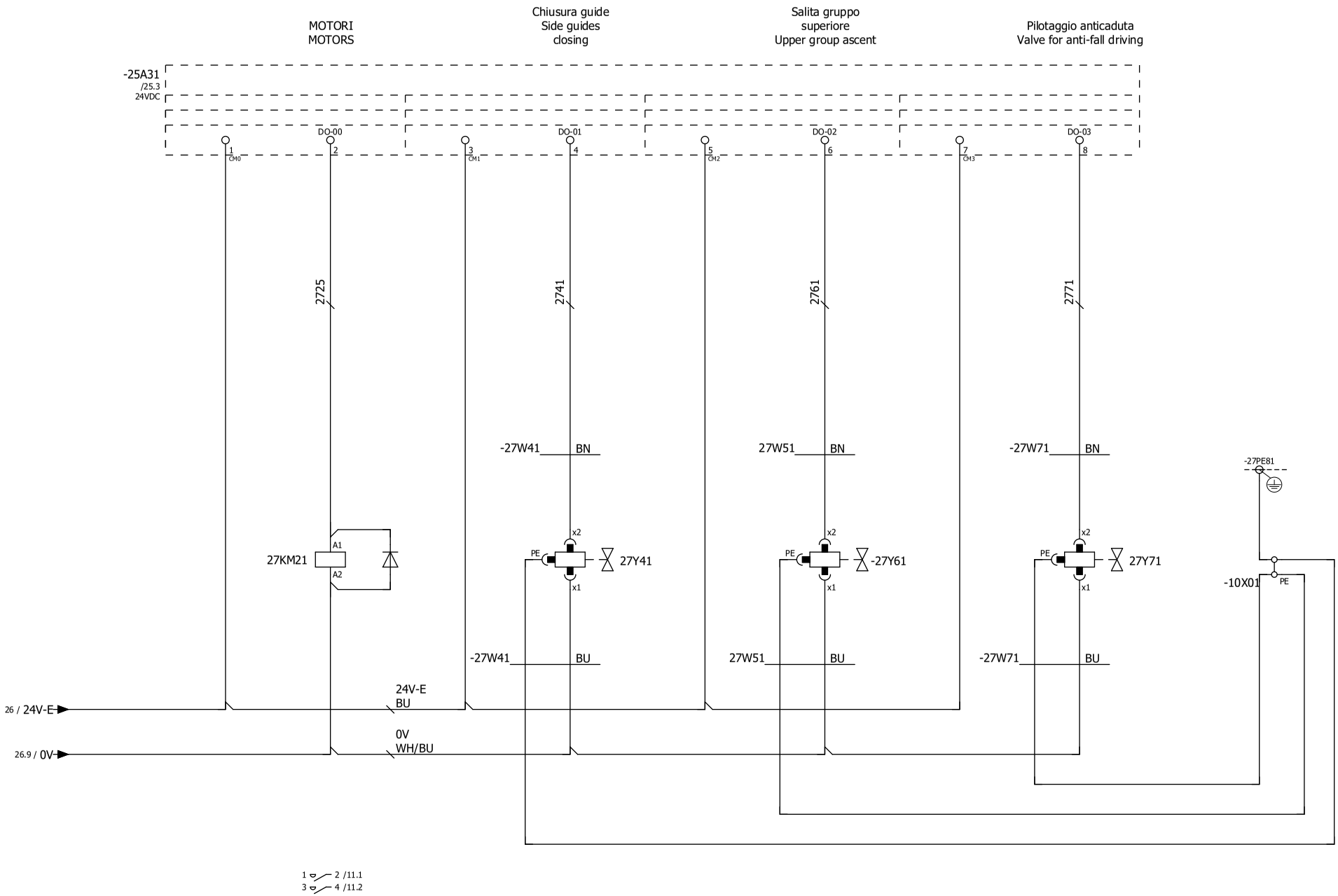
Pg. 26
18 Pgs



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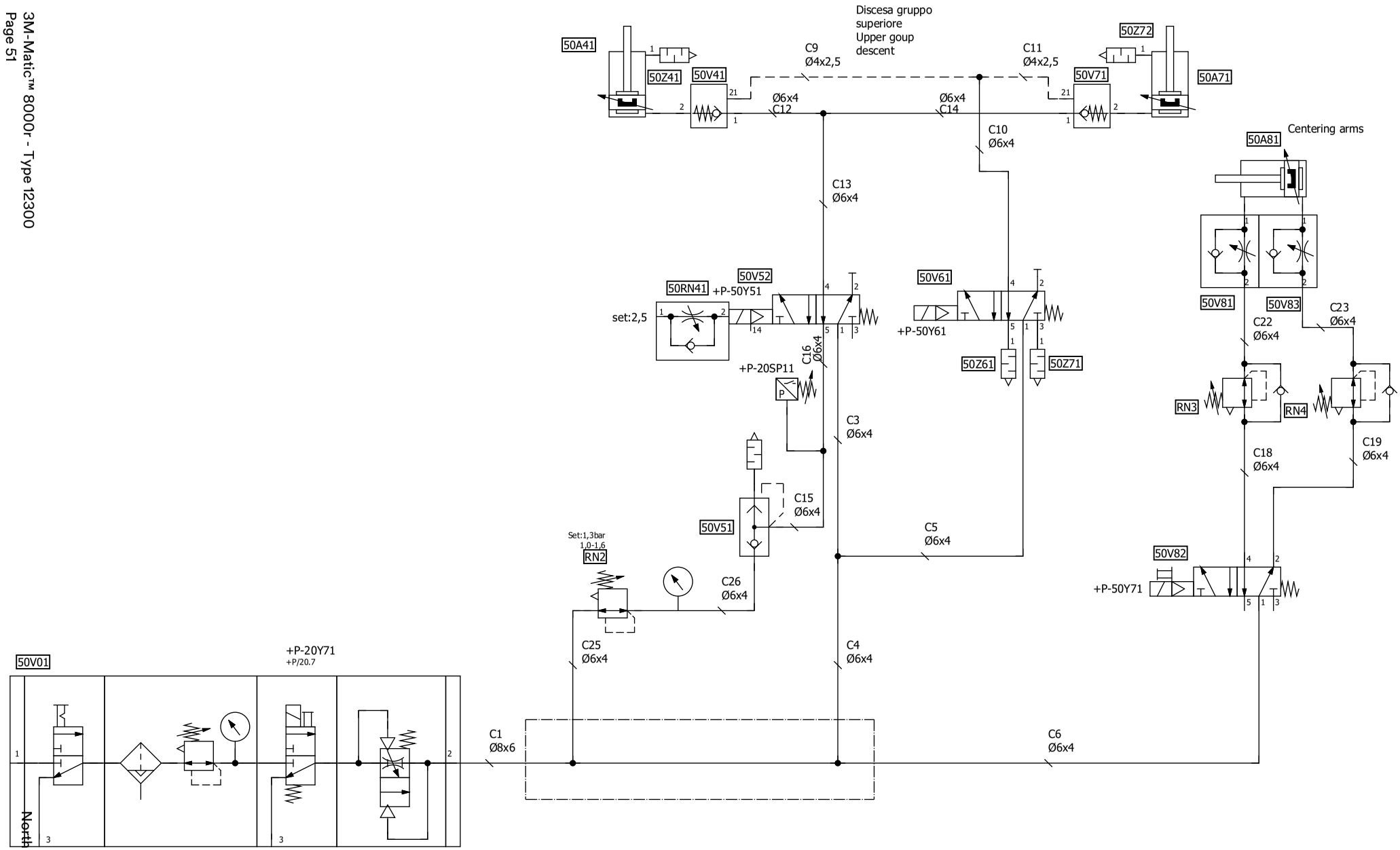

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Check.		Name	Norm		Revision 2	Created for			18 Pgs

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 or 3 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 – 8000r-8000r3 Random Case Sealer

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

8000r-8000r3

Qty.	3M-Part Number	Description
2	78-8076-5452-6	Belt-Drive w/Hook

Labels

In the event that any labels are damaged or destroyed, they must be replaced to ensure operator safety. .

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. Optional Accessories

8000r-8000r3 Random Case Sealer, Type 12300 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.

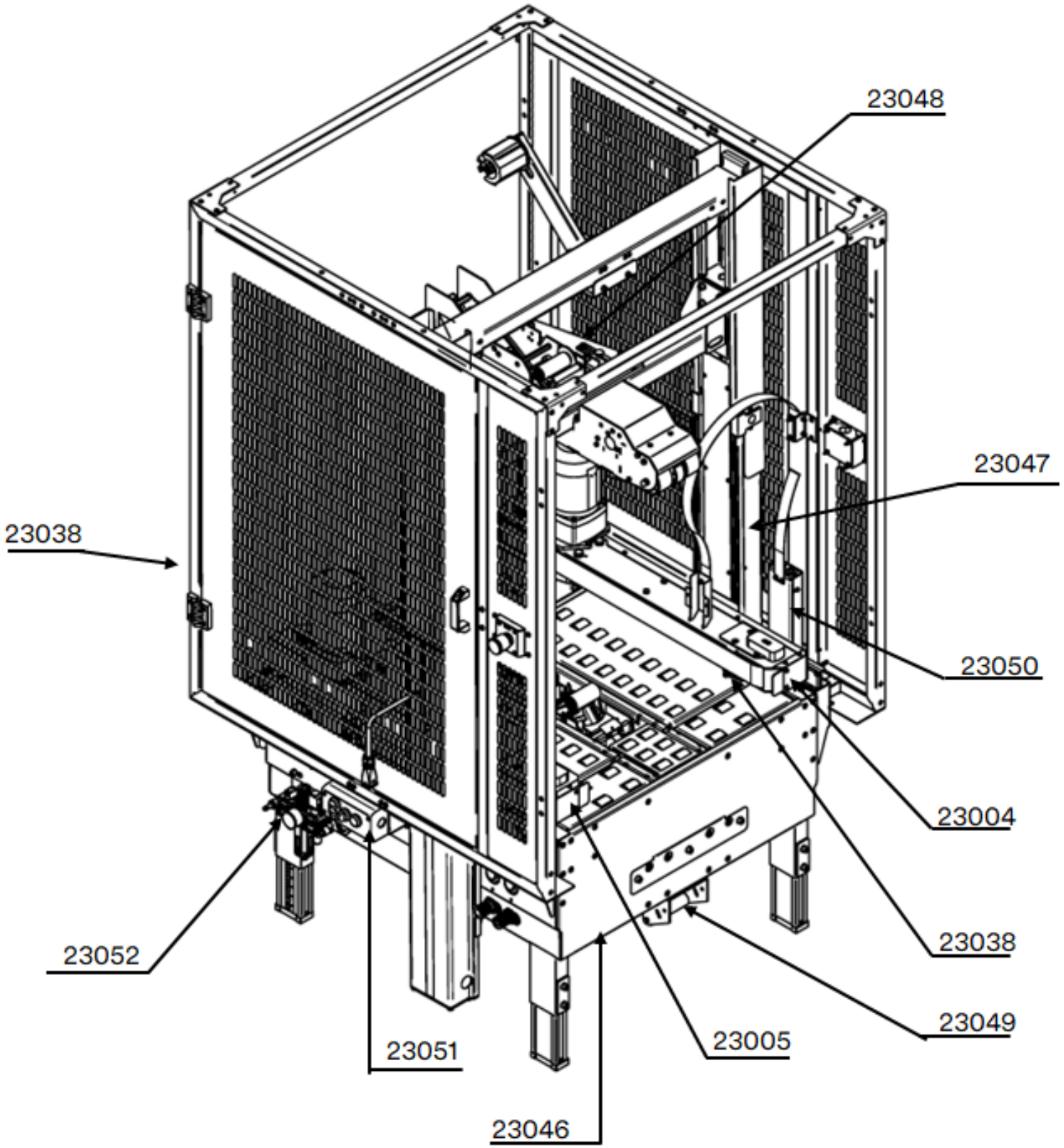
Important – Not all the parts listed are normally stocked items. Some parts or assemblies shown are available only on special order.

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
78-8095-4862-7	Infeed/Exit Conveyor Attachment
78-8069-3926-6	Low Tape Sensor Kit
78-8069-3983-7	Caster Kit



Frame Assemblies

8000r-8000r3

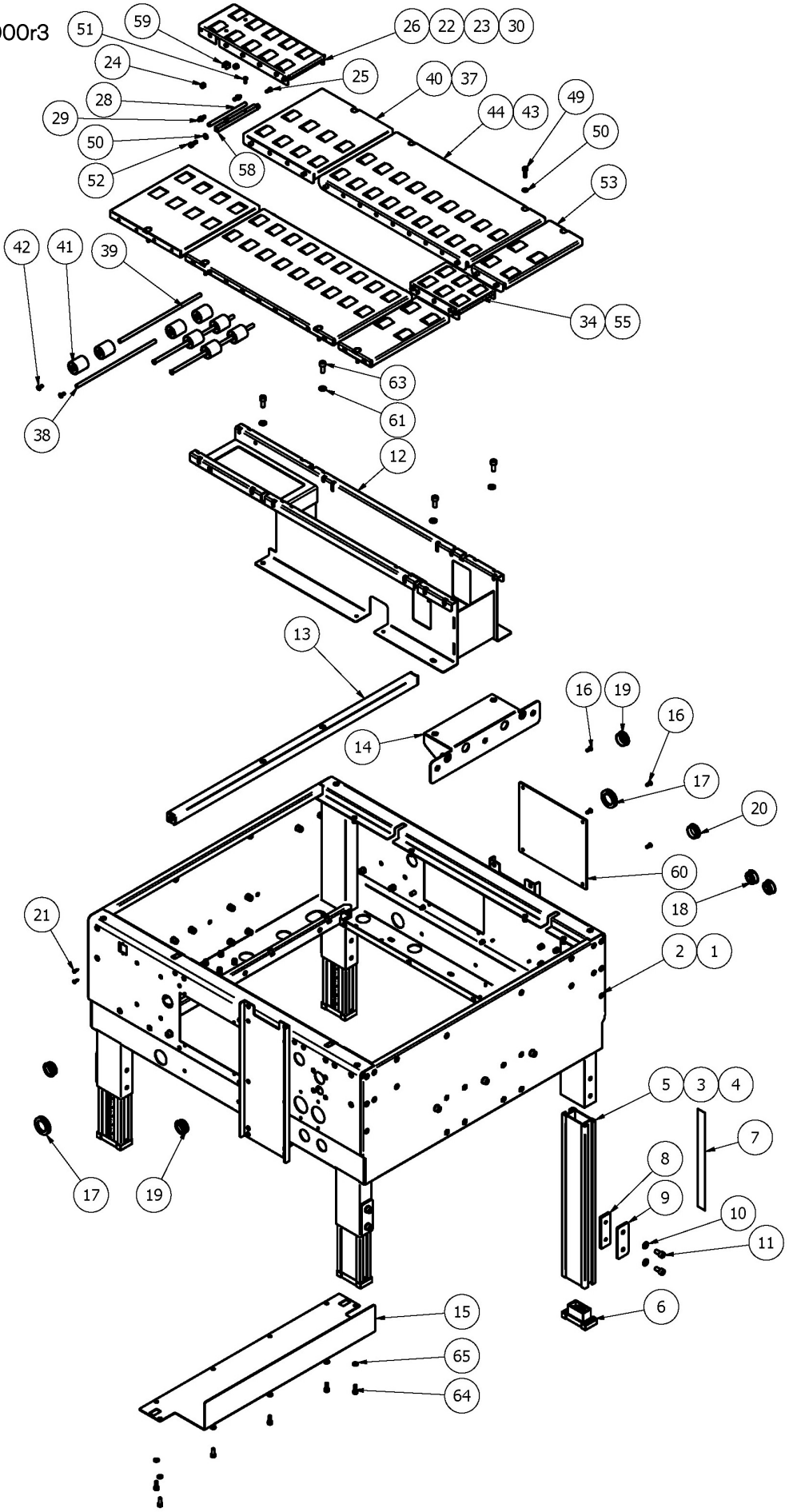


Figure 23046

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
1	1	78-0025-3593-4	BED W/INSERTS
2	1	78-0025-3594-2	WELDMENT-BED
3	1	78-0025-3635-3	LEG ASSEMBLY
4	4	78-8137-6373-3	LEG-INNER ASSY.
5	1	78-8137-6287-5	LEG-INNER
6	1	78-8137-0641-9	PAD-FOOT
7	1	78-8060-8481-6	LABEL-LEG RULER
8	4	78-8137-0635-1	CLAMP-LEG
9	4	78-8129-6100-7	BRACKET
10	8	M8 WSHR	WASHER-M8 PLAIN
11	10	M8x16 SHCS	SCREW-M8x16 SHCS
12	1	78-0025-3599-1	WELDMENT-LOWER BED SUPPORT
13	1	78-0025-3603-1	CROSSBAR ASSEMBLY
14	1	78-8137-7799-8	SHOULDER SUPPORT-LOWER UNIT
15	1	78-0025-3634-6	SUPPORT-BOTTOM REAR
16	4	78-8094-6145-8	SCREW-M5X12 PHBHCS
17	2	78-8094-6406-4	RUBBER CABLE FOR HOLE / 38
18	2	78-8137-0752-4	CAP DP 1187 "Heyco"
19	3	78-8094-6489-0	GROMMET
20	1	78-8094-6177-1	CAP
21	4	78-0025-3646-0	SCREW-SELF TAPPING 6PX13
22	1	78-0025-3647-8	BED PAN ASSEMBLIES
23	1	78-0025-3648-6	REAR PAN ASSY
24	8	M6 HEX NUT-L	NUT-M6 HEX LOCKING
25	8	M5X12 HHCS	SCREW-M5X12 HHCS
26	1	78-0025-3649-4	PAN-BED, REAR
28	8	78-0025-3219-6	PIN-8X124
29	8	78-8076-5389-0	MOUNTING-CONVEYOR
30	1	78-0025-3218-8	REAR CONVEYOR BED PLATE ASSY.
34	1	78-8137-7775-8	BED PLATE-REAR CONVEYOR
37	2	78-0025-3225-3	CONVEYOR-REAR RIGHT/LEFT PLATE ASSY.
38	18	78-0025-3224-6	PIN-8X263.5
39	12	78-0025-3222-0	PIN-8X271
40	1	78-8137-8046-3	CONVEYOR-REAR RIGHT/LEFT PLATE
41	76	78-8060-7693-7	ROLLER-32X38
42	30	M5X12 PHBHCS	SCREW-M5X12 PHBHCS
43	2	78-0025-3650-2	CONVEYOR-MIDDLE RIGHT/LEFT PLATE ASSY.
44	1	78-0025-3651-0	PAN-BED, MIDDLE
49	8	M6x20 SHCS	SCREW-M6X20 SHCS
50	10	M6 WSHR	WASHER-M6 PLAIN
51	2	78-8094-6145-8	SCREW-M5X12 PHBHCS
52	2	M6X16 SHCS	SCREW-M6X16 SHCS
53	2	78-0025-3652-8	CONVEYOR-FRONT RIGHT/LEFT PLATE ASSY.
55	1	78-0025-3653-6	PAN-BED, FRONT
58	1	78-8137-0568-4	Spacer
59	2	78-8091-0655-8	BRACKET-SPACER
60	1	78-0025-3637-9	COVER PLATE-PNEUMATICS
61	9	M8 WSHR	WASHER-M8 PLAIN
63	7	M8x20 SHCS	SCREW-M8X20 SHCS
64	6	M6X16 SHCS	SCREW-M6X16 SHCS
65	6	M6 WSHR	WASHER-M6 PLAIN

Figure 23046

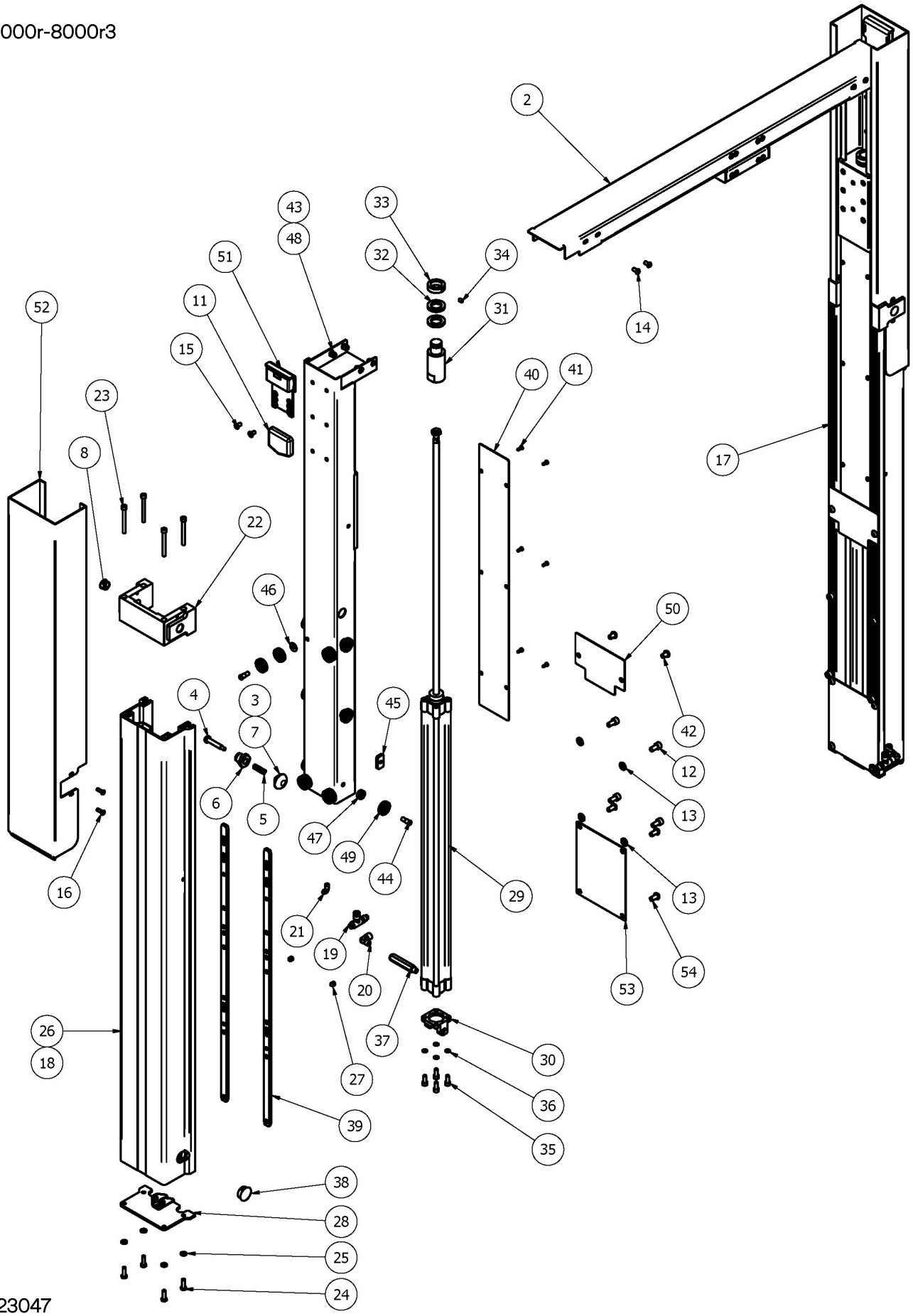


Figure 23047

8000r-8000r3

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
1	1	78-0025-3683-3	COLUMN ASSEMBLIES
2	1	78-8137-8361-6	BEAM ASSY
3	1	78-8137-7949-9	Handle Assembly - Height Adjusting
4	1	78-8076-4544-1	Stud - Height Stop
5	1	78-8076-4545-8	Spring
6	1	78-8076-4543-3	Bushing - Height Stop
7	1	78-8100-0954-4	KNOB (BLACK)
8	3	78-8076-4744-7	CAP-BLACK ABS/22X1
11	2	78-8137-0831-6	Bumper
12	8	M8x16 SHCS	SCREW-M8x16 SHCS
13	8	M8 WSHR	WASHER-M8 PLAIN
14	7	M6X12 BHSHCS	SCREW-6X12 BHSHCS
15	4	M6X12 FHSHCS	SCREW-M6X12 FHSHCS
16	8	78-0025-3696-5	SCREW-M5X16 BHSHCS
17	2	78-0025-3697-3	COLUMN ASSY
18	1	78-0025-3698-1	OUTER COLUMN ASSY
19	1	78-8137-8400-2	CHECK VALVE HGL-1/8-QS-6
20	1	26-1005-6895-0	ELBOW JUNCTION MF 1/8"
21	1	78-8057-5732-1	Ftg - Elbow 1/16 NPT x 4mm (7359-62)
22	1	78-8137-6379-0	CENTRAL BLOCK-COLUMNS
23	4	78-8137-3616-8	Screw - M6X60 Galvanized
24	4	M6X20 HHCS	SCREW-M6X20 HHCS
25	4	M6 WSHR	WASHER-M6 PLAIN
26	1	78-0025-3699-9	COLUMN W/ADHESIVE AND INSERTS
27	2	78-8060-7889-1	SET SCREW-M8X10
28	1	78-8137-6377-4	Bracket - Cylinder Connection
29	1	78-0025-3703-9	CYLINDER ASSY
30	1	78-8137-6383-2	Hinge - Type D5032-A SMC
31	1	78-8137-6378-2	Cylinder Rod Attachment
32	2	78-8054-8823-2	Washer - Bumper
33	1	78-8076-4552-4	Ring Nut - Rod
34	1	78-8059-5617-0	Set Screw - M6 x 8
35	4	M6X16 SHCS	SCREW-M6X16 SHCS
36	4	M6 WSHR SCHN	WASHER-SAFETY (SCHNORR)/6 F144
37	1	78-0025-3704-7	EXTENSION-PNEUMATIC
38	1	78-0025-3705-4	CAP
39	2	78-0025-3706-2	CLEAT
40	1	78-8137-8394-7	PLATE-INNER COLUMN COVER
41	6	78-8017-9257-9	Screw - Phil Hd, M4 x 14
42	2	M8X12 BHSHCS	SCREW-M8X12 BHSHCS
43	1	78-0025-3707-0	INNER COLUMN ASSY
44	10	78-8129-6312-8	SCREW-BEARING
45	10	78-8129-6311-0	PLATE-TAPPED/COLUMN BEARING
46	4	78-8129-6314-4	WASHER-SPECIAL 7 ID x 18 OD
47	6	78-8129-6313-6	BUSHING-SPECIAL 8 ID x 18 OD x 7
48	1	78-0025-3708-8	INNER COLUMN W/INSERTS
49	14	78-0025-0723-0	BEARING 28x6x6
50	2	78-8137-8395-4	PLATE-OUTTER COLUMN COVER
51	2	78-8137-7990-3	DAMPER-SUPPORT ASSY.
52	2	78-0025-3712-0	GUARD-COLUMN
53	2	78-0025-3713-8	COVER-OUTER COLUMN LOWER
54	8	M8X16 BHSHCS	SCREW-M8X16 BHSHCS

Figure 23046

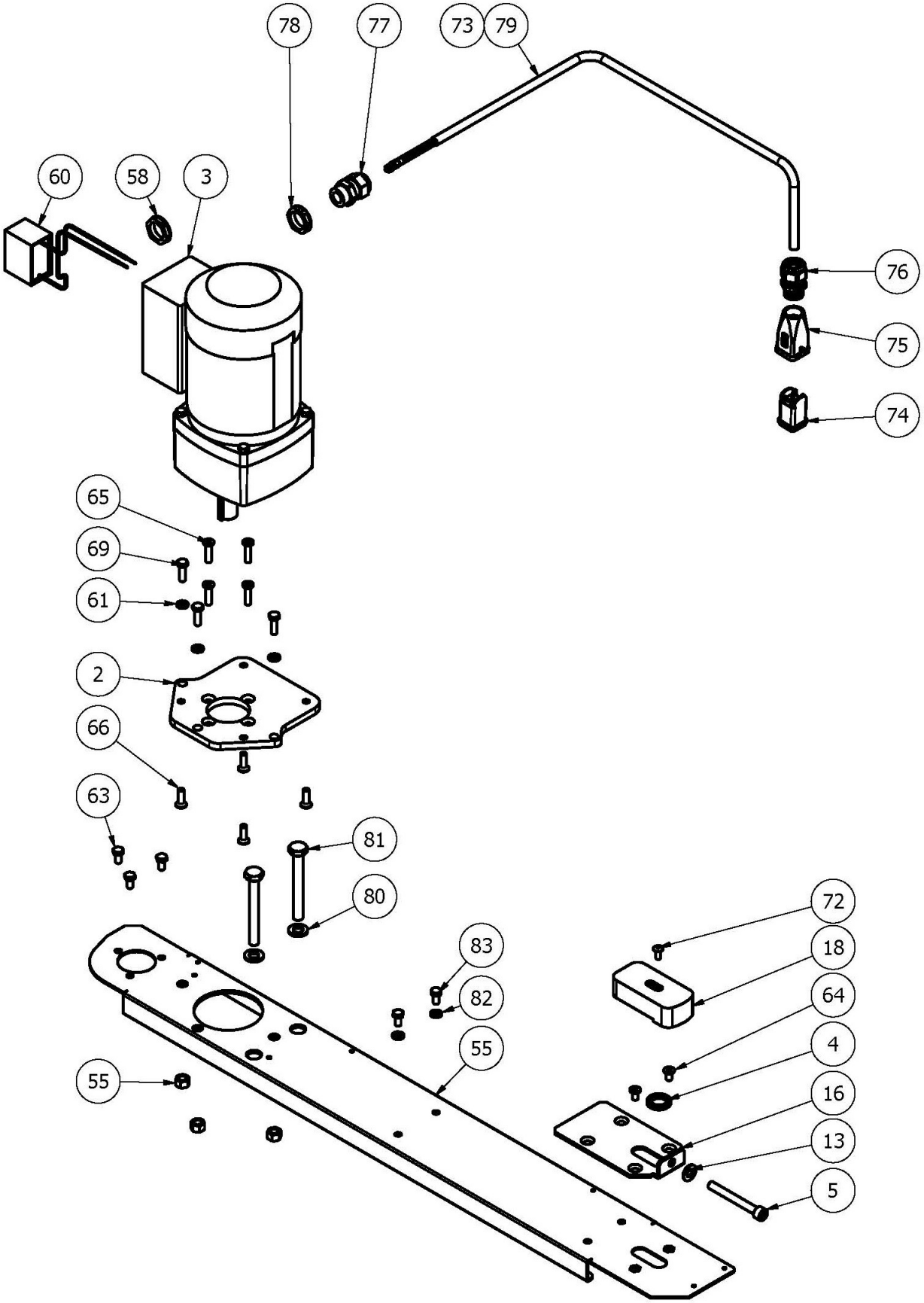


Figure 23004

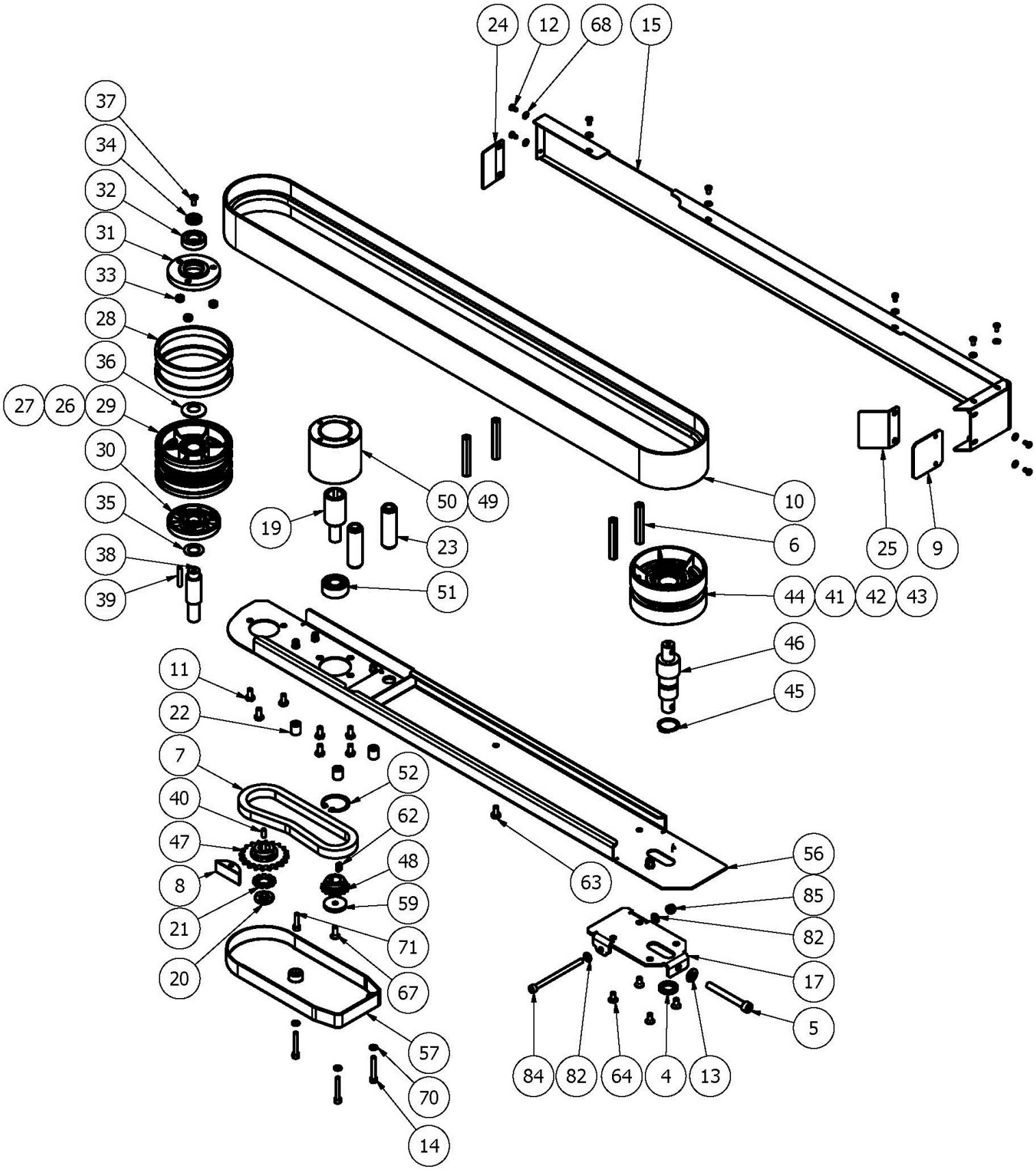


Figure 23004

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
1	1	78-8137-8144-6	RIGHT DRIVE ASSY W/BODINE MOTOR 8000a
2	1	78-8137-7996-0	BRACKET-MOTOR MOUNT BODINE
3	1	78-8070-1522-3	Gearmotor - 115V,60HZ,Bodine w/Cap 1/6HP
4	2	78-8076-5446-8	WASHER-SHAFT
5	2	78-8070-1519-9	SCREW-M8X70 SHCS
6	4	78-8055-0661-1	SPACER-W=10 L=61
7	1	78-8137-7748-5	CHAIN-P3/8 46 LINKS
8	1	78-8137-3796-8	TENSIONER-CHAIN
9	1	78-8100-1214-2	FLAP-DRIVE ENTRY
10	1	78-8076-5452-6	BELT-DRIVE/55X1834 +-2.5
11	7	26-1003-5829-5	Screw - Hex Hd, M6 X 12
12	9	78-8137-7747-7	SCREW-SELF TAPPING 3.9X8
13	2	78-8017-9318-9	Washer - Plain 8 mm
14	3	26-1003-7954-9	SCREW-SOC. HD M5X35
15	1	78-8137-8025-7	COVER-RIGHT DRIVE BELT
16	1	78-8137-7756-8	BRACKET-BELT TENSIONER
17	1	78-8137-7757-6	BRACKET-BELT TENSIONER TOP
18	1	78-8076-5448-4	COVER-BELT TENSIONER
19	1	78-8137-8003-4	SHAFT-PINION
20	1	78-8057-5835-2	WASHER-CENTERING (LOCK NUT)
21	1	78-8057-5834-5	WASHER-LOCK
22	3	78-8137-7760-0	BUSHING-DRIVE BELT COVER
23	2	78-8137-7761-8	SPACER-DRIVE BELT
24	1	78-8137-8023-2	FLAP-DRIVE EXIT
25	1	78-8137-8022-4	BRACKET-DRIVE ENTRY ASSY
26	1	78-8076-5440-1	PULLEY-DRIVE ASSY
27	1	78-8076-5441-9	PULLEY-DRIVE W/RINGS AND BEARINGS
28	2	78-8052-6713-1	RING-POLYURETHANE FRICTION
29	1	78-8137-0858-9	PULLEY-DRIVE
30	2	78-8076-5442-7	FLANGE-ASSY W/NUTS
31	1	78-8114-4709-9	FLANGE-BEARING SUPPORT
32	1	26-1000-4350-9	BEARING-6002 2RS
33	3	78-8137-7936-6	NUTSERT-M6 GALVANIZED
34	1	78-8054-8877-8	WASHER-5.5X20X4 W/COUNTERSINK
35	1	78-8055-0668-6	WASHER-15.2X26X1
36	1	78-8091-0382-9	WASHER-BELLEVILLE 5/16
37	1	26-0001-5862-1	SCREW-M5X12 FHSHCS
38	1	78-8055-0669-4	PIN-DRIVE PULLEY
39	1	78-8057-5739-6	KEY-5X5X30
40	1	5X5X12 KEY	KEY-5X5X12
41	1	78-8076-5443-5	PULLEY-IDLER ASSY
42	1	78-8055-0660-3	PULLEY-IDLER W/BEARINGS
43	1	78-8070-1530-6	BEARING-6205 2RS
44	1	78-0025-3211-3	PULLEY-IDLER
45	1	12-7997-0272-0	SNAP RING-EXT. 25 STAINLESS STEEL
46	1	78-8076-5444-3	PIN-IDLER PULLEY
47	1	78-8137-0935-5	SPROCKET-3/8" Z20
48	1	78-8137-0934-8	SPROCKET-3/8" Z-17
49	1	78-8137-8368-1	SUPPORT-BEARING ASSY
50	1	78-8137-8024-0	SUPPORT-BEARING
51	1	78-8137-7946-5	BEARING-2202 2RS
52	1	78-0025-3398-8	Snap ring
53	1	78-8137-8370-7	GUIDE-UPPER RIGHT W/INSERTS
54	1	78-8137-8371-5	GUIDE-WELDED RIGHT UPPER SUPPORT
55	3	78-0025-3106-5	NUT-M8-3M
56	1	78-8137-8004-2	GUIDE-LOWER RIGHT W/INSERTS
57	1	78-8137-0870-4	COVER-CHAIN
58	1	78-8129-6469-6	NUT-CORD GRIP M20X1.5
59	1	78-8054-8577-4	WASHER-SPECIAL 6.5X30X5 W/COUNTERSINK
60	1	26-1011-8828-7	CAPACITOR-15 MF 300V
61	5	M6 WSHR	WASHER-M6 PLAIN
62	1	5X5X12 KEY	KEY-5X5X12
63	5	M6X12 HHCS	SCREW- M6X12 HHCS SPECIAL
64	8	M6X12 FHSHCS	SCREW-M6X12 FHSHCS
65	4	M6X25 FHSHCS	SCREW-M6X25 FHSHCS
66	4	M6X20 FHSHCS	SCREW-M6X20 FHSHCS
67	1	M6X16 FHSHCS	SCREW-M6X16 FHSHCS
68	9	M4 WSHR	WASHER-M4 PLAIN
69	3	M6X20 HHCS	SCREW-M6X20 HHCS

Figure 23004

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
70	3	M5 WSHR	WASHER-M5 PLAIN
71	1	M5X20 SHCS	SCREW-M5X20 SHCS
72	1	M5X12 PHBHCS	SCREW-M5X12 PHBHCS
73	1	78-0025-3399-6	HARNESS-DRIVE MOTOR
74	1	78-8060-7875-0	PLUG-MALE 3P+T
75	1	78-8060-7877-6	PLUG HOUSING-VERTICAL
76	1	78-8076-4532-6	CORD GRIP-PG11
77	1	78-8076-4715-7	CORD GRIP-13X1.5
78	1	78-8076-5211-6	NUT-SET GMP 13.5
79	1	78-8134-1975-7	CABLE-3G 1.5UL/CSA
80	2	M10 WSHR	WASHER-M10 PLAIN
81	2	M10X85 HHCS	SCREW-M10X85 HHCS
82	4	M6 WSHR	WASHER-M6 PLAIN
83	2	M6X12 HHCS	SCREW- M6X12 HHCS SPECIAL
84	1	M6X90 SHCS	SCREW-M6X90 SHCS
85	1	M6 HEX NUT-L	NUT-M6 HEX LOCKING

Figure 23004

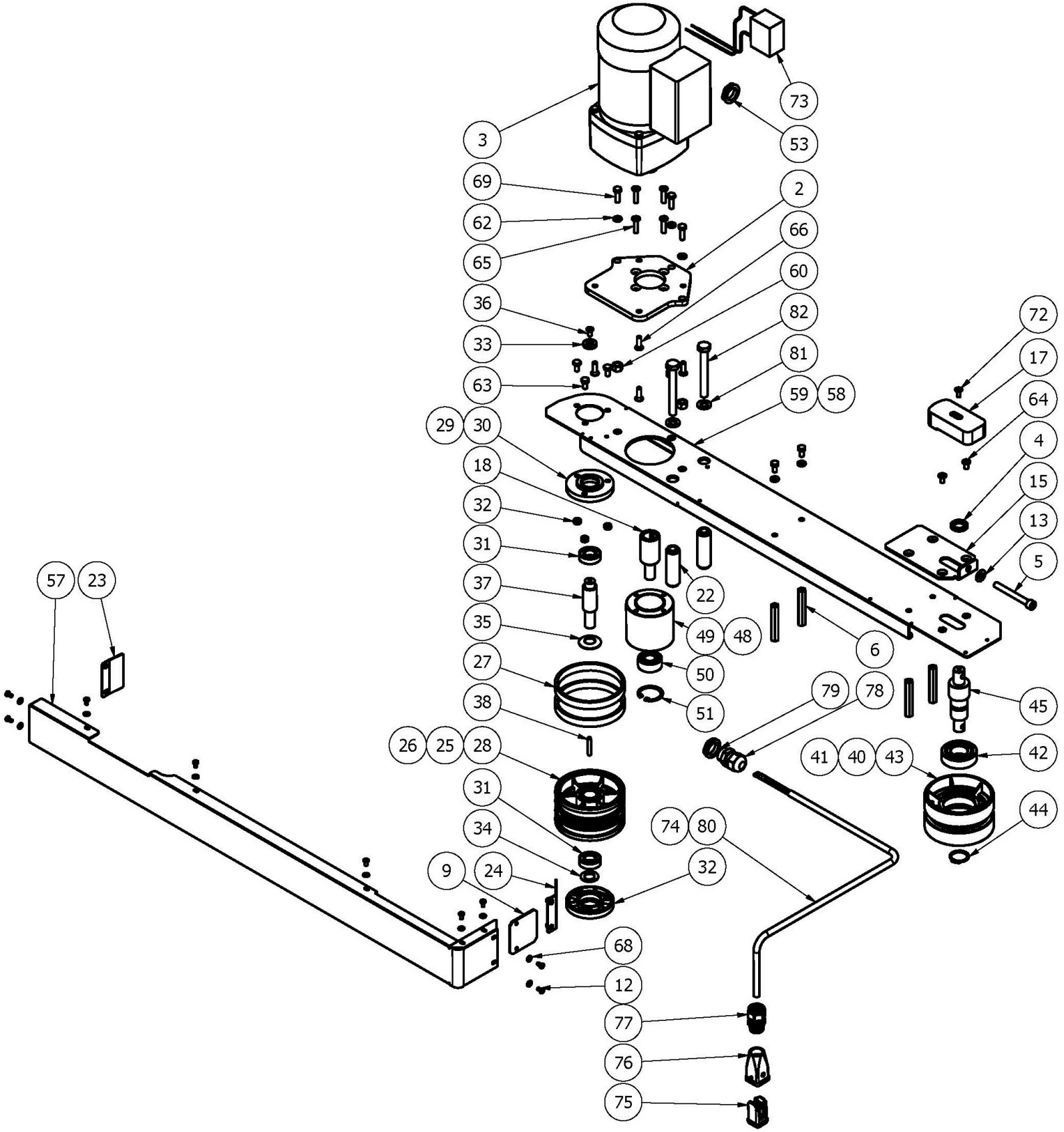


Figure 23005

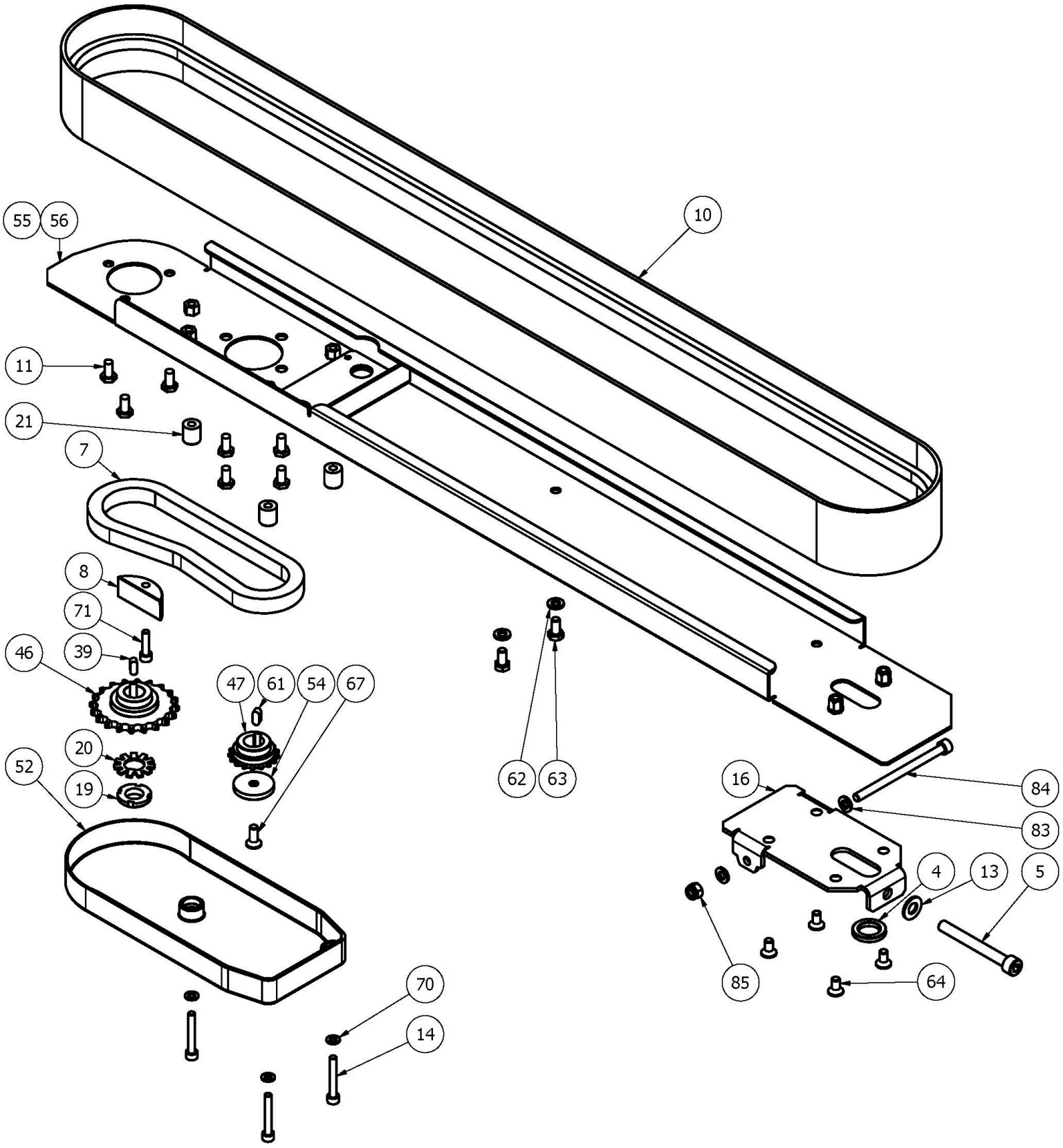


Figure 23005

8000r-8000r3

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
1	1	78-8137-8145-3	LEFT DRIVE ASSY 8000a-3M
2	1	78-8137-7996-0	BRACKET-MOTOR MOUNT BODINE
3	1	78-8070-1522-3	Gearmotor - 115V,60HZ,Bodine w/Cap 1/6HP
4	2	78-8076-5446-8	WASHER-SHAFT
5	2	78-8070-1519-9	SCREW-M8X70 SHCS
6	4	78-8055-0661-1	SPACER-W=10 L=61
7	1	78-8137-7748-5	CHAIN-P3/8 46 LINKS
8	1	78-8137-3796-8	TENSIONER-CHAIN
9	1	78-8100-1214-2	FLAP-DRIVE ENTRY
10	1	78-8076-5452-6	BELT-DRIVE/55X1834 +-2.5
11	7	26-1003-5829-5	Screw - Hex Hd, M6 X 12
12	9	78-8137-7747-7	SCREW-SELF TAPPING 3.9X8
13	2	78-8017-9318-9	Washer - Plain 8 mm
14	3	26-1003-7954-9	SCREW-SOC. HD M5X35
15	1	78-8137-7756-8	BRACKET-BELT TENSIONER
16	1	78-8137-7757-6	BRACKET-BELT TENSIONER TOP
17	1	78-8076-5448-4	COVER-BELT TENSIONER
18	1	78-8137-8003-4	SHAFT-PINION
19	1	78-8057-5835-2	WASHER-CENTERING (LOCK NUT)
20	1	78-8057-5834-5	WASHER-LOCK
21	3	78-8137-7760-0	BUSHING-DRIVE BELT COVER
22	2	78-8137-7761-8	SPACER-DRIVE BELT
23	1	78-8137-8023-2	FLAP-DRIVE EXIT
24	1	78-8137-8022-4	BRACKET-DRIVE ENTRY ASSY
25	1	78-8076-5440-1	PULLEY-DRIVE ASSY
26	1	78-8076-5441-9	PULLEY-DRIVE W/RINGS AND BEARINGS
27	2	78-8052-6713-1	RING-POLYURETHANE FRICTION
28	1	78-8137-0858-9	PULLEY-DRIVE
29	2	78-8076-5442-7	FLANGE-ASSY W/NUTS
30	1	78-8114-4709-9	FLANGE-BEARING SUPPORT
31	1	26-1000-4350-9	BEARING-6002 2RS
32	3	78-8137-7936-6	NUTSERT-M6 GALVANIZED
33	1	78-8054-8877-8	WASHER-5.5X20X4 W/COUNTERSINK
34	1	78-8055-0668-6	WASHER-15.2X26X1
35	1	78-8091-0382-9	WASHER-BELLEVILLE 5/16
36	1	26-0001-5862-1	SCREW-M5X12 FHSHCS
37	1	78-8055-0669-4	PIN-DRIVE PULLEY
38	1	78-8057-5739-6	KEY-5X5X30
39	1	5X5X12 KEY	KEY-5X5X12
40	1	78-8076-5443-5	PULLEY-IDLER ASSY
41	1	78-8055-0660-3	PULLEY-IDLER W/BEARINGS
42	1	78-8070-1530-6	BEARING-6205 2RS
43	1	78-0025-3211-3	PULLEY-IDLER
44	1	12-7997-0272-0	SNAP RING-EXT. 25 STAINLESS STEEL
45	1	78-8076-5444-3	PIN-IDLER PULLEY
46	1	78-8137-0935-5	SPROCKET-3/8" Z20
47	1	78-8137-0934-8	SPROCKET-3/8" Z-17
48	1	78-8137-8368-1	SUPPORT-BEARING ASSY
49	1	78-8137-8024-0	SUPPORT-BEARING
50	1	78-8137-7946-5	BEARING-2202 2RS
51	1	78-0025-3398-8	Snap ring
52	1	78-8137-0870-4	COVER-CHAIN
53	1	78-8129-6469-6	NUT-CORD GRIP M20X1.5
54	1	78-8054-8577-4	WASHER-SPECIAL 6.5X30X5 W/COUNTERSINK
55	1	78-8137-8365-7	GUIDE-WELDED LEFT LOWER SUPPORT
56	1	78-0025-3244-4	GUIDE-LOWER SUPPORT LEFT
57	1	78-8137-8027-3	COVER-LEFT DRIVE BELT
58	1	78-8137-8366-5	GUIDE-UPPER LEFT W/INSERTS
59	1	78-0025-3246-9	SUP GUIDE LEFT ENGINE BODINE 8000a-3M

Figure 23005

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
60	3	78-0025-3106-5	NUT-M8-3M
61	1	5X5X12 KEY	KEY-5X5X12
62	7	M6 WSHR	WASHER-M6 PLAIN
63	7	M6X12 HHCS	SCREW- M6X12 HHCS SPECIAL
64	8	M6X12 FHSHCS	SCREW-M6X12 FHSHCS
65	4	M6X25 FHSHCS	SCREW-M6X25 FHSHCS
66	4	M6X20 FHSHCS	SCREW-M6X20 FHSHCS
67	1	M6X16 FHSHCS	SCREW-M6X16 FHSHCS
68	9	M4 WSHR	WASHER-M4 PLAIN
69	3	M6X20 HHCS	SCREW-M6X20 HHCS
70	3	M5 WSHR	WASHER-M5 PLAIN
71	1	M5X20 SHCS	SCREW-M5X20 SHCS
72	1	M5X12 PHBHCS	SCREW-M5X12 PHBHCS
73	1	26-1011-8828-7	CAPACITOR-15 MF 300V
74	1	78-0025-3399-6	HARNESS-DRIVE MOTOR
75	1	78-8060-7875-0	PLUG-MALE 3P+T
76	1	78-8060-7877-6	PLUG HOUSING-VERTICAL
77	1	78-8076-4532-6	CORD GRIP-PG11
78	1	78-8076-4715-7	CORD GRIP-13X1.5
79	1	78-8076-5211-6	NUT-SET GMP 13.5
80	1	78-8134-1975-7	CABLE-3G 1.5UL/CSA
81	2	M10 WSHR	WASHER-M10 PLAIN
82	2	M10X85 HHCS	SCREW-M10X85 HHCS
83	2	M6 WSHR	WASHER-M6 PLAIN
84	1	M6X90 SHCS	SCREW-M6X90 SHCS
85	1	M6 HEX NUT-L	NUT-M6 HEX LOCKING

Figure 23005

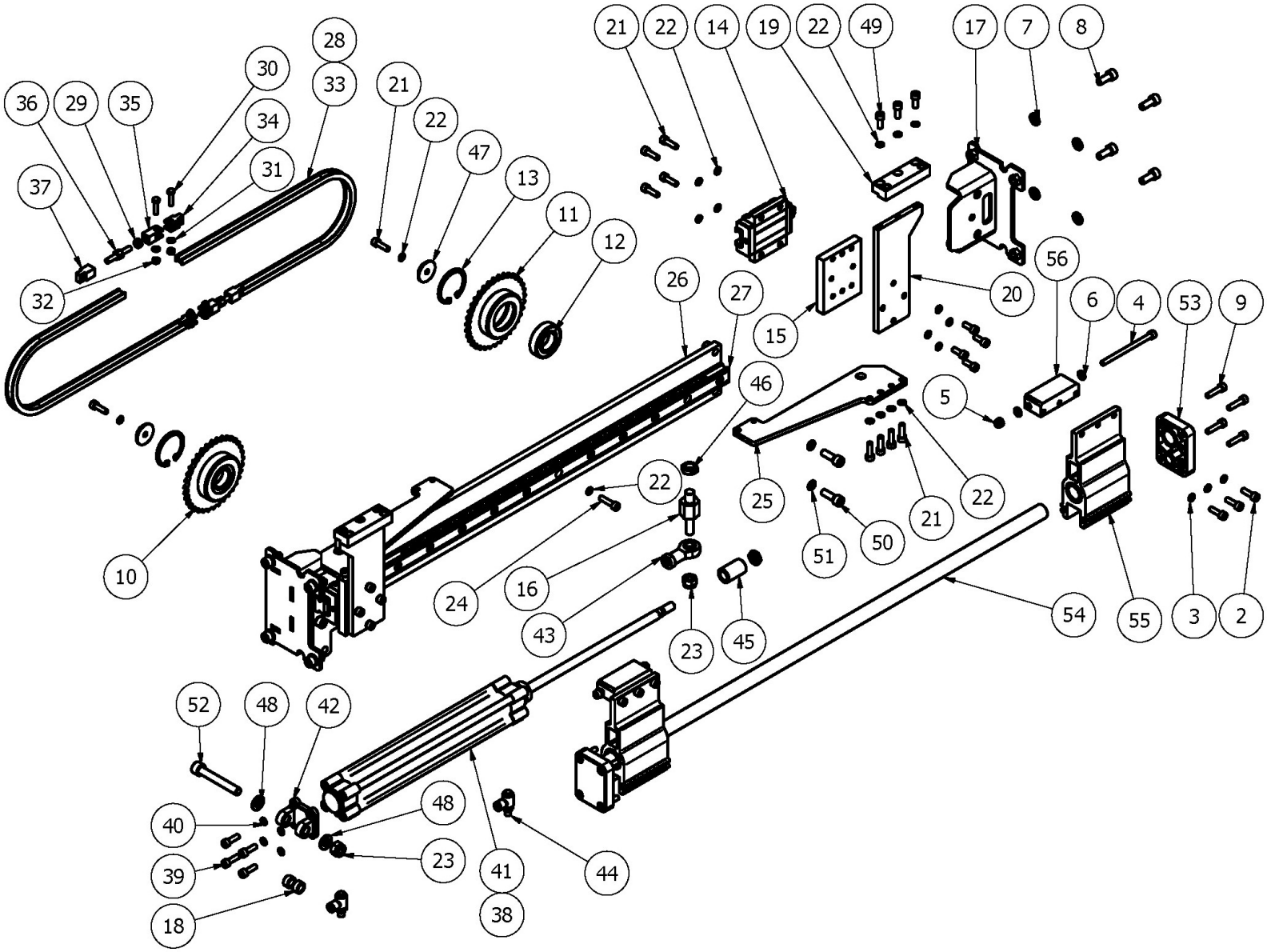


Figure 23038

8000r-8000r3

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
1	1	78-0025-3607-2	CENTERING ASSEMBLY
2	6	M6x20 SHCS	SCREW-M6X20 SHCS
3	6	M6 WSHR SCHN	WASHER-SAFETY (SCHNORR)/6 F144
4	2	M6X90 SHCS	SCREW-M6X90 SHCS
5	2	M6 HEX NUT-L	NUT-M6 HEX LOCKING
6	4	M6 WSHR	WASHER-M6 PLAIN
7	8	M8 WSHR	WASHER-M8 PLAIN
8	8	M8x20 SHCS	SCREW-M8X20 SHCS
9	8	M6x25 SHCS	SCREW-M6X25 SHCS
10	2	78-8137-3619-2	SPROCKET - 3/8" Z35 W/BEARING
11	1	78-0025-3609-8	SPROCKET-3/8" Z35
12	1	78-8023-2551-0	BEARING - 6005-2RS
13	1	78-8137-3621-8	SNAP RING-EXT.D47 STAINLESS STEEL
14	2	78-0025-3610-6	BLOCK-GUIDE ASSY
15	2	78-0025-3611-4	BLOCK-MOUNTING
16	1	78-0025-3612-2	PIN-CYLINDER
17	2	78-0025-3613-0	WELDMENT-MOUNTING ASSY
18	2	78-0025-3616-3	BUSHING
19	2	78-0025-3617-1	PLATE-DRIVE MOUNTING
20	2	78-0025-3618-9	PLATE-CENTERING ARM
21	18	M6x20 SHCS	SCREW-M6X20 SHCS
22	45	M6 WSHR SCHN	WASHER-SAFETY (SCHNORR)/6 F144
23	2	M10 HEX NUT	NUT-M10 HEX LOCKING
24	13	M6x25 SHCS	SCREW-M6X25 SHCS
25	2	78-0025-3619-7	CONNECTING ARM
26	1	78-0025-3620-5	WELDMENT-TRANSMISSION BAR
27	1	78-0025-3623-9	GUIDE-BEARING
28	1	78-0025-3624-7	CHAIN ASSY
29	2	M6 HEX NUT	NUT-M6 HEX
30	4	M5X20 HHCS	SCREW-M5X20 HHCS
31	4	M5 WSHR	WASHER-M5 PLAIN
32	4	26-1005-6859-6	Nut - Self-Locking, M5 VC
33	2	78-0025-3625-4	CHAIN
34	2	78-8137-3629-1	Chain coupling
35	2	78-8137-3628-3	Right fork
36	2	78-8054-8785-3	Rod - Threaded Right/Left
37	2	78-8137-3627-5	Left Fork
38	1	78-0025-3626-2	CYLINDER ASSY
39	4	M6x20 SHCS	SCREW-M6X20 SHCS
40	4	M6 WSHR SCHN	WASHER-SAFETY (SCHNORR)/6 F144
41	1	78-0025-3627-0	CYLINDER
42	1	78-8129-6494-4	CYLINDER BASE
43	2	78-8100-0828-0	FLOW REGULATOR AS 2201F 01-06S F144
44	1	78-0025-3628-8	SPACER
45	1	78-0025-3769-0	Mount - Cylinder Rod End
46	1	78-8091-0555-0	Nut - M12 Special
47	2	78-8052-6709-9	Washer - Special
48	2	M10 WSHR	WASHER-M10 PLAIN
49	14	M6X16 SHCS	SCREW-M6X16 SHCS
50	4	26-1003-7965-5	Screw - Soc. Hd. Hx. Soc. M8 x 25
51	4	M8 WSHR SCHN	WASHER-SAFETY (SCHNORR)/8 F144
52	1	78-0025-3629-6	SCREW-M10X70 SHCS
53	2	78-8137-8100-8	ROD SUPPORT-S11-T KYOWA S8
54	1	78-0025-3630-4	LINEAR GUIDE ROD
55	2	78-0025-3631-2	BEARING BLOCK ASSY
56	2	78-0025-3633-8	BLOCK-DRIVE ATTACHMENT

Figure 23038

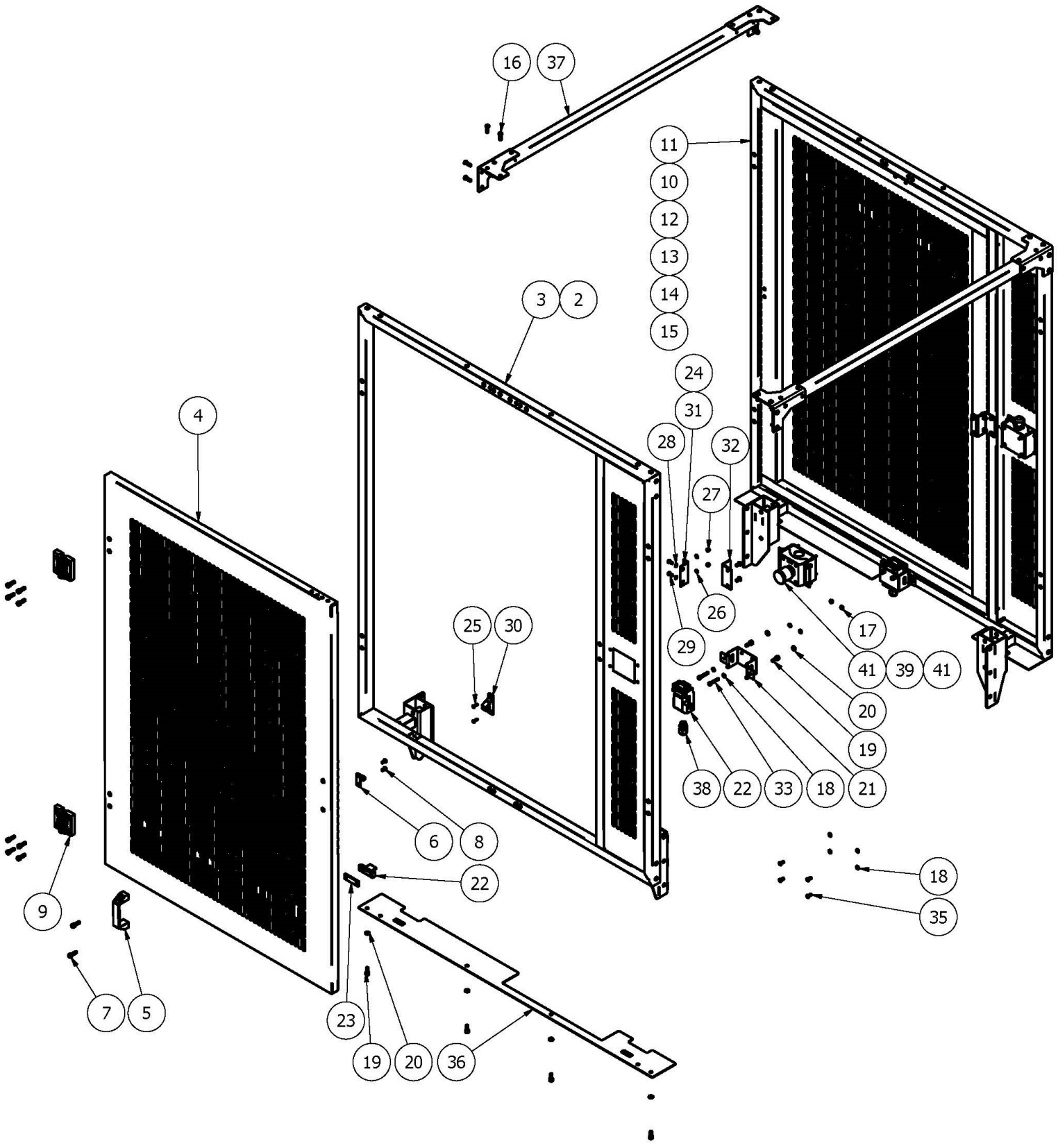


Figure 23044

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
1	1	78-0025-3655-1	Guarding Assemblies
2	1	78-0025-3656-9	GAURDING-LEFT SIDE ASSY
3	1	78-0025-3657-7	FRAME-LEFT W/STATIC PANEL & INSERTS
4	1	78-0025-3667-6	GUARDING-DOOR ASSEMBLY
5	1	78-8060-7807-3	HANDLE M443/110
6	1	78-8076-4931-0	Stop - Male Latch
7	12	M6x20 SHCS	SCREW-M6X20 SHCS
8	4	M5X12 FHSHCS	SCREW-M5X12 FHSHCS
9	2	78-8129-6293-0	Hinge - Elesa
10	1	78-0025-3669-2	GAURDING-RIGHT SIDE ASSY
11	1	78-0025-3670-0	FRAME-RIGHT W/STATIC PANEL & INSERTS
12	1	78-0025-3667-6	GUARDING-DOOR ASSEMBLY
13	2	78-8129-6293-0	Hinge - Elesa
14	1	78-8060-7807-3	HANDLE M443/110
15	1	78-8076-4931-0	Stop - Male Latch
16	20	78-8137-4035-0	SCREW-M6X20 BHSHCS
17	4	26-1005-6859-6	Nut - Self-Locking, M5 VC
18	14	M5 WSHR	WASHER-M5 PLAIN
19	20	M6X16 SHCS	SCREW-M6X16 SHCS
20	12	M6 WSHR	WASHER-M6 PLAIN
21	2	78-0025-3672-6	BRACKET-INTERLOCK
22	2	78-8076-4929-4	SAFETY INTERLOCK 800af AZ15ZVR
23	2	78-0025-3673-4	SPACER-DOOR LOCK
24	2	78-0025-3674-2	DOOR LOCK ASSY
25	2	26-1004-7121-3	SCREW-M4X15 FHSHCS
26	2	M4 WSHR	WASHER-M4 PLAIN
27	2	M4 HEX-L	NUT-M4 HEX-L
28	2	M5 WSHR SCHN	SAFETY WASHER "S" (SCHNORR)/5 F144
29	2	78-8094-6145-8	SCREW-M5X12 PHBHCS
30	1	78-8076-4932-8	Stop - Female Latch
31	1	78-0025-3676-7	BRACKET-DOOR LOCK "B"
32	1	78-0025-3759-1	BRACKET ASSY
33	4	M5X30 SHCS	SCREW-M5X30 SHCS
34	4	M6X12 BHSHCS	SCREW-6X12 BHSHCS
35	8	78-8094-6145-8	SCREW-M5X12 PHBHCS
36	2	78-0025-3677-5	PLATE-BOTTOM GUARDING
37	2	78-0025-3680-9	CROSSBAR ASSY
38	2	78-8100-1199-5	CORD GRIP
39	2	78-0025-3757-5	E-STOP ASSY W/BRACKET
40	1	78-0025-3678-3	BRACKET-E STOP ASSY
41	1	78-0025-3385-5	EMERGENCY STOP ASSY 8000A

Figure 23044

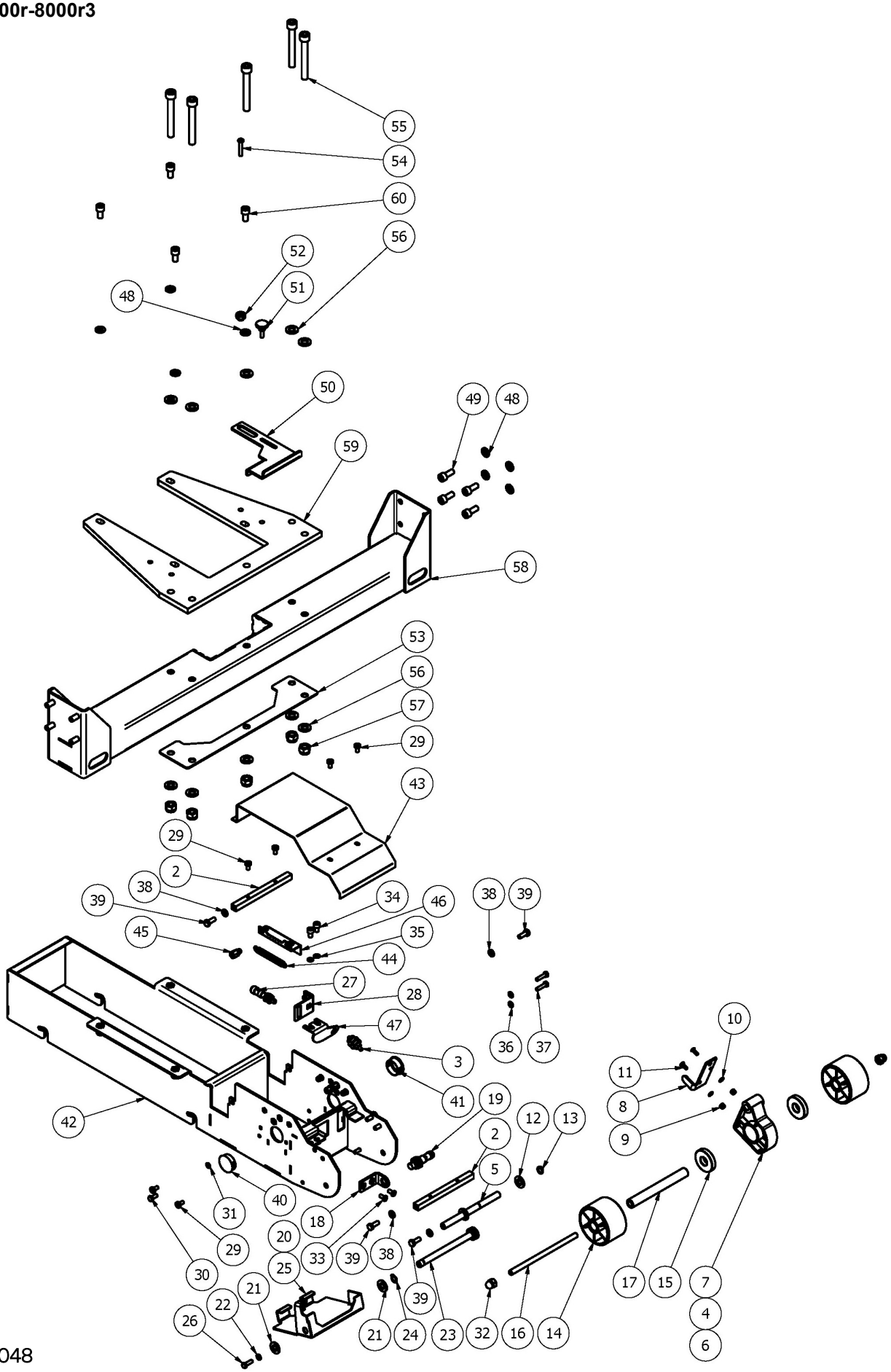
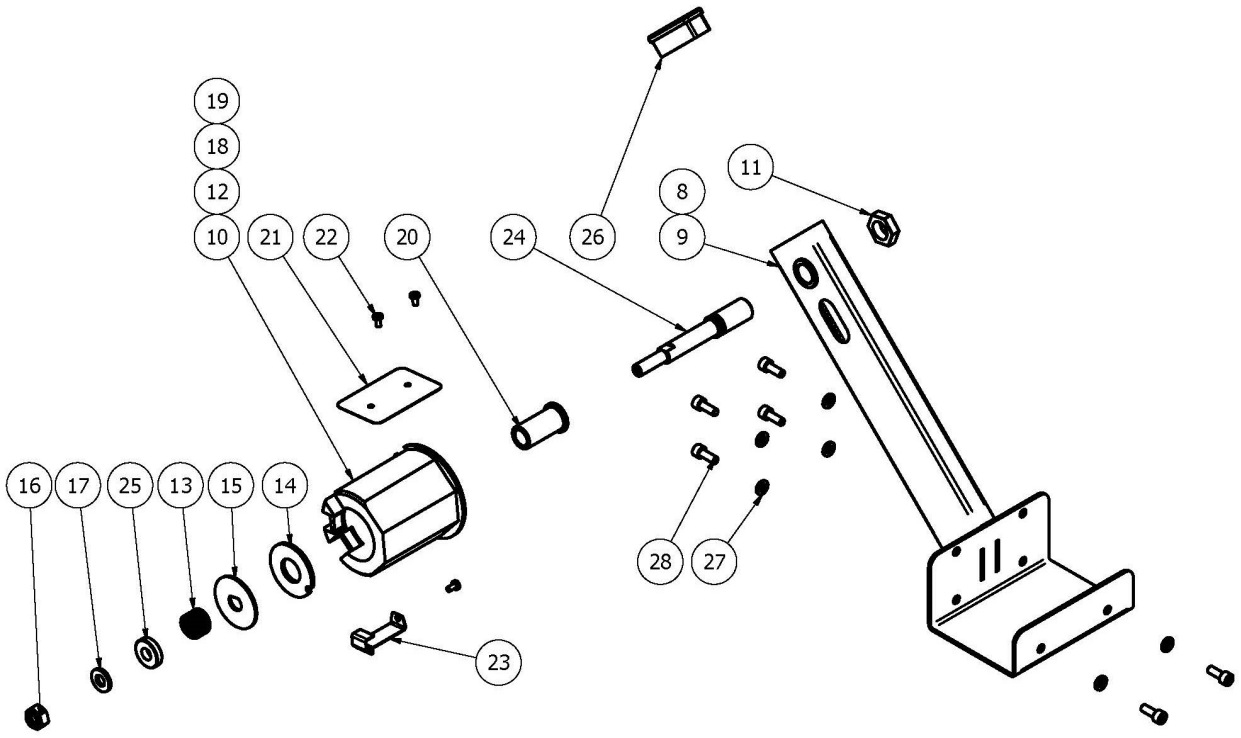


Figure 23048

8000r-8000r3

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
1	1	78-0025-3719-5	UPPER HEAD SUPPORT ASSY
2	2	78-8137-0568-4	Spacer
3	1	78-8137-7719-6	SPRING PLUNGER
4	1	78-0025-3720-3	NOSE SWITCH ASSY
5	1	78-8137-0591-6	PIN-CAM
6	1	78-8137-8224-6	Lever Assy
7	1	78-8137-8019-0	Lever - Proximity Sensor
8	1	78-8137-8387-1	Bracket – Support Nose Switch 7000rhs
9	2	M4 HEX-L	NUT-M4 HEX-L
10	2	M4 WSHR	WASHER-M4 PLAIN
11	2	78-8017-9317-1	SCREW-M4X12 FHSHCS
12	2	M10 WSHR	WASHER-M10 PLAIN
13	2	78-8016-5855-6	E-Ring - 10 mm
14	2	78-8137-0599-9	Roller
15	2	78-8137-7715-4	Spacer - Infeed Rollers
16	1	78-8137-0535-3	Shaft - Roller 700a3 (15233-14)
17	1	78-8137-0536-1	Tube - Roller Entry
18	1	78-0025-3721-1	BRACKET-SENSOR
19	1	78-8137-7720-4	Switch - Proximity M12 7000r
20	1	78-0025-3722-9	PADDLE ASSY
21	4	M10 WSHR	WASHER-M10 PLAIN
22	2	M5 WSHR	WASHER-M5 PLAIN
23	1	78-8137-8234-5	PIN-PADDLE
24	2	78-8016-5855-6	E-Ring - 10 mm
25	1	78-0025-3723-7	PADDLE
26	2	M5X16 HHCS	SCREW-M5X16 HHCS
27	1	78-8137-8230-3	PROXIMITY SENSOR
28	1	78-0025-3724-5	PROXIMITY SENSOR BRACKET ASSY
29	6	78-8060-8087-1	Screw - M5 x 10
30	1	M5X12 HHCS	SCREW-M5X12 HHCS
31	1	M5 WSHR SCHN	SAFETY WASHER "S" (SCHNORR)/5 F144
32	2	M8 ACORN NUT	NUT-M8 ACORN
33	2	M5X12 FHSHCS	SCREW-M5X12 FHSHCS
34	2	78-8010-7229-5	SCREW-M6X10 SHCS
35	2	M6 WSHR SCHN	WASHER-SAFETY (SCHNORR)/6 F144
36	2	M5 WSHR	WASHER-M5 PLAIN
37	2	M5X20 HHCS	SCREW-M5X20 HHCS
38	6	M6 WSHR	WASHER-M6 PLAIN
39	6	M6X16 HHCS	SCREW-M6X16 HHCS
40	1	78-8114-4966-5	CAP - DP-1093 /28
41	1	78-8076-4702-5	GROMMET-HEYCO SB1093-13
42	1	78-0025-3726-0	HOUSING ASSY
43	1	78-0025-3732-8	HOUSING TOP
44	1	78-0025-3733-6	SPRING
45	1	78-0025-3734-4	Pivot
46	1	78-0025-3735-1	SPRING BRACKET ASSY
47	1	78-0025-3737-7	BRACKET-SPRING PLUNGER
48	12	M8 WSHR	WASHER-M8 PLAIN
49	8	M8x20 SHCS	SCREW-M8X20 SHCS
50	1	78-0025-3687-4	LOCK-TAPE HEAD
51	1	78-8137-6355-0	Knob - M5X16 Elesa DIN 464
52	1	78-8137-8397-0	BUSHING
53	1	78-0025-3692-4	PLATE-BOTTOM CROSSBEAM
54	1	78-0025-3695-7	SCREW-M5X30 BHSHCS
55	5	78-8076-4796-7	SCREW-M10X80 SHCS
56	10	M10 WSHR	WASHER-M10 PLAIN
57	5	M10 HEX NUT	NUT-M10 HEX LOCKING
58	1	78-0025-3688-2	WELDMENT-TAPE HEAD CROSSBEAM
59	1	78-0025-3693-2	PLATE-TOP CROSSBEAM ASSY
60	4	M8x16 SHCS	SCREW-M8x16 SHCS

Figure 23048



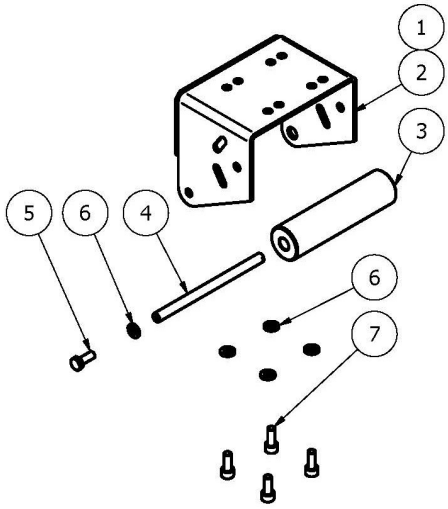


Figure 23049

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
1	1	78-0025-3235-2	OUTBOARD TAPING ASSY 3"
2	1	78-0025-3236-0	BRACKET-SUPPORT OUTBOARD TAPING 3" (LOWER)
3	1	78-0025-3241-0	ROLLER-TAPE 3"
4	1	78-8076-4759-5	SHAFT - ROLLER 3"
5	1	M6X16 HHCS	SCREW-M6X16 HHCS
6	5	M6 WSHR	WASHER-M6 PLAIN
7	4	M6X16 SHCS	SCREW-M6X16 SHCS
8	1	78-8137-8154-5	UPPER TAPE ARM ASSY
9	1	78-8137-8028-1	Bracket - Tape Head Arm
10	1	78-0025-3260-0	TAPE DRUM ASSY-3" WITH NUT
11	1	78-8017-9169-6	Nut - M18 x 1
12	1	78-8098-8832-0	TAPE DRUM ASSY W/SHAFT 3"
13	1	78-8100-1048-4	Spring - Core Holder
14	1	78-8060-8172-1	Washer - Friction
15	1	78-8052-6271-0	Washer - Tape Drum
16	1	78-8017-9077-1	Nut - Self Locking, M10 x 1
17	1	26-1004-5510-9	Washer - Plain, M10 x 20 x 2.5
18	1	78-8098-8829-6	Tape Drum Sub Assembly - 3 Inch Wide
19	1	78-8098-8828-8	DRUM-TAPE 3"
20	1	78-8137-8360-8	BUSHING
21	1	78-8098-8830-4	SPRING-LEAF 3"
22	3	26-1002-5753-9	Screw - Self Tapping
23	1	78-8098-8816-3	Latch - Tape Drum
24	1	78-8137-8058-8	SHAFT-TAPE DRUM 3"
25	1	78-8052-6651-3	Washer - Nylon
26	1	78-8137-6346-9	Cap
27	6	M6 WSHR	WASHER-M6 PLAIN
28	6	M6X16 SHCS	SCREW-M6X16 SHCS

Figure 23049

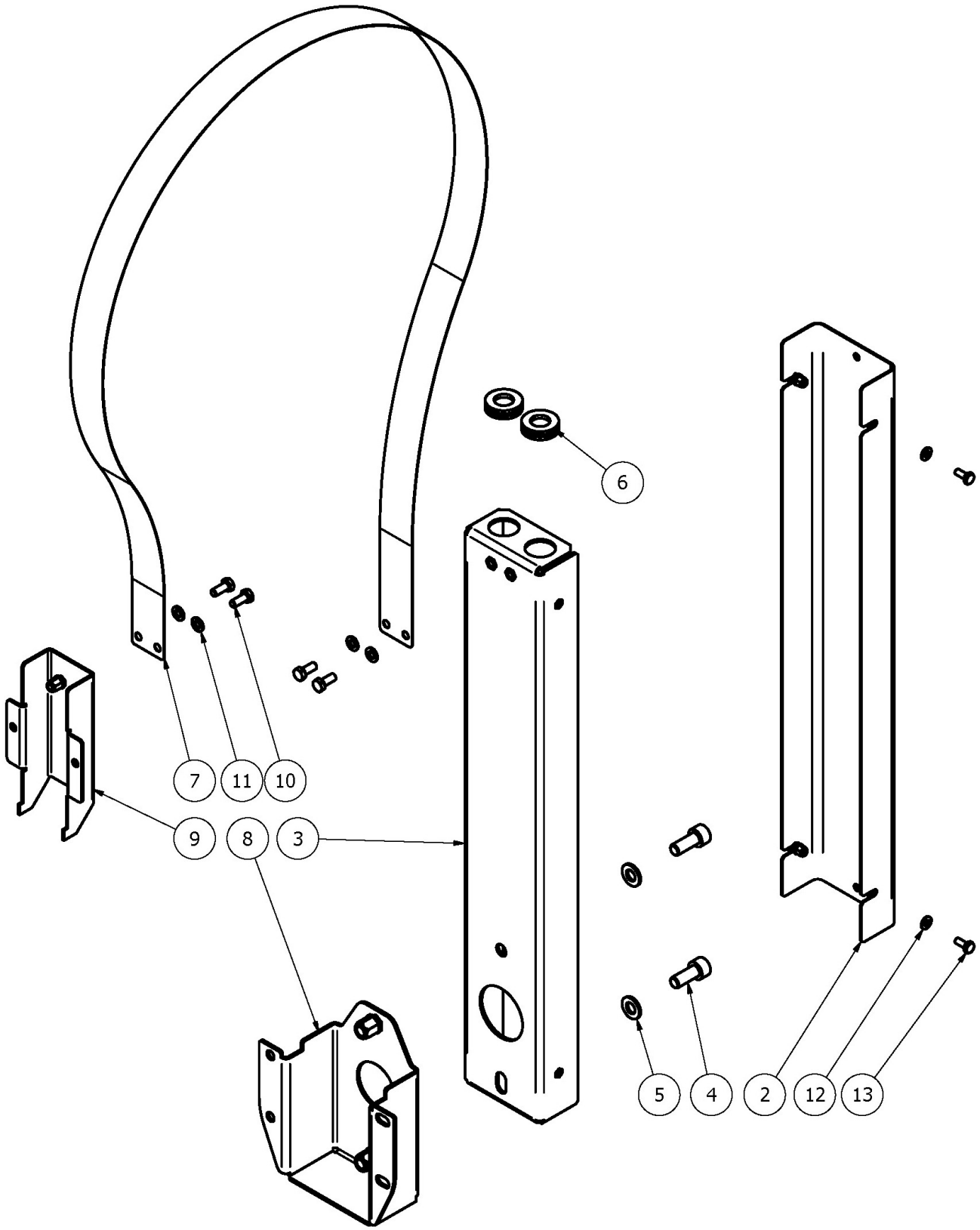


Figure 23050

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
1	1	78-0025-3715-3	Cable Track Assembly
2	1	78-8137-7853-3	COVER-HOUSING
3	1	78-0025-0934-3	HOUSING BODY ASSY
4	2	M8x20 SHCS	SCREW-M8X20 SHCS
5	2	M8 WSHR	WASHER-M8 PLAIN
6	2	78-8060-7758-8	GROMMET
7	1	78-0025-0928-5	TRACK-CABLE
8	1	78-0025-3716-1	CABLE TRACK BRACKET ASSY "A"
9	1	78-0025-3718-7	BRACKET-CABLE TRACK ASSY "B"
10	4	M5X12 HHCS	SCREW-M5X12 HHCS
11	4	M5 WSHR	WASHER-M5 PLAIN
12	4	M4 WSHR	WASHER-M4 PLAIN
13	4	M4X10 HHCS	SCREW-M4X10 HHCS

Figure 23050

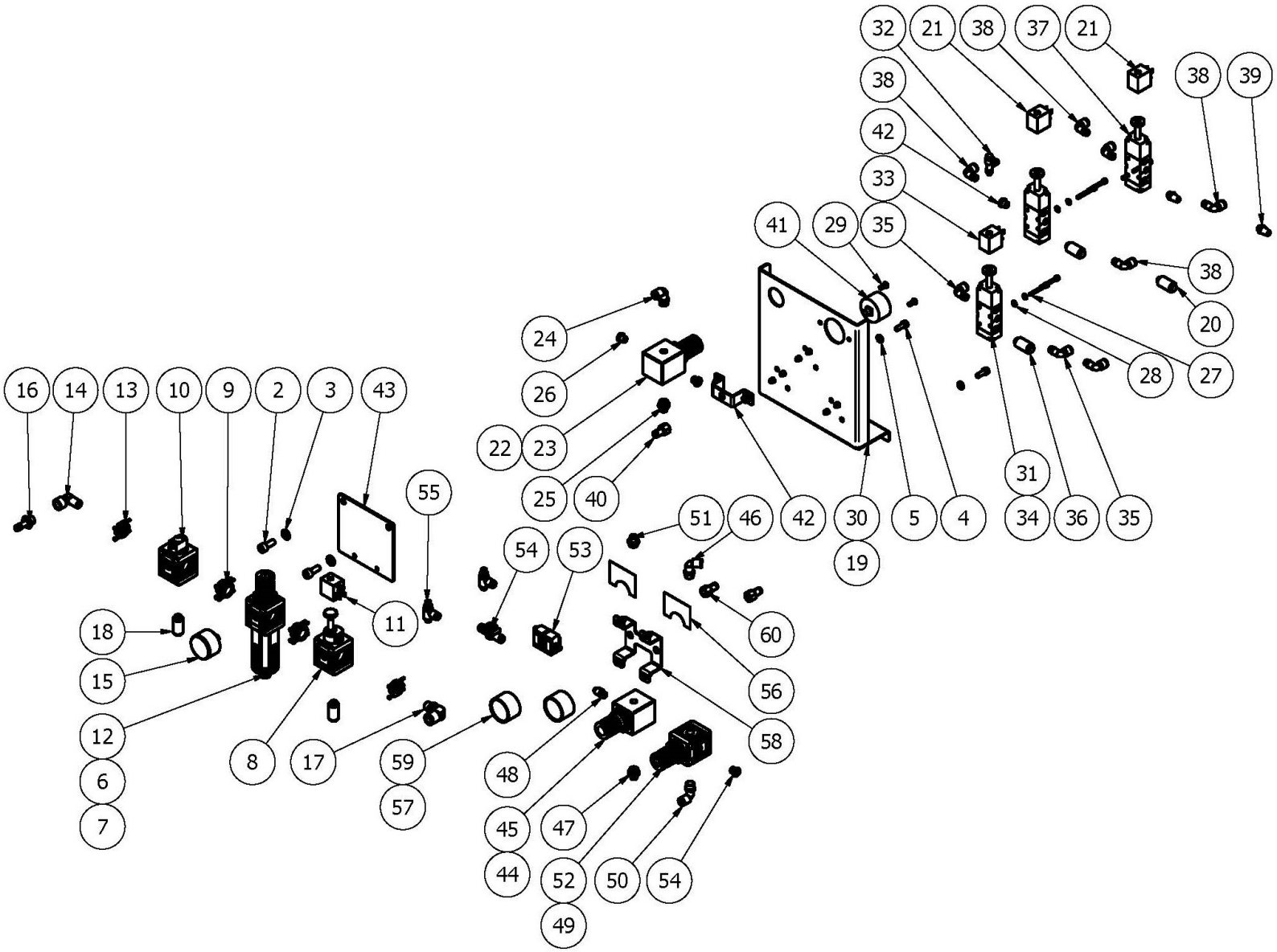


Figure 23051

8000r-8000r3

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
1	1	78-0025-3638-7	PNEUMATIC ASSEMBLIES
2	2	M8x20 SHCS	SCREW-M8X20 SHCS
3	2	M8 WSHR	WASHER-M8 PLAIN
4	2	M6X16 SHCS	SCREW-M6X16 SHCS
5	2	M6 WSHR	WASHER-M6 PLAIN
6	1	78-8137-7956-4	Air Supply
7	1	78-8137-8249-3	Air Pressure Assembly - 24VDC
8	1	78-8137-8252-7	Filter - Regulator FR SY1
9	2	78-8137-8251-9	COUPLER
10	1	78-8137-7957-2	Valve - Manual V3V SY1
11	1	78-8137-7701-4	Coil - 22 ø8 BA 2W-24VDC UR
12	1	78-8137-6395-6	Filter - Regulator FR SY1 20 08 RA
13	2	78-0025-0620-8	CONNECTOR
14	1	78-8060-7900-6	Union - RA022 1/4"-1/4"
15	1	78-8054-8838-0	Guage - Air (6236-15)
16	1	26-1005-6897-6	Hose Connector RA030 9-1/4"(6236-18) VC
17	1	78-8119-8615-3	MALE ELBOW G1/4-10 31991013 LEGRIS
18	2	78-8137-7704-8	SILENCER MWSPL-F 1/8
19	1	78-0025-3639-5	VALVE GROUP ASSEBMLY
20	2	78-8137-7704-8	SILENCER MWSPL-F 1/8
21	2	78-8137-7701-4	Coil - 22 ø8 BA 2W-24VDC UR
22	1	78-0025-3640-3	REGULATOR SY1 0-4 BAR ASSY
23	1	78-8137-6398-0	Regulator - SY1 1/4 04 PZ 1
24	1	78-8055-0756-9	Union Rotating MR41-6-14 (Elbow 1/4 x 6mm)
25	1	26-1005-6901-6	Fitting - DIR.M.CIL.31010613
26	5	78-8060-7690-3	Cap - B-1/8 Inch
27	6	M4X35 SHCS	SCREW-M4X35 SHCS
28	6	M4 WSHR	WASHER-M4 PLAIN
29	6	78-8094-6145-8	SCREW-M5X12 PHBHCS
30	1	78-0025-3644-5	SUPPORT ASSEMBLY
31	1	78-8137-7953-1	Valve - Solenoid
32	1	78-8137-7992-9	Regulator - Flow AS-FS AS1201FS-M5-04
33	1	78-8137-7701-4	Coil - 22 ø8 BA 2W-24VDC UR
34	1	78-8137-7700-6	Valve - SOV 25 SOS OO
35	3	78-8076-4890-8	Fitting - 90 Degree Elbow, 6mm
36	1	78-8137-7704-8	SILENCER MWSPL-F 1/8
37	2	78-8137-7700-6	Valve - SOV 25 SOS OO
38	5	78-8076-4890-8	Fitting - 90 Degree Elbow, 6mm
39	2	26-1005-6890-1	Muffler - Bronze 1/8"
40	1	78-8076-4672-0	Union - Straight, Female
41	1	78-8076-4671-2	Gauge - Pressure
42	1	78-8076-4535-9	BRACKET-GAUGE ASSY
43	1	78-8137-8401-0	BRACKET-MOUNTING REGULATOR GROUP
44	1	78-8137-7952-3	Regulator - Columns Cylinders
45	1	78-8137-6398-0	Regulator - SY1 1/4 04 PZ 1
46	1	78-8055-0756-9	Union Rotating MR41-6-14 (Elbow 1/4 x 6mm)
47	1	26-1005-6901-6	Fitting - DIR.M.CIL.31010613
48	1	78-8076-4888-2	KQL Male elbow - Inch-size One-touch Fittings Male elbow
49	1	78-8137-7954-9	Regulator - Centering Assembly
50	1	78-8055-0756-9	Union Rotating MR41-6-14 (Elbow 1/4 x 6mm)
51	1	26-1005-6901-6	Fitting - DIR.M.CIL.31010613
52	1	78-8137-7702-2	REGULATOR SY1 1/4 08
53	1	78-8137-8410-1	PRESSURE SWITCH SDE5-D10-FP-Q6-P-M8
54	1	78-8137-7951-5	Valve - Quick Exhaust
55	2	78-8137-7703-0	VALVLE-FLOW CONTROL
56	2	78-8137-8332-7	LABEL-REGULATOR
57	1	78-0025-3641-1	GUAGE CLUSTER ASSY
58	1	78-0025-3642-9	BRACKET-ASSY-GAUGE CLUSTER
59	2	78-8076-4671-2	Gauge - Pressure
60	2	78-8076-4672-0	Union - Straight, Female

Figure 23051

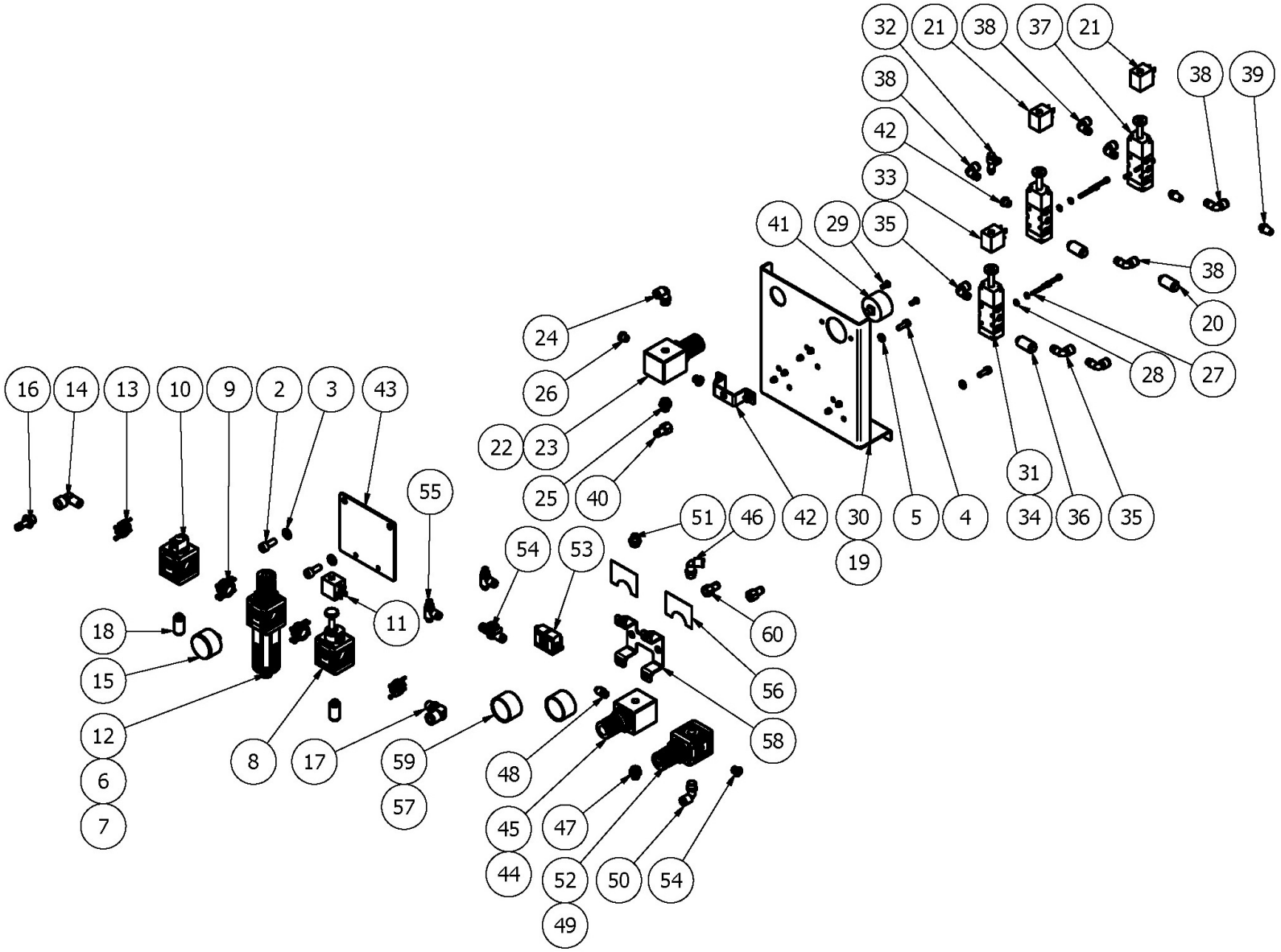


Figure 23052

8000r-8000r3

Bill of Materials			
ITM#	QTY	PART NUMBER	DESCRIPTION
1	1	78-0025-3638-7	PNEUMATIC ASSEMBLIES
2	2	M8x20 SHCS	SCREW-M8X20 SHCS
3	2	M8 WSHR	WASHER-M8 PLAIN
4	2	M6X16 SHCS	SCREW-M6X16 SHCS
5	2	M6 WSHR	WASHER-M6 PLAIN
6	1	78-8137-7956-4	Air Supply
7	1	78-8137-8249-3	Air Pressure Assembly - 24VDC
8	1	78-8137-8252-7	Filter - Regulator FR SY1
9	2	78-8137-8251-9	COUPLER
10	1	78-8137-7957-2	Valve - Manual V3V SY1
11	1	78-8137-7701-4	Coil - 22 ø8 BA 2W-24VDC UR
12	1	78-8137-6395-6	Filter - Regulator FR SY1 20 08 RA
13	2	78-0025-0620-8	CONNECTOR
14	1	78-8060-7900-6	Union - RA022 1/4"-1/4"
15	1	78-8054-8838-0	Guage - Air (6236-15)
16	1	26-1005-6897-6	Hose Connector RA030 9-1/4"(6236-18) VC
17	1	78-8119-8615-3	MALE ELBOW G1/4-10 31991013 LEGRIS
18	2	78-8137-7704-8	SILENCER MWSPL-F 1/8
19	1	78-0025-3639-5	VALVE GROUP ASSEBMLY
20	2	78-8137-7704-8	SILENCER MWSPL-F 1/8
21	2	78-8137-7701-4	Coil - 22 ø8 BA 2W-24VDC UR
22	1	78-0025-3640-3	REGULATOR SY1 0-4 BAR ASSY
23	1	78-8137-6398-0	Regulator - SY1 1/4 04 PZ 1
24	1	78-8055-0756-9	Union Rotating MR41-6-14 (Elbow 1/4 x 6mm)
25	1	26-1005-6901-6	Fitting - DIR.M.CIL.31010613
26	5	78-8060-7690-3	Cap - B-1/8 Inch
27	6	M4X35 SHCS	SCREW-M4X35 SHCS
28	6	M4 WSHR	WASHER-M4 PLAIN
29	6	78-8094-6145-8	SCREW-M5X12 PHBHCS
30	1	78-0025-3644-5	SUPPORT ASSEMBLY
31	1	78-8137-7953-1	Valve - Solenoid
32	1	78-8137-7992-9	Regulator - Flow AS-FS AS1201FS-M5-04
33	1	78-8137-7701-4	Coil - 22 ø8 BA 2W-24VDC UR
34	1	78-8137-7700-6	Valve - SOV 25 SOS OO
35	3	78-8076-4890-8	Fitting - 90 Degree Elbow, 6mm
36	1	78-8137-7704-8	SILENCER MWSPL-F 1/8
37	2	78-8137-7700-6	Valve - SOV 25 SOS OO
38	5	78-8076-4890-8	Fitting - 90 Degree Elbow, 6mm
39	2	26-1005-6890-1	Muffler - Bronze 1/8"
40	1	78-8076-4672-0	Union - Straight, Female
41	1	78-8076-4671-2	Gauge - Pressure
42	1	78-8076-4535-9	BRACKET-GAUGE ASSY
43	1	78-8137-8401-0	BRACKET-MOUNTING REGULATOR GROUP
44	1	78-8137-7952-3	Regulator - Columns Cylinders
45	1	78-8137-6398-0	Regulator - SY1 1/4 04 PZ 1
46	1	78-8055-0756-9	Union Rotating MR41-6-14 (Elbow 1/4 x 6mm)
47	1	26-1005-6901-6	Fitting - DIR.M.CIL.31010613
48	1	78-8076-4888-2	KQL Male elbow - Inch-size One-touch Fittings Male elbow
49	1	78-8137-7954-9	Regulator - Centering Assembly
50	1	78-8055-0756-9	Union Rotating MR41-6-14 (Elbow 1/4 x 6mm)
51	1	26-1005-6901-6	Fitting - DIR.M.CIL.31010613
52	1	78-8137-7702-2	REGULATOR SY1 1/4 08
53	1	78-8137-8410-1	PRESSURE SWITCH SDE5-D10-FP-Q6-P-M8
54	1	78-8137-7951-5	Valve - Quick Exhaust
55	2	78-8137-7703-0	VALVLE-FLOW CONTROL
56	2	78-8137-8332-7	LABEL-REGULATOR
57	1	78-0025-3641-1	GUAGE CLUSTER ASSY
58	1	78-0025-3642-9	BRACKET-ASSY-GAUGE CLUSTER
59	2	78-8076-4671-2	Gauge - Pressure
60	2	78-8076-4672-0	Union - Straight, Female

Figure 23052