

Instructions Manual

3M-Matic™ 8000ab-8000ab3

Type 22600

Adjustable Case Sealer

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.



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™ 8000ab-8000ab3 Adjustable case sealer.

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

Edition June 2026

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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 8000ab-8000ab3 - Type 22600 - Serial Number 13282).

To order replacement parts, contact us:

CSPD division of Combi Packaging Systems LLC.

6299 Dressler Rd. NW

North Canton, OH 44720

store.combi.com/CSPD/PublicStore/

1-800-344-9883 Fax: 1-877-847-5883

e-mail: CSPD-CSR@combi.com

www.combi.com

Identification Plate

	3M Company - St. Paul MN 55144 USA 3M - Matic™		Conforms to / Conforme UL STD 963/ Certified to / Certifié CSA STD C22.2 No. 68 Indoor industrial use only / Usage intérieur industriel seulement		Control No. / Numéro de contrôle 4000563  Intertek	
	Model / Modèle	Part Number / Numéro de pièce	VAC / V.c.a.	Hertz	Ampère	Compressed Air/Air Comprimé
Type	Serial Number/Numero de série	Yr/Année	Phase	Watts	Volume	

Minimum billing on replacement part orders will be \$50.00

Replacement part informationa and pricing availabel on request

There is a 15% restocking fee (per order) on returned parts

Note: Outside of the United States, for replacement parts and ordering
information please contact your local /regional 3M or 3M representative.

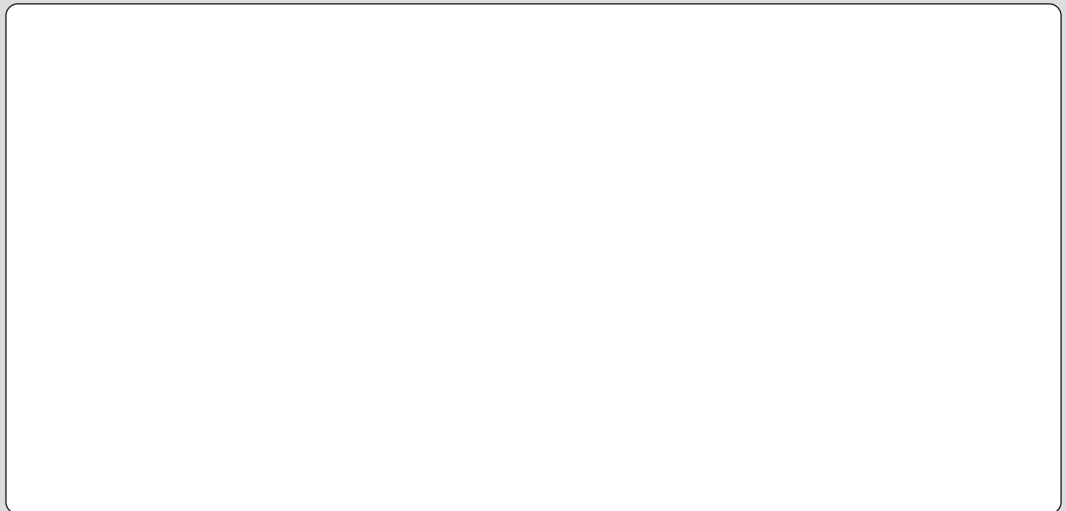
Replacement parts and service information

To Our Customers:

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

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

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



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

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8000ab-8000ab3 Adjustable Case Sealer

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Taping Head Information (See applicable taping head manual)

Abbreviations and Acronyms

List of Abbreviations/Acronyms

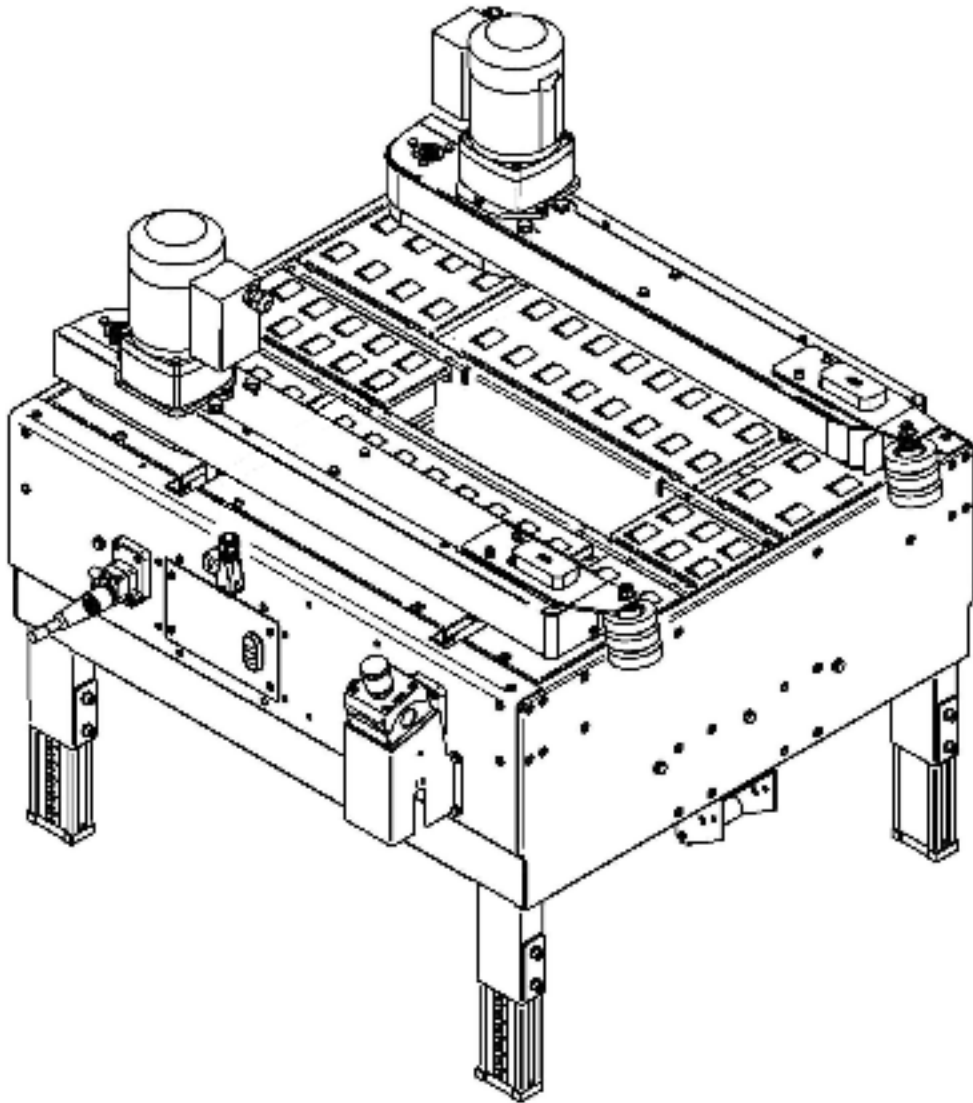
3M-Matic	Trademark of 3M St. Paul, MN 55144-1000
AccuGlide	Trademark of 3M St. Paul, MN 55144-1000
Scotch	Trademark of 3M St. Paul, MN 55144-1000
Drw.	Drawing
Ex.	For Example
Fig.	Exploded View Figure no. (spare parts)
Figure	Illustration
Max.	Maximum
Min.	Minimum
Nr.	Number
N/A.	Not Applicable
OFF.	Machine Not Operating
ON	Machine Operating
PLC.	Programmable Logic Control
PP	Polypropylene
PU/PU Foam	Polyurethane Foam
PTFE.	Polytetrafluorethelene
PVC.	Poly-vinyl chloride
W	Width
H	Height
L	Length

1. Introduction

1.1 Manufacturing Specifications / Description / Intended Use

The 3M-Matic™ 8000ab-8000ab3 Adjustable Case Sealer 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 8000ab-8000ab3 is manually adjustable to a wide range of box sizes (see “Specifications Section – Box Weight and Size Capacities”).

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



3M-Matic™ 8000ab-8000ab3 Adjustable Case Sealer, Type 22600

1. Introduction *(continued)*

1.2 How to Read and Use the Instruction Manual

This instruction manual covers safety aspects, handling and transport, storage, unpacking, preparation, installation, operation, set-up and adjustments, technical and manufacturing specifications, maintenance, troubleshooting, repair work and servicing, electric diagrams, warranty information, disposal (ELV), a definition of symbols, plus a parts list of the 3M-Matic™ 8000ab-8000ab3 Adjustable 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.

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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.

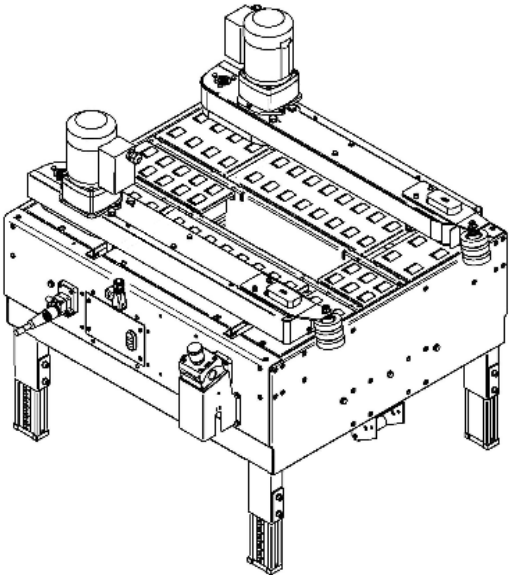
2. General Information

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 3M - Matic™		Conforms to / Conforme UL STD 963/ Certified to / Certifié CSA STD C22.2 No. 68 Indoor industrial use only / Usage intérieur industriel seulement		Control No. / Número de control 4000563	
					Intertek	
Model / Modèle	Part Number / Numéro de pièce	VAC / V.c.a.	Hertz	Ampère	Compressed Air/Air Comprimé	
Type	Serial Number/Numero de série	Yr/Année	Phase	Watts	Volume	

2.2 Data for Technical Assistance and Service

Agent/Distributor or
Local After Sale Service:

2. General Information *(continued)*

2.3 Warranty

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

3M sells its **3M-Matic™ 8000ab-8000ab3 Adjustable Case Sealer, Type 22600** 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: 8000ab-8000ab3 Adjustable Case Sealer

- (1) 8000ab-8000ab3 Adjustable Case Sealer, Type 22600
- (1) Tool and Spare Parts Kit
- (1) Instruction and Parts Manual

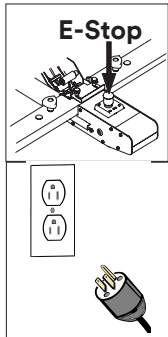
3. Safety

3.1 General Safety Information

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



Figure 3-1



The machine is provided with a LATCHING EMERGENCY STOP BUTTON (Figure 3-1); when this button is pressed, it stops the machine at any point in the working cycle. Maintain clear access to power cord while machine is operating.

Disconnect plug from power source before machine maintenance (Figure 3-1). Also disconnect air if the machine has a pneumatic system.

Keep this manual in a handy place near the machine. This manual contains information that will help you to maintain the machine in a good and safe working condition.

3.2 Explanation of Signal Word and Possible Consequences



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



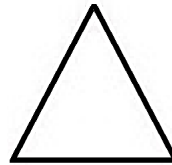
Caution

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

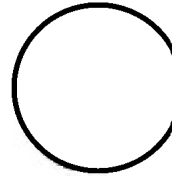


Warning

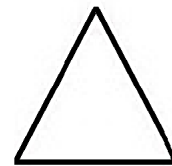
Indicates a potentially hazardous situation, which, if not avoided, could result in death or serious injury and/or property damage.



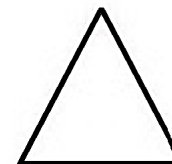
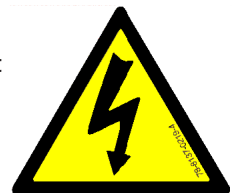
Caution
Prohibition



Information



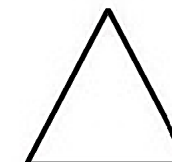
Electrical Supply Disconnect before work or servicing machine



Warning!
Sharp knife



Emergency Stop
(Latching)



Physical Earth connection



3. Safety (continued)

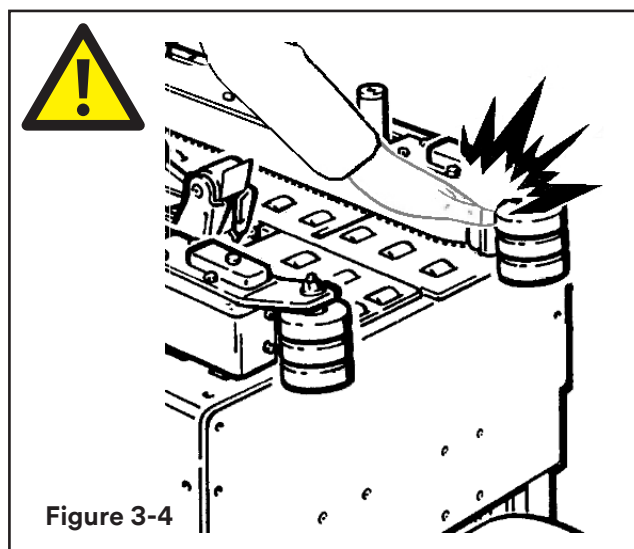
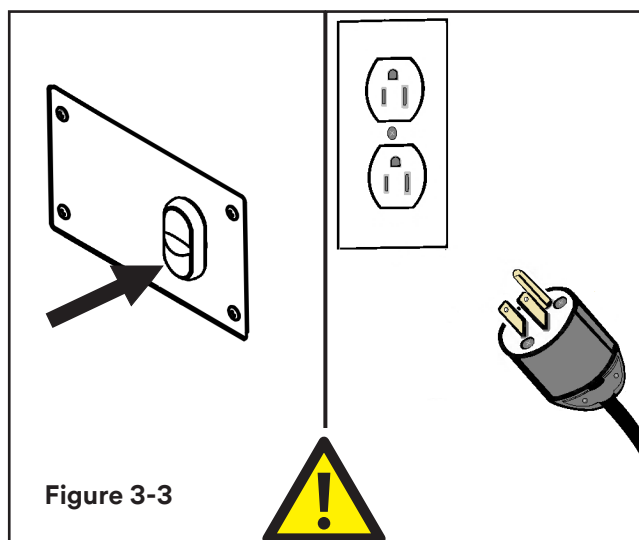
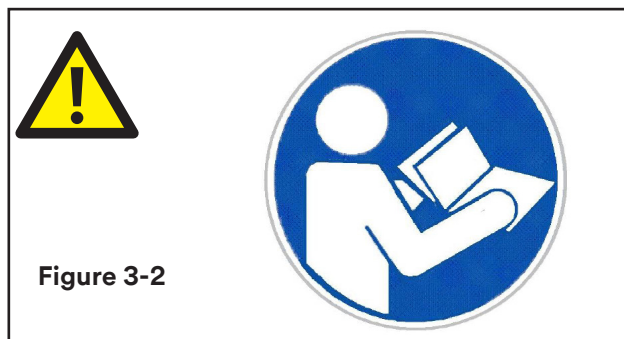
3.3 Table of Warnings

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

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

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

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



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

3. Safety (continued)



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 the taping unit. Blades are extremely sharp. Any error may cause serious injuries (Figure 3-5).



Warning

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



Warning

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



Caution

- To reduce the risk associated with pinch and entanglement hazards:
 - 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.

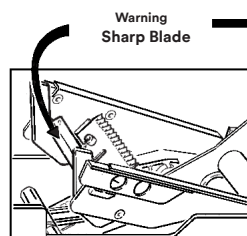


Figure 3-5

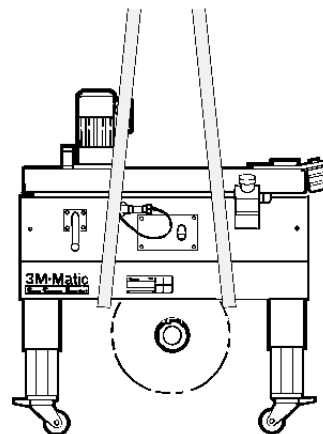


Figure 3-6

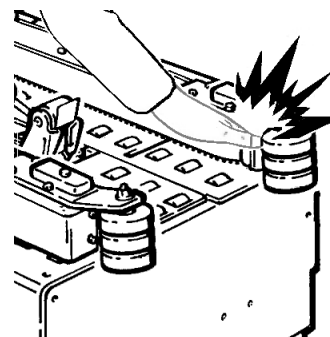


Figure 3-7

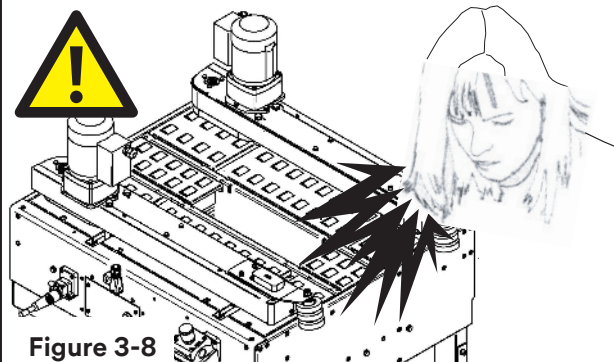


Figure 3-8

3. Safety *(continued)*

3.4 Operator's Qualifications

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

3.5 Number of Operators

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

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

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

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

3.7 Residual Hazards

The case sealer 8000ab-8000ab3 incorporates various safety protections which should never be removed or disabled. It is essential that the operator and service personnel be warned that hazards exist which cannot be eliminated:

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

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

3.9 Personal Safety Measures

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

3.10 Predictable Actions which are Incorrect and Not Allowed

- Never try to stop/hold the box while being driven by the belts.
- Never remove or disable the safety devices.
- Only authorized personnel should be allowed to carry out the adjustments, repairs or maintenance which require operation with reduced safety protections.
During such operations, access to the machine must be restricted. When the work is finished, the safety protections must immediately be reactivated.
- The cleaning and maintenance operations must be performed after disconnecting the electric power.
- Do not modify the machine or any part of it.
- Clean the machine using only dry cloths or light detergents. Do not use solvents, petrols, etc.
- Install the machine following the suggested layouts and drawings.



Warning

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

3. Safety *(continued)*

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

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

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

Skill 1: Machine Operator

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

Skill 2: Mechanical Maintenance Technician

This operator is trained to use the machine as the MACHINE OPERATOR and in addition is able to:

- Work with the safety protection disconnected
- Check and adjust mechanical parts
- Carry out machine maintenance operations/repairs

He is not allowed to work on live electrical components

Skill 2a: Electrical Maintenance Technician

This operator is trained to use the machine as the MACHINE OPERATOR and in addition is able to:

- Work with the safety protection disconnected
- Check and adjust mechanical parts
- Carry out machine maintenance operations / repairs / adjustments / repair electrical components

He is allowed to work on live electrical panels, connector blocks, control equipment, etc.

Skill 3: Specialist from the Manufacturer

Skilled operator sent by the manufacturer or its agent to perform complex repairs or modifications (on agreement with the customer).

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

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

3. Safety *(continued)*

3.12 Component Locations

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

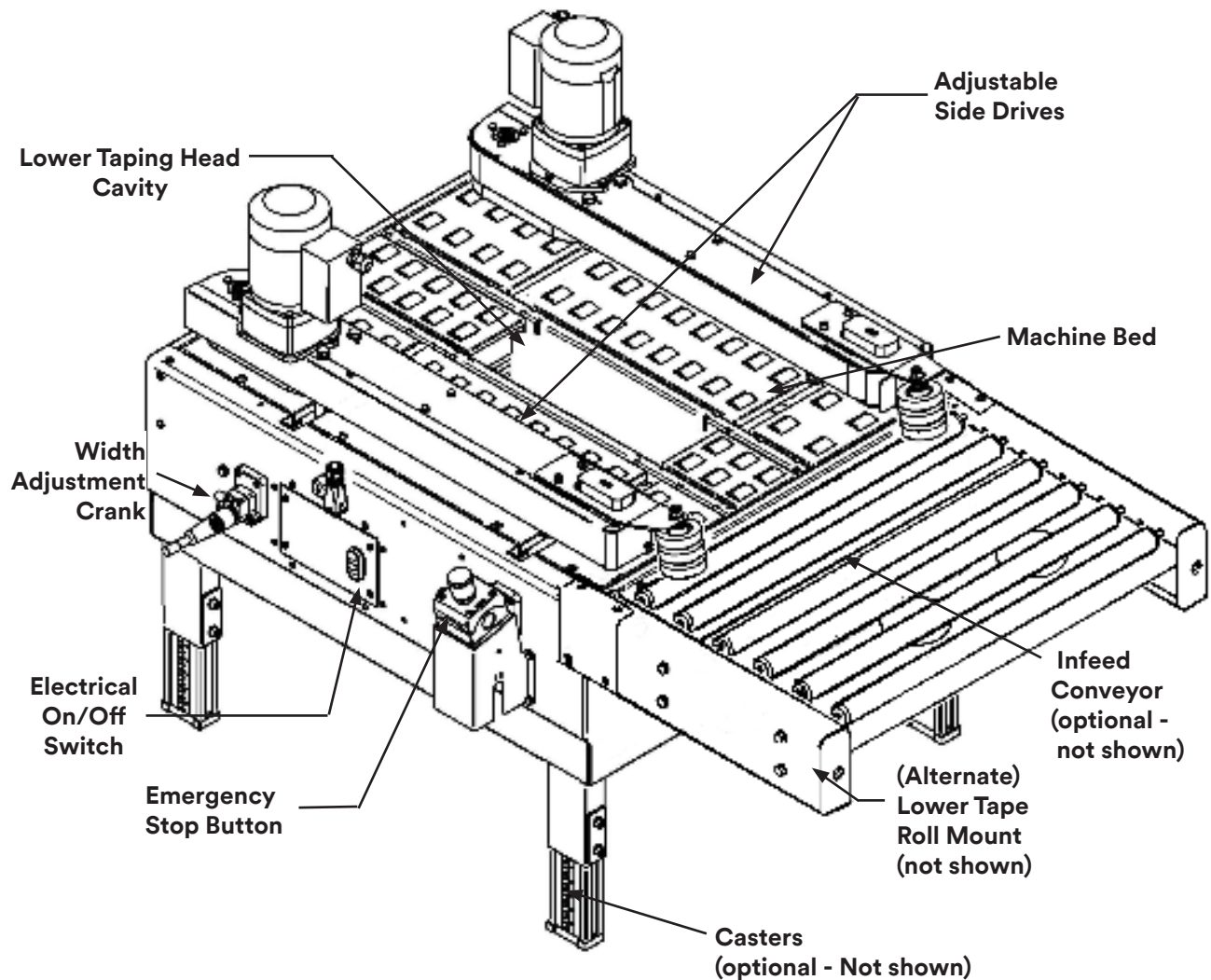


Figure 3-9 8000ab-8000ab3 Case Sealer Components (Left Front View)

3. Safety (continued)

3.13 Table of Warnings and Replacements Labels (continued)

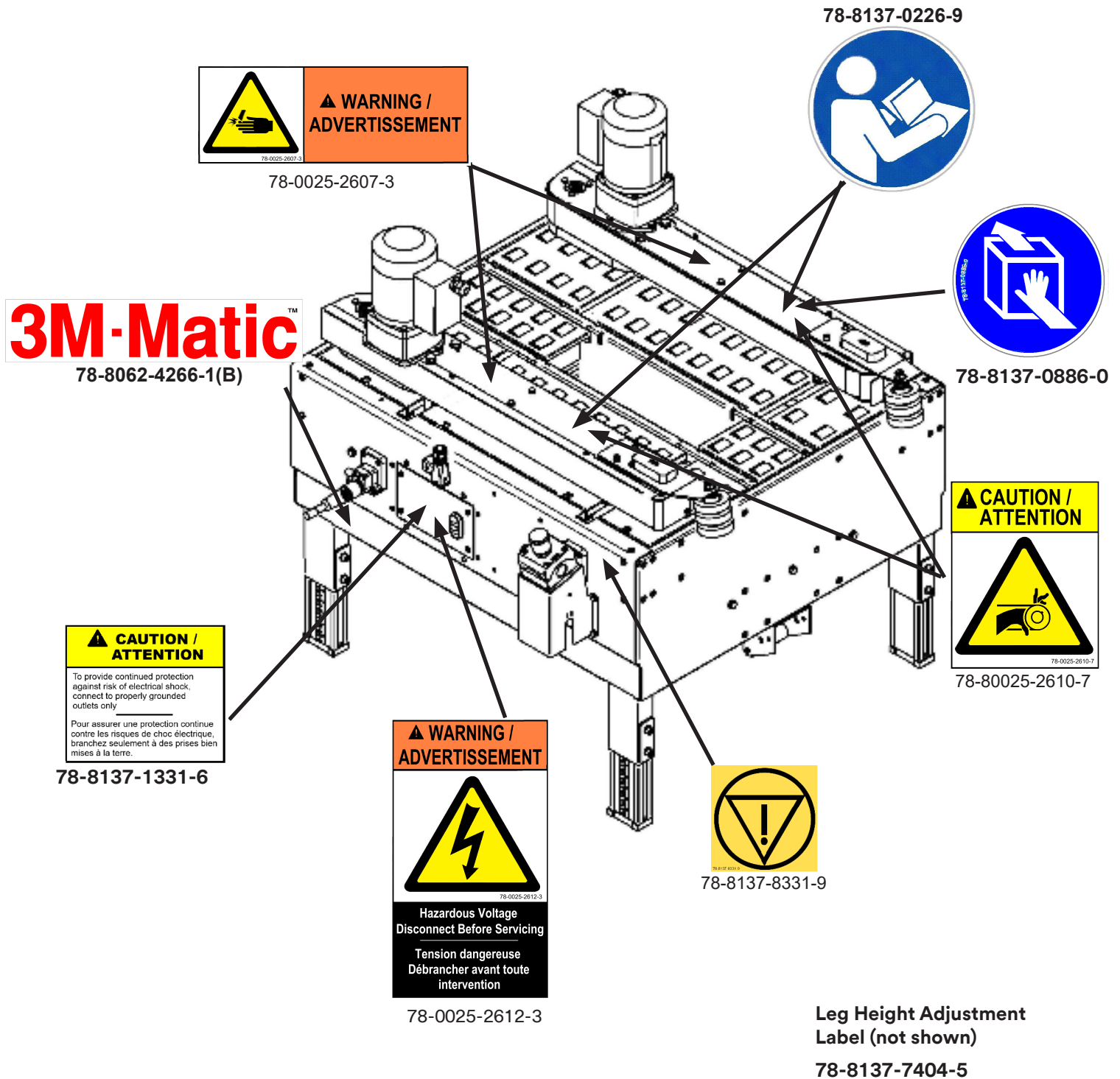


Figure 3-10 Replacement Labels / 3M Part Numbers

4. Specifications

4.1 Power Requirements:

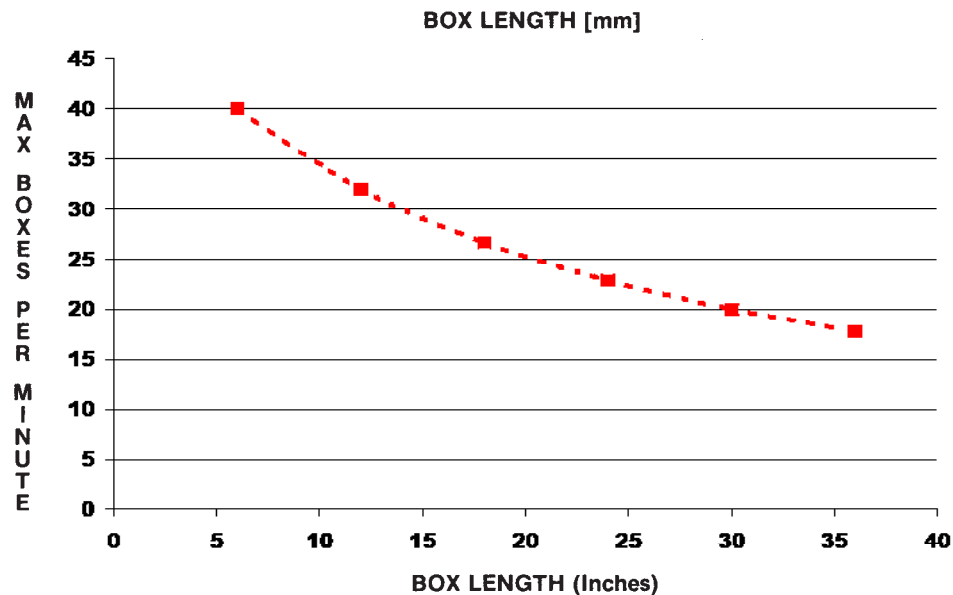
Electrical – 115 VAC, 60 Hz, 6.4 A , 1/4 hp (720 watts)

The machine is equipped with two 1/6 HP gearmotors and comes with a 2.4m [8 foot] standard neoprene covered power cord and a grounded plug.

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

4.2 Operating Rate: Belt speed is 0.5m/s [100 F.P.M.]

BOXES PER MINUTE VS. BOX LENGTH



Actual production rate is dependent on operator's dexterity.

Boxes must be 18 inches (457mm) apart minimum.

4.3 Operating Conditions

Use in dry, relatively clean environments at 5° C to 50° C [40° F to 120° F] with clean, dry boxes.

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



Warning

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

4.4 Machine Noise Level:

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

4. Specifications *(continued)*

4.5 Set-Up Recommendations:

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

4.6 Tape

Scotch® pressure-sensitive film box sealing tapes.

4.7 Tape Width

50.8 mm [2 inch] minimum to 76.2 mm [3 inch] maximum

4.8 Tape Roll Diameter

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

4.9 Tape Application Leg Length – Standard

70mm ± 6mm [2.75 inch ± 0.25 inch]

Tape Application Leg Length – Optional

50mm ± 6mm [2 inch ± 0.25 inch]

(See “Removing Taping Heads Procedure – Changing the Tape Leg Length”)

4.10 Box Board

Style – regular slotted containers – RSC

125 to 275 P.S.I. bursting test, single wall or double wall B or C flute.

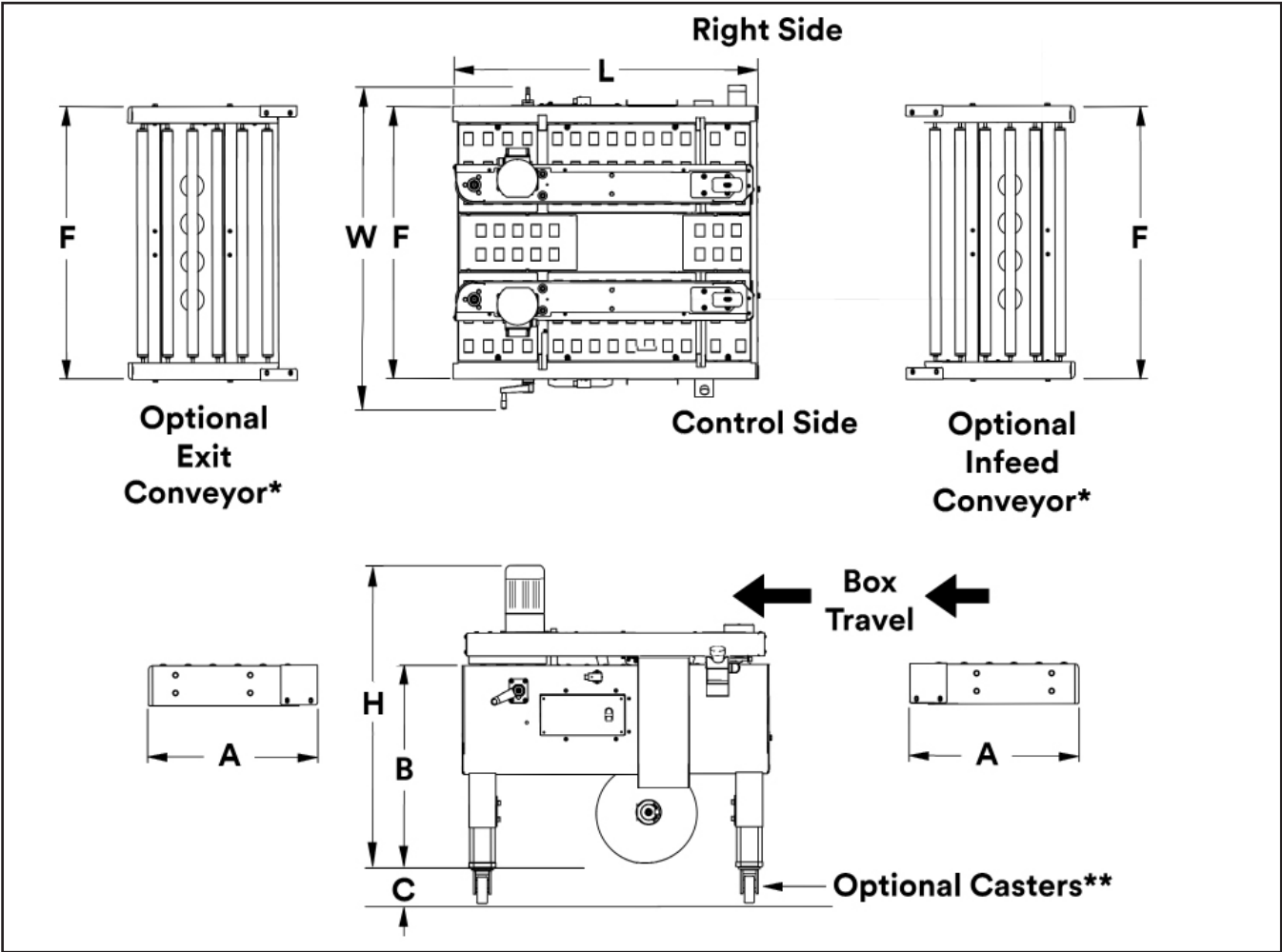
23-44 lbs. per inch of width Edge Crush Test (ECT)

4.11 Box Weight and Size Capacities

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

	Length	Width
Minimum	6" [152]	3.63" [92]
Máximo		21.5" [546]

4. Specifications (continued)



4.12 Machine Dimensions

	W	L	H	A*	B	C**	F
Minimum							
mm	980	920	990	460*	610	105**	826
[Inches]	[38.5]	[36.25]	[39]	[18]	[24]*	[4.19]	[32.5]
Maximum							
mm			1220		890		
[Inches]	--	--	[48]	--	[35]*	--	--

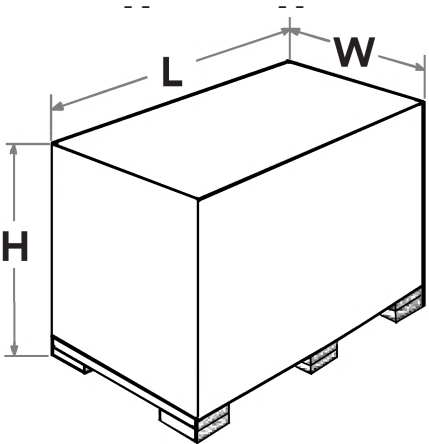
- * Infeed/Exit conveyors are optional
- ** Casters and Conveyors are optional

Packaged Machine Dimensions:

Height (H) - 49.5" [1257]
Length (L) - 51" [1295]
Width (W) - 42" [1067]

Weight:

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



5. Shipment-Handling-Storage-Transport

5.1 Shipment and Handling of Packed Machine

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

Packaging Overall Dimensions (Figure 5-1)

See Specifications.

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

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

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

5.3 Handling and Transportation of Uncrated Machine

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

5.4 Storage of the Packed or Unpacked Machine

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

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

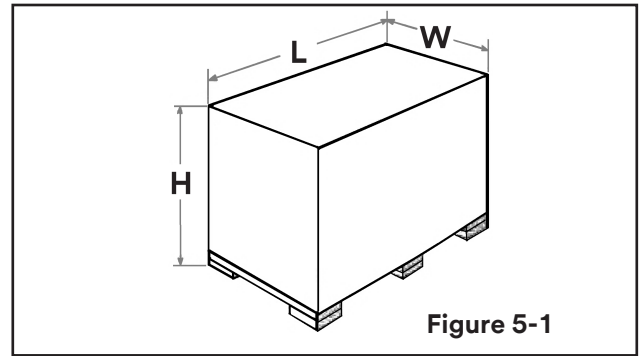


Figure 5-1

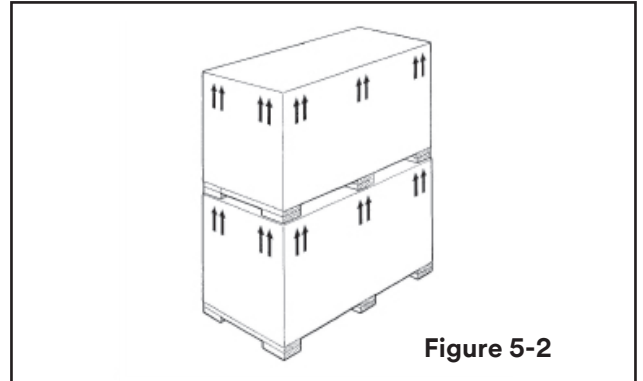


Figure 5-2

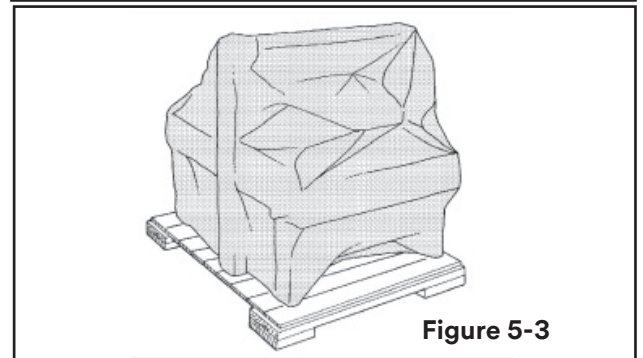


Figure 5-3

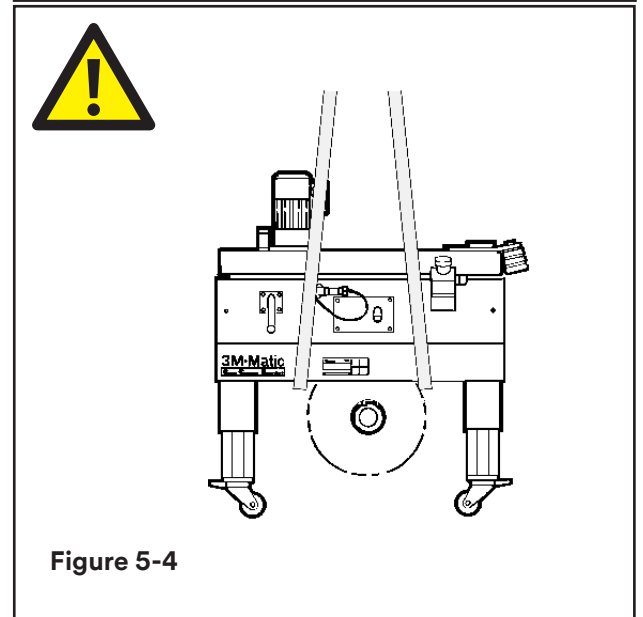


Figure 5-4

6. Unpacking

6.1 Uncrating

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

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

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

Removal of Pallet

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

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

6.2 Disposal of Packaging Materials

The 8000ab-8000ab3 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.

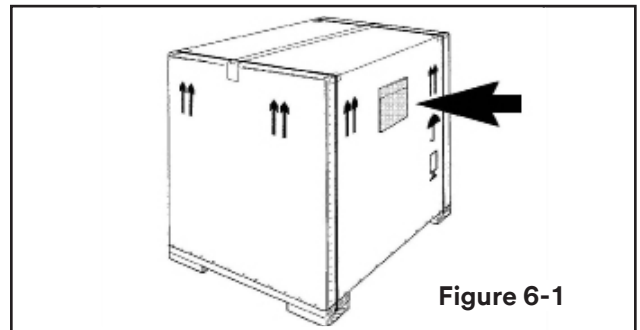


Figure 6-1

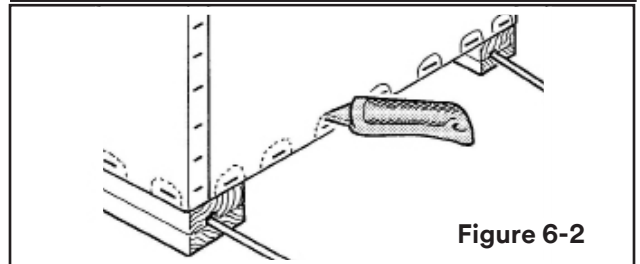


Figure 6-2

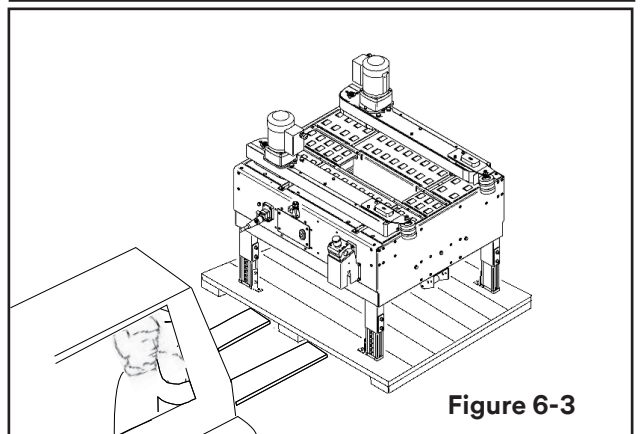


Figure 6-3

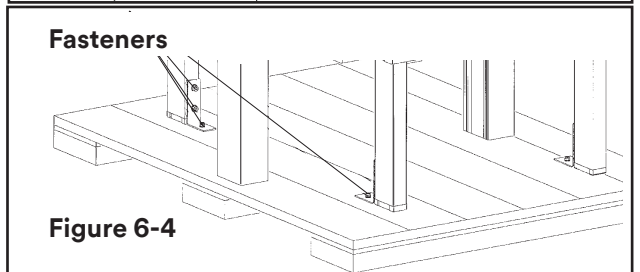


Figure 6-4

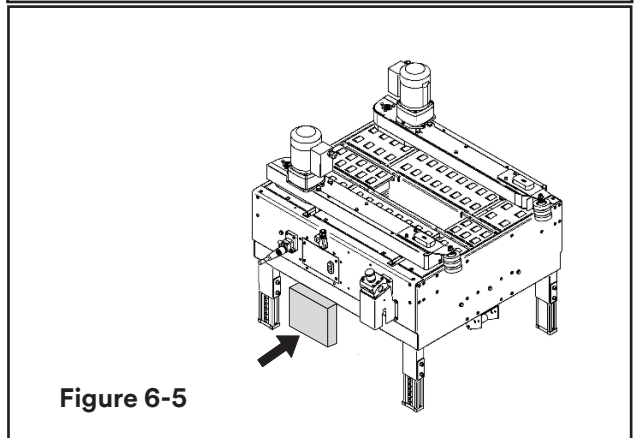


Figure 6-5

7. Installation

7.1 Operating Conditions

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

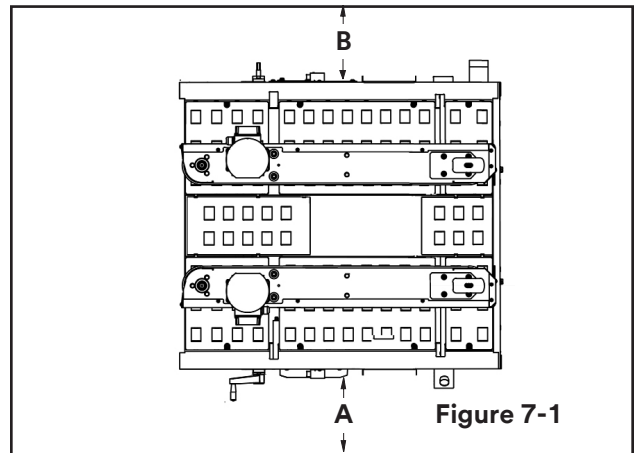
7.2 Space Requirements for Machine Operation and Maintenance Work

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 Set-Up / Bed Height

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

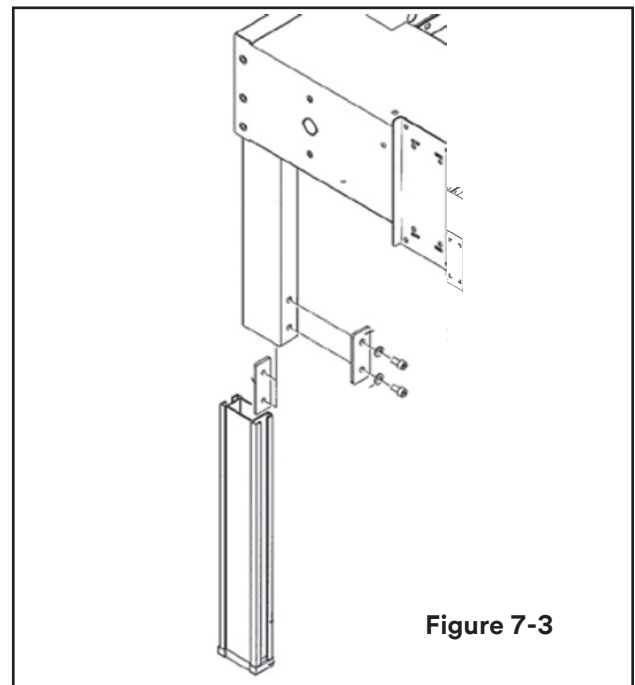
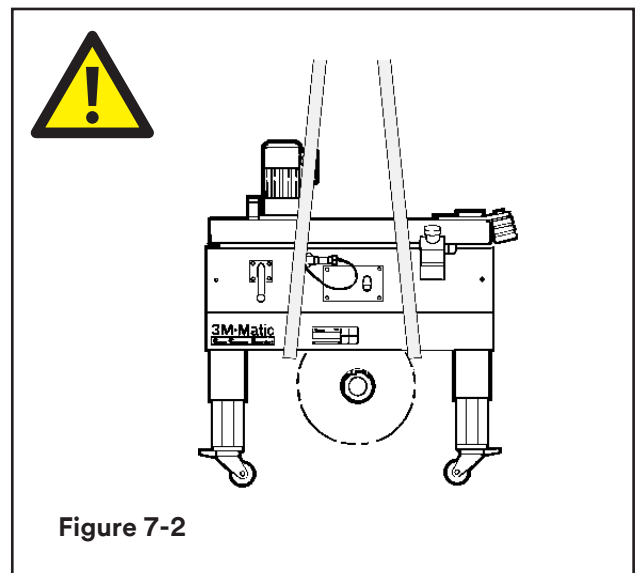
To set the machine bed height, do the following:

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

Also refer to "Specifications"

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

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

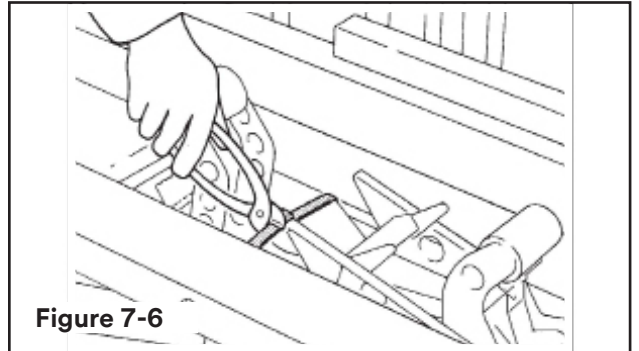
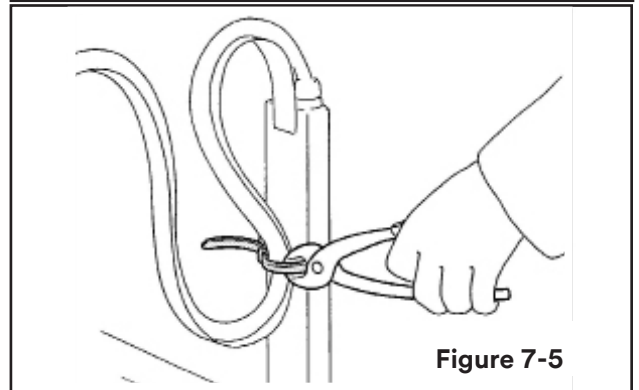
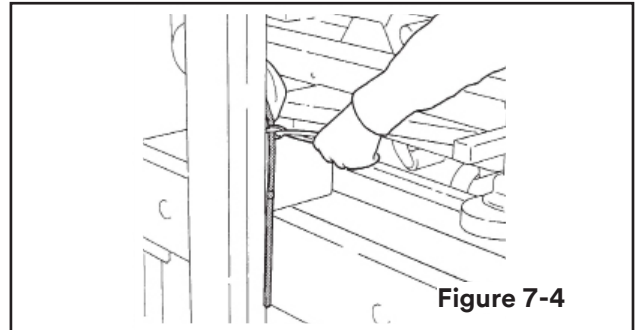


7. Installation *(continued)*

7.5 Removal of Plastic Ties

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

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



7. Installation *(continued)*

7.7 Completion of Taping Heads

See Manual 2 or 3 for Complete Instructions:

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

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

7.8 Outboard Tape Roll Holder

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

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

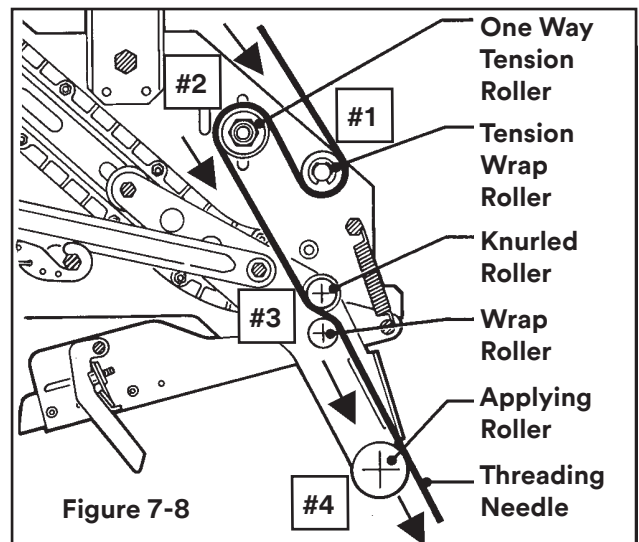


Figure 7-8

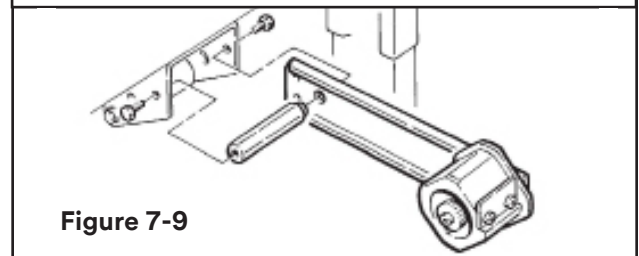


Figure 7-9

7.9 Preliminary Electric Inspection

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

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

7.10 Machine Connection to the Mains

For technical specifications:

See Section 4 - Specifications

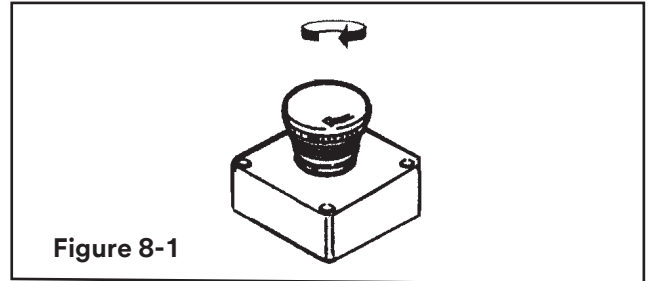
- Push the LATCHING EMERGENCY STOP BUTTON.
- The main switch turned OFF (O).

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

8. Theory of Operation

8.1 Description of the Working Cycle

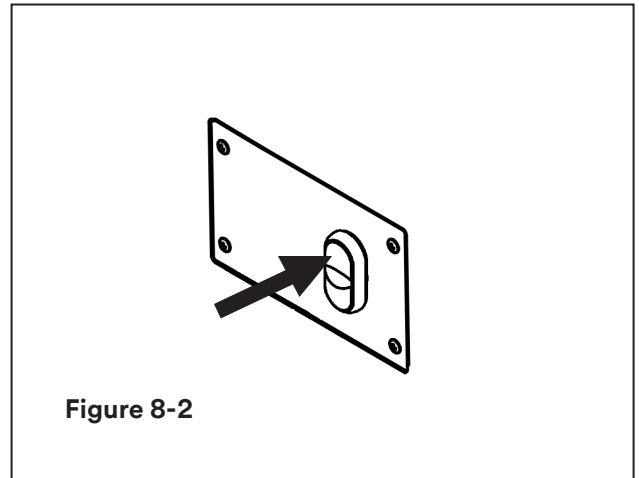
After having closed the top flaps of the carton, the operator pushes it under the top infeed end in order to avoid the opening of the top flaps. Further pushing causes the two top and bottom belts to drive the box through the taping heads which automatically seal the top and bottom seams. The carton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



8.2 Definition of Running Mode

The case sealer 8000ab-8000ab3 has only one (automatic) operating mode with:

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

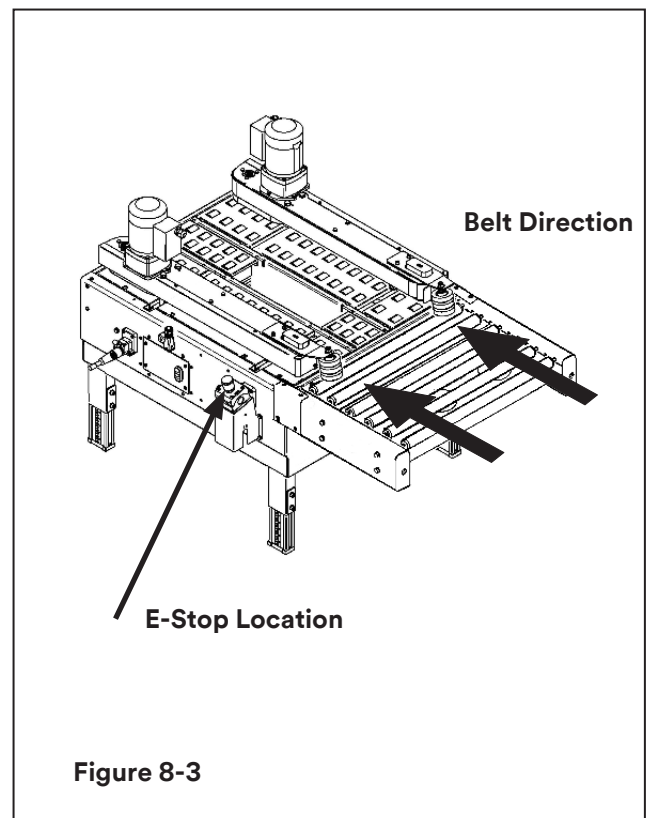


8.3.1 Normal Stop Procedure

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

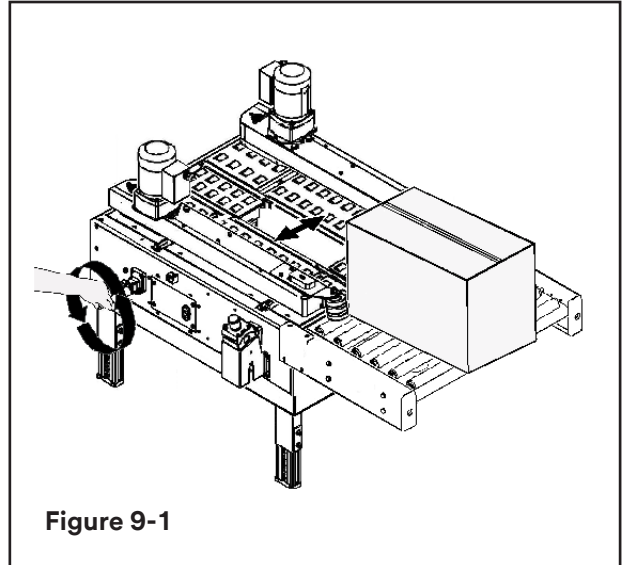
8.3.2 Emergency Stop

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

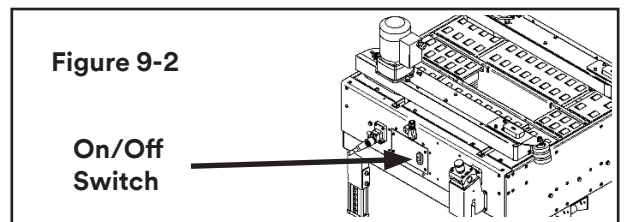


9. Controls

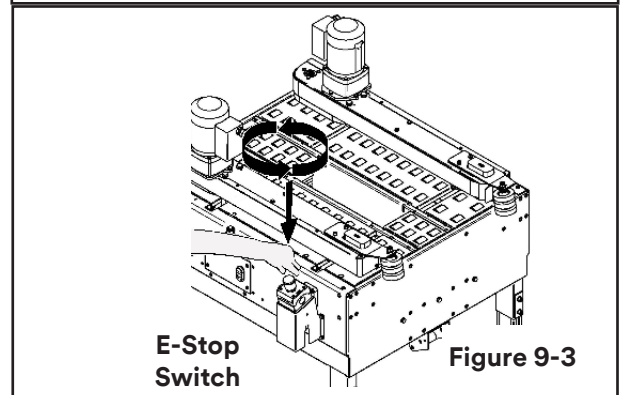
9.1 Box Width Adjusting Knobs



9.2 On/Off Switch



9.3 Latching Emergency Stop Button



10. Safety Devices of the Machine

10.1 Blade Guards

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

10.2 Emergency Stop Button

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

The machine electrical supply can be turned off by pressing the latching emergency stop switch.

To restart machine, rotate the emergency stop switch clockwise to release the switch latch (Figure 10-1).

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

10.3 Electric System / Circuit Breaker

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

Circuit Breaker

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

1. Determine cause of overload and correct.
2. Plug in machine.
3. Turn machine switch "On" (I) to resume case sealing

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

- Have wire size 1.5mm dia. [AWG 16]
- Have a max. length 30.5m [100 ft]
- Be properly grounded.

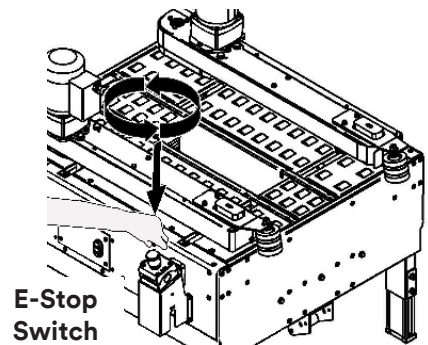


Figure 10-1

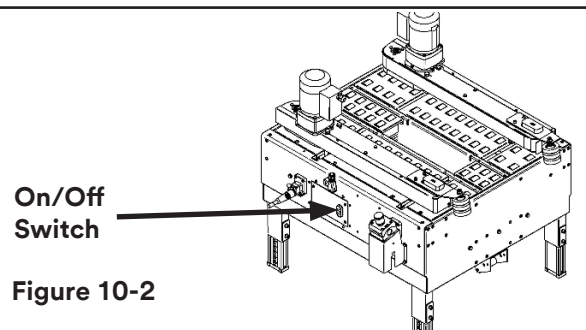


Figure 10-2



Warning

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



Warning

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



Warning

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

11. Set-Up and Adjustments

11.1 Box Width Adjustment

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

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

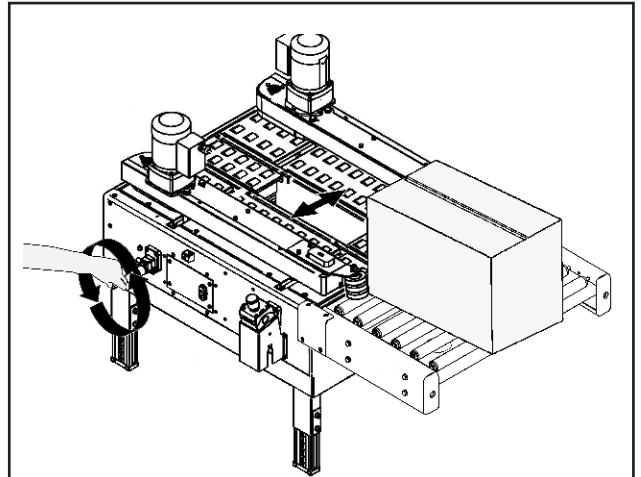


Figure 11-1

11.2 Changing the Tape Leg Length

Refer to applicable taping head manual for related set-up procedure.

12. Operation

12.1 Operator's Correct Working Position and Operational Flow (Figure 12-1).

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

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

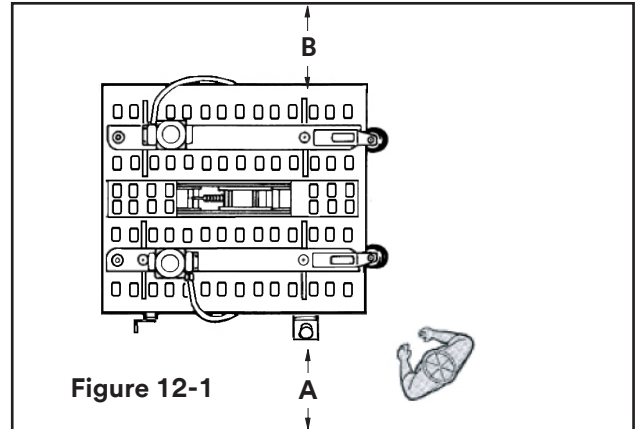


Figure 12-1

12.2 Starting the Machine

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

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

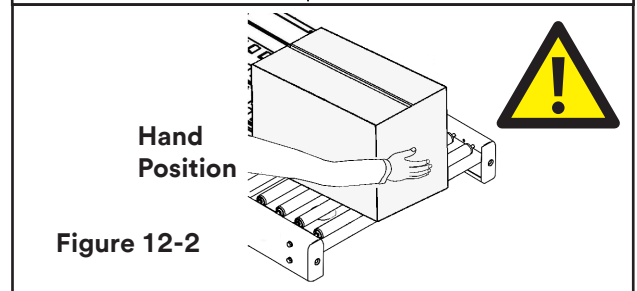


Figure 12-2

12.3 Starting Production

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

12.4 Tape Replacement and Threading

Skill 1 - Operator

Refer to applicable taping head manual for related set-up procedure.

Press the LATCHING EMERGENCY STOP BUTTON.

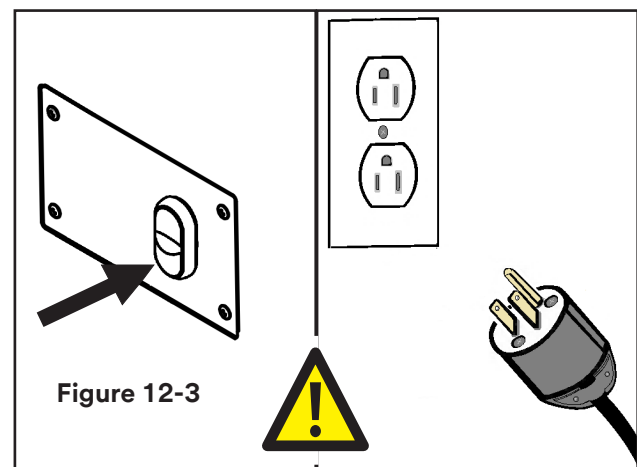


Figure 12-3

12.5 Box Size Adjustment

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

12.6 Cleaning

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

12.7 Table of Operation Adjustments - Operator Qualifications

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

12.8 Safety Devices Inspection

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

12. Operation *(continued)*

12.9 Trouble Shooting Guide

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

(continued on next page)

12. Operation *(continued)*

12.9 Trouble Shooting Guide *(continued)*

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

12. Operation *(continued)*

12.10 Operation Warnings



Warning

1. Turn electrical and air supply off and disconnect before servicing taping heads or performing any adjustments or maintenance on the machine. Turn electrical and air supplies off when machine is not in use.
2. Do not leave machine running unattended.
3. Before turning drive belts on, be sure no tools or other objects are on the machine bed.
4. Keep hands and loose clothing away from moving belts.
5. Never attempt to remove jammed boxes from the machine while machine is running.
6. Do not attempt to override safety devices.
7. Keep hands and clothing away from taping heads when machine is running. A box traveling through the machine causes taping head rollers to retract when box enters and extend as box leaves taping head.
8. The taping heads utilize extremely sharp tape cut-off knives. The Blade is located under the orange Blade guard which has the "Warning – SHARP BLADE" label. Before loading tape, refer to to identify the Blade location. Keep hands out of these areas except as necessary to service the taping heads.
9. To provide continued protection against risk of electric shock, connect to properly grounded outlets only.
10. Failure to comply with these Warnings could result in severe personal injury and/or equipment damage.

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 Manual 2 or 3
Drive belt replacement	when worn	2	13.10

13.4 Inspections to be Performed Before and after every Maintenance Operation

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

13.5 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 (Refer to appropriate taping 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 *(continued)*

13.8 Box Drive Belt Replacement

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

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

(continued on next page)



Warning

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



Warning

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

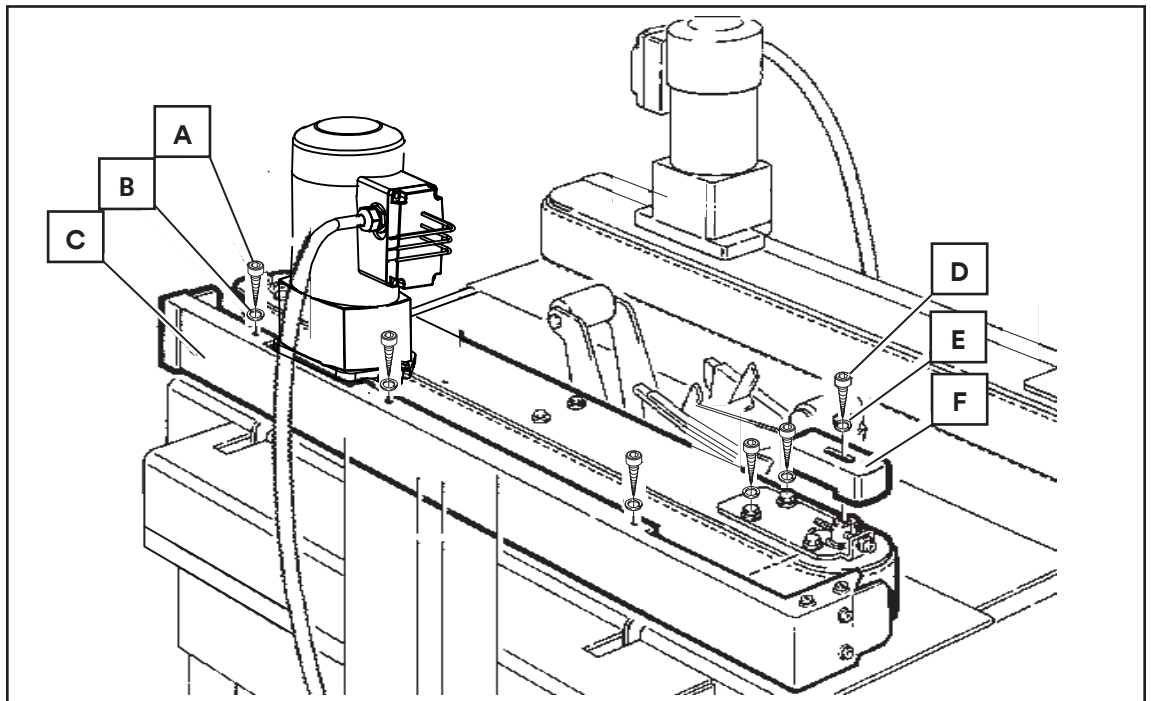


Figure 13-1 Box Drive Belt (Left Side View – Infeed End)

13. Maintenance and Repairs *(continued)*

6. Install the new belt around drive rollers and insert new pin. Pin must not extend beyond edge of belt.
7. To set drive belt tension, turn adjustment screws (G) equally on both the upper and lower tension assemblies. Turn the screws clockwise to increase tension or counterclockwise to decrease tension - See Figure 13-2.

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

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

13.9 Box Drive Pulley Rings

Before installing a new belt, check the orange plastic drive pulley rings for wear. If torn, broken, or worn smooth, replace the rings (Figure 13-3).

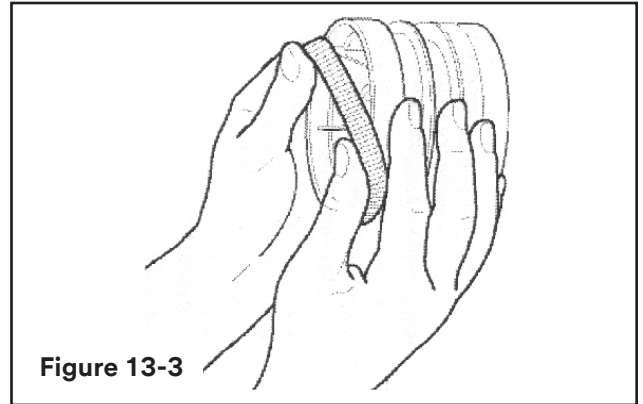


Figure 13-3



Warning

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

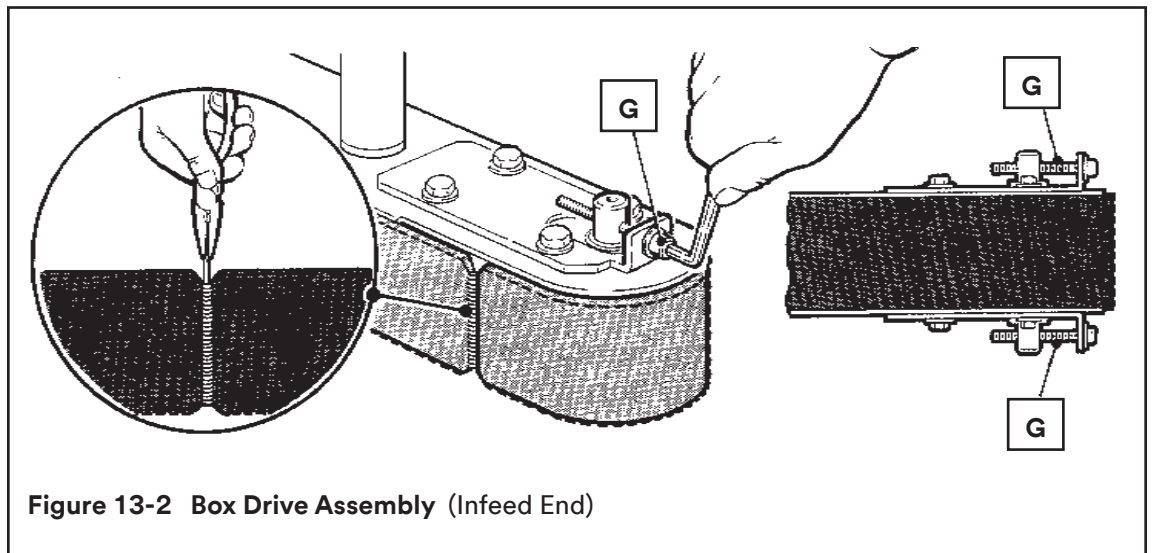
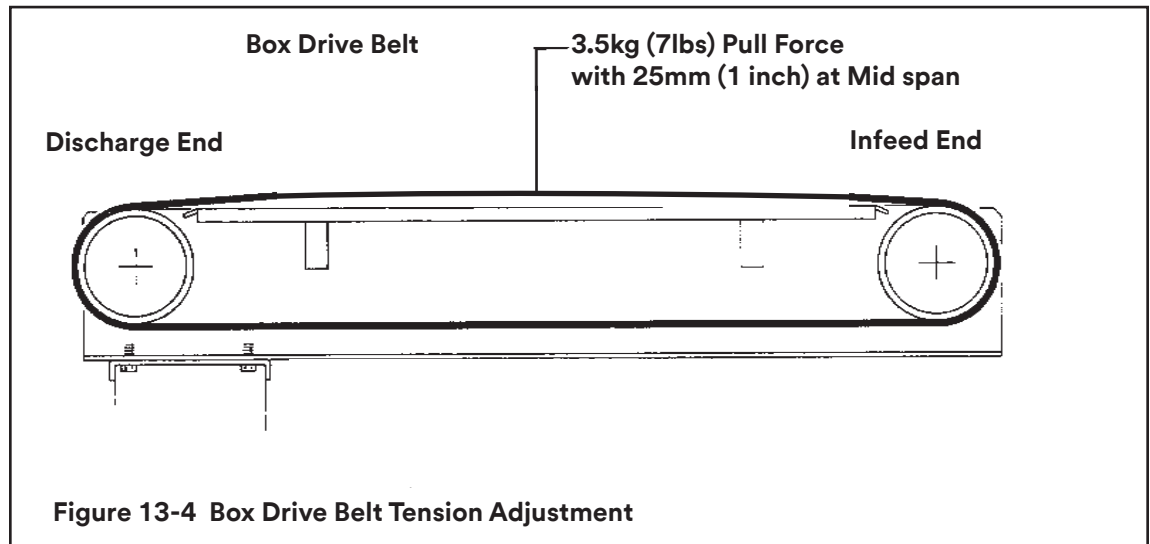


Figure 13-2 Box Drive Assembly (Infeed End)

13. Maintenance and Repairs *(continued)*



13.10 Drive Belt Tension

Tension adjustment of the drive belts may be required during normal operation. Belt tension must be adequate to positively move the box through the machine and they should run fully on the surface of the pulleys at each end of the frame.

The idler pulleys on the infeed end are adjusted in or out to provide proper belt tension. Each belt is adjusted separately. Belt tension is obtained by tightening the adjustment screw so that a moderate pulling force of 3.5 kg [7 lbs] applied at the mid span, as shown in Figure 13-4, will deflect the belt 25.4 mm [1 inch]. This will assure positive contact between the belt and the drive pulley on the discharge end of the taping head. To adjust belts, see “Maintenance – Drive Belts”, steps 3 and 7.



Warning

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



Warning

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

13. Maintenance and Repairs *(continued)*

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

Note – (See applicable taping head manual)

1. Lift the lower taping head, shown in Figure 13-5C, straight up to remove it from the case sealer bed.
2. Refer to applicable taping head manual 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 (See applicable taping head manual)

Tape Web Alignment

Tape Drum Friction Brake

Applying Mechanism Spring

One Way Tension Roller

Tape Leg Length

Leading Tape Leg Length Adjust

Changing Tape Leg Length

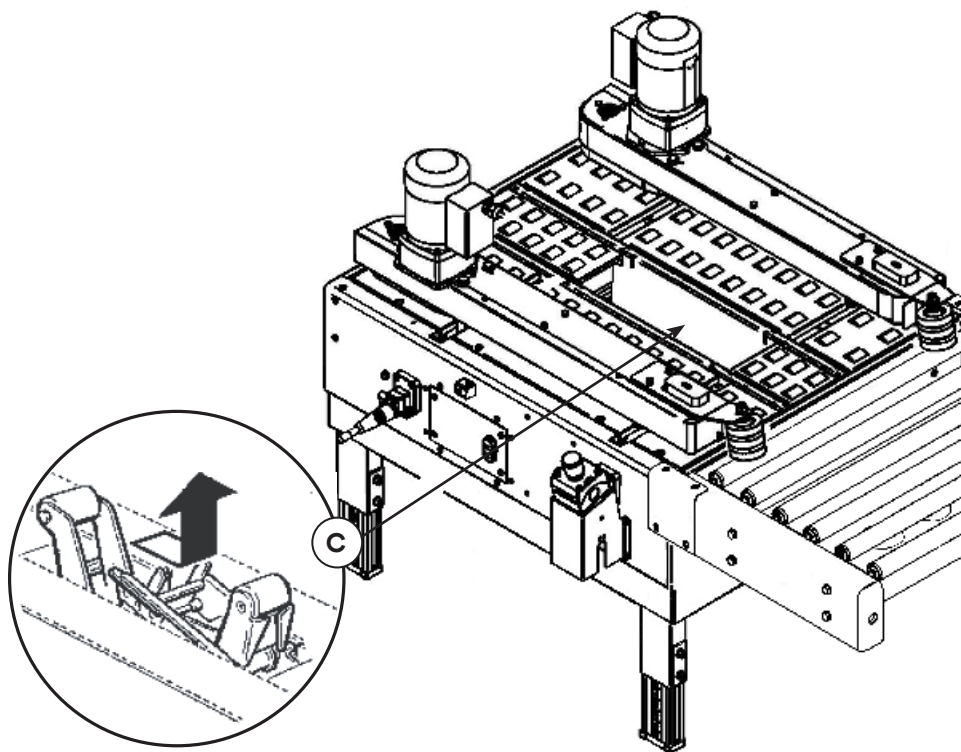


Figure 13-5 Removing Taping Heads From Case Sealer

13. Maintenance and Repairs (continued)

13.12 List of the Maintenance Operations

Date:

Description of Operation

[illegible]

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

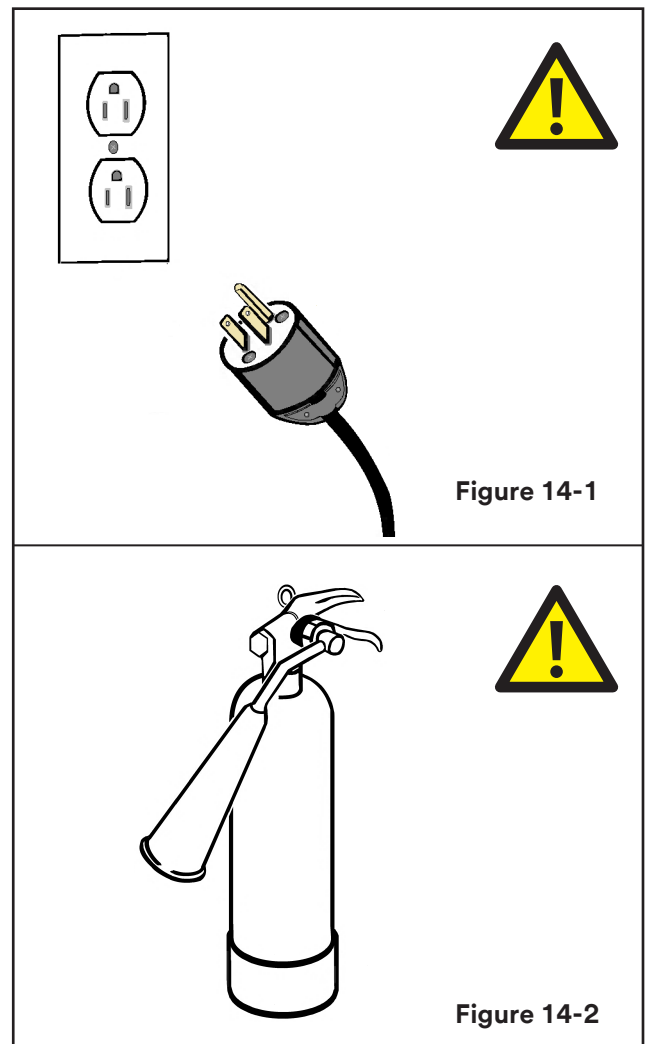
For machine disposal, follow the regulations published in each country.

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).



15. Additional Information

15.1 Statement of Conformity

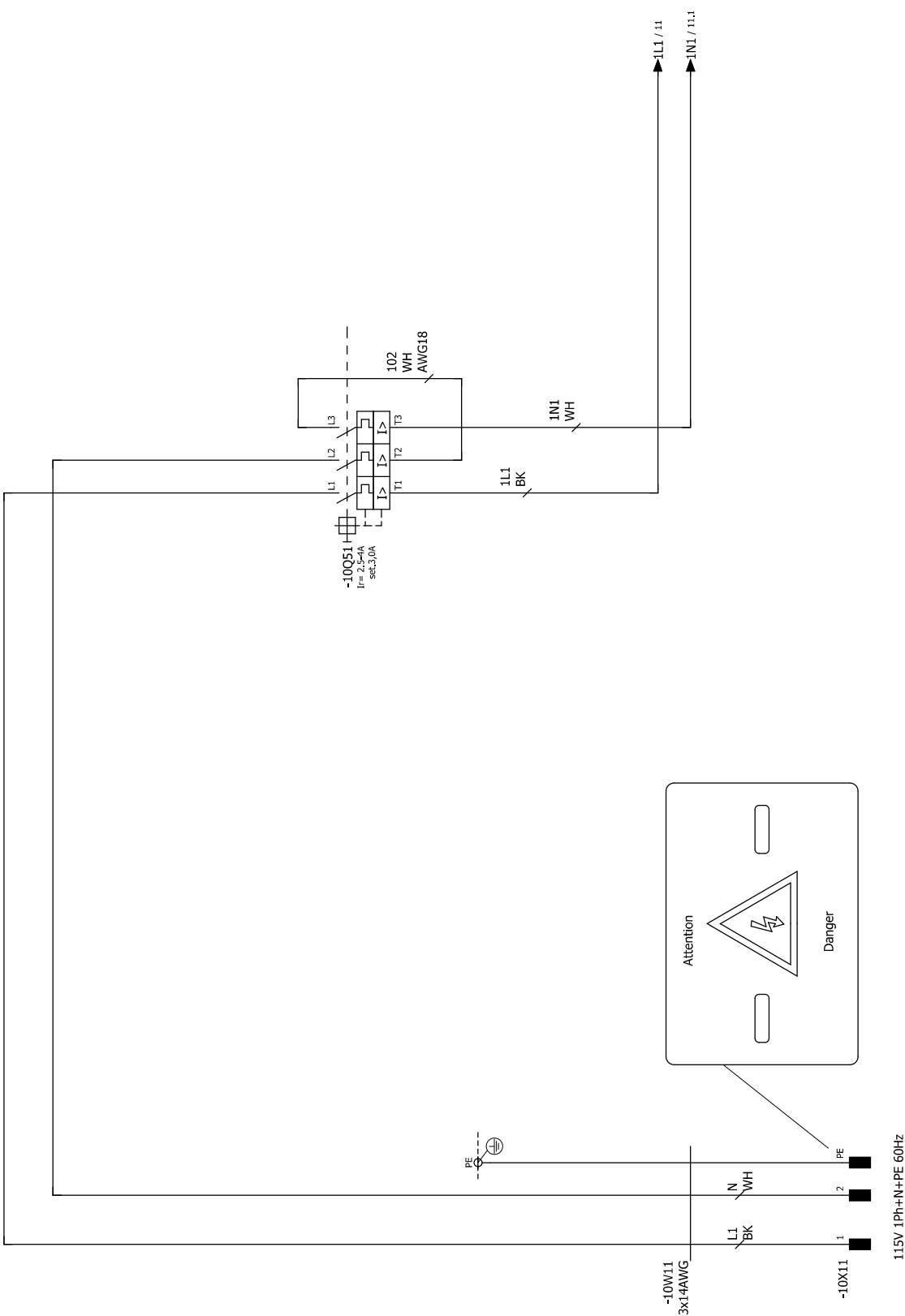
N/A

15.2 Emission of Hazardous Substances

Nothing to report

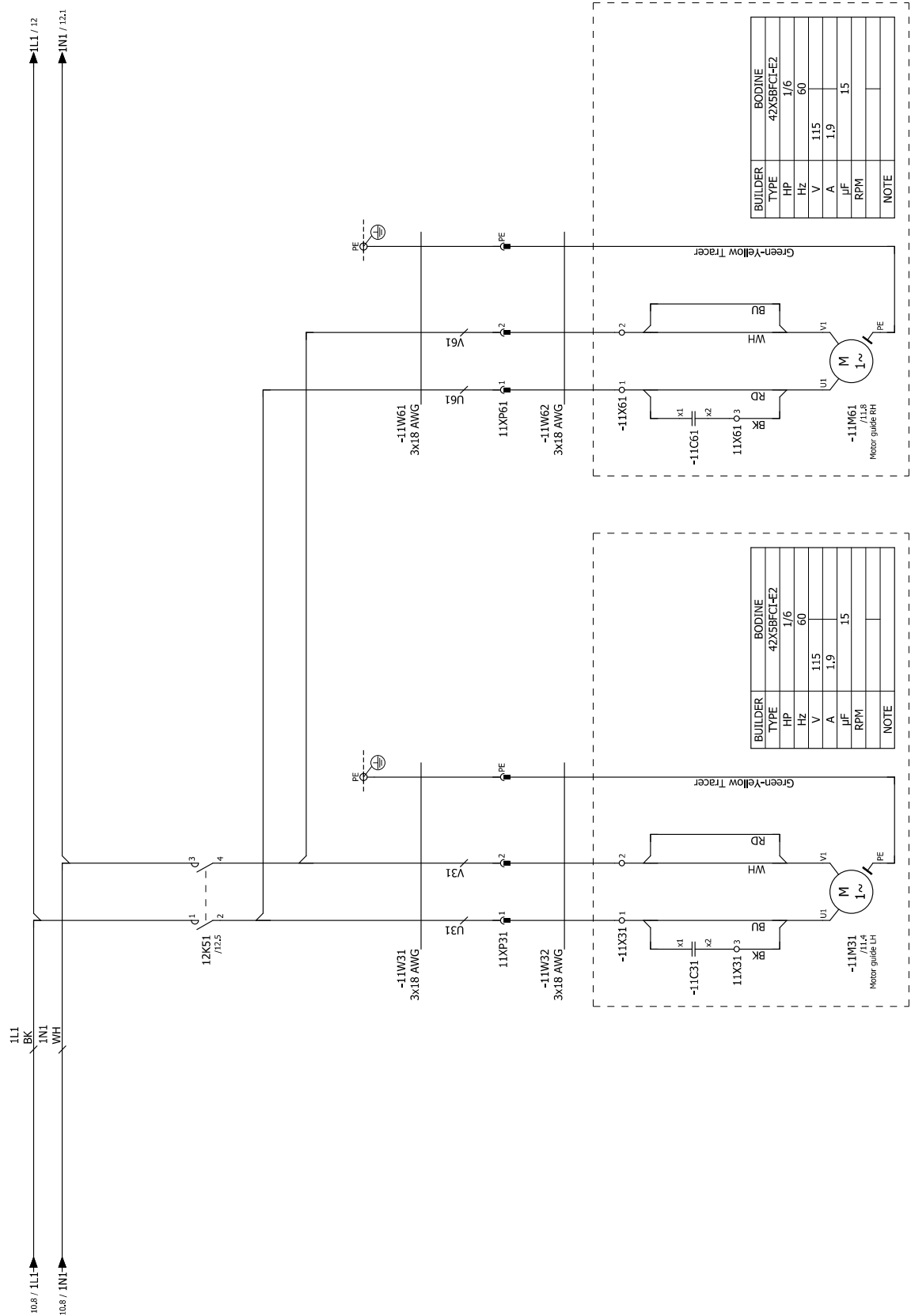
16. Technical Documentation and Information

16.1 Technical Diagrams - Electric

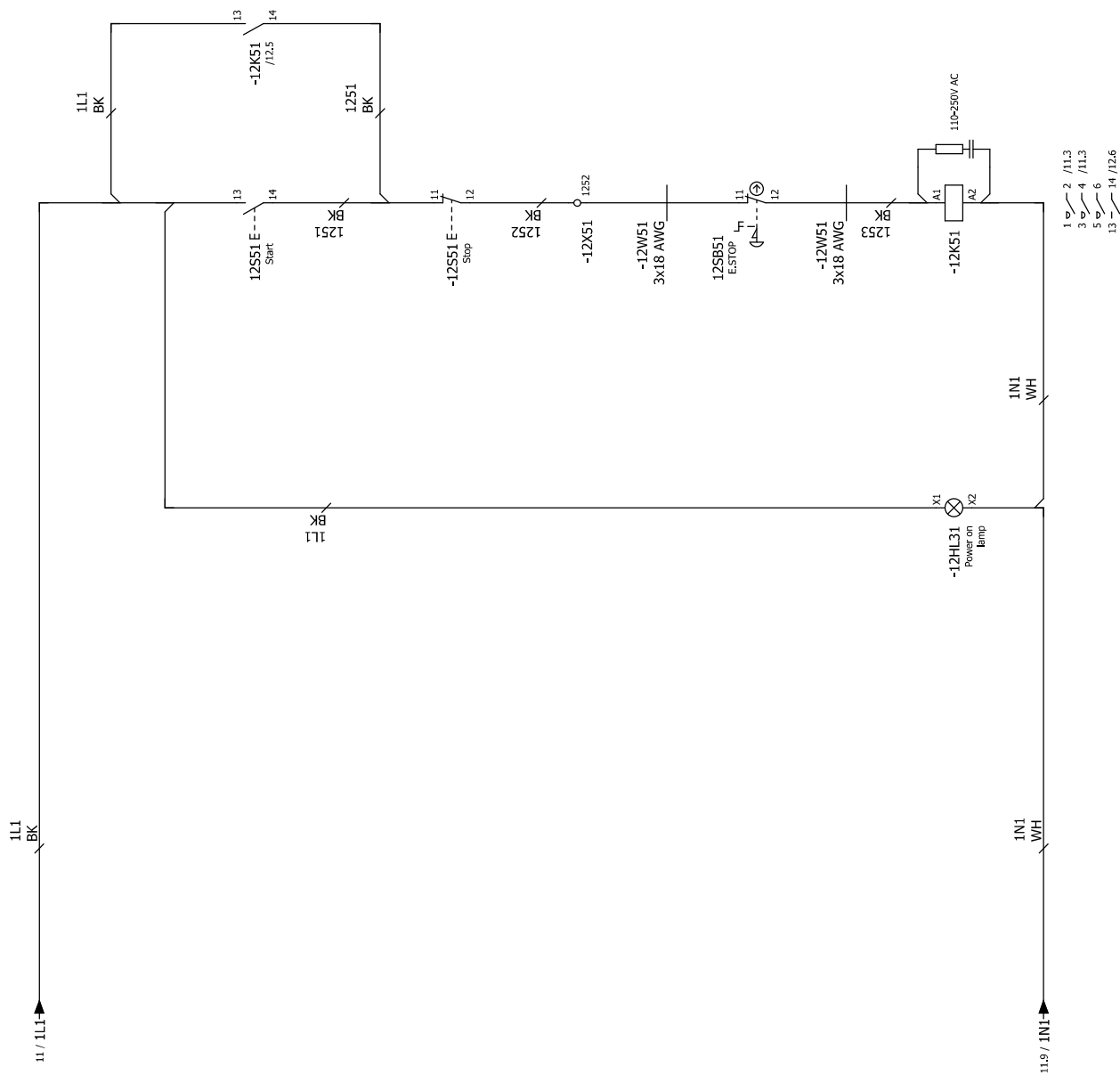


16. Technical Documentation and Information

16.1 Technical Diagrams - Electric



16.1 Technical Diagrams - Electric



16. Technical Documentation and Information *(continued)*

16.2 Spare Parts Order

Replacement Parts Ordering Information and Service

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

Order parts by quoting the following information:

(Refer to the Identification Plate on the Machine)

- Machine Model
- Serial Number
- Figure Number
- Position
- 3M Part Number (11 Digits)
- Description
- Quantity

Refer to Manual 2 for recommended taping head spare parts.

Important!

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

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

Spare Parts – 8000ab-8000ab3 Adjustable Case Sealer

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

8000ab-8000ab3

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

Spare Parts Kit

Part Number	78-0025-0525-9
	78-0025-0526-7

Label Kit

In the event that any labels are damaged or destroyed, they must be replaced to ensure operator safety. A label kit, part number 78-8137-7540-6, is available as a stock item. It contains all the safety labels used on the 8000ab-8000ab3 Adjustable Case Sealer.

Tool Kit

A tool kit, part number 78-8137-7543-0, is supplied with the machine as a stock item. The kit contains the necessary open end and hex socket wrenches for use with the metric fasteners on the case sealer. The threading tool, part number 78-8076-4726-4 contained in above kit is also available as a replacement stock item.

Replacement Parts Ordering Information and Service

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

16. Technical Documentation and Information *(continued)*

8000ab-8000ab3 Adjustable Case Sealer, Type 22600 Frame Assemblies

To Order Parts:

1. Refer to first illustration, Frame Assemblies, for the Figure Number that identifies a specific portion of the machine.
2. Refer to the appropriate Figure or Figures to determine the parts required and the parts reference number.
3. The Parts List that follows each illustration, includes the Reference Number, Part Number and Part Description for the parts on that illustration.

Note – The complete description has been included for standard fasteners and some commercially available components. This has been done to allow obtaining these standard parts locally, if desired.

4. Order parts by Part Number, Part Description and Quantity required. Also include the model/machine name, machine type, and serial number that are located on the identification plate.
5. Refer to the first page of this instruction manual “Replacement Parts and Service Information” for replacement parts ordering information.

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

Options and Accessories

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

Part Number	Option / Accessory
78-8052-6553-1	Box Hold Down Attachment
70-0064-2998-2	Caster Kit Attachment
78-0067-5967-7	Conveyor Extension Attachment
78-8069-3926-6	Low Tape Sensor Kit
78-8095-4855-1	2-Inch Tape Edge Fold Attachment, Lower Head
70-0067-6506-2	Drive Height Adjustment Kit

