

Instructions

3M-Matic™ 8000af-8000af3

Type 32600

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™ 8000af-8000af3** 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 8000af-8000af3 - Type 32600 - Serial Number 13282).

To order replacement parts, contact us:

CSPD division of Combi Packaging Systems LLC.	Phone: 1-800-344-9883
6299 Dressler Road NW	Fax: 1-877-847-5883
North Canton, OH 44720	e-mail: CSPD-CSR@combi.com
store.combi.com/CSPD/PublicStore/	www.combi.com

Identification Plate

	3M Company - St. Paul MN 55144 USA 3M - Matic™	Elec. Drawing Schéma électrique 	Conforms to / Conforme à la norme UL 963 Certified to / Certifié selon la norme CSA 22.2 No 68 Indoor Industr. use only / Utilisation industrielle intérieure seulement Control No / Numéro de contrôle 4000563			 Intertek
	Model / Modèle 	Part Number / Numéro de pièce 	VAC / V.c.a. 	Hertz 	Ampère 	
Type 	Serial Number/Numéro 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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Taping Head Information: (See applicable taping head manual)

Abbreviations and Acronyms

List of Abbreviations/Acronyms

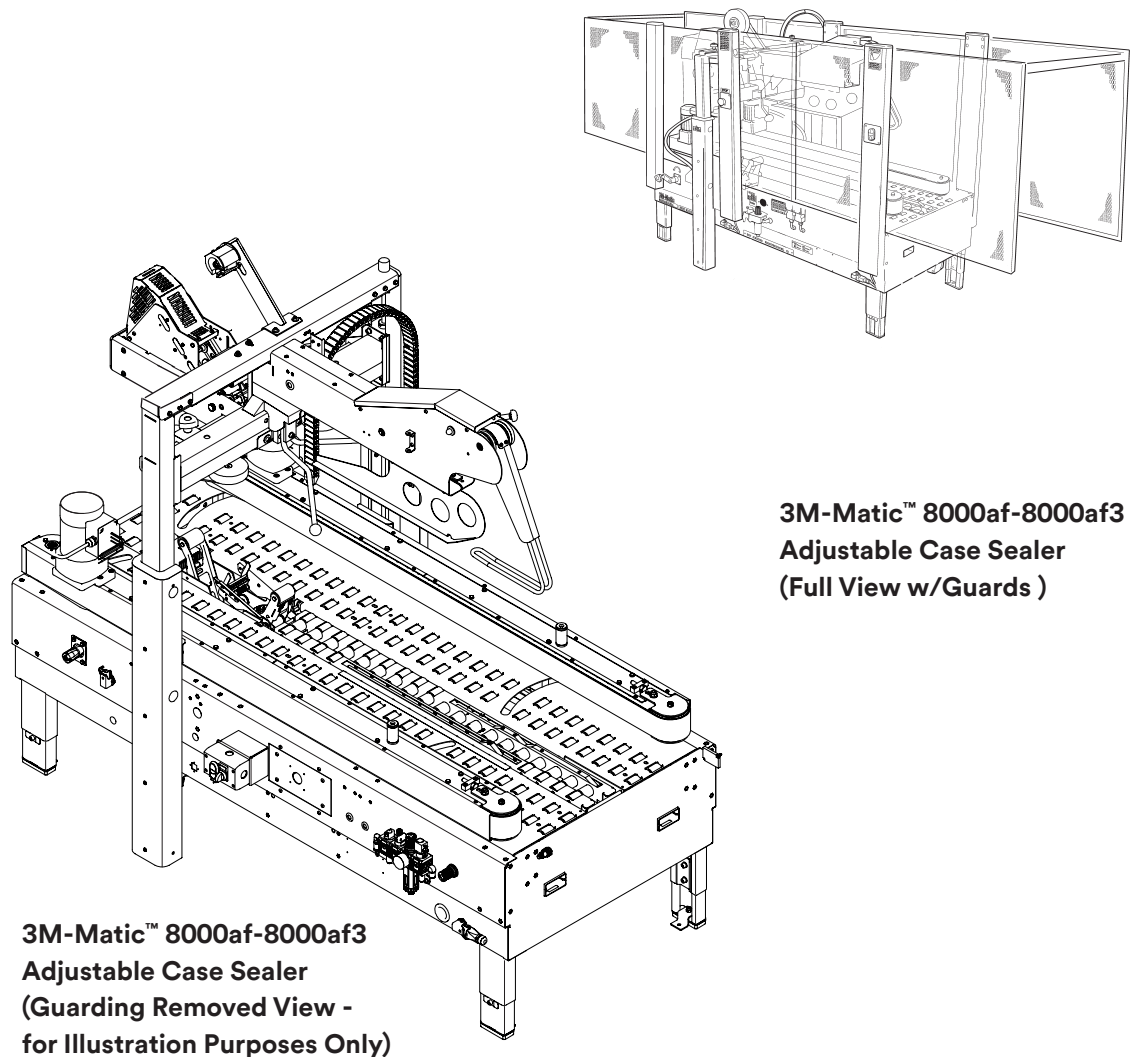
3M-Matic	Trademark of 3M St. Paul, MN 55144-1000
AccuGlide	Trademark of 3M St. Paul, MN 55144-1000
Scotch	Trademark of 3M St. Paul, MN 55144-1000
Drw.	Drawing
Ex.	For Example
Fig.	Exploded View Figure no. (spare parts)
Figure	Illustration
Max.	Maximum
Min.	Minimum
Nr.	Number
N/A.	Not Applicable
OFF.	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™ 8000af-8000af3 Adjustable Case Sealer with AccuGlide™ 3 Taping Heads is designed to apply a “C” clip of Scotch® pressure-sensitive film box sealing tape to the top and bottom center seam of regular slotted containers. The 8000af-8000af3 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™ 8000af-8000af3
Adjustable Case Sealer
(Full View w/Guards)**

**3M-Matic™ 8000af-8000af3
Adjustable Case Sealer
(Guarding Removed View -
for Illustration Purposes Only)**

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™ 8000af-8000af3 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.

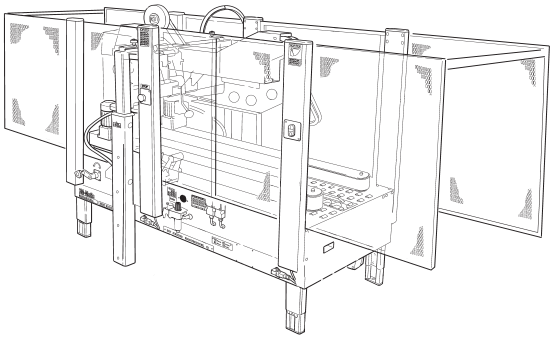
2. General Information

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™	Elec. Drawing Schéma électrique	Conforms to / Conforme à la norme UL 963 Certified to / Certifié selon à la norme CSA 22.2 No 68 Indoor Industr. use only / Utilisation industrielle intérieure 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/Numéro 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™ 8000af-8000af3 Adjustable Case Sealer, Type 32600 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: 8000af-8000af3 Adjustable Case Sealer

- (1) 8000af-8000af3 Adjustable Case Sealer, Type 32600
- (1) Tool and Spare Parts Kit
- (1) Instruction and Parts Manual

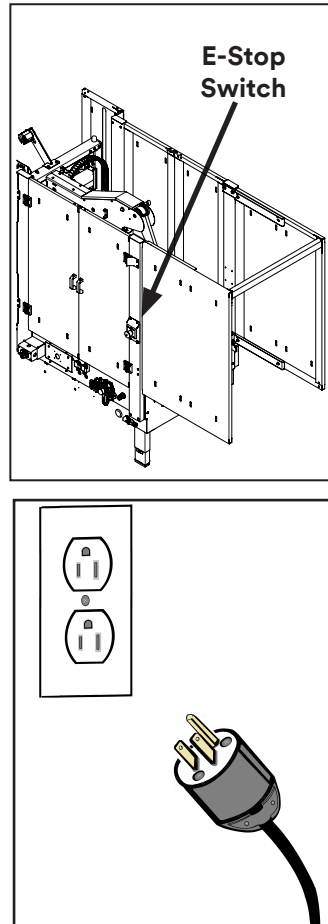
3. Safety

3.1 General Safety Information

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



Figure 3-1



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

Also disconnect air if the machine has a pneumatic system.

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

3.2 Explanation of Signal Word and Possible Consequences



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



Caution

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



Warning

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

3. Safety *(continued)*

3.3 Table of Warnings



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

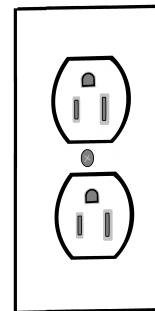


Figure 3-3

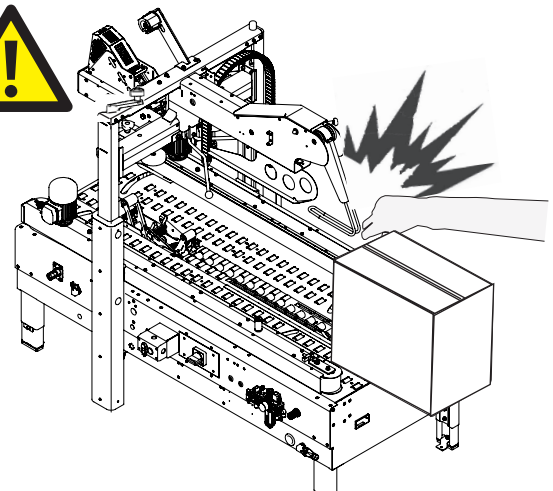


Figure 3-4

(Guarding Removed - Illustration Purposes Only)

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 top and bottom taping units. 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 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.

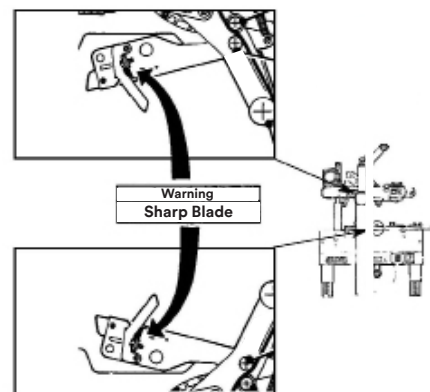


Figure 3-5

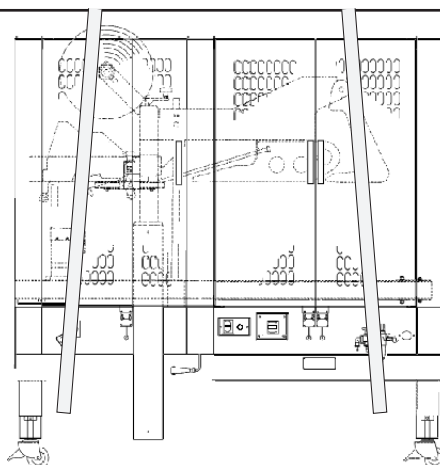
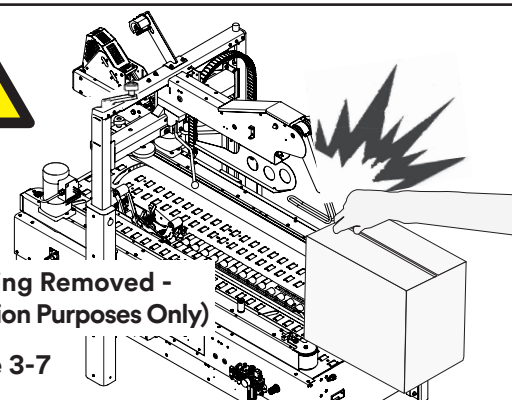
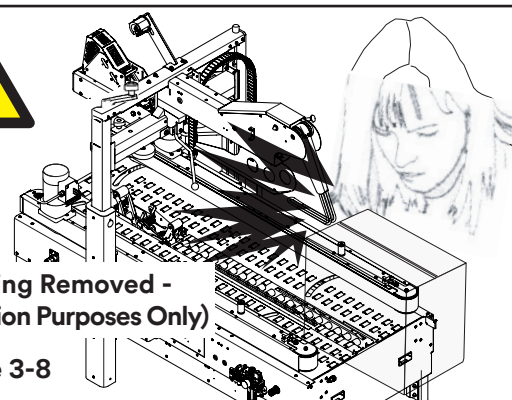


Figure 3-6



(Guarding Removed - Illustration Purposes Only)

Figure 3-7



(Guarding Removed - Illustration Purposes Only)

Figure 3-8

(Guarding Removed - for Illustration Purposes Only)

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 8000af-8000af3 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 taping head manual for taping head components.

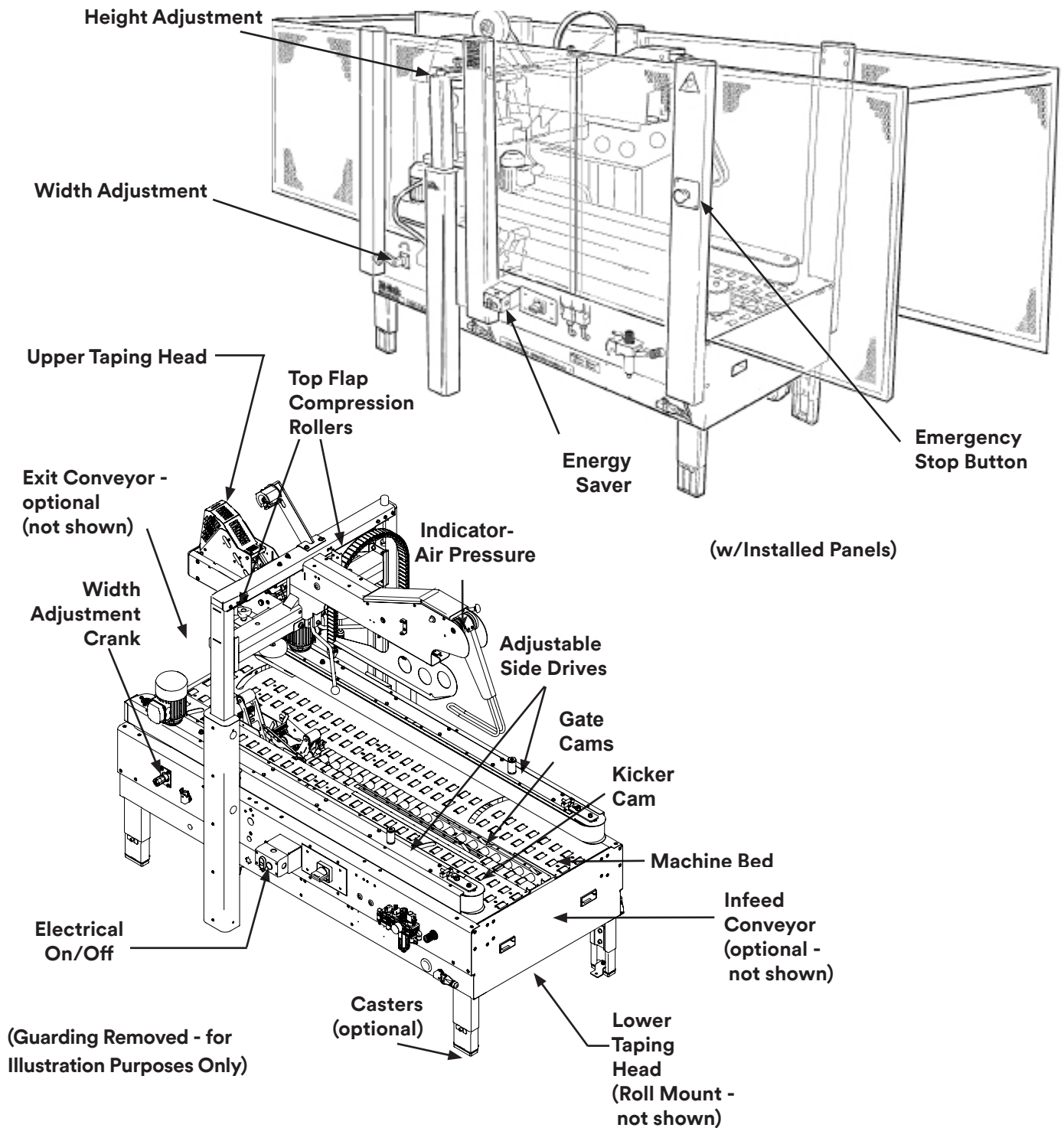


Figure 3-9 8000af-8000af3 Case Sealer Components (Left Front View)

3. Safety (continued)

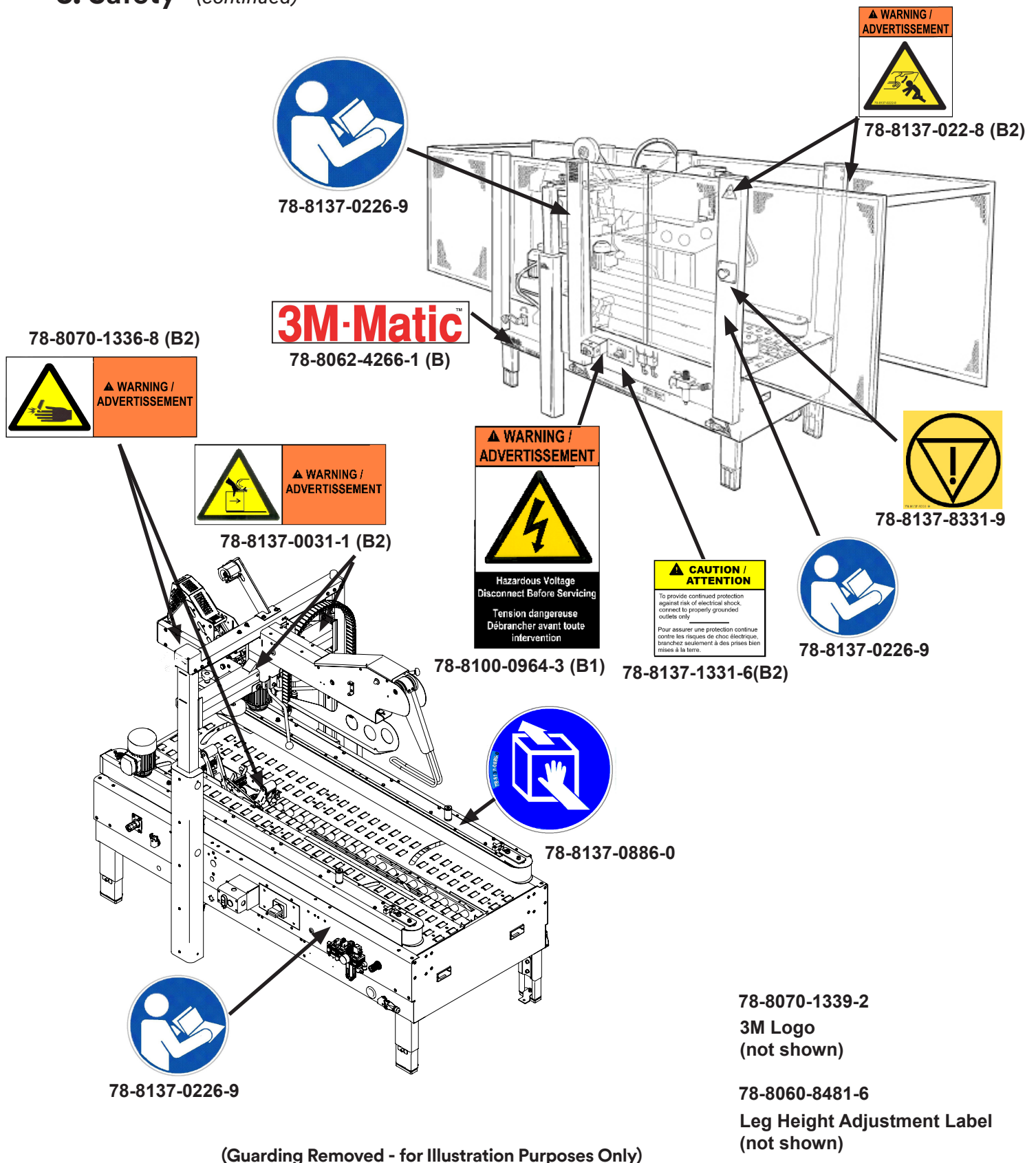


Figure 3-10 Warning Labels

4. Specifications

4.1 Power Requirements:

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

Pneumatic Supply: Min: 5.2 bar [75 PSI] Max: 9.7 bar [140 PSI] pressure

Maximum regulator setting 6.6 bar [95 PSIG]

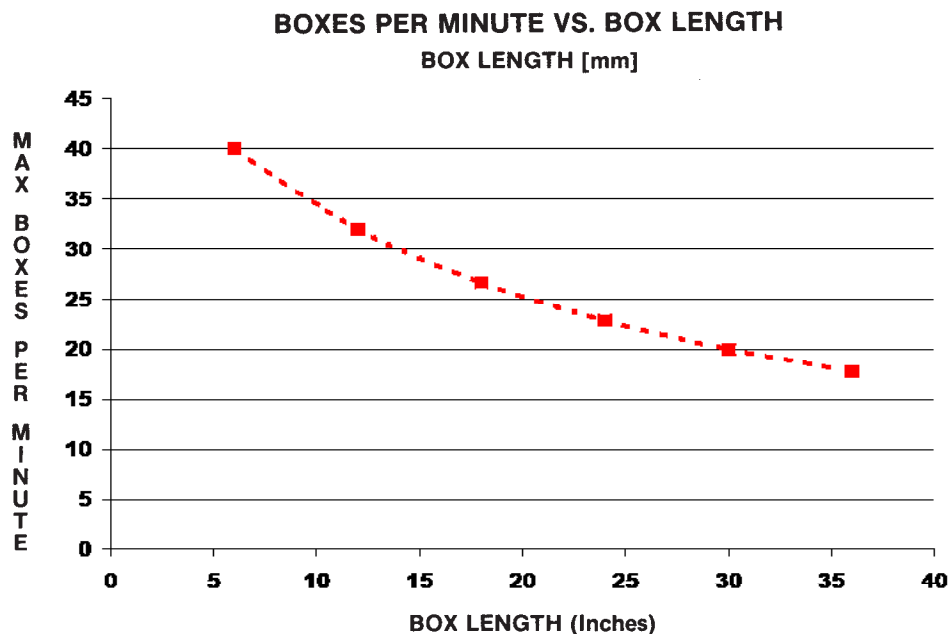
110 liter/min @ 21°C, 1.01 bar [3.75 SCFM] at 15 boxes per minute

A pressure regulator is included

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

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

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



Actual production rate is dependent on operator's dexterity.

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

4.3 Operating Conditions

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

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



Warning

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

4.4 Machine Noise Level:

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

4. Specifications *(continued)*

4.5 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.

4.6 Tape:

Scotch™ brand pressure-sensitive film box sealing tapes.

4.7 Tape Width:

36mm [1.50 inch] minimum to 72mm [3 inch] maximum

4.8 Tape Roll Diameter:

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

4.9 Tape Application Leg Length

(Refer to applicable taping head manual)

4.10 Box Board:

Style – regular slotted containers – RSC
125 to 275 P.S.I. bursting test, single wall B or C flute.

4. Specifications *(continued)*

Specifications *(continued)*

4.11 Box Weight and Size Capacities:

A. Box Weight, filled – contents must support flaps.

Minimum – weight must be sufficient to hold carton on the conveyor bed with bottom flaps fully closed or 1.4 kg [3 lb.] minimum.

Maximum – 40 kg [85 lb.]

B. Box Size:

Minimum: Length – 150mm [6 inches]	Maximum: Length – 760mm [30 inches]
Width – 120mm [4.75 inches]	Width – 545mm [21.50 inches]
Height – 95.25mm [3.75 inches]*	Height – 724mm [28.50 inches]**

* Boxes lower than 165mm [6.50 inches] and wider than 320mm [12.50 inches] require removal of compression rollers.
With taping heads adjusted to apply 50mm [2 inch] tape legs, minimum box height is 95mm [3.75 inches] with box widths greater than 195mm [7.75 inches]. See "Special Setup Procedure - Changing the Tape Leg Length".

** With columns adjusted to upper position, maximum box height increase to 725mm [28.50 inches] and minimum box height increases to 225mm [8.75 inches]. See "Special Setup Procedure – Outer Column Re-Positioning".

Note – The case sealer is designed to accommodate most boxes complying with the 1976 FBA and PMMI*** voluntary standard "Tolerances for Top Opening" regular slotted containers (RSC).

Two of the requirements of the standard are the following:

1. The box length is not more than twice the box width.
2. The box length is not more than four times the box depth.

In addition, the box score lines must be sufficient to facilitate automatic flap folding. Certain environmental conditions, such as high humidity, can be detrimental to automatic flap folding.

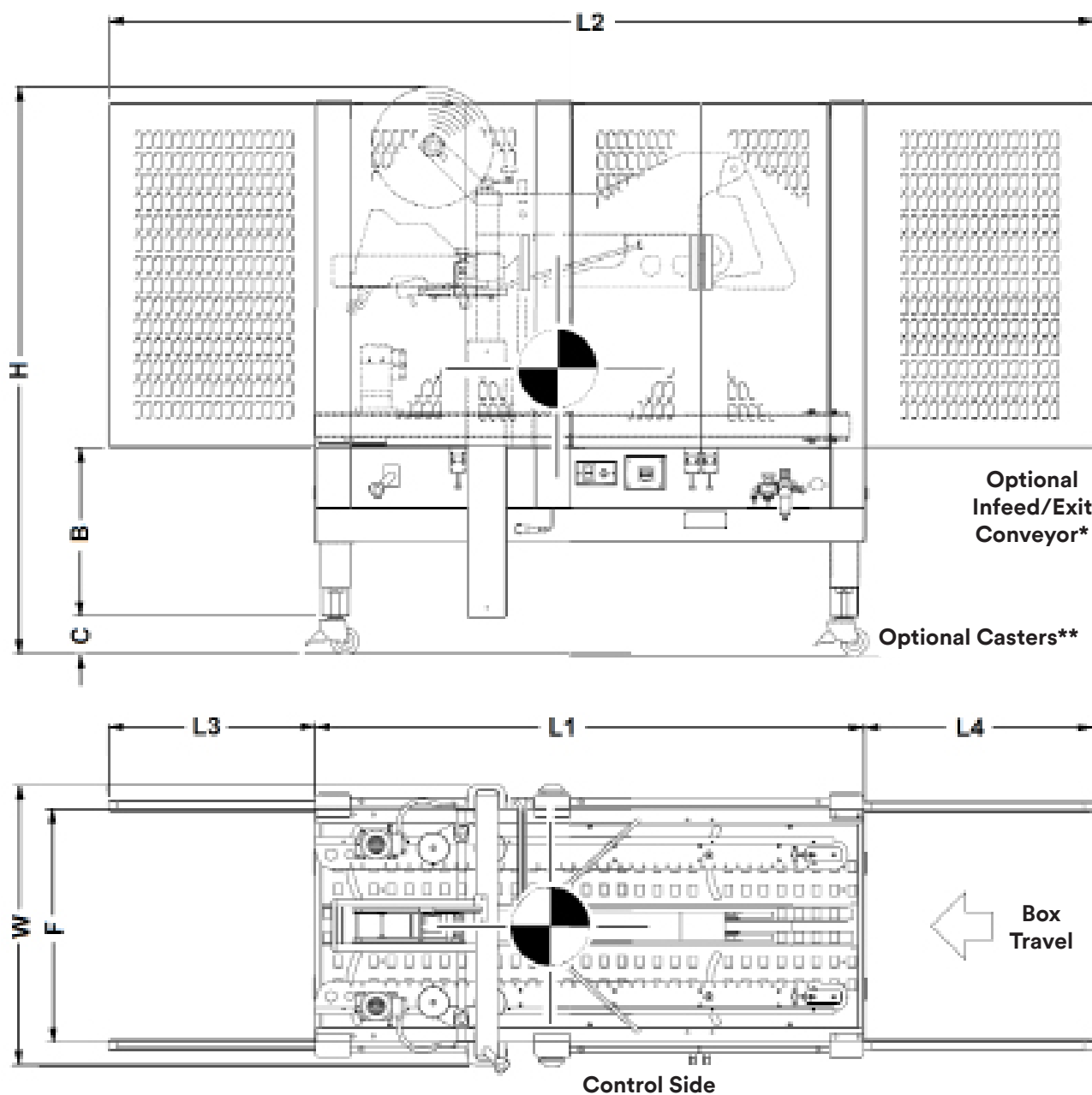
***Fibre Box Association, Packaging Machinery Manufacturer's Association

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

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

If any of the above criteria are not met boxes should be test run to assure proper machine performance.

4. Specifications (continued)



4.12 Machine Dimensions:

	W	F	H	B	L1	L2	L3	L4	C
Minimum									
mm	1045	819	1810	610	1920	3520	800	800	121
[Inches]	[41.13]	[32.25]	[71.25]	[24]	[75.63]	[138.63]	[31.5]	[31.5]	[4.75]
Maximum									
mm	--	--	2090	890	--	--	--	--	--
[Inches]	--	--	[82.25]	[35]	--	--	--	--	--

Weight: 410 kg [900 lbs.] crated (approximate)
370 kg [820 lbs.] uncrated (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).

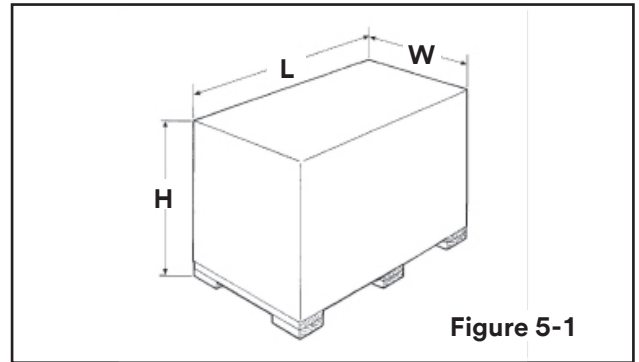


Figure 5-1

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.

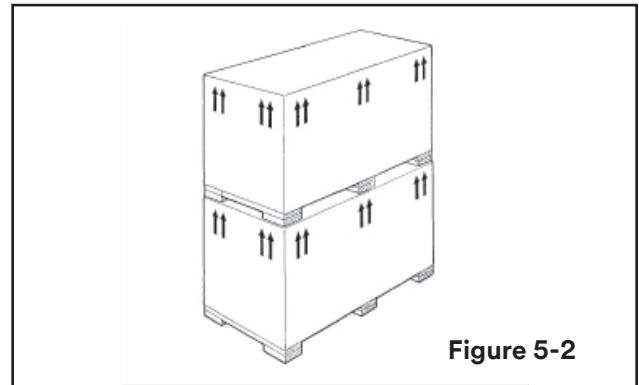


Figure 5-2

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).

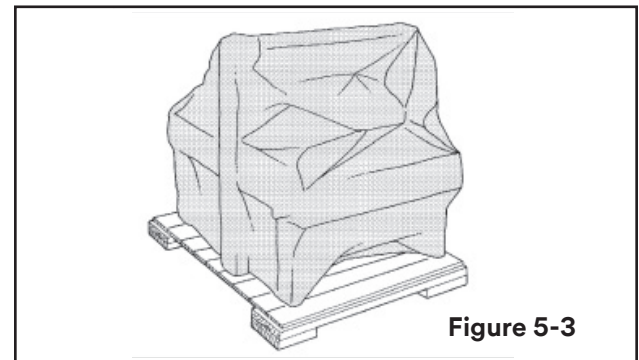


Figure 5-3

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).

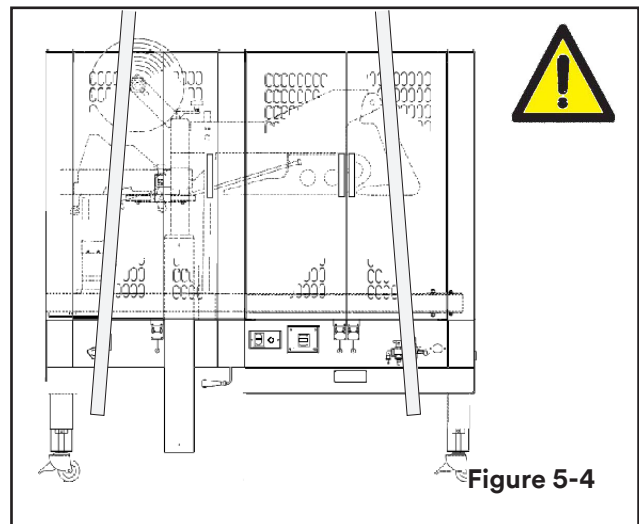


Figure 5-4

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 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 8000af-8000af3 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.

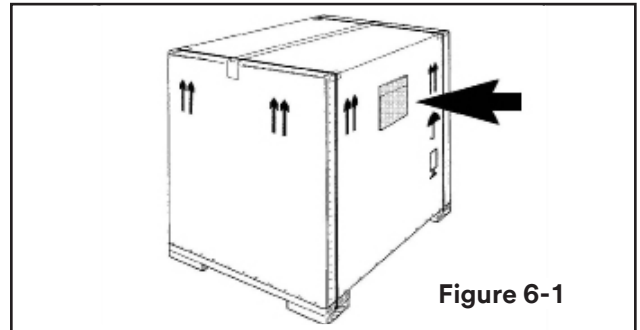


Figure 6-1

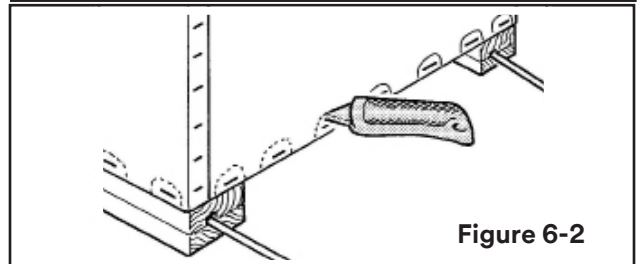


Figure 6-2

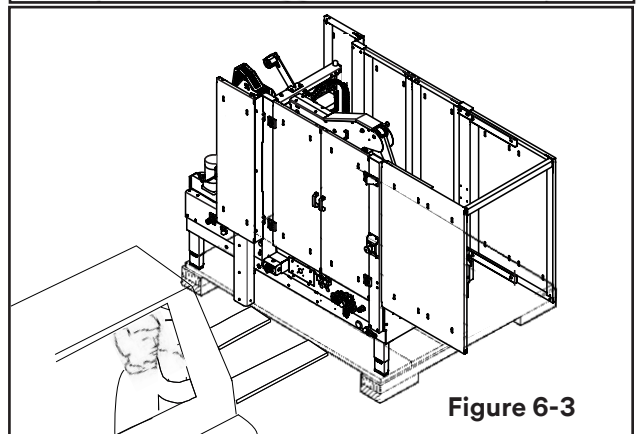


Figure 6-3

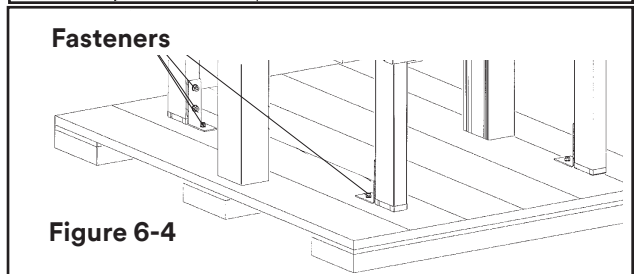


Figure 6-4

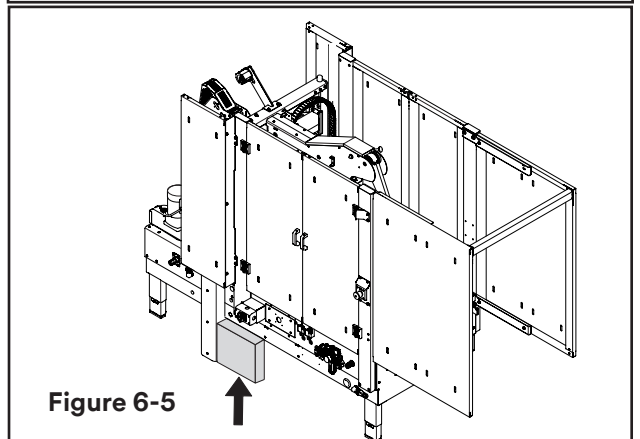


Figure 6-5

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.

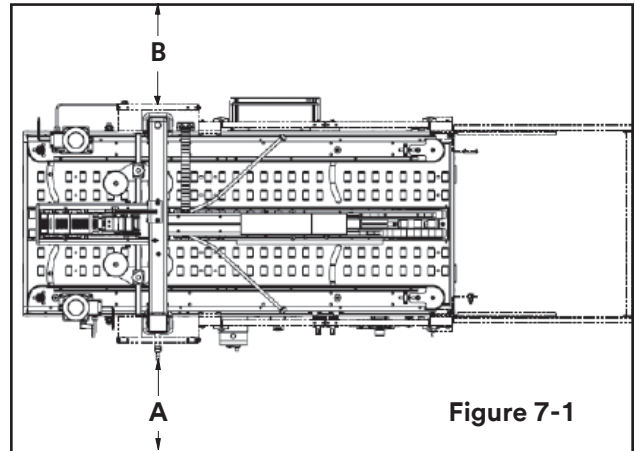


Figure 7-1

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

Important: Before lifting or repositioning the machine

- Review machine weight in specification section
- Observe permissible lift areas when positioning straps or lift truck forks (minimum fork length 890 mm [35 pouces])

1. Lift the machine with belts or ropes or lift truck, 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) .

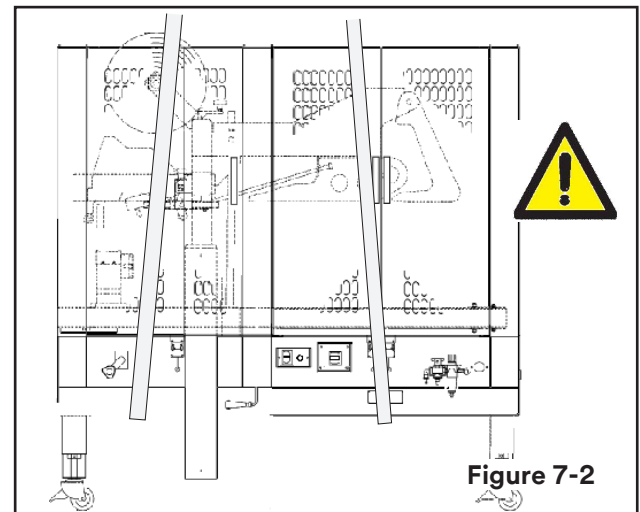


Figure 7-2

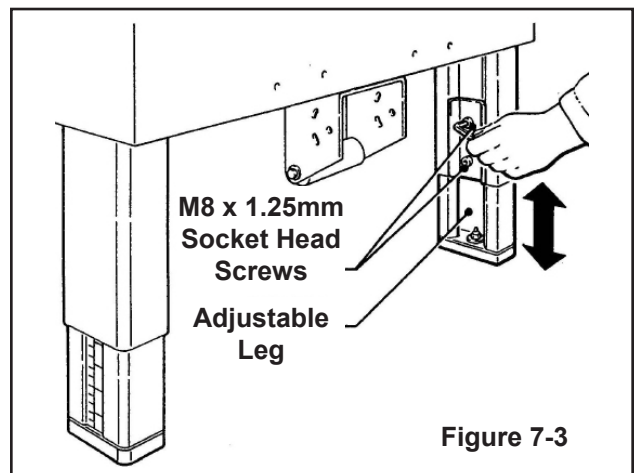


Figure 7-3

7. Installation *(continued)*

7.5 Removal of Plastic Ties

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

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

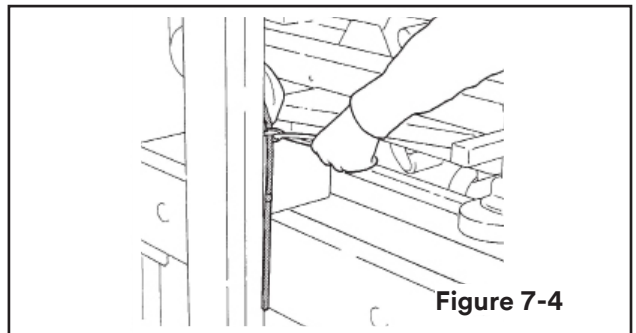


Figure 7-4

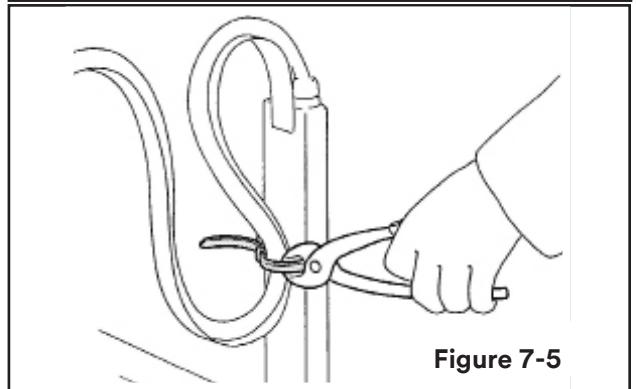


Figure 7-5

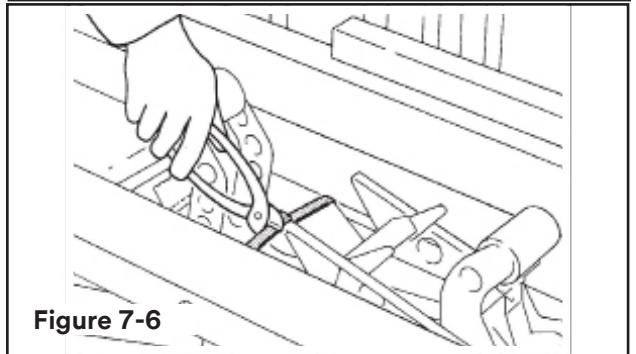


Figure 7-6

7.6 Assembly Completion

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

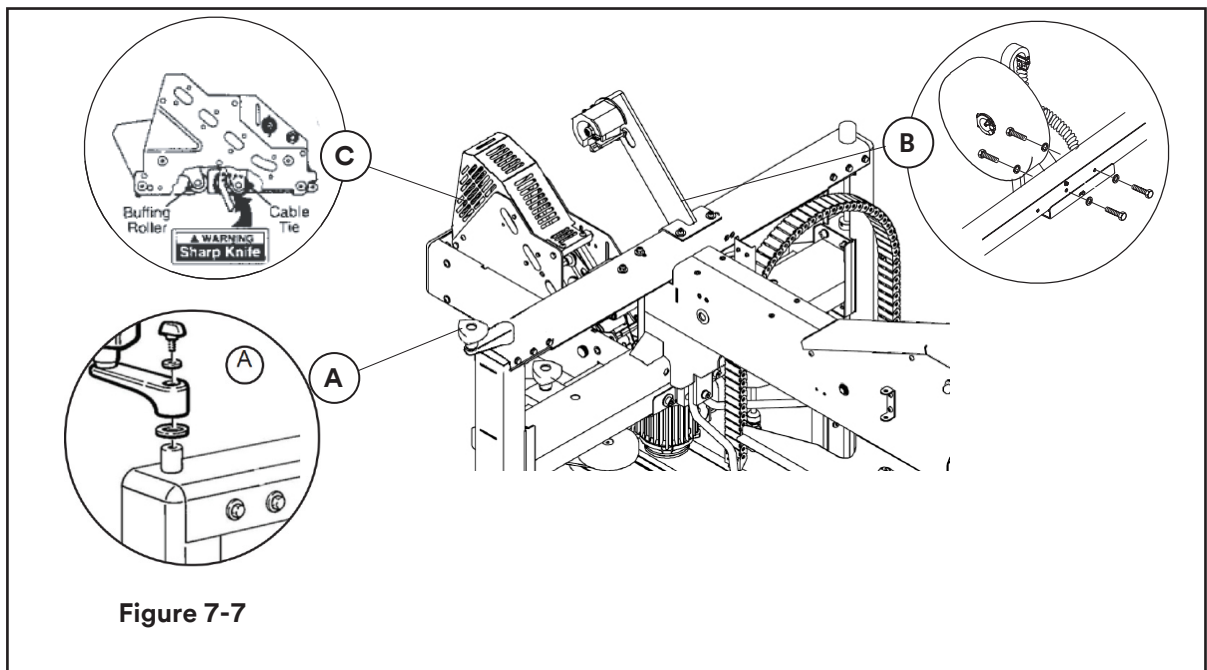


Figure 7-7

7. Installation *(continued)*

7.7 Completion of Taping Heads

See for Complete Instructions:

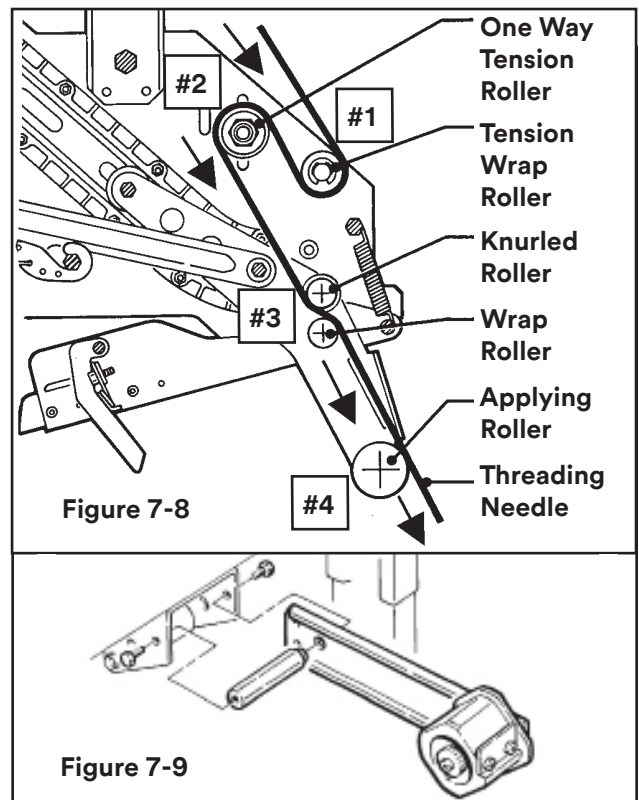
1. Place the Upper Taping Head in a convenient working position
2. Use Figure 7-8 and tape threading label. Position the tape supply roll so the adhesive side of tape is facing the front of the taping head as it is pulled from the supply roll.
3. Attach the threading needle to the end of the roll. Guide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

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

7.8 Outboard Tape Roll Holder

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

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



7.9 Preliminary Electric Inspection

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

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

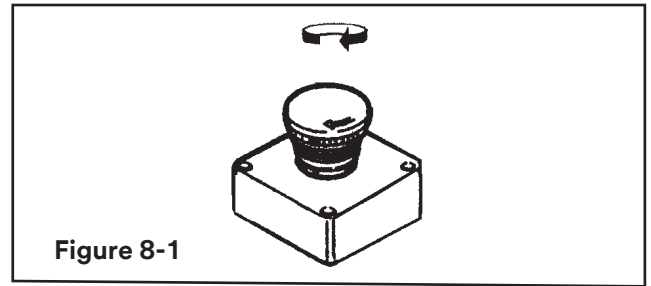
- Push the LATCHING EMERGENCY STOP BUTTON.
- The main switch turned OFF (O).

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

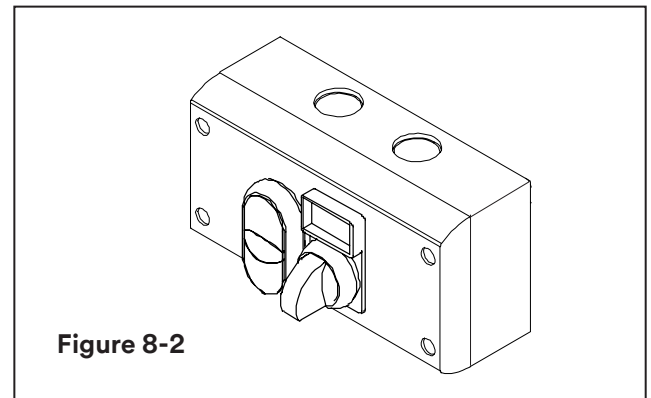
After having closed the top flaps of the carton, the operator pushes it under the top infeed end in order to avoid the opening of the top flaps. Further pushing causes the two bottom side belts to drive the box through the taping heads which automatically seal the top and bottom seams. The carton is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



8.2 Definition of Running Mode

The case sealer 8000af-8000af3 has two (automatic) operating modes with:

- The EMERGENCY STOP BUTTON unlocked (Figure 8-1)
- The Main Start Switch “ON” (I) / The Energy Saver Control (Figure 8-2)



8.2.1 Normal Stop Procedure

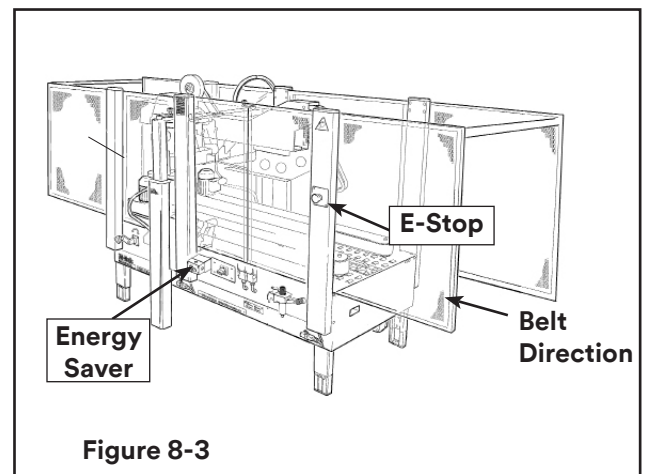
When the main switch is OFF (O), the machine stops immediately at any point of the working cycle. The same thing happens in case of electrical failure or when the machine is disconnected from the mains.

8.2.2 Emergency Stop

The LATCHING EMERGENCY STOP and ENERGY SAVING BUTTONS are located on the machine frame as shown - (Figure 8-3).

8.2.3 Energy Saving Control

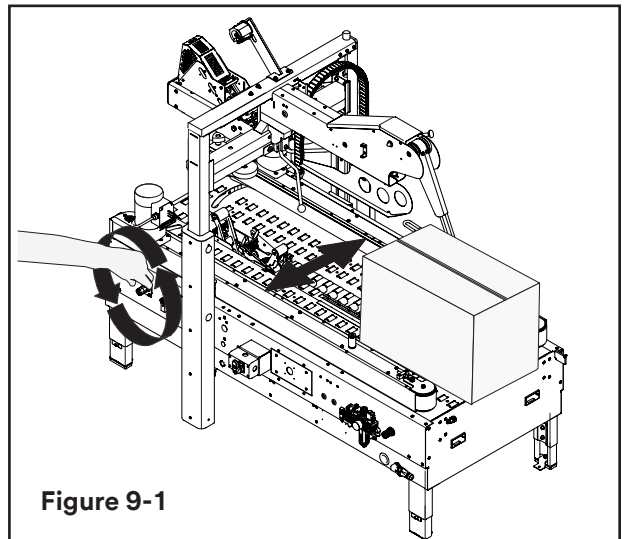
The Energy Saving Control Button is located on the column below the Emergency Stop Button on the Operator side of the machine. Pressing the lighted Energy Saving Control Button engages/disengages this feature. When engaged, the drive belts will stop if there is not a continuous flow of boxes through the machine. Inserting a box will re-start the machine (Figure 8-2).



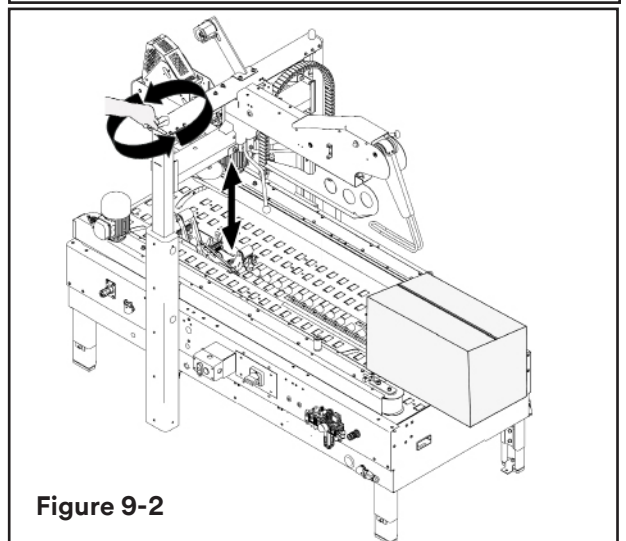
9. Controls

(Guarding Removed - for Illustration Purposes Only)

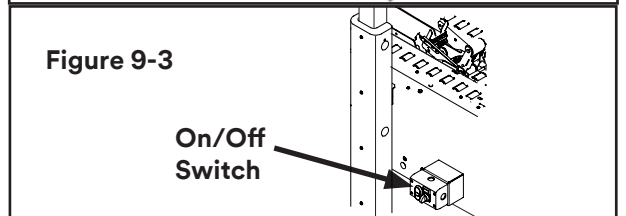
9.1 Box Width Adjusting Knobs



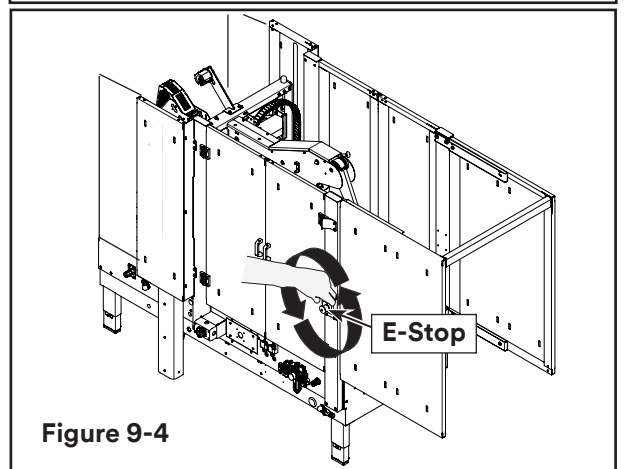
9.2 Box Height Adjusting Crank



9.3 On/Off Switch/Energy Saver



9.4 Latching Emergency Stop Button



10. Safety Devices of the Machine

10.1 Blade Guards

Both top and bottom taping units have a blade guard (See : 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)

Energy Saving Control

The Energy Saving Control Button is located on the column below the Emergency Stop Button on the Operator side of the machine. Pressing the lighted Energy Saving Control Button engages/disengages this feature. When engaged, the drive belts will stop if there is not a continuous flow of boxes through the machine. Inserting a box will re-start the machine.

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.

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.

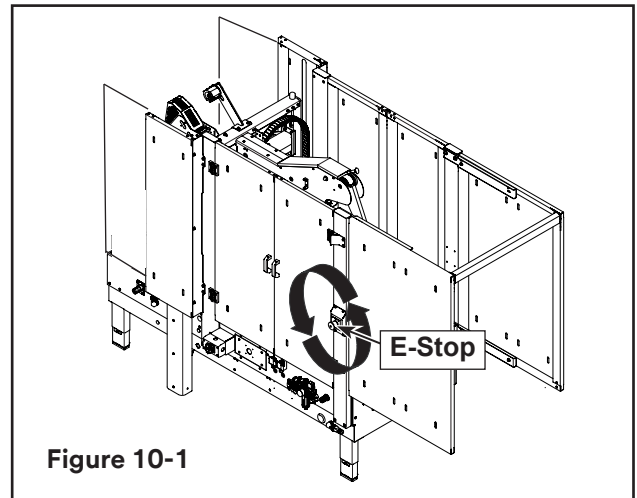


Figure 10-1

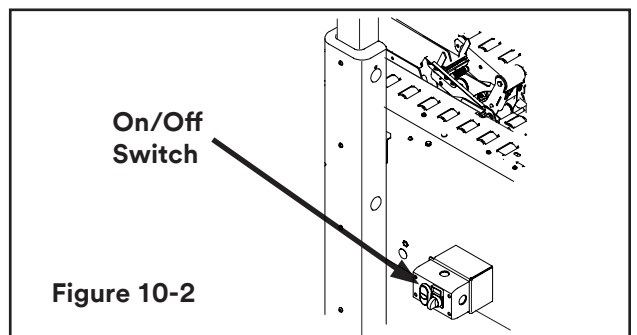


Figure 10-2



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. Operation

Note: See next page for the function of these controls

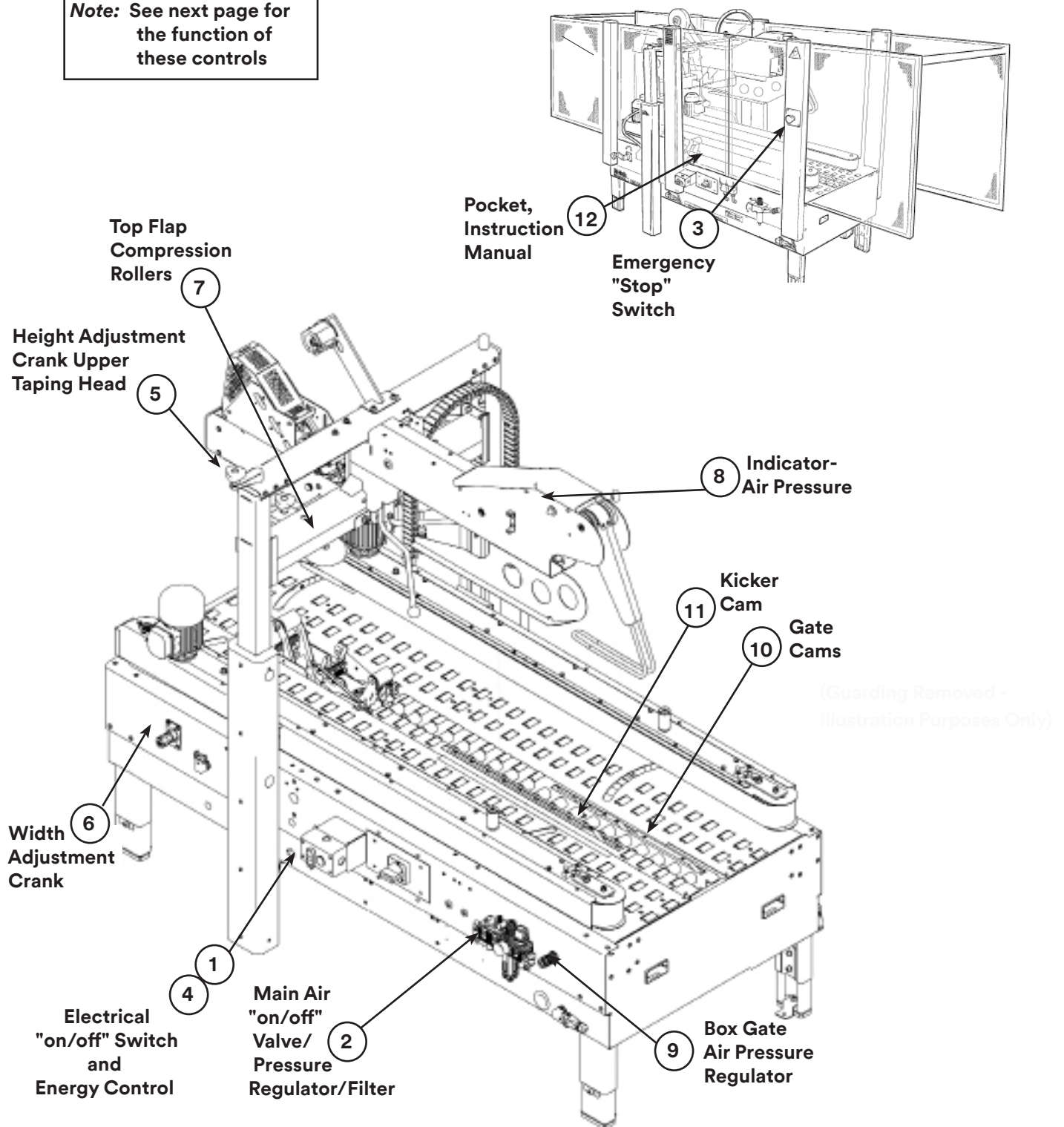


Figure 11-1 Controls

(continued on next page)

11. Operation *(continued)*

11.1 Component Locations *(continued)*

① Electrical “On/Off” Switch:

The box drive belts are turned on and off (off button is red) with the electrical switch on the side of the machine guard at infeed end.

② Main Air “On/Off” Valve/Pressure Regulator/Filter – Figure 11-2:

This set of pneumatic components controls, regulates and filters plant air supply to two separate control circuits of the case sealer.

“On/Off” Valve – “On” turn to “SUP” – “Off” turn to “EXH”

Note – Turning air supply “Off” automatically bleeds air pressure from the case sealer air circuits.

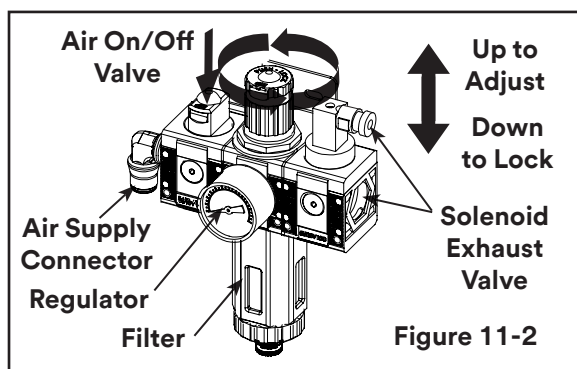
Always turn the air “Off” when machine is not in use, when servicing the machine, or when connecting or disconnecting air supply line.

Note – The air valve has provisions for lockout/tagout according to plant regulations.

Pressure Regulator: Regulates main air pressure to the machine to adjust pressure, pull knob up and turn – push down to lock setting. **Filter** removes dirt and moisture from plant air before it enters the case sealer pneumatic circuits. If water collects in bottom of bowl, lift up on the valve on the bottom of bowl to drain.

③ **Emergency “Stop” Switch:** The two emergency “Stop” switches are mounted for operator convenience, on both sides of the case sealer. Pushing either of these switches will stop the drive motors/belts and exhaust air from the flap kicker. To restart machine, rotate emergency stop switch (release switch latch) and then restart machine by pressing green (On) button on side guard.

④ **Energy Saving Control:** The Energy Saving Control Button is located on the column below the Emergency Stop Button on the Operator side of the machine. Pressing the lighted Energy Saving Control Button engages/disengages this feature. When engaged, the drive belts will stop if there is not a continuous flow of boxes through the machine. Inserting a box will re-start the machine.



⑤ **Height Adjustment Crank, Upper Taping Head:** Raises and lowers upper taping head/flap folders to accommodate box height.

⑥ **Width Adjustment Crank:** Adjusts distance between side drive belts to accommodate box width.

⑦ **Top Flap Compression Rollers:** Rollers adjust to properly maintain box width/top flap center seam for tape seal.

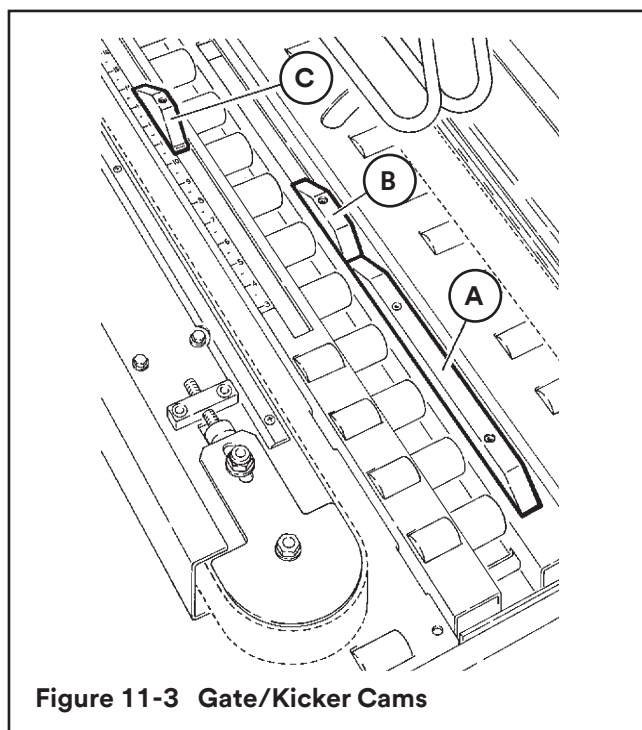
⑧ **Indicator, Air Pressure:** The optical Warning indicator, located on the upper flap folder frame, indicates “Red” when compressed air circuit is on.

⑨ **Box Gate Air Pressure Regulator:** Adjusts lifting force of the box gate depending on the weight of boxes being sealed.

⑩ **Gate Cams – Figure 11-3:** The gate cams (A) (B) control the rate of box entry into the case sealer. Depending on box size, gate cams can be adjusted to increase production rate. See “Adjustments – Gate Operation”.

⑪ **Kicker Cam – Figure 11-3:** The minor flap folder, controlled by the kicker cam (C), closes the trailing minor flap on the box. The kicker cam must be adjusted according to the length of the box being sealed. See “Operation”.

⑫ **Pocket, Instruction Manual:** A pocket is provided inside the right door for storage of the machine instruction manual. Keep the manual in this pocket for the convenience of machine operators.



11. Operation *(continued)*

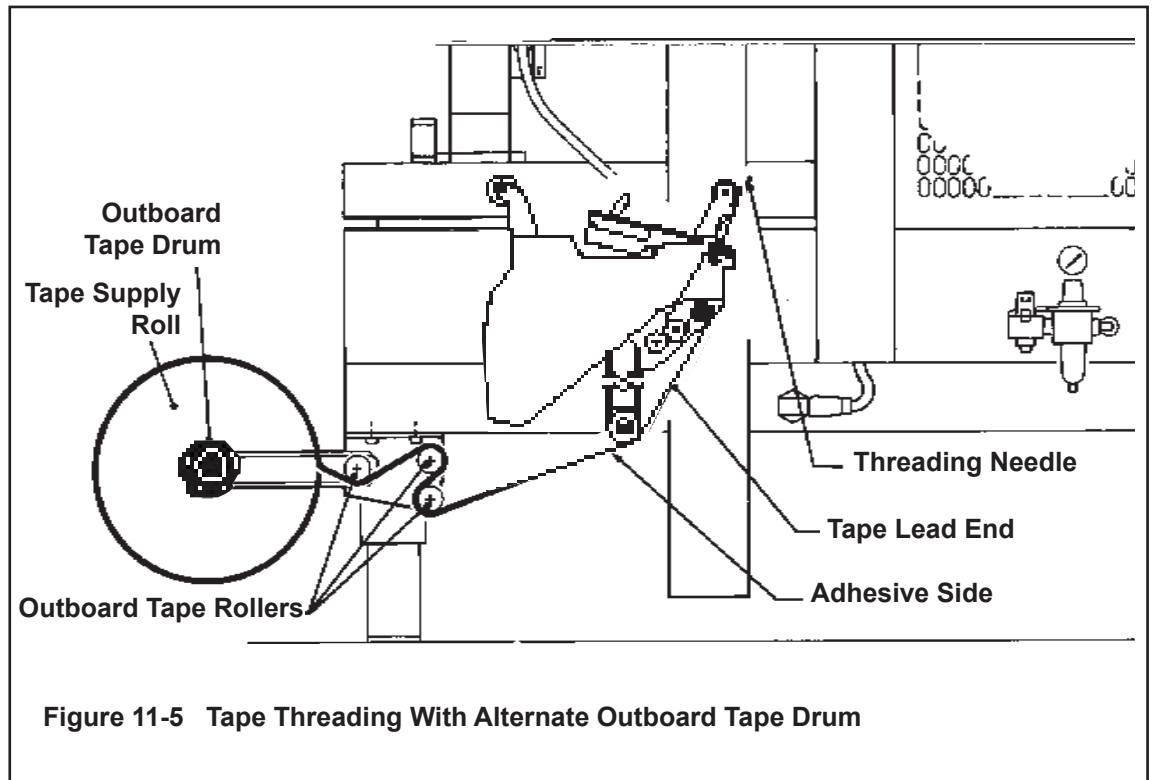
11.2 Operation Warnings



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 and flap kicker.
5. Keep away from flap kicker. Flap kicker is controlled by air and can be activated (if air supply is "On") by depressing flap kicker cam. Be sure flap kicker is in the down position before servicing.
6. Never attempt to remove jammed boxes from the machine while machine is running.
7. Machine access door must be closed when drive belts are running. Do not attempt to override door interlock switch.
8. 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.
9. Both the upper and lower 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.
10. To provide continued protection against risk of electric shock, connect to properly grounded outlets only.
11. Failure to comply with these Warnings could result in severe personal injury and/or equipment damage.

11. Operation *(continued)*

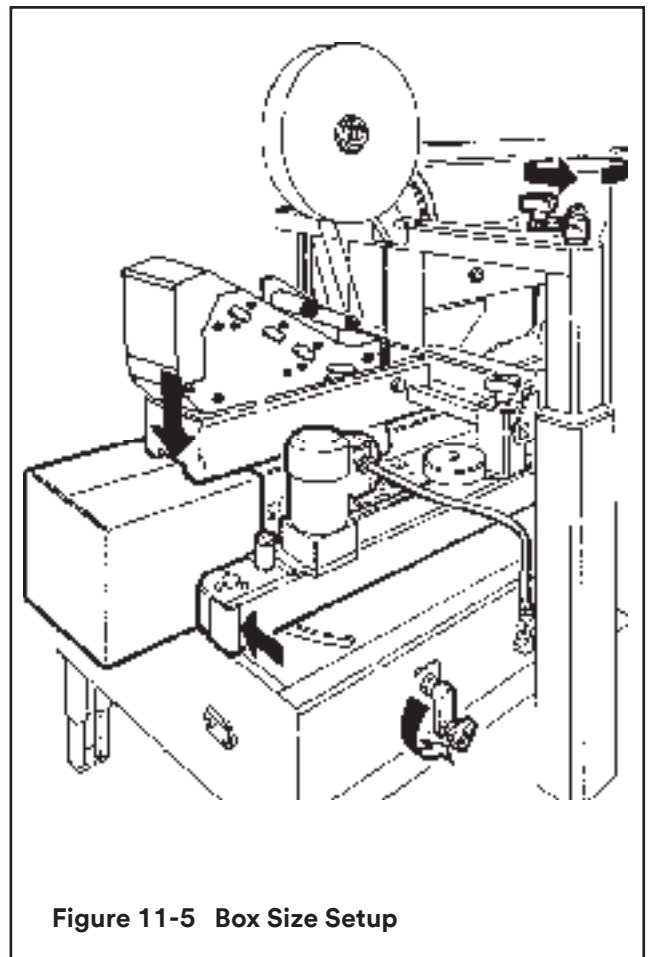


11.3 Box Size Setup

Figure 11-5

Open the side drive belts and raise the upper head assembly to accommodate the desired box width and height.

Move the compression rolls as wide as possible.



11. Operation *(continued)*

Figure 11-6

Place a product filled box 55 to 65mm [2.25 to 2.5 inches] into the exit end of the machine with the top flaps folded as shown.

Crank the upper head down until it just contacts the top of the box.

Crank the side drive belts in until the belts firmly grip the box.

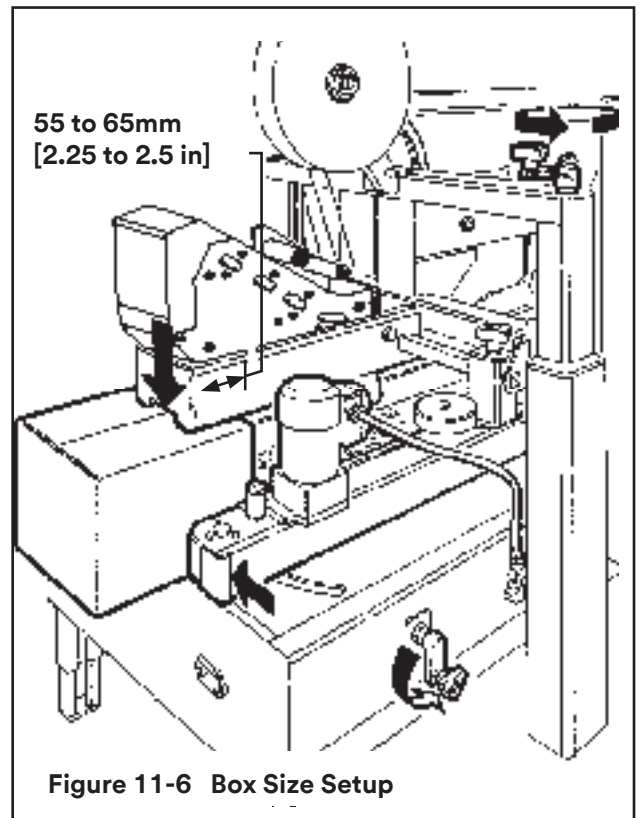
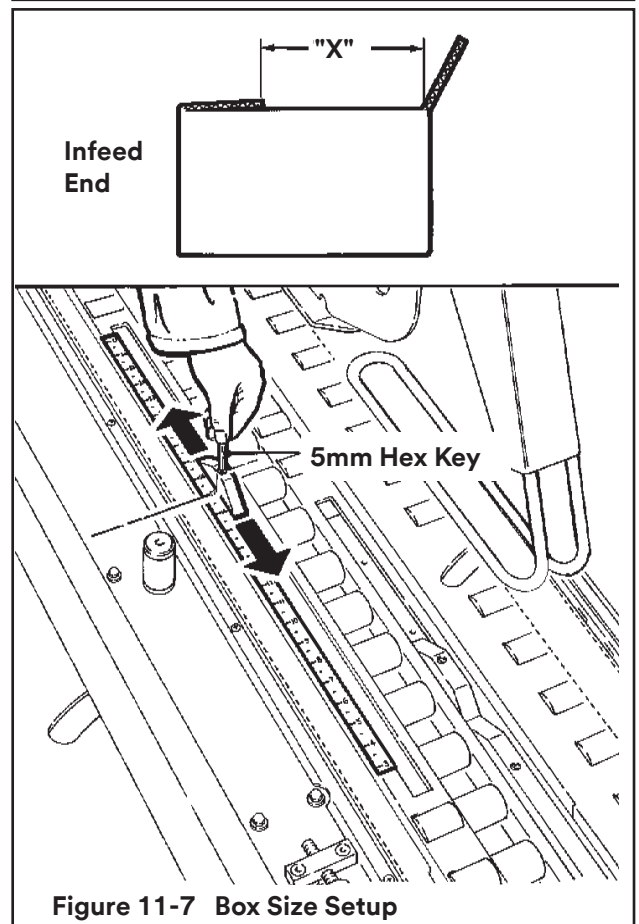


Figure 11-7

Set Kicker cam relative to length of box being sealed. Measure the distance "X" as shown and set the cam to the same dimension measured on the box (this dimension provides a good starting point for setting the kicker cam).

Note: 5mm hex key wrench is supplied with machine and should be kept in wrench holder on side of upper frame.



11. Operation *(continued)*

Figure 11-8

Important – Be sure all packaging materials and tools are removed from machine before operating.

Turn air On/Off valve to "On" (SUP) position.
Press electrical "On" button to start drive belts.

Place box at infeed end of machine and push into machine until it is taken away by drive belts.



Caution

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

Figure 11-9

Adjust compression rollers. Run box through machine and stop when adjacent to compression rollers.

Move compression rollers in to press box top flaps firmly together.

Restart machine to exit box

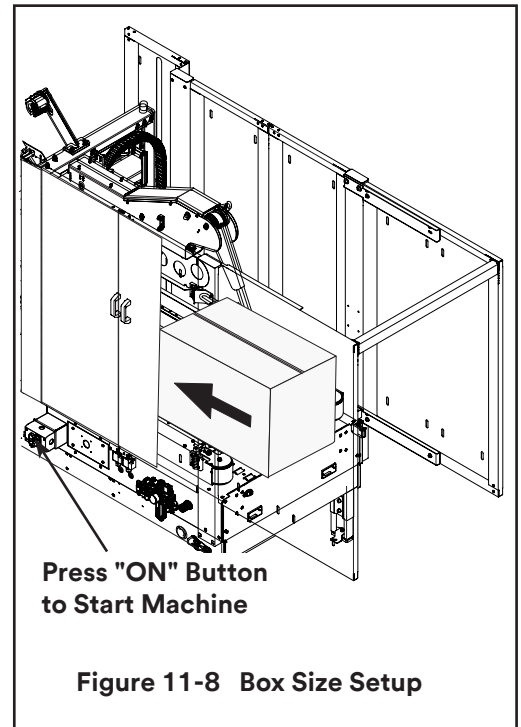


Figure 11-8 Box Size Setup

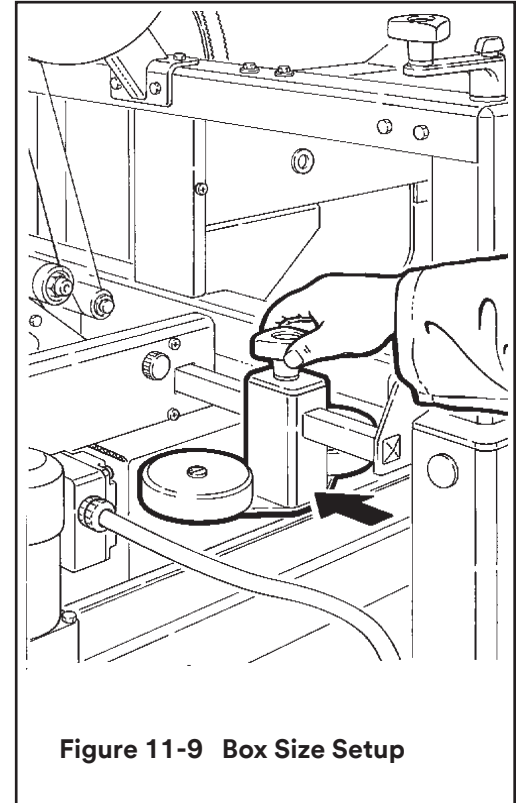


Figure 11-9 Box Size Setup

11. Operation *(continued)*

Figure 11-10

Run several test boxes through the machine, and observe the flap kicking action. Adjust the kicker cam so the kicker "kicks" earlier or later as required (refer to figure 11-10). In general, it is better to set the kicker to "kick" early because it contacts the flap higher above the score-line which results in more reliable flap folding.



Warning

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

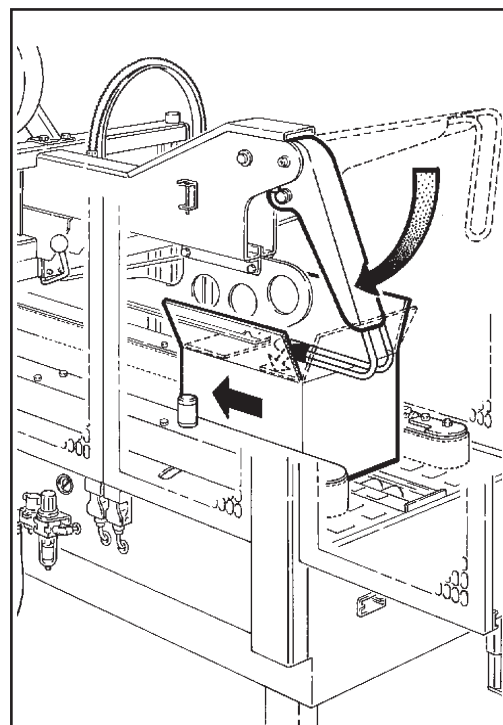


Figure 11-10 Box Size Setup

Figure 11-11

The upper side flap folding guides can be adjusted in or out to accommodate the width of the box. For optimum performance, the side flap folding guides should be adjusted to the narrowest position which allows them to catch any side flaps that may be bent outward past vertical.

Note – Box flaps should not be bent outward past vertical more than 15° when entering case sealer.

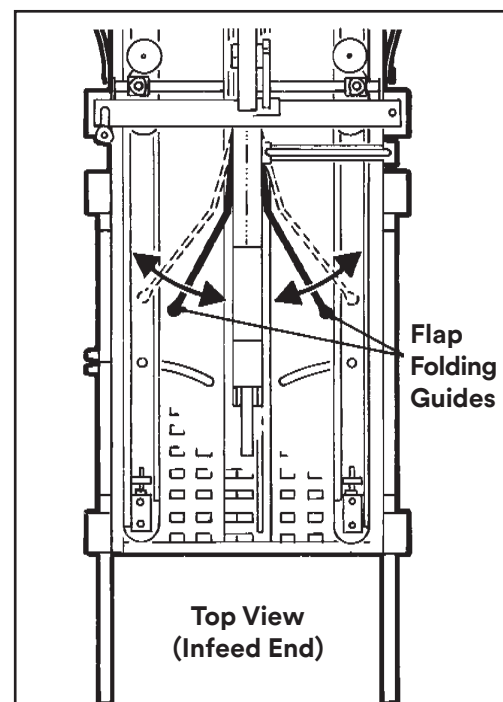


Figure 11-11 Box Size Setup

11. Operation *(continued)*

Figure 11-12

If the box is hard to move under the top head or is crushed, raise the top head slightly.

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

Note: Upper head has unique feature for overstuffed boxes. The head will raise up to 13mm [1/2 inch] to compensate for this type of condition.

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

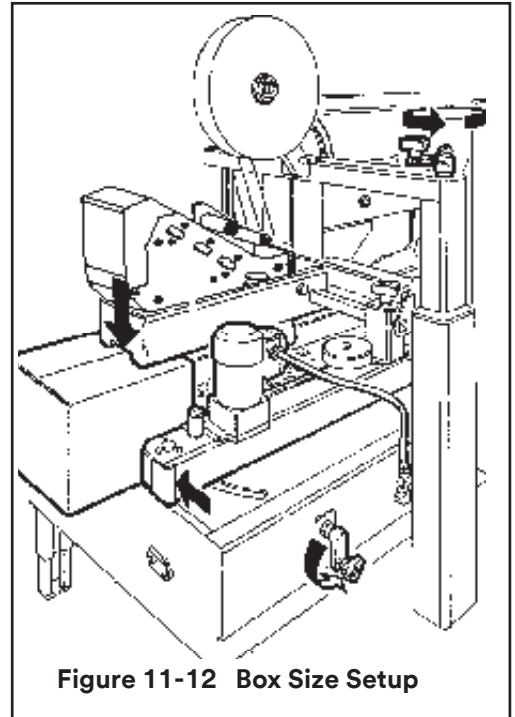


Figure 11-12 Box Size Setup

11.4 Box Sealing



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.

1. Connect electrical and air supplies.
2. Turn main air valve "On" and adjust air regulator if pressure does not read 5 bar gauge pressure [70 PSIG].
3. Press electrical "On" button to start drive belts.
4. Continually feed boxes to case sealer, case sealer will automatically space entrance of boxes to machine.
5. Turn electrical and air supplies "Off" when machine is not in use.
6. Reload and thread tape as necessary.
7. Be sure machine is cleaned and lubricated according to recommendations in "Maintenance" section of this manual.

Notes:

1. Box drive motors are designed to run at a moderate temperature of 40° C [104° F]. In some cases they may feel hot to the touch.
2. Adjustment of the machine or taping heads are described in the "Adjustment" section of this manual.

11. Operation *(continued)*

11.5 Box Jams

If a box is improperly fabricated or filled, if the machine is improperly adjusted for the box being run, or if boxes enter the machine incorrectly, a box jam may occur. To clear a box jam, follow these steps:

1. Determine cause of box jam so corrective action can be taken to prevent reoccurrence.

Important - be sure to wait for the flap kicker to reach down position to avoid being hit or startled by its movement.

2. Turn off machine.



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.

3. Crank upper head up and/or drive belts out until box is free.

4. Carefully pull box out of machine.



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.

5. Readjust upper head and drive belts according to "Machine Adjustment for Box Size" instructions.

6. Connect air and electrical supplies.

7. Turn machine "On" (I).

12. Maintenance

The case sealer been designed for long, trouble- free service. The machine will perform best when it receives routine maintenance and cleaning. Machine components that fail or wear excessively should be promptly repaired or replaced to prevent damage to other portions of the machine or to the product.



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.

Note – Never attempt to remove dirt by blowing it out with compressed air. This can cause the dirt to be blown inside the motor and onto sliding surfaces which may cause premature equipment wear. Never wash down or subject equipment to conditions causing moisture condensation on components. Serious equipment damage could result.

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

12.1 Cleaning

Regular slotted containers produce a great deal of dust and paper chips when processed or handled in equipment. If this dust is allowed to build up on machine components, it can cause component wear and overheating of drive motor.

The dust build-up can best be removed from the machine by a shop vacuum. Depending on number and type of boxes sealed, this cleaning should be done approximately once per month. If the boxes sealed are dirty, or environment in which the machine operates is dusty, cleaning on a more frequent basis may be necessary. Excessive dirt buildup that cannot be removed by vacuuming should be wiped off with a damp cloth.

12.2 Lubrication

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

Figure 12-1 illustrates the areas of the case sealer that require lubrication. Lubricate points indicated by arrows with Synthetic Silicone.

TAPING HEAD LUBRICATION – See "Maintenance – Lubrication".

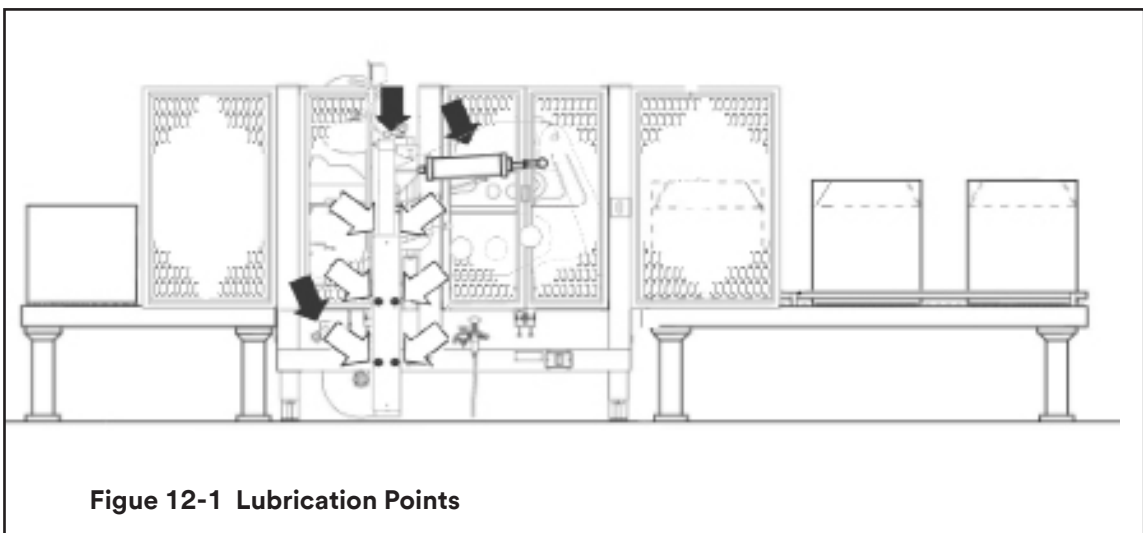


Figure 12-1 Lubrication Points

12. Maintenance *(continued)*



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.

12.3 Drive Belt Replacement/Tension Adjustment

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

REPLACEMENT – STEPS 1-11

TENSION ADJUSTMENT – STEPS 1, 2, 4-6, 10 & 11

Figure 12-2

1. Raise upper taping head to its fully raised position.
2. Disconnect motor plug (A).
3. Remove and retain the six screws (B) and side cover (C).
4. Remove and retain screws (D), cap washers (E) and spacers (F) from the front and rear arm assembly pivots.
5. Lift belt assembly (G) up and off arm assembly pivots.

Note – Keep motor in vertical position to prevent gear oil from leaking out of motor.

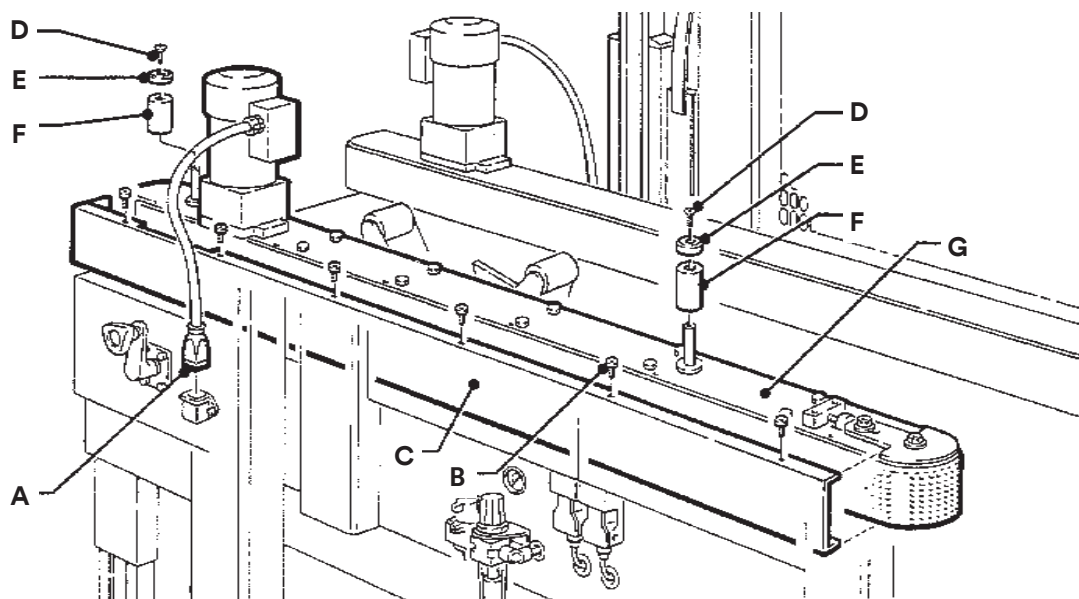
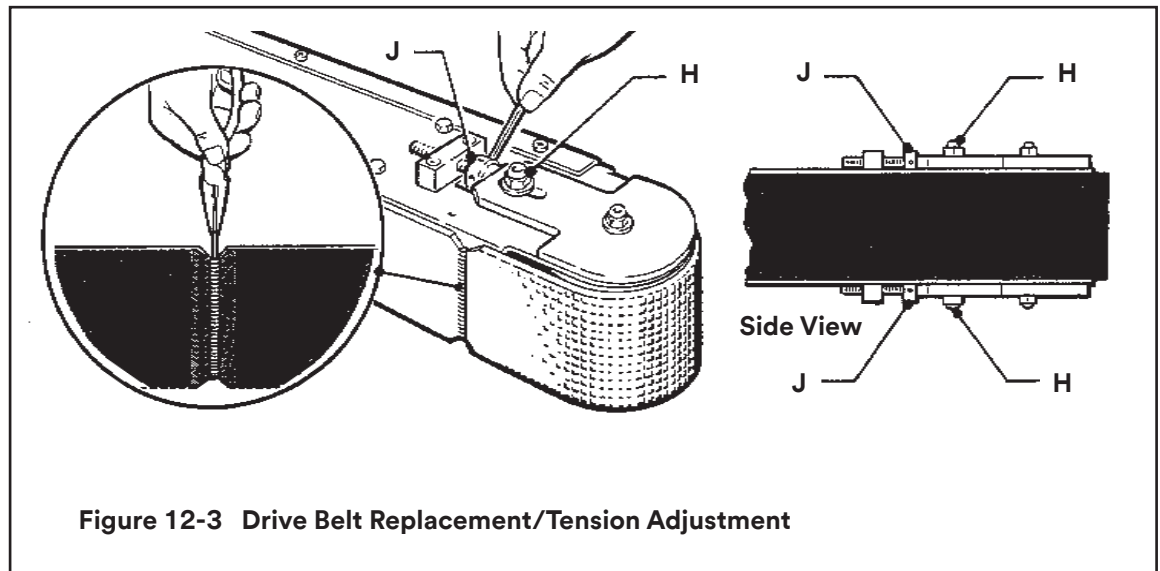


Figure 12-2 Drive Belt Replacement

12. Maintenance *(continued)*



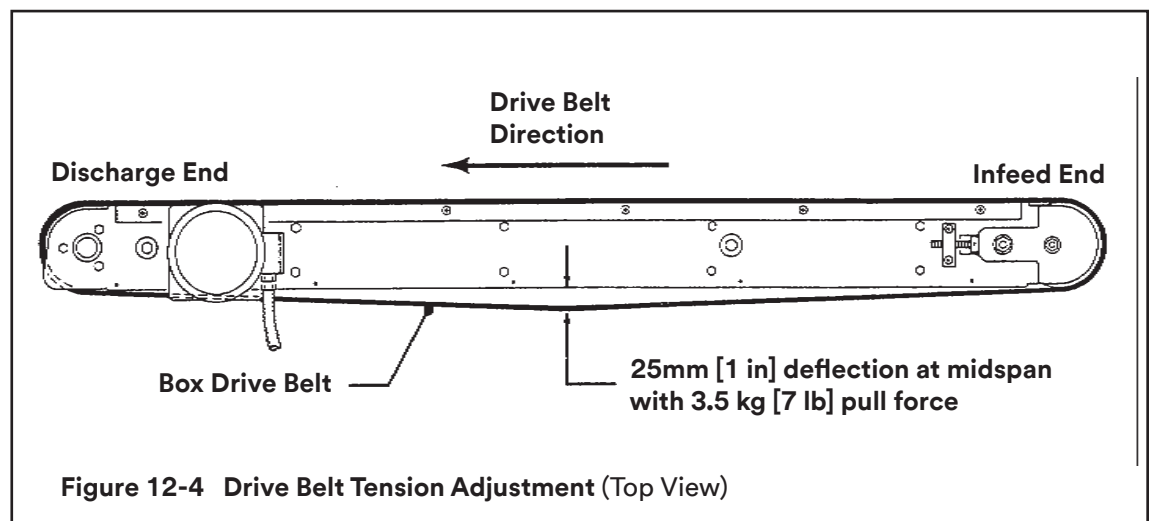
9. **Important** – Before installing new drive belt, check belt inside surface for drive direction arrows and install belt accordingly. If no arrows are shown, belt may be installed either way.

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

10. Set drive belt tension – turn adjustment screws (J) equally on both upper and lower tension assemblies. Turn screws clockwise to reduce belt tension, counterclockwise to increase tension.

Use force gauge to pull belt outward one inch [25mm] at midspan, as shown in Figure 12-4, with a moderate pulling force of 7 lbs. [3.5 kg]. Tighten lock nuts (H) on both tension assemblies to secure tension setting.

11. Assembly is reverse of disassembly.



12. Maintenance *(continued)*



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.

12.4 Air Line Filter (Figure 12-5)

Periodically check the air line filter to drain water and clean as necessary. Do not allow water to go above the filter element.

12.5 Circuit Breaker

The case sealer is equipped with a circuit breaker which trips if the motors are overloaded. Located inside the electrical control box on the side of the machine, the circuit breaker has been preset 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. Wait two minutes.
3. Press machine “On” (I) button, on the side guard, to resume case sealing.

12.6 Blade Replacement, Taping Head

See , “Maintenance – Blade (Blade) Replacement”.

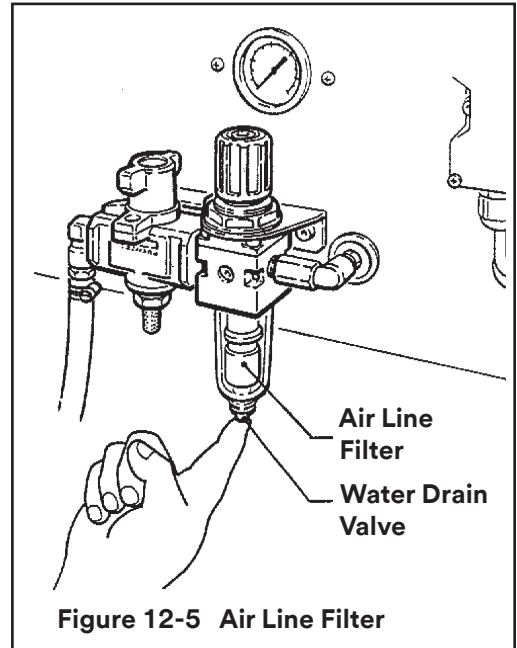


Figure 12-5 Air Line Filter



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 sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp.

13. Adjustments



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.

13.1 Gate Operation (Figure 13-1)

- A – Permanent gate cam
- B – Removable gate cam
- C – Kicker cam

The 8000af-8000af3 is shipped with both gate cams A and B installed. With both cams the entire range of box lengths can be run (150-760mm [6-30 inches]). However if only boxes longer than 305mm [12 inches] will be run, cam B can be removed to increase the production rate. Refer to the box rate chart in specification section.

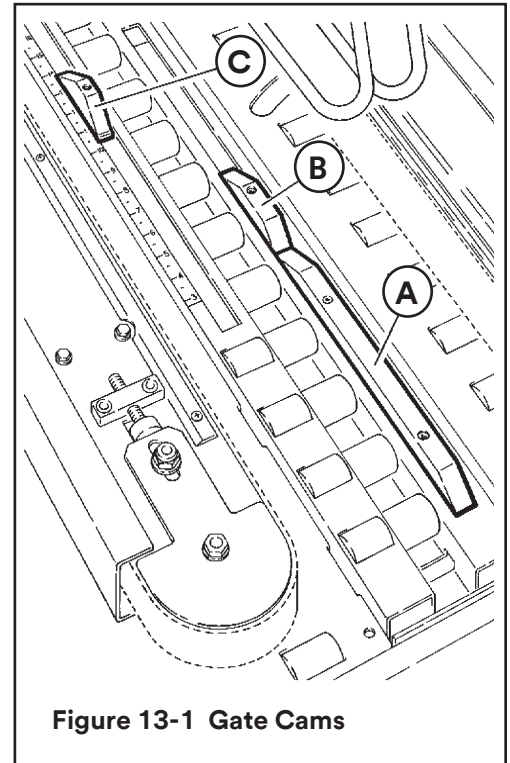


Figure 13-1 Gate Cams

13.2 Drive Belt Tension

Belt tension must be adequate to positively move boxes through the machine and belts should run fully on the surface of the pulleys at each end of the frame. The idler pulleys on the infeed end are positioned by tension adjustment screws. To adjust tension, see "Maintenance – Drive Belt Replacement/ Tension Adjustment".

13.3 Taping Head Adjustments – Refer to taping head a manual

Tape Web Alignment

Tape Drum Friction Brake

Applying Mechanism Spring

One-Way Tension Roller

Tape Leg Length Adjustment

13. Adjustments *(continued)*



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.

13.4 Upper Taping Head Leveling

If the upper taping head is not horizontal, it can be leveled by adjusting the self-locking nut.

1. Loosen the five (5) bolts on each side of crossbar shown in Figure 13-2A.
2. Remove access cover as shown in Figure 13-2B and (using M13 hex key wrench) tighten or loosen M8 self-locking nut until upper head is level.
3. Take measurement from exit end of upper head assembly and front of flap folding ski to machine bed, as shown in Figure 13-2. Upper assembly must be level $\pm 1.5\text{mm}$ [$\pm 1/16$ inch].
4. Retighten five (5) bolts on each side of crossbar to secure adjustment.

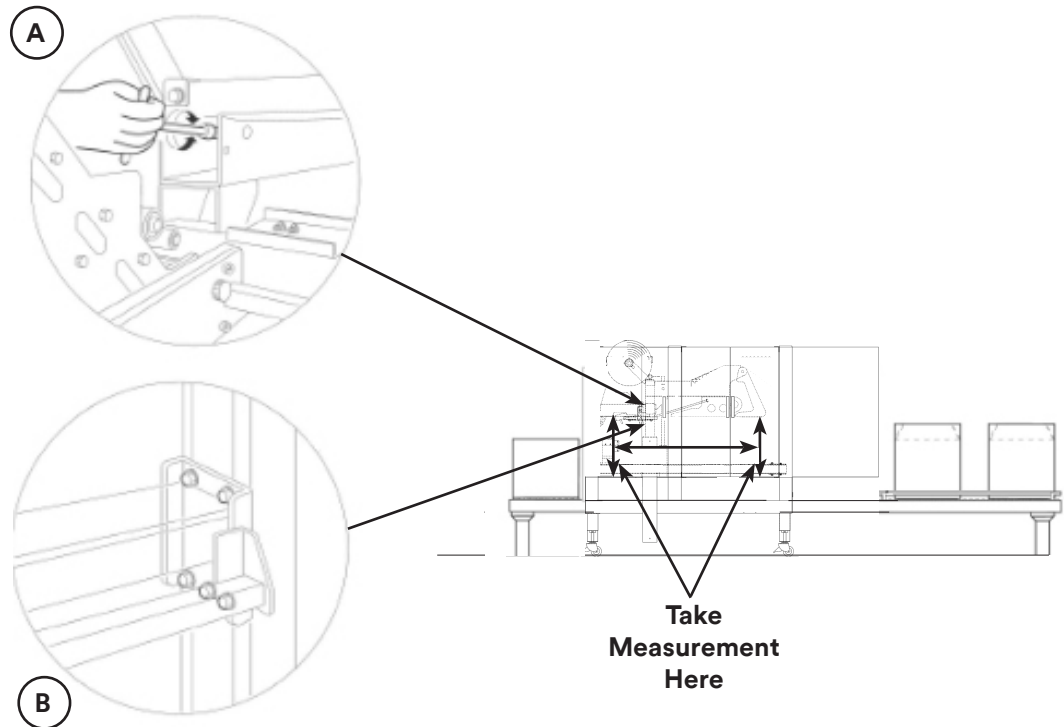


Figure 13-2 Upper Taping Head Leveling

13. Adjustments *(continued)*



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.

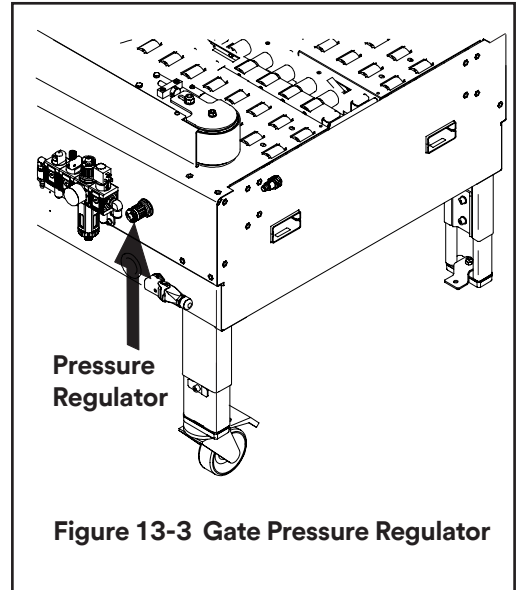


Figure 13-3 Gate Pressure Regulator

13.5 Gate Pressure Regulator (Figure 13-3)

The gate air pressure is controlled by a regulator mounted under the machine frame. This provides adjustment of the gate lifting force. When lightweight boxes are being run, the gate pressure can be reduced to minimize lifting of the box.

13.6 Gate Stroke Setting (Figure 13-4)

The machine is initially set at the maximum gate lift of 25mm [1 inch]. This can be reduced if needed for special situations. To do this, remove the center roller section and turn the stop nuts clockwise until the desired lift is achieved.

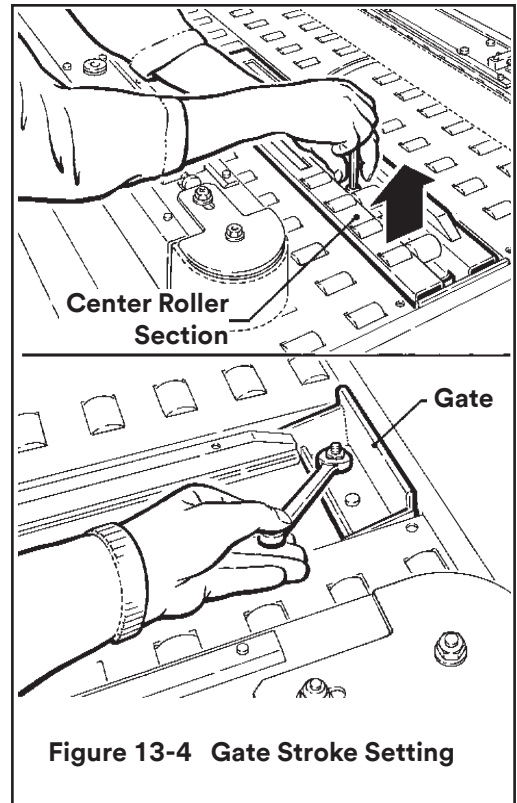


Figure 13-4 Gate Stroke Setting

14. Special Set-Up Procedure



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.

14.1 Changing Drive Belt Height

The drive belt assemblies can be raised 50.8 mm [2 inches] to provide better conveying of tall boxes. This change increase minimum box height that can be taped to 190mm [7.25 inches].

Disassembly – Figure 14-1

1. Using the height adjustment crank, raise upper taping head to its fully raised position.
2. Remove and retain the M6 × 16 flat head cap screw (A), special washer (B) and spacer (C) from the front and rear arm assembly pivots.
3. Lift drive belt assembly (D) up off the arm assembly pivots.

Note – Keep motor in vertical position to prevent gear oil leaking out of motor.

Reassembly – Figure 14-2

4. Reassemble the spacer (C) onto the front and rear arm assembly pivots.
5. Install the belt drive assembly (D) onto the pivots and secure with special washers (B) and M6 × 16 flat head cap screws (A).

Note – Both drive belt assemblies must be installed at same operating height.

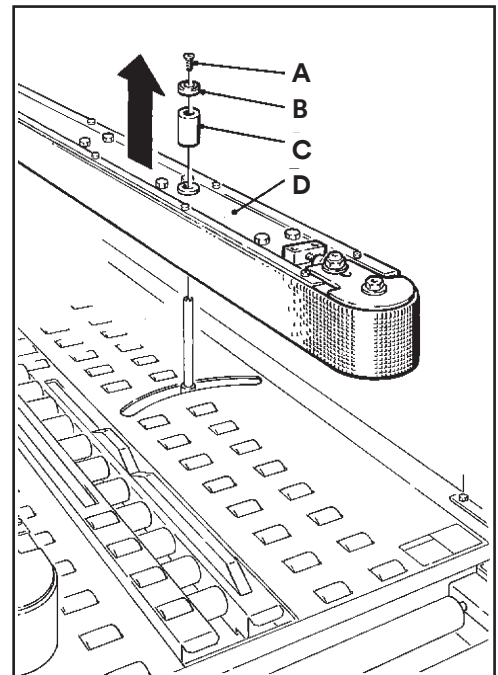


Figure 14-1 Drive Belt Height, Disassembly

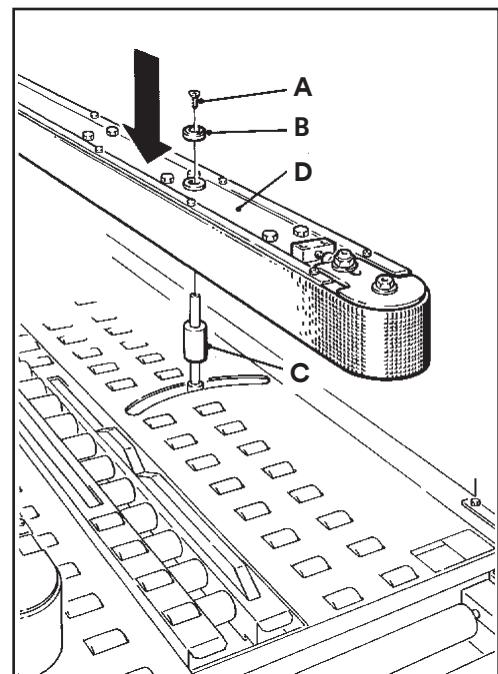


Figure 14-2 Drive Belt Height, Reassembly

14. Special Set-Up Procedure *(continued)*

14.2 Changing the Tape Leg Length

Refer to taping head manual

Case Sealer Frame

1. Crank upper taping head frame up high enough to allow clearance for removal of lower taping heads.
2. Remove the stop bracket (Figure 14-3C) from normal position "A" and fasten in lower position "A-A". Relocate stop brackets on both columns.

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.

Important – Taping heads weigh approximately 7.2 kg [16 lbs]. Use proper body mechanics when lifting or holding taping head.

3. Lift lower taping head, shown in Figure 14-3B, straight up to remove it from machine bed.
4. Refer to , "Adjustments – Changing Tape Leg Length" for taping head setup.
5. Replace taping heads in case sealer, reverse of disassembly.

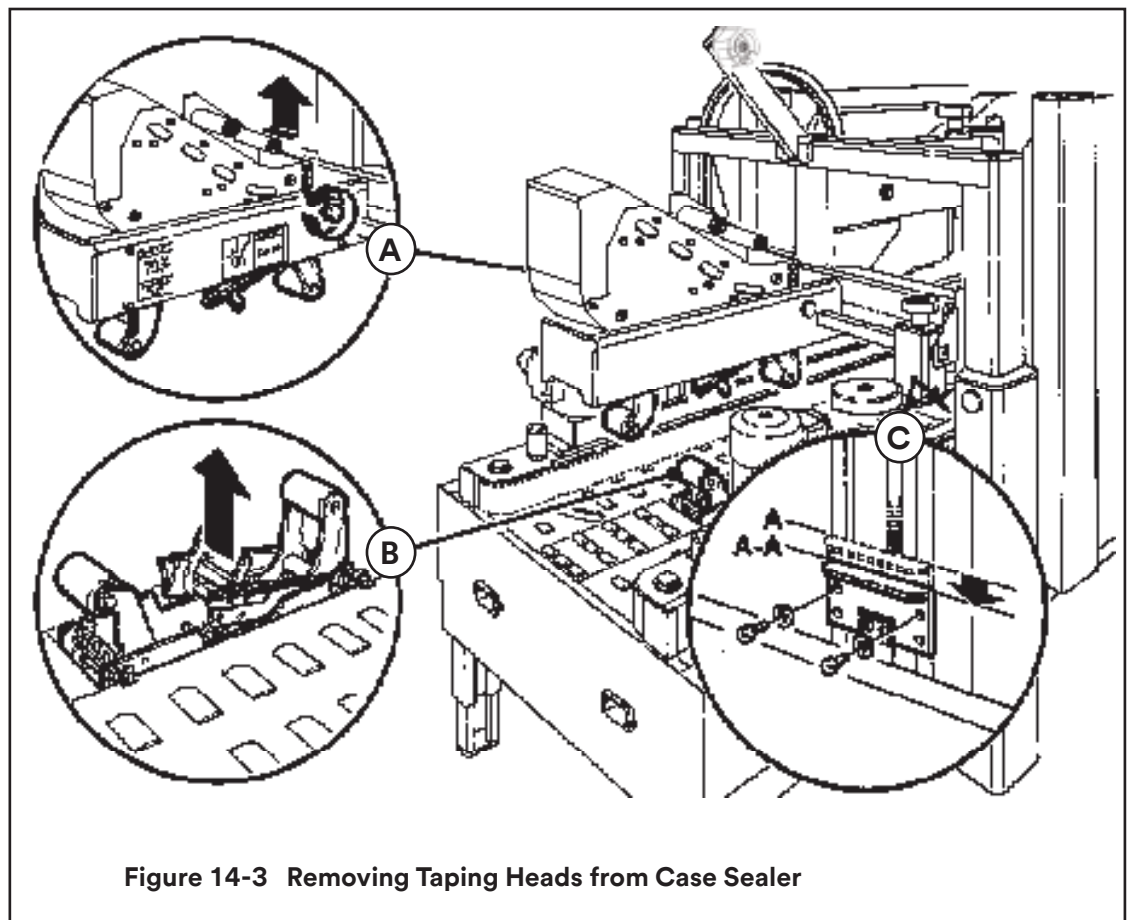


Figure 14-3 Removing Taping Heads from Case Sealer

14. Special Set-Up Procedure *(continued)*

14.3 Outer Column Re-Positioning (Refer to Figure 14-4)

Moving the outer columns up one set of mounting holes increases the maximum box size handled by the case sealer from 620mm [24.5 inches] to 725mm [28.5 inches].

Important – It is recommended that no less than two people assist on this setup or severe injury or equipment damage could result.

To move the outer columns up one set of mounting holes:

1. Crank side drive belts to full open position.
2. Crank upper taping head frame assembly up approximately 330mm [13 inches] from machine bed.
3. Place solid blocks approximately 305mm [12 inches] high beneath upper taping head frame at rear of taping head and under front flap folding ski (Figure 14-4A).

Note – Blocks (front and rear) must be the same height in order to keep upper frame level.

4. Crank upper taping head frame down until weight of upper frame is fully on blocks.
5. Remove and retain six mounting screws in each outer column assembly (Figure 13-4B).

Important - A second person should assist with this part of setup to hold (steady) upper frame until columns are re-positioned and column screws are installed and tightened.

6. Crank outer column up 100mm [4 inches] and re-install six (6) screws in each column. Tighten screws.
7. Crank upper taping head up and remove blocks.
8. Check horizontal alignment of upper taping head frame and adjust as described in “Adjustments – Upper Taping Head Leveling”.

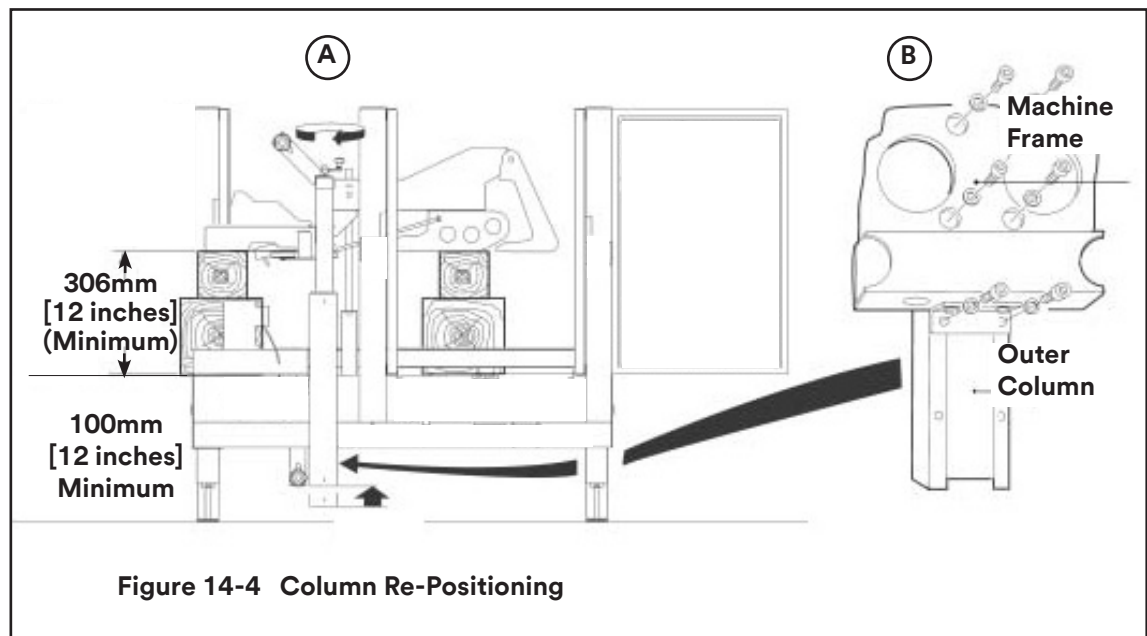


Figure 14-4 Column Re-Positioning

14. Special Set-Up Procedure (continued)

14.4 List of the Maintenance Operations

Date:

Description of Operation

[illegible]

15. Troubleshooting

The Troubleshooting Guide lists some possible machine problems, causes and corrections. Also see "Troubleshooting" pages for taping head problems.

Note – Adjustment of the machine or taping heads are described in "Adjustments".

15.1 Troubleshooting Guide

Problem	Cause	Correction
Drive belts do not convey boxes	Worn drive belts	Replace drive belts
	Top taping head does not apply enough pressure	Adjust the box height adjustment with the crank
	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
	Energy Stop Button engaged	Insert box in machine to re-start
Drive belts break	Worn belt	Replace belt
Squeaking noise as boxes pass through machine	Dry compression bearings	Lubricate compression bearings
	Dry column bearings	Lubricate column bearings
Tape not centered on box seam	Centering guides not centered	Adjust centering guides
	Box flaps not of equal length	Check box specifications
Flap kicker kicks at wrong time	Kicker cam improperly set	Reposition kicker cam
	Air cylinder flow controls out of adjustment	Readjust flow controls
Gate does not raise to stop next box	Too much air pressure on gate cylinder lifts box off of gate cam	Reduce gate air pressure using regulator
	Incoming boxes not low enough and therefore not actuating cam	
Gate retracts too soon/ kicker does not kick	The removable portion of the gate cam has been removed and boxes shorter than 12 inches are being run	Reinstall removable gate cam portion

16. Additional Instructions

16.1 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.

16.2 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).

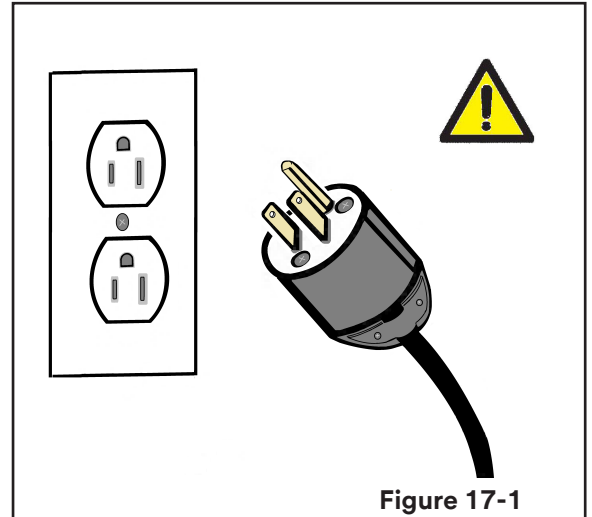


Figure 17-1

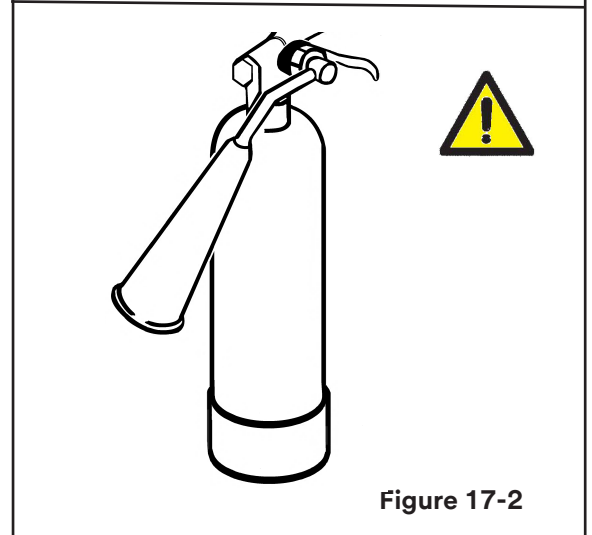


Figure 17-2

17. Additional Information

17.1 Statement of Conformity

N/A

17.2 Emission of Hazardous Substances

Nothing to report

18. Technical Diagrams

18.1 Electric Diagrams - 1 Phase 115V 60Hz

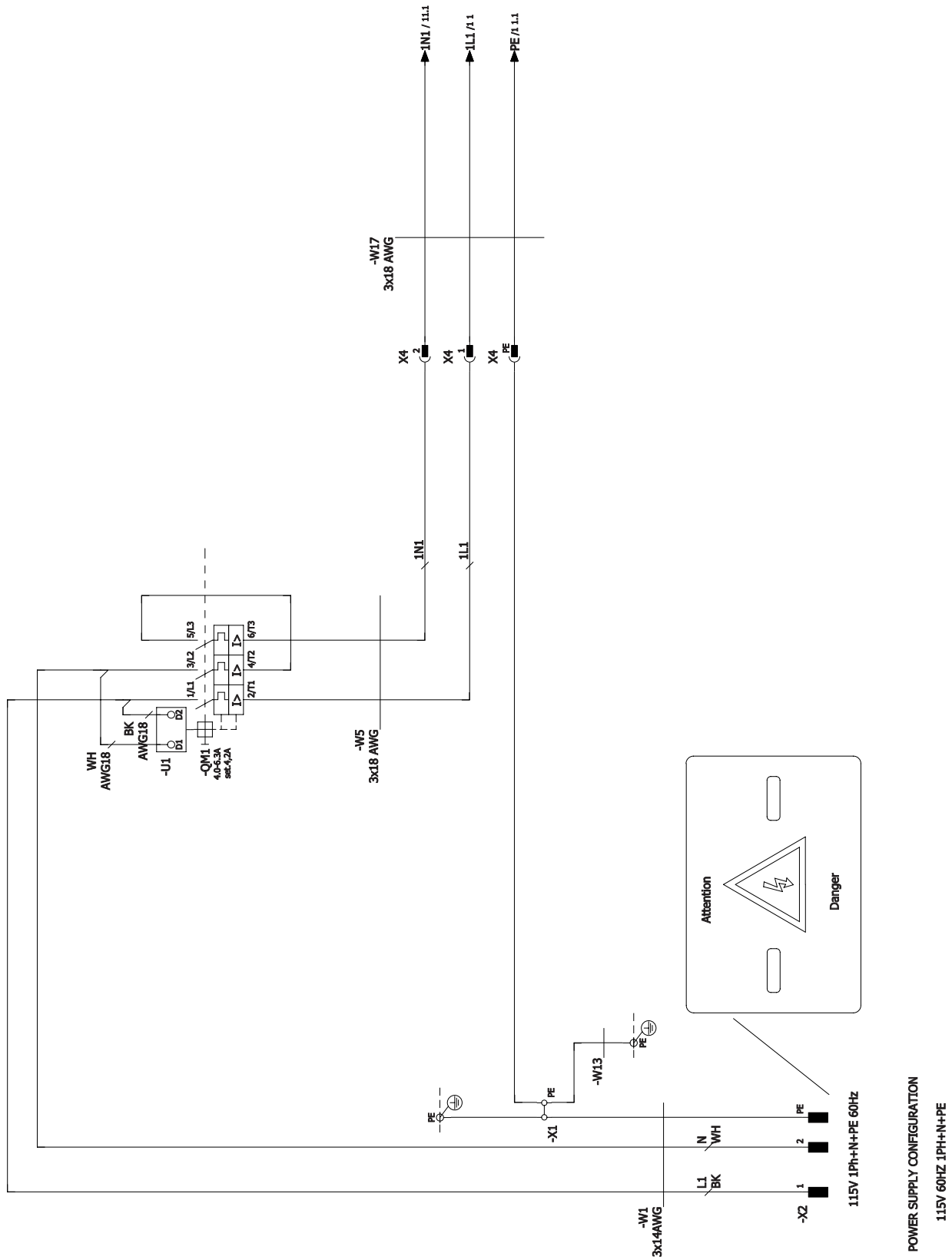
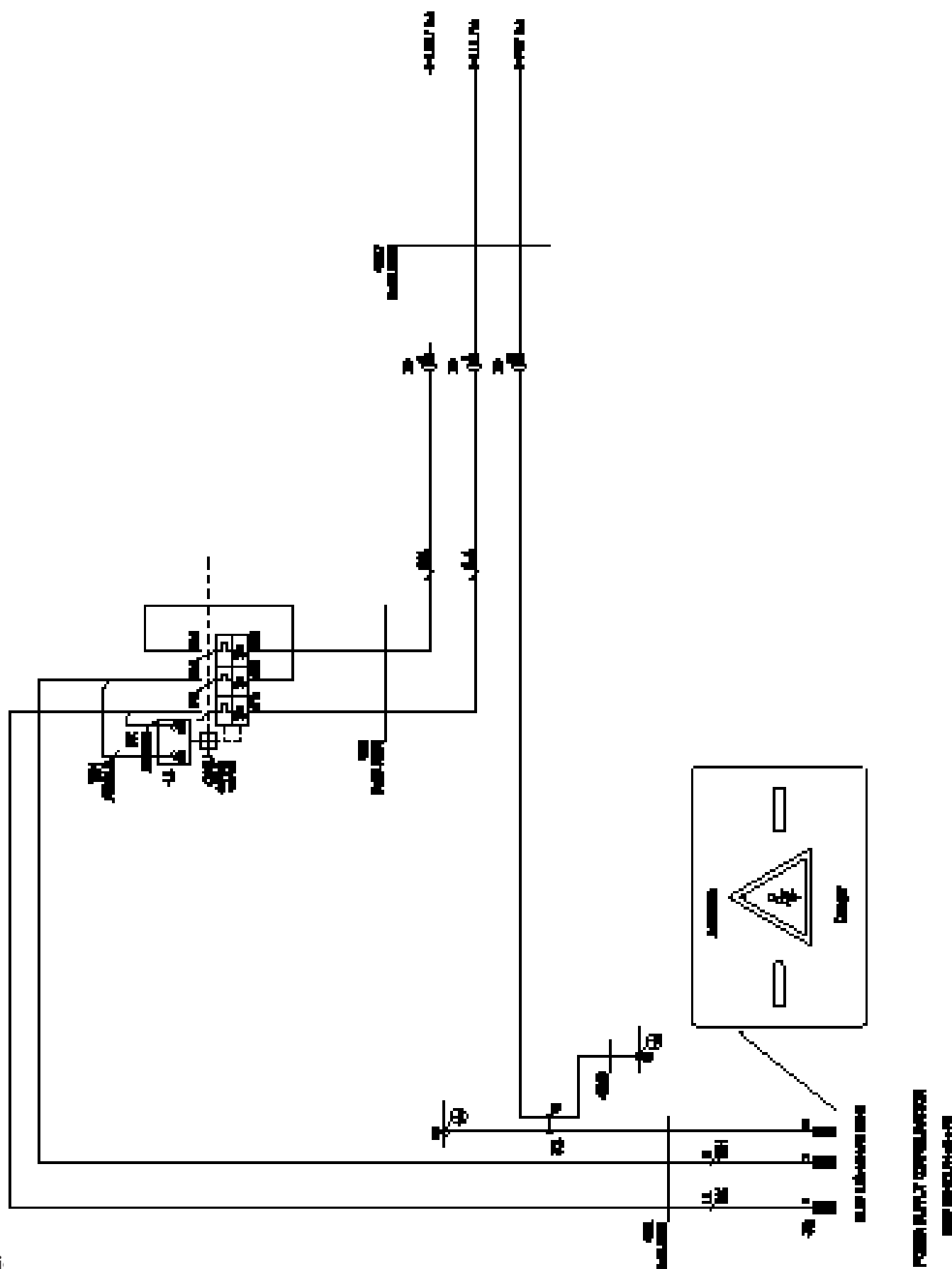


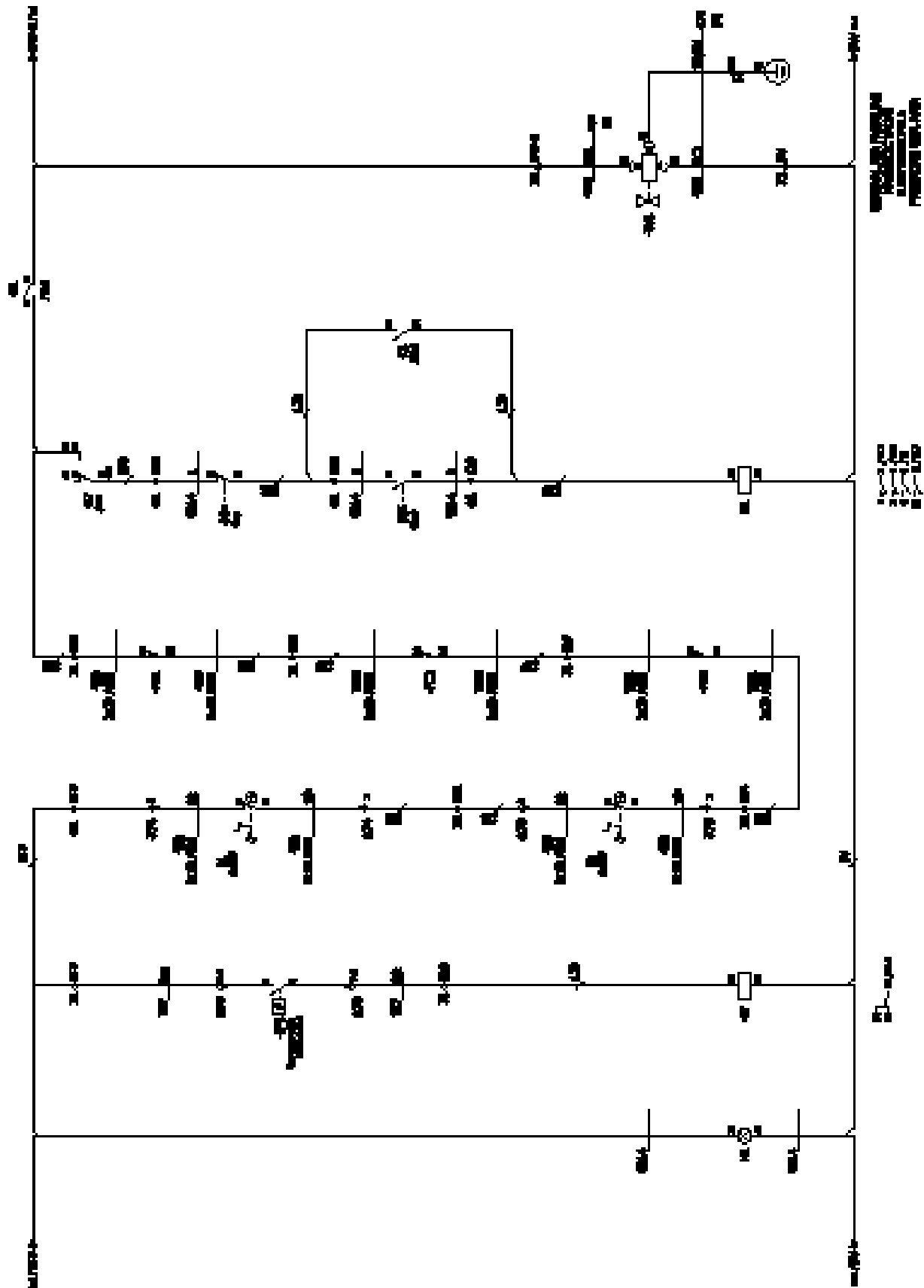
Figure 18-1 Electrical Diagram / 1 Phase 115V 60Hz

18. Technical Diagrams



18. Technical Diagrams

18.1 Electric Diagrams - 1 Phase 115V 60Hz



18. Technical Diagrams

18.1 Electric Diagrams - 1 Phase 115V 60Hz

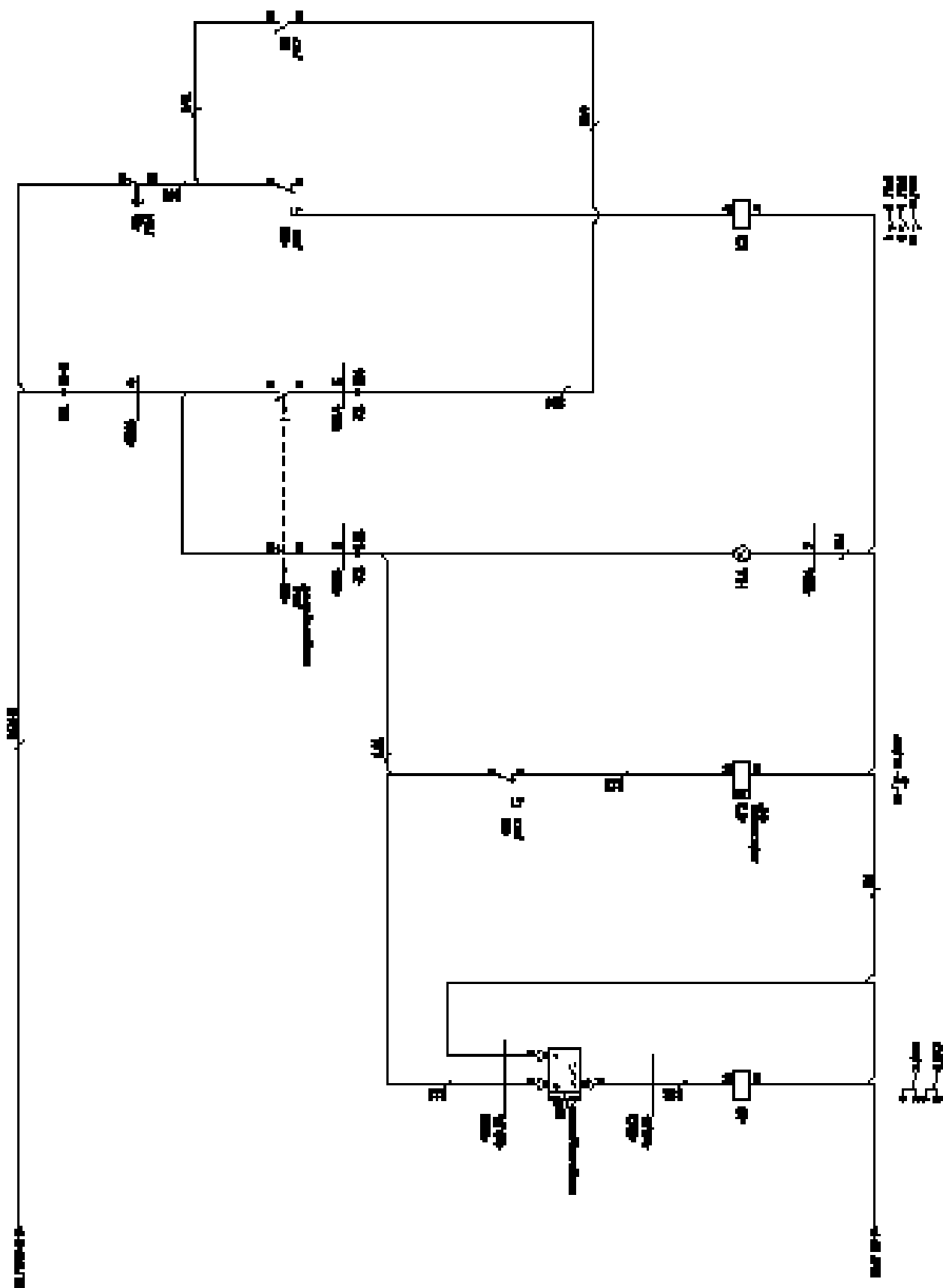


Figure 18-1 Electrical Diagram / 1 Phase 115V 60Hz (continued)

18. Technical Diagrams

18.1 Electric Diagrams - 1 Phase 115V 60Hz

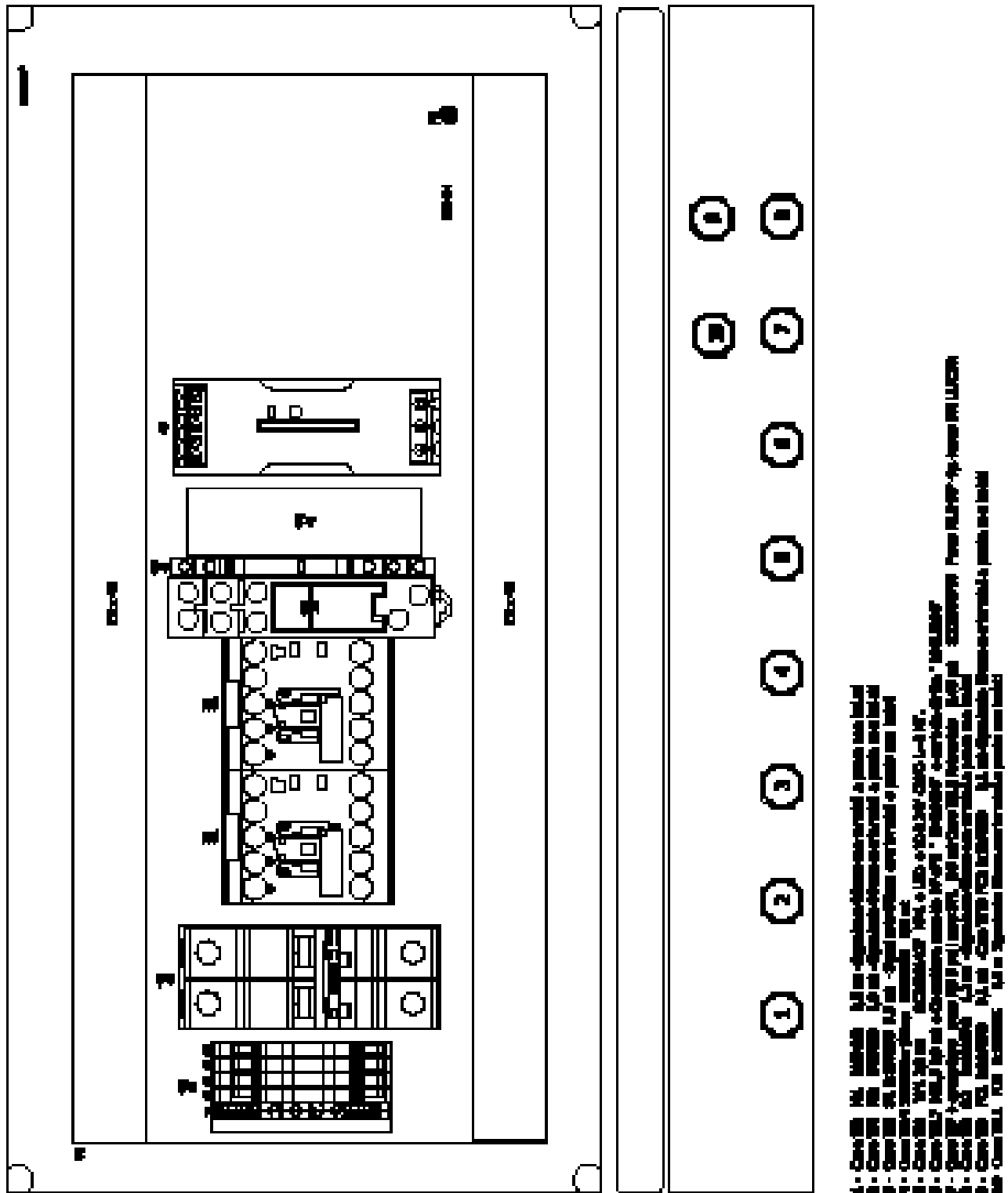
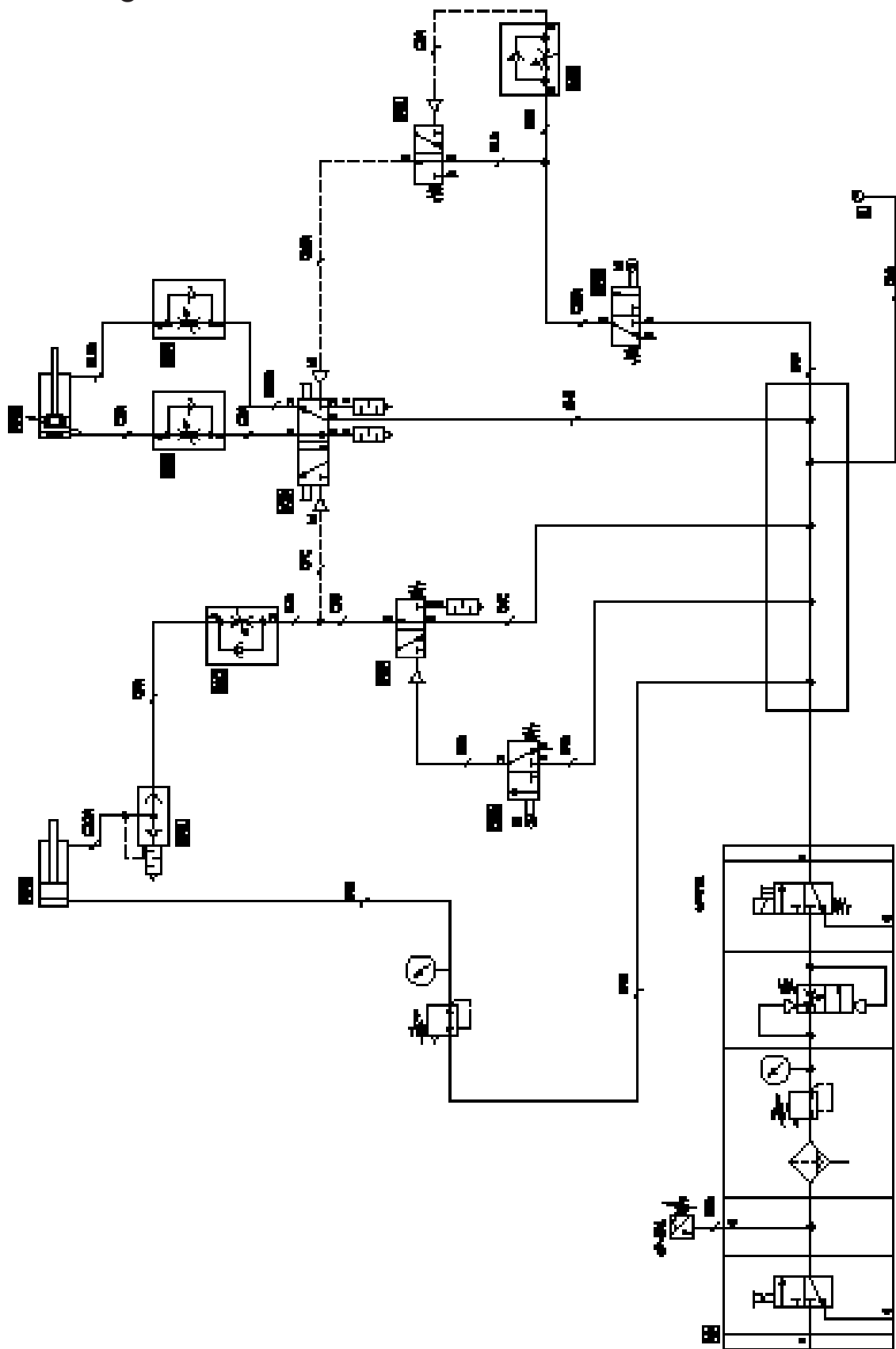


Figure 18-1 Electrical Diagram / 1 Phase 115V 60Hz *(continued)*

18. Technical Diagrams

Figure 1:



19. Spare and Miscellaneous Parts

19.1 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 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 – 8000af-8000af3 Adjustable Case Sealer

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

8000af-8000af3

Qty.	3M-Part Number	Description
2	78-8076-4865-0	Belt-Drive w/Hook

19.2 Labels

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

19.3 Tool Kit

A tool kit, part number 78-8060-8476-6, 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.

19.4 Replacement Parts Ordering Information and Service

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

20. Optional Accessories

8000af Adjustable Case Sealer, Type 32600 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
78-8069-3983-7	Caster Kit Attachment
78-8069-3926-6	Low Tape Sensor Kit
70-0064-4963-4	AccuGlide™ 3 Upper Taping Head 2 inch, Type 10800
70-0064-4962-6	AccuGlide™ 3 Lower Taping Head 2 inch, Type 10800
70-0064-4965-9	AccuGlide™ 3 Upper Taping Head 3 inch, Type 10800
70-0064-4964-2	AccuGlide™ 3 Lower Taping Head 3 inch, Type 10800
70-0064-1097-4	Tape Monitor Kit (TAM)
78-8095-4854-4	2 Inch Tape Edge Fold - Top
78-8095-4855-1	2 Inch Tape Edge Fold - Bottom

20. Options / Accessories *(continued)*

Replacement Parts – Illustrations and Parts Lists

8000af-8000af3 Adjustable Case Sealer, Type 32600 (2 or 3 Inch Width Taping Heads)

Frame Assemblies

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

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

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

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

