

Instructions

3M-Matic™ 7000r-7000r3 Pro

Type 32600

Random 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™ 7000r-7000r3 Pro Random case sealer.

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

Edition 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 7000r -7000r3 - Type 32600 - 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

	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			
	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 available 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.**

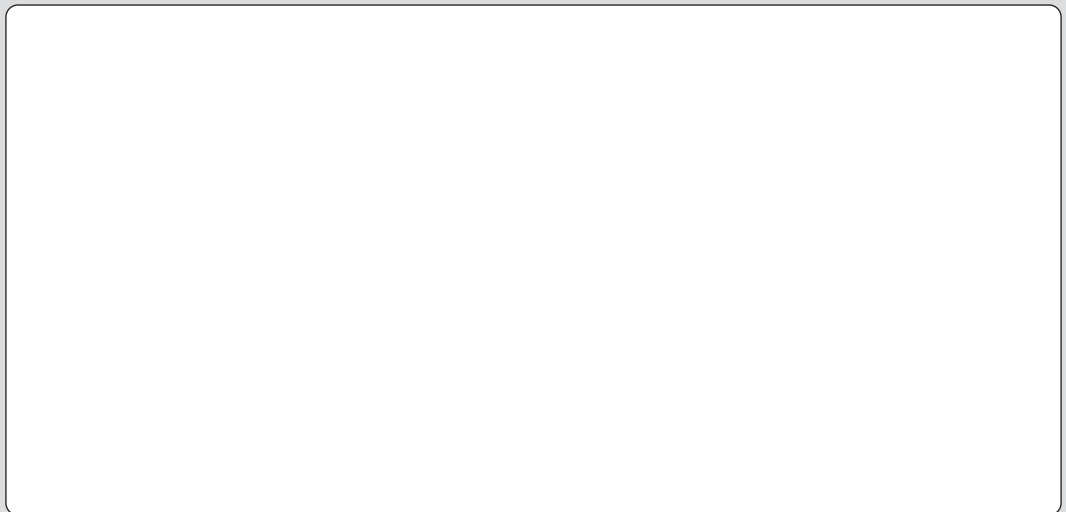
Replacement parts and service information

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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7000r-7000r3 Pro Random Case Sealer

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Taping Head Information: (See applicable taping head manual)

Abbreviations and Acronyms

List of Abbreviations/Acronyms

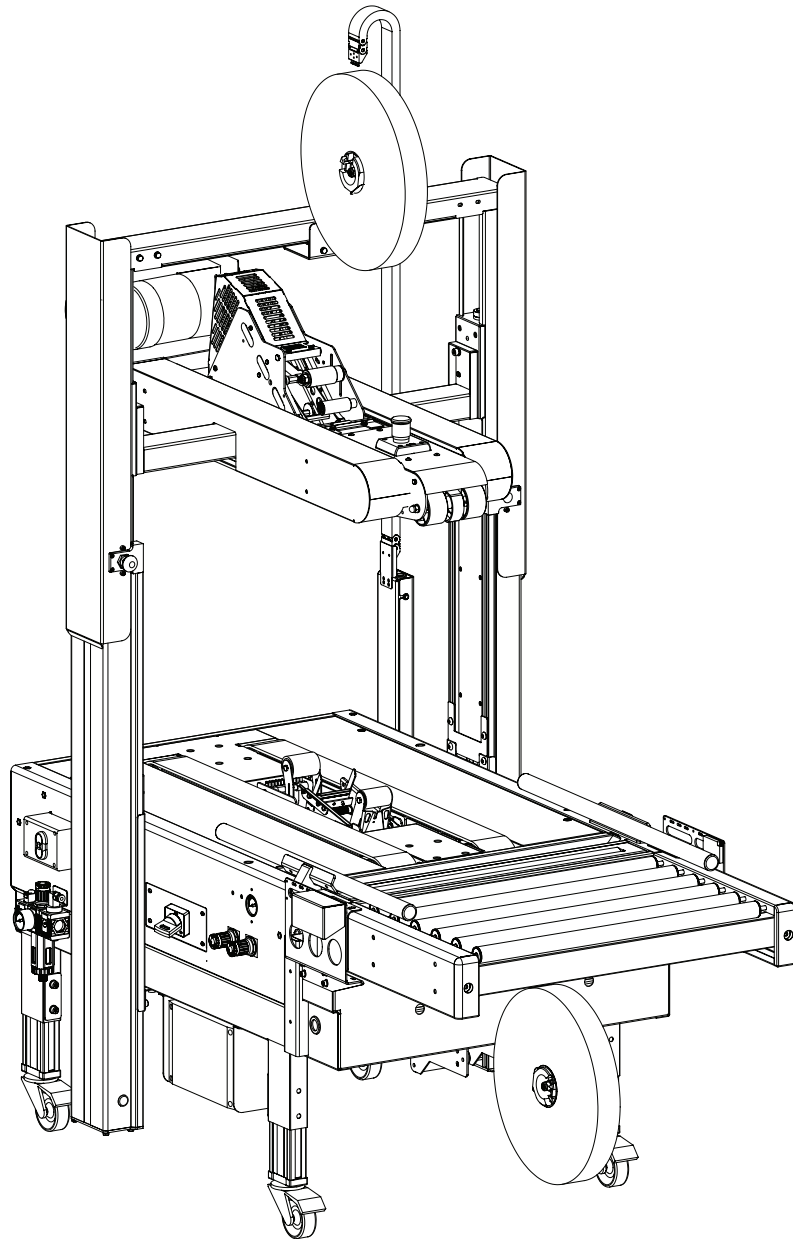
3M-Matic	Trademark of 3M St. Paul, MN 55144-1000
AccuGlide	Trademark of 3M St. Paul, MN 55144-1000
Scotch	Trademark of 3M St. Paul, MN 55144-1000
Drw.	Drawing
Ex.....	For Example
Fig.	Exploded View Figure no. (spare parts)
Figure.....	Illustration
Max.	Maximum
Min.....	Minimum
Nr.....	Number
N/A.....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

1. Introduction

1.1 Manufacturing Specifications / Description / Intended Use

The 3M-Matic™ 7000r-7000r3 Pro Random 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 7000r-7000r3 Pro automatically adjusts to a wide range of box sizes (see “Specifications Section – Box Weight and Size Capacities”).

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



3M-Matic™ 7000r-7000r3 Pro Random Case Sealer, Type 32600

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™ 7000r-7000r3 Pro Random Case Sealer.

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

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Publication © 3M 2026. 44-0009-2133-6.

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:

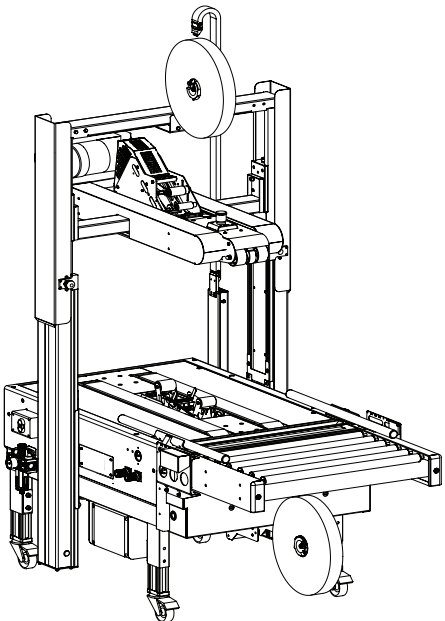


1.2.4 How to Update the Manual in Case of Modifications to the Machine

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



Identification Plate

3M	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	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 Scelleuse de caisses aléatoire 3M-Matic™ 7000r-7000r3 Pro., 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: Scelleuse de caisses aléatoire 7000r-7000r3 Pro.

- (1) Scelleuse de caisses aléatoire 7000r-7000r3 Pro., Type 32600
- (1) Tool/Spare Parts Kit
- (1) Instruction and Parts Manual

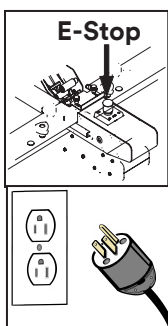
3. Safety

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.



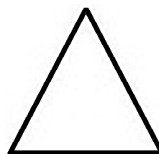
Caution

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

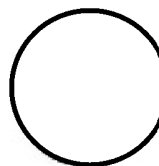


Warning

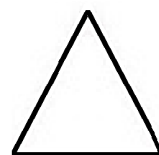
Indicates a potentially hazardous situation, which, if not avoided, could result in death or serious injury and/or property damage.



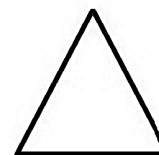
Caution
Prohibition



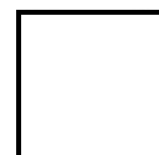
Information



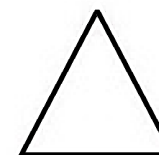
Electrical Supply Disconnect before work or servicing machine



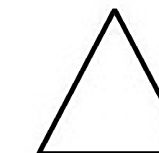
Warning!
Sharp knife



Emergency Stop (Latching)



Keep hands out of moving parts



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 pneumatic and electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.



Warning

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



Figure 3-2

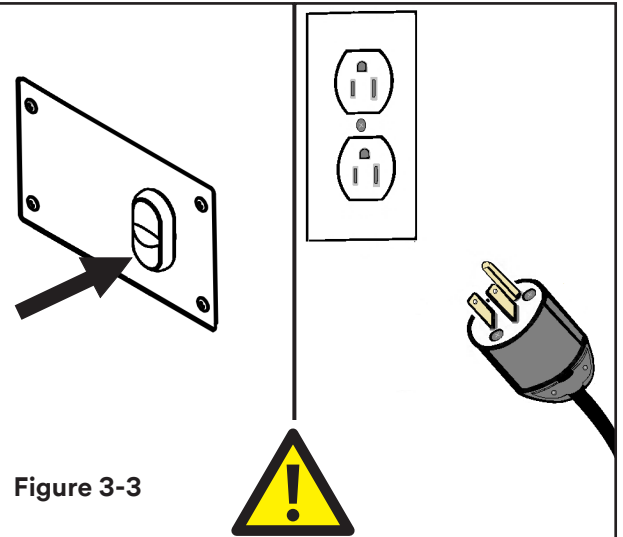


Figure 3-3

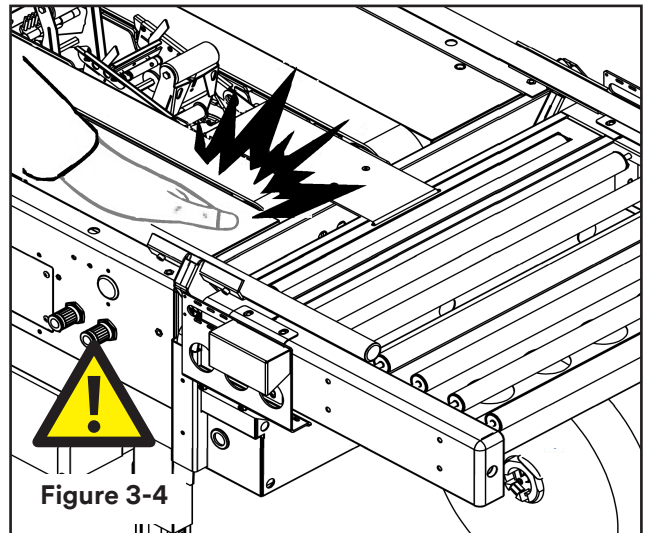


Figure 3-4

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

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.

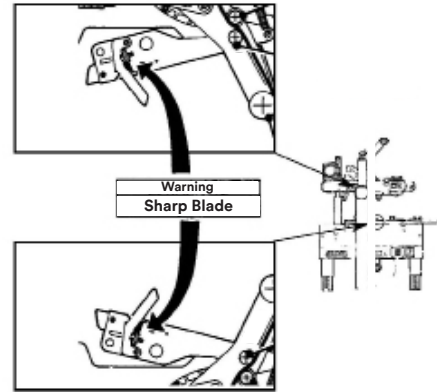


Figure 3-5

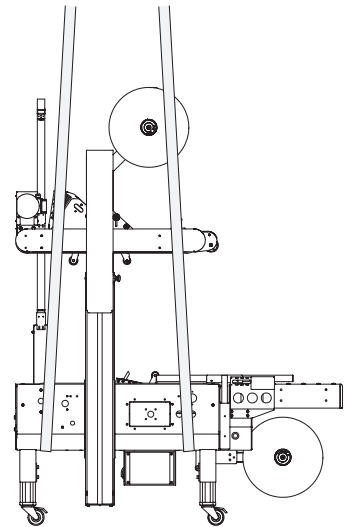


Figure 3-6

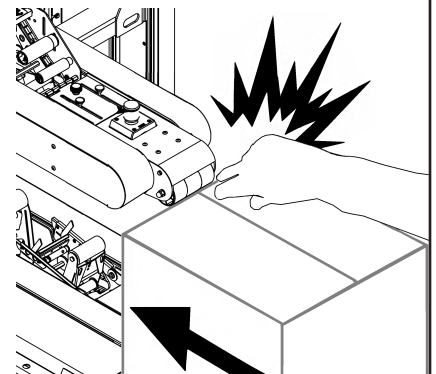


Figure 3-7

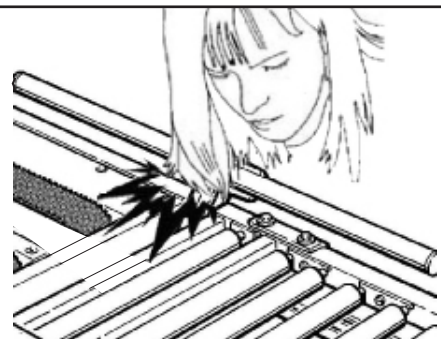


Figure 3-8

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 7000r/7000r3 Pro 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.

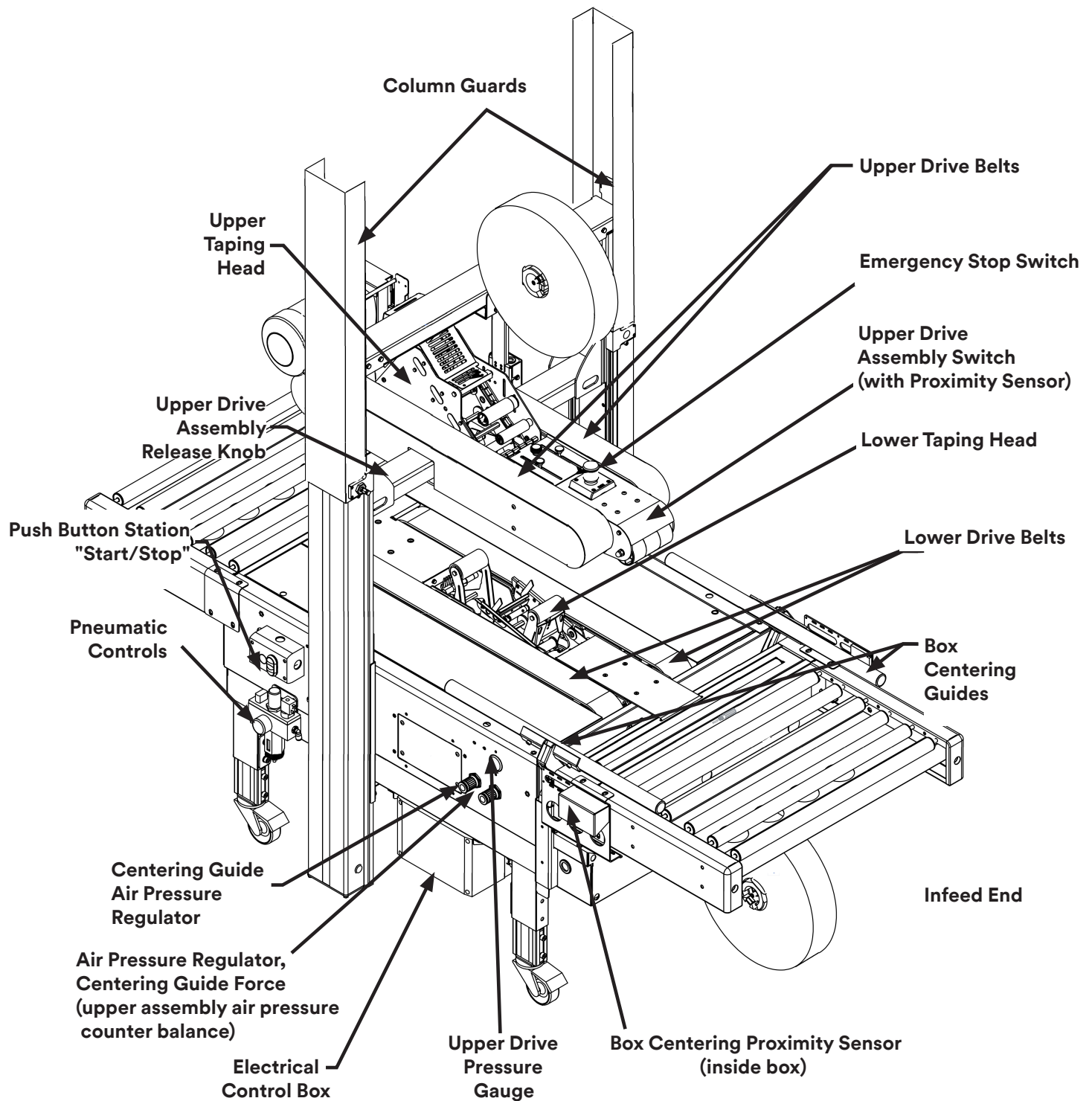


Figure 3-9 7000r-7000r3 Pro Case Sealer Components (Left Front View)

3. Safety (continued)

3.13 Table of Warnings and Replacements Labels

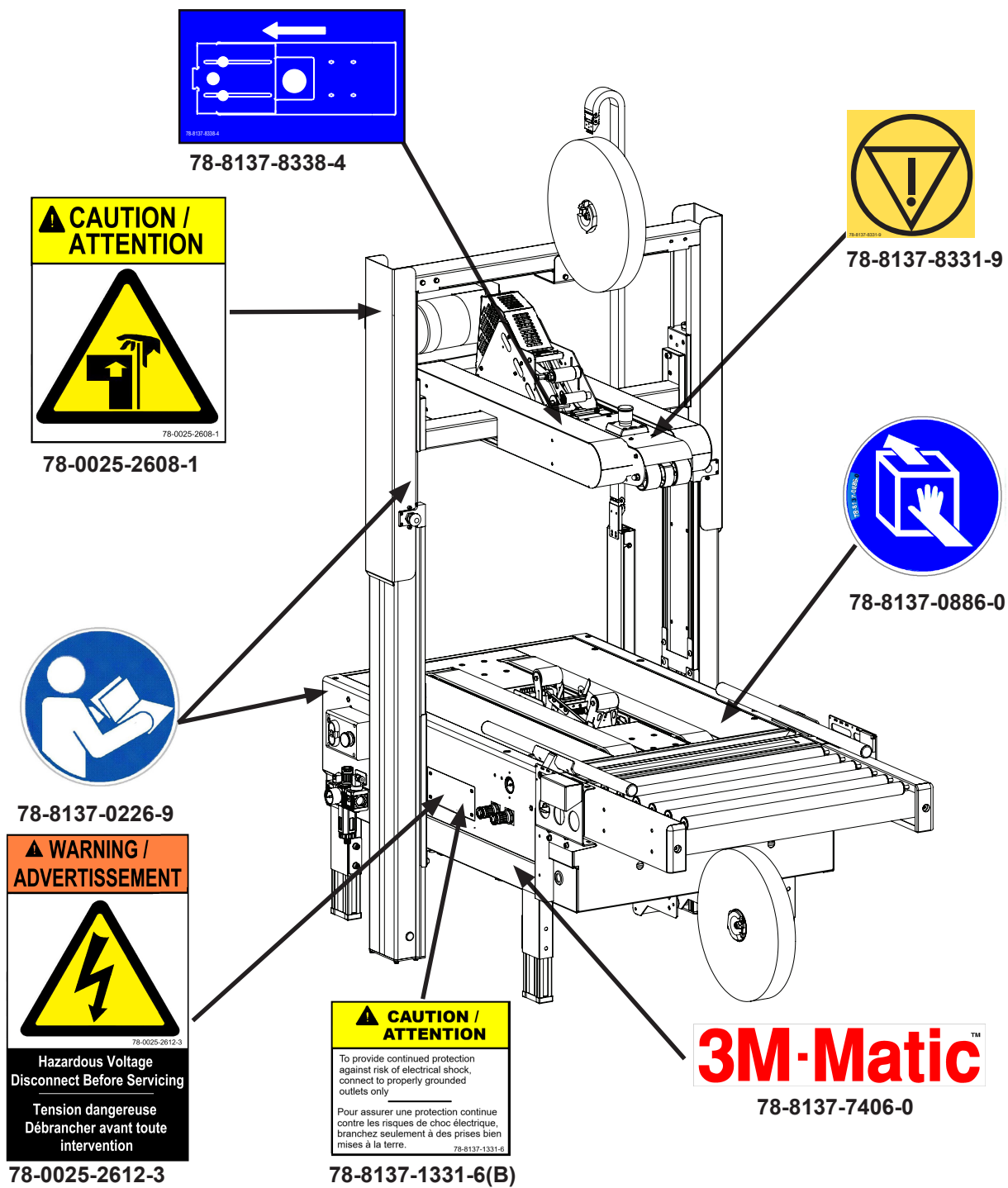


Figure 3-10 Replacement Labels / 3M Part Numbers

3. Safety (continued)

3.13 Table of Warnings and Replacements Labels (continued)

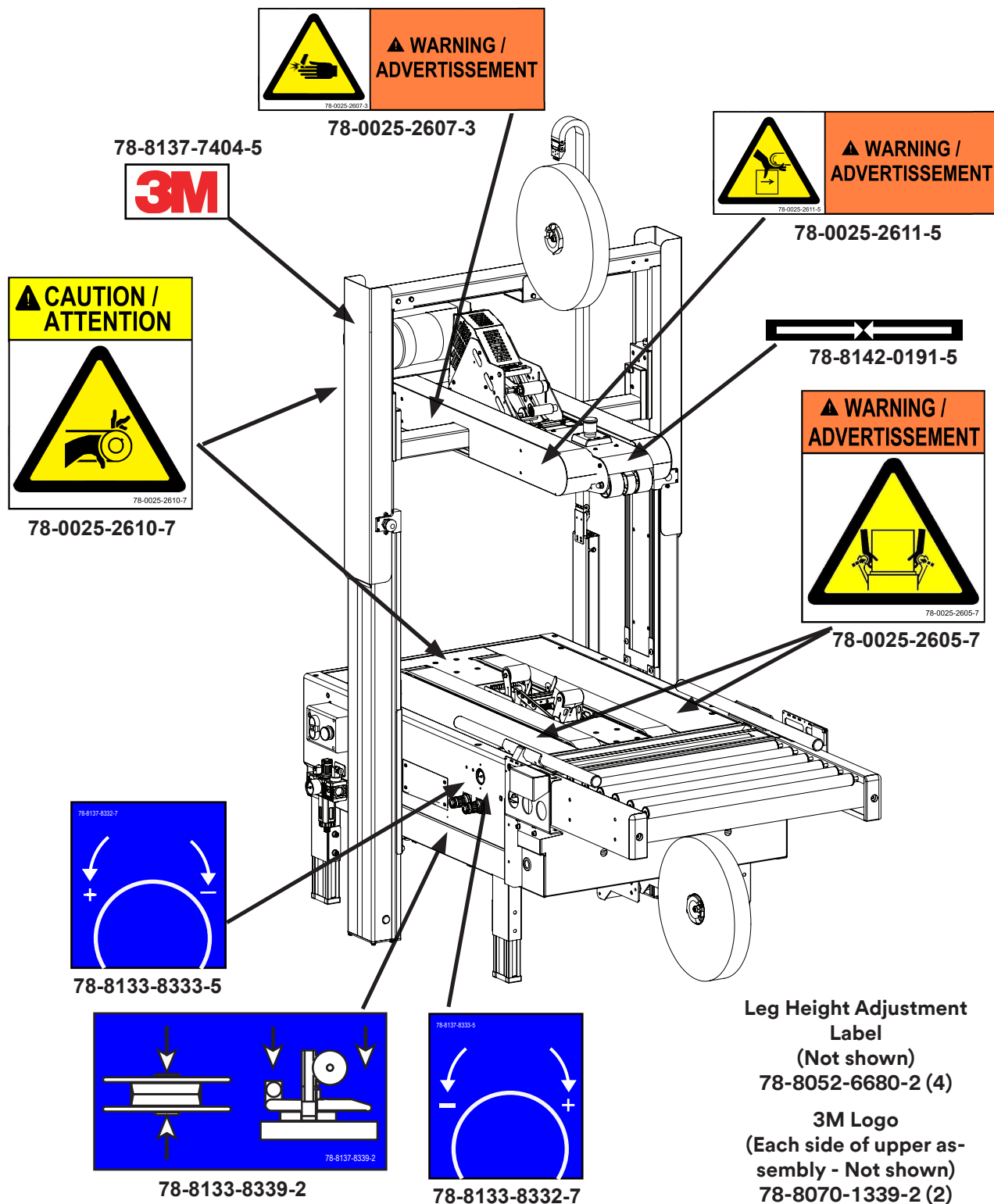


Figure 3-11 Replacement Labels / 3M Part Numbers

4. Caracteristiques

4.1 Power Requirements:

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

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

Maximum regulator setting 6.6 bar [95 PSIG]

6.20 SCFM (175.52 NL/m) 0.87CFM@90Psig

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

4.2 Operating Rate:

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 Tape

Scotch® pressure-sensitive film box sealing tapes.

4. Specifications *(continued)*

4.5 Tape Width

50.8mm [2 inches] to 76.2mm [3 inches]

4.6 Tape Roll Diameter

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

4.7 Tape Width - Standard

70mm ± 6 mm [2.75 inch ± 0.25 inch]

Tape Application Leg Length – Optional

50.8mm ± 6mm [2 inch ± 0.25 inch]

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

4.8 Box Board

Style – regular slotted containers – RSC

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

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

4.9 Box Weight and Size Capacities

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

B. Box Dimensions for 7000r Pro and 7000r3 Pro Machines: Inches [mm]

* Boxes narrower than 8 inches [200mm] may require more frequent belt replacement because of limited contact area.

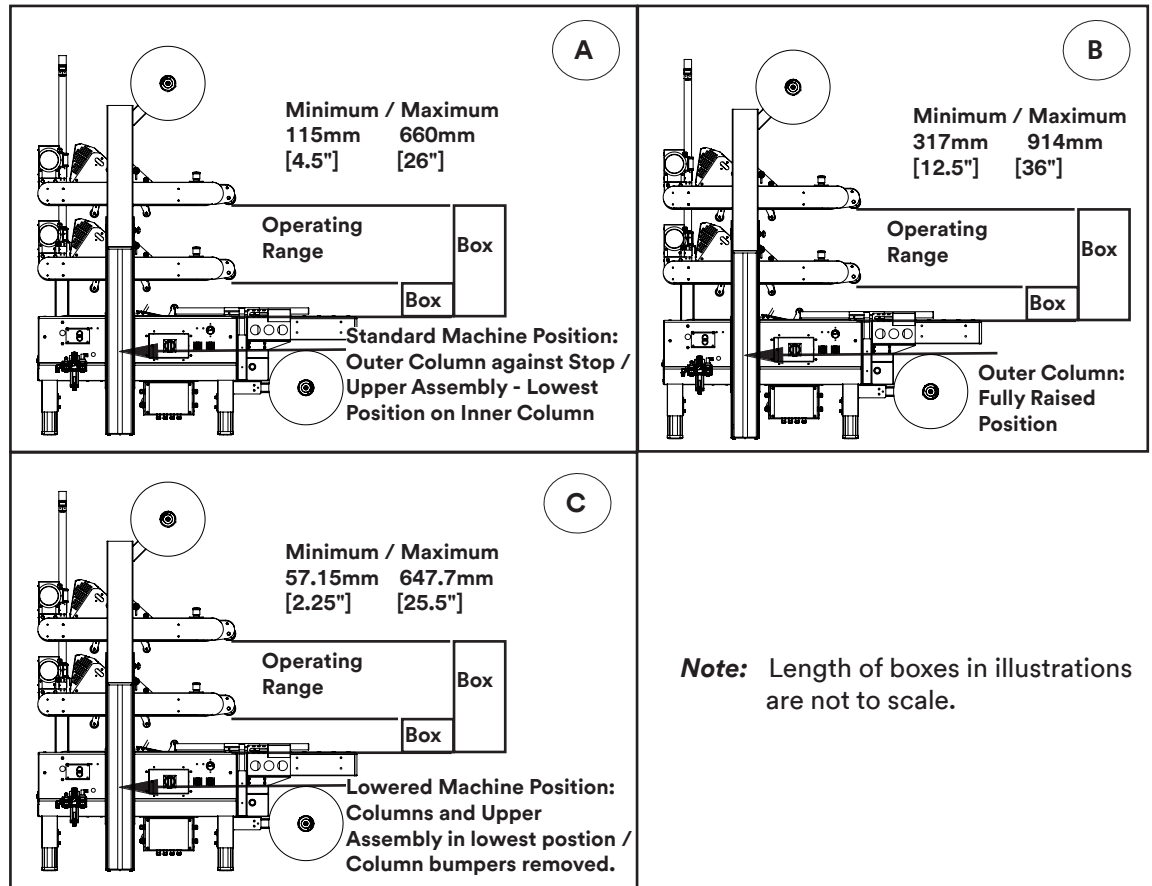
To accommodate smaller or larger boxes, machine upper taping head frame and/or outer column assemblies can be repositioned as described in “Special Set-Up Procedure” section of this manual. Refer to illustration/chart for box height range possibilities by adjusting machine upper frame and/or outer column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

	Length	Width	(A) Standard Pos. AG 3 Tape Leg (i.e. 2.75" [70])	(B) Fully Raised Pos.	(C) Lowered Pos. Tape Leg 2" [70] (AG3/no bumper)
Minimum	6" [152]	6.5" [165]*	4.5" [115]	12.5" [317]	2.25" [57]
Maximum	N/A	26" [660]	26" [660]	36" [914]	25.5" [647]

4. Specifications *(continued)*

Minimum/Maximum Box Height Combinations

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



Case Height Range Illustration:

- A. Standard Machine Position:** Outer Columns positioned against Stop with Upper Drive Assembly set to Lowest Position on Inner Columns.
Tape Leg Length - 2.75" [70mm].
- B. Raised Machine Position:** Maximum Box Height (i.e. Outer Columns and Upper Drive Assembly in Highest Position - See Special Set-Up Procedure).
Tape Leg Length - 2.75" [70mm].
- C. Lowered Machine Position:** Lowest Box Height, columns in lowest position heads in offset position, Tape leg length 2", Upper assembly in lowest position, column bumpers removed.

Boxes narrower than 8" [203mm] may require more frequent belt replacement because of limited contact area.

Special modifications may be available for carton sizes not listed on previous page.

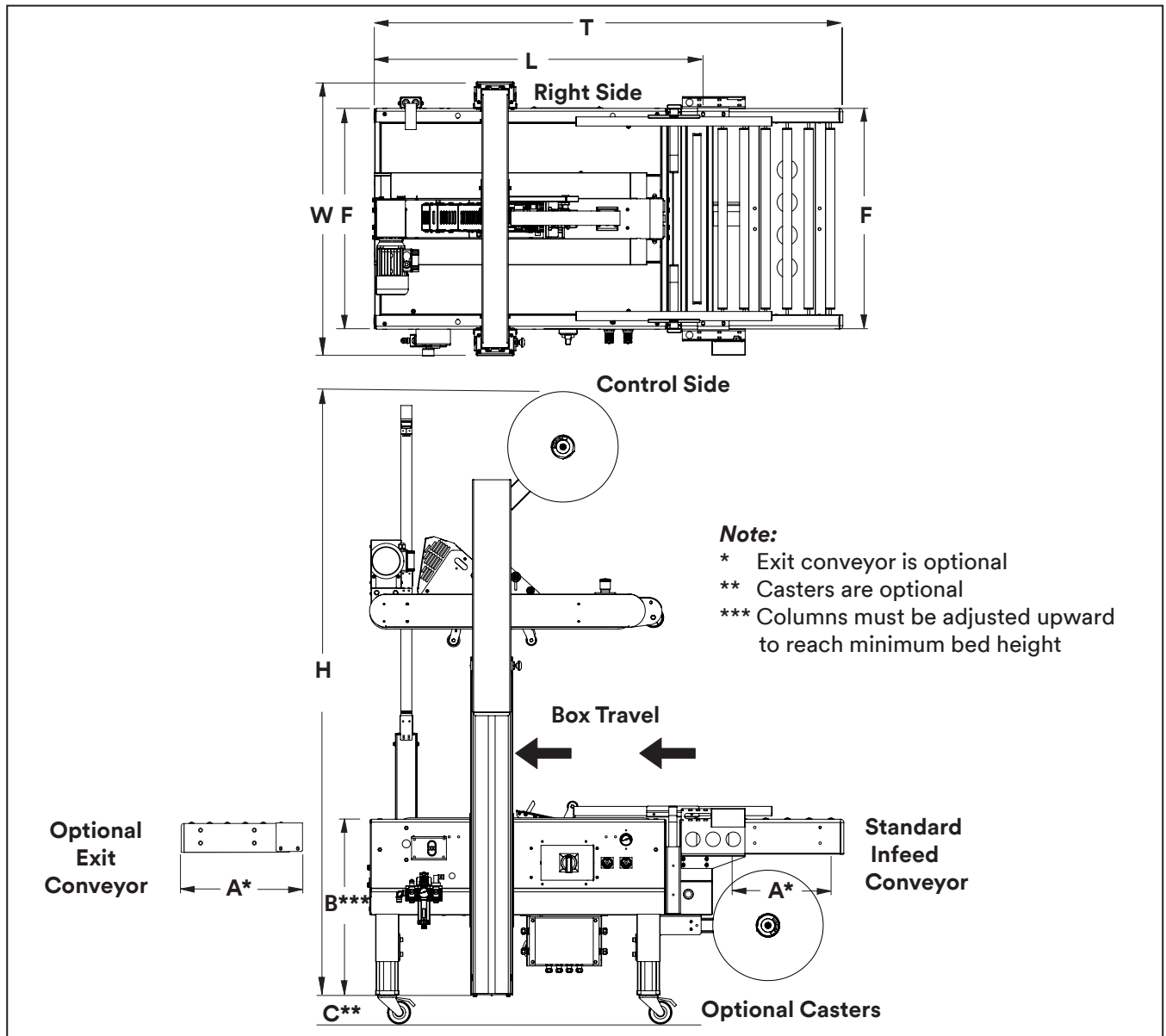
Contact your 3M Representative for information.

Note: The case sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is .6 or less, then several boxes should be test run to assure proper machine performance. Any box ratio approaching this limitation should be test run to assure performance.

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

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

4. Specifications *(continued)*



4.10 Machine Dimensions:

	W	L	H	A	B	C	F	T
Minimum								
mm	959	1180	1575	457	597***	111	768	1637
[Inches]	[37.75]	[46.5]	[62]	[18]	[23.5]	[4.38]	[30.25]	[64.5]
Maximum								
mm	--	--	2642	--	890	--	--	--
[Inches]	--	--	[104]	--	[35]	--	--	--

Packaged:
 49.5" [1257] (H) x 51" [1295] (L) x 42" [1067] (W)

Weight: 225 kg [500 pounds] crated (approximate)
 200 kg [430 pounds] uncrated (approximate)

4.11 Machine Noise Level:

78 dB with tape roll inserted.

4.12 Set-Up Recommendations:

- Machine must be level.
- Supplied infeed and optional 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.

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/polyethene 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).

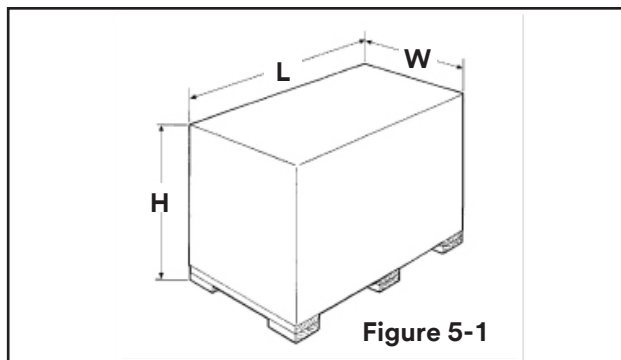


Figure 5-1

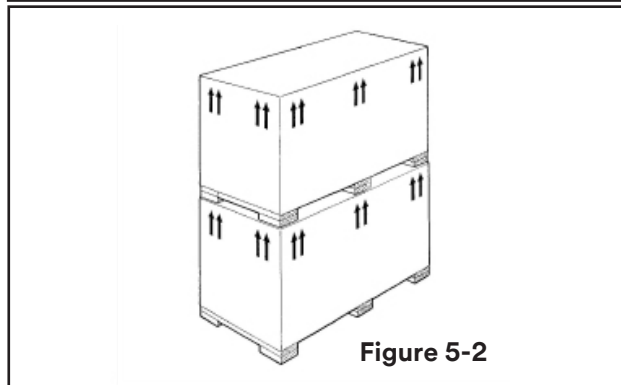


Figure 5-2

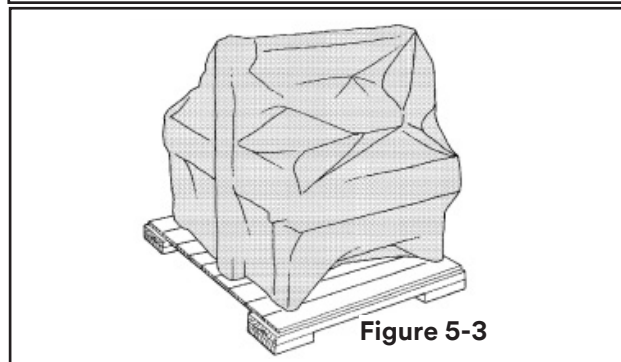


Figure 5-3

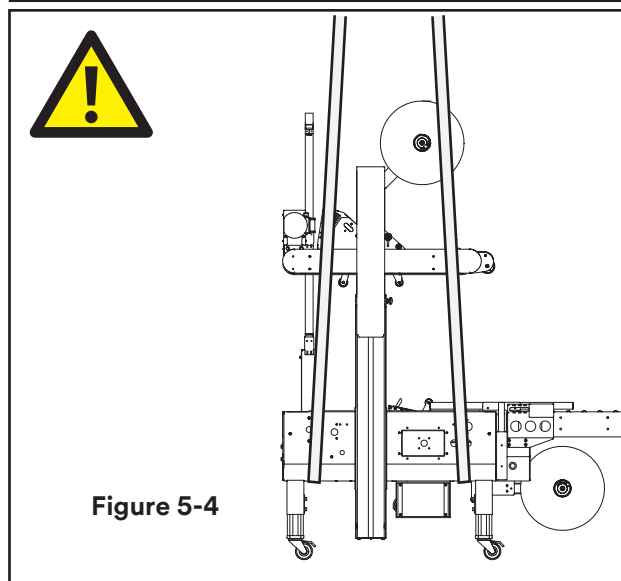


Figure 5-4

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).

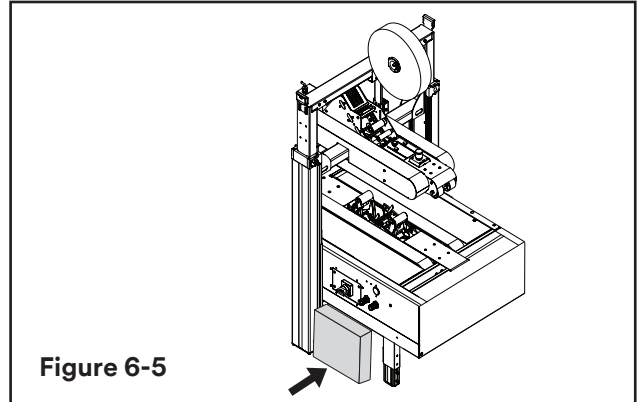
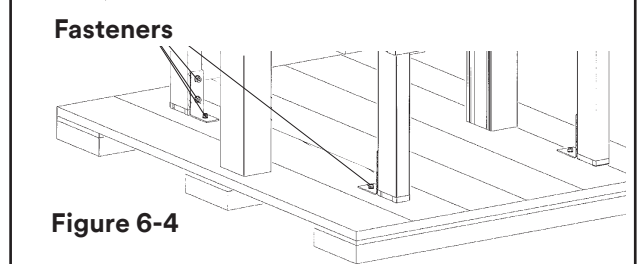
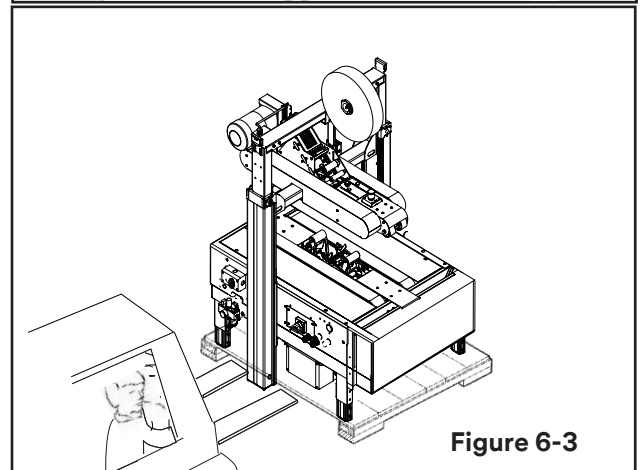
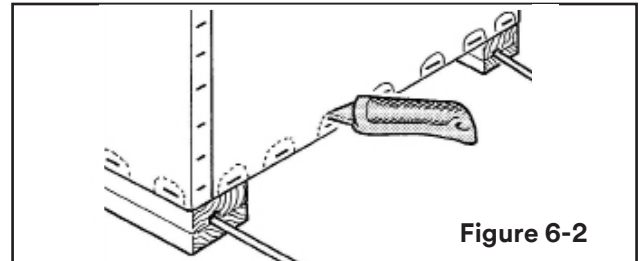
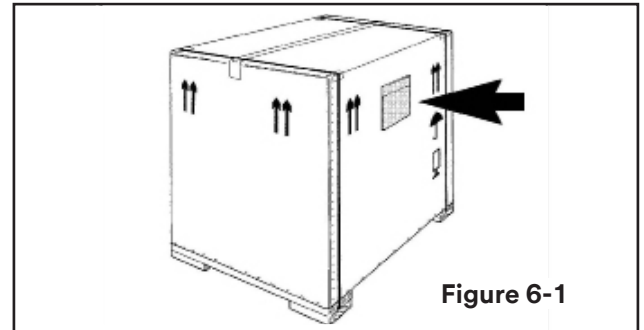
A cardboard box is located under the machine body. Retrieve instruction manual for additional set-up procedures. The box also contains parts removed for shipping, spare parts and tools (Figure 6-5).

6.2 Disposal of Packaging Materials

The 7000r-7000r3 Pro package is composed of:

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

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



7. Installation

7.1 Operating Conditions

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

7.2 Space Requirements for Machine Operation and Maintenance Work

Minimum distance from wall (Figure 7-1):

A = 1000mm.

B = 700mm.

Minimum height = 2700mm.

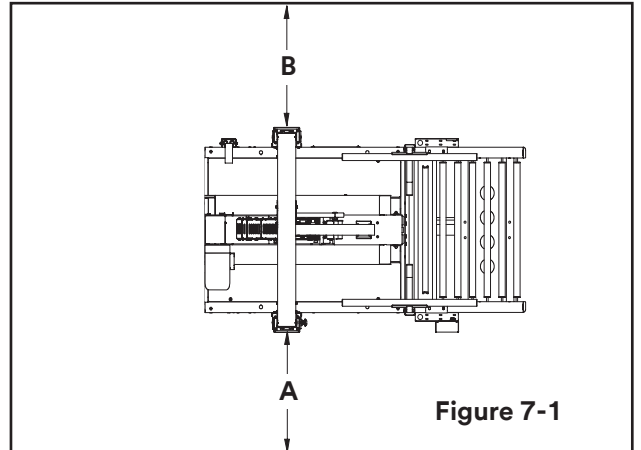


Figure 7-1

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

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

To set the machine bed height, do the following:

2. Adjust machine bed height. The case sealer is equipped with four (4) Random 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 Repositioning- See Special Set-up Procedure (Section 11).

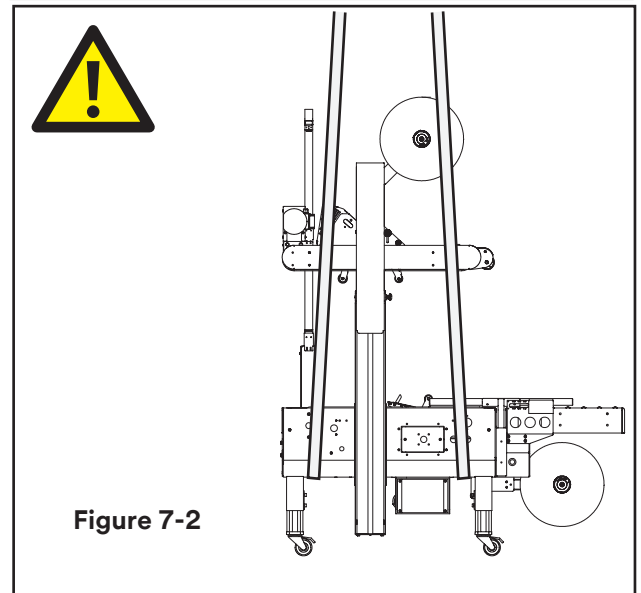


Figure 7-2

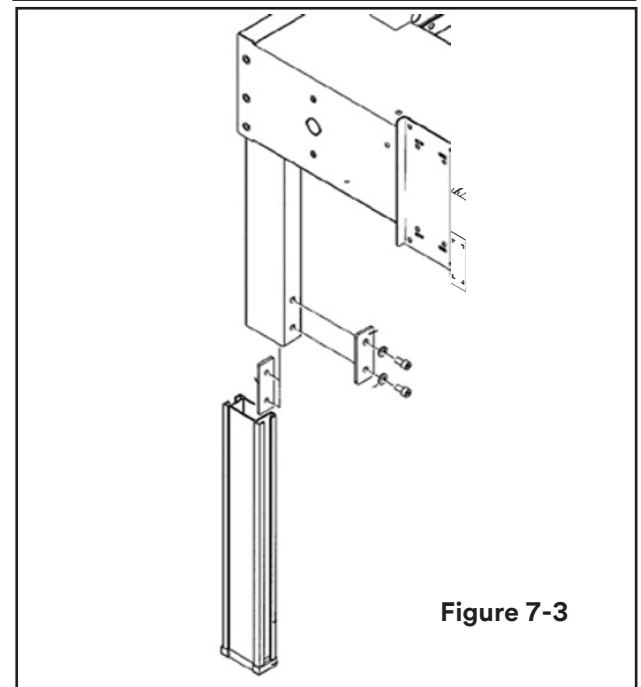


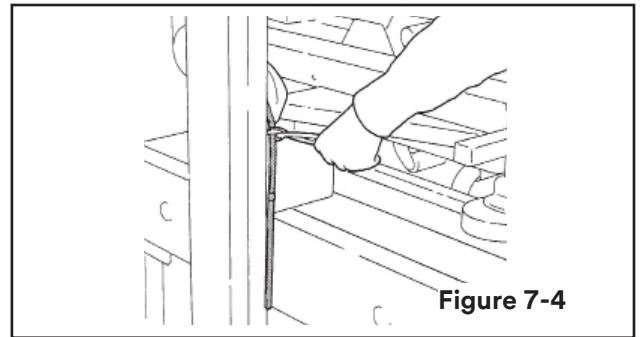
Figure 7-3

7. Installation *(continued)*

7.5 Removal of Plastic Ties

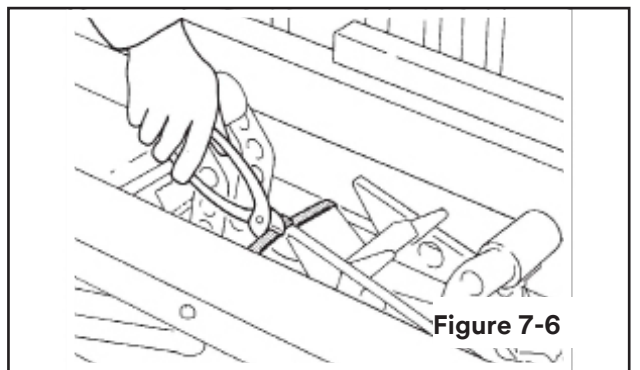
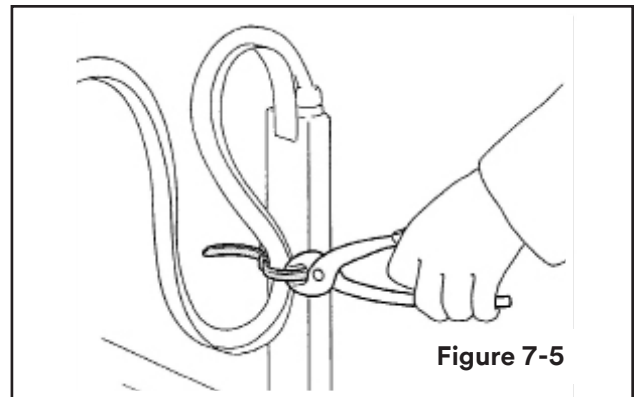
Cut the plastic which attaches the top head to the frame and remove the polystyrene blocks (Figure 7-4).

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).



7.6 Assembly Completion / Machine Set-up

Note – A tool kit consisting of metric open end and hex socket wrenches is provided 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 (see the Technical Documentation/ Spare Parts-Order Section).



7. Installation *(continued)*

Machine Set-Up

The following instructions are presented in the order recommended for setting up and installing the case sealer, as well as for learning the operating functions and adjustments. Following them step by step will result in your thorough understanding of the machine and an installation in your production line that best utilizes the many features built into the case sealer.

Refer to Figure 7-14 to identify the various components of the case sealer.

1. Install the upper tape drum bracket on top crossbar as shown in Figure 7-7A.
2. Mount the column guards, shown in Figure 7-7. Remove and retain the screws and washers holding the guards on the columns for reinstallation after Bumper Supports have been mounted (see Column Bumper Installation in the Installation and Set-Up Section and Special Set-Up Procedures Section / Figure 7-7 and Section 13). After the Bumpers have been installed, the Column Guards must be installed - Figure 7-7) for safe operation of the machine. Replace existing screws and washers to secure the guards in place.
3. Cut cable ties securing upper assembly to machine bed on each side.

Important – Use care when working with compressed air.

See Specifications for compressed air supply needs. As shown in Figure 7-15, an on/off valve, pressure regulator, and filter are provided to service the air supply.

Note – A precision regulator is used to balance the upper drive assembly. Due to the self relieving feature of this regulator a small amount of air will continually vent to the atmosphere. This is normal and amounts to approximately 3 litre/min. [0.1 SCFM].

The case sealer requires a 6.2 bar gauge pressure 166 liter/min [90 PSIG], @21°C, 1.01 bar [11.6 SCFM]



Warning

- Allow only properly trained and qualified personnel to operate and service this equipment.

4. Pneumatic connection.

- a. Read and remove safety tag from pneumatic “On/Off” valve.
- b. Connect the main air supply line to the inlet side of the on/off valve using the barbed fitting and hose clamp provided (See Figure 7-7B).

The customer supplied air hose (8mm [0.313 inch] must be clamped tightly to the barbed fitting.

If another type of connector is desired, the barbed fitting can be removed and replaced with the desired 1/4-18 NPT threaded connector. Always turn the air valve “Off” when the air supply line is being connected or disconnected.

5. Turn the air supply on by turning the air on/off valve to SUP (On).
6. Raise and latch upper drive assembly in full “Up” position.

Note – Read “Operation – Mechanical Latch” before raising and latching upper drive assembly.



Warning

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

7. Installation *(continued)*

7. Hold taping head Buffing Roller and cut and remove cable tie that holds applying/buffing arms retracted (Applying/buffing rollers are held retracted for shipment - Figure 7-6). Allow buffing/applying arms to extend slowly.

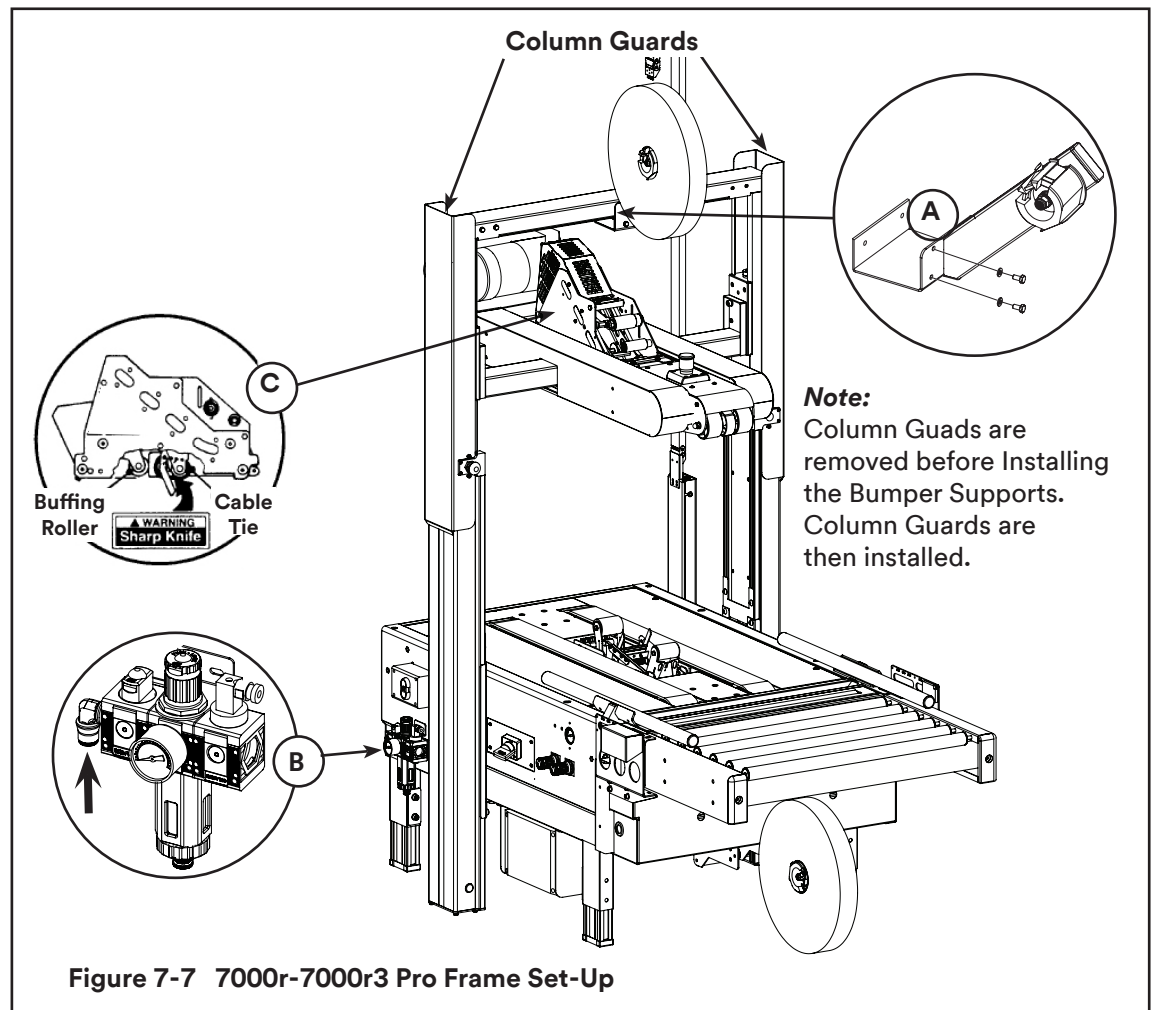
Also cut and remove cable tie at rear of lower taping head.

8. Check for free action of both upper and lower taping heads. Push buffing roller into head to check for free, smooth action of taping heads.
9. Ensure that the tape drum bracket assembly, located on the lower taping head, is mounted straight down (Figure 7-8). The tape drum bracket assembly can be pivoted to provide tape roll clearance in certain cases.



Warning

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



7. Installation *(continued)*

7.7 Infeed Conveyor Assembly

1. Remove the conveyor and the package of parts from the carton.
2. Verify that package contains two right angled cover plates, twelve (12) M8 × 15 hex head screws, and eight (8) M8 flat washers.
3. To assemble the infeed conveyor, refer to Figure 7-9 and locate four (4) bolt holes on the infeed end of the case sealer frame.
4. Insert a M8 × 15 screw in each hole so that only a few threads take hold. Do not use washers with these screws.
5. Attach the infeed conveyor over the screws using the inverted keyholes in the end of the conveyor. Tighten all four (4) screws with a 13mm wrench.
6. Refer to Figure 7-10. Set the cover plates over the joint between the conveyor and the frame on each side and secure them with four (4) M8 × 15 screws and M8 washers.

7.8 Centering Guides

1. Remove the two centering guides and four (4) M6 × 20 socket head screws from the package.
2. Using a 5mm hex key wrench, attach the centering guides to the rails with four (4) M6 × 20 screws (two [2] in each guide) as shown in Figure 7-11.

7.9 Outboard Tape Roll Mounting (Lower Taping Head)

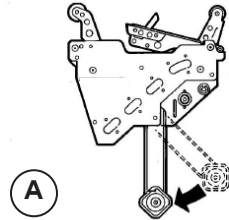
Remove the tape drum bracket assembly, spacer and fasteners from the lower taping head. Install and secure on the infeed end of lower frame (as shown in Figure 7-8).

7.10 Tape Leg Length

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

Figure 7-8

**Lower
Taping
Head
Mounting**



B

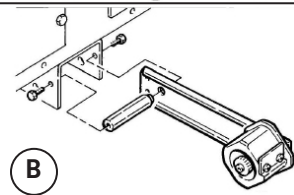


Figure 7-9 Infeed Conveyor

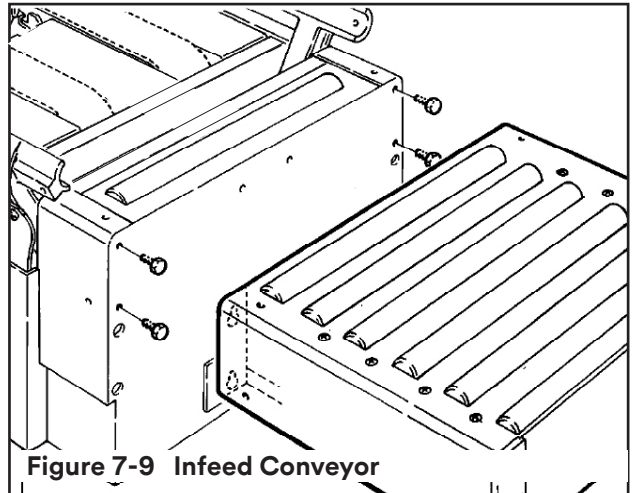


Figure 7-10 Cover Plates

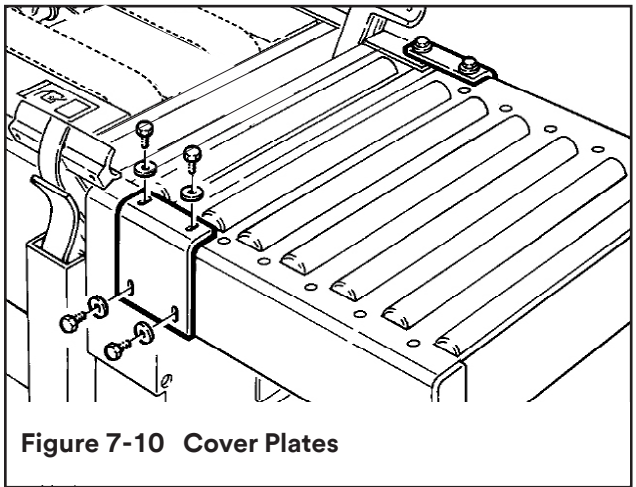
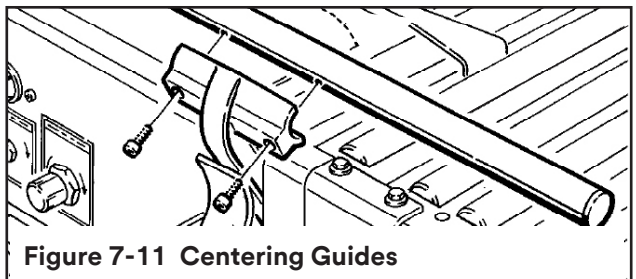


Figure 7-11 Centering Guides



7. Installation *(continued)*

7.11 Column Cap and Bumper Supports (Upper Drive Assembly)

With Safety Guard removed - Figure 7-13:
(Also See Special Set-Up Procedure -
Column Bumper Installation).

1) Install Column Cap (see Figure 7-12)

- Remove Column Cap and socket head screw parts package from carton.
- Latching mechanism should be installed on operator side column.

2) Install Bumper Supports

Raise and lock the upper drive assembly in the raised position.
See Controls, Valves, Switch Locations - Section 7.

- Turn off air supply and electric power.
- Remove the Column Bumper and flat head screw parts package from carton.
- Using flat head screws provided, install Column Bumper (recommended position is shown in Figure 7-13).
- Install Safety Guard using socket heads screws from parts package

Important: Some bumper positions may allow upper and lower taping heads to come into contact with each other. This creates added stress to bumper and/or can cause a malfunction of machine.

For more information on bumper settings, contact your 3M service representative.

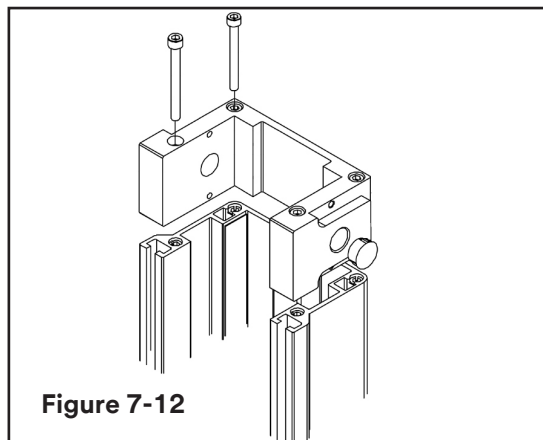
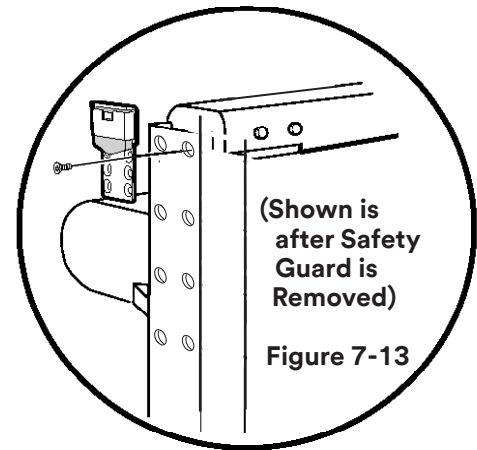


Figure 7-12

7.12 Box Size Capacity of Case Sealer

At its factory setting, case sealer handles a variety of box sizes. If larger capacity is needed, machine can be adjusted to accommodate larger boxes (refer to Specifications Section).



7.13 Electrical Connections and Controls

The electrical and pneumatic “On/Off” switch and the Push Button Station “Start/Stop” are located on the left side of the machine frame (Figure 7-14). If desired, for operator convenience, the “On/Off” and “Start/Stop” switches can be relocated to the right side of the machine frame. A standard three conductor power cord with plug is provided at the back of the electrical control box for (See Specifications) electrical service. The receptacle providing this service shall be properly grounded. Before the power cord is plugged into outlet make sure that all packaging materials and tools are removed from the machine.

Do not plug electrical cord into outlet until ready to run machine.

Use of an extension cord is not recommended. However, if one is needed for temporary use, it must have a wire size of 1.5mm diameter [AWG16], have a maximum length of 30.5m [100 ft] and must be properly grounded.

Note - Machines outside the U.S. may be equipped with 220/240 Volt, 50Hz systems, or other electrical requirements compatible with local practice.

7.14 Initial Start-Up of Case Sealer

After completing the “Installation and Set-Up” procedure, continue through “Operation” for tape loading and start-up to be sure case sealer is properly adjusted to run boxes.

7. Installation *(continued)*

7.15 Controls, Valves, Switch Locations

1. Electrical/Pneumatic “On/Off” Switch

The switch box houses an under voltage motor protection release circuit breaker that supplies AC power to the Electrical Control Box. The Circuit Breaker is preset and requires no further maintenance. If circuit is overloaded and trips, unplug machine from power source:

- Determine and correct cause of overload.
- Reconnect machine to power source.
- Turn “On/Off” and Push Button Switches “On”.

2. Main Air “On/Off” Valve/Pressure Regulator/Filter/Exhaust Valve – Figure 7-15

This set of pneumatic components controls, regulates and filters plant air supply to the 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 circuit *(continued)*

Refer to Figure 7-14 below to acquaint yourself with the various components and controls of the case sealer. Also see component locations in Section 3 and Manual 2 and Manual 3 for taping head components.

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

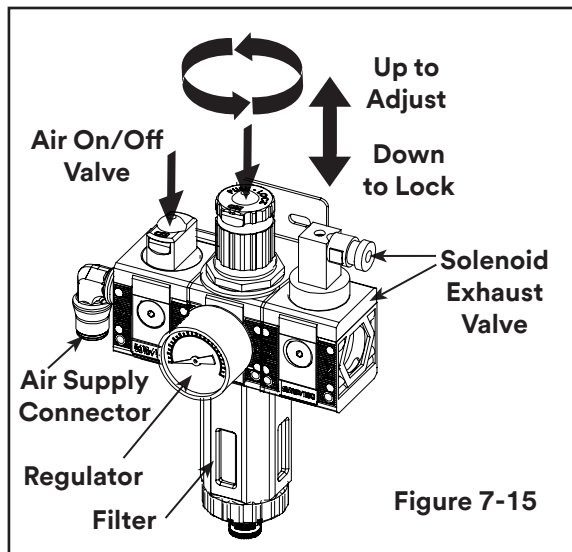


Figure 7-15

Note: See 7.15 Control Function Explanations

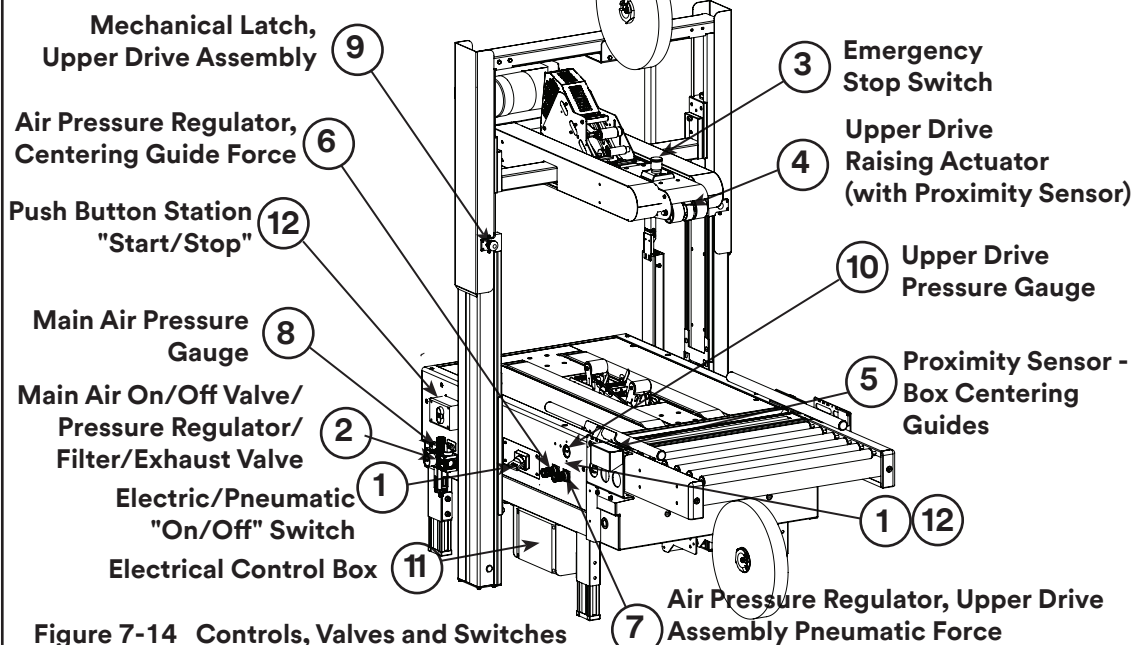


Figure 7-14 Controls, Valves and Switches

7. Installation *(continued)*

(continued)

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. The Exhaust Valve releases exhaust air from the pneumatic circuit (but column air pressure is maintained).

Note: Column air pressure is maintained to keep the upper assembly from dropping too quickly from raised position.

3. Emergency Stop Switch

The machine electrical supply can be turned off by pressing the latching emergency stop switch. To restart machine, rotate emergency stop switch (releases switch latch) and then restart machine by turning switch on side of machine frame to “ON” and then pressing the “Start” Station Button.

4. Raising Actuator - Upper Drive Assembly

This switch, when touched by the leading edge of a box, triggers a proximity sensor that pneumatically raises the upper frame to allow insertion of the box under the drive belts. As the box moves under the switch, the upper drive assembly descends on the box and the drive belts convey the box through the machine. When switch is actuated by hand, the upper drive assembly rises to its maximum height. Released, the upper drive assembly descends to its rest position.

5. Proximity Sensor - Box Centering Guide

This sensor controls the box centering guides. When sensor is activated by box entering the case sealer, centering guides close (centering the box), and release (after box passes sensor), the guides open.

6. Air Pressure Regulator, Centering Guide Force Adjustment – Figure 7-16

This regulator is used to adjust Centering Guides according to weight of boxes. Pressure should be adequate to center boxes, but low enough to allow easy pushing of boxes under taping head.

7. Air Pressure Regulator/Gauge, Upper Drive Assembly Force Adjustment – Figure 7-17

Set nominally to control “down” movement of upper drive assembly and resulting pressure exerted against the box. The regulator setting is changed as necessary for the boxes being sealed to provide adequate drive belt pressure against the box positively conveying boxes through the machine. This Pressure Regulator acts as a “counter balance force” that equalizes air pressure on the Column Cylinders and keeps the Upper Assembly from dropping too quickly from the raised position. If the boxes stop or hesitate, decrease the Regulator pressure (which will increase drive belt force on the box) for more friction between the box and drive belts. Adjust setting as necessary to get continuous movement of boxes through machine.

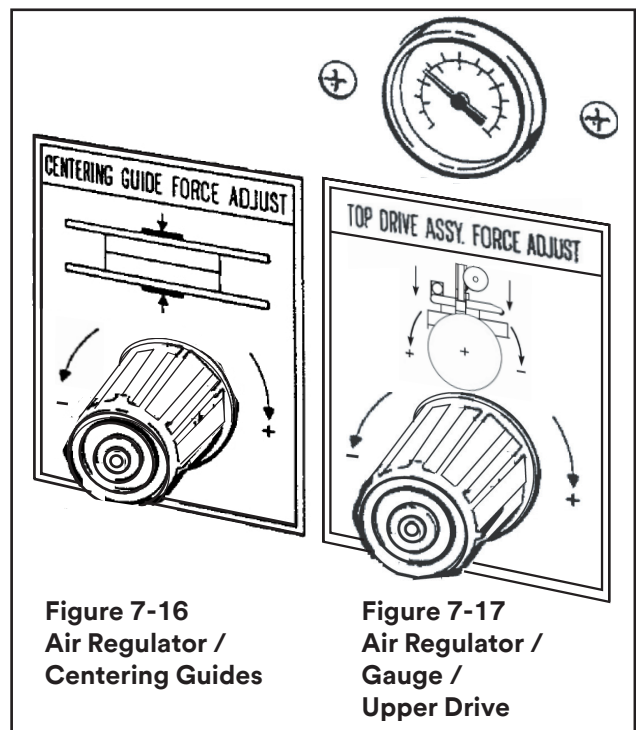


Figure 7-16
Air Regulator /
Centering Guides

Figure 7-17
Air Regulator /
Gauge /
Upper Drive

7. Installation *(continued)*

For boxes which are fully packed with products that support the top flaps, adjustment of this regulator is not critical since the boxes can support pressure of upper frame (drive belts) at a wide range of regulator settings. However, if under-filled or fragile boxes are to be sealed, this regulator can be used to set the upper frame to a higher pressure that is adequate for conveying boxes through the machine while also allowing upper assembly to descend on box (preventing box damage).

Note – A precision regulator is used to balance upper drive assembly. Due to the self relieving feature of this regulator a small amount of air will continually vent to atmosphere. This is normal and amounts to approx. 3 liter/min [0.1 SCFM].

8. Main Air Pressure Gauge - Indicates main air regulator pressure setting. Air regulator should be adjusted so gauge reads 5 bar gauge pressure [70 PSIG].

9. Mechanical Latch, Upper Drive Assembly (Figure 7-18)
The mechanical latch is provided to hold the upper drive assembly at the fully raised position for tape threading and maintenance.

To raise and latch upper assembly:

1. Push and hold upper frame raising switch “A”.
2. Push and hold latching knob “B”.
3. Release switch “A”.
4. Release knob “B”.
5. Shut off air supply.

To release/lower the upper assembly:

1. Turn on air supply.
2. Push and release switch “A”.

10. Upper Drive Pressure Gauge
As indicated in Air Pressure Regulator / Gauge, Upper Drive Assembly Force Adjustment, Upper Drive Pressure Gauge is used as indicator of “counter balance force” that equalizes air pressure on the Column Cylinders and keeps Upper Assembly from dropping too quickly from raised position. Adjust force higher (+)/ Lower (-) to equalize and create balance.

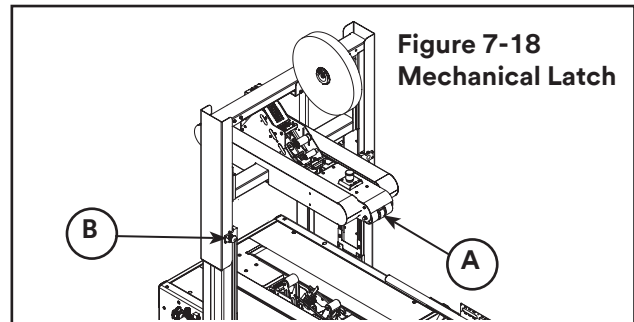


**Figure 7-18
Mechanical Latch**

Important – Before turning drive belts on, be sure no tools/objects are on the conveyor bed.

11. Electrical Control Box - Houses DC Power Supply for Proximity Sensors, Control Relays, Motor(s) Contactor, and opening delay timer for Box Centering Guides.

12. Push Button Station “Start/Stop”
Controls Box taping Cycle / Starts and Stops Drive Belts.

7.16 Tape Loading/Threading -
See Manual 2 or 3.

Note – If lower tape drum is mounted in alternate lower outboard position, remove taping head from machine bed by pulling straight up, insert threading needle in taping head and replace taping head. Install tape roll on drum (adhesive on tape leg up), thread tape under knurled roller on outboard mount, then attach tape to threading needle and pull tape through taping head with threading needle.



Warning

- **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.

7. Installation *(continued)*

7.17 Theory of Operation

The air supply powers movement of the centering guides and upper drive assembly to automatically adjust the case sealer to the box size being sealed as follows:

1. A box centering Proximity Sensor in infeed roller conveyor actuates movement of the centering guides. When the operator pushes a box onto the infeed conveyor, as shown in Figure 7-19, the proximity sensor activates causing the air cylinder powered centering guides to move inward, thereby centering the box.
2. Once the box is centered by the guides, the operator pushes the box against the Raising Actuator/ Proximity Sensor on the upper drive assembly, as shown in Figure 7-20, causing the upper taping head to be raised by two air cylinders. The upper taping head will continue to rise above the box height so the operator can insert the box underneath the upper drive belts.
3. Once the box is pushed under the upper taping head, the upper drive assembly raising switch is released causing the upper drive assembly to descend onto the box top, as shown in Figure 7-21, allowing the drive belts to convey the box through the upper and lower taping heads for application of the tape seals.
4. As the box is conveyed through the machine, the box centering Proximity Sensor is deactivated causing the centering guides to return to their full open position, ready for insertion of the next box.

At this point it is recommended that the centering proximity sensor and upper drive assembly switches be manually actuated to understand the functions described above. Activation (run a box on conveyor) of the automatic sensors causes the guides to close. Deactivation (box moves past Proximity Sensor) causes guides to open. Depressing upper drive assembly raising switch causes upper drive assembly to rise, releasing the switch causes drive assembly to descend.

Notes:

1. Machine or taping head adjustments are described in "Adjustments" Section for machine or Manual 2 or Manual 3 for taping heads.
2. Box drive motors are designed to run at a moderate temperature (See Specifications) In some cases, they may feel hot to the touch.

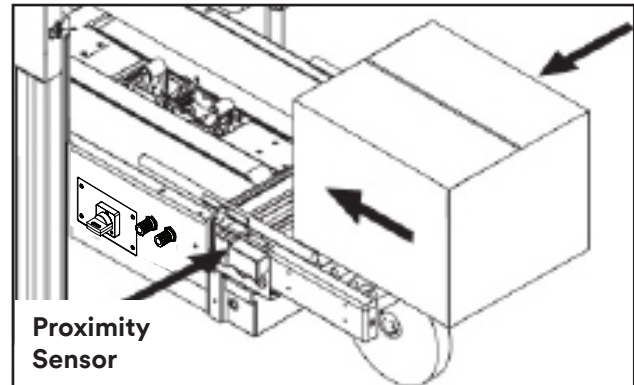


Figure 7-19 Box Centering Proximity Sensor

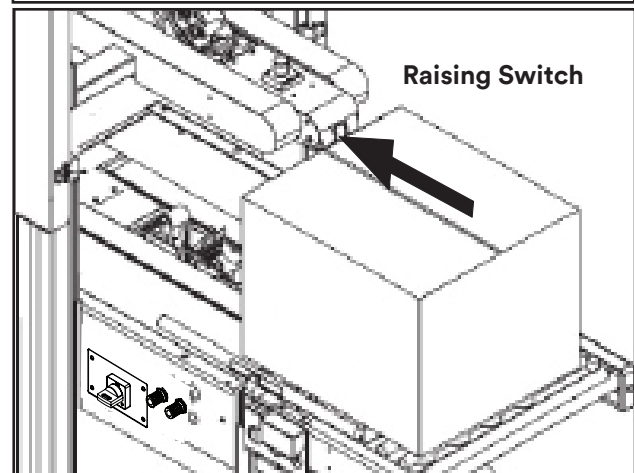


Figure 7-20 Drive Assembly Raising Switch

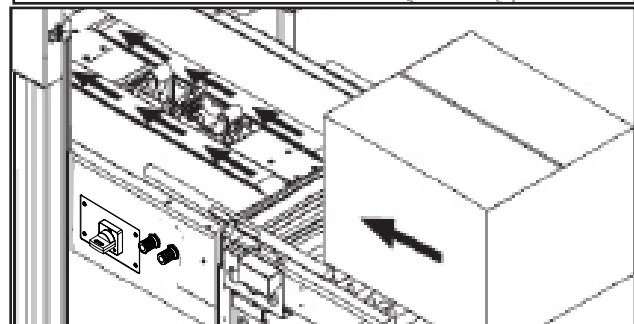


Figure 7-21 Drive Belts

7. Installation *(continued)*

7.18 Box Sealing

1. Turn main air valve to "SUP" (On).
2. Turn pneumatic/electrical switch (side of machine) to start machine.
3. Press Push Button Station "Start/Stop" to start drive belts and Air Pressure/Pneumatic operations.
4. Feed boxes to machine allowing previous box to exit machine BEFORE feeding next box.
5. Turn electrical/pneumatic switch "Off" when machine is not in use.
6. Reload and thread tape as needed.
7. Be sure machine is cleaned and lubricated according to recommendations in "Maintenance" section of this manual.

7.19 Completion of Taping Heads

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

1. Place the Upper Taping Head in a convenient working position
2. Use Figure 7-22 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 between the two (2) rollers on the apply arm (Position 3).
5. Pull threading needle down until the tape travels between 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 position 3.
6. Cut away excess tape and repeat steps for Lower Taping Head.

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

7.20 Outboard Tape Roll Holder

To use the Outboard Tape Roll Holder:

1. Remove lower taping head from machine.

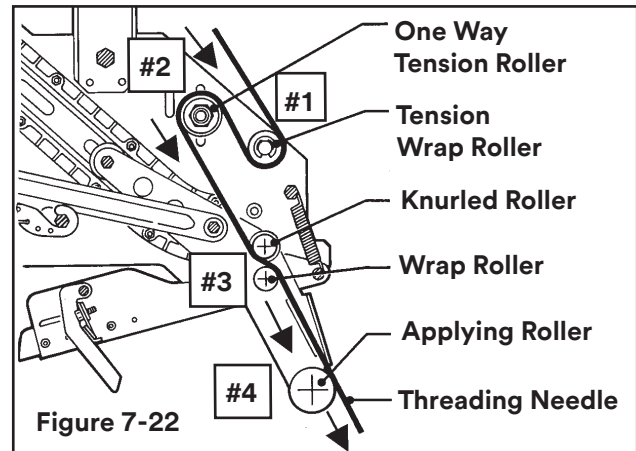


Figure 7-22

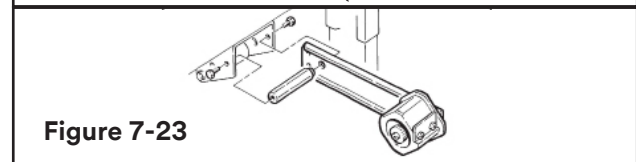


Figure 7-23

2. Remove tape drum bracket assembly, stud spacer, fasteners from lower taping head.
3. Install alternative wrap roller and bracket on head in place of tape bracket. Place lower head in machine.
4. Install and secure tape drum bracket assembly on the entry end of lower frame (as shown in Figure 7-23).

7.21 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 circuit breaker. User should check that electrical settings of the machine are compatible with all components of mains system.

7.22 Machine Connection to the Mains

For technical specifications:
See Section 4 - Specifications

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

Connect the power cord supplied to a wall socket using a plug which complies with 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 past the box centering guides Proximity Sensor and against the upper assembly raising Proximity Sensor/Raising Actuator and under 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 (exit conveyor is optional)

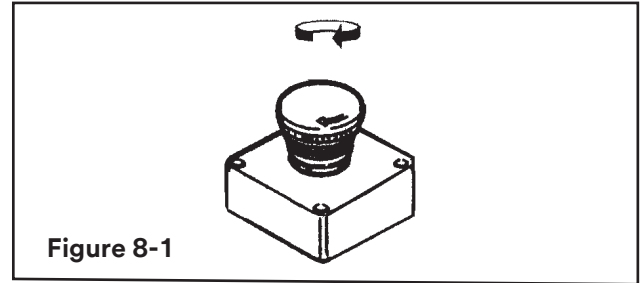


Figure 8-1

8.2 Definition of Running Model

The case sealer 7000r-7000r3 Pro has only one (automatic) operating mode with:

- The EMERGENCY STOP BUTTON unlocked (Figure 8-1)
- The Push Button Station "Start" is pressed (Figure 8-2)

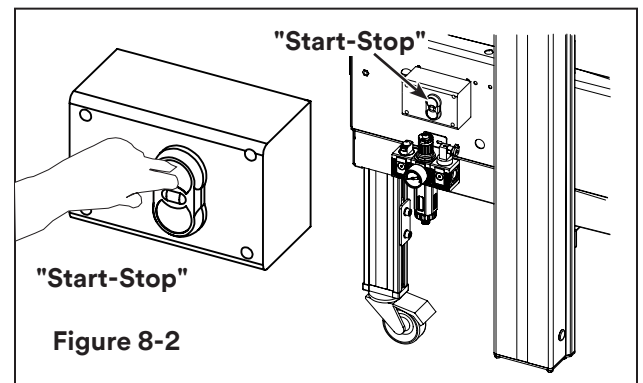


Figure 8-2

8.3.1 Normal Stop Procedure

The Push Button Station "Stop" is pressed, the machine stops immediately at any point of the working cycle.

8.3.2 Emergency Stop

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

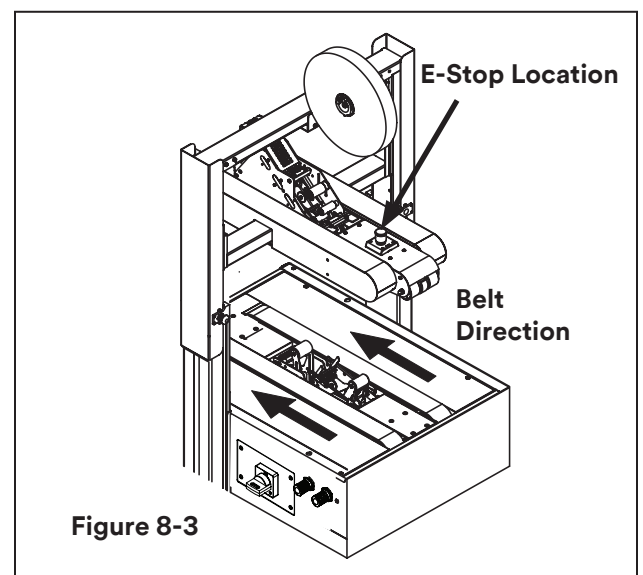
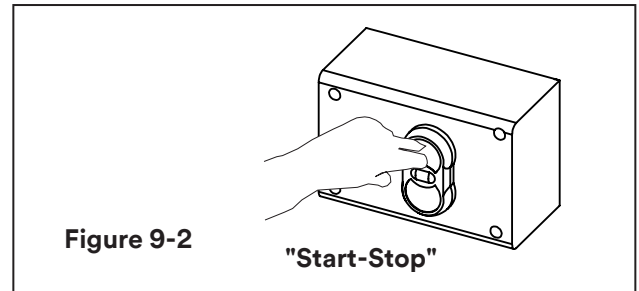


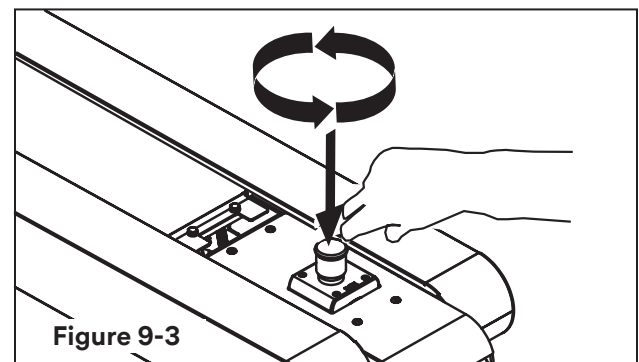
Figure 8-3

9. Controls

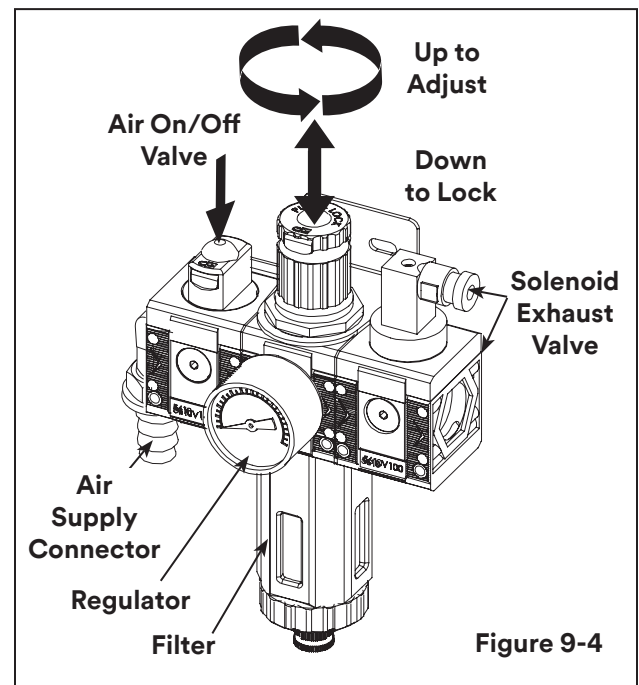
9.1 “Start/Stop” Button



9.2 Latching Emergency Stop Button

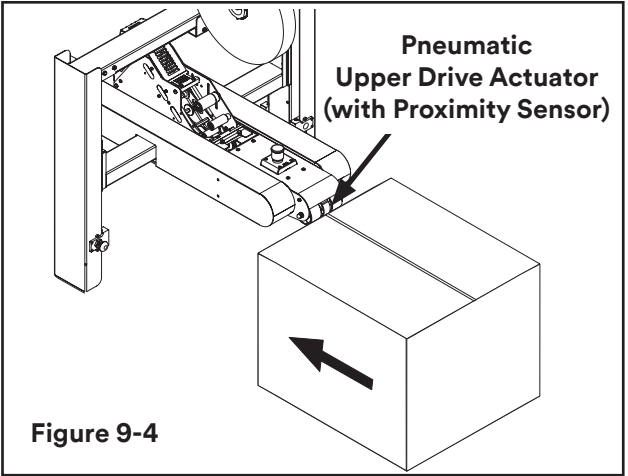


9.3 Main Air On-Off Valve-Regulator-Filter

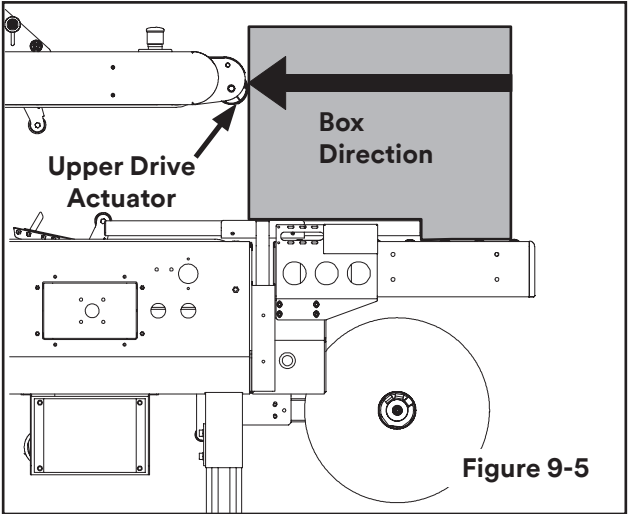


9. Controls *(continued)*

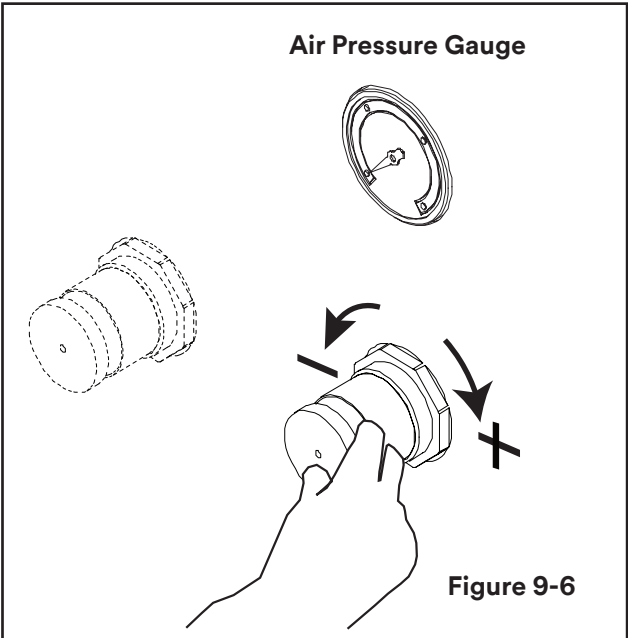
9.4 Upper Drive Actuator
(with Proximity Sensor)



9.5 Initiating the Raising Actuator

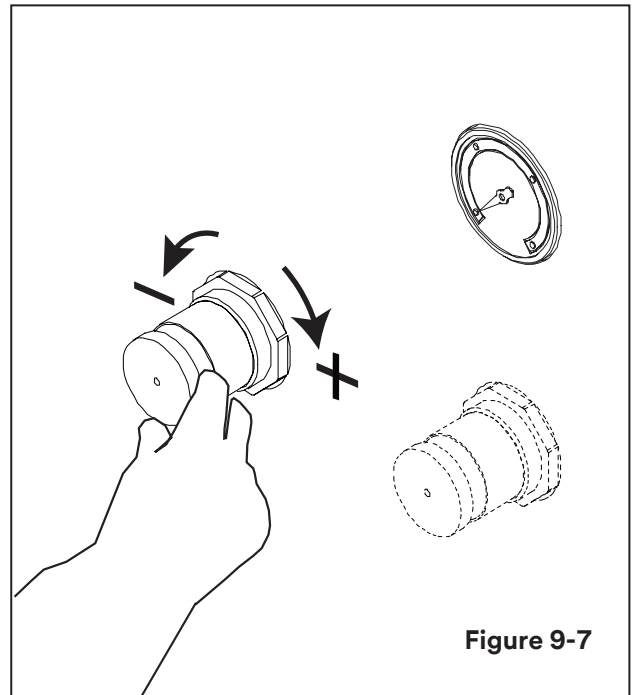


9.6 Air Pressure Regulator /
Upper Drive Force Adjustment

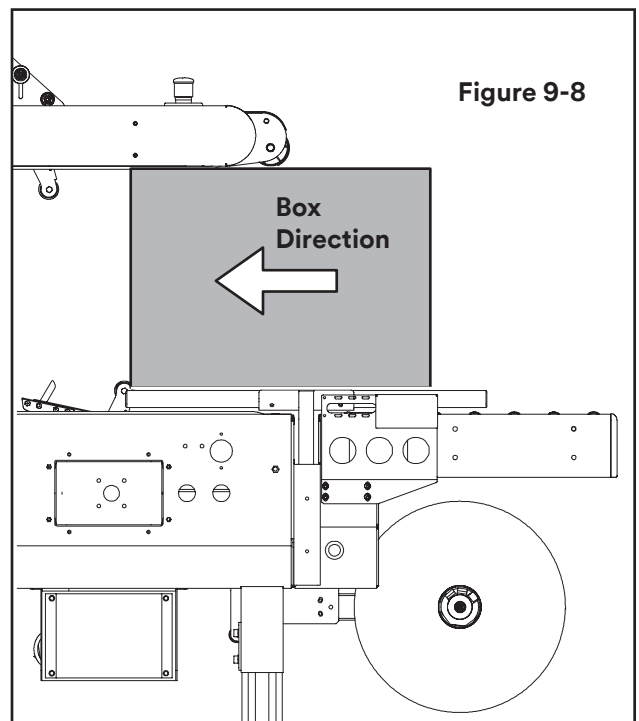


9. Controls *(continued)*

9.7 Air Pressure Regulator / Box Centering Side Guides Pressure Adjustment



9.8 Box Conveying / Tape Seal Application



10. Safety Devices of the Machine

10.1 Blade Guards

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

10.2 Emergency Stop Button

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

- To restart machine, rotate the emergency stop switch clockwise to release the switch latch (Figure 10-1).
- Then press the Station "Start" Button (Figure 10-2).

10.3 Electric System / Circuit Breaker

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

Note: The case sealer has a circuit breaker located in the electrical enclosure on the machine frame. If circuit becomes overloaded and circuit breaker trips, unplug the machine electrical cord and determine cause of overload. After two minutes, reset the circuit breaker. Plug machine electrical cord into outlet and restart machine by Turning the On/Off switch to the On position.

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

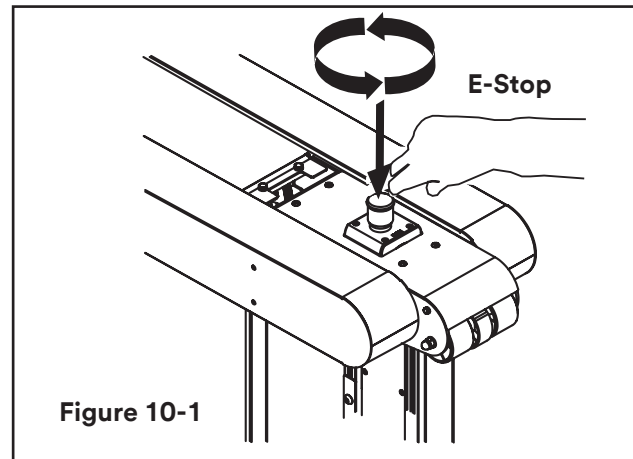


Figure 10-1

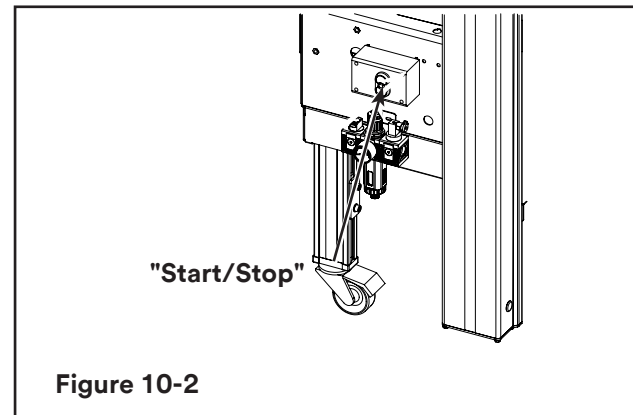


Figure 10-2



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

Boxes are automatically centered by Side Guides (Figure 11-1). The Box Centering Guides are triggered by Proximity Sensor which is located on side of the infeed conveyor. Side Guides air pressure adjustments can be made using Centering Guide Air Pressure Regulator (Figure 9-8).

11.2 Box Height Adjustment

Box Height is automatically determined when the Upper Drive Assembly Actuator Switch is engaged which is located on the front of the Upper Drive Assembly (See Figure 11-2). The Upper Drive air pressure adjustments can be made using the Air Regulator and Gauge for the Upper Drive Assembly (See Figure 7-17).

11.3 Adjustment of Top Flap Compression Rollers

(Not Applicable to this Machine)

11.4 Changing the Tape Leg Length

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

Important! Turn off Pneumatics and Electric Power

With upper drive assembly in raised position:

1. Remove tape from upper taping head.
2. Pivot up the clamp that secures the upper taping head.
3. Hold upper taping head applying and buffing arms from under upper assembly, slide head forward and down to remove (Figure 11-3).
4. Lift the lower taping head, shown in Figure 11-4, straight up to remove it from the case sealer bed.
5. Refer to applicable taping head manual for related set-up procedure.
6. Replace taping heads reverse of disassembly. Turn on air supply/electric power, unlatch upper drive assembly and allow it to return to its rest position.
7. Replace taping heads in the reverse order of disassembly.

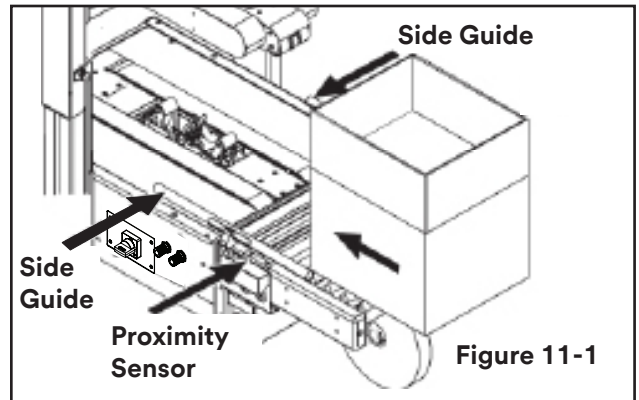


Figure 11-1

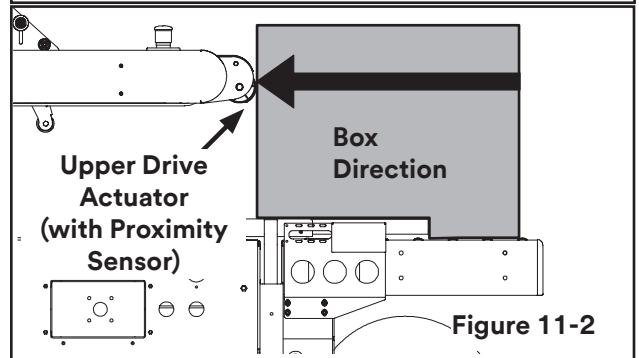


Figure 11-2

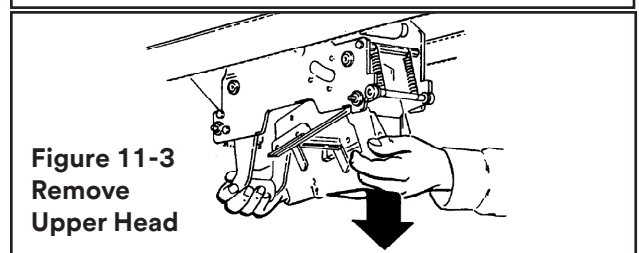


Figure 11-3
Remove
Upper Head

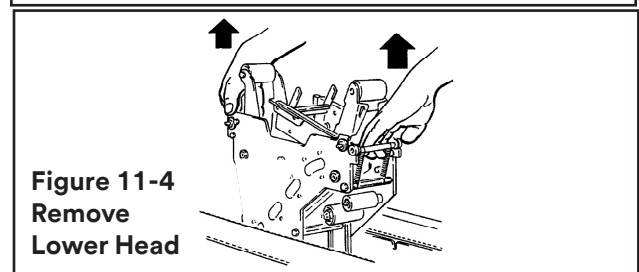


Figure 11-4
Remove
Lower Head

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

11.5 Run Boxes to Inspect Adjustment (Figure 11-5)

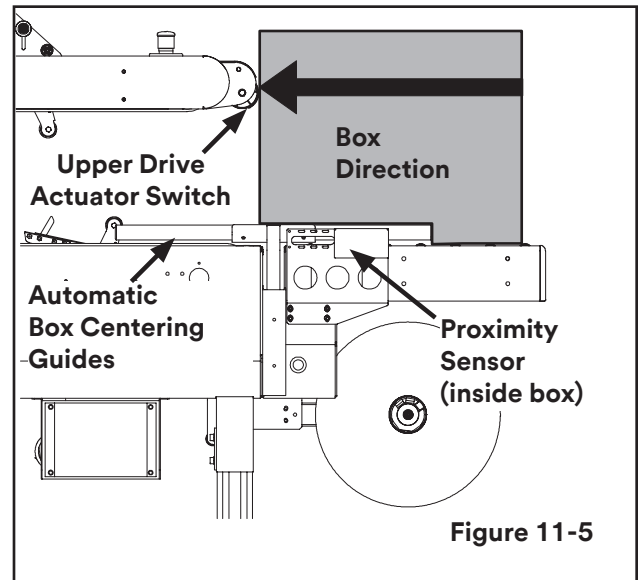
Important: Before starting machine, verify no tools or other objects are on the conveyor bed.

Turn main electrical/pneumatic switch to “On”. Then press the Push Button Station “Start”. This starts the drive belts and engages the pneumatic air pressure system. Move box forward on the infeed conveyor until the Proximity Sensor is activated (which activates the Box Centering Guides automatically centering the box). Continue moving the box forward until it contacts the Upper Drive Assembly Actuator Switch. The Upper Drive Height adjustment adjusts automatically as the box is taken away by the drive belts. Always push at the end of the box. If the box is not centered correctly or the Upper Drive Assembly does not contact the top of the box correctly, see pressure adjustment settings and/or the Troubleshooting Section.

Note – The upper head has a unique feature for overstuffed boxes. The head will raise up to 13mm [0.5 inches] to compensate for this condition.

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

Note - For belt replacement and tension specifications - refer to Section 13 / Maintenance and Repairs.



Warning

- 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.

Warning

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

12. Operation

12.1 Operator's 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 top and bottom box seams. Then the box will be expelled on the exit conveyor.

12.2 Starting the Machine

Important: Before starting the machine, verify that no tools or objects are on conveyor bed. Let the machine run without cartons and check its safety devices. Then start the working cycle.

12.3 Starting Production

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

12.4 Tape Replacement and Threading

Refer to applicable taping head manual for related set-up procedure. Press the LATCHING EMERGENCY STOP BUTTON.

12.5 Box Size Adjustment

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

12.6 Cleaning

Before carrying out cleaning or maintenance operation, stop the machine by turning OFF (O) switch on main and disconnect pneumatic and 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 Adjust-Changing tape leg	2
9 Special Adjust-Column re-position	2

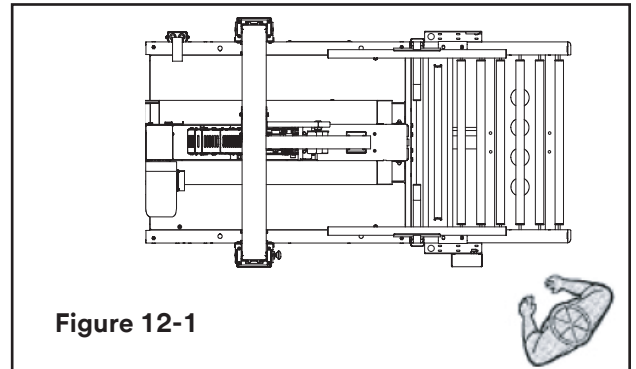


Figure 12-1

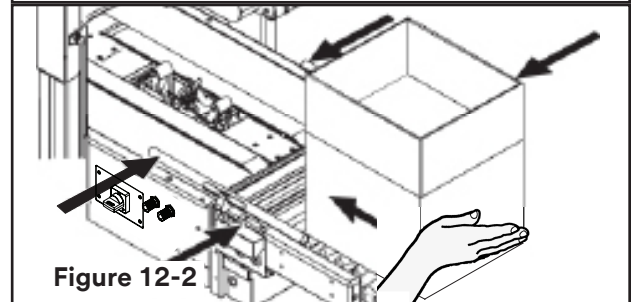


Figure 12-2

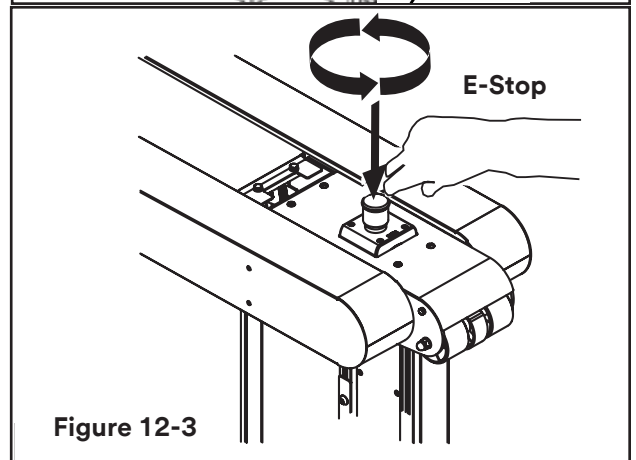


Figure 12-3

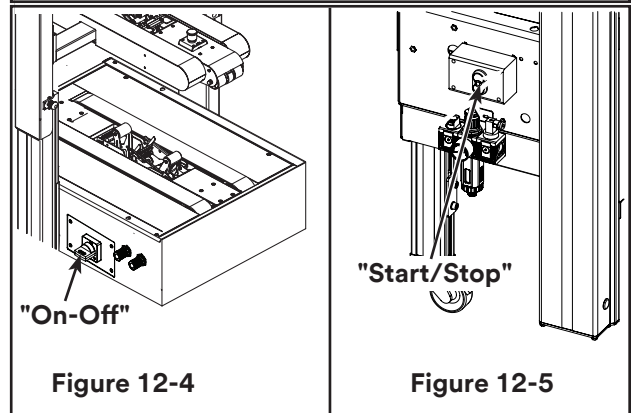


Figure 12-4

Figure 12-5

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
Drive belts do not convey boxes	Narrow boxes	Check machine specifications. Boxes are narrower than recommended, causing slippage and premature belt wear.
	Worn drive belts	Replace drive belts
	Upper taping head does not apply enough pressure	Adjust the upper drive assembly force adjust regulator to increase the force against the top of the box. Turn air regulator counterclockwise
	Taping head applying spring holder missing	Replace spring holder
	Taping head applying spring set too high	Reduce spring pressure
Drive belts do not turn	Worn or missing friction rings	Replace friction rings
	Drive belt tension too low	Adjust belt tension
	Electrical disconnect	Check power and electrical plug
	Circuit breaker not at correct setting	Set to correct current value
	Motor not turning	Evaluate problem and correct
Upper and lower applying mechanisms interfere with each other	Machine's minimum height stop does not match tape head leg length setting	Check manual to make sure taping heads match machine setting
Squeaking noise as boxes pass through machine	Dry compression rollers	Lubricate compression rollers
	Dry column bearings	Lubricate column bearings
	Defective column bearings	Replace column bearings
Tape not centered on box seam	Tape drum not centered	Reposition tape drum
	Centering guides not centered	Adjust centering guides
	Box flaps not of equal length	Check box specifications

(continued)

12. Operation *(continued)*

12.9 Trouble Shooting Guide *(continued)*

Problem	Cause	Correction
Upper drive assembly does not move up, moves up slowly or fails to operate	Lower air pressure Defective or incorrect setting on Proximity Sensor Clogged or damaged exhaust mufflers on the upper ends of the head raising cylinders Defective upper assembly valve	Verify air line is connected and regulator set at 70 psi. [5 bar] Readjust sensor Clean or replace exhaust mufflers Clean or replace the valve
Upper assembly does not move down at the end of the aping cycle	Upper drive assembly force adjust regulator set too light Defective upper drive assembly force adjust regulator Defective one-way valve Defective upper assembly valve	Adjust the upper drive assembly force adjust regulator to increase the force against the top of the box. Turn air regulator counterclockwise. Replace regulator Clean or replace valve Clean or replace valve
Upper drive assembly comes down too fast or hard or fails to operate	Upper drive assembly force adjust regulator set too heavy Defective upper drive assembly force adjust regulator Cushion screw wrongly adjusted Cushion screw missing	Adjust upper drive assembly force adjust regulator to decrease force against top of box. Turn regulator clockwise. Replace regulator Adjust cushion screw at base of cylinder Replace screw
Centering guides move slower than normal or fail to operate	Centering guide force adjust regulator set too low Centering guide cylinder speed controls need correct adjustment Defective centering guide power valve/proximity sensor misaligned with sensor receptacle	Adjust regulator Adjust speed controls mounted on centering guide cylinder Clean/replace valve / realign sensor and sensor receptacle

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 parts.
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. 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.
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.

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

13.3 Recommended Frequency of Inspection and Maintenance Operations

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

13.4 Inspections to be Performed Before and after every Maintenance Operation

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

13.7 Cleaning of Cutter Blade Qualification 2

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

13.5 Check Efficiency of Safety Features

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

13.6 Cleaning of Machine

Qualification 1

A weekly cleaning with dry rags or diluted detergents is necessary. Cardboard boxes produce a significant quantity of dust and paper chips when processed or handled in case sealing equipment. If this dust is allowed to build up on machine components, it can cause



Warning

- To reduce the risk associated with mechanical and electrical hazards:
 - Read, understand, and follow all safety and operating instructions before operating or servicing the case sealer.
 - Allow only properly trained and qualified personnel to operate and service this equipment.
- To reduce the risk associated with pinches, entanglement and hazardous voltage:
 - Turn pneumatic and 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 replacement of drive belts in pairs, especially if belts are unevenly worn.

Lower Drive Belts - Figure 13-1

1. Remove and retain center plate (A) and four (4) screws.
2. Remove and retain side cover (B) and fasteners.
3. Loosen, but do not remove lock nut (C).
4. Loosen tension screw (D) until all belt tension is removed.
5. Pull belt splicing pin (E) out and remove belt.
6. Place new belt over pulleys with laced splice at top. Insert splicing pin.

Note – Pin must not extend beyond edge of belt.

7. Adjust belt tension as explained in “Adjustments – Box Drive Belt Tension”.
8. Replace side cover and center plates and secure with original fasteners.

Upper Drive Belts - Figure 13-2

1. Remove and retain center plate (A) and four (4) screws and plain washers.
2. Loosen, but do not remove lock nut (B).
3. Loosen tension screw (C) until all tension is removed from belt.
4. Remove four (4) screws on side of belt guard (D) and slide belt guard out to expose belt.
5. Pull belt splicing pin (E) out and remove belt.
6. Place new belt over pulleys with laced splice at top. Insert splicing pin.

Note – Pin must not extend beyond edge of belt.

7. Adjust belt tension as explained in “Adjustments – Box Drive Belt Tension”.
8. Replace front cover and belt guard(s) and secure with original fasteners.

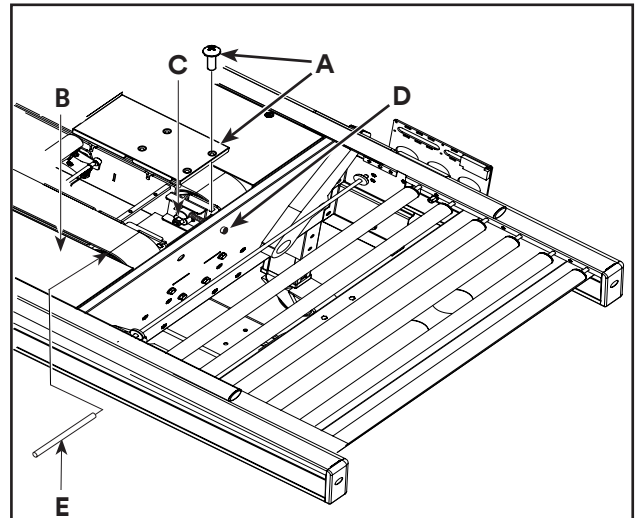


Figure 13-1 Lower Drive Belt Replacement

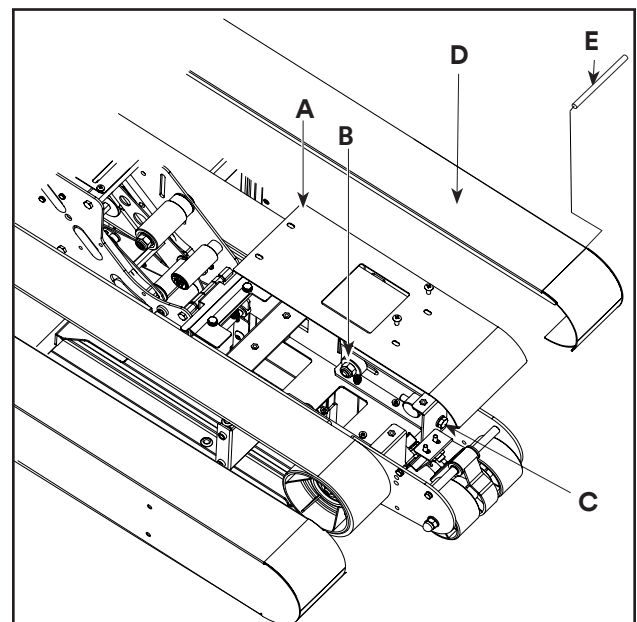


Figure 13-2 Upper Drive Belt Replacement



Warning

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

13. Maintenance and Repairs *(continued)*

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).

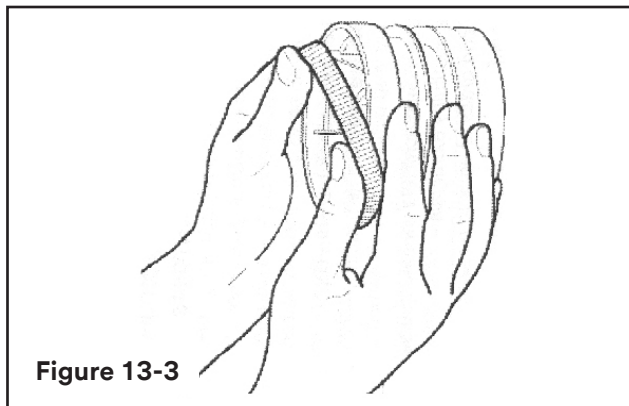


Figure 13-3

13.10 Box Drive Belt Tension

The four (4) continuously moving drive belts convey boxes through the tape applying mechanism. The box drive belts are powered by an electric gear motor.

Tension adjustment of these belts may be required during normal operation (for Belt Tension Adjustment - refer to Box Drive Belt Replacement). Belt tension must be adequate to positively move the box through the machine and the belts should run fully on the surface of the pulleys at each end of the frame. The idler pulleys on the infeed end are adjusted in or out to provide proper belt tension. Each belt is adjusted separately. Belt tension is obtained by tightening the adjustment screw so that a moderate pulling force of 3.5kg [7lbs.] applied at the mid span, as shown in Figure 13-4, will deflect the belt 25mm [1 inch]. This will assure positive contact between the belt and the drive pulley on the discharge end of the drive assembly.



Warning

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

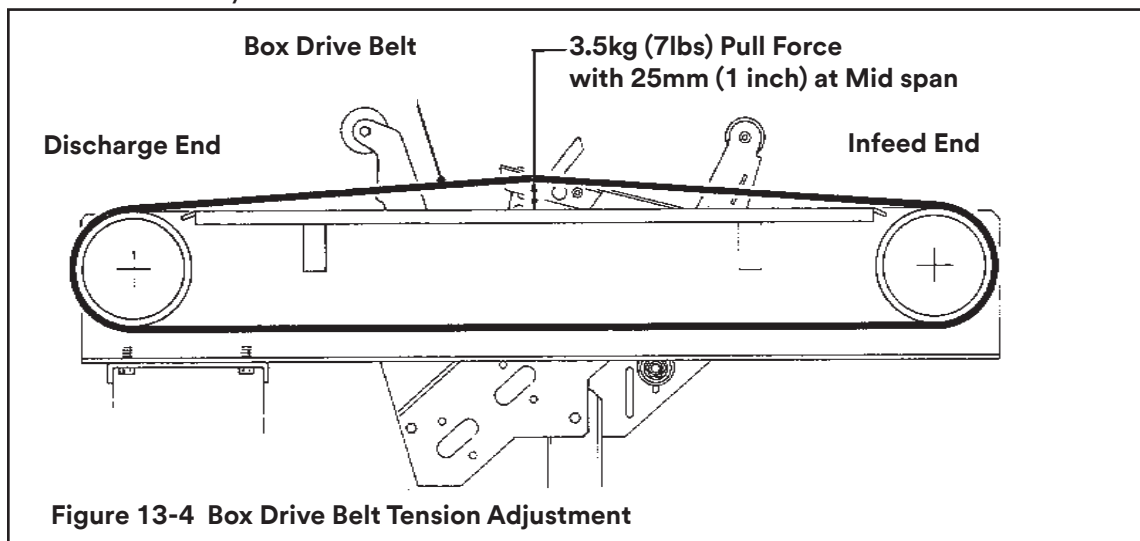


Figure 13-4 Box Drive Belt Tension Adjustment

13. Maintenance and Repairs *(continued)*

Refer to Figure 13-5 and 13-6 and adjust belt tension as follows:

1. Remove and retain center plates/ front cover and four (4) screws.
2. Loosen, but do not remove, the lock nut with an open end wrench.
3. Reset the tension on the drive belts as needed. Adjust the tension screws in (clockwise) to increase tension or out (counterclockwise) to decrease tension. Tighten lock nut to secure tension setting.
4. Replace center plates/front cover and secure with original screws.



Warning

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

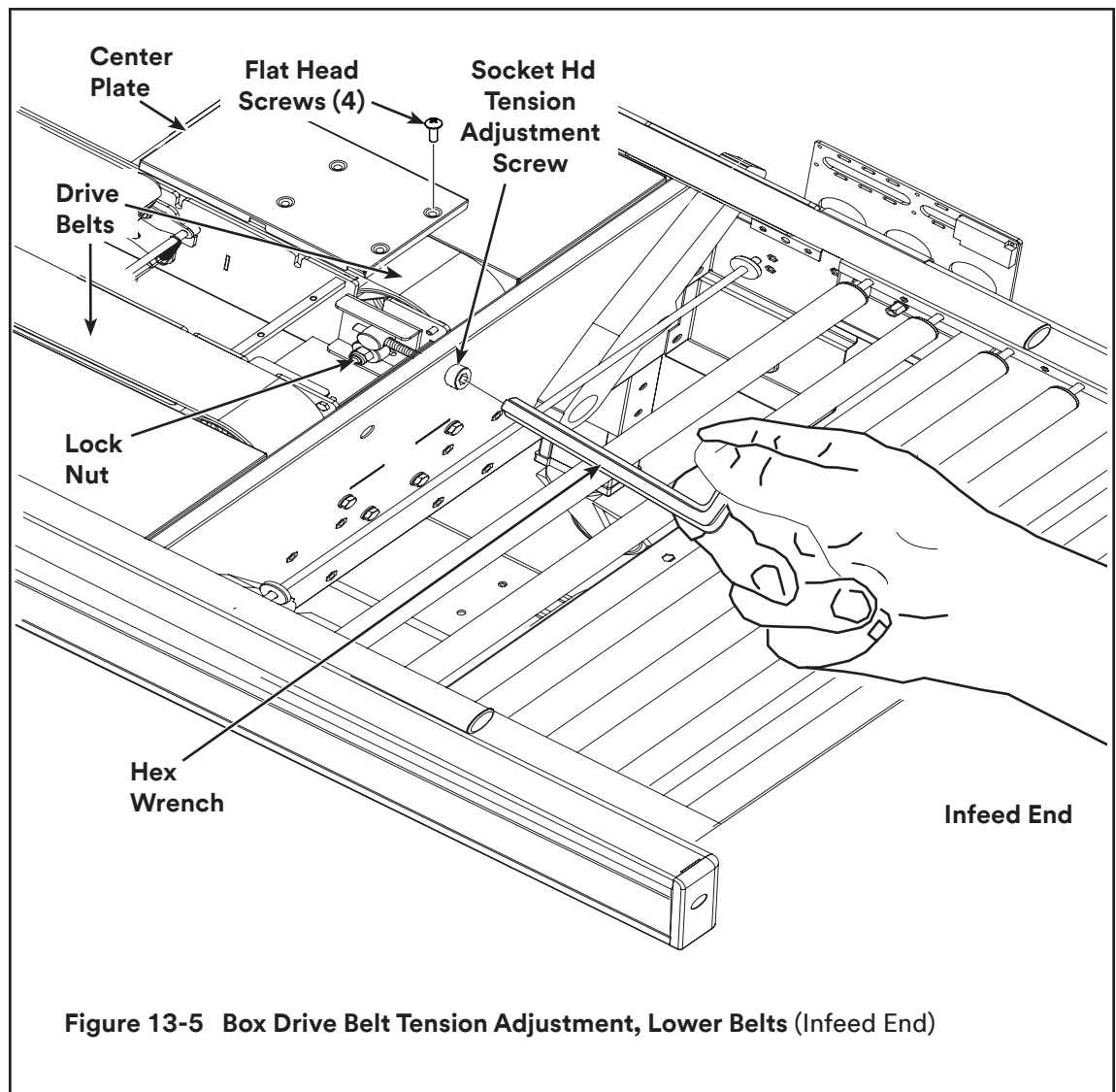


Figure 13-5 Box Drive Belt Tension Adjustment, Lower Belts (Infeed End)

13. Maintenance and Repairs *(continued)*

Taping Head Adjustments: (Refer to Taping Head Manual)

Tape Web Alignment
Tape Drum Friction Brake
Applying Mechanism Spring
One-Way Tension Roller
Tape Leg Length Adjustment
Extended Plate Bumper



Warning

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



Warning

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

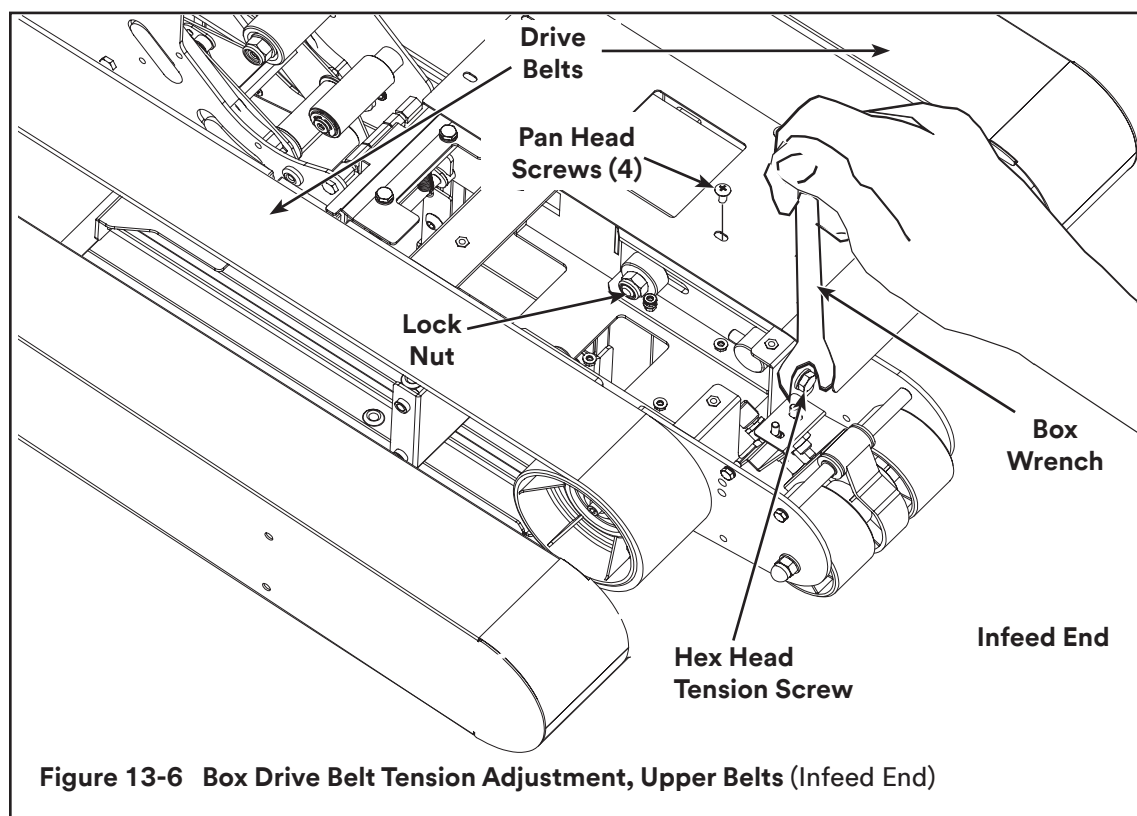


Figure 13-6 Box Drive Belt Tension Adjustment, Upper Belts (Infeed End)

13. Maintenance and Repairs *(continued)*

13.11 Special Set-Up Procedure - Column Bumper Installation

Purpose of Bumper Special Set-up Procedure: Installing Column Bumpers restrict operating range of upper assembly in proportion to box sizes to be sealed (Figure 13-7A). This installation limits working cycle time resulting in increased operating speed.

Installation Instructions - Column Bumper (A parts package is included with the unit for installation purposes).

The Column Bumper will be located on the column according to the size of the box that is to be taped (Refer to Figure 13-7A).

1. Raise and Lock the Upper Drive Assembly.

Important: This procedure is for authorized personnel ONLY!

2. Turn off air supply/electric power.
3. Remove Guard (see Installation and Set-Up / Section 7), existing holes/installing Column Bumper should be visible.
4. Remove Column Bumper and set screw parts package from carton.
5. Position Bumper as needed (the recommended position is shown in Figure 13-7A).
6. After the new Bumper is installed, re-install the Safety Guard (see Installation and Set-Up Section 7).
7. Turn "On" Electric Power/Pneumatics and press Station "Start" Button.

* **Important:** Plate Change require when column is adjusted to "Raised" Position - Part #30 is removed and replaced by Part #12.

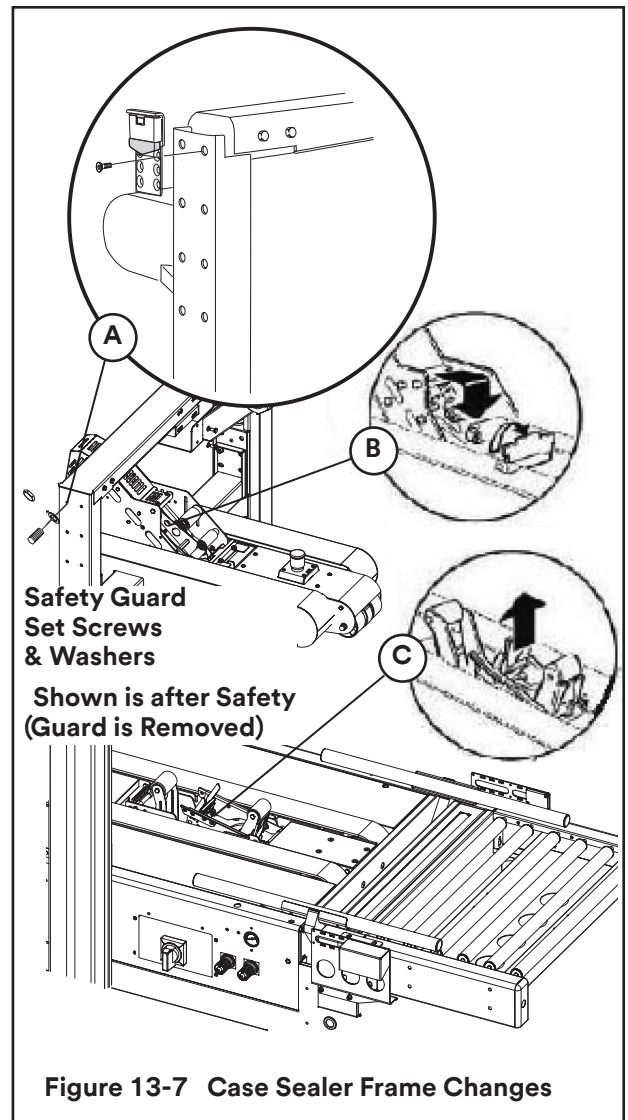
- Some bumper positions may:
 - 1) Allow upper and lower taping heads to come into contact with each other.
 - 2) Create added stress to the bumper.
 - 3) Cause malfunction of machine.

These events can potentially cause damage to machine. For more information on bumper settings, contact your 3M service representative.



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.



13. Maintenance and Repairs *(continued)*

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

Moving the outer columns will increase/decrease the maximum box height capacity of the 7000r-7000r3 Pro case sealer.

1. On both sides, place a solid spacer block (as needed to support column and to help line up new holes) between floor and bottom of outer column (Figure 13-8A).
2. On both front and rear, place solid spacer blocks (14" [355mm]) and lower the upper taping head assembly until the upper assembly rests on blocks.
3. Remove eight (8) column screws (Figure 13-8B).
4. Place second spacer block under column (Figure 13-8A).
5. Re-attach/tighten the eight (8) screws and washers in each column (Figure 13-8B).
6. Remove existing guard and attach inner guide plate using hardware provided (Figure 13-8B).

(continued)

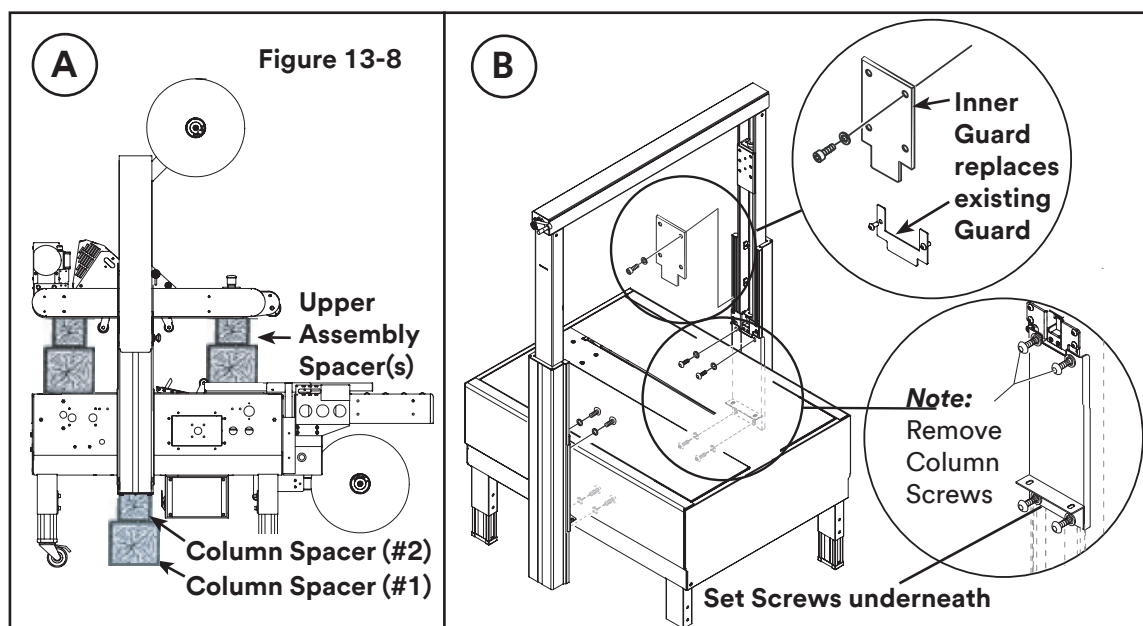
Important! When the column is in the upper position, the Inner Column Guard must be installed (Figure 13-8B).

Warning

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

Warning

- To reduce the risk associated with muscle strain:
 - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment
- To reduce the risk associated with impact hazards:
 - Always use appropriate supporting means when working under the upper drive assembly



13. Maintenance and Repairs *(continued)*

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

Moving the outer columns will increase or decrease the box height handled by the 7000r-7000r3 Pro case sealer.

Maximum Height:

An additional adjustment can be made to reach Maximum Height. This additional height adjustment can be made by moving the Upper Assembly Crossbar up to top holes - (Figure 13-9).

Box Height Range – (Refer to Figure 13-8 / Section 7 / and Specifications)

The operating range of the upper drive assembly can be adjusted to minimize its movement (which increases the operating speed) and in conjunction with adjusting the bed height, to change the range of box heights being sealed.

After establishing the minimum box height to be sealed, position the stop bumpers as follows:

1. Latch upper drive assembly in upper position, turn off air and electric.
2. Remove and relocate the stop bumper assembly to the desired position on both side columns. Be sure that the stop bumpers are reassembled as shown and secure (Figure 13-7).
3. Turn on the air and electrical power to the case sealer. The upper taping head will now descend only part way thus increasing operating speed.



Warning

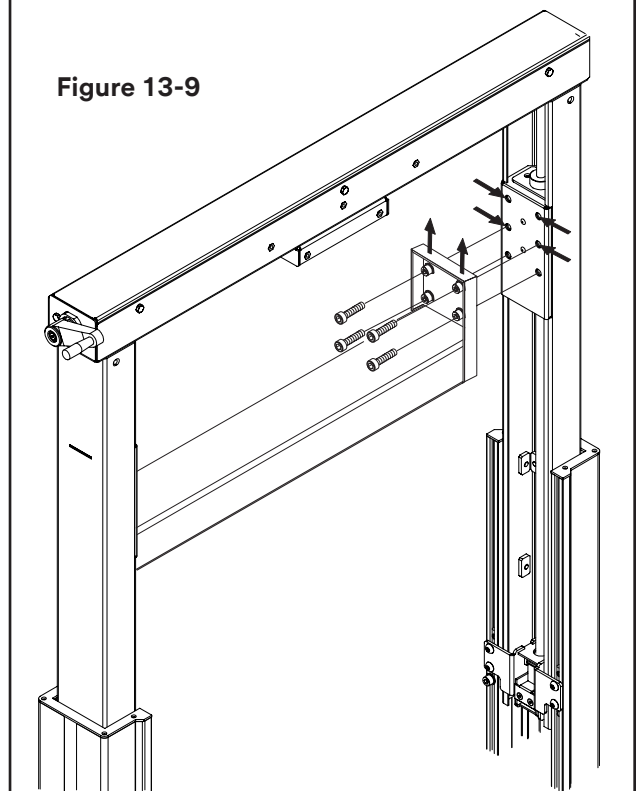
- To reduce the risk associated with mechanical and electrical hazards:
 - Turn peumatic and electrical supplies off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.



Warning

- To reduce the risk associated with muscle strain:
 - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment
- To reduce the risk associated with impact hazards:
 - Always use appropriate supporting means when working under the upper drive assembly

Figure 13-9



13. Maintenance and Repairs (continued)

13.13 List of the Maintenance Operations

Date:

Description of Operation

This image shows a blank sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

14. Additional Instructions

14.1 Information for Disposal of Machine (ELV)

The machine is composed of the following materials:

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

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

14.2 Emergency Procedures

In case of danger/fire:

Disconnect plug of power cable from power supply (Figure 14-1).

IN CASE OF FIRE

Use a fire extinguisher that is rated for electrical fires (Figure 14-2).

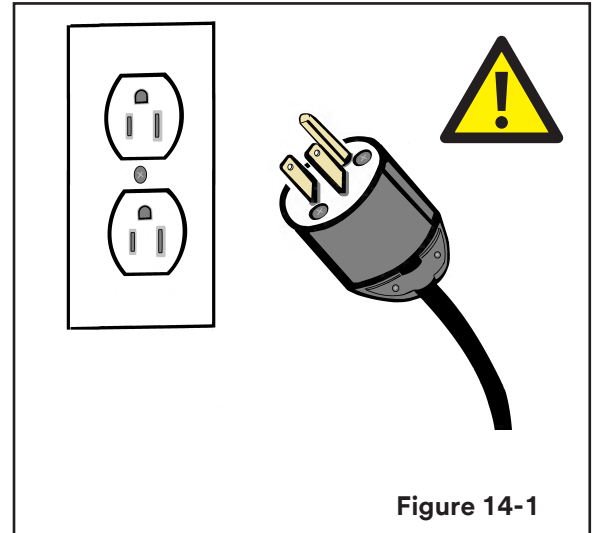


Figure 14-1

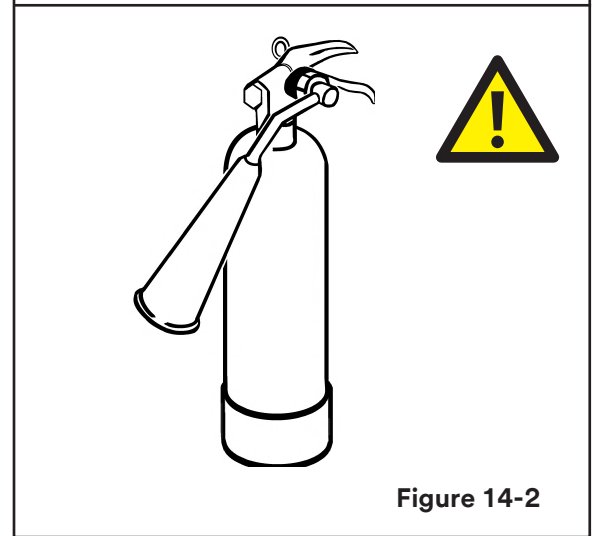


Figure 14-2

15. Additional Information

15.1 Statement of Conformity

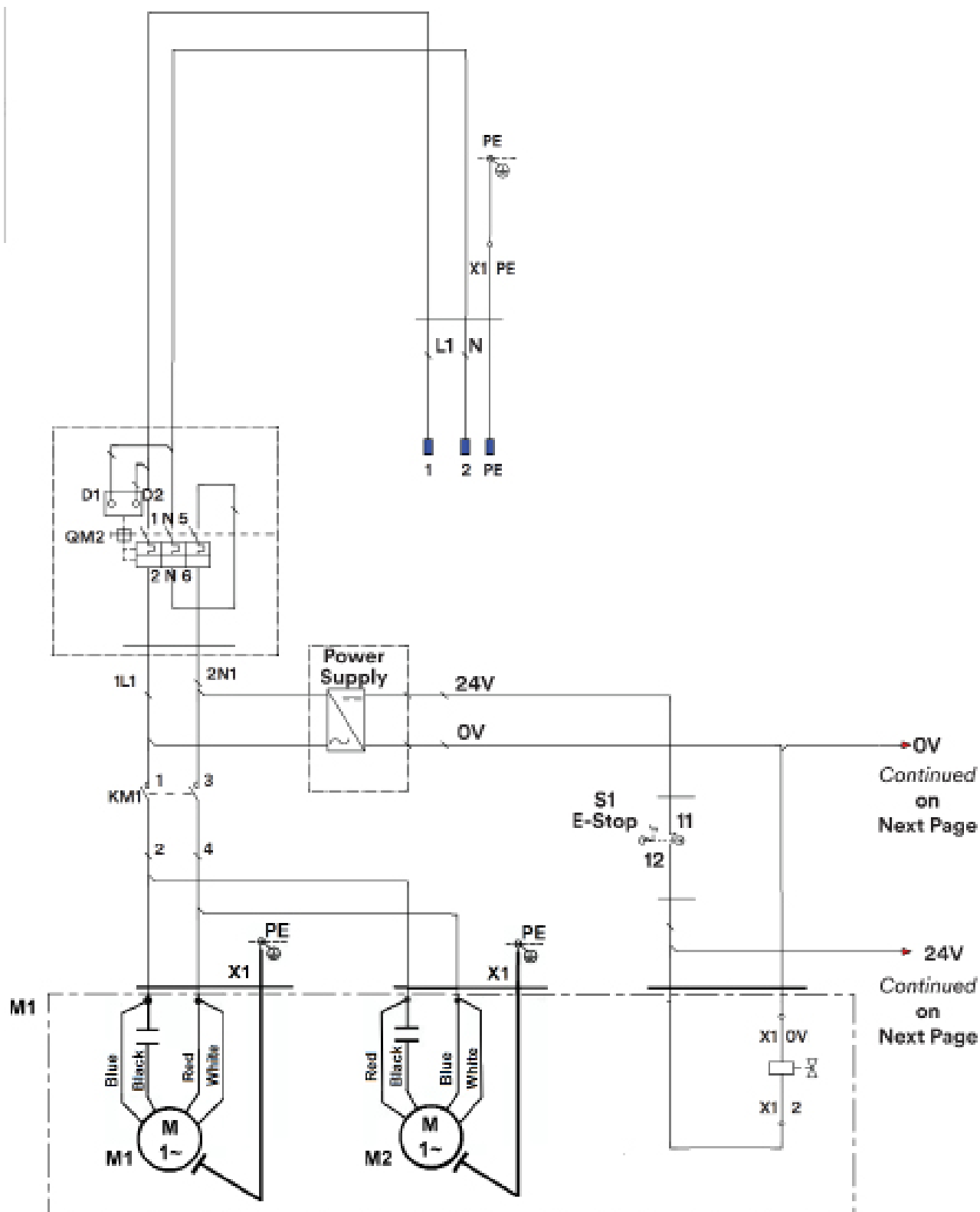
N/A

15.2 Emission of Hazardous Substances

Nothing to report

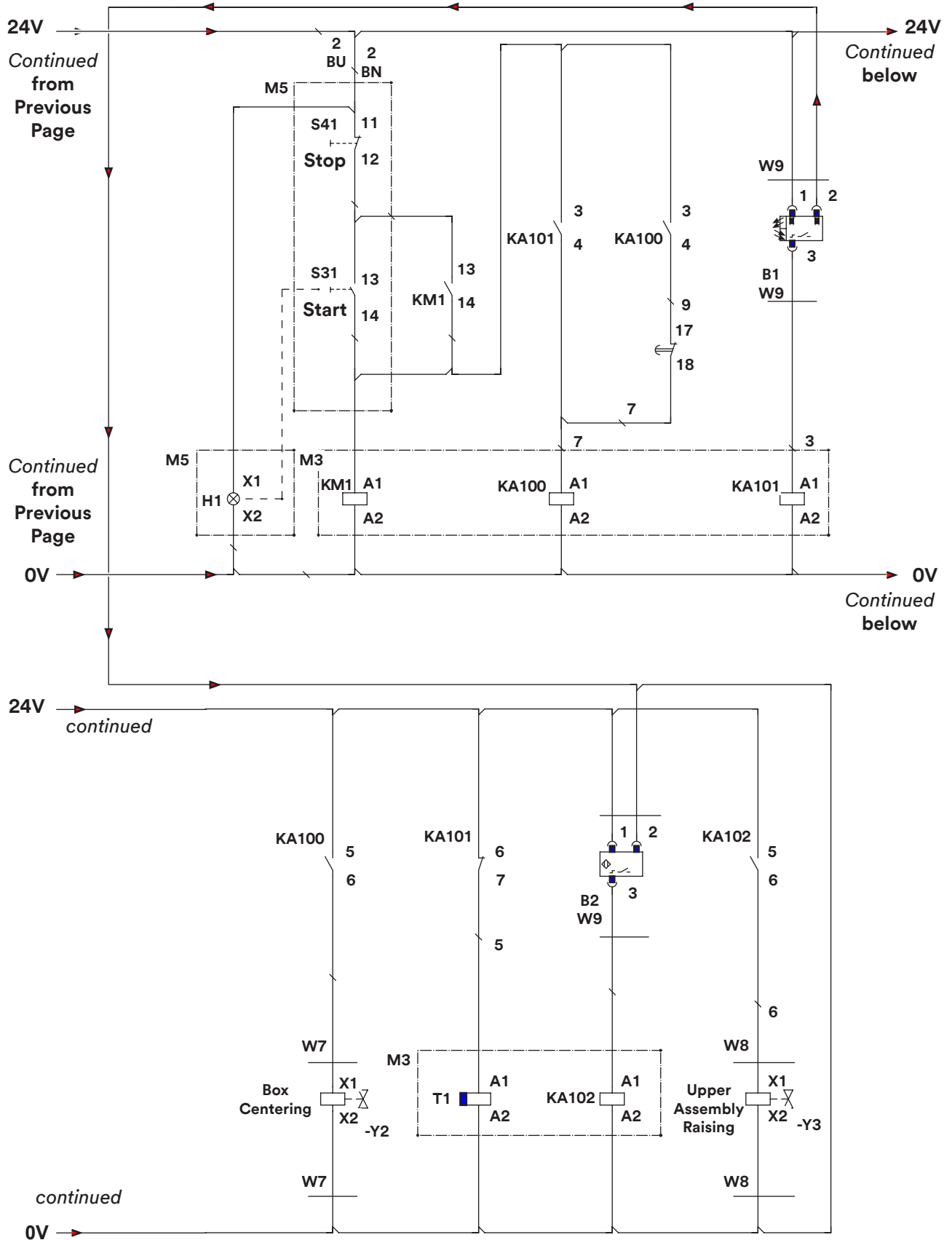
16. Technical Documentation and Information *(continued)*

16.1 Technical Diagrams - Electric



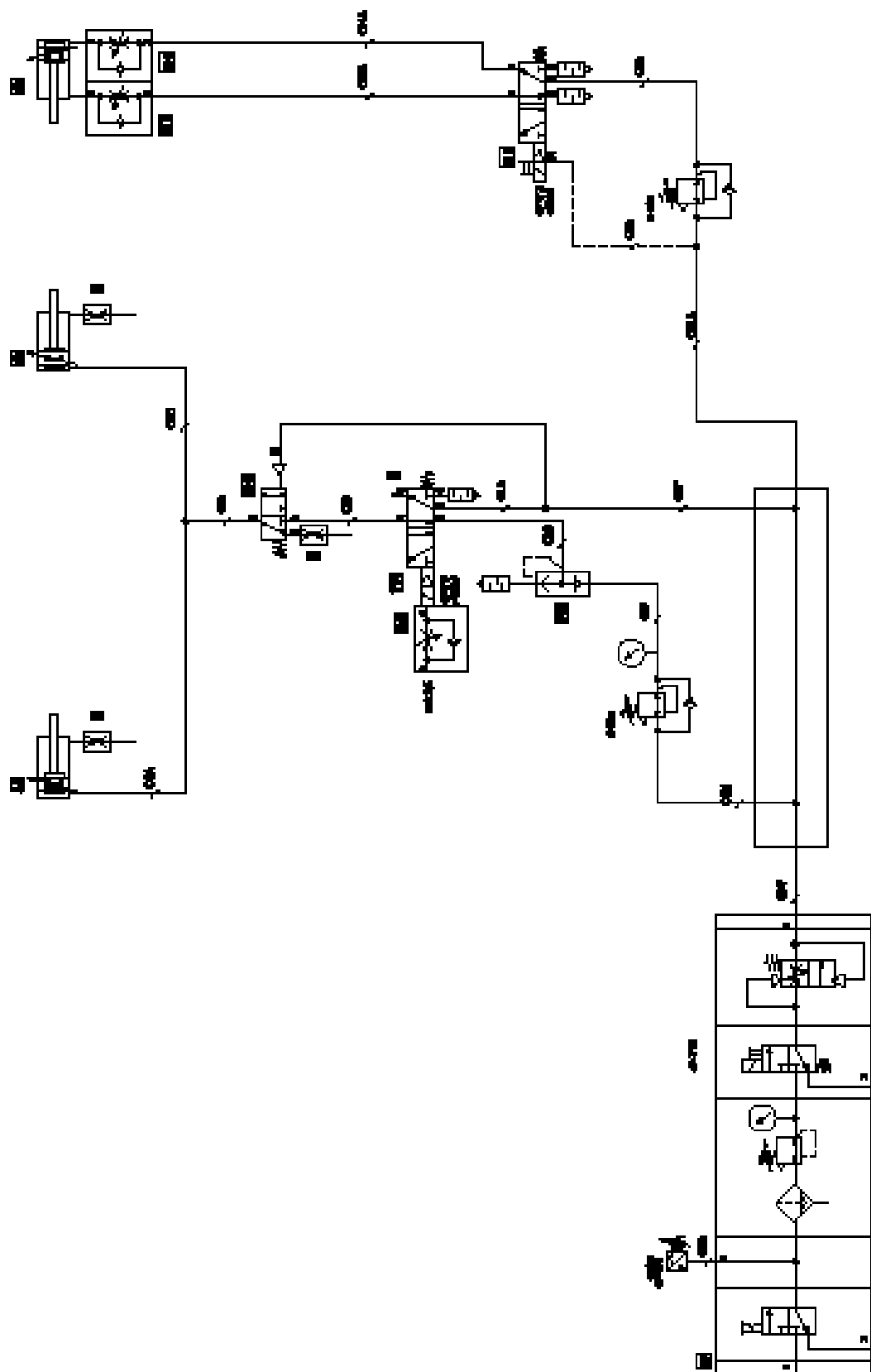
16. Technical Documentation and Information *(continued)*

16. Technical Diagrams - Electric *(continued)*



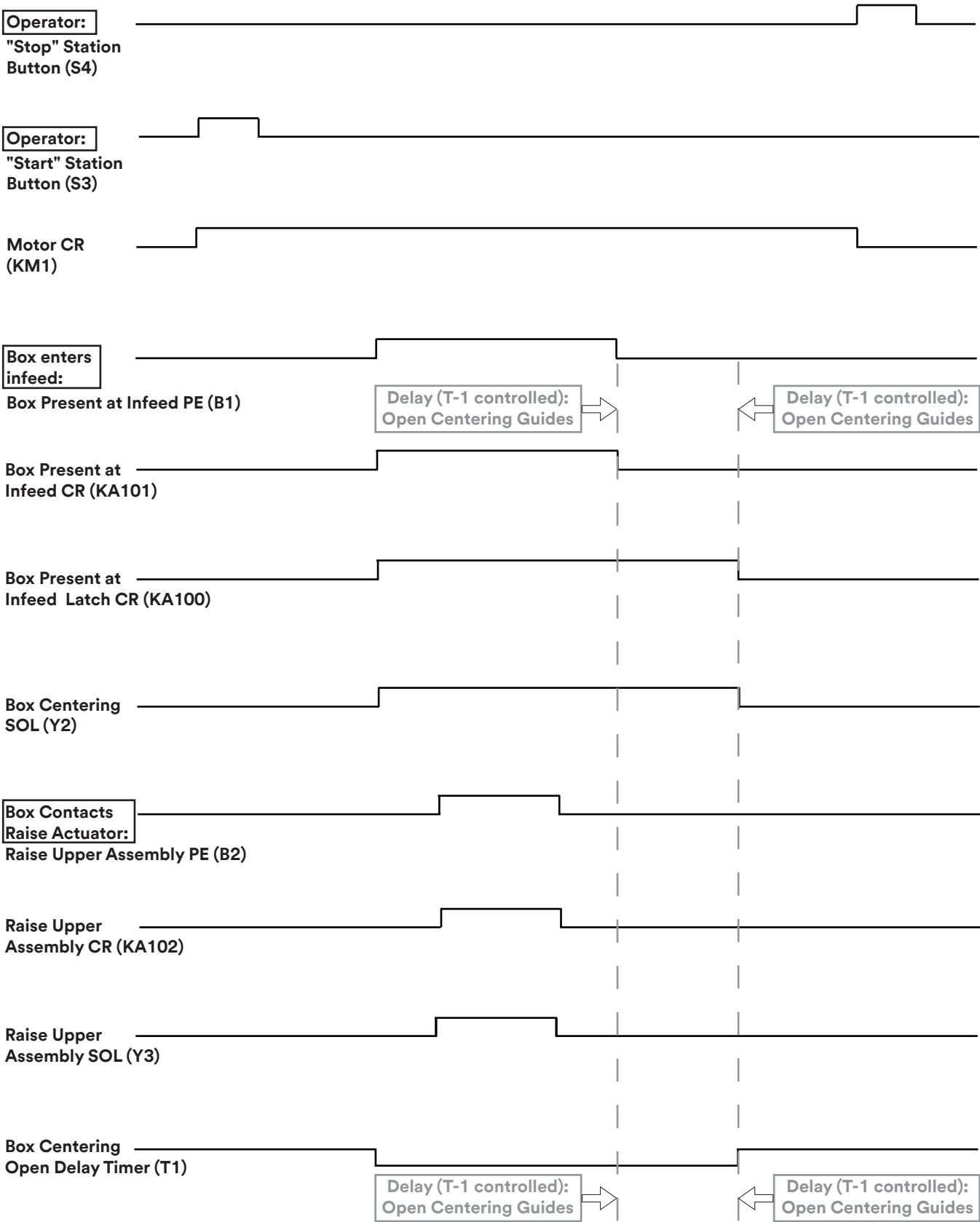
16. Technical Documentation and Information *(continued)*

16.2 Technical Diagrams - Pneumatic



16. Technical Documentation and Information *(continued)*

16.3 Technical Diagrams - Electrical Component Timing



16. Technical Documentation and Information *(continued)*

16.4 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 – 7000r-7000r3 Pro Random Case Sealer

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

7000r-7000r3 Pro

Qty.	3M-Part Number	Description
2	78-8137-6303-0	Belt-Drive w/Hook

Spare Parts Kit

7000r - Part Number 78-8137-8728-6
7000r3 - Part Number 78-8137-8729-4

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 78-8137-7538-0, is available as a stock item. It contains all the safety labels used on the 7000r-7000r3 Pro Random Case Sealer.

Tool Kit

A tool kit, part number 78-8137-7541-4, 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)*

7000r-7000r3 Pro Random 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
70-0064-2998-2	Caster Kit Attachment
70-0067-5966-9	Conveyor Extension Attachment
78-8069-3926-6	Low Tape Sensor Kit
70-0064-1097-4	Tape Application Monitor (TAM)
70-0064-1104-8	Tape Application Monitor - Tape Outboard
78-8095-4854-4	Tape Edge Fold Attachment - Upper Head 2 inch
78-8095-4855-1	Tape Edge Fold Attachment - Lower Head 2 inch
70-0067-3769-9	Filler Plate - Lower

