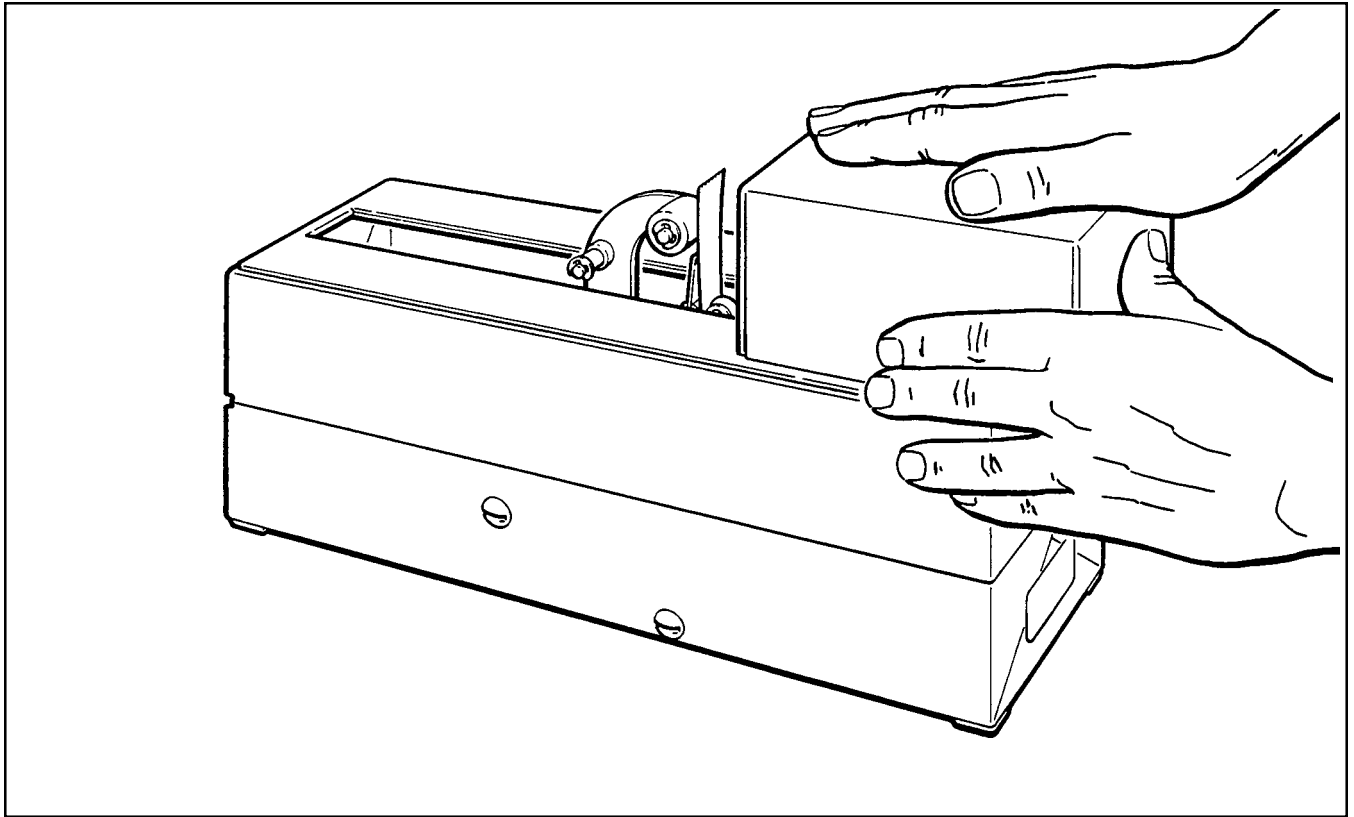


# Instructions and Parts List

**Scotch**<sup>™</sup>  
BRAND

## S-634 Manual Box Sealer Model 28500



**S-634 Manual Box Sealer – Model 28500**

### Description

The “Scotch” brand S-634 Manual Box Sealer applies a 4 inch [100 mm] long “L” shaped clip of “Scotch” brand Filament Tape with equal length legs when a box is passed across the top of the sealer. It can be operated from a table or bench as shown above, or it can be placed into a cut-out recess in a bench for flush-mounted operation.

### Specifications

**Tape:**

For use with most “Scotch” brand filament tapes.

**Tape Widths:**

3/8 inch or 9 mm minimum to 3/4 inches or 18 mm maximum.

**Tape Roll Diameter:**

Up to 5-1/2 inches [140 mm] on a 3 inch [76.2 mm] diameter core.

**Overall Dimensions:**

Length	16-1/4 inches [410 mm]
Height	8-1/4 inches [210 mm]
Width	5-1/2 inches [140 mm]

**Weight:**

Packaged	13-3/4 lbs [6.2 kg]
Unpackaged	13 lbs. [5.9 kg]

## Loading Instructions



**WARNING – Use care when working near blade as blade is extremely sharp.**

1. Place tape roll (A) fully on tape drum (B) so when the tape is pulled toward the stripper assembly (C) the tape adhesive side is up.
2. Thread the tape from the tape roll (A) over the plain roller (D), under the knurled roller (E) and up between the crease roller (F) and the tape guide (G).
3. Pull approximately 4 inches or 100 mm of tape through the stripper assembly (C). With the thumb against adhesive side of tape, pivot the applying roller (H) toward the blade assembly (J). When the blade is actuated into the tape, continue to pull the tape until cut-off is complete.
4. Close cover to begin operation.

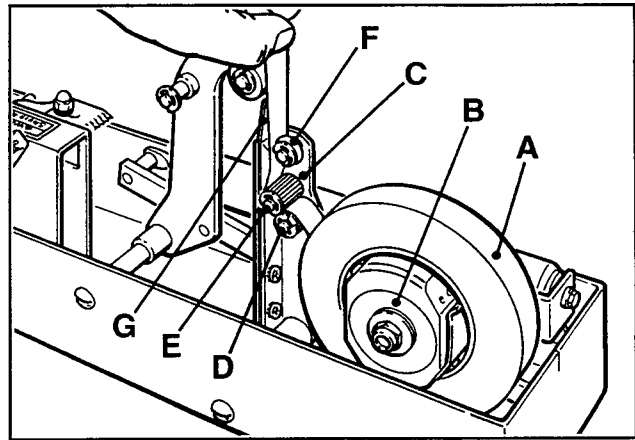


Figure 1

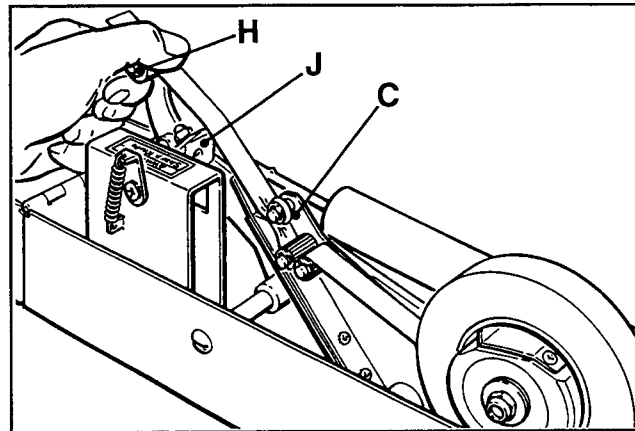


Figure 2

## Operating Instructions

Place the container on the Box Sealer top surface with the edge to be taped square with the applying roller (H). Move the container completely across the sealer top surface to seal the container with an "L" shaped tape clip.

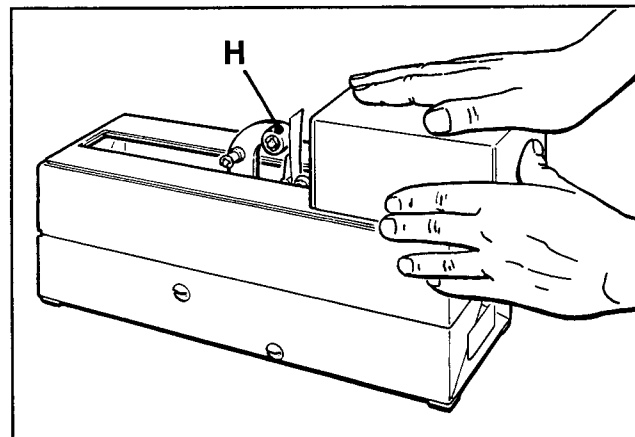


Figure 3

## Adjustments

**Tape Web Alignment –** Refer to Figure 4. Center the tape on the crease wheel (F) by loosening the screw (K) and sliding the tape roll (A) in the desired direction. Allow for clearance between the edge of the tape roll and the side of the stripper arm assembly (C). Retighten screw (K). This adjustment must be made for each different width tape used.

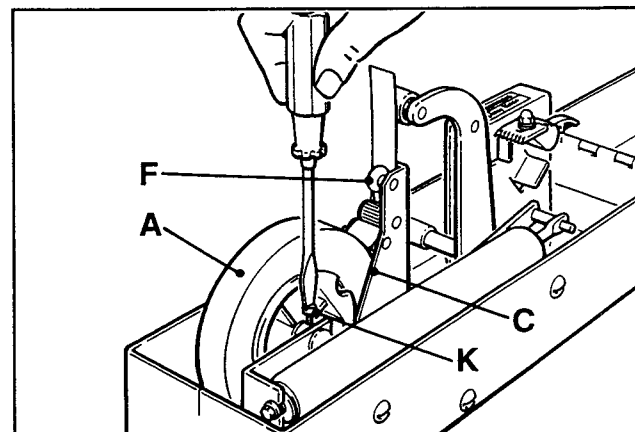


Figure 4

## Adjustments (Continued)

Tape Web Tension – Refer to Figure 5. Adjust the tape tension nut (clockwise to increase tension, counterclockwise to decrease tension) to obtain the proper cut-off for satisfactory tape application and to prevent the tape from sticking to the case due to the over spinning of the tape roll.

## How To Replace the Blade



**WARNING**– Use care when working near blade as blade is extremely sharp.

Refer to Figure 6.

1. Loosen but do not remove blade mounting screw/acorn nut (1) and remove used blade.
2. Insert new blade (2), beveled cutting edge of blade up, between flat washer and blade hinge assembly (3).
3. Position blade against blade stop on blade hinge assembly (3) and tighten blade mounting screw/acorn nut (1).

## Maintenance

### Lubrication

The S-634 Box Sealer uses self-lubricated bearings. Routine lubrication of the Box Sealer is not required.

## Replacement Parts List

Ref No.	Part Number	Description
1	70-8671-7400-8	Check Cylinder
2	70-8126-1320-9	Buffing Roller Assembly
3	26-1003-3501-2	Spring – Extension
4	78-8032-3554-4	Bumper
5	70-8041-8401-1	Bracket – Spring
6	70-8126-0136-0	Roller – Trip Pin
7	70-8658-9000-1	Washer
8	70-8634-9605-8	Spring – Leaf
9	70-8693-3721-5	Guide – Tape
10	70-8126-1825-7	Roller – Crease
11	70-8126-1042-9	Roller – Knurled
12	78-8032-1536-3	Washer – Curved
13	78-8161-8074-5	Bearing – Sleeve “Oilite” AA-307
16	78-8003-8677-9	Bearing – Flange Thomson #6LI-FF
18	78-8023-2190-7	Drum – Tape
19	78-8023-2613-8	Retainer – Tape

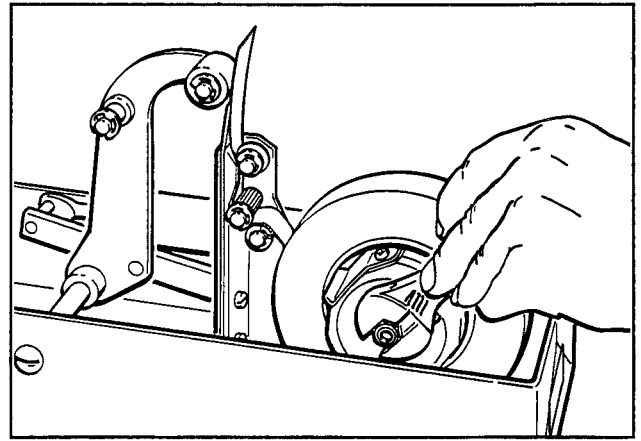


Figure 5

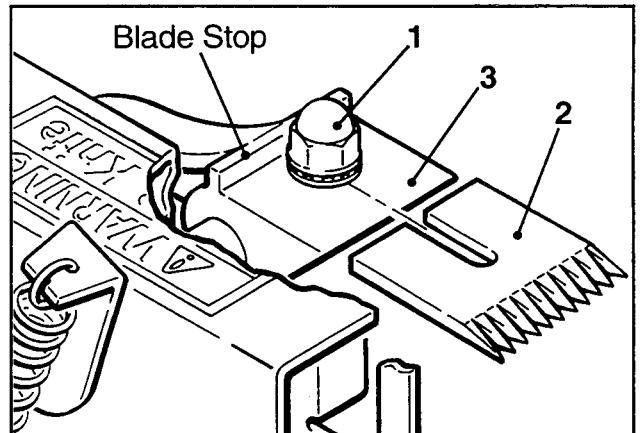


Figure 6

DO NOT lubricate the tape drum tension assembly or the return arm on the check cylinder – Ref. No. 1, Figure 7.

Ref No.	Part Number	Description
20	12-7994-9492-2	Spring – Ext.
21	70-8656-9000-5	Orifice Screw
22	26-1002-4949-4	Screw-Self-Tap, Phil Pan Hd 6-19 x 3/8 Lg.
23	18-1756-3403-1	Nut – Self Lock Hex 3/8-24
24	70-8659-1600-4	Washer – Friction (Metal)
25	78-8052-6293-4	Washer – Friction (Felt)
26	78-8052-6292-6	Shaft – Drum Brake
27	78-8003-9255-3	Screw – Machine Fill Hd Slotted 8-32 x 1/2 Lg.
28	70-8160-5501-9	Bearing
29	78-8046-8438-5	Link
30	78-8068-3876-5	Spacer
31	78-8046-8405-4	Blade Hinge Assembly
32	70-8601-0078-6	Blade – Serrated
33	12-7996-2818-0	Ring – Retaining, Waldes Tru-Arc #5133-25
34	70-8261-6512-1	Sealer Arm

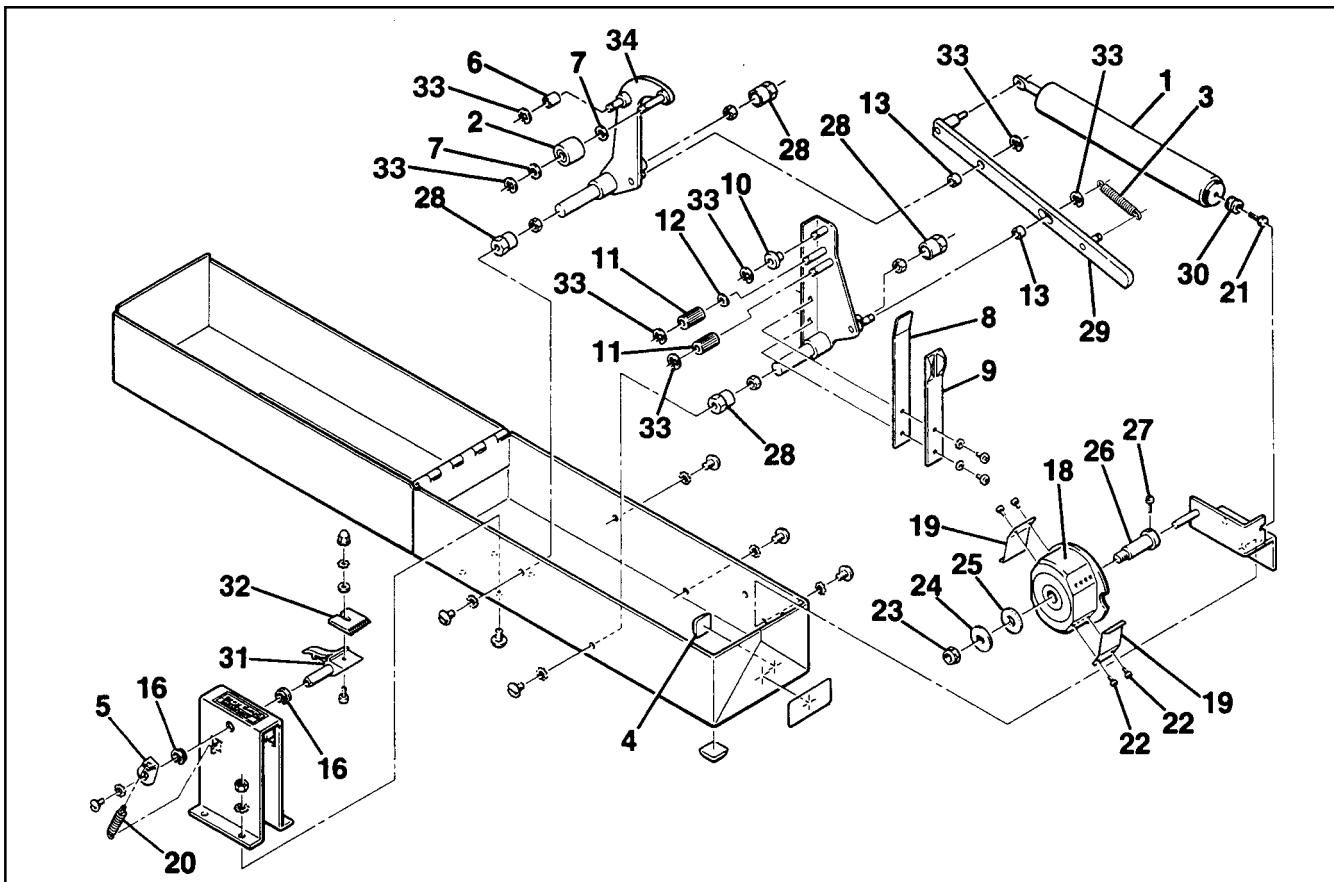


Figure 7 – Replacement Parts

### HOW TO ORDER REPLACEMENT PARTS

1. Refer to Parts Illustration Figure 7 to find part needed and reference number.
2. Refer to parts list for correct part number.
3. Order by **part number, description, dispenser name and model number.**

4. Replacement parts and part prices available direct from:

**3M/Tape Dispenser Parts** 800/344 9883  
**241 Venture Drive**  
**Amery, WI 54001-1325** FAX # 715/268 8153

5. Machine repair service ship direct to:  
**Tape Equipment Repair Services**  
**241 Venture Drive**  
**Amery, WI 54001-1325**

Minimum billing on parts orders will be \$25.00. Replacement part prices available on request.  
 \$10.00 restocking charge per invoice on returned parts.  
 Note: Outside the U.S. contact the local 3M subsidiary for parts ordering information.

**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 FITNESS FOR A PARTICULAR PURPOSE AND ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, A CUSTOM OR USAGE OF TRADE:**

3M warrants that its **Scotch™** brand dispensers will be free from defects for ninety (90) days after delivery. If any part is proved to be defective within the 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 the 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.

**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.



**3M Masking and Packaging Systems Division**  
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