



Instructions and Parts List

3M-MaticTM

800r Type 40800

Random Case Sealer

with AccuGlideTM 2+ Taping Heads

Serial No. _____
For reference, record machine serial number here.



3M Industrial Adhesives and Tapes
3M Center, Building 220-5E-06
St. Paul, MN 55144-1000



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.

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Printed in U.S.A

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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 800r-NA** Adjustable case sealer.

3M Industrial Adhesives and Tapes
3M Center, Building 220-5E-06
St. Paul, MN 55144-1000

Edition January 2010

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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. If technical assistance or replacement parts are needed, call or fax the appropriate number listed below.

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

Technical Assistance / Replacement Parts and Additional Manuals:

Contact your local service provider. 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 800r - Type 40800 - Serial Number 13282).

Identification Plate

3M 3M Company St. Paul, MN 55144 USA	Part Number <input type="text"/>	3M-Matic™			
Model <input type="text"/>	Serial Number <input type="text"/>	Year <input type="text"/>	Ampere <input type="text"/>	Watt <input type="text"/>	
Type <input type="text"/>		Volt <input type="text"/>	Hertz <input type="text"/>	Phase <input type="text"/>	

Minimum billing on parts orders will be \$25.00. Replacement part prices available on request.
\$10.00 restocking charge per invoice on returned parts



3M Industrial Adhesives and Tapes

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St. Paul, MN 55144-1000

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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.



3M Industrial Adhesives and Tapes
3M Center, Building 220-5E-06
St. Paul, MN 55144-1000

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Instruction Manual

800r Random Case Sealer, Type 40800

This instruction manual is divided into two sections as follows:

- Manual 1** Includes all information related to installation, operation and parts for the case sealer.
- Manual 2** Includes specific information regarding the AccuGlide™ 2+ STD 2 Inch Taping Heads.

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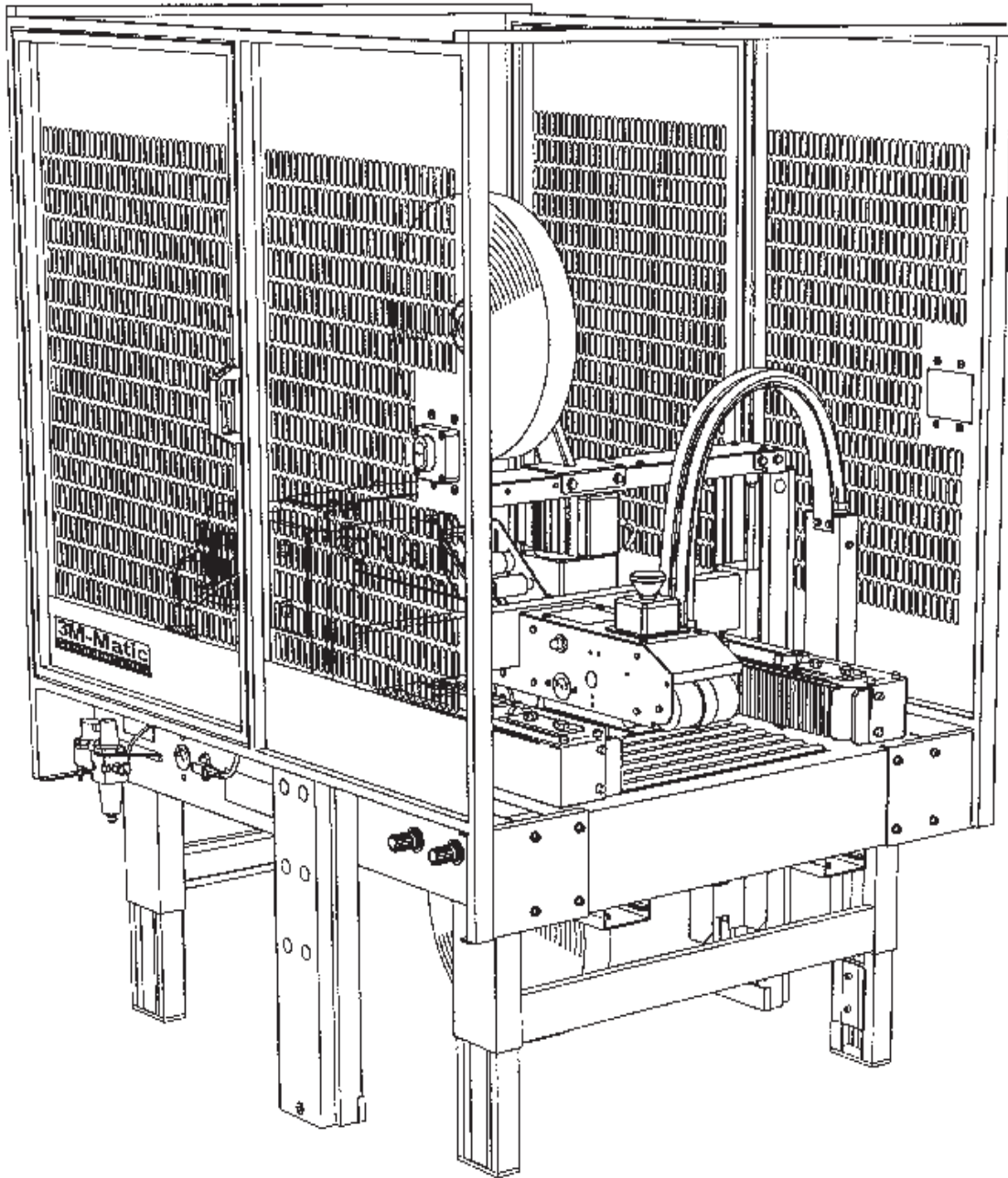
Manual 2 – AccuGlide™ 2+ STD 2-Inch Taping Head
 (See Manual 2 for Table of Contents)

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
PTFE	- Polytetrafluorethelene
PVC	- Poly-vinyl chloride
W	- Width
H	- Height
L	- Length

Intended Use

The intended use of the **3M-Matic™ 800r Random Case Sealer** with **AccuGlide™ 2+** Taping Heads is to apply a “C” clip of **Scotch®** brand pressure-sensitive film box sealing tape to the top and bottom center seam of regular slotted containers. The case sealer automatically adjusts to a wide range of box sizes (see "Specifications – Box Weight and Size Capacities")



3M-Matic™ 800r Random Case Sealer, Type 40800

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

Important – In the event the following safety labels are damaged or destroyed, **they must be replaced to ensure operator safety.** A label kit, part number 78-8113-6778-4 is available as a stock item or individual labels can be ordered.

The "Warning - Hazardous Voltage" label, shown in **Figure 1-2**, is attached to the electrical enclosure on the lower right side of the machine frame. The label warns service personnel to unplug the power supply before attempting any service work on the case sealer.



Figure 1-2 – Electrical Warning Label

Two "Warning Sharp Knife" labels, shown in **Figure 1-1**, are attached to both sides of the upper assembly at the location of the cut-off knife on the upper taping head. The labels warn operators and service personnel of the very sharp knife used to cut the tape at the end of the tape application.

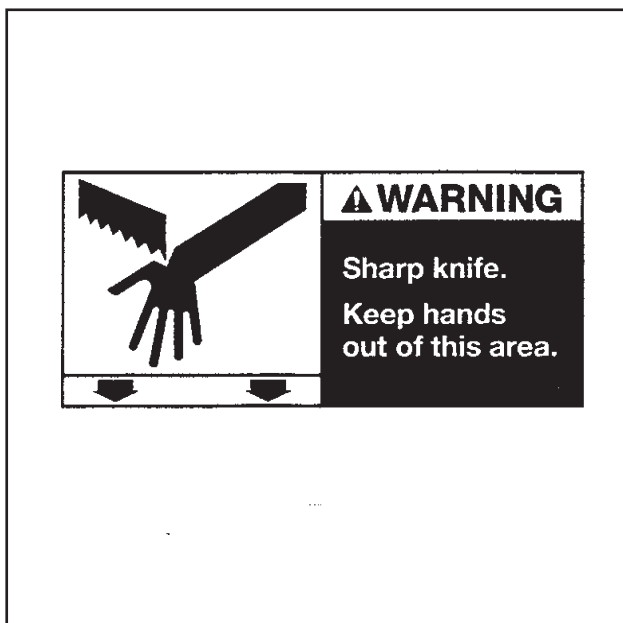


Figure 1-1 – Knife Warning Label

The two "Warning – Keep Away From Moving Belts" labels, shown in **Figure 1-3**, are located on each side of the top surface of the machine bed at the infeed end. These labels warn operators and service personnel to keep hands away from this area when the drive belts are running.

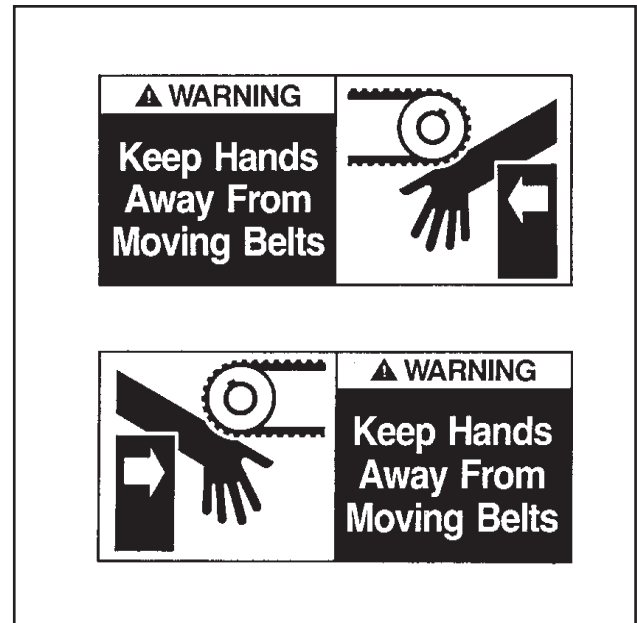


Figure 1-3 – Hands Warning Label

Important Safeguards

The **"Stop"** label, shown in **Figure 1-4**, is located in front of the E-Stop switch and reminds operators and casual personnel of the function of this switch. In addition, an **"On/Off"** label is attached next to the On/Off switch on the left machine guard at the infeed end.

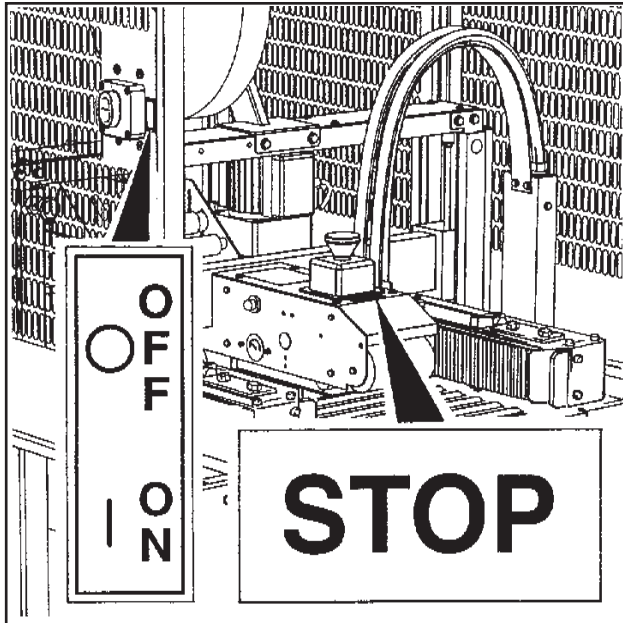


Figure 1-4 – Stop and On/Off Labels

The **"Safety Instructions"** label, shown in **Figure 1-5**, is attached to the front of the upper assembly. The label provides convenient safeguard instructions for the operator and service personnel.

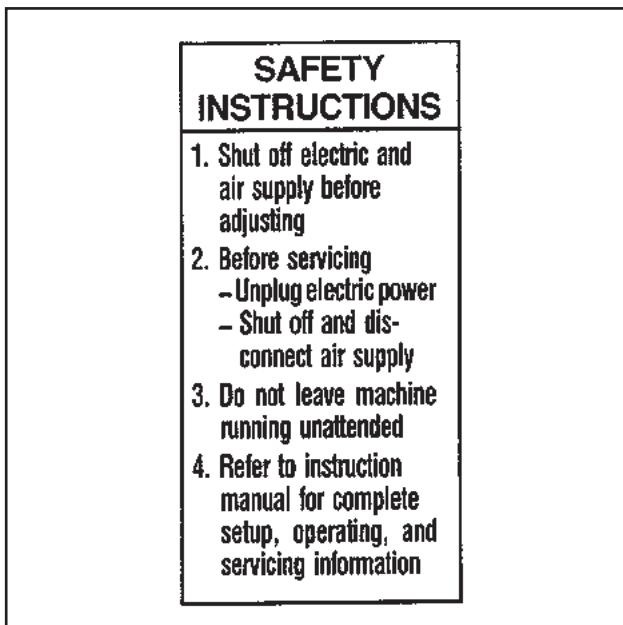


Figure 1-5 – Safety Instructions Label

The **"Safety Instructions"** label, shown in **Figure 1-6**, is attached to the frame next to the air valve/regulator and reminds operator of correct air pressure to use. The **"On/Off"** label reminds operators of the location of the pneumatic On/Off valve.

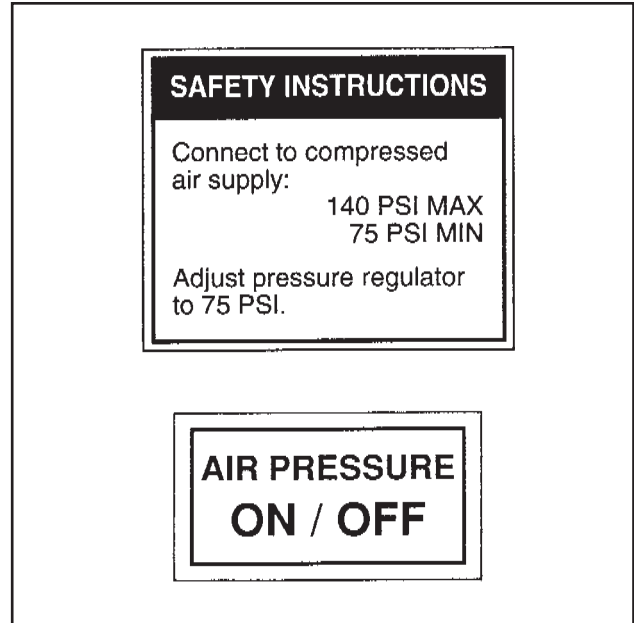


Figure 1-6 – Safety Instructions Label

Two **"Operating Notice"** labels, shown in **Figure 1-7**, are located on the top, infeed end of both drive belt assemblies. The labels remind operators of correct belt adjustment procedures.

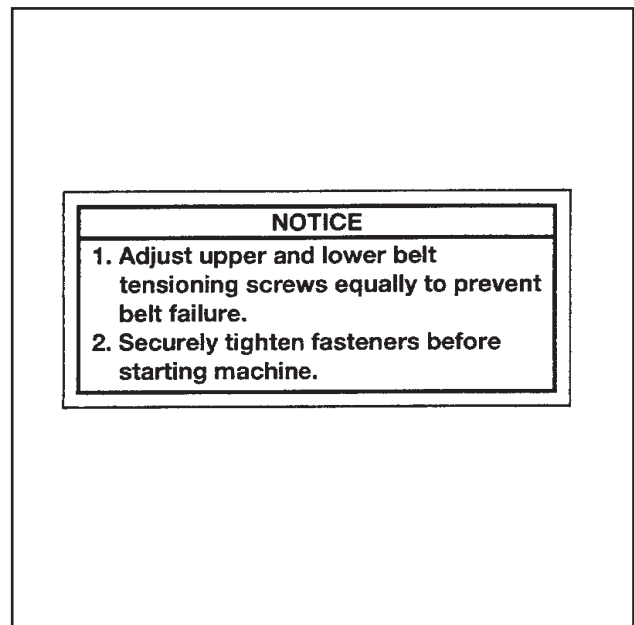


Figure 1-7 – Operating Notice Label

Important Safeguards

The "**Raise/Latch**" label, shown in **Figure 1-8**, is attached to the upper, middle of the left machine guard. The label provides quick reference instructions for raising, latching and unlatching the upper assembly.

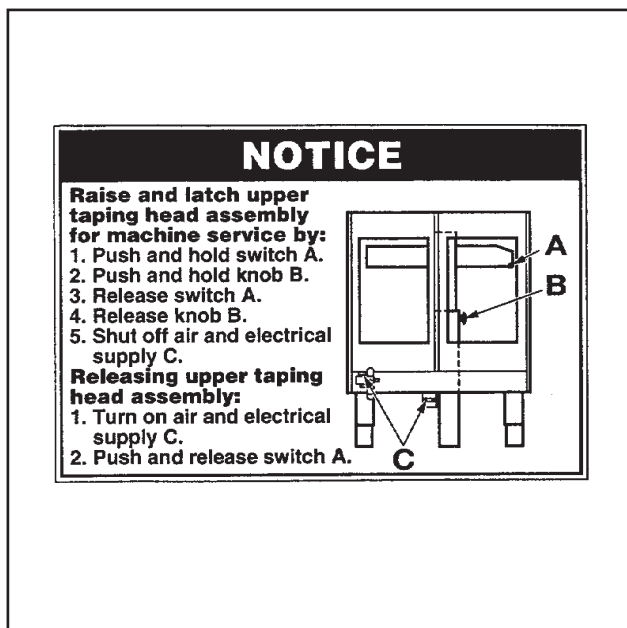


Figure 1-8 – Raise/Latch Upper Assembly Label

The "**Upper Head Pressure Gage**" label, shown in **Figure 1-10**, is attached to the upper assembly by the air pressure gage.

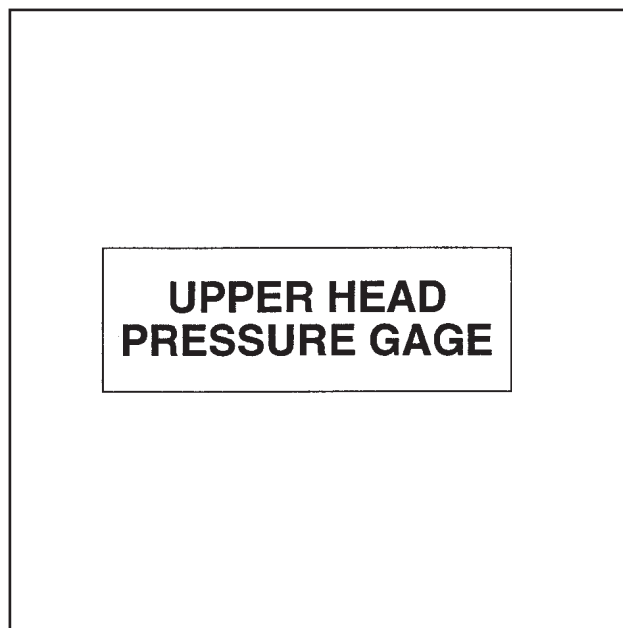


Figure 1-10 – Air Pressure Gage Label

The "**Force Adjustment**" label, shown in **Figure 1-9**, is attached to the left side of the machine frame at the infeed end. The label provides force adjustment information for the upper taping head assembly and belt centering.

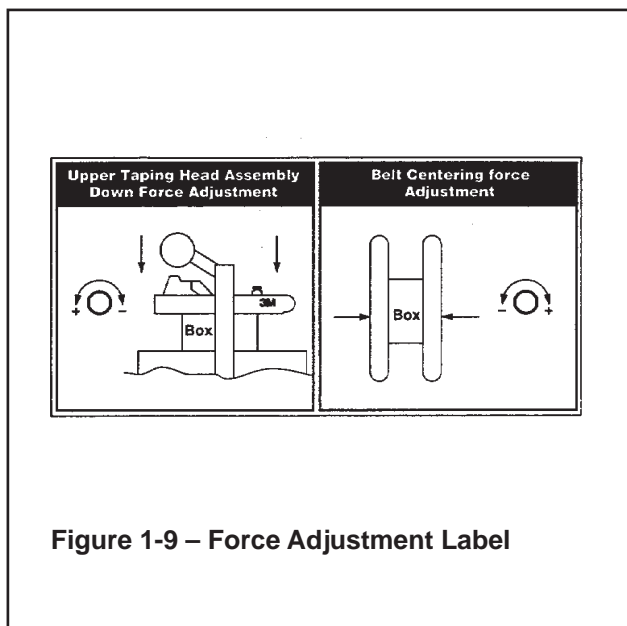


Figure 1-9 – Force Adjustment Label

Important Safeguards

The following two labels are located on the upper and lower taping heads. Replacement part numbers for these labels are listed below each label.

The "**Warning-Sharp Knife**" label warns operators and service personnel of the extremely sharp knife used to cut the tape at the end of the box sealing operation. The label, shown in **Figure 1-11**, is located on the orange knife guard between the applying roller assembly and the buffing roller assembly. **Never operate taping heads with knife guard removed.**

Before working with the taping heads or loading/threading tape, refer to **Figures 3-1 and 3-2** in Section II to identify the knife location. **Keep hands out of these areas except as necessary to service the upper taping heads or to load/thread tape.**

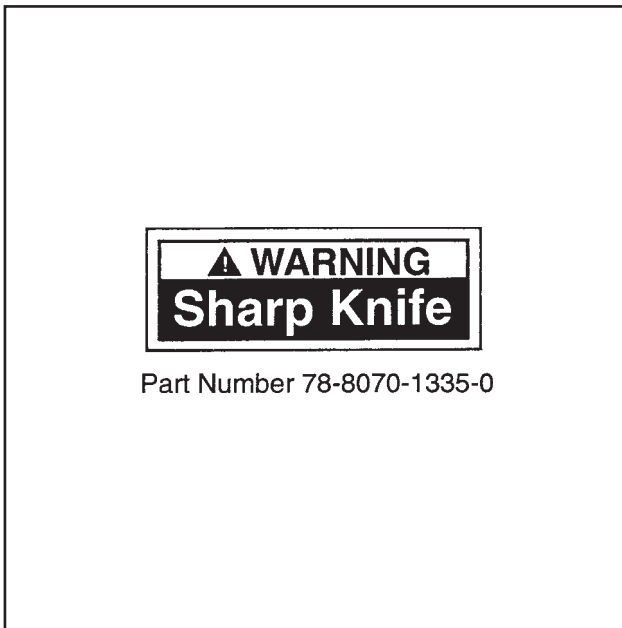


Figure 1-11 – Knife Warning Label

The "**Tape Threading Label**", shown in **Figure 1-12**, is attached to the left side of both the upper and lower taping heads. This label provides a convenient tape threading diagram. More detailed tape loading and threading information is provided in this manual in the set-up procedure section.

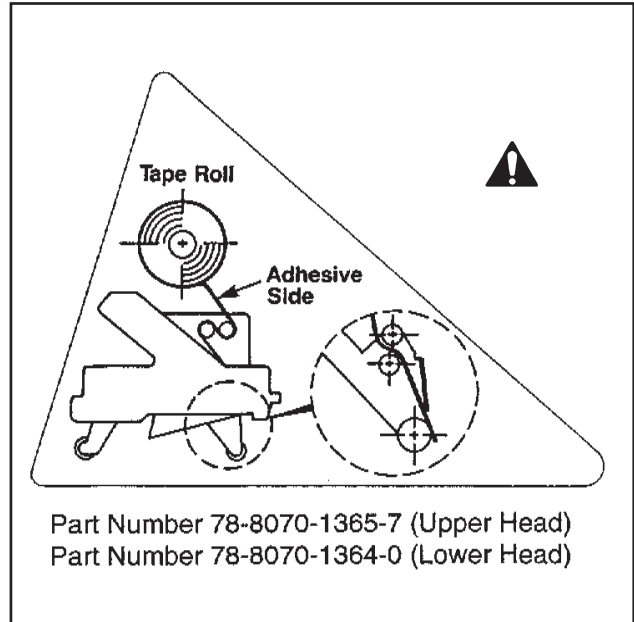
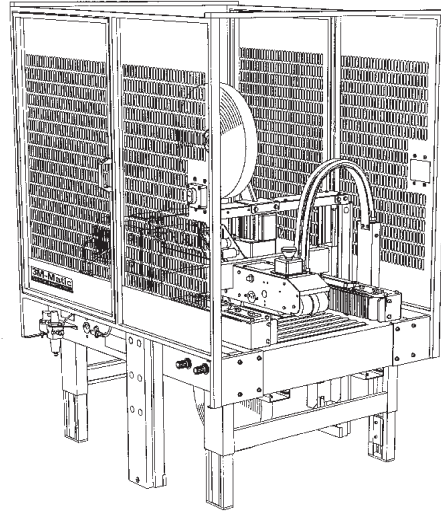



Figure 1-12 – Tape Threading Label

2.1 Data Identifying Manufacturer and Machine

3M
**3M Industrial Adhesives
and Tapes**

3M Center Bldg. 220-5E-06
St. Paul, MN 55144-1000 (USA)



3M 3M Company St. Paul, MN 55144 USA	Part Number	3M-Matic™			
	Model	Year	Ampere	Watt	
Type	Serial Number	Volt	Hertz	Phase	

2.2 Data for Technical Assistance and Service

**AGENT/DISTRIBUTOR OR LOCAL
AFTER SALE SERVICE:**

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

3M sells its **3M-Matic™ 800r Random Case Sealer, Type 40800** with the following warranties:

1. The drive belts and the taping head knives, springs and rollers will be free from defects in material and manufacture for ninety (90) days after delivery.
2. All other taping head parts will be free from defects in material and manufacture for three (3) years after delivery.
3. All other parts will be free from defects in material and manufacture for two (2) years after delivery.

If any part is defective within this warranty period, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to repair or replace the part. 3M must receive actual notice of any alleged defect within a reasonable time after it is discovered, but in no event shall 3M have any obligation under this warranty unless it receives such notice within five (5) business days after the expiration of the warranty period. All notices required hereunder shall be given to 3M solely through the 3M-Matic™ Helpline (800-328-1390). To be entitled to repair or replacement as provided under this warranty, the part must be returned as directed by 3M to its factory or other authorized service station designated by 3M. If 3M is unable to repair or replace the part within a reasonable time after receipt thereof, 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 remove any part or equipment or to install the repaired or replacement part or equipment. 3M shall have no obligation to repair or replace those parts failing due to normal wear, inadequate or improper maintenance, inadequate cleaning, non-lubrication, improper operating environment, improper utilities, operator error or misuse, alteration or modification, mishandling, lack of reasonable care, or due to any accidental cause.

Limitation of Liability: Except where prohibited by law, 3M and seller will not be liable for any loss or damage arising from this 3M equipment, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including breach of warranty, breach of contract, negligence, or strict liability.


Note: The foregoing Equipment Warranty and Limited Remedy and Limitation of Liability may be changed only by a written agreement signed by authorized representatives of 3M and seller.

800r Contents


- (1) 800r Random Case Sealer, Type 40800
- (1) Tool and Parts List
- (1) Instruction and Parts Manual


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Important Safeguards

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

Explanation of Signal Word Consequences

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

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

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/or service this equipment
 - Turn electrical and air supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads
- **To reduce the risk associated with pinch and entanglement hazards:**
 - Do not leave the machine running while unattended
 - Turn the machine off while 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
- **To reduce the risk associated with hazardous voltage:**
 - Position electrical cord away from foot and/or vehicle traffic

WARNING (continued)

- **To reduce the risk associated with impact hazards:**
 - Always use appropriate supporting means when working under the upper drive assembly
- **To reduce the risk associated with sharp blade hazards:**
 - Keep hands and fingers away from tape cutoff blades under orange blade guards. The blades are extremely sharp
- **To reduce the risk associated with fire and explosion hazards:**
 - Do not operate this equipment in potentially flammable/explosive environments
- **To reduce the risk associated with muscle strain:**
 - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment
 - Use proper body mechanics when removing or installing drive assemblies or taping heads that are moderately heavy or may be considered awkward to lift

CAUTION

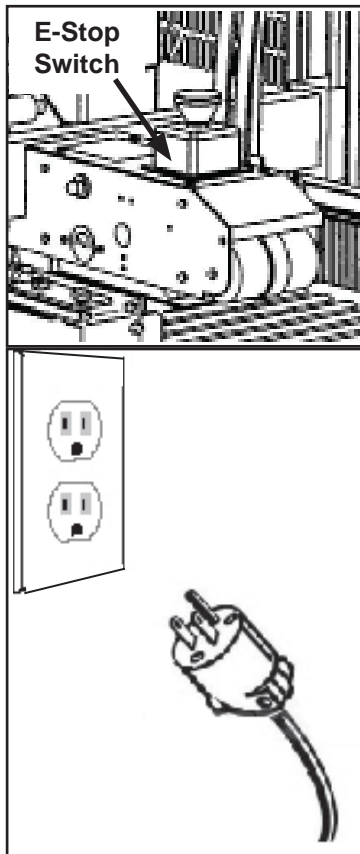
- **To reduce the risk associated with pinch and entanglement hazards:**
 - Keep hands clear of the upper head support assembly as boxes are transported through the machine
 - Always feed boxes into the machine by pushing only from the end of the box
 - Keep hands, hair, loose clothing, and jewelry away from moving belts and taping heads
- **To reduce the risk associated with pinch and impact hazards:**
 - Keep away from the pneumatically controlled upper drive assembly and box drive belts when air and electric supplies are on

3.1 General Safety Information

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



Figure 3-1



The machine is provided with a LATCHING EMERGENCY STOP BUTTON (**Figure 3-1**); when this button is pressed, it stops the machine at any point in the working cycle. Maintain clear access to power cord while machine is operating. Disconnect plug from power source before machine maintenance (**Figure 3-1**). Also disconnect air if the machine has a pneumatic system. Keep this manual in a handy place near the machine. This manual contains information that will help you to maintain the machine in a good and safe working condition.

3.2 Explanation of Signal Word and Possible Consequences



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





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




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

3.3 Table of Warnings

 WARNING
<ul style="list-style-type: none"> • To reduce the risk associated with mechanical and electrical hazards: <ul style="list-style-type: none"> – 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.

	SAFETY INSTRUCTIONS <ol style="list-style-type: none"> 1. Shut off machine before adjusting 2. Unplug electric power before servicing 3. Do not leave machine running unattended 4. Refer to instruction manual for complete setup, operating, and servicing information
Figure 3-2	

 WARNING
<ul style="list-style-type: none"> • To reduce the risk associated with hazardous voltage: <ul style="list-style-type: none"> – Position electrical cord away from foot and vehicle traffic.

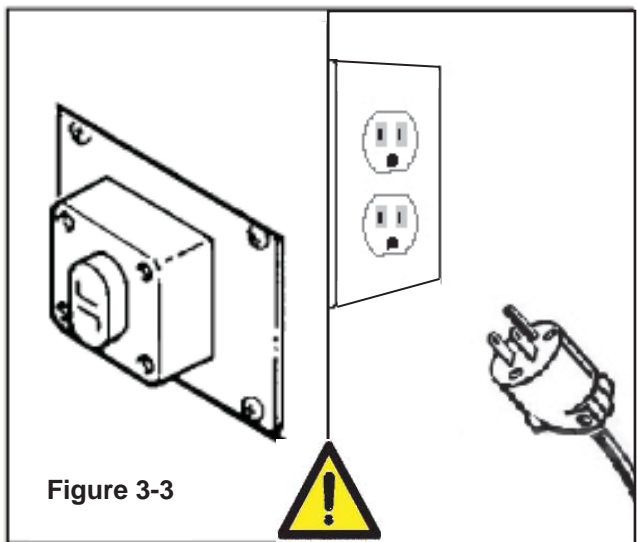



Figure 3-3

 WARNING
<ul style="list-style-type: none"> • To reduce the risk associated with pinches, entanglement and hazardous voltage: <ul style="list-style-type: none"> – Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.

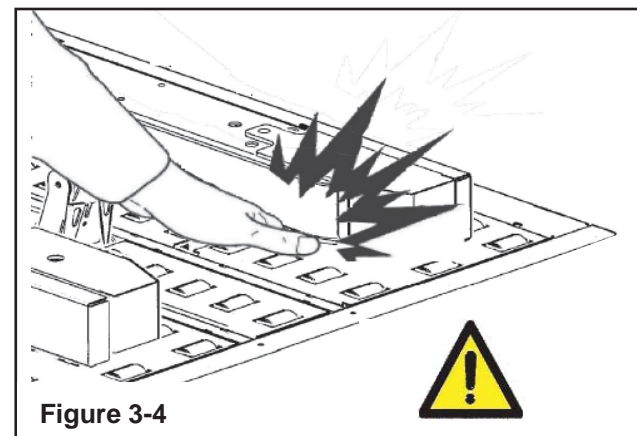



Figure 3-4

 WARNING
<ul style="list-style-type: none"> • To reduce the risk associated with pinches and entanglement hazards: <ul style="list-style-type: none"> – Do not leave the machine running while unattended. – Turn the machine off when not in use. – Never attempt to work on any part of the machine, load tape, or remove jammed boxes from the machine while the machine is running.

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



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 the safety device which covers the blade on the 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 the 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 pinches hazards:**
 - Keep hands clear of the upper head support assembly as boxes are transported through the machine.
 - Keep hands, hair, loose clothing, and jewelry away from box compression rollers.
 - Always feed boxes into the machine by pushing only from the end of the box.
 - Keep hands, hair, loose clothing, jewelry away from moving belts and taping heads.

IMPORTANT! Side belts. Keep hands away from moving parts (**Figure 3-7**).

IMPORTANT! Drive belts. Never work on the machine with loose hair or loose garments such as scarfs, ties or sleeves (**Figure 3-8**).

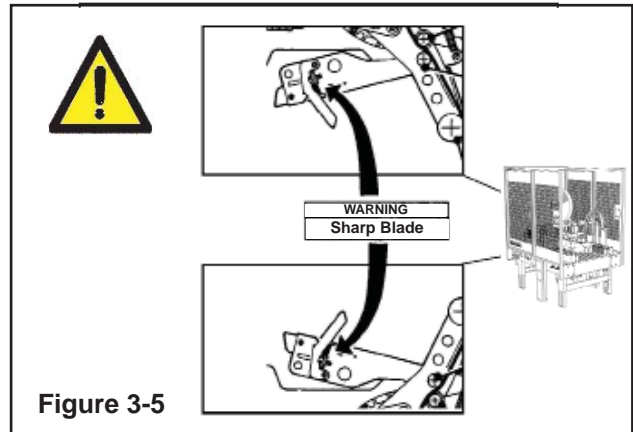


Figure 3-5

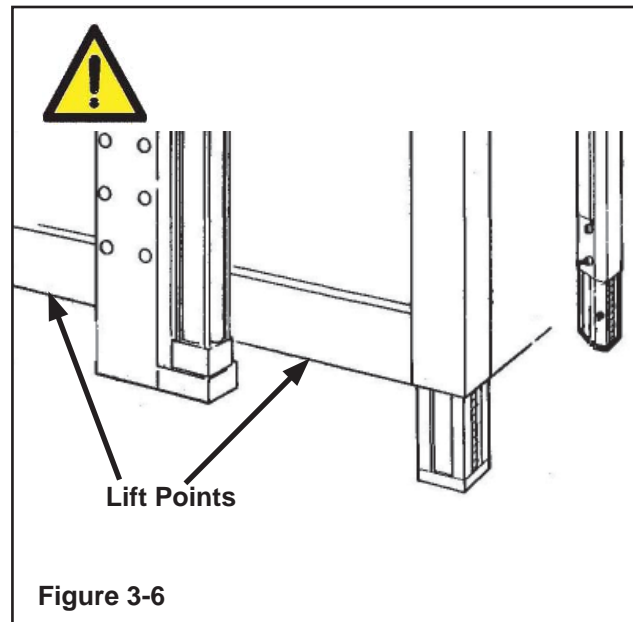


Figure 3-6

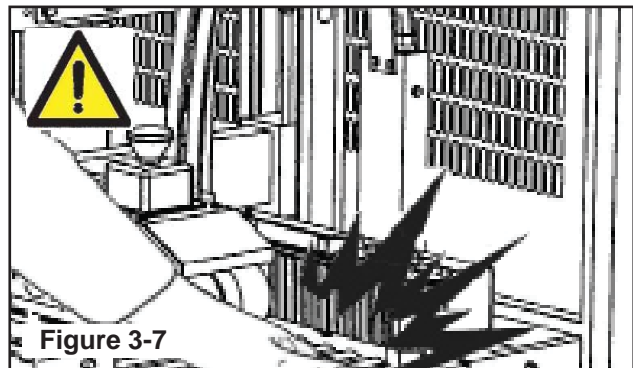


Figure 3-7

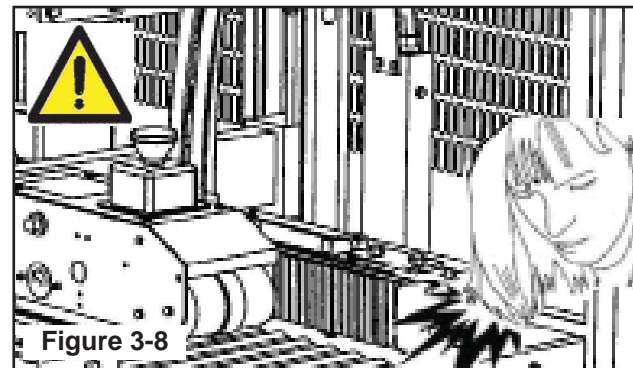


Figure 3-8

3.4 Operator's Qualifications

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

3.5 Number of Operators

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

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

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

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

3.7 Residual Hazards

The case sealer 800r 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.



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.

3.9 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.

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).

 WARNING
<ul style="list-style-type: none"> • To reduce the risk associated with mechanical and electrical hazards: <ul style="list-style-type: none"> – Allow only properly trained and qualified personnel to operate and service this machine

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
Adjusting box size	Stopped by pressing the EMERGENCY STOP button	1	1
Tape replacement	Stopped by pressing the EMERGENCY STOP button	1	1
Blade replacement	Electric power disconnected	2	1
Drive belt replacement	Electric power disconnected	2	1
Ordinary maintenance	Electric power disconnected	2	1
Extraordinary mechanical maintenance	Running with safety protections disabled	3	1
Extraordinary electrical maintenance	Running with safety protections disabled	2a	1

Box Jam

 **WARNING**

- **To reduce the risk associated with mechanical and electrical hazards:**
 - Turn electrical and air supply off and disconnect before performing any adjustments, maintenance, or servicing the machine or taping heads
- **To reduce the risk associated with impact hazards:**
 - Always use appropriate supporting means when working under the upper drive assembly

If a box should jam or there is a need to shut the machine off with the upper head assembly in the up position, the E-Stop button can be pressed or the guard door can be opened. Either function will automatically raise the upper head assembly to its highest position and the air pressure will be exhausted from the belt assemblies. The box can be removed and the tape should be checked to insure that it is threaded properly. When the E-Stop is pulled up or the door closed the upper head assembly will lower to the lowest position.

Notes

1. Machine or taping head adjustments are described in "Adjustments", Manual 1 for machine or Manual 2 for taping heads.
2. Box drive motors are designed to run at a moderate temperature of 40°C [104°F]. In some cases, they may feel hot to the touch.

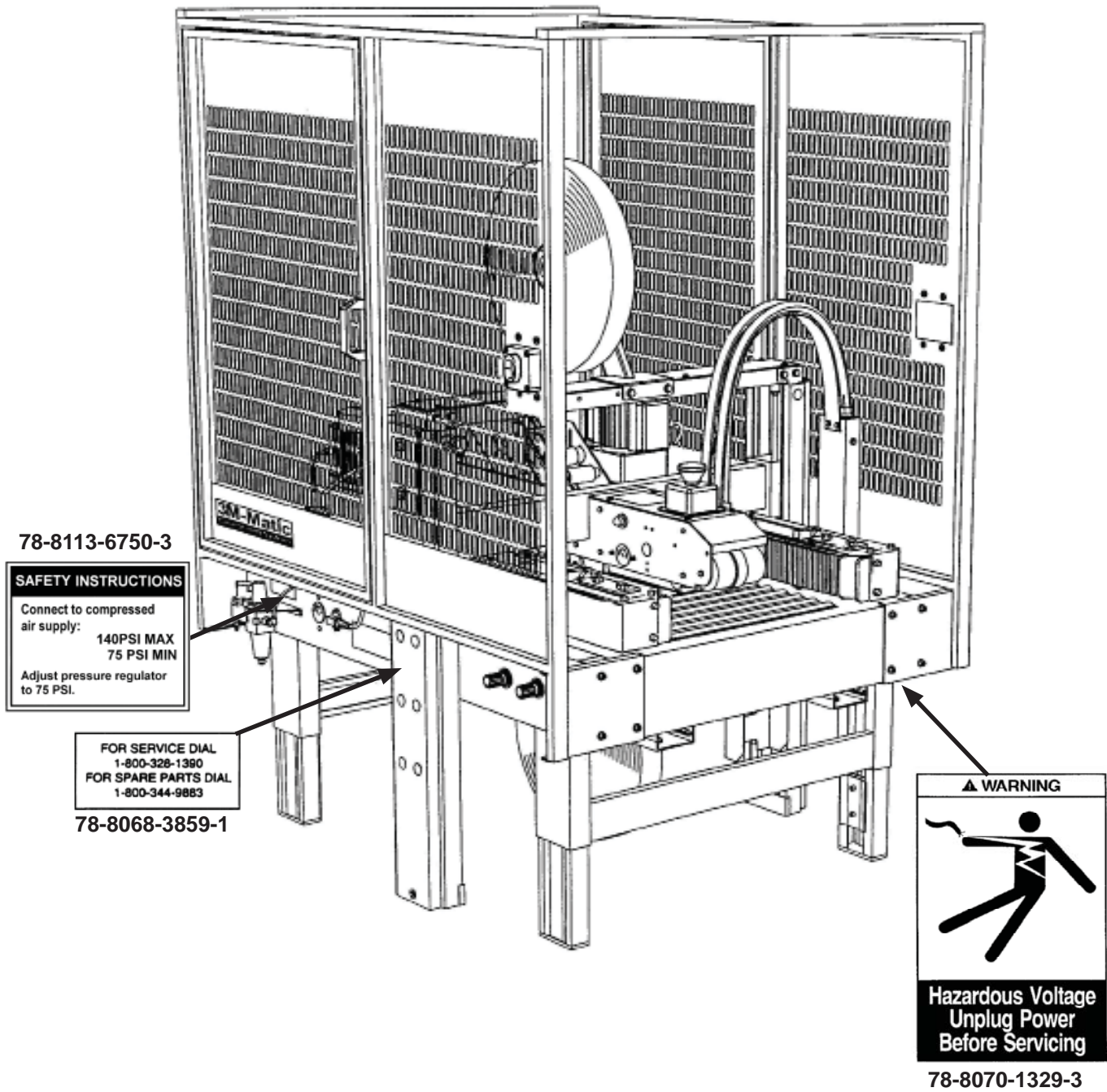


Figure 1-1 – Replacement Labels/3M Part Numbers

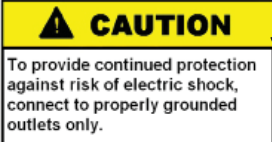
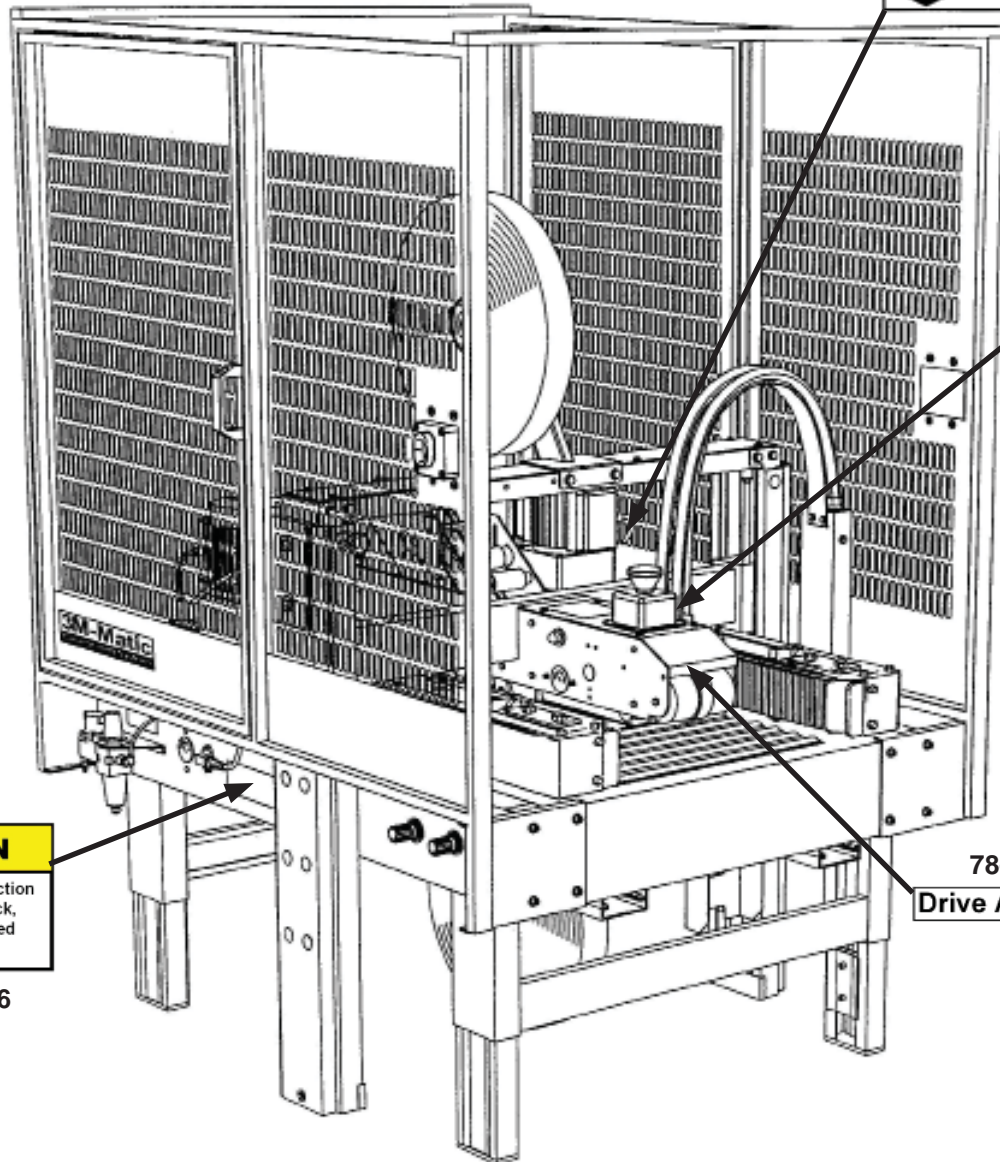
78-8070-1336-8 (2)



WARNING
Sharp knife.
Keep hands out of this area.

78-8095-1141-9

STOP



CAUTION
To provide continued protection against risk of electric shock, connect to properly grounded outlets only.

78-8137-1331-6

78-8070-1319-4
Drive Assy Raising Switch

Figure 1-2 – Replacement Labels/3M Part Numbers

78-8070-1332-7

SAFETY INSTRUCTIONS

1. Shut off machine before adjusting
2. Unplug electric power before servicing
3. Do not leave machine running unattended
4. Refer to instruction manual for complete setup, operating, and servicing information

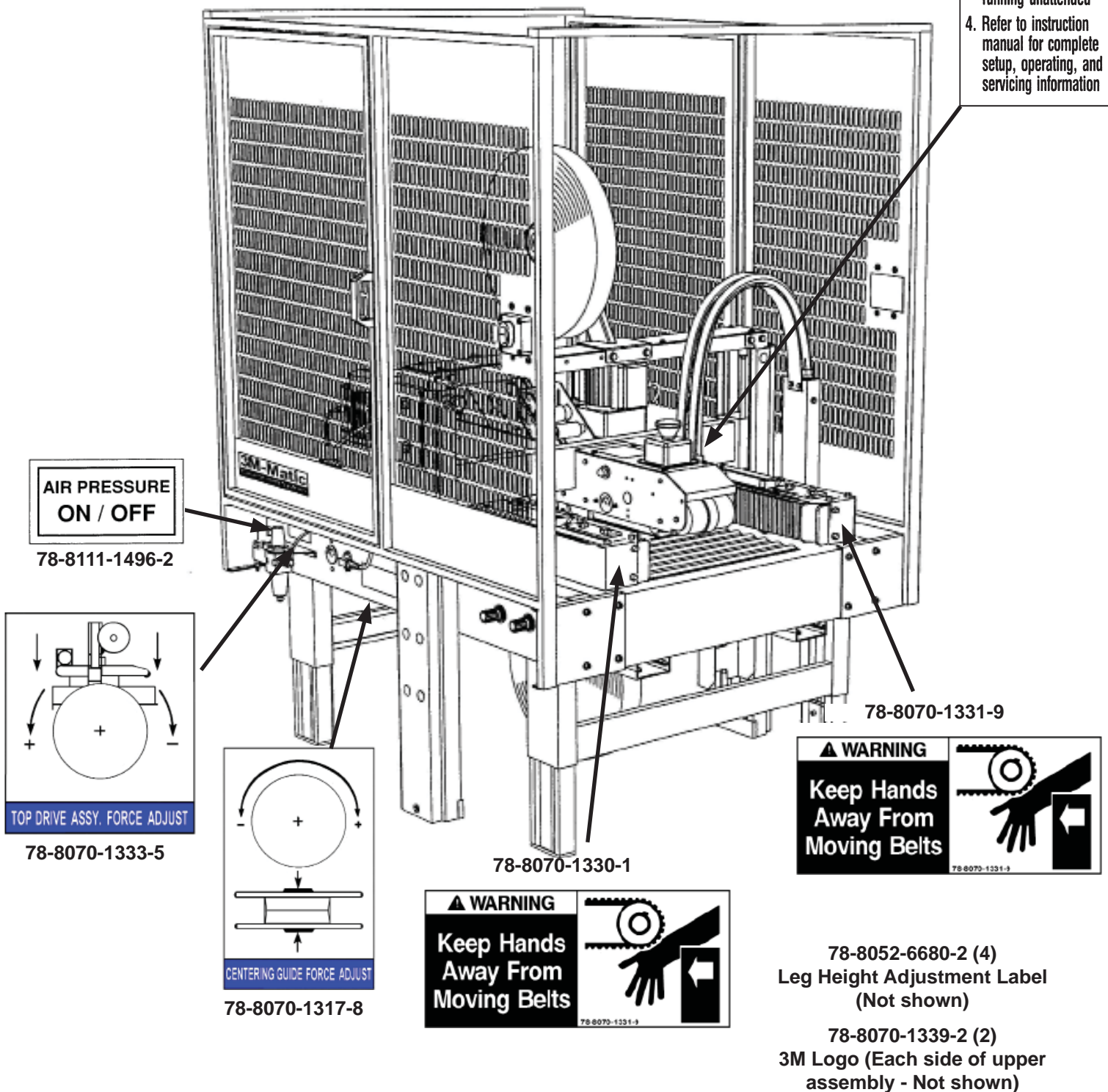


Figure 1-3 – Replacement Labels/3M Part Numbers

4-SPECIFICATIONS

1. Power Requirements

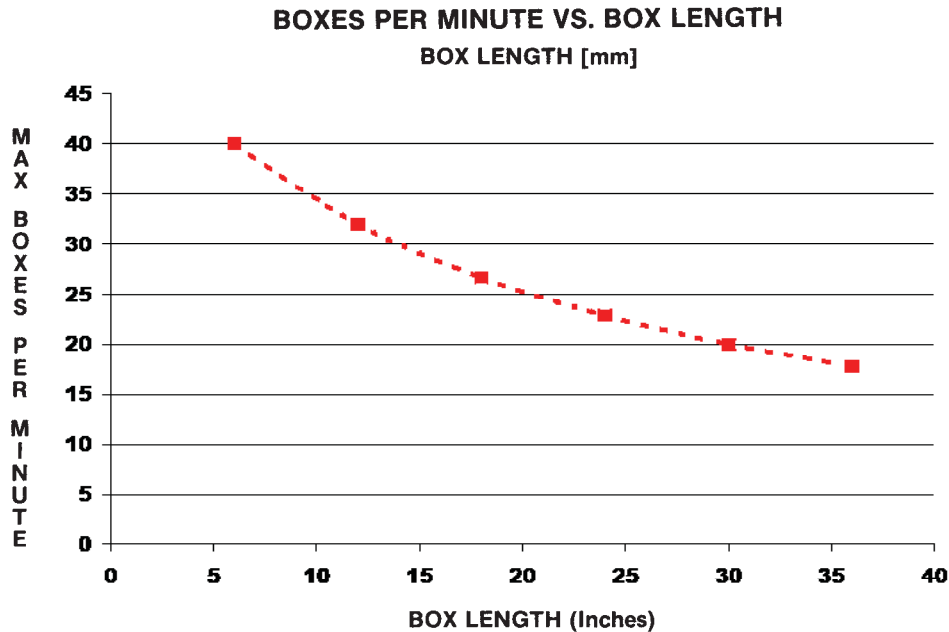
Electrical: 115 Volt, 60Hz, 3.8 A (440 watts)

Pneumatic – 5 bar gauge pressure [70 PSIG] 110 litre/min @ 21 C, 1.01 bar [3.75 SCFM] at 15 boxes per minute A pressure regulator is included

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

2. Operating Rate

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



Actual production rate is dependent on operator's dexterity.

Boxes must be 18 inches [455mm] apart minimum.

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
<ul style="list-style-type: none">• To reduce the risk associated with fire and explosion hazards:<ul style="list-style-type: none">– Do not operate this equipment in potentially flammable or explosive environments.	

4. Tape

Scotch® pressure-sensitive film box sealing tapes.

5. Tape Width

36mm [1 1/2 inch] minimum to 50mm [2 inch] maximum

4-SPECIFICATIONS (continued)

Specifications

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.)

7. Tape Application Leg Length – Standard

70mm ± 6mm [2 3/4 inch ± 1/4 inch]

Tape Application Leg Length – Optional

50mm ± 6mm [2 inch ± 1/4 inch]

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

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)

9. Box Weight and Size Capacities

A. Box Weight, filled: 5 lbs.– 65 lbs. [2.3 kg–29.5 kg]. Contents must support flaps.

B. Box Size:	Minimum	Maximum
Length –	205mm [8.0 inch]	Unlimited
Width –	133mm [5.25 inch]*	508mm [20.0 inch]
Height –	127mm [5.0 inch]	533mm [21.0 inch]

Outer Columns in Optional Raised Position

	Minimum	Maximum
Length –	150mm [6.0 inch]	Unlimited
Width –	95mm [3.75 inch]	508mm [20.0 inch]
Height –	232mm [9.12 inch]	644mm [25.4 inch]

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

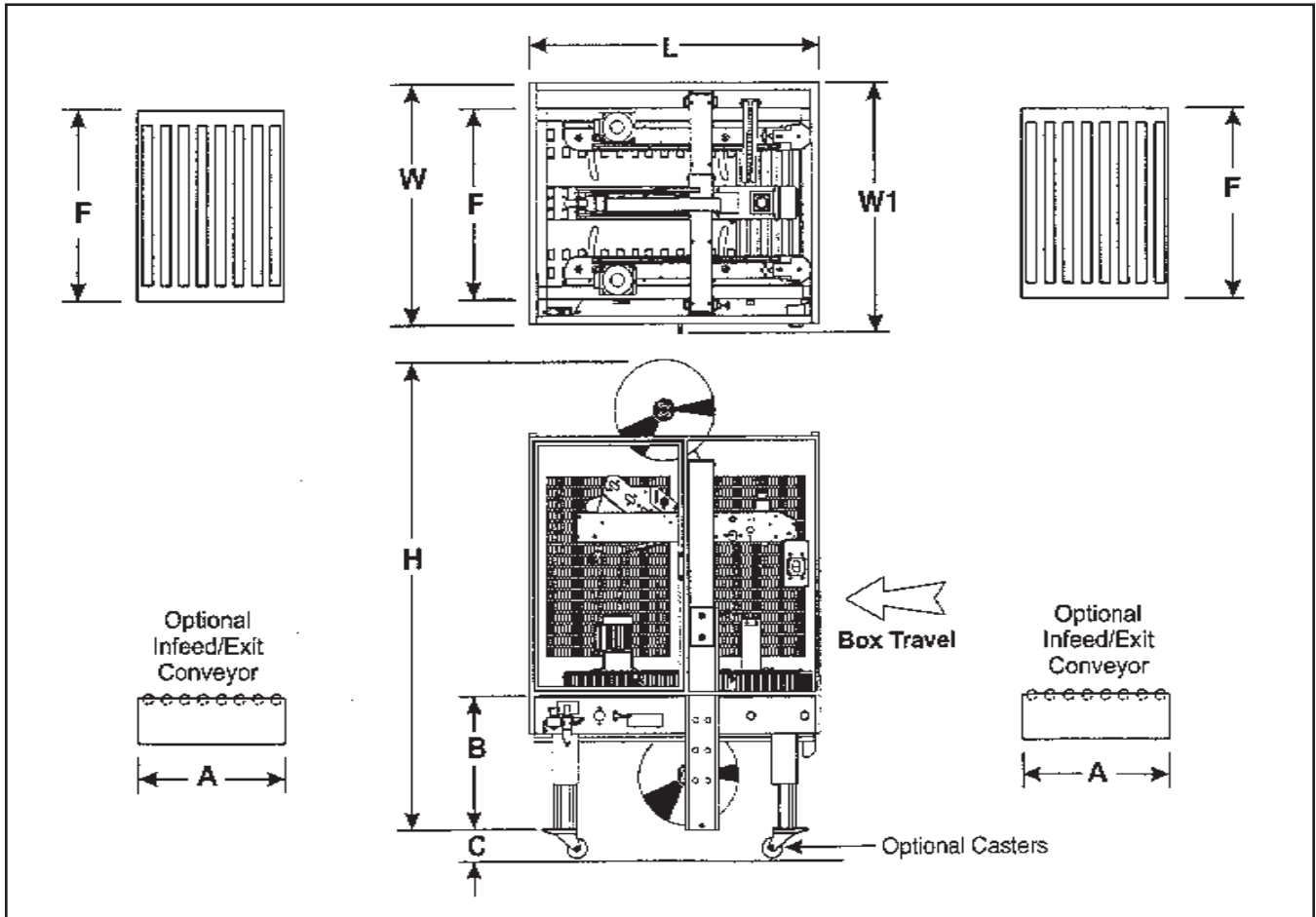
DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

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

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

(specifications continued on next page.)

Specifications (continued)



10. Machine Dimensions:

	W	W1	L	H	A*	B	C**	F
Minimum								
millimeters	970	1010	1180	1675	460	510	108	770
[Inches]	[38.25]	[39.75]	[46.50]	[66.00]	[18.00]	[20.00]	[4.25]	[30.38]
Maximum								
millimeters	--	--	--	1955	--	690	--	--
[Inches]	--	--	--	[77.00]***	--	[27.25]	--	--

* Exit conveyor is optional

** Casters are optional

*** When columns are adjusted to upper position, "H" maximum dimension is 2062mm [81.19 inches]. (See "Special Set-Up Procedure – Outer Column Re-Positioning")

Weight – 225kg [500 pounds] crated (approximate)
 208kg [460 pounds] uncrated (approximate)

11. Set-Up Recommendations:

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

5-SHIPMENT-HANDLING-STORAGE, TRANSPORT

5.1 Shipment and Handling of Packed Machine

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

Packaging Overall Dimensions (Figure 5-1)

See Specifications.

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

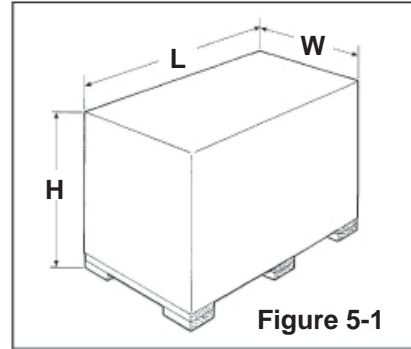


Figure 5-1

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

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

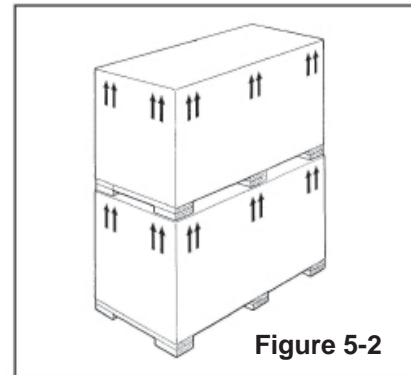


Figure 5-2

5.3 Handling and Transportation of Uncrated Machine

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

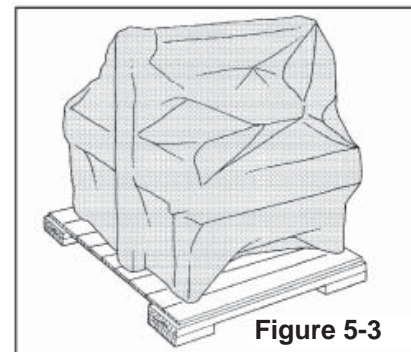


Figure 5-3

5.4 Storage of the Packed or Unpacked Machine

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

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

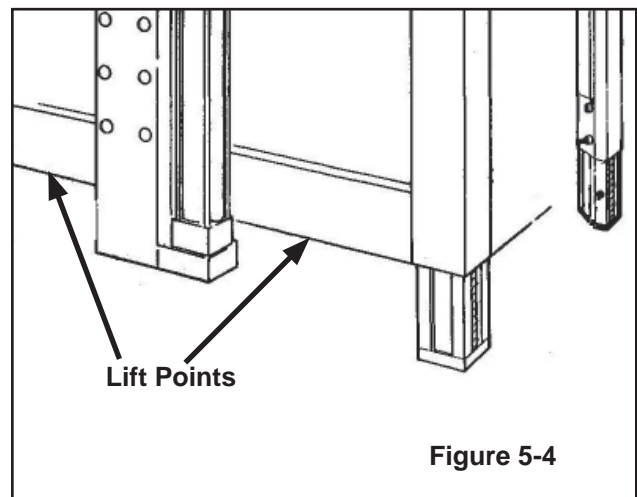
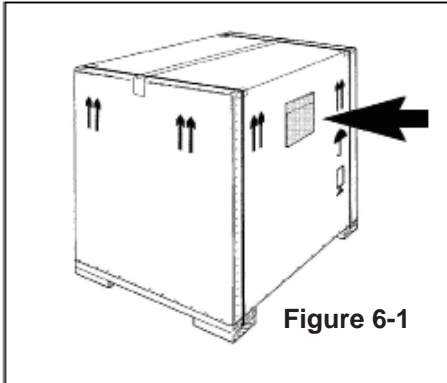


Figure 5-4

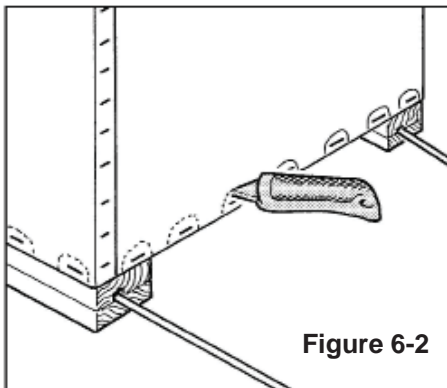
6-UNPACKING

6.1 Uncrating

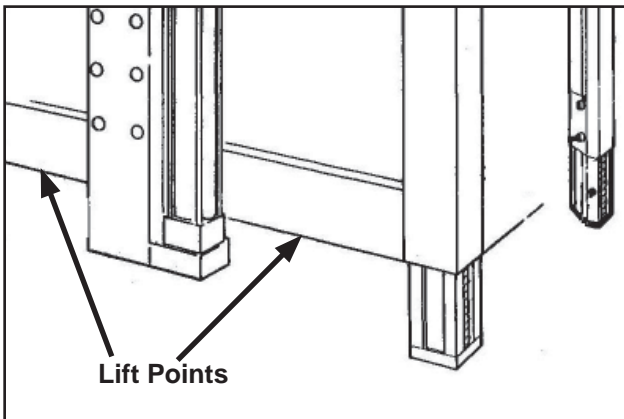
The envelope attached to the shipping box contains the uncrating instructions of the machine (**Figure 6-1**).



Cut straps. Cut out staple positions along the bottom of the shipping box (or remove staples with an appropriate tool) (**Figure 6-2**).



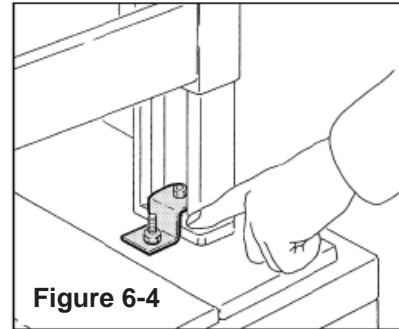
After cutting out or removing the staples, lift the shipping box in order to clear the machine (two persons required).



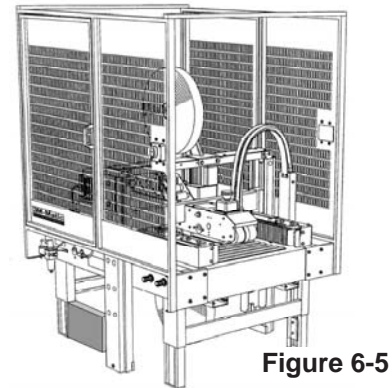
Transport the machine with a fork-lift truck to the operating position. Lift the pallet at the point indicated in **Figure 6-3** (weight of machine + pallet = 225 kg).

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 the instruction manual for additional procedures of the set up. The box also contains parts removed for shipping, spare parts and tools (**Figure 6-5**).



6.2 Disposal of Packaging Materials

The 800r-NA 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.

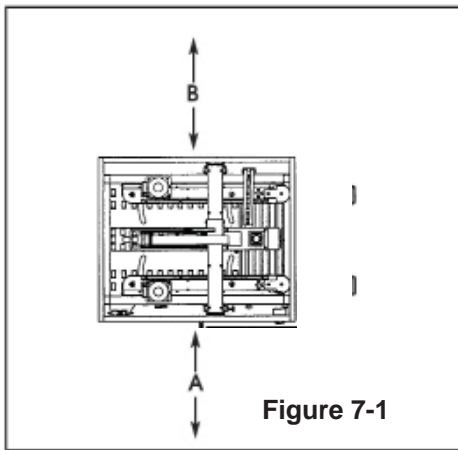


Figure 7-1

7.3 Tool Kit Supplied with the 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.

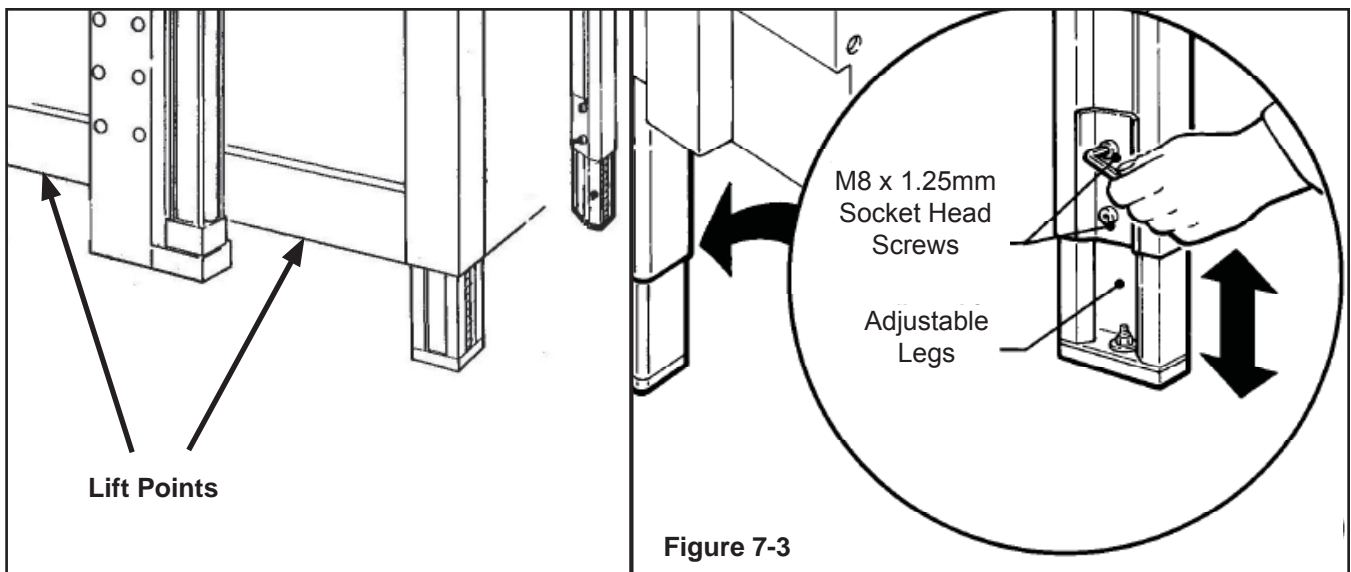


Figure 7-3



WARNING

- **To reduce the risk associated with muscle strain:**
 - Use the 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.

7.4 Machine Positioning / Bed Height

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

Adjust machine bed height. The case sealer is equipped with four (4) adjustable legs that are located at the corners of the machine frame. The legs can be adjusted to obtain different machine bed heights from 610mm [24 inch] minimum to 890mm [35 inch] maximum.

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

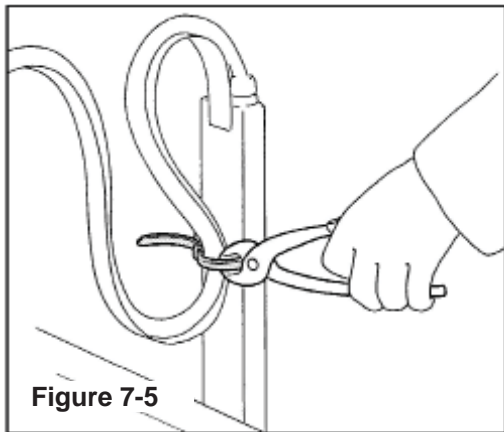
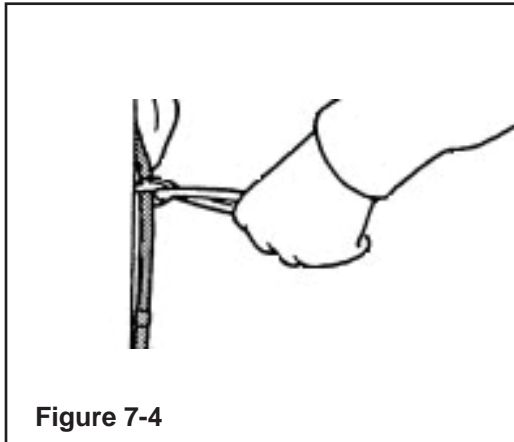
Refer to **Figure 7-3** and set the machine bed height as follows:

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

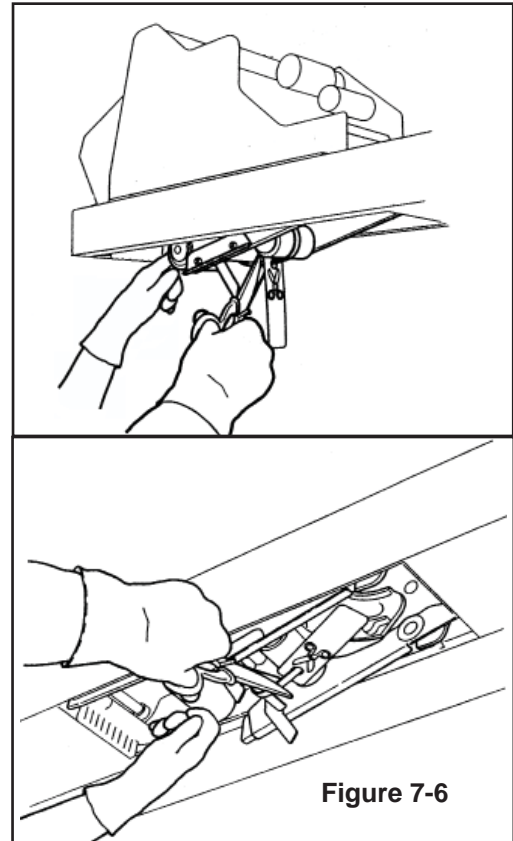
7.5 Removal of Plastic Ties

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

1. Install the upper tape drum bracket on the top crossbar as shown in **Figure 7-7A**.
2. The column guards, shown in **Figure 7-7** have been installed upside down for shipping. Remove and retain the screws and washers holding the guards on the columns for re-installation after the 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**). After the Bumpers have been installed, the Column Guards must be repositioned (rotated 180° and re-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.

Machine Set-Up (continued)

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 [5/16 inch] ID) 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.


Important – Use care when working with compressed air.


The case sealer requires a 5 bar gauge pressure 110 litre/min [70 PSIG], @21°C, 1.01 bar [3.75 SCFM] compressed air supply. As shown in **Figure 7-14**, an on/off valve, pressure regulator, and filter are provided to service the air supply.

Note – A precision regulator is used to balance the top 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].

Note – The air valve has provisions for lock out/tag out according to plant regulations.

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

 WARNING
<ul style="list-style-type: none">• To reduce the risk associated with mechanical and electrical hazards:<ul style="list-style-type: none">– Allow only properly trained and qualified personnel to operate and/or service this equipment

 WARNING
<ul style="list-style-type: none">• To reduce the risk associated with impact hazards:<ul style="list-style-type: none">– Always use appropriate supporting means when working under the upper drive assembly

7-INSTALLATION AND SET-UP (continued)

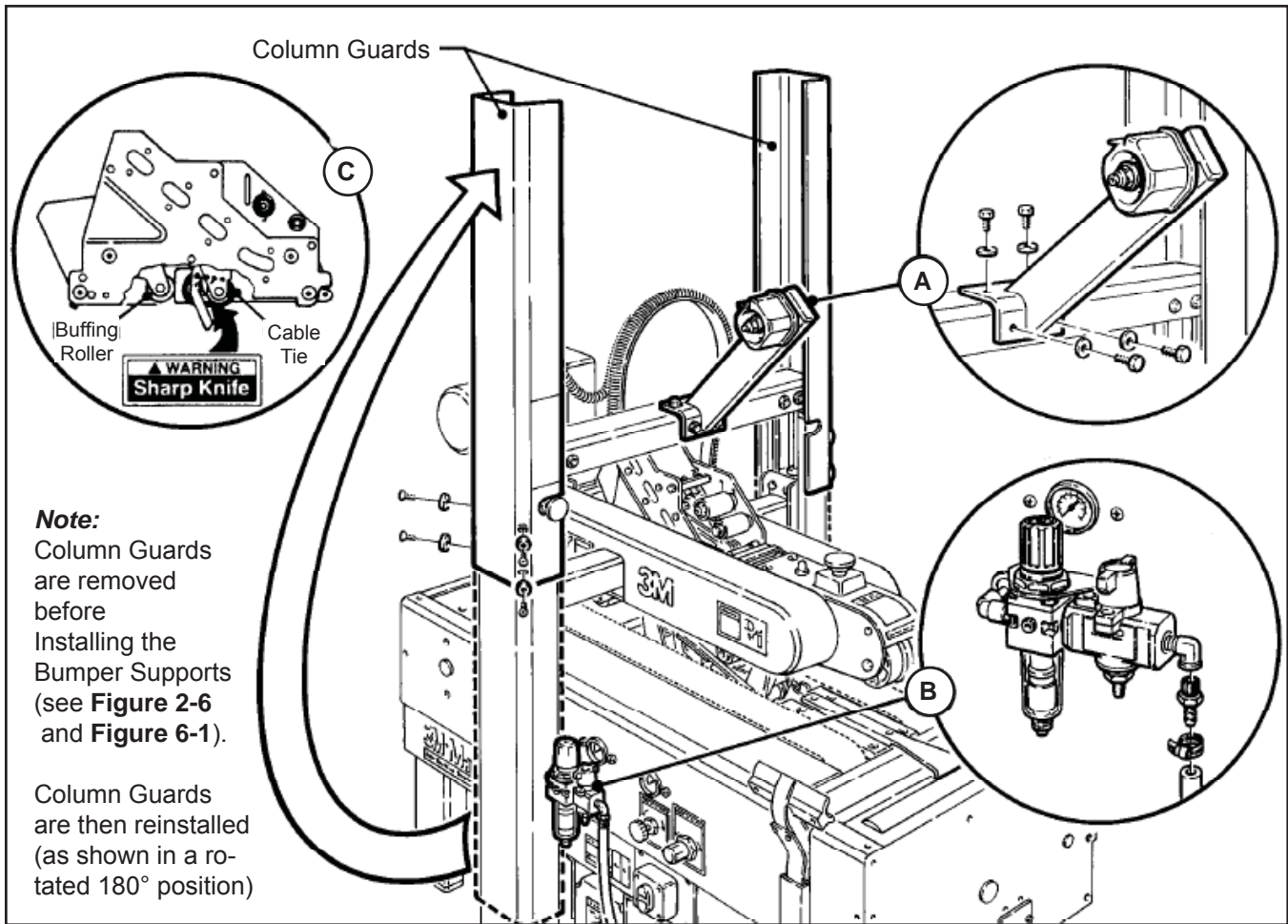


Figure 7-7 – 800r Frame Set-Up

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 - See Figure 7-6). Allow buffering/applying arms to extend slowly.

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



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

9. Ensure that the tape drum bracket assembly, located on the lower taping head, is mounted straight down, as shown in Figure 7-8A. The tape drum bracket assembly can be pivoted to provide tape roll clearance in certain cases.

8. Check for free action of both upper and lower taping heads. Push buffering roller into head to check for free, smooth action of taping heads.

7.7 Infeed Conveyor Assembly

1. Remove the conveyor and the package of parts from the carton.
2. Verify that the package contains two right angled cover plates, twelve (12) M8 x 15 hex head screws, and eight (8) M8 flat washers.
3. To assemble the infeed conveyor, refer to **Figure 7-9** and locate four bolt holes on the infeed end of the case sealer frame.
4. Insert a M8 x 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 x 15 screws and M8 washers.

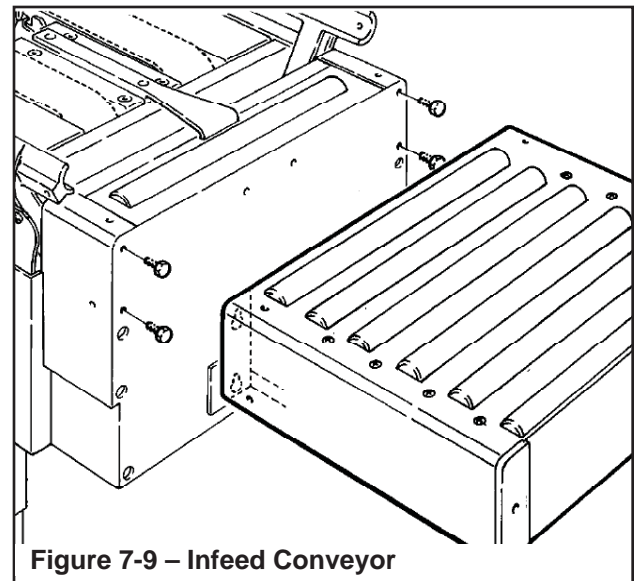


Figure 7-9 – Infeed Conveyor

7.8 Centering Guides

1. Remove the two centering guides and four (4) M6 x 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 x 20 screws (two [2] in each guide as shown in **Figure 7-11**).

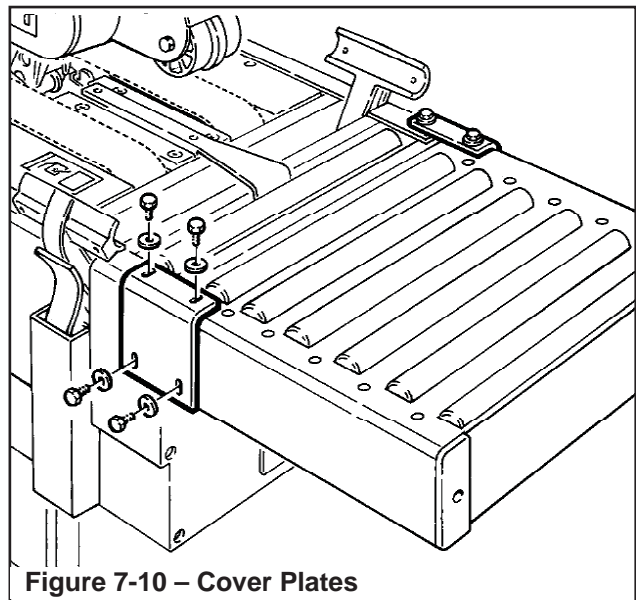


Figure 7-10 – Cover Plates

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 the lower frame, as shown in **Figure 7-8**.

7.10 Tape Leg Length

Taping heads are pre-set to apply 70mm [2.75 inch] long tape legs. To change tape leg length to 50mm [2.0 inch], see "Special Set-Up Procedure – Changing the Tape Leg Length."

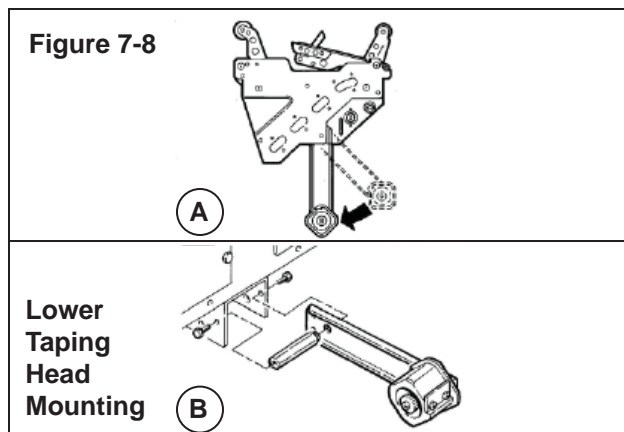


Figure 7-8

Lower Taping Head Mounting

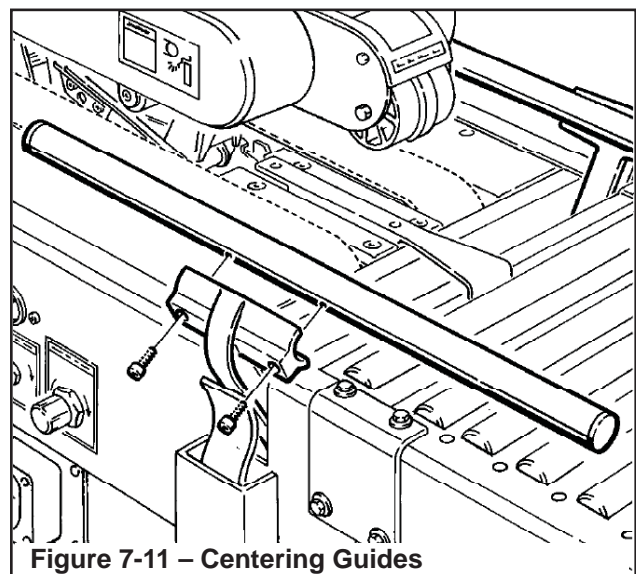



Figure 7-11 – Centering Guides

 WARNING
<ul style="list-style-type: none"> • To reduce the risk associated with impact hazards: <ul style="list-style-type: none"> – Always use appropriate supporting means when working under the upper drive assembly • To reduce the risk associated with mechanical and electrical hazards: <ul style="list-style-type: none"> – Allow only properly trained and qualified personnel to operate and/or service this equipment

7.11 Bumper Supports (Upper Drive Assembly)

With the Safety Guard removed (**Figure 7-12**):
Also See Special Set-Up Procedure - Column Bumper Installation

- Raise and lock the upper drive assembly in the raised position. See "Operation – Mechanical Latch."
- Turn off air supply and electric power.
- Remove the Column Bumper and set screw parts package from the carton.
- Using set screws provided, install Column Bumper (the recommended position is shown below).
- Re-install Safety Guard.

* **NOTE - IMPORTANT:** - 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 a malfunction of the machine.
 These events can potentially cause damage to the machine. For more information on bumper settings, contact your 3M service representative.

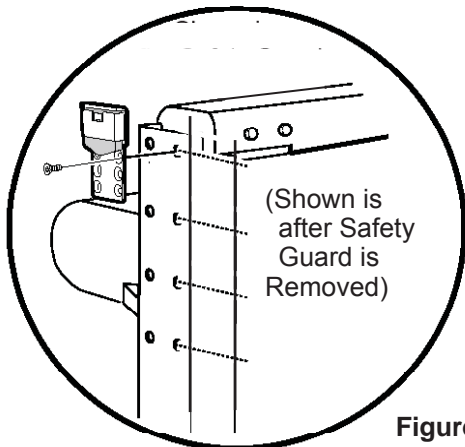


Figure 7-12

7.12 Box Size Capacity of Case Sealer

At its factory setting, the case sealer handles box sizes up to 620mm [24.5 inch] maximum height (See Specifications Section). If larger capacity is needed, the machine can be adjusted to accommodate boxes up to 725mm [28.5 inch] high. Refer to "Special Set-Up Procedure – Box and Machine Bed Height Range."


Note – Adjusting machine to accommodate 725mm [28.5 inch] high boxes also increases minimum box size to 170mm [6.8 inch] - **See Figure 15104.**

7.13 Electrical Connections and Controls

The electrical control box and "On/Off" switch are located on the lower left side of the machine frame. See **Figure 7-13**. If desired, for operator convenience, the "On/Off" switch 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 115 Volt, 60 Hz., 3.8 Amp electrical service. The receptacle providing this service shall be properly grounded. Before the power cord is plugged into 115 Volt, 60 Hz 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 30.5 m [100 ft], and must be properly grounded.

 WARNING
<ul style="list-style-type: none"> • To reduce the risk associated with hazardous voltage: <ul style="list-style-type: none"> – Position electrical cord away from foot and/or vehicle traffic

Note - Machines outside the U.S. may be equipped with 220/240 Volt, 50 Hz 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

7.15 Case Sealer Components

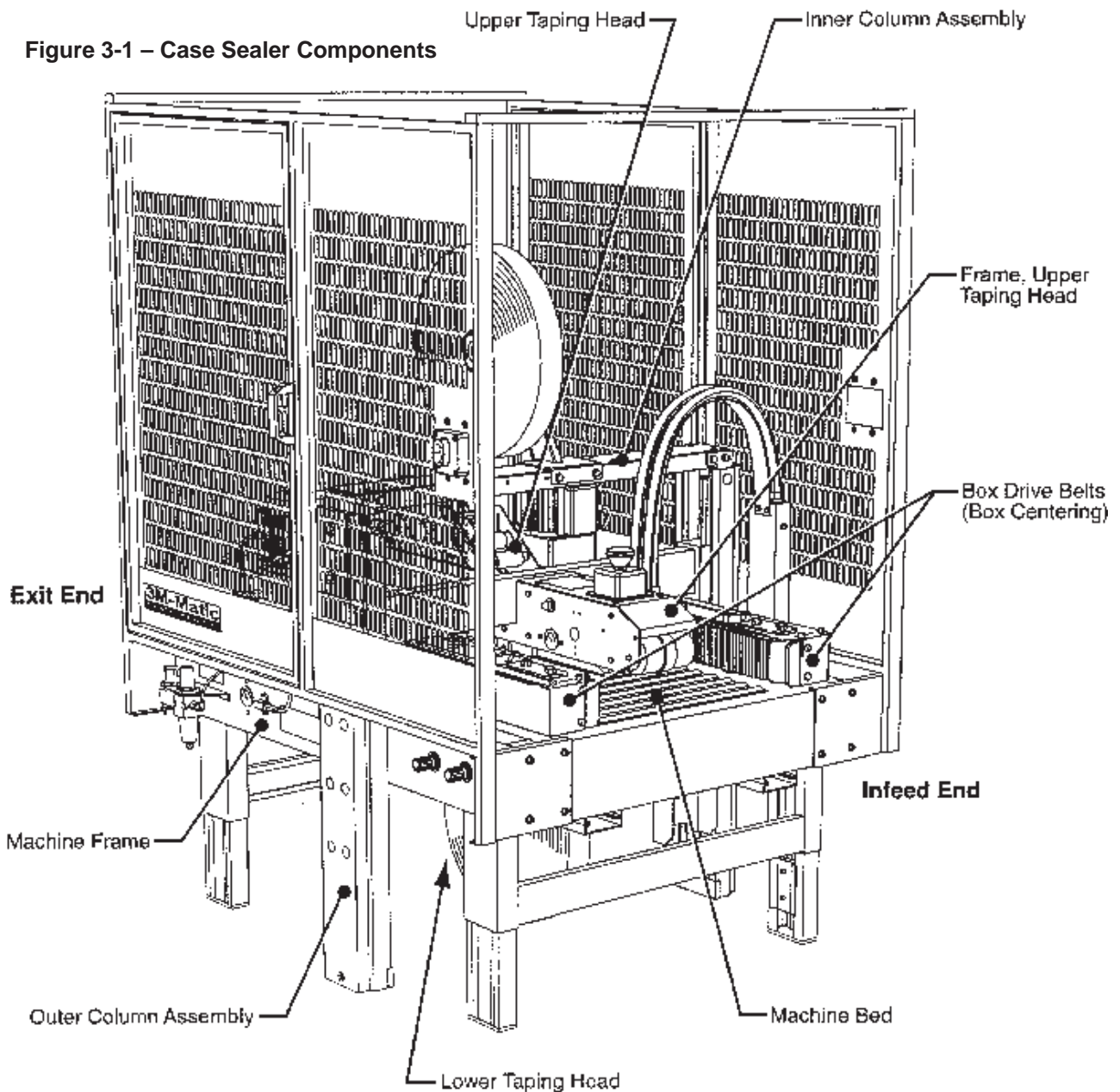
Operation

⚠ 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

Refer to **Figure 3-1 and 3-2** to acquaint yourself with the various components and controls of the case sealer. Also see **Figures 3-1 and 3-2** in Manual 2 for taping head components.

Figure 3-1 – Case Sealer Components



Operation (continued)

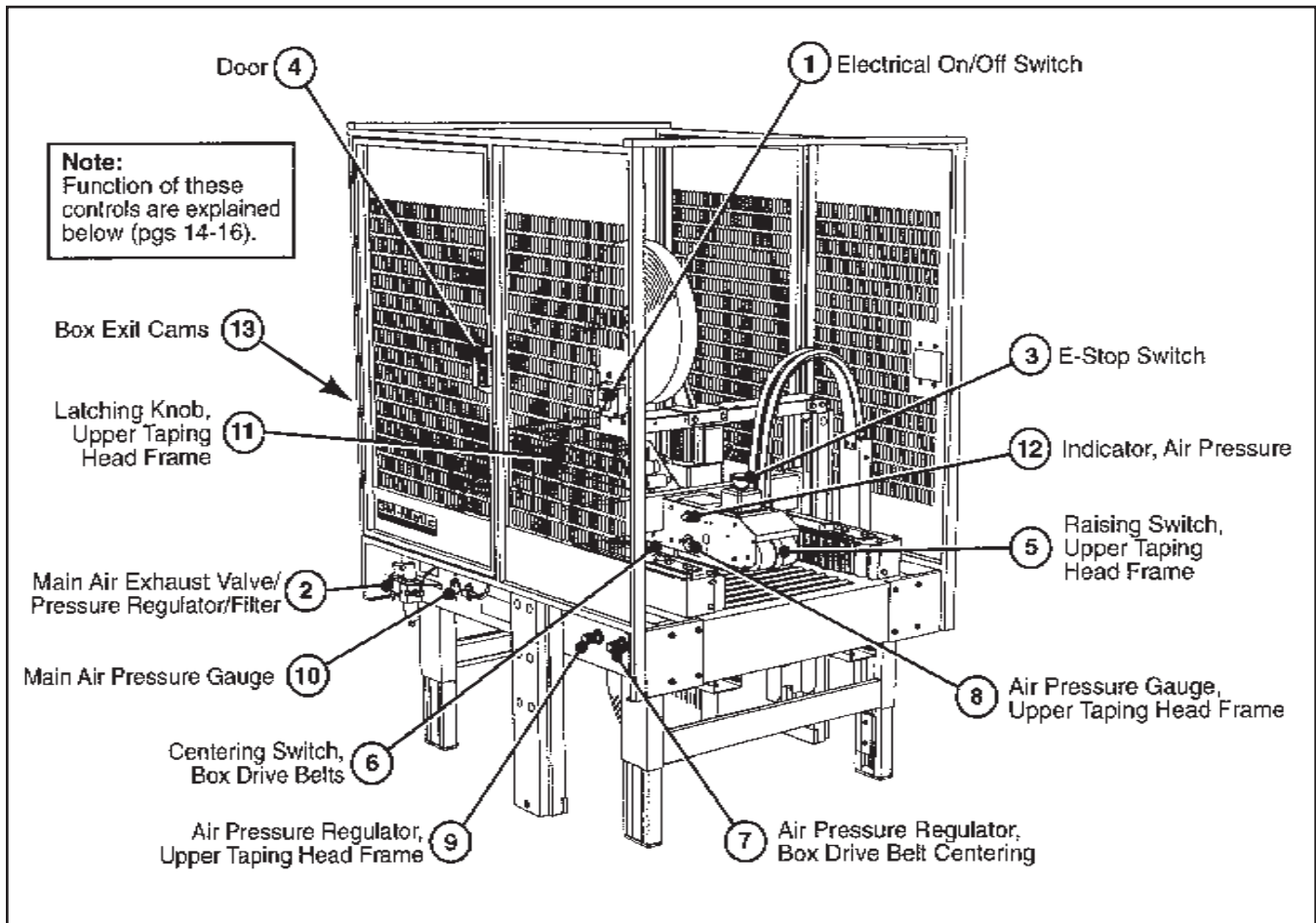


Figure 3-2 – Controls, Valves and Switches

① **Electrical "On/Off" Switch**
The box drive belts are turned on and off ("Off" button is red) with the electrical switch on the left side guard on the infeed end of the machine.

Note – The case sealer has a circuit breaker located in the electrical control box on the lower right side of the machine frame. If circuit becomes overloaded and circuit breaker trips, see "Maintenance – Circuit Breaker".

② **Main Air "On/Off" Valve/Pressure Regulator/Filter – Figure 3-3**
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 circuits.

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

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

Pressure Regulator regulates main air pressure to the machine. The factory set point is 95 PSIG. To re-adjust pressure, pull knob up and turn to desired pressure. 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.

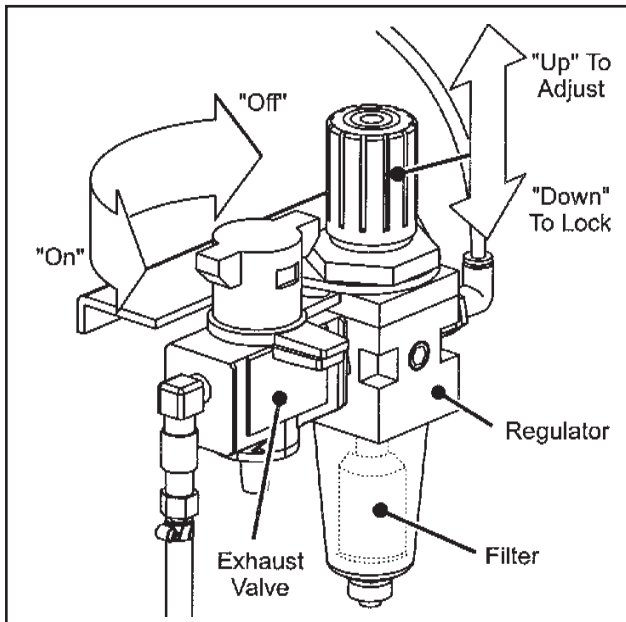


Figure 3-3 – "On/Off" Valve/Regulator/Filter

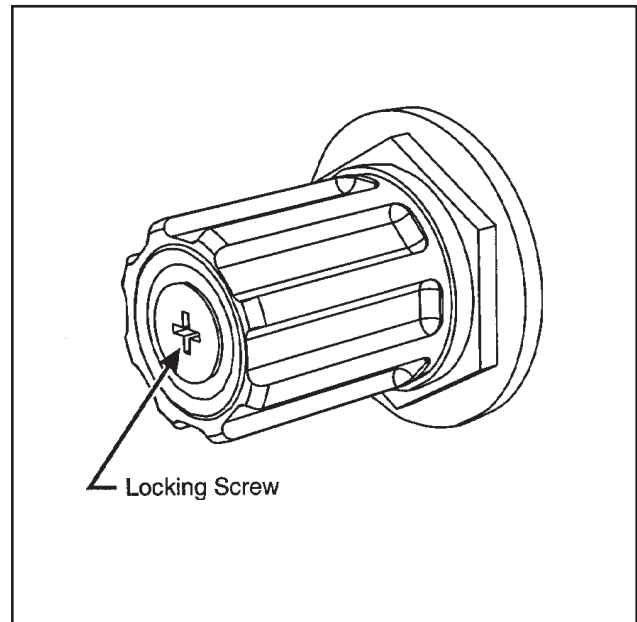


Figure 3-4 – Air Regulator, Drive Belts

③ **E-Stop Switch**

The E-Stop switch kills electrical power and exhaust air pressure from the drive belt assemblies. The upper head assembly will raise to its upper most position. To restart machine, rotate E-stop switch (releases switch latch) and then restart machine by pressing electrical switch "I" (On) button on side guard of machine.

④ **Door**

The door is equipped with a safety interlock which kills electrical power and exhaust air pressure from the drive belt assemblies. The upper head assembly will raise to its upper most position when the door is opened.



WARNING

• **To reduce the risk associated with impact hazards:**

- Always use appropriate supporting means when working under the upper drive assembly

⑤ **Raising Switch, Upper Taping Head Frame**

This switch, when touched by the leading edge of a box, pneumatically raises the upper frame to allow insertion of a box under the upper frame, as the box moves under the switch, releasing it, the upper frame descends

on the box and the drive belts convey the box through the machine. When switch is actuated by hand, the upper frame rises to its maximum height. Released, the upper frame descends to its rest position.

⑥ **Centering Switch, Box Drive Belts** - This pneumatic switch controls the closing (centering) of the drive belts. When switch is activated by a box passing under it, the drive belts close and center the box.

⑦ **Air Pressure Regulator, Box Drive Belt Centering – Figure 3-4** - This regulator is used to adjust drive belt centering pressure. The factory set point is 5 turns clockwise. If more pressure is needed to center box, turn knob clockwise to desired pressure. If box is being crushed, turn knob counterclockwise to relieve pressure. Regulator is locked by tightening screw.

⑧ **Air Pressure Gauge, Upper Taping Head Frame** - This gauge, used in conjunction with the upper frame air regulator, provides operator with a reference pressure setting for various size/weight boxes.

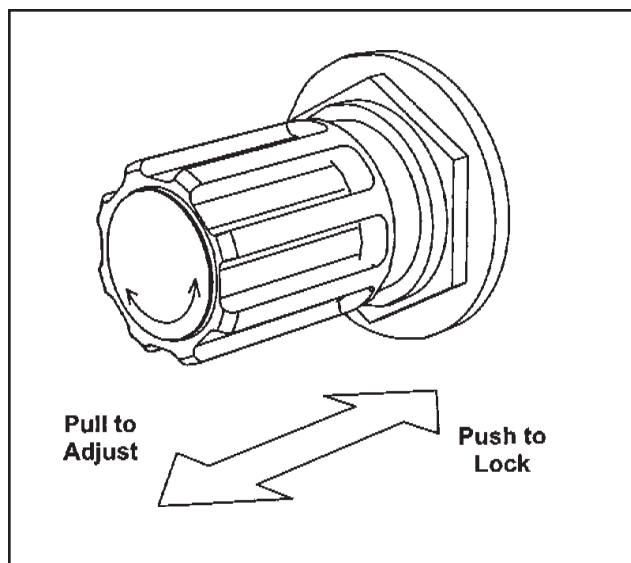


Figure 3-5 – Air Regulator, Upper Taping Head Frame

- 9 **Air Pressure Regulator, Upper Taping Head Frame – Figure 3-5** - Set nominally to control "down" pressure against box. The factory set point is 15 PSIG [1 bar]. The regulator setting is adjusted as necessary to allow free movement of boxes through taping heads while maintaining boxes flaps in fully closed position. Decreasing air pressure will increase down pressure on boxes while increasing air pressure will decrease down force on boxes.

For boxes which are fully packed with products that support the top flaps, the adjustment of this regulator is not critical since the boxes can support the pressure of the upper frame at a wide range of regulator settings. However, if under-filled or fragile boxes are sealed, this regulator is used to set the upper frame at the minimum setting while still maintaining adequate closure of boxes.

The air regulator is adjusted by pulling out to adjust and pushing in to lock the setting as shown in Figure 3-5.

- 10 **Main Air Pressure Gauge**
Indicates main air regulator pressure setting. Air regulator should be adjusted so gauge reads 6.5 bar gauge pressure [95 PSIG].
- 11 **Latching Knob, Upper Taping Head Frame –Figure 3-6**
The mechanical latch is provided to hold the upper frame at the fully raised position for tape threading and maintenance.

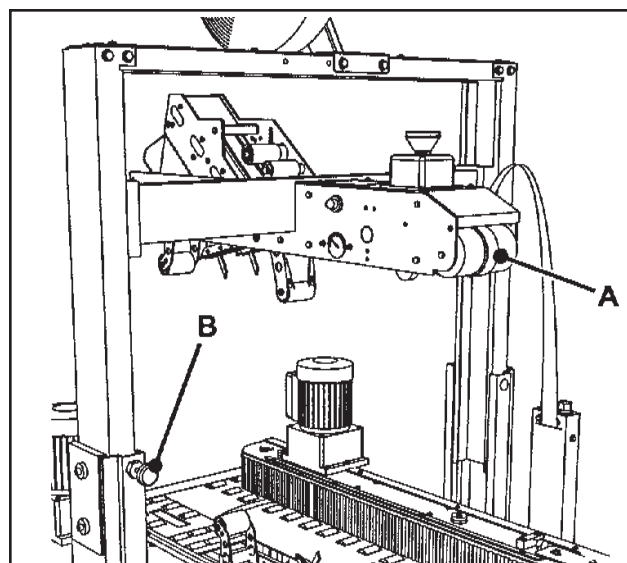


Figure 3-6 – Latching Knob, Upper Taping Head Frame

- To raise and latch the upper frame:
1. Push and hold the 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 and lower the upper frame:
1. Turn on air supply.
 2. Push and release switch "A".

CAUTION

- **To reduce the risk associated with pinch and impact hazards:**
 - Keep away from the pneumatically controlled upper drive assembly and box drive belts when air and electric supplies are on

- 12 **Indicator, Air Pressure**
An "Optical" Warning Indicator for the compressed air circuit of the machine is located on the upper taping head frame just behind the red "Stop" button. When indicator is "Red", air circuit is on.
- 13 **Box Exit Cams**
These cams, when tripped by exiting box, signal drive belts to return to their fully open (rest) position.

! 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

Tape Loading/Threading (See Manual 2.)

Note – If lower tape drum is mounted in lower out-board 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 leg under knurled roller on outboard mount, then attach tape leg to threading needle and pull tape through taping head with threading needle.

Box Sealing

1. Turn main air valve "On".
2. Push electrical switch "On" to start drive belts.
3. With access door closed, feed boxes to machine at minimum 460mm [18 in] intervals.

5. Be sure machine is cleaned and lubricated according to recommendations in "Maintenance" section of this manual.
6. Reload and thread tape as necessary.

! CAUTION

• **To reduce the risk associated with pinch and entanglement hazards:**

- Always feed boxes into the machine by pushing only from the end of the box
- Keep hands clear of the upper head support assembly as boxes are transported through the machine

• **To reduce the risk associated with pinch and impact hazards:**

- Keep away from the pneumatically controlled upper drive assembly and box drive belts when air and electric supplies are on

Operator pushes box against raising switch on upper frame assembly, as shown in **Figure 3-7**, causing the upper frame (taping head) to be raised above the box.

4. Box is then pushed under belt centering roller switch (**Figure 3-8**), which closes drive belts and conveys box through machine.

Once the box is conveyed from under the upper taping head, the upper frame assembly returns to its rest position, ready for insertion of next box. Also, box exiting machine, trips box exit cams which signal drive belts to return to their full open (rest) position.

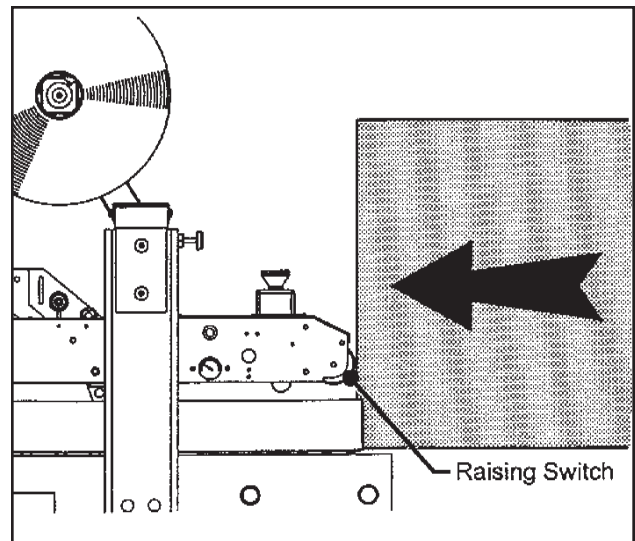


Figure 3-7 – Operation

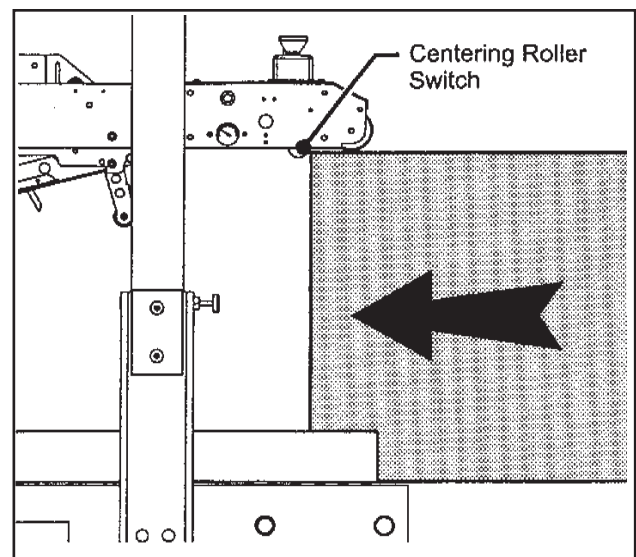


Figure 3-8 – Operation

Box Jam



WARNING

- **To reduce the risk associated with mechanical and electrical hazards:**
 - Turn electrical and air supply off and disconnect before performing any adjustments, maintenance, or servicing the machine or taping heads
- **To reduce the risk associated with impact hazards:**
 - Always use appropriate supporting means when working under the upper drive assembly

If a box should jam or there is a need to shut the machine off with the upper head assembly in the up position, the E-Stop button can be pressed or the guard door can be opened. Either function will automatically raise the upper head assembly to its highest position and the air pressure will be exhausted from the belt assemblies. The box can be removed and the tape should be checked to insure that it is threaded properly. When the E-Stop is pulled up or the door closed the upper head assembly will lower to the lowest position.

Notes

1. Machine or taping head adjustments are described in "Adjustments", Manual 1 for machine or Manual 2 for taping heads.
2. Box drive motors are designed to run at a moderate temperature of 40°C [104°F]. In some cases, they may feel hot to the touch.

7.19 Completion of Taping Heads

See Manual 2 for Complete Instructions:

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 it between the two (2) rollers on the apply arm (**Position 3**).
5. Pull the threading needle down until the tape travels between the apply plate and the ears of the apply arm (**Position 4**) until it extends past the applying roller. When properly threaded the adhesive side of the tape should be facing the knurled rollers at position 2 and also position 3.
6. Cut away any excess tape and repeat steps for Lower Taping Head.

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

7.20 Outboard Tape Roll Holder

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

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

7.21 Preliminary Electric Inspection

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

- 7.21.1 Make sure that the socket is provided with an earth protection circuit and that both the mains voltage and the frequency match the specifications on the name plate.
- 7.21.2 Check that the connection of the machine to the mains meets the safety regulations in your country.
- 7.21.3 The machine is fitted with a main switch having a maximum breaking power of 42kA and a short-circuit breaker pre-set at 120A. The user will be responsible for testing the short-circuit current in its facility and should check that the short-circuit amperage setting of the machine is compatible with all the components of the mains system.

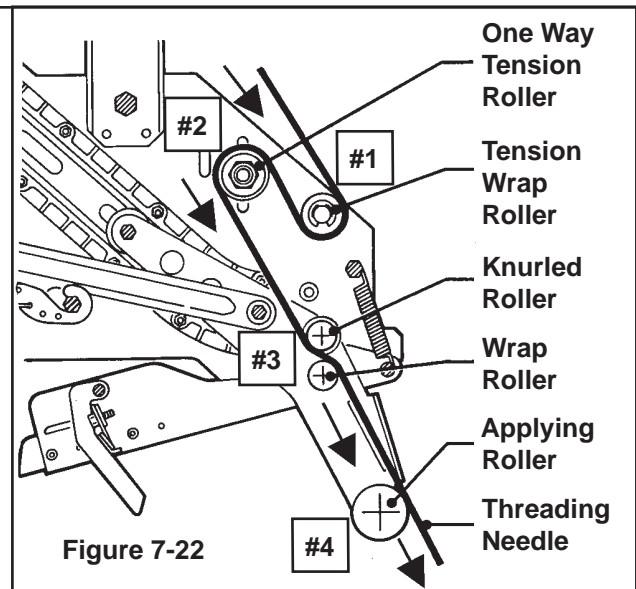


Figure 7-22

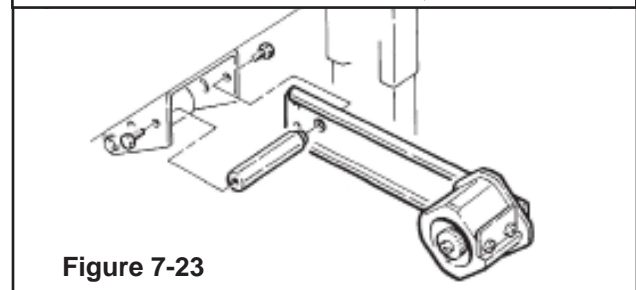


Figure 7-23

7.22 Machine Connection to the Mains

For technical specifications: **See Section 4 - Specifications**

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

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

7.23 Inspection of Phases (For Three-Main Phases Only)

Procedure to be followed in order to correctly connect the position of the phases:

- Release the latching emergency stop button by turning it clockwise (**Figure 8-1**).
- Turn Main Switch to ON Position (**Figure 8-2**).
- Check the rotation direction of the drive belts (**Figure 8-3**).
- If the drive belts rotate in the wrong direction, correct the rotation direction of the drive belts by reversing 2 phases on the plug.

Note - Machines outside the U.S. may be equipped with 220/380 Volt, 50Hz systems, or other electrical requirements compatible with local practice.

8-THEORY OF OPERATION

8.1 Description of the Working Cycle

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

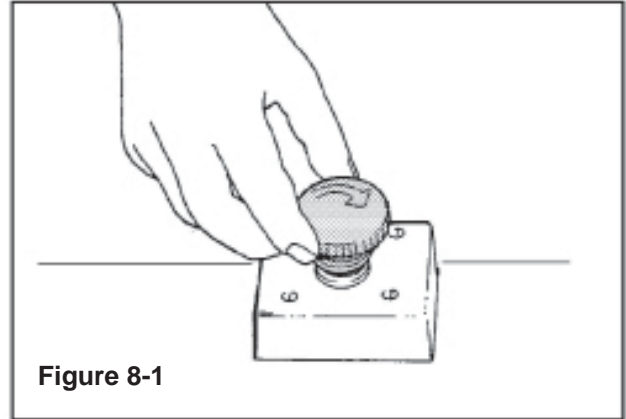


Figure 8-1

8.2 Definition of Running Mode

The case sealer 800r-NA has only one (automatic) operating mode with:

- The EMERGENCY STOP BUTTON unlocked (**Figure 8-1**)
- The main start switch "ON" (**Figure 8-2**)

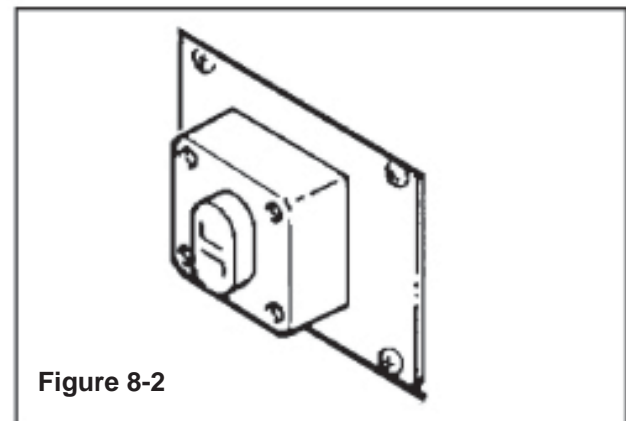


Figure 8-2

8.3.1 Normal Stop Procedure

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

8.3.2 Emergency Stop

The LATCHING EMERGENCY STOP BUTTON is located on the top center of the machine (**Figure 8-1**).

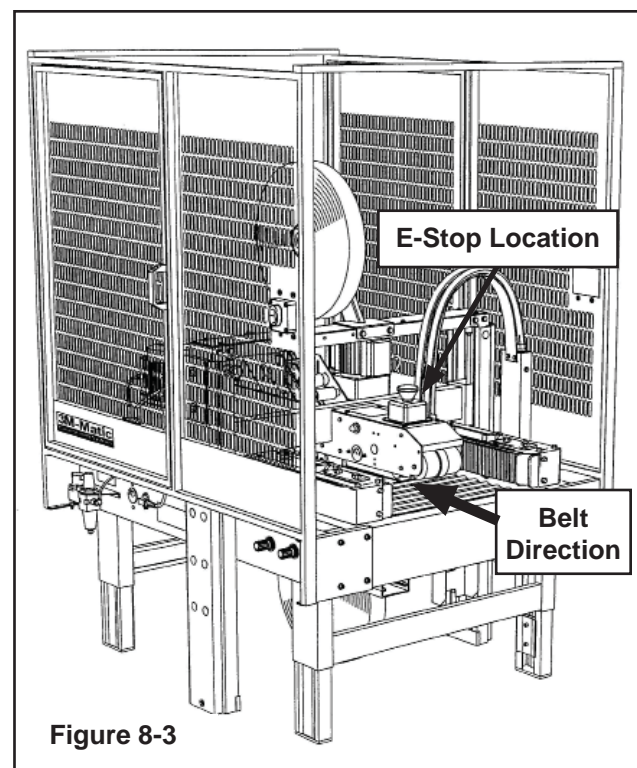
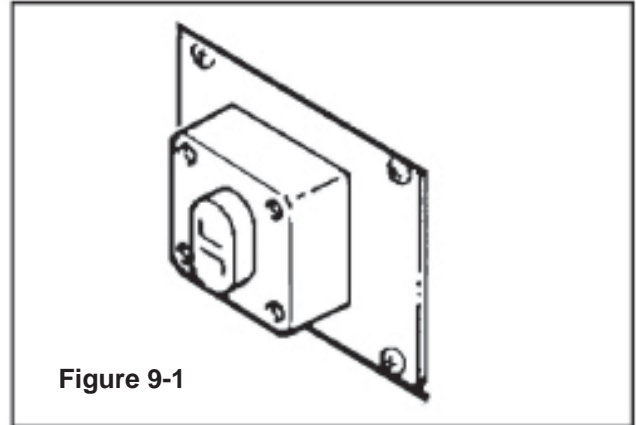
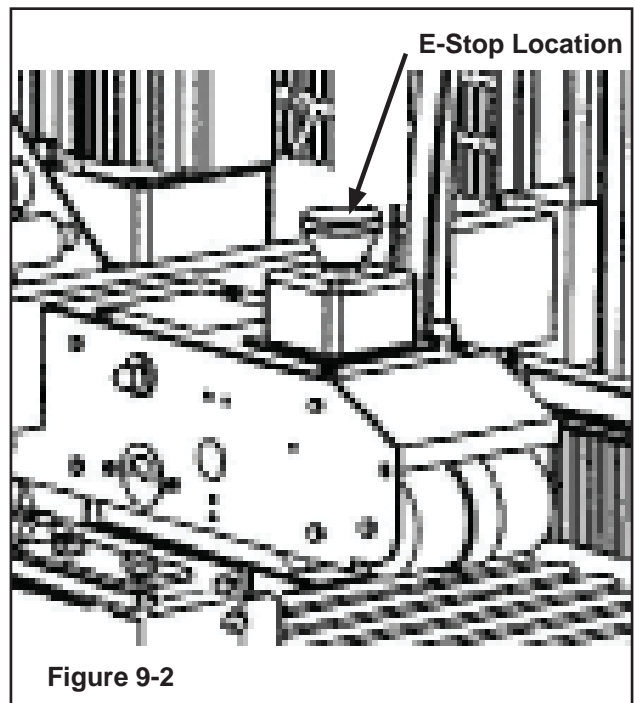


Figure 8-3

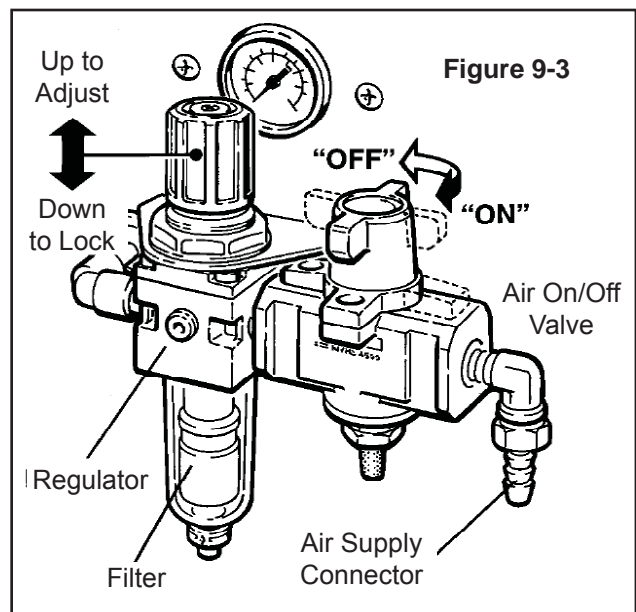
9.1 Electrical/Drive Belt On/Off Switch



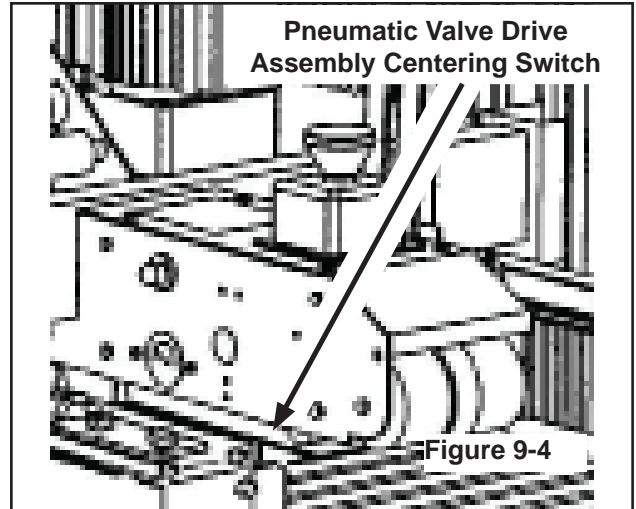
9.2 Latching Emergency Stop Button



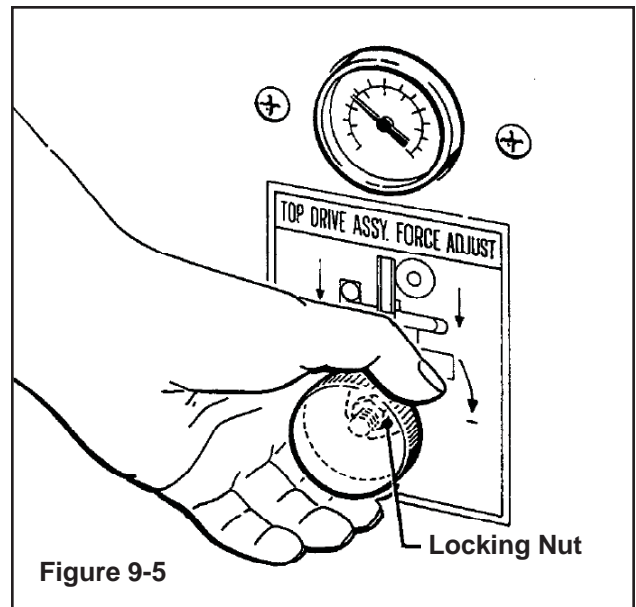
9.3 Main Air On-Off Valve-Regulator-Filter



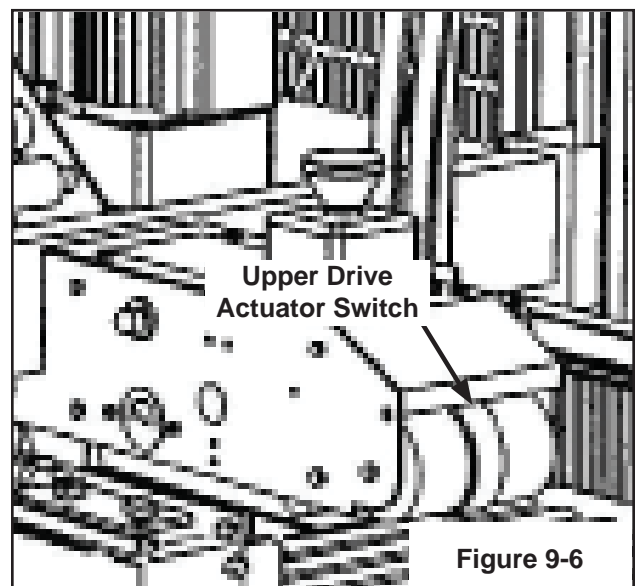
9.4 Upper Drive Centering Switch



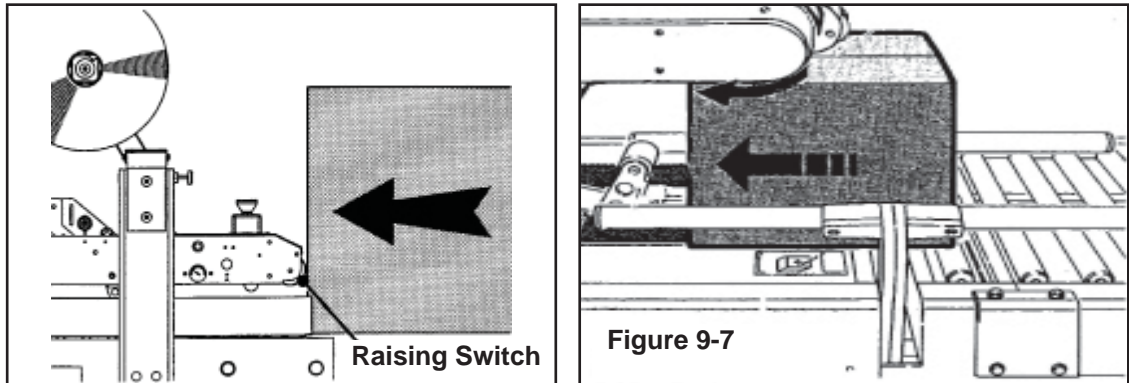
9.5 Air Pressure Regulator / Top Drive Force Adjustment



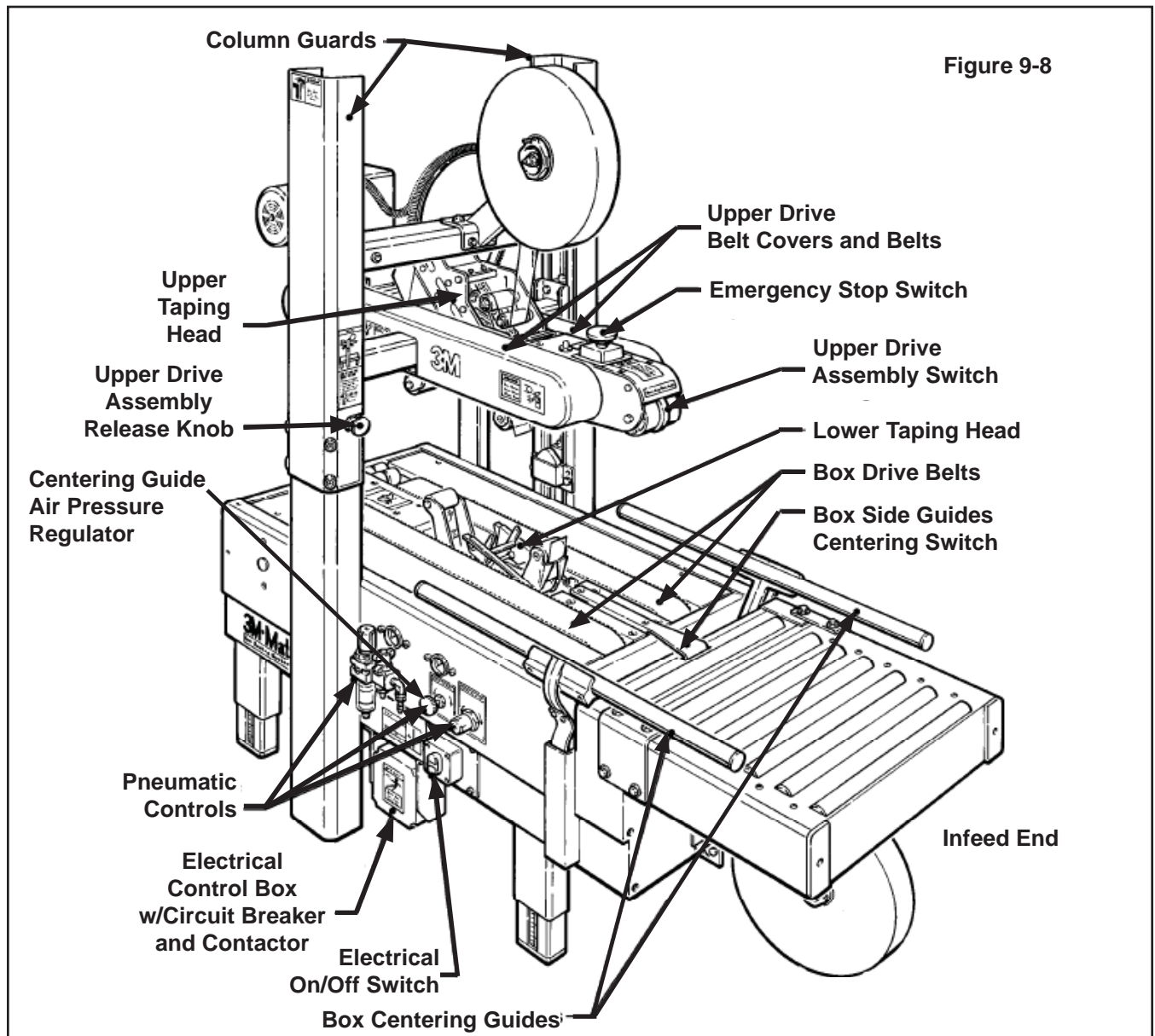
9.6 Upper Drive Assembly Actuator Switch



9.7 Box Conveying / Tape Seal Application



9.8 Location of Controls



10-SAFETY DEVICES OF THE MACHINE

10.1 Blade Guards

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



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.

10.2 Emergency Stop Button

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

The machine electrical supply can be turned off by pressing the latching emergency stop switch. To restart machine, rotate the emergency stop switch clockwise to release the switch latch. Restart machine by turning the On/Off switch to the Off (O) position and then to the On (I) position (**Figure 10-1**).



WARNING

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

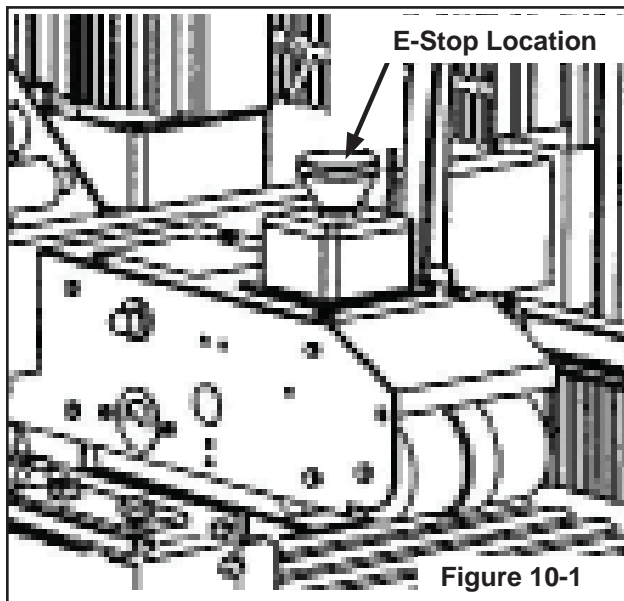


Figure 10-1

10.3 Electric System

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



WARNING

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

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 pushing the On/Off switch to the On (O) position.

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.

11 - SET UP AND ADJUSTMENTS

11.1 Box Height and Width Adjustment

1. Turn main air valve "On".
2. Push electrical switch "On" to start drive belts.
3. With access door closed, feed boxes to machine at minimum 460 mm [18 in] intervals. Operator pushes box against raising switch on upper frame assembly, as shown in Figure 3-7, causing the upper frame (taping head) to be raised above the box.
4. Box is then pushed under belt centering roller-switch (**Figure 3-8**), which closes drive belts and conveys box through machine. Once the box is conveyed from under the upper taping head, the upper frame assembly returns to its rest position, ready for insertion of next box. Also, box exiting machine, trips box exit cams which signal drive belts to return to their full open (rest) position.

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 Centering Guide Air Pressure Regulator (**See Figure 9-8**).

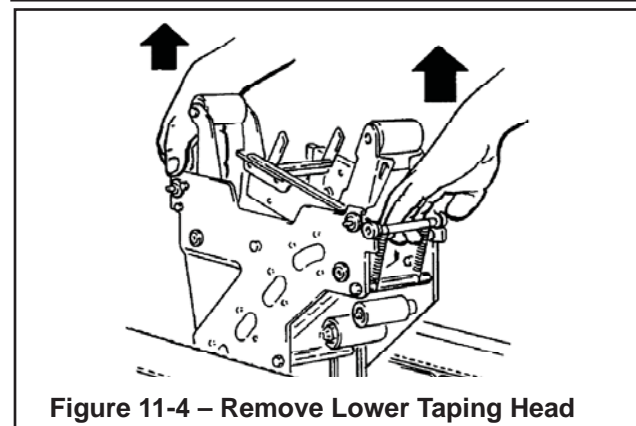
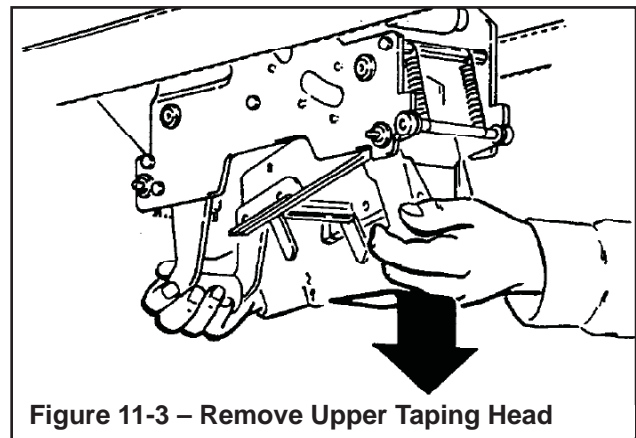
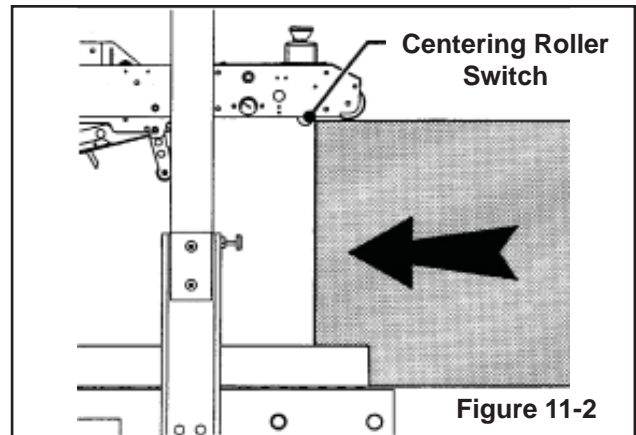
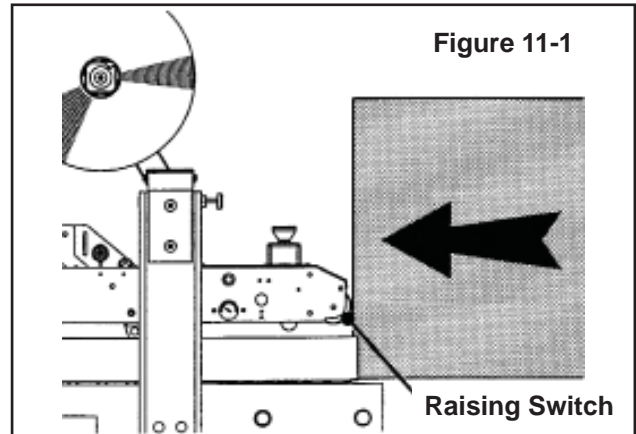
11.3 Adjustment of Top Flap Compression Rollers (Not Applicable to this Machine)

11.4 Changing the Tape Leg Length

Taping heads are preset to apply 70mm [2.75 inches] long tape legs. To change tape leg length to 50mm [2.0 inches], refer to Instructions below and also to Manual 2, "Removing Taping Heads Procedure - Changing the Tape Leg Length".

With upper drive assembly in raised position:

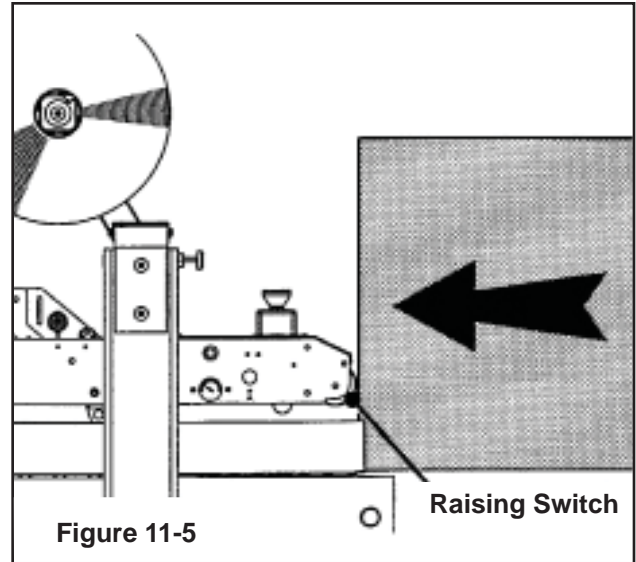
1. Remove tape from upper taping head.
2. Pivot up the clamp that secures the upper taping head.
3. Hold upper taping head applying and buffing arms from under upper assembly, slide head forward and down to remove. See **Figure 11-3**.
4. Lift the lower taping head, shown in **Figure 11-4**, straight up to remove it from the case sealer bed.
5. Refer to Manual 2, "Adjustments – Changing Tape Leg Length," for taping head set-up.
6. Replace taping heads reverse of disassembly. Turn on air supply and electric power, unlatch upper drive assembly and allow it to return to its rest position.



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

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

Turn electrical and air pressure switches to **On**. This starts the drive belts and engages the pneumatic air pressure system. Move box forward until it contacts the Side Guides Centering Switch in the machine bed which automatically center 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.



CAUTION

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

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**).

12-OPERATION

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

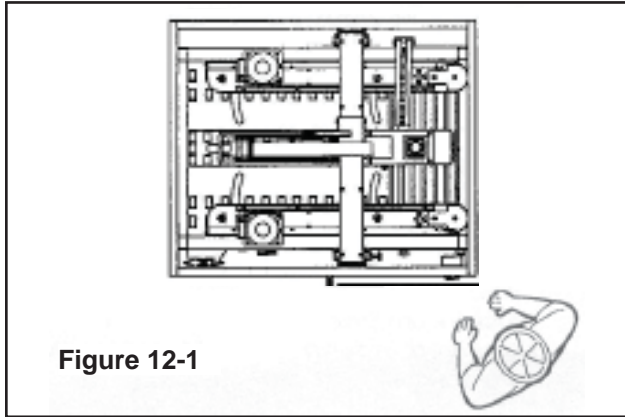


Figure 12-1

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

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



Figure 12-2

12.2 Starting the Machine

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

Push the main rotary switch ON after the EMERGENCY BUTTON is released (**Figure 12-3**).

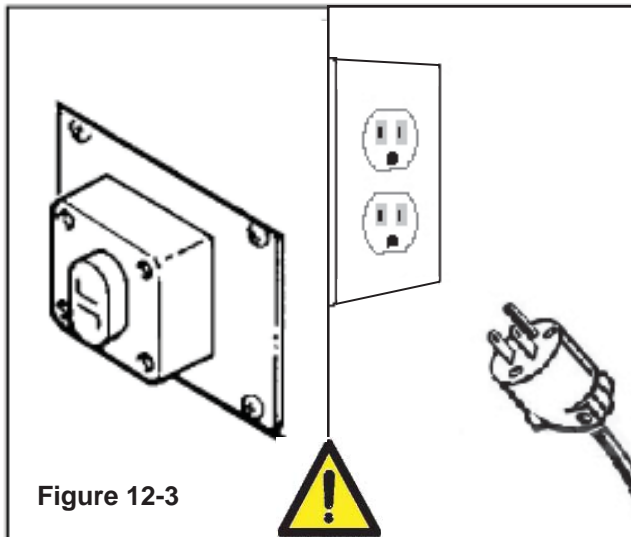


Figure 12-3

12.3 Starting Production

Let the machine run without cartons and check its safety devices. Then start the working cycle.

12.4 Tape Replacement and Threading

Skill 1 - Operator

See Manual 2: AccuGlide™ 3 Taping Heads - 2 inch.

Press the LATCHING EMERGENCY STOP BUTTON.

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.

12.5 Box Size Adjustment

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

12.6 Cleaning

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

12.7 Table of Operation Adjustments - Operator Qualifications

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

12.8 Safety Devices Inspection

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

Troubleshooting

The Troubleshooting Guide lists some possible machine problems, causes and corrections. Also see Manual 2 "Troubleshooting", for taping head problems.

Troubleshooting Guide

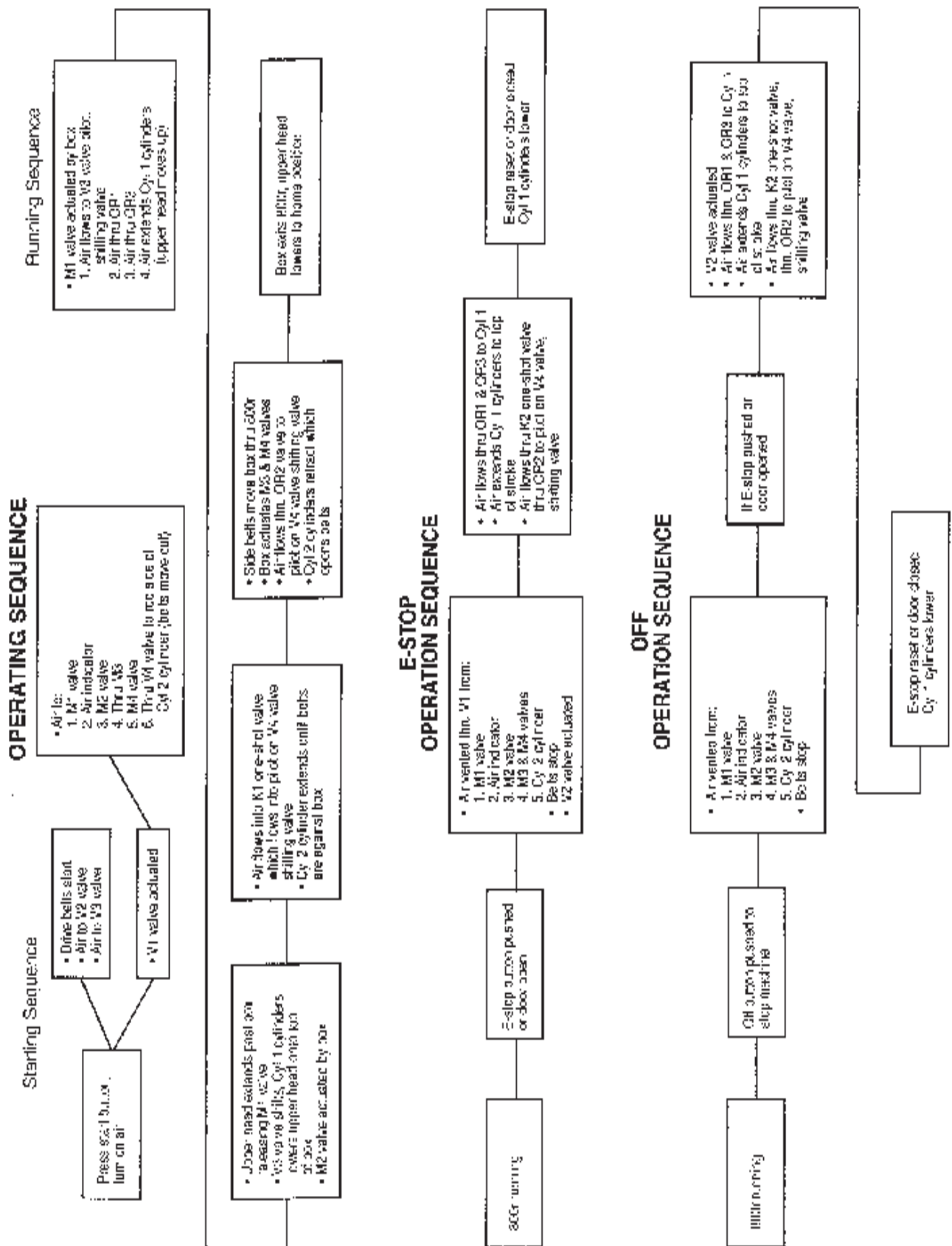
Problem	Cause	Correction
Drive belts do not convey boxes	Narrow boxes	Check machine specifications. Boxes are narrower than recommended, causing slippage and premature belt wear.
	Worn drive belts	Replace drive belts
	Top taping head does not apply enough pressure	Adjust the upper drive assembly force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

(continued)

Troubleshooting (continued)

Troubleshooting Guide

Problem	Cause	Correction
Upper drive assembly does not move up or moves up slowly	Lower air pressure	Disconnect the air supply. Make sure main pressure regulator reads zero. Reconnect air supply and adjust regulator to read 5 bar [70 PSIG].
	Defective head raising valve	Clean or replace head raising valve
	Worn head raising valve actuator	Replace valve
	Clogged or damaged exhaust mufflers on the upper ends of the head raising cylinders	Clean or replace exhaust mufflers
Upper drive assembly does not move up or moves up slowly	Defective head power valve	Clean or replace the head power valve
	Upper drive assembly force adjust regulator set too light	Adjust the upper drive assembly force adjust regulator to increase the force against the top of the box. Turn air regulator counterclockwise.
	Defective top drive assembly force adjust regulator	Replace regulator
	Defective "OR" valve	Clean or replace valve
Upper drive assembly does not move up or moves up slowly	Defective head power valve	Clean or replace valve
	Upper drive assembly force adjust regulator set too heavy	Adjust upper drive assembly force adjust regulator to decrease force against top of box. Turn regulator clockwise.
	Defective upper drive assembly force adjust regulator	Replace regulator
	Cushion screw misadjusted	Adjust cushion screw at base of cylinder
Upper drive assembly does not move up or moves up slowly	Cushion screw missing	Replace screw
	Centering force adjust regulator set too low	Adjust regulator
	Centering guide cylinder speed controls not in correct adjustment	Adjust speed controls mounted on centering guide cylinder
Upper drive assembly does not move up or moves up slowly	Defective centering guide power valve	Clean or replace valve



13-MAINTENANCE AND REPAIRS

13.1 Safety Measures (see section 3)

Carrying out maintenance and repairs may imply the necessity to work in dangerous situations.

13.2 Tools and Spare Parts Supplied with the Machine

See Spare Parts Order Section.

13.3 Recommended Frequency of Inspection and Maintenance Operations

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

13.4 Inspections to be Performed Before and After Every Maintenance Operation

Before every maintenance operation, turn the main switch OFF 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 (**Figure 13-1**). Oil prevents the build-up of tape adhesive.

(See manual 2.)

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 the main switch STOP/OFF
5. Safety guards top drive belts

13.6 Cleaning of Machine

Qualification 1

A weekly cleaning with dry rags or diluted detergents is necessary. Cardboard boxes produce a significant quantity of dust and paper chips when processed or handled in case sealing equipment. If this dust is allowed to build up on machine components, it can cause component wear and over-heating of drive motors. The dust build up is best removed from the machine with a vacuum cleaner. Depending on the number of cartons processed, this cleaning should be done weekly. Excessive build-up that cannot be removed by vacuuming should be removed with a damp cloth.



WARNING

- **To reduce the risk associated with mechanical and electrical hazards:**
 - Read, understand, and follow all safety and operating instructions before operating or servicing the case sealer.
 - Allow only properly trained and qualified personnel to operate and service this equipment.
- **To reduce the risk associated with pinches, entanglement and hazardous voltage:**
 - Turn electrical supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads.

⚠ WARNING

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

Drive Belts

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

REPLACEMENT – SEE STEPS 1 THRU 17

TENSION ADJUSTMENT – SEE STEPS 1-8, 10, 11, 14 and 15

1. Turn air and electrical supply on.
2. Push and hold the upper frame raising switch (A). **Figure 3-2.**
3. Push and hold the latching knob (B). **Figure 3-6.**
4. Release switch (A). Knob (B) will lock the upper head assembly in the upper position.
5. Shut off air supply.
6. Disconnect motor plug (A). **Figure 4-2.**
7. Remove and retain snap rings (B) and special washer (C) from front and rear arm assembly pivots. **Figure 4-2.**
8. Lift side drive assembly (D) up and off arm assembly pivots. **Figure 4-2.**
9. Remove and retain the four screws (E), washers (F) and side cover (G). See **Figure 4-2.**

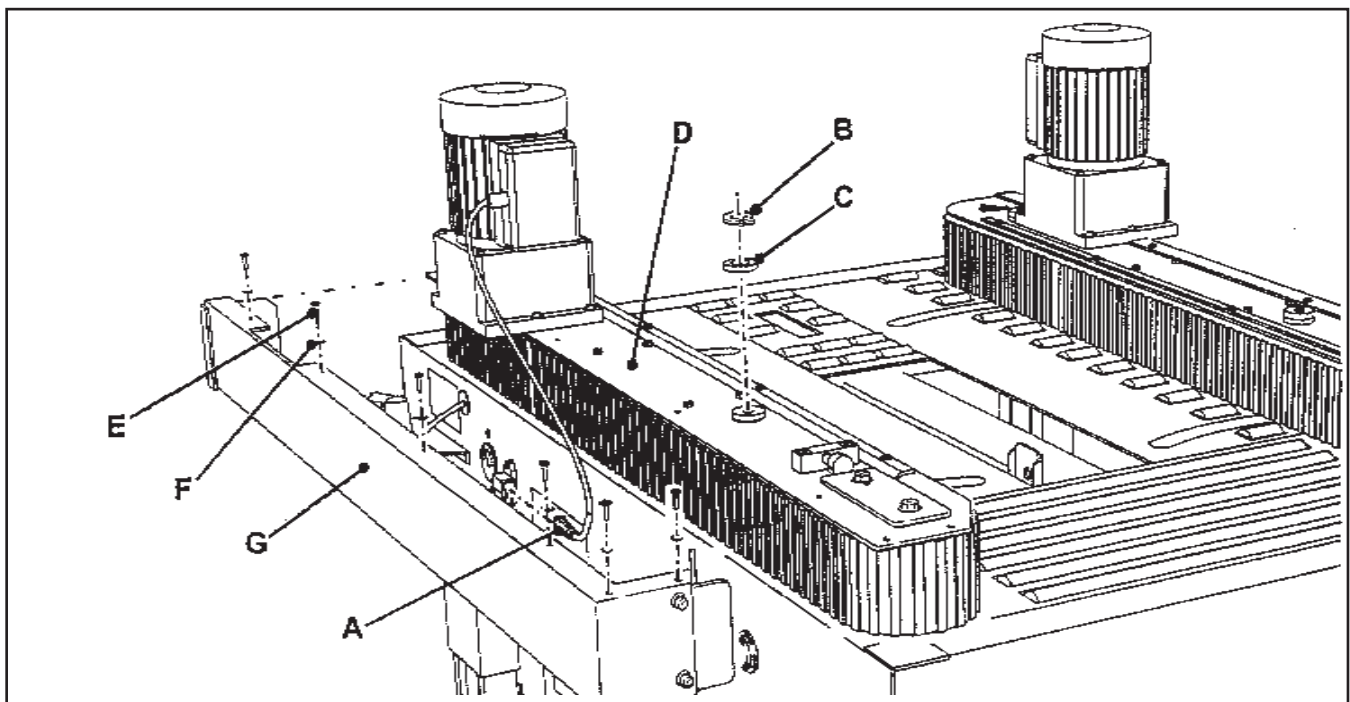


Figure 4-2 – Box Drive Belt (Left Side View – Infeed End)

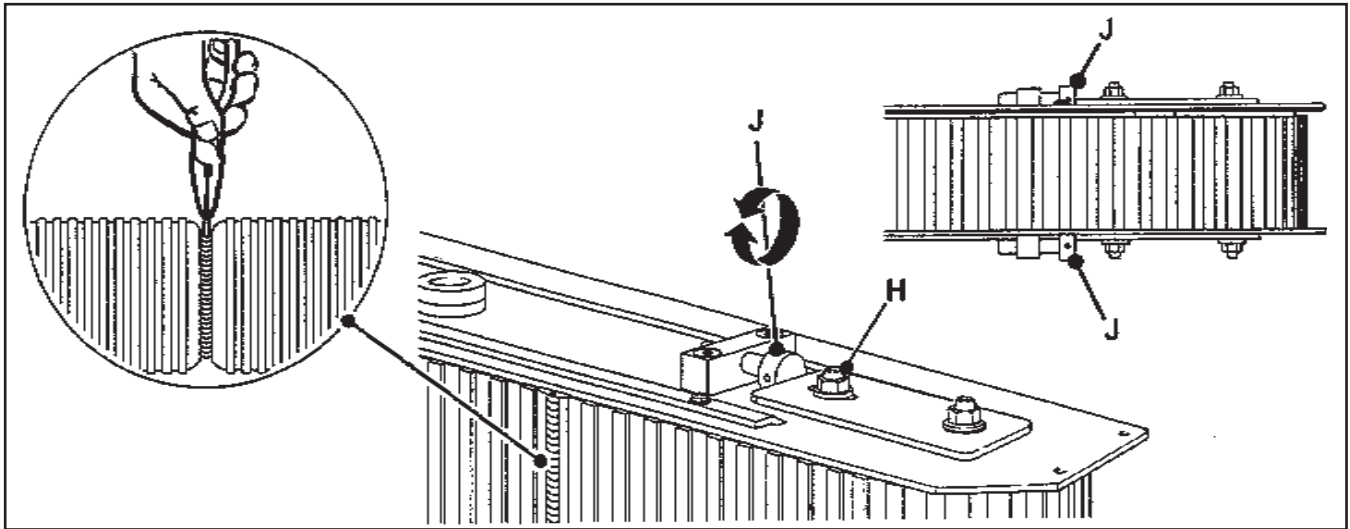


Figure 4-3 – Box Drive Assembly, Infeed End

10. Loosen, but do not remove lock nuts (H) on both the upper and lower belt tension assemblies. See **Figure 4-3**.
11. Turn belt adjustment screws (J) clockwise on both the upper and lower tension assemblies until belt is loose. See **Figure 4-3**.
12. Locate the belt lacing (joint) by turning the belt manually. Remove the pin with pliers. Remove and discard old belt.
13. Install the new belt around drive rollers and insert new pin. Pin **must not** extend beyond edge of belt.

Note – Before installing new drive belt, check the belt inside surface for drive direction arrows and install belt accordingly. If no arrows are shown, the belt may be installed either way.
14. To set drive belt tension, turn adjustment screws (J) equally on both the upper and lower tension assemblies. Turn the screws counterclockwise to increase tension or clockwise to decrease tension. See **Figure 4-3**.

Use a force gauge to pull the belt outward 25mm [1 in] at midspan, as shown in **Figure 4-4** with a moderate pulling force of 3.5 kg [7 lbs].
15. After adjusting belt tension, tighten lock nuts (H) on both the upper and lower tension assemblies.
16. Reverse procedures in Steps 1-6 to complete drive reassembly.
17. Repeat procedure for other belt.

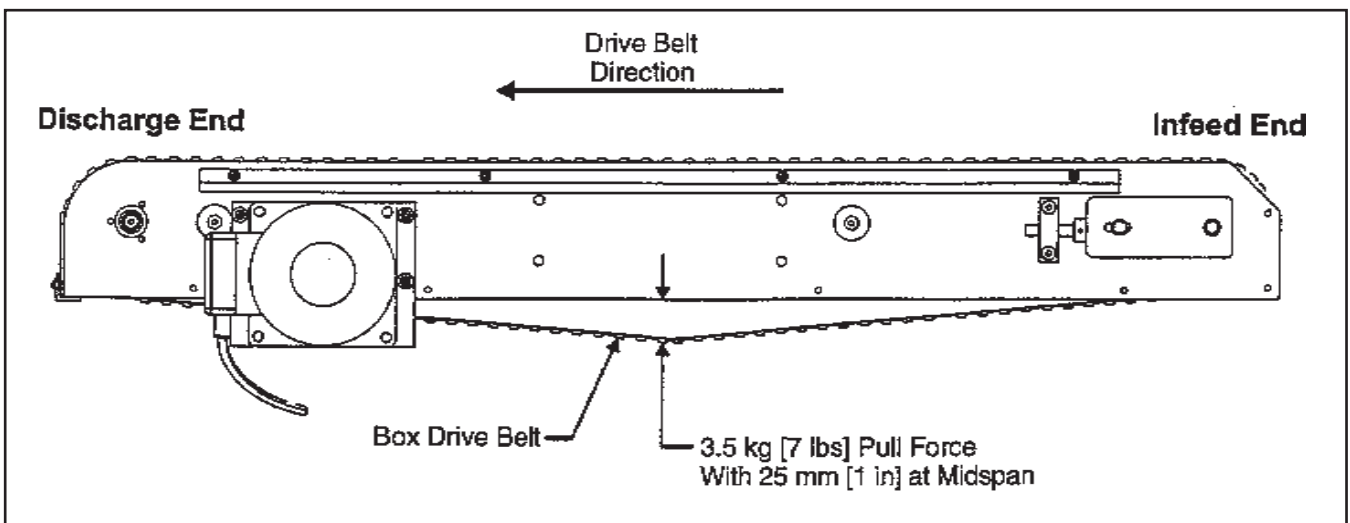


Figure 4-4 – Box Drive Belt Tension Adjustment, Top View

 **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/or service this equipment
 - Turn electrical and air supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads

Circuit Breaker

The case sealer is equipped with a circuit breaker which trips if the motors are overloaded. Located inside the electrical enclosure on the side of the machine frame just below the machine bed, the circuit breaker has been pre-set at 1.9 amps and requires no further maintenance.

If circuit is overloaded and circuit breaker trips, unplug machine from electrical power:

1. Determine cause of overload and correct.
2. Remove electrical enclosure cover.
3. Press the red "Reset" button and then the green "Start" button.
4. Replace cover.
5. Plug in machine.
6. Press machine "On" button to resume case sealing.

Knife Replacement, Taping Head

 **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

See Manual 2, "Maintenance – Knife Replacement".

Adjustments

WARNING

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

Drive Belt Tension

Tension adjustment of the drive belts may be required during normal operation. Belt tension must be adequate to positively move the box through the machine and they should run fully on the surface of the pulleys at each end of the frame. The idler pulleys on the infeed end are adjusted in or out to provide proper belt tension. Each belt is adjusted separately.

Belt tension is obtained by tightening the adjustment screws so that a moderate pulling force of 3.5kg [7 lbs] applied at the midspan, as shown in Figure 4-4, will deflect the belt 25mm [1 in]. This will assure positive contact between the belt and the drive pulley on the discharge end of the taping head.

To adjust belts, see "Maintenance – Drive Belts".

Taping Head Adjustments – Refer to Manual 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

TAPE WEB ALIGNMENT – Manual 2

TAPE DRUM FRICTION BRAKE – Manual 2

APPLYING MECHANISM SPRING – Manual 2

ONE-WAY TENSION ROLLER – Manual 2

TAPE LEG LENGTH ADJUSTMENT – Manual 2

⚠ WARNING

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

Changing the Tape Leg Length

(From 70 to 50mm [2.75 to 2.00 in])

Changing tape leg length to 50mm [2 in] allows taping of smaller boxes. Refer to "Specifications – Box Weight and Size Capacities", for box sizes.

Taping Heads

⚠ WARNING

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

1. Remove upper taping head. Loosen and remove four (each) M6 x 25 flat head screws (A), special washers (B) and spacers (C) that fasten head to upper assembly as shown in **Figure 5-1**. **Support or hold taping head to keep it from falling when screws are removed.**
2. Turn air supply on and raise and latch upper assembly in full up position. Turn air supply off.

⚠ WARNING

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

3. Remove lower taping head by pulling straight up.

4. Refer to Manual 2 "Adjustments – Changing Tape Leg Length".

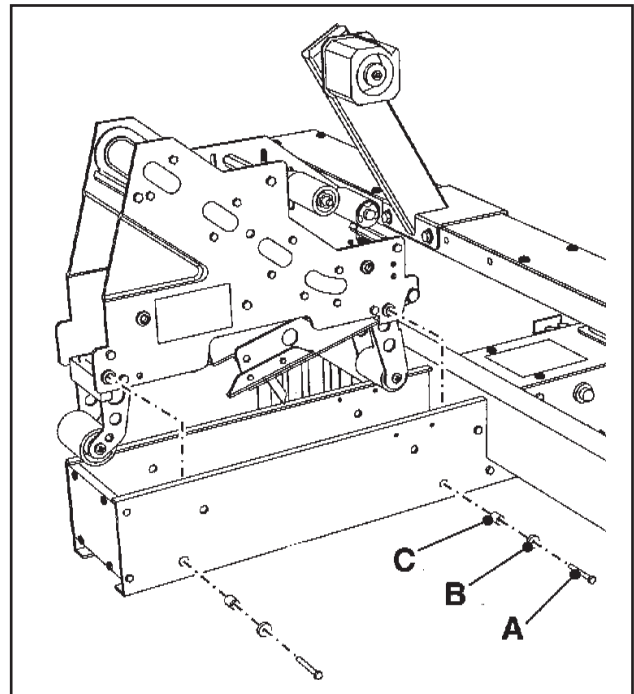


Figure 5-1 – Upper Taping Head Mounting

Outer Column – Re-Positioning

⚠ WARNING

- To reduce the risk associated with muscle strain:
 - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment

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

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

Refer to **Figure 5-2**

1. With air on, raise and latch upper assembly in full raised position. **Be sure electrical supply is disconnected.**
2. Place solid blocks 495 to 535mm [19.5 to 21.0 in] high under front and back of upper assembly as shown in Figure 5-2A.

⚠ WARNING

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

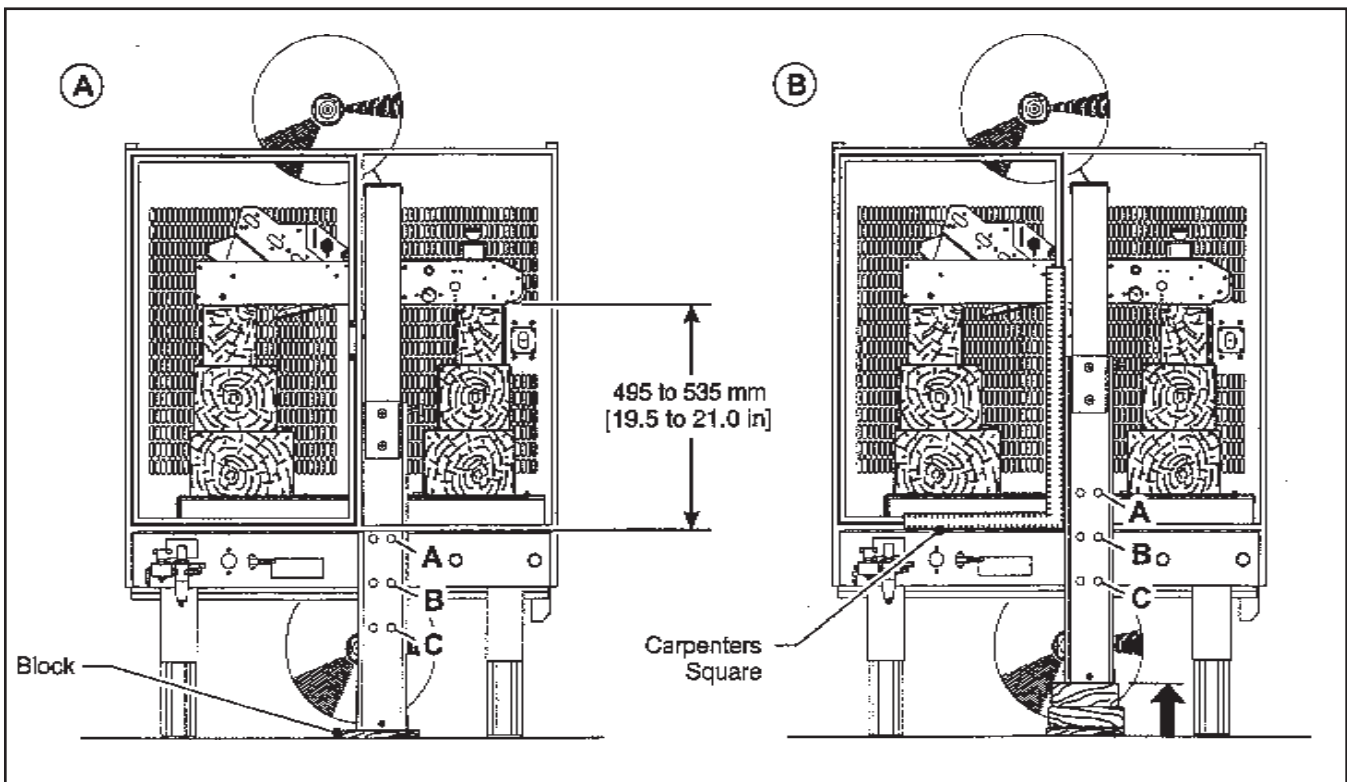


Figure 5-2 – Column Re-Positioning

3. Actuate raising switch to release upper assembly latch. (Upper assembly will rest on blocks) **Turn off and disconnect air supply.**
4. Remove plastic plugs and M8 x 20 socket head capscrews from (A) and (B) in one side column (4 each). Slide side column up approximately 110mm [4.25 in] and re-install capscrews in (B) and (C). **DO NOT TIGHTEN SCREWS.** Repeat procedure for other side column.
5. Using carpenter's square, line up column perpendicular to machine bed as shown in **Figure 5-2B.** Tighten capscrews and install plastic plugs. Repeat this procedure for both columns.
6. Connect and turn on air supply, actuate raising switch and latch upper assembly in full up position.
7. Remove blocking, unlatch and lower upper assembly.

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14.1 Information for Disposal of Machine (ELV)

The machine is composed of the following materials:

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

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

14.2 Emergency Procedures

In case of danger/fire:

Disconnect plug of power cable from power supply.

(Figure 14-1)

IN CASE OF FIRE

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

15.1 Statement of Conformity

Not Applicable.

15.2 Emission of Hazardous Substances

Nothing to report

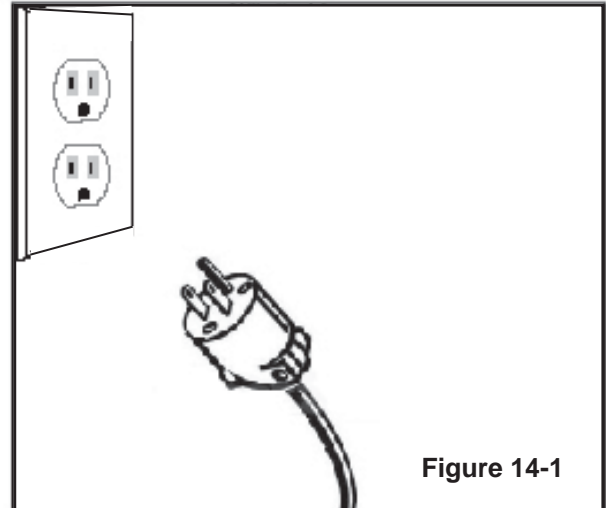


Figure 14-1

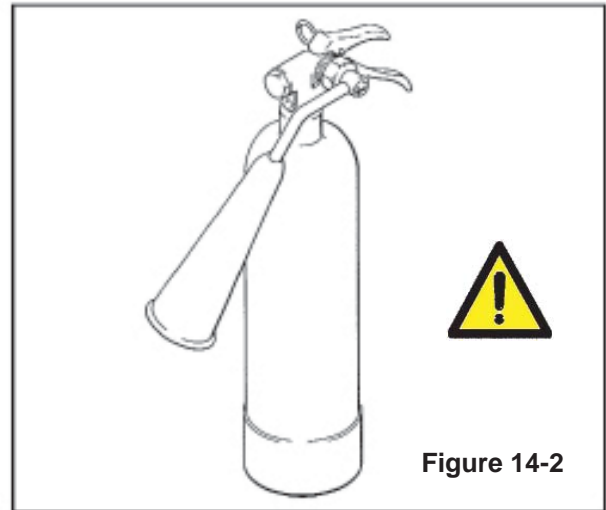
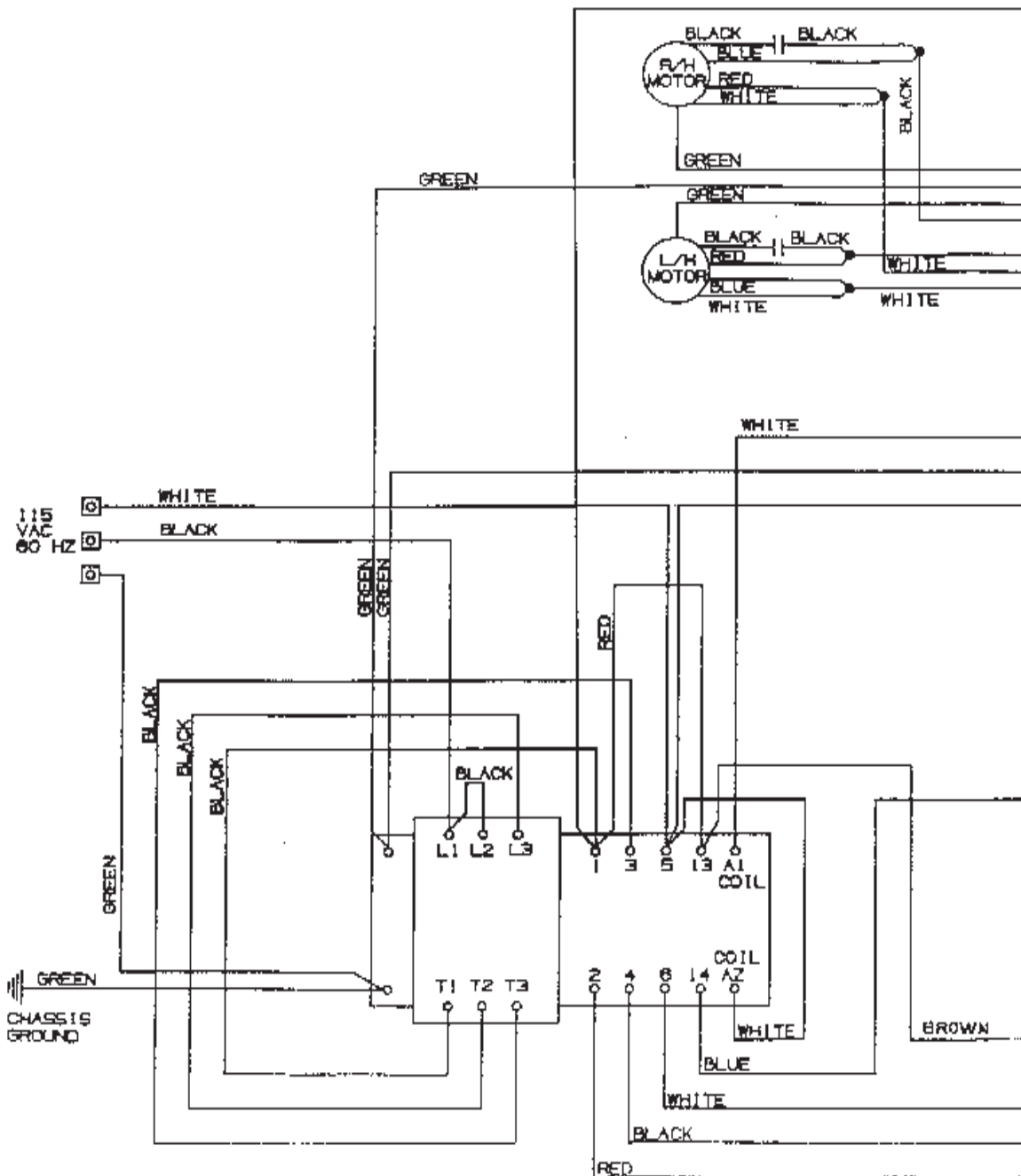


Figure 14-2

16.1 Electric Diagram

⚠ WARNING

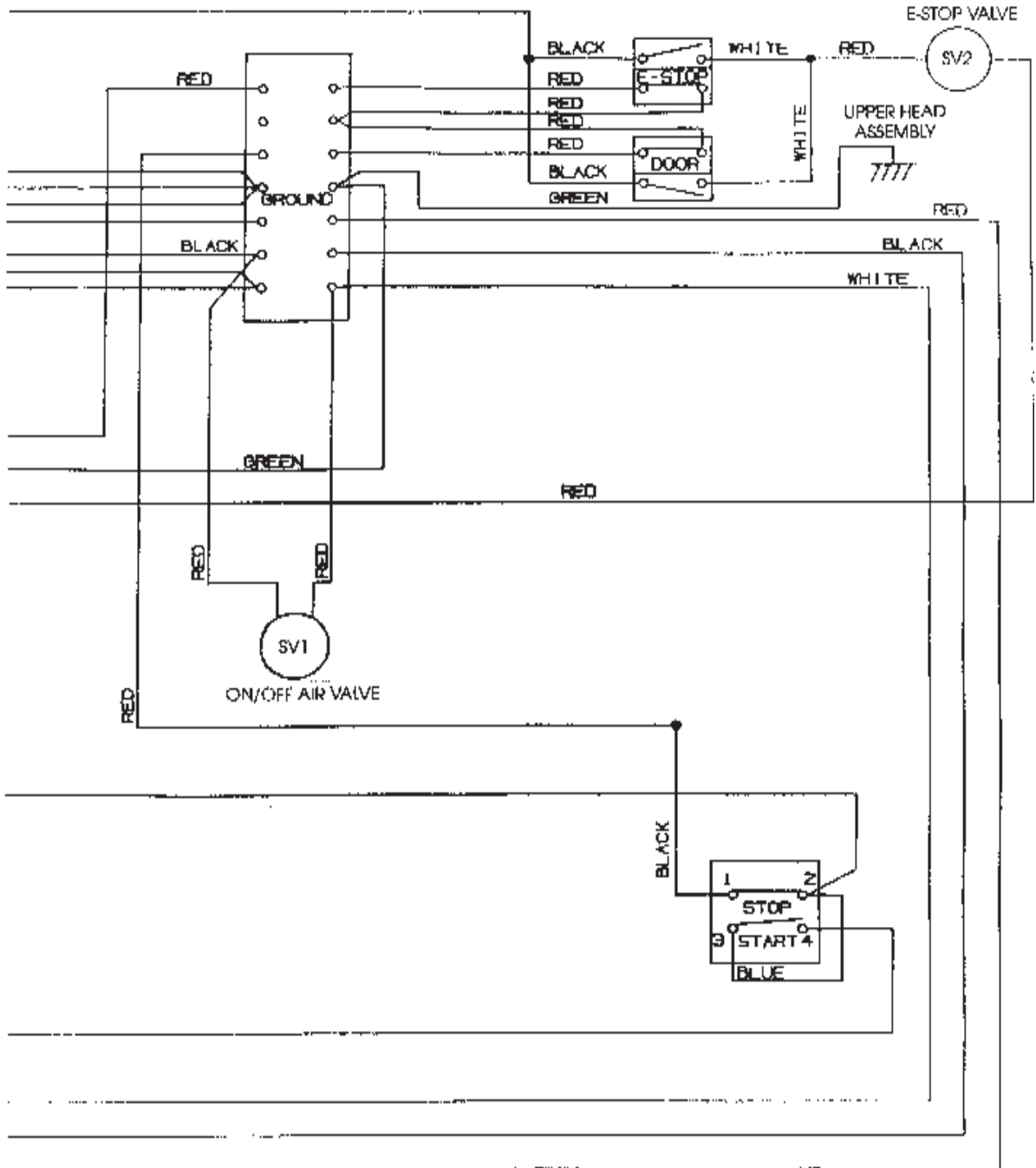
- To reduce the risk associated with mechanical and electrical hazards:
 - Turn electrical and air supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads
 - Allow only properly trained and qualified personnel to operate and/or service this equipment



16.2 Pneumatic Diagram

⚠ WARNING

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



⚠ WARNING

• To reduce the risk associated with mechanical and electrical hazards:

- Turn electrical and air supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads
- Allow only properly trained and qualified personnel to operate and/or service this equipment

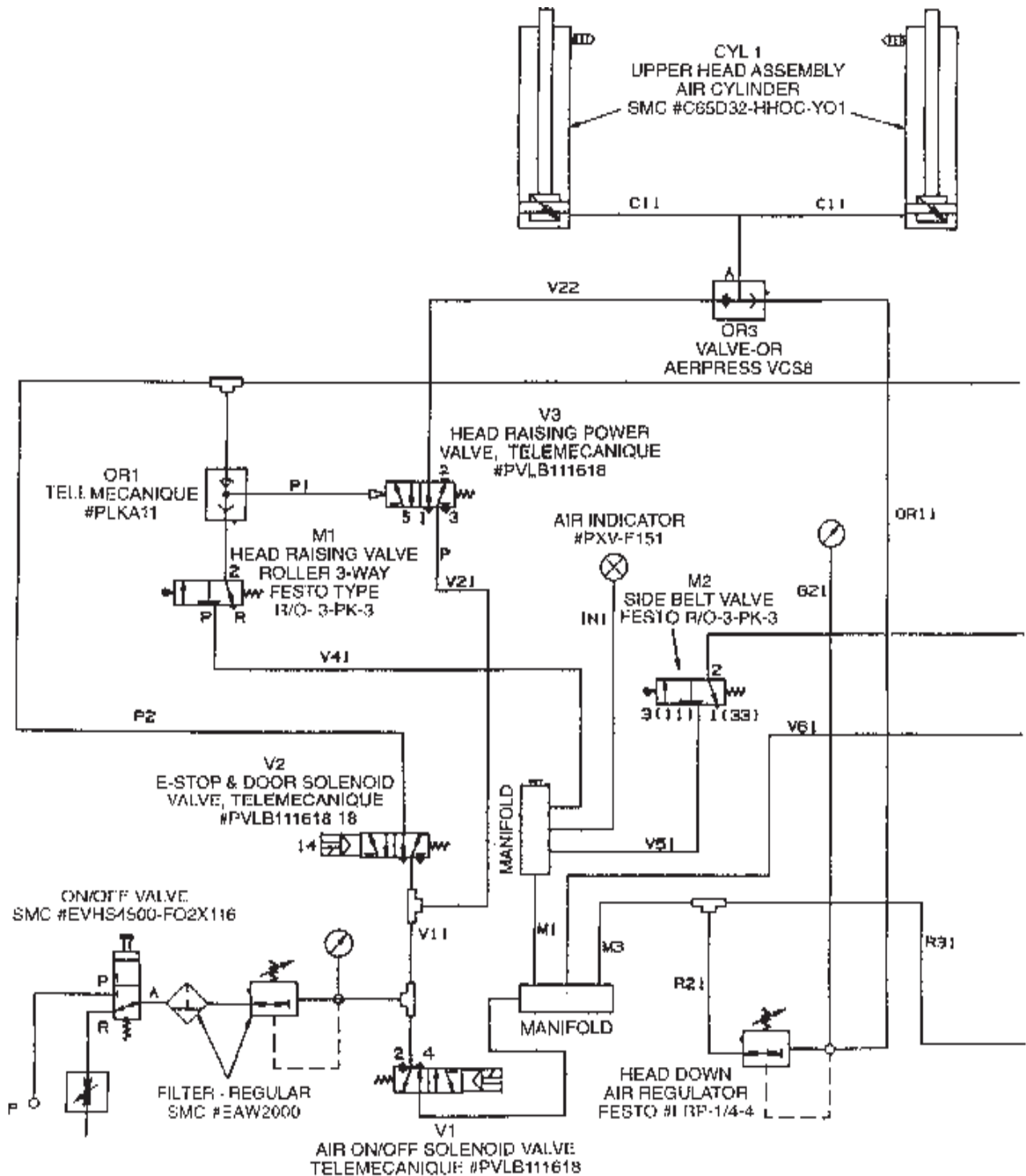
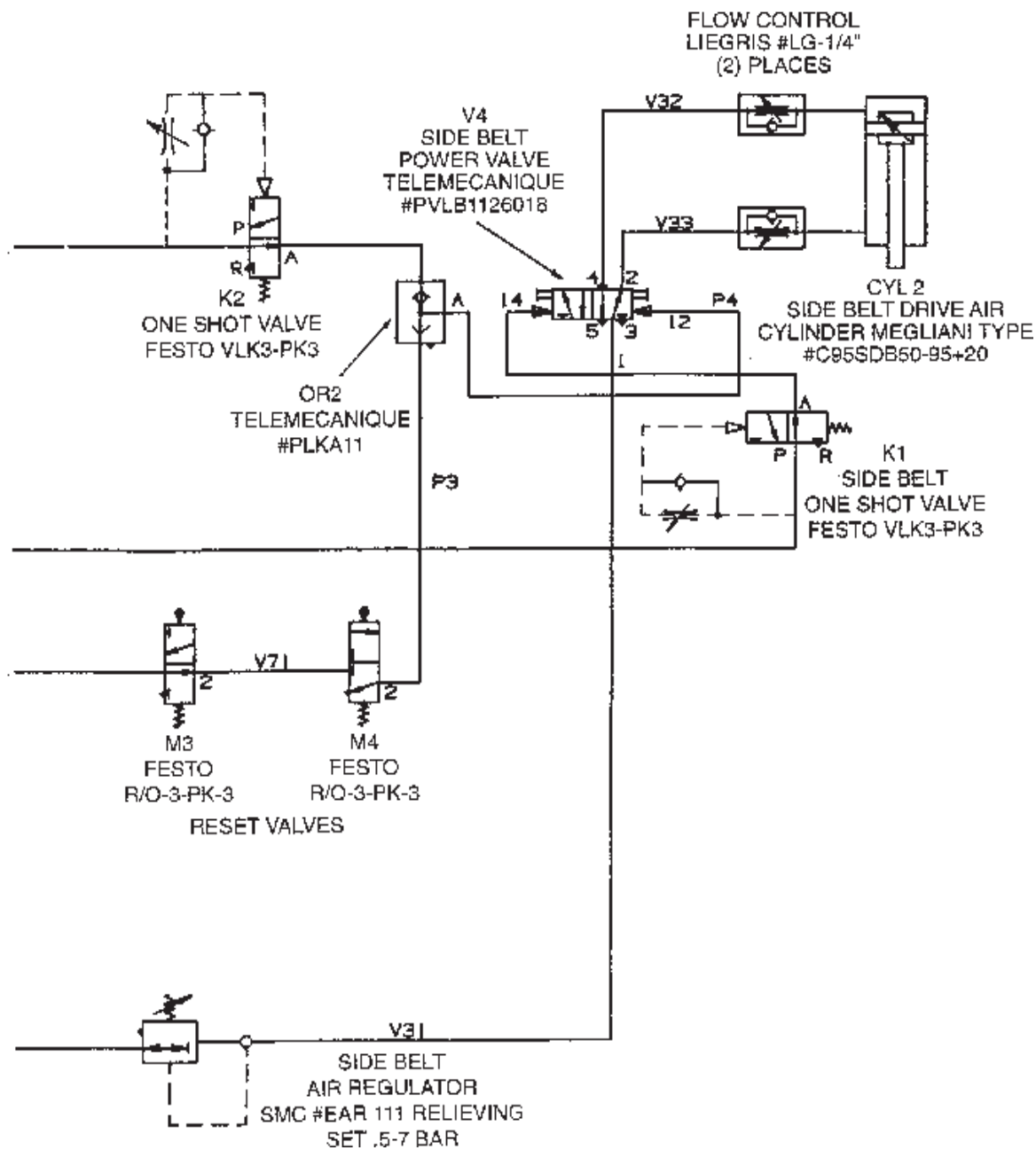


Figure 6-2 – Pneumatic Diagram



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Parts and Service Information

Spare Parts

The following parts periodically require replacement due to normal wear. They should be ordered immediately and kept on hand to keep the case sealer in production.

Qty.	Part Number	Description
1	78-8057-6179-4	Roller – Applying
1	78-8057-6178-6	Roller – Buffing
1	78-8070-1274-1	Spring – Upper Extension (Silver)
1	78-8017-9173-8	Knife – 65 mm/2.56 Inch
1	78-8113-7030-9	Spring – Torsion
2	78-8052-6602-6	Spring – Cutter
1	78-8070-1273-3	Spring – Lower Extension (Black)
4	78-8094-6447-8	Belt – Drive

Labels

In the event that any labels are damaged or destroyed, **they must be replaced to ensure operator safety.** For safety and information replacement labels, see Parts Illustration/Lists, Manual 1, pages 68-69.

Tool Kit

A tool kit, P/N 78-8060-8476-6, packaged separately and included with your machine, contains the necessary wrenches for use with the metric fasteners on the case sealer. The threading tool, part number 78-8076-4726-4, contained in the kit is available as a stock replacement item and can be ordered separately.

Parts Ordering/Service

Refer to the first page of this instruction manual for parts ordering or service information.

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Options/Accessories

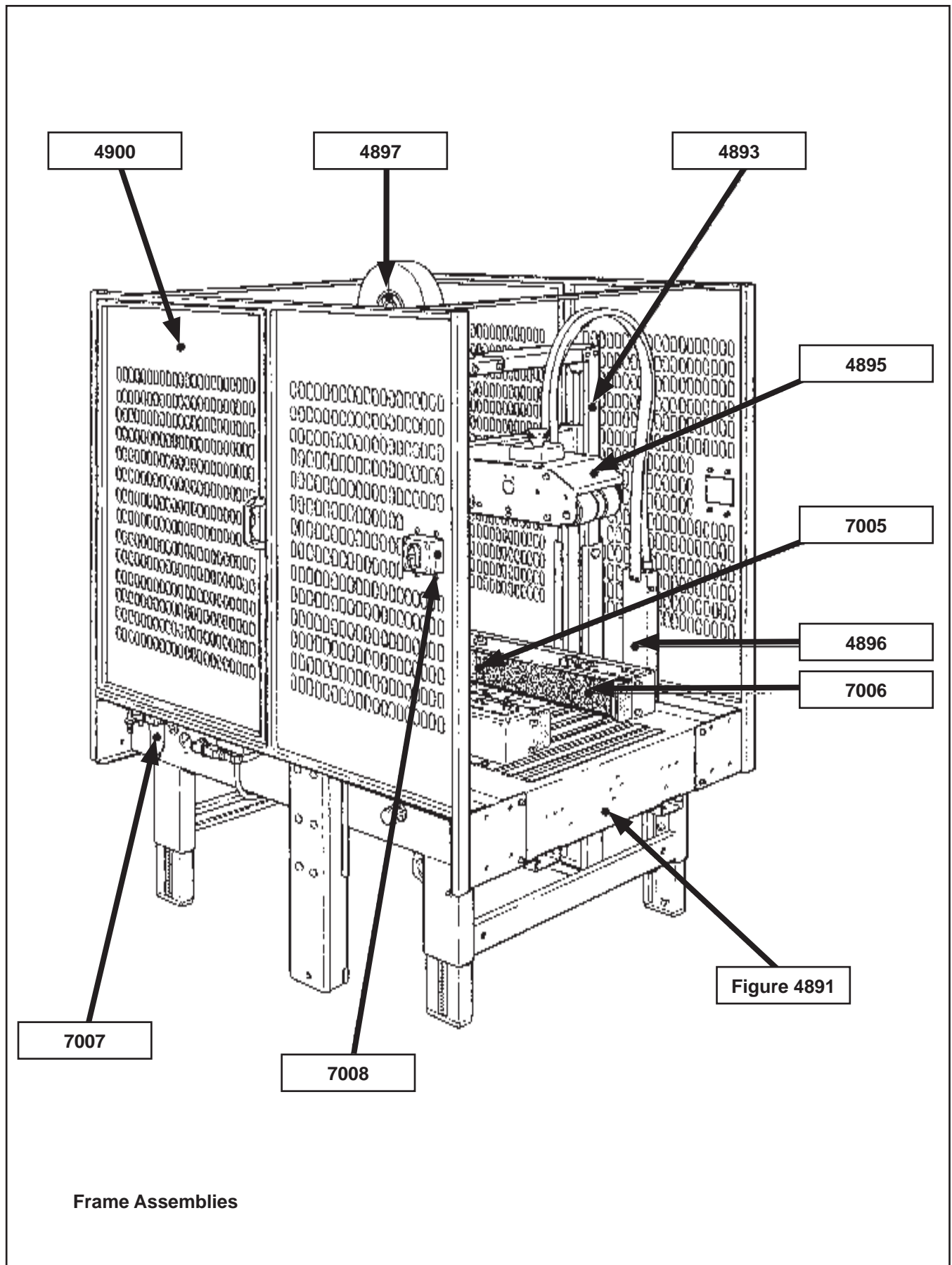
For additional information on the options/accessories listed below, contact your 3M Representative.

Part Number	Option/Accessory
78-8095-4862-7	Infeed/Exit Conveyor Attachment
78-8069-3926-6	Low Tape Sensor Kit
70-0064-0353-2	AccuGlide 2+ STD 2 Inch Upper Taping Head, Type 10500
70-0064-0354-0	AccuGlide 2+ STD 2 Inch Lower Taping Head, Type 10500
78-8095-4854-4	2 Inch Tape Edge Fold Attachment (Upper Head)
78-8095-4855-1	2 Inch Tape Edge Fold Attachment (Lower Head)
78-8069-3983-7	Caster Kit

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800r Random Case Sealer



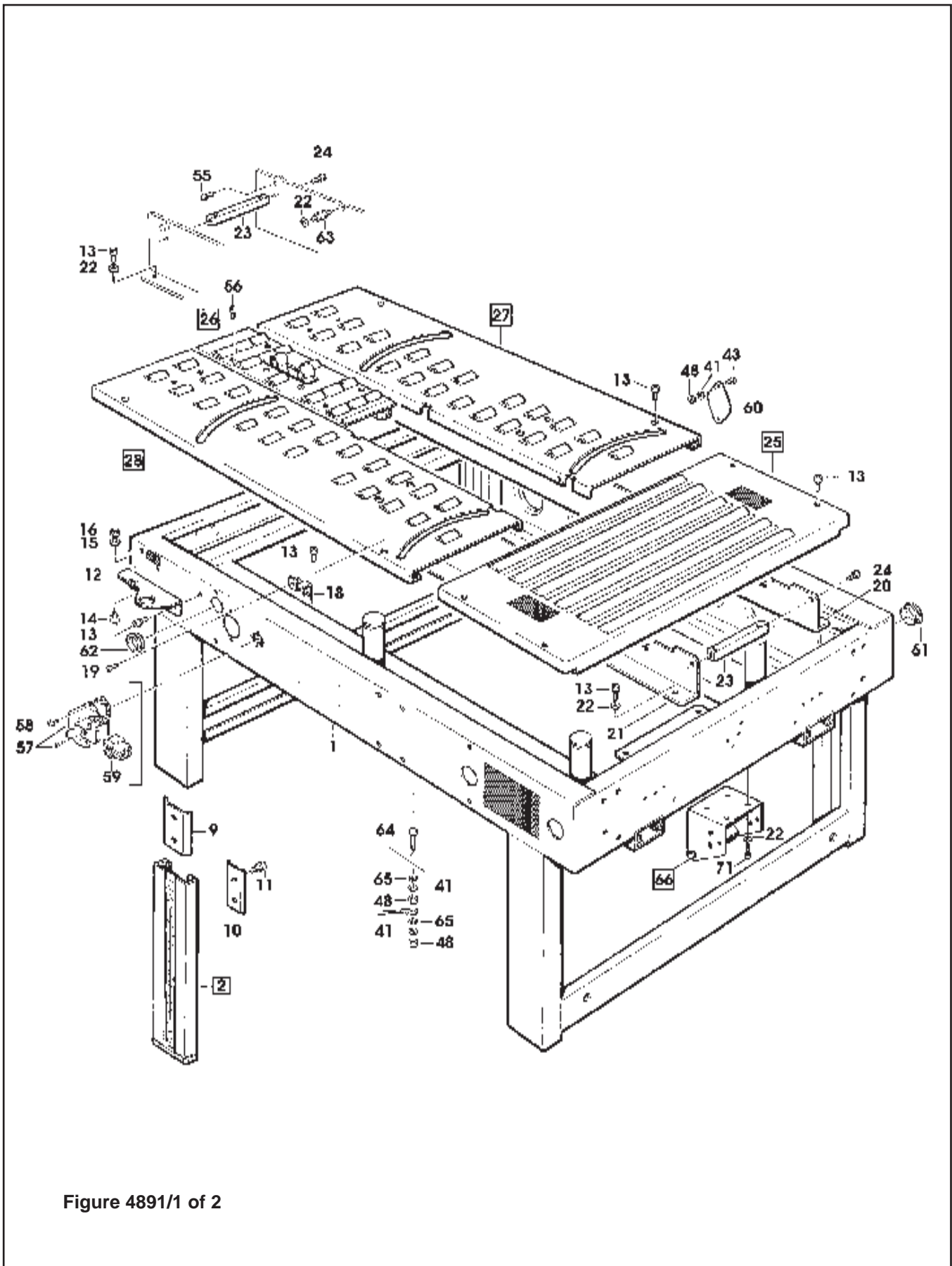


Figure 4891/1 of 2

Figure 4891 (page 1 of 2)

Ref. No.	3M Part No.	Description
4891-1	78-8113-6827-9	Bed Assembly – Conveyor, W/English Language Label
4891-2	78-8094-6486-6	Leg Assembly – Inner
4891-3	78-8100-1246-4	Leg – Inner
4891-4	78-8060-8480-8	Pad – Foot
4891-5	78-8055-0867-4	Screw – Hex Hd, M8 x 30
4891-6	26-1004-5507-5	Washer – M8
4891-7	78-8017-9313-0	Nut – Self-Locking, M8
4891-8	78-8094-6487-4	Label – Leg
4891-9	78-8052-6677-8	Clamp – Inner
4891-10	78-8052-6676-0	Clamp – Outer
4891-11	26-1003-7963-0	Screw – Soc Hd, M8 x 16
4891-12	78-8094-6392-6	Bracket
4891-13	78-8010-7209-7	Screw – Soc Hd, M6 x 12
4891-14	78-8091-0613-7	Shaft – Valve
4891-15	78-8042-2919-9	Washer – Triple, M6
4891-16	26-1003-6916-9	Nut – Locking Plastic Insert, M6
4891-18	78-8076-4535-9	Bracket
4891-19	78-8076-4625-8	Screw – Special, M5 x 16
4891-20	78-8094-6393-4	Frame – BTM, R/H
4891-21	78-8094-6394-2	Frame – BTM, L/H
4891-22	26-1000-0010-3	Washer – Flat, M6
4891-23	78-8060-7955-0	Spacer – Center Frame
4891-24	78-8010-7169-3	Screw – Hex Hd, M6 x 12
4891-25	78-8094-6395-9	Conveyor Assembly – Front
4891-26	78-8094-6396-7	Conveyor Assembly – Rear
4891-27	78-8094-6397-5	Conveyor Assembly – R/H
4891-28	78-8094-6398-3	Conveyor Assembly – L/H
4891-29	78-8113-6826-1	Conveyor – Front, W/English Language Label
4891-30	78-8094-6400-7	Conveyor – Rear
4891-31	78-8094-6401-5	Conveyor – R/H
4891-32	78-8094-6402-3	Conveyor – L/H
4891-33	78-8094-6403-1	Shaft – Roller
4891-34	78-8059-5596-6	Roller
4891-35	78-8052-6694-3	Shaft – /8 x 128
4891-36	78-8060-7693-7	Roller – 32 x 38
4891-37	78-8060-7965-9	Shaft – Hex Hd, /8 x 120
4891-38	78-8054-8857-0	Shaft – 8 x 43 mm

800r Random Case Sealer

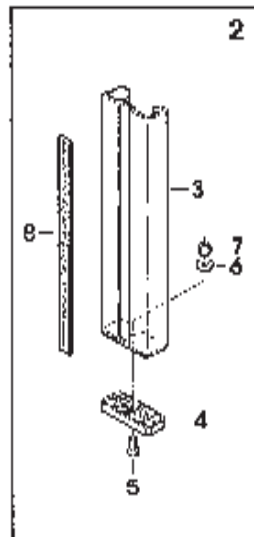
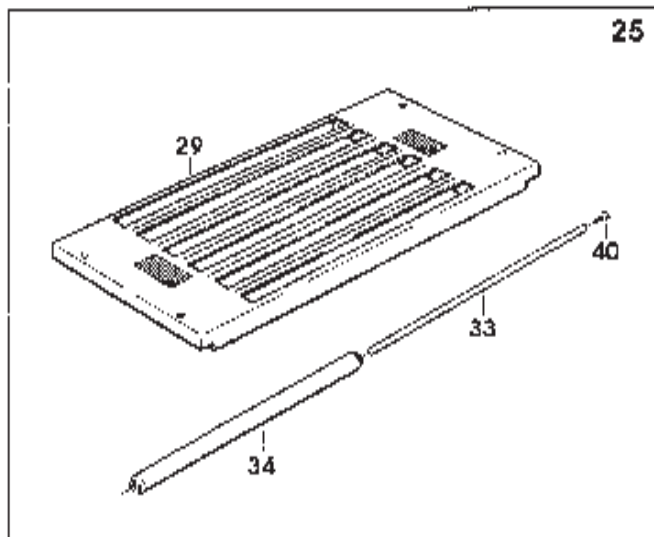
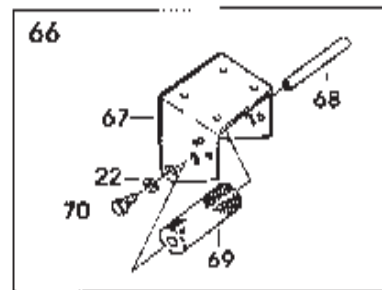
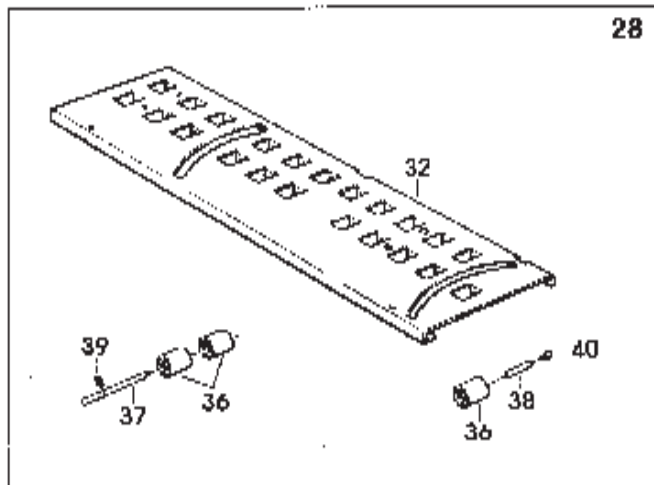
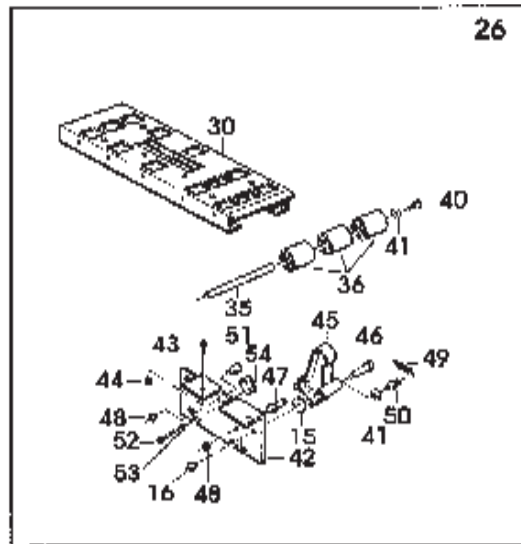
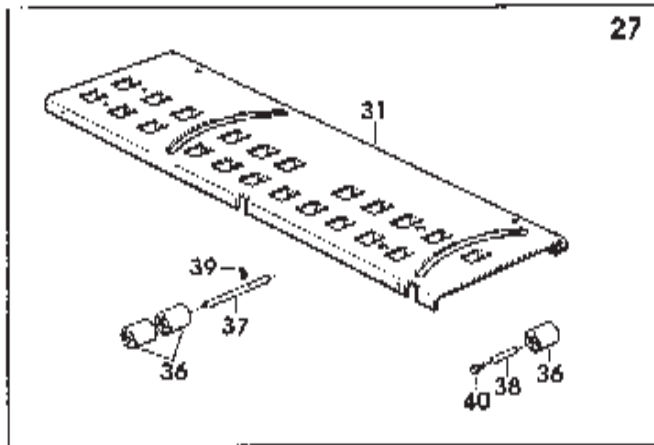


Figure 4891/2 of 2

Figure 4891 (page 2 of 2)

Ref. No.	3M Part No.	Description
4891-39	78-8060-8035-0	E-Ring – 7DIN6799
4891-40	78-8010-7163-6	Screw – Hex Hd, M5 x 10
4891-41	78-8005-5741-1	Washer – Plain, M5
4891-42	78-8060-8086-3	Support – Valve
4891-43	78-8060-8087-1	Washer – Plain, M5
4891-44	26-1005-6859-6	Nut – Self-Locking, M5
4891-45	78-8060-7775-2	Cam – Rear
4891-46	78-8060-8088-9	Shaft – Cam
4891-47	78-8054-8757-2	Pin – Spring Holder
4891-48	78-8010-7417-6	Nut – Hex, M5
4891-49	78-8094-6404-9	Spring
4891-50	78-8060-7777-8	Spring – Tensioner
4891-51	78-8060-8080-6	Guard – Stop
4891-52	26-1003-7946-5	Screw – Soc Hd, M4 x 25
4891-53	78-8017-9018-5	Washer – Plain, SPEC, M4
4891-54	78-8059-5607-1	Plate – Threaded
4891-55	26-1003-5829-5	Screw – Hex Hd, M6 x 12
4891-56	26-1003-7948-1	Screw – Soc Hd, Hex Soc, M5 x 10
4891-57	78-8060-7876-8	Cover Plug – Lateral
4891-58	78-8028-8208-0	Screw – 6PX9,5
4891-59	78-8060-7873-5	Plug – Female
4891-60	78-8094-6305-8	Plate – Gauge
4891-61	78-8094-6177-1	Cap
4891-62	78-8094-6489-0	Snap Bushing
4891-63	78-8070-1456-4	Stud – Hex
4891-64	78-8060-8488-1	Screw – Hex Hd, M5 x 20
4891-65	78-8046-8217-3	Washer – Special
4891-66	78-8076-5392-4	Support – Tape Drum
4891-67	78-8060-8483-2	Support – Outboard Roll Mount
4891-68	78-8060-8484-0	Shaft – Roller
4891-69	78-8060-8485-7	Roller
4891-70	78-8032-0375-7	Screw – Hex Hd, M6 x 16
4891-71	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16

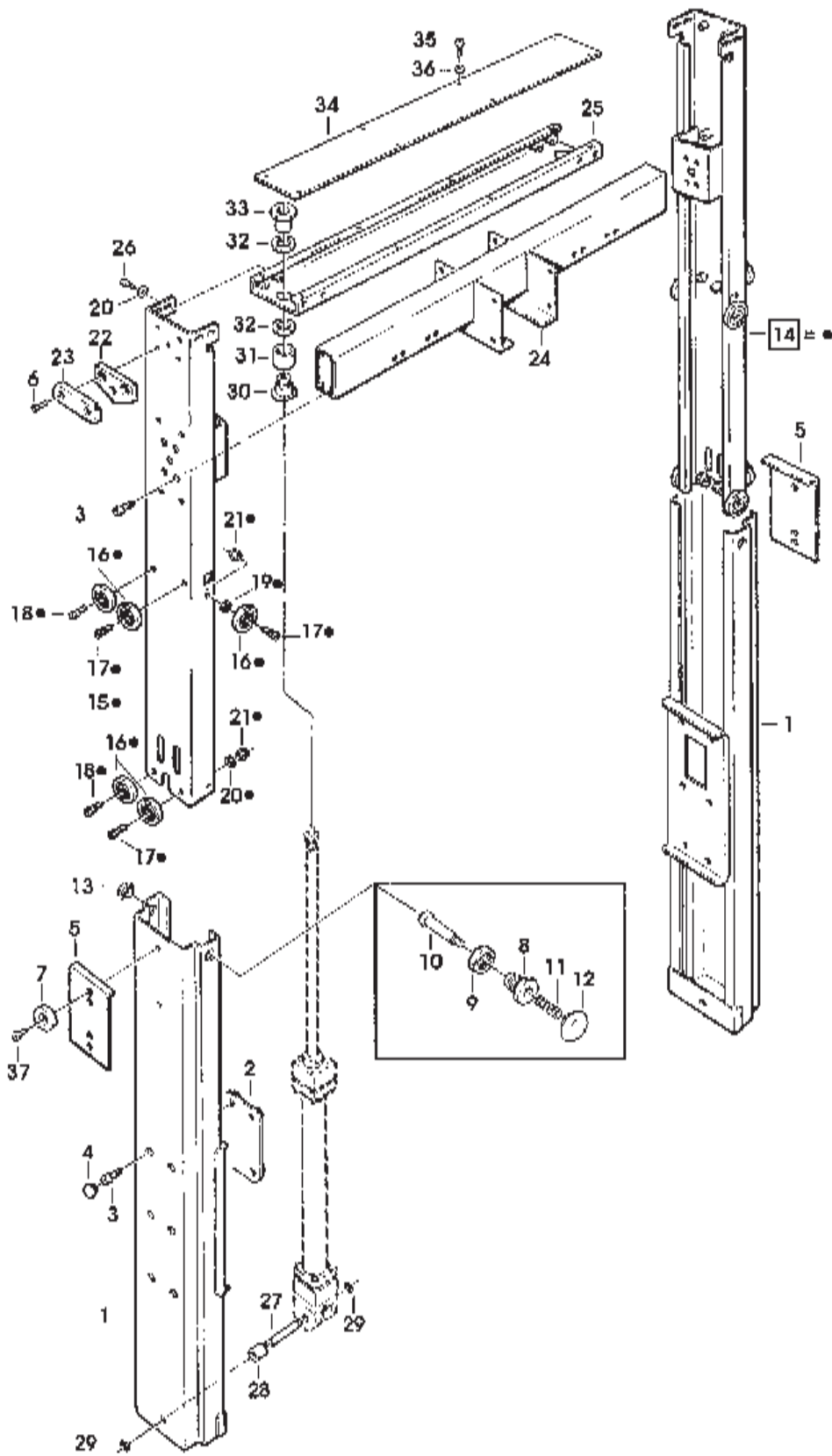


Figure 4893

Figure 4893

Ref. No.	3M Part No.	Description
4893-1	78-8094-6408-0	Column Assembly – Outer
4893-2	78-8076-5474-0	Plate Assembly – Column Mount
4893-3	26-1003-7964-8	Screw – Soc Hd, Hex Soc Dr, M8 x 20
4893-4	78-8054-8821-6	End – Cap
4893-5	78-8091-0621-0	Plate – Outer Column
4893-6	78-8060-7918-8	Screw – Flat, Soc Hd, M6 x 25
4893-7	78-8054-8577-4	Washer – Special
4893-8	78-8091-0615-2	Bushing – Stop
4893-9	78-8017-9169-6	Nut – M18 x 1
4893-10	78-8076-4544-1	Stud – Height Stop
4893-11	78-8076-4545-8	Spring
4893-12	78-8100-0954-4	Knob
4893-13	78-8076-4547-4	Cap – /18
4893-14	78-8094-6410-6	Column Assembly – Inner
4893-15	78-8094-6411-4	Column – Inner
4893-16	78-8054-8617-8	Bearing – Special
4893-17	78-8017-9106-8	Screw – Bearing Shoulder
4893-18	78-8054-8589-9	Screw – Special
4893-19	78-8054-8576-6	Spacer
4893-20	26-1000-0010-3	Washer – Flat, M6
4893-21	26-1003-6916-9	Nut – Locking Plastic Insert, M6
4893-22	78-8060-7916-2	Bumper
4893-23	78-8091-0617-8	Plate – Support Bumper
4893-24	78-8094-6412-2	Bar
4893-25	78-8094-6413-0	Cross Member
4893-26	78-8032-0375-7	Screw – Hex Hd, M6 x 16
4893-27	78-8054-8966-9	Pin – Air Cylinder Clevis
4893-28	78-8054-8828-1	Spacer – 10,5/16X14, 5MM
4893-29	78-8060-8035-0	E-Ring – 7DIN6799
4893-30	78-8054-8824-0	Rod End
4893-31	78-8094-6416-3	Spacer
4893-32	78-8054-8823-2	Washer – Bumper
4893-33	78-8094-6417-1	Ring Nut
4893-34	78-8094-6418-9	Cover
4893-35	78-8076-5255-3	Screw – Phillips Hd, M4 x 12
4893-36	78-8005-5740-3	Washer – Plain, 4MM
4893-37	26-1001-9843-6	Screw – Flat, Soc Hd, M6 x 16

800r Random Case Sealer

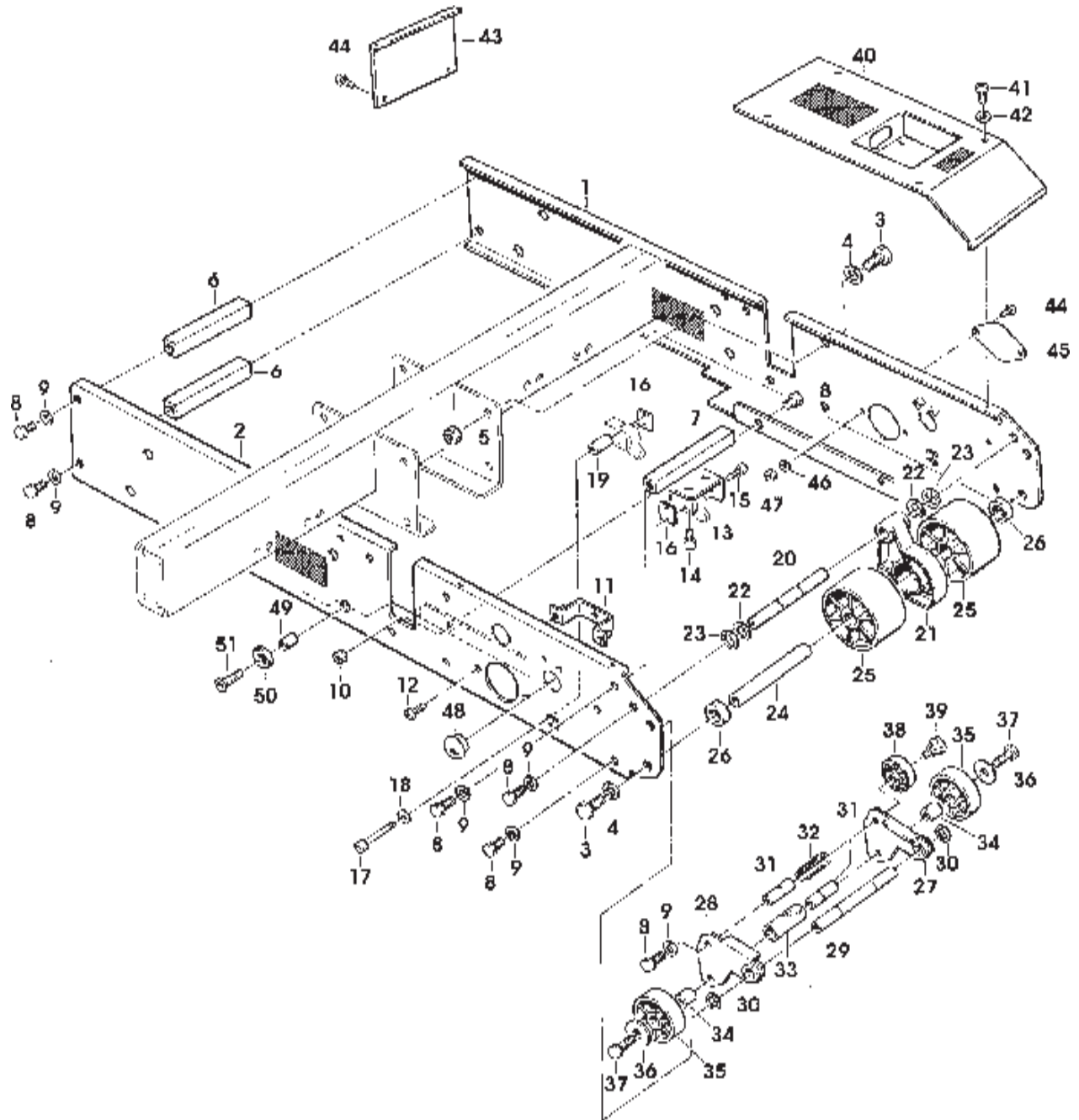


Figure 4895

Figure 4895

Ref. No.	3M Part No.	Description
4895-1	78-8113-6832-9	Frame Assembly – R/H, W/English Language Label
4895-2	78-8113-6830-3	Frame Assembly – L/H, W/English Language Label
4895-3	26-1003-5841-0	Screw – M8 x 16
4895-4	78-8017-9318-9	Washer – Plain, 8MM
4895-5	26-1000-1347-8	Nut – Hex, M8
4895-6	78-8094-6432-0	Spacer
4895-7	78-8094-6433-8	Spacer
4895-8	78-8010-7169-3	Screw – Hex Hd, M6 x 12
4895-9	26-1000-0010-3	Washer – Flat, M6
4895-10	78-8010-7418-4	Nut – Hex, M6
4895-11	78-8076-4535-9	Bracket
4895-12	78-8076-4625-8	Screw – Special, M5 x 16
4895-13	78-8054-8832-3	Support – Valve
4895-14	26-1003-7949-9	Screw – Soc Hd, Hex Soc, M5 x 12
4895-15	26-1003-7946-5	Screw – Soc Hd, M4 x 25
4895-16	78-8059-5607-1	Plate – Threaded
4895-17	78-8094-6434-6	Screw – Soc Hd, Hex Hd, M4 x 50
4895-18	78-8017-9018-5	Washer – Plain, M4 SPEC.
4895-19	78-8094-6435-3	Spacer
4895-20	78-8094-6436-1	Shaft – Lever
4895-21	78-8076-4657-1	Link – Actuator, Valve
4895-22	78-8052-6566-3	Washer – Friction
4895-23	78-8016-5855-6	E-Ring – 10MM
4895-24	78-8094-6437-9	Shaft – Roller
4895-25	78-8094-6438-7	Roller
4895-26	78-8094-6251-4	Spacer
4895-27	78-8094-6439-5	Frame – R/H
4895-28	78-8094-6440-3	Frame – L/H
4895-29	78-8094-6441-1	Shaft – 10 x 125
4895-30	78-8060-8035-0	E-Ring – 7DIN6799
4895-31	78-8094-6255-5	Shaft – 10 x 46
4895-32	78-8076-4774-4	Spring
4895-33	78-8094-6256-3	Sleeve
4895-34	78-8094-6258-9	Bushing
4895-35	78-8060-7798-4	Wheel – /50
4895-36	78-8042-2919-9	Washer – Triple, M6
4895-37	26-1003-5832-9	Screw – Hex Hd, M6 x 25
4895-38	78-8054-8617-8	Bearing – Special
4895-39	78-8017-9106-8	Screw – Bearing Shoulder
4895-40	78-8113-6829-5	Upper Cover Assembly – W/English Language Label
4895-41	26-1002-5753-9	Screw – Self-Tapping
4895-42	78-8005-5740-3	Washer – Plain, 4 MM
4895-43	78-8094-6444-5	Cover – Rear
4895-44	78-8060-8087-1	Screw – M5 x 10
4895-45	78-8094-6259-7	Plate
4895-46	78-8005-5741-1	Washer – Plain, M5
4895-47	78-8010-7417-6	Nut – Hex, M5
4895-48	78-8060-7885-9	End Cap – /25X1,2
4895-49	78-8052-6700-8	Spacer – Taping Head Mtg.
4895-50	78-8076-5477-3	Washer – Taping Head Mtg., 6.5 x 20 x 4
4895-51	78-8060-7918-8	Screw – Flat, Soc Hd, M6 x 25

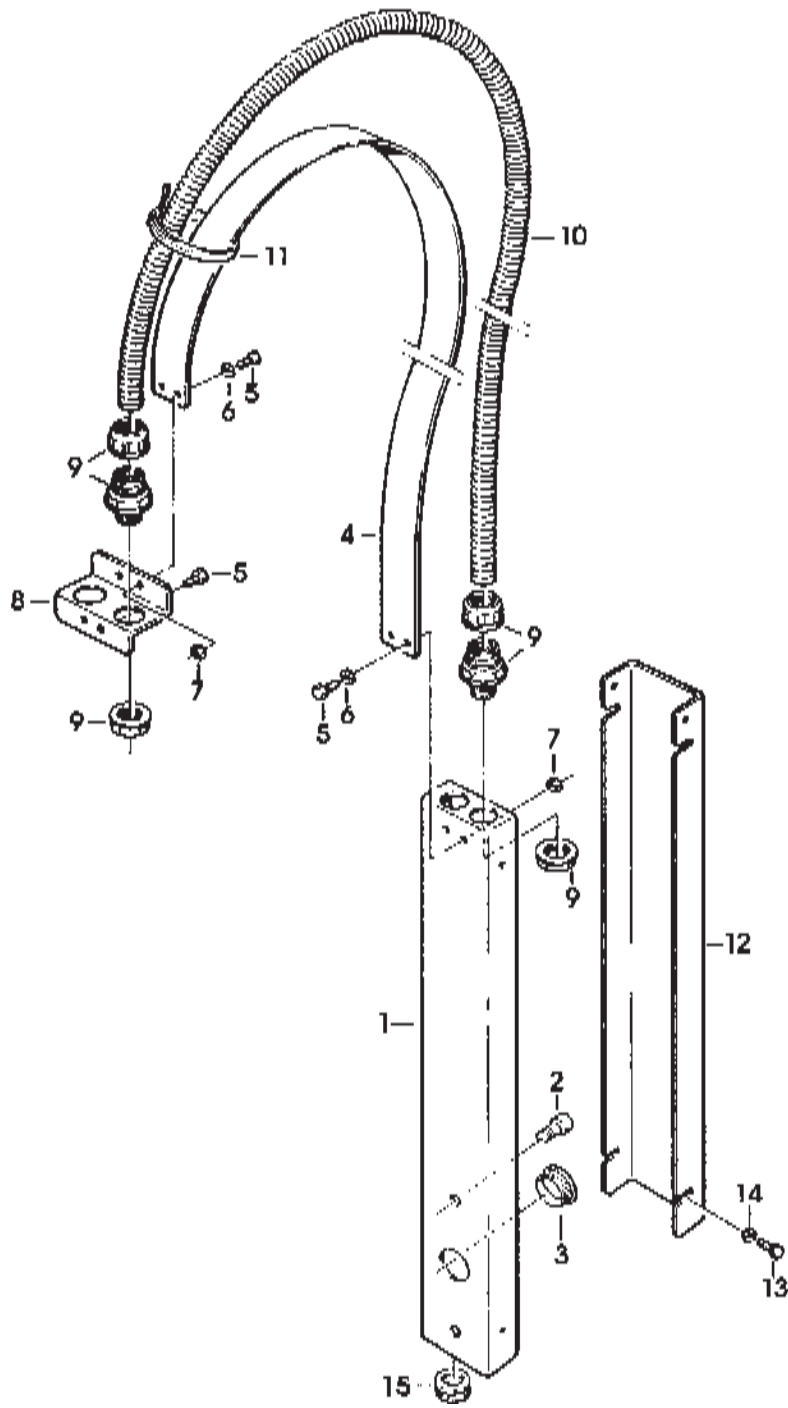


Figure 4896

Figure 4896

Ref. No.	3M Part No.	Description
4896-1	78-8091-0600-4	Housing – Wire
4896-2	26-1003-7963-0	Screw – Soc Hd, M8 x 16
4896-3	78-8094-6489-0	Snap Bushing – SB 1250-15
4896-4	78-8076-4636-5	Strap – Wire
4896-5	78-8010-7163-6	Screw – Hex Hd, M5 x 10
4896-6	78-8005-5741-1	Washer – Plain, M5
4896-7	78-8010-7417-6	Nut – Hex, M5
4896-8	78-8076-4873-4	Plate – Strap
4896-9	78-8076-4638-1	Union PG13.5 – Sleeve / 14
4896-10	78-8094-6445-2	Sleeve – /14, 980 MM
4896-11	78-8060-8029-3	Clamp – 140 x 3,5
4896-12	78-8076-5118-3	Cover – Channel
4896-13	26-1003-5810-5	Screw – Hex Hd, M4 x 8
4896-14	78-8017-9018-5	Washer – Plain, M4 SPEC.
4896-15	78-8060-7785-1	Fairlead – /22

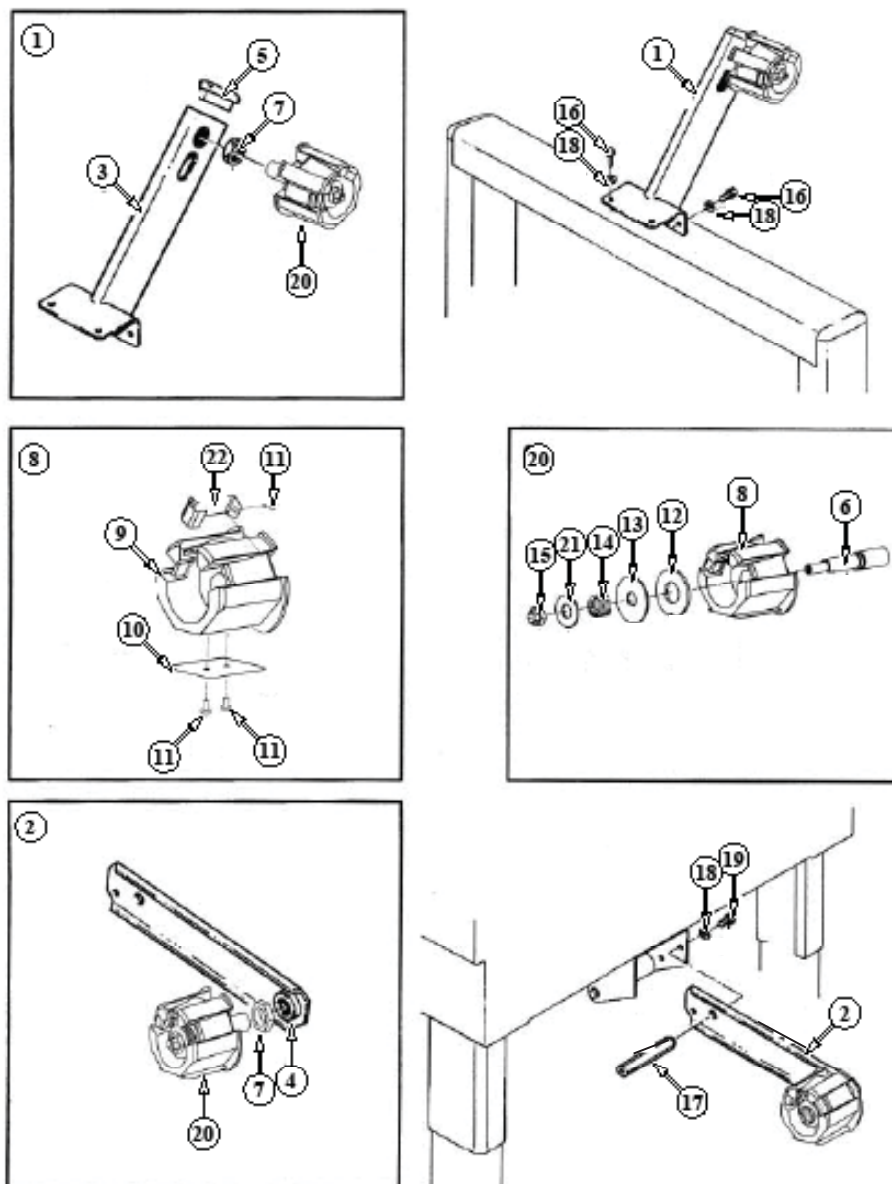


Figure 10440

Figure 10440

Ref. No.	3M Part No.	Description
10440-1	78-8076-4633-2	Tape Roll Bracket Assembly
10440-2	78-8070-1565-2	Tape Drum Bracket Assembly
10440-3	78-8070-1566-0	Bracket – Tape Drum
10440-4	78-8070-1395-4	Bracket – Bushing Assembly
10440-5	78-8070-1568-6	Cap – Bracket
10440-6	78-8076-4519-3	Shaft – Tape Drum
10440-7	78-8017-9169-6	Nut – M18 x 1
10440-8	78-8098-8827-0	Tape Drum Sub-Assembly - 2 Inch
10440-9	78-8098-8749-6	Tape Drum
10440-10	78-8098-8817-1	Leaf Spring
10440-11	26-1002-5753-9	Screw – Self Tapping
10440-12	78-8060-8172-1	Washer – Friction
10440-13	78-8052-6271-0	Washer – Tape Drum
10440-14	78-8100-1048-4	Spring – Core Holder
10440-15	78-8017-9077-1	Nut – Self Locking, M10 x 1
10440-16	78-8032-0375-7	Screw – Hex Hd, M6 x 16
10440-17	78-8070-1215-4	Spacer – Stud
10440-18	26-1000-0010-3	Washer – Flat, M6
10440-19	78-8010-7169-3	Screw – Hex Hd, M6 x 12
10440-20	78-8060-8474-1	Tape Drum Assembly – 2 Inch Head
10440-21	26-1004-5510-9	Washer - Plain, M10
10440-22	78-8098-8816-3	Latch - Tape Drum

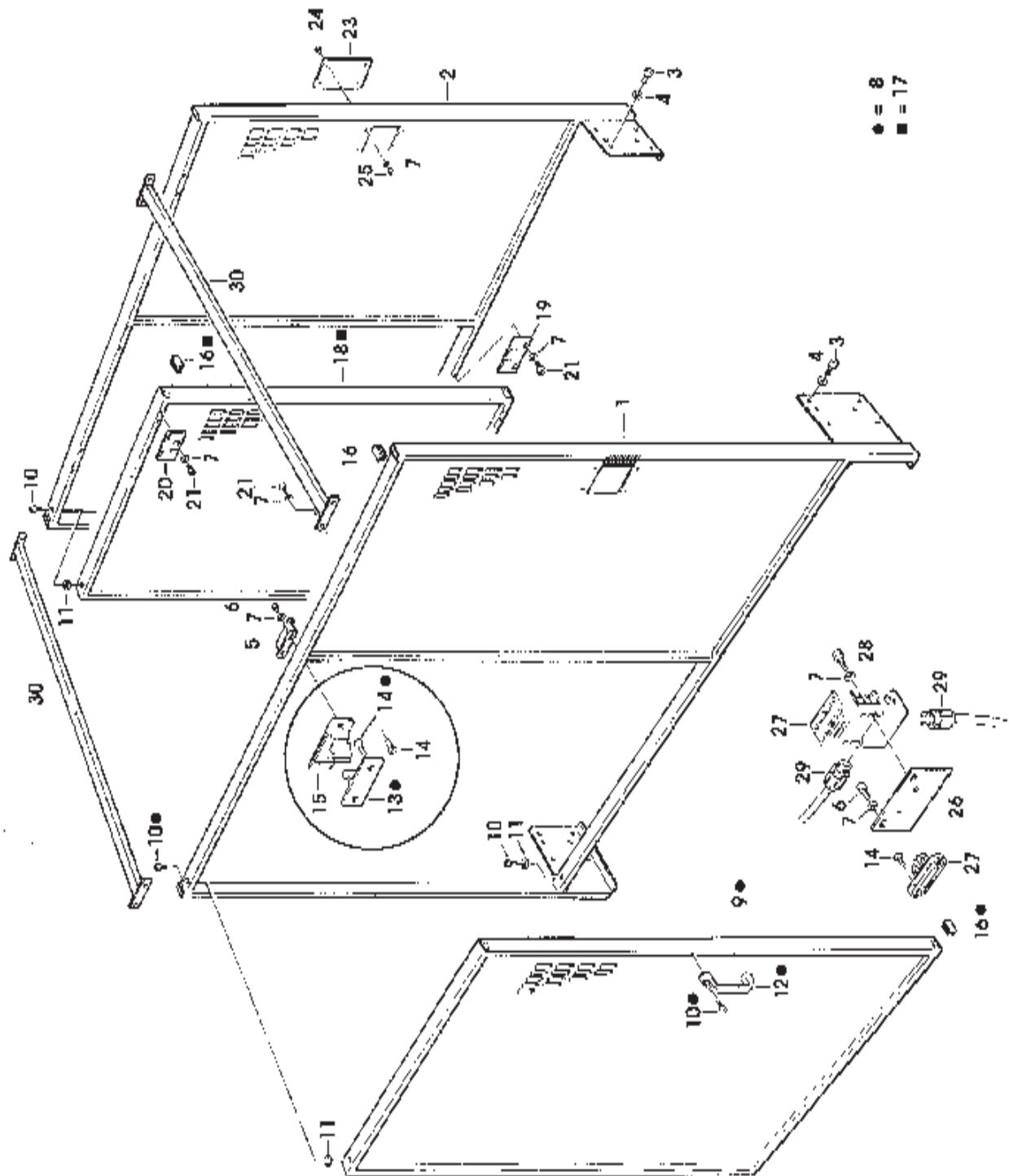


Figure 4900

Figure 4900

Ref. No.	3M Part No.	Description
4900-1	78-8113-6835-2	Guard Assembly – L/H, W/English Language Label
4900-2	78-8094-6460-1	Guard – R/H
4900-3	26-1003-7964-8	Screw – Soc Hd, Hex Hd, Soc Dr, M8 x 20
4900-4	78-8017-9318-9	Washer – Plain, 8 MM
4900-5	78-8094-6461-9	Bracket
4900-6	78-8032-0382-3	Screw – Soc Hex Hd, M5 x 16
4900-7	78-8005-5741-1	Washer – Plain, M5
4900-8	78-8094-6462-7	Door Assembly – L/H
4900-9	78-8094-6463-5	Door – L/H
4900-10	26-1003-7957-2	Screw – Soc Hd, Hex Hd, M6 x 16
4900-11	78-8094-6464-3	Spacer
4900-12	78-8060-7807-3	Handle
4900-13	78-8076-4931-0	Drawbar – Lock
4900-14	26-0001-5862-1	Screw – Flat Hd Soc , M5 x 12
4900-15	78-8076-4932-8	Lock – Wing
4900-16	78-8094-6195-3	Cap
4900-17	78-8094-6465-0	Door Assembly – R/H
4900-18	78-8094-6466-8	Door – R/H
4900-19	78-8094-6467-6	Plate – Lower
4900-20	78-8094-6468-4	Plate – Upper
4900-21	26-1003-7949-9	Screw – Soc Hd, Hex Soc, M5 x 12
4900-23	78-8094-6470-0	Plate
4900-24	78-8060-8087-1	Screw – M5 x 10
4900-25	78-8010-7417-6	Nut – Hex, M5
4900-26	78-8094-6471-8	Plate – Switch Mounting
4900-27	78-8114-5024-2	Security Switch – SK-U1ZM
4900-28	26-1003-7951-5	Screw – Soc Hd, Hex Soc, M5 x 20
4900-29	78-8076-4532-6	Union
4900-30	78-8094-6469-2	Cross Bar

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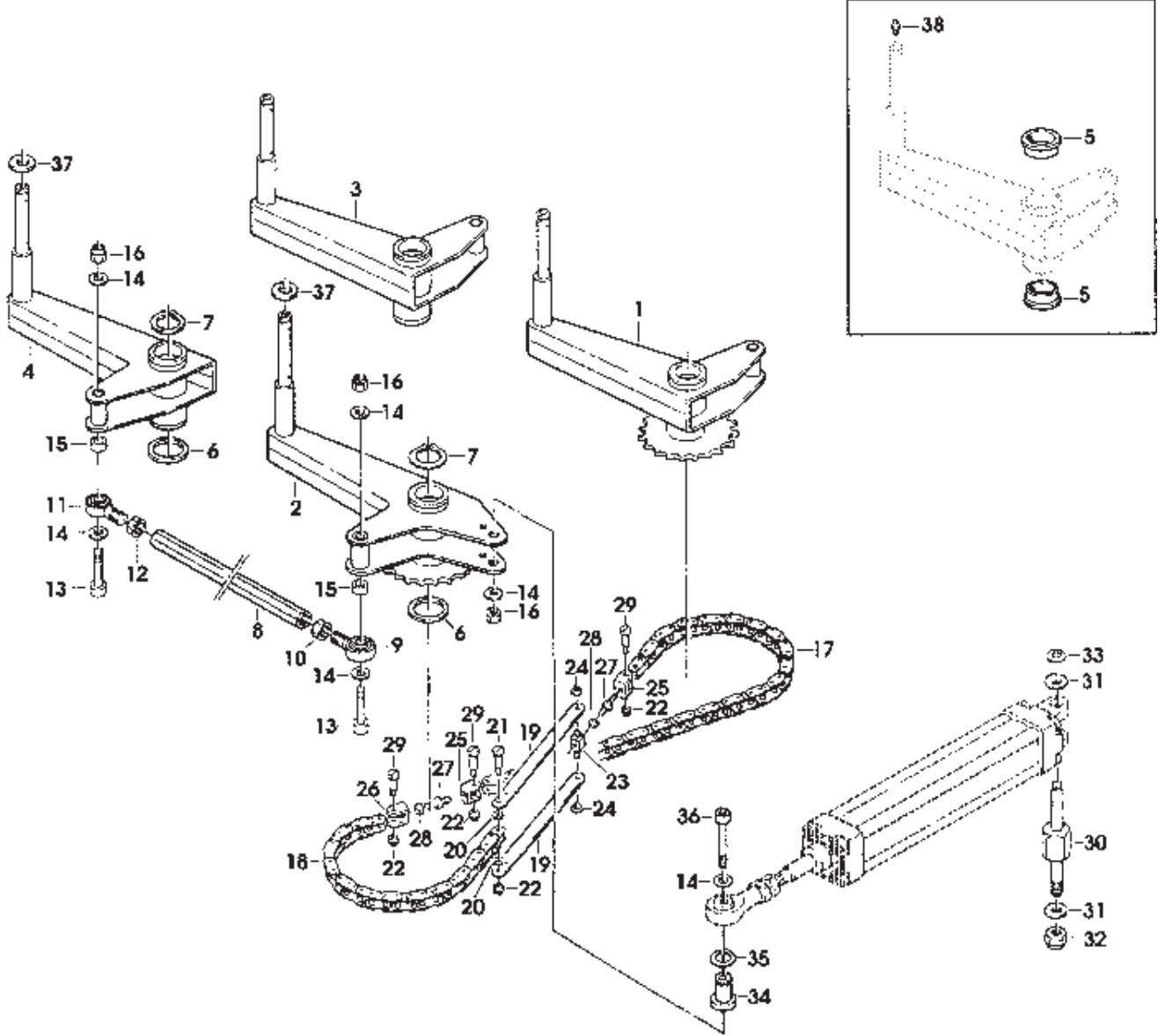


Figure 7005

Figure 7005

Ref. No.	3M Part No.	Description
7005-1	78-8114-4867-5	Arm Assembly – Front, Right
7005-2	78-8114-4868-3	Arm Assembly – Front, Left
7005-3	78-8114-4869-1	Arm Assembly – Rear Right
7005-4	78-8114-4870-9	Arm Assembly – Rear, Left
7005-5	78-8076-4791-8	Bushing
7005-6	78-8060-7534-3	Washer
7005-7	78-8060-7521-0	Lock Ring
7005-8	78-8094-6407-2	Rod
7005-9	78-8076-4793-4	Ball Joint – KA 10 D
7005-10	78-8060-7525-1	Nut – Right Flat, M10
7005-11	78-8076-4794-2	Ball Joint – KAL 10 D
7005-12	78-8060-7546-7	Nut – Left Flat, M10
7005-13	78-8076-4796-7	Screw – Soc Hd, M10 x 80
7005-14	78-8052-6566-3	Washer– Friction
7005-15	78-8076-4795-9	Spacer
7005-16	26-1003-6918-5	Nut – Plastic Insert, Hex Flange, M10
7005-17	78-8060-7518-6	Chain – 3/8 Inch, 60 Pitch Long
7005-18	78-8054-8777-0	Chain – 3/8 Inch Pitch, 41 Links Long
7005-19	78-8054-8787-9	Chain Link
7005-20	78-8054-8783-8	Washer – Special
7005-21	78-8060-7519-4	Screw – M3 x 25
7005-22	78-8059-5517-2	Nut – Self-Locking, M3
7005-23	78-8054-8784-6	Block – Chain
7005-24	78-8056-3945-3	E-Ring – M4
7005-25	78-8054-8786-1	Chain Connector
7005-26	78-8054-8788-7	Chain Connector
7005-27	78-8054-8785-3	Rod – Threaded Right/Left
7005-28	78-8010-7418-4	Nut – Hex, M6
7005-29	78-8060-7520-2	Screw - M3 x 20
7005-30	78-8060-7531-9	Stud – Cylinder
7005-31	78-8017-9059-9	Washer – Flat For M12 Screw
7005-32	78-8060-7532-7	Nut – Self-Locking
7005-33	78-8056-3965-1	E-Ring – M8
7005-34	78-8060-7538-4	Bushing – Cylinder
7005-35	78-8060-7533-5	Lock-Ring
7005-36	78-8060-7535-0	Screw – Soc Hd, Hex Soc
7005-37	78-8060-7541-8	Washer
7005-38	78-8114-4871-7	Grease Nipple

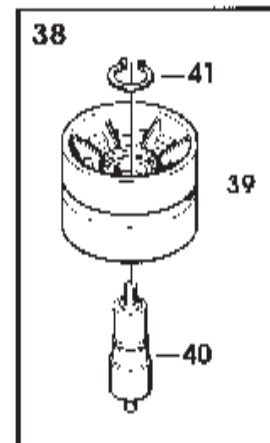
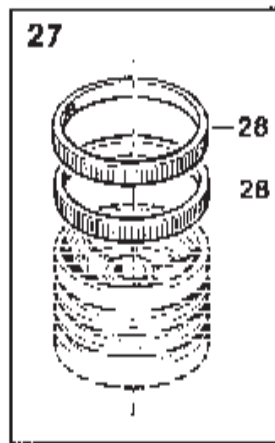
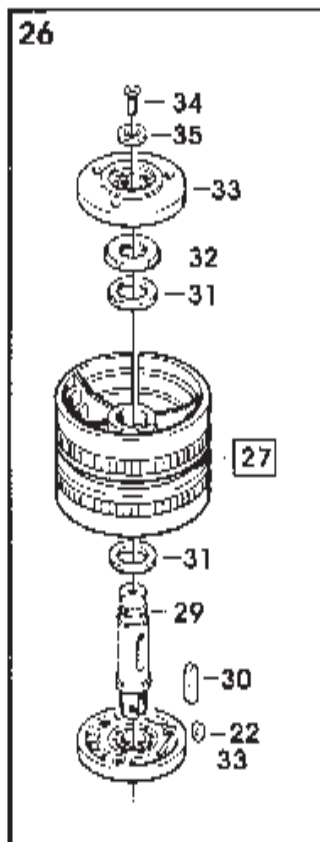
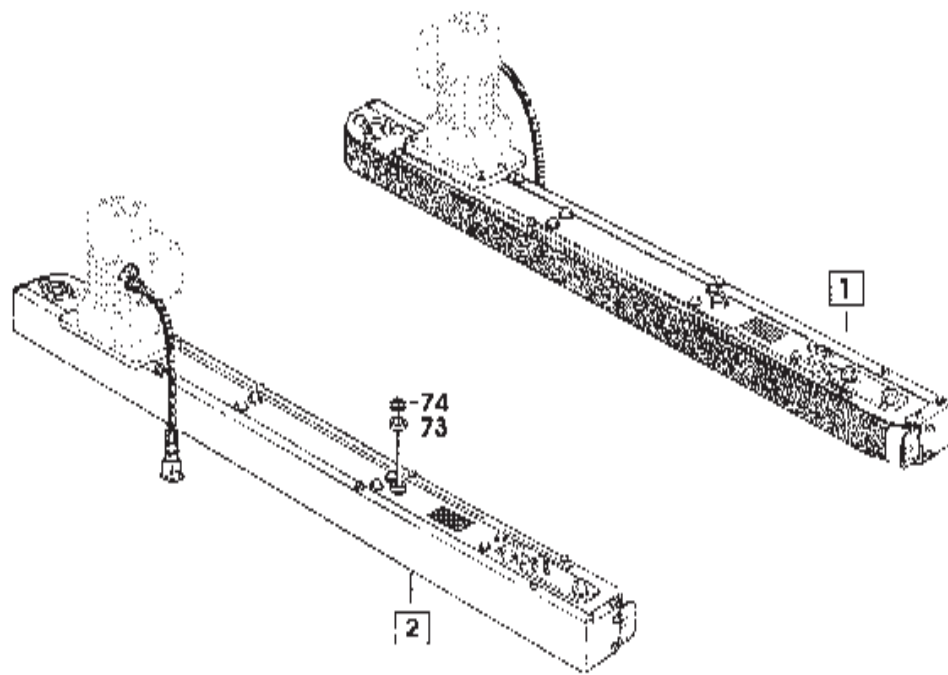


Figure 7006/1 of 2

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Ref. No.	3M Part No.	Description
7006-1	78-8114-4872-5	Side Drive – R/H, W/O Motor
7006-2	78-8114-4873-3	Side Drive – L/H, W/O Motor
7006-3	78-8114-4874-1	Guide – Lower, R/H
7006-4	78-8114-4875-8	Guide – Lower, L/H
7006-5	78-8113-6833-7	Guide – Upper, R/H
7006-6	78-8113-6834-5	Guide – Upper, L/H
7006-7	78-8114-4878-2	Bushing
7006-8	78-8060-7995-6	Pin – Roller
7006-9	78-8060-7996-4	Roller
7006-10	78-8094-6424-7	Plate – Lower, R/H
7006-11	78-8094-6425-4	Plate – Lower, L/H
7006-12	78-8094-6426-2	Plate – Upper, R/H
7006-13	78-8094-6427-0	Plate – Upper, L/H
7006-14	78-8076-5255-3	Screw – Phillips Dr, M4 x 12
7006-15	78-8005-5740-3	Washer – Plain, 4 MM
7006-16	78-8076-4855-1	Washer – Special, /4.5-9X1.5
7006-17	78-8054-8910-7	Spacer – Hexagonal
7006-18	26-1003-5829-5	Screw – Hex Hd, M6 x 12
7006-19	26-1000-0010-3	Washer – Flat, M6
7006-20	78-8076-5439-3	Flange Assembly
7006-21	78-8091-0757-2	Extension – Gearmotor
7006-22	78-8046-8135-7	Key – 5 x 5, 12MM
7006-23	78-8091-0758-0	Sprocket – 3/8 Inch, Z=14
7006-24	78-8057-5834-5	Tab Washer
7006-25	78-8057-5835-2	Centering Washer
7006-26	78-8076-4862-7	Pulley – Drive
7006-27	78-8076-5105-0	Pulley Assembly – Drive
7006-28	78-8052-6713-1	Ring – Polyurethane
7006-29	78-8054-8878-6	Shaft – Pulley Keyed
7006-30	78-8057-5739-6	Key – M5 x 5 x 30MM
7006-31	78-8054-8879-4	Washer – /20, 5MM
7006-32	78-8017-9096-1	Nut – Special, M18 x 1
7006-33	78-8076-5442-7	Flange Assembly
7006-34	26-0001-5862-1	Screw – Flat Hd Soc, M5 x 12
7006-35	78-8054-8877-8	Washer – 5,5/20X4
7006-36	78-8090-0759-0	Sprocket – 3/8 Inch, Z=23
7006-37	78-8076-4933-6	Chain – 3/8 Inch Pitch, 52 Pitch

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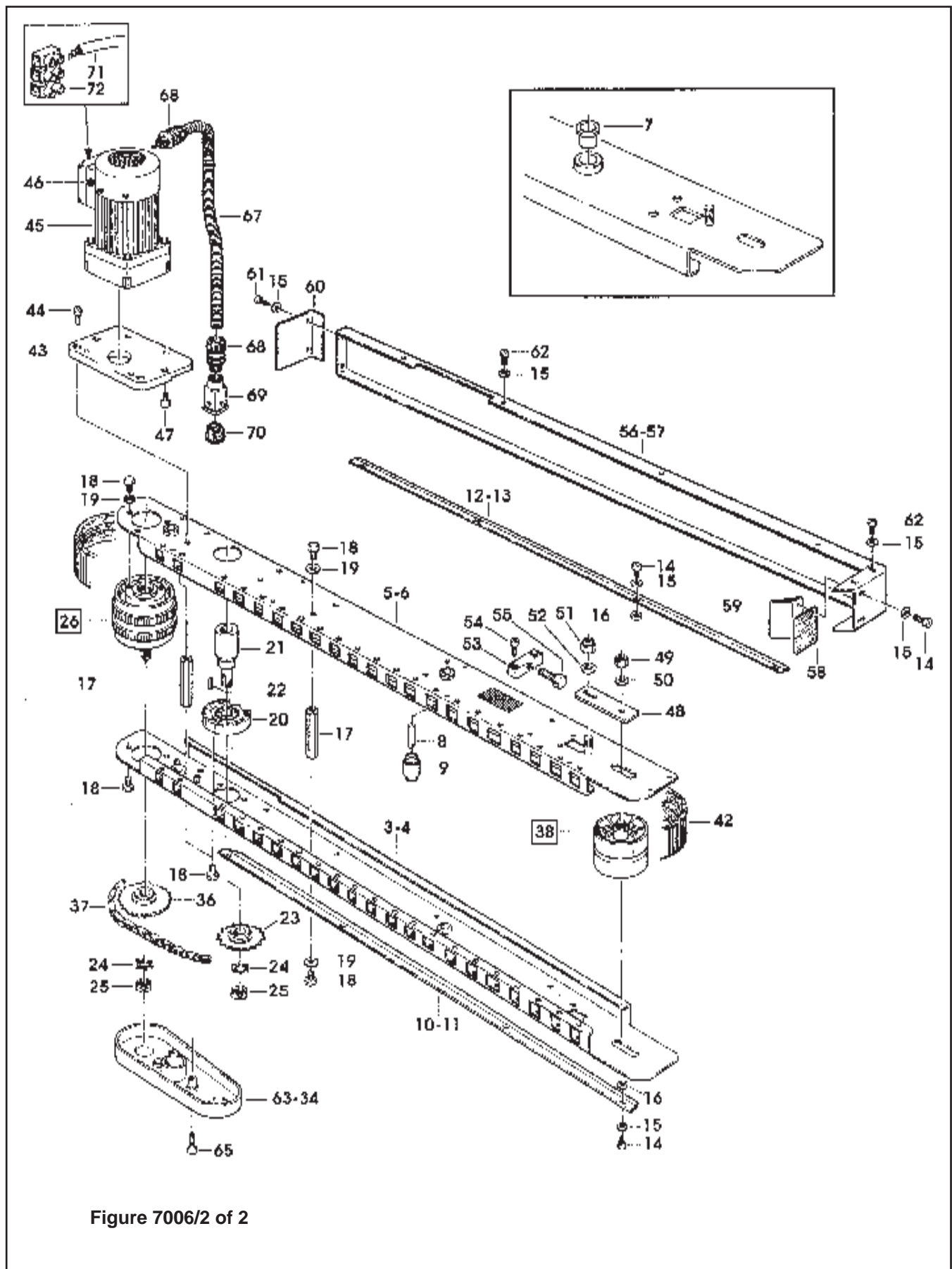


Figure 7006/2 of 2

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Ref. No.	3M Part No.	Description
7006-38	78-8060-8014-5	Idler Roller Assembly
7006-39	78-8052-6710-7	Roller – Idler
7006-40	78-8054-8913-1	Shaft – Roller
7006-41	12-7997-0272-0	E-Ring – M25
7006-42	78-8094-6447-8	Belt – Drive
7006-43	78-8094-6109-4	Support – Gearmotor
7006-44	78-8010-7210-5	Screw – Soc Hd, Hex Soc, M6 x 20
7006-45	78-8070-1522-3	Gearmotor – 115V, 60HZ
7006-46	26-1011-8828-7	Capacitor – 115V Gearmotor
7006-47	78-8070-1523-1	Screw – 1/4-28X1/2 SHCS
7006-48	78-8076-4864-3	Plate – Belt Tensioning
7006-49	26-1003-6904-5	Nut – M8
7006-50	78-8017-9318-9	Washer – Plain, 8MM
7006-51	26-1003-6918-5	Nut – Plastic Insert, Hex, M10
7006-52	78-8052-6566-3	Washer – Friction
7006-53	78-8054-8903-2	Block – Belt
7006-54	78-8010-7210-5	Screw – Soc Hd, Hex Soc, M6 x 20
7006-55	78-8054-8904-0	Screw – Belt Adjustment
7006-56	78-8114-4879-0	Cover – R/H
7006-57	78-8114-4880-8	Cover – L/H
7006-58	78-8114-4881-6	Guard – Drive
7006-59	78-8114-4882-4	Cover
7006-60	78-8114-4787-5	Guard – Belt
7006-61	26-1002-4955-1	Screw – Self-Tap, 8PX13
7006-62	26-1002-5753-9	Screw – Self-Tapping
7006-63	78-8091-0764-8	Cover – Chain, Right
7006-64	78-8091-0765-5	Cover – Chain, Left
7006-65	78-8010-7165-1	Screw – Flat Hd, Soc, M5 x 25
7006-67	78-8076-4871-8	Sleeving
7006-68	78-8060-7626-7	Connector
7006-69	78-8060-7877-6	Plug – Housing, Vertical
7006-70	78-8060-7875-0	Plug – Male
7006-71	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
7006-72	78-8076-4968-2	Terminal
7006-73	78-8060-7541-8	Washer
7006-74	78-8060-7533-5	Lock Ring

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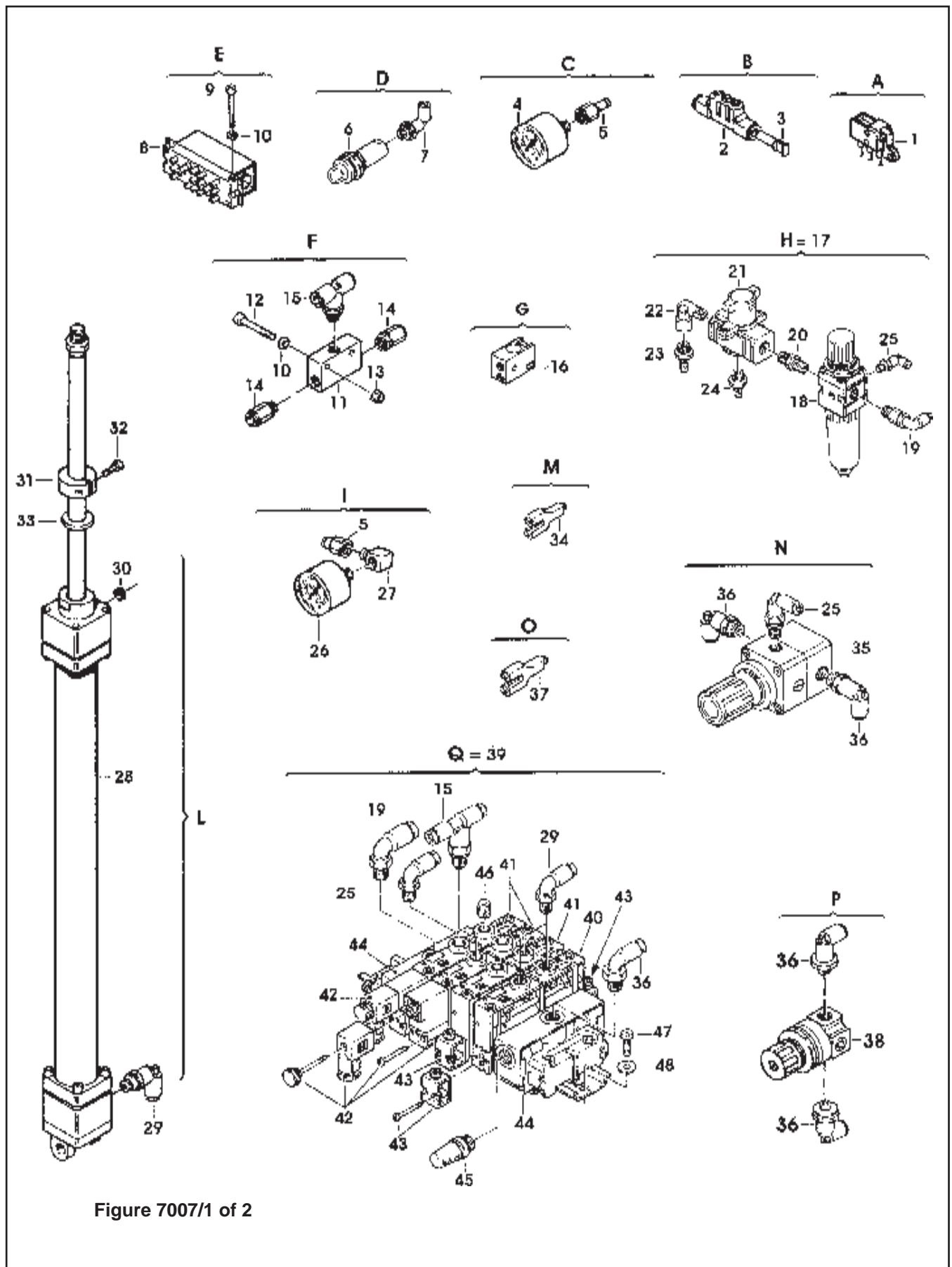


Figure 7007/1 of 2

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Ref. No.	3M Part No.	Description
7007-1	78-8060-8091-3	Valve – FESTO R/O-3-PK-3
7007-2	78-8094-6448-6	Union – TE 33040604
7007-3	78-8114-4883-2	Cap
7007-4	78-8076-4671-2	Gauge – Pressure
7007-5	78-8076-4672-0	Union – Straight, Female
7007-6	78-8076-4665-4	Indicator – Visual
7007-7	78-8076-4888-2	Elbow
7007-8	78-8060-7656-4	Valve – One-Shot, FESTO VLK-3-PK-3
7007-9	78-8060-7711-7	Screw – Soc Hd, Hex Soc, M4 x 30
7007-10	78-8005-5740-3	Washer – Plain, 4 MM
7007-11	26-1005-6904-0	Valve – OR Aerpress VCS8
7007-12	26-1003-7946-5	Screw – Soc Hd, M4 x 25
7007-13	26-1003-6914-4	Nut – Plastic Insert, M4
7007-14	26-1005-6910-7	Union – Straight
7007-15	78-8060-8183-8	Union – Rotating
7007-16	78-8094-6451-0	Valve – Selector, Parker PLK-A11
7007-17	78-8114-4884-0	Filter/Regulator Assembly
7007-18	26-1014-4558-8	Filter/Regulator – W/Metal Bowl, SMC EAW2000-FO2D-2
7007-19	78-8091-0315-9	Elbow
7007-20	78-8060-7899-0	Nipple – 1/4 Inch
7007-21	78-8091-0715-0	Valve – SMC EVHS-4500 FO2-X116
7007-22	78-8060-7900-6	Union
7007-23	26-1005-6897-6	Hose Connector
7007-24	78-8114-4885-7	Muffler
7007-25	26-1005-5909-0	Elbow
7007-26	78-8054-8838-0	Gauge – Air
7007-27	78-8091-0638-4	Elbow

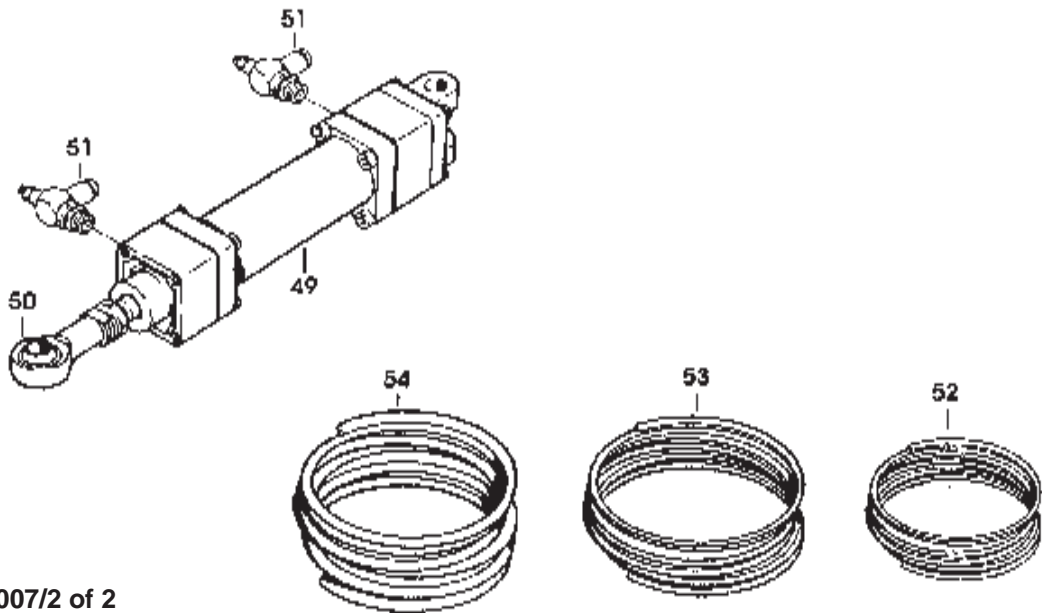
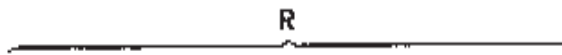
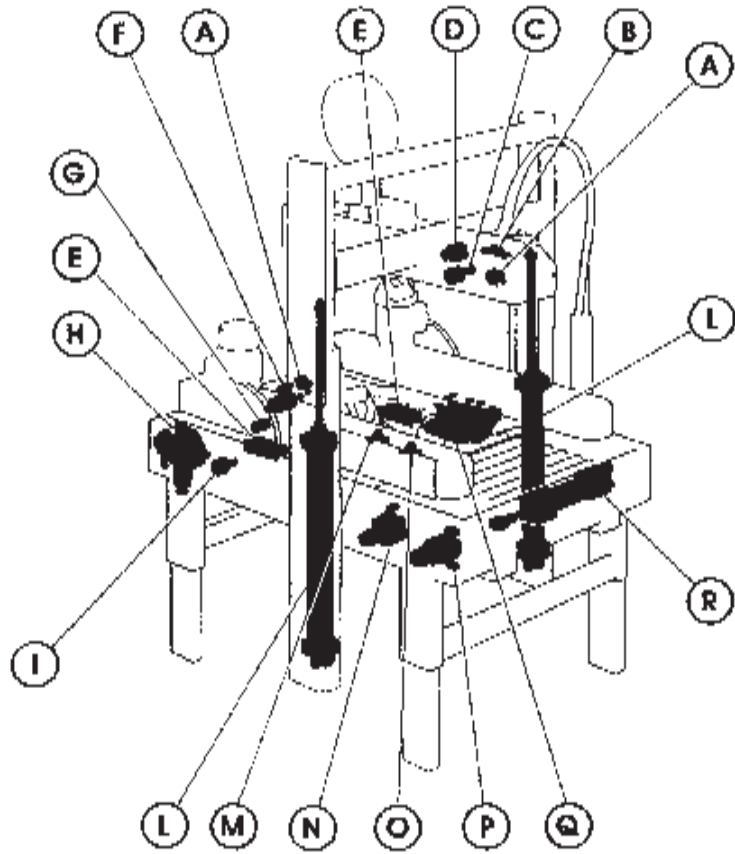


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Ref. No.	3M Part No.	Description
7007-28	78-8054-8827-3	Cylinder – Air, C65D32-440CY01
7007-29	26-1005-6893-5	90 Degree Elbow
7007-30	78-8094-6457-7	Cap – 1/8 Inch
7007-31	78-8100-1153-2	Collar – Height Locking
7007-32	78-8010-7210-5	Screw – Soc Hd Hex Soc, M6 x 20
7007-33	78-8100-1154-0	Washer
7007-34	78-8076-4664-7	Union – Female
7007-35	78-8094-6458-5	Reducer
7007-36	78-8055-0756-9	Union – Rotating
7007-37	78-8094-6079-9	Union – Y, Female
7007-38	78-8076-4675-3	Regulator – 0.5-7 Bar, SMC EAR111-F02
7007-39	78-8114-4886-5	Valve Assembly
7007-40	78-8114-4887-3	Distributor – SMC PVL-B122618
7007-41	78-8114-4888-1	Distributor – SCM PVL B121618
7007-42	78-8094-6456-9	Actuator – SMC PVA H2491F, 100/115V, 50/50 HZ
7007-43	78-8094-6450-2	Connector – SMC PVA-P111
7007-44	78-8114-4889-9	Feeding End – SMC PVL-B1729
7007-45	78-8076-4886-6	Muffler – 1/4 Inch
7007-46	78-8060-7690-3	Cap
7007-47	78-8094-6145-8	Screw – Phillis, M5 x 12
7007-48	78-8028-8214-8	Washer
7007-49	78-8100-0757-1	Cylinder – SCM C95SDB50-95+20
7007-50	78-8060-7539-2	Head Joint
7007-51	78-8091-0510-5	Regulator – Speed
7007-52	78-8119-8666-6	Tube – Air, 4 mm O.D. x 2.5 mm I.D.
7007-53	78-8119-8667-4	Tube – Air, 6 mm O.D. x 4 mm I.D.
7007-54	78-8119-8668-2	Tube – Air, 8 mm O.D. x 5 mm I.D.
7007-00	78-8060-8175-4	Seal Kit – Cylinder, Megliani/32
7007-00	78-8100-0758-9	Seal Kit – Cylinder, SMC /32
7007-00	78-8100-0759-7	Seal Kit – Cylinder, SMC /50

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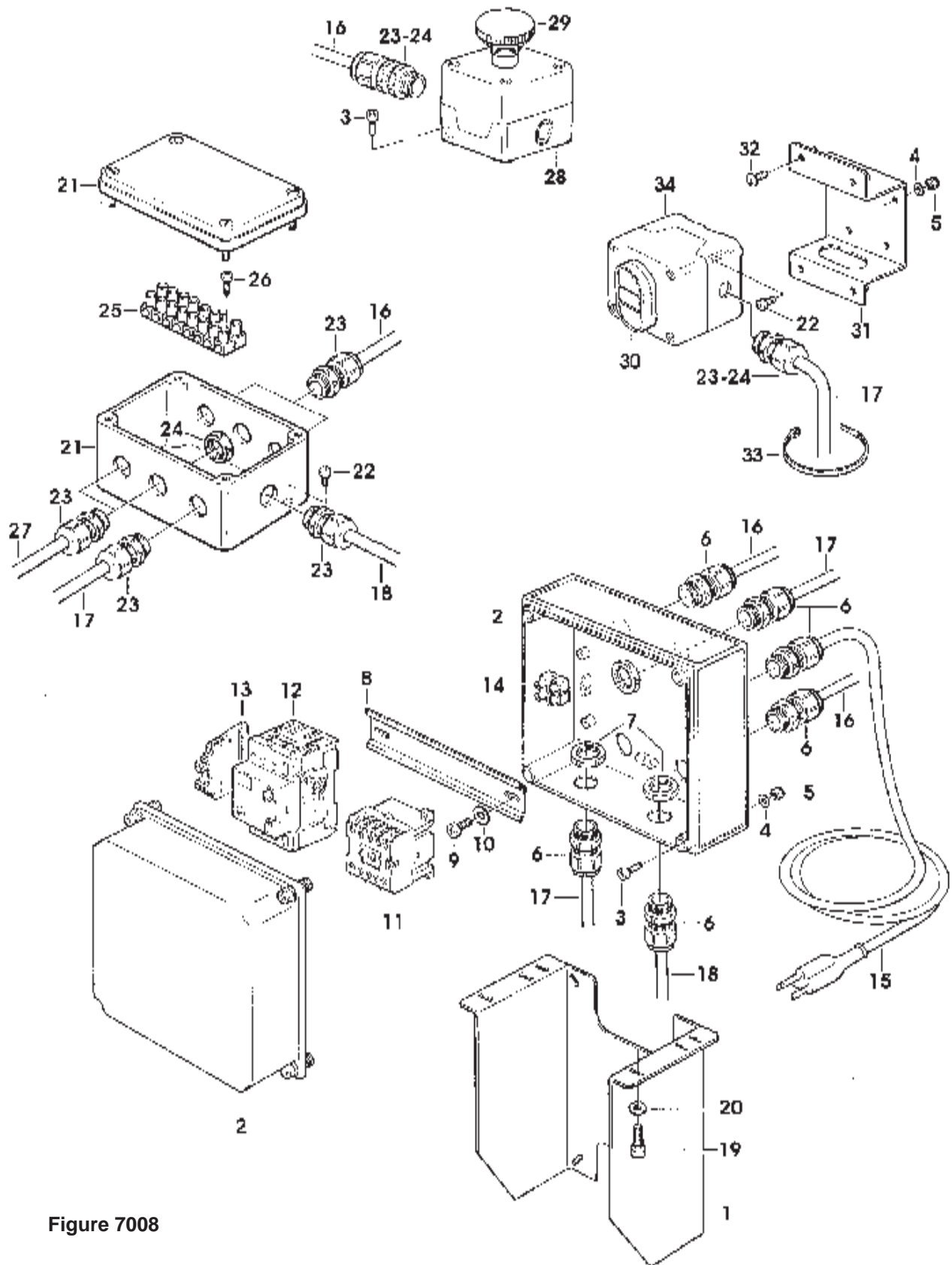


Figure 7008

Figure 7008

Ref. No.	3M Part No.	Description
7008-1	78-8094-6379-3	Support Box
7008-2	78-8094-6380-1	Box
7008-3	78-8094-6381-9	Screw – Soc Hd, Hex Hd, M4 x 15
7008-4	78-8005-5740-3	Washer – Plain, 4 MM
7008-5	26-1003-6914-4	Nut – Plastic Insert, M4
7008-6	78-8076-4715-7	Cord Grip
7008-7	78-8076-5211-6	Nut
7008-8	78-8094-6382-7	Guide – Mounting
7008-9	78-8028-8208-0	Screw – 6PX9,5
7008-10	78-8017-9018-5	Washer – Plain, M4
7008-11	78-8094-6383-5	Contactactor – CA4-5-10, 110V, 60HZ
7008-12	78-8076-5378-3	Switch – Thermal, KTA-3-25
7008-13	78-8094-6384-3	Clamp – VGPE 4/6
7008-14	78-8076-4882-5	Terminal Board
7008-15	78-8028-7909-4	Power Cord W/Plug
7008-16	78-8114-4821-2	Cable – CAVO, 4 x 20, AWG UL/CSA
7008-17	78-8100-1038-5	Cable – CAVO, 3X20, AWG-MT.5
7008-18	78-8094-6223-3	Cable – CAVO, SJTO, 16/4 (5M)
7008-19	78-8010-7210-5	Screw – Soc Hd, Hex Soc, M6 x 20
7008-20	26-1000-0010-3	Washer – Flat, M6
7008-21	78-8076-4881-7	Pull Box
7008-22	78-8017-9257-9	Screw – Phillips Hd, M4 x 10
7008-23	78-8076-4532-6	Cord Grip
7008-24	78-8076-4645-6	Lock Nut – GMP11
7008-25	78-8076-4968-2	Terminal
7008-26	78-8091-0434-8	Screw – Self-Tapping, 4.2X19
7008-27	78-8060-8053-3	Wire – 3-Pole, 5M Long
7008-28	78-8076-5194-4	Box – E-Stop, Yellow
7008-29	26-1014-5845-8	E-Stop – 800EM-MTS44-3LX01
7008-30	78-8094-6386-8	Switch – On/Off, DM3N-C-01/10, Allen Bradley
7008-31	78-8094-6387-6	Support – Switch
7008-32	78-8060-8087-1	Screw – M5 x 10
7008-33	78-8060-8029-3	Clamp – 140X3,5
7008-34	78-8114-4896-4	Box – On/Off, Grey

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