



Instructions and Parts List

3M-Matic™

700a-s Type 10500

Adjustable

Case Sealer

with

AccuGlide™ SST

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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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:

3M-Matic™ Helpline – 1-800/328 1390. Please provide the customer support coordinator with the machine number, machine type/model and serial number. If you have a technical question that does not require an immediate response, you may Fax it to 651-736-7282.

Replacement Parts and Additional Manuals

Order parts by part number, part description and quantity required. Also, when ordering parts and/or additional manuals, include machine name, number and type. A parts order form is provided at the back of this manual.

3M/Tape Dispenser Parts

241 Venture Drive

Amery, WI 54001-1325

1-800/344 9883

FAX# 715/268 8153

Minimum billing on parts orders will be \$25.00. Replacement part prices available on request.

\$10.00 restocking charge per invoice on returned parts.

Note : Outside the U.S., contact the local 3M subsidiary for parts ordering information.



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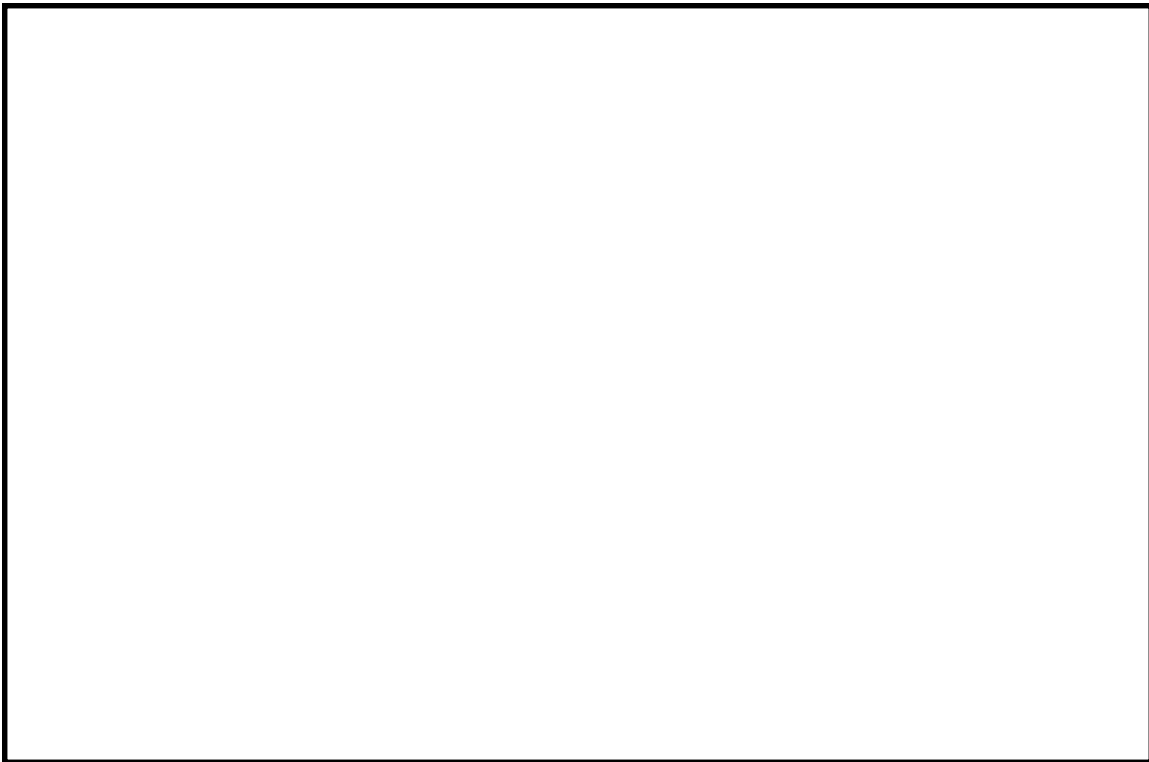
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To Our Customers:

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 and/or additional manuals, include machine name, number and type.

3M

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

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Instruction Manual

700a-s Stainless Steel, Adjustable Case Sealer, Type 10500

This instruction manual is divided into two sections as follows:

- Section I** Includes all information related to installation, operation and parts for the case sealer.
- Section II** Includes specific information regarding the AccuGlide™ SST 2 Inch Taping Heads.

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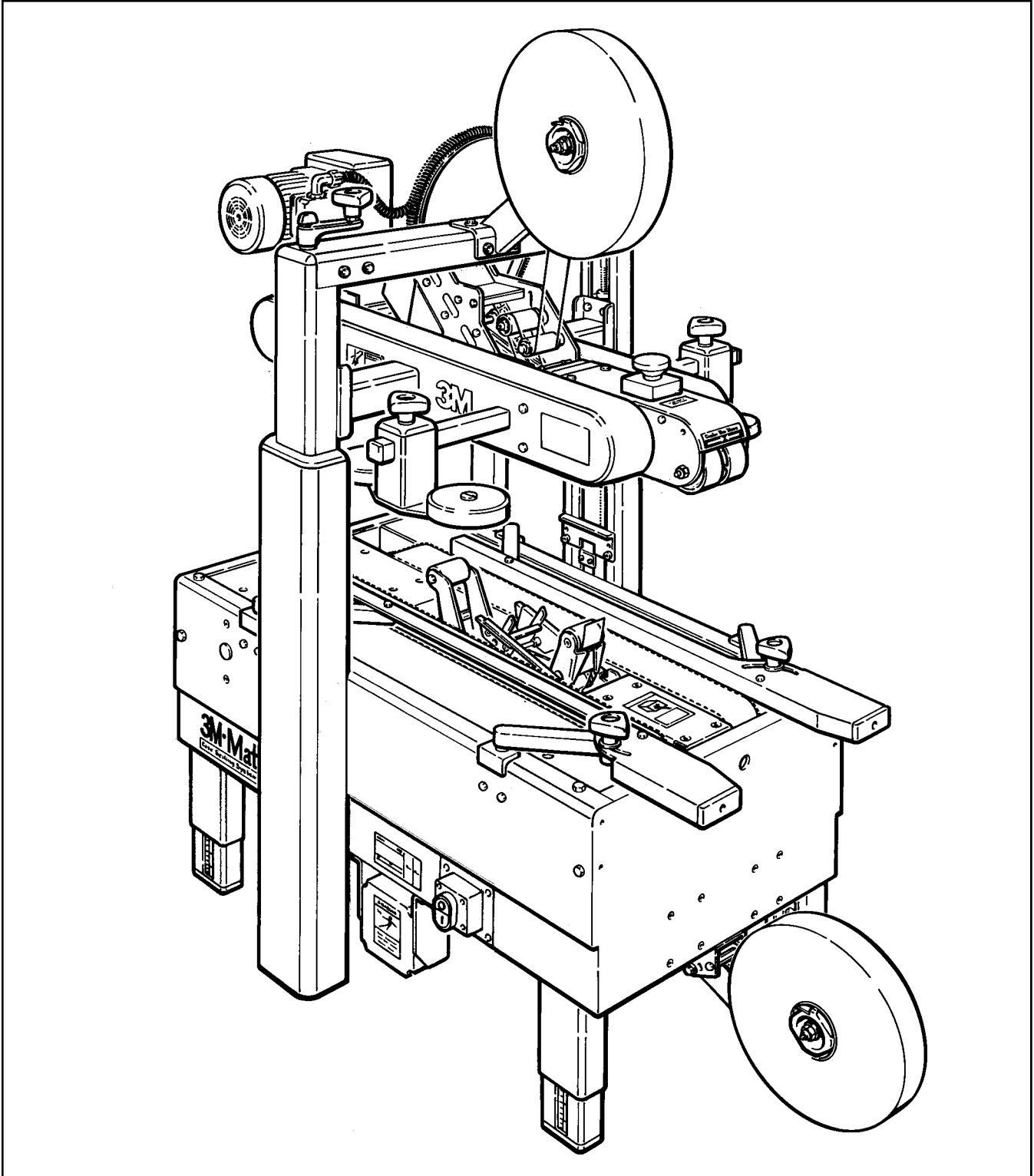
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Section II – AccuGlide™ SST 2 Inch Taping Heads

(See Section II for Table of Contents)

Intended Use

The **3M-Matic™ 700a-s Stainless Steel Adjustable Case Sealer with AccuGlide™ SST Taping Heads** is designed to apply a “C” clip of **Scotch®** pressure-sensitive film box sealing tape to the top and bottom center seam of regular slotted containers. The 700a-s is manually adjustable to a wide range of box sizes (see "Specifications Section – Box Weight and Size Capacities").



3M-Matic™ 700a-s Stainless Steel Adjustable Case Sealer, Type 10500

Note – Lower tape supply roll and bracket assembly are shown in the alternate location.

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

3M sells its **3M-Matic™ 700a-s Adjustable Case Sealer, Type 10500** with the following warranties:

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

If any part is proved to be defective within its warranty period, then the exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to repair or replace the part, provided the defective part is returned immediately to 3M's factory or an authorized service station designated by 3M. A part will be presumed to have become defective after its warranty period unless the part is received or 3M is notified of the problem no later than five (5) calendar days after the warranty period. If 3M is unable to repair or replace the part within a reasonable time, then 3M at its option, will replace the equipment or refund the purchase price. 3M shall have no obligation to provide or pay for the labor required to install the repaired or replacement part. 3M shall have no obligation to repair or replace (1) those parts failing due to operator misuse, carelessness, or due to any accidental cause other than equipment failure, or (2) parts failing due to non-lubrication, inadequate cleaning, improper operating environment, improper utilities or operator error.


Limitation of Liability: 3M and seller shall not be liable for direct, indirect, special, incidental or consequential damages based upon breach of warranty, breach of contract, negligence, strict liability or any other legal theory.

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


Contents – 700a-s Stainless Steel Adjustable Case Sealer


- (1) 700a-s Stainless Steel Adjustable Case Sealer, Type 10500
- (1) Upper Assembly Height Adjustment Crank/Hardware
- (1) Upper Tape Drum/Bracket/Hardware
- (2) Column Stop Bracket/Hardware
- (1) Tool/Spare Parts Kit
- (1) Instruction and Parts Manual

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 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 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 taping heads that are moderately heavy or may be considered awkward to lift

CAUTION

- **To reduce the risk associated with pinch and entanglement hazards:**
 - Keep hands clear of the upper head support assembly as boxes are transported through the machine
 - Keep hands, hair, loose clothing and jewelry away from box compression rollers
 - 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

Important Safeguards (Continued)

Important – In the event the following safety labels are damaged or destroyed, **they must be replaced to ensure operator safety**. Replacement part numbers for individual labels are shown in Figures 1-1 and 1-2, or a label kit, part number 78-8098-9175-3, is available that includes all labels used on the machine.

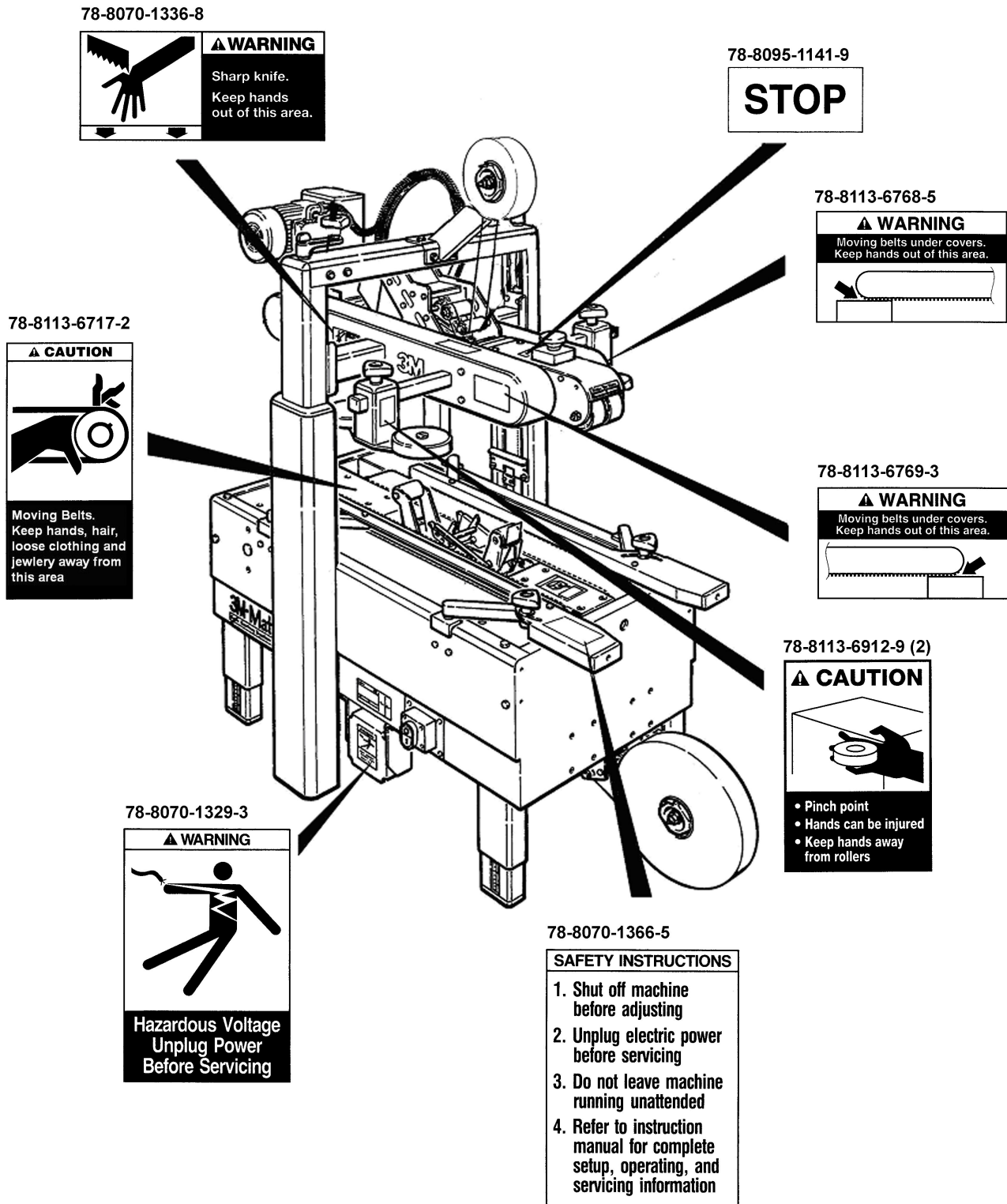


Figure 1-1 – Replacement Labels/3M Part Numbers

Important Safeguards (Continued)

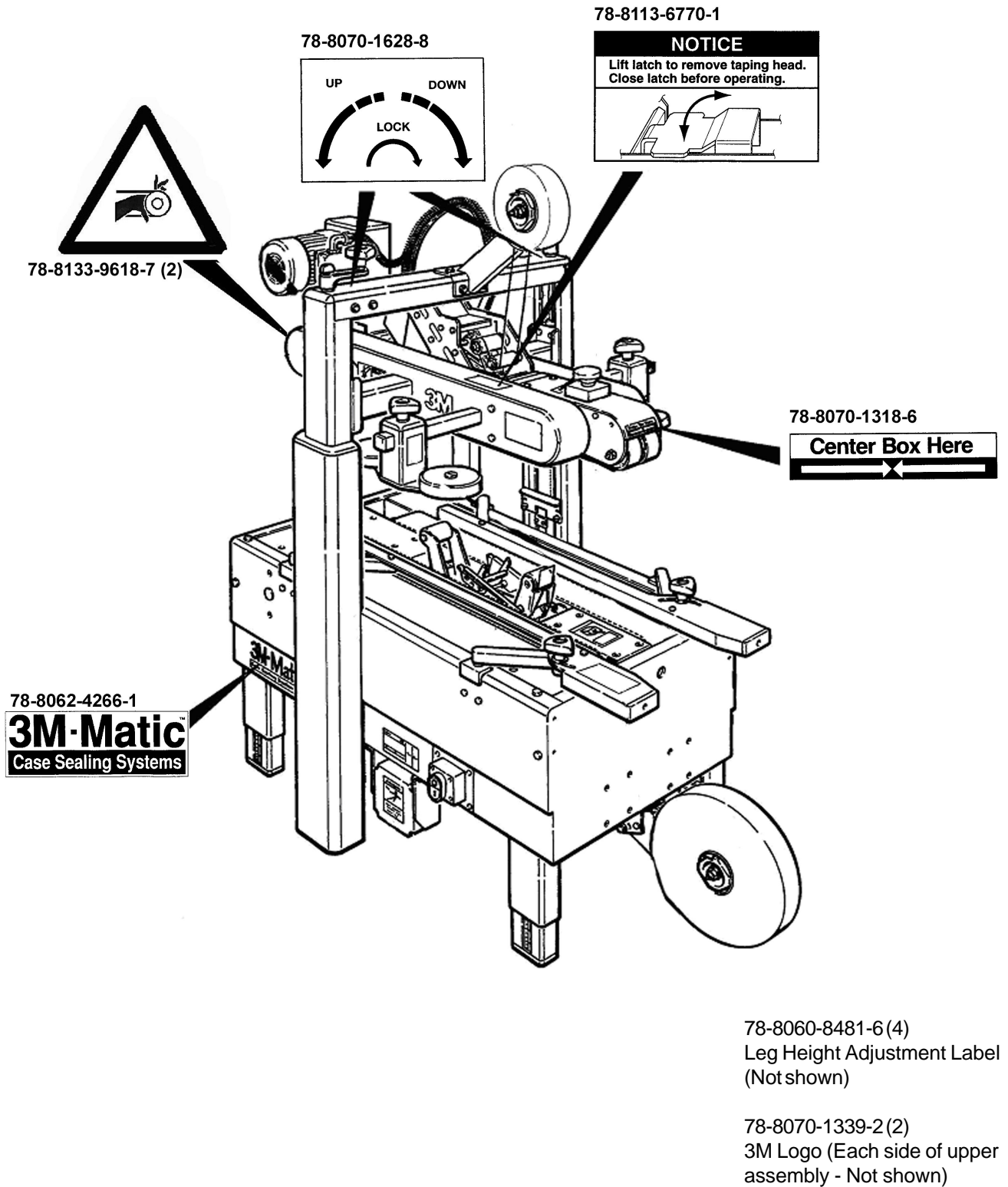


Figure 1-2 – Replacement Labels/3M Part Numbers

Important Safeguards (Continued)



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

Operator Skill Level Descriptions

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. N.B.: the factory manager must ensure that the operator has been properly trained on all the machine functions before starting work.

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, to check and adjust mechanical parts, to carry out maintenance operations and repair the machine. 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, to make adjustments, to carry out maintenance operations and repair the electrical components of the machine. 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, when agreed with the customer.

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

Operation	State of the Machine	Operator's Skill	Number of Operators
Installation and set up of the machine.	Running with safety protections disabled.	2 and 2a	2
Adjustment of the box size.	Stopped by pressing the EMERGENCY STOP button.	1	1
Tape replacement.	Stopped by pressing the EMERGENCY STOP button.	1	1
Replacement of blades.	Electric power disconnected.	2	1
Replacement of drive belts.	Electric power disconnected.	2	1
Ordinary maintenance.	Electric power disconnected.	2	1
Extraordinary maintenance (mechanical).	Running with safety protections disabled.	3	1
Extraordinary maintenance (electrical).	Running with safety protections disabled.	2a	1

Specifications

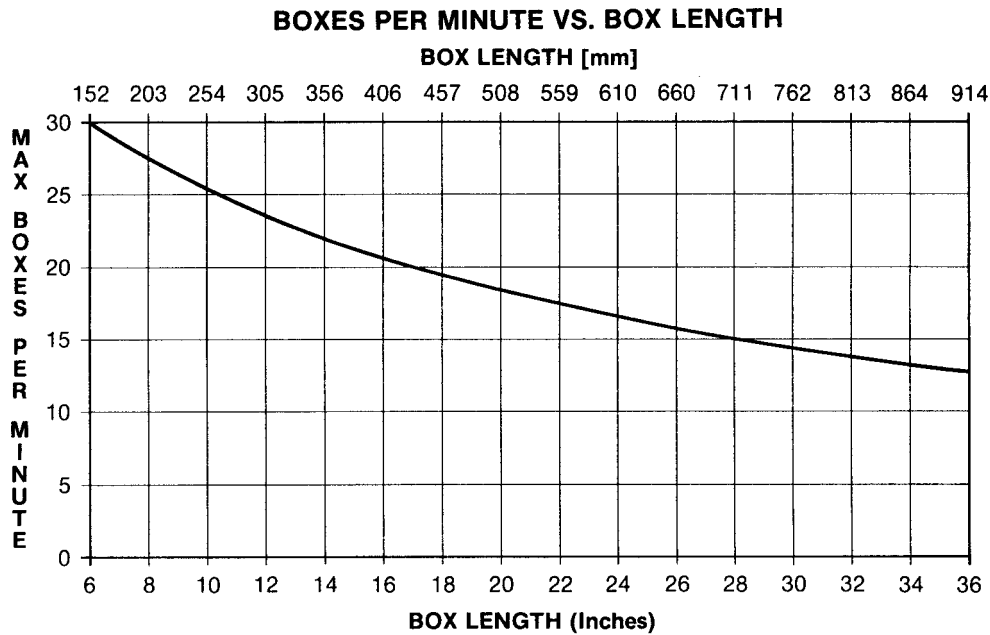
1. Power Requirements:

Electrical - 115 VAC, 60 Hz, 5.6 A

The machine is equipped with a 2.4 m [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 0.4 m/s [78 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 a relatively clean environment at 5° to 40° C [40° to 105° F] with clean, dry boxes.

Important: Machine should not be washed down.

 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/explosive environments

4. Tape:

Scotch® pressure-sensitive film box sealing tapes.

5. Tape Width:

36 mm [1 1/2 inch] minimum to 48 mm [2 inch] maximum

(Specifications continued on next page.)

Specifications (Continued)

6. Tape Roll Diameter:

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

7. Tape Application Leg Length – Standard:

70 mm ± 6 mm [2.75 inch ±.25 inch]

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.

9. Box Weight and Size Capacities:

A. Box Weight, filled – up to 38.6 kg [85 lbs.] maximum. Contents must support flaps.

B. Box Size:	Minimum	Maximum
Length –	150 mm [6.0 inch]	Unlimited
Width –	150 mm [6.0 inch]*	550 mm [21.5 inch]
Height –	120 mm [4.75 inch]**	620 mm [24.5 inch] **

* Cartons narrower than 250 mm [10 inch] in width may require more frequent belt replacement because of limited contact area.

** 165 mm [6.5 inch] minimum to 725 mm [28.5 inch] maximum height with columns adjusted to upper position. (See "Special Set-Up Procedure – Box and Machine Bed Height Range".)

**Special modifications may be available for carton sizes not listed above.
Contact your 3M Representative for information.**

Note: *The case sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is .5 or less, then several boxes should be test run to assure proper machine performance.*

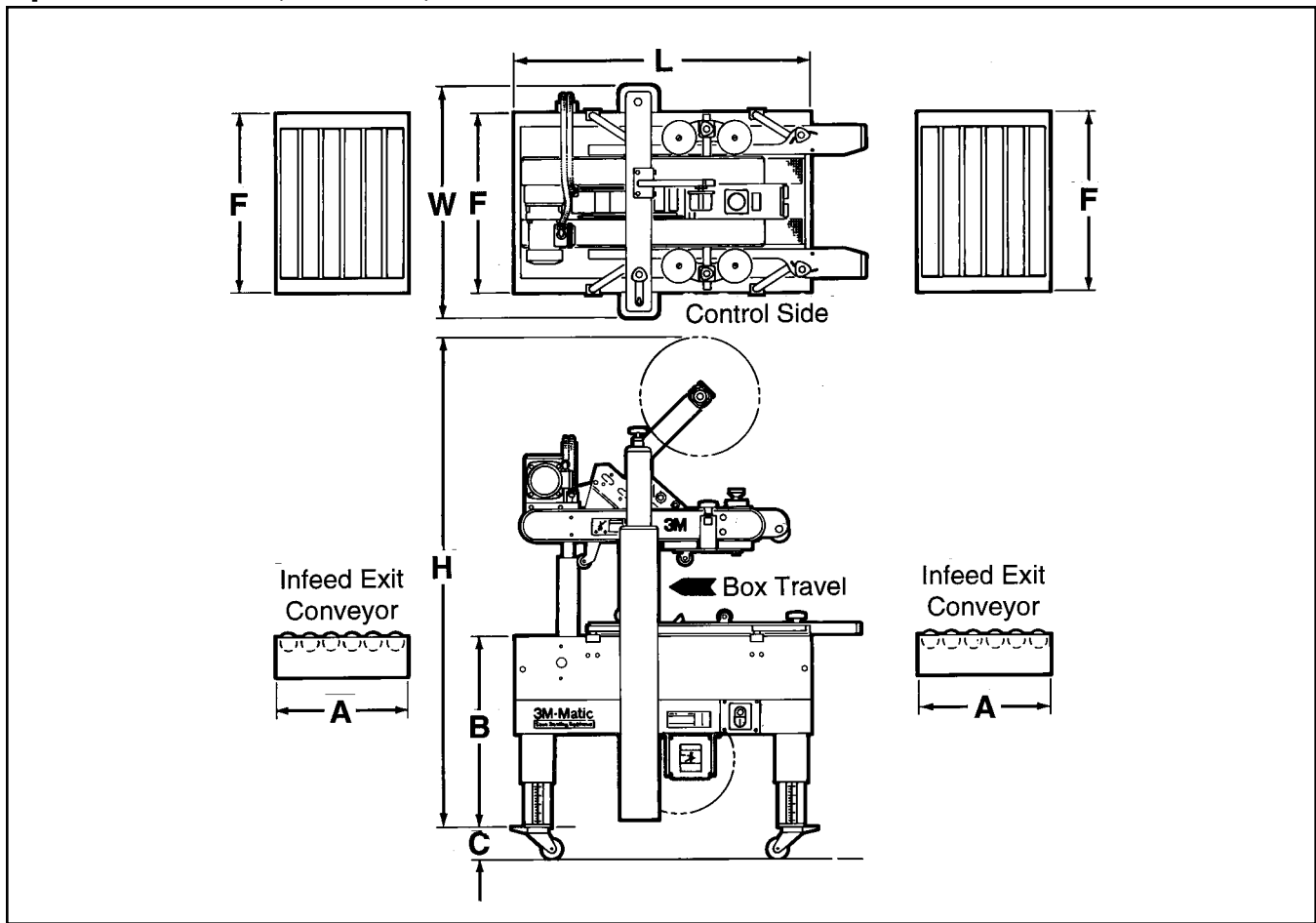
DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

$$\frac{\text{BOX LENGTH IN DIRECTION OF SEAL}}{\text{BOX HEIGHT}} = \text{MUST BE GREATER THAN .5}$$

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

(Specifications continued on next page.)

Specifications (Continued)



10. Machine Dimensions:

	W	L	H	A*	B	C**	F
Minimum							
mm	790	1030	1350	460	610	100	625
[Inches]	[31]	[40.5]	[53]	[18]	[24]**	[4]	[24.5]
Maximum							
mm	--	--	2185	--	890	--	--
[Inches]	--	--	[86]**	--	[35]**	--	--

* Infeed/Exit conveyors are optional

** Casters are optional

*** When columns are adjusted to upper position, "B" minimum dimension is 520 mm [20.5 inch], maximum dimension is 780 mm [31 inch] and "H" maximum dimension is 2290 mm [90 inch]. (See "Special Set-Up Procedure – Box and Machine Bed Height Range".)

Weight – 180 kg [400 lbs] crated (approximate)
160 kg [350 lbs] 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.

Installation and Set-Up

Receiving And Handling

After the machine has been uncrated, examine the case sealer for damage that might have occurred during transit. **If damage is evident, file a damage claim immediately** with the transportation company and also notify your 3M Representative.

Machine Set-Up

 **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

The following instructions are presented in **the order recommended** for setting up and installing the case sealer, as well as **for learning the operating functions and adjustments**. Following them step by step will result in your thorough understanding of the machine and an installation in your production line that best utilizes the many features built into the case sealer. Refer to Figure 3-1 to identify the various components of the case sealer.

Note – A tool kit consisting of metric open end and hex socket wrenches is provided with the machine. These tools should be adequate to set-up the machine, however, other tools supplied by the customer will be required for machine maintenance.

PACKAGING AND SEPARATE PARTS

1. Remove straps and staples and lift fiberboard cover off pallet.
2. Remove protective wrapping around machine.
3. Cut and remove cable tie from electrical conduit.
4. Cut cable ties that secure upper assembly to machine bed on each side.
5. Remove tape drum bracket bolts (4) from top crossbar and install tape drum bracket from parts box as shown in Figure 2-1A.
6. Loosen and move both compression rollers out so they don't catch on side guides.
7. Install height adjustment crank and locking knob on top of left column as shown in Figure 2-1B. Crank upper assembly up high enough to allow clear access to lower taping head. Remove and discard the two cushion shipping blocks.
8. Using 17 mm wrench, remove nuts from top of side guides. Replace with black knobs from parts box. Figure 2-1C.
9. Cut and remove cable ties on both upper and lower taping heads. (Applying/buffing rollers are held retracted for shipment.)

 **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

Hold taping head **BUFFING ROLLER** and cut and remove cable tie that holds applying/buffing arms retracted. See Figure 2-1D. Allow buffering/applying arms to extend slowly.

10. Install machine stops onto columns as shown in Figure 2-1E. Use the lowest hole position and bolt into the lowest threaded insert on the column.

Installation and Set-Up (Continued)

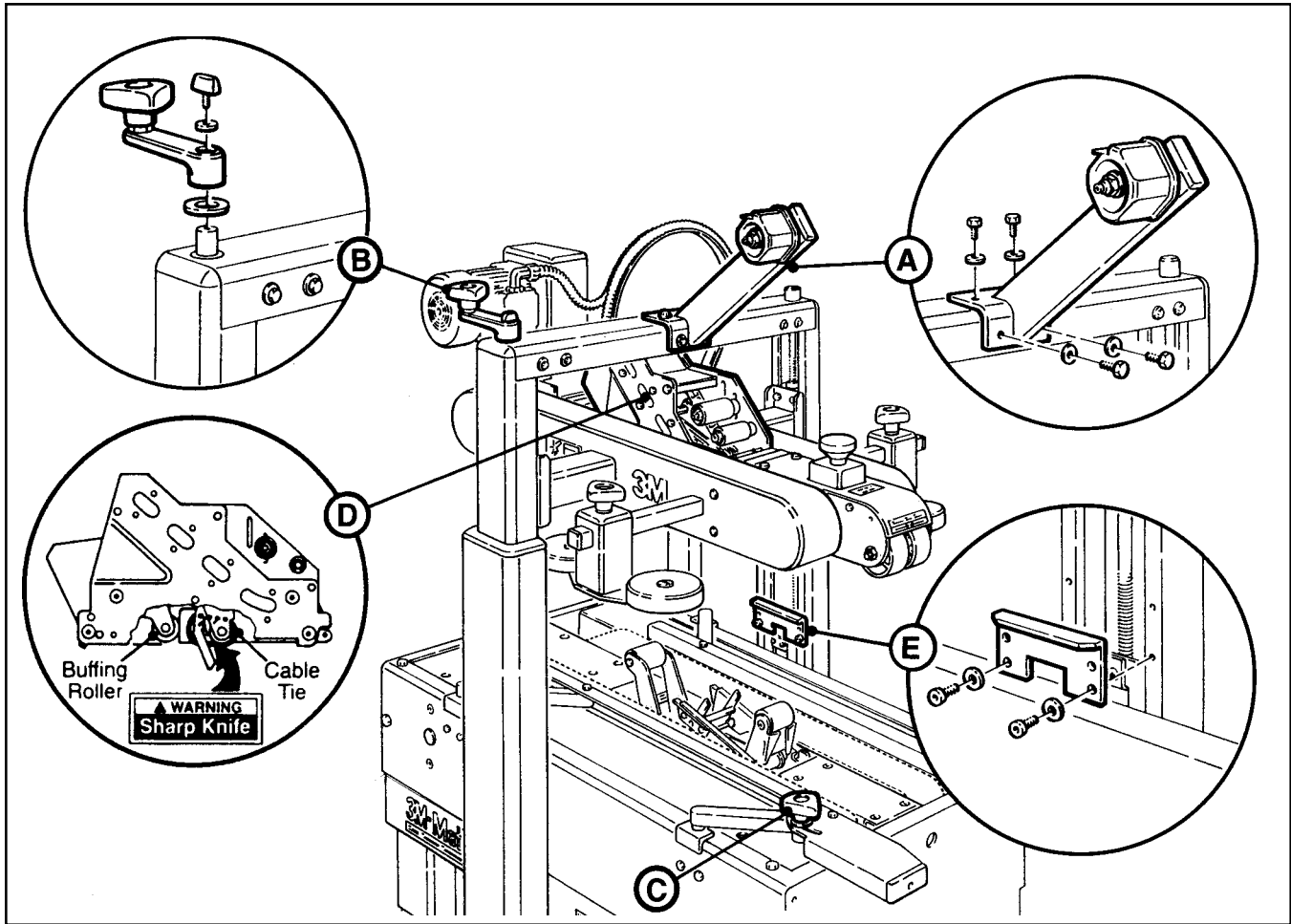


Figure 2-1 – 700a-s Frame Set-Up

11. Check for free action of both upper and lower 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

Push buffing roller into head to check for free, smooth action of taping heads.

12. Ensure that the tape drum bracket assembly, located on the lower taping head, is mounted straight down, as shown in Figure 2-2A. The tape drum bracket assembly can be pivoted to provide tape roll clearance in certain cases.
13. Remove fasteners that secure case sealer legs to pallet.

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

14. Remove the machine from the pallet and move it into position.

Important – Whenever the machine is lifted with a fork truck, insure that the forks span completely across the machine frame and do not contact any wiring or mechanism under the machine frame. In some cases the lower taping head may need to be removed to avoid damage.

15. Continue with the remainder of the Installation and Set-Up procedure through the end of the topic.

Installation and Set-Up (Continued)

MACHINE BED HEIGHT

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


Note – Minimum machine bed height can be reduced to 520 mm [20.5 inch] by moving outer columns up one set of mounting holes. However, this change also increases the minimum box height of 120 mm [4.8 inch] to 165 mm [6.5 inch]. (See "Special Set-Up Procedure – Box/Machine Bed Height Range".)

Refer to Figure 2-2C and set the machine bed height as follows:

1. Use appropriate material handling equipment and blocking techniques to raise the machine frame to allow adequate leg adjustment.
2. Loosen, but do not remove, two 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 screws to secure the leg. Adjust all four legs equally.

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 2-2B.

 **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

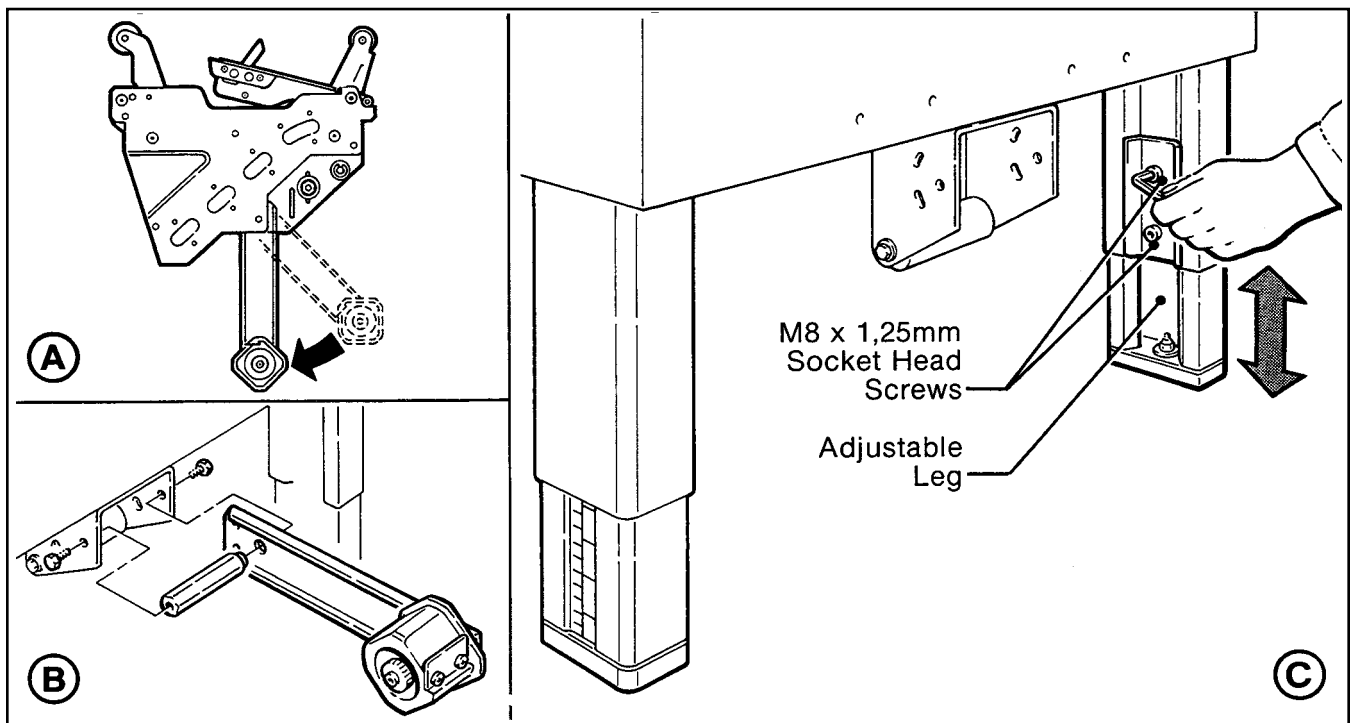


Figure 2-2 – Machine Bed Height Adjustment and Lower Tape Drum Bracket Position

Installation and Set-Up (Continued)

BOX SIZE CAPACITY OF CASE SEALER

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

Note – *Adjusting machine to accommodate 725 mm [28.5 inch] high boxes also increases minimum box size to 165 mm [6.5 inch].*

ELECTRICAL CONNECTION AND CONTROLS

The electrical control box (with circuit breaker) and "On/Off" switch are located on the lower left side of the machine frame. See Figure 3-1. 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. 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 1.5 mm diameter [AWG 16], have a maximum length of 30.5 m [100 ft], and must be properly grounded.

WARNING

• To reduce the risk associated with hazardous voltage:

- 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.*

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

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 below to acquaint yourself with the various components and controls of the case sealer. Also see Figures 3-1 and 3-2 in Section II for taping head components.

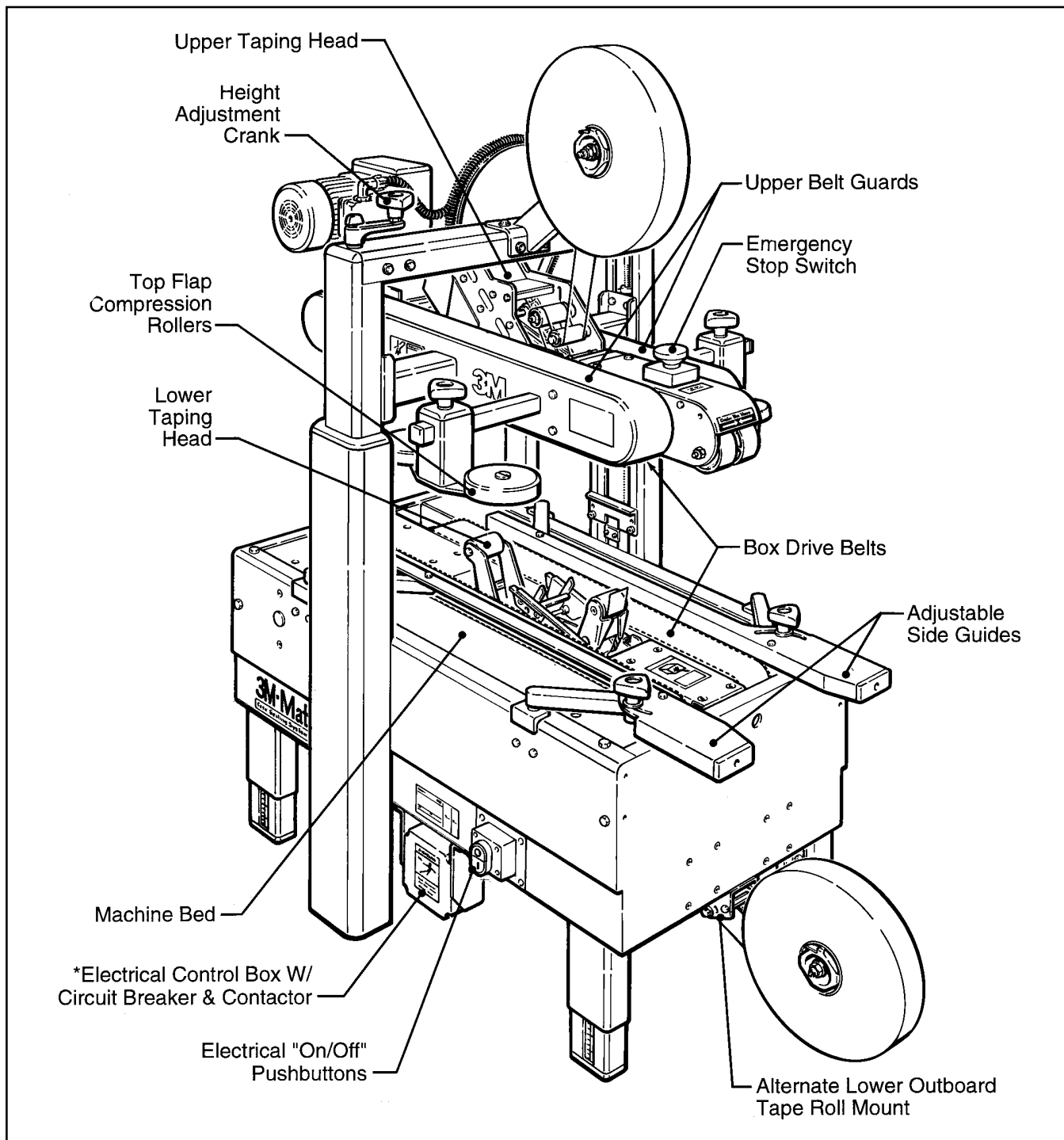


Figure 3-1 – 700a-s Stainless Steel Case Sealer Components (Left Front View)

Operation (Continued)

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

Electrical "On/Off" Switch

The box drive belts are turned on and off ("Off" button is red) with the electrical switch on the side of the machine frame.

Note – The case sealer has a circuit breaker located in the electrical enclosure on the lower left side of the machine frame. If circuit becomes overloaded and circuit breaker trips, **unplug the machine electrical cord** and determine cause of overload. After two minutes, open the electrical enclosure and reset the circuit breaker by lifting the reset lever. Close the electrical enclosure, plug machine electrical cord into outlet and restart machine by pressing "I" (On) button.

Emergency Stop Switch

The machine electrical supply can be turned off by pressing the latching emergency stop switch. To restart machine, rotate emergency stop switch (releases switch latch) and then restart machine by pressing "I" (On) button on side of machine frame.

Tape Loading/Threading

See Section II, Operation Section.

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



WARNING

- **To reduce the risk associated with muscle strain:**
 - Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift

Operation (Continued)

Box Size Set-Up

1. ADJUST UPPER TAPING HEAD

The upper taping head is positioned for the box height by means of the height adjustment crank shown in Figure 3-2. Turn crank clockwise to lower head, counterclockwise to raise head.

Move the top flap compression rollers to a position wider than the box.

Place box on infeed end of machine bed with both top and bottom flaps folded and insert under upper head ski approximately 150 mm [6 inch] as shown in Figure 3-3. Lower the head until all flaps are fully closed. Align box top flap center seam with arrows on front of upper frame.

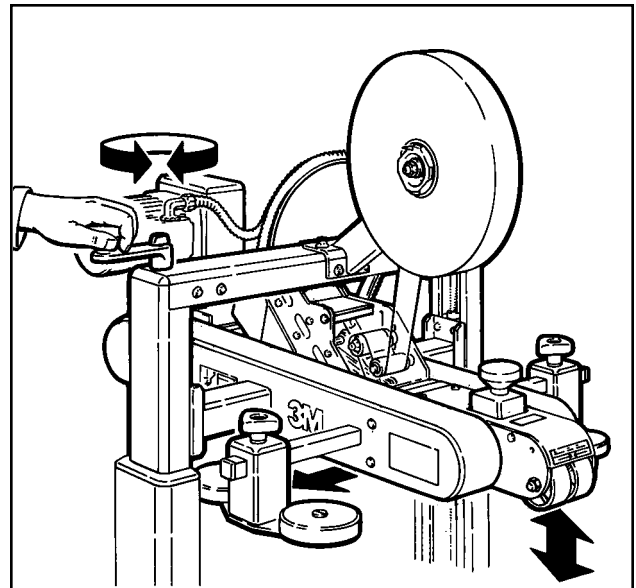


Figure 3-2 – Upper Taping Head

2. ADJUST SIDE GUIDES (Figure 3-4)

Align box top flap center seam with arrows on front of ski.

Move side guides against each side of box to hold box in position, centered on arrows on front of ski.

Tighten hand knobs to secure side guides.

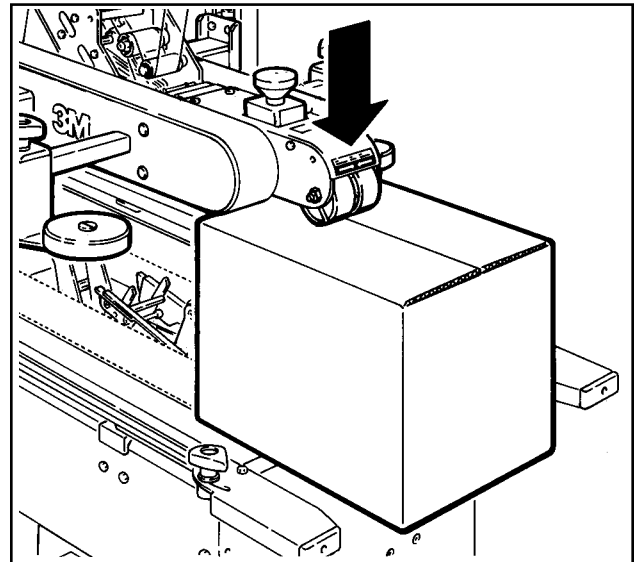


Figure 3-3 – Upper Taping Head

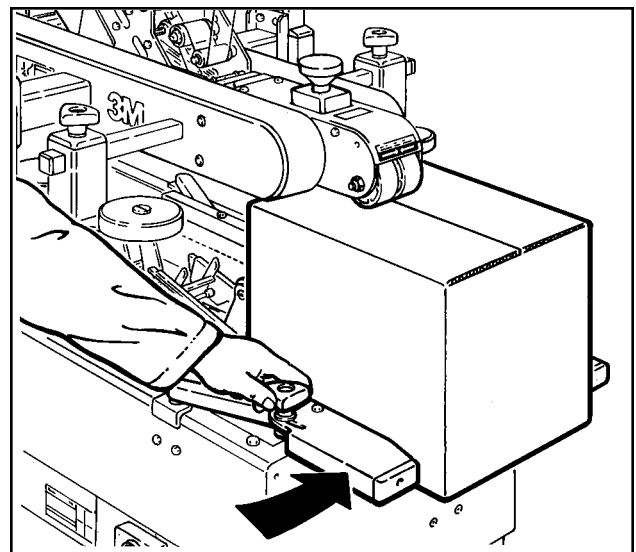


Figure 3-4 – Side Guides

Operation (Continued)

3. RUN BOXES TO CHECK ADJUSTMENT (Figure 3-5)

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

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

Turn electrical switch to "On" to start drive belts. Move box forward under upper taping head until it is taken away by drive belts. If box is hard to move under head or is crushed, **raise** head slightly. If box movement is jerky or stops under upper head, **lower** upper head slightly to add more pressure between box and drive belts.

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

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

4. TOP FLAP COMPRESSION ROLLERS (Figure 3-6)

CAUTION

- To reduce the risk associated with pinch and entanglement hazards:
 - Keep hands, hair, loose clothing and jewelry away from box compression rollers.

The top flap compression rollers have two mounting positions to provide side compression through the full range of box widths.

The rollers have been pre-assembled in position "B" to accommodate box widths from 200 mm [8 inch] to 545 mm [21.5 inch] maximum.

To accommodate box widths less than 200 mm [8 inch] to 140 mm [5.5 inch] minimum, move all four rollers to position "A".

Adjust the top flap compression rollers against top edge of box and tighten knobs to secure rollers in operating position.

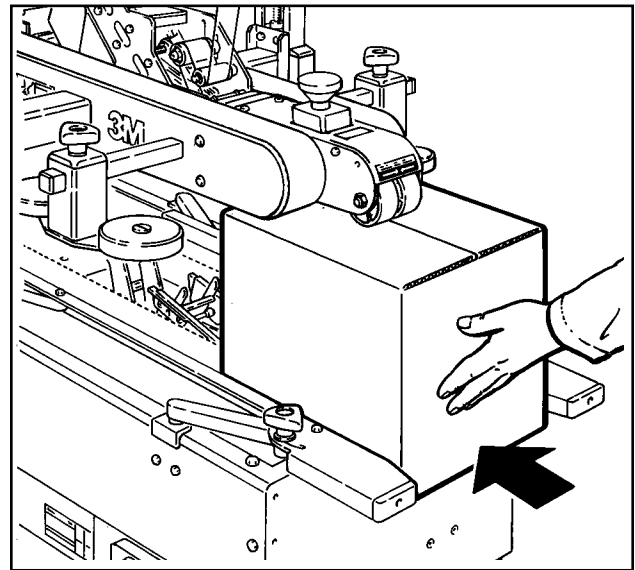


Figure 3-5 – Check Adjustments

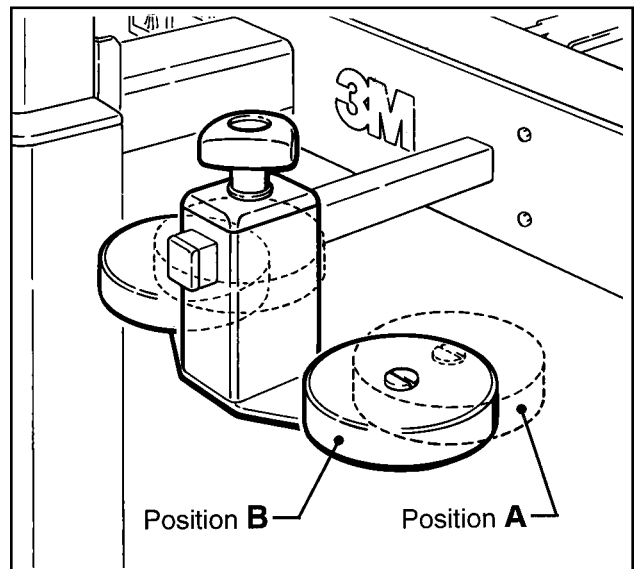


Figure 3-6 – Compression Rollers

Operation (Continued)

5. ADJUST COMPRESSION ROLLERS

Adjust the top flap compression rollers against top edge of box and tighten knobs to secure rollers in operating position as shown in Figure 3-7.

Box Sealing

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 box compression rollers
 - Keep hands, hair, loose clothing, and jewelry away from moving belts and taping heads

WARNING

- **To reduce the risk associated with pinch, entanglement, and hazardous voltage:**
 - Never attempt to work on any part of the machine, load tape, or remove jammed boxes from the machine while the machine is running

1. Feed boxes to machine at minimum 455 mm [18 inch] intervals.
2. Reload and thread tape as necessary.
3. Be sure machine is cleaned and lubricated according to recommendations in "Maintenance" section of this manual.

WARNING

- **To reduce the risk associated with pinch and entanglement hazards:**
 - Do not leave the machine running while unattended

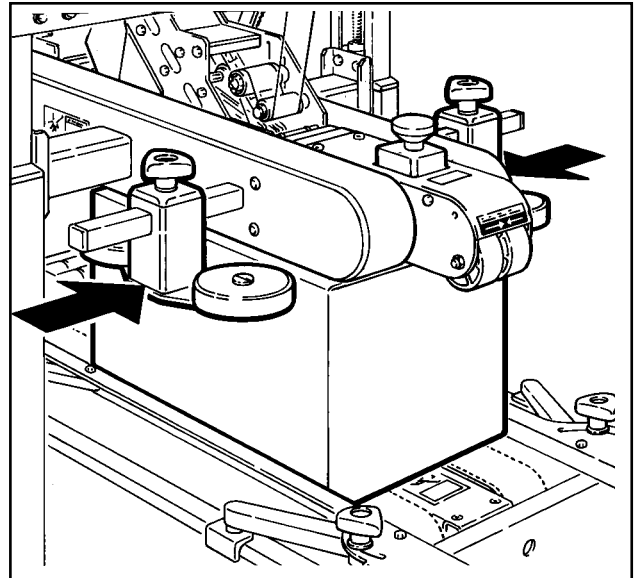


Figure 3-7 – Compression Rollers

Notes–

1. Machine or taping head adjustments are described in "Adjustments" Section I for machine or Section II 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.

Maintenance

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

WARNING

- **To reduce the risk associated with 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 supply off and disconnect before performing any adjustments, maintenance or servicing the machine or taping heads

Cleaning

Note – Never attempt to remove dirt from the machine by blowing it out with compressed air. This can cause the dirt to be blown inside the motor and onto sliding surfaces which may cause premature equipment wear. Never wash down this equipment. Serious equipment damage could result.

Regular slotted containers produce a great deal of dust and paper chips when processed or handled in equipment. If this dust is allowed to build-up on machine components, it can cause component wear and overheating of drive motor. The dust build-up can best be removed from the machine by a shop vacuum. Depending on the number and type of boxes sealed in the case sealer, this cleaning should be done approximately once per month. If the boxes sealed are dirty, or if the environment in which the machine operates is dusty, cleaning on a more frequent basis may be necessary. Excessive dirt build-up that cannot be removed by vacuuming should be wiped off with a damp cloth.

Lubrication

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

Figure 4-1 illustrates the machine points that do require lubrication every 250 hours of operation. Lubricate the points indicated by arrows (⇔) with a small amount of multi-purpose grease.

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

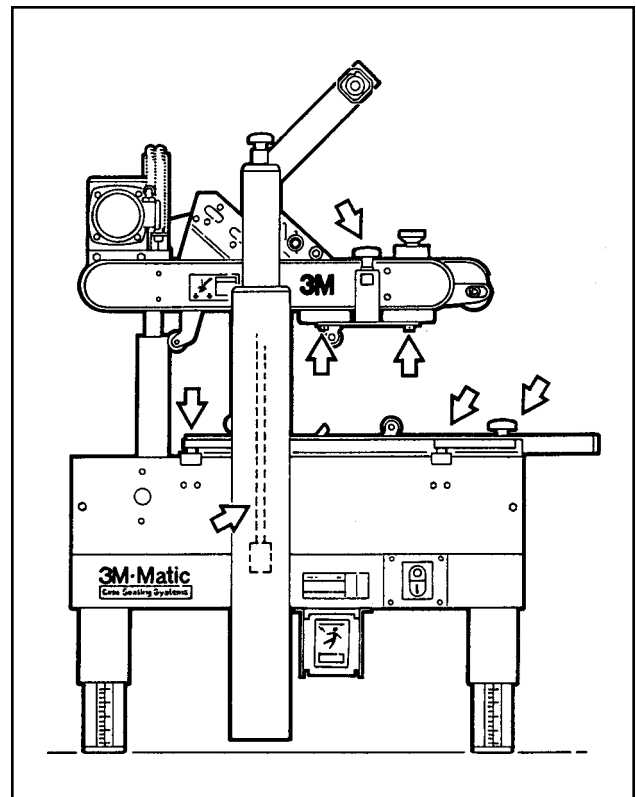


Figure 4-1 – Lubrication Points – Frame

Maintenance (Continued)

WARNING

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

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

Box Drive Belt Replacement

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

LOWER DRIVE BELTS

Figure 4-2

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

Important – Pin must not extend beyond edge of belt.

7. Adjust belt tension as explained in "Adjustments - Box Drive Belt Tension."
8. Replace side cover and center plate and secure with original fasteners.

UPPER DRIVE BELTS

Figure 4-3

1. Remove and retain front cover **(A)** and four screws.
2. Loosen, but do not remove lock nut **(C)**.
3. Loosen tension screw **(D)** until all tension is removed from belt.
4. Move compression roller assembly out to full open position.
5. Remove 4 screws on side of belt guard **(E)** and slide belt guard out to expose belt.
6. Pull belt splicing pin **(F)** out and remove belt.
7. Place new belt over pulleys with laced splice at top. Insert splicing pin.

Important – Pin must not extend beyond edge of belt.

8. Adjust belt tension as explained in "Adjustments - Box Drive Belt Tension."
9. Replace front cover and belt guard(s) and secure with original fasteners.

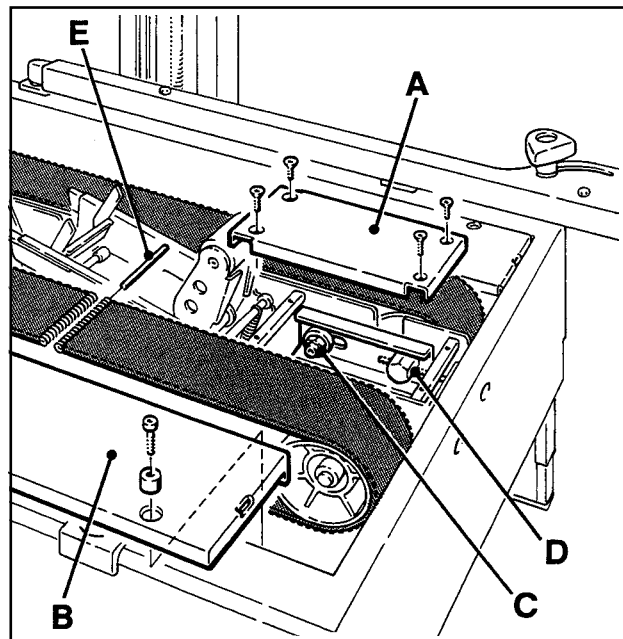


Figure 4-2 – Lower Drive Belt Replacement

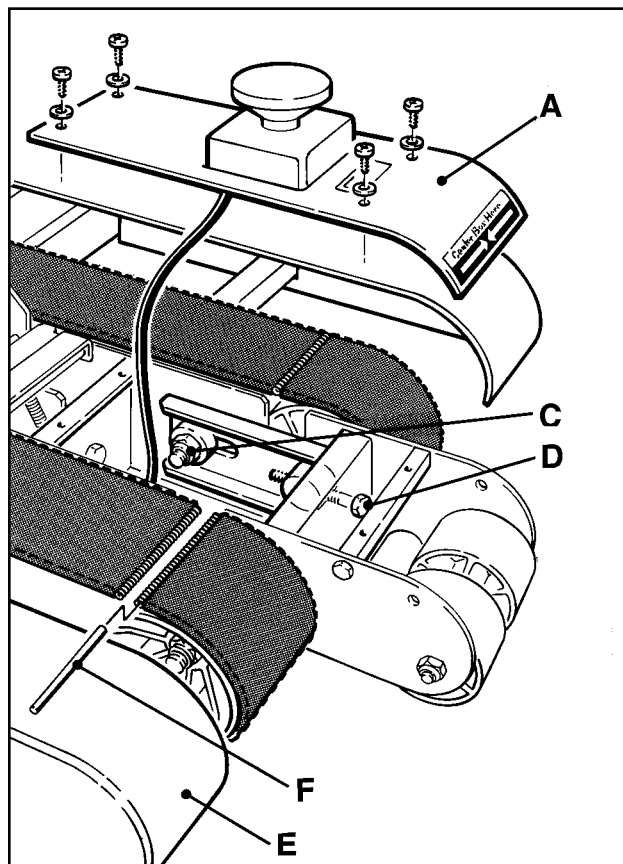


Figure 4-3 – Upper Drive Belt Replacement

Maintenance (Continued)



WARNING

- **To reduce the risk associated with mechanical and electrical hazards:**

- Turn electrical 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 3.4 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 "Reset" and then press "On" button.
If circuit breaker will not reset, wait 2 minutes and retry.
4. Replace cover.
5. Plug in machine.
6. Press machine "On" button to resume case sealing.

Blade Replacement, Taping Head

See Section II, "Maintenance – Blade Replacement."

Adjustments

WARNING

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

Box Drive Belt Tension

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

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

Belt tension is obtained by tightening the adjustment screw so that a moderate pulling force of 3.5 kg [7 lbs.] applied at the midspan, as shown in Figure 5-1, will deflect the belt 25 mm [1 inch]. This will assure positive contact between the belt and the drive pulley on the discharge end of the drive assembly.

Note – Figure 5-1 illustrates the lower drive belts; however, upper belts are adjusted in the same manner.

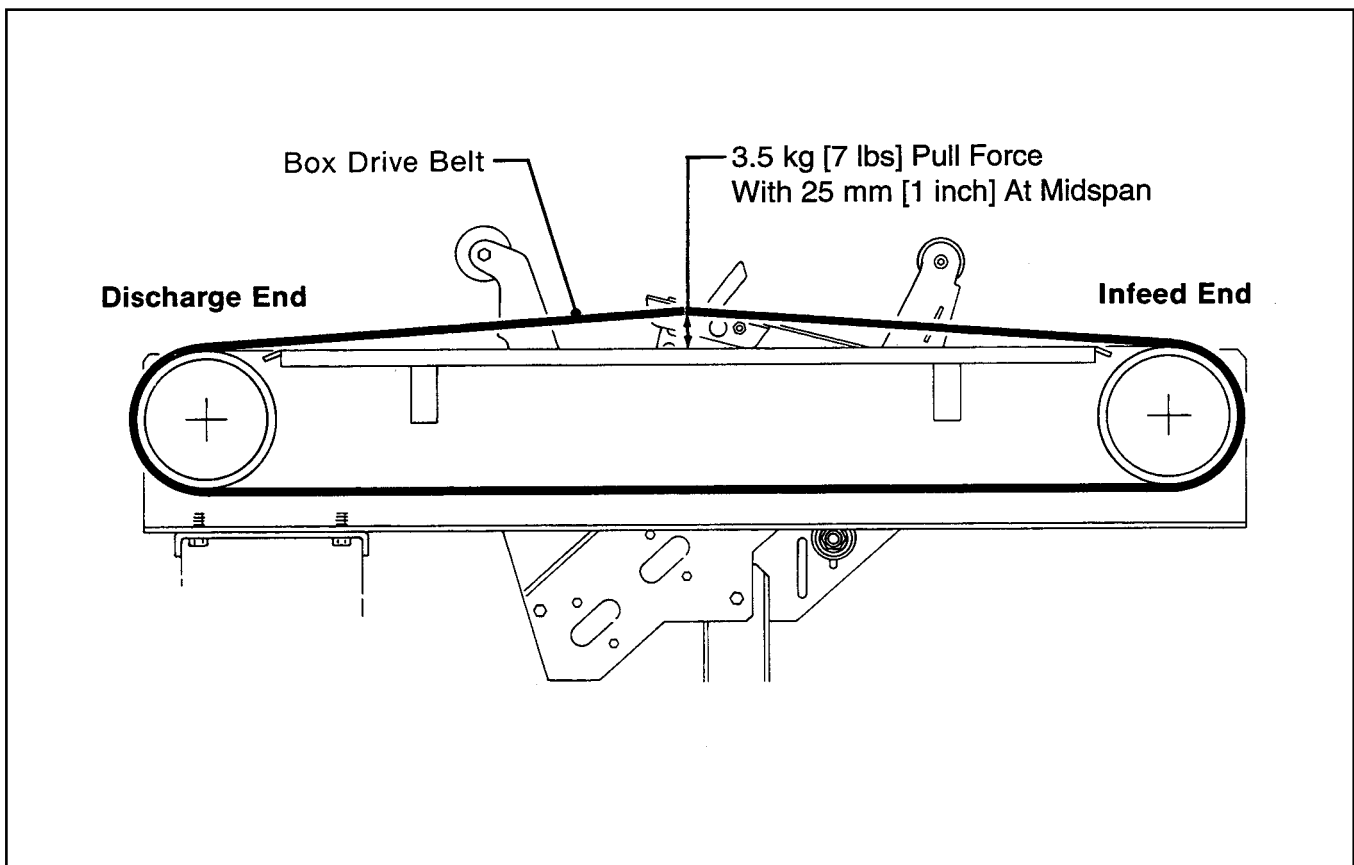


Figure 5-1 – Box Drive Belt Tension Adjustment

Adjustments (Continued)

WARNING

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

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

Refer to Figure 5-2 and 5-3 and adjust belt tension as follows:

1. Remove and retain center plate/front cover and four screws.
2. Loosen, but do not remove, M10 lock nut with a 17 mm open end wrench.
3. Reset the tension on the drive belts as needed. Adjust the M8 tension screws in (clockwise) to **increase** tension or out (counterclockwise) to **decrease** tension. Tighten lock nut to secure tension setting.
4. Replace center plate/front cover and secure with original screws.

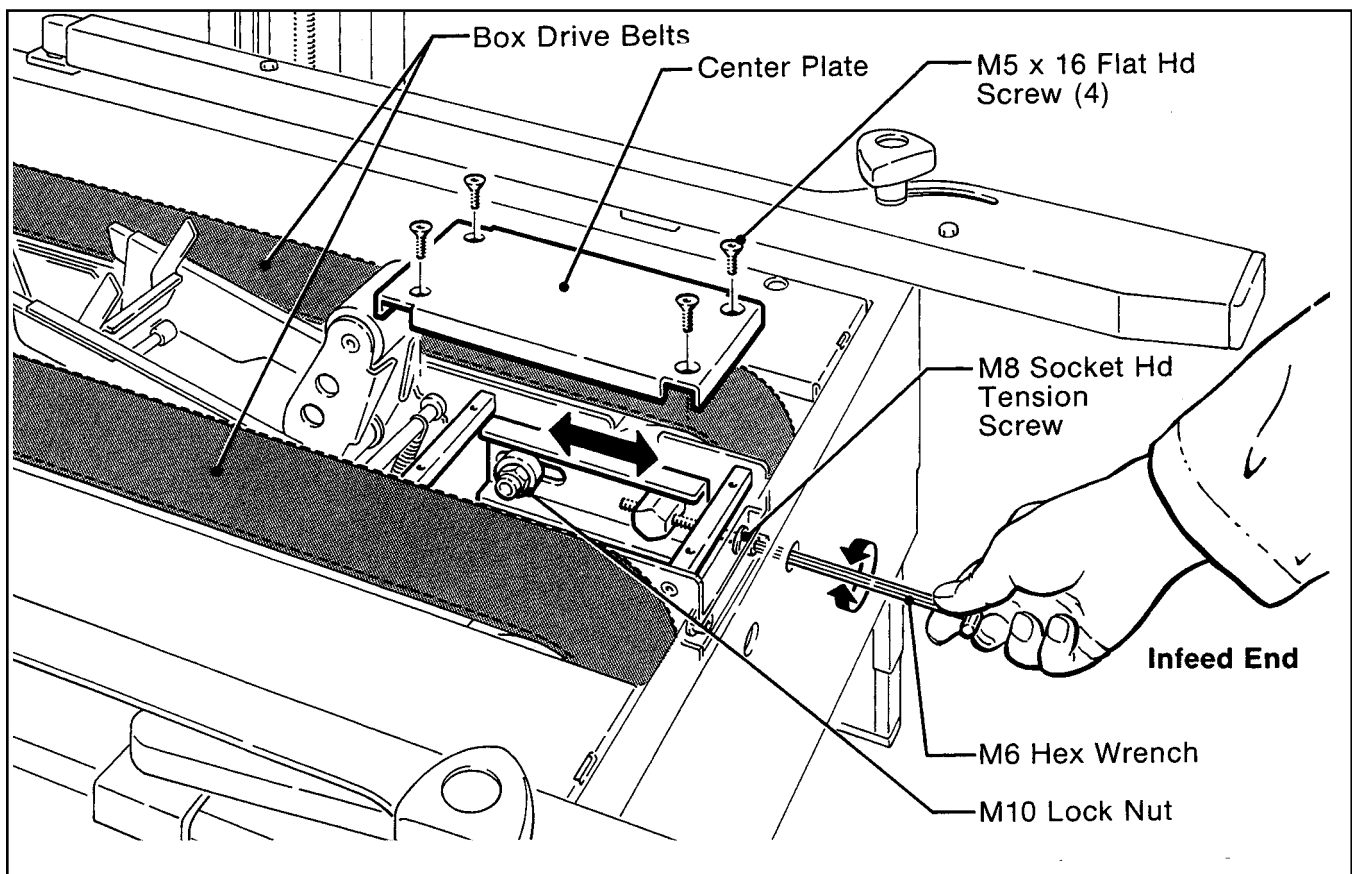


Figure 5-2 – Box Drive Belt Tension Adjustment, Lower Belts (Infeed End)

Adjustments (Continued)

WARNING

- **To reduce the risk associated with mechanical and electrical hazards:**

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

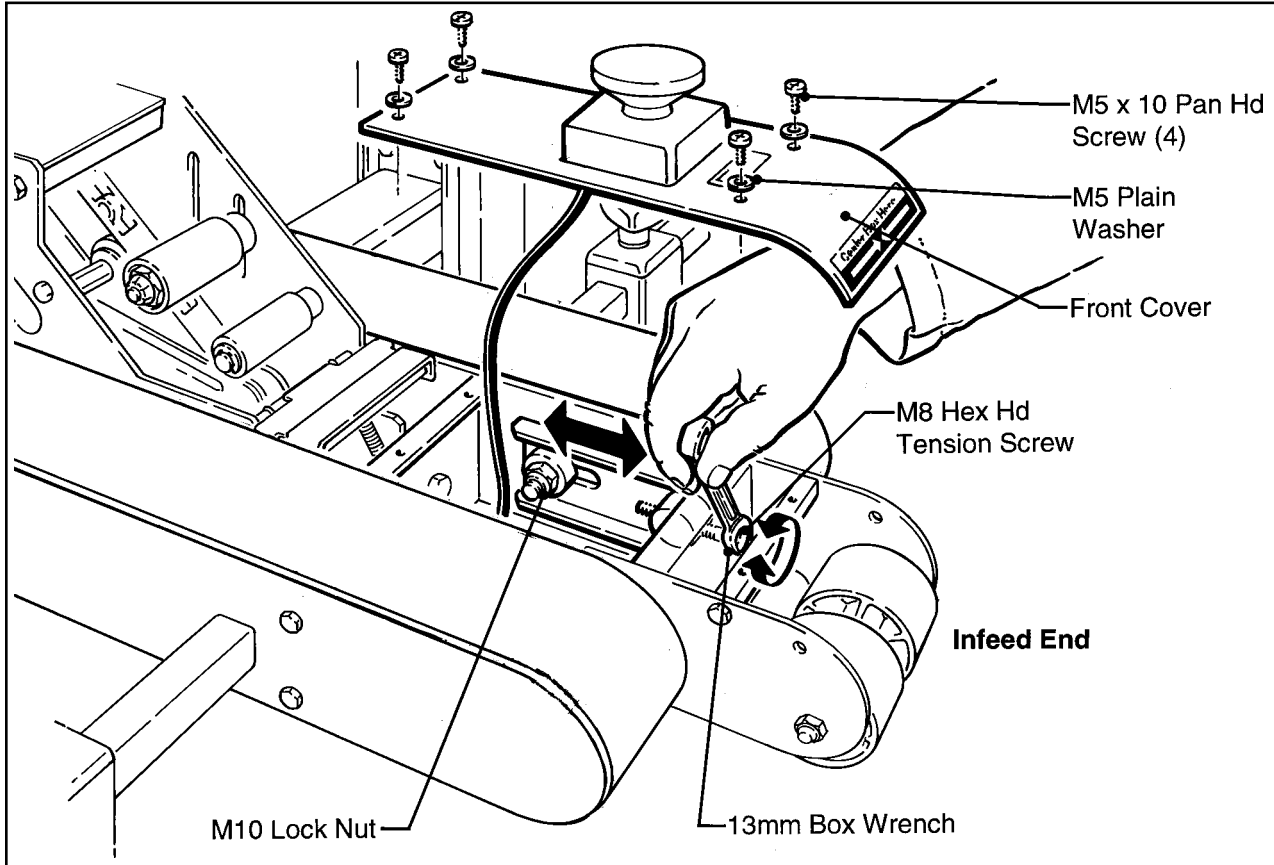


Figure 5-3 – Box Drive Belt Tension Adjustment, Upper Belts (Infeed End)

Taping Head Adjustments – Refer to Section II.

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 – Section II

TAPE DRUM FRICTION BRAKE – Section II

APPLYING MECHANISM SPRING – Section II

ONE-WAY TENSION ROLLER – Section II

TAPE LEG LENGTH ADJUSTMENT – Section II

Special Set-Up Procedure

WARNING

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

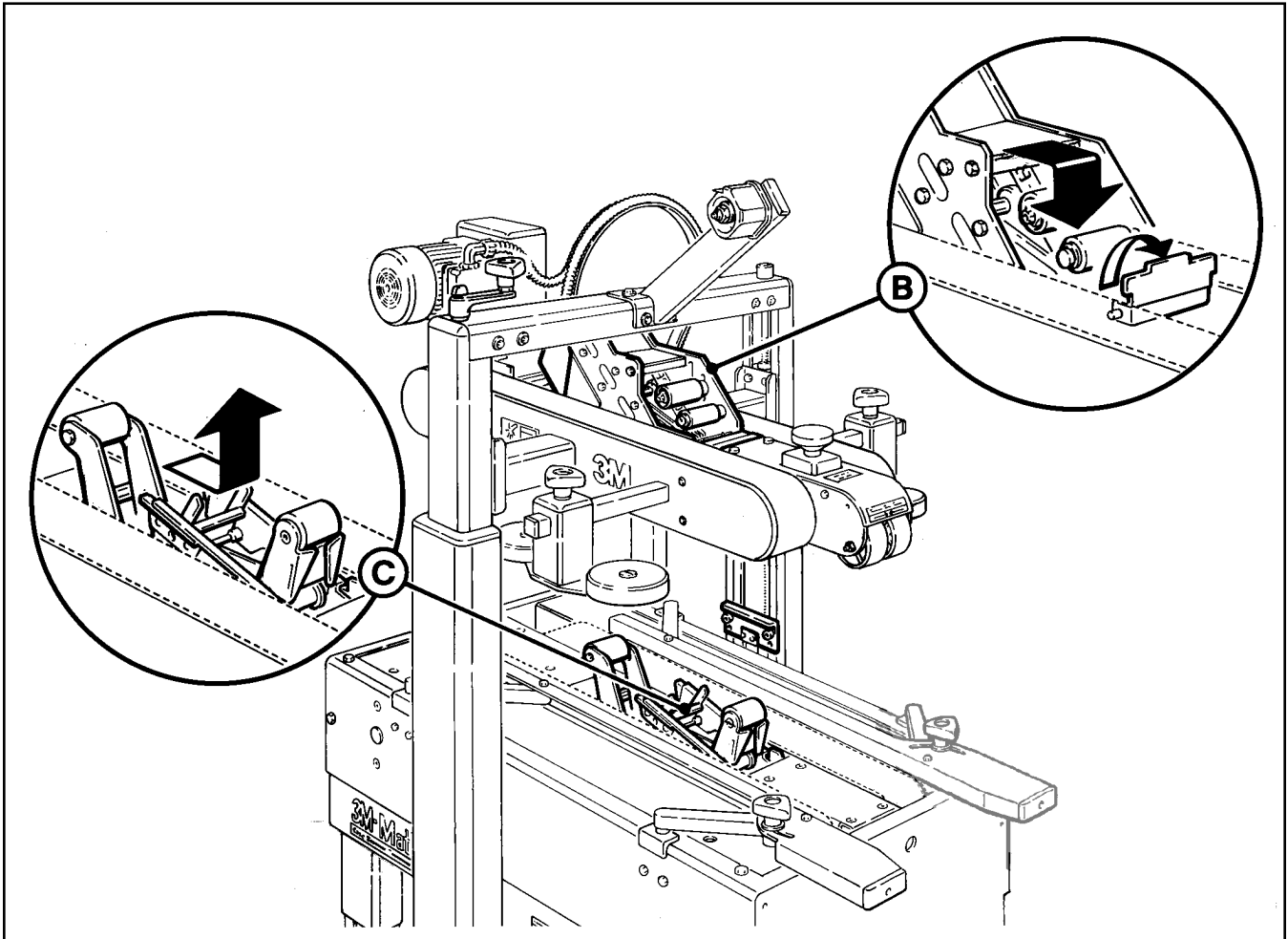


Figure 6-1 – Case Sealer Frame Changes

Special Set-Up Procedure (Continued)

WARNING

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

TAPING HEAD REMOVAL

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

1. Remove tape from upper taping head and raise upper assembly to a convenient working height.
2. Pivot up the clamp that secures the upper taping head as shown in Figure 6-1B.
3. Hold upper taping head applying and buffing arms from under upper assembly, slide head forward and down to remove. See Figure 6-2.

CAUTION

- **To reduce the risk associated with muscle strain:**
 - Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift

4. Raise upper assembly to provide working room around lower taping head and remove tape from taping head.
5. Lift the lower taping head, shown in Figure 6-3 and 6-1C, straight up to remove it from the case sealer bed.
6. Replace taping heads reverse of disassembly.

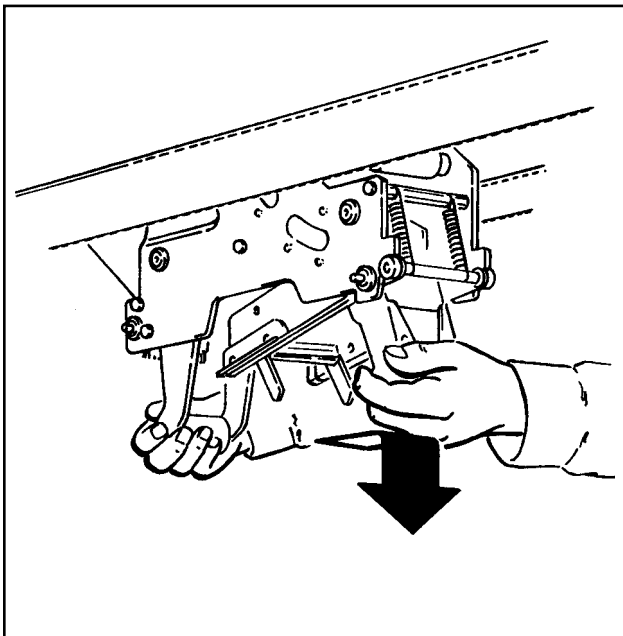


Figure 6-2 – Remove Upper Taping Head

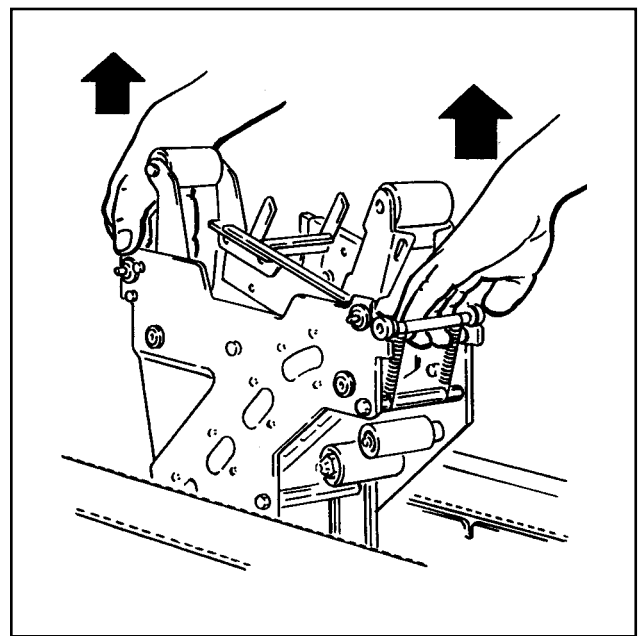


Figure 6-3 – Remove Lower Taping Head

Special Set-Up Procedure (Continued)

Box and Machine Bed Height Range – Refer to Figure 6-4

Moving the outer columns up one set of mounting holes increases the maximum box size handled by the 700a-s case sealer and decreases the minimum machine bed height.

Note – This also increases the minimum box height from 120 mm [4.8 inch] to 165 mm [6.5 inch].

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

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

1. Place minimum 305 mm [12 inch] high blocks at the front and rear of the upper taping head assembly as shown in Figure 6-4A. Crank the upper taping head assembly down until it touches these blocks.

Important – Blocks (front and rear) must be same height in order to keep upper taping head assembly parallel with machine bed/drive belts.

2. Remove and retain the six screws and plain washers that fasten each column to the frame. Figure 6-4B.
3. Turn the height adjustment crank clockwise to raise the outer columns up one set of mounting holes (100 mm [4 inch]).
4. Install and tighten the six screws and plain washers in each column that were removed in Step 2. Crank upper taping head assembly up and remove blocks.

If desired, the bed height can now be decreased to 520 mm [20.5 inch] by adjusting legs upward. (See "Installation and Set-Up – Machine Bed Height".)

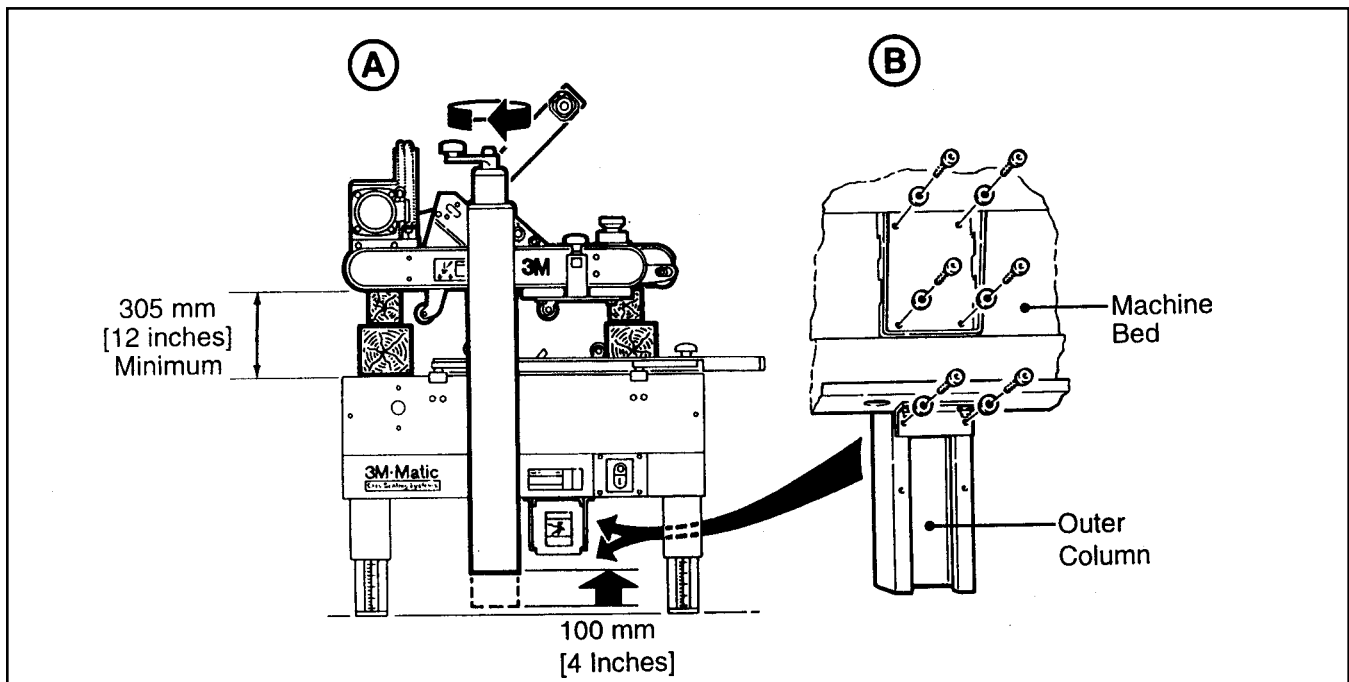


Figure 6-4 – Box and Machine Bed Height Range

Troubleshooting

The Troubleshooting Guide lists some possible machine problems, causes and corrections. Also see Section II "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 box height adjustment with the crank
	Top flap compression rollers in too tight	Readjust compression rollers
	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
	Circuit breaker not at correct setting	Set to correct current value
Upper and lower applying mechanisms interfere with each other	Motor not turning	Evaluate problem and correct
	Machine's minimum height stop does not match tape head leg length setting	Check manual to make sure taping heads match machine setting
Drive belts break	Worn belt	Replace belt
Light boxes tip back on exit	Upper ski down too far	Carefully adjust upper ski
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

Replacement Parts And Service Information

Spare Parts

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

Qty.	Ref. No.	Part Number	Description
4	10426-85 & 10427-70	78-8070-1531-4	Belt - Drive W/Pin

Also see Section II for recommended taping head spare parts.

Label Kit

In the event that any labels are damaged or destroyed, **they must be replaced to ensure operator safety.** A label kit, part number 78-8098-9175-3 is available as a stock item. It contains all the safety labels used on the 700a-s Adjustable Case Sealer.

Tool Kit

A tool kit, part number 78-8060-8476-6, is available as a stock item. The kit contains the necessary open end and hex socket wrenches for use with the metric fasteners on the case sealer. The threading tool, part number 78-8076-4726-4, contained in above kit is also available as a replacement stock item.

Replacement Parts Ordering Information and Service

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

Options/Accessories

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

Part Number	Option/Accessory
78-8052-6553-1	Box Hod Down Attachment, Model 18500
70-0064-0379-7	Caster Kit Attachment
70-0064-0378-9	Conveyor Extension Attachment
78-8060-8156-4	AccuGlide SST 2 Inch Upper Taping Head, Type 18900
78-8060-8157-2	AccuGlide SST 2 Inch Lower Taping Head, Type 18900

Replacement Parts – Illustrations and Parts Lists

700a-s Stainless Steel Adjustable Case Sealer, Type 10500 Frame Assemblies

To Order Parts:

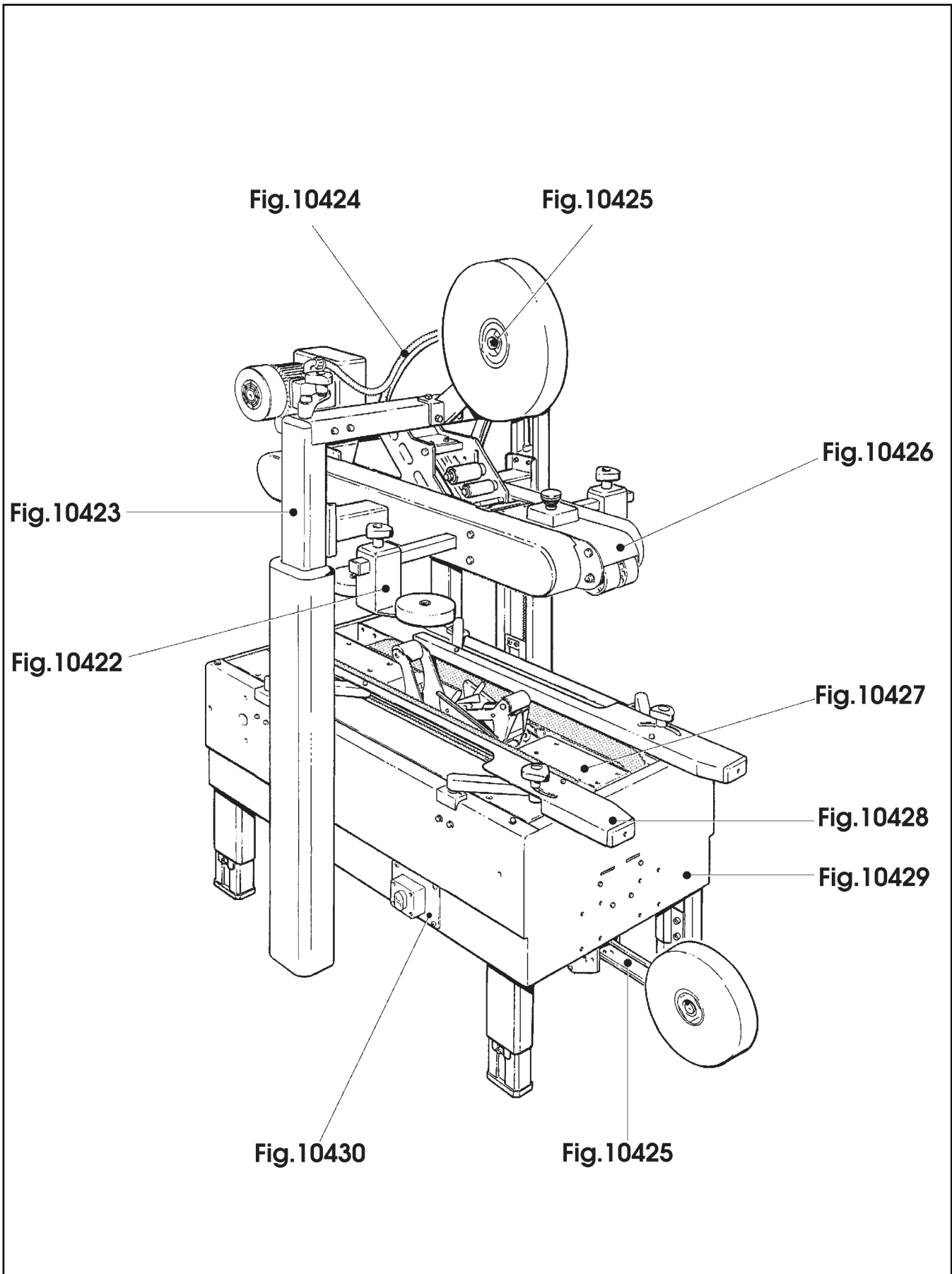
1. Refer to first illustration, **Frame Assemblies**, for the **Figure Number** that identifies a specific portion of the machine.
2. Refer to the appropriate **Figure or Figures** to determine the parts required and the parts reference number.
3. The Parts List that follows each illustration, includes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

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

4. Order parts by **Part Number, Part Description** and **Quantity** required. Also include machine name, number and type.
5. Refer to the first page of this instruction manual “**Replacement Parts and Service Information**” for replacement parts ordering information.

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

700a-s Stainless Steel Adjustable Case Sealer



Frame Assemblies

700a-s Stainless Steel Adjustable Case Sealer

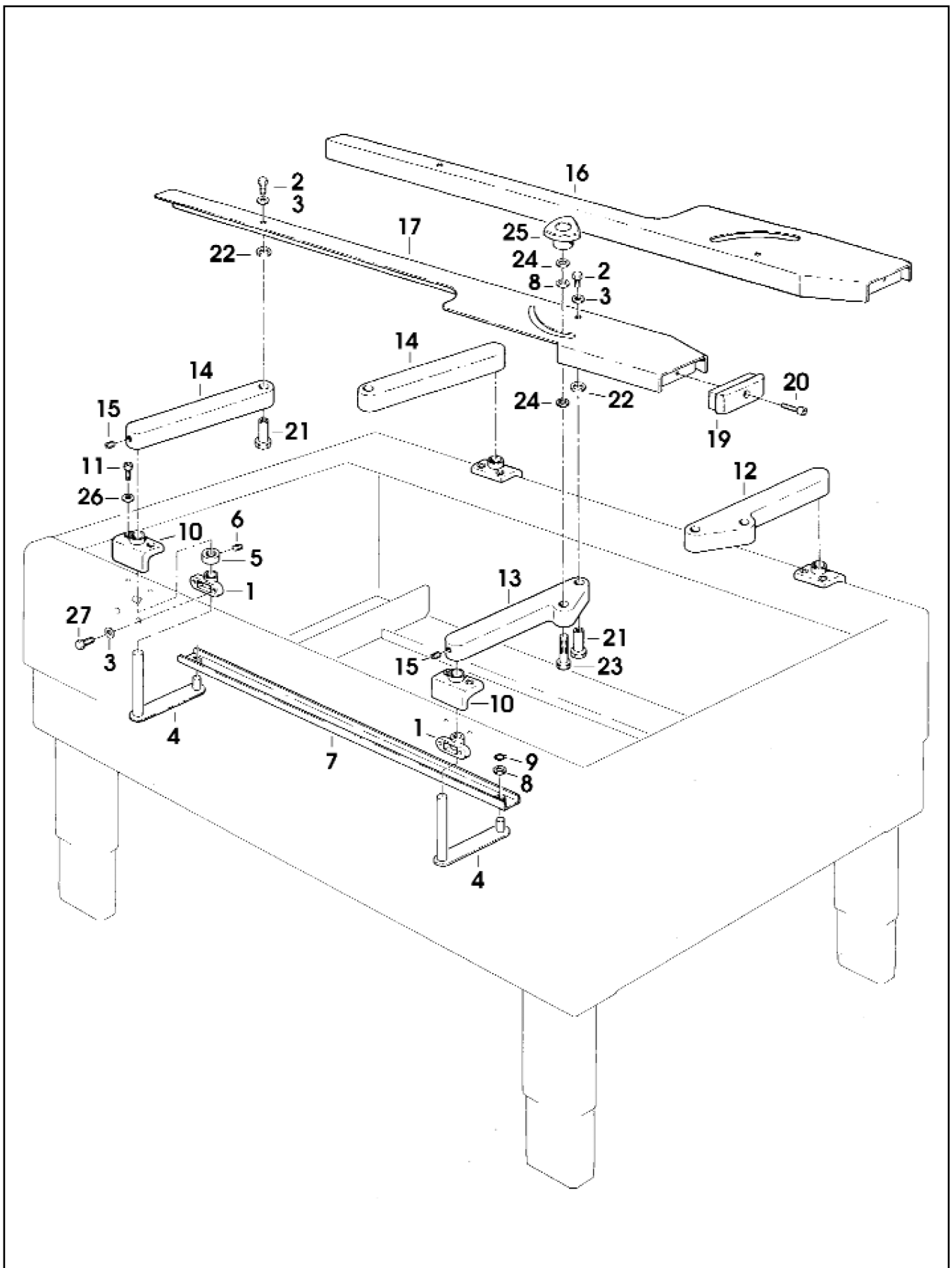


Figure 10428

Figure 10428

Ref. No.	3M Part No.	Description
10428-1	78-8070-1536-3	Support - Guide Arm
10428-2	78-8060-8292-7	Screw - Hex.Hd, M6x12
10428-3	78-8060-8312-3	Washer - Flat, M6
10428-4	78-8060-1976-5	Lever - Pivot
10428-5	78-8134-1977-3	Bushing
10428-6	78-8060-8326-3	Set Screw - M5x6
10428-7	78-8134-1978-1	Link - Guide
10428-8	78-8017-9074-8	Washer - Nylon, 15 mm
10428-9	78-8060-8339-6	Ring - M10
10428-10	78-8070-1540-5	Support - Lever
10428-11	78-8134-1979-9	Screw - Soc.Hd, M5x16
10428-12	78-8134-1980-7	Guide Arm - Front, Right
10428-13	78-8134-1981-5	Guide Arm - Front, Left
10428-14	78-8134-1982-3	Guide Arm - Rear
10428-15	78-8076-4505-2	Set Screw - M6x8
10428-16	78-8134-1983-1	Guide - R/H
10428-17	78-8134-1984-9	Guide - L/H
10428-19	78-8070-1546-2	Cap - Guide
10428-20	78-8134-1985-6	Screw - Soc.Hd, M5x30
10428-21	78-8134-1986-4	Shaft - Guide
10428-22	78-8070-1548-8	Washer - Nylon, 20 mm
10428-23	78-8134-1987-2	Screw - Hex.Hd, M10x40
10428-24	78-8060-8315-6	Washer - Flat, M10
10428-25	78-8070-1549-6	Knob
10428-26	78-8134-1988-0	Washer - Flat, M5
10428-27	78-8060-8295-0	Screw - Hex.Hd, M6x16

700a-s Stainless Steel Adjustable Case Sealer

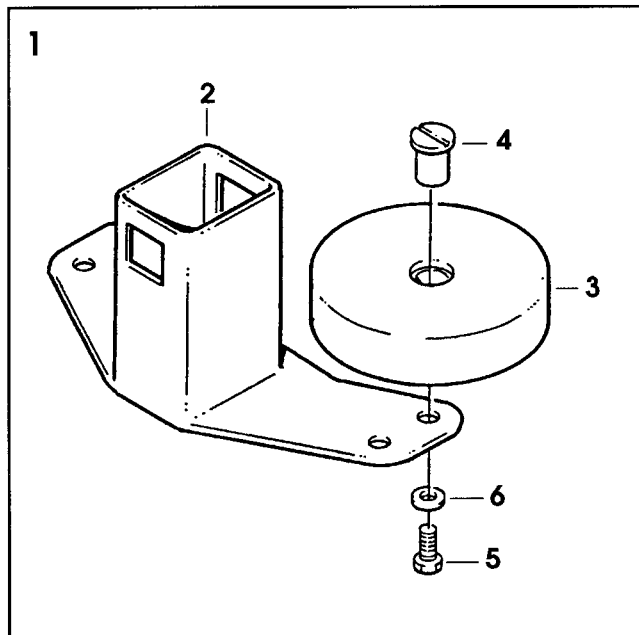
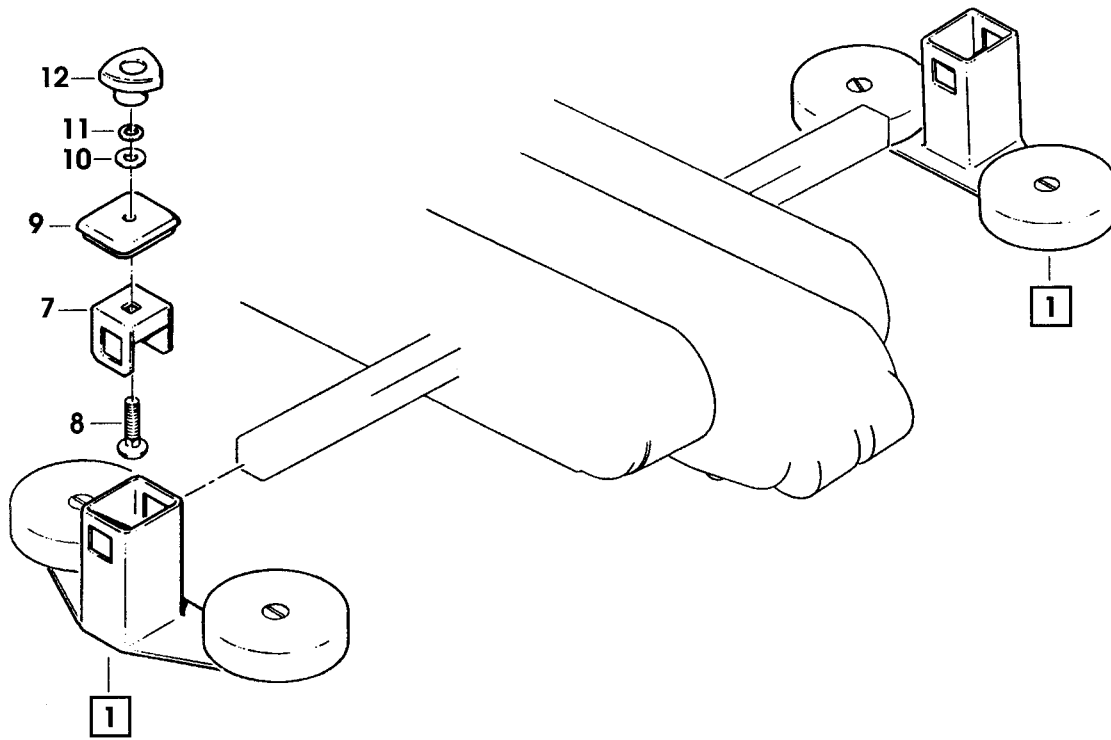


Figure 10422

Figure 10422

Ref. No.	3M Part No.	Description
10422-1	78-8134-1900-5	Side Compression Rollers Assy
10422-2	78-8134-1901-3	Support - Roller
10422-3	78-8076-4628-2	Roller - Compression
10422-4	78-8134-1902-1	Shaft - Roller
10422-5	78-8060-8323-0	Screw - Hex.Hd. M8x16
10422-6	78-8060-8308-1	Washer - Flat, M8
10422-7	78-8134-1903-9	Plate - Tube
10422-8	78-8134-1904-7	Screw - Carriage, M10x35
10422-9	78-8134-1905-4	Cap - Support
10422-10	78-8017-9074-8	Washer - Nylon
10422-11	78-8060-8315-6	Washer - Flat, M10
10422-12	78-8070-1549-6	Knob

700a-s Stainless Steel Adjustable Case Sealer

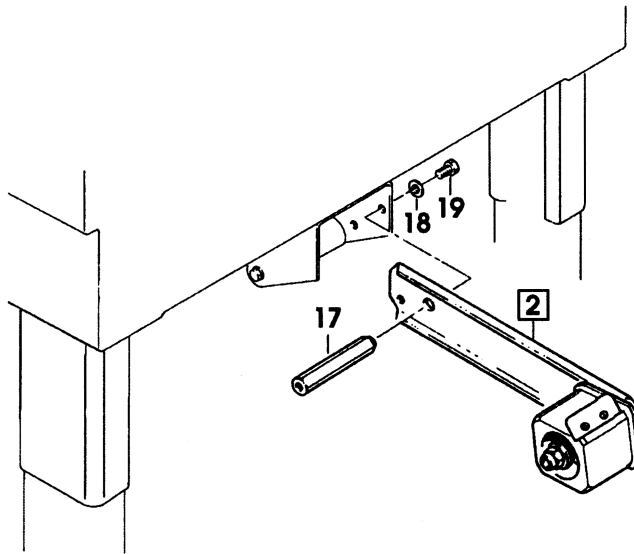
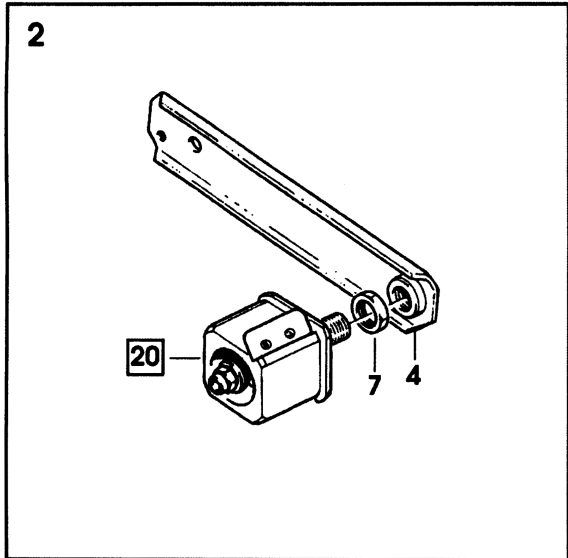
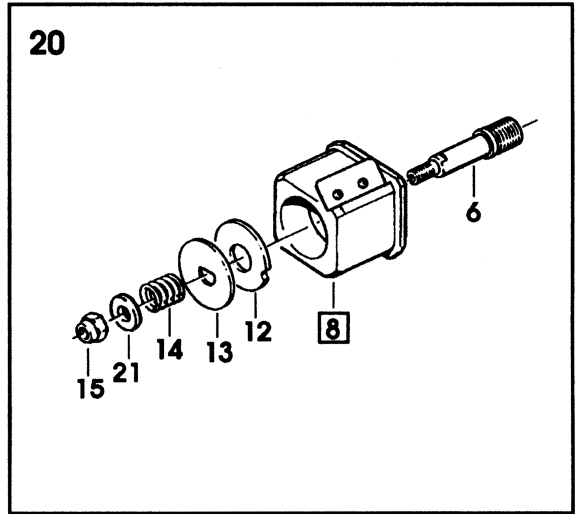
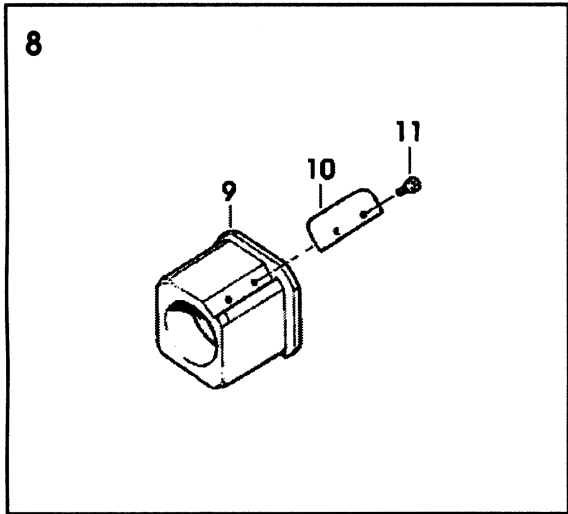
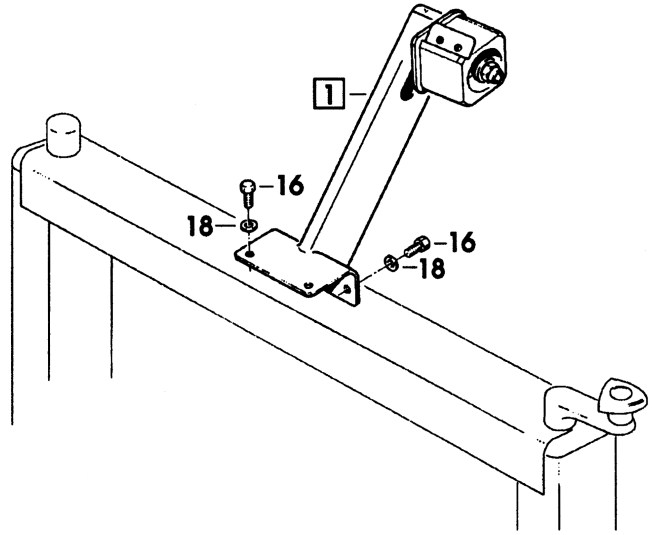
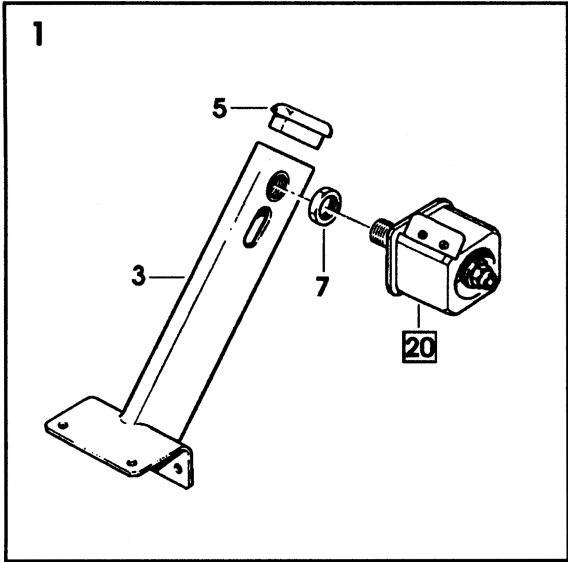


Figure 10425

Figure 10425

Ref. No.	3M Part No.	Description
10425-1	78-8134-1933-6	Tape Roll Bracket Assy
10425-2	78-8134-1934-4	Tape Drum Bracket Assy
10425-3	78-8134-1935-1	Bracket - Tape Drum, Upper
10425-4	78-8134-1936-9	Bracket - Tape Drum, Lower
10425-5	78-8070-1568-6	Cap - Bracket
10425-6	78-8134-1937-7	Shaft - Tape Drum
10425-7	78-8134-1938-5	Nut - M18x1
10425-8	78-8076-4730-6	Tape Drum Assy - 2" Wide
10425-9	78-8052-6749-5	Tape Drum
10425-10	78-8060-8362-8	Leaf spring
10425-11	78-8060-8337-0	Screw - Self Tapping, 7SPx8
10425-12	78-8060-8172-1	Washer - Friction
10425-13	78-8134-1939-3	Washer - Tape Drum
10425-14	78-8134-1940-1	Spring - Tape Drum
10425-15	78-8060-8201-8	Nut - Self Locking, M10x1
10425-16	78-8060-8295-0	Screw - Hex.Hd, M6x16
10425-17	78-8134-1941-9	Spacer
10425-18	78-8060-8312-3	Washer - Flat, M6
10425-19	78-8060-8292-7	Screw - Hex.Hd, M6x12
10425-20	78-8134-1942-7	Tape Drum Assy - 2" Wide
10425-21	78-8060-8315-6	Washer - Flat, M10

700a-s Adjustable Case Sealer

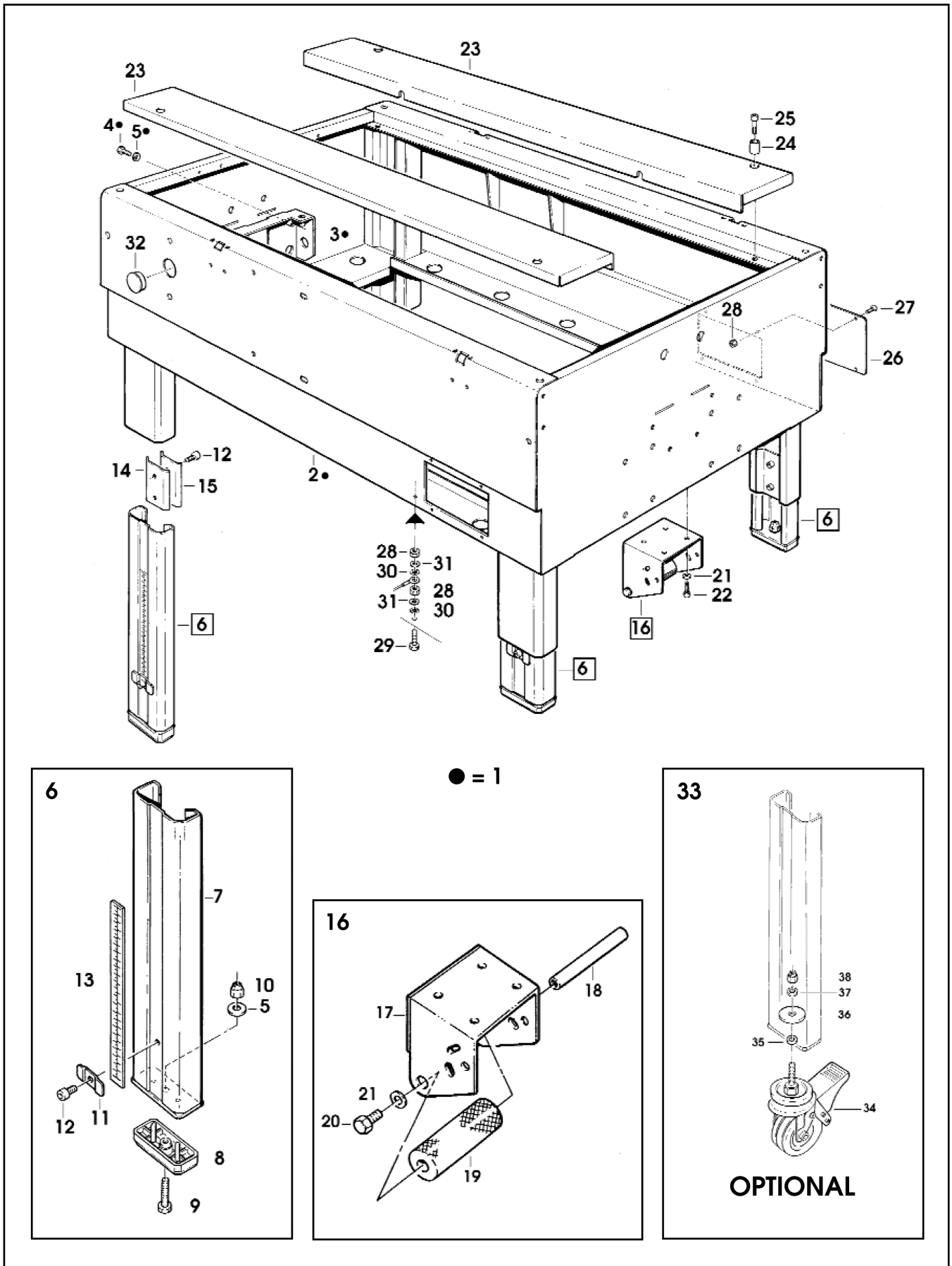


Figure 10429

Figure 10429

Ref. No.	3M Part No.	Description
10429-1	78-8134-1989-8	Conveyor Bed Assembly
10429-2	78-8134-1990-6	Bed – Conveyor
10429-3	78-8134-1991-4	Support – Drive
10429-4	78-8060-8319-8	Screw – Hex Hd, M8 x 20
10429-5	78-8060-8308-1	Washer – Plain, 8 mm
10429-6	78-8134-1992-2	Leg Assembly – Inner
10429-7	78-8134-1993-0	Leg – Inner
10429-8	78-8060-8480-8	Pad – Foot
10429-9	78-8134-1994-8	Screw – Hex Hd, M8 x 30
10429-10	78-8060-8320-6	Nut – Self Locking, M8
10429-11	78-8134-1995-5	Stop – Leg
10429-12	78-8060-8332-1	Screw – Soc Hd, M8 x 16
10429-13	78-8060-8481-6	Label – Height
10429-14	78-8060-8195-2	Clamp – Inner
10429-15	78-8060-8196-0	Clamp – Outer
10429-16	78-8134-1996-3	Support assy - Tape Bracket
10429-17	78-8134-1997-1	Support
10429-18	78-8134-1998-9	Shaft - Roller
10429-19	78-8060-8485-7	Roller
10429-20	78-8060-8295-0	Screw – Hex.Hd, M6 x 16
10429-21	78-8060-8312-3	Washer – Flat, M6
10429-22	78-8060-8331-3	Screw – Soc Hd, M6 x 16
10429-23	78-8076-4620-9	Plane – Conveyor Bed
10429-24	78-8060-8486-5	Bushing
10429-25	78-8060-8290-1	Screw – Soc Hd, M6 x 25
10429-26	78-8134-1999-7	Cover – Switch
10429-27	78-8134-2000-3	Screw – M5 x 10
10429-28	78-8060-8293-5	Nut – M5
10429-29	78-8134-1974-0	Screw – Hex Hd, M5 x 20
10429-30	78-8060-8401-4	Washer – Special
10429-31	78-8060-8303-2	Washer – Flat, M5
10429-32	78-8076-4701-7	Cap /28
10429-33	78-8060-8404-8	Caster Assembly
10429-34	78-8134-2294-2	Caster /80
10429-35	78-8060-8405-5	Spacer - Caster
10429-36	78-8060-8406-3	Washer /12-45, 5x4
10429-37	78-8060-8304-0	Washer – Flat, M12
10429-38	78-8060-8407-1	Nut – Self Locking, M12

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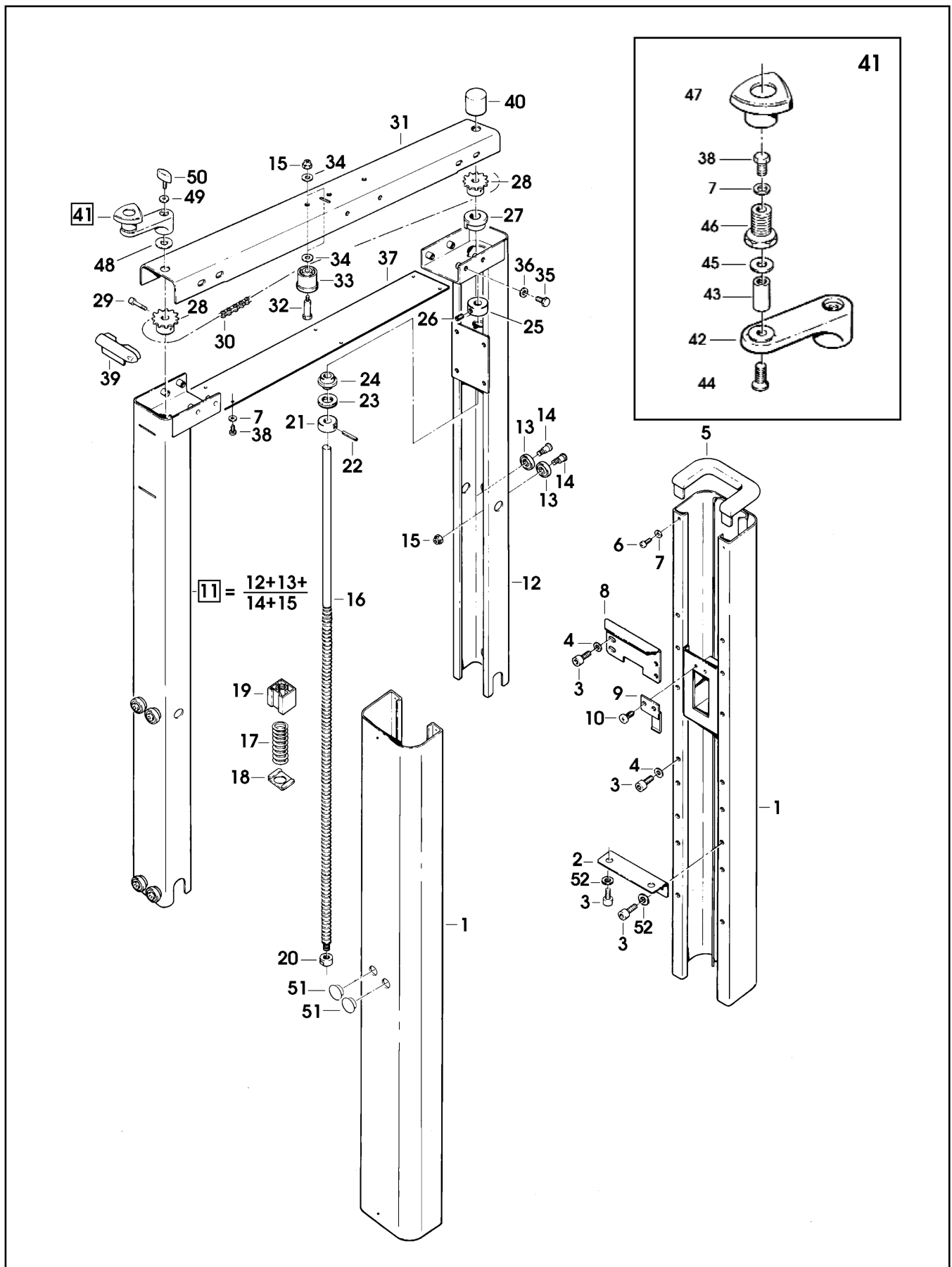


Figure 10423

Figure 10423

Ref. No.	3M Part No.	Description
10423-1	78-8134-1906-2	Column Assy - Outer
10423-2	78-8134-1907-0	Plate - Column Mounting
10423-3	78-8060-8307-3	Screw - Soc.Hd, M8x20
10423-4	78-8060-8308-1	Washer - Flat, M8
10423-5	78-8060-8491-5	Cap - Column
10423-6	78-8134-1908-8	Screw - Self Tapping, 8Px13
10423-7	78-8060-8297-6	Washer - Flat, M4
10423-8	78-8134-1909-6	Stop - Height
10423-9	78-8134-1910-4	Plate - Nut Stop
10423-10	78-8134-1911-2	Screw - Pan Hd., M5x12
10423-11	78-8134-1912-0	Column Assy - Inner
10423-12	78-8134-1913-8	Column - Inner
10423-13	78-8054-8617-8	Bearing - Special
10423-14	78-8060-8272-9	Screw - Special
10423-15	78-8060-8318-0	Nut - Self Locking, M6
10423-16	78-8134-1914-6	Lead Screw
10423-17	78-8134-1915-3	Spring
10423-18	78-8054-8970-1	Bed Plate - Spring
10423-19	78-8054-8571-7	Plastic Nut
10423-20	78-8060-8284-4	Nut - Special
10423-21	78-8060-8271-1	Collar
10423-22	78-8060-8343-8	Pin
10423-23	78-8134-1916-1	Bearing
10423-24	78-8054-8583-2	Bushing
10423-25	78-8134-1917-9	Bushing - Lead Screw
10423-26	78-8134-1918-7	Set Screw - M6x8
10423-27	78-8060-8498-0	Bushing - Inner Ccolumn
10423-28	78-8134-1919-5	Sprocket - 3/8", P=13
10423-29	78-8060-8310-7	Screw - Soc.Hd. M4x25
10423-30	78-8134-1920-3	Chain - 3/8", P=156
10423-31	78-8134-1921-1	Housing - Chain
10423-32	78-8060-8295-1	Idler Screw
10423-33	78-8070-1503-3	Roller - Chain Tensioning
10423-34	78-8060-8296-8	Washer - Triple, M6
10423-35	78-8060-8204-2	Screw - Special, M6x12
10423-36	78-8060-8312-3	Washer - Flat, M6
10423-37	78-8134-1922-9	Cover
10423-38	78-8100-0905-6	Screw - Hex.Hd. M4x10
10423-39	78-8070-1505-8	Cap - Inner Column
10423-40	78-8070-1506-6	Cover - Screw
10423-41	78-8134-1923-7	Crank Assy
10423-42	78-8076-5422-9	Crank
10423-43	78-8134-1924-5	Shaft - Crank
10423-44	78-8060-8327-1	Screw - Flat Hd, M5x16
10423-45	78-8070-1510-8	Washer - Nylon
10423-46	78-8134-1925-2	Bushing
10423-47	78-8070-1512-4	Knob
10423-48	78-8076-4800-7	Washer - Crank, Lower
10423-49	78-8134-1926-0	Washer - Crank, Upper
10423-50	78-8134-1927-8	Key - Stop
10423-51	78-8054-8821-6	Cap
10423-52	78-8060-8335-4	Washer - Triple, M8

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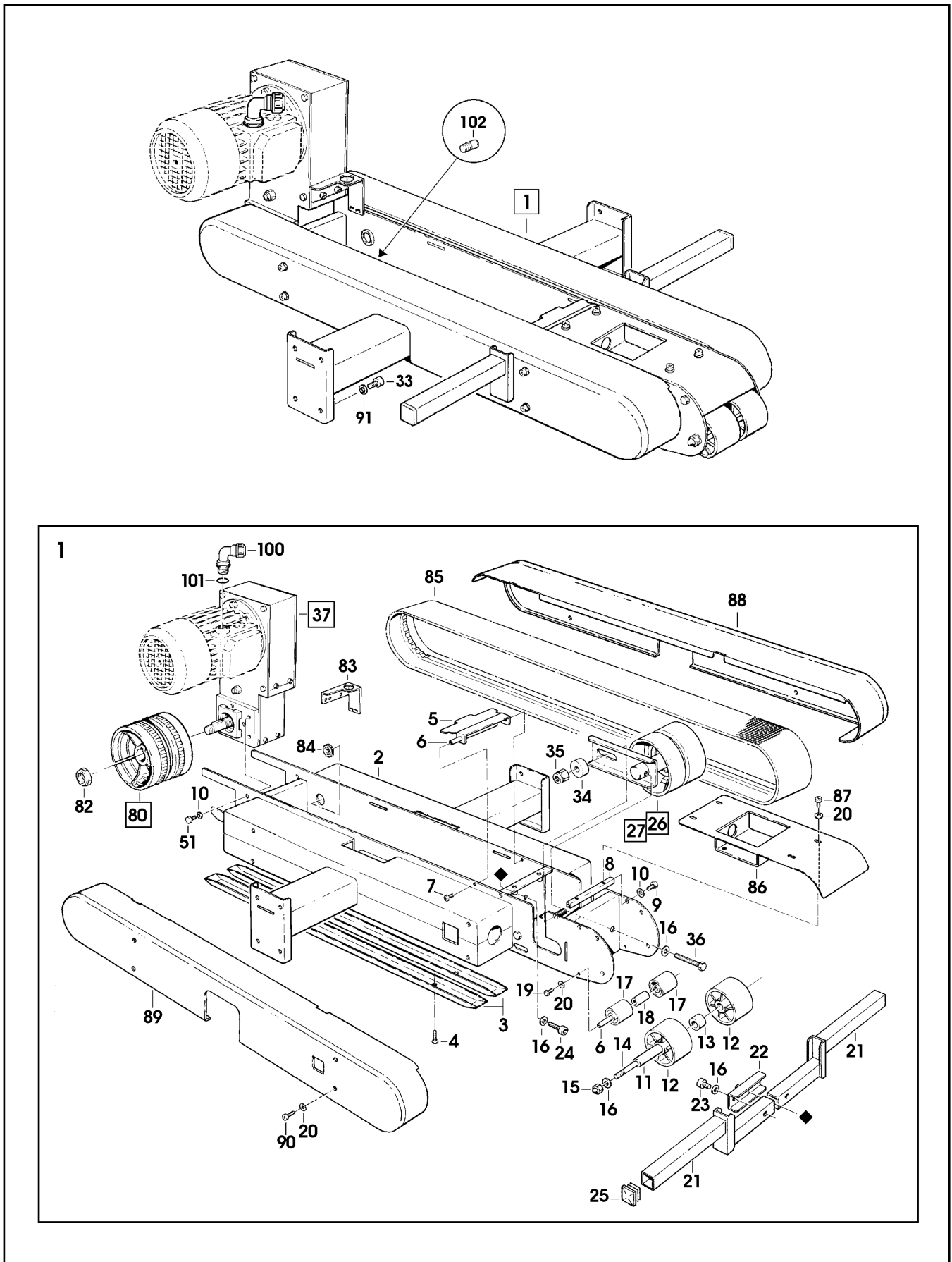


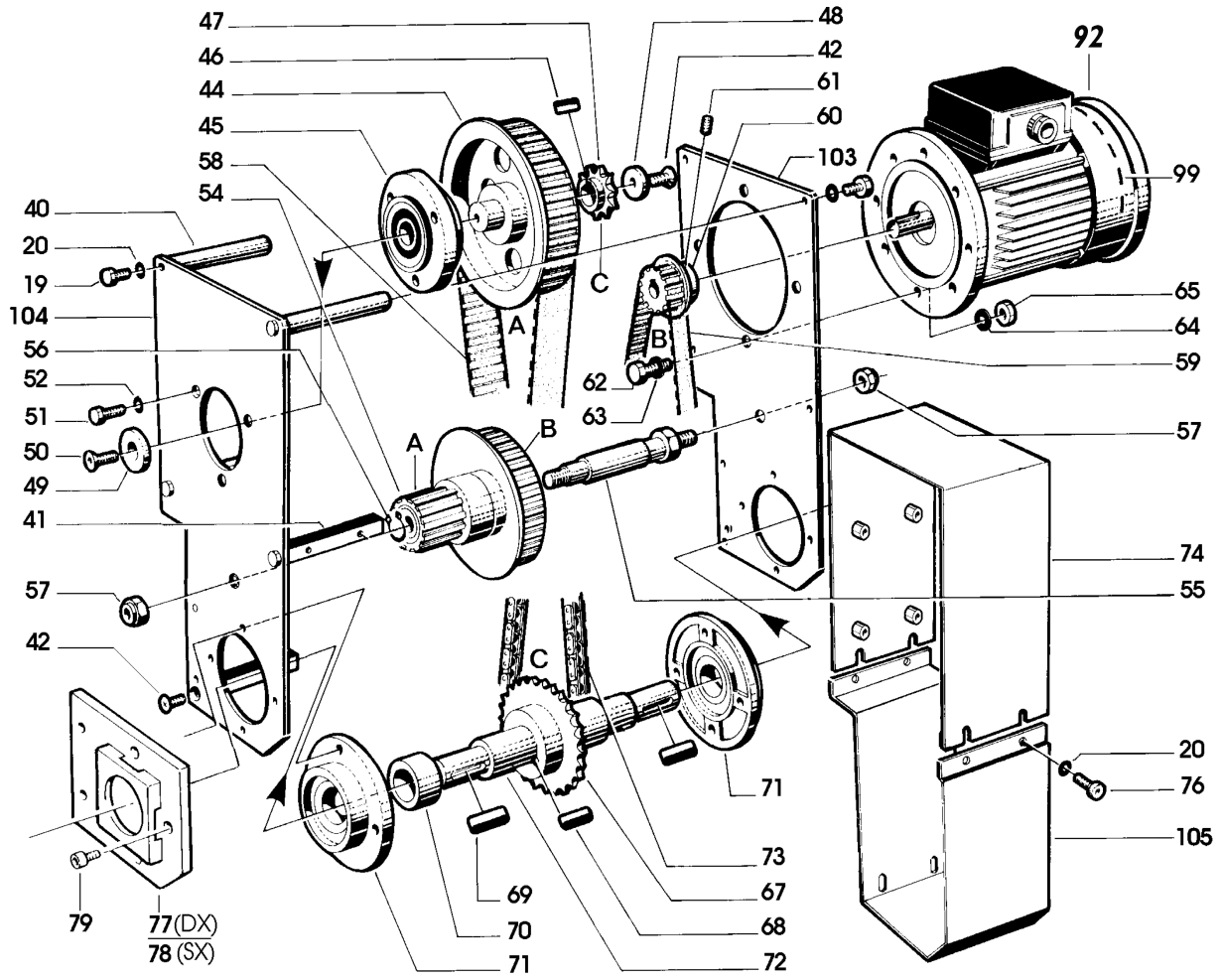
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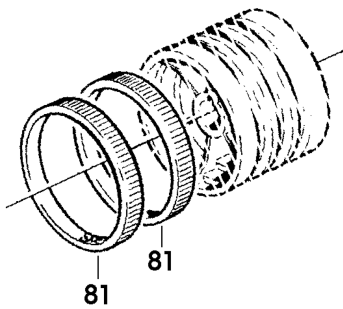
Ref. No.	3M Part No.	Description
10426-1	78-8134-1943-5	Drive Assy -Top, W/O Motor
10426-2	78-8134-1944-3	Frame - Top Drive
10426-3	78-8134-1944-3	Guide - Drive Belt
10426-4	78-8060-8333-9	Screw - Flat Hd, M5x20
10426-5	78-8134-1945-0	Clamp - Upper Head
10426-6	78-8134-1946-8	Shaft - Roller
10426-7	78-8060-8306-5	Screw - Soc.Hd, M5x10
10426-8	788134-1947-6	Spacer
10426-9	78-8060-8292-7	Screw - Hex.Hd, M6x12
10426-10	78-8060-8312-3	Washer - Flat, M6
10426-11	78-8134-1948-4	Tube - Roller
10426-12	78-8052-6641-4	Roller
10426-13	78-8070-1592-6	Spacer - Roller
10426-14	78-8134-1949-2	Shaft - Roller
10426-15	78-8134-1950-0	Nut - Special, M8
10426-16	78-8060-8308-1	Washer - FLat, M8
10426-17	78-8060-7693-7	Roller
10426-18	78-8070-1593-4	Spacer - Roller
10426-19	78-8060-8325-5	Screw - Hex.Hd, M5x12
10426-20	78-8060-8303-2	Washer - Flat, M5
10426-21	78-8134-1951-8	Support - Roller
10426-22	78-8134-1952-6	Bracket - Compression Roller
10426-23	78-8060-8307-3	Screw - Soc.Hd, M8x20
10426-24	78-8134-1953-4	Screw - Soc.Hd, M8x40
10426-25	78-8052-6652-1	Cap
10426-26	78-8134-1954-2	Belt Tensioning Assy - R/H
10426-27	78-8134-1955-9	Belt Tensioning Assy - L/H
10426-28	78-8134-1956-7	Belt Tensioning - R/H
10426-29	78-8134-1957-5	Belt Tensioning - L/H
10426-30	78-8052-6710-7	Roller - Idler
10426-31	78-8060-8248-9	Washer - Special
10426-32	78-8060-8294-3	Washer - Lock, M6
10426-33	78-8060-8331-3	Screw - Soc.Hd, M6x16
10426-34	78-8134-1958-3	Spacer - Shaft
10426-35	78-8060-8328-9	Nut - Self Locking M10
10426-36	78-8134-1959-1	Screw - Hex.Hhd, M6x60
10426-37	78-8060-8391-7	Gearbox Assy - W/O Motor
10426-40	78-8060-8282-8	Spacer
10426-41	78-8060-8281-0	Spacer
10426-42	78-8060-8330-5	Screw - Flat Hd, M5x12
10426-44	78-8060-8372-7	Pulley - Timing Belt
10426-45	78-8060-8373-5	Support - Pulley
10426-46	78-8060-8336-2	Key 4x4x10
10426-47	78-8060-8279-4	Sprocket - 3/8", 11 Teeth
10426-48	78-8060-8269-5	Washer - 5,5/20x4
10426-49	78-8060-8243-0	Washer - 6,5/30x5
10426-50	78-8060-8299-2	Screw - Flat Hd, M6x16
10426-51	78-8060-8301-6	Screw - Hex.Hd, M6x20

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27 (SX)

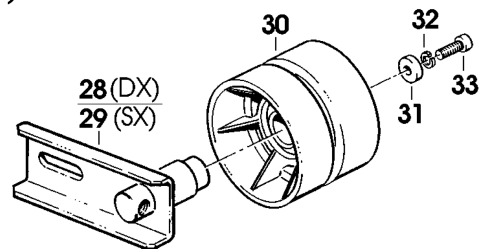


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Ref. No.	3M Part No.	Description
104-26-52	78-8060-8296-8	Washer - Triple, M6
104-26-54	78-8060-8370-1	Pulley - Reducer
104-26-55	78-8060-8280-2	Shaft - Pulley
104-26-56	78-8060-8314-9	E-ring - 10 mm
104-26-57	78-8060-8320-6	Nut - Self Locking M8
104-26-58	78-8057-5808-9	Belt - Timing, 187L100
104-26-59	78-8057-5724-8	Belt - Timing, 187L050
104-26-60	78-8060-8283-6	Pulley - Timing, 11 teeth
104-26-61	78-8060-8326-3	Set Screw - M5x6
104-26-62	78-8060-8302-4	Screw - Hex.Hd, M8x25
104-26-63	78-8060-8335-4	Washer - Triple, M8
104-26-64	78-8060-8302-4	Lockwasher - M8
104-26-65	78-8060-8289-3	Nut - M8
104-26-67	78-8060-8277-8	Sprocket - 3/8", 28 teeth
104-26-68	78-8060-8316-4	Key 6x6x20
104-26-69	78-8060-83131	Key 5x5x30
104-26-70	78-8060-8278-6	Bushing
104-26-71	78-8060-8374-3	Flange - Shaft
104-26-72	78-8060-8352-9	Shaft - Drive
104-26-73	78-8060-8345-3	Chain - 3/8", 57 pitch
104-26-74	78-8060-8233-1	Cover - Top
104-26-76	78-8060-8322-2	Screw - Soc.Hd, M5x12
104-26-77	78-8076-4585-4	Support - Bearing, R/H
104-26-78	78-8076-4586-2	Support - Bearing, L/H
104-26-79	78-8060-8322-2	Screw - Soc.Hd, M5x12
104-26-80	78-8060-8371-9	Pulley Assy - Drive
104-26-81	78-8052-6713-1	Ring - Pulley
104-26-82	78-8060-8351-1	Nut - Self Locking, M20x1
104-26-83	78-8134-1960-9	Bracket
104-26-84	78-8076-4702-5	Grommet /28
104-26-85	78-8070-1531-4	Belt - Drive, Laced
104-26-86	78-8134-1961-7	Cover - Upper, Front
104-26-87	78-8134-1962-5	Screw - Pan Hd., M5x10
104-26-88	78-8134-1963-3	Guard - Belt, R/H
104-26-89	78-8134-1964-1	Guard - Belt, L/H
104-26-90	78-8134-1965-8	Screw - Pan Hd., M5x16
104-26-91	78-8134-1966-6	Washer - Special
104-26-92	78-8076-4994-8	Motor - 110V 60Hz 1Ph, IP56
104-26-99	78-8076-5372-6	Fan - Motor
104-26-100	78-8076-4532-6	Cord Grip ST11
104-26-101	78-8114-4601-8	Gasket
104-26-102	78-8134-1967-4	Stud - Mounting
104-26-103	78-8060-8230-7	Frame - R/H
104-26-104	78-8060-8231-5	Frame - L/H
104-26-105	78-8060-8232-3	Cover - Bottom

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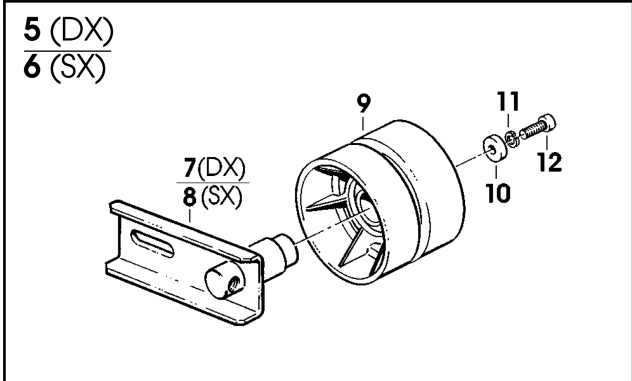
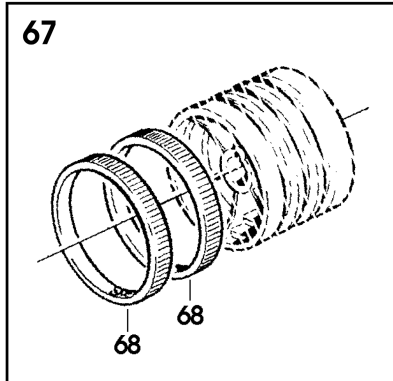
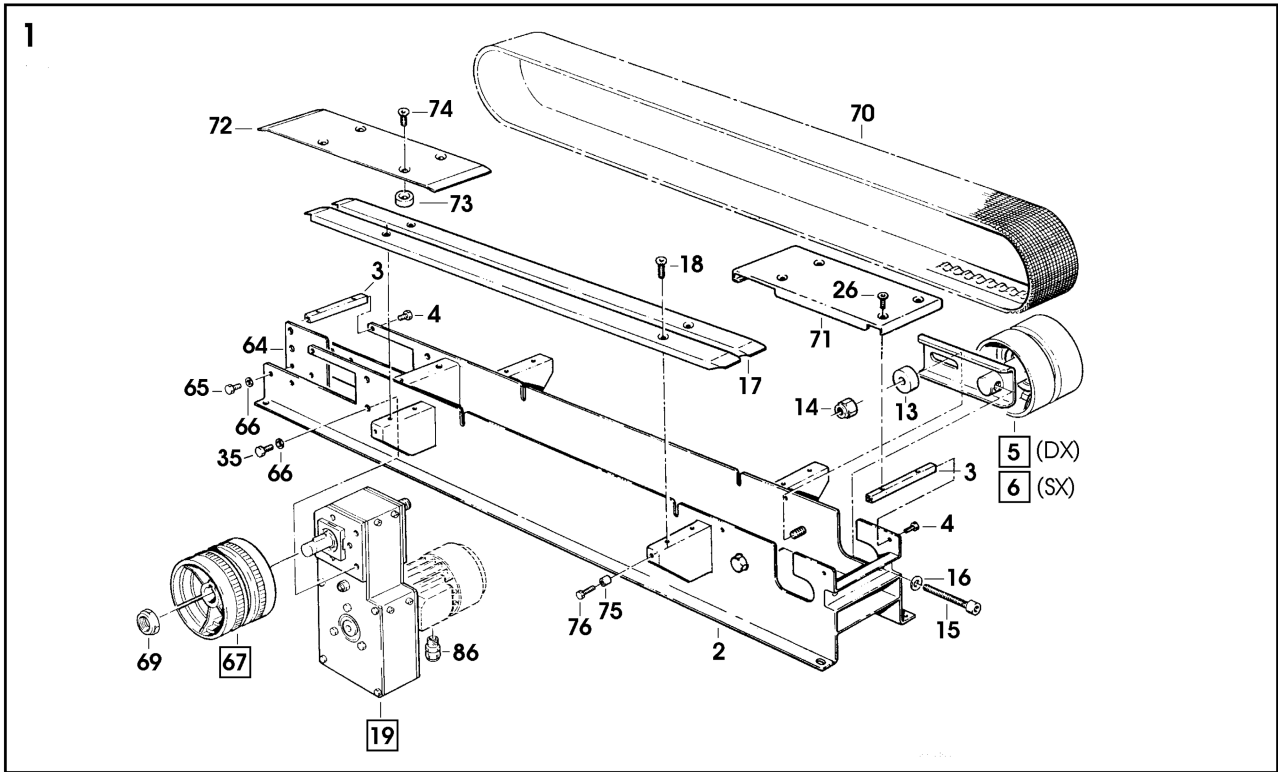
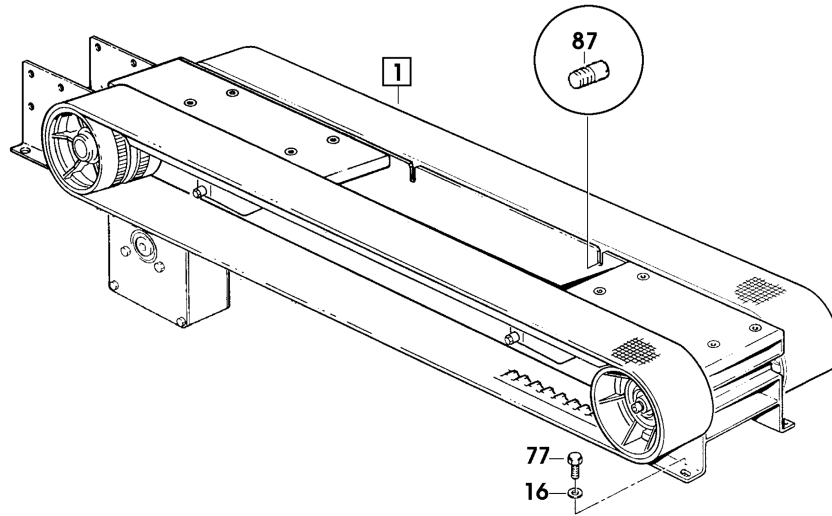


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Ref. No.	3M Part No.	Description
10427-1	78-8134-1969-0	Drive Assy - Bottom, W/O Motor
10427-2	78-8134-1970-8	Frame - Bottom Drive
10427-3	78-8134-1947-6	Spacer
10427-4	78-8060-8292-7	Screw - Hex.Hd, M6x12
10427-5	78-8134-1954-2	Belt Tensioning Assy - R/H
10427-6	78-8134-1955-9	Belt Tensioning Assy - L/H
10427-7	78-8134-1956-7	Belt Tensioning - R/H
10427-8	78-8134-1957-5	Belt Tensioning - L/H
10427-9	78-8052-6710-7	Roller - Idler
10427-10	78-8060-8248-9	Washer - Special
10427-11	78-8060-8294-3	Washer - Lock, M6
10427-12	78-8060-8331-3	Screw - Soc.Hd, M6x16
10427-13	78-8134-1958-3	Spacer - Shaft
10427-14	78-8060-8328-9	Nut - Self Locking M10
10427-15	78-8134-1971-6	Screw - Soc.Hd, M8x70
10427-16	78-8060-8308-1	Washer - Flat, M8
10427-17	78-8134-1944-3	Guide - Drive Belt
10427-18	78-8060-8333-9	Screw - flat hd, M5x20
10427-19	78-8060-8391-7	Gearbox Assy - W/O Motor
10427-22	78-8060-8282-8	Spacer
10427-23	78-8060-8281-0	Spacer
10427-24	78-8060-8325-5	Screw - Hex.Hd, M5x12
10427-25	78-8060-8303-2	Washer - Flat, M5
10427-26	78-8060-8330-5	Screw - Flat Hd, M5x12
10427-28	78-8060-8372-7	Pulley - Timing Belt
10427-29	78-8060-8373-5	Support - Pulley
10427-30	78-8060-8336-2	Key 4x4x10
10427-31	78-8060-8279-4	Sprocket - 3/8", 11 teeth
10427-32	78-8060-8269-5	Washer - 5,5/20x4
10427-33	78-8060-8243-0	Washer - 6,5/30x5
10427-34	78-8060-8299-2	Screw - Flat Hd, M6x16
10427-35	78-8060-8301-6	Screw - Hex.Hd, M6x20
10427-36	78-8060-8296-8	Washer - Triple, M6
10427-38	78-8060-8370-1	Pulley - Reducer
10427-39	78-8060-8280-2	Shaft - Pulley
10427-40	78-8060-8314-9	E-ring - 10 mm
10427-41	78-8060-8320-6	Nut - Self Locking M8
10427-42	78-8057-5808-9	Belt - Timing, 187L100
10427-43	78-8057-5724-8	Belt - Timing, 187L050
10427-44	78-8060-8283-6	Pulley - Timing, 11 teeth
10427-45	78-8060-8326-3	Set Screw - M5x6

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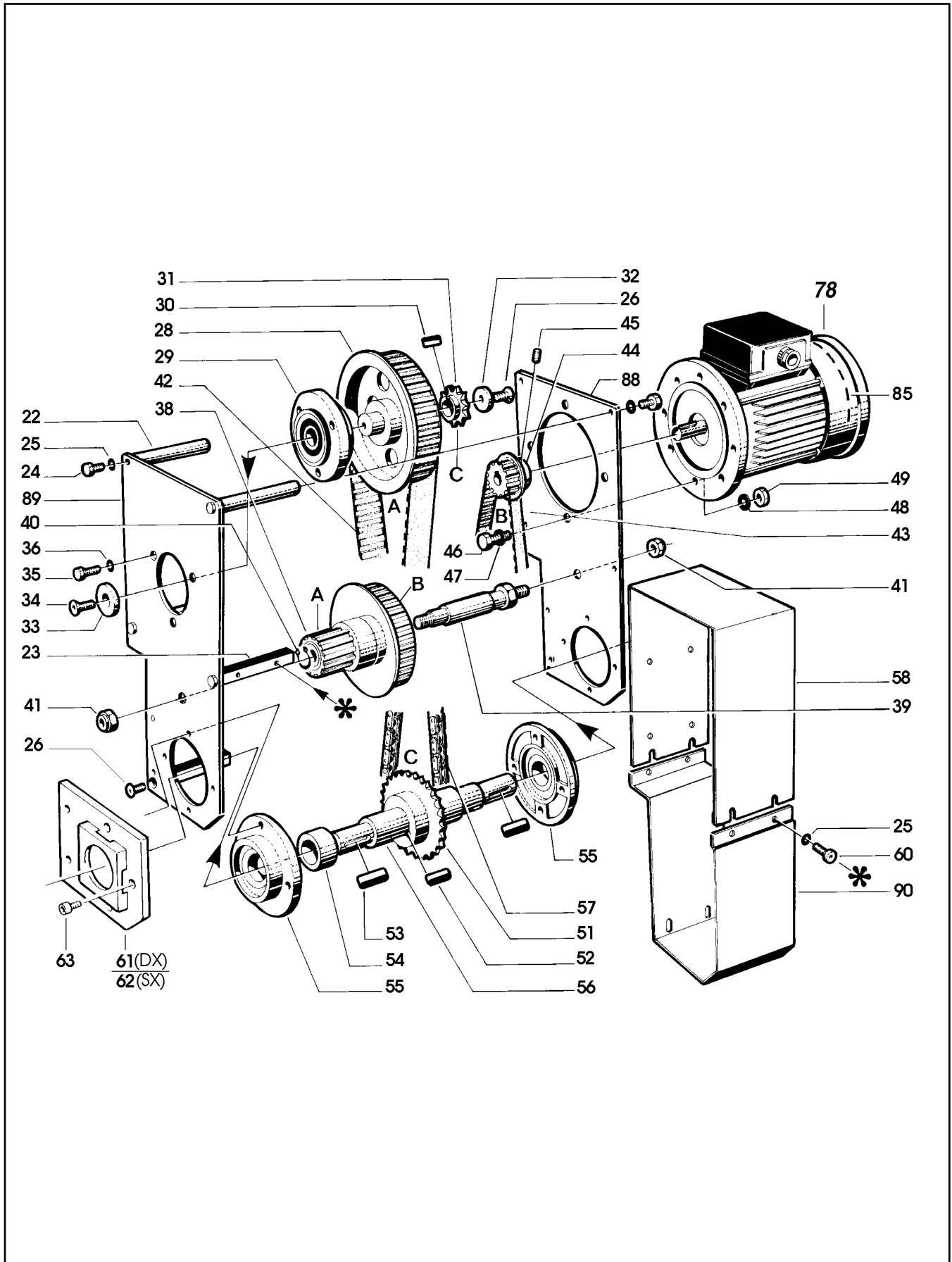


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Ref. No.	3M Part No.	Description
10427-46	78-8060-8302-4	Screw - Hex.Hd, M8x25
10427-47	78-8060-8335-4	Washer - Triple, M8
10427-48	78-8060-8302-4	Lockwasher - M8
10427-49	78-8060-8289-3	Nut - M8
10427-51	78-8060-8277-8	Sprocket - 3/8", 28 teeth
10427-52	78-8060-8316-4	Key 6x6x20
10427-53	78-8060-8313-1	Key 5x5x30
10427-54	78-8060-8278-6	Bushing
10427-55	78-8060-8374-3	Flange - Shaft
10427-56	78-8060-8352-9	Shaft - Drive
10427-57	78-8060-8345-3	Chain - 3/8", 57 pitch
10427-58	78-8060-8233-1	Cover - Top
10427-60	78-8060-8322-2	Screw - Soc.Hd, M5x12
10427-61	78-8076-4585-4	Support - Bearing, R/H
10427-62	78-8076-4586-2	Support - Bearing, L/H
10427-63	78-8060-8322-2	Screw - Soc.Hd, M5x12
10427-64	78-8134-1972-4	Bracket - Roller, Rear
10427-65	78-8060-8292-7	Screw - Hex.Hd, M6x12
10427-66	78-8060-8312-3	Washer - Flat, M6
10427-67	78-8060-8371-9	Pulley Assy - Drive
10427-68	78-8052-6713-1	Ring - Pulley
10427-69	78-8060-8351-1	Nut - Self Locking, M20x1
10427-70	78-8070-1531-4	Belt - Drive, Laced
10427-71	78-8070-1584-3	Cover - Drive, Front
10427-72	78-8076-4618-3	Cover - Drive, Rear
10427-73	78-8060-8267-9	Spacer
10427-74	78-8060-8327-1	Screw - Flat Hd, M5x16
10427-75	78-8134-1973-2	Stud - Side Plate
10427-76	78-8134-1974-0	Screw - Hex Hd, M5x20
10427-77	78-8060-8323-0	Screw - Hex Hd, M8x16
10427-78	78-8076-4994-8	Motor - 110V 60Hz 1Ph, IP56
10427-85	78-8076-5372-6	Fan - Motor
10427-86	78-8076-4532-6	Cord Grip ST11
10427-87	78-8134-1967-4	Stud - Mounting
10427-88	78-8060-8230-7	Frame - R/H
10427-89	78-8060-8231-5	Frame - L/H
10427-90	78-8060-8232-3	Cover - Bottom

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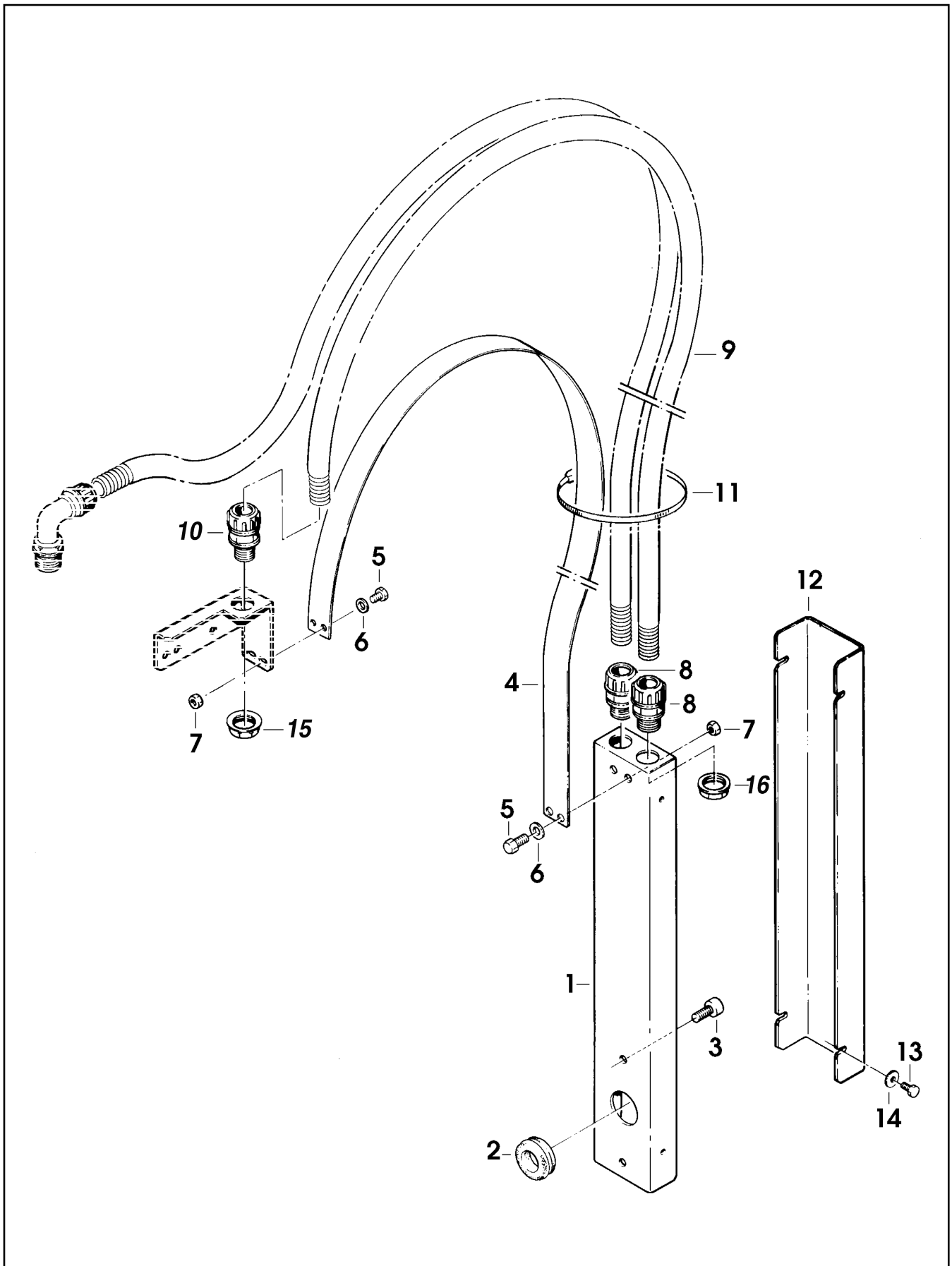


Figure 10424

Figure 10424

Ref. No.	3M Part No.	Description
10424-1	78-8134-1928-6	Housing - Wire
10424-2	78-8076-4702-5	Grommet /28
10424-3	78-8060-8332-1	Screw - Soc.Hd, M8x16
10424-4	78-8134-1929-4	Strap - Wire
10424-5	78-8060-8300-8	Screw - Hex.Hd, M5x10
10424-6	78-8060-8303-2	Washer - Flat, M5
10424-7	78-8060-8293-5	Nut - M5
10424-8	78-8076-4715-7	Cord Grip ST13,5
10424-9	78-8134-1975-7	Cable - 491P 3 G 1.5, 6 mt
10424-10	78-8076-4532-6	Cord Grip ST11
10424-11	78-8060-8029-3	Clamp
10424-12	78-8134-1931-0	Cover - Housing
10424-13	78-8100-0905-6	Screw - Hex.Hd, M4x10
10424-14	78-8134-1932-8	Washer - Triple, M4
10424-15	78-8076-4645-6	Nut - Lock, GMP11
10424-16	78-8076-5211-6	Nut - Lock, GMP13,5

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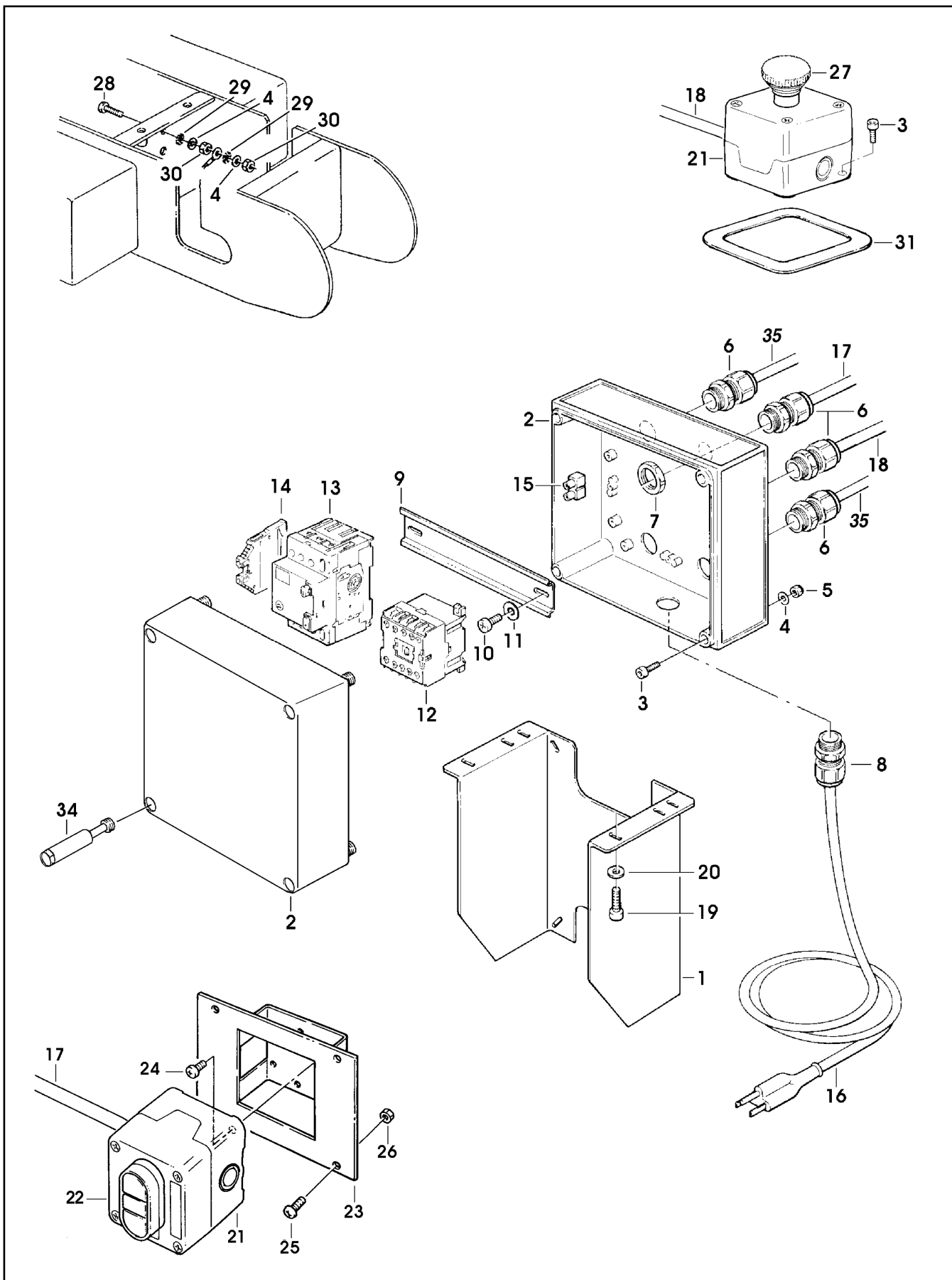


Figure 10430

Figure 10430

Ref. No.	3M Part No.	Description
10430-1	78-8134-2001-1	Support - Electric Box
10430-2	78-8113-6759-4	Electric Box
10430-3	78-8094-6381-9	Screw - Soc.Hd, M4x15
10430-4	78-8060-8297-6	Washer - Flat, M4
10430-5	78-8060-8321-4	Nut - Self Locking, M4
10430-6	78-8076-4715-7	Cord Grip ST13,5
10430-7	78-8076-5211-6	Nut - Lock GMP 13,5
10430-9	78-8094-6382-7	Guide - Mounting
10430-10	78-8028-8208-0	Screw - Self Tapping, 6Px9,5
10430-11	78-8017-9018-5	Washer - Triple, M4
10430-12	78-8094-6383-5	Contactactor - Allen Bradley 10E
10430-13	78-8076-5378-3	Switch - Allen Bradley 3-25
10430-14	78-8094-6384-3	Clamp
10430-15	78-8076-4968-2	Terminal
10430-16	78-8028-7909-4	Power Cord
10430-17	78-8100-1038-5	Cable - 3x20 AWG, 5 mt
10430-18	78-8060-8053-3	Cable - 3-pole, 5 mt
10430-19	78-8060-8331-3	Screw - Soc.Hd, M6x16
10430-20	78-8060-8312-3	Washer - Flat, M6
10430-21	78-8076-5194-4	Box - E-Stop
10430-22	78-8094-6386-8	Switch - ON/OFF
10430-23	78-8134-2002-9	Support - ON/OFF Sswitch
10430-24	78-8017-9257-9	Screw - Pan Hd, M5x12
10430-25	78-8134-2000-3	Screw - M5x10
10430-26	78-8060-8293-5	Nut - M5
10430-27	26-1014-5845-8	E-Stop W/Latch
10430-28	78-8134-2003-7	Screw - Hex.hd, M4x20
10430-29	78-8134-2004-5	Washer - Triple, M4
10430-30	78-8060-8414-7	Nut - M4
10430-31	78-8134-2005-2	Collar
10430-33	78-8114-4896-4	Box - ON/OFF
10430-35	78-8134-1975-7	Cable - 491P 3G 1.5, 6 mt

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