



## Instructions and Parts List

# 3M-Matic™

# 300cf

# Case Former

Type 29800

**For Use With 3M-Matic™:**

**100a Type 29600, 120a Type 19700,  
120a3 Type 19700, 120ab Type 19700,  
200a Type 39600, 700a Type 39600,  
800a Type 39600, 800a3 Type 39600,  
800ab Type 39600 Case Sealers**

Note: The 300cf is not compatible with the Low  
Tape Sensor Kit or outboard tape roll mounting

Serial No. \_\_\_\_\_

For reference, record machine serial number here.



### Important Safety Information

Read "Important Safeguards",  
pages 3 and 4, BEFORE  
INSTALLING OR  
OPERATING THIS  
EQUIPMENT.

**3M Packaging Systems Division**

3M Center, Building 220-8W-01  
St. Paul, MN 55144-1000

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St. Paul, MN 55144-1000

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## To Our Customers:

**This is the 3M-Matic™/AccuGlide™/Scotch™ brand equipment you ordered. It has been set up and tested in the factory with "Scotch" brand tapes. If technical assistance or replacement parts are needed, call or Fax the appropriate number listed below.**

### 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 715/381 0248.

### Replacement Parts

Order parts by part number, part description and quantity required. Also 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.



#### **3M Packaging Systems Division**

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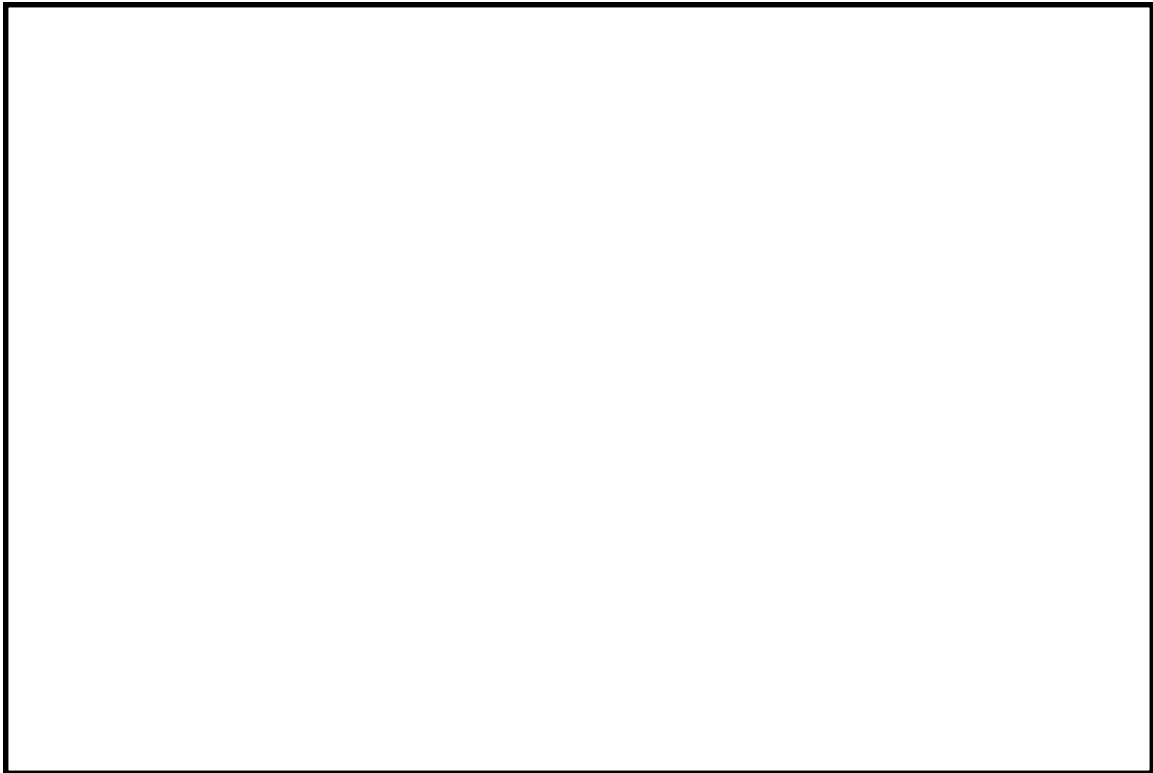
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## To Our Customers:

**This is the 3M-Matic™/AccuGlide™/Scotch™ brand equipment you ordered. It has been set up and tested in the factory with "Scotch" brand 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.**

### SERVICE AND PARTS AVAILABLE DIRECT FROM:



Order parts by part number, part description and quantity required. Also include machine name, number and type.



#### **3M Packaging Systems Division**

3M Center, Building 220-8W-01  
St. Paul, MN 55144-1000  
1-800/328 1390

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# Instruction Manual

## 300cf Case Former Type 29800

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<b>Table of Contents</b>	<b>Page</b>
Intended Use .....	1
Equipment Warranty and Limited Remedy .....	2
Contents .....	2
Important Safeguards .....	3 - 4
Specifications .....	5 - 6
Air Power Requirements .....	5
Box Board .....	5
Box Weight and Size Capacities .....	5
Operating Conditions .....	5
Machine Dimensions .....	6
Installation and Set-Up .....	7 - 9
Receiving and Handling .....	7
Machine Set-Up .....	7 - 9
Operation .....	11 - 14
Manual/Automatic Mode .....	12
Emergency Stop Button .....	13
Reset Button .....	13
Box Centering Guides .....	13
Box Ejector .....	13
Manual Operating Procedure .....	13
Automatic Operating Procedure .....	14
Maintenance .....	15
Cleaning of the Machine .....	15
Lubrication .....	15
Pneumatic Diagram .....	16 - 17
Parts and Service Information .....	19
Replacement Parts Illustrations and Parts List.....	21 - 37

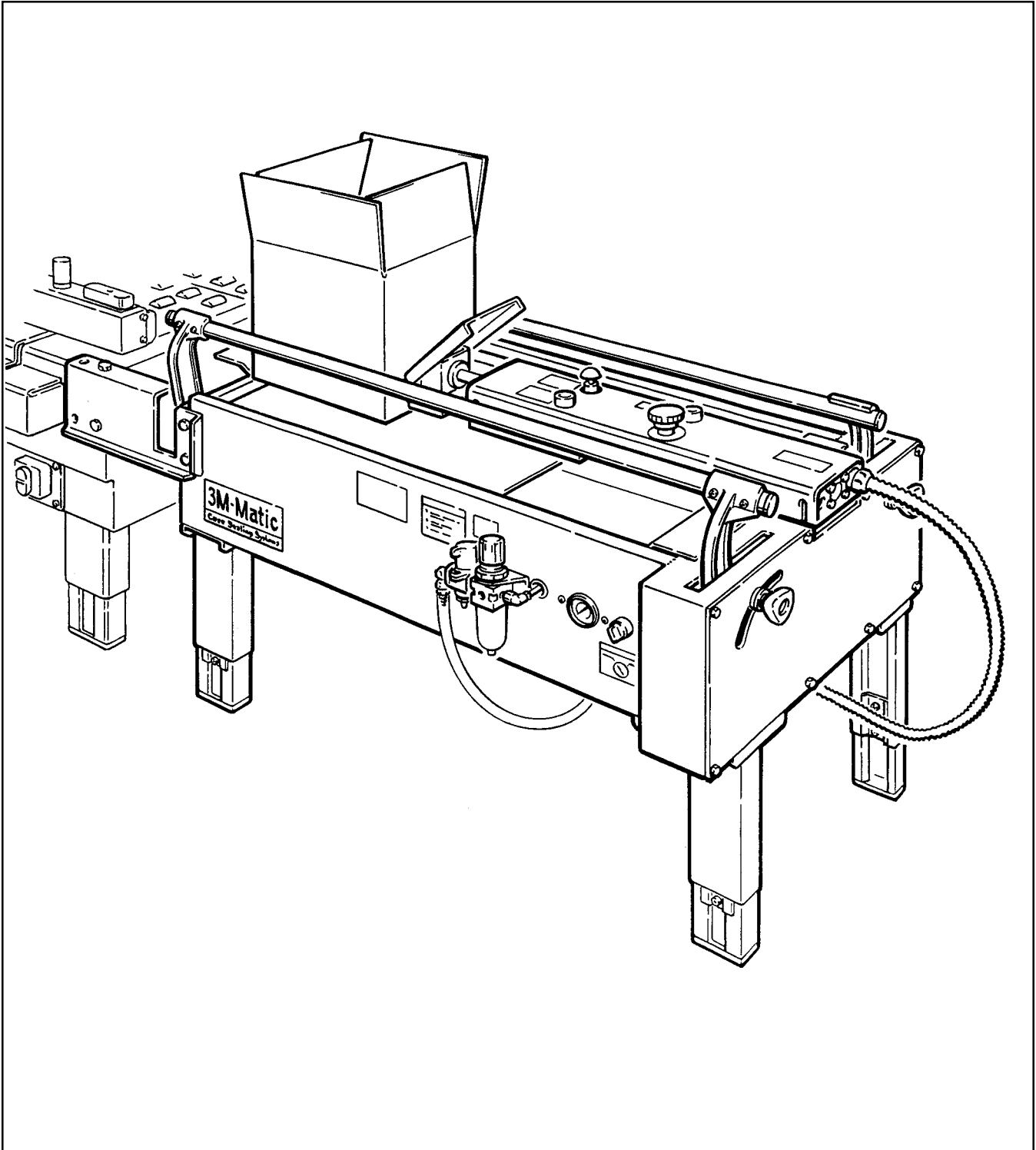
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## Intended Use

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The **3M-Matic™ 300cf Case Former** has been designed and tested for use with the following 3M-Matic™ case sealers:

100a, 120a, 120a3, 120ab, 200a, 700a, 800a, 800a3 and 800ab. A regular slotted carton is placed on the center rail of the case former and the bottom side flaps are automatically closed by the machine. A pneumatic device pushes the carton into the case sealer for bottom sealing of the carton.



**3M-Matic™ 300cf Case Former, Model 29800 (Shown installed with 800a Case Sealer).**

**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 warrants that its **3M-Matic™ 300cf Case Former, Type 29800** will be free from defects for ninety (90) days after delivery. If any part is proved to be defective within the warranty period, then the exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to repair or replace the part, provided the defective part is returned immediately to 3M's factory or an authorized service station designated by 3M. A part will be presumed to have become defective after the warranty period unless the part is received or 3M is notified of the problem no later than five (5) calendar days after the warranty period. If 3M is unable to repair or replace the part within a reasonable time, then 3M, at its option, will replace the equipment or refund the purchase price. 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.

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## **Contents – 300cf Case Former**

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- (1) 300cf Case Former, Type 29800
- (1) Tool/Spare Parts Kit, P/N 78-8111-1356-8
- (1) Instruction and Parts Manual

## Important Safeguards



This safety alert symbol identifies important safety 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 78-8119-6942-3 is available as a stock item or individual labels can be ordered. See Parts Illustration/List, pages 36 and 37.

The "**Warning – Air Pressure**" label, shown in **Figure 1-1**, is attached next to the return stroke air pressure regulator. The regulator is located behind the pneumatic compartment cover and is factory adjusted. No operator adjustment is required.



Figure 1-1 – Air Pressure Warning Label

The "**Emergency Stop**" label, shown in **Figure 1-2**, is attached to the top of the adjustable carton ejector assembly around the E-Stop push-button. The label reminds operators and casual personnel of the function of this switch.

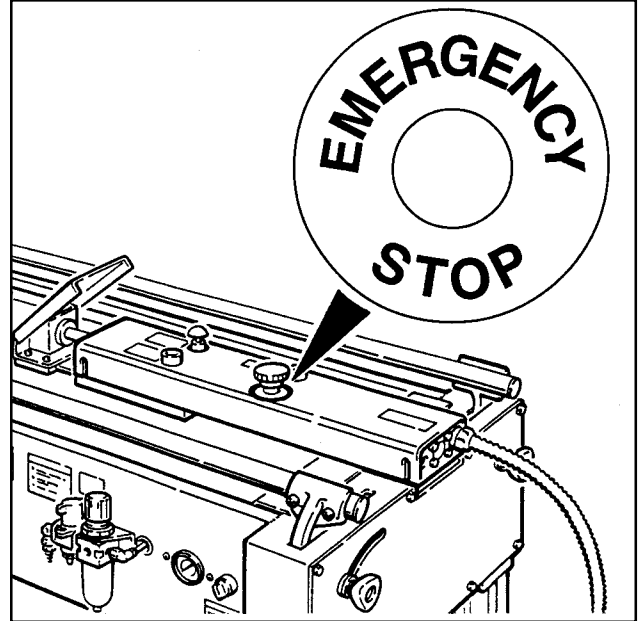


Figure 1-2 – Emergency Stop Label

The "**Re-Set**" label, shown in **Figure 1-3**, is attached to the top of the adjustable carton ejector next to the "Reset" push-button. The "Reset" push-button must be pushed to restore air supply after stopping machine with E-Stop switch.



Figure 1-3 – Reset Label

## Important Safeguards (Continued)

The "Safety Instructions" label, shown in **Figure 1-4**, is attached on the left side of the machine frame. The label provides convenient safeguard instructions for the operator and service personnel.

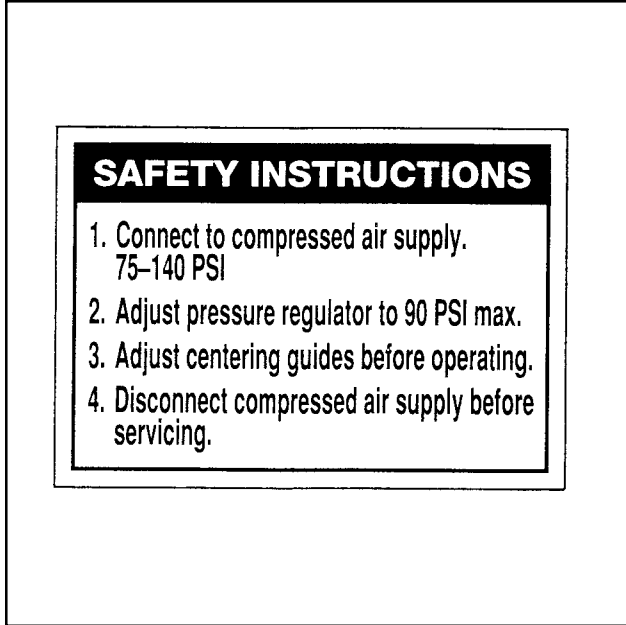


Figure 1-4 – Safety Instructions Label

The "Air Pressure – On/Off" label, shown in **Figure 1-5**, is attached on the left side of the machine frame above the On/Off valve. The label reminds operators of the location of the pneumatic On/Off valve,

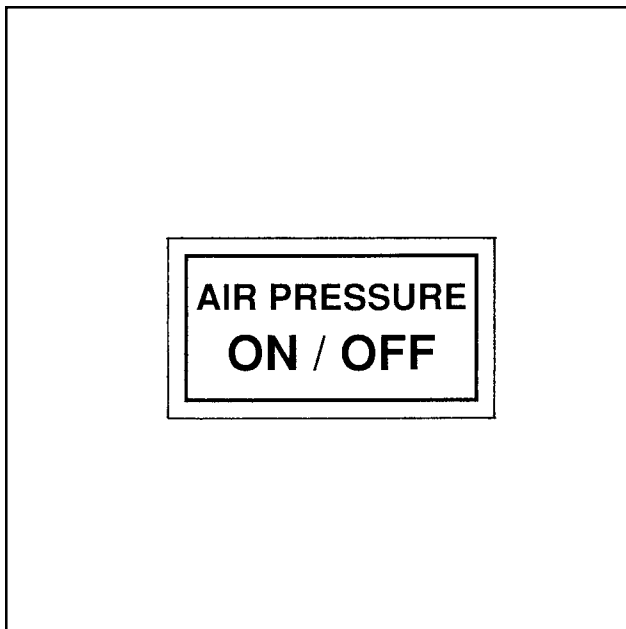


Figure 1-5 – Air On/Off Label

The "Operation Mode" label, shown in **Figure 1-6** is attached on the left side of the machine frame below the Manual/Automatic switch. The label indicates the correct position of the switch for manual or automatic operation.

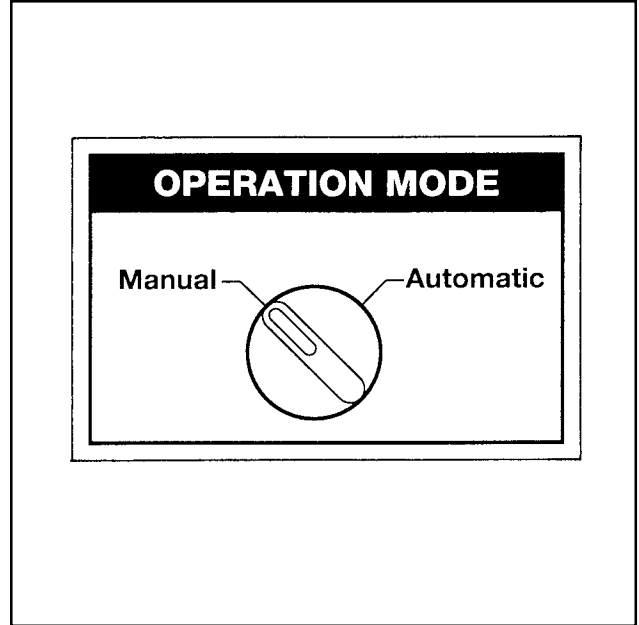


Figure 1-46– Operation Mode Label

The "Ram Adjust" and "Box Ejector" labels, shown in **Figure 1-7** are attached to the top of the adjustable carton ejector. The labels remind operators of the function of the push-button switch and the adjustment detent knob.

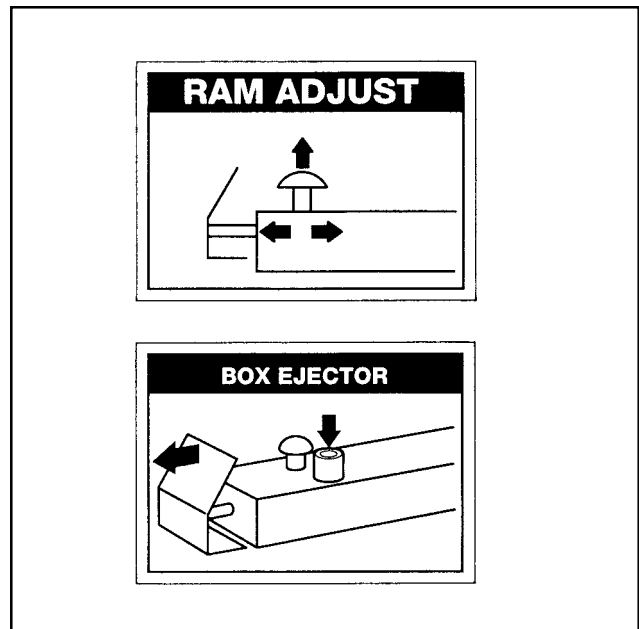


Figure 1-7 – Ram Adjust and Box Ejector Labels



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# Specifications

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## Air Power Requirements

517 kPa minimum gauge pressure, 6.0 m<sup>3</sup>/h @ 21°C, 101 kPa maximum at maximum cycle rate [75 PSIG minimum gauge pressure, 3.5 SCFM maximum at maximum random cycle rate]. A pressure regulator-filter is included. For best operation set pressure regulator to 90 PSIG.

## Box Board

125 to 275 P.S.I. bursting test, single wall B, or C flute.  
Boxes should be well scored for proper performance.

## Box Weight and Size Capacities

A. Box weight, filled – 2.3 kg [5 lbs] minimum to 37 kg [80 lbs] maximum.

B . Sizes:	Minimum	Maximum
Length	205 mm [8.0 inch]	600 mm [23.5 inch]
Width	205 mm [8.0 inch]	545 mm [21.5 inch]
Height	100 mm [4.0 inch]	limited by case sealer

**Note:** The box size capacities for the 300cf may be limited by the capacity of the case sealer in some instances.

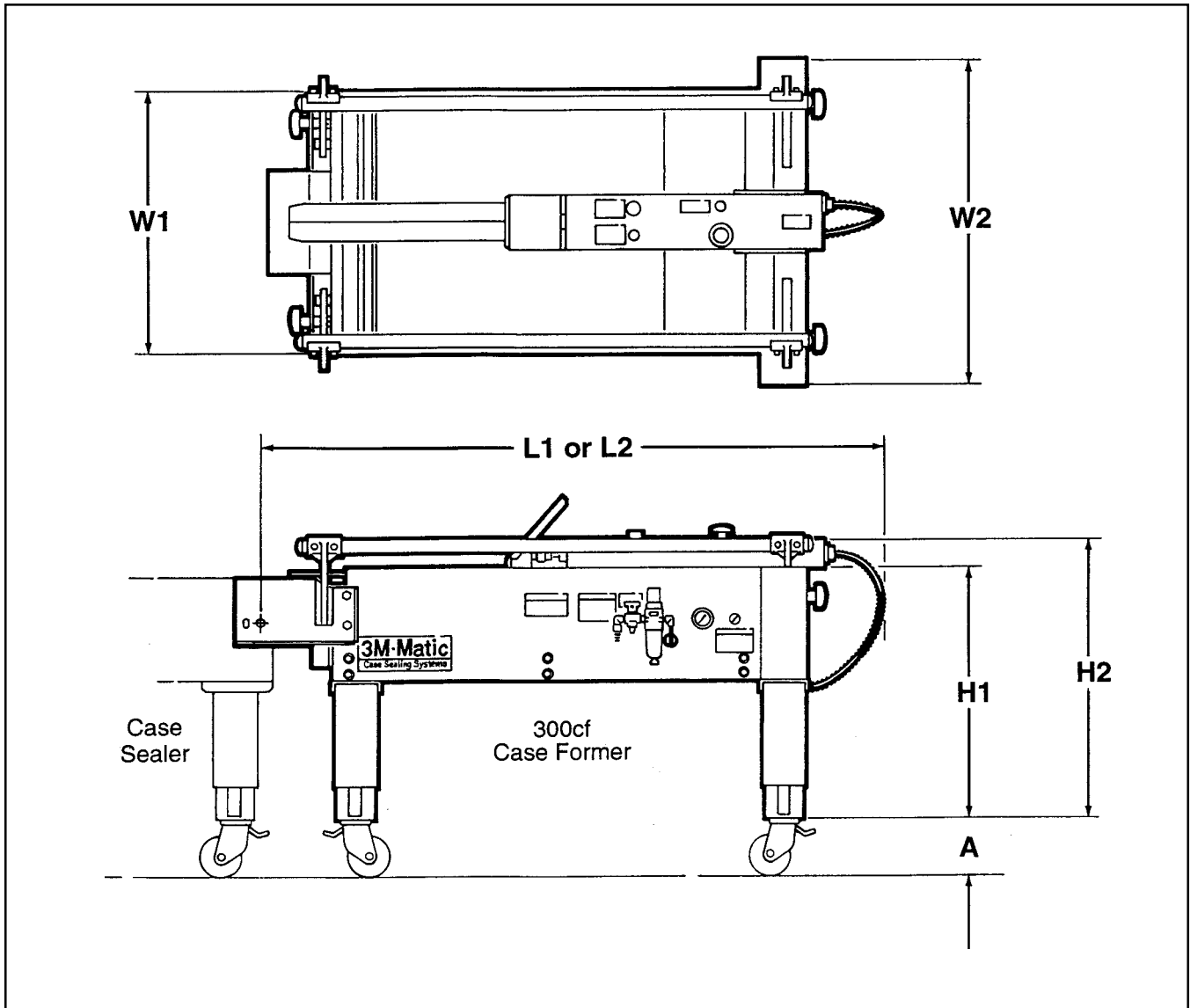
## Operating Conditions

Use in dry, relatively clean environments at 5° to 40° C [40° to 105° F] with clean dry boxes.

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

(Specifications continued on next page.)

## Specifications (Continued)



### Machine Dimensions

	A <sup>1</sup>	H1 <sup>2</sup>	H2 <sup>2</sup>	L1 <sup>3,5</sup>	L2 <sup>4,5</sup>	W1	W2
<b>Minimum</b>							
mm	120	610	685	1375	1385	615	765
[Inches]	[4.81]	[24.0]	[27.0]	[54.1]	[54.6]	[24.3]	[30.2]
<b>Maximum</b>							
mm	120	775	850	1705	1715	615	765
[Inches]	[4.81]	[30.5]	[33.5]	[67.1]	[67.6]	[24.3]	[30.2]

- ① Casters are optional
- ② Includes the height of a plastic foot which is removed if casters are used.
- ③ L1 is 300cf Case Former connected to 120a, 120a3
- ④ L2 is 300cf Case Former connected to 100a, 200a, 700a, 800a, 800a3
- ⑤ Add 30 mm to these dimensions when connecting to a 120ab or 800ab

Weight – Approximate 86 kg [190 pounds] crated (approximate)  
 Approximate 75 kg [165 pounds] uncrated (approximate)

# Installation and Set-Up

## Receiving And Handling

After the machine has been uncrated, examine the case former 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

**Important** – Read "Warnings", on page 12, before attempting to set up the case former for operation.

For future reference, record machine serial number on front cover of this manual in the space provided.

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

**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.

1. Follow "Unpacking Instructions" label attached to corrugated packing cover.

Use appropriate material handling equipment to remove the machine from the pallet and move it into position.

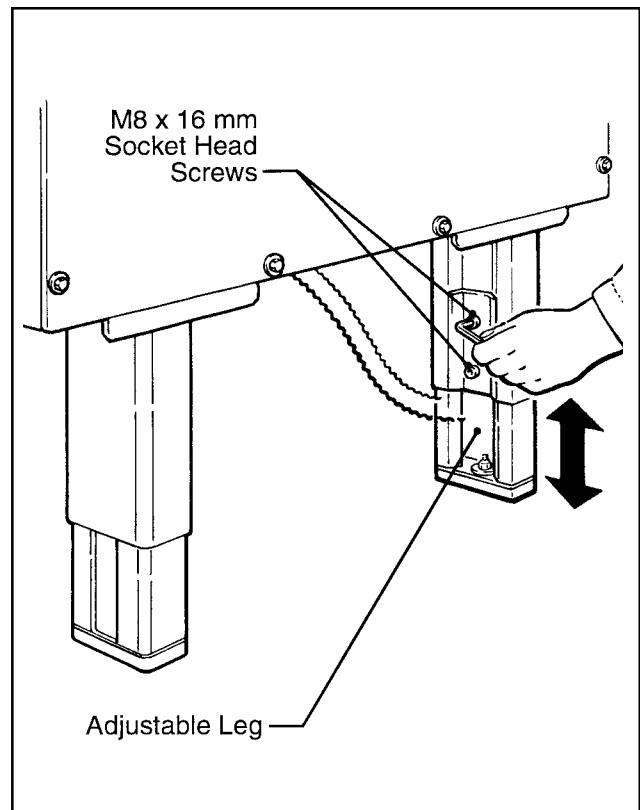
Whenever the machine is lifted with a fork truck, insure that the forks span completely across the machine frame and do not contact any mechanism under the machine frame.

**CAUTION** – Machine weighs approximately 85 kg [190 lbs] uncrated.

2. Adjust machine bed height.  
The case former is equipped with four adjustable legs that are located at the corners of the frame. The legs can be adjusted to obtain different conveyor bed heights from 610 mm [24.0 inch] minimum to 775 mm [30.5 inch] maximum.

Refer to Figure 2-1 and adjust the bed height as follows:

- (a) Block up the machine frame to allow adequate leg adjustment.
- (b) Loosen, but do not remove, two M8 x 16 mm socket screws in one leg. Adjust the leg length for the desired bed height. Retighten the two screws to secure the leg. Adjust all four legs equally.



**Figure 2-1 – Bed Height Adjustment**

3. Install case former in production line.

Refer to Figure 2-2 for installation set up. Case former bed must be level and equal or slightly higher than case sealer bed height.

Install mounting brackets as shown in Figure 2-2.

# Installation and Set-Up (Continued)

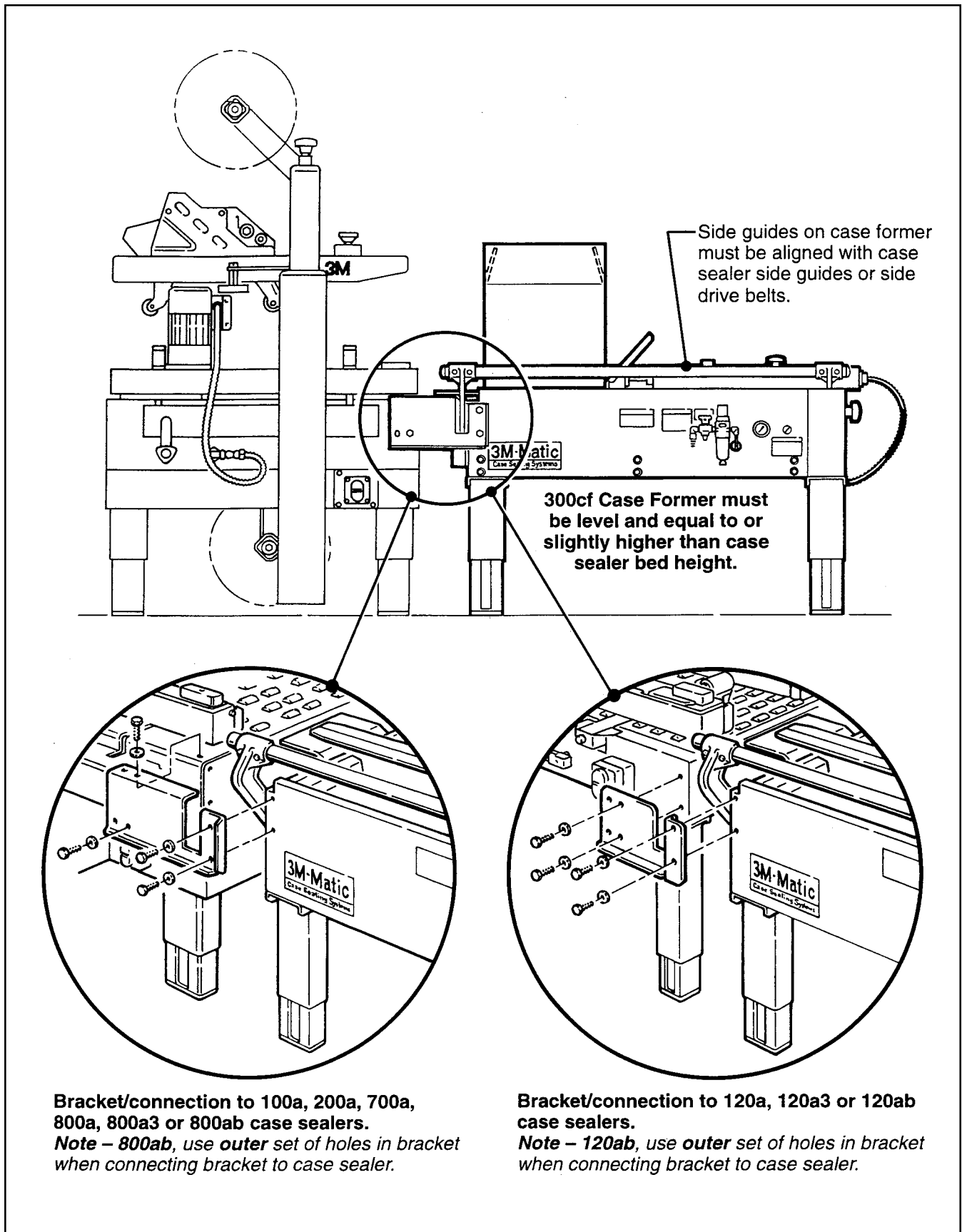


Figure 2-2 – Mounting Bracket Installation

## Installation and Set-Up (Continued)

### 4. Pneumatic Connection

The case former requires a 5.2 bar gauge pressure [75 PSIG], 6.0 m<sup>3</sup>/h @ 21°C, 1.01 bar [3.5 SCFM] compressed air supply.

The customer supplied air supply hose should be connected to the barbed fitting on the On/Off valve and clamped tightly with the hose clamp provided. See Figure 2-3. Shut the air valve off and connect the air line. Turn the On/Off valve On (SUP), to energize the pneumatic components.

If another type of connector is desired, the barbed fitting and/or elbow can be removed and replaced with the desired connector. The air On/Off valve inlet is 1/4-18 standard pipe threads.

### 5. Side Guide Extensions

Under certain circumstances, the centering guides may interfere with the side guides on the 100a, 200a or 700a case sealers. If this occurs, the case sealer side guides can be removed and centering guide extensions can be installed on the 300cf Case Former. The side guide extensions are included with the 300cf. Install guides as shown in Figure 2-4.

6. After completing the "Installation and Set-Up" procedure, continue through "Operation" to be sure case former is properly set-up to run boxes.

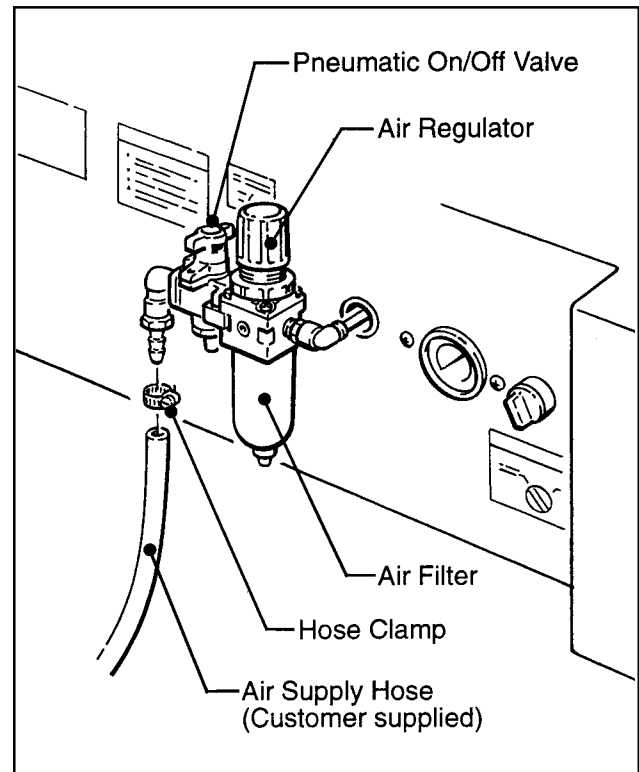


Figure 2-3 – Pneumatic Connections

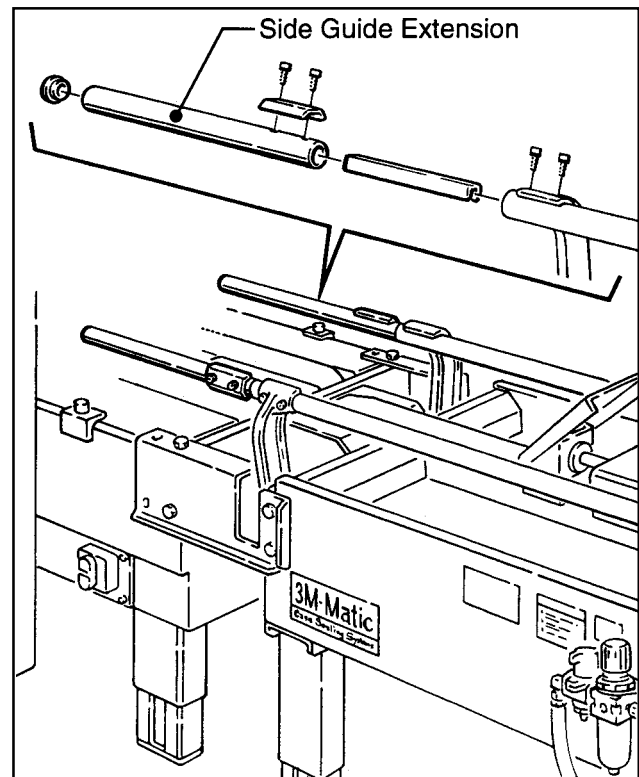


Figure 2-4 – Side Guide Extensions

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## Operation

**IMPORTANT** – Before operating the case former, read the "Important Safeguards", pages 3-4 and "Warnings" on page 12 as well as all of the "Operation" instructions.

Refer to Figure 3-1 to acquaint yourself with the various components and controls of the case former.

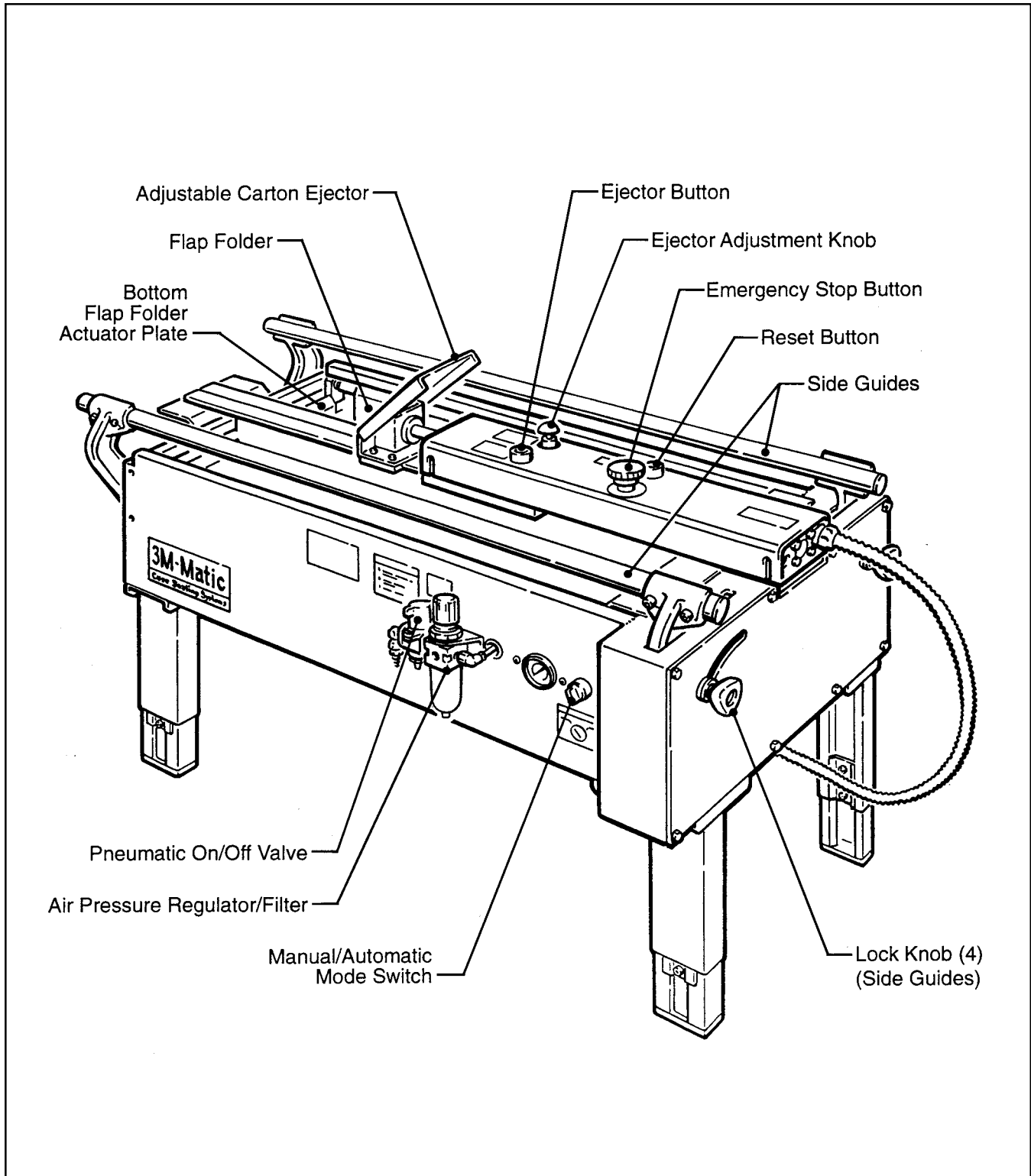


Figure 3-1 – 300cf Case Former Components

## Operation (Continued)

### WARNINGS

1. Turn air supply off before performing any adjustments or maintenance on the machine.
2. Turn air supply off when machine is not in use.
3. The case former contains flap folders and sliding components that operate in rapid succession. Keep hands out of this area when machine is in operation.
4. Failure to comply with these warnings could result in severe personal injury and/or equipment damage.

### Manual/Automatic Mode

The operator can control the box movement from the case former to the case sealer by the manual/automatic mode switch located on the left side of the frame. Figure 3-1.

In the manual mode, (for top and bottom taping) the operator must press the ejector button (Figure 3-2)

to cause the ejector to move the box forward into the case sealer.

In the automatic mode, (for bottom taping only) the box is moved forward by the ejector without operator assistance.

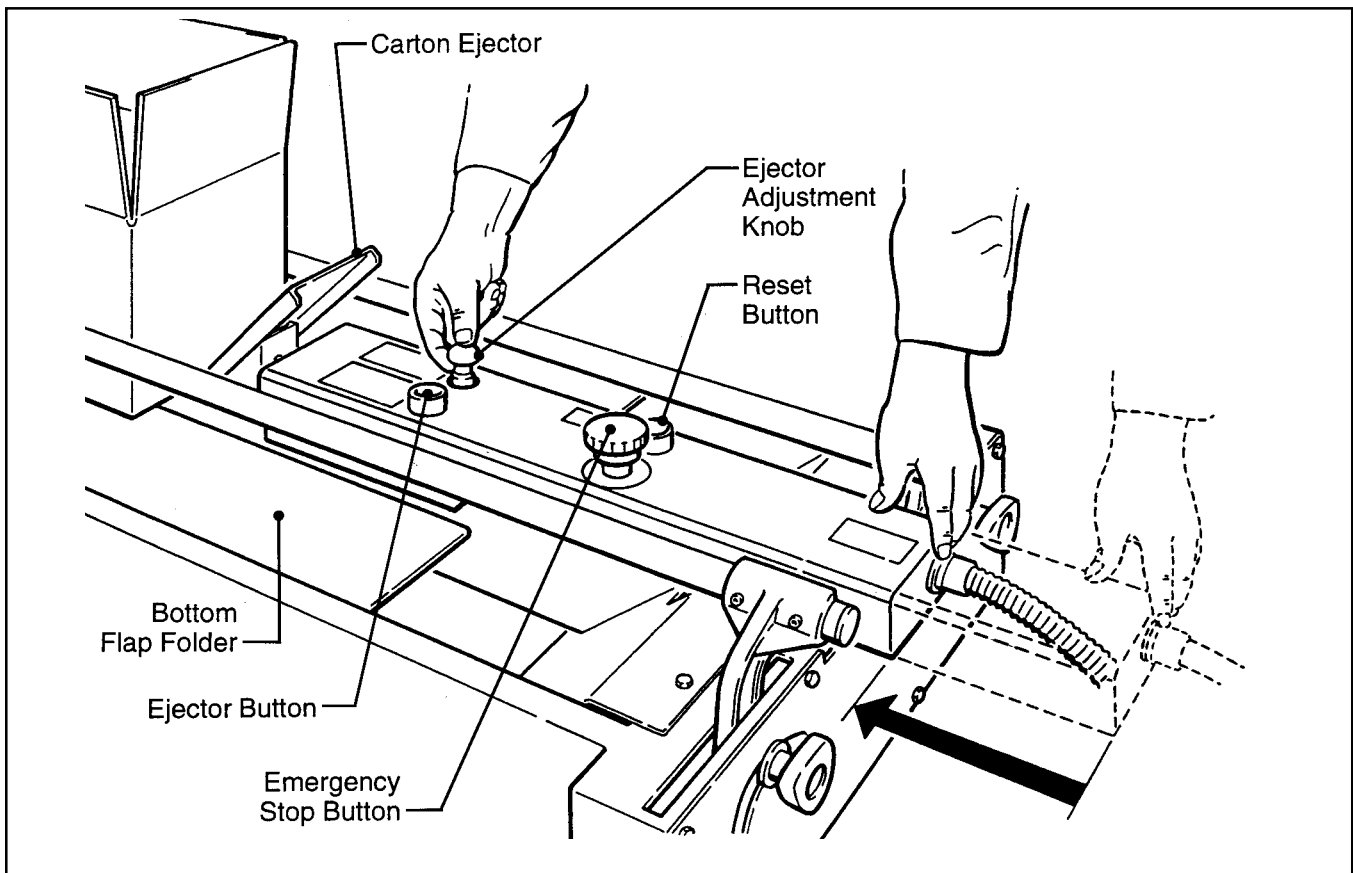


Figure 3-2 – Adjustable Carton Ejector



## Operation (Continued)

### Emergency Stop Button

The E-Stop button can be pushed at any time to stop machine operation and bleed air from the pneumatic system.

### Reset Button

When case former is stopped with E-Stop, the Reset Button must be pushed to restore air supply to the machine.

### Box Centering Guide

The four knobs for locking the centering guides in position are located at the front and rear of the machine. Center the box in the machine with the centering guides and tighten the knobs to lock guides in place.

### Box Ejector

The ejector and air cylinder are located on the top center rail of the case former as shown in Figure 3-2. The ejector is adjustable along the rail in 25 mm [1 inch] increments to accommodate box lengths from 205 mm [8 inch] minimum to 600 [23-1/2 inch] maximum.

### Manual Operating Procedure

(Top and Bottom Taping)

Refer to Figures 3-2 and 3-3

1. Turn case former air valve "On" (SUP).
2. Turn Manual/Auto valve to "Man".
3. Hold the empty box over the center rail. Fold the front bottom flap on the rail and rear bottom flap on the carton ejector.
4. Move box forward (toward case sealer) until both side bottom flaps contact the bottom flap actuator plates. The two bed plates will then rotate up and fold the side box flaps up.
5. Fill the box with product.
6. Close box top flaps, front and rear and then side flaps.
7. While holding top flaps down, press "Eject" button to move box into case sealer. Hold top flaps down until box moves into case sealer.

The ejector will return to the rest position and the bed plates will return to full open position ready for the next box.

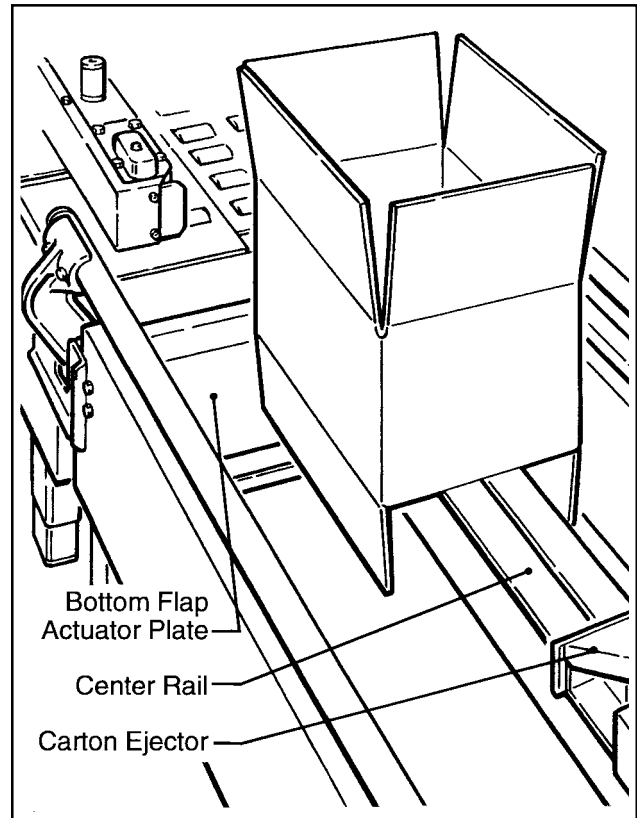


Figure 3-3 – Box Placement

## Operation (Continued)

### Automatic Operating Procedure

(Bottom Taping Only)

1. Raise case sealer upper taping head to maximum height (if applicable).
2. Turn case former air valve "On" (SUP).
3. Turn Manual/Auto valve to "Auto".
4. Place open box with front and back bottom flaps folded in, onto the case former center rail.
5. Move box forward (toward case sealer) until both side bottom flaps contact the bottom flap actuator plates. The two bed plates will then rotate up and fold the side box flaps up.

The box ejector will automatically push the box into the case sealer and then return to the rest position ready for the next box.

# Maintenance



**WARNING – Disconnect air supply to the machine before beginning any maintenance, Failure to do so could result in personnel injury or damage to the machine.**

**Note – Never attempt to remove dirt from machine by blowing it off with compressed air. This can cause dirt to be blown into critical machine components and cause premature wear. Never wash down or subject machine to conditions causing moisture condensation as serious equipment damage could result.**

## Cleaning of the Machine

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. The dust build-up can best be removed from the machine by a shop vacuum. Depending on the number and type of boxes used in the case former, this cleaning should be done approximately once per month. If the boxes 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

The Lubrication Chart shown in Figure 4-1 illustrates the frame points which should be lubricated every 250 hours of operation. Lubricate the rotating and pivoting points noted by the arrows with SAE #30 non-detergent oil.

**Note – Wipe off excess oil and grease. It will attract dust which can cause premature equipment wear and jamming.**

Description (Parts Drawing Reference/Item Number)	Lubricant	Instructions
Chain (Ref. No. 5422-9 & 5422-10)	2	Lightly coat chain
Sliding Block – Ejector Guide (Ref. No. 5424-13)	1	Lightly coat guide slots
Sliding Block – L/H (Ref. No. 5424-14)	1	Lightly coat guide slots
Sliding – Flap Folder (Ref. No. 5424-27)	1	Lightly coat guide slots

<b>Lubricant</b>	<ol style="list-style-type: none"> <li>1. White Moly Grease With Liquilon, Plate Master #177L</li> <li>2. NLGI Grade 2 Multi-purpose Film Forming With Liquilon, Polymere #400</li> </ol>
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**Figure 4-1 – Lubrication Chart**

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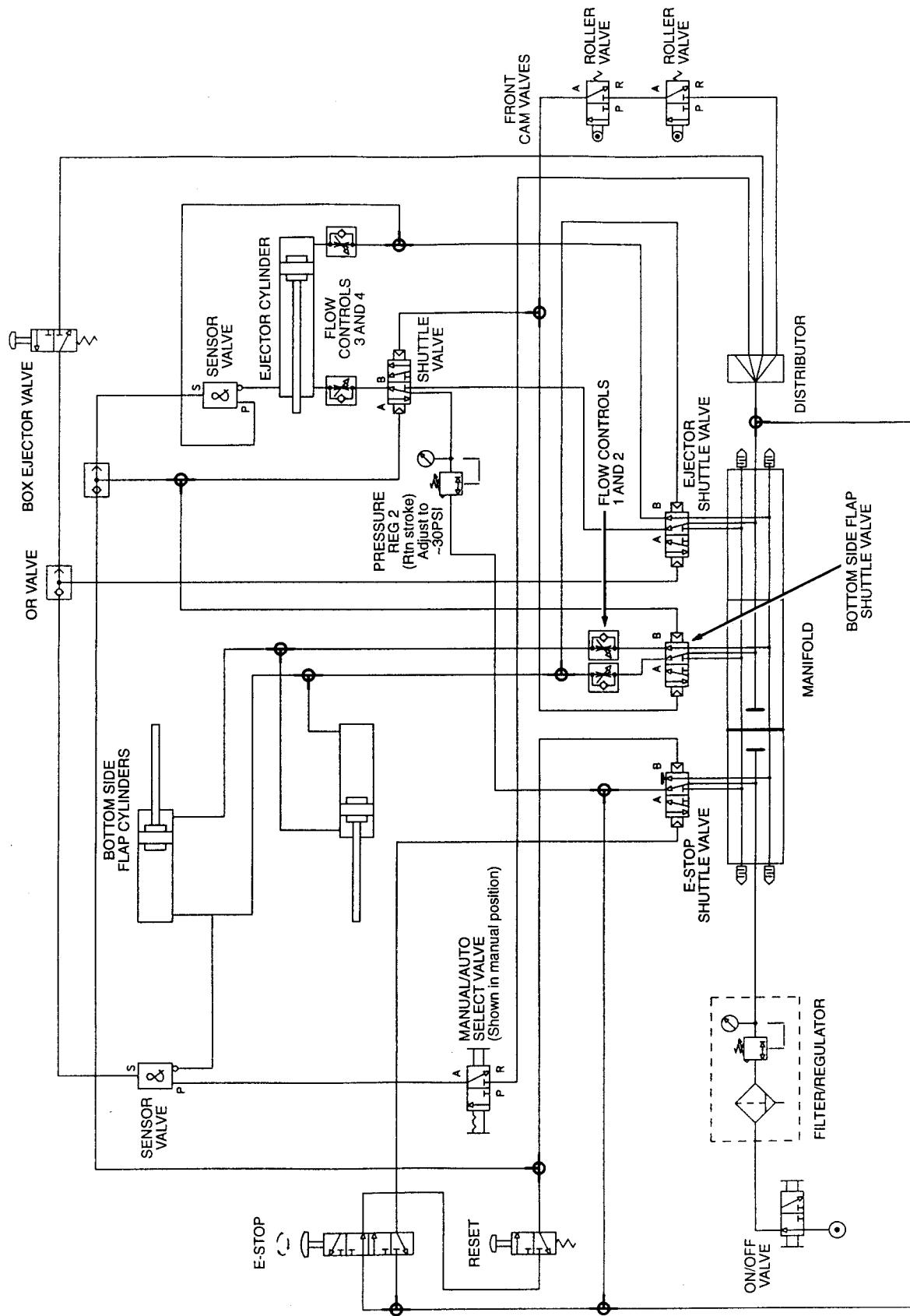
## Pneumatic Diagram

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On/Off Valve:	SMC EVHS2500
Filter-Regulator:	SMC EAW2000
Shuttle Valves:	SMC EVZA5220
Roller Valves:	Telemecanique PXC-M52
Flow Controls 1 and 2:	Legris 7665-56-11
Pressure Regulator 2:	SMC EAR111
Manual-Auto Select Valve:	Telemecanique PXB-B1011BA2
Flow Control Valves 3 and 4:	Legris 7665-56-14
Sensor Valves:	Legris PWS-P
Bottom Side Flap Cylinders:	SMC C65B32-125C-Y2-*
Ejector Cylinder:	SMC C65B40-500C-Y37-*
OR Valve:	Telemecanique PLK-A11
Box Ejector Valve:	Telemecanique PXB-B191

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Figure 5-1 – Pneumatic Diagram



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## Parts and Service Information

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### Labels

In the event that any labels are damaged or destroyed, **they must be replaced to ensure operator safety**. A label kit, part number 78-8119-6942-3 is available as a stock item. It contains all the safety labels used on the 300cf Case Former or separate labels can be ordered from the parts list, page 37.

### Replacement Parts Ordering Information and Service

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

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## Replacement Parts Illustrations and Parts List

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### 300cf Case Former, Type 29800 Frame Assemblies

1. Refer to first illustration, Frame Assemblies, for the figure number that identifies a specific portion of the machine.
2. Refer to the Figure or Figures to determine the individual parts required and the parts reference number.
3. The replacement parts list that follows each illustration, includes the part number and part description for the parts in that illustration.

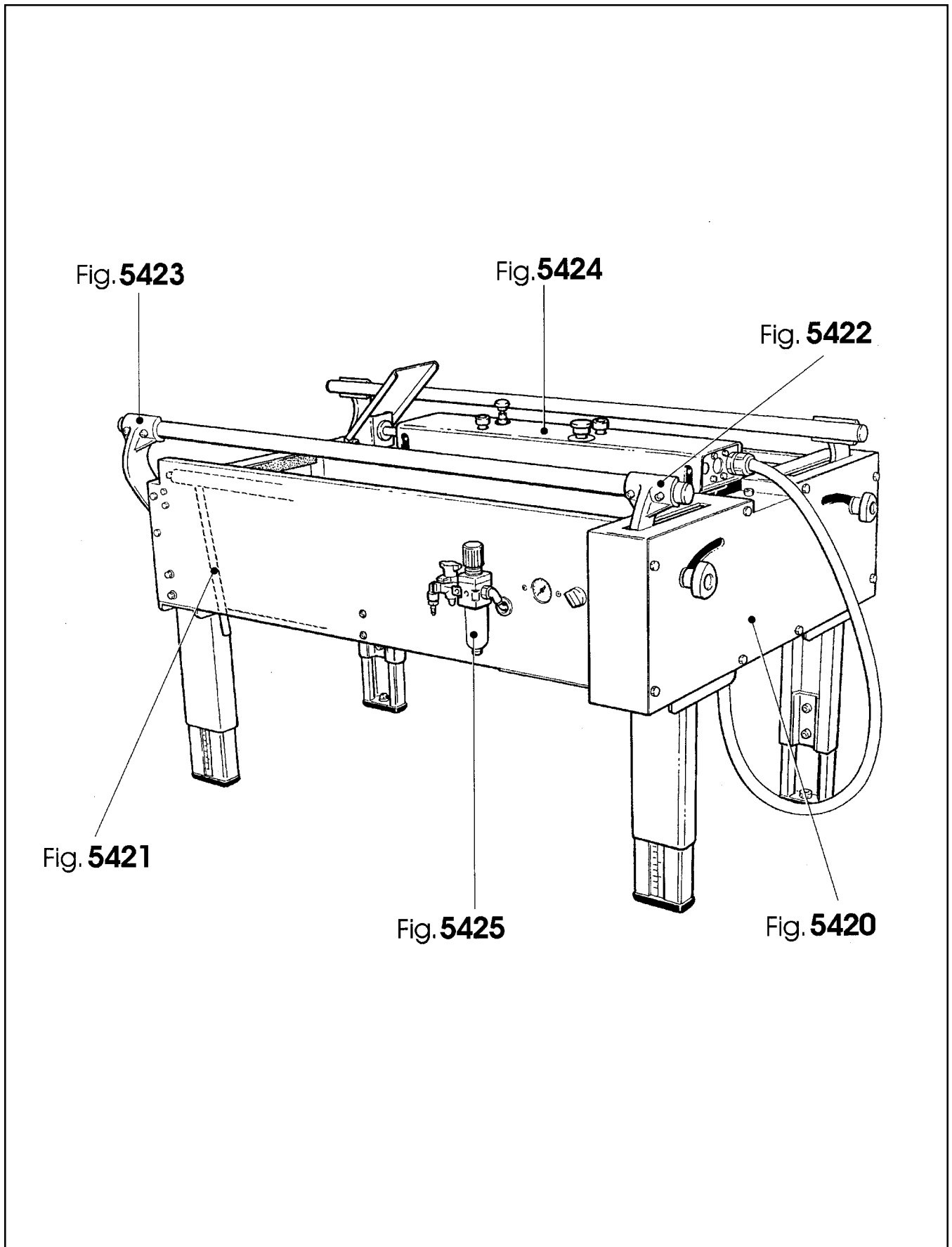
**Note** – The complete description has been included for standard fasteners and some commercially available components. This has been done to allow obtaining these standard parts locally, should the customer elect to do so.

4. Order parts by part number, part description and quantity required. Also include machine name, number and type.
5. Refer to first page of this instruction manual for parts ordering address and/or fax number.

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

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# 300cf Case Former



## Frame Assemblies

# 300cf Case Former

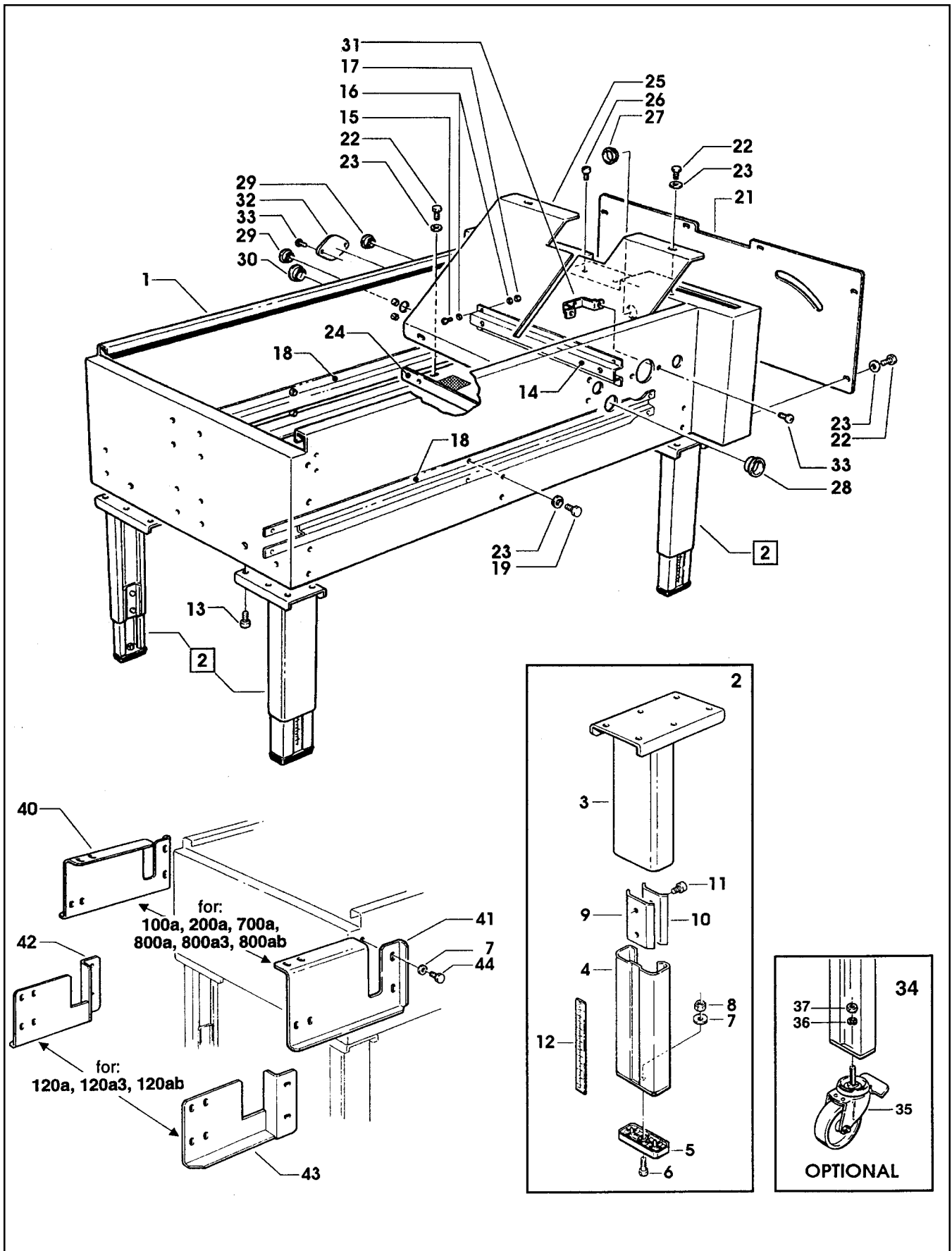


Figure 5420

## Figure 5420

Ref. No.	3M Part No.	Description
5420-1	78-8119-6529-8	Conveyor – Bed, W/English Language Label
5420-2	78-8100-0914-8	Leg Assembly
5420-3	78-8100-0915-5	Leg – Outer
5420-4	78-8100-0916-3	Leg – Inner
5420-5	78-8060-8480-8	Pad – Foot
5420-6	78-8055-0867-4	Screw – Hex Hd – M8 x 30
5420-7	78-8017-9318-9	Washer – Plain, 8 mm
5420-8	78-8017-9313-0	Nut – Self-Locking, M8
5420-9	78-8052-6677-8	Clamp – Inner
5420-10	78-8052-6676-0	Clamp – Outer
5420-11	26-1003-7963-0	Screw – Soc Hd, M8 x 16
5420-12	78-8100-0917-1	Label – Leg
5420-13	26-1003-7964-8	Screw – Soc Hd Hex Soc Dr, M8 x 20
5420-14	78-8100-0918-9	Reinforcement
5420-15	26-1003-7943-2	Screw – Soc Hd, M4 x 12
5420-16	78-8005-5740-3	Washer – Plain, 4 mm
5420-17	78-8010-7416-8	Nut – Hex, M4
5420-18	78-8114-4982-2	Plate – Reinforcement
5420-19	78-8010-7169-3	Screw – Hex Hd, M6 x 12
5420-21	78-8100-0920-5	Cover – Front
5420-22	78-8032-0375-7	Screw – Hex Hd, M6 x 16
5420-23	78-8042-2919-9	Washer – Triple, M6
5420-24	78-8100-0922-1	Support
5420-25	78-8100-0921-3	Cover
5420-26	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
5420-27	78-8100-0923-9	Grommet
5420-28	78-8094-6489-0	Snap Bushing – SB 1250-15
5420-29	78-8114-4703-2	End Cap – /25 x 1.2
5420-30	78-8094-6177-1	Cap
5420-31	78-8076-4535-9	Bracket
5420-32	78-8094-6305-8	Plate – Gauge
5420-33	78-8060-8087-1	Screw – M5 x 10
5420-34	78-8098-9076-3	Caster Assembly
5420-35	26-1009-9096-4	Caster – Dual Locking
5420-36	26-1009-9094-9	Washer – Spring Helical, M12
5420-37	26-1009-9095-6	Nut – M12
5420-40	78-8100-0926-2	Bracket – R/H, 100a, 200a, 700a, 800a
5420-41	78-8100-0927-0	Bracket – L/H, 100a, 200a, 700a, 800a
5420-42	78-8100-0924-7	Bracket – R/H
5420-43	78-8100-0925-4	Bracket – L/H
5420-44	26-1003-5842-8	Screw – Hex Hd, M8 x 20

# 300cf Case Former

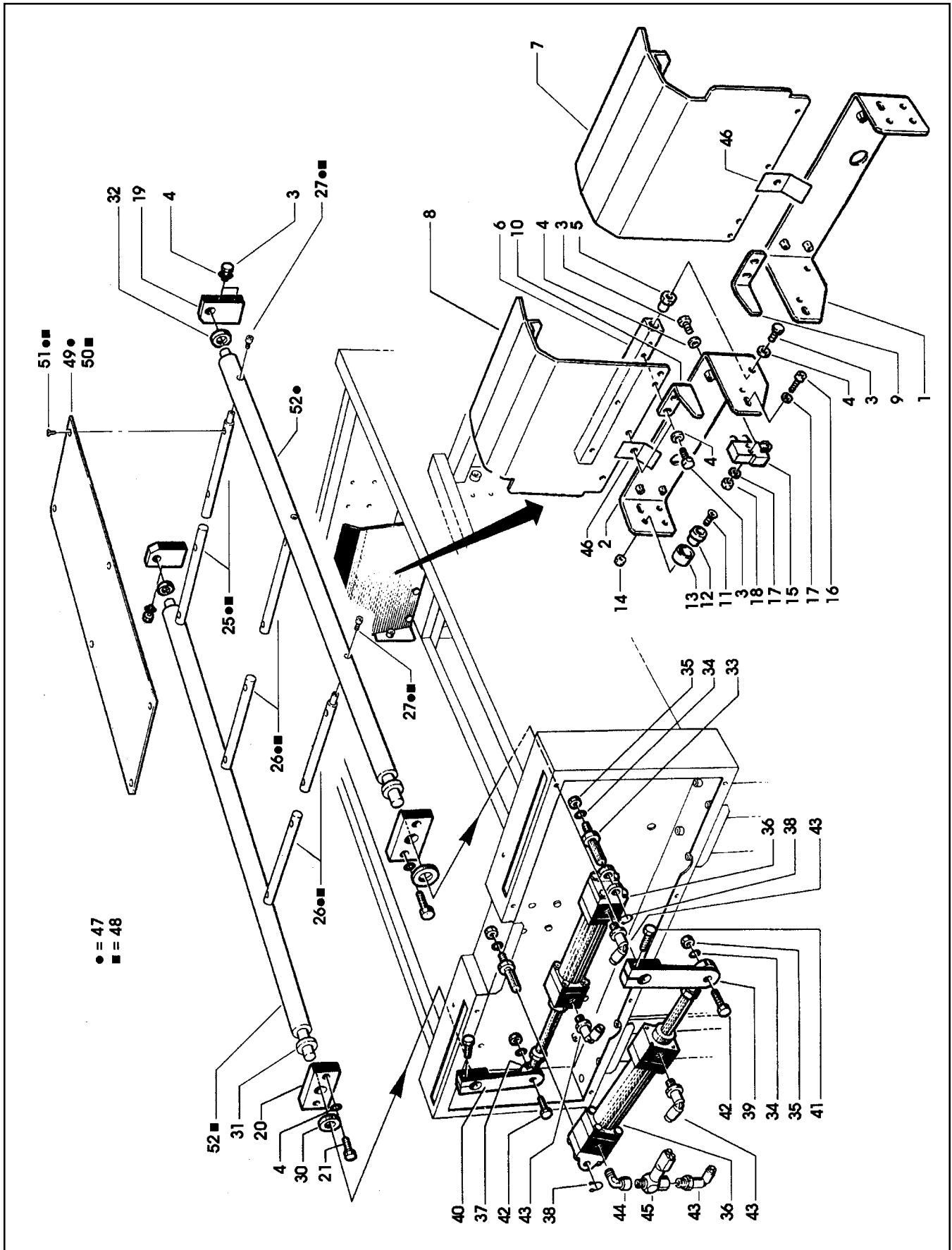


Figure 5421

## Figure 5421

Ref. No.	3M Part No.	Description
5421-1	78-8114-4983-0	Support – Valve, R/H
5421-2	78-8114-4984-8	Support – Valve, L/H
5421-3	78-8032-0375-7	Screw – Hex Hd – M6 x 16
5421-4	26-1000-0010-3	Washer – Flat, M6
5421-5	78-8094-6081-5	Hinge
5421-6	78-8100-0930-4	Support – Cam
5421-7	78-8114-4985-5	Cam – Flap, R/H
5421-8	78-8114-4986-3	Cam – Flap, L/H
5421-9	78-8100-0933-8	Actuator – Valve, R/H
5421-10	78-8094-6083-1	Lever – Actuator
5421-11	26-1005-5316-8	Screw – Flat Hd Hex Dr, M5 x 16
5421-12	78-8052-6600-0	Spacer
5421-13	78-8070-1269-1	Bumper
5421-14	78-8010-7417-6	Nut – Hex, M5
5421-15	78-8094-6084-9	Limit Switch PXC-M521
5421-16	26-1003-7946-5	Screw – Soc Hd, M4 x 25
5421-17	78-8005-5740-3	Washer – Plain, M4
5421-18	78-8010-7416-8	Nut – Hex, M4
5421-19	78-8055-0786-6	Support – Shaft Right
5421-20	78-8055-0782-5	Support – Shaft Left
5421-21	26-1003-5833-7	Screw – Hex Hd, 6 x 30
5421-25	78-8114-4674-5	Support – Long
5421-26	78-8114-4675-2	Support – Short
5421-27	26-1003-7951-5	Screw – Soc Hd Hex Soc, M5 x 20
5421-30	78-8055-0783-3	Washer – D18/30 x 7
5421-31	78-8055-0781-7	Ring Nut
5421-32	78-8055-0787-4	Washer – D14 /30 x 5
5421-33	78-8055-0790-8	Shaft – Cylinder Support
5421-34	78-8052-6566-3	Washer – Friction
5421-35	26-1003-6918-5	Nut – Hex Flange, M10
5421-36	78-8094-6087-2	Cylinder – C65 B332-125C-Y2
5421-37	78-8057-5748-7	Mount – Cylinder Rod End
5421-38	78-8016-5855-6	E-Ring – 10 mm
5421-39	78-8055-0785-8	Lever – Cylinder, Right
5421-40	78-8055-0784-1	Lever – Cylinder, Left
5421-41	78-8017-9301-5	Screw – Hex Hd, M8 x 25
5421-42	26-1003-7976-2	Screw – Hex Hd, M10 x 35
5421-43	26-1005-6893-5	Elbow – 90°
5421-44	26-1005-6895-0	Elbow – 90°
5421-45	78-8094-6078-1	Sensor – 78180410
5421-46	78-8114-4987-1	Spring – Cam
5421-47	78-8119-8701-1	Flap Folder Assembly – R/H
5421-48	78-8119-8702-9	Flap Folder Assembly – L/H
5421-49	78-8119-8703-7	Plate – Flap Folder, R/H
5421-50	78-8119-8704-5	Plate – Flap Folder, L/H
5421-51	26-1001-9843-6	Screw – Flat Soc Hd, M6 x 16
5421-52	78-8100-0936-1	Arm

# 300cf Case Former

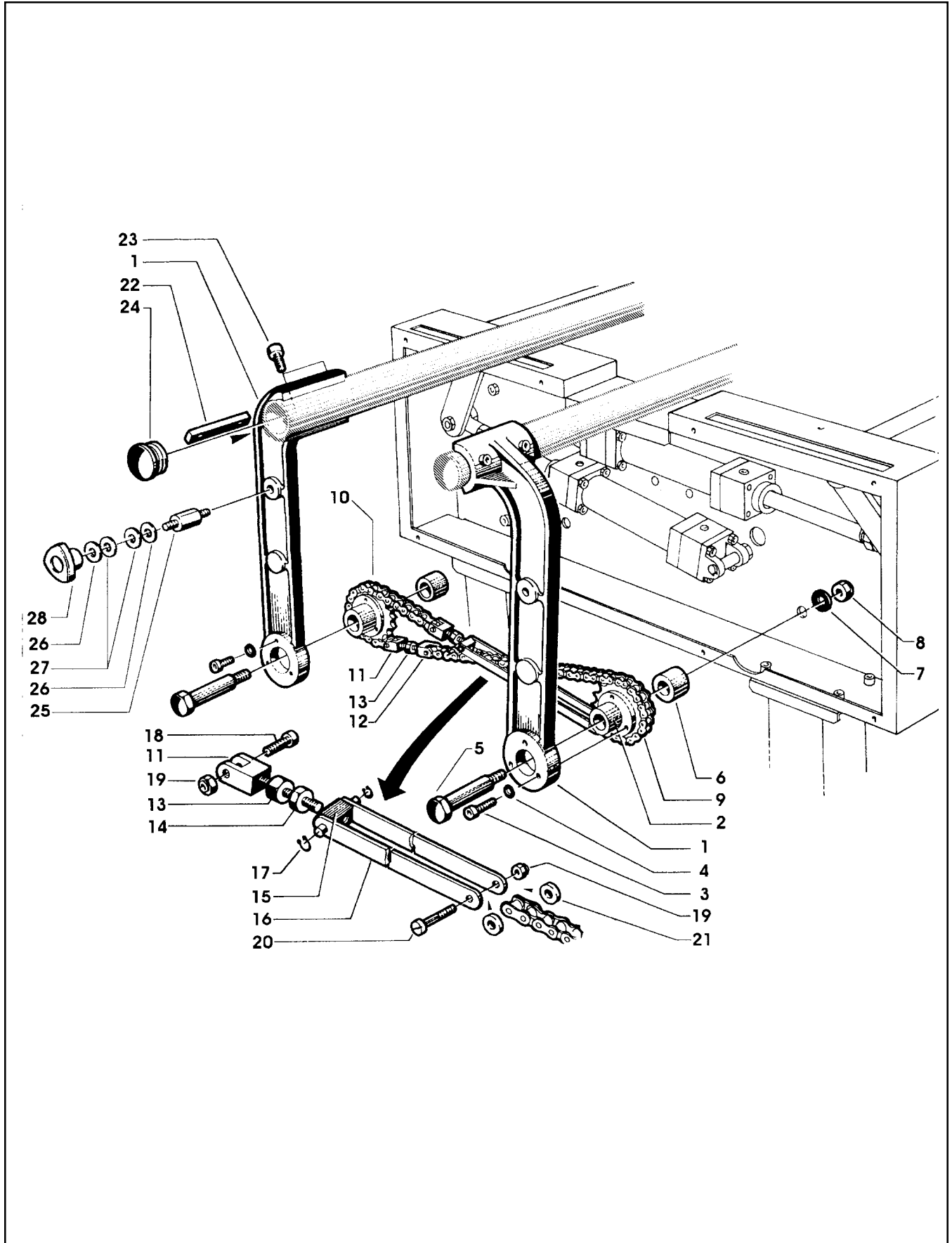


Figure 5422



## Figure 5422

Ref. No.	3M Part No.	Description
5422-1	78-8100-0938-7	Lever – Front
5422-2	78-8055-0808-8	Sprocket
5422-3	78-8010-7165-1	Screw – Flat Hd Soc, M5 x 25
5422-4	78-8005-5741-1	Washer – Flat, M5
5422-5	78-8055-0807-0	Shoulder Bolt
5422-6	78-8055-0806-2	Spacer – D16/30 x 35
5422-7	78-8052-6566-3	Washer – Friction
5422-8	26-1003-6918-5	Nut – Hex Flange, M10
5422-9	78-8100-0939-5	Chain – 3/8 Inch Pitch, 28 Pitch
5422-10	78-8054-8777-0	Chain – 3/8 Inch, 41 Pitch Long
5422-11	78-8054-8786-1	Chain Connector
5422-12	78-8054-8788-7	Chain Connector
5422-13	78-8054-8785-3	Rod – Threaded Right/Left
5422-14	78-8010-7418-4	Nut – Hex, M6
5422-15	78-8054-8784-6	Block – Chain
5422-16	78-8054-8787-9	Chain Link
5422-17	78-8056-3945-3	E-Ring – M4
5422-18	78-8060-7520-2	Screw – M3 x 20
5422-19	78-8059-5517-2	Nut – Self-Locking, M3
5422-20	78-8060-7519-4	Screw – M3 x 25
5422-21	78-8054-8783-8	Washer – Special
5422-22	78-8055-0800-5	Plate – 5 x 15 x 70
5422-23	78-8059-5526-3	Screw – Soc Hd Hex Soc Dr – M6 x 15
5422-24	78-8054-8779-6	End Cap
5422-25	78-8100-0940-3	Hexagon – Threaded
5422-26	78-8060-8452-7	Washer – M10
5422-27	78-8100-0941-1	Washer – Nylon
5422-28	78-8070-1549-6	Knob – VTR-B-M10

# 300cf Case Former

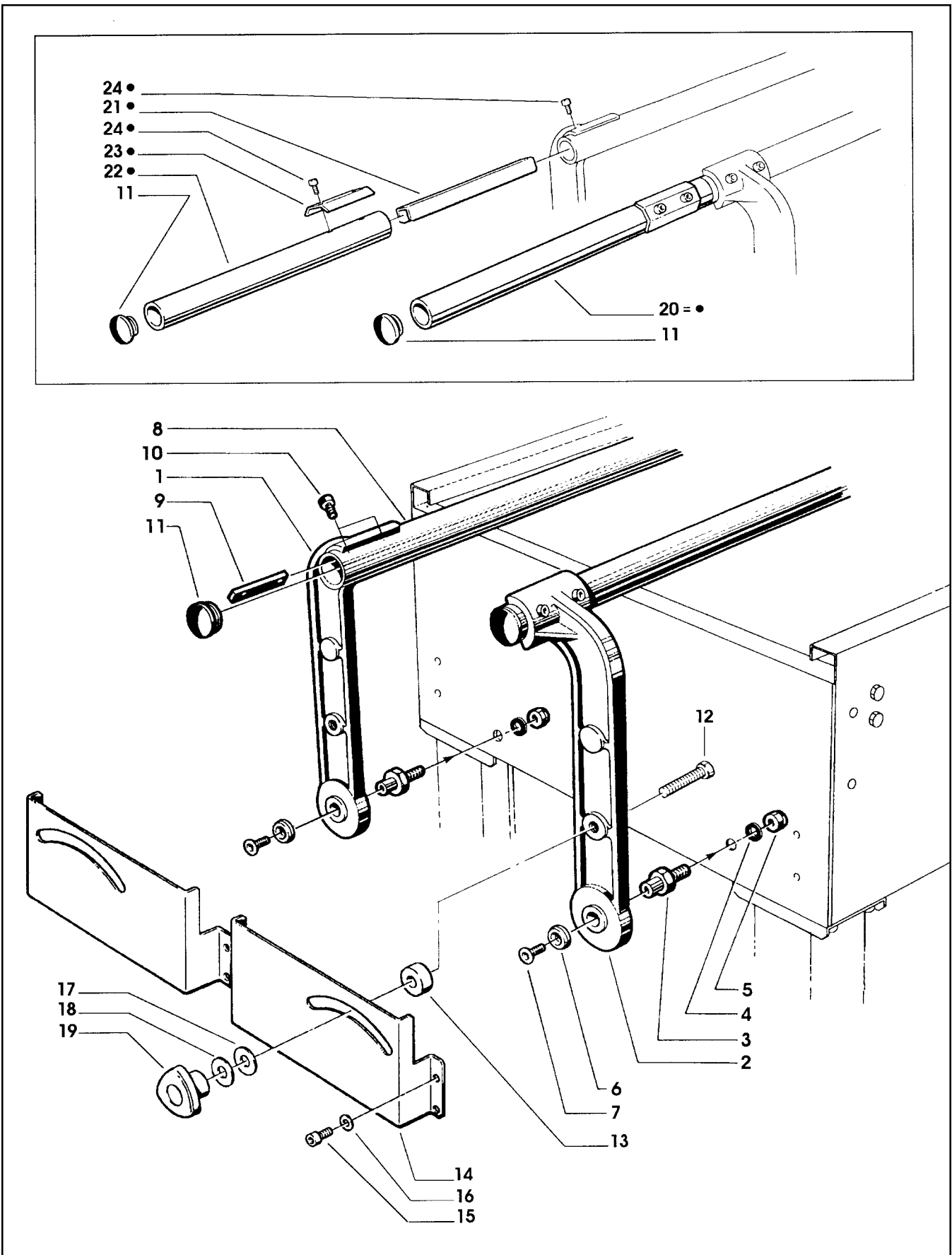


Figure 5423

**Figure 5423**

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
5423-1	78-8100-0942-9	Lever – Rear, R/H
5423-2	78-8100-0943-7	Lever – Rear, L/H
5423-3	78-8094-6057-5	Shaft – Lever
5423-4	78-8052-6566-3	Washer – Friction
5423-5	26-1003-6918-5	Nut – Plastic Insert Hex, M10
5423-6	78-8054-8577-4	Washer – Special
5423-7	26-1001-9843-6	Screw – Flat Soc Hd, M6 x 16
5423-8	78-8055-0798-1	Guide – Centering
5423-9	78-8055-0800-5	Plate – 5 x 15 x 70
5423-10	78-8059-5526-3	Screw – Soc Hd Hex Soc Dr, M6 x 15
5423-11	78-8054-8779-6	End – Cap
5423-12	78-8114-4678-6	Screw – Hex Hd, M10 x 50
5423-13	78-8114-4679-4	Spacer
5423-14	78-8114-4680-2	Guide Adjustment
5423-15	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
5423-16	26-1000-0010-3	Washer – Flat, M6
5423-17	78-8100-0941-1	Washer – Nylon
5423-18	78-8060-8452-7	Washer – M10
5423-19	78-8070-1549-6	Knob – VTR-B-M10
5423-20	78-8100-0969-2	Extension Assembly – Side Guide
5423-21	78-8100-0971-8	Extension – Inner
5423-22	78-8100-0970-0	Extension – Outer
5423-23	78-8100-0972-6	Plate
5423-24	78-8023-2334-1	Screw – Soc Hd Hex Soc, M6 x 25

# 300cf Case Former

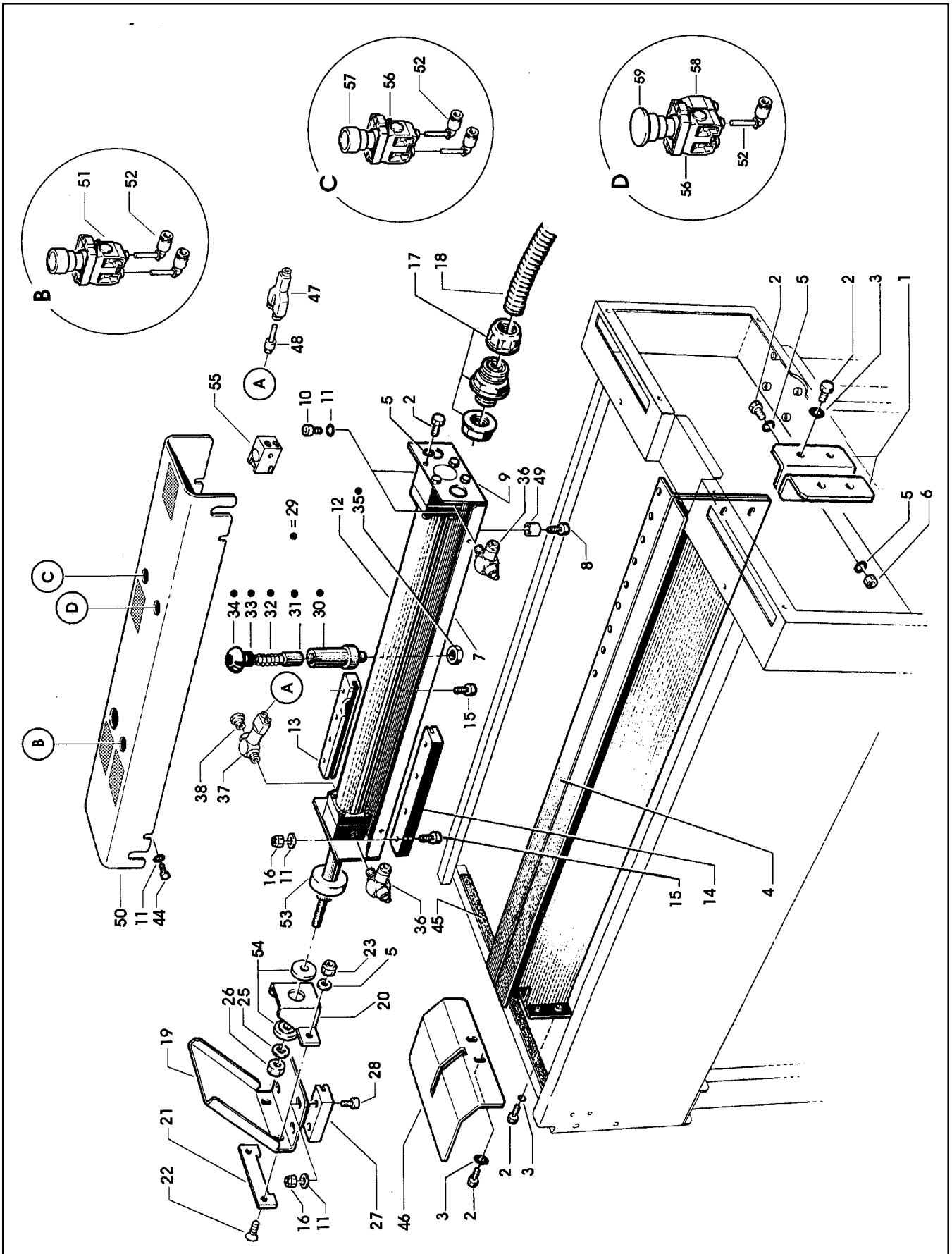
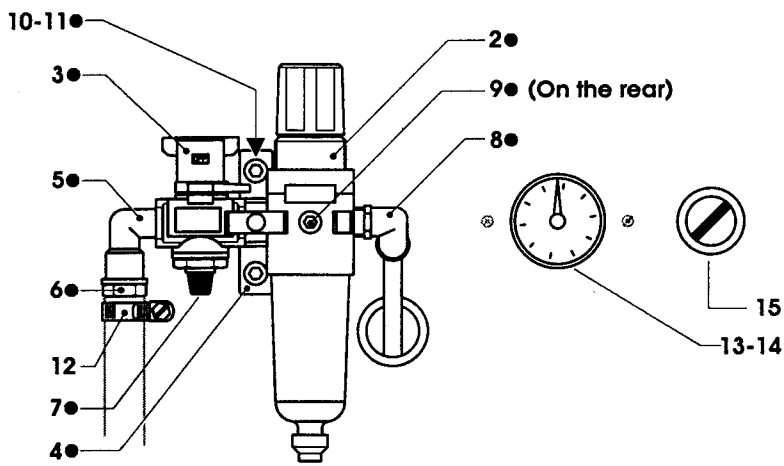


Figure 5424

**Figure 5424**

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
5424-1	78-8094-6089-8	Bracket
5424-2	78-8032-0375-7	Screw – Hex Hd, M6 x 16
5424-3	78-8042-2919-9	Washer – Triple, M6
5424-4	78-8114-4681-0	Box Holder
5424-5	26-1000-0010-3	Washer – Flat, M6
5424-6	78-8010-7418-4	Nut – Hex, M6
5424-7	78-8114-4988-9	Support – Cylinder
5424-8	78-8010-7210-5	Screw – Soc Hd Hex Soc, M6 x 20
5424-9	78-8100-0947-8	Plate
5424-10	78-8032-0382-3	Screw – Soc Hex Hd, M5 x 16
5424-11	78-8005-5741-1	Washer – Flat, M5
5424-12	78-8100-0948-6	Cylinder – C65B40-500C
5424-13	78-8055-0768-4	Sliding Block – Ejector Guide
5424-14	78-8114-4682-8	Sliding Block – L/H
5424-15	25-1003-7951-5	Screw – Soc Hd Hex Soc, M5 x 20
5424-16	26-1005-6859-6	Nut – Self-Locking, M5
5424-17	78-8060-8454-3	Union – 1/2 Inch
5424-18	78-8060-8455-0	Sheath – /18 (1 MT)
5424-19	78-8114-4683-6	Flap Folder – Cylinder
5424-20	78-8119-8682-3	Bracket – Cylinder
5424-21	78-8060-7933-7	Guide
5424-22	78-8060-8179-6	Screw – Flat Hd Hex, M6 x 20
5424-23	26-1003-6916-9	Nut – Locking Plastic Insert, M6
5424-25	78-8100-0783-7	Washer – Special, /12
5424-26	78-8091-0775-4	Nut – M12 x 1.25
5424-27	78-8114-4684-4	Sliding – Flap Folder
5424-28	78-8100-0952-8	Screw – Soc Hd Hex Hd, M5 x 14
5424-29	78-8100-0953-6	Latch
5424-30	78-8094-6096-3	Sleeve – Latch
5424-31	78-8055-0775-9	Jack – Ejector
5424-32	78-8094-6097-1	Spring
5424-33	78-8055-0772-6	Spacer – D8/15 x 8
5424-34	78-8100-0954-4	Knob
5424-35	78-8017-9096-1	Nut – Special, M18 x 1
5424-36	78-8091-0510-5	Regulator – Speed
5424-37	78-8094-6078-1	Sensor – 78180410
5424-38	78-8060-7690-3	Cap – B-1/8 Inch
5424-44	26-1002-5820-6	Screw – Hex Hd, M5 x 16
5424-45	78-8114-4686-9	Bumper
5424-46	78-8114-4687-7	Slide
5424-47	78-8094-6079-9	Union – Y, Male
5424-48	78-8057-5735-4	Fitting – Reducer
5424-49	78-8055-0640-5	Spacer – Collar
5424-50	78-8119-6870-6	Cover – Support, W/English
5424-51	78-8114-4990-5	Push Button Assembly – Parker
5424-52	78-8114-4991-3	Union
5424-53	78-8114-4992-1	Bumper
5424-54	78-8119-8683-1	Bushing – Cylinder
5424-55	78-8094-6451-0	Valve – Selector, Parker
5424-56	78-8119-8684-9	Valve – W/Support, PXB-B1011
5424-57	78-8119-8685-6	Button – Pulse, ZB2-BA6
5424-58	78-8119-8686-4	Valve – Single, PXB-B1921
5424-59	78-8119-8687-2	E-Stop

# 300cf Case Former



- = 1
- = 16
- ▲ = 28

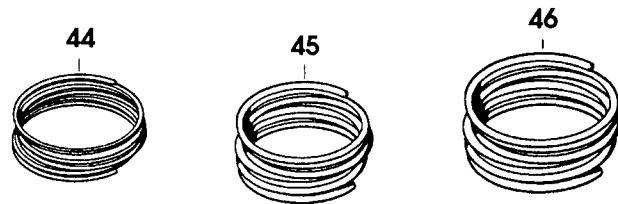
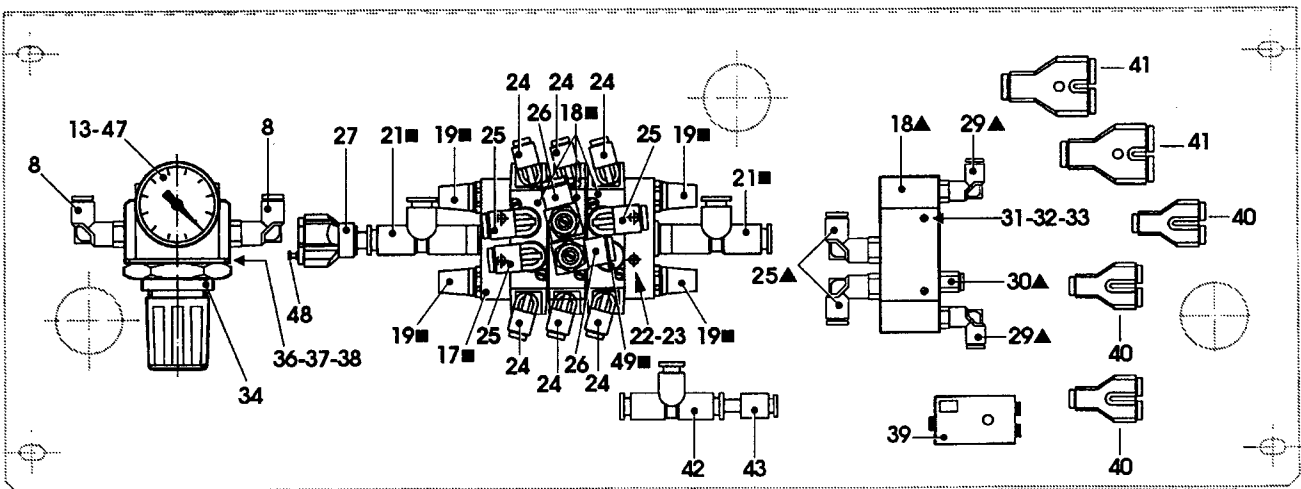
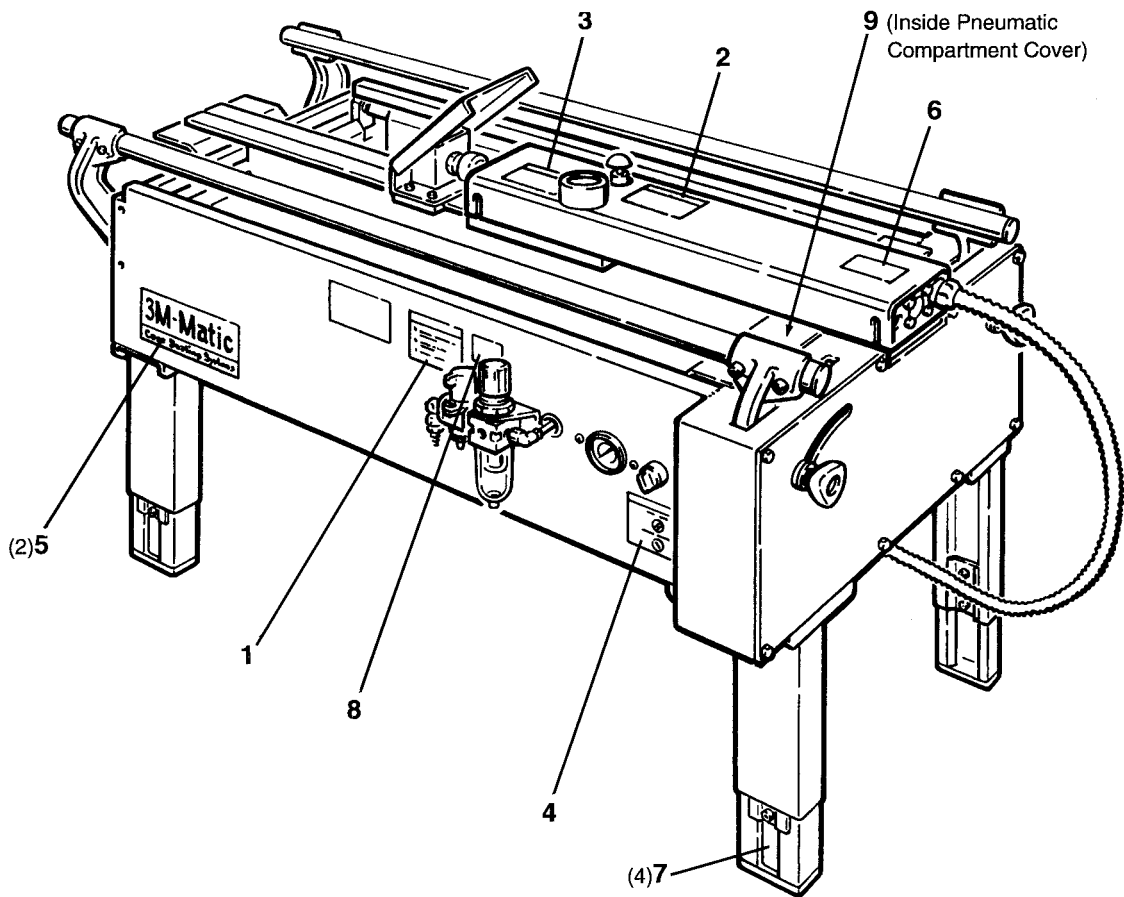


Figure 5425

## Figure 5425

Ref. No.	3M Part No.	Description
5425-1	78-8100-0956-9	Filter Regulator/Assembly
5425-2	26-1014-4558-8	Filter – Regulator, W/Metal Bowl
5425-3	78-8100-0957-7	Valve – EVHS 2500-F02-X116
5425-4	78-8100-0958-5	Block
5425-5	78-8060-7900-6	Union – RA 022, 1/4 Inch - 1/4 Inch
5425-6	26-1005-6897-6	Hose Connector – RA 030 9 1/4 Inch
5425-7	26-1005-6890-1	Muffler
5425-8	78-8055-0756-9	Union
5425-9	78-8076-4891-6	Union – Straight KQHH-O1S
5425-10	78-8032-0382-3	Screw – Soc Hd, Hex Soc, M5 x 16
5425-11	78-8028-8214-8	Washer
5425-12	78-8091-0430-6	Clamp – /14-24
5425-13	78-8054-8838-0	Gauge – Air
5425-14	78-8076-4672-0	Union – Straight, Female
5425-15	78-8094-6071-6	Valve – PXB-B2011BD2
5425-16	78-8100-0959-3	Valve Assembly
5425-17	78-8119-8705-2	Manifold
5425-18	78-8094-6074-0	Valve – EVZA 5220
5425-19	78-8076-4886-6	Muffler – 1/4 Inch
5425-20	78-8094-6075-7	Union – Straight
5425-21	78-8119-8706-0	Union
5425-22	26-1003-7947-3	Screw – Soc Hd Hex Soc, M4 x 35
5425-23	78-8005-5740-3	Washer – Plain, 4 mm
5425-24	78-8057-5732-1	Fitting – Elbow
5425-25	26-1005-6893-5	Elbow – 90 Degree
5425-26	78-8094-6077-3	Regulator – Flow, 77080610
5425-27	78-8094-6076-5	Union – Y
5425-28	78-8114-4688-5	Valve Assembly – EVZA 5220
5425-29	26-1005-5909-0	ELbow
5425-30	26-1005-6910-7	Union – Straight
5425-31	78-8076-4537-5	Screw – Soc Hd, Hex Hd, M3 x 25
5425-32	78-8076-4538-3	Washer – Flat, M3
5425-33	78-8114-4690-1	Nut – M3
5425-34	78-8076-4675-3	Regulator – 0.5-7 BAR
5425-36	78-8114-4673-7	Bracket
5425-37	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
5425-38	26-1000-0010-3	Washer – Flat, M6
5425-39	78-8094-6451-0	Valve – Selector, PLK-A11
5425-40	78-8076-4664-7	Union – Female
5425-41	78-8094-6079-9	Union – Y, Female
5425-42	78-8057-6170-3	Tee – Tubing, 6 mm
5425-43	78-8057-5735-4	Fitting – Reducer
5425-44	78-8060-8033-5	Tubing – 5M Skein, D4/3
5425-45	78-8060-8034-3	Tubing – 5M Skein, D6/4
5425-46	78-8076-4911-2	Tubing – DX6, 5 MT

# 120af-if Infeed Conveyor



## Safety and Information Labels



## 120af-if Safety and Information Labels

A label kit, part number 78-8113-6932-7 is available as a stock item. It contains all the safety and information labels used on the coder conveyor, or labels can be ordered separately from the following list.

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>	<b>Qty.</b>
1	78-8062-4266-1	Label – Product	2
2	78-8070-1329-3	Label – Warning, Hazardous Voltage	1
3	78-8068-3859-1	Label – Service and Spares	1
4	78-8060-8481-6	Label – Leg	4