

3M

Instructions and Parts List

3M-Matic™

800r3 Type 29600

Random

Case Sealer

with

AccuGlide™ II

Taping Heads

Serial No. _____
For Reference, record taping head(s) serial number(s) here.

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



Important Safeguards

Read "Safety Labels", pages 3-6 and also operating "Warnings", page 17
**BEFORE INSTALLING
OR OPERATING THIS
EQUIPMENT.**

Important

It is recommended you immediately order the spare parts listed on page 37. 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™ 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.

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 715/381 0248.

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.



3M Packaging Systems Division

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

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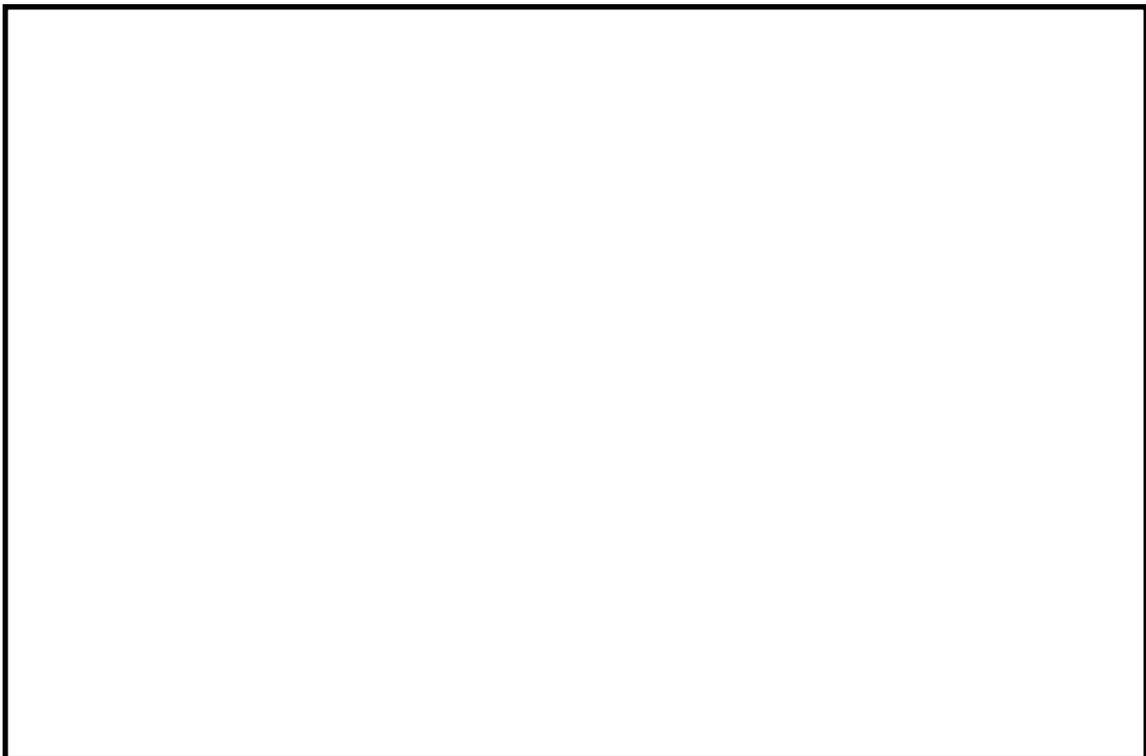
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To Our Customers:

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.

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 Packaging Systems Division

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

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Instruction Manual

800r3 Random Case Sealer, Type 29600

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™ II STD 3 Inch Taping Heads.

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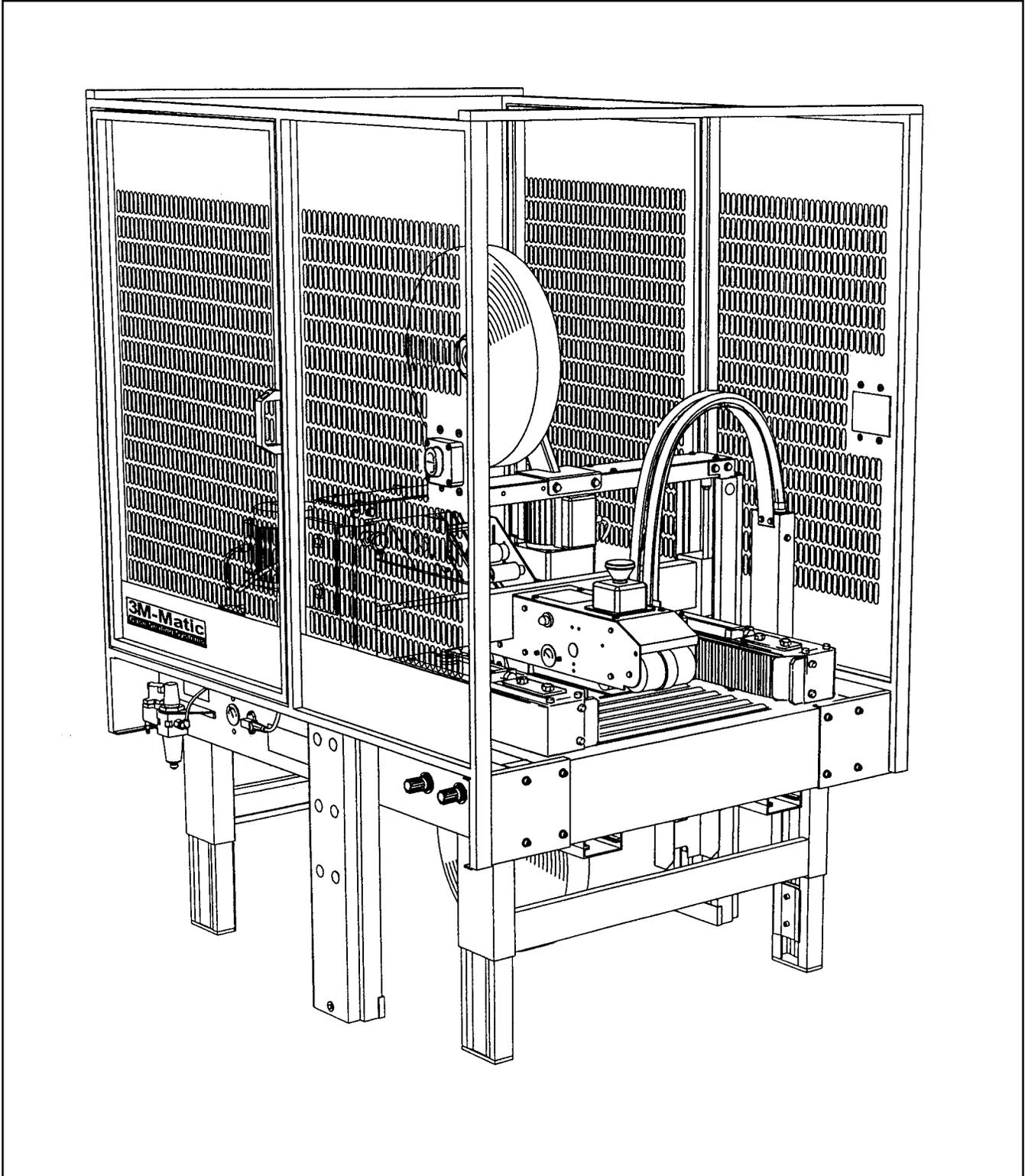
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Section II – AccuGlide™ II STD 3-Inch Taping Head

(See Section II for Table of Contents)

Intended Use

The intended use of the **3M-Matic™ 800r3 Random Case Sealer with AccuGlide™ II Taping Heads** is to apply a "C" clip of **Scotch™** brand pressure-sensitive film box sealing tape to the top and bottom center seam of regular slotted containers. The case sealer automatically adjusts to a wide range of box sizes (see "Specifications – Box Weight and Size Capacities", page 8).



3M-Matic™ 800r3 Random Case Sealer, Type 29600

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™ 800r3 Random Case Sealer, Type 29600** 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.

800r3 Contents

- (1) 800r3 Random Case Sealer, Type 29600
- (1) Tool and Parts List
- (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.**

Important – In the event the following safety labels are damaged or destroyed, **they must be replaced to ensure operator safety.** A label kit, part number 78-8113-6778-4 is available as a stock item or individual labels can be ordered. See Parts Illustration/List, Section I, pages 66 and 67.

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

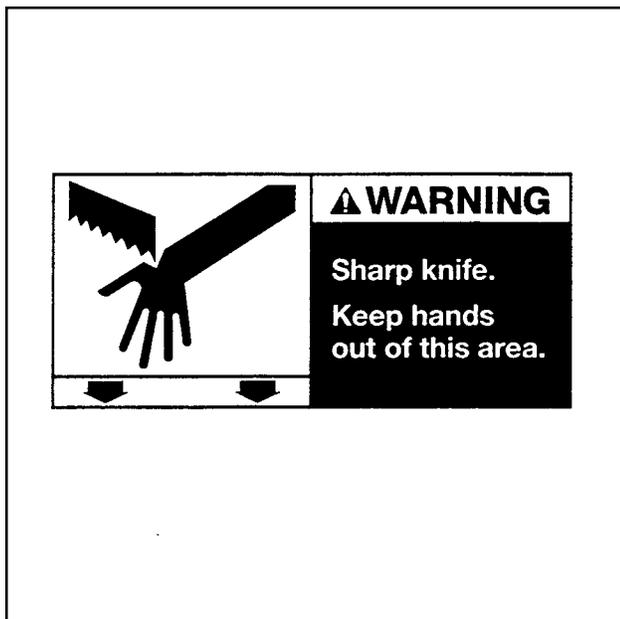


Figure 1-1 – Knife Warning Label

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



Figure 1-2 – Electrical Warning Label

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

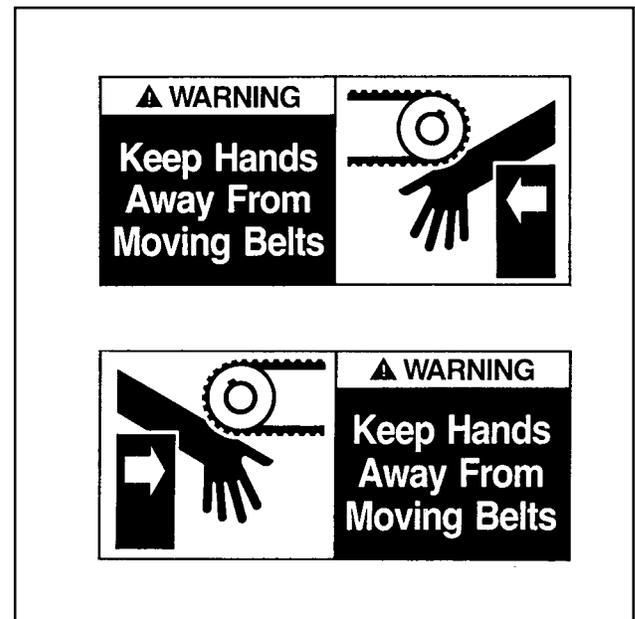


Figure 1-3 – Hands Warning Label

Important Safeguards (Continued)

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

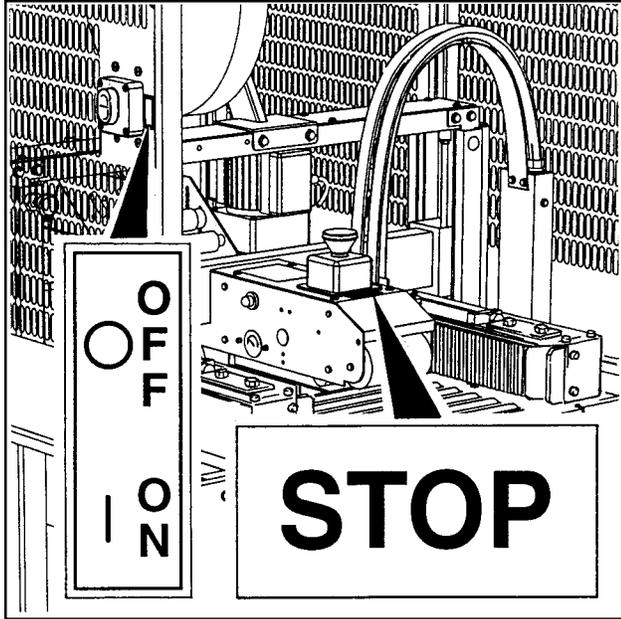


Figure 1-4 – Stop and On/Off Labels

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

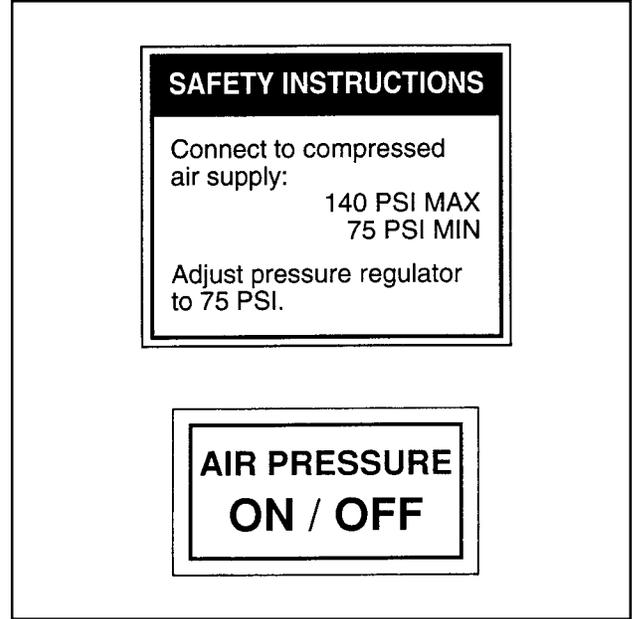


Figure 1-6 – Safety Instructions Label

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

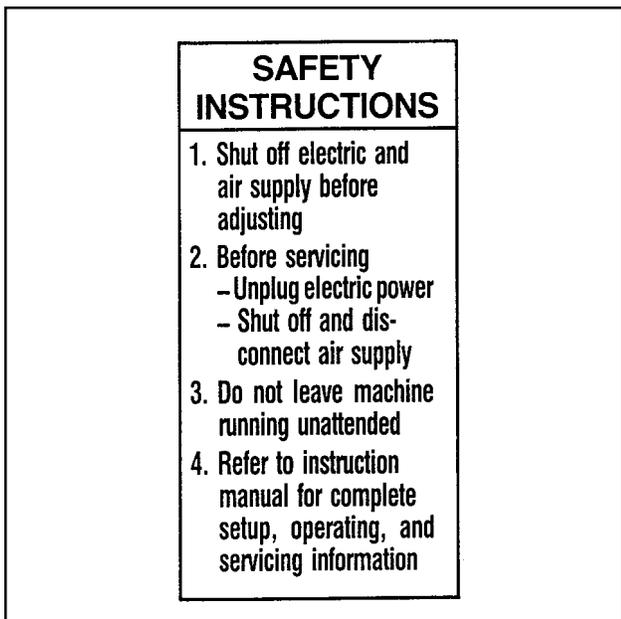


Figure 1-5 – Safety Instructions Label

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

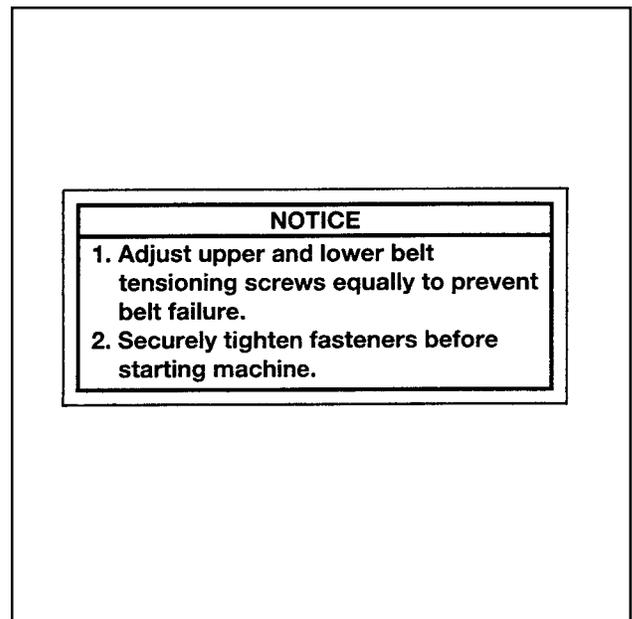


Figure 1-7 – Operating Notice Label

Important Safeguards (Continued)

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

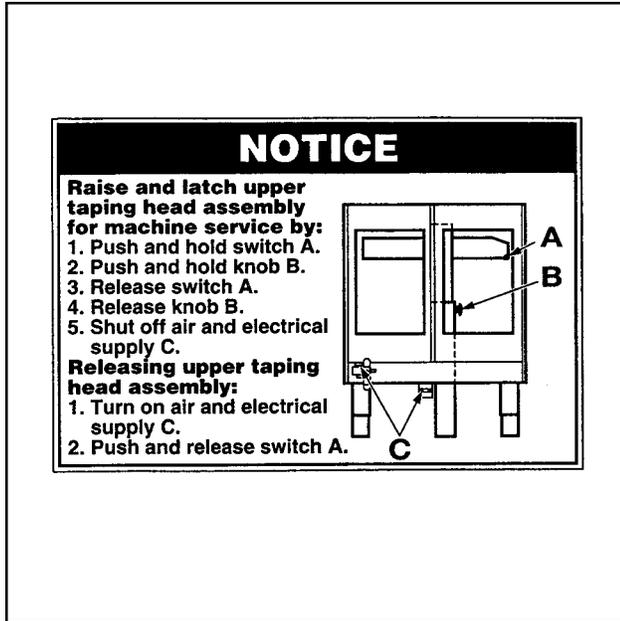


Figure 1-8 – Raise/Latch Upper Assembly Label

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

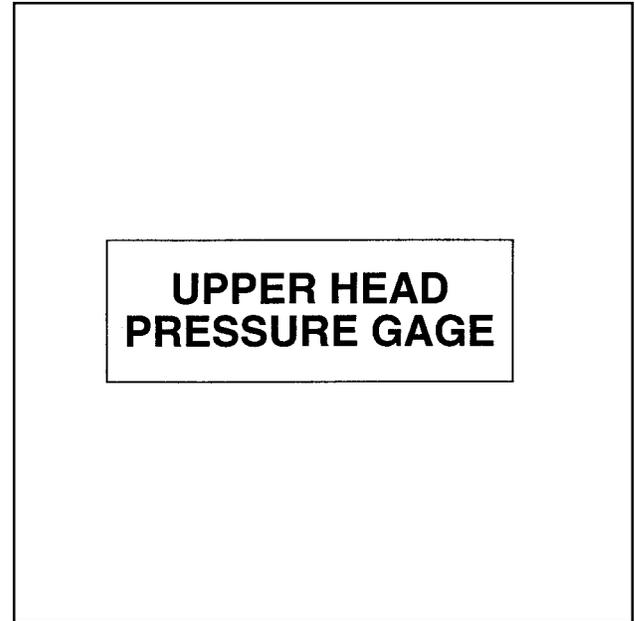


Figure 1-10 –Air Pressure Gage Label

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

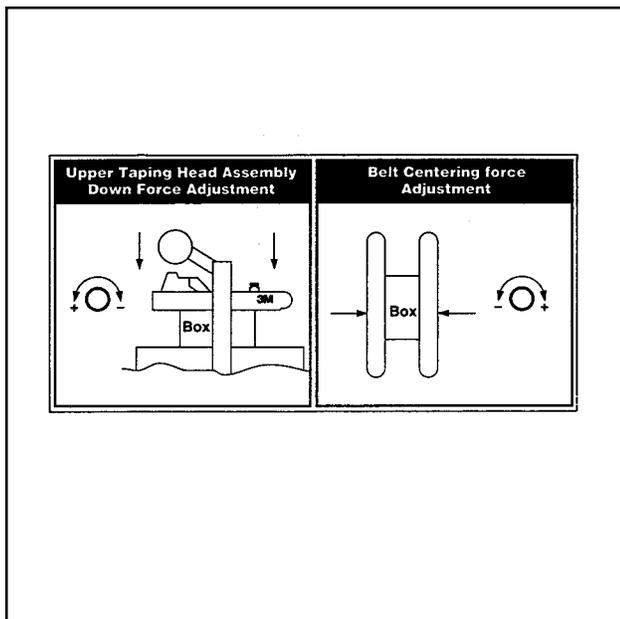


Figure 1-9 – Force Adjustment Label

Important Safeguards (Continued)

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

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

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



Figure 1-11 – Knife Warning Label

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

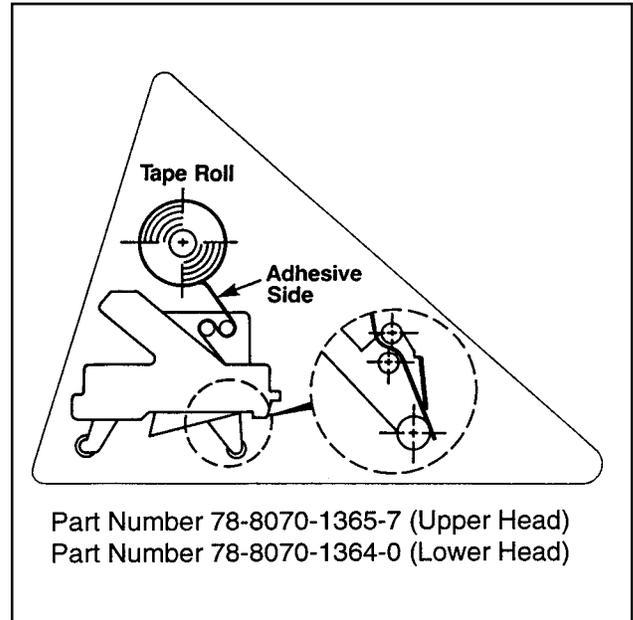


Figure 1-12 – Tape Threading Label

Specifications

1. Power Requirements:

Electrical – 115 VAC, 60 Hz, 3.8 A (440 watts)
Pneumatic – 6.5 bar gauge pressure [95 PSIG]
110 litre/min @ 21° C, 1.01 bar
[3.75 SCFM] at 15 boxes per
minute

The machine is equipped with two 1/6 HP gearmotors and comes with a 2.4 meter [8 ft] long standard neoprene covered power cord and a grounded plug. Contact your 3M Representative for power requirements not listed above.

2. Operating Rate:

Up to 15 boxes per minute. Actual production rate is dependent on box size, box size mix, and operator dexterity.

Box drive belt speed is 24 m/m [78 FPM]

3. Operating Conditions:

Use in dry, relatively clean environments at 4° to 50° C [40° to 120° F] with clean, dry, boxes.

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

4. Tape:

Scotch™ brand pressure-sensitive film box sealing tapes.

5. Tape Width:

48 mm [2.0 in] minimum to
72 mm [3.0 in] maximum

6. Tape Roll Diameter:

Up to 405 mm [16.0 in] maximum on a
76.2 mm [3.0 in] diameter core.
(Accommodates all system roll lengths of
Scotch™ brand film tapes.)

7. Tape Application Leg Length – Standard:

70 mm ± 6 mm [2.75 in ±.25 in]

Tape Application Leg Length – Optional:
(See "Special Set-Up Procedure", page 24)

50 mm ± 6 mm [2.00 in ±.25 in]

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.

Specifications (Continued)

9. Box Weight and Size Capacities:

Weight

Maximum – up to 38.6 kg [85 pounds]
Minimum – contents must support top flaps and weight must be sufficient to hold bottom flaps fully closed.

Box Size

OUTER COLUMNS IN STANDARD POSITION

MINIMUM

Length	–	205 mm [8.00 in]
Width	–	133 mm [5.25 in]
Height	–	127 mm [5.00 in]

MAXIMUM

Length	–	Not Limited
Width	–	508 mm [20.0 in]
Height	–	533 mm [21.0 in]

OUTER COLUMNS IN OPTIONAL RAISED POSITION

MINIMUM

Length	–	205 mm [8.00 in]
Width	–	130 mm [5.25 in]
Height	–	232 mm [9.12 in]

MAXIMUM

Length	–	Not Limited
Width	–	508 mm [20.00 in]
Height	–	644 mm [25.38 in]

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

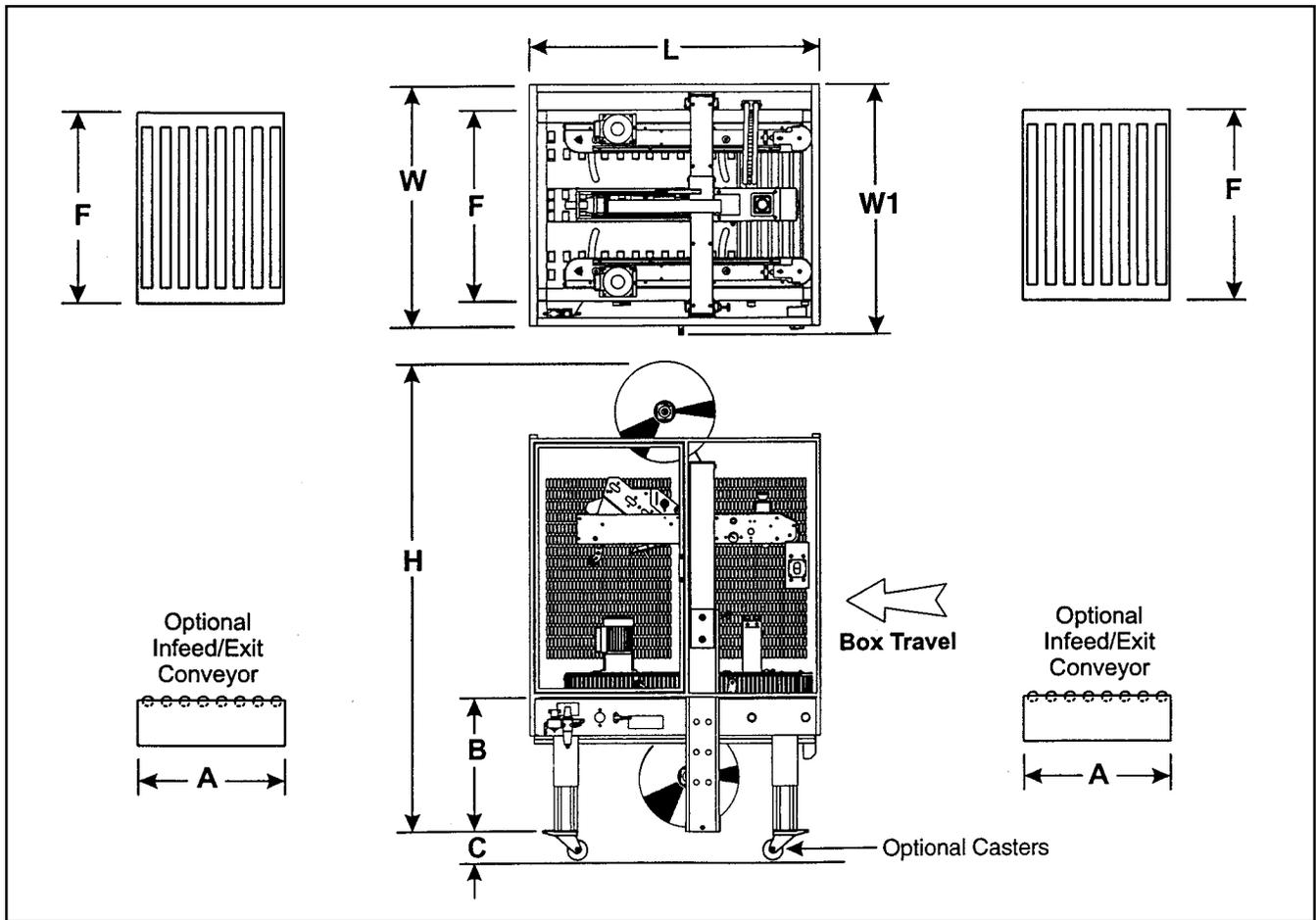
Note: The case sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is .5 or less, then several boxes should be test run to assure the proper machine performance.

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)



10. Machine Dimensions:

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

* Exit conveyor is optional

** Casters are optional

*** When columns are adjusted to upper position, "H" maximum dimension is 2062 mm [81.19 inches]. (See "Special Set-Up Procedure – Outer Column Re-Positioning", page 24)

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

11. Set-Up Recommendations:

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

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 your 3M Representative.

Machine Set-Up

Important – Read "Warnings" on page 17 before attempting to set-up the case sealer for operation.

The following instructions are presented in **the order recommended** for setting up and installing the case sealer. Following them step by step will result in an installation in your production line that best utilizes the many features built into the case sealer. Refer to Figures 3-1 and 3-2 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. Lift off fiberboard cover off pallet after removing staples at bottom.
2. Remove protective wrapping around machine.
3. Remove hardware that secures case sealer legs to pallet.
4. Cut cable ties that secure upper assembly to machine bed on each side of machine. Remove and discard cable ties and foam blocks.

5. Ensure that the tape drum bracket assembly, located on the lower taping head, is mounted straight down, as shown in Figure 2-1A. The tape drum bracket assembly can be pivoted to provide tape roll clearance in certain cases.
6. Use appropriate material handling equipment to remove the machine from the pallet and move it into position.

 **CAUTION – Machine weighs approximately 208 kg [460 pounds] uncrated.**

7. 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 510 mm [20 in] minimum to 690 mm [27.25 in] maximum.

Note – Minimum machine bed height can be reduced to 400 mm [15.75 inch] by moving outer columns up one set of mounting holes. However, this change also reduces minimum box height of 127 mm [5.00 inch] to 232 mm [9.12 inch]. (See "Special Set-Up Procedure – Outer Column Re-positioning", page 24.)

Refer to Figure 2-1C and set the machine bed height as follows:

- a. Use appropriate material handling equipment and blocking techniques to raise the machine frame to allow adequate leg adjustment.
- b. Loosen, but do not remove, two M8 x 16 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.

Installation and Set-Up (Continued)

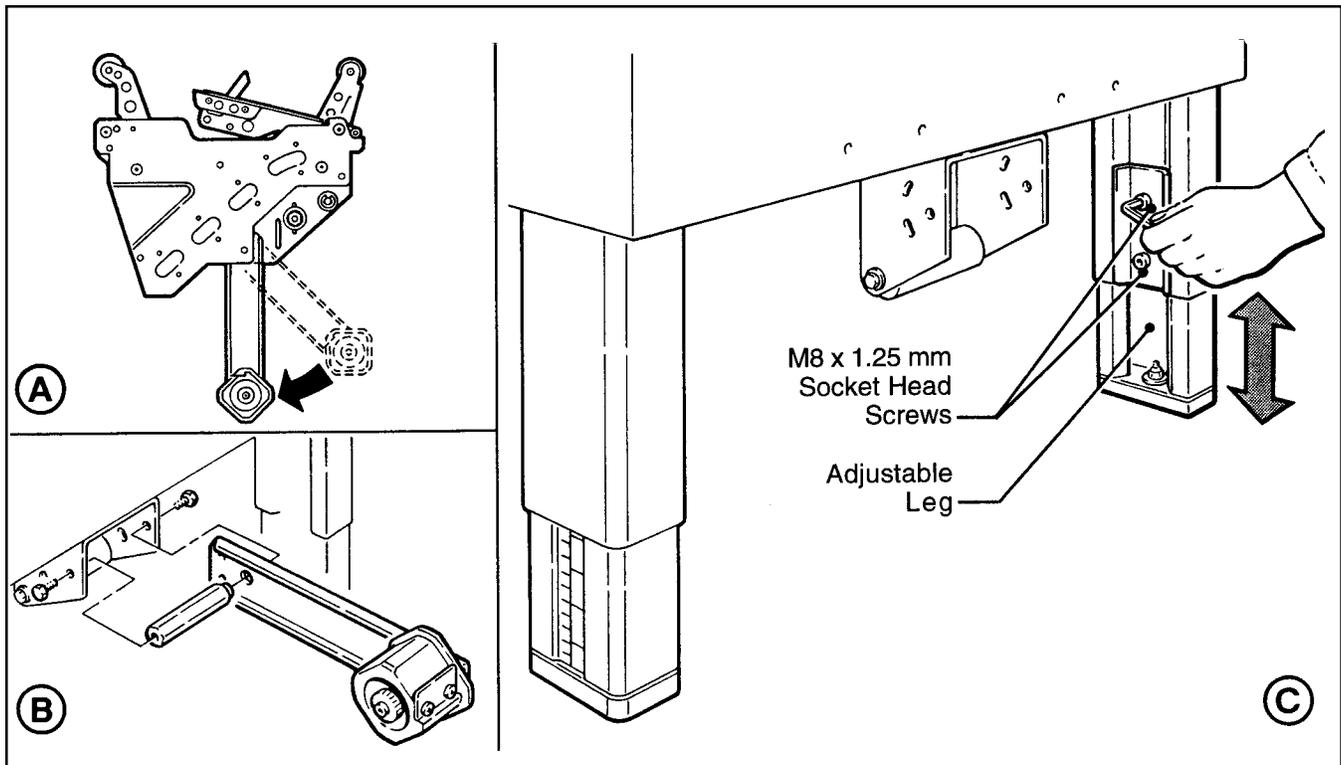


Figure 2-1 – Conveyor Bed Height Adjustment and Lower Tape Drum Bracket Position

OUTBOARD TAPE ROLL MOUNTING (Lower Taping Head Alternate Position)

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 2-1B.

TAPING HEADS

Tape Width – the taping heads have been pre-set to accommodate 72 mm [3 inch] wide tape rolls. To apply 48 mm [2 inch] or 42 mm [1.75 inch] wide tapes, refer to Section II, "Adjustments – Tape Web Alignment", page 11.

Tape Leg Length – taping heads are pre-set to apply 70 mm [2.75 in] long tape legs. To change tape legs to 50 mm [2.0 inch], refer to Section I, "Special Set-Up Procedure – Changing Tape Leg Length", page 24.

BOX SIZE CAPACITY OF CASE SEALER

At its factory setting, the case sealer handles box sizes up to 533 mm [21.00 in] maximum height. If larger capacity is needed, the machine can be adjusted to accommodate boxes up to 644 mm [25.38 in] high. Refer to page 24, "Special Set-Up Procedures – Outer Column Re-positioning", for set-up procedure.

Note – Adjusting machine to accommodate 644 mm [25.38 in] high boxes also increases minimum box size to 232 mm [9.12 in].

Installation and Set-Up (Continued)

PNEUMATIC CONNECTION



WARNING – Use care when working with compressed air.

The case sealer requires a 6.5 bar gauge pressure [95 PSIG], 110 litre/min @ 21° C, 1.01 bar [3.75 SCFM] compressed air supply.

Using customer supplied air hose (8 mm [.31 in] I.D.) and clamp provided with machine, connect plant air to barbed fitting on inlet side of "On/Off" valve. See Figure 2-2. **Note:** *If another type of connector is desired, the barbed fitting can be replaced with the desired 1/4-18 NPT connector.*

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

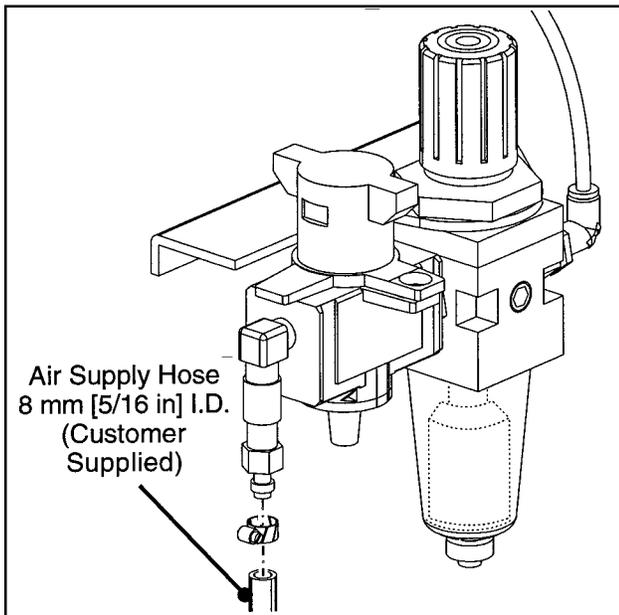


Figure 2-2 – Pneumatic Connection

ELECTRICAL CONNECTION AND CONTROLS

The electrical control box, located on the lower right side of the machine frame, contains the pre-set circuit breaker. The control box can be located on the opposite side of the machine frame if desired. A standard three conductor power cord with plug is provided at the back of the electrical control box for 115 Volt, 60 Hz, 6.4 Amp electrical service. The receptacle providing this service shall be properly grounded. Before the power cord is plugged into 115 Volt, 60 Hz outlet make sure the red "Off" button is depressed and that all packaging materials and tools are removed from the machine. **Do not plug electrical cord into outlet until ready to run machine.**

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

IMPORTANT – Before operating the case sealer, read the "Important Safeguards", pages 3-6 and "Warnings" on page 17 as well as all of the "Operation" instructions.

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

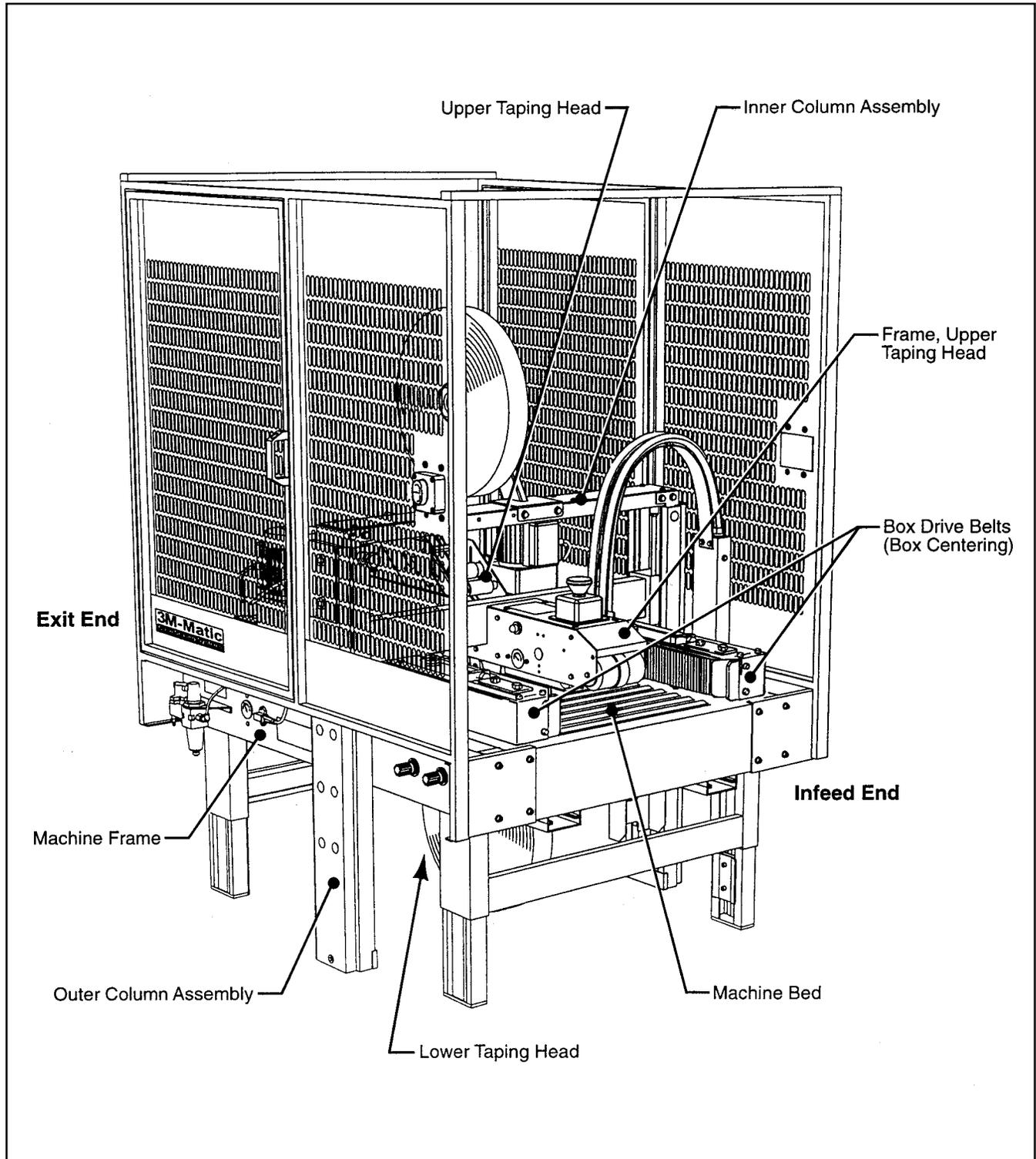


Figure 3-1 – Case Sealer Components

Operation (Continued)

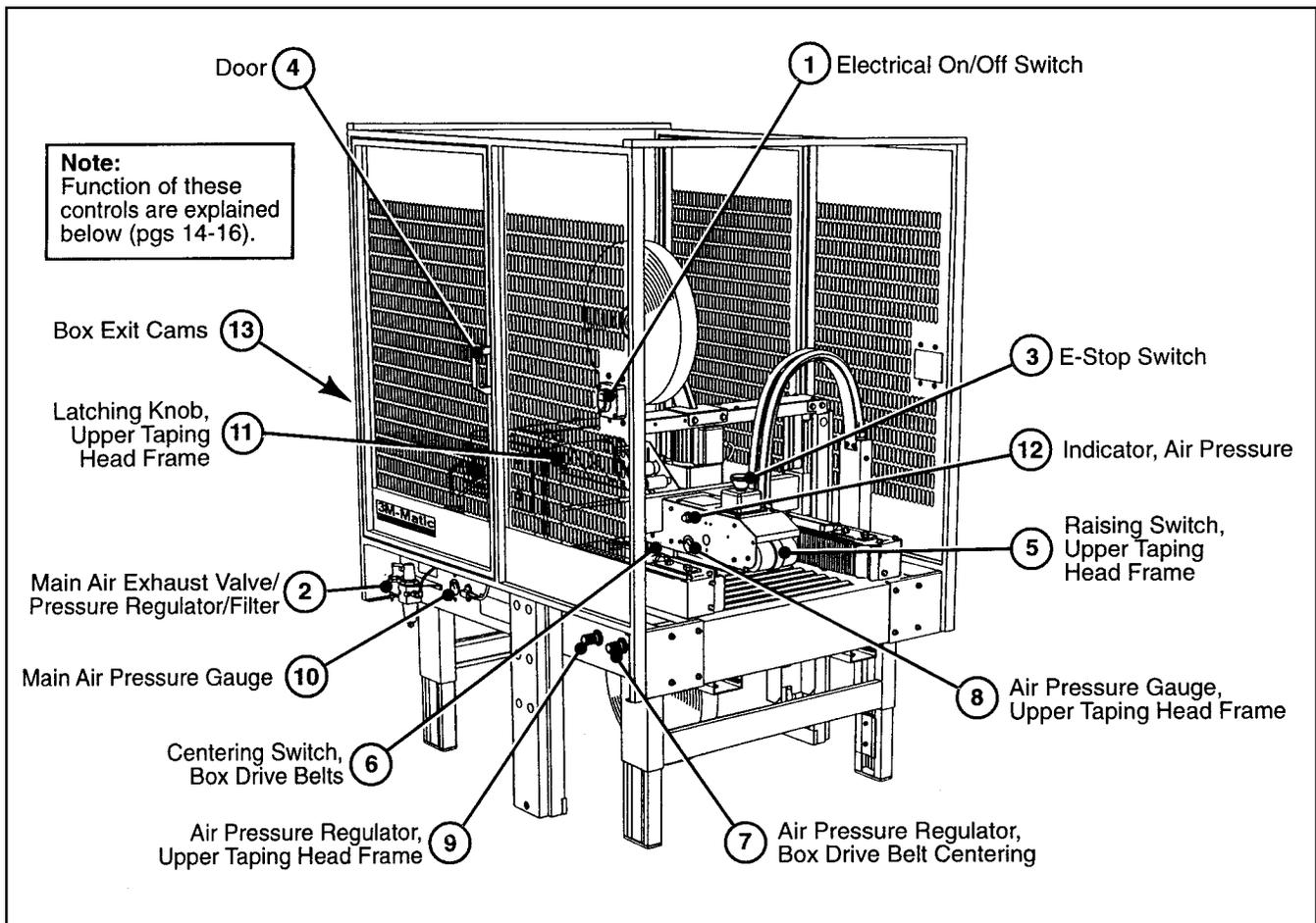


Figure 3-2 – Controls, Valves and Switches

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

Note – The case sealer has a circuit breaker located in the electrical control box on the lower right side of the machine frame. If circuit becomes overloaded and circuit breaker trips, see "Maintenance – Circuit Breaker", page 22.

- ② **Main Air "On/Off" Valve/Pressure Regulator/Filter** – Figure 3-3
This set of pneumatic components controls, regulates and filters plant air supply to the two separate control circuits of the case sealer.

"On/Off" Valve – "On" turn to "SUP" – "Off" turn to "EXH". **Note** – Turning air supply "Off" automatically bleeds air pressure from the case sealer air circuits.

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

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

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

Filter removes dirt and moisture from plant air before it enters the case sealer pneumatic circuits. If water collects in bottom of bowl, lift up on the valve on the bottom of bowl to drain.

Operation (Continued)

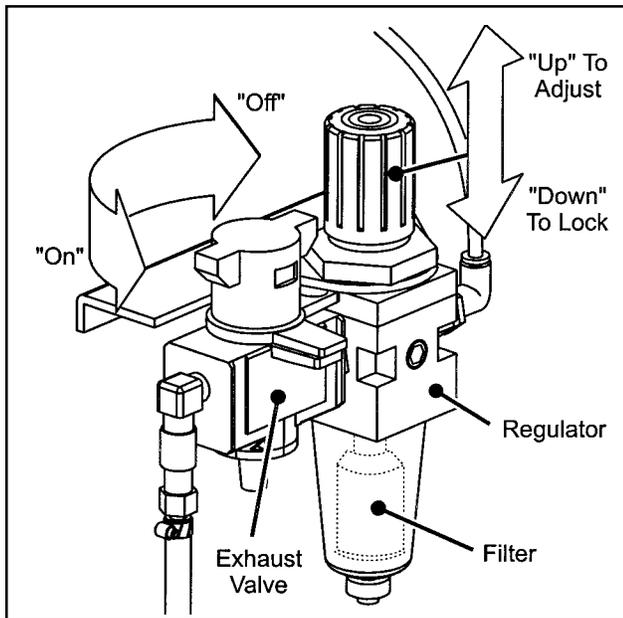


Figure 3-3 – "On/Off" Valve/Regulator/Filter

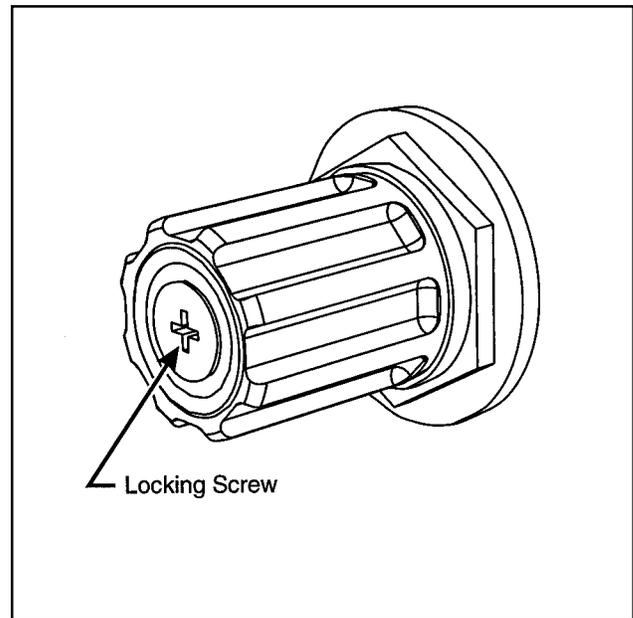


Figure 3-4 – Air Regulator, Drive Belts

- ③ **E-Stop Switch**
The E-Stop switch kills electrical power and exhaust air pressure from the drive belt assemblies. The upper head assembly will raise to its upper most position. To restart machine, rotate E-stop switch (releases switch latch) and then restart machine by pressing electrical switch "I" (On) button on side guard of machine.
- ④ **Door**
The door is equipped with a safety interlock which kills electrical power and exhaust air pressure from the drive belt assemblies. The upper head assembly will raise to its upper most position when the door is opened.

⚠ WARNING – The E-Stop switch or door must not be used for raising the upper head assembly for maintenance work. If these are used the upper head assembly could lower during maintenance work causing injury to personnel.

- ⑤ **Raising Switch, Upper Taping Head Frame**
This switch, when touched by the leading edge of a box, pneumatically raises the upper frame to allow insertion of a box under the upper frame, as the box moves under the switch, releasing it, the upper frame descends on the box and the drive belts convey the box through the machine. When switch is actuated by hand, the upper frame rises to its maximum height. Released, the upper frame descends to its rest position.
- ⑥ **Centering Switch, Box Drive Belts**
This pneumatic switch controls the closing (centering) of the drive belts. When switch is activated by a box passing under it, the drive belts close and center the box.
- ⑦ **Air Pressure Regulator, Box Drive Belt Centering – Figure 3-4.**
This regulator is used to adjust drive belt centering pressure. The factory set point is 5 turns clockwise. If more pressure is needed to center box, turn knob clockwise to desired pressure. If box is being crushed, turn knob counterclockwise to relieve pressure. Regulator is locked by tightening screw.
- ⑧ **Air Pressure Gauge, Upper Taping Head Frame**
This gauge, used in conjunction with the upper frame air regulator, provides operator with a reference pressure setting for various size/weight boxes.

Operation (Continued)

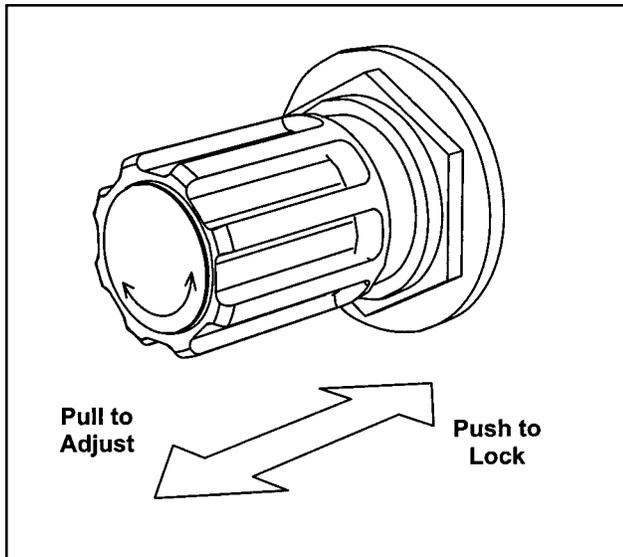


Figure 3-5 – Air Regulator, Upper Taping Head Frame

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

Set nominally to control "down" pressure against box. The factory set point is 15 PSIG [1 bar]. The regulator setting is adjusted as necessary to allow free movement of boxes through taping heads while maintaining boxes flaps in fully closed position. Decreasing air pressure will increase down pressure on boxes while increasing air pressure will decrease down force on boxes.

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

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

10 Main Air Pressure Gauge

Indicates main air regulator pressure setting. Air regulator should be adjusted so gauge reads 6.5 bar gauge pressure [95 PSIG].

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

The mechanical latch is provided to hold the upper frame at the fully raised position for tape threading and maintenance.

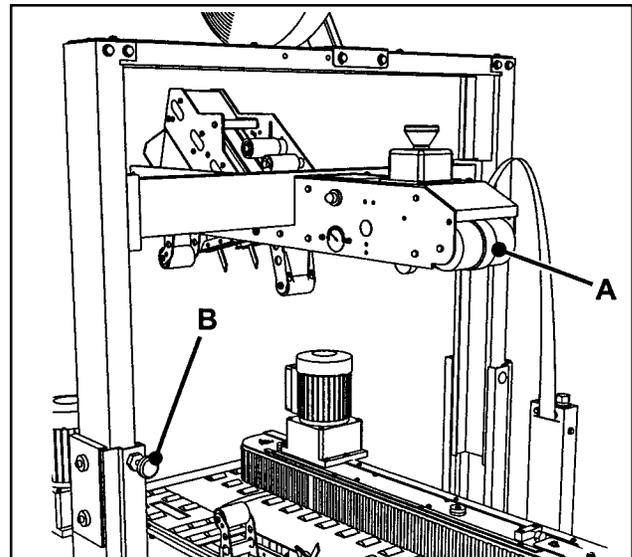


Figure 3-6 – Latching Knob, Upper Taping Head Frame

To raise and latch the upper frame:

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

To release and lower the upper frame:

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

WARNING – Do not put hands beneath upper taping head frame when upper frame lowers to its rest position. Severe personal injury could result.

12 Indicator, Air Pressure

An "Optical" Warning Indicator for the compressed air circuit of the machine is located on the upper taping head frame just behind the red "Stop" button. When indicator is "Red", air circuit is on.

13 Box Exit Cams

These cams, when tripped by exiting box, signal drive belts to return to their fully open (rest) position.

Operation (Continued)



WARNINGS

1. Turn electrical and air supply off and disconnect before servicing taping heads or performing any adjustments or maintenance on the machine.
2. Turn electrical and air supply off when machine is not in use.
3. Before turning drive belts on, be sure no tools or other objects are on the conveyor bed.
4. Keep hands and loose clothing away from moving belts.
5. Never attempt to remove jammed boxes from the machine while machine is running.
6. Be aware of the pneumatically controlled movement of the upper frame and drive belts. Keep away from these components when air and electrical supplies are on.
7. When feeding boxes to the machine by hand, push box in from end only – DO NOT PUSH WITH HANDS ON ANY CORNER OF THE BOX.
8. Both the upper and lower taping heads utilize extremely sharp knife blades. The blades are located under the orange blade guard which has the "WARNING – SHARP KNIFE" label. Before loading tape, refer to Figures 3-1 and 3-2 in Section II to identify the blade location. Keep hands out of these areas except as necessary to service the taping heads.
9. Failure to comply with these warnings can result in severe personal injury and/or equipment damage.

Tape Loading/Threading

See Section II, pages 7 and 8.

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

Operation (Continued)

Box Sealing

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

WARNING – Keep hands away from drive belts when feeding boxes to machine. Push boxes from the end only, DO NOT push with hands on any corners of the box.

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

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

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

5. Turn air and electrical supplies "Off" when machine is not in use.
6. Reload and thread tape as necessary.
7. Be sure machine is cleaned and lubricated according to recommendations in "Maintenance" section of this manual.

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.

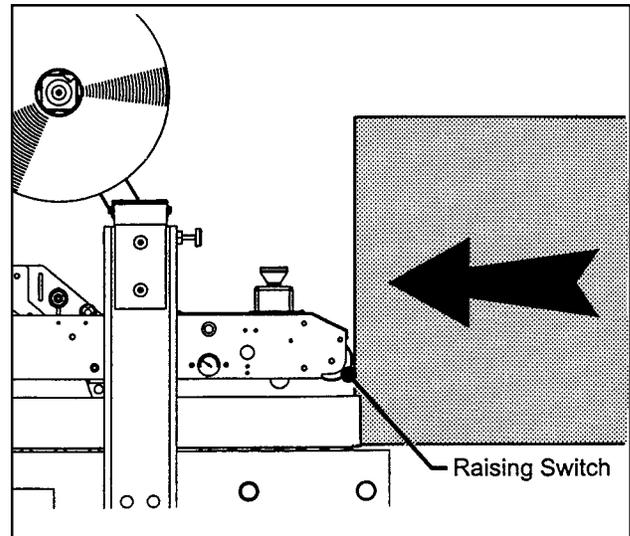


Figure 3-7 – Operation

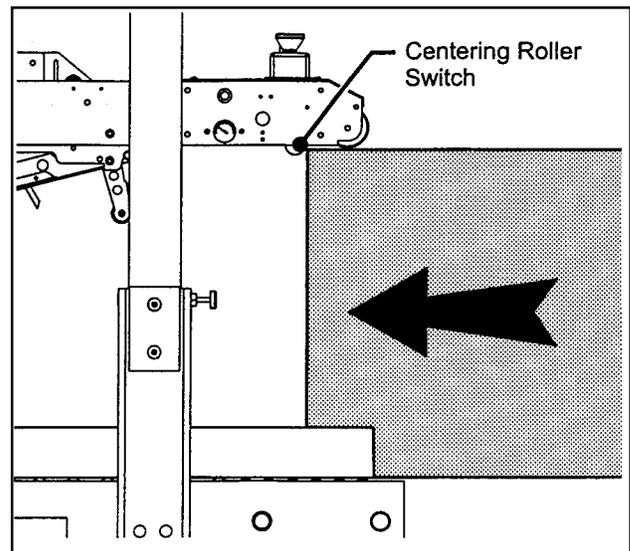


Figure 3-8 – Operation 8888 – Operation

Box Jam

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

Maintenance

The case sealer 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 – Turn off electrical and air supplies and disconnect power cord from electrical supply before beginning maintenance. If electrical power is not disconnected, severe injury to personnel could result.

Cleaning

Note – Never attempt to remove dirt from taping heads 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 or subject equipment to conditions causing moisture condensation on components. 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

Like most other equipment, the case sealer must be properly lubricated to insure long, trouble free service. Most of the machine bearings are permanently lubricated and sealed and do not need to be greased. The drive motor is also permanently lubricated and does not require additional lubrication.

Figures 4-1 illustrates the frame points which should be lubricated every 250 hours of operation. Lubricate the points noted by solid arrow (➡) with SAE #30 non-detergent oil. Lubricate the points noted by outline arrow (⇨) with multipurpose grease.

Note – Wipe off excess oil and grease. It will attract dust and dirt 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.

Taping Head Lubrication – See Section II, "Maintenance – Lubrication", page 10.

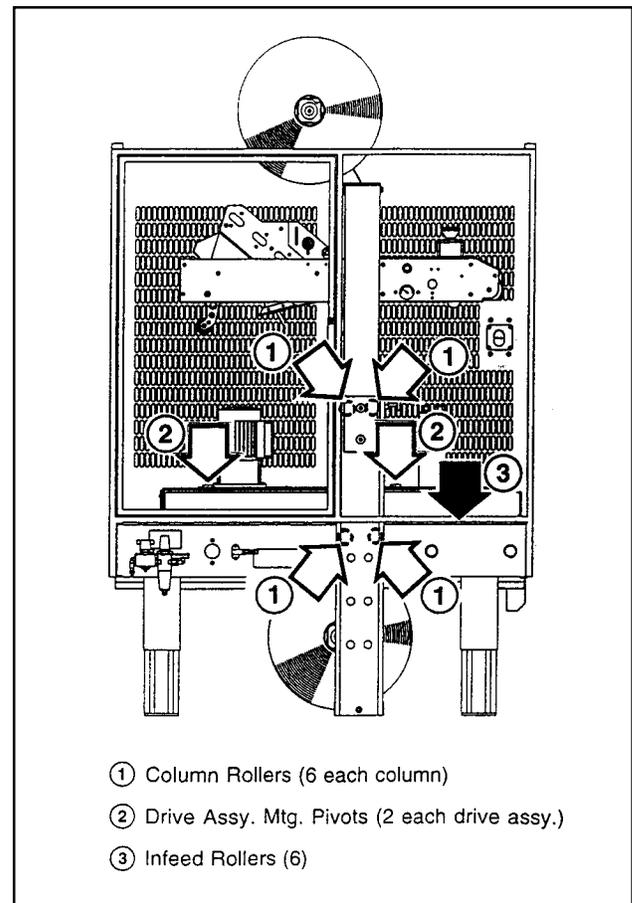


Figure 4-1 – Frame Lubrication Points

Maintenance (Continued)

WARNING – Turn off electrical and air supplies and disconnect power cord from electrical supply before beginning maintenance. If power cord is not disconnected, severe injury to personnel could result.

Drive Belts

WARNING –The E-Stop switch or door must not be used for raising the upper head assembly for maintenance work. If these are used the upper head assembly could lower during maintenance work causing injury to personnel.

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

REPLACEMENT – SEE STEPS 1 THRU 17

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

1. Turn air and electrical supply on.
2. Push and hold the upper frame raising switch (A). Figure 3-2, page 16.

3. Push and hold the latching knob (B). Figure 3-6, page 16.
4. Release switch (A). Knob (B) will lock the upper head assembly in the upper position.
5. Shut off air supply.
6. Disconnect motor plug (A). Figure 4-2.
7. Remove and retain snap rings (B) and special washer (C) from front and rear arm assembly pivots. Figure 4-2.
8. Lift side drive assembly (D) up and off arm assembly pivots. Figure 4-2.

WARNING – Each drive assembly weighs approximately 20.4 kg [45 lbs]. To prevent injury, drive assembly should be lifted by two people, one at the front and one at the rear.

9. Remove and retain the four screws (E), washers (F) and side cover (G). See Figure 4-2.

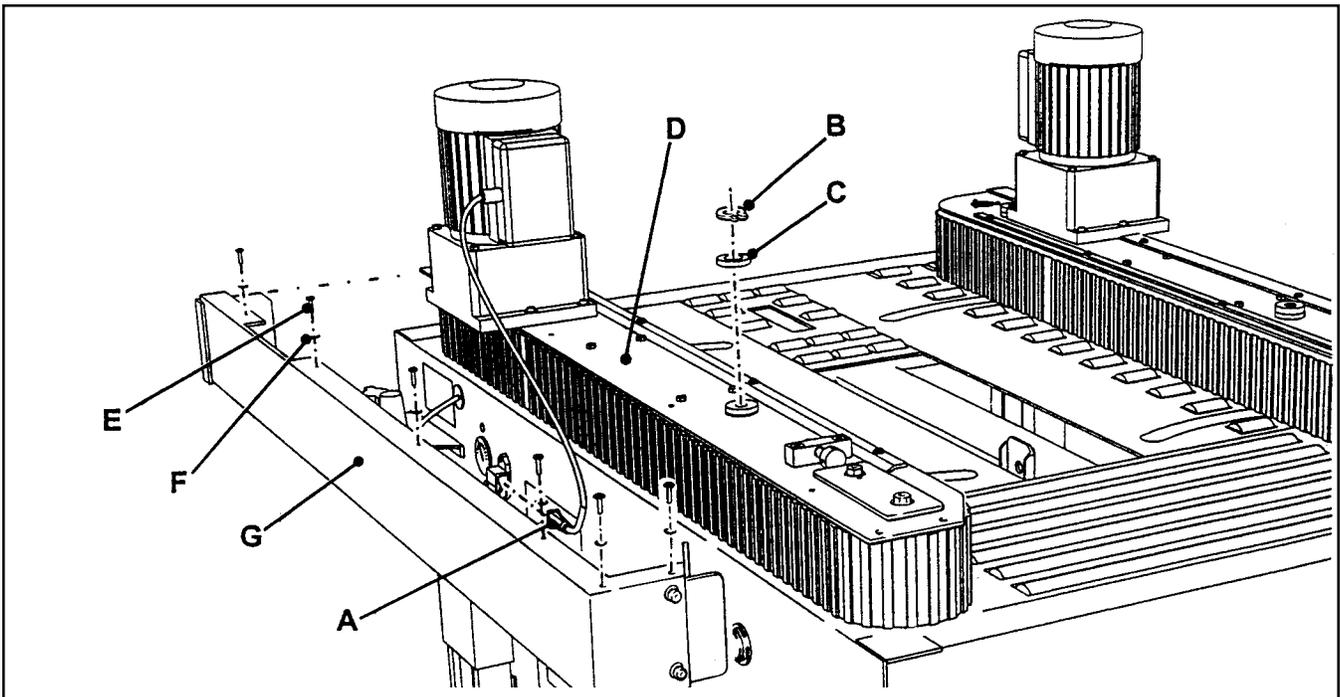


Figure 4-2 – Box Drive Belt (Left Side View – Infeed End)

Maintenance (Continued)

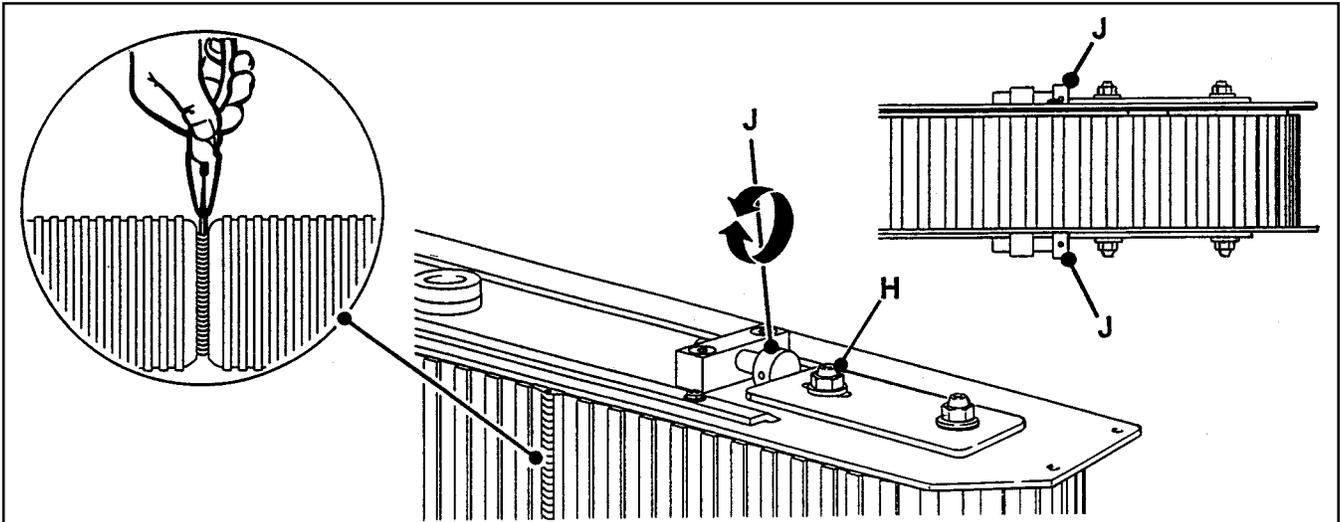


Figure 4-3 – Box Drive Assembly, Infeed End

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

Note – Before installing new drive belt, check the belt inside surface for drive direction arrows and install belt accordingly. If no arrows are shown, the belt may be installed either way.

14. To set drive belt tension, turn adjustment screws (J) equally on both the upper and lower tension assemblies. Turn the screws counterclockwise to increase tension or clockwise to decrease tension. See Figure 4-3.

Use a force gauge to pull the belt outward 25 mm [1 in] at midspan, as shown in Figure 4-4 with a moderate pulling force of 3.5 kg [7 lbs].

15. After adjusting belt tension, tighten lock nuts (H) on both the upper and lower tension assemblies.
16. Reverse procedures in Steps 1-6 to complete drive reassembly.
17. Repeat procedure for other belt.

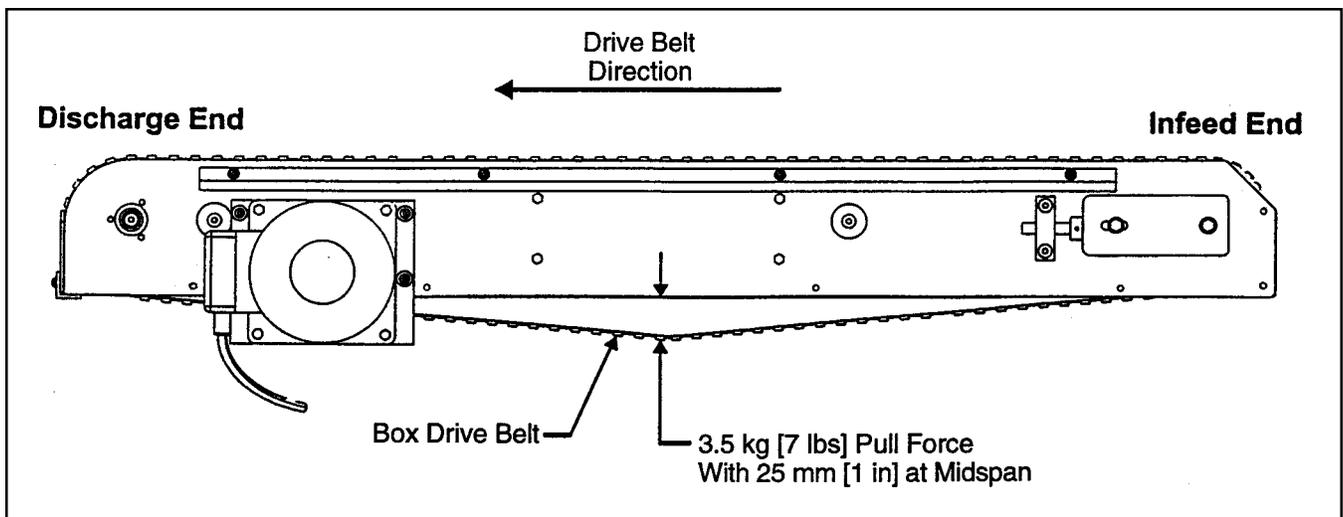


Figure 4-4 – Box Drive Belt Tension Adjustment, Top View

Maintenance (Continued)



WARNING – Turn off electrical and air supplies and disconnect power cord from electrical supply before beginning maintenance. If power cord is not disconnected, severe injury to personnel could result.

Circuit Breaker

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



WARNING – The following procedure must be performed by trained service personnel because of the high voltage electrical hazard within the control box.

Knife Replacement, Taping Head

See Section II, "Maintenance – Knife Replacement", page 9.

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

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

Adjustments



WARNING – Turn air supply and electrical power off and disconnect power cord from power supply before beginning adjustments. If power cord is not disconnected, severe injury to personnel could result.

Drive Belt Tension

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

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

To adjust belts, see "Maintenance – Drive Belts", page 20.

Taping Head Adjustments – Refer to Section II



WARNING – Use care when working near tape cut-off blades on taping heads as blades are extremely sharp. If care is not taken, severe injury to personnel could result.

TAPE WEB ALIGNMENT – Section II, Page 11

TAPE DRUM FRICTION BRAKE – Section II, Page 11

APPLYING MECHANISM SPRING – Section II, Page 11

ONE-WAY TENSION ROLLER – Section II, Page 12

TAPE LEG LENGTH ADJUSTMENT – Section II, Page 13

Special Set-Up Procedure



WARNING – Turn air supply and electrical power off and disconnect power cord from power supply before beginning special set-up procedure. If power cord is not disconnected, severe injury to personnel could result.

Changing the Tape Leg Length

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

Changing tape leg length to 50 mm [2 in] allows taping of smaller boxes. Refer to "Specifications – Box Weight and Size Capacities", page 8 for box sizes.

CASE SEALER FRAME

No changes required.

TAPING HEADS



WARNING – Use care when working near taping head knives as knives are extremely sharp. If care is not taken, severe injury to personnel could result.

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



WARNING –The E-Stop switch or door must not be used for raising the upper head assembly for maintenance work. If these are used the upper head assembly could lower during maintenance work causing injury to personnel.

3. Remove lower taping head by pulling straight up.
4. Refer to Section II "Adjustments – Changing Tape Leg Length", page 13.

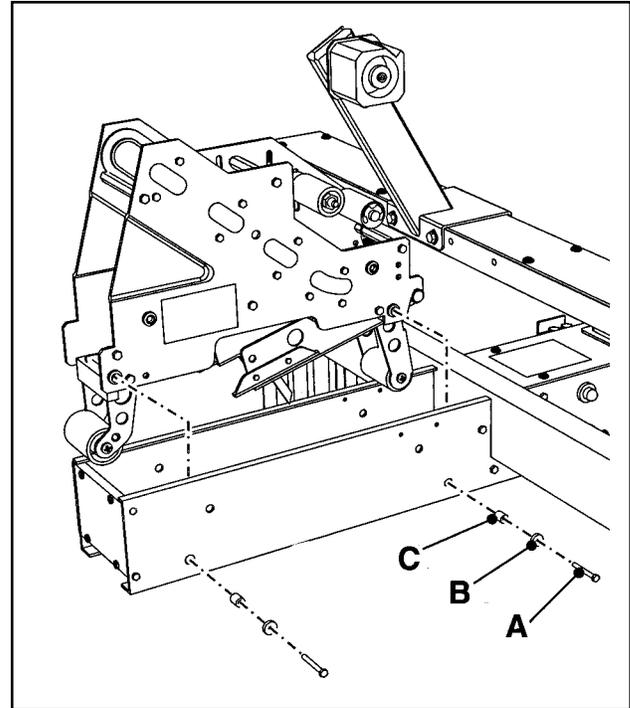


Figure 5-1 – Upper Taping Head Mounting

Outer Column – Re-Positioning



WARNING – It is recommended that no less than two people assist on this set-up or severe injury or equipment damage could result.

Moving the outer columns to the upper set of mounting holes, increases the maximum box size (height) handled by the case sealer from 533 mm [21.00 in] to 644 mm [25.38 in]. (Dimensions given are with lift cylinders mounted in standard position.)
Note – This also increases the minimum box height from 127 mm [5.00 in] to 232 mm [9.12 in].

Refer to Figure 5-2

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

Special Set-Up Procedure (Continued)

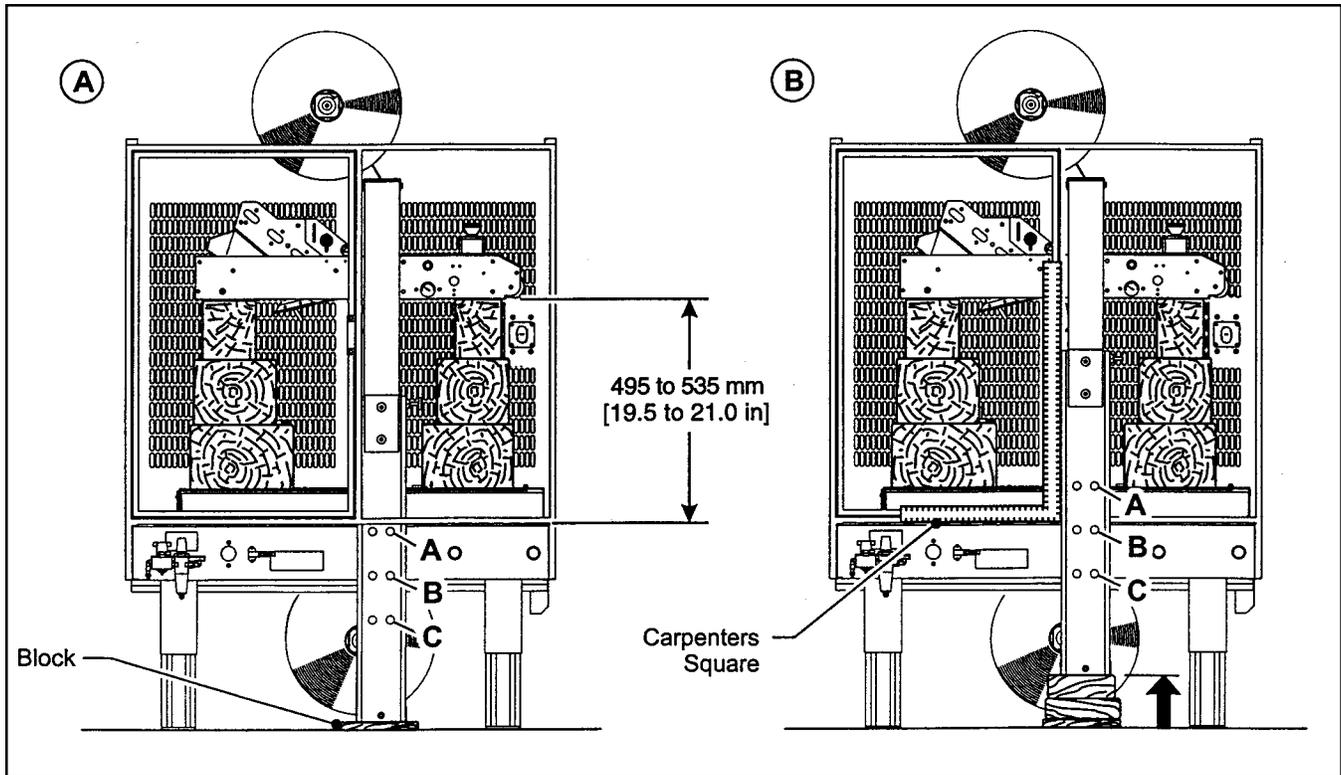


Figure 5-2 – Column Re-Positioning

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

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Troubleshooting

The Troubleshooting Guide lists some possible machine problems, causes and corrections. Also see Section II "Troubleshooting", pages 15 and 16 for taping head problems.

Troubleshooting Guide

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

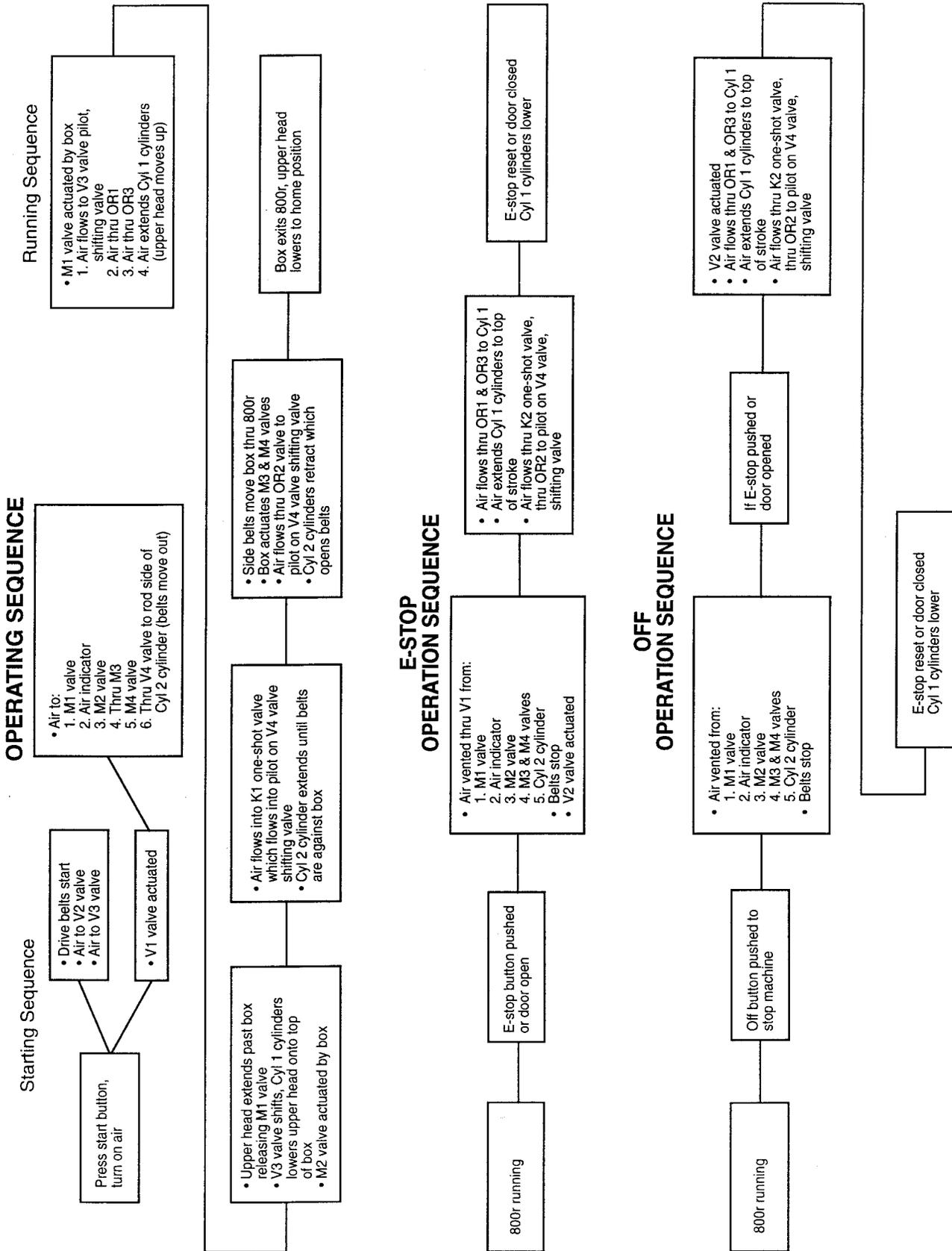
(Continued)

Troubleshooting (Continued)

Troubleshooting Guide

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

800r3 Case Sealer Operating Sequence



Electrical/Pneumatic Diagrams

⚠ WARNING – Electrical service procedures must be performed by a qualified electrical technician. Turn off and disconnect electrical and pneumatics before servicing unit. High voltage inside electrical enclosure can cause severe injury or death.

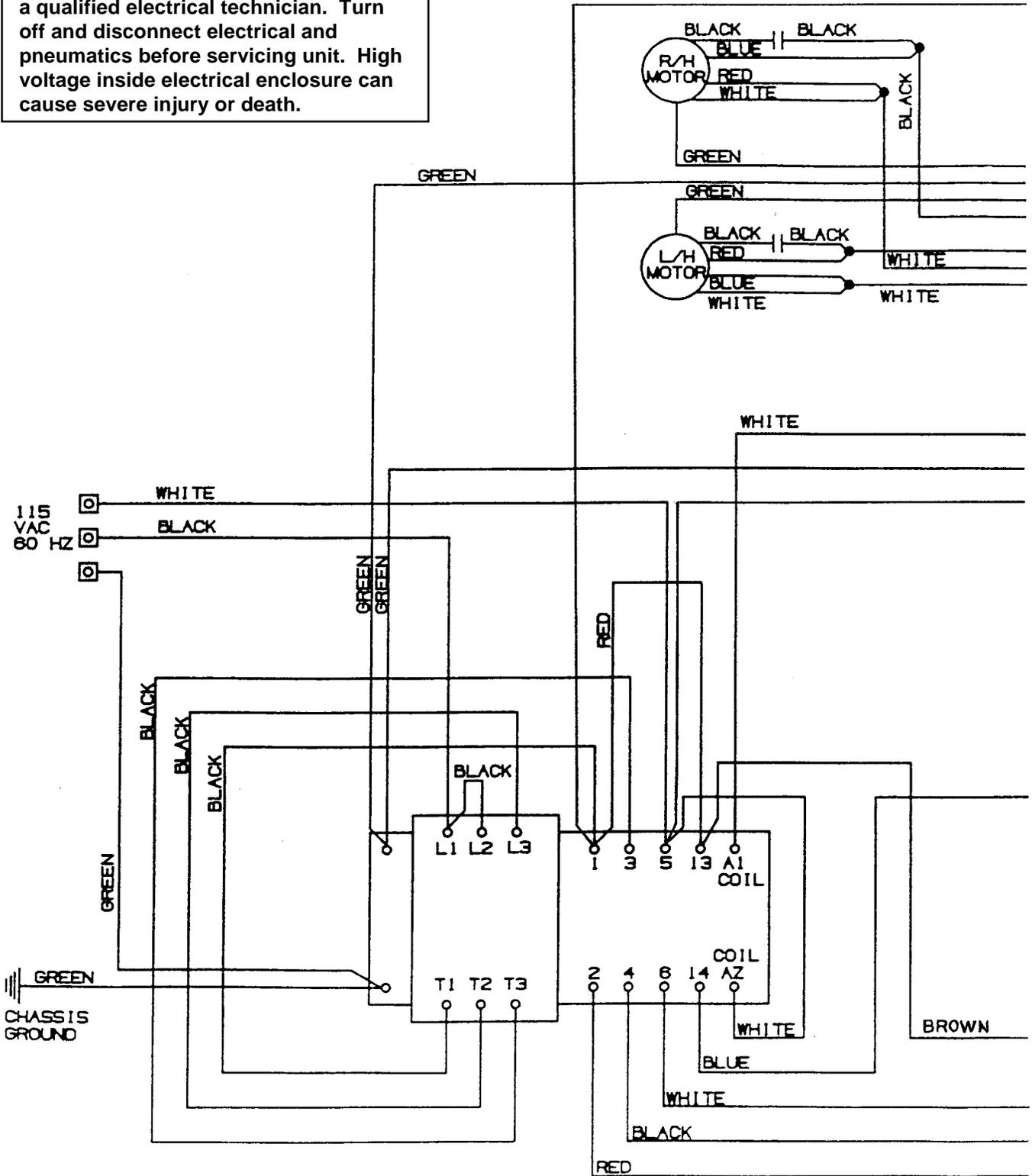
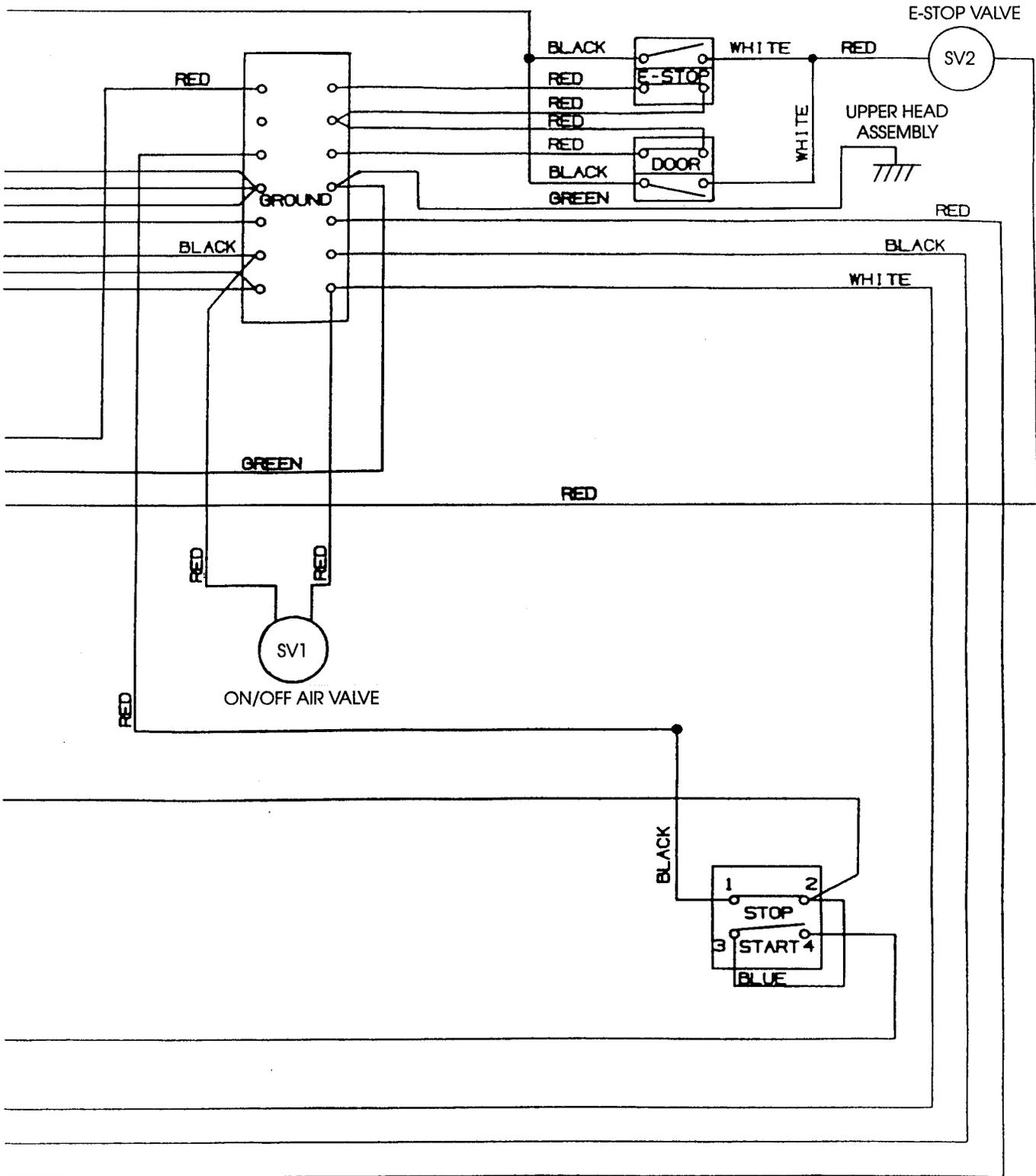


Figure 6-1 – Electrical Diagram



Electrical/Pneumatic Diagrams (Continued)

⚠ WARNING – Turn off and disconnect air and electrical supplies before servicing pneumatic components. High pressure air can cause severe injury.

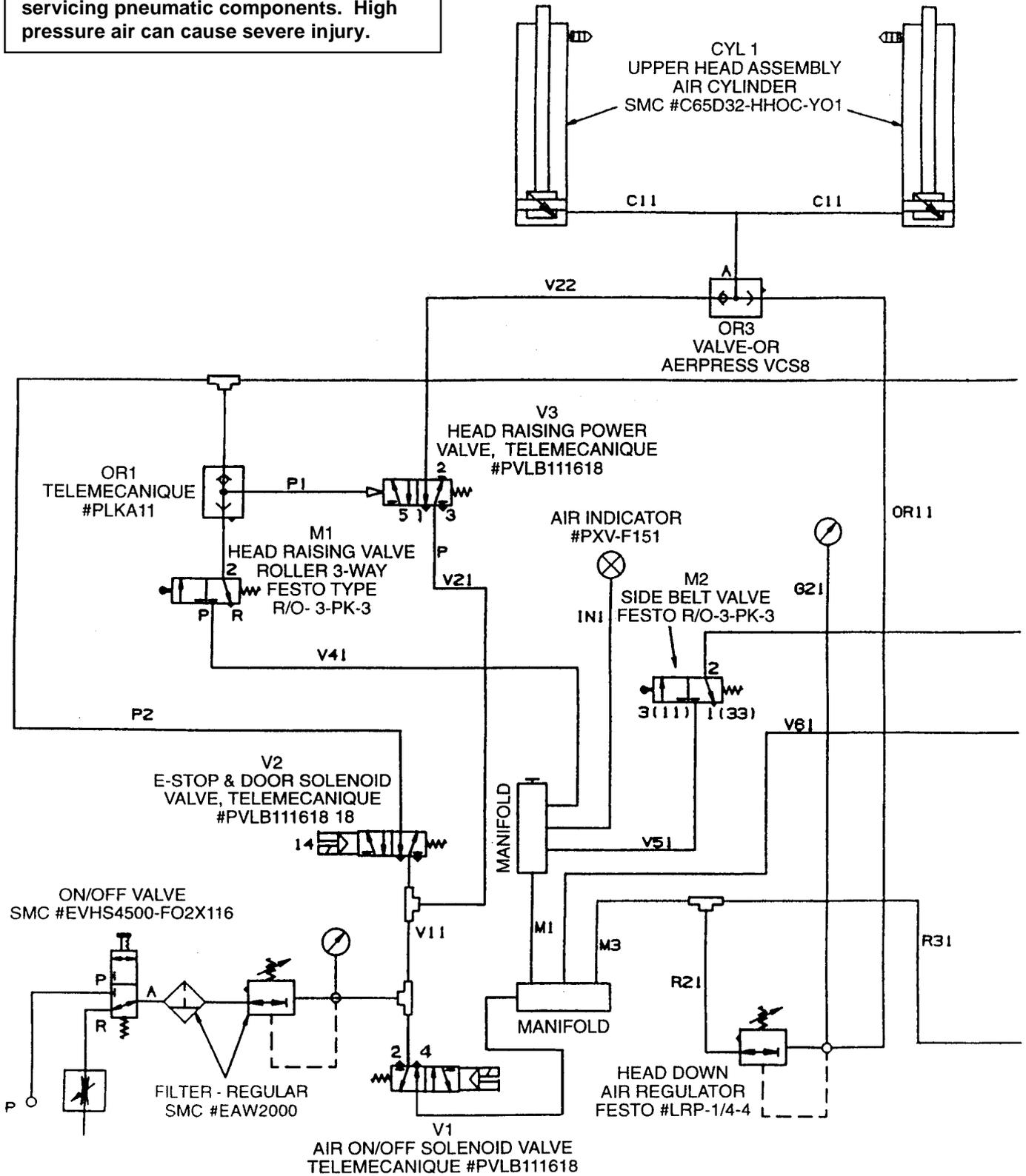
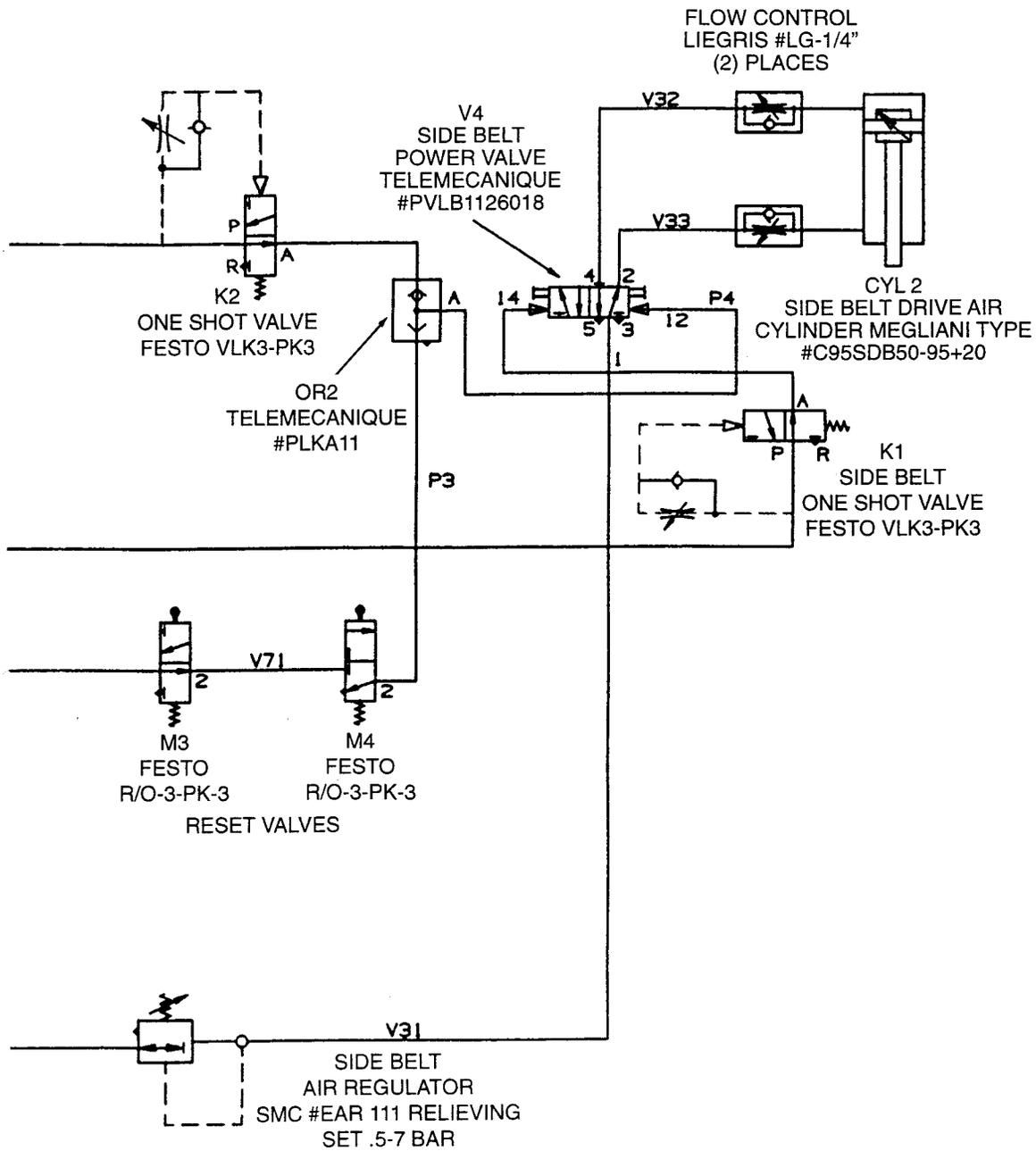


Figure 6-2 – Pneumatic Diagram



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Parts and Service Information

Spare Parts

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

Qty.	Section/Ref. No.	Part Number	Description
1	II/2949-15	78-8057-6181-0	Roller – Applying
1	II/2950-5, 2955-5	78-8057-6180-2	Roller – Buffing
1	II/2950-10	78-8070-1274-1	* Spring – Upper Extension (Silver)
1	II/2952-2	78-8028-7899-7	* Knife – 89 mm/3.5 Inch
1	II/2952-18	78-8113-7030-9	Spring – Torsion
2	II/2952-12	78-8052-6602-6	* Spring – Cutter
1	II/2955-10	78-8070-1273-3	* Spring – Lower Extension (Black)
4	I/7006-42	78-8094-6447-8	Belt – Drive

* **Note** – These spare parts are supplied with the tool kit that comes with your machine and should also be ordered separately as used, to keep the case sealer in production.

Labels

In the event that any labels are damaged or destroyed, **they must be replaced to ensure operator safety**. For safety and information replacement labels, see Parts Illustration/Lists, Section I, pages 66-67.

Tool Kit

A tool kit, P/N 78-8098-8868-4, packaged separately and included with your machine, contains the necessary wrenches for use with the metric fasteners on the case sealer. The threading tool, part number 78-8076-4726-4, contained in the kit is available as a stock replacement item and can be ordered separately.

Parts Ordering/Service

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

Options/Accessories

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

Part Number	Option/Accessory
78-8095-4862-7	Infeed/Exit Conveyor Attachment
78-8095-4852-8	3 Inch Tape Edge Fold Attachment (Upper Head)
78-8095-4853-6	3 Inch Tape Edge Fold Attachment (Lower Head)
78-8079-5560-0	Tape Application Sensor Kit
78-8069-3983-7	Caster Kit

Replacement Parts – Illustrations and Parts Lists

800r3 Random Case Sealer, Type 29600 With AccuGlide™ II STD 3 Inch Taping Heads

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.

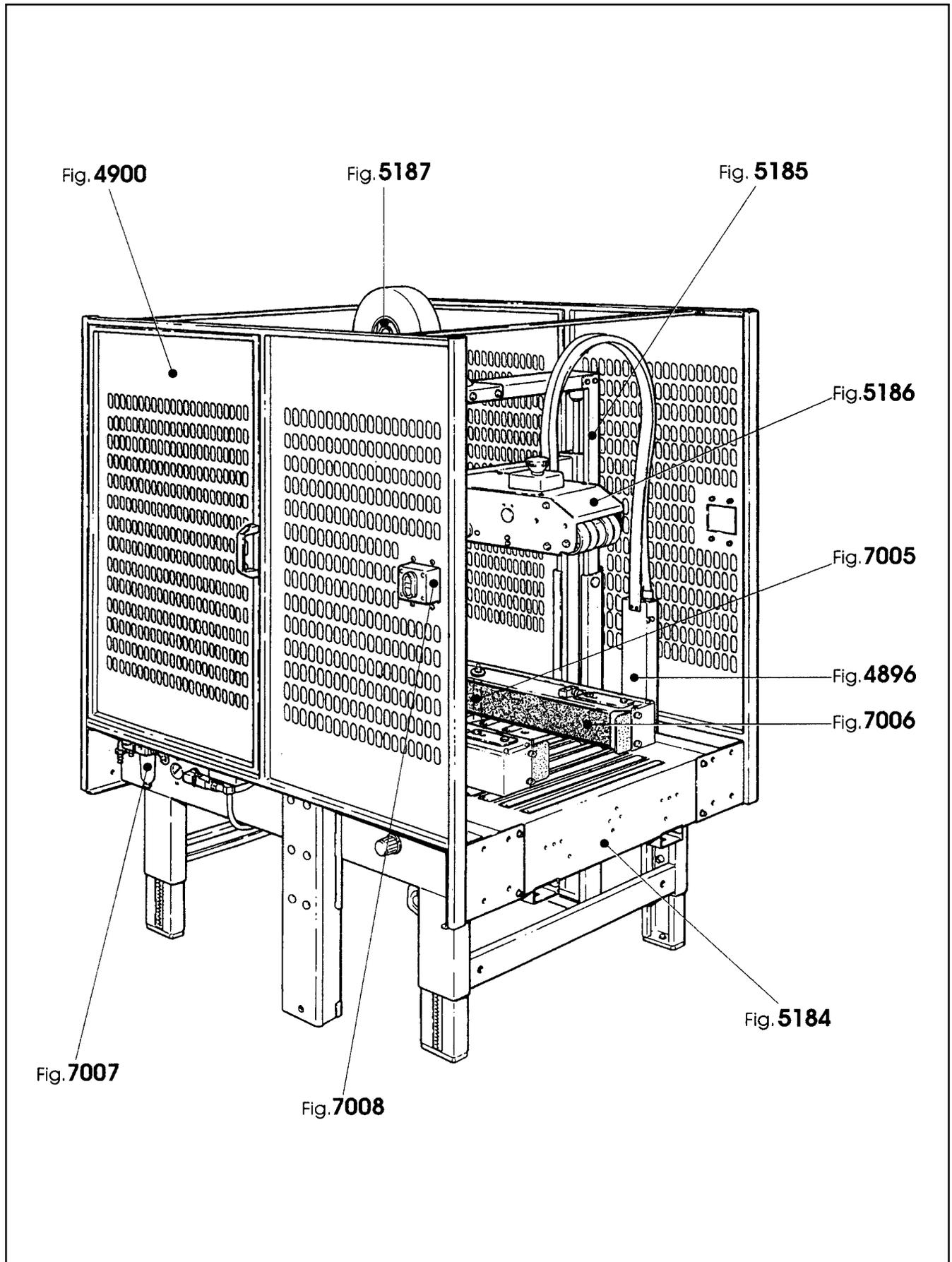
Note – The complete description has been included for **standard fasteners** and **some commercially available components**. This has been done to allow obtaining these standard parts locally, should the customer elect to do so.

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 phone/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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800r3 Random Case Sealer



Frame Assemblies

800r3 Random Case Sealer

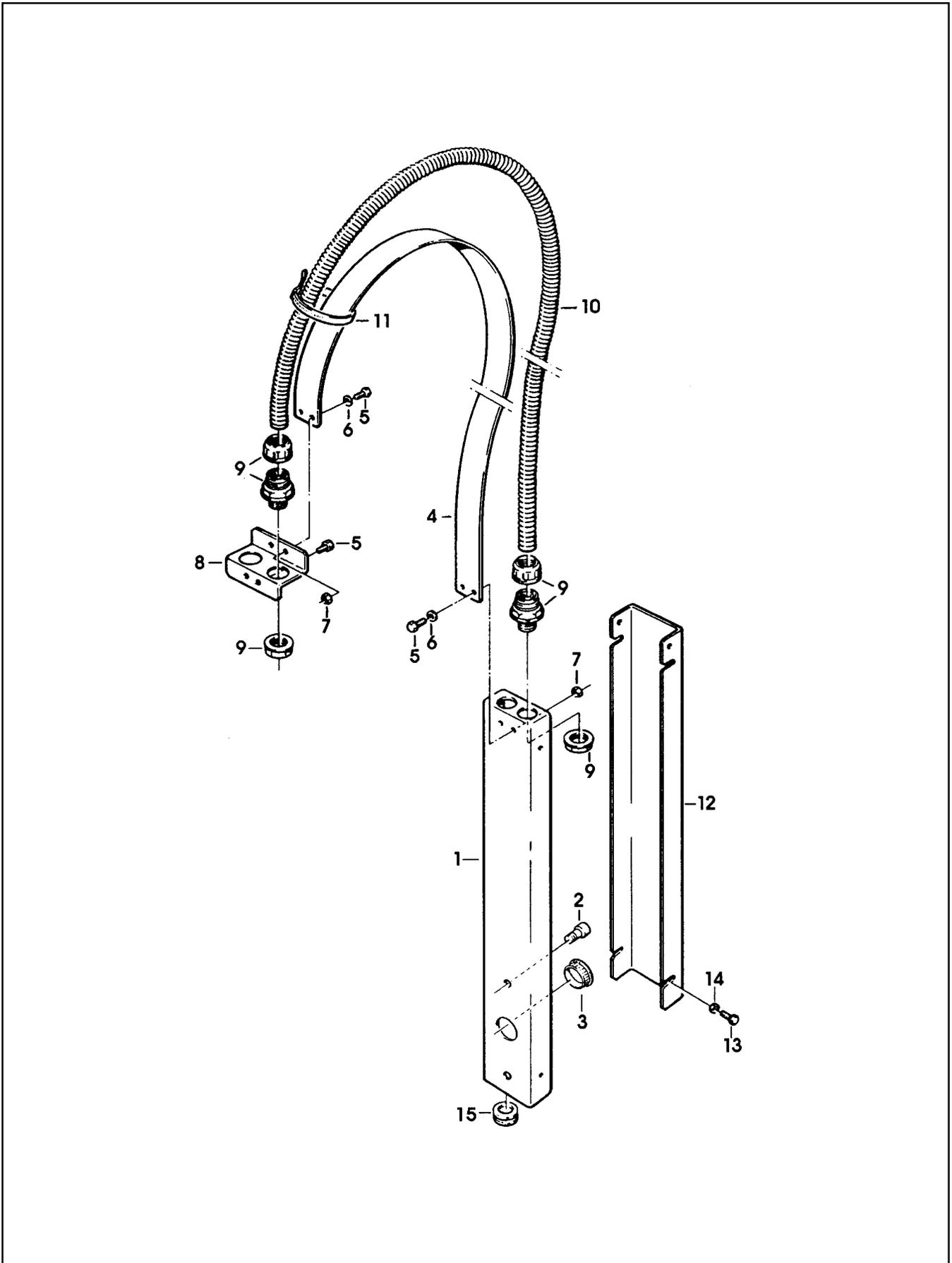


Figure 4896

Figure 4896

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

800r3 Random Case Sealer

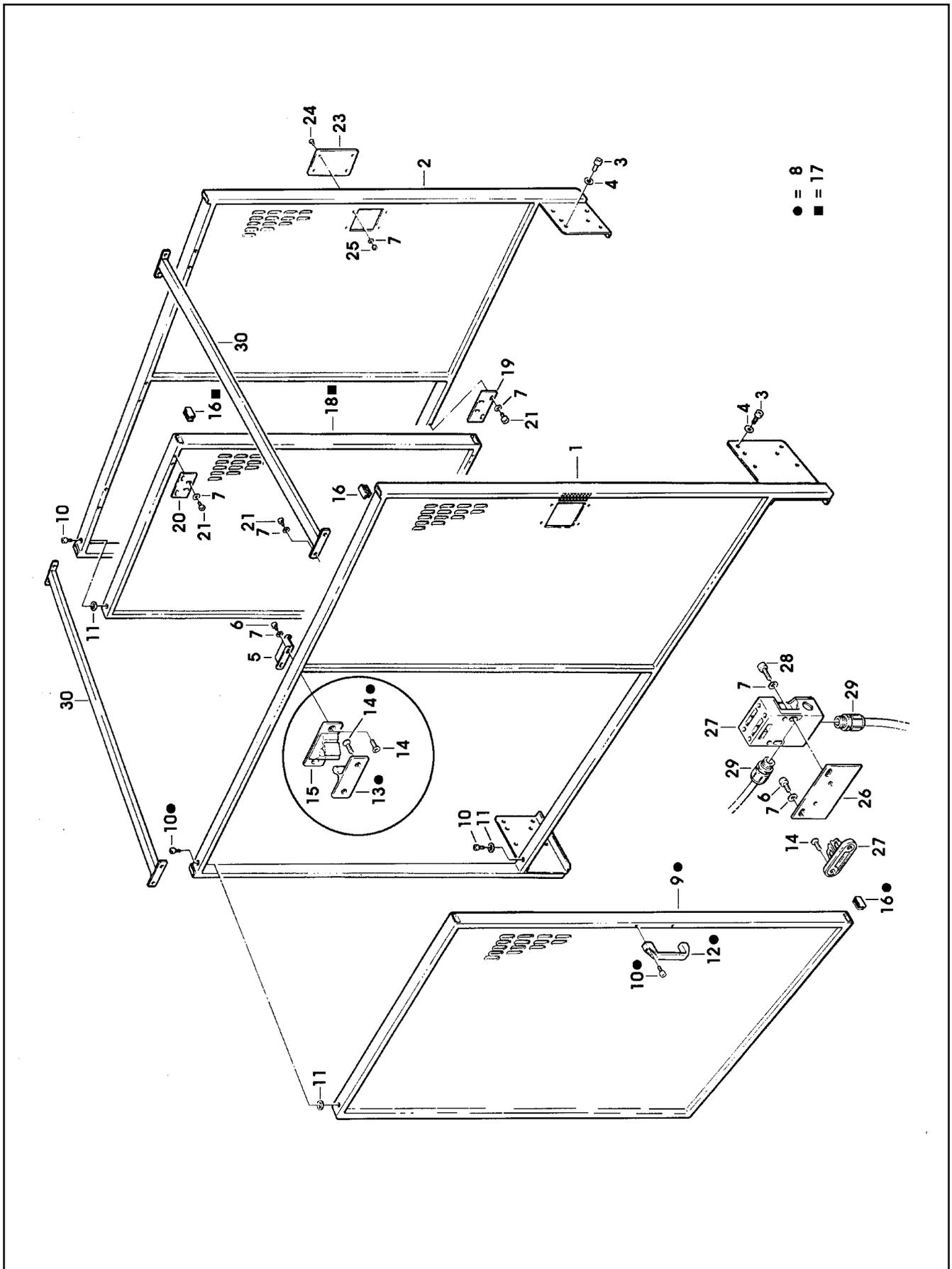


Figure 4900

Figure 4900

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

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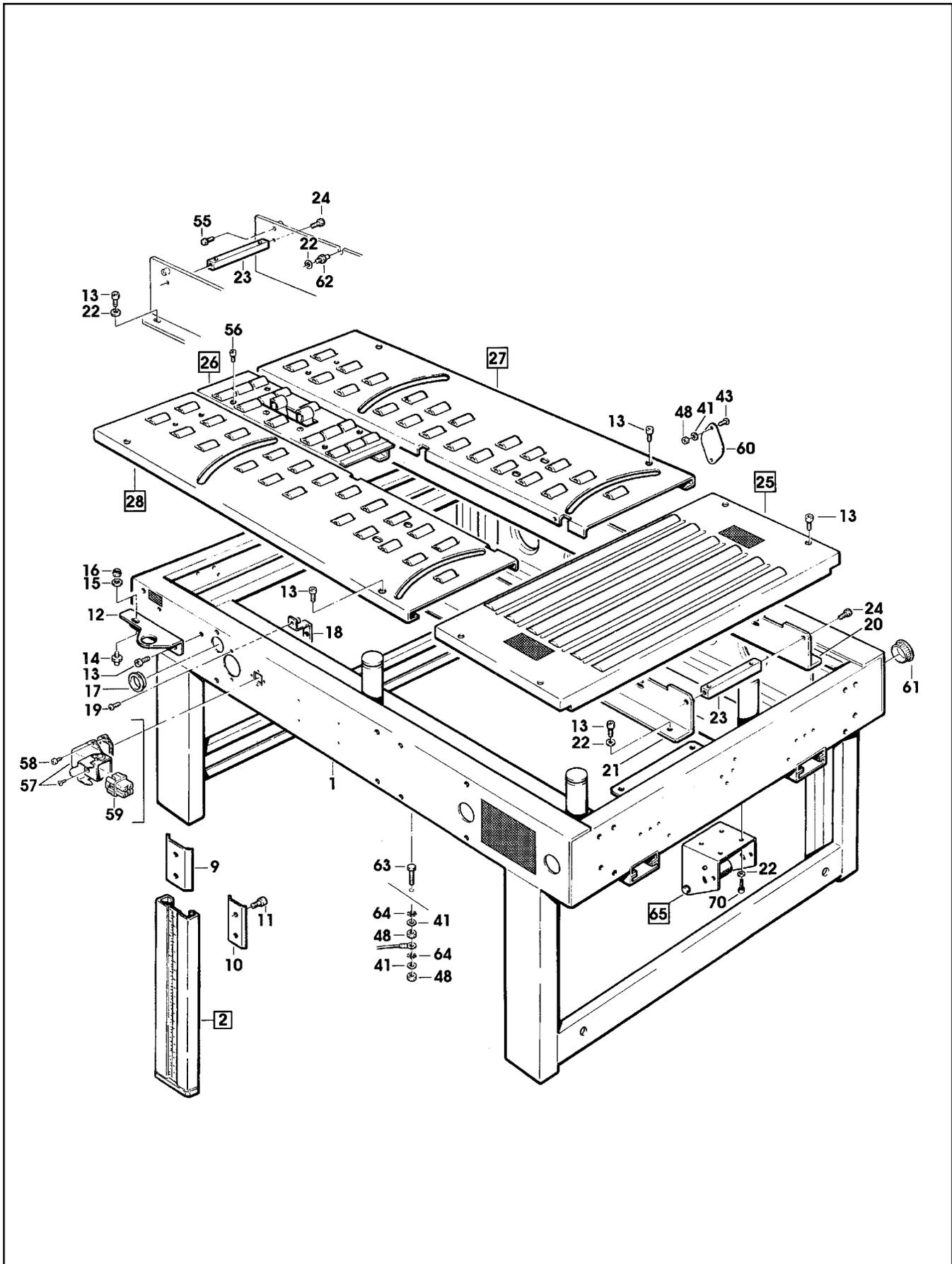


Figure 5184/1 of 2

Figure 5184 (page 1 of 2)

Ref. No.	3M Part No.	Description
5184-1	78-8113-6827-9	Bed Assembly – Conveyor, W/English Language Label
5184-2	78-8094-6486-6	Leg Assembly – Inner
5184-3	78-8094-6390-0	Leg – Inner
5184-4	78-8060-8480-8	Pad – Foot
5184-5	78-8055-0867-4	Screw – Hex Hd, M8 x 30
5184-6	26-1004-5507-5	Washer – M8
5184-7	78-8017-9313-0	Nut – Self-Locking, M8
5184-8	78-8094-6487-4	Label – Leg
5184-9	78-8052-6677-8	Clamp – Inner
5184-10	78-8052-6676-0	Clamp – Outer
5184-11	26-1003-7963-0	Screw – Soc Hd, M8 x 16
5184-12	78-8094-6392-6	Bracket
5184-13	78-8010-7209-7	Screw – Soc Hd, M6 x 12
5184-14	78-8091-0613-7	Shaft – Valve
5184-15	78-8042-2919-9	Washer – Triple, M6
5184-16	26-1003-6916-9	Nut – Locking Plastic Insert, M6
5184-17	78-8094-6489-0	Snap Bushing – SB 1250-15
5184-18	78-8076-4535-9	Bracket
5184-19	78-8076-4625-8	Screw – Special, M5 x 16
5184-20	78-8094-6393-4	Frame – BTM, R/H
5184-21	78-8094-6394-2	Frame – BTM, L/H
5184-22	26-1000-0010-3	Washer – Flat, M6
5184-23	78-8060-7955-0	Spacer – Center Frame
5184-24	78-8010-7169-3	Screw – Hex Hd, M6 x 12
5184-25	78-8094-6395-9	Conveyor Assembly – Front
5184-26	78-8094-6396-7	Conveyor Assembly – Rear
5184-27	78-8094-6397-5	Conveyor Assembly – R/H
5184-28	78-8094-6398-3	Conveyor Assembly – L/H
5184-29	78-8113-6826-1	Conveyor – Front, W/English Language Label
5184-30	78-8094-6400-7	Conveyor – Rear
5184-31	78-8094-6401-5	Conveyor – R/H
5184-32	78-8094-6402-3	Conveyor – L/H
5184-33	78-8094-6403-1	Shaft – Roller
5184-34	78-8059-5596-6	Roller
5184-35	78-8052-6694-3	Shaft – /8 x 128
5184-36	78-8060-7693-7	Roller – 32 x 38
5184-37	78-8060-7965-9	Shaft – Hex Hd, /8 x 120
5184-38	78-8054-8857-0	Shaft – 8 x 43 mm

Figure 5184 (page 2 of 2)

Ref. No.	3M Part No.	Description
5184-39	78-8060-8035-0	E-Ring – 7DIN6799
5184-40	78-8010-7163-6	Screw – Hex Hd, M5 x 10
5184-41	78-8005-5741-1	Washer – Plain, M5
5184-42	78-8060-8086-3	Support – Valve
5184-43	78-8060-8087-1	Washer – Plain, M5
5184-44	26-1005-6859-6	Nut – Self-Locking, M5
5184-45	78-8060-7775-2	Cam – Rear
5184-46	78-8060-8088-9	Shaft – Cam
5184-47	78-8054-8757-2	Pin – Spring Holder
5184-48	78-8010-7417-6	Nut – Hex, M5
5184-49	78-8094-6404-9	Spring
5184-50	78-8060-7777-8	Spring – Tensioner
5184-51	78-8060-8080-6	Guard – Stop
5184-52	26-1003-7946-5	Screw – Soc Hd, M4 x 25
5184-53	78-8017-9018-5	Washer – Plain, SPEC, M4
5184-54	78-8059-5607-1	Plate – Threaded
5184-55	26-1003-5829-5	Screw – Hex Hd, M6 x 12
5184-56	26-1003-7948-1	Screw – Soc Hd, Hex Soc, M5 x 10
5184-57	78-8060-7876-8	Cover Plug – Lateral
5184-58	78-8028-8208-0	Screw – 6PX9,5
5184-59	78-8060-7873-5	Plug – Female
5184-60	78-8094-6305-8	Plate – Gauge
5184-61	78-8094-6177-1	Cap
5184-62	78-8070-1665-0	Stud – Hex, Taping Head
5184-63	78-8060-8488-1	Screw – Hex Hd, M5 x 20
5184-64	78-8046-8217-3	Washer – Special
5184-65	78-8076-5462-5	Support – Tape Drum
5184-66	78-8076-4758-7	Support – Tape Bracket
5184-67	78-8076-4759-5	Shaft – Roller
5184-68	78-8076-5030-0	Roller – Knurled, L=114
5184-69	78-8032-0375-7	Screw – Hex Hd, M6 x 16
5184-70	26-1003-7957-2	Screw – Soc Hd, Hex Hd, M6 x 16

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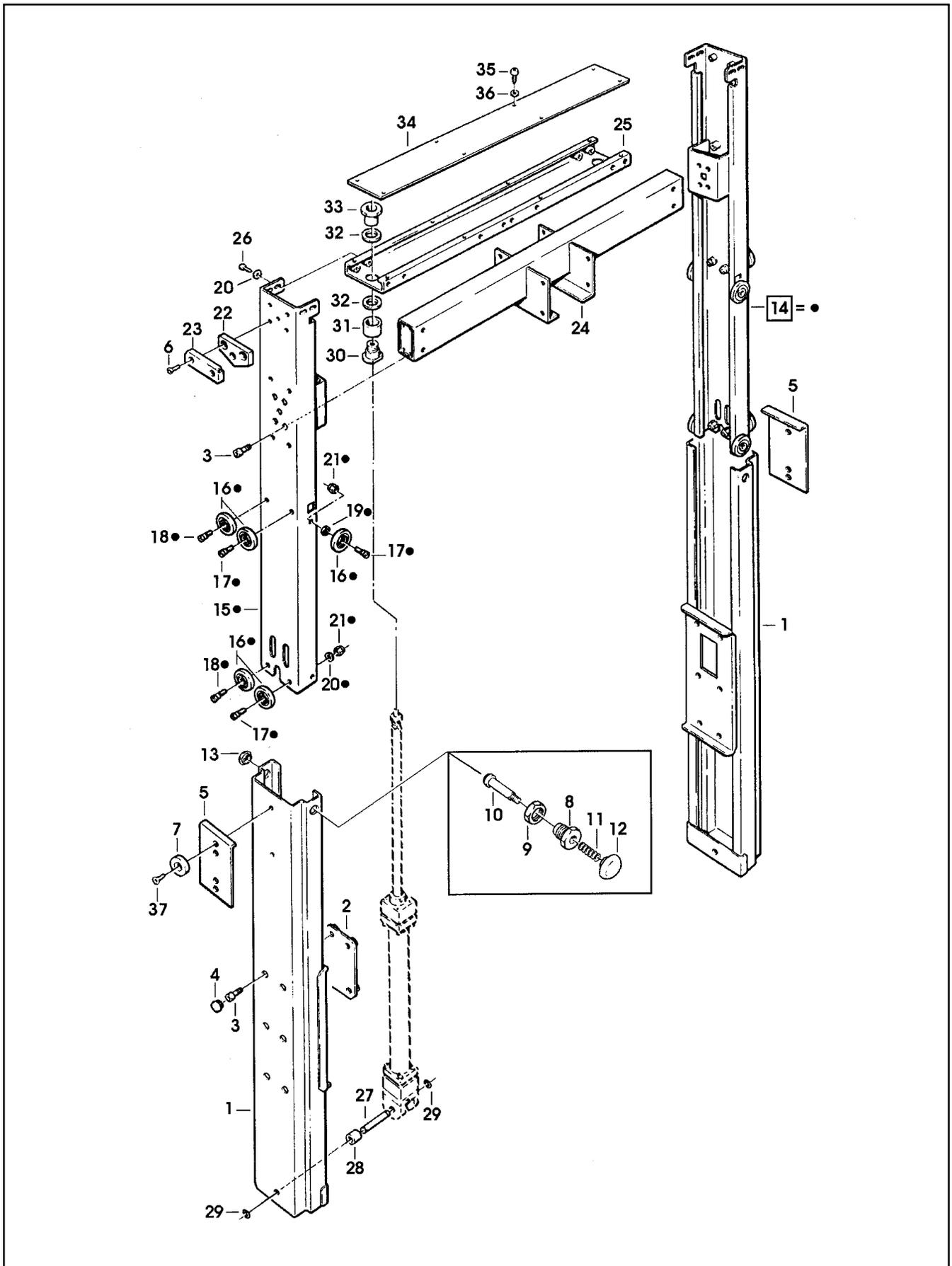


Figure 5185

Figure 5185

Ref. No.	3M Part No.	Description
5185-1	78-8094-6408-0	Column Assembly – Outer
5185-2	78-8076-5474-0	Plate Assembly – Column Mount
5185-3	26-1003-7964-8	Screw – Soc Hd, Hex Soc Dr, M8 x 20
5185-4	78-8054-8821-6	End – Cap
5185-5	78-8091-0621-0	Plate – Outer Column
5185-6	78-8060-7918-8	Screw – Flat, Soc Hd, M6 x 25
5185-7	78-8054-8577-4	Washer – Special
5185-8	78-8091-0615-2	Bushing – Stop
5185-9	78-8017-9169-6	Nut – M18 x 1
5185-10	78-8076-4544-1	Stud – Height Stop
5185-11	78-8076-4545-8	Spring
5185-12	78-8076-4546-6	Knob
5185-13	78-8076-4547-4	Cap – /18
5185-14	78-8094-6410-6	Column Assembly – Inner
5185-15	78-8094-6411-4	Column – Inner
5185-16	78-8054-8617-8	Bearing – Special
5185-17	78-8017-9106-8	Screw – Bearing Shoulder
5185-18	78-8054-8589-9	Screw – Special
5185-19	78-8054-8576-6	Spacer
5185-20	26-1000-0010-3	Washer – Flat, M6
5185-21	26-1003-6916-9	Nut – Locking Plastic Insert, M6
5185-22	78-8060-7916-2	Bumper
5185-23	78-8091-0617-8	Plate – Support Bumper
5185-24	78-8100-0764-7	Bar
5185-25	78-8100-0765-4	Cross Member
5185-26	78-8032-0375-7	Screw – Hex Hd, M6 x 16
5185-27	78-8054-8966-9	Pin – Air Cylinder Clevis
5185-28	78-8054-8828-1	Spacer – 10,5/16X14, 5MM
5185-29	78-8060-8035-0	E-Ring – 7DIN6799
5185-30	78-8054-8824-0	Rod End
5185-31	78-8094-6416-3	Spacer
5185-32	78-8054-8823-2	Washer – Bumper
5185-33	78-8094-6417-1	Ring Nut
5185-34	78-8094-6418-9	Cover
5185-35	78-8076-5255-3	Screw – Phillips Hd, M4 x 12
5185-36	78-8005-5740-3	Washer – Plain, 4MM
5185-37	26-1001-9843-6	Screw – Flat, Soc Hd, M6 x 16

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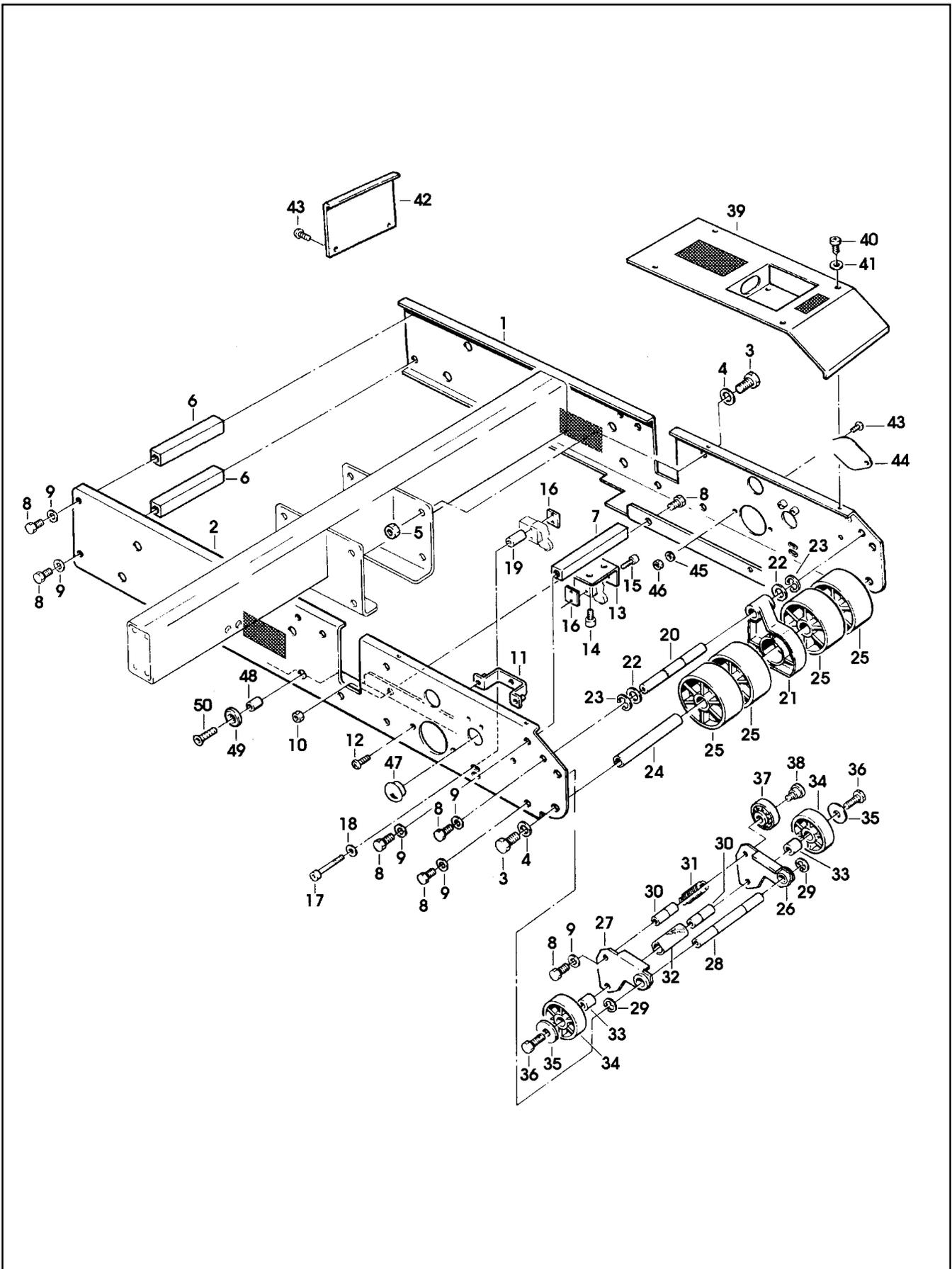


Figure 5186

Figure 5186

Ref. No.	3M Part No.	Description
5186-1	78-8113-6838-6	Frame Assembly – R/H, W/English Language Label
5186-2	78-8113-6839-4	Frame Assembly – L/H, W/English Language Label
5186-3	26-1003-5841-0	Screw – M8 x 16
5186-4	78-8017-9318-9	Washer – Plain, 8MM
5186-5	26-1000-1347-8	Nut – Hex, M8
5186-6	78-8094-6247-2	Spacer
5186-7	78-8100-0768-8	Spacer
5186-8	78-8010-7169-3	Screw – Hex Hd, M6 x 12
5186-9	26-1000-0010-3	Washer – Flat, M6
5186-10	78-8010-7418-4	Nut – Hex, M6
5186-11	78-8076-4535-9	Bracket
5186-12	78-8076-4625-8	Screw – Special, M5 x 16
5186-13	78-8054-8832-3	Support – Valve
5186-14	26-1003-7949-9	Screw – Soc Hd, Hex Soc, M5 x 12
5186-15	26-1003-7946-5	Screw – Soc Hd, M4 x 25
5186-16	78-8059-5607-1	Plate – Threaded
5186-17	78-8094-6434-6	Screw – Soc Hd, Hex Hd, M4 x 50
5186-18	78-8017-9018-5	Washer – Plain, M4 SPEC.
5186-19	78-8094-6435-3	Spacer
5186-20	78-8100-0769-6	Shaft – Lever
5186-21	78-8076-4657-1	Link – Actuator, Valve
5186-22	78-8052-6566-3	Washer – Friction
5186-23	78-8016-5855-6	E-Ring – 10MM
5186-24	78-8094-6250-6	Shaft – Roller
5186-25	78-8100-0770-4	Roller
5186-26	78-8094-6439-5	Frame – R/H
5186-27	78-8094-6440-3	Frame – L/H
5186-28	78-8094-6254-8	Shaft – 10 X 150
5186-29	78-8060-8035-0	E-Ring – 7DIN6799
5186-30	78-8094-6255-5	Shaft – 10 x 46
5186-31	78-8076-4774-4	Spring
5186-32	78-8094-6256-3	Sleeve
5186-33	78-8094-6258-9	Bushing
5186-34	78-8060-7798-4	Wheel – /50
5186-35	78-8042-2919-9	Washer – Triple, M6
5186-36	26-1003-5832-9	Screw – Hex Hd, M6 x 25
5186-37	78-8054-8617-8	Bearing – Special
5186-38	78-8017-9106-8	Screw – Bearing Shoulder
5186-39	78-8113-6860-0	Upper Cover Assembly – W/English Language Label
5186-40	26-1002-5753-9	Screw – Self-Tapping
5186-41	78-8005-5740-3	Washer – Plain, 4 MM
5186-42	78-8100-0772-0	Cover – Upper, Rear
5186-43	78-8060-8087-1	Screw – M5 x 10
5186-44	78-8094-6259-7	Plate
5186-45	78-8005-5741-1	Washer – Plain, M5
5186-46	78-8010-7417-6	Nut – Hex, M5
5186-47	78-8060-7885-9	End Cap – /25X1,2
5186-48	78-8052-6700-8	Spacer – Taping Head Mtg.
5186-49	78-8076-5477-3	Washer – Taping Head Mtg., 6.5 x 20 x 4
5186-50	78-8060-7918-8	Screw – Flat, Soc Hd, M6 x 25

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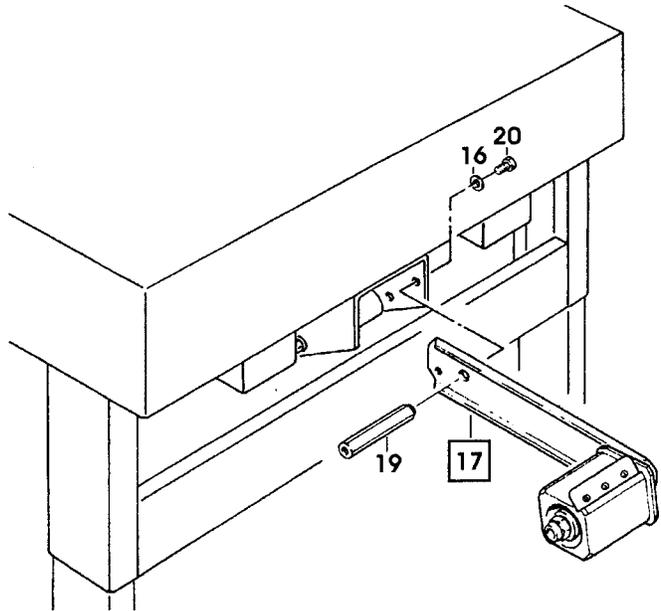
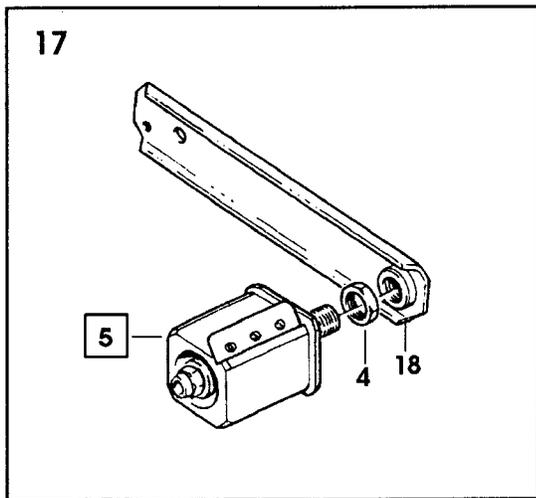
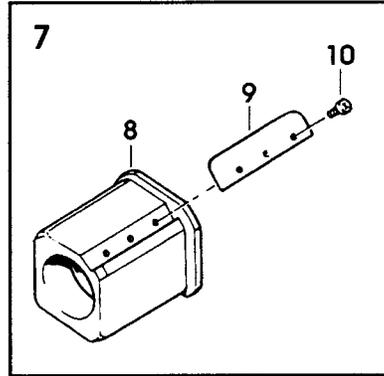
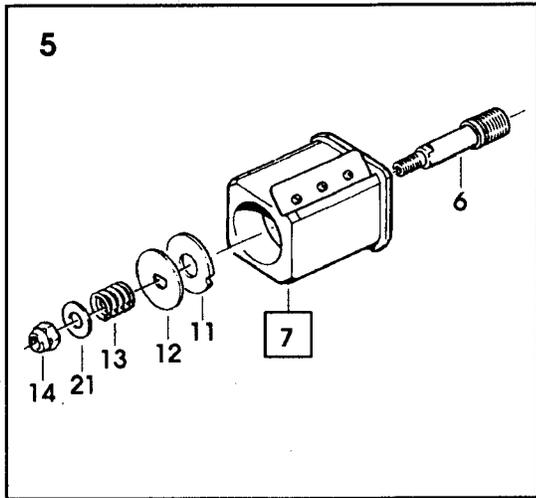
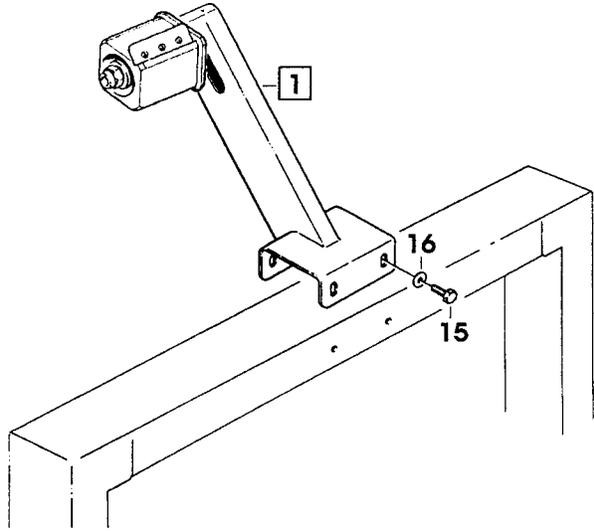
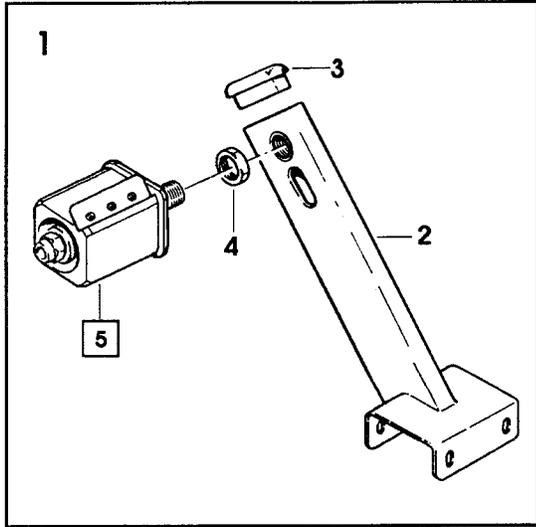


Figure 5187

Figure 5187

Ref. No.	3M Part No.	Description
5187-1	78-8094-6342-1	Bracket Assembly – Tape Drum
5187-2	78-8091-0605-3	Bracket – Core Holder
5187-3	78-8070-1568-6	Cap – Bracket
5187-4	78-8017-9169-6	Nut – M18 x 1
5187-5	78-8076-4732-2	Tape Drum Assembly – 3 Inch Head
5187-6	78-8060-8462-6	Shaft – Tape Drum
5187-7	78-8076-4731-4	Tape Drum Assembly – 3 Inch Wide
5187-8	78-8054-8815-8	Tape Drum Assembly
5187-9	78-8054-8816-6	Leaf Spring
5187-10	26-1002-5753-9	Screw – Self-Tapping
5187-11	78-8060-8172-1	Washer – Friction
5187-12	78-8052-6271-0	Washer – Tape Drum
5187-13	78-8054-8826-5	Spring
5187-14	78-8060-7511-1	Ring – Nut. Self-Tapping
5187-15	78-8032-0375-7	Screw – Hex Hd, M6 x 16
5187-16	26-1000-0010-3	Washer – Flat, M6
5187-17	78-8076-4935-1	Tape Drum Bracket Assembly
5187-18	78-8070-1395-4	Bracket – Bushing Assembly
5187-19	78-8076-4742-1	Spacer – Tape Drum Bracket
5187-20	78-8010-7169-3	Screw – Hex Hd, M6 x 12

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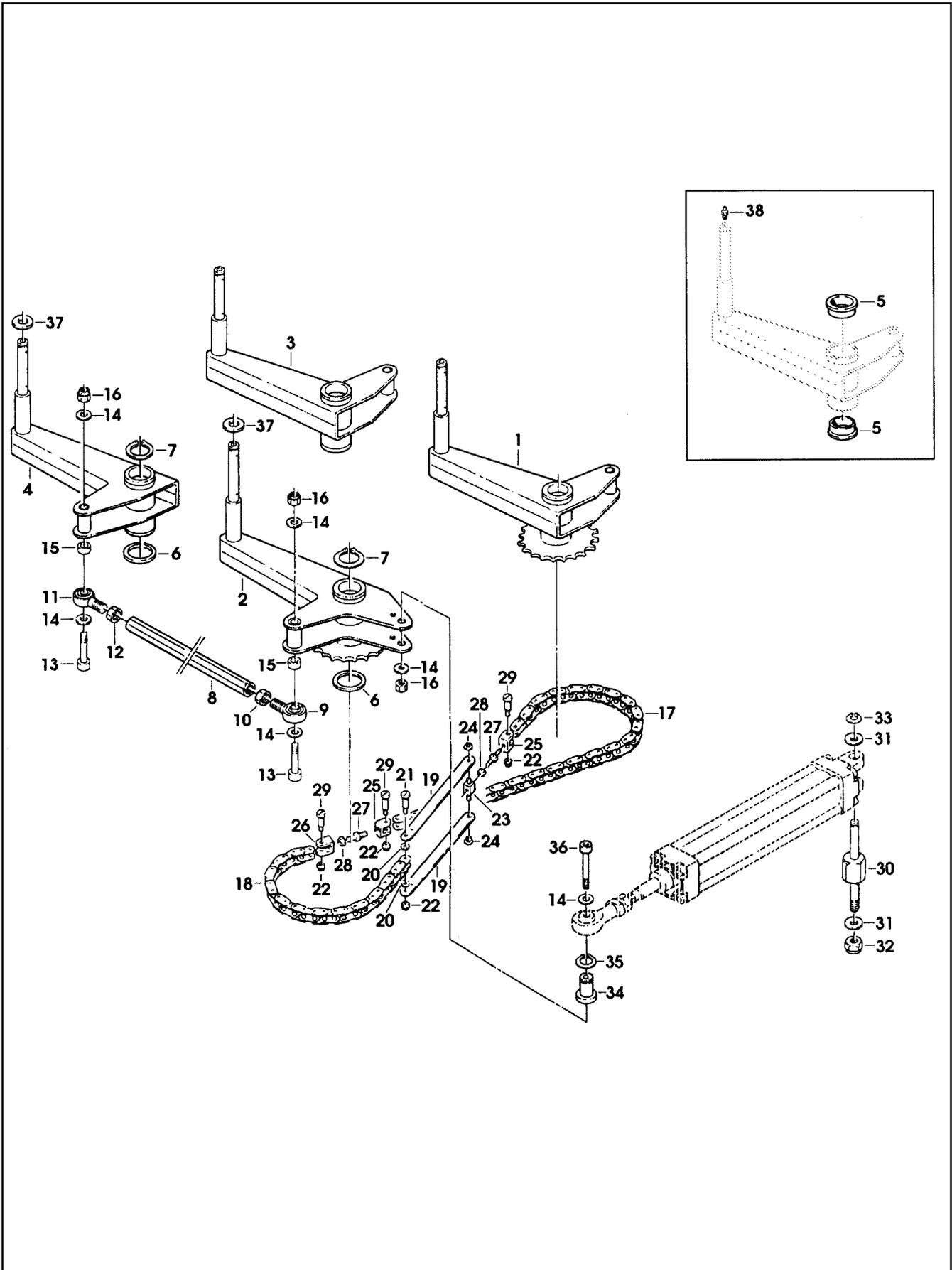


Figure 7005

Figure 7005

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

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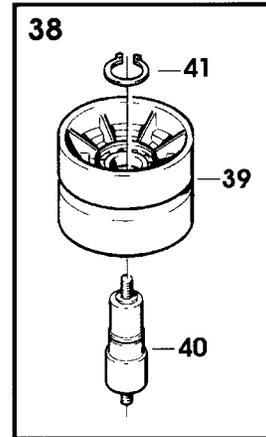
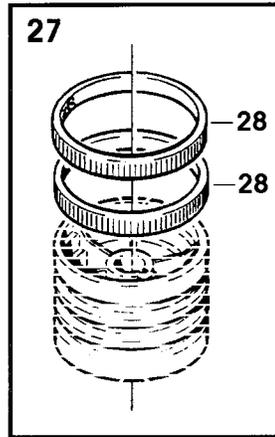
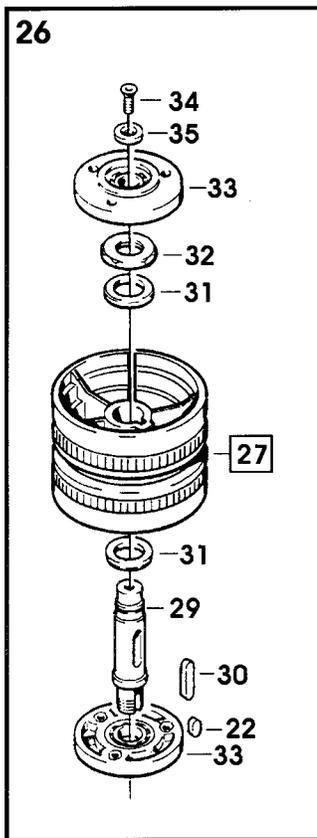
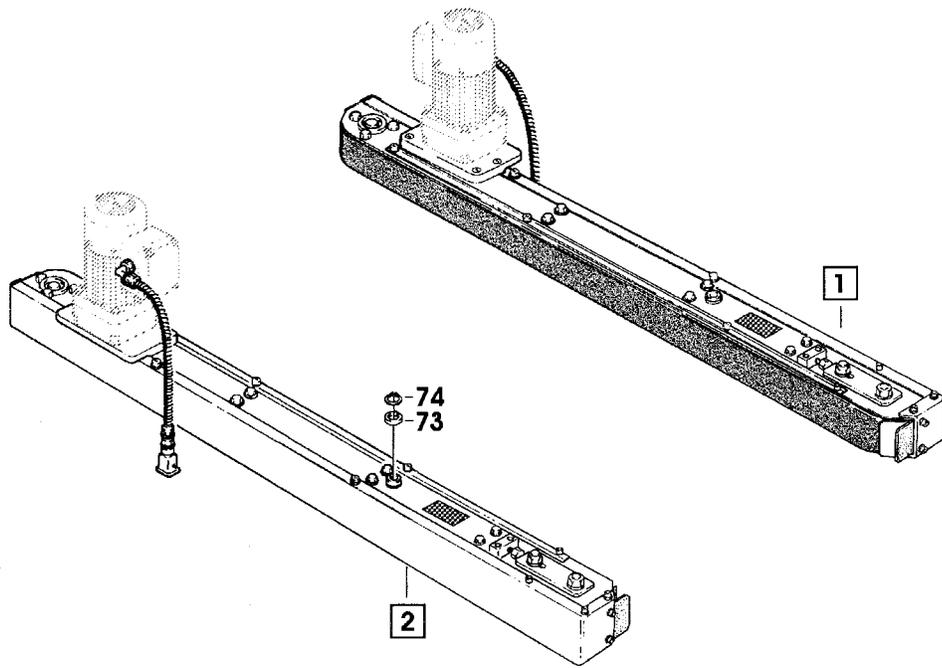


Figure 7006/1 of 2

Figure 7006 (page 1 of 2)

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

Figure 7006 (page 2 of 2)

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

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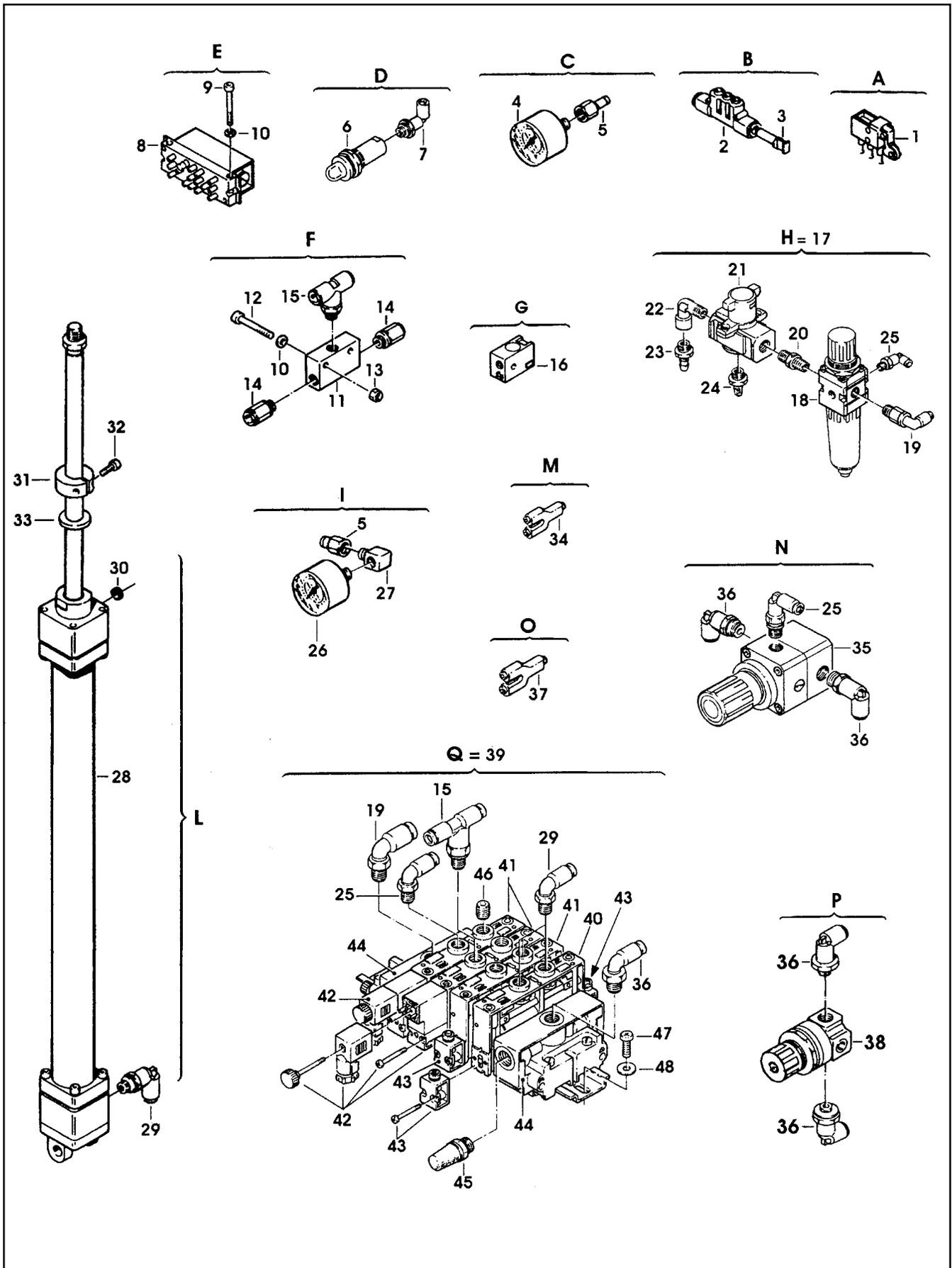


Figure 7007/1 of 2

Figure 7007 (page 1 of 2)

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

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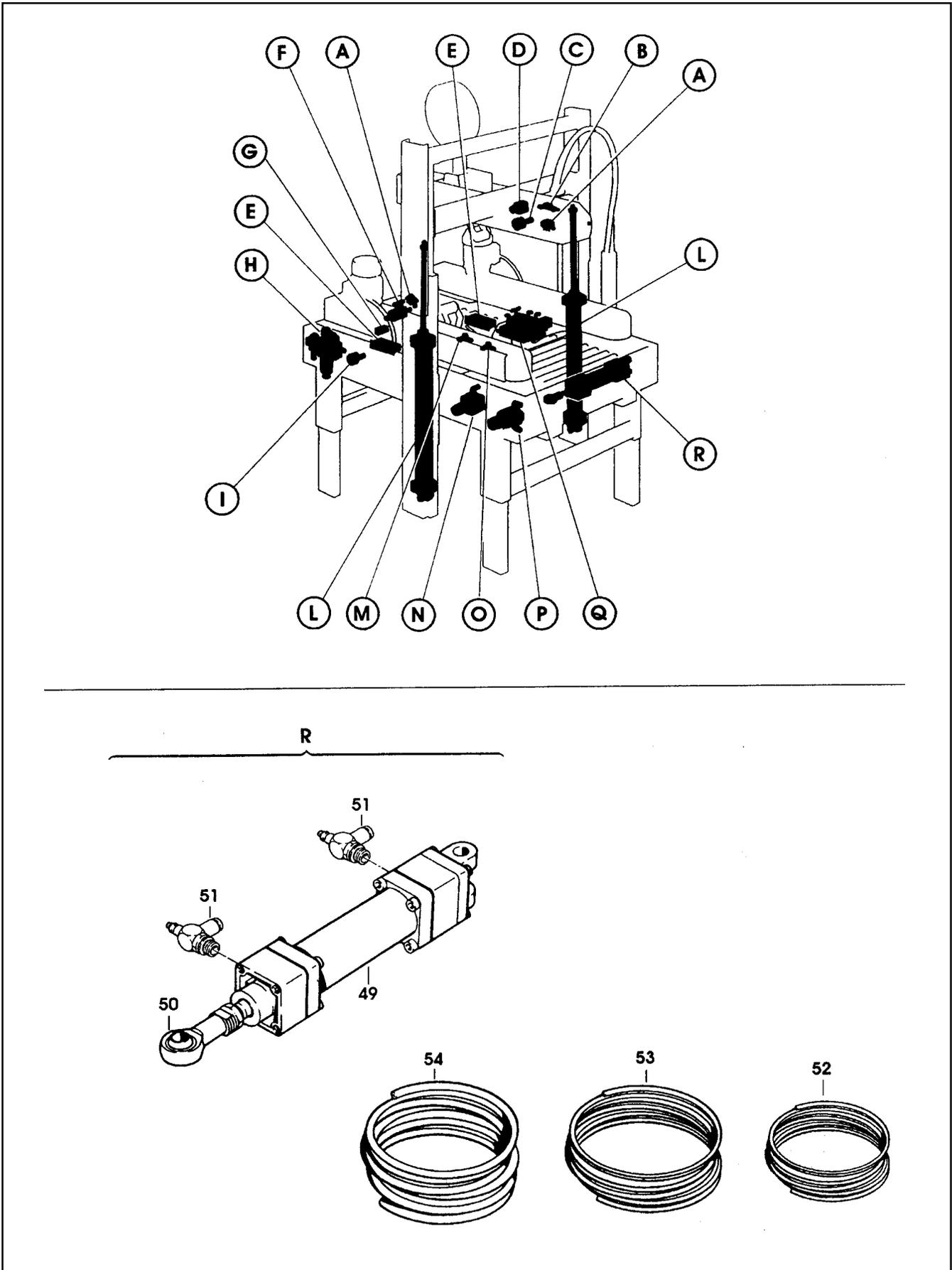


Figure 7007/2 of 2

Figure 7007 (page 2 of 2)

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

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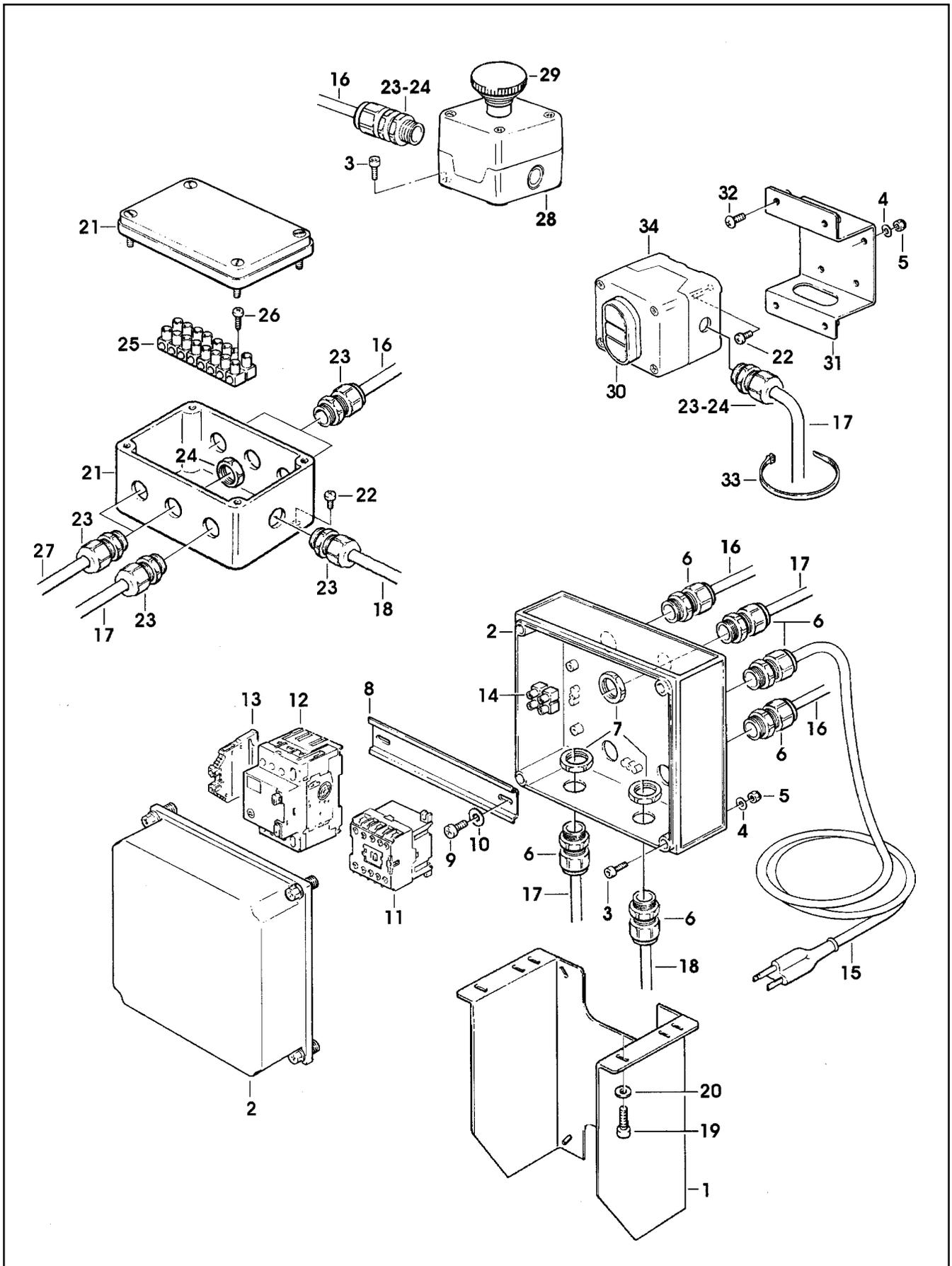
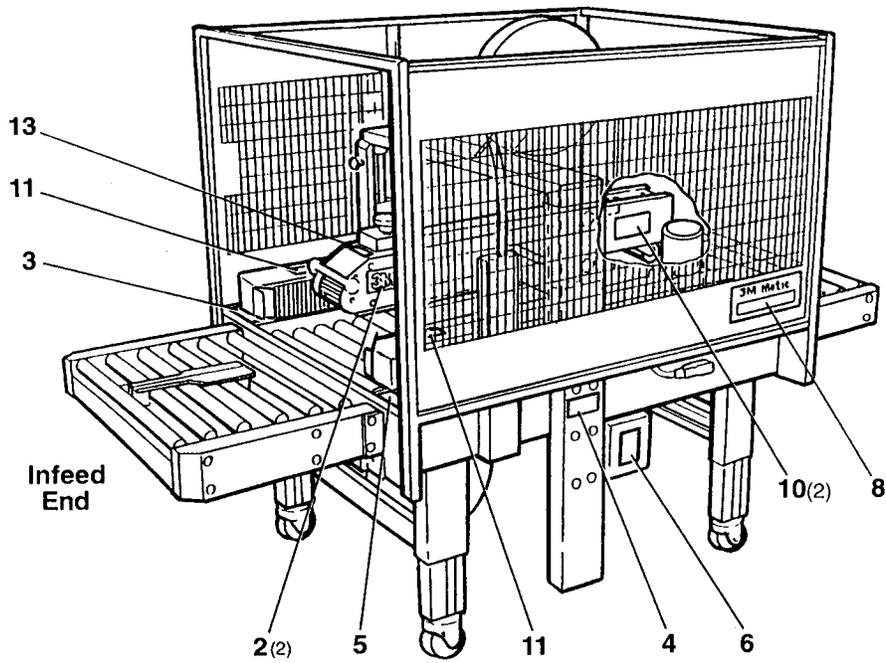
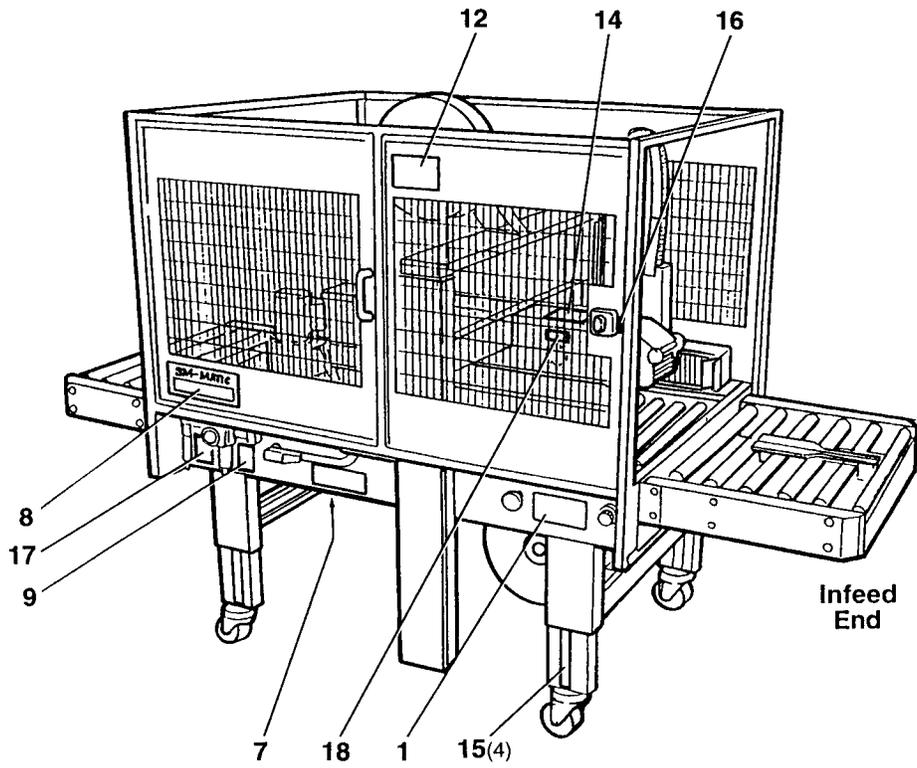


Figure 7008

Figure 7008

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

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Note: Infeed/Exit conveyors and casters are optional.

800r3 Safety and Information Labels

A label kit, part number 78-8113-6778-4 is available as a stock item. It contains all the safety and information labels used on the case sealer, or labels can be ordered separately from the following list.

Ref. No.	3M Part No.	Description	Qty.
	78-8113-6778-4	Label Kit (Includes items 1-18)	
1	78-8098-8916-1	Label – Air Control	1
2	78-8070-1339-2	Label – 3M Logo	2
3	78-8070-1331-9	Label – Warning, Moving Belts	1
4	78-8068-3859-1	Label – Service and Spares	1
5	78-8070-1330-1	Label – Warning, Moving Belts	1
6	78-8070-1329-3	Label – Warning, Hazardous Voltage	1
7	78-8068-3852-6	Label – Ground Symbol	1
8	78-8062-4266-1	Label – Product	2
9	78-8113-6750-3	Label – Air Supply	1
10	78-8070-1336-8	Label – Warning, Sharp Knife	2
11	78-8070-1629-6	Label – Belt Tensioning	2
12	78-8098-8917-9	Label – Latch Upper Head	1
13	78-8095-1141-9	Label – Stop	1
14	78-8070-1332-7	Label – Safety Instructions	1
15	78-8094-6487-4	Label – Leg	4
16	78-8113-6775-0	Label – Electrical, On/Off	1
17	78-8111-1496-2	Label – Air Pressure	1
18	78-8113-6831-1	Label – Upper Head Gage	1