



Instructions and Parts List

3M-Matic™

800af

 Type 39600

Adjustable

Case Sealer

with

AccuGlide™ II

Taping Heads

Serial No. _____

For reference, record machine serial number here.



Important Safety Information

Read "Safeguards", pages 3-6
and also operating

"Warnings", page 18

**BEFORE INSTALLING OR
OPERATING THIS
EQUIPMENT.**

Spare Parts

It is recommended you immediately order the spare parts listed on page 41. These parts are expected to wear through normal use and should be kept on hand to minimize production delays.

3M Masking and Packaging Systems Division

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

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of 3M, St. Paul, MN 55144-1000

Litho in U.S.A.

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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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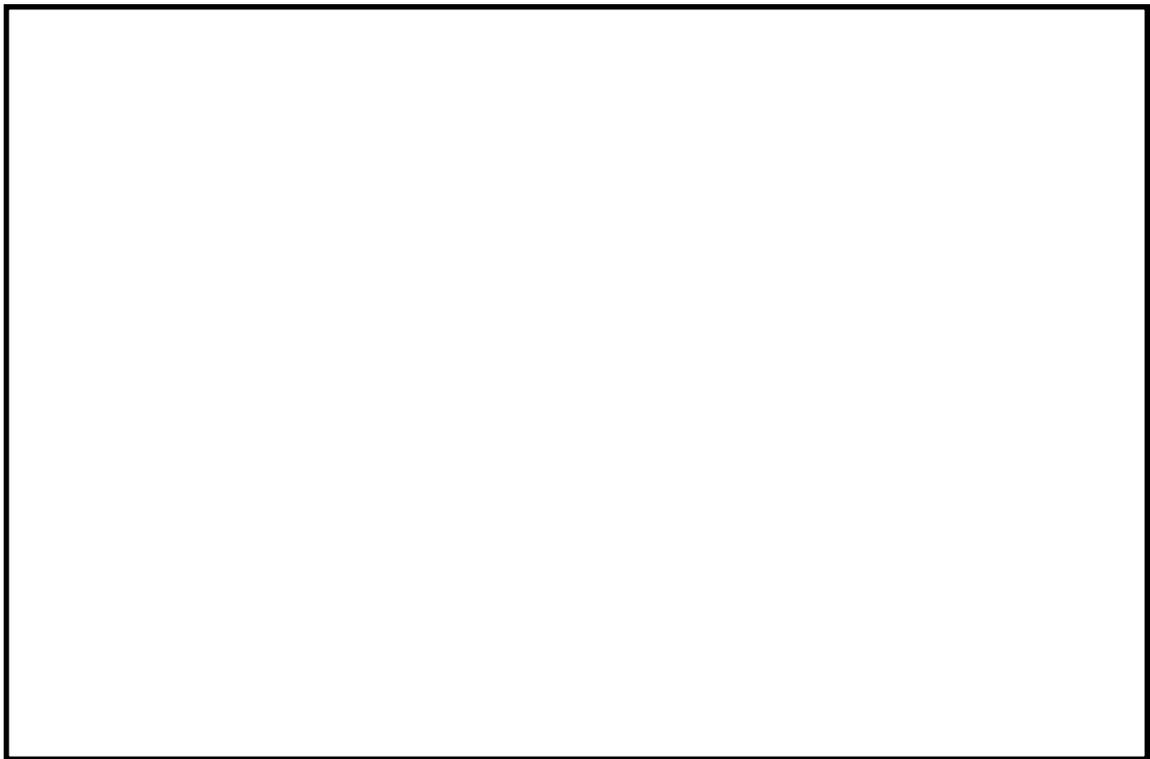
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To Our Customers:

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

800af Adjustable Case Sealer
Type 39600

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 2 Inch Taping Heads.

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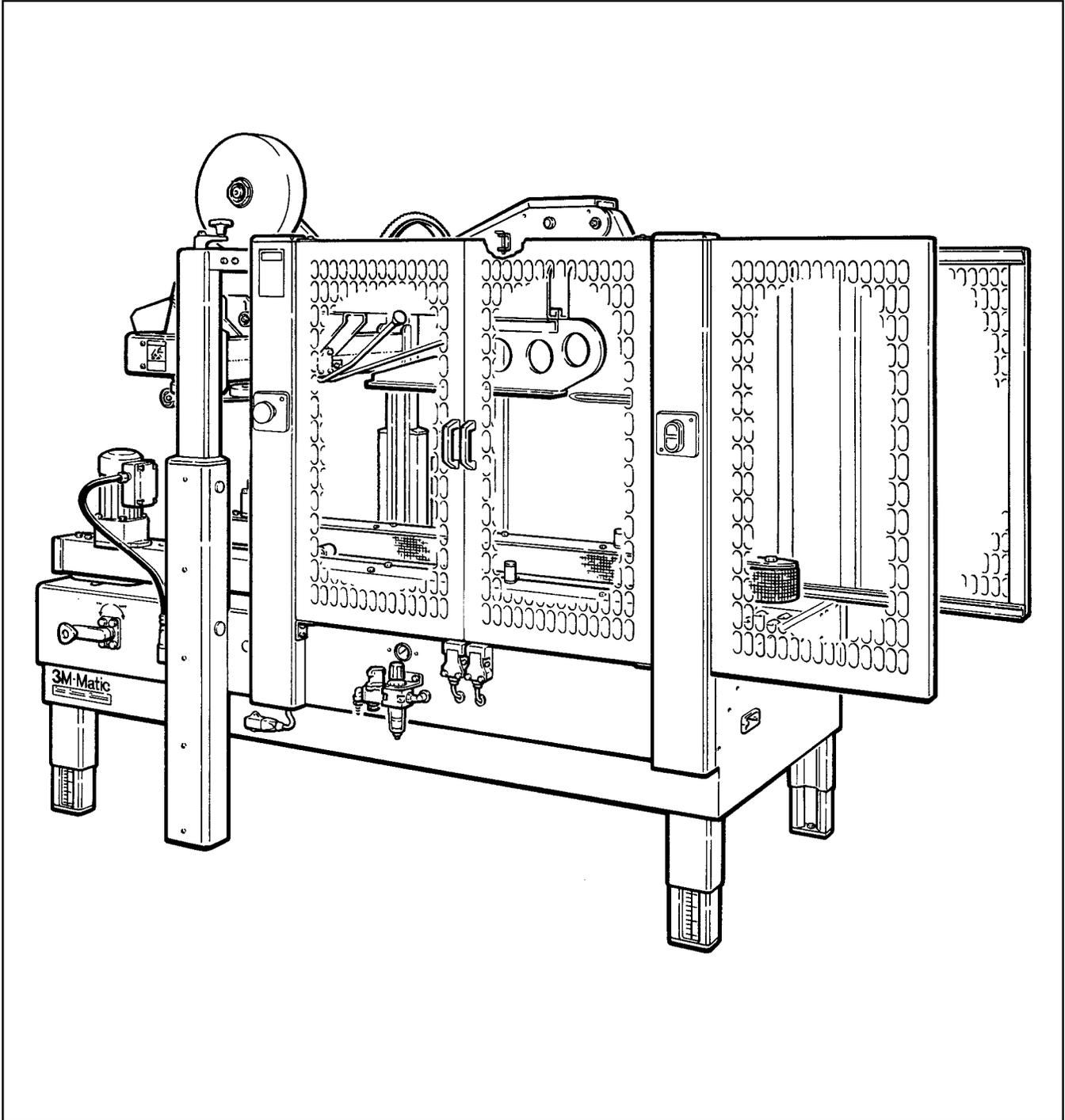
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Section II – AccuGlide™ STD 2 Inch Taping Heads
(See Section II for Table of Contents)

Intended Use

The intended use of the **3M-Matic™ 800af Adjustable Case Sealer with AccuGlide™ II Taping Heads** is to automatically seal the top and bottom center seams of regular slotted containers without the need for an operator. It will accept filled regular slotted containers from an existing conveyor, fold the top flaps and apply a "C" clip of **Scotch™** brand pressure-sensitive film box sealing tape to the top and bottom center seams of the box. An integral gate provides the proper spacing of incoming boxes. Infeed conveyor speed must not exceed 0.3 m/s [60 F.P.M.] maximum. The machine has been designed and tested for use with **Scotch™** brand pressure-sensitive film box sealing tape.



3M-Matic™ 800af Adjustable Case Sealer, Type 39600

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™ 800af Type 39600** with the following warranties:

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

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

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

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

Contents – 800af Adjustable Case Sealer

- (1) 800af Adjustable Case Sealer, Type 39600
- (1) Tool/Spare Parts Kit, P/N 78-8060-8476-6
- (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 78-8113-6881-6 is available as a stock item or individual labels can be ordered. See Parts Illustration/List, Section I, pages 86 & 87.

The "**Warning – Sharp Knife**" label (A), shown in **Figure 1-1**, is attached to both sides of the upper frame at the location of the cut-off knife on the upper taping heads. The "**Warning – Sharp Knife**" label (B), shown in **Figure 1-1**, is attached to the orange cut-off knife guard on both taping heads. The labels warn operators and service personnel of the very sharp knife used to cut the tape at the end of the tape application.

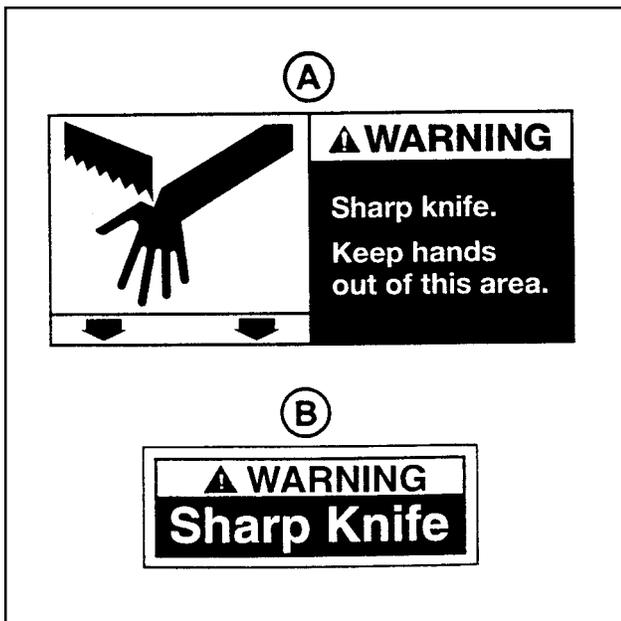


Figure 1-1 – Knife Warning Label

The "**Warning – Hazardous Voltage**" label, shown in **Figure 1-2**, is attached to the cover of the electrical control box 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 "**Warning – Keep Hands Away From Moving Belts**" labels, shown in **Figure 1-3**, are located on the infeed end of the machine bed on each side. The labels warn operators to keep hands away from this area when drive belts are running.

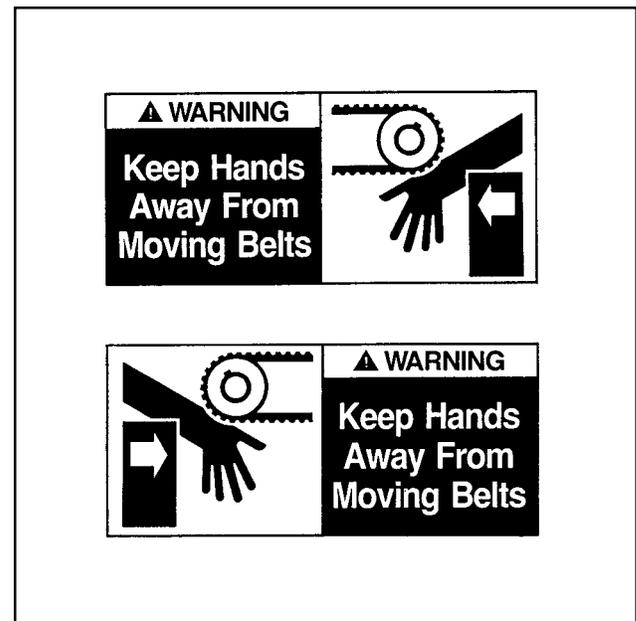


Figure 1-3 – Box Drive Belt Warning Label

Important Safeguards (Continued)

The "**Warning – Moving Flap Kicker**" labels, shown in **Figure 1-4**, are attached to the machine guards on the infeed end, close to the top. These labels remind the operator and service personnel to keep away from flap kicker when machine is running.



Figure 1-4 – Moving Flap Kicker

The "**Caution – Pinch Point**" label, shown in **Figure 1-5**, is attached to the back side of the compression roller brackets on both sides of the machine. The label reminds operator to keep hands away from compression rollers when machine is running.



Figure 1-5 – Pinch Point Caution Label

Two emergency stop switches are located, one on each side of the machine, on the guard at the center of the machine. The "**Stop**" label, shown in **Figure 1-6**, is located near these switches and remind operators and other personnel of the function of these switches.

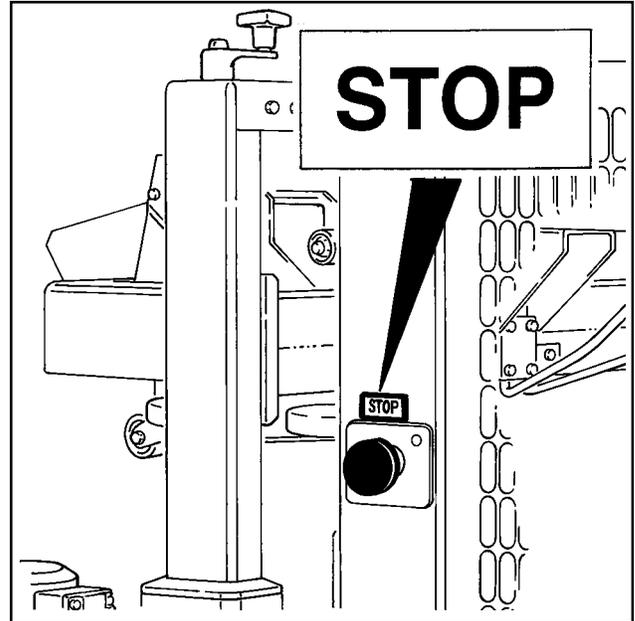


Figure 1-6 – Stop and On/Off Labels

The "**On/Off**" label, shown in **Figure 1-7**, is located next to the electrical on/off switch on the guard (left side) at the infeed end of the machine. The label reminds operators of the function of this switch.

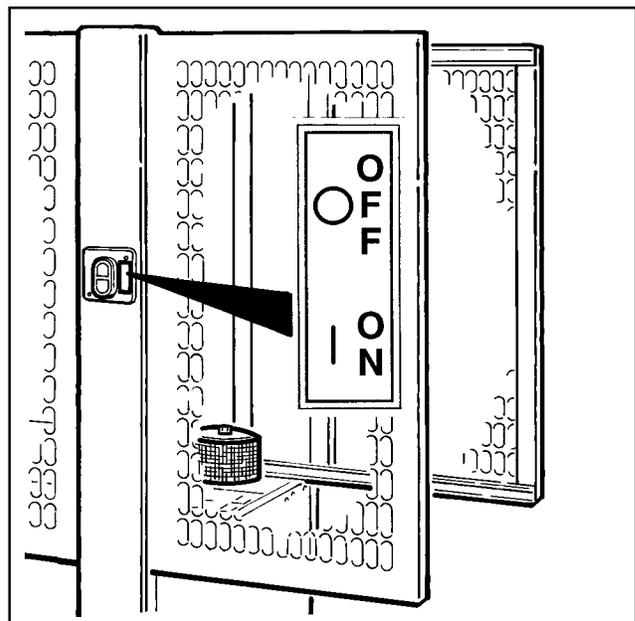


Figure 1-7 – On/Off Label

Important Safeguards (Continued)

The "Safety Instructions" label, shown in **Figure 1-8**, is attached to the top of both side guards near the center of the machine. The label provides convenient safeguard instructions for the operator and service personnel.

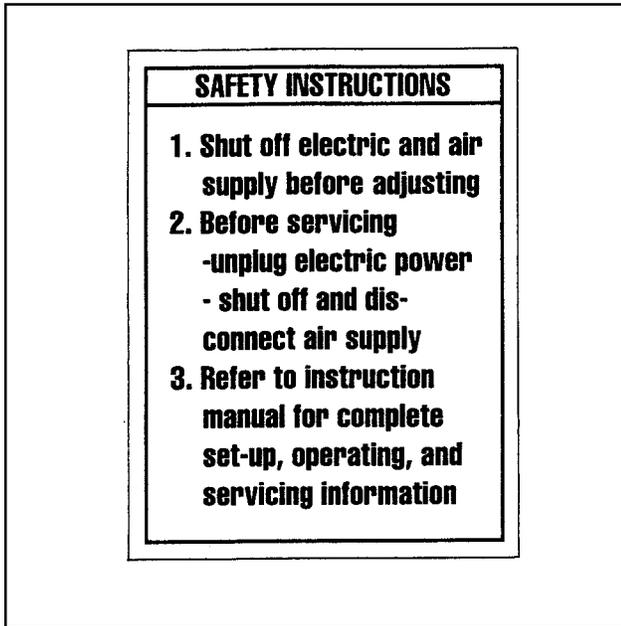


Figure 1-8 – Safety Instructions Label

The "On/Off" label, shown in **Figure 1-10**, is attached to the frame above the On/Off valve and reminds operators of the location of this valve and its function.



Figure 1-10 – On/Off Label

The "Safety Instructions" label, shown in **Figure 1-9**, is attached to the frame above the air valve/regulator and reminds operator of the correct air pressure to use.

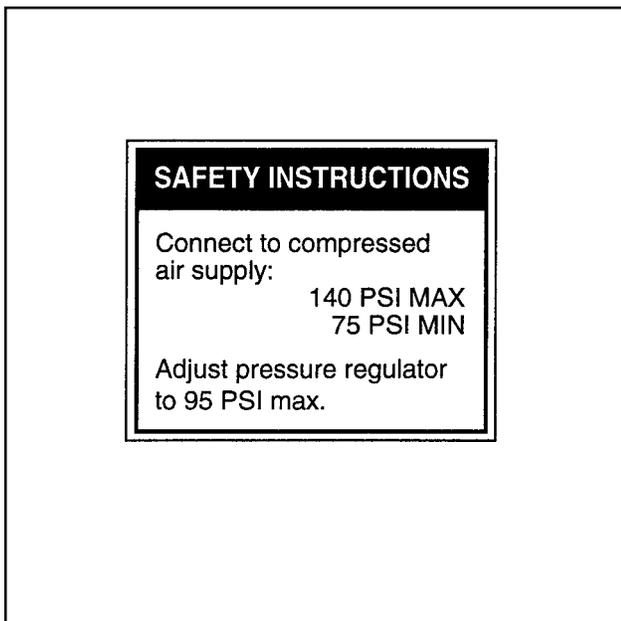


Figure 1-9 – Safety Instructions

Two "Operating Notice" labels, shown in **Figure 1-11**, are located on the top, infeed end of both drive belt assemblies. The labels remind operators of correct belt adjustment procedures.

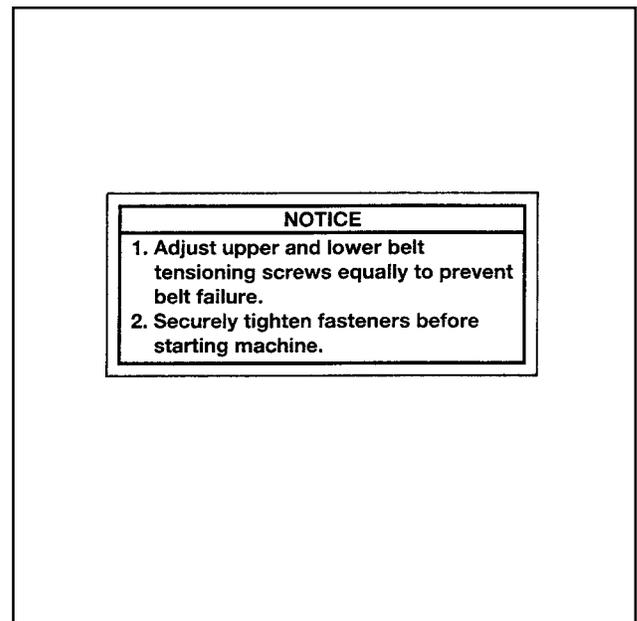


Figure 1-11 – Operating Notice Label

Important Safeguards (Continued)

The "Lifting Notice" label, shown in **Figure 1-12**, is attached to the left side of the machine frame close to the air pressure regulator. This label reminds service personnel of the center-of-gravity and weight of the machine if machine must be lifted and moved.

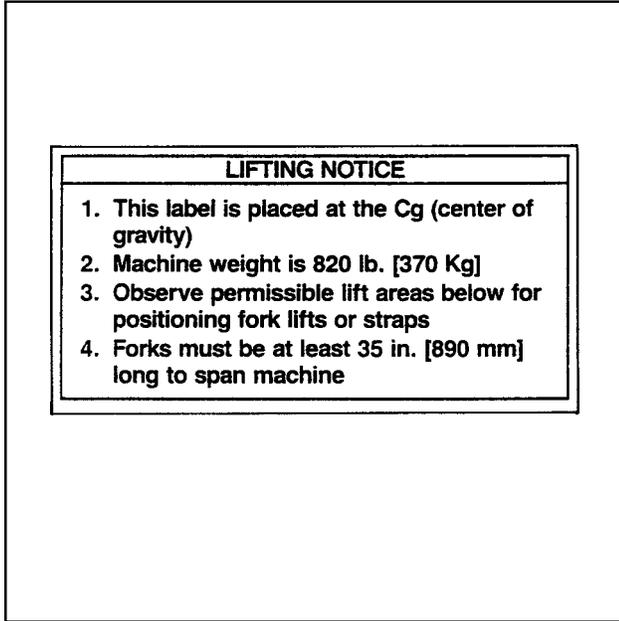


Figure 1-12 – Lifting Notice Label

Two "Permissible Lift Area" labels shown in **Figure 1-13**, are attached, two on each side of machine, at the lower edge of the frame. These labels remind service personnel where to place forks if machine is lifted and moved with forklift truck.

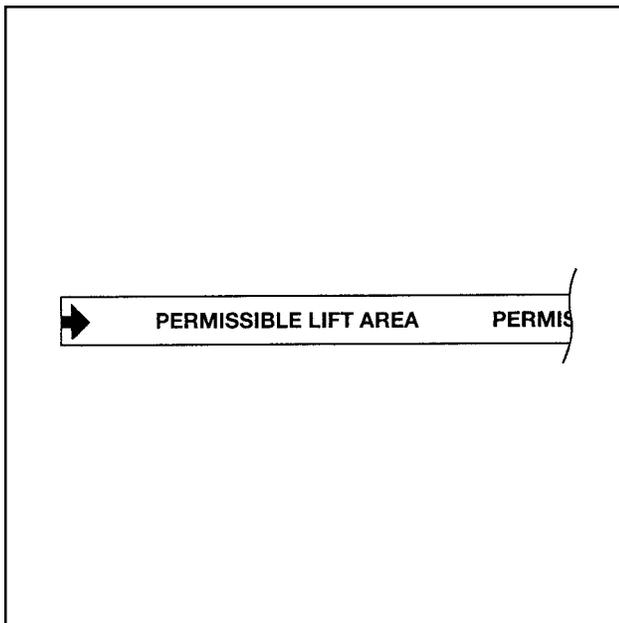


Figure 1-13 – Permissible Lift Area Label

The "Up/Down/Lock" and "In/Out" labels shown in **Figure 1-14**, are attached next to the corresponding height and width adjustment cranks. These labels remind operators of direction to turn adjustment cranks to match box height/width.

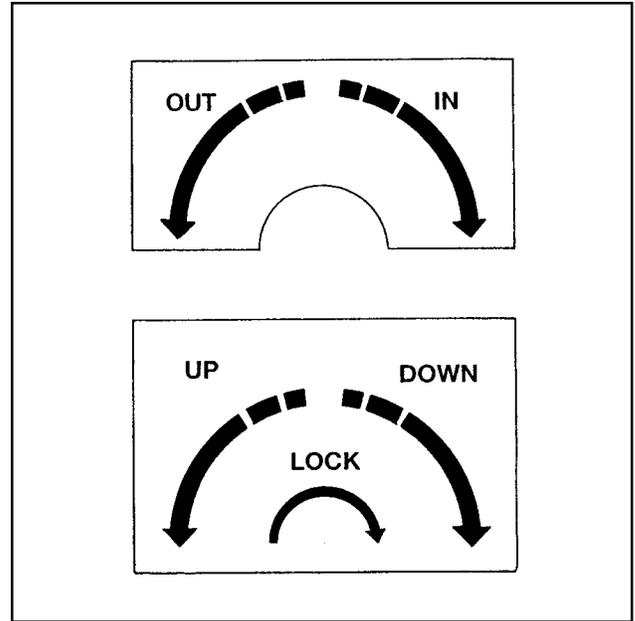


Figure 1-14 – Up/Down/Lock and In/Out Labels

The "Tape Threading" label, shown in **Figure 1-15**, is attached to the lower frame, at the infeed end. This label is a quick reference for tape threading when lower tape roll is mounted in outboard position.

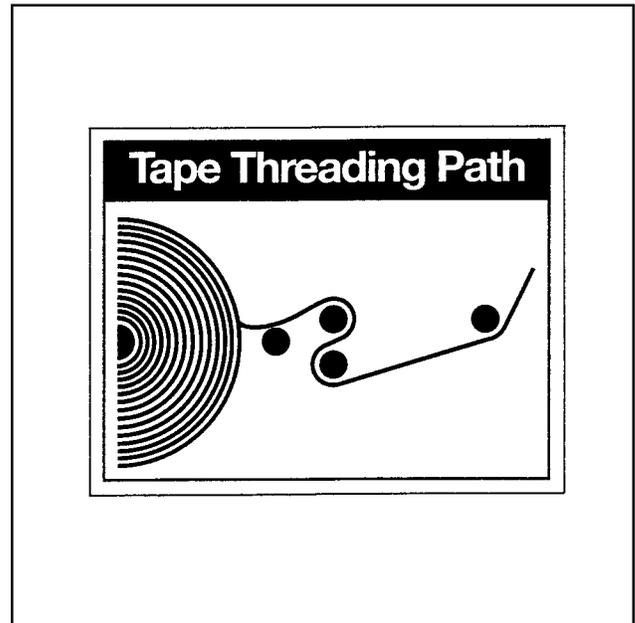


Figure 1-15 – Tape Threading Label

Specifications

1. Power Requirements:

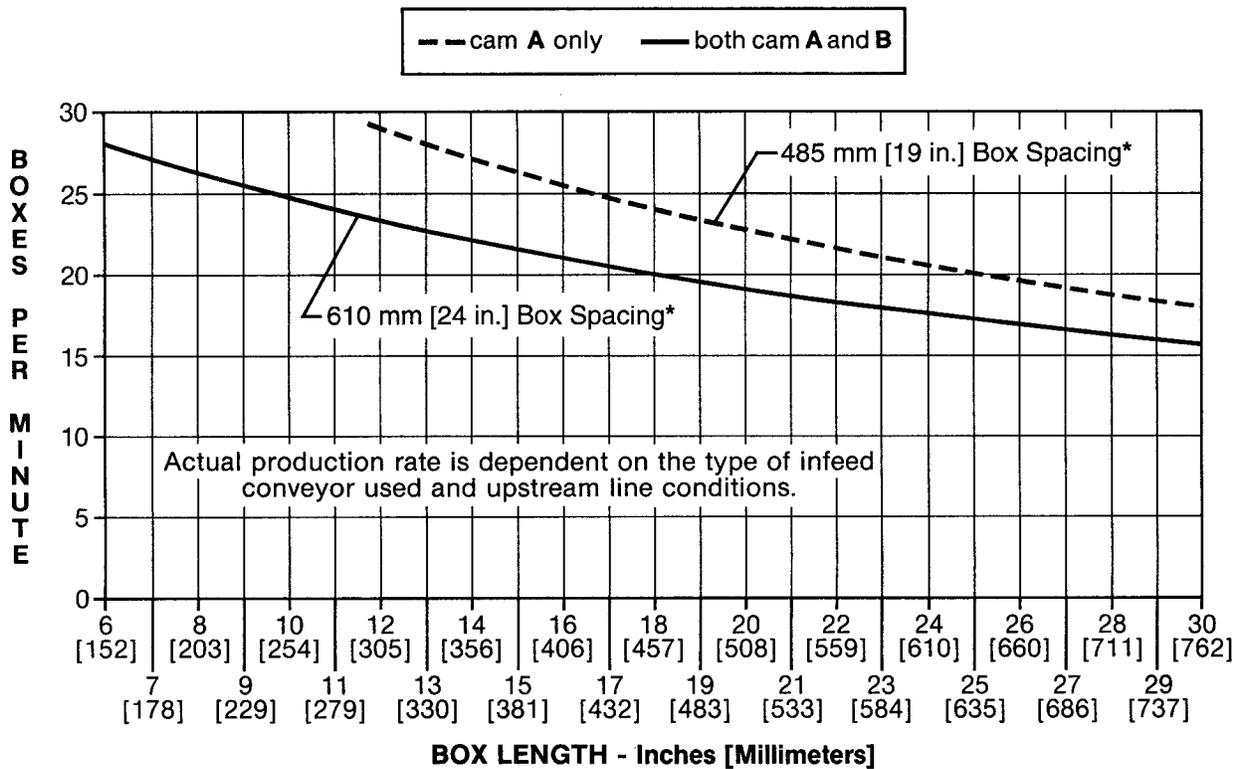
Electrical – 115 VAC, 60 Hz, 3.8 Amp (440 watts)

Pneumatic – 6.5 bar gauge pressure [95 PSIG], 2.5 SCFM
 75 liter/minute @ 21° C., 1.01 bar maximum at maximum cycle rate.
 A pressure regulator/filter is included.

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

2. Operating Rate:

800af BOX RATE vs. BOX LENGTH



*Approximate, dependent on infeed conditions.

Note: Machine is shipped with both cams (A and B) installed. To obtain production rate shown with dotted line (cam A only), cam B must be removed. See "Adjustments – Gate Operation", page 29.

(continued)

Specifications (Continued)

3. 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.

4. Tape:

Scotch™ brand pressure-sensitive film box sealing tapes.

5. Tape Width:

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

6. Tape Roll Diameter:

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

7. Tape Application Leg Length – Standard:

70 mm \pm 6 mm [2-3/4 inch \pm 1/4 inch]

Tape Application Leg Length – Optional:

50 mm \pm 6 mm [2 inch \pm 1/4 inch] (See "Special Set-Up Procedure" – Changing the Tape Leg Length", page 34.)

8. Box Board:

Style – regular slotted containers – RSC
125 to 275 P.S.I. bursting test, single wall B or C flute.

(continued)

Specifications (Continued)

9. Box Weight and Size Capacities:

A. Box Weight, filled – contents must support flaps.

Minimum – weight must be sufficient to hold carton on the conveyor bed with bottom flaps fully closed or 1.4 kg [3 lb.] minimum.

Maximum – 40 kg [85 lb.]

B. Box Size:

Minimum:	Length – 150 mm [6 inches]	Maximum:	Length – 760 mm [30 inches]
	Width – 120 mm [4-3/4 inches]		Width – 545 mm [21-1/2 inches]
	Height – 120 mm [4-3/4 inches]*		Height – 620 mm [24-1/2 inches]**

* Boxes lower than 165 mm [6-1/2 inches] and wider than 320 mm [12-1/2 inches] require removal of compression rollers.

With taping heads adjusted to apply 50 mm [2 inch] tape legs, minimum box height is 95 mm [3-3/4 inches] with box widths greater than 195 mm [7-3/4 inches]. See "Special Set-Up Procedure - Changing the Tape Leg Length", page 34.

** With columns adjusted to upper position, maximum box height increase to 725 mm [28-1/2 inches] and minimum box height increases to 225 mm [8-3/4 inches]. See "Special Set-Up Procedure – Outer Column Re-Positioning", page 35.

Note – The case sealer is designed to accommodate most boxes complying with the 1976 FBA and PMMI*** voluntary standard "Tolerances for Top Opening" regular slotted containers (RSC).

Two of the requirements of the standard are the following:

1. The box length is not more than twice the box width.
2. The box length is not more than four times the box depth.

In addition, the box score lines must be sufficient to facilitate automatic flap folding. Certain environmental conditions, such as high humidity, can be detrimental to automatic flap folding.

***Fibre Box Association, Packaging Machinery Manufacturer's Association

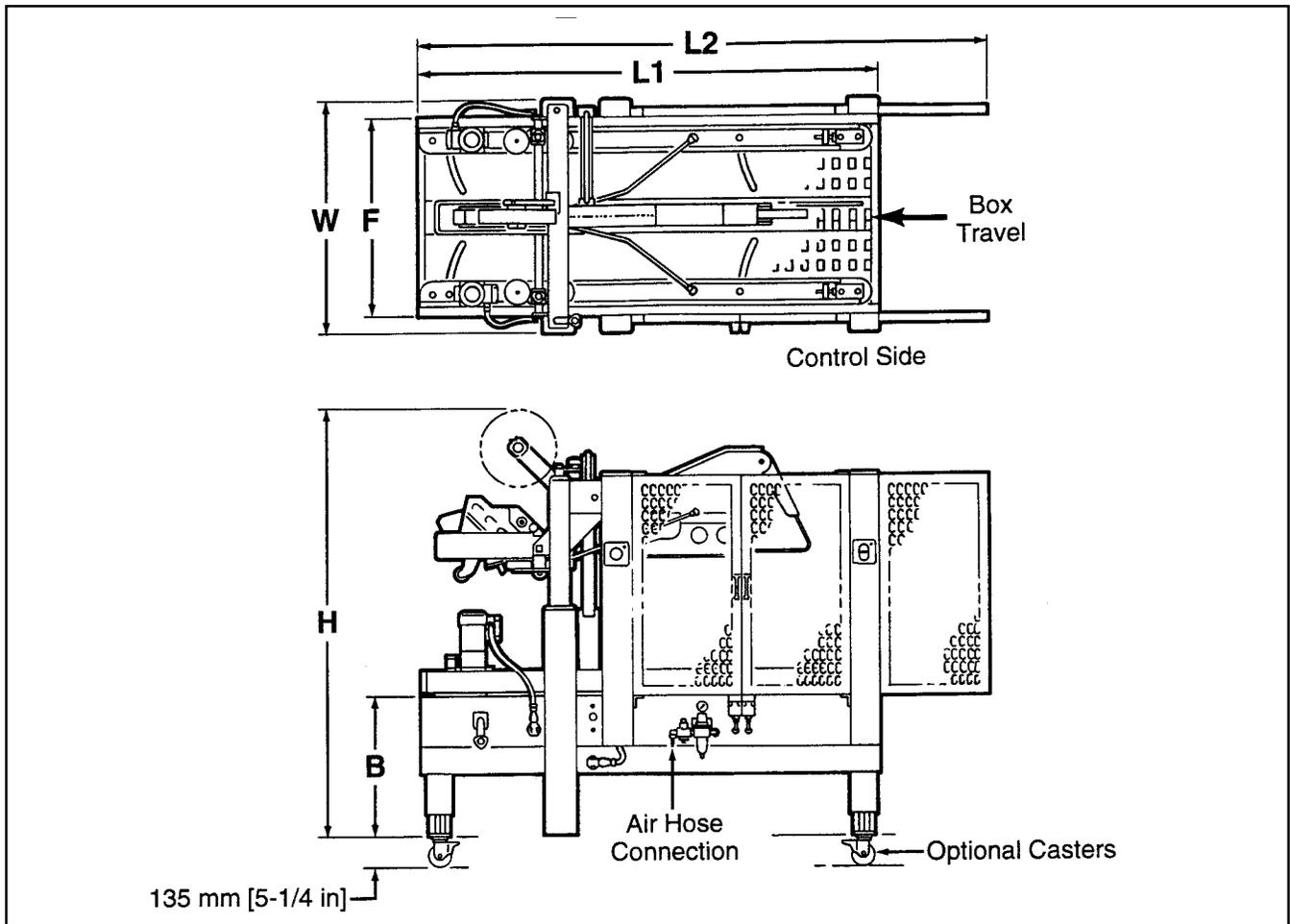
DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

$$\frac{\text{BOX LENGTH IN DIRECTION OF SEAL}}{\text{BOX HEIGHT}} \quad \text{MUST BE GREATER THAN .6}$$

If any of the above criteria are not met boxes should be test run to assure proper machine performance.

(continued)

Specifications (Continued)



10. Machine Dimensions:

	W	L1	L2	H	B	F
Minimum						
mm	985	1920	2375	1575	610	825
[inches]	[38-3/4]	[75-5/8]	[93-7/16]	[62]	[24]	[32-1/2]
Maximum						
mm	985	1920	2375	2185	890	825
[inches]	[38-3/4]	[75-5/8]	[93-7/16]	[86]	[35]	[32-1/2]

Weight – 410 kg [900 lbs.] crated (approximate)
 370 kg [820 lbs.] uncrated (approximate)

11. Set-Up Recommendations:

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

Installation and Set-Up

Receiving And Handling

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

Machine Set-Up

It is recommended that the case sealer be set-up and operated with product before placing it in the production line. This approach will allow your thorough review and familiarization with the 800af before subjecting it and operating personnel to a production situation where time for set-up, adjustments, and operator training usually becomes limited.

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 Figure 3-1 and 3-2 to identify the various components and controls of the machine.

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

IMPORTANT – Read "Warnings" on page 18 before attempting to set-up the case sealer for operation.

1. Follow "Unpacking Instructions" label attached to corrugated packing cover.
2. 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 wiring or mechanism under the machine frame. In some cases the lower taping head may need to be removed to avoid damage.



CAUTION – Machine weighs approximately 370 kg [820 lbs] uncrated.

2. Remove and discard cable ties on upper head assembly.
3. Install the crank handle on the top of the left column, as shown in Figure 2-1A.
4. Install upper tape drum bracket on the top cross bar, as shown in Figure 2-1B.
5. Install the two infeed end guards. Attach the guards to the infeed end vertical masts, as shown in Figure 2-1C.
6. Raise upper head assembly (turn crank handle counterclockwise). Install the machine stops (from parts bag). Mount these stops as shown in Figure 2-1D using lowest hole position on brackets. The upper hole position in the stops should only be used when the heads are adjusted to apply 50 mm [2 inch] tape legs.
7. The lower tape drum bracket assembly is mounted on the lower head in the standard position. Ensure that the bracket assembly is mounted straight down, as shown in Figure 2-2A. The tape drum bracket assembly can be pivoted to provide clearance or for retrofit in certain cases.

Lower outboard tape roll mounting (alternate position) –

- a. Remove lower taping head from machine.
- b. Remove existing tape drum bracket from taping head and replace with bracket/roller assembly (shipped loose), Figure 2-2B. Replace taping head in machine.
- c. Install tape drum bracket (removed from taping head) on exit end of machine lower frame as shown in Figure 2-2B.

Installation and Set-Up (Continued)

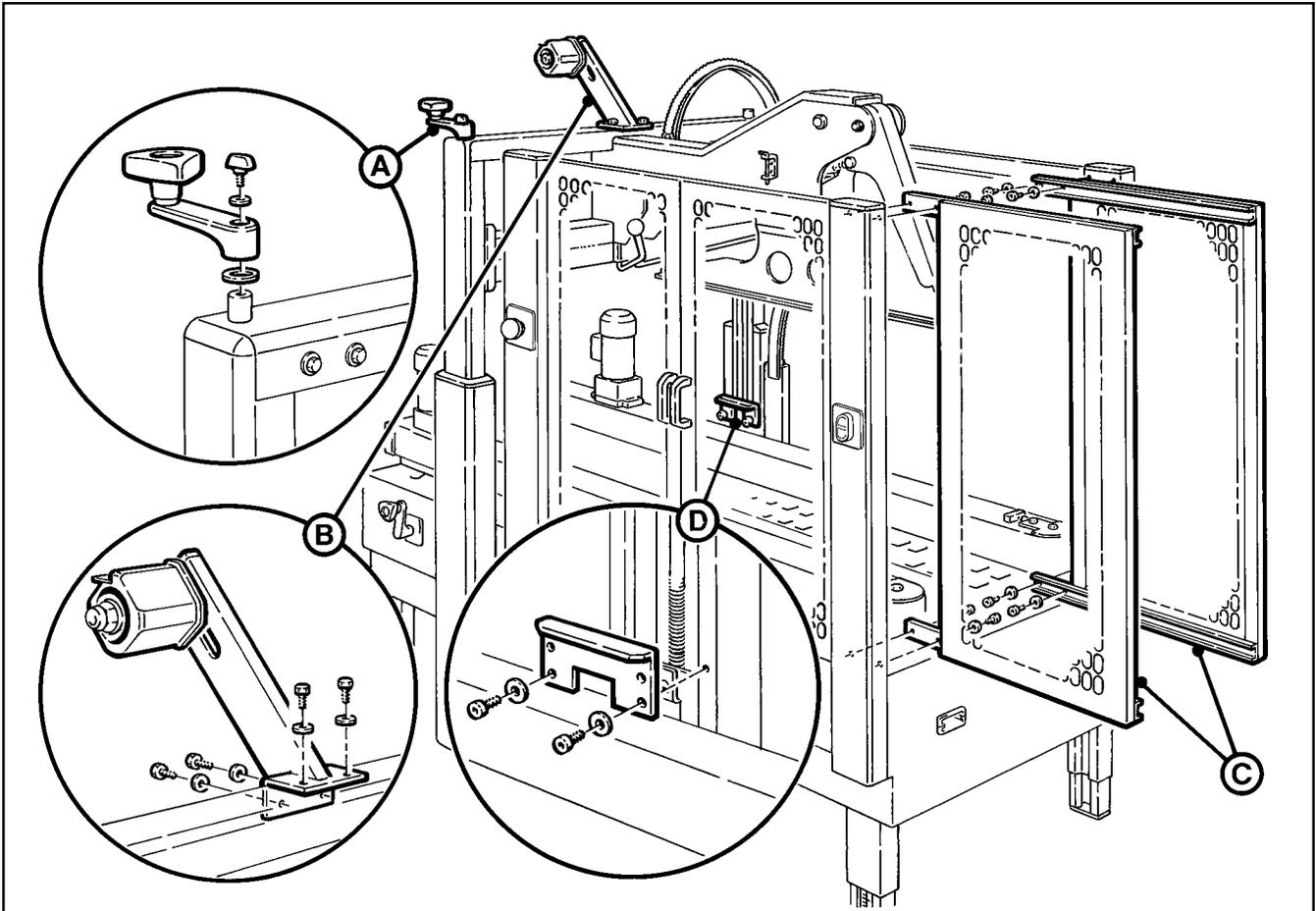


Figure 2-1 – Installation and Set-Up

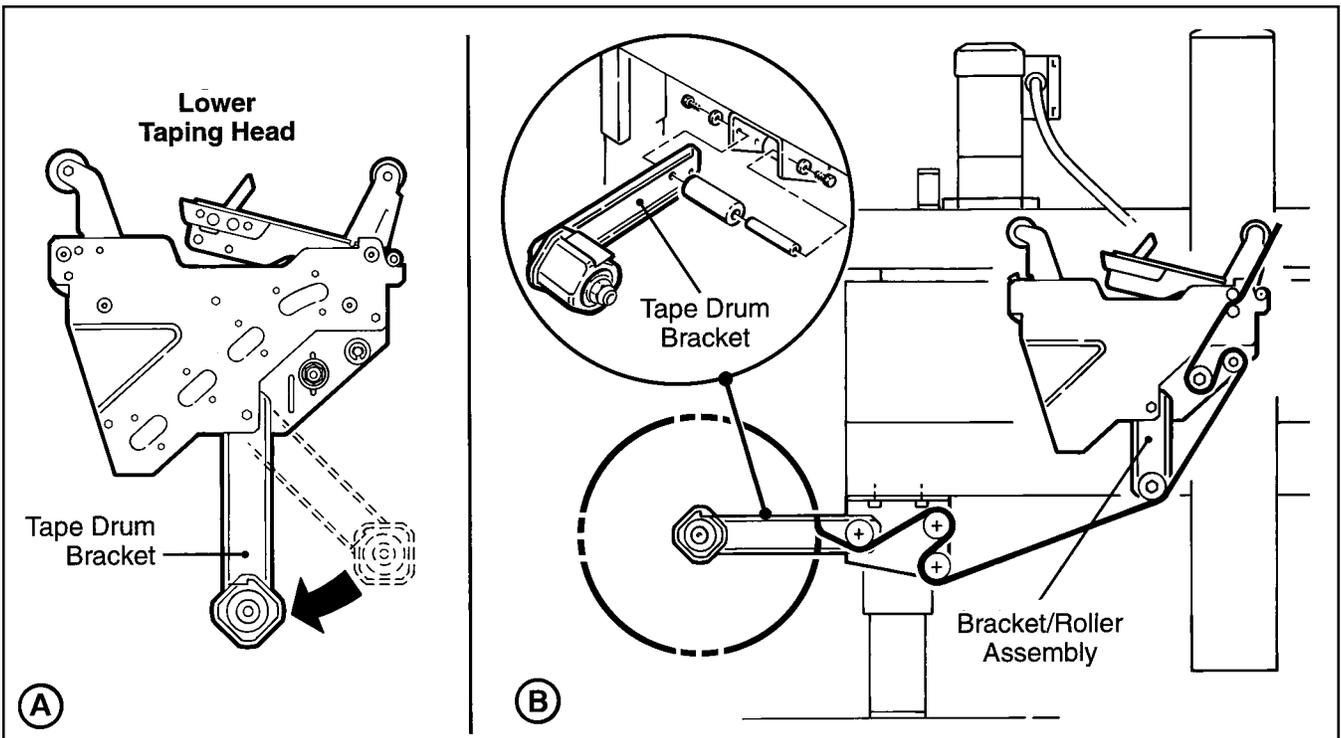


Figure 2-2 – Lower Tape Drum Bracket Position

Installation and Set-Up (Continued)

8. Install case sealer in production line. When installing the case sealer, be sure to observe the following guidelines.
 - a. Case sealer must be installed level – it is not designed to convey boxes uphill.
 - b. Infeed conveyor must convey boxes to case sealer at a speed not to exceed 0.30 m/s [60 f/m].
 - c. Precautions must be taken to prevent excessive box pressure against the case sealer infeed gate. This will help to prevent damage to the boxes and ensure proper performance.
 - d. Infeed and exit conveyors must provide straight entrance and exit of boxes to/from case sealer and exit conveyor must positively convey boxes away from machine.
 - e. Refer to Figure 2-3 for suggested conveyor types that can be used with the case sealer.

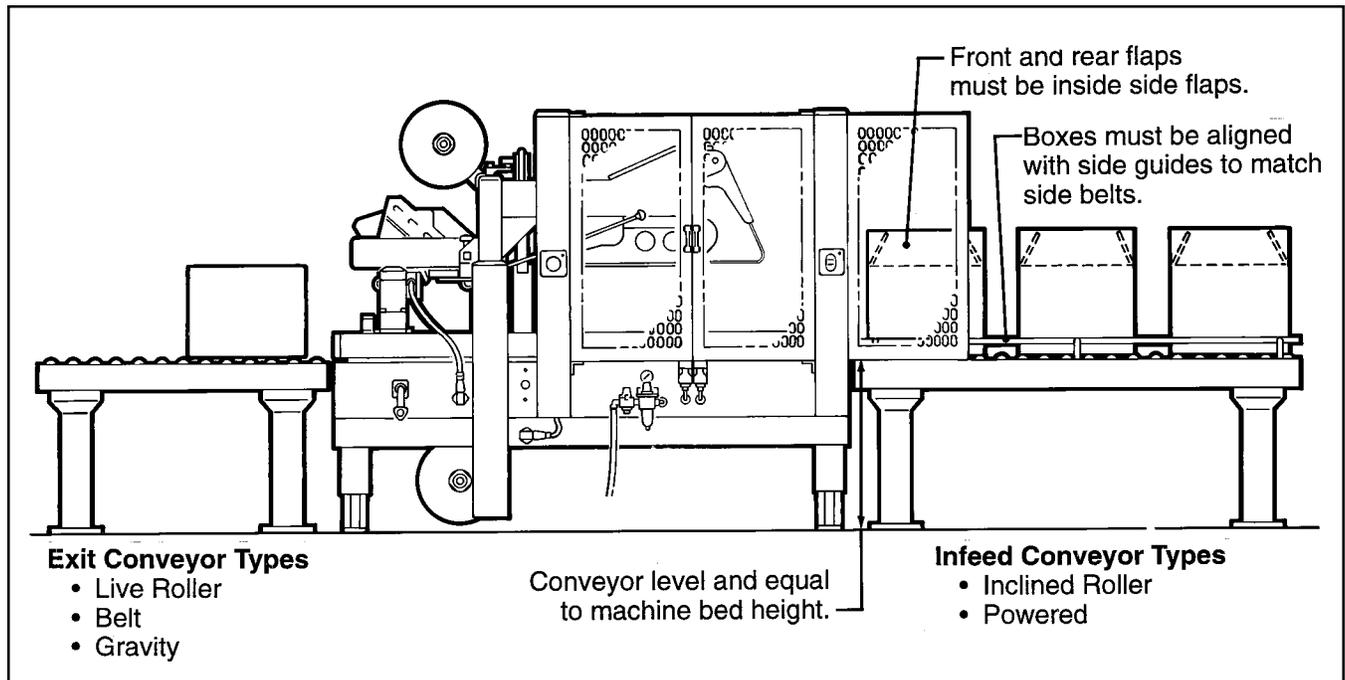


Figure 2-3 – Conveyor Systems

9. Adjust case sealer bed height. The adjustable legs provide different machine bed heights from 610 mm [24 inches] minimum to 890 mm [35 inches] maximum.

Refer to Figure 2-4 and set the machine bed height as follows:

- a. Block up the machine frame to allow adequate leg adjustment.
 - b. Loosen, but do not remove, two M8 x 1.25 mm socket head screws in one leg (use M6 hex key wrench). Adjust the leg length for the desired machine bed height. Retighten the two screws to secure the leg. Adjust all four legs equally.
10. Tape width – the taping heads have been preset to accommodate 72 mm [3 inch] wide tape rolls. To apply narrower width tapes, refer to Section II, "Adjustments – Tape Web Alignment", page 11.

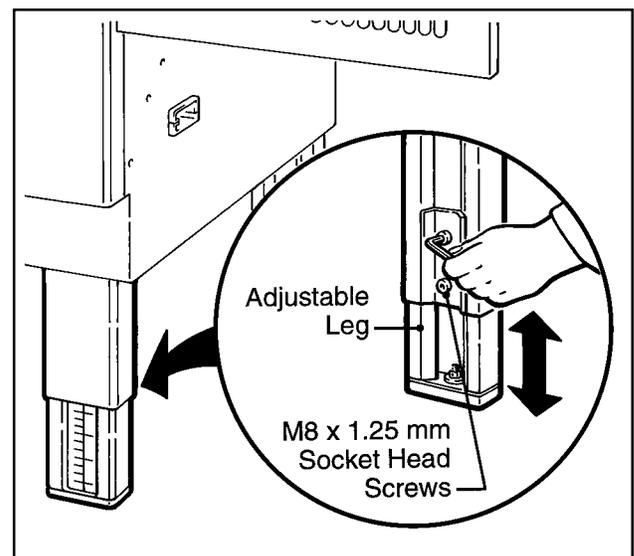


Figure 2-4 – Conveyor Bed Height Adjustment

Installation and Set-Up (Continued)

11. Box size capacity (height) – at its factory setting, the case sealer handles box sizes up to 620 mm [24-1/2 inches] maximum height. If larger capacity is needed, the machine can be adjusted to accommodate up to 725 mm [28-1/2 inches] high boxes. Refer to "Special Set-Up Procedure – Outer Column Re-Positioning", page 35 for set-up information.
12. Drive Belt Height – drive belt assemblies can be raised 50 mm [2 inches] to provide better conveying of tall boxes. Refer to "Special Set-Up Procedure – Changing Drive Belt Height", page 33.
13. Pneumatic connection.



WARNING – USE CARE WHEN WORKING WITH COMPRESSED AIR.

The case sealer requires a 6.5 bar gauge pressure [95 PSIG] 75 liter/min @21°C, 1.01 bar [2.5 SCFM] compressed air supply. As shown in Figure 2-3 an on/off valve, pressure regulator, and filter are provided to service the air supply.

The main air supply line should be connected to the on/off valve by means of the barbed fitting and hose clamp provided on the outer side of the on/off valve as shown in Figure 2-3. The customer supplied air hose (5/16 inch [8 mm] ID) should be slipped over the barbed fitting and clamped tightly in place.

If another type of connector is desired, the fitting can be removed and replaced with the desired 1/4-18 NPT threaded connector.

Always turn the valve "Off" when air supply line is being connected or disconnected.

14. Electrical connection and controls – the electrical control box shown in Figure 3-1, contains the "On/Off" switch with pre-set breaker and can be located on either side of the machine frame for operator convenience. A standard three conductor power cord with plug is provided at the back of the electrical control box for 115 Volt, 60 Hz, 3.8 Amp electrical service. The receptacle providing this service shall be properly grounded. Before the power cord is plugged into 115 Volt, 60 Hz outlet, make sure 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 "Set-Up" procedure, continue through "Operation", pages 15-24 to be sure case sealer is properly adjusted to run product.

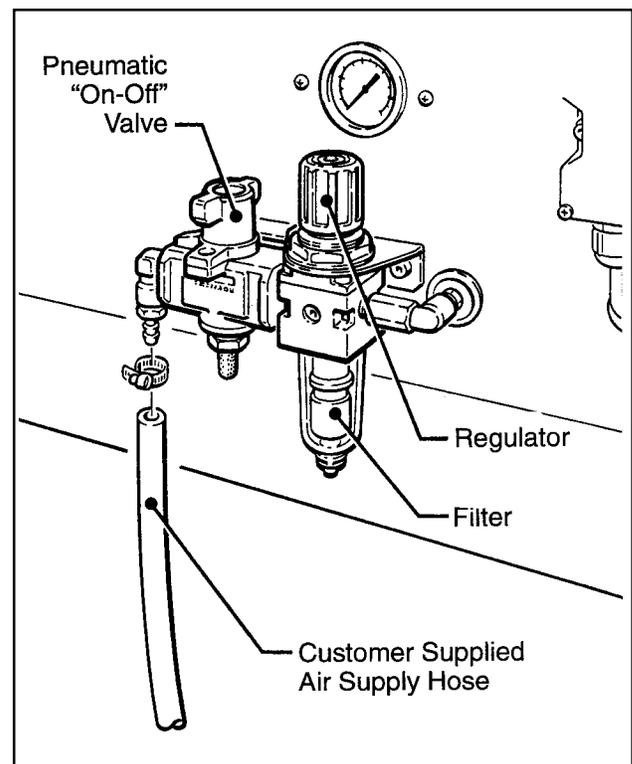


Figure 2-3 – Pneumatic Connection

Operation

IMPORTANT - Before operating the case sealer, read all the "Important Safeguards", pages 3 - 6 and "Warnings" on page 18 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 800af case sealer. Also see Figures 3-1 and 3-2 in Section II for taping head components.

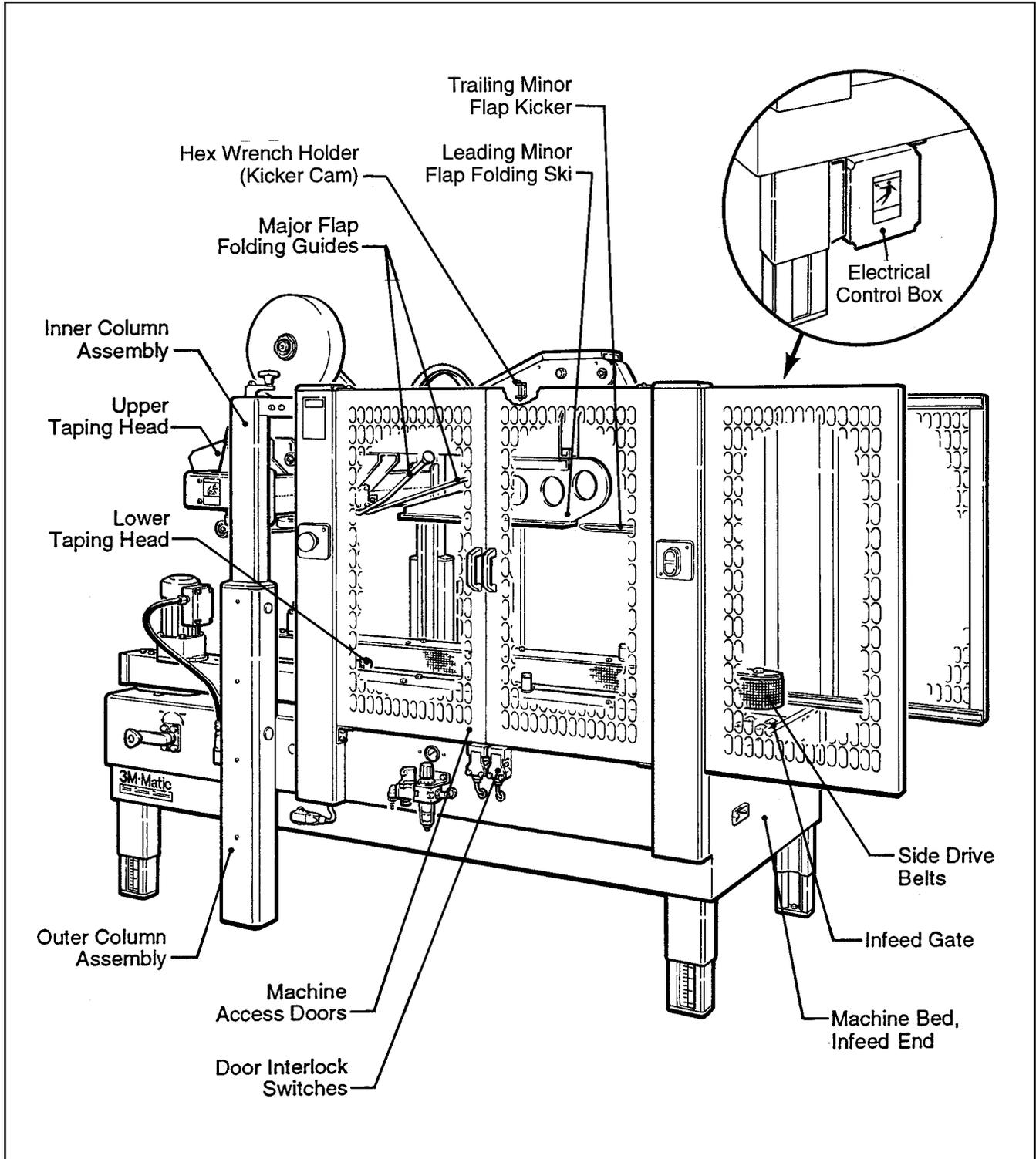


Figure 3-1 – Case Sealer Components

Operation (Continued)

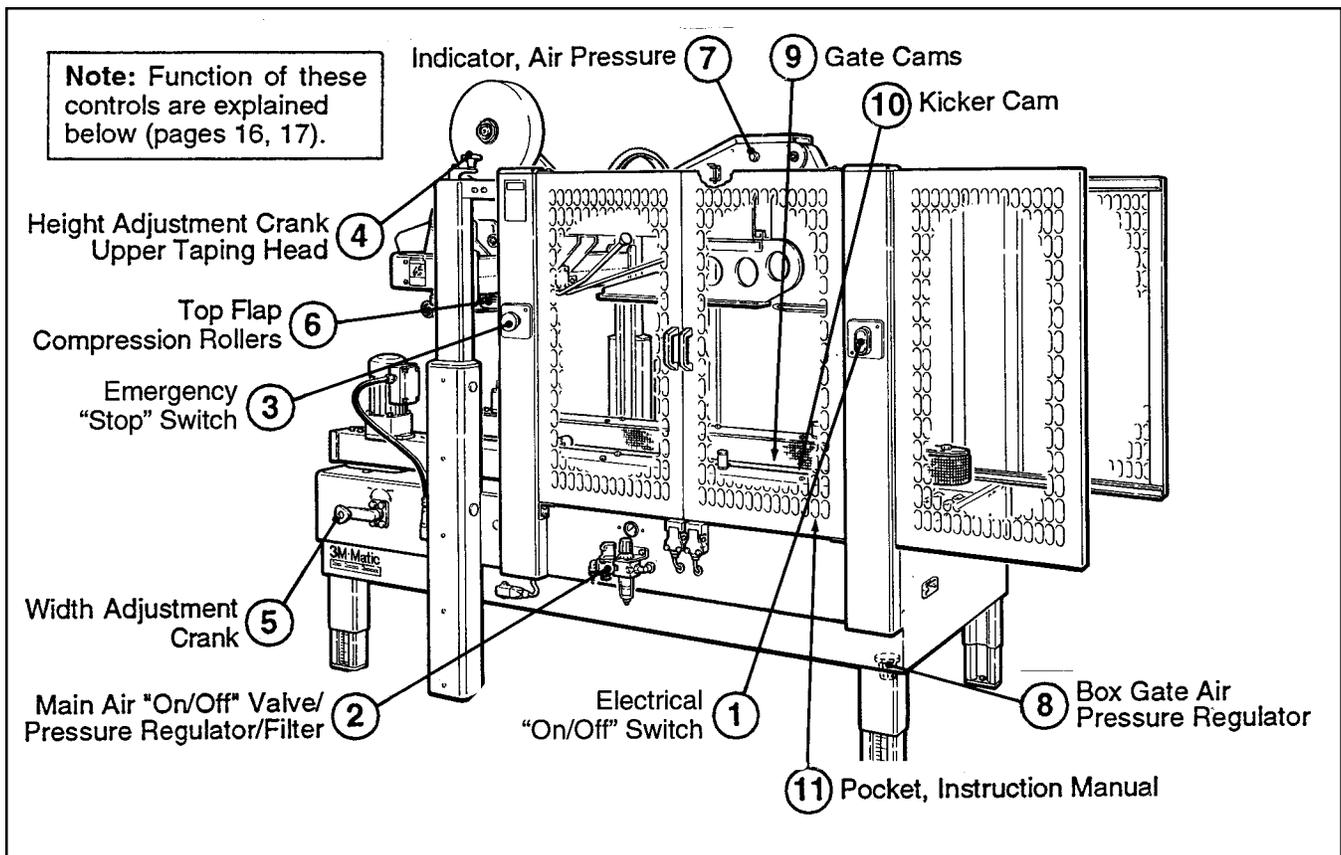


Figure 3-2 – Controls, Valves and Switches

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

Note – The case sealer has a circuit breaker located in the electrical enclosure on the lower right side of the machine frame. If circuit becomes overloaded and circuit breaker trips, unplug the machine electrical cord and determine cause of overload. After two minutes, remove the electrical control box cover and reset the circuit breaker by pressing the "Reset" button and then the "Start" button on the circuit breaker. Replace the control box cover, plug machine electrical cord into outlet and restart machine by pressing green "On" button.

- 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 to adjust pressure, pull knob up and turn – 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)

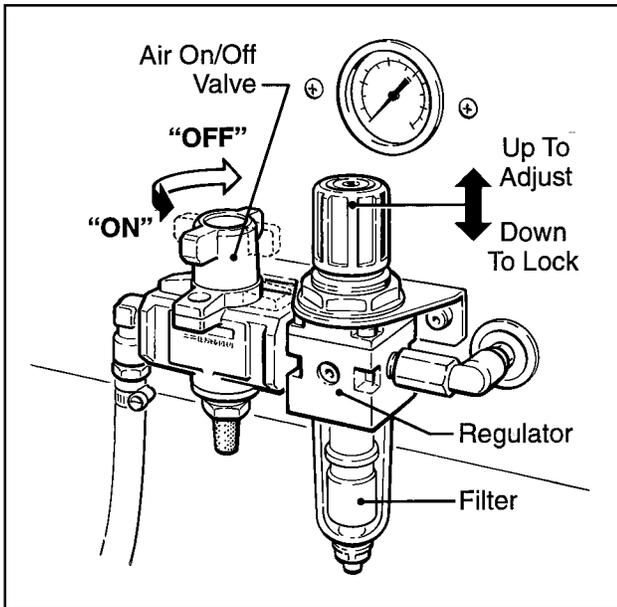


Figure 3-3 – "On/Off" Valve/Regulator/Filter

- ③ **Emergency "Stop" Switch**
The two emergency "Stop" switches are mounted for operator convenience, on both sides of the case sealer. Pushing either of these switches will stop the drive motors/belts and exhaust air from the flap kicker.

To restart machine, rotate emergency stop switch (release switch latch) and then restart machine by pressing green (On) button on side guard.
- ④ **Height Adjustment Crank, Upper Taping Head**
Raises and lowers upper taping head/flap folders to accommodate box height.
- ⑤ **Width Adjustment Crank**
Adjusts distance between side drive belts to accommodate box width.
- ⑥ **Top Flap Compression Rollers**
Rollers adjust to properly maintain box width/top flap center seam for tape seal.
- ⑦ **Indicator, Air Pressure**
The optical warning indicator, located on the upper flap folder frame, indicates "Red" when compressed air circuit is on.
- ⑧ **Box Gate Air Pressure Regulator**
Adjusts lifting force of the box gate depending on the weight of boxes being sealed.

- ⑨ **Gate Cams** Figure 3-4
The gate cams (A) (B) control the rate of box entry into the case sealer. Depending on box size, gate cams can be adjusted to increase production rate. See "Adjustments – Gate Operation", page 29.
- ⑩ **Kicker Cam** Figure 3-4
The minor flap folder, controlled by the kicker cam (C), closes the trailing minor flap on the box. The kicker cam must be adjusted according to the length of the box being sealed. See "Operation", page 20, Figure 3-8.
- ⑪ **Pocket, Instruction Manual**
A pocket is provided inside the right door for storage of the machine instruction manual. Keep the manual in this pocket for the convenience of machine operators.

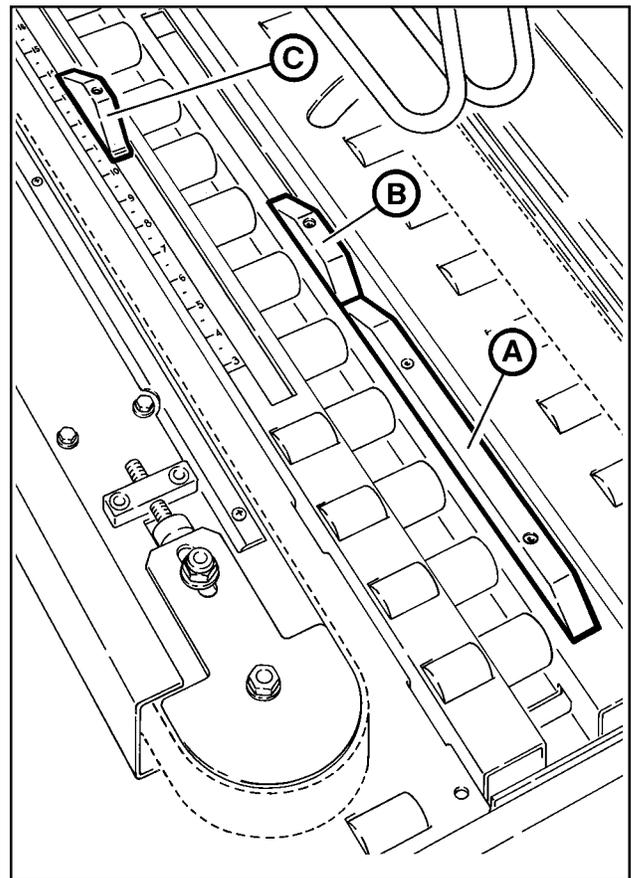


Figure 3-4 – Gate/Kicker Cams

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. Turn electrical and air supplies off when machine is not in use.
2. Do not leave machine running unattended.
3. Before turning drive belts on, be sure no tools or other objects are on the machine bed.
4. Keep hands and loose clothing away from moving belts and flap kicker.
5. Keep away from flap kicker. Flap kicker is controlled by air and can be activated (if air supply is "On") by depressing flap kicker cam. Be sure flap kicker is in the down position before servicing.
6. Never attempt to remove jammed boxes from the machine while machine is running.
7. Machine access door must be closed when drive belts are running. Do not attempt to override door interlock switch.
8. Keep hands and clothing away from taping heads when machine is running. A box traveling through the machine causes taping head rollers to retract when box enters and extend as box leaves taping head.
9. Both the upper and lower taping heads utilize extremely sharp tape cut-off knives. The knife is located under the orange knife 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 knife location. Keep hands out of these areas except as necessary to service the taping heads.
10. Failure to comply with these warnings could result in severe personal injury and/or equipment damage.

Tape Loading/Threading – Upper Taping Head

See Section II, Pages 7 and 8

Tape Loading/Threading – Lower Taping Head With Tape Drum On Taping Head

See Section II, Pages 7 and 8

Tape Loading/Threading – Lower Taping Head With Alternate Outboard Tape Drum

1. Raise upper taping head high enough to allow clearance for removing lower taping head.
2. Remove lower taping head from machine bed and install threading needle as explained in Section II, page 7.
3. Replace taping head back into machine.
4. Place tape roll on outboard tape drum with adhesive side down on lead end of tape. (Seat tape roll fully against back flange of tape drum.) Thread tape through outboard tape rollers as shown in Figure 3-5 and adhere tape lead end to lower end of threading needle.
5. Complete tape threading as explained in Section II, page 8.



CAUTION – Taping head weighs approximately 7.2 kg [16 pounds] without tape. Use proper body mechanics when removing or installing taping head.

Operation (Continued)

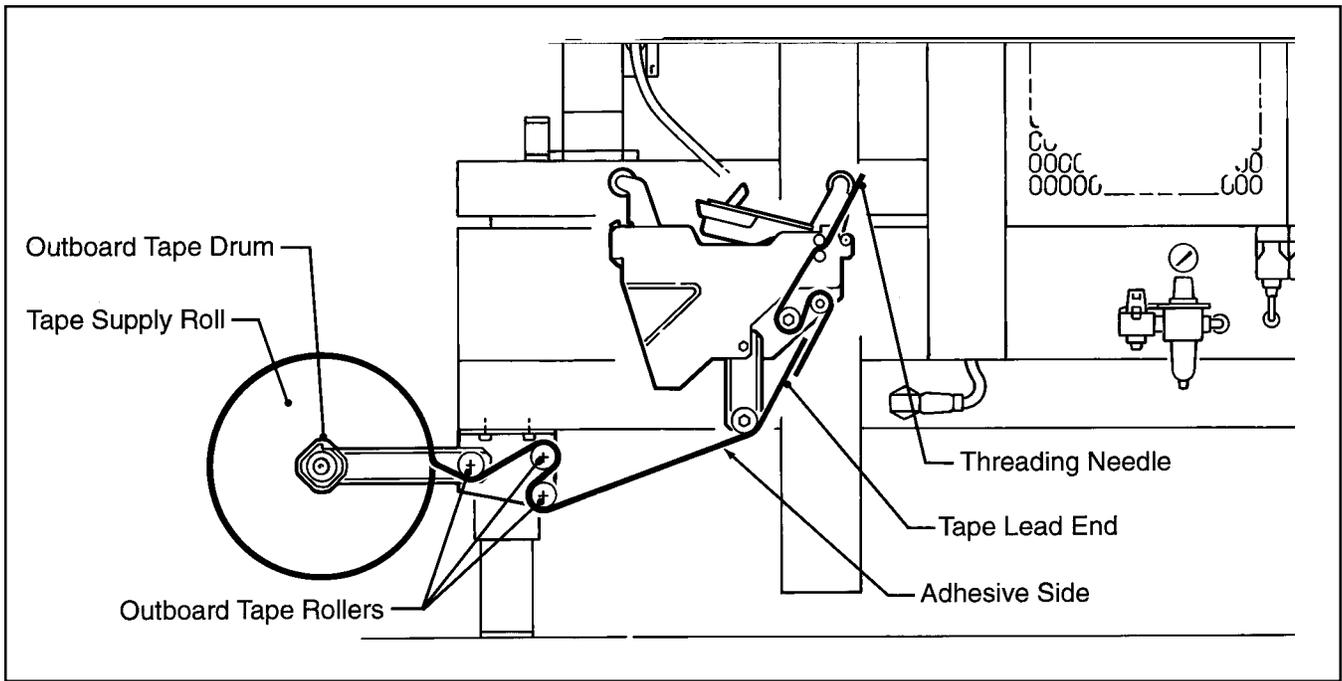


Figure 3-5 – Tape Threading With Alternate Outboard Tape Drum

Box Size Set-Up

Figure 3-6

Open the side drive belts and raise the upper head assembly to accommodate the desired box width and height.

Move the compression rolls as wide as possible.

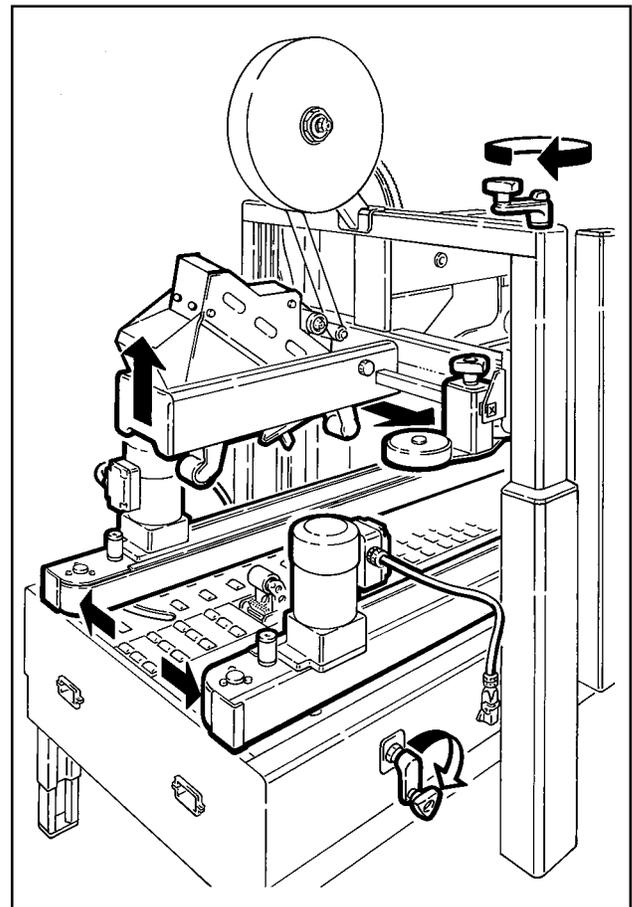


Figure 3-6 – Box Size Set-Up

Operation (Continued)

Figure 3-7

Place a product filled box 55 to 65 mm [2-1/4 to 2-1/2 inches] into the exit end of the machine with the top flaps folded as shown.

Crank the upper head down until it just contacts the top of the box.

Crank the side drive belts in until the belts firmly grip the box.

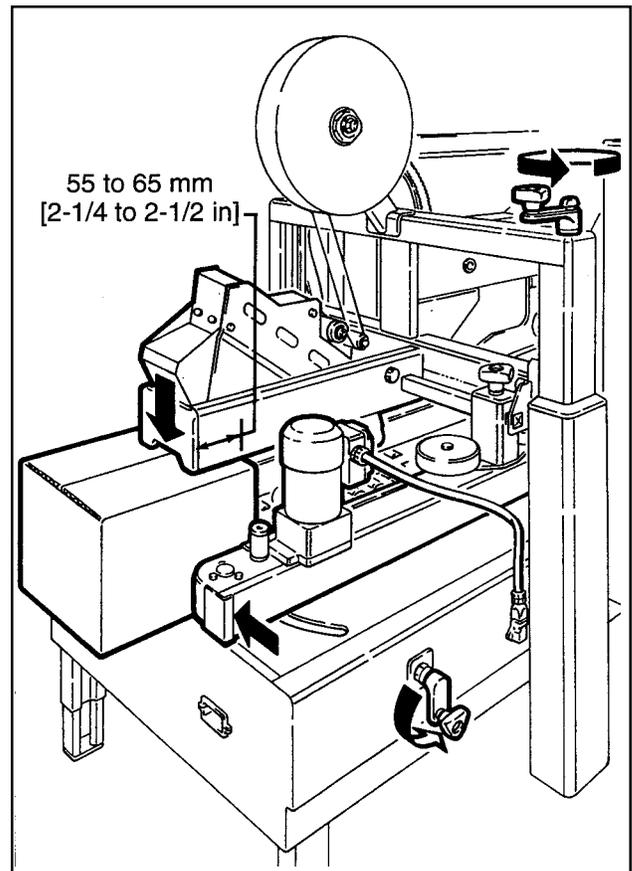


Figure 3-7 – Box Size Set-Up

Figure 3-8

Set Kicker cam relative to length of box being sealed. Measure the distance "X" as shown and set the cam to the same dimension measured on the box. (This dimension provides a good starting point for setting the kicker cam.)

Note: 5 mm hex key wrench is supplied with machine and should be kept in wrench holder on side of upper frame. See Figure 3-1.

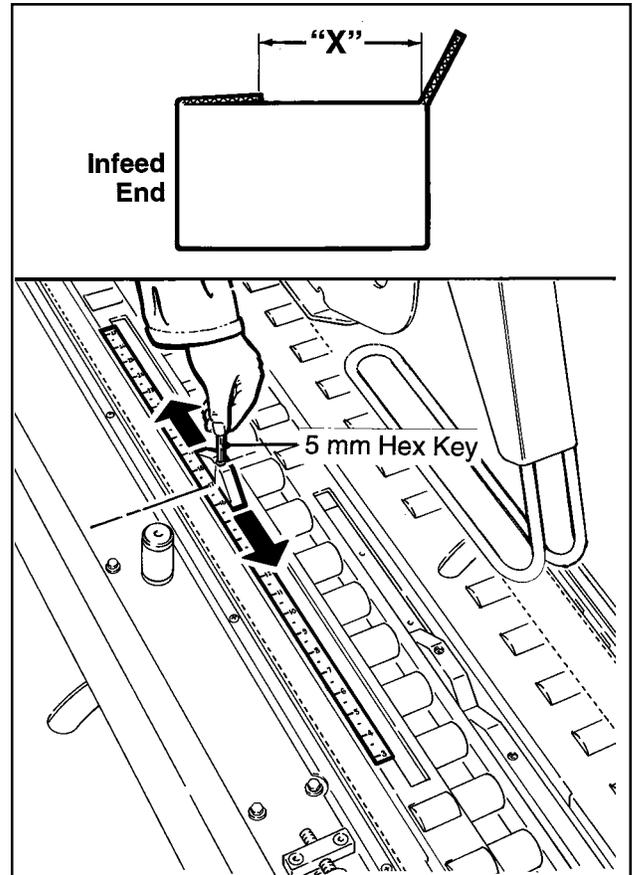


Figure 3-8 – Box Size Set-Up

Operation (Continued)

Figure 3-9

WARNING – Be sure all packaging materials and tools are removed from the machine before operating

Turn air On/Off valve to the "On" (SUP) position.

Press electrical "On" button to start drive belts.

Place box at infeed end of machine and push into machine until it is taken away by drive belts.

CAUTION – Keep hands away from drive belts when feeding boxes.

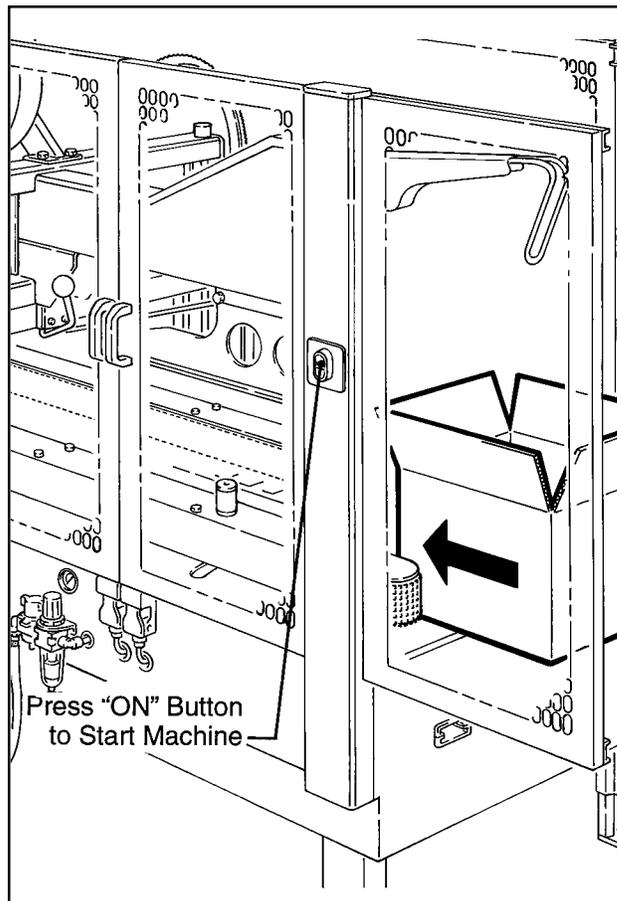


Figure 3-9 – Box Size Set-Up

Figure 3-10

Adjust compression rollers. Run box through machine and stop when adjacent to compression rollers. Move compression rollers in to press box top flaps firmly together. Restart machine to exit box.

WARNING – Keep hands away from compression rollers when box is passing through machine to avoid injury.

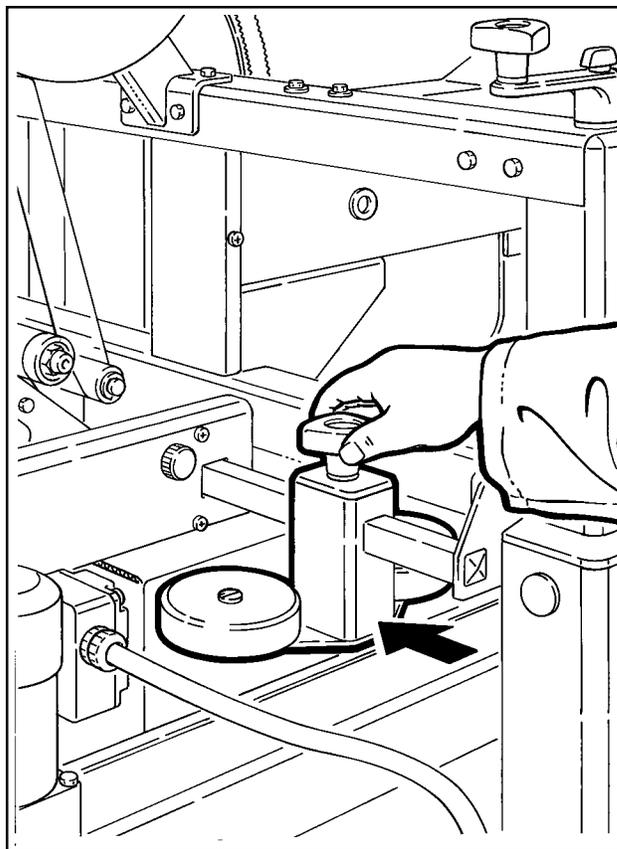


Figure 3-10 – Box Size Set-Up

Operation (Continued)

Figure 3-11

Run several test boxes through the machine, and observe the flap kicking action. Adjust the kicker cam so the kicker "kicks" earlier or later as required (refer to figure 3-8). In general, it is better to set the kicker to "kick" early because it contacts the flap higher above the score-line which results in more reliable flap folding.



WARNING – Keep hands away from drive belts and flap kicker when feeding boxes to the machine.

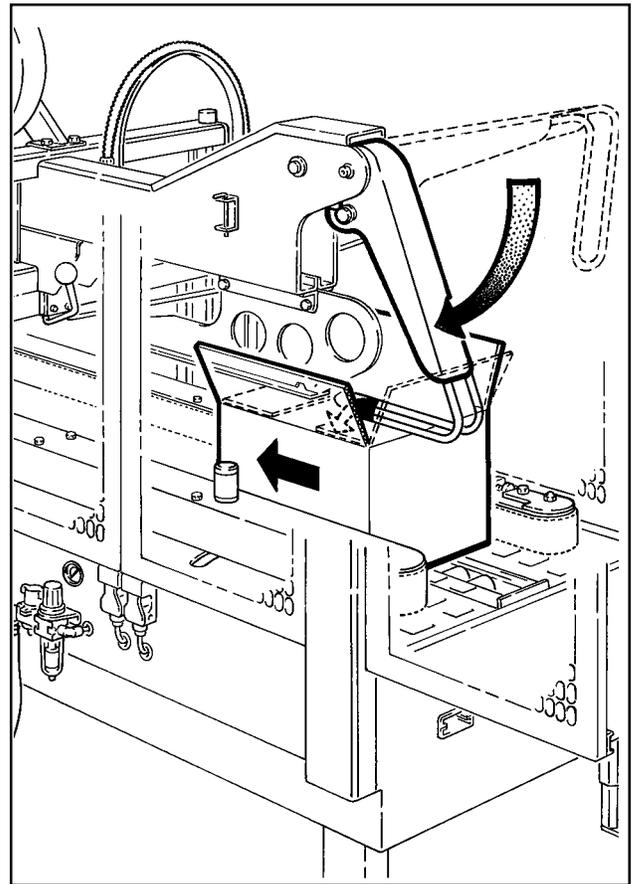


Figure 3-11 – Box Size Set-Up

Figure 3-12

The upper side flap folding guides can be adjusted in or out to accommodate the width of the box. For optimum performance, the side flap folding guides should be adjusted to the narrowest position which allows them to catch any side flaps that may be bent outward past vertical.

Note – Box flaps should not be bent outward past vertical more than 15° when entering case sealer.

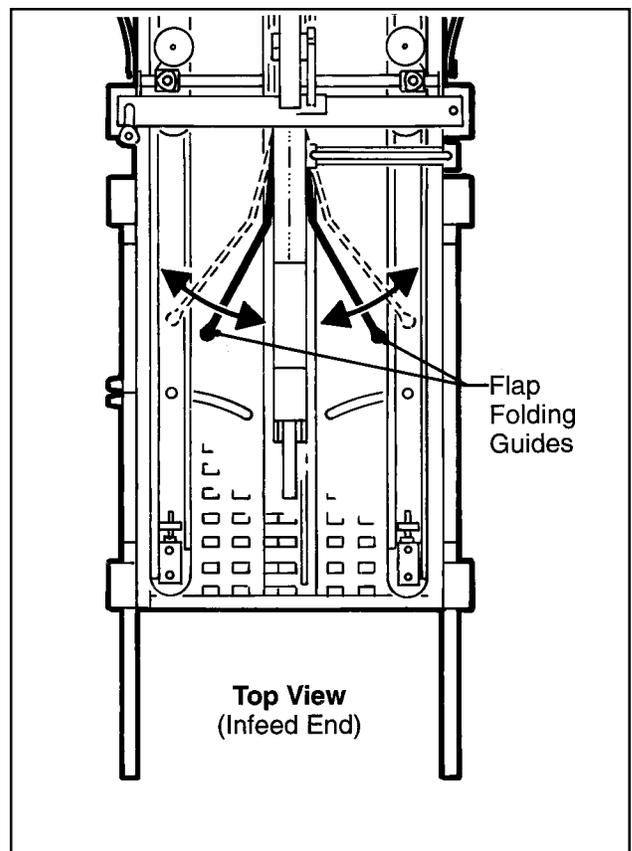


Figure 3-12 – Box Size Set-Up

Operation (Continued)

Figure 3-13

If the box is hard to move under the top head or is crushed, raise the top head slightly.

If the box movement is jerky or stops under the top head, move the side drive belts in slightly to add more pressure between the box and drive belts.

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

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

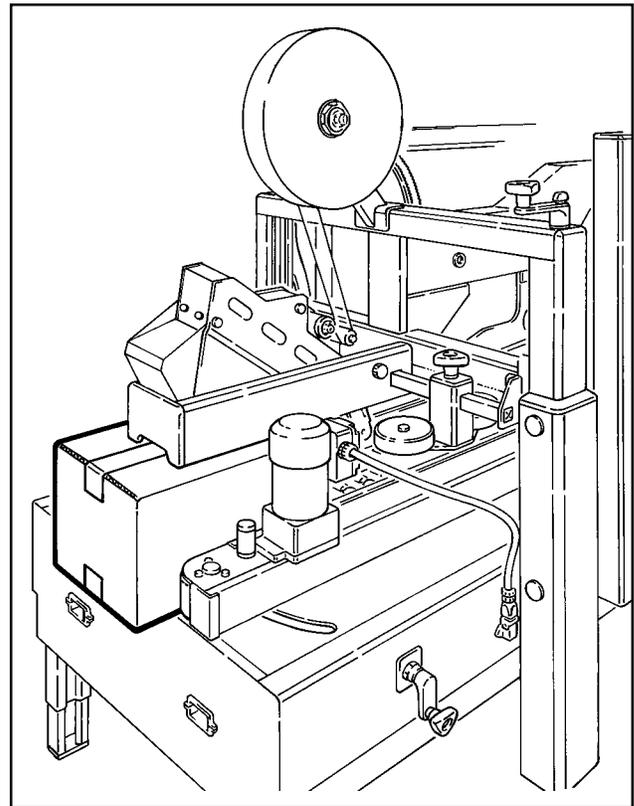


Figure 3-13 – Box Size Set-Up

Box Sealing

WARNINGS

1. Remove tools or other objects from machine bed before starting machine.
2. Keep hands and loose clothing away from moving belts, flap kicker and flap kicker cam.
3. 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.**
5. Never attempt to remove jammed boxes from the machine while machine is running. See "Box Jams", page 24.

1. Connect electrical and air supplies.
2. Turn main air valve "On" and adjust air regulator if pressure does not read 5 bar gauge pressure [70 PSIG].
3. Press electrical "On" button to start drive belts.
4. Continually feed boxes to case sealer, case sealer will automatically space entrance of boxes to machine.
5. Turn electrical and air 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. 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.
2. Adjustment of the machine or taping heads are described in the "Adjustment" section of this manual.

Operation (Continued)

Box Jams

If a box is improperly fabricated or filled, if the machine is mis-adjusted for the box being run, or if boxes enter the machine incorrectly, a box jam may occur. To clear a box jam, follow these steps:

1. Determine cause of box jam so corrective action can be taken to prevent reoccurrence.
2. Turn off machine.



WARNINGS

1. **Turn off and disconnect air and electrical supplies before attempting to remove jammed box or serious injury could occur.**
2. **Wait for flap kicker to reach down position as shown in Figure 3-11, to avoid being hit or startled by its movement.**

3. Crank upper head up and/or drive belts out until box is free.
4. Carefully pull box out of machine.



WARNINGS

1. **Keep hands away from upper and lower taping head cut-off knife as knife is extremely sharp and can cause severe injury.**
2. **When reaching into the machine to remove a jammed box, use proper posture to prevent back or other injuries.**

5. Readjust upper head and drive belts according to "Machine Adjustment for Box Size" instructions on pages 19 - 23.
6. Connect air and electrical supplies.
7. Turn machine "On" **only when it is safe to do so!**

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 air and electrical supplies off and disconnect before beginning maintenance. Failure to comply with this warning could result in severe personal injury or equipment damage.

Cleaning

Note – Never attempt to remove dirt 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

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

Figure 4-1 illustrates the areas of the case sealer that require lubrication. Lubricate points indicated by arrows (➡) with SAE #30 non-detergent oil and points indicated by arrows (⇨) with a small amount of multi-purpose 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.

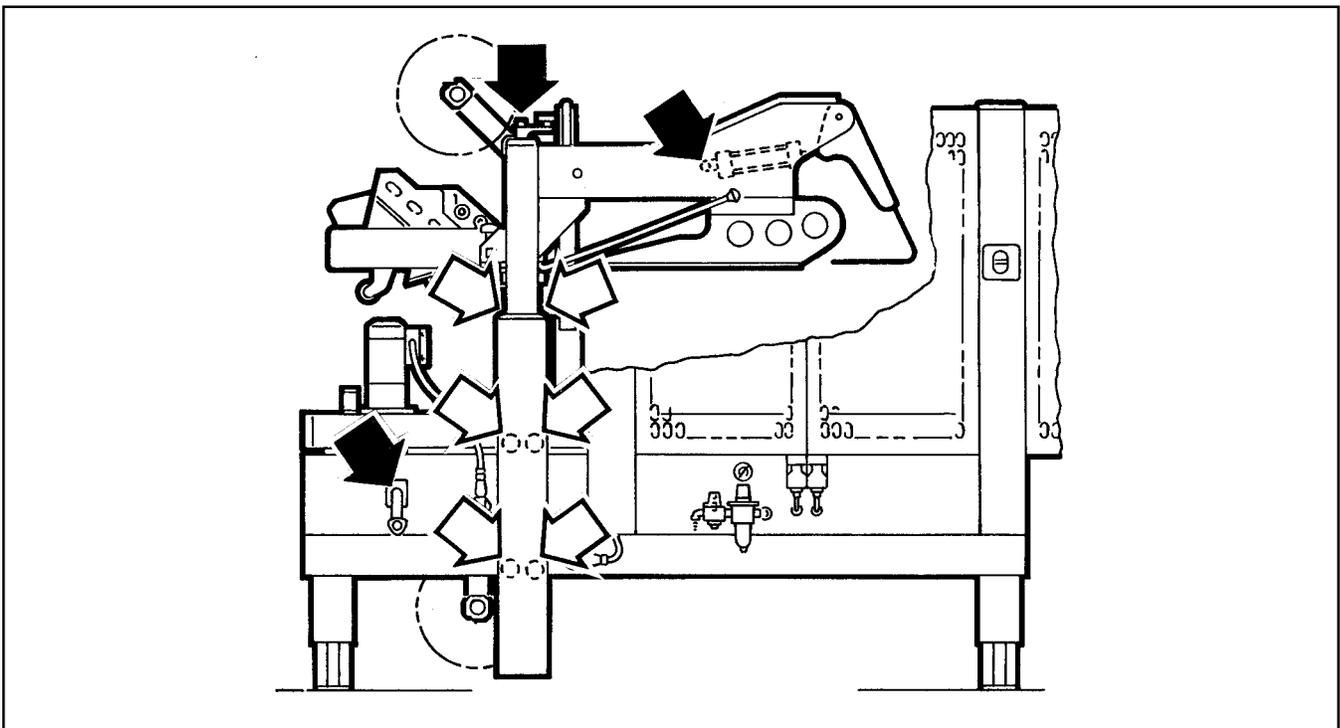


Figure 4-1 – Lubrication Points, Frame

Maintenance (Continued)



WARNING – Turn air and electrical supplies off and disconnect before beginning maintenance. Failure to comply with this warning could result in severe personal injury or equipment damage.

Drive Belt Replacement/Tension Adjustment

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

REPLACEMENT – STEPS 1-11

TENSION ADJUSTMENT – STEPS 1, 2, 4-6, 10 & 11

Figure 4-2

1. Raise upper tapping head to its fully raised position.
2. Disconnect motor plug (A).
3. Remove and retain the six screws (B) and side cover (C).
4. Remove and retain screws (D), cap washers (E) and spacers (F) from the front and rear arm assembly pivots.
5. Lift belt assembly (G) up and off arm assembly pivots.

Note – Keep motor in vertical position to prevent gear oil from leaking out of motor.

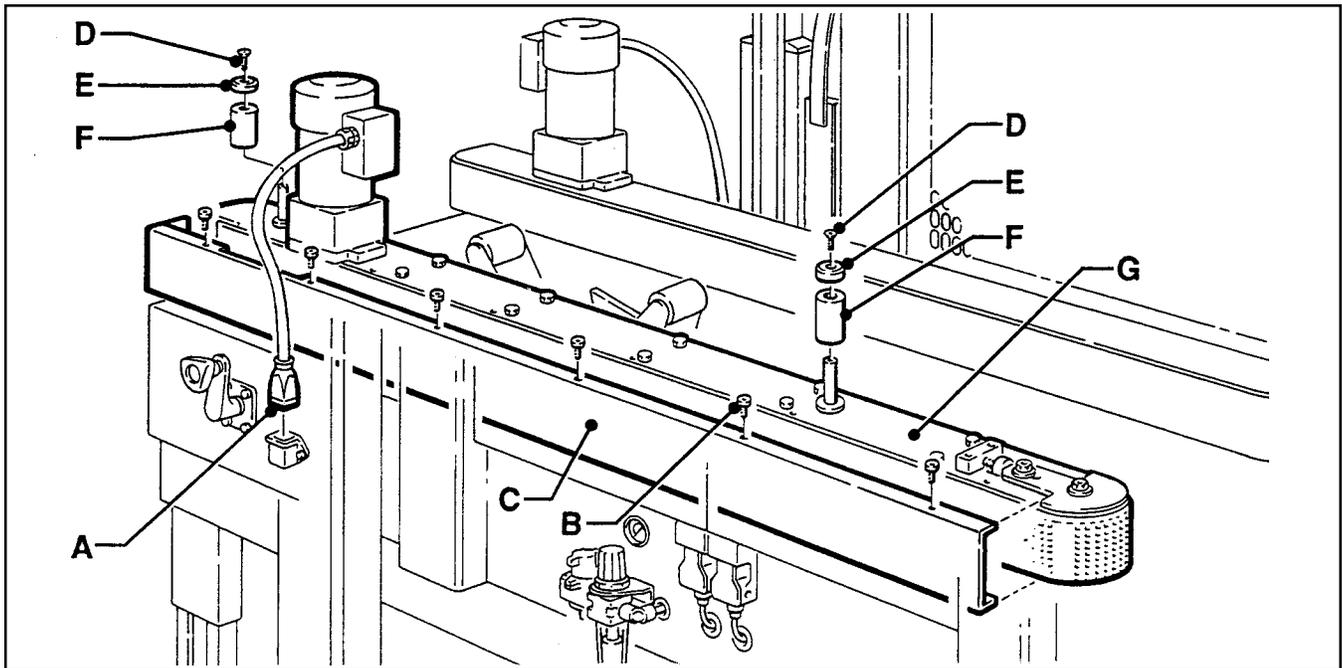


Figure 4-2 – Drive Belt Replacement

Figure 4-3

6. Loosen, but do not remove lock nuts (H) on both the upper and lower belt tension assemblies.
7. Turn belt adjustment screws (J) clockwise to end of adjustment on both upper and lower tension assemblies.
8. Locate belt lacing (joint) by turning belt manually. Remove splicing with pliers. Remove and discard belt.

Maintenance (Continued)

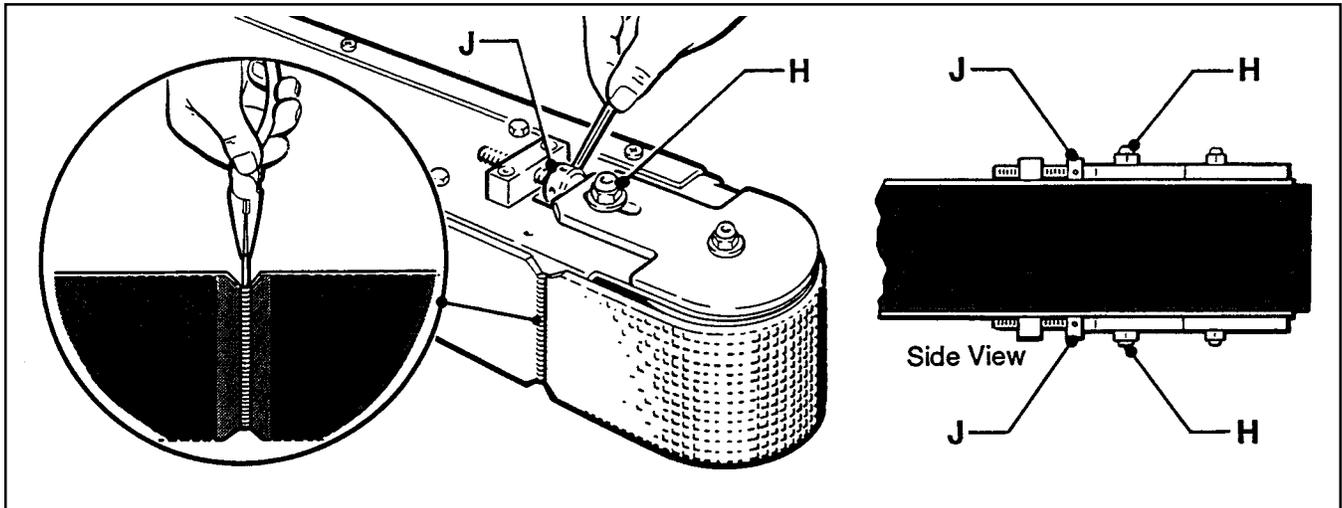


Figure 4-3 – Drive Belt Replacement/Tension Adjustment

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

Install new belt around drive rollers and insert splicing pin. Pin must not extend beyond edge of belt.

10. Set drive belt tension – turn adjustment screws (J) equally on both upper and lower tension assemblies. Turn screws clockwise to reduce belt tension, counterclockwise to increase tension.

Use force gauge to pull belt outward one inch [25 mm] at midspan, as shown in Figure 4-4, with a moderate pulling force of 7 lbs. [3.5 kg]. Tighten lock nuts (H) on both tension assemblies to secure tension setting.

11. Assembly is reverse of disassembly.

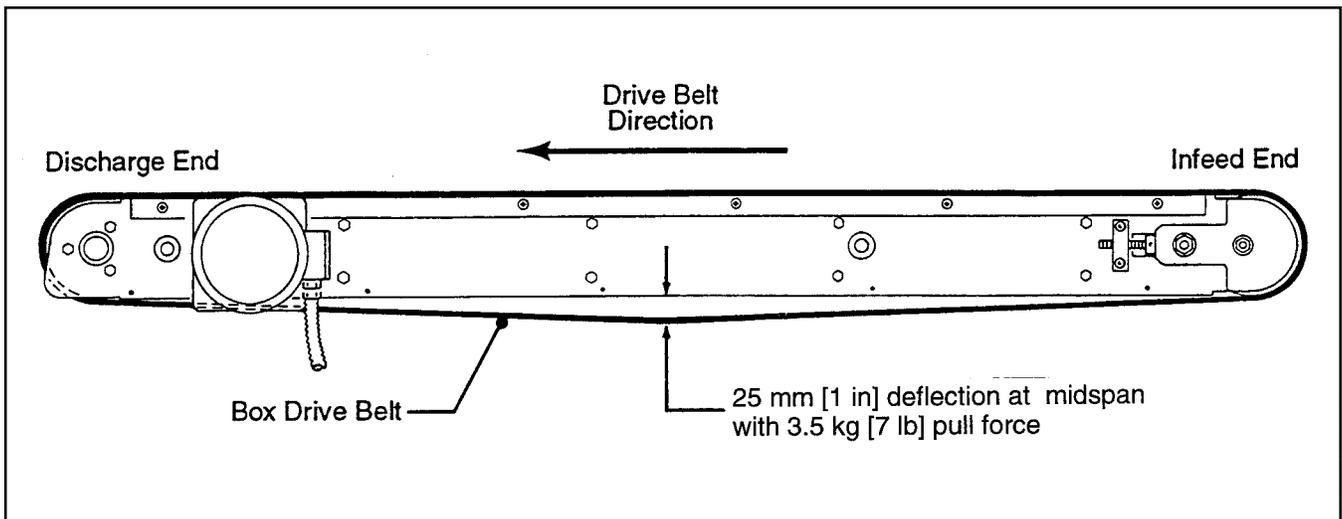


Figure 4-4 – Drive Belt Tension Adjustment (Top View)

Maintenance (Continued)



WARNING – Turn air and electrical supplies off and disconnect before beginning maintenance. Failure to comply with this warning could result in severe personal injury or equipment damage.

Air Line Filter – Figure 4-5

Periodically check the air line filter to drain water and clean as necessary. Do not allow water to go above the filter element.

Circuit Breaker

The case sealer is equipped with a circuit breaker which trips if the motors are overloaded. Located inside the electrical control box on the side of the machine, the circuit breaker has been pre-set at 2.2 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.

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. Wait two minutes.
6. Press machine "On" button, on the side guard, to resume case sealing.

Knife Replacement, Taping Head

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

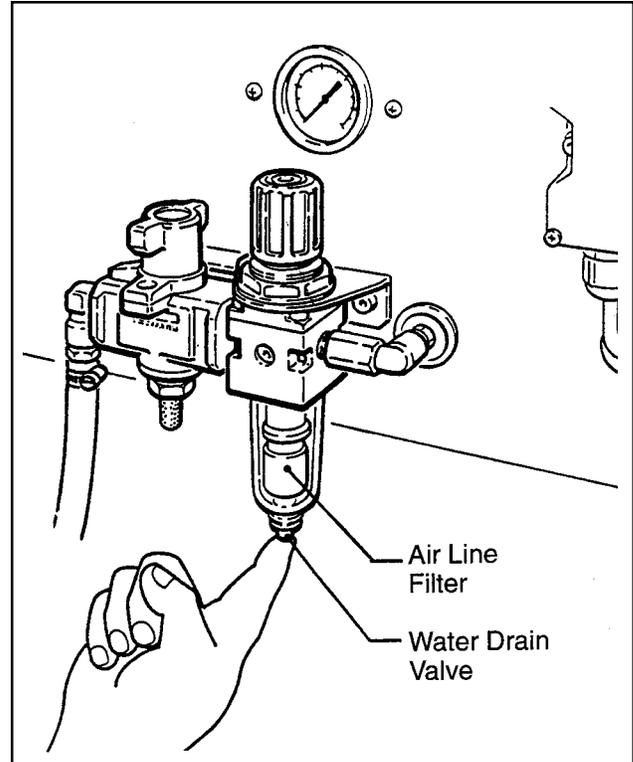


Figure 4-5 – Air Line Filter

Adjustments

WARNING – Turn air and electrical supplies off and disconnect before beginning adjustments. Failure to comply with this warning could result in severe personal injury or equipment damage.

Gate Operation

Figure 5-1

- A** – Permanent gate cam
- B** – Removable gate cam
- C** – Kicker cam

The 800af is shipped with both gate cams **A** and **B** installed. With both cams the entire range of box lengths can be run (150-760 mm [6-30 inches]). However if only boxes longer than 305 mm [12 inches] will be run, cam **B** can be removed to increase the production rate. Refer to the box rate chart in specification section.

Drive Belt Tension

Belt tension must be adequate to positively move boxes through the machine and belts should run fully on the surface of the pulleys at each end of the frame. The idler pulleys on the infeed end are positioned by tension adjustment screws. To adjust tension, see "Maintenance – Drive Belt Replacement/Tension Adjustment", page 26.

Taping Head Adjustments – Refer to Section II

TAPE WEB ALIGNMENT – Section II, Page 11

TAPE DRUM FRICTION BRAKE – Section II, Page 11

APPLYING MECHANISM SPRING – Section II, Page 12

ONE-WAY TENSION ROLLER – Section II, Page 12

TAPE LEG LENGTH ADJUSTMENT – Section II, Page 13

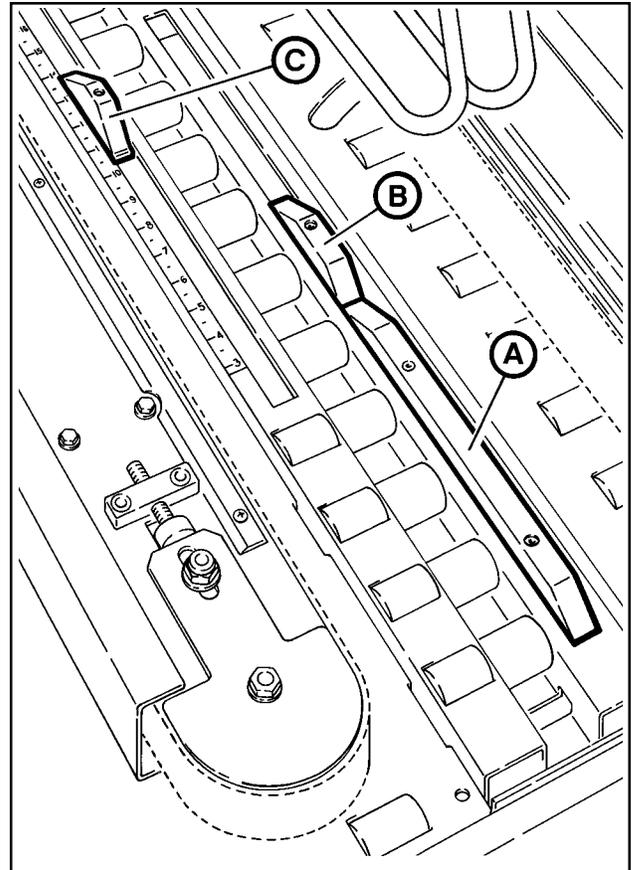


Figure 5-1 – Gate Cams

Adjustments (Continued)



WARNING – Turn air and electrical supplies off and disconnect before beginning adjustments. Failure to comply with this warning could result in severe personal injury or equipment damage.

Upper Taping Head Leveling

If the upper taping head is not horizontal, it can be leveled by adjusting the self-locking nut.

1. Loosen the five bolts on each side of crossbar shown in Figure 5-2A.
2. Remove access cover as shown in Figure 5-2B and (using M13 hex key wrench) tighten or loosen M8 self-locking nut until upper head is level.
3. Take measurement from exit end of upper head assembly and front of flap folding ski to machine bed, as shown in Figure 5-2. Upper assembly must be level ± 1.5 mm [$\pm 1/16$ inch].
4. Retighten five bolts on each side of crossbar to secure adjustment.

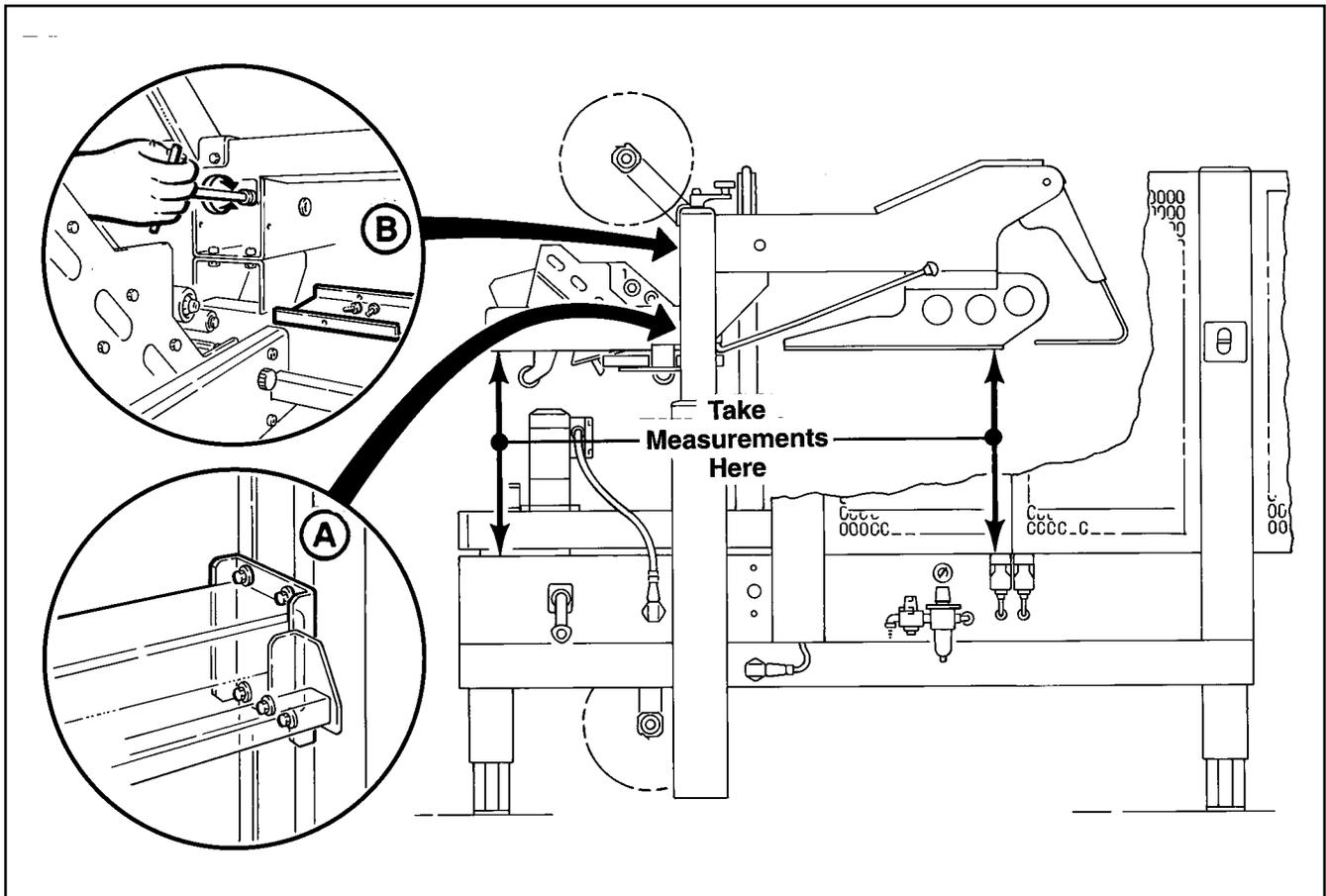


Figure 5-2 – Upper Taping Head Leveling

Adjustments (Continued)

WARNING – Turn air and electrical supplies off and disconnect before beginning adjustments. Failure to comply with this warning could result in severe personal injury or equipment damage.

Gate Pressure Regulator

Figure 5-3

The gate air pressure is controlled by a regulator mounted under the machine frame. This provides adjustment of the gate lifting force. When light weight boxes are being run the gate pressure can be reduced to minimize lifting of the box.

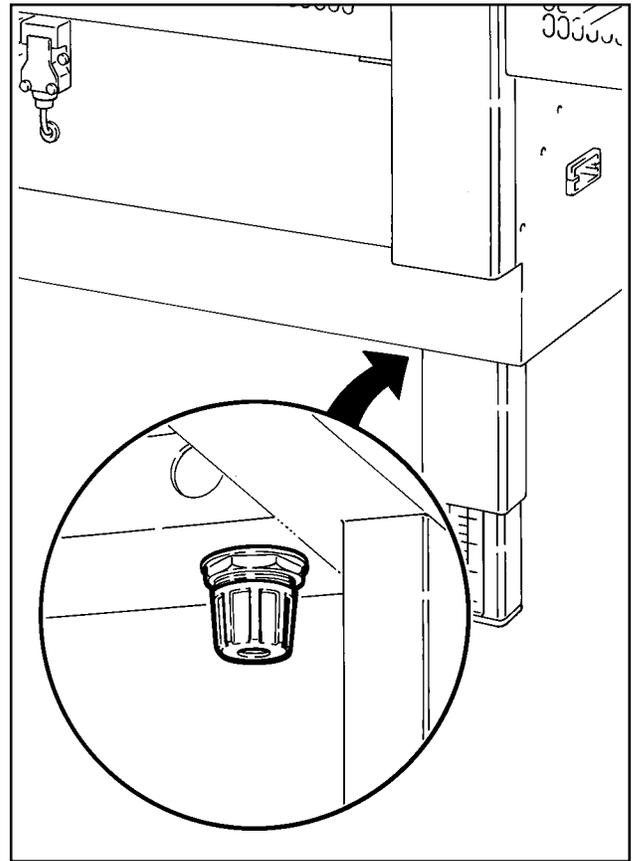


Figure 5-3 – Gate Pressure Regulator

Gate Stroke Setting

Figure 5-4

The machine is initially set at the maximum gate lift of 25 mm [1 inch]. However this can be reduced if needed for special situations. To do this, remove the center roller section and turn the stop nuts clockwise until the desired lift is achieved.

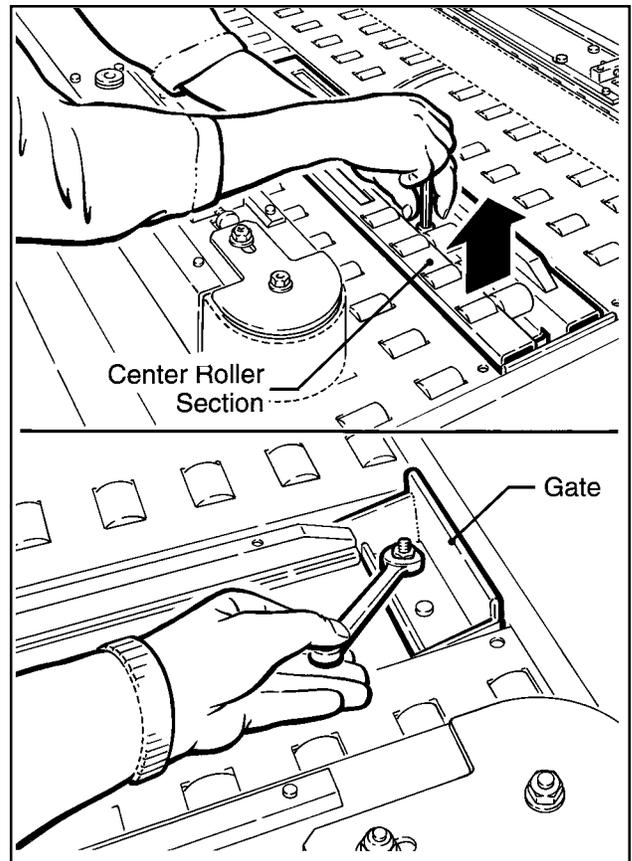


Figure 5-4 – Gate Stroke Setting

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Special Set-Up Procedure

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

Changing Drive Belt Height

The drive belt assemblies can be raised 50 mm [2 inches] to provide better conveying of tall boxes. **This change increase the minimum box height that can be taped to 190 mm [7-1/4 inches].**

DISASSEMBLY – Figure 6-1

1. Using the height adjustment crank, raise the upper taping head to its fully raised position.
2. Remove and retain the M6 x 16 flat head cap screw (A), special washer (B) and spacer (C) from the front and rear arm assembly pivots.
3. Lift drive belt assembly (D) up off the arm assembly pivots.

Note – Keep motor in vertical position to prevent gear oil from leaking out of motor.

REASSEMBLY – Figure 6-2

4. Reassemble the spacer (C) onto the front and rear arm assembly pivots first.
5. Install the belt drive assembly (D) onto the pivots and secure with special washers (B) and M6 x 16 flat head cap screws (A).

Note – Both drive belt assemblies must be installed at the same operating height.

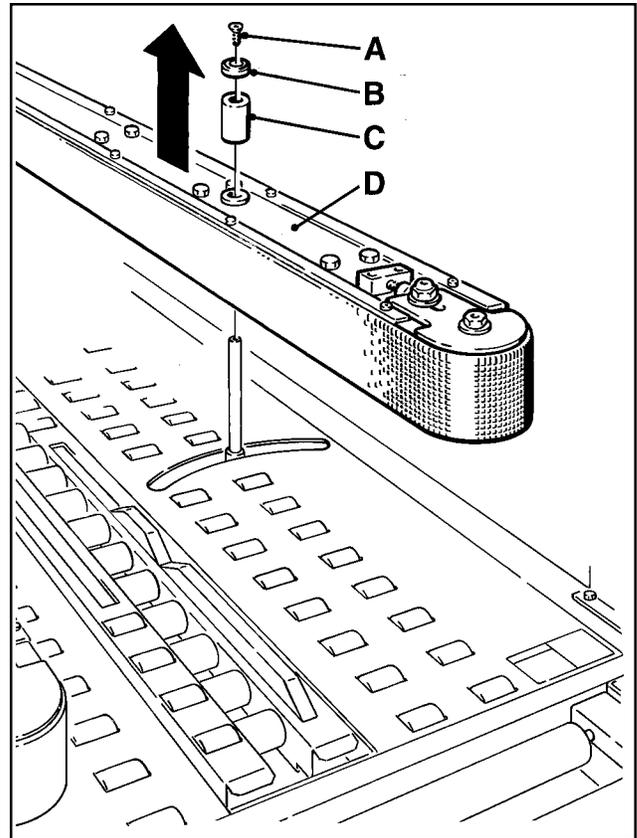


Figure 6-1 – Drive Belt Height, Disassembly

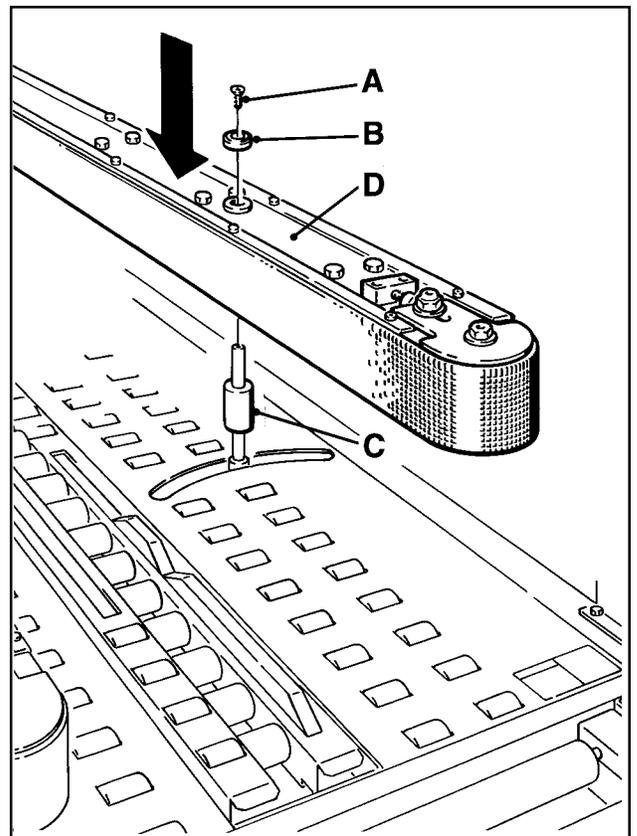


Figure 6-2 – Drive Belt Height, Reassembly

Special Set-Up Procedure (Continued)

Changing the Tape Leg Length (from 70 to 50 mm [2-3/4 to 2 inches])

The following changes to the case sealer frame and upper/lower taping heads will allow the taping of boxes 95 mm [3-3/4 inch] minimum height with box widths greater than 195 mm [7-3/4 inch].

CASE SEALER FRAME

1. Crank upper taping head frame up high enough to allow clearance for removal of lower taping.
2. Remove the stop bracket (Figure 6-3C) from normal position "A" and fasten in lower position "A-A". Relocate stop brackets on both columns.

TAPING HEADS

WARNING – Use care when working near tape cut-off knife on taping heads as knife is extremely sharp and could cause severe injury

1. Remove tape rolls from both upper and lower taping heads.
2. Loosen, but do not remove, the two retaining screws that secure the upper taping head. See Figure 6-3A. Slide the head forward and lift straight up to remove it from case sealer.

CAUTION – Taping heads weigh approximately 7.2 kg [16 lbs]. Use proper body mechanics when lifting or holding taping head.

3. Lift the lower taping head, shown in Figure 6-3B, straight up to remove it from the machine bed.
4. Refer to Section II, Adjustments – Changing Tape Leg Length" page 13 for taping head set-up.
5. Replace taping heads in case sealer, reverse of disassembly.

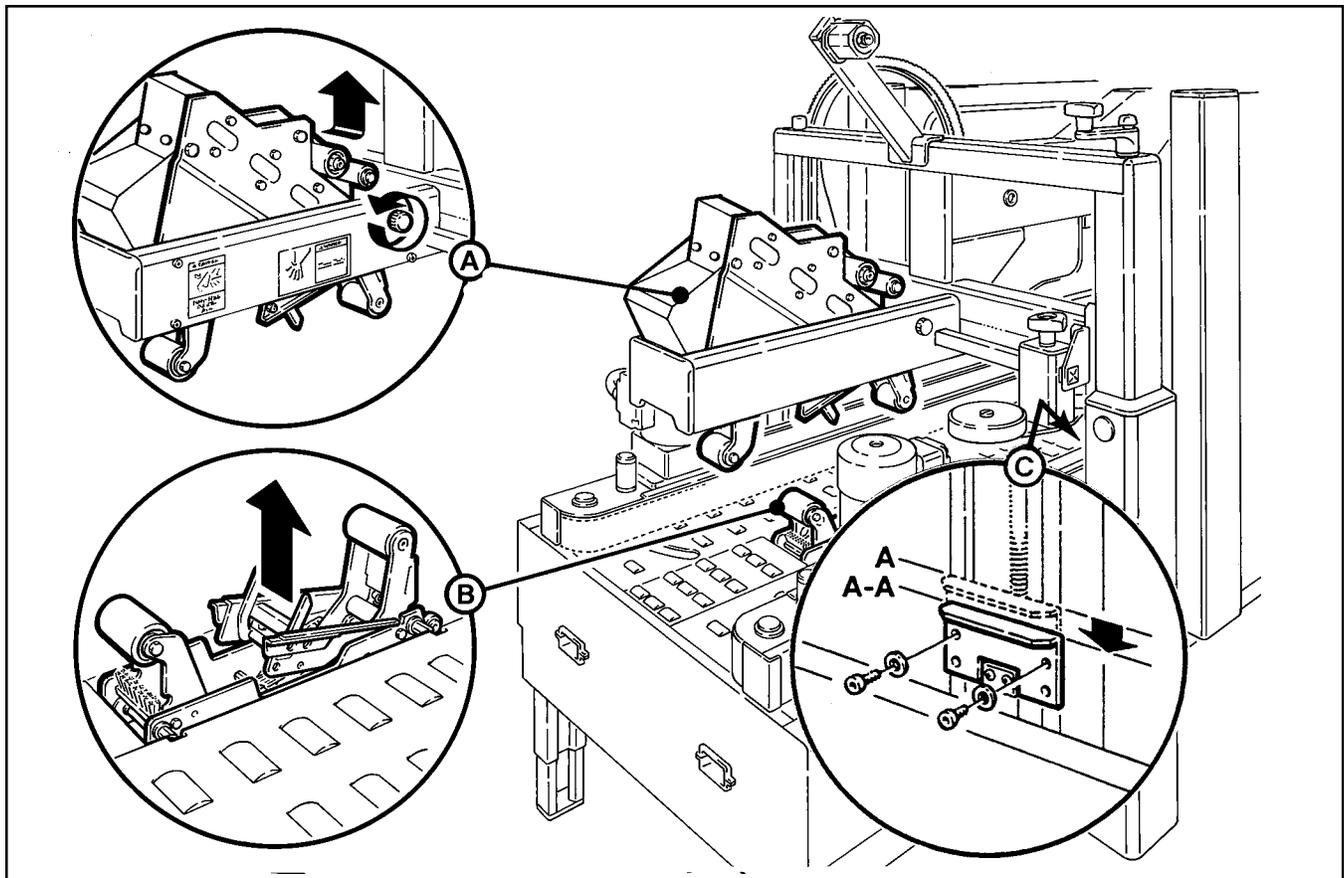


Figure 6-3 – Removing Taping Heads from Case Sealer

Special Set-Up Procedure (Continued)

Outer Column Re-Positioning (Refer to Figure 6-4)

Moving the outer columns up one set of mounting holes increases the maximum box size handled by the case sealer from 620 mm [24-1/2 inches] to 725 mm [28-1/2 inches].



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

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

1. Crank side drive belts to full open position.
2. Crank upper taping head frame assembly up approximately 330 mm [13 inches] from machine bed.
3. Place solid blocks approximately 305 mm [12 inches] high beneath upper taping head frame at rear of taping head and under front flap folding ski (Figure 6-4A).

Note – Blocks (front and rear) must be the same height in order to keep upper frame level.

4. Crank upper taping head frame down until weight of upper frame is fully on blocks.
5. Remove and retain six mounting screws in each outer column assembly (Figure 6-4B).



WARNING – A second person should assist with this part of set-up to hold (steady) upper frame until columns are re-positioned and column screws are installed and tightened.

6. Crank outer column up 100 mm [4 inches] and re-install six (6) screws in each column. Tighten screws.
7. Crank upper taping head up and remove blocks.
8. Check horizontal alignment of upper taping head frame and adjust as described in "Adjustments – Upper Taping Head Leveling", page 30.

Special Set-Up Procedure (Continued)

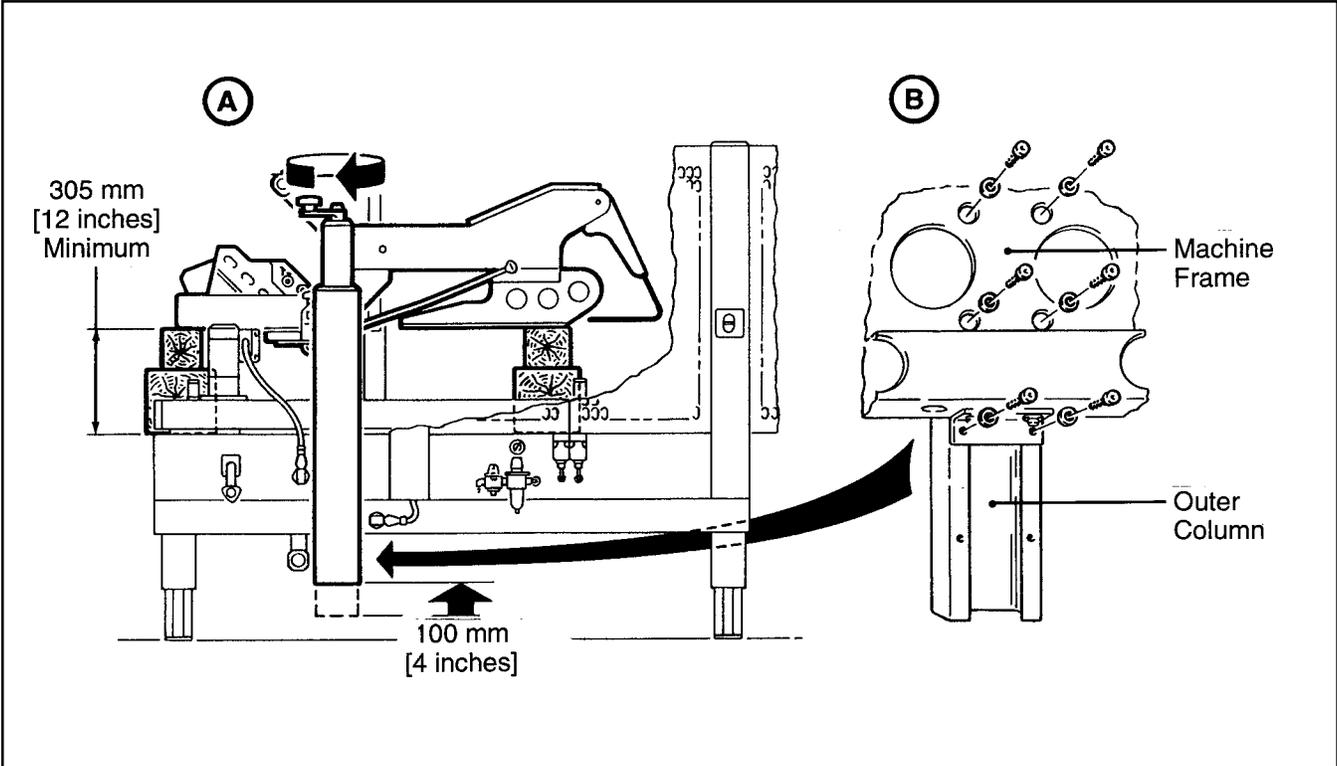


Figure 6-4 – Column Re-Positioning

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.

Note – Adjustment of the machine or taping heads are described in "Adjustments", Section I and II of this manual.

Troubleshooting Guide

Problem	Cause	Correction
Drive belts do not convey boxes	Worn drive belts	Replace drive belts
	Top taping head does not apply enough pressure	Adjust the box height adjustment with the crank
	Taping head applying spring holder missing	Replace spring holder
	Taping head applying spring set too high	Reduce spring pressure
Drive belts do not turn	Worn or missing friction rings	Replace friction rings
	Drive belt tension too low	Adjust belt tension
	Electrical disconnect	Check power and electrical plug
	Circuit breaker not at correct setting	Set to correct current value
	Motor not turning	Evaluate problem and correct
Drive belts break	Worn belt	Replace belt
Squeaking noise as boxes pass through machine	Dry compression bearings	Lubricate compression bearings
	Dry column bearings	Lubricate column bearings
Tape not centered on box seam	Centering guides not centered	Adjust centering guides
	Box flaps not of equal length	Check box specifications

(Continued)

Troubleshooting (Continued)

Troubleshooting Guide

Problem	Cause	Correction
Flap kicker kicks at wrong time	Kicker cam improperly set	Reposition kicker cam (see page 29)
	Air cylinder flow controls out of adjustment	Readjust flow controls
Gate does not raise to stop next box	Too much air pressure on gate cylinder lifts box off of gate cam	Reduce gate air pressure using regulator (see page 31)
	Incoming boxes not low enough and therefore not actuating cam	
Gate retracts too soon/kicker does not kick	The removable portion of the gate cam has been removed and boxes shorter than 12 inches are being run	Reinstall removable gate cam portion
Two boxes are taped together		

Pneumatic Diagram

⚠ WARNING – Turn off electrical power and air supply and disconnect power cord from electrical supply before beginning service. If power cord is not disconnected, personnel could be exposed to dangerous voltages. Severe injury or equipment damage could result.

Item	Parts Dwg. Ref. No.	Description	Item	Parts Dwg. Ref. No.	Description
1	3027-4	Exhaust Valve – Manual, SMC EVHS-4500, F02 x 116	10	3027-27	Valve – Power, 3-Way, Spring Return, Single Pilot, SMC V2A-5120-01
2	3027-2	Air Regulator/Filter – SMC EAW-2000	11	3027-44	Valve – Power, 3-Way, Double Pilot SMC EVFA-3230-02F
3	3027-9	Gauge – Air Pressure	12	3027-23	Valve – One Shot, Festo VLK-3-PK-3
4	3027-11	Solenoid Valve – Slow Start, Festo MFHE-3-1/4"	13	3027-31	Flow Control – SMC AS2000F-06
5	3027-49	Coil – Solenoid Valve, Festo MSFW 110V, 50/60 Hz	14	3027-36	Valve – Quick Exhaust, Festo SEU-1/8"
6	3027-15	Manifold – Festo FR-8-1/8"	15	3027-43	Flow Control – SMC EAS 2201F-02-08S
7	3027-39	Indicator – Air Pressure, SMC VR-3100-1	16	3027-34	Hinge Mount – SMC C-DN40
8	3027-24	Regulator – Gate, SMC EAR 111-F02-1	17	3027-32	Air Cylinder – Gate, SMC ECQ-2B-40-25
9	3027-20	Valve – Mechanical, Festo R-E-M5	18	3027-33	Ball Joint – SMC CQ2
			19	3027-41	Hinge Mount – SMC D40
			20	3027-40	Air Cylinder – Kicker, SMC SB40-125

NOTE: Component and reference number shown. Refer to parts list for part number.

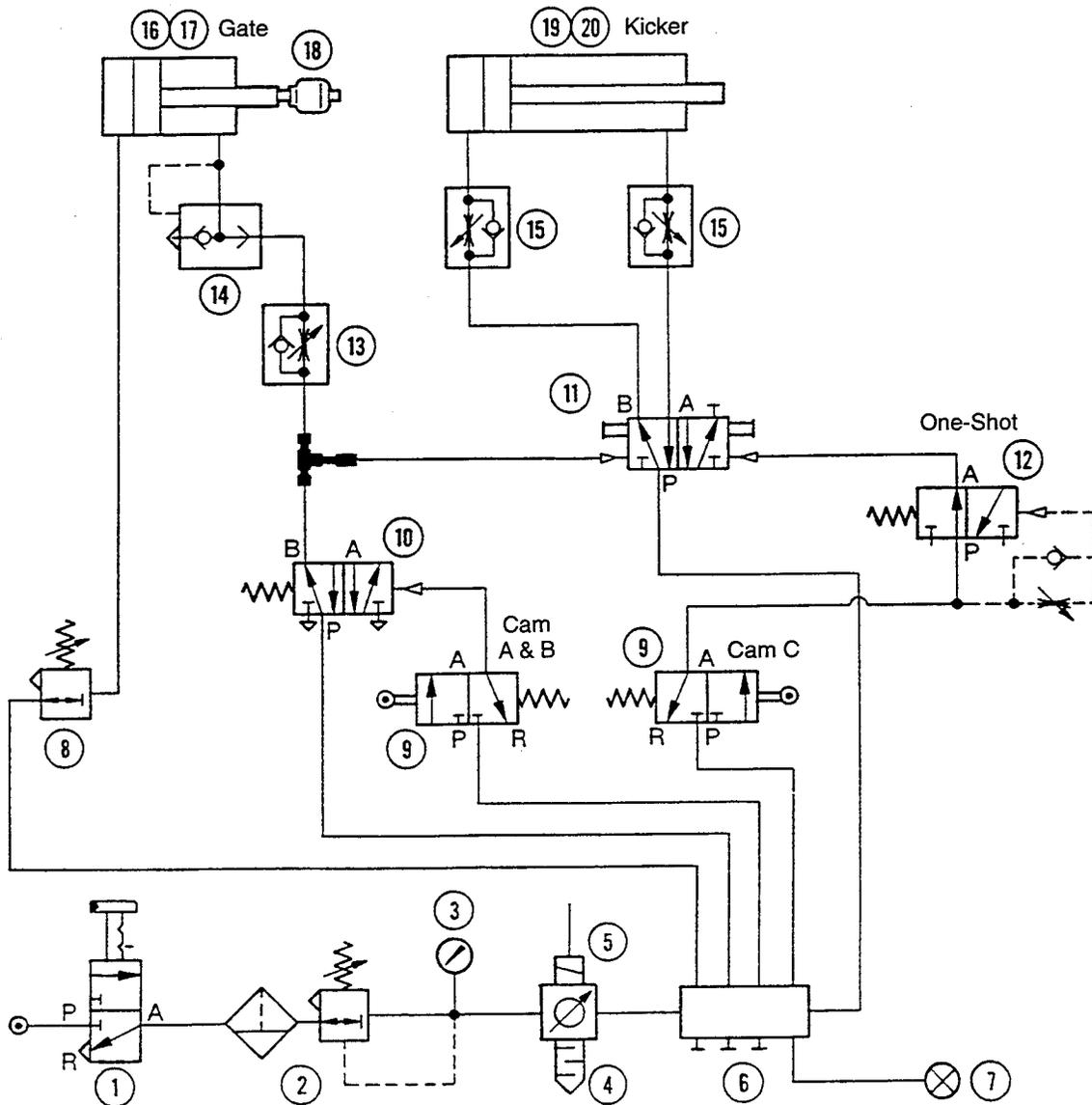


Figure 7-1 – Pneumatic Diagram

Electrical Diagram

⚠ WARNING – Turn off electrical power and air supply and disconnect power cord from electrical supply before beginning service. If power cord is not disconnected, personnel could be exposed to dangerous voltages. Severe injury or equipment damage could result.

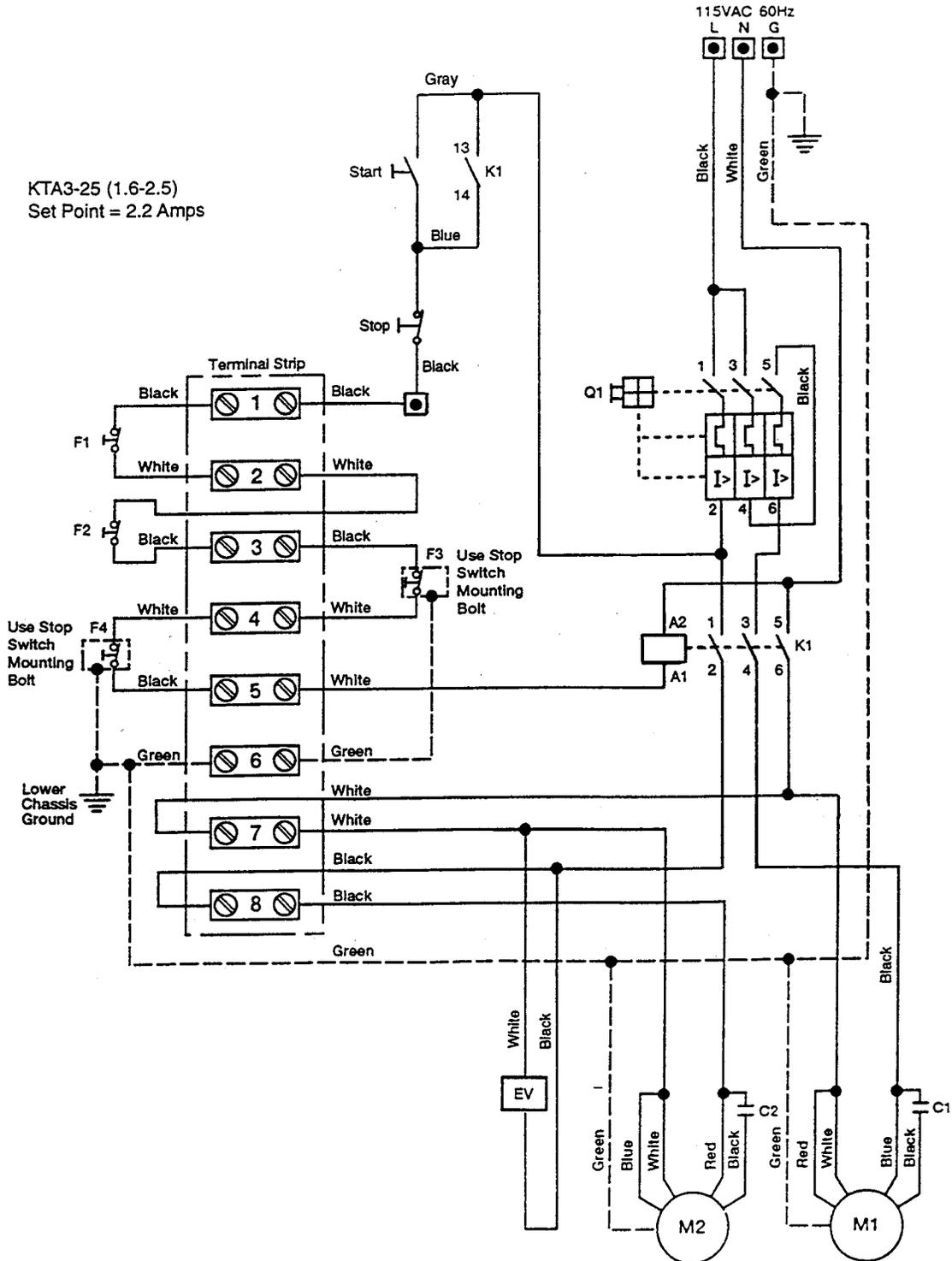
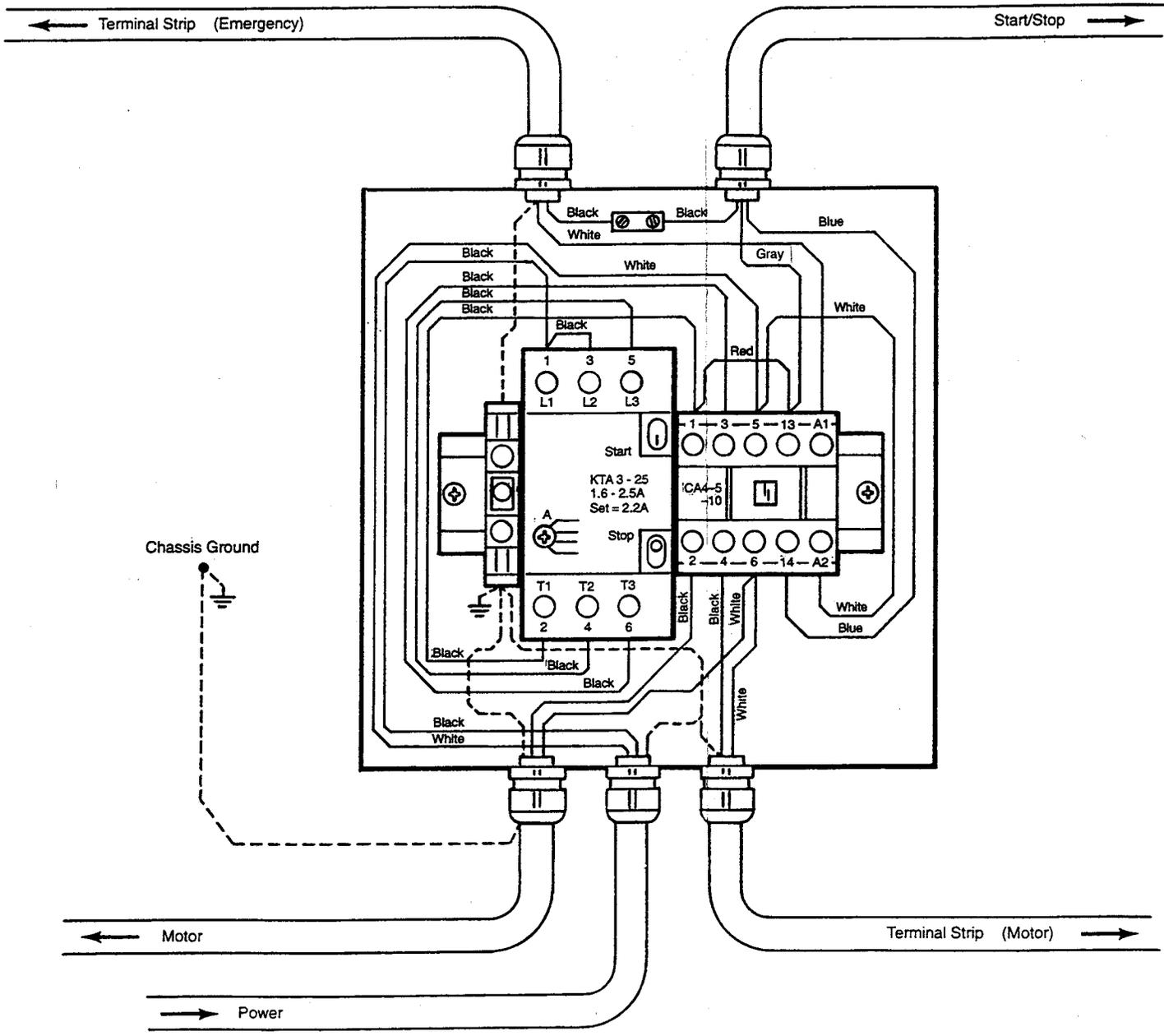


Figure 7-2 – Electrical Diagram



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Spare and Miscellaneous Parts

Spare Parts

The following parts are normal wear items and should be ordered and kept on hand as used.

Qty.	Ref. No.	Part Number	Description
2	4186-49 (Sec. I)	78-8076-4865-0	Belt – Drive W/Pin

In addition, a tool/spare parts kit supplied with the 800af3 Adjustable Case Sealer contains the following spare parts:

Qty.	Ref. No.	Part Number	Description
1	2950-10 (Sec. II)	78-8070-1274-1	Spring – Upper Extension (Silver)
1	2955-10 (Sec. II)	78-8070-1273-3	Spring – Lower Extension (Black)
2	2883-2 (Sec. II)	78-8017-9173-8	Knife – 65 mm/2.56 Inch
4	2883-12 (Sec. II)	78-8052-6602-6	Spring – Cutter

All the above listed parts can be ordered separately and when used should be ordered and kept on hand for spares.

Also see Section II, Page 17 for recommended taping head spare parts.

Label Kit

In the event that any labels are damaged or destroyed, they must be replaced to ensure operator safety. A label kit, part number 78-8113-6876-6 is available as a stock item. It contains all the safety labels used on the 800af Adjustable Case Sealer. Labels can also be purchased separately. See Parts Drawing/List, pages 86 and 87.

Tool and Parts Kit

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

Replacement Parts Ordering Information and Service

Refer to first page of this manual "Replacement Parts and Service Information" for parts ordering information.

Options/Accessories

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

Part Number	Option/Accessory
78-8069-3983-7	Caster Kit Attachment
78-8069-3926-6	Low Tape Sensor Kit
78-8114-0828-1	AccuGlide II STD 2 Inch Upper Taping Head, Type 39600
78-8114-0829-9	AccuGlide II STD 2 Inch Lower Taping Head, Type 39600
78-8079-5560-0	Tape Application Sensor Kit
78-8095-4854-4	2 Inch Tape Edge Fold Attachment – Top
78-8095-4855-1	2 Inch Tape Edge Fold Attachment – Bottom

Replacement Parts – Illustrations and Parts Lists

800af Adjustable Case Sealer, Type 39600 (2 Inch Width Taping Heads)

Frame Assemblies

1. Refer to **Frame Assemblies** Figure to find all the parts illustrations identified by **figure numbers**.
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. Refer to the first page of this instruction manual “**Replacement Parts and Service Information**” for replacement parts ordering information.

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

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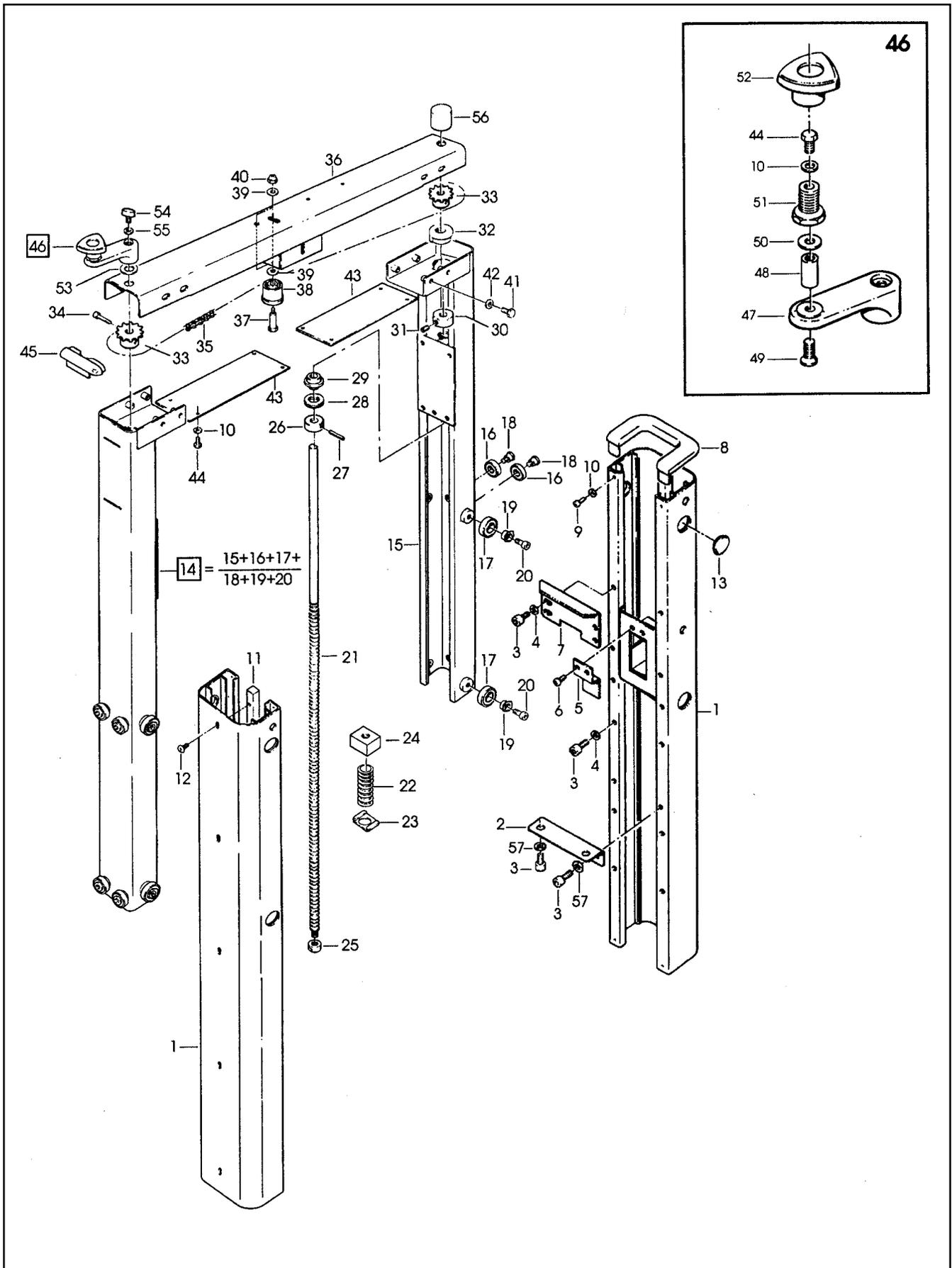


Figure 3019

Figure 3019

Ref. No.	3M Part No.	Description
3019-1	78-8076-4810-6	Column – Outer
3019-2	78-8060-8490-7	Plate – Column Mounting
3019-3	26-1003-7963-0	Screw – Soc Hd, M8 x 16
3019-4	78-8017-9318-9	Washer – Plain 8 mm
3019-5	78-8060-8493-1	Plate – Nut Stop
3019-6	78-8060-8087-1	Screw – M5 x 10
3019-7	78-8060-8492-3	Stop – Height
3019-8	78-8060-8491-5	Cap – Column
3019-9	26-1002-4955-1	Screw – Self Tap 8P x 13
3019-10	78-8005-5740-3	Washer – Plain 4 mm
3019-11	78-8076-4811-4	Guide – Outer Column
3019-12	78-8076-4503-7	Screw – M6 x 12
3019-13	78-8076-4812-2	Plug – Outer Column
3019-14	78-8076-4813-0	Column Assembly – Inner
3019-15	78-8076-4814-8	Column – Inner
3019-16	78-8059-5625-3	Bearing
3019-17	26-1000-4350-9	Bearing – 6002-2RS
3019-18	78-8076-4815-5	Screw – Bearing
3019-19	78-8076-4816-3	Bushing – Eccentric
3019-20	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
3019-21	78-8076-4817-1	Lead Screw
3019-22	78-8054-8997-4	Spring
3019-23	78-8054-8970-1	Bed Plate For Spring
3019-24	78-8091-0551-9	Nut – Lead Screw
3019-25	78-8054-8968-5	Special Nut
3019-26	78-8054-8585-7	Collar
3019-27	78-8054-8586-5	Pin
3019-28	78-8054-8584-0	Spacer
3019-29	78-8054-8583-2	Bushing
3019-30	78-8060-8497-2	Bushing – Lead Screw
3019-31	78-8059-5617-0	Set Screw – M6 x 8
3019-32	78-8060-8498-0	Bushing – Inner Column
3019-33	78-8060-8499-8	Sprocket – 3/8 Inch Z=13
3019-34	26-1003-7946-5	Screw – Soc Hd, M4 x 25
3019-35	78-8076-4818-9	Chain – 3/8 Inch Pitch 197 Pitch
3019-36	78-8076-4819-7	Crossmember – Chain
3019-37	78-8060-7878-4	Idler Screw
3019-38	78-8070-1503-3	Roller – Chain Tensioning
3019-39	78-8042-2919-9	Washer – Triple, M6
3019-40	26-1003-6916-9	Nut – Locking Plastic Insert M6
3019-41	26-1003-5829-5	Screw – Hex Hd. M6 x 12
3019-42	26-1000-0010-3	Washer – Flat M6
3019-43	78-8076-4820-5	Cover – Chain
3019-44	78-8010-7157-8	Screw – Hex Hd, M4 x 10
3019-45	78-8070-1505-8	Cap – Inner Column
3019-46	78-8076-4807-2	Crank Assembly
3019-47	78-8076-5422-9	Crank
3019-48	78-8070-1509-0	Shaft – Crank
3019-49	26-1005-5316-8	Screw – Flat Hd Hex Dr, M5 x 16
3019-50	78-8070-1510-8	Washer – Nylon, / 7 x 15 x 1
3019-51	78-8070-1511-6	Bushing
3019-52	78-8070-1512-4	Knob – VTR-B-M12
3019-53	78-8076-4800-7	Washer – Crank
3019-54	78-8076-4821-3	Key – Stop
3019-55	78-8076-4809-8	Washer – Crank
3019-56	78-8070-1506-6	Cover – Screw
3019-57	26-1004-5507-5	Washer – M8

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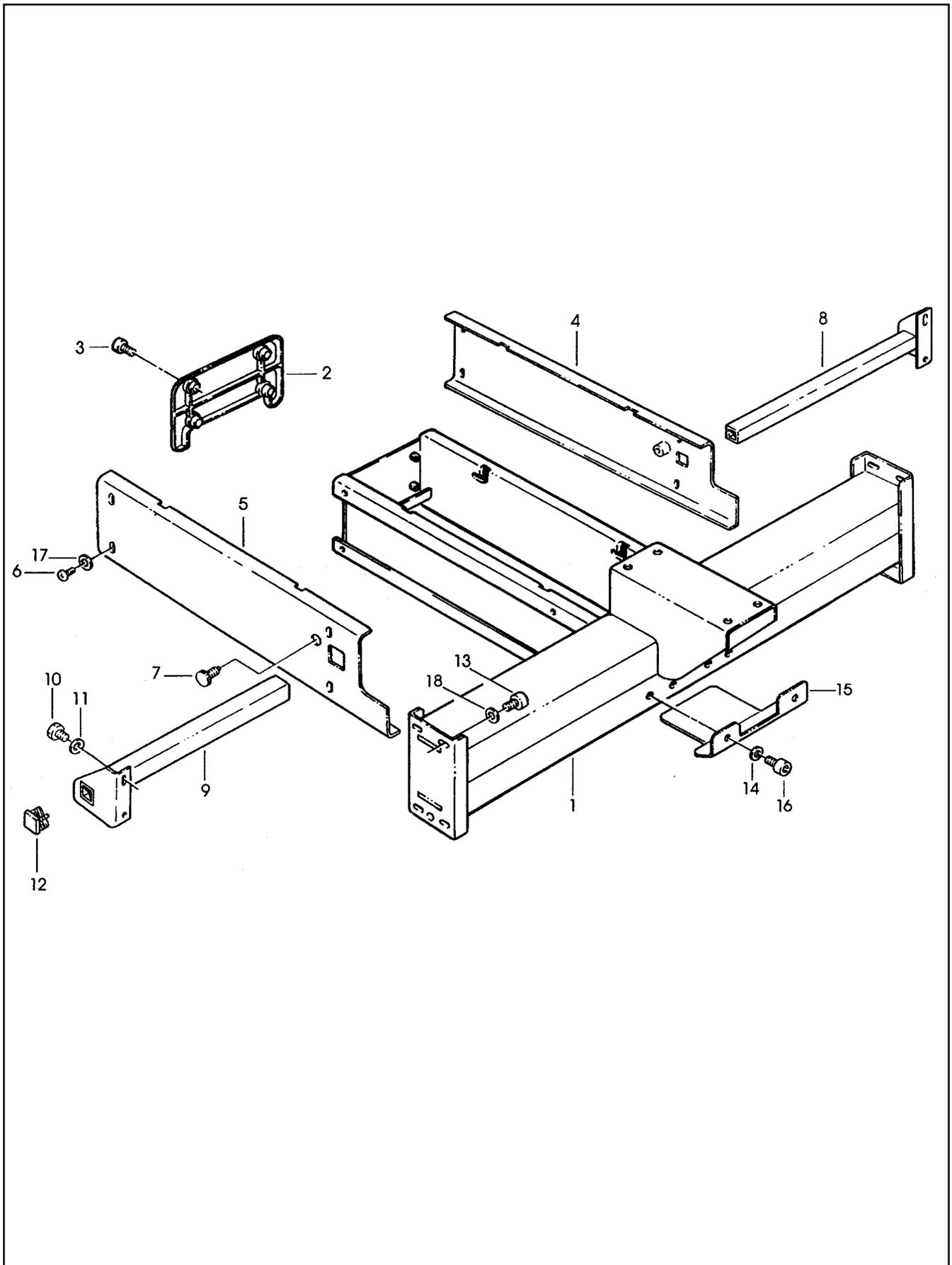


Figure 3020

Figure 3020

Ref. No.	3M Part No.	Description
3020-1	78-8076-4822-1	Support – Upper Head
3020-2	78-8076-4823-9	Cover – Rear
3020-3	26-1003-7951-5	Screw – Soc Hd Hex Soc, M5 x 20
3020-4	78-8113-6898-0	Frame Assembly – Upper, R/H (W/English Language Label)
3020-5	78-8113-6897-2	Frame Assembly – Upper, L/H (W/English Language Label)
3020-6	78-8060-8087-1	Screw – M5 x 10
3020-7	78-8070-1555-3	Block – Upper Head
3020-8	78-8076-4826-2	Support – Right Roller
3020-9	78-8076-4827-0	Support – Left Roller
3020-10	78-8032-0375-7	Screw – Hex Hd, M6 x 16
3020-11	78-8042-2919-9	Washer – Triple, M6
3020-12	78-8052-6652-1	Cap – End
3020-13	26-1003-7964-8	Screw – Soc Hd Hex Soc Dr, M8 x 20
3020-14	78-8017-9318-9	Washer – Plain 8 mm
3020-15	78-8114-4786-7	Slide
3020-16	26-1003-7963-0	Screw – Soc Hd, M8 x 16
3020-17	78-8100-1036-9	Washer

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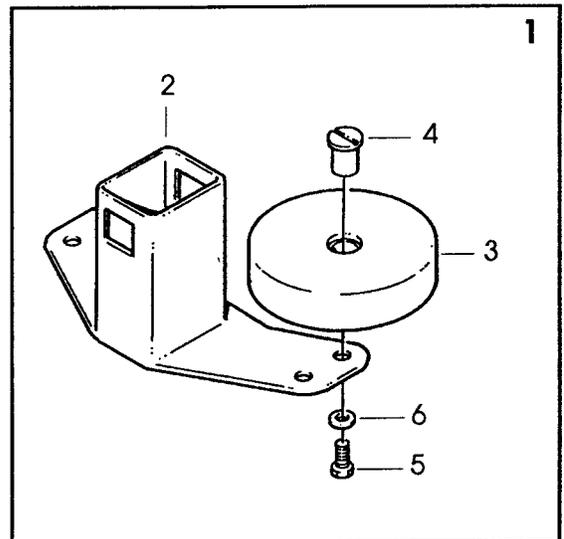
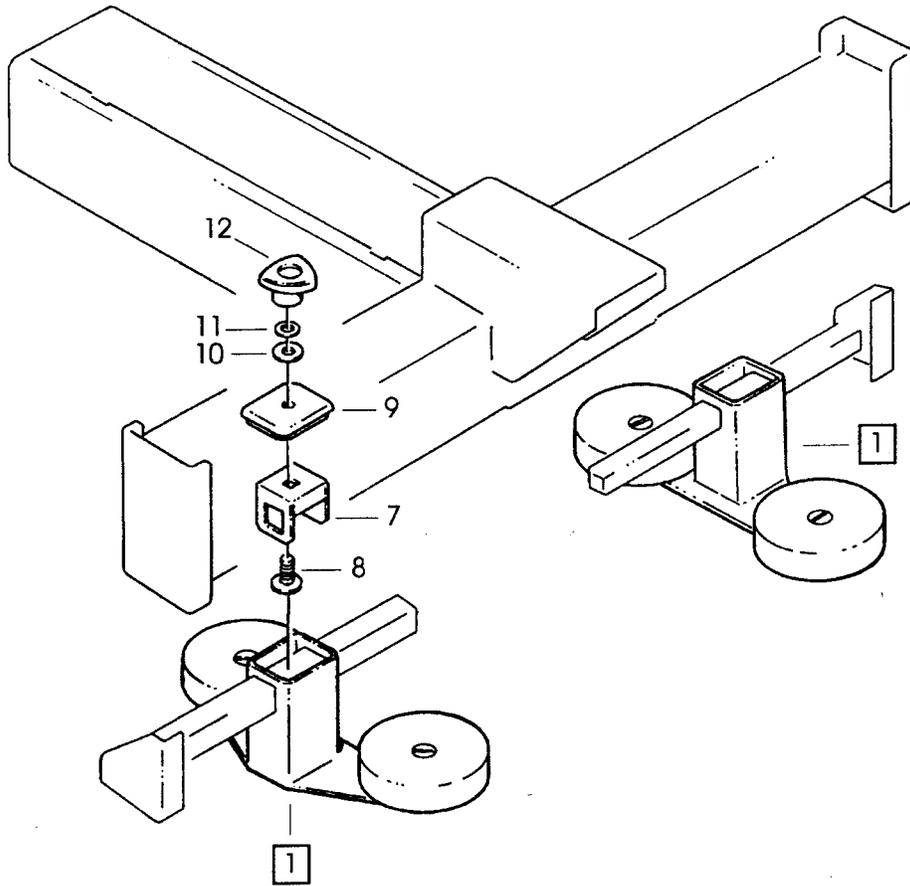


Figure 3021

Figure 3021

Ref. No.	3M Part No.	Description
3021-1	78-8100-0863-7	Compression Roller Assembly
3021-2	78-8113-6899-8	Compression Roller Support Assembly (W/English Language Label)
3021-3	78-8076-4628-2	Roller – Compression
3021-4	78-8076-4629-0	Shaft – Roller
3021-5	26-1003-5841-0	Screw – M8 x 16
3021-6	78-8017-9318-9	Washer – Plain 8 mm
3021-7	78-8076-4630-8	Plate – Tube, Roller
3021-8	78-8076-4631-6	Screw – M10 x 35
3021-9	78-8076-4632-4	Cap – Support
3021-10	78-8017-9074-8	Washer – Nylon 15 mm
3021-11	78-8052-6566-3	Washer – Friction
3021-12	78-8070-1549-6	Knob – VTR-B-M10

Figure 3025

Ref. No.	3M Part No.	Description
3205-1	78-8091-0660-8	Housing – Wire
3205-2	78-8076-4702-5	Grommet /28
3025-3	26-1003-7963-0	Screw – Soc Hd, M8 x 16
3025-4	78-8076-4872-6	Strap – Wire
3025-5	78-8010-7163-6	Screw – Hex Hd, M5 x 10
3025-6	78-8005-5741-1	Washer – Plain, M5
3025-7	78-8010-7417-6	Nut – Hex, M5
3025-8	78-8076-4873-4	Plate – Strap
3025-9	26-1003-7949-9	Screw – Soc Hd Hex Soc, M5 x 12
3025-10	78-8060-7758-8	Fairlead /20
3025-13	78-8060-8029-3	Clamp – 140X3,5
3025-14	78-8076-4641-5	Cover
3025-15	78-8076-4875-9	Screw – Hex Hd, M4 x 8 W/Ext.
3025-16	78-8076-4520-1	Union PG13 – Sleeve /16
3025-17	78-8076-5229-8	Sleeving – /16, 1180 mm

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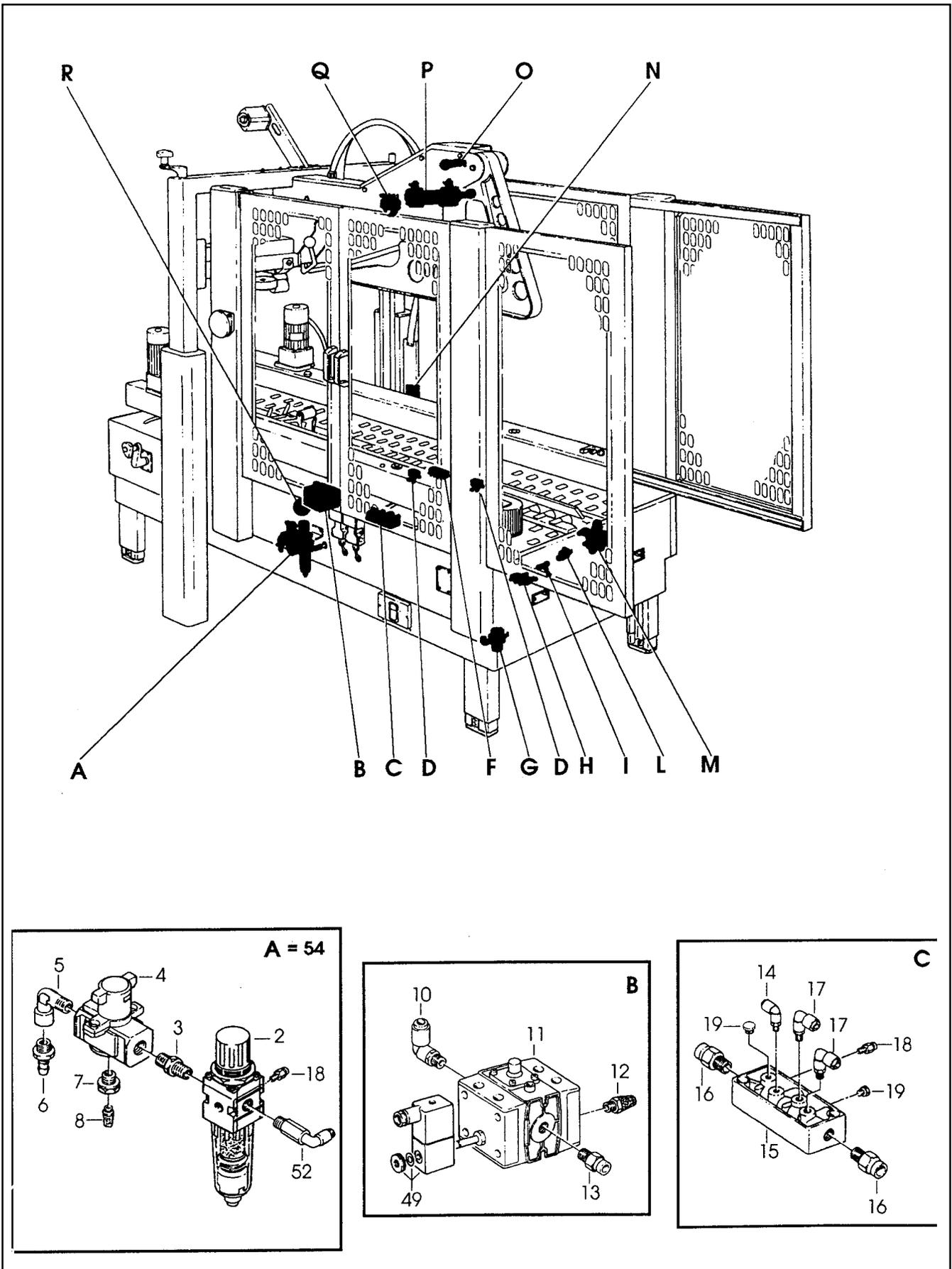


Figure 3027/1 of 2

Figure 3027 (Page 1 of 2)

Ref. No.	3M Part No.	Description
3027-2	78-8076-4668-8	Filter – Pressure Regulator
3027-3	78-8060-7899-0	Nipple – RA 012, 1/4 Inch - 1/4 Inch
3027-4	78-8091-0715-0	Valve – SMC EVHS-4500 FO2-X116
3027-5	78-8060-7900-6	Union – RA 022, 1/4 Inch - 1/4 Inch
3027-6	26-1005-6897-6	Hose Connector
3027-7	78-8076-4670-4	Reduction – 3/8 Inch - 1/8 Inch
3027-8	26-1005-6890-1	Muffler
3027-9	78-8054-8838-0	Gauge – Air
3027-10	78-8076-4885-8	Elbow – KQL08-02S
3027-11	78-8091-0419-9	Valve – MFHE-3-1/4 Inch
3027-12	78-8076-4886-6	Muffler – 1/4 Inch
3027-13	78-8076-4887-4	Union – Straight KQH08-02S
3027-14	78-8076-4888-2	Elbow – KQL04-01S
3027-15	78-8060-7651-5	Union – FR-8-1/8 Inch
3027-16	78-8076-4889-0	Union – Straight KHQ08-03S
3027-17	78-8076-4890-8	Elbow – KQL06-01S
3027-18	78-8076-4891-6	Union – Straight KQH04-01S
3027-19	78-8060-7690-3	Cap – B-1/8 Inch
3027-20	26-1005-6358-9	3-Way – 2 Position Valve
3027-21	78-8076-4892-4	Elbow – KQL04-M5
3027-23	78-8060-7656-4	Valve – VLK3-PK3
3027-24	78-8076-4894-0	Pressure Regulator – EAR111
3027-25	78-8076-4895-7	Elbow – KQL06-02S
3027-26	78-8076-4896-5	Union – Straight KQH06-02S
3027-27	78-8076-4677-9	Valve – V2A 5120-01
3027-28	78-8076-4897-3	Union – Straight KQH06-01S
3027-29	78-8076-4898-1	Union – KQT06-00

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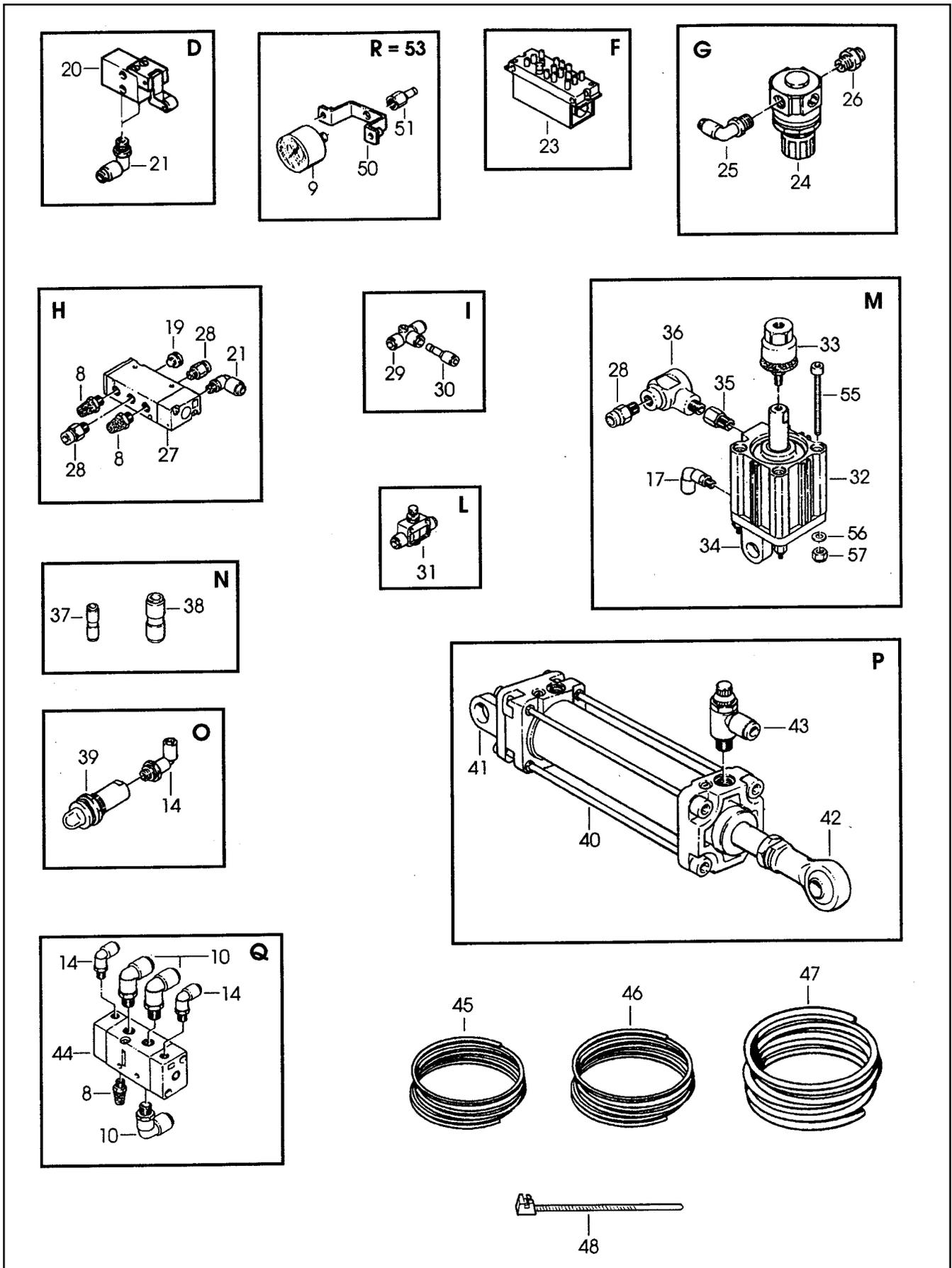


Figure 3027/2 of 2

Figure 3027 (Page 2 of 2)

Ref. No.	3M Part No.	Description
3027-30	78-8076-4899-9	Union – Straight KQR04-06
3027-31	78-8076-4900-5	Flow Regulator – AS2000F-06
3027-32	78-8076-4901-3	Air Cylinder – SMC ECQ 2B 40-25
3027-33	78-8076-4902-1	Ball Joint – CQ2
3027-34	78-8076-4903-9	Hinge – Cylinder /40
3027-35	78-8076-4904-7	Extension
3027-36	78-8013-9935-9	Valve – Quick Exhaust
3027-37	78-8076-4905-4	Union – KQH04-00
3027-38	78-8076-4906-2	Union – KQH08-00
3027-39	78-8076-4665-4	Indicator – Visual
3027-40	78-8076-4907-0	Air Cylinder – C92SB40-125
3027-41	78-8076-4908-8	Hinge
3027-42	78-8057-5747-9	Mount – Cylinder Rod End
3027-43	78-8076-4909-6	Flow Regulator – EAS2200F02-085
3027-44	78-8076-4910-4	Valve – EVFA 3230-02F
3027-45	78-8060-8033-5	Tubing – D4/3
3027-46	78-8060-8034-3	Tubing – D6/4
3027-47	78-8076-4911-2	Tubing – D8X6, 5MT
3027-48	78-8076-5228-0	Clamp – 95X2.4
3027-49	78-8091-0420-7	Coil – Magnetic, MSFW 110V, 50/60HZ
3027-50	78-8076-4535-9	Bracket
3027-51	78-8076-4672-0	Union – Straight, Female
3027-52	78-8091-0422-3	Elbow – KQW08-02S
3027-53	78-8091-0423-1	Gauge – W/Support
3027-54	78-8091-0424-9	Filter/Regulator Assembly
3027-55	78-8060-7582-2	Screw – Soc Hd Hex Soc, M5 x 70
3027-56	78-8005-5741-1	Washer – Plain, M5
3027-57	26-1005-6859-6	Nut – Self-Locking, M5

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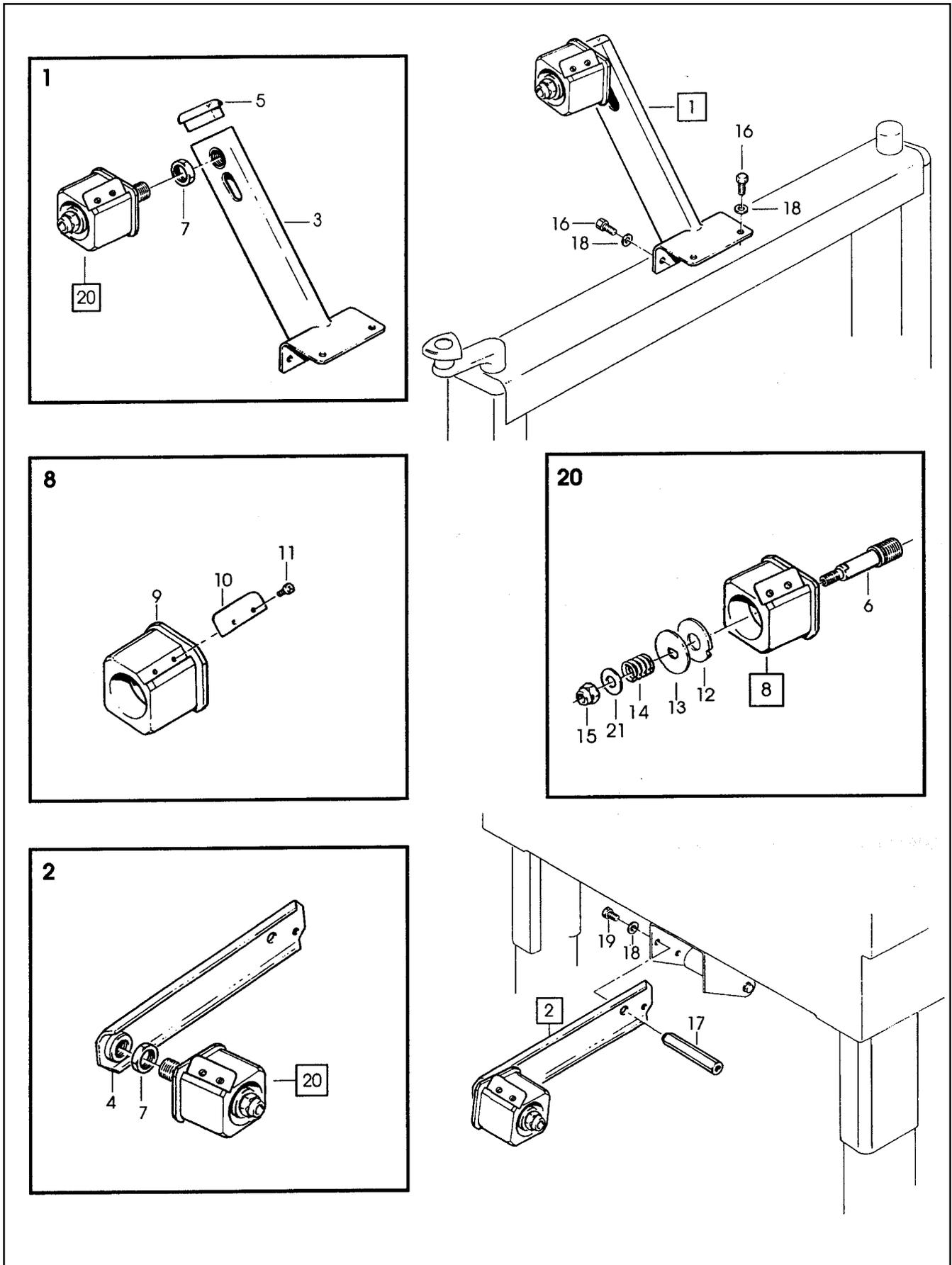


Figure 3182

Figure 3182

Ref. No.	3M Part No.	Description
3182-1	78-8070-1564-5	Tape Drum Bracket Assembly
3182-2	78-8070-1565-2	Tape Drum Bracket Assembly
3182-3	78-8070-1566-0	Bracket – Tape Drum
3182-4	78-8070-1395-4	Bracket – Bushing Assembly
3182-5	78-8070-1568-6	Cap – Bracket
3182-6	78-8076-4519-3	Shaft – Tape Drum
3182-7	78-8017-9169-6	Nut – M18 x 1
3182-8	78-8070-1569-4	Tape Drum Assembly
3182-9	78-8052-6749-5	Tape Drum
3182-10	78-8052-6286-6	Leaf Spring
3182-11	26-1002-5753-9	Screw – Self-Tapping
3182-12	78-8060-8172-1	Washer – Friction
3182-13	78-8052-6271-0	Washer – Tape Drum
3182-14	78-8100-1048-4	Spring – Core Holder
3182-15	78-8017-9077-1	Nut – Self-Locking, M10 x 1
3182-16	78-8032-0375-7	Screw – Hex Hd, M6 x 16
3182-17	78-8076-4742-1	Spacer – Tape Drum Bracket
3182-18	26-1000-0010-3	Washer – Flat M6
3182-19	78-8010-7169-3	Screw – Hex Hd, M6 x 12
3182-20	78-8060-8474-1	Tape Drum Assembly – Complete
3182-21	78-8052-6566-3	Washer – Friction

800af Adjustable Case Sealer

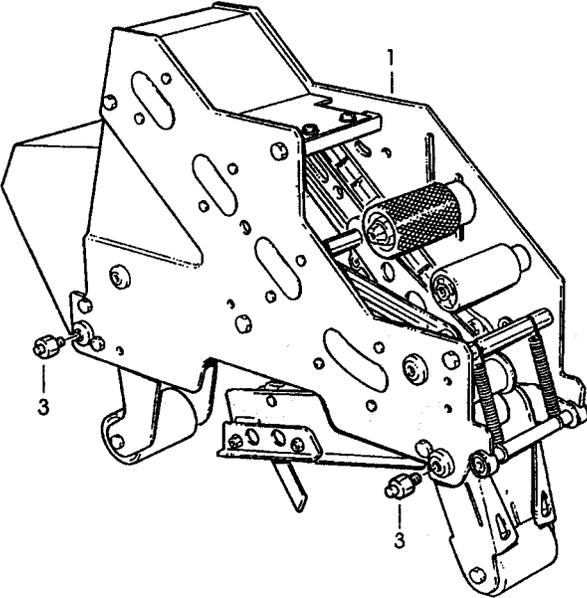


Figure 3183

Figure 3183

Ref. No.	3M Part No.	Description
3183-1	78-8114-0828-1	AccuGlide II, Upper, 2 Inch – Type 39600
3183-3	78-8076-4991-4	Spacer

Note – See Section II of this manual for taping head parts.

800af Adjustable Case Sealer

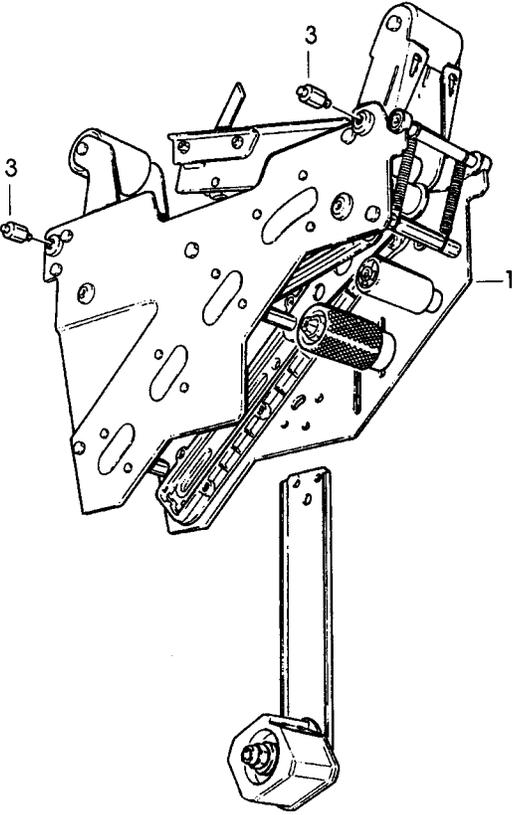


Figure 3184

Figure 3184

Ref. No.	3M Part No.	Description
3184-1	78-8114-0829-9	AccuGlide II, Lower, 2 Inch – Type 39600
3184-3	78-8060-8460-0	Stud – 2 Inch Bottom Hd Mount

Note – See Section II of this manual for taping head parts.

800af Adjustable Case Sealer

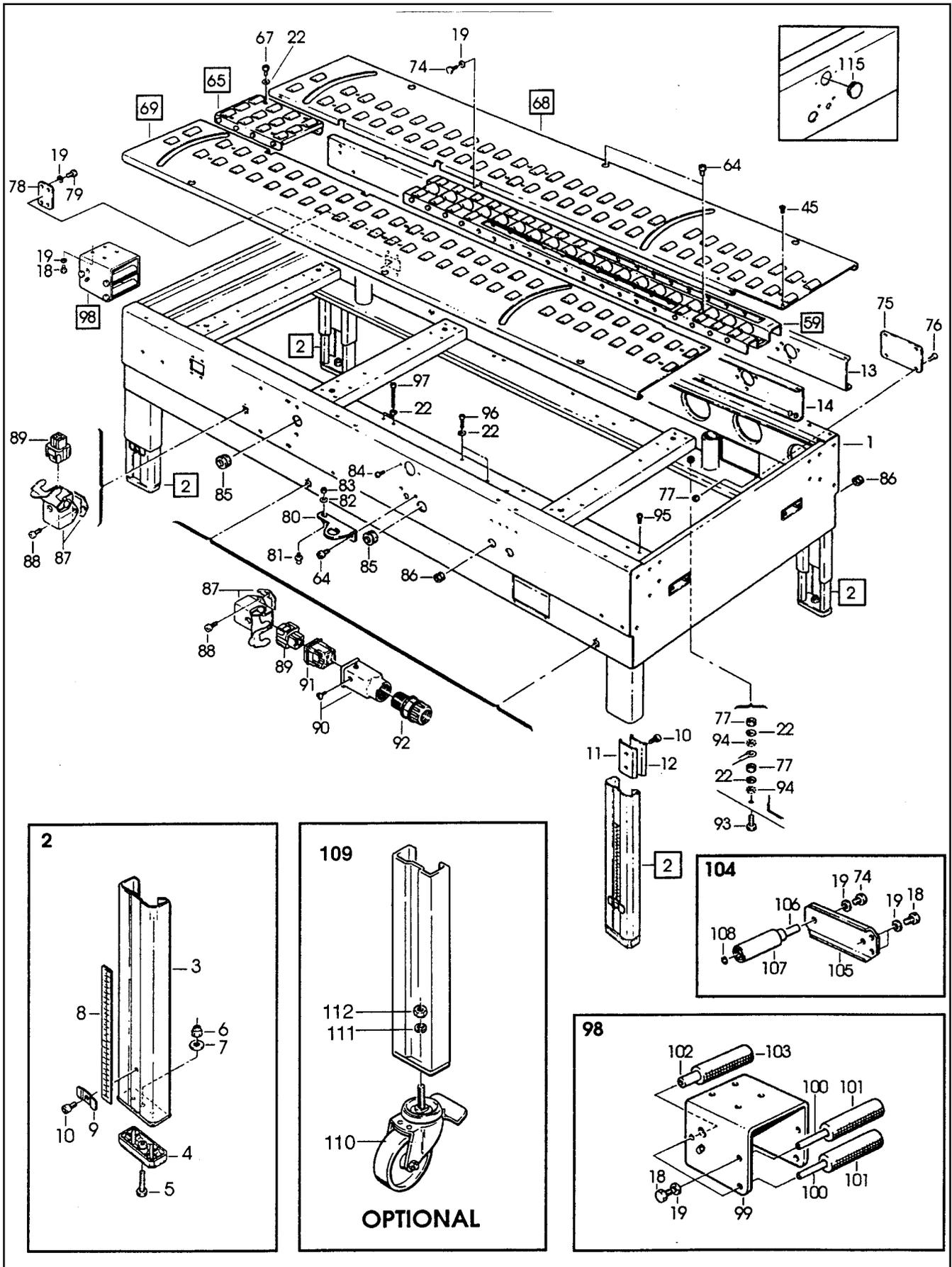


Figure 4184/1 of 4

Figure 4184 (Page 1 of 4)

Ref. No.	3M Part No.	Description
4184-1	78-8076-4747-0	Bed Conveyor
4184-2	78-8076-5381-7	Leg Assembly – Inner, W/Stop
4184-3	78-8076-5382-5	Leg – Inner
4184-4	78-8060-8480-8	Pad – Foot
4184-5	78-8055-0867-4	Screw
4184-6	78-8017-9313-0	Nut – Self-Locking, M8
4184-7	78-8017-9318-9	Washer – Plain, 8 mm
4184-8	78-8060-8481-6	Label – Height
4184-9	78-8076-5383-3	Stop – Leg
4184-10	26-1003-7963-0	Screw – Soc Hd, M8 x 16
4184-11	78-8052-6677-8	Clamp – Inner
4184-12	78-8052-6676-0	Clamp – Outer
4184-13	78-8076-4748-8	Center Frame – Right
4184-14	78-8076-4749-6	Center Frame – Left
4184-15	26-1003-7964-8	Screw – Soc Hd Hex Soc Dr, M8 x 20
4184-16	78-8060-7722-4	Spacer – L=144
4184-17	78-8091-0696-2	Spacer
4184-18	78-8032-0375-7	Screw – Hex Hd, M6 x 16
4184-19	26-1000-0010-3	Washer – Flat, M6
4184-20	78-8076-4751-2	Bearing Support – Gate
4184-21	78-8032-0382-3	Screw – Soc Hex Hd, M5 x 16
4184-22	78-8005-5741-1	Washer – Plain, M5
4184-23	78-8076-4752-0	Gate
4184-24	78-8076-4753-8	Spacer – Gate
4184-25	78-8076-4754-6	Washer – Special, Gate
4184-26	78-8076-4755-3	Support – Cylinder, Gate
4184-27	78-8076-4756-1	Shaft – Cylinder, Gate
4184-28	78-8056-3965-1	Ring – 8 DIN 6799
4184-29	78-8076-4757-9	Bumper

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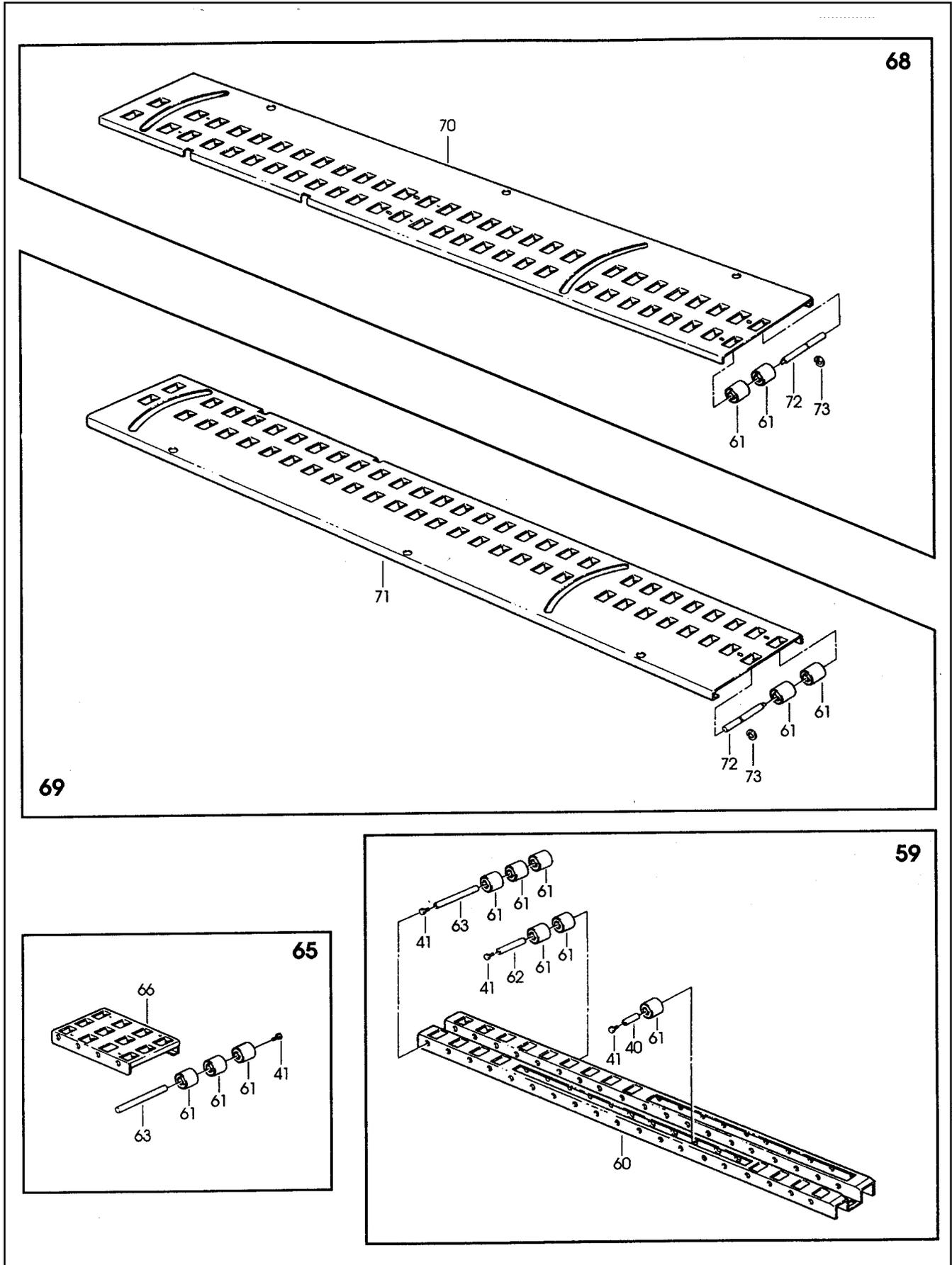


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Figure 4184 (Page 2 of 4)

Ref. No.	3M Part No.	Description
4184-30	78-8076-4772-8	Support Assembly W/Cam – Gate
4184-31	78-8076-4773-6	Support Assembly – Cam, Gate
4184-32	26-1003-7947-3	Screw – Soc Hd Hex Soc, M4 x 35
4184-33	78-8054-8758-0	Spacer – Valve Holder
4184-34	78-8059-5607-1	Plate – Threaded
4184-35	78-8054-8757-2	Pin – Spring Holder
4184-36	26-1005-6859-6	Nut – Self-Locking, M5
4184-37	78-8076-4774-4	Spring
4184-38	78-8055-0746-0	Link – Front Actuator, 12AF Black
4184-39	78-8055-0747-8	Link – Rear Actuator, 12AF Black
4184-40	78-8054-8857-0	Shaft – 8 x 43 mm
4184-41	78-8010-7163-6	Screw — Hex Hd, M5 x 10
4184-42	26-1002-4955-1	Screw – Self-Tap, 8P x 13
4184-43	78-8076-4775-1	Support Assembly– Cam
4184-44	78-8054-8858-8	Spacer – 8 x 26,5 mm
4184-45	26-1002-3866-1	Screw – Flat Hd Hx Dr, M5 x 10
4184-46	78-8076-4776-9	Cam – Long
4184-47	78-8076-4777-7	Cam – Short
4184-48	26-1003-7953-1	Screw – Soc Hd, M5 x 30
4184-49	78-8023-2334-1	Screw – Soc Hd, Hex Soc, M6 x 25
4184-50	78-8076-4778-5	Actuator Assembly
4184-51	78-8076-4779-3	Support – Actuator
4184-52	26-1003-6914-4	Nut – Plastic Insert, M4
4184-53	78-8005-5740-3	Washer – Plain, 4 mm
4184-54	78-8076-4780-1	Guide – Right, Actuator
4184-55	78-8076-4781-9	Guide – Left, Actuator
4184-56	78-8076-4782-7	Actuator – Flap Folder
4184-57	78-8076-4784-3	Screw – Soc Hd Hex Hd, M6 x 35

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Ref. No.	3M Part No.	Description
4184-58	78-8076-4783-5	Plate – Actuator
4184-59	78-8076-4764-5	Conveyor Assembly – Center
4184-60	78-8091-0356-3	Conveyor – Center
4184-61	78-8060-7693-7	Roller – 32 x 38
4184-62	78-8076-4766-0	Shaft – /8 x 83
4184-63	78-8052-6694-3	Shaft – /8 x 128
4184-64	78-8010-7209-7	Screw – Soc Hd, M6 x 12
4184-65	78-8076-4762-9	Conveyor Assembly – Rear
4184-66	78-8076-4763-7	Conveyor – Rear
4184-67	26-1003-7948-1	Screw – Soc Hd Hex Soc, M5 x 10
4184-68	78-8076-4767-8	Conveyor Assembly – Right
4184-69	78-8076-4768-6	Conveyor Assembly – Left
4184-70	78-8113-6901-2	R/H Conveyor Label Assembly (W/English Language Label)
4184-71	78-8113-6902-0	L/H Conveyor Label Assembly (W/English Language Label)
4184-72	78-8076-4771-0	Shaft – Roller
4184-73	78-8060-8035-0	E-Ring – 7DIN6799
4184-74	78-8010-7169-3	Screw – Hex Hd, M6 x 12
4184-75	78-8060-8487-3	Cover – Switch
4184-76	78-8060-8087-1	Screw – M5 x 10
4184-77	78-8010-7417-6	Nut – Hex, M5
4184-78	78-8076-4761-1	Plate
4184-79	26-1003-5829-5	Screw – Hex Hd, M6 x 12
4184-80	78-8091-0612-9	Plate – L/H
4184-81	78-8091-0613-7	Shaft – Valve
4184-82	78-8042-2919-9	Washer – Triple, M6
4184-83	26-1003-6916-9	Nut – Locking Plastic Insert, M6
4184-84	78-8076-4625-8	Screw – Special, M5 x 16
4184-85	78-8076-4702-5	Grommet – /28
4184-86	78-8060-7758-8	Fairlead /20

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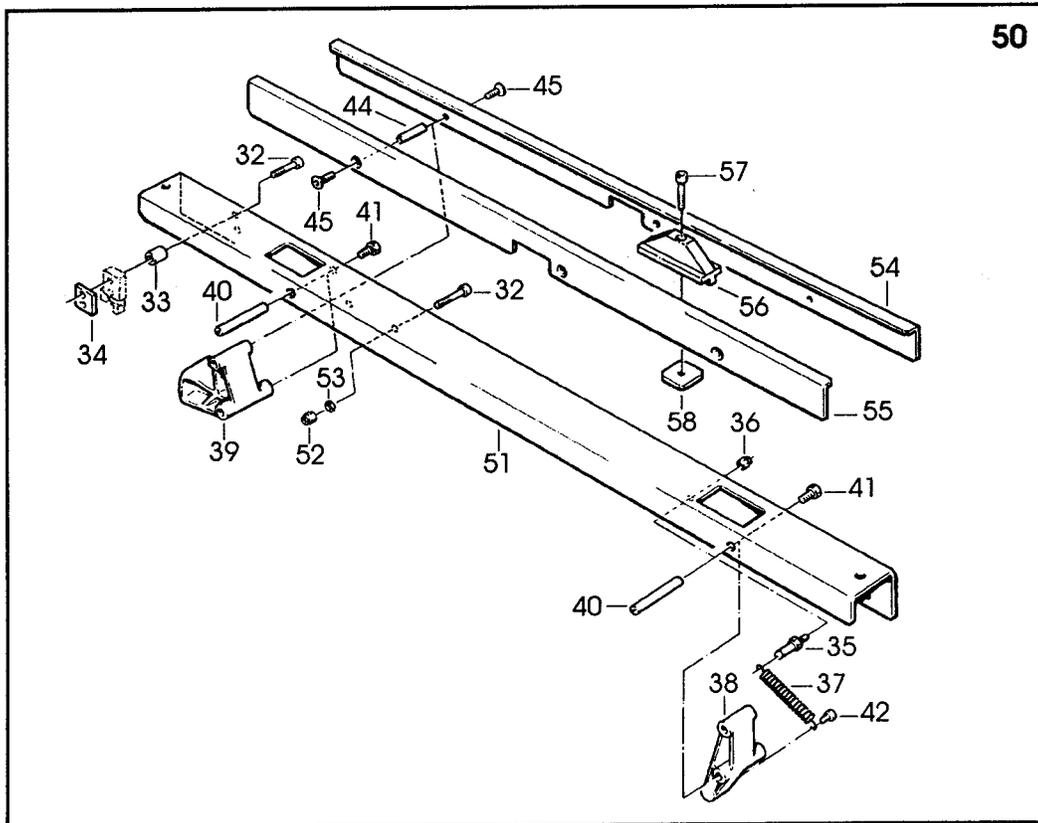
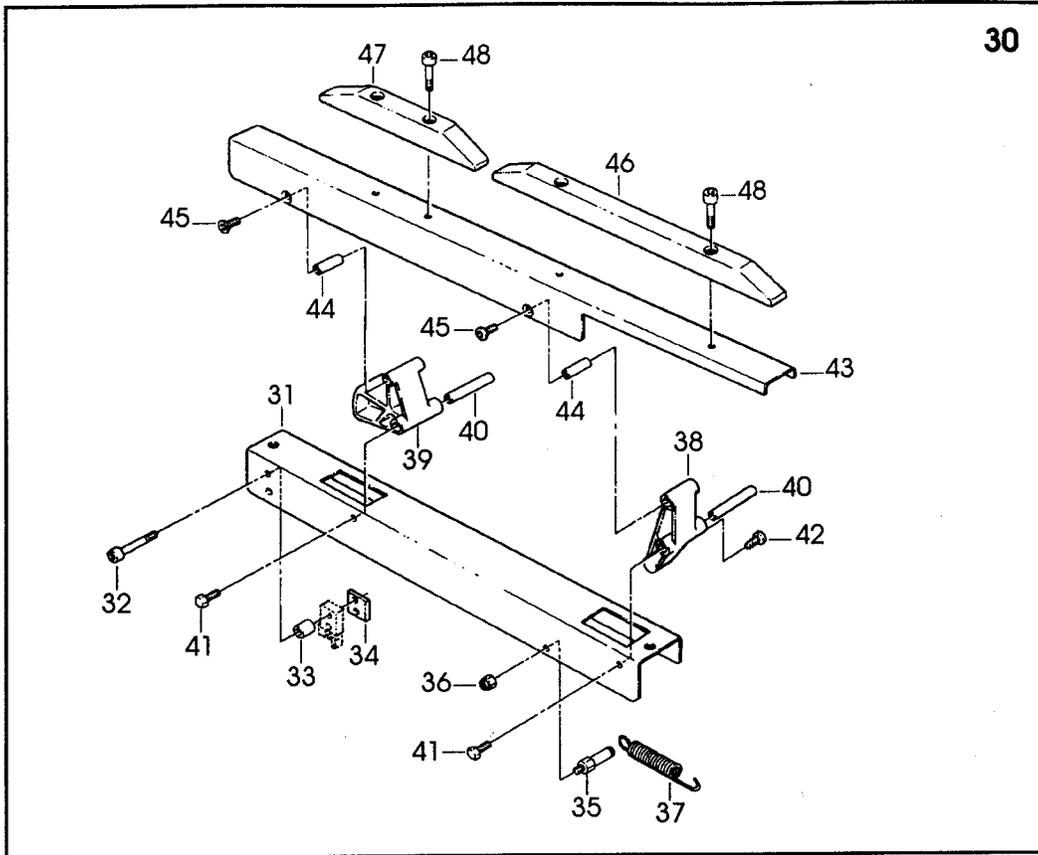


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Ref. No.	3M Part No.	Description
4184-87	78-8060-7876-8	Cover Plug – Lateral
4184-88	78-8028-8208-0	Screw – 6P x 9,5
4184-89	78-8060-7873-5	Plug – Female
4184-90	78-8060-7877-6	Plug Housing – Vertical
4184-91	78-8060-7875-0	Plug – Male
4184-92	78-8076-4532-6	Union
4184-93	78-8060-8488-1	Screw – Hex Hd, M5 x 20
4184-94	78-8046-8217-3	Washer – Special
4184-95	78-8094-6479-1	Screw – Self-Tapping. 6P x 30
4184-96	26-1003-7954-9	Screw - Soc Hd, M5 x 35
4184-97	78-8060-7582-2	Screw – Soc Hd Hex Soc, M5 x 70
4184-98	78-8076-5025-0	Support Assembly – Tape Roll Bracket
4184-99	78-8076-5027-6	Support – Tape Roll Bracket
4184-100	78-8076-5028-4	Shaft – Roller
4184-101	78-8076-5030-0	Roller – Knurled, 114 mm
4184-102	78-8076-5031-8	Shaft – Roller
4184-103	78-8076-5032-6	Roller – Knurled, 110,5 mm
4184-104	78-8114-4717-2	Bracket Assembly
4184-105	78-8076-5033-4	Bracket
4184-106	78-8114-4718-0	Shaft
4184-107	78-8114-4719-8	Roller
4184-108	26-1000-1613-3	Ring – Retaining 10DIN6799
4184-109	78-8098-9076-3	Caster Assembly
4184-110	26-1009-9096-4	Caster – Dual Locking
4184-111	26-1009-9094-9	Washer – Spring, Helical, M12
4184-112	26-1009-9095-6	Nut – M12
4184-115	78-8076-4536-7	Cap – /45X1.5

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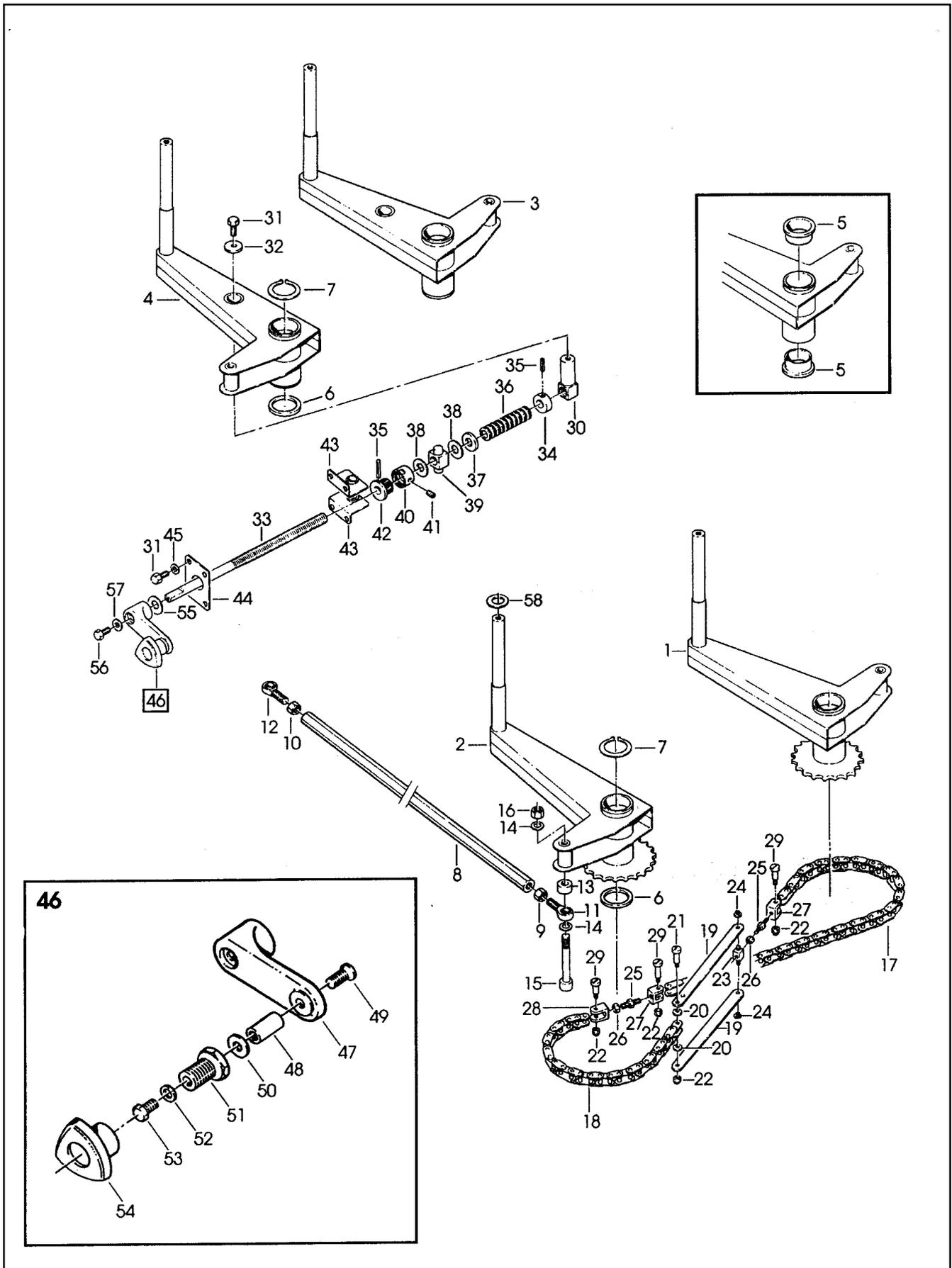


Figure 4185

Figure 4185

Ref. No.	3M Part No.	Description
4185-1	78-8091-0741-6	Arm Assembly – Front, R/H
4185-2	78-8091-0742-4	Arm Assembly – Front, L/H
4185-3	78-8091-0743-2	Arm Assembly – Rear, R/H
4185-4	78-8091-0744-0	Arm Assembly – Rear, L/H
4185-5	78-8076-4791-8	Bushing
4185-6	78-8060-7534-3	Washer
4185-7	78-8060-7521-0	Lock Ring
4185-8	78-8076-4792-6	Bar – Coupling
4185-9	78-8060-7525-1	Nut – Right Flat, M10
4185-10	78-8060-7546-7	Nut – Left Flat, M10
4185-11	78-8076-4793-4	Ball Joint – KA 10 D
4185-12	78-8076-4794-2	Ball Joint – KAL 10 D
4185-13	78-8076-4795-9	Spacer
4185-14	78-8052-6566-3	Washer – Friction
4185-15	78-8076-4796-7	Screw – Soc Hd Hex Hd, M10 x 80
4185-16	26-1003-6918-5	Nut – Plastic Insert, M10 Hex Flange
4185-17	78-8076-4797-5	Chain – Metric #35, 59 Links
4185-18	78-8076-4798-3	Chain – Metric #35, 47 Links
4185-19	78-8054-8787-9	Chain Link
4185-20	78-8054-8783-8	Washer – Special
4185-21	78-8060-7519-4	Screw – M3 x 25
4185-22	78-8059-5517-2	Nut – Self-Locking, M3
4185-23	78-8054-8784-6	Block – Chain
4185-24	78-8056-3945-3	E-Ring – M4
4185-25	78-8054-8785-3	Rod – Threaded Right/ Left
4185-26	78-8010-7418-4	Nut – Hex, M6
4185-27	78-8054-8786-1	Chain Connector
4185-28	78-8054-8788-7	Chain Connector
4185-29	78-8060-7520-2	Screw – M3 x 20
4185-30	78-8076-4799-1	Nut – Arm
4185-31	78-8060-7886-7	Screw – Special Hex Hd, M6 x 16
4185-32	78-8076-4754-6	Washer – Special, Gate
4185-33	78-8076-4801-5	Screw – Centering
4185-34	78-8060-7981-6	Bushing – Dowel
4185-35	78-8054-8586-5	Pin
4185-36	78-8060-7984-0	Washer – Belleville
4185-37	78-8060-7983-2	Washer
4185-38	78-8060-8036-8	Washer – Nylon
4185-39	78-8060-8436-0	Plastic Nut
4185-40	78-8076-4802-3	Ring Nut
4185-41	78-8076-4803-1	Set Screw – M5 x 8
4185-42	78-8076-4804-9	Bushing – Threaded
4185-43	78-8076-4805-6	Plate – W/Bushing
4185-44	78-8076-4806-4	Plate
4185-45	26-1000-0010-3	Washer – Flat, M6
4185-46	78-8076-4807-2	Crank Assembly
4185-47	78-8076-5422-9	Crank
4185-48	78-8070-1509-0	Shaft – Crank
4185-49	26-1005-5316-8	Screw – Flat Hd Hex Dr, M5 x 16
4185-50	78-8070-1510-8	Washer – Nylon, /7 x 15 x 1
4185-51	78-8070-1511-6	Bushing
4185-52	78-8005-5740-3	Washer – Plain 4 mm
4185-53	78-8010-7157-8	Screw – Hex Hd, M4 x 10
4185-54	78-8070-1512-4	Knob – VTR-B-M12
4185-55	78-8070-1548-8	Washer – Nylon 20 x 12, 5 x 1
4185-56	78-8032-0375-7	Screw – Hex Hd, M6 x 16
4185-57	78-8076-4809-8	Washer – Crank
4185-58	78-8060-7541-8	Washer

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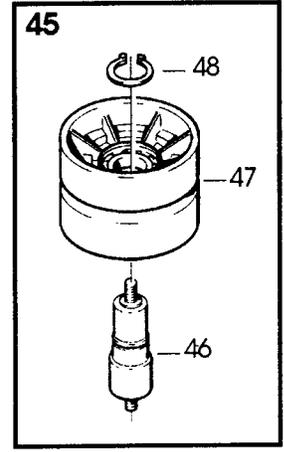
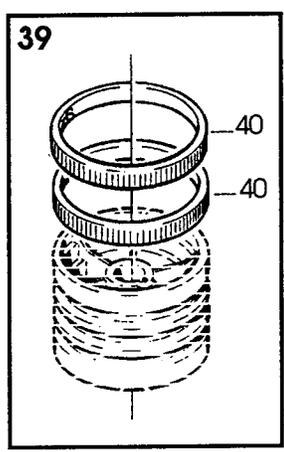
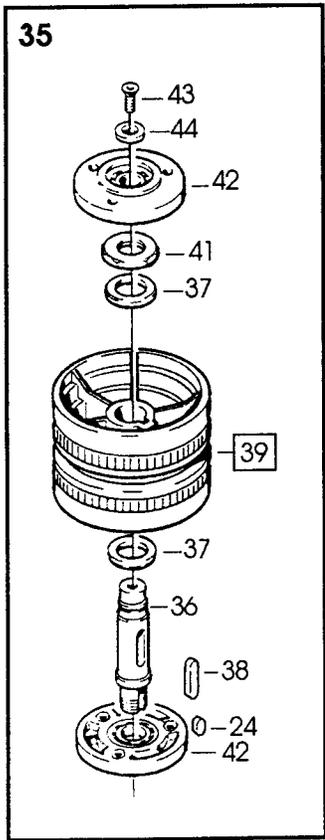
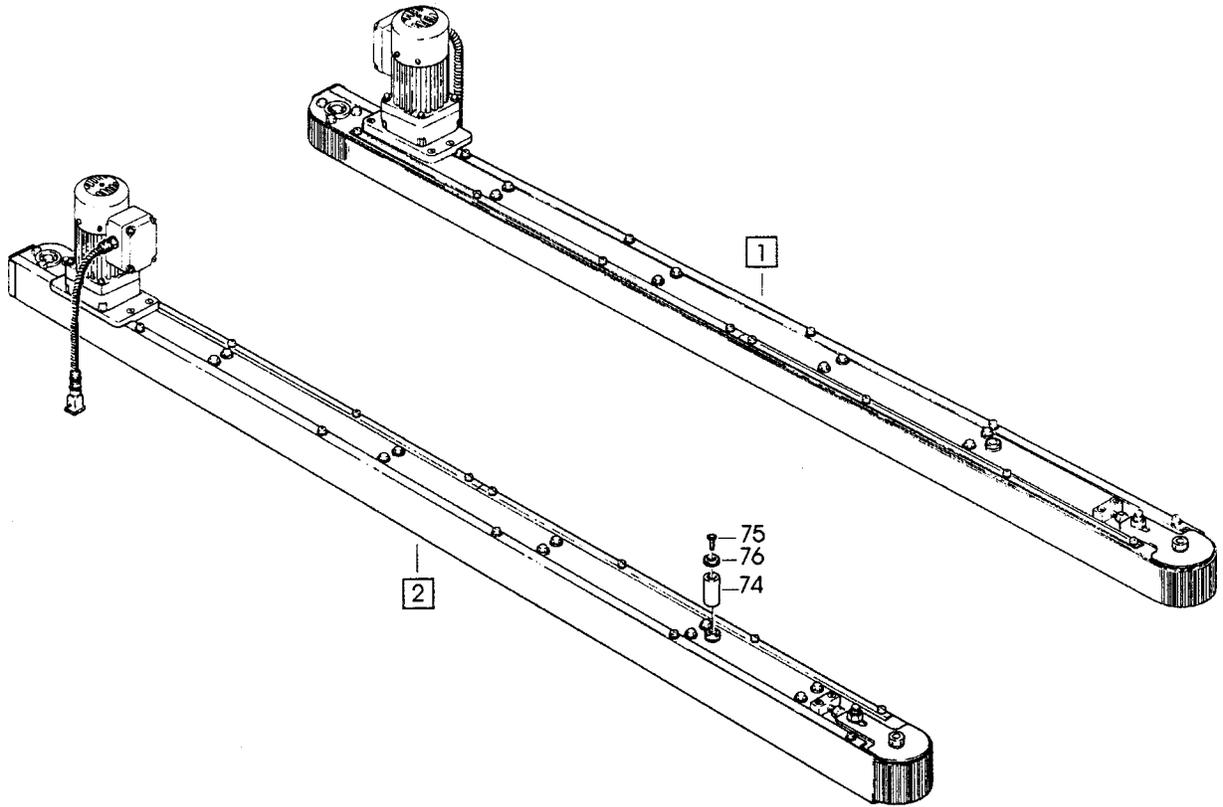


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Ref. No.	3M Part No.	Description
4186-1	78-8091-0745-7	Side Drive Assembly – R/H, W/O Motor
	78-8098-8956-7	Side Drive Assembly – R/H, With Motor
4186-2	78-8091-0746-5	Side Drive Assembly – L/H, W/O Motor
	78-8098-8957-5	Side Drive Assembly – L/H, With Motor
4186-3	78-8091-0747-3	Guide – Lower, R/H
4186-4	78-8091-0748-1	Guide – Lower, L/H
4186-5	78-8091-0749-9	Guide – Upper, R/H
4186-6	78-8091-0750-7	Guide – Upper, L/H
4186-7	78-8091-0500-6	Bushing – Side Drive
4186-8	78-8060-7995-6	Pin – Roller
4186-9	78-8060-7996-4	Roller
4186-10	78-8091-0751-5	Plate – Roller Stop, Right
4186-11	78-8091-0752-3	Plate – Roller Stop, Left
4186-12	78-8091-0753-1	Plate – Roller Stop, Right, R/H Drive
4186-13	78-8091-0754-9	Plate – Roller Stop, Left, R/H Drive
4186-14	78-8091-0755-6	Plate – Roller Stop, Right, L/H Drive
4186-15	78-8091-0756-4	Plate – Roller Stop, Left, L/H Drive
4186-16	78-8076-5255-3	Screw – Phillips Hd, M4 x 12
4186-17	78-8005-5740-3	Washer – Plain, 4 mm
4186-18	78-8076-4855-1	Washer – Special
4186-19	78-8054-8910-7	Spacer – Hexagonal
4186-20	26-1003-5829-5	Screw – Hex Hd, M6 x 12
4186-21	26-1000-0010-3	Washer – Flat, M6
4186-22	78-8076-5439-3	Flange Assembly
4186-23	78-8091-0757-2	Extension – Gearmotor
4186-24	78-8046-8135-7	Key – 5 x 5, 12 mm
4186-25	78-8091-0758-0	Sprocket – 3/8 Inch, Z=14
4186-26	78-8057-5834-5	Tab Washer
4186-27	78-8057-5835-2	Centering Washer
4186-28	78-8091-0759-8	Sprocket – 3/8 Inch, Z=23
4186-29	78-8076-4933-6	Chain – 3/8 Inch Pitch, 52 Pitch
4186-30	78-8094-6109-4	Support – Gearmotor
4186-31	78-8010-7210-5	Screw – Soc Hd Hex Soc, M6 x 20
4186-32	78-8070-1522-3	Gearmotor – 115V, 60HZ, Bodine 42R5BFC1-E2
4186-33	78-8070-1523-1	Screw – 1/4-28 x 1/2 SHCS
4186-34	26-1011-8828-7	Capacitor – 115V Gearmotor
4186-35	78-8076-4862-7	Pulley – Drive
4186-36	78-8054-8878-6	Shaft – Pulley Keyed
4186-37	78-8054-8879-4	Washer – /20,5 mm
4186-38	78-8057-5739-6	Key – M5 x 5 x 30 mm

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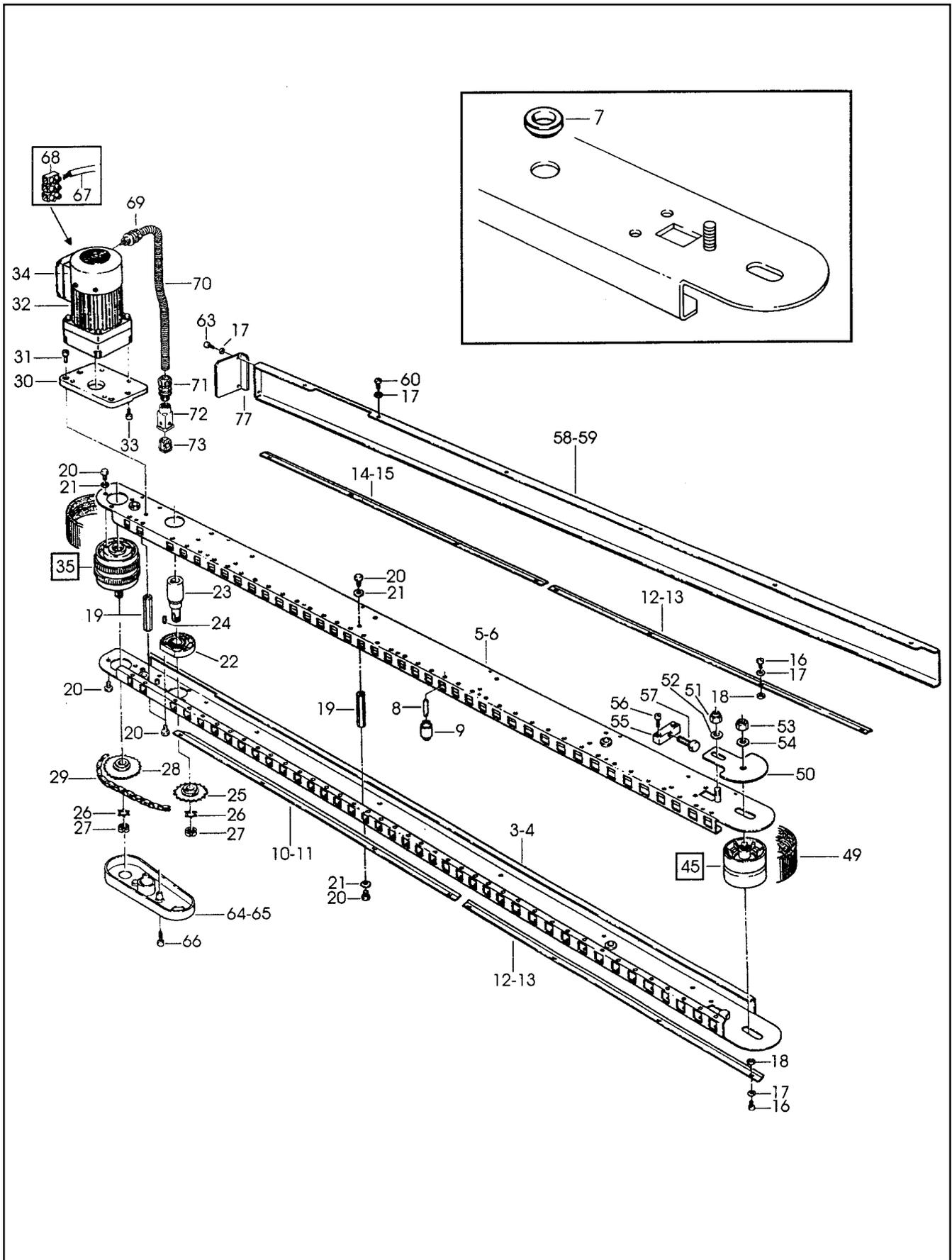


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Ref. No.	3M Part No.	Description
4186-39	78-8076-5105-0	Pulley Assembly – Drive
4186-40	78-8052-6713-1	Ring – Polyurethane
4186-41	78-8017-9096-1	Nut – Special, M18 x 1
4186-42	78-8076-5442-7	Flange Assembly
4186-43	26-0001-5862-1	Screw – Flat Hd Soc, M5 x 12
4186-44	78-8054-8877-8	Washer – 5.5/20 x 4
4186-45	78-8060-8014-5	Idler Roller Assembly
4186-46	78-8054-8913-1	Shaft – Roller
4186-47	78-8052-6710-7	Roller – Idler
4186-48	12-7997-0272-0	E-Ring – M-25
4186-49	78-8076-4865-0	Belt – Box Drive
4186-50	78-8091-0761-4	Plate – Belt Tensioning
4186-51	26-1003-6918-5	Nut – Plastic Insert, M10 Hex Flange
4186-52	78-8052-6566-3	Washer – Friction
4186-53	26-1000-1347-8	Nut – Hex, M8
4186-54	78-8017-9318-9	Washer – Plain, 8 mm
4186-55	78-8054-8903-2	Block – Belt
4186-56	78-8010-7210-5	Screw – Soc Hd Hex Soc, M6 x 20
4186-57	78-8054-8904-0	Screw – Belt Adjustment
4186-58	78-8091-0762-2	Cover – Drive, Right
4186-59	78-8091-0763-0	Cover – Drive, Left
4186-60	26-1002-5753-9	Screw – Self-Tapping
4186-63	26-1002-4955-1	Screw – Self-Tap, 8P x 13
4186-64	78-8091-0764-8	Cover – Chain, Right
4186-65	78-8091-0765-5	Cover – Chain, Left
4186-66	78-8010-7165-1	Screw – Flat Hd Soc, M5 x 25
4186-67	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
4186-68	78-8076-4968-2	Terminal
4186-69	78-8060-7631-7	Connector – 3/8 Inch
4186-70	78-8076-4871-8	Sleeving – /12, 600 mm
4186-71	78-8060-7626-7	Connector – PG 11/12
4186-72	78-8060-7877-6	Plug – Housing Vertical
4186-73	78-8060-7875-0	Plug – Male
4186-74	78-8091-0766-3	Spacer – Drive
4186-75	26-1001-9843-6	Screw – Flat Soc Hd, M6 x 16
4186-76	78-8054-8577-4	Washer – Special
4186-77	78-8114-4787-5	Guard – Belt

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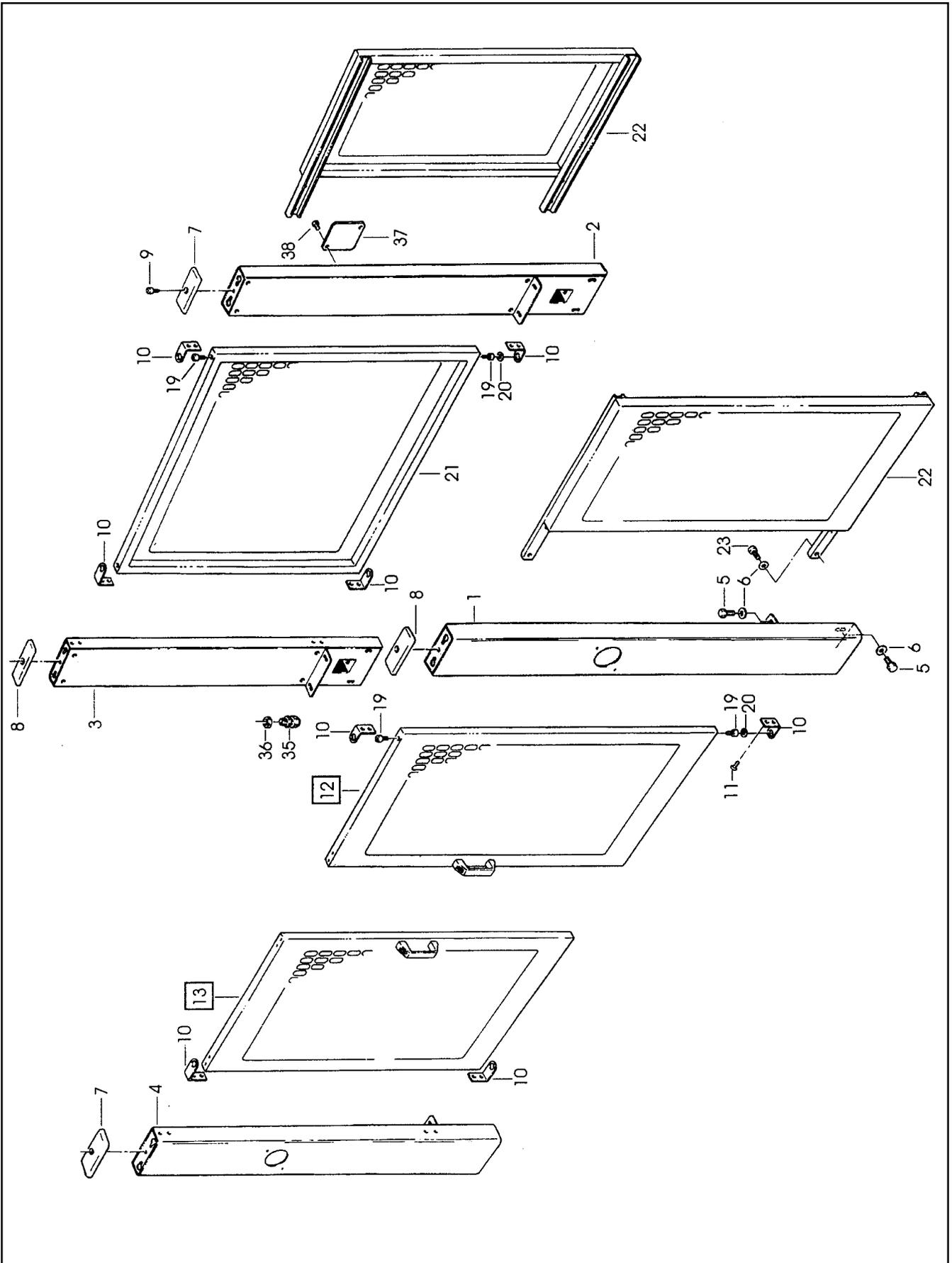


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Ref. No.	3M Part No.	Description
4188-1	78-8113-6905-3	Jamb Assembly – Right Front (W/English Language Label)
4188-2	78-8113-6903-8	Jamb Assembly – Right Rear (W/English Language Label)
4188-3	78-8113-6904-6	Jamb Assembly – Left Rear (W/English Language Label)
4188-4	78-8113-6906-1	Jamb Assembly – Left Front (W/English Language Label)
4188-5	26-1003-5842-8	Screw – Hex Hd, M8 x 20
4188-6	78-8017-9318-9	Washer – Plain, 8 mm
4188-7	78-8076-4511-0	Cap – Front, R/H
4188-8	78-8076-4512-8	Cap – Front, L/H
4188-9	78-8010-7210-5	Screw – Soc Hd Hex Soc, M6 x 20
4188-10	78-8076-4916-1	Hinge
4188-11	26-0001-5862-1	Screw – Flat Hd Soc, M5 x 12
4188-12	78-8091-0769-7	Wing Assembly – Left
4188-13	78-8091-0768-9	Wing Assembly – Right
4188-14	78-8091-0770-5	Wing
4188-15	78-8060-7807-3	Handle
4188-16	78-8091-0771-3	Pocket
4188-17	26-1003-7949-9	Screw – Soc Hd Hex Soc, M5 x 12
4188-18	78-8005-5741-1	Washer – Plain, M5

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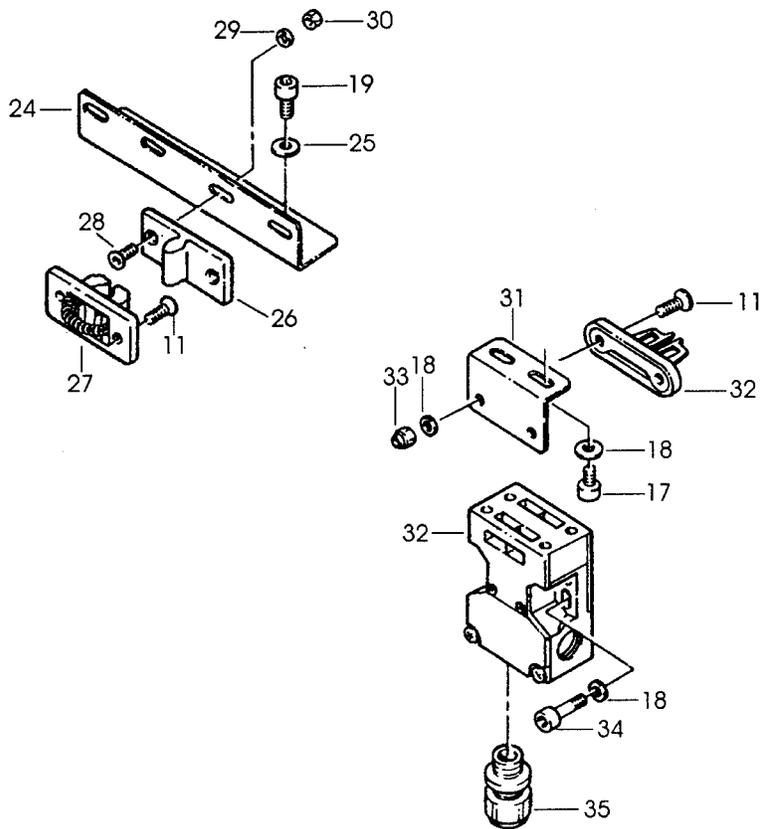
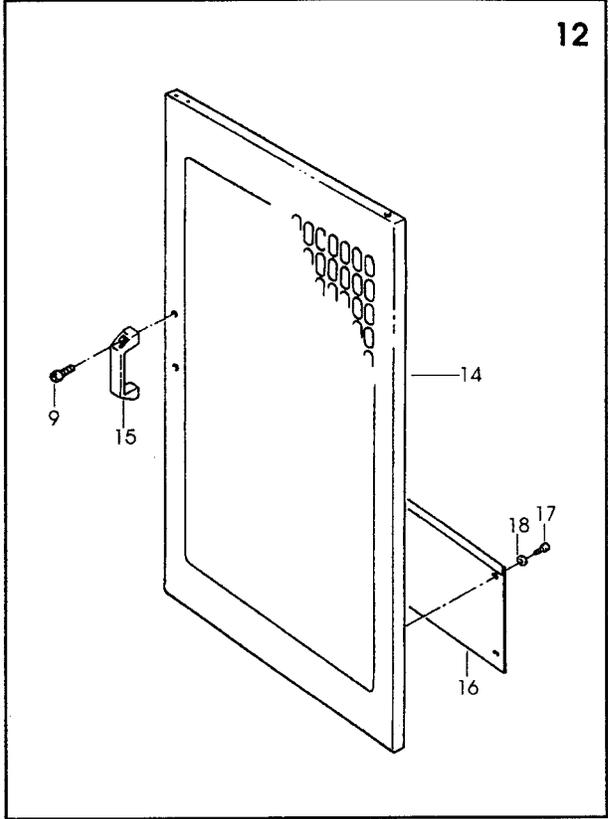
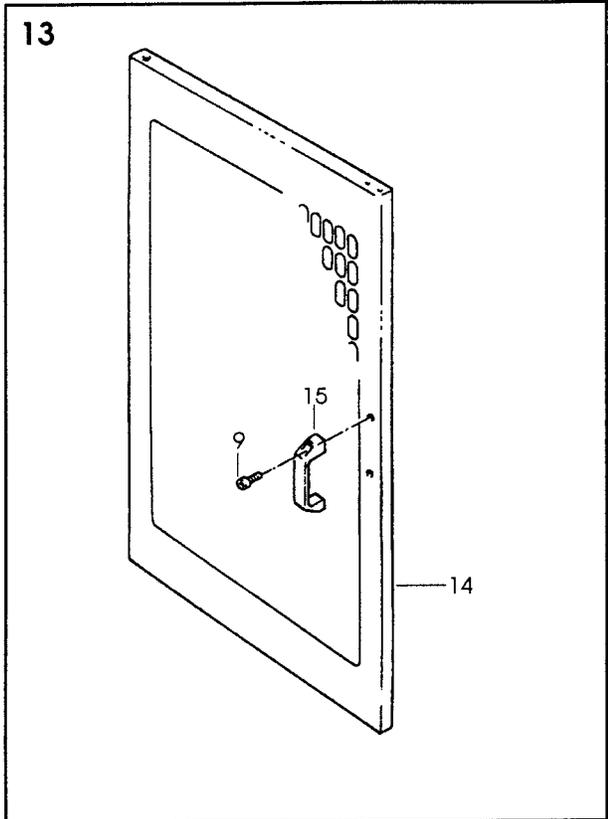


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Ref. No.	3M Part No.	Description
4188-19	78-8010-7209-7	Screw – Soc Hd, M6 x 12
4188-20	78-8017-9074-8	Washer – Nylon, 15 mm
4188-21	78-8091-0772-1	Panel Assembly
4188-22	78-8091-0773-9	Panel Assembly – Infeed
4188-23	26-1003-7964-8	Screw – Soc Hd Hex Soc Dr, M8 x 20
4188-24	78-8076-4930-2	Square – Support
4188-25	26-1000-0010-3	Washer – Flat, M6
4188-26	78-8076-4931-0	Drawbar – Lock
4188-27	78-8076-4932-8	Lock – Wing
4188-28	26-1005-4758-2	Screw – Flat Hd, Soc Dr, M4 x 10
4188-29	78-8005-5740-3	Washer – Plain, 4 mm
4188-30	78-8010-7416-8	Nut – Hex, M4
4188-31	78-8076-4992-2	Plate – Security Switch
4188-32	78-8076-4929-4	Security Switch – Schmersal AZ15ZVR
4188-33	26-1005-6859-6	Nut – Self-Locking , M5
4188-34	26-1003-7951-5	Screw – Soc Hd Hex Soc, M5 x 20
4188-35	78-8076-4532-6	Union
4188-36	78-8076-4645-6	Lock Nut – GMP11
4188-37	78-8114-4788-3	Plate
4188-38	26-1003-5707-3	Screw – Phillips Dr, M4 x 16

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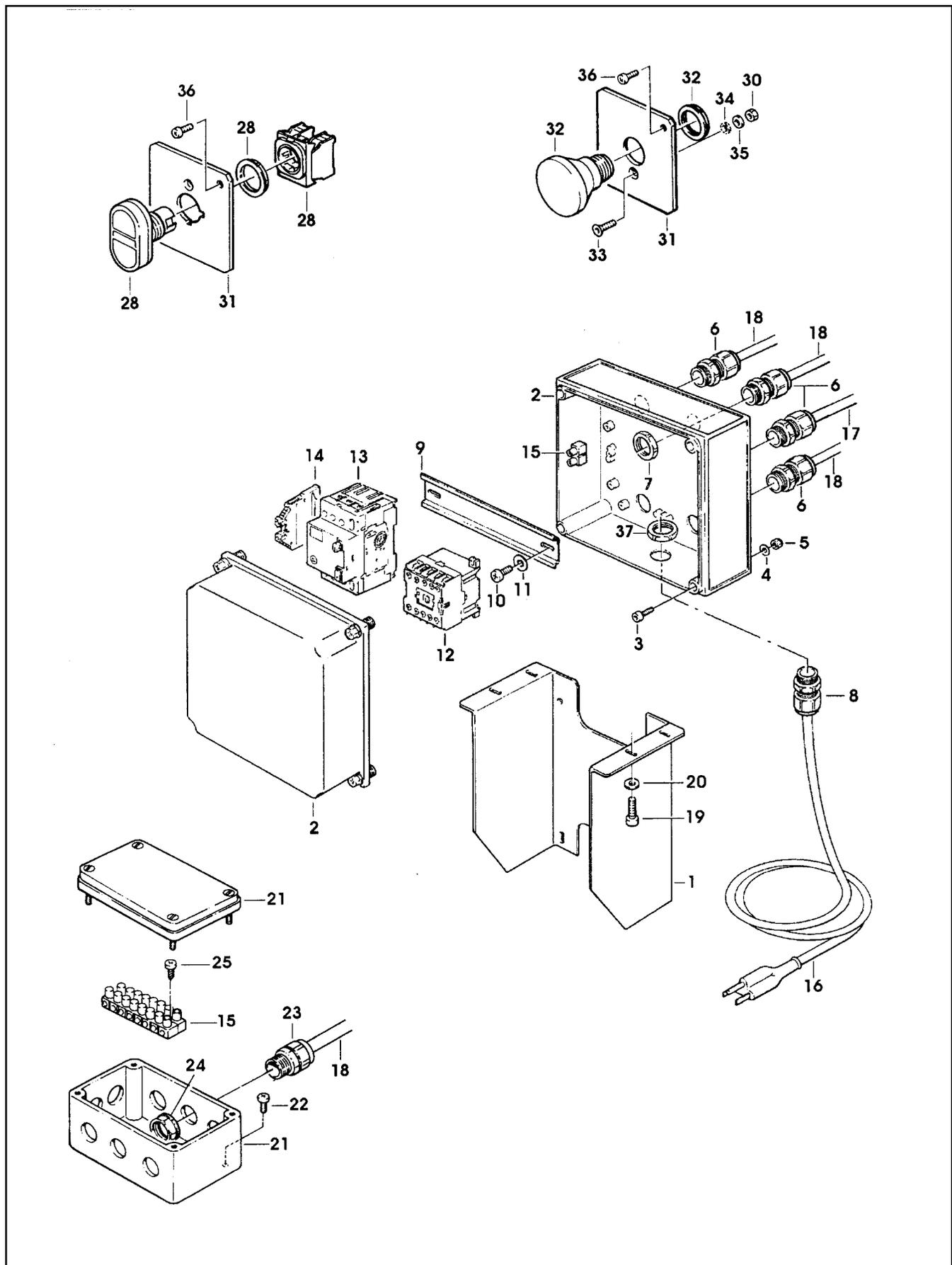


Figure 5600

Figure 5600

Ref. No.	3M Part No.	Description
5600-1	78-8094-6379-3	Support – Box
5600-2	78-8094-6380-1	Box
5600-3	78-8094-6381-9	Screw – Soc Hd, Hex Hd, M4 x 15
5600-4	78-8005-5740-3	Washer – Plain, 4 mm
5600-5	26-1003-6914-4	Nut – Plastic Insert, M4
5600-6	78-8076-4715-7	Cord Grip
5600-7	78-8076-5211-6	Set Nut – GMP 13,5
5600-8	78-8057-5807-1	Cord Grip – ST 16
5600-9	78-8094-6382-7	Guide – Mounting
5600-10	78-8028-8208-0	Screw – 6PX9,5
5600-11	78-8017-9018-5	Washer – Plain, M4 SPEC
5600-12	78-8094-6383-5	Contactor – CA-5-10, 110V, 60 HZ
5600-13	78-8076-5378-3	Switch – Thermal, KTA-3-25
5600-14	78-8094-6384-3	Clamp – VGPE 4/6
5600-15	78-8076-4968-2	Terminal
5600-16	78-8028-7909-4	Power Cord – U.S.A.
5600-17	78-8100-1038-5	Cable – 3X20 AWG, 5 MT
5600-18	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
5600-19	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
5600-20	26-1000-0010-3	Washer – Flat, M6
5600-21	78-8076-4881-7	Pull Box
5600-22	78-8060-8087-1	Screw – M5 x 10
5600-23	78-8076-4532-6	Cord Grip – ST11
5600-24	78-8076-4645-6	Lock Nut – GMP 11
5600-25	78-8091-0434-8	Screw – Self-Tapping, 4.2X19
5600-28	78-8094-6386-8	Switch – On/Off, DM3N-C-01/10
5600-30	78-8010-7417-6	Nut – Hex, M5
5600-31	78-8094-6474-2	Support – E-Stop
5600-32	78-8094-6385-0	E-Stop – 800EP-MTS643LX01
5600-33	26-1005-5316-8	Screw – Flat Hd Hex Dr, M5 x 16
5600-34	78-8046-8217-3	Washer – Special
5600-35	78-8005-5741-1	Washer – Flat, M5
5600-36	26-1003-5707-3	Screw – Phillips Dr, M4 x 16
5600-37	78-8100-1202-7	Lock Nut – GMP 16

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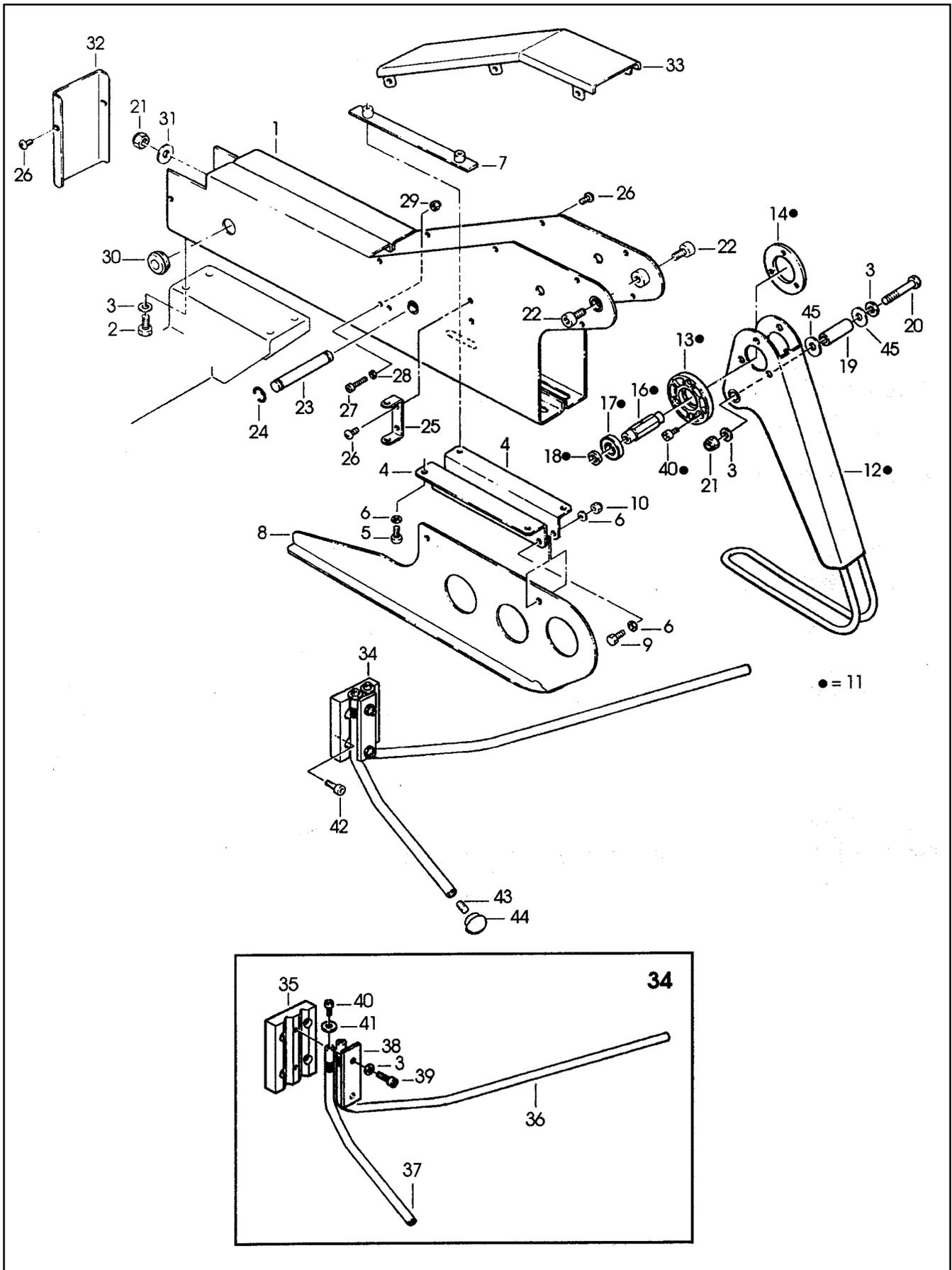


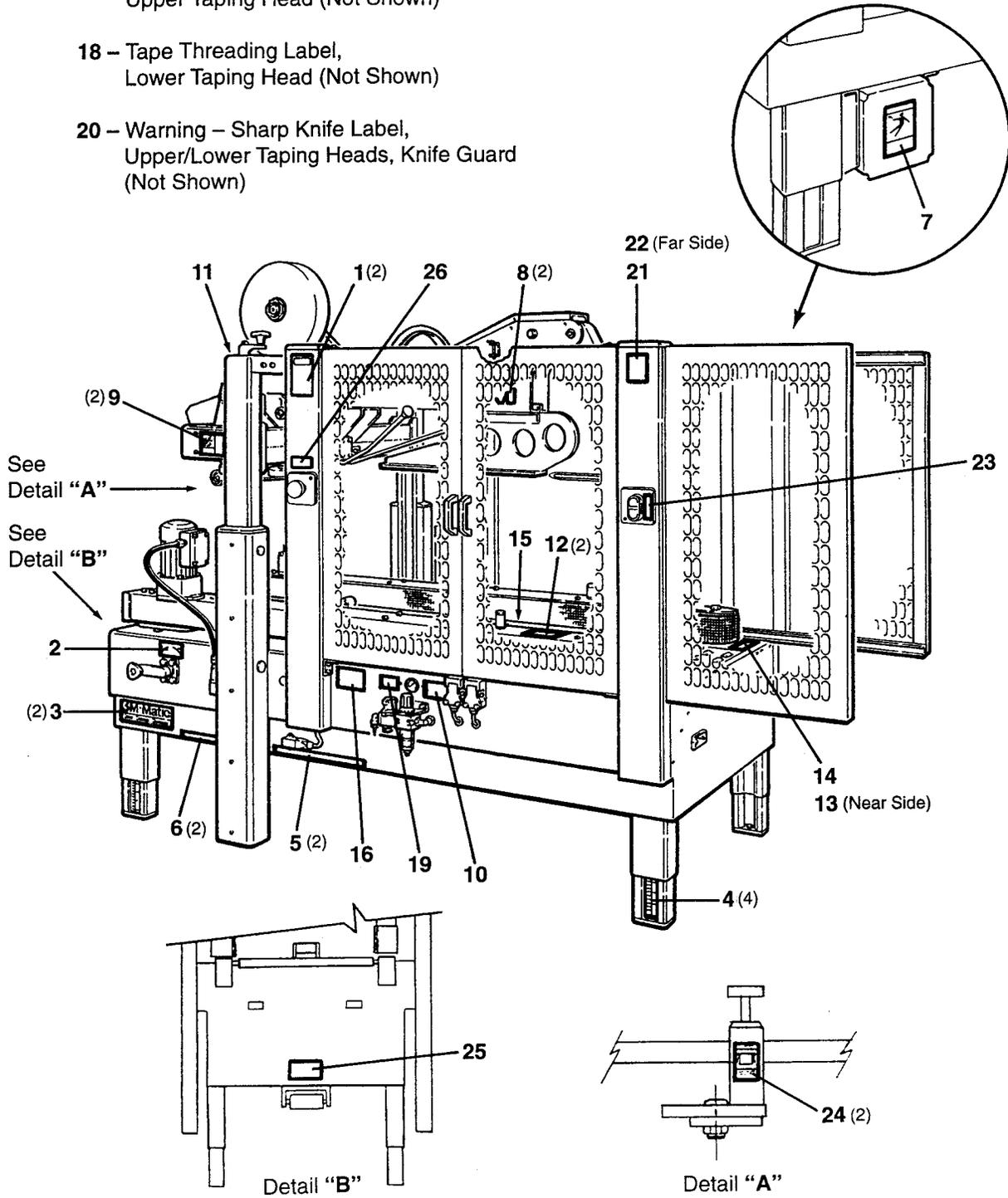
Figure 6419

Figure 6419

Ref. No.	3M Part No.	Description
6419-1	78-8091-0739-0	Support – Front Flap Folder
6419-2	78-8017-9301-5	Screw – Hex Hd, M8 x 25
6419-3	78-8017-9318-9	Washer – Plain, 8 mm
6419-4	78-8076-4832-0	Plate – Box Guide
6419-5	78-8010-7210-5	Screw – Soc Hd Hex Soc, M6 x 20
6419-6	26-1000-0010-3	Washer – Flat, M6
6419-7	78-8076-4833-8	Strap
6419-8	78-8114-4706-5	Flap Folder – Front
6419-9	78-8032-0375-7	Screw – Hex Hd, M6 x 16
6419-10	26-1003-6916-9	Nut – Locking, Plastic Insert, M6
6419-11	78-8114-4707-3	Flap Folder Assembly – Rear
6419-12	78-8114-4708-1	Flap Folder – Rear
6419-13	78-8114-4709-9	Support – Bearing
6419-14	78-8114-4710-7	Washer – Support
6419-16	78-8114-4711-5	Shaft – Support, Hex
6419-17	26-1000-4350-9	Bearing – 6002-2RS
6419-18	78-8114-4712-3	Spacer – Bearing
6419-19	78-8114-4695-0	Spacer – Cylinder
6419-20	26-1002-5949-3	Screw – Hex Hd, M8 x 60
6419-21	78-8017-9313-0	Nut – Self-Locking, M8
6419-22	26-1003-7964-8	Screw – Soc Hd Hex Soc Dr, M8 x 20
6419-23	78-8076-4831-2	Pin – Air Cylinder
6419-24	78-8056-3965-1	Ring – 8 DIN 6799
6419-25	78-8091-0740-8	Holder – Hex Wrench
6419-26	78-8060-8087-1	Screw – M5 x 10
6419-27	26-1003-7947-3	Screw – Soc Hd Hex Soc, M4 x 35
6419-28	78-8005-5740-3	Washer – Plain, 4 mm
6419-29	26-1003-6914-4	Nut – Plastic Insert, M4
6419-30	78-8060-7785-1	Fairlead – /22
6419-31	26-1004-5507-5	Washer – M8
6419-32	78-8076-4830-4	Cover – Flap Folder Support
6419-33	78-8076-4840-3	Cover
6419-34	78-8114-4713-1	Flap Folder Assembly – Side
6419-35	78-8114-4791-7	Block – Side Flap Folder
6419-36	78-8114-4714-9	Side Flap Folder – R/H
6419-37	78-8114-4715-6	Side Flap Folder – L/H
6419-38	78-8114-4792-5	Plate – Side Flap Folder
6419-39	78-8060-7895-8	Screw – M8 x 35
6419-40	78-8010-7209-7	Screw – Soc Hd, M6 x 12
6419-41	78-8042-2919-9	Washer – Triple, M6
6419-42	26-1003-7965-5	Screw – Soc Hd Hex Soc, M8 x 25
6419-43	78-8060-7863-6	Grain – M6 x 20
6419-44	78-8076-4546-6	Knob
6419-45	78-8017-9059-9	Washer – Flat For M12 Screw

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- 17 – Tape Threading Label, Upper Taping Head (Not Shown)
- 18 – Tape Threading Label, Lower Taping Head (Not Shown)
- 20 – Warning – Sharp Knife Label, Upper/Lower Taping Heads, Knife Guard (Not Shown)



Safety and Information Labels

Safety and Information Labels

A label kit, part number 78-8113-6881-6, 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.
1	78-8070-1621-3	Label – Safety Instructions	2
2	78-8070-1622-1	Label – In/Out	1
3	78-8062-4266-1	Label – 3M-Matic	2
4	78-8060-8481-6	Label – Leg Height	4
5	78-8070-1623-9	Label – Permissible Lift Area	2
6	78-8070-1624-7	Label – Permissible Lift Area	2
7	78-8070-1329-3	Label – Warning Hazardous Voltage	1
8	78-8070-1626-2	Label – 3M	2
9	78-8070-1336-8	Label – Warning, Sharp Knife	2
10	78-8113-6750-3	Label – Air Pressure, 95 PSI Maximum	1
11	78-8070-1628-8	Label – Up, Down, Lock	1
12	78-8070-1629-6	Label – Belt Tensioning	2
13	78-8070-1331-9	Label – Warning, Moving Belts	1
14	78-8070-1330-1	Label – Warning, Moving Belts	1
15	78-8070-1630-4	Label – Cam	1
16	78-8070-1631-2	Label – Lifting Notice	1
17	78-8070-1365-7	Label – Tape Threading, Upper	1
18	78-8070-1364-0	Label – Tape Threading, Lower	1
19	78-8111-1496-2	Label – Air Pressure	1
20	78-8070-1335-0	Label – Warning, Sharp Knife	2
21	78-8113-6882-4	Label – Warning, Flap Kicker, L/H	1
22	78-8113-6883-2	Label – Warning, Flap Kicker, R/H	1
23	78-8113-6775-0	Label – Electrical On/Off	1
24	78-8113-6912-9	Label – Caution, Pinch Point	2
25	78-8095-1049-4	Label – Tape Threading	1
26	78-8095-1141-9	Label – Stop	2