



Instructions and Parts List

3M-Matic™

100a

Type 29600

Adjustable Case Sealer

with

AccuGlide™ II

Taping Heads

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



Important Safety Information

Read "Important Safeguards",
pages 3-5 and also
operating "Warnings",
page 14 BEFORE
INSTALLING OR
OPERATING THIS
EQUIPMENT.

Spare Parts

It is recommended you
immediately order the spare
parts listed on page 29,
Section I and page 17,
Section II. 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 Bldg. 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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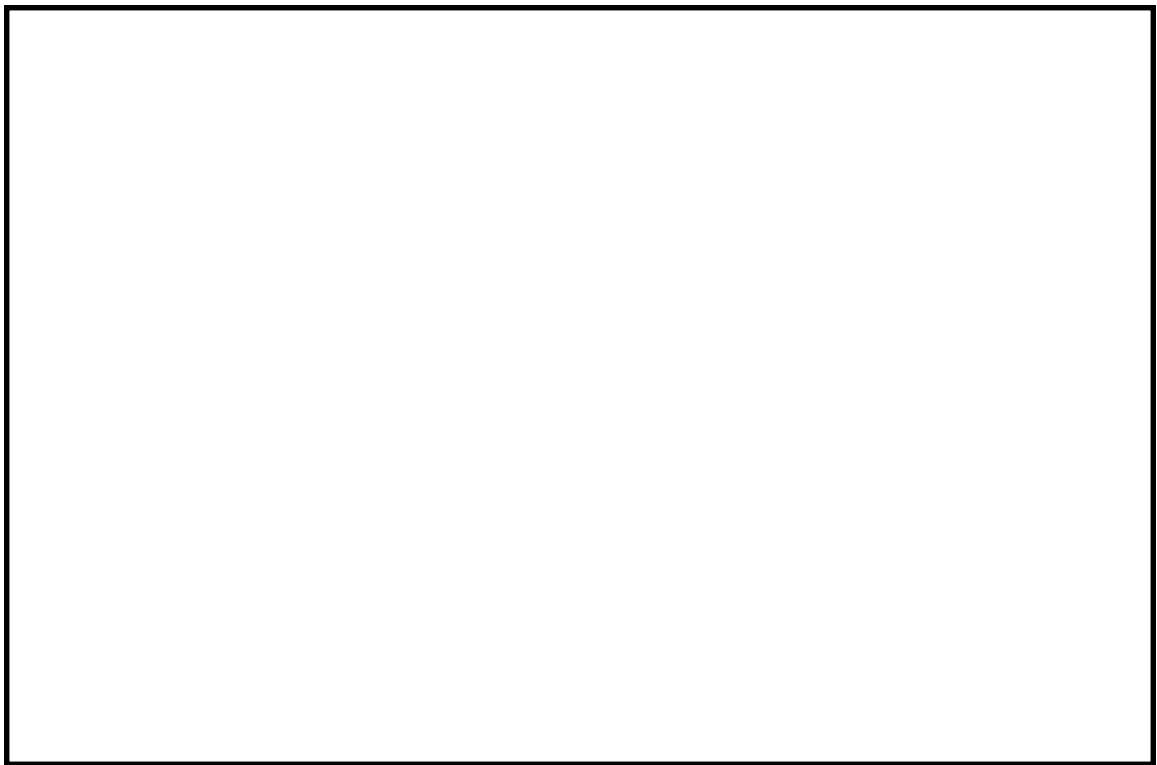
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To Our Customers:

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

100a, Adjustable Case Sealer, Type 29600

This instruction manual is divided into two sections as follows:

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

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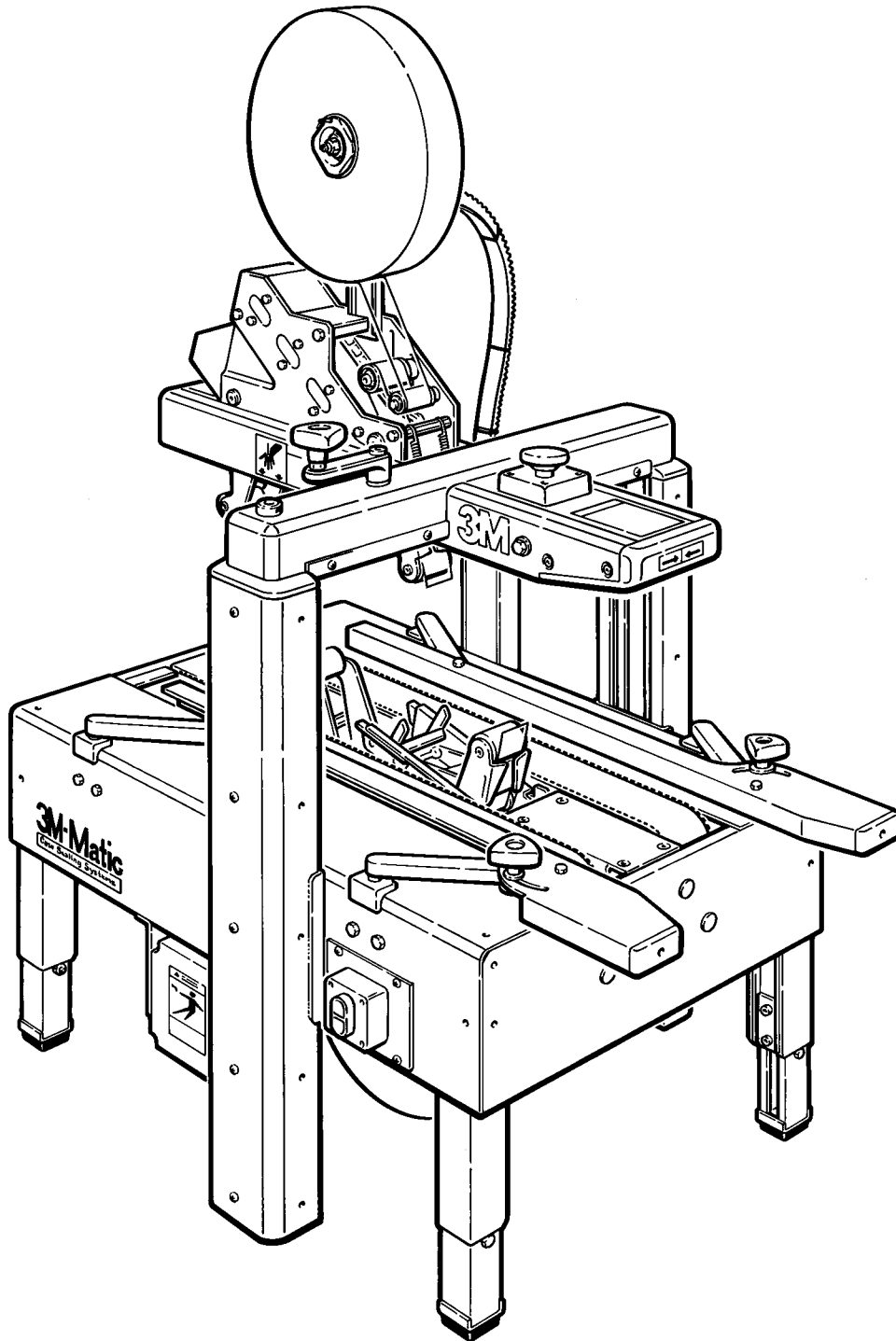
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Section II – AccuGlide™ II STD 2 Inch Taping Heads

(See Section II for Table of Contents)

Description

The **3M-Matic™ 100a Adjustable Case Sealer** with **AccuGlide™ II** Taping Heads is designed to apply a “C” clip of **Scotch™** brand pressure-sensitive film box sealing tape to the top and bottom center seam of regular slotted containers. The 100a is manually adjustable to a wide range of box sizes (see "Specifications – Box Weight and Size Capacities", Page 7).



3M-Matic™ 100a Adjustable Case Sealer, Type 29600

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

3M sells its **3M-Matic™ 100a Adjustable Case Sealer, Type 29600** with the following warranties:

1. The Taping Head knife, springs and rollers will be free from all defects for ninety (90) days after delivery.
2. All other Taping Head parts will be free from all defects for three (3) years after delivery.
3. The gearmotor will be free from all defects for one (1) year after delivery.
4. All other parts will be free from all defects for ninety (90) days 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 – 100a Adjustable Case Sealer

- | | |
|-----|---|
| (1) | 100a Adjustable Case Sealer, Type 29600 |
| (1) | Upper Tape Drum/Bracket/Hardware |
| (1) | Tool/Spare Parts Kit |
| (1) | Instruction and Parts Manual |

Important Safeguards

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

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 78-8098-9072-2 is available as a stock item or individual labels can be ordered. See Parts Illustration/List, Section I, pages 50 and 51.

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

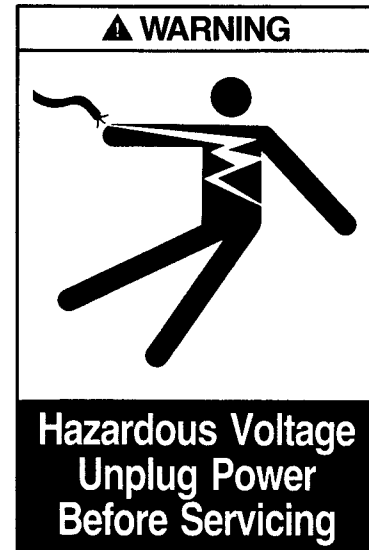


Figure 1-2 – Electrical Warning Label

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

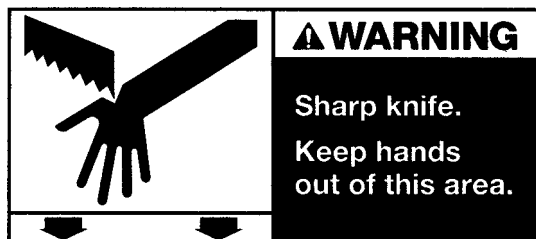


Figure 1-1 – Knife Warning Label

The "**Caution – Pinch Point**" label, shown in **Figure 1-3**, is attached to the center plate at the exit end of the machine bed. The label warns the operator to keep hands out of this area when the drive belts are running.

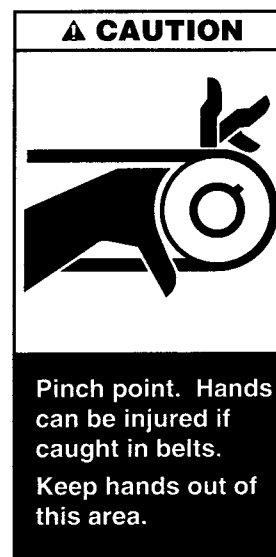


Figure 1-3 – Pinch Point Caution Label

Important Safeguards (Continued)

The 100a is equipped with a red emergency stop switch located on the top/front of the upper ski assembly. The **"Stop"** label, shown in **Figure 1-4**, is located near the switch and reminds operators and casual personnel of the function of this switch. In addition, an **"On/Off"** label is attached next to the electrical On/Off switch on the side of the machine.

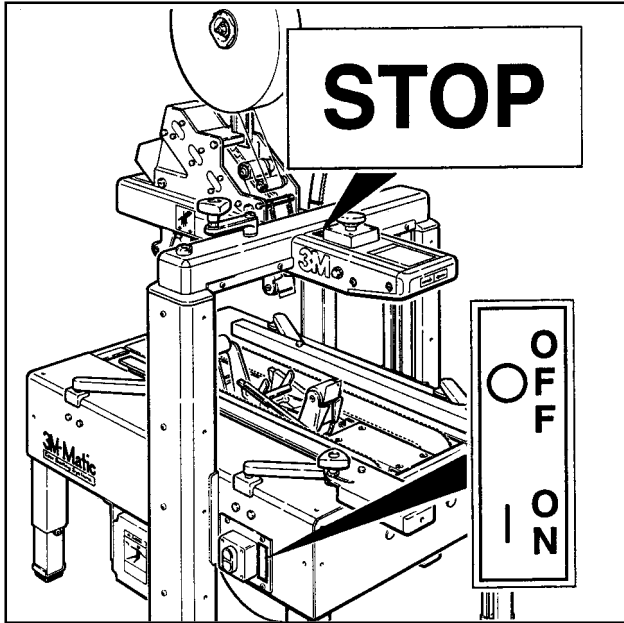


Figure 1-4 – Stop and On/Off Labels

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

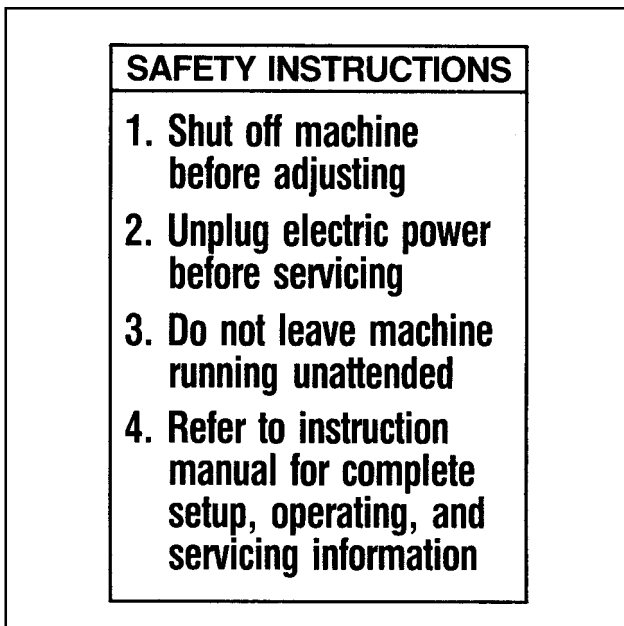


Figure 1-5 – Safety Instruction Label

The **"Center Box Here"** label, shown in **Figure 1-6**, is attached to the front of the upper frame to remind the operator of the proper box placement procedure.

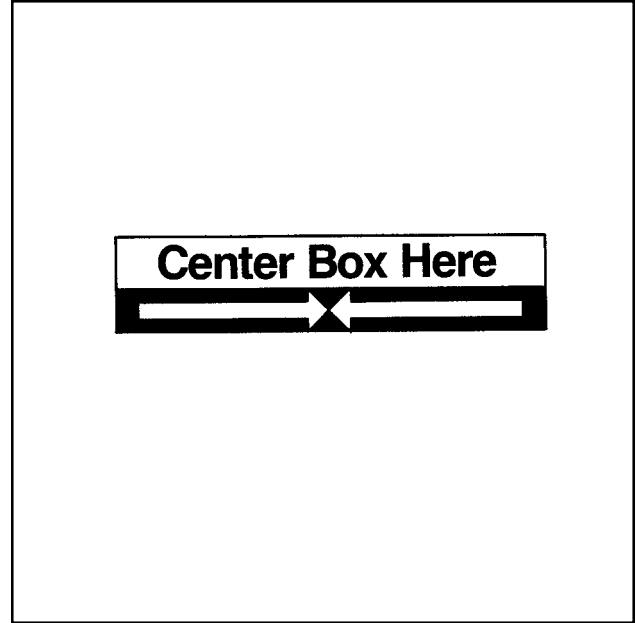


Figure 1-6 – Center Box Label

The **"Up/Down"** label, shown in **Figure 1-7**, is located on the top surface of the upper column assembly next to the height adjustment crank. The label reminds the operator of the direction to turn the height adjustment crank to raise and lower the upper ski/taping head.

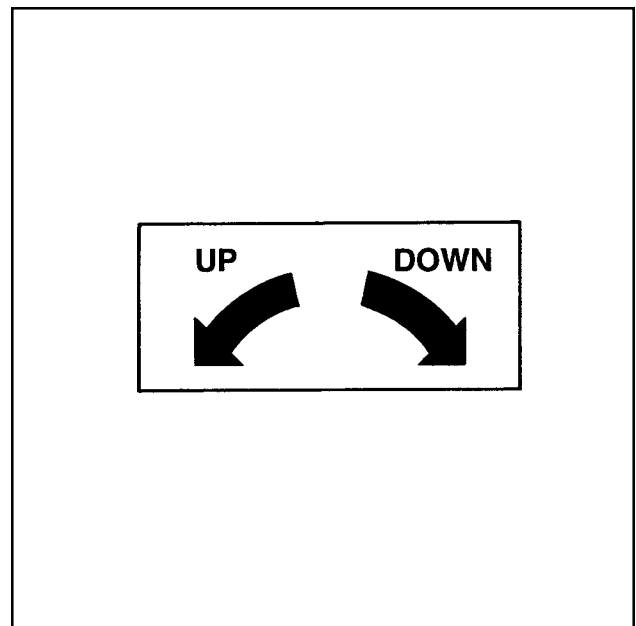


Figure 1-7 – Up/Down Label

Important Safeguards (Continued)

The following two labels are located on the upper and lower taping heads. Replacement part numbers for these labels are listed in Section II.

The **"Warning – Sharp Knife"** label warns operators and service personnel of the extremely sharp knife used to cut the tape at the end of the box sealing operation. The label, shown in **Figure 1-8**, is located on the orange knife guard between the applying roller assembly and the buffing roller assembly. **Never operate taping head with knife guard removed.**

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

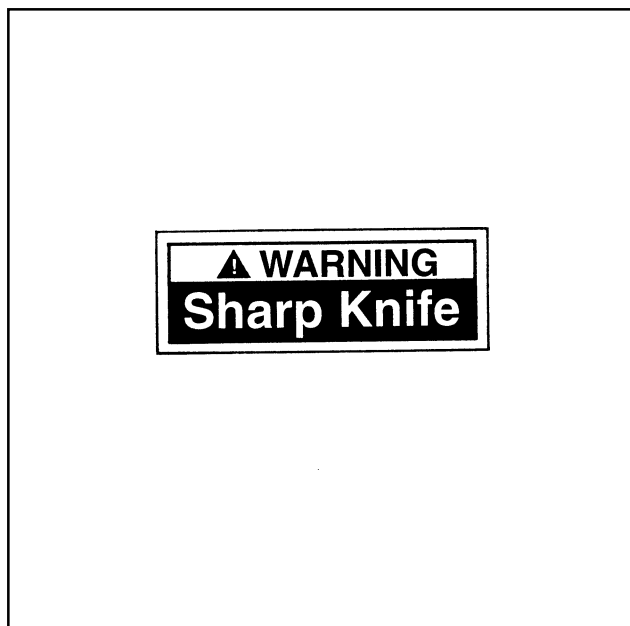


Figure 1-8 – Knife Warning Label

The **"Tape Threading Label"**, shown in **Figure 1-9**, is attached to the left side of both the upper and lower taping heads. This label provides a convenient tape threading diagram. More detailed tape loading and threading information is provided in Section II of this manual.

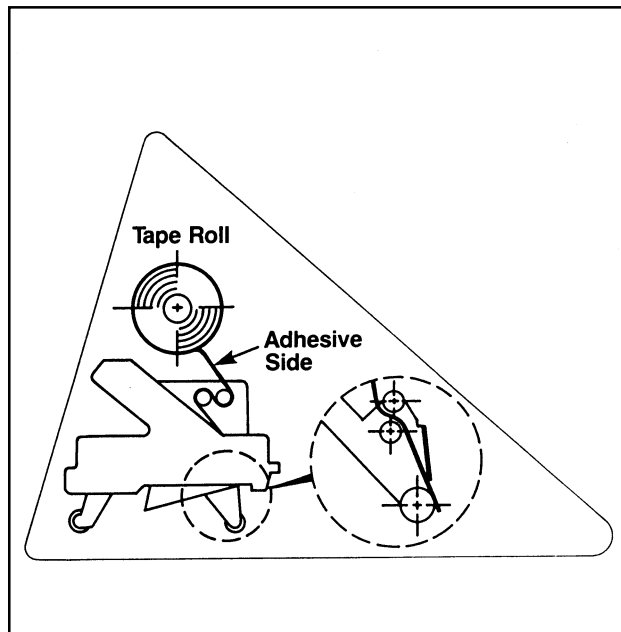


Figure 1-9 – Tape Threading Label

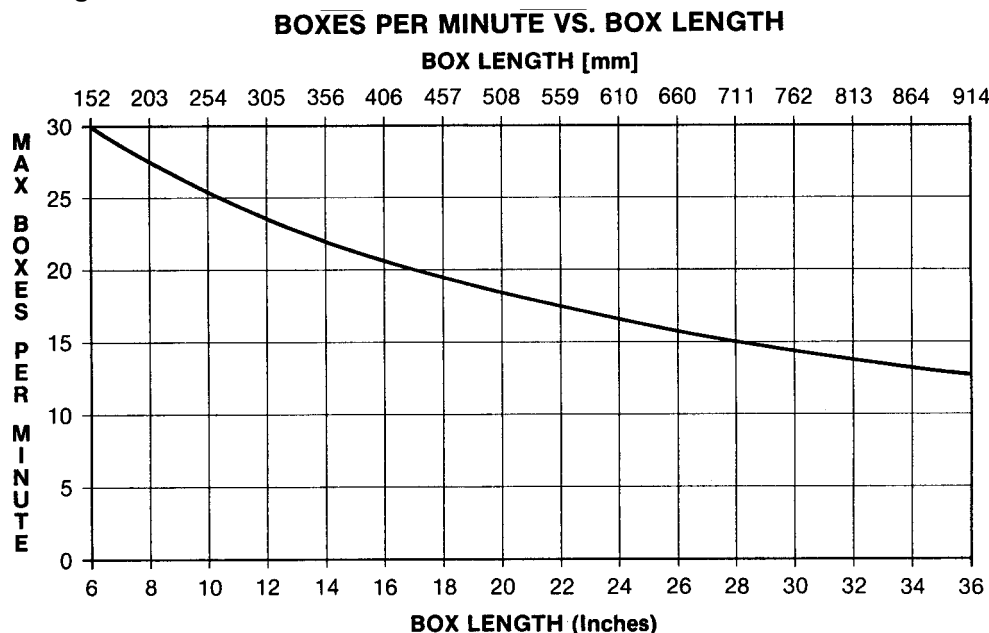
Specifications

1. **Power Requirements:**

Electrical - 115 VAC, 60 Hz, 2.9 A (340 watts)

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

2. **Operating Rate:**



Actual production rate is dependent on operator's dexterity .
Boxes must be 455 mm [18 in.] apart minimum.
Box drive speed is approximately 0.4 m/s [78 ft./min.].

3. **Operating Conditions:**

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

IMPORTANT SAFEGUARD

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

(Specifications continued on next page)

Specifications (Continued)

6. Tape Roll Diameter:

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

7. Tape Application Leg Length – Standard:

70 mm ± 6 mm [2.75 inch ± 0.25 inch]

Tape Application Leg Length – Optional:

50 mm ± 6 mm [2 inch ± 0.25 inch]

(See "Special Set-Up Procedure – Changing the Tape Leg Length", Page 23.)

8. Box Board:

Style – regular slotted containers – RSC

125 to 275 P.S.I. bursting test, single wall or double wall B or C flute.

9. Box Weight and Size Capacities:

For use with center seam regular slotted containers.

A. Box Weight, filled – 2.3 kg [5 lbs.] **minimum**, 38.6 kg [85 lbs.] **maximum**.

B. Box Size:	Minimum	Maximum
Length –	150 mm [6.0 inch]	Unlimited
Width –	150 mm [6.0 inch]*	550 mm [21.5 inch]
Height –	130 mm [4.8 inch]**	550 mm [21.5 inch]

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

** 90 mm [3.5 inch] height with heads adjusted to apply 50 mm [2 inch] tape leg lengths. (See "Special Set-Up Procedure – Changing the Tape Leg Length", Page 23.)

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

Note: The case sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is .75 or less, then several boxes should be test run to assure proper machine performance.

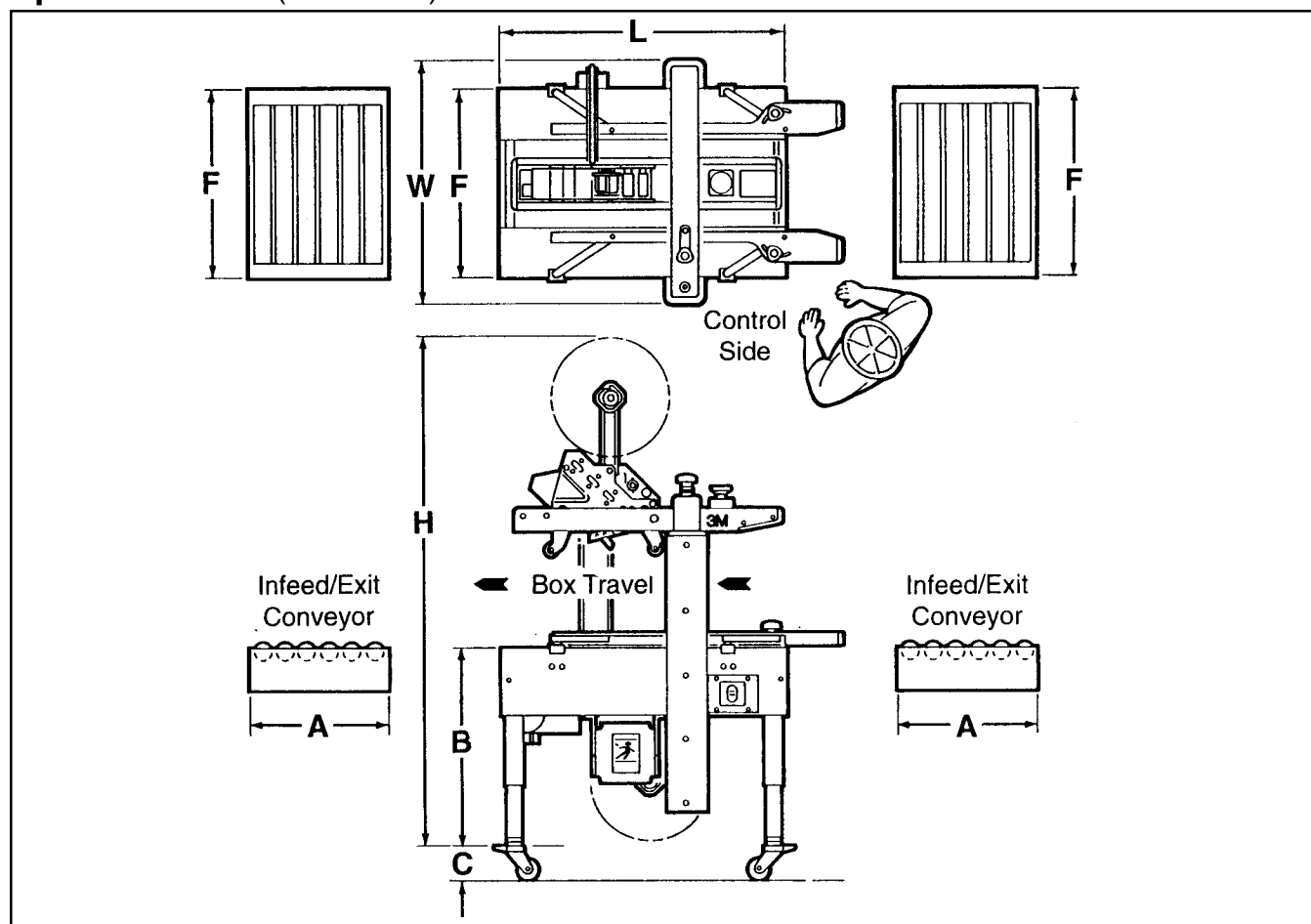
DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

BOX LENGTH IN DIRECTION OF SEAL **MUST BE GREATER THAN .75**
BOX HEIGHT

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

(Specifications continued on next page.)

Specifications (Continued)



10. Machine Dimensions:

	W	L	H	A*	B	C**	F
Minimum							
mm	--	--	1320	--	570	--	--
[Inches]	--	--	[52]	--	[22 1/2]	--	--
Maximum							
mm	790	903	2190	460	760	100	620
[Inches]	[31]	[36 1/2]	[86]	18	[30]	4	24 1/2

* Infeed/Exit conveyors are optional

** Casters are optional

Weight – 120 kg [265 lbs] crated (approximate)
102 kg [225 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

Important – Read "Warnings", on page 14, before attempting to set-up the case sealer for operation.

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

PACKAGING AND SEPARATE PARTS

1. Lift fiberboard cover off pallet after removing staples at bottom.
2. Remove protective wrapping around machine.
3. Remove the hold-down strapping that secures the upper assembly.
4. Cut and remove cable ties on both upper and lower taping heads. (Applying/buffing rollers are held retracted for shipment.)



WARNING – Follow this step carefully as spring pressure is applied to applying and buffing arms when cable tie is removed. Keep hands/fingers AWAY from tape cut-off blade under orange blade guard. Blade is extremely sharp and can cause severe injury.

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

Installation and Set-Up (Continued)

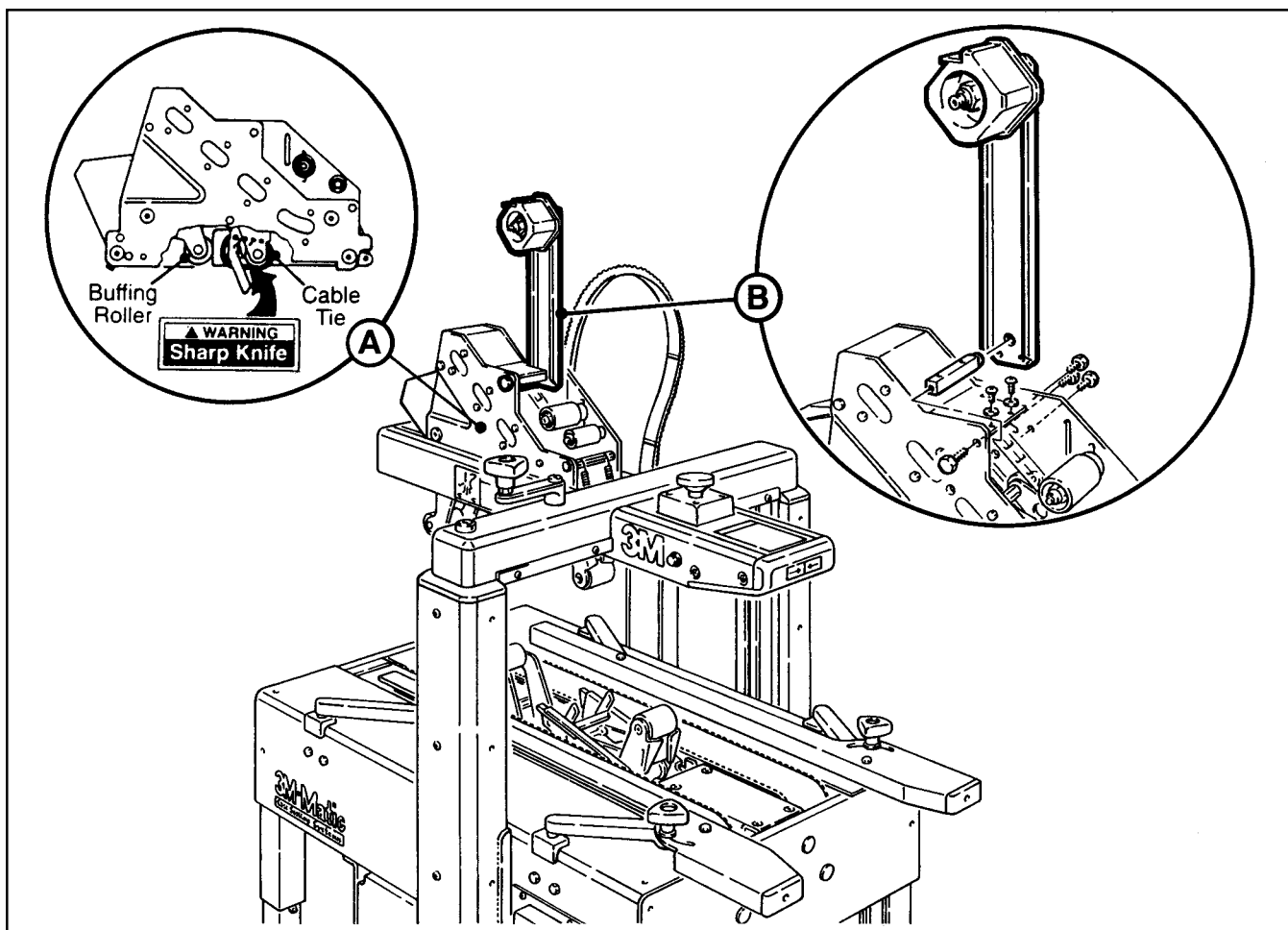


Figure 2-1 – 100a Frame Set-Up

5. Check for free action of both upper and lower taping heads.



WARNING – Keep hands/fingers away from tape cut-off knife under orange knife guard. Knife is extremely sharp and can cause severe injury.

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

6. Install the tape drum bracket on the upper taping head as shown in Figure 2-1B.
7. Ensure that the tape drum bracket assembly, located on the lower taping head, is mounted straight down, as shown in Figure 2-2A. The tape drum bracket assembly can be pivoted to provide tape roll clearance in certain cases.

8. Remove hardware that secures case sealer legs to pallet.

9. 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 102 kg [225 pounds] uncrated.

10. Continue with the remainder of the Installation and Set-Up procedure through page 12.

Installation and Set-Up (Continued)

MACHINE BED HEIGHT

Adjust machine bed height. The case sealer is equipped with four adjustable legs that are located at the corners of the machine frame. The legs can be adjusted to obtain different machine bed heights from 570 mm [22 1/2 in] minimum to 760 mm [30 in] maximum.

Note – When a caster kit is installed, the stop bolt on each lower (inner) leg can be removed to obtain a minimum bed height of 570 mm [22.5 in].

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

1. Use appropriate material handling equipment and/or blocking techniques to raise the machine frame to allow adequate leg adjustment.



CAUTION – Machine weighs approximately 102 kg [225 pounds] uncrated.

2. Loosen, but do not remove, two M8 x 16 socket head screws in one leg (use M6 hex wrench). Adjust the leg length for the desired machine bed height. Retighten the two screws to secure the leg. Adjust all four legs equally.

TAPE LEG LENGTH

Taping heads are pre-set to apply 70 mm [2.75 in] long tape legs. To change tape leg length to 50 mm [2.0 in], see "Special Set-Up Procedure – Changing the Tape Leg Length", page 23.

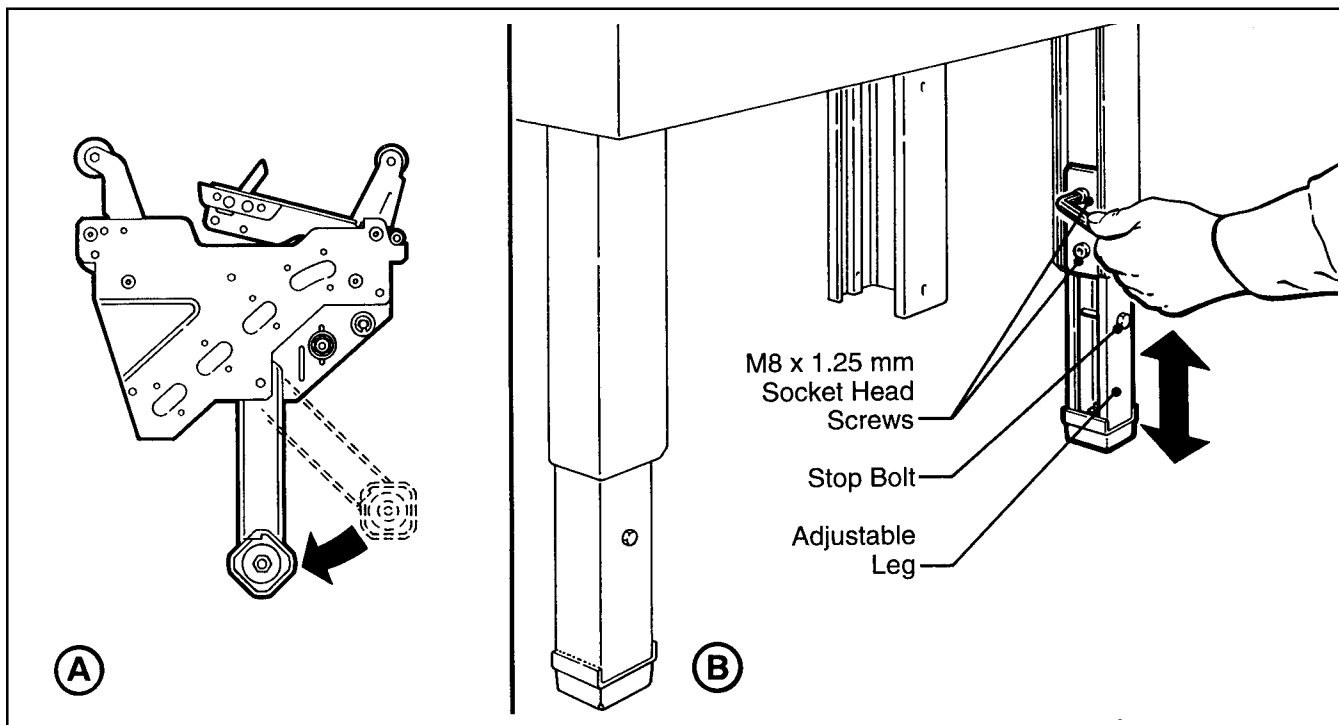


Figure 2-2 – Machine Bed Height Adjustment and Lower Tape Drum Bracket Position

Installation and Set-Up (Continued)

ELECTRICAL CONNECTION AND CONTROLS

The electrical "On/Off" switch on the side of the machine frame (Figure 3-1) can be relocated to the opposite side of the machine if desired. The electrical control box (Figure 3-1) contains the machine circuit breaker and drive motor contactor. A 2.4 meter [8 foot] standard three conductor power cord with plug is provided at the back of the electrical control box for 115 Volt, 60 Hz., 20 Amp electrical service. The receptacle providing this service shall be properly grounded. Before the power cord is plugged into 115 Volt, 60 Hz outlet make sure that all packaging materials and tools are removed from the machine. **Do not plug electrical cord into outlet until ready to run machine.**

Use of an extension cord is not recommended. However, if one is needed for temporary use, it must have a wire size of 1.5 mm dia. [AWG 16], have a maximum length of 30.5 m [100 ft], and must be properly grounded.



WARNING – To prevent shock and fire hazard: Position extension cord where it will be out of the way of foot or vehicle traffic. Extension cord is only for temporary use – do not use for a permanent installation.

Note – Machines outside the U.S. may be equipped with 220/240 Volt, 50 Hz systems or other electrical requirements compatible with local practice.

INITIAL START-UP OF CASE SEALER

After completing the "Installation and Set-Up" procedure, continue through "Operation" for tape loading and start-up to be sure case sealer is properly adjusted to run boxes

Operation

IMPORTANT – Before operating the case sealer, read the "Important Safeguards", pages 3-5 and "Warnings" on page 14 as well as all of the "Operation" instructions.

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

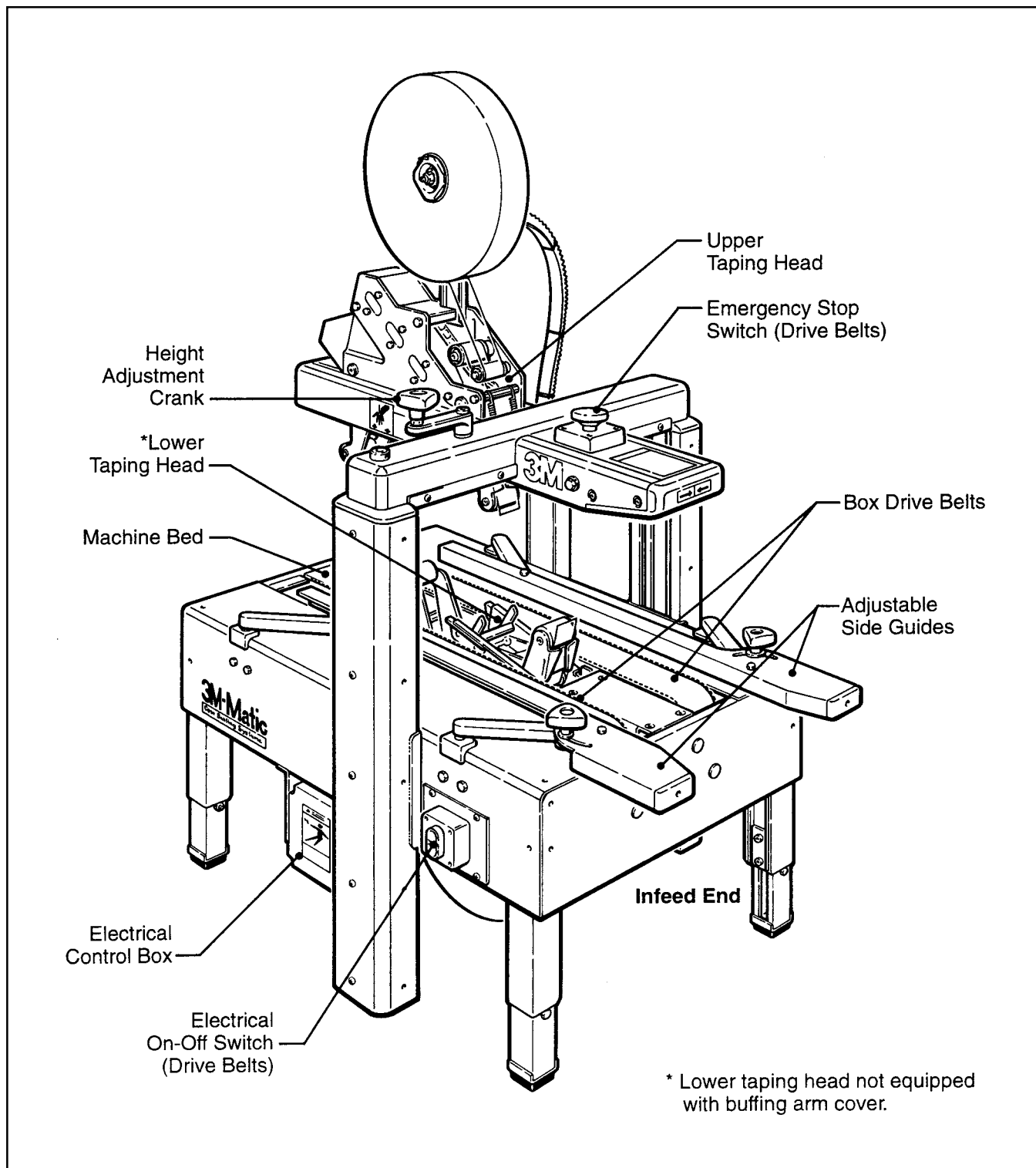


Figure 3-1 – 100a Case Sealer Components (Left Front View)

Operation (Continued)



WARNINGS

1. Turn electrical supply off and disconnect before servicing taping heads or performing any adjustments or maintenance on the machine.
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.
5. 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.
6. Never attempt to work on any part of the machine, load tape or remove jammed boxes from the machine while machine is running.
7. When feeding boxes to the machine by hand, push box in from end only – DO NOT PUSH WITH HANDS ON ANY CORNER OF THE BOX.
8. Both the upper and lower taping heads utilize extremely sharp 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.
9. Turn drive belts "Off" when machine is not in use.
10. Failure to comply with these warnings could result in severe personal injury and/or equipment damage.

Electrical "On/Off" Switch

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

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

Emergency Stop Switch

Pressing the emergency stop switch at the top/front of the upper frame assembly will stop the machine drive belts. If the emergency stop switch is pressed, it must be rotated clockwise to return it to normal operating position. Machine can then be restarted by pressing green (1) "On" button on side of machine frame.

Tape Loading/Threading

See Section II, pages 7 and 8

Operation (Continued)

Box Size Set-Up

1. ADJUST UPPER TAPING HEAD

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

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

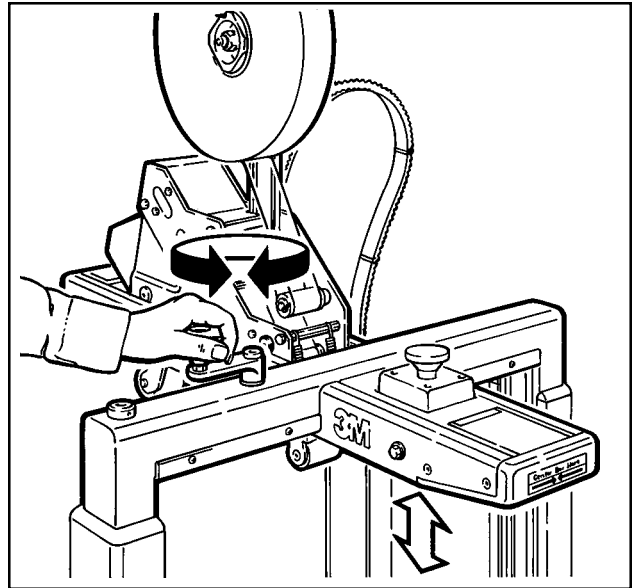


Figure 3-2 – Upper Taping Head

2. ADJUST SIDE GUIDES (Figure 3-4)

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

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

Tighten hand knobs to secure side guides.

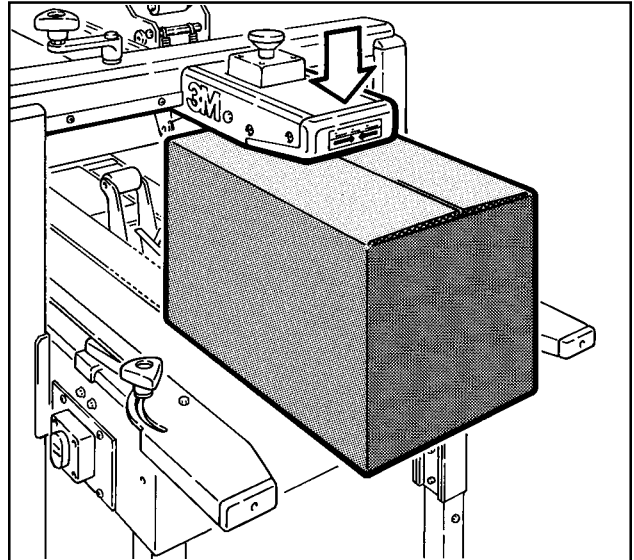


Figure 3-3 – Upper Taping Head

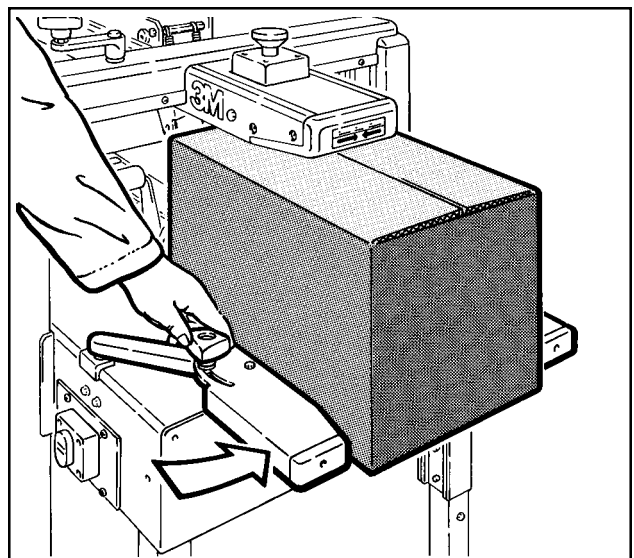


Figure 3-4 – Side Guides

Operation (Continued)

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

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

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



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

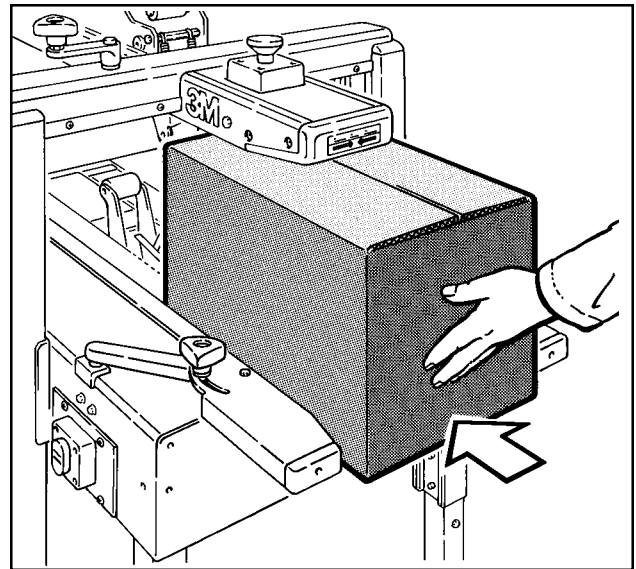


Figure 3-5 – Check Adjustments

Box Sealing

1. Feed boxes to machine at minimum 455 mm [18 inch] intervals.
2. Turn electrical supply "Off" when machine is not in use.
3. Reload and thread tape as necessary.
4. Be sure machine is cleaned and lubricated according to recommendations in "Maintenance" section of this manual.

Notes –

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

Maintenance

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



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


Cleaning

Note – Never attempt to remove dirt from taping heads by blowing it out with compressed air. This can cause the dirt to be blown inside the motor and onto sliding surfaces which may cause premature equipment wear. Never wash down or subject equipment to conditions causing moisture condensation on components. Serious equipment damage could result.

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

Lubrication

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

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

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

TAPING HEAD LUBRICATION – See Section II, "Maintenance – Lubrication", page 10.

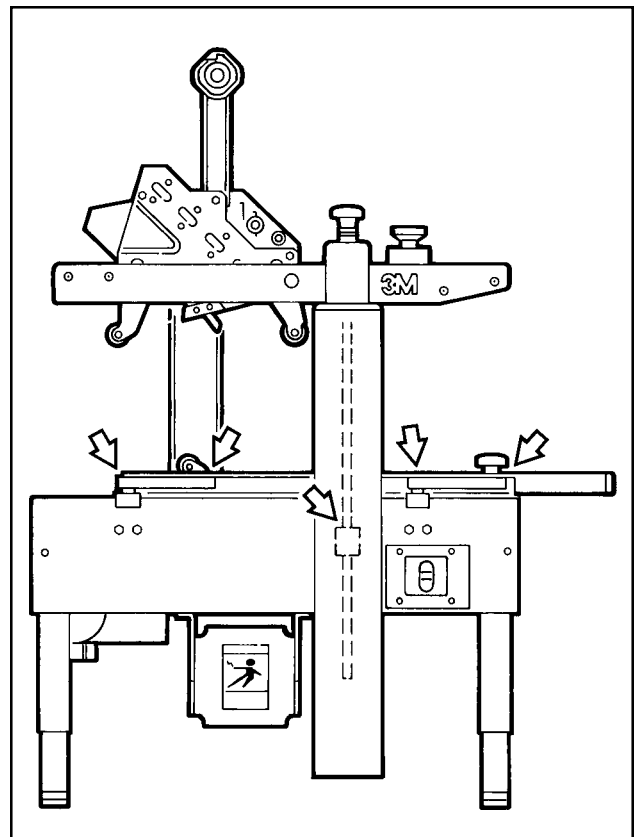


Figure 4-1 – Lubrication Points – Frame

Maintenance (Continued)



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

Circuit Breaker

The case sealer is equipped with a circuit breaker which trips if the motor is overloaded. The circuit breaker is located inside the electrical control box on the side of machine frame just below the conveyor bed.

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. Lift reset lever on circuit breaker. If circuit breaker will not reset, wait 2 minutes and try again.
4. Replace cover.
5. Plug in machine.
6. Press green (I) "On" button to resume case sealing.

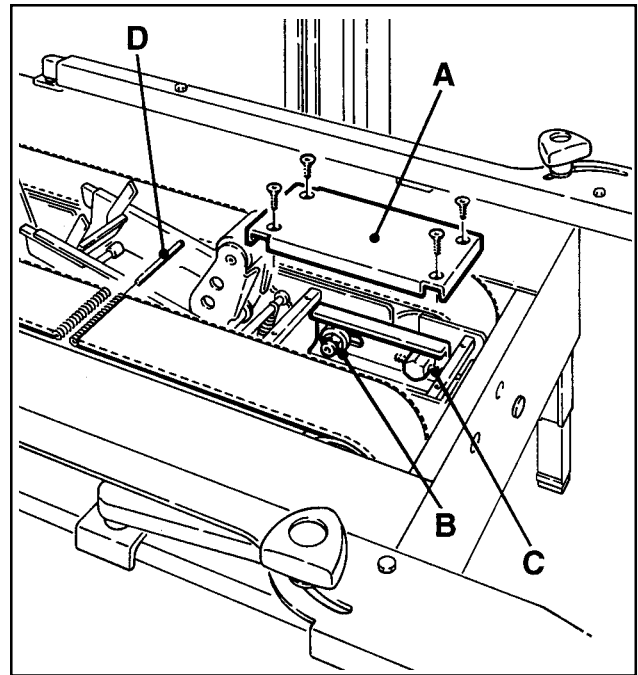


Figure 4-2 – Box Drive Belt Replacement

Knife Replacement, Taping Head

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

Box Drive Belt Replacement

Figure 4-2

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

To remove old belt:

1. Remove and retain center plate (A) and four screws.
2. Loosen, but do not remove lock nut (B).

3. Loosen tension screw (C) until all belt tension is removed.
4. Pull belt splicing pin (D) out and remove belt.
5. Place new belt over pulleys with laced splice at top. Insert splicing pin. **Note – Pin must not extend beyond edge of belt.**
6. Adjust belt tension as explained in "Adjustments - Box Drive Belt Tension", Page 19.
7. Replace the center plate and secure with original fasteners.

Adjustments



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

Box Drive Belt Tension

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

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

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

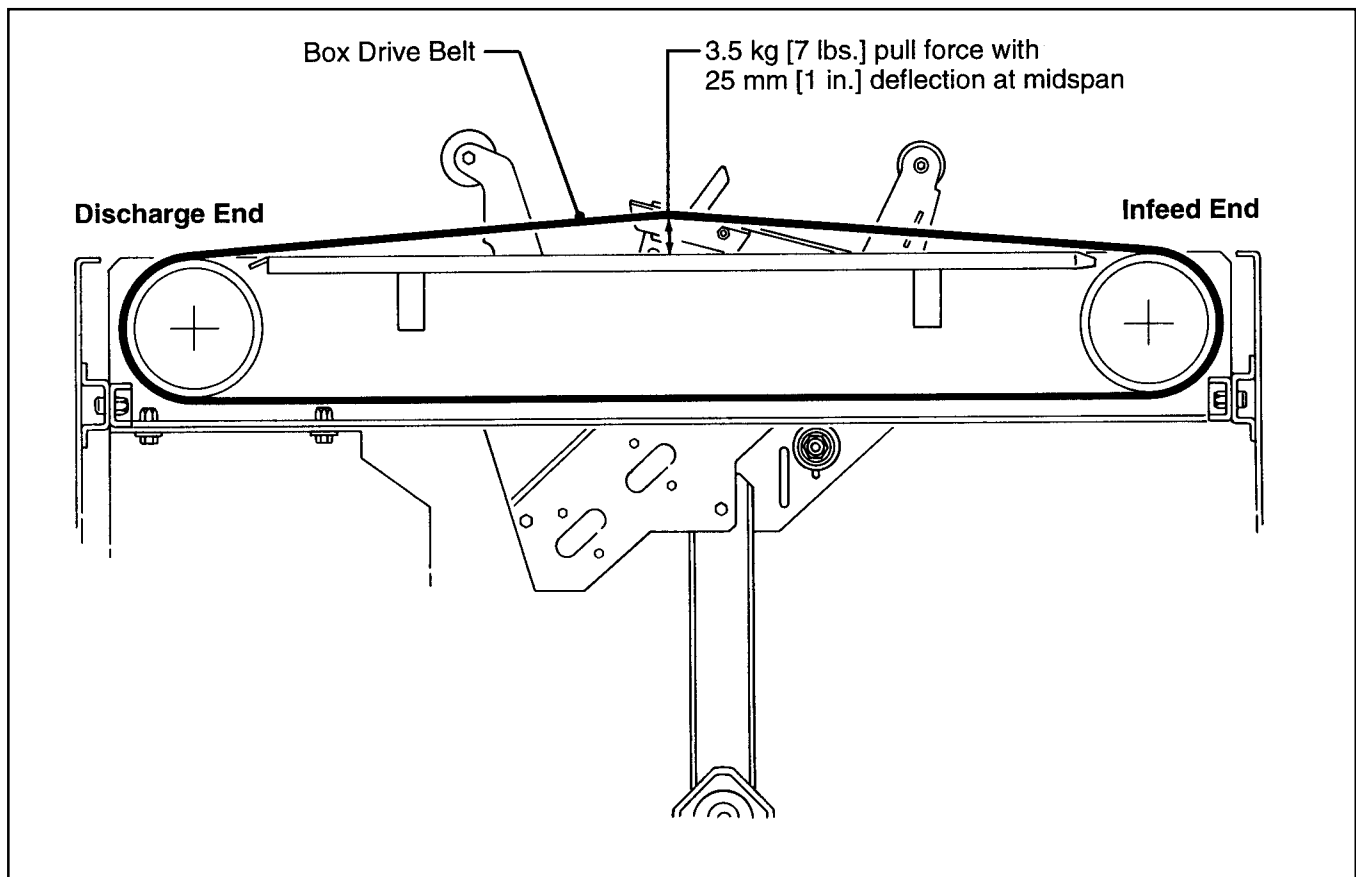


Figure 5-1 – Box Drive Belt Tension Adjustment

Adjustments (Continued)



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

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

1. Remove and retain center plate and four screws.
2. Loosen, but do not remove, M10 lock nut with a 17 mm open end wrench.
3. Reset the tension on the drive belt as needed. Use M6 hex wrench and adjust the M8 socket head tension screw in (clockwise) to **increase** tension or out (counterclockwise) to **decrease** tension. Tighten lock nut to secure tension setting.
4. Repeat this procedure for the other belt.
5. Replace center plate and secure with original screws.

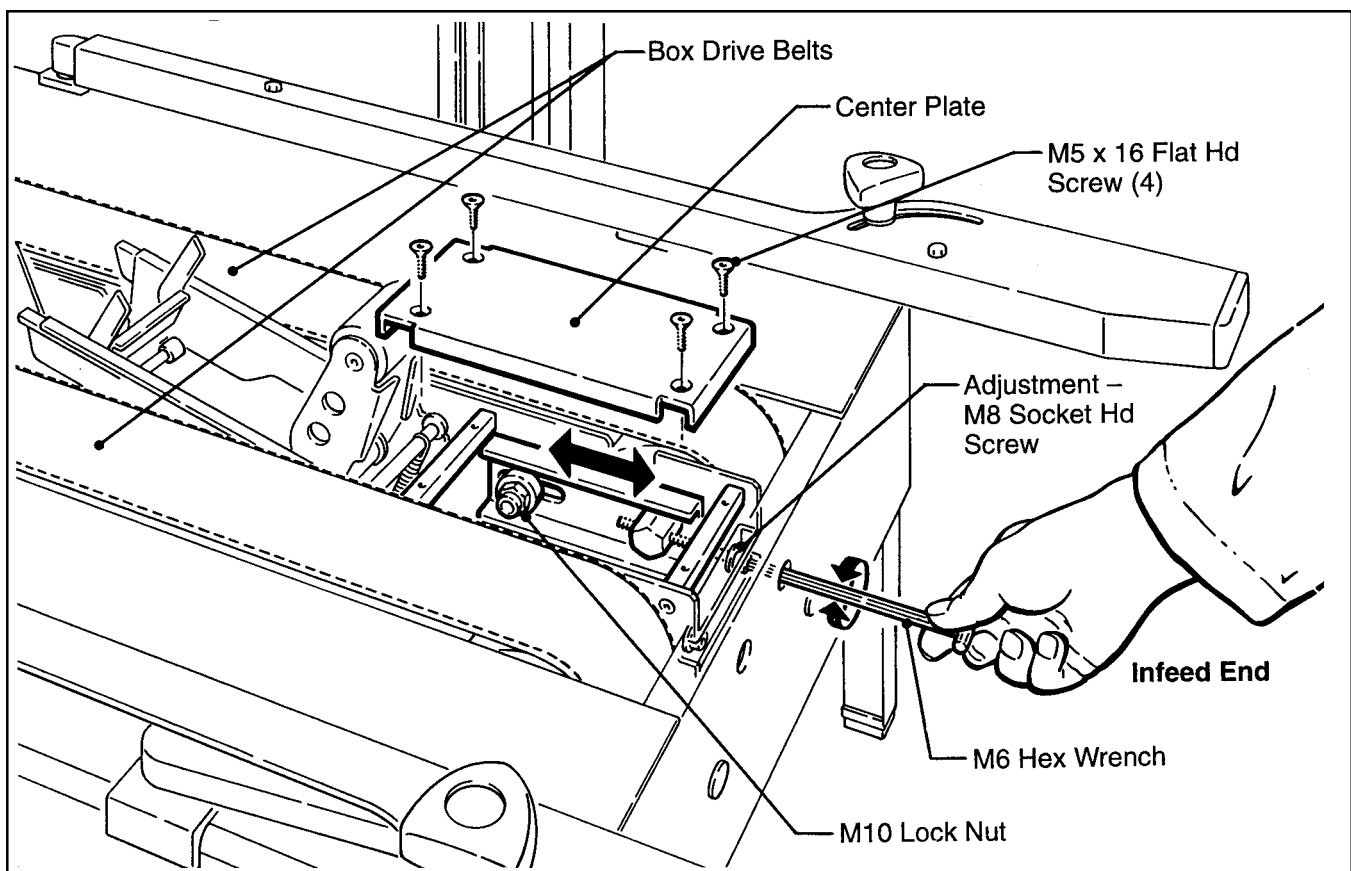


Figure 5-2 – Box Drive Belt Tension Adjustment (Machine Bed Infeed End)

Adjustments (Continued)



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

Taping Head Adjustments – Refer to Section II



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

TAPE WEB ALIGNMENT – Section II, Page 11

TAPE DRUM FRICTION BRAKE – Section II, Page 11

APPLYING MECHANISM SPRING – Section II, Page 12

ONE-WAY TENSION ROLLER – Section II, Page 12

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Special Set-Up Procedure



WARNING – Turn off electrical power 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 the Tape Leg Length

(From 70 to 50 mm [2-3/4 to 2 inch])

The following changes to the upper and lower taping heads will allow the taping of boxes 90 mm [3.5 inch] minimum height.

TAPING HEADS



WARNING – Use care when working near tape cut-off knife as knife is extremely sharp. If care is not taken, severe personal injury could result.

1. Loosen, but do not remove, the two retaining screws that secure the upper taping head shown in Figure 6-1A
2. Slide the head forward and lift straight up to remove it from the case sealer.



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

3. Lift the lower taping head, shown in Figure 6-1B, straight up to remove it from the case sealer bed.
4. Refer to Section II, "Adjustments – Changing Tape Leg Length", page 13 for taping head set-up.

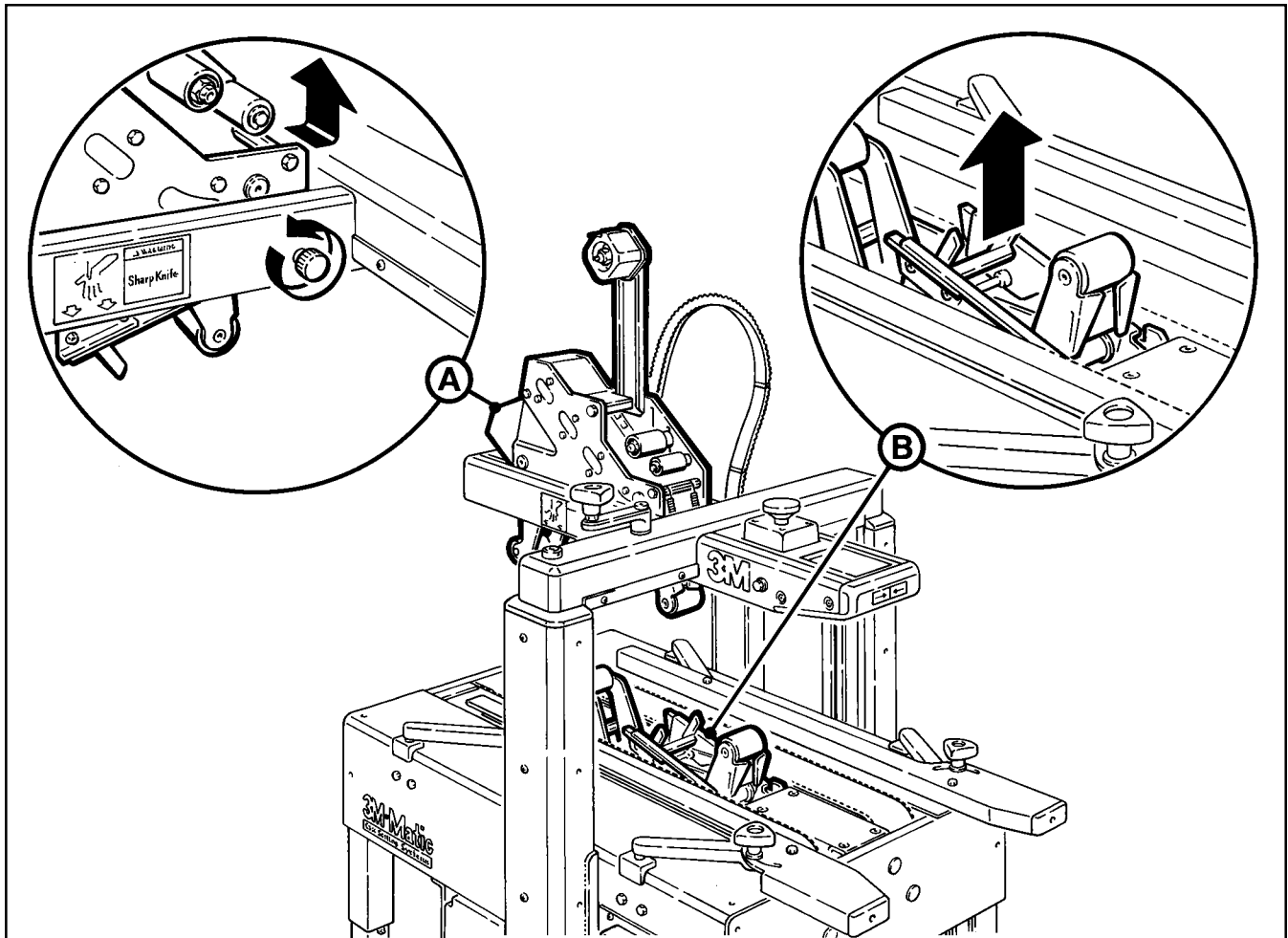


Figure 6-1 – Changing Tape Leg Length

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Troubleshooting

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

Troubleshooting Guide

Problem	Cause	Correction
Drive belts do not convey boxes	Narrow boxes	Check machine specifications. Boxes are narrower than recommended, causing slippage and premature belt wear.
	Worn drive belts	Replace drive belts
	Top taping head does not apply enough pressure	Adjust the box height adjustment with the crank
	Top flap compression rollers in too tight	Readjust compression rollers
	Taping head applying spring holder missing	Replace spring holder
Drive belts do not turn	Taping head applying spring set too high	Reduce spring pressure
	Worn or missing friction rings	Replace friction rings
	Drive belt tension too low	Adjust belt tension
	Electrical disconnect	Check power and electrical plug
	Circuit breaker tripped	Remove cause of overload and reset
Upper and lower applying mechanisms interfere with each other	Motor not turning	Evaluate problem and correct
	Machine adjusted below minimum	Set taping heads to apply 2 inch leg lengths
Drive belts break	Worn belt	Replace belt
	Excessive belt tension	Tension to 7 lbs. per adjustment section
Light boxes tip back on exit	Upper ski down too far	Carefully adjust upper ski
Squeaking noise as boxes pass through machine	Dry column bearings	Lubricate column bearings
	Defective column bearings	Replace column bearings

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Electrical Diagram



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

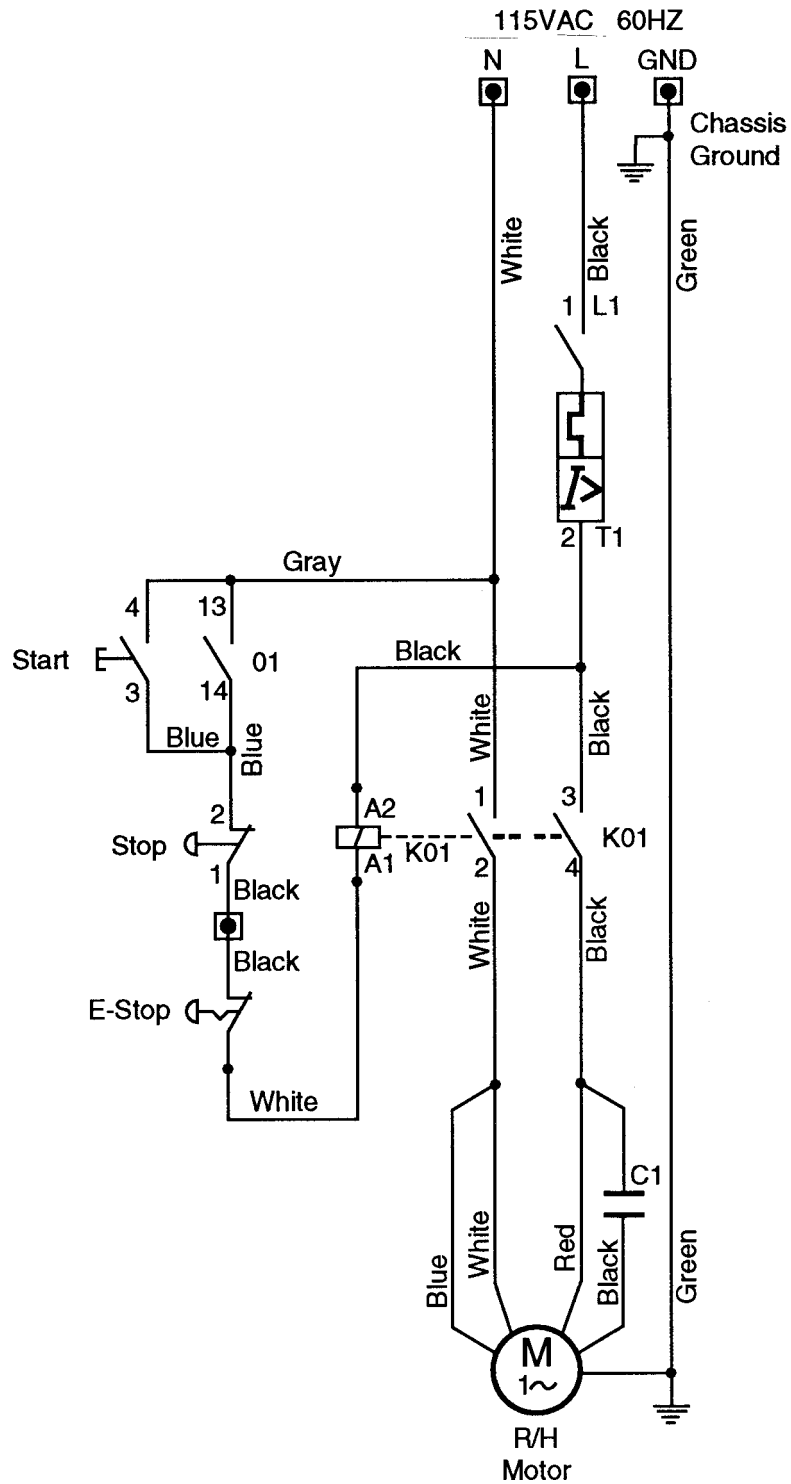


Figure 7-1 – Electrical Diagram

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Replacement Parts And Service Information

Spare Parts

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

Qty.	Ref. No.	Part Number	Description
2	3289-68	78-8070-1531-4	Belt - Drive W/Pin

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 78-8098-9072-2, is available as a stock item. It contains all the safety labels used on the 100a Adjustable Case Sealer.

Tool Kit

A tool kit, part number 78-8098-8942-7, is available as a stock item. The kit contains the necessary open end and hex socket wrenches for use with the metric fasteners on the case sealer. The threading tool, part number 78-8076-4726-4, contained in above kit is also available as a replacement stock item.

Replacement Parts Ordering Information and Service

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

Options/Accessories

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

Part Number	Option/Accessory
78-8052-6553-1	Box Hold Down Attachment, Model 18500
78-8069-3983-7	Caster Kit Attachment
78-8069-3924-1	Conveyor Extension 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
78-8079-5505-5	Three Flap Folder Kit
78-8095-4854-4	2-Inch Tape Edge Fold Attachment, Upper Head
78-8095-4855-1	2-Inch Tape Edge Fold Attachment, Lower Head
78-8079-5560-0	Tape Application Sensor Kit

Replacement Parts – Illustrations and Parts Lists

100a Adjustable Case Sealer, Type 29600 Frame Assemblies

To Order Parts:

1. Refer to first illustration, **Frame Assemblies**, page 33 for the **Figure Number** that identifies a specific portion of the machine.
2. Refer to the appropriate **Figure or Figures** to determine the parts required and the parts reference number.
3. The Parts List that follows each illustration, includes the **Reference Number, Part Number** and **Part Description** for the parts on that illustration.

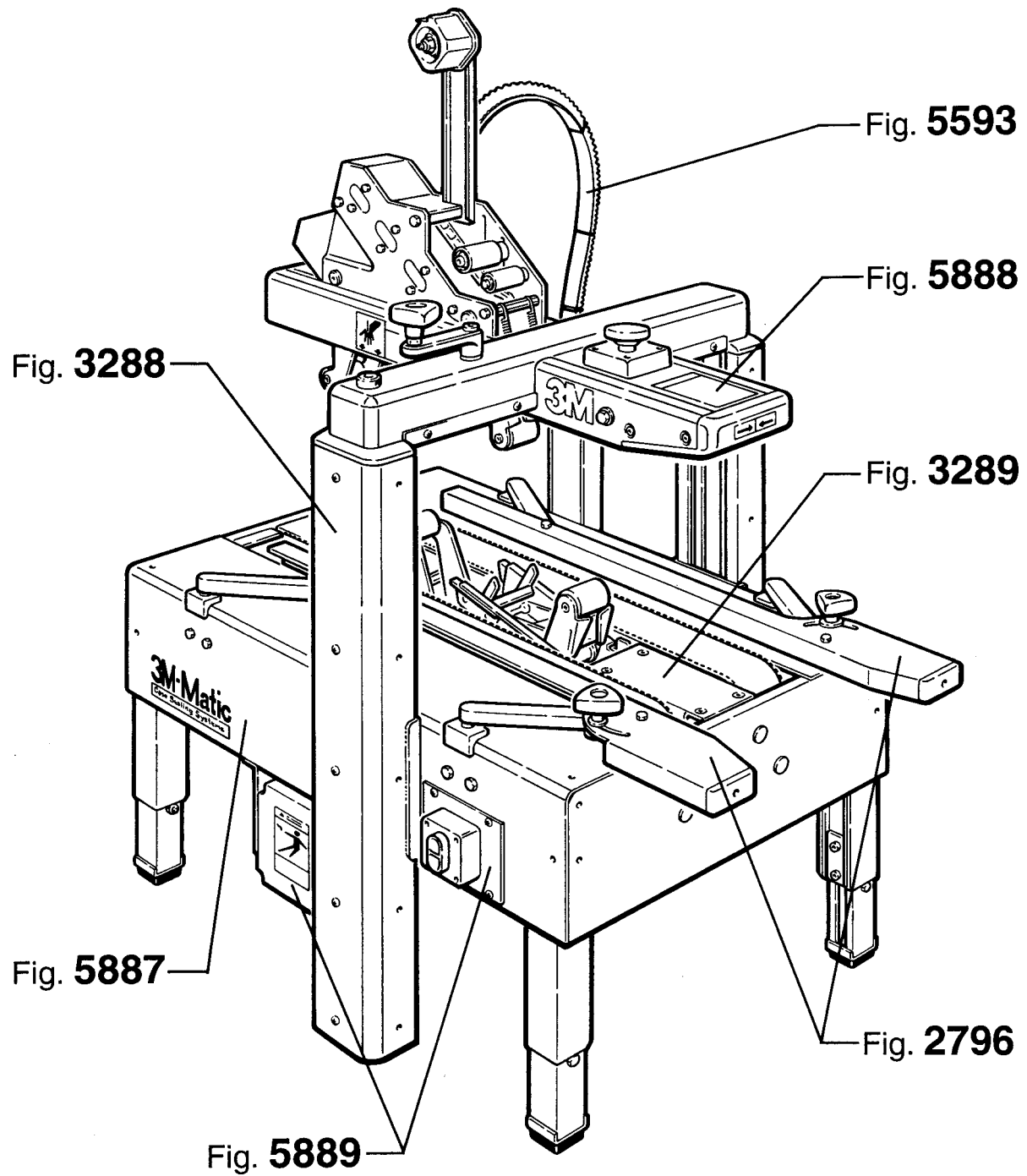
Note – The complete description has been included for standard fasteners and some commercially available components. This has been done to allow obtaining these standard parts locally, if desired.

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

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

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100a Adjustable Case Sealer



Frame Assemblies

100a Adjustable Case Sealer

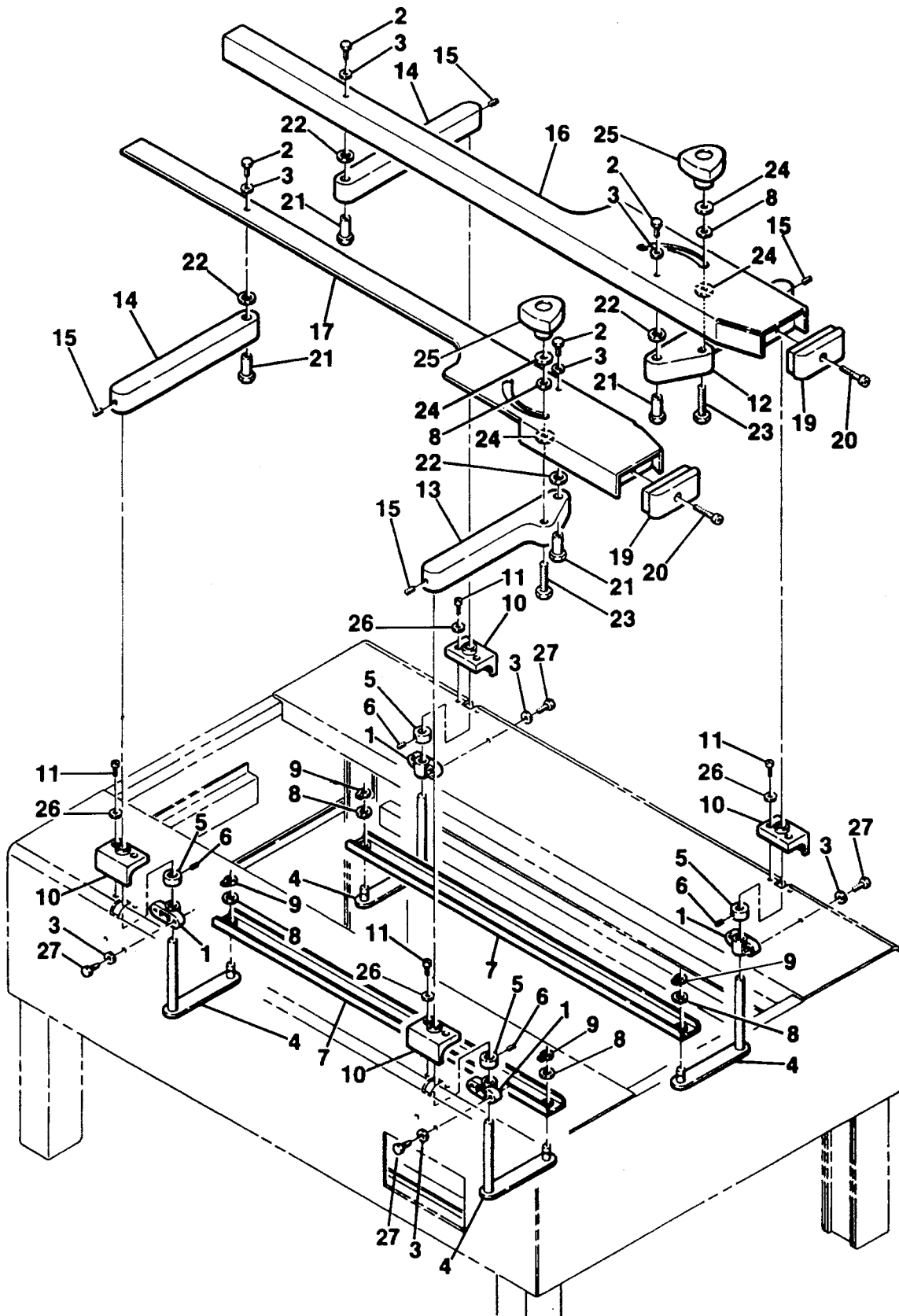


Figure 2796

Figure 2796

Ref. No.	3M Part No.	Description
2796-1	78-8070-1536-3	Support – Guide Arm
2796-2	78-8010-7169-3	Screw – Hex Hd, M6 x 12
2796-3	26-1000-0010-3	Washer – Flat, M6
2796-4	78-8070-1537-1	Lever With Pivot
2796-5	78-8070-1538-9	Bushing
2796-6	26-1003-8816-9	Screw – Set, M5 x 6
2796-7	78-8070-1539-7	Link – Guide
2796-8	78-8017-9074-8	Washer – 15 mm, Nylon
2796-9	78-8052-6733-9	Ring – M10, Special
2796-10	78-8070-1540-5	Support – Lever
2796-11	78-8032-0382-3	Screw – Soc Hd, M5 x 16
2796-12	78-8070-1541-3	Guide Arm – Front, Right
2796-13	78-8070-1542-1	Guide Arm – Front, Left
2796-14	78-8070-1543-9	Guide Arm – Rear
2796-15	78-8076-4505-2	Screw – Set, M6 x 8
2796-16	78-8070-1544-7	Guide – Right
2796-17	78-8070-1545-4	Guide – Left
2796-19	78-8070-1546-2	Cap – Guide
2796-20	26-1003-7953-1	Screw – Soc Hd, M5 x 30
2796-21	78-8070-1547-0	Shaft - Guide
2796-22	78-8070-1548-8	Washer – 20 x 12, 5 x 1 Nylon
2796-23	26-1003-5852-7	Screw – Hex Hd, M10 x 40
2796-24	26-1004-5510-9	Washer – Plain, M10
2796-25	78-8070-1549-6	Knob – VTR-B-M10
2796-26	78-8005-5735-3	Washer – Lock, M5
2796-27	78-8032-0375-7	Screw – Hex Hd, M6 x 16

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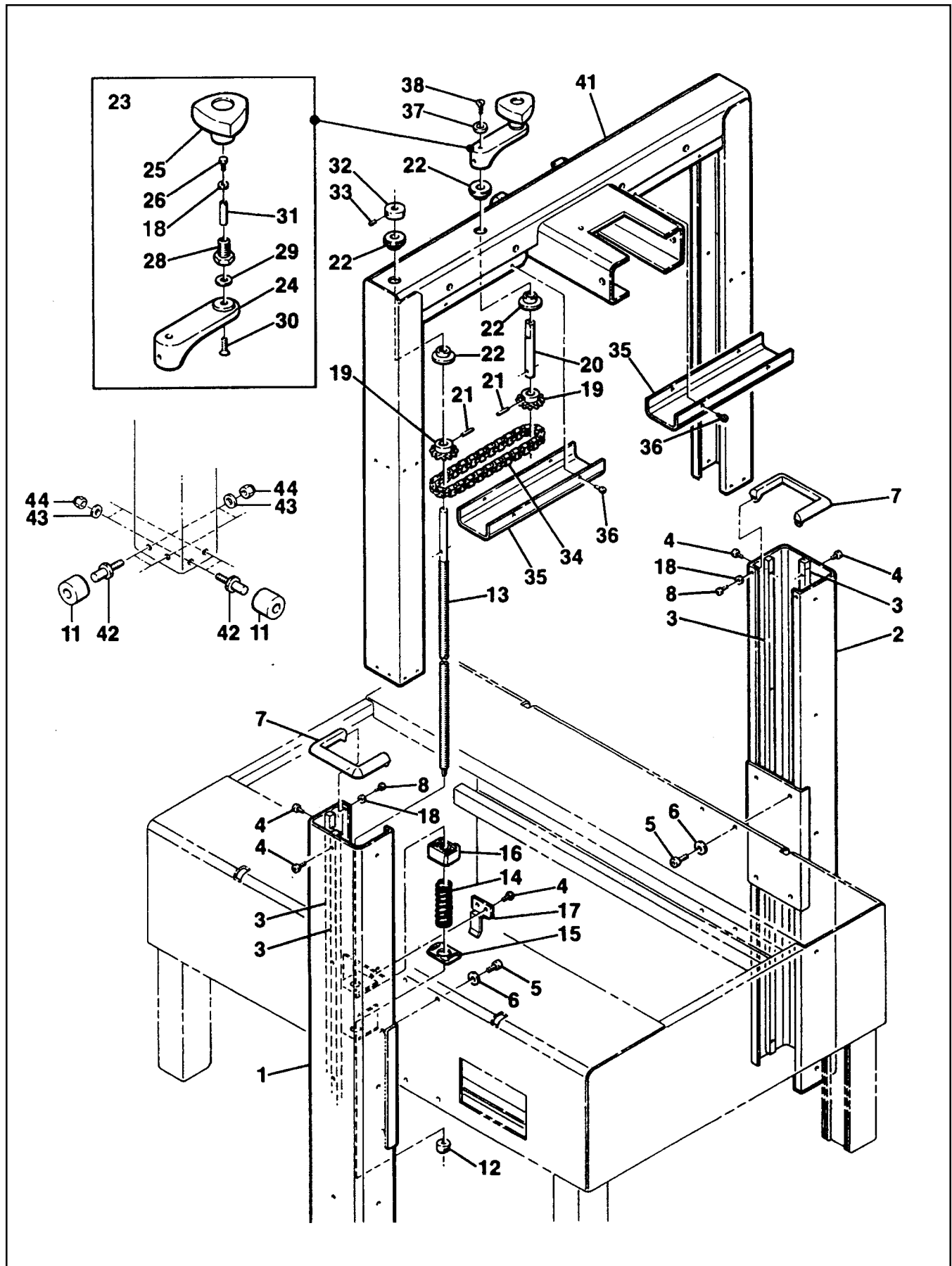


Figure 3288

Figure 3288

Ref. No.	3M Part No.	Description
3288-1	78-8091-0669-9	Column Assembly – Outer L/H
3288-2	78-8079-5133-6	Column Assembly – Outer R/H
3288-3	78-8079-5134-4	Guide – Outer Column
3288-4	78-8060-8087-1	Screw – M5 x 10, Metric
3288-5	78-8091-0656-6	Screw – Hex Soc Hd M8 x 12
3288-6	78-8005-5736-1	Lockwasher – For M8 Screw
3288-7	78-8079-5135-1	Cap – Column
3288-8	26-1002-4955-1	Screw – 8P x 13 Self-Tap
3288-11	78-8076-5481-5	Roller – Column
3288-12	78-8054-8968-5	Nut – Special
3288-13	78-8079-5139-3	Lead Screw
3288-14	78-8054-8969-3	Spring
3288-15	78-8054-8970-1	Bed Plate For Spring
3288-16	78-8054-8571-7	Nut – Plastic
3288-17	78-8076-5482-3	Plate – Nut Stop
3288-18	78-8005-5740-3	Washer – Plain 4 mm
3288-19	78-8079-5140-1	Sprocket – Screw, 3/8
3288-20	78-8079-5141-9	Shaft – Crank
3288-21	78-8079-5142-7	Spring Pin – 4 x 26 Collar
3288-22	78-8079-5168-2	Collar
3288-23	78-8076-4807-2	Crank Assembly
3288-24	78-8076-5422-9	Crank
3288-25	78-8070-1512-4	Knob – VTR-B-M12
3288-26	78-8010-7157-8	Screw – Hex Hd, M4 x 10
3288-28	78-8070-1511-6	Bushing
3288-29	78-8070-1510-8	Washer – Nylon 7 x 15 x 1
3288-30	26-1005-5316-8	Screw – Flat Hd, Hex Dr, M5 x 16
3288-31	78-8070-1509-0	Shaft – Crank
3288-32	78-8070-1538-9	Bushing
3288-33	78-8091-0354-8	Screw – Set, M5 x 6
3288-34	78-8060-8020-2	Chain – 3/8 Inch Pitch, L=50
3288-35	78-8079-5144-3	Cover – Chain
3288-36	26-1002-5753-9	Screw – Self-Tapping
3288-37	78-8076-4809-8	Washer – Crank
3288-38	78-8032-0375-7	Screw – Hex Hd M6 x 16
3288-41	78-8091-0505-5	Bar – Supporting
3288-42	78-8091-0324-1	Screw – Special
3288-43	26-1000-0010-3	Washer – Flat M6
3288-44	26-1003-6916-9	Nut – Locking Plastic Insert M6

Drive Pulley Assy.
(See Fig. 3289/2 of 2)

Bottom Drive Assy.
(See Fig. 3289/2 of 2)

***Motor**

***Not included with Ref. No. 1.**

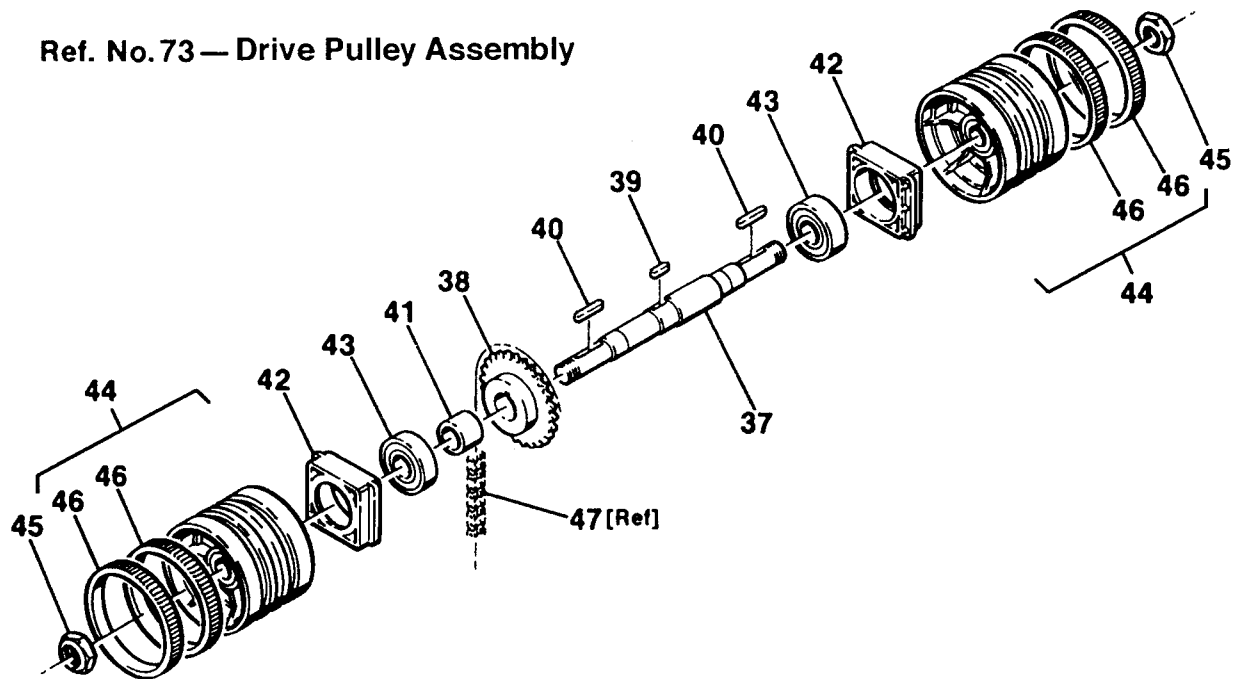
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Figure 3289 (page 1 of 2)

Ref. No.	3M Part No.	Description
3289-1	78-8079-5146-8	Bottom Drive Assembly, w/o Motor
3289-2	78-8079-5147-6	Bottom Drive, w/o Motor
3289-3	78-8079-5148-4	Frame – R/H
3289-4	78-8079-5149-2	Frame – L/H
3289-5	78-8079-5150-0	Frame – Front
3289-6	78-8079-5151-8	Frame – Rear
3289-7	78-8017-9301-5	Screw – Hex Hd, M8 x 25
3289-8	26-1004-5507-5	Washer – M8
3289-9	78-8076-5479-9	Plate – Motor Mounting
3289-11	78-8054-8980-0	Pulley Timing Belt
3289-12	78-8054-8979-2	Housing – Bearing
3289-13	78-8028-8244-5	Key – 4 x 4 x 10 mm
3289-14	78-8079-5154-2	Sprocket
3289-15	78-8054-8877-8	Washer – 5,5/20 x 4
3289-16	26-0001-5862-1	Screw – Flat Hd Soc, M5 x 12
3289-17	78-8054-8577-4	Washer – Special
3289-18	26-1001-9843-6	Screw – Flat, Soc Hd , M6 x 16
3289-19	78-8010-7193-3	Screw – Hex Hd, M6 x 20
3289-20	78-8042-2919-9	Washer – Triple M6
3289-21	78-8060-8147-3	Reducer Pulley Assembly
3289-22	78-8054-8978-4	Reducer – Pulley
3289-23	78-8054-8988-3	Shaft – Timing Pulley
3289-24	78-8016-5855-6	E-Ring – 10 mm
3289-25	78-8017-9318-9	Washer – Plain 8 mm
3289-26	78-8017-9313-0	Nut – Self-Lock, M8
3289-27	78-8057-5724-8	Timing Belt – 187L050
3289-28	26-1003-8816-9	Screw – Set, M5 x 6
3289-29	78-8054-8982-6	Pulley – Timing 11 Teeth
3289-30	26-1003-5820-4	Screw – Hex Hd, M5 x 12
3289-31	78-8005-5741-1	Washer – Plain, M5
3289-32	78-8060-8087-1	Screw – Pan Hd, M5 x 10
3289-33	78-8054-8977-6	Spacer
3289-34	78-8054-8975-0	Spacer
3289-35	78-8079-5155-9	Belt – Timing 210L100
3289-36	78-8091-0506-3	Motor – 115V, 60Hz, 1-Phase
3289-37	78-8070-1528-0	Shaft – Gearbox
3289-38	78-8054-8986-7	Sprocket – 3/8 Inch Pitch, 28 Teeth
3289-39	78-8057-5811-3	Key – 6 x 6 x 20 mm

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Ref. No.73 — Drive Pulley Assembly



Ref. No.2 — Bottom Drive Assembly

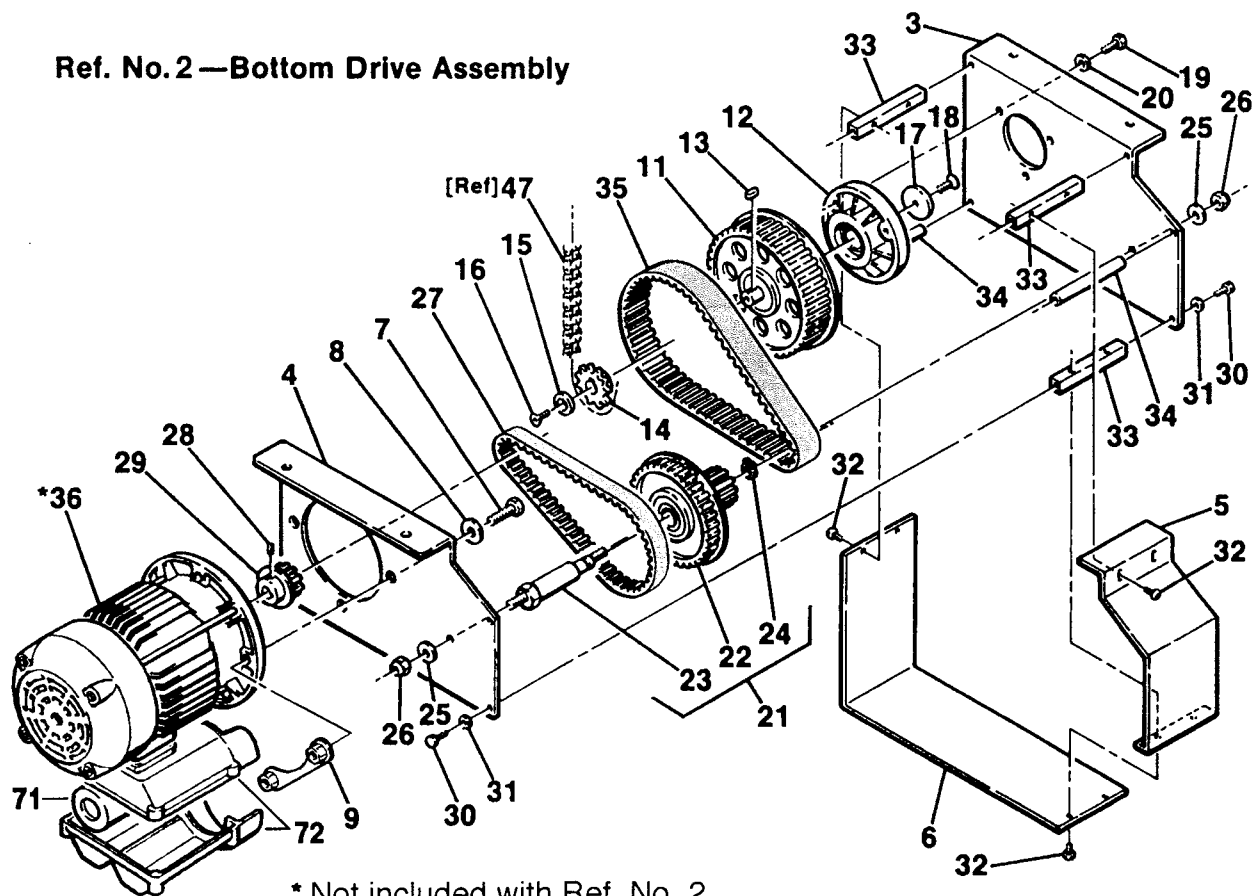


Figure 3289/2 of 2

Figure 3289 (page 2 of 2)

Ref. No.	3M Part No.	Description
3289-40	78-8057-5739-6	Key – 5 x 5 x 30 mm
3289-41	78-8054-8984-2	Bushing
3289-42	78-8070-1529-8	Support – Shaft
3289-43	78-8070-1530-6	Bearing – 6205 - 2 RS
3289-44	78-8076-5105-0	Pulley Assembly – Drive
3289-45	78-8060-8416-2	Nut – Special, M20 x 1
3289-46	78-8052-6713-1	Ring – Polyurethane
3289-47	78-8018-7709-9	Chain – 3/8 Inch Pitch
3289-50	78-8010-7435-8	Washer – Lock M6
3289-51	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
3289-52	78-8052-6709-9	Washer – Special
3289-53	78-8052-6710-7	Roller – Idler
3289-54	26-1003-6918-5	Nut – Hex M10 Plastic Insert
3289-55	78-8070-1519-9	Screw – Soc Hd Hex Hd, M8 x 70
3289-56	78-8017-9318-9	Washer – Plain M8
3289-57	78-8070-1518-1	Spacer – Shaft
3289-58	78-8070-1515-7	Spacer
3289-59	78-8070-1514-0	Spacer – W/Holes
3289-60	26-1003-5829-5	Screw – Hex Hd, M6 x 12
3289-61	26-1003-5841-0	Screw – M8 x 16
3289-62	78-8070-1520-7	Guide – Drive Belt
3289-63	78-8079-5177-3	Plate – Front
3289-64	78-8079-5128-6	Plate – Rear
3289-65	26-1005-4757-4	Screw – Flat Hd, Soc Dr. M5 x 20
3289-66	78-8079-5178-1	Frame – Drive
3289-67	78-8070-1531-4	Belt – Drive W/Hook
3289-68	26-1003-7964-8	Screw – Soc Hd, Hex Soc Dr, M8 x 20
3289-69	78-8076-4500-3	Stud – Mounting
3289-70	78-8076-4644-9	Union
3289-71	78-8091-0737-4	Capacitor – For Motor 110V
3289-72	78-8091-0738-2	Terminal Box W/Cover – Lafert Motor
3289-73	78-8070-1527-2	Shaft With Drive Pulleys
3289-74	78-8100-1236-5	Belt Tensioning Assembly – R/H
3289-75	78-8100-1237-3	Belt Tensioning Assembly – L/H
3289-76	78-8100-1238-1	Belt Tensioner – R/H
3289-77	78-8100-1239-9	Belt Tensioner – L/H

100a Adjustable Case Sealer

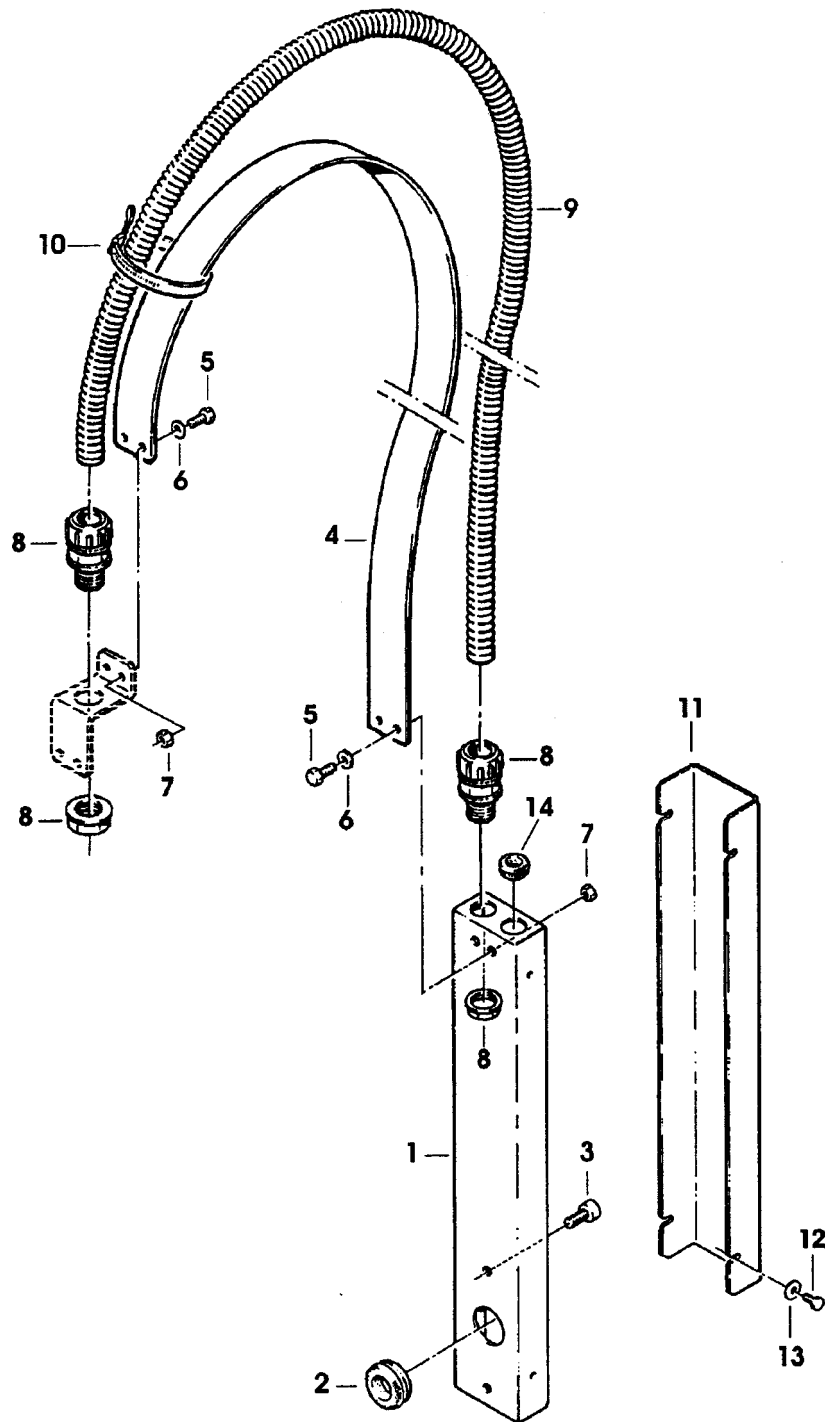


Figure 5593

Figure 5593

Ref. No.	3M Part No.	Description
5593-1	78-8091-0660-8	Housing – Wire
5593-2	78-8076-4702-5	Grommet
5593-3	26-1003-7963-0	Screw – Soc Hd, M8 x 16
5593-4	78-8076-4636-5	Strap – Wire
5593-5	78-8010-7163-6	Screw – Hex Hd, M5 x 10
5593-6	78-8005-5741-1	Washer – Flat, M5
5593-7	78-8010-7417-6	Nut – Hex, M5
5593-8	78-8060-7631-7	Connector – 3/8 Inch
5593-9	78-8060-8028-5	Sleeving – /12, 0,930 M.
5593-10	78-8060-8029-3	Clamp – 140X3,5
5593-11	78-8076-4641-5	Cover
5593-12	78-8010-7157-8	Screw – Hex Hd, M4 x 10
5593-13	78-8017-9018-5	Washer – Plain, M4
5593-14	78-8060-7758-8	Fairlead – /20

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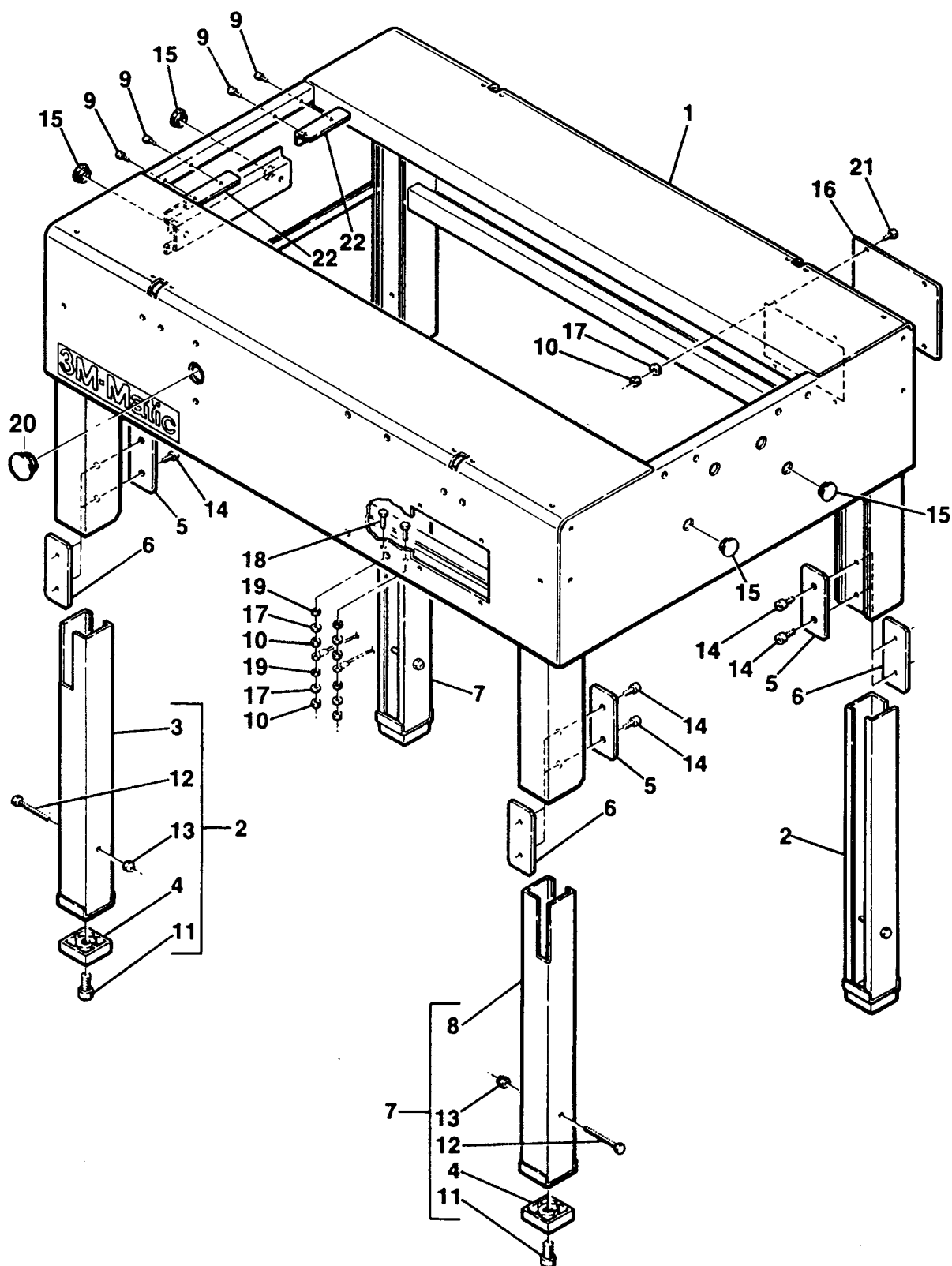


Figure 5887

Figure 5887

Ref. No.	3M Part No.	Description
5887-1	78-8079-5119-5	Bed – Conveyor
5887-2	78-8079-5120-3	Leg Assembly – Inner R/H
5887-3	78-8079-5121-1	Leg – Inner R/H
5887-4	78-8079-5122-9	Pad – Foot
5887-5	78-8079-5124-5	Clamp – Leg
5887-6	78-8079-5125-2	Clamp – Leg
5887-7	78-8079-5126-0	Leg Assembly – Inner L/H
5887-8	78-8079-5127-8	Leg – Inner L/H
5887-9	26-1003-7948-1	Screw – Soc Hd, Hex Soc, M5 x 10
5887-10	78-8010-7417-6	Nut – Hex M5
5887-11	26-1003-7985-3	Screw – Soc Hd, Hex Soc, M12 x 20
5887-12	26-1005-5318-4	Screw – Soc Hd, Hex Soc, M6 x 55
5887-13	26-1003-6916-9	Nut – Plastic Insert, M6
5887-14	26-1003-7963-0	Screw – Soc Hd, Hex Soc, M8 x 16
5887-15	78-8054-8821-6	Cap
5887-16	78-8060-8487-3	Cover – Switch
5887-17	78-8005-5741-1	Washer – Plain, M5
5887-18	78-8060-8488-1	Screw – Hex Hd, M5 x 20
5887-19	78-8046-8217-3	Washer – Special Lock
5887-20	78-8076-4701-7	Cap – /28
5887-21	78-8060-8087-1	Screw – Pan Hd, M5 x 10
5887-22	78-8060-8482-4	Plate – Protection

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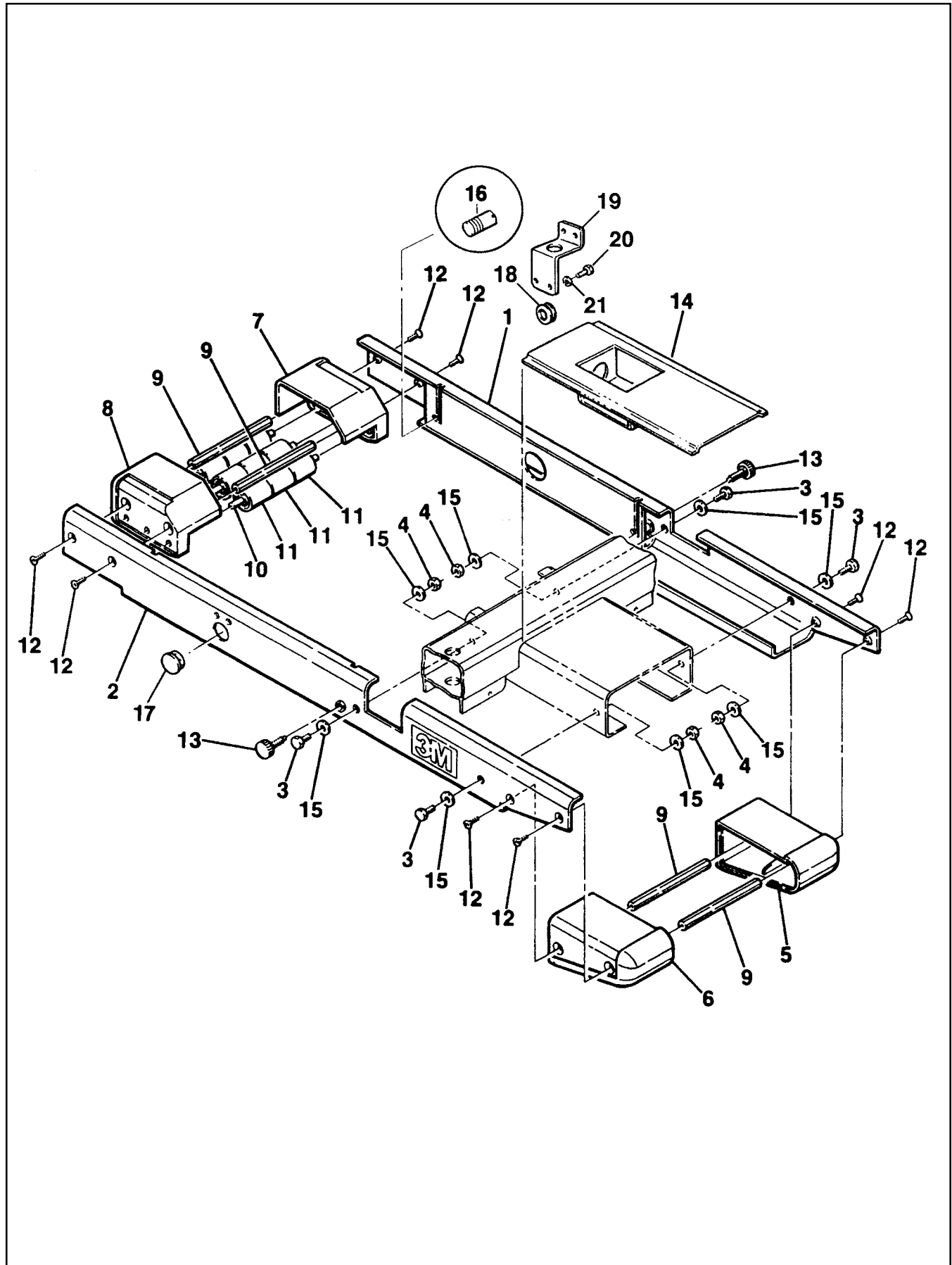


Figure 5888

Figure 5888

Ref. No.	3M Part No.	Description
5888-1	78-8079-5174-0	Side Plate – R/H
5888-2	78-8079-5175-7	Side Plate – L/H
5888-3	26-1003-5842-8	Screw – Hex Hd, M8 x 20
5888-4	26-1000-1347-8	Nut – Hex M8
5888-5	78-8070-1574-4	Slide – Front, Right
5888-6	78-8070-1575-1	Slide – Front, Left
5888-7	78-8070-1576-9	Slide – Rear, Right
5888-8	78-8070-1577-7	Slide – Rear, Left
5888-9	78-8070-1553-8	Spacer
5888-10	78-8070-1554-6	Stud
5888-11	78-8060-7693-7	Roller – 32 x 38
5888-12	26-1005-5316-8	Screw – Flat Hd, Hex Dr, M5 x 16
5888-13	78-8070-1555-3	Block – Upper Head
5888-14	78-8100-0775-3	Cover – Upper
5888-15	78-8017-9318-9	Washer – Plain, M8
5888-16	78-8076-4500-3	Stud – Mounting
5888-17	78-8076-4517-7	End Cap – /22X1
5888-18	78-8060-7758-8	Fairlead – /20
5888-19	78-8054-8955-2	Clamp – Bracket
5888-20	26-1003-5820-4	Screw – Hex Hd, M5 x 12
5888-21	78-8005-5741-1	Washer – Flat, M5

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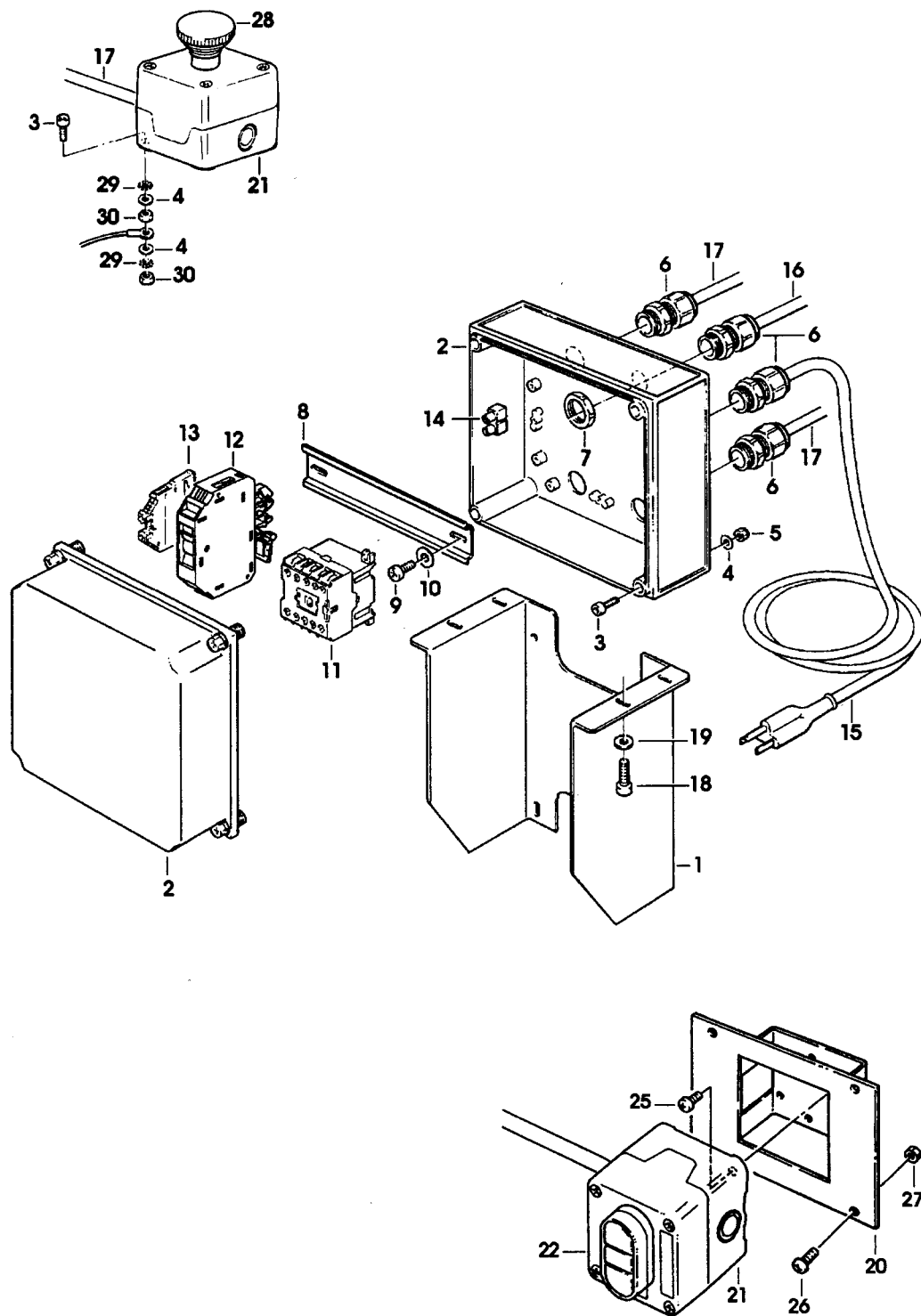
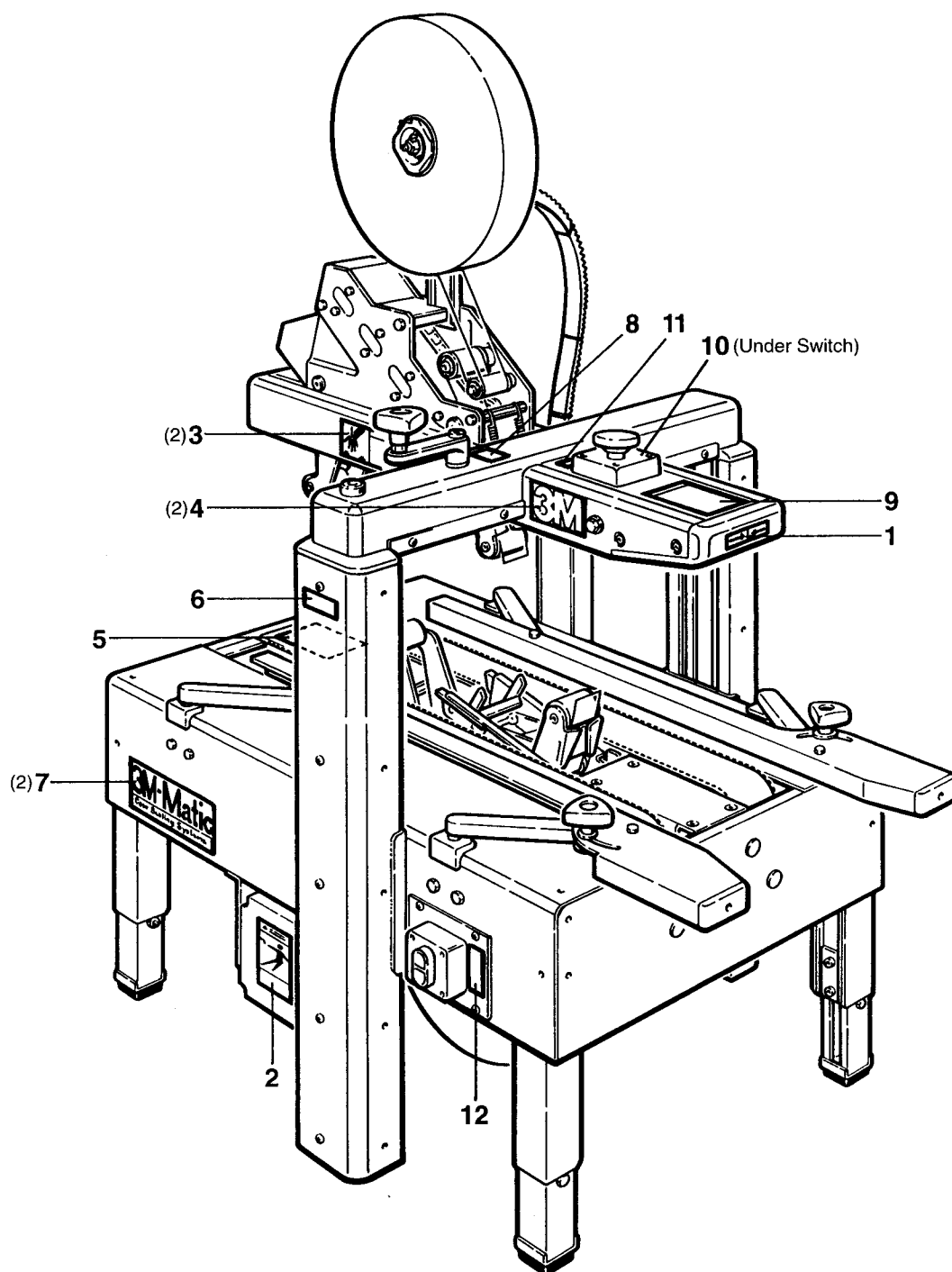


Figure 5889

Figure 5889

Ref. No.	3M Part No.	Description
5889-1	78-8094-6379-3	Support – Box
5889-2	78-8094-6380-1	Box
5889-3	78-8094-6381-9	Screw – Soc Hd, Hex Hd, M4 x 15
5889-4	78-8005-5740-3	Washer – Plain, 4 mm
5889-5	26-1003-6914-4	Nut – Plastic Insert, M4
5889-6	78-8076-4715-7	Cord Grip
5889-7	78-8076-5211-6	Set Nut – GMP13.5
5889-8	78-8094-6382-7	Guide – Mounting
5889-9	78-8028-8208-0	Screw – 6P X 9,5
5889-10	78-8017-9018-5	Washer – Plain, M4, SPEC
5889-11	78-8094-6383-5	Contactor – Sprecher and Shuh CA4-5-10, 110V, 60Hz
5889-12	78-8100-1146-6	Circuit Breaker – Single Pole, GB2-COB
5889-13	78-8094-6384-3	Ground Clamp – VGPE 4/6
5889-14	78-8076-4882-5	Terminal Board
5889-15	26-1009-8724-2	Power Cord W/Plug – Type SO
5889-16	78-8100-1038-5	Cable – 4 x 20 AWG, MT .5
5889-17	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
5889-18	26-1003-7957-2	Screw – Soc Hd Hex, M6 x 16
5889-19	26-1000-0010-3	Washer – Flat, M6
5889-20	78-8100-1039-3	Support – On/Off Switch
5889-21	78-8076-5194-4	Box – E-Stop, Allen Bradley 800E-1PY
5889-22	78-8094-6386-8	Switch – On/Off, Allen Bradley 800EP-U2C21
5889-25	78-8017-9257-9	Screw – M4 x 10
5889-26	78-8060-8087-1	Screw – M5 x 10
5889-27	78-8010-7417-6	Nut – Hex, M5
5889-28	78-8094-6385-0	E-Stop – Allen Bradley MTS-64-3LX01
5889-29	78-8076-4716-5	Star Washer – M4
5889-30	78-8010-7416-8	Nut – Hex, M4

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Safety and Information Labels

A label kit, part number 78-8098-9072-2, 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	78-8070-1318-6	Label – Box Centering	1
2	78-8070-1329-3	Label – Warning, Hazardous Voltage	1
3	78-8070-1336-8	Label – Warning, Sharp Knife	2
4	78-8070-1339-2	Label – 3M Logo	2
5	78-8113-6717-2	Label – Caution, Pinch Point	1
6	78-8068-3859-1	Label – Service and Spares	1
7	78-8062-4266-1	Label – Product	2
8	78-8070-1423-4	Label – Up and Down	1
9	78-8070-1366-5	Label – Safety Instructions	1
10	78-8068-3852-6	Label – Ground Symbol	1
11	78-8095-1141-9	Label – Stop	1
12	78-8113-6775-0	Label – Electrical On/Off	1