

## 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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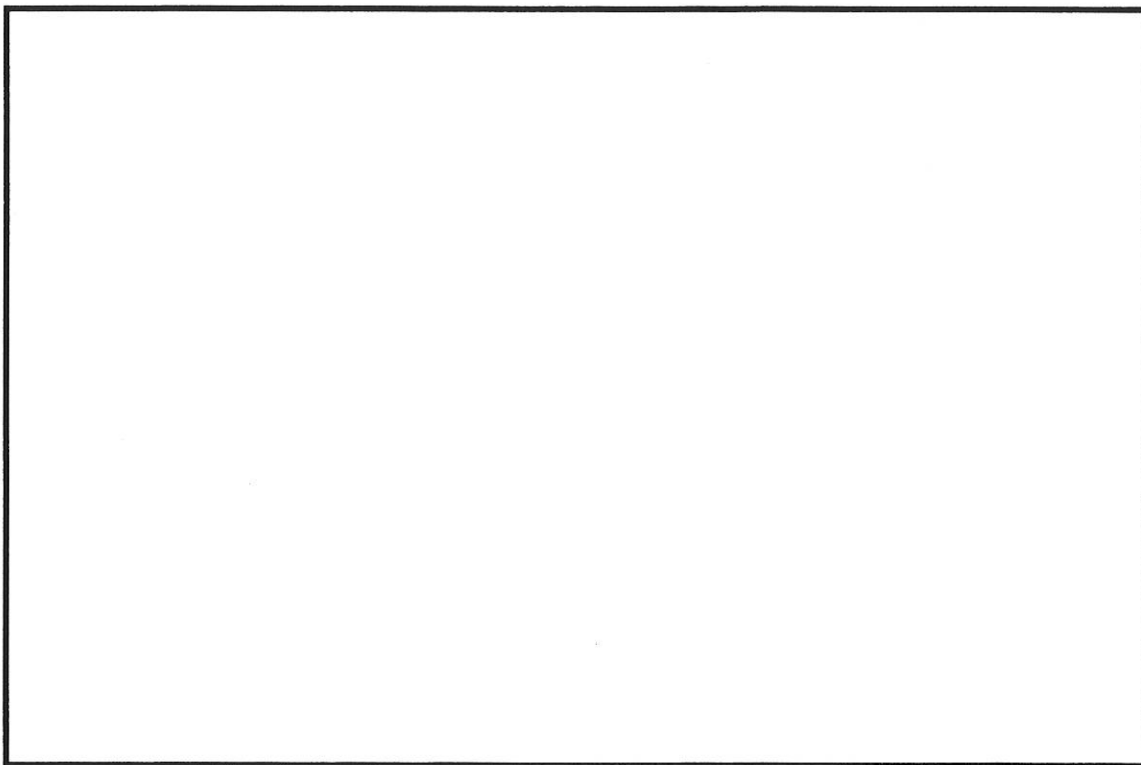


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**Included with each machine is an Instructions and Parts List manual.**

**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.



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St. Paul, MN 55144-1000  
1-800/328 1390

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# Instruction Manual

800asb, Type 19500  
Adjustable Case Sealer

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 1-1/2 Inch Taping Heads

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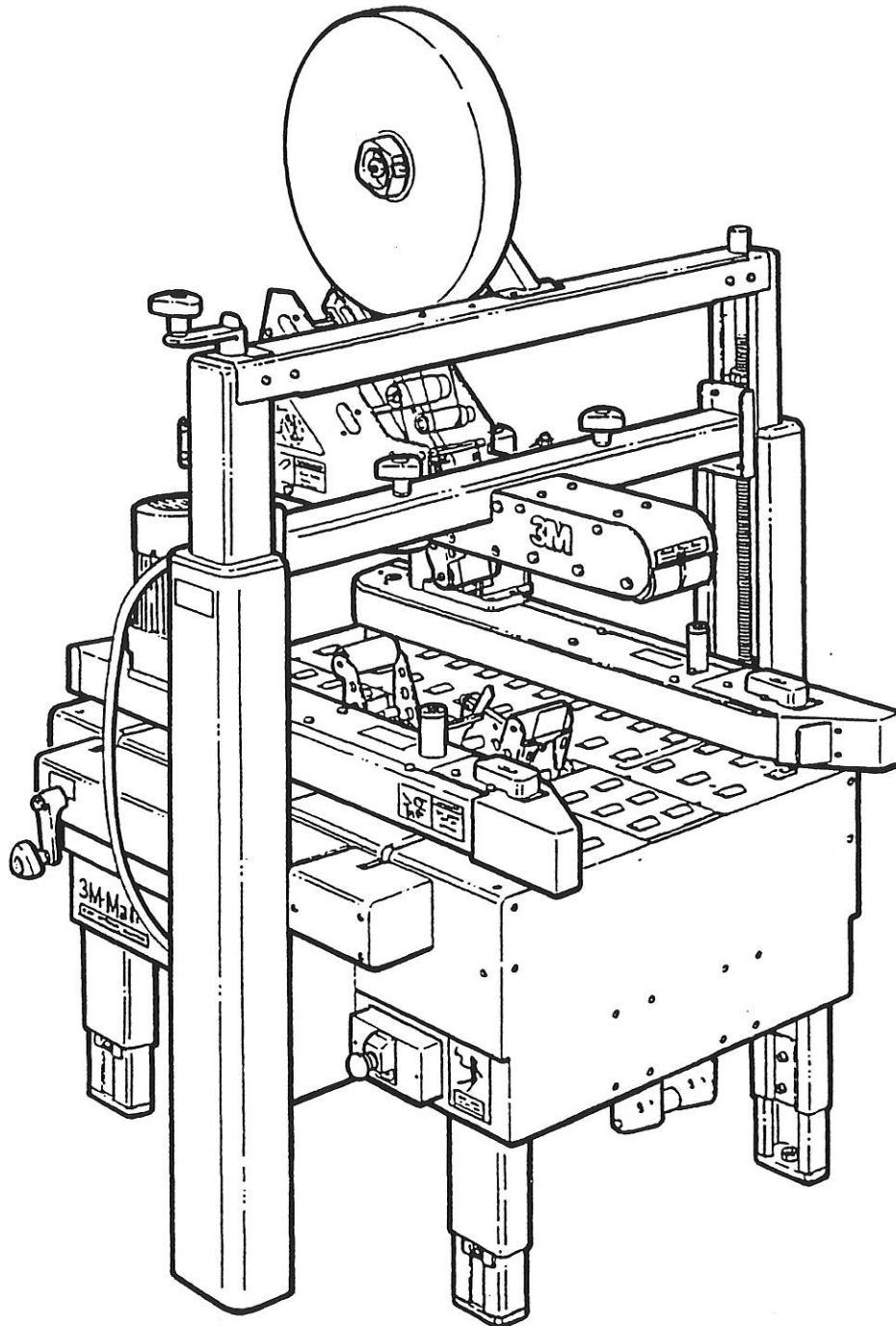
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## Section II – AccuGlide™ II STD 1-1/2 Inch Taping Heads

## Description

The **3M-Matic™** 800asb Adjustable Case Sealer with **AccuGlide™ II** 1-1/2 Inch Taping Head 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 case sealer is manually adjustable to a wide range of box sizes (see Box Weight and Size Capacities, page 8).



**3M-Matic™ 800asb Adjustable Case Sealer, Type 19500**

**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™ 800asb Adjustable Case Sealer, Type 19500** with the following warranties:

1. The Taping Head knife blades, 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.

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## **800asb Contents**

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800asb – (1) 800asb Adjustable Case Sealer, Type 19500  
(1) Tool Kit  
(1) Instruction and Parts Manual

## Safety Labels

**Important** – In the event the following Safety labels are damaged or destroyed, they must be replaced to ensure operator safety. For safety and information replacement labels, see Parts Illustrations/Lists, Section I, pages 70 - 71.

The "**Warning – Hazardous Voltage**" label, shown in **Figure 1-2**, is attached to the frame next to the on/off switch. The label warns service personnel to unplug the power supply before attempting any service work on the case sealer.



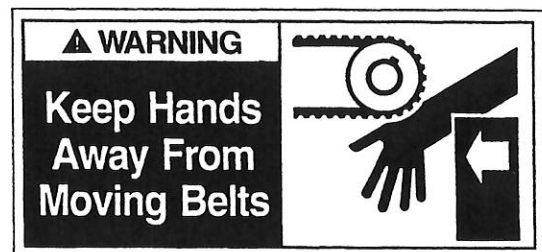
**Figure 1-2 – Electrical Warning Label**

Two "**Warning Sharp Knife**" labels, shown in **Figure 1-1**, are attached to the sides of the upper frame at the location of the cut-off blade 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**

Two "**Warning – Keep Away From Moving Belts**" labels, shown in **Figure 1-3**, are located on the right and left side panel of the conveyor bed. The labels warn operators and service personnel to keep hands away from this area when the drive belts are running.



**Figure 1-3 – Hands Warning Label**

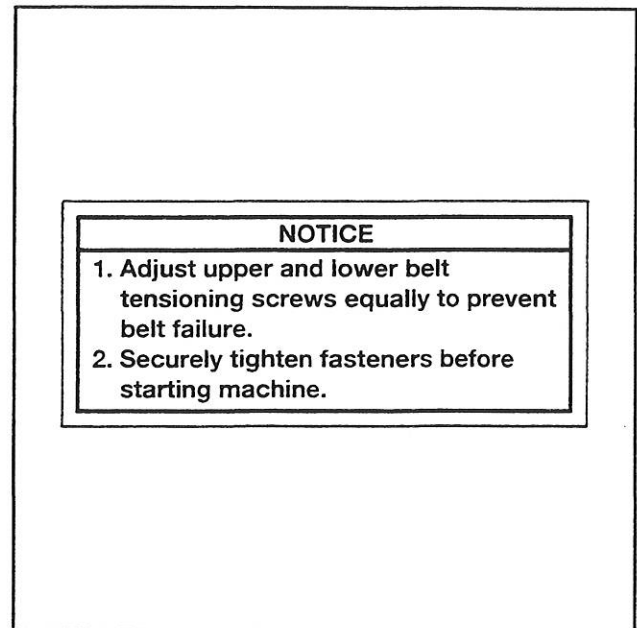
## Safety Labels (Continued)

The "**Caution - Keep Hands Out Of This Area**" label, shown in **Figure 1-4**, is attached to the rear of the upper frame. It warns the operator to keep hands out of this area when the upper taping head mechanism is in operation.



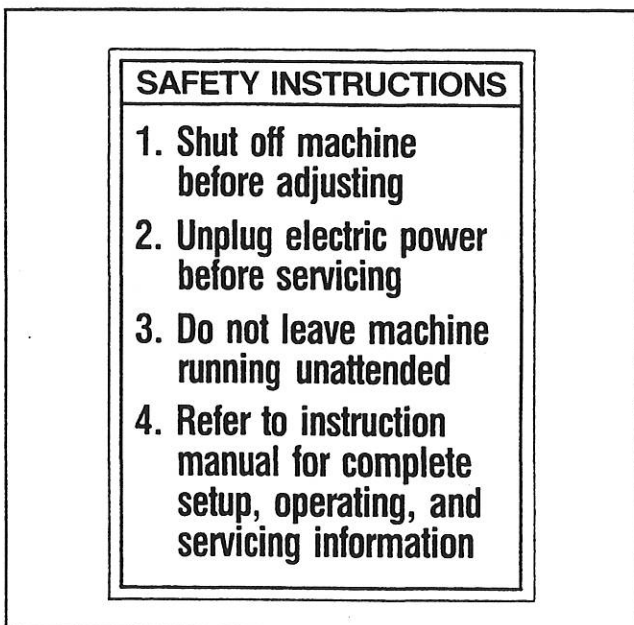
**Figure 1-4 – Hands Caution Label**

The "**Operating Notice**" label, shown in **Figure 1-6**, is located on top of both drive belt assemblies to remind operators of belt adjustment procedures.



**Figure 1-6 – Operating Notice Label**

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



**Figure 1-5 – Safety Instructions Label**

## Safety Labels (Continued)

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

The **"Warning-Sharp Knife"** label warns operators and service personnel of the extremely sharp knife used to cut the tape at the end of the box sealing operation. The label, shown in **Figure 1-7**, is located on the orange blade guard between the applying roller assembly and the buffing roller assembly. **Never operate taping heads with blade guard removed.**

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

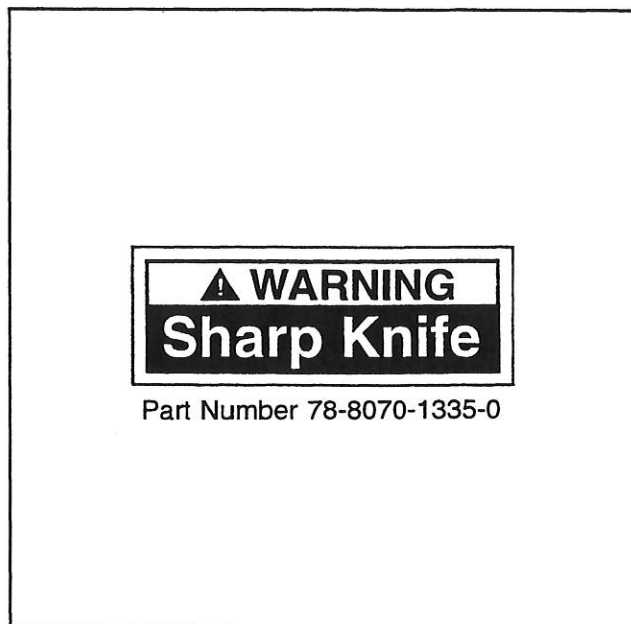


Figure 1-7 – Knife Warning Label

The **"Tape Threading Label"**, shown in **Figure 1-8**, is attached to the left side of both upper and lower taping heads. This label provides a convenient tape threading diagram. More detailed tape loading and threading information is provided in this manual in the set-up procedure section.

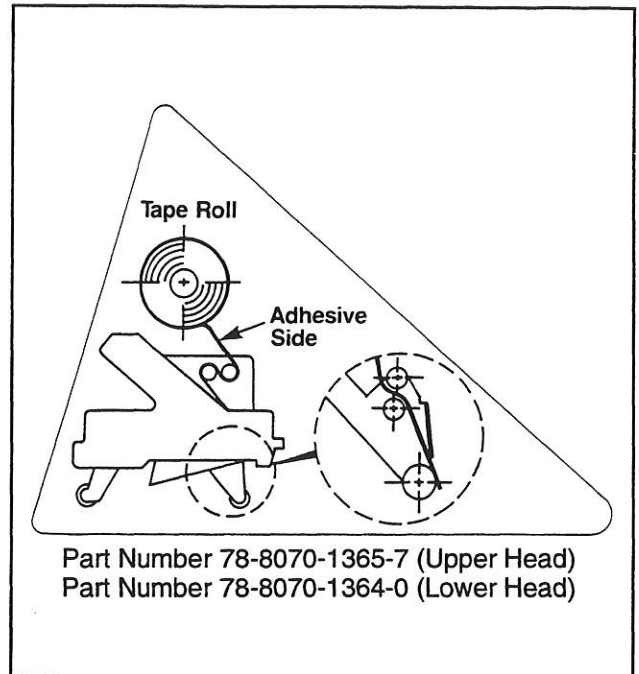
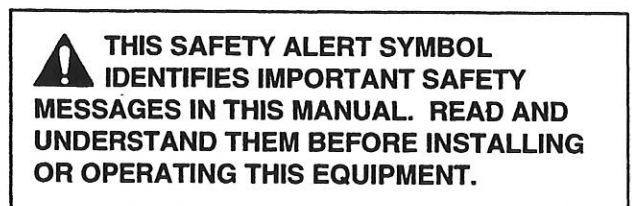


Figure 1-8 – Tape Threading Label



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# Specifications

## 1. Power Requirements:

Electrical – 115 VAC, 60 Hz, 3.8 A

The machine is equipped with an 2.4 m [8 ft] standard neoprene covered power cord and a grounded plug.

Contact your 3M Representative for power requirements not listed above.

## 2. Operating Rate:

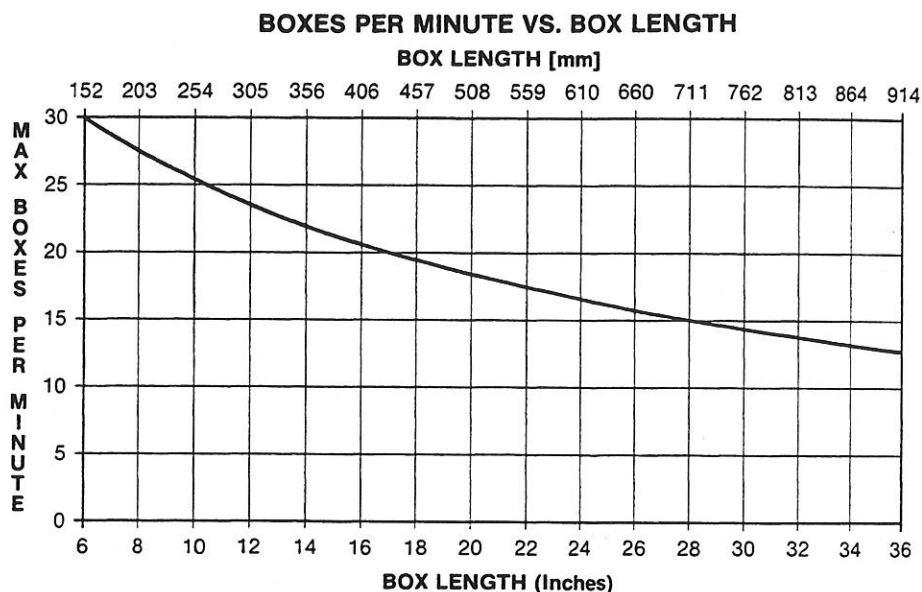
Belt speed is 0.40 m/s [78 ft/min]

## 5. Tape Width:

36 mm [1.5 in]

## 6. Tape Roll Diameter:

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



Actual production rate is dependent on operator's dexterity.  
Boxes must be 18 inches [455mm] apart minimum.

## 3. Operating Conditions:

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

**Important** – 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.

## 7. Tape Leg Length (Standard):

50 mm ± 6 mm [2 in ±.25 in]

## Tape Leg Length (Optional):

70 mm ± 6 mm [2.75 in ±.25 in]  
(To change tape leg to 70 mm [2.75 in], see "Special Set-Up Procedures", page 28.)

## 8. Box Board:

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

(Specifications continued on next page)

## Specifications (Continued)

### 9. Box Weight and Size Capacities:

#### Weight

Maximum – up to 38.6 kg [85 lbs]

Minimum – contents must support top flaps and weight must be sufficient to hold bottom flaps fully closed.

#### Box Size – With standard 50 mm [2.00 in] tape leg length

##### MINIMUM

Length – 150 mm [6.00 in]  
Width – 100 mm [3.90 in]  
Height – 70 mm [2.75 in] \*

##### MAXIMUM

Length – unlimited  
Width – See Below \*\*  
Height – 570 mm [22.38 in]

#### Box Size – With optional 70 mm [2.75 in] tape leg length

##### MINIMUM

Length – 150 mm [6 in]  
Width – 140 mm [5.50 in]  
Height – 120 mm [4.75 in]

##### MAXIMUM

Length – Unlimited  
Width – 545 mm [21.50 in]  
Height – 570 mm [22.38 in]

**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 corrugated containers (RSC). Two of the requirements of the standard are the following:

The box length is not more than twice the box width.

The box length is not more than four times the box depth.

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

**Box Length In**  
**Direction Of Seal      Must Be Greater Than .6**  
**Box Height**

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

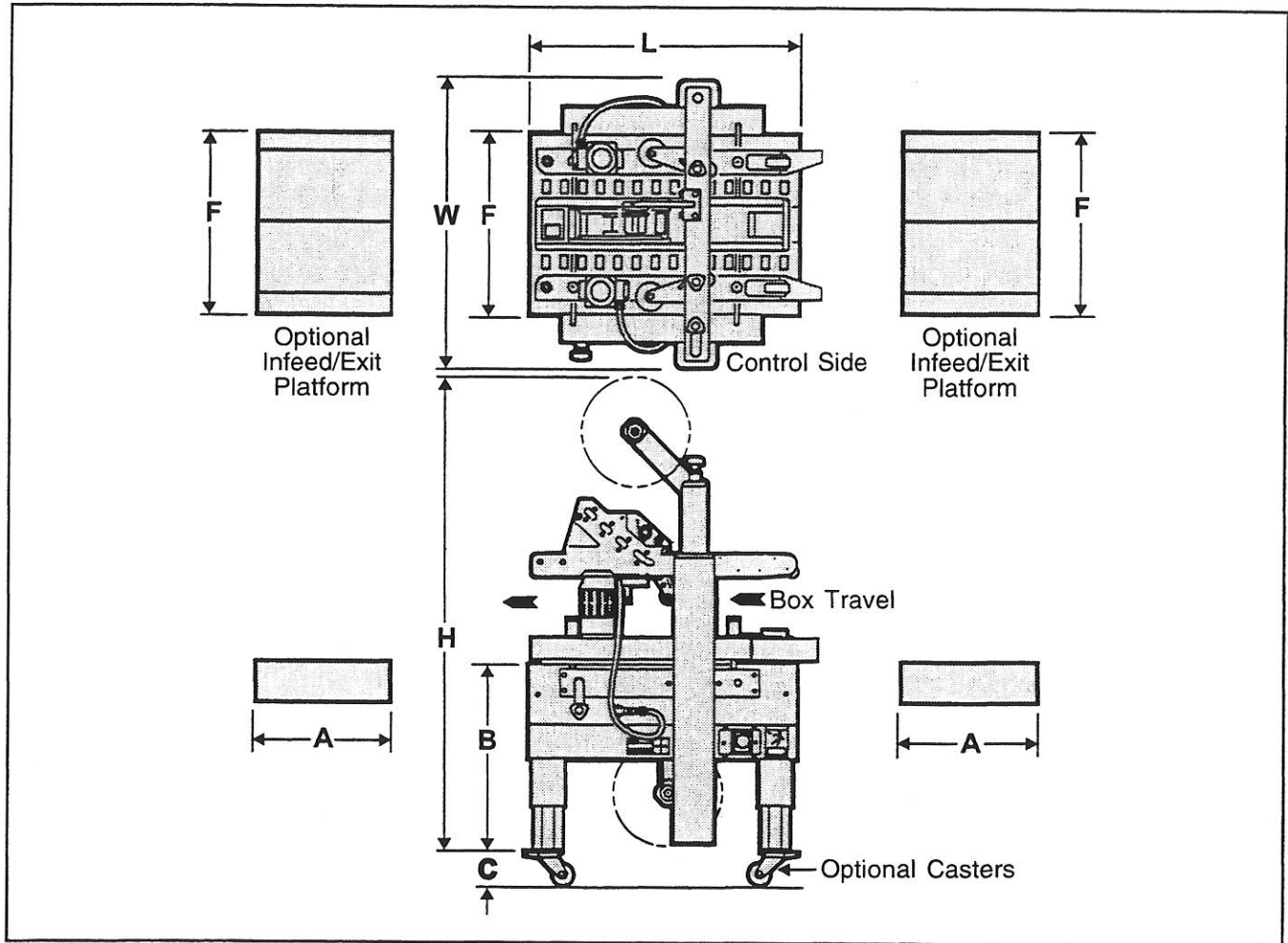
\* With outer columns relocated to upper position, minimum box height is 108 mm [4.25 in] and maximum box height is 670 mm [26.38 in]. (See "Special Set-Up Procedure – Box Height Range", page 28.)

\*\* Maximum box width is 545 mm [21.50 in] on boxes higher than 110 mm [4.25 in]. (To run boxes less than 110 mm [4.25 in] high, remove compression rollers.

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

(Specifications continued on next page.)

## Specifications (Continued)



### Machine Dimensions:

	W	L	H	A	B	C	F
<b>Minimum</b>							
mm [Inches]	980 [38.50]	920 [36.25]	1335 [52.50]	460 [18]	610 [24] *	105 [4.18]	620 [24.50]
<b>Maximum</b>							
mm [Inches]	--	--	2184 [86] *	--	890 [35] *	--	--

\* With outer columns relocated to upper position, "H" maximum dimension increases 100 mm [4 in] and "B" minimum/maximum dimension decreases by 100 mm [4 in]. (See "Special Set-Up Procedure – Box Height Range", page 28.)

Weight – approximate 170 kg [375 lbs] crated  
 approximate 152 kg [335 lbs] uncrated

### 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.

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## 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.

**Important – Read "Warnings" on page 16 before attempting to set-up the case sealer for operation.**

### Machine Set-Up

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 to identify the various components of the case sealer.

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

### PACKAGING AND SEPARATE PARTS STEPS 1 THRU 5

1. Lift fiberboard cover off pallet after removing staples at bottom.
2. Install the crank handle on the top of the left column, as shown in Figure 2-1A.
3. Install the upper tape drum bracket on the top cross bar, as shown in Figure 2-1B.
4. Remove height stop plates on both columns (from shipping position) and re-install with screws in lower set of holes as shown in Figure 2-1C.

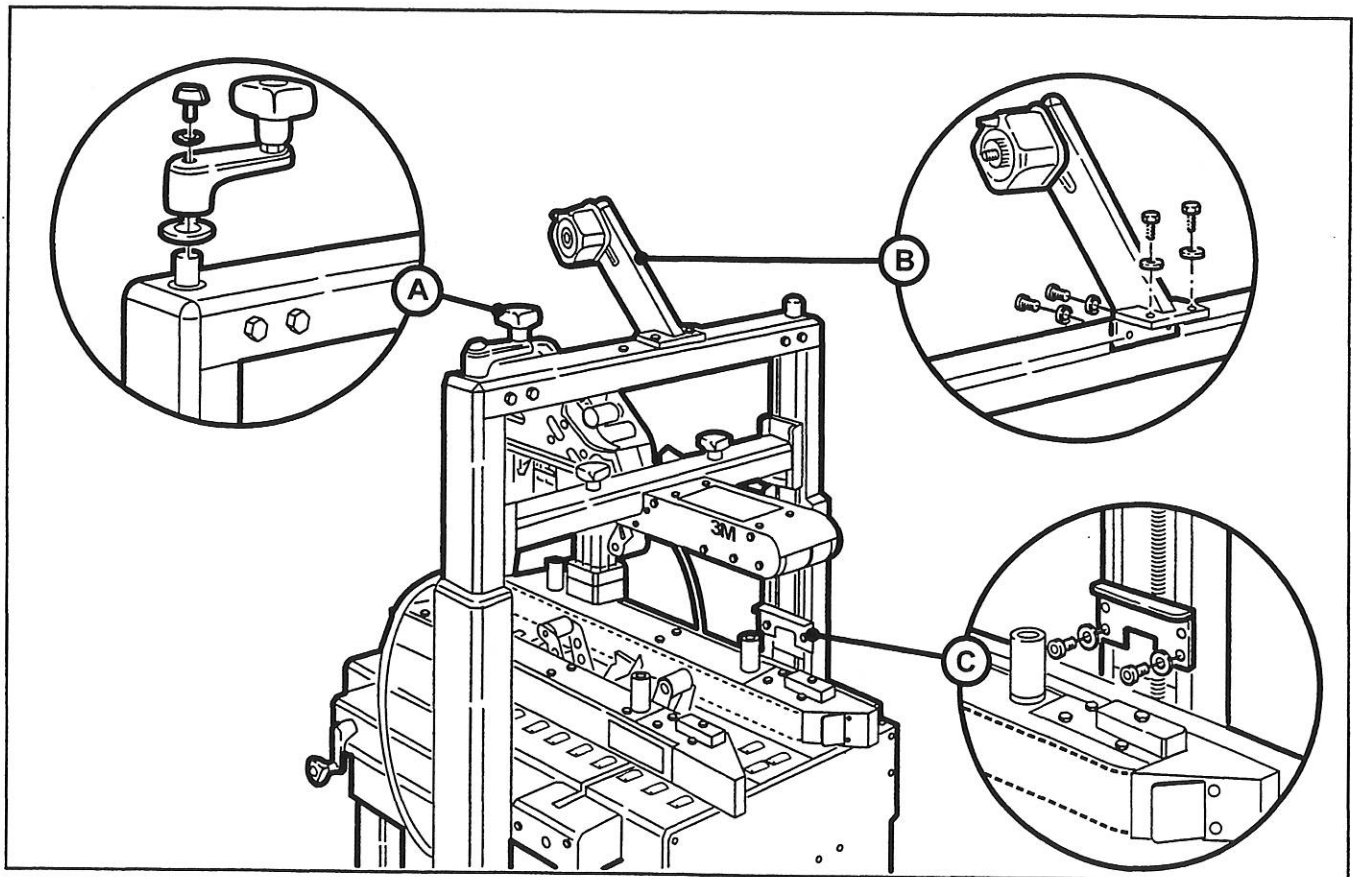


Figure 2-1 – Set-Up and Installation

## Installation and Set-Up (Continued)

5. Install drive belt assemblies. Refer to Figure 2-2.
  - a. Crank upper taping head to its fully raised position.
  - b. Install drive belt assemblies on mounting shafts with exposed belt towards inside of case sealer and drive motor at exit end of machine. **Note – Keep drive motors in vertical position to prevent gear oil from leaking out of transmission.**
  - c. Fasten drive belt assemblies in place with spacer (A), special washer (B) and M6 x 16 flat head screw (C) on each mounting shaft.
  - d. Plug each motor cord into receptacle on each side of case sealer bed and secure with receptacle clamp.

**Note** – The drive belt assemblies can be raised 55 mm [2.16 in] to provide better conveying of tall boxes. Refer to "Special Set-Up Procedure – Drive Belt Height", page 27 for set-up procedure. **(Raising drive belts increases the minimum box height that can be taped to 115 mm [4.50 in].)**

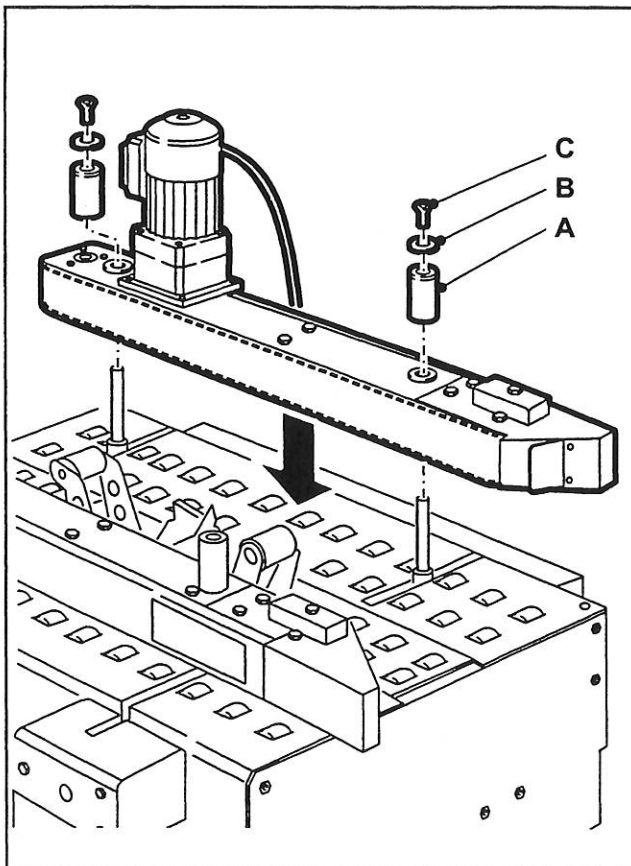


Figure 2-2 – Drive Assemblies

### TAPE DRUM BRACKET (Lower Taping Head)

Ensure that the tape drum bracket assembly is mounted straight down, as shown in Figure 2-3A. The tape drum bracket assembly can be pivoted to provide clearance or for retrofit in certain cases.

Outboard tape roll mounting (Alternate Position) – Remove the tape drum bracket assembly, stud spacer and fasteners from the taping head. Install and secure on the infeed end of the lower frame, as shown in Figure 2-3B.

### CONVEYOR BED HEIGHT

Adjust conveyor bed height. The case sealer is equipped with four adjustable legs that are located at the corners of the machine frame. The legs can be adjusted to obtain different machine bed heights from 610 mm [24 in] minimum to 855 mm [35 in] maximum.

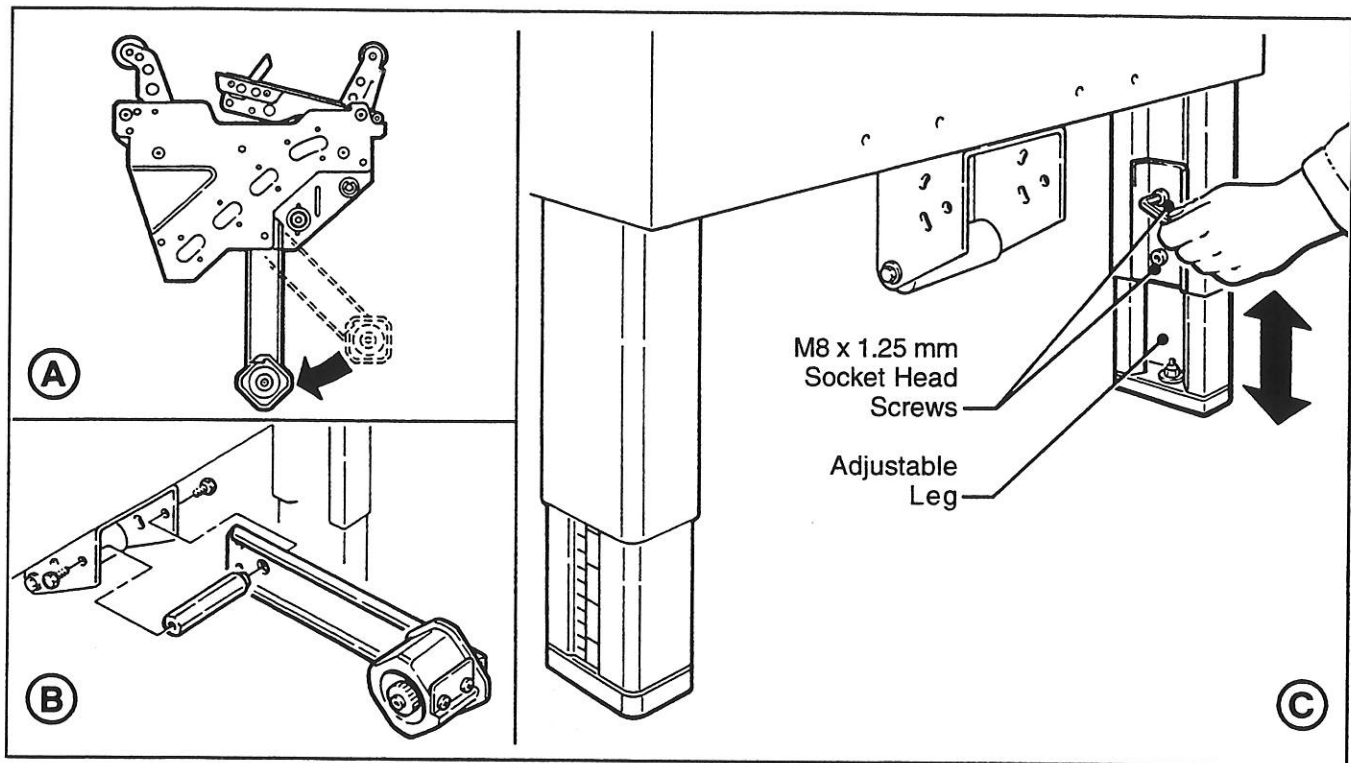
Refer to Figure 2-3C and set the machine bed height as follows:

1. Raise and block up the machine frame to allow adequate leg adjustment.
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 50 mm [2 in] long tape legs. To change tape legs to 70 mm [2.75 in], see "Special Set-Up Procedures", page 28.

## Installation and Set-Up (Continued)



**Figure 2-3 – Conveyor Bed Height Adjustment and Lower Tape Drum Bracket Position**

### BOX SIZE CAPACITY OF CASE SEALER

At its factory setting, the case sealer handles box sizes up to 570 mm [22.38 in] maximum height. If larger capacity is needed, the machine can be adjusted to accommodate boxes up to 670 mm [26.38 in] high. Refer to page 28, "Special Set-Up Procedures – Box Height Range", for set-up procedure.

**Note – Adjusting machine to accommodate 670 mm [26.38 in] high boxes also increases minimum box size to 170 mm [6.75 in].**

the electrical control box. The receptacle providing this service shall be properly grounded. Before the power cord is plugged into 115 Volt, 60 Hz outlet, make sure the red "Off" button is depressed and that all packaging materials and tools are removed from the machine. **Do not plug electrical cord into outlet until ready to run machine.**

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

### ELECTRICAL CONNECTION AND CONTROLS

The electrical control box, shown in Figure 3-1, contains the "On/Off" switch with pre-set circuit breaker and can be located on either side of the machine frame for customer operating convenience. A standard three conductor power cord with plug is provided at the back of

### 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.

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## Operation

**IMPORTANT** – Before operating the case sealer read all the "Warning/Information Labels", pages 3-5 and "Warnings", on page 16 as well as all of the "Operation" instructions.

Refer to Figure 3-1 to acquaint yourself with the various components of the case sealer and also see Section II, page 6, for taping head components.

**Note** – Although the upper taping head is built into the machine frame, it has the same components (except for side frames) as the lower head which is described in Section II. Refer to Section II for both upper and lower taping head tape loading, maintenance and adjustment procedures.

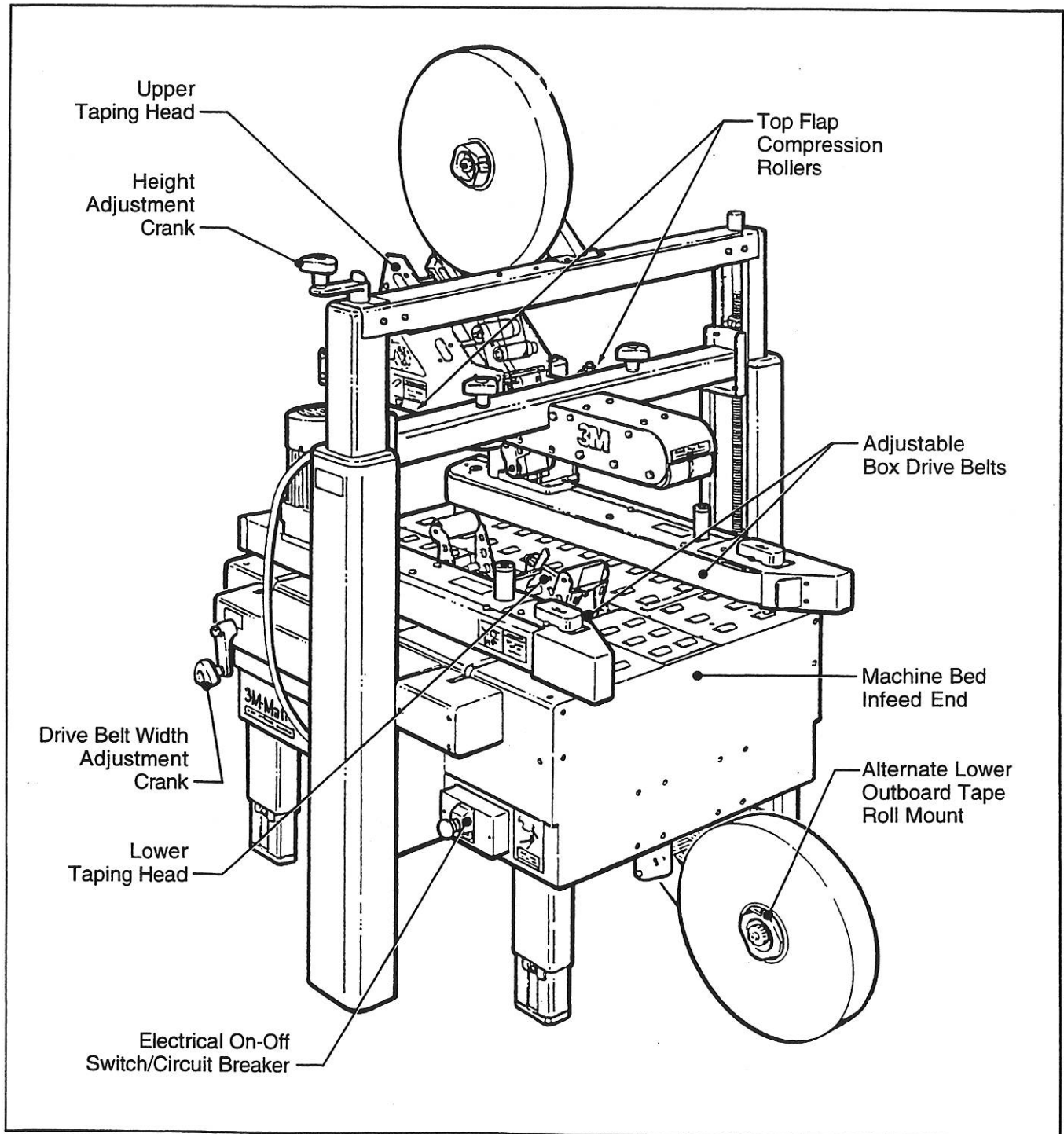


Figure 3-1 – Case Sealer Components, Left Front View

## Operation (Continued)



### WARNINGS

1. Turn electrical supply off and disconnect before servicing taping heads or performing any adjustments or maintenance on the machine.
2. Turn electrical supply off when machine is not in use.
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. Never attempt to work on any part of the machine, load tape or remove jammed boxes from the machine while machine is running.
6. 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.**
7. Taping heads utilize extremely sharp knife blades. The blade is located under the orange blade guard that has the "WARNING – SHARP KNIFE" label. Before loading tape, refer to Section II, page 6, Figures 3-1 and 3-2 to identify the blade location. Keep hands out of these areas except as necessary to service the taping head(s).
8. Turn drive belts "Off" when machine is not in use.
9. 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 incorporated into the "On/Off" switch. If circuit becomes overloaded and circuit breaker trips, determine cause of overload (wait two minutes), then push "On" button to re-set breaker/start machine.

### Tape Loading/Threading

See Section II, pages 7 and 8

#### Notes

1. Although upper taping head is built into machine, tape threading is the same as shown in Section II, pages 7 and 8.
2. If lower taping head tape drum is mounted in outboard position, remove taping head from machine bed by pulling straight up, insert threading needle in taping head and replace taping head. Install tape roll on drum (adhesive on tape leg up), thread tape leg under knurled roller on outboard mount, then attach tape leg to threading needle and pull tape through taping head with threading needle.

## Operation (Continued)

### Box Size Set-Up

#### 1. ADJUST DRIVE BELTS (Figure 3-2)

Place a product filled box on infeed conveyor bed with top flaps folded as shown and manually move box forward to contact lower taping head applying roller.

Turn drive belt adjustment crank to position both side drive belts against sides of box.

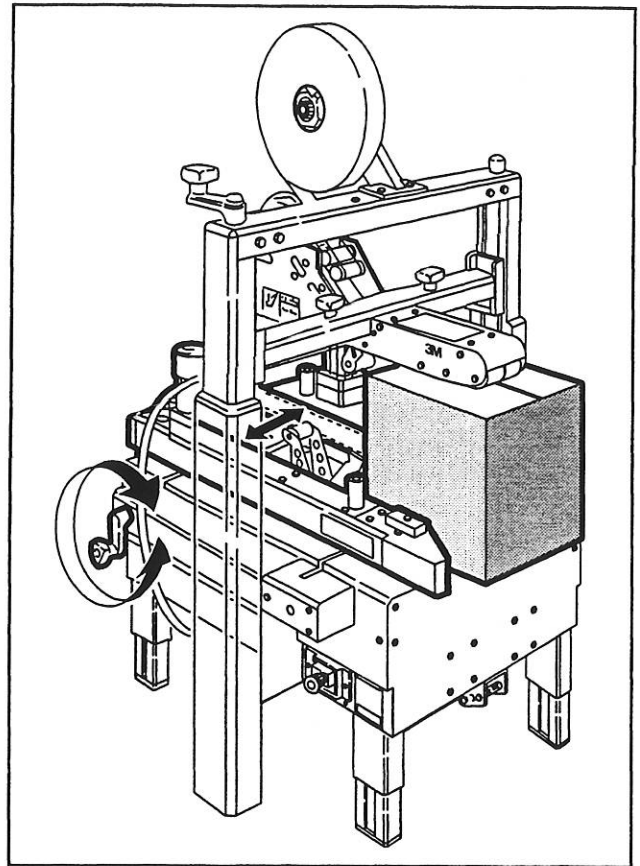


Figure 3-2 – Side Drive Belts

#### 2. ADJUST UPPER TAPING HEAD (Figure 3-3)

Turn height adjustment crank to position upper taping head onto box. Turn clockwise to lower head, counterclockwise to raise head. Upper taping head must contact and hold top box flaps closed.

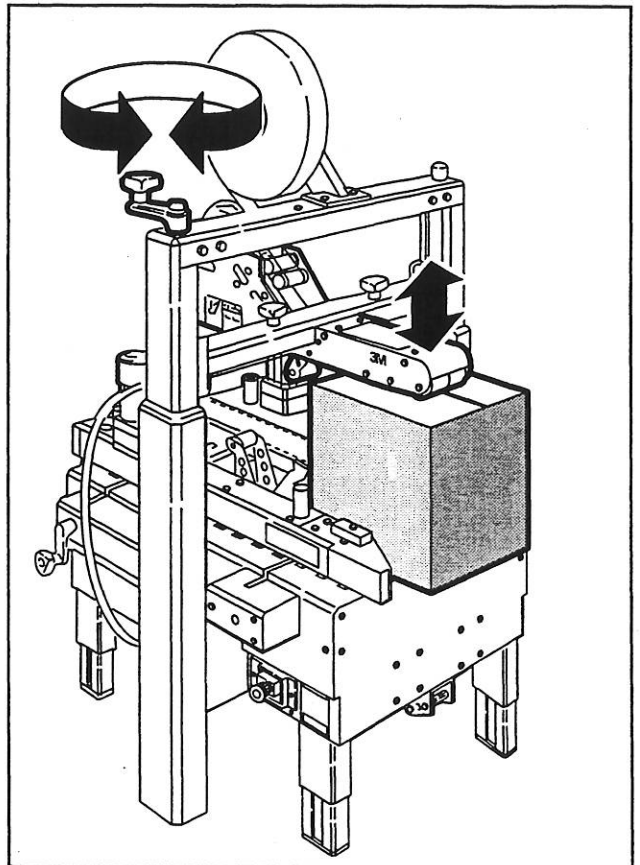


Figure 3-3 – Upper Taping Head

## Operation (Continued)

### 3. POSITION COMPRESSION ROLLERS (Figure 3-4)

The top flap compression rollers have an adjustable slide mounting to provide side compression on boxes higher than 110 mm [4.25 in].

Manually move box forward so front of box is aligned with top flap compression rollers.

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

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



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

Push electrical switch "On" to start drive belts.

Move box forward under upper taping head until it is taken away by drive belts. If box is hard to move under head or is crushed, raise head slightly.

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



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

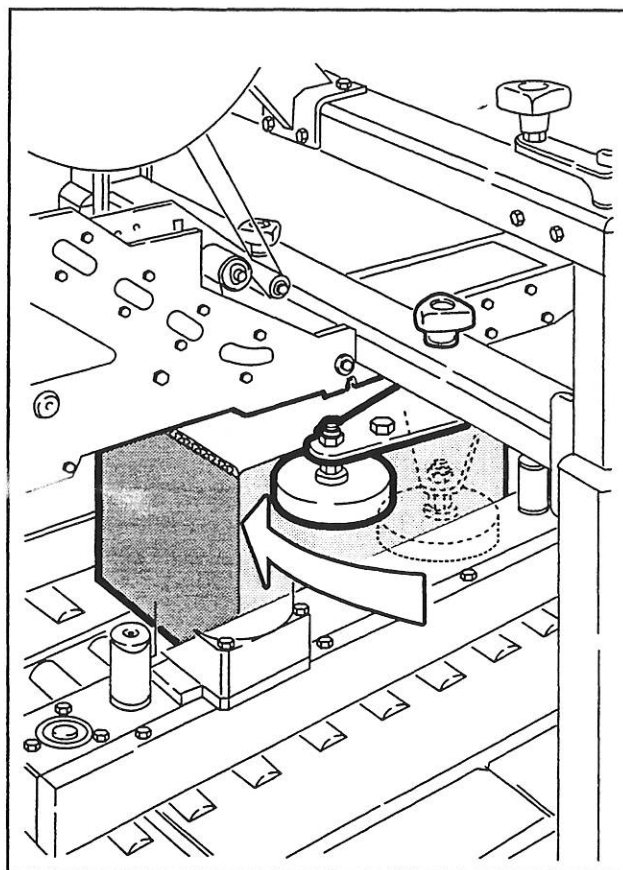


Figure 3-4 – Top Flap Compression Rollers

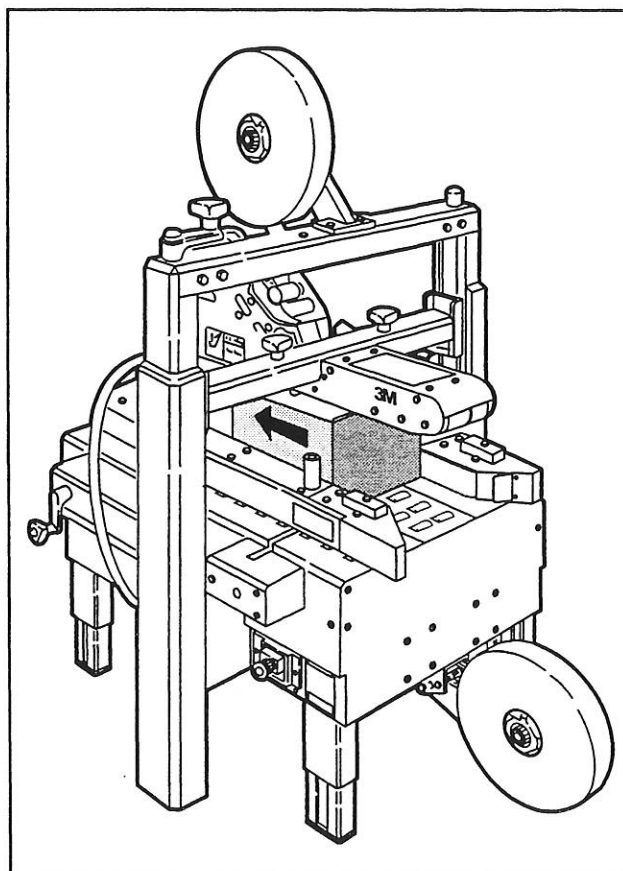


Figure 3-5 – Check Adjustment

## Operation (Continued)

### Box Sealing

1. Feed boxes to machine at minimum 455 mm [18 in] 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.

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## 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.

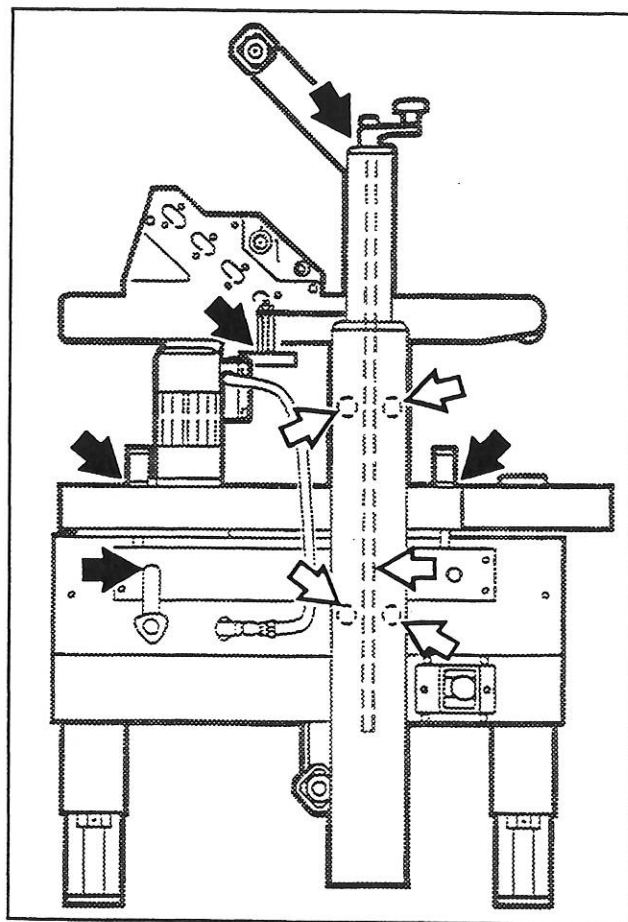
### Lubrication

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

Figure 4-1 illustrates the frame points which should be lubricated every 250 hours of operation. Lubricate the rotating and pivoting points, noted by the arrows, (➡) with SAE #30 non-detergent oil. At the same time, a small amount of multipurpose grease should be applied to the end of each spring where the loop is secured at an eyelet, post, or hole noted by arrows (⇨).

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

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



**Figure 4-1 – Frame Lubrication Points**



## Maintenance (Continued)



**WARNING** – Turn off electrical power 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 the "On/Off" switch to tripped position. If circuit is overloaded and circuit breaker trips, determine cause and correct (wait two minutes), then turn "On". Located inside the electrical control box on the side of the machine frame, the circuit breaker has been pre-set at 1.9 Amps and requires no further maintenance.

### Blade Replacement, Taping Head

See Section II, "Maintenance - Blade Replacement", page 9.

### Drive Belts

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

REPLACEMENT – SEE STEPS 1 THRU 8

TENSION ADJUSTMENT – SEE STEPS 3, 7 AND 8

1. Crank the upper taping head to its fully raised position.
2. Remove and retain the three screws (A), three washers (B) and side cover (C). See Figure 4-2.
3. Remove and retain the screw (D), washer (E) and belt tensioner cover (F).
4. Turn belt adjustment screws (G) counterclockwise on both the upper and lower tension assemblies until belt is loose. See Figure 4-3.
5. Locate the belt lacing (joint) by turning the belt manually. Remove the pin with pliers. Remove and discard old belt.

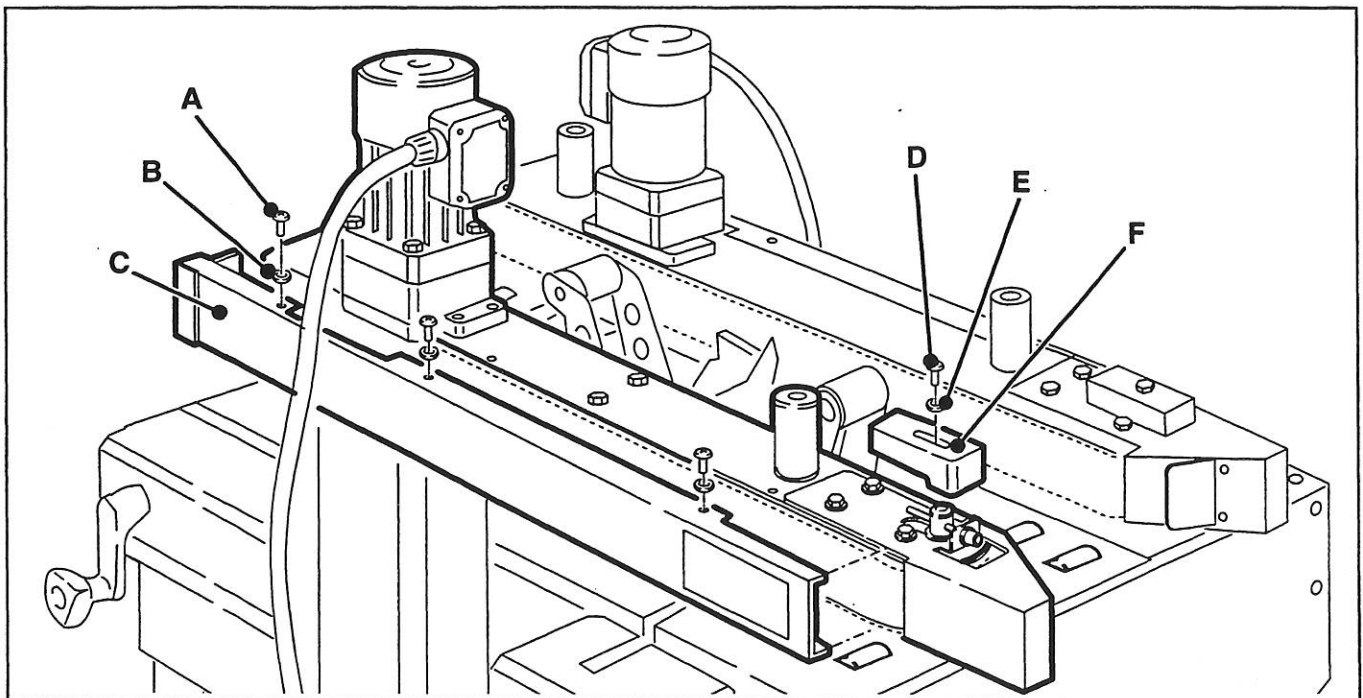
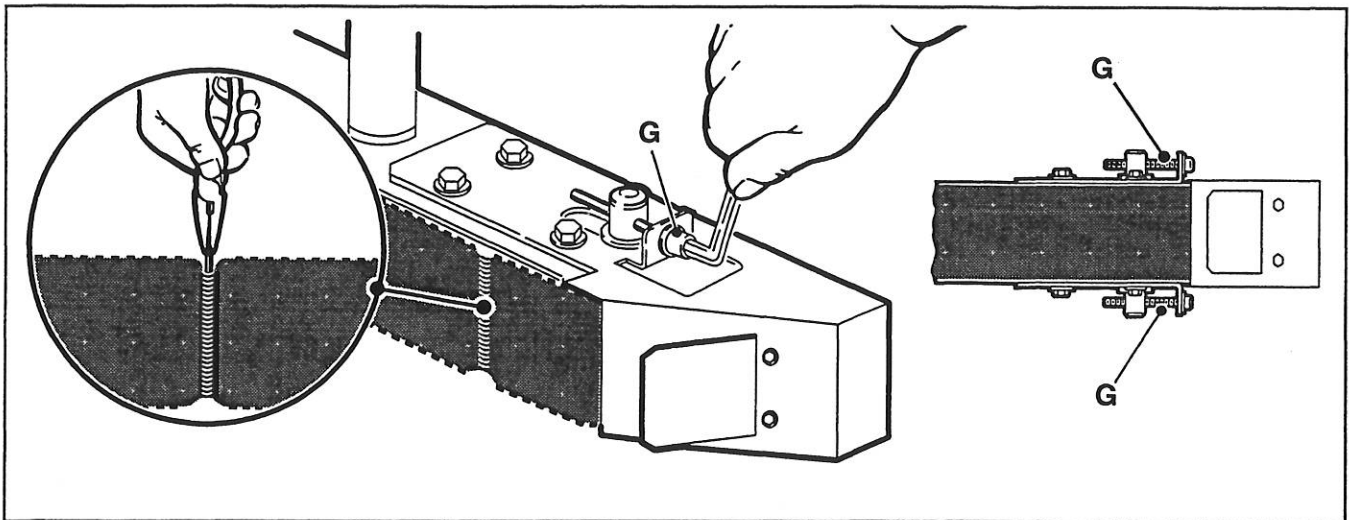


Figure 4-2 – Box Drive Belt (Left Side View – Infeed End)



## Maintenance (Continued)



**Figure 4-3 – Box Drive Assembly, Infeed End**

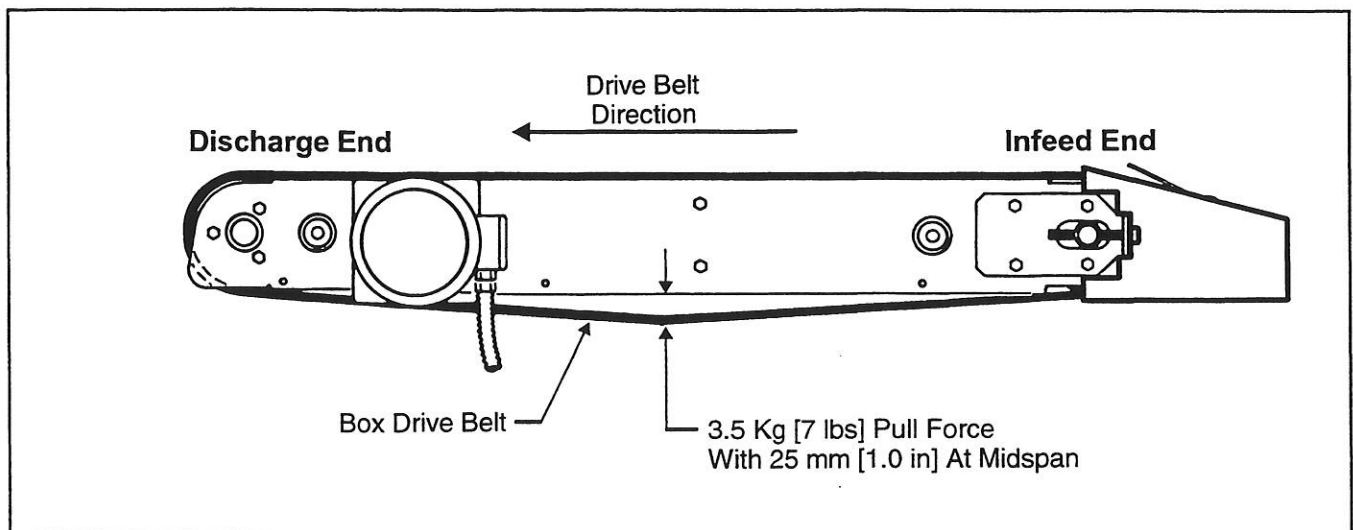
6. Install the new belt around drive rollers and insert new pin. Pin must not extend beyond edge of belt.

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

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

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

8. Reverse procedures in Steps 1-3 (Figure 4-2) to reassemble the drive belt assembly.



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

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## 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.

### Drive Belt Tension

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

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

To adjust belts, see "Maintenance – Drive Belts", page 22.

### Taping Head Adjustments

See Section II for 1-1/2 Inch Taping Heads

**Note** – Although the upper taping head is built into the machine frame, it has the same components (except for side frames) as the lower head. Adjustments are the same as lower head.

TAPE WEB ALIGNMENT – Section II, Page 11

TAPE DRUM FRICTION BRAKE – Section II, Page 11

APPLYING MECHANISM SPRING – Section II, page 11

ONE-WAY TENSION ROLLER – Section II, page 12

### TAPE LEG LENGTH

Leading Tape Leg Length Adjustment – Section II, Page 13

Changing Tape Leg Length from 50 to 70 mm [2 to 2.75 in] – Section II, page 13.

**Note** – Changing tape leg to 70 mm [2.75 in] requires machine adjustment also. See Section I, "Special Set-Up Procedure – Changing Tape Leg Length", page 28.

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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.

### Drive Belt Height

The drive belt assemblies can be raised 55 mm [2.16 in] to provide better conveying of tall boxes. **This change increases the minimum box height that can be taped to 115 mm [4.5 in].**

### DISASSEMBLE – Figure 5-1

1. It is first necessary to raise the top taping head. Utilize the height adjustment crank and move the upper taping head to the fully raised position.
2. Remove and retain the screw (A), cap washer (B) and spacer (C) from the front and rear arm assembly pivots.
3. Lift belt drive assembly (D) up off the arm assembly pivots.

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

### REASSEMBLE – Figure 5-2

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 the cap washers (B) and screws (A).

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

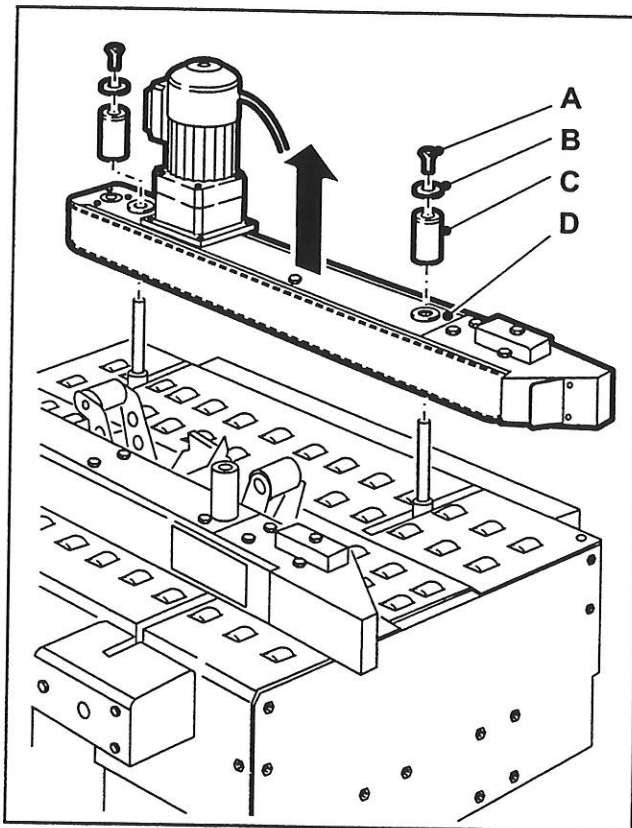


Figure 5-1 – Drive Belt Assembly, Disassembly

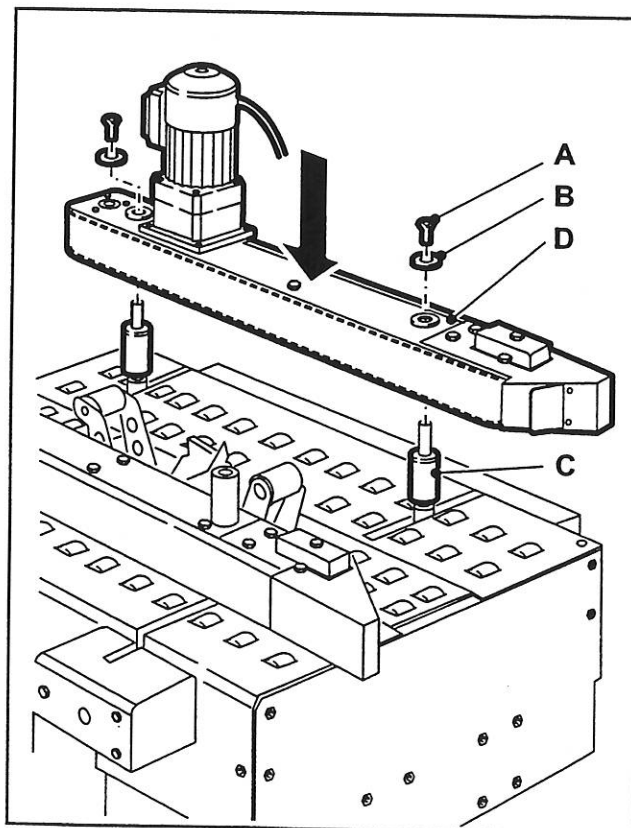


Figure 5-2 – Drive Belt Assembly, Reassembly

## Special Set-Up Procedure (Continued)



**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 Tape Leg Length

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

#### Notes

1. Changing tape leg lengths to 70 mm [2.75 in] increases minimum box height to 120 mm [4.75 in].
2. When changing tape leg length, both upper and lower taping heads must be adjusted to apply the same tape leg lengths.

### UPPER TAPING HEAD

Upper taping head is built into case sealer frame, however, it has the same mechanical components as the lower head which is a separate assembly.

To convert the upper head to 70 mm [2.75 in] tape leg length, refer to Section II, "Adjustments – Changing Tape Leg Lengths", page 13.

### LOWER TAPING HEAD

Remove the lower taping head from the case sealer by lifting the head straight up out of the machine bed.



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

Converting the lower head to apply 70 mm [2.75 in] tape legs is the same as the upper head. Refer to Section II, "Adjustments – Changing Tape Leg Lengths", page 13.

### Box Height Range

(Outer Column – Re-Positioning)



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

Moving the outer columns to the upper set of mounting holes increases the maximum box size (height) handled by the 800asb case sealer from 570 mm [22.38 in] to 670 mm [26.38 in]. **Note – this also increases the minimum box height from 70 mm [2.75 in] to 108 mm [4.25 in].**

To Re-position the outer columns:

1. Remove special nut from the bottom of each column lead screw. Figure 5-4A.
2. Remove plastic column cap from the top of each outer column as shown in Figure 5-4B.
3. Crank upper assembly up, out of plastic nuts. Lift upper assembly up and out of outer columns. Be careful not to damage lead screws. Figure 5-4C.



**WARNING** – Upper assembly weight is approximately 35 kg [75 lbs]. Lift with hoist or be sure to have adequate help available to physically lift upper assembly up and out of outer columns.

## Special Set-Up Procedure (Continued)

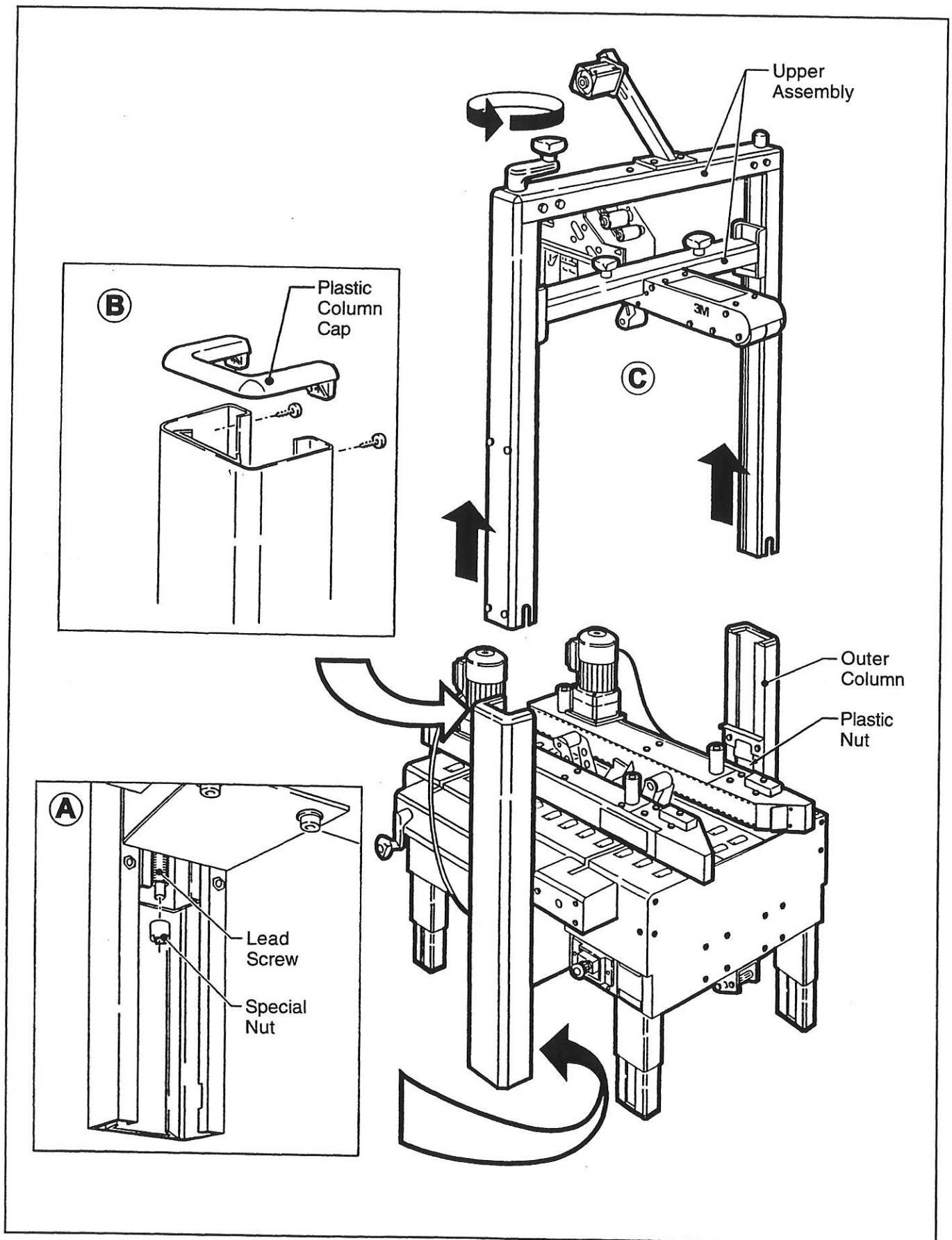


Figure 5-4 – Upper Frame Removal

## Special Set-Up Procedure (Continued)



**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.

4. Remove M6 x 16 hex hd screw, special washer and drive belt width adjustment crank. Figure 5-5.
5. Remove side covers (2) from each side of machine bed. Figure 5-5.

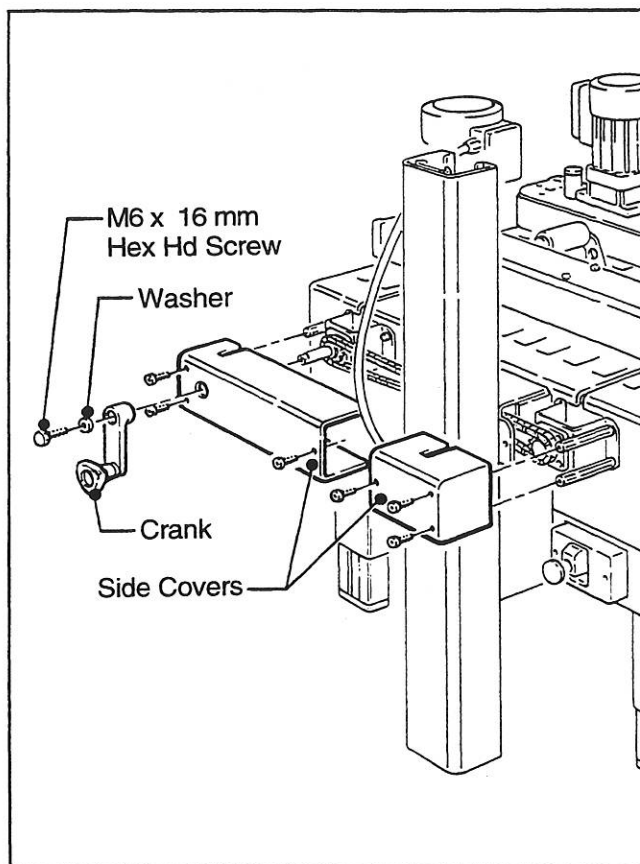


Figure 5-5 – Crank/Chain Guards

6. If necessary, slip width adjustment crank on shaft and rotate until chain master link is in convenient position for removal.

**Important** – Before removing chain, mark both front and rear sprockets/chain with chalk or paint to be sure sprockets/chain when re-assembled, will be in same position as before disassembly. Figure 5-6A and B. Do not rotate sprockets once chain is removed. (This would result in the right and left drive assemblies not being parallel.)

Loosen chain tightener, remove chain master link and remove chain. Figure 5-6C.

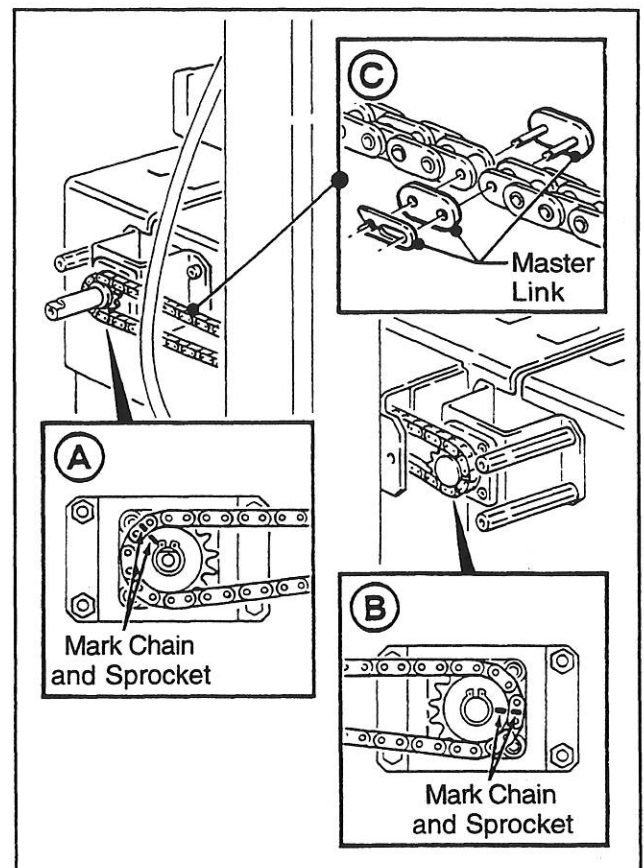


Figure 5-6 – Chain Removal



## Special Set-Up Procedure (Continued)

**⚠ 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.**

7. Remove fasteners (M8 x 16 socket head screws and M6 plain washers) that attach column spacers to machine bed and remove spacers/outer columns from machine bed. Figure 5-7A.
8. Remove fasteners (M8 x 20 socket head screws) that attach spacers to columns, move spacer down 100mm [4 in] to lower set of mounting holes and re-attach spacers to columns. Figure 5-7B.

9. Reverse procedure, Steps 7-1 to reassemble machine.

**Note –** When installing upper assembly back into machine (removed in Step 3), slide upper assembly down into outer columns until lead screws contact plastic nuts and support upper assembly. Then, slowly turn height adjustment crank counterclockwise until two "clicks" are heard, one at each plastic nut. Now the upper assembly can be cranked down (turn height adjustment crank clockwise) for installation of special nut on bottom of each lead screw.

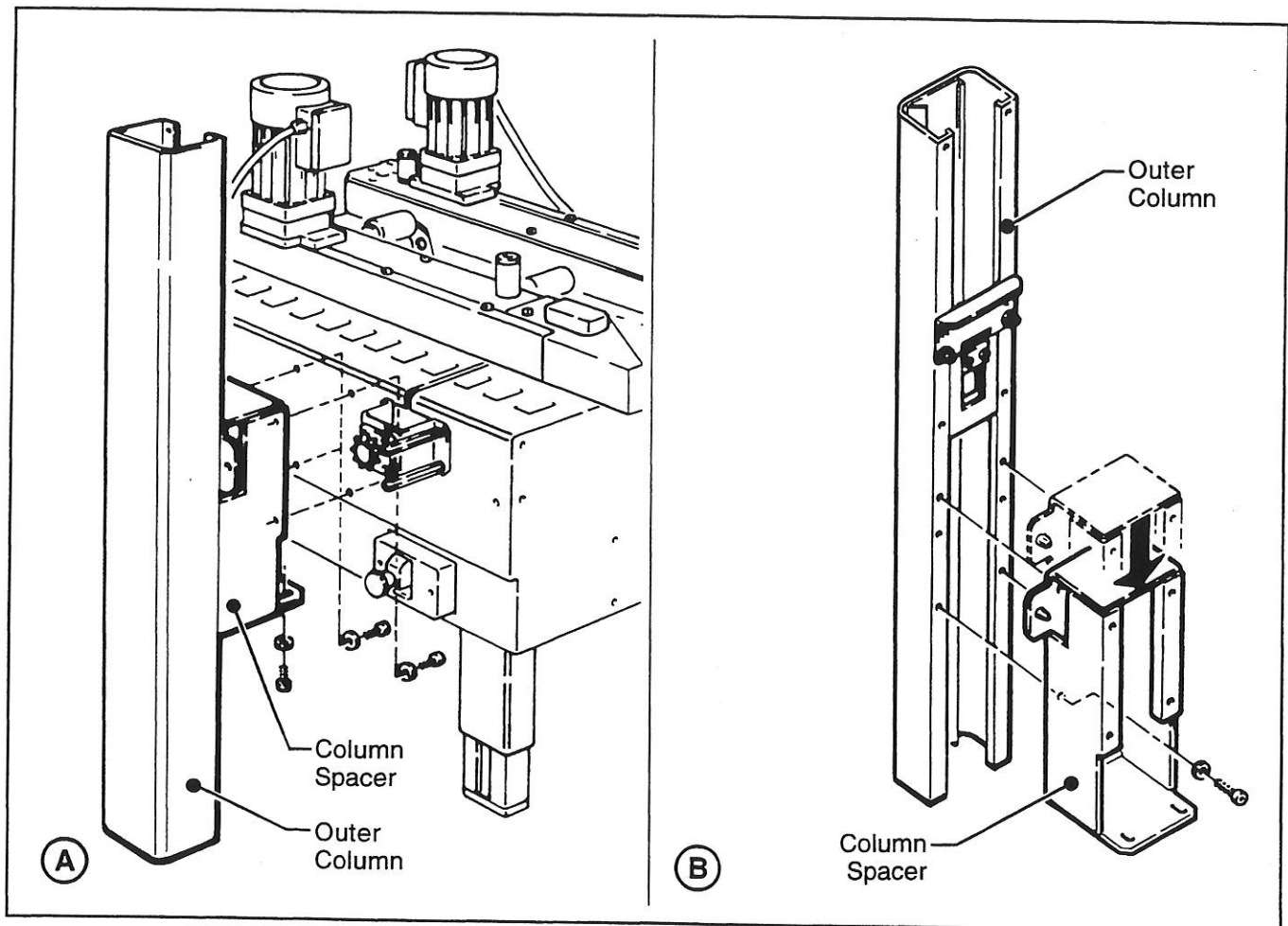


Figure 5-7 – Column Spacers/Columns

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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.

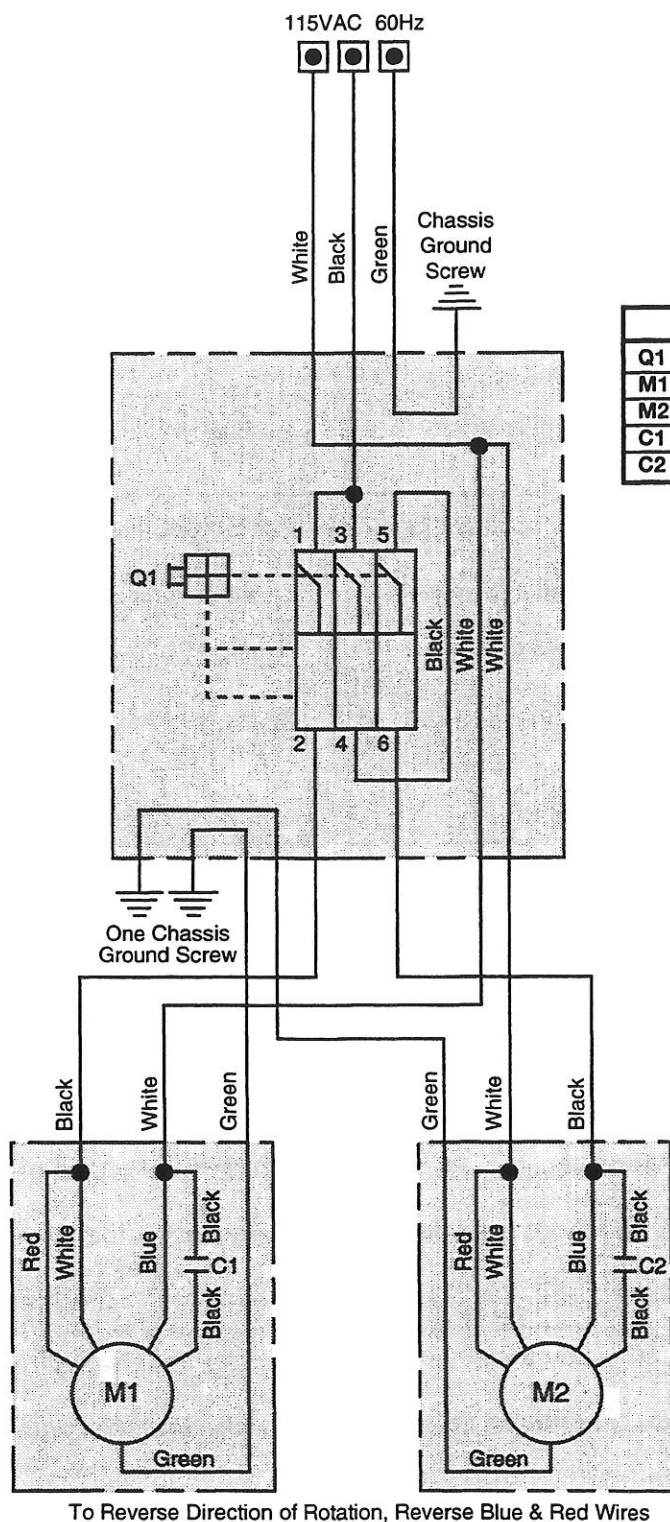
### Troubleshooting Guide

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 flap compression rollers in too tight	Readjust compression rollers
	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
Upper and lower applying mechanisms interfere with each other	Machine adjusted below minimum	Set taping heads to apply 2 inch leg lengths
Drive belt break	Worn belt	Replace belt
	Excessive belt tension	Tension to 7 lbs. per adjustment section
Squeaking noise as boxes pass through machine	Dry column bearings	Lubricate column bearings
	Defective column bearings	Replace column bearings
	Top flap compression rollers dry	Lubricate roller shafts
Tape not centered on box seam	Tape drum not centered	Reposition tape drum
	Centering guides not centered	Adjust centering guides
	Box flaps not of equal length	Check box specifications

# Electrical Diagram



**WARNING** – Turn off electrical power 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.



	Component	Ref. No.
Q1	On/Off Switch Circuit Breaker	4760-3
M1	L/S Motor	5030-13
M2	R/S Motor	5030-13
C1	Motor Run Capacitor 15 $\mu$ F 300VAC	5030-14
C2	Motor Run Capacitor 15 $\mu$ F 300VAC	5030-14

Rated Voltage – 600V  
 Rated Thermal Current – 25A  
 Set Point – 2.2A

## Notes:

1. Component & Reference Number Shown.
2. Refer to Parts List for Part Number.
3. Solid Lines Indicate Electrical Connections.
4. Dotted Lines Indicate Mechanical Connections.

Figure 7 – Electrical Diagram

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## Spare Parts/Tools

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### Spare Parts

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

#### 800asb Adjustable Case Sealer, Type 19500

Qty	Section/Ref. No.	Part Number	Description
1	I & II/4792-16	78-8094-6153-2	Roller – Applying
1	I/4793-5 & II/4798-5	78-8094-6155-7	Roller – Buffing
1	I/4793-10	78-8070-1274-1	* Spring – Upper Extension (Silver)
2	I & II/4795-2	78-8017-9173-8	* Blade – 2.56 Inch [65 mm]
4	I & II/4795-12	78-8052-6602-6	* Spring – Cutter
1	II/4798-10	78-8070-1273-3	* Spring – Lower Extension (Black)
2	I/4759-55	78-8076-5452-6	Belt – Drive, W/Hook
2	I & II/4795-6	78-8070-1390-5	Spring – Torsion
2	I/4793-12 & II/4798-12	78-8098-9095-3	* Spring – Extension

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

### Tool Kit

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

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## Options/Accessories

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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
78-8069-3926-6	Low Tape Sensor
78-8079-5560-0	Tape Application Sensor Kit
78-8095-4849-4	AccuGlide II, 1-1/2 Inch Lower Head
78-8098-8840-3	AccuGlide II, Head Parts Kit
78-8095-4861-9	Infeed/Exit Platform

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## Replacement Parts Illustrations and Parts List

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### 800asb Adjustable Case Sealer, Type 19500 With AccuGlide™ II STD 1-1/2 Inch Taping Heads

1. Refer to first illustration, **800asb Assembly**, for the **Figure Number** that identifies a specific portion of the machine.
2. Refer to the Figure or Figures to determine the individual parts required and the part reference number.
3. The parts list that follows each illustration, includes the part number and part description for the parts in that illustration.

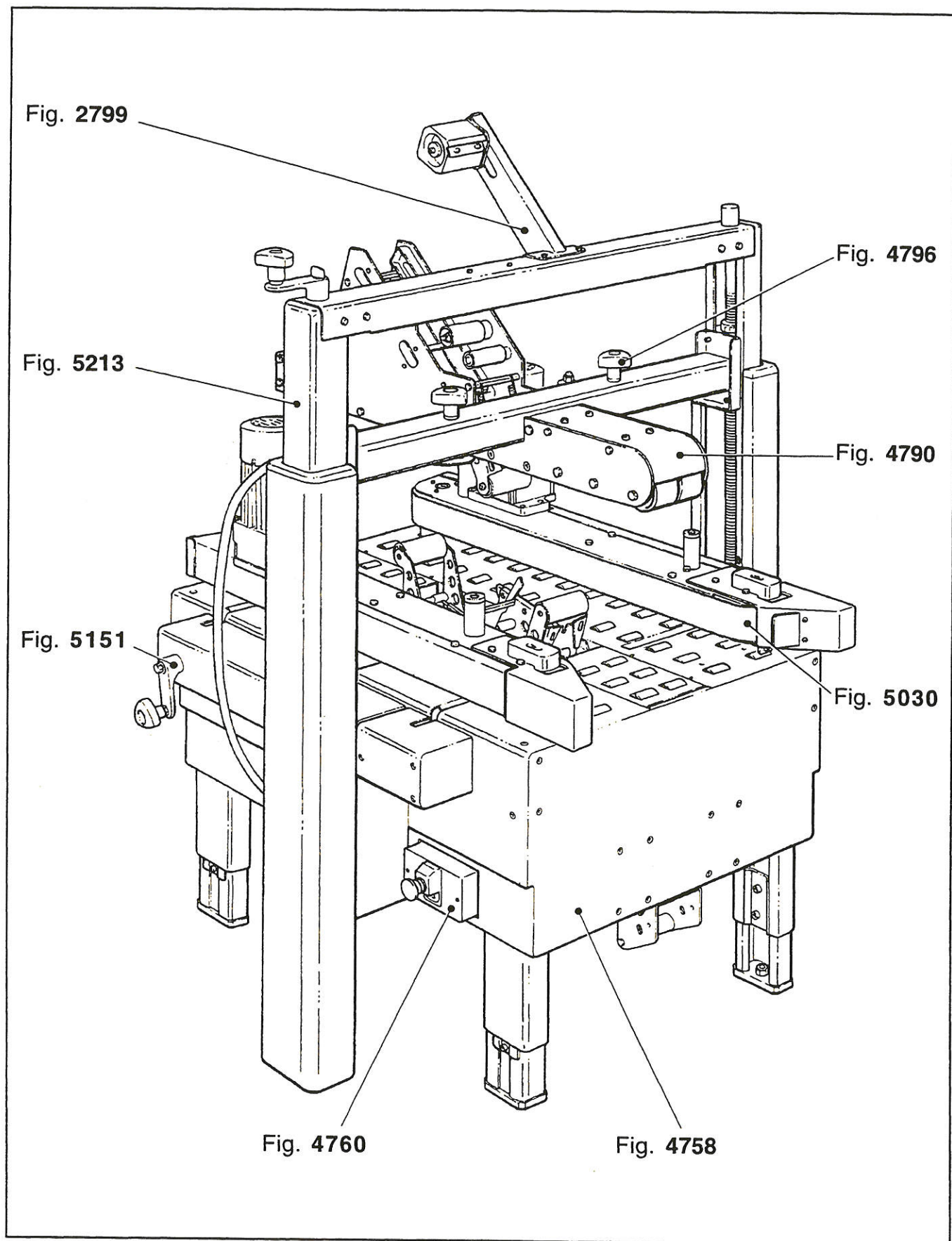
**Note** – The complete description has been included for standard fasteners and some commercially available components. This has been done to allow obtaining these standard parts locally should the customer elect to do so.

4. Refer to the first page of this instruction manual 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.



## 800asb Adjustable Case Sealer W/AccuGlide™ II STD 1-1/2 Inch Taping Heads



**800asb Assembly**

# 800asb Adjustable Case Sealer

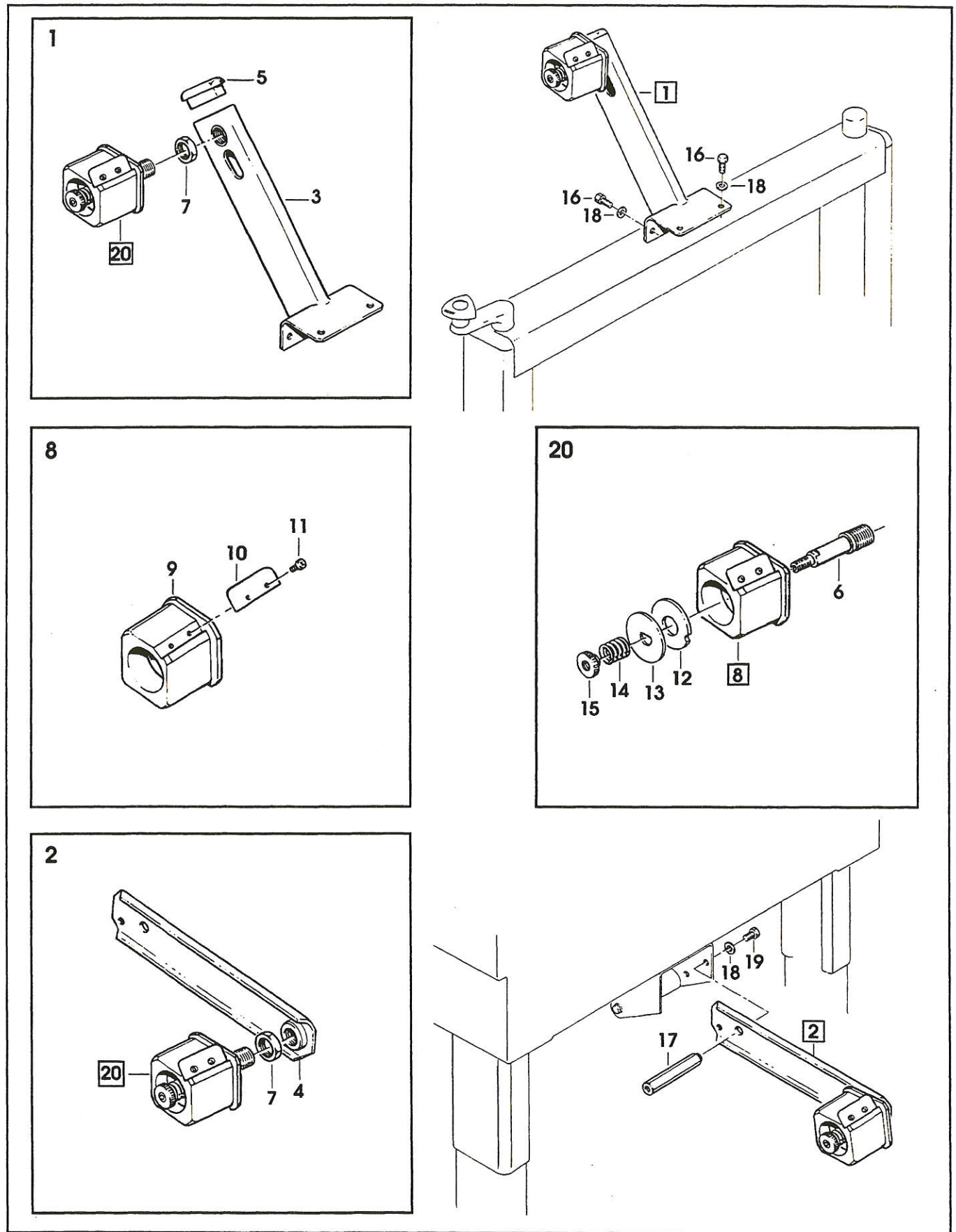


Figure 2799



**Figure 2799**

Ref. No.	3M Part No.	Description
2799-1	78-8070-1564-5	Tape Drum Bracket Assembly
2799-2	78-8070-1565-2	Tape Drum Bracket Assembly
2799-3	78-8070-1566-0	Bracket – Tape Drum
2799-4	78-8070-1395-4	Bracket – Bushing Assembly
2799-5	78-8070-1568-6	Cap – Bracket
2799-6	78-8076-4519-3	Shaft – Tape Drum
2799-7	78-8017-9169-6	Nut – M18 x 1
2799-8	78-8070-1569-4	Tape Drum Assembly – 2 Inch Wide
2799-9	78-8052-6749-5	Tape Drum Assembly
2799-10	78-8052-6268-6	Leaf Spring
2799-11	26-1002-5753-9	Screw – Self-Tapping
2799-12	78-8060-8172-1	Washer – Friction
2799-13	78-8052-6271-0	Washer – Tape Drum
2799-14	78-8054-8826-5	Spring
2799-15	78-8060-7851-1	Ring Nut – Adjusting
2799-16	78-8032-0375-7	Screw – Hex Hd, M6 x 16
2799-17	78-8070-1215-4	Spacer – Stud
2799-18	26-1000-0010-3	Washer – Flat M6
2799-19	78-8010-7169-3	Screw – Hex Hd, M6 x 12
2799-20	78-8060-8474-1	Tape Drum Assembly

## 800asb Adjustable Case Sealer

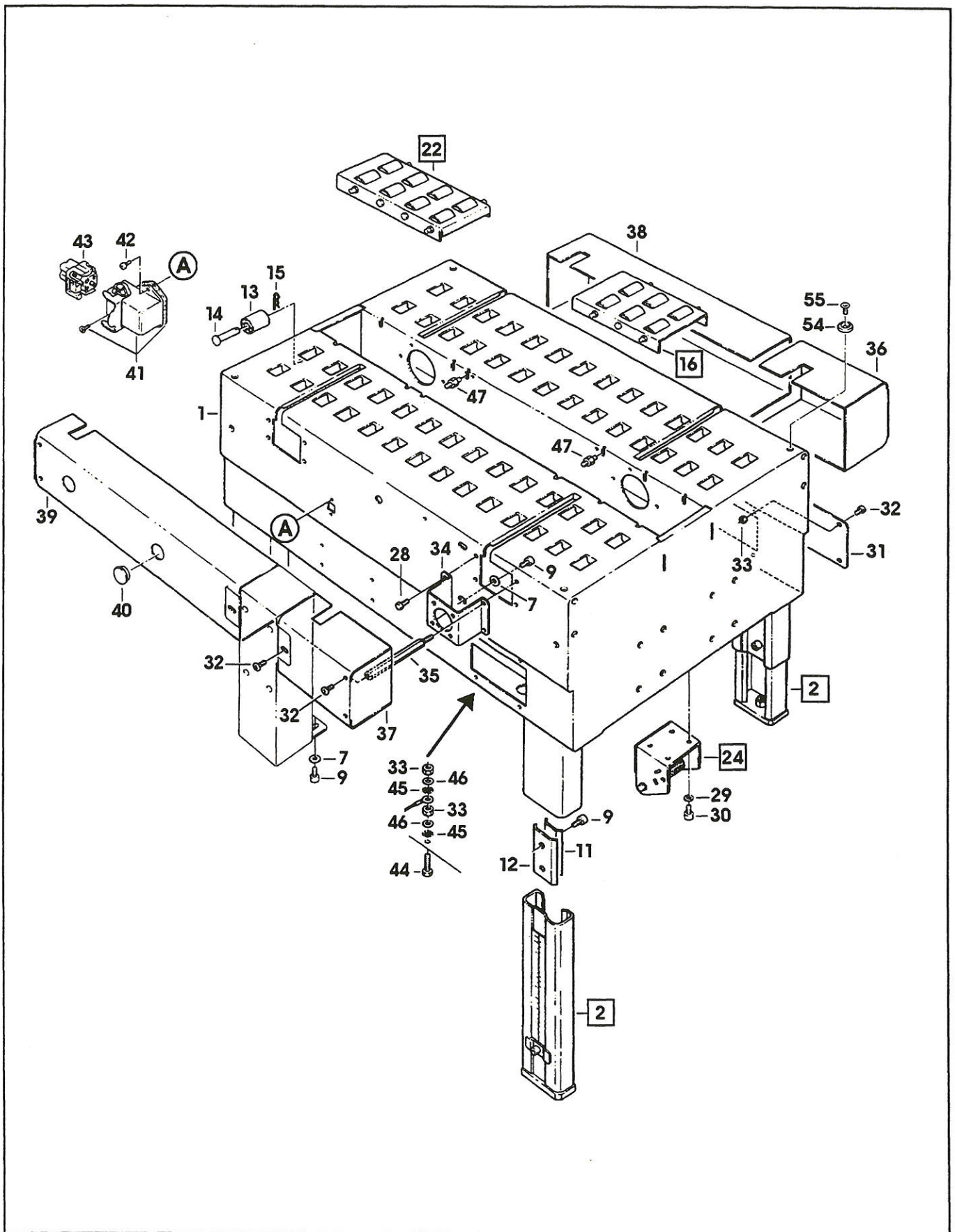


Figure 4758/1 of 2

**Figure 4758** (page 1 of 2)

Ref. No.	3M Part No.	Description
4758-1	78-8076-5380-9	Bed – Conveyor
4758-2	78-8076-5381-7	Leg Assembly – Inner, W/Stop
4758-3	78-8076-5382-5	Leg – Inner
4758-4	78-8060-8480-8	Pad – Foot
4758-5	78-8055-0867-4	Screw – Hex Hd, M8 x 30
4758-6	78-8017-9313-0	Nut – Self-Locking, M8
4758-7	78-8017-9318-9	Washer – Plain 8 mm
4758-8	78-8076-5383-3	Stop – Leg
4758-9	26-1003-7963-0	Screw – Soc Hd, M8 x 16
4758-10	78-8060-8481-6	Label – Height
4758-11	78-8052-6676-0	Clamp – Outer
4758-12	78-8052-6677-8	Clamp – Inner
4758-13	78-8060-7693-7	Roller – 32 x 38
4758-14	78-8076-5384-1	Shaft – Roller
4758-15	78-8076-5385-8	Spring
4758-16	78-8094-6100-3	Conveyor Assembly – Front
4758-17	78-8076-5387-4	Conveyor – Front
4758-18	78-8091-0780-4	Shaft – Central Roller
4758-19	78-8091-0781-2	Shaft – Side Roller
4758-20	78-8060-7852-9	Screw – Hex Hd, M6 x 10
4758-21	78-8076-5389-0	Mounting – Conveyor
4758-22	78-8094-6101-1	Conveyor Assembly – Rear
4758-23	78-8076-5391-6	Conveyor – Rear
4758-24	78-8076-5392-4	Support – Tape Drum
4758-25	78-8060-8483-2	Support – Outboard Roll Mount
4758-26	78-8060-8484-0	Shaft – Roller
4758-27	78-8060-8485-7	Roller

800asb Adjustable Case Sealer

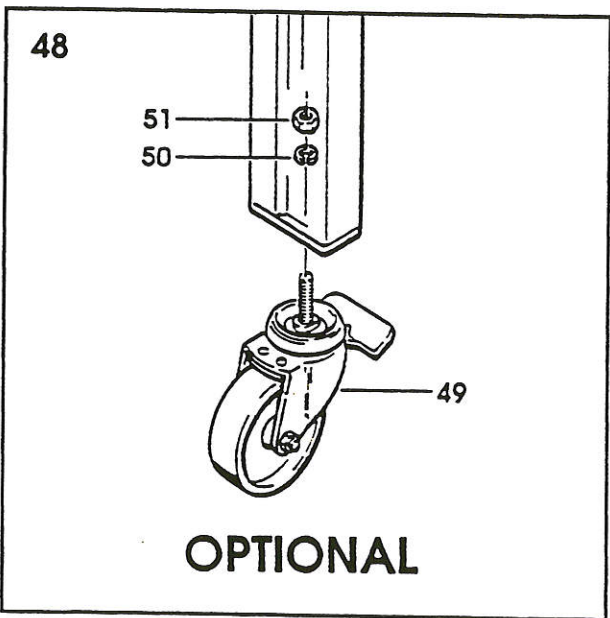
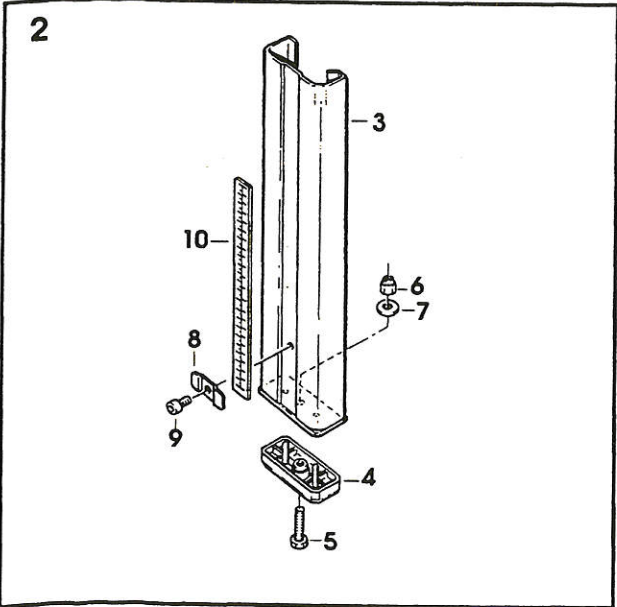
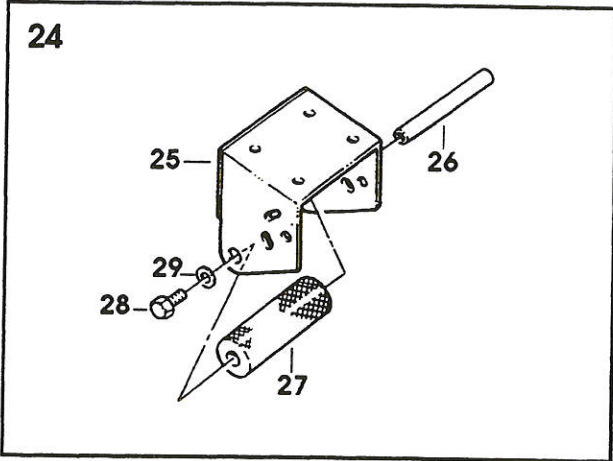
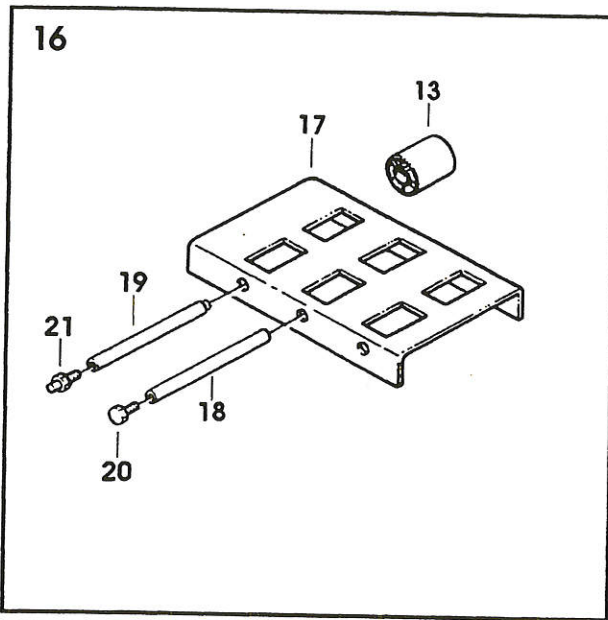
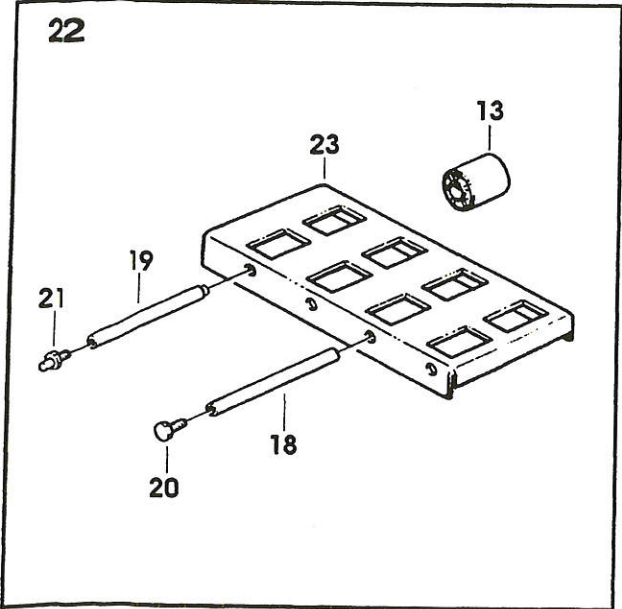


Figure 4758/2 of 2



**Figure 4758** (page 2 of 2)

Ref. No.	3M Part No.	Description
4758-28	78-8032-0375-7	Screw – Hex Hd, M6 x 16
4758-29	26-1000-0010-3	Washer – Flat M6
4758-30	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
4758-31	78-8060-8487-3	Cover – Switch
4758-32	78-8060-8087-1	Screw – M5 x 10
4758-33	78-8010-7417-6	Nut – Hex M5
4758-34	78-8076-5393-2	Plate – Tape Bracket Support
4758-35	78-8076-5394-0	Spacer
4758-36	78-8076-5395-7	Cover – Side, Front, R/H
4758-37	78-8076-5396-5	Cover – Side, Front, L/H
4758-38	78-8094-6102-9	Cover – Side, Rear, R/H
4758-39	78-8091-0511-3	Cover – Rear, Left
4758-40	78-8076-4517-7	End Cap – /22 x 1
4758-41	78-8060-7876-8	Cover – Plug Lateral
4758-42	78-8028-8208-0	Screw – 6P x 9,5
4758-43	78-8060-7873-5	Plug – Female
4758-44	78-8060-8488-1	Screw – Hex Hd, M5 x 20
4758-45	78-8046-8217-3	Washer – Special
4758-46	78-8005-5741-1	Washer – Plain M5
4758-47	78-8076-4991-4	Spacer
4758-48	78-8098-9076-3	Caster Assembly
4758-49	26-1009-9096-4	Caster – Dual Locking
4758-50	26-1009-9094-9	Washer – Spring, Helical, M12
4758-51	26-1009-9095-6	Nut – M12
4758-54	78-8100-0763-9	Washer – Special
4758-55	78-8057-5716-4	Screw – Flat Hd, M8 x 15

## 800asb Adjustable Case Sealer

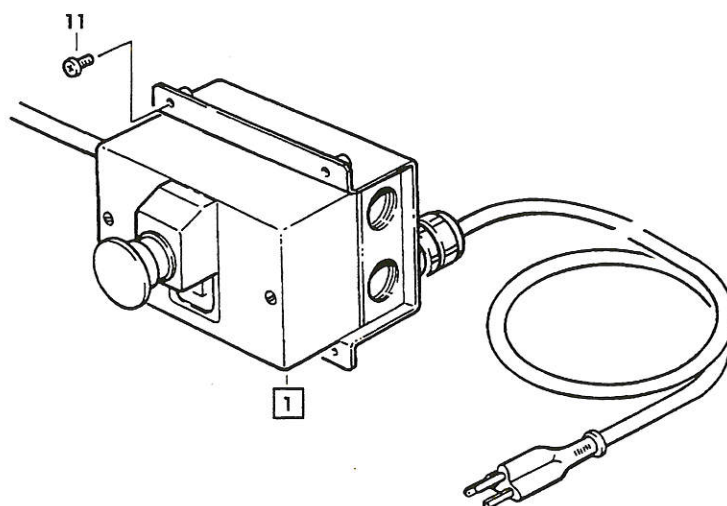
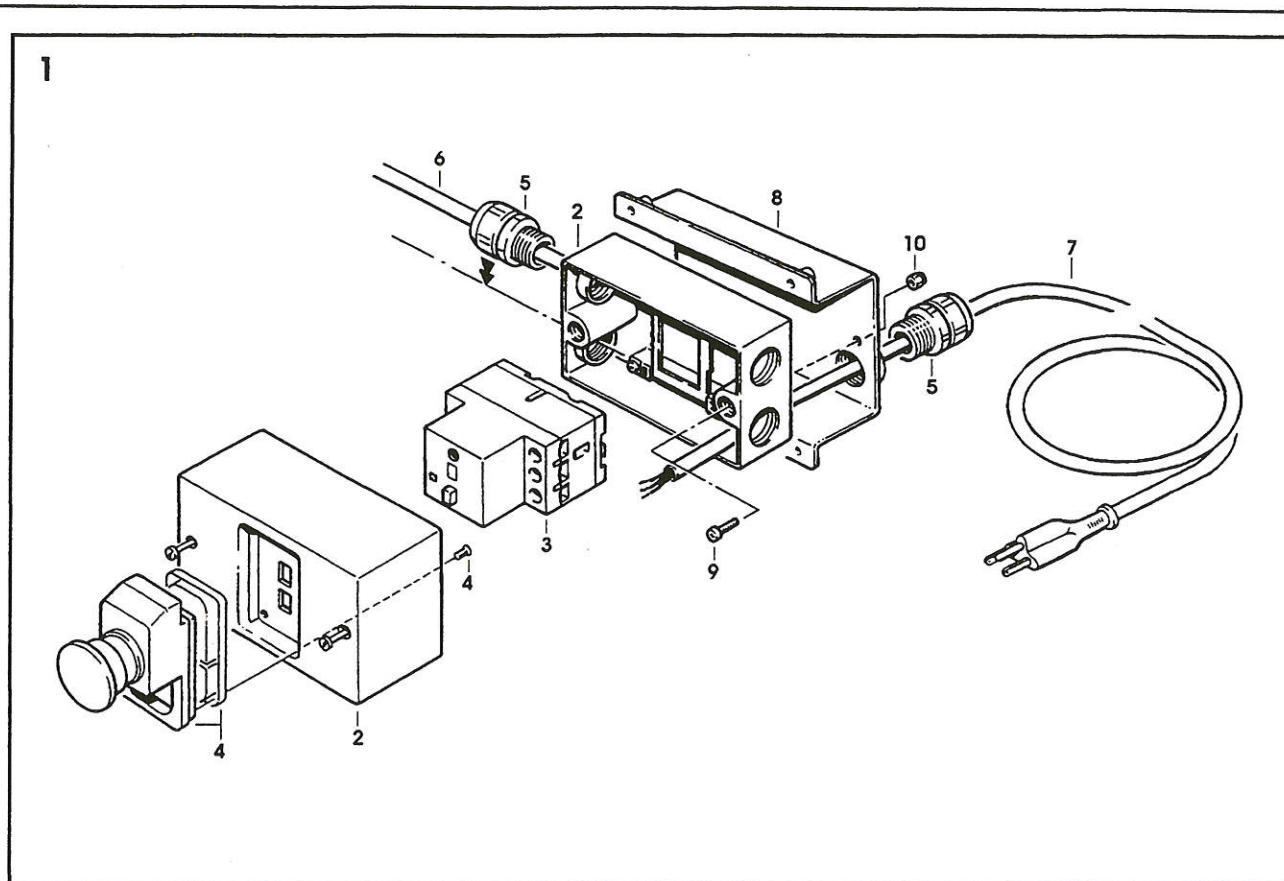


Figure 4760

**Figure 4760**

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
4760-1	78-8094-6112-8	On/Off Switch Assembly – 1.6 - 2.5 A.
4760-2	78-8076-4879-1	Box – On/Off Switch
4760-3	78-8076-5267-8	Switch – On/Off, 1.6 - 2.5 A.
4760-4	78-8076-5455-9	E-Stop Button
4760-5	78-8057-5807-1	Cord Grip
4760-6	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
4760-7	26-1009-8724-2	Power Cord W/Plug – Type SO
4760-8	78-8076-5456-7	Support – Switch
4760-9	26-1003-5707-3	Screw – Phillips Dr, M4 x 16
4760-10	26-1003-6914-4	Nut – Plastic Inset, M4
4760-11	78-8060-8087-1	Screw – M5 x 10

## 800asb Adjustable Case Sealer

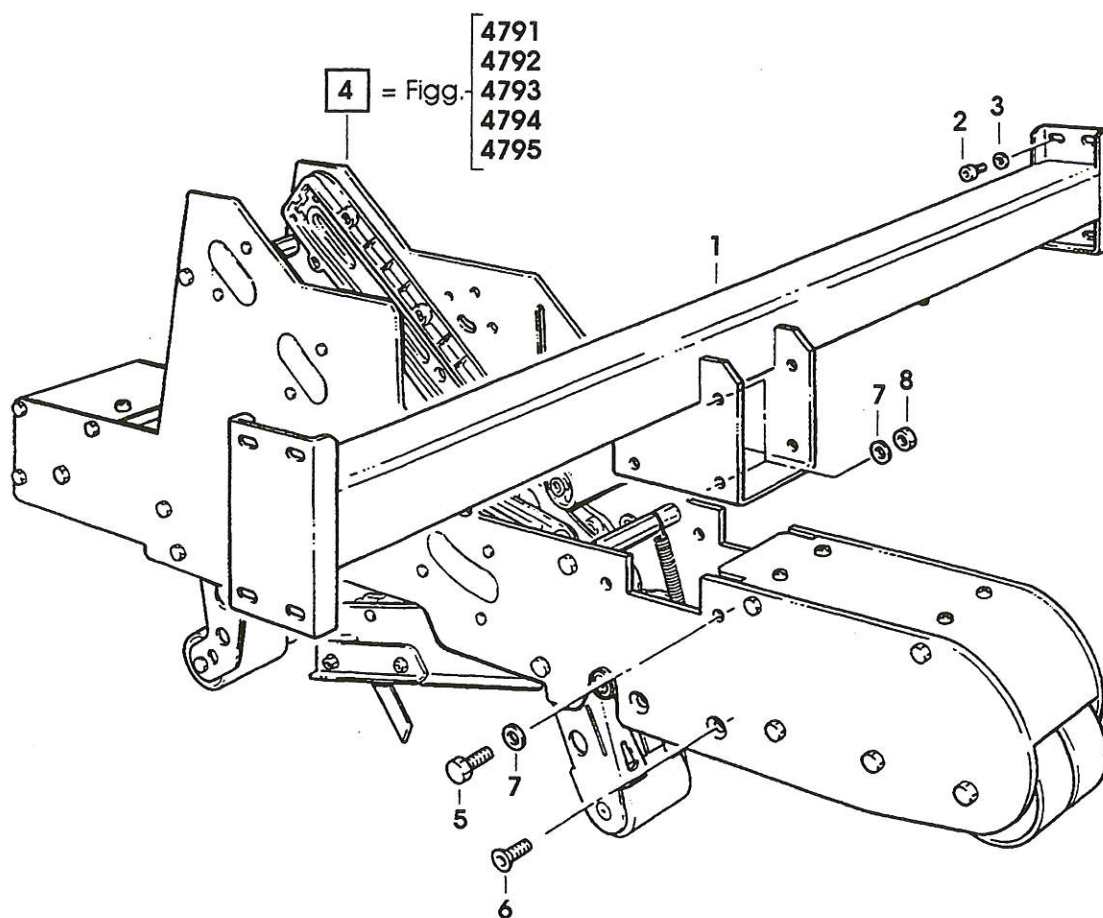


Figure 4790



**Figure 4790**

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
4790-1	78-8094-6128-4	Cross Bar
4790-2	26-1003-7957-2	Screw – Soc Hd Hex Hd, M6 x 16
4790-3	26-1000-0010-3	Washer – Flat M6
4790-4	78-8094-6129-2	Top Head Assembly – 1-1/2 Inch Wide
4790-5	26-1003-5841-0	Screw – M8 x 16
4790-6	78-8057-5716-4	Screw – Flat Head Soc, M8 x 15
4790-7	78-8017-9318-9	Washer – Plain, 8 mm
4790-8	26-1000-1347-8	Nut – Hex, M8

# 800asb Adjustable Case Sealer

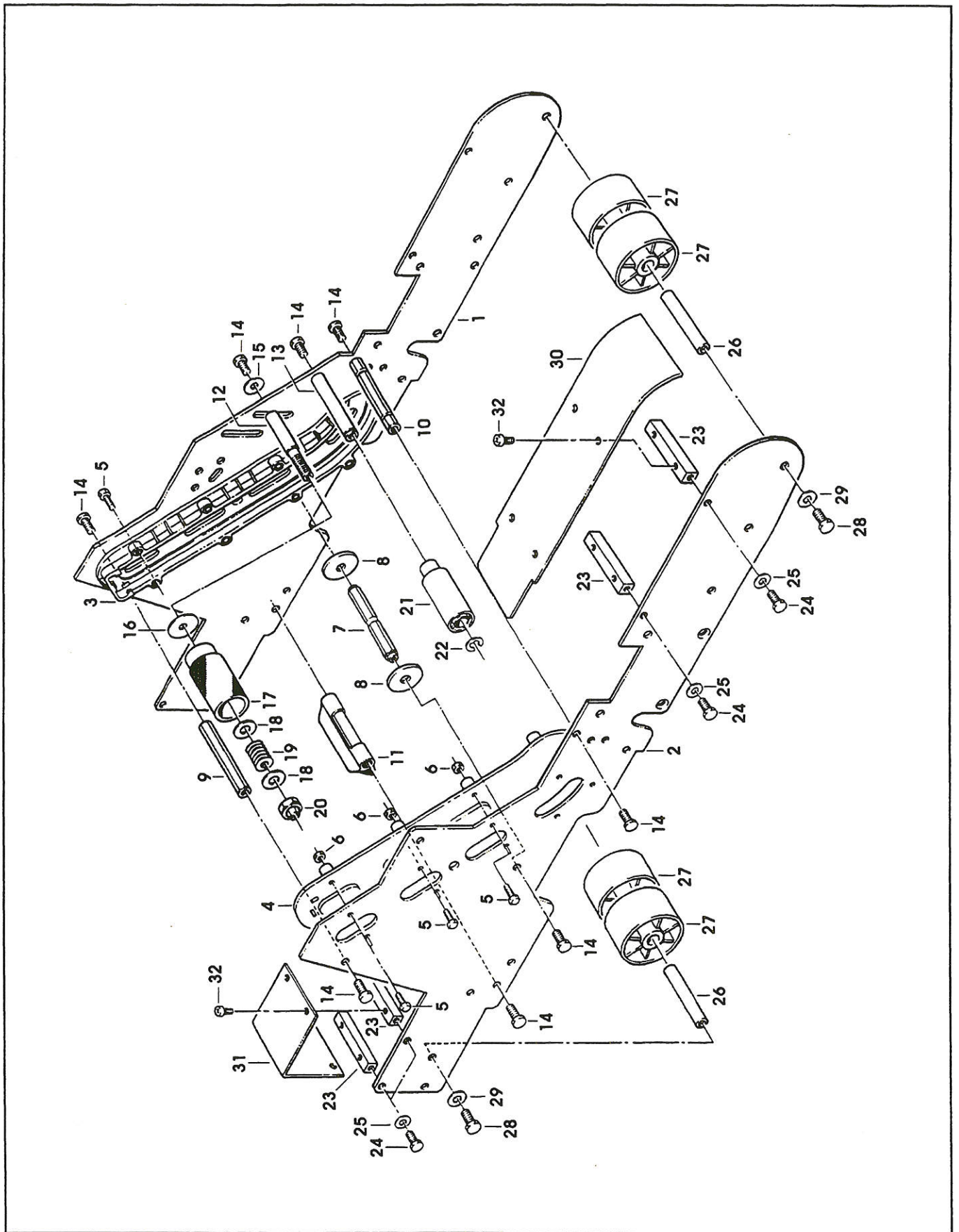


Figure 4791

**Figure 4791**

Ref. No.	3M Part No.	Description
4791-1	78-8094-6130-0	Frame – Top, R/H
4791-2	78-8094-6131-8	Frame – Top, L/H
4791-3	78-8068-4143-9	Guide – R/H
4791-4	78-8068-4144-7	Guide – L/H
4791-5	83-0002-7336-3	Screw – Hex Hd, M4 x 14
4791-6	78-8010-7416-8	Nut – Hex, M4
4791-7	78-8094-6132-6	Spacer – Spring
4791-8	78-8076-5242-1	Stop – Cut-Off Frame
4791-9	78-8094-6133-4	Stud
4791-10	78-8094-6134-2	Spacer – Hex
4791-11	78-8094-6135-9	Brush Assembly
4791-12	78-8094-6136-7	Shaft
4791-13	78-8094-6137-5	Shaft – Roller
4791-14	26-1003-5828-7	Screw – Hex Hd, M6 x 12
4791-15	78-8042-2919-9	Washer – Triple, M6
4791-16	78-8070-1268-3	Washer – Roll Back Up
4791-17	78-8094-6138-3	Roller – Tension
4791-18	78-8052-6566-3	Washer – Friction
4791-19	78-8052-6567-1	Spring – Compression
4791-20	78-8017-9077-1	Nut – Self-Locking, M10 x 1
4791-21	78-8094-6139-1	Roller – Wrap
4791-22	26-1000-1613-3	Ring – Retaining 10DIN6799
4791-23	78-8094-6140-9	Spacer
4791-24	78-8010-7169-3	Screw – Hex Hd, M6 x 12
4791-25	26-1000-0010-3	Washer – Flat, M6
4791-26	78-8094-6141-7	Shaft – /15
4791-27	78-8094-6142-5	Roller – Applying
4791-28	26-1003-5841-0	Screw – M8 x 16
4791-29	78-8017-9318-9	Washer – Plain, 8 mm
4791-30	78-8094-6143-3	Cover – Upper, Front
4791-31	78-8094-6144-1	Cover – Upper, Rear
4791-32	78-8094-6145-8	Screw – Phillis, M5 x 12

800asb Adjustable Case Sealer

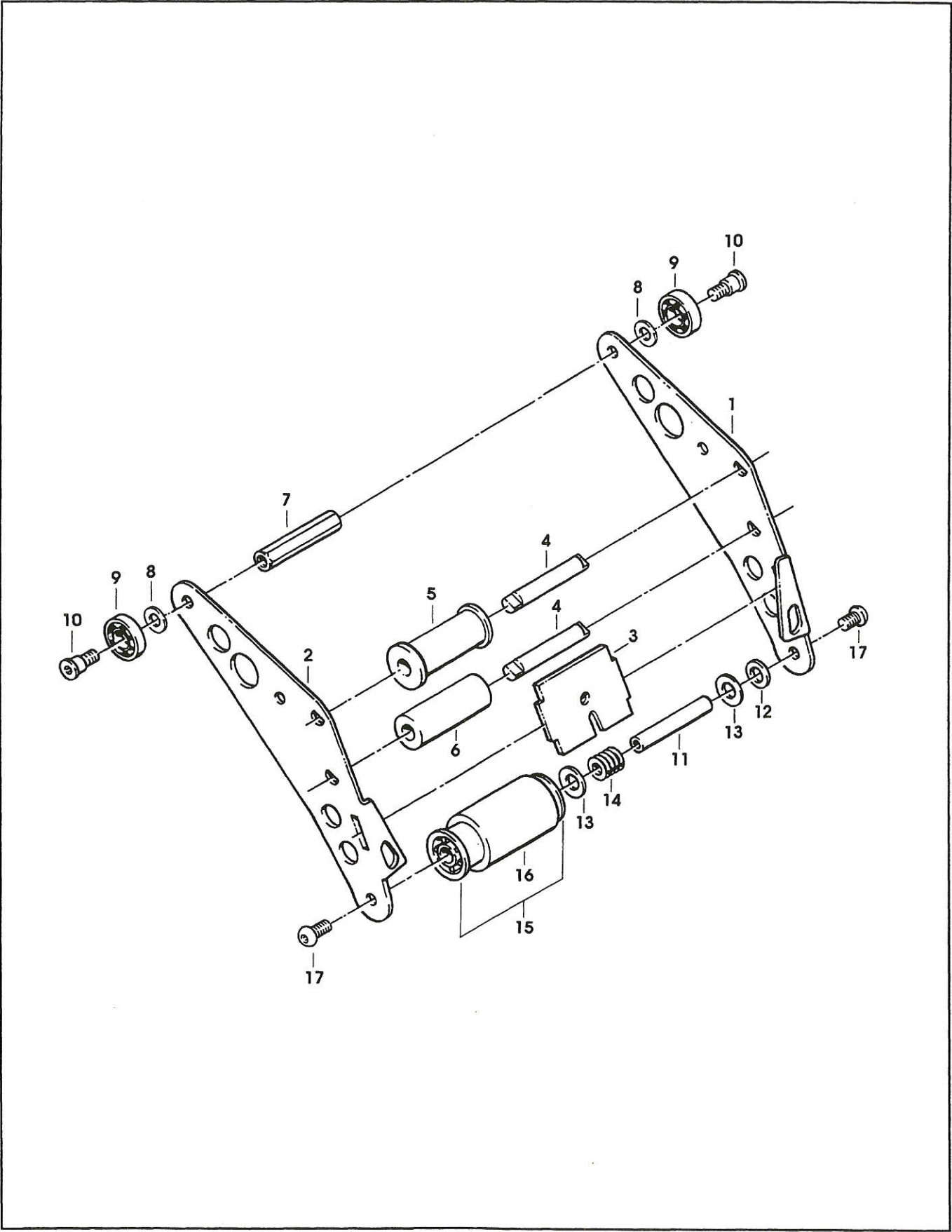


Figure 4792

**Figure 4792**

Ref. No.	3M Part No.	Description
4792-1	78-8070-1206-3	Arm – Applying, R/H
4792-2	78-8070-1207-1	Arm – Applying, L/H
4792-3	78-8094-6146-6	Plate
4792-4	78-8094-6147-4	Shaft – /10
4792-5	78-8094-6148-2	Roller – Knurled
4792-6	78-8094-6149-0	Roller
4792-7	78-8094-6150-8	Spacer – Hex
4792-8	78-8094-6151-6	Washer
4792-9	78-8017-9082-1	Bearing – 30 mm
4792-10	78-8017-9106-8	Screw – Bearing Shoulder
4792-11	78-8094-6152-4	Shaft – /10 x 48
4792-12	78-8017-9074-8	Washer – Nylon, 15 mm
4792-13	78-8052-6566-3	Washer – Friction
4792-14	78-8052-6567-1	Spring – Compression
4792-15	78-8094-6370-2	Bushing – Applying Roller
4792-16	78-8094-6153-2	Roller – Applying
4792-17	78-8076-4503-7	Screw – M6 x 12

## 800asb Adjustable Case Sealer

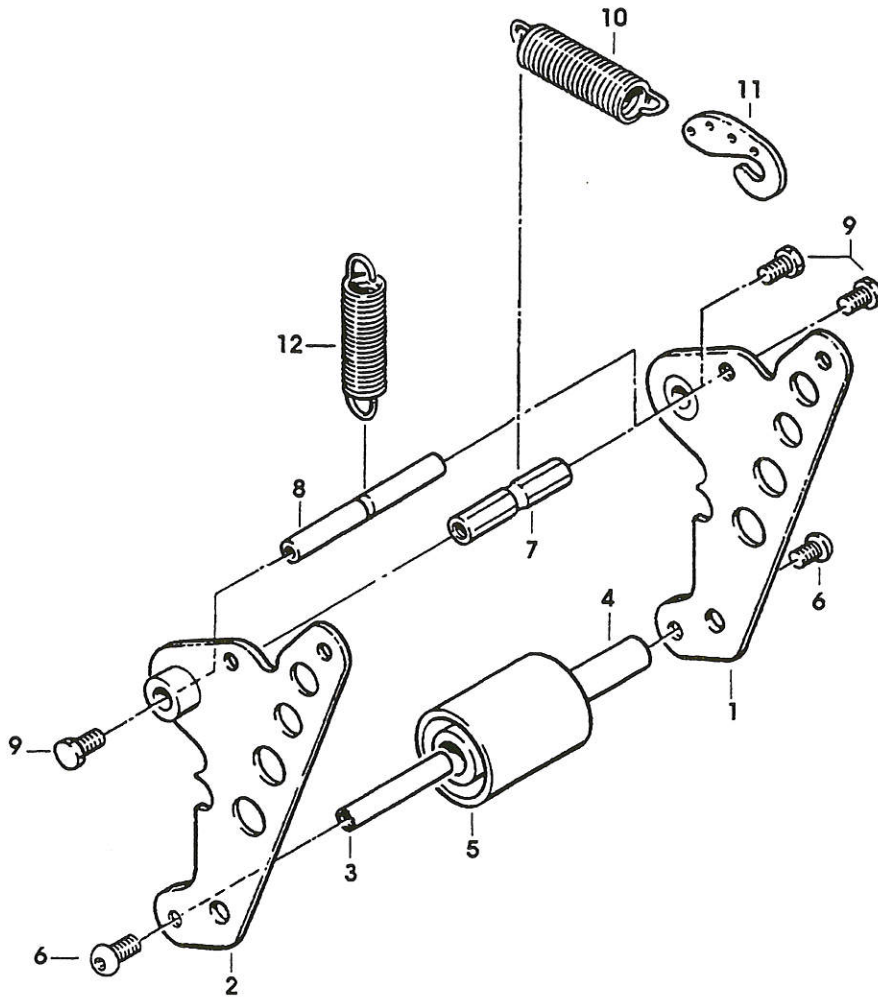


Figure 4793



**Figure 4793**

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
4793-1	78-8094-6484-1	Arm – Buffing, R/H
4793-2	78-8094-6485-8	Arm – Buffing, L/H
4793-3	78-8094-6152-4	Shaft – /10 x 48
4793-4	78-8094-6154-0	Bushing – Buffing Roller
4793-5	78-8094-6155-7	Roller – Buffing
4793-6	78-8076-4503-7	Screw – M6 x 12
4793-7	78-8094-6156-5	Spacer – Spring
4793-8	78-8094-6157-3	Shaft – /10 x 78
4793-9	26-1003-5828-7	Screw – Hex Hd, M6 x 12
4793-10	78-8070-1274-1	Spring – Upper (Silver)
4793-11	78-8070-1244-4	Holder – Spring
4793-12	78-8098-9095-3	Spring – Extension

## 800asb Adjustable Case Sealer

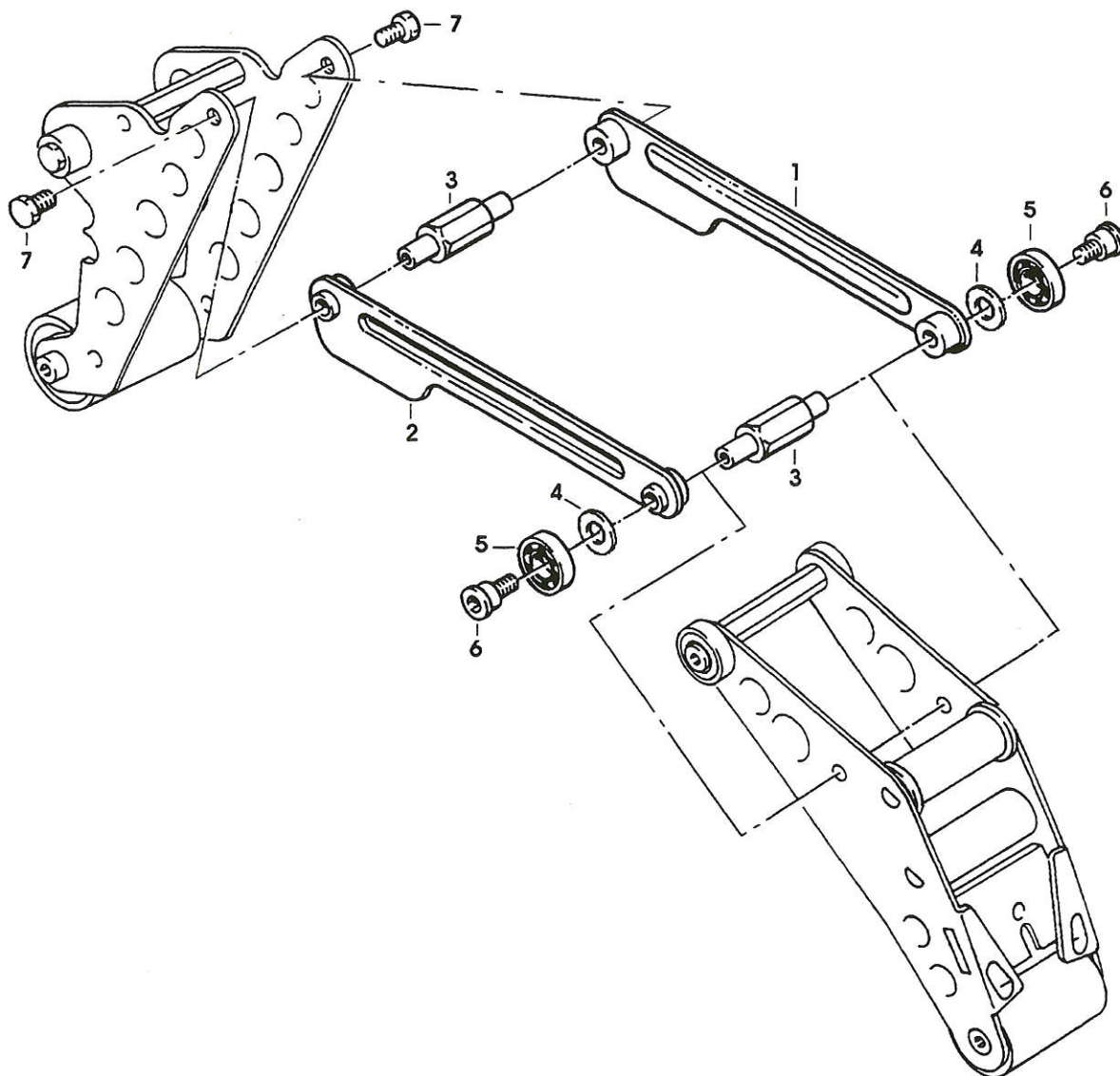


Figure 4794



**Figure 4794**

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
4794-1	78-8070-1388-9	Link – Arm Bushing Assembly
4794-2	78-8070-1389-7	Link – Arm Bushing Assembly
4794-3	78-8094-6158-1	Shaft – Pivot
4794-4	78-8094-6151-6	Washer
4794-5	78-8017-9082-1	Bearing – Special, 30 mm
4794-6	78-8017-9106-8	Screw – Bearing Shoulder
4794-7	78-8060-7852-9	Screw – Hex Hd, M6 x 10, Special

## 800asb Adjustable Case Sealer

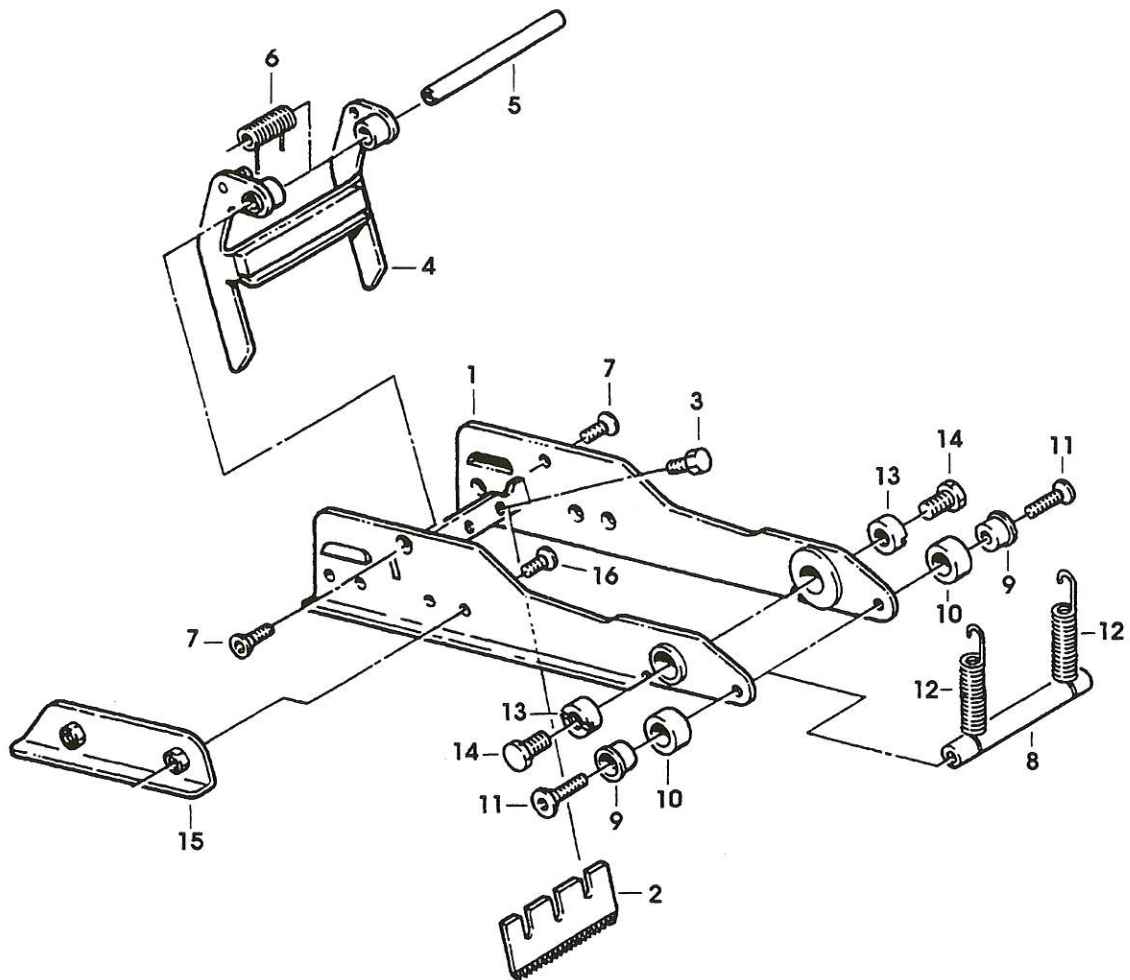


Figure 4795

**Figure 4795**

<b>Ref. No.</b>	<b>3M Part No.</b>	<b>Description</b>
4795-1	78-8094-6159-9	Frame – Cut-Off Weldment
4795-2	78-8017-9173-8	Blade – 2.56 Inches (65 mm)
4795-3	26-1002-5817-2	Screw – Hex Hd, M5 x 8
4795-4	78-8094-6160-7	Guard – Blade
4795-5	78-8094-6161-5	Stud
4795-6	78-8070-1390-5	Spring – Torsion
4795-7	26-1005-4758-2	Screw – Flat Hd, M4 x 10
4795-8	78-8094-6162-3	Shaft – Spring
4795-9	78-8052-6600-0	Spacer
4795-10	78-8070-1269-1	Bumper
4795-11	26-1005-4757-4	Screw – Flat Hd, M5 x 20
4795-12	78-8052-6602-6	Spring – Cutter
4795-13	78-8017-9132-4	Pivot – Cutter Lever
4795-14	78-8060-7852-9	Screw – Hex Hd, M6 x 10, Special
4795-15	78-8070-1216-2	Slide – Extension
4795-16	26-1008-6574-5	Screw – Flat Hd, Phillips Dr, M4 x 10

## 800asb Adjustable Case Sealer

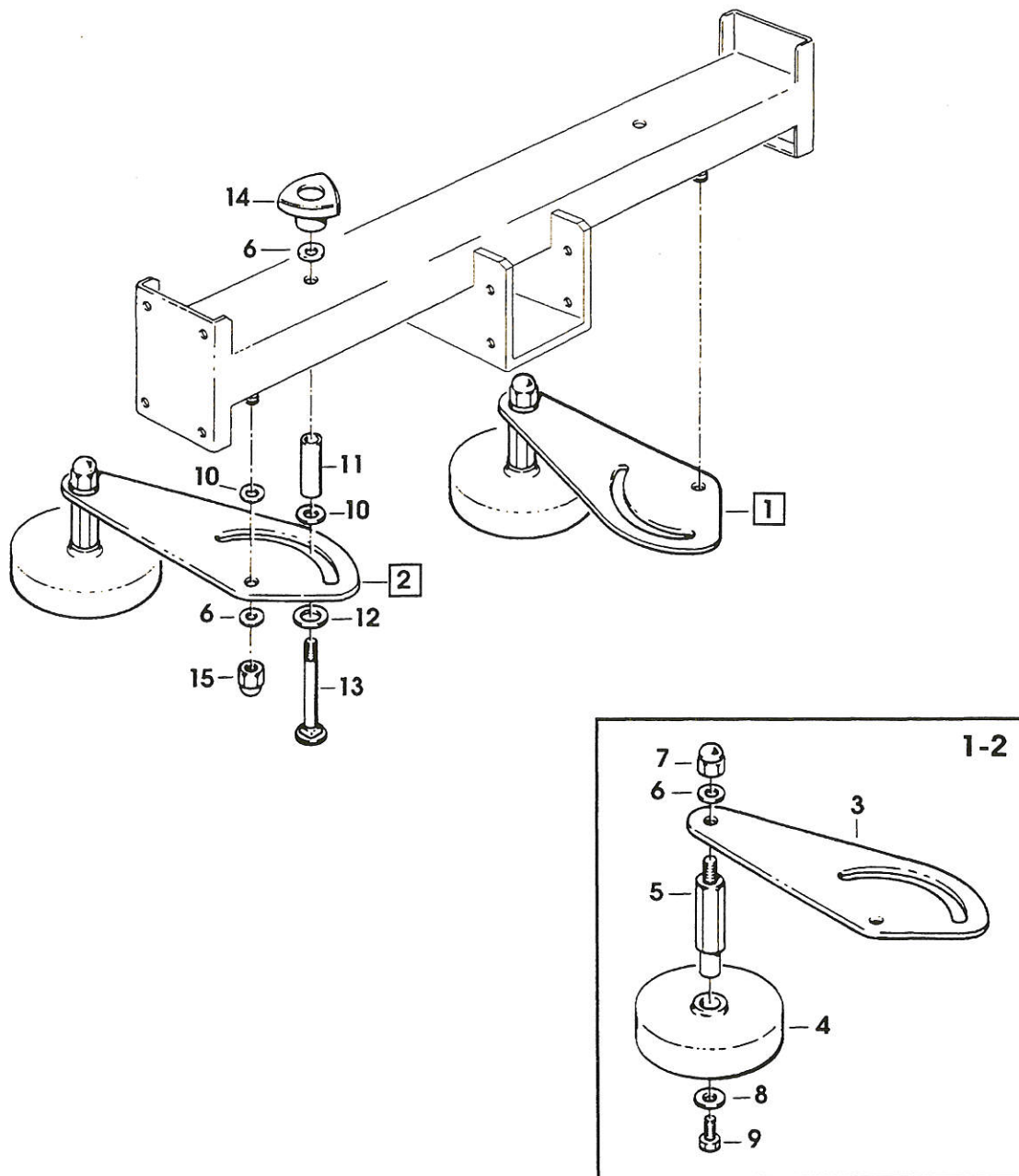


Figure 4796

**Figure 4796**

Ref. No.	3M Part No.	Description
4796-1	78-8094-6163-1	Roller Assembly – R/H
4796-2	78-8094-6164-9	Roller Assembly – L/H
4796-3	78-8070-1559-5	Support – Compression Roller
4796-4	78-8054-8974-3	Pressure Roller
4796-5	78-8094-6165-6	Shaft – Roller
4796-6	78-8052-6566-3	Washer – Friction
4796-7	78-8070-1561-1	Nut – M10
4796-8	26-1004-5507-5	Washer – M8
4796-9	26-1003-5841-0	Screw – M8 x 16
4796-10	78-8017-9074-8	Washer – Nylon 15 mm
4796-11	78-8070-1562-9	Tube – Roller Support
4796-12	12-7991-1752-3	Washer – Plain M14
4796-13	78-8070-1563-7	Screw – M10 x 80
4796-14	78-8070-1549-6	Knob – VTR-B-M10
4796-15	26-1003-6918-5	Nut – Plastic Insert, M10 Hex Flange

# 800asb Adjustable Case Sealer

1-71= R/H  
2-72= L/H

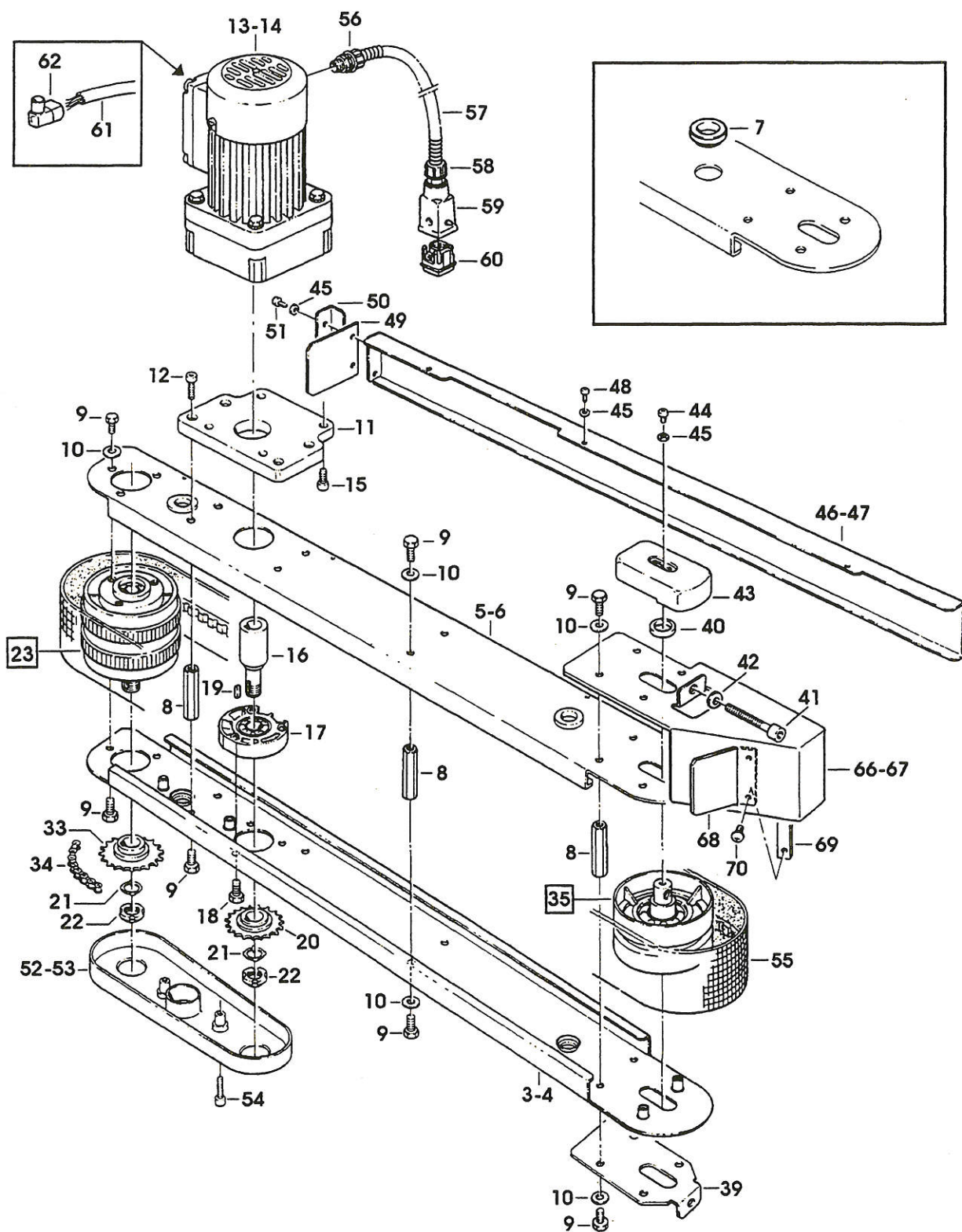


Figure 5030/1 of 2



**Figure 5030** (page 1 of 2)

Ref. No.	3M Part No.	Description
5030-1	78-8094-6371-0	Drive Assembly – R/H W/O Motor
5030-2	78-8094-6372-8	Drive Assembly – L/H W/O Motor
5030-3	78-8094-6105-2	Guide – Lower, R/H
5030-4	78-8094-6106-0	Guide – Lower, L/H
5030-5	78-8094-6107-8	Guide – Upper, R/H
5030-6	78-8094-6108-6	Guide – Upper, L/H
5030-7	78-8091-0500-6	Bushing – Side Drive
5030-8	78-8055-0661-1	Spacer
5030-9	26-1003-5828-7	Screw – Hex Hd, M6 x 12
5030-10	26-1000-0010-3	Washer – Flat M6
5030-11	78-8094-6109-4	Support – Gearmotor
5030-12	78-8010-7211-3	Screw – Soc Hd, M6 x 25
5030-13	78-8070-1522-3	Gearmotor – 115V, 60 Hz
5030-14	26-1011-8828-7	Capacitor – 115V Gearmotor
5030-15	78-8070-1523-1	Screw – 1/4 - 28 x 1/2 SHCS
5030-16	78-8094-6174-8	Extension – Gearmotor
5030-17	78-8076-5439-3	Flange Assembly
5030-18	78-8060-7886-7	Screw – Hex Hd, M6 x 16, Special
5030-19	78-8046-8135-7	Key – 5 x 5, 12 mm
5030-20	78-8091-0758-0	Sprocket – 3/8 Inch, Z=14
5030-21	78-8057-5834-5	Tab Washer
5030-22	78-8057-5835-2	Centering Washer
5030-23	78-8076-5440-1	Pulley Assembly – Drive
5030-24	78-8091-0716-8	Roller – Drive
5030-25	78-8052-6713-1	Ring – Polyurethane
5030-26	78-8055-0669-4	Shaft – Pulley Keyed
5030-27	78-8057-5739-6	Key – M5 x 5 x 30 mm
5030-28	78-8055-0668-6	Washer – 15/26 x 1
5030-29	78-8091-0382-9	Belleville Washer – /16
5030-30	78-8076-5442-7	Flange Assembly
5030-31	26-0001-5862-1	Screw – Flat Hd Soc, M5 x 12
5030-32	78-8054-8877-8	Washer – 5,5/20 x 4
5030-33	78-8091-0759-8	Sprocket – 3/8 Inch Z=23
5030-34	78-8076-4933-6	Chain – 3/8 Inch Pitch, 52 Pitch

1 w/o Motor  
71 w/ Motor

2 w/o Motor  
72 w/ Motor

65  
64  
63

62

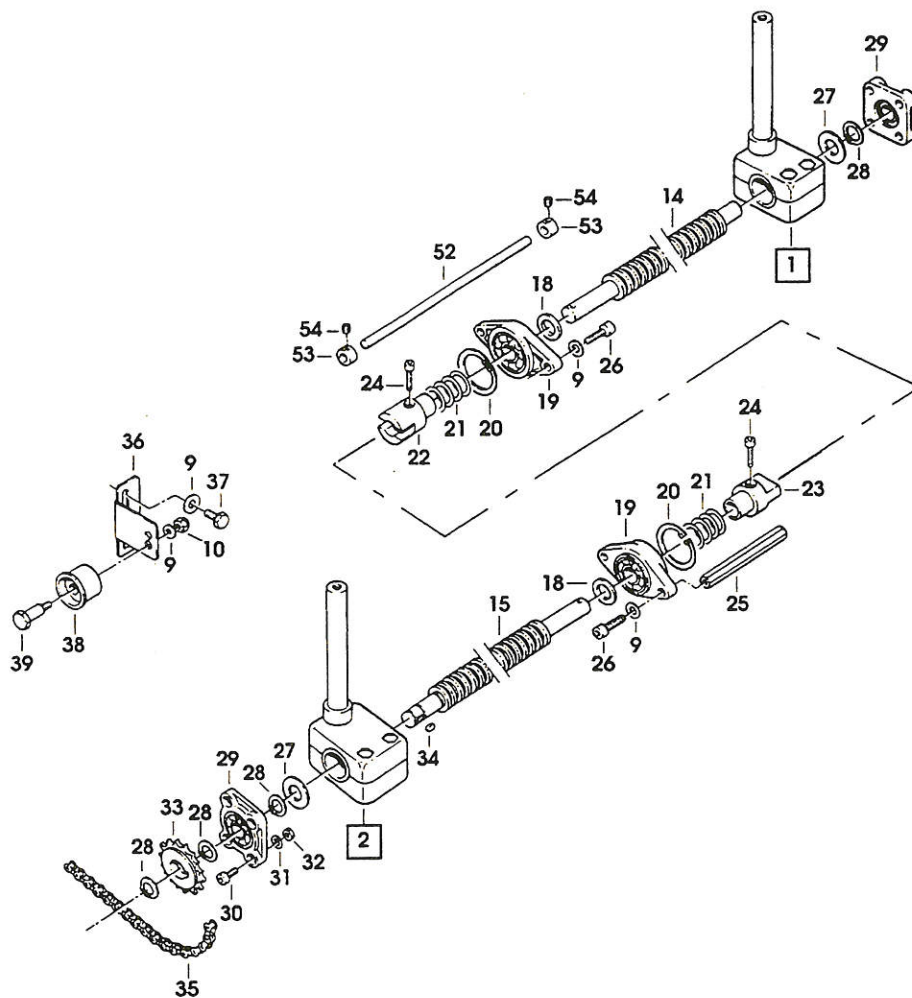


**Figure 5030** (page 2 of 2)

Ref. No.	3M Part No.	Description
5030-35	78-8076-5443-5	Pulley Assembly – Idler
5030-36	78-8055-0660-3	Roller – Idler
5030-37	78-8076-5444-3	Shaft – Idler Pulley
5030-38	12-7997-0272-0	E-Ring – M-25
5030-39	78-8076-5445-0	Tensioning – Belt
5030-40	78-8076-5446-8	Washer – Shaft
5030-41	78-8076-5447-6	Screw – Special, M8 x 70
5030-42	78-8017-9318-9	Washer – Plain 8 mm
5030-43	78-8076-5448-4	Cover – Belt Tensioner
5030-44	78-8055-0850-0	Screw – Cap, M4 x 6
5030-45	78-8005-5740-3	Washer – Plain 4 mm
5030-46	78-8094-6110-2	Cover – Drive, R/H
5030-47	78-8094-6111-0	Cover – Drive, L/H
5030-48	26-1002-5753-9	Screw – Self-Tapping
5030-49	78-8055-0650-4	Guard – Belt
5030-50	78-8076-5451-8	Guard – Belt
5030-51	26-1002-4955-1	Screw – Self-Tap 8P x 13
5030-52	78-8091-0764-8	Cover – Chain, Right
5030-53	78-8091-0765-5	Cover – Chain, Left
5030-54	78-8010-7165-1	Screw – Flat Hd Soc, M5 x 25
5030-55	78-8076-5452-6	Belt – Box Drive
5030-56	78-8060-7631-7	Connector – 3/8 Inch
5030-57	78-8076-5197-7	Sleeving – /12, 800 mm
5030-58	78-8060-7626-7	Connector – PG 11/12
5030-59	78-8060-7877-6	Plug Housing – Vertical
5030-60	78-8060-7875-0	Plug Male
5030-61	78-8060-8053-3	Wire – 3-Pole, 5 Meters Length
5030-62	78-8076-4602-7	Terminal
5030-63	78-8076-5434-4	Roller
5030-64	78-8054-8577-4	Washer – Special
5030-65	26-1001-9843-6	Screw – Flat Soc Hd, M6 x 16
5030-66	78-8094-6373-6	Belt Tensioning Assembly – R/H
5030-67	78-8094-6374-4	Belt Tensioning Assembly – L/H
5030-68	78-8094-6375-1	Guard – Rubber
5030-69	78-8052-6715-6	Bracket
5030-70	78-8094-6145-8	Screw – Phillips, M5 x 12
5030-71	78-8098-9004-5	Drive Assembly With Motor – R/H
5030-72	78-8098-9005-2	Drive Assembly With Motor – L/H

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FRONT



• = Pos.3 and 4  
to be ordered  
always together

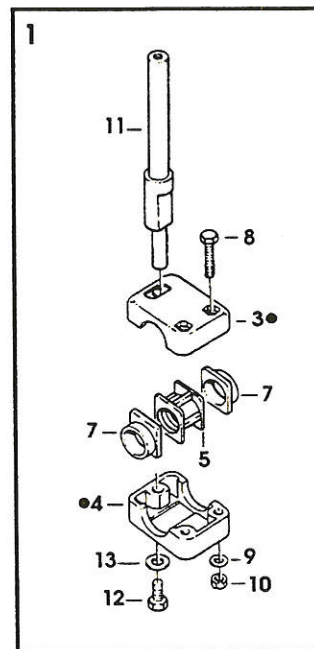
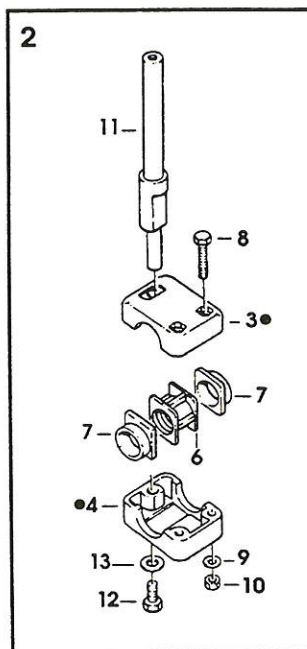


Figure 5151/1 of 2

**Figure 5151** (page 1 of 2)

Ref. No.	3M Part No.	Description
5151-1	78-8076-5399-9	Block Assembly – R/H
5151-2	78-8076-5400-5	Block Assembly – L/H
5151-3	78-8076-5401-3	Block – Upper
5151-4	78-8076-5402-1	Block – Lower
5151-5	78-8076-5403-9	Nut – Block, R/H
5151-6	78-8076-5404-7	Nut – Block, L/H
5151-7	78-8076-5405-4	Bushing – Block
5151-8	78-8076-5239-7	Screw – Hex Hd, M6 x 50
5151-9	26-1000-0010-3	Washer – Flat M6
5151-10	26-1003-6916-9	Nut – Locking, Plastic Insert M6
5151-11	78-8076-5406-2	Shaft – Drive Mount
5151-12	26-1003-5842-8	Screw – Hex Hd, M8 x 20
5151-13	78-8017-9318-9	Washer – Plain 8 mm
5151-14	78-8076-5407-0	Screw – R/H
5151-15	78-8076-5408-8	Screw – L/H
5151-16	78-8076-5409-6	Screw – Handle, R/H
5151-17	78-8076-5410-4	Screw – Handle, L/H
5151-18	78-8076-5411-2	Spacer – Screw
5151-19	78-8076-5412-0	Flange – W/Bearing
5151-20	78-8060-8010-3	Snap Ring – 42 mm Shaft
5151-21	78-8076-5413-8	Spring
5151-22	78-8076-5414-6	Coupling – Screw
5151-23	78-8076-5415-3	Coupling – Female, Screw
5151-24	26-1003-7946-5	Screw – Soc Hd, M4 x 25
5151-25	78-8076-5416-1	Spacer – Hex, 10 x 107
5151-26	78-8010-7211-3	Screw – Soc Hd, M6 x 25
5151-27	78-8076-5417-9	Spacer

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REAR

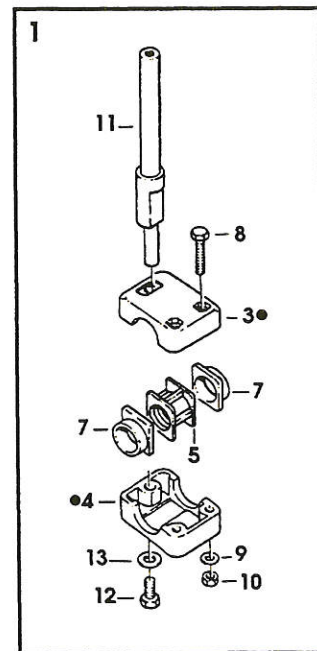
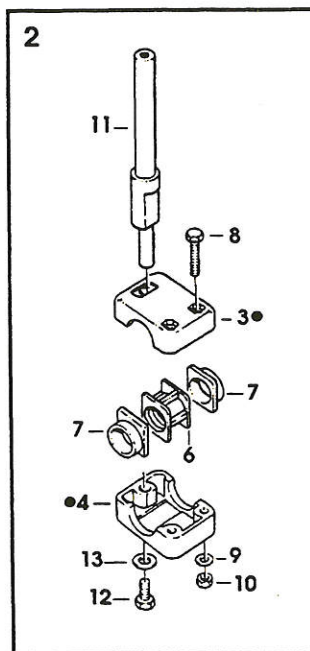
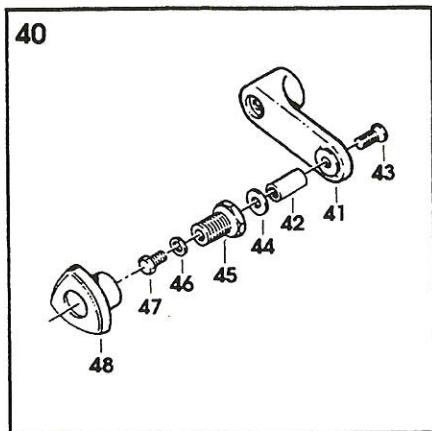
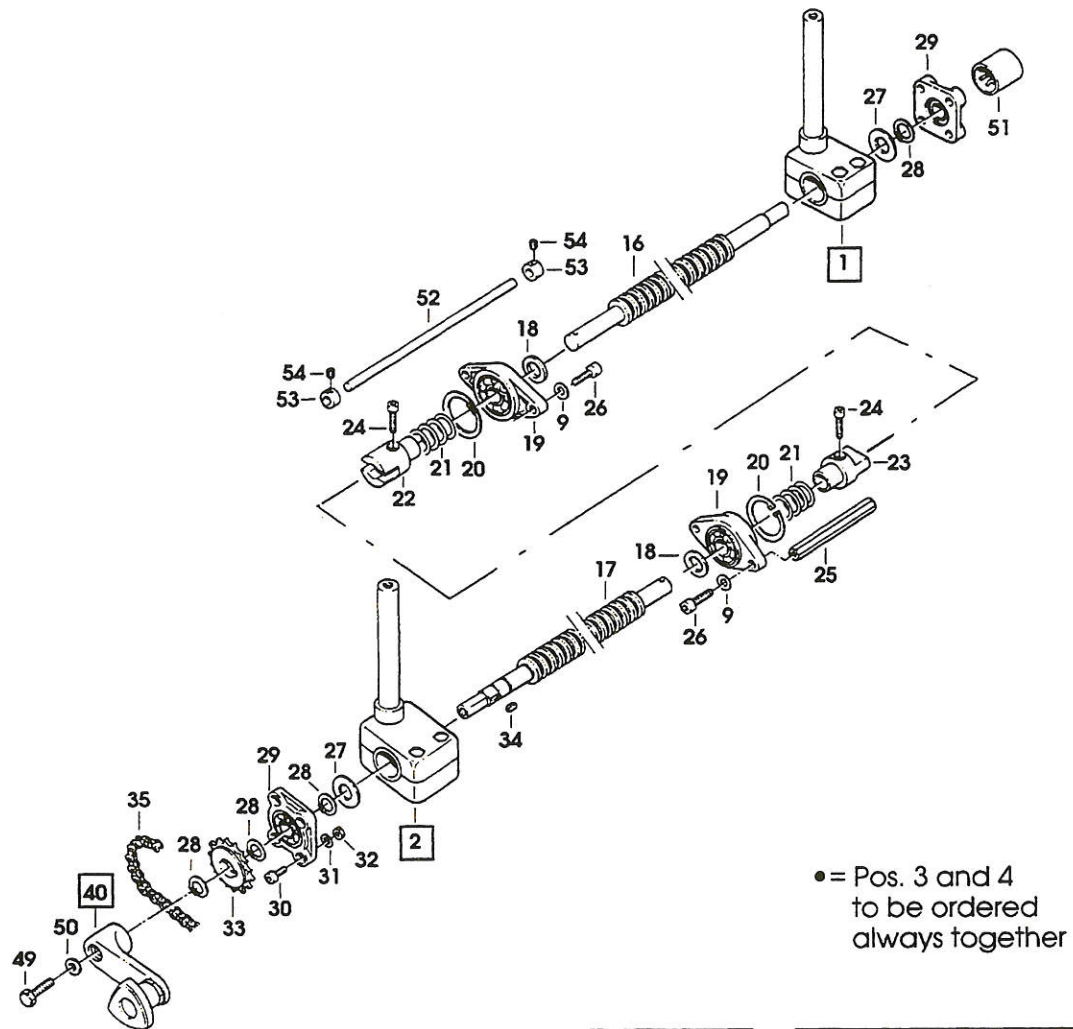


Figure 5151/2 of 2



**Figure 5151** (page 2 of 2)

Ref. No.	3M Part No.	Description
5151-28	78-8017-9079-7	Ring – Snap For 15 mm Shaft
5151-29	78-8076-5418-7	Support – Screw
5151-30	26-1003-7949-9	Screw – Soc Hd Hex Soc, M5 x 12
5151-31	78-8005-5741-1	Washer – Plain M5
5151-32	78-8010-7417-6	Nut – Hex M5
5151-33	78-8076-5419-5	Sprocket – 3/8 Inch Z=16
5151-34	78-8046-8135-7	Key – 5 x 5, 12 mm
5151-35	78-8076-5420-3	Chain – 3/8 Inch, 133 Pitch
5151-36	78-8076-5421-1	Support – Tension Roller
5151-37	78-8010-7169-3	Screw – Hex Hd, M6 x 12
5151-38	78-8070-1503-3	Roller – Chain Tensioning
5151-39	78-8060-7878-4	Idler Screw
5151-40	78-8076-4807-2	Crank Assembly
5151-41	78-8076-5422-9	Crank Assembly
5151-42	78-8070-1509-0	Shaft – Crank
5151-43	26-1005-5316-8	Screw – Flat Hd Hex Dr, M5 x 16
5151-44	78-8070-1510-8	Washer – Nylon, 7 x 15 x 1
5151-45	78-8070-1511-6	Bushing
5151-46	78-8005-5740-3	Washer – Plain 4 mm
5151-47	78-8010-7157-8	Screw – Hex Hd, M4 x 10
5151-48	78-8070-1512-4	Knob – VTR-B-M12
5151-49	78-8032-0375-7	Screw – Hex Hd, M6 x 16
5151-50	78-8076-4809-8	Washer – Crank
5151-51	78-8070-1506-6	Cover – Screw
5151-52	78-8094-6483-3	Shaft – Belt Stop
5151-53	78-8076-5424-5	Block
5151-54	78-8076-5425-2	Set Screw – M4 x 3

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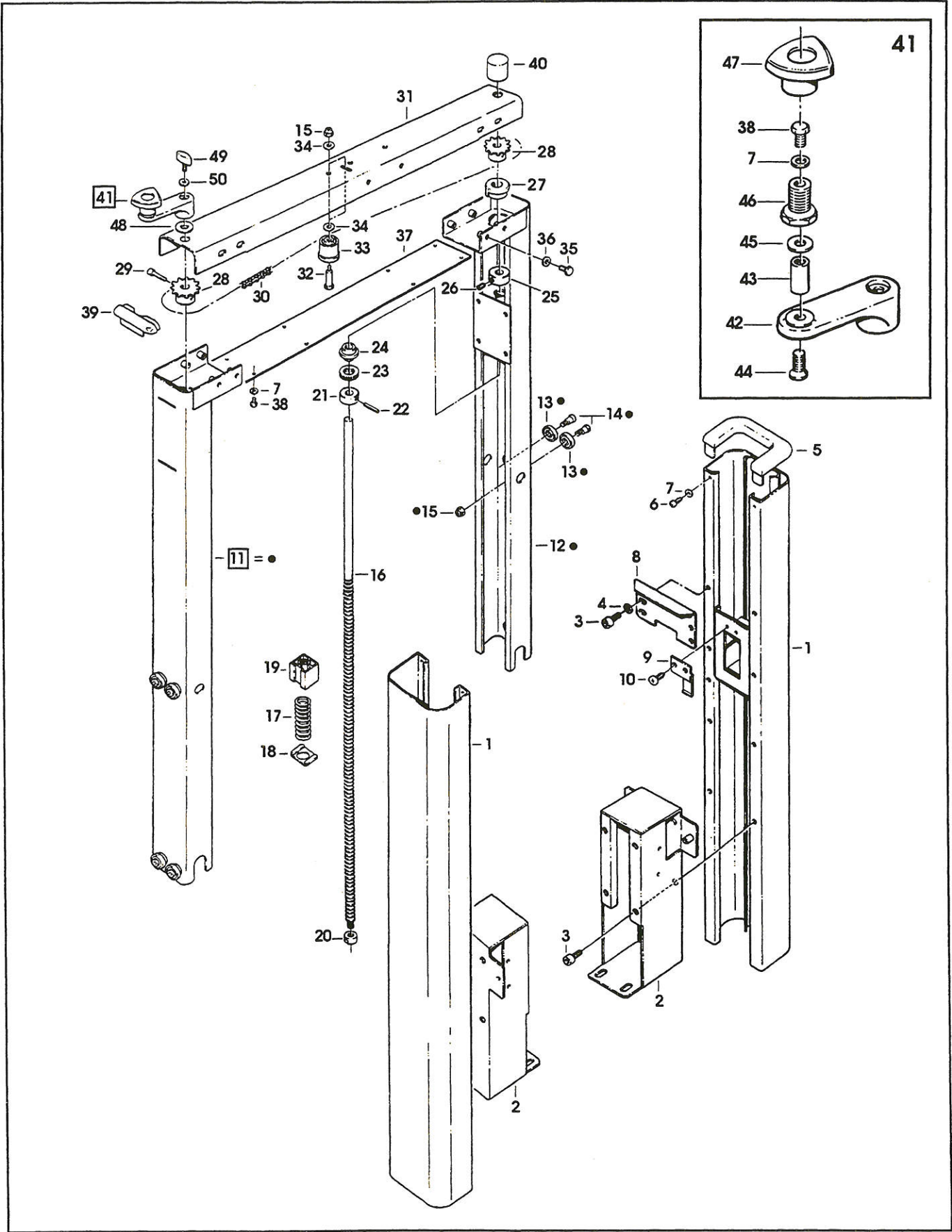


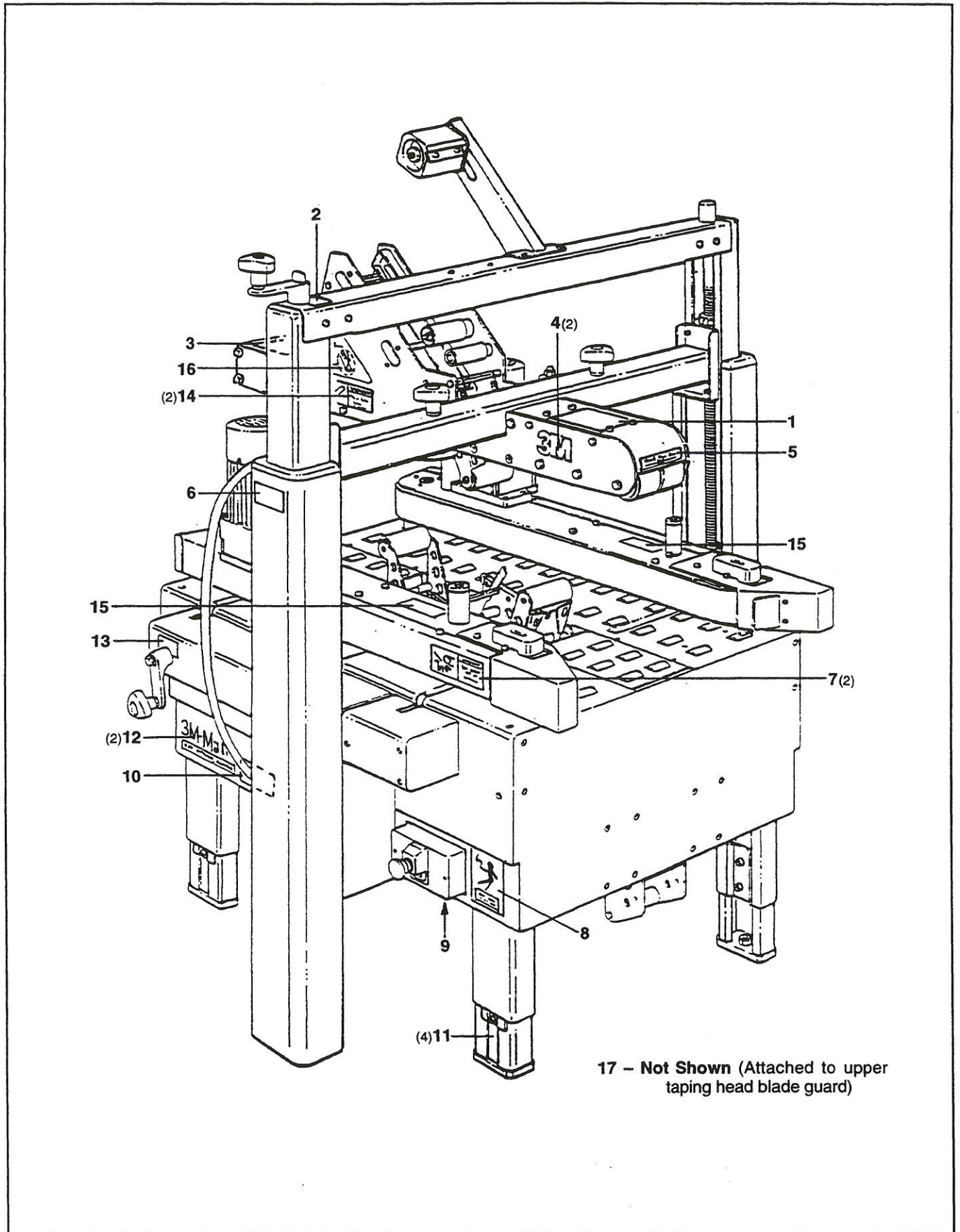
Figure 5213

**Figure 5213**

Ref. No.	3M Part No.	Description
5213-1	78-8060-8489-9	Column – Outer
5213-2	78-8076-5426-0	Plate
5213-3	26-1003-7964-8	Screw – Soc Hd, M8 x 20
5213-4	78-8017-9318-9	Washer – Plain 8 mm
5213-5	78-8060-8491-5	Cap – Column
5213-6	26-1002-4955-1	Screw – Self-Tap, 8P x 13
5213-7	78-8005-5740-3	Washer – Plain 4 mm
5213-8	78-8100-0762-1	Stop – Height
5213-9	78-8076-5482-3	Plate – Nut Stop
5213-10	78-8060-8087-1	Screw – M5 x 10
5213-11	78-8060-8494-9	Column Assembly – Inner
5213-12	78-8060-8495-6	Column – Inner
5213-13	78-8054-8617-8	Bearing – Special
5213-14	78-8054-8589-9	Screw – Special
5213-15	26-1003-6916-9	Nut – Locking, M6, Plastic Insert
5213-16	78-8060-8496-4	Lead Screw
5213-17	78-8054-8969-3	Spring
5213-18	78-8054-8970-1	Bed Plate For Spring
5213-19	78-8054-8571-7	Nut – Plastic
5213-20	78-8054-8968-5	Nut – Special
5213-21	78-8054-8585-7	Collar
5213-22	78-8054-8586-5	Pin
5213-23	78-8054-8584-0	Spacer
5213-24	78-8054-8583-2	Bushing
5213-25	78-8060-8497-2	Bushing – Lead Screw
5213-26	78-8059-5617-0	Set Screw – M6 x 8
5213-27	78-8060-8498-0	Bushing – Inner Column
5213-28	78-8060-8499-8	Sprocket – 3/8 Inch, Z=13
5213-29	26-1003-7946-5	Screw – Soc Hd, M4 x 25
5213-30	78-8076-4818-9	Chain – 3/8 Inch, Pitch 197
5213-31	78-8076-5427-8	Housing – Chain
5213-32	78-8060-7878-4	Idler Screw
5213-33	78-8070-1503-3	Roller – Chain Tensioning
5213-34	78-8042-2919-9	Washer – Triple, M6
5213-35	26-1003-5829-5	Screw – Hex Hd, M6 x 12
5213-36	26-1000-0010-3	Washer – Flat M6
5213-37	78-8076-5428-6	Cover
5213-38	78-8010-7157-8	Screw – Hex Hd, M4 x 10
5213-39	78-8070-1505-8	Cap – Inner Column
5213-40	78-8070-1506-6	Cover – Screw
5213-41	78-8076-4807-2	Crank Assembly
5213-42	78-8076-5422-9	Crank Assembly
5213-43	78-8070-1509-0	Shaft – Crank
5213-44	26-1005-5316-8	Screw – Flat Hd Hex Dr, M5 x 16
5213-45	78-8070-1510-8	Washer – Nylon, 7 x 15 x 1
5213-46	78-8070-1511-6	Bushing
5213-47	78-8070-1512-4	Knob – VTR-B-M12
5213-48	78-8076-4800-7	Washer – Crank
5213-49	78-8076-4821-3	Key – Stop
5213-50	78-8076-4809-8	Washer – Crank



## 800asb Adjustable Case Sealer



## Safety and Information Labels

## 800asb Safety and Information Labels

A label kit, part number 78-8098-8966-6, 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.
	78-8098-8966-6	Label Kit (Includes items 1 - 17)	
1	78-8070-1366-5	Information – Safety Instructions	1
2	78-8070-1628-8	Information – Up/Down/Lock, Height Adjustment	1
3	78-8070-1362-4	Caution – Keep Hands Out Of This Area	1
4	78-8070-1339-2	Information – 3M Logo	2
5	78-8098-8818-9	Information – Box Centering	1
6	78-8068-3859-1	Information – Service and Spares	1
7	78-8070-1331-9	Warning – Moving Belts	2
8	78-8070-1329-3	Warning – Hazardous Voltage	1
9	78-8068-3852-6	Information – Ground	1
10	78-8098-8813-0	Nameplate – Type 19500	1
11	78-8060-8481-6	Information – Leg Height	4
12	78-8062-4266-1	Identification – 3M-Matic	2
13	78-8070-1622-1	Information – In/Out, Belt Adjustment	1
14	78-8070-1336-8	Warning – Sharp Knife	2
15	78-8070-1629-6	Information – Belt Tensioning	2
16	78-8070-1365-7	Information – Tape Threading	1
17	78-8070-1335-0	Warning – Sharp Knife	1

