

Instructions and Parts List

3M-Matic™

77A

Model 28600

Adjustable Case Sealer

with

AccuGlide™

STD

Model 18500

Taping Heads

IMPORTANT
It is recommended you immediately order the spare parts listed on page 19. These parts are expected to wear through normal use, and should be kept on hand to minimize production delays.

"3M-Matic" and "AccuGlide" are Trademarks of 3M, St. Paul, MN 55144-1000

34-7004-7387-8(G100.025)R1

© 3M 1990

Litho in U.S.A.

3M Packaging Systems Division

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



Replacement Parts and Service Information

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

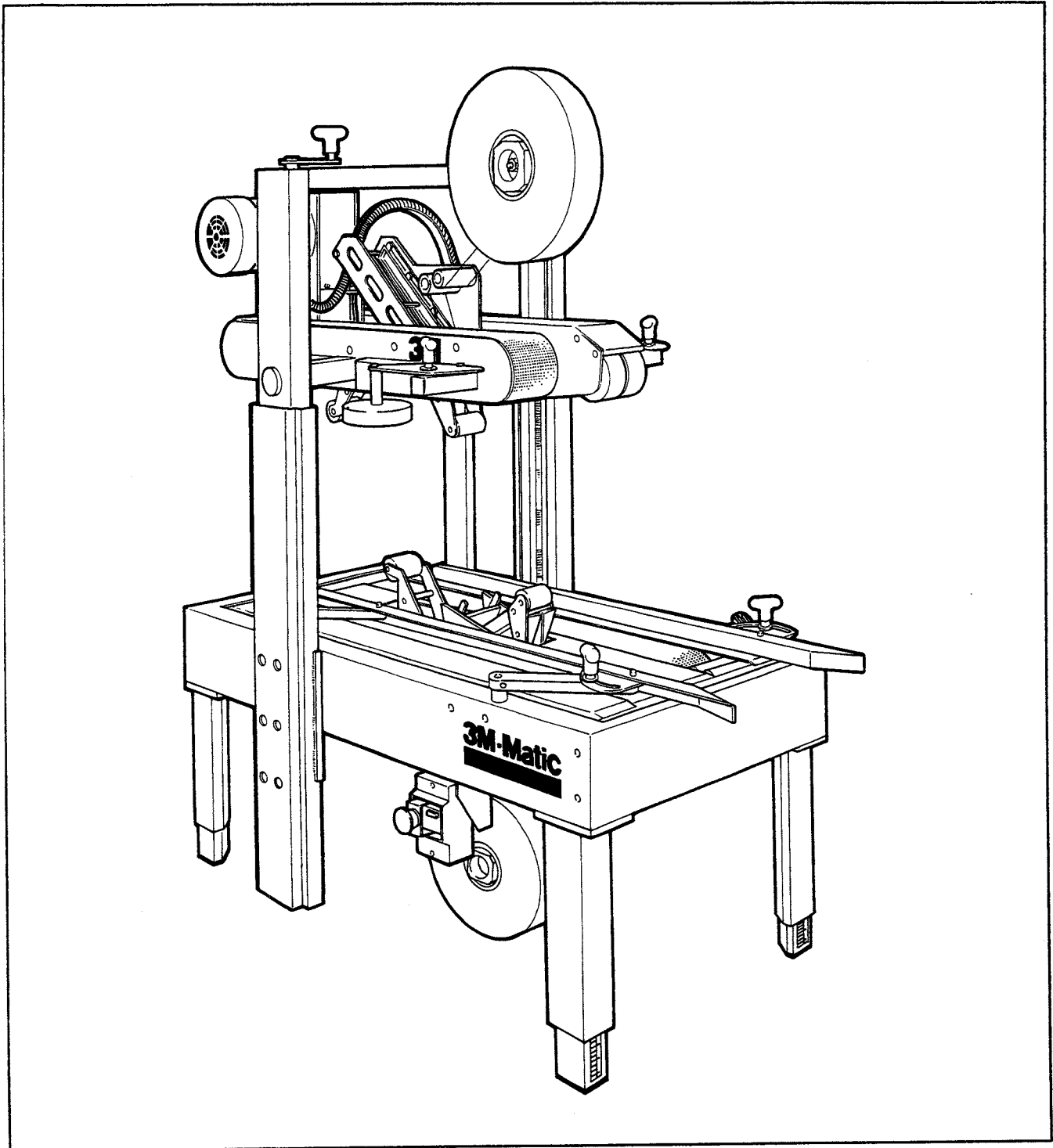
3M-Matic, *AccuGlide* and *Scotch* are trademarks of 3M, St. Paul, Minnesota 55144-1000

Printed in U.S.A.

© 3M 1999 44-0009-1851-4(E79.0)

Instruction Manual
77A Adjustable Case Sealer
Model 28600

Table of Content	Page
Description - - - - -	1
Receiving and Handling - - - - -	2
Warranty - - - - -	2
Specifications - - - - -	2 - 4
Set-Up Procedure - - - - -	5 - 11
Conveyor Bed Height - - - - -	6
Machine Leveling - - - - -	6
Electrical Connection - - - - -	7
Tape Loading - - - - -	7 - 9
Box Size Set-Up & Operation - - - - -	10 - 11
Adjustments - - - - -	12 - 15
Tape Web Alignment - - - - -	12
Applying Mechanism Spring - - - - -	12
One Way Tension Roller Assembly- Box Drive Belts - - - - -	13 14 - 15
Maintenance - - - - -	16 - 18
Blade Replacement - - - - -	16
Replacing Box Drive Belts - - - - -	16
Cleaning of the Machine - - - - -	17
Cut-Off Blade - - - - -	17
Electrical Schematic - - - - -	17
Circuit Breaker - - - - -	17
Lubrication - - - - -	18
Suggested Spare Parts - - - - -	19
How To Order Replacement Parts - - - - -	19
Repair Service - - - - -	19
Attachments - - - - -	20
Replacement Parts Illustrations & Parts Lists - - - - -	21 - 22
Taping Head Assemblies - - - - -	21
Frame Assemblies - - - - -	22



"3M-Matic" 77A Adjustable Case Sealer - Model 28600

Description

The "3M-Matic" 77A Adjustable Case Sealer with "AccuGlide" STD 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 77A is manually adjustable to a wide range of box sizes (see box size specifications).

Receiving And Handling

After the machine has been uncrated, examine the 77A Case Sealer for damage that might have occurred during transit. If damage is evident, file a damage claim immediately with the transportation company and also your 3M Representative. Several machine components are tied down to prevent damage during transit. Remove these before proceeding with following set-up instructions.

Warranty

IMPORTANT NOTICE TO PURCHASER: The following is made in lieu of all warranties, expressed or implied, including the implied warranties of merchantability and fitness for purpose: Seller and manufacturer warrant that the "3M-Matic" equipment is free from defects in material and workmanship on the date the machine is shipped by the seller and for the time periods stated below. Seller's and manufacturer's only obligation hereunder shall be to repair or replace, at its option, any mechanical part proved to be defective, provided the defect occurs within ninety (90) days* (see NOTE below) after the date of delivery and the said part is returned immediately to the 3M factory or to an authorized service station designated by the manufacturer. Neither seller nor manufacturer shall be liable either in tort or in contract for any loss or damage, direct, incidental, or consequential, arising out of the use of or the inability to use the "3M-Matic" equipment. No statement or recommendation not contained herein shall have any force or effect unless in an agreement signed by officers of seller and manufacturer.

NOTE: * The time period shall be one (1) year for the transmission and motor, three (3) years for the "AccuGlide" taping head, except for the blades, springs and apply/buffing rollers which shall remain subject to the ninety (90) day warranty period.

"Scotch", "3M-Matic" and "AccuGlide" are trademarks of 3M, St. Paul, Minnesota 55144-1000.

Specifications

1. Power Requirements:

Electrical - 115 VAC, 60 Hz, 5.6 A

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. Machine Dimensions:

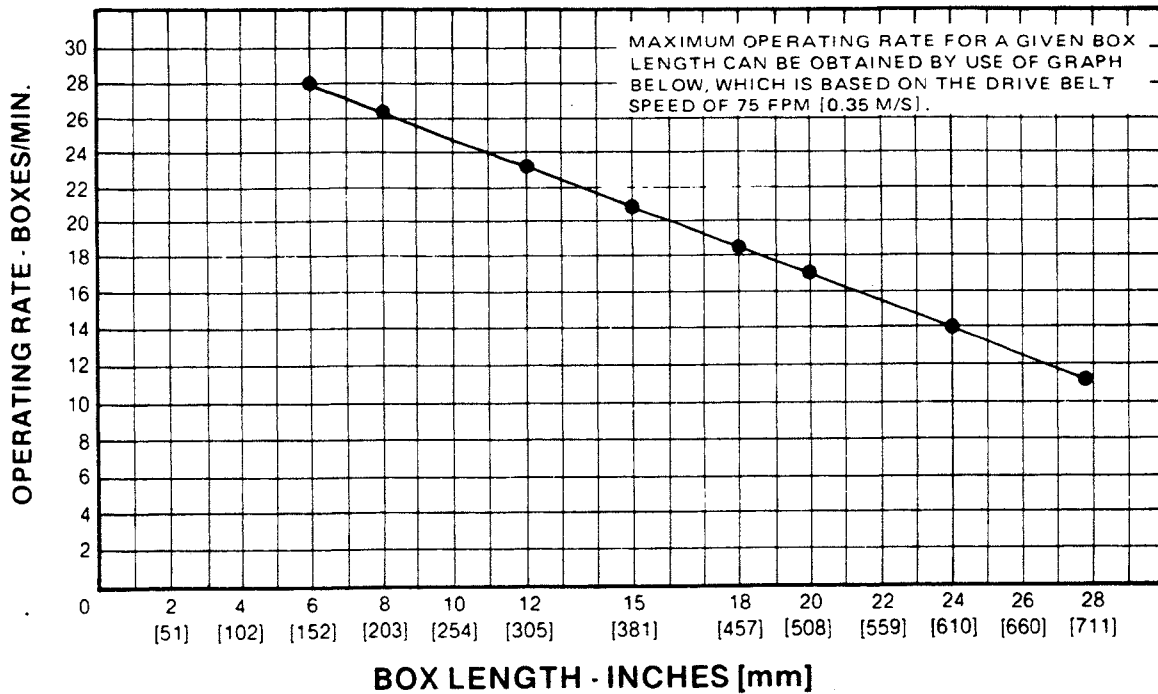
Overall Dimensions

Length	-	42 1/2 inches [1.080 m]
Width	-	27 1/2 inches [0.700 m]
Height	-	56 5/8 inches [1.440 m]
Conveyor Bed Height	-	Adjustable from 20 1/2 inches [520 mm] to 31 1/2 inches [800 mm]
Weight	-	350 pounds [160 kg] crated 295 pounds [135 kg] uncrated

(Specifications continued on next page.)

Specifications (Continued)

3. Operating Rate:



4. Operating Conditions:

Use in dry, relatively clean environments at 40⁰ to 105⁰F [5⁰ to 40⁰C] with clean, dry boxes.

IMPORTANT SAFEGUARD

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

5. Tape:

"Scotch" brand pressure-sensitive film box sealing tapes.

6. Tape Width:

1 1/2 inches or 36 mm minimum to 2 inches [50 mm] maximum.

7. Tape Roll Diameter:

Up to 15-1/2 inches [395 mm] maximum on a 3 inch [76.2 mm] diameter core. (Accommodates all system roll lengths "Scotch" brand film tapes.)

8. Tape Application Leg Length:

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

(Specifications continued on next page.)

Specifications (Continued)

9. Box Board:

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

10. Box Weight and Size Capacities

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

B. Box size:	Minimum	Maximum
Length -	6.0 inches or 150 mm	unlimited
Width -	6.0 inches or 150 mm *	20 inches or 500 mm
Height -	4.75 inches or 120 mm	20 inches or 500 mm

* **Note:** Cartons smaller than 8 inches or 200 mm in width may require more frequent belt replacement because of limited contact area.

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

Note: The 77A Case Sealer can accommodate most boxes within the size range listed above. However, if the box length (in direction of seal) to box height ratio is **.5 or less**, several boxes should be test run to assure proper machine performance.

DETERMINE THE BOX LIMITATIONS BY COMPLETING THIS FORMULA:

$$\frac{\text{BOX LENGTH IN DIRECTION OF SEAL}}{\text{BOX HEIGHT}} \quad \text{SHOULD BE GREATER THAN .5}$$

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

Set-Up Procedure

It is recommended that the 77A Case Sealer be set-up and operated with product before placing it in the production line. This approach will allow your thorough review and familiarization with the 77A before subjecting it and operating personnel to a production situation where time for set-up, adjustments, and operator training usually becomes limited.

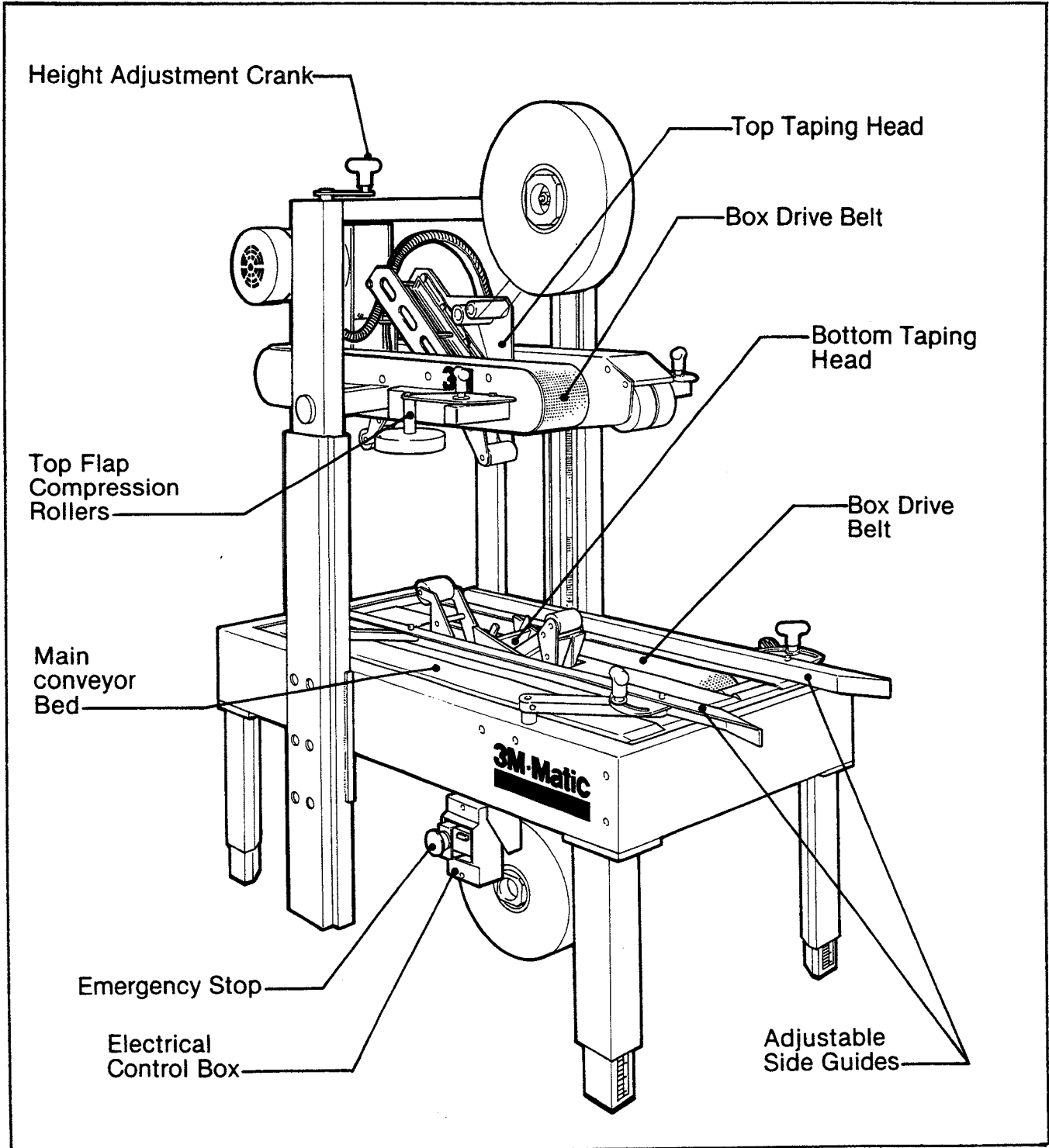


Figure 1 - Set-Up Instructions - Case Sealer Components - Left Front View

Set-Up Procedure (Continued)

The following instructions are presented in **the order recommended** for setting up and installing the 77A 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 77A Case Sealer.

Conveyor Bed Height:

The 77A Case Sealer is equipped with four **adjustable legs** that are located at the corners of the frame. The legs can be adjusted to obtain different machine conveyor bed heights from **20 1/2 inches [520 mm] minimum to 31 1/2 inches [800 mm] maximum**.

The recommended minimum machine conveyor bed height (measured from floor) is 24 inches [610 mm].

Refer to Figure 2A and set the conveyor bed height as follows:

1. Block up the machine frame to allow adequate leg adjustment.
2. **Loosen, but do not remove**, two M8 x 16 mm socket head screws in one leg. Adjust the leg length for the desired conveyor bed height. **Retighten** the two screws to secure the leg. Adjust all four legs as noted.

The tape drum bracket assembly, located on the bottom taping head, has two mounting positions to allow maximum tape roll capacity through the machine conveyor bed height range.

For conveyor bed heights 24 inches and above, use mounting position shown in Figure 2B.

For conveyor bed heights below 24 inches, use mounting position shown in Figure 2C.

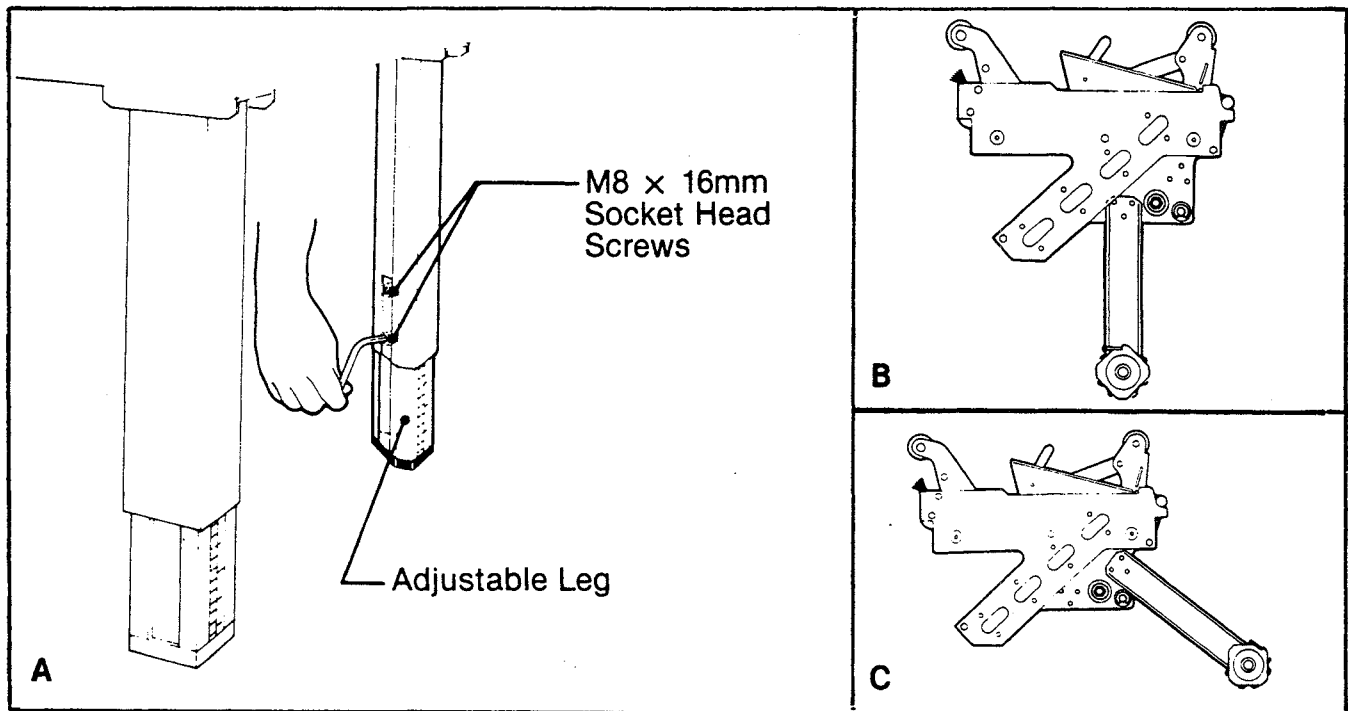


Figure 2 - Conveyor Bed Height Adjustment

Set-Up Procedure (Continued)

Electrical Connection

The electrical control box, shown in Figure 1, contains the "On-Off" switch with pre-set circuit breaker and can be located on either side of the main conveyor for customer operating convenience. A standard three conductor power cord with plug is provided at the back of the electrical control box for 115 Volt, 60 Hz electrical service. The receptacle providing this service shall be properly grounded. Before the power cord is plugged into 115 Volt, 60 Hz outlet, make sure the switch is "Off" and that all packaging materials and tools are removed from the machine.

Note: Machines outside the U.S. may be equipped with 220/440 Volt, 50 Hz systems, or other electrical requirements compatible with local practice.

IMPORTANT SAFEGUARDS

1. BOTH THE TOP AND BOTTOM TAPING HEADS UTILIZE EXTREMELY SHARP KNIFE BLADES ON THE ORANGE CUTTER LEVER ASSEMBLY AND WHICH ARE LOCATED UNDER THE BLADE GUARD WHICH HAS THE "WARNING - SHARP KNIFE" LABEL. BEFORE WORKING WITH THE TAPING HEADS OR ATTEMPTING TO LOAD THE TAPE, REFER TO FIGURE 3A AND IDENTIFY THE BLADE LOCATION. KEEP HANDS OUT OF THESE AREAS EXCEPT AS NECESSARY TO SERVICE THE TAPING HEADS.
2. NEVER ATTEMPT TO WORK ON THE TAPING HEADS OR LOAD TAPE WHEN THE BOX DRIVE BELTS ARE RUNNING.
3. BOX DRIVE MOTORS ARE DESIGNED TO RUN AT A MODERATE TEMPERATURE OF 104° F [40° C]. IN SOME CASES THEY MAY FEEL WARM TO THE TOUCH.

Tape Loading

The taping heads have been pre-set to accommodate 2 inch [50 mm] wide tape rolls. To apply 1-1/2 inch or 36 mm or 1- 3/4 inch or 42 mm wide tapes, refer to "Adjustments" Section for set-up information. Two temporary threading needles are shipped in threaded position for initial tape loading convenience.

Retain these for continued use in the tape loading operation. For operator assistance, a threading diagram has been applied to the taping heads. However, it is recommended that the more detailed instructions and sketches in this manual be referred to the first few times the unit is loaded until the operator becomes thoroughly familiar with the tape loading operation. The bottom taping head can be removed from unit by lifting out for convenience in tape loading.

Tape Loading - Top Taping Head

WARNING - NEVER ATTEMPT TO WORK ON THE TAPING HEADS OR LOAD TAPE WHEN THE BOX DRIVE BELTS ARE RUNNING. PERSONNEL INJURY OR EQUIPMENT DAMAGE CAN POTENTIALLY RESULT.

1. It is first necessary to raise the top taping head. Utilize the height adjustment crank and move the top taping head to the fully raised position.
2. With the temporary threading needle already in position, as shown in Figure 3, follow the tape loading procedure from Figure 3C to complete the tape threading.

Set-Up Procedure (Continued)

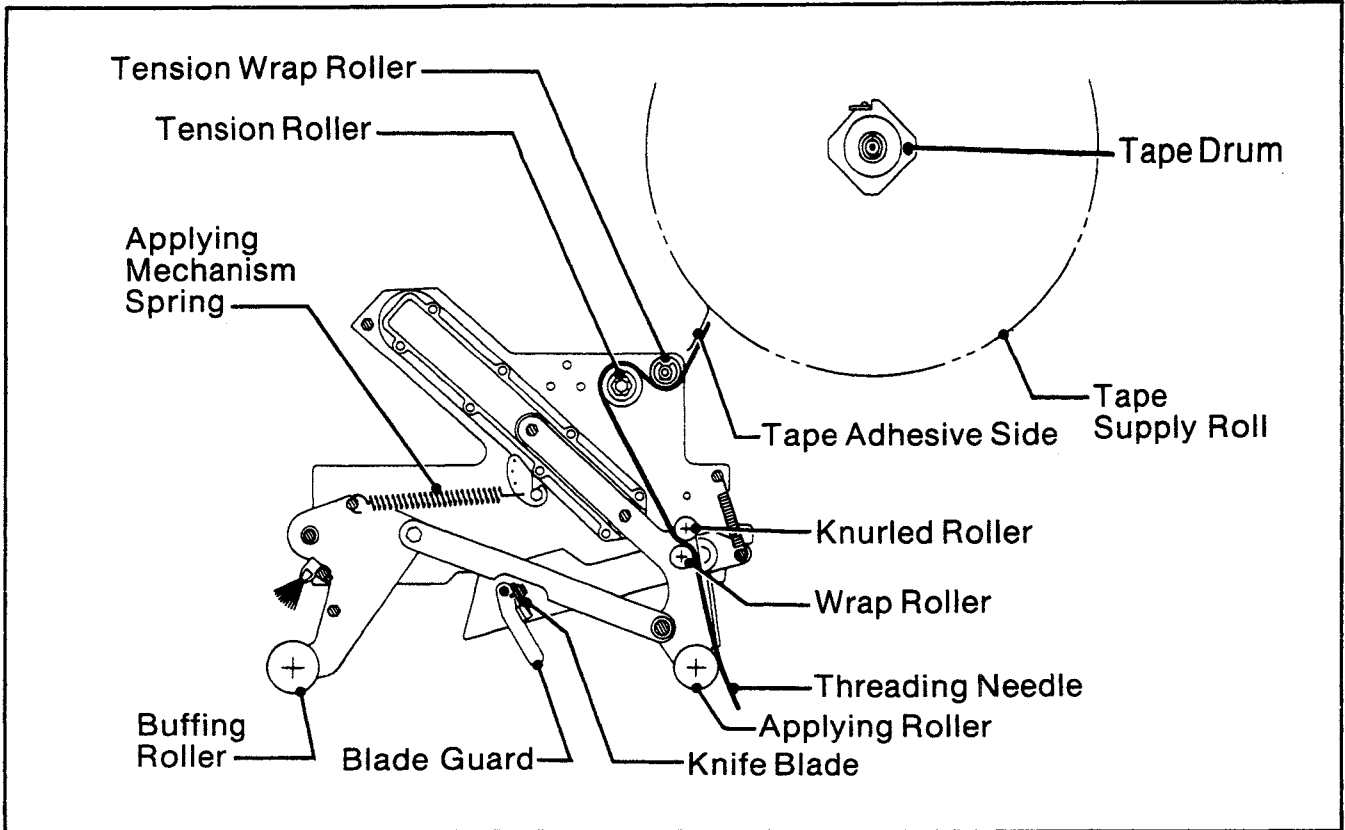


Figure 3 - Tape Threading Diagram - Top Taping Head - Left Side View

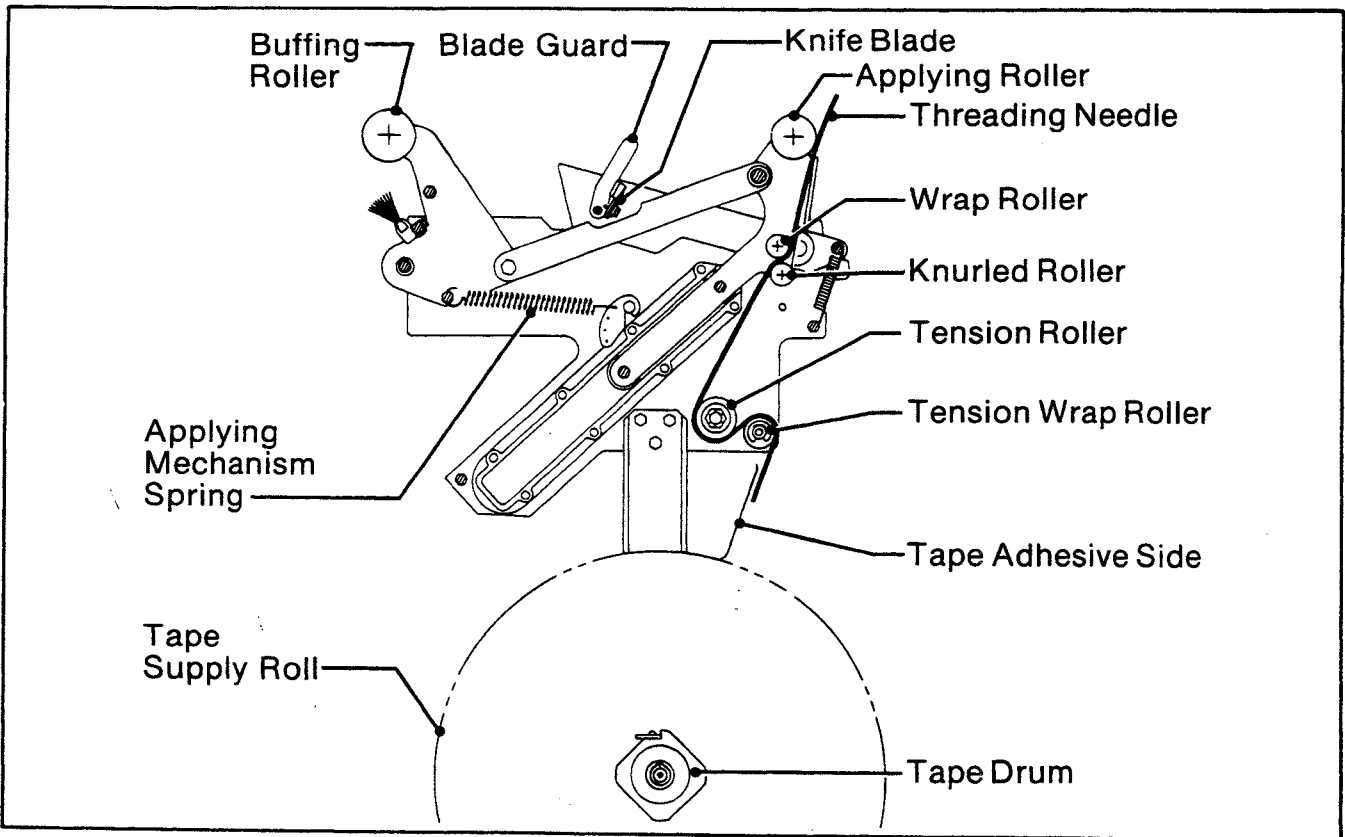


Figure 3A - Tape Threading Diagram - Bottom Taping Head - Left Side View

Set-Up Procedure (Continued)

3. For subsequent tape loading operations, use the red plastic threading needle and follow the loading procedures from Figure 3B to complete the tape threading.

Tape Loading - Bottom Taping Head Refer to Figure 3A

The bottom taping head is loaded and threaded in the same manner as the top taping head.
For ease in loading, first remove the bottom taping head from the conveyor bed and follow the top taping head tape loading procedure.

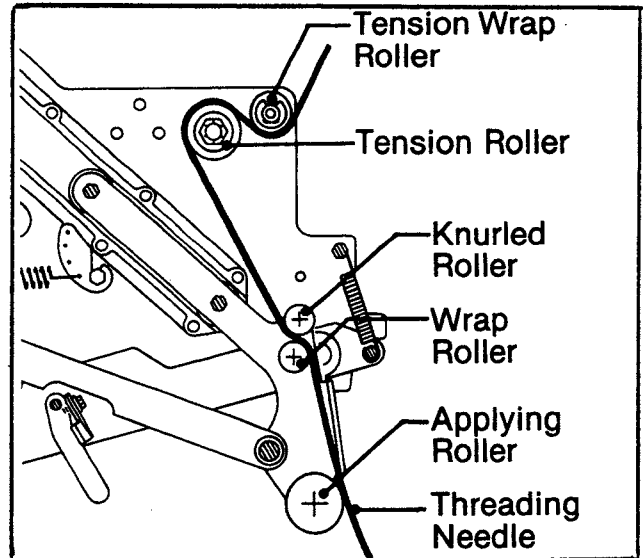


Figure 3B

Figure 3B

Insert the red plastic needle downward around rollers as illustrated.

Figures 3B and 3C

Place tape roll on drum to dispense tape from bottom of roll toward tension wrap roller with tape adhesive side in. Seat tape roll fully against back flange of drum. Adhere tape lead end to upper end of threading needle as shown.

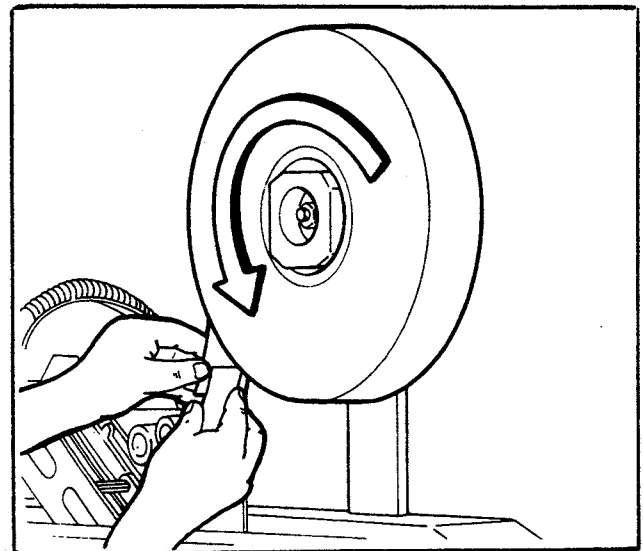


Figure 3C

Figure 3D

WARNING - USE CARE WHEN WORKING NEAR BLADES AS BLADES ARE EXTREMELY SHARP. IF CARE IS NOT TAKEN, SEVERE INJURY TO PERSONNEL COULD RESULT.

Manually turn tape roll to create slack tape while pulling threading needle through tape applying mechanism until needle is through and tape is in alignment with applying roller.

Excess tape can be cut with a scissors or knife at applying roller.

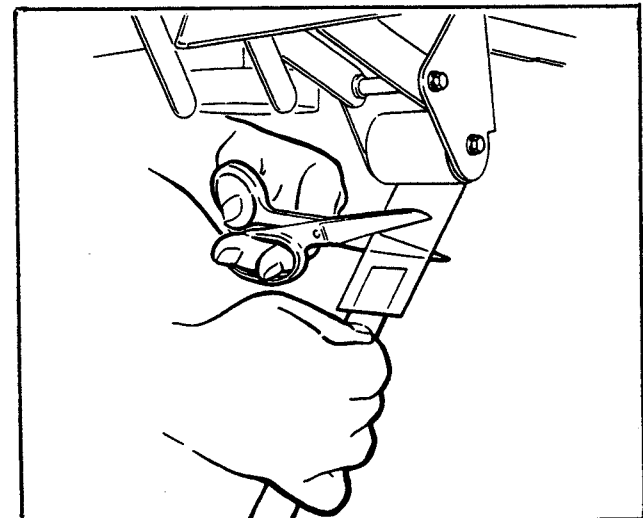


Figure 3D

Set-Up Procedure (Continued)

Box Size Set-Up and Operation

Figure 4 -

Once both taping heads are loaded with tape, the top taping head can be positioned for the box height being sealed by means of the **height adjustment crank**. Turn **clockwise** to raise head, **counterclockwise** to lower head.

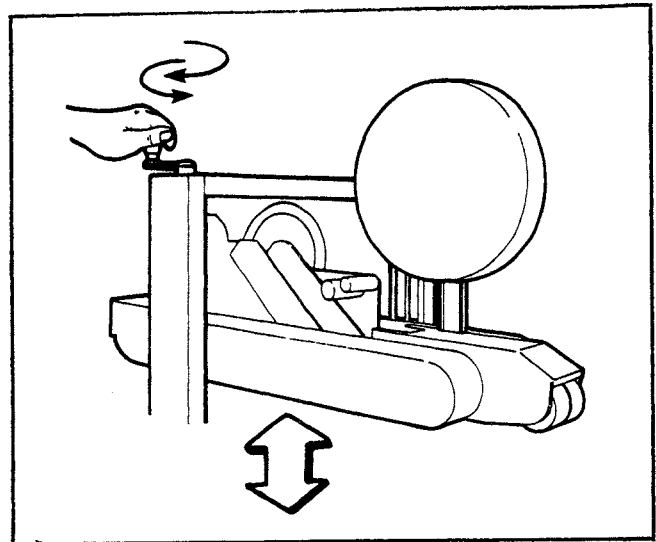


Figure 4

Figure 5 -

Place box on infeed conveyor with both top and bottom flaps folded and insert under top head skis approximately **2 inches or 50 mm**. Lower top head until all flaps are fully closed. Align box top flap center seam with **groove** in top head front roller.

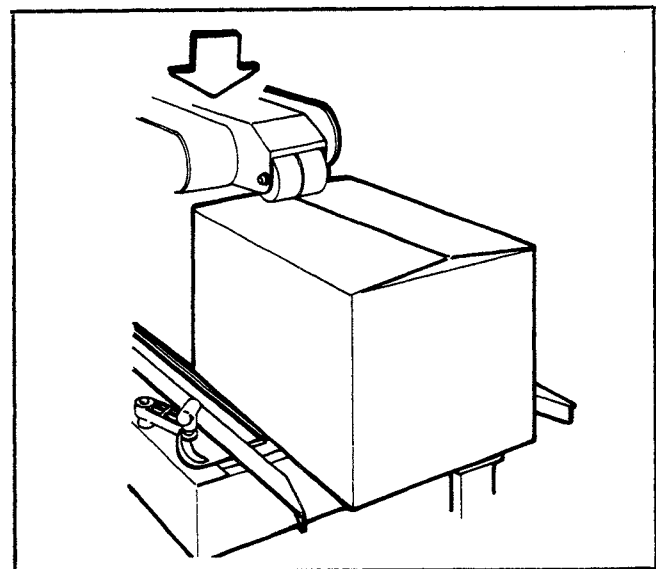


Figure 5

Figure 6 -

Move side guides against each side of box to hold box in position, centered on **groove** in roller. **Tighten hand knobs to secure side guides.**

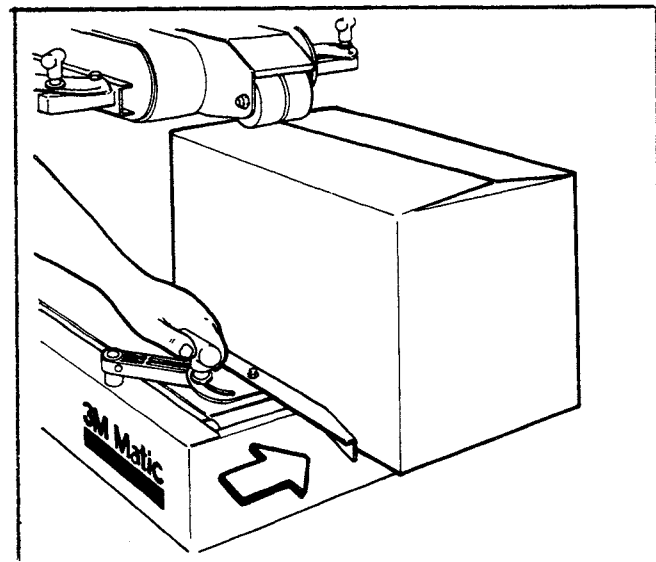


Figure 6

Set-Up Procedure (Continued)

Figure 7 -

Turn electrical switch to "On" to start drive belts. Move box forward under top tapping head until it is taken away by drive belts. If box is hard to move under head or is crushed, **raise** top head slightly. If box movement is jerky or stops under top head, **lower** top head slightly to add more pressure between box and drive belts.

Note: Top head has unique feature for overstuffed boxes. Top head will raise automatically for this type of condition.

CAUTION - IF DRIVE BELTS ARE ALLOWED TO SLIP ON BOX, EXCESSIVE BELT WEAR WILL OCCUR.

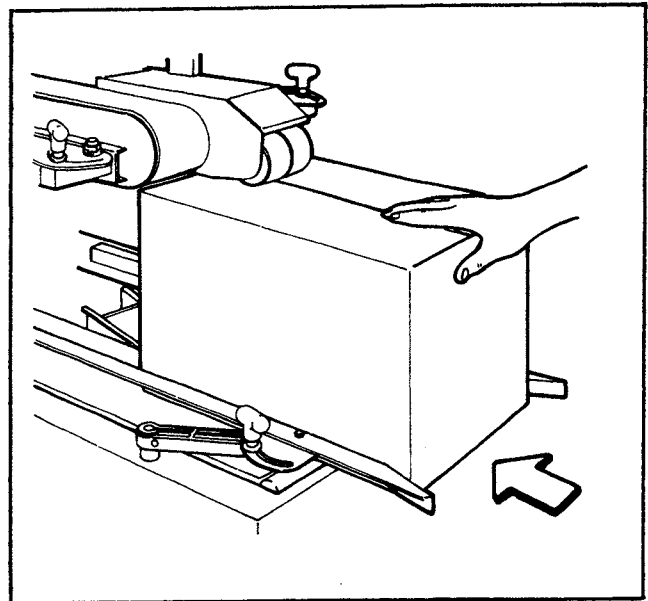


Figure 7

Figure 8

Adjust Top Flap Compression rollers against top edge of box and **tighten knobs** to secure rollers in operating position.

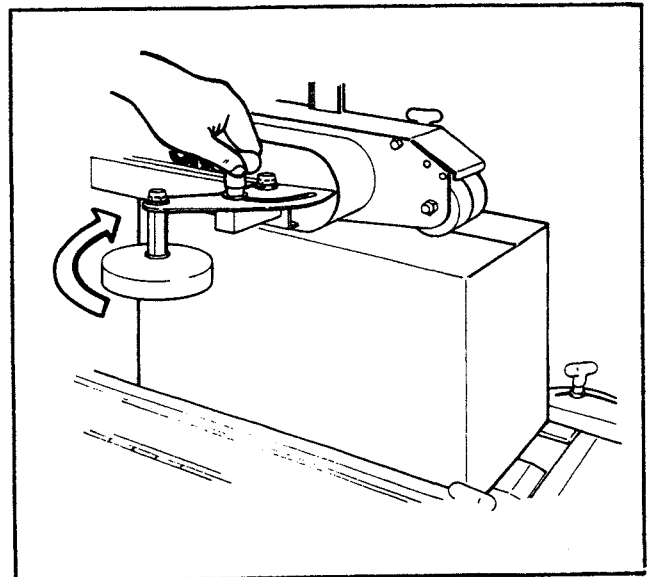


Figure 8

Adjustments

Tape Web Alignment-

Refer to Figure 9

The tape drum assembly on each taping head is **pre-set** to accommodate **2 inch [50 mm] wide tape**, but is adjustable to provide alignment of narrower tapes. If adjustment is necessary to center the tape width on the centerline of the taping head, (and therefore box center seam), make adjustment as follows:

1. **Loosen** hand knob behind tape drum on tape drum shaft.
2. **Turn tape drum shaft** in or out to center the tape web.
3. **Tighten** hand knob to secure the adjustment.

No other components require adjustment for tape web alignment.

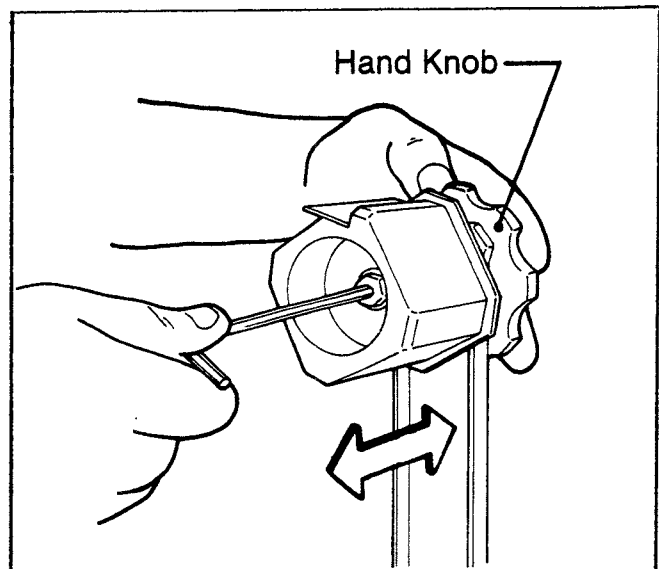


Figure 9

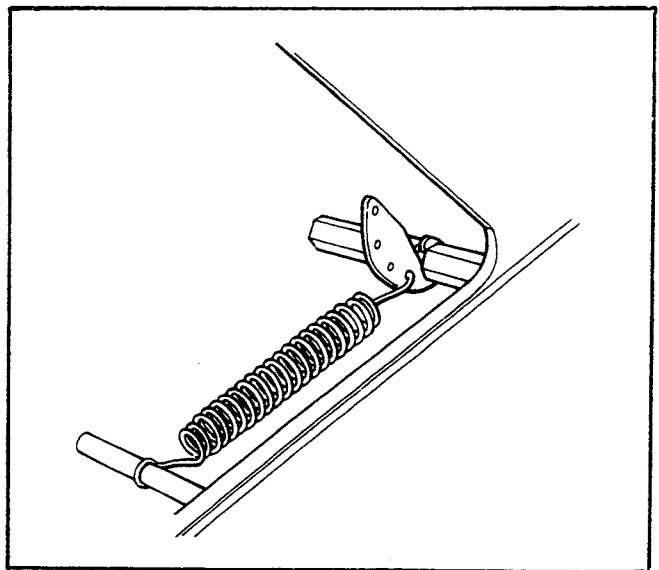


Figure 10

Applying Mechanism Spring

The applying mechanism spring, shown in Figure 3A, controls applying and buffing roller pressure on the box and returns the mechanism to the reset position. The spring pressure is pre-set, as shown in Figure 10, for normal operation but is adjustable.

Removing the spring end loop from the spring holder and placing loop in other holes provided, as shown in Figure 11, will decrease the spring pressure.

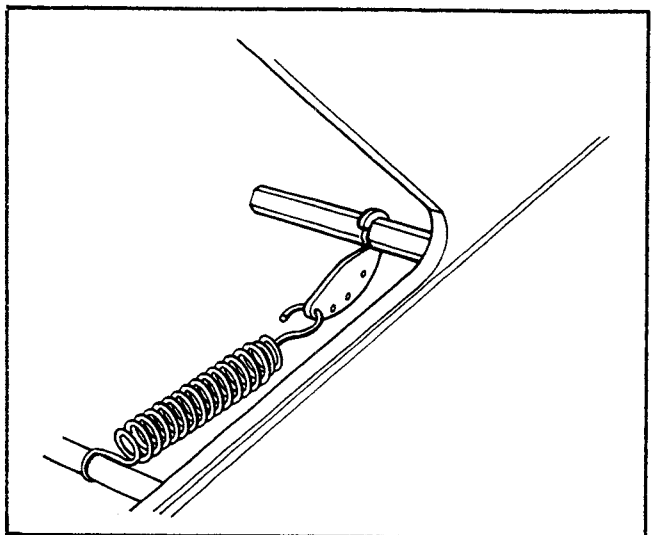


Figure 11

Adjustments (Continued)

One Way Tension Roller Assembly

The one way tension roller is factory set. When replacing this assembly, the roller must have 1 lb. [0,5 kg] tangential force when turning. See Figure 12.

1. Wrap a cord or small strap (non-adhesive) 4 to 6 turns around the tension roller.
2. Attach a spring scale to the end of the cord or strap.
3. Turn the adjusting nut until a force of approximately 1 lb. [0,5 kg] is required to turn the roller by pulling on the spring scale.

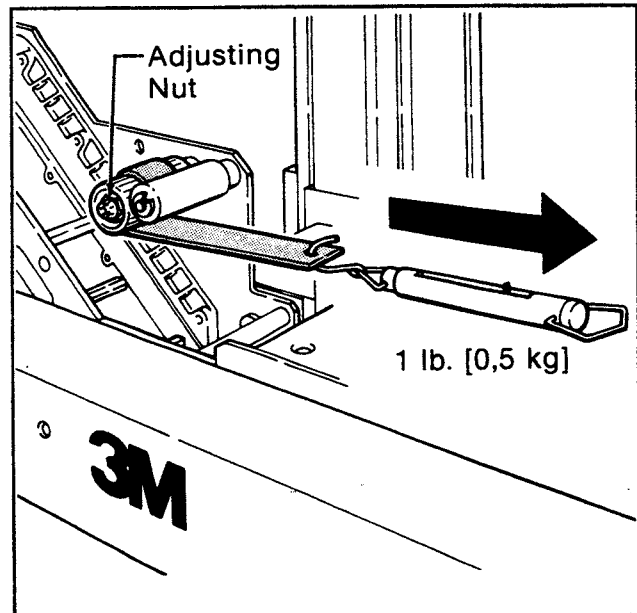


Figure 12

Adjustments (Continued)

Box Drive Belts

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

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 they should run fully on the surface of the pulleys at each end of the frame. The idler pulleys on the infeed end are positioned by adjustment screws. Adjustment of these screws can be made by using the following steps to provide proper tension. Each belt is adjusted separately.

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 Belts - Bottom Taping Head

Refer to Figure 13

Step 1. **Remove and retain** center plates and 4 screws.

Step 2. **Remove and retain** eight M6 x 12 mm socket head screws to remove conveyor tops from housing.

Belt tension is obtained by **uniform tightening** of the adjustment screws so that a moderate pulling force of **7 lbs. [3.5 kg]** applied at the midspan, as shown in Figure 14, will deflect the belt **1 inch [25 mm]**.

This will assure **positive contact** between the belt and the drive pulley on the discharge end of the taping head.

Refer to Figure 15

Step 3. **Loosen, but do not remove,** lock nut M20 x 16 with socket wrench provided.

Step 4. **Reset the tension** on the drive belt as needed. Adjust the M8 x 40 mm hex head screws, **(out to increase - in to decrease)**. Tighten lock nut to **secure tension setting**.

Step 5. **Reverse procedure** in steps 1 and 2 above to reassemble the unit.

Adjustments (Continued)

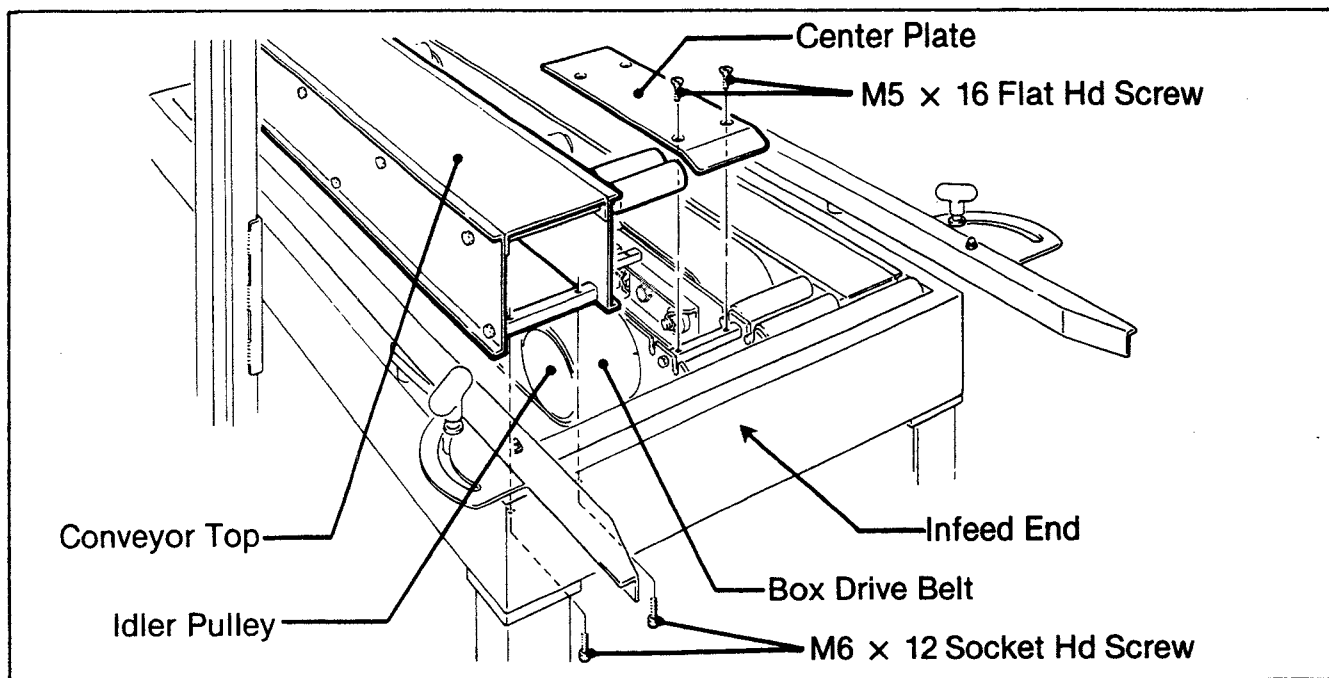


Figure 13 - Box Drive Belt Adjustment - Frame Bed Infeed End

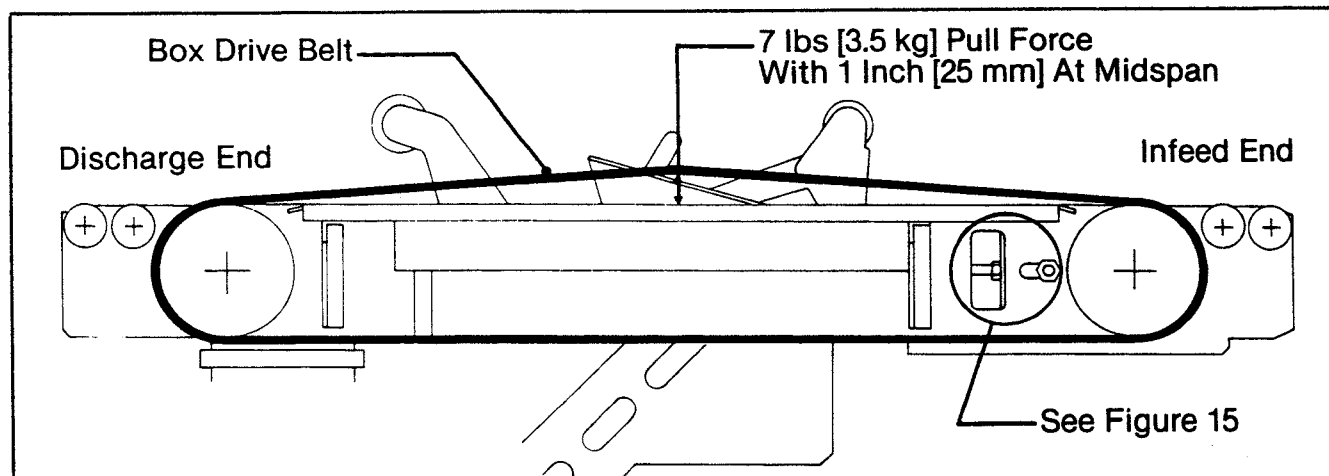


Figure 14 - Box Drive Belt Tension Adjustment - Left Side View

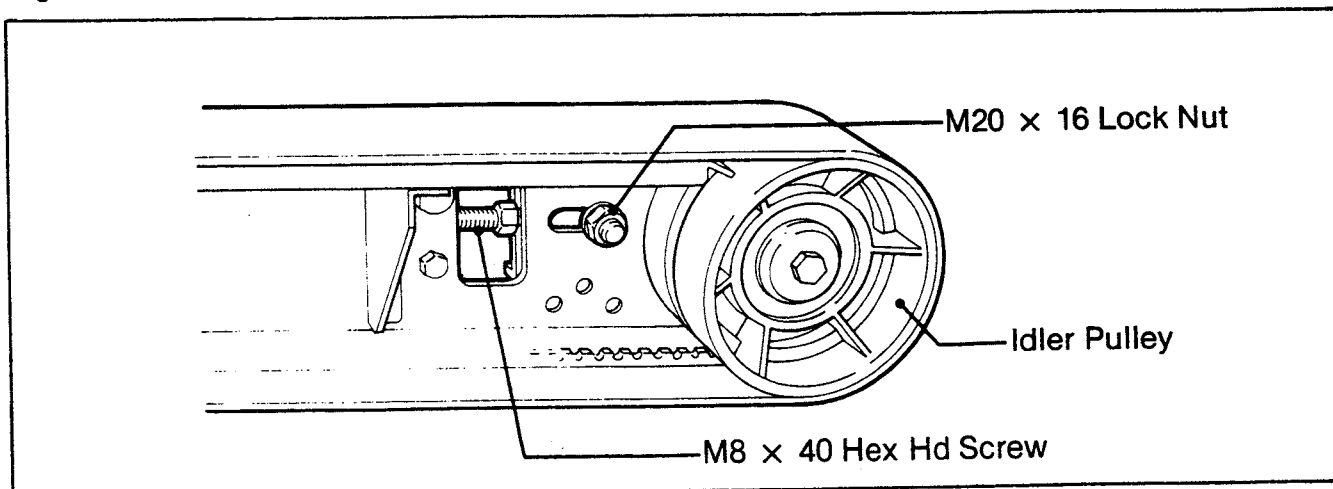


Figure 15 - Tension Adjustment - Left Side View

Maintenance

The 77A 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 POWER CORD IS NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT. USE CARE WHEN REPLACING BLADES AS BLADES ARE EXTREMELY SHARP. IF CARE IS NOT TAKEN, SEVERE INJURY TO PERSONNEL COULD RESULT.

Replacing Box Drive Belts

1. Top taping head must be removed to replace top box drive belts.
2. Remove top taping head from frame assembly. Remove top flap compression rollers and loosen four mounting screws.

Note: Make sure taping head has adequate support before screws are removed.

3. Install new belts and adjust belt tension as noted in Step 4 under adjustments.
4. **DO NOT REMOVE BOTTOM TAPING HEAD.**
Install new belts and adjust belt tension as noted in Step 4 under adjustments.

Blade Replacement - Refer to Figure 16

1. Loosen, but do not remove, the blade screws (A). Remove and discard the old blade.
2. Mount the new blade (B) with the beveled side toward the blade holder.
3. Position the blade at an angle so all the teeth are as close as possible to the blade guard without contacting it. Tighten the blade screws to secure the blade.

NOTE - check the blade position to insure proper clearance by slowly pivoting the blade guard back.

The same steps are followed on the top and bottom taping heads. Connect the main power supply.

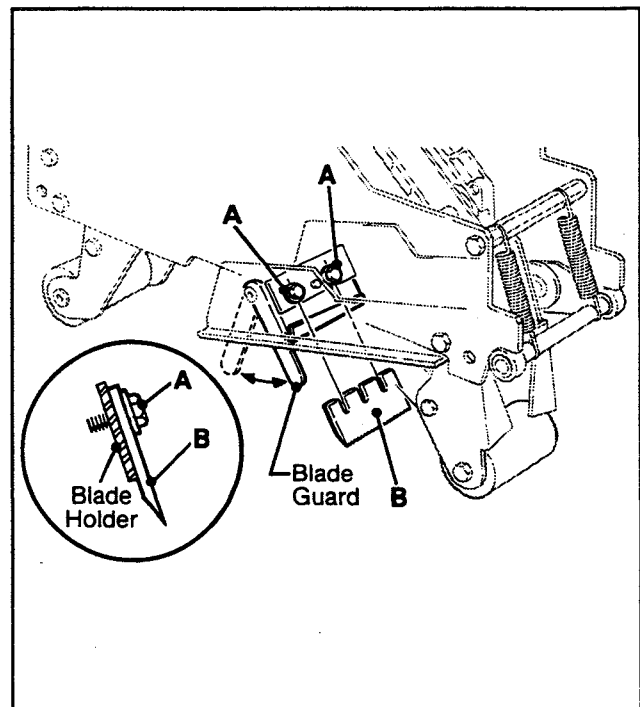


Figure 16 - Blade Replacement

Maintenance (Continued)

Cleaning Of The Machine

CAUTION - NEVER ATTEMPT TO REMOVE DIRT BY BLOWING IT OUT WITH COMPRESSED AIR. THIS CAN CAUSE THE DIRT TO BE BLOWN INSIDE THE MOTOR, AND SLIDING SURFACES. GRITTY DIRT IN THESE AREAS CAN CAUSE SERIOUS EQUIPMENT DAMAGE. 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 77A 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.

Cut-Off Blade

Should tape adhesive build-up occur, carefully wipe clean with oily cloth.

Electrical Schematic

WARNING - TURN OFF ELECTRICAL POWER SUPPLY AND DISCONNECT POWER CORD FROM ELECTRICAL SUPPLY BEFORE BEGINNING MAINTENANCE. IF POWER CORD IS NOT DISCONNECTED, PERSONNEL COULD BE EXPOSED TO DANGEROUS VOLTAGES. SEVERE INJURY OR EQUIPMENT DAMAGE COULD RESULT.

Figure 17 illustrates the electrical system of the 77A Case Sealer. No adjustments to the electrical systems are required.

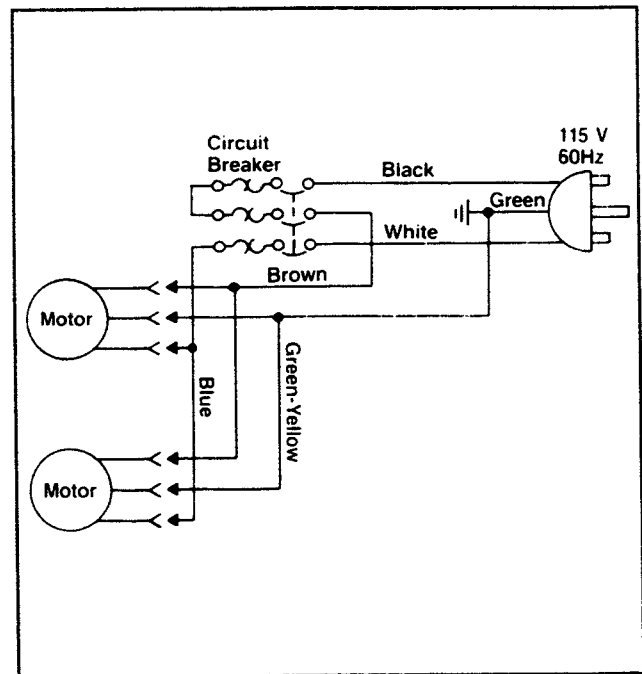


Figure 17

Circuit Breaker

The 77A 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, wait 2 minutes, move to "Off", then turn "On". Located inside the electrical control box on the side of the main frame just below the conveyor bed, the circuit breaker has been pre-set and requires no further maintenance.

Maintenance (Continued)

Lubrication - Mechanical

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

Figure 18 and 19 illustrate the taping head and frame points which should be lubricated every 3 months or 150,000 machine cycles, whichever comes first. The oil bottle supplied with the case sealer can be utilized to 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.

CAUTION - WIPE OFF EXCESS OIL AND GREASE; IT WILL ATTRACT DUST AND DIRT WHICH CAN CAUSE PREMATURE EQUIPMENT WEAR AND JAMMING. TAKE CARE THAT OIL AND GREASE ARE NOT LEFT ON THE SURFACE OF ROLLERS AROUND WHICH TAPE IS THEADED, AS IT CAN CONTAMINATE THE TAPE'S ADHESIVE.

Blade Oiler Pad

The taping heads are equipped with a blade oiler pad that has been pre-lubricated at the factory to provide a film of oil on the cut-off blade to reduce adhesive build-up. Apply SAE #30 non-detergent oil as needed. Do not saturate.

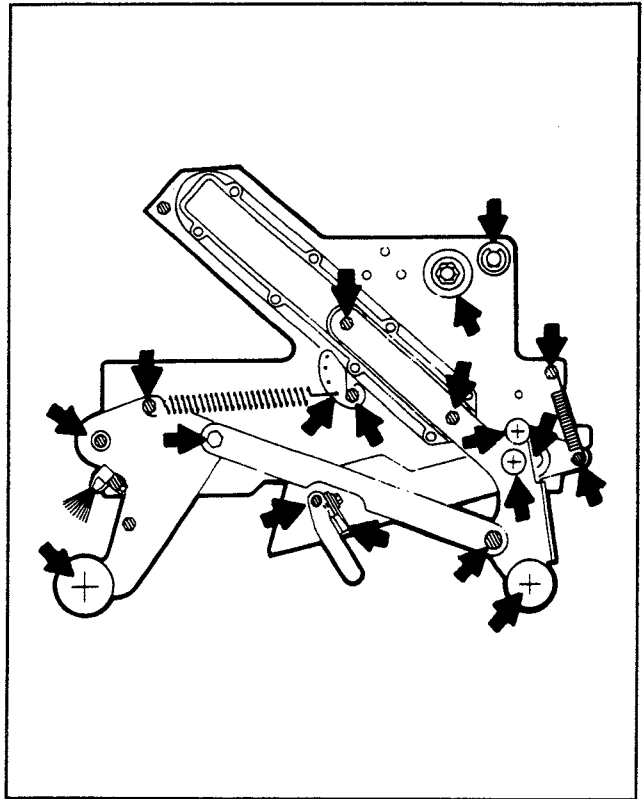


Figure 18 - Lubrication Points - Top and Bottom Taping Heads

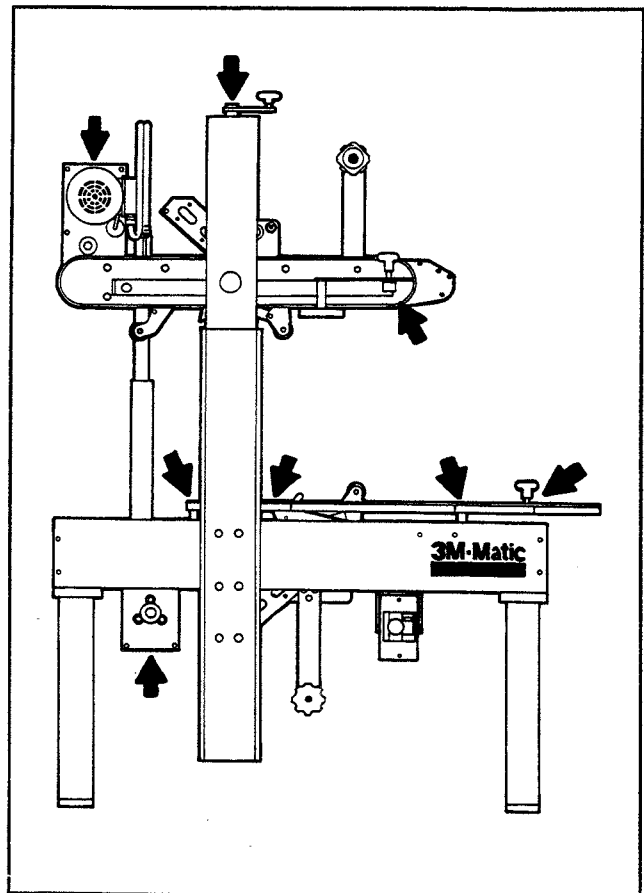


Figure 19 - Lubrication Points - Frame

Replacement Parts And Service Information

Spare Parts

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

Qty.	Ref. No.	3M Part Number	Description
1	1145-6	78-8017-9101-9	Roller - Applying
1	1146-5	78-8017-9140-7	Roller - Buffing
1	1146-10	78-8052-6589-5	Spring - Extension Top
2	1148-2	78-8017-9173-8	Blade - 2.56 inch/65 mm
2	1148-10	78-8052-6602-6	Spring - Cutter
1	1198-11	78-8054-8550-1	Spring - Extension Bottom
2	1314-5	78-8052-6722-2	Belt - Drive

Tool Kit

A tool kit, P/N 78-8054-8732-5, 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 77A case sealer. The threading tool, Part No. 78-8017-9433-6, contained in above kit is also available as a replacement stock item. Refer to "How To Order Replacement Parts" for ordering information.

How To Order Replacement Parts

1. Order parts by part number, part name, machine catalog number, model number and part quantity required.

<p>Minimum billing on parts orders will be \$10.00. Replacement part prices available on request.</p>

2. Replacement parts and part prices available direct from:

**Dispenser Parts
Route 4, Box 5B
Amery, WI 54001**

Note - Outside the U.S. contact the local 3M subsidiary for parts order information.

3. Refer to the front of the instruction manual for 3M equipment service information.

Attachments

Additional information on the attachments listed below is included with the manual except where noted:

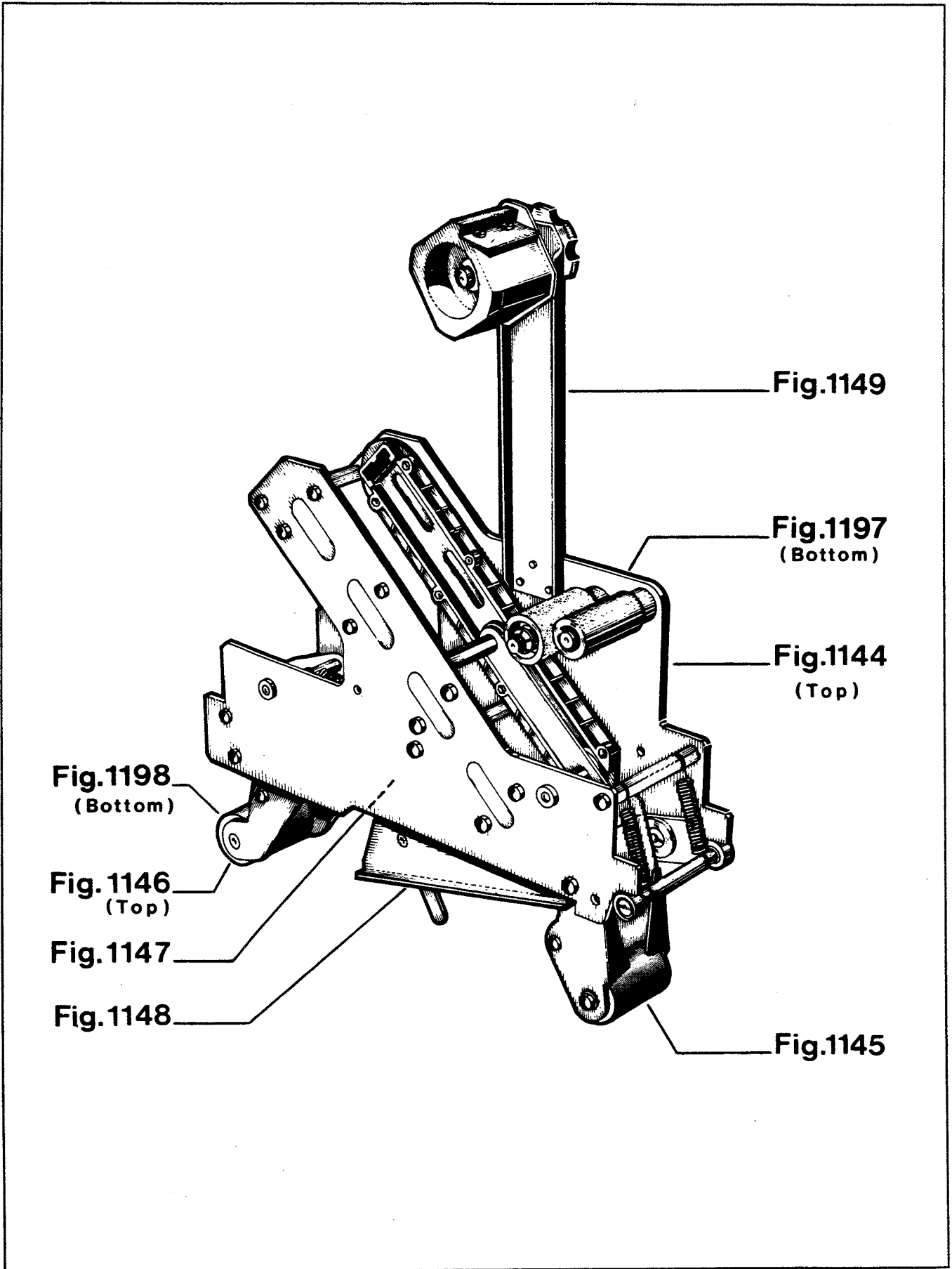
<u>Part Number</u>	<u>Attachment Name</u>
78-8052-6553-1	Box Hold Down Attachment, Model 18500
78-8060-7405-6	Caster Kit Attachment, Model 28700
78-8052-6555-6	Conveyor Extension Attachment, Model 18500

77A Case Sealer, Model 28600
Replacement Parts Illustrations and Parts Lists
Taping Head Assemblies

1. Refer to **Taping Head Assemblies** figure to find all the parts illustrations identified by **figure numbers**.
2. Refer to the figure or figures to determine the **individual parts** required and the parts **reference number**.
3. The **replacement parts list**, that follows each illustration, includes the **part number** and **part description** for the parts in that illustration.

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

4. Refer to page 19 - "**Replacement Parts and Service Information**" of this manual for replacement parts ordering information.



Taping Head Assemblies

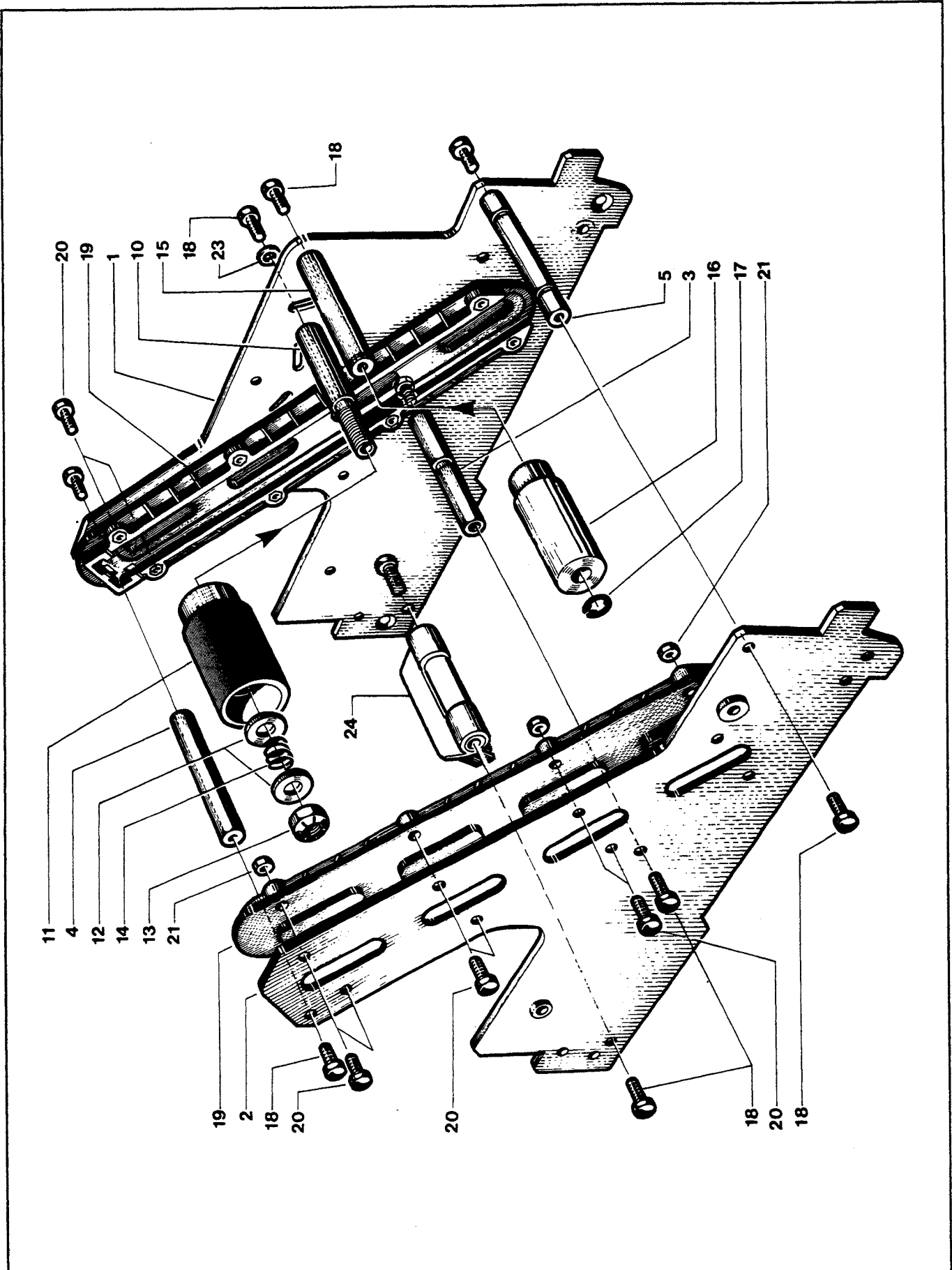


Figure 1144 Top

Figure 1144

Ref. No.	3M Part No.	Description
1144-1	78-8052-6556-4	Frame - R/H Top
1144-2	78-8052-6557-2	Frame - L/H Top
1144-3	78-8052-6558-0	Spacer - Spring Hook
1144-4	78-8052-6559-8	Spacer - Upper
1144-5	78-8052-6560-6	Spacer - Front
1144-6	78-8052-6561-4	Spacer - Brush Holder
1144-7	78-8052-6562-2	Buffing Brush Assy.
1144-8	78-8018-7798-2	Screw - Hex Hd M5 x 14 Zinc Pl.
1144-9	78-8052-6563-0	Bumper
1144-10	78-8052-6564-8	Shaft - Tension Roller
1144-11	78-8052-6565-5	Roller - Top Tension
1144-12	78-8052-6566-3	Washer - Friction
1144-13	78-8017-9077-1	Nut - Hex M10 x 1
1144-14	78-8052-6567-1	Spring - Compression
1144-15	78-8052-6568-9	Shaft - Wrap Roller
1144-16	78-8052-6569-7	Roller - Wrap
1144-17	26-1000-1613-3	Ring - Retaining, No. 10
1144-18	26-1003-5828-7	Screw - Hex Hd M6 x 10 Zinc Pl.
1144-19	78-8052-6570-5	Guide
1144-20	83-0002-7336-3	Screw - Hex Hd M4 x 14 Zinc Pl.
1144-21	78-8010-7416-8	Nut - Hex M4 Zinc Pl.
1144-23	26-1000-0010-3	Washer - Flat M6

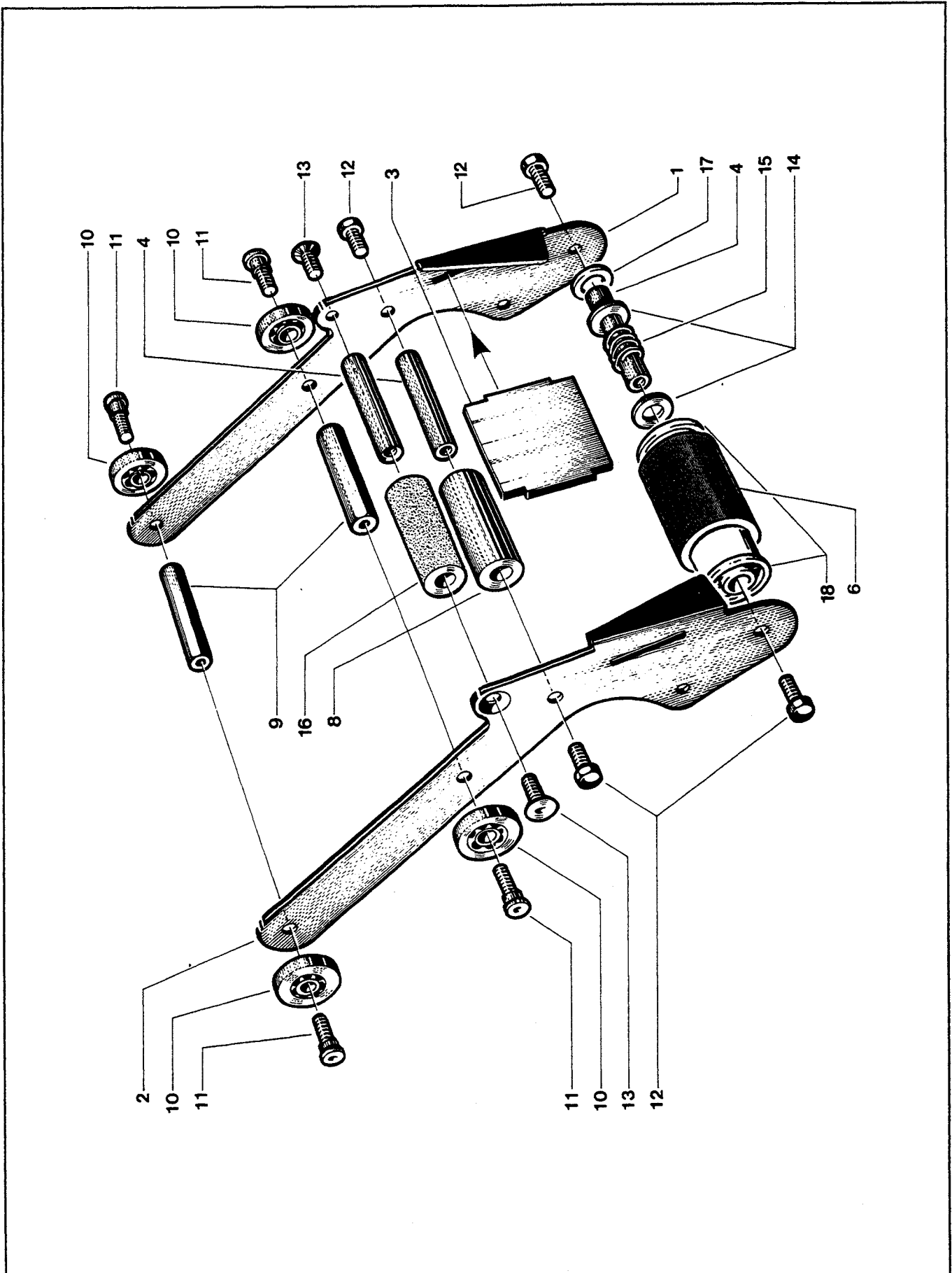


Figure 1145

Figure 1145

Ref. No.	3M Part No.	Description
1145-1	78-8052-6572-1	Frame - Applying Right Hand
1145-2	78-8052-6573-9	Frame - Applying Left Hand
1145-3	78-8052-6574-7	Plate - Back Up
1145-4	78-8052-6575-4	Shaft - Roller
1145-6	78-8057-6179-4	Roller - Applying
1145-8	78-8052-6579-6	Roller - Wrap
1145-9	78-8052-6580-4	Spacer
1145-10	78-8017-9082-1	Bearing - Special 30 mm
1145-11	78-8017-9106-8	Screw - Bearing Shoulder
1145-12	26-1003-5828-7	Screw - Hex Hd M6 x 10
1145-13	26-1005-4759-0	Screw - Flat Hd M6 x 12
1145-14	78-8052-6566-3	Washer - Friction
1145-15	78-8052-6567-1	Spring - Compression
1145-16	78-8060-7942-8	Roller - Knurled
1145-17	78-8017-9074-8	Washer - Nylon 15 mm
1145-18	78-8060-8395-8	Bushing - Applying Roller

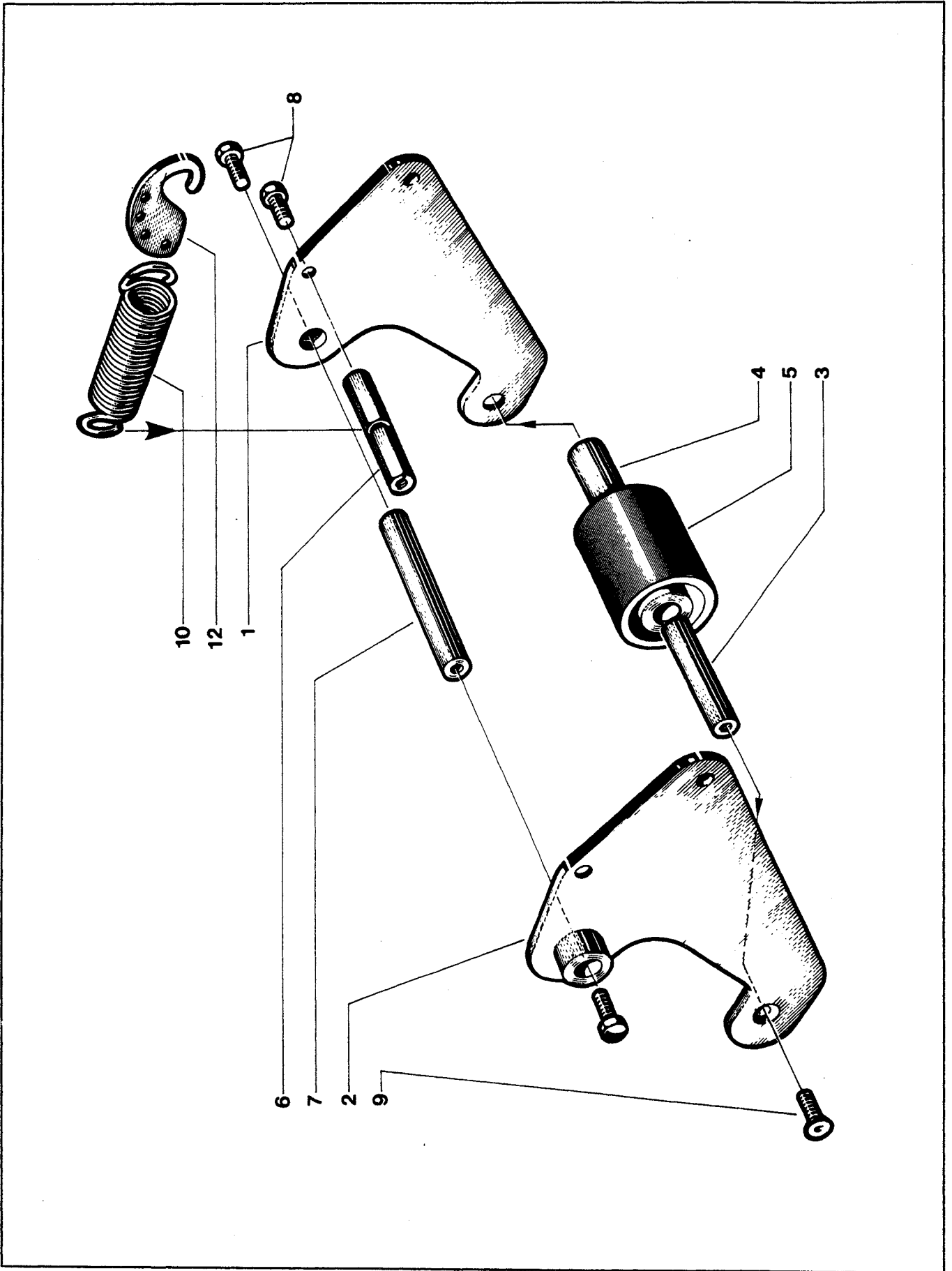


Figure 1146 Top

Figure 1146

Ref. No.	3M Part No.	Description
1146-1	78-8052-6583-8	Frame - R/H
1146-2	78-8052-6584-6	Frame - L/H
1146-3	78-8052-6575-4	Shaft - Buffing Roller
1146-4	78-8052-6586-1	Bushing - Buffing Roller
1146-5	78-8057-6178-6	Roller - Buffing
1146-6	78-8052-6587-9	Spacer - Spring
1146-7	78-8017-9109-2	Shaft - Buffing Assy.
1146-8	26-1003-5828-7	Screw - Hex Hd M6 x 10
1146-9	26-1005-4759-0	Screw - Flat Hd M6 x 12
1146-10	78-8052-6589-5	Spring - Top Ext.
1146-12	78-8052-6590-3	Holder - Spring

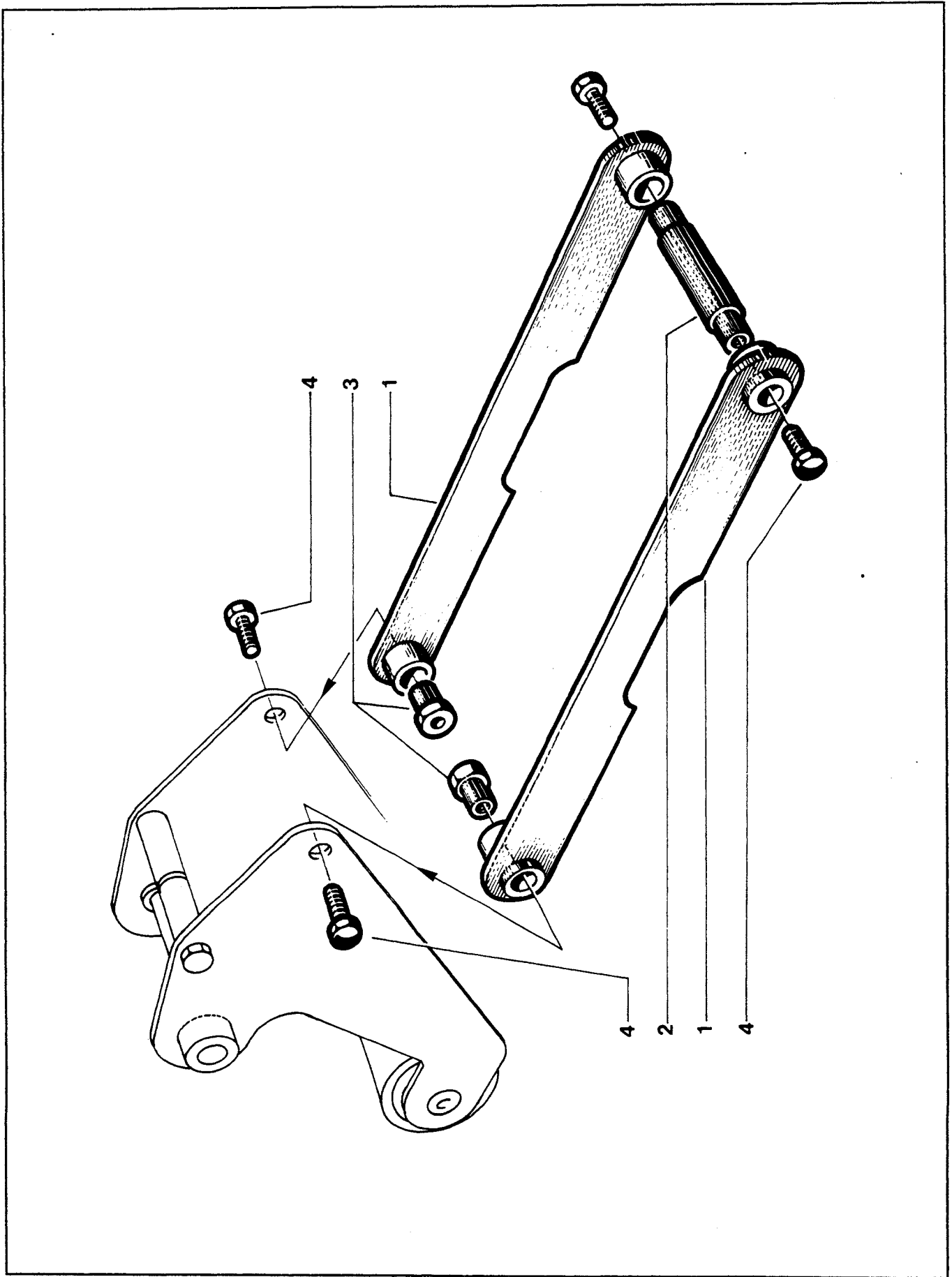


Figure 1147

Figure 1147

Ref. No.	3M Part No.	Description
1147-1	78-8052-6592-9	Arm - Link
1147-2	78-8052-6593-7	Shaft - Pivot
1147-3	78-8052-6594-5	Bushing - Pivot
1147-4	78-8010-7163-6	Screw - Hex Hd M5 x 10 Zinc Pl.

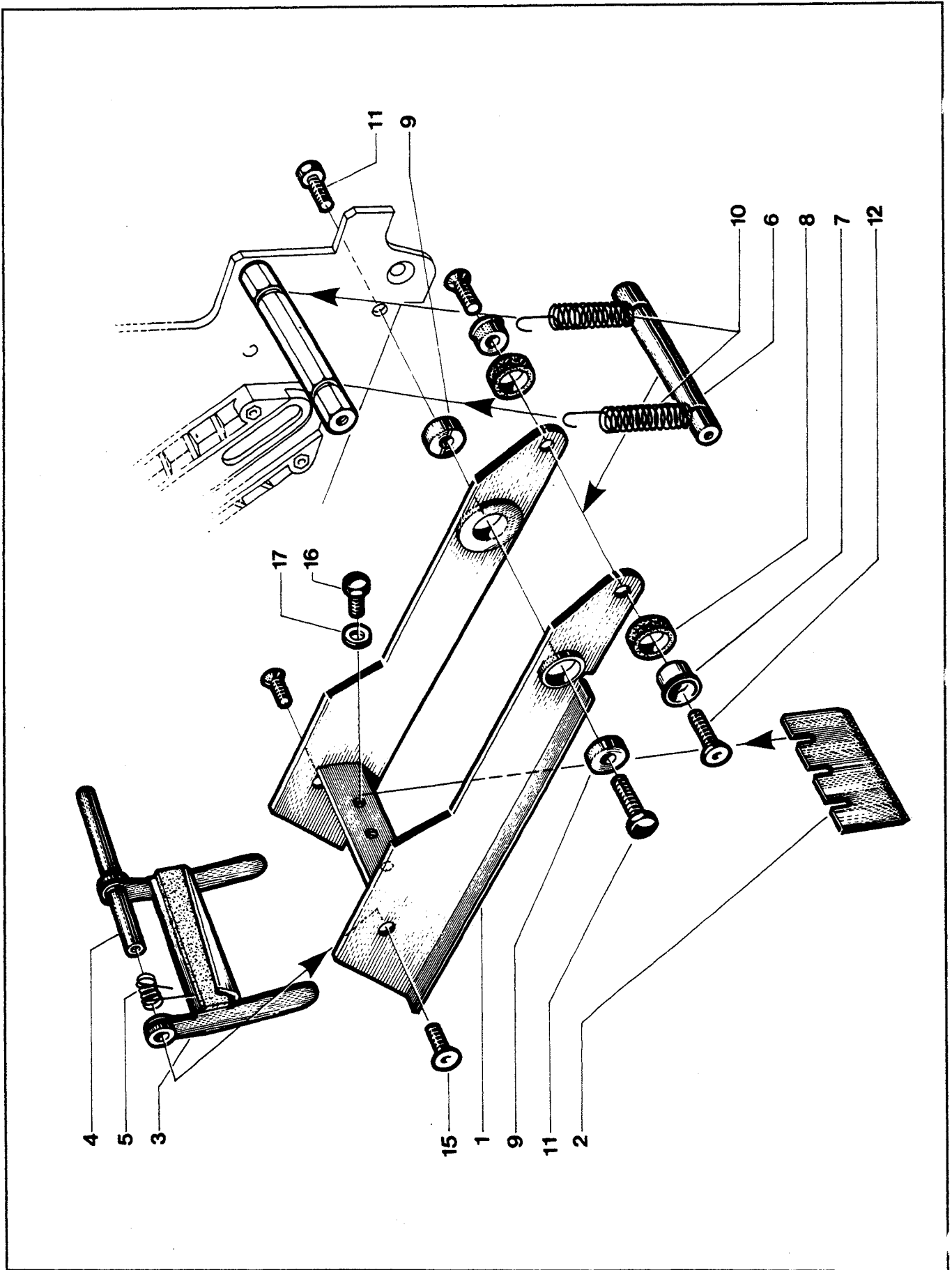


Figure 1148

Figure 1148

Ref. No.	3M Part No.	Description
1148-1	78-8052-6595-2	Bracket - Cut-off`
1148-2	78-8017-9173-8	Blade - 2.56 inch/65 mm
1148-3	78-8052-6596-0	Guard - Blade
1148-4	78-8052-6597-8	Shaft - Blade Guard
1148-5	78-8052-6598-6	Spring - Tension
1148-6	78-8017-9135-7	Pin - Spring Holder
1148-7	78-8052-6600-0	Spacer
1148-8	78-8017-9133-2	Bumper
1148-9	78-8017-9132-4	Pivot - Cutter Lever
1148-10	78-8052-6602-6	Spring - Cutter
1148-11	26-1003-5828-7	Screw - Hex Hd M6 x 10 Zinc Pl.
1148-12	26-1005-4757-4	Screw - Flat Hd M5 x 20 Zinc Pl.
1148-15	26-1005-4758-2	Screw - Flat Hd M4 x 10 Zinc Pl.
1148-16	78-8052-6747-9	Collar Screw M5 x 8 Zinc Pl.

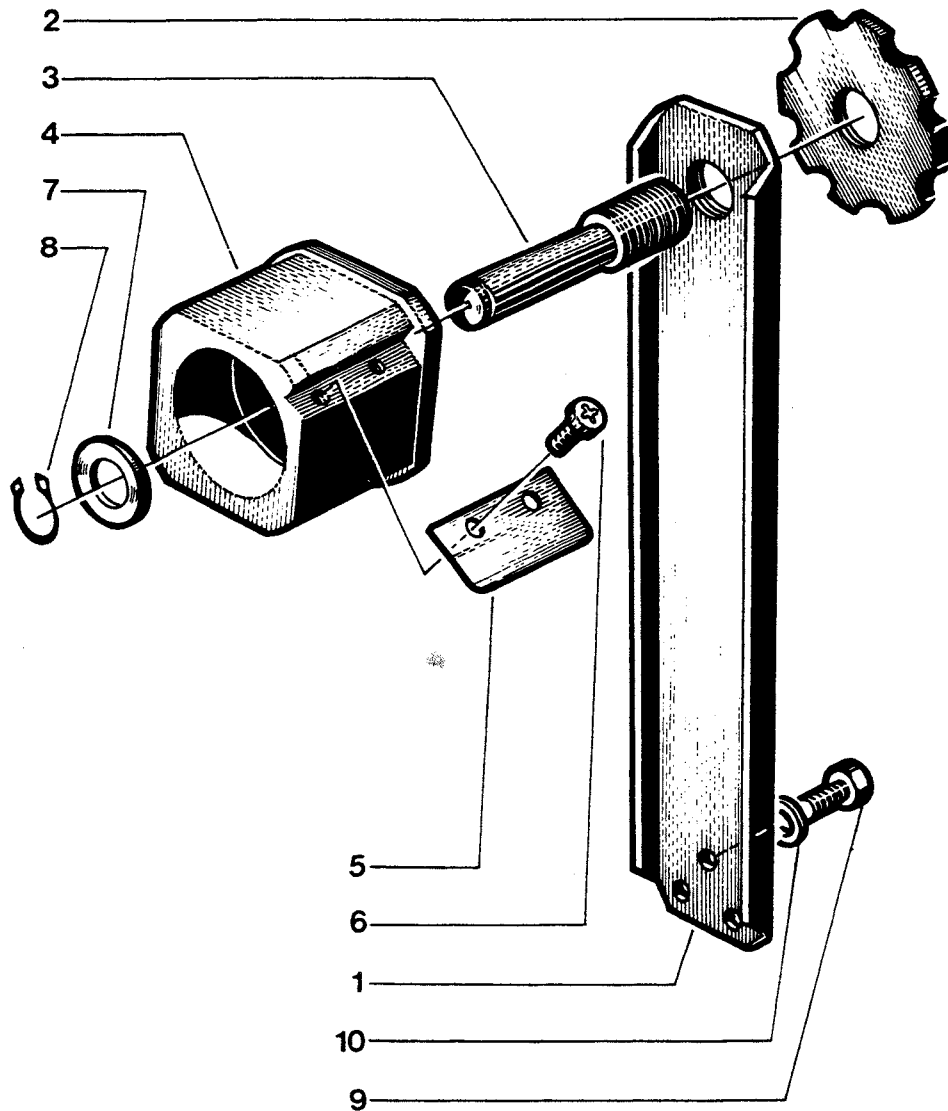


Figure 1149

Figure 1149

Ref. No.	3M Part No.	Description
1149-1	78-8052-6544-0	Bracket - Tape Drum
1149-2	78-8017-9091-2	Plate - Locking, Tape Drum Shaft
1149-3	78-8052-6603-4	Shaft - Tape Drum
1149-4	78-8052-6749-5	Drum - Tape
1149-5	78-8052-6268-6	Leaf - Spring
1149-6	26-1002-5753-9	Screw - Self Tapping 7SP x 8
1149-7	78-8052-6541-6	Washer - Special
1149-8	26-1002-6110-1	Ring - Retaining No. 14
1149-9	26-1003-5828-7	Screw - Hex Hd M6 x 10
1149-10	26-1000-0010-3	Washer - Flat M6

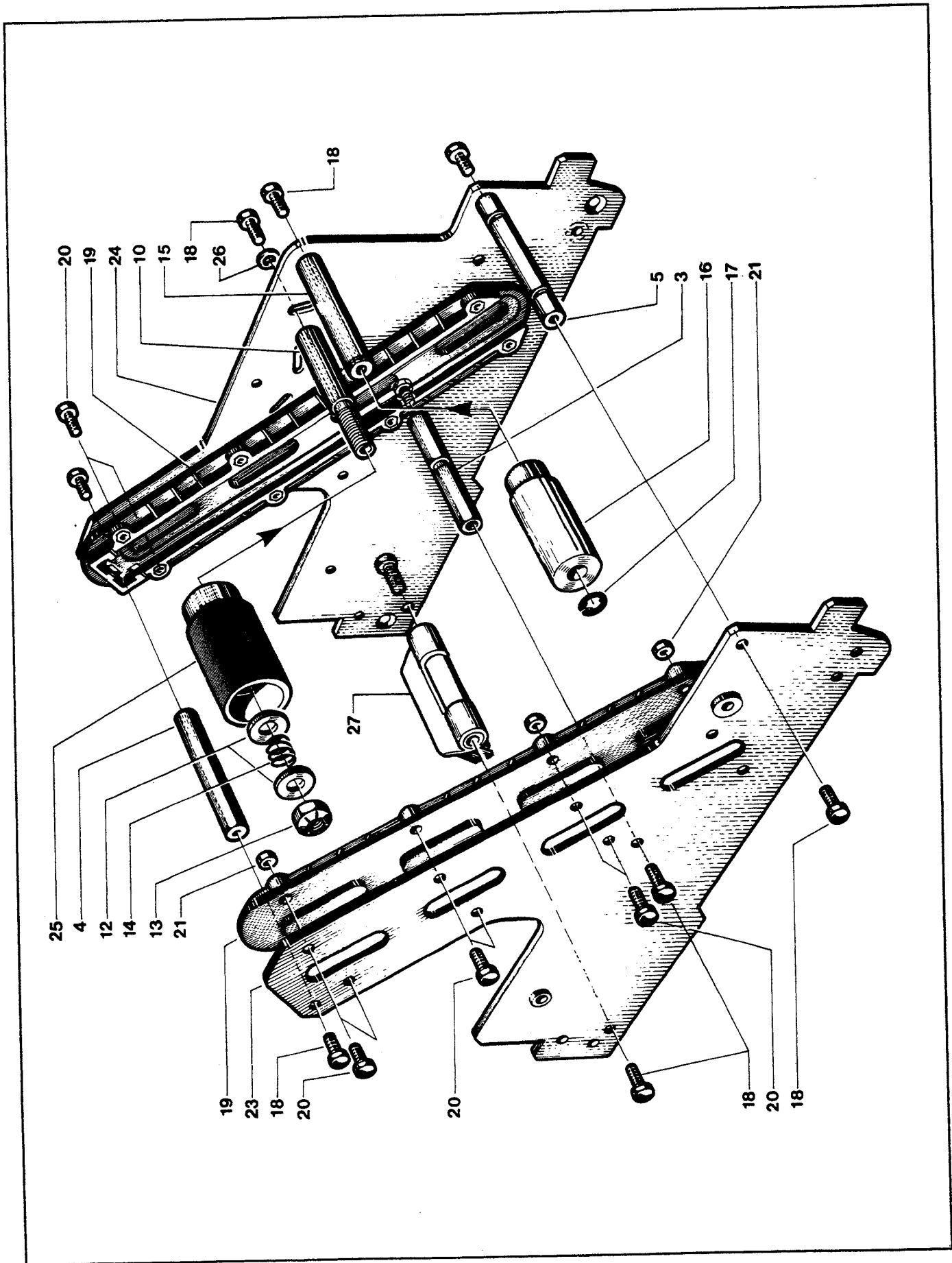


Figure 1197 Bottom

Figure 1197

Ref. No.	3M Part No.	Description
1197-3	78-8052-6558-0	Spacer - Spring Hook
1197-4	78-8052-6559-8	Spacer - Upper
1197-5	78-8052-6560-6	Spacer - Front
1197-6	78-8052-6561-4	Spacer - Brush Holder
1197-7	78-8052-6562-2	Buffing Brush Assy.
1197-8	78-8018-7798-2	Screw - Hex Hd M5 x 14 Zinc Pl.
1197-9	78-8052-6563-0	Bumper
1197-10	78-8052-6564-8	Shaft - Tension Roller
1197-12	78-8052-6566-3	Washer - Friction
1197-13	78-8017-9077-1	Nut - Hex
1197-14	78-8052-6567-1	Spring - Compression
1197-15	78-8052-6568-9	Shaft - Wrap Roller
1197-16	78-8052-6569-7	Roller Wrap
1197-17	26-1000-1613-3	Ring - Retaining
1197-18	26-1003-5828-7	Screw - Hex Hd M-6 x 10 Zinc Pl.
1197-19	78-8052-6570-5	Guide
1197-20	83-0002-7336-3	Screw - Hex Hd M4 x 14 Zinc. Pl.
1197-21	78-8010-7416-8	Nut - Hex M4 Zinc Pl.
1197-23	78-8052-6604-2	Frame - L/H Bottom
1197-24	78-8052-6605-9	Frame - R/H Bottom
1197-25	78-8052-6606-7	Roller - Tension Bottom
1197-26	26-1000-0010-3	Washer - Flat M6

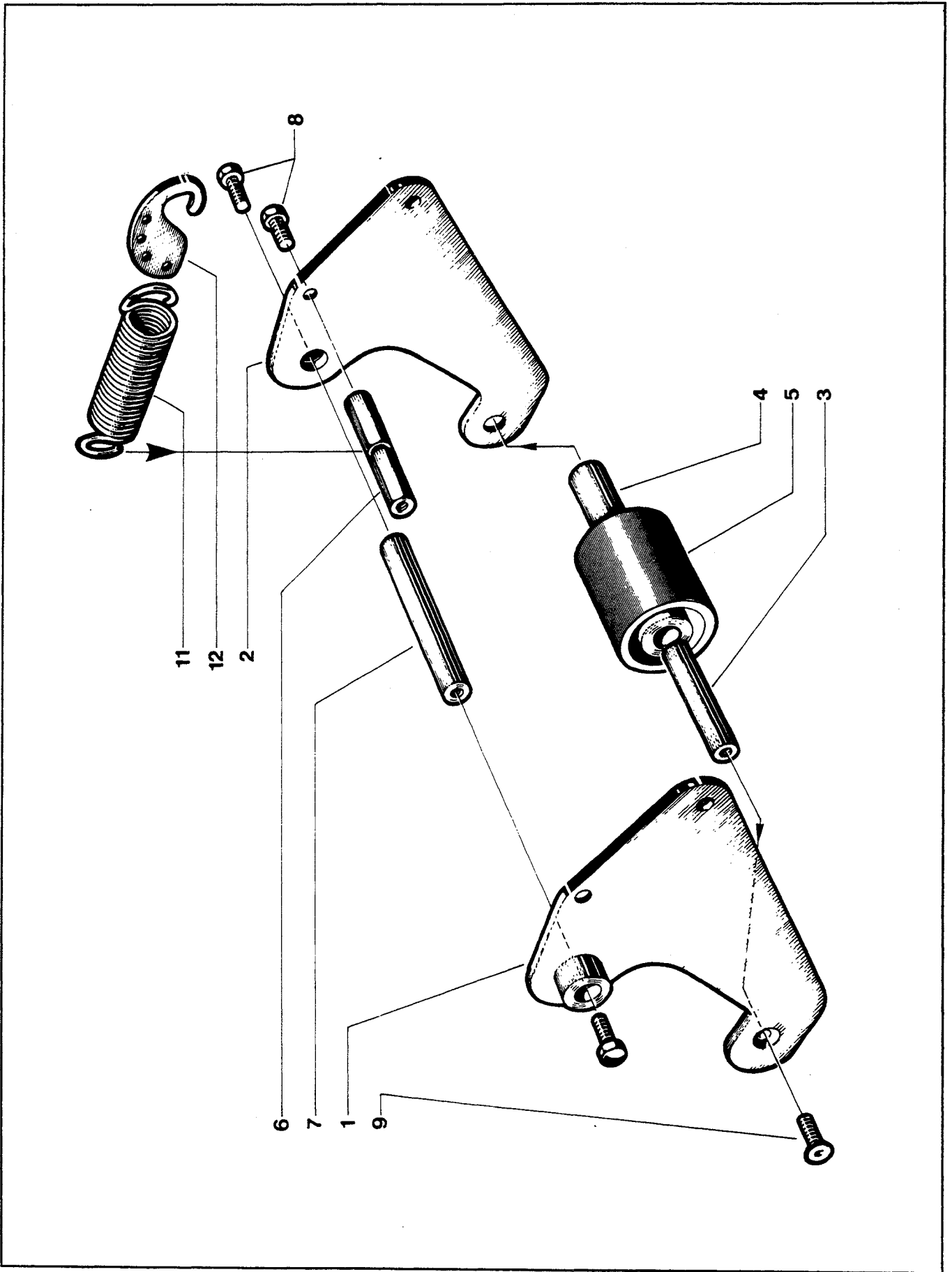


Figure 1198 Bottom

Figure 1198

Ref. No.	3M Part No.	Description
1198-1	78-8052-6583-8	Frame - R/H
1198-2	78-8052-6584-6	Frame - L/H
1198-3	78-8052-6575-4	Shaft - Buffing Roller
1198-4	78-8052-6586-1	Bushing - Buffing Roller
1198-5	78-8017-9140-7	Roller - Buffing
1198-6	78-8052-6587-9	Spacer - Spring
1198-7	78-8017-9109-2	Shaft - Buffing Assy.
1198-8	26-1003-5828-7	Screw - Hex Hd M6 x 10
1198-9	26-1005-4759-0	Screw - Flat Hd M6 x 12
1198-11	78-8054-8550-1	Spring - Bottom Ext.
1198-12	78-8052-6590-3	Holder - Spring

77A Case Sealer, Model 28600
Replacement Parts Illustrations and Parts Lists
Frame Assemblies

1. Refer to **Frame Assemblies figure** to find all parts illustrations identified by **figure numbers**.
2. Refer to the figure or figures to determine the **individual parts** required and the **parts reference number**.
3. The **replacement parts list**, that follows each illustration, includes the **part number** and **part description** for the parts in the 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 page 19 - "**Replacement Parts and Service Information**" of this manual for replacement parts ordering information.

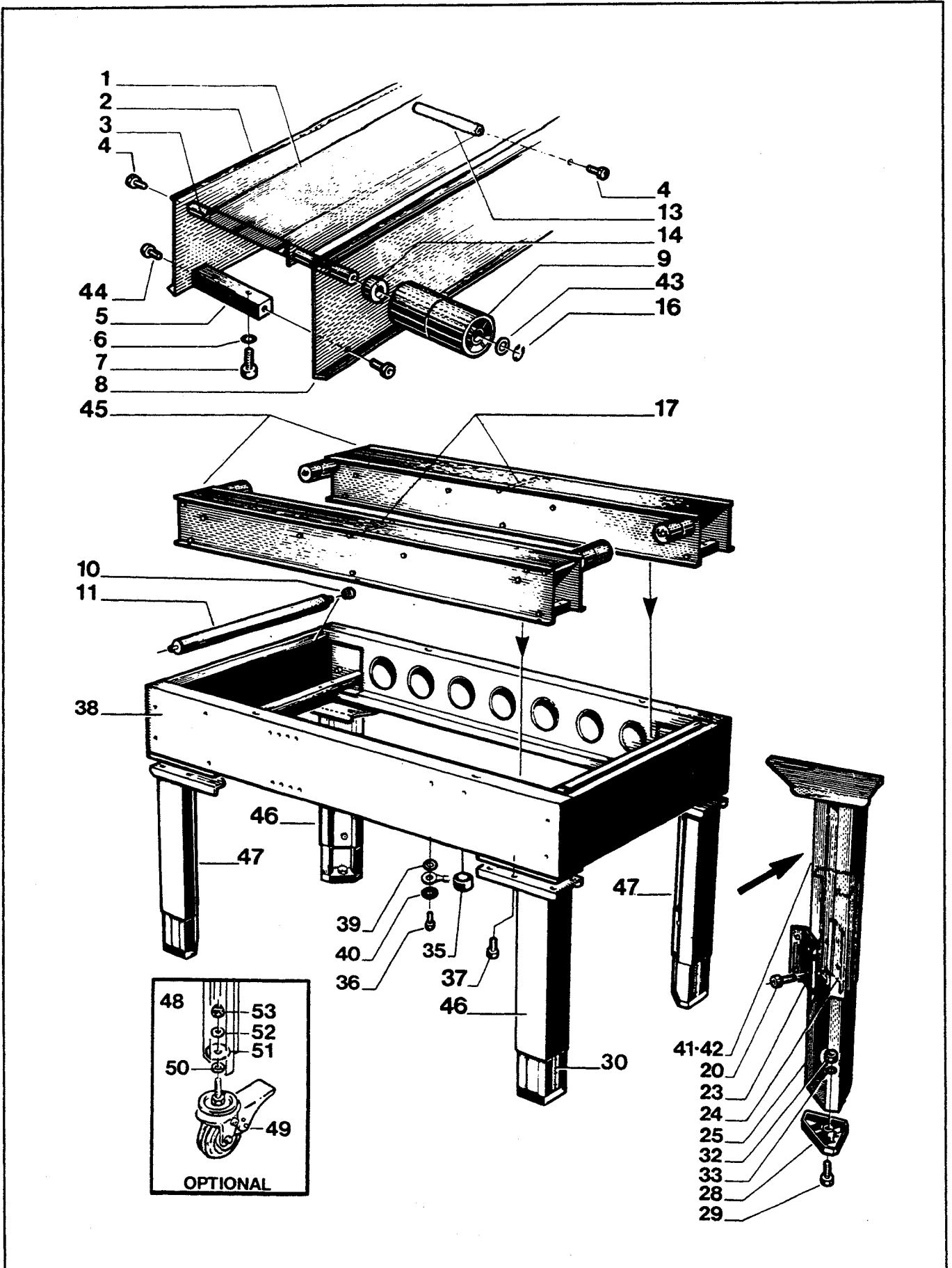


Figure 1304

Figure 1304

Ref. No.	3M Part No.	Description
1304-1	78-8052-6662-0	Conveyor Bed
1304-2	78-8052-6663-8	Side Plate
1304-3	78-8052-6664-6	Spacer
1304-4	78-8010-7163-6	Screw - Hex Hd M5 x 10 Metric
1304-5	78-8052-6665-3	Block - Mounting
1304-6	26-1000-0010-3	Washer - Flat M6
1304-7	78-8010-7209-7	Screw - Soc Hd M6 x 12
1304-8	78-8052-6666-1	Side Plate
1304-9	78-8052-6667-9	Roller
1304-10	78-8052-6668-7	Snap - Roller
1304-11	78-8052-6669-5	Roller - Conveyor
1304-13	78-8052-6671-1	Spacer
1304-14	78-8052-6672-9	Spacer
1304-16	78-8052-6732-1	Ring - M8 Special
1304-17	78-8052-6673-7	Spacer
1304-20	26-1003-7963-0	Screw - Soc Hd M8 x 16
1304-23	78-8052-6676-0	Clamp - Outer
1304-24	78-8052-6677-8	Clamp - Inner
1304-25	78-8052-6678-6	Leg - Inner
1304-28	78-8052-6679-4	Pad - Foot
1304-29	26-1003-5842-8	Screw - Hex Hd M8 x 20
1304-30	78-8052-6680-2	Label - Height
1304-32	78-8017-9313-0	Nut - Self Locking M8
1304-33	26-1004-5507-5	Washer - M8
1304-35	78-8060-7758-8	Fairlead /20
1304-36	26-1003-5820-4	Screw - Hex Hd M5 x 12
1304-37	26-1003-7964-8	Screw - Soc Hd Hex M8 x 20
1304-38	78-8055-0671-0	Bed - Conveyor
1304-39	78-8046-8217-3	Washer - Special
1304-40	78-8005-5741-1	Washer - Plain, M5 Metric
1304-41	78-8060-7948-5	Leg - Left
1304-42	78-8060-7947-7	Leg - Right
1304-43	78-8017-9318-9	Washer - Plain 8 mm Metric
1304-44	26-1003-7948-1	Screw - Soc Hd Hex M5 x 10
1304-45	78-8060-8141-6	Conveyor Bed Assembly
1304-46	78-8060-8123-4	Leg Assembly - Left
1304-47	78-8060-8122-6	Leg Assembly - Right
1304-48	78-8060-8060-8	Caster Assembly - /80
1304-49	78-8060-8061-6	Caster - /80
1304-50	78-8060-8124-2	Spacer - Caster
1304-51	78-8060-7699-4	Washer - /12-45,5X4
1304-52	78-8017-9059-9	Washer - Flat for M12 Screw
1304-53	78-8060-7532-7	Nut - M12 Self Locking

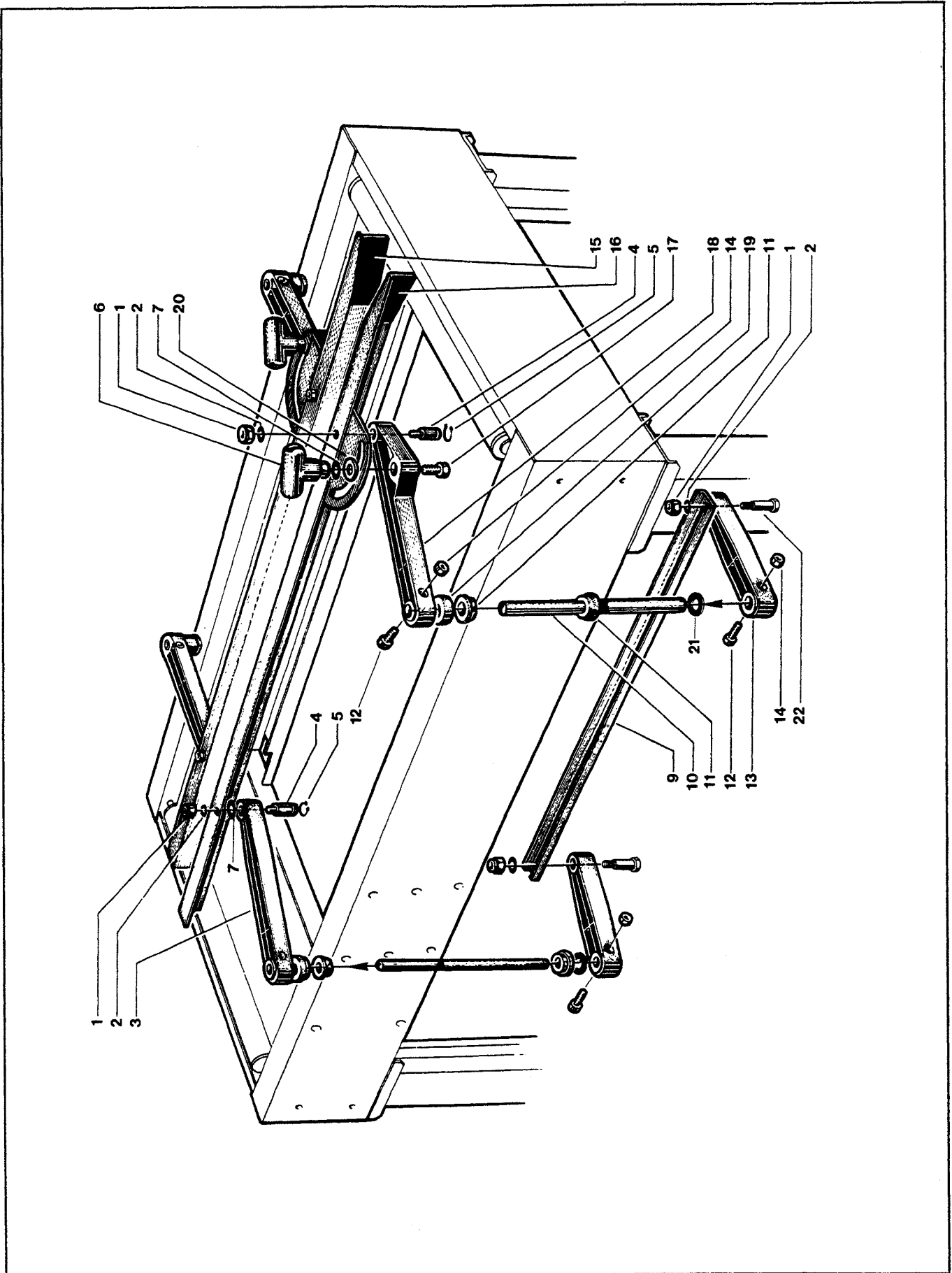


Figure 1305

Figure 1305

Ref. No.	3M Part No.	Description
1305-1	26-1003-6916-9	Nut - Locking Plastic Insert M6
1305-2	26-1000-0010-3	Washer - Flat M6
1305-3	78-8052-6682-8	Arm - Guide
1305-4	78-8052-6683-6	Stud - Guide
1305-5	78-8052-6733-9	Ring - M10 Special
1305-6	78-8060-8055-8	Knob
1305-7	78-8052-6566-3	Washer - Friction
1305-9	78-8052-6685-1	Link - Guide
1305-10	78-8052-6686-9	Shaft
1305-11	78-8052-6687-7	Sleeve
1305-12	78-8010-7210-5	Screw - Soc Hd M6 x 20
1305-13	78-8052-6688-5	Arm - Guide
1305-14	78-8010-7418-4	Nut - Hex M6 Metric
1305-15	78-8052-6689-3	Guide - Right
1305-16	78-8052-6690-1	Guide - Left
1305-17	26-1003-7976-2	Screw - Soc Hd M10 x 35
1305-18	78-8052-6691-9	Arm - Guide
1305-19	78-8052-6692-7	Sleeve
1305-20	78-8057-5803-0	Washer - Dented
1305-21	78-8017-9059-9	Washer - Flat for M12 Screw
1305-22	78-8060-7878-4	Screw - Idler

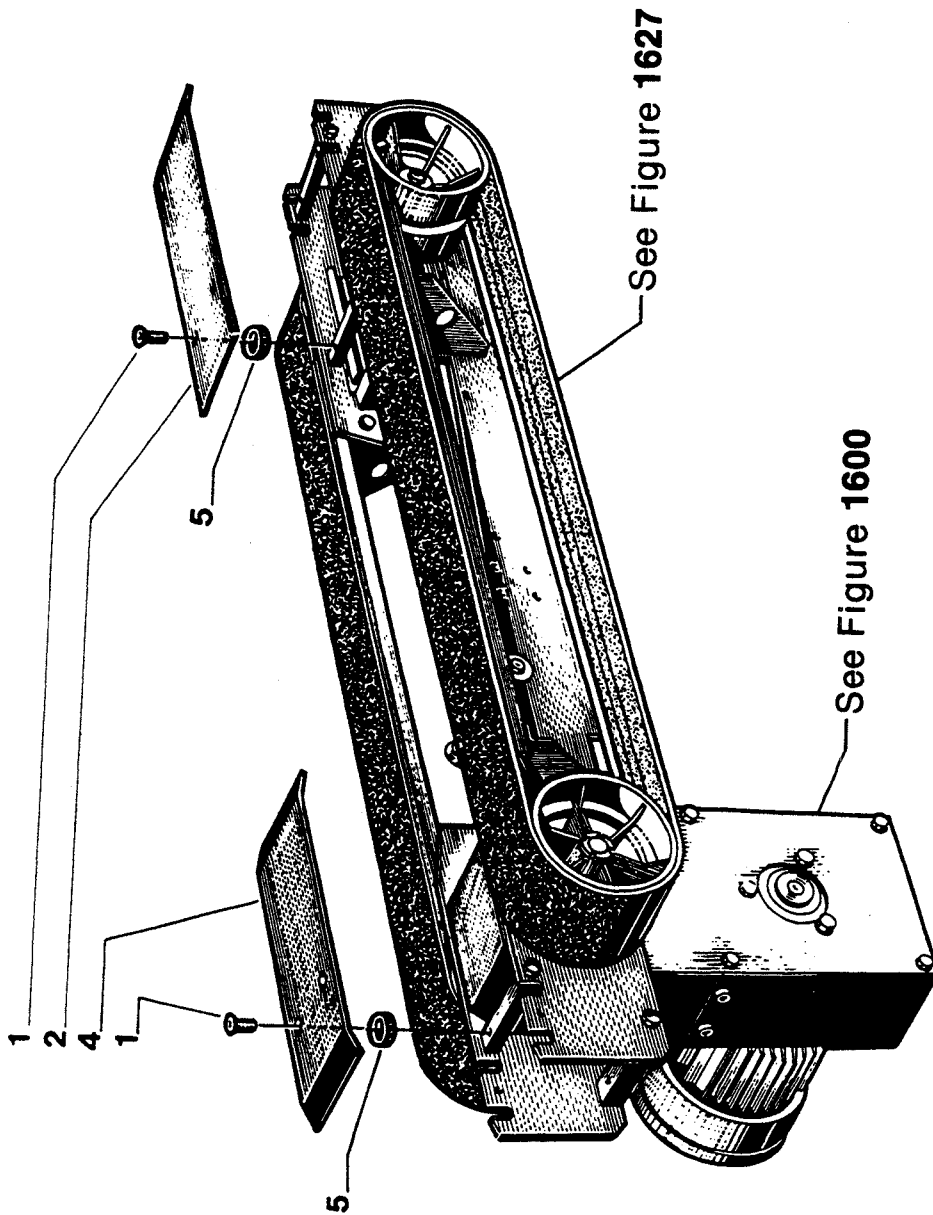


Figure 1310

Figure 1310

Ref. No.	3M Part No.	Description
1310-1	26-1005-5316-8	Screw - Flat Hd Hex M5 x 16
1310-2	78-8052-6721-4	Plate - Center, Front
1310-4	78-8052-6723-0	Plate - Center, Rear
1310-5	78-8054-8751-5	Spacer

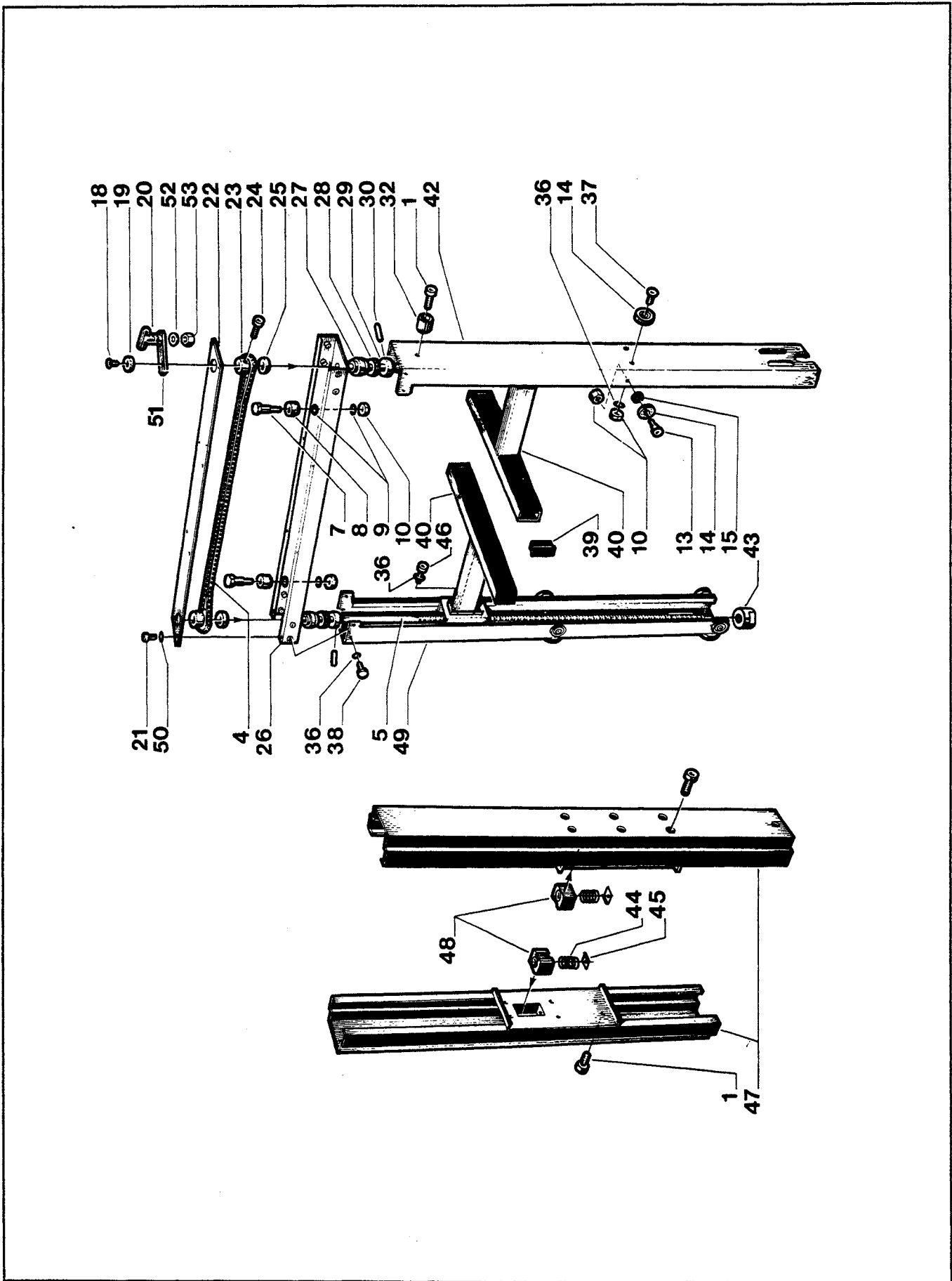


Figure 1312

Figure 1312

Ref. No.	3M Part No.	Description
1312-1	26-1003-7964-8	Screw - Soc Hd Hex M8 x 20
1312-4	78-8054-8572-5	Chain
1312-5	78-8054-8573-3	Screw - Lead
1312-7	78-8060-7878-4	Screw - Idler
1312-8	78-8054-8575-8	Roller - Idler
1312-9	78-8042-2919-9	Washer - M6
1312-10	26-1003-6916-9	Nut - Locking Plastic Insert M6
1312-13	78-8017-9106-8	Screw - Bearing Shoulder
1312-14	78-8054-8617-8	Bearing Special
1312-15	78-8054-8576-6	Spacer
1312-18	26-1001-9843-6	Screw - Flat Soc Hd M6 x 16
1312-19	78-8054-8577-4	Washer - Special
1312-20	78-8054-8578-2	Crank
1312-21	26-1002-5753-9	Screw - Self Tapping
1312-22	78-8054-8579-0	Cover - Chain
1312-23	78-8054-8580-8	Sprocket
1312-24	26-1003-7946-5	Screw - Soc. Hd M4 x 25
1312-25	78-8054-8581-6	Spacer
1312-26	78-8054-8582-4	Chain - Housing
1312-27	78-8054-8583-2	Bushing
1312-28	78-8054-8584-0	Spacer
1312-29	78-8054-8585-7	Collar
1312-30	78-8054-8586-5	Pin
1312-32	78-8054-8587-3	Stop
1312-36	26-1000-0010-3	Washer - Flat M6
1312-37	78-8054-8589-9	Screw Special
1312-38	78-8032-0375-7	Screw - Hex Hd M6 x 16 Metric
1312-39	78-8054-8593-1	Cap - End
1312-40	78-8054-8594-9	Head Support
1312-42	78-8054-8592-3	Column - Inner
1312-43	78-8054-8968-5	Nut - Special
1312-44	78-8054-8997-4	Spring
1312-45	78-8054-8970-1	Bed Plate for Spring
1312-46	78-8010-7210-5	Screw - Soc Hd Hex M6 x 20
1312-47	78-8054-8994-1	Column - Outer
1312-48	78-8054-8971-9	Nut - Plastic
1312-49	78-8060-8142-4	Inner Column Assembly
1312-50	78-8005-5740-3	Washer - Plain 4 mm Metric
1312-51	78-8060-8065-7	Lever - Knob
1312-52	78-8010-7435-8	Washer - Lock M6 Metric
1312-53	78-8010-7418-4	Nut - Hex M6 Metric

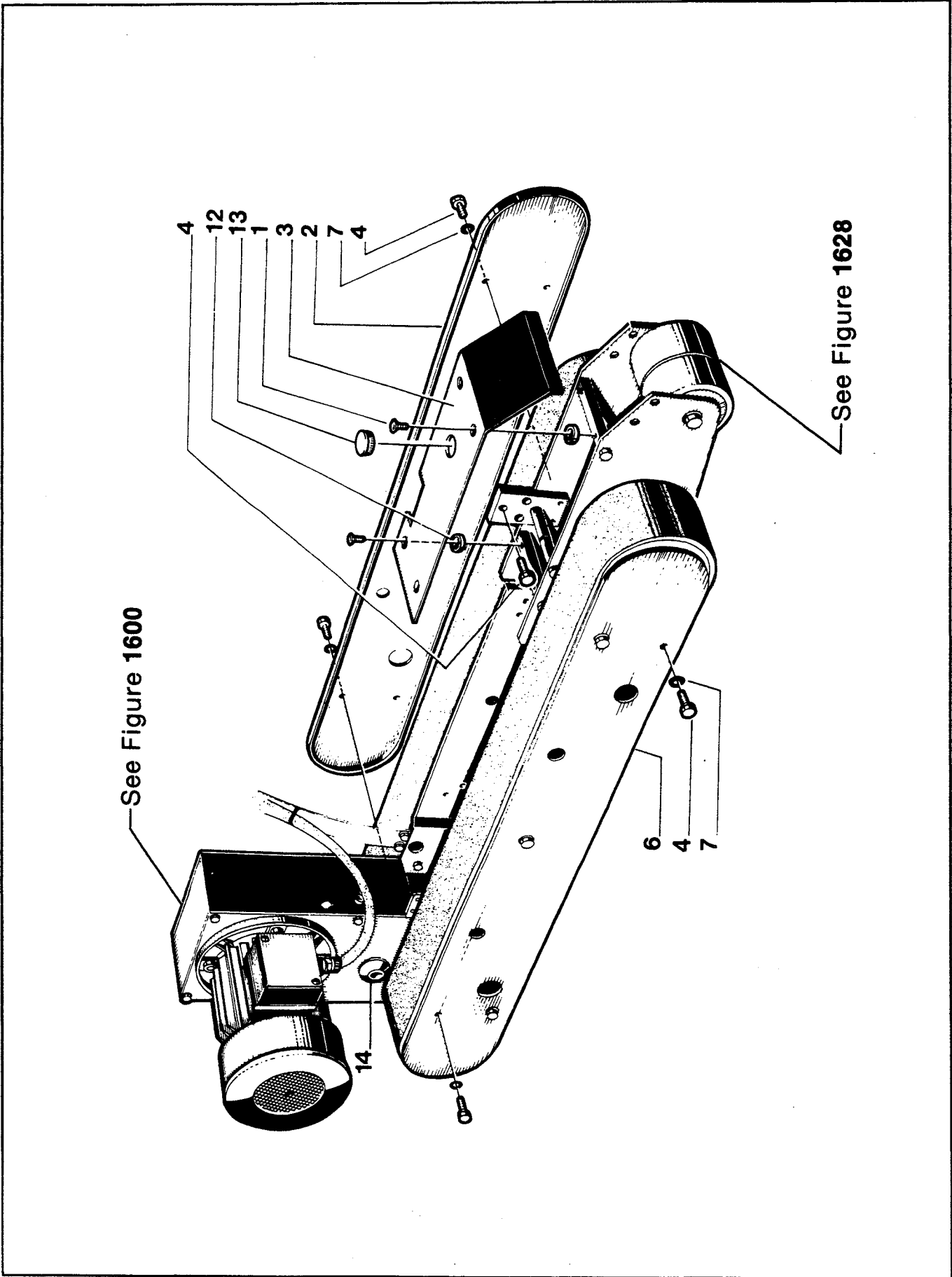


Figure 1314

Figure 1314

Ref. No.	3M Part No.	Description
1314-1	26-1005-5316-8	Screw - Flat Hd Hex Dr M5 x 16
1314-2	78-8052-6645-5	Cover - Right
1314-3	78-8052-6646-3	Cover - Top
1314-4	78-8010-7169-3	Screw - Hex Hd M6 x 12 Metric
1314-6	78-8052-6647-1	Cover - Left
1314-7	26-1000-0010-3	Washer - Flat M6
1314-12	78-8054-8751-5	Spacer
1314-13	78-8060-7885-9	End Cap - /25X1,2
1314-14	78-8054-8992-5	Guard - Nut

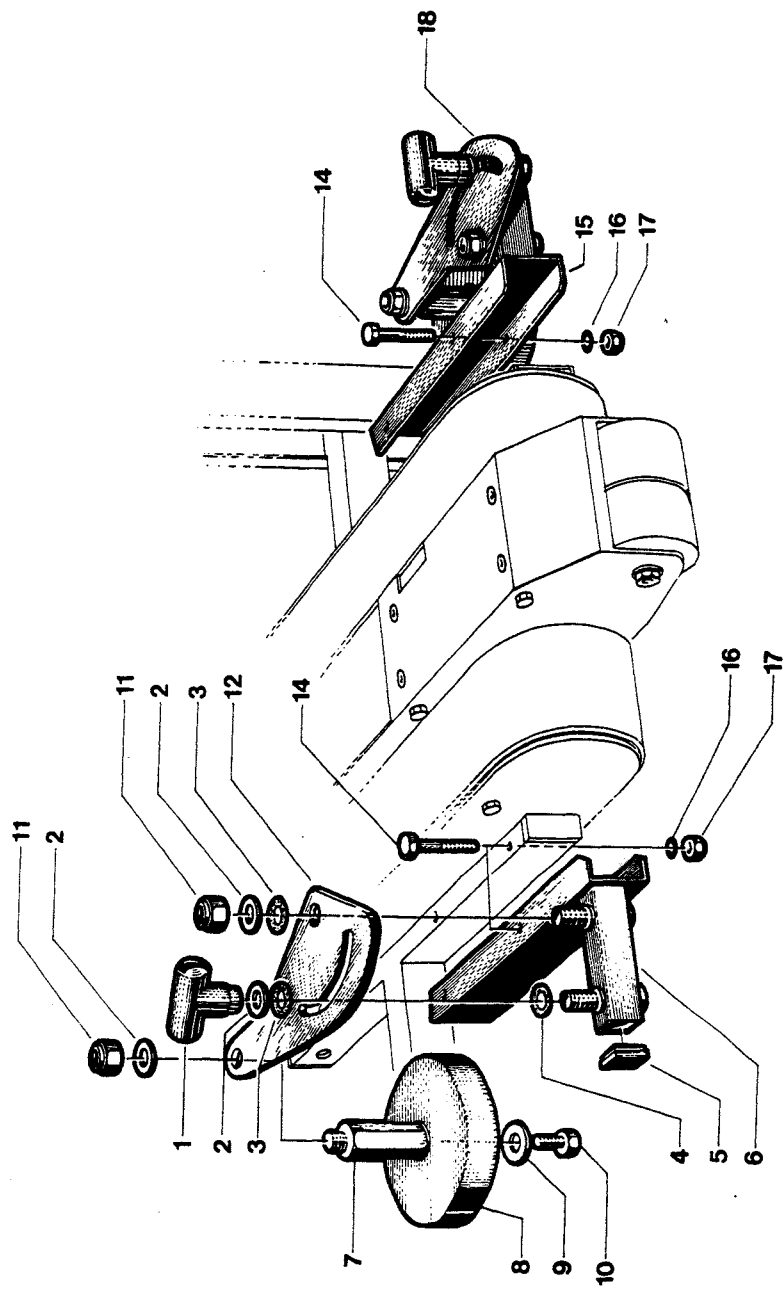


Figure 1315

Figure 1315

Ref. No.	3M Part No.	Description
1315-1	78-8060-8055-8	Knob
1315-2	78-8052-6566-3	Washer - Friction
1315-3	78-8017-9074-8	Washer - Nylon 15 mm
1315-4	78-8052-6651-3	Washer - Nylon
1315-5	78-8052-6652-1	Cap - End
1315-6	78-8052-6654-7	Support - Roller Left
1315-7	78-8052-6702-4	Stud - Mounting
1315-8	78-8054-8648-3	Pressure Roller
1315-9	78-8052-6703-2	Washer - Special
1315-10	26-1003-5841-0	Screw - M8 x 16
1315-11	26-1003-6918-5	Nut - Hex M10 Plastic Insert
1315-12	78-8052-6701-6	Plate - Mounting
1315-14	26-1005-5318-4	Screw - Hex Hd. M6 x 55
1315-15	78-8052-6653-9	Support - Roller, Right
1315-16	26-1000-0010-3	Washer - Flat M6
1315-17	26-1003-6916-9	Nut - Locking M6 Plastic Insert
1315-18	78-8060-8152-3	Roller Support Assembly - Right

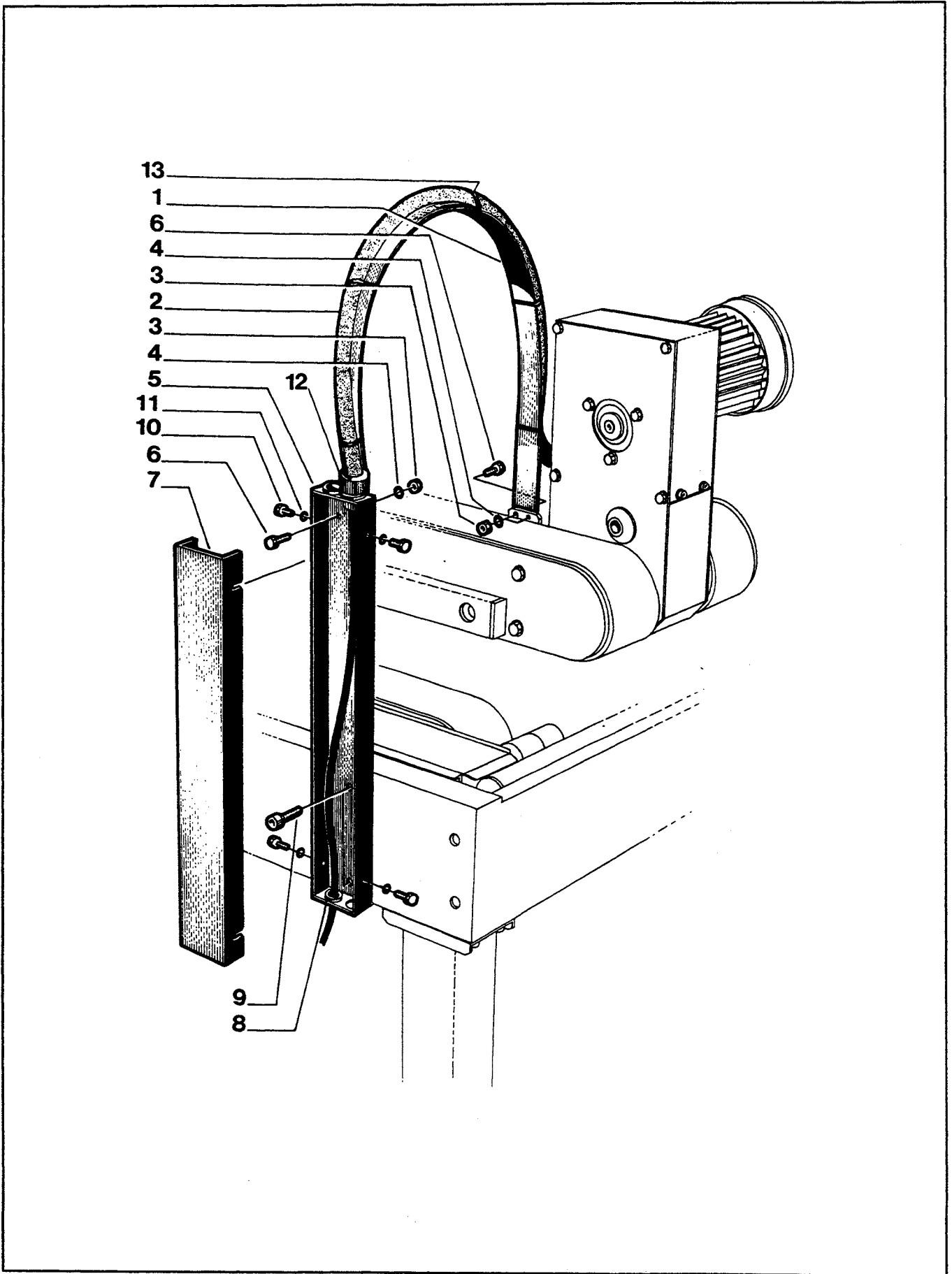


Figure 1316

Figure 1316

Ref. No.	3M Part No.	Description
1316-1	78-8052-6655-4	Strap - Wire
1316-2	78-8060-8154-9	Sleeving - 0,90 MT
1316-3	78-8010-7417-6	Nut - Hex M5 Metric
1316-4	78-8005-5741-1	Washer - Plain M5 Metric
1316-5	78-8052-6657-0	Housing - Wire
1316-6	78-8010-7163-6	Screw - Hex Hd. M5 x 10 Metric
1316-7	78-8052-6658-8	Cover
1316-8	78-8052-6659-6	Grommet
1316-9	26-1003-7963-0	Screw - Soc Hd. M8 x 16
1316-10	26-1003-5810-5	Screw - Hex Hd. M4 x 8
1316-11	78-8017-9018-5	Washer - Plain 4mm Metric
1316-12	78-8060-7631-7	Connector - 3/8
1316-13	78-8060-8029-3	Clamp - 14X3,5

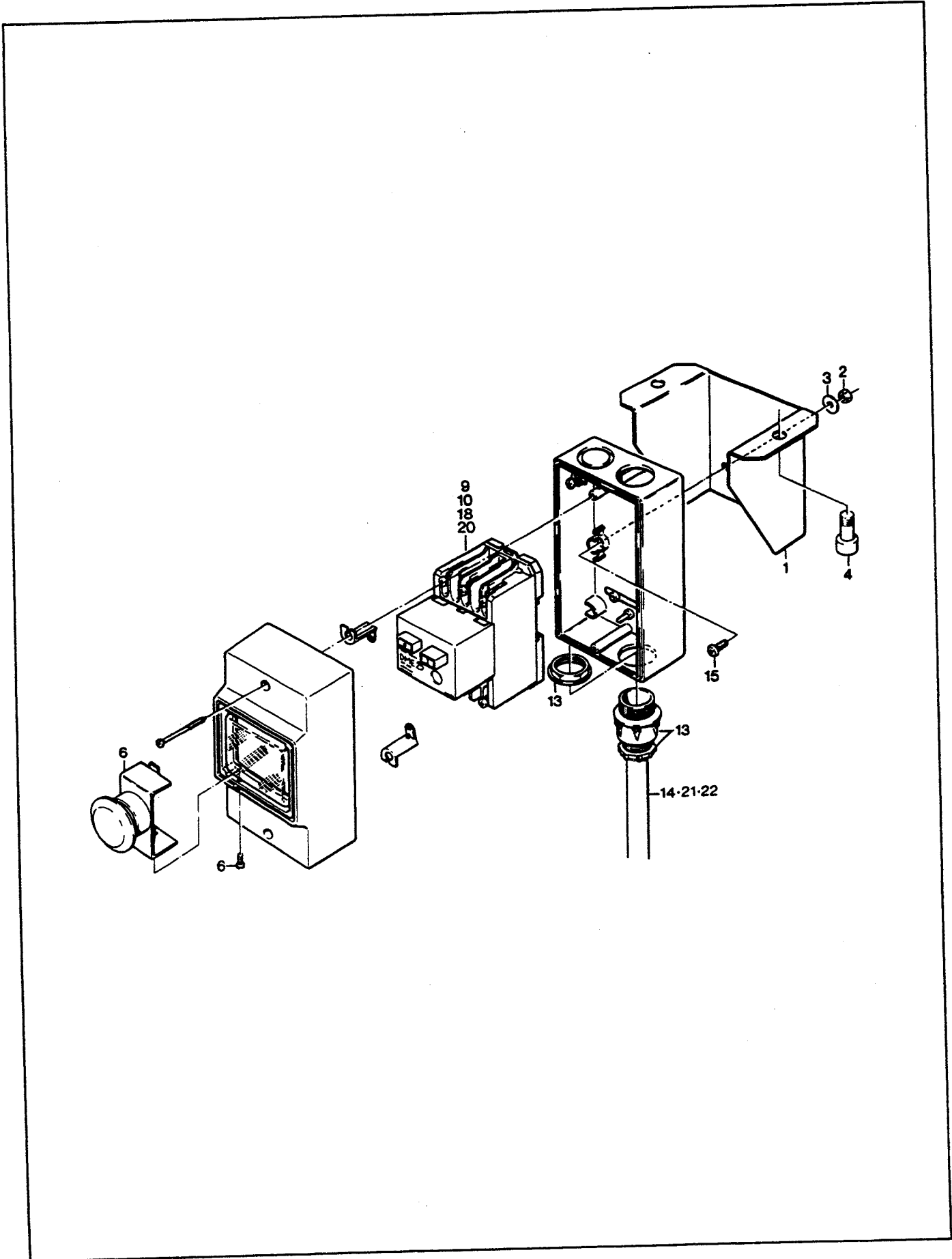
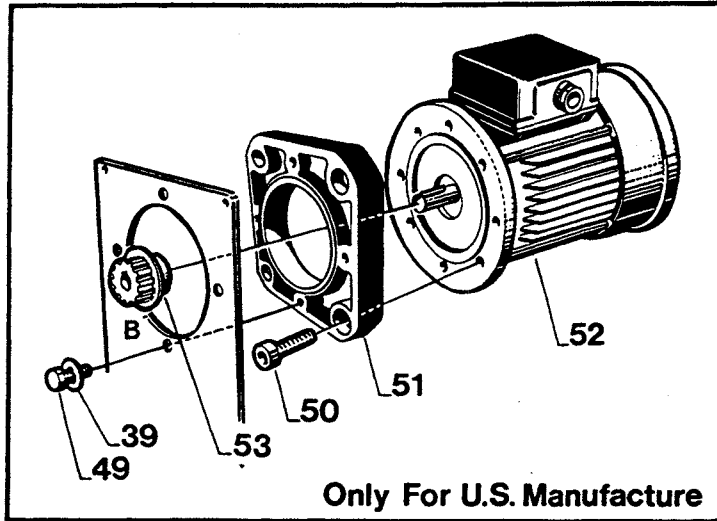


Figure 1317

Figure 1317

Ref. No.	3M Part No.	Description
1317-1	78-8052-6724-8	Switch - Bracket
1317-2	78-8010-7416-8	Nut - Hex M4 Metric
1317-3	78-8017-9018-5	Washer - Plain M4 Metric
1317-4	26-1003-7963-0	Screw - Soc Hd M8 x 16
1317-6	78-8052-6725-5	Emergency Stop
1317-9	78-8052-6728-9	Switch - On/Off 1,6 - 2,5 Amp
1317-10	78-8052-6729-7	Switch - On/Off 2,5 - 4 Amp
1317-13	78-8057-5807-1	Cord - Grip
1317-14	78-8028-7909-4	Power Cord - USA
1317-15	78-8017-9257-9	Screw - Phil Hd M4 x 10
1317-18	78-8060-7637-4	Plug Terminal - Wire /1,5
1317-20	78-8060-7881-8	Eyelet Terminal - /5 Yellow
1317-21	78-8060-8052-5	Cable - 4X1,5 SMT 3PH
1317-22	78-8060-8053-3	Cable - 3X1,5 SMT 1PH



23·24·25·61·62 - 3F
 26·27·28·63·64·65 - MF

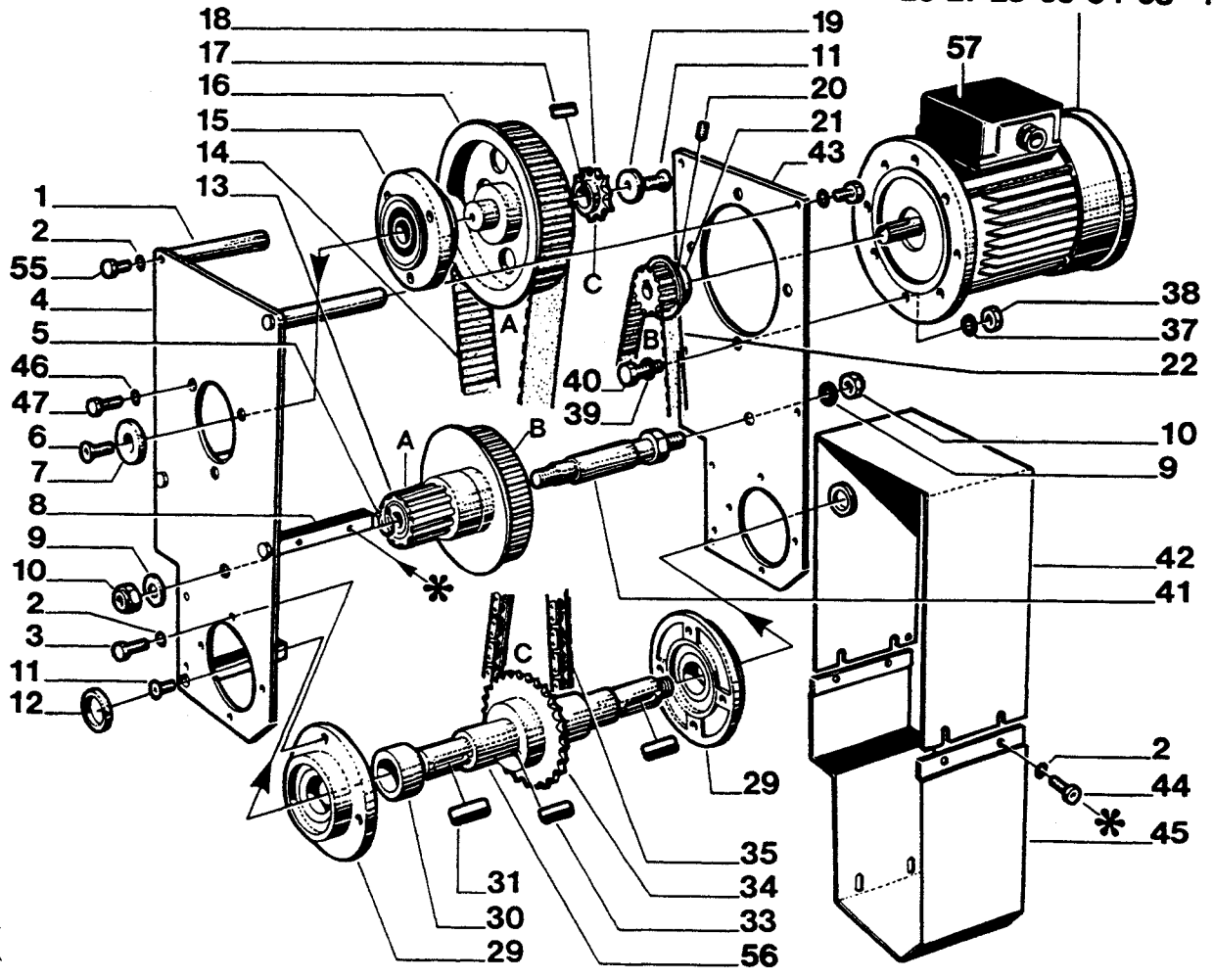


Figure 1600

Figure 1600

Ref. No.	3M Part No.	Description
1600-1	78-8054-8975-0	Spacer
1600-2	78-8005-5741-1	Washer - Plain M5 Metric
1600-3	26-1002-5820-6	Screw - Hex Hd M5 x 16
1600-4	78-8054-8976-8	Frame - Left Side
1600-5	78-8016-5855-6	E-Ring - 10 mm
1600-6	26-1001-9843-6	Screw - Flat Soc Hd M6 x 16
1600-7	78-8054-8577-4	Washer - Special
1600-8	78-8054-8977-6	Spacer
1600-9	78-8017-9318-9	Washer - Plain 8 mm Metric
1600-10	78-8017-9313-0	Nut - Self Locking M8
1600-11	26-0001-5862-1	Screw - Flat Hd Soc M5 x 12
1600-12	78-8054-8879-4	Washer - 20,5 mm
1600-13	78-8054-8978-4	Reducer - Pulley
1600-14	78-8057-5808-9	Belt - Timing 187L100
1600-15	78-8054-8979-2	Housing - Bearing
1600-16	78-8054-8980-0	Pulley Timing Belt
1600-17	78-8028-8244-5	Key - 4 x 4 x 10 mm
1600-18	78-8054-8981-8	Sprocket - 3/8 Pitch, 13 Teeth
1600-19	78-8054-8877-8	Washer - 5,5 x 20 x 4 mm
1600-20	26-1003-8816-9	Screw - Set M5 x 6
1600-21	78-8054-8982-6	Pulley - Timing 11 Teeth
1600-22	78-8057-5724-8	Timing Belt - 187L050 Boran
1600-23	78-8052-6718-0	Motor - 220/380V, 50 HZ, 3 PH - Europe
1600-24	78-8052-6719-8	Motor - 260/440V, 50 HZ, 3 PH - U.K.
1600-25	78-8052-6720-6	Motor - 240/415V, 50 HZ, 3 PH - Australia/N.Zealand
1600-26	78-8046-8268-6	Motor - 220V, 50 HZ, Single PH - Ireland/Hong Kong
1600-27	78-8046-8270-2	Motor - 240V, 50 HZ, Single PH - U.K.
1600-28	78-8046-8267-8	Motor - 110V, 60 HZ, Single Phase 3A - U.S.A.
1600-29	78-8054-8983-4	Housing - Bearing
1600-30	78-8054-8984-2	Bushing
1600-31	78-8057-5739-6	Key - 5 x 5 x 30 mm
1600-33	78-8057-5811-3	Key - 6 x 6 x 20 mm
1600-34	78-8054-8986-7	Sprocket - 3/8 Pitch, 28 Teeth
1600-35	78-8054-8987-5	Chain - 3/8 Pitch, 56 Pitch Long
1600-37	78-8005-5736-1	Lockwasher - For M8 Screw
1600-38	26-1000-1347-8	Nut - Hex M8 Metric
1600-39	26-1004-5507-5	Washer - M8
1600-40	78-8017-9301-5	Screw - Hex Head M8 x 25
1600-41	78-8054-8988-3	Shaft - Timing Pulley
1600-42	78-8054-8989-1	Covert - Top
1600-43	78-8054-8990-9	Frame - Right Side
1600-44	26-1003-7949-9	Screw - Soc Hd Hex M5 x 12
1600-45	78-8054-8991-7	Cover - Bottom
1600-46	78-8042-2919-9	Washer - M6
1600-47	78-8010-7193-3	Screw - Hex Hd M6 x 20 Metric
1600-49	26-1003-5842-8	Screw - Hex Hd M8 x 20
1600-50	12-7991-1573-3	Screw - Soc Hd 3/8 -16 x 1 1/4
1600-51	78-8054-8993-3	Adapter
1600-52	26-1005-8092-2	Motor - 115V, 60 HZ, US
1600-53	78-8055-0672-8	Pulley for US Motor
1600-55	26-1003-5820-4	Screw - Hex Hd M5 x 12
1600-56	78-8060-8047-5	Shaft - Drive
1600-57	78-8060-7880-0	Eyelet - Terminal /4 Red
1600-58	78-8060-8146-5	Gear Box Pulley Assembly
1600-59	78-8060-8147-3	Pulley Assembly
1600-60	78-8060-8148-1	Drive Shaft Assembly
1600-61	78-8059-5621-2	Motor - 20V, 60 HZ, 3 PH - Japan
1600-62	78-8060-8158-0	Motor - 220V, 60 HZ, 3 PH - Korea
1600-63	78-8059-5622-0	Motor - 100V, 50/60 HZ, 1 PH - Japan
1600-64	78-8060-8159-8	Motor - 115V, 60 HZ, Single Phase - U.S.A
1600-65	78-8060-8160-6	Motor - 230V, 50 HZ, Single Phase - Singapore

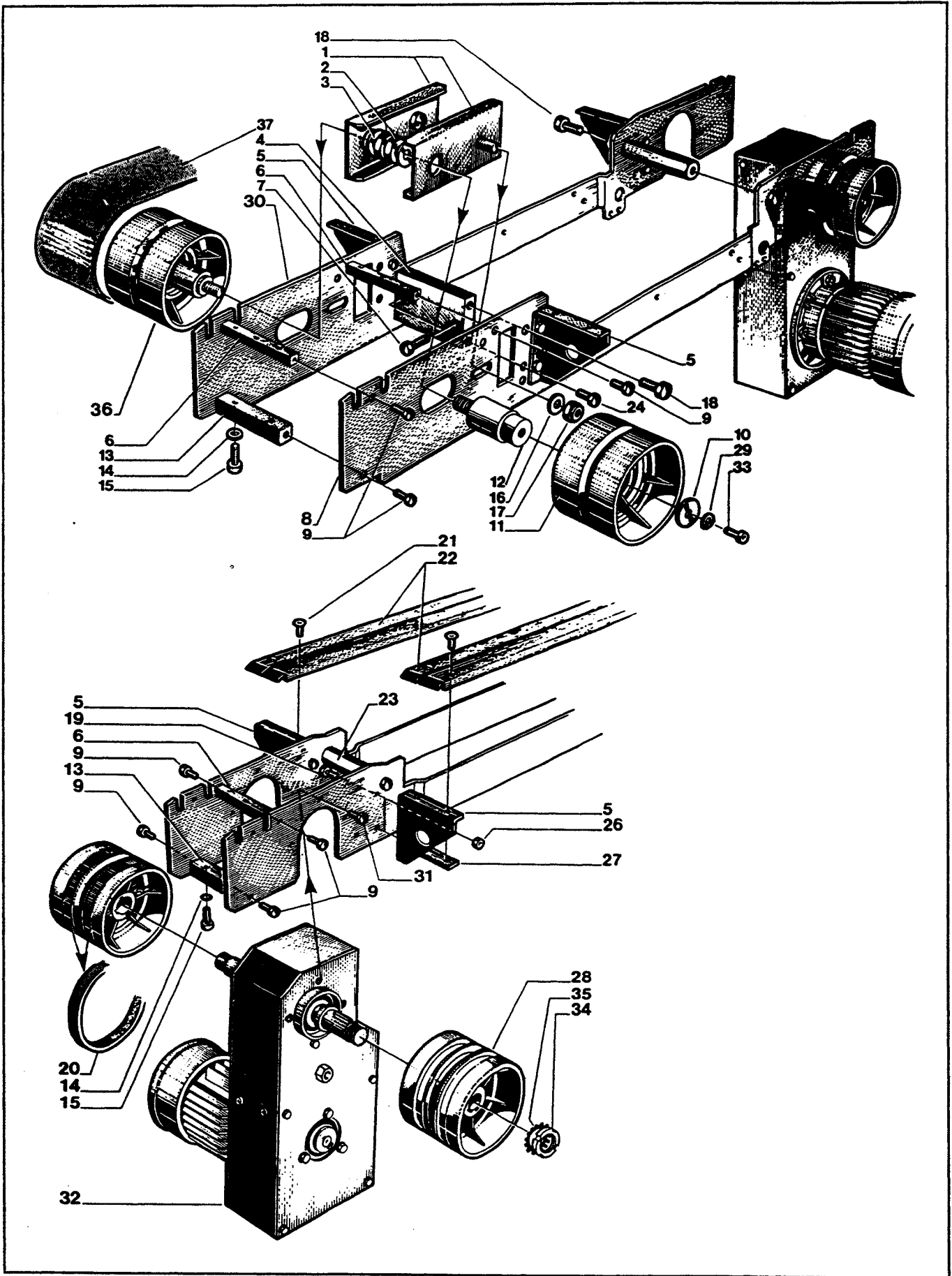


Figure 1627

Figure 1627

Ref. No.	3M Part No.	Description
1627-1	78-8052-6704-0	Roller - Bracket
1627-2	26-1003-6906-0	Nut - M-12 Metric
1627-3	26-1004-5511-7	Washer - Metric
1627-4	78-8052-6705-7	Block - Spacer
1627-5	78-8052-6706-5	Bracket
1627-6	78-8054-8764-8	Spacer - 10 x 10 x 90 mm
1627-7	26-1003-5845-1	Screw - Hex Hd M8 x 40
1627-8	78-8052-6708-1	Side Plate
1627-9	78-8010-7169-3	Screw - Hex Hd M6 x 12 Metric
1627-10	78-8052-6709-9	Washer - Special
1627-11	78-8052-6710-7	Roller - Idler
1627-12	78-8052-6711-5	Shaft - Roller
1627-13	78-8052-6712-3	Bar - Spacer
1627-14	26-1000-0010-3	Washer - Flat M6
1627-15	78-8010-7209-7	Screw - Soc Hd M6 x 12
1627-16	78-8052-6566-3	Washer - Friction
1627-17	26-1003-6918-5	Nut - Hex M10 Plastic Insert
1627-18	26-1003-5849-3	Screw - Hex Hd M10 x 16
1627-19	26-1003-5820-4	Screw - Hex Hd M5 x 12
1627-20	78-8052-6713-1	Ring - Polyurethane
1627-21	26-1005-5316-8	Screw, Flat Hd Hex M5 x 16
1627-22	78-8052-6714-9	Guide - Drive Belt
1627-23	78-8017-9144-9	Spacer - Hexagonal
1627-24	78-8032-0375-7	Screw - Hex Hd M6 x 16 Metric
1627-26	78-8010-7417-6	Nut - Hex M5 Metric
1627-27	78-8052-6715-6	Bracket
1627-28	78-8060-8072-3	Roller - Drive
1627-29	78-8010-7435-8	Washer - Lock M6 Metric
1627-30	78-8054-8649-1	Lower Main Plate Left
1627-31	26-1002-5820-6	Screw - Hex Hd M5 x 16
1627-32	78-8052-6716-4	Gear Box Assembly W/O Motor
1627-33	26-1003-7957-2	Screw - Soc Hd Hex M6 X 16
1627-34	78-8060-8149-9	Ring Nut - M20 X 1
1627-35	78-8060-8150-7	Washer
1627-36	78-8060-8151-5	Idler Roller Assembly
1627-37	78-8052-6722-2	Belt - Drive

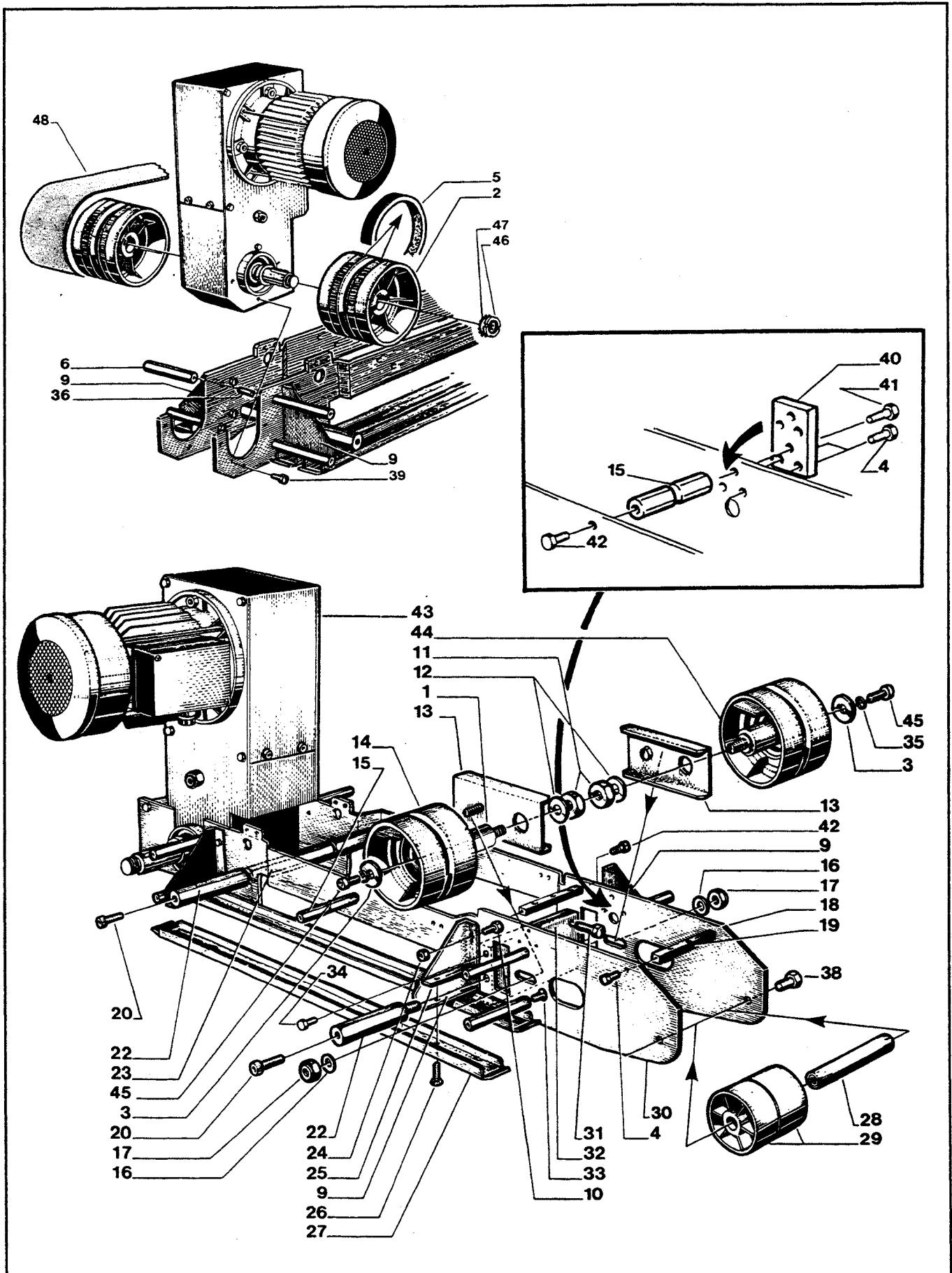


Figure 1628

Figure 1628

Ref. No.	3M Part No.	Description
1628-1	78-8052-6711-5	Shaft - Roller
1628-2	78-8060-8072-3	Roller - Drive
1628-3	78-8052-6709-9	Washer - Special
1628-4	78-8010-7169-3	Screw - Hex Hd M6 x 12 Metric
1628-5	78-8052-6713-1	Ring - Polyurethane
1628-6	78-8052-6559-8	Spacer - Upper
1628-9	78-8052-6706-5	Bracket
1628-10	26-1003-5820-4	Screw - Hex Hd M5 x 12
1628-11	26-1003-6906-0	Nut - M-12 Metric
1628-12	26-1004-5511-7	Washer - Metric
1628-13	78-8052-6704-0	Roller - Bracket
1628-14	78-8052-6710-7	Roller - Idler
1628-15	78-8052-6643-0	Spacer
1628-16	78-8052-6566-3	Washer - Friction
1628-17	26-1003-6918-5	Nut - Hex M10 Plastic Insert
1628-18	78-8052-6638-0	Side Plate - Right
1628-19	78-8054-8764-8	Spacer - 10 X 10 X 90 mm
1628-20	26-1003-7973-9	Screw - Soc Hd M10 x 16
1628-22	78-8054-8843-0	Spacer
1628-23	78-8017-9144-9	Spacer - Hexagonal
1628-24	78-8010-7417-6	Nut - Hex M5 Metric
1628-25	78-8052-6715-6	Bracket
1628-26	26-1005-5316-8	Screw - Flat Hd Hex M5 x 16
1628-27	78-8052-6714-9	Guide - Drive Belt
1628-28	78-8052-6640-6	Shaft - Roller
1628-29	78-8052-6641-4	Roller
1628-30	78-8052-6642-2	Side Plate - Left
1628-31	26-1003-5845-1	Screw - Hex Hd M8 x 40
1628-32	78-8052-6705-7	Block - Spacer
1628-33	26-1002-5830-5	Screw - Hex Hd M6 x 12
1628-34	78-8032-0375-7	Screw - Hex Hd M6 x 16 Metric
1628-35	78-8010-7435-8	Washer - Lock M6 Metric
1628-36	78-8060-8155-6	Screw - Set M6 x 35
1628-38	26-1003-5841-0	Screw - M8 x 16
1628-39	26-1002-5820-6	Screw - Hex Hd M5 x 16
1628-40	78-8052-6644-8	Bracket
1628-41	78-8010-7193-3	Screw - Hex Hd M6 x 20
1628-42	26-1003-5828-7	Screw - Hex Hd M6 x 12
1628-43	78-8052-6716-4	Gear Box Assembly - W/O Motor
1628-44	78-8060-8151-5	Idler Roller Assembly
1628-45	26-1003-7957-2	Screw - Soc Hd Hex M6 x 16
1628-46	78-8060-8149-9	Ring Nut - M20 X 1
1628-47	78-8060-8150-7	Washer
1628-48	78-8052-6722-2	Belt - Drive

3M Parts Order Form

Form 26989 - 3 - D

**Mail To: Dispenser Parts
241 Venture Drive
Amery, WI 54001**

**Fax or Call: 715-268-8126 (Wisc.)
800-344-9883 (Outside Wisc.)
FAX# 715-268-8153**

-- Shaded Areas To Be Filled In By 3M --

P.O. No.		Date		Catalog No.		Phone No. (including Area Code)		Customer Name	
Attr.		Model No.		Serial No.		Sales Rep. No.		Invoice No.	
Charge Back		Do Not Charge Back		Via		Account No.		Special Instructions	
Tax Exempt No.		Account No.		Serial No.		Phone No. (including Area Code)		Customer Name	
SIC		Account No.		Serial No.		Phone No. (including Area Code)		Customer Name	

Charge To

FAX Your Order For Faster Service FAX No. 715-268-8153

Qty.	Part Number	Description	Price
1.			
2.			
3.			
4.			
5.			
6.			
7.			
8.			
9.			

Please Print

Signature

Ship Via Air At Customer Expense

\$25.00 Minimum Order

